



Powerful and robust boiler pipe preparation machine!



BRB Pneumatic/Auto with pneumatic clamping, ideal for series processing



The "NC" clamping system never loses grip thanks to clamping wedges firmly anchored in the mandrel



Optimized electric motor – the BRB 2 will also soon be available as an electric model



Holder for balancer allows work to be carried out quickly and effortlessly



Optimum performance with the low weight

# Boiler Pipe Preparation Machines BRB

- Handy and compact design
- Precise and reproducible weld preparation
- Fast application with the BRB Pneumatic/Auto by means of pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications
- High performance and lightweight
- High-performance coated tool bits with up to 4 cutting edges
- Quick clamping system for tools with easy adjustment
- Adjustable air outlet
- Easy to change tools
- Tools adaptable on all BRB machines
- Possibility to retrofit to previous BRB models to BRB Pneumatic/Auto and to the new clamping system "NC"
- Up to 3 tools can be used at the same time

**Powerful and robust Boiler Prep Machine. Counterboring and axial turning of pipes made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique tool system QTC®.** Designed for pipe end preparations and boiler pipe applications.

The BRB machines are available in the following **drive versions**:

- **Electric:** 230 V, 50/60 Hz EU or 120 V, 50/60 Hz EU/US  
Electric drive with single-phase AC motor, protection class II (double insulated), Built-in electronic variable cutting speed
- **Pneumatic:** Pneumatic power drive. Manufacturer's warranty can only be given when using a mobile air unit. We recommend the mobile air unit from Orbitalum Tools, Code 790 093 060 (see page 65).
- **Pneumatic/Auto:** Pneumatic multi-disc motor with additional pneumatic clamping system. Time is of the essence when installing or repairing boiler pipes, the new pneumatic clamping system greatly reduces the time to both clamp and release the machine, improving efficiency. The machine centers itself on the inside diameter of the pipe and then clamps automatically by using the toggle switch, likewise the toggle switch releases the clamping after the machining operation. This is why the BRB with automatic pneumatic clamping is ideal for continuous production e.g. boiler and heat exchanger applications.

Technical data	BRB 2 Electric	BRB 2 Pneumatic	BRB 2 Pneu/Auto	BRB 4 Electric	BRB 4 Pneumatic	BRB 4 Pneu/Auto
Power	0.5 kW	0.38 kW	0.38 kW	1.5 kW	1.0 kW	1.0 kW
Speed	18 - 118 rpm	0 - 120 rpm	0 - 120 rpm	12 - 37 rpm	0 - 110 rpm	0 - 110 rpm
Air supply requirement (at 6 bar)	–	0.7 m <sup>3</sup> /min	0.7 m <sup>3</sup> /min	–	1.0 m <sup>3</sup> /min	1.0 m <sup>3</sup> /min
Noise level LAeq 1 m (EN 23741), approx.	76 dB (A)	82 dB (A)	82 dB (A)	82 dB (A)	84 dB (A)	84 dB (A)
Vibration level (EN 28662, part 1)	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>	2.5 m/s <sup>2</sup>

Please choose before ordering the above mentioned BRB drive version one of the following **clamping systems**:

- Standard clamping system (see page 52)
- NC clamping system (see page 54)

**All BRB machines come with:**

- 1 Boiler Pipe Preparation Machine BRB 2 or BRB 4
- 1 Durable storage and shipping case
- Tool retainer, clamping sets, mandrels, application kits (tables see page 52 and page 54).
- 1 KSS-TOP lubricant spray pump KSS-TOP (Code 790 060 226)
- 1 Tool set
- 1 Set of operating instructions and spare parts list

## BRB with clamping system "Standard"

BRB 4 with clamping system "NC" see page 54.

A detailed description of the machine, technical specifications and scope of delivery see on page 50. Please specify the required clamping system ("Standard" or "NC"), the application kit (Kit 1 to Kit 5) as well as the drive version (Electric, Pneumatic or Pneumatic/Auto) with your purchase order.

Application range	BRB 2		BRB 4					
	Kit 1	Kit 2	Kit 1	Kit 2	Kit 3	Kit 4	Kit 5	
Pipe ID (Ø)	[mm]	12.75 - 25.5	19.1 - 46.0	19.1 - 33.8	32.0 - 61.7	32.0 - 110.8	19.1 - 61.7	19.1 - 110.8
clamping range)	[inch]	0.502 - 1.004	0.752 - 1.811	0.752 - 1.330	1.260 - 2.429	1.260 - 4.370	0.752 - 2.429	0.752 - 4.362
Tool retainer Ø	[mm]	50.0 / 12.75	50.0 / 16.0	68.0 / 19.0	68.0 / 27.0	120.0 / 27.0	68.0 / 19.0 68.0 / 27.0	68.0 / 19.0 68.0 / 27.0 120.0 / 27.0
	[inch]	1.969 / 0.502	1.969 / 0.630	2.677 / 0.748	2.677 / 1.063	4.724 / 1.063	2.677 / 0.748 2.677 / 1.063	2.677 / 0.748 2.677 / 1.063 4.724 / 1.063
Clamping wedges	[Sets]	6	8	4	3	6	7	10
Mandrel Ø	[mm]	12.75	19.05	19.05	31.5	31.5	19.05 31.5	19.05 31.5
	[inch]	0.502	0.750	0.750	1.240	1.240	0.750 1.240	0.750 1.240
Pipe OD	[mm]	16.75 - 41.5	23.0 - 62.0	64.0	73.0	114.3	73.0	114.3
	[inch]	0.659 - 1.634	0.906 - 2.441	2.51	2.87	4.50	2.87	4.50
Wall thickness*	[mm]	2 - 8	2 - 8	2 - 15	2 - 15	2 - 15	2 - 15	2 - 15
	[inch]	0.079 - 0.315	0.079 - 0.315	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590

\* depending on pipe material and dimension

Article	Version	Clamping system	Code	Weight of machine kg	Dispatch weight kg
BRB 2 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 085 011		12.200
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 085 012		12.000
BRB 2 EL, Kit 1	120 V, 50/60 Hz EU/US	Standard	790 085 021		
BRB 2 EL, Kit 2	120 V, 50/60 Hz EU/US	Standard	790 085 022		
BRB 2 Pneumatic, Kit 1	Pneumatic	Standard	790 085 007		11.900
BRB 2 Pneumatic, Kit 2	Pneumatic	Standard	790 085 008		12.300
BRB 2 Pneu/Auto, Kit 1	Pneumatic/Auto	Standard	790 085 041		13.300
BRB 2 Pneu/Auto, Kit 2	Pneumatic/Auto	Standard	790 085 042		13.500
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	Standard	790 086 011		15.000
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	Standard	790 086 012		16.000
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	Standard	790 086 013		22.800
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	Standard	790 086 014		18.000
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	Standard	790 086 015		19.000
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	Standard	790 086 021		15.000
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	Standard	790 086 022		16.000
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	Standard	790 086 023		18.500
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	Standard	790 086 024		18.000
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	Standard	790 086 025		19.000
BRB 4 Pneumatic, Kit 1	Pneumatic	Standard	790 086 001		14.000
BRB 4 Pneumatic, Kit 2	Pneumatic	Standard	790 086 002		15.000
BRB 4 Pneumatic, Kit 3	Pneumatic	Standard	790 086 003		17.000
BRB 4 Pneumatic, Kit 4	Pneumatic	Standard	790 086 004		16.600
BRB 4 Pneumatic, Kit 5	Pneumatic	Standard	790 086 005		23.700
BRB 4 Pneu/Auto, Kit 1	Pneumatic/Auto	Standard	790 086 031		
BRB 4 Pneu/Auto, Kit 2	Pneumatic/Auto	Standard	790 086 032		
BRB 4 Pneu/Auto, Kit 3	Pneumatic/Auto	Standard	790 086 033		
BRB 4 Pneu/Auto, Kit 4	Pneumatic/Auto	Standard	790 086 034		
BRB 4 Pneu/Auto, Kit 5	Pneumatic/Auto	Standard	790 086 035		24.500



**BRB 2 and BRB 4 Electric**  
with clamping system "Standard"



**BRB 2 and BRB 4 Pneumatic**  
with clamping system "Standard"



**BRB 2 and BRB 4 Pneumatic/Auto**  
with clamping system "Standard"

## Retrofit kits BRB Standard “Dimension”

To extend the diameter dimension range of BRB machines.

Retrofit kits “Dimension” for BRB machines with clamping system “NC” see page 55.

Retrofit kits “Dimension” for BRB 4 with drive version Pneumatic/Auto on request.



Retrofit kit BRB Standard “Dimension”

No.	for	Version	Code-No.	For retrofitting	Mandrel Ø		Tool retainer Ø		Extension of dimension to			
					Pipe ID		Pipe OD		Pipe ID		Pipe OD	
					[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
01	BRB 2	Auto	790 085 016	Kit 2 to Kit 1	12.75	0.500	50.00	1.968	12.75 - 25.5	0.500 - 1.004	16.75 - 41.5	0.659 - 1.634
02	BRB 2	Pneu/EL	790 085 017	Kit 2 to Kit 1	12.75	0.500	50.00	1.968	12.75 - 25.5	0.500 - 1.004	16.75 - 41.5	0.659 - 1.634
03	BRB 2	Pneu/EL	790 085 018	Kit 1 to Kit 2	19.10	0.750	50.00	1.968	19.10 - 46.0	0.750 - 1.811	23.00 - 50.0	0.910 - 1.960
01	BRB 4	Pneu/EL	790 086 051	Kit 1 to Kit 4 / Kit 1 to Kit 2	31.50	1.240	68.0	2.677	19.1 - 61.7	0.752 - 2.429	70.0	2.756
02	BRB 4	Pneu/EL	790 086 052	Kit 1 to Kit 3	31.50	1.240	120.0	4.724	19.1 - 110.8	0.752 - 4.362	114.3	4.500
03	BRB 4	Pneu/EL	790 086 053	Kit 2 to Kit 1 / Kit 3 to Kit 1	19.05	0.750	68.0	2.677	19.1 - 61.7	0.752 - 2.429	70.0	2.756
04	BRB 4	Pneu/EL	790 086 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	32.0 - 120.0	1.260 - 4.724	114.3	4.500
05	BRB 4	Pneu/EL	790 086 055	Kit 1 to Kit 5	31.50	1.240	68.0	2.677	19.1 - 120.0	0.752 - 4.724	114.3	4.500
06	BRB 4	Pneu/EL	790 086 056	Kit 3 to Kit 2	-	-	68.0	2.677	32.0 - 110.8	1.260 - 4.362	114.3	4.500

Article	Version	Code	kg
Retrofit kit BRB 2 Standard/01 "Dimension"	Kit 2 to Kit 1 (Auto)	790 085 016	1.235
Retrofit kit BRB 2 Standard/02 "Dimension"	Kit 2 to Kit 1	790 085 017	0.800
Retrofit kit BRB 2 Standard/03 "Dimension"	Kit 1 to Kit 2	790 085 018	1.235
Retrofit kit BRB 4 Standard/01 "Dimension"	Kit 1 to Kit 4 / Kit 1 to Kit 2	790 086 051	2.600
Retrofit kit BRB 4 Standard/02 "Dimension"	Kit 1 to Kit 3	790 086 052	3.700
Retrofit kit BRB 4 Standard/03 "Dimension"	Kit 2 to Kit 1 / Kit 3 to Kit 1	790 086 053	1.900
Retrofit kit BRB 4 Standard/04 "Dimension"	Kit 2 to Kit 3 / Kit 4 to Kit 5	790 086 054	1.900
Retrofit kit BRB 4 Standard/05 "Dimension"	Kit 1 to Kit 5	790 086 055	4.200
Retrofit kit BRB 4 Standard/06 "Dimension"	Kit 3 to Kit 2	790 086 056	0.700

## Retrofit kits BRB Standard “Pneumatic to Auto”

Retrofitting to pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications. Only for pneumatic machine versions. Easy and fast to mount.

The retrofit kit comes with: clamping cylinder complete, spindle complete and feed handle.

BRB retrofit kits for machines with clamping system “NC” see page 55.

Article	Kit	Code	kg
Retrofit kit BRB 2 Standard/01 "Pneumatic to Auto"	Kit 1	790 085 081	-
Retrofit kit BRB 2 Standard/02 "Pneumatic to Auto"	Kit 2	790 085 082	-
Retrofit kit BRB 4 Standard/01 "Pneumatic to Auto"	Kit 1	790 086 081	-
Retrofit kit BRB 4 Standard/02 "Pneumatic to Auto"	Kit 2	790 086 082	-
Retrofit kit BRB 4 Standard/03 "Pneumatic to Auto"	Kit 3	790 086 083	-
Retrofit kit BRB 4 Standard/04 "Pneumatic to Auto"	Kit 4	790 086 084	-
Retrofit kit BRB 4 Standard/05 "Pneumatic to Auto"	Kit 5	790 086 085	-

## Retrofit kits BRB “Standard to NC”

Retrofit kits BRB “Standard to NC” for BRB with drive version Pneumatic/Auto on request.

Article	Clamping range Ø		Code		kg
	[mm]	[inch]			
Retrofit kit BRB 2/01 "Standard to NC"	19.1 - 38.0	0.752 - 1.490	<b>790 185 083</b>		–
Retrofit kit BRB 4/01 "Standard to NC"	19.1 - 38.0	0.752 - 1.490	<b>790 186 071</b>		–
Retrofit kit BRB 4/02 "Standard to NC"	35.0 - 64.0	1.378 - 2.520	<b>790 186 072</b>		–
Retrofit kit BRB 4/03 "Standard to NC"	35.0 - 108.0	1.378 - 4.252	<b>790 186 073</b>		–
Retrofit kit BRB 4/04 "Standard to NC"	19.1 - 64.0	0.752 - 2.520	<b>790 186 074</b>		–
Retrofit kit BRB 4/05 "Standard to NC"	19.1 - 108.0	0.752 - 4.252	<b>790 186 075</b>		–

## BRB 4 with clamping system "NC"

BRB with clamping system "Standard" see page 52.

The wedges of the new clamping system "NC" are fixed to the mandrel – the ideal solution for applications where foreign particles should not access into the pipe or boiler pipe. Especially when working vertically the "NC" clamping system ensures additional safety.

A detailed description of the machine, technical specifications and scope of delivery see on page 51. Please specify the required clamping system ("Standard" or "NC"), the application kit (Kit 1 to Kit 5) as well as the drive version (Electric, Pneumatic or Pneumatic/Auto) with your purchase order.



BRB 2 and BRB 4 Electric with clamping system "NC"



BRB 2 and BRB 4 Pneumatic with clamping system "NC"



BRB 2 and BRB 4 Pneumatic/Auto with clamping system "NC"

Application rangee	BRB 2		BRB 4				
	Kit 2	Kit 1	Kit 2	Kit 3	Kit 4	Kit 5	
Pipe ID (Ø) [mm]	19.1 - 38.0	19.1 - 38.0	35.0 - 64.0	35.0 - 108.0	19.1 - 64.0	19.1 - 108.0	
clamping range) [inch]	0.752 - 1.490	0.752 - 1.490	1.378 - 2.520	1.378 - 4.252	0.752 - 2.520	0.752 - 4.252	
Tool retainer Ø [mm]	50.0 / 16.0	68.0 / 19.0	68.0 / 27.0	120.0 / 27.0	68.0 / 19.0 68.0 / 27.0	68.0 / 19.0 68.0 / 27.0 120.0 / 27.0	
[inch]	1.969 - 0.630	2.677 / 0.748	2.677 / 1.063	4.724 / 1.063	2.677 / 0.748 2.677 / 1.063	2.677 / 0.748 2.677 / 1.063 4.724 / 1.063	
Clamping wedges [Sets]	6	6	7	18 (8+10)	13	24 (14+10)	
Mandrel Ø [mm]	19.05	19.05	34.5	34.5	19.05 34.5	19.05 34.5	
[inch]	0.750	0.750	1.358	1.358	0.750 1.358	0.750 1.358	
Pipe OD [mm]	23.0 - 62.0	64.0	73.0	114.3	73.0	114.3	
[inch]	0.906 - 2.441	2.51	2.87	4.50	2.87	4.50	
Wall thickness* [mm]	2 - 8	2 - 15	2 - 15	2 - 15	2 - 15	2 - 15	
min. - max. [inch]	0.079 - 0.315	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	0.079 - 0.590	

\* depending on pipe material and dimension

Article	Version	Clamping system	Code	Weight of machine kg	Dispatch weight kg
BRB 2 EL, Kit 2	230 V, 50/60 Hz EU	NC	790 185 012		13.000
BRB 2 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	790 185 022		13.000
BRB 2 Pneumatic, Kit 2	Pneumatic	NC	790 185 002		12.500
BRB 2 Pneu/Auto, Kit 2	Pneumatic/Auto	NC	790 185 042		13.800
BRB 4 EL, Kit 1	230 V, 50/60 Hz EU	NC	790 186 011		
BRB 4 EL, Kit 2	230 V, 50/60 Hz EU	NC	790 186 012		
BRB 4 EL, Kit 3	230 V, 50/60 Hz EU	NC	790 186 013		23.300
BRB 4 EL, Kit 4	230 V, 50/60 Hz EU	NC	790 186 014		25.200
BRB 4 EL, Kit 5	230 V, 50/60 Hz EU	NC	790 186 015		26.400
BRB 4 EL, Kit 1	120 V, 50/60 Hz EU/US	NC	790 186 021		
BRB 4 EL, Kit 2	120 V, 50/60 Hz EU/US	NC	790 186 022		
BRB 4 EL, Kit 3	120 V, 50/60 Hz EU/US	NC	790 186 023		
BRB 4 EL, Kit 4	120 V, 50/60 Hz EU/US	NC	790 186 024		
BRB 4 EL, Kit 5	120 V, 50/60 Hz EU/US	NC	790 186 025		26.000
BRB 4 Pneumatic, Kit 1	Pneumatic	NC	790 186 001		19.500
BRB 4 Pneumatic, Kit 2	Pneumatic	NC	790 186 002		
BRB 4 Pneumatic, Kit 3	Pneumatic	NC	790 186 003		22.200
BRB 4 Pneumatic, Kit 4	Pneumatic	NC	790 186 004		
BRB 4 Pneumatic, Kit 5	Pneumatic	NC	790 186 005		25.500
BRB 4 Pneu/Auto, Kit 1	Pneumatic/Auto	NC	790 186 031		
BRB 4 Pneu/Auto, Kit 2	Pneumatic/Auto	NC	790 186 032		
BRB 4 Pneu/Auto, Kit 3	Pneumatic/Auto	NC	790 186 033		23.400
BRB 4 Pneu/Auto, Kit 4	Pneumatic/Auto	NC	790 186 034		
BRB 4 Pneu/Auto, Kit 5	Pneumatic/Auto	NC	790 186 035		26.000

## Retrofit kits BRB 4 NC "Dimension"

To extend the diameter dimension range of BRB 4 machines.

Retrofit kits "Dimension" for BRB 4 machines with clamping system "Standard" see page 53. Retrofit kits "Dimension" for BRB with drive version Pneumatic/Auto on request.

No.	Code-No.	For retrofitting	Mandrel Ø		Tool retainer Ø		Extension of dimension to			
							Pipe ID		Pipe OD	
			[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
10	790 186 051	Kit 1 to Kit 4 / Kit 1 to Kit 2	34.50	1.358	68.0	2.677	19.1 - 64.0	0.752 - 2.520	70.0	2.756
11	790 186 052	Kit 1 to Kit 3	34.50	1.358	120.0	4.724	19.1 - 108.0	0.752 - 4.252	114.3	4.500
12	790 186 053	Kit 2 to Kit 1 / Kit 3 to Kit 1	19.05	0.750	68.0	2.677	19.1 - 64.0	0.752 - 2.520	70.0	2.756
13	790 186 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	35.0 - 120.0	1.378 - 4.724	114.3	4.500
14	790 186 055	Kit 1 to Kit 5	34.50	1.358	68.0	2.677 120.0 4.724	19.1 - 120.0	0.752 - 4.724	114.3	4.500
15	790 186 056	Kit 3 to Kit 2	-	-	68.0	2.677	35.0 - 108.0	1.378 - 4.252	114.3	4.500

Article	Version	Code	kg
Retrofit kit BRB 4 NC/10 "Dimension"	Kit 1 to Kit 4 / Kit 1 to Kit 2	790 186 051	-
Retrofit kit BRB 4 NC/11 "Dimension"	Kit 1 to Kit 3	790 186 052	-
Retrofit kit BRB 4 NC/12 "Dimension"	Kit 2 to Kit 1 / Kit 3 to Kit 1	790 186 053	-
Retrofit kit BRB 4 NC/13 "Dimension"	Kit 2 to Kit 3 / Kit 4 to Kit 5	790 186 054	-
Retrofit kit BRB 4 NC/14 "Dimension"	Kit 1 to Kit 5	790 186 055	-
Retrofit kit BRB 4 NC/15 "Dimension"	Kit 3 to Kit 2	790 186 056	-

## Retrofit kits BRB NC "Pneumatic to Auto"

**Retrofitting to pneumatic clamping, ideal for continuous production e.g. boiler and heat exchanger applications. Only for pneumatic machine versions.** Easy and fast to mount.

The retrofit kit comes with: clamping cylinder complete, spindle complete and feed handle. BRB retrofit kits for machines with clamping system "Standard" see page 53.

Article	Kit	Code	kg
Retrofit kit BRB 2 NC/03 "Pneumatic to Auto"	Kit 2	790 185 082	-
Retrofit kit BRB 4 NC/10 "Pneumatic to Auto"	Kit 1	790 186 081	-
Retrofit kit BRB 4 NC/11 "Pneumatic to Auto"	Kit 2	790 186 082	-
Retrofit kit BRB 4 NC/12 "Pneumatic to Auto"	Kit 3	790 186 083	-
Retrofit kit BRB 4 NC/13 "Pneumatic to Auto"	Kit 4	790 186 084	-
Retrofit kit BRB 4 NC/14 "Pneumatic to Auto"	Kit 5	790 186 085	-

## Brush attachments

For BRB 4 machines. These new brush attachments made from brass prevent swarf and any other foreign materials entering the pipe, especially when using the machine vertically. The brushes can be mounted quickly and easily to the threaded spindle of the new BRB 4 models. The new threaded spindle can be retrofitted to machines manufactured up to October 2009. The brushes are applicable for both clamping systems (Standard/NC).

1 packaging unit = 5 brushes. Price per packaging unit. Weight per brush attachment.

Further dimensions on request.



Brush attachment

Article	Brush adapter			Pipe ID min.-max.		Code		kg
	10	25	33	[mm]	[inch]			
Brush M8/25*	-	-	-	19.1 - 24.3	0.752 - 0.957	790 086 520		-
Brush M8/28*	-	-	-	22.1 - 27.3	0.870 - 1.075	790 086 521		-
Brush M8/31*	-	-	-	25.5 - 30.8	1.004 - 1.213	790 086 522		-
Brush M8/34*	-	-	-	28.5 - 33.8	1.122 - 1.331	790 086 523		-
Brush adapter 10	x	-	-	-	-	790 086 497		-
Brush 10/43	x	-	-	32.0 - 42.1	1.260 - 1.657	790 086 524		-
Brush 10/53	x	-	-	40.9 - 52.0	1.610 - 2.047	790 086 525		-
Brush adapter 25	-	x	-	-	-	790 086 498		-
Brush 25/62,5	-	x	-	50.7 - 61.7	1.996 - 2.429	790 086 526		-
Brush 25/71	-	x	-	59.4 - 70.4	2.339 - 2.772	790 086 527		-
Brush 25/81	-	x	-	69.2 - 80.2	2.724 - 3.157	790 086 528		-
Brush adapter 33	-	-	x	-	-	790 086 499		-
Brush 33/91	-	-	x	79.6 - 90.5	3.134 - 3.563	790 086 529		-
Brush 33/101	-	-	x	89.4 - 100.4	3.520 - 3.953	790 086 530		-
Brush 33/112	-	-	x	99.6 - 110.8	3.921 - 4.362	790 086 531		-

\* Comes with the suitable adapter.

\*\* When ordering, please indicate the inside diameter of the pipe to be worked on. The brush comes with a suitable adapter.

## Initial equipment kit of brushes for BRB 4

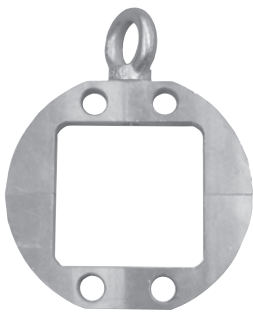
Including all above listed adapters and brushes (1 brush of each dimension).

Article	Brush adapter			Pipe ID min.-max.		Code		kg
	10	25	33	[mm]	[inch]			
Initial equipment kit of brushes for BRB 4	x	x	x	19.1 - 110.8	0.752 - 4.362	790 086 535		-

Machines manufactured up to October 2009 can be used with brushes by upgrading with one of the following threaded spindles:

Article	Code	kg
Threaded spindle for mandrel 19.05 / BRB 4	790 086 190	0.136
Threaded spindle for mandrel 31.50 / BRB 4	790 086 160	0.100





Hoist bracket

## Hoist bracket

**Designed for use with a hoist.**

BRB machines which have been manufactured up to October 2009 can be retrofitted with this hoist bracket; all new models are already equipped with the hoist bracket.

Article	Code	kg
Hoist bracket for BRB 4	790 086 310	0.270
Hoist bracket for BRB 2	790 085 310	0.185



Bevel cutter head for BRB 2

## Bevel cutter head for BRB 2 (V-/Y-prep)

**Optimized work, smoother and steadier cutting. Including adjustable tool holder.**

The bevel cutter heads can be replaced like a tool mounting plate. They are available for several prep angles. The bevel cutter heads can be adapted to all machines (even older models).

**Comes with:**

- 3 multifunctional tools (MFW-12-V/I-2, Code 790 086 060)
- 1 multifunctional tool (MFW5-U/I-2, Code 790 085 030)
- 4 Torx screws
- 3 fastening screws M5x16

Article	Application range				Code	kg
	Kit 1 (ID min. – OD max.)		Kit 2 (ID min. – OD max.)			
	[mm]	[inch]	[mm]	[inch]		
Bevel cutter head 30°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 380	–
Bevel cutter head 37.5°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 381	–
Bevel cutter head 45°	14.5 - 48.0	0.570 - 1.890	–	–	790 085 382	–
Bevel cutter head 30°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 383	–
Bevel cutter head 37.5°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 384	–
Bevel cutter head 45°	–	–	18.0 - 44.0	0.708 - 1.732	790 085 385	–



Bevel cutter head for BRB 4

## Bevel cutter head for BRB 4 (V-prep)

**The bevel cutter heads with 3 cutting edges provide considerable advantages for heavy chip removal, e.g. for welded material.** The bevel cutter heads can be replaced like a tool mounting plate. They are available for various prep angles and can be adapted to all machines (even older models).

**Comes with:**

- 3 multifunctional tools: MFW-12-V/I-2, Code 790 086 060  
MFW-P-2, Code 790 038 314 on request
- 3 Torx screws
- 3 fastening screws M6x16

Article	Application range	Pipe wall thickness max.		Code	kg
		[mm]	[inch]		
Bevel cutter head 30°	ID 36 mm to OD 78 mm (1.417 - 3.071 inch) in 3 steps of 5 mm (0.197 inch) distance	10	0.394	790 086 500	0.465
Bevel cutter head 45°	ID 45 mm to OD 73 mm (1.772 - 2.874 inch) in 2 steps of 5 mm (0.197 inch) distance	10	0.394	790 086 459	0.515

## Adjustable spacer

**For BRB machines.** The adjustable spacer ensures a constant and repeatable depth machining of boiler pipes, etc.

Article	Code		kg
Adjustable spacer for BRB 4	790 086 045		1.285
Adjustable spacer for BRB 2	790 085 055		-



*Adjustable spacer*