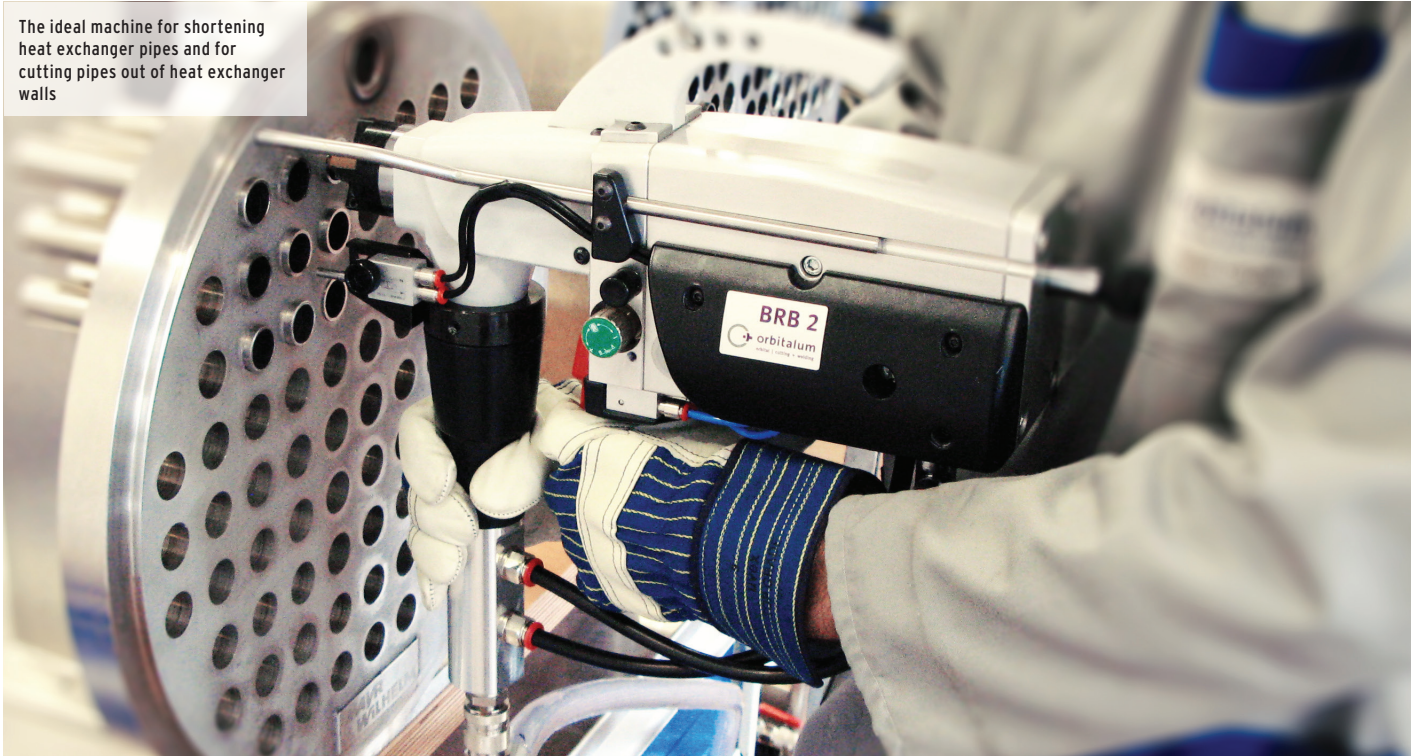


BRB 2 FullAuto

Boiler pipe preparation machine

The highest level of boiler pipe processing! The pneumatically-operated BRB 2 FullAuto pipe processing machine is particularly economical and ensures the highest levels of precision and quality when shortening and welding in of thousands of pipes on heat exchangers. The machine provides users the same precision and efficiency during maintenance and service - defective pipes can be easily cut out of the pipe sheet.

The ideal machine for shortening heat exchanger pipes and for cutting pipes out of heat exchanger walls



For standard-compliant, precise and reproducible weld seam preparations. The perfect addition to Orbitalum's WIG pipe-in-sheet weld heads!

The cutting system for exact squaring and beveling works with up to four, extremely low cost, cutting bits. Automatic hydro pneumatics are started when the touch control is activated: The BRB 2 FullAuto clamps and centers itself in the pipe using compressed air. The cutting process begins with hydraulic soft start. In addition, rapid traverse can be used for faster working.

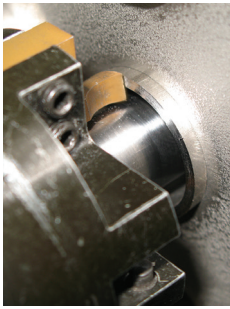
Unlike conventional machines with additional ballast such as an external control box and foot pedal, the BRB 2 FullAuto is much more convenient and cost-efficient, as all of the control elements are easier to operate because they are integrated in to the machine. Initially, the speed is ideally adapted to heat exchanger

use, but it can be conveniently varied using a control valve. The feed can also be controlled continuously with a voltage divider. The very robust, length-adjustable end switch also stops the shortening process exactly at the desired position.

Further special features are the balance setting, which is integrated into the handle for easy operation between the processing cycles. Also a very clever solution for the compressed air outlet for quality and value, the exhaust air ring can be rotated, which allows the air flow to be kept away from the workpiece and operator. The advantage is that an oil film does not form on the workpiece. This unwanted effect is often the cause for errors (pores and cavities) forming in the weld metal, which can be difficult to avoid in the machines with rigid front air outlets which are commercially available.

The BRB 2 FullAuto is equipped with a high-quality, powerful compressed air motor. The machine and accessories are supplied in a durable storage and shipping case.

- Ideal for shortening heat exchanger pipes and for cutting pipes out of heat exchanger walls
- Starting of the working process, automatic feeding and automatic clamping by using one tip switch only
- Standard-compliant, precise and reproducible weld seam preparation
- Rapid processing, ideal for serial processing
- Handy, ergonomic and compact design, all control elements for operating the machine are integrated in it, no external control box or pedal required
- Continuous adjustment of the feed speed
- Integrated rapid feed sensing device



Exact squaring and beveling through the use of up to four extremely inexpensive tool bits (available optionally)



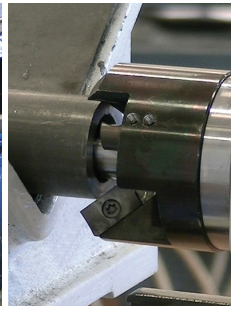
Handy, ergonomic and compact design



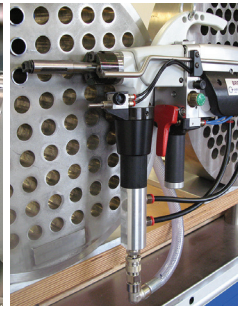
The "NC" clamping system cannot be lost thanks to its clamping wedges anchored in the mandrel



Automatic starting of the working process (pipe clamping and machining) with only one tip switch



Standard-compliant, precise and reproducible weld seam preparation



Integrated balancer device for safe, relaxed and fatigue-free working, also during longer working periods

APPLICATION RANGE		BRB 2 FULLAUTO
Code		790 185 052
Tube ID*	[mm]	19.1 - 47.0
	[inch]	0.75 - 1.85
Wall thickness	[mm]	1.2 - 3.0
	[inch]	0.047 - 0.118
Tube materials		Unalloyed and low-alloy steels, high-alloy steels (high-grade steel, material no. 1.40 - 1.45, in accordance with DIN 17 455 and DIN 17 456), aluminum. Others on request.
TECHNICAL DATA		BRB 2 FULLAUTO
Dimensions (lxwxh)	[mm]	515 x 105 x 400
	[inch]	20.3 x 4.1 x 15.7
Weight gross/net, approx.	[kg]	21.6 / 12.1
	[lbs]	47.6 / 26.7
Power (pneumatic power drive)	[kW]	0.38
	[hp]	0.51
Air consumption (at 6 bar)	[m³/min]	0.7
Speed max. idling speed	[min ⁻¹]	139
Noise level at the workplace (EN 23741)	[dB (A)]	approx. 83 (mid-range speed)
Vibration level (EN 60745)	[m/s ²]	> 2.5
SCOPE OF DELIVERY		BRB 2 FULLAUTO
Boiler pipe preparation machine	Pc.	1
Durable storage and shipping case	Pc.	1
Clamping sets	Pc.	9 (for dimensions, please see the table below)
Mandrel (Ø 19.05 mm/0.75")	Pc.	1
Tool holder for tool bits**	Pc.	1
Cutting lubrication KSS-TOP (Code 790 060 226)	Spray pump	1
Tool set	Set	1
Operating instructions and spare parts list	Set	1

* Smaller dimensions on request

** Tool bits must be ordered separately, see catalogue, page 67

FURTHER ADVANTAGES:

- Very robust length-adjustable end switch. Terminates the process of shortening exactly at the desired final size
- Integrated length stop for easier positioning of the machine in the pipe, protects the cutting edges
- Compressed-air motor with speed regulation and low-maintenance gearing with grease lubrication
- Optimized speed range, ideal for heat exchanger applications
- The exhaust air ring can be rotated, which allows the air flow to be kept away from the workpiece and user
- Integrated balancer device for safe, relaxed and fatigue-free working, also during longer working periods
- The perfect addition to Orbitalum's WIG pipe-in-sheet weld heads

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

A tool retainer for working with the conventional tool combination (WH/MFW) continues to be available optionally.

CLAMPING SETS FOR PIPE ID			CLAMPING RANGE		MANDREL Ø	
[MM]	[INCH]	CODE	[MM]	[INCH]	[MM]	[INCH]
19.1 - 23.0	0.75 - 0.91	790 086 390	19.1 - 47.0	0.75 - 1.85	19.05	0.750
22.0 - 26.0	0.87 - 1.02	790 086 391				
25.0 - 29.0	0.98 - 1.14	790 086 392				
28.0 - 32.0	1.10 - 1.26	790 086 393				
31.0 - 35.0	1.22 - 1.38	790 086 394				
34.0 - 38.0	1.34 - 1.50	790 086 395				
37.0 - 41.0	1.46 - 1.61	790 086 396				
40.0 - 44.0	1.57 - 1.73	790 086 397				
43.0 - 47.0	1.69 - 1.85	790 086 398				

The technical data are not binding. They are not warranted characteristics and are subject to change. Please consult our general conditions of supply.

