

# Accessories for BRB and REB machines

## Tool holder WH

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 72.

ARTICLE	WELD PREP PROFILE	APPLICABLE WITH	HEIGHT [MM]	HEIGHT [INCH]	CODE	KG
WH5-I	I	BRB 2 / REB	10	0.394	790 085 230	0.005
WH4-I*	I	BRB 2	10	0.394	790 085 234	0.033
WH12-I	I	BRB 4	20	0.787	790 086 210	0.035
WH12-I / short	I	BRB 2 / BRB 4	14	0.551	790 086 281	0.032
WH15-I	I	BRB 4 / REB	20	0.787	790 092 202	0.100
WH15-I	I	BRB 4 / REB	27	1.063	790 092 204	0.100
WH15-I**	I	BRB 4 / REB	16.5 - 23	0.650 - 0.906	790 093 410	0.247
WH30-I	I	REB	20	0.787	790 093 202	0.166
WH30-I	I	REB	27	1.063	790 093 204	0.235
WH5-V-30°	V/Y	BRB 2	-	-	790 085 236	0.015
WH12-V-30°	V/Y	BRB 4	-	-	790 086 214	0.040
WH12-V-30° / short	V	BRB 2 / BRB 4	-	-	790 086 282	0.036
WH12-V-37.5°	V/Y	BRB 4	-	-	790 086 216	0.040
WH12-V-45°	V/Y	BRB 4	-	-	790 086 474	0.052
WH12-V-80°	V/Y	BRB 4 / REB	-	-	790 093 462	0.115
WH12-V-35°	V/Y	BRB 4	-	-	790 086 272	0.048
WH15-V-30°	V/Y	BRB 4 / REB	-	-	790 092 210	0.100
WH15-V-37.5°	V/Y	BRB 4 / REB	-	-	790 092 216	0.100
WH12-V-37.5° / short	V	BRB 2 / BRB 4	-	-	790 086 283	0.035
WH15-V-45°	V/Y	BRB 4 / REB	-	-	790 092 218	0.144
WH15-V-60°	V/Y	BRB 4 / REB	-	-	790 092 212	0.100
WH30-V-15°	V/Y	REB	-	-	790 093 468	0.200
WH30-V-25°	V/Y	REB	-	-	790 093 476	0.209
WH30-V-30°	V/Y	REB	-	-	790 093 210	0.192
WH30-V-32.5°	V/Y	REB	-	-	790 093 424	0.234
WH30-V-37.5°	V/Y	REB	-	-	790 093 216	0.199
WH30-V-40°	V/Y	REB	-	-	790 093 510	0.237
WH30-V-45°	V/Y	REB	-	-	790 093 404	0.204
WH5-U-20°	U	BRB 2	-	-	790 085 228	0.014
WH12-U-10°	U	BRB 4	-	-	790 086 208	0.044
WH12-U-15°	U	BRB 4 / REB	-	-	790 086 213	0.044
WH12-U-20°	U	BRB 4	-	-	790 086 224	0.047
WH12-U-20° / large clamping surface	U	BRB 4 / REB	-	-	790 086 476	0.091
WH12-U-25°	U	BRB 4	-	-	790 086 212	0.051
WH30-U-5°	U	REB	-	-	790 093 509	0.210
WH30-U-7°	U	BRB 4 / REB	-	-	790 093 408	0.206
WH30-U-10°	U	BRB 4 / REB	-	-	790 093 220	0.174
WH30-U-14°	U	REB	-	-	790 093 474	0.190
WH30-U-20°	U	BRB 4 / REB	-	-	790 093 218	0.184
WH30-U-25°	U	REB	-	-	790 093 478	0.165
WH5-ID-14° / 10 mm (0.394") deep	ID	BRB 2	-	-	790 085 232	0.017
WH5-ID-14°	ID	BRB 4 / REB	-	-	790 093 406	0.139
WH5-ID-45°***	ID	BRB 2 / BRB 4 / REB	-	-	790 086 218	0.055
WH10-ID-5° / short	ID	BRB 4 / REB	-	-	790 093 398	0.135
WH10-ID-5° / long	ID	BRB 4 / REB	-	-	790 093 400	0.152
WH10-ID-14°	ID	BRB 4 / REB	-	-	790 093 402	0.160
WH10-ID-14° / 30 mm (1.181") deep	ID	BRB 4 / REB	-	-	790 093 466	0.265
WH12-ID-10° / from ID 50 (1.969")	ID	BRB 4 / REB	-	-	790 086 280	0.060
WH10-ID-30°	ID	BRB 4 / REB	-	-	790 093 493	0.100
WH10-ID-45°	ID	REB	-	-	790 093 494	0.107
WH10-ID-80°****	ID	BRB 2 / BRB 4	-	-	790 086 275	0.075

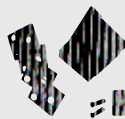
\* Special tool holder for facing pipes in pipe plates.

\*\* Adjustable tool holder WH for I-prep. Comes with adjustable tool holder, multifunctional tool MFW15-V/I-4 (Code 790 093 037), Torx screws and adjusting plates.

\*\*\* Special tool holder WH for cutting tubes from tube sheets.



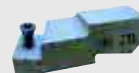
WH12-I



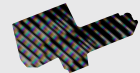
WH15-I\*\*



WH15-V-30°



WH12-U-15°



WH5-ID-14°

## Multifunctional tools MFW "Economy"

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

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

ARTICLE	VERSION	FOR WALL THICKNESS		APPLICABLE WITH TOOL HOLDER / FOR WELD PREP PROFILE	APPLICABLE WITH	CODE		KG
		[MM]	[INCH]					
MFW15-V/I-4	Economy	2 - 15	0.079-0.591	V, Y, I	BRB 4 / REB	790 093 047		0.033
MFW30-V/I-4	Economy	2 - 30	0.079-1.181	V, Y, I	REB	790 093 043		0.055

## Multifunctional tools MFW "High-Performance"

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

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

ARTICLE	VERSION	FOR WALL THICKNESS		APPLICABLE WITH TOOL HOLDER / FOR WELD PREP PROFILE	APPLICABLE WITH	CODE		KG
		[MM]	[INCH]					
MFW5-U-2-R0.4	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20° radius 0.4 mm	BRB 2	790 085 030		0.002
MFW5-U-2-R2	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20° radius 2 mm	BRB 2	790 085 032		0.002
MFW30-V / I-4	High-Performance	2 - 30	0.079 - 1.181	V, Y, I	REB	790 093 033		0.055
MFW30-U-4-R5	High-Performance	2 - 30	0.079 - 1.181	V, Y, I, U radius 5 mm	REB	790 093 034		0.055
MFW30-U-4-R2	High-Performance	2 - 30	0.079 - 1.181	V, Y, I, U radius 2 mm	REB	790 093 035		0.060
MFW30-U-4-R0.4	High-Performance	2 - 30	0.079 - 1.181	V, Y, I, U radius 0.4 mm	REB	790 093 042		0.060
MFW4-I-2	High-Performance	max. 4	max. 0.157	WH4-I-2 (special holder)	BRB 2	790 085 031		0.002
MFW15-V / I-4	High-Performance	2 - 15	0.079 - 0.591	V, Y, I	BRB 4 / REB	790 093 037		0.055
MFW12-V / I-2	High-Performance	2 - 12	0.079 - 0.472	V, Y, I, U radius 1.2 mm	BRB 4	790 086 060		0.003
MFW12-U-2-R2	High-Performance	2 - 12	0.079 - 0.472	V, Y, I, U radius 2 mm	BRB 4	790 086 064		0.003
MFW5-ID-2-R0.4 (14°)	High-Performance	-	-	WH5-ID-14° radius 0.4 mm	BRB 4 / REB	790 093 039		0.003
MFW5-ID-2-R0.4 (45°)	High-Performance	-	-	WH5-ID-45° radius 0.4 mm	BRB 4 / REB	790 086 061		0.002
MFW10-ID-2-R0.4 (80°)	High-Performance	-	-	WH10-ID-80° radius 0.4 mm	BRB 4	790 086 062		0.002
MFW10-ID-2-R0.8 (14°)	High-Performance	-	-	WH10-ID-14° radius 0.8 mm	REB	790 093 038		0.002
MFW10-ID-2-R3 (14°)	High-Performance	-	-	WH10-ID-14° radius 3 mm	REB	790 093 041		0.004

## Tool bits TB

Can only be used with the BRB 2 and BRB 2 FullAuto.

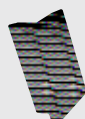
With a width of only 4.5 mm (0.177") the tool bits are ideal for shortening heat exchanger pipes. This allows even heat exchangers with minimal pipe spacing to be processed without problems. The opposing tool holders or cutting edges furthermore ensure improved force transmission.

The corresponding **tool retainer for tool bits** is already included in the scope of delivery at the BRB 2 FullAuto. At the BRB 2 it has to be ordered separately (see below).

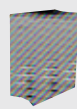
ARTICLE	WELD PREP PROFILE	APPLICABLE WITH	WIDTH	WIDTH	PREP ANGLE	CODE		KG
			[MM]	[INCH]				
TB4.5-I	I	BRB 2 / BRB 2 FullAuto	4.5	0.177	-	790 085 500		0.012
TB4.5-V-30°	V	BRB 2 / BRB 2 FullAuto	4.5	0.177	30	790 085 501		0.014
TB4.5-V-37.5°	V	BRB 2 / BRB 2 FullAuto	4.5	0.177	37.5	790 085 502		0.015
TB4.5-V-45°	V	BRB 2 / BRB 2 FullAuto	4.5	0.177	45	790 085 503		0.015
TB6-REMOVE-45°	-	BRB 2 / BRB 2 FullAuto	6.0	0.236	45	790 085 504		0.012



MFW15-V/I-4 "Economy"



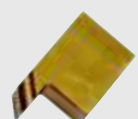
MFW30-U-4-R1



MFW15-V / I-4



MFW5-ID-2-R0.4 (14°)



Tool bits TB



Tool holder for tool bits TB

## Tool holder for tool bits TB

Already included in the scope of delivery of the **BRB 2 FullAuto**.  
This tool retainer is available separately for the **BRB 2**.

Depending on the application (for example the processing of heat exchangers) the use of tool bits (page 67) as well as the corresponding tool retainer is required.  
This retainer can be mounted on the BRB 2 and BRB 2 FullAuto in just a few steps.

ARTICLE	CODE	KG
Tool holder for tool bits	<b>790 085 510</b>	0.235



Tool retainer for tool combinations  
WH/MFW

## Tool retainer for tool combinations WH/MFW

Already included in the scope of delivery of the **BRB 2**.  
This tool retainer is available separately for the **BRB 2 FullAuto**.

Depending on the application, the use of conventional tool holders (see page 66) and multifunctional tools (page 67) as well as the associated tool retainer is required. This holder can be mounted on the BRB 2 and BRB 2 FullAuto in just a few steps.

Advantages:

- Only one multifunctional tool required for different types of processing (beveling, squaring), different pipe wall thickness and different pipe materials
- High-performance coated tool bits with up to 4 cutting edges
- Up to 3 tools can be used simultaneously

ARTICLE	CODE	KG
Tool retainer for tool combinations WH/MFW	<b>790 085 261</b>	0.300



Upgrade set BRB Standard "dimension extension"

## Upgrade sets BRB 2 for dimension extension

For dimension extension of BRB 2 machines through upgrading from Kit 2 to Kit 1 (BRB 2 Standard) or from Kit 1 to Kit 2 (BRB 2 NC).

MACHINE, CLAMPING SYSTEM	UPGRADING FROM KIT TO KIT	MANDREL Ø		TOOL RETAINER Ø		DIMENSION EXTENSION TO			
		[MM]	[INCH]	[MM]	[INCH]	TUBE ID		TUBE OD	
						[MM]	[INCH]	[MM]	[INCH]
BRB 2, Standard	Kit 2 > Kit 1	12.75	0.500	50.0	1.968	12.75 - 25.5	0.500 - 1.004	16.75 - 41.5	0.659 - 1.634
BRB 2, NC	Kit 1 > Kit 2	19.05	0.750	50.0 / 16.0	1.969 / 0.630	19.1 - 47.0	0.752 - 1.850	23.0 - 62.0	0.906 - 2.441

ARTICLE	CODE	KG
Upgrade set BRB 2, Standard "Kit 2 to Kit 1"	<b>790 085 017</b>	0.800
Upgrade set BRB 2, NC "Kit 1 to Kit 2"	<b>790 185 018</b>	1.870



Balancer spring

## Balancer spring

For load-free hanging of BRB machines with a balancer. Ideal for series machining!  
Using a balancer enables optimal machining results from relaxed and fatigue-free work with longer work duration, and at the same time ensures more safety for the user (machine is safeguarded from falling).

ARTICLE	CODE	KG
Balancer spring	<b>832 030 002</b>	3.800

### PIPE BEVELING TECHNOLOGY

## Hoist bracket

**Designed for use with a hoist.** BRB machines which have been manufactured up to October 2009 can be retrofitted with this hoist bracket; all new models are already equipped with the hoist bracket).

ARTICLE	CODE	KG
Hoist bracket for BRB 4	790 086 310	0.270
Hoist bracket for BRB 2	790 085 310	0.185



Hoist bracket

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

**Optimized work, smoother and steadier cutting.** Including adjustable tool holder. The bevel cutter heads can be replaced like a tool mounting plate. They are available for several prep angles. The bevel cutter heads can be adapted to all machines (even older models).

### Scope of delivery:

- 2 Multifunctional tools (MFW-12-V/I-2, Code 790 086 060)
- 2 Tool bits (tool bit R4.5-I, Code 790 085 390)
- 2 Torx screws
- 6 Threaded pins
- 3 Fastening screws each, M5x16



Bevel cutter heads for BRB 2

ARTICLE	APPLICATION RANGE				CODE	KG
	KIT 1 (ID MIN. - OD MAX.)		KIT 2 (ID MIN. - OD MAX.)			
	[MM]	[INCH]	[MM]	[INCH]		
Bevel cutter head 30°	16 - 46	0.630 - 1.810	-	-	790 085 380	-
Bevel cutter head 37.5°	16 - 36	0.630 - 1.420	-	-	790 085 381	0.316
Bevel cutter head 45°	16 - 33	0.630 - 1.300	-	-	790 085 382	0.330
Bevel cutter head 30°	-	-	19 - 43	0.750 - 1.690	790 085 383	0.360
Bevel cutter head 37.5°	-	-	19 - 39	0.750 - 1.540	790 085 384	-
Bevel cutter head 45°	-	-	19 - 36	0.750 - 1.420	790 085 385	0.356

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

**The bevel cutter heads with 3 cutting edges provide considerable advantages for heavy chip removal, e.g. for welded material.** The bevel cutter heads can be replaced like a tool mounting plate. They are available for various prep angles and can be adapted to all machines (even older models).

### Scope of delivery:

- 3 Multifunctional tools (MFW-12-V/I-2, Code 790 086 060; MFW-P-2, Code 790 038 314 on request)
- 3 Torx screws
- 3 Fastening screws each, M6x16



Bevel cutter heads for BRB 4

ARTICLE	APPLICATION RANGE	WALL THICKNESS MAX.		CODE	KG
		[MM]	[INCH]		
Bevel cutter head 30°	ID 36 mm to OD 78 mm (1.417 - 3.071") in 3 steps of 5 mm (0.197") distance	10	0.394	790 086 500	0.465
Bevel cutter head 45°	ID 45 mm to OD 73 mm (1.772 - 2.874") in 2 steps of 5 mm (0.197") distance	10	0.394	790 086 459	0.515

### PIPE BEVELING TECHNOLOGY



Adjustable spacer



Mobile air unit DWE 10



Air hose with quick coupling



Cutting lubrication KSS-TOP



Elbow clamping system

## Adjustable spacer

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

ARTICLE	CODE	KG
Adjustable spacer for BRB 2	790 085 055	0.513

## Mobile air unit DWE 10

Lubricator and air filter adjustable pressure range 0-10 bar, flow max. 2.6 m<sup>3</sup>/min (91.8 cfm). Air inlet side: 1/2" clutch coupling (DIN 3481). Air outlet side: 1/2" quick coupling. Suitable for air hose 790 093 061.

ARTICLE	CODE	KG
Mobile air unit DWE 10	790 093 060	4.200

## Air hose with quick coupling

To connect the REB or BRB machine with the mobile air unit DWE 10. Length: 4 m (157.5"). ID: 19.1 mm (0.752"). Air inlet side: 1/2" quick coupling. Air outlet side: 90° angle screw with 1/2" quick coupling and a nipple to screw into the speed regulation handle on REB or BRB.

ARTICLE	CODE	KG
Air hose with quick coupling	790 093 061	2.000

## Cutting lubrication KSS-TOP

The water soluble, fully synthetic cooling fluid extends the tool life of the tool bits. Is well corrosion resistant. Developed conforming to drinking water requirements according to DVGW work sheet W521 (thread cutting compounds for drinking water installations) and basically complies with these specifications. Is biologically degradable (OECD 302 B).

ARTICLE	VERSION	CODE	KG
Cutting lubrication KSS-TOP	Spray pump with 500 ml	790 060 226	0.630
Cutting lubrication KSS-TOP refill canister	Canister with 10 l	790 060 227	11.000

## Elbow clamping system

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

### Scope of delivery:

- 1 Durable storage and shipping case
- 1 Mandrel with clamping mechanism for elbows
- 1 Straightening tool
- 8 Sets with 3 pins for dimension range 75 - 157 mm (2.953" - 6.181")

ARTICLE	CODE	KG
Elbow clamping system for REB 6 complete	790 093 015	9.900

## PIPE BEVELING TECHNOLOGY

## Optional clamping wedges

To extend the dimension of the REB standard machines.

ARTICLE	APPLICABLE WITH	TUBE ID [MM]	TUBE ID [INCH]	CODE		KG
Clamping sets	REB 6	155 - 166	6.102 - 6.535	<b>790 093 295</b>		1.300
Clamping sets	REB 14	320 - 339	12.598 - 13.346	<b>790 094 189</b>		3.600
Clamping sets	REB 14	331 - 350	13.031 - 13.780	<b>790 094 190</b>		3.850



Optional clamping wedges

## Plastic (POM) clamping shell segments

**Customized plastic (POM) clamping shell segments for REB 6 and REB 14 for thin-walled pipes. Deformation-free clamping system.** These clamping shell segments are especially manufactured for an individual ID of a pipe and can be utilized only for this diameter. Please specify the exact pipe ID with your order.

### Scope of delivery:

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



Plastic (POM) clamping shell segments

ARTICLE	APPLICABLE WITH	TUBE ID [MM]	TUBE ID [INCH]	CODE		KG
Plastic clamping shell segment	REB 6	108.2 - 110.1	4.260 - 4.335	<b>790 093 297</b>		1.600
Plastic clamping shell segment	REB 6	147.0 - 149.0	5.787 - 5.866	<b>790 093 298</b>		1.905
Plastic clamping shell segment	REB 14	160.0	6.299	<b>790 094 203</b>		3.700
Plastic clamping shell segment	REB 14	161.5 - 162.7	6.358 - 6.406	<b>790 094 202</b>		3.800
Plastic clamping shell segment	REB 14	211.6 - 213.5	8.331 - 8.401	<b>790 094 206</b>		5.600
Plastic clamping shell segment	REB 14	227.58	8.960	<b>790 094 198</b>		5.880
Plastic clamping shell segment	REB 14	250.0	9.843	<b>790 094 208</b>		5.600
Plastic clamping shell segment	REB 14	264.7 - 266.2	10.421 - 10.480	<b>790 094 210</b>		5.600
Plastic clamping shell segment	REB 14	314.7 - 315.9	12.390 - 12.437	<b>790 094 222</b>		4.100
Plastic clamping shell segment	REB 14	342.9	13.500	<b>790 094 226</b>		4.800
Plastic clamping shell segment	REB 14	347.7	13.689	<b>790 094 224</b>		4.750

## ID tracking for REB 14

**The REB ID tracking can be used to prepare thin-walled, large-scale pipes for welding, where precise pipe end preparation and an exact base height are required.** The module measures the pipe ID. The force of the spring on the inside diameter ensures that the roller "tracks" any irregularities of the pipe, producing a weld prep exactly in accordance with the ID. Thus maintaining a perfect weld prep. All weld preparations such as V-, Y- and U-preps can be realized with the ID tracking module.

### Scope of delivery:

- ID tracking module
- Mount for plane
- Assembly instructions

APPLICATION RANGE	[MM]	[INCH]
Tube ID	150 - 320	5.910 - 12.600
Wall thickness max.	15	0.591

ARTICLE	CODE	KG
ID tracking for REB 14	<b>790 094 013</b>	5.750



ID tracking for REB 14

## PIPE BEVELING TECHNOLOGY

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

CODE	TOOL HOLDER	TORX SCREWS	SUITABLE MULTIFUNCTIONAL TOOLS
<b>Tools for "I-prep"</b>			
790 085 234	WH 4-I	790 085 244	790 085 031 with R 0
790 085 230	WH 5-I	790 093 224	790 085 030 with R 0.4
790 086 210	WH 12-I-H 20 mm	790 086 220	790 086 060 with R 1.2
790 086 281	WH 12-I / short	790 086 220	790 086 060 with R 1.2
790 092 202	WH 15-I-H 20 mm	790 093 226	790 093 037 with R 0
790 092 204	WH 15-I-H 27 mm	790 093 226	790 093 037 with R 0
790 093 202	WH 30-I-H 20 mm	790 093 226	790 093 033 with R 0
790 093 204	WH 30-I-H 27 mm	790 093 226	790 093 033 with R 0
790 093 410	WH 15-I-H 16.5-23 mm (adjustable)	790 093 226 / 790 093 425	790 093 037 with R 0
<b>Tools for "V-prep" and "Y-prep"</b>			
790 085 236	WH 5-V-30°	790 093 224	790 085 030 with R 0.4
790 086 214	WH 12-V-30°	790 086 220	790 086 060 with R 1.2
790 086 282	WH 12-V-30° / short	790 086 220	790 086 060 with R 1.2
790 086 272	WH 12-V-35°	790 086 220	790 086 060 with R 1.2
790 086 216	WH 12-V-37.5°	790 086 220	790 086 060 with R 1.2
790 086 283	WH 12-V-37.5° / short	790 086 220	790 086 060 with R 1.2
790 086 474	WH 12-V-45°	790 086 022	790 086 060 with R 1.2
790 093 462	WH 12-V-80°	790 086 220	790 086 060 with R 1.2
790 092 210	WH 15-V-30°	790 093 226	790 093 037 with R 0 / 790 093 047
790 092 216	WH 15-V-37.5°	790 093 226	790 093 037 with R 0 / 790 093 047
790 092 218	WH 15-V-45°	790 093 226	790 093 037 with R 0 / 790 093 047
790 092 212	WH 15-V-60°	790 093 226	790 093 037 with R 0 / 790 093 047
790 093 468	WH 30-V-15°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 476	WH 30-V-U-25°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 210	WH 30-V-30°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 424	WH 30-V-32.5°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 216	WH 30-V-37.5°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 404	WH 30-V-45°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 470	WH 30-V-50°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 472	WH 30-V-55°	790 093 226	790 093 033 with R 0 / 790 093 043
<b>Tools for "U-prep"</b>			
790 085 228	WH 5-U-20°	790 093 224	790 085 030 with R 0.4
790 086 208	WH 12-U-10°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 213	WH 12-U-15°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 224	WH 12-U-20°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 476	WH 12-U-20° large clamping surface	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 212	WH 12-U-25°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 093 408	WH 30-U-7°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 220	WH 30-U-10°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 474	WH 30-U-14°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 468	WH 30-V-U-15°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 218	WH 30-U-20°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 478	WH 30-U-25°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
<b>Tools for "beveling / counterboring"</b>			
790 085 232	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 093 406	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 086 218	WH 5-ID-45°	790 093 224	790 086 061 with R 0.4
790 093 398	WH 10-ID-5° / short	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 400	WH 10-ID-5° / long	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 402	WH 10-ID-14°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 466	WH 10-ID-14° / 30 mm (1.181") deep	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 296	WH 10-ID-60°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 275	WH 10-ID-80°	790 086 220	790 086 062 with R 0.4
790 086 280	WH 12-ID-10° / from ID 50 (1.969")	790 086 217	790 086 060 with R 1.2
790 093 494	WH 10-ID-45°	790 086 220	790 093 040 with R 0.8
790 093 493	WH 10-ID-30°	790 086 220	790 093 040 with R 0.8

## Application range of tool holder for J-prep

		BRB 2 Mandrel Ø 12.7 WZT Ø 51		BRB 2 Mandrel Ø 19 WZT Ø 51		BRB 4 Mandrel Ø 19 WZT Ø 68		BRB 4 Mandrel Ø 32 WZT Ø 68		BRB 4 Mandrel Ø 32 WZT Ø 90		BRB 4 Mandrel Ø 32 WZT Ø 120		REB 6 Mandrel Ø 40 WZT Ø 183		REB 14 Mandrel Ø 63 WZT Ø 375	
Max. ID with a height of land 1 mm (0.039")																	
Code	Description	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]
790 085 228	WH 5-U-20°	34	15	38	21	-	-	-	-	-	-	104	34	159	49	320	65
790 093 220	WH 30-U-10°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 093 474	WH 30-U-14°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 093 468	WH 30-V/U-15°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 093 218	WH 30-U-20°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 093 478	WH 30-U-25°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 093 408	WH 30-U-7°	-	-	-	-	-	-	-	-	-	-	58	34	121	49	313	65
790 086 208	WH 12-U-10°	-	-	-	-	32	21	-	-	54	34	84	34	147	49	320	65
790 086 224	WH 12-U-20°	-	-	-	-	32	21	-	-	54	34	84	34	147	49	320	65
790 086 212	WH 12-U-25°	-	-	-	-	32	21	-	-	54	34	84	34	147	49	320	65

## Application range of tool holders for counterboring

Counterboring		BRB 2 Mandrel Ø 12.7 WZT Ø 51		BRB 2 Mandrel Ø 19 WZT Ø 51		BRB 4 Mandrel Ø 19 WZT Ø 68		BRB 4 Mandrel Ø 32 WZT Ø 68		BRB 4 Mandrel Ø 32 WZT Ø 90		BRB 4 Mandrel Ø 32 WZT Ø 120		REB 6 Mandrel Ø 40 WZT Ø 183		REB 14 Mandrel Ø 63 WZT Ø 375	
Workable pipe inner diameter (0.5 mm / 0.020" safe distance to mandrel)																	
Code	Description	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]
790 085 232	WH 5-ID-14°/ 10 mm deep	38	27	38	36	55	36	55	42	77	42	107	42	159	53	320	92
790 093 398	WH 10-ID-5° / short	-	-	-	-	-	-	-	-	72	59	105	61	159	71	320	95
790 093 400	WH 10-ID-5° / long	-	-	-	-	-	-	-	-	72	59	105	61	159	71	320	95
790 093 402	WH 10-ID-14°	-	-	-	-	-	-	-	-	72	59	105	61	159	71	320	95
790 093 406	WH 5-ID-14°	-	-	-	-	-	-	-	-	60	39	96	43	159	60	320	92
790 093 466	WH 10-ID-14° / 30 mm (1.181") deep	-	-	-	-	-	-	-	-	61	53	105	61	159	78	320	101
790 086 218	WH 5-ID-45°	24	20*	37	24	49	27	49	37	40	40	107	37	159	58	320	92
Application range of tool holders for facing																	
790 086 275	WH 10-ID-80°	41	37	41	43	58	43	58	56	80	56	110	56	159	64	320	92

\* With diameter 20 mm: max. length of bevel 4 - 5 mm (0.157" - 0.197").

### Abbreviations:

WH = Tool holder

WZT = Tool support / Tool retainer



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

Code	Description (C)	MFW 12-V/I-2- R1.2 790 086 060	MFW 30-U-4- R2 790 093 035	MFW 30-U-4- R5 790 093 034
		Length of land (X1)		
790 085 228	WH 5-U-20°	-	-	-
790 093 218	WH 30-U-20°	-	1.4 mm	0 mm
790 093 220	WH 30-U-10°	-	2.5 mm	0.5 mm
790 093 408	WH 30-U-7°	-	3.8 mm	1.1 mm
790 093 474	WH 30-U-14°	-	2.3 mm	0 mm
790 093 478	WH 30-U-25°	-	1.1 mm	0 mm
790 086 208	WH 12-U-10°	1.5 mm	-	-
790 086 212	WH 12-U-25°	1.5 mm	-	-
790 086 224	WH 12-U-20°	1.5 mm	-	-

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

Code	Description (C)	MFW 12-V/I-2- R1.2 790 086 060	MFW 30-U-4- R2 790 093 035	MFW 30-U-4- R5 790 093 034
		Length of land (X1)		
790 093 408	WH 30-U-7°	-	1 - 7 mm	0 - 2.5 mm
790 093 220	WH 30-U-10°	-	0 - 6 mm	0 - 3 mm
790 093 474	WH 30-U-14°	-	0 - 6.5 mm	0 - 1 mm
790 093 218	WH 30-U-20°	-	0 - 5 mm	0 - 3.5 mm
790 093 478	WH 30-U-25°	-	0 - 5 mm	0 - 1 mm
790 086 208	WH 12-U-10°	0 - 5 mm	-	-
790 086 224	WH 12-U-20°	0 - 5 mm	-	-
790 086 212	WH 12-U-25°	0 - 5 mm	-	-

**Abbreviations:**

WH = Tool holder

WZT = Tool support / Tool retainer

