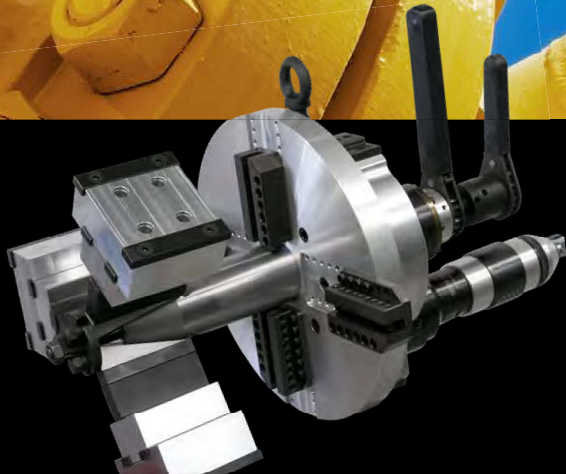
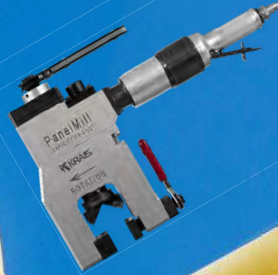
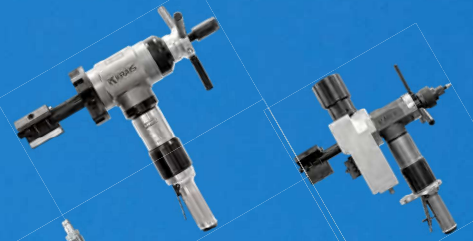
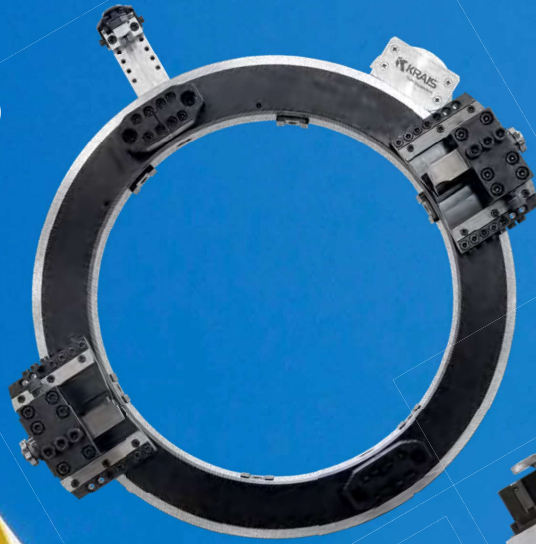




**MADE IN
POLAND**

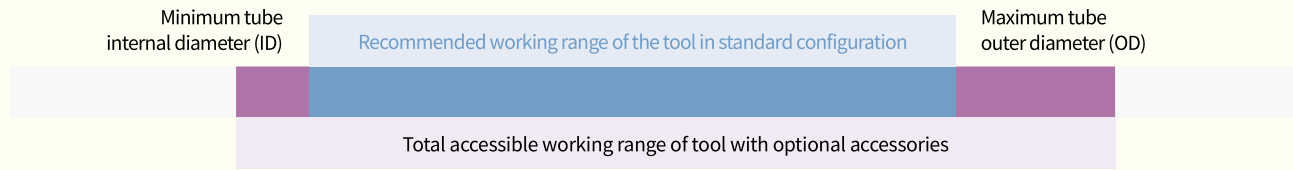


Tube & Pipe Professional Tools

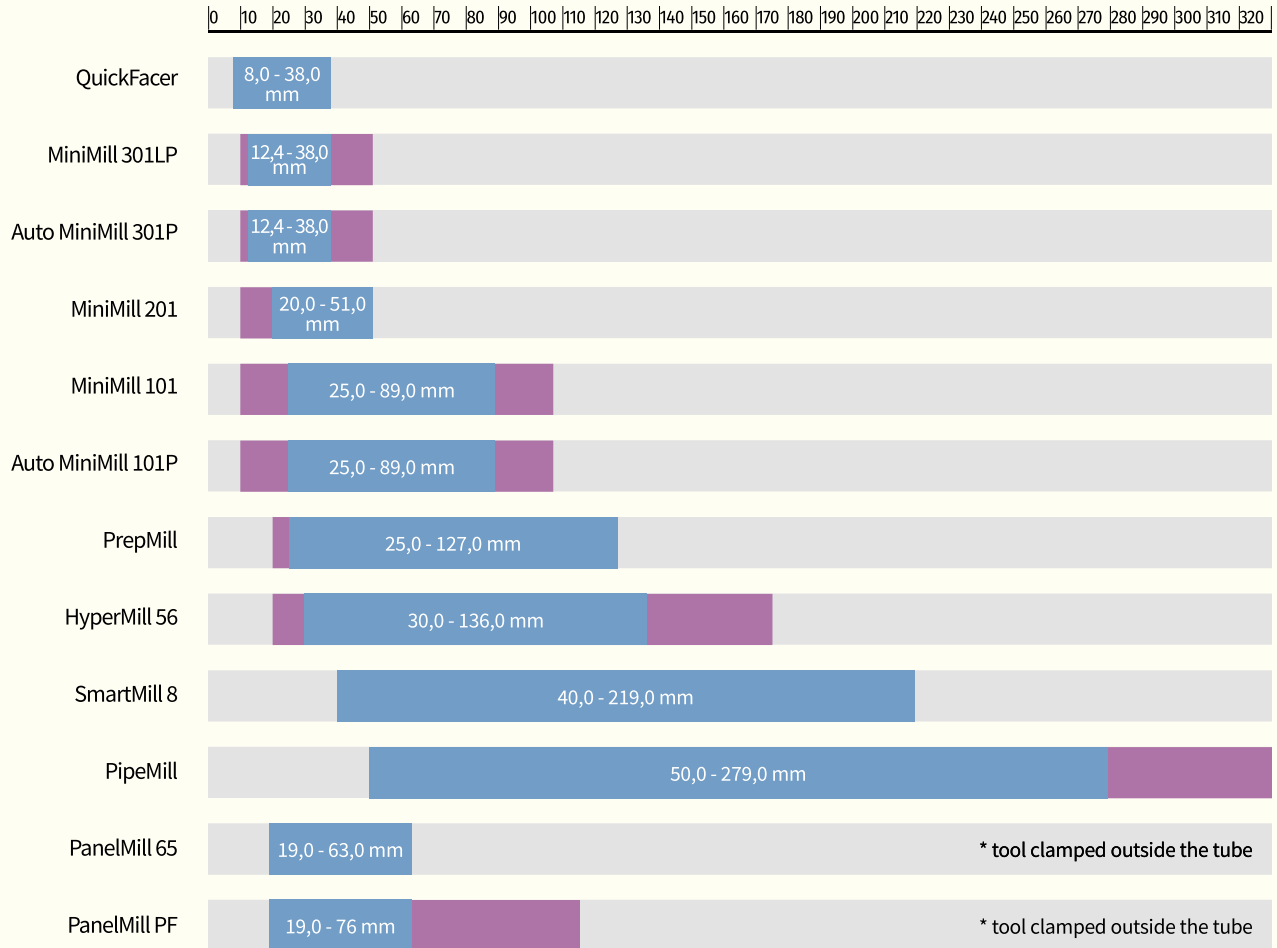


Working ranges for ID/OD mount bevelers

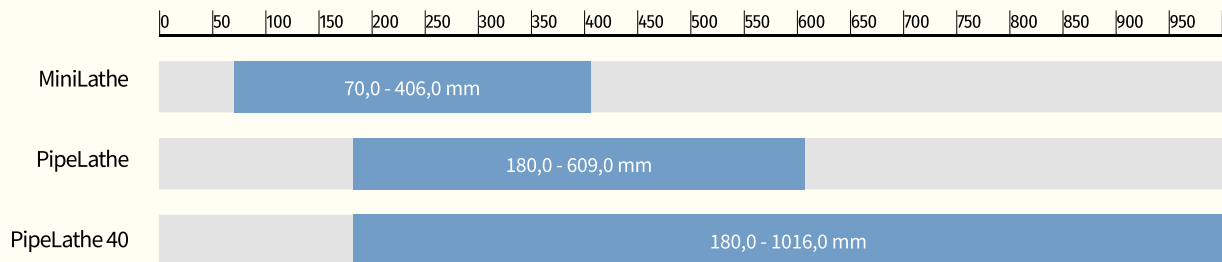
HOW TO READ IT



MILL SERIE WORKING RANGES (UNIVERSAL TOOLS)



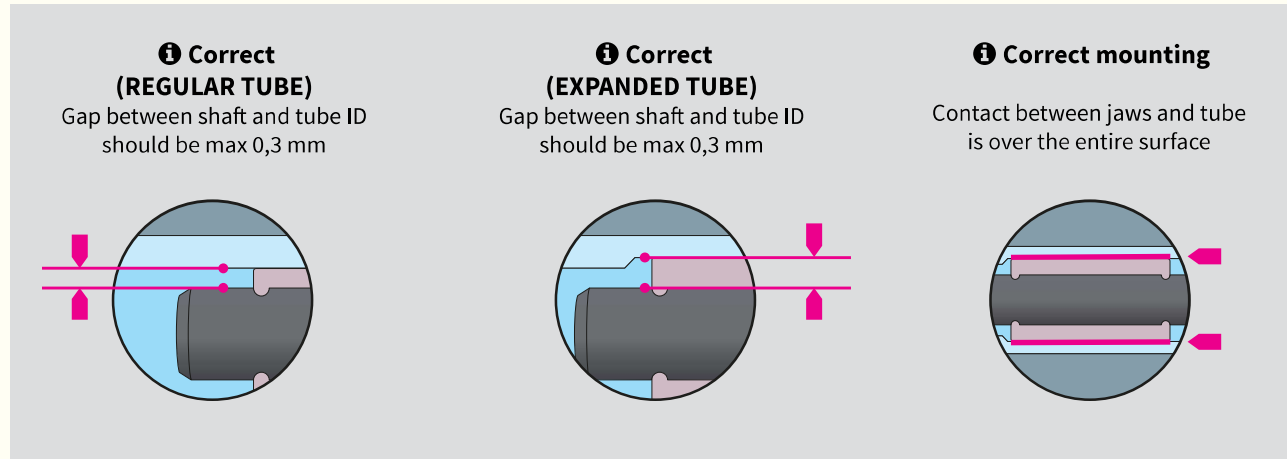
LATHE SERIE WORKING RANGES (UNIVERSAL TOOLS)



How to proper lock ID beveling machines

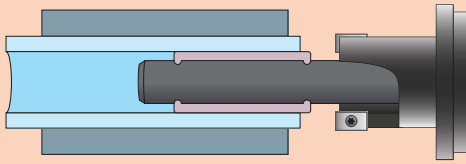
FOR: MINIMILL 101, MINIMILL 201, MINIMILL 301LP AND AUTO MINIMILL WITH MINISHAFT.

In order to obtain the best possible centring of the MiniMill into the faced, bevel or weld removal tube, we recommend to select the shaft with diameter closest possible to the inner diameter of tube.

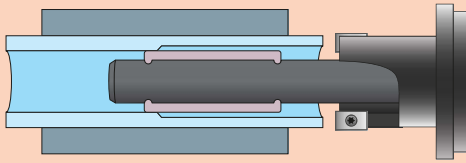


✘ WRONG JAWS SETUP

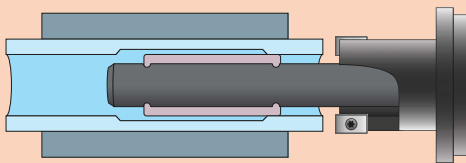
Facing before expanding



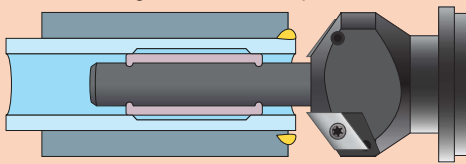
Facing after expanding



Facing after expansion with double radius rolls

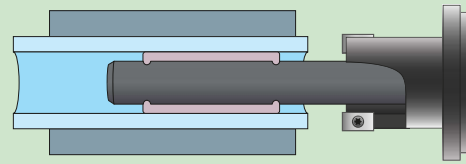


Strength weld removal application

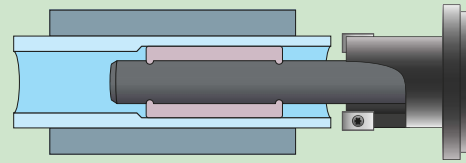


✔ CORRECT JAWS SETUP

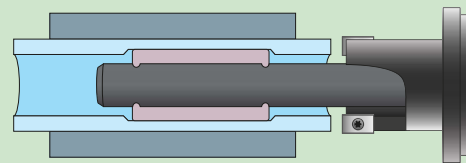
Facing before expanding



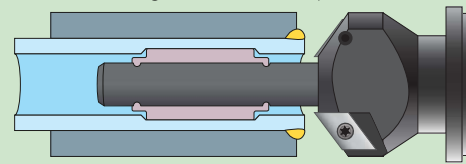
Facing after expanding



Facing after expansion with double radius rolls

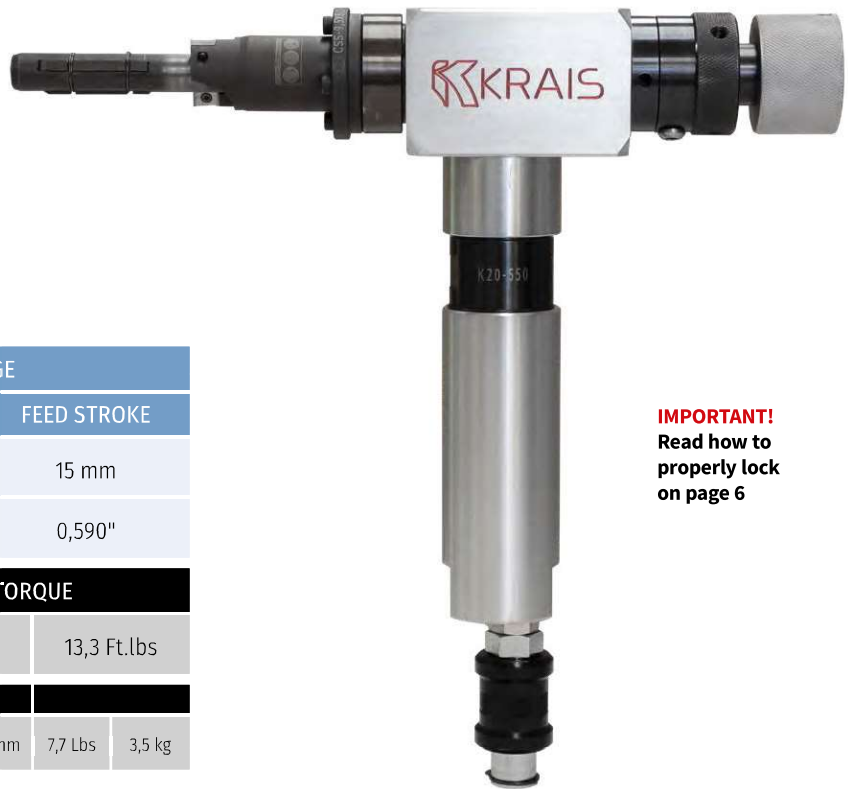


Strength weld removal application



QuickFacer

KRAIS QuickFacer is a rugged, fast, portable tube facing weld end preparation and weld removal tool. It is a micro lathe – designed for various tubes materials, including stainless steel and other high chromium materials. QuickFacer standard machine can be used for machining tube sizes from 8 mm ID to 38 mm OD (0.314” – 1.2”) and comes with a 50 mm cutting head.



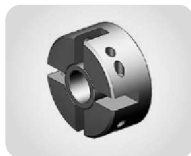
IMPORTANT!
Read how to properly lock on page 6

STANDARD WORKING RANGE					
APPLICATION (ID-OD)		LOCKING RANGE	FEED STROKE		
8 – 38 mm		7,8 – 36 mm	15 mm		
0,314 – 1,496”		0,307 – 1,417”	0,590”		
POWER		FREE SPEED	TORQUE		
0,98 hp		300 rpm	18 Nm	13,3 Ft.lbs	
17 cfm	0,48 m ³ /min	1,73 x 10,82 x 12,20”	44 x 275 x 310 mm	7,7 Lbs	3,5 kg

STANDARD SET UP



MICROSHAFT
A system with interchangeable guide shafts. A complete set covers 10,0 to 15,0 mm ID tubes.



50 MM (2”)
The smallest cutter head, designed to fasten the wide range of cutting inserts.

OPT. SHAFT



MINISHAFT
An optional system with interchangeable guide shafts. A complete set covers 12,4 to 48,0 mm ID tubes.

OPTIONAL HEADS



OBMH
Head for outside beveling tubes from 1/2” to 1-1/2” OD
→ TABLE PAGE 84



STWRMH
Head dedicated for strength weld removal. Heads are easy to align and sized per tube diameter, max size 1”
→ TABLE PAGE 83



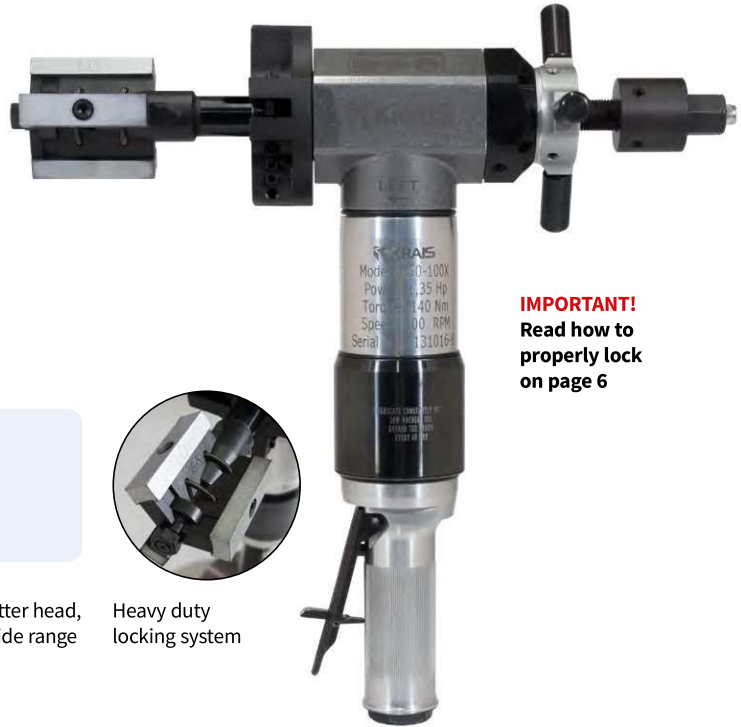
TFMH
Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.
→ TABLE PAGE 83

LOCKING RANGES FOR SHAFTS

SHAFT	SIZE		JAWS	EXPANSION SHAFT	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]			MIN	MAX	MIN	MAX	
878MM#151	0,307	7,80	378MM#36	MS-158-45	8,00	9,00	0,314	0,354	DW-7,5
885MM#151	0,334	8,50	385MM#36	MS-158-45	9,00	10,00	0,354	0,394	DW-7,7
800MM#151	0,354	9,00	301MM#36	MS-158-51	10,00	11,00	0,394	0,433	DW-7,5
801MM#151	0,394	10,00	303MM#36	MS-158	11,00	12,00	0,433	0,472	DW-8,5
805MM#151	0,453	11,50	305MM#36	MS-158	12,00	13,00	0,472	0,512	DW-10
			307MM#36	MS-158	13,00	14,00	0,512	0,551	
			309MM#36	MS-158	14,00	15,00	0,551	0,591	
901MM#152	0,492	12,40	201MM#36	MM#158-QF	12,40	14,50	0,488	0,571	DW-11
905MM#152	0,547	13,90	203 MM#36	MM#158-QF	13,90	16,00	0,547	0,630	DW-12,5
909MM#152	0,661	16,90	205 MM#36	MM#158-QF	15,90	18,00	0,626	0,709	DW-15,5
			207 MM#36	MM#158-QF	16,90	19,00	0,665	0,748	
			209 MM#36	MM#158-QF	18,90	21,00	0,744	0,827	
			211 MM#36	MM#158-QF	19,90	22,00	0,783	0,866	
			213 MM#36	MM#158-QF	20,90	23,00	0,823	0,906	
214 MM#36	MM#158-QF	21,90	24,00	0,862	0,944				
915MM#152	0,787	20,00	MADE ON ORDER						

MiniMill 101

The MiniMill 101 is a rugged, fast, portable weld end preparation lathe designed for various tubes and pipes, including stainless steel and other high chromium materials. Our standard machine can be used for pipe sizes of 20 - 74 mm i.d. (0.787" - 2.913") and comes with a 88 mm cutting head.



IMPORTANT!
Read how to properly lock on page 6

STANDARD SET UP



SHAFT25
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.



88 MM (3,46")
The popular, medium cutter head, designed to fasten the wide range of cutting inserts.



Heavy duty locking system

STANDARD WORKING RANGE				TOTAL WORKING RANGE			
APPLICATION RANGE		LOCKING RANGE		APPLICATION RANGE		LOCKING RANGE	
25 – 89 mm		25 – 77 mm		10 – 107 mm		10 – 102 mm	
0,984 – 3,504"		0,984 – 3,031"		0,394 – 4,213"		0,394 – 4,016"	
FEED STROKE		POWER		FREE SPEED		TORQUE	
20 mm	0,787"	1,3 hp		100 rpm		140 Nm	105 Ft.lbs
55 cfm	1,3 m ³ /min	2,32"	59 mm	13,1"	335 mm	11,4 Lbs	5,2 kg

MINIMILL 101E

MiniMill 101E is electric version of MiniMill 101. A standard machine cover the same pipe sizes and comes with the same cutting head. The electric motor made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time.

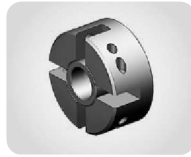
Free Speed 115 RPM
Power..... 750 W
Torque 366 NM (280 Ft.Lbs)
Feed Stroke 20 mm (0,787")



AUTOMINIMILL 101

Auto MiniMill 101P is a fully automatic machine, controlled by a built-in, fully pneumatic control box, with adjustable feed rate and actuated by a hand button (foot switch optional). Ideal for repetitive work cycles on condensers and heat exchangers, as well as for bevelling and facing boiler tubes.

OPTIONAL HEADS



60 MM (2,36")
The smallest cutter head, designed to fasten the wide range of cutting inserts.



106 MM (4,16")
The popular, large cutter head, designed to fasten the wide range of cutting inserts.



OBMH
Head for bevelling tubes without membranes in the boiler water walls.
→ TABLE PAGE 84



SWROTC
Seal weld removal head over tube circumference prior to re-welding the damaged joint without removing the tube.
→ TABLE PAGE 85



STWRMH
Head dedicated for strength weld removal. Heads are easy to align and sized per tube diameter.
→ TABLE PAGE 83



TFMH
Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.
→ TABLE PAGE 83

OPTIONAL SHAFTS



MICROSHAFT
A system with interchangeable guide shafts. A complete set covers 10,0 to 15,0 mm ID tubes.



MINISHAFT
A system with interchangeable guide shafts. A complete set covers 12,4 to 48,0 mm ID tubes.

OTHER OPTIONAL ACCESSORIES



RATCHET FEED
Feed system allowing to work in narrow and tight locations, eg. in water walls.



FAST CLAMPING SYSTEM
System offers rapid tube to tube cycle time, increased productivity (up to 4x) with little operator fatigue. Ideal for large amount of end preps.



SPEED REDUCER
Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.

STANDARD MINIMILL 101 LOCKING RANGES

WITH SHAFT25

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING		
			MIN	MAX	MIN	MAX	NO.	QTY.	
SHAFT25	NS-1	-	25	30	0,984	1,181	SP-24	1	
	NS-2	-	30	35	1,181	1,378	SP-24	1	
	NS-3	-	35	40	1,378	1,575	SP-25	2	
	NS-4	-	40	45	1,575	1,772	SP-25	2	
	NS-5	-	45	50	1,772	1,969	SP-25	2	
	NS-6	-	50	55	1,969	2,165	SP-25	2	
	NS-7	-	55	60	2,165	2,362	SP-25	2	
	NS-8	-	60	65	2,362	2,559	SP-25	2	
	NS-5	NS-10		62	67	2,441	2,638	SP-25	2
	NS-6	NS-10		67	72	2,638	2,835	SP-25	2
NS-7	NS-10		72	77	2,835	3,031	SP-25	2	

OPTIONAL MINIMILL 101 LOCKING RANGES

WITH SHAFT25

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT25	NS-8	NS-10	77	82	3,031	3,228	SP-25	2
	NS-5	NS-20	82	87	3,228	3,425	SP-25	2
	NS-6	NS-20	87	92	3,425	3,622	SP-25	2
	NS-7	NS-20	92	97	3,622	3,819	SP-25	2
	NS-8	NS-20	97	102	3,819	4,016	SP-25	2
	NS-5	NS-30	102	107	4,016	4,213	SP-25	2

WITH SHAFT20

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT20	NS-0	-	20	24	0,787	0,945	SP-19	1
	NS-1	-	24	28	0,945	1,102	SP-19	1

WITH MINISHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
901MM#151	0,492	12,40	201MM#36	12,40	14,50	0,488	0,571	DW-11
905MM#151	0,547	13,90	203 MM#36	13,90	16,00	0,547	0,630	DW-12,5
			205 MM#36	15,90	18,00	0,626	0,709	
909MM#151	0,661	16,90	207 MM#36	16,90	19,00	0,665	0,748	
			209 MM#36	18,90	21,00	0,744	0,827	DW-15,5
			211 MM#36	19,90	22,00	0,783	0,866	
			213 MM#36	20,90	23,00	0,823	0,906	
			214 MM#36	21,90	24,00	0,862	0,944	

WITH MICROSHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
800MM#151	0,354	9,00	301MM#36	10,00	11,00	0,394	0,433	DW-7,5
801MM#151	0,394	10,00	303MM#36	11,00	12,00	0,433	0,472	DW-8,5
			305MM#36	12,00	13,00	0,472	0,512	
805MM#151	0,453	11,50	307MM#36	13,00	14,00	0,512	0,551	DW-10
			309MM#36	14,00	15,00	0,551	0,591	

MiniMill 201

The MiniMill 201 is a rugged, fast, portable weld end preparation lathe for various tubes including stainless steel and other high chromium alloys. A standard machine comes complete with a 60 mm head, a locking system and includes all jaw sets to cover sizes of 20 to 44 mm (0.787" to 1.732")

STANDARD SET UP



SHAFT20

Redesigned heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force. The jaws are self-align.



60 MM (2,36")

The smallest cutter head, designed to fasten the wide range of cutting inserts.



IMPORTANT!
Read how to properly lock on page 6

STANDARD WORKING RANGE				TOTAL WORKING RANGE			
APPLICATION RANGE		LOCKING RANGE		APPLICATION RANGE		LOCKING RANGE	
20 – 51 mm		20 – 48 mm		10 – 51 mm		10 – 48 mm	
0,787 – 2,008"		0,787 – 1,890"		0,394 – 2,008"		0,394 – 1,890"	
FEED STROKE		POWER		FREE SPEED		TORQUE	
20 mm	0,787"	1,3 hp		200 rpm		72 Nm	53 Ft.lbs
55 cfm	1,3 m³/min	2,32"	59 mm	13,1"	335 mm	11,4 Lbs	5,2 kg

EXAMPLE TOOL APPLICATION



Standard locking system with handle feed makes quick work of trimming back tubes.



Completed strength weld removal.



Facing, bevelling tubes quickly and safely.

OPTIONAL HEADS



88 MM (3,46")
The popular, medium cutter head, designed to fasten the wide range of cutting inserts.



OBMH
Outside bevelling of both tubes and pipes. Sized per tube or pipe diameter and angle of required weld bevel.
→ TABLE PAGE 84



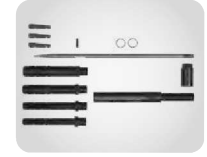
SWROTC
Seal weld removal head over tube circumference prior to re-welding the damaged joint without removing the tube.
TABLE PAGE 85



STWRMH
Custom designed head dedicated for strength weld removal. Heads are sized per tube diameter.
→ TABLE PAGE 83



MICROSHAFT
A system with interchangeable guide shafts. A complete set covers 9,0 to 15,0 mm inside diameter.



MINISHAFT
A system with interchangeable guide shafts. A complete set covers 12,4 to 48 mm inside diameter.

OTHER OPTIONAL ACCESSORIES



RATCHET FEED
Feed system allowing to work in narrow and tight locations, eg. in water walls.



LEVER FEED
Quick and easy feed system. Used in many basic applications.



SPEED REDUCER
Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.



FAST CLAMPING SYSTEM
System offers rapid tube to tube cycle time, increased productivity (up to 4x) with little operator fatigue. Ideal for large amount of end preps.

MINIMILL 201 LOCKING RANGES

WITH SHAFT20

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT25	NS-0	-	20	24	0,787	0,945	SP-19	1
	NS-1	-	24	28	0,945	1,102	SP-19	1
	NS-2	-	28	33	1,102	1,299	SP-19	1
	NS-3	-	33	38	1,299	1,496	SP-20	2
	NS-4	-	38	43	1,496	1,693	SP-20	2
	NS-5	-	43	48	1,693	1,890	SP-20	2

WITH MINISHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
901MM#151	0,492	12,40	201MM#36	12,40	14,50	0,488	0,571	DW-11
905MM#151	0,547	13,90	203 MM#36	13,90	16,00	0,547	0,630	DW-12,5
			205 MM#36	15,90	18,00	0,626	0,709	
			207 MM#36	16,90	19,00	0,665	0,748	
909MM#151	0,661	16,90	209 MM#36	18,90	21,00	0,744	0,827	DW-15,5
			211 MM#36	19,90	22,00	0,783	0,866	
			213 MM#36	20,90	23,00	0,823	0,906	
			214 MM#36	21,90	24,00	0,862	0,944	

WITH MICROSHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
800MM#151	0,354	9,00	301MM#36	10,00	11,00	0,394	0,433	DW-7,5
801MM#151	0,394	10,00	303MM#36	11,00	12,00	0,433	0,472	DW-8,5
			305MM#36	12,00	13,00	0,472	0,512	
805MM#151	0,453	11,50	307MM#36	13,00	14,00	0,512	0,551	DW-10
			309MM#36	14,00	15,00	0,551	0,591	

MiniMill 301LP

The fastest and strongest facing machine on the market. Engineered for safety and ease of use, featuring a pneumatic locking system with a double piston cylinder. Compact milling head with double cutting edge inserts with 6% cobalt. For all types of material including: ferrous, non-ferrous, stainless and exotic alloys steel, duplex, inconel and titanium.



IMPORTANT!
Read how to
properly lock
on page 6

STANDARD SET UP



MINISHAFT

A system with interchangeable guide shafts. A complete set covers 12,4 to 48,0 mm ID tubes.



60 MM (2,36")

The smallest cutter head, designed to fasten the wide range of cutting inserts.

STANDARD WORKING RANGE		TOTAL WORKING RANGE					
APPLICATION RANGE	LOCKING RANGE	APPLICATION RANGE	LOCKING RANGE				
12,4 – 38,0 mm	12,4 – 24,0 mm	10 – 51 mm	10 – 48 mm				
0,488 – 1,496"	0,488 – 0,945"	0,394 – 2,008"	0,394 – 1,890"				
FEED STROKE		POWER		FREE SPEED		TORQUE	
20 mm	0,787"	1,3 hp		300 rpm		43 Nm	32 Ft.lbs
55 cfm	1,3 m ³ /min	2,32"	59 mm	13,1"	335 mm	15,4 Lbs	7 kg



AUTOMINIMILL 301

Auto MiniMill 301 is a fully automatic machine, controlled by a built-in, fully pneumatic control box, with adjustable feed rate and actuated by a hand button (foot switch optional). Ideal for repetitive work cycles on condensers and heat exchangers, as well as for bevelling and facing boiler tubes.

EXAMPLE TOOL APPLICATION



A real application: shortening a bundle. MiniMill can deal with this task quickly and efficiently.



Double sided inserts and fixed diameter heads ensure unsurpassed efficiency and quality. Mechanical stops ensure identical tube projection.

OPTIONAL HEADS



TFMH
Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.
→ TABLE PAGE 83



STWRMH
Head for strength weld removal. Easy to align and sized per tube diameter. Must be used with 3X Speed Reducer.
→ TABLE PAGE 83

OPTIONAL SHAFTS



MICROSHAFT
A system with interchangeable guide shafts. A complete set covers 9,0 to 15,0 mm inside diameter.



SHAFT20
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.

OTHER OPTIONAL ACCESSORIES



SPEED REDUCER
Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.



STAR WHEEL
The most precise feed system. Used in many basic and demanding applications.

EXAMPLE TOOL APPLICATION



The fast locking and the handle feed make this system very efficient for heat exchanger manufacturers.

MINIMILL 301LP LOCKING RANGES

WITH MINISHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
901MM#151	12,40	0,492	201MM#36	12,40	14,50	0,488	0,571	DW-11
905MM#151	13,90	0,547	203 MM#36	13,90	16,00	0,547	0,630	DW-12,5
909MM#151	16,90	0,661	205 MM#36	15,90	18,00	0,626	0,709	DW-15,5
			207 MM#36	16,90	19,00	0,665	0,748	
			209 MM#36	18,90	21,00	0,744	0,827	
			211 MM#36	19,90	22,00	0,783	0,866	
			213 MM#36	20,90	23,00	0,823	0,906	
			214 MM#36	21,90	24,00	0,862	0,944	

WITH MICROSHAFT

SHAFT	SIZE		JAWS	RANGE [MM]		RANGE [INCH]		SPRING
	[INCH]	[MM]		MIN	MAX	MIN	MAX	
800MM#151	0,354	9,00	301MM#36	10,00	11,00	0,394	0,433	DW-7,5
801MM#151	0,394	10,00	303MM#36	11,00	12,00	0,433	0,472	DW-8,5
805MM#151	0,453	11,50	305MM#36	12,00	13,00	0,472	0,512	DW-10
			307MM#36	13,00	14,00	0,512	0,551	
			309MM#36	14,00	15,00	0,551	0,591	

WITH SHAFT20

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT20	NS-0	-	20	24	0,787	0,945	SP-19	1
	NS-1	-	24	28	0,945	1,102	SP-19	1
	NS-2	-	28	33	1,102	1,299	SP-19	1
	NS-3	-	33	38	1,299	1,496	SP-20	2
	NS-4	-	38	43	1,496	1,693	SP-20	2
	NS-5	-	43	48	1,693	1,890	SP-20	2

PrepMill

The PrepMill series pneumatic tube facing, bevelling and weld removal machine. The PrepMill is a rugged, fast, portable weld end preparation lathe for various tubes including stainless steel and other high chromium alloys. Machine is constructed on two opposite set up taper roller bearings that makes the machine extremely stable and very rigid and compact. A standard machine is equipped to cover 25 to 122 mm ID (1" to 4,8") with a 116 mm cutter head.



SIGNATURE BEVELER FOR BOILER-WORKS. BUILT TO LAST!

STANDARD SET UP



SHAFT25
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.



116 MM (4,56")
The large cutter head, designed to fasten the wide range of cutting inserts.



Heavy duty locking system

STANDARD WORKING RANGE				TOTAL WORKING RANGE			
APPLICATION RANGE		LOCKING RANGE		APPLICATION RANGE		LOCKING RANGE	
25 – 127 mm		25 – 122 mm		20 – 127 mm		20 – 122 mm	
1 – 5"		1,0 – 4,8"		0,787 – 5"		0,787 – 4,8"	
FEED STROKE		POWER		FREE SPEED		TORQUE	
25 mm	1"	1,3 hp		120 rpm		140 Nm	105 Ft.lbs
55 cfm	1,3 m ³ /min	2,59"	66 mm	14,5"	370 mm	20,5 Lbs	9,5 kg

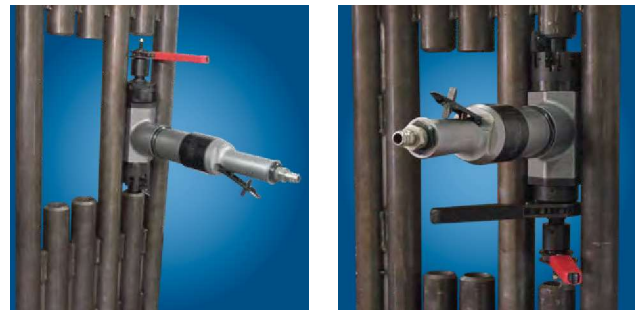
PREPMILL-E

PrepMill-E is electric version of PrepMill. A standard machine can cover the same pipe sizes and comes with the same cutting head. The electric motor made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time.

Free Speed 115 RPM
Power..... 750 W
Torque 368 Nm (280 Ft.Lbs)
Feed Stroke 25 mm (1")

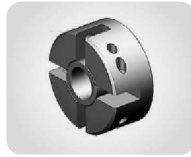


EXAMPLE TOOL APPLICATION



PrepMill with its 66 mm (2-5/8) width body perfectly fit into limited access areas such as Water wall panels. Easy to clamp and feed with our heavy duty ratchet or star wheel feed.

OPTIONAL HEADS



66 MM (2,59'')
The smallest cutter head, designed to fasten the wide range of cutting inserts.



88 MM (3,46'')
The popular, medium cutter head, designed to fasten the wide range of cutting inserts.



OBPM
Head for outside bevelling of tubes and pipes. Available in wide range of diameters and beveling angles.
→ TABLE PAGE 86



PRRMBH
Head for membrane and overlay removal. Efficiently remove material between boiler tubes.
→ TABLE PAGE 86



STWRPM
Head dedicated for strength weld removal. Heads are easy to align and sized per tube diameter.
→ TABLE PAGE 87



TFPM
Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.
→ TABLE PAGE 87

OPT. SHAFT



SHAF20
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.

OTHER OPTIONAL ACCESSORIES



HEAD FLANGE
Adapter to use all MiniMill's special cutter heads (from size 1-1/2" and up).



SPEED REDUCER
Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.



FAST CLAMPING SYSTEM
System offers rapid tube to tube cycle time, increased productivity (up to 4x) with little operator fatigue. Ideal for large amount of end preps.



STAR WHEEL
The most precise feed system. Used in many basic and demanding applications.

PREMILL LOCKING RANGES

WITH SHAF25

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAF25	NS-1	-	25	30	0,984	1,181	SP-24	1
	NS-2	-	30	35	1,181	1,378	SP-24	1
	NS-3	-	35	40	1,378	1,575	SP-25	2
	NS-4	-	40	45	1,575	1,772	SP-25	2
	NS-5	-	45	50	1,772	1,969	SP-25	2
	NS-6	-	50	55	1,969	2,165	SP-25	2
	NS-7	-	55	60	2,165	2,362	SP-25	2
	NS-8	-	60	65	2,362	2,559	SP-25	2
	NS-5	NS-10	62	67	2,441	2,638	SP-25	2
	NS-6	NS-10	67	72	2,638	2,835	SP-25	2
	NS-7	NS-10	72	77	2,835	3,031	SP-25	2
	NS-8	NS-10	77	82	3,031	3,228	SP-25	2
	NS-5	NS-20	82	87	3,228	3,425	SP-25	2
	NS-6	NS-20	87	92	3,425	3,622	SP-25	2
	NS-7	NS-20	92	97	3,622	3,819	SP-25	2
	NS-8	NS-20	97	102	3,819	4,016	SP-25	2
	NS-5	NS-30	102	107	4,016	4,213	SP-25	2
	NS-6	NS-30	107	112	4,213	4,409	SP-25	2
	NS-7	NS-30	112	117	4,409	4,606	SP-25	2
	NS-8	NS-30	117	122	4,606	4,803	SP-25	2

WITH SHAF20

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAF20	NS-0	-	20	24	0,787	0,945	SP-19	1
	NS-1	-	24	28	0,945	1,102	SP-19	1

EXAMPLE TOOL APPLICATION



HyperMill 56

Powerful pneumatic tube facing, bevelling and weld removal machine. The HyperMill 56 is a rugged, fast, portable weld end preparation lathe for various tubes and pipes, including stainless steel and other high chromium materials. A standard machine is equipped with a solid locking system to cover most common tube sizes.



STANDARD SET UP



SHAFT30
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.



135 MM (5,3")
The large cutter head, very sturdy and rigid, designed to fasten the wide range of cutting inserts.



Heavy duty locking system

STANDARD WORKING RANGE				TOTAL WORKING RANGE			
APPLICATION RANGE		LOCKING RANGE		APPLICATION RANGE		LOCKING RANGE	
30 – 136 mm		30 – 136 mm		20 – 175 mm		20 – 166 mm	
1,181 – 5,354"		0,181 – 4,354"		0,787 – 6,890"		0,787 – 6,535"	
FEED STROKE		POWER		FREE SPEED		TORQUE	
40 mm	1,6"	1,3 hp		55 rpm		280 Nm	210 Ft.lbs
55 cfm	1,3 m ³ /min	3,22"	82 mm	15"	385 mm	19 Lbs	9 kg

HYPERMILL 56E

HyperMill 56E is electric version of HyperMill 56. The machine can cover the same pipe sizes and comes with the same cutting head. The electric motor made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time.



Free Speed 58 RPM
Power..... 750 W
Torque 720 Nm (530 Ft.Lbs)
Feed Stroke 40 mm (1,6")

EXAMPLE TOOL APPLICATION



OPTIONAL HEADS



116 MM (4,56")
The large cutter head, designed to fasten the wide range of cutting inserts.



175 MM (6,89")
Cutter head special for the largest machines, designed to fasten the wide range of cutting inserts.



HMRBMH
Head for membrane and overlay removal. Efficiently remove material between boiler tubes.

OPTIONAL SHAFTS



SHAFT20
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.



SHAFT25
Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.

AVAILABLE HOLDERS

Streight weld removal holder



IB-45-37-HM
IB-45-30-HM
BIT:
2CDI

OTHER OPTIONAL ACCESSORIES



HEAD FLANGE
Adapter to use all MiniMill's special cutter heads (from size 1-1/2" and up).



SPEED REDUCER
Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.



RATCHET FEED
Feed system allowing to work in narrow and tight locations, eg. in water walls.

STANDARD HYPERMILL 56 LOCKING RANGES

WITH SHAFT30

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING		
			MIN	MAX	MIN	MAX	NO.	QTY.	
SHAFT30	NS-1		30	34	1,181	1,339	SP-29	1	
	NS-2		34	39	1,339	1,535	SP-29	1	
	NS-3		39	44	1,535	1,732	SP-30	2	
	NS-4		44	49	1,732	1,929	SP-30	2	
	NS-5		49	54	1,929	2,126	SP-30	2	
	NS-6		54	59	2,126	2,323	SP-30	2	
	NS-7		59	64	2,323	2,520	SP-30	2	
	NS-8		64	69	2,520	2,717	SP-30	2	
	NS-5	NS-10		66	71	2,598	2,795	SP-30	2
	NS-6	NS-10		71	76	2,795	2,992	SP-30	2
	NS-7	NS-10		76	81	2,992	3,189	SP-30	2
	NS-8	NS-10		81	86	3,189	3,386	SP-30	2
	NS-5	NS-20		86	91	3,386	3,583	SP-30	2
	NS-6	NS-20		91	96	3,583	3,780	SP-30	2
	NS-7	NS-20		96	101	3,780	3,976	SP-30	2
	NS-8	NS-20		101	106	3,976	4,173	SP-30	2
	NS-5	NS-30		106	111	4,173	4,370	SP-30	2
	NS-6	NS-30		111	116	4,370	4,567	SP-30	2
	NS-7	NS-30		116	121	4,567	4,764	SP-30	2
	NS-8	NS-30		121	126	4,764	4,961	SP-30	2

OPTIONAL HYPERMILL 56 LOCKING RANGES

WITH SHAFT30

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT30	NS-5	NS-40	126	131	4,961	5,157	SP-30	2
	NS-6	NS-40	131	136	5,157	5,354	SP-30	2
	NS-7	NS-40	136	141	5,354	5,551	SP-30	2
	NS-8	NS-40	141	146	5,551	5,748	SP-30	2
	NS-5	NS-50	146	151	5,748	5,945	SP-30	2
	NS-6	NS-50	151	156	5,945	6,142	SP-30	2
	NS-7	NS-50	156	161	6,142	6,339	SP-30	2
	NS-8	NS-50	161	166	6,339	6,535	SP-30	2

WITH SHAFT25

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING		
			MIN	MAX	MIN	MAX	NO.	QTY.	
SHAFT25	NS-1	-	25	30	0,984	1,181	SP-24	1	
	NS-2	-	30	35	1,181	1,378	SP-24	1	
	NS-3	-	35	40	1,378	1,575	SP-25	2	
	NS-4	-	40	45	1,575	1,772	SP-25	2	
	NS-5	-	45	50	1,772	1,969	SP-25	2	
	NS-6	-	50	55	1,969	2,165	SP-25	2	
	NS-7	-	55	60	2,165	2,362	SP-25	2	
	NS-8	-	60	65	2,362	2,559	SP-25	2	
	NS-5	NS-10		62	67	2,441	2,638	SP-25	2
	NS-6	NS-10		67	72	2,638	2,835	SP-25	2
	NS-7	NS-10		72	77	2,835	3,031	SP-25	2
	NS-8	NS-10		77	82	3,031	3,228	SP-25	2
	NS-5	NS-20		82	87	3,228	3,425	SP-25	2
	NS-6	NS-20		87	92	3,425	3,622	SP-25	2
	NS-7	NS-20		92	97	3,622	3,819	SP-25	2
	NS-8	NS-20		97	102	3,819	4,016	SP-25	2

WITH SHAFT20

SHAFT	JAWS	EXT.	RANGE [MM]		RANGE [INCH]		SPRING	
			MIN	MAX	MIN	MAX	NO.	QTY.
SHAFT20	NS-0	-	20	24	0,787	0,945	SP-19	1
	NS-1	-	24	28	0,945	1,102	SP-19	1
	NS-2	-	28	33	1,102	1,299	SP-19	1
	NS-3	-	33	38	1,299	1,496	SP-20	2

PipeMill

PipeMill is a pneumatic powered tube facing, bevelling and weld removal machine. The PipeMill is a rugged, fast and powerful weld end preparation lathe for various pipes including stainless steel and other exotic alloys. A standard machine is equipped with a locking system to cover sizes of 50,8 to 172 mm ID (2.000" to 6.800") with a 250 mm cutting head.



STANDARD SET UP



250 MM (9,8")

Cutter head special for the largest machines. Very rigid. Designed to fasten the wide range of cutting inserts.

STANDARD WORKING RANGE				OPTIONAL WORKING RANGE			
APPLICATION RANGE		LOCKING RANGE		APPLICATION RANGE		LOCKING RANGE	
50 – 279 mm		50 – 319 mm		50 – 319 mm		50 – 319 mm	
1,968 – 10,984"		1,968 – 12,559"		1,968 – 12,559"		1,968 – 12,559"	
FEED STROKE		POWER		FREE SPEED		TORQUE	
50 mm	1,968"	1,3 hp		Depends on gear			
AIR USE		BODY WIDTH		BODY HEIGHT		BODY WEIGHT	
70 cfm	2,2 m ³ /min	5,7"	145 mm	21,5"	550 mm	52,9 Lbs	24 kg

LOCKING RANGES WITH STANDARD JAWS

JAWS: SM-42






RANGE [MM]		RANGE [INCH]		EXTENSIONS		
MIN	MAX	MIN	MAX	A	B	C
50,0	65,0	1,969	2,559			
65,0	80,0	2,559	3,150	ML-42-A-75		
80,0	95,0	3,150	3,740	ML-42-A-150		
95,0	110,0	3,740	4,331	ML-42-A-225		
110,0	125,0	4,331	4,921	ML-42-A-300		
125,0	140,0	4,921	5,512	ML-42-A-375		
140,0	155,0	5,512	6,102			SML-42-C
155,0	170,0	6,102	6,693	ML-42-A-75		SML-42-C
170,0	184,5	6,693	7,264	ML-42-A-150		SML-42-C
184,5	199,0	7,264	7,835	ML-42-A-225		SML-42-C
199,0	214,0	7,835	8,425	ML-42-A-300		SML-42-C
214,0	229,0	8,425	9,016	ML-42-A-375		SML-42-C
229,0	244,5	9,016	9,626		ML-42-B	SML-42-C
244,5	259,5	9,626	10,217	ML-42-A-75	ML-42-B	SML-42-C
259,5	274,0	10,217	10,787	ML-42-A-150	ML-42-B	SML-42-C
274,0	289,0	10,787	11,378	ML-42-A-225	ML-42-B	SML-42-C
289,0	304,0	11,378	11,969	ML-42-A-300	ML-42-B	SML-42-C
304,0	319,0	11,969	12,559	ML-42-A-375	ML-42-B	SML-42-C

AVAILABLE GEARBOX CONFIGURATIONS

This tool comes with one chosen gearbox as a standard. Torque/speed depends on gear configuration:

GEARBOX 15	15 RPM	2544 Nm	1908 Ft.Lbs
GEARBOX 20	20 RPM	1883 Nm	1415 Ft.Lbs
GEARBOX 28	28 RPM	1290 Nm	969 Ft.Lbs
GEARBOX 37	37 RPM	971 Nm	730 Ft.Lbs

AVAILABLE HOLDERS

Facing	Inside bevelling and boring	Outside bevelling	J-Prep	Compound bevelling
				
F-45-90 BIT: 2CDI	F-CB-25+2-90 (ADJUSTABLE LENGTH FACING HOLDER FOR THE LAND) BIT: XXXXXXX	IB-45-37 IB-45-10 BIT: 2CDI	OB-45-45 OB-45-37 OB-45-30 OB-45-10 BIT: 2CDI	JP-45-45 JP-45-37 JP-45-30 BIT: 2CDJ-5
				CB-1037 (OTHERS ON REQUEST) BIT: CB-45

OPTIONAL HEAD

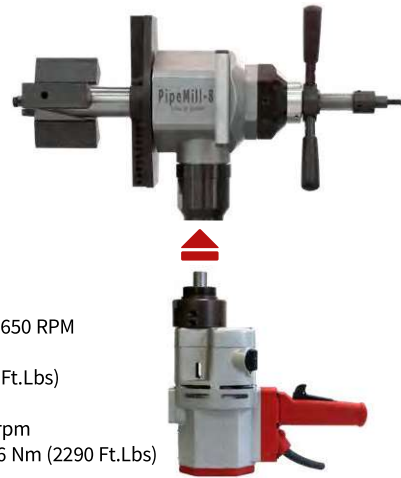


290 MM (11,4")
Biggest head for KRAIS Mini&HyperMill tools. Very rigid. Designed to fasten the wide range of cutting inserts.

PIPEMILL-E – ELECTRIC VERSION

PipeMill-E is electric version of PipeMill. The machine can cover the same pipe sizes and comes with the same cutting head. The electric motor with 4 speed mechanical gear box has also variable speed control and produce enormous torque on the cutter blade. Is interchangeable with pneumatic drive and can be purchased separately at any time. Take 5 min to replace from pneumatic to electric.

- DUDE-2000-4-SPEED
- Motor free speed.....120-210-380-650 RPM
 - Motor power.....2000 W
 - Motor torque (on the 1st gear).....240 Nm (180 Ft.Lbs)
 - Machine feed stroke40 mm (1,6")
 - Cutter head speed10-17-30-50 rpm
 - Max torque on cutter blade (on the 1st gear).... 3096 Nm (2290 Ft.Lbs)



EXAMPLE TOOL APPLICATION



SmartMill-8

Most powerful machine within this size range on the market today. Utilizes a powerful 2.2 kW (3 HP) pneumatic motor that is entirely engineered and manufactured by KRAIS. SmartMill-8 has a unique construction that has been specifically designed for the largest end prep systems.

- › Self-centering 40 mm (1,57") one piece locking shaft.
- › Only one mandrel and 6 Jaw sets needed to cover machines entire range.
- › Wide clamps produce superior clamping force for chatter free end preps.
- › Fully portable for on-site and Fab-shop work.

SmartMill-8 is available for sale or rent.



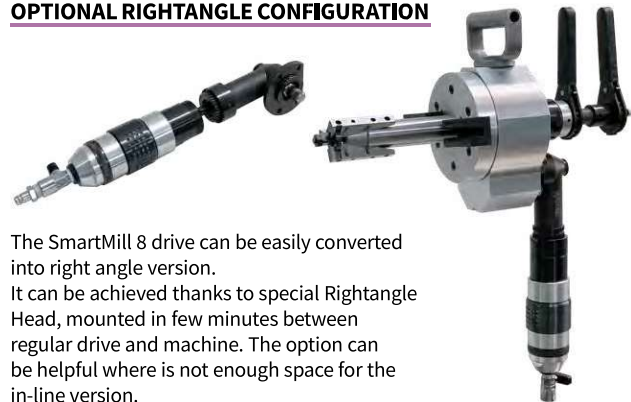
STANDARD WORKING RANGE		FEED STROKE	FREE SPEED	POWER	TORQUE		
APPLICATION RANGE	LOCKING RANGE						
40 - 219 mm	40 - 203,5 mm	50 mm	39 Rpm	3,0 hp	930 Nm		
1,574 - 8,622"	1,574 - 8,012"	2"			697 Ft.Lbs		
AIR USE		AIR PRESSURE		BODY DIMENSIONS		BODY WEIGHT	
75 cfm	2,2 m³/min	90 PSI	6,2 Bar	22 x 9,25 x 7,48"	560 x 235 x 190 mm	46 Lbs	21 kg

LOCKING RANGES WITH STANDARD JAWS

JAWS: SM-7

RANGE [MM]		RANGE [INCH]		SEGMENTS		
MIN	MAX	MIN	MAX	SM-42-0	SM-42-1	ML-42-A
40,0	55,0	1,575	2,165	SM-42-0		
55,0	69,5	2,165	2,736		SM-42-1	
69,5	84,0	2,736	3,307		SM-42-1	ML-42-A-75
84,0	98,5	3,307	3,878		SM-42-1	ML-42-A-150
98,5	113,5	3,878	4,469		SM-42-1	ML-42-A-225
113,5	128,5	4,469	5,059		SM-42-1	ML-42-A-300
128,5	143,5	5,059	5,650		SM-42-1	ML-42-A-300 ML-42-A-75
143,5	158,5	5,650	6,240		SM-42-1	ML-42-A-300 ML-42-A-150
158,5	173,5	6,240	6,831		SM-42-1	ML-42-A-300 ML-42-A-225
173,5	188,5	6,831	7,421		SM-42-1	ML-42-A-300 ML-42-A-225 ML-42-A-75
188,5	203,5	7,421	8,012		SM-42-1	ML-42-A-300 ML-42-A-225 ML-42-A-150

OPTIONAL RIGHTANGLE CONFIGURATION



The SmartMill 8 drive can be easily converted into right angle version. It can be achieved thanks to special Rightangle Head, mounted in few minutes between regular drive and machine. The option can be helpful where is not enough space for the in-line version.

SMARTMILL-8 PERFORMANCE



The performance of the machine may vary depending on the skill of the operator, the materials, the conditions of the tools and the air supply system in case of pneumatic unit.

AVAILABLE HOLDERS

Facing		Inside bevelling and boring	Outside bevelling	J-Prep	Compound bevelling
					
F-45-90 BIT: 2CDI	F-CB-25+2-90 (ADJUSTABLE LENGTH FACING HOLDER FOR THE LAND) BIT: XXXXXXX	IB-45-37 IB-45-10 BIT: 2CDI	OB-45-45 OB-45-37 OB-45-30 OB-45-10 BIT: 2CDI	JP-45-45 JP-45-37 JP-45-30 BIT: 2CDJ-5	CB-1037 (OTHERS ON REQUEST) BIT: CB-45

ADVANTAGES OF SMARTMILL-8



UNIQUE SHAFT DESIGN
40 mm (1,57") shaft, assures rigidity when machining heavy wall pipe. Only 6 set of jaws needed to cover the full locking range.



POWERFUL MOTOR UNIT
SmartMill-8 is powered by powerful and efficient drives dedicated for our Lathe series beveling machines. 39 rpm and 930 Nm (697 Ft.Lbs) torque on the cutter blade is a standard feature.



LIGHTWEIGHT AND PORTABLE
The innovative design made it possible to produce lightweight and portable machine. Small weight of SmartMill-8 allows for fatigue-free operation in all conditions.



HEAVY DUTY HANDLE
Machine is equipped with a solid and convenient aluminium handle.

OPTIONALS



RIGHT ANGLE HEAD
This right angle head allows for fastening drive in alternate positions. The useful option in tight spaces.



30 MM SHAFT
Optional shaft to enable the machine to be used for smaller tubes. The shaft is supplied with complete jaws set to cover up to 2" ID.

OPTIONAL ELECTRIC MOTOR UNIT

SmartMill-8E is electric version of SmartMill-8. The machine can cover the same pipe sizes and comes with the same cutting head. The electric motor with 4 speed mechanical gear box has also variable speed control and produce enormous torque on the cutter blade. Is interchangeable with pneumatic drive and can be purchased separately at any time. Take 5 min to replace from pneumatic to electric.



DUDE-2000-4-SPEED

Motor free speed: 120-210-380-650 RPM
Motor power: 2000 Watt
Motor torque (on the 1st gear): 240 Nm (180 Ft.Lbs)
Machine feed stroke: 50 mm (2")
Cutter head speed: 8-14-25-43 rpm
Max torque on cutter blade (on the 1st gear): 3600 Nm (2664 Ft.Lbs)

MiniLathe

- Most powerful machine within this size range on the market today. Utilises a powerful 2.2kW (3 HP) pneumatic motor that is entirely engineered and manufactured by KRAIS for the largest end prep systems.
- MiniLathe comes with one of 3 gearboxes as a standard. It gives a wide choice for operator. No need for extra gearbox that reduces the RPM and multiplies the torque - it comes as standard!
- Innovative 6 point locking system assures maximum stability during all machining operations.
- Self-centering 2,75" one piece locking shaft with built in jaws, eliminates the issue of broken or loosening retaining springs and o-rings.
- Only one mandrel and 10 Jaw sets needed to cover machines entire range.
- Wide clamps produce superior clamping force for chatter free end preps.
- Fully portable for on-site and Fab-shop work.
- Available for sale or rent.



STANDARD WORKING RANGE		FEED STROKE	POWER	FREE SPEED	TORQUE		
APPLICATION RANGE	LOCKING RANGE (ID)						
72 - 406 mm	70 - 400 mm	50 mm	3,0 Hp	DEPENDS ON GEARBOX			
2,800 - 16,000"	2,755 - 15,700"	2"					
70 cfm	2,2 m³/min	90 PSI	6,2 Bar	25 x 13 x 12"	640 x 330 x 300 mm	75 Lbs	35 kg

LOCKING RANGES WITH STANDARD JAWS

JAWS: ML-42







RANGE [MM]		RANGE [INCH]		SEGMENT		
MIN	MAX	MIN	MAX	A	B	C
70	85	2,756	3,346			
85	100	3,346	3,937	ML-42-A-75		
100	115	3,937	4,528	ML-42-A-150		
115	130	4,528	5,118	ML-42-A-225		
130	145	5,118	5,709	ML-42-A-300		
145	160	5,709	6,299	ML-42-A-375		
160	175	6,299	6,890			ML-42-C
175	190	6,890	7,480	ML-42-A-75		ML-42-C
190	205	7,480	8,071	ML-42-A-150		ML-42-C
205	220	8,071	8,661	ML-42-A-225		ML-42-C
220	235	8,661	9,252	ML-42-A-300		ML-42-C
235	250	9,252	9,843	ML-42-A-375		ML-42-C
250	265	9,843	10,433		ML-42-B	ML-42-C
265	280	10,433	11,024	ML-42-A-75	ML-42-B	ML-42-C
280	295	11,024	11,614	ML-42-A-150	ML-42-B	ML-42-C
295	310	11,614	12,205	ML-42-A-225	ML-42-B	ML-42-C
310	325	12,205	12,795	ML-42-A-300	ML-42-B	ML-42-C
325	340	12,795	13,386	ML-42-A-375	ML-42-B	ML-42-C
340	355	13,386	13,976	ML-42-A-300 ML-42-A-150	ML-42-B	ML-42-C
355	370	13,976	14,567	ML-42-A-300 ML-42-A-225	ML-42-B	ML-42-C
370	385	14,567	15,157	ML-42-A-375 ML-42-A-225	ML-42-B	ML-42-C
385	400	15,157	15,748	ML-42-A-375 ML-42-A-300	ML-42-B	ML-42-C

AVAILABLE GEARBOX

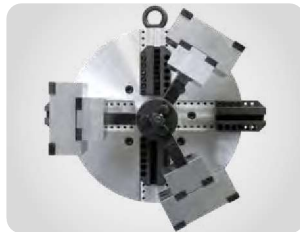
This tool comes with one of 3 gearboxes as a standard. Torque/speed depends on gear configuration.

GEARBOX 11	11 RPM	3850 Nm	2840 Ft.Lbs
GEARBOX 15	15 RPM	2615 Nm	1960 Ft.Lbs
GEARBOX 21	21 RPM	1770 Nm	1327 Ft.Lbs

AVAILABLE HOLDERS

Facing	Inside bevelling and boring	Outside bevelling	J-Prep	Compound bevelling	
 F-45-90 BIT: 2CDI	 F-CB-25+2-90 (ADJUSTABLE LENGTH FACING HOLDER FOR THE LAND) BIT: XXXXXXX	 IB-45-37 IB-45-10 BIT: 2CDI	 OB-45-45 OB-45-37 OB-45-30 OB-45-10 BIT: 2CDI	 JP-45-45 JP-45-37 JP-45-30 BIT: 2CDJ-5	 CB-1037 (OTHERS ON REQUEST) BIT: CB-45

ADVANTAGES OF MINILATHE



6 POINT LOCKING JAWS

150 mm (5,9") shaft, assures rigidity when machining heavy wall pipe. The jaws are fully contained within the shaft with no need for retaining springs or O-rings that easily brake or get lost.



POWERFUL MOTOR UNIT

Powerful and efficient drives dedicated for our Lathe series beveling machines. 11 rpm and 3850 Nm (2840 Ft.Lbs) torque on the cutter blade is a standard feature.



HEAVY DUTY PENDANT

Machine is equipped with a heavy duty pendant. This can be attached to both sides of the motor for operator convenience.



SLIDE BEARING

As an option we can supply a bronze slide bearing that delivers more stability and rigidity while machining a very hard materials and heavy wall pipes.

OPTIONAL MOTOR UNITS



DUDE-2000-4-SPEED

For thin wall application (up to 1" / 25,4 mm) is an electric motor DUDE-2000-4-SPEED, which offers 4 speed: 120-210-380-650 RPM



PDE MOTOR

The PipeLathe can also be supplied as an electric version, with a 3200 Watt heavy duty motor.



PDH MOTOR

Optional super strong hydraulic motor. Constructed on the basis of a small hydraulic motor and multistage planetary gear box. HyperLathe version generates 11 rpm and up to 8200 Nm (6050 Ft.Lbs) torque on cutter blade at constant cutting speed.



PDU MOTOR

Powerful and efficient drive dedicated for our Lathe series beveling machines. 0-5 rpm and 12500 Nm (9219 ft.lbs) torque on the cutter blade is a standard feature.

EXAMPLE TOOL APPLICATION



In order to facilitate the assembly of the machine in the pipe, the machine optionally can be equipped with a double-sided yoke with removable extensions so that two people can freely install into the processed pipe.

PipeLathe

- Powerful 3.5 HP pneumatic drive generating 12500 Nm (9259 ft.lbs) torque on the cutter blade. Variable speed control 0-5 rpm.
- No need for extra gear box that reduces the rpm and multiplies the torque. It comes as standard!
- 150 mm (5,9") One piece locking shaft with build in jaws, eliminates the issue of broken or loosening retaining springs and o-rings.
- One mandrel covers complete working range.
- Innovative 6 point locking system assures maximum stability during all machining operations.
- Only one mandrel and 6 Jaw sets needed to cover machines entire range.
- Self-centering shaft with build in jaws.
- Wide Clamps produce superior clamping force for chatter free end preps.
- Fully portable for on-site and Fab-shop work.
- Available for sale or rent.



STANDARD WORKING RANGE		FEED STROKE	POWER	FREE SPEED	TORQUE		
APPLICATION RANGE	LOCKING RANGE						
180 - 609 mm	175 - 600 mm	60 mm	3,5 hp	5 Rpm	12500 Nm		
7,0 - 24,0"	6,889 - 23,6"	2,4"			9219 Ft.lbs		
AIR USE		AIR PRESSURE		BODY DIMENSIONS		BODY WEIGHT	
85 cfm	2,8 m ³ /min	90 PSI	6,2 Bar	38 x 22 x 22"	950 x 550 x 500 mm	495 Lbs	225 kg

LOCKING RANGES WITH STANDARD JAWS

JAWS: PL-42







RANGE [MM]		RANGE [INCH]		SEGMENT		
MIN	MAX	MIN	MAX	A	B	C
175,0	200,0	6,890	7,874			
200,0	225,0	7,874	8,858	PL-42-A-125		
225,0	250,0	8,858	9,843	PL-42-A-250		
250,0	275,0	9,843	10,827	PL-42-A-375		
275,0	300,0	10,827	11,811	PL-42-A-500		
300,0	325,0	11,811	12,795	PL-42-A-500 PL-42-A-125		
325,0	350,0	12,795	13,780	PL-42-A-500 PL-42-A-250		
350,0	375,0	13,780	14,764		PL-42-B	
375,0	400,0	14,764	15,748	PL-42-A-125	PL-42-B	
400,0	425,0	15,748	16,732	PL-42-A-250	PL-42-B	
425,0	450,0	16,732	17,717	PL-42-A-375	PL-42-B	
450,0	475,0	17,717	18,701	PL-42-A-500	PL-42-B	
475,0	500,0	18,701	19,685			PL-42-C
500,0	525,0	19,685	20,669	PL-42-A-125		PL-42-C
525,0	550,0	20,669	21,654	PL-42-A-250		PL-42-C
550,0	575,0	21,654	22,638	PL-42-A-375		PL-42-C
575,0	600,0	22,638	23,622	PL-42-A-500		PL-42-C

EXAMPLE TOOL APPLICATION



PipeLathe is the strongest machine from all KRAIS Lathe tools. It allows for machining tubes up to 24" (600 mm) OD.

AVAILABLE HOLDERS

Facing	Inside bevelling and boring	Outside bevelling	J-Prep	Compound bevelling	
 F-45-90 BIT: 2CDI	 F-CB-25+2-90 (ADJUSTABLE LENGTH FACING HOLDER FOR THE LAND) BIT: XXXXXXX	 IB-45-37 IB-45-10 BIT: 2CDI	 OB-45-45 OB-45-37 OB-45-30 OB-45-10 BIT: 2CDI	 JP-45-45 JP-45-37 JP-45-30 BIT: 2CDJ-5	 CB-1037 (OTHERS ON REQUEST) BIT: CB-45

ADVANTAGES OF HYPERLATHE



HEAVY DUTY DESIGN

All the Lathe series machine design is based on long steel spindle which assure maximum rigidity because the locking shaft is fully mounted into that spindle instead partially into the main aluminium body what is causing adverse vibration due to a lot of tension on it.



POWERFUL MOTOR UNIT

Powerful and efficient drive dedicated for our Lathe series beveling machines. 0-5 rpm and 12500 Nm (9219 ft.lbs) torque on the cutter blade is a standard feature.



6 POINT LOCKING JAWS

150 mm (5,9") shaft, assures rigidity when machining heavy wall pipe. The jaws are fully contained within the shaft with no need for retaining springs or O-rings that easily brake or get lost.



HEAVY DUTY PENDANT

Machine is equipped with a heavy duty pendant. This can be attached to both sides of the motor for operator convenience.

OPTIONAL MOTOR UNITS



MOTOR PDE

The PipeLathe can also be supplied as an electric version, with a 3200 Watt heavy duty motor.



MOTOR PDH

Optional super strong hydraulic motor. Constructed on the basis of a small hydraulic motor and multistage planetary gear box. PipeLathe version generates 6 rpm and up to 14200 Nm (10475 Ft.Lbs) torque on cutter blade at constant cutting speed.

PipeLathe 40

- Powerful hydraulic drive generating 14500 Nm (10800 Ft.lbs) torque on the cutter blade. Variable speed control 0-5 RPM.
- No need for extra gear box that reduces the RPM and multiplies the torque. It comes as standard!
- 150 mm (5,9") locking shaft with build in jaws, eliminates the issue of broken or loosening retaining springs and o-rings.
- Innovative 6 point locking system with wide clamps assures maximum stability during machining.
- Only one mandrel and 6 Jaws set covers entire working range.
- Fully portable for on-site and Fab-shop work.
- Available for sale or rent.



MACHINE PERFORMANCE

PipeLathe 40 is the biggest internal mounted machine from all KRAIS Lathe tools. It allows for machining tubes up to 40" (600 mm) OD. Picture shows PipeLathe 40 machining 36" tube.



STANDARD WORKING RANGE		FEED STROKE	POWER	FREE SPEED	TORQUE		
APPLICATION RANGE	LOCKING RANGE						
180 - 1016 mm	175 - 972 mm	60 mm	3,5 hp	5 Rpm	12500 Nm		
7,0 - 40,0"	6,9 - 38,3"	2,4"			9219 Ft.lbs		
AIR USE		AIR PRESSURE		BODY DIMENSIONS		BODY WEIGHT	
85 cfm	2,8 m ³ /min	90 PSI	6,2 Bar	38 x 22 x 22"	950 x 550 x 500 mm	495 Lbs	225 kg

LOCKING RANGES WITH STANDARD JAWS

JAWS: PL-42

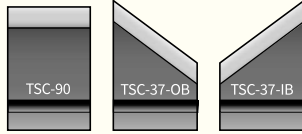
RANGE [MM]		RANGE [INCH]		SEGMENT				
MIN	MAX	MIN	MAX	A	B	C	D	E
175	200	6,9	7,9					
200	225	7,9	8,9	PL-42-A-125				
225	250	8,9	9,8	PL-42-A-250				
250	275	9,8	10,8	PL-42-A-375				
275	300	10,8	11,8	PL-42-A-500				
300	325	11,8	12,8	PL-42-A-500 PL-42-A-125				
325	350	12,8	13,8	PL-42-A-500 PL-42-A-250				
350	375	13,8	14,8		PL-42-B			
375	400	14,8	15,7	PL-42-A-125	PL-42-B			
400	425	15,7	16,7	PL-42-A-250	PL-42-B			
425	450	16,7	17,7	PL-42-A-375	PL-42-B			
450	475	17,7	18,7	PL-42-A-500	PL-42-B			
475	500	18,7	19,7			PL-42-C		
500	525	19,7	20,7	PL-42-A-125		PL-42-C		
525	550	20,7	21,7	PL-42-A-250		PL-42-C		
550	575	21,7	22,6	PL-42-A-375		PL-42-C		
575	600	22,6	23,6	PL-42-A-500		PL-42-C		
593	622	23,3	24,5	PL-42-A-500 PL-42-A-125		PL-42-C		

RANGE [MM]		RANGE [INCH]		SEGMENT				
MIN	MAX	MIN	MAX	A	B	C	D	E
621	647	24,4	25,5	PL-42-A-500 PL-42-A-250		PL-42-C		
646	671	25,4	26,4	PL-42-A-500 PL-42-A-375		PL-42-C		
667	693	26,3	27,3			PL-42-C	PL-42-D	
692	716	27,2	28,2	PL-42-A-125		PL-42-C	PL-42-D	
715	739	28,1	29,1	PL-42-A-250		PL-42-C	PL-42-D	
738	762	29,1	30,0	PL-42-A-375		PL-42-C	PL-42-D	
761	786	30,0	30,9	PL-42-A-500		PL-42-C	PL-42-D	
787	811	31,0	31,9			PL-42-C		PL-42-E
810	834	31,9	32,8	PL-42-A-125		PL-42-C		PL-42-E
833	856	32,8	33,7	PL-42-A-250		PL-42-C		PL-42-E
856	879	33,7	34,6	PL-42-A-375		PL-42-C		PL-42-E
878	903	34,6	35,6	PL-42-A-500		PL-42-C		PL-42-E
902	925	35,5	36,4	PL-42-A-500 PL-42-A-125		PL-42-C		PL-42-E
924	949	36,4	37,4	PL-42-A-500 PL-42-A-250		PL-42-C		PL-42-E
948	972	37,3	38,3	PL-42-A-500 PL-42-A-375				PL-42-E

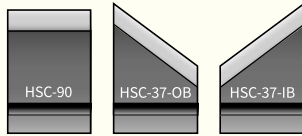
Cutters and inserts for tube bevelers

REGULAR CUTTERS

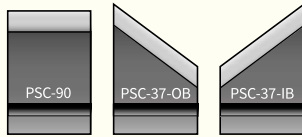
FOR USE WITHOUT HOLDERS
BIT: HSS and HSS Cobalt



Cutters for MiniMill series



Cutters for HyperMill series



Cutters for PipeMill series

INSERTS

Inserts options:
HSS-Co 5% cobalt
HSS-Co-AN 5% cobalt + ANOVA coating
HSS-M2
HSS-M2-TiN HSS+TiN coating



CI	A	B
mm	5	5

MAT: Carbide
Screw: MHS-2



CI7	A	B
mm	7	7

MAT: Carbide
Screw: MHS-2,7



CS	A	B
mm	9,5	9,5

MAT: HSS 6% Cobalt
Screw: MHS-4



CSZ	A	B
mm	5,8	9,5

MAT: HSS 6% Cobalt
Screw: MHS-2,5



CSS-CB	A	B
mm	6,3	9,5

MAT: HSS 6% Carbide
Screw: MHS-2,5



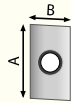
CSS	A	B
mm	6,3	9,5

MAT: HSS 6% Cobalt
Screw: MHS-2,5



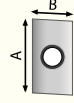
PO8	R
mm	8

MAT: Carbide
Screw: MHS-2,7



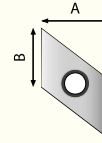
CDI	A	B
mm	18	9,5

MAT: HSS 6% Cobalt
Screw: MHS-4



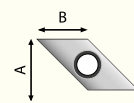
CDI-CB	A	B
mm	18	9,5

MAT: HSS 6% Carbide
Screw: MHS-4



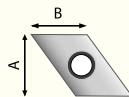
WRIL	A	B
mm	13,5	9,5

MAT: HSS 6% Cobalt
Screw: MHS-4



WRK	A	B
mm	10	9,5

MAT: HSS 6% Cobalt
Screw: MHS-4



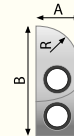
WRI	A	B
mm	13,5	9,5

MAT: HSS 6% Cobalt
Screw: MHS-4



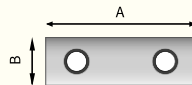
	A	B	R
CDJ-2.5*	18	9,5	2,5
CDJ-5	18	9,5	4,7
CDJ-8*	18	9,5	8,0

MAT: HSS 6% Cobalt
Screw: MHS-4
* na zamówienie



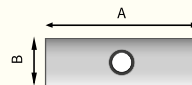
CSWR	A	B	R
mm	6,5	16,5	6

MAT: HSS 6% Cobalt
Screw: MHS-2,5



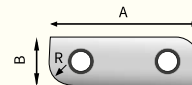
2CDI	A	B
mm	45	12,7

MAT: HSS 6% Cobalt
Screw: MHS-5



CDK	A	B
mm	25	9,5

MAT: HSS 6% Cobalt
Screw: MHS-5



2CDJ-5	A	B	R
mm	45	12,7	4,7

MAT: HSS 6% Cobalt
Screw: MHS-5



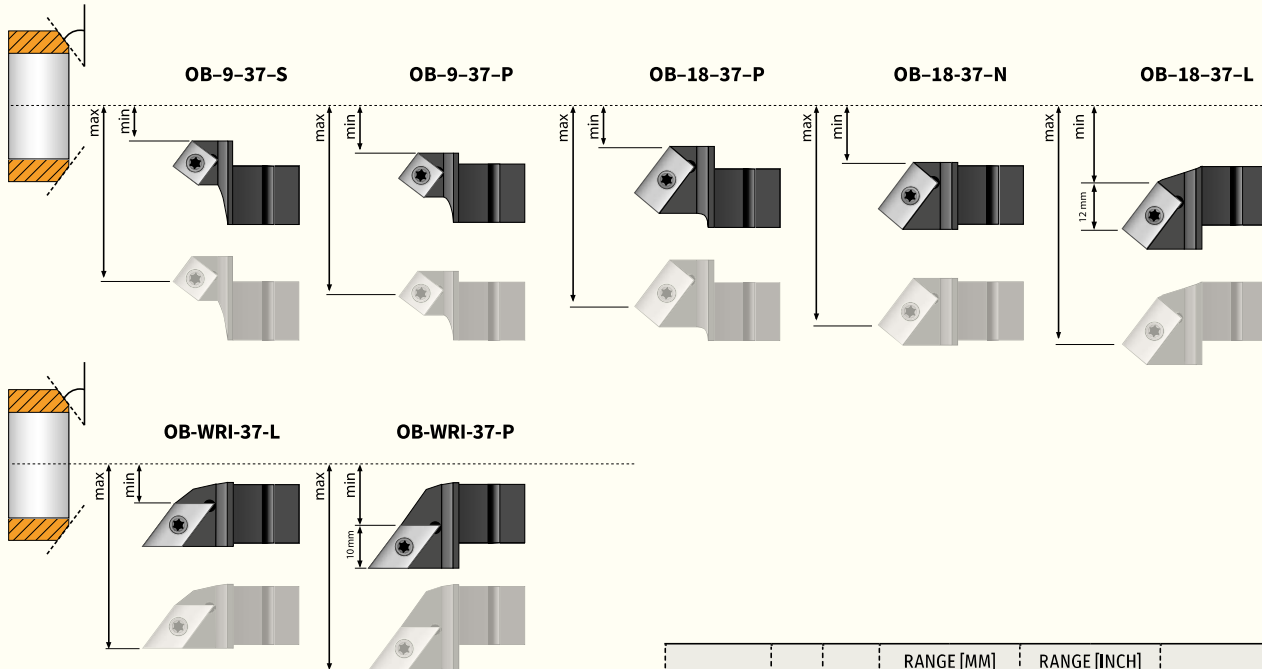
CSS-127	Min	Max
mm	9,5	15,0

MAT: HSS 6% Cobalt

📌 Holders for regular MiniMill/HyperMill cutter heads

OUTSIDE BEVELING HOLDERS

Standard: 37,5°; other angles only on request

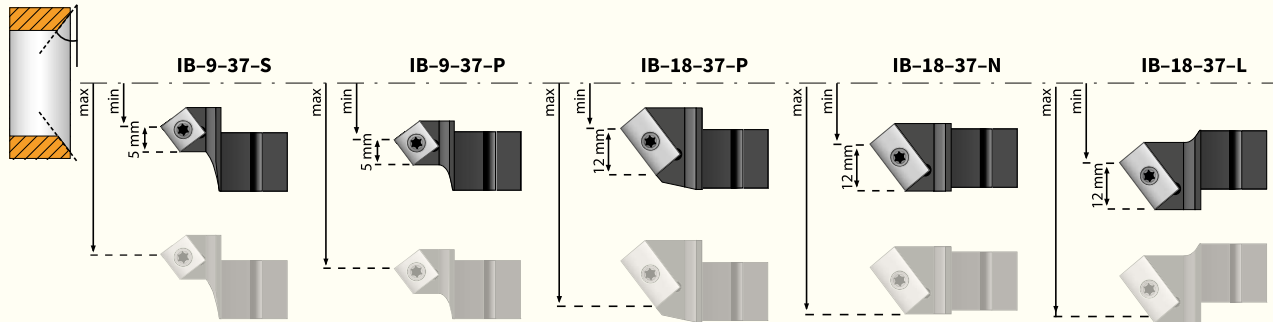


HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
OB-9-37-S	CS	60	16,00	26,00	0,630	1,024	20; 30; 37,5 ; 45
		88	16,00	51,00	0,630	2,008	20; 30; 37,5 ; 45
OB-9-37-P	CS	60	24,00	34,00	0,945	1,339	20; 30; 37,5 ; 45
		88	24,00	58,00	0,945	2,283	20; 30; 37,5 ; 45
OB-18-37-P	CDI	106	28,00	72,00	1,102	2,835	20; 30; 37,5 ; 45
		60	24,00	47,00	0,945	1,850	20; 30; 37,5 ; 45
		88	24,00	71,00	0,945	2,795	20; 30; 37,5 ; 45
		106	28,00	85,00	1,102	3,346	20; 30; 37,5 ; 45
		114	31,00	88,00	1,220	3,465	20; 30; 37,5 ; 45
OB-18-37-L	CDI	135	31,00	109,00	1,220	4,291	20; 30; 37,5 ; 45
		175	31,00	149,00	1,220	5,866	20; 30; 37,5 ; 45

HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
OB-18-37-N	CDI	60	34,00	56,00	1,339	2,205	20; 30; 37,5 ; 45
		88	34,00	80,00	1,339	3,150	20; 30; 37,5 ; 45
		106	38,00	94,00	1,496	3,701	20; 30; 37,5 ; 45
		114	43,00	101,00	1,693	3,976	20; 30; 37,5 ; 45
		135	43,00	122,00	1,693	4,803	20; 30; 37,5 ; 45
OB-18-37-L	CDI	175	43,00	162,00	1,693	6,378	20; 30; 37,5 ; 45
		60	40,00	63,00	1,575	2,480	20; 30; 37,5 ; 45
		88	40,00	87,00	1,575	3,425	20; 30; 37,5 ; 45
		106	44,00	101,00	1,732	3,976	20; 30; 37,5 ; 45
		114	47,00	104,00	1,850	4,094	20; 30; 37,5 ; 45
OB-18-37-L	CDI	135	47,00	125,00	1,850	4,921	20; 30; 37,5 ; 45
		175	47,00	165,00	1,850	6,496	20; 30; 37,5 ; 45
		OB-WRI-37-L	WRIL	64	22,00	66,00	0,866
OB-WRI-37-P	WRIL	64	36,00	80,00	1,417	3,150	30; 37,5
		99	36,00	116,00	1,417	4,567	30; 37,5

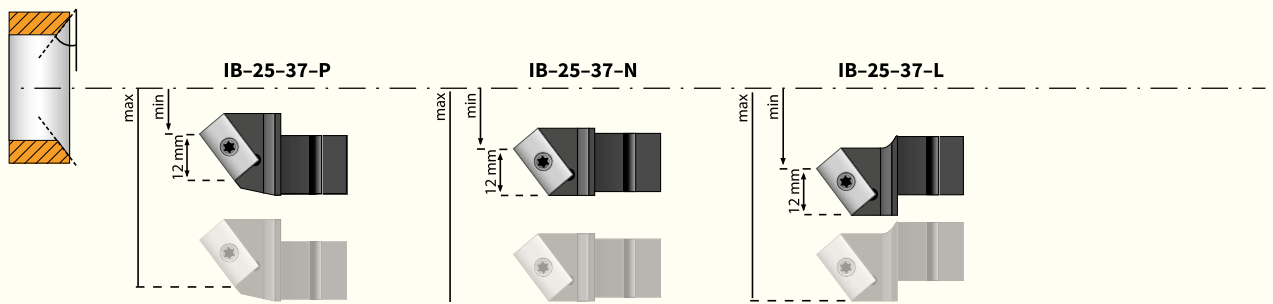
INSIDE BEVELING HOLDERS

Standard: 37,5°; other angles only on request



HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
IB-9-37-S	CS	60	29,00	39,00	1,142	1,535	20; 30; 37,5 ; 45
		88	29,00	63,00	1,142	2,480	20; 30; 37,5 ; 45
		106	33,00	77,00	1,299	3,031	20; 30; 37,5 ; 45
IB-9-37-P	CS	60	35,50	45,50	1,398	1,791	20; 30; 37,5 ; 45
		88	35,50	70,00	1,398	2,756	20; 30; 37,5 ; 45
		106	39,50	84,00	1,555	3,307	20; 30; 37,5 ; 45
IB-18-37-P	CDI	60	35,50	58,00	1,398	2,283	20; 30; 37,5 ; 45
		88	35,50	82,50	1,398	3,248	20; 30; 37,5 ; 45
		106	39,50	96,50	1,555	3,799	20; 30; 37,5 ; 45
		114	42,00	102,00	1,654	4,016	20; 30; 37,5 ; 45
		135	42,00	123,00	1,654	4,843	20; 30; 37,5 ; 45
175	42,00	163,00	1,654	6,417	20; 30; 37,5 ; 45		

HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
IB-18-37-N	CDI	60	44,50	67,50	1,752	2,657	20; 30; 37,5 ; 45
		88	44,50	92,00	1,752	3,622	20; 30; 37,5 ; 45
		106	48,50	106,00	1,909	4,173	20; 30; 37,5 ; 45
		114	51,00	111,00	2,008	4,370	20; 30; 37,5 ; 45
		135	51,00	132,00	2,008	5,197	20; 30; 37,5 ; 45
175	51,00	172,00	2,008	6,772	20; 30; 37,5 ; 45		
IB-18-37-L	CDI	60	53,00	76,00	2,087	2,992	20; 30; 37,5 ; 45
		88	53,00	100,00	2,087	3,937	20; 30; 37,5 ; 45
		106	57,00	114,00	2,244	4,488	20; 30; 37,5 ; 45
		114	60,00	120,00	2,362	4,724	20; 30; 37,5 ; 45
		135	60,00	141,00	2,362	5,551	20; 30; 37,5 ; 45
175	60,00	181,00	2,362	7,126	20; 30; 37,5 ; 45		

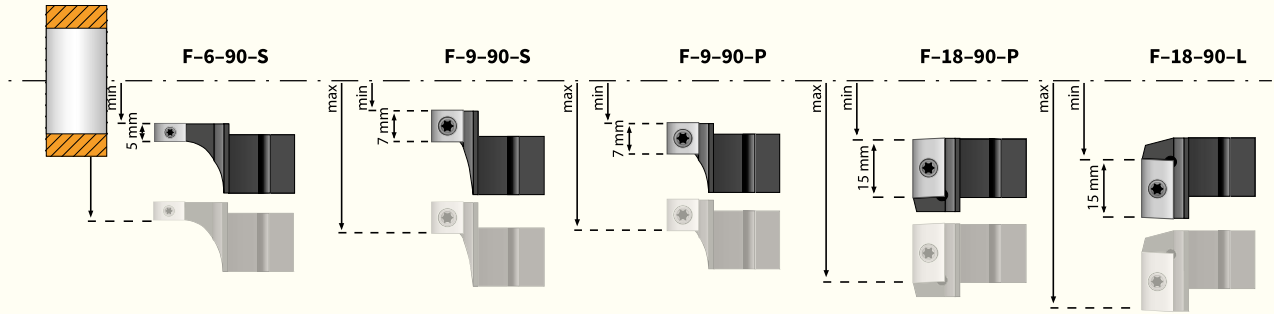


HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
IB-25-37-P	CDK	60	35,50	63,00	1,398	2,480	20; 30; 37,5 ; 45
		88	35,50	87,50	1,398	3,444	20; 30; 37,5 ; 45
		106	39,50	101,50	1,555	3,996	20; 30; 37,5 ; 45
		114	42,00	107,00	1,654	4,212	20; 30; 37,5 ; 45
		135	42,00	128,00	1,654	5,039	20; 30; 37,5 ; 45
		175	42,00	168,00	1,654	6,614	20; 30; 37,5 ; 45
IB-25-37-N	CDK	60	44,50	72,50	1,752	2,854	20; 30; 37,5 ; 45
		88	44,50	97,00	1,752	3,818	20; 30; 37,5 ; 45
		106	48,50	111,00	1,909	4,370	20; 30; 37,5 ; 45
		114	51,00	116,00	2,008	4,566	20; 30; 37,5 ; 45
		135	51,00	137,00	2,008	5,393	20; 30; 37,5 ; 45
		175	51,00	177,00	2,008	6,969	20; 30; 37,5 ; 45

HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
IB-25-37-L	CDK	60	53,00	81,00	2,087	3,188	20; 30; 37,5 ; 45
		88	53,00	105,00	2,087	4,133	20; 30; 37,5 ; 45
		106	57,00	119,00	2,244	4,685	20; 30; 37,5 ; 45
		114	60,00	125,00	2,362	4,921	20; 30; 37,5 ; 45
		135	60,00	146,00	2,362	5,748	20; 30; 37,5 ; 45
		175	60,00	186,00	2,362	7,322	20; 30; 37,5 ; 45

FACING HOLDERS

Standard: 90,0°

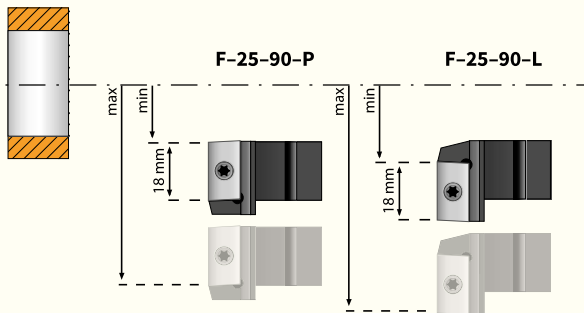


HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
F-6-90-S	CSS	60	14,50	24,50	0,571	0,965	90
F-9-90-S	CS	60	16,00	30,00	0,630	1,181	90
F-9-90-P	CS	60	24,00	38,00	0,945	1,496	90
		88	24,00	62,00	0,945	2,441	90
		106	28,00	75,00	1,102	2,953	90
		114	31,00	80,00	1,220	3,150	90
F-18-90-P	CDI	60	24,00	54,00	0,945	2,126	90
		88	24,00	79,00	0,945	3,110	90
		106	28,00	95,00	1,102	3,740	90

HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
F-18-90-P	CDI	114	31,00	98,00	1,220	3,858	90
		135	31,00	119,00	1,220	4,685	90
		175	31,00	159,00	1,220	6,260	90
F-18-90-L	CDI	60	33,00	62,00	1,299	2,441	90
		88	33,00	87,00	1,299	3,425	90
		106	37,00	101,00	1,457	3,976	90
		114	38,00	104,00	1,496	4,094	90
		135	38,00	125,00	1,496	4,921	90
		175	38,00	165,00	1,496	6,496	90

FACING HOLDERS

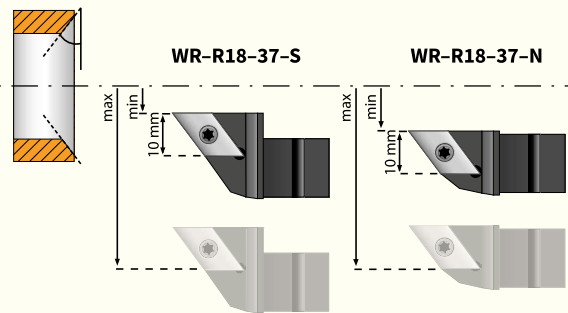
Standard: 90,0°



HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
F-25-90-P	CDK	60	24,00	61,00	0,945	2,401	90
		88	24,00	86,00	0,945	3,385	90
		106	28,00	102,00	1,102	4,015	90
	CDK	114	31,00	105,00	1,220	4,133	90
		135	31,00	126,00	1,220	4,960	90
		175	31,00	166,00	1,220	6,535	90
F-25-90-L	CDK	60	33,00	69,00	1,299	2,716	90
		88	33,00	94,00	1,299	3,700	90
		106	37,00	108,00	1,457	4,251	90
		114	38,00	111,00	1,496	4,370	90
		135	38,00	132,00	1,496	5,196	90
		175	38,00	172,00	1,496	6,771	90

WELD REMOVAL HOLDERS

STANDARD: 37,5°; OTHER ANGLES ONLY ON REQUEST



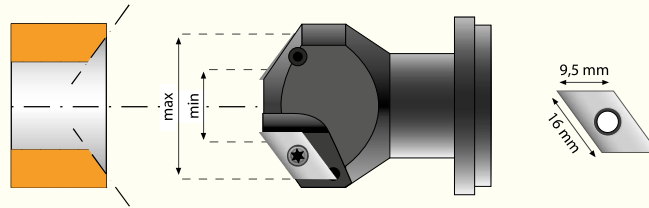
HOLDER NO.	BIT	HEAD	RANGE [MM]		RANGE [INCH]		DEGREE*
			MIN	MAX	MIN	MAX	
WR-R18-37-S	WRI	60	15,50	36,00	0,610	1,417	20; 30; 37,5 ; 45
		88	15,50	61,00	0,610	2,402	20; 30; 37,5 ; 45
		106	19,50	75,00	0,768	2,953	20; 30; 37,5 ; 45
		175	31,00	166,00	1,220	6,535	20; 30; 37,5 ; 45
WR-R18-37-N	WRI	60	30,00	50,00	1,181	1,969	20; 30; 37,5 ; 45
		88	30,00	75,00	1,181	2,953	20; 30; 37,5 ; 45
		106	34,00	89,00	1,339	3,504	20; 30; 37,5 ; 45
		114	37,00	94,00	1,457	3,701	20; 30; 37,5 ; 45
		175	37,00	155,00	1,457	6,102	20; 30; 37,5 ; 45

Special Heads for MiniMill

STWRMH

STRENGTH WELD REMOVAL
BIT: HSS 6% Cobalt
DEGREE: 37.5°

Custom designed head dedicated for strength weld removal. The heads are sized per tube diameter and are precisely engineered so that the inserts cannot damage the shaft or locking jaws. Simple, trouble-free set up makes these heads very advantageous.

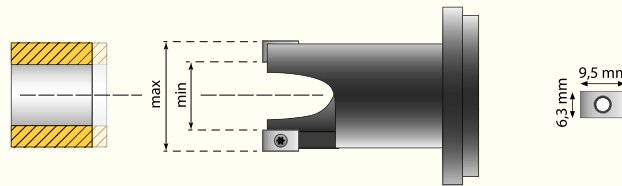


HEAD NR	TUBE CAPACITY			RANGE [INCH]		RANGE [MM]		INSERT	NO. OF INSERTS	SHAFT
	[INCH]	[MM]	BWG	MIN	MAX	MIN	MAX			
STWRMH-190	0,750	19,05	12-23	0,530	1,46	13,50	37,00	WRI	2	901 MM#151 12,4 mm
STWRMH-222	0,875	22,23	12-23	0,650	1,496	16,50	38,00	WRI	2	905 MM#151 13,9 mm
STWRMH-254	1,000	25,40	10-23	0,732	1,654	18,60	42,00	WRI	2	909 MM#151 16,9 mm
STWRMH-285	1,125	28,58	10-23	0,858	1,772	21,80	45,00	WRI	2	STD Shaft: 20 or 25 mm
STWRMH-317	1,250	31,75	9-23	0,945	1,850	24,00	47,00	WRI	2	STD Shaft: 20 or 25 mm
STWRMH-381	1,500	38,10	8-23	1,142	2,047	29,00	52,00	WRI	2	STD Shaft: 20 or 25 mm
STWRMH-444	1,750	44,45	8-23	1,417	2,244	36,00	57,00	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-508	2,000	50,80	6-23	1,575	2,480	40,00	63,00	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-571	2,250	57,15	6-23	1,811	2,717	46,00	69,00	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-603	2,375	60,33	6-23	1,949	2,854	49,50	72,50	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-635	2,500	63,50	6-23	2,067	2,972	52,50	75,50	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-762	3,000	76,20	6-23	2,579	3,484	65,50	88,50	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-889	3,500	88,90	6-23	3,071	3,976	78,00	101,00	CDI	2	STD Shaft: 20 or 25 mm
STWRMH-900	4,000	101,60	6-23	3,563	4,469	90,50	113,50	CDI	2	STD Shaft: 20 or 25 mm

TFMH

TUBE FACING MILLING HEAD
BIT: HSS 6% Cobalt
DEGREE: 90.0°

A tube facing milling head created for facing tubes made of any type of material. Utilizes 6% cobalt inserts.

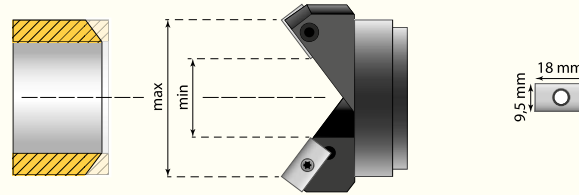


HEAD NR	RURA			RANGE [INCH]		RANGE [MM]		INSERT	NO. OF INSERTS	SHAFT
	[INCH]	[MM]	BWG	MIN	MAX	MIN	MAX			
TFMH-145	0,570	14,48	16-23	0,441	0,870	11,2	22,1	CSZ	2	801 MM#151 Micro 10,0MM
TFMH-158	0,625	15,88	16-23	0,500	0,933	12,70	23,70	CSZ	2	805 MM#151 Micro 11,5 MM
TFMH-190	0,750	19,05	12-23	0,531	1,004	13,50	25,50	CSS	2	901 MM#151 12,4 mm
TFMH-222	0,875	22,23	12-23	0,654	1,063	16,60	27,00	CSS	2	905 MM#151 13,9 mm
TFMH-254	1,000	25,40	11-23	0,764	1,201	19,40	30,50	CSS	2	909 MM#151 16,9 mm
TFMH-285	1,125	28,58	11-23	0,854	1,307	21,70	33,20	CSS	2	915 MM#151 20,0 mm
TFMH-317	1,250	31,75	9-23	0,949	1,366	24,10	34,70	CSS	2	915 MM#151 20,0 mm
TFMH-381	1,500	38,10	9-23	1,197	1,614	30,40	41,00	CSS	2	915 MM#151 20,0 mm
TFMH-444	1,750	44,45	9-23	1,449	1,862	36,80	47,30	CS	2	MM#37
TFMH-508	2,000	50,80	9-23	1,701	2,114	43,20	53,70	CS	2	MM#37

OBMH

OUTSIDE BEVEL MILING HEAD
BIT: HSS 6% Cobalt
DEGREE: 37,5°

Dedicated for the outside beveling of both tubes and pipes. Sized per tube or pipe diameter and angle of required weld bevel. The heads are precisely engineered so that the inserts cannot damage the shaft or locking jaws.

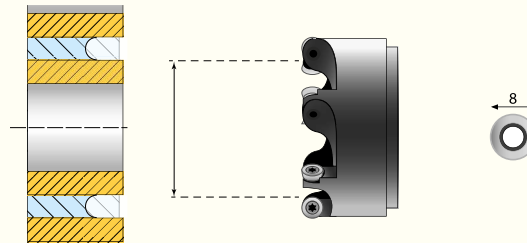


HEAD NR	TUBE CAPACITY			RANGE [INCH]		RANGE [MM]		INSERT	NO. OF INSERTS	SHAFT
	[INCH]	[MM]	BWG	MIN	MAX	MIN	MAX			
OBMH-190	0,750	19,05	14-23	0,5826	0,866	14,80	22,00	CS	2	901 MM#151 12,4 mm
OBMH-222	0,875	22,23	12-23	0,654	1,004	16,60	25,50	CS	2	905 MM#151 13,9 mm
OBMH-254	1,000	25,40	11-23	0,764	1,122	19,40	28,50	CS	2	909 MM#151 16,9 mm
OBMH-285	1,125	28,58	11-23	0,890	1,240	22,60	31,50	CS	2	915 MM#151 20 mm
OBMH-317	1,250	31,75	8-23	0,917	1,732	23,30	44,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-381	1,500	38,10	6-23	0,984	1,850	25,00	47,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-444	1,750	44,45	6-23	1,024	1,890	26,00	48,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-508	2,000	50,80	6-23	1,181	2,047	30,00	52,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-571	2,250	57,15	6-23	1,417	2,283	36,00	58,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-603	2,375	60,33	6-23	1,535	2,402	39,00	61,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-635	2,500	63,50	6-23	1,654	2,559	42,00	65,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-762	3,000	76,20	6-23	2,165	3,031	55,00	77,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-889	3,500	88,90	6-23	2,677	3,543	68,00	90,00	CDI	2	STD Shaft: 20 or 25 mm
OBMH-900	4,000	101,60	6-23	3,150	4,016	80,00	102,00	CDI	2	STD Shaft: 20 or 25 mm

MMRBMH

MEMBRANE REMOVAL HEAD
BIT: CARBIDE

Specially designed head for membrane removal and overlay head (cladding removal)

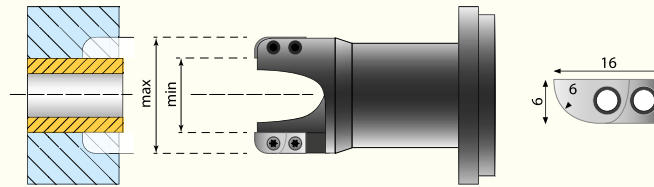


HEAD NR	TUBE CAPACITY		RANGE [INCH]		RANGE [MM]		INSERT	NO. OF INSERTS
	[INCH]	[MM]	MIN	MAX	MIN	MAX		
MMRBMH-254	1,000	25,40	1,000	1,630	25,40	41,40	PO8	4
MMRBMH-288	1,125	28,58	1,134	1,764	28,80	44,80	PO8	5
MMRBMH-317	1,250	31,75	1,248	1,878	31,70	47,70	PO8	5
MMRBMH-381	1,500	38,10	1,500	2,130	38,10	54,10	PO8	6
MMRBMH-444	1,750	44,45	1,748	2,378	44,40	60,40	PO8	6
MMRBMH-508	2,000	50,80	2,000	2,630	50,80	66,80	PO8	7
MMRBMH-571	2,250	57,15	2,252	2,882	57,20	73,20	PO8	7
MMRBMH-603	2,375	60,33	2,374	3,004	60,30	76,30	PO8	7
MMRBMH-635	2,500	63,50	2,500	3,130	63,50	79,50	PO8	7
MMRBMH-762	3,000	76,20	3,000	3,630	76,20	92,20	PO8	8
MMRBMH-889	3,500	88,90	3,500	4,130	88,90	104,90	PO8	8
MMRBMH-101	4,000	101,60	4,000	4,630	101,60	117,60	PO8	9

SWROTC

TUBE FACING MILLING HEAD
BIT: HSS 6% Cobalt

A seal weld removal head over tube circumference prior to re-welding the damaged joint without removing the tube.



HEAD NR	TUBE CAPACITY		RANGE [INCH]		RANGE [MM]		INSERT	NO. OF INSERTS	SHAFT
	[INCH]	[MM]	MIN	MAX	MIN	MAX			
SWROTC-190	0,750	19,05	0,750	1,222	19,05	31,05	CSWR	2	901 MM#151 12,4 mm
SWROTC-222	0,875	22,23	0,874	1,346	22,20	34,20	CSWR	2	905 MM#151 13,9 mm
SWROTC-254	1,000	25,40	1,000	1,472	25,40	37,40	CSWR	2	909 MM#151 16,9 mm
SWROTC-285	1,125	28,58	1,124	1,596	28,55	40,55	CSWR	2	915 MM#151 20,0 mm
SWROTC-318	1,250	31,7	1,250	1,722	31,75	43,75	CSWR	2	915 MM#151 20,0 mm
SWROTC-381	1,500	38,1	1,500	1,969	38,10	50,01	CSWR	2	915 MM#151 20,0 mm