

PORTABLE PIPE BEVELING AND CUTTING MACHINES

Made in Germany

- Low weight due to aluminium construction
- Developed and constructed by German boiler manufacturers with "on-site know-how"
- Flexible and reliable use on-site
- Easy and fast operating and clamping



Pipe beveling



Pipe cutting



Boiler wall beveling



Boiler wall cutting

TECHNICAL DATA

We are quite prepared to assist you in solving your specific machining problems. Please give us the following information, as appropriate:

- Tube dimensions (diameter and wall thickness) and material
- Desired machining operations and/or forms of weld
- Other conditions, including drawing or sketch, if possible

	Pipe beveling machines (internal clamping)				Pipe beveling machines (external clamping)					
Unit Type	MF3iw	MF3i	MF5i	MF6i-50	MF3-R	MF4-R	MF2-25	MF3-K	MF3-25	MF4
Tube outside diameter (mm)	max. 101,6	max. 160	max. 460	max. 711	12 - 44,5	44,5 - 88,9	20 - 38	20 - 63,5	20 - 63,5	38 - 133
Tube outside diameter (inch)	max. 4	max. 6,3	max. 18,1	max. 28	0,5 - 1,75	1,75 - 3,5	0,8 - 1,5	0,8 - 2,5	0,8 - 2,5	1,5 - 5,3
Tube inside diameter (mm)	16,2 - 96	25 - 152	100 - 448	280 - 700	min. 9	min. 30	min. 12,5	min. 12,5	min. 12,5	min. 25
Tube outside diameter (inch)	0,6 - 3,8	1 - 6	3,9 - 17,6	11 - 27,5	min. 0,4	min. 1,2	min. 0,5	min. 0,5	min. 0,5	min. 1
Tube wall thickness (mm)	max. 15	max. 25	max. 30	max. 36	max. 10	max. 10	max. 15	max. 15	max. 15	max. 25
Spindle stroke (mm)	20	15	30	50	15	15	25	15	25	15
Weight (kg)	5,8	10,3	23,8	79	4,8	6,2	5,6	7,1	8,6	12
Pneumatic motor (kW)	0,74	0,74	2 x 0,74	3 x 0,74	0,74	0,74	0,74	0,74	0,74	0,74
Electric motor (kW)	1,2	1,2	2,2	/	1,2	1,2	1,2	1,2	1,2	1,2
Geared air motor	●	●	●	●	●	●	●	●	●	●
Geared electric motor	○	○	○		○	○	○	○	○	○
Angle air motor		○	○					○	○	○
Angle electric motor		○						○	○	○

● Standardversion ○ Available special version

Pipe cold cutting system

Type	3 - 6	4 - 8	5 - 10	6 - 12	8 - 14	10 - 16	12 - 18	14 - 20	20 - 24	26 - 30	32 - 36	36 - 43	40 - 48
Pipe outside-Ø (mm)	76,2 - 152,4	101,6 - 203,2	127 - 254	152,4 - 304,8	203,2 - 355,6	254 - 406,4	304,8 - 457,2	355,6 - 508	508 - 609,6	660,4 - 762	812,8 - 914,4	914,4 - 1092,2	1016 - 1219,2
Wall thickness (mm)	No limit												
Rpm (min ⁻¹)	27	23	20	27	25	23	20	26	23	25	22	19	22
A (mm)	308	360	414	465	496	547	602	649	750	920	1068	1250	1420
B (mm)	180	232	286	337	368	419	470	521	622	775	928	1105	1245
C (mm)	88,5	88,5	88,5	88,5	88,5	88,5	88,5	88,5	88,5	88,5	88,5	88,5	95
D (mm)	65	65	65	65	65	65	65	65	65	74	74	74	89
E (mm)	127	127	127	127	127	127	127	127	127	136	136	136	151

Boiler wall cutting system

Type	MF BWC 1DL
Power (W)	3500
Wall diameter (mm)	63,5
Standard rail length (mm)	4500
Speed (1/min)	4000

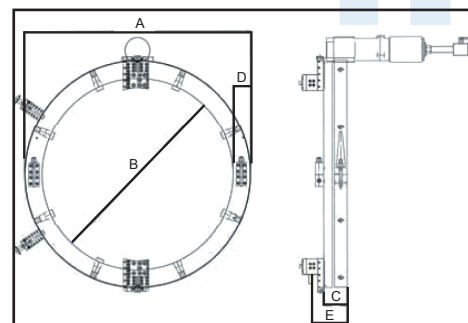


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TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling
- Low price at high quality



MF3-R

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

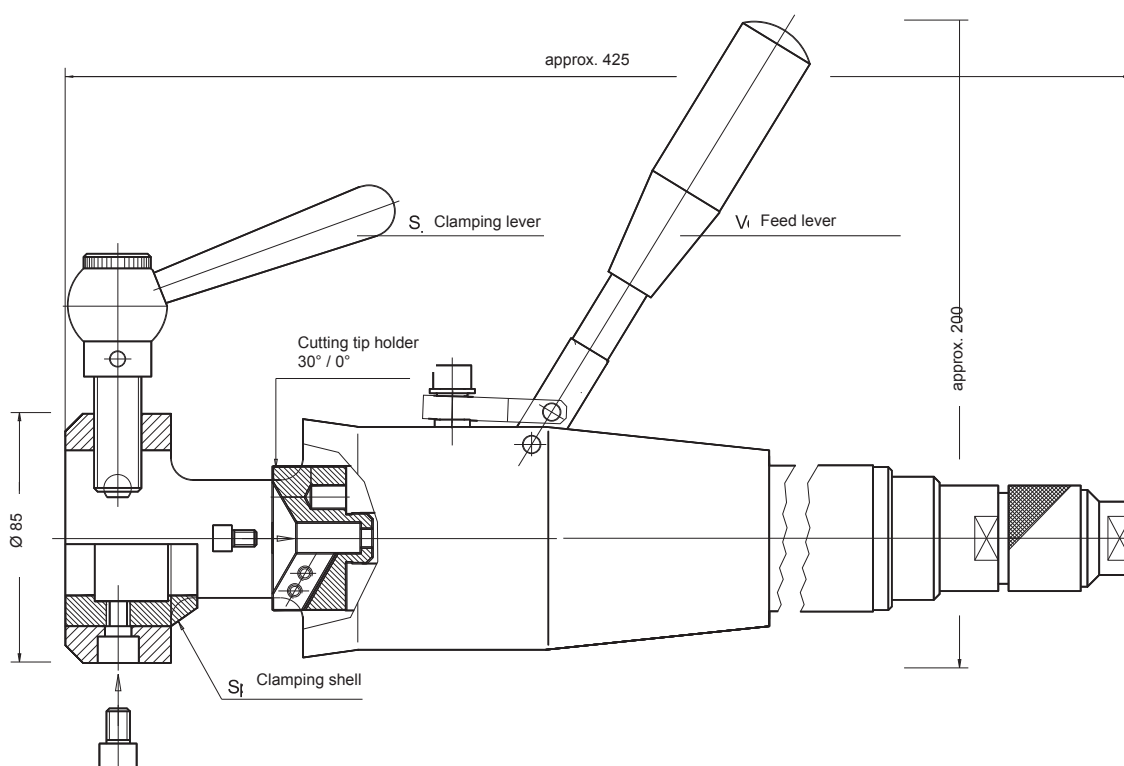
Tube outside diameter:	min. 12,0 mm max. 44,5 mm
Tube wall thickness:	max. 10,0 mm
Spindle stroke:	15,0 mm
Form of weld:	I, V or special form

Compressed air gear motor:

Power:	740 W at 6 bar
Air consumption:	0,96 m³/min
Compressed air connection:	R 1/4"
Feed:	manual
Weight:	4,8 kg

FORM OF WELD

FORM I	FORM V	SPECIAL FORM



CUTTING TOOLS

for the tube end milling unit Type **MF3-R**



091501105
HSS
Cutting tool tip 0°



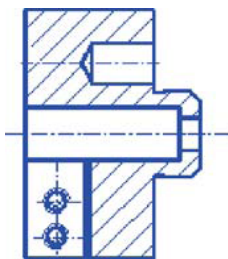
091501028
HSS
Cutting tool tip 30°



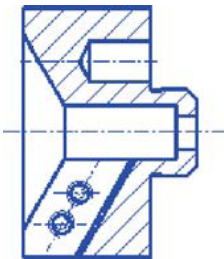
091501106
HSS
Cutting tool tip 0° (TIN)



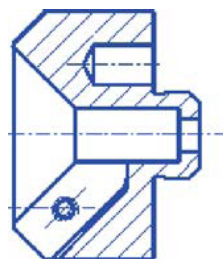
091501108
HSS
Cutting tool tip 30° (TIN)



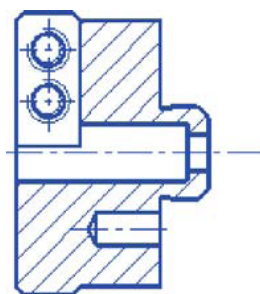
091502825
Tool tip holder 0°



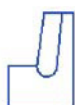
091502824
Tool tip holder 30°



091502999
Tool tip holder 45°



091502870
Blade holder for
special blades



Various special blades on request!

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF4-R

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working Range:

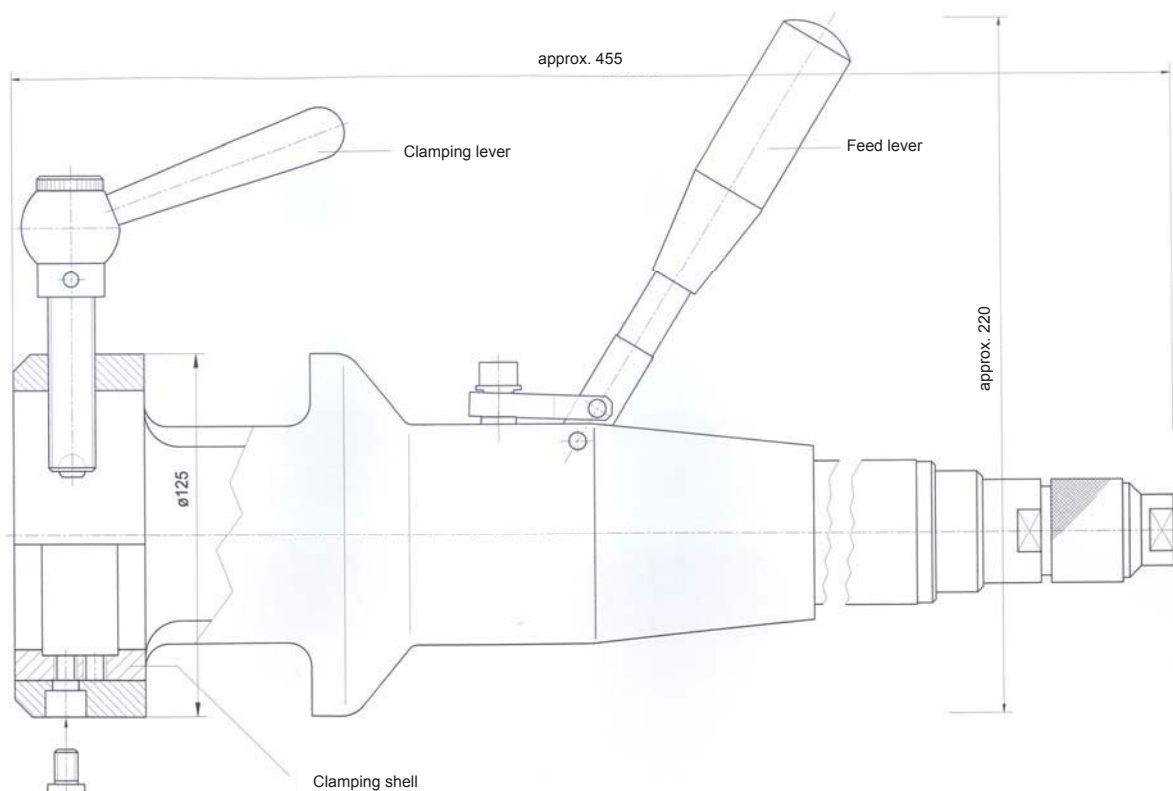
Tube outside diameter:	min. 48,3 mm max. 88,9 mm
Tube wall thickness:	max. 10,0 mm
Spindle stroke:	15,0 mm
Form of weld:	I, V or special form

Compressed air gear motor:

Power:	740 W at 6 bar
Air consumption:	0,96 m ³ /min
Compressed air connection:	R 1/4"
Feed:	manual
Weight:	5,3 kg

Electric geared motor:

Power consumption / connection voltage: 1200 W with 230V - 50Hz
 ~(singlephase - alternating current) II - all-insulated
 Protective class



BLADE & TOOL TIP HOLDER

with adjustable cutting tools for tube end milling unit Type **MF4-R**



091501105
HSS
Cutting tool tip 0°



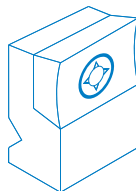
091501028
HSS
Cutting tool tip 30°



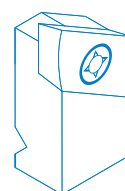
091501106
HSS
Cutting tool tip 0° (TIN)



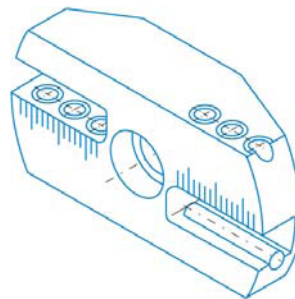
091501108
HSS
Cutting tool tip 30° (TIN)



091502138
Cutting tool tip holder 0°



091502136
Cutting tool tip holder 30°



091502118
Adjustable blade holder size 1
Working range: di 25 - do 88,9 mm



091502141
HSS-blade 0°



091502140
HSS-blade 30°



091502162
10° - internal



091502163
8° - internal



091502135
10° - internal



091502160
DIN 2559-4



091502148
DIN 2559-3



091502154
DBS 34-R3



091502159
DBS 34-R5

Various special blades on request!

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and extreme compact design
- Easy handling
- Membranewall cutting down to Ø 20,0 mm



MF2-25

Field of application

The machine serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of a very rugged design. Operated by one man only it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working Range:

Tube outside diameter:	min. 20 mm max. 38 mm
Tube inside diameter:	min. 8 mm
Tube wall thickness:	max. 15 mm
Minimum width of membrane wall ports:	37 mm
Form of weld:	I, V or special form
Feed:	manual
Spindle stroke:	25 mm

Weight:

with pneumatic drive:	approx. 5,6 kg
with electric drive:	approx. 7,1 kg

Pneumatic geared motor:

Power:	740 W at 6 bar 400 W at 4 bar
Operating pressure:	6 - 7 bar
Air consumption:	0,96 m ³ /min
Compressed air connection:	R 1/4"

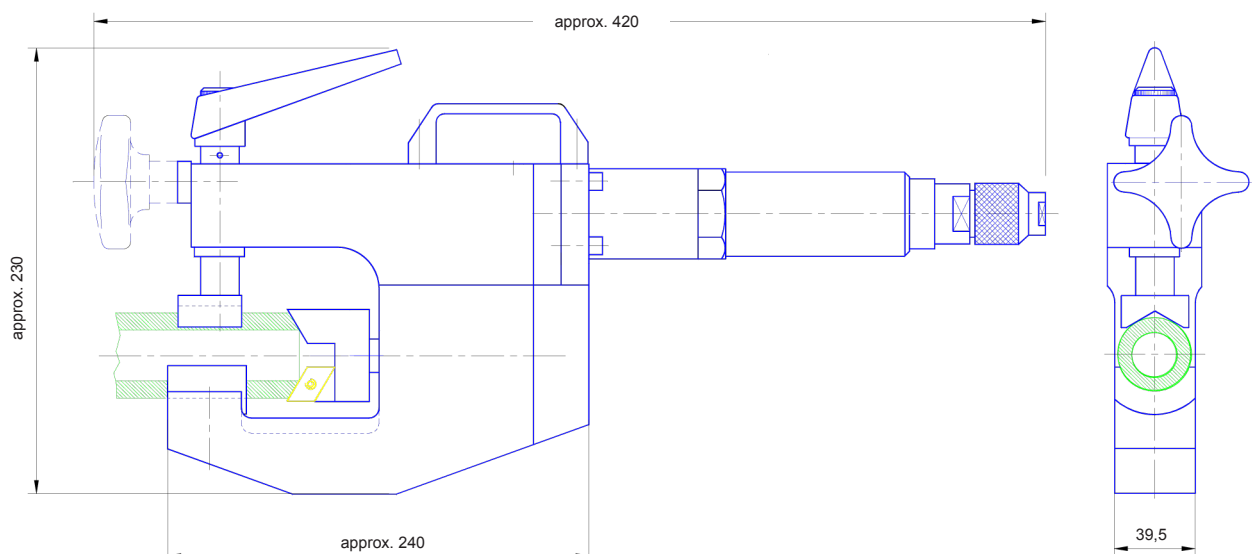
Electric geared motor:

Power consumption/Connection voltage:
abt. 1200W with 230 V

~ (singlephase-alternating current)
Protective class
II – all-insulated

The big advantage of this machine is that membrane walls down to a size of Ø 20mm can be bevelled with tool tip crown milling heads. The minimum membranewall width is only 37,0 mm.

MF2-25



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SPECIAL TOOL TIP HOLDERS

for tube end milling unit Type **MF2-25**



091501105
HSS

Cutting tool tip holder 0°



091501028
HSS

Cutting tool tip holder 30°



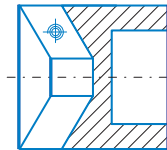
091501106
HSS

Cutting tool tip holder 0° (TIN)

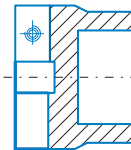


091501108
HSS

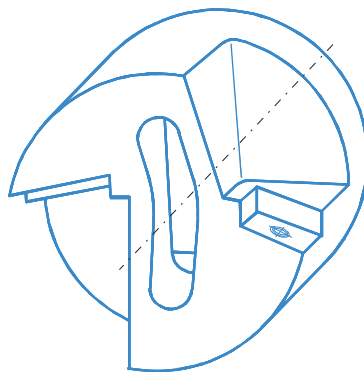
Cutting tool tip holder 30° (TIN)



091503868
Cutting tool tip holder 30°
(Ø 20 - Ø 38)



091504432
Cutting tool tip holder 0°
(Ø 20 - Ø 38)



MEMBRANE WALL MACHINING

with crown milling cutters

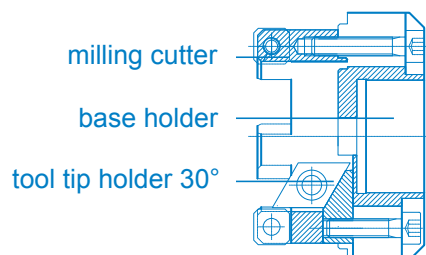
Made in Germany

For tube end milling unit MF2-25

- High cutting capacity
- Tool tips can be used twiced
- Easy to change on site
- Modular designed for different tube dimensions



After the formerly offered fullsteel crown milling cutters we can now offer after two years of test experience on site a new type of crown milling cutters. The tool is equipped with tool tips to cut of the bars between the tubes of the panel wall and in the same step to bevel the tube end.



It is mainly consisting of:

- 1 base holder for each machine type
 - 1 tool tip milling cutter for each diameter
 - 2 tool tip holder 30° are for all diameters identical.
- Tool tips and screws are identical as well for all applications.

TOOL TIP CROWN MILLING CUTTER

Survey MF2-25

Tube - Ø	All necessary parts for one complete unit					Spare parts			
	1	2	3	4	5	6	7	8	9
						Holding-down bolts			
	TT crown milling cutter with kinox screws M4 and 4 srews M5x25	TT 0° Art.-No.: 91502494 Number	Basic holder (compl. thread-pin M8 x 10)	TT-tool tip holder 30° 2 pieces per crown milling cutters	TT 30° for tool tip holder 1 pcs. per TT-holder	Knox screws M4 (TT) 1 pcs. per TT	Screw M5 x 20 4 pcs.	Screw M5 x 20 1 pcs. per TT-holder	Thread-pin M8 x 10 1 pcs. per basic holder
(mm)	(Art.-No.)	(Pieces)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)
MF2-25									
20,0	091503973	4	091503974	091502483 compl. with 1 Knox screw M4 and 1 screw M5 x 20	091502495	091502468	000488737	000983010	091500642
21,3	091503972	4							
25,0	091503971	6							
26,9	091503969	6							
28,6	091504440	6							
30,0	091502588	6							
31,8	091502484	6							
33,7	091502467	6							
35,0	091502485	6							
38,0	091502457	6							

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF3-25

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

Tube outside diameter:	min. 20 mm max. 63,5 mm
Inside tube diameter:	min. 12,5 mm
Tube wall thickness:	max. 15 mm
Form of weld:	I, V or special form
Minimum width of membrane wall ports:	56 mm

Feed:	manual
Spindle stroke:	25 mm

Weight:

with pneumatic drive:	approx. 8,8 kg
with electric drive:	approx. 10,3 kg

Pneumatic geared motor:

Power:	740 W at 6 bar 400 W at 4 bar
Operating pressure:	6 - 7 bar
Air consumption:	0,96 m³/min
Compressed air connection:	R 1/4"

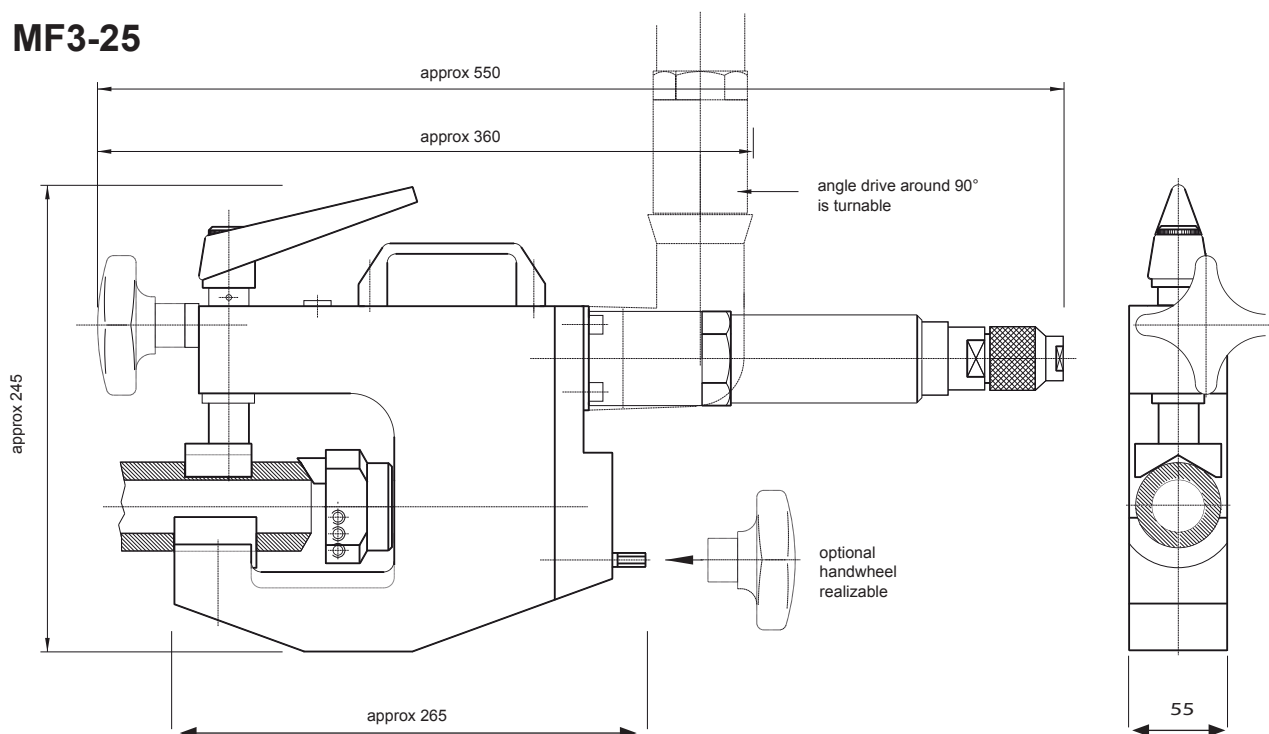
Electric geared motor:

Power consumption/Connection voltage:
abt.1200W with 230 V

~ (singlephase-alternating current)
Protective class
II – all-insulatet

Besides the conventional design in which the motor and the milling spindle are arranged in line, the unit is on request provided with an angle drive. Therefore, it can be used in special situations if for limited space applications if a short overall length is required.

MF3-25



BLADE & TOOL TIP HOLDER

with adjustable holder for tube end milling type **MF3-25**



091501105
HSS
Cutting tool tip 0°



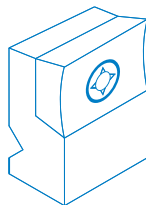
091501028
HSS
Cutting tool tip 30°



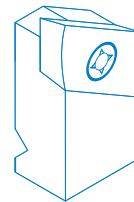
091501106
HSS
Cutting tool tip 0° TIN



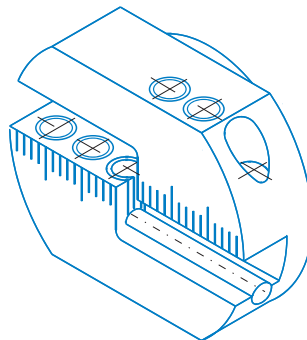
091501108
HSS
Cutting tool tip 30° TIN



091502138
Cutting tool tip holder 0°



091502136
Cutting tool tip holder 30°



Adjustable blade holder
091502121
Standard blade holder



091502141
HSS blade 0°



091502140
HSS blade 30°



091502162
10° - internal



091502163
8° - internal



091502135
10° - internal



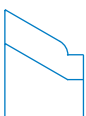
091502160
DIN 2559-4



091502148
DIN 2559-3



091502154
DBS 34-R3



091502159
DBS 34-R5

Various special blades on request!

SPECIAL TOOL TIP HOLDERS

for tube end milling unit type **MF3-25**



091501105
HSS
Cutting tool tip 0°



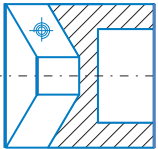
091501028
HSS
Cutting tool tip 30°



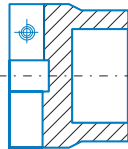
091501106
HSS
Cutting tool tip 0° (TIN)



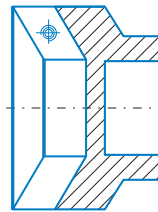
091501108
HSS
Cutting tool tip 30° (TIN)



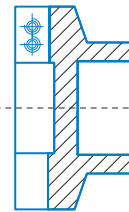
091501029
Cutting tool tip holder 30°
(Ø 20 - Ø 44,5)



091501031
Cutting tool tip holder 0°
(Ø 20 - Ø 44,5)



091501030
Cutting tool tip holder 30°
(Ø 35 - Ø 63,5)



091501032
Cutting tool tip holder 0°
(Ø 30 - Ø 63,5)

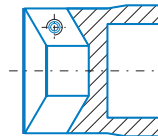
With small cutting tool tips



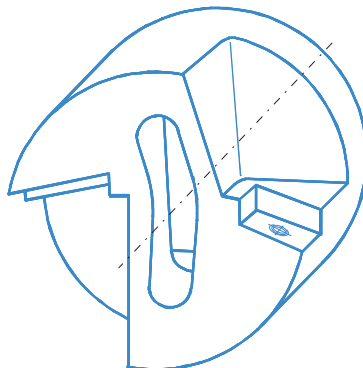
091500591
HSS
Tool tip holder 30° (small)
(TIN)



091500592
HSS
Tool tip holder 30° (small)
(TIN)



091500586
Cutting tool tip holder 30°
(Ø 16 - Ø 38)



MEMBRANE WALL MACHINING

with crown milling cutters

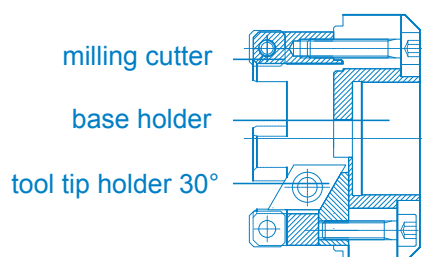
Made in Germany

For tube milling unit MF3-25 and MF4

- High cutting capacity
- Tool tips can be used twiced
- Easy to change on site
- Modular designed for different tube dimensions



After the formerly offered fullsteel crown milling cutters we can now offer after two years of test experience on site a new type of crown milling cutters. The tool is equipped with tool tips to cut of the bars between the tubes of the panel wall and in the same step to bevel the tube end.



It is mainly consisting of:

- 1 base holder for each machine type
- 1 tool tip milling cutter for each diameter
- 2 tool tip holder 30° are for all diameters identical. Tool tips and screws are identical as well for all applications.

TOOL TIP CROWN MILLING CUTTER

Survey MF3-25 / MF4

Tube - Ø	All necessary parts for one complete unit					Spare parts			
	1	2	3	4	5	6	7	8	9
	TT crown milling cutter with knox screws M4 and 4 srews M5x25	TT 0°	Basic holder	TT-tool tip holder 30°	TT 30° for tool tip holder	Knox screws M4 (TT)	Holding-down bolts		
		Art.-No.: 91502494 Number	(compl. thread-pin M8 x 10)	2 pieces per crown milling cutters	1 pcs. per TT-holder		Screw M5 x 20	Screw M5 x 20	Thread-pin M8 x 10
(mm)	(Art.-No.)	(Pieces	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-Nr.)	(Art.-No.)
MF3-25									
30,0 31,8 33,7 35,0 38,0 42,4 44,5 48,3	091502588 091502484 091502467 091502485 091502457 091502486 091502487 091502488	6 6 6 6 6 6 6 8	091502458 (Gr. 1) oder 091502460 (Gr. 2)	091502483 compl. with 1 Knox screw M4 and 1 screw M5 x 20	091502495	091502468	000488737	000983010	091500642
51,0 57,0 60,3 63,5	091502489 091502459 091502490 091502491	8 8 8 10	091502460 (Gr. 2)						
MF4									
44,5 48,3 51,0 57,0 60,3 63,5 70,0 76,1	091502487 091502488 091502489 091502459 091502490 091502491 091502492 091502493	6 8 8 8 8 10 10 10	091502479	091502483 compl. with 1 Knox screw M4 and 1 screw M5 x 20	091502495	091502468	000488737	000983010	091500642

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF4

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

Tube outside diameter:	min. 38 mm max. 133 mm
Inside tube diameter:	min. 26 mm
Tube wall thickness:	max. 25 mm
Form fo weld:	I, V or special form
Minimum width of membrane wall ports:	80 mm

Feed:	manual
Spindle stroke:	25 mm

Weight:

with pneumatic drive:	approx. 13,0 kg
with electric drive:	approx. 14,5 kg

Pneumatic geared motor:

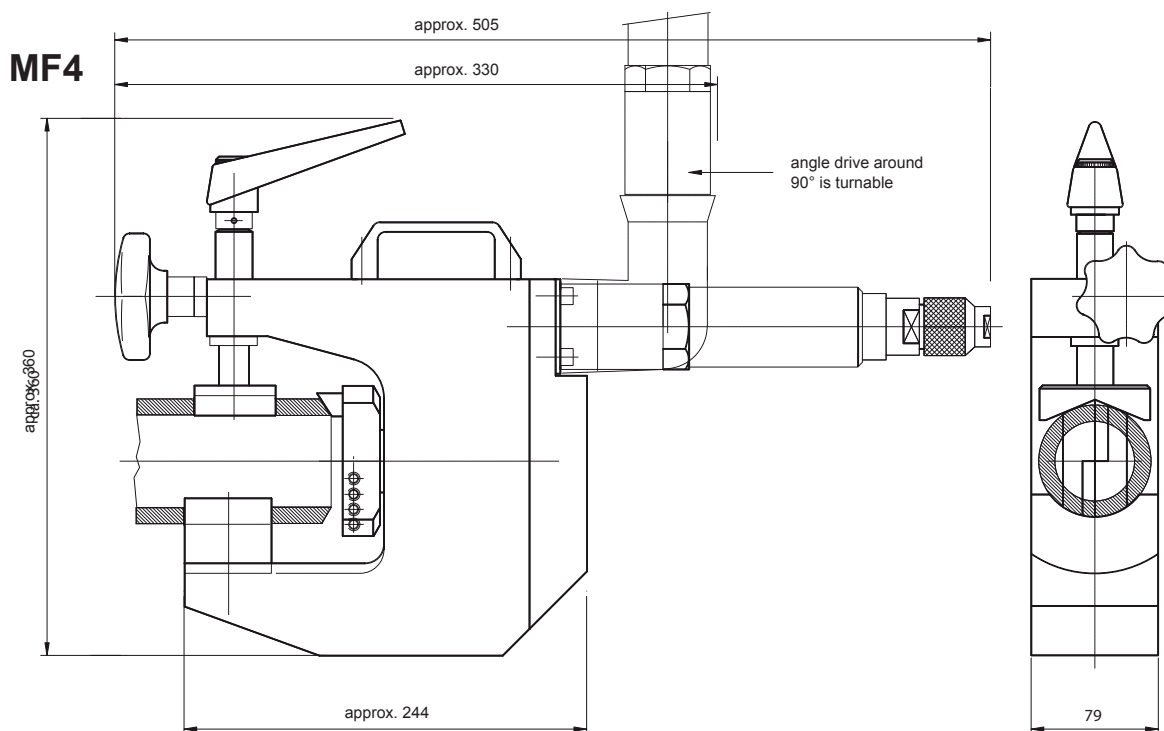
Power:	ca. 740 W bei 6 bar
Operating pressure:	6 - 7 bar
Air consumption:	0,96 m³/min
Compressed air connection:	R 1/4"

Electric geared motor:

Power consumption/Connection voltage:
abt.1200W with 230 V

~ (singlephase-alternating current)
Protective class
II – all-insulatet

Besides the conventional design in which the motor and the milling spindle are arranged in Line, the unit is on request providet with an offset drive. Thus, it can also be used in special Situations where a particulary short overall length is required.



BLADE & TOOL TIP HOLDER

with adjustable cutting tools for tube end milling unit type **MF4**



091501105
HSS
Cutting tool tip 0°



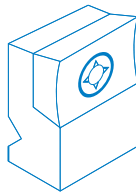
091501028
HSS
Cutting tool tip 30°



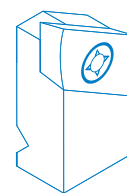
091501106
HSS
Cutting tool tip 0° (TIN)



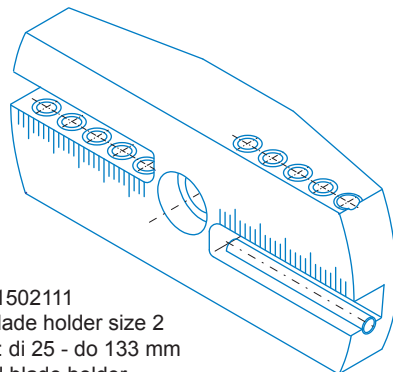
091501108
HSS
Cutting tool tip 30° (TIN)



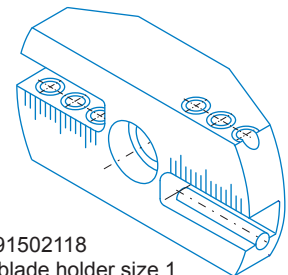
091502138
Cutting tool tip holder 0°



091502136
Cutting tool tip holder 30°



091502111
Adjustable blade holder size 2
working range: di 25 - do 133 mm
Standard blade holder



091502118
Adjustable blade holder size 1
working range: di 25 - do 88,9 mm



091502141
HSS blade 0°



091502140
HSS blade 30°



091502162
10° - internal



091502163
8° - internal



091502135
10° - internal



091502160
DIN 2559-4



091502148
DIN 2559-3



091502154
DBS 34-R3



091502159
DBS 34-R5

Various special blades on request!

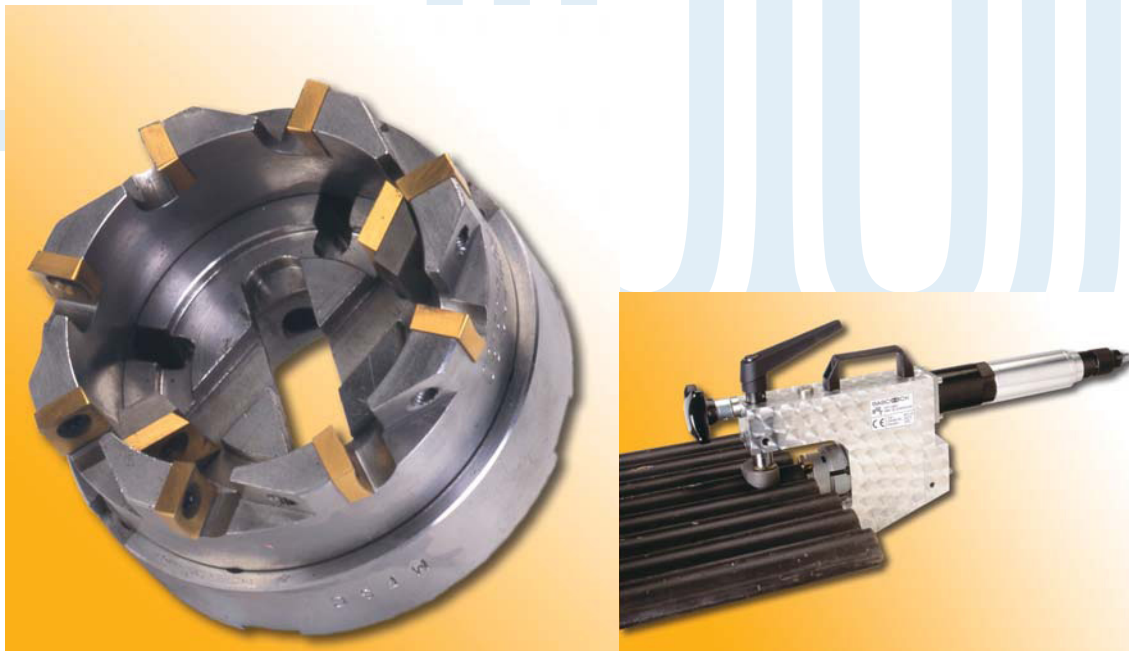
MEMBRANE WALL MACHINING

with crown milling cutters

Made in Germany

For tube milling unit MF3-25 and MF4

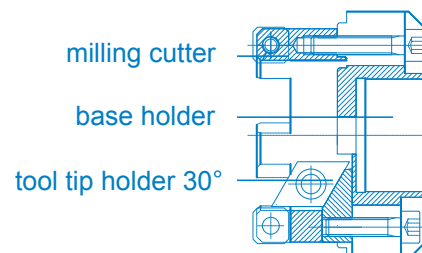
- High cutting capacity
- Tool tips can be used twiced
- Easy to change on site
- Modular designed for different tube dimensions



After the formerly offered fullsteel crown milling cutters we can now offer after two years of test experience on site a new type of crown milling cutters. The tool is equipped with tool tips to cut of the bars between the tubes of the panel wall and in the same step to bevel the tube end.

It is mainly consisting of:

- 1 base holder for each machine type
- 1 tool tip milling cutter for each diameter
- 2 tool tip holder 30° are for all diameters identical.
Tool tips and screws are identical as well for all applications.



TOOL TIP CROWN MILLING CUTTER

Survey MF3-25 / MF4

Tube - Ø	All necessary parts for one complete unit					Spare parts			
	1	2	3	4	5	6	7	8	9
	TT crown milling cutter with knox screws M4 and 4 srews M5x25	TT 0°	Basic holder	TT-tool tip holder 30°	TT 30° for tool tip holder	Knox screws M4 (TT)	Holding-down bolts		
Art.-No.: 91502494		(compl. thread-pin M8 x 10)	2 pieces per crown milling cutters	1 pcs. per TT-holder	1 pcs. per TT		Screw M5 x 20	Screw M5 x 20	Thread-pin M8 x 10
Number						4 pcs.	1 pcs. per TT-holder	1 pcs. per basic holder	
(mm)	(Art.-No.)	(Pieces	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-No.)	(Art.-Nr.)	(Art.-No.)
MF3-25									
30,0	091502588	6	091502458 (Gr. 1) oder 091502460 (Gr. 2)	091502483 compl. with 1 Knox screw M4 and 1 screw M5 x 20	091502495	091502468	000488737	000983010	091500642
31,8	091502484	6							
33,7	091502467	6							
35,0	091502485	6							
38,0	091502457	6							
42,4	091502486	6							
44,5	091502487	6							
48,3	091502488	8							
51,0	091502489	8	091502460 (Gr. 2)						
57,0	091502459	8							
60,3	091502490	8							
63,5	091502491	10							
MF4									
44,5	091502487	6	091502479	091502483 compl. with 1 Knox screw M4 and 1 screw M5 x 20	091502495	091502468	000488737	000983010	091500642
48,3	091502488	8							
51,0	091502489	8							
57,0	091502459	8							
60,3	091502490	8							
63,5	091502491	10							
70,0	091502492	10							
76,1	091502493	10							

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF3iw

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

Tube outside diameter:	min. 18 mm max. 101,6 mm
Tube wall thickness:	max. 15 mm
Form of weld:	I, V or special form
Spindle stroke:	20 mm

Clamping range:

Tube inside diameter:	min. 16,2 mm max. 96 mm
Feed:	manual

Weight:

with pneumatic drive:	approx. 5,5 kg
with electric drive:	approx. 7,0 kg

Pneumatic geared motor:

Power:	740 W at 6 bar 400 W at 4 bar
Operating pressure:	6 - 7 bar
Air consumption:	0,96 m³/min
Compressed air connection:	R 1/4"

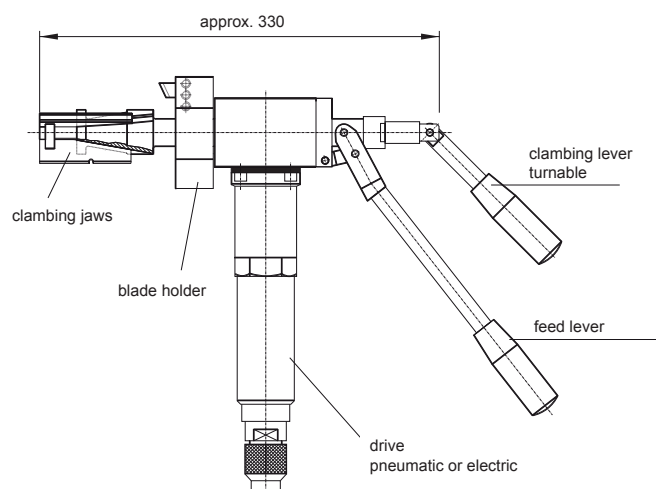
Electric geared motor:

Power consumption/Connection voltage:
abt. 1200W with 230 V

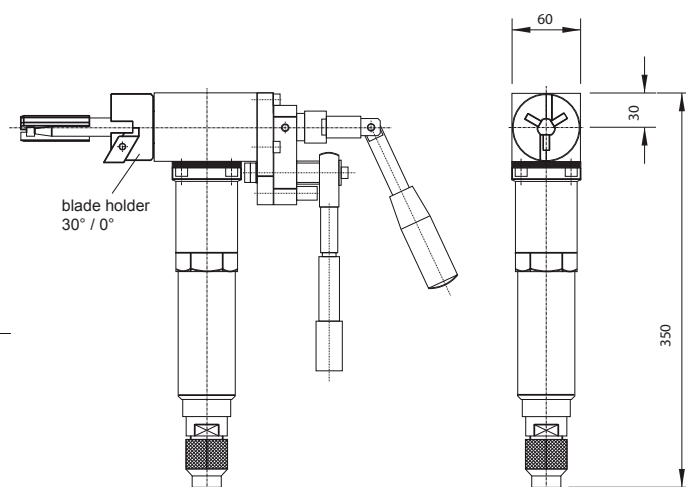
~ (singlephase-alternating current)
Protective class
II – all-insulated

The standard version comes with levers for clamping and feeding. An extra version with a ratchet for clamping and feeding is also available.

MF3iw with feed lever



MF3iw with ratchet feed



BLADE & TOOL TIP HOLDER

with adjustable tools for tube end milling unit type **MF3iw**



091501105
HSS
Cutting tool tip 0°



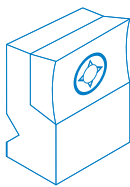
091501028
HSS
Cutting tool tip 30°



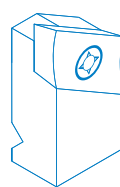
091501106
HSS
Cutting tool tip 0° (TIN)



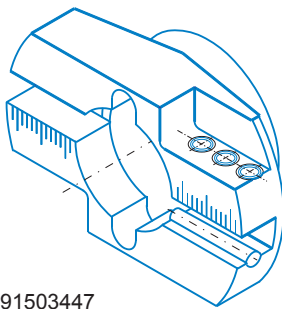
091501108
HSS
Cutting tool tip 30° (TIN)



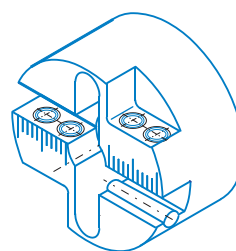
091502138
Cutting tool tip holder 0°



091502136
Cutting tool tip holder 30°



091503447
Universal blade holder
(Outside-Ø 101,6 mm)
(Standard blade holder)



091502166
Blade holder
for the clamping size 1
(Outside-Ø 62 mm)



091502141
HSS blade 0°



091502140
HSS blade 30°



091502162
10° - internal



091502163
8° - internal



091502135
10° - internal



091502160
DIN 2559-4



091502148
DIN 2559-3



091502154
DBS 34-R3



091502159
DBS 34-R5

Various special blades on request!

Blade holder can be used only with sleeve size 2 and system clamping set.

Blade holder can be used only with clamping sleeve size 1.

TOOL TIP HOLDER

for tube end milling unit type **MF3iw**

Cutting tool tip holder 0°



091501105
HSS

Cutting tool tip 0°



091501106
HSS

Cutting tool tip 0° (TIN)

Cutting tool tip holder 30°



091501028
HSS

Cutting tool tip 30°



091501108
HSS

Cutting tool tip 30° (TIN)

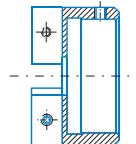
Cutting tool tip holder 45° - internal



091501187
HSS

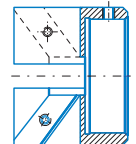
Cutting tool tip 45° (TIN)

Clamping sleeve 1



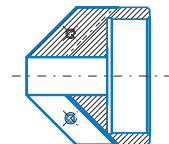
091501113

Cutting tool tip holder 0°
(Ø-internal 16 mm - Ø-external 56 mm)



091501101

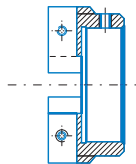
Cutting tool tip holder 30°
(Ø-internal 16 mm - Ø-external 50 mm)



010007080

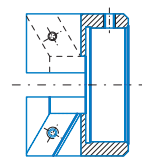
Cutting tool tip holder 45°
(Ø-internal 16 mm - Ø-external 56 mm)

Clamping sleeve 2



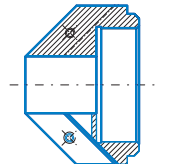
091501114

Cutting tool tip holder 0°
(Ø-internal 25 mm - Ø-external 64 mm)



091501102

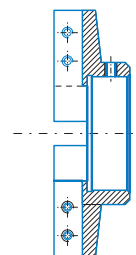
Cutting tool tip holder 30°
(Ø-internal 25 mm - Ø-external 58 mm)



010007080

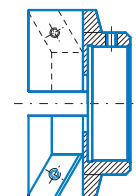
Cutting tool tip holder 45°
(Ø-internal 25 mm - Ø-external 66 mm)

Clamping sleeve 3



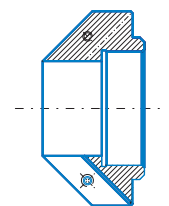
091501104

Cutting tool tip holder 0°
(Ø-internal 40 mm - Ø-external 104 mm)



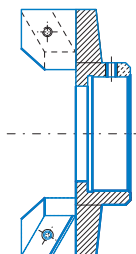
091501103

Cutting tool tip holder 30°
(Ø-internal 40 mm - Ø-external 78 mm)



091501107

Cutting tool tip holder 45°
(Ø-internal 40 mm - Ø-external 82 mm)



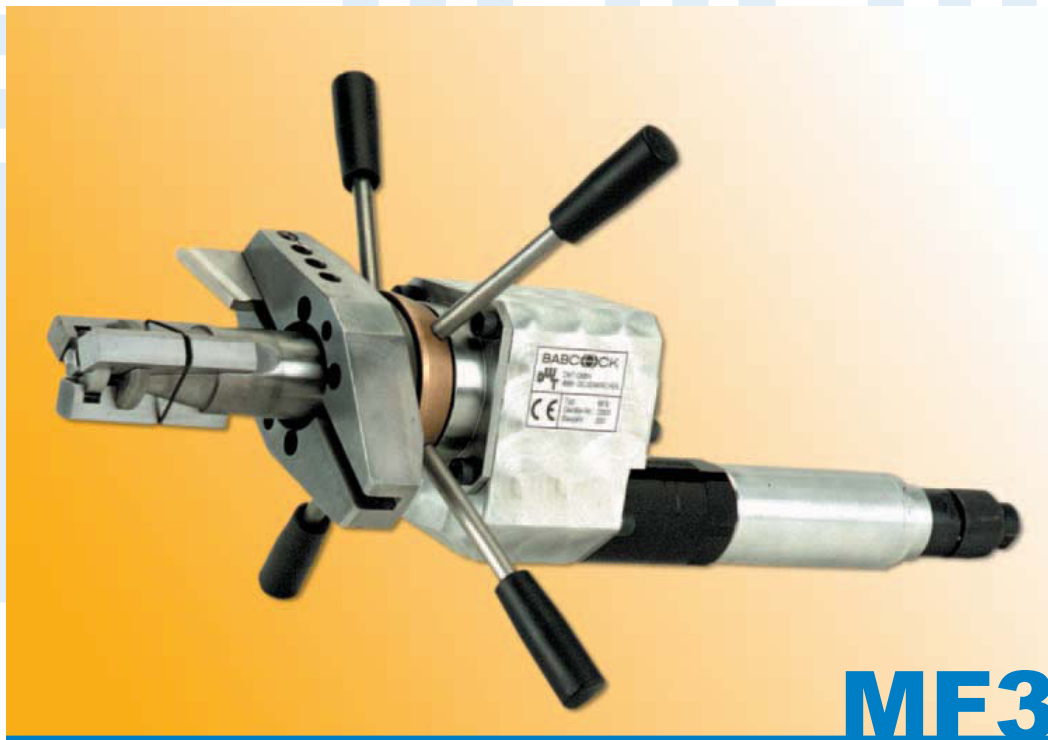
091501112

Cutting tool tip holder 30°
(Ø-internal 70 mm - Ø-external 103 mm)

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF3i

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

Tube outside diameter:	min. 27 mm max. 160 mm
Tube wall thickness:	max. 25 mm
Form of weld:	I, V or special form
Spindle stroke:	15 mm

Clamping range:

Inside tube diameter:	min. 25 mm max. 152 mm
Feed:	manual

Weight:

with pneumatic drive:	approx. 10,3 kg
with electric drive:	approx. 11,3 kg

Pneumatic geared motor:

Power:	740 W at 6 bar 400 W at 4 bar
Operating pressure:	6 - 7 bar
Air consumption:	0,96 m³/min
Compressed air connection:	R 1/4"

Electric geared motor:

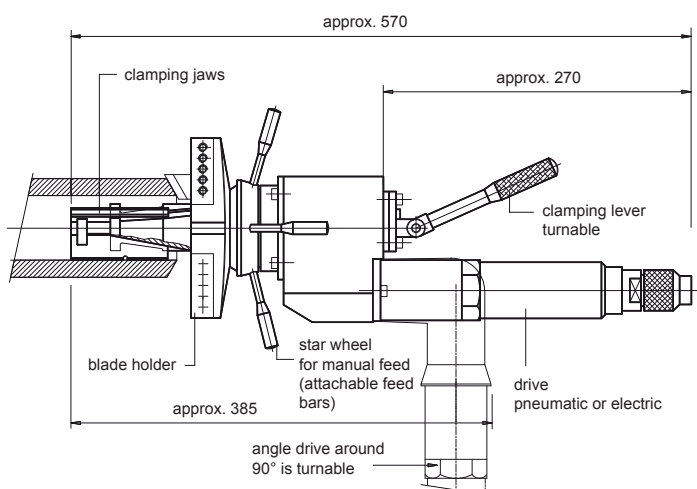
Power consumption/Connection voltage:
abt. 1200W with 230 V

~ (singlephase-alternating current)
Protective class
II – all-insulated

The standard version comes with levers for clamping and feeding. An extra version with a ratchet for clamping and feeding is also available.

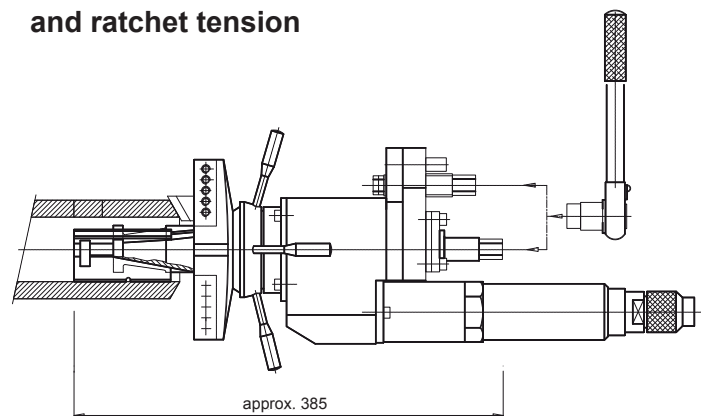
Besides the conventional design in which the motor and the milling spindle are arranged in line, the unit is on request provided with an offset drive. Thus, it can also be used in special situations where a particularly short overall length is required.

MF3i



MF3i

with ratchet feed motion and ratchet tension



BLADE & TOOL TIP HOLDER

with adjustable cutting tools for tube end milling unit type **MF3i**



091501105
HSS
Cutting tool tip 0°



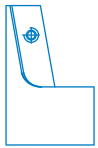
0915010106
HSS
Cutting tool tip 0° (TIN)



091501415
HSS
Cutting tool tip 30°



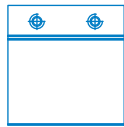
091501416
HSS
Cutting tool tip 30° (TIN)



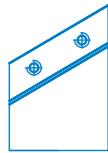
091500665
Cutting tool tip
holder 0°
(short)



091501413
Cutting tool tip
holder 0°
(short)



091502125
Cutting tool tip
holder 0°
(long)



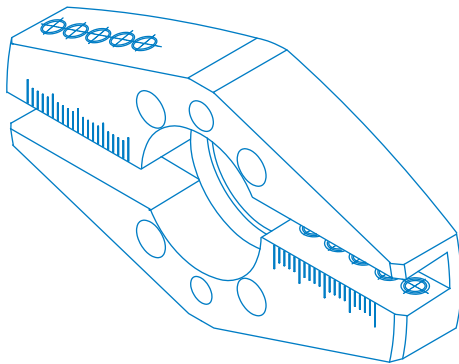
091501414
Cutting tool tip
holder 30°



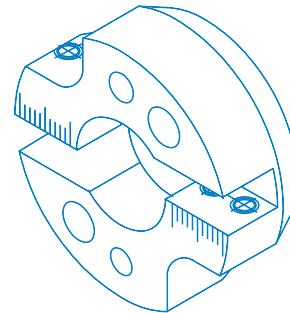
091502183
Cutting tool tip
holder 0°
(small)



091502184
Cutting tool tip
holder 30°
(small)



091502139
Blade holder size 2
for clamping sleeve size 2
(Outside-Ø 158 mm)
(Standard-blade holder)



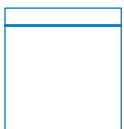
091502144
Blade holder size 1
for clamping sleeve size 1
(Outside-Ø 84 mm)



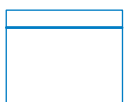
091502185
10° - internal



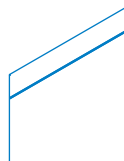
091502186
8° - internal



091502126
HSS blade 0°
(long)



091501410
HSS blade 0°
(short)



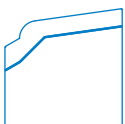
091502191
HSS blade 30°



091502189
HSS blade 0°
(small)



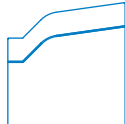
091502190
HSS blade 30°
(small)



091502134
DIN 2559-4



091502133
DIN 2559-3



091502128
DBS 34-R3



091502127
DBS 34-R5



091502192
DIN 2559-4
(small)



091502195
DIN 2559-3
(small)



091502194
DBS 34-R3
(small)



091502193
DBS 34-R5
(small)

Various special blades on request!

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Easy handling



MF5i

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

Working range:

Tube outside diameter:	
Blade holder size 1	max. 322 mm
Blade holder size 2	max. 460 mm
Tube wall thickness:	max. 30 mm
Spindle stroke:	30 mm
Form of weld:	I, V or special form
Feed:	manual

MF5i (2 pneumatic geared motors):

Power:	1480 W at 6 bar
Air consumption:	1,92 m³/min
Compressed air connection:	R 3/8"
Weight:	approx. 23,8

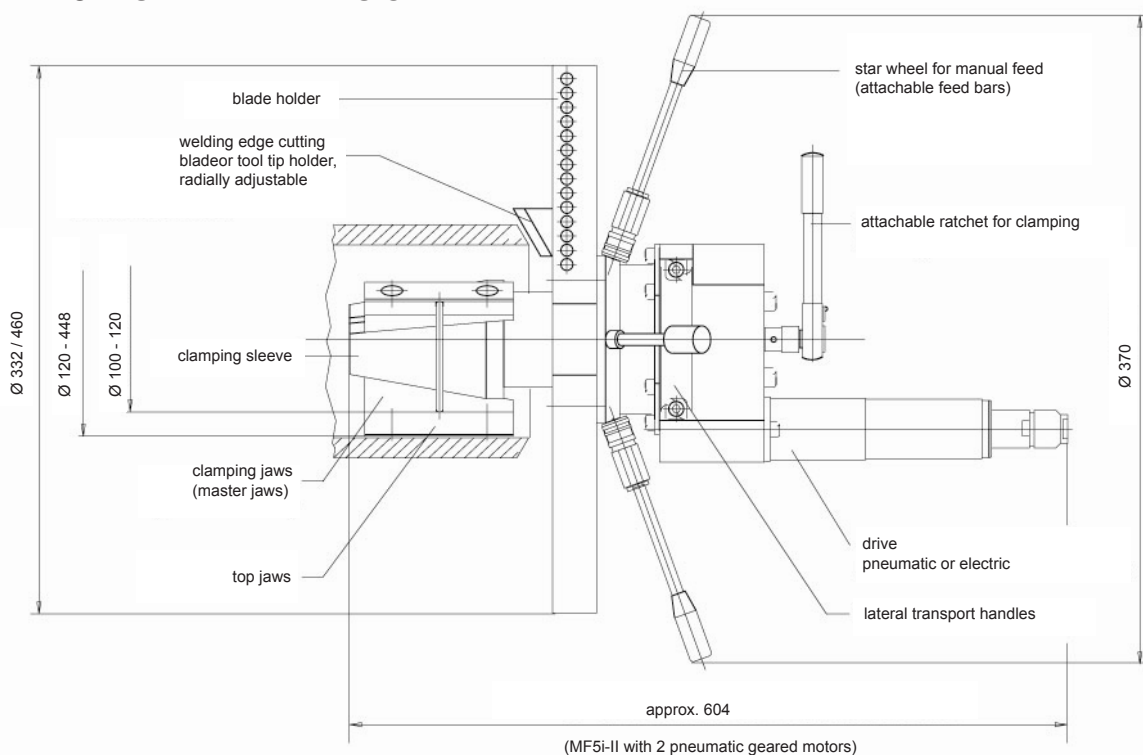
MF5i-I-EL (1 electric geared motor 2,2 kW)

Power consumption/Connection voltage:
abt. 1200W with 230 V

Pneumatic geared motor:

Operating pressure:	6 - 7 bar	Weight:	approx. 27,5 kg
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MF5i STANDARDVERSION



BLADE & TOOL TIP HOLDER

with adjustable cutting tools for tube end milling unit type **MF5i**



091501105
HSS
Cutting tool tip 0°



091501106
HSS
Cutting tool tip 0° (TIN)



091501415
HSS
Cutting tool tip 30°



091501108
HSS
Cutting tool tip 30° (TIN)



091500665
Cutting tool tip holder 10°
(internal)



091501413
Cutting tool tip holder 0°
(short)



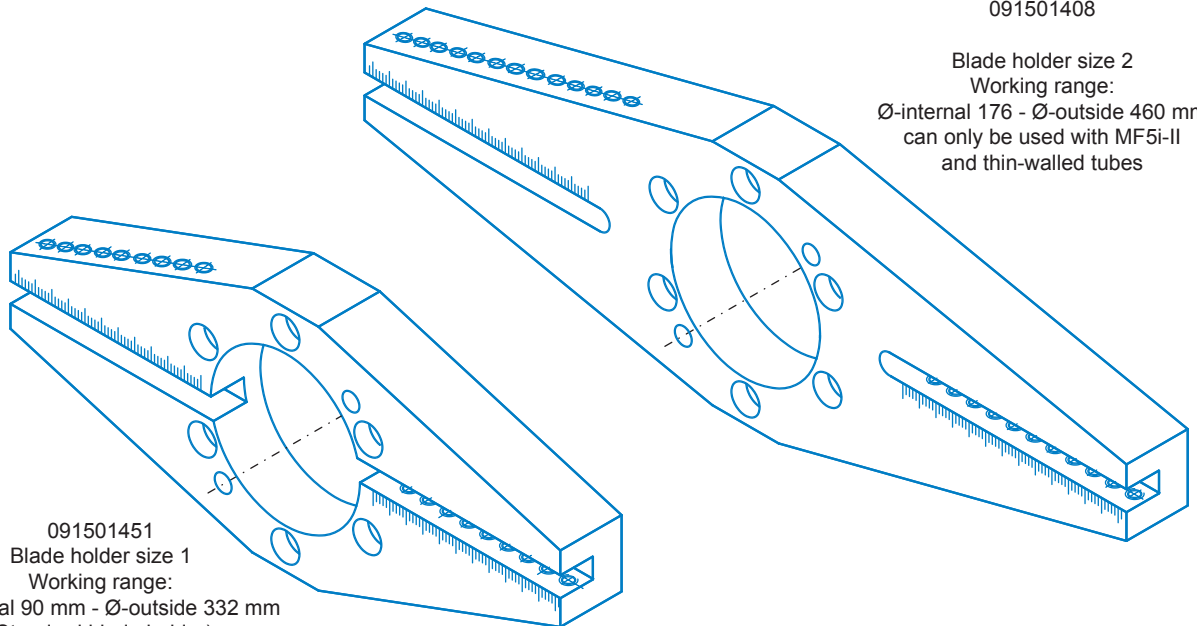
091502125
Cutting tool tip holder 0°
(long)



091501414
Cutting tool tip holder 30°

091501408

Blade holder size 2
Working range:
Ø-internal 176 - Ø-outside 460 mm
can only be used with MF5i-II
and thin-walled tubes



091501451
Blade holder size 1
Working range:
Ø-internal 90 mm - Ø-outside 332 mm
(Standard blade holder)



091502185
10° internal



091502186
8° internal



091502126
0° - HSS blade
(long)



091501410
0° - HSS blade
(short)



091502191
30° - HSS blade



091502134
DIN 2559-4



091502133
DIN 2559-3



091502128
DBS 34-R3



091502127
DBS 34-R5

Various special blades on request!

TUBE END MILLING UNIT

Made in Germany

- High cutting capacity
- Quick and secure clamping
- Rugged and compact type of construction
- Low weight due to aluminium housing
- Easy operating and clamping



MF6i-50

Field of application

The unit serves to machine and prepare welding edges on tubes, branches and headers. On steambloc boilers it is used for machining tube walls and cutting out welds. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allow economical manufacturing.

TECHNICAL DATA

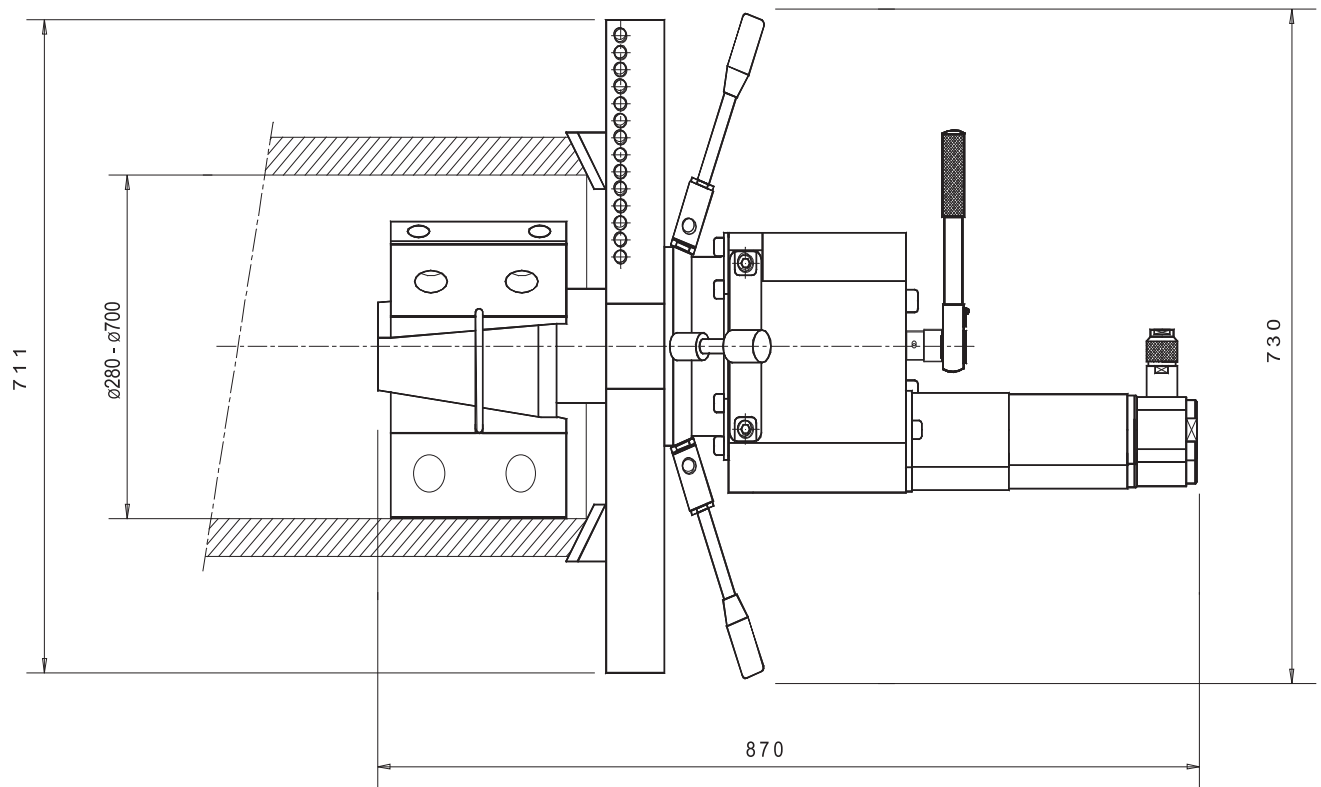
Working range:

Tube outside diameter:	max. 711 mm
Tube inside diameter:	min. 280 mm
Tube wall thickness:	max. 32 mm
Spindle stroke:	50 mm
Form of weld:	I, V or special form
Feed:	manual

Technical Data:

Drive:	3 geared air motors
Operating pressure:	6 - 7 bar (g)
Power:	2220 W at 6 bar (ü)
Air consumption:	2,9 m ³ /min
Weight:	approx. 79 kg

MF 6i-50



CUTTING TOOLS

for tube end milling unit type **MF6i-50**



091501105
HSS
Cutting tool tip 0°



091501106
HSS
Cutting tool tip 0° (TIN)



091501415
HSS
Cutting tool tip 30°



091501416
HSS
Cutting tool tip 30° (TIN)



091500665
Cutting tool tip holder 10°
internal



091501413
Cutting tool tip holder 0°
(short)



091502125
Cutting tool tip holder 0°
(long)



091501414
Cutting tool tip holder 30°



091502185
10° - internal



091502186
8° - internal



091502126
0° - HSS blade
(long)



091501410
0° - HSS blade
(short)



091502191
30° - HSS blade



091502134
DIN 2559-4



091502133
DIN 2559-3



091502128
DBS 34-R3



091502127
DBS 34-R5

Various special blades on request!

PIPE COLD CUTTING SYSTEM

Made in Germany

- Split-Frame technology for endless tubes
- Extremely low weight
- Quick and safe clamping and adjusting
- Reduced space requirement
- Multiple operations possible

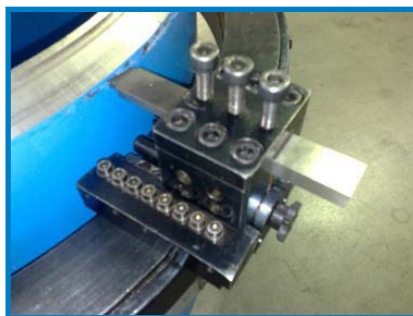
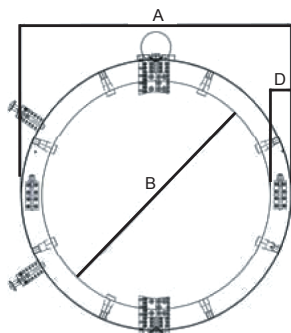


Type DLW

Field of application

Portable pipe cutters, for machining of pipes on-site, are versatile in application and can perform many operations. The machines are reduced in weight and dimensioning. The accessories needed for the different machining allow multiple operations, like beveling and cutting in one operation, inside beveling, flange repair or flange facing.

TECHNICAL DATA



Type	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weigth (kg)	Ø (inch)		Ø (mm)		rpm	max. WT (mm)
							up	to	up	to		
DLW 3-6	308	180	88,5	65	127	23	3	6	76,2	152,4	27	no limit
DLW 4-8	360	232	88,5	65	127	27	4	8	101,6	203,2	23	no limit
DLW 5-10	414	286	88,5	65	127	30	5	10	127	254	20	no limit
DLW 6-12	465	337	88,5	65	127	34	6	12	152,4	304,8	27	no limit
DLW 8-14	496	368	88,5	65	127	38	8	14	203,2	355,6	25	no limit
DLW 10-16	547	419	88,5	65	127	42	10	16	254	406,4	23	no limit
DLW 12-18	602	470	88,5	65	127	45	12	18	304,8	457,2	20	no limit
DLW 14-20	649	521	88,5	65	127	50	14	20	355,6	508	26	no limit
DLW 20-24	750	622	88,5	65	127	60	20	24	508	609,6	23	no limit
DLW 26-30	920	775	88,5	74	127	83	26	30	660,4	762	25	no limit
DLW 32-36	1068	928	88,5	74	127	93	32	36	812,8	914,4	22	no limit
DLW 36-43	1250	1105	88,5	74	136	102	36	43	914,4	1092,2	19	no limit
DLW 40-48	1420	1245	95	89	151	n.a.	40	48	1016	1219,2	22	no limit

OPERATIONS & OPTIONS DLW COLD CUTTER

Field of application :

- Radial cold cutting pipes
- Beveling end of pipes
- Simultaneous cutting & beveling
- Beveling both end in one operation
- Inside machining of pipe ends
- Flange facing

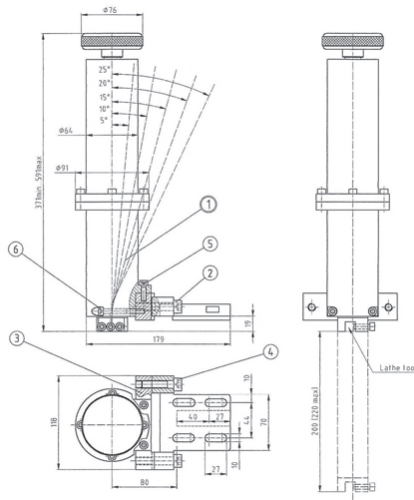
Options drive:

- Hydraulic Motor
- Pneumatic Motor
- Elektrical Motor (max. WT=10 mm)

Cutter overview:

- Radial parting of pipes
- Beveling ends of pipes
- Simultaneous cutting & beveling (depending on wall-thickness)
- Simultaneous cutting both pipe ends (depending on wall-thickness)





Inside beveling device for calibration of inside diameter and inside boring of max. 200 mm depth, adjustable 0° - 25°.



-
- Technical drawing of a mechanical assembly, likely a pump or motor component, showing a cross-section and a perspective view. The drawing includes numbered callouts (1 through 10) identifying various parts:
- 1: A horizontal shaft or axle.
 - 2: A vertical shaft or axle.
 - 3: A vertical shaft or axle.
 - 4: A vertical shaft or axle.
 - 5: A vertical shaft or axle.
 - 6: A vertical shaft or axle.
 - 7: A vertical shaft or axle.
 - 8: A vertical shaft or axle.
 - 9: A vertical shaft or axle.
 - 10: A vertical shaft or axle.
- The drawing also shows various mounting brackets, bolts, and a circular component at the bottom right. The overall assembly is mounted on a base plate.

Flange facing device for DLW machines to regroove the flange surface, automatic feed mechanism, to be used together with DLW-CB.



BOILER WALL CUTTING SYSTEMS

Made in Germany

- Increased safety of workers
- No heat affected zone
- Less wearing of cutting disks
- High productivity
- High cutting quality

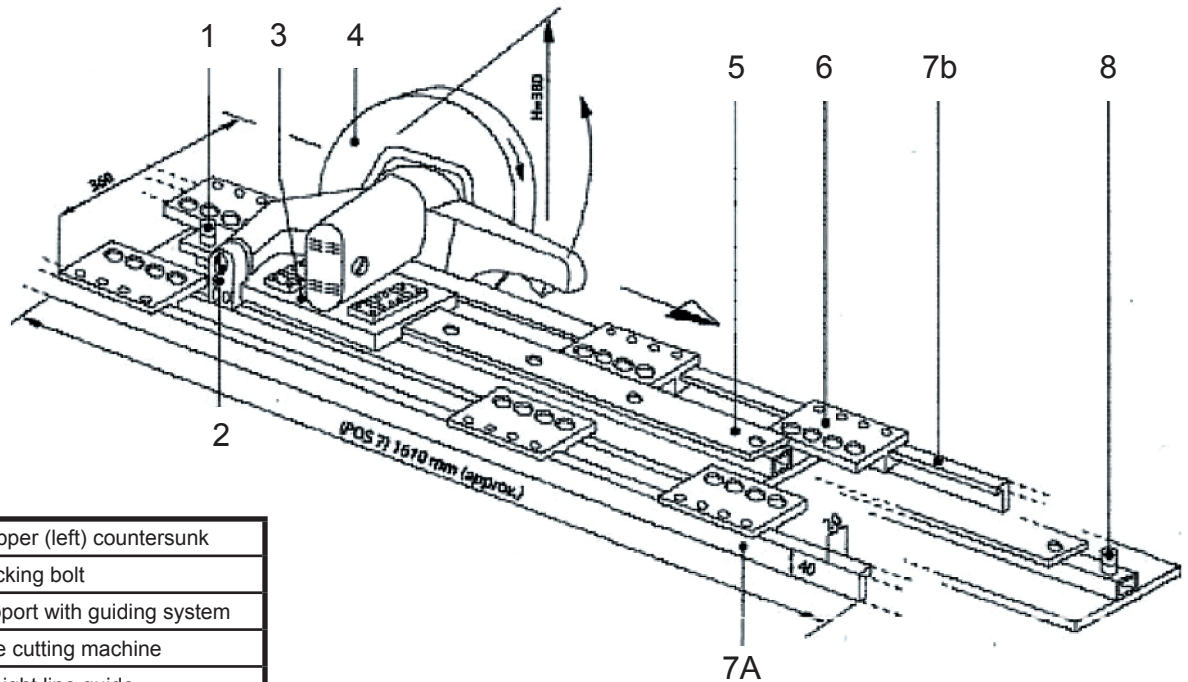


Type BWC

Field of application

The machine serves to cut boiler walls. Having a low weight the unit is of very rugged design. Operated by one man only, it is well suited for use in the workshop and on site. Due to its extremely compact type of construction it can be readily used in confined space. Its high working speed and quick readiness allows economical manufacturing.

TECHNICAL DATA



1	Stopper (left) countersunk
2	Blocking bolt
3	Support with guiding system
4	Pipe cutting machine
5	Straight line guide
6	Coupling device
7A	Angle steel bar
7B	Angle steel bar
8	Stopper (right)

Technical data complete system:

Max. membrane length:	4,5 m
Max. tube diameter:	63,5 mm
Rail material:	aluminium
Weight:	on request

Technical data pneumatic feed:

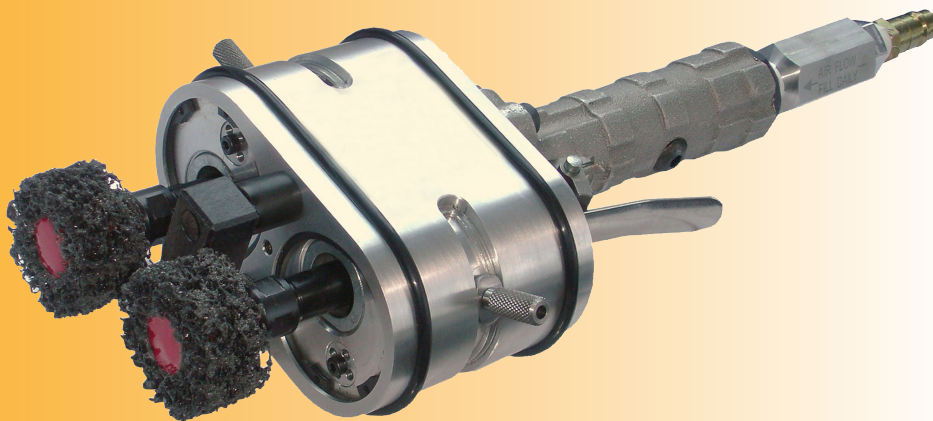
Power:	3500 Watt
Compressed air:	6,2 bar(g)
Air consumption:	60 l/s
Connection:	R 1/2 inch
Noise level:	85 d(B)A



PIPE END GRINDING MACHINE

Made in Germany

- Fast cleaning
- Easy handling
- Compact design
- Simple adjustment



RS 5090

Field of application

The RS 5090 is a compressed air powered grinding and polishing machine for cleaning pipe- and plateends easy and fast. Both grinding parts of the RS 5090 can simple be adjusted for every required wall thickness. Useable in Heat exchanger, Offshore-Technic, Steel industy, Equipment manufacturing, Shipyards, Machine engineering, Pipeline construction and many more...

TECHNICAL DATA



Model	RS 5090 S	RS 5090 D	RS 5090 AUTO
Design	with straight handle	with D handle	with AUTO unit
Air Consumption	0,46 m³/min	0,46 m³/min	0,58 m³/min
Drive	manual feed	manual feed	rotation through airfeed
Grinding range	25 and 30 mm		
Deliverable Graining	40, 80 and (black) Strip-It-Wheels		
Speed	12.000 rpm		
Operating pressure	6 bar		
Weight	3,5 kg		

The RS-machine cleans simple and fast the interior and exterior side of each pipe (or the top and rear side of plates).

The exchangeable grinding parts will be delivered standardly with a diameter of 30 mm and 50 mm. The grinding width is by default 20 and 30 mm. The standard graining of the grinding tools is 40 and 80. Commercial grinding tools can also be used.

The RS grinding machine will be delivered in a stable plasticsuitcase with adequate place for necessary tools and replacement grinding tools. The content can be matched for all requires.



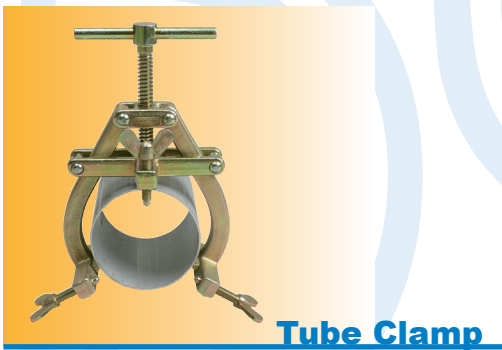
USEFULL ACCESSORIES



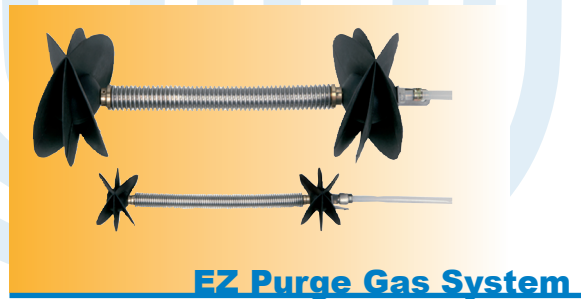
FMT Marking Tool



Centering Head



Tube Clamp



EZ Purge Gas System



Flange Leveler



Pipe Stand

Field of application

DWT develops and supply tools for aligning and adjusting pipes and fittings of metal when welding. Other products are Purge Gas Equipment, Pipe Welding Equipment and Measuring Instruments for welding with purge gas.

PIPE END PREPARATION MACHINES

- Heat exchanger manufacturing
- Offshore constructions
- Apparatus manufacture
- Equipment constructions
- Shipbuilding
- Machine construction
- Pipeline construction



MFS

MFS-4, MFS-6 AND MFS-16

The basis of the MFS series is formed by the new MFS-4 with clamping range from 1/2" to 4" (20 mm - 116 mm outside diameter). The number in the title of the machine refers to the maximum clamping range in inches for that particular machine. For example, the MFS-16 has a clamping range up to 16" (410 mm).

Making weld preparations is a matter of seconds

The performance determines the choice of a machine. It is the fastest working machine for machining (thick-walled) pipes made from duplex steel, stainless steel or hasteloy, for example. The minimal handling of materials required and the very short machining time make the MFS end preparation machines to some of the fastest on the market.



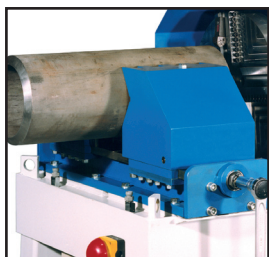
MFS-16



MFS-4



MFS-6



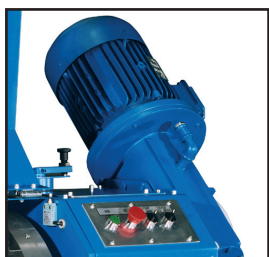
Self-centering prism clamp

A self-centring prism-clamp holds the pipe firmly in place. The clamp can be manually opened and closed rapidly using a large ratchet. The MFS-24 and MFS-30 have an electric drive as standard for the prism-clamp.



Large chip tray

The large chip tray has a separator to filter the chips out of the coolant. All MFS machines have a built-in pump for cooling fluid.



Powerful electric motors

The more than adequate electric motors of the MFS-4 and MFS-6 have two speeds and can be operated very simply. As well as the two speed motor, MFS-16 also has a gearbox allowing simple switching to a total of four speeds.

TECHNICAL DATA



	MFS-4	MFS-6
Clamp range ¹ (mm)	20 - 116	46 - 180
Clamp range ¹ (pipe in inches)	1/2" - 4"	1 1/2" - 6"
Turning range (mm)	10 - 116	30 - 180
Voltage ² (Volt)	400V - 3Ph - 50Hz	400V - 3Ph - 50Hz
Motor power (kW)	2,6 / 3,2	4,5 / 5,5
Clamping	Prism-clamp	Prism-clamp
Clamp operation	Manuel	Manuel
Machining	Carbide inserts	Carbide inserts
Max. wall thickness ³ (mm)	13 (in 1 machining)	25 (in 1 machining)
Feed operation	Manuel	Manuel
Feed stroke (mm)	100	100
Speed (r.p.m.) at 50 HZ.	96 and 195	48 and 96
Size LxWxH (mm)	900 x 740 x 1300	1300 x 900 x 1450
Weight (kg)	700	1.250

Options

	MFS-4	MFS-6
Electrically operated clamp	●	●
Electrically operated feed	●	●
Electrically operated pipe-stop	●	●
Semi-automatic	●	●
Built-in cooling pump	Standard	Standard
Mist cooling system	-	-
Copying system	-	-
RBT roller bench	●	●
Maintenance contract	●	●



MFS-16	MFS-24	MFS-30
80 - 410	215 - 620	215 - 780
3" - 16"	8" - 24"	8" - 30"
60 - 410	170 - 620	170 - 780
400V - 3Ph - 50Hz	400V - 3Ph - 50Hz	400V - 3Ph - 50Hz
4,5 / 5,5	15	18,5
Prism-clamp	Prism-clamp	Prism-clamp
Manuel	Electric	Electric
Carbide inserts	Carbide inserts	Carbide inserts
20 (in 1 machining)	35 (in 1 machining)	35 (in 1 machining)
Manuel	Electric	Electric
100	100	100
36, 48, 72 and 96	25, 38 and 50	20, 40 and 70
1400 x 1100 x 1300	3000 x 2300 x 1800	3500 x 2400 x 1800
2.250	11.000	12.000

(¹) Clamping range and turning range can be reduced using optional insert jaws.

(²) Other voltages/frequencies can be supplied on request

(³) The maximum wall thickness is unrestricted by machining the pipe several times in succession.

MFS-16	MFS-24	MFS-30
●	Standard	Standard
●	Standard	Standard
●	●	●
●	●	●
Standard	Standard	Standard
-	●	●
●	●	●
●	●	●
●	●	●

● = optionally available

ROLLER BENCHES TYPE RBT

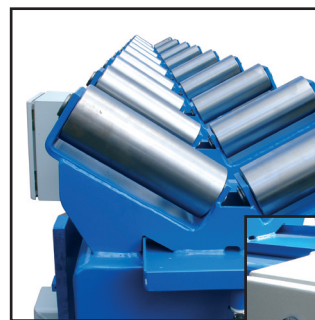
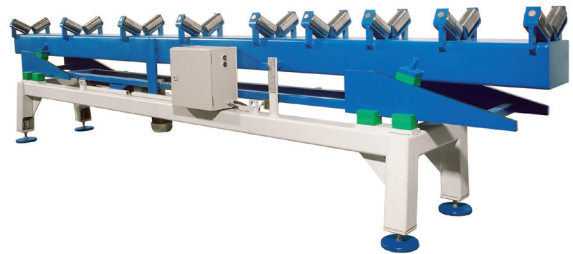
The RBT roller benches have been especially designed for use in combination with the MFS pipe end preparation machines. The trough system with steel rollers makes it possible to roll the pipe easily by hand into the machine.

Just as the MFS machines the RBT roller benches are extra strong and robust and exceptionally suitable for heavy work.

Unusual sizes or modified models, for example with stainless steel rollers or completely turnable through 180°, are available on request.

All MFS machines are provided with an extra 400 volt socket in which the roller bench cable can be connected, so that there is always a powered socket available for the RBT.

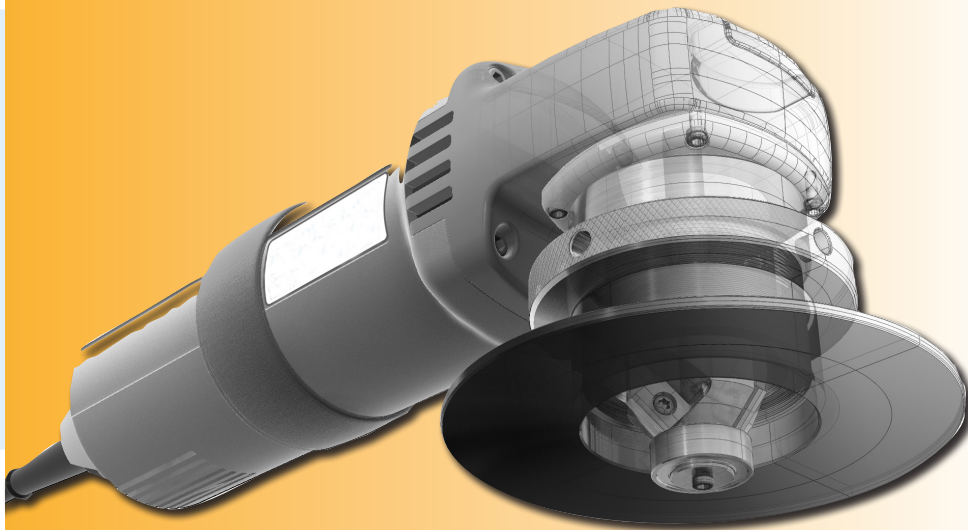
The height can easily be adjusted electrically with one push on the button. The top part with the V-rolls then moves up or down in its entirety. The desired height can be seen on the scale.



	RBT-3004	RBT-5004	RBT-3000	RBT-5000	RBT-7000	RBT-3016	RBT-5016	RBT-7016	RBT-4024	RBT-5024	RBT-7024	RBT-4030	RBT-5030	RBT-7030
MFS-4	●	●	-	-	-	-	-	-	-	-	-	-	-	-
MFS-6	-	-	●	●	●	-	-	-	-	-	-	-	-	-
MFS-16	-	-	-	-	-	●	●	●	-	-	-	-	-	-
MFS-24	-	-	-	-	-	-	-	-	●	●	●	-	-	-
MFS-30	-	-	-	-	-	-	-	-	-	-	-	●	●	●
Bench length (mm)	3000	5000	3000	5000	7000	3000	5000	7000	4000	5000	7000	4000	5000	7000
Bench width (mm)	300	300	300	300	300	400	400	400	600	600	600	700	700	700
Capacity (kg)	1000	1000	2000	2000	2000	3000	3000	3000	8000	8000	8000	10000	10000	10000
Weight (kg)	450	600	700	1000	1300	900	1200	1500	2500	4000	5500	4000	5000	7000

HANDHELD MILLING MACHINES

- Deburring
- Edge milling
- Chamfering technology



Field of application

With this edge milling machine different inside and outside contours can be milled and/or deburred, e.g.: boreholes, flanges, sheet metal, pipes. Even visible surfaces in process plant engineering and welding seams can be prepared with this handy, yet powerful machine. Furthermore, sharp corners and edges can be safely deburred.

Application range: Steel, light metal, VA, GG, non-ferrous metal, plastic

TECHNICAL DATA

K-HFM/KaKi 2014-1-8-E



Advantages:

- Low emission
- Special angle upon request
- Threaded connections allows for simple cutter head replacement

Option:

- Also available with 30° and 60° cutter heads

100004	45°-chamfer = Standard
100005	30°-chamfer
100006	60°-chamfer**

Included in delivery:

- 1 Standard machine incl. cutter head
- 1 Carrying case
- 1 Hook spanner
- 1 Torx screw driver
- 1 Guide plate

Motor: 230 V electronically infinitely variable

RPM: 2.800 - 11.000 min⁻¹

Protection category: IP20

Rated power consumption: 1.400 W

Weight: 3,5 kg

Chamfering bit / 8 cutters:

- Igel-indexable cutting insert KIF/MF 42.45.1.8

Guide:

- radial = guide roller R=14 mm
- c/w ball bearings
- axial = guide plate R=63,5 mm
- c/w hardened steel

Chamfer 45°:

- Width and angle max. 5 mm / 45°

Chamfer 30°:

- Width and angle max. 8 mm / 30°

Chamfer 60°:

- Width and angle max. 8 mm / 60°
- Min. material thickness 3 mm und 0,5 mm when using straight level guide stop K-HFMGFASVS50

Item no.	Description	I.D. no.	Unit*
100044	Guide plate D=127 steel, hardened	K-HFMFT127St	1
100047	Straight level guide stop	K-HFMGFASVS50	1
100114	Cutting insert	X.11.30.35.45 P25	10
100115	Cutting insert	X.11.30.35.45 P25 B - with TiN coating	10
100116	Cutting insert	X.11.30.35.45 P25 BS - with TiCN coating	10
100128	Cutting insert	X.11.30.35.45 P25 VA/AL BST	10
100160	Screw for cutting insert	Screw 35	10
100166	Hook spanner 68	for HFM plate/ring	1
100171	Screwdriver	T8	1
100177	Modular chamfering bit for 45° chamfers	KIF/MF42.45.1.8.R	1
100181	Modular chamfering bit for 60° chamfers incl. guide roller	KIF/MF42.60.1.8.R	1
100173	Modular chamfering bit for 60° chamfers excl. guide roller	KIF/MF42.60.1.8.R	1
100055	Guide roller for 60° chamfers	K-FR	1
100182	Modular chamfering bit for 45° chamfers	KIF/MF48.30.1.8.R	1

*Unit = packaging unit, ** For item 100006 is a guide roller for the 60°chamfer required. Additional accessories, milling machines and special designs upon request.



TECHNICAL DATA

K-HFM/KaKi 2023-2-8-65

- 100017** 45°-chamfer = Standard
100015 30°-chamfer
100016 60°-chamfer**

Advantages:

- Low emission
- Special angle upon request
- Threaded connections allows for simple cutter head replacement

Included in delivery:

- 1 Standard machine incl. cutter head
- 1 Carrying case
- 1 Hook spanner
- 1 Torx screw driver
- 1 Guide plate

Motor: 230 V electronically infinitely variable

RPM: 6.500 min⁻¹ constant

Protection category: IP20

Rated power consumption: 2.600 W

Weight: 7,5 kg

Chamfering bit / 8 cutters:

- Igel-cutting insert KIF/MF... (siehe Tabelle)

Guide:

- radial = guide roller R=14 mm
- c/w ball bearings
- axial = guide plate R=63,5 mm
- hardened steel - c/w clamps

Chamfer width:

- Width depends on milling angle and material

Chamfer 45°:

- Width and angle max. 10 mm / 45°

Chamfer 30°:

- Width and angle max. 14 mm / 30°

Chamfer 60°:

- Width and angle max. 14 mm / 60°
- Min. material thickness 4 mm

Please note that the chamfer size varies with different materials

Item no.	Description	I.D. no.	Unit*
100045	Guide plate D=148 steel, hardened	K-HFMFT148St	1
100048	Straight level guide stop	K-HFMGFASVS60	1
100053	Guide roller for 60° cutter head	K-HFMFR-60°	1
100054	Guide roller for 30° cutter head	K-HFMFR-30°	1
100114	Cutting insert	X.11.30.35.45 P25	10
100115	Cutting insert	X.11.30.35.45 P25 B - with TiN coating	10
100116	Cutting insert	X.11.30.35.45 P25 BS - with TiCN coating	10
100128	Cutting insert	X.11.30.35.45 P25 VA/AL BST	10
100160	Screw for cutting insert plate	Screw 35	10
100167	Hook spanner 80	for HFM plate/ring	1
100171	Screwdriver	T8	1
100196	Modular chamfering bit for 30° chamfers	KIF/MF60.30.2.8.R	1
100195	Modular chamfering bit for 60° chamfers	KIF/MF60.60.2.8.R	1
100194	Modular chamfering bit for 45° chamfers	KIF/MF60.45.2.8.R	1
100495	Spacer ring for 30° chamfers		

*Unit = packaging unit. Additional accessories, milling machines and special designs upon request.

MORE PRODUCTS

for production, maintenance and repair

CHAIN LIFT



IMPACT WRENCH

CONTACT

DWT GmbH

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eMail: info@dwt-gmbh.de



The DWT GmbHs head office is in the industrial heart of Germany. With the trademark DWT Babcock machines for pipe beveling are produced by a competent team and are delivered in the whole world.