**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 beveling
- Min plate thickness 1.5mm
- Pipe OD beveling
- Pipe ID beveling

**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 beveler including milling head 45° w/o inserts
- Plastic box
- Special wrench
- Torx T15 screwdriver
- Screw grease (5g)
- Operator’s manual

**Spares & Consumables**

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

**Accessories**

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

**BM16**

**PORTABLE BEVELLING MACHINE**

- Maximum 16mm bevel width
- Mill edges of plates and pipes made of steel, aluminum 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
- Beveling radius milling head enables beveling 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 beveling 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**

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

**Accessories**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-BM16/1010</td>
<td>Milling Head For Rounding</td>
</tr>
<tr>
<td>WAP-BM16/1030</td>
<td>Milling Head 37.5°</td>
</tr>
<tr>
<td>WAP-BM16/1015</td>
<td>Milling Head 45°</td>
</tr>
<tr>
<td>WAP-BM16/1017</td>
<td>Milling Head 50°</td>
</tr>
<tr>
<td>WAP-BM16/1025</td>
<td>Milling Head 55°</td>
</tr>
<tr>
<td>WAP-BM16/1020</td>
<td>Milling Head 60°</td>
</tr>
<tr>
<td>WAP-BM16/1022</td>
<td>Milling Head 65°</td>
</tr>
<tr>
<td>WAP-BM16/1070</td>
<td>Cutting Insert For Steel To Suit Above Angle (Not Radius) Milling Heads Only (5 Pcs Required)</td>
</tr>
<tr>
<td>WAP-BM16/1065</td>
<td>Cutting Insert For Aluminum To Suit Above Angle (Not Radius) Milling Heads Only (5 Pcs Required)</td>
</tr>
<tr>
<td>WAP-BM16/1130</td>
<td>Pipe Attachment</td>
</tr>
<tr>
<td>WAP-BM16/1135</td>
<td>Work Table</td>
</tr>
<tr>
<td>WAP-BM16/1140</td>
<td>Anti-Scratch Guide Sticker</td>
</tr>
</tbody>
</table>
**BM20 PLUS**

**PORTABLE BEVELLER**

- Maximum 21mm bevel width
- 15° to 60° beveling 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

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B020</td>
<td>Replacement Standard Cutting Tips (10 Required)</td>
</tr>
<tr>
<td>WAP-B20/4210</td>
<td>0° Edge Planing Attachment</td>
</tr>
<tr>
<td>WAP-B20/4010</td>
<td>Pipe Attachment To Suit 150-300mm Pipe</td>
</tr>
<tr>
<td>WAP-B20/4230</td>
<td>Round Plate Beveling Attachment</td>
</tr>
</tbody>
</table>

**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
- Bevels pipes 150 - 300mm diameter with optional attachment available for bevelling pipes 250 - 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

### Accessories & Consumables

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B020</td>
<td>Replacement Standard Cutting Tips (10 Required)</td>
</tr>
<tr>
<td>WAP-B020/4010</td>
<td>Large Pipe Attachment For 258 - 600mm Pipe</td>
</tr>
</tbody>
</table>

**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 49 Kg / mm² or 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 & bevels 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
- SCD-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-000001 Tube Beveling Shaft
- PDK-000240 Tube Beveling Washer
- WAP-B14/TROLLEY Adjustable Trolley

### Package Includes :

- WA-ABM14 beveler
- Cutting wheel for mild steel
- Cutter Extraction tool
- Tube beveling shaft & washer
- Flat wrenches: 12-13mm 18-19mm 24-25mm
- Hex wrenches: 5mm 6mm
- Operator’s manual

### Schematic Diagrams of Bevels for Plates and Pipes

#### SINGLE RUN BEVELLING - MILD STEEL

<table>
<thead>
<tr>
<th>Rm (≤ 392 MPa)</th>
<th>392-490 MPa (57,000 - 71,000 psi)</th>
<th>490-588 MPa (71,000 - 85,000 psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>β</td>
<td>b [mm]</td>
<td>a [mm]</td>
</tr>
<tr>
<td>22.5°</td>
<td>12</td>
<td>11</td>
</tr>
<tr>
<td>30</td>
<td>12</td>
<td>10</td>
</tr>
<tr>
<td>35</td>
<td>12</td>
<td>9.5</td>
</tr>
<tr>
<td>37.5</td>
<td>12</td>
<td>9</td>
</tr>
<tr>
<td>45</td>
<td>12</td>
<td>8.5</td>
</tr>
</tbody>
</table>

#### SINGLE RUN BEVELLING - STAINLESS / ALLOY STEEL

<table>
<thead>
<tr>
<th>Rm (&lt; 400 MPa (71,000 psi))</th>
<th>490-588 MPa (71,000 - 85,000 psi)</th>
<th>588-686 MPa (85,000 - 100,000 psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>β</td>
<td>b [mm]</td>
<td>a [mm]</td>
</tr>
<tr>
<td>22.5°</td>
<td>6</td>
<td>5.5</td>
</tr>
<tr>
<td>30</td>
<td>6</td>
<td>5</td>
</tr>
<tr>
<td>35</td>
<td>6</td>
<td>5</td>
</tr>
<tr>
<td>37.5</td>
<td>6</td>
<td>4.5</td>
</tr>
<tr>
<td>45</td>
<td>6</td>
<td>4</td>
</tr>
</tbody>
</table>

**Part No.** | **Description** |
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>WA-ABM14</td>
<td>Voltage 3~ 400 V + PE, 50/60 Hz</td>
</tr>
<tr>
<td></td>
<td>Power 2200 W</td>
</tr>
<tr>
<td></td>
<td>Speed 9 rpm</td>
</tr>
<tr>
<td></td>
<td>Maximum bevel width (b) 14mm</td>
</tr>
<tr>
<td></td>
<td>Maximum bevel width (b) in a single run 12mm</td>
</tr>
<tr>
<td></td>
<td>Minimum plate thickness 6mm</td>
</tr>
<tr>
<td></td>
<td>Maximum plate thickness 40 mm</td>
</tr>
<tr>
<td></td>
<td>Minimum plate width 55 mm</td>
</tr>
<tr>
<td></td>
<td>Bevel length per minute 2.6 m</td>
</tr>
<tr>
<td></td>
<td>Minimum pipe ID 100 mm</td>
</tr>
<tr>
<td></td>
<td>Weight 65 kg</td>
</tr>
</tbody>
</table>
**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.
- Bevelling 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.

**Package Includes**
- Bevelling Machine
- 1200mm Track Segment x 2
- Positioner Unit, 35mm
- 35mm Track Clamp x 3
- Standard Milling Unit Support

**Maximum Bevel Width**

<table>
<thead>
<tr>
<th>A</th>
<th>0°</th>
<th>30°</th>
<th>45°</th>
<th>60°</th>
</tr>
</thead>
<tbody>
<tr>
<td>B</td>
<td>35mm</td>
<td>30mm</td>
<td>28mm</td>
<td>30mm</td>
</tr>
</tbody>
</table>

**Accessories & Consumables**

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

---

**ABM 50**  
**AUTO-FEED PLATE & PIPE BEVELLER**

- Bevel width up to 50mm at 45 degrees
- Auto-feed portable beveler
- 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 bevelling) 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

**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**

<table>
<thead>
<tr>
<th>a</th>
<th>15°</th>
<th>30°</th>
<th>45°</th>
<th>60°</th>
</tr>
</thead>
<tbody>
<tr>
<td>b</td>
<td>66mm</td>
<td>52mm</td>
<td>50mm</td>
<td>51mm</td>
</tr>
</tbody>
</table>

**Part No.**  
**WA-ABM50**

<table>
<thead>
<tr>
<th>Voltage</th>
<th>3–400 V+ PE, 50/60 Hz</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power</td>
<td>6.5kw</td>
</tr>
<tr>
<td>Spindle speed (no load)</td>
<td>300 - 800rpm</td>
</tr>
<tr>
<td>Feed speed</td>
<td>0 - 1.2m/min</td>
</tr>
<tr>
<td>Maximum depth of cut per single pass</td>
<td>6mm</td>
</tr>
<tr>
<td>Plate thickness</td>
<td>8 - 80mm</td>
</tr>
<tr>
<td>Required ambient temperature</td>
<td>0 - 40°C</td>
</tr>
<tr>
<td>Dimensions</td>
<td>1179mm L x 853mm W x 1524mm H</td>
</tr>
<tr>
<td>Weight</td>
<td>320kg</td>
</tr>
</tbody>
</table>
**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**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B02/130</td>
<td>Extension Set - Extension Set For Pipes From ID 42mm (1.65&quot;) Up To OD 60mm (2.37&quot;)</td>
</tr>
<tr>
<td>WAP-B02/150</td>
<td>Small Mandrel Set - Suit Pipes From ID 15.5mm (0.6&quot;) Up To OD 30mm (1.18&quot;)</td>
</tr>
</tbody>
</table>

**Specifications with electric motor**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B02/100</td>
<td>Pneumatic Motor suit PRO 2 PB</td>
</tr>
<tr>
<td>WAP-B02/110</td>
<td>Adapter And Driver For Pneumatic Motor</td>
</tr>
<tr>
<td>WAP-B02/105</td>
<td>Electric Motor suit PRO 2 PB</td>
</tr>
<tr>
<td>WAP-B02/112</td>
<td>Driver For Electric Motor</td>
</tr>
<tr>
<td>WAP-B02/108</td>
<td>Battery Powered Motor For Use With PRO 2 PB</td>
</tr>
<tr>
<td>WAP-B02/114</td>
<td>Driver For Battery Powered Motor</td>
</tr>
<tr>
<td>WAP-B02/150</td>
<td>Small Mandrel Set - Suit Pipes From ID 15.5mm (0.6&quot;) Up To OD 30mm (1.18&quot;)</td>
</tr>
<tr>
<td>WAP-B02/130</td>
<td>Extension Set - Extension Set For Pipes From ID 42mm (1.65&quot;) Up To OD 60mm (2.37&quot;)</td>
</tr>
</tbody>
</table>

**Consumables**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Use With Pipe O.D.</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B05/B30</td>
<td>External Bevelling HSS Cutting Tip 30°</td>
<td>32 - 56mm</td>
</tr>
<tr>
<td>WAP-B05/B30D</td>
<td>External Bevelling HSS Cutting Tip 30° Deep</td>
<td>56 - 83mm</td>
</tr>
<tr>
<td>WAP-B05/B37</td>
<td>External Bevelling HSS Cutting Tip 37.5°</td>
<td>83 - 114mm</td>
</tr>
<tr>
<td>WAP-B05/B45</td>
<td>External Bevelling HSS Cutting Tip 45°</td>
<td>114 - 140mm</td>
</tr>
<tr>
<td>WAP-B05/B30D</td>
<td>External Bevelling HSS Cutting Tip 30° Deep</td>
<td>56 - 83mm</td>
</tr>
<tr>
<td>WAP-B05/B45D</td>
<td>External Bevelling HSS Cutting Tip 45° Deep</td>
<td>83 - 114mm</td>
</tr>
<tr>
<td>WAP-B05/I540</td>
<td>Internal Bevelling HSS Cutting Tip 15° For Diameters Under 56mm</td>
<td>32 - 56mm</td>
</tr>
<tr>
<td>WAP-B05/I540/56</td>
<td>Internal Bevelling HSS Cutting Tip 15° For Diameters Over 56mm</td>
<td>56 - 83mm</td>
</tr>
</tbody>
</table>

**CUTTING INSERTS - HIGH SPEED STEEL**

- Facing HSS Cutting Tip 0° Width 40mm
- Bevelling HSS Cutting Tip 30° Width 50mm
- Bevelling HSS Cutting Tip 37° Width 53mm
- Bevelling HSS Cutting Tip 45° Width 56mm

**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

**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

**Specifications with electric motor**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B05/100</td>
<td>Pneumatic Motor 800W</td>
</tr>
<tr>
<td>WAP-B05/110</td>
<td>Electric Motor 1100W</td>
</tr>
</tbody>
</table>

**Rotational Speed**

- 90rpm gear 1: 0 to 90rpm
- 300rpm gear 2: 0 to 300rpm

**Air Consumption**

- 1800 l/min (49.4CFM) |

**Weight (incl. PRO5PB)**

- 10kg |
- 11kg

**Overall Length**

- 533mm |
- 577mm

**Consumables**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B05/B30</td>
<td>J-Groove Bevelling HSS Cutting Tip 20° R8</td>
</tr>
<tr>
<td>WAP-B05/B10R6</td>
<td>J-Groove Bevelling HSS Cutting Tip 20° R8</td>
</tr>
<tr>
<td>WAP-B05/B20R8</td>
<td>J-Groove Bevelling HSS Cutting Tip 30° R8</td>
</tr>
<tr>
<td>WAP-B05/B30D</td>
<td>External Bevelling HSS Cutting Tip 30° Deep</td>
</tr>
<tr>
<td>WAP-B05/BD37</td>
<td>External Bevelling HSS Cutting Tip 37.5° R7</td>
</tr>
<tr>
<td>WAP-B05/B45D</td>
<td>External Bevelling HSS Cutting Tip 45° R7</td>
</tr>
<tr>
<td>WAP-B05/I540</td>
<td>Internal Bevelling HSS Cutting Tip 15° For Diameters Under 56mm</td>
</tr>
<tr>
<td>WAP-B05/I540/56</td>
<td>Internal Bevelling HSS Cutting Tip 15° For Diameters Over 56mm</td>
</tr>
</tbody>
</table>

**Cutting Tips**

- 0° Facing HSS Cutting Tip 0° Width 8mm
- 30° Bevelling HSS Cutting Tip 30° Width 8mm
- 45° Bevelling HSS Cutting Tip 45° Width 8mm

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

- 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

**MACHINE WORKING RANGE**

**PIPE BEVELLING & FACING RANGE - STANDARD**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>WA-PR01PBA</th>
<th>WA-PR01PBE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor</td>
<td>Pneumatic Motor 1.5kw</td>
<td>Electric Motor 1.8kw</td>
</tr>
<tr>
<td>Power Requirements</td>
<td>1750 U/min at 630 kPa</td>
<td>230V/50Hz</td>
</tr>
<tr>
<td>Spindle Speed</td>
<td>20rpm</td>
<td>2 Speed Gearbox With Electronic Variable Speed 12 - 28, 41 - 96rpm</td>
</tr>
<tr>
<td>Overall Length</td>
<td>540mm</td>
<td>580mm</td>
</tr>
<tr>
<td>Weight (with standard mandrel)</td>
<td>32.0kg</td>
<td>36.0kg</td>
</tr>
</tbody>
</table>

**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. WAP-PB10/550) - PIPE I.D. 219 - 392mm Turning Range 90 - 508mm

**Package Includes**

- PRO 10 PB Bevelling 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

**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

**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

**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

**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**

**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
- 125 - 296mm I.D. with optional Large Expanding Mandrel Set (WAP-B10/540)

**FLANGE TURNING ATTACHMENT**

Part# WAP-PB10/529

Part# WAP-PB10/529INSERT (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**
--- | ---
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**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-B40/8010</td>
<td>Standard Milling Head</td>
</tr>
<tr>
<td>WAP-B8020</td>
<td>Replacement Standard Cutting Tips (7 Required)</td>
</tr>
<tr>
<td>WAP-B8040</td>
<td>Cutting Tips For Hard Steels (7 Required)</td>
</tr>
<tr>
<td>WAP-B40/8020</td>
<td>J-Groove R6 Milling Head</td>
</tr>
<tr>
<td>WAP-B40/8040</td>
<td>J-Groove R6 Cutting Tip (6 Required)</td>
</tr>
<tr>
<td>WAP-B40/8030</td>
<td>J-Groove R8 Milling Head</td>
</tr>
<tr>
<td>WAP-B40/8050</td>
<td>J-Groove R8 Cutting Tip (5 Required)</td>
</tr>
<tr>
<td>WAP-B40/8090</td>
<td>Oval Attachment</td>
</tr>
</tbody>
</table>

---

**Operations With Optional Heads**

- J-groove Bevelling
- Internal Bevelling
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

Standard Part No. WA-GECKO
High Speed Part No. WA-GECKO HS
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)

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)

WA-GECKO Standard Package Includes
- Welding carriage
- Power lead
- Arc ignition cable
- Torch holder
- 4mm Allen key
- Operator’s manual

Accessories

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>UCW-055S-08-00-00-0</td>
<td>Cable Anchor Suit Spider</td>
</tr>
<tr>
<td>LDW-000005</td>
<td>Battery Charger Suit Spider</td>
</tr>
<tr>
<td>ZSL-0525-20-00-00-0</td>
<td>Power Supply Suit Spider</td>
</tr>
<tr>
<td>PWD-0466-18-00-00-0</td>
<td>Power Cord 3 Metre For Power Supply Suit Spider</td>
</tr>
</tbody>
</table>

Part No. Description

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WA-GECKO</td>
<td>Power Supply 115-230VAC / 50-60Hz</td>
</tr>
<tr>
<td>WA-GECKO HS</td>
<td>Power Supply 115-230VAC / 50-60Hz</td>
</tr>
<tr>
<td>WA-GECKO-18V</td>
<td>18V DC 5.2 Ah Battery</td>
</tr>
</tbody>
</table>

Torch placement on either left or right side
Welding edge to edge
Welding in narrow spaces

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

Standard Part No. WA-GECKO
High Speed Part No. WA-GECKO HS
Battery Model Part No. WA-GECKO-18V

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

Part No. Description

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>UCW-055S-08-00-00-0</td>
<td>Cable Anchor Suit Spider</td>
</tr>
<tr>
<td>LDW-000005</td>
<td>Battery Charger Suit Spider</td>
</tr>
<tr>
<td>ZSL-0525-20-00-00-0</td>
<td>Power Supply Suit Spider</td>
</tr>
<tr>
<td>PWD-0466-18-00-00-0</td>
<td>Power Cord 3 Metre For Power Supply Suit Spider</td>
</tr>
</tbody>
</table>

Part No. Description

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>UCW-055S-08-00-00-0</td>
<td>Cable Anchor Suit Spider</td>
</tr>
<tr>
<td>LDW-000005</td>
<td>Battery Charger Suit Spider</td>
</tr>
<tr>
<td>ZSL-0525-20-00-00-0</td>
<td>Power Supply Suit Spider</td>
</tr>
<tr>
<td>PWD-0466-18-00-00-0</td>
<td>Power Cord 3 Metre For Power Supply Suit Spider</td>
</tr>
</tbody>
</table>
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

Package Includes
• Welding carriage
• Power lead
• Arc ignition cable
• Cable holder
• Torch holder
• Lower torch holder
• 4 mm Allen key
• Operator’s manual

Part No. Description
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
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

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 No. Description
WAP-L4000 Dual Torch Mount - Enables Mounting Of A Second Torch For Dual Sided Fillet Welding.
WAP-G2010 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

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
- Digital LED display for presetting of travel speed
- 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

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 / 3G
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

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

* All Tracks Sold Separately - See pg 12
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
  - 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

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 2000mm rails to form various lengths
- Rigid and heat-proof design

*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# WAP-D6150)
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

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-D6020</td>
<td>Basic Torch Holder</td>
</tr>
<tr>
<td>WAP-D6030</td>
<td>Torch Holder With Angle &amp; Height Adjustment</td>
</tr>
<tr>
<td>WAP-D6040</td>
<td>Machine Torch Holder</td>
</tr>
<tr>
<td>WAP-D6050</td>
<td>Machine Torch Holder With Angle Adjustment</td>
</tr>
<tr>
<td>WAP-D6010</td>
<td>Track Assembly</td>
</tr>
<tr>
<td>WAP-D6080</td>
<td>Sliding Torch Holder Mount</td>
</tr>
<tr>
<td>WAP-D6180</td>
<td>Cable Anchor</td>
</tr>
<tr>
<td>WAP-D6190</td>
<td>Carriage Support</td>
</tr>
<tr>
<td>WAP-D6160</td>
<td>Large Counterweight</td>
</tr>
<tr>
<td>WAP-D6150</td>
<td>Circle Cutting Attachment</td>
</tr>
<tr>
<td>WAP-D6170</td>
<td>Extended Torch Rack</td>
</tr>
</tbody>
</table>

Part No. | Description
---|---
WA-RAILBULL2 | Voltage 1-230 V, 50-60 Hz - 1-115 V, 50-60 Hz
Power | 120W
Welding position (according to EN ISO 6947 and AWS/ASME) | PA / 1F / 1G
| PB / 2F
| PC / 3G
| PD / 4F
| PE / 4G
| PF / 3G
| PG / 3G
(in certain applications only)
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

*Track sold separately

Part No. | Description
---|---
WA-RAILBULL2 | 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# WAP-D6150)
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

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-D6020</td>
<td>Basic Torch Holder</td>
</tr>
<tr>
<td>WAP-D6030</td>
<td>Torch Holder With Angle &amp; Height Adjustment</td>
</tr>
<tr>
<td>WAP-D6040</td>
<td>Machine Torch Holder</td>
</tr>
<tr>
<td>WAP-D6050</td>
<td>Machine Torch Holder With Angle Adjustment</td>
</tr>
<tr>
<td>WAP-D6010</td>
<td>Track Assembly</td>
</tr>
<tr>
<td>WAP-D6080</td>
<td>Sliding Torch Holder Mount</td>
</tr>
<tr>
<td>WAP-D6180</td>
<td>Cable Anchor</td>
</tr>
<tr>
<td>WAP-D6190</td>
<td>Carriage Support</td>
</tr>
<tr>
<td>WAP-D6160</td>
<td>Large Counterweight</td>
</tr>
<tr>
<td>WAP-D6150</td>
<td>Circle Cutting Attachment</td>
</tr>
<tr>
<td>WAP-D6170</td>
<td>Extended Torch Rack</td>
</tr>
</tbody>
</table>

Part No. | Description
---|---
WA-RAILBULL2 | Voltage 1-230 V, 50-60 Hz - 1-115 V, 50-60 Hz
Power | 120W
Welding position (according to EN ISO 6947 and AWS/ASME) | PA / 1F / 1G
| PB / 2F
| PC / 3G
| PD / 4F
| PE / 4G
| PF / 3G
| PG / 3G
(in certain applications only)
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

*Track sold separately

Part No. | Description
---|---
WA-RAILBULL2 | Voltage 1-230 V, 50-60 Hz - 1-115 V, 50-60 Hz
Power | 120W
Welding position (according to EN ISO 6947 and AWS/ASME) | PA / 1F / 1G
| PB / 2F
| PC / 3G
| PD / 4F
| PE / 4G
| PF / 3G
| PG / 3G
(in certain applications only)
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

*Track sold separately
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

Promotech offers lightweight and portable track system for a variety of circumferential and straight line applications.

Custom Rolled Tracks

- Choose the appropriate track system and auxiliary accessories for your own application.

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 fail.

Vacuum Track Fitting System Specifications

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

Vacuum Pump Specifications

- Voltage: 115V 50/60Hz or 230V 50/60Hz
- Power: 0.4 kW
- Vacuum: min -0.8 bar
- Pump Capacity: 4 m³/h (141 ft³/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 3500mm OD (in 50mm increments).
- Can be equipped with various supports depending on the customer’s needs.

Custom Rolled Tracks

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

Rigid, Semi Flexible & Hi-Flex Tracks Specifications

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>TRD-0073-00-00-00-0</td>
<td>Hi Flex track length 1.52m</td>
</tr>
<tr>
<td>WAP-RB2020</td>
<td>Semi Flexible track length 2m</td>
</tr>
<tr>
<td>WAP-RB2005</td>
<td>Ring track length 2m</td>
</tr>
<tr>
<td>WAP-RB2026</td>
<td>Bracket for magnetic unit for semi-flexible track and Hi Flex track</td>
</tr>
<tr>
<td>WAP-RB2045</td>
<td>Vacuum Modular Unit For Rigid &amp; Semi Flexible Track</td>
</tr>
<tr>
<td>WAP-RB3010</td>
<td>Magnetic unit for Hi Flex track</td>
</tr>
<tr>
<td>WAP-RB3015</td>
<td>Magnetic track support for semi-flexible track</td>
</tr>
<tr>
<td>WAP-RB3020</td>
<td>Steel track support for semi-flexible track</td>
</tr>
<tr>
<td>WAP-RB3030</td>
<td>Magnetic pivoting unit</td>
</tr>
<tr>
<td>WAP-RB3040</td>
<td>Magnetic spacing-adjustable unit</td>
</tr>
<tr>
<td>WAP-RB3045</td>
<td>Bracket for magnetic unit for semi-flexible track and Hi Flex track</td>
</tr>
<tr>
<td>WAP-RB3050</td>
<td>Bracket for magnetic unit for rigid track</td>
</tr>
</tbody>
</table>

Vacuum Track Fitting System Specifications

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-RB3010, WAP-RB3200 &amp; WAP-000365</td>
<td>Entry Modular Vacuum Unit</td>
</tr>
<tr>
<td>WAP-RB3010</td>
<td>Middle Modular Vacuum Unit</td>
</tr>
<tr>
<td>WAP-RB3010, WAP-RB3210 &amp; WAP-RB-000365</td>
<td>End Modular Vacuum Unit</td>
</tr>
<tr>
<td>WAP-RB3020</td>
<td>Aluminum track support for rigid and semi-flexible track</td>
</tr>
<tr>
<td>ZSP-0523-19-00-00-0</td>
<td>Heat-resistant magnetic unit</td>
</tr>
<tr>
<td>WAP-RB3030</td>
<td>Magnetic track support for semi-flexible track</td>
</tr>
<tr>
<td>WAP-RB3040</td>
<td>Magnetic spacing-adjustable unit</td>
</tr>
<tr>
<td>WAP-RB3045</td>
<td>Bracket for magnetic unit for semi-flexible track and Hi Flex track</td>
</tr>
<tr>
<td>WAP-RB3050</td>
<td>Bracket for magnetic unit for rigid track</td>
</tr>
</tbody>
</table>

Ring Tracks Specifications

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAP-RB2210</td>
<td>Support with bolts</td>
</tr>
<tr>
<td>WAP-RB2208</td>
<td>Support with magnets</td>
</tr>
<tr>
<td>WSP-0523-14-12-00-0</td>
<td>Support with plastic feet</td>
</tr>
</tbody>
</table>