

# PROMOTECH<sup>®</sup>

**PLATE BEVELLERS**



**PLATE BEVELLERS**



**PIPE BEVELLERS**



**PIPE BEVELLERS**



*smart tools  
for heavy tasks*

**PLATE AND PIPE  
BEVELLERS**

## PROMOTECH – PROFESSIONAL MANUFACTURER OF PREMIUM MACHINES FOR METALWORKING INDUSTRY

Promotech is an innovation driven ISO 9001:2000 manufacturer of professional power tools, welding automation equipment and industrial systems tailored for structural steel fabricators, heavy machinery manufacturers, shipyards and other metal machining companies.

### Main product lines:

- mag drills, pneumatic drills, rail drills and hydraulic punchers
- weld preparation/portable and stationary bevellers for plates and pipes
- welding and cutting tractors
- welding and cutting automation equipment

### Our products:

- offer solutions to reduce cost and increase productivity
- are designed and engineered for long term use in tough industrial conditions
- meet the requirements of the most demanding clients and markets worldwide
- are made in Poland according to the highest quality standards
- include top quality components
- are thoroughly tested for quality approval
- proved to be extremely reliable with a variety of practical applications in most difficult climatic environments



Mitglied im DVS – Deutscher Verband für  
Schweißen und verwandte Verfahren e. V.



**American Welding Society**  
Supporting Company Member







**BEVELING**

pages  
**1-32**

[www.promotech.eu](http://www.promotech.eu)



## PLATE BEVELLERS



**ABM-14**



**ABM-28**



**ABM-50**



**BM-16**



**BM-18A**



**BM-20 PLUS**



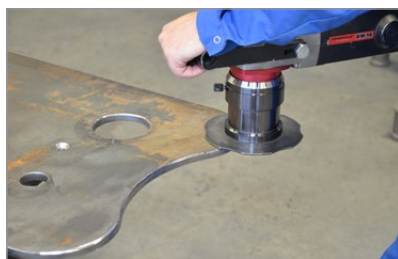
**BM-21**



**BM-21S**



**SBM-500**





# PIPE BEVELLERS



PRO-2 PB



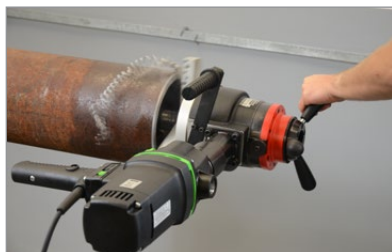
PRO-5 PB



PRO-10 PB



PRO-40 PBS





# BM-16 | BEVELLING MACHINE

Portable, handy beveling machine is designed for milling edges of plates and pipes made of steel, aluminum alloys, brass, or plastic.

Depending on the chosen milling head the machine enables beveling materials with minimum thickness of 1.5 mm (0.06") at the angles of 22.5°, 30°, 37.5°, 45°, 55° or 60° and with maximum bevel width of 16 mm (0.63").

Each milling head uses 5 indexable cutting inserts.

One milling head for beveling radiuses enables beveling edges with radius of 2, 3, 4 or 5mm with use of 4-sided indexable R2, R3, R4 or R5 cutting inserts.

Countersinking of holes with minimum 40 mm (1.57") diameter is also possible.

BM-16 is equipped with continuous bevel width adjustment, overload protection and electronic speed control for use on a variety of materials.

It is highly efficient machine for edge weld preparation and rounding off steel construction before painting or coating.



## Basic set:

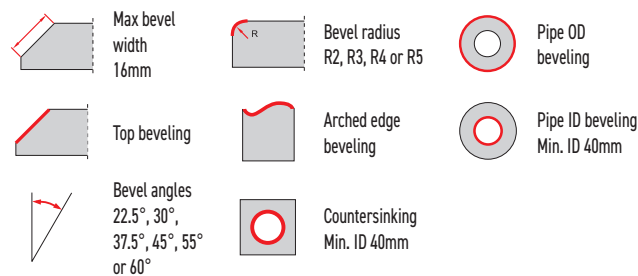
- BM-16 beveling machine without accessories (see list below)
- Metal box
- 32mm flat wrench
- Allen wrench hex s=5
- Allen wrench hex s=14
- Operator's Manual

## Accessories:

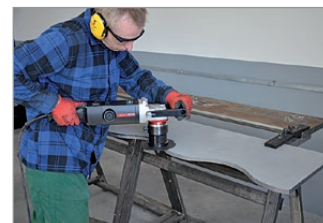
- GLW-000011 - Milling head for rounding
- PLY-000360 - Cutting insert R2 (4pcs required)
- PLY-000159 - Cutting insert R3 (4pcs required)
- PLY-000160 - Cutting insert R4 (4pcs required)
- PLY-000161 - Cutting insert R5 (4pcs required)
- PLY-000391 - Cutting insert for steel (4pcs required- bevel up to 7 mm)
- PLY-000423 - Cutting insert for aluminium (4pcs required- bevel up to 7 mm)
- GLW-000010 - Milling head 22,5°
- GLW-000005 - Milling head 30°
- GLW-000009 - Milling head 37,5°
- GLW-000006 - Milling head 45°
- GLW-000008 - Milling head 55°
- GLW-000007 - Milling head 60°
- PLY-000395 - Cutting insert for steel (5pcs required)
- PLY-000195 - Cutting insert for aluminum (5pcs required)

## Spare and consumable parts:

- SRB-000289 - Insert Screw (Radius)
- SRB-000290 - Insert Screw
- RLK-0509-04-00-00-0 - Guiding roller
- SMR-000005 - Screw grease (5 g)
- SCZ-000030 - Motor brush for 230 V
- SCZ-000031 - Motor brush for 115 V
- NKL-0509-05-00-00-0 - Sticker against scratches (dedicated for aluminum beveling)



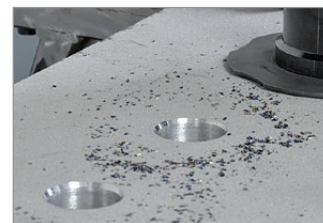
Steel plate beveling



Curved edge beveling



Arched edge beveling with radius



Countersinking



Pipe beveling



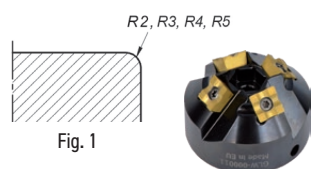
Aluminum beveling

## BM-16 TECHNICAL SPECIFICATION

Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Motor	2200W
Spindle speed (without load)	1800-5850 rpm
Maximum bevel width	b=16 mm (0.63") Fig. 2
Bevel angle (depending on milling head)	$\beta = 22.5^\circ, 30^\circ, 37.5^\circ, 45^\circ, 55^\circ, 60^\circ$ Fig.2
Minimal diameter of countersinking	ca 40 mm (1.57")
Rounding edges	R2, R3, R4, R5 (Fig. 1)
Dimensions (L x W x H)	585 mm (23.0") x 156 mm (6.1") x 238 mm (9.4")
Weight (without milling head)	10 kg (22 lbs)
Product code (220-240 V)	UKS-0509-10-20-00-0
Product code (110-120 V)	UKS-0509-10-10-00-0



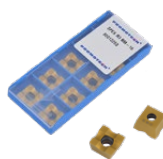
**Optional accessories:**



Milling head for rounding  
GLW-000011



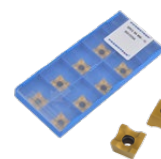
Cutting insert R2



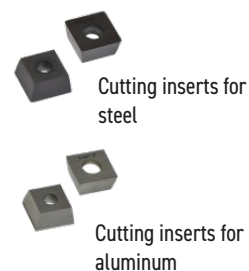
Cutting insert R3



Cutting insert R4

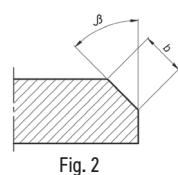


Cutting insert R5



Cutting inserts for  
steel

Cutting inserts for  
aluminium



Milling head 22.5°



Milling head 30°



Milling head 37.5°



Cutting insert for steel



Milling head 45°



Milling head 55°



Milling head 60°



Cutting insert for aluminium



Insert Screw  
(Radius)



Guiding roller

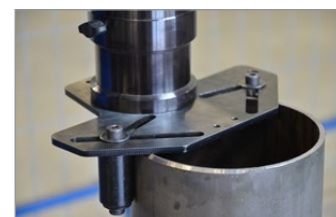


Insert Screw

**Pipe attachment for BM-16**



Product code:  
PRW-0509-07-00-00-0

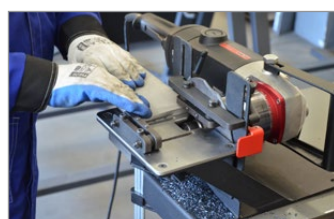


Allows external beveling of pipes with a diameter of at least 150 mm (5.9") and internal beveling of pipes with a diameter of at least 110 mm (4.3").

**Worktable fixture for BM-16**



Product Code:  
ZBD-0509-12-00-00-0



Handy and convenient tool for machining small workpieces with cross section of at least 15×25 mm (0.6×1") and length of at least 400 mm (16").

The width of the workpiece can be up to 100 mm (4"), and height up to 65 mm (2.5"). The maximum bevel width is 14 mm (0.55").

**Radius insert positioner for BM-16 and BM-7**



Product code:  
UST-0509-16-00-00-0



Useful device for easy and precise setting of radius R2, R3, R4 and R5.



# BM-18A | PNEUMATIC PLATE BEVELLER

The BM-18A is a new Promotech's plate beveller with a powerful pneumatic motor. It enables machining up to 18 mm bevel.

New hexagonal fixing of milling head increases beveller durability and makes replacement of the head more convenient and user-friendly.

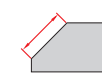
## Features & benefits

- Powerful pneumatic motor
- Maximum 18 mm bevel width  
(more than one pass could be required)
- New more durable milling heads with hexagonal fixing
- Easy replacement of milling head
- 2-sided indexable cutting inserts for beveling remain the same as for BM-16
- Rounding edges R2, R3, R4 or R5
- 4-sided indexable cutting inserts for rounding remain the same as for BM-7 and BM-16



## BM-18A TECHNICAL SPECIFICATION

Spindle speed (without load)	6.000 rpm
Maximum bevel width	b=18 mm (Fig.1)
Bevel angle (depending on milling head in use)	$\beta = 22.5^\circ, 30^\circ, 37.5^\circ, 45^\circ, 50^\circ, 55^\circ, 60^\circ$ (Fig. 1)
Minimal diameter of countersinking	ca 40 mm (1.57")
Rounding edges (option)	R2, R3, R4, R5 (Fig. 2)
Minimal plate thickness	2 mm
Air requirement	6 bar (0,6MPa) (87 PSI)
Air consumption	1800 L/min, (64 CFM)
Pneumatic drive	2.800 W
Minimum required diameter of supply hose	19 mm (3/4")
Weight (without milling head)	9,3 kg
Product Code	UKS-0640-10-00-00-0



Max. bevel width  
18 mm



Top beveling



Bevel angles  
22.5°, 30°, 37.5°, 45°,  
50°, 55°, 60°



Countersinking  
Min. ID 40 mm



Min. plate thickness  
2 mm



Rounding edges  
R2, R3, R4 or R5



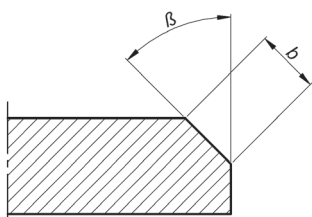


Fig. 1

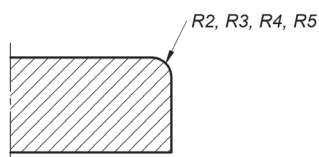
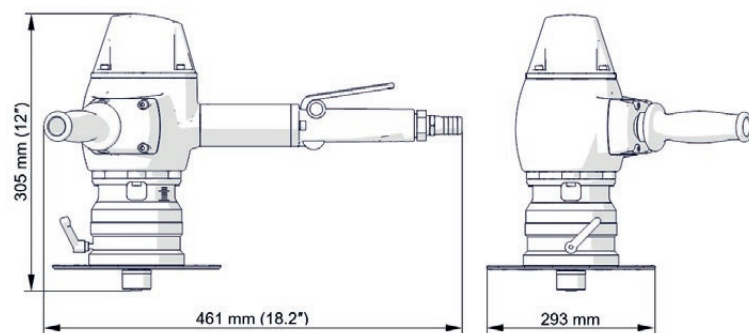


Fig. 2



### New design of milling heads with hexagonal fixing

- increases durability
- more convenient assembly and disassembly of the milling head
- guiding roller is integrated with each milling head
- the clearance between milling head and guiding roller is precisely factory calibrated, thus requires no adjustment by the operator



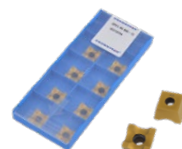
GLW-0640-30-02-00-0

PLY-000395

PLY-000195



UST-0509-16-00-00-0



PLY-000161

### Basic set:

- BM-18A beveling machine without accessories (see list below)
- Handle
- Plastic box
- Lock pin
- 32mm flat wrench
- Allen wrench hex s=6
- Grease for mounting screws (5 g, 0.17 oz)
- Toolbox
- Operator's Manual

### Accessories:

GLW-0640-30-01-00-0	Beveling milling head 22.5° (5 cutting inserts required)
GLW-0640-30-02-00-0	Beveling milling head 30° (5 cutting inserts required)
GLW-0640-30-03-00-0	Beveling milling head 37.5° (5 cutting inserts required)
GLW-0640-30-04-00-0	Beveling milling head 45° (5 cutting inserts required)
GLW-0640-30-05-00-0	Beveling milling head 50° (5 cutting inserts required)
GLW-0640-30-06-00-0	Beveling milling head 55° (5 cutting inserts required)
GLW-0640-30-07-00-0	Beveling milling head 60° (5 cutting inserts required)
PLY-000395	Cutting insert for steel (sold 10 pcs/box)
PLY-000195	Cutting insert for aluminum (sold 10 pcs/box)
GLW-0640-30-34-00-0	Milling head for rounding (4 cutting inserts required)
PLY-000360	Cutting insert R2 (sold 10 pcs/box)
PLY-000159	Cutting insert R3 (sold 10 pcs/box)
PLY-000160	Cutting insert R4 (sold 10 pcs/box)
PLY-000161	Cutting insert R5 (sold 10 pcs/box)
UST-0509-16-00-00-0	Radius insert positioner
ZST-000021	Air preparation unit

### Spare and consumable parts:

SRB-000289	Insert Screw (Radius)
SRB-000290	Insert Screw (Beveling)
SMR-000005	Screw grease (5 g)
NKL-0640-07-00-00-0	Sticker against scratches (dedicated for aluminum beveling)
WBJ-000002	Lock pin



NKL-0640-07-00-00-0



ZST-000021





# BM-20plus

## PORTABLE BEVELLER

BM-20plus is an easy-to-use, portable heavy-duty machine designed for beveling steel plates and pipes prior to welding.

The machine is fitted with two rotary milling heads, each holding five 4-sided indexable inserts, allowing smooth operation and exceptional efficiency.

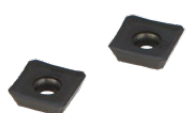
BM-20plus has a state of the art electronic motor overload module protecting the operator, the machine and the tooling.

It is equipped with guide rolls, which make it easy and light to operate.

### Features and benefits:

- Portable, heavy-duty machine
- Equipped with guide rolls for easy operation
- Automatic motor overload protection
- Fitted with two milling heads for smooth and efficient operation
- Adjustable bevel angle, 15°- 60°

$\beta$	15°	30°	45°	60°
$b$	21 mm	20.5 mm	21 mm	20.5 mm



Cutting Insert (1 piece),  
sold 10pcs/box  
Product code: PLY-000282



Cutting Insert HD (1 piece),  
sold 10pcs/box  
Product code: PLY-000591

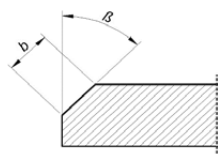


Fig. 1  
Maximum bevel width  
depending on the angle



Plate beveling



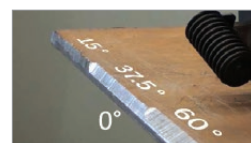
Plate facing-off (option)



Round plate beveling (option)



Pipe beveling (option)



2 rotary milling heads, each  
holding five 4-sided indexable  
inserts

### Optional accessories:



Facing off attachment (0°)  
(enables beveling at zero degree)  
Product code: ZSP-0075-32-00-0-1



150-300mm (6" - 12")  
Product code:  
ZSP-0075-31-00-00-0



260-600mm (10" - 24")  
Product code:  
ZSP-0075-31-00-00-1



Round plate beveling attachment:  
Minimal outer radius R=1000 mm (40")  
Minimal inner radius R=1000 mm (40")  
Max bevel width 19 mm  
Product code: ZSP-0539-10-00-00-0

BM-20plus TECHNICAL SPECIFICATION	
Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Power	2.15 HP (1.6 kW) for 50 Hz 2.41 HP (1.8 kW) for 60 Hz
Spindle speed	2780-3340 rpm (at 230 V) 2740-3290 rpm (at 115 V)
Tooling	Two milling heads with 10 square cutting inserts
Maximum bevel width ( $b$ )	21 mm (13/16") Fig.1
Bevel angle ( $\beta$ )	15°-60° Fig. 1; 0° (option)
Weight	20.5 kg (45 lbs)
Product Code (220-240 V)	UKS-0539-10-20-00-0
Product Code (110-120 V)	UKS-0539-10-10-00-0



Max. bevel width  
21 mm



Bevel angles  
15°-60°  
or 0° (option)



Top beveling



Facing off  
(option)



Round plate  
beveling  
(option)



Pipe beveling  
OD 150-300mm (option)  
OD 260-600mm (option)



# BM-21 | INDUSTRIAL PLATE & PIPE BEVELLER



This new generation portable beveling machine BM-21 is one of the best tools for machining plates and pipes prior to welding. It is a beveller developed on the basis of many years of experience with highly successful predecessor model

BM-20, which for many years was on the most favored tool list for many customers worldwide.

## Features and benefits:

- new single milling head equipped with 10 square inserts, that makes machining process far more efficient with little operator's effort
- fast and easy exchange of inserts with no need for special adjustment
- extended working range from 0 to 60 degrees with continuous angle adjustment
- easy setting of bevel angle and bevel width
- vibration insulation protects both the operator and electronics against vibration
- one universal guide plate for beveling both plates and pipes



Pipe beveling



Continuous angle adjustment from 0 to 60 degrees.



Plate facing-off

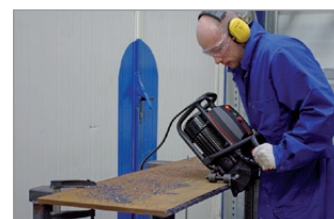


Plate beveling

## BM-21 TECHNICAL SPECIFICATION

Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Induction motor	with increased start-up current
Power	1100 W
Spindle speed	2820 rpm
Tooling	integrated milling head with 10 square TCT inserts
Beveling angle	0-60° with continuous angle adjustment
Max bevel width	21 mm
Weight	20 kg (43 lbs)
Product Code (220-240 V)	UKS-0461-10-20-00-0
Product Code (110-120 V)	UKS-0461-10-10-00-0

BM-21 contains anti-vibration system including special shaped gripping construction with 4 dampers, enabling more comfortable operation, minimizing unwanted vibrations.

According to manufacturer's research the new anti-vibration system reduces vibration perceptibility by 37%.



Mono block milling head, with 10 indexable inserts fixed with screws.  
Product code: GLW-0461-03-00-00-0



Standard universal guide plate for beveling both plates and pipes Ø 150-300mm (6-12")



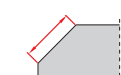
Optional guide for pipes Ø 260-600mm (10-24")  
Product code: PRW-0461-22-00-00-0



Cutting Insert (1 piece),  
sold 10pcs/box  
Product code: PLY-000282



Cutting Insert HD (1 piece),  
sold 10pcs/box  
Product code: PLY-000591



Max. bevel width  
21 mm



Bevel angles  
0-60°



Top beveling



Facing off



Pipe beveling  
OD 150-300 mm  
OD 260-600 mm (option)



# BM-21S

## STAINLESS STEEL PLATE & PIPE BEVELER

The BM-21S Beveling Machine is designed for milling edges of plates and pipes made of stainless steels. The machine enables to bevel sheet edges as well as pipe edges with diameters from 150 mm (6") to 300 mm (12") in 0-60° range with maximum bevel width of 21 mm (13/16").

When equipped with an optional guide, BM-21S allows working on pipes with diameters over 300 mm (12").

### Features & benefits:

- low speed motor suitable for machining stainless steel
- guide plate with guide rolls made of stainless steel
- up to 21 mm bevel width at 45 degrees
- beveling angles adjusted continuously between 0 to 60 degrees
- new single milling head equipped with 10 square inserts makes machining process far more efficient and much less operator fatiguing
- fast and easy inserts exchange with no need for special adjustment
- easy setting of bevel angle and bevel width
- vibration insulation protects both the operator and electronics against vibration
- one universal guide plate for beveling both plates and pipes



Plate facing-off



Plate beveling



Pipe beveling

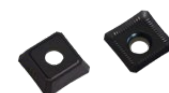


Mono block milling head, with 10 indexable inserts fixed with screws.

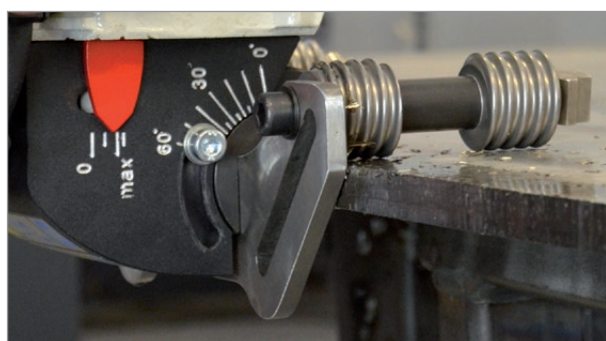
Product code: GLW-0461-03-00-0-0



Cutting Insert (1 piece), sold 10pcs/box  
Product code: PLY-000282



Cutting Insert HD (1 piece), sold 10pcs/box  
Product code: PLY-000591



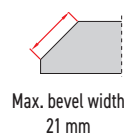
Continuous angle adjustment from 0 to 60 degrees.



Optional guide for pipes Ø 260-600mm (10-24")  
Product code: PRW-0505-03-00-00-0



Standard universal guide plate made of Stainless Steel for beveling both plates and pipes Ø 150-300mm (6-12")



Max. bevel width 21 mm



Bevel angles 0-60°



Top beveling



Facing off



Pipe beveling  
OD 150-300 mm  
OD 260-600 mm (option)

### BM-21S TECHNICAL SPECIFICATION

Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Induction motor	with increased start-up current
Power	1600 W (for 50 Hz); 1800 W (for 60 Hz)
Spindle speed	1360-1630 rpm (at 230 V) 1300-1560 rpm (at 115 V)
Tooling	integrated milling head with 10 square TCT inserts
Beveling angle	0-60° with continuous angle adjustment
Max bevel width	21 mm (13/16")
Weight Approx.	23 kg (51 lbs)
Product Code (220-240 V)	UKS-0505-10-20-00-0
Product Code (110-120 V)	UKS-0505-10-10-00-0



# SBM-500 | STATIONARY BEVELING MACHINE



Stationary beveller for machining straight edges of different size workpieces. Modern design, numbers of advanced control systems and innovative solutions streamlines workflow to maximize your production efficiency.

## Features & benefits:

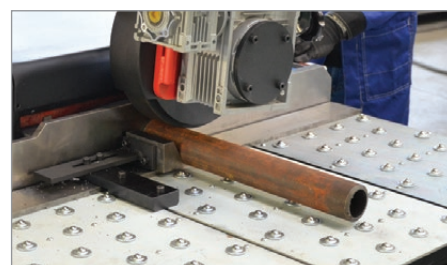
- very high surface quality
- precise setting of bevel angle from 15 up to 60 degrees and bevel width up to 30 mm
- continuous adjustment of spindle speed and feed rate make it suitable for different types of steel and aluminum
- high speed rotary milling head equipped with 10 inserts
- cutting inserts dedicated to various materials
- no heat affected zones or distortion of the workpiece
- easy access to milling head and cutting inserts
- workpiece height up to 100 mm
- powerful 7.500 W motor
- 3D contact wheel control ensures proper workpiece alignment in relation to milling head
- ergonomic ball roller bench
- swarf drawer
- supplementary tables to accommodate long workpieces
- pipe beveling attachment for pipes 50-150 mm (2-6") OD



Attachment for narrow workpieces



Auxiliary tables to accommodate long workpieces



Posibility of pipe OD beveling

## SBM-500 TECHNICAL SPECIFICATION

Voltage	3~ 400 VAC + N+PE, 50/60 Hz
Power	7500 W
Spindle speed (no load)	500 - 2920 rpm
Feed rate	up to 3.3 m/min
Feed by contact wheel	YES
Bevel angle range	15 - 60° with continuous angle adjustment
Bevel width	up to 30 mm
Milling head with 10 inserts	YES
Min. dimensions of a bar	50x150x3 mm
Max. workpiece height	up to 100 mm
Weight	850 kg
Product Code:	UKS-0573-10-00-00-0



Edge Beveling



Workpiece height  
from 3 mm up to  
100 mm



Bevel width  
up to 30 mm



Min. workpiece width 50 mm  
Min. workpiece length 150 mm



Bevel angles 15° - 60°  
continuous adjustment



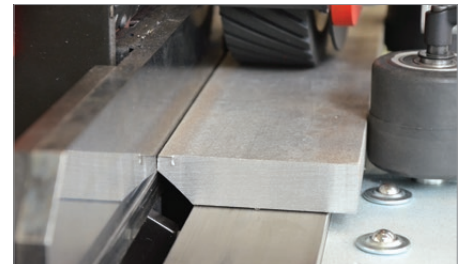
Pipe OD beveling  
from 50 mm up to 150 mm  
(option)



Convenient ball roller bench



Suitable for various materials including aluminum and stainless steel



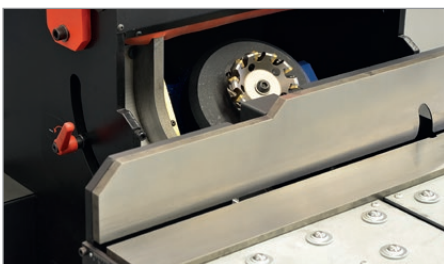
Precise bevel angle adjustment



Simple setting of bevel width



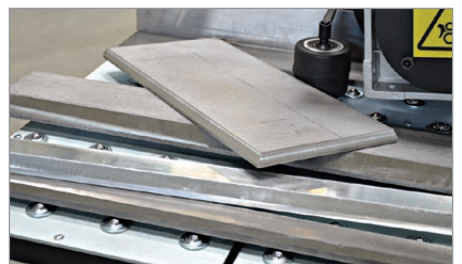
User-friendly control panel



Easy access to milling head and inserts



Capacious swarf drawer



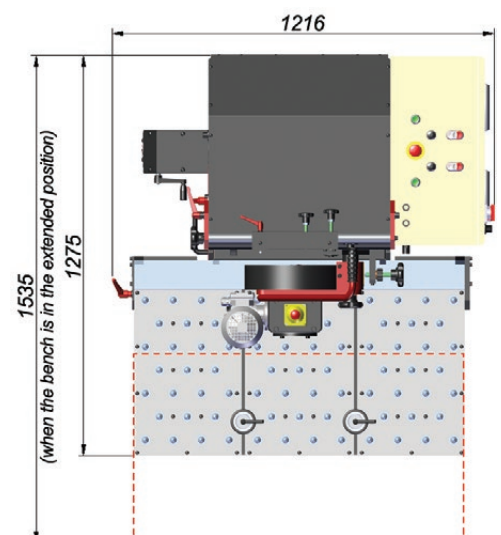
High quality bevel results

## Standard shipping set:

- SBM-500
- Set of Tools
- Operator's Manual

## Accessories:

- GLW-000030 - Milling head (10 pcs required)
- PLY-000396 - Cutting insert for steel (sold 10 pcs/box)
- PLY-000408 - Cutting insert for aluminum (sold 10 pcs/box)
- PLY-000692 - Cutting insert for stainless steel (sold 10 pcs/box)
- SRB-000418 - Insert screw
- PLY-000439 - Shim
- SRB-000417 - Shim screw
- STL-0573-37-00-00-0 - Auxiliary table for long workpieces
- PRK-0573-36-00-00-0 - Pipe beveling attachment for pipes 50-150 mm (2-6") OD
- PRK-0573-38-00-00-0 - Narrow plate attachment



GLW-000030



PLY-000396



PLY-000408



SRB-000418



PLY-000408 SRB-000417



PRK-0573-38-00-00-0



STL-0573-37-00-00-0



# ABM-14 | PLATE AND PIPE BEVELLER



ABM-14 is a beveling machine designed to mill plates and pipes made of carbon steel, alloy steel, stainless steel or aluminum alloys.

In just one single run the machine can bevel up to 2.6 m/min. (8.5 ft/min.) to a width of 12 mm (1/2") in workpieces with tensile strength of  $R_m \leq 392$  MPa (57,000 psi).

Maximum bevel width is 14 mm (9/16"). Depending on materials two or more runs are needed.

Bevel angles incl. 30° (standard) and with optional angle variation devices also 22.5°, 25°, 35°, 37.5° or 45°.

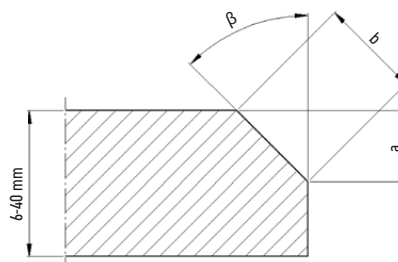
The machine can bevel plates from the top and bottom.

In the case of the milling tool getting stuck in the material and beveling cannot be continued the direction of rotation of the tool can be reversed to release the machine from the workpiece.

There is no need to wear acoustic protection equipment because the noise produced by the machine does not exceed 70 dB.

## Features and benefits:

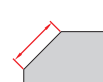
- fast and efficient
- bevels both small and large pieces to cover most of the common applications for its type
- auto feed on large plates with optional trolley
- beveling of lower edge in inverted position
- standard shearing cutter for machining stainless/alloyed steel
- 2 optional shearing cutters dedicated to carbon steel and to aluminum
- reversible spindle against stuck milling tool
- versatile and transportable on its own trolley
- low noise



SINGLE RUN BEVELLING - CARBON STEEL						
$R_m$	$\leq 392$ MPa (57,000 psi)		392-490 MPa (57,000-71,000 psi)		490-588 MPa (71,000-85,000 psi)	
$\beta$	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	12	11	10	9	8	7.5
30°	12	10	10	8.5	8	7
35°	12	9.5	10	8	8	6.5
37.5°	12	9	10	7.5	8	6
45°	12	8.5	10	7	8	5.5

SINGLE RUN BEVELLING - STAINLESS / ALLOY STEEL						
$R_m$	$\leq 490$ MPa (71,000 psi)		490-588 MPa (71,000-85,000 psi)		588-686 MPa (85,000-100,000 psi)	
$\beta$	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	6	5.5	5	4.5	4.2	3.8
30°	6	5	5	4.3	4.2	3.6
35°	6	5	5	4	4.2	3.5
37.5°	6	4.5	5	4	4.2	3.3
45°	6	4	5	3.5	4.2	3

ABM-14 TECHNICAL SPECIFICATION	
Voltage	3~ 400 V + PE, 50/60 Hz
Power	2200 W
Spindle speed	9 rpm
Bevel angle range ( $\beta$ - depending on angle device in use)	30° 22.5°, 25°, 35°, 37.5°, 45° (options)
Bevel width (b)	up to 14 mm (9/16")
Maximum bevel in one single run	12 mm (in 40 Kg/ 392 MPa carbon steel)
Minimum plate thickness	6 mm (1/4")
Maximum plate thickness	40 mm (1-9/16")
Minimum plate width	55 mm (2-3/16")
Bevel length per minute	2.6 m (8.5 ft)
Minimum pipe ID	100 mm (4")
Weight	65 kg (144 lbs)
Product Code:	UKS-0639-10-40-00-0



Bevel width  
up to 14 mm



Bevel angles 30°,  
(option): 22.5°, 25°,  
35°, 37.5°, 45°



Min plate thickness 6 mm  
Max plate thickness  
40 mm



Min plate width  
55 mm



Top beveling



Bottom  
beveling



Pipe OD beveling  
Min. ID 100 mm

## Standard shipping set:

- ABM-14 beveller
- milling cutter for stainless steel
- cutter extraction tool
- tube beveling shaft
- tube beveling washer
- flat wrenches: 12-13 mm, 18-19 mm, 24-26 mm
- hex wrenches: 5 mm and 6 mm
- Operator's Manual



## Optional and spare accessories:



- FRZ-000586 Milling cutter for carbon steel
- FRZ-000588 Milling cutter for stainless steel
- FRZ-000587 Milling cutter for aluminum



- SCG-000002 Milling cutter extraction tool



- PRW-000100 Angle Variation Device 22.5°
- PRW-000101 Angle Variation Device 25°
- PRW-000105 Angle Variation Device 30°
- PRW-000102 Angle Variation Device 35°
- PRW-000103 Angle Variation Device 37.5°
- PRW-000104 Angle Variation Device 45°



- TRZ-000017 Tube beveling shaft
- PDK-000240 Tube beveling washer



- WOZ-000009 Adjustable trolley



ABM-14 runs along a plate automatically





# ABM-28 | PORTABLE AUTO FEED MACHINE



This latest generation portable beveling machine performs auto feed beveling on steel plates on top, face and bottom edges.



## Most important features include:

- Auto-feed portable beveling.
- Continuously adjustable bevel angle between 60 and minus 60 degrees, eliminating the need to turn a plate over
- Max. bevel width (depending on the beveled angle) from 28 up to 35 mm
- Variable feed control for work on a variety of steel grades and thicknesses (up to 35 mm as standard or optionally up to 70 mm)
- Beveling in both travel directions
- Motor overload protection
- J groove beveling available as option
- Quick setup
- Extendable rails



The ABM-28 can perform beveling along steel plate's edge in both travel directions eliminating hard physical work of the operator. Required length of the guide track (rail) can be accomplished with additional sections of guide tracks.

ABM-28 TECHNICAL SPECIFICATION	
Voltage	~220-240 V, 50-60 Hz
Power	1600 W
Spindle speed (no load)	2780 rpm
Bevel angle ( $\beta$ )	60 to -60°
Maximum bevel width ( $b$ )	35 mm (1.38")
Feed speed	250 - 500 mm/min
Plate thickness	max 35mm, 36-70mm (option)
Weight (machine with 1 guide track)	53.5 kg (118 lbs)



Plate thickness  
max 35mm  
36-70mm (option)



Bevel width  
up to 35mm



Bevel angle  
from 60 to  
minus 60°



Top beveling



Facing off



Bottom  
beveling



Clad removal (option)  
depth up to 5 mm (0.2")  
width up to 25 mm (1")



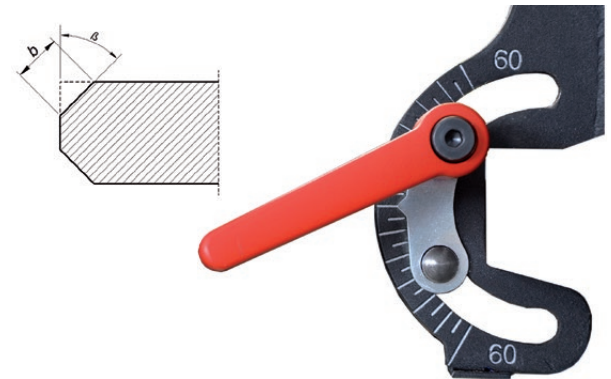
J-groove  
beveling  
(option)



Milling heads for beveling (standard) and for J-groove (option)

$\beta$	0°	30°	45°	60°
b	35 mm	30 mm	28 mm	30 mm

Maximum bevel width depends on the beveled angle



## Standard shipping set:

- Carriage mounted on a guide track
- Milling unit
- Milling unit support for beveling at 60° to -60°
- Additional guide track section
- Track clamp for 10-35mm thick plates (3 pcs)
- Chip container
- Set of tools
- Clamp for 10-35mm thick plates (2 pcs)
- Wooden box
- Operator's Manual

Product Code: UKS-0518-10-20-00-0



## Accessories and optional equipment:

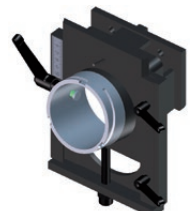
- GLW-000013 Milling head (7 inserts required)
- PLY-000282 Cutting Insert (1 piece), sold 10pcs/box
- GLW-0518-07-03-00-0 J-groove R6 milling head (6 inserts R6 required)
- PLY-000422 Cutting insert for J-groove R6 end preparation
- GLW-0518-07-04-00-0 J-groove R8 milling head (5 inserts R8 required)
- PLY-000424 Cutting insert for J-groove R8 end preparation
- ZSP-0518-13-00-00-0 Guide track L=1200mm (47.25")
- UST-0152-99-02-00-0 Track clamp for 10-35mm thick plates
- UST-0152-15-01-00-1 Track clamp for 36-70 mm thick plates
- ZCS-0152-99-00-00-0 Clamp for 10-35 mm thick plates
- ZCS-0152-99-01-00-0 Clamp for 36-70 mm thick plates
- WSP-0518-03-00-00-0 Milling unit support for beveling 10-35mm thick plates from -60° to 60°
- WSP-0518-04-00-00-0 Milling unit support for beveling 36-70 mm thick plates at 0° to 60° (incl. facing)
- WSP-0518-05-00-00-0 Milling unit support for beveling 36-70 mm thick plates at 0° to -60°
- ZST-0518-07-00-00-0 12° Angle attachment with height adjustment
- ZST-0518-09-00-00-0 Clad removal attachment incl. milling unit support and 3 track clamps for up to 35 mm thick plate



WSP-0518-04-00-00-0



WSP-0518-05-00-00-0



ZST-0518-07-00-00-0





# ABM-50 | AUTO-FEED DOUBLE-SIDED BEVELLER



ABM-50 produces accurate high-quality double-sided bevels without thermal distortion or creation of heat affected zone on plate thickness range 8-80 mm (15/16" - 3 1/8") using a purpose designed milling head with eight 4-sided indexable cutting inserts.

Continuously adjustable bevel angle between 15 and 60 degrees (for both top and bottom beveling) requires no tooling to change.

## The operator can easily adjust and monitor the following parameters:

- bevel angle
- bevel width
- bevel height
- depth of cut
- spindle speed
- feed rate
- spindle load

## Features & benefits

- auto-feed portable beveling
- real-time measurement and on-screen display of exact bevel geometry and cutting parameters
- bevel width up to 50 mm (2") at 45 degrees
- 180° inversion allows for creation of a double-sided bevel – no need to rotate or flip heavy material reduces material handling costs and improves shop safety
- variable spindle speed for work on a variety of steel grades and thicknesses
- versatile and transportable on its own trolley
- equipped with milling head including 8 replaceable inserts
- feedback-controlled overload system

The ABM-50 features an unique remote control panel with LCD display that shows exact bevel geometry as well as enables precise adjustment of spindle speed and feed speed to optimize them depending on material grade incl. stainless steel, aluminum etc.



ABM-28 TECHNICAL SPECIFICATION	
Voltage	3~ 400 V + PE, 50/60 Hz 3~ 480 V + PE, 50/60 Hz
Power	6.5 kW
Spindle speed (no load)	300~800 rpm
Feed speed	0~1.2 m/min (47"/min)
Bevel angle ( $\beta$ )	15~60°
Maximum bevel width (b, Fig. 1)	50 mm (2")
Maximum depth of cut (d, Fig. 1) allowed per single pass	6 mm (1/4")
Plate thickness	8~80 mm (5/16"~3 1/8")
Required ambient temperature	0~40 °C (34~104°F)
Weight	320 kg (700 lbs)
Product Code:	UKS-0627-10-40-00-0

$\beta$	b
15°	66 mm (2 5/8")
30°	52 mm (2")
45°	50 mm (2")
60°	51 mm (2")

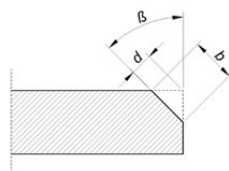
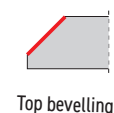


Fig. 1

Bevel width  
up to 50 mm (2") / 45°  
up to 66 mm (2 5/8") / 15°

Min plate thickness 8 mm 5/16"  
Max plate thickness 80 mm 3 1/8"

Bevel angles  
top 15° - 60°  
bottom 15° - 60°



Top beveling



Bottom beveling



- ABM-50 can perform beveling along steel plate's edge eliminating hard physical work of the operator.

- The maximum bevel at 45 degrees is up to 50 mm (2").



- ABM-50 can create a double-sided bevel eliminating the need to turn a plate over.
- Precise adjustment of spindle speed and feed rate to optimize cutting conditions depending on sort of material grade incl. stainless steel, duplex, alloys and aluminum.

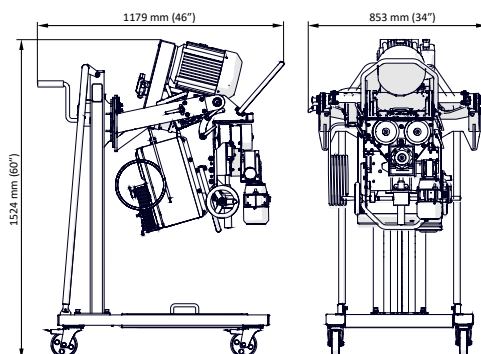


- 180° inversion of ABM-50 enables bottom beveling. No the need to rotate or flip heavy material that reduces workpiece handling costs and improves shop safety.



## Standard shipping set:

- Beveling machine with milling head and 8 cutting inserts
- Wooden box with base and mounting brackets
- Special wrench
- 10 mm T-handle hex wrench with ball tip
- 3,5 mm hex wrench
- T15 torx screwdriver
- Grease for screws
- Operator's Manual



## Accessories

- Milling head (8 cutting inserts required) Product code: GLW-000033
- Cutting insert 1 piece (8 required, sold 10 per box) Product code: PLY-000282
- Cutting insert HD 1 piece (sold 10 pcs/box) Product code: PLY-000591
- PDK-000268 Shim
- SRB-000466 Shim screw
- SRB-000465 Insert screw for cutting insert



# PRO-2 PB | COMPACT PIPE BEVELLER



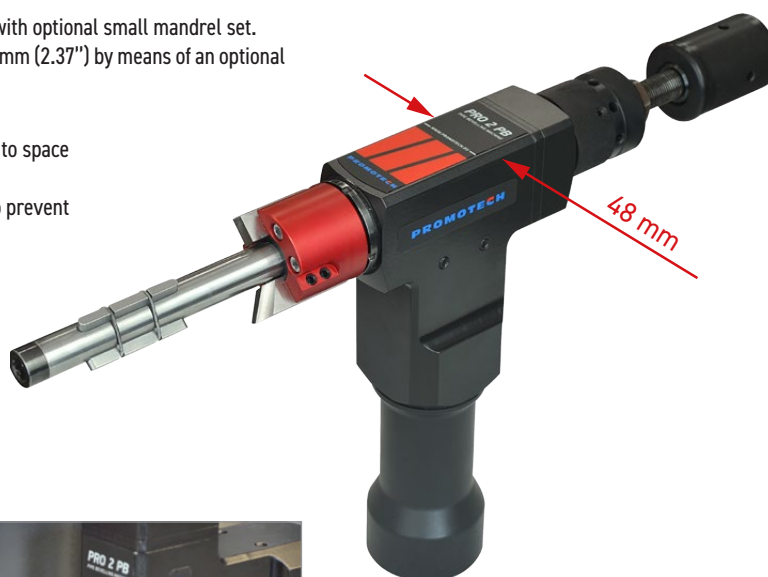
PRO 2 PB is a compact, handy pipe beveller that mills pipes made of carbon and stainless steel, aluminum alloys, and copper-nickels. The machine can face and bevel pipes from inner diameters (ID) of 22 mm (0.87") to outer diameters (OD) of 48 mm (1.89").

Small pipes from ID 15.5 mm (0.61") up to OD 30 mm (1.18") can be beveled with optional small mandrel set.

PRO-2 PB is able to mill also larger pipes from ID 42 mm (1.65") up to OD 60.3 mm (2.37") by means of an optional extension set.

Its exceptionally narrow housing (only 48 mm wide) makes it perfectly suited to space restricted areas such as boiler water walls.

PRO-2 PB incorporates overload systems incl. wet multi-disk friction clutch to prevent gear damage if the tool gets stuck.



## Standard shipping set:

- Beveling machine (without motor, tool bits)
- Metal box
- Standard self-centering expandable mandrel for pipe ID  $\varnothing$  22-42 mm (0.87-1.65")
- 2 sets of jaws (no. 4, 5), 3 sets of jaw blocks (no. 6, 7, 8) and 5 sets of springs (no. 4, 5, 6, 7, 8) for standard mandrel
- Tool bit holder
- Spring gauge
- Handle
- Coolant container with nozzle
- Set of tools
- Operator's Manual

Product Code: UKS-0567-10-00-00-0

TECHNICAL SPECIFICATION	PRO 2 PB with air motor	PRO 2 PB with electric motor	PRO 2 PB with battery motor
Air requirement	0.6 MPa (87 psi)	-	-
Air consumption	1400 l/min (50 CFM)	-	-
Voltage	-	1 ~ 220-240 V, 50-60 Hz	18 V DC, 5.2 Ah
Power	800 W	1100 W	-
Connection	CEJN 410 DN 10.4 R 1/2" BSPT fitting for quick-coupling	Electrical plug	Battery connection
Nominal rotational speed	105 rpm	10-134 rpm (gear 1) 30-377 rpm (gear 2)	10-60 rpm (gear 1) 30-205 rpm (gear 2)
Pipe diameter	22 mm ID - 48 mm OD 15.5 mm ID - 30 mm OD 42 mm ID - 60.3 mm OD**	22 mm ID - 48 mm OD 15.5 mm ID - 30 mm OD* 42 mm ID - 60.3 mm OD**	22 mm ID - 48 mm OD 15.5 mm ID - 30 mm OD* 42 mm ID - 60.3 mm OD**
Maximum pipe wall thickness	8 mm 3.5 mm*	8 mm 3.5 mm*	8 mm 3.5 mm*
Weight with motor	7.6 kg (17 lbs)	7.4 kg (16.5 lbs)	6.5 kg (14.5 lbs), includes battery

\* With an optional small mandrel set (ZST-0567-20-00-00-0).

\*\* With an optional extension set (ZST-0567-21-00-00-0).



Max wall thickness  
up to 8 mm (0.32")



ID 22-42 mm (0.87-1.65")  
15.5-22 mm (0.61-0.87") /option/  
42-58 mm (1.65-2.28") /option/



Facing off

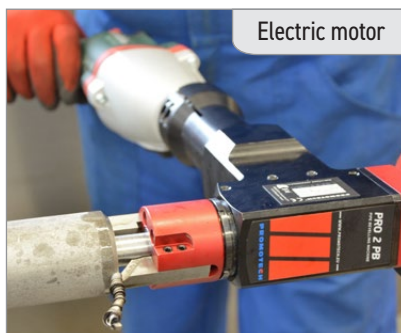


Pipe OD beveling  
up to 48 mm (1.89")  
up to 60.3 mm (2.37") /option/

## 3 different sources of power to choose from:



Pneumatic motor



Electric motor



Battery drive

## Optional accessories:



Adapter and driver  
Product Code:  
ZST-0567-24-00-00-0

Pneumatic motor  
Product Code:  
NPD-0472-03-00-00-0



Driver  
Product Code:  
ZBI-0567-25-00-00-0

Electric motor  
Product Code:  
SLN-000238 (230 V)



Driver  
Product Code:  
ZBI-0567-26-00-00-0

Battery motor and two 5.2 Ah batteries  
Product Code:  
WRT-000021

## Tool bits:

NOZ-000071 for steel	0° facing tool bit short	
NOZ-000078 for stainless steel	0° facing tool bit short*	
NOZ-000072 for steel	0° facing tool bit long	
NOZ-000079 for stainless steel	0° facing tool bit long*	
NOZ-000073 for steel	30° bevelling tool bit	
NOZ-000080 for stainless steel	30° bevelling tool bit*	
NOZ-000074 for steel	37.5° bevelling tool bit	
NOZ-000081 for stainless steel	37.5° bevelling tool bit*	
NOZ-000075 for steel	45° bevelling tool bit	
NOZ-000082 for stainless steel	45° bevelling tool bit*	

\* Tool bits for stainless steel feature TiAlN coating

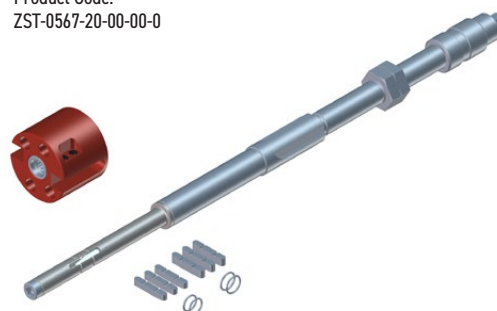


Battery charger  
Product Code:  
LDW-000008 (230 V CEE)  
LDW-000010 (120 V UK)  
LDW-000011 (230 V AU)

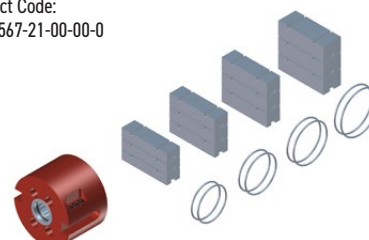


5.2 Ah battery  
Product Code:  
AKM-000088

Small mandrel set for pipes from ID 15.5 mm (0.61") up to OD 30 mm (1.18")  
Product Code:  
ZST-0567-20-00-00-0



Extension set for pipes from ID 42 mm (1.65") up to OD 60.3 mm (2.37")  
Product Code:  
ZST-0567-21-00-00-0





# PRO-5 PB | PORTABLE PIPE BEVELLER



PRO-5 PB is a handy, portable pipe beveling machine suitable for milling edges of pipes made of carbon and stainless steels, aluminum alloys and copper-nickels.

It can be used efficiently by a single operator. Self-centering expandable mandrels provide quick and proper alignment to a pipe or a tube prior to machining operations.

Depending on the tool bits in use PRO-5 PB can perform external beveling, J-beveling, internal calibration and facing pipes from inside diameters of 32 mm (1.26") to outside diameters of 114 mm (4.49") or up to 140 mm (5.51") as option.

All these weld prep operations are made fast and easy. Up to three tool bits can be mounted and work, simultaneously.

According to users preferences and depending on site conditions PRO-5 PB machine can be operated with a high quality powerful pneumatic motor or top quality high torque electric motor.

Optional small spindle disc and ratchet wrench enable pipe machining in difficult to access and space restricted areas.



## Standard shipping set:

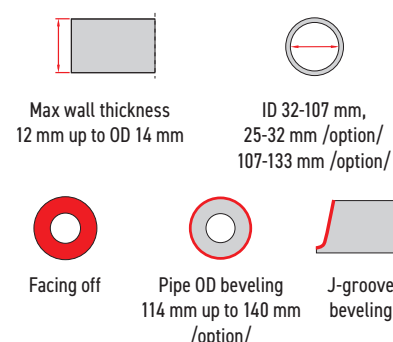
- PRO-5 PB (without motor, tool bits)
- Metal box
- Standard self-centering expandable mandrel for pipe ID Ø 32 – 107 mm (1.26 – 4.21")
- 118 mm spindle disc
- Jaw blocks (1,2,3,4,5,6) – 3 sets
- Set of tools
- Coolant container
- Operator's Manual

Product Code: UKS-0472-10-00-00-0



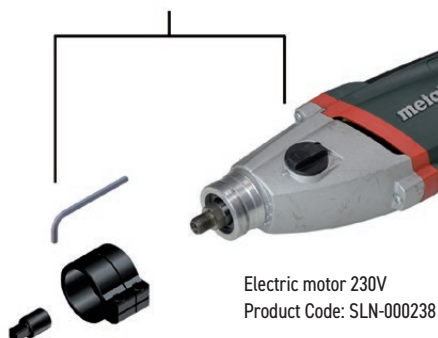
Technical specifications		PRO-5 PB with electric motor	PRO 5-PB with pneumatic motor	
Electric motor		1.100 W	-	
Voltage		1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz	-	18 V DC, 5.2 Ah
Rotational speed (nominal)		gear 1 - 0 to 90 rpm gear 2 - 0 to 300 rpm	-	
Pneumatic drive		-	800 W	
Air requirement		-	0,6 MPa (87 PSI)	
Air consumption		-	1600 l/min (49.4 CFM)	
Rotational speed (nominal)		-	90 rpm	
Pipe diameter		32 mm ID to 114 mm OD (1.26-4.49") ID 25-32 mm (1" - 1.25") /option/ ID 107-133mm (4.21" - 5.24") /option/		
Maximum pipe wall thickness for outside diameter	up to 114 mm	12 mm (0.47")	12 mm (0.47")	12 mm (0.47")
	114-124 mm*	10 mm (0.39")	10 mm (0.39")	10 mm (0.39")
	124-132 mm*	8 mm (0.31")	8 mm (0.31")	8 mm (0.31")
	132-140 mm*	6 mm (0.24")	6 mm (0.24")	6 mm (0.24")
Weight (incl. motor)		11 kg (24 lbs)	10 kg (22 lbs)	10 kg (22 lbs) includes battery

\* Available with the optional 140 mm spindle disk set.



## Optional accessories:

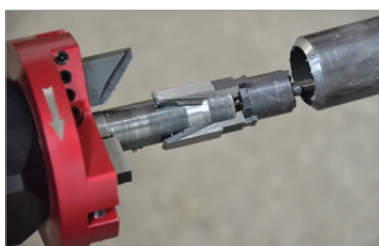
Electric motor 230V with connection set



Connection set for electric motor  
Product Code: ZST-0472-11-00-00-1



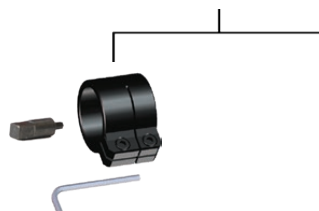
Small mandrel  
ID 25 - 32 mm (1" - 1-1/4")  
Product Code: TRZ-0472-21-00-00-0



Pneumatic motor  
Product Code:  
NPD-0472-03-00-00-0



Battery drive 18V  
with connection set



Connection set for battery drive  
Product Code: ZST-0472-22-00-00-0

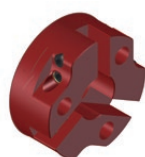


Battery drive for PRO-5 beveller  
incl. 2 batteries 18 V, 5.2 Ah  
Product Code: WRT-000021



Battery charger 18 V  
Product Code for Europe: LDW-000008  
Product Code for USA: LDW-000009  
Product Code for UK: LDW-000010

Battery 18 V, 5.2 Ah  
Product Code: AKM-000088



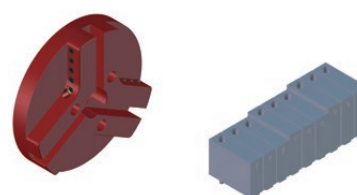
75 mm spindle disc  
Product Code:  
TRC-0472-12-00-00-0



Ratchet wrench  
Product Code: KLC-000045



Minimum distance between  
tubes is 75 mm (2.95")



Extension set for OD Ø up to 140 mm (5.51") including 140  
mm spindle disc and jaw blocks (7, 8, 9) - 3 sets  
Product Code: ZST-0472-15-00-00-0



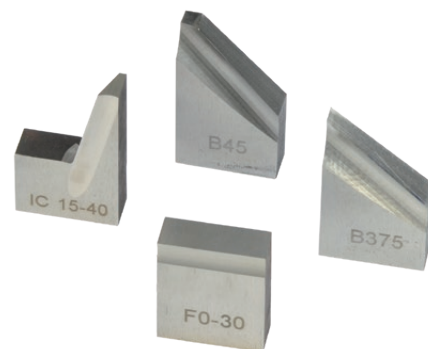
NOZ-000031 for steel NOZ-000067 for stainless steel	F0-30 0° facing tool bit	
NOZ-000032 for steel NOZ-000034 for stainless steel	B30 30° bevelling tool bit*	
NOZ-000033 for steel NOZ-000035 for stainless steel	B30d 30° bevelling tool bit**	
NOZ-000036 for steel NOZ-000038 for stainless steel	B375 37.5° bevelling tool bit*	
NOZ-000037 for steel NOZ-000039 for stainless steel	B375d 37.5° bevelling tool bit**	
NOZ-000040 for steel	B45 45° bevelling tool bit*	
NOZ-000041 for steel	B45d 45° bevelling tool bit**	

Tool bits for stainless steel feature TiAlN coating

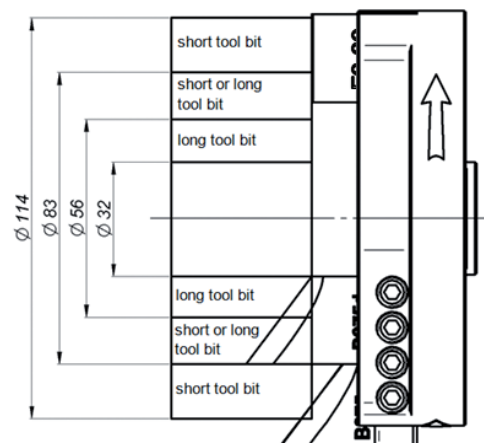
\* for diameters over 56 mm, if works together with 0° facing tool bit

\*\* for diameters under 83mm, if works together with 0° facing tool bit

NOZ-000052 for steel	IC15-40 15° internal calibration tool bit	
NOZ-000053 for steel	IC15-40 15° internal calibration tool bit (for Φ over 56 mm)	
NOZ-000087 for steel	IB12-60 12° internal bevelling	
NOZ-000058 for steel	J10-R6 10° J-bevelling tool bit	
NOZ-000057 for steel	J15-R2 15° J-bevelling tool bit	
NOZ-000059 for steel	J20-R8 20° J-bevelling tool bit	
NOZ-000088 for steel	J20-R1 20° J-bevelling tool bit	



Wide range of tool bits for various applications.



Together with 0° facing tool bit either standard or long bevelling tool bits are in use depending on pipe diameter



Stainless steel machining is available by means of special tool bits



HD-CUT OIL 1 - tapping, drilling and machining fluid product codes:  
OLJ-0505-09-00-00 (0.5 kg)  
OLJ-0505-10-00-00 (1.0 kg)  
OLJ-0505-11-00-00 (5.0 kg)



Air preparation set  
Product Code:  
ZST-000021



# PRO-10 PB | PORTABLE PIPE BEVELLER

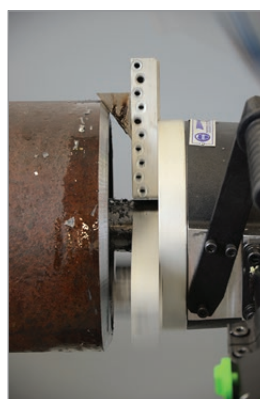
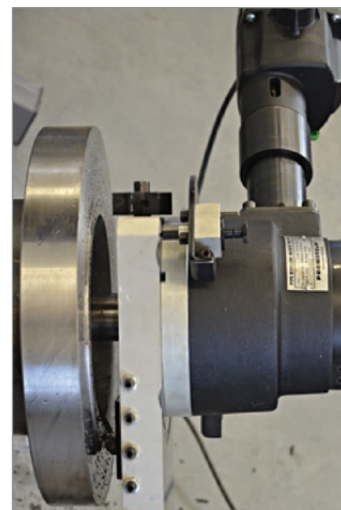
PRO-10 PB is a heavy duty pipe Beveller designed for portable use in pipe machining operations. Self-centering expandable mandrels provide quick and proper alignment to a pipe or a tube prior to machining operations. PRO-10 PB is able to bevel, face off, ID chamfer, counterbore and J-beveling, making all these weld prep operations quick and simple. Depending on users preferences and on site conditions PRO-10 PB machine can be operated with a high quality powerful pneumatic motor or top quality high torque electric motor.



## Standard shipping set:

- PRO-10 PB (without motor, tool bits)
- Metal box
- Standard self-centering expandable mandrel for pipe ID Ø 84 - 269 mm (3.31 - 10.59")
- Jaw blocks (1,2,3,4,5,6) and adapter - 3 sets
- Set of tools
- Coolant container
- Operator's Manual

Product code: UKS-0200-10-00-01-1



Technical specifications	PRO-10 PB with electric motor	PRO-10 PB with pneumatic motor
Electric motor	1.8 kW	-
Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz	-
Rotational speed (nominal)	gear 1-12 to 29 rpm gear 2-41 to 96 rpm	-
Pneumatic drive	-	1,8 kW
Air requirement	-	0,6 MPa
Air consumption	-	1750 NL/min
Rotational speed (without load)	-	17 rpm
Rotational speed (nominal)	-	9 rpm
Min ID	84 mm (3.31"); 38 mm - option	84mm (3.31"); 38mm - option
Max ID	269 mm (10.59"); 349 mm (13.74") - option	269 mm (10.59"); 349 mm (13.74") - option
Max OD	273 mm (10.75"); 355 mm (13.98") - option	273 mm (10.75"); 355 mm (13.98") - option
Max. wall thickness	15 mm (0.59")	15 mm (0.59")
Weight (incl. motor)	35.9 kg (79 lbs)	33 kg (73 lbs)



Max. wall  
thickness 15 mm



ID 84-269 mm  
38-84 mm (option)  
or 270-349 mm (option)



Facing off



Pipe OD  
beveling



Pipe ID  
beveling



J-groove beveling  
(option)





Pneumatic motor  
Product Code: SLN-0200-15-00-00-0



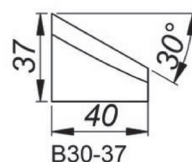
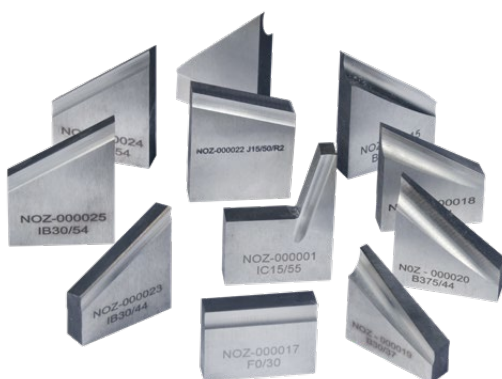
Electric motor 230 V  
Product Code: SLN-000094

Electric motor 115 V US plug  
Product Code: SLN-000102

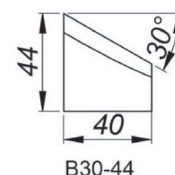
Electric motor 115 V UK plug  
Product Code: SLN-000120



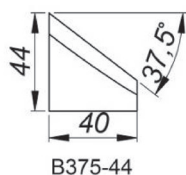
Connection set for electric motor  
Product Code: ZST-0200-99-01-00-0



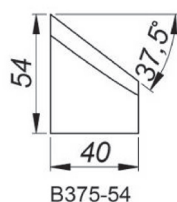
30° Beveling Tool Bit,  
Height 37 mm [B30/37]  
Product Code: NOZ-000019



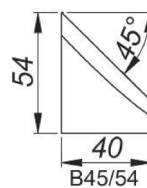
30° Beveling Tool Bit,  
Height 44 mm [B30/44]  
Product Code: NOZ-000018



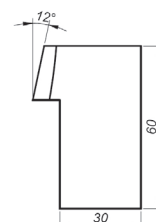
37.5° Beveling Tool Bit,  
Height 44 mm [B375/44]  
Product Code: NOZ-000020



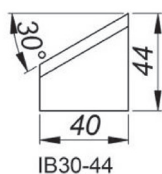
37.5° Beveling Tool Bit,  
Height 54 mm [B375/54]  
Product Code: NOZ-000015



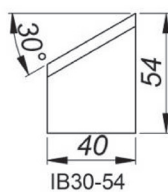
45° Beveling Tool Bit,  
Height 54 mm [B45/54]  
Product Code: NOZ-000021



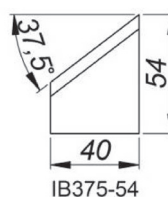
12° Special Tool Bit  
Height 60 mm  
Product Code: NOZ-000086



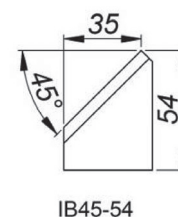
30° Internal Beveling Tool Bit,  
Height 44 mm [IB30/44]  
Product Code: NOZ-000023



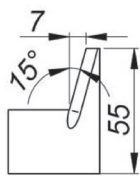
30° Internal Beveling Tool Bit,  
Height 54 mm [IB30/54]  
Product Code: NOZ-000025



37.5° Internal Beveling Tool Bit,  
Height 54 mm [IB375/54]  
Product Code: NOZ-000024

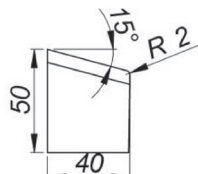


45° Internal Beveling Tool Bit,  
Height 54 mm [IB45/54]  
Product Code: NOZ-000026



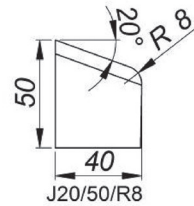
IC15-55

15° Internal Calibration Tool Bit,  
Height 55 mm [IC15/55]  
Product Code: NOZ-000001



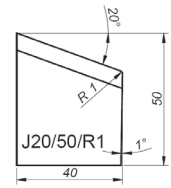
J15-50-R2

15° J-Beveling Tool Bit,  
Height 50 mm, Radius 2mm [J15/50/R2]  
Product Code: NOZ-000022

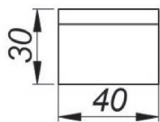


J20/50/R8

20° J-Beveling Tool Bit,  
Height 50 mm, Radius 8mm [J20/50/R8]  
Product Code: NOZ-000016



20° J-Beveling Tool Bit,  
Height 50 mm, Radius 1mm [J20/50/R1]  
Product Code: NOZ-000085



F0-30

Facing Tool Bit,  
Height 30 mm [F0/30]  
Product Code: NOZ-000017

Custom made versions of tool bits are available on request.  
Tool bits could also be coated to increase their durability.



Small expanding mandrel set incl. jaws  
I, II, III, IV for pipe ID  $\varnothing$  38 - 86 mm (1.5 to 3.39")  
Product Code: ZSP-0200-05-00-00-2



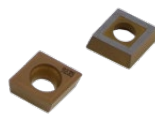
Extension set for OD  $\varnothing$  up to 355 mm (14") incl.  
3 steel tool holders and jaws 7, 8, 9, 10, 11  
Recommended for pipe wall thickness  
up to 7 mm (0.26")  
Product Code: ZST-0200-13-00-00-2



Large expanding mandrel for pipe  
ID  $\varnothing$  126 - 296 mm (5 to 11.65")  
with standard jaws, and pipe  
ID  $\varnothing$  219 - 376 mm (8.62 to 14.80")  
with optional extension set  
Product Code: TRZ-0200-99-00-00-0



Flange facing attachment  
Product Code: PRK-0447-00-00-00-2



Flange facing insert  
Product Code: PLY-000533

Flange diameter	90-508 mm (3.54-20")
Automatic feed range	180.5 mm (7.11")
Diameter of rotating parts	569.4 mm (22.42")
Pipe ID	84-269mm (3.31-10.59") using the standard expanding mandrel 219-376 mm (8.62-13.74") using the large expanding mandrel
Feed per rotation	0.33 mm (0.013", with one tripper block engaged) 0.66 mm (0.026", with two tripper blocks engaged)



Oval attachment set incl. large mandrel for pipe ID  $\varnothing$  126 - 296 mm (5 to 11-5/8")  
Product Code: PRK-0463-00-00-00-1



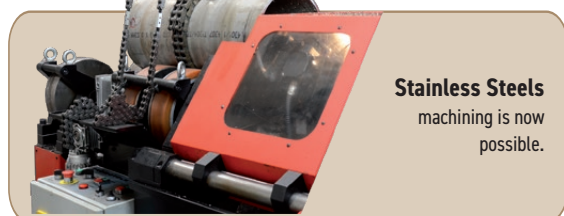
Air preparation set  
Product Code: ZST-000021



# PRO-40 PBS | PIPE BEVELLING MACHINE



PRO 40 PBS is designed for beveling and facing pipes, tanks or tubes in a range of diameters from 200mm to 1000mm (8-40"). High-speed rotary milling head with replaceable inserts enables effective and efficient machining with bevel widths up to 45mm (1-3/4") and angles between 0° and 60°. Internal beveling and J-groove end preparation is optionally available.



**Stainless Steels**  
machining is now possible.

Use of heavy duty milling head in PRO 40 PBS offers accurate bevels in a fraction of the time compared to traditional single point machining. This feature saves time and money by excellent efficiency.

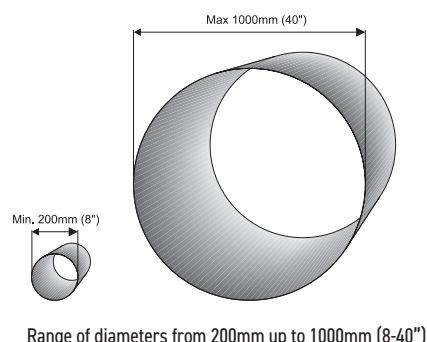


## Standard shipping set:

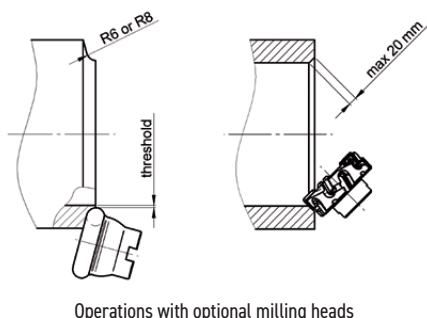
- stationary pipe beveling machine
- active support (with plastic rollers)
- passive support (with steel rollers)
- standard milling head with 7 cutting inserts
- set of guiding chains
- 10 mm hex wrench
- 8 mm hex wrench
- 5 mm hex wrench
- torx T15P screwdriver
- Operator's Manual
- wooden box



User-friendly control panel



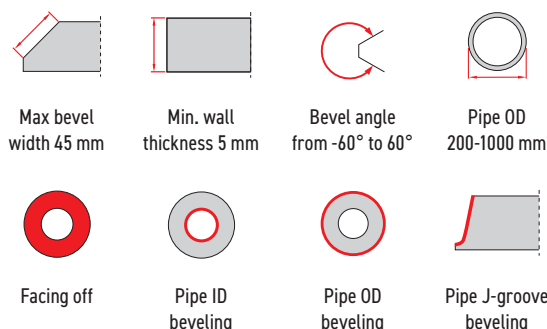
Range of diameters from 200mm up to 1000mm (8-40")



Operations with optional milling heads

PRO 40 PBS Technical specification	
Power supply	1~ 208 - 230 V, 50/60 Hz 3~ 208 - 230 V, 50/60 Hz
External pipe diameter range	200 - 1000 mm (8" - 40") pipes longer than 830 mm; 200 - 600 mm (8" - 23-5/8") pipes of 400-830 mm length
Maximum allowed pipe weight	10 000 kg (22 000 lbs)*, if active support is equipped with optional steel rollers
Min. pipe wall thickness	5 mm (3/16")
Pipe fixing	mechanical with chain
Feed rate	100-1100 mm/min
Beveling angle range	0-60° with continuous angle adjustment
Max OD bevel width	45 mm (1-3/4")
Max ID bevel width	5 mm (1/4") standard, up to 20 mm (13/16) - option
Beveling type „J“	YES - option
„J“ type beveling radius	0.24 in./6 mm or 0.31 in./8 mm
Product Code	UKS-0436-10-20-00-1

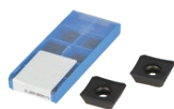
\* 6000 kg (13 200 lbs) for plastic rollers of active support (standard)



## Beveling - standard accessories



GLW-000013  
Standard Milling head  
(7 inserts required)



PLY-000282  
Cutting inserts for beveling  
1pc (sold 10pcs/box)



PLY-000591  
Cutting insert HD for beveling  
1pc (sold 10pcs/box)

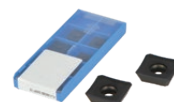


SRB-000311  
Insert fixing screw for  
PLY-000282

## Internal Beveling - option



GLW-0436-19-00-00-0  
Milling head for internal beveling



PLY-000282  
Cutting inserts for beveling  
1pc (sold 10pcs/box)

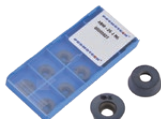


SRB-000311  
Insert fixing screw for  
PLY-000282

## J-Groove Beveling - option



GLW-000014  
J-groove R6 milling head  
(6 inserts R6 required)



PLY-000422  
Cutting insert for J groove R6 end  
preparation 1pc (sold 10pcs/box)



SRB-000297  
Insert fixing screw for  
PLY-000422



GLW-000015  
J-groove R8 milling head  
(5 inserts R8 required)



PLY-000424  
Cutting insert for J groove R8 end  
preparation 1pc (sold 10pcs/box)



SRB-000367  
Insert fixing screw for  
PLY-000424

## Beveling of short pipes - option



DCS-0436-99-00-00-0  
Clamping device for short pipes  
of 400-830 mm length

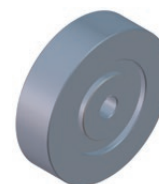


## Beveling of oval pipes - option



WSP-0436-24-00-00-0  
Oval pipe tracking attachment (enables  
consistent land/root face thickness)  
Available either with brand new machine  
or for retrofitting

## Beveling pipes up to 10 tons - option



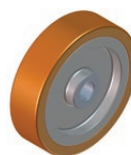
## Stainless Steels Beveling - option



LNC-0436-25-01-00-0  
Set of guiding chains  
for Stainless Steel



DCS-0436-25-10-00-0  
Clamping device for short  
Stainless Steel pipes



KOL-000077  
Wheel with Vulkollan tire  
1pc (2 pcs needed)



## Features and benefits



Shields and internal lighting increase safety  
and comfort of the operator



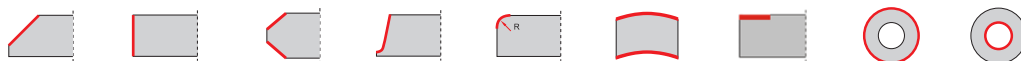
Adjustable chain  
( $\varnothing$  200-1000 mm) ensures  
positive axial rotation



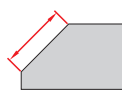
Heavy-duty adjustable pipe  
support ( $\varnothing$  200-1000 mm)



## PLATE BEVELLERS FAMILY



	SINGLE	FACE-OFF	DOUBLE	J-GROOVE	RADIUS	ROUND	CLAD	OD	ID
ABM-14	X		X					X	
ABM-28	X	X	X	X			X		
ABM-50	X		X						
BM-7	X				X	X		X	X
BM-16	X				X	X		X	X
BM-18A	X				X	X			
BM-20plus	X	X				X		X	
BM-21	X	X						X	
BM-21S	X	X						X	
SBM-500	X		X					X	

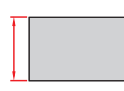


	BEVEL ANGLES	MAX BEVEL WIDTH	MATERIAL TYPE
ABM-14	22.5°, 25°, 30°, 35°, 37.5° or 45°	14 mm	mild steel, aluminum, alloys, stainless steel
ABM-28	- 60° to 0°; 0° to 60°	35 mm	mild steel
ABM-50	- 60° to - 15°; 15° to 60°	50 mm	mild steel, aluminum, alloys, stainless steel
BM-7	45°, 30° (option)	7 mm	mild steel, aluminum
BM-16	22.5°, 30°, 37.5°, 45°, 55° or 60°	16 mm	mild steel, aluminum, alloys, brass or plastic
BM-18A	22.5°, 30°, 37.5°, 45°, 50°, 55° or 60°	18 mm	mild steel, aluminum
BM-20plus	15° to 60° or 0° (option)	21 mm	mild steel
BM-21	0° to 60°	21 mm	mild steel
BM-21S	0° to 60°	21 mm	stainless steel
SBM-500	15° to 60°	30 mm	mild steel, aluminum, alloys, stainless steel

# PIPE BEVELLERS FAMILY

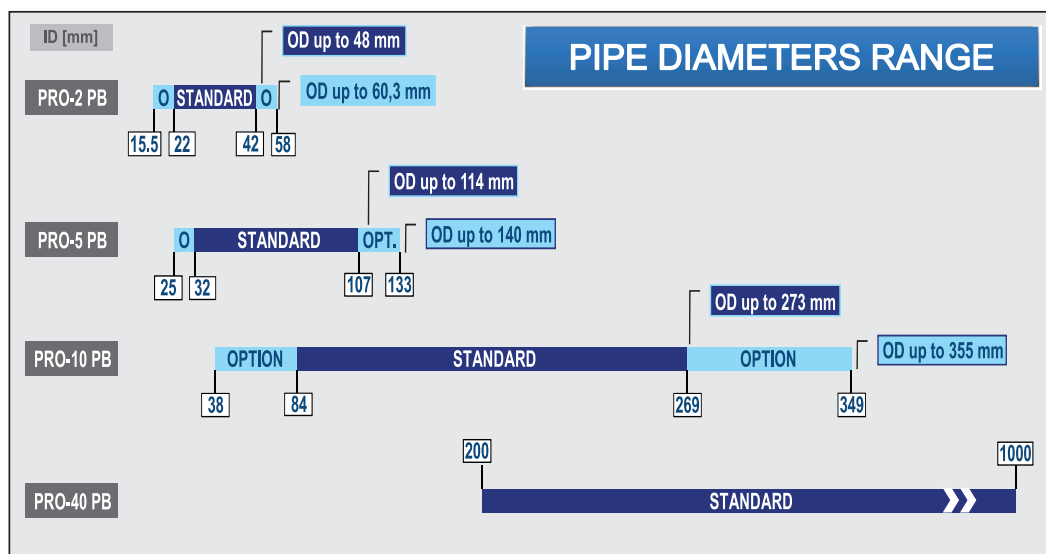


	OD BEVEL	FACE-OFF	ID BEVEL	J-GROOVE	FLANGE FACING
PRO-2 PB	X	X			
PRO-5 PB	X	X	X	X	
PRO-10 PB	X	X	X	X	X
PRO-40 PBS	X	X	X	X	



	BEVEL ANGLES	PIPE WALL THICKNESS	MATERIAL TYPE
PRO-2 PB	F0°, B30°, B37.5° or B45°	up to 8 mm	mild steel, stainless steel
PRO-5 PB	F0°, J10°, IC15°, J15°, J20°, B30°, B37.5° or B45°	up to 12 mm	mild steel, stainless steel
PRO-10 PB	0°, 10°, 15°, 20°, 30°, 37.5° or 45°	up to 15 mm	mild steel, stainless steel
PRO-40 PBS	0° to 60° or -60° to 0° (option)	minimum 5 mm	mild steel, stainless steel

B - bevel tool bit, F - facing tool bit, IC - internal calibration tool bit, J - J-groove tool bit





# HD-CUT | COOLANT FAMILY

## HD-CUT Spray - tapping, drilling and machining multi-position spray

### Features and benefits:

- multi-position spray for drilling, tapping and beveling
- recommended especially for out of position works
- for hard-to-machine metals such as acid resistant or stainless steel
- provides strong and efficient protection of tools, pieces and machineries against corrosion
- water based fluid made of vegetal polymer having outstanding lubricating properties
- ready-to-use (not need to be diluted)
- free from any petroleum-based solvent
- less fumes and smell in comparison to usual products
- nonflammable
- bio-degradable lubricant
- white foaming gel
- no odour
- aerosol 650 ml / net volume 400 ml
- product code: PRE-0440-41-00-00-0



## HD-CUT OIL 1 - tapping, drilling and machining fluid

### Features and benefits:

- extreme pressure full oil for cutting, boring, beveling, high thickness stamping, punching, works on stainless steels all nature, threading, machining, precision and high thickness boring, drawing and profiling of all high thicknesses kinds of steels
- complex oily composition for all operations on hard-to-machine metals such as acid resistant or stainless steel, where seizing and wear quickly happen
- builds high superficial tension film to extend the life of tools and reduce their replacement interval
- significantly facilitates machining and increases its precision
- excellent product for manual working
- deposition on the tools with a brush or with an oil-can
- easy to remove using standard methods
- thick dark oil
- weight 0.5 kg or 1.0 kg or 5.0 kg
- product codes:  
OLJ-0505-09-00-00-0 (0.5 kg)  
OLJ-0505-10-00-00-0 (1.0 kg)  
OLJ-0505-11-00-00-0 (5.0 kg)



## HD-CLEAN SPRAY

### Features and benefits:

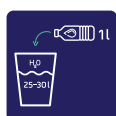
- perfect industrial cleaner for metal machining
- provides elimination of greases, oils, sludge and other chemical or petroleum based fluids
- perfectly suitable for all degreasing operations on all kinds of mechanical parts
- non-flammable
- biodegradable
- aerosol 650 ml / net volume 400 ml
- product code: ZMY-0440-40-00-00-0



## HD-CUT BIO - concentrated micro emulsion for various machining applications

### Features and benefits:

- concentrated ecofriendly micro emulsion for various machining and shavings removal operations
- suitable for coolant systems for e.g. drills, bandsaws or CNC machines
- provides effective protection against corrosion for parts, tools, and machines
- to be diluted with water
- recommended mix ratio of 25-30 parts water to 1 part concentrate
- reduce consumption dramatically compared to usual emulsions
- formulated with high molecular weight based-polyester and high viscosity index allowing a high thermal stability and outstanding lubricant qualities
- high flash point reducing fumes
- bio-degradable
- amber-colored liquid (milky aspect at 5% dilution)
- light smell
- net volume 1000 ml
- product code: CHL-0440-42-00-00-0





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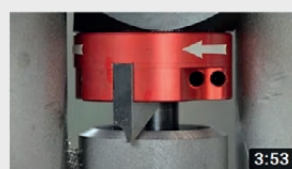
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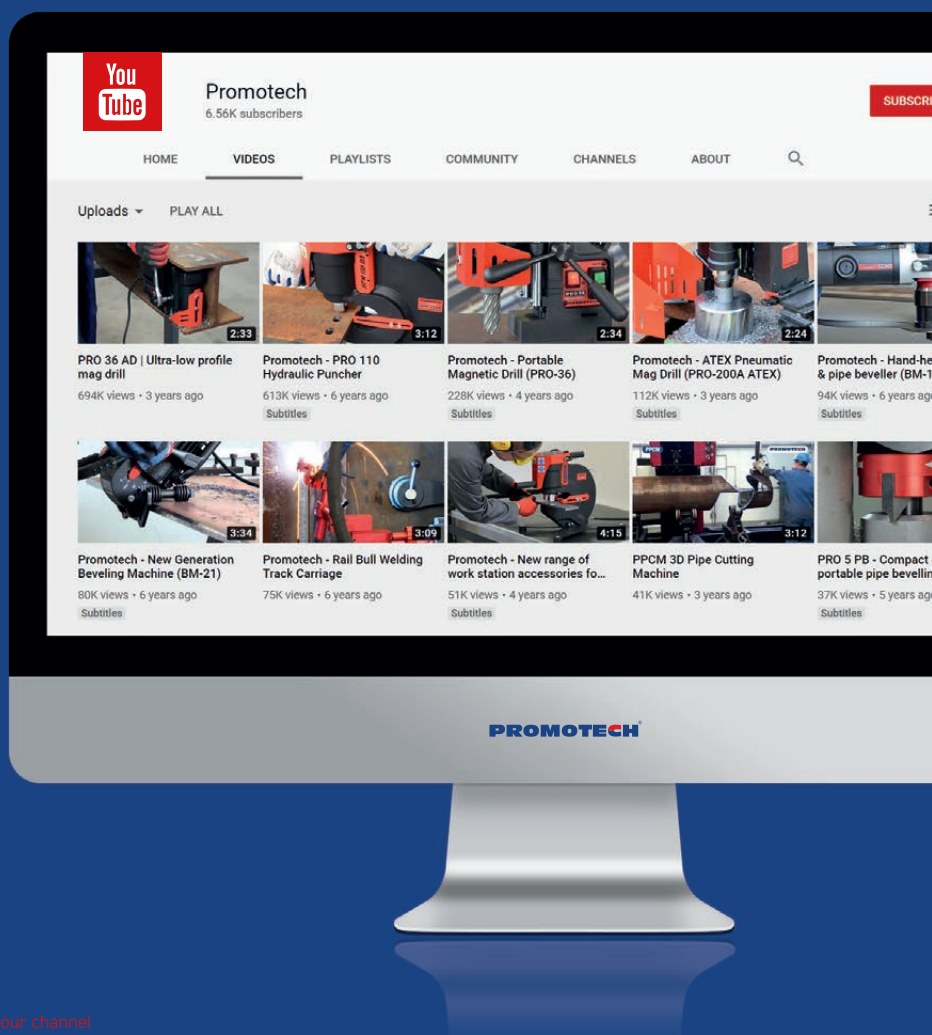
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