

# Power.

Machines and tools  
for tube and pipe  
preparation.

# 2012 Catalog

AMERICAS

orbital

cutting.  
beveling.  
facing.  
welding.



... [ehwachs.com](http://ehwachs.com)



## Orbitalum Tools GmbH

### Setting New Standards in Orbital Cutting + Welding

Founded in 1960 as a subsidiary of Georg Fischer (+GF+) and renamed Orbitalum in 2006, Orbitalum is a highly regarded manufacturer of superior quality, long lasting tube cutting and pipe preparation machine tools including portable tube saws, tube facing machines and pipe end preparation machines. Building on decades of expertise in the field and responding to market interest in a unified equipment supplier, Orbitalum merged with Germany's Orbimatic Welding Systems in 2009, with the combined organization renamed Orbitalum Tools GmbH.

Orbitalum cutting tools and orbital welding systems are the perfect complement to each other, as a precision weld preparation is the key ingredient to a successful welding program. Orbitalum cutting and facing machines deliver a perfect prep so you can produce a perfect weld. Now offering a full range of machines from pipe and tube cutters to weld preparation tools to orbital welding equipment, all Orbitalum products are engineered and built to the most rigorous standards under ISO 9001:2008. They exhibit the excellence that German machines are famed for including high precision, robust designs, powerful drives, and ease of operation.

Precision. Power. Simplicity.

**E.H. Wachs is the North and South America distributor of Orbitalum tube cutters, weld preparation tools and orbital welding equipment manufactured in Singen, Germany. Wachs warehouses a large selection of Orbitalum machines and genuine Orbitalum parts and accessories ready for immediate shipment.**

### Genuine Parts + Factory Service

E.H. Wachs offers genuine Orbitalum replacement parts and full repair services with factory trained and certified service technicians. Our large inventory of OEM parts is designed to help keep your Orbitalum product operating at peak efficiency. It's all part of our commitment to supplying our customers with affordably priced parts and service so you can continue to enjoy Orbitalum's unrivaled productivity for years to come.



### Customer Support + Orbitalum Dealers

Orbitalum cutting and welding equipment is distributed and serviced in the Americas by Orbitalum's ITW sister company E.H. Wachs, and we're here to back you up with the expert advice and support our customers have relied on for over 125 years.

A growing network of localized Orbitalum dealers is fully trained to provide sales, service and technical support, making Orbitalum the industry's best built and supported tube cutting and facing machines with wide applications in:

#### High Purity Applications

- Semiconductor
- Electronic
- Biopharmaceutical
- Chemical
- Food, Dairy, Beverage
- Aviation, Aerospace
- HVAC

#### Industrial Applications

- Power Generation
- Boiler, Heat Exchanger
- Refineries
- Oil, Gas, Petrochemical
- Water and Gas Distribution
- Contractors
- Fabrication Shop

## Corporate Profile



Complete Solutions. One Source.

## Technology + Orbitalum Saws

Since our beginnings as a division of Georg Fischer we've strived to engineer machines that are as good as we can possibly make them, with robust construction, ergonomic designs and intuitive controls. Today we offer the best selling GF 4 and GF 6 tube saws with new anthracite colored coating for added anti-corrosion

properties, and the innovative new GFX 3.0 incorporating everything we've learned about portable cutting machines in a compact, lightweight design.



Our RA 2, RA 8 and RA 12 pipe cutting and beveling machines cover an OD range of .47" to 12.8" (12-323mm) up to a wall thickness of .39" (10mm, depending on model).

The GF and RA series utilize an advanced planetary cold cutting technology that consistently delivers a true, square cut. The

PS 4.5 and PS 6.6 saws use the same advanced cutting method but are constructed with aluminum components rather than steel making them highly portable, ideal for the contractor who travels to multiple sites in the course of a day.



## Tube Facing + Squaring

Orbitalum offers a wide range of top selling RPG series tube squaring machines, where the model number indicates the maximum OD in inches. These include the RPG One, RPG 1.5, RPG 2.5 and the larger RPG 4.5 and RPG 8.6. All Orbitalum RPG machines are electrically powered, with cordless drive offered on select models. Corded models utilize the powerful Metabo motor with VTC® (Vario Tacho Constant) speed control.



## Beveling + End Prep

The Orbitalum BRB series of boiler tube bevelers and REB series pipe end preparation machines. The BRB 2 and BRB 4 bevelers are offered in a choice of electric, pneumatic or pneumatic/auto clamping drives that, depending on configuration, will clamp a pipe ID of .5" to 4.4" (12.75-112mm).

The powerful electric and pneumatic driven REB 6 and REB 14 end preparation machines feature an integrated stand and the QTC® Quick Tool Change System for use in continuous production applications.

For additional information or to request a product demonstration contact your local Orbitalum representative, or learn more online at [ehwachs.com](http://ehwachs.com).



## Corporate Profile

# New Products



## GF 4 and GF 6 (AVM/MVM) | Pipe Cutting and Beveling Machines

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.

### Advantages:

- Anthracite-colored coated components for improved sliding properties and protection against corrosion
- Reduced operator impact by optional feed module AVM or MVM for an automated or manual cutting process

[...more on page 5](#)



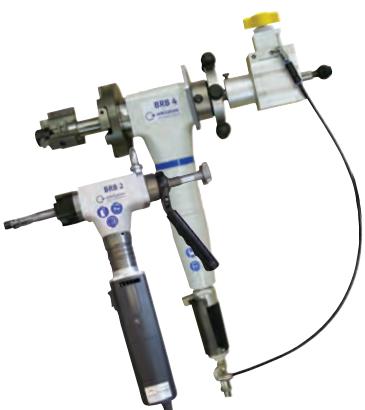
## GFX 3.0 | Pipe Cutting and Beveling Machines

New, innovative saw from Orbitalum Tools for cutting and beveling of tubes and elbows in just seconds. The perfect preparation for orbital welding!

### Advantages:

- Square, burr-free and cold machining process
- Deformation-free clamping system especially applicable for thin-walled tubes
- Easy handling through light weight
- Simultaneous or separate cutting and beveling

[...more on page 11](#)



## BRB 2 and BRB 4 | Boiler Pipe Preparation Machines

Powerful 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®.

### Advantages:

- Handy and compact design
- Precise and reproducible weld preparation
- Fast application with the BRB Pneumatic/Auto by means of pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications

[...more on page 37](#)

Subject to change. Our general terms and conditions apply.

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Order hotline: +1.847.537.8800



# Orbitalum Cutting & Beveling Products

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The GF series sets new standards in orbital tube and pipe machining.

## Pipe Cutting and Beveling Machines GF

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## 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
- Simultaneous or separate cutting and beveling
- Cost-effective, increasing productivity
- Even longer tool life

### 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. 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.

- Anthracite-colored coated components for improved sliding properties and protection against corrosion
- Stainless steel clamping attachments (Code 790 142 241) for protection against contact corrosion included
- Reduced operator impact by 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 line laser 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 (Hastelloy®, P91, etc.)
- 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**. This intelligent solution continuously controls the cutting speed depending on the torque and the parameter settings. The AVM improves the handling of the GF and RA machine and stops automatically after the cutting process. The restart inhibit does not allow an unintended start-up.

##### GF MVM\*

Pipe Cutting and Beveling Machines **with manual feed module MVM**. This manually operated feed module facilitates the cutting and beveling of pipes. With the help of a hand wheel, the machine head rotates easily and with little effort 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 790 043 018)
- 1 Set of stainless steel clamping attachments

- 1 Mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Bottle 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.

Application range	GF 4 (AVM/MVM)	GF 6 (AVM/MVM)
Pipe OD	12 - 120 mm 0.472 - 4.724 inch	21.3 - 168.3 mm 0.839 - 6.626 inch
Wall thickness (depends on material)*	1 - 9 mm 0.039 - 0.354 inch	1.5 - 15 mm 0.059 - 0.591 inch
Pipe ID min. (saw blade Ø 63 mm/Ø 2.480 inch)	21 mm 0.827 inch	30 mm 1.181 inch
Pipe ID min. (saw blade Ø 68 mm/2.677 inch)	16 mm 0.630 inch	25 mm 0.984 inch
Pipe ID min. (saw blade Ø 80 mm/3.150 inch)	4 mm 0.157 inch	13 mm 0.512 inch
Pipe ID min. (saw blade Ø 100 mm/3.937 inch)	— —	0 mm 0 inch
<b>Technical data</b>	Drive with single-phase AC motor	
Power	1.8 kW without AVM / 1.9 kW with AVM	
Built-in electronic variable cutting speed with restart inhibitor	65 - 215 rpm	65 - 215 rpm
Protection class	Double-insulated according to class II, DIN EN 60745-1 Double-insulated according to class I, DIN EN 60204-1 (GF AVM)	
Noise level at the workplace approx.	79 dB (A)	79 dB (A)
Vibration level	< 2.5 m/s <sup>2</sup> in accordance with DIN EN 28662, part 1	

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

Article	Version	Code	Weight of machine kg	Dispatch weight kg
GF 4	230 V, 50/60 Hz EU	790 142 001	61.300	88.000
GF 4	120 V, 50/60 Hz EU/US	790 142 002	61.300	88.000
GF 4 AVM	230 V, 50/60 Hz EU	790 142 011	70.500	98.000
GF 4 AVM	120 V, 50/60 Hz EU/US	790 142 012	70.500	98.000
GF 4 MVM	230 V, 50/60 Hz EU	790 142 021	66.600	98.000
GF 4 MVM	120 V, 50/60 Hz EU/US	790 142 022	66.600	98.000
GF 6	230 V, 50/60 Hz EU	790 143 001	92.700	140.000
GF 6	120 V, 50/60 Hz EU/US	790 143 002	92.700	140.000
GF 6 AVM	230 V, 50/60 Hz EU	790 143 011	101.700	153.000
GF 6 AVM	120 V, 50/60 Hz EU/US	790 143 012	101.700	153.000
GF 6 MVM	230 V, 50/60 Hz EU	790 143 021	97.800	147.000
GF 6 MVM	120 V, 50/60 Hz EU/US	790 143 022	97.800	147.000



## Pipe Cutting and Beveling Technology



Perform economical cutting and beveling with technology made by Orbitalum Tools.

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## Pipe Cutting and Beveling Machines RA

# 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 8 and RA 12

**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.**

- Reduced operator impact by optional feed module AVM or MVM for an automated or manual cutting process
- Multiple point clamping
- Fast adjustment of dimensions
- Regulated cutting speed
- Optimal tool contact
- Working direction from the inside towards the outside
- Fast tool replacement
- Optimal speed range of 65 - 215 rpm, ideal for the cutting of high-performance materials (Hastelloy®, P91, etc.)
- An ergonomically-designed motor handle for a safe and comfortable operating position
- Square, burr-free and deformation-free pipe end
- Cold machining process
- Cutting in seconds
- Simultaneous or separate cutting and beveling
- Increased productivity
- Improved cutting quality
- Increased service life of tools

Pipe Cutting and Beveling Machines **with special aluminum attachments**. Supplied as standard with RA 8 and RA 12.

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

### RA 8 AVM and RA 12 AVM

Pipe Cutting and Beveling Machines **with integrated crown wheel and automatic feed module AVM**. This intelligent solution continuously controls the cutting speed depending on the torque and the parameter settings. The AVM improves the handling of the GF and RA machine and stops automatically after the cutting process. The restart inhibit does not allow an unintended start-up.

### RA 8 MVM and RA 12 MVM

Pipe Cutting and Beveling Machines **with manual feed module MVM**. This manually operated feed module facilitates the cutting and beveling of pipes. With the help of a hand wheel, the machine head rotates easily and with little effort 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: Code 790 041 035, RA 8: Code 790 043 018, RA 12: Code 790 043 018)
- 1 Mounting plate
- 1 Tool set



RA 2



RA 8, RA 8 AVM, RA 8 MVM



RA 12, RA 12 AVM, RA 12 MVM

## Pipe Cutting and Beveling Technology

- 1 Tube of saw blade lubricant GF TOP (Code 790 060 228)
- 1 Bottle 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.

Application range	RA 2	RA 8 (AVM/MVM)	RA 12 (AVM/MVM)	
Pipe OD	[mm] 12 - 63 [inch] 0.472 - 2.480	114 - 230 4.488 - 9.055	154 - 325 6.063 - 12.795	
Wall thickness depends on material**	[mm] 1.5 - 5.5 [inch] 0.059 - 0.217	2 - 10 0.079 - 0.394	2 - 10 0.079 - 0.394	
Pipe ID min. (saw blade-Ø 63 mm/2.480 inch)	[mm] 7 [inch] 0.276	137 5.394	190 7.480	
Pipe ID min. (saw blade-Ø 68 mm/2.677 inch)	[mm] 2 [inch] 0.079	132 5.197	185 7.283	
Pipe ID min. (saw blade-Ø 80 mm/3.150 inch)	[mm] – [inch] –	120 4.724	173 6.811	
Pipe ID min. (saw blade-Ø 100 mm/3.937 inch)	[mm] – [inch] –	100 3.937	153 6.024	
Technical data	Drive with single-phase AC motor			
Dimensions (lxwxh) RA	[mm] 620 x 350 x 420 [inch] 24.4 x 13.8 x 16.5	778 x 485 x 430 30.6 x 19.1 x 16.9	940 x 592 x 374 37.0 x 23.3 x 14.7	
Dimensions (lxwxh) RA AVM	[mm] – [inch] –	918 x 485 x 430 36.1 x 19.1 x 16.9	1.070 x 592 x 374 42.1 x 23.3 x 14.7	
Dimensions (lxwxh) RA MVM	[mm] – [inch] –	788 x 485 x 430 31.0 x 19.1 x 16.9	1.090 x 592 x 374 42.9 x 23.3 x 14.7	
Power RA / RA AVM / RA MVM	[kW] 1.8 / - / -	1.8 / 1.9 / 1.8	1.8 / 1.9 / 1.8	
Power AVM	[kW] –	0.10	0.10	
Protection class	[class]	Double-insulated according to class II, DIN EN 60745-1 (RA AVM: according to class I, EN 60204-1)		
Built-in electronic speed regulation with speed stabilisation	[rpm] 65 - 215	65 - 215	65 - 215	
Vibration level in accordance with 28662, part 1	[m/s <sup>2</sup> ] < 2.5	< 2.5	< 2.5	
Noise level at the workplace approx.	[dB (A)] 79	79	79	

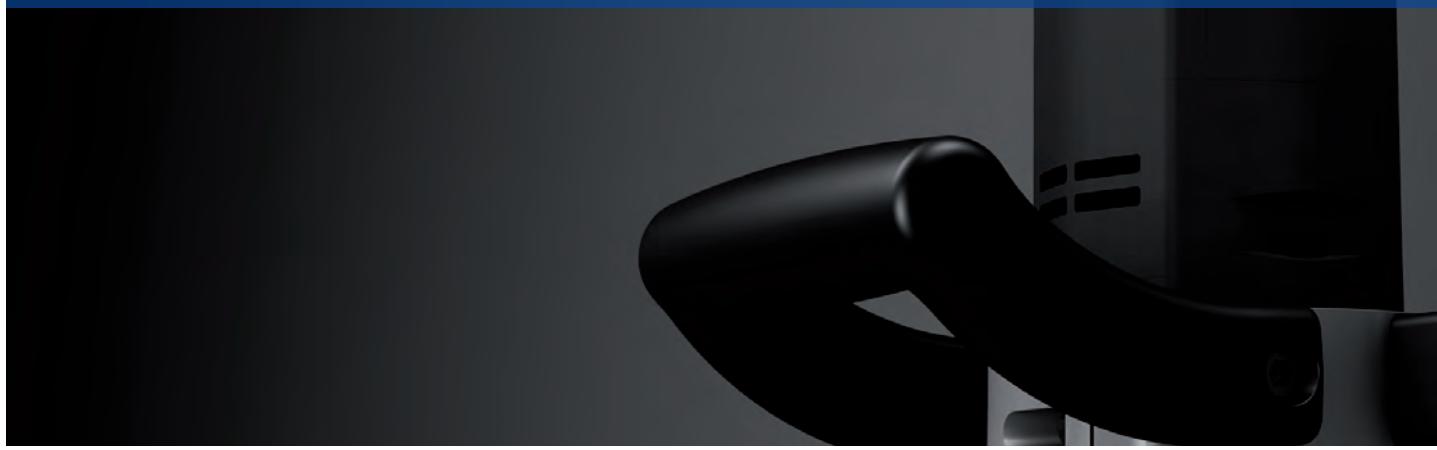
Article	Version	Code	Weight of machine kg	Dispatch weight kg
RA 2	230 V, 50/60 Hz EU	790 041 095	41.000	60.000
RA 2	120 V, 50/60 Hz EU/US	790 041 096	41.000	60.000
RA 2 INOX	230 V, 50/60 Hz EU	790 041 057	41.000	62.000
RA 2 INOX	120 V, 50/60 Hz EU/US	790 041 090	41.000	62.000
RA 8	230 V, 50/60 Hz EU	790 045 095	102.000	149.000
RA 8	120 V, 50/60 Hz EU/US	790 045 096	102.000	149.000
RA 8 AVM	230 V, 50/60 Hz EU	790 045 001	114.000	165.000
RA 8 AVM	120 V, 50/60 Hz EU/US	790 045 007	114.000	165.000
RA 8 MVM	230 V, 50/60 Hz EU	790 045 069	103.000	153.000
RA 8 MVM	120 V, 50/60 Hz EU/US	790 045 082	103.000	153.000
RA 12	230 V, 50/60 Hz EU	790 047 095	135.000	177.000
RA 12	120 V, 50/60 Hz EU/US	790 047 096	135.000	177.000
RA 12 AVM	230 V, 50/60 Hz EU	790 047 001	146.000	205.000
RA 12 AVM	120 V, 50/60 Hz EU/US	790 047 007	146.000	205.000
RA 12 MVM	230 V, 50/60 Hz EU	790 047 069	139.000	200.000
RA 12 MVM	120 V, 50/60 Hz EU/US	790 047 082	139.000	200.000

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

\*\* 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 15.



The perfect preparation for orbital welding.



Pipe Cutting and Beveling Machine GFX 3.0

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## GFX Pipe Cutting and Beveling Machines

- Square, burr-free and cold machining process
- Deformation-free clamping system especially applicable for thin-walled tubes
- Easy handling through light weight
- Simultaneous or separate cutting and beveling
- Increased productivity
- Low-maintenance and service friendly
- Environmentally friendly and long product life
- Second saw blade position to cut off elbows
- Ideal for pressfitting applications



GFX 3.0



GFX 3.0

### GFX 3.0

New, innovative saw from Orbitalum Tools for cutting and beveling of tubes and elbows in just seconds. The perfect preparation for orbital welding. Easy to use, powerful and compact saw with low weight – our new GFX 3.0 provides even more outstanding features:

- Optimized chip flow due to a new vice design
- Hardened cast iron clamping jaws
- Integrated line laser to mark the cut off point
- Ergonomically designed motor handle
- 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 for easy and quick replacement of power cables
- Directly mountable to the work bench

#### Machine comes with:

- 1 Pipe Cutting and Beveling Machine GFX 3.0
- 1 Transportation case
- 1 Saw blade (Code 790 041 035)
- 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	with tubes	with bars
Tube OD min.-max. (saw blade Ø 63 mm/2.480 inch)	6.0 - 78.0 mm 0.236 - 3.071 inch	6.0 - 16.0 mm 0.236 - 0.630 inch
Tube OD min.-max. (saw blade Ø 68 mm/2.677 inch)	6.0 - 73.0 mm 0.236 - 2.874 inch	6.0 - 21.0 mm 0.236 - 0.827 inch
Wall thickness min.-max. (saw blade Ø 63 mm/2.480 inch)	0.8 - 5.5 mm 0.032 - 0.217 inch	–
Wall thickness min.-max. (saw blade Ø 68 mm/2.677 inch)	0.8 - 7.0 mm 0.032 - 0.276 inch	–
Tube materials	Unalloyed, low-alloy and high-alloy steel, stainless steel, non-ferrous metal, aluminum alloy, titanium alloy, composite material and plastic	
Technical data	Electric drive with single-phase AC motor	
Dimensions (lxhxw)	570 x 280 x 330 mm / 22.441 x 11.024 x 12.993 inch	
Protection class	Class II	
Power	1200 W	
Built-in electronic speed regulation with speed stabilisation	30 - 200 rpm	
Vibration level in accordance with 50144	< 2.5 m/s <sup>2</sup>	

Article	Version	Code	Weight of machine kg	Dispatch weight kg
GFX 3.0	230 V, 50/60 Hz EU	790 144 001	28.500	44.000
GFX 3.0	120 V, 50/60 Hz US	790 144 002	28.500	44.000

## Accessories for GFX 3.0

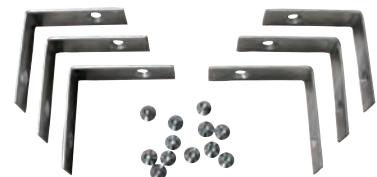
### Set of stainless steel caps

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



*Set of stainless steel caps*

### Quick-mounting base plates

With and without integrated screw clamps for quick mounting of the machine on work benches, see page 17.

### 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



*Durable storage and shipping case*



For more efficiency and easy handling in the workplace.



Our high-performance lubricants for cutting and beveling to increase the tool life of saw blades (page 16)



Clamping shells or jaws for deformation- or corrosion-free clamping of tubes (page 16)



Quick-mounting base plates – ideal for frequent changes of location (page 17)



Pipe feeder for accurately feeding long and heavy pipes into GF and RA machines (page 18)

Our Mobile Workstation for the mobile site and/or workshop (page 19):



Lockable tool box with 4 drawers



Lifting table with height adjustment



Swarf collection tray



Roller pipe support

# 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.

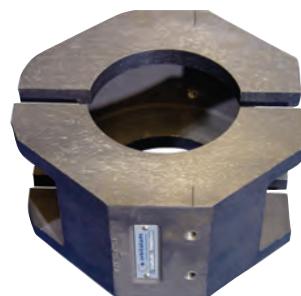
### Comes with:

- 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.



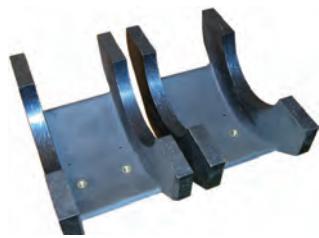
Aluminum clamping shells

Article	Version	Pipe OD [mm]	Pipe OD [inch]	Code	kg
Aluminum clamping shells	for RA 6	76.1	3.000	790 043 216	4.500
Aluminum clamping shells	for RA 6	122.5	4.823	790 043 220	3.800
Aluminum clamping shells	for RA 6	125.0	4.921	790 043 219	—
Aluminum clamping shells	for RA 6	148.5	5.846	790 043 221	3.300
Aluminum clamping shells	for RA 6	154.0	6.063	790 043 218	3.130
Aluminum clamping shells	for RA 6	177.5	6.988	790 043 222	2.600
Aluminum clamping shells	for RA 8	129.0	5.079	790 045 216	4.300
Aluminum clamping shells	for RA 8	139.1	5.476	790 045 219	4.700
Aluminum clamping shells	for RA 8	167.0	6.575	790 045 218	4.000
Aluminum clamping shells	for RA 8	168.3	6.626	790 045 220	3.600
Aluminum clamping shells	for RA 8	210.0	8.268	790 045 217	2.900
Aluminum clamping shells	for RA 8	219.1	8.626	790 045 222	—
Aluminum clamping shells	for RA 12	204.0	8.030	790 047 222	—
Aluminum clamping shells	for RA 12	209.0	8.230	790 047 221	11.500
Aluminum clamping shells	for RA 12	219.0	8.620	790 047 220	11.200
Aluminum clamping shells	for RA 12	254.0	10.000	790 047 216	9.200
Aluminum clamping shells	for RA 12	273.0	10.750	790 047 219	8.400
Aluminum clamping shells	for RA 12	300.0	11.810	790 047 224	9.100
Aluminum clamping shells	for RA 12	324.0	12.760	790 047 218	6.100
Aluminum clamping shells	for RA 12	306.0	12.047	790 047 225	5.800

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

For deformation-free clamping of thin-walled tubes.

Further clamping shells are available for various outer diameters.



Aluminum clamping shells  
for GF 4 and RA 41 Plus

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

# Pipe Cutting and Beveling Technology



Special stainless steel clamping jaws



Set of stainless steel clamping attachments



GF TOP



GF LUB



Special gear oil

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

In pairs. Retrofit. While stock last.

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

## Set of stainless steel clamping attachments

For GF 4 and GF 6 (AVM/MVM). For protection against contact erosion.  
Standard part of the GF 4 and the GF 6 (AVM/MVM).

Article	Version	Code	kg
Set of stainless steel clamping attachments for GF 4	right + left	790 142 241	0.510
Set of stainless steel clamping attachments for GF 6	right + left	790 143 200	0.510

## Continuous cooling system

On request for GF 4, GF 6, RA 8 and RA 12 available.

## 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

## 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, 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.



Intermediate gearbox retrofit kit

Article	Code	kg
Intermediate gearbox retrofit kit	790 041 063	2.000

## 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	4/13.1	790 142 081	0.560
Swivel cable complete	120 V, 50/60 Hz US/CA	4/13.1	790 142 082	0.560
Swivel cable complete	230 V, 50/60 Hz CH	4/13.1	790 142 083	0.560
Swivel cable complete	230 V, 50/60 Hz AU	4/13.1	790 142 084	0.560
Swivel cable complete	120 V, 50/60 Hz GB	4/13.1	790 142 087	0.560
Swivel cable	230 V, 50/60 Hz EU	4/13.1	790 142 076	0.560
Swivel cable	120 V, 50/60 Hz US/CA	4/13.1	790 142 077	0.560
Swivel cable	230 V, 50/60 Hz CH	4/13.1	790 142 078	0.560
Swivel cable	120 V, 50/60 Hz GB	4/13.1	790 142 079	0.560
Swivel cable	230 V, 50/60 Hz AU	4/13.1	790 142 080	0.560



Swivel cable



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 plate without screw clamps

## 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



Quick-mounting base plates with integrated screw clamps

# Pipe Cutting and Beveling Technology

## 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.

### Advantages:

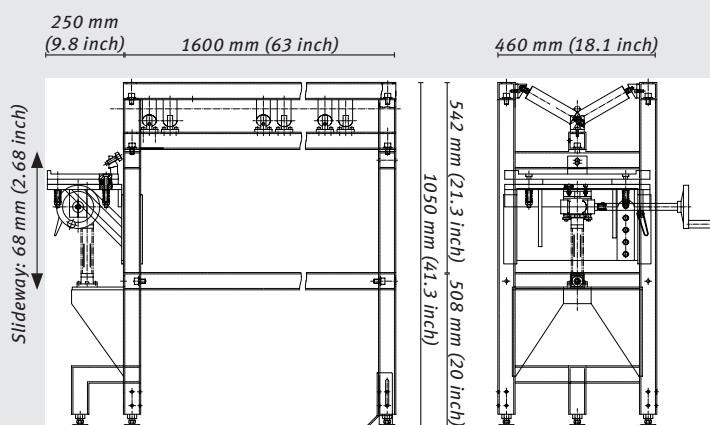
- Extremely stable and sturdy
- Fast adjustment of dimensions
- Centerline of tubes and pipes adjust easily in seconds
- Steel frame coated for maintenancefree finish
- Rollers made of stainless steel
- Extension of the Pipe Feeder possible with Extension Unit
- Saves time and money
- No contamination
- Perfect for all kinds of steel

### 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, GFX 3.0, PS 4.5 and PS 6.6 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.



Pipe feeder base unit

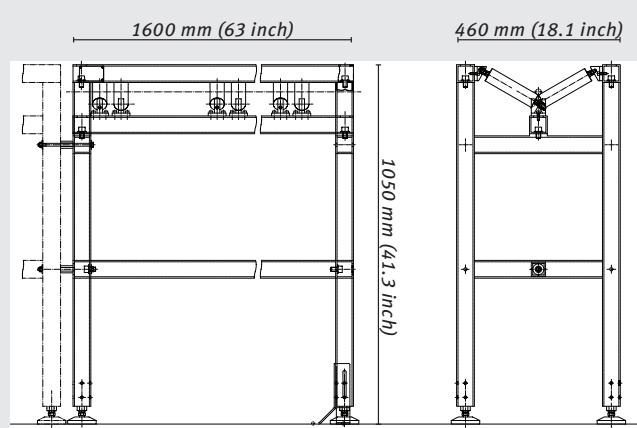


### Extension unit:

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



Pipe feeder extension unit



**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 data	Pipe feeder base unit	Pipe feeder extension unit
Pipe OD	16 - 325 mm 0.63 - 12.8 inch	16 - 325 mm 0.63 - 12.8 inch
Dimensions approx.	185 x 105 x 50 cm 72.8 x 41.3 x 19.7 inch	approx. 160 x 105 x 50 62.9 x 41.3 x 19.7 inch
Load capacity max.	400 kg 881.8 lbs	400 kg 881.8 lbs
Height-adjustable mounting plate (adjusting range)	68 mm 2.68 inch	– –
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 GF 20 AVM. RA 2, GFX 3.0, PS 4.5 and PS 6.6 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



*Mobile Workstation*

Technical data	Mobile Workstation	
Dimensions (hxlwx)	91 x 115 x 43 cm 35.8 x 45.3 x 16.9 inch	
Load capacity max.	675 kg 1488.1 lbs	
Article	Code	kg
Mobile Workstation	790 068 071	137.000



For highest requirements and longest service life.



Saw blades and bevel cutters for GF and RA machines

## 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

Version	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	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
Economy*	5.0 - 12.0	.197 -.472	80	2.953	790 043 030		0.053
Economy*	6.0 - 15.0	.236 -.591	100	3.937	790 047 030		0.117
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 - 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



Saw blade Economy



Saw blade Performance



Saw blade High-Performance



Saw blade Premium



Saw blade with additional borehole



Weld-prep saw blade/bevel cutter combinations (V-prep)

## Saw blades

Saw blades with additional borehole. Minimum purchase: 5 blades

Version	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 combinations (V-prep)\*

Version	Pipe wall thickness		Beveling angle	Height of bevel max.	Saw blade Ø	Code		kg
	[mm]	[inch]						
Performance	1.2 - 3.0	.047 - .118	30	3	.118	63	2.480	790 044 050
Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 161
High-Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 015
High-Performance	2.5 - 6.0	.098 - .236	45	4	.236	68	2.677	790 042 023
High-Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 013

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

Article	Version	Code		kg
Saw blade for 790 044 050	Performance	790 044 040		0.027
Bevel cutter 30° for 790 044 050	Performance	790 044 049		0.065
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\*\*

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



Press fitting saw blade/bevel cutter combination

# Pipe Cutting and Beveling Technology

## 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-prep 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-prep

Version	Beveling angle [°]	Height of bevel max.		Bevel cutter Ø		Code		kg
		[mm]	[inch]	[mm]	[inch]			
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
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).



Bevel cutter V-prep

## 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



GF TOP

## 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



GF LUB

# Pipe Cutting and Beveling Technology



Tube cutting made easy.

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## Portable Tube Saws PS

## 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 line laser to identify the cut-off point
- Orbital cutting process saves time
- Multi-point clamping of the tube
- Fast adjustment of tube dimensions
- Long saw blade service life
- Press fitting saw blade combinations can be used\*

### 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 system 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

Application range	PS 4.5	PS 6.6
Tube OD	6 - 120 mm 0.236 - 4.724 inch	50** - 170 mm 1.969** - 6.693 inch
Elbow OD	30 - 120 mm 1.181 - 4.724 inch	50** - 170 mm 1.969** - 6.693 inch
Wall thickness max.	< 3 mm < 0.118 inch	< 3 mm < 0.118 inch
Technical data	<b>Electric drive (single-phase AC motor)</b>	
Dimensions	480 x 230 x 600 mm 20.9 x 9.1 x 23.6 inch	480 x 230 x 660 mm 20.9 x 9.1 x 26 inch
Power	1100 W 1.5 hp	1100 W 1.5 hp
Protection class	Protection isolated class II, DIN VDE 0740	
Speed	30 - 165 rpm	30 - 165 rpm
Vibration level (EN 28662, part 1)	< 2.5 m/s <sup>2</sup>	< 2.5 m/s <sup>2</sup>
Noise level at the workplace	approx. 78 dB (A)	approx. 78 dB (A)

\* Only with saw blade/bevel cutter 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.



PS 4.5



PS 6.6

Article	Version	Code	Weight of machine kg	Dispatch weight kg
PS 4.5	230 V, 50/60 Hz EU	790 048 001	23.600	37.000
PS 4.5	110 V, 50/60 Hz EU	790 048 002	23.600	37.000
PS 4.5	120 V, 50/60 Hz US	790 048 003	23.600	37.000
PS 6.6	230 V, 50/60 Hz EU	790 049 001	26.300	41.000
PS 6.6	110 V, 50/60 Hz EU	790 049 002	26.300	41.000
PS 6.6	120 V, 50/60 Hz US	790 049 003	26.300	41.000

## Pipe Cutting and Beveling Technology

## Accessories for PS machines



Quick-mounting plate with screw clamps



Saw blade Performance



Tripod



Clamping jaws replacement set



Laser retrofitting kit

### Quick-mounting plate with screw clamps

**Quick and easy mounting of the machine to the bench with no drilling.**

Including 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.

Version	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	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 tube.**

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



Manual cutting of metal tubes in any position.

## Metal Tube Cutter MRA

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## 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

### MRA

For manual cutting of metal tubes in any position.

Easy to use – first-rate cutting technology.

The patented cutting technique used in designing the MRA is based on the diameter-specific clamping shells and the flexible multi-roller cutting chain. Both these components are made of hardened, wear resistant steel and provide the following advantages:

- Long service life of the components
- The cutting chain is at a right-angle around the tube
- The MRA runs on track rollers on the clamping shells
- Minimum hand movements
- Tubes made of stainless steel can be cut

#### For tube 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	MRA
Tube OD	33.7 - 254.0 mm 1.327 - 10.000 inch
Wall thickness (depends on material)*	0.8 - 3.0 mm 0.031 - 0.118 inch
<b>Technical data</b>	
Dimensions	450 x 105 mm 17.7 x 4.1 inch

\* for high-alloy steels, the max. wall thickness which can be processed is 2.0 - 2.5 mm (0.08 - 0.09 inch).

Article	Code	Weight of machine kg	Dispatch weight kg
Metal Tube Cutter MRA	790 008 001	3.100	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 for MRA	33.7 - 114.3	1.330 - 4.500	15	790 008 018		0.500
Multi-roller cutting chain for MRA	114.3 - 254.0	4.500 - 10.000	16	790 008 041		0.900



Multi-roller cutting chain

## 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 on request.

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



Clamping shells



The required, high-quality tube end preparation for orbital welding.



## Tube Squaring Machines RPG ONE, 1.5, 2.5 (Cordless)

# Tube Squaring Machines

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Beveling possible with a special tool 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)



RPG ONE



RPG ONE Cordless



RPG 1.5



RPG 1.5 Cordless



RPG 2.5



RPG 2.5 Cordless

## 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).

Application range	RPG ONE	RPG ONE cordless	RPG 1.5	RPG 1.5 cordless	RPG 2.5	RPG 2.5 cordless
Tube OD min.-max.	3.0 - 25.4 mm 0.118 - 1.0 inch	3.0 - 25.4 mm 0.118 - 1.0 inch	3.0 - 38.1 mm 0.118 - 1.5 inch	3.0 - 38.1 mm 0.118 - 1.5 inch	6.35* - 63.5 mm 0.25* - 2.5 inch	6.35* - 63.5 mm 0.25* - 2.5 inch
Wall thickness max.	3.0 mm 0.118 inch	3.0 mm 0.118 inch	3.0 mm 0.118 inch	3.0 mm 0.118 inch	3.0 mm 0.118 inch	3.0 mm 0.118 inch
Tube materials	High-alloy steels (stainless steel material no. 1.40... to 1.45... as per DIN 17 455 and DIN 17 456), unalloyed and low-alloy steels, aluminum.					
<b>Technical data</b>						
Dimensions (lxhxd)	390 x 200 x 70 15.4 x 7.9 x 2.8	261 x 255 x 80 10.3 x 10 x 3.2	400 x 350 x 160 15.8 x 13.8 x 6.3	275 x 255 x 90 10.8 x 10 x 3.5	500 x 300 x 170 19.7 x 11.8 x 6.7	260 x 300 x 320 10.2 x 11.8 x 12.6

# Tube Squaring Technology

Built-in electronic variable cutting speed	145 - 380 rpm	0 - 400 rpm	145 - 380 rpm	0 - 400 rpm	1. speed: 9 - 2 rpm 2. speed: 27 - 153 rpm	1. speed: 0 - 24 rpm 2. speed: 0 - 83 rpm
Power	1100 W	-	1100 W	-	1100 W	-
Voltage of rechargeable battery	-	18 V	-	18 V	-	18 V
Capacity	-	2.6 Ah	-	2.6 Ah	-	2.6 Ah

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

Article	Version	Code	Weight of machine kg	Dispatch weight kg
RPG ONE	230 V, 50/60 Hz EU	790 036 031	4.140	9.600
RPG ONE	120 V, 50/60 Hz US	790 036 032	4.140	9.600
RPG ONE	110 V, 50/60 Hz EU	790 036 033	4.140	9.600
RPG ONE Cordless (18 V)	230 V, 50/60 Hz EU	790 036 021	2.880	8.200
RPG ONE Cordless (18 V)	115 V, 60 Hz US	790 036 022	2.880	8.200
RPG 1.5	230 V, 50/60 Hz EU	790 037 001	3.880	9.500
RPG 1.5	120 V, 50/60 Hz US	790 037 002	3.880	9.500
RPG 1.5	110 V, 50/60 Hz EU	790 037 003	3.880	9.500
RPG 1.5 Cordless (18 V)	230 V, 50/60 Hz EU	790 037 011	3.440	10.100
RPG 1.5 Cordless (18 V)	115 V, 60 Hz US	790 037 012	3.440	10.100
RPG 2.5	230 V, 50/60 Hz EU	790 030 001	6.600	12.500
RPG 2.5	120 V, 50/60 Hz US	790 030 002	6.600	12.500
RPG 2.5	110 V, 50/60 Hz EU	790 030 003	6.600	12.500
RPG 2.5 Cordless (18 V)	230 V, 50/60 Hz EU	790 030 011	5.340	11.320
RPG 2.5 Cordless (18 V)	110 V, 60 Hz US	790 030 012	5.340	11.320



Angle drive

### 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.

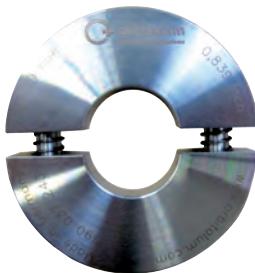
Article	Code	kg
Angle drive for RPG ONE and RPG 1.5 (cordless)	790 037 400	0.475

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

Please check the outer diameter of the tubes before ordering the clamping shells.

### 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.

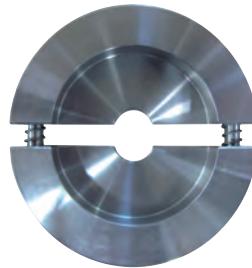


One-piece stainless steel clamping shell

Applicable with	Applicable for	Tube OD		Tube clamping length		Code		kg
		[mm]	[inch]	[mm]	[inch]			
RPG ONE	Tubes	3.175	0.125	10.0076	0.394	790 036 201		.2 lbs
RPG ONE	Tubes	6.35	0.250	10.0076	0.394	790 036 202		.2 lbs
RPG ONE	Tubes	7.9502	0.313	10.0076	0.394	790 036 215		.2 lbs
RPG ONE	Tubes	9.525	0.375	10.0076	0.394	790 036 203		.2 lbs
RPG ONE	Tubes	12.7	0.500	10.0076	0.394	790 036 206		.2 lbs
RPG ONE	Tubes	15.875	0.625	10.0076	0.394	790 036 211		.2 lbs
RPG ONE	Tubes	19.05	0.750	10.0076	0.394	790 036 208		.2 lbs
RPG ONE	Tubes	25.4	1.000	10.0076	0.394	790 036 210		.2 lbs
RPG ONE	Microfittings	6.35	0.250	3.9878	0.157	790 036 301		.2 lbs
RPG ONE	Microfittings	7.9502	0.313	3.9878	0.157	790 036 307		.2 lbs
RPG ONE	Microfittings	9.525	0.375	3.9878	0.157	790 036 302		.2 lbs
RPG ONE	Microfittings	12.7	0.500	3.9878	0.157	790 036 303		.2 lbs

## Tube Squaring Technology

Applicable with	Applicable for	Tube OD		Tube clamping length		Code	kg
		[mm]	[inch]	[mm]	[inch]		
RPG ONE	Microfittings	12.7	0.500	3.9878	0.157	790 036 303	.2 lbs
RPG 1.5	Tubes	3.175	0.125	15.0114	0.591	790 037 221	.6 lbs
RPG 1.5	Microfittings	3.175	0.125	3.9878	0.157	790 037 301	.4 lbs
RPG 1.5 & 2.5	Tubes	6.35	0.250	15.0114	0.591	790 037 226	.6 lbs
RPG 1.5 & 2.5	Tubes	7.9502	0.313	15.0114	0.591	790 037 227	.6 lbs
RPG 1.5 & 2.5	Tubes	9.525	0.375	15.0114	0.591	790 037 228	.6 lbs
RPG 1.5 & 2.5	Tubes	12.7	0.500	15.0114	0.591	790 037 231	.6 lbs
RPG 1.5 & 2.5	Tubes	15.875	0.625	15.0114	0.591	790 037 236	.6 lbs
RPG 1.5 & 2.5	Tubes	19.05	0.750	15.0114	0.591	790 037 241	.6 lbs
RPG 1.5 & 2.5	Tubes	25.4	1.000	15.0114	0.591	790 037 248	.6 lbs
RPG 1.5 & 2.5	Tubes	38.1	1.500	15.0114	0.591	790 037 287	.6 lbs
RPG 1.5 & 2.5	Microfittings	6.35	0.250	3.9878	0.157	790 037 306	.4 lbs
RPG 1.5 & 2.5	Microfittings	7.9502	0.313	3.9878	0.157	790 037 307	.4 lbs
RPG 1.5 & 2.5	Microfittings	9.525	0.375	3.9878	0.157	790 037 308	.4 lbs
RPG 1.5 & 2.5	Microfittings	12.7	0.500	3.9878	0.157	790 037 311	.4 lbs
RPG 1.5 & 2.5	Microfittings	19.05	0.750	3.9878	0.157	790 037 315	.4 lbs
RPG 2.5	Tubes	50.8	2.000	15.0114	0.591	790 030 220	.8 lbs
RPG 2.5	Tubes	63.5	2.500	15.0114	0.591	790 030 223	.7 lbs
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



One-piece stainless steel clamping shell for micro fittings

### 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



Adapter clamping shell



Tool holder WH

Application range	Possible application		Beveling angle	Tube OD			
	Squaring	Beveling		RPG ONE (cordless)	RPG 1.5 (cordless)	RPG 2.5 (cordless)	[mm]
WH12-**	x	-	-	3.0 - 25.4	0.118 - 1.0	3.0 - 38.1	0.118 - 1.5
WH12-I (optional)	x	-	-	12.7 - 25.4	0.5 - 1.0	12.7 - 38.1	0.5 - 1.5
WH12-I (micro fittings)*	x	-	-	-	-	3.0 - 21.3	0.118 - 0.84
WH3-V-30	-	x	30°	-	-	max. 35.0	max. 1.378
WH3-V-35	-	x	35°	-	-	max. 34.0	max. 1.339
WH3-V-45	-	x	45°	-	-	max. 33.7	max. 1.327

Article	Code	kg
Torx Fixing crew	790 086 220	
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
Tool holder WH3-V-45	790 037 157	0.022

\* 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).

### Multifunctional tool MFW

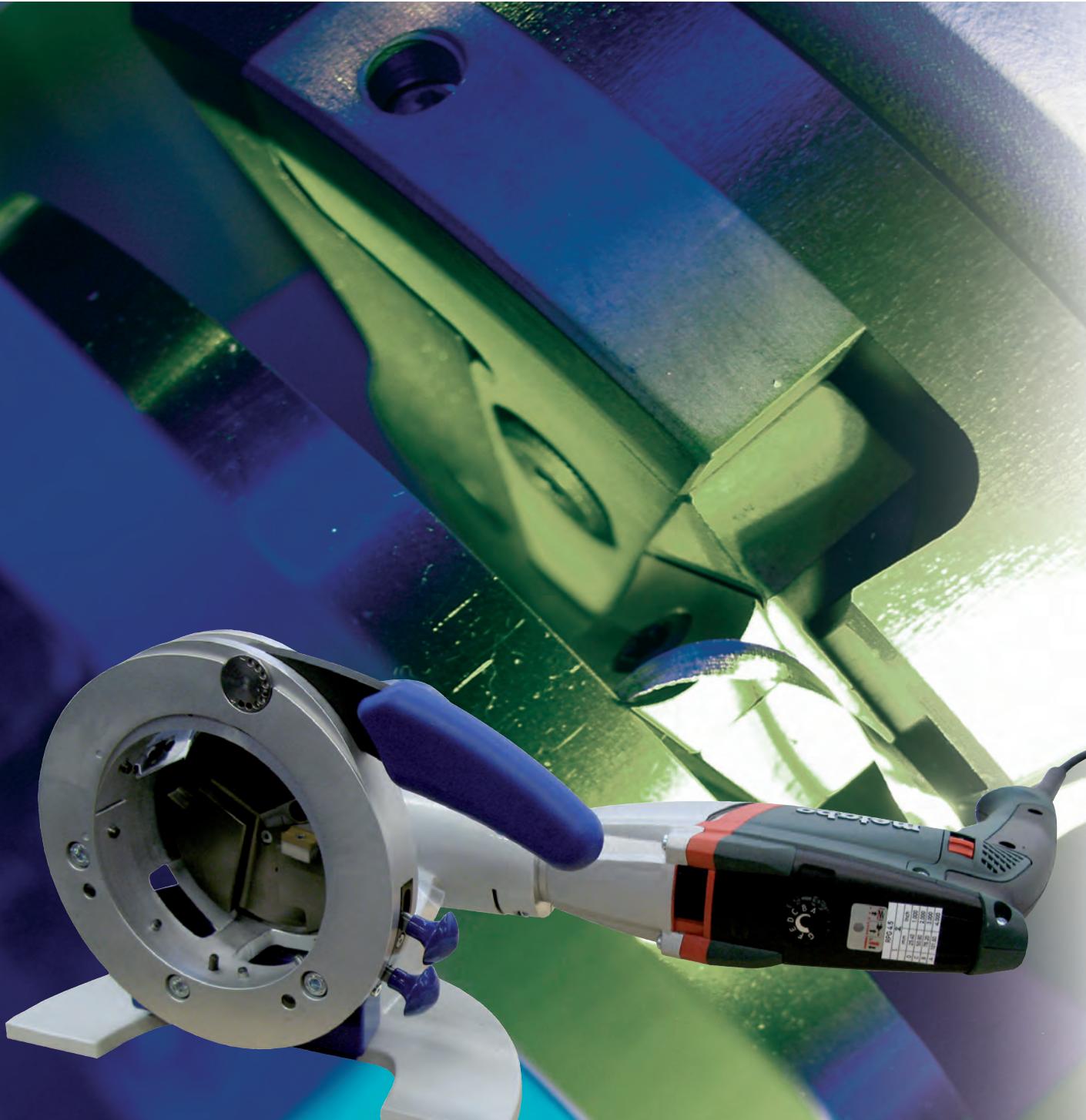
Two-sided tool bit with high-performance Balinit® Futura protective coating against tool wear. Usable for all machines of the RPG series.

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



Multifunctional tool MFW

## Tube Squaring Technology



The clean and high-value solution for specific welding preparations.

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## Tube Squaring Machines RPG 4.5, RPG 8.6

# Tube Squaring Machines

- Squaring tube ends with a high-quality finish
- Burr-free and square
- Beveling possible with a special tool 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.



RPG 4.5



RPG 8.6

### Machine comes with:

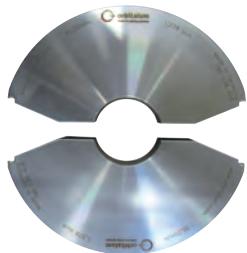
- 1 Tube Squaring Machine RPG 4.5 or RPG 8.6
- 1 Durable storage and shipping case
- 1 Tool holder (Code 790 038 320) with multifunctional tool (Code 790 038 314)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

Application range	RPG 4.5	RPG 8.6
Tube OD	12.7 - 114.3 mm 0.5 - 4.5 inch	50.8 - 219.1 mm 2 - 8.6 inch
Wall thickness max.	3.0 mm 0.118 inch	3.6 mm 0.142 inch
Tube materials	High-alloy steels, unalloyed and low-alloy steels and aluminum. Others on request.	
Technical data	Electric drive with single-phase AC motor	
Dimensions (including motor)	525 x 256 x 226 mm 20.7 x 10 x 8.9 inch	630 x 390 x 340 mm 24.8 x 15.4 x 13.4 inch
Power	1100 W	1100 W
Protection class	II	II
Built-in electronic variable cutting speed	8 - 52 min <sup>-1</sup>	7 - 18 min <sup>-1</sup>
Vibration level according to EN 28662, Part 1	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>
Noise level at the workplace	Idle running approx. 83 dB (A)	

Article	Version	Code	Weight of machine kg	Dispatch weight kg
RPG 4.5	230 V, 50/60 Hz EU	790 038 001	10.500	19.400
RPG 4.5	110 V, 50/60 Hz EU	790 038 003	10.500	19.400
RPG 4.5	120 V, 50/60 Hz US	790 038 002	10.500	19.400
RPG 8.6	230 V, 50/60 Hz EU	790 039 001	20.500	32.000
RPG 8.6	110 V, 50/60 Hz EU	790 039 003	20.500	32.000
RPG 8.6	120 V, 50/60 Hz US	790 039 002	20.500	32.000

## Accessories for RPG 4.5, RPG 8.6

*Please check the outer diameter of the tubes before ordering the clamping shells.*



Clamping shells for RPG 4.5



Aluminum clamping shells for RPG 8.6



Tool holder WH



Multifunctional tool MFW

### 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.

Applicable with	Shell Material	Application	Tube OD [mm]	Tube OD [in]	Code	Weight
RPG 4.5	Stainless Steel	Tube	12.7	0.500	790 038 438	5 lbs
RPG 4.5	Stainless Steel	Tube	19.05	0.750	790 038 446	5 lbs
RPG 4.5	Stainless Steel	Tube	25.4	1.000	790 038 051	5 lbs
RPG 4.5	Stainless Steel	Tube	38.1	1.500	790 038 053	4.5 lbs
RPG 4.5	Stainless Steel	Tube	50.8	2.000	790 038 054	4 lbs
RPG 4.5	Stainless Steel	Tube	63.5	2.500	790 038 055	4 lbs
RPG 4.5	Stainless Steel	Tube	76.2	3.000	790 038 056	3.5 lbs
RPG 4.5	Stainless Steel	Tube	101.6	4.000	790 038 058	2 lbs
RPG 4.5	Stainless Steel	Pipe	33.401	1.315	790 038 405	5 lbs
RPG 4.5	Stainless Steel	Pipe	42.164	1.660	790 038 414	4.5 lbs
RPG 4.5	Stainless Steel	Pipe	48.26	1.900	790 038 420	4 lbs
RPG 4.5	Stainless Steel	Pipe	60.325	2.375	790 038 427	4 lbs
RPG 4.5	Stainless Steel	Pipe	73.025	2.875	790 038 453	3.5 lbs
RPG 4.5	Stainless Steel	Pipe	88.9	3.500	790 038 057	3 lbs
RPG 4.5	Stainless Steel	Pipe	114.3	4.500	790 038 059	1.5 lbs
RPG 8.6	Aluminum	Tube	50.8	2.000	790 039 260	8 lbs
RPG 8.6	Aluminum	Tube	76.2	3.000	790 039 261	8 lbs
RPG 8.6	Aluminum	Tube	101.6	4.000	790 039 252	8 lbs
RPG 8.6	Aluminum	Tube	152.4	6.000	790 039 253	6 lbs
RPG 8.6	Aluminum	Tube	203.2	8.000	790 039 258	5 lbs
RPG 8.6	Stainless Steel	Tube	101.6	4.000	790 039 287	12 lbs
RPG 8.6	Stainless Steel	Tube	152.4	6.000	790 039 283	10 lbs
RPG 8.6	Stainless Steel	Tube	203.2	8.000	790 039 286	7 lbs
RPG 8.6	Aluminum	Pipe	88.9	3.500	790 039 264	9 lbs
RPG 8.6	Aluminum	Pipe	114.3	4.500	790 039 256	8 lbs
RPG 8.6	Aluminum	Pipe	168.275	6.625	790 039 254	6 lbs
RPG 8.6	Aluminum	Pipe	219.075	8.625	790 039 255	3 lbs
RPG 8.6	Stainless Steel	Pipe	114.3	4.500	790 039 280	12 lbs
RPG 8.6	Stainless Steel	Pipe	168.275	6.625	790 039 284	10 lbs
RPG 8.6	Stainless Steel	Pipe	219.075	8.625	790 039 285	5 lbs

### Tool holder WH

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

Application range	Possible application		Beveling angle [°]
	Squaring	Beveling	
Tool holder WH15-I	x	–	–
Tool holder WH12-V-45°	–	x	45
Tool holder WH12-V-35°	–	x	35
Tool holder WH12-U-20°	–	x	20

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
Tool holder WH12-U-20°	790 038 326	0.031

### 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



Powerful and robust boiler pipe preparation machine.

## Boiler Pipe Preparation Machines BRB

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## Boiler Pipe Preparation Machines BRB

- Handy and compact design
- Precise and reproducible weld preparation
- Fast application with the BRB Pneumatic/Auto by means of pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications
- High 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
- Possibility to retrofit to previous BRB models to BRB Pneumatic/Auto and to the new clamping system "NC"
- Up to 3 tools can be used at the same time

**Powerful 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 a mobile air unit. We recommend the 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 Electric	BRB 2 Pneumatic	BRB 2 Pneu/Auto	BRB 4 Electric	BRB 4 Pneumatic	BRB 4 Pneu/Auto
Power	0.5 kW	0.38 kW	0.38 kW	1.5 kW	1.0 kW	1.0 kW
Speed	18 - 118 rpm	0 - 120 rpm	0 - 120 rpm	12 - 37 rpm	0 - 110 rpm	0 - 110 rpm
Air supply requirement (at 6 bar)	–	0.7 m³/min	0.7 m³/min	–	1.0 m³/min	1.0 m³/min
Noise level LAeq 1 m (EN 23741), approx.	76 dB (A)	82 dB (A)	82 dB (A)	82 dB (A)	84 dB (A)	84 dB (A)
Vibration level (EN 28662, part 1)	2.5 m/s²	2.5 m/s²	2.5 m/s²	2.5 m/s²	2.5 m/s²	2.5 m/s²

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

- Standard clamping system (see page 39)
- NC clamping system (see page 41)

**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, mandrels, application kits (tables see page 39 and page 41).
- 1 KSS-TOP lubricant spray pump KSS-TOP (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 41.

A detailed description of the machine, technical specifications and scope of delivery see on page 38. 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 rangee	BRB 2		BRB 4				
	Kit 1	Kit 2	Kit 1	Kit 2	Kit 3	Kit 4	Kit 5
Pipe ID (Ø [mm])	12.75 - 25.5	19.1 - 46.0	19.1 - 33.8	32.0 - 61.7	32.0 - 110.8	19.1 - 61.7	19.1 - 110.8
clamping range [inch]	0.502 - 1.004	0.752 - 1.811	0.752 - 1.330	1.260 - 2.429	1.260 - 4.370	0.752 - 2.429	0.752 - 4.362
Tool retainer Ø [mm]	50.0 / 12.75	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 / 27.0	120.0 / 27.0
	[inch]	1.969 / 0.502	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 / 1.063
Clamping wedges	[Sets]	6	8	4	3	6	7
Mandrel Ø [mm]	12.75	19.05	19.05	31.5	31.5	19.05	19.05
	[inch]	0.502	0.750	0.750	1.240	1.240	0.750
Pipe OD [mm]	16.75 - 41.5	23.0 - 62.0	64.0	73.0	114.3	73.0	114.3
	[inch]	0.659 - 1.634	0.906 - 2.441	2.51	2.87	4.50	2.87
Wall thickness* [mm]	2 - 8	2 - 8	2 - 15	2 - 15	2 - 15	2 - 15	2 - 15
min. - max. [inch]	0.079 - 0.315	0.079 - 0.315	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590

\* depending on pipe material and dimension

Article	Version	Clamping system	Code	Weight of machine kg	Dispatch weight kg
BRB 2 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 085 011		12.200
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 085 012		12.000
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 Pneumatic, Kit 1	Pneumatic	Standard	790 085 007		11.900
BRB 2 Pneumatic, Kit 2	Pneumatic	Standard	790 085 008		12.300
BRB 2 Pneu/Auto, Kit 1	Pneumatic/Auto	Standard	790 085 041		13.300
BRB 2 Pneu/Auto, Kit 2	Pneumatic/Auto	Standard	790 085 042		13.500
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 086 011		15.000
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 086 012		16.000
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	Standard	790 086 013		22.800
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	Standard	790 086 014		18.000
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	Standard	790 086 015		19.000
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	Standard	790 086 021		15.000
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	Standard	790 086 022		16.000
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	Standard	790 086 023		18.500
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	Standard	790 086 024		18.000
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	Standard	790 086 025		19.000
BRB 4 Pneumatic, Kit 1	Pneumatic	Standard	790 086 001		14.000
BRB 4 Pneumatic, Kit 2	Pneumatic	Standard	790 086 002		15.000
BRB 4 Pneumatic, Kit 3	Pneumatic	Standard	790 086 003		17.000
BRB 4 Pneumatic, Kit 4	Pneumatic	Standard	790 086 004		16.600
BRB 4 Pneumatic, Kit 5	Pneumatic	Standard	790 086 005		23.700
BRB 4 Pneu/Auto, Kit 1	Pneumatic/Auto	Standard	790 086 031		
BRB 4 Pneu/Auto, Kit 2	Pneumatic/Auto	Standard	790 086 032		
BRB 4 Pneu/Auto, Kit 3	Pneumatic/Auto	Standard	790 086 033		
BRB 4 Pneu/Auto, Kit 4	Pneumatic/Auto	Standard	790 086 034		
BRB 4 Pneu/Auto, Kit 5	Pneumatic/Auto	Standard	790 086 035		24.500



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



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



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



Retrofit kit BRB Standard "Dimension"

## 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 42.

Retrofit kits "Dimension" for BRB 4 with drive version Pneumatic/Auto on request.

No.	for	Version	Code-No.	For retrofitting	Mandrel Ø		Tool retainer Ø	Extension of dimension to				
					[mm] [inch]			[mm] [inch]		Pipe ID		
					[mm]	[inch]		[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 42.

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		Code	kg
	[mm]	[inch]		
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 4 with clamping system “NC”

BRB with clamping system “Standard” see page 39.

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 scope of delivery see on page 39. 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 rangee	BRB 2	BRB 4				
		Kit 2	Kit 1	Kit 2	Kit 3	Kit 4
Pipe ID (Ø clamping range) [mm] [inch]	19.1 - 38.0 0.752 - 1.490	19.1 - 38.0 0.752 - 1.490	35.0 - 64.0 1.378 - 2.520	35.0 - 108.0 1.378 - 4.252	19.1 - 64.0 0.752 - 2.520	19.1 - 108.0 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
Clamping wedges	[Sets]	6	6	7	18 (8+10)	13
Mandrel Ø	[mm]	19.05	19.05	34.5	34.5	19.05 34.5
	[inch]	0.750	0.750	1.358	1.358	0.750 1.358
Pipe OD	[mm]	23.0 - 62.0	64.0	73.0	114.3	73.0
	[inch]	0.906 - 2.441	2.51	2.87	4.50	2.87
Wall thickness*	[mm]	2 - 8	2 - 15	2 - 15	2 - 15	2 - 15
min. - max.	[inch]	0.079 - 0.315	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590

\* depending on pipe material and dimension



**BRB 2 and BRB 4 Electric with clamping system “NC”**



**BRB 2 and BRB 4 Pneumatic with clamping system “NC”**

Article	Version	Clamping system	Code	Weight of machine kg	Dispatch weight kg
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	NC	<b>790 185 012</b>		13.000
BRB 2 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	<b>790 185 022</b>		13.000
BRB 2 Pneumatic, Kit 2	Pneumatic	NC	<b>790 185 002</b>		12.500
BRB 2 Pneu/Auto, Kit 2	Pneumatic/Auto	NC	<b>790 185 042</b>		13.800
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	NC	<b>790 186 011</b>		
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	NC	<b>790 186 012</b>		
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	NC	<b>790 186 013</b>		23.300
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	NC	<b>790 186 014</b>		25.200
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	NC	<b>790 186 015</b>		26.400
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	NC	<b>790 186 021</b>		
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	<b>790 186 022</b>		
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	NC	<b>790 186 023</b>		
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	NC	<b>790 186 024</b>		
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	NC	<b>790 186 025</b>		26.000
BRB 4 Pneumatic, Kit 1	Pneumatic	NC	<b>790 186 001</b>		19.500
BRB 4 Pneumatic, Kit 2	Pneumatic	NC	<b>790 186 002</b>		
BRB 4 Pneumatic, Kit 3	Pneumatic	NC	<b>790 186 003</b>		22.200
BRB 4 Pneumatic, Kit 4	Pneumatic	NC	<b>790 186 004</b>		
BRB 4 Pneumatic, Kit 5	Pneumatic	NC	<b>790 186 005</b>		25.500
BRB 4 Pneu/Auto, Kit 1	Pneumatic/Auto	NC	<b>790 186 031</b>		
BRB 4 Pneu/Auto, Kit 2	Pneumatic/Auto	NC	<b>790 186 032</b>		
BRB 4 Pneu/Auto, Kit 3	Pneumatic/Auto	NC	<b>790 186 033</b>		23.400
BRB 4 Pneu/Auto, Kit 4	Pneumatic/Auto	NC	<b>790 186 034</b>		
BRB 4 Pneu/Auto, Kit 5	Pneumatic/Auto	NC	<b>790 186 035</b>		26.000



**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 4 machines with clamping system "Standard" see page 39. Retrofit kits "Dimension" for BRB with drive version Pneumatic/Auto on request.

No.	Code-No.	For retrofitting	Mandrel Ø		Tool retainer Ø		Extension of dimension to			
			[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 40.

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 Beveling Technology

## 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. Weight per brush attachment.

Further dimensions on request.



*Brush attachment*

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		—

\* 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*

## 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



*Bevel cutter head for BRB 2*

## Bevel cutter head for BRB 2 (V-/Y-prep)

**Optimized work, smoother and steadier cutting. Including adjustable tool holder.**

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

**Comes with:**

- 3 multifunctional tools (MFW-12-V/I-2, Code 790 086 060)
- 1 multifunctional tool (MFW5-U/I-2, Code 790 085 030)
- 4 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]						
Bevel cutter head 30°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 380		–			
Bevel cutter head 37.5°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 381		–			
Bevel cutter head 45°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 382		–			
Bevel cutter head 30°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 383		–			
Bevel cutter head 37.5°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 384		–			
Bevel cutter head 45°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 385		–			

## Bevel cutter head for BRB 4 (V-prep)

**The bevel cutter heads with 3 cutting edges provide considerable advantages for heavy chip removal, e.g. for welded material.** The bevel cutter 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).

**Comes with:**

- 3 multifunctional tools: MFW-12-V/I-2, Code 790 086 060  
MFW-P-2, Code 790 038 314 on request
- 3 Torx screws
- 3 fastening screws M6x16

Article	Application range	Pipe wall thickness max.		Code		kg
		[mm]	[inch]			
Bevel cutter 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
Bevel cutter 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

## Adjustable spacer

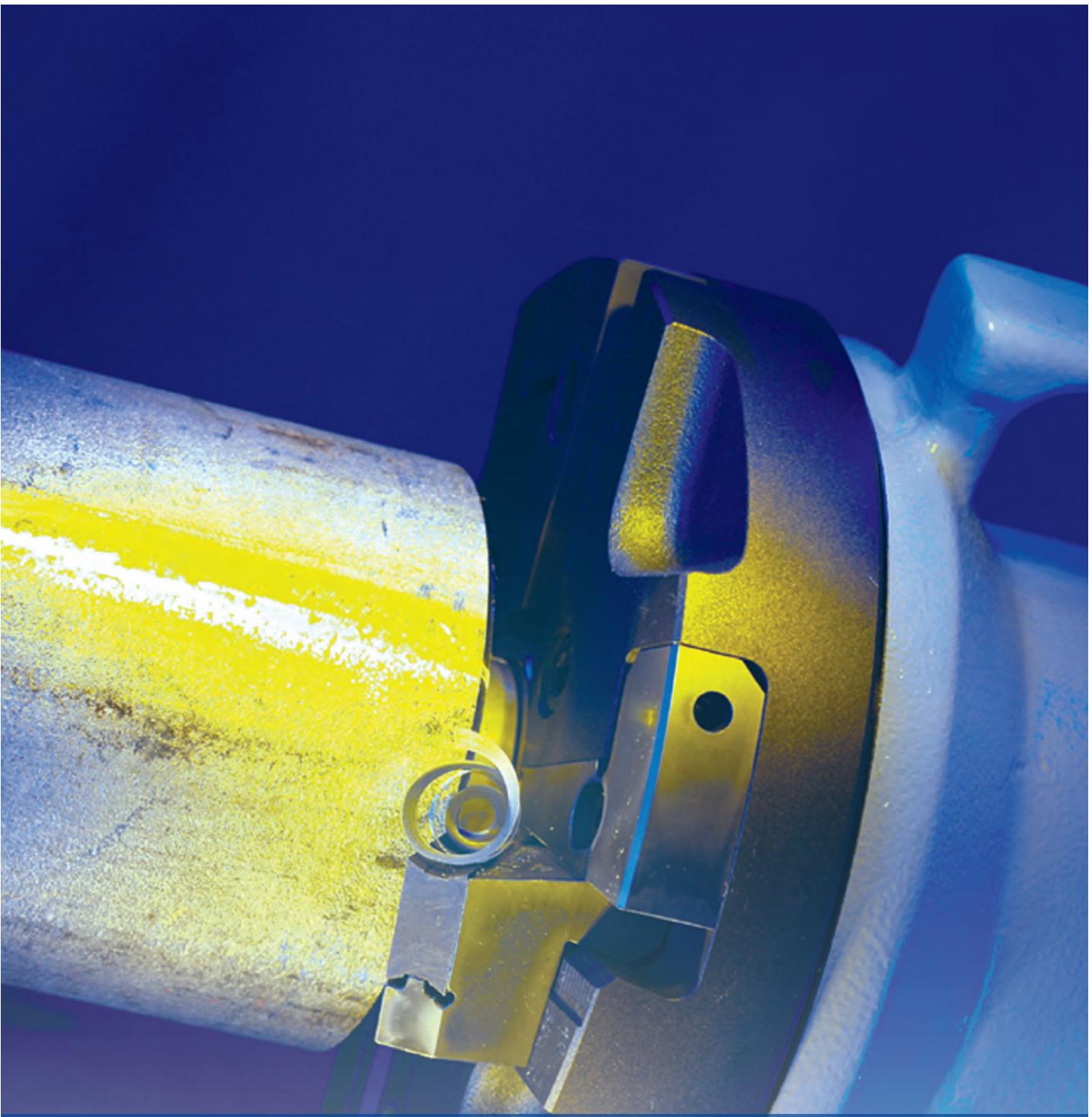
**For BRB machines.** The adjustable spacer ensures a constant and repeatable depth machining of boiler pipes, etc.

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



*Adjustable spacer*

# Pipe Beveling Technology



The powerful pipe end preparation solution.

## Pipe End Preparation Machines REB

45



*REB 6 Electric*



*REB 14 Pneumatic*



*REB 20 Pneumatic*

## 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 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 KSS-TOP (Code 790 060 226)
- 1 Set of operating instructions and spare parts list

Manufacturer's warranty can only be given when using a mobile air unit. We recommend the mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 50).

Application range*	REB 6 Pneumatic	REB 6 Electric	REB 14 Pneumatic	REB 14 Electric	REB 20 Pneumatic
Pipe ID	49 - 159 mm 1.93 - 6.26 inch	49 - 159 mm 1.93 - 6.26 inch	92 - 320 mm 3.62 - 12.60 inch	92 - 320 mm 3.62 - 12.60 inch	282 - 500 mm 11.10 - 19.69 inch
Wall thickness	3 - 22 mm 0.12 - 0.87 inch	3 - 22 mm 0.12 - 0.87 inch	4 - 30 mm 0.16 - 1.18 inch	4 - 22 mm 0.16 - 0.87 inch	4 - 10 mm 0.16 - 0.39 inch
Pipe OD	56 - 168 mm 2.20 - 6.61 inch	56 - 168 mm 2.20 - 6.61 inch	100 - 355.6 mm 3.94 - 14.00 inch	100 - 355.6 mm 3.94 - 14.00 inch	290 - 508 mm 11.42 - 20 inch
Pipe materials	Unalloyed and low-alloyed steels, high-alloyed steels (stainless steel), aluminum				
<b>Technical data</b>					
Dimensions	560 x 260 x 400 mm 22 x 10.2 x 15.8 inch	640 x 260 x 420 mm 25.2 x 10.2 x 16.5 inch	625 x 375 x 490 mm 24.6 x 14.8 x 19.3 inch	700 x 375 x 510 mm 27.6 x 14.8 x 20 inch	700 x 510 x 570 mm 27.6 x 20 x 22.4 inch
Power	1.8 kW	1.2 kW	1.8 kW	1.2 kW	1.8 kW
Air consumption (at 6 bar)	2.0 m³/min	–	2.0 m³/min	–	2.0 m³/min
Speed	0 - 26 min⁻¹	10 - 32 min⁻¹	0 - 13 min⁻¹	5 - 16 min⁻¹	0 - 13 min⁻¹
Vibration level according to EN 28662, Part 1	< 2.5 m/s²	< 2.5 m/s²	< 2.5 m/s²	< 2.5 m/s²	< 2.5 m/s²
Noise level in the workplace	at idle-speed: approx. 75 dB (A) (average speed range); under load: approx. 77 dB (A)				

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

Article	Version	Code		Weight of machine kg	Dispatch weight kg
REB 6	Pneumatic	<b>790 093 001</b>		32.000	52.000
REB 6	230 V, 50/60 Hz EU	<b>790 093 002</b>		35.000	55.000
REB 6	120 V, 50/60 Hz US	<b>790 093 005</b>		35.000	55.000
REB 14	Pneumatic	<b>790 094 001</b>		61.000	90.000
REB 14	230 V, 50/60 Hz EU	<b>790 094 002</b>		64.000	93.000
REB 14	120 V, 50/60 Hz US	<b>790 094 005</b>		64.000	93.000
REB 20	Pneumatic	<b>790 094 010</b>		88.000	135.000
Retrofit kit REB 14 to REB 20		<b>790 094 015</b>		34.000	55.000

# 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:

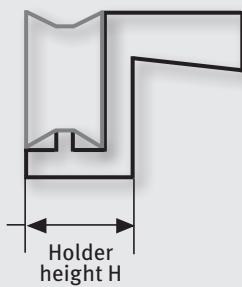
WH 30-I-H27

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



## The different weld prep profiles:



Facing  
I-prep



Plain beveling  
V-prep



Beveling, facing  
Y-prep



J-prepping  
U-prep



Counterboring  
ID-prep

## 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
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-45°	V/Y	BRB 4 / REB	-	-	790 092 218		0.144
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-15°	U	BRB 4 / REB	-	-	790 086 213		0.044
WH12-U-20°	U	BRB 4	-	-	790 086 224		0.047
WH12-U-20° / large clamping surface	U	BRB 4 / REB	-	-	790 086 476		0.091
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-5° / short	ID	BRB 4 / REB	-	-	790 093 398		0.135
WH10-ID-5° / long	ID	BRB 4 / REB	-	-	790 093 400		0.152
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
WH12-ID-10° / from ID 50 (1.969")	ID	BRB 4 / REB	-	-	790 086 280		0.060
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°***	ID	BRB 2 / BRB 4	-	-	790 086 275		0.075
WH5-ID-45°***	ID	BRB 2 / BRB 4 / REB	-	-	790 086 218		0.155



WH12-I



WH15-I\*\*



WH15-V-30°



WH12-U-15°



WH5-ID-14°

- \* Special tool holder for facing pipes in pipe plates.
- \*\* Adjustable tool holder WH for I-prep. Comes with adjustable tool holder, multifunctional tool MFW15-V/I-4 (Code 790 093 037), Torx screws and adjusting plates.
- \*\*\* Special tool holder WH for cutting tubes from tube sheets.

## Pipe Beveling Technology

## Multifunctional tool MFW "Economy"

**Two- or four-sided tool bits without coating.**

For low-alloy steel, carbon steel, aluminum and cast iron pipes.

Article	Version	For wall thickness		Applicable with tool holder / for weld prep profile	Applicable with	Code		kg
		[mm]	[inch]					
MFW15-V/I-4	Economy	2 - 15	0.079 - 0.591	V, Y, I	BRB 4 / REB	790 093 047		0.033
MFW30-V/I-4	Economy	2 - 30	0.079 - 1.181	V, Y, I	REB	790 093 043		0.055

## Multifunctional tool MFW "High-Performance"

**Two- and/or four-sided tool bits with high-performance protective coating against tool wear.**

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

Article	Version	For wall thickness		Applicable with tool holder / for weld prep profile	Applicable with	Code		kg
		[mm]	[inch]					
MFW5-V / I-2	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20°	BRB 2	790 085 030		0.155
MFW30-V / I-4	High-Performance	2 - 30	0.079 - 1.181	V, Y, I	REB	790 093 033		0.055
MFW30-U-4-R5	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 5 mm	REB	790 093 034		0.055
MFW30-U-4-R2	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 2 mm	REB	790 093 035		0.060
MFW30-U-4-R1	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 1 mm	REB	790 093 036		0.060
MFW30-U-4-R0.4	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 0,4 mm	REB	790 093 042		0.060
MFW4-I-2	High-Performance	max. 4	max. 0.157	WH4-I-2 (special holder)	BRB 2	790 085 031		0.002
MFW15-V / I-4	High-Performance	2 - 15	0.079 - 0.591	V, Y, I	BRB 4 / REB	790 093 037		0.055
MFW12-V / I-2	High-Performance	2 - 12	0.079 - 0.472	V, Y, I, U radius 1.2	BRB 4	790 086 060		0.025
MFW12-U-2-R2	High-Performance	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°)	High-Performance	–	–	WH5-ID-14° radius 0.4	BRB 4 / REB	790 093 039		0.003
MFW5-ID-2-R0.4 (45°)	High-Performance	–	–	WH5-ID-45° radius 0.4	BRB 4 / REB	790 086 061		0.002
MFW10-ID-2-R0.4 (80°)	High-Performance	–	–	WH10-ID-80° radius 0.4	BRB 4	790 086 062		0.002
MFW10-ID-2-R0.8 (14°)	High-Performance	–	–	WH10-ID-14° radius 0.8 mm	REB	790 093 038		0.002
MFW10-ID-2-R3.0 (14°)	High-Performance	–	–	WH10-ID-14° radius 3.0 mm	REB	790 093 041		0.004



MFW15-V/I-4 "Economy"



MFW30-U-4-R1



MFW15-V/I-4



MFW5-ID-2-R0.4 (14°)



Mobile air unit DWE 10



Air hose with quick coupling



Cutting lubrication KSS-TOP



Elbow clamping system

## 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 GefStoffV1) and is well corrosion resistant. Developed conforming to drinking water requirements according to DVGW work sheet W521 (thread cutting compounds for drinking water installations) and basically complies with these specifications. Is biologically degradable (OECD 302 B).

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

Comes with:

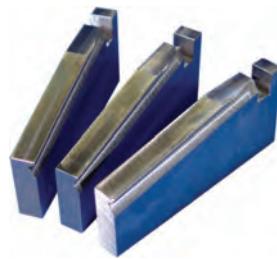
- 1 Durable storage and shipping case
- 1 Mandrel with clamping mechanism for elbows
- 1 Straightening tool
- 8 Sets with 3 pins for dimension range 75 - 157 mm (2.95 - 6.18 inch).

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

## Optional clamping wedges

To extend the dimension of the REB standard machines.

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



Clamping wedges optional

## Plastic (POM) clamping shell segments

Customized plastic (POM) clamping shell segments for REB 6, REB 14 and REB 20 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 on request.

Article	Applicable with	Pipe ID [mm]	Pipe ID [inch]	Code		kg
Plastic clamping shell segment	REB 6	108.2 - 110.1	4.260 - 4.335	790 093 297		1.600
Plastic clamping shell segment	REB 6	147.0 - 149.0	5.787 - 5.866	790 093 298		1.905
Plastic clamping shell segment	REB 14	160.0	6.299	790 094 203		
Plastic clamping shell segment	REB 14	161.5 - 162.7	6.358 - 6.406	790 094 202		3.800
Plastic clamping shell segment	REB 14	211.6 - 213.5	8.331 - 8.401	790 094 206		5.600
Plastic clamping shell segment	REB 14	227.58	8.960	790 094 198		5.880
Plastic clamping shell segment	REB 14	250.0	9.843	790 094 208		5.600
Plastic clamping shell segment	REB 14	264.7 - 266.2	10.421 - 10.480	790 094 210		5.600
Plastic clamping shell segment	REB 14	314.7 - 315.9	12.390 - 12.437	790 094 222		4.100
Plastic clamping shell segment	REB 14	342.9	13.500	790 094 226		4.800
Plastic clamping shell segment	REB 14	347.7	13.689	790 094 224		4.750
Plastic clamping shell segment	REB 20	501.0	19.724	790 094 220		



Plastic (POM) clamping shell segments

## 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 height 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, REB 20		790 094 013	5.750	



ID-Tracking

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

<b>Code-No.</b>	<b>Tool holder</b>	<b>Torx screw</b>	<b>Suitable multifunctional tools</b>
<b>Tools for "I-prep"</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-prep" and "Y-prep"</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 / 790 093 047
790 092 216	WH 15-V-37.5°	790 093 226	790 093 037 with R 0 / 790 093 047
790 092 218	WH 15-V-45°		
790 092 212	WH 15-V-60°	790 093 226	790 093 037 with R 0 / 790 093 047
790 093 468	WH 30-V-15°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 476	WH 30-V/U-25°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 210	WH 30-V-30°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 424	WH 30-V-32.5°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 216	WH 30-V-37.5°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 404	WH 30-V-45°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 470	WH 30-V-50°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 472	WH 30-V-55°	790 093 226	790 093 033 with R 0 / 790 093 043
<b>Tools for "U-prep"</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 / 790 086 064 with R 2
790 086 213	WH 12-U-15°		
790 086 224	WH 12-U-20°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 476	WH 12-U-20° large clamping surface		
790 086 212	WH 12-U-25°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 093 408	WH 30-U-7°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2 / 790 093 036 with R 1
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
790 093 398	WH 10-ID-5° / short	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 400	WH 10-ID-5° / long	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
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
790 086 280	WH 12-ID-10° from ID 50		
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°	—	—	—	—	—	—	—	—	—	—	58 2.283	34 1.339	121 4.764	49 1.929	313 12.323	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 holders for 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
790 093 398	WH 10-ID-5° / short	—	—	—	—	—	—	—	—	72 2.835	59 2.323	105 4.134	61 2.402	159 6.260	71 2.795	320 12.598	95 3.740
790 093 400	WH 10-ID-5° / long	—	—	—	—	—	—	—	—	72 2.835	59 2.323	105 4.134	61 2.402	159 6.260	71 2.795	320 12.598	95 3.740
790 093 402	WH 10-ID-14°	—	—	—	—	—	—	—	—	72 2.835	59 2.323	105 4.134	61 2.402	159 6.260	71 2.795	320 12.598	95 3.740
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

\* 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

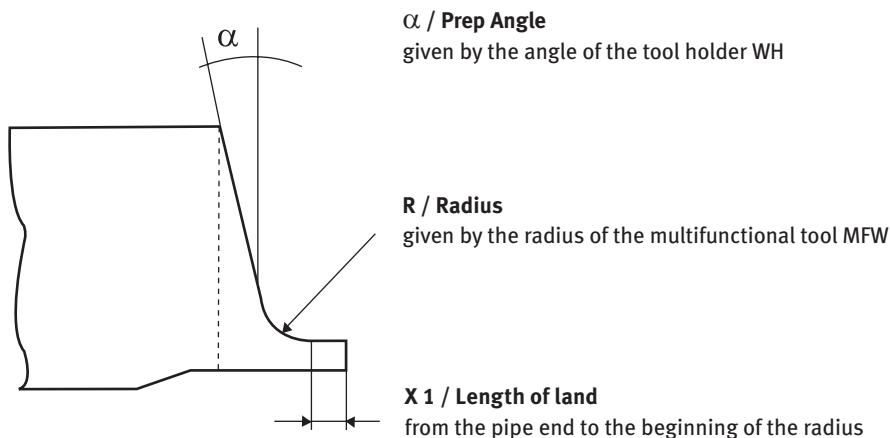
## **Length of land with the use of tool holder for facing 790 092 202 / 790 093 202 and 790 086 210**

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

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

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

Abbreviations:  
 WH = Tool holder  
 MFW = Multifunctional tool





## Accessories for Workshop and Site

55



*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
Dimensions (l x w x h)	120 x 75 x 85 cm	150 x 100 x 85 cm	100 x 70 x 85 cm
Article	Code	kg	
Work bench, small, dismountable, with 1 tool box support	790 052 001		64.000
Work bench, large*, dismountable, 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 stock last.

### Tool box

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

Dimensions	Tool box	
Outside dimensions	100 x 40 x 65 cm / 39.37 x 15.75 x 25.59 inch	
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	up to 165 mm / 6.496 inch	up to 230 mm / 9.055 inch	20 - 250 mm / 0.8 - 9.8 inch
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	Deburring tool	
Pipe OD max.	54 mm / 2.126 inch	
Pipe ID max.	10 mm / 0.394 inch	
Article	Code	kg
Deburring tool	790 052 052	0.455

## Accessories for Workshop and Site



## Rental and Training

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## Rental and Training



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