

precision.
power.
simplicity.

Precision.

Machines and tools
for pipe and tube
preparation.



› 10/2006
Catalogue



tools for piping systems

New products



Tube Squaring Machines **RPG 1.0 Cordless**

Burr-free and square preparation of thin-walled stainless steel tubes up to 1 inch. The cost-effective tube end preparation for welds conforming to industry standards.

Your benefits:

- High-quality machining results
- Burr-free and square
- High-performance coated tool bit with two cutting edges
- Quick clamping system for tubes, tools and clamping shells
- No additional tools required for operation
- Space saving, light-weight and portable machine
- Built-in electronic speed regulation
- Micrometer feed for optimum results
- Feed unit adjustable for cramped working areas

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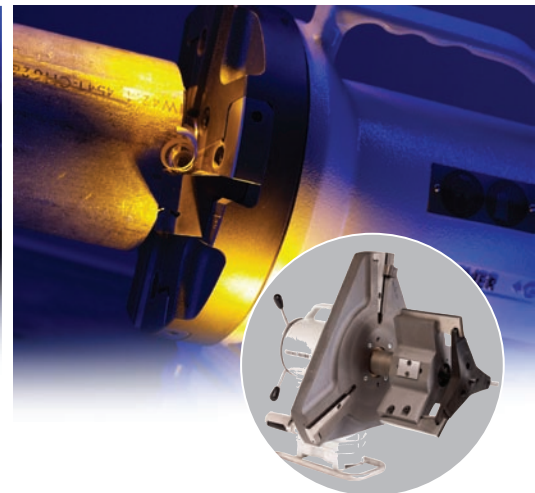
Orbital Cutting Machine **OTM 2.0**

Chipless cutting of thin-walled stainless steel tubes up to 2 inch. Optimal tube end preparation for welding joints conforming to industry standards.

Your benefits:

- The ideal tube cutting machine for high-purity applications
- Deformation-free stainless steel clamping system
- Burr-free, square and deformation-free cut
- Portable machine for a mobile and secure application
- Orbital and automated process for accuracy, time after time after time
- 1 tool for different wall thicknesses (0.8 - 3 mm/.032 - .118 inch) and different tube materials
- Quick clamping system for tubes and tools and adjusting facility to compensate for pipe irregularities

[...more from page 19](#)



Pipe End Preparation Machine **REB 20**

The most powerful, square and burr-free solution for pipe end preparation.

Your benefits:

- Wide application range from OD 290 – 508 mm (11.42 - 20 inch)
- Quick-Tool-Change QTC®
- High-performance tool bit with Balinit® Futura protective coating against tool wear
- Quick clamping system for tools
- Sturdy construction

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According to our mission statement „Precision. Power. Simplicity.“

the products produced in Singen, Germany combine high precision, due to superior drive and tooling concepts with secure and mobile handling.

Look and see!

Power.

Durable, robust and powerful machines and tools enable a continuous and effective usage for your individual application.

Either for a professional weld preparation or for preparing pipe ends and fittings for mechanical joints, the **Orbitalum Tools GmbH** is your highly efficient partner with a worldwide presence and logistics network.

Precision.

A square, deformation- and burr-free cut or a reproducible pipe end preparation is a must for a optimised subsequent treatment.

The **Orbitalum Tools GmbH** develops, produces and markets these highly precise machines and tools as well as the corresponding consumables for the industrial and plumbing piping industries.

Simplicity.

As complexity and demand are continuously increasing in our surroundings, **Orbitalum Tools GmbH** is focusing on machines and tools that are ergonomic and user friendly and specially made for pipeline constructors.

The **Orbitalum Tools GmbH** stands for a quick, precise and easy preparation of any kind of pipe.



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Pipe Cutting and Beveling Technology

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RA Pipe Cutting and Beveling Machines

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

RA 2, RA 4, RA 6, RA 8 and RA 12

Cutting and beveling high-alloy steel (stainless steel), low-alloy and carbon steel, casting materials, non-ferrous metal and plastic pipes in just seconds, using the superior «Planetary Cutting Technology».

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

RA H

Pipe Cutting and Beveling Machines **with additional intermediate gear** for lower cutting speed and more torque for high-performance pipes e.g. Hastelloy, Inconel, Duplex, high-alloy steel (stainless steel) and titanium alloys.

RA INOX

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

Feed versions:

RA 6 AVM, RA 8 AVM and RA 12 AVM

Pipe Cutting and Beveling Machines **with integrated crown wheel and automatic feed module AVM**. By means of the intelligent AVM the feed is controlled and the cutting process is automated. The AVM will be separately delivered with the RA machine and is easy and fast to mount to the pipe cutter.

RA 6 MVM, RA 8 MVM and RA 12 MVM

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

Scope of delivery:

- 1 Pipe Cutting and Beveling Machine RA
- 1 Wooden shipping case
- 1 Saw blade
- 1 Quick mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricating compound GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Operating instructions and spare parts list

All RA's are equipped with the swivel cable (Code 790 041 076).

Electric drive with single-phase AC motor:

Power: 1.6 kW (2.18 HP)
Protection class II (double insulated)
Built-in electronic speed regulation:
RA: 150 - 270 rpm
RA H: 40 - 70 rpm

Pneumatic drive (only on request):

Saw blade speed range:
approx. 120 rpm
Air supply requirement:
1.5 m³/min at 6 bar
(53 cfm at 90 PSI)



RA 4



RA 8 AVM



RA 6 MVM

Application range		RA 2	RA 4	RA 6	RA 8	RA 12
Pipe OD	[mm]	12 - 63	13 - 120	44 - 182	124 - 230	180 - 325
	[inch]	0.472 - 2.480	0.518 - 4.724	1.732 - 7.165	4.882 - 9.055	7.087 - 12.795
Wall thickness (depends on material)*	[mm]	2 - 5.5	2 - 7	2 - 10	2 - 10	2 - 10
	[inch]	0.079 - 0.217	0.079 - 0.276	0.079 - 0.394	0.079 - 0.394	0.079 - 0.394
Pipe ID min.	[mm]	7	21	76	137	190
Saw blade-Ø 63 mm / 2.480 inch	[inch]	0.276	0.827	2.992	5.394	7.480
Pipe ID min.	[mm]	2	16	71	132	185
Saw blade Ø 68 mm / 2.677 inch	[inch]	0.079	0.630	2.795	5.197	7.283
Pipe ID min.	[mm]	-	4	59	120	173
Saw blade Ø 80 mm / 3.150 inch	[inch]	-	0.157	2.329	4.724	6.811
Pipe ID min.	[mm]	-	-	39	-	-
Saw blade Ø 100 mm / 3.937 inch	[inch]	-	-	1.535	-	-

* when processing thin-walled tubes there are special clamping shells to eliminate distortion, see page 10.

Article	Version	Code	kg
RA 2	200 - 240 V, 50/60 Hz EU	790 041 095	45.000
RA 2	100 - 120 V, 50/60 Hz EU	790 041 092	45.000
RA 2 INOX	200 - 240 V, 50/60 Hz EU	790 041 057	49.000
RA 2 H	200 - 240 V, 50/60 Hz EU	790 041 097	47.000
RA 2 H	100 - 120 V, 50/60 Hz EU	790 041 401	47.000
RA 2 H INOX	200 - 240 V, 50/60 Hz EU	790 041 402	49.000
RA 4	200 - 240 V, 50/60 Hz EU	790 042 095	76.000
RA 4	100 - 120 V, 50/60 Hz EU	790 042 092	76.000
RA 4 INOX	200 - 240 V, 50/60 Hz EU	790 042 057	78.000
RA 4 H	200 - 240 V, 50/60 Hz EU	790 042 097	80.000
RA 4 H	100 - 120 V, 50/60 Hz EU	790 042 401	80.000
RA 4 H INOX	200 - 240 V, 50/60 Hz EU	790 042 402	80.000
RA 6	200 - 240 V, 50/60 Hz EU	790 043 095	98.000
RA 6	100 - 120 V, 50/60 Hz EU	790 043 092	98.000
RA 6 H	200 - 240 V, 50/60 Hz EU	790 043 097	102.000
RA 6 H	100 - 120 V, 50/60 Hz EU	790 043 401	102.000
RA 6 AVM	200 - 240 V, 50/60 Hz EU	790 043 001	108.000
RA 6 AVM	100 - 120 V, 50/60 Hz EU	790 043 005	108.000
RA 6 H AVM	200 - 240 V, 50/60 Hz EU	790 043 003	112.000
RA 6 H AVM	100 - 120 V, 50/60 Hz EU	790 043 006	112.000
RA 6 MVM	200 - 240 V, 50/60 Hz EU	790 043 069	101.000
RA 6 MVM	100 - 120 V, 50/60 Hz EU	790 043 078	101.000
RA 6 H MVM	200 - 240 V, 50/60 Hz EU	790 043 071	105.000
RA 6 H MVM	100 - 120 V, 50/60 Hz EU	790 043 079	105.000
RA 8	200 - 240 V, 50/60 Hz EU	790 045 095	112.000
RA 8	100 - 120 V, 50/60 Hz EU	790 045 092	112.000
RA 8 H	200 - 240 V, 50/60 Hz EU	790 045 097	116.000
RA 8 H	100 - 120 V, 50/60 Hz EU	790 045 401	116.000
RA 8 AVM	200 - 240 V, 50/60 Hz EU	790 045 001	122.000
RA 8 AVM	100 - 120 V, 50/60 Hz EU	790 045 005	122.000
RA 8 H AVM	200 - 240 V, 50/60 Hz EU	790 045 003	126.000
RA 8 H AVM	100 - 120 V, 50/60 Hz EU	790 045 006	126.000
RA 8 MVM	200 - 240 V, 50/60 Hz EU	790 045 069	115.000
RA 8 MVM	100 - 120 V, 50/60 Hz EU	790 045 078	115.000
RA 8 H MVM	200 - 240 V, 50/60 Hz EU	790 045 071	118.000
RA 8 H MVM	100 - 120 V, 50/60 Hz EU	790 045 079	118.000
RA 12	200 - 240 V, 50/60 Hz EU	790 047 095	141.000
RA 12	100 - 120 V, 50/60 Hz EU	790 047 092	141.000
RA 12 H	200 - 240 V, 50/60 Hz EU	790 047 097	143.000
RA 12 H	100 - 120 V, 50/60 Hz EU	790 047 401	143.000
RA 12 AVM	200 - 240 V, 50/60 Hz EU	790 047 001	144.000
RA 12 AVM	100 - 120 V, 50/60 Hz EU	790 047 005	144.000
RA 12 H AVM	200 - 240 V, 50/60 Hz EU	790 047 003	147.000
RA 12 H AVM	100 - 120 V, 50/60 Hz EU	790 047 006	147.000
RA 12 MVM	200 - 240 V, 50/60 Hz EU	790 047 069	137.000
RA 12 MVM	100 - 120 V, 50/60 Hz EU	790 047 078	137.000
RA 12 H MVM	200 - 240 V, 50/60 Hz EU	790 047 071	140.000
RA 12 H MVM	100 - 120 V, 50/60 Hz EU	790 047 079	140.000



RA 4 H

Pipe Cutting and Beveling Technology

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RA Pipe Cutting and Beveling Machines

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

RA 21 S

Cutting and beveling high-alloy steel (stainless steel), low- and unalloyed steel, casting materials, non-ferrous metal and plastic pipes in just seconds, using the superior «Planetary Cutting Technology». Ideal for thin-walled and press fitting applications.

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

RA 21 S INOX

Pipe Cutting and Beveling Machine with special stainless steel clamping jaws and/or stainless steel attachment.

Scope of delivery:

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

Electric drive with single-phase AC motor:

Power: 550 W (0.75 HP)

Protection class II (double insulated)

Saw blade speed: 180 rpm

Application range	[mm]	[inch]
Pipe OD	5 - 63	0.197 - 2.481
Wall thickness, depends on material	0.5 - 4.5	0.019 - 0.177
Pipe ID min. (saw blade-Ø 63 mm/2.480 inch)	7	0.276
Pipe ID min. (saw blade-Ø 68 mm/2.677 inch)	2	0.079
Pipe OD for bars (saw blade-Ø 63 mm/2.480 inch)	6 - 16	0.236 - 0.630

Article	Version	Code		kg
RA 21 S	230 - 240 V, 50/60 Hz EU	790 044 008		34.200
RA 21 S	115 V, 50/60 Hz EU	790 044 015		34.200
RA 21 S INOX	230 - 240 V, 50/60 Hz EU	790 044 060		34.200



RA Pipe Cutting and Beveling Machines

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

RA 41 Plus

Cutting and beveling tubes and cutting elbows made of high-alloy steel (stainless steel), low- and unalloyed steel, casting materials and non-ferrous metal in just seconds, using the superior «Planetary Cutting Technology».

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

RA 41 Plus H

Pipe Cutting and Beveling Machine **with additional intermediate gear** for lower cutting speed and more torque for high-performance pipes e.g. Hastelloy, Inconel, Duplex, high-alloy steel (stainless steel) and titanium alloys.

Scope of delivery:

- 1 Pipe Cutting and Beveling Machine RA 41 Plus (H)
- 1 Transportation box
- 1 Saw blade (Code 790 042 064)
- 1 Quick mounting plate
- 1 Tool set
- 1 Tube of saw blade lubricating compound GF TOP (Code 790 060 228)
- 1 Tube of special gear oil (Code 790 041 030)
- 1 Operating instructions with spare parts list

Electric drive with single-phase AC motor:

Power: 1.6 kW (2.18 HP)

Protection class II (double insulated)

Built-in electronic speed regulation: 150 - 270 rpm



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

Article	Version	Code		kg
RA 41 Plus	200 - 240 V, 50/60 Hz EU	790 046 011		77.000
RA 41 Plus	100 - 120 V, 50/60 Hz EU	790 046 014		77.000
RA 41 Plus H	200 - 240 V, 50/60 Hz EU	790 046 017		79.000
RA 41 Plus H	100 - 120 V, 50/60 Hz EU	790 046 030		79.000

Pipe Cutting and Beveling Technology

Accessories for RA machines



Aluminum clamping shells

For RA 6, RA 8 and RA 12.

Customised 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.

Scope of delivery:

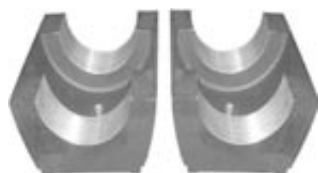
- 4 Cylinder head screws
- 1 Set of clamping shells

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

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

Other dimensions are available.

Article	Tube OD [mm]	Tube OD [inch]	Code		kg
for RA 6	76.1	3.000	790 043 216		4.500
for RA 8	129.0	5.079	790 045 216		4.300
for RA 8	167.0	6.575	790 045 218		4.000
for RA 8	210.0	8.268	790 045 217		2.900
for RA 12	209.0	8.230	790 047 221		11.500
for RA 12	219.0	8.620	790 047 220		11.200
for RA 12	254.0	10.000	790 047 216		9.200
for RA 12	273.0	10.750	790 047 219		8.400
for RA 12	324.0	12.760	790 047 218		6.100
for RA 12	325.0	12.790	790 047 215		6.100



Aluminum clamping shells for RA 41 Plus

For deformation-free clamping of thin-walled tubes.

Other dimensions are available.

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



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

In pairs.

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

Aluminum clamping jaws

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

1 pair.

Article	Code		kg
Aluminum clamping jaws	790 046 250		2.600



Saw blade lubricating compound GF TOP

Synthetic high-performance lubricant for pipe cutting and beveling.
Increases the life of the saw blades. Complies with USDA H2 registration.
Easy and constant lubrication of the saw blade, supplied with a special brush.

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



Saw blade lubricating compound ROCOL

High-performance lubricant for pipe cutting and beveling.
Increases the life of the saw blades.

Article	Version	Code		kg
Saw blade lubricating compound ROCOL	Tube, 150 ml	790 041 016		0.195
Saw blade lubricating compound ROCOL	Can, 0.5 kg	790 041 013		0.605
Saw blade lubricating compound ROCOL	Can, 5.0 kg	790 041 019		5.520



Special gear oil

For all RA machines.

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



Pipe length gauge bar

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

Article	Code		kg
Pipe length gauge bar	790 041 011		1.568



Pipe Cutting and Beveling Technology

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Length gauge

Combined metric and inch scale.

Measuring range up to 250 mm (9.84 inch).

Article	Code		kg
Lenght gauge for RA 21 S	790 044 020		0.815
Lenght gauge for RA 41	790 046 020		1.000



Intermediate retrofit gear kit for RA machines

To convert the RA machines to RA H machines.

Reducing the cutting speed of the RA machine to 40 - 70 rpm and more torque.

For cutting of high-performance materials e.g. Hastelloy and Inconel.

Fits for 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 special gear oil (Code 790 041 030).

Article	Code		kg
Intermediate gear retrofit kit	790 041 063		2.000



Swivel cable

To prevent twisting of the cable.

For all RA and PS machines with protection class II (double insulated).

Cable length: 4 m (15.75 inch).

Article	Code		kg
Swivel cable	790 041 076		0.550



Quick-mounting base plate

With integrated screw clamps for easy and fast mounting of the machine to the bench.

Ideal for frequent location change.

Article	Code		kg
Quick-mounting base plate for RA 2 (H), RA 21 S	790 041 027		4.230
Quick-mounting base plate for RA 4 (H), RA 6 (H), RA 8 (H), RA 41 (Plus)	790 042 027		6.165



RA carrier

For easy transportation of RA machines.

For all RA 4, RA 41, RA 41 Plus and RA 6 machines.

On request, the RA carrier can be pre-mounted on new purchases of one of the above RA machines.

Article	Code		kg
RA carrier	790 042 035		5.000

Pipe feeder base unit

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

This feature helps the squariness of the cut and is suitable for all +GF+ pipe cutting and beveling RA machines made by Orbitalum Tools (not for RA 2 and RA 21). The RA machines can be directly mounted onto the base plate of the pipe feeder base unit, without further parts. The RA machines can be easily adjusted to the required cutting dimension. The machine is resilient supported on the base plate.



Application range	Pipe feeder base unit
Pipe OD [mm]	16 - 325
Pipe OD [inch]	0.630 - 12.795
Dimensions [cm] approx.	185 x 105 x 50
Dimensions [inch] approx.	72.8 x 41.3 x 19.7
Load max. [kg]	400

Article	Code		kg
Pipe feeder base unit	790 068 051		116.000

Pipe feeder extension unit

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

Application range	Pipe feeder extension unit
Pipe OD [mm]	16 - 325
Pipe OD [inch]	0.630 - 12.795
Dimensions [cm] approx.	160 x 105 x 50
Dimensions [inch] approx.	62.9 x 41.3 x 19.7
Load max. [kg]	400

Article	Code		kg
Pipe feeder extension unit	790 068 061		72.000



Floor bracket accessory

To fasten the base unit or the extension unit to the floor.

The assembly consists of:

- 4 Brackets
- 8 Bolts with washers

Article	Code		kg
Floor bracket accessory	790 068 053		1.900

Pipe support

With rotating support roller. Adjustable from 85 up to 110 cm (33.47 - 43.31 inch).

Load: max. 300 kg

Article	Code		kg
Pipe support	790 052 301		7.000



Pipe Cutting and Beveling Technology

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Saw blades and bevel cutters for RA machines

These saw blades and bevel cutters are especially designed for our pipe cutters for highest requirements and longest service life.

4 different high-quality tool ranges are available for different applications:

- **Economy Range**
for low and unalloyed steel and cast iron pipes
- **Performance Range**
for high-alloy steel (stainless steel)
- **High-Performance Range**
for high-performance materials and high-alloy steel (stainless steel)
- **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 order quantity: 5 blades

Article	Pipe wall thickness		Saw blade Ø		Code		kg
	[mm]	[inch]	[mm]	[inch]			
Economy	1.2 - 2.0	.047 - .079	63	2.480	790 041 040		0.031
Economy*	1.5 - 6.0	.059 - .236	68	2.677	790 042 063		0.036
Economy*	5.0 - 12.0	.197 - .472	75	2.953	790 043 030		0.053
Economy	2.0 - 5.5	.079 - .217	63	2.480	790 041 020		0.032
Economy	2.5 - 7.0	.098 - .276	68	2.677	790 042 020		0.045
Performance	0.6 - 1.2	.024 - .047	63	2.480	790 041 036		0.027
Performance	1.0 - 1.6	.039 - .063	68	2.677	790 042 049		0.040
Performance	1.0 - 2.5	.039 - .098	63	2.480	790 041 041		0.042
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	1.5 - 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	77	3.031	790 043 018		0.060
Performance	6.0 - 10.0	.236 - .394	75	2.953	790 043 022		0.055
Performance	6.0 - 10.0	.236 - .394	100	3.937	790 047 026		0.105
Performance	for bar stock up to Ø 30 mm / 1.181"		82	3.228	790 046 023		0.070
High-Performance	1.0 - 2.5	.039 - .098	68	2.677	790 042 159		0.040
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 and RA 12

Saw blade/bevel cutter combinations

Simultaneous cutting and beveling of pipes in just seconds.

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

Article	Pipe wall thickness		Beveling angle	Height of bevel max.		Saw blade-Ø		Code		kg
	[mm]	[inch]	[°]	[mm]	[inch]	[mm]	[inch]			
Performance	2.5 - 5.0	.098 - .197	30	5	.197	68	2.677	790 042 155		0.095
Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 157		0.103
Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 161		0.108
High-Performance	2.5 - 5.0	.098 - .197	30	5	.197	68	2.677	790 042 018		0.095
High-Performance	2.5 - 5.0	.098 - .197	35	5	.197	68	2.677	790 042 015		0.120
High-Performance	2.5 - 6.0	.098 - .236	45	4	.157	68	2.677	790 042 023		0.135
High-Performance	2.5 - 7.0	.098 - .276	30	7	.276	68	2.677	790 042 013		0.108

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

Article	Version	Code		kg
Saw blade for 790 042 155, 790 042 157 and 790 042 161	Performance	790 042 153		0.040
Bevel cutter 30° for 790 042 155	Performance	790 042 154		0.045
Bevel cutter 30° for 790 042 161	Performance	790 042 160		0.060
Bevel cutter 35° for 790 042 157	Performance	790 042 156		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 790 042 018	High-Performance	790 042 017		0.045
Bevel cutter 35° for 790 042 015	High-Performance	790 042 014		0.060
Bevel cutter 30° for 790 042 013	High-Performance	790 042 021		0.077
Bevel cutter 45° for 790 042 023	High-Performance	790 042 022		0.077

Press fitting saw blade/bevel cutter combination**

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

Replacement parts for press fitting saw blade/bevel cutter combination

Article	Version	Code		kg
Saw blade for 790 044 046	Performance	790 044 040		0.027
Bevel cutter for 790 044 046	Performance	790 044 042		0.064
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

Support disc for saw blade/bevel cutter combination

We recommend to use 1 support disc when using saw blade/bevel cutter combination.

Article	Code		kg
Support disc	790 046 188		0.068

- * Consisting of one saw blade and one bevel cutter with high-performance coating. It is possible to order the individual parts.
 ** Consisting of one saw blade and one bevel cutter (uncoated). Especially for stainless steel press fitting systems. It is possible to order the individual parts.





Bevel cutters

For V-seam profiles on pipe ends.

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

Bevel cutters V-seam

Article	Beveling angle	Height of bevel max.		Bevel cutter-Ø		Code		kg
	[°]	[mm]	[inch]	[mm]	[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
Economy	60.0	4.7	.185	70	2.756	790 042 046		0.175
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	37.5	8.4	.331	70	2.756	790 042 070		0.163
Performance	50.0	5.8	.228	70	2.756	790 042 050		0.168
High-Performance	30.0	9.5	.374	72	2.835	790 042 073		0.157
High-Performance	37.5	8.4	.331	70	2.756	790 042 072		0.163



Saw blade lubricating compound GF TOP

Synthetic high-performance lubricant for pipe cutting and beveling.

Increases the life of the saw blades. Complies with USDA H2 registration.

Easy and constant lubrication of the saw blade, supplied with a special brush.

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



Saw blade lubricating compound ROCOL

High-performance lubricant for pipe cutting and beveling.

Increases the life of the saw blades.

Article	Version	Code		kg
Saw blade lubricating compound ROCOL	Tube, 150 ml	790 041 016		0.195
Saw blade lubricating compound ROCOL	Can, 0.5 kg	790 041 013		0.605
Saw blade lubricating compound ROCOL	Can, 5.0 kg	790 041 019		5.520

Portable Tube Saws

- Lightweight and easily transportable machine (only 19 kg / 22 kg) 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
- Orbital cutting process saves time
- Multipoint clamping system of tubes
- Fast adjustment of tube dimensions
- Long saw blade service life

PS 4.5, PS 6.6

Tube cutting made easy!

Cutting thin-walled stainless-steel tubes and elbows using the superior «Planetary Cutting Technology».

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

Scope of delivery:

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

Electric drive with a single phase AC motor:

Power: 1010 W (1.35 HP)

Protection class II (double insulated)

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



PS 6.6

PS 4.5

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

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

Article	Version	Code	kg
PS 4.5	230 V, 50/60 Hz EU	790 048 001	34.000
PS 4.5	110 V, 50/60 Hz EU	790 048 002	34.000
PS 6.6	230 V, 50/60 Hz EU	790 049 001	41.000
PS 6.6	110 V, 50/60 Hz EU	790 049 002	41.000

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Accessories for PS machines

Quick mounting plate with screw clamps

With integrated screw clamps for easy and fast mounting of the machine to the bench.
Ideal for frequent location change.

Article	Code		kg
Quick mounting plate with screw clamps	790 048 334		2.600

Saw Blades

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

Article	Tube wall thickness [mm]	Tube wall thickness [inch]	Saw blade-Ø [mm]	Saw blade-Ø [inch]	Code		kg
Performance	1.0 - 3.0	0.039 - 0.118	63	2.480	790 048 072		0.035
Performance	1.2 - 2.5	0.047 - 0.098	63	2.480	790 041 035		0.045
Performance	0.6 - 1.2	0.024 - 0.047	63	2.480	790 041 036		0.027

Tripod

Made of stainless steel. Ideal for on-site work with PS machines.

- Space saving
- Fast application
- Easy handling

Article	Code		kg
Tripod	790 048 335		10.600

Clamping jaws replacement set for PS 4.5 and PS 6.6

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

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

Saw blade lubricating compound GF TOP

Synthetic high-performance lubricant for pipe cutting and beveling.
Increases the life of the saw blades. Complies with USDA H2 registration.
Easy and constant lubrication of the saw blade, supplied with a special brush.

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

Orbital Cutting Machine

- The ideal tube cutting machine for high-purity applications
- Deformation-free stainless steel clamping system
- Burr-free, square and deformation-free cut
- Portable machine for a mobile and secure application
- Orbital and automated cutting process
- 1 tool for different wall thicknesses and different tube materials
- Quick clamping system for tubes and tools and adjusting facility to compensate for tube irregularities

OTM 2.0

Cutting of thin-walled stainless steel tubes up to 2".
The optimal tube end preparation for welding joints conforming to industry standards.

Scope of delivery:

- 1 Orbital Cutting Machine OTM 2.0
- 1 Durable storage and shipping case
- 1 Tool holder WH (Code 790 022 736) with high-performance coated tool bit (Code 790 022 737)
- 1 Tool set
- 1 Operating instructions with spare parts list

Electric drive with single-phase AC motor:

Power: 1010 W (1.35 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 24 - 42 rpm



Application range		[mm]	[inch]
Tube OD		6.35 - 50.8	1/4 - 2
Wall thickness (depends on material)		0.8 - 3	0.032 - 0.118

Article	Version	Code	kg
OTM 2.0	200 - 240 V, 50/60 Hz EU	790 022 701	8.000
OTM 2.0	100 - 120 V, 50/60 Hz EU	790 022 703	8.000

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Accessories for OTM 2.0

Tool bit

Two-sided tool bit with high-performance protective coating against tool wear (TiN).
1 tool for different wall thicknesses (0.8 -3 mm/.032 -.118 inch) and different tube materials.

Article	Code		kg
Tool bit for OTM 2.0	790 022 737		0.003

Tool holder WH

Including Torx-screw.

Article	Code		kg
Tool holder for OTM 2.0	790 022 736		0.066

Clamping shells

The two-piece-design of the stainless steel clamping shells with click mechanism are extremely durable.

- Ensures accurate and deformation-free centering of the tube
- Quick clamping shell change, no tools required

Further dimensions are available.

Article	Tube OD [mm]	Tube OD [inch]	Code		kg
Clamping shells for OTM 2.0	6.35	0.250	790 022 781		0.915
Clamping shells for OTM 2.0	9.53	0.375	790 022 787		0.905
Clamping shells for OTM 2.0	12.70	0.500	790 022 782		0.857
Clamping shells for OTM 2.0	19.05	0.750	790 022 783		0.860
Clamping shells for OTM 2.0	24.40	1.000	790 022 784		0.754
Clamping shells for OTM 2.0	38.10	1.500	790 022 785		0.580
Clamping shells for OTM 2.0	50.80	2.000	790 022 786		0.342

Universal Pipe Cutter

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

SCORP 220 Plus, SCORP 360

The ultimate and fast solution for cutting of cast iron, stainless steel, steel, copper, aluminum and plastic pipes.

Ideal for pipe fitters to use on construction sites and in industrial pipe installations.

Scope of delivery:

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

Electric drive with single-phase AC motor:

Power:

SCORP 220 Plus: 1.1 kW (1.5 HP)

SCORP 360: 1.4 kW (1.9 HP)

Max. saw blade speed range: 4.000 rpm



SCORP 220 Plus

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

Article	Version	Code		kg
SCORP 220 Plus	200 - 240 V, 50/60 Hz EU	790 014 007		9.500
SCORP 220 Plus	100 - 120 V, 50/60 Hz EU	790 014 008		9.500
SCORP 360	200 - 240 V, 50/60 Hz EU	790 015 001		14.300
SCORP 360	100 - 120 V, 50/60 Hz EU	790 015 002		14.300

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Saw blades for SCORP machines

Saw blade TCT

Article	For pipe material	Saw blade-Ø [mm]	rpm max.	Code		kg
Saw blade TCT	Steel, copper, aluminum, all kinds of plastic	140	4.200	790 014 055		0.154
Saw blade TCT*	All kinds of plastic	155	4.200	790 014 058		0.195

* only for SCORP 360

Application range SCORP 360 with TCT saw blades

Plastic pipe OD [mm]	Saw blade Ø 140 mm max. wall thickness [mm]	Saw blade Ø 155 mm max. wall thickness [mm]
75	15.1	22.6
90	11.4	18.9
100	10.1	17.6
110	9.3	16.8
115	9.1	16.6
140	8.7	16.2
160	9.1	16.6
165	9.3	16.8
190	10.4	17.9
215	11.8	19.3
240	13.4	20.9
270	15.4	22.9
320	18.6	26.1
355	20.4	27.9

Cutting blade Diamond

Article	For pipe material	Saw blade-Ø [mm]	rpm max.	Code		kg
Cutting blade Diamond	Cast iron	140	4.200	790 014 057		0.173

Saw blade Cermet

Article	For pipe material	Saw blade-Ø [mm]	rpm max.	Code		kg
Saw blade Cermet	Stainless steel	140	4.200	790 014 056		0.153

Metal Tube Cutter

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

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

MRA

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

For tube materials:

- Stainless steel (special steel material no. 1.40... – 1.45... as per DIN 17 455 and DIN 17 456)
- Low alloy and unalloyed steel
- Aluminum
- Cast materials
- Non-ferrous metals
- PVDF plastic

Versions:

MRA HP

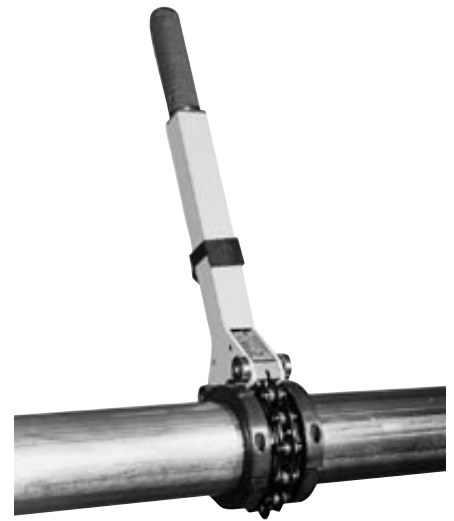
Metal Tube Cutter for high-purity applications. Only applicable with the HP multi-roller cutting chain (Code 790 008 014).

Scope of delivery:

- 1 Metal Tube Cutter MRA*
- 1 Plastic carrying case (ABS)
- 1 Socket head key
- 1 Connection clamp
- 1 Tube of lubricating compound GF TOP (Code 790 060 228)**
- 1 Pair of working gloves
- 1 Operating instructions with spare parts list

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

** not with MRA HP



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

Article	Version	Code	kg
Metal Tube Cutter MRA	Standard	790 008 001	8.000
Metal Tube Cutter MRA	HP	790 008 002	8.000

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Accessories for MRA

Multi-roller cutting chain

Cutting wheels made from hardened steel.

Article	Tube OD [mm]	Tube OD [inch]	Number of cutting wheels [pieces]	Code		kg
Multi-roller cutting chain	33.7 - 114.3	1.330 - 4.500	15	790 008 018		0.500
Multi-roller cutting chain HP*	33.7 - 114.3	1.330 - 4.500	15	790 008 014		0.510
Multi-roller cutting chain	114.3 - 154.0	4.500 - 6.060	10	790 008 013		0.610
Multi-roller cutting chain	114.3 - 254.0	4.500 - 10.000	16	790 008 041		0.900

* Multi-roller cutting chain for high-purity applications. Only applicable with the HP Metal Tube Cutter (Code 790 008 002).

Clamping shells MRA

Set of two pieces, made from hardened steel.
Further dimensions of clamping shells are available.

Tube OD [mm]	Tube OD [inch]	Code		kg
33.7	1.330	790 008 105		0.885
38.1	1.500	790 008 130		0.955
40.0	1.575	790 008 135		0.955
42.4	1.670	790 008 140		1.005
48.3	1.900	790 008 155		1.100
50.0	1.970	790 008 160		1.130
50.8	2.000	790 008 165		1.140
52.0	2.050	790 008 175		1.190
54.0	2.125	790 008 185		1.100
60.3	2.375	790 008 195		1.315
63.5	2.500	790 008 200		1.375
70.0	2.755	790 008 215		1.445
75.0	2.950	790 008 225		1.600
76.1	2.996	790 008 230		1.560
84.0	3.300	790 008 240		1.690
85.0	3.350	790 008 245		1.750
88.9	3.500	790 008 250		1.780
101.6	4.000	790 008 260		2.025
104.0	4.095	790 008 270		1.925
110.0	4.330	790 008 285		2.150
114.3	4.500	790 008 290		2.295
129.0	5.080	790 008 315		3.000
139.7	5.500	790 008 325		3.365
154.0	6.060	790 008 340		3.365
160.0	6.300	790 008 355		3.520
168.3	6.625	790 008 365		3.600
204.0	8.030	790 008 380		4.375
219.1	8.625	790 008 385		4.680

Pipe vice for MRA

For pipes up to OD 300 mm (11.81 inch), with a plastic clamping strap, reversible. Can be easily combined with the Manual Tube Cutter MRA due to an integrated clamping shell bearing.

Article	Code		kg
Pipe vice for MRA	790 008 008		17.000





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Tube Squaring Machines

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

RPG 1.0 Cordless, RPG 1.0 Cordless right-angled drive

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

Scope of delivery:

- 1 Tube Squaring Machine RPG 1.0 Cordless / Cordless right-angled drive
- 1 Durable storage and shipping case
- 2 Rechargeable batteries
- 1 Battery charger (110 - 120 V, 50/60 Hz or 240 V, 50/60 Hz)
- 1 Multifunctional tool (Code 790 038 314)
- 1 Torx T-spanner for securing the multifunctional tools (T15)
- 1 Operating instructions with spare parts list
- Operating instructions and safety notes for the battery charger

Drive with rechargeable battery

Voltage of rechargeable battery: 12 V

Speed RPG 1.0 Cordless: 0 - 400 rpm

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

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

Article	Version (battery charger)	Code		kg
RPG 1.0 Cordless EU	220 - 240 V, 50/60 Hz	790 036 001		2.100
RPG 1.0 Cordless EU	110 - 120 V, 50/60 Hz	790 036 003		2.100
RPG 1.0 Cordless right-angled drive EU	220 - 240 V, 50/60 Hz	790 036 011		2.900
RPG 1.0 Cordless right-angled drive EU	110 - 120 V, 50/60 Hz	790 036 013		2.900



RPG 1.0 Cordless right-angled drive

RPG 1.0 Cordless

Accessories for RPG 1.0

One-piece stainless steel clamping shells

Extremely durable. Ensures accurate centring and quick clamping shell change without any tools. For use on all materials with a OD of 3.18 mm up to 25.40 mm (0.125 - 1.000 inch). Further clamping shell dimensions are available.

Tube OD [mm]	Tube OD [inch]	Code	kg
3.18	0.125	790 036 201	0.119
6.35	0.250	790 036 202	0.118
9.53	0.375	790 036 203	0.115
10.00	0.375	790 036 204	0.115
12.00	0.472	790 036 205	0.112
12.70	0.500	790 036 206	0.111
17.20	0.677	790 036 207	0.104
19.05	0.750	790 036 208	0.100
21.30	0.839	790 036 209	0.094
25.40	1.000	790 036 210	0.083



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



Durable storage and shipping case

High-quality blue transportation case with insert. Very sturdy design. Already included in the standard scope of delivery of the RPG 1.0 Cordless right-angled drive.

Article	Code	kg
Durable storage and shipping case	790 036 080	5.400



Tube Squaring Machines

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

RPG 1.5, RPG 1.5 Cordless

Designed for burr-free squaring of thin-walled stainless steel tubes and micro fittings up to OD 38.1 mm (1.5 inch). The cost-effective solution for precise welds conforming to industry standards. Clean and secure working area with clear view cutting head.

RPG 1.5:

- Removable bench stand

RPG 1.5 Cordless:

- Light-weight and portable machine
- Right-angled machine with carrying handle and rechargeable battery
- Short machine length

Scope of delivery:

- 1 Tube Squaring Machine RPG 1.5 or RPG 1.5 Cordless
- 1 Durable storage and shipping case
- 2 Rechargeable batteries*
- 1 Battery charger*
- 1 Tool holder (Code 790 037 152) with multifunctional tool (Code 790 038 314)
- 1 Tool set
- 1 Operating instructions with spare parts list
- Operating instructions and safety notes for the battery charger*

* only with RPG 1.5 Cordless

RPG 1.5 with single-phase AC motor:

Power: 1010 W (1.35 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 20 - 160 rpm

Speed stabilisation

RPG 1.5 Cordless with rechargeable battery

12 v rechargeable battery

1. speed: 0 - 350 rpm

2. speed: 0 - 1300 rpm

Application range	[mm]	[inch]
Tube OD	3.0 - 38.1	0.118 - 1.500
Wall thickness max.	3.0	0.118

Article	Version	Code		kg
RPG 1.5	200 - 240 V, 50/60 Hz EU	790 037 001		9.500
RPG 1.5	100 - 120 V, 50/60 Hz EU	790 037 003		9.500
RPG 1.5 Cordless	200 - 240 V, 50/60 Hz EU	790 037 011		10.100
RPG 1.5 Cordless	100 - 120 V, 50/60 Hz EU	790 037 013		10.100



RPG 1.5



RPG 1.5 Cordless

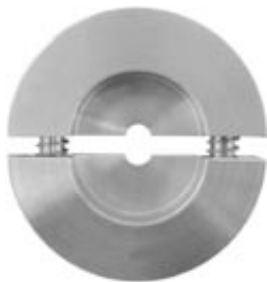
Accessories for RPG 1.5 (Cordless)

One-piece stainless steel clamping shells

Extremely durable. Ensures accurate centring and quick clamping shell change without any tools. For use on all materials with a OD of 3.0 mm up to 38.1 mm (0.118 - 1.500 inch). Further clamping shell dimensions are available.



Tube OD [mm]	Tube OD [inch]	Code	kg
3.00	0.118	790 037 220	0.300
3.18	0.125	790 037 221	0.308
4.00	0.157	790 037 222	0.308
4.78	0.188	790 037 223	0.308
5.00	0.197	790 037 224	0.290
6.00	0.236	790 037 225	0.310
6.35	0.250	790 037 226	0.306
8.00	0.314	790 037 227	0.299
9.53	0.375	790 037 228	0.297
10.00	0.394	790 037 229	0.298
12.00	0.472	790 037 230	0.293
12.70	0.500	790 037 231	0.292
13.00	0.512	790 037 232	0.291
13.50	0.531	790 037 233	0.290
14.00	0.551	790 037 234	0.288
15.00	0.591	790 037 235	0.286
15.88	0.625	790 037 236	0.285
16.00	0.630	790 037 237	0.282
17.20	0.677	790 037 238	0.300
18.00	0.709	790 037 239	0.280
19.00	0.748	790 037 240	0.277
19.05	0.750	790 037 241	0.274
20.00	0.787	790 037 242	0.272
21.30	0.839	790 037 243	0.270
22.00	0.866	790 037 244	0.264
23.00	0.906	790 037 245	0.261
24.00	0.945	790 037 246	0.256
25.00	0.984	790 037 247	0.252
25.40	1.000	790 037 248	0.240
26.90	1.059	790 037 249	0.260
28.00	1.102	790 037 250	0.238
29.00	1.142	790 037 251	0.235
30.00	1.181	790 037 252	0.232
31.80	1.250	790 037 280	0.230
33.40	1.315	790 037 281	0.220
33.70	1.327	790 037 282	0.218
34.00	1.339	790 037 283	0.210
35.00	1.377	790 037 284	0.210
36.00	1.417	790 037 285	0.204
38.00	1.496	790 037 286	0.199
38.10	1.500	790 037 287	0.194



One-piece stainless steel clamping shells for micro fittings

Extremely durable. Ensures accurate centring and quick clamping shell change without any tools. For use on all materials with a OD of 3.0 mm up to 21.2 mm (0.118 - 0.835 inch). Further clamping shell dimensions are available.

Tube OD [mm]	Tube OD [inch]	Code		kg
3.00	0.118	790 037 300		0.241
3.18	0.125	790 037 301		0.227
4.00	0.157	790 037 302		0.237
4.78	0.188	790 037 303		0.234
5.00	0.197	790 037 304		0.228
6.00	0.236	790 037 305		0.220
6.35	0.250	790 037 306		0.460
8.00	0.314	790 037 307		0.223
9.53	0.375	790 037 308		0.300
10.00	0.394	790 037 309		0.222
12.00	0.472	790 037 310		0.220
12.70	0.500	790 037 311		0.220
17.20	0.678	790 037 312		0.220
21.20	0.835	790 037 313		0.213

Tool holder WH

For multifunctional tool 790 038 314. Adjustable tool holder with Torx screw.

Application range	Standard Tool holder	Optional Tool holder
Pipe OD [mm]	3.0 - 38.1	15.0 - 38.1
Pipe OD [inch]	0.118 - 1.500	0.590 - 1.500
Best machining results with tube OD [mm]	15.0	–
Best machining results with tube OD [inch]	0.590	–

Article	Code		kg
Standard Tool holder WH12-I	790 037 152		0.040
Optional Tool holder WH12-I	790 037 154		0.050

Optional Tool holder WH for micro fittings

For multifunctional tool 790 038 314. With Torx screw.

Application range	Optional Tool holder
Micro fittings OD [mm]	3.0 -21.2
Micro fittings OD [inch]	0.118 - 0.835

Article	Code		kg
Optional Tool holder for micro fittings WH12-I	790 037 156		0.100

Multifunctional tool MFW

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

Article	Quantity	Code		kg
Multifunctional tool MFW-P-2	1	790 038 314		0.003
Multifunctional tool MFW-P-2	10	790 038 315		0.045



Tube Squaring Machines

- Squaring tube ends with high-quality surface
- Burr-free and square
- Quick clamping system for tools, clamping shells and tubes
- Preparation of stainless steel tubes
- 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
- Portable and light weight machine for a mobile and secure application

RPG 4.5

Designed for burr-free squaring of thin-walled stainless steel tubes up to OD 114.3 mm (4.5 inch). The cost-effective solution for precise welds conforming to industry standards.
Clean and secure working area with clear view cutting head. Machine with removable bench stand.

Scope of delivery:

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

Electric drive with single-phase AC motor:

Power: 1010 W (1.35 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 8 - 52 rpm

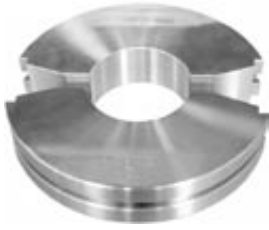
Speed stabilisation



Application range	[mm]	[inch]
Tube OD	12.7 – 114.3	0.500 - 4.500
Wall thickness max.	3.0	0.118

Article	Version	Code		kg
RPG 4.5	200 - 240 V, 50/60 Hz EU	790 038 001		19.400
RPG 4.5	100 - 120 V, 50/60 Hz EU	790 038 003		19.400

Accessories for RPG 4.5



Stainless steel clamping shells

Extremely durable. The two-piece-design with click mechanism ensures accurate centring and quick clamping shell change without any tools. For use on all materials with a OD of 12.0 mm up to 114.3 mm (0.500 - 4.500 inch). Further clamping shell dimensions are available.

Tube OD [mm]	Tube OD [inch]	Code	kg
12.00	0.472	790 038 454	2.170
12.70	0.500	790 038 438	2.177
13.00	0.512	790 038 439	2.176
13.50	0.531	790 038 440	2.175
14.00	0.551	790 038 441	2.174
16.00	0.630	790 038 442	2.168
17.20	0.677	790 038 443	2.164
18.00	0.709	790 038 444	2.161
19.00	0.748	790 038 445	2.150
19.05	0.750	790 038 446	2.157
20.00	0.787	790 038 447	2.153
21.30	0.839	790 038 448	2.100
22.00	0.866	790 038 449	2.144
23.00	0.906	790 038 450	2.140
24.00	0.945	790 038 451	2.133
25.00	0.984	790 038 452	2.127
25.40	1.000	790 038 051	2.100
26.90	1.059	790 038 400	2.090
28.00	1.102	790 038 401	2.110
29.00	1.142	790 038 402	2.105
30.00	1.181	790 038 403	2.095
31.75	1.250	790 038 052	2.090
31.80	1.252	790 038 404	2.080
33.40	1.315	790 038 405	2.040
33.70	1.327	790 038 406	2.060
34.00	1.339	790 038 407	2.040
35.00	1.378	790 038 408	2.050
36.00	1.417	790 038 409	2.044
38.00	1.496	790 038 410	2.025
38.10	1.500	790 038 053	2.020
40.00	1.575	790 038 411	2.000
41.00	1.614	790 038 412	1.990
42.00	1.654	790 038 413	1.976
42.16	1.660	790 038 414	1.950
42.40	1.669	790 038 415	1.965
42.70	1.681	790 038 416	1.950
44.45	1.750	790 038 417	1.955
44.50	1.752	790 038 418	1.955
45.00	1.772	790 038 419	1.948
48.26	1.900	790 038 420	1.880
48.30	1.902	790 038 421	1.905
48.60	1.913	790 038 422	1.875
50.00	1.969	790 038 456	1.880
50.80	2.000	790 038 054	1.895
51.00	2.008	790 038 423	1.870
52.00	2.047	790 038 424	1.850
53.00	2.087	790 038 425	1.835
54.00	2.126	790 038 426	1.827
57.00	2.244	790 038 457	1.780
60.30	2.375	790 038 427	1.700
60.45	2.380	790 038 428	1.726
60.50	2.382	790 038 429	1.695
63.00	2.480	790 038 461	1.688
63.50	2.500	790 038 055	1.670

Tube OD [mm]	Tube OD [inch]	Code	kg
70.00	2.756	790 038 430	1.545
73.03	2.875	790 038 453	1.485
73.15	2.880	790 038 431	1.482
75.00	2.953	790 038 462	1.443
76.10	2.996	790 038 432	1.420
76.20	3.000	790 038 056	1.390
76.30	3.004	790 038 433	1.390
85.00	3.346	790 038 434	1.220
85.90	3.382	790 038 435	1.200
88.90	3.500	790 038 057	1.130
89.10	3.508	790 038 436	1.100
101.60	4.000	790 038 058	0.800
104.00	4.094	790 038 437	0.740
108.00	4.252	790 038 458	0.620
114.30	4.500	790 038 059	0.435

Tool holder WH

For multifunctional tool 790 038 314.
With Torx screw.

Article	Code	kg
Tool holder WH	790 038 320	0.025

Multifunctional tool MFW

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

Article	Quantity	Code	kg
Multifunctional tool MFW-P-2	1	790 038 314	0.003
Multifunctional tool MFW-P-2	10	790 038 315	0.045



Tube Squaring Machines

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

RPG 8.6

Designed for burr-free squaring of thin-walled stainless steel tubes up to OD 219.1 mm (8.6 inch). The cost-effective solution for precise welds conforming to industry standards. Clean and secure working area with clear view cutting head. Machine with removable bench stand.

Scope of delivery:

- 1 Tube Squaring Machine 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 Operating instructions with spare parts list

Electric drive with single-phase AC motor:

Power: 1010 W (1.35 HP)

Protection class II (double insulated)

Built-in electronic variable cutting speed: 7 - 18 rpm

Speed stabilisation

Application range	[mm]	[inch]
Tube OD	50.8 – 219.1	2 – 8.6
Wall thickness max.	3.6	0.142

Article	Version	Code		kg
RPG 8.6	200 - 240 V, 50/60 Hz EU	790 039 001		20.500
RPG 8.6	100 - 120 V, 50/60 Hz EU	790 039 003		20.500



Accessories for RPG 8.6

Clamping shells

Made from aluminum or stainless steel. Extremely durable. The two-piece-design with click mechanism ensures accurate centring and quick clamping shell change without any tools. For use on all materials with a OD of 50.8 - 219.5 mm (2.000 - 8.625 inch). Further clamping shell dimensions are available.



Version	Tube OD [mm]	Tube OD [inch]	Code		kg
Aluminum	101.6	4.000	790 039 252		3.800
Aluminum	114.3	4.500	790 039 256		3.500
Aluminum	141.3	5.563	790 039 257		2.900
Aluminum	152.4	6.000	790 039 253		2.700
Aluminum	168.3	6.625	790 039 254		2.300
Aluminum	219.1	8.625	790 039 255		0.600
Stainless steel	114.3	4.500	790 039 280		4.700
Stainless steel	141.3	5.563	790 039 281		4.500
Stainless steel	152.4	6.000	790 039 283		4.400
Stainless steel	168.3	6.625	790 039 284		4.000
Stainless steel	219.1	8.625	790 039 285		1.500

Tool holder WH

For multifunctional tool 790 038 314.
With Torx screw.



Article	Code		kg
Tool holder WH	790 038 320		0.025

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

Boiler Pipe Preparation Machines

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

BRB 2

Lightweight and robust Boiler Prep Machine. For high-precision and reproducible weld-prep profiles. Simultaneous facing, beveling, counterboring and axial turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®.

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

Scope of delivery:

- 1 Boiler Pipe Preparation Machine BRB 2
- 1 Durable storage and shipping case
- 1 Mandrel
- 3 Clamping sets (Kit 1) or 8 clamping sets (Kit 2)
- 1 Tool retainer
- 1 Cooling and cutting lubrication KSS-TOP (Code 790 060 226)
- 1 Tool set
- 1 Operating instructions with spare parts list

Pneumatic power drive:

Power: 0.38 kW (0.52 HP)

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

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

Application range / Characteristics	BRB 2 Kit 1		BRB 2 Kit 2	
	[mm]	[inch]	[mm]	[inch]
Pipe ID	12.75 - 24.00	0.502 - 0.945	19.05 - 46.00	0.750 - 1.811
Wall thickness with steel	1 - 8	0.039 - 0.315	1 - 8	0.039 - 0.315
Wall thickness with stainless steel (max. OD approx. 40 mm/1.57 inch)	1 - 6	0.039 - 0.236	1 - 6	0.039 - 0.236
Mandrel Ø	12.75	0.502	19.05	0.750
Tool retainer Ø	50 / 19.05	1.97 / 0.75	50 / 19.05	1.97 / 0.75
Article	Version		Code	kg
BRB 2, Kit 1	Pneumatic drive EU		790 085 001	7.700
BRB 2, Kit 2	Pneumatic drive EU		790 085 002	8.400

Retrofit kits for BRB 2

Retrofit kits are available for both basic machines.

Retrofit kit to basic machine 1 consists of:

- 7 Clamping sets
- 1 Mandrel complete with spindle

Retrofit kit to basic machine 2 consists of:

- 2 Clamping sets
- 1 Mandrel complete with spindle

Application range / Characteristics	Retrofit kit for BRB 2 basic machine 1		Retrofit kit for BRB 2 basic machine 2	
	[mm]	[inch]	[mm]	[inch]
Pipe ID	22.10 - 46.00	0.870 - 1.810	12.75 - 21.50	0.500 - 0.850
Mandrel Ø	19.05	0.750	12.75	0.500
Clamping sets [pieces]	7		2	
Article		Code		kg
Retrofit kit for BRB 2, basic machine 1		790 085 006		0.835
Retrofit kit for BRB 2, basic machine 2		790 085 005		0.371

Boiler Pipe Preparation Machines

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



BRB 4

The powerful and durable Boiler Pipe Prep Machine. For high-precision and reproducible weld-prep profiles. Simultaneous facing, beveling, counterboring and axial-turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®. Designed for pipe end preparations and boiler pipe applications. Up to 3 tools can be used at the same time. Pneumatic or electric drive available.

Scope of delivery:

- 1 Boiler Pipe Preparation Machine BRB 4
- 1 Durable storage and shipping case
- 1 Cooling and cutting lubrication KSS-TOP (Code 790 060 226)
- 1 Tool set
- 1 Operating instructions with spare parts list

Additional Scope of delivery		BRB 4 Kit 1	BRB 4 Kit 2	BRB 4 Kit 3	BRB 4 Kit 4	BRB 4 Kit 5
Clamping sets	[pieces]	4	-	-	4	4
		-	3	3	3	3
		-	-	3	-	3
Clamping range	[mm]	19.1 - 33.8	-	-	19.1 - 33.8	19.1 - 33.8
		-	32.0 - 61.7	32.0 - 61.7	32.0 - 61.7	32.0 - 61.7
		-	-	59.4 - 110.8	-	59.4 - 110.8
	[inch]	0.752 - 1.330	-	-	0.752 - 1.330	0.752 - 1.330
		-	1.260 - 2.429	1.260 - 2.429	1.260 - 2.429	1.260 - 2.429
		-	-	2.339 - 4.362	-	2.339 - 4.362
Threaded spindle		M8	M8	M8	M8	M8
Clamping disc Ø	[mm]	18.8	-	-	18.8	18.8
		-	30.0	30.0	30.0	30.0
	[inch]	0.740	-	-	0.740	0.740
Mandrel Ø		-	1.181	1.181	1.181	1.181
	[mm]	19.05	-	-	19.05	19.05
		-	31.50	31.50	31.50	31.50
	[inch]	0.750	-	-	0.750	0.750
		-	1.240	1.240	1.240	1.240
Tool support Ø	[mm]	68 / 19	-	-	68 / 19	68 / 19
		-	68 / 27	-	68 / 27	68 / 27
		-	-	120 / 27	-	120 / 27
	[inch]	2.677 / 0.748	-	-	2.677 / 0.748	2.677 / 0.748
		-	2.677 / 1.063	-	2.677 / 1.063	2.677 / 1.063
		-	-	4.724 / 1.063	-	4.724 / 1.063

Electric drive with single-phase AC motor:

Power: 1.2 kW (1.63 HP)

Protection class II (double insulated)

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

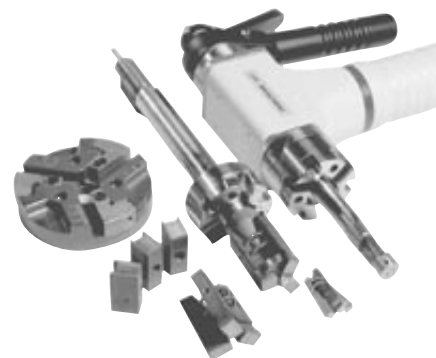
Pneumatic power drive:

Power: 1 kW (1.36 HP)

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

Speed: 50 - 110 rpm

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



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

Article	Version	Code		kg
BRB 4, Kit 1	230 V, 50 Hz EU	790 086 011		15.000
BRB 4, Kit 1	110 V, 50 Hz EU	790 086 021		15.000
BRB 4, Kit 2	230 V, 50 Hz EU	790 086 012		16.000
BRB 4, Kit 2	110 V, 50 Hz EU	790 086 022		16.000
BRB 4, Kit 3	230 V, 50 Hz EU	790 086 013		17.000
BRB 4, Kit 3	110 V, 50 Hz EU	790 086 023		17.000
BRB 4, Kit 4	230 V, 50 Hz EU	790 086 014		18.000
BRB 4, Kit 4	110 V, 50 Hz EU	790 086 024		18.000
BRB 4, Kit 5	230 V, 50 Hz EU	790 086 015		19.000
BRB 4, Kit 5	110 V, 50 Hz EU	790 086 025		19.000
BRB 4, Kit 1	Pneumatic drive EU	790 086 001		14.000
BRB 4, Kit 2	Pneumatic drive EU	790 086 002		15.000
BRB 4, Kit 3	Pneumatic drive EU	790 086 003		17.000
BRB 4, Kit 4	Pneumatic drive EU	790 086 004		16.600
BRB 4, Kit 5	Pneumatic drive EU	790 086 005		18.600

Retrofit kits for BRB 4

Retrofit kits for pneumatic and electric drive consisting of:

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

Article	Code		kg
Kit 1 to Kit 4	790 086 051		2.600
Kit 1 to Kit 3	790 086 052		3.700
Kit 2 to Kit 1 / Kit 3 to Kit 1	790 086 053		1.900
Kit 2 to Kit 3 / Kit 4 to Kit 5	790 086 054		1.900
Kit 1 to Kit 5	790 086 055		4.200
Kit 3 to Kit 2	790 086 056		0.700

Pipe End Preparation Technology

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Accessories for BRB machines

Tool support Ø 90 mm (3.543 inch)

For Mandrel Ø 31.5 mm (1.240 inch)

Article	Code		kg
Tool support Ø 90 mm (3.543 inch)	790 086 207		1.100

Tool holder WH for I-prep

With torx screw.

Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Applicable with BRB type	Height [mm]	Height [inch]	Code		kg
WH5-I	BRB 2	10	0.394	790 085 230		0.005
WH4-I*	BRB 2	10	0.394	790 085 234		0.033
WH12-I	BRB 4	20	0.787	790 086 210		0.035
WH15-I	BRB 4	20	0.787	790 092 202		0.100
WH15-I	BRB 4	27	1.063	790 092 204		0.100

* Special tool holder for facing pipes in pipe plates.

Adjustable tool holder WH for I-prep

Combination possibilities of tool holder and multifunctional tools, see page 49.

Scope of delivery:

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

Article	Applicable with BRB type	Height [mm]	Height [inch]	Code		kg
WH15-I	BRB 4	16.5 - 23	0.650 - 0.906	790 093 410		0.247

Tool holder WH for V- and Y-prep

With Torx screw.

Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Applicable with BRB type	Code		kg
WH5-V-30°	BRB 2	790 085 236		0.015
WH12-V-30°	BRB 4	790 086 214		0.040
WH12-V-37.5°	BRB 4	790 086 216		0.115
WH12-V-80°	BRB 4	790 093 462		0.048
WH12-V-35°	BRB 4	790 086 272		0.100
WH15-V-30°	BRB 4	790 092 210		0.100
WH15-V-37.5°	BRB 4	790 092 216		0.100
WH15-V-60°	BRB 4	790 092 212		0.100

Tool holder WH for U-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Applicable with BRB type	Code		kg
WH5-U-20°	BRB 2	790 085 228		0.014
WH12-U-10°	BRB 4	790 086 208		0.044
WH12-U-20°	BRB 4	790 086 224		0.047
WH12-U-25°	BRB 4	790 086 212		0.051
WH30-U-7°	BRB 4	790 093 408		0.206
WH30-U-10°	BRB 4	790 093 220		0.174
WH30-U-20°	BRB 4	790 093 218		0.184



Tool holder WH for counterboring

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

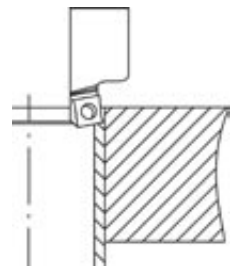
Article	Applicable with BRB type	Code		kg
WH5-ID-14°, 10 mm (0.394") deep	BRB 2	790 085 232		0.017
WH5-ID-14°	BRB 4	790 093 406		0.139
WH5-ID-45°	BRB 4	790 086 218		0.160
WH10-ID-14°	BRB 4	790 093 402		0.170
WH10-ID-14°, 30 mm (1.181") deep	BRB 4	790 093 466		0.155
WH12-ID-10°	BRB 4	790 086 274		0.042



Tool holder WH for cutting tubes from tube sheets

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

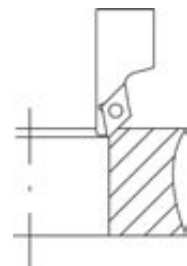
Article	Applicable with BRB type	Code		kg
WH10-ID-80°	BRB 2 / BRB 4	790 086 275		0.075



Tool holder WH for cutting tubes from tube sheets

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Applicable with BRB type	Code		kg
WH5-ID-45°	BRB 2 / BRB 4	790 086 218		0.155



Multifunctional tool MFW

For pipe wall thickness up to 6 mm (0.236 inch)

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

Article	Applicable with WH	Applicable with BRB type	Code		kg
MFW5-V / I-2	WH5-I and WH5-U-20°	BRB 2	790 085 030		0.155





Multifunctional tool MFW

For pipe wall thickness up to 3 mm (0.118 inch)

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

Article	Applicable with WH	Applicable with BRB type	Code		kg
MFW4-I-2	WH4-I-2 (special tool holder)	BRB 2	790 085 031		0.002



Multifunctional tool MFW

For pipe wall thickness 2 up to 15 mm (0.079 - 0.591 inch)

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

Article	For weld prep profiles	Applicable with BRB type	Code		kg
MFW15-V / I-4	V-, Y-, I-preps	BRB 4	790 093 037		0.055

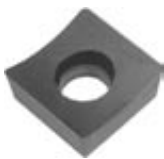


Multifunctional tool MFW

For pipe wall thickness 2 up to 10 mm (0.079 - 0.394 inch)

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

Article	For weld prep profiles	Applicable with BRB type	Code		kg
MFW12-V / I-2	V-, Y-, I- and U-preps with a prep radius 1.2 mm (0.047 inch)	BRB 4	790 086 060		0.025



Multifunctional tools MFW

For counterboring ID

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

Article	Applicable with WH	Applicable with BRB type	Code		kg
MFW5-ID-2-R0.4 (14°)	WH5-ID-14° with a prep radius 0.4 mm (0.016 inch)	BRB 4	790 093 039		0.003
MFW5-ID-2-R0.4 (45°)	WH5-ID-45°	BRB 4	790 086 061		0.002
MFW10-ID-2-R0.4 (80°)	WH10-ID-80°	BRB 4	790 086 062		0.002

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
- Optimised performance and ergonomic drive system
- Portable with an integral carrying handle

REB 6, REB 14, REB 20

The powerful pipe end preparation solution. For high-precision and reproducible weld-prep profiles on high-alloy steel (stainless steel), low-alloy and carbon steel pipes with the unique tool system QTC®. Up to 4 tools can be used at the same time.

Scope of delivery:

- 1 Pipe End Preparation Machine REB 6, REB 14 or REB 20
- 1 Transportation box
- 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 Cooling and cutting lubrication KSS-TOP (Code 790 060 226)
- 1 Operating instructions with spare parts list

Pneumatic power drive:

Power: 1.8 kW (2.45 HP)

Air supply requirement: 2 m³/min at 6 bar (70.6 cfm at 90 PSI)

Nominal speed range: REB 6: 0 - 26 rpm, REB 14: 0 - 13 rpm, REB 20: 0 - 13 rpm

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

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

Power: 1.2 kW (1.63 HP)

Built-in electronic variable cutting speed: REB 6: 10 - 32 rpm, REB 14: 5 - 16 rpm



REB 6 Electric



REB 14 Pneumatic



REB 20 Pneumatic

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

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

Article	Version	Code		kg
REB 6	Pneumatic drive EU	790 093 001		32.000
REB 6	230 V, 50/60 Hz EU	790 093 002		35.000
REB 14	Pneumatic drive EU	790 094 001		61.000
REB 14	230 V, 50/60 Hz EU	790 094 002		64.000
REB 20	Pneumatic drive EU	790 094 010		70.000

Pipe End Preparation Technology

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Accessories for REB machines

Tool holder WH for I-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Height [mm]	Height [inch]	Code		kg
WH15-I	20	0.787	790 092 202		0.100
WH15-I	27	1.063	790 092 204		0.100
WH30-I	20	0.787	790 093 202		0.166
WH30-I	27	1.063	790 093 204		0.235

Adjustable tool holder WH for I-prep

Combination possibilities of tool holder and multifunctional tools, see page 49.

Scope of delivery:

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

Article	Height [mm]	Height [inch]	Code		kg
WH15-I	16.5 - 23	0.650 - 0.906	790 093 410		0.247

Tool holder WH for V- and Y-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Code		kg
WH12-V-80°	790 093 462		0.115
WH15-V-30°	790 092 210		0.100
WH15-V-37.5°	790 092 216		0.100
WH15-V-60°	790 092 212		0.100
WH30-V-15°	790 093 468		0.200
WH30-V-30°	790 093 210		0.192
WH30-V-32.5°	790 093 424		0.234
WH30-V-37.5°	790 093 216		0.199
WH30-V-45°	790 093 404		0.204
WH30-V-25°	790 093 476		0.206

Tool holder WH for U-prep

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Code		kg
WH30-U-7°	790 093 408		0.206
WH30-U-10°	790 093 220		0.174
WH30-U-20°	790 093 218		0.184
WH30-U-14°	790 093 474		0.174
WH30-U-25°	790 093 478		0.165

Tool holder WH for counterboring

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 49.

Article	Code		kg
WH5-ID-14°	790 093 406		0.139
WH5-ID-45°	790 086 218		0.155
WH10-ID-14°	790 093 402		0.160
WH10-ID-14°, 30 mm (1.181 inch) deep	790 093 466		0.170
WH12-ID-10°	790 086 274		0.042



Multifunctional tools MFW

For pipe wall thickness 2 - 30 mm (0.079 - 1.181 inch)

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

Article	For weld prep profiles	Code		kg
MFW30-V / I-4	V-, Y-, I-prep	790 093 033		0.055
MFW30-U-4-R5	I-, V-, Y-, U-prep with a prep radius 5 mm (0.197 inch)	790 093 034		0.055
MFW30-U-4-R2	I-, V-, Y-, U-prep with a prep radius 2 mm (0.079 inch)	790 093 035		0.060



Multifunctional tool MFW

For pipe wall thickness 2 - 15 mm (0.079 - 0.591 inch)

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

Article	For weld prep profiles	Code		kg
MFW15-V / I-4	V-, Y-, I-prep	790 093 037		0.055

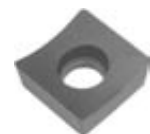


Multifunctional tools MFW

For counterboring

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

Article	Applicable with WH	Code		kg
MFW5-ID-2-R0.4 (14°)	WH5-ID-14° with a prep radius 0.4 mm / 0.016"	790 093 039		0.003
MFW5-ID-2-R0.4 (45°)	WH5-ID-45° with a prep radius 0.4 mm / 0.016"	790 086 061		0.002
MFW10-ID-2-R0.8 (14°)	WH10-ID-14° with a prep radius 0.8 mm / 0.031"	790 093 038		0.002
MFW10-ID-2-R3.0 (14°)	WH10-ID-14° with a prep radius 3.0 mm / 0.118"	790 093 041		0.004





Elbow clamping system

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

Scope of delivery:

- 1 Durable storage and shipping case
- 1 Mandrel with clamping mechanism for elbows
- 1 Straightening tool
- 8 Sets with 3 dimension-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	Pipe ID [mm]	Pipe ID [inch]	Code		kg
for REB 6	155 - 166	6.102 - 6.535	790 093 295		1.300
for REB 14	320 - 339	12.598 - 13.346	790 094 189		3.600
for REB 14	331 - 350	13.031 - 13.780	790 094 190		3.850

Clamping shell segments for REB

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

Scope of delivery:

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

Other dimensions are available.

Article	Pipe ID [mm]	Pipe ID [inch]	Code		kg
for REB 6	108.2 - 110.1	4.260 - 4.335	790 093 297		1.600
for REB 6	147.0 - 149.0	5.787 - 5.866	790 093 298		1.905
for REB 6	161.5 - 162.8	6.358 - 6.409	790 093 452		1.600
for REB 14	161.5 - 162.7	6.358 - 6.406	790 094 202		3.800
for REB 14	211.6 - 213.5	8.330 - 8.406	790 094 206		5.600
for REB 14	250.0	9.843	790 094 208		5.600
for REB 14	264.7 - 266.2	10.421 - 10.480	790 094 210		5.600
for REB 14	314.7 - 315.9	12.390 - 12.437	790 094 222		4.100
for REB 14	342.9	13.500	790 094 226		4.800
for REB 14	347.7	13.689	790 094 224		4.750

Accessories for BRB and REB machines

Mobile air unit DWE 10

Lubricator and air filter adjustable pressure range 0 – 10 bar. Flow max. 2.6 m³/min (92 cfm).

Air inlet side: 1/2" clutch coupling (DIN 3481).

Air outlet side: 1/2" quick coupling.

Suitable for air hose 790 093 061.

Article	Code		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 (15.748 in); ID 19.1 mm (0.752 in).

Air inlet side: 1/2" quick coupling.

Air outlet side: 90° angle screw with 1/2" quick coupling and a nipple to screw into the speed regulation handle on REB or BRB.

Article	Code		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 labelling requirements according to GefStoffV.).

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

Protects against corrosion, even during longer periods of downtime.

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



The different weld prep profiles



Description of the tools made by Orbitalum Tools

Multifunctional tool MFW for working on the pipe OD:

MFW 30-V / I-4-R5

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

Multifunctional tool MFW for working on the pipe ID:

MFW 10-ID-2-R0.8

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

Tool holder WH for beveling:

WH 30-V-30°

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

Tool holder WH for facing:

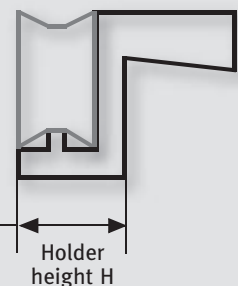
WH 30-I-H27

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

Tool holder WH for counterboring ID:

WH 10-ID-14°

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



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

Code-No.	Tool holder	Torx screw	Multifunctional tool
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Tools for I-seam

790 085 234	WH 4-I	790 085 244	790 085 031 with R 0
790 085 230	WH 5-I	790 093 224	790 085 030 with R 0.4
790 086 210	WH 12-I-H 20 mm	790 086 220	790 086 060 with R 1.2
790 092 202	WH 15-I-H 20 mm	790 093 226	790 093 037 with R 0
790 092 204	WH 15-I-H 27 mm	790 093 226	790 093 037 with R 0
790 093 202	WH 30-I-H 20 mm	790 093 226	790 093 033 with R 0
790 093 204	WH 30-I-H 27 mm	790 093 226	790 093 033 with R 0
790 093 410	WH 15-I-H 16.5-23 mm (adjustable)	790 093 226 / 790 093 425	790 093 037 with R 0

Tools for V- and Y-seam

790 085 236	WH 5-V-30°	790 093 224	790 085 030 with R 0.4
790 086 214	WH 12-V-30°	790 086 220	790 086 060 with R 1.2
790 086 272	WH 12-V-35°	790 086 220	790 086 060 with R 1.2
790 086 216	WH 12-V-37.5°	790 086 220	790 086 060 with R 1.2
790 093 462	WH 12-V-80°	790 086 220	790 086 060 with R 1.2
790 092 210	WH 15-V-30°	790 093 226	790 093 037 with R 0
790 092 216	WH 15-V-37.5°	790 093 226	790 093 037 with R 0
790 092 212	WH 15-V-60°	790 093 226	790 093 037 with R 0
790 093 468	WH 30-V-15°	790 093 226	790 093 033 with R 0
790 093 476	WH 30-V/U-25°	790 093 226	790 093 033 with R 0
790 093 210	WH 30-V-30°	790 093 226	790 093 033 with R 0
790 093 424	WH 30-V-32.5°	790 093 226	790 093 033 with R 0
790 093 216	WH 30-V-37.5°	790 093 226	790 093 033 with R 0
790 093 404	WH 30-V-45°	790 093 226	790 093 033 with R 0
790 093 470	WH 30-V-50°	790 093 226	790 093 033 with R 0
790 093 472	WH 30-V-55°	790 093 226	790 093 033 with R 0

Tools for U-seam

790 085 228	WH 5-U-20°	790 093 224	790 085 030 with R 0.4
790 086 208	WH 12-U-10°	790 086 220	790 086 060 with R 1.2
790 086 224	WH 12-U-20°	790 086 220	790 086 060 with R 1.2
790 086 212	WH 12-U-25°	790 086 220	790 086 060 with R 1.2
790 093 408	WH 30-U-7°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 220	WH 30-U-10°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 474	WH 30-U-14°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 468	WH 30-V/U-15°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 218	WH 30-U-20°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 478	WH 30-U-25°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2

Tools for beveling / counterboring

790 085 232	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 093 406	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 086 218	WH 5-ID-45°	790 093 224	790 086 061 with R 0.4
790 093 402	WH 10-ID-14°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 466	WH 10-ID-14° / 30 mm deep	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 296	WH 10-ID-60°	790 093 224	790 093 039 with R 0.8 / 790 093 041 with R 3
790 086 275	WH 10-ID-80°	790 086 220	790 086 062 with R 0.4
790 086 274	WH 12-ID-10°	790 086 220	790 086 060 with R 1.2

Application range of tool holder for J-prep

	BRB 2 Mandrel-Ø 12.7 WZT-Ø 51	BRB 2 Mandrel-Ø 19 WZT-Ø 51	BRB 4 Mandrel-Ø 19 WZT-Ø 68	BRB 4 Mandrel-Ø 32 WZT-Ø 68	BRB 4 Mandrel-Ø 32 WZT-Ø 90	BRB 4 Mandrel-Ø 32 WZT-Ø 120	REB 4 Mandrel-Ø 25 WZT-Ø 120	REB 6 Mandrel-Ø 25 WZT-Ø 183	REB 14 Mandrel-Ø 25 WZT-Ø 375
Max. ID with a height of land 1 mm (0.039 in)									
Code	DI max. [mm] [inch]	DI min. [mm] [inch]	DI max. [mm] [inch]	DI min. [mm] [inch]	DI max. [mm] [inch]	DI min. [mm] [inch]	DI max. [mm] [inch]	DI min. [mm] [inch]	DI max. [mm] [inch]
790 085 228	34 1.339	15 0.591	38 1.496	21 0.827	-	-	-	-	-
790 093 220	-	-	-	-	-	-	58 2.283	27 1.063	313 12.323
790 093 474	-	-	-	-	-	-	58 2.283	121 4.764	313 12.323
790 093 468	WH 30-V/ U-15°	-	-	-	-	-	58 2.283	121 4.764	313 12.323
790 093 218	WH 30-U-20°	-	-	-	-	-	58 2.283	121 4.764	313 12.323
790 093 478	WH 30-U-25°	-	-	-	-	-	58 2.283	121 4.764	313 12.323
790 093 408	WH 30-U-7°	-	-	-	-	-	58 2.283	121 4.764	313 12.323
790 086 208	WH 12-U-10°	-	-	-	-	-	27 1.063	147 5.787	339 13.346
790 086 224	WH 12-U-20°	-	-	-	-	-	27 1.063	147 5.787	339 13.346
790 086 212	WH 12-U-25°	-	-	-	-	-	27 1.063	147 5.787	339 13.346
Application range of tool bits for J-prep									
790 086 462	15-U-25°-R2	-	-	-	32 1.260	21 0.827	-	54 2.126	34 1.339
790 086 464	20-U-20°-R2	-	-	-	-	-	-	-	-
790 086 466	20-U-25°-R2	-	-	-	-	-	-	-	-

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

Application range of tool holder for counterboring

Counterboring		BRB 2		BRB 2		BRB 4		BRB 4		BRB 4		BRB 4		BRB 4		REB 4		REB 6		REB 14	
		Mandrel-Ø 12.7 WZT-Ø 51	Mandrel-Ø 19 WZT-Ø 51	Mandrel-Ø 19 WZT-Ø 51	Mandrel-Ø 19 WZT-Ø 68	Mandrel-Ø 32 WZT-Ø 68	Mandrel-Ø 32 WZT-Ø 90	Mandrel-Ø 32 WZT-Ø 120	Mandrel-Ø 25 WZT-Ø 120	Mandrel-Ø 25 WZT-Ø 183	Mandrel-Ø 25 WZT-Ø 375										
Workable pipe inner diameter (0.5 mm / 0.020 inch safe distance to mandrel)																					
Code	Description	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI	DI
		max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]	max. [mm] [inch]	min. [mm] [inch]
790 085 232	WH 5-ID-14°/ 10 mm deep (0.394 inch)	38 1.496	27 1.063	38 1.496	36 1.417	55 2.165	36 1.417	42 1.654	77 3.031	107 4.213	42 1.654	112 4.409	38 1.496	170 6.693	53 2.087	350 13.780	77 3.031				
790 086 274	WH 10-ID-10°	53 2.087	38 1.496	53 2.087	44 1.732	70 2.756	43 1.693	56 2.205	92 3.622	122 4.803	56 2.205	127 5.000	49 1.929	185 7.283	66 2.598	350 13.780	87 3.425				
790 093 402	WH 10-ID-14°	*	*	*	*	*	*	*	72 2.835	105 4.134	61 2.402	105 4.134	61 2.402	166 6.535	78 3.071	350 13.780	101 3.976				
790 093 406	WH 5-ID-14°	*	*	*	39 1.535	39 1.535	36 1.417	*	60 2.362	96 3.780	43 1.693	96 3.780	43 1.693	160 6.299	60 2.362	350 13.780	85 3.346				
790 093 466	WH 10-ID-14°/ 30 mm deep (1.181 inch)	*	*	*	*	*	*	*	61 2.402	105 4.134	61 2.402	105 4.134	61 2.402	166 6.535	78 3.071	350 13.780	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	40 1.575	107 4.213	37 1.457	100 3.937	43 1.693	168 6.614	58 2.283	350 13.780	85 3.346				
Application range of tool holder for working tubesheets																					
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	56 2.205	80 3.150	110 4.331	56 2.205	115 4.528	49 1.929	173 6.811	64 2.520	350 13.780	87 3.425				

Abbreviations:

$WH = Tool\ holder$

WZT = Tool support / Tool retainer

* Tool holder cannot be clamped / is not usable

** On diameter 20 mm (0.787 inch): max. length of bevel 4 – 5 mm (0.157 – 0.197 inch).

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

Code	Description (α)	MFW 12-V/I-2-R1.2 790 086 060		MFW 30-U-4-R2 790 093 035		MFW 30-U-4-R5 790 093 034	
		Length of land (X1)					
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
790 085 228	WH 5-U-20°	*	*	*	*	*	*
790 093 218	WH 30-U-20°	*	*	1.4	0.055	0	0
790 093 220	WH 30-U-10°	*	*	2.5	0.098	0.5	0.020
790 093 408	WH 30-U-7°	*	*	3.8	0.150	1.1	0.043
790 093 474	WH 30-U-14°	*	*	2.3	0.091	0	0
790 093 478	WH 30-U-25°	*	*	1.1	0.043	0	0
790 093 468	WH 30-V/U-15°	*	*	Land < 0	Land < 0	Land < 0	Land < 0
790 086 208	WH 12-U-10°	1.5	0.059	*	*	*	*
790 086 212	WH 12-U-25°	1.5	0.059	*	*	*	*
790 086 224	WH 12-U-20°	1.5	0.059	*	*	*	*

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

Code	Description (α)	MFW 12-V/I-2-R1.2 790 086 060		MFW 30-U-4-R2 790 093 035		MFW 30-U-4-R5 790 093 034	
		Length of land (X1)					
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
790 093 408	WH 30-U-7°	*	*	1-7	0.039-0.276	0-2.5	0-0.098
790 093 220	WH 30-U-10°	*	*	0-6	0-0.236	0-3	0-0.118
790 093 474	WH 30-U-14°	*	*	0-6.5	0-0.256	0-1	0-0.039
790 093 218	WH 30-U-20°	*	*	0-5	0-0.197	0-3.5	0-0.138
790 093 478	WH 30-U-25°	*	*	0-5	0-0.197	0-1	0-0.039
790 093 468	WH 30-V/U-15°	*	*	Land < 0	Land < 0	Land < 0	Land < 0
790 086 208	WH 12-U-10°	0-5	0-0.197	*	*	*	*
790 086 224	WH 12-U-20°	0-5	0-0.197	*	*	*	*
790 086 212	WH 12-U-25°	0-5	0-0.197	*	*	*	*

* Multifunctional tool not usable with tool holder

Abbreviations:

WH = Tool holder

WZT = Tool support / Tool retainer



α / Prep Angle

given by the angle of the tool holder WH

R / Radius

given by the radius of the multifunctional tool MFW

X1 / Length of land

from the pipe end to the beginning of the radius



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Tungsten Grinding Technology

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Tungsten Grinder

- No adjustment needs to be done before operation
- Repeatable points every time due preset grinding angles
- Easy and fast to use
- Optimal welding and cutting results through centric and longitudinal grinding

ESG Plus

This ESG Plus is the perfect hand-held grinder for cutting, grinding and planing electrodes which are used in WIG or TIG welding machines.

Consider country-specific regulations, standards and guidelines when using tungsten electrodes with thorium.

Scope of delivery:

- 1 Tungsten Grinder ESG Plus
- 1 Powder-coated carrying steel case
- 1 Diamond grinding wheel (790 052 487)
- 1 Tool to replace the grinding wheel
- 1 Operating instructions with spare parts list

Electric drive with single-phase AC motor:

Power: 500 W (0.68 HP)

Protection class II (double insulated)

Versions: 230 V, 50/60 Hz (110 V, 50/60 Hz on request)

Speed drive: 30.000 rpm

100% power-on time

Application range				ESG Plus
Electrode-Ø [mm]				1.0 / 1.6 / 2.0 / 2.4 / 3.2 / 4.0
Electrode-Ø [inch]				0.040 / 1/16 / 0.080 / 3/32 / 1/8 / 5/32
Grinding angles [°]				15 / 18 / 22.5 / 30
Article	Version	Code		kg
ESG Plus	230 V, 50/60 Hz EU	790 052 485		3.560

Accessories for ESG Plus

Diamond grinding wheels

Exchangeable grinding wheel diamond-coated on both sides for optimal performance.
For 1.9 and 1.6 mm (0.039 and 0.063 inch) electrodes we recommend the standard grinding wheel.

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

* for ESG 4

** for ESG Plus



Cutting device

To cut tungsten electrodes to length.

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

* Other cutting length possible.

Article	Code		kg
Cutting device for ESG Plus	790 052 513		0.030



Electrode holder

Without clamping collet.

Article	Code		kg
Electrode holder	790 052 457		0.023



Clamping collet

To center the electrode in the holder. For easy grinding of smaller electrodes.
Flexible clamping collet for clamping range 1.0 - 3.2 mm (0.039 - 0.126 inch).

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





Wall-/table-/vice-mounting plate

For stationary ESG Plus set-up.

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



Protective cover

Easy to adapt on the ESG Plus head. With integrated retainer for suction units.
For use on electrodes with thorium.

Article	Code		kg
Protective cover	790 052 496		0.220



Double-Decker Kit

Easy to mount to the ESG Plus. Possibility to use 2 different grinding wheels at the same time on one ESG Plus (790 052 488 and 790 052 487 for scrubbing and smoothing).

Article	Code		kg
Double-Decker Kit	790 052 490		0.160



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Accessories for Pipe Threading



Automatic quick-change die-heads ASK

for Withworth pipe threads according to DIN 2999

For threaded pipes according to DIN 2440 and 2441 as well as for stainless steel pipes. Die-heads are equipped with threading chasers made of HSS (high-speed steel). In the factory the die-heads are precision-adjusted to the requirements according to the thread standards. Right-hand.

Die-heads ASK are applicable for:

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

Article	Code		kg
R 1/4	790 003 402		2.220
R 3/8	790 003 403		2.200
R 1/2	790 003 404		2.380
R 3/4	790 003 405		2.400
R 1	790 003 406		2.950
R 1 1/4	790 003 407		2.870
R 1 1/2*	790 003 408		3.165
R 2*	790 003 409		4.055

* not for TGA



Replacement set of threading chasers

for Withworth pipe threads according to DIN 2999

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

Article	Code		kg
R 1/4	790 003 502		0.110
R 3/8	790 003 503		0.100
R 1/2	790 003 504		0.145
R 3/4	790 003 505		0.130
R 1	790 003 506		0.170
R 1 1/4	790 003 507		0.145
R 1 1/2*	790 003 508		0.205
R 2*	790 003 509		0.260

* not for TGA



Replacement set of threading chasers

For pipe threads according to ANSI

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

Article	Code		kg
NPT 1/2	790 003 114		0.140
NPT 3/4	790 003 115		0.130
NPT 1	790 003 116		0.165
NPT 1 1/4	790 003 117		0.140
NPT 1 1/2*	790 003 118		0.195
NPT 2*	790 003 119		0.255

* not for TGA

Replacement set of threading chasers

For pipe threads according to DIN 2440 and 2441

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



Article	Code		kg
G 3/4	790 005 309		0.133
G 1	790 005 310		0.175
G 1 1/4	790 005 311		0.145
G 1 1/2*	790 005 312		0.200
G 1 3/4*	790 005 316		0.291
G 2*	790 005 313		0.200

* not for TGA

Replacement set of threading chasers for GA 2 and SGM 2

for Withworth pipe threads according to DIN 2999

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

Article	Code		kg
R 3/8	790 011 213		0.785
R 1/2	790 011 214		0.720
R 3/4	790 011 215		0.730
R 1	790 011 216		0.720
R 1 1/4	790 011 217		0.660
R 1 1/2	790 011 218		0.630
R 2	790 011 219		0.555

Carrying case for ASK

Large: for 4 die-heads ASK up to R 1.

Small: for 2 die-heads ASK up to R 1 1/2 and R 2.

Article	Version	Code		kg
Carrying case for ASK	large	790 003 200		2.490
Carrying case for ASK	small	790 003 198		2.010



Carrying case for ASK small



Carrying case for ASK large

Nipple holder

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

Article	Thread	Code		kg
DN 15	R 1/2	790 002 101		0.345
DN 20	R 3/4	790 002 102		0.566
DN 25	R 1	790 002 103		0.740
DN 32	R 1 1/4	790 002 104		1.120
DN 40*	R 1 1/2	790 002 105		1.420
DN 50*	R 2	790 002 106		2.120

* not for TGA



Threading, Jointing and Sealing Technology

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Wooden carrying case for nipple holder

For 6 nipple holder with internal clamping from DN 15 up to DN 50.

Article	Code		kg
Wooden carrying case for nipple holder	790 002 107		1.520



Thread cutting compound SPN PARALIQU® PLUS

Pressure absorption capacity 4 times higher than required according to DVGW worksheet W521 – highly increased service life of the chasers.

On synthetical basis for drinking-water installations and for the food industries, conforms to requirements regarding food and beverage stuff legislation set out in DVGW/SGW/ÖVGW, environment friendly – readily biodegradable.

Article	Version	Code		kg
SPN PARALIQU® PLUS	Can with 10 l	790 060 202		11.100
SPN PARALIQU® PLUS, pump sprayer (refillable)	Bottle with 500 ml	790 060 207		0.615



Thread cutting compound NORMOLIC® S

For drinking-water installations according to SVGW regulations.

Article	Version	Code		kg
NORMOLIC® S	Can with 10 l	790 051 263		9.000



Universal fluid QUIETSCH-EX® Spray

Multiple application for lubricating, dissolving rust and dirt as well as protection against corrosion. CFC free.

Article	Version	Code		kg
Universal fluid QUIETSCH-EX® Spray	Can with 250 ml	790 060 222		0.255

Thread Jointing Technology

Thread jointing compound PARALIQ® PM 35

For gas, air and water up to 130 °C.

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



Article	Version	Code		kg
Thread jointing compound PARALIQ® PM 35	Can of 600 g	790 060 102		0.690

Thread sealing tape PARALIQ® PM 35

For gas, air and water up to 130 °C. Synthetical tape.

Approved by the DVGW/SGW/ÖVGW in accordance with DIN EN 751, part 2 (DIN 30 660) in the house installation, especially for drinking-water installations. For use without flax.



Article	Version	Code		kg
Thread sealing tape PARALIQ® PM 35	Roll of 25 m, 16 mm width	790 060 112		0.050

Thread sealing tape SYNTHESOL®

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

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



Article	Version	Code		kg
Thread sealing tape SYNTHESOL®	Roll of 25 m, 16 mm width	790 060 062		0.050

Flax dispenser (retail pack)

Including 10 flax bobbin.

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



Article	Code		kg
Flax dispenser, retail pack of 10 bobbins	790 052 702	*	0.780
Flax dispenser, retail pack of 10 bobbins, set including flax pocket dispenser	790 052 703		1.000

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

Flax dispenser

With fixing plate for mounting on wall or work bench.

Ensures simple using, no waste, optimal proportioning.



Article	Code		kg
Flax dispenser	790 052 701		0.304

Threading, Jointing and Sealing Technology

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Flax bobbin pocket dispenser

For the fitters pocket.

Ensures simple using, no waste, optimal proportioning.

Article	Version	Code		kg
Flax bobbin pocket dispenser	with flax bobbin	790 052 710		0.225
Flax bobbin pocket dispenser	without flax bobbin	790 052 708		0.135

Seals

For gas and water. Approved by the DVGW in accordance with DIN 3535, part 6.

Seals with a special gasket material based on aramide fibres and NBR nitrile rubber. It has an excellent chemical and good dynamical resistance. Material has a wide general application. It is used in gas, food and chemical industry. It is also approved by many institutions: DVGW, KTW, SVGW, WRc, Germanischer Lloyd.

Seal dispenser

With approx. 225 seals. With protective covering.

Article	Code		kg
Seal dispenser	790 052 721		0.682
Seal dispenser, empty	790 052 722		0.335
Protective covering for seal dispenser	790 052 723		0.049

Seals for seal dispenser

IT-seals.

Explanations

R = Raccord (union/fittings)

RV = Radiator-valve

H = Dutchman-seal

HK = Dutchman-seal small

HG = Dutchman-seal large

Article	Dimension	Pieces each package	Code		kg*
R 1/4	10 x 6	100	790 052 726		0.001
R 3/8	14 x 10	100	790 052 727		0.001
R 3/8	15 x 8	100	790 052 728		0.001
R 3/8	15 x 10	100	790 052 729		0.001
R 1/2	18 x 10	100	790 052 730		0.001
R 1/2	18 x 11	100	790 052 731		0.001
R 1/2	18 x 12	100	790 052 732		0.001
R 3/4	23 x 17	100	790 052 733		0.001
R 3/4	24 x 15	100	790 052 734		0.001
R 1	30 x 22	100	790 052 735		0.001
R 1 1/4	37 x 29	100	790 052 736		0.001
R 1 1/4	39 x 32	100	790 052 737		0.001
R 1 1/2	44 x 37	100	790 052 738		0.001
R 2	56 x 48	50	790 052 739		0.002
Leather 3/4	23 x 16	100	790 052 740		0.001
RV 3/4	23 x 17	100	790 052 741		0.001
H 3/4	38 x 27	100	790 052 742		0.002
H 1	44 x 32	100	790 052 743		0.002
H 1 1/4	55 x 42	50	790 052 744		0.004
H 1 1/2	62 x 46	50	790 052 745		0.002
H 2	78 x 60	50	790 052 746		0.007
HK 3/8	24 x 17	100	790 052 747		0.001
HK 1/2	30 x 21	100	790 052 748		0.001
HG 3/8	27 x 19	100	790 052 749		0.001
HG 1/2	34 x 23	100	790 052 750		0.001

* Weight each seal



Notes



Accessories for LAM 1500, LAM 1600

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Cleaning brushes and calibrating tools

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Copper Pipe Installation Technology

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Accessories for LAM 1500, LAM 1600

Clamp holder with carbon V-electrode

Made of stainless steel.

Article	Code		kg
Clamp holder with carbon V-electrode	790 057 020		0.038

Carbon V-electrode

Minimum purchase: 10 pieces

Article	Code		kg
Carbon V-electrode	790 057 025		0.010

Stick electrode

Minimum purchase: 6 pieces

Article	Code		kg
Stick electrode	790 057 026		0.020

Wooden transportation case

Empty. With partition for solder accessories from 8 - 22 mm (0.315 - 0.866 inch).

Article	Code		kg
Wooden transportation case for solder accessories	790 057 005		5.500

Heating tongs with cable

Complete. Cable of 2.7 m (10.630 inch).
Only for LAM 1600.

Article	Code		kg
Heating tongs with cable	790 057 351		2.090

Thawing device

Complete with 2 cables of 5 m (19.685 inch) and 1 permanent switch.
Only for LAM 1600.

Article	Code		kg
Thawing device	790 057 045		4.900

Cleaning brushes and calibrating tools

Cleaning brushes

Metal brushes to clean copper fittings on the inner diameter

Extended service life through high-grade steel alloy.



Pipe ID [mm]	Pipe ID [inch]	Code		kg
10	0.394	790 072 282		0.024
12	0.472	790 072 283		0.025
15	0.591	790 072 285		0.022
18	0.709	790 072 288		0.025
22	0.866	790 072 289		0.027
28	1.102	790 072 290		0.030

Cleaning brushes

Ring brushes to clean copper pipes on the outer diameter

Extended service life through high-grade steel alloy.



Pipe OD [mm]	Pipe OD [inch]	Code		kg
10	0.394	790 072 301		0.021
12	0.472	790 072 302		0.024
15	0.591	790 072 304		0.025
18	0.709	790 072 307		0.032
22	0.866	790 072 308		0.035
28	1.102	790 072 309		0.048

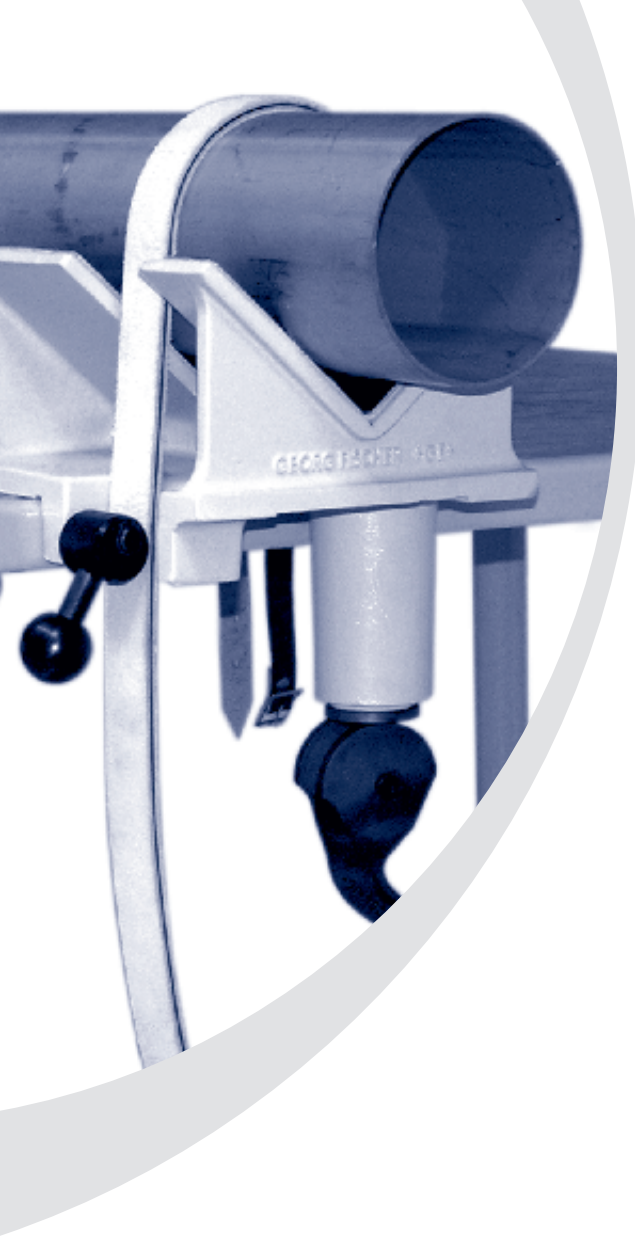
Calibrating tools

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



Pipe OD [mm]	Pipe OD [inch]	Pipe ID [mm]	Pipe ID [inch]	Code		kg
8	0.315	6	0.236	790 072 412		0.065
10	0.394	8	0.315	790 072 414		0.082
12	0.472	10	0.394	790 072 417		0.120
15	0.591	13	0.512	790 072 421		0.175
18	0.709	16	0.630	790 072 427		0.250
22	0.866	20	0.787	790 072 432		0.395
28	1.102	25	0.984	790 072 433		0.691

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Accessories for workshop and site

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Pipe Bending Machine

RBA

Easy and quick manual bending.
Without formers.

Application range		[mm]	[inch]
Pipe OD		6 - 22	0.236 - 0.866
Article	Code		kg
RBA with rubber pressure roller	790 055 003		3.140
RBA with steel pressure roller	790 055 002		3.290

Formers

For half hard and soft copper pipes.
For covered pipes the outside diameter is standard for the size of the former.

Pipe OD [mm]	Pipe OD [inch]	Bending radius [mm]	Bending radius [inch]	Code		kg
8	0.315	28	1.102	790 055 008		0.070
10	0.394	35	1.378	790 055 010		0.077
12	0.472	42	1.654	790 055 012		0.120
14	0.551	49	1.929	790 055 014		0.155
15	0.591	53	2.087	790 055 015		0.163
16	0.630	56	2.205	790 055 016		0.190
17	0.669	60	2.362	790 055 017		0.215
18	0.709	63	2.480	790 055 018		0.210
19	0.748	67	2.638	790 055 019		0.260
20	0.787	70	2.756	790 055 020		0.284
22	0.866	77	3.031	790 055 022		0.345

Special formers

With small bending radius for soft annealed steel pipes and hydraulic pipes.

Pipe OD [mm]	Pipe OD [inch]	Bending radius [mm]	Bending radius [inch]	Code		kg
15	0.591	38	1.496	790 055 038		0.105
18	0.709	45	1.771	790 055 035		0.165
22	0.866	55	2.165	790 055 034		0.485

Accessories for RBA

Steel pressure roller

For pipe OD 6 - 22 mm (0.236 - 0.866 inch).

Article	Code		kg
Steel pressure roller	790 055 030		0.247

Spare rubber pressure roller

Article	Code		kg
Spare rubber pressure roller	790 055 110		0.166

Tool box

Empty. With space for all formers from 6 - 22 mm (0.236 - 0.866 inch).

Article	Code		kg
Tool box	790 055 050		4.850



Accessories for workshop and site

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Work bench large



Collapsible work bench



Work benches, tool box

Work bench

Dismountable.

Small: with 1 tool box support

Large: with 2 tool box supports

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

Article	Code		kg
Work bench, small	790 052 001		64.000
Work bench, large	790 052 004		95.000

Collapsible work bench

Dimensions	Collapsible work bench
[cm]	100 x 70
[inch]	39.37 x 27.56
Load capacity [kg]	650

Article	Code		kg
Collapsible work bench	790 052 030		32.000

Tool box

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

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

Article	Code		kg
Tool box	790 052 101		50.000

Pipe vices, deburring tool

Chain pipe vice

Complete with pipe support.

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

Article	Code		kg
Chain pipe vice	790 052 201		6.200
Spare roller chain	790 052 859		0.870
Bench vice mounting clamp	790 052 204		2.350



Bench vice

For plastic and stainless steel pipes.

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

Article	Code		kg
Bench vice	790 052 231		5.500
Pipe support	790 052 228		0.650
Bench vice mounting clamp	790 052 204		2.350
Belt (930 x 28 mm / 36.6 x 1.1 inch)	790 052 247		0.100



Deburring tool

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

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

Article	Code		kg
Deburring tool	790 052 052		0.455



Accessories for workshop and site

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Notes

Worldwide customer focus

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



Our focus is on our customers.

The Orbitalum Tools staff around the world are highly qualified and motivated to provide you with the best solutions. Our quality management system is also ISO 9001/EN 29001 certified.

Waste disposal / environmental protection



Disposal of electrical (electronic) devices

(RL 2002/96/EC)

Electrical (electronic) devices which are marked with the symbol above, may not be disposed of with household waste in accordance to the EU directive 2002/96/EC.

By actively using the offered return and collection systems, you actively contribute to the reuse, recycling and utilisation of electrical (electronic) devices.

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

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

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

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



Returning of batteries

Some of our products work with batteries.

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

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

Cd = Cadmium

Hg = Mercury

Pb = Lead

Subject to alteration. Please consult our General Conditions of Supply.

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worldwide

Tools for piping systems.

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