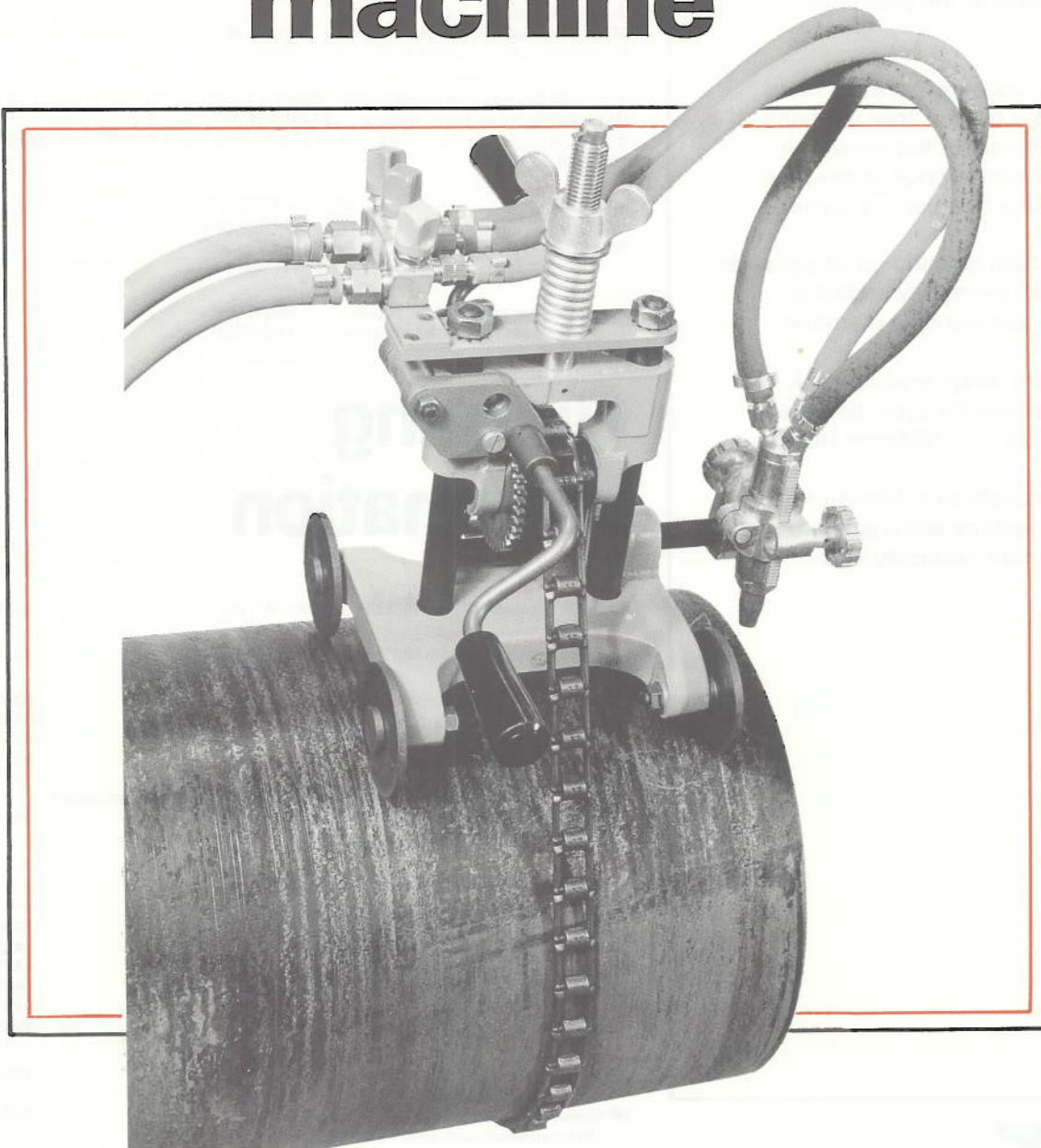


Portable pipe cutting and bevelling machine



- For precision cutting of pipes from 100mm (4") diameter up to 600mm (24").
- Track band version available for precision cutting of pipes up to a maximum diameter of 1200mm (48").
- Maximum of 100mm (4") pipe thickness at 0° and 50mm (2") at 45° bevel angle.
- Built for use under arduous site and factory conditions.
- Hand driven via a worm and pinion simply requires supplies of fuel gas and oxygen.

The portable pipe cutting machine is available in two versions, one for use direct on the pipe as illustrated overleaf, and a track band conversion for accurate edge preparation of the pipe sizes indicated.

Both machines incorporate a hand operated, chain driven, four wheeled carriage which carries the blowpipe around the circumference of the pipe when the driving handles are turned.

The drive chain is made up of separate links which can be readily added or subtracted to suit the pipe diameter.

Five standard wrap around track bands are available for pipe diameters from 600mm (24") to 1200mm (48").

A 100NM (nozzle mix) blowpipe is fitted to the machine with rack and pinion adjustment vertically and horizontally.

Specifications

Machine types

Standard machine for pipe diameters 100mm (4") to 600mm (24")
Track Band machine for pipe diameters 600mm (24") to 1200mm (48")

Drive chain

Pipe diameters in excess of 600mm (24") require additional drive chain links. 8 links are required for every 75mm (3") increase in diameter.

Pipe wall thickness

Maximum wall thickness at 0° bevel 100mm (4")
Maximum wall thickness at 45° bevel 50mm (2")

Blowpipe adjustments

Vertically by rack and pinion 80mm (3 1/4")
Horizontally by rack and pinion 117mm (4 5/8")
Blowpipe angle can be varied against a calibrated scale for bevelling between zero and 45°

Gas connections

Machine	3/8" BP	RH oxygen LH fuel gas
Blowpipe	1/4" BSP	RH oxygen LH fuel gas

Weight

Standard machine with blowpipe	9kg (20lb)
Track band version with blowpipe	11kg (25lb)

Ordering information

	Part Number
Standard machine for cutting pipes 100mm (4") to 600mm (24") dia	133611
Conversion Kit to Track band machine for cutting pipes 600mm (24") to 1200mm (48") dia	637176
Track bands	
600mm (24") diameter pipe	637661
750mm (30") diameter pipe	637662
900mm (36") diameter pipe	637663
1050mm (42") diameter pipe	637664
1200mm (48") diameter pipe	637665
(each band is supplied with appropriate number of extra chain links)	
Additional chain links (packet 20 links) (to adapt for larger diameter pipes)	889400
Nozzles	
Acetylene ANM 1/32" for 3-6mm (1/8-1/4") plate	143016
Acetylene ANM 3/64" for 5-12mm (1/4-1/2") plate	140317
Acetylene ANM 1/16" for 10-75mm (1/2-3") plate	143018
Acetylene ANM 5/64" for 70-100mm (3-4") plate	143019
Propane PNM 1/32" for 3-6mm (1/8-1/4") plate	143780
Propane PNM 3/64" for 5-12mm (1/4-1/2") plate	143781
Propane PNM 1/16" for 10-75mm (1/2-3") plate	143782
Propane PNM 5/64" for 70-100mm (3-4") plate	143783
Hoses	
HP 5mm (3/16") bore fuel gas hose fitted 3/8" BSP LH connection each end. 10m (33ft app.) long.	1262205
HP 5mm (3/16") bore oxygen hose fitted 3/8" BSP RH connection each end. 10m (33ft app.) long	1262255
Regulators	
Acetylene	A 1.5 Series 3
Propane	P 3.5 Series 1
Oxygen	0-3.5 Series 3
	1281211
	1281206
	1281209



ESAB AUTOMATION LIMITED

1-3 Crown Way
Walworth Industrial Estate
Andover
Hampshire SP10 5LU
England

Telephone: (01264) 332233
Fax: (01264) 332074

In pursuance of their policy of continuous improvement ESAB Automation Limited reserve the right to amend the specification without prior notice.