

BRB 2 BRB 4

Pneumatic, Pneumatic/Auto, Electric

Boiler Pipe Preparation Machines

Lightweight and robust boiler pipe preparation machines. Prepare I/V/Y and U seam weld joint geometries in pipe ends made from high-alloy steel (stainless steel), low-alloy and carbon steel with the unique QTC® tool system. Pipe end and tube sheet joint preparations in boiler, tank and apparatus construction.

New and Improved drive systems

- Double-quick machining using the BRB Auto with pneumatic clamping: ideal for series processing, e.g. heat exchanger applications.
- Option to retrofit older BRB machines with BRB Pneumatic/Auto or the new "NC" clamping system.
- Both the gears and the speed range of the electric motors have been optimized with regard to the greater beveling requirements. The BRB 2 is now available with electric motors.

New, Variable Clamping Systems

- The "NC" clamping system, with its clamping wedges firmly anchored in the mandrel, is ideal for applications where no foreign bodies must enter the inside of the pipe or container. The "NC" clamping system provides extra safety, particularly for vertical applications.
- The "Standard" clamping system has been optimized in terms of stability and reliability. You can still use this system.

New, Innovative accessories

- Holder for balancer
- Brush attachments prevent chips falling into the pipe
- Bevel heads for different bevel angles

Additional Benefits

- Precise and reproducible weld prep profiles
- Handy and compact design
- Maximum performance and lightweight
- Tool bits with up to 4 cutting edges and high-performance coating
- Up to 3 tools can be used at the same time
- Quick clamping system for tools with easy adjustment
- Adjustable air outlet
- Easy to change tools
- Tools adaptable on all BRB machines
- Low noise level



BRB 2 & BRB 4
Pneumatic



BRB 2 & BRB 4
Pneumatic/Auto



BRB 2 & BRB 4
Electric



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.



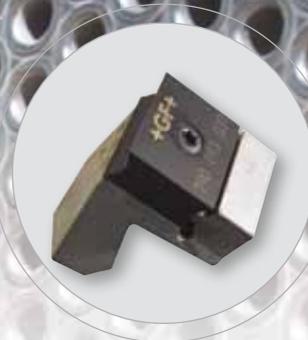
Precise and reproducible pipe end and tube sheet joint preparations.



Optimum performance with the lowest weight.



The **brass brush attachments** prevent chips and other foreign bodies from inadvertently falling into the pipe.



A large selection of **tool holders** and **multifunctional tools** with two or four cutting edges for different wall thicknesses and joint geometries.



The clamping wedges of the BRB "NC" machines are neatly arranged in a handy plastic case.



The **bevel heads** with three cutting edges provide considerable advantages for heavy-duty chip removal, e.g. on welded material. Available for different bevel angles.

BRB 2 and BRB 4 Boiler Pipe Preparation Machines

The solution when space is limited! Only very limited space is available between welded boiler pipes; the compact body design of BRB machines is optimized for the application in question to provide the operator with the best possible access in every position. Existing and older BRB machines can be **retrospectively converted to another clamping system, drive system or a different dimension range ("Kit")** (an overview of the different retrofit kits can be found in our current product catalog).

	BRB 2				BRB 4										
	Kit 1		Kit 2		Kit 1		Kit 2		Kit 3		Kit 4		Kit 5		
Order No. (790...)	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	
Electric Version (230 V, 50/60 Hz)	085 011	-	085 012	185 012	086 011	186 011	086 012	186 012	086 013	186 013	086 014	186 014	086 015	186 015	
Electric Version (120 V, 50/60 Hz)	085 021	-	085 022	185 022	086 021	186 021	086 022	186 022	086 023	186 023	086 024	186 024	086 025	186 025	
Pneumatic Version	085 007	-	085 008	185 002	086 001	186 001	086 002	186 002	086 003	186 003	086 004	186 004	086 005	186 005	
Pneumatic/Auto Version	085 041	-	085 042	185 042	086 031	186 031	086 032	186 032	086 033	186 033	086 034	186 034	086 035	186 035	
Application range	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	
Pipe ID / clamping range Ø	[mm]	12.75-25.5	-	19.1-46.0	19.1-38.0	19.1-33.8	19.1-38.0	32.0-61.7	35.0-64.0	32.0-110.8	35.0-108.0	19.1-61.7	19.1-64.0	19.1-110.8	19.1-108.0
	[inch]	0.50-1.00	-	0.75-1.81	0.75-1.49	0.75-1.33	0.75-1.49	1.26-2.43	1.38-2.52	1.26-4.37	1.38-4.25	0.75-2.43	0.75-2.52	0.75-4.36	0.75-4.25
Tool mounting plate Ø	[mm]	50.0/12.75	-	50.0/16.0	50.0/16.0	68.0/19.0	68.0/19.0	68.0/27.0	68.0/27.0	120.0/27.0	120.0/27.0	68.0/19.0	68.0/19.0	68.0/19.0	68.0/19.0
	[inch]	1.97/0.50	-	1.97/0.63	1.97-0.63	2.68/0.75	2.68/0.75	2.68/1.06	2.68/1.06	4.72/1.06	4.72/1.06	2.68/0.75	2.68/0.748	2.68/0.75	2.68/0.75
												2.68/1.06	2.68/1.063	2.68/1.06	2.68/1.06
Clamping sets	[pieces]	6	-	8	6	4	6	3	7	6	18 (8+10)	7	13	10	24 (14+10)
Mandrel Ø	[mm]	12.75	-	19.05	19.05	19.05	19.05	31.5	34.5	31.5	34.5	19.05	19.05	19.05	19.05
	[inch]	0.502	-	0.750	0.750	0.750	0.750	1.240	1.358	1.240	1.358	0.750	0.750	0.750	0.750
												1.240	1.358	1.240	1.358
Pipe OD	[mm]	16.75-41.5	-	23.0-62.0	23.0-62.0	64.0	64.0	73.0	73.0	114.3	114.3	73.0	73.0	114.3	114.3
	[inch]	0.66-1.63	-	0.91-2.44	0.91-2.44	2.51	2.51	2.87	2.87	4.50	4.50	2.87	2.87	4.50	4.50
Wall thickness min. - max.	[mm]	2-8	-	2-8	2-8	2-15	2-15	2-15	2-15	2-15	2-15	2-15	2-15	2-15	2-15
	[inch]	0.08-0.32	-	0.08-0.32	0.08-0.32	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59	0.08-0.59

BRB machine comes with:

One BRB 2 or BRB 4 boiler pipe preparation machine • One durable storage and transportation case • Tool mounting plates, clamping sets and mandrel, depending on the machine kit and clamping system • One KSS-TOP cooling/cutting lubrication spray pump (Code 790 060 226) • One tool key set • One set of operating instructions and spare parts list

	BRB 2				BRB 4									
	Pneumatic		Pneumatic/Auto		Electric		Pneumatic		Pneumatic/Auto		Electric			
Technical data	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC	Standard	NC
Dimensions, approx.	[mm]	400x350x50	400x360x50	400x480x120	400x505x120	380x350x50	380x360x50	533x120x454	531x120x454	529x120x610	642x120x610	471x120x380	471x120x378	
	[inch]	15.7x13.8x1.2	15.7x14.2x1.2	15.7x18.9x4.7	15.7x19.9x4.7	15x13.8x1.2	15x14.2x1.2	21.0x4.7x17.9	531x120x454	20.8x4.7x24.0	25.3x4.7x24.0	18.5x4.8x15.0	20.9x4.8x14.9	
Machine weight, approx.	[kg/lbs]	5.6 / 12.3		5.6 / 12.3		4.7 / 10.4		9.3 / 20.5		13.3 / 29.3		11.4 / 25.1		
Power	[kW/hp]	0.38 / 0.51		0.38 / 0.51		0.5 / 0.67		1.0 / 1.34		1.0 / 1.34		1.0 / 1.34		
Air consumption (6 bar)	[m³/min]	0.7		0.7		-		0.7		0.7		-		
Power supply*	[V, Hz]	-		-		230 V/120 V (50/60 Hz)		-		-		230 V/120 V (50/60 Hz)		
Speed (max. idling speed)	[rpm]	120		120		118		0 - 110		0 - 110		17 - 35		
Sound pressure level LAeq 1 m (EN 23741), approx.**	[dB (A)]	82		82		76		84		84		82		
Vibration level (EN 28662, Part 1)	[m/s²]	2.5		2.5		2.5		2.5		2.5		2.5		

* Single-phase alternating current, electronic cutting speed control
** Mid-range speed

The technical data is non-binding. It does not include any assurance of properties. Subject to change. Our general terms and conditions apply.