

Accessories for BRB and REB machines

Tool holder WH

Incl. Torx screw. Combination possibilities of tool holders and multifunctional tools.

ITEM	WELD	CAN BE USED WITH MACHINE	HEIGHT [MM]	HEIGHT [INCH]	CODE	KG
WH12-I	I	BRB 4	20	0.787	790 086 210	0.035
WH12-I / short	I	BRB 4	14	0.551	790 086 281	0.032
WH15-I	I	BRB 4 / REB	20	0.787	790 092 202	0.100
WH15-I	I	BRB 4 / REB	27	1.063	790 092 204	0.100
WH15-I**	I	BRB 4 / REB	16.5 - 23	0.650 - 0.906	790 093 410	0.247
WH30-I	I	REB	20	0.787	790 093 202	0.166
WH30-I	I	REB	27	1.063	790 093 204	0.235
WH12-V-30°	V/Y	BRB 4	-	-	790 086 214	0.040
WH12-V-30° / short	V	BRB 4	-	-	790 086 282	0.036
WH12-V-37.5°	V/Y	BRB 4	-	-	790 086 216	0.040
WH12-V-45°	V/Y	BRB 4	-	-	790 086 474	0.052
WH12-V-80°	V/Y	BRB 4 / REB	-	-	790 093 462	0.115
WH12-V-35°	V/Y	BRB 4	-	-	790 086 272	0.048
WH15-V-30°	V/Y	BRB 4 / REB	-	-	790 092 210	0.100
WH15-V-37.5°	V/Y	BRB 4 / REB	-	-	790 092 216	0.100
WH12-V-37.5° / short	V	BRB 4	-	-	790 086 283	0.035
WH15-V-45°	V/Y	BRB 4 / REB	-	-	790 092 218	0.144
WH15-V-60°	V/Y	BRB 4 / REB	-	-	790 092 212	0.100
WH30-V-15°	V/Y	REB	-	-	790 093 468	0.200
WH30-V-30°	V/Y	REB	-	-	790 093 210	0.192
WH30-V-37.5°	V/Y	REB	-	-	790 093 216	0.199
WH30-V-40°	V/Y	REB	-	-	790 093 510	0.237
WH30-V-45°	V/Y	REB	-	-	790 093 404	0.204
WH12-U-10°	U	BRB 4	-	-	790 086 208	0.044
WH12-U-15°	U	BRB 4 / REB	-	-	790 086 213	0.044
WH12-U-20°	U	BRB 4	-	-	790 086 224	0.047
WH12-U-20° / large clamping surface	U	BRB 4 / REB	-	-	790 086 476	0.091
WH12-U-25°	U	BRB 4	-	-	790 086 212	0.051
WH30-U-7°	U	BRB 4 / REB	-	-	790 093 408	0.206
WH30-U-10°	U	BRB 4 / REB	-	-	790 093 220	0.174
WH30-U-14°	U	REB	-	-	790 093 474	0.190
WH30-U-20°	U	BRB 4 / REB	-	-	790 093 218	0.184
WH30-U-25°	U	REB	-	-	790 093 478	0.165
WH5-ID-14°	ID	BRB 4 / REB	-	-	790 093 406	0.139
WH5-ID-45°***	ID	BRB 4 / REB	-	-	790 086 218	0.055
WH10-ID-5° / long	ID	BRB 4 / REB	-	-	790 093 400	0.152
WH10-ID-14°	ID	BRB 4 / REB	-	-	790 093 402	0.160
WH10-ID-14° / 30 mm deep	ID	BRB 4 / REB	-	-	790 093 466	0.265
WH12-ID-10° / from ID 50	ID	BRB 4 / REB	-	-	790 086 280	0.060
WH10-ID-30°	ID	BRB 4 / REB	-	-	790 093 493	0.100
WH10-ID-45°	ID	REB	-	-	790 093 494	0.107
WH10-ID-80°***	ID	BRB 4	-	-	790 086 275	0.075
WH10-AD-10°	OD	BRB 4	-	-	790 086 276	

* Special holder for squaring pipes in pipe sheets.

** Tool holder WH, adjustable for I-seam. The scope of delivery includes: Adjustable tool holder, multifunctional tool MFW 15-V / I-4 (Code 790 093 037), Torx screws, adjustment plates.

*** Tool holder WH for cutting pipes from pipe sheets.



WH12-I



WH15-I**



WH15-V-30°



WH12-U-15°



WH5-ID-14°

Multifunctional tools MFW "High-Performance"

Turning plate tools with 2 or 4 cutting edges coated with a high-performance tool wear protective coating. Can be used for pipes made of high-alloyed steel (special steel), low-alloy and unalloyed steel, aluminum as well as cast materials.

ITEM	VERSION	FOR WALL THICKNESSES		CAN BE USED WITH WH/FOR JOINT FORM	CAN BE USED WITH	CODE	KG
		[MM]	[INCH]				
MFW5-U-2-R0,4	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20° with radius 0.4 mm	BRB 2	790 085 030	0.002
MFW5-U-2-R2	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20° with radius 2 mm	BRB 2	790 085 032	0.002
MFW30-V /I-4	High-Performance	2 - 30	0,079 - 1,181	V, Y, I	REB	790 093 033	0.055
MFW30-U-4-R5	High-Performance	2 - 30	0,079 - 1,181	V, Y, I, U with radius 5 mm	REB	790 093 034	0.055
MFW30-U-4-R2	High-Performance	2 - 30	0,079 - 1,181	V, Y, I, U with radius 2 mm	REB	790 093 035	0.060
MFW30-U-4-R0,4	High-Performance	2 - 30	0,079 - 1,181	V, Y, I, U with radius 0.4 mm	REB	790 093 042	0.060
MFW4-I-2	High-Performance	max. 4	max. 0.157	WH4-I-2 (special bracket)	BRB 2	790 085 031	0.002
MFW15-V /I-4	High-Performance	2 - 15	0,079 - 0,591	V, Y, I	BRB 4 / REB	790 093 037	0.055
MFW12-V /I-2	High-Performance	2 - 12	0,079 - 0,472	V, Y, I, U with radius 1.2 mm	BRB 4	790 086 060	0.003
MFW12-U-2-R2	High-Performance	2 - 12	0,079 - 0,472	V, Y, I, U with radius 2 mm	BRB 4	790 086 064	0.003
MFW5-ID-2-R0.4 (14°)	High-Performance	-	-	WH5-ID-14° with radius 0.4 mm	BRB 4 / REB	790 093 039	0.003
MFW5-ID-2-R0.4 (45°)	High-Performance	-	-	WH5-ID-45° with radius 0.4 mm	BRB 4 / REB	790 086 061	0.002
MFW10-ID-2-R0.4 (80°)	High-Performance	-	-	WH10-ID-80° with radius 0.4 mm	BRB 4	790 086 062	0.002
MFW10-ID-2-R0.8 (14°)	High-Performance	-	-	WH10-ID-14° with radius 0.8 mm	REB	790 093 038	0.002
MFW10-ID-2-R3 (14°)	High-Performance	-	-	WH10-ID-14° with radius 3 mm	REB	790 093 041	0.004



Feed ratchet for BRB 4



Balancer spring



Cooling cutting material KSS-TOP



Pipe elbow clamp



Clamping wedge set optional

Feed ratchet for BRB 4

Specifically for use in tight spaces, such as when cutting finned pipes.

ITEM	CODE	KG
Feed ratchet for BRB 4	790 086 127	0.420

Balancer spring

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

ITEM	CODE	KG
Balancer spring	832 030 002	3.800

Cooling cutting material KSS-TOP

The water-soluble, fully synthetic fluid increases the tool service lives of the turning plates. Has good corrosion protection characteristics. Was developed to drinking water requirements in accordance with the DVGW work sheet W521 (thread-cutting materials for drinking water installation) and corresponds in essential respects to these specifications. Is biologically readily degradable (OECD 302 B).

ITEM	VERSION	CODE	KG
Cooling cutting material KSS-TOP	Pump sprayer with 500ml	790 060 226	0.630
Cooling cutting material KSS-TOP refill canister	Canister with 10l	790 060 227	11.000

Tube elbow tensioner

For processing pipe elbows with the REB 6 with an ID of 75 to 157 mm (2.953" - 6.181").

Scope of delivery:

- 1 hard-sided transport case
- 1 mast with clamping device for pipe elbows
- 1 aligning tool
- 8 clamping inserts with 3 pins each for the dimension range 75 - 157 mm (2.953" - 6.181")

ITEM	CODE	KG
Tube elbow tensioner for REB 6 complete	790 093 015	9.900

Clamping wedge sets optional

For extending the dimension of the standard REB machines.

ITEM	CAN BE USED WITH	PIPE ID [MM]	PIPE ID [INCH]	CODE	KG
Clamping wedge sets	REB 6	155 - 166	6.102 - 6.535	790 093 295	1.300

PIPE BEVELING TECHNOLOGY

Combination possibilities of tool holders WH and multifunctional tool MFW for REB and BRB machines

Tools for weld seam preparation "I-seam"			
CODE	TOOL HOLDER	TORX SCREWS	FITTING MFWs
790 086 210	WH 12-I-H 20 mm	790 086 220	790 086 060 with R 1.2
790 086 281	WH 12-I / short	790 086 220	790 086 060 with R 1.2
790 092 202	WH 15-I-H 20 mm	790 093 226	790 093 037 with R 0
790 092 204	WH 15-I-H 27 mm	790 093 226	790 093 037 with R 0
790 093 202	WH 30-I-H 20 mm	790 093 226	790 093 033 with R 0
790 093 204	WH 30-I-H 27 mm	790 093 226	790 093 033 with R 0
790 093 410	WH 15-I-H 16.5-23 mm (adjustable)	790 093 226 / 790 093 425	790 093 037 with R 0
Tools for weld seam preparation "V-seam" and "Y-seam"			
CODE	TOOL HOLDER	TORX SCREWS	FITTING MFWs
790 086 214	WH 12-V-30°	790 086 220	790 086 060 with R 1.2
790 086 282	WH 12-V-30° / short	790 086 220	790 086 060 with R 1.2
790 086 272	WH 12-V-35°	790 086 220	790 086 060 with R 1.2
790 086 216	WH 12-V-37.5°	790 086 220	790 086 060 with R 1.2
790 086 283	WH 12-V-37.5° / short	790 086 220	790 086 060 with R 1.2
790 086 474	WH 12-V-45°	790 086 022	790 086 060 with R 1.2
790 093 462	WH 12-V-80°	790 086 220	790 086 060 with R 1.2
790 092 210	WH 15-V-30°	790 093 226	790 093 037 with R 0
790 092 216	WH 15-V-37.5°	790 093 226	790 093 037 with R 0
790 092 218	WH 15-V-45°	790 093 226	790 093 037 with R 0
790 092 212	WH 15-V-60°	790 093 226	790 093 037 with R 0 / 790 093 047
790 093 468	WH 30-V-15°	790 093 226	
790 093 210	WH 30-V-30°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 216	WH 30-V-37.5°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 404	WH 30-V-45°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 470	WH 30-V-50°	790 093 226	790 093 033 with R 0 / 790 093 043
790 093 472	WH 30-V-55°	790 093 226	790 093 033 with R 0 / 790 093 043
Tools for weld seam preparation "U-seam"			
CODE	TOOL HOLDER	TORX SCREWS	FITTING MFWs
790 086 208	WH 12-U-10°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 213	WH 12-U-15°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 224	WH 12-U-20°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 476	WH 12-U-20° large clamping surface	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 086 212	WH 12-U-25°	790 086 220	790 086 060 with R 1.2 / 790 086 064 with R 2
790 093 408	WH 30-U-7°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 220	WH 30-U-10°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 474	WH 30-U-14°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 468	WH 30-U-15°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 218	WH 30-U-20°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
790 093 478	WH 30-U-25°	790 093 226	790 093 034 with R 5 / 790 093 035 with R 2
Tools for "Beveling/inside turning"			
CODE	TOOL HOLDER	TORX SCREWS	FITTING MFWs
790 093 406	WH 5-ID-14°	790 093 224	790 093 039 with R 0.4
790 086 218	WH 5-ID-45°	790 093 224	790 086 061 with R 0.4
790 093 400	WH 10-ID-5° / long	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 402	WH 10-ID-14°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 093 466	WH 10-ID-14° / 30 mm deep	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 296	WH 10-ID-60°	790 093 225	790 093 038 with R 0.8 / 790 093 041 with R 3
790 086 275	WH 10-ID-80°	790 086 220	790 086 062 with R 0.4
790 086 280	WH 12-ID-10° / from ID 50	790 086 217	790 086 060 with R 1.2
790 093 494	WH 10-ID-45°	790 086 220	790 093 040 with R 0.8
790 093 493	WH 10-ID-30°	790 086 220	790 093 040 with R 0.8
Tools for "outer processing"			
CODE	TOOL HOLDER	TORX SCREWS	FITTING MFWs
790 086 276	WH 10-AD-10°	790 086 220	790 086 062 with R 0.4

Areas of application of tool holders for U-seam

		BRB 4 Mast Ø 19 WZT Ø 68		BRB 4 Mast Ø 32 WZT Ø 68		BRB 4 Mast Ø 32 WZT Ø 120		REB 6 Mast Ø 40 WZT Ø 183	
Maximum inner diameter for 1mm lip strength									
Code	Designation	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]
790 085 228	WH 5-U-20°	-	-	-	-	104	34	159	49
790 093 220	WH 30-U-10°	-	-	-	-	58	34	121	49
790 093 474	WH 30-U-14°	-	-	-	-	58	34	121	49
790 093 468	WH 30-V/U-15°	-	-	-	-	58	34	121	49
790 093 218	WH 30-U-20°	-	-	-	-	58	34	121	49
790 093 478	WH 30-U-25°	-	-	-	-	58	34	121	49
790 093 408	WH 30-U-7°	-	-	-	-	58	34	121	49
790 086 208	WH 12-U-10°	32	21	-	-	84	34	147	49
790 086 224	WH 12-U-20°	32	21	-	-	84	34	147	49
790 086 212	WH 12-U-25°	32	21	-	-	84	34	147	49

Areas of application of tool holders for pipe inner processing

Inside turning		BRB 4 Mast Ø 19 WZT Ø 68		BRB 4 Mast Ø 32 WZT Ø 68		BRB 4 Mast Ø 32 WZT Ø 120		REB 6 Mast Ø 40 WZT Ø 183	
Processable pipe inner diameter (0.5 mm safety distance to the mast)									
Code	Designation	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]	ID max. [mm]	ID min. [mm]
790 093 400	WH 10-ID-5° / long	-	-	-	-	105	61	159	71
790 093 402	WH 10-ID-14°	-	-	-	-	105	61	159	71
790 093 406	WH 5-ID-14°	-	-	-	-	96	43	159	60
790 093 466	WH 10-ID-14° / 30 mm deep	-	-	-	-	105	61	159	78
790 086 218	WH 5-ID-45°	49	27	49	37	107	37	159	58
Areas of application of tool holders for pipe sheet processing									
790 086 275	WH 10-ID-80°	58	43	58	56	110	56	159	64

* For diameter 20 mm: maximum chamfer width 4 - 5 mm

Abbreviations:

WH = Tool holder

WZT = Tool carrier/holder

Lip lengths for use of plane holders 790 092 202 / 790 093 202 or 790 086 210

Code	Designation (α)	MFW 12-V/1-2-R1.2 790 086 060	MFW 30-U-4-R2 790 093 035	MFW 30-U-4-R5 790 093 034
		Lip length (X1)		
790 093 218	WH 30-U-20°	-	1.4 mm	0 mm
790 093 220	WH 30-U-10°	-	2.5 mm	0.5 mm
790 093 408	WH 30-U-7°	-	3.8 mm	1.1 mm
790 093 474	WH 30-U-14°	-	2.3 mm	0 mm
790 093 478	WH 30-U-25°	-	1.1 mm	0 mm
790 086 208	WH 12-U-10°	1.5 mm	-	-
790 086 212	WH 12-U-25°	1.5 mm	-	-
790 086 224	WH 12-U-20°	1.5 mm	-	-

Lip lengths for use of plane holders 790 093 410 (adjustable)

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

Abbreviations:

WH = Tool holder

WZT = Tool carrier/holder

