

BEVELLING MACHINES WELDING CARRIAGES



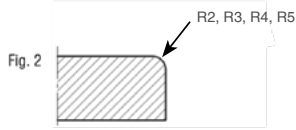
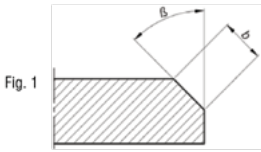
BM7

COMPACT PLATE & PIPE BEVELLER

- Maximum 7mm bevel width
- Lightweight and compact design
- Small overall dimensions
- Excellent for limited access
- Continuous bevel width adjustments
- Ideal for radius edge bevelling (R2, R3, R4 or R5) in just one pass
- One single 45° milling head for both radius and V bevels
- Capable of arched edge bevelling
- Min plate thickness 1.5mm
- Pipe OD bevelling
- Pipe ID bevelling Min. ID 40mm



Part No.	WA-BM7
Power supply	1~ 220-240 V, 50-60 Hz
Motor	1100W
Spindle speed (without load)	6500rpm
Maximum bevel width (b)	7mm (Fig.1)
Bevel angle (β, depending on milling head)	45°; 30° (option); Fig.1
Minimal diameter of countersinking	35mm
Rounding edges	R2, R3, R4, R5 (Fig. 2)
Dimensions (L x W x H)	327mm x 142mm x 319mm
Weight (without milling head)	5.8kg



Standard Package Includes

- WA-BM7 beveller including milling head 45° w/o inserts
- Plastic box
- Special wrench
- Torx T15 screwdriver
- Screw grease (5g)
- Operator's manual

Spares & Consumables

Part No.	Description
WAP-BM7/1035	Insert Screw
WAP-BM7/1030	Guiding Roller 22.5mm
WAP-BM7/1020	Guiding Roller 30mm
WAP-BM16/1110	Grease Screw (5G)
WAP-BM7/1025	Anti-Scratch Guide Sticker
WAP-BM16/1085	Radius Positioner (R2, R3, R4, R5)

Accessories

Part No.	Description
WAP-BM7/1010	Milling Head 45° For Cutting And Radius Bevels
WAP-BM7/1015	Milling Head 30° For Cutting
WAP-BM16/1115	Cutting Insert For Steel (4 Pcs Required)
WAP-BM16/1120	Cutting Insert For Aluminum (4 Pcs Required)
WAP-BM16/1045	Cutting Insert R2 (4 Pcs Required)
WAP-BM16/1050	Cutting Insert R3 (4 Pcs Required)
WAP-BM16/1055	Cutting Insert R4 (4 Pcs Required)
WAP-BM16/1060	Cutting Insert R5 (4 Pcs Required)

BM16

PORTABLE BEVELLING MACHINE

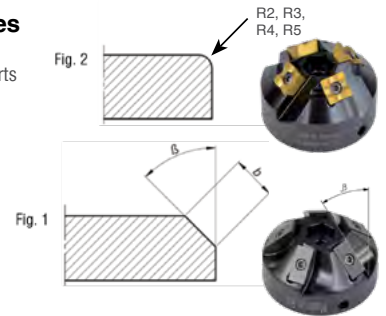
- Maximum 16mm bevel width
- Mill edges of plates and pipes made of steel, aluminium alloys, brass, or plastic
- Bevel materials with minimum thickness of 1.5mm
- Continuous bevel width adjustment
- Overload protection
- Electronic variable speed control
- Each standard milling head uses 5 indexable cutting inserts
- Bevelling radius milling head enables bevelling edges with radius of 2, 3, 4 or 5mm with use of 4-sided indexable R2, R3, R4 or R5 cutting inserts
- Highly efficient for edge weld preparation and rounding off steel construction before painting or coating



Part No.	WA-BM16
Power supply	220-240 V / 50-60 Hz
Motor	2200W
Spindle speed (without load)	1800-5850 rpm
Maximum bevel width (b)	16mm (Fig.1)
Bevel angle (β, depending on milling head)	20°, 22.5°, 30°, 37.5°, 45°, 50°, 55°, 60°, 65° (Fig.1)
Minimal diameter of countersinking	40mm
Rounding edges	R2, R3, R4, R5 (Fig. 2)
Dimensions (L x W x H)	585mm x 156mm x 238mm
Weight (without milling head)	10 kg

Standard Package Includes

- WA-BM16 bevelling machine without milling heads or cutting inserts
- Plastic Case
- 32mm flat wrench
- Allen wrench hex s=5
- Allen wrench hex s=14
- Operator's Manual (English)



Spares & Consumables

Part No.	Description
WAP-BM16/1100	Insert Screw
WAP-BM16/1085	Radius Insert Positioner
WAP-BM16/1075	Guiding Roller
WAP-BM16/1105	Carbon Brush

Accessories

Part No.	Description
WAP-BM16/1040	Milling Head For Rounding
WAP-BM16/1045	Cutting Insert R2 (4 Pcs Required)
WAP-BM16/1050	Cutting Insert R3 (4 Pcs Required)
WAP-BM16/1055	Cutting Insert R4 (4 Pcs Required)
WAP-BM16/1060	Cutting In sert R5 (4 Pcs Required)
WAP-BM16/1115	Cutting Inserts For 45° Bevelling To Suit Radius Head Only
WAP-BM16/1035	Milling Head 22.5°
WAP-BM16/1010	Milling Head 30°
WAP-BM16/1030	Milling Head 37.5°
WAP-BM16/1015	Milling Head 45°
WAP-BM16/1017	Milling Head 50°
WAP-BM16/1025	Milling Head 55°
WAP-BM16/1020	Milling Head 60°
WAP-BM16/1022	Milling Head 65°
WAP-BM16/1070	Cutting Insert For Steel To Suit Above Angle (Not Radius) Milling Heads Only (5 Pcs Required)
WAP-BM16/1065	Cutting Insert For Aluminum To Suit Above Angle (Not Radius) Milling Heads Only (5 Pcs Required)
WAP-BM16/1130	Pipe Attachment
WAP-BM16/1135	Work Table
WAP-BM16/1140	Anti Scratch Guide Sticker

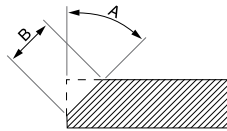
BM20 PLUS PORTABLE BEVELLER

- Maximum 21mm bevel width
- 15° to 60° bevelling as standard with optional 0° edge planing attachment available
- Portable, easy to use, heavy duty machine
- Designed for bevelling steel plates & pipes prior to welding or edge finishing work
- Fitted with two milling heads each holding five carbide inserts
- Provides a smooth milled finish



Accessories & Consumables

Part No.	Description
WAP-B020	Replacement Standard Cutting Tips (10 Required)
WAP-B20/4210	0° Edge Planing Attachment
WAP-B20/4010	Pipe Attachment To Suit 150-300mm Pipe
WAP-B20/4020	Pipe Attachment To Suit 258-600mm Pipe
WAP-B20/4230	Round Plate Beveling Attachment



Part No.	Induction Motor	Grinding Angle	Speed	Weight	Maximum Bevel Width					
					A	B	15°	30°	45°	60°
WA-BM20+	1600W	15° - 60°	3340rpm	20.5kg			15°	30°	45°	60°
WA-BM21	1600W	0° - 60°	2800rpm	21kg	A	0°	15°	30°	45°	60°
WA-BM21S			1360rpm		B	21mm	18.5mm	18.5mm	21mm	18.5mm

BM21 BM21S FOR USE WITH STAINLESS STEEL PORTABLE BEVELLERS

- Maximum 21mm bevel width
- 0° to 60° continuous angle adjustment
- Allows 0° angle for edge planing
- Improved design offers a number of innovative solutions that increase ergonomics and ensure even more comfort and work safety of the operator
- Single milling head equipped with 10 indexable inserts that require no set up and makes the machining process far more efficient with little operator's effort
- Easy setting of chamfer angle and bevel width
- One universal guideline for bevelling both plates and pipes
- Bevells pipes 150 - 300mm diameter with optional attachment available for bevelling pipes 260 - 600mm diameter
- 4 vibration isolators
- Unique BM21S features include a low speed (grey colour) motor, plus guide plate and guide rollers made of stainless steel



BM21



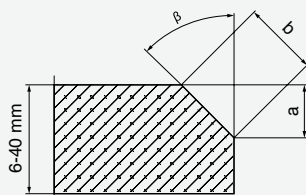
BM21S

Accessories & Consumables

Part No.	Description
WAP-B020	Replacement Standard Cutting Tips (10 Required)
WAP-BM21/3010	Large Pipe Attachment For 258 - 600mm Pipe

ABM 14 AUTO PLATE & PIPE BEVELLER

- Maximum 14mm bevel width
- Plate thickness range of 6-40mm
- Bevel plates and pipes made of mild steel, alloy steel, stainless steel or aluminum alloys
- Auto feed on large plates with optional trolley
- Machine uses a single shearing cutter, giving a sheared finish on the material
- In just one single run the machine can bevel up to 2.6 m/min to a width of 12 mm in workpieces with tensile strength of 40 Kg / Rm ≤ 392 MPa (57,000 psi)
- Standard bevel angle (β) of 30°
- Optional angle variation devices available 22.5°, 25°, 35°, 37.5° or 45°
- Can bevel plates from the top and bottom
- Low noise, 70 dB
- Fast and efficient & bevells both small and large pieces
- 2 optional shearing cutters dedicated to stainless/alloyed steel and aluminum



Optional and Spare Accessories :

- WAP-B14/1000 Cutting Wheel For Mild Steel
- WAP-B14/1020 Cutting Wheel For Stainless Steel
- WAP-B14/1010 Cutting Wheel For Aluminum
- SCG-000002 Cutting Wheel Extraction Tool
- WAP-B14/2010 Angle Variation Device 22.5°
- WAP-B14/2020 Angle Variation Device 25°
- WAP-B14/2030 Angle Variation Device 30°
- WAP-B14/2040 Angle Variation Device 35°
- WAP-B14/2050 Angle Variation Device 37.5°
- WAP-B14/2060 Angle Variation Device 45°
- TRZ-000017 Tube Beveling Shaft
- PDK-000240 Tube Beveling Washer
- WAP-B14/TROLLEY Adjustable Trolley

Package Includes :

- WA-ABM14 beveller
- Cutting wheel for mild steel
- Cutter extraction tool
- Tube beveling shaft & washer
- Flat wrenches: 12-13mm, 18-19mm, 24-26mm
- Hex wrenches: 5mm, 6mm
- Operator's manual

SINGLE RUN BEVELLING - MILD STEEL

Rm	t ≤ 392 MPa (57,000 psi)		392-490 MPa (57,000 - 71,000 psi)		490-588 MPa (71,000 - 85,000 psi)	
	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	12	11	10	9	8	7.5
30	12	10	10	8.5	8	7
35	12	9.5	10	8	8	6.5
37.5	12	9	10	7.5	8	6
45	12	8.5	10	7	8	5.5

SINGLE RUN BEVELLING - STAINLESS / ALLOY STEEL

Rm	≤ 490 MPa (71,000 psi)		490-588 MPa (71,000 - 85,000 psi)		588-686 MPa (85,000 - 100,000 psi)	
	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	6	5.5	5	4.5	4.2	3.8
30	6	5	5	4.3	4.2	3.6
35	6	5	5	4	4.2	3.5
37.5	6	4.5	5	4	4.2	3.3
45	6	4	5	3.5	4.2	3

Part No.	WA-ABM14
Voltage	3~ 400 V + PE, 50/60 Hz
Power	2200 W
Spindle speed	9 rpm
Maximum bevel width (b)	14mm
Maximum bevel width (b) in a single run	12mm
Minimum plate thickness	6 mm
Maximum plate thickness	40 mm
Minimum plate width	55 mm
Bevel length per minute	2.6 m
Minimum pipe ID	100 mm
Weight	65 kg

ABM 28

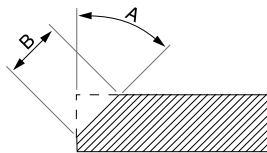
AUTO-FEED PORTABLE BEVELLING MACHINE



- Bevel width up to 28mm at 45 degrees
- Single milling head equipped with 10 indexable inserts giving a milled finish
- Fast and effortless setup
- Automatic feed
- Variable travel speed control
- Can mill all types of metal including stainless steel, aluminium and composites
- Can mill plates in both directions eliminating unnecessary "empty journeys"
- Equipped with an overload control system
- Length of the guide track can be extended to any required length.
- Beveling angle can be set between -60° and 60°, including facing at 0°. This allows both the top and underside of the plate to be bevelled without moving the material.
- Using optional accessories, the ABM28 can also create J-groove bevels.

Package Includes

- Beveling Machine
- 1200mm Track Segment x 2
- Positioner Unit, 35mm
- 35mm Track Clamp x 3
- Standard Milling Unit Support



Maximum Bevel Width

A	0°	30°	45°	60°
B	35mm	30mm	28mm	30mm

Part No.	WA-ABM28
Plate Thickness	10mm Minimum To 35mm Maximum, 70mm With Optional Attachment
Machining Angle	-60° to 60°
Motor	1600 Watt 240V 2800rpm
Dimensions	1211 W x 532 H x 619 D

Accessories & Consumables

Part No.	Description
WAP-B020	Replacement Standard Cutting Tips (10 Required)
WAP-B28/6130	Track Clamp For Plate Up To 35mm Thick
WAP-B28/6140	Track Clamp For Plate Up To 70mm Thick
WAP-B28/6150	Positioner Unit For Plate Up To 35mm Thick
WAP-B28/6160	Positioner Unit For Plate Up To 70mm Thick
WAP-B28/6170	Rail Segment 1200mm Long
WAP-B28/6180	Milling Unit Support For Beveling 35 - 70mm 0° To 60°
WAP-B28/6190	Milling Unit Support For Beveling 35 - 70mm 0° To -60°

ABM 50

AUTO-FEED PLATE & PIPE BEVELLER



- Bevel width up to 50mm at 45 degrees
- Auto-feed portable beveller
- Produces accurate high-quality double-sided bevels without thermal distortion or creation of heat affected zone
- Purpose designed milling head with eight 4-sided indexable cutting inserts giving a milled finish
- Continuously adjustable bevel angle between 15 and 60 degrees (for both top and bottom beveling) requires no tooling to change
- 180° inversion allows for creation of a double-sided bevel - no need to rotate or flip heavy material reduces material handling costs and improves shop safety
- Variable spindle speed for work on a variety of steel grades and thicknesses
- Versatile and transportable on its own trolley
- Feedback-controlled overload system

Remote Control Panel

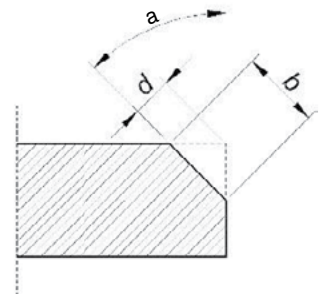
- LCD display that shows real-time measurement and on-screen display of exact bevel geometry and cutting parameters as well as enables precise adjustment of spindle speed and feed speed to optimize them depending on material grade



- The operator can easily adjust and monitor the following parameters:
 - Bevel angle
 - Bevel width
 - Bevel height
 - Spindle speed
 - Feed rate
 - Spindle load

Package Includes

- Beveling machine with milling head and 8 cutting inserts
- Wooden box with base and mounting brackets• Special wrench
- 10 mm T-handle hex wrench with ball tip
- 3.5 mm hex wrench
- T15 torx screwdriver
- Grease for screws
- Operator's manual



Maximum Bevel Width

a	15°	30°	45°	60°
b	66mm	52mm	50mm	51mm

Part No.	WA-ABM50
Voltage	3~400 V+ PE, 50/60 Hz 3~480 V+ PE, 50/60 Hz
Power	6.5kw
Spindle speed (no load)	300 - 800rpm
Feed speed	0 - 1.2m/min
Maximum depth of cut per single pass	6mm
Plate thickness	8 - 80mm
Required ambient temperature	0 - 40°C
Dimensions	1179mm L x 853mm W x 1524mm H
Weight	320kg

PRO 2 PB COMPACT PIPE BEVELLER

- 48mm wide makes it perfectly suited to space restricted areas
- Maximum pipe wall thickness of 8mm
- 3 different power sources to chose from: pneumatic motor, electric motor and battery drive
- Overload systems incl. wet multi-disk friction clutch to prevent gear damage if the tool gets stuck



Pipe machining range

- 22mm I.D. to 48mm O.D. pipe capacity as standard
- 15.5mm I.D. minimum pipe capacity with optional small mandrel set
- 60.3mm O.D. maximum pipe capacity with optional extension set set

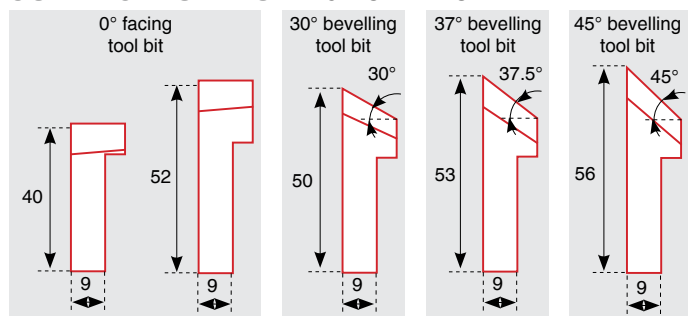
Specifications with pneumatic motor	
Air requirement	0.6 MPa (87 psi)
Air consumption	1400 l/min (50 CFM)
Power	800W
Connection	CEJN 410 DN 10.4 R 1/2" BSPT fitting for quick-coupling
Nominal rotational speed	105 rpm
Weight with motor	7.6kg
Specifications with electric motor	
Voltage	1 ~ 220-240 V, 50-60 Hz
Power	1100W
Nominal rotational speed	10-134 rpm (gear 1), 30-377 rpm (gear 2)
Weight with motor	7.4kg
Specifications with battery powered motor	
Voltage	18 V DC, 5.2 Ah
Nominal rotational speed	10-60 rpm (gear 1), 30-205 rpm (gear 2)
Weight with motor	6.5kg, including battery

Package Includes

- WA-PRO2PB beveler (not including motor or cutting inserts)
- Mandrel for pipe ID Ø 22-48 mm & 6 sets of springs (no. 3, 4, 5, 6, 7, 8)
- 3 sets of jaws (no. 3, 4, 5) & 3 sets of jaw blocks (no. 6, 7, 8)

Part No.	Description
WAP-B05/100	Pneumatic Motor suit PRO 2 PB
WAP-B02/110	Adapter And Driver For Pneumatic Motor
WAP-B02/105	Electric Motor suit PRO 2 PB
WAP-B02/112	Driver For Electric Motor
WAP-B02/108	Battery Powered Motor For Use With PRO 2 PB
WAP-B02/114	Driver For Battery Powered Motor
WAP-B02/150	Small Mandrel Set - Suit Pipes From ID 15.5mm (0.49") Up To OD 30mm (0.98") - Maximum Pipe Wall Thickness 3.5mm
WAP-B02/130	Extension Set - Extension Set For Pipes From ID 42mm (1.65") Up To OD 60.3mm (2.37")

CUTTING INSERTS - HIGH SPEED STEEL



Tool bits for stainless steel feature TiAlN coating

Part No.	Description
WAP-B02/F040	0° Facing Tool Bit Short For Use With Steel
WAP-B02/F040T	0° Facing Tool Bit Short For Use With Stainless Steel*
WAP-B02/F052	0° Facing Tool Bit Long For Use With Steel
WAP-B02/F052T	0° Facing Tool Bit Long For Use With Stainless Steel*
WAP-B02/B3050	30° Bevelling Tool Bit For Use With Steel
WAP-B02/B3050T	30° Bevelling Tool Bit For Use With Stainless Steel*
WAP-B02/B37553	37.5° Bevelling Tool Bit For Use With Steel
WAP-B02/B37553T	37.5° Bevelling Tool Bit For Use With Stainless Steel*
WAP-B02/B4556	45° Bevelling Tool Bit For Use With Steel
WAP-B02/FB556T	45° Bevelling Tool Bit For Use With Stainless Steel*

PRO 5 PB PORTABLE PIPE BEVELLER

- I.D. mounted pipe bevelling machine
- Designed for portable use by a single operator
- The self-centring expandable mandrel provides quick and correct alignment to pipe or tube
- Able to simultaneously perform 3 of the following operations; external bevel, internal bevel, face off, I.D. chamfer, J-groove bevel, and counterbore



PRO 5 PB shown with electric motor

Pipe machining range

- 32mm I.D. minimum to 114mm O.D. maximum pipe capacity as standard
- 140mm O.D. maximum pipe capacity with optional 140mm spindle disk set
- 12mm maximum wall thickness

Part No.	WA-PRO5PBA	WA-PRO5PBE
Motor	Pneumatic Motor 800W	Electric Motor 1100W
Rotational Speed	90rpm	gear 1: 0 to 90rpm gear 2: 0 to 300rpm
Air Consumption	1600 l/min (49.4CFM)	-
Weight (incl. PRO5PB)	10kg	11kg
Overall Length	533mm	577mm

Package Includes

- PRO 5 PB Bevelling Machine with Electric or Pneumatic Motor
- Mandrel 32mm I.D. to 107mm I.D.
- 118mm spindle disc
- 3 Set of jaw blocks (1,2,3,4,5,6)
- Coolant container

Consumables

Part No.	Description	Use With Pipe O.D.		
		32 - 56mm	56 - 83mm	83 - 114mm
WAP-B05/B30	External Bevelling HSS Cutting Tip 30°		✓	✓
WAP-B05/B30D	External Bevelling HSS Cutting Tip 30° Deep	✓	✓	
WAP-B05/B37	External Bevelling HSS Cutting Tip 37.5°		✓	✓
WAP-B05/B37D	External Bevelling HSS Cutting Tip 37.5° Deep	✓	✓	
WAP-B05/B45	External Bevelling HSS Cutting Tip 45°		✓	✓
WAP-B05/B45D	External Bevelling HSS Cutting Tip 45° Deep	✓	✓	
WAP-B05/IC1540	Internal Bevelling HSS Cutting Tip 15° For Diameters Under 56mm	✓		
WAP-B05/IC1540/56	Internal Bevelling HSS Cutting Tip 15° For Diameters Over 56mm		✓	✓

Consumables

Part No.	Description
WAP-B05/BJ20R8	J-Groove Bevelling HSS Cutting Tip 20° R8
WAP-B05/BJ10R6	J-Groove Bevelling HSS Cutting Tip 10° R6
WAP-B05/BJ15R2	J-Groove Bevelling HSS Cutting Tip 15° R2
WAP-B05/F030	Facing HSS Cutting Tip 30mm Width

75mm Spindle Disc

WAP-B05/140

For working in tight spaces of 75mm width or more (standard machine setup requires 118mm or more.) When used in this manner the standard handles must be replaced with a ratcheting wrench.



Extension Set

WAP-B05/130

Extension set for OD up to 140mm. Including 140mm spindle disc and jaw blocks 3 sets (7, 8, 9).



PRO 10 PB

PORTABLE PIPE BEVELLER



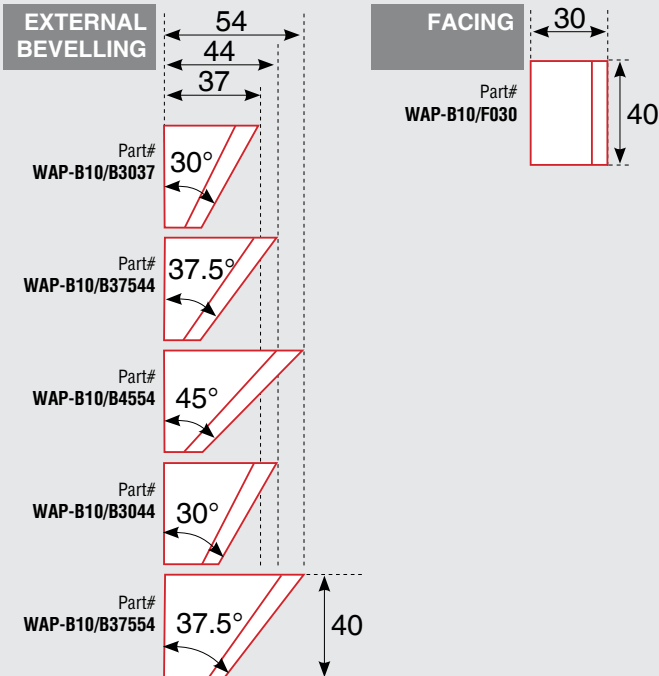
PRO 10 PB shown with electric motor

- I.D. mounted portable pipe beveling machine
- Large capacity heavy duty machine
- Can be used efficiently by a single operator
- Self-centring expandable mandrels
- Can simultaneously perform 3 of the following operations - internal bevel, external bevel, J-groove bevel, face off, I.D. chamfer and counterbore
- Can be operated with just 1 cutting insert though optimal results are achieved by using 3 cutting inserts at once
- Available with either a pneumatic motor or high torque electric motor

Part No.	WA-PRO10PBA	WA-PRO10PBE
Motor	Pneumatic Motor 1.5kw	Electric Motor 1.8kw
Power Requirements	1750 l/min at 630 kPa	230V/50Hz
Spindle Speed	20rpm	2 Speed Gearbox With Electronic Variable Speed 12 - 28; 41 - 96rpm
Overall Length	540mm	580mm
Weight (with standard mandrel)	32.0kg	36.0kg

CUTTING INSERTS

HIGH SPEED STEEL



OPTIONAL ATTACHMENTS

SMALL EXPANDING MANDREL SET

Part# WAP-PB10/510

- Enables machining of pipe 38 to 86mm I.D.
- 292mm tooling reach
- Includes jaw blocks No.1 to No.5



MACHINE WORKING RANGE

PIPE BEVELLING & FACING RANGE - STANDARD

With standard equipment	I.D. 84 - 269mm Tooling Reach 292mm
Maximum wall thickness	15mm

PIPE BEVELLING & FACING RANGE WITH OPTIONAL ATTACHMENTS

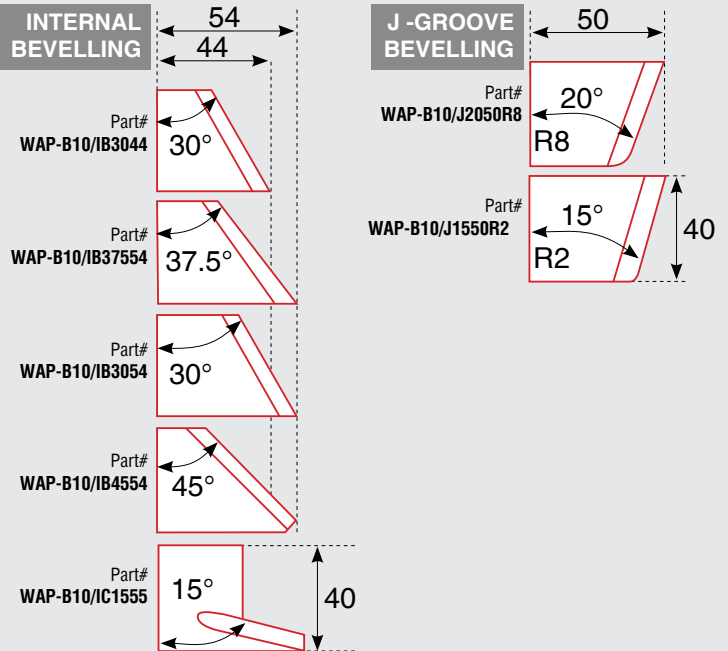
With optional Small Expanding Mandrel Set (Part No. WAP-PB10/510)	PIPE I.D. 38 - 86mm Tooling Reach 292mm
With optional Large Expanding Mandrel Set (Part No. WAP-PB10/540)	PIPE I.D. 126 - 296mm Tooling Reach 292mm
With optional Range Increasing Set (Part No. WAP-PB10/550). Recommended for wall thickness up to 7mm	PIPE I.D. 192 - 365mm Tooling Reach 372mm

FLANGE TURNING RANGE WITH OPTIONAL ATTACHMENTS

With standard mandrel & optional Flange Turning Attachment (Part No. WAP-PB10/520)	PIPE I.D. 84 - 269mm Turning Range 90 - 508mm
With optional Flange Turning Attachment (Part No. WAP-PB10/520) & optional Large Expanding Mandrel Set (Part No. WAP-PB10/540) & optional Range Increasing Set (Part No. PB10/550)	PIPE I.D. 219 - 392mm Turning Range 90 - 508mm

Package Includes

- PRO 10 PB Beveling Machine
- Electric or Pneumatic motor
- Mandrel for pipe 84mm I.D. to 269mm I.D.
- Jaw block set no. 1 to 6
- Toolbox & tools
- Coolant bottle



LARGE EXPANDING MANDREL SET

Part# WAP-PB10/540

- Specifically designed to be used with optional Flange Turning Attachment (WAP-PB10/520) & Range Increasing Jaw Block Set (WAP-PB10/550) for flange turning on pipe up to 392mm I.D. and turning range up to 508mm diameter
- 126 - 296mm I.D. with standard jaw block set
- 292mm tooling reach



PRO 10 PB

OPTIONAL ATTACHMENTS (continued)

RANGE INCREASING SET

Part# WAP-PB10/550

- Enables machining of pipe 192 - 365mm I.D. with standard mandrel fitted
- Recommended for wall thickness up to 7mm
- Jaw blocks No.7 to No.12 increase the pipe range to 192 - 365mm I.D.
- Includes 3 steel tool bit holders to increase the tooling reach to 372mm
- Supplied in a metal box.



OVAL PIPE ATTACHMENT

Part# WAP-B10/530

Overview

Attachment for bevelling and facing oval shaped pipe. The spring loaded guide roller rotates on the I.D. of the pipe, and allows the cutting insert to move in and out with the oval pipe up to 15mm.



Specifications

- 84 - 269mm I.D. with standard jaw block set
- 126 - 296mm I.D. with optional Large Expanding Mandrel Set (WAP-B10/540)



FLANGE TURNING ATTACHMENT

Part# WAP-PB10/520

Part# WAP-PB10/520INSERT (Indexable carbide insert to suit)

Overview

Flange turning attachment using indexable carbide inserts with cutting capacities 90 to 508mm diameter. The machine can mill inwards or outwards at a feed rate of 0.33mm or 0.66mm per revolution, using a bumper system to automatically feed the carbide insert with each revolution of the machine.

Specifications

- Minimum milling diameter : 90mm
- Maximum milling diameter : 508mm
- Feed rate: 0.33mm per revolution using 1 bumper or 0.66mm per revolution using 2 bumpers
- Recommended maximum milling depth : 0.5mm per pass



PRO 40 PBS

PIPE BEVELLING MACHINE

- High-speed rotary milling head with replaceable inserts
- Heavy duty milling head offers accurate bevels in a fraction of the time compared to traditional single point machining
- Bevel widths up to 45mm and angles between 0° and 60°
- Internal bevelling and J-groove end preparation is an available option.
- An optional Oval Pipe attachment is available for bevelling of pipe which is not truly round



Part No.	PRO40PBS
Power supply	Single Phase 240V
External pipe diameter range	200-1000mm Pipe Longer Than 830mm; 200-600mm Pipes Of 400-830mm Length
Maximum pipe weight	6 000kg With Standard Plastic Rollers On Active Support 10 000kg With Optional Steel Rollers On Active Support
Min. pipe thickness	5mm
Pipe fixing	Mechanical With Chain
Feed rate	100 - 1100 mm/min
Bevelling angle range	0° - 60° With Continuous Angle Adjustment
Max OD bevel width	45mm
Max ID bevel width	5mm Standard, Up To 20mm - Optional
Bevelling type "J"	YES - Optional
"J" type bevelling radius	6mm or 8mm
Overall Dimensions (with a 1.4m x 1m dia. pipe)	2372mm L x 1507mm W x 1993mm H
Weight	1100kg

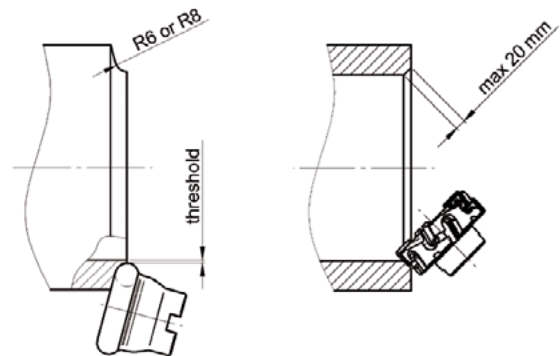
Accessories & Consumables

Part No.	Description
WAP-B40/8010	Standard Milling Head
WAP-B020	Replacement Standard Cutting Tips (7 Required)
WAP-B040	Cutting Tips For Hard Steels (7 Required)
WAP-B40/8020	J-Groove R6 Milling Head
WAP-B40/8040	J-Groove R6 Cutting Tip (6 Required)
WAP-B40/8030	J-Groove R8 Milling Head
WAP-B40/8050	J-Groove R8 Cutting Tip (5 Required)
WAP-B40/8090	Oval Attachment

Operations With Optional Heads

J-groove Bevelling

Internal Bevelling



MINI SPIDER COMPACT WELDING CARRIAGE

- Produce continuous fillet welds using MIG/MAG torches.
- 4-wheel drive system with magnetic base
- Constant, continuous and repeatable travel speed enables weld bead geometry that is exact to the required specifications
- Compact and lightweight design to weld in narrow spaces
- Convenient 18V DC battery supply (the same battery for both Mini Spider and Gecko Battery)
- An optional power supply can be used to plug the carriage into a 110-240V power source.
- Torch placement on either left or right side
- Welding edge to edge
- Closed-loop speed control system ensures increased speed accuracy
- Consistent heat input reduces distortion
- Reduces wasted filler metal - eliminates over welding
- Digital LED display for presetting of travel speed and diagnostic messages
- Low-battery indicator
- Built-in guide rollers
- Torch Diameter 16-22mm
- Min workpiece thickness 4mm
- Ground clearance 4mm



Part No.	WA-SPIDER
Voltage	18V DC, 5.2 Ah 1~ 110-240V, 50-60 Hz (option)
Power	25W
Welding position (according to EN ISO 6947 and AWS/ASME)	PB / 2F PD / 4F
Horizontal pulling force	150N
Vertical pulling force	100N
Horizontal speed *	0-110 cm/min
Vertical speed *	0-100 cm/min
Overall Dimensions	191mm(W) x 194mm(H) x 350mm(L)
Weight	7.6kg w/o battery

*With fully charged battery

Package Includes

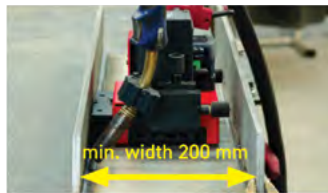
- Mini Spider welding carriage
- 5.2 Ah Battery (Charger sold separately WAP-G3510)
- Torch Holder
- 4 mm hex wrench
- 3 mm hex wrench
- Operator's Manual



Torch placement on either left or right side



Welding edge to edge



Welding in narrow spaces

Accessories

Part No.	Description
UCW-0655-08-00-00-0	Cable Anchor Suit Spider
LDW-000006	Battery Charger Suit Spider
ZSL-0526-20-00-00-0	Power Supply Suit Spider
PWD-0466-18-00-00-0	Power Cord 3 Metre For Power Supply Suit Spider

GECKO STANDARD GECKO HS HIGH SPEED GECKO BATTERY BATTERY POWERED PORTABLE WELDING CARRIAGE

- Portable fillet welding carriage designed to produce consistent high quality welds
- 4-wheel drive system with magnetic base traction and a control loop feedback mechanism
- Constant, continuous and repeatable travel speed enables weld bead geometry that is exact to the required specifications, thus substantially reducing costly over welding and decreasing filler metal usage.
- Suitable for both speed welding and plasma cutting.
- Compact & lightweight design with durable aluminum housing
- Permanent magnet clamping system with on/off lever ensures positive magnetic traction
- Maintenance free 4-wheel drive with worm gear reduction
- Quick clamping torch holder mechanism for different types of MIG/MAG torches with diameters of 16-22mm (5/8"-7/8")
- Precise torch adjustment with screw drive cross slide
- Multifunctional LED display - presetting of travel speed, metric & imperial units, error codes information
- Closed loop speed control system stabilises travel speed to reduce weld defects and costly rework
- Consistent heat input reduces distortion
- Automatic ARC ON/OFF system initiates welding and travel, simultaneously
- Self-guiding roller arms eliminate the need for track
- Improves working environment - removes operator from heat and fumes



Battery Powered Model Features

- Supplied with 18V DC 5.2 Ah battery providing 6 hours average operation time (Charger sold separately WAP-G3510)
- Gecko Battery can also be connected to 240V AC mains by means of power supply (Sold separately WAP-G3520)

Standard Part No.	WA-GECKO
High Speed Part No.	WA-GECKOHS
Battery Model Part No.	WA-GECKO-18V
Power supply	115-230VAC / 50-60Hz
Welding positions	Vertical / Horizontal
Chassis to material clearance	4mm
Travel mechanism	Friction Drive With Worm Gear Reduction, 4 Wheel Drive, Heat Resistant Silicone Wheels
Tracking method	2-Guide Rollers
Torch adjustment	Up-Down 35mm, Left-Right 35mm
Gear roller adjustment	100mm
Horizontal speed (GECKO)	0-1100mm/min
Horizontal speed (GECKO - HS)	0-2200mm/min
Vertical speed	0-1000mm/min
Dimensions	240mm (L) x 258mm (W) x 253mm (H)
Weight	8kg (8.6kg battery model)

WA-GECKO Standard Package Includes

- Welding carriage
- Power lead
- Arc ignition cable
- Torch holder
- 4mm Allen key
- Operator's manual



LIZARD PROGRAMMABLE WELDING CARRIAGE

- Portable welding carriage designed to produce consistently high quality welds.
- Programmable welding patterns and parameters, and an optional oscillating attachment is available.
- Enables weld bead geometry that is exact to the required specifications, thus substantially reducing costs.
- Simple to use multifunction LED display for programming welding patterns & parameters including travel speed, weld length, skip length, total length, reverse fill & crater fill time. These settings can be saved, & up to 40 different programs can be stored.
- Continuous and stitch weld capability
- Compact & lightweight design with durable cast aluminum housing
- Permanent magnet clamping system with on/off lever ensures positive magnetic traction
- Maintenance free 4-wheel drive with worm gear reduction
- Friction drive and control loop feedback mechanism provides speed stabilisation in all positions, to reduce weld defects
- Automatic off limit switches on both ends of machine
- Automatic ARC ON/OFF system initiates welding and travel, simultaneously
- Quick clamping torch holder mechanism for different types of MIG/MAG torches with diameters of 16 - 22mm (5/8" - 7/8"); optionally up to 35mm (1-3/8")
- Precise torch adjustment with screw drive cross slide
- Consistent heat input reduces distortion
- Self-guiding roller arms eliminate the need for track
- Improves working environment - removes operator from heat and fumes



Part No.	WA-LIZARD
Power supply	115-230VAC / 50-60Hz
Welding positions	Vertical / Horizontal
Chassis to material clearance	5mm
Travel mechanism	Friction Drive With Worm Gear Reduction 4 Wheel Drive Heat Resistant Silicone Wheels
Tracking method	2-Guide Rollers
Torch adjustment	Up-Down 35mm, Left-Right 35mm
Gear roller adjustment	75mm
Horizontal speed	0-1200mm/min
Vertical speed	0-1100mm/min
Dimensions	282mm (L) x 272mm (W) x 390mm (H)
Weight	13.5kg

Package Includes

- Welding carriage
- Power lead
- Arc ignition cable
- Cable holder
- Torch holder
- Lower torch holder
- 4 mm Allen key
- Operator's manual

Oscillation Attachment

A critical optional feature of the LIZARD is the oscillation attachment. This attachment allows the unit to be capable of performing weave welds.

- Oscillation type: Angular max 11°
- Amplitude R - 150mm : 2 - 30mm
- Frequency: 12 - 115 cycles/min
- Delay at ends: 0 - 3 secs
- Weight: 2.5kg



Part# WAP-L4000

Gecko & Lizard Accessories



Part No.	Description
WAP-G2010	Dual Torch Mount - Enables Mounting Of A Second Torch For Dual Sided Fillet Welding.
WAP-G2020	Torch Extension Arm To Suit Gecko & Lizard
WAP-G2030	Edge Guide Arms To Suit Gecko - Enables Guiding Off An Outside Edge
WAP-L4010	Edge Guide Arms To Suit Lizard - Enables Guiding Off An Outside Edge
WAP-L4040	Large Torch Clamp Designed To Hold Large Diameter Torches 22 to 35mm To Suit Lizard
WAP-G2040	Adjustable Guide Arms To Suit Gecko - Enables Guiding On Lap Joints And Templates
WAP-L4020	Adjustable Guide Arms To Suit Lizard - Enables Guiding On Lap Joints And Templates
WAP-G2050	110mm Length Torch Arms To Suit Gecko & Lizard
WAP-L4030	230mm Length Torch Arms To Suit Gecko & Lizard
WAP-G2080	Follower Guide Arms For Flexible Track To Suit Gecko
WAP-L4050	Follower Guide Arms For Flexible Track To Suit Lizard
WAP-G2060	1825mm Flexible Track To Suit Gecko & Lizard
WAP-G2070	Magnetic Block To Suit Flexible Track
WAP-G2090	Torch Clamp Assembly To Suit Gecko

**VIEW EXTRA PRODUCT INFORMATION
& VIDEO DEMONSTRATIONS OF
OUR WELDING CARRIAGES
ON OUR WEBSITE**

ITMTOOLS.COM.AU

RAIL TUG



- Welding and cutting carriage
- Suitable for use on plate or pipe from 200mm to 10m diameter
- No oscillation
- Rack and pinion drive track system
- Suitable for variety of circumferential and irregular surface applications down to minimum radius of 200mm:
 - Ring tracks on diameters from 200mm OD up to 3m OD
 - Custom rolled tracks on diameters from 3m OD up to 10m OD
 - Semi-flexible tracks can be flexed to minimum radius of 5m without permanent deformation
 - Hi-flex track from 1500mm OD
- Compact, lightweight design
- Closed-loop position control system ensures increased accuracy of speed and position
- Quick-clamping torch holder mechanism for different types of torches with diameters of 16 - 22mm; up to 35mm option
- Consistent heat input reduces distortion
- Reduces wasted filler metal - eliminates over welding
- Digital LED display for presetting of travel speed
- Automatic arc on/off initiates welding and travel simultaneously
- Oxy-fuel and plasma cutting possible with optional accessories
- Precise torch adjustment with screw drive cross slide
- Using a vacuum system allows the track to be clamped to non-ferrous surfaces (stainless steel, aluminium etc.) - optional
- Convenient external 230V, 115V power supply
- Improves working environment - removes operator from heat and fumes
- High speed up to 3m/min makes plasma cutting available

* All Tracks Sold Separately - See pg 12

Part No.	WA-RAILTUG
Voltage	1~115-230 V, 50/60 Hz
Power	66w
Welding position (according to EN ISO 6947 and AWS/ASME)	PA / 1F / 1G PB / 2F PC / 2G PD / 4F PE / 4G (in certain applications only) PG / 3F
Horizontal pulling force	300N
Vertical pulling force	200N
Horizontal speed	10-200 cm/min
Vertical speed	10-200 cm/min
Overall Dimensions	334mm(L) x 713mm(W) x 379mm(H)
Weight	10kg

RAIL BULL



- Welding and cutting carriage
- Suitable for use on plate or tanks with minimum radius of 5 metres
- In-built Oscillator
- Rack and pinion drive track system
- Moves along either rigid or semi-flexible track on both ferromagnetic and non-ferromagnetic materials thanks to rack and pinion drive and tracks fixed to flat or curved surfaces by means of various magnetic or vacuum units. The minimum curvature radius required for semi-flexible track is 5m.
- Continuous welding
- Compact, lightweight design with durable aluminum cast housing
- Closed loop position control system ensures increased accuracy of speed and positioning
- Quick clamping torch holder mechanism for different types of MIG/MAG torches with diameters of 16-22mm; up to 35mm option
- Precise torch adjustment with screw drive cross slide
- Ready to work in both vertical & horizontal positions
- Multifunctional LED display
- Consistent heat input reduces distortion
- Reduce wasted filler metal - eliminates over welding
- Automatic arc on/off initiates welding and travel, simultaneously
- Improves working environment - removes operator from heat and fumes
- Linear torch oscillator to produce weave welds with trapezoid, triangle and straight line paths
- Stores most recent welding settings
- Cross slide adjustment range: 0-35mm, up-down, left-right
- Minimum workpiece thickness 5mm

* All Tracks Sold Separately - See pg 12

Part No.	WA-RAILBULL	
Voltage	1~ 115-230 V, 50-60 Hz - 42 V, 50-60 Hz	
Power	100W	
Welding position (according to EN ISO 6947 and AWS/ASME)	PA / 1F / 1G PB / 2F PC / 2G PD / 4F PE / 4G PF / 3G PG / 3G	
Horizontal pulling force	350N	
Vertical pulling force	150N	
Horizontal speed	0-120 cm/min	
Vertical speed	0-110 cm/min	
Oscillation	width	0-50 mm
	speed	0-1500 mm/min
	delay time	0-5s (at external and central points)
Overall Dimensions	441mm(L) x 670mm(W) x 362mm(H)	
Weight	20kg	

RAIL BULL 2



- All-position welding and cutting carriage
- Suitable for use on plate or pipe
- In-built Oscillator
- Rack and pinion drive track system
- Suitable for variety of circumferential and irregular surface applications down to minimum radius of 200mm:
 - Ring tracks on diameters from 200mm OD up to 3m OD
 - Custom rolled tracks on diameters from 3m OD up to 10m OD
 - Semi-flexible tracks can be flexed to minimum radius of 5m without permanent deformation
 - Hi-flex track from 1500mm OD
- Fully modular mechanized travel carriage can be custom configured for a variety of welding, thermal cutting and gouging applications on flat or curved plate, tube and pipe
- Linear torch oscillator to produce weave welds with straight, triangle, trapezoid & square paths
- Suitable for MIG/MAG, TIG, Plasma & Oxy-fuel torches with diameters of 16-22mm; up to 35mm option
- Active compensation of torch position vertically and horizontally by means of modular automatic seam tracking system - optional
- Programmable path of stitch welds
- Possibility to select one limit switch preset out of three presets available.
- Suitable for all welding positions on both ferromagnetic and non-ferromagnetic materials thanks to rack and pinion drive and various tracks equipped with magnetic or vacuum units
- Ergonomic remote control pendant with simple control system makes adjustments possible while using welding helmet
- Magnetic remote control pendant provides firm grip on ferromagnetic materials
- High speed up to 3m/min makes plasma cutting available
- Optional seam tracking attachment (shown in photo) sold separately

* All Tracks Sold Separately - See pg 12

Part No.	WA-RAILBULL2	
Voltage	1~230 V, 50-60 Hz - 1~115 V, 50-60 Hz 1~ 42 V, 50-60 Hz	
Power	120W	
Welding position (according to EN ISO 6947 and AWS/ASME)	PA / 1F / 1G PB / 2F PC / 2G PD / 4F PE / 4G PF / 3G PG / 3G (in certain applications only) PG / 3F	
Horizontal pulling force	400N	
Vertical pulling force	300N	
Horizontal speed	0-300 cm/min	
Vertical speed	0-300 cm/min	
Oscillation	width	0.2-11.8 cm
	speed	10-300 cm/min
	delay time	0-5s (at external and central points)
Overall Dimensions	318mm(L) x 470mm(W) x 354mm(H)	
Weight	10kg	

DRAGON CUTTING & BEVELLING CARRIAGE

- Cutting and bevelling 0° to 45° (also parallel with 2 cutting torches)
- Quick clamping torch holder for torch diameter 28mm to 35mm
- Advanced speed control system with implemented digital control loop feedback PID regulator
- LED display with readout of actual and set speed, and report messages
- Optional circle cutting attachment available
- 2-wheel drive with automatic braking drive unit
- Quick drive release switch for easy re-positioning
- Connectable 2200mm rails to form various lengths
- Rigid and heat-proof design



*Track sold separately
Part# WAP-D6010

*Track sold separately

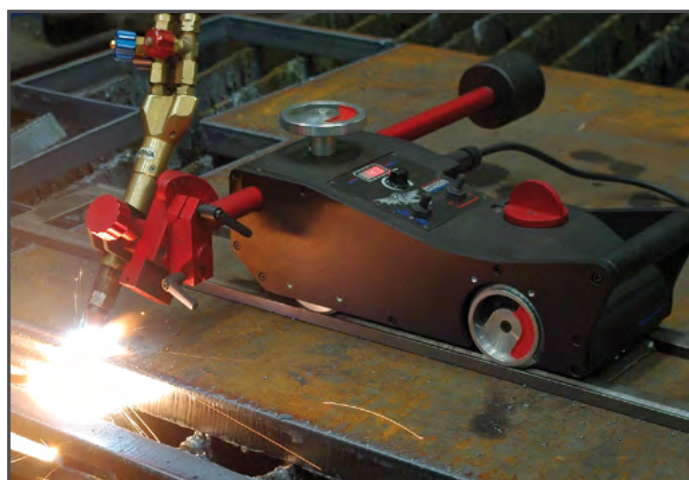
Part No.	WA-DRAGON
Power supply	115-230VAC / 50-60Hz
Power	13W
Torch grip diameter	28-35mm
Chassis to material clearance	7.5mm
Travel mechanism	4 Knurled Wheels, 2 Wheel Drive
Guiding equipment	Optional "V" Type Rail With Grooves At 152mm Centres, 1800mm Length (Part# WAP-D6010) Circle Cutting Attachment (Part# WAPD6150)
Cutting speed	0-1500mm/min
Chassis dimensions	427mm(L) x 189mm(W) x 180mm(H)
Overall dimensions	473mm(L) x 655mm(W) x 180mm(H)
Weight	16.8kg

Package Includes

- Dragon carriage
- Torch rack 580mm
- Counterweight 1.3kg
- Torch holder with angle & height adjustment (Part# WAP-D6030)
- Operator's manual

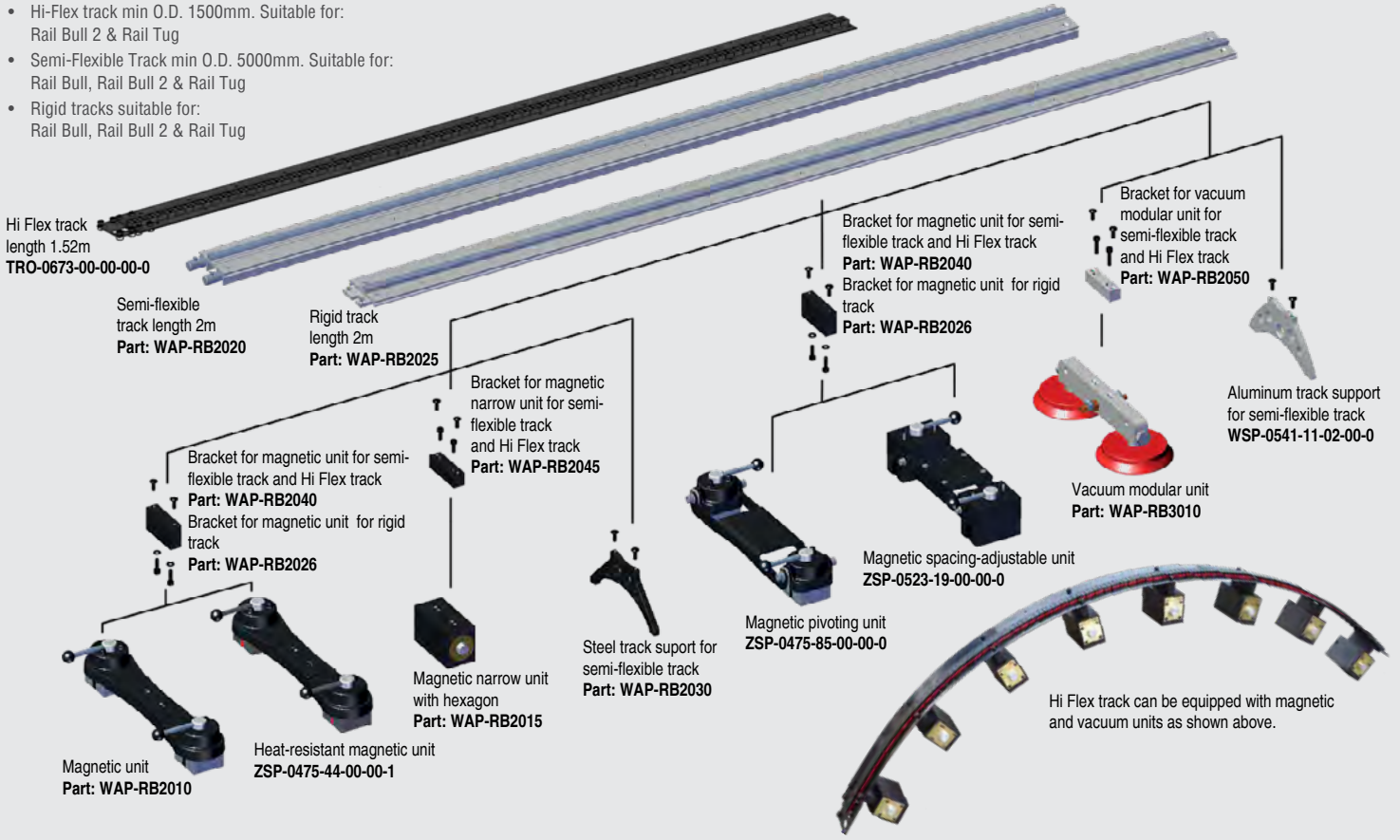
Accessories & Consumables

Part No.	Description
WAP-D6020	Basic Torch Holder
WAP-D6030	Torch Holder With Angle & Height Adjustment
WAP-D6040	Machine Torch Holder
WAP-D6050	Machine Torch Holder With Angle Adjustment
WAP-D6010	Track Assembly
WAP-D6060	Sliding Torch Holder Mount
WAP-D6180	Cable Anchor
WAP-D6190	Carriage Support
WAP-D6160	Large Counterweight
WAP-D6150	Circle Cutting Attachment
WAP-D6170	Extended Torch Rack



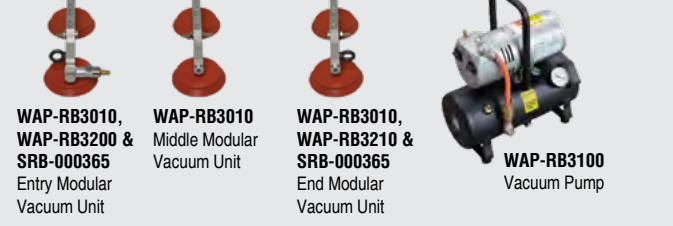
Rigid, Semi Flexible & Hi-Flex Tracks

- Hi-Flex track min O.D. 1500mm. Suitable for:
Rail Bull 2 & Rail Tug
- Semi-Flexible Track min O.D. 5000mm. Suitable for:
Rail Bull, Rail Bull 2 & Rail Tug
- Rigid tracks suitable for:
Rail Bull, Rail Bull 2 & Rail Tug



Vacuum Track Fitting System

- Provides firm grip of track segments on both ferrous and non-ferrous materials.
- Light-weight and modular design enables easy adjustment and fitting of the system to specific needs depending on welding or cutting applications and working positions (e.g. flat, horizontal or vertical).
- Can be applied to both rigid and semi-flexible tracks to enable usage on surface with a radius of more than 5 m (16 ft).
- Single vacuum unit provides suction power of 1400N (-0,7bar)
- Permitted load up to 30kg (welding/cutting carriage & accessories)
- Temperature of material on which vacuum pads are used cannot exceed 320°C
- Safety eye bolts are available to suspend vacuum track segments and protect them against accidental fall.



Part No.	Description
WAP-RB2050	Bracket For Vacuum Modular Unit For Semi-Flexible Track
WAP-RB3010	Vacuum Modular Unit For Rigid & Semi Flexible Track
WAP-RB3110	Connection Hose, 10 Metre For Vacuum Pump
WAP-RB3120	Interconnection Hose, 2 Metre For Vacuum Modular Units
WAP-RB3130	Hose, Between Vacuum Units On Separate Rails
WAP-RB3200	Cut Off Entry Valve For Vacuum Unit
WAP-RB3210	Plug For End Vacuum Unit
SSW-0541-99-01-00-0	Spare Vacuum Pad

Vacuum Pump	WAP-RB3100
Voltage	115V 50/60Hz or 230V 50/60Hz
Power	0,4 kW
Vacuum	min -0,8 bar
Pump Capacity	4 m ³ /h (141 ft ³ /h)
Noise Level	max 70 dB
Ambient Temperature	0°C to 40°C
Safety Reservoir Volume	10L
Weight	23 kg

Ring Tracks

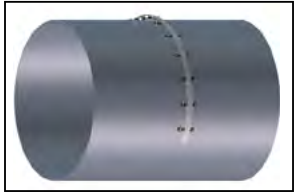
- Suitable for Rail Bull 2 & Rail Tug
- For circumferential applications from 200mm OD up to 3000mm OD (in 50mm increments).
- Can be equipped with various supports depending on the customer's needs.



Part No.	Description
WAP-RB2210	Support with bolts
WAP-RB2208	Support with magnets
WSP-0523-14-12-00-0	Support with plastic feet

Custom Rolled Tracks

- Suitable for Rail Bull 2 & Rail Tug
- Available for circumferential applications from 3m OD up to 10m OD



Distributor Details: