

# Power.

Machines and tools  
for tube and pipe  
preparation.

## 2011 Catalog AMERICAS

**orbital** | cutting.  
beveling.  
facing.



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# Superior Equipment. Complete Support.

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# Pipe Cutting & Beveling Technology

3



GF 4



GF 4 AVM



GF 4 MVM

## 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, GF 6 (AVM/MVM)

The new GF series sets new standards in orbital pipe machining. Numerous innovative functions combined with an ergonomic design create significant advantages for you in the industrial prefabrication of pipeline systems.

- Optional feed module AVM or MVM for an automated or manual cutting process
- Locking mechanism prevents unauthorized usage and theft
- A new ergonomically-designed motor handle for a safe and comfortable operating position, which also enables easy cutting of elbows
- Integrated laser pointer to determine the cut off point
- 2 position 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 (65-215 rpm), 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 chip guard protects against flying chips and comes with a measuring port (for GF 4 only)

#### Feed versions:

##### GF 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, plastics, casting materials and non-ferrous metals in just seconds, using the "Planetary Cutting" method.

##### GF 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 or GF 6 (AVM/MVM)\*
- 1 Transportation case
- 1 Saw blade (GF 4: Code 790 042 064, GF 6: 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.

All saws are fitted with the quick disconnect swivel cable.

Drive with single-phase AC motor  
 Power: 1.8 kW (2.41 HP) / 1.9 kW (2.54 HP) with AVM  
 Protection class I (GF AVM), protection class II (GF (MVM))  
 Built-in electronic variable cutting speed with restart inhibitor: 65 - 215 rpm

Application range	GF 4 (AVM/MVM)		GF 6 (AVM/MVM)	
	[mm]	[inch]	[mm]	[inch]
Pipe OD	12 - 120	0.472 - 4.724	21.3 - 168.3	0.839 - 6.626
Wall thickness (depends on material)*	1 - 9	0.039 - 0.354	1.5 - 15	0.059 - 0.591
Pipe ID min. (saw blade Ø 63 mm/2.480 inch)	21	0.827	30	1.181
Pipe ID min. (saw blade Ø 68 mm/2.677 inch)	16	0.630	25	0.984
Pipe ID min. (saw blade Ø 80 mm/3.150 inch)	4	0.157	13	0.512
Pipe ID min. (saw blade Ø 100 mm/3.937 inch)	-	-	0	0
Pipe ID min. (saw blade Ø 110 mm/4.331 inch)	-	-	0	0

\* Increased wall thickness possible with manual feed or by adding an additional cut (depending on the saw blade diameter).

Article	Version	Code	kg
GF 4	230 V, 50/60 Hz EU	790 142 001	55.000
GF 4	120 V, 50/60 Hz EU	790 142 002	55.000
GF 4 AVM	230 V, 50/60 Hz EU	790 142 011	64.500
GF 4 AVM	120 V, 50/60 Hz EU	790 142 012	64.500
GF 4 MVM	230 V, 50/60 Hz EU	790 142 021	60.000
GF 4 MVM	120 V, 50/60 Hz EU	790 142 022	60.000
GF 6	230 V, 50/60 Hz EU	790 143 001	92.700
GF 6	120 V, 50/60 Hz EU	790 143 002	92.700
GF 6 AVM	230 V, 50/60 Hz EU	790 143 011	101.700
GF 6 AVM	120 V, 50/60 Hz EU	790 143 012	101.700
GF 6 MVM	230 V, 50/60 Hz EU	790 143 021	97.800
GF 6 MVM	120 V, 50/60 Hz EU	790 143 022	97.800



GF 6



GF 6 AVM

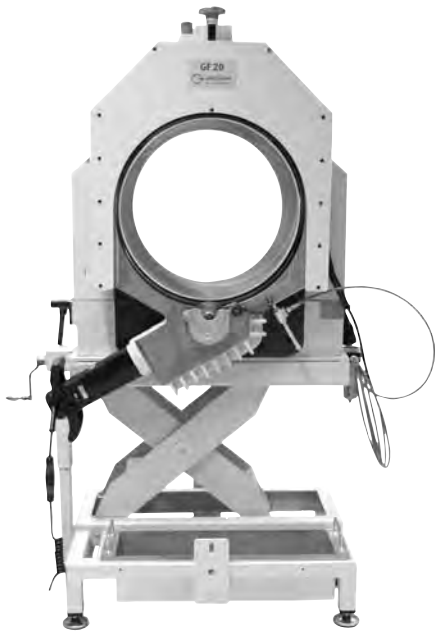


GF 6 MVM

# Pipe Cutting & 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 with 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, plastics, 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 swivel cable with a quick-disconnect coupler for easy and quick replacement of power cables.

Drive with single-phase AC motor

Power: 1.9 kW (2.54 HP)

Protection class I

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

### Application range/dimensions

Pipe ID min. (saw blade Ø 80 mm/3.150 inch)	295 mm	11.6 inch
Pipe ID min. (saw blade Ø 100 mm/3.937 inch)	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	kg
GF 20 AVM	230 V, 50/60 Hz EU	790 050 001	500.000
GF 20 AVM	120 V, 50/60 Hz EU	790 050 002	500.000

## 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	kg
Lifting bench for GF 20 AVM and RA 12	790 050 051	170.000



## Extension unit

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]	400

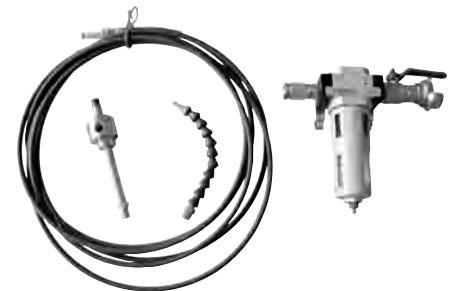
Article	Code	kg
Extension unit for GF 20 AVM	790 050 061	67.000



## Continuous Cooling System

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	kg
Continuous cooling system	Compressed air (5.5 - 8.0 bar required)	790 050 773	0.600



## Aluminum clamping shells

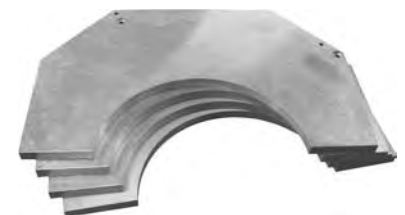
Ideal for clamping thin-walled pipes.

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	kg
Aluminum clamping shells for GF 20 AVM	790 050 708	3.700



# Pipe Cutting & Beveling Technology

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## 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 2, RA 6\*, RA 8 and RA 12

Cutting high-alloy steel (stainless steel), low- and unalloyed steel, plastics, casting materials and non-ferrous metals in just seconds, using the "Planetary Cutting" method. Pipe Cutting and Beveling Machines with special aluminum clamping jaws or aluminum attachments. Supplied as standard with RA 6\*, RA 8 and RA 12.

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

All RA's are fitted with the swivel cable with a quick-disconnect coupler for easy and quick replacement of power cables.

Drive with single-phase AC motor

Power: 1.8 kW (2.41 HP) / 1.9 kW (2.55 HP) with AVM

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

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



RA 6, RA 6 AVM, RA 6 MVM\*



RA 8, RA 8 AVM, RA 8 MVM

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	190
saw blade Ø 63 mm/2.480 inch	[inch]	0.276	2.992	5.394	7.480
Pipe ID min.	[mm]	2	71	132	185
saw blade Ø 68 mm/2.677 inch	[inch]	0.079	2.795	5.197	7.283
Pipe ID min.	[mm]	-	59	120	173
saw blade Ø 80 mm/3.150 inch	[inch]	-	2.329	4.724	6.811
Pipe ID min.	[mm]	-	39	100	153
saw blade Ø 100 mm/3.937 inch	[inch]	-	1.535	3.937	6.024

\* RA 6 (AVM/MVM) while stocks last. Replaced by GF 6 (AVM/MVM), see page 6.  
 \*\* The automatic and manual feed module AVM/MVM is already fitted to the pipe cutter upon delivery.  
 \*\*\* Special clamping jaws must be installed for pipes with an outer diameter (OD) of < 85 mm (3.346 inch). These are already delivered with the RA 6.  
 \*\*\*\* Increased wall thickness possible with manual feed or by adding an additional cut (depending on the saw blade diameter). When processing thin-walled tubes, special clamping shells may be needed, see page 16.

Article	Version	Code		kg
RA 2	230 V, 50/60 Hz EU	790 041 095		45.000
RA 2	120 V, 50/60 Hz EU/US	790 041 096		45.000
RA 2 INOX	230 V, 50/60 Hz EU	790 041 057		49.000
RA 2 INOX	120 V, 50/60 Hz EU/US	790 041 090		49.000
RA 6*	230 V, 50/60 Hz EU	790 043 095		98.000
RA 6*	120 V, 50/60 Hz EU/US	790 043 096		98.000
RA 6 AVM*	230 V, 50/60 Hz EU	790 043 001		108.000
RA 6 AVM*	120 V, 50/60 Hz EU/US	790 043 007		108.000
RA 6 MVM*	230 V, 50/60 Hz EU	790 043 069		101.000
RA 6 MVM*	120 V, 50/60 Hz EU/US	790 043 082		101.000
RA 8	230 V, 50/60 Hz EU	790 045 095		112.000
RA 8	120 V, 50/60 Hz EU/US	790 045 096		112.000
RA 8 AVM	230 V, 50/60 Hz EU	790 045 001		122.000
RA 8 AVM	120 V, 50/60 Hz EU/US	790 045 007		122.000
RA 8 MVM	230 V, 50/60 Hz EU	790 045 069		115.000
RA 8 MVM	120 V, 50/60 Hz EU/US	790 045 082		115.000
RA 12	230 V, 50/60 Hz EU	790 047 095		141.000
RA 12	120 V, 50/60 Hz EU/US	790 047 096		141.000
RA 12 AVM	230 V, 50/60 Hz EU	790 047 001		144.000
RA 12 AVM	120 V, 50/60 Hz EU/US	790 047 007		144.000
RA 12 MVM	230 V, 50/60 Hz EU	790 047 069		137.000
RA 12 MVM	120 V, 50/60 Hz EU/US	790 047 082		137.000



RA 12, RA 12 AVM, RA 12 MVM

# Pipe Cutting & Beveling Technology



# GFX Pipe Cutting and Beveling Machines



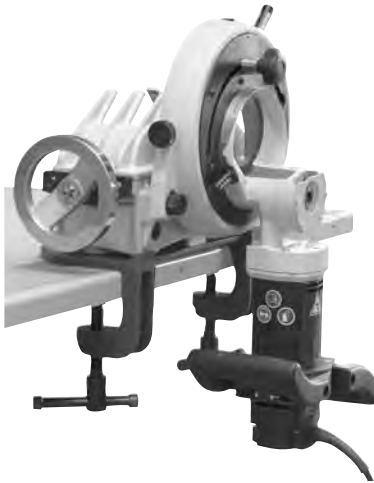
- Square, burr-free and cold machining process
- Deformation-free clamping system especially applicable for thin-walled tubes
- Optimized chip flow due to a new vice design
- Hardened cast iron clamping jaws
- Integrated laser pointer to mark the cut off point
- Ergonomically designed motor handle
- New more powerful drive with 1.2 kW and adjustable speed control for cutting several materials and extended tool life
- Electronic overload protection with integrated temperature monitor and electronic speed regulation
- Increased durability of tools due to the new drive GF10
- Ergonomically positioned speed control adjusting wheel
- Swivel cable with a quick-disconnect coupler
- Environmentally friendly and long product life
- Second saw blade position to cut off elbows
- Easy handling through light weight
- Simultaneous or separate cutting and beveling
- Increased productivity
- Low-maintenance und service friendly

## GFX 3.0

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.

### Machine comes with:

- 1 Pipe Cutting and Beveling Machine GFX 3.0
- 1 Transportation case
- 1 Saw blade (Code 790 048 072)
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Set of operating instructions and spare parts list



Application range	Pipe OD min.-max.		Saw blade-Ø		Wall thickness min.-max.	
	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
Pipes	6.0 - 78.0	0.236 - 3.071	63	2.480	0.8 - 5.5	0.032 - 0.217
	6.0 - 73.0	0.236 - 2.874	68	2.677	0.8 - 7.0	0.032 - 0.276
Bars	6.0 - 16.0	0.236 - 0.630	63	2.480	-	-
	6.0 - 21.0	0.236 - 0.827	68	2.677	-	-
Pipe materials	Unalloyed steel, low alloy steel, high alloy steel, stainless steel, nonferrous metal, aluminum alloy, titanium alloy, composite material and plastic					

Technical data	Electric drive with single-phase AC motor
Dimensions (l x h x d) [mm/inch]	570 x 280 x 330 / 22.441 x 11.024 x 12.993
Weight (without clamping shells) [kg/lbs]	28.1 / 62.04
Protection class	II (double insulated)
Voltage	230 V, 50/60 Hz EU 120 V, 50/60 Hz US
Power [W]	1200
Nominal speed range [rpm]	30 - 200
Vibration level (EN 50144) [m/s²]	< 2.5

Article	Version	Code	kg
GFX 3.0	230 V, 50/60 Hz EU	790 144 001	28.100
GFX 3.0	120 V, 50/60 Hz US	790 144 002	28.100

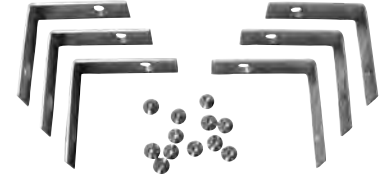
## Accessories for GFX 3.0

### Set of stainless steel caps

Ideal for preparing stainless steel tubes. Prevents contact corrosion between tube and clamping parts. Clamping shells for thin-walled tubes are available on request.

**Set comes with:**

- 6 Stainless steel caps
- 12 Countersunk screws
- 1 Allen key



Article	Code	kg
Set of stainless steel caps for GFX 3.0	790 144 200	0.150

### Quick-mounting base plates

With and without integrated screw clamps for quick mounting of the machine on work benches, see pages 18 and 19.

### Durable storage and shipping case

High-quality padded blue shipping case.

Article	Code	kg
Durable storage and shipping case for GFX 3.0	790 144 019	12.500



## 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 especially for use on site
- Sturdy design with powerful drive



### RA 21 S

Cutting high-alloy steel (stainless steel), low- and unalloyed steel, plastics, 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	kg
RA 21 S	230 - 240 V, 50/60 Hz EU	790 044 008	34.200
RA 21 S	115 V, 50/60 Hz EU	790 044 015	34.200
RA 21 S	100 - 120 V, 50/60 Hz US	790 044 010	34.200
RA 21 S INOX	230 - 240 V, 50/60 Hz EU	790 044 060	34.200
RA 21 S INOX	115 V, 50/60 Hz	790 044 094	34.200



### Durable storage and shipping case

High quality padded blue shipping case. Particularly sturdy design.

Supplied as standard with the RA 21 S.

Article	Code	kg
Durable storage and shipping case for RA 21 S	790 044 019	11.400

# 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, plastics, casting materials and non-ferrous metals in just seconds, using the "Planetary Cutting" method.

### Machine comes with:

- 1 Pipe Cutting and Beveling Machine RA 41 Plus
- 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: 1.8 kW (2.41 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed with restart inhibitor: 65 - 215 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	kg
RA 41 Plus	230 V, 50/60 Hz EU	790 046 011	77.000
RA 41 Plus	120 V, 50/60 Hz EU	790 046 014	77.000
RA 41 Plus	120 V, 50/60 Hz US	790 046 012	77.000

## 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	Tube OD [mm]	Tube OD [inch]	Code	kg
for RA 6	76.1	3.000	790 043 216	4.500
for RA 8	129.0	5.079	790 045 216	4.300
for RA 8	167.0	6.575	790 045 218	4.000
for RA 8	210.0	8.268	790 045 217	2.900
for RA 12	209.0	8.230	790 047 221	11.500
for RA 12	219.0	8.620	790 047 220	11.200
for RA 12	254.0	10.000	790 047 216	9.200
for RA 12	273.0	10.750	790 047 219	8.400
for RA 12	324.0	12.760	790 047 218	6.100

### Aluminum clamping shells for GF 4 and RA 41 Plus

For deformation-free clamping of thin-walled pipes.

Further clamping shells are available for various outer diameters.



Pipe-OD [mm]	Pipe-OD [inch]	Code	kg
25.40	1.000	790 046 316	3.025
38.10	1.500	790 046 331	2.950
50.80	2.000	790 046 345	2.850
76.10	2.996	790 046 358	2.800
88.90	3.500	790 046 363	2.500
108.00	4.252	790 046 367	1.640
114.30	4.500	790 046 368	1.640

### Special stainless steel clamping jaws for RA 2, RA 21 S, GF 4, RA 4 and RA 41 Plus

In pairs.



Article	Code	kg
Special stainless steel clamping jaws for RA 2 and RA 21 S	790 041 323	1.035
Special stainless steel clamping jaws for GF 4, RA 4 and RA 41 Plus	790 042 201	2.350

## Aluminum clamping jaws

For GF 4 and RA 41 Plus.

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

Article	Version	Code	kg
Aluminum clamping jaws for RA 41 Plus	right + left	790 046 250	2.600
Aluminum clamping jaws for GF 4	right + left	790 142 100	2.745

## Tempered cast steel clamping jaws

For GF 4.

Article	Version	Code	kg
Tempered cast steel clamping jaws for GF 4	right + left	790 142 139	6.300

## 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 food approval NSF H2.

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

Article	Version	Code	kg
Saw blade lubricant GF TOP	Tube, 180 g	790 060 228	0.205

## Saw blade lubricant GF LUB

**The NEW chlorine-free high-performance lubricant for cutting and beveling.**

Increases the tool life of the saw blade. This ecologically cutting compound is the environmentally friendly replacement for ROCOL: just with a new name and improved quality. GF LUB meets the latest environmental directives and ecological standards.

Article	Version	Code	kg
Saw blade lubricant GF LUB	Tube, 160 ml	790 041 016	0.144

## Special gear oil

For all GF and RA machines.

Article	Version	Code	kg
Special gear oil	Bottle, 250 ml	790 041 030	0.235



Aluminum clamping jaws for GF 4





## 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	kg
Pipe length gauge bar	790 041 011	1.568



## Intermediate gearbox retrofit kit

To convert a standard pipe cutting and beveling RA machine (RA) to RA H (with intermediate gear) with the former FE 680 Motor (150 - 270 rpm). 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 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	kg
Intermediate gearbox retrofit kit	790 041 063	2.000



Swivel cable

## Swivel cable

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

Article	Version	Cable length [m/ft]	Code	kg
Swivel cable complete	230 V, 50/60 Hz EU	4	790 142 081	0,560
Swivel cable complete	120 V, 50/60 Hz US/CN	4	790 142 082	0,560
Swivel cable complete	230 V, 50/60 Hz CH	4	790 142 083	0,560
Swivel cable complete	230 V, 50/60 Hz AUS	4	790 142 084	0,560
Swivel cable complete	120 V, 50/60 Hz GB	4	790 142 087	0,560
Swivel cable	230 V, 50/60 Hz EU	4	790 142 076	0,560
Swivel cable	120 V, 50/60 Hz US/CN	4	790 142 077	0,560
Swivel cable	230 V, 50/60 Hz CH	4	790 142 078	0,560
Swivel cable	120 V, 50/60 Hz GB	4	790 142 079	0,560
Swivel cable	230 V, 50/60 Hz AUS	4	790 142 080	0,560



Swivel cable complete

## Quick-mounting base plate without screw clamps

Complete with screws and nuts to mount the GFX 3.0 on a work bench.

Article	Code	kg
Quick-mounting base plate complete for GFX 3.0, RA 2 (H), RA 21 S	790 041 026	2.380



## Quick-mounting base plates with integrated screw clamps

For quick mounting of the machine on work benches. Ideal for frequent changes of location.

Article	Code	kg
Quick-mounting base plate for GFX 3.0, RA 2 (H), RA 21 S	790 041 027	4.230
Quick-mounting base plate for GF 4, RA 4 (H), RA 6 (H), RA 8 (H), RA 41 Plus (H)	790 042 027	6.165
Quick-mounting base plate for PS 4.5 and PS 6.6	790 048 334	2.600

## 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 21 S and GF 20 AVM. RA 2 on request). 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.

Application range / technical details	Pipe feeder base unit		Pipe feeder extension unit	
Pipe OD [mm/inch]	16 - 325	0.630 - 12.795	16 - 325	0.630 - 12.795
Dimensions [cm/inch] approx.	185 x 105 x 50	72.8 x 41.3 x 19.7	160 x 105 x 50	62.9 x 41.3 x 19.7
Load capacity max. [kg/lbs]	400	881.84	400	881.84

Article	Code	kg
Pipe feeder base unit	790 068 051	116.000
Pipe feeder extension unit	790 068 061	72.000
Floor bracket accessory	790 068 053	1.900

## Mobile Workstation

For the mobile site and/or workshop. The ideal addition for all Orbitalum pipe cutters (with exception of RA 21 S and PS saws. RA 2 on request).

- Safe and easy transportation of machines and equipment on site.
- Flexible operation at each working station.
- Elimination of material handling and setting up of the machines e.g. no requirement to mount the machines to benches.
- Height-adjustable pipe support with stainless steel roller.
- The tool box comes with 4 drawers for tools and equipment and is lockable.
- Lifting table with height adjustment of the GF- and RA-machines to the required pipe dimension.
- Accurate and clean work by swarf collection tray.

Technical details	Mobile Workstation
Dimensions (h x l x b) [cm/inch]	91 x 115 x 43 / 35.83 x 45.28 x 16.93
Load capacity max. [kg/lbs]	675/1,488

Article	Code	kg
Mobile Workstation	790 068 071	137.000



Pipe feeder base unit



Pipe feeder extension unit



# Pipe Cutting & Beveling Technology

# 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	kg
	[mm]	[inch]	[mm]	[inch]		
Economy	1.2 - 2.5	.047 - .098	63	2.480	790 041 135	0.035
Economy*	1.5 - 6.0	.059 - .236	68	2.677	790 042 063	0.036
Economy*	5.0 - 12.0	.197 - .472	80	2.953	790 043 030	0.053
Economy	2.0 - 5.5	.079 - .217	63	2.480	790 041 020	0.032
Economy	2.5 - 7.0	.098 - .276	68	2.677	790 042 020	0.045
Performance	0.6 - 1.2	.024 - .047	63	2.480	790 041 036	0.027
Performance	1.0 - 1.6	.039 - .063	68	2.677	790 042 049	0.040
Performance	1.0 - 3.0	.039 - .118	63	2.480	790 048 072	0.025
Performance	1.2 - 2.5	.047 - .098	63	2.480	790 041 035	0.045
Performance	1.2 - 2.5	.047 - .098	68	2.677	790 042 064	0.050
Performance**	1.2 - 2.5	.047 - .098	100	3.937	790 043 036	0.104
Performance	1.2 - 3.0	.047 - .118	83	3.268	790 043 024	0.060
Performance	1.5 - 2.5	.059 - .098	80	3.150	790 046 022	0.085
Performance	2.5 - 5.5	.098 - .217	63	2.480	790 041 048	0.035
Performance**	2.5 - 5.5	.098 - .217	100	3.937	790 043 038	0.104
Performance***	2.5 - 5.5	.098 - .217	110	4.331	790 050 110	0.138
Performance	2.5 - 7.0	.098 - .276	68	2.677	790 042 048	0.045
Performance	2.5 - 7.0	.098 - .276	80	3.150	790 043 018	0.060
Performance	6.0 - 10.0	.236 - .394	80	2.953	790 043 022	0.055
Performance**	6.0 - 15.0	.236 - .591	100	3.937	790 047 026	0.105
High-Performance	1.2 - 2.5	.047 - .098	80	3.150	790 046 021	0.064
High-Performance	1.2 - 2.5	.047 - .098	63	2.480	790 041 034	0.031
High-Performance	2.5 - 7.0	.098 - .267	68	2.677	790 042 058	0.045
Premium	1.2 - 2.5	.047 - .098	63	2.480	790 041 049	0.033

\* applicable only for aluminum pipes

\*\* only for RA 6, RA 8, RA 12 and GF 20 AVM

\*\*\* only for GF 20 AVM

## Saw blades

Saw blades with additional borehole. Minimum purchase: 5 blades

Article	Pipe wall thickness		Saw blade Ø		Code	kg
	[mm]	[inch]	[mm]	[inch]		
Performance	1.2 - 2.5	.047 - .098	63	2.480	790 041 435	0.030
Performance	1.2 - 2.5	.047 - .098	68	2.677	790 042 464	0.037
Performance	1.5 - 2.5	.059 - .098	80	3.150	790 046 422	0.080
Performance	2.5 - 7.0	.098 - .276	68	2.677	790 042 448	0.036



## 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	kg
	[mm]	[inch]		[°]	[mm]	[inch]	[mm]		
Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 161	0.108
High-Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 015	0.120
High-Performance	2.5 - 6.0	.098 - .236	45	4	.157	68	2.677	790 042 023	0.135
High-Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 013	0.108



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

Article	Version	Code	kg
Saw blade for 790 042 155, 790 042 157 and 790 042 161	Performance	790 042 153	0.040
Bevel cutter 30° for 790 042 161	Performance	790 042 160	0.060
Saw blade for 790 042 018, 790 042 015, 790 042 023, 790 042 013	High-Performance	790 042 016	0.040
Bevel cutter 30° for 790 042 013	High-Performance	790 042 021	0.077

## 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	kg
Support disc	790 046 188	0.068

## Press fitting saw blade/bevel cutter combinations\*\*

Article	Pipe wall thickness		Beveling angle	Height of bevel max.		Saw blade Ø		Code	kg
	[mm]	[inch]		[°]	[mm]	[inch]	[mm]		
Performance	1.0 - 2.0	.039 - .079	45 / 70	0.4/1.0	.016/.039	63	2.480	790 044 046	0.090
High Performance	1.0 - 2.0	.039 - .079	45 / 70	0.4/1.0	.016/.039	63	2.480	790 044 047	0.090



## Replacement parts for press fitting saw blade/bevel cutter combinations

Article	Version	Code	kg
Saw blade for 790 044 046	Performance	790 044 040	0.027
Saw blade for 790 044 047	High Performance	790 044 041	0.030
Bevel cutter for 790 044 047	High Performance	790 044 043	0.065

\* 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	kg
		[°]	[mm]	[inch]	[mm]		
Economy	30.0	9.5	.374	72	2.835	790 042 045	0.135
Economy	35.0	8.9	.350	70	2.756	790 042 037	0.170
Economy	37.5	8.4	.331	70	2.756	790 042 036	0.162
Economy	45.0	7.5	.295	70	2.756	790 042 038	0.162
Performance	30.0	9.5	.374	72	2.835	790 042 071	0.153
Performance	30.0	13.0	.512	76	2.992	790 043 023	0.187
Performance	30.0	20.0*	.787*	100	3.937	790 043 027	0.250
Performance	37.5	8.4	.331	70	2.756	790 042 070	0.163
Performance	50.0	5.8	.228	70	2.756	790 042 050	0.168
High-Performance	30.0	9.5	.374	72	2.835	790 042 073	0.157
High-Performance	37.5	8.4	.331	70	2.756	790 042 072	0.163

\* Height of bevel max. 20 mm (0.787 inch) only with aluminum pipes. Other pipe materials: max. 13 mm (0.512 inch).



### 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 food approval NSF H2.

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

Article	Version	Code	kg
Saw blade lubricant GF TOP	Tube, 180 g	790 060 228	0.205



### Saw blade lubricant GF LUB

#### The NEW chlorine-free high-performance lubricant for cutting and beveling.

Increases the tool life of the saw blade. This ecologically cutting compound is the environmentally friendly replacement for ROCOL: just with a new name and improved quality. GF LUB meets the latest environmental directives and ecological standards.

Article	Version	Code	kg
Saw blade lubricant GF LUB	Tube, 160 ml	790 041 016	0.144

# Portable Tube Saws

- Lightweight and easily transportable machine (only 23 kg (PS 4.5) or 26 kg (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 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	kg
PS 4.5	230 V, 50/60 Hz EU	790 048 001	37.000
PS 4.5	110 V, 50/60 Hz EU	790 048 002	37.000
PS 4.5	120 V, 50/60 Hz US	790 048 003	37.000
PS 6.6	230 V, 50/60 Hz EU	790 049 001	41.000
PS 6.6	110 V, 50/60 Hz EU	790 049 002	41.000
PS 6.6	120 V, 50/60 Hz US	790 049 003	41.000

# Pipe Cutting & Beveling Technology

## 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	kg
Quick-mounting plate with screw clamps	790 048 334	2.600



### 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	kg
Performance	1.0 - 3.0	0.039 - 0.118	63	2.480	790 048 072	0.035
Performance	1.2 - 2.5	0.047 - 0.098	63	2.480	790 041 035	0.045
Performance	0.6 - 1.2	0.024 - 0.047	63	2.480	790 041 036	0.027



### 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	kg
Tripod	790 048 335	10.600



### Clamping jaws replacement set

**Made from coated cast aluminum.**  
Extends the dimension range of the PS 6.6 to OD min. 30 mm (1.181 inch).

Article	Code	kg
Clamping jaws replacement set for PS 4.5 and extension jaws for PS 6.6	790 048 380	2.030



### Laser retrofitting kit

**Line laser 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	kg
Laser retrofitting kit for PS 4.5 and PS 6.6	790 048 060	0.150

# Universal Pipe Cutter

- Powerful and lightweight machine
- Secure operation by means of overload protection and chip guard
- Burr-free and square cut
- Corrosion and heat resistant
- The SCORP 170e now incorporates an electric speed regulator – preserves the tools, optimises the working process!
- Wide range of applications and dimensions
- No rework necessary
- The cut is square enough for a mechanical clamping joint
- Reduction of tool costs and cutting time



SCORP 170e and SCORP 170

## SCORP 170(e)\*, 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
- 1 Bag for easy transportation
- 4 Small pipe rollers (SCORP 170(e) and SCORP 220 Plus)
- 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:

Technical details	SCORP 170	SCORP 170e*	SCORP 220 Plus	SCORP 360
Power (230 V)	1,010 W / 1.3 hp	1,200 W / 1.6 hp	1,100 W / 1.5 hp	1,400 W / 1.9 hp
Power (120 V)	950 W / 1.2 hp	1,100 W / 1.5 hp	1,100 W / 1.5 hp	1,400 W / 1.9 hp
Max. saw blade speed range [rpm]	4,000	1,600 - 3,500	4,000	4,000

Application range		SCORP 170	SCORP 170e*	SCORP 220 Plus	SCORP 360
Pipe OD	[mm]	15 - 170	15 - 170	20 - 220	75 - 360
	[inch]	0.591 - 6.693	0.591 - 6.693	0.800 - 8.660	2.950 - 14.170
Wall thickness (steel) max.	[mm]	6	8	8	8
	[inch]	0.236	0.315	0.315	0.315
Wall thickness (plastic) max.	[mm]	14	14	10	27.9**
	[inch]	0.551	0.551	0.394	1.098**

\* SCORP 170e = with speed regulator

\*\* depends on dimension

Article	Version	Code		kg
SCORP 170	230 V, 50/60 Hz	790 016 001		5.800
SCORP 170	120 V, 50/60 Hz	790 016 002		5.800
SCORP 170e	230 V, 50/60 Hz	790 016 004		5.900
SCORP 170e	120 V, 50/60 Hz	790 016 005		5.900
SCORP 220 Plus	230 V, 50/60 Hz	790 014 007		9.500
SCORP 220 Plus	120 V, 50/60 Hz	790 014 008		9.500
SCORP 360	230 V, 50/60 Hz	790 015 001		14.300
SCORP 360	120 V, 50/60 Hz	790 015 002		14.300



SCORP 220 Plus



SCORP 360



Pipe roller (small)



Transportation bag

# Pipe Cutting & Beveling Technology

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# Saw blades for SCORP machines

## Saw blade TCT



Article	For pipe materials	Saw blade Ø [mm/inch]	rpm max.	Code	kg
Saw blade TCT	Steel, copper, aluminum, all kinds of plastic	140/5.512	4,200	790 014 055	0.154
Saw blade TCT*	All kinds of plastic	155/6.102	4,200	790 014 058	0.195

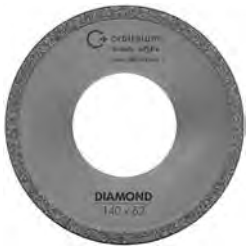
\* only for SCORP 360

### 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
125	4.921	8.8	0.346	16.3	0.642
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
180	7.087	9.9	0.390	17.4	0.685
190	7.480	10.4	0.409	17.9	0.705
200	7.874	10.9	0.429	18.4	0.724
215	8.465	11.8	0.465	19.3	0.760
225	8.858	12.4	0.488	19.9	0.783
240	9.449	13.4	0.528	20.9	0.823
250	9.843	14.0	0.551	21.5	0.846
270	10.630	15.4	0.606	22.9	0.902
280	11.024	16.0	0.630	23.5	0.925
315	12.402	18.3	0.720	25.8	1.016
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	Cutting blade Ø [mm/inch]	rpm max.	Code	kg
Cutting blade Diamond	Cast iron	140/5.512	4,200	790 014 057	0.173
Cutting blade Diamond*	Cast iron	155/6.102	4,200	790 014 059	0.200

\* only for SCORP 360

## Saw blade Cermet



Article	For pipe materials	Saw blade Ø [mm/inch]	rpm max.	Code	kg
Saw blade Cermet	Stainless steel	140/5.512	4,200	790 014 056	0.153

# Metal Tube Cutter

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 e.g. no. 1.40... to 1.45... or 304/316 materials)
- Low alloy and unalloyed steel
- Cast materials
- Non-ferrous metals

### Comes with:

- 1 Metal Tube Cutter MRA\*
- 1 Durable storage and shipping case
- 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	kg
Metal Tube Cutter MRA	Standard	790 008 001	8.000

## Accessories for MRA

### Multi-roller cutting chains

Cutting wheels made from hardened steel.



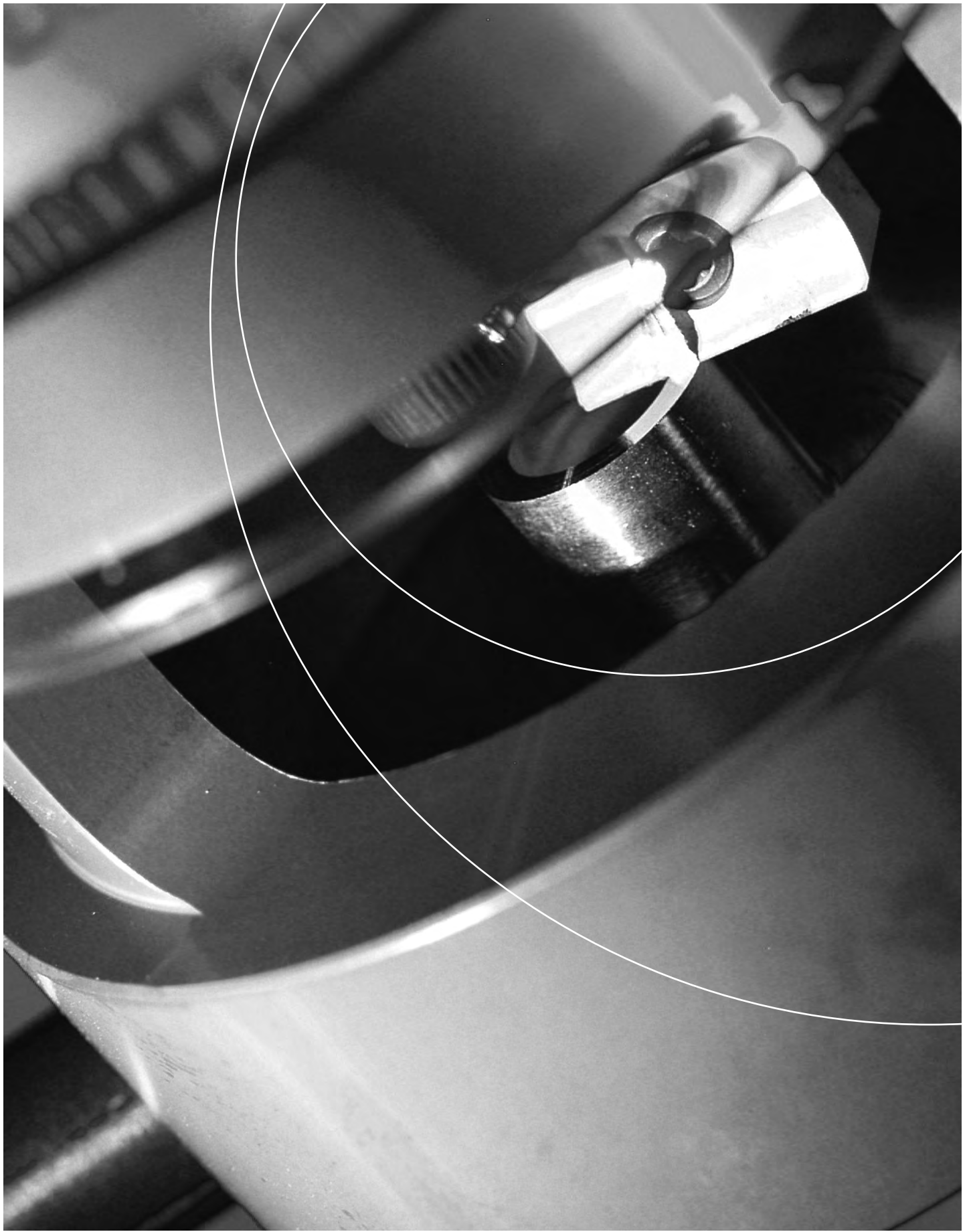
Article	Tube OD [mm]	Tube OD [inch]	Number of cutting wheels [pieces]	Code	kg
Multi-roller cutting chain	33.7 - 114.3	1.330 - 4.500	15	790 008 018	0.500
Multi-roller cutting chain	114.3 - 254.0	4.500 - 10.000	16	790 008 041	0.900

### Clamping shells

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.



Article	Tube OD [mm]	Tube OD [inch]	Code	kg
Clamping shells for MRA	25.0	0.984	790 008 102	0.750
Clamping shells for MRA	25.4	1.000	790 008 104	0.795
Clamping shells for MRA	29.0	1.142	790 008 103	0.835
Clamping shells for MRA	33.7	1.330	790 008 105	0.885
Clamping shells for MRA	38.1	1.500	790 008 130	0.955
Clamping shells for MRA	40.0	1.575	790 008 135	0.955
Clamping shells for MRA	42.4	1.670	790 008 140	1.005
Clamping shells for MRA	44.5	1.752	790 008 150	1.052
Clamping shells for MRA	48.3	1.900	790 008 155	1.100
Clamping shells for MRA	50.0	1.970	790 008 160	1.130
Clamping shells for MRA	50.8	2.000	790 008 165	1.140
Clamping shells for MRA	52.0	2.050	790 008 175	1.190
Clamping shells for MRA	53.0	2.087	790 008 180	1.150
Clamping shells for MRA	54.0	2.125	790 008 185	1.100
Clamping shells for MRA	57.0	2.244	790 008 190	1.200
Clamping shells for MRA	60.3	2.375	790 008 195	1.315
Clamping shells for MRA	63.5	2.500	790 008 200	1.375
Clamping shells for MRA	65.0	2.559	790 008 203	1.375
Clamping shells for MRA	70.0	2.755	790 008 215	1.445
Clamping shells for MRA	73.0	2.874	790 008 220	1.480
Clamping shells for MRA	75.0	2.950	790 008 225	1.600
Clamping shells for MRA	76.1	2.996	790 008 230	1.560
Clamping shells for MRA	80.0	3.150	790 008 233	1.375
Clamping shells for MRA	84.0	3.300	790 008 240	1.690
Clamping shells for MRA	85.0	3.350	790 008 245	1.750
Clamping shells for MRA	88.9	3.500	790 008 250	1.780
Clamping shells for MRA	100.0	3.937	790 008 255	1.970
Clamping shells for MRA	101.6	4.000	790 008 260	2.025
Clamping shells for MRA	104.0	4.095	790 008 270	1.925
Clamping shells for MRA	108.0	4.252	790 008 280	2.100
Clamping shells for MRA	110.0	4.330	790 008 285	2.150
Clamping shells for MRA	114.3	4.500	790 008 290	2.295
Clamping shells for MRA	129.0	5.080	790 008 315	3.000
Clamping shells for MRA	139.7	5.500	790 008 325	3.365
Clamping shells for MRA	150.0	5.906	790 008 333	3.375
Clamping shells for MRA	152.4	6.000	790 008 335	3.232
Clamping shells for MRA	154.0	6.060	790 008 340	3.365
Clamping shells for MRA	160.0	6.300	790 008 355	3.520
Clamping shells for MRA	165.0	6.496	790 008 360	4.125
Clamping shells for MRA	168.3	6.625	790 008 365	3.600
Clamping shells for MRA	204.0	8.030	790 008 380	4.375
Clamping shells for MRA	219.1	8.625	790 008 385	4.680
Clamping shells for MRA	228.6	9.000	790 008 387	4.890
Clamping shells for MRA	254.0	10.000	790 008 390	5.420



## Tube Squaring Technology

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RPG ONE



RPG ONE Cordless



RPG 1.5



RPG 1.5 Cordless



RPG 2.5



RPG 2.5 Cordless

## Tube Squaring Machines

- 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
- Modular design, ensuring compatibility within the RPG series
- The special adaptor clamping shell allows the RPG 2.5 to be used with the clamping shells for the RPG 1.5 machines
- Machines have a removable bench stand (mains versions only)
- Machine with rotating/removable drive
- Very short design (cordless versions)

### Improved features in the cordless versions thanks to lithium ion technology:

- Motor with high performance and small size
- No memory effect
- Single cell monitoring in the cordless pack
- Electronic overload protection with integrated temperature monitor
- Robust cordless packs with capacity display
- Minimal self-discharge
- Environmentally friendly
- AIR COOLED technology for short charging times and a long service life

### RPG ONE (Cordless), RPG 1.5 (Cordless), RPG 2.5 (Cordless)

Designed for burr-free squaring and beveling of thin-walled stainless steel tubes and micro fittings. For the required, high quality tube end preparation for orbital welding!

#### Machine comes with:

- 1 Tube Squaring Machine RPG ONE, RPG 1.5 or 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)
- 1 Multifunctional tool (Code 790 038 314)
- 1 Adapter clamping shell (Code 790 030 094, only for RPG 2.5)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

Bench stand for cordless machines optional available (Code 790 037 169).

Technical data	RPG ONE	RPG ONE Cordless	RPG 1.5	RPG 1.5 Cordless	RPG 2.5	RPG 2.5 Cordless
Built-in electronic variable cutting speed [rpm]	145 - 380	0 - 400	145 - 380	0 - 400	1. speed: 9 - 52 2. speed: 27 - 153	1. speed: 0 - 24 2. speed: 0 - 83
Power [W]	1010	-	1010	-	1010	-
Voltage of rechargeable battery [V]	-	18	-	18	-	18

Application range	RPG ONE (Cordless)	RPG 1.5 (Cordless)	RPG 2.5 (Cordless)
Tube OD min.-max. [mm]	3.00 - 25.40	3.00 - 38.10	6.35* - 63.50
Tube OD min.-max. [inch]	0.118 - 1.000	0.118 - 1.500	0.250* - 2.500
Wall thickness max. [mm]	3.00	3.00	3.00
Wall thickness max. [inch]	0.118	0.118	0.118

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

Article	Version	Code	kg
RPG ONE	230 V, 50/60 Hz EU	790 036 031	4,140
RPG ONE	120 V, 50/60 Hz US	790 036 032	4,140
RPG ONE	110 V, 50/60 Hz EU	790 036 033	4,140
RPG ONE Cordless (18 V)	230 V, 50/60 Hz EU	790 036 021	2,880
RPG ONE Cordless (18 V)	115 V, 60 Hz US	790 036 022	2,880
RPG 1.5	230 V, 50/60 Hz EU	790 037 001	4,700
RPG 1.5	120 V, 50/60 Hz US	790 037 002	4,700
RPG 1.5	110 V, 50/60 Hz EU	790 037 003	4,700
RPG 1.5 Cordless (18 V)	230 V, 50/60 Hz EU	790 037 011	3,440
RPG 1.5 Cordless (18 V)	115 V, 60 Hz US	790 037 012	3,440
RPG 2.5	230 V, 50/60 Hz EU	790 030 001	6,600
RPG 2.5	120 V, 50/60 Hz US	790 030 002	6,600
RPG 2.5	110 V, 50/60 Hz EU	790 030 003	6,600
RPG 2.5 Cordless (18 V)	230 V, 50/60 Hz EU	790 030 011	5,230
RPG 2.5 Cordless (18 V)	110 V, 60 Hz US	790 030 012	5,230

### Angle drive RPG ONE (Cordless) and RPG 1.5 (Cordless)

The angle drive is optionally available and may be retrofitted to the RPG ONE and RPG 1.5 (cordless). The squaring machine reduces the design length to 200 mm (7.874 inch). Technical characteristics remain unchanged.

Article	Code	kg
Angle drive for RPG ONE and RPG 1.5 (Cordless)	790 037 400	0.475



# Accessories for RPG ONE, RPG 1.5, RPG 2.5 (Cordless)

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



Stainless steel clamping shell  
for micro fittings

## 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.

Applicable with*	Applicable for	Tube OD		Tube clamping length		Code	kg
		[mm]	[inch]	[mm]	[inch]		
RPG ONE	Tubes	3.00	0.118	10.00	0.394	790 036 232	0.118
RPG ONE	Tubes	3.18	0.125	10.00	0.394	790 036 201	0.119
RPG ONE	Tubes	6.00	0.236	10.00	0.394	790 036 213	0.117
RPG ONE	Tubes	6.35	0.250	10.00	0.394	790 036 202	0.118
RPG ONE	Tubes	7.00	0.276	10.00	0.394	790 036 214	0.118
RPG ONE	Tubes	8.00	0.315	10.00	0.394	790 036 215	0.116
RPG ONE	Tubes	9.53	0.375	10.00	0.394	790 036 203	0.115
RPG ONE	Tubes	10.00	0.394	10.00	0.394	790 036 204	0.115
RPG ONE	Tubes	10.10	0.398	10.00	0.394	790 036 222	0.114
RPG ONE	Tubes	11.00	0.433	10.00	0.394	790 036 226	0.112
RPG ONE	Tubes	12.00	0.472	10.00	0.394	790 036 205	0.112
RPG ONE	Tubes	12.10	0.476	10.00	0.394	790 036 223	0.111
RPG ONE	Tubes	12.70	0.500	10.00	0.394	790 036 206	0.111
RPG ONE	Tubes	13.50	0.531	10.00	0.394	790 036 227	0.110
RPG ONE	Tubes	14.00	0.551	10.00	0.394	790 036 228	0.108
RPG ONE	Tubes	14.10	0.555	10.00	0.394	790 036 224	0.107
RPG ONE	Tubes	15.00	0.590	10.00	0.394	790 036 216	0.107
RPG ONE	Tubes	15.60	0.614	10.00	0.394	790 036 225	0.105
RPG ONE	Tubes	15.88	0.625	10.00	0.394	790 036 211	0.105
RPG ONE	Tubes	16.00	0.630	10.00	0.394	790 036 212	0.104
RPG ONE	Tubes	17.00	0.670	10.00	0.394	790 036 221	0.103
RPG ONE	Tubes	17.20	0.677	10.00	0.394	790 036 207	0.104
RPG ONE	Tubes	18.00	0.709	10.00	0.394	790 036 217	0.102
RPG ONE	Tubes	19.05	0.750	10.00	0.394	790 036 208	0.100
RPG ONE	Tubes	20.00	0.787	10.00	0.394	790 036 230	0.096
RPG ONE	Tubes	21.30	0.839	10.00	0.394	790 036 209	0.094
RPG ONE	Tubes	21.70	0.854	10.00	0.394	790 036 220	0.093
RPG ONE	Tubes	22.00	0.866	10.00	0.394	790 036 218	0.093
RPG ONE	Tubes	23.00	0.906	10.00	0.394	790 036 219	0.085
RPG ONE	Tubes	25.00	0.984	10.00	0.394	790 036 231	0.081
RPG ONE	Tubes	25.40	1.000	10.00	0.394	790 036 210	0.083
RPG ONE	Micro fittings	6.00	0.236	4.00	0.157	790 036 304	0.066
RPG ONE	Micro fittings	6.35	0.250	4.00	0.157	790 036 301	0.066
RPG ONE	Micro fittings	8.00	0.315	4.00	0.157	790 036 307	0.065
RPG ONE	Micro fittings	9.53	0.375	4.00	0.157	790 036 302	0.064
RPG ONE	Micro fittings	10.00	0.394	4.00	0.157	790 036 305	0.065
RPG ONE	Micro fittings	12.00	0.472	4.00	0.157	790 036 306	0.064
RPG ONE	Micro fittings	12.70	0.500	4.00	0.157	790 036 303	0.062
RPG 1.5	Tubes	3.00	0.118	15.00	0.591	790 037 220	0.300
RPG 1.5	Tubes	3.18	0.125	15.00	0.591	790 037 221	0.308
RPG 1.5	Tubes	4.00	0.157	15.00	0.591	790 037 222	0.308
RPG 1.5	Tubes	4.78	0.188	15.00	0.591	790 037 223	0.308
RPG 1.5	Tubes	5.00	0.197	15.00	0.591	790 037 224	0.290
RPG 1.5	Tubes	6.00	0.236	15.00	0.591	790 037 225	0.310
RPG 1.5, RPG 2.5	Tubes	6.35	0.250	15.00	0.591	790 037 226	0.306
RPG 1.5, RPG 2.5	Tubes	7.00	0.276	15.00	0.591	790 037 257	0.306
RPG 1.5, RPG 2.5	Tubes	8.00	0.314	15.00	0.591	790 037 227	0.299
RPG 1.5, RPG 2.5	Tubes	9.00	0.354	15.00	0.591	790 037 254	0.280
RPG 1.5, RPG 2.5	Tubes	9.53	0.375	15.00	0.591	790 037 228	0.297
RPG 1.5, RPG 2.5	Tubes	10.00	0.394	15.00	0.591	790 037 229	0.298
RPG 1.5, RPG 2.5	Tubes	11.00	0.433	15.00	0.591	790 037 293	0.252
RPG 1.5, RPG 2.5	Tubes	11.11	0.437	15.00	0.591	790 037 255	0.295

Applicable with*	Applicable for	Tube OD		Tube clamping length		Code	kg
		[mm]	[inch]	[mm]	[inch]		
RPG 1.5, RPG 2.5	Tubes	12.00	0.472	15.00	0.591	790 037 230	0.293
RPG 1.5, RPG 2.5	Tubes	12.70	0.500	15.00	0.591	790 037 231	0.292
RPG 1.5, RPG 2.5	Tubes	13.00	0.512	15.00	0.591	790 037 232	0.291
RPG 1.5, RPG 2.5	Tubes	13.20	0.520	15.00	0.591	790 037 263	0.290
RPG 1.5, RPG 2.5	Tubes	13.50	0.531	15.00	0.591	790 037 233	0.290
RPG 1.5, RPG 2.5	Tubes	14.00	0.551	15.00	0.591	790 037 234	0.288
RPG 1.5, RPG 2.5	Tubes	14.30	0.563	15.00	0.591	790 037 253	0.289
RPG 1.5, RPG 2.5	Tubes	14.70	0.579	15.00	0.591	790 037 290	0.287
RPG 1.5, RPG 2.5	Tubes	15.00	0.591	15.00	0.591	790 037 235	0.286
RPG 1.5, RPG 2.5	Tubes	15.30	0.602	15.00	0.591	790 037 259	0.287
RPG 1.5, RPG 2.5	Tubes	15.70	0.618	15.00	0.591	790 037 291	0.284
RPG 1.5, RPG 2.5	Tubes	15.88	0.625	15.00	0.591	790 037 236	0.285
RPG 1.5, RPG 2.5	Tubes	16.00	0.630	15.00	0.591	790 037 237	0.282
RPG 1.5, RPG 2.5	Tubes	17.00	0.669	15.00	0.591	790 037 256	0.280
RPG 1.5, RPG 2.5	Tubes	17.08	0.672	15.00	0.591	790 037 260	0.281
RPG 1.5, RPG 2.5	Tubes	17.20	0.677	15.00	0.591	790 037 238	0.300
RPG 1.5, RPG 2.5	Tubes	18.00	0.709	15.00	0.591	790 037 239	0.280
RPG 1.5, RPG 2.5	Tubes	19.00	0.748	15.00	0.591	790 037 240	0.277
RPG 1.5, RPG 2.5	Tubes	19.05	0.750	15.00	0.591	790 037 241	0.274
RPG 1.5, RPG 2.5	Tubes	20.00	0.787	15.00	0.591	790 037 242	0.272
RPG 1.5, RPG 2.5	Tubes	21.00	0.827	15.00	0.591	790 037 294	0.270
RPG 1.5, RPG 2.5	Tubes	21.30	0.839	15.00	0.591	790 037 243	0.270
RPG 1.5, RPG 2.5	Tubes	21.70	0.854	15.00	0.591	790 037 261	0.270
RPG 1.5, RPG 2.5	Tubes	22.00	0.866	15.00	0.591	790 037 244	0.264
RPG 1.5, RPG 2.5	Tubes	22.22	0.875	15.00	0.591	790 037 292	0.270
RPG 1.5, RPG 2.5	Tubes	23.00	0.906	15.00	0.591	790 037 245	0.261
RPG 1.5, RPG 2.5	Tubes	24.00	0.945	15.00	0.591	790 037 246	0.256
RPG 1.5, RPG 2.5	Tubes	25.00	0.984	15.00	0.591	790 037 247	0.252
RPG 1.5, RPG 2.5	Tubes	25.40	1.000	15.00	0.591	790 037 248	0.240
RPG 1.5, RPG 2.5	Tubes	26.90	1.059	15.00	0.591	790 037 249	0.260
RPG 1.5, RPG 2.5	Tubes	27.00	1.063	15.00	0.591	790 037 264	0.260
RPG 1.5, RPG 2.5	Tubes	27.20	1.071	15.00	0.591	790 037 262	0.260
RPG 1.5, RPG 2.5	Tubes	28.00	1.102	15.00	0.591	790 037 250	0.238
RPG 1.5, RPG 2.5	Tubes	29.00	1.142	15.00	0.591	790 037 251	0.235
RPG 1.5, RPG 2.5	Tubes	30.00	1.181	15.00	0.591	790 037 252	0.232
RPG 1.5, RPG 2.5	Tubes	31.80	1.250	15.00	0.591	790 037 280	0.230
RPG 1.5, RPG 2.5	Tubes	32.00	1.260	15.00	0.591	790 037 258	0.226
RPG 1.5, RPG 2.5	Tubes	33.40	1.315	15.00	0.591	790 037 281	0.220
RPG 1.5, RPG 2.5	Tubes	33.70	1.327	15.00	0.591	790 037 282	0.218
RPG 1.5, RPG 2.5	Tubes	34.00	1.339	15.00	0.591	790 037 283	0.210
RPG 1.5, RPG 2.5	Tubes	35.00	1.377	15.00	0.591	790 037 284	0.210
RPG 1.5, RPG 2.5	Tubes	36.00	1.417	15.00	0.591	790 037 285	0.204
RPG 1.5, RPG 2.5	Tubes	38.00	1.496	15.00	0.591	790 037 286	0.199
RPG 1.5, RPG 2.5	Tubes	38.10	1.500	15.00	0.591	790 037 287	0.194
RPG 2.5	Tubes	40.00	1.575	15.00	0.591	790 030 234	0.565
RPG 2.5	Tubes	41.00	1.614	15.00	0.591	790 030 230	0.560
RPG 2.5	Tubes	42.00	1.654	15.00	0.591	790 030 237	0.500
RPG 2.5	Tubes	42.40	1.669	15.00	0.591	790 030 227	0.483
RPG 2.5	Tubes	42.70	1.681	15.00	0.591	790 030 224	0.483
RPG 2.5	Tubes	43.00	1.693	15.00	0.591	790 030 231	0.544
RPG 2.5	Tubes	44.50	1.752	15.00	0.591	790 030 228	0.483
RPG 2.5	Tubes	48.30	1.902	15.00	0.591	790 030 226	4.990
RPG 2.5	Tubes	50.80	2.000	15.00	0.591	790 030 220	0.483
RPG 2.5	Tubes	51.00	2.008	15.00	0.591	790 030 233	0.482
RPG 2.5	Tubes	52.00	2.047	15.00	0.591	790 030 225	0.483
RPG 2.5	Tubes	53.00	2.087	15.00	0.591	790 030 232	0.457
RPG 2.5	Tubes	54.00	2.126	15.00	0.591	790 030 221	0.452
RPG 2.5	Tubes	55.00	2.165	15.00	0.591	790 030 235	0.440
RPG 2.5	Tubes	57.00	2.244	15.00	0.591	790 030 229	0.419
RPG 2.5	Tubes	60.30	2.374	15.00	0.591	790 030 222	0.386
RPG 2.5	Tubes	63.50	2.500	15.00	0.591	790 030 223	0.350
RPG 2.5	Tubes	65.00	2.559	15.00	0.591	790 030 236	0.330
RPG 1.5	Micro fittings	3.00	0.118	4.00	0.157	790 037 300	0.241
RPG 1.5	Micro fittings	3.18	0.125	4.00	0.157	790 037 301	0.227
RPG 1.5	Micro fittings	4.00	0.157	4.00	0.157	790 037 302	0.237
RPG 1.5	Micro fittings	4.78	0.188	4.00	0.157	790 037 303	0.234
RPG 1.5	Micro fittings	5.00	0.197	4.00	0.157	790 037 304	0.228
RPG 1.5	Micro fittings	6.00	0.236	4.00	0.157	790 037 305	0.220
RPG 1.5, RPG 2.5	Micro fittings	6.35	0.250	4.00	0.157	790 037 306	0.460
RPG 1.5, RPG 2.5	Micro fittings	8.00	0.314	4.00	0.157	790 037 307	0.223

# Tube Squaring Technology

Applicable with*	Applicable for	Tube OD		Tube clamping length		Code	kg
		[mm]	[inch]	[mm]	[inch]		
RPG 1.5, RPG 2.5	Micro fittings	9.53	0.375	4.00	0.157	790 037 308	0.300
RPG 1.5, RPG 2.5	Micro fittings	10.00	0.394	4.00	0.157	790 037 309	0.222
RPG 1.5, RPG 2.5	Micro fittings	12.00	0.472	4.00	0.157	790 037 310	0.220
RPG 1.5, RPG 2.5	Micro fittings	12.50	0.492	4.00	0.157	790 037 317	0.220
RPG 1.5, RPG 2.5	Micro fittings	12.70	0.500	4.00	0.157	790 037 311	0.220
RPG 1.5, RPG 2.5	Micro fittings	17.20	0.678	4.00	0.157	790 037 312	0.220
RPG 1.5, RPG 2.5	Micro fittings	19.00	0.748	4.00	0.157	790 037 314	0.216
RPG 1.5, RPG 2.5	Micro fittings	19.05	0.750	4.00	0.157	790 037 315	0.215
RPG 1.5, RPG 2.5	Micro fittings	21.20	0.835	4.00	0.157	790 037 313	0.213
RPG 1.5, RPG 2.5	Micro fittings	21.30	0.839	4.00	0.157	790 037 318	0.212
RPG 1.5, RPG 2.5	Micro fittings	25.10	0.988	4.00	0.157	790 037 319	0.205
RPG 1.5, RPG 2.5	Micro fittings	26.90	1.059	4.00	0.157	790 037 320	0.200
RPG 1.5, RPG 2.5	Micro fittings	33.70	1.327	4.00	0.157	790 037 321	0.198
RPG 1.5, RPG 2.5	Micro fittings	34.00	1.339	4.00	0.157	790 037 316	0.195

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. 6.35 mm (0.250 inch). Supplied as standard with the RPG 2.5.

Article	Code	kg
Adapter clamping shell for RPG 2.5	790 030 094	0.150



## 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**	x	–	–	3.0 - 63.5	0.118 - 2.500	3.0 - 63.5	0.118 - 2.500
Optional tool holder WH12-I	x	–	–	12.7 - 63.5	0.500 - 2.500	12.7 - 63.5	0.500 - 2.500
Optional tool holder WH12-I for micro fittings*	x	–	–	3.0 - 21.2	0.118 - 0.835	6.35 - 21.2	0.250 - 0.835
Tool holder WH3-V-30	–	x	30°	max. 35.0	max. 1.378	max. 60.3	max. 2.374
Tool holder WH3-V-35	–	x	35°	max. 34.0	max. 1.339	max. 59.3	max. 2.335

\* Only to be used with stainless steel clamping shells for micro fittings.

\*\* Recommended application range with the standard tool holder: 3.0 - 12.7 mm (0.118 - 0.5 inch).

Article	Code	kg
Standard tool holder WH12-I	790 037 152	0.040
Optional tool holder WH12-I	790 037 154	0.050
Optional tool holder for micro fittings WH12-I*	790 037 156	0.100
Tool holder WH3-V-30	790 037 158	0.024
Tool holder WH3-V-35	790 037 159	0.024



## 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	kg
Multifunctional tool MFW-P-2	1	790 038 314	0.003
Multifunctional tool MFW-P-2	10	790 038 315	0.045

# Tube Squaring Machines

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Beveling (35°/45°) possible with a special holder
- 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 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 4.5



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

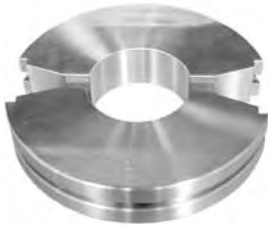
Article	Version	Code	kg
RPG 4.5	230 V, 50/60 Hz EU	790 038 001	19.400
RPG 4.5	110 V, 50/60 Hz EU	790 038 003	19.400
RPG 4.5	120 V, 50/60 Hz US	790 038 002	19.400
RPG 8.6	230 V, 50/60 Hz EU	790 039 001	20.500
RPG 8.6	110 V, 50/60 Hz EU	790 039 003	20.500
RPG 8.6	120 V, 50/60 Hz US	790 039 002	20.500

# 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).

## 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.



Stainless steel clamping shell for RPG 4.5



Aluminum clamping shell for RPG 8.6

Applicable with	Version	Tube OD [mm]	Tube OD [inch]	Code	kg
RPG 4.5	Stainless steel	12.00	0.472	790 038 454	2.170
RPG 4.5	Stainless steel	12.70	0.500	790 038 438	2.177
RPG 4.5	Stainless steel	13.00	0.512	790 038 439	2.176
RPG 4.5	Stainless steel	13.50	0.531	790 038 440	2.175
RPG 4.5	Stainless steel	14.00	0.551	790 038 441	2.174
RPG 4.5	Stainless steel	16.00	0.630	790 038 442	2.168
RPG 4.5	Stainless steel	17.20	0.677	790 038 443	2.164
RPG 4.5	Stainless steel	18.00	0.709	790 038 444	2.161
RPG 4.5	Stainless steel	19.00	0.748	790 038 445	2.150
RPG 4.5	Stainless steel	19.05	0.750	790 038 446	2.157
RPG 4.5	Stainless steel	20.00	0.787	790 038 447	2.153
RPG 4.5	Stainless steel	21.30	0.839	790 038 448	2.100
RPG 4.5	Stainless steel	22.00	0.866	790 038 449	2.144
RPG 4.5	Stainless steel	22.22	0.875	790 038 050	2.195
RPG 4.5	Stainless steel	23.00	0.906	790 038 450	2.140
RPG 4.5	Stainless steel	24.00	0.945	790 038 451	2.133
RPG 4.5	Stainless steel	25.00	0.984	790 038 452	2.127
RPG 4.5	Stainless steel	25.25	0.994	790 038 049	2.180
RPG 4.5	Stainless steel	25.40	1.000	790 038 051	2.100
RPG 4.5	Stainless steel	26.90	1.059	790 038 400	2.090
RPG 4.5	Stainless steel	27.20	1.071	790 038 468	2.165
RPG 4.5	Stainless steel	28.00	1.102	790 038 401	2.110
RPG 4.5	Stainless steel	29.00	1.142	790 038 402	2.105
RPG 4.5	Stainless steel	30.00	1.181	790 038 403	2.095
RPG 4.5	Stainless steel	31.75	1.250	790 038 052	2.090
RPG 4.5	Stainless steel	31.80	1.252	790 038 404	2.080
RPG 4.5	Stainless steel	32.00	1.260	790 038 455	2.080
RPG 4.5	Stainless steel	33.00	1.299	790 038 465	2.120
RPG 4.5	Stainless steel	33.40	1.315	790 038 405	2.040
RPG 4.5	Stainless steel	33.70	1.327	790 038 406	2.060
RPG 4.5	Stainless steel	34.00	1.339	790 038 407	2.040
RPG 4.5	Stainless steel	35.00	1.378	790 038 408	2.050
RPG 4.5	Stainless steel	36.00	1.417	790 038 409	2.044
RPG 4.5	Stainless steel	38.00	1.496	790 038 410	2.025
RPG 4.5	Stainless steel	38.10	1.500	790 038 053	2.020
RPG 4.5	Stainless steel	40.00	1.575	790 038 411	2.000
RPG 4.5	Stainless steel	41.00	1.614	790 038 412	1.990
RPG 4.5	Stainless steel	42.00	1.654	790 038 413	1.976
RPG 4.5	Stainless steel	42.16	1.660	790 038 414	1.950
RPG 4.5	Stainless steel	42.40	1.669	790 038 415	1.965
RPG 4.5	Stainless steel	42.70	1.681	790 038 416	1.950
RPG 4.5	Stainless steel	44.45	1.750	790 038 417	1.955
RPG 4.5	Stainless steel	44.50	1.752	790 038 418	1.955
RPG 4.5	Stainless steel	45.00	1.772	790 038 419	1.948
RPG 4.5	Stainless steel	48.00	1.890	790 038 464	1.960
RPG 4.5	Stainless steel	48.26	1.900	790 038 420	1.880
RPG 4.5	Stainless steel	48.30	1.902	790 038 421	1.905
RPG 4.5	Stainless steel	48.60	1.913	790 038 422	1.875
RPG 4.5	Stainless steel	50.00	1.969	790 038 456	1.880
RPG 4.5	Stainless steel	50.80	2.000	790 038 054	1.895
RPG 4.5	Stainless steel	51.00	2.008	790 038 423	1.870
RPG 4.5	Stainless steel	52.00	2.047	790 038 424	1.850
RPG 4.5	Stainless steel	53.00	2.087	790 038 425	1.835

Applicable with	Version	Tube OD [mm]	Tube OD [inch]	Code	kg
RPG 4.5	Stainless steel	54.00	2.126	790 038 426	1.827
RPG 4.5	Stainless steel	57.00	2.244	790 038 457	1.780
RPG 4.5	Stainless steel	60.00	2.362	790 038 469	1.780
RPG 4.5	Stainless steel	60.30	2.375	790 038 427	1.700
RPG 4.5	Stainless steel	60.45	2.380	790 038 428	1.726
RPG 4.5	Stainless steel	60.50	2.382	790 038 429	1.695
RPG 4.5	Stainless steel	63.00	2.480	790 038 461	1.688
RPG 4.5	Stainless steel	63.50	2.500	790 038 055	1.670
RPG 4.5	Stainless steel	65.00	2.559	790 038 463	1.700
RPG 4.5	Stainless steel	70.00	2.756	790 038 430	1.545
RPG 4.5	Stainless steel	73.03	2.875	790 038 453	1.485
RPG 4.5	Stainless steel	73.15	2.880	790 038 431	1.482
RPG 4.5	Stainless steel	75.00	2.953	790 038 462	1.443
RPG 4.5	Stainless steel	76.10	2.996	790 038 432	1.420
RPG 4.5	Stainless steel	76.20	3.000	790 038 056	1.390
RPG 4.5	Stainless steel	76.30	3.004	790 038 433	1.390
RPG 4.5	Stainless steel	80.00	3.150	790 038 466	1.390
RPG 4.5	Stainless steel	85.00	3.346	790 038 434	1.220
RPG 4.5	Stainless steel	85.90	3.382	790 038 435	1.200
RPG 4.5	Stainless steel	88.90	3.500	790 038 057	1.130
RPG 4.5	Stainless steel	89.10	3.508	790 038 436	1.100
RPG 4.5	Stainless steel	90.00	3.543	790 038 467	1.150
RPG 4.5	Stainless steel	101.60	4.000	790 038 058	0.800
RPG 4.5	Stainless steel	104.00	4.094	790 038 437	0.740
RPG 4.5	Stainless steel	108.00	4.252	790 038 458	0.620
RPG 4.5	Stainless steel	114.30	4.500	790 038 059	0.435
RPG 8.6	Aluminum	50.80	2.000	790 039 260	3.800
RPG 8.6	Aluminum	57.00	2.244	790 039 265	4.000
RPG 8.6	Aluminum	76.20	3.000	790 039 261	4.200
RPG 8.6	Aluminum	88.90	3.500	790 039 264	4.000
RPG 8.6	Aluminum	101.60	4.000	790 039 252	3.800
RPG 8.6	Aluminum	108.00	4.252	790 039 266	4.850
RPG 8.6	Aluminum	114.30	4.500	790 039 256	3.500
RPG 8.6	Aluminum	127.05	5.002	790 039 262	3.420
RPG 8.6	Aluminum	133.00	5.236	790 039 267	4.600
RPG 8.6	Aluminum	139.70	5.500	790 039 259	3.100
RPG 8.6	Aluminum	141.30	5.563	790 039 257	2.900
RPG 8.6	Aluminum	152.40	6.000	790 039 253	2.700
RPG 8.6	Aluminum	159.00	6.260	790 039 268	4.200
RPG 8.6	Aluminum	168.30	6.625	790 039 254	2.300
RPG 8.6	Aluminum	193.70	7.626	790 039 269	3.500
RPG 8.6	Aluminum	197.00	7.756	790 039 263	1.530
RPG 8.6	Aluminum	203.20	8.000	790 039 258	3.500
RPG 8.6	Aluminum	219.10	8.625	790 039 255	0.600
RPG 8.6	Stainless steel	101.60	4.000	790 039 287	5.000
RPG 8.6	Stainless steel	114.30	4.500	790 039 280	4.700
RPG 8.6	Stainless steel	141.30	5.563	790 039 281	4.500
RPG 8.6	Stainless steel	152.40	6.000	790 039 283	4.400
RPG 8.6	Stainless steel	168.30	6.625	790 039 284	4.000
RPG 8.6	Stainless steel	203.20	8.000	790 039 286	3.240
RPG 8.6	Stainless steel	219.10	8.625	790 039 285	1.500

# Tube Squaring Technology



## Tool holder WH

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

Application range	Possible application		Bevel angle
	Squaring	Beveling	[°]
Tool holder WH15-I	x	–	–
Tool holder WH12-V-45°	–	x	45
Tool holder WH12-V-35°	–	x	35

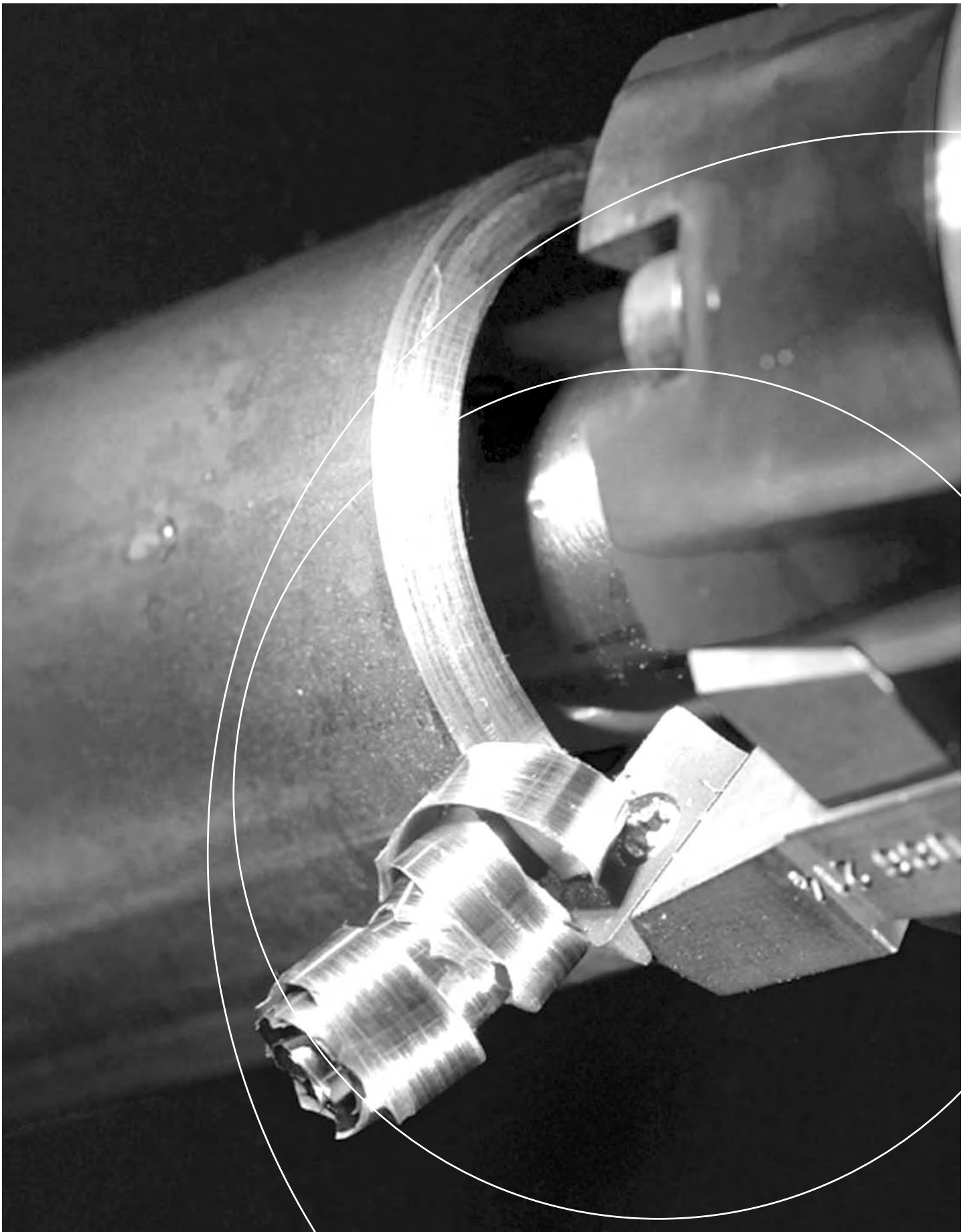
Article	Code	kg
Tool holder WH15-I	790 038 320	0.025
Tool holder WH12-V-45°	790 038 280	0.044
Tool holder WH12-V-35°	790 038 282	0.054



## 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	kg
Multifunctional tool MFW-P-2	1	790 038 314	0.003
Multifunctional tool MFW-P-2	10	790 038 315	0.045



## Pipe Beveling Technology

37

**NEW**



The clamping system "NC" with fixed wedges is ideal for applications in cramped areas (see page 43)

**NEW**



The BRB "Pneumatic/Auto" with automatic pneumatic clamping – ideal for continuous production!

**NEW**



Brush attachments, see page 48

## Boiler Pipe Preparation Machines BRB

- Fastest application with the new BRB Pneumatic/Auto by means of pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications
- Variable clamping system
- Possibility to retrofit to previous BRB models to BRB Pneumatic/Auto and to the new clamping system "NC"
- Compact design
- Precise and reproducible weld preparation
- Maximum performance and lightweight
- High-performance coated tool bits with up to 4 cutting edges
- Quick clamping system for tools with easy adjustment
- Adjustable air outlet
- Easy to change tools
- Tools adaptable on all BRB machines
- Low noise level
- Up to 3 tools can be used at the same time
- Hoist bracket
- Brush attachments prevent swarf and any other foreign materials entering the pipe (available as an optional accessory)

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.

The BRB machines are available in the following **drive versions**:

- **Electric:** 230 V, 50/60 Hz EU or 120 V, 50/60 Hz EU/US  
Electric drive with single-phase AC motor, Protection class II (double insulated), Built-in electronic variable cutting speed
- **Pneumatic:** Pneumatic power drive. Manufacturer's warranty can only be given when using the original mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 50).
- **Pneumatic/Auto:** Pneumatic multi-disc motor with additional pneumatic clamping system. Time is of the essence when installing or repairing boiler pipes, the new pneumatic clamping system greatly reduces the time to both clamp and release the machine, improving efficiency. The machine centers itself on the inside diameter of the pipe and then clamps automatically by using the toggle switch, likewise the toggle switch releases the clamping after the machining operation. This is why the BRB with automatic pneumatic clamping is ideal for continuous production e.g. boiler and heat exchanger applications.

Technical data		BRB 2			BRB 4		
		Electric	Pneumatic	Pneumatic/Auto	Electric	Pneumatic	Pneumatic/Auto
Power	[kW/HP]	0.5/0.67	0.38/0.51	0.38/0.51	1.5/2.0	1.0/1.36	1.0/1.36
Speed	[rpm]	18 - 118	0 - 120	0 - 120	12 - 37	0 - 110	0 - 110
Air supply requirement (at 6 bar)	[m³/min]	–	0.7	0.7	–	1.0	1.0

Please choose before ordering the above mentioned BRB drive version one of the following **clamping systems**:

- Standard clamping system (see page 41)
- NC clamping system (see page 43)

**All BRB machines come with:**

- 1 Boiler Pipe Preparation Machine BRB 2 or BRB 4
- 1 Durable storage and shipping case
- Tool retainer, clamping sets, mandrel, application kits (tables see pages 41 and 43).
- 1 KSS-TOP lubricant spray pump (Code 790 060 226)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

## BRB with clamping system "Standard"

BRB 4 with clamping system "NC" see page 43.

A detailed description of the machine, technical specifications and included with the machine see on page 40. Please specify the required clamping system ("Standard" or "NC"), the application kit (Kit 1 to Kit 5) as well as the drive version (Electric, Pneumatic or Pneumatic/Auto) with your purchase order.

Application range	BRB 2		BRB 4				
	Kit 1	Kit 2	Kit 1	Kit 2	Kit 3	Kit 4	Kit 5
Pipe ID (Ø clamp- ing range)	[mm] 12.75 - 25.5 [inch] 0.502 - 1.004	19.1 - 46.0 0.752 - 1.811	19.1 - 33.8 0.752 - 1.330	32.0 - 61.7 1.260 - 2.429	32.0 - 110.8 1.260 - 4.370	19.1 - 61.7 0.752 - 2.429	19.1 - 110.8 0.752 - 4.362
Tool retainer Ø	[mm] 50.0 / 12.75 [inch] 1.969 / 0.502	50.0 / 16.0 1.969 / 0.630	68.0 / 19.0 2.677 / 0.748	68.0 / 27.0 2.677 / 1.063	120.0 / 27.0 4.724 / 1.063	68.0 / 19.0 2.677 / 0.748 68.0 / 27.0 2.677 / 1.063	68.0 / 19.0 2.677 / 0.748 68.0 / 27.0 2.677 / 1.063 120.0 / 27.0 4.724 / 1.063
Clamping wedges	[Sets] 6	8	4	3	6	7	10
Mandrel Ø	[mm] 12.75 [inch] 0.502	19.05 0.750	19.05 0.750	31.5 1.240	31.5 1.240	19.05 0.750 31.5 1.240	19.05 0.750 31.5 1.240
Pipe OD	[mm] 16.75 - 41.5 [inch] 0.659 - 1.634	23.0 - 62.0 0.906 - 2.441	64.0 2.51	73.0 2.87	114.3 4.50	73.0 2.87	114.3 4.50
Wall thickness min. - max.	[mm] 2 - 8 [inch] 0.079 - 0.315	2 - 8 0.079 - 0.315	2 - 15 0.079 - 0.590	2 - 15 0.079 - 0.590	2 - 15 0.079 - 0.590	2 - 15 0.079 - 0.590	2 - 15 0.079 - 0.590
Code (230 V, 50/60 Hz)	790 085 011	790 085 012	790 086 011	790 086 012	790 086 013	790 086 014	790 086 015
Code (120 V, 50/60 Hz)	790 085 021	790 085 022	790 086 021	790 086 022	790 086 023	790 086 024	790 086 025
Code (Pneumatic)	790 085 007	790 085 008	790 086 001	790 086 002	790 086 003	790 086 004	790 086 005
Code (Pneumatic/Auto)	790 085 041	790 085 042	790 086 031	790 086 032	790 086 033	790 086 034	790 086 035

Article	Version	Clamping system	Code	kg
BRB 2 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 085 011	-
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 085 012	-
BRB 2 EL, Kit 1	120 V, 50/60 Hz EU/US	Standard	790 085 021	-
BRB 2 EL, Kit 2	120 V, 50/60 Hz EU/US	Standard	790 085 022	-
BRB 2 DL, Kit 1	Pneumatic	Standard	790 085 007	-
BRB 2 DL, Kit 2	Pneumatic	Standard	790 085 008	-
BRB 2 DL/Auto, Kit 1	Pneumatic/Auto	Standard	790 085 041	-
BRB 2 DL/Auto, Kit 2	Pneumatic/Auto	Standard	790 085 042	-
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 086 011	-
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 086 012	-
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	Standard	790 086 013	-
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	Standard	790 086 014	-
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	Standard	790 086 015	-
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	Standard	790 086 021	-
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	Standard	790 086 022	-
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	Standard	790 086 023	-
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	Standard	790 086 024	-
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	Standard	790 086 025	-
BRB 4 DL, Kit 1	Pneumatic	Standard	790 086 001	-
BRB 4 DL, Kit 2	Pneumatic	Standard	790 086 002	-
BRB 4 DL, Kit 3	Pneumatic	Standard	790 086 003	-
BRB 4 DL, Kit 4	Pneumatic	Standard	790 086 004	-
BRB 4 DL, Kit 5	Pneumatic	Standard	790 086 005	-
BRB 4 DL/Auto, Kit 1	Pneumatic/Auto	Standard	790 086 031	-
BRB 4 DL/Auto, Kit 2	Pneumatic/Auto	Standard	790 086 032	-
BRB 4 DL/Auto, Kit 3	Pneumatic/Auto	Standard	790 086 033	-
BRB 4 DL/Auto, Kit 4	Pneumatic/Auto	Standard	790 086 034	-
BRB 4 DL/Auto, Kit 5	Pneumatic/Auto	Standard	790 086 035	-

**NEW: BRB 2 Electric**

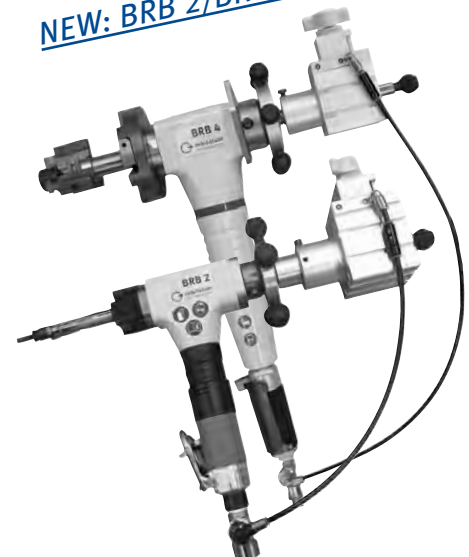


BRB 2 and BRB 4 Electric with clamping system "Standard"



BRB 2 and BRB 4 Pneumatic with clamping system "Standard"

**NEW: BRB 2/BRB 4 Auto**



BRB 2 and BRB 4 Pneumatic/Auto with clamping system "Standard"

## Retrofit kits BRB Standard "Dimension"

To extend the diameter dimension range of BRB machines.

Retrofit kits "Dimension" for BRB machines with clamping system "NC" see page 44.

Retrofit kits "Dimension" for BRB with drive version Pneumatic/Auto on request.



No.	for	Version	Code-Nr.	For retrofitting	Mandrel Ø		Tool retainer Ø		Extension of dimension to			
					[mm]	[inch]	[mm]	[inch]	Pipe ID		Pipe OD	
									[mm]	[inch]	[mm]	[inch]
01	BRB 2	Auto	790 085 016	Kit 2 to Kit 1	12.75	0.500	50.00	1.968	12.75 - 25.5	0.500 - 1.004	16.75 - 41.5	0.659 - 1.634
02	BRB 2	Pneu./EL	790 085 017	Kit 2 to Kit 1	12.75	0.500	50.00	1.968	12.75 - 25.5	0.500 - 1.004	16.75 - 41.5	0.659 - 1.634
03	BRB 2	Pneu./EL	790 085 018	Kit 1 to Kit 2	19.10	0.750	50.00	1.968	19.10 - 46.0	0.750 - 1.811	23.00 - 50.0	0.910 - 1.960
01	BRB 4	Pneu./EL	790 086 051	Kit 1 to Kit 4 / Kit 1 to Kit 2	31.50	1.240	68.0	2.677	19.1 - 61.7	0.752 - 2.429	70.0	2.756
02	BRB 4	Pneu./EL	790 086 052	Kit 1 to Kit 3	31.50	1.240	120.0	4.724	19.1 - 110.8	0.752 - 4.362	114.3	4.500
03	BRB 4	Pneu./EL	790 086 053	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
04	BRB 4	Pneu./EL	790 086 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	32.0 - 120.0	1.260 - 4.724	114.3	4.500
05	BRB 4	Pneu./EL	790 086 055	Kit 1 to Kit 5	31.50	1.240	68.0	2.677	19.1 - 120.0	0.752 - 4.724	114.3	4.500
06	BRB 4	Pneu./EL	790 086 056	Kit 3 to Kit 2	-	-	68.0	2.677	32.0 - 110.8	1.260 - 4.362	114.3	4.500

Article	Version	Code	kg
Retrofit kit BRB 2 Standard/01 "Dimension"	Kit 2 to Kit 1 (Auto)	790 085 016	1.235
Retrofit kit BRB 2 Standard/02 "Dimension"	Kit 2 to Kit 1	790 085 017	0.800
Retrofit kit BRB 2 Standard/03 "Dimension"	Kit 1 to Kit 2	790 085 018	1.235
Retrofit kit BRB 4 Standard/01 "Dimension"	Kit 1 to Kit 4 / Kit 1 to Kit 2	790 086 051	2.600
Retrofit kit BRB 4 Standard/02 "Dimension"	Kit 1 to Kit 3	790 086 052	3.700
Retrofit kit BRB 4 Standard/03 "Dimension"	Kit 2 to Kit 1 / Kit 3 to Kit 1	790 086 053	1.900
Retrofit kit BRB 4 Standard/04 "Dimension"	Kit 2 to Kit 3 / Kit 4 to Kit 5	790 086 054	1.900
Retrofit kit BRB 4 Standard/05 "Dimension"	Kit 1 to Kit 5	790 086 055	4.200
Retrofit kit BRB 4 Standard/06 "Dimension"	Kit 3 to Kit 2	790 086 056	0.700

## Retrofit kits BRB Standard "Pneumatic to Auto"

**Retrofitting to pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications.** Only for pneumatic machine versions. Easy and fast to mount.

The retrofit kit comes with: clamping cylinder complete, spindle complete and feed handle.

BRB retrofit kits for machines with clamping system "NC" see page 44.

Article	Kit	Code	kg
Retrofit kit BRB 2 Standard/01 "Pneumatic to Auto"	Kit 1	790 085 081	-
Retrofit kit BRB 2 Standard/02 "Pneumatic to Auto"	Kit 2	790 085 082	-
Retrofit kit BRB 4 Standard/01 "Pneumatic to Auto"	Kit 1	790 086 081	-
Retrofit kit BRB 4 Standard/02 "Pneumatic to Auto"	Kit 2	790 086 082	-
Retrofit kit BRB 4 Standard/03 "Pneumatic to Auto"	Kit 3	790 086 083	-
Retrofit kit BRB 4 Standard/04 "Pneumatic to Auto"	Kit 4	790 086 084	-
Retrofit kit BRB 4 Standard/05 "Pneumatic to Auto"	Kit 5	790 086 085	-

## Retrofit kits BRB "Standard to NC"

Retrofit kits BRB "Standard to NC" for BRB with drive version Pneumatic/Auto on request.

Article	Clamping range Ø [mm]	Clamping range Ø [inch]	Code	kg
Retrofit kit BRB 2/01 "Standard to NC"	19.1 - 38.0	0.752 - 1.490	790 185 083	-
Retrofit kit BRB 4/01 "Standard to NC"	19.1 - 38.0	0.752 - 1.490	790 186 071	-
Retrofit kit BRB 4/02 "Standard to NC"	35.0 - 64.0	1.378 - 2.520	790 186 072	-
Retrofit kit BRB 4/03 "Standard to NC"	35.0 - 108.0	1.378 - 4.252	790 186 073	-
Retrofit kit BRB 4/04 "Standard to NC"	19.1 - 64.0	0.752 - 2.520	790 186 074	-
Retrofit kit BRB 4/05 "Standard to NC"	19.1 - 108.0	0.752 - 4.252	790 186 075	-

## BRB with clamping system "NC"

BRB with clamping system "Standard" see page 41.

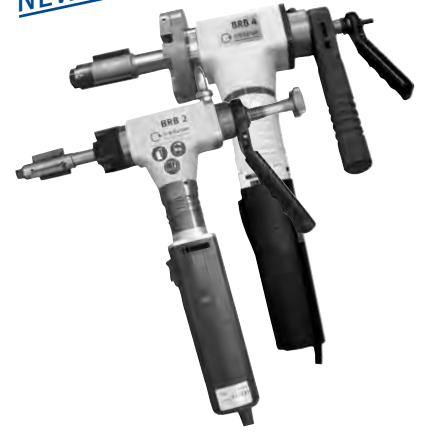
The wedges of the new clamping system "NC" are fixed to the mandrel – the ideal solution for applications where foreign particles should not access into the pipe or boiler pipe. Especially when working vertically the "NC" clamping system ensures additional safety.

A detailed description of the machine, technical specifications and included with the machine see on page 40. Please specify the required clamping system ("Standard" or "NC"), the application kit (Kit 1 to Kit 5) as well as the drive version (Electric, Pneumatic or Pneumatic/Auto) with your purchase order.

Application range	BRB 2		BRB 4				
	Kit 2	Kit 1	Kit 2	Kit 3	Kit 4	Kit 5	
Pipe ID (Ø clamp- ing range)	[mm]	19.1 - 38.0	19.1 - 38.0	35.0 - 64.0	35.0 - 108.0	19.1 - 64.0	19.1 - 108.0
	[inch]	0.752 - 1.490	0.752 - 1.490	1.378 - 2.520	1.378 - 4.252	0.752 - 2.520	0.752 - 4.252
Tool retainer Ø	[mm]	50.0 / 16.0	68.0 / 19.0	68.0 / 27.0	120.0 / 27.0	68.0 / 19.0 68.0 / 27.0	68.0 / 19.0 68.0 / 27.0 120.0 / 27.0
	[inch]	1.969 - 0.630	2.677 / 0.748	2.677 / 1.063	4.724 / 1.063	2.677 / 0.748 2.677 / 1.063	2.677 / 0.748 2.677 / 1.063 4.724 / 1.063
Clamping wedges	[Sets]	6	6	7	18 (8+10)	13	24 (14+10)
Mandrel Ø	[mm]	19.05	19.05	34.5	34.5	19.05 34.5	19.05 34.5
	[inch]	0.750	0.750	1.358	1.358	0.750 1.358	0.750 1.358
Pipe OD	[mm]	23.0 - 62.0	64.0	73.0	114.3	73.0	114.3
	[inch]	0.906 - 2.441	2.51	2.87	4.50	2.87	4.50
Wall thickness min. - max.	[mm]	2 - 8	2 - 15	2 - 15	2 - 15	2 - 15	2 - 15
	[inch]	0.079 - 0.315	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590
Code (230 V, 50/60 Hz)		790 185 012	790 186 011	790 186 012	790 186 013	790 186 014	790 186 015
Code (120 V, 50/60 Hz)		790 185 022	790 186 021	790 186 022	790 186 023	790 186 024	790 186 025
Code (Pneumatic)		790 185 002	790 186 001	790 186 002	790 186 003	790 186 004	790 186 005
Code (Pneumatic/Auto)		790 185 042	790 186 031	790 186 032	790 186 033	790 186 034	790 186 035

Article	Version	Clamping system	Code	kg
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	NC	790 185 012	-
BRB 2 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	790 185 022	-
BRB 2 DL, Kit 2	Pneumatic	NC	790 185 002	-
BRB 2 DL/Auto, Kit 2	Pneumatic/Auto	NC	790 185 042	-
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	NC	790 186 011	-
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	NC	790 186 012	-
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	NC	790 186 013	-
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	NC	790 186 014	-
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	NC	790 186 015	-
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	NC	790 186 021	-
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	790 186 022	-
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	NC	790 186 023	-
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	NC	790 186 024	-
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	NC	790 186 025	-
BRB 4 DL, Kit 1	Pneumatic	NC	790 186 001	-
BRB 4 DL, Kit 2	Pneumatic	NC	790 186 002	-
BRB 4 DL, Kit 3	Pneumatic	NC	790 186 003	-
BRB 4 DL, Kit 4	Pneumatic	NC	790 186 004	-
BRB 4 DL, Kit 5	Pneumatic	NC	790 186 005	-
BRB 4 DL/Auto, Kit 1	Pneumatic/Auto	NC	790 186 031	-
BRB 4 DL/Auto, Kit 2	Pneumatic/Auto	NC	790 186 032	-
BRB 4 DL/Auto, Kit 3	Pneumatic/Auto	NC	790 186 033	-
BRB 4 DL/Auto, Kit 4	Pneumatic/Auto	NC	790 186 034	-
BRB 4 DL/Auto, Kit 5	Pneumatic/Auto	NC	790 186 035	-

### NEW: BRB 2 Electric

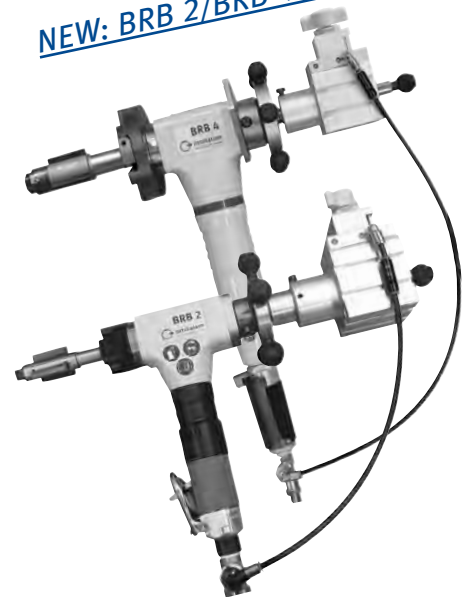


BRB 2 and BRB 4 Electric with clamping system "NC"



BRB 2 and BRB 4 Pneumatic with clamping system "NC"

### NEW: BRB 2/BRB 4 Auto



BRB 2 and BRB 4 Pneumatic/Auto with clamping system "NC"

## Retrofit kits BRB 4 NC "Dimension"

To extend the diameter dimension range of BRB 4 machines.

Retrofit kits "Dimension" for BRB machines with clamping system "Standard" see page 42.

Retrofit kits "Dimension" for BRB with drive version Pneumatic/Auto on request.

No.	Code	For retrofitting	Mandrel Ø		Tool retainer Ø		Extension of dimension to			
			Pipe ID		Pipe OD		Pipe ID		Pipe OD	
			[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
10	790 186 051	Kit 1 to Kit 4 / Kit 1 to Kit 2	34.50	1.358	68.0	2.677	19.1 - 64.0	0.752 - 2.520	70.0	2.756
11	790 186 052	Kit 1 to Kit 3	34.50	1.358	120.0	4.724	19.1 - 108.0	0.752 - 4.252	114.3	4.500
12	790 186 053	Kit 2 to Kit 1 / Kit 3 to Kit 1	19.05	0.750	68.0	2.677	19.1 - 64.0	0.752 - 2.520	70.0	2.756
13	790 186 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	35.0 - 120.0	1.378 - 4.724	114.3	4.500
14	790 186 055	Kit 1 to Kit 5	34.50	1.358	68.0 120.0	2.677 4.724	19.1 - 120.0	0.752 - 4.724	114.3	4.500
15	790 186 056	Kit 3 to Kit 2	-	-	68.0	2.677	35.0 - 108.0	1.378 - 4.252	114.3	4.500

Article	Version	Code		kg
Retrofit kit BRB 4 NC/10 "Dimension"	Kit 1 to Kit 4 / Kit 1 to Kit 2	790 186 051		-
Retrofit kit BRB 4 NC/11 "Dimension"	Kit 1 to Kit 3	790 186 052		-
Retrofit kit BRB 4 NC/12 "Dimension"	Kit 2 to Kit 1 / Kit 3 to Kit 1	790 186 053		-
Retrofit kit BRB 4 NC/13 "Dimension"	Kit 2 to Kit 3 / Kit 4 to Kit 5	790 186 054		-
Retrofit kit BRB 4 NC/14 "Dimension"	Kit 1 to Kit 5	790 186 055		-
Retrofit kit BRB 4 NC/15 "Dimension"	Kit 3 to Kit 2	790 186 056		-

## Retrofit kits BRB NC "Pneumatic to Auto"

**Retrofitting to pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications. Only for pneumatic machine versions.** Easy and fast to mount.

The retrofit kit comes with: clamping cylinder complete, spindle complete and feed handle. BRB retrofit kits for machines with clamping system "Standard" see page 42.

Article	Kit	Code		kg
Retrofit kit BRB 2 NC/03 "Pneumatic to Auto"	Kit 2	790 185 082		-
Retrofit kit BRB 4 NC/10 "Pneumatic to Auto"	Kit 1	790 186 081		-
Retrofit kit BRB 4 NC/11 "Pneumatic to Auto"	Kit 2	790 186 082		-
Retrofit kit BRB 4 NC/12 "Pneumatic to Auto"	Kit 3	790 186 083		-
Retrofit kit BRB 4 NC/13 "Pneumatic to Auto"	Kit 4	790 186 084		-
Retrofit kit BRB 4 NC/14 "Pneumatic to Auto"	Kit 5	790 186 085		-

# 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 and 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 (70.6 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 50).

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

Power: 1.2 kW (1.63 HP), Voltage: 230 V, 50/60 Hz and 120 V, 50/60 Hz  
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

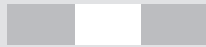
Application range*	Pipe ID		Wall thickness s		Pipe OD		
	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	
REB 6	min.	49	1.93	3	0.12	56	2.20
	max.	159	6.26	22	0.87	168	6.61
REB 14	min.	92	3.62	4	0.16	100	3.94
	max.	320	12.60	30**	1.18**	355.6	14.00
REB 20	min.	282	11.10	4	0.16	290	11.42
	max.	500	19.69	10	0.39	508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

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

\*\* Max. wall thickness with REB 14 Electric: 22 mm (0.866 inch).

Article	Version	Code	kg
REB 6	Pneumatic drive	790 093 001	32.000
REB 6	230 V, 50/60 Hz EU	790 093 002	35.000
REB 6	120 V, 50/60 Hz US	790 093 005	35.000
REB 14	Pneumatic drive	790 094 001	61.000
REB 14	230 V, 50/60 Hz EU	790 094 002	64.000
REB 14	120 V, 50/60 Hz US	790 094 005	64.000
REB 20	Pneumatic drive	790 094 010	70.000
Retrofit kit REB 14 to REB 20	Pneumatic drive	790 094 015	34.000

## The different weld prep profiles:



Facing  
I-seam



Plain beveling  
V-seam



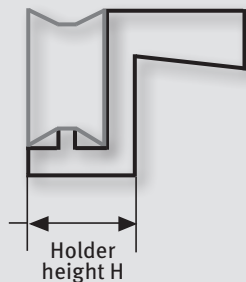
Beveling, facing  
Y-seam



J-prepping  
U-seam



Counterboring  
ID-seam



## Accessories for BRB- and REB machines

### 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	30 mm

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	30 mm

Tool holder WH for facing:

WH 30-I-H27

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

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

### Tool holder WH

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 52.

Article	Weld prep profile	Applicable with	Height [mm]	Height [inch]	Code		kg
WH5-I	I	BRB 2 / REB	10	0.394	790 085 230		0.005
WH4-I*	I	BRB 2	10	0.394	790 085 234		0.033
WH12-I	I	BRB 4	20	0.787	790 086 210		0.035
WH15-I	I	BRB 4 / REB	20	0.787	790 092 202		0.100
WH15-I	I	BRB 4 / REB	27	1.063	790 092 204		0.100
WH15-I**	I	BRB 4 / REB	16.5 - 23	0.650 - 0.906	790 093 410		0.247
WH30-I	I	REB	20	0.787	790 093 202		0.166
WH30-I	I	REB	27	1.063	790 093 204		0.235
WH5-V-30°	V/Y	BRB 2	-	-	790 085 236		0.015

Article	Weld prep profile	Applicable with	Height [mm]	Height [inch]	Code	kg
WH12-V-30°	V/Y	BRB 4	–	–	790 086 214	0.040
WH12-V-37.5°	V/Y	BRB 4	–	–	790 086 216	0.115
WH12-V-45°	V/Y	BRB 4	–	–	790 086 474	0.054
WH12-V-80°	V/Y	BRB 4 / REB	–	–	790 093 462	0.048
WH12-V-35°	V/Y	BRB 4	–	–	790 086 272	0.100
WH15-V-30°	V/Y	BRB 4 / REB	–	–	790 092 210	0.100
WH15-V-37.5°	V/Y	BRB 4 / REB	–	–	790 092 216	0.100
WH15-V-60°	V/Y	BRB 4 / REB	–	–	790 092 212	0.100
WH30-V-15°	V/Y	REB	–	–	790 093 468	0.200
WH30-V-25°	V/Y	REB	–	–	790 093 476	0.206
WH30-V-30°	V/Y	REB	–	–	790 093 210	0.192
WH30-V-32.5°	V/Y	REB	–	–	790 093 424	0.234
WH30-V-37.5°	V/Y	REB	–	–	790 093 216	0.199
WH30-V-40°	V/Y	REB	–	–	790 093 510	0.237
WH30-V-45°	V/Y	REB	–	–	790 093 404	0.204
WH5-U-20°	U	BRB 2	–	–	790 085 228	0.014
WH12-U-10°	U	BRB 4	–	–	790 086 208	0.044
WH12-U-20°	U	BRB 4	–	–	790 086 224	0.047
WH12-U-25°	U	BRB 4	–	–	790 086 212	0.051
WH30-U-5°	U	REB	–	–	790 093 509	0.210
WH30-U-7°	U	BRB 4 / REB	–	–	790 093 408	0.206
WH30-U-10°	U	BRB 4 / REB	–	–	790 093 220	0.174
WH30-U-14°	U	REB	–	–	790 093 474	0.174
WH30-U-20°	U	BRB 4 / REB	–	–	790 093 218	0.184
WH30-U-25°	U	REB	–	–	790 093 478	0.165
WH5-ID-14°, 10 mm (0.394") deep	ID	BRB 2	–	–	790 085 232	0.017
WH5-ID-14°	ID	BRB 4 / REB	–	–	790 093 406	0.139
WH5-ID-45°	ID	BRB 4	–	–	790 086 218	0.160
WH10-ID-14°	ID	BRB 4 / REB	–	–	790 093 402	0.170
WH10-ID-14°, 30 mm (1.181") deep	ID	BRB 4 / REB	–	–	790 093 466	0.155
WH12-ID-10°	ID	BRB 4 / REB	–	–	790 086 274	0.042
WH10-ID-30°	ID	BRB 4 / REB	–	–	790 093 493	0.042
WH10-ID-45°	ID	REB	–	–	790 093 494	0.107
WH10-ID-80°***	***	BRB 2 / BRB 4	–	–	790 086 275	0.075
WH5-ID-45°***	***	BRB 2 / BRB 4 / REB	–	–	790 086 218	0.155

\* Special tool holder for facing pipes in pipe plates.

\*\* Adjustable tool holder WH for I-prep. Comes with: Adjustable tool holder, Multifunctional tool MFW 15-V / I-4, Code 790 093 037, Torx screws, adjusting plates.

\*\*\* Special tool holder WH for cutting tubes from tube sheets.



Tool holder  
WH for I-prep



Tool holder WH15-I  
(adjustable) for I-prep



Tool holder WH for  
V- and Y-prep



Tool holder  
WH for U-prep



Tool holder  
WH-ID for counterboring

## Multifunctional tools MFW

Two- and/or 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.

Article	For wall thickness		Applicable with tool holder / for weld prep profile	Applicable with	Code	kg
	[mm]	[inch]				
MFW5-V / I-2	max. 6	max. 0.236	WH5-I and WH5-U-20°	BRB 2	790 085 030	0.155
MFW30-V / I-4	2 - 30	0.079-1.181	V, Y, I	REB	790 093 033	0.055
MFW30-U-4-R5	2 - 30	0.079-1.181	I-, V-, Y-, U radius 5 mm	REB	790 093 034	0.055
MFW30-U-4-R2	2 - 30	0.079-1.181	I-, V-, Y-, U radius 2 mm	REB	790 093 035	0.060
MFW30-U-4-R1	2 - 30	0.079-1.181	I-, V-, Y-, U radius 1 mm	REB	790 093 036	0.060
MFW30-U-4-R0.4	2 - 30	0.079-1.181	I-, V-, Y-, U radius 0.4 mm	REB	790 093 042	0.060
MFW4-I-2	max. 4	max. 0.157	WH4-I-2 (special holder)	BRB 2	790 085 031	0.002
MFW15-V / I-4	2 - 15	0.079-0.591	V, Y, I	BRB 4 / REB	790 093 037	0.055
MFW12-V / I-2	2 - 12	0.079-0.472	V, Y, I, U radius 1,2	BRB 4	790 086 060	0.025
MFW12-U-2-R2	2 - 12	0.079-0.472	V, Y, I, U radius 2.0	BRB 4	790 086 064	0.025
MFW5-ID-2-R0.4 (14°)	–	–	WH5-ID-14° radius 0.4 mm	BRB 4 / REB	790 093 039	0.003
MFW5-ID-2-R0.4 (45°)	–	–	WH5-ID-45° radius 0.4 mm	BRB 4 / REB	790 086 061	0.002
MFW10-ID-2-R0.4 (80°)	–	–	WH10-ID-80° radius 0.4 mm	BRB 4	790 086 062	0.002
MFW10-ID-2-R0.8 (14°)	–	–	WH10-ID-14° radius 0.8 mm	REB	790 093 038	0.002
MFW10-ID-2-R3.0 (14°)	–	–	WH10-ID-14° radius 3.0 mm	REB	790 093 041	0.004



Multifunctional Tool  
MFW15-V / I-4



Multifunctional Tool  
MFW-ID for counterboring

**NEW**



## Brush attachments

For BRB 4 machines. These new brush attachments made from brass prevent swarf and any other foreign materials entering the pipe, especially when using the machine vertically. The brushes can be mounted quickly and easily to the threaded spindle of the new BRB 4 models. The new threaded spindle can be retrofitted to machines manufactured up to October 2009. The brushes are applicable for both clamping systems (Standard/NC).

1 packaging unit = 5 brushes. Price per packaging unit.

Article	Brush adapter			Pipe ID min.-max.		Code	kg
	10	25	33	[mm]	[inch]		
Brush M8/25*	-	-	-	19.1 - 24.3	0.752 - 0.957	790 086 520	-
Brush M8/28*	-	-	-	22.1 - 27.3	0.870 - 1.075	790 086 521	-
Brush M8/31*	-	-	-	25.5 - 30.8	1.004 - 1.213	790 086 522	-
Brush M8/34*	-	-	-	28.5 - 33.8	1.122 - 1.331	790 086 523	-
Brush adapter 10	x	-	-	-	-	790 086 497	-
Brush 10/43	x	-	-	32.0 - 42.1	1.260 - 1.657	790 086 524	-
Brush 10/53	x	-	-	40.9 - 52.0	1.610 - 2.047	790 086 525	-
Brush adapter 25	-	x	-	-	-	790 086 498	-
Brush 25/62,5	-	x	-	50.7 - 61.7	1.996 - 2.429	790 086 526	-
Brush 25/71	-	x	-	59.4 - 70.4	2.339 - 2.772	790 086 527	-
Brush 25/81	-	x	-	69.2 - 80.2	2.724 - 3.157	790 086 528	-
Brush adapter 33	-	-	x	-	-	790 086 499	-
Brush 33/91	-	-	x	79.6 - 90.5	3.134 - 3.563	790 086 529	-
Brush 33/101	-	-	x	89.4 - 100.4	3.520 - 3.953	790 086 530	-
Brush 33/112	-	-	x	99.6 - 110.8	3.921 - 4.362	790 086 531	-
Custom-made brush**	-	-	-	-	-	790 086 540	-

\* Comes with the suitable adapter.

\*\* When ordering, please indicate the inside diameter of the pipe to be worked on. The brush comes with a suitable adapter.

## Initial equipment kit of brushes for BRB 4

Including all above listed adapters and brushes (1 brush of each dimension).

Article	Brush adapter			Pipe ID min.-max.		Code	kg
	10	25	33	[mm]	[inch]		
Initial equipment kit of brushes for BRB 4	x	x	x	19.1 - 110.8	0.752 - 4.362	790 086 535	-

Machines manufactured up to October 2009 can be used with brushes by upgrading with one of the following threaded spindles:

Article	Code	kg
Threaded spindle for mandrel 19.05 / BRB 4	790 086 190	0.136
Threaded spindle for mandrel 31.50 / BRB 4	790 086 160	0.100

## Hoist bracket

### Designed for use with a hoist.

BRB machines which have been manufactured up to October 2009 can be retrofitted with this hoist bracket; all new models are already equipped with the hoist bracket.



Article	Code	kg
Hoist bracket for BRB 4	790 086 310	0.270
Hoist bracket for BRB 2	790 085 310	0.185

## Heavy duty cutting heads for BRB 4 (V-prep)

The bevel heads with 3 cutting edges provide considerable advantages for heavy chip removal, e.g. for welded material. The bevel heads can be replaced like a tool mounting plate. They are available for various prep angles and can be adapted to all machines (even older models).



### Bevel head comes with:

- 3 multifunctional tools, Code 790 086 060
- 3 Torx screws
- 3 fastening screws M6x16

Article	Application range	Max. pipe wall thickness		Code	kg
		[mm]	[inch]		
Cutting head 30°	ID 36 mm to OD 78 mm (1.417 - 3.071 inch) in 3 steps of 5 mm (0.197 inch) distance	10	0.394	790 086 500	0.465
Cutting head 45°	ID 45 mm to OD 73 mm (1.772 - 2.874 inch) in 2 steps of 5 mm (0.197 inch) distance	10	0.394	790 086 459	0.515

## Heavy duty cutting heads for BRB 2 (V-/Y-prep)

### Optimized work, smoother and steadier cutting. Incl. adjustable tool holder.

The bevel heads can be replaced like a tool mounting plate. They are available for several prep angles. The bevel heads can be adapted to all machines (even older models).

### Bevel head comes with:

- 3 multifunctional tools, Code 790 086 060
- 1 multifunctional tool, Code 790 085 030
- 3 Torx screws
- 3 fastening screws M5x16

Article	Application range				Code	kg
	Kit 1 (ID min. – OD max.)		Kit 2 (ID min. – OD max.)			
	[mm]	[inch]	[mm]	[inch]		
Cutting head 30°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 380	–
Cutting head 37.5°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 381	–
Cutting head 45°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 382	–
Cutting head 30°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 383	–
Cutting head 37.5°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 384	–
Cutting head 45°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 385	–

**NEW**

## Adjustable spacer

For BRB machines. The adjustable spacer ensures a constant and repeatable depth machining of boiler pipes, etc.

Article	Code		kg
Adjustable spacer for BRB 4	790 086 045		1.285
Adjustable spacer for BRB 2	790 085 055		-

## Mobile air unit DWE 10

Lubricator and air filter adjustable pressure range 0 - 10 bar.

Flow max. 2.6 m<sup>3</sup>/min (91.8 cfm). Air inlet side: ½" clutch coupling (DIN 3481).

Air outlet side: ½" quick coupling. Suitable for air hose 790 093 061.

Article	Code		kg
Mobile air unit DWE 10	790 093 060		4.200

## Air hose with quick coupling

To connect the REB or BRB machine with the mobile air unit DWE 10.

Length: 4 m (157.5 inch). ID: 19.1 mm (0.752 inch). Air inlet side: ½" quick coupling.

Air outlet side: 90° angle screw with ½" quick coupling and a nipple to screw into the speed regulation handle on REB or BRB.

Article	Code		kg
Air hose with quick coupling	790 093 061		2.000

## 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 EU guidelines).

Fulfills DVGW requirements, regarding drinking water, work sheet W 521.

Good anti-corrosion properties.

Article	Version	Code		kg
Cutting lubrication KSS-TOP	Pump sprayer with 500 ml	790 060 226		0.630
Cutting lubrication KSS-TOP refill canister	Canister with 10 l	790 060 227		11.000

## Elbow clamping system

For REB 6. For preparing elbows with ID 75 - 157 mm (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 75 - 157 mm (2.95 - 6.18 inch).

Article	Code		kg
Elbow clamping system for REB 6 complete	790 093 015		9.900

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# Pipe Beveling Technology

## Optional clamping wedges

To extend the dimension of the REB standard machines.

Article	To utilize with	Pipe ID [mm]	Pipe ID [inch]	Code	kg
Optional clamping wedges	REB 6	155 - 166	6.102 - 6.535	790 093 295	1.300
Optional clamping wedges	REB 14	320 - 339	12.598 - 13.346	790 094 189	3.600
Optional clamping wedges	REB 14	331 - 350	13.031 - 13.780	790 094 190	3.850



## Plastic (POM) clamping shell segments

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

These clamping shell segments are especially manufactured for an individual ID of a pipe and can be utilized only for this diameter. Please specify the exact pipe ID with your order.

Comes with:

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

Other dimensions are available.

Article	To utilize with	Pipe ID [mm]	Pipe ID [inch]	Code	kg
Plastic clamping shell segments	REB 6	105 - 183	4.134 - 7.205	-	-
Plastic clamping shell segments	REB 14	150 - 375	5.906 - 14.764	-	-
Plastic clamping shell segments	REB 20	340 - 540	13.386 - 21.260	-	-



## ID tracking for REB 14 and REB 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 on the inside diameter ensures that the roller "tracks" any irregularities of the pipe, producing a weld prep exactly in accordance with the ID. Thus maintaining a perfect weld prep. 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	kg
ID tracking for REB 14 and REB 20	790 094 013	5.750



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

Code-No.	Tool holder	Torx screw	Multifunctional tool
<b>Tools for "I-seam"</b>			
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 16.5-23 mm (adjustable)	790 093 226 / 790 093 425	790 093 037 with R 0
<b>Tools for "V" and "Y-seam"</b>			
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
790 086 474	WH 12-V-45°	790 086 022	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
<b>Tools for "U-seam"</b>			
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
<b>Tools for "beveling / counterboring"</b>			
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°	790 086 217	790 086 060 with R 1.2
790 093 494	WH 10-ID-45°	790 086 219	790 093 040 with R 0.8
790 093 493	WH 10-ID-30°	790 086 219	790 093 040 with R 0.8

# 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 inch)															
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

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

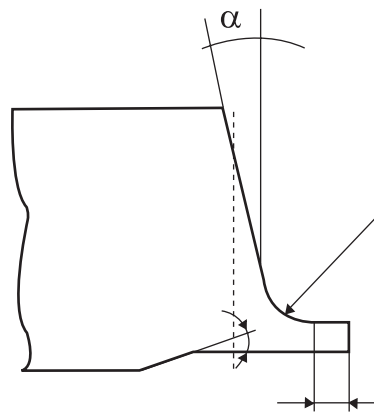
Code-No.	Description ( $\alpha$ )	MFW 12-V/1-2-R1.2 790 086 060		MFW 30-U-4-R2 790 093 035		MFW 30-U-4-R5 790 093 034	
		Length of land (X1)					
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
790 085 228	WH 5-U-20°	*	*	*	*	*	*
790 093 218	WH 30-U-2°	*	*	1.4	0.055	0	0
790 093 220	WH 30-U-10°	*	*	2.5	0.098	0.5	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 ( $\alpha$ )	MFW 12-V/1-2-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	*	*	*	*

\* Multifunctional tool not usable with tool holder

Abbreviations:  
WH = Tool holder  
MFW = Multifunctional tool



$\alpha$  / Prep Angle

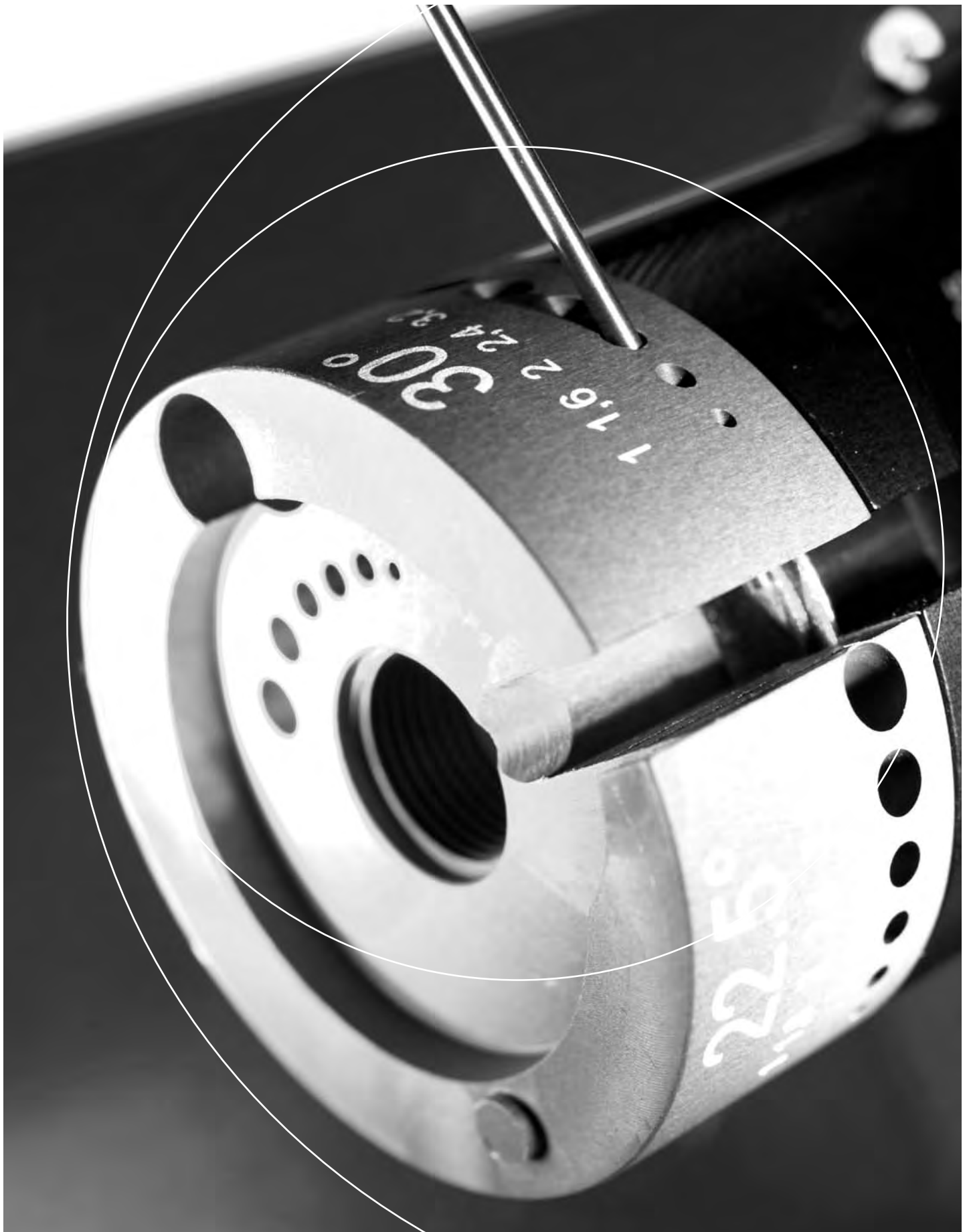
given by the angle of the tool holder WH

R / Radius

given by the radius of the multifunctional tool MFW

X1 / Length of land

from the pipe end to the beginning of the radius



## Tungsten Grinding Technology

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## 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
- Grinding angles 15°; 18°; 22.5°; 30° or 15°, 30°, 45°; 60°
- Facility for easy trimming of the electrodes (optional)
- External dust extractor can be easily adapted
- Short preparation times with high grinding performance



ESG Plus



ESG Plus<sup>2</sup>

### ESG Plus

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

#### Versions:

#### ESG Plus<sup>2</sup>

**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 Plus<sup>2</sup>
- 1 Powder-coated steel carrying case
- 1 Diamond grinding wheel (medium, Code 790 052 488)
- 1 Tool to replace the grinding wheel
- 1 Set of operating instructions and spare parts list

#### Optional for the ESG Plus<sup>2</sup>

- 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 <sup>2</sup>	
Electrode Ø [mm/inch]	1.0 / 1.6 / 2.0 / 2.4 / 3.2 / 4.0	0.040 / 1/16 / 0.080 / 3/32 / 1/8 / 5/32	
Grinding angles [°]		15 / 18 / 22.5 / 30 or 15 / 30 / 45 / 60	

Article	Version	Grinding angles [°]	Code	kg
ESG Plus	230 Volt, 50/60 Hz EU	15 / 18 / 22.5 / 30	790 052 485	3.560
ESG Plus	230 Volt, 50/60 Hz EU	15 / 30 / 45 / 60	790 052 545	3.560
ESG Plus <sup>2</sup>	230 Volt, 50/60 Hz EU	15 / 18 / 22.5 / 30	790 052 585	3.720
ESG Plus <sup>2</sup>	230 Volt, 50/60 Hz EU	15 / 30 / 45 / 60	790 052 546	3.720
ESG Plus	110 V, 50/60 Hz EU/US	15 / 18 / 22,5 / 30	790 052 486	3.560
ESG Plus	110 V, 50/60 Hz EU/US	15 / 30 / 45 / 60	790 052 645	3.560
ESG Plus <sup>2</sup>	110 V, 50/60 Hz EU/US	15 / 18 / 22.5 / 30	790 052 586	3.720
ESG Plus <sup>2</sup>	110 V, 50/60 Hz EU/US	15 / 30 / 45 / 60	790 052 646	3.720

# Accessories for ESG Plus

## Diamond grinding wheels

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

For 1.0 and 1.6 mm (0.039 and 0.063 inch) electrodes we recommend the standard grinding wheel. For 2.0 mm (0.078 inch) and larger electrodes, a medium to coarse grained grinding wheel is advisable.



Article	Version	Grinding wheel Ø [mm/inch]	s [mm/inch]	Code	kg
Diamond grinding wheel*	Standard	32.0/1.260	1.2/0.047	790 052 460	0.005
Diamond grinding wheel**	Fine	33.5/1.319	2.2/0.087	790 052 487	0.010
Diamond grinding wheel**	Medium	33.5/1.319	2.2/0.087	790 052 488	0.011
Diamond grinding wheel**	Coarse	33.5/1.319	2.2/0.087	790 052 550	0.011

\* 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	kg
Cutting device for ESG Plus	790 052 513	0.030

## Electrode holder

With clamping collet for clamping range 1.0 - 3.2 mm (0.039 - 0.126 inch), Code 790 052 481.



Article	Code	kg
Electrode holder	790 052 457	0.023

## Clamping collet

To center the electrode in the holder.

For easy grinding of smaller electrodes.

Flexible clamping collet for clamping range 1.0 - 3.2 mm (0.039 - 0.126 inch).



Article	Clamping range [mm]	Clamping range [inch]	Code	kg
Clamping collet	1.0 - 3.2	0.039 - 0.126	790 052 481	0.002



## Wall-/table-/vice-mounting plate

For stationary ESG Plus set-up.

Article	Code		kg
Wall-/table-/vice-mounting plate	790 052 483		0.102



## Protective cover

Easy to adapt on the ESG Plus head.

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

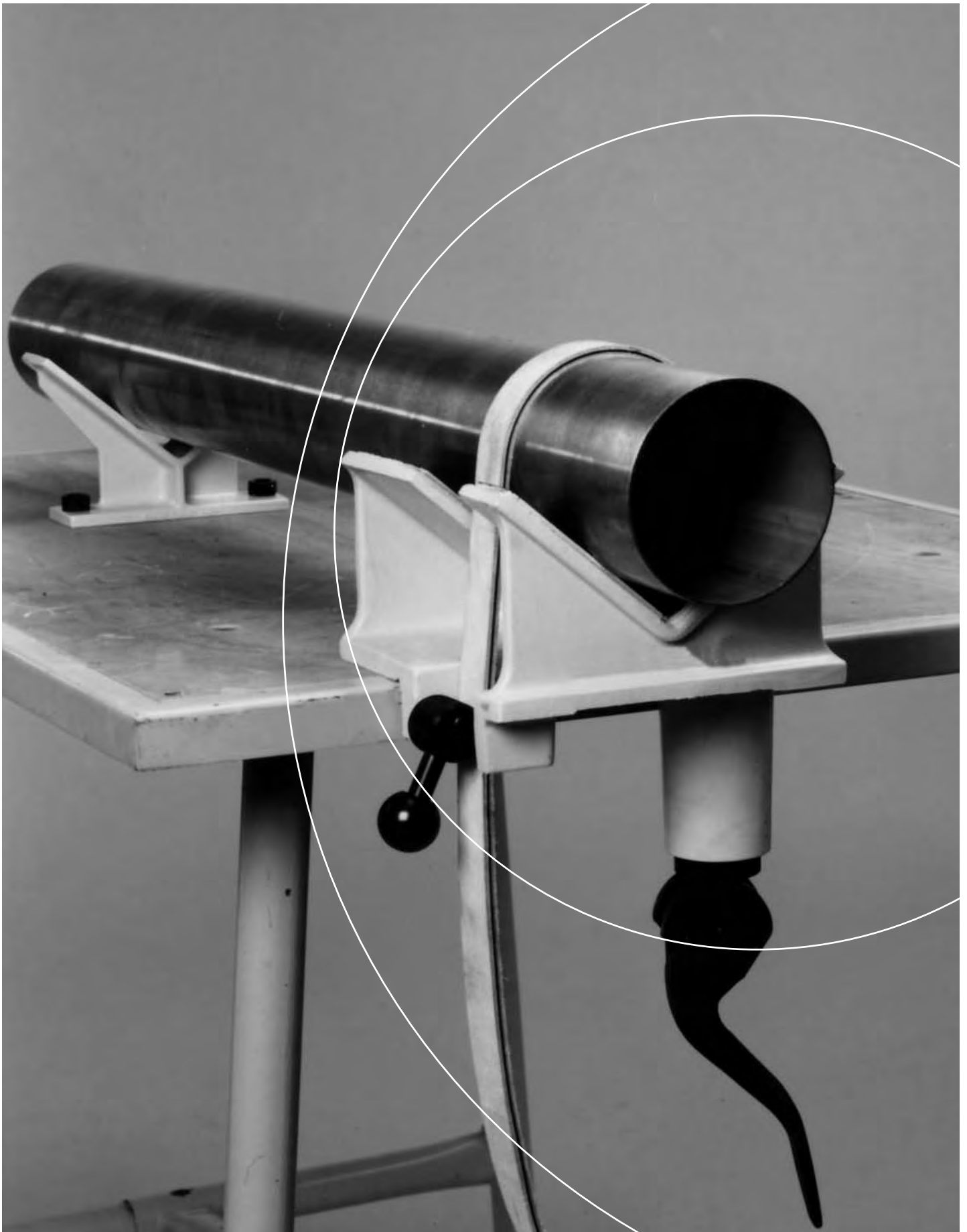
Article	Code		kg
Protective cover for ESG Plus	790 052 496		0.220
Protective cover for ESG Plus <sup>2</sup>	790 052 596		0.220



## 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	Grinding angles [°]	Code		kg
Double-Decker Kit	15 / 18 / 22,5 / 30	790 052 490		0.160
Double-Decker Kit	15 / 30 / 45 / 60	790 052 390		0.160



## Accessories for Workshop and Site

57



Work bench, small



Collapsible work bench



Tool box



Chain pipe vice



Bench vice for plastic and stainless steel pipes



Deburring tool

## Work benches, tool box, pipe vices, deburring tool

### Work benches

Dimensions	Work bench, small	Work bench, large	Collapsible work bench
[cm] (l x w x h)	120 x 75 x 85	150 x 100 x 85	100 x 70 x 85
[inch] (l x w x h)	47.24 x 29.53 x 3.346	59.06 x 39.37 x 3.346	39.37 x 27.56 x 3.346

Article	Code		kg
Work bench, small, dismantlable, with 1 tool box support	790 052 001		64.000
Work bench, large*, dismantlable, with 2 tool box supports	790 052 004		95.000
Collapsible work bench, load capacity: 650 kg/1433 lbs	790 052 030		32.000

\* while stocks last

### Tool box

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

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

Article	Code		kg
Tool box	790 052 101		50.000

### Pipe vices

Application range	Chain pipe vice	Chain pipe vice with extension roller chain	Bench vice
Pipe OD [mm]	up to 165	up to 230	20 - 250
Pipe OD [inch]	up to 6.496	up to 9.055	0.8 - 9.8

Article	Code		kg
Chain pipe vice, complete with pipe support	790 052 201		6.200
Extension roller chain	790 052 859		0.870
Bench vice for plastic and stainless steel pipes	790 052 231		5.500
Spare belt (930 x 28 mm / 36.6 x 1.1 inch) for bench vice	790 052 247		0.100

### 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		kg
Deburring tool	790 052 052		0.455



# Superior Equipment. Complete Support.

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- On-site support technicians
- Advance cost estimates at competitive rates
- On-site machine repair
- On-site operation and service training

## Repair Parts and Service

- Large inventory of spare parts and consumables
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- Large inventory of rental equipment
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- Next day service available
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- Rental purchase available

**Service hotline:  
+1.847.537.8800**

## Waste disposal / environmental protection



### Disposal of electrical (electronic) devices

(RL 2002/96/EC)

Electrical (electronic) devices which are marked with the symbol above, may not be disposed of with household waste in accordance to the EU directive 2002/96/EC. By actively using the offered return and collection systems, you actively contribute to the reuse, recycling and utilisation of electrical (electronic) devices.

Electrical (electronic) used devices contain parts which must be handled selectively according to the EU directive. Separate collection and selective treatment is the basis for environment-friendly disposal and the protection of human health.

Our products that were sold to you after August 13<sup>th</sup>, 2005 are taken back and treated according to legal standards. These products have to be sent free of charge.

The return of used devices which pose a health or safety risk for human beings due to contamination during use may be refused.

The legally compliant disposal of electrical (electronic) devices that were placed on the market before August 13<sup>th</sup>, 2005 are in the responsibility of the end-user.



### Returning of batteries

Some of our products work with batteries.

Batteries which are marked with the symbol above may not be disposed of together with household waste according to the applicable EU directive 91/157/EEC.

With batteries containing hazardous substances, the chemical symbol for the heavy metal content is indicated below the waste bin.

Cd = Cadmium

Hg = Mercury

Pb = Lead

ehwachs.com



## Contact:

### Worldwide Headquarters

E.H. Wachs  
600 Knightsbridge Parkway  
Lincolnshire, Illinois 60069

### Sales & Service

T: +1.847.537.8800  
F: +1.847.520.1147  
sales@ehwachs.com



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