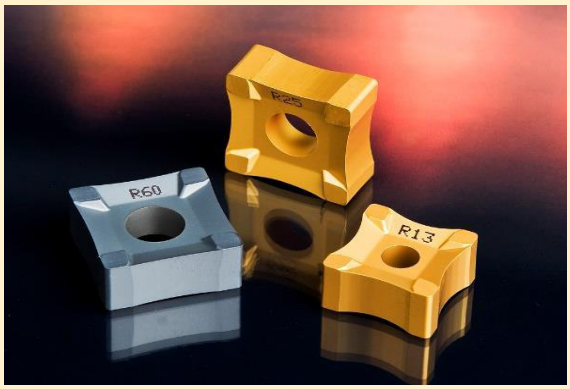
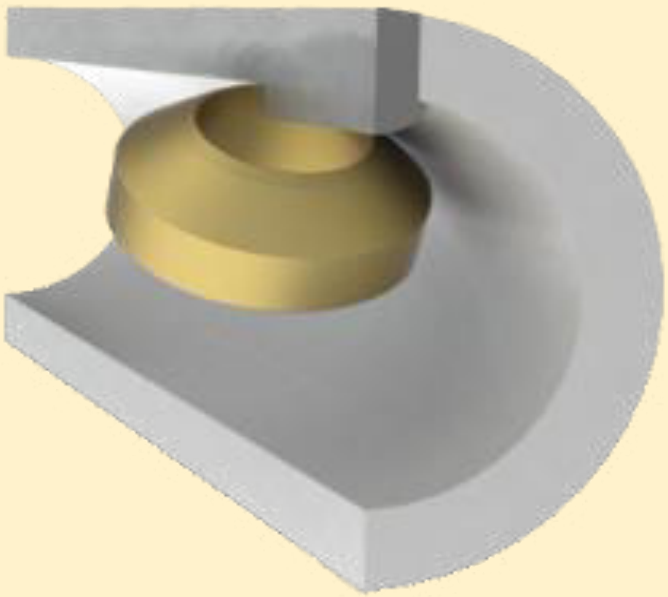
Zubehör für Rohrschweissanlagen
Accessories for tube welding machines

Aussenentgraten / Aussenbearbeitung



Outside deburring

Innenentgraten / Innenbearbeitung



Inside deburring

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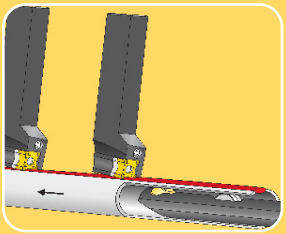
Inhalt / Content



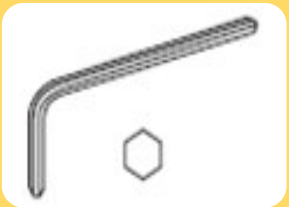
Anwendung / Application 2

Aussenbearbeitung / Outside working

- Wendeplattenhalter / Insert holders 3
- Definition 4
- SNMX 15 5
- SNMX19 6
- SNMX 25 7

Innenbearbeitung / Inside working

- Definition 8
- Schneidringe / Scarfing rings 9



Ersatzteile / Spare parts 10

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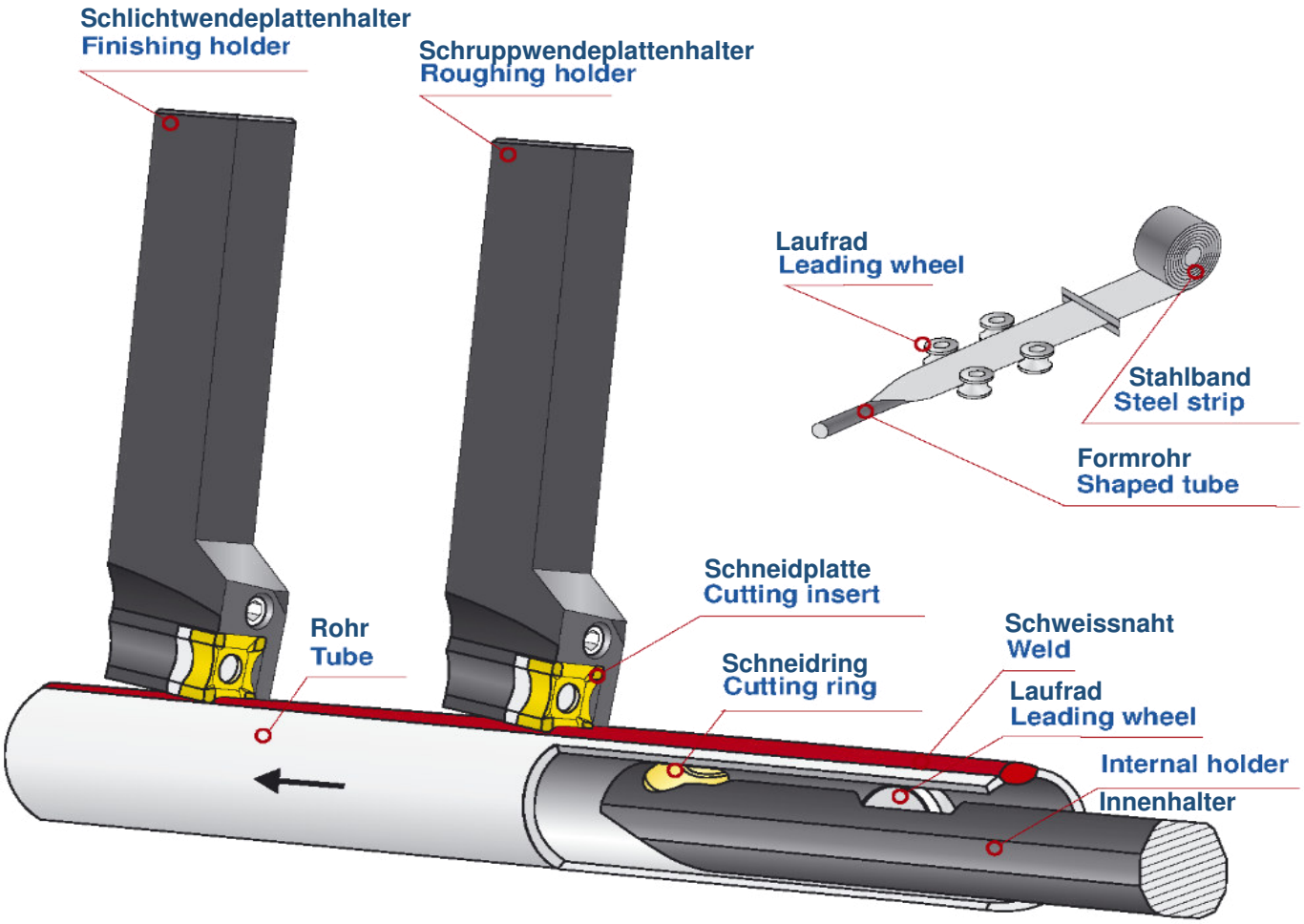
Anwendungshinweise / Application



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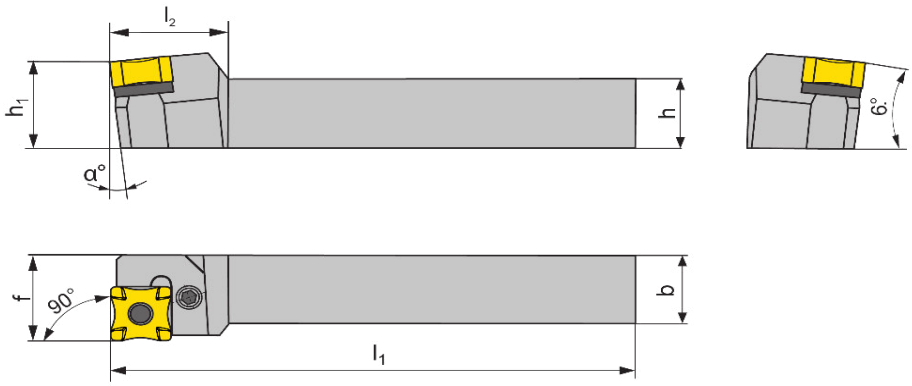
Wendeplattenhalter / Insertholder — SXFN



Artikel Order-No.	Beschreibung Description	Dimension (mm)						kg	WP Insert
		h = h1	b	f	l_1	l_{2max}	a°		
10008845	SXFN 15/6 - L	25	25	25	200	40	6	1.05	SNMX 15
10008846	SXFN 15/6 - R	25	25	25	200	40	6	1.05	SNMX 15
10008847	SXFN 15/20 - L	25	25	25	200	40	20	1.05	SNMX 15
10008848	SXFN 15/20 - R	25	25	25	200	40	20	1.05	SNMX 15
10008849	SXFN 19/6 - L	25	25	25	250	45	6	1.30	SNMX 19
10008850	SXFN 19/6 - R	25	25	25	250	45	6	1.30	SNMX 19
10008851	SXFN 19/20 - L	25	25	25	250	50	20	1.30	SNMX 19
10008852	SXFN 19/20 - R	25	25	25	250	50	20	1.30	SNMX 19
10008853	SXFN 25/6 - L	32	32	40	250	50	6	2.20	SNMX 25
10008854	SXFN 25/6 - R	32	32	40	250	50	6	2.20	SNMX 25

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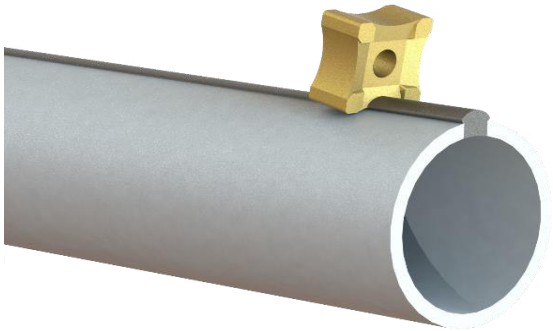
Aussenentgraten
Outside deburring

Technische Information / Technical Information



S N M X 15 - R10 ; P34

S	**Plattenform (ISO)** S = Vierkantplatte
N	**Freiwinkel (ISO)** N = neutral 0°
M	**Toleranzklasse (ISO)**
X	**Spannfläche (ISO)** X = Spezialausführung
15	**Plattengrösse / Size** 15 = 15.875 mm 19 = 19.050 mm 25 = 25.400 mm
R10	**Radius** erhätlich von R0 - 200
P35/P34	**Ausführung** P35 = TiN (goldig) P34 = Al2O3 (schwarz)

S	**Insert shape (ISO)** S = Square
N	**Free angle (ISO)** N = neutral 0°
M	**Tolerance class (ISO)**
X	**Chip breaker (ISO)** X = special execution
15	**Insert size** 15 = 15.875 mm 19 = 19.050 mm 25 = 25.400 mm
R10	**Radius** available from R0 - 200
P35/P34	**Execution** P35 = TiN (gold) P34 = Al2O3 (black)

Wir empfehlen die TiN-Beschichtung, auf Wunsch Al2O3-Beschichtung
We recommend TiN-coating, according your request with Al2O3-coating

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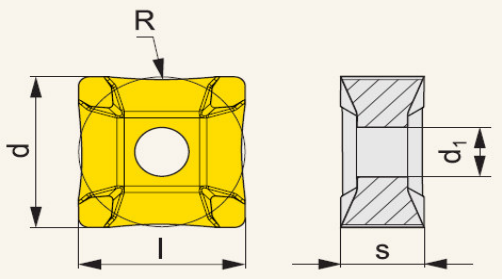
Aussenentgraten
Outside deburring

WP Aussenentgraten / Inserts for outside scarfing — SNMX 15



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008823	SNMX 15 - R00	P35 / P34	15.875	5.16	8.15	0	0
	10006768	SNMX 15 - R07	P35 / P34	15.875	5.16	8.15	7	8 - 10
	10008781	SNMX 15 - R09	P35 / P34	15.875	5.16	8.15	9	10 - 13
	10008782	SNMX 15 - R11	P35 / P34	15.875	5.16	8.15	11	13 - 16
	10008792	SNMX 15 - R13	P35 / P34	15.875	5.16	8.15	13	15 - 19
	10008783	SNMX 15 - R15	P35 / P34	15.875	5.16	8.15	15	17 - 22
	10008784	SNMX 15 - R18	P35 / P34	15.875	5.16	8.15	18	21 - 26
	10008785	SNMX 15 - R20	P35 / P34	15.875	5.16	8.15	20	23 - 29
	10008786	SNMX 15 - R22	P35 / P34	15.875	5.16	8.15	22	25 - 32
	10008787	SNMX 15 - R25	P35 / P34	15.875	5.16	8.15	25	29 - 36
	10008793	SNMX 15 - R27	P35 / P34	15.875	5.16	8.15	27	31 - 39
	10008788	SNMX 15 - R30	P35 / P34	15.875	5.16	8.15	30	35 - 44
	10008794	SNMX 15 - R35	P35 / P34	15.875	5.16	8.15	35	40 - 51
	10008795	SNMX 15 - R40	P35 / P34	15.875	5.16	8.15	40	46 - 58
	10008796	SNMX 15 - R45	P35 / P34	15.875	5.16	8.15	45	52 - 65
	10008797	SNMX 15 - R50	P35 / P34	15.875	5.16	8.15	50	58 - 73
	10008798	SNMX 15 - R60	P35 / P34	15.875	5.16	8.15	60	63 - 80

Spezialgrössen / Special size

10008790	* SNMX 15 - R08	P35 / P34	15.875	5.16	8.15	8	9 - 11
10008789	* SNMX 15 - R10	P35 / P34	15.875	5.16	8.15	10	11 - 14

andere Qualitäten und Sondergrössen auf Anfrage
different qualities and special sizes on request

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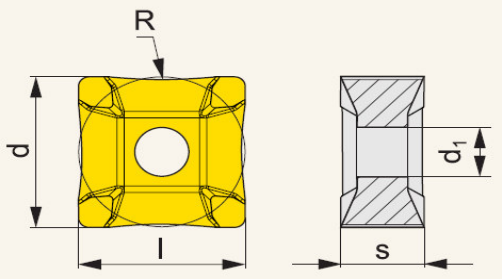
Aussenentgraten
Outside deburring

WP Aussenentgraten / Inserts for outside scarfing — SNMX 19



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008824	SNMX 19 - R00	P35 / P34	19.050	7.95	8.15	0	0
	10008799	SNMX 19 - R10	P35 / P34	19.050	7.95	8.15	10	12 - 15
	10008800	SNMX 19 - R12	P35 / P34	19.050	7.95	8.15	12	14 - 17
	10008801	SNMX 19 - R15	P35 / P34	19.050	7.95	8.15	15	17 - 22
	10008825	SNMX 19 - R18	P35 / P34	19.050	7.95	8.15	18	21 - 26
	10008802	SNMX 19 - R20	P35 / P34	19.050	7.95	8.15	20	23 - 29
	10008826	SNMX 19 - R22	P35 / P34	19.050	7.95	8.15	22	25 - 32
	10008803	SNMX 19 - R25	P35 / P34	19.050	7.95	8.15	25	29 - 36
	10008804	SNMX 19 - R30	P35 / P34	19.050	7.95	8.15	30	35 - 44
	10008805	SNMX 19 - R35	P35 / P34	19.050	7.95	8.15	35	40 - 51
	10008806	SNMX 19 - R40	P35 / P34	19.050	7.95	8.15	40	46 - 58
	10008807	SNMX 19 - R45	P35 / P34	19.050	7.95	8.15	45	52 - 65
	10008808	SNMX 19 - R50	P35 / P34	19.050	7.95	8.15	50	58 - 73
	10008809	SNMX 19 - R55	P35 / P34	19.050	7.95	8.15	55	63 - 80
	10008810	SNMX 19 - R60	P35 / P34	19.050	7.95	8.15	60	69 - 87
	10008811	SNMX 19 - R65	P35 / P34	19.050	7.95	8.15	65	75 - 94
	10008827	SNMX 19 - R75	P35 / P34	19.050	7.95	8.15	75	86-108
	10008812	SNMX 19 - R80	P35 / P34	19.050	7.95	8.15	80	92 - 116
	10008828	SNMX 19 - R85	P35 / P34	19.050	7.95	8.15	85	92 - 116
	10008813	SNMX 19 - R90	P35 / P34	19.050	7.95	8.15	90	104 - 131
	10008814	SNMX 19 - R110	P35 / P34	19.050	7.95	8.15	110	127 - 160

andere Qualitäten und Sondergrössen auf Anfrage
different qualities and special sizes on request

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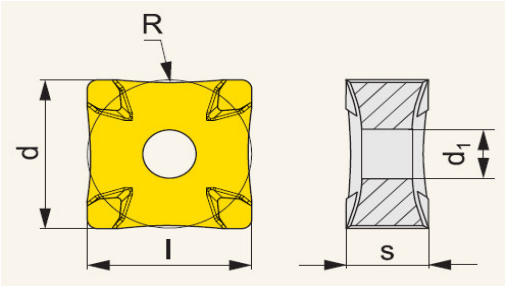
Aussenentgraten
Outside deburring

WP Aussenentgraten / Inserts for outside scarfing — SNMX 25



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008829	SNMX 25 - R00	P35 / P34	25.400	9.12	12.20	0	0
	10008815	SNMX 25 - R50	P35 / P34	25.400	9.12	12.20	50	58 - 73
	10008816	SNMX 25 - R80	P35 / P34	25.400	9.12	12.20	80	92 -116
	10008817	SNMX 25 - R100	P35 / P34	25.400	9.12	12.20	100	115 - 145
	10008818	SNMX 25 - R120	P35 / P34	25.400	9.12	12.20	120	138 - 174
	10008819	SNMX 25 - R140	P35 / P34	25.400	9.12	12.20	140	161 - 230
	10008820	SNMX 25 - R160	P35 / P34	25.400	9.12	12.20	160	184 - 232
	10008821	SNMX 25 - R180	P35 / P34	25.400	9.12	12.20	180	207 - 261
	10008822	SNMX 25 - R200	P35 / P34	25.400	9.12	12.20	200	230 - 290

andere Qualitäten und Sondergrössen auf Anfrage
different qualities and special sizes on request

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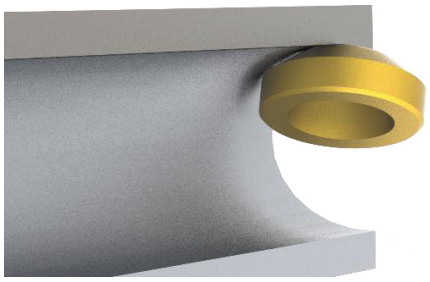
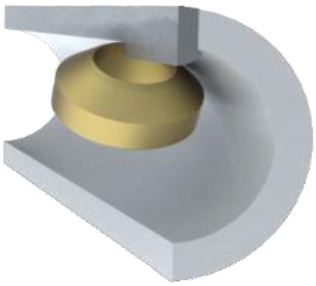
Innenentgraten
Inside deburring

Technische Information / Technical Information

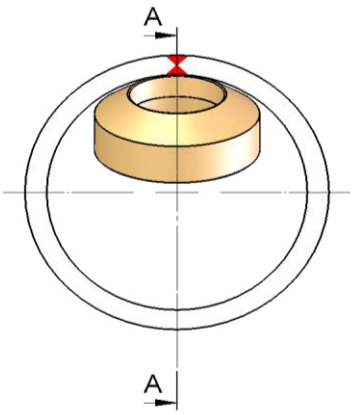


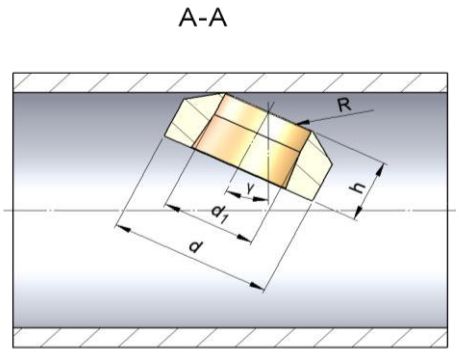


SR 1 - AR5 ; P34

SR	**Ringtyp (Scarfing Ring)**
1	**Aussendruchmesser (d)** 1 = 13 mm 5 = 35 mm 2 = 19 mm 6 = 45 mm 3 = 22 mm 7 = 50 mm 4 = 30 mm 8 = 55 mm
AR5	**Arbeitsradius (R)** y = in der Regel 26°
P34	**Ausführung** P34 = Al2O3 (schwarz)

SR	**Ring typ (Scarfing Ring)**
1	**Outside diameter (d)** 1 = 13 mm 5 = 35 mm 2 = 19 mm 6 = 45 mm 3 = 22 mm 7 = 50 mm 4 = 30 mm 8 = 55 mm
AR5	**Working radius (R)** y = usually 26°
P34	**Execution** P34 = Al2O3 (black)





$$R = \frac{d_1}{2 * \sin \gamma}$$

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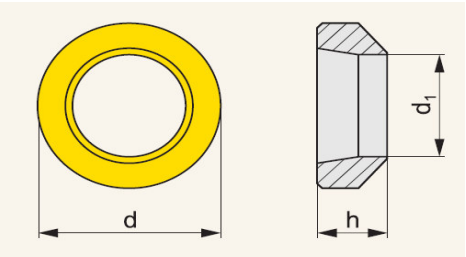
Innenentgraten
Inside deburring

Schneidringe / Scarfing rings — SR - AR ; P34



Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
			l = d	d1	h	R	Rohrinnen - Ø Tube inside - Ø
10008830	SR0 - AR3.5	3503 P34 CA	6.00	3.00	3.50	3.40	12 - 13.5
10008831	SR0 - AR4	3503 P34 CA	6.00	3.50	3.50	4.00	12 - 14
10008778	SR0 - AR4.5	421 P34 CA	8.00	4.00	4.00	4.60	13.5 - 19
10008832	SR0/10 - AR4.5	421 P34 CA	10.00	4.00	4.00	4.60	13.5 - 19
10008833	SR0 - AR5.5	3706 P34 CA	8.00	5.00	4.00	5.70	16 - 20
10008770	SR0/10 - AR5.5	3706 P34 CA	10.00	5.00	4.00	5.70	16 - 20
10008834	SR0 - AR6	421 P34 CA	10.00	5.50	4.50	6.30	17 - 20
10008766	SR0 - AR6.5	421 P34 CA	10.00	6.00	4.50	6.80	17 - 21
10008835	SR0/5 - AR6.5	421 P34 CA	10.00	6.00	5.00	6.80	20 - 22
10006766	SR0 - AR7	421 P34 CA	10.00	6.50	4.50	7.40	17 - 22
10008764	SR1 - AR7	421 P34 CA	13.00	6.00	5.00	6.80	20 - 22
10008761	SR1 - AR8	421 P34 CA	13.00	7.00	5.00	8.00	22 -24
10008836	SR1 - AR9	421 P34 CA	13.00	8.00	5.00	9.10	24 - 26
10006767	SR1 - AR10	421 P34 CA	13.00	9.00	5.00	10.20	25 - 28
10008837	SR2 - AR9	421 P34 CA	19.00	8.00	8.00	9.10	24 - 26
10008765	SR2 - AR10	421 P34 CA	19.00	9.00	8.00	10.20	26 - 28
10008762	SR2 - AR11	421 P34 CA	19.00	10.00	8.00	11.40	28 - 30
10008780	SR2 - AR12	421 P34 CA	19.00	11.00	8.00	12.50	30 - 34
10008771	SR2 - AR14	421 P34 CA	19.00	12.50	8.00	14.30	32 - 41
10008838	SR3 - AR12	421 P34 CA	22.00	11.00	10.00	12.50	30 - 34
10008763	SR3 - AR14	421 P34 CA	22.00	12.00	10.00	13.70	32 - 41
10008839	SR3 - AR17	421 P34 CA	22.00	15.00	10.00	17.10	41 - 50
10008840	SR4 - AR20	421 P34 CA	30.00	17.00	12.00	19.40	45 - 60
10008841	SR4 - AR23	421 P34 CA	30.00	20.00	12.00	22.80	48 - 72
10008842	SR5 - AR25	422 P34 CA	35.00	22.00	12.00	25.10	70 - 85
10008768	SR5 - AR28	422 P34 CA	35.00	25.00	12.00	28.50	85 - 100
10008843	SR6 - AR34	422 P34 CA	45.00	30.00	15.00	34.20	100 - 130
10008769	SR7 - AR39	422 P34 CA	50.00	35.00	15.00	39.50	125 - 140
10008844	SR8 - AR46	422 P34 CA	55.00	40.00	18.00	45.60	150 - 400

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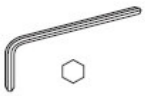
Ersatzteile / Spare parts

	Artikel Order-No.	Beschreibung Description	Halter Holder
	10008855	Unterlagsscheibe / Shim	SXFN 15...
	10008856	Unterlagsscheibe / Shim	SXFN 19...
	10008857	Unterlagsscheibe / Shim	SXFN 25...
	10008858	Klemmstück / Clamp piece	SXFN 15...
	10008859	Klemmstück / Clamp piece	SXFN 19...
	10008860	Klemmstück / Clamp piece	SXFN 25...
	10008861	Spannschraube / Clamp screw	SXFN 15...
	10008862	Spannschraube / Clamp screw	SXFN 19...
	10008863	Spannschraube / Clamp screw	SXFN 25...
	10008864	Halbhohlniet / Half hollow rivet	SXFN 15...
	10008865	Halbhohlniet / Half hollow rivet	SXFN 19...
	10008866	Halbhohlniet / Half hollow rivet	SXFN 25...
	10008867	Spannstift / Clamp pin	SXFN 15...
	10008868	Spannstift / Clamp pin	SXFN 19...
	10008869	Spannstift / Clamp pin	SXFN 25...
	10008870	Schlüssel / Wrench	SXFN 15...
	10008871	Schlüssel / Wrench	SXFN 19...
	10008872	Schlüssel / Wrench	SXFN 25...

Kontaktdaten / Contact

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