



SDB 206/2

Small Diameter Beveler

PORTABLE PIPE &, TUBE PREPPING MACHINE

Wachs SDB 206/2, a hand held beveling machine that delivers maximum power and performance for fast, accurate weld preps on pipe and tube from 2" I.D. thru 6" O.D. (50.8mm to 152.4mm). Pipe or tube up to .750" (19.05 mm) wall.

Face, bevel and counterbore simultaneously on carbon, stainless and high alloy steels.

Benefit from the SDB's versatility. Machine boiler tube, heavy wall pipe, thin wall tube, prep elbows and face flanges with the SDB 206/2.

FAST SETUP

- Set up and operate from storage case to pipe in under 10 minutes.
- "QUICK CHANGE " extension legs use captivated fasteners to mount firmly to mandrel.
- One adjustment, universal three leg chuck automatically centers and squares the machine in pipe I.D.
- Install or adjust tool bits in seconds.
- Converts to a Flange Facer in minutes with a FF 313 Flange Facing module.

EASY OPERATION

- Convenient "Fail safe" on/off motor valve.
- Adjustable hand grip speed control.
- In-feed hand wheel with indices for precise measurement.
- Adjustable dual key design makes tool feed easy, absorbs torque, reduces operator fatigue and increases safety.
- Compact design requires minimal radial clearance of only 2.25"
- Powerful 2-1/2 horse power air motor easily machines .750" (19.05 mm) wall stainless pipe or tube.
- Setup square in elbows, tees, and valves with adjustable 3 leg fitting mandrel.

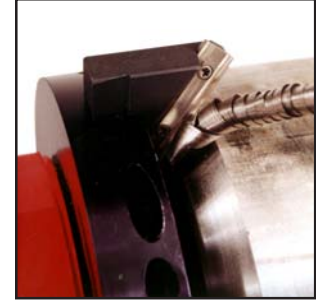


SDB 206/2 BEVELING MACHINE

VERSATILE DESIGN

- Compact, heavy duty cast Aluminum housing is tough yet lightweight.
- Four tool rotating head with large "easy to access" tool locking set screws.
- Precision tapered roller bearing and self lubricating bushing maximize machine life.
- High strength, mandrel shaft and wide surface chuclegs maximize rigidity.

- Right angle air motor placement satisfies minimum clearance requirements.
- Special heat treated ring and pinion gears for demanding pipe prepping applications.
- Corrosion and wear resistant finish applied to external components.



Convert from beveler to flange facer in minutes with the Flange Facing Module for raised and flat faced flanges from 3" (76.2mm) I.D. through 13" (330.2 mm) O.D.

Independent Fitting Mandrel: Adjustable 3-leg "Short Perch" mount for elbows, bends, flanges, fitting and valves.

SDB 206 & 412 Insert Tooling System: Significantly reduces tooling costs. Tool holders for facing & beveling utilize replaceable double edge cutting inserts.

SPECIFICATIONS

MACHINING FUNCTION: PORTABLE PIPE PREPPING MACHINE: FACE, BEVEL, COMPOUND BEVEL, J PREP, AND COUNTERBORE USING UP TO 4 TOOLS SIMULTANEOUSLY. • MACHINE FLAT FACE AND RAISED FACE FLANGES, RECORD GROOVE (500 RMS), 250 RMS, 125 RMS, AND 63 RMS SURFACE FINISHES WITH OPTIONAL FF 313 FLANGE FACING MODULE.

CAPACITY: MOUNT IN 2.28" (57.91 mm) I.D. THROUGH 6.58" (167.13 mm) I.D.**

CONTROLS: MANUAL IN-FEED WITH INDEX GAUGE FOR PRECISE IN-FEED AND MEASUREMENT
• ON/OFF FAIL-SAFE MOTOR LEVER • SPEED CONTROL VALVE.

AXIAL FEED: .08" (2 mm) PER REVOLUTION 2-1/2" (63.5 mm) TOTAL USABLE TRAVEL.

MANDREL: SELF-CENTERING, I.D. MOUNTED, SINGLE ACTION 3 BLADE SYSTEM WITH ADJUSTABLE EXPANSION NUT. COMPLETE SET OF 10 "CAPTIVATED FASTENER" EXTENSION LEG SETS TO COVER 2.28" (57.91mm) THROUGH 6.58" (167.13 mm) I.D. PIPE OR TUBE.

DRIVE: PNEUMATIC, HYDRAULIC , ELECTRIC 110 VOLT OR 220 VOLT

AIR REQUIREMENTS: 70 CFM @ 90 PSI (1.98 cu.m @ 6.2 BAR)

HYD. REQUIREMENTS: 8 GPM @1500 PSI (30.28 LPM @ 103 BAR)

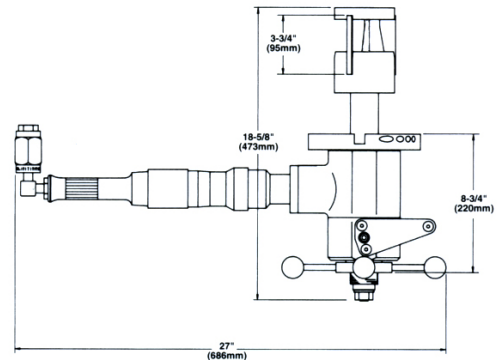
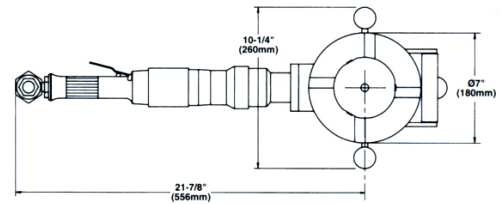
TOOL RPM: 0 TO 60 RPM

TOOLING: PREMIUM HIGH SPEED STEEL AND CARBIDE INSERT TOOLING SYSTEM. IN STANDARD OR J PREP CONFIGURATION TO FACE OR BEVEL, COUNTERBORE. CUSTOM TOOLING AVAILABLE UPON REQUEST.

WEIGHT: BASIC MACHINE WITHOUT MANDREL 28 LBS. (12.7 KG.)
STANDARD MANDREL 7 LBS. (3.18KG.)

STANDARD EQUIPMENT: BASIC MACHINE AND AIR MOTOR DRIVE • STANDARD MANDREL AND COMPLETE EXTENSION LEG SET • OPERATING TOOLS
• MANUAL • STORAGE CASE.

OPTIONAL ACCESSORIES: FITTING MANDREL, 3-LEG ADJUSTABLE FOR ELBOWS, TEES, VALVES AND FLANGES • FLANGE FACING MODULE • ATM "AIR TREATMENT MODULE" • LOW CLEARANCE TOOL HOLDER • DIAL INDICATOR SYSTEM • DELRIN COLLET MANDREL FOR THIN WALL TUBE & PIPE • SMALL MANDREL FOR 1.91" THRU TO 2.46" • RANGE EXTENDER KIT FOR 8" PIPE.



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