

precision.
power.
simplicity.

Power.

Machines and tools
for pipe and tube
preparation.



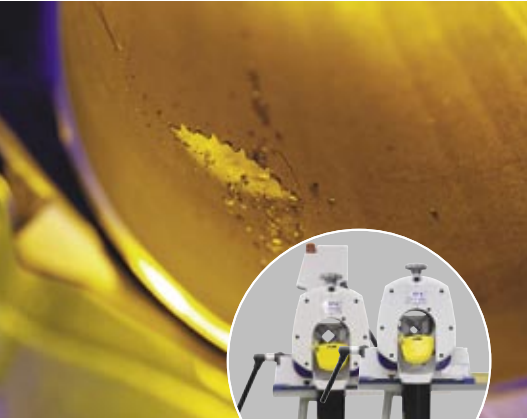
> 03/2008

Catalog
US



precision.
power.
simplicity.

New products



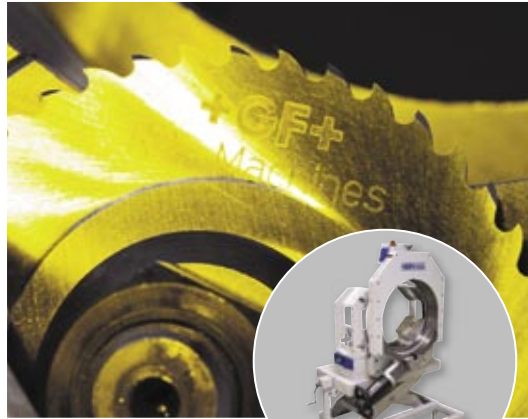
Pipe Cutting and Beveling Machines

GF 4 (AVM/MVM)

New era – even higher standards!
Having set the benchmark for pipe cutting and beveling machines for over 40 years, our new range of machines takes us even further forward. The new GF 4, GF 4 AVM and GF 4 MVM are now available!

- Optional feed module AVM or MVM for an automated or manual cutting process
- Weight reduction for ease of movement
- Ergonomically optimized motor handle giving a safer operating position; pipe elbows can be cut without modification
- Integrated line laser pointer to determine the cut-off point
- 2 position aluminum clamping jaws to reduce chatter and enable smaller length of pipe to be machined
- 1 multifunctional tool for all adjustments on the machine
- Extended speed range, ideal for the cutting of high-performance materials
- Swivel cable with a quick-disconnect coupler for easy and quick replacement of power cables
- The new saw blade guard protects against flying chips

...more on page 6



Pipe Cutting and Beveling Machines

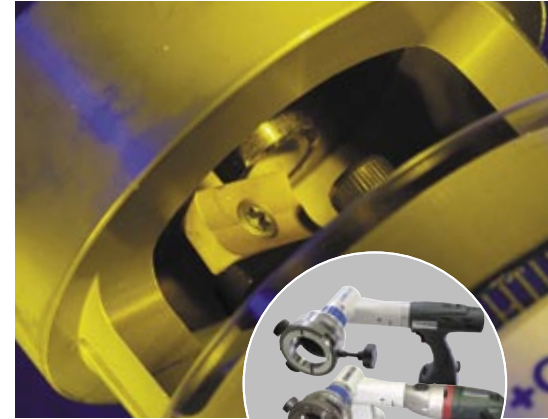
GF 20 AVM

The powerful solution for cutting pipes with OD 12 - 20 inch.
Cutting high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metals in just seconds, using the “planetary cutting” method. The intelligent AVM controls the feed and the cutting process automatically.

Advantages:

- Square, burr-free and cold machining process
- Optimum preparation for the automated welding process
- Sturdy design with powerful drive
- Unique and automated orbital cutting process
- Height-adjustable lifting bench included

...more on page 8



Tube Squaring Machines

RPG 2.5

RPG 2.5 Cordless

Burr-free squaring of thin-walled stainless steel tubes up to 2.5 inch. For cost-effective and precise preparation of pipe ends for orbital welding.

Advantages:

- High-quality results
- Beveling (30°/35°) possible with a special holder
- Burr-free and square
- High-performance coated tool bit with two cutting edges
- Quick clamping system for pipes, tools and clamping shells
- No additional tools required for operation
- Space-saving, easy to use, compact
- Built-in electronic speed regulation
- Micrometer feed for optimum results
- Feed unit can be rotated in cramped working conditions
- The special adapter clamping shell allows the RPG 2.5 to be used with the clamping shells for the RPG 1.5 machines also

...more on page 30



Page

Pipe Cutting and Beveling Technology 5

Pipe End Preparation Technology 27

Tungsten Grinding Technology 53

*Threading, Jointing and Sealing
Technology* 57

Copper Pipe Installation Technology 63

Accessories for Workshop and Site 67

Contents

3



Process Engineering

*Superclean media
Semiconductors
Electronics
Pharmaceuticals
Biotechnology*

Food and drink industry

Chemical industry

Aerospace industry

Shipbuilding



Power plant engineering

Power stations

Oil and gas

Petrochemicals



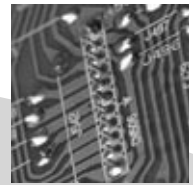
Building services

Water and gas

Heating

Air conditioning and refrigeration

Sprinkler installation





Page

**Pipe Cutting and
Beveling Machines**

GF 4 (AVM/MVM) 6 **NEW**

GF 20 AVM 8 **NEW**

RA 2, RA 6, RA 8, RA 12 (AVM/MVM) 10

RA 21 S 12

RA 41 Plus 13

Accessories 14

Saw blades and bevel cutters 18

Portable Tube Saws *PS 4.5, PS 6.6* 21 **NEW**

Accessories 22

Pipe Cutters *SCORP 220 Plus, SCORP 360* 23

Saw blades 24

Metal Tube Cutter *MRA* 25

Accessories 26

Pipe Cutting and Beveling Technology

5

GF Pipe Cutting and Beveling Machines

- Square, burr-free and cold machining process
- Deformation-free clamping system for tubes and pipes
- Optimum preparation for the automated welding process
- Sturdy design with powerful drive
- Unique and automated orbital cutting process

GF 4 (AVM/MVM)

New era – even higher standards!

Having set the benchmark for pipe cutting and beveling machines for over 40 years, our new range of machines takes us even further forward. The new GF 4, GF 4 AVM and GF 4 MVM are now available!

What's new:

- Weight reduction for ease of movement
- Optional feed module AVM or MVM for an automated or manual cutting process
- Integrated laser pointer to determine the cut off point
- Extended speed range (65 - 215 rpm), ideal for the cutting of high-performance materials (Hastelloy, P91, etc.)
- Swivel cable with a quick-disconnect coupler for easy and quick replacement of power cables
- A new ergonomically-designed motor handle for a safer and more comfortable operating position, which also enables easier cutting of elbows
- The new saw blade guard protects against flying chips and comes with a measuring port
- 1 multifunctional tool for all adjustments on the machine
- 2 position aluminum clamping jaws to reduce chatter and enable smaller length of pipe to be machined
- Locking mechanism prevents unauthorized usage and theft

Feed versions:

GF 4 AVM*

Pipe Cutting and Beveling Machines **with integrated crown wheel and automatic feed module AVM**. The intelligent AVM constantly monitors the feed force depending on the required performance, increasing the service life of the saw blades.

GF 4 MVM*

Pipe Cutting and Beveling Machines **with manual feed module MVM**. With the help of a hand wheel, the machine head rotates easily around the pipe with a constant speed.

Machine comes with:

- 1 Pipe Cutting and Beveling Machine GF 4 (AVM / MVM)*
- 1 Transportation case
- 1 Saw blade (Code 790 042 064)
- 1 Mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Set of operating instructions and spare parts list

* The automatic / manual feed module AVM/MVM is already fitted to the pipe cutter upon delivery.



GF 4



GF 4 AVM



GF 4 MVM

6

Pipe Cutting and Beveling Technology

All saws are fitted with the quick disconnect swivel cable.

Electric drive with single-phase AC motor:

Power: 1.8 kW (2.18 HP)

Protection class I (GF 4 AVM), Protection class II (GF 4 (MVM))

Built-in electronic variable cutting speed with restart inhibitor: 65 - 215 rpm

Application range	[mm]	[inch]
Pipe OD	12 - 120	0.472 - 4.724
Wall thickness (depends on material)	1 - 9	0.039 - 0.354
Pipe ID min. (saw blade Ø 63 mm/2.480 inch)	21	0.827
Pipe ID min. (saw blade Ø 68 mm/2.677 inch)	16	0.630
Pipe ID min. (saw blade Ø 80 mm/3.150 inch)	4	0.157

Article	Version	Code		lbs
GF 4	110 - 120 V, 50/60 Hz	790 142 002		145.504
GF 4 AVM	110 - 120 V, 50/60 Hz	790 142 012		167.550
GF 4 MVM	110 - 120 V, 50/60 Hz	790 142 022		156.527

Pipe Cutting and Beveling Technology

GF Pipe Cutting and Beveling Machine

- Square, burr-free and cold machining process
- Optimum preparation for the automated welding process
- Sturdy design with powerful drive
- Unique and automated orbital cutting process
- Height-adjustable lifting bench

GF 20 AVM

Pipe Cutting and Beveling Machine **with automatic feed module AVM***. The intelligent AVM controls the feed and the cutting process is automated. Cutting and beveling high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metals in just seconds, using the “Planetary Cutting” method.

Lifting bench

Supplied as standard. Can also be used in combination with the Pipe Cutting and Beveling Machine RA 12. Easy mounting of the saw directly on to the plate. On the RA 12, fastening with quick-mounting plate only. Mechanical height adjustment using a handwheel. Very sturdy and robust design with steel construction. Swarf collector included.

Machine comes with:

- 1 Pipe Cutting and Beveling Machine GF 20 AVM*
- 1 Transportation case
- 1 Lifting bench (Code 790 050 051)
- 1 Saw blade (Code 790 047 026)
- 1 Tool set
- 1 KSS-TOP lubricant spray pump (Code 790 060 226)
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Set of operating instructions and spare parts list

* The automatic feed module AVM is already fitted to the pipe cutter upon delivery.

The saw is fitted with the quick disconnect swivel cable.

Electric drive with single-phase AC motor:

Power: 1.8 kW (2.18 HP)

Protection class I

Built-in electronic variable cutting speed with restart inhibitor: 50 - 163 rpm

Application range / dimensions

Pipe ID min.	275 mm	10.8 inch
Pipe OD	283 - 508 mm	11.14 - 20 inch
Wall thickness max.	15 mm	0.59 inch
Dimensions of GF 20 incl. lifting bench (h x w x d) approx.	145 - 171 x 94 x 63 cm	57.1 - 67.3 x 37 x 24.8 inch
Dimensions of lifting bench (h x w x d) approx.	44.5 - 70.5 x 94 x 63 cm	17.5 - 27.8 x 37 x 24.8 inch
Load capacity of lifting bench max.	1,200 kg	2,645.5 lbs

Article	Version	Code	lbs
GF 20 AVM	110 - 120 V, 50/60 Hz	790 050 002	1,102.300



GF 20 AVM with lifting bench

Extension unit for GF 20 AVM

Available as an accessory. The extension unit accurately feeds long and heavy pipes into the pipe cutter. Very robust and sturdy design with 2 V supports and stainless steel bearings. Modular construction.

Application range	Extension unit
Pipe OD max.	508 mm / 20 inch
Dimensions approx.	110 x 50 x 95 cm / 43.3 x 19.7 x 37.4 inch
Load capacity max. [kg/lbs]	400/882

Article	Code	lbs
Extension unit	790 050 061	147.708



Continuous Cooling System for GF 20 AVM

To increase the service life of the saw blade and for improved surface finish to the pipe. The system is cooled with compressed air fed through a vortex tube. The cooling air rate can be configured to the optimum level for your application. Also suitable for cutting plastic pipes. Cooling without coolants. The saw blade is constantly cooled during the cutting process with cold air (to -37°C).

Article	Version	Code	lbs
Continuous cooling system	Compressed air (5.5 - 8.0 bar required)	790 050 773	1.323



Aluminum clamping shells for GF 20 AVM

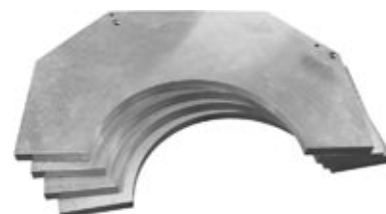
Ideal for clamping thin-walled pipes.

When ordering, please indicate the outside diameter of the tube to be worked on.

Comes with:

- 4 Clamping shells
- 8 Cylinder head screws
- 8 Cylinder head pins

Article	Code	lbs
Aluminum clamping shells for GF 20 AVM	790 050 708	8.157



RA Pipe Cutting and Beveling Machines

- Square, burr-free and cold machining process
- Deformation-free clamping system for tubes and pipes
- Optimum preparation for the automated welding process
- Sturdy design with powerful drive
- Unique and automated orbital cutting process

RA 2, RA 6, RA 8 and RA 12

Cutting high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metals in just seconds, using the “Planetary Cutting” method.

The above-mentioned RA machines are also available in the following versions:

RA H

Pipe Cutting and Beveling Machines **with an additional intermediate gearbox** for lower cutting speeds for pipes in high-performance materials e.g. Hastelloy, Inconel, Duplex, high-alloy steel (stainless steel) and titanium alloys.

RA INOX

Pipe Cutting and Beveling Machines **with special stainless steel clamping jaws or stainless steel attachments**. Supplied as standard with RA 6, RA 8 and RA 12.

Feed versions:

RA 6 AVM, RA 8 AVM and RA 12 AVM*

Pipe Cutting and Beveling Machines **with integrated crown wheel and automatic feed module AVM**. The intelligent AVM controls the feed and the cutting process is automated.

RA 6 MVM, RA 8 MVM and RA 12 MVM*

Pipe Cutting and Beveling Machines **with manual feed module MVM**. With the help of a hand wheel, the machine head rotates easily around the pipe with a constant speed.

Machine comes with:

- 1 Pipe Cutting and Beveling Machine RA (AVM/MVM)*
- 1 Transportation case
- 1 Saw blade
RA 2: 790 041 035, RA 6: 790 042 048, RA 8: 790 043 018, RA 12: 790 043 018
- 1 Mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Set of operating instructions and spare parts list

* The automatic and manual feed module AVM/MVM is already fitted to the pipe cutter upon delivery.

All RA's are fitted with the swivel cable.

Electric drive with single-phase AC motor:

Power: 1.6 kW (2.18 HP)

Protection class II (RA standard), Protection class I (RA AVM), Protection class II (RA MVM)



RA 2



RA 6 AVM



RA 8 MVM

Built-in electronic variable cutting speed with restart inhibitor:
 RA: 150 - 270 rpm; RA H: 40 - 70 rpm

Application range		RA 2	RA 6	RA 8	RA 12
Pipe OD	[mm]	12 - 63	44 - 182	114 - 230	154 - 325
	[inch]	0.472 - 2.480	1.732 - 7.165	4.488 - 9.055	6.063 - 12.795
Wall thickness (depends on material)*	[mm]	1.5 - 5.5	2 - 10	2 - 10	2 - 10
	[inch]	0.059 - 0.217	0.079 - 0.394	0.079 - 0.394	0.079 - 0.394
Pipe ID min.	[mm]	7	76	137	185
Saw blade Ø 63 mm/2.480 inch	[inch]	0.276	2.992	5.394	7.283
Pipe ID min.	[mm]	2	71	132	176
Saw blade Ø 68 mm/2.677 inch	[inch]	0.079	2.795	5.197	6.929
Pipe ID min.	[mm]	-	59	120	164
Saw blade Ø 80 mm/3.150 inch	[inch]	-	2.329	4.724	6.457
Pipe ID min.	[mm]	-	39	110	144
Saw blade Ø 100 mm/3.937 inch	[inch]	-	1.535	4.331	5.669

* when processing thin-walled tubes, special clamping shells may be needed, see page 14.

Article	Version	Code	lbs
RA 2	100 - 120 V, 50/60 Hz	790 041 096	99.207
RA 2 INOX	100 - 120 V, 50/60 Hz	790 041 090	103.620
RA 2 H	100 - 120 V, 50/60 Hz	790 041 099	108.025
RA 2 H INOX	100 - 120 V, 50/60 Hz	790 041 094	108.025
RA 6	100 - 120 V, 50/60 Hz	790 043 096	216.051
RA 6 H	100 - 120 V, 50/60 Hz	790 043 099	213.850
RA 6 AVM	100 - 120 V, 50/60 Hz	790 043 007	246.915
RA 6 H AVM	100 - 120 V, 50/60 Hz	790 043 008	246.915
RA 6 MVM	100 - 120 V, 50/60 Hz	790 043 082	222.665
RA 6 H MVM	100 - 120 V, 50/60 Hz	790 043 083	231.483
RA 8	100 - 120 V, 50/60 Hz	790 045 096	246.915
RA 8 H	100 - 120 V, 50/60 Hz	790 045 099	255.734
RA 8 AVM	100 - 120 V, 50/60 Hz	790 045 007	268.961
RA 8 H AVM	100 - 120 V, 50/60 Hz	790 045 008	295.420
RA 8 MVM	100 - 120 V, 50/60 Hz	790 045 082	253.529
RA 8 H MVM	100 - 120 V, 50/60 Hz	790 045 083	260.143
RA 12	100 - 120 V, 50/60 Hz	790 047 096	310.849
RA 12 H	100 - 120 V, 50/60 Hz	790 047 099	315.258
RA 12 AVM	100 - 120 V, 50/60 Hz	790 047 007	341.720
RA 12 H AVM	100 - 120 V, 50/60 Hz	790 047 008	348.330
RA 12 MVM	100 - 120 V, 50/60 Hz	790 047 082	302.030
RA 12 H MVM	100 - 120 V, 50/60 Hz	790 047 083	313.050



RA 12 H

Pipe Cutting and Beveling Technology

11

RA Pipe Cutting and Beveling Machines

- Square, burr-free and cold machining process
- Deformation-free clamping system, especially applicable for thin-walled tubes
- Ideal for simultaneous cutting and beveling
- Fast dimension adjustment
- Lightweight machine specially to use on site
- Sturdy design with powerful drive



RA 21 S

Cutting high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metals, as well as bar stock and thin-walled stainless steel pipes, in just seconds, using the “Planetary Cutting” method. Ideal for press fitting applications.

The above-mentioned RA machine is also available in the following version:

RA 21 S INOX

Pipe Cutting and Beveling Machines with special stainless steel clamping jaws.

Machine comes with:

- 1 Pipe Cutting and Beveling Machine RA 21 S
- 1 Durable storage and shipping case
- 1 Saw blade (Code 790 041 035)
- 1 Mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Set of operating instructions and spare parts list

Electric drive with single-phase AC motor:

Power: 550 W (0.75 HP)

Protection class II (double insulated)

Speed drive: 180 rpm

Application range	[mm]	[inch]
Pipe OD	5 - 63	0.197 - 2.481
Wall thickness (depends on material)	0.5 - 4.5	0.019 - 0.177
Pipe OD for bars (saw blade Ø 63 mm/2.480 inch)	5 - 16	0.236 - 0.630

Article	Version	Code	lbs
RA 21 S	100 - 120 V, 50/60 Hz	790 044 010	75.397
RA 21 S INOX	100 - 120 V, 50/60 Hz	790 044 094	75.397



Durable storage and shipping case

High quality padded blue shipping case. Particularly sturdy design.

Supplied as standard with the RA 21 S.

Article	Code	lbs
Durable storage and shipping case for RA 21 S	790 044 019	25.132

RA Pipe Cutting and Beveling Machines

- Square, burr-free and cold machining process
- Deformation-free clamping system, especially applicable for thin-walled tubes
- Ideal for simultaneous cutting and beveling with eccentric setting of the tool
- Fast dimension adjustment
- Sturdy design with powerful drive
- Optimum preparation for the automated welding process
- Clamping jaws made of aluminum

RA 41 Plus

Cutting and beveling pipes and elbows in high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metals in just seconds, using the “Planetary Cutting” method.

The above-mentioned RA machine is also available in the following version:

RA 41 Plus H

Pipe Cutting and Beveling Machines **with an additional intermediate gearbox** for lower cutting speeds for pipes in high-performance materials e.g. Hastelloy, Inconel, Duplex, high-alloy steel (stainless steel) and titanium alloys.

Machine comes with:

- 1 Pipe Cutting and Beveling Machine RA 41 Plus (H)
- 1 Transportation case
- 1 Saw blade (Code 790 042 064)
- 1 Set of aluminum clamping jaws (Code 790 046 250)
- 1 Mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Set of operating instructions and spare parts list

Electric drive with single-phase AC motor:

Power: 1.6 kW (2.18 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed with restart inhibitor: 150 - 270 rpm



Application range	[mm]	[inch]
Pipe OD (pipes)	10 - 120	0.394 - 4.724
Pipe OD (elbows)	30 - 120	1.181 - 4.724
Wall thickness (depends on material)	0.6 - 7	0.024 - 0.276
Pipe ID min. (saw blade Ø 63 mm/2.480 inch)	21	0.827
Pipe ID min. (saw blade Ø 68 mm/2.677 inch)	16	0.630
Pipe ID min. (saw blade Ø 80 mm/3.150 inch)	4	0.157

Article	Version	Code	lbs
RA 41 Plus	100 - 120 V, 50/60 Hz	790 046 012	169.754
RA 41 Plus H	100 - 120 V, 50/60 Hz	790 046 029	174.163

Pipe Cutting and Beveling Technology

Accessories for GF and RA machines



Aluminum clamping shells

For RA 6, RA 8 and RA 12. Customized aluminum clamping shells for deformation-free clamping of thin-walled tubes. When ordering, please indicate the outside diameter and/or inside diameter and the wall thickness of the tube to be worked on.

Comes with:

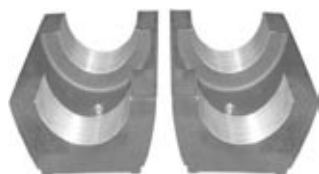
- 4 Cylinder head screws
- 1 Set of clamping shells

When ordering clamping shells for RA 8 you will also receive:

- 1 Drilling jig for the assembly of the clamping shells
- 2 Cylinder head screws for the drilling jig

Other dimensions are available.

Article	Pipe OD [mm]	Pipe OD [inch]	Code	lbs
for RA 6	76.1	3.000	790 043 216	9.921
for RA 8	129.0	5.079	790 045 216	9.480
for RA 8	167.0	6.575	790 045 218	8.818
for RA 8	210.0	8.268	790 045 217	6.393
for RA 12	209.0	8.230	790 047 221	25.353
for RA 12	219.0	8.620	790 047 220	24.692
for RA 12	254.0	10.000	790 047 216	20.282
for RA 12	273.0	10.750	790 047 219	18.519
for RA 12	324.0	12.760	790 047 218	13.448



Aluminum clamping shells for GF 4 and RA 41 Plus

For deformation-free clamping of thin-walled tubes.

Further clamping shells are available for various outer diameters.

Tube OD [mm]	Tube OD [inch]	Code	lbs
25.40	1.000	790 046 316	6.669
38.10	1.500	790 046 331	6.504
50.80	2.000	790 046 345	6.283
76.10	2.996	790 046 358	6.173
88.90	3.500	790 046 363	5.512
108.00	4.252	790 046 367	3.616
114.30	4.500	790 046 368	3.616



Special stainless steel clamping jaws for RA 2, RA 21 S, GF 4, RA 4

In pairs.

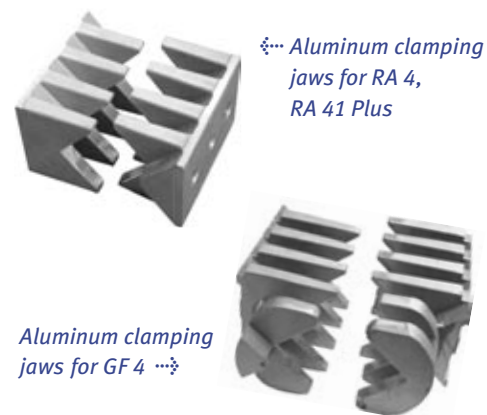
Article	Code	lbs
Special stainless steel clamping jaws for RA 2 and RA 21 S	790 041 323	2.282
Special stainless steel clamping jaws for GF 4 and RA 4	790 042 201	5.181

Aluminum clamping shells

For GF 4, RA 4 and RA 41 Plus.

Standard part of the GF 4 and the RA 41 Plus.

Article	Version	Code		lbs
Aluminum clamping jaws for RA 4, RA 41 Plus	right + left	790 046 250		5.732
Aluminum clamping jaws for GF 4	right	790 142 104		2.866
Aluminum clamping jaws for GF 4	left	790 142 106		3.186



Tempered cast steel clamping jaws

For GF 4.

Article	Version	Code		lbs
Tempered cast steel clamping jaws for GF 4	right	790 142 236		6.592
Tempered cast steel clamping jaws for GF 4	left	790 142 238		7.297



Saw blade lubricant GF TOP

Synthetic high-performance lubricant for cutting and beveling machines.

Increases the tool life of the saw blade. Compliant with the former food approval USDA H2.

The screwable brush guarantees an easy and uniform application of lubricant on the saw blade.

Article	Version	Code		lbs
Saw blade lubricant GF TOP	Tube, 180 g/0.45 lbs	790 060 228		0.452



Saw blade lubricant ROCOL

High-performance lubricant for cutting and beveling.

Increases the tool life of the saw blade.

Article	Version	Code		lbs
Saw blade lubricant ROCOL	Tube, 150 ml/5 fl oz	790 041 016		0.430
Saw blade lubricant ROCOL	Can, 0.5 kg/1.1 lbs	790 041 013		1.334
Saw blade lubricant ROCOL	Bucket, 5.0 kg/11 lbs	790 041 019		12.169



Special gear oil

For all GF and RA machines.

Article	Version	Code		lbs
Special gear oil	Bottle, 250 ml/8.9 fl oz	790 041 030		0.518



Pipe Cutting and Beveling Technology

15



Pipe length gauge bar

For all GF 4, RA 2, RA 4, RA 6 and RA 8 machines.
Measuring range up to 680 mm (26.77 inch). While stocks last.

Article	Code		lbs
Pipe length gauge bar	790 041 011		3.457



Length gauge

Combined metric and inch scale. Measuring range up to 250 mm (9.84 inch). While stocks last.

Article	Code		lbs
Length gauge for RA 21 S	790 044 020		1.797
Length gauge for RA 41	790 046 020		2.205



Intermediate gearbox retrofit kit

To convert a standard pipe cutting and beveling RA machine (RA) to RA H (with intermediate gear). The intermediate gearbox reduces the cutting speed of the RA machine to 40 - 70 rpm and increases torque. For cutting high-performance materials e.g. Hastelloy and Inconel. Fits all RA 2, RA 4, RA 41, RA 41 Plus, RA 6, RA 8 and RA 12 machines. The kit includes all parts necessary for retrofitting as well as additional gear oil.

Article	Code		lbs
Intermediate gearbox retrofit kit	790 041 063		4.409



Swivel cable
for RA and PS
machines

Swivel cable

To prevent twisting of the cable. For all GF, RA and PS machines, protection class II (double insulated).

Article	Version	Cable length [m]	Code		lbs
Swivel cable for RA/PS machines	200 - 240 V, 50/60 Hz EU	4	790 041 076		1.213
Swivel cable for RA/PS machines	100 - 120 V, 50/60 Hz US/CN	4	790 041 077		1.213
Swivel cable for RA/PS machines	100 - 120 V, 50/60 Hz CH	4	790 041 078		1.213
Swivel cable for GF machines	200 - 240 V, 50/60 Hz EU	4	790 142 076		1.235
Swivel cable for GF machines	100 - 120 V, 50/60 Hz US/CN	4	790 142 077		1.235
Swivel cable for GF machines	100 - 120 V, 50/60 Hz GB	4	790 142 079		1.235
Swivel cable for GF machines	200 - 240 V, 50/60 Hz AUS	4	790 142 080		1.235
Swivel cable for GF machines	200 - 240 V, 50/60 Hz CH	4	790 142 078		1.235



Swivel cable for
GF machines

Quick-mounting base plate

With integrated screw clamps for quick mounting of the machine on work benches.
Ideal for frequent changes of location.

Article	Code		lbs
Quick-mounting base plate for RA 2 (H), RA 21 S	790 041 027		9.325
Quick-mounting base plate for GF 4, RA 4 (H), RA 6 (H), RA 8 (H), RA 41 Plus (H)	790 042 027		13.591
Quick-mounting base plate for PS 4.5 and PS 6.6	790 c		5.732



RA carrier

For easy transportation of RA pipe cutters. For all RA 4, RA 41, RA 41 Plus and RA 6 machines. On request, the RA carrier can be pre-mounted on new purchases of one of the above RA machines. While stocks last.

Article	Code		lbs
RA carrier	790 042 035		11.023



Pipe feeder base unit and extension unit

The pipe feeder accurately feeds long and heavy pipes into GF and RA machines. Very sturdy and stable design with powder-coated frames and stainless steel rollers.

Base unit: Fits all pipe cutting and beveling machines in the GF and RA series from Orbitalum Tools (except the RA 2, RA 21 S and GF 20). The machines can be directly mounted onto the base plate of the pipe feeder base unit, without further parts. The machines can be easily adjusted to the required cutting dimension using the handwheel-operated mechanical height adjustment. The machine is securely fastened to the base plate.

Extension unit: To extend the the base unit, can be used singularly or in multiples, easily bolted together.

Floor bracket accessory: To fasten the base unit or the extension unit to the floor. The assembly consists of 4 brackets and 8 bolts with washers.



Pipe feeder base unit

Application range / technical details	Pipe feeder base unit	Pipe feeder extension unit
Pipe OD [mm]	16 - 325	16 - 325
Pipe OD [inch]	0.630 - 12.795	0.630 - 12.795
Dimensions [cm] approx.	185 x 105 x 50	160 x 105 x 50
Dimensions [inch] approx.	72.8 x 41.3 x 19.7	62.9 x 41.3 x 19.7
Load capacity max. [kg/lbs]	400/882	400/882

Article	Code		lbs
Pipe feeder base unit	790 068 051		255.734
Pipe feeder extension unit	790 068 061		158.731
Floor bracket accessory	790 068 053		4.189



Pipe feeder extension unit

Lifting bench

For GF 20 AVM (supplied as standard) and RA 12. Easy mounting of the saw directly on to the plate. On the RA 12, fastening with quick-mounting plate only. Mechanical height adjustment using a handwheel. Very sturdy and robust design with steel construction. Swarf collector included.

Technical data		
Dimensions of lifting bench (h x w x d) approx.	44.5 - 70.5 x 94 x 63 cm	17.5 - 27.8 x 37 x 24.8 inch
Load max.	1,200 kg	2,645.5 lbs

Article	Code		lbs
Lifting bench for GF 20 AVM and RA 12	790 050 051		374.782



Saw blades and bevel cutters for GF and RA machines

These saw blades and bevel cutters are especially designed for our pipe cutters for highest requirements and longest service life. 4 different ranges of saw blades are available:

- **Economy Range** for low and non-alloy steels and cast iron pipes
- **Performance Range** for high-alloy steels (stainless steel)
- **High Performance Range** for high-performance materials and high-alloy steels
- **Premium Range** especially made for stainless steel applications with extra long durability



Workable pipe materials	Al	Mild steel, Cu, CuNi, CuZn, CuSn	INOX, V2A, V4A, 304, 316 (L)	Ti, Duplex, Inconel
Economy	*	*		
Performance		*	*	
High Performance		*	*	*
Premium			*	

Saw blades

Minimum purchase: 5 blades

Article	Pipe wall thickness		Saw blade Ø		Code	lbs
	[mm]	[inch]	[mm]	[inch]		
Economy	1.2 - 2.5	.047 - .098	63	2.480	790 041 135	0.077
Economy*	1.5 - 6.0	.059 - .236	68	2.677	790 042 063	0.079
Economy*	5.0 - 12.0	.197 - .472	75	2.953	790 043 030	0.117
Economy	2.0 - 5.5	.079 - .217	63	2.480	790 041 020	0.071
Economy	2.5 - 7.0	.098 - .276	68	2.677	790 042 020	0.099
Performance	0.6 - 1.2	.024 - .047	63	2.480	790 041 036	0.060
Performance	1.0 - 1.6	.039 - .063	68	2.677	790 042 049	0.088
Performance	1.0 - 3.0	.039 - .118	63	2.480	790 048 072	0.055
Performance	1.2 - 2.5	.047 - .098	63	2.480	790 041 035	0.099
Performance	1.2 - 2.5	.047 - .098	68	2.677	790 042 064	0.110
Performance**	1.2 - 2.5	.047 - .098	100	3.937	790 043 036	0.229
Performance	1.2 - 3.0	.047 - .118	83	3.268	790 043 024	0.132
Performance	1.5 - 2.5	.059 - .098	80	3.150	790 046 022	0.187
Performance	2.5 - 5.5	.098 - .217	63	2.480	790 041 048	0.077
Performance**	2.5 - 5.5	.098 - .217	100	3.937	790 043 038	0.229
Performance	2.5 - 7.0	.098 - .276	68	2.677	790 042 048	0.099
Performance	2.5 - 7.0	.098 - .276	80	3.150	790 043 018	0.132
Performance	6.0 - 10.0	.236 - .394	75	2.953	790 043 022	0.121
Performance**	6.0 - 15.0	.236 - .591	100	3.937	790 047 026	0.231
High Performance	1.2 - 2.5	.047 - .098	80	3.150	790 046 021	0.141
High Performance	1.2 - 2.5	.047 - .098	63	2.480	790 041 034	0.068
High Performance	2.5 - 7.0	.098 - .267	68	2.677	790 042 058	0.099
Premium	1.2 - 2.5	.047 - .098	63	2.480	790 041 049	0.073

* applicable only for aluminum pipes

** only for RA 6, RA 8 and RA 12

Saw blade/bevel cutter combinations

Simultaneous cutting and beveling of pipes in just seconds.

Weld-prep saw blade/bevel cutter combination (V-seam)*

Article	Pipe wall thickness		Beveling angle	Height of bevel max.		Saw blade Ø		Code	lbs
	[mm]	[inch]		[°]	[mm]	[inch]	[mm]		
Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 157	0.227
Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 161	0.238
High Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 015	0.265
High Performance	2.5 - 6.0	.098 - .236	45	4	.157	68	2.677	790 042 023	0.298
High Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 013	0.238



Replacement parts for weld-prep saw blade/bevel cutter combination (V-seam)*

Article	Version	Code	lbs
Saw blade for 790 042 155, 790 042 157 and 790 042 161	Performance	790 042 153	0.088
Bevel cutter 30° for 790 042 161	Performance	790 042 160	0.132
Saw blade for 790 042 018, 790 042 015, 790 042 023, 790 042 013	High Performance	790 042 016	0.088
Bevel cutter 30° for 790 042 013	High Performance	790 042 021	0.170

Support disc for saw blade/bevel cutter combinations

We recommend the use of 1 support disc for the saw blade/bevel cutter combination.

Article	Code	lbs
Support disc	790 046 188	0.150

Press fitting saw blade/bevel cutter combinations**

Article	Pipe wall thickness		Beveling angle	Height of bevel max.		Saw blade Ø		Code	lbs
	[mm]	[inch]		[mm]	[inch]	[mm]	[inch]		
Performance	1.0 - 2.0	.039 - .079	45 / 70	0.4/1.0	.016/.039	63	2.480	790 044 046	0.198
High Performance	1.0 - 2.0	.039 - .079	45 / 70	0.4/1.0	.016/.039	63	2.480	790 044 047	0.198



Replacement parts for press fitting saw blade/bevel cutter combinations

Article	Version	Code	lbs
Saw blade for 790 044 046	Performance	790 044 040	0.060
Saw blade for 790 044 047	High Performance	790 044 041	0.066
Bevel cutter for 790 044 047	High Performance	790 044 043	0.143

* Consisting of one saw blade and one bevel cutter. It is possible to order the individual parts separately.

** Consisting of one saw blade and one bevel cutter. Especially for stainless steel press fitting systems. It is possible to order the individual parts separately.



Bevel cutters

For V-seam profiles on pipe ends.

The bevel cutter is mounted on the RA pipe cutter instead of a saw blade. Reproducible weld seam preparation in just seconds.

Bevel cutters V-seam

Article	Beveling angle	Height of bevel max.		Bevel cutter Ø		Code		lbs
	[°]	[mm]	[inch]	[mm]	[inch]			
Economy	30.0	9.5	.374	72	2.835	790 042 045		0.298
Economy	35.0	8.9	.350	70	2.756	790 042 037		0.375
Economy	37.5	8.4	.331	70	2.756	790 042 036		0.357
Economy	45.0	7.5	.295	70	2.756	790 042 038		0.357
Performance	30.0	9.5	.374	72	2.835	790 042 071		0.357
Performance	30.0	13.0	.512	76	2.992	790 043 023		0.412
Performance	37.5	8.4	.331	70	2.756	790 042 070		0.359
Performance	50.0	5.8	.228	70	2.756	790 042 050		0.370
High Performance	30.0	9.5	.374	72	2.835	790 042 073		0.346
High Performance	37.5	8.4	.331	70	2.756	790 042 072		0.359



Saw blade lubricant GF TOP

Synthetic high-performance lubricant for cutting and beveling machines.

Increases the tool life of the saw blade. Compliant with the former food approval USDA H2. The screwable brush guarantees an easy and uniform application of lubricant on the saw blade.

Article	Version	Code		lbs
Saw blade lubricant GF TOP	Tube, 180 g/0.45 lbs	790 060 228		0.452



Saw blade lubricant Rocol

High-performance lubricant for cutting and beveling.

Increases the tool life of the saw blade.

Article	Version	Code		lbs
Saw blade lubricant Rocol	Tube, 150 ml/5 fl oz	790 041 016		0.430
Saw blade lubricant Rocol	Can, 0.5 kg/1.1 lbs	790 041 013		1.334
Saw blade lubricant Rocol	Bucket, 5.0 kg/11 lbs	790 041 019		12.169

Portable Tube Saws

- Lightweight and easily transportable machine (only 50.7 lbs (PS 4.5) or 57.3 lbs (PS 6.6)), to provide flexibility for on-site applications
- Deformation-free clamping of thin-walled tubes
- For cutting of thin-walled tubes and elbows
- No rework necessary because of a burr-free and square cut
- Cold cutting process prevents corrosion
- Integrated line laser pointer to identify the cut-off point
- Orbital cutting process saves time
- Multi-point clamping of the pipe
- Fast adjustment of tube dimensions
- Long saw blade service life
- Press fitting saw blade combinations can be used*



PS 4.5

PS 6.6

PS 4.5, PS 6.6

Tube cutting made easy! Cutting thin-walled stainless-steel tubes and elbows using the superior “Planetary Cutting Technology”

Deformation-free clamping systems by integrated clamping jaws made from coated cast aluminum for different tube diameters.

Machine comes with:

- 1 Portable Tube Saw PS 4.5 or PS 6.6
- 1 Set of cast aluminum clamping jaws
- 1 Durable storage and shipping case
- 1 Saw blade, already mounted on the PS-machine (Code 790 048 072)
- 1 Tool bag equipped with tools
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Set of operating instructions and spare parts list

Electric drive (single-phase AC motor):

Power: 1010 W (1.5 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 30 - 160 rpm

Application range	Material	Saw position	Tube OD		Wall thickness	
			[mm]	[inch]	[mm]	[inch]
PS 4.5	Tube	1	6 - 120	0.236 - 4.724	< 3	< 0.118
	Elbow	2	30 - 120	1.181 - 4.724		
PS 6.6	Tube	1	50** - 170	1.969* - 6.693		
	Elbow	2	50** - 170	1.969* - 6.693		

* Only with combinations of Orbitalum Tools: Code 790 044 046 or 790 044 047. Especially for stainless steel press fitting systems. Consisting of one saw blade and one bevel cutter. It is possible to order the individual parts separately. Workable wall thickness: 1 - 2 mm (0.039 - 0.079 inch), beveling angle: 45°/70°, height of bevel: max. 0.4/1 mm (0.016/0.039 inch).

** It is possible to cut tubes with a outer diameter min. 30 mm (1.181 inch) with the PS 6.6 by using additional clamping jaws (accessory, Code 790 048 380). These clamping jaws are delivered as a standard with the PS 4.5.

Article	Version	Code	lbs
PS 4.5	100 - 120 V, 50/60 Hz	790 048 003	81.570
PS 6.6	100 - 120 V, 50/60 Hz	790 049 003	90.389

Pipe Cutting and Beveling Technology

21

Accessories for PS machines



Quick-mounting plate with screw clamps

Quick and easy mounting of the machine to the bench with no drilling.
Incl. 4 socket head screws to fix the PS to the quick-mounting base plate.

Article	Code	lbs
Quick-mounting plate with screw clamps	790 048 334	5.732



Saw blades

Performance Range for high-alloy steels (stainless steel).
Recommended saw blades for the Portable Tube Saws PS 4.5 and PS 6.6.

Article	Tube wall thickness [mm]	Tube wall thickness [inch]	Saw blade Ø [mm]	Saw blade Ø [inch]	Code	lbs
Performance	1.0 - 3.0	0.039 - 0.118	63	2.480	790 048 072	0.077
Performance	1.2 - 2.5	0.047 - 0.098	63	2.480	790 041 035	0.099
Performance	0.6 - 1.2	0.024 - 0.047	63	2.480	790 041 036	0.060



Tripod

Made of stainless steel.
For easy mounting of PS machines directly on the tripod with no base plate.
Space saving – fast application – easy handling

Article	Code	lbs
Tripod	790 048 335	23.369



Clamping jaws replacement set for PS 4.5 and PS 6.6

Made from coated cast aluminum. Extends the dimension range of the PS 6.6 to OD min. 1.181 inch.

Article	Code	lbs
Clamping jaws replacement set for PS 4.5 and extension jaws for PS 6.6	790 048 380	4.475



Laser retrofitting kit for PS 4.5 and PS 6.6

Line laser pointer to identify the cutting point on the pipe.
Easy mounting on the swivel on the PS machines. Kit contains 1 line laser, 1 laser holder with 2 fixing screws, replacement batteries, 1 set of assembly instructions.

Article	Code	lbs
Laser retrofitting kit for PS 4.5 and PS 6.6	790 048 060	0.331

Universal Pipe Cutter

- Wide range of applications and dimensions
- No rework necessary
- Suitable for clamping joints
- Reduction of tool costs and cutting time
- Flexible application range

SCORP 220 Plus, SCORP 360

The new way of cutting cast iron, stainless steel, steel, copper, aluminum and plastic pipes. Ideal for pipe fitters to use on construction sites and in industrial pipe installations.

Machine comes with:

- 1 Universal Pipe Cutter SCORP 220 Plus / SCORP 360
- 1 Bag for easy transportation
- 4 Small pipe rollers (SCORP 220 Plus) or 2 small and 1 large pipe roller (SCORP 360)
- 1 Saw blade TCT (Code 790 014 055)
- 1 Set of operating instructions and spare parts list

Electric drive with single-phase AC motor:

Power:

SCORP 220 Plus: 1.1 kW (1.5 HP)

SCORP 360: 1.4 kW (1.9 HP)

Max. saw blade speed range: 4,000 rpm

Application range	SCORP 220 Plus		SCORP 360	
	[mm]	[inch]	[mm]	[inch]
Pipe OD	20 - 220	0.800 - 8.660	75 - 360	2.950 - 14.170
Wall thickness (steel) max.	8	0.315	8	0.315
Wall thickness (plastic) max.	10	0.394	27.9	1.098

Article	Version	Code	lbs
SCORP 220 Plus	100 - 120 V, 50/60 Hz	790 014 008	20.944
SCORP 360	100 - 120 V, 50/60 Hz	790 015 002	31.526



SCORP 220 Plus



SCORP 360

Pipe Cutting and Beveling Technology

Saw blades for SCORP machines

Saw blade TCT



Article	For pipe materials	Saw blade Ø [mm]	rpm max.	Code	lbs
Saw blade TCT	Steel, copper, aluminum, all kinds of plastic	140	4,200	790 014 055	0.340
Saw blade TCT*	All kinds of plastic	155	4,200	790 014 058	0.430

* only for SCORP 360

Application range SCORP 360 with TCT saw blades

Plastic pipe OD		Saw blade Ø 140 mm/5.512 inch max. wall thickness		Saw blade Ø 155 mm/6.102 inch max. wall thickness	
[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
75	2.953	15.1	0.594	22.6	0.889
90	3.543	11.4	0.449	18.9	0.744
100	3.937	10.1	0.398	17.6	0.693
110	4.331	9.3	0.366	16.8	0.661
115	4.528	9.1	0.358	16.6	0.654
140	5.512	8.7	0.343	16.2	0.638
160	6.299	9.1	0.358	16.6	0.654
165	6.496	9.3	0.366	16.8	0.661
190	7.480	10.4	0.409	17.9	0.705
215	8.465	11.8	0.465	19.3	0.760
240	9.449	13.4	0.528	20.9	0.823
270	10.630	15.4	0.606	22.9	0.902
320	12.598	18.6	0.732	26.1	1.028
355	13.976	20.4	0.803	27.9	1.098

Cutting blade Diamond

Article	For pipe materials	Saw blade Ø [mm]	rpm max.	Code	lbs
Cutting blade Diamond	Cast iron	140	4,200	790 014 057	0.381

Saw blade Cermet

Article	For pipe materials	Saw blade Ø [mm]	rpm max.	Code	lbs
Saw blade Cermet	Stainless steel	140	4,200	790 014 056	0.337

Metal Tube Cutters

The clever solution for cutting metal tubes manually. This Metal Tube Cutter is especially designed for cramped working places and for chipless cutting processes.

- Deformation-free and square cut
- No electricity required
- Requires little space, for use in limited access areas

MRA

For manual cutting of metal tubes in any position.
Easy to use – first-rate cutting technology.

For pipe materials:

- High-alloy steel (stainless steel material no. 1.40... to 1.45...)
- Low alloy and unalloyed steel
- Cast materials
- Non-ferrous metals

Comes with:

- 1 Metal Tube Cutter MRA*
- 1 Plastic carrying case (ABS)
- 1 Socket head key
- 1 Connection clamp
- 1 Pair of working gloves
- 1 Set of operating instructions and spare parts list

* without multi-roller cutting chains and without clamping shells (see accessories)



Application range	[mm]	[inch]
Pipe OD	33.7 - 254.0	1.327 - 10.000
Wall thickness (depends on material)	0.8 - 3.0	0.031 - 0.118

Article	Version	Code	lbs
Metal Tube Cutters	Standard	790 008 001	17.637

Accessories for MRA

Multi-roller cutting chains

Cutting wheels made from hardened steel.



Article	Tube OD [mm]	Tube OD [inch]	Number of cutting wheels [pieces]	Code	lbs
Multi-roller cutting chain	33.7 - 114.3	1.330 - 4.500	15	790 008 018	1.102
Multi-roller cutting chain	114.3 - 254.0	4.500 - 10.000	16	790 008 041	1.984

Clamping shells for MRA

Set of two pieces, made from hardened steel. One pair of clamping shells needed for each tube size. Further dimensions of clamping shells are available.



Tube OD [mm]	Tube OD [inch]	Code	lbs
33.7	1.330	790 008 105	1.951
38.1	1.500	790 008 130	2.105
40.0	1.575	790 008 135	2.105
42.4	1.670	790 008 140	2.216
48.3	1.900	790 008 155	2.425
50.0	1.970	790 008 160	2.491
50.8	2.000	790 008 165	2.513
52.0	2.050	790 008 175	2.623
54.0	2.125	790 008 185	2.425
60.3	2.375	790 008 195	2.899
63.5	2.500	790 008 200	3.031
70.0	2.755	790 008 215	3.186
75.0	2.950	790 008 225	3.527
76.1	2.996	790 008 230	3.439
84.0	3.300	790 008 240	3.726
85.0	3.350	790 008 245	3.858
88.9	3.500	790 008 250	3.924
101.6	4.000	790 008 260	4.464
104.0	4.095	790 008 270	4.244
110.0	4.330	790 008 285	4.740
114.3	4.500	790 008 290	5.060
129.0	5.080	790 008 315	6.614
139.7	5.500	790 008 325	7.418
154.0	6.060	790 008 340	7.418
160.0	6.300	790 008 355	7.760
168.3	6.625	790 008 365	7.937
204.0	8.030	790 008 380	9.645
219.1	8.625	790 008 385	10.318

Tube Squaring Machines	<i>RPG 1.0 Cordless, RPG 1.0 Cordless right-angled drive</i>	28	
	<i>Accessories</i>	29	
	<i>RPG 1.5, RPG 1.5 Cordless RPG 2.5, RPG 2.5 Cordless</i>	30	NEW
	<i>Accessories</i>	31	
	<i>RPG 4.5, RPG 8.6</i>	33	
	<i>Accessories</i>	34	
Boiler Pipe Preparation Machines	<i>BRB 2</i>	36	
	<i>BRB 4</i>	38	
	<i>Accessories</i>	40	
Pipe End Preparation Machines	<i>REB 6, REB 14, REB 20</i>	43	
	<i>Accessories</i>	44	
	<i>Accessories for BRB and REB machines</i>	48	
Application ranges of tool holders and multifunctional tools	<i>Description of the different weld prep profiles and the tools made by Orbitalum Tools</i>	49	
	<i>Combination possibilities of tool holder and multifunctional tools for REB and BRB machines</i>	50	
	<i>Application range of tool holder</i>	51	
	<i>Length of land with the use of the tool holder for facing</i>	52	

Tube Squaring Machines

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Quick clamping system for tools, clamping shells and tubes
- Preparation of thin-walled stainless steel tubes (V4A) and micro fittings
- High-performance coated tool bit with two cutting edges
- Built-in electronic speed regulation
- Micrometer feed for optimum results
- No additional tools required for operation
- Space saving, light weight and portable machine for a mobile and secure application

RPG 1.0 Cordless, RPG 1.0 Cordless right-angled drive

Designed for burr-free squaring of thin-walled stainless steel tubes and micro fittings up to OD 25.4 mm (1 inch). The clean and cost-effective solution for precise welds conforming to industry standards.

Machine comes with:

- 1 Tube Squaring Machine RPG 1.0 Cordless / Cordless right-angled drive
- 1 Durable storage and shipping case
- 2 Rechargeable batteries
- 1 Battery charger
- 1 Multifunctional tool (Code 790 038 314)
- 1 Torx T-spanner for securing the multifunctional tools (T15)
- 1 Set of operating instructions and spare parts list
- Operating instructions and safety notes from the manufacturer of the motor

Drive with rechargeable battery

Voltage of rechargeable battery: 12 V

Speed RPG 1.0 Cordless: 0 - 400 rpm⁻¹

Speed RPG 1.0 Cordless right-angled drive: 0 - 350 rpm⁻¹

Application range	RPG 1.0 Cordless		RPG 1.0 Cordless right-angled drive	
	[mm]	[inch]	[mm]	[inch]
Tube OD	3.18 - 25.40	0.125 - 1.000	3.18 - 25.40	0.125 - 1.000
Wall thickness max.	2	0.079	2	0.079
Dimension of base unit approx.	235 x 380 x 75	9.25 x 15 x 3	145 x 380 x 75	5.7 x 15 x 3

Article	Version (battery charger)	Code	lbs
RPG 1.0 Cordless	115 V, 60 Hz	790 036 002	4.630
RPG 1.0 Cordless right-angled drive	115 V, 60 Hz	790 036 012	6.393



RPG 1.0 Cordless right-angled drive

RPG 1.0 Cordless

Accessories for RPG 1.0

Please check the outer diameter of the tubes before ordering the clamping shells. The different standards sometimes involve a special size (particularly for tubes in accordance with DIN 2430).

One-piece stainless steel clamping shells

Extremely durable. Assures accurate centering and quick clamping shell change without any tools with its unique design and positive clamping shell mechanism. Further dimensions of clamping shells are available.

For material	Tube OD [mm]	Tube OD [inch]	Code	lbs
Tubes	3.18	0.125	790 036 201	0.262
Tubes	6.35	0.250	790 036 202	0.260
Tubes	9.53	0.375	790 036 203	0.254
Tubes	10.00	0.394	790 036 204	0.254
Tubes	12.00	0.472	790 036 205	0.247
Tubes	12.70	0.500	790 036 206	0.245
Tubes	17.20	0.677	790 036 207	0.229
Tubes	19.05	0.750	790 036 208	0.220
Tubes	21.30	0.839	790 036 209	0.207
Tubes	25.40	1.000	790 036 210	0.183
Micro fittings	6.00	0.236	790 036 304	0.146
Micro fittings	6.35	0.250	790 036 301	0.146
Micro fittings	9.53	0.375	790 036 302	0.141
Micro fittings	10.00	0.394	790 036 305	0.143
Micro fittings	12.00	0.472	790 036 306	0.141
Micro fittings	12.70	0.500	790 036 303	0.137



Stainless steel clamping shell



Stainless steel clamping shell for micro fittings

Multifunctional tool MFW

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear. Usable for all machines of the RPG series.

Article	Quantity	Code	lbs
Multifunctional tool MFW-P-2	1	790 038 314	0.007
Multifunctional tool MFW-P-2	10	790 038 315	0.099



Durable storage and shipping case

High quality padded blue shipping case. Particularly sturdy design. Supplied as standard with the RPG 1.0 Cordless right-angled drive.

Article	Code	lbs
Durable storage and shipping case	790 036 080	11.905



Tube Squaring Machines



RPG 1.5



RPG 1.5 Cordless



RPG 2.5



RPG 2.5 Cordless

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Beveling (30°/35°) possible with a special holder
- Quick clamping system for tools, clamping shells and tubes
- Preparation of thin-walled stainless steel tubes (V4A) and micro fittings
- High-performance coated tool bit with two cutting edges
- Built-in electronic speed regulation
- Micrometer feed for optimum results
- No additional tools required for operation
- Space saving, light weight and portable machine for a mobile and secure application
- The special adaptor clamping shell allows the RPG 2.5 to be used with the clamping shells for the RPG 1.5 machines
- Space saving, light weight and portable machine for a mobile and secure application
- Machines have a removable bench stand (mains versions only)
- Right-angled machine with rotating/removable battery drive (cordless version)
- Very short design (cordless version)

RPG 1.5 (Cordless), RPG 2.5 (Cordless)

Designed for burr-free squaring of thin-walled stainless steel tubes and micro fittings up to OD 1.5 inch (RPG 1.5) or up to 2.5 inch (RPG 2.5). Clean and secure working area with a clear view of the cutting head.

Machine comes with:

- 1 Tube Squaring Machine RPG 1.5 (Cordless), RPG 2.5 (Cordless)
- 1 Durable storage and shipping case
- 2 Rechargeable batteries, 1 Battery charger (for Cordless versions only)
- 1 Tool holder (Code 790 037 152) with multifunctional tool (Code 790 038 314)
- 1 Adapter clamping shell (Code 790 030 106, only for RPG 2.5)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

Electric drive with single-phase AC motor:

Power: 1010 W

Protection class II (double insulated)

Built-in electronic variable cutting speed:

RPG 1.5: 145 - 235 rpm

RPG 2.5:

1. speed: 9 - 52 rpm; 2. speed: 27 - 153 rpm

Drive with rechargeable battery

Voltage of rechargeable battery: 12 V

Speed RPG 1.5 Cordless:

1. speed: 0 - 350 rpm; 2. speed: 0 - 1,300 rpm

Speed RPG 2.5 Cordless:

1. speed: 0 - 24 rpm; 2. speed: 0 - 80 rpm

Application range	RPG 1.5 (Cordless)		RPG 2.5 (Cordless)	
	[mm]	[inch]	[mm]	[inch]
Tube OD	3.0 - 38.1	0.118 - 1.500	6.35* - 63.5	0.250 - 2.500
Wall thickness max.	3.0	0.118	3.0	0.118

* only with special adapter clamping shell (supplied as standard with RPG 2.5)

Article	Version	Code	lbs
RPG 1.5	120 V, 50/60 Hz	790 037 002	20.944
RPG 1.5 Cordless (12 V)	120 V, 50/60 Hz	790 037 012	22.266
RPG 2.5	120 V, 50/60 Hz	790 030 002	22.046
RPG 2.5 Cordless (12 V)	115 V, 60 Hz	790 030 012	22.046

Accessories for RPG 1.5, RPG 2.5

Please check the outer diameter of the tubes before ordering the clamping shells. The different standards sometimes involve a special size (particularly for tubes in accordance with DIN 2430).

One-piece stainless steel clamping shells

Extremely durable. Assures accurate centering and quick clamping shell change without any tools with its unique design and positive clamping shell mechanism. Further dimensions of clamping shells are available.

Usable for*	For material	Tube OD [mm]	Tube OD [inch]	Code	lbs
RPG 1.5	Tubes	3.00	0.118	790 037 220	0.661
RPG 1.5	Tubes	3.18	0.125	790 037 221	0.679
RPG 1.5	Tubes	4.00	0.157	790 037 222	0.679
RPG 1.5	Tubes	4.78	0.188	790 037 223	0.679
RPG 1.5	Tubes	5.00	0.197	790 037 224	0.639
RPG 1.5	Tubes	6.00	0.236	790 037 225	0.683
RPG 1.5, RPG 2.5	Tubes	6.35	0.250	790 037 226	0.675
RPG 1.5, RPG 2.5	Tubes	8.00	0.314	790 037 227	0.659
RPG 1.5, RPG 2.5	Tubes	9.53	0.375	790 037 228	0.655
RPG 1.5, RPG 2.5	Tubes	10.00	0.394	790 037 229	0.657
RPG 1.5, RPG 2.5	Tubes	12.00	0.472	790 037 230	0.646
RPG 1.5, RPG 2.5	Tubes	12.70	0.500	790 037 231	0.644
RPG 1.5, RPG 2.5	Tubes	13.00	0.512	790 037 232	0.642
RPG 1.5, RPG 2.5	Tubes	13.50	0.531	790 037 233	0.639
RPG 1.5, RPG 2.5	Tubes	14.00	0.551	790 037 234	0.635
RPG 1.5, RPG 2.5	Tubes	15.00	0.591	790 037 235	0.631
RPG 1.5, RPG 2.5	Tubes	15.88	0.625	790 037 236	0.628
RPG 1.5, RPG 2.5	Tubes	16.00	0.630	790 037 237	0.622
RPG 1.5, RPG 2.5	Tubes	17.20	0.677	790 037 238	0.661
RPG 1.5, RPG 2.5	Tubes	18.00	0.709	790 037 239	0.617
RPG 1.5, RPG 2.5	Tubes	19.00	0.748	790 037 240	0.611
RPG 1.5, RPG 2.5	Tubes	19.05	0.750	790 037 241	0.604
RPG 1.5, RPG 2.5	Tubes	20.00	0.787	790 037 242	0.600
RPG 1.5, RPG 2.5	Tubes	21.30	0.839	790 037 243	0.595
RPG 1.5, RPG 2.5	Tubes	22.00	0.866	790 037 244	0.582
RPG 1.5, RPG 2.5	Tubes	23.00	0.906	790 037 245	0.575
RPG 1.5, RPG 2.5	Tubes	24.00	0.945	790 037 246	0.564
RPG 1.5, RPG 2.5	Tubes	25.00	0.984	790 037 247	0.556
RPG 1.5, RPG 2.5	Tubes	25.40	1.000	790 037 248	0.529
RPG 1.5, RPG 2.5	Tubes	26.90	1.059	790 037 249	0.573
RPG 1.5, RPG 2.5	Tubes	28.00	1.102	790 037 250	0.525
RPG 1.5, RPG 2.5	Tubes	29.00	1.142	790 037 251	0.518
RPG 1.5, RPG 2.5	Tubes	30.00	1.181	790 037 252	0.511
RPG 1.5, RPG 2.5	Tubes	31.80	1.250	790 037 280	0.507
RPG 1.5, RPG 2.5	Tubes	33.40	1.315	790 037 281	0.485
RPG 1.5, RPG 2.5	Tubes	33.70	1.327	790 037 282	0.481
RPG 1.5, RPG 2.5	Tubes	34.00	1.339	790 037 283	0.463
RPG 1.5, RPG 2.5	Tubes	35.00	1.377	790 037 284	0.463
RPG 1.5, RPG 2.5	Tubes	36.00	1.417	790 037 285	0.450
RPG 1.5, RPG 2.5	Tubes	38.00	1.496	790 037 286	0.439
RPG 1.5, RPG 2.5	Tubes	38.10	1.500	790 037 287	0.428
RPG 2.5	Tubes	42.70	1.681	790 030 224	1.065
RPG 2.5	Tubes	50.80	2.000	790 030 220	1.065
RPG 2.5	Tubes	52.00	2.047	790 030 225	1.065
RPG 2.5	Tubes	54.00	2.126	790 030 221	0.996
RPG 2.5	Tubes	60.30	2.374	790 030 222	0.851
RPG 2.5	Tubes	63.50	2.500	790 030 223	0.772
RPG 1.5	Micro fittings	3.00	0.118	790 037 300	0.531
RPG 1.5	Micro fittings	3.18	0.125	790 037 301	0.500



Stainless steel clamping shell



Stainless steel clamping shell for micro fittings

Usable for*	For material	Tube OD [mm]	Tube OD [inch]	Code	lbs
RPG 1.5	Micro fittings	4.00	0.157	790 037 302	0.522
RPG 1.5	Micro fittings	4.78	0.188	790 037 303	0.516
RPG 1.5	Micro fittings	5.00	0.197	790 037 304	0.503
RPG 1.5	Micro fittings	6.00	0.236	790 037 305	0.485
RPG 1.5, RPG 2.5	Micro fittings	6.35	0.250	790 037 306	1.014
RPG 1.5, RPG 2.5	Micro fittings	8.00	0.314	790 037 307	0.492
RPG 1.5, RPG 2.5	Micro fittings	9.53	0.375	790 037 308	0.661
RPG 1.5, RPG 2.5	Micro fittings	10.00	0.394	790 037 309	0.489
RPG 1.5, RPG 2.5	Micro fittings	12.00	0.472	790 037 310	0.485
RPG 1.5, RPG 2.5	Micro fittings	12.70	0.500	790 037 311	0.485
RPG 1.5, RPG 2.5	Micro fittings	17.20	0.678	790 037 312	0.485
RPG 1.5, RPG 2.5	Micro fittings	21.20	0.835	790 037 313	0.470

* Using a special adapter clamping shell (supplied as standard with the RPG 2.5), the clamping shells for the RPG 1.5 can also be used for the RPG 2.5 machines, extending the range of application to min. 6.35 mm (0.250 inch).

Adapter clamping shell for RPG 2.5

Using this adapter clamping shell, the clamping shells for the RPG 1.5 can also be used for the RPG 2.5 machines, extending the range of application to min. 0.250". Supplied as standard with the RPG 2.5.

Article	Code	lbs
Adapter clamping shell for RPG 2.5	790 030 106	0.331

Tool holder WH

Fits multifunctional tool 790 038 314. Adjustable tool holder incl. Torx fixing screw.
For max. wall thickness 3 mm / 0.118 inch.

Application range	Possible application		Bevel angle [°]	Tube OD RPG 1.5 (Cordless)		Tube OD RPG 2.5 (Cordless)	
	Squaring	Beveling		[mm]	[inch]	[mm]	[inch]
Standard tool holder WH12-I**	*	-	-	3.0 - 63.5	0.118 - 2.500	3.0 - 63.5	0.118 - 2.500
Optional tool holder WH12-I	*	-	-	12.7 - 63.5	0.500 - 2.500	12.7 - 63.5	0.500 - 2.500
Optional tool holder WH12-I micro fittings*	*	-	-	3.0 - 21.2	0.118 - 0.835	-	-
Tool holder WH3-V-30	-	*	30°	max. 35.0	1.378	max. 58.0	2.283
Tool holder WH3-V-35	-	*	35°	max. 35.0	1.378	max. 58.0	2.283

* Only for RPG 1.5 and only to be used with stainless steel clamping shells for micro fittings.

** Recommended application range with the RPG 1.5 and the standard tool holder: 0.118 - 0.5 inch.

Article	Code	lbs
Standard tool holder WH12-I	790 037 152	0.088
Optional tool holder WH12-I	790 037 154	0.110
Optional tool holder for micro fittings WH12-I*	790 037 156	0.220
Tool holder WH3-V-30	790 037 158	0.053
Tool holder WH3-V-35	790 037 159	0.053

Multifunctional tool MFW

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
Usable for all machines of the RPG series.

Article	Quantity	Code	lbs
Multifunctional tool MFW-P-2	1	790 038 314	0.007
Multifunctional tool MFW-P-2	10	790 038 315	0.099



Tube Squaring Machines

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Quick clamping system for tools, clamping shells and tubes
- Preparation of thin-walled stainless steel tubes (V4A)
- High-performance coated tool bit with two cutting edges
- Built-in electronic speed regulation
- Micrometer feed for optimum results
- No additional tools required for operation
- Space saving, light weight and portable machine for a mobile and secure application



RPG 4.5

RPG 4.5, RPG 8.6

Designed for burr-free squaring of thin-walled stainless steel tubes.

Clean and secure working area with a clear view of the cutting head.

Machine with rotating/removable bench stand.

Machine comes with:

- 1 Tube Squaring Machine RPG 4.5 or RPG 8.6
- 1 Durable storage and shipping case
- 1 Tool holder (Code 790 038 320) with multifunctional tool (Code 790 038 314)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

Electric drive with single-phase AC motor:

Power: 1010 W

Protection class II (double insulated)

Built-in electronic variable cutting speed:

RPG 4.5: 8 - 52 rpm; RPG 8.6: 7 - 18 rpm



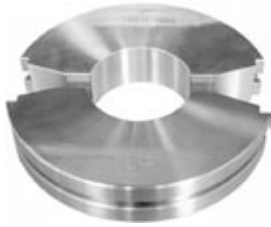
RPG 8.6

Application range	RPG 4.5		RPG 8.6	
	[mm]	[inch]	[mm]	[inch]
Tube OD	12.7 - 114.3	0.5 - 4.5	50.8 - 219.1	2 - 8.6
Wall thickness max.	3.0	0.118	3.6	0.142

Article	Version	Code	lbs
RPG 4.5	120 V, 50/60 Hz	790 038 002	42.769
RPG 8.6	120 V, 50/60 Hz	790 039 002	45.194

Accessories for RPG 4.5, RPG 8.6

Please check the outer diameter of the tubes before ordering the clamping shells. The different standards sometimes involve a special size (particularly for tubes in accordance with DIN 2430).



Stainless steel clamping shell for RPG 4.5



Aluminum clamping shell for RPG 8.6

Clamping shells

Extremely durable. The two-piece-design with click mechanism ensures accurate centering and quick clamping shell change without any tools. Further dimensions of clamping shells are available.

Usable for	Version	Tube OD [mm]	Tube OD [inch]	Code		lbs
RPG 4.5	Stainless steel	12.00	0.472	790 038 454		4.784
RPG 4.5	Stainless steel	12.70	0.500	790 038 438		4.799
RPG 4.5	Stainless steel	13.00	0.512	790 038 439		4.797
RPG 4.5	Stainless steel	13.50	0.531	790 038 440		4.795
RPG 4.5	Stainless steel	14.00	0.551	790 038 441		4.793
RPG 4.5	Stainless steel	16.00	0.630	790 038 442		4.780
RPG 4.5	Stainless steel	17.20	0.677	790 038 443		4.771
RPG 4.5	Stainless steel	18.00	0.709	790 038 444		4.764
RPG 4.5	Stainless steel	19.00	0.748	790 038 445		4.740
RPG 4.5	Stainless steel	19.05	0.750	790 038 446		4.755
RPG 4.5	Stainless steel	20.00	0.787	790 038 447		4.747
RPG 4.5	Stainless steel	21.30	0.839	790 038 448		4.630
RPG 4.5	Stainless steel	22.00	0.866	790 038 449		4.727
RPG 4.5	Stainless steel	23.00	0.906	790 038 450		4.718
RPG 4.5	Stainless steel	24.00	0.945	790 038 451		4.702
RPG 4.5	Stainless steel	25.00	0.984	790 038 452		4.689
RPG 4.5	Stainless steel	25.40	1.000	790 038 051		4.630
RPG 4.5	Stainless steel	26.90	1.059	790 038 400		4.608
RPG 4.5	Stainless steel	28.00	1.102	790 038 401		4.652
RPG 4.5	Stainless steel	29.00	1.142	790 038 402		4.641
RPG 4.5	Stainless steel	30.00	1.181	790 038 403		4.619
RPG 4.5	Stainless steel	31.75	1.250	790 038 052		4.608
RPG 4.5	Stainless steel	31.80	1.252	790 038 404		4.586
RPG 4.5	Stainless steel	33.40	1.315	790 038 405		4.497
RPG 4.5	Stainless steel	33.70	1.327	790 038 406		4.541
RPG 4.5	Stainless steel	34.00	1.339	790 038 407		4.497
RPG 4.5	Stainless steel	35.00	1.378	790 038 408		4.519
RPG 4.5	Stainless steel	36.00	1.417	790 038 409		4.506
RPG 4.5	Stainless steel	38.00	1.496	790 038 410		4.464
RPG 4.5	Stainless steel	38.10	1.500	790 038 053		4.453
RPG 4.5	Stainless steel	40.00	1.575	790 038 411		4.409
RPG 4.5	Stainless steel	41.00	1.614	790 038 412		4.387
RPG 4.5	Stainless steel	42.00	1.654	790 038 413		4.356
RPG 4.5	Stainless steel	42.16	1.660	790 038 414		4.299
RPG 4.5	Stainless steel	42.40	1.669	790 038 415		4.332
RPG 4.5	Stainless steel	42.70	1.681	790 038 416		4.299
RPG 4.5	Stainless steel	44.45	1.750	790 038 417		4.310
RPG 4.5	Stainless steel	44.50	1.752	790 038 418		4.310
RPG 4.5	Stainless steel	45.00	1.772	790 038 419		4.295
RPG 4.5	Stainless steel	48.26	1.900	790 038 420		4.145
RPG 4.5	Stainless steel	48.30	1.902	790 038 421		4.200
RPG 4.5	Stainless steel	48.60	1.913	790 038 422		4.134
RPG 4.5	Stainless steel	50.00	1.969	790 038 456		4.145
RPG 4.5	Stainless steel	50.80	2.000	790 038 054		4.178
RPG 4.5	Stainless steel	51.00	2.008	790 038 423		4.123
RPG 4.5	Stainless steel	52.00	2.047	790 038 424		4.079
RPG 4.5	Stainless steel	53.00	2.087	790 038 425		4.045
RPG 4.5	Stainless steel	54.00	2.126	790 038 426		4.028
RPG 4.5	Stainless steel	57.00	2.244	790 038 457		3.924

Usable for	Version	Tube OD [mm]	Tube OD [inch]	Code	lbs
RPG 4.5	Stainless steel	60.30	2.375	790 038 427	3.748
RPG 4.5	Stainless steel	60.45	2.380	790 038 428	3.805
RPG 4.5	Stainless steel	60.50	2.382	790 038 429	3.737
RPG 4.5	Stainless steel	63.00	2.480	790 038 461	3.721
RPG 4.5	Stainless steel	63.50	2.500	790 038 055	3.682
RPG 4.5	Stainless steel	70.00	2.756	790 038 430	3.406
RPG 4.5	Stainless steel	73.03	2.875	790 038 453	3.274
RPG 4.5	Stainless steel	73.15	2.880	790 038 431	3.267
RPG 4.5	Stainless steel	75.00	2.953	790 038 462	3.181
RPG 4.5	Stainless steel	76.10	2.996	790 038 432	3.131
RPG 4.5	Stainless steel	76.20	3.000	790 038 056	3.064
RPG 4.5	Stainless steel	76.30	3.004	790 038 433	3.064
RPG 4.5	Stainless steel	85.00	3.346	790 038 434	2.690
RPG 4.5	Stainless steel	85.90	3.382	790 038 435	2.646
RPG 4.5	Stainless steel	88.90	3.500	790 038 057	2.491
RPG 4.5	Stainless steel	89.10	3.508	790 038 436	2.425
RPG 4.5	Stainless steel	101.60	4.000	790 038 058	1.764
RPG 4.5	Stainless steel	104.00	4.094	790 038 437	1.631
RPG 4.5	Stainless steel	108.00	4.252	790 038 458	1.367
RPG 4.5	Stainless steel	114.30	4.500	790 038 059	0.959
RPG 8.6	Aluminum	50.8	2.000	790 039 260	8.377
RPG 8.6	Aluminum	76.2	3.000	790 039 261	9.259
RPG 8.6	Aluminum	101.6	4.000	790 039 252	8.377
RPG 8.6	Aluminum	114.3	4.500	790 039 256	7.716
RPG 8.6	Aluminum	127.05	5.002	790 039 262	7.540
RPG 8.6	Aluminum	139.7	5.500	790 039 259	6.834
RPG 8.6	Aluminum	141.3	5.563	790 039 257	6.393
RPG 8.6	Aluminum	152.4	6.000	790 039 253	5.952
RPG 8.6	Aluminum	168.3	6.625	790 039 254	5.071
RPG 8.6	Aluminum	197.0	7.756	790 039 263	3.373
RPG 8.6	Aluminum	203.2	8.000	790 039 258	7.716
RPG 8.6	Aluminum	219.1	8.625	790 039 255	1.323
RPG 8.6	Stainless steel	101.6	4.000	790 039 287	11.023
RPG 8.6	Stainless steel	114.3	4.500	790 039 280	10.362
RPG 8.6	Stainless steel	141.3	5.563	790 039 281	9.921
RPG 8.6	Stainless steel	152.4	6.000	790 039 283	9.700
RPG 8.6	Stainless steel	168.3	6.625	790 039 284	8.818
RPG 8.6	Stainless steel	203.2	8.000	790 039 286	7.143
RPG 8.6	Stainless steel	219.1	8.625	790 039 285	3.307

Tool holder WH

Fits multifunctional tool 790 038 314. Incl. Torx fixing screw.

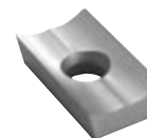
Article	Code	lbs
Tool holder WH	790 038 320	0.055



Multifunctional tool MFW

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear. Usable for all machines of the RPG series.

Article	Quantity	Code	lbs
Multifunctional tool MFW-P-2	1	790 038 314	0.007
Multifunctional tool MFW-P-2	10	790 038 315	0.099



Pipe End Preparation Technology

Boiler Pipe Preparation Machines

- Compact design for precise and reproducible weld prep profiles
- Maximum performance and lightweight
- High-performance coated tool bit with two cutting edges
- Quick clamping system for tools with easy adjustment
- Adjustable air outlet
- Ergonomic handling
- Easy to change tools
- Tools adaptable on all BRB machines
- Low noise level
- Application optimized housing design



BRB 2

Lightweight and robust Boiler Prep Machine. counterboring and axial turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®.

Designed for pipe end preparations and boiler pipe applications.
Up to 3 tools can be used at the same time.

Machine comes with:

- 1 Boiler Pipe Preparation Machine BRB 2
- 1 Durable storage and shipping case
- 1 Mandrel
- 3 Clamping sets (Kit 1) or 8 clamping sets (Kit 2)
- 1 Tool retainer
- 1 KSS-TOP lubricant spray pump (Code 790 060 226)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

Pneumatic power drive:

Power: 0.38 kW (0.52 HP)

Air supply requirement: 0.7 m³/min at 6 bar (35.3 cfm at 90 PSI)

Manufacturer's warranty can only be given when using the original mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 48).

Application range / Characteristics	BRB 2 Kit 1		BRB 2 Kit 2	
	[mm]	[inch]	[mm]	[inch]
Pipe ID	12.75 - 24	0.502 - 0.945	19.05 - 46	0.750 - 1.811
Wall thickness with steel	2 - 8	0.079 - 0.315	2 - 8	0.079 - 0.315
Wall thickness with stainless steel (max. OD 40 mm/1.57")	2 - 6	0.079 - 0.236	2 - 6	0.079 - 0.236
Mandrel Ø	12.75	0.502	19.05	0.750
Tool retainer Ø	50 / 19.05	1.97 / 0.75	50 / 19.05	1.97 / 0.75
Article	Version		Code	lbs
BRB 2, Kit 1	Pneumatic drive		790 085 019	16.975
BRB 2, Kit 2	Pneumatic drive		790 085 020	18.519

Retrofit kits for BRB 2

Retrofit kits are available for both basic machines.

Retrofit kit to basic machine 1 consists of:

- 7 Clamping sets
- 1 Mandrel complete with spindle

Retrofit kit to basic machine 2 consists of:

- 2 Clamping sets
- 1 Mandrel complete with spindle

Application range	Retrofit kit for BRB 2 Kit 1	Retrofit kit for BRB 2 Kit 2
Pipe ID [mm]	22.10 - 46.00	12.75 - 21.50
Pipe ID [inch]	0.870 - 1.811	0.502 - 0.846
Mandrel Ø [mm]	19.05	12.75
Mandrel Ø [inch]	0.75	0.5
Clamping sets [pieces]	7	2

Article	Code	lbs
Retrofit kit for BRB 2, basic machine 1	790 085 006	1.841
Retrofit kit for BRB 2, basic machine 2	790 085 005	0.818

Boiler Pipe Preparation Machines

- Compact design for precise and reproducible weld prep profiles
- Maximum performance and lightweight
- High-performance coated tool bit with two cutting edges
- Quick clamping system for tools with easy adjustment
- Adjustable air outlet
- Ergonomic handling
- Easy to change tools
- Tools adaptable on all BRB machines
- Low noise level
- Application optimized housing design

BRB 4

Lightweight and robust Boiler Prep Machine. counterboring and axial turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®. Designed for pipe end preparations and boiler pipe applications. Up to 3 tools can be used at the same time. Available in pneumatic and electric versions.

Machine comes with:

- 1 Boiler Pipe Preparation Machine BRB 4
- 1 Durable storage and shipping case
- 1 KSS-TOP lubricant spray pump (Code 790 060 226)
- 1 Tool set
- 1 Set of operating instructions and spare parts list



BRB 4
pneumatic

BRB 4 electric

Additional parts		BRB 4 Kit 1	BRB 4 Kit 2	BRB 4 Kit 3	BRB 4 Kit 4	BRB 4 Kit 5
Clamping sets	[pieces]	4	-	-	4	4
		-	3	3	3	3
Clamping range		19.1 - 33.8	-	-	19.1 - 33.8	19.1 - 33.8
	[mm]	-	32.0 - 61.7	32.0 - 61.7	32.0 - 61.7	32.0 - 61.7
		-	-	59.4 - 110.8	-	59.4 - 110.8
	[inch]	0.752 - 1.330	-	-	0.752 - 1.330	0.752 - 1.330
Clamping disc Ø with threaded spindle M8	[mm]	18.8	-	-	18.8	18.8
	[inch]	0.740	30.0	30.0	30.0	30.0
Mandrel Ø	[mm]	19.05	-	-	19.05	19.05
	[inch]	0.750	31.50	31.50	31.50	31.50
Tool retainer Ø	[mm]	68 / 19	-	-	68 / 19	68 / 19
	[inch]	2.677 / 0.748	-	-	2.677 / 0.748	2.677 / 0.748
		-	68 / 27	-	68 / 27	68 / 27
		-	-	120 / 27	-	120 / 27
		2.677 / 1.063	-	-	2.677 / 1.063	2.677 / 1.063
		-	4.724 / 1.063	-	4.724 / 1.063	4.724 / 1.063

Electric drive with single-phase AC motor:

Power: 1.2 kW (1.63 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 35 - 120 rpm

Pneumatic power drive:

Power: 1 kW (1.36 HP)

Air supply requirement: 1 m³/min at 6 bar (35.3 cfm at 90 PSI)

Speed: 0 - 110 rpm

Manufacturer's warranty can only be given when using the original mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 48).

Application range		BRB 4, Kit 1	BRB 4, Kit 2	BRB 4, Kit 3	BRB 4, Kit 4	BRB 4, Kit 5
Pipe ID	[mm]	19.1 - 33.8	32.0 - 61.7	32.0 - 110.8	19.1 - 61.7	19.1 - 110.8
	[inch]	0.752 - 1.330	1.260 - 2.429	1.260 - 4.370	0.752 - 2.429	0.752 - 4.362
Pipe OD	[mm]	64.0	73.0	114.3	73.0	114.3
	[inch]	2.51	2.87	4.50	2.87	4.50
Wall thickness min. - max.	[mm]	2.0 - 15.0	2.0 - 15.0	2.0 - 15.0	2.0 - 15.0	2.0 - 15.0
	[inch]	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590

Article	Version	Code	lbs
BRB 4, Kit 1	110 V, 50 Hz	790 086 016	33.069
BRB 4, Kit 2	110 V, 50 Hz	790 086 017	35.274
BRB 4, Kit 3	110 V, 50 Hz	790 086 018	37.478
BRB 4, Kit 4	110 V, 50 Hz	790 086 019	39.683
BRB 4, Kit 5	110 V, 50 Hz	790 086 020	41.887
BRB 4, Kit 1	Pneumatic drive	790 086 006	30.864
BRB 4, Kit 2	Pneumatic drive	790 086 007	33.069
BRB 4, Kit 3	Pneumatic drive	790 086 008	37.478
BRB 4, Kit 4	Pneumatic drive	790 086 009	36.596
BRB 4, Kit 5	Pneumatic drive	790 086 010	41.006

Retrofit kits for BRB 4

Retrofit kits comprising:

Comes with / For application range	Mandrel Ø		Tool support Ø		Extension of dimension to pipe ID		Extension of dimension to pipe OD max.	
	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
Kit 1 to Kit 4	-	-	68.0	2.677	19.1 - 61.7	0.752 - 2.429	70.0	2.756
Kit 1 to Kit 3	31.50	1.240	-	-	19.1 - 110.8	0.752 - 4.362	114.3	4.500
Kit 2 to Kit 1 / Kit 3 to Kit 1	19.05	0.750	68.0	2.677	19.1 - 61.7	0.752 - 2.429	70.0	2.756
Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	-	-	32.0 - 120.0	1.260 - 4.724	114.3	4.500
Kit 1 to Kit 5	-	-	68.0	2.677	19.1 - 120.0	0.752 - 4.724	114.3	4.500
Kit 3 to Kit 2	31.50	1.240	110.8	4.362	-	-	-	-
Kit 3 to Kit 2	-	-	68.0	2.677	32.0 - 110.8	1.260 - 4.362	114.3	4.500

Article	Code	lbs
Kit 1 to Kit 4	790 086 051	5.732
Kit 1 to Kit 3	790 086 052	8.157
Kit 2 to Kit 1 / Kit 3 to Kit 1	790 086 053	4.189
Kit 2 to Kit 3 / Kit 4 to Kit 5	790 086 054	4.189
Kit 1 to Kit 5	790 086 055	9.259
Kit 3 to Kit 2	790 086 056	1.543



Pipe End Preparation Technology

39

Accessories for BRB machines



Tool retainer Ø 3.543 inch

For Mandrel Ø 1.240 inch. While stocks last.

Article	Code	lbs
Tool retainer Ø 3.543 inch	790 086 207	2.425

Tool holder WH for I-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Version	Height [mm]	Height [inch]	Code	lbs
WH5-I	for BRB 2	10	0.394	790 085 230	0.011
WH4-I*	for BRB 2	10	0.394	790 085 234	0.073
WH12-I	for BRB 4	20	0.787	790 086 210	0.077
WH5-I	for BRB 4	20	0.787	790 092 202	0.220
WH5-I	for BRB 4	27	1.063	790 092 204	0.220

* Special tool holder for facing pipes in pipe plates



Adjustable tool holder WH for I-prep

Combination possibilities of tool holder and multifunctional tools, see page 50.

Comes with:

- Adjustable tool holder
- Multifunctional tool MFW 15-V / I-4, Code 790 093 037
- Torx screws
- Adjusting plates

Article	Version	Height [mm]	Height [inch]	Code	lbs
WH15-I	for BRB 4	16.5 - 23	0.650 - 0.906	790 093 410	0.545



Tool holder WH for V- and Y-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Version	Code	lbs
WH5-V-30°	for BRB 2	790 085 236	0.033
WH12-V-30°	for BRB 4	790 086 214	0.088
WH12-V-37.5°	for BRB 4	790 086 216	0.254
WH12-V-80°	for BRB 4	790 093 462	0.106
WH12-V-35°	for BRB 4	790 086 272	0.220
WH15-V-30°	for BRB 4	790 092 210	0.220
WH15-V-37.5°	for BRB 4	790 092 216	0.220
WH15-V-60°	for BRB 4	790 092 212	0.220



Tool holder WH for U-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Version	Code		lbs
WH5-U-20°	for BRB 2	790 085 228		0.031
WH12-U-10°	for BRB 4	790 086 208		0.097
WH12-U-20°	for BRB 4	790 086 224		0.104
WH12-U-25°	for BRB 4	790 086 212		0.112
WH30-U-7°	for BRB 4	790 093 408		0.454
WH30-U-10°	for BRB 4	790 093 220		0.384
WH30-U-20°	for BRB 4	790 093 218		0.406



Tool holder WH for counterboring

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

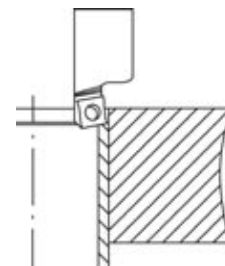
Article	Version	Code		lbs
WH5-ID-14°, 10 mm (0.394") deep	for BRB 2	790 085 232		0.037
WH5-ID-14°	for BRB 4	790 093 406		0.306
WH5-ID-45°	for BRB 4	790 086 218		0.353
WH10-ID-14°	for BRB 4	790 093 402		0.375
WH10-ID-14°, 30 mm (1.181") deep	for BRB 4	790 093 466		0.342
WH12-ID-10°	for BRB 4	790 086 274		0.093



Tool holder WH for cutting tubes from tube sheets

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

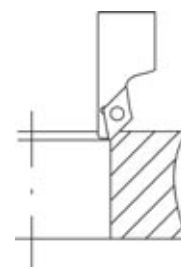
Article	Version	Code		lbs
WH10-ID-80°	for BRB 2 / BRB 4	790 086 275		0.165



Tool holder WH for cutting tubes from tube sheets

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Version	Code		lbs
WH5-ID-45°	for BRB 2 / BRB 4	790 086 218		0.342



Multifunctional tool MFW

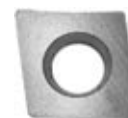
For pipe wall thicknesses up to 0.236 inch

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.

For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.

For WH5-I and WH5-U-20°

Article	Version	Code		lbs
MFW5-V / I-2	for BRB 2	790 085 030		0.342





Multifunctional tool MFW

For pipe wall thicknesses up to 0.157 inch

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
 For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.
 For WH4-I-2 (special holder)

Article	Version	Code		lbs
MF4-I-2	for BRB 2	790 085 031		0.004

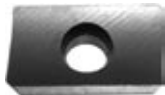


Multifunctional tool MFW

For pipe wall thicknesses from 0.079 to 0.59 inch

Four-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
 For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.
 V-, Y-, I-preps

Article	Version	Code		lbs
MF15-V / I-4	for BRB 4	790 093 037		0.121

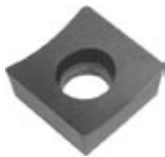


Multifunctional tool MFW

For pipe wall thicknesses from 0.079 to 0.472 inch

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
 For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.
 V-, Y-, I- and U-preps with a prep radius 1.2 mm (0.047 inch)

Article	Version	Code		lbs
MF12-V / I-2	for BRB 4	790 086 060		0.055



Multifunctional tool MFW

For counterboring ID

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
 For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.
 790 093 039 for WH5-ID-14° with a prep radius 0.4 mm (0.016 inch)
 790 086 061 for WH5-ID-45°
 790 086 062 for WH10-ID-80°

Article	Version	Code		lbs
MF5-ID-2-R0.4 (14°)	for BRB 4	790 093 039		0.007
MF5-ID-2-R0.4 (45°)	for BRB 4	790 086 061		0.004
MF10-ID-2-R0.4 (80°)	for BRB 4	790 086 062		0.004

Pipe End Preparation Machines

- Compact design for precise and reproducible weld prep profiles
- Quick-Tool-Change QTC®
- Square and burr-free
- High-performance coated tool bit with two or four cutting edges
- Sturdy construction
- Tools adaptable on all REB machines
- Optimized performance and ergonomic drive system
- Portable with an integral carrying handle

REB 6, REB 14, REB 20

The most powerful pipe end preparation solution. counterboring and axial turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®. Up to 4 tools can be used at the same time.

Machine comes with:

- 1 Pipe End Preparation Machine REB 6, REB 14 or REB 20
- 1 Transportation case
- 1 Clamping chuck (REB 6 und REB 14) or 2 clamping chucks (REB 20)
- 5 Clamping sets, each with 3 clamping wedges (REB 6) or 6 Clamping sets, each with 3 clamping wedges (REB 14 and REB 20)
- 1 Tool set
- 1 KSS-TOP lubricant spray pump (Code 790 060 226)
- 1 Set of operating instructions and spare parts list

Pneumatic power drive:

Power: 1.8 kW (2.45 HP); Air supply requirement: 2 m³/min at 6 bar (35.3 cfm at 90 PSI)
Nominal speed range: REB 6: 0 - 26 rpm, REB 14: 0 - 13 rpm, REB 20: 0 - 13 rpm

Manufacturer's warranty can only be given when using the original mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 48).

Electric drive with single-phase AC motor (only REB 6 and REB 14):

Power: 1.2 kW (1.63 HP)
Built-in electronic variable cutting speed: REB 6: 10 - 32 rpm, REB 14: 5 - 16 rpm



REB 6 electric



REB 14 pneumatic



REB 20 pneumatic

Application range*		Pipe ID		Wall thickness s		Pipe OD	
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
REB 6	min.	49	1.93	3	0.12	56	2.20
	max.	159	6.26	22	0.87	168	6.61
REB 14	min.	92	3.62	4	0.16	100	3.94
	max.	320	12.60	30	1.18	355.6	14.00
REB 20	min.	282	11.10	4	0.16	290	11.42
	max.	500	19.69	10	0.39	508	20

* It is possible to extend the dimensions by using the optional clamping wedges (accessories).

Article	Version	Code	lbs
REB 6	Pneumatic drive	790 093 003	70.547
REB 6	230 V, 50/60 Hz	790 093 004	77.161
REB 14	Pneumatic drive	790 094 003	134.481
REB 14	230 V, 50/60 Hz	790 094 004	141.094
REB 20	Pneumatic drive	790 094 011	154.322

Pipe End Preparation Technology

Accessories for REB machines



Tool holder WH for I-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Height [mm]	Height [inch]	Code	lbs
WH5-I	20	0.787	790 092 202	0.220
WH5-I	27	1.063	790 092 204	0.220
WH30-I	20	0.787	790 093 202	0.366
WH30-I	27	1.063	790 093 204	0.518



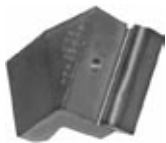
Adjustable tool holder WH for I-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Comes with:

- Adjustable tool holder
- Multifunctional tool MFW 15-V / I-4, Code 790 093 037
- Torx screws
- Adjusting plates

Article	Height [mm]	Height [inch]	Code	lbs
WH15-I	16.5 - 23	0.650 - 0.906	790 093 410	0.545



Tool holder WH for V- and Y-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Code	lbs
WH12-V-80°	790 093 462	0.106
WH15-V-30°	790 092 210	0.220
WH15-V-37.5°	790 092 216	0.220
WH15-V-60°	790 092 212	0.220
WH30-V-15°	790 093 468	0.441
WH30-V-30°	790 093 210	0.423
WH30-V-32.5°	790 093 424	0.516
WH30-V-37.5°	790 093 216	0.439
WH30-V-45°	790 093 404	0.450
WH30-V-25°	790 093 476	0.454

Tool holder WH for U-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Code		lbs
WH30-U-7°	790 093 408		0.454
WH30-U-10°	790 093 220		0.384
WH30-U-20°	790 093 218		0.406
WH30-U-14°	790 093 474		0.384
WH30-U-25°	790 093 478		0.364



Tool holder WH for counterboring

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 50.

Article	Code		lbs
WH5-ID-14°	790 093 406		0.306
WH5-ID-45°	790 086 218		0.342
WH10-ID-14°	790 093 402		0.353
WH10-ID-14°, 30 mm (1.181") deep	790 093 466		0.375
WH12-ID-10°	790 086 274		0.093



Multifunctional tool MFW

For pipe wall thicknesses from 0.087 to 1.18 inch

Four-sided tool bits with high-performance Balinit® Futura protective coating against tool wear.

For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.

790 093 033 for V-, Y-, I-preps

790 093 034 for I-, V-, Y-, U-prep with a prep radius 5 mm (0.197 inch)

790 093 035 for I-, V-, Y-, U-prep with a prep radius 2 mm (0.078 inch)

Article	Code		lbs
MFW30-V / I-4	790 093 033		0.121
MFW30-U-4-R5	790 093 034		0.121
MFW30-U-4-R2	790 093 035		0.132



Multifunctional tool MFW

For pipe wall thicknesses from 0.087 to 1.18 inch

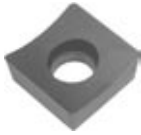
Four-sided tool bits with high-performance Balinit® Futura protective coating against tool wear.

For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.

V-, Y-, I-preps

Article	Code		lbs
MFW15-V / I-4	790 093 037		0.121





Multifunctional tool MFW

For counterboring ID

Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear.
For high-alloy steel (stainless steel) low-alloy steel, carbon steel and cast iron pipes.

Article	for WH	Code	lbs
MFW5-ID-2-R0.4 (14°)	WH5-ID-14° with a prep radius 0.4 mm (0.016 inch)	790 093 039	0.007
MFW5-ID-2-R0.4 (45°)	WH5-ID-45° with a prep radius 0.4 mm (0.016 inch)	790 086 061	0.004
MFW10-ID-2-R0.8 (14°)	WH10-ID-14° with a prep radius 0.8 mm (0.032 inch)	790 093 038	0.004
MFW10-ID-2-R3.0 (14°)	WH10-ID-14° with a prep radius 3.0 mm (0.032 inch)	790 093 041	0.009



Elbow clamping system

For REB 6. For preparing elbows with ID 2.95 - 6.18 inch.

Comes with:

- 1 Durable storage and shipping case
- 1 Mandrel with clamping mechanism for elbows
- 1 Straightening tool
- 8 Sets with 3 pins for dimension range 2.95 - 6.18 inch.

Article	Code	lbs
Elbow clamping system for REB 6 complete	790 093 015	21.826



Optional clamping wedges

To extend the dimension of the REB standard machines.

Article	Pipe ID [mm]	Pipe ID [inch]	Code	lbs
for REB 6	155 - 166	6.102 - 6.535	790 093 295	2.866
for REB 14	320 - 339	12.598 - 13.346	790 094 189	7.937
for REB 14	331 - 350	13.031 - 13.780	790 094 190	8.488

Plastic (POM) clamping shell segments

Customized plastic (POM) clamping shell segments for thin-walled pipes.
Deformation-free clamping system.

Comes with:

- 6 Cylinder head screws
- 3 Clamping shells
- 3 Plastic (POM) clamping shell segments

Other dimensions are available.



Article	Pipe ID [mm]	Pipe ID [inch]	Code		lbs
for REB 6	108.2 - 110.1	4.260 - 4.335	790 093 297		3.527
for REB 6	147.0 - 149.0	5.787 - 5.866	790 093 298		4.200
for REB 6	161.5 - 162.8	6.358 - 6.409	790 093 452		3.527
for REB 14	161.5 - 162.7	6.358 - 6.406	790 094 202		8.377
for REB 14	211.6 - 213.5	8.330 - 8.406	790 094 206		12.346
for REB 14	250.0	9.843	790 094 208		12.346
for REB 14	264.7 - 266.2	10.421 - 10.480	790 094 210		12.346
for REB 14	314.7 - 315.9	12.390 - 12.437	790 094 222		9.039
for REB 14	342.9	13.500	790 094 226		10.582
for REB 14	347.7	13.689	790 094 224		10.472

ID tracking for REB 14 and 20

The REB ID tracking can be used to prepare thin-walled, large-scale pipes for welding, where precise pipe-end preparation and an exact base width are required.

The module measures the pipe ID. The force of the spring rounds out imperfect sections of the pipe and so maintains an even base height for preparation. All weld preparations such as V-, Y- and U-preps can be realized with the ID tracking module.

Comes with:

- ID tracking module
- Mount for plane
- Assembly instructions



Application range	ID tracking for REB 14		ID tracking for REB 20	
	[mm]	[inch]	[mm]	[inch]
Pipe ID	150 - 320	5.910 - 12.600	290 - 500	11.417 - 19.685
Wall thickness max.	15	0.591	10	0.394

Article	Code	lbs
ID tracking for REB 14 and REB 20	790 094 013	12.676

Pipe End Preparation Technology

Accessories for BRB and REB machines

Mobile air unit DWE 10

Lubricator and air filter adjustable pressure range 0 - 10 bar. Flow max. 2.6 m³/min.
 Air inlet side: 1/2" clutch coupling (DIN 3481).
 Air outlet side: 1/2" quick coupling.
 Suitable for air hose 790 093 061.



Article	Code	lbs
Mobile air unit DWE 10	790 093 060	9.259

Air hose with quick coupling

To connect the REB or BRB machine with the mobile air unit DWE 10.
 Length: 4 m. ID: 0.752 inch.
 Air inlet side: 1/2" quick coupling.
 Air outlet side: 90° angle screw with 1/2" quick coupling and a nipple to screw into the speed regulation handle on REB or BRB.



Article	Code	lbs
Air hose with quick coupling	790 093 061	4.409

Cutting lubrication KSS-TOP

The water soluble, fully synthetic cooling fluid extends the tool life of the tool bits.
 Contains no hazardous substances (no labeling requirements according to GefStoffV.). Fulfils DVGW requirements, regarding drinking water, work sheet W 521.
 Good anti-corrosion properties.



Article	Version	Code	lbs
Cutting lubrication KSS-TOP	Pump sprayer with 500 ml/16.9 fl oz	790 060 226	1.389
Cutting lubrication KSS-TOP refill canister	Canister with 10 l/338 fl oz	790 060 227	24.251

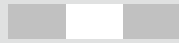
Converter 110 V - 120 V

For Pipe End Preparation Machines REB with electric drive.



Article	Code	lbs
Converter 110 V - 120 V	790 103 095	48.500

The different weld prep profiles



I

Facing
I-seam



V

Plain beveling
V-seam



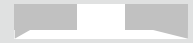
Y

Beveling, facing
Y-seam



U

J-prepping
U-seam



ID

Counterboring
ID-seam

Description of the tools made by Orbitalum Tools

Multifunctional tool MFW for working on the pipe OD:

MFW 30-V / I-4-R5

Prep radius in mm	R5
Number of cutting edges	4
Weld prep profiles	V and I
max. workable wall thickness in mm	30

Multifunctional tool MFW for working on the pipe ID:

MFW 10-ID-2-R0.8

Prep radius in mm	R0.8
Number of cutting edges	2
for working on the inner diameter	ID
max. length on the counterbore / bevel	10 mm

Tool holder WH for beveling:

WH 30-V-30°

Prep angle	30°
Weld prep profile	V
max. workable wall thickness in mm	30

Tool holder WH for facing:

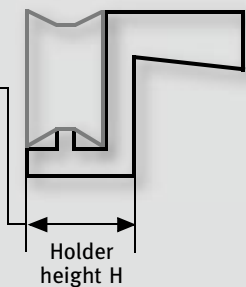
WH 30-I-H27

Holder height in mm	H27
Weld prep profile	I
max. workable wall thickness in mm	30

Tool holder WH for counterboring ID:

WH 10-ID-14°

Counterbore angle	14°
for working on the inner diameter	ID
max. length on the counterbore / bevel	10 mm



Combination possibilities of tool holder WH and multifunctional tools MFW for REB and BRB machines

Code-No.	Tool holder	Torx screw	Multifunctional tool
Tools for "I-seam"			
790 085 234	WH 4-I	790 085 244	790 085 031 with R 0
790 085 230	WH 5-I	790 093 224	790 085 030 with R 0.4
790 086 210	WH 12-I-H 20 mm	790 086 220	790 086 060 with R 1.2
790 092 202	WH 15-I-H 20 mm	790 093 226	790 093 037 with R 0
790 092 204	WH 15-I-H 27 mm	790 093 226	790 093 037 with R 0
790 093 202	WH 30-I-H 20 mm	790 093 226	790 093 033 with R 0
790 093 204	WH 30-I-H 27 mm	790 093 226	790 093 033 with R 0
790 093 410	WH 15-I-H-23 mm (adjustable)	790 093 226 / 790 093 425	790 093 037 with R 0
Tools for "V" and "Y-seam"			
790 085 236	WH 5-V-30°	790 093 224	790 085 030 with R 0.4
790 086 214	WH 12-V-30°	790 086 220	790 086 060 with R 1.2
790 086 272	WH 12-V-35°	790 086 220	790 086 060 with R 1.2
790 086 216	WH 12-V-37.5°	790 086 220	790 086 060 with R 1.2
790 093 462	WH 12-V-80°	790 086 220	790 086 060 with R 1.2
790 092 210	WH 15-V-30°	790 093 226	790 093 037 with R 0
790 092 216	WH 15-V-37.5°	790 093 226	790 093 037 with R 0
790 092 212	WH 15-V-60°	790 093 226	790 093 037 with R 0
790 093 468	WH 30-V-15°	790 093 226	790 093 033 with R 0
790 093 476	WH 30-V/U-25°	790 093 226	790 093 033 with R 0
790 093 210	WH 30-V-30°	790 093 226	790 093 033 with R 0
790 093 424	WH 30-V-32.5°	790 093 226	790 093 033 with R 0
790 093 216	WH 30-V-37.5°	790 093 226	790 093 033 with R 0
790 093 404	WH 30-V-45°	790 093 226	790 093 033 with R 0
790 093 470	WH 30-V-50°	790 093 226	790 093 033 with R 0
790 093 472	WH 30-V-55°	790 093 226	790 093 033 with R 0
Tools for "U-seam"			
790 085 228	WH 5-U-20°	790 093 224	790 085 030 with R 0.4
790 086 208	WH 12-U-10°	790 086 220	790 086 060 with R 1.2
790 086 224	WH 12-U-20°	790 086 220	790 086 060 with R 1.2
790 086 212	WH 12-U-25°	790 086 220	790 086 060 with R 1.2
790 093 408	WH 30-U-7°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 220	WH 30-U-10°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 474	WH 30-U-14°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 468	WH 30-V/U-15°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 218	WH 30-U-20°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 478	WH 30-U-25°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
Tools for "beveling / counterboring"			
790 085 232	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 093 406	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 086 218	WH 5-ID-45°	790 093 224	790 086 061 with R 0.4
790 093 402	WH 10-ID-14°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 466	WH 10-ID-14° / 30 mm deep	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 296	WH 10-ID-60°	790 093 224	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 275	WH 10-ID-80°	790 086 220	790 086 062 with R 0.4
790 086 274	WH 12-ID-10°	790 086 220	790 086 060 with R 1.2

Application range of tool holder for J-prep

		BRB 2 Mandrel Ø 12.7 WZT-Ø 51		BRB 2 Mandrel Ø 19 WZT-Ø 51		BRB 4 Mandrel Ø 19 WZT-Ø 68		BRB 4 Mandrel Ø 32 WZT-Ø 68		BRB 4 Mandrel Ø 32 WZT-Ø 90		BRB 4 Mandrel Ø 32 WZT-Ø 120		REB 6 Mandrel Ø 40 WZT-Ø 183		REB 14 Mandrel Ø 63 WZT-Ø 375	
		Max. ID with a height of land 1 mm (0.039 in)															
Code-No.	Description	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]
790 085 228	WH 5-U-20°	34 1.339	15 0.591	38 1.496	21 0.827	-	-	-	-	-	-	104 4.094	34 1.339	159 6.260	49 1.929	320 12.598	65 2.559
790 093 220	WH 30-U-10°	-	-	-	-	-	-	-	-	-	-	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	65 2.559
790 093 474	WH 30-U-14°	-	-	-	-	-	-	-	-	-	-	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	65 2.559
790 093 468	WH 30-V/U-15°	-	-	-	-	-	-	-	-	-	-	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	65 2.559
790 093 218	WH 30-U-20°	-	-	-	-	-	-	-	-	-	-	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	65 2.559
790 093 478	WH 30-U-25°	-	-	-	-	-	-	-	-	-	-	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	65 2.559
790 093 408	WH 30-U-7°	-	-	-	-	32 1.260	21 0.827	-	-	54 2.126	34 1.339	84 3.307	34 1.339	147 5.787	49 1.929	320 12.598	65 2.559
790 086 208	WH 12-U-10°	-	-	-	-	32 1.260	21 0.827	-	-	54 2.126	34 1.339	84 3.307	34 1.339	147 5.787	49 1.929	320 12.598	65 2.559
790 086 224	WH 12-U-20°	-	-	-	-	32 1.260	21 0.827	-	-	54 2.126	34 1.339	84 3.307	34 1.339	147 5.787	49 1.929	320 12.598	65 2.559
790 086 212	WH 12-U-25°	-	-	-	-	32 1.260	21 0.827	-	-	54 2.126	34 1.339	84 3.307	34 1.339	147 5.787	49 1.929	320 12.598	65 2.559
Application range of tool bits for J-prep																	
790 086 462	15-U-25°-R2	-	-	-	-	32 1.260	21 0.827	-	-	54 2.126	34 1.339	84 3.307	34 1.339	147 5.787	49 1.929	320 12.598	65 2.559
790 086 464	20-U-20°-R2	-	-	-	-	-	-	-	-	-	-	78 3.071	54 2.126	141 5.551	62 2.441	320 12.598	85 3.346
790 086 466	20-U-25°-R2	-	-	-	-	-	-	-	-	-	-	78 3.071	54 2.126	141 5.551	62 2.441	320 12.598	85 3.346

Application range of tool holders for counterboring

Counterboring		BRB 2 Mandrel Ø 12.7 WZT-Ø 51		BRB 2 Mandrel Ø 19 WZT-Ø 51		BRB 4 Mandrel Ø 19 WZT-Ø 68		BRB 4 Mandrel Ø 32 WZT-Ø 68		BRB 4 Mandrel Ø 32 WZT-Ø 90		BRB 4 Mandrel Ø 32 WZT-Ø 120		REB 6 Mandrel Ø 40 WZT-Ø 183		REB 14 Mandrel Ø 63 WZT-Ø 375	
		Workable pipe inner diameter (0.5 mm / 0.020 inch safe distance to mandrel)															
Code-No.	Description	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]	ID max. [mm] [inch]	ID min. [mm] [inch]
790 085 232	WH 5-ID-14°/ 10 mm deep	38 1.496	27 1.063	38 1.496	36 1.417	55 2.165	36 1.417	55 2.165	42 1.654	77 3.031	42 1.654	107 4.213	42 1.654	159 6.260	53 2.087	320 12.598	92 3.622
790 086 274	WH 10-U-10°	53 2.087	38 1.496	53 2.087	44 1.732	70 2.756	43 1.693	70 2.756	56 2.205	92 3.622	56 2.205	122 4.803	56 2.205	159 6.260	66 2.598	320 12.598	92 3.622
790 093 402	WH 10-U-14°	*	*	*	*	*	*	*	*	72 2.835	63 2.480	105 4.134	61 2.402	159 6.260	78 3.071	320 12.598	101 3.976
790 093 406	WH 5-ID-14°	*	*	*	*	*	*	*	*	60 2.362	39 1.535	96 3.780	43 1.693	159 6.260	60 2.362	320 12.598	92 3.622
790 093 466	WH 10-ID-14°/ 30 mm deep	*	*	*	*	*	*	*	*	61 2.402	53 2.087	105 4.134	61 2.402	159 6.260	78 3.071	320 12.598	101 3.976
790 086 218	WH 5-ID-45°	24 0.945	20** 0.787	37 1.457	24 0.945	49 1.929	27 1.063	49 1.929	37 1.457	40 1.575	40 1.575	107 4.213	37 1.457	159 6.260	58 2.283	320 12.598	92 3.622
Application range of tool holders for facing																	
790 086 275	WH 10-ID-80°	41 1.614	37 1.457	41 1.614	43 1.693	58 2.283	43 1.693	58 2.283	56 2.205	80 3.150	56 2.205	110 4.331	56 2.205	159 6.260	64 2.520	320 12.598	92 3.622

* Tool holder cannot be clamped / is not usable

** With diameter 20 mm: max. length of bevel 4 - 5 mm (0.157 - 0.197 inch).

Abbreviations:

WH = Tool holder

WZT = Tool support / Tool retainer

Pipe End Preparation Technology

51

Length of land with the use of tool holder for facing 790 092 202 / 790 093 202 and 790 086 210

Code-No.	Description (α)	MFW 12-V/I-2-R1.2 790 086 060		MFW 30-U-4-R2 790 093 035		MFW 30-U-4-R5 790 093 034	
		Length of land (X1)					
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
790 085 228	WH 5-U-20°	*	*	*	*	*	*
790 093 218	WH 30-U-2°	*	*	1.4	0.055	0	0
790 093 220	WH 30-U-10°	*	*	2.5	0.098	0.5	0.020
790 093 408	WH 30-U-7°	*	*	3.8	0.150	1.1	0.043
790 093 474	WH 30-U-14°	*	*	2.3	0.091	0	0
790 093 478	WH 30-U-25°	*	*	1.1	0.043	0	0
790 093 468	WH 30-V/U-15°	*	*	Land < 0	Land < 0	Land < 0	Land < 0
790 086 208	WH 12-U-10°	1.5	0.059	*	*	*	*
790 086 212	WH 12-U-25°	1.5	0.059	*	*	*	*
790 086 224	WH 12-U-20°	1.5	0.059	*	*	*	*

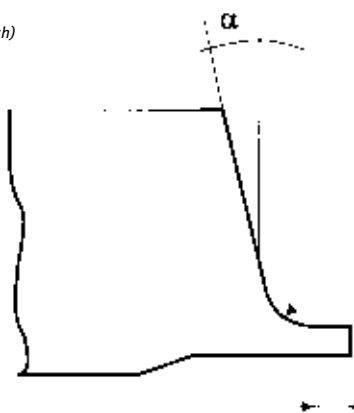
Length of land with the use of tool holder for facing 790 093 410 (adjustable)

Code-No.	Description (α)	MFW 12-V/I-2-R1.2 790 086 060		MFW 30-U-4-R2 790 093 035		MFW 30-U-4-R5 790 093 034	
		Length of land (X1)					
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
790 093 408	WH 30-U-7°	*	*	1 - 7	0.039 - 0.276	0 - 2.5	0 - 0.098
790 093 220	WH 30-U-1°	*	*	0 - 6	0 - 0.236	0 - 3	0 - 0.118
790 093 474	WH 30-U-14°	*	*	0 - 6.5	0 - 0.256	0 - 1	0 - 0.039
790 093 218	WH 30-U-20°	*	*	0 - 5	0 - 0.197	0 - 3.5	0 - 0.138
790 093 478	WH 30-U-25°	*	*	0 - 5	0 - 0.197	0 - 1	0 - 0.039
790 093 468	WH 30-V/U-15°	*	*	Land < 0	Land < 0	Land < 0	Land < 0
790 086 208	WH 12-U-10°	0 - 5	0 - 0.197	*	*	*	*
790 086 224	WH 12-U-2°	0 - 5	0 - 0.197	*	*	*	*
790 086 212	WH 12-U-25°	0 - 5	0 - 0.197	*	*	*	*

* Tool holder cannot be clamped / is not usable

** With diameter 20 mm: max. length of bevel 4 - 5 mm (0.157 - 0.197 inch)

Abbreviations:
WH = Tool holder
WZT = Tool support / Tool retainer



α / Prep Angle

given by the angle of the tool holder WH

R / Radius

given by the radius of the multifunctional tool MFW

X 1 / Length of land

from the pipe end to the beginning of the radius



	<i>Page</i>
<i>Tungsten Grinder</i>	
<i>ESG Plus, ESG Plus²</i>	<i>54</i>
<i>Accessories</i>	<i>55</i>

Tungsten Grinding Technology

Tungsten Grinder

- No adjustment needs to be done before operation
- Repeatable points every time due to preset grinding angles
- Easy and fast to use
- Optimum preparation for orbital and manual welding
- Longitudinal grinding for optimum arc ignition and excellent arc stability
- Guarantees longer tool life and ease of ignition of the tungsten electrode
- Specially designed for one-off jobs on site
- Compact design, optimum resilience and perfect reproducibility
- Solid, functional design
- Precise orbital grinding, very well centered
- Beveling angles 15°; 18°; 22.5°; 30°
- Facility for easy trimming of the electrodes (optional)
- External dust extractor can be easily adapted
- Short preparation times with high grinding performance

ESG Plus

This ESG Plus is the perfect hand-held grinder for cutting, grinding and planing electrodes which are used in WIG or TIG welding machines. Consider country-specific regulations, standards and guidelines when using tungsten electrodes with thorium.

Versions:

ESG Plus²

A sensation: The first portable tungsten grinder with two different grinding wheels. This allows the electrode to be pre-ground with the coarse diamond wheel then finished with the fine diamond wheel.

Comes with:

- 1 Tungsten Grinder ESG Plus or ESG Plus²
- 1 Powder-coated steel carrying case
- 1 Diamond grinding wheel (fine, Code 790 052 487)
- 1 Tool to replace the grinding wheel
- 1 Set of operating instructions and spare parts list

Optional for the ESG Plus²

- 1 Diamond grinding wheel (coarse, Code 790 052 550)

Electric drive with single-phase AC motor:

Power: 500 W

Speed drive: 30,000 rpm

100% power-on time

Application range	ESG Plus, ESG Plus ²
Electrode Ø [mm]	1.0 / 1.6 / 2.0 / 2.4 / 3.2 / 4.0
Electrode Ø [inch]	0.040 / 1/16 / 0.080 / 3/32 / 1/8 / 5/32
Grinding angles [°]	15 / 18 / 22.5 / 30

Article	Version	Code	lbs
ESG Plus	110 V, 50/60 Hz	790 052 486	7.848
ESG Plus ²	110 V, 50/60 Hz	790 052 586	8.201



ESG Plus



ESG Plus²

Accessories for ESG Plus

Diamond grinding wheels

Exchangeable grinding wheel diamond-coated on both sides for optimal performance.

For 0.039 and 0.063 inch electrodes we recommend the standard grinding wheel.

For 0.078 inch and larger electrodes, a medium to coarse grained grinding wheel is advisable.



Article	Version	Grinding wheel Ø [mm]	s [mm]	Code		lbs
Diamond grinding wheel*	Standard	32.0	1.2	790 052 460		0.011
Diamond grinding wheel**	Fine	33.5	2.2	790 052 487		0.022
Diamond grinding wheel**	Medium	33.5	2.2	790 052 488		0.024
Diamond grinding wheel**	Coarse	33.5	2.2	790 052 550		0.024

* for ESG 4
** for ESG Plus

Cutting device

To cut tungsten electrodes to length.

Application range	[mm]	[inch]
Electrode Ø	1.0 / 1.6 / 2.0 / 2.4	0.040 / 1/16 / 0.080 / 3/32
Fixed cutting lengths*	12 / 13 / 15 / 17	0.472 / 0.512 / 0.591 / 0.669

* Other cutting lengths possible.



Article	Code		lbs
Cutting device for ESG Plus	790 052 513		0.066

Electrode holder

With clamping collet for clamping range 0.039 - 0.126 inch, Code 790 052 481.

Article	Code		lbs
Electrode holder	790 052 457		0.051



Clamping collet

To center the electrode in the holder.

For easy grinding of smaller electrodes.

Flexible clamping collet for clamping range 0.039 - 0.126 inch.



Article	Clamping range [mm]	Clamping range [inch]	Code		lbs
Clamping collet	1.0 - 3.2	0.039 - 0.126	790 052 481		0.004



Wall-/table-/vice-mounting plate

For stationary ESG Plus set-up.

Article	Code		lbs
Wall-/table-/vice-mounting plate	790 052 483		0.225



Protective cover

Easy to adapt on the ESG Plus head.

With integrated retainer for suction units. For use on electrodes with thorium.

Not for ESG Plus².

Article	Code		lbs
Protective cover	790 052 496		0.485



Double-Decker Kit

Easy to mount to the ESG Plus. This attachment makes it possible to use 2 different grinding wheels at the same time.

The kit contains a head and a diamond grinding wheel (Code 790 052 550) with an extension shaft.

Article	Code		lbs
Double-Decker Kit	790 052 490		0.353

Page

Accessories for Pipe Threading 58

Thread Jointing Technology 60

Seals 62

Threading, Jointing and Sealing Technology

57

Accessories for Pipe Threading Technology



Automatic quick-change die-heads ASK

for Whitworth pipe threads according to DIN 2999

For threaded pipes according to DIN 2440 and 2441 as well as for stainless steel pipes.

For KM 2. Die-heads are equipped with threading chasers made of HSS (high-speed steel). In the factory the die-heads are precision-adjusted to the requirements according to the thread standards. Right-handed.

Die-heads ASK are also applicable for:

- up to R 2 on KM 2 and GTM 2
- up to R 1 1/4 on TGA

Article	Code	lbs
R 3/8	790 003 403	4.850
R 1/2	790 003 404	5.247
R 3/4	790 003 405	5.291
R 1	790 003 406	6.504
R 1 1/4	790 003 407	6.327
R 1 1/2*	790 003 408	6.978
R 2*	790 003 409	8.940

* not for TGA



Replacement set of threading chasers

for Whitworth pipe threads according to DIN 2999

Made of HSS (high-speed steel). Right-handed.

Article	Code	lbs
R 1/4	790 003 502	0.243
R 3/8	790 003 503	0.220
R 1/2	790 003 504	0.320
R 3/4	790 003 505	0.287
R 1	790 003 506	0.375
R 1 1/4	790 003 507	0.320
R 1 1/2*	790 003 508	0.452
R 2*	790 003 509	0.573

* not for TGA



Replacement set of threading chasers

for pipe threads according to DIN 2440 and 2441

Made of HSS (high-speed steel). Right-handed.

Article	Code	lbs
G 1	790 005 310	0.386
G 1 1/4	790 005 311	0.320
G 1 1/2*	790 005 312	0.441
G 2*	790 005 313	0.441

* not for TGA

Replacement set of threading chasers for GA 2 and SGM 2

Made of HSS (high-speed steel), for Whitworth pipe threads according to DIN 2999
Right-handed.

Article	Code	lbs
R 3/4	790 011 215	1.609
R 1	790 011 216	1.587

Nipple holder

With internal clamping. Self-clamping. For pipes according to DIN 2440.

Article	Thread	Code	lbs
DN 15	R 1/2	790 002 101	0.761
DN 20	R 3/4	790 002 102	1.248
DN 25	R 1	790 002 103	1.631
DN 32	R 1 1/4	790 002 104	2.469
DN 40*	R 1 1/2	790 002 105	3.131
DN 50*	R 2	790 002 106	4.674

* not for TGA



Thread cutting compound SPN PARALIQ® PLUS

Pressure absorption capacity 4 times higher than required according to DVGW worksheet W521. Readily biodegradable. On synthetic basis for drinking-water installations and for the food industries, conforms to requirements regarding food and beverage stuff legislation set out in DVGW/SVGW/ ÖVGW, environmentally friendly.

Article	Version	Code	lbs
SPN PARALIQ® PLUS	Canister, 10 l/357.1 fl oz	790 060 202	24.471
SPN PARALIQ® PLUS, pump sprayer (refillable)	Bottle, 500 ml/17.86 fl oz	790 060 207	1.356



Thread cutting compound NORMOLIC® S

For drinking-water installations according to SVGW regulations.

Article	Version	Code	lbs
NORMOLIC® S	Canister, 10 l/357.1 fl oz	790 051 263	19.841



Thread Jointing Technology



Thread jointing compound PARALIQ® PM 35

For gas, air and water up to 130 °C.

Approved by the DVGW/SGW/ÖVGW in accordance with DIN EN 751, part 2 (DIN 30 660) in the house installation, especially for drinking-water installations. For use with flax.

Article	Version	Code	lbs
Thread jointing compound PARALIQ® PM 35	Can of 600 g	790 060 102	1.521



Thread sealing tape PARALIQ® PM 35

For gas, air and water up to 130 °C. Approved by the DVGW/SGW/ÖVGW in accordance with DIN EN 751, part 2 (DIN 30 660) in the house installation, especially for drinking-water installations. Synthetic tape. For use without flax.

Article	Version	Code	lbs
Thread sealing tape PARALIQ® PM 35	Roll of 25 m, 16 mm wide	790 060 112	0.110



Thread sealing tape SYNTHESOL®

For petrol, heating oil, diesel and fuel up to 150 °C.

Not for use with drinking-water installations. For use without flax.

Article	Version	Code	lbs
Thread sealing tape SYNTHESOL®	Roll of 25 m, 16 mm wide	790 060 062	0.110



Flax dispenser (retail pack)

Including 10 flax bobbins. Innovative and unique retail pack for the presentable display of flax bobbins at the sales counter.

Article	Code	lbs
Flax dispenser, retail pack of 10 bobbins	790 052 702	* 1.720
Flax dispenser, retail pack of 10 bobbins, Set incl. flax pocket dispenser	790 052 703	2.205

* Price refers to a single flax bobbin. Minimum purchase: 10 bobbins = 1 retail pack.



Flax dispenser

Empty, with fixing plate for mounting on wall or work bench.

Easy to use, no waste, optimal proportioning.

Article	Code	lbs
Flax dispenser	790 052 701	0.670

Flax bobbin pocket dispenser

For the fitters pocket.

Easy to use, no waste, optimal proportioning.



Article	Version	Code		lbs
Flax bobbin pocket dispenser	with flax bobbin	790 052 710		0.496
Flax bobbin pocket dispenser	without flax bobbin	790 052 708		0.298

Seals



Seal dispenser

For gas and water installations. Approved by the DVGW in accordance with DIN 3535, Part 6. With 225 asbestos-free seals and protective covering.

Article	Code		lbs
Seal dispenser	790 052 721		1.504
Seal dispenser, empty	790 052 722		0.739
Protective covering for seal dispenser	790 052 723		0.108

Seals for seal dispenser

IT-seals, asbestos-free.

Explanations

- R = Raccord (union/fittings)
- RV = Radiator valve
- H = Dutchman seal
- HK = Dutchman seal, small
- HG = Dutchman seal, large

Article	Dimension	Quantity per pack	Code	lbs*
R 1/4	10 x 6	100	790 052 726	0.002
R 3/8	14 x 10	100	790 052 727	0.002
R 3/8	15 x 8	100	790 052 728	0.002
R 3/8	15 x 10	100	790 052 729	0.002
R 1/2	18 x 10	100	790 052 730	0.002
R 1/2	18 x 11	100	790 052 731	0.002
R 1/2	18 x 12	100	790 052 732	0.002
R 3/4	23 x 17	100	790 052 733	0.002
R 3/4	24 x 15	100	790 052 734	0.002
R 1	30 x 22	100	790 052 735	0.002
R 1 1/4	37 x 29	100	790 052 736	0.002
R 1 1/4	39 x 32	100	790 052 737	0.002
R 1 1/2	44 x 37	100	790 052 738	0.002
R 2	56 x 48	50	790 052 739	0.004
Leather 3/4	23 x 16	100	790 052 740	0.002
RV 3/4	23 x 17	100	790 052 741	0.002
H 3/4	38 x 27	100	790 052 742	0.004
H 1	44 x 32	100	790 052 743	0.004
H 1 1/4	55 x 42	50	790 052 744	0.009
H 1 1/2	62 x 46	50	790 052 745	0.004
H 2	78 x 60	50	790 052 746	0.015
HK 3/8	24 x 17	100	790 052 747	0.002
HK 1/2	30 x 21	100	790 052 748	0.002
HG 3/8	27 x 19	100	790 052 749	0.002
HG 1/2	34 x 23	100	790 052 750	0.002

* Weight per seal



Page

Accessories for LAM 1500, LAM 1600 *64*

Cleaning brushes and calibrating tools *65*

Copper Pipe Installation Technology

63

Accessories for LAM 1500, LAM 1600



Clamp holder with carbon V-electrode

Made of stainless steel.

Article	Code		lbs
Clamp holder with carbon V-electrode	790 057 020		0.084



Carbon V-electrode

Minimum purchase: 10 pieces.

Article	Code		lbs
Carbon V-electrode	790 057 025		0.022



Stick electrode

Minimum purchase: 6 pieces.

Article	Code		lbs
Stick electrode	790 057 026		0.044



Heating tongs with cable

Complete. Cable length 106.3 inch.
Only for LAM 1600.

Article	Code		lbs
Heating tongs with cable	790 057 351		4.608

Cleaning brushes and calibrating tools

Cleaning brushes

Metal brushes to clean copper fittings on the inner diameter

Extended service life through high-grade steel alloy.



Pipe ID [mm]	Pipe ID [inch]	Code	lbs
12	0.472	790 072 283	0.055
15	0.591	790 072 285	0.049
18	0.709	790 072 288	0.055
22	0.866	790 072 289	0.060

Cleaning brushes

Ring brushes to clean copper pipes on the outer diameter

Extended service life through high-grade steel alloy.



Pipe OD [mm]	Pipe OD [inch]	Code	lbs
10	0.394	790 072 301	0.046
18	0.709	790 072 307	0.071

Calibrating tools

In order to get a capillary gap according to standard DIN 1786.



Pipe OD [mm]	Pipe OD [inch]	Pipe ID [mm]	Pipe ID [inch]	Code	lbs
12	0.472	10	0.394	790 072 417	0.265
15	0.591	13	0.512	790 072 421	0.386
18	0.709	16	0.630	790 072 427	0.551

Notes



Page

Work benches, tool box *68*

Pipe vices, deburring tool *69*

Accessories for Workshop and Site

67

Work benches, tool box

Work bench

Dismountable.

Small: with 1 tool box support

Large: with 2 tool box supports



Work bench, large

Dimensions	Work bench small	Work bench large
[cm]	120 x 75	150 x 100
[inch]	47.24 x 29.53	59.06 x 39.37

Article	Code	lbs
Work bench, small	790 052 001	141.094
Work bench, large*	790 052 004	209.437

* while stocks last.

Collapsible work bench



Collapsible work bench

Dimensions	Collapsible work bench
Dimensions [cm]	100 x 70
Dimensions [inch]	39.37 x 27.56
Load capacity [kg/lbs]	650 / 1,433

Article	Code	lbs
Collapsible work bench	790 052 030	70.547

Tool box

For mounting under the work benches Code 790 052 001 and 790 052 004.



Dimensions	Tool box
Outside dimensions [cm]	100 x 40 x 65
Outside dimensions [inch]	39.37 x 15.75 x 25.59

Article	Code	lbs
Tool box	790 052 101	110.230

Pipe vices, deburring tool

Chain pipe vice

Complete with pipe support.

Application range	[mm]	[inch]
Pipe OD	up to 165	up to 6.496
Pipe OD with extension roller chain	up to 230	up to 9.055

Article	Code	lbs
Chain pipe vice	790 052 201	13.669
Extension roller chain	790 052 859	1.918



Bench vice

For plastic and stainless steel pipes.

Application range	[mm]	[inch]
Pipe OD	20 - 250	0.8 - 9.8

Article	Code	lbs
Bench vice	790 052 231	12.125
Pipe support	790 052 228	1.433
Spare belt (930 x 28 mm / 36.6 x 1.1 inch)	790 052 247	0.220



Deburring tool

For inner and outer deburring of stainless steel, mild steel, aluminum, non-ferrous metal and plastic tubes and pipes.

Application range	[mm]	[inch]
Pipe OD max.	54	2.126
Pipe ID max.	10	0.394

Article	Code	lbs
Deburring tool	790 052 052	1.003



Worldwide customer focus



- Acclaimed state-of-the-art technology
- Competent contact partners
- Fast, comprehensive delivery service
- Reliable product support
- Practical training programs
- Certified company

You can count on our comprehensive range of services. Our aim is to offer you inspiring customer service – you can measure us against this promise.

Technical support

- Repairs, maintenance, replacement
- Advance cost estimates
- On-site service
- Service training for our customers
- Cost-effective replacement devices on request

Spare parts service

- Approx. 2,000 spare parts always in stock
- State-of-the-art logistics systems

Rental/used machine service

- Weekly rental charges
- Hire purchase
- Long-term rental
- Rental with operator on request

Further support services

- Pick-up service from the customer
- Used machines with warranty

Our customer service team



Service hotline: +49 (0) 77 31 - 792 789

www.orbitalum.com

worldwide

Tools for piping systems.

© DESIGNUM, Radolfzell

ehemals / formerly

+GF+



orbitalum

Contact:

Orbitalum Tools GmbH
Freibühlstraße 19
(from 10.2008:
Josef-Schüttler-Straße 17)
78224 Singen, Germany
Phone +49 (0) 77 31 - 792-0
Fax +49 (0) 77 31 - 792-524
tools@orbitalum.com
www.orbitalum.com

An ITW Company

US 790 700 004_01 (07.2008)

 **orbitalum**

tools for piping systems