



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 ³ /min	0.7 m ³ /min	–	1.0 m ³ /min	1.0 m ³ /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 ²	2.5 m/s ²	2.5 m/s ²	2.5 m/s ²	2.5 m/s ²	2.5 m/s ²

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 (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
min. - max.	[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	68.0	2.677
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	68.0	2.677
04	BRB 4	Pneu/EL	790 086 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	32.0 - 110.8	1.260 - 4.362	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 - 110.8	0.752 - 4.362	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	790 185 083		-
Retrofit kit BRB 4/01 "Standard to NC"	19.1 - 38.0	0.752 - 1.490	790 186 071		-
Retrofit kit BRB 4/02 "Standard to NC"	35.0 - 64.0	1.378 - 2.520	790 186 072		-
Retrofit kit BRB 4/03 "Standard to NC"	35.0 - 108.0	1.378 - 4.252	790 186 073		-
Retrofit kit BRB 4/04 "Standard to NC"	19.1 - 64.0	0.752 - 2.520	790 186 074		-
Retrofit kit BRB 4/05 "Standard to NC"	19.1 - 108.0	0.752 - 4.252	790 186 075		-

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.

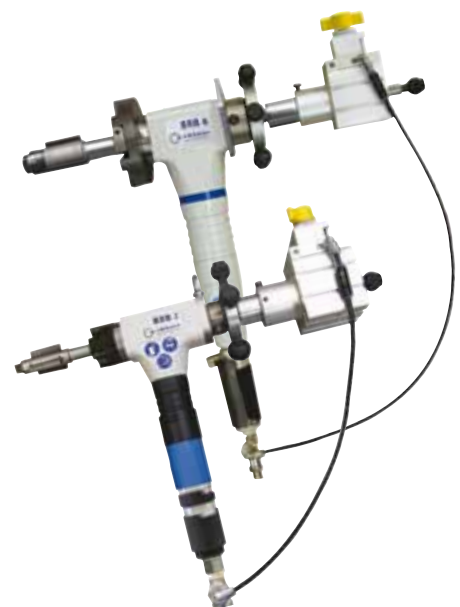
A detailed description of the machine, technical specifications and scope of delivery see on page 51. Please specify the required clamping system (“Standard” or “NC”), the application kit (Kit 1 to Kit 5) as well as the drive version (Electric, Pneumatic or Pneumatic/Auto) with your purchase order.



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 / 19.0	
	[inch]	1.969 - 0.630	2.677 / 0.748	2.677 / 1.063	4.724 / 1.063	2.677 / 0.748	2.677 / 0.748	
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	19.05
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	
	[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	68.0	2.677
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	68.0	2.677
13	790 186 054	Kit 2 to Kit 3 / Kit 4 to Kit 5	-	-	120.0	4.724	35.0 - 108.0	1.378 - 4.252	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 - 108.0	0.752 - 4.252	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.

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.



Brush attachment

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 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

Accessories for BRB- and REB machines

Description of the tools made by Orbitalum Tools:

Multifunctional tool MFW for working on the pipe OD:

MFW 30-V / I-4-R5

Prep radius in mm	R5
Number of cutting edges	4
Weld prep profiles	V and I
max. workable wall thickness	30 mm

Multifunctional tool MFW for working on the pipe ID:

MFW 10-ID-2-R0,8

Prep radius in mm	R0.8
Number of cutting edges	2
for working on the inner diameter	ID
max. length on the counterbore / bevel	10 mm

Tool holder WH for beveling:

WH 30-V-30°

Prep angle	30°
Weld prep profile	V
max. workable wall thickness	30 mm

Tool holder WH for facing:

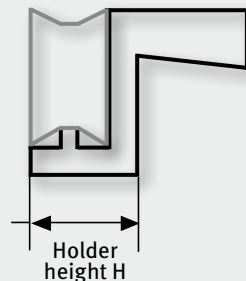
WH 30-I-H27

Holder height in mm	H27
Weld prep profile	I
max. workable wall thickness	30 mm

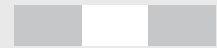
Tool holder WH for counterboring ID:

WH 10-ID-14°

Counterbore angle	14°
for working on the inner diameter	ID
max. length on the counterbore / bevel	10 mm



The different weld prep profiles:



Facing
I-prep



Plain beveling
V-prep



Beveling, facing
Y-prep



J-prepping
U-prep



Counterboring
ID-prep

Tool holder WH

With Torx screw. Combination possibilities of tool holder and multifunctional tools, see page 69.

Article	Weld prep profile	Applicable with	Height [mm]	Height [inch]	Code	kg
WH5-I	I	BRB 2 / REB	10	0.394	790 085 230	0.005
WH4-I*	I	BRB 2	10	0.394	790 085 234	0.033
WH12-I	I	BRB 4	20	0.787	790 086 210	0.035
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
WH5-V-30°	V/Y	BRB 2	-	-	790 085 236	0.015
WH12-V-30°	V/Y	BRB 4	-	-	790 086 214	0.040
WH12-V-37,5°	V/Y	BRB 4	-	-	790 086 216	0.115
WH12-V-45°	V/Y	BRB 4	-	-	790 086 474	0.054
WH12-V-80°	V/Y	BRB 4 / REB	-	-	790 093 462	0.048
WH12-V-35°	V/Y	BRB 4	-	-	790 086 272	0.100
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
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-25°	V/Y	REB	-	-	790 093 476	0.206
WH30-V-30°	V/Y	REB	-	-	790 093 210	0.192
WH30-V-32,5°	V/Y	REB	-	-	790 093 424	0.234
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
WH5-U-20°	U	BRB 2	-	-	790 085 228	0.014
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-5°	U	REB	-	-	790 093 509	0.210
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	0.174
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° / 10 mm (0.394") deep	ID	BRB 2	-	-	790 085 232	0.017
WH5-ID-14°	ID	BRB 4 / REB	-	-	790 093 406	0.139
WH5-ID-45°	ID	BRB 4	-	-	790 086 218	0.160
WH10-ID-5° / short	ID	BRB 4 / REB	-	-	790 093 398	0.135
WH10-ID-5° / long	ID	BRB 4 / REB	-	-	790 093 400	0.152
WH10-ID-14°	ID	BRB 4 / REB	-	-	790 093 402	0.170
WH10-ID-14° / 30 mm (1.181") deep	ID	BRB 4 / REB	-	-	790 093 466	0.155
WH12-ID-10° / from ID 50 (1.969")	ID	BRB 4 / REB	-	-	790 086 280	0.060
WH10-ID-30°	ID	BRB 4 / REB	-	-	790 093 493	0.042
WH10-ID-45°	ID	REB	-	-	790 093 494	0.107
WH10-ID-80°***	ID	BRB 2 / BRB 4	-	-	790 086 275	0.075
WH5-ID-45°***	ID	BRB 2 / BRB 4 / REB	-	-	790 086 218	0.155



WH12-I



WH15-I**



WH15-V-30°



WH12-U-15°



WH5-ID-14°

* Special tool holder for facing pipes in pipe plates.

** Adjustable tool holder WH for I-prep. Comes with adjustable tool holder, multifunctional tool MFW15-V/I-4 (Code 790 093 037), Torx screws and adjusting plates.

*** Special tool holder WH for cutting tubes from tube sheets.

Multifunctional tool MFW "Economy"

Two- or four-sided tool bits without coating.

For low-alloy steel, carbon steel, aluminum and cast iron pipes.

Article	Version	For wall thickness		Applicable with tool holder / for weld prep profile	Applicable with	Code		kg
		[mm]	[inch]					
MFW15-V/I-4	Economy	2 - 15	0.079 - 0.591	V, Y, I	BRB 4 / REB	790 093 047		0.033
MFW30-V/I-4	Economy	2 - 30	0.079 - 1.181	V, Y, I	REB	790 093 043		0.055

Multifunctional tool MFW "High-Performance"

Two- and/or four-sided tool bits with high-performance protective coating against tool wear.

For high-alloy steel (stainless steel) low-alloy steel, carbon steel, aluminum and cast iron pipes.

Article	Version	For wall thickness		Applicable with tool holder / for weld prep profile	Applicable with	Code		kg
		[mm]	[inch]					
MFW5-V / I-2	High-Performance	max. 6	max. 0.236	WH5-I and WH5-U-20°	BRB 2	790 085 030		0.155
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	I-, V-, Y-, U radius 5 mm	REB	790 093 034		0.055
MFW30-U-4-R2	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 2 mm	REB	790 093 035		0.060
MFW30-U-4-R1	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 1 mm	REB	790 093 036		0.060
MFW30-U-4-R0.4	High-Performance	2 - 30	0.079 - 1.181	I-, V-, Y-, U radius 0,4 mm	REB	790 093 042		0.060
MFW4-I-2	High-Performance	max. 4	max. 0.157	WH4-I-2 (special holder)	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 radius 1.2	BRB 4	790 086 060		0.025
MFW12-U-2-R2	High-Performance	2 - 12	0.079 - 0.472	V, Y, I, U radius 2.0	BRB 4	790 086 064		0.025
MFW5-ID-2-R0.4 (14°)	High-Performance	-	-	WH5-ID-14° radius 0.4	BRB 4 / REB	790 093 039		0.003
MFW5-ID-2-R0.4 (45°)	High-Performance	-	-	WH5-ID-45° radius 0.4	BRB 4 / REB	790 086 061		0.002
MFW10-ID-2-R0.4 (80°)	High-Performance	-	-	WH10-ID-80° radius 0.4	BRB 4	790 086 062		0.002
MFW10-ID-2-R0.8 (14°)	High-Performance	-	-	WH10-ID-14° radius 0.8 mm	REB	790 093 038		0.002
MFW10-ID-2-R3.0 (14°)	High-Performance	-	-	WH10-ID-14° radius 3.0 mm	REB	790 093 041		0.004



MFW15-V/I-4 "Economy"



MFW30-U-4-R1



MFW15-V/I-4



MFW5-ID-2-R0.4 (14°)



Mobile air unit DWE 10



Air hose with quick coupling



Cutting lubrication KSS-TOP



Elbow clamping system

Mobile air unit DWE 10

Lubricator and air filter adjustable pressure range 0 - 10 bar.

Flow max. 2.6 m³/min (91.8 cfm). Air inlet side: 1/2" clutch coupling (DIN 3481).

Air outlet side: 1/2" quick coupling. Suitable for air hose 790 093 061.

Article	Code	kg
Mobile air unit DWE 10	790 093 060	4.200

Air hose with quick coupling

To connect the REB or BRB machine with the mobile air unit DWE 10.

Length: 4 m (157.5 inch). ID: 19.1 mm (0.752 inch). Air inlet side: 1/2" quick coupling.

Air outlet side: 90° angle screw with 1/2" quick coupling and a nipple to screw into the speed regulation handle on REB or BRB.

Article	Code	kg
Air hose with quick coupling	790 093 061	2.000

Cutting lubrication KSS-TOP

The water soluble, fully synthetic cooling fluid extends the tool life of the tool bits.

Contains no hazardous substances (no labeling requirements according to GefStoffV1) and is well corrosion resistant. Developed conforming to drinking water requirements according to DVGW work sheet W521 (thread cutting compounds for drinking water installations) and basically complies with these specifications. Is biologically degradable (OECD 302 B).

Article	Version	Code	kg
Cutting lubrication KSS-TOP	Pump sprayer with 500 ml	790 060 226	0.630
Cutting lubrication KSS-TOP refill canister	Canister with 10 l	790 060 227	11.000

Elbow clamping system

For preparing elbows with the REB 6 with an ID of 75 - 157 mm (2.95 - 6.18 inch).

Comes with:

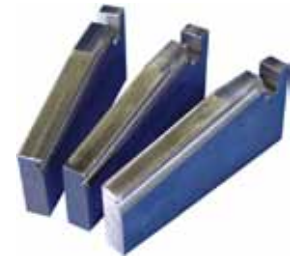
- 1 Durable storage and shipping case
- 1 Mandrel with clamping mechanism for elbows
- 1 Straightening tool
- 8 Sets with 3 pins for dimension range 75 - 157 mm (2.95 - 6.18 inch).

Article	Code	kg
Elbow clamping system for REB 6 complete	790 093 015	9.900

Optional clamping wedges

To extend the dimension of the REB standard machines.

Article	Applicable with	Pipe ID [mm]	Pipe ID [inch]	Code	kg
Clamping wedges	REB 6	155 - 166	6.102 - 6.535	790 093 295	1.300
Clamping wedges	REB 14	320 - 339	12.598 - 13.346	790 094 189	3.600
Clamping wedges	REB 14	331 - 350	13.031 - 13.780	790 094 190	3.850



Clamping wedges optional

Plastic (POM) clamping shell segments

Customized plastic (POM) clamping shell segments for REB 6, REB 14 and REB 20 for thin-walled pipes. Deformation-free clamping system.

These clamping shell segments are especially manufactured for an individual ID of a pipe and can be utilized only for this diameter. Please specify the exact pipe ID with your order.

Comes with:

- 6 Cylinder head screws
- 3 Clamping shells
- 3 Plastic (POM) clamping shell segments

Other dimensions on request.

Article	Applicable with	Pipe ID [mm]	Pipe ID [inch]	Code	kg
Plastic clamping shell segment	REB 6	108.2 - 110.1	4.260 - 4.335	790 093 297	1.600
Plastic clamping shell segment	REB 6	147.0 - 149.0	5.787 - 5.866	790 093 298	1.905
Plastic clamping shell segment	REB 14	160.0	6.299	790 094 203	3.700
Plastic clamping shell segment	REB 14	161.5 - 162.7	6.358 - 6.406	790 094 202	3.800
Plastic clamping shell segment	REB 14	211.6 - 213.5	8.331 - 8.401	790 094 206	5.600
Plastic clamping shell segment	REB 14	227.58	8.960	790 094 198	5.880
Plastic clamping shell segment	REB 14	250.0	9.843	790 094 208	5.600
Plastic clamping shell segment	REB 14	264.7 - 266.2	10.421 - 10.480	790 094 210	5.600
Plastic clamping shell segment	REB 14	314.7 - 315.9	12.390 - 12.437	790 094 222	4.100
Plastic clamping shell segment	REB 14	342.9	13.500	790 094 226	4.800
Plastic clamping shell segment	REB 14	347.7	13.689	790 094 224	4.750



Plastic (POM) clamping shell segments



ID-Tracking

ID tracking for REB 14 and REB 20

The REB ID tracking can be used to prepare thin-walled, large-scale pipes for welding, where precise pipe end preparation and an exact base height are required.

The module measures the pipe ID. The force of the spring on the inside diameter ensures that the roller “tracks” any irregularities of the pipe, producing a weld prep exactly in accordance with the ID. Thus maintaining a perfect weld prep. All weld preparations such as V-, Y- and U-preps can be realized with the ID tracking module.

Comes with:

- ID tracking module
- Mount for plane
- Assembly instructions

Application range	ID Tracking for REB 14		ID Tracking for REB 20	
	[mm]	[inch]	[mm]	[inch]
Pipe ID	150 - 320	5.910 - 12.600	290 - 500	11.417 - 19.685
Wall thickness max.	15	0.591	10	0.394

Article	Code	kg
ID-Tracking for REB 14, REB 20	790 094 013	5.750