

# S F E

## SPECIALIZED FABRICATION EQUIPMENT GROUP



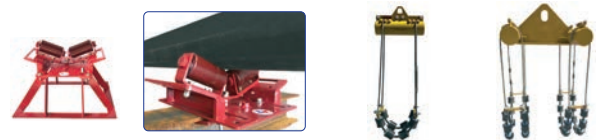
### PIPE ALIGNMENT CLAMPS



### PIPE FLAME CUTTING AND BEVELLING



### PIPE RIGGING EQUIPMENT



### MEGA JACKS AND ROLLERS



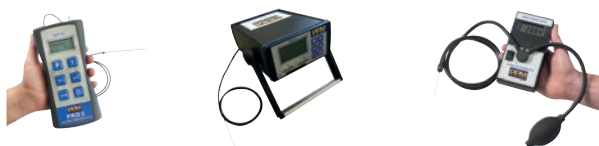
### PIPE JACKS AND STANDS



### MATERIAL HANDLING EQUIPMENT



### PURGE OXYGEN MONITORS



### PIPE PURGING SYSTEMS



### PIPE STOPPERS





## SPECIALIZED FABRICATION EQUIPMENT GROUP

### Introduction to S.F.E. Group

Mathey Dearman Inc, B&B Pipe and Industrial Tools LLC and TAG Pipe Equipment Specialist Ltd; are proud to announce their merging and the formation of Specialized Fabrication Equipment Group, or The S.F.E. Group.

The synergies of these three global brands enable S.F.E. Group to not only offer a more robust product range to our distribution partners, but also a proactive sales and marketing approach and increased infrastructure and customer support.

With the backing of Gladstone Companies, a publicly listed private equity group; The S.F.E. Group will proactively be looking to further invest in the Welding and Industrial Equipment channels through add on acquisitions of other leading Brands, while continuing to grow our existing brands and product portfolio.



**Mathey Dearman** based in Tulsa, Oklahoma is an 80-year-old company with 45 employees. Mathey Dearman is known as the pioneer of Mathey saddle type pipe cutters and bevelers, as well as Dearman type alignment and reforming clamps.

#### PIPE FLAME CUTTING AND BEVELLING



Mathey manufactures multiple flame and plasma Pipe Cutters and Bevelers and are recognized as the leader in this product category. These machines are used across multiple fabrication projects, most commonly found in the energy construction markets.

#### PIPE ALIGNMENT CLAMPS



With the invention of the Dearman clamp taking lead, additional Pipe Alignment and Reforming Clamps are now offered exhibiting the most complete line in the industry.

#### PIPE RIGGING EQUIPMENT



A new line of Pipe Rigging Products will be offered under the Mathey Brand in 2020. Pipe Slings and Cradles, Pipe Launchers and Rigging Rollers add focus on a complimentary pipeline product category to Mathey Saddle Machines and Cage Clamps.



**B&B Pipe and Industrial Tools, LLC** is based in Houston Texas and are recognized as an aggressive and growing brand in the Pipe and heavy Industrial construction markets. B&B has approximately 40 employees and sells its products internationally on every continent.

#### PIPE JACKS AND STANDS



Over the past several years, B&B has led the market in the Pipe Jack and Stand product category offering more models and innovative variations than any other manufacturer. With thousands of products sold every year, B&B is one of the recognized leaders in this category.

#### MATERIAL HANDLING EQUIPMENT



B&B's line of Material Handling Carts and Buggies compliments the jacks and stands product category from a distribution and supply chain perspective. This line also allows further expansion into new product markets.

[www.BBPIPETOOLS.COM](http://www.BBPIPETOOLS.COM)



We are also excited to launch a new brand called **Pipe Purging Masters (PPM)**. This brand will offer a comprehensive and innovative range of pipe purging equipment.

#### PIPE PURGING SYSTEMS



PPM's range of Purge systems greatly reduce the purging time and give significant gas savings while producing a top quality weld.

#### PURGE OXYGEN MONITORS



PPM also offers a full range of weld purge monitoring systems to accurately measure the level of oxygen within the weld chamber for high quality purity welding.

#### PIPE STOPPERS



In addition to our Purging Systems and Purge Monitors PPM also offers an extensive range of pipe stoppers from inflatable stoppers available in all shapes, sizes and materials, as well as expanding stoppers available in Nylon, Steel and Aluminium.

[www.PURGEMASTERS.COM](http://www.PURGEMASTERS.COM)

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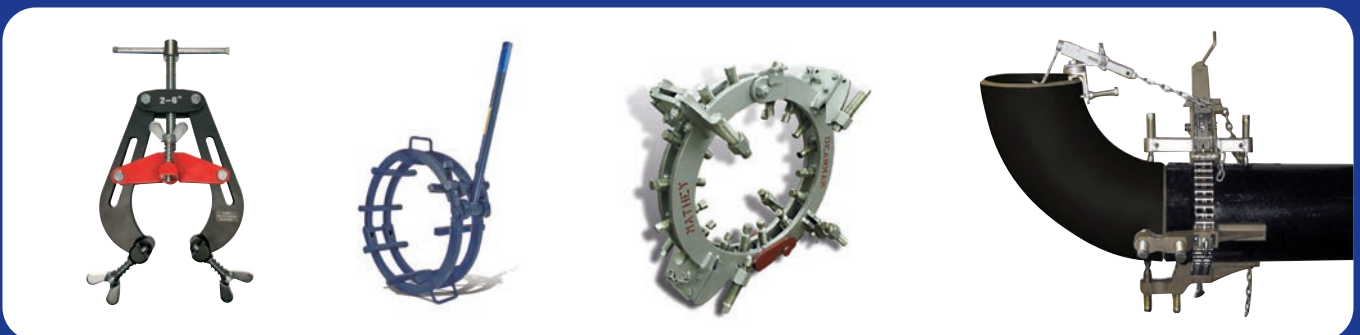


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## PIPE FLAME CUTTING AND BEVELLING



## PIPE ALIGNMENT CLAMPS



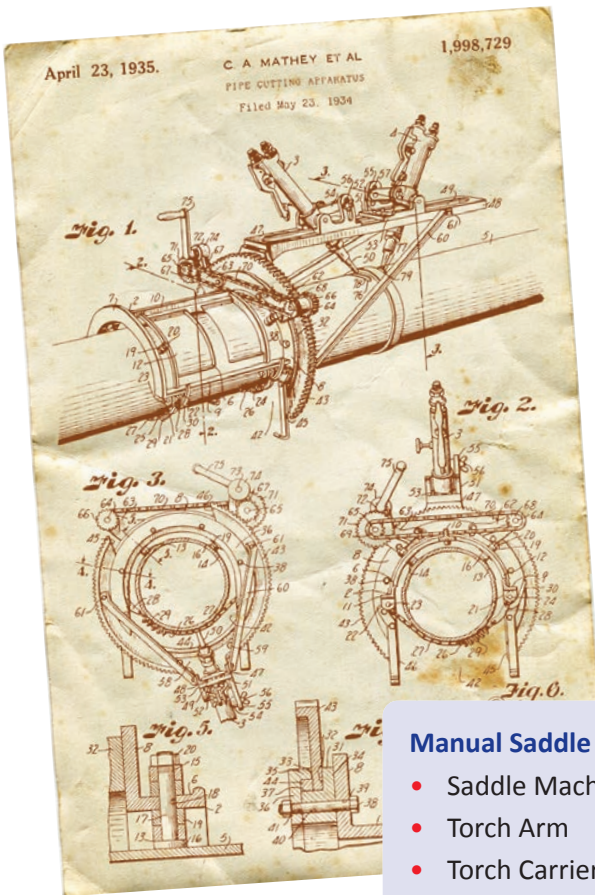
## PIPE RIGGING EQUIPMENT



The industry-standard for over 80 years, the Mathey Dearman Saddle Machine is versatile, simple to use, and perfect for almost any pipe cutting and beveling application. Lightweight and durable, Mathey Dearman Saddle Machines are designed for accurate, quality cuts on 1½" - 48" (38 mm - 1,219 mm) pipes.

- Versatile** | Every model works on a range of pipe sizes
- Adaptable** | Works with all standard torches, including plasma
- Portable** | Light and compact, perfect for shop or field applications
- Easy Set-Up** | Mount and begin cutting in as little as 5 minutes
- Proven** | Depended on by professionals for over 70 years
- Fast** | Pipe is ready to weld up to five times quicker than hand cutting and grinding

**Mathey has been the leader in pipe cutting since we invented the saddle machine in 1934.**



#### Manual Saddle Machine Includes:

- Saddle Machine
- Torch Arm
- Torch Carrier Assembly
- Boomer Assembly (fastens the machine to the pipe)
- Spacer Bolt Set
- Parts and Operating Manual

*Note: Machine torches sold separately.*

Want the easiest way to get a perfect cut every time? Motorized Saddle Machines from Mathey Dearman are precise and fast, delivering smooth cuts requiring little or even no grinding. Both experienced and inexperienced welders can benefit from the increased productivity (up to 5 times quicker!) and cut quality of Motorized Saddle Machines compared to traditional hand-cutting or manual machines. Motorized PLASMASPEED Saddle Machines can use 110/230 VAC for pipe sizes 1½" - 48" (38 - 1,219 mm) and can operate at increased cutting speeds to use powerful plasma torches.

It's what Mathey Dearman calls PLASMASPEED!

#### Motorized Saddle Machine Includes:

- 110/230 VAC Motorized Saddle Machine
- Torch Arm
- Torch Carrier Assembly
- Boomer Assembly (fastens the machine to the pipe)
- Spacer Bolt Set
- Parts and Operating Manual
- Mounting Bracket
- Right-angle precision stepper motor
- Motor Control Box
- Plasma communication cable

*Note: Machine torches sold separately - machine shown with optional step spacers and pro model torch.*



#### Conventional Cutting vs Saddle Cutting Time

##### Hand Cutting

###### Time: 30 Minutes

- 8" Schedule 40 Pipe being cut by hand. Time includes measuring, cutting and grinding
- Longer than necessary layout time
- Excessive amount of time to cut the pipe
- Inaccurate/uneven cut requiring grinding
- Extended fit-up time
- Uneven weld gap

##### Mathey Dearman Cutting

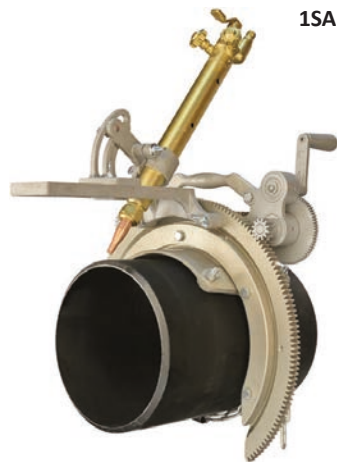
###### Time: 6 Minutes

- 8" Schedule 40 Pipe being cut with a 1SA Manual Saddle Machine
- Perfect Cut
- No Grinding
- Perfect Fit-up



MSA

Pipe Size Range  
1.5" - 4" / 38 - 102 mm



1SA

Pipe Size Range  
3" - 8" / 76 - 203 mm



2SA

Pipe Size Range  
6" - 12" / 152 - 305 mm



3SA

Pipe Size Range  
12" - 20" / 305 - 508 mm

## Manual Saddle Machines

MACHINE MODEL	MSA	1SA	2SA
Manual with Spacer Bolts	03.0100.000	03.0101.000	03.0102.000
Manual with Step Spacers	---	03.01S1.000	03.01S2.000

## Motorized Saddle Machines / PLASMASPEED

MACHINE MODEL	MSA	1SA	2SA
Motorized with Spacer Bolts 115/230 VAC	03.0100.S01	03.0101.S01	03.0102.S01
Motorized with Step Spacers 115/230 VAC	---	03.01S1.S01	03.01S2.S01

## Plasmaspeed Retrofit Kits

MACHINE MODEL	MSA	1SA	2SA
PLASMASPEED Retrofit Kits 115/230 VAC	03.0100.SA1	03.0101.SA1	03.0101.SA1

## General / Specifications

MACHINE MODEL	MSA	1SA	2SA
Pipe Size in (mm)	2 - 4 (50 - 102)	3 - 8 (76 - 203)	6 - 12 (152 - 305)
Net Weight lbs. / kg	10 / 5	16 / 7	26 / 12
Estimated Shipping Weight lbs. / kg	12 / 5.4	24 / 11	34 / 15.5
Shipping Dimensions in (mm)	12 x 12 x 10 (305 x 305 x 254)	18 x 18 x 11½ (457 x 457 x 492)	23 x 23 x 12½ (584 x 584 x 318)
Max. Speed (Motorized) ipm* / mpm**	141 / 3581	71 / 1803	89 / 2261
Min. Speed (Motorized) ipm* / mpm**	4 / 102	4 / 102	6 / 152
Includes Spacer Bolts to cut pipe sizes	2", 3", 4" (51, 76, 102 mm)	3", 4", 6", 8" (76, 102, 152, 203 mm)	6", 8", 10", 12" (152, 203, 254, 305 mm)

\* Inches per minute | \*\* Millimeters per minute





4SA

Pipe Size Range  
20" - 26" / 508 - 660 mm



5SA

Pipe Size Range  
24" - 30" / 610 - 762 mm



6SA

Pipe Size Range  
28" - 36" / 711 - 914 mm



8SA

Pipe Size Range  
36" - 48" / 914 - 1,219 mm

3SA	4SA	5SA	6SA	8SA
03.0103.000	03.0104.000	03.0105.000	03.0106.000	03.0108.000
03.01S3.000	---	---	---	---

3SA	4SA	5SA	6SA	8SA
03.0103.S01	03.0104.S01	03.0105.S01	03.0106.S01	03.0108.S01
03.01S3.S01	---	---	---	---

3SA	4SA	5SA	6SA	8SA
03.0103.SA1	03.0103.SA1	03.0105.SA1	03.0105.SA1	03.0105.SA1

3SA	4SA	5SA	6SA	8SA
12 - 20 (305 - 508)	20 - 26 (508 - 660)	24 - 30 (610 - 762)	28 - 36 (711 - 914)	36 - 48 (914 - 1219)
50 / 22	75 / 34	110 / 50	180 / 82	287 / 130
73 / 33	150 / 68	185 / 84	295 / 134	537 / 244
34 x 32 x 12 (864 x 813 x 305)	40½ x 41 x 19 (1,029 x 1,041 x 423)	40½ x 41 x 19 (1,029 x 1,041 x 423)	57 x 43 x 18 (1,488 x 1,002 x 483)	69 x 60 x 21 (1,753 x 1,524 x 533)
47 / 1194	53 / 1346	34 / 864	35 / 889	36 / 914
7 / 178	7 / 178	8 / 203	5 / 127	5 / 127
12", 14", 16", 18", 20" (305, 356, 406, 457, 508 mm)	20", 22", 24", 26" (508, 559, 610, 660 mm)	24", 26", 28", 30" (610, 660, 711, 762 mm)	28", 30", 36" (711, 762, 914 mm)	36", 38", 40", 42", 48" (914, 964, 1,016, 1,067, 1,219 mm)

**Contour Cutting Attachment** - When cutting a 90° saddle on 8" pipe, the combination of the Saddle Machine and Contour Cutting Attachment reduces cutting and grinding time by up to 80%.

MACHINE MODEL	PIPE SIZE		PART NO.	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
	IN	MM		LBS.	KG	IN	MM
MSA	1.5 - 4	38 - 102	03.0116.MSA	7.0	3.2	23 x 10 x 9	584 x 254 x 229
1 - 2 SA	3 - 12	76 - 305	03.0116.1SA	7.0	3.2	36 x 12 x 12	914 x 305 x 305
3SA	12 - 20	305 - 508	03.0116.3SA	9.0	4.1	36 x 12 x 12	914 x 305 x 305
4SA	20 - 26	508 - 660	03.0116.4SA	9.0	4.1	36 x 12 x 12	914 x 305 x 305
5SA	24 - 30	610 - 762	03.0116.5SA	11.0	5.0	48 x 12 x 12	1,219 x 305 x 305
6SA	28 - 36	711 - 914	03.0116.6SA	13.0	5.9	48 x 12 x 12	1,219 x 305 x 305
8SA	36 - 48	914 - 1,219	03.0116.8SA	16.0	7.2	48 x 12 x 12	1,219 x 305 x 305



**Contour Cutting Shape Templates** - Produce perfect miter and saddle cuts with the easy to use Mathey Dearman Contour Cutting Attachment. Simply choose the Template for the desired type of cut and the torch will follow the Template around the pipe. Contour Cutting Attachments and Templates are available for 1½" - 48" (38 mm - 1,219 mm) pipe.

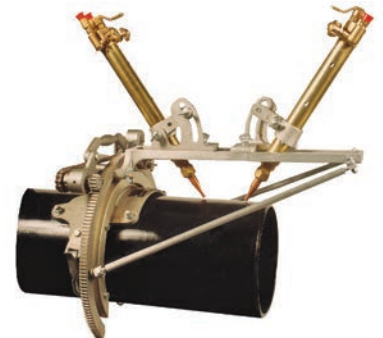
*NOTE: Template Form is required prior to order - Template cannot be returned*

MACHINE MODEL	SPACERS FOR PIPE SIZES		PART NO.	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
	IN	MM		LBS.	KG	IN	MM
MSA	1.5 - 4	38 - 102	03.0115.M . .	3.5 - 5.0	1.6 - 2.3	12 x 12 x 9	305 x 305 x 229
1SA	3 - 8	76 - 203	03.0115.1 . .	4.5 - 6.0	2.0 - 2.7	18 x 18 x 11	457 x 457 x 279
2SA	8 - 12	152 - 305	03.0115.2 . .	6.0 - 8.0	2.7 - 3.6	23 x 23 x 13	584 x 584 x 330
3SA	12 - 20	305 - 508	03.0115.3 . .	11.0 - 15.0	5.0 - 7.0	36 x 12 x 12	914 x 305 x 305
4SA	20 - 26	508 - 660	03.0115.4 . .	18.0 - 27.0	8.0 - 12.0	36 x 36 x TBD	914 x 914 x TBD
5SA	24 - 30	610 - 762	03.0115.5 . .	22.0 - 31.0	10.0 - 14.0	42 x 48 x TBD	1,067 x 1,219 x TBD
6SA	28 - 36	711 - 914	03.0115.6 . .	27.0 - 35.0	12.0 - 16.0	48 x 48 x TBD	1,219 x 1,219 x TBD
8SA	36 - 48	914 - 1,219	03.0115.8 . .	31.0 - 40.0	14.0 - 18.0	60 x 60 x TBD	1,524 x 1,524 x TBD



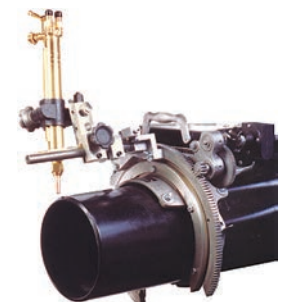
**Double Torch Arm** - Reduce setup and cutting time by up to 50% with our Double Torch Arm accessory. By eliminating the need to rotate one torch to obtain a forward or back bevel on the pipe end, our Double Torch Arm dramatically reduces cutting and beveling time.

MACHINE MODEL	PIPE SIZE		PART NO.	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
	IN	MM		LBS.	KG	IN	MM
1SA	3 - 8	76 - 203	03.0101.030	5.0	2.3	20 x 6 x 6	508 x 152 x 152
2SA	8 - 12	152 - 305	03.0102.015	5.0	2.3	20 x 6 x 6	508 x 152 x 152
3SA	12 - 20	305 - 508	03.0103.030	5.0	2.3	23 x 10 x 9	584 x 254 x 229
4SA	20 - 26	508 - 660	03.0104.021	5.0	2.3	23 x 10 x 9	584 x 254 x 229
5SA	24 - 30	610 - 762	03.0105.025	5.0	2.3	23 x 10 x 9	584 x 254 x 229
6SA	28 - 36	711 - 914	03.0106.018	5.5	2.5	23 x 10 x 9	584 x 254 x 229
8SA	36 - 48	914 - 1,219	03.0108.014	5.5	2.5	23 x 10 x 9	584 x 254 x 229



**Pro Model Torch Arm** - Choose the Pro Model Torch Arm with our innovative Out-of-Round Roller Attachment to create perfect cuts and bevels on oversize, undersize or out-of-round pipe.

DESCRIPTION	PART NO.	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
		LBS.	KG	IN	MM
PRO Model With Out of Round	03.0209.000	9.5	4.3	16 x 8 x 8	406 x 203 x 203
PRO Model Basic Assembly	03.0209.001	7.0	3.2	16 x 8 x 8	406 x 203 x 203
Tracer Point	03.0209.012	1.6	0.7	12 x 6 x 6	305 x 152 x 152



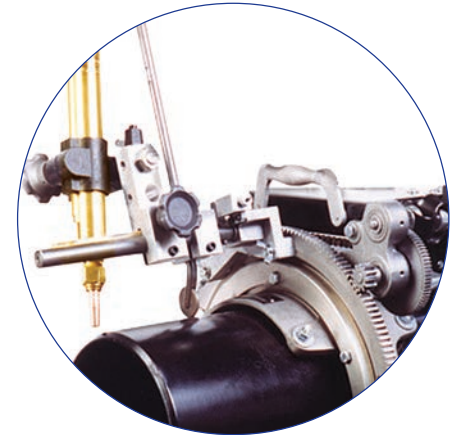
Torch holders that can accommodate up to 2" barrel diameter torches are available.

### Out-of-Round Roller Attachment

Would you like to add out-of-round compensating capabilities to your current Pro Model Torch Arm?

Our Out-of-Round Roller Attachment Kit compensates for oversize and undersize pipe, handling out-of-round conditions up to ¼" (6mm). Order separately. Comes with all required parts and assembly instructions.

DESCRIPTION	PART NO.	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
		LBS.	KG	IN	MM
Out of Round Kit	03.0209.003	2.5	1.1	12 x 6 x 6	305 x 152 x 152

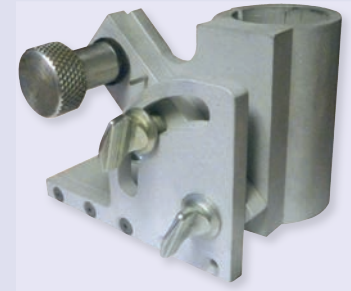


Pro Model with Out-of-Round Roller Attachment Kit installed

### Cam-Adjustable Torch Carrier

Our Cam-adjustable Torch Carrier makes it simple to make perfect, no-notch cuts, every time. Just start the cut away from the desired cut line, use the knurled cam adjustment knob to move the torch into the cut line then start your cut. In addition, the Torch Holder's large wing screw makes tightening the torch in the Torch Holder easy, even when wearing gloves. Our innovative design even allows forward or back-beveling without the need to reverse the Torch Holder in the Torch Arm.

**ITEM NO. 03.0100.052**



### Saddle Machine Storage Box

To help protect your valuable investment, store your Saddle Machine, Torch, Torch Arm, Torch Carrier, Spacer Bolts and Parts and Operating Manual in this specially-designed Storage Box. MSA, 1SA, and 2SA Storage Boxes are made of 16 gauge, powder-coated steel, with attached lifting handles. Storage Boxes for Saddle Machines larger than the 2SA are made of plywood with reinforced corners and edges.



MODEL	ITEM NUMBER	DIMENSIONS	FOR MANUAL OR MOTORIZED	BOX TYPE	EST. SHIPPING WEIGHT
MSA	03.0100.BOX	17" x 17" x 17" / 432 x 432 x 432 mm	Manual Only	Metal	23 lbs. / 11 kg
1SA	03.0101.BOX	20" x 18" x 17" / 205 x 457 x 432 mm	Manual Only	Metal	33 lbs. / 15 kg
2SA	03.0102.BOX	25" x 22" x 18" / 635 x 559 x 457 mm	Manual Only	Metal	41 lbs. / 19 kg
3SA	03.0103.BOX	34" x 34" x 14" / 864 x 864 x 356 mm	Manual or Motorized	Wood	60 lbs. / 27 kg
4SA	03.0104.BOX	40" x 38" x 14" / 1,016 x 965 x 356 mm	Manual or Motorized	Wood	75 lbs. / 34 kg
5SA	03.0105.BOX	42" x 40" x 14" / 1,067 x 1,016 x 356 mm	Manual or Motorized	Wood	75 lbs. / 34 kg
6SA	03.0106.BOX	56" x 48" x 16" / 1,422 x 1,219 x 406 mm	Manual Only	Wood	175 lbs. / 79 kg
8SA	03.0108.BOX	70" x 56" x 19" / 1,778 x 1,422 x 483 mm	Manual Only	Wood	250 lbs. / 102 kg

## Self-Storing Step-Down Spacer

Combining multiple Spacer Bolt sizes into one easy-to-use part, our Step-down Spacers are machined to the same tolerances as Spacer Bolts. Each Step Spacer covers a range of four (4) pipe sizes; eliminating the need to store 16 Spacer Bolts. No more searching for lost or misplaced Spacer Bolts with high quality aluminum alloy or stainless steel self-storing Step-down Spacers.

### Step Spacer Kit

DESCRIPTION	ITEM NUMBER	FOR PIPE SIZES		EST. SHIPPING WEIGHT
		IN	MM	
1SA Step Spacers	03.0110.1SAKIT	3, 4, 6, 8	76, 102, 152, 203	1.6 lbs. / .7 kg
2SA Step Spacers	03.0110.2SAKIT	6, 8, 10, 12	152, 203, 254, 305	1.6 lbs. / .7 kg
3SA Step Spacers	03.0110.3SAKIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	1.6 lbs. / .7 kg



**1SA STEP SPACER**



**2SA STEP SPACER**



**3SA STEP SPACER**

### Step Spacers (Individual)

DESCRIPTION	ITEM NUMBER	FOR PIPE SIZES		EST. SHIPPING WEIGHT
		IN	MM	
1SA Step Spacer	03.0110.1SA	3, 4, 6, 8	76, 102, 152, 203	0.4 lbs. / 0.2 kg
2SA Step Spacer	03.0110.2SA	6, 8, 10, 12	152, 203, 254, 305	0.4 lbs. / 0.2 kg
3SA Step Spacer	03.0110.3SA	12, 14, 16, 18, 20	305, 356, 406, 457, 508	0.4 lbs. / 0.2 kg



### Saddle Machine Spacer Bolts

Our Spacer Bolt Kits include the Spacer Bolts available for any Mathey Dearman Saddle Machine model in one handy container. An actual-size diagram is located on the lid, making finding the correct Spacer Bolts quick and easy. All Spacer Bolts are precision-machined for maximum cutting accuracy and labeled with the Mathey Dearman logo and item number for quick identification.

*Actual size is shown on box lid for quick spacer bolt identification.*

*Spacer Bolts can be replaced individually or in sets.*

### Spacer Bolt Kits

DESCRIPTION	ITEM NUMBER	FOR PIPE SIZES		EST. SHIPPING WEIGHT
		IN	MM	
MSA	03.0MSA.KIT	2, 3	51, 76	1.0 lbs. / 0.5 kg
1SA	03.01SA.KIT	3, 4, 6, 8	76, 102, 152, 203	4.0 lbs. / 1.8 kg
2SA	03.02SA.KIT	6, 8, 10, 12	152, 203, 254, 305	5.0 lbs. / 2.3 kg
3SA	03.03SA.KIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	9.0 lbs. / 4.1 kg
4SA	03.04SA.KIT	20, 22, 24, 26	508, 559, 610, 660	10.0 lbs. / 4.5 kg
5SA	03.05SA.KIT	24, 26, 28, 30	610, 660, 711, 762	10.0 lbs. / 4.5 kg
6SA	03.06SA.KIT	28, 30, 36	711, 762, 914	20.0 lbs. / 9.0 kg
8SA	03.08SA.KIT	36, 38, 40, 42, 48	916, 964, 1,016, 1,069, 1,219	20.0 lbs. / 9.0 kg

\* No spacers required for 4" pipe set-up

## Mini Jolli Chain Machine

Extremely rugged yet lightweight, the Mini Jolli is our most popular chain cutting and beveling machine. Recommended for cutting a very broad range of pipe and vessels, the Mini Jolli Chain Machine easily adjusts from one pipe size to the next, precisely following the outside pipe diameter to produce a consistent bevel. The Mini Jolli's unique, compact design delivers exceptional performance and accurate results. Cuts pipe diameters 2" (51 mm) and larger.

**Best Choice** | For small shop or maintenance facility

**Best Machine** | For multiple pipe diameters

**Faster** | Up to 50% faster than hand cutting and grinding

**Accurate** | Two wheel positions, Double Row Chain and available Guide Track ensure precision cutting and beveling

**Simplified Setup** | With MagSquare Magnets



ITEM NO.  
05.0520.000

TORCH SOLD  
SEPARATELY

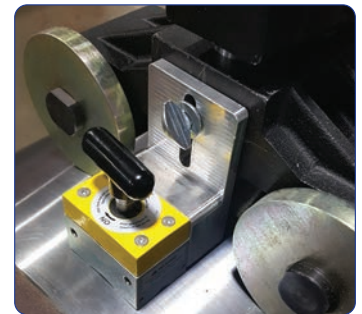
### Mini Jolli Chain Machine Includes:

- Base machine
- Torch Arm
- Service Keys
- Sliding Support
- Hose Support
- Rack-adjustable Torch Holder
- Parts and Operating Manual

MagSquare Magnets are now standard with all MINI JOLLI CHAIN MACHINES

MODEL	ITEM NUMBER	EST. SHIP. WEIGHT
Manual Mini Jolli	05.0520.000	34 lbs. / 15.4 kg
PLASMASPEED Mini Jolli, 110/230 VAC	05.0520.S01	42 lbs. / 18.9 kg
PLASMASPEED Retrofit Kit, 110/230 VAC	05.0520.SA1	18 lbs. / 8.1 kg

\* Includes 32-pitch torch holder. Add an I to the end of the item number shown to order a Mini Jolli with a metric torch holder.



**Note:** For maximum cutting and beveling accuracy the use of our optional guide track is recommended for pipe or vessels 18 inches (457 mm) in diameter and larger.



**Sliding Support and Torch Holder** | Add a second sliding support and torch holder giving your Jolli Chain Machine the ability to bevel both sides of the cut line simultaneously.

**ITEM NO. 05.0510.810**



**Plasmaspeed Motorized Model** | Choosing a 110/230 VAC Plasmaspeed motorized machine significantly reduces grinding



**Remote Cable Mini Drive** | Operate your Jolli Machine remotely when cutting large diameter pipe by attaching our flexible Drive Cable. Cable available in lengths of 9' (2.7m) and 14' (4.3m).



**Heavy Duty Storage Box** | Perfect for shipping and storing your Mathey Dearman Jolli Chain Machine, this rugged box is constructed from steel with a durable powder coat finish.

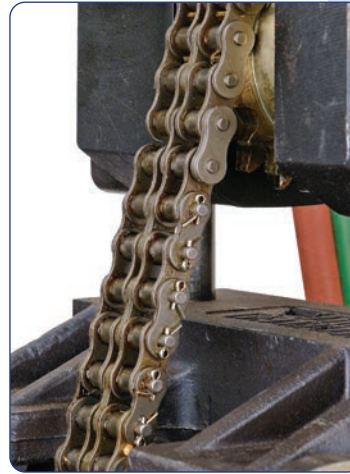
## Jolli Chain Machine | Accessories:

ACCESSORY DESCRIPTION	ITEM NUMBER	EST. SHIPPING WEIGHT
PLASMASPEED Mini Jolli Retrofit Kit, 110/230 VAC	05.0520.SA1	18 lbs. / 8.1 kg
Sliding Support for 2nd Torch	05.0510.180	1 lbs. / .5 kg
1 3/8" (35 mm) Torch Holder with 32-pitch pinion	05.0510.117	.7 lbs. / .3 kg
1 3/8" (35 mm) Torch Holder with metric pinion	05.0510.117E	.7 lbs. / .3 kg
9' (274 cm) Flexible Remote Drive Cable	05.0510.FDC	12 lbs. / 5.4 kg
14' (427 cm) Flexible Remote Drive Cable	05.0510.FD14	15 lbs. / 6.8 kg
Out-of-Round Roller Attachment	05.0520.300	7 lbs. / .3 kg
Storage Box	05.0520.BOX	28 lbs. / 12.7 kg
Protective Leather Sleeve for power cord (recommended)	05.0550.SLV	1.5 lbs. / 0.7 kg

**Note:** A step-down transformer is also available for international voltages.

## Mini Jolli Drive Chains

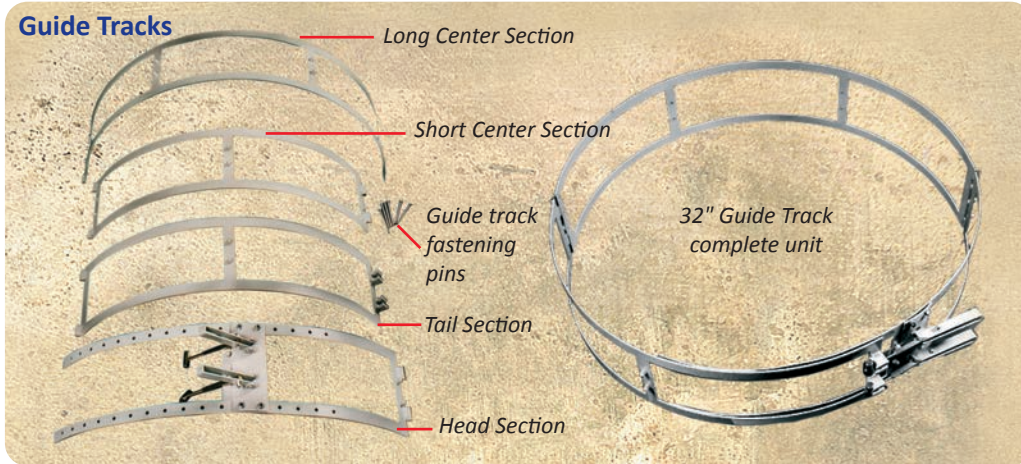
DESCRIPTION	WHEEL POSITION	ITEM NUMBER	EST. SHIPPING WEIGHT
Drive Chain Kit for 6" Pipe	2	01.0520.006	3 lbs. / 1.4 kg
Drive Chain Kit for 8" Pipe	2	01.0520.008	4 lbs. / 1.8 kg
Drive Chain Kit for 10" Pipe	2	01.0520.010	4 lbs. / 1.8 kg
Drive Chain Kit for 12" Pipe	2	01.0520.012	5 lbs. / 2 kg
Drive Chain Kit for 16" Pipe	2	01.0520.016	6 lbs. / 2.7 kg
Drive Chain Kit for 18" Pipe	2	01.0520.018	6 lbs. / 2.7 kg
Drive Chain Kit for 20" Pipe	2	01.0520.020	7 lbs. / 3 kg
Drive Chain Kit for 24" Pipe	2	01.0520.024	8 lbs. / 3.6 kg
Drive Chain Kit for 28" Pipe	2	01.0520.028	9 lbs. / 4 kg
Drive Chain Kit for 30" Pipe	2	01.0520.030	9 lbs. / 4 kg
Drive Chain Kit for 32" Pipe	2	01.0520.032	10 lbs. / 4.5 kg
Drive Chain Kit for 36" Pipe	2	01.0520.036	11 lbs. / 5 kg
Drive Chain Kit for 40" Pipe	2	01.0520.040	12 lbs. / 5.4 kg
Drive Chain Kit for 42" Pipe	2	01.0520.042	13 lbs. / 5.9 kg
Drive Chain Kit for 48" Pipe	2	01.0520.048	14 lbs. / 6.4 kg
Drive Chain Kit for 50" Pipe	2	01.0520.050	15 lbs. / 6.8 kg
Drive Chain Kit for 52" Pipe	2	01.0520.052	15 lbs. / 6.8 kg
Drive Chain Kit for 56" Pipe	2	01.0520.056	17 lbs. / 7.7 kg
Drive Chain Kit for 60" Pipe	2	01.0520.060	18 lbs. / 8.2 kg



### Double-Row

#### Cotter Pin Chain

Move quickly from one pipe size to another with our Double-row Cotter Pin Chain designed for the Mini Jolli Chain Machine. Simply remove the cotter pins to add or remove sections of chain. Every link is a master link.



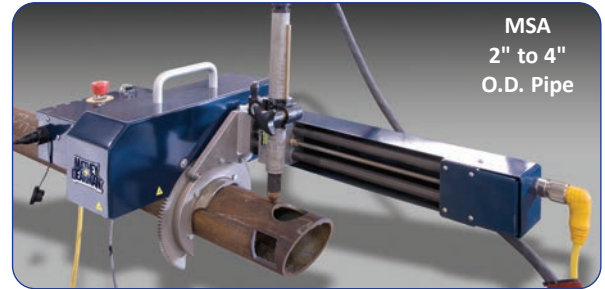
Mini Jolli Guide Tracks ensure optimum cut accuracy and fit-up while reducing set-up time up to 20%. Guide Tracks are designed for use on horizontal and vertical pipes 18" (457 mm) and larger.

## Guide Track Ordering Guide

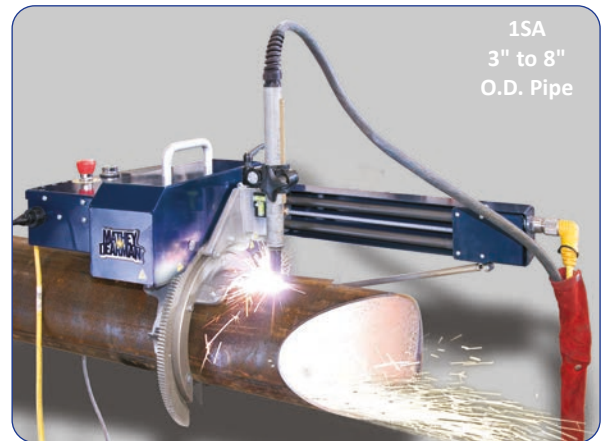
MODEL	HEAD SECTION	TAIL SECTION	SHORT CENTER SECTION	LONG CENTER SECTION
Mini Jolli	05.0520.013B	05.0520.013D	05.0520.013C	05.0520.013A
Weight (lbs. / kg)	4.7 / 2	3.6 / 1.6	3.2 / 1.5	4.3 / 2
PIPE RANGE IN (MM)	GUIDE TRACK SECTION(S) REQUIRED			
18 - 22 (458 - 559)	1	1	---	---
18 - 32 (610 - 813)	1	1	1	---
18 - 36 (864 - 914)	1	1	---	1
18 - 48 (1,118 - 1,219)	1	1	---	2
18 - 52 (1,270 - 1,321)	1	1	---	2
18 - 58 (1,372 - 1,473)	1	1	2	1
18 - 64 (1,524 - 1,625)	1	1	3	2
18 - 72 (1,674 - 1,829)	1	1	3	2

We've taken the industry's most trusted pipe cutting machines and made them...well, smarter.

For decades, CNC pipe profiling has been reserved for folks with big budgets, spare shop floor space and lots of time for training. Thanks to our amazingly simple and affordable CNC Saddle Machines, those days are long gone. With the industry's most trusted pipe cutting and beveling machines as their foundation, we've engineered a compact 2-axis pipe profiling system that performs like a big stationary machine, but without the complexity or cost. Lightweight enough to be mounted and operated by one person, three models of machines cover pipe sizes ranging from 2" to 12". Mathey CNC machines are able to produce an almost infinite number of profiles, like miters and saddles plus openings including rectangles and squares. Compared to time and material wasting manual methods, our CNC machines literally create precision profiles in just minutes. When not in use, storage and transportation are safe and secure thanks to the rugged molded HDPE case with custom-designed foam insert that is included with each machine. CNC Saddle Machines perform well with either oxy/fuel or plasma machine torches and require only standard 115 or 230-volt power to operate.



MSA  
2" to 4"  
O.D. Pipe



1SA  
3" to 8"  
O.D. Pipe



2SA  
6" to 12"  
O.D. Pipe

**Simple** | Icon-driven laptop control screens let users follow an intuitive cut selection process; *no programming required*

**Comprehensive** | Literally millions of cuts available including the ability to utilize custom shapes (Contact Mathey CNC support for details and pricing)

**Compact** | Portable design means no permanent installation or dedicated shop space necessary

**Adaptable** | Works with standard machine torches, including plasma

**Rugged** | Based on our proven and reliable Saddle Machines with industrial-grade electronics and cabling

### CNC Saddle Machines Include:

- 115/230 VAC CNC Saddle Machine Base Unit
- Lead Screw Assembly
- Torch Holder Assembly
- Boomer Assembly
- Industrial Grade Automation Connector Cable
- Spacer Bolt Set
- Parts and Operating Manual
- Computer to Machine Industrial USB Cable
- 15' Power Supply Cable
- Mathey CNC Software (USB Memory Stick) for Windows®
- HDPE Shipping and Storage Case w/ Custom Foam Insert



ITEM NUMBER	MODEL	PIPE SIZES (NPS)
03.0117.MSA	MSA	1½, 2, 2½, 3, 3½, 4
03.0117.1SA	1SA	3, 3½, 4, 5, 6, 8
03.0117.2SA	2SA	6, 8, 10, 12
03.0117.SET	All 3 Above	1½ thru 12
03.0117.000	Software Only	All Models



## Innovative pipefitter-friendly software interface:

### Step-by-step software gives you complete control

- Operates on a common Windows laptop
- Simple icon-driven control screens
- Step-by step cut selection process
- Requires little to no training, set up and make cuts in minutes
- Dynamic on-screen display of cut
- Cutting speed can be user controlled during cut
- Automatic storage of previous cuts
- Multiple cut sequencing for automating common tasks
- Plasma torch auto-fire and stop control



### CNC SADDLE MACHINE, PARTS / ACCESSORIES

PART NUMBER	DESCRIPTION	MODEL
03.0203.082	AC Power Cord	All
03.0117.SOFT	Operating Software ( 1 license )	All
03.0203.070	Yellow Lead Screw Assembly Cordset	All
03.0203.051	USB Cable	All
03.0203.101	Plasma connectivity cord, Hypertherm	All
03.0203.103	Plasma connectivity cord, Thermal Dynamics	All

PART NUMBER	DESCRIPTION	MODEL	SHIPPING WEIGHT		SHIPPING DIMENSIONS	
			LBS.	KG	IN	MM
05.0510.117	Torch Holder	ALL	0.7	0.3	6 x 6 x 4	152 x 152 x 102
03.0100.022	Drive Chain	MSA	0.4	0.2	6 x 6 x 4	152 x 152 x 102
03.0101.015	Drive Chain	1SA	0.5	0.2	6 x 6 x 4	152 x 152 x 102
03.0102.009	Drive Chain	2SA	0.6	0.3	6 x 6 x 4	152 x 152 x 102
03.0100.024	Boomer Assembly	MSA	0.5	0.2	6 x 6 x 4	152 x 152 x 102
03.0101.018	Boomer Assembly	1SA	0.9	0.4	6 x 6 x 4	152 x 152 x 102
03.0102.011	Boomer Assembly	2SA	1.1	0.5	6 x 6 x 4	152 x 152 x 102
03.0MSA.KIT	Spacer Bolt Kit	MSA	1.0	45.9	8 x 6 x 6	203 x 152 x 152
03.01SA.KIT	Spacer Bolt Kit	1SA	4.0	51.6	8 x 6 x 6	203 x 152 x 152
03.02SA.KIT	Spacer Bolt Kit	2SA	5.0	55.9	8 x 6 x 6	203 x 152 x 152

The ideal solution for cutting and beveling in close quarters, our Band Crawler requires as little as 6" (153 mm) of clearance around the pipe. Install the stainless steel Band anywhere on the pipe and it conforms to the pipe shape, producing a consistent precise bevel, even on severely out-of-round pipe. Our lightweight Band Crawler can be quickly set up and operated by one person on pipe as large as 60" (1,524 mm). Bands 48" (1,219 mm) and larger feature a standard stiffening rib which simplifies one-person set-up.



- Precise** | Band conforms precisely to the out-of-round condition of the pipe to maintain consistent cutting tip distance from pipe surface
- Simple** | One person can set up and cut horizontal or vertical pipes as large as 48" (1,219 mm)
- Low Profile** | Requires as little as 10½" (267 mm) of radial clearance
- One Size Fits All** | One Band Crawler fits all Band sizes
- Fast** | 60% faster than hand cutting and grinding
- Motorized** | Available with PlasmaSpeed Digital Motor Control

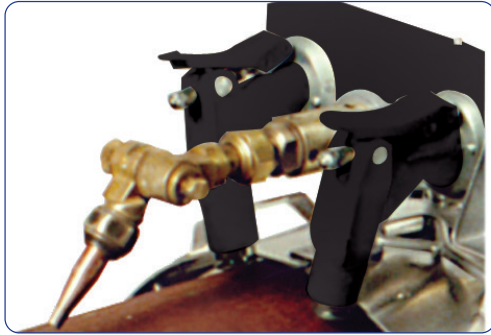
MODEL	ITEM NUMBER	EST. SHIPPING WEIGHT
Band Crawler with 9' (2.7m) Flexible Drive Cable	05.0116.009	26 lbs. / 11.7 kg
Band Crawler with 14' (4.3m) Flexible Drive Cable	05.0116.014	30 lbs. / 14 kg
Motorized PLASMASPEED Band Crawler 110/230 VAC	05.0116.S01	26 lbs. / 11.7 kg
PLASMASPEED Retro fit kit 110/230 VAC	05.0116.SA1	26 lbs. / 11.7 kg



- No more special sized bands, Better Bands Bridge the Gap - Up to 3 times more GAP allowance than any other Band on the market
- Patented "Staggered" Latching System for improved setup
- Ensures maximum traction for the beveling machine, maintaining 3 points of contact at all times
- Industry leading GAP allowance allows one size to work on Coated or Out of Round Pipe
- Consistent speed and travel of Beveling machine equals improved cut quality
- MADE IN USA

PIPE SIZE	ITEM NUMBER	EST. SHIP WEIGHT
6" / 152 mm	05.0204.006	5 lbs. / 2 kg
8" / 203 mm	05.0204.008	6 lbs. / 3 kg
10" / 254 mm	05.0204.010	7 lbs. / 3 kg
12" / 305 mm	05.0204.012	7 lbs. / 3 kg
14" / 356 mm	05.0204.014	11 lbs. / 5 kg
16" / 406 mm	05.0204.016	12 lbs. / 5 kg
18" / 457 mm	05.0204.018	14 lbs. / 6 kg
20" / 508 mm	05.0204.020	16 lbs. / 7 kg
22" / 559 mm	05.0204.022	17 lbs. / 8 kg
24" / 610 mm	05.0204.024	18 lbs. / 6 kg
26" / 660 mm	05.0204.026	20 lbs. / 9 kg
28" / 711 mm	05.0204.028	22 lbs. / 10 kg
30" / 762 mm	05.0204.030	25 lbs. / 11 kg
32" / 813 mm	05.0204.032	26 lbs. / 12 kg
34" / 864 mm	05.0204.034	27 lbs. / 12 kg
36" / 914 mm	05.0204.036	29 lbs. / 13 kg
38" / 965 mm	05.0204.038	31 lbs. / 14 kg
40" / 1016 mm	05.0204.040	33 lbs. / 15 kg
42" / 1067 mm	05.0204.042	36 lbs. / 16 kg
44" / 1118 mm	05.0204.044	39 lbs. / 18 kg
46" / 1168 mm	05.0204.046	43 lbs. / 20 kg
48" / 1219 mm	05.0204.048	90 lbs. / 41 kg
50" / 1270 mm	05.0204.050	92 lbs. / 42 kg
52" / 1321 mm	05.0204.052	96 lbs. / 44 kg
54" / 1372 mm	05.0204.054	100 lbs. / 45 kg
56" / 1422 mm	05.0204.056	106 lbs. / 48 kg
58" / 1473 mm	05.0204.058	110 lbs. / 50 kg
60" / 1524 mm	05.0204.060	115 lbs. / 52 kg

**Torch Angle Head Adapter** | Allows the torch tip to be adjusted for any angle from a square cut (no bevel) to a bevel angle up to 90 degrees while also allowing torch lead or lag angle adjustment.



**Right Angle Drive Adapter** | Permits the Flexible Drive Cable to pivot 180 degrees on the end of the Band Crawler, lowering the profile of the Crawler to 6" (153 mm).



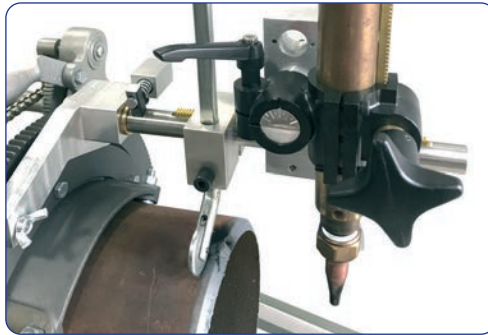
**PLASMASPEED** | The Motorized PLASMASPEED Band Crawler can increase cutting and beveling efficiency of large diameter pipes up to 60% and is the quickest and easiest cutting tool to set up on vertical pipe.



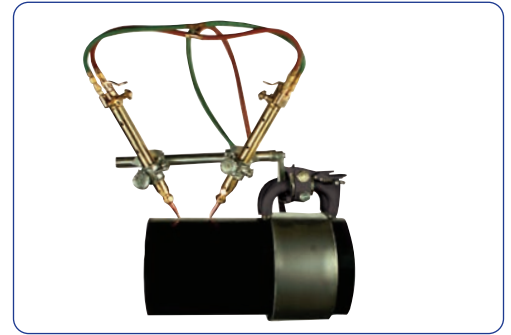
**Drive Cable** | Enables the motorized Band Crawler to be retrofitted to manual operation. Available in 9' (2.7m) and 14' (4.3m) lengths.



**Rack Adjustable Torch Arm** | Allows both horizontal and vertical adjustment of the torch in relationship to the pipe surface.

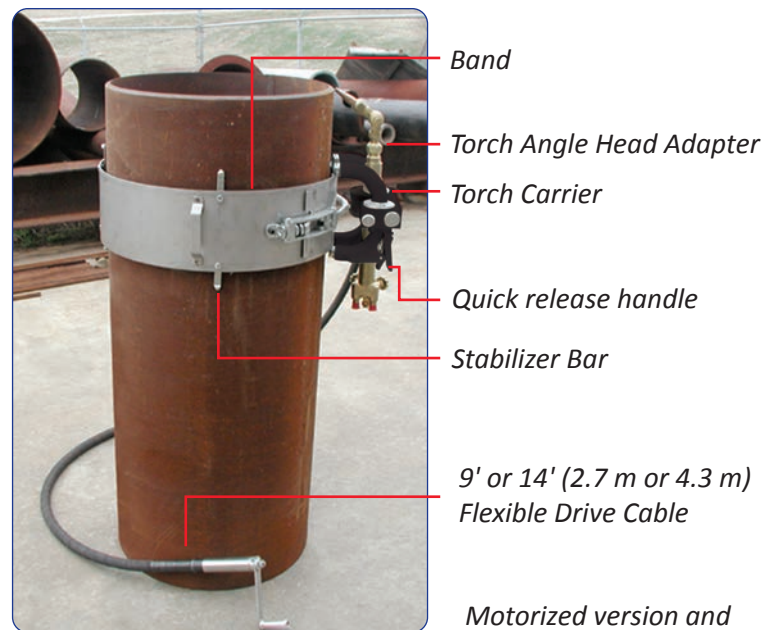


**Double Torch Arm** | Makes two cuts and bevels simultaneously, reducing cutting time and labor.



### Band Crawler Accessories

ITEM/ ASSEMBLY DESCRIPTION	ITEM NUMBER	EST. SHIPPING WEIGHT
PLASMASPEED Retro fit kit 110/230 VAC	05.0116.SA1	26 lbs. / 11.7 kg
Rack-Adjustable Torch Arm	05.0116.032	3 lbs. / 1.4 kg
Double Torch Arm	05.0116.039	4 lbs. / 1.8 kg
Right Angle Drive Adapter (for Drive Cable)	05.0116.030	2 lbs. / .9 kg
Torch Angle Head Adapter	05.0200.003	1.2 lbs. / .5 kg
Protective Leather Cable Sleeve	05.0550.SLV	1.5 lbs. / .7 kg



*Motorized version and motorizing kits available*



# MINIMAG XM PIPE / PLATE CUTTER AND WELDER



## MiniMag XM

The versatile MiniMag XM is an excellent tool for cutting, beveling, and welding. It requires minimum set-up time and secures to work surfaces with 300 pounds of magnetic force.

The MiniMag XM can be used with plasma or oxy-fuel torches, but unlike the larger MagnaCut XM, does not offer a motorized torch arm. The MiniMag XM cuts pipe and plate with a coating up to .015" thick, and will cut materials with wall thicknesses up to 3" (76 mm).

The MiniMag XM can also make flawless welds on steel plate and other flat surfaces, with travel speeds from 2" to 40" (51 mm to 1,016 mm) per minute.

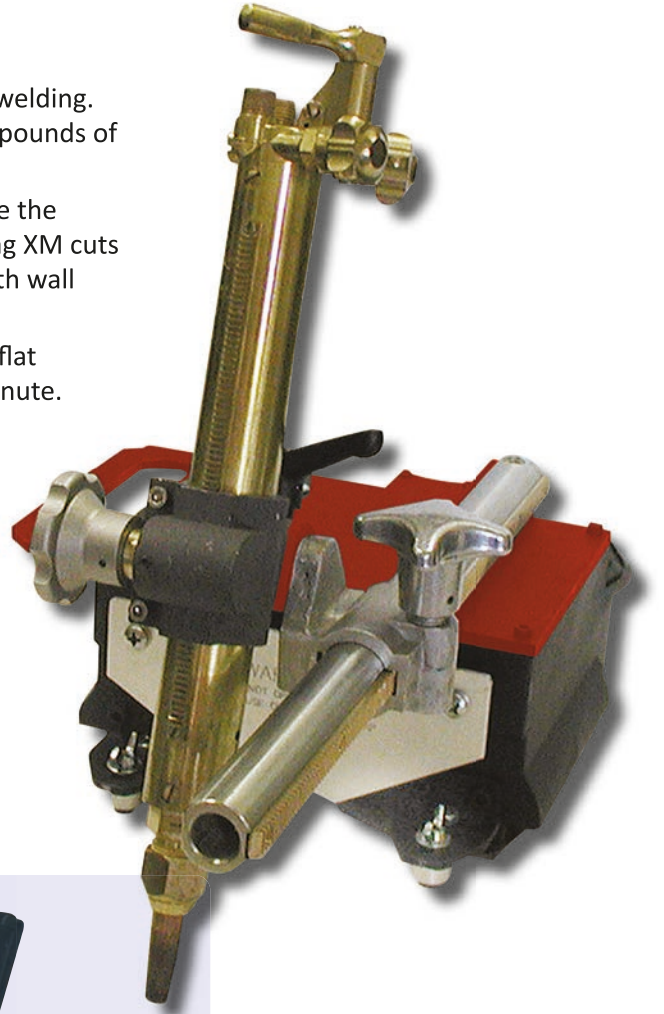
**Quick** | Sets up and is ready to cut in minutes

**Versatile** | Makes horizontal and vertical cuts, bevels plate and pipe at angles to 45 degrees

**Flexible** | Works with all standard torches (including plasma)

**Precise** | Meets even the most exacting cutting specifications

**Fast** | Up to 80% faster than cutting by hand



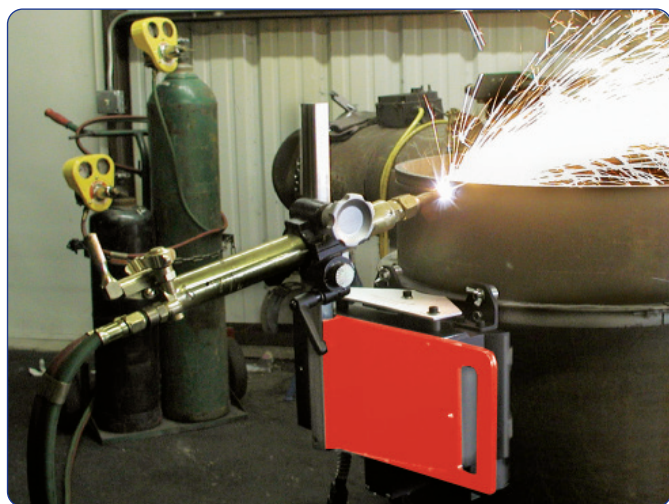
### Includes:

- 115 VAC or 230 VAC MiniMag XM Machine
- Storage Box
- Motor Control Box
- Torch Arm
- Torch Holder
- Sliding Support
- Safety Cable fits up to 24" (610 mm) pipe
- Snap Hooks (2)
- Cable Latch
- Protective Leather Cable Sleeve
- Parts and Operating Manual



## MiniMAG XM and Accessories

MODEL	ITEM NUMBER	EST. SHIPPING WEIGHT
MiniMag XM, 115 VAC	05.0550.MINIXM	39 lbs. / 17.6 kg
MiniMag XM, 230 VAC	05.0550.MINIXM2	39 lbs. / 17.6 kg



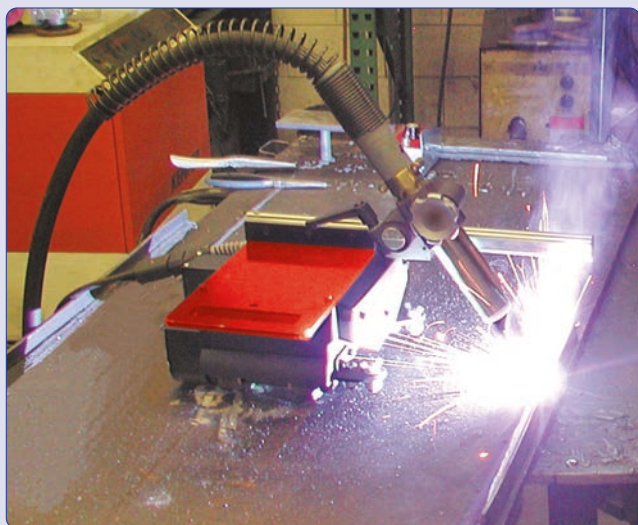
Cutting and welding on vertical pipe and plate is accomplished safely and with ease when the MiniMag XM is used with an optional Guide Track.

The ability to precisely control cutting speed helps the MiniMag XM and a plasma torch create perfect cuts and bevels that require little or no grinding.

### MiniMag XM Technical Specifications

DESCRIPTION	
Method of Attachment	Rare Earth Magnets
Holding Force	150 lbs. / 68 kg per Wheel Assembly 300 lbs. (136 Kg) Total
Set Up Time	2 Minutes or less
Minimum Cutting Range	O.D. - 6 $\frac{3}{8}$ " / 168 mm I.D. - 24" / 610 mm
Minimum Speed	2" / 51 mm per minute
Maximum Speed	40" / 1,016 mm per minute
Net Weight	31 lbs. / 14 kg
Shipping Dimensions	24" x 8 $\frac{7}{8}$ " x 19 $\frac{1}{2}$ " / 622 x 255 x 495 mm
DIMENSIONS	
Width	17" / 432 mm
Length	13" / 330 mm
Height	9" / 229 mm
Electrical Requirement	115 VAC or 230 VAC

### MiniMag XM Welding

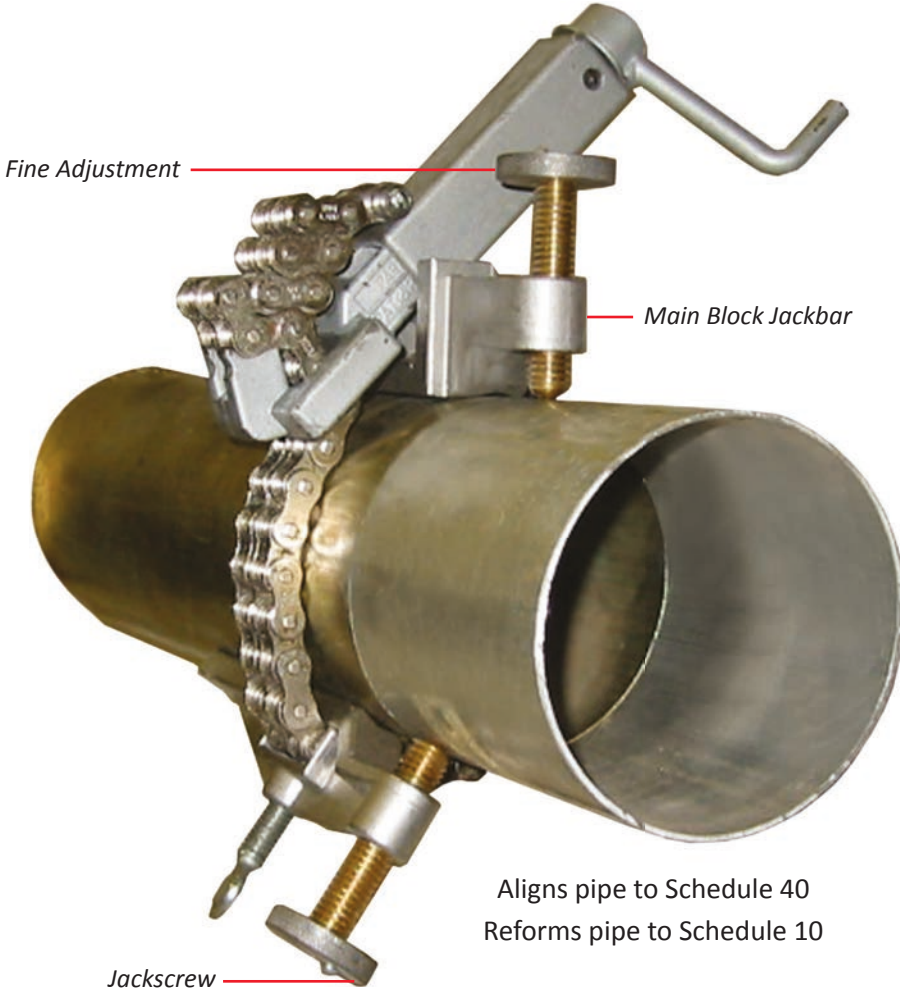


In addition to perfect cuts and bevels, the MiniMag XM can make flawless welds on steel plate and other flat surfaces, moving at speeds from 2" to 40" (51 mm to 1016 mm) per minute. The machine is remotely controlled by the handheld Motor Control Box, keeping the operator a safe distance from the work.

**CONTACT MATHEY DEARMAN TECHNICAL SALES FOR DETAILS ON WELDING WITH THE MINIMAG XM**

*Note: The minimag xm is equipped with guides that can be used with 1" x 1" x  $\frac{1}{8}$ " (25 mm x 25 mm x 3 mm) angle iron for vertical welding applications*

The Mini-Fit is an excellent tool to align and fit-up small tubes, pipes and fittings. It is extremely lightweight, easy to set up and adjust, is small enough to fit in the welder's toolbox, and requires no tools to use. This ingenious adaptation of our proven Chain Clamp design is perfect for light-duty applications. The Mini-Fit is tough enough to align 3/4" to 8" (19 mm to 203 mm) carbon or stainless steel pipe and fittings with a wall thickness up to Schedule 40 and will reform Schedule 10.



Aligns pipe to Schedule 40  
Reforms pipe to Schedule 10

**Lightweight** | Easy to carry and handle

**Economical** | Covers all pipe diameters from 3/4" to 8" (19 mm to 203 mm) with one clamp

**Accurate** | 3 Jackscrews help ensure perfect alignment on small diameter pipe and fittings

**Versatile** | Align pipe to Schedule 40, reform pipe to Schedule 10

**Strong** | Constructed with the same materials and methods as our larger heavy-duty Chain Clamps

**Mini-Fit Chain Clamps include:**

- Double-row chain (nickle plated carbon or stainless steel)
- Single Screw Jackbars listed for the pipe diameter
- Main Block Jackbar
- Parts and Operating Manual

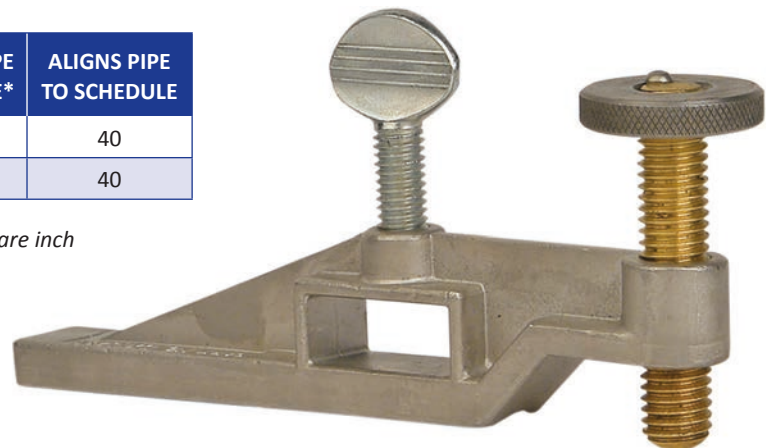
**Mini-Fit Single Screw Jackbar**

The end of the jackscrew is round to reduce the risk of marring the pipe.

MODEL	PIPE SIZE RANGE	NUMBER OF JACKBARS	REFORMS PIPE TO SCHEDULE*	ALIGNS PIPE TO SCHEDULE
D230	3/4" - 8" / 19 - 203 mm	2	10	40
D230SS	3/4" - 8" / 19 - 204 mm	2	10	40

\*Calculations are based on pipe with a tensile strength of 45,000 lbs. per square inch (3168 kg force per square centimeter).

SS - Indicates clamp is for stainless steel application.





The Mathey Dearman STURDI-CLAMP is ideal for Schedule 20 and below pipe alignment and reforming. Lighter weight than the original Mathey Dearman Chain Clamps, Mathey Dearman STURDI-CLAMPS are quick and easy to set up while still providing the ability to get excellent fitups on pipe from 1" to 36" (25 mm to 914 mm) diameter. Mathey Dearman STURDI-CLAMPS are available in carbon steel chain or stainless steel chain versions. ALL Mathey Dearman STURDI-CLAMPS feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination. Mathey Dearman STURDI-CLAMPS have the same Quality as all Mathey Dearman products but at a lesser cost than our Heavy Duty Clamping models.

**Precise Alignment** | Jackbars, spaced around the diameter of the pipe allow for precise alignment of joint

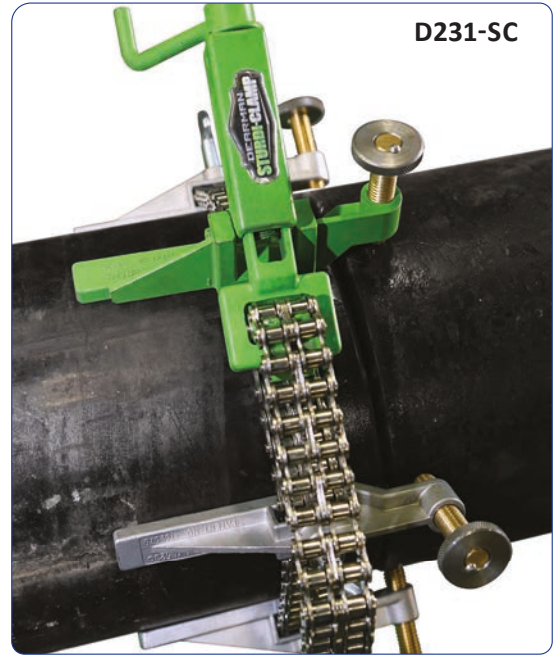
**Quality** | Same proven quality as other Dearman chain clamps

**Wide Range** | One Chain Clamp covers a wide range of pipe sizes

**Strength** | Aligns and Reforms pipe with wall thickness to Schedule 20

**Mathey Dearman STURDI-CLAMP Includes:**

- Nickel plated carbon steel or stainless steel duplex roller chain
- Stainless steel Single or Double Jackscrew Jackbars - quantity as indicated in specifications
- Stainless steel Main Block
- Jackscrew Breaker Bar and Socket
- Heavy-duty Storage Box\*
- Parts and Operating Manual



D231-SC



D235-SC

**Mathey Dearman Sturdi-Clamp Chain Clamp**

MODEL	NUMBER OF JACKBARS	PIPE SIZE RANGE	REFORMS PIPE TO SCHEDULE*	JACKBAR TYPE	EST. SHIPPING WEIGHT
D231-SC**	5	1" - 12" / 25 - 305 mm)	20	Single	13 lbs. / 6 kg
D231-SCSS**	5	1" - 12" / 25 - 305 mm)	20	Single	13 lbs. / 6 kg
D249-SC	7	4" - 20" / 102 - 508 mm)	20	Double	36 lbs. / 16.2 kg
D249SCSS	7	4" - 20" / 102 - 508 mm)	20	Double	36 lbs. / 16.2 kg
D235-SC	10	6" - 36" / 152 - 914 mm)	20	Double	90 lbs. / 40.5 kg
D235-SCSS	10	6" - 36" / 152 - 914 mm)	20	Double	90 lbs. / 40.5 kg

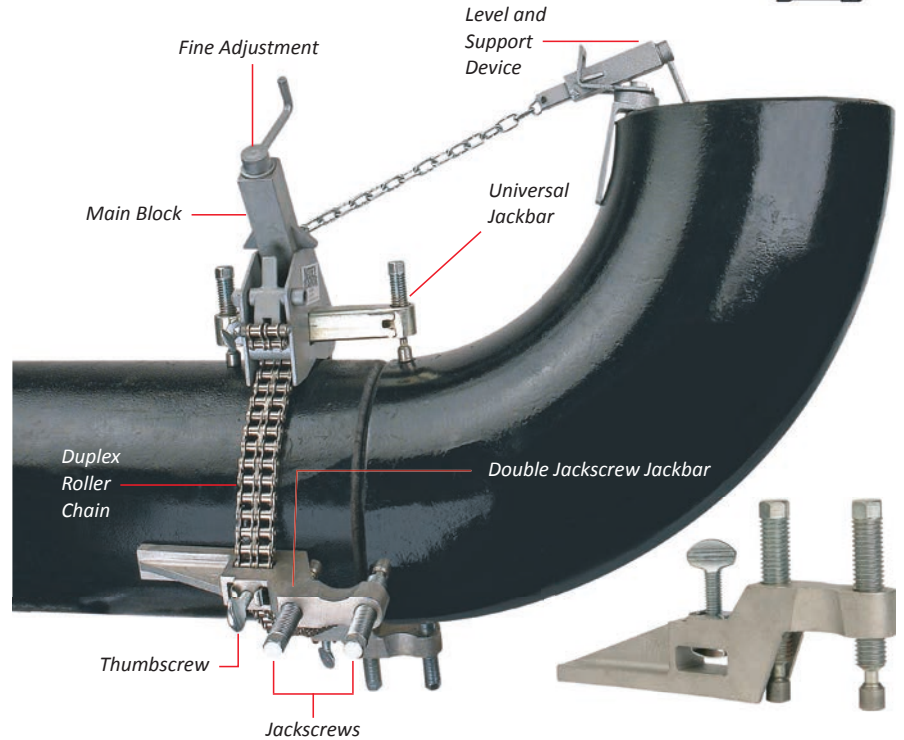
\* Calculations are based on pipe with a tensile strength of 45,000 lbs. per square inch (3,168 kg per square centimeter)

SS - INDICATES CLAMP IS FOR STAINLESS STEEL APPLICATION.

\*\* DOES NOT INCLUDE LEVEL AND SUPPORT DEVICE OR STORAGE BOX.

## Double Jackscrew Chain Clamp

Mathey Dearman's Double Jackscrew Chain Clamp reforms Schedule 40 pipe on either side of the joint to be welded. It is also able to exert pressure on the high points of both sides to eliminate "Hi-Low." The Chain Clamp's Level and Support Device allows the pipe, elbow, tee, flange and other fittings to be held securely in place during alignment and welding. Pipe with wall thicknesses up to Schedule 80 can be aligned with the Double Jackscrew Chain Clamp. Mathey Dearman Double Jackscrew Chain Clamps are available in carbon steel chain and stainless steel chain versions to fit pipe from 1" to 54" (25 mm to 1,372 mm) in diameter. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination.



**Extra Welding Clearance** | Jackbar design provides additional clearance, so the weld can be easily completed with clamp in place

**Precise Alignment** | Double Jackbars spaced around the diameter of the pipe allow reforming on both sides of joint to within  $\frac{1}{64}$ " (.4mm)

**Heavy Duty** | Aligns pipe with wall thickness up to Schedule 80

**Strong** | Reforms pipe with wall thickness to Schedule 40

**Wide Range** | Support, align, and reform elbow, tees, and other fittings that cage clamps can't; one Chain Clamp covers the range of 8 cage clamps

**Versatile** | With the standard Level and Support Device, the clamp can be configured to align, reform and support almost any type of fitting for welding

### Double Jackscrew Chain Clamp Includes:

- Nickel plated carbon steel or stainless steel duplex roller chain
- Stainless steel Double Jackscrew Jackbars - quantity as indicated in specifications
- Stainless steel Main Block
- Level and Support Device
- Jackscrew Breaker Bar with Socket
- Heavy-duty Storage Box
- Parts and Operating Manual

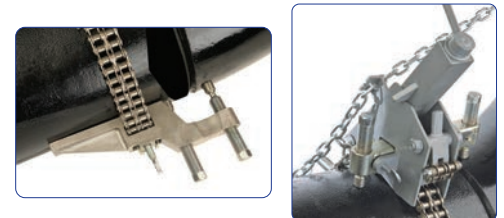
## Double Jackscrew Chain Clamp | Specifications

MODEL	NUMBER OF JACKBARS	NOMINAL PIPE SIZE RANGE	REFORMS PIPE TO SCHEDULE*	ALIGNS PIPE TO SCHEDULE	EST. SHIPPING WEIGHT
D250	3	1" - 8" / 25 - 203 mm	40	80	27 lbs. / 12 kg
D250SS	3	1" - 8" / 25 - 203 mm	40	80	27 lbs. / 12 kg
D249	7	4" - 16" / 102 - 406 mm	40	80	72 lbs. / 33 kg
D249SS	7	4" - 16" / 102 - 406 mm	40	80	72 lbs. / 33 kg
D235	8	10" - 36" / 254 - 914 mm	40	80	144 lbs. / 67 kg
D235SS	8	10" - 36" / 254 - 914 mm	40	80	144 lbs. / 67 kg
D236	13	10" - 54" / 254 - 1,372 mm	40	80	180 lbs. / 72 kg
D236SS	13	10" - 54" / 254 - 1,372 mm	40	80	180 lbs. / 72 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs. per square inch (3,164 kg per square centimeter)

SS - Indicates clamp Includes stainless steel chain. All clamps are equipped with stainless steel Jackbars, Jackscrews, and Main Blocks.

**WARNING:** THE DOUBLE JACKSCREW CHAIN CLAMP SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.





## Double Chain Clamp | D251 Series

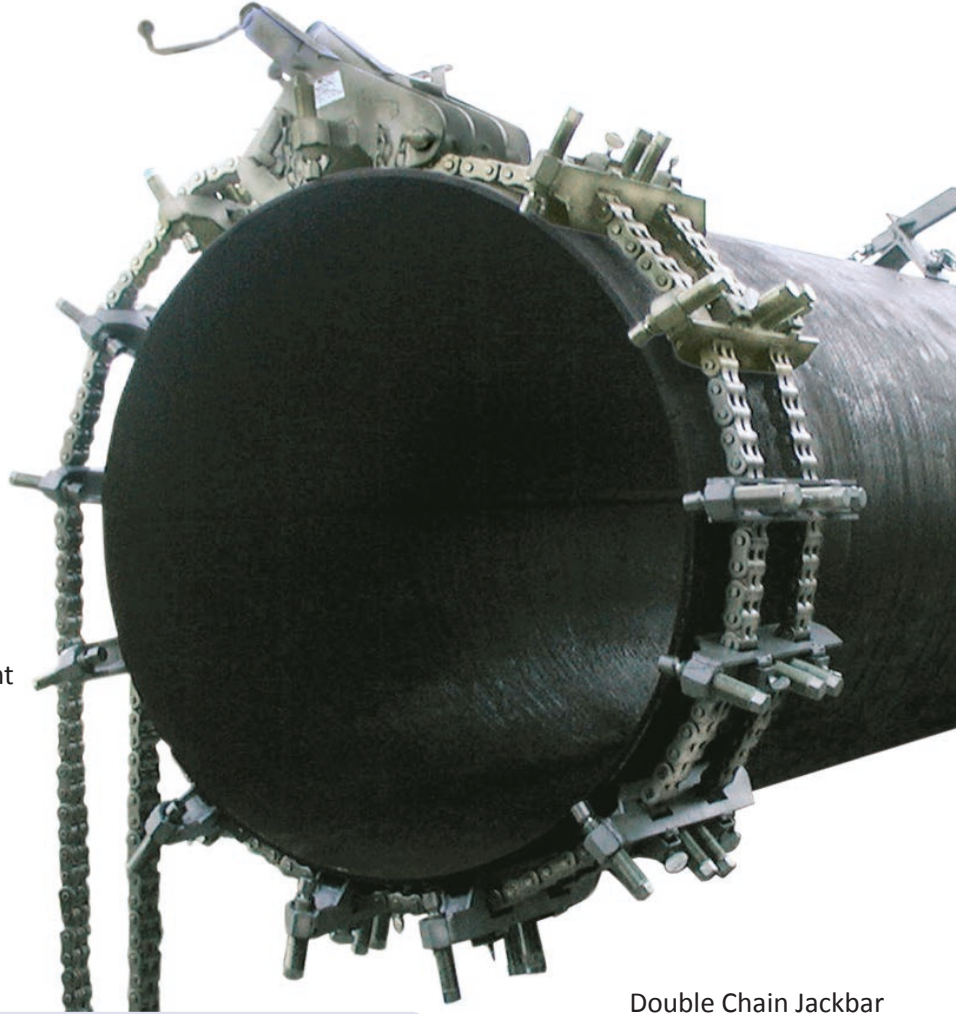
The Mathey Dearman Double Chain Clamp is a heavy-duty vessel clamp designed for alignment and reforming of pipes and vessels up to 20' (6 m) in diameter with Schedule 80 wall thickness. Our Double Chain Clamps also align Schedule 80 pipe and heavier when no reforming is required. The extra heavy-duty Jackbars and Main Block provide the brute strength necessary to accomplish even the toughest reforming jobs. Models 10" to 36" through 10" to 54" come with a Level and Support Device. All other models come with a cable hoist. The Double Chain Clamp is available in steel and stainless steel versions and is shipped in a wooden crate.

**Precise** | Numerous Jackbars provide clamping pressure exactly where needed for perfect alignment

**Tough** | Reforms and aligns pipe with Schedule 80 wall thickness

**Adaptable** | Fits extremely large range of pipe diameters

**Conforming** | Jackbar pads pivot independently to handle uneven pipe and fitting surfaces



Double Chain Jackbar

### Double Chain Clamp Includes:

- 2 Nickel plated or stainless steel high-strength leaf chains
- Extra heavy-duty stainless steel Jackbars-quantity as listed in specifications
- Double chain Main block with 2 Fine Adjustments
- Level and Support Device (D251-1060 model and larger supplied with cable hoist)
- Jackscrew Breaker Bar with Socket
- Parts and Operating Manual



MagSquare Magnets are now standard with all DOUBLE CHAIN CLAMPS to make setup simple and easy.



Joints on large pipe or tube shells up to 20' (6,096 mm) in diameter can be aligned, reformed and welded without removing the clamp, saving time and improving weld quality.

## Double Chain Clamp | Specifications

NUMBER	NUMBER OF MAIN BLOCKS	NUMBER OF JACKBARS	PIPE SIZE RANGE	EST. SHIPPING WEIGHT
D251-1036	1	9	10" - 36" / 254 - 914 mm	220 lbs. / 100 kg
D251-1036SS	1	9	10" - 48" / 254 - 914 mm	220 lbs. / 100 kg
D251-1048	1	12	10" - 48" / 254 - 1,219 mm	278 lbs. / 126 kg
D251-1048SS	1	12	10" - 48" / 254 - 1,219 mm	278 lbs. / 126 kg
D251-1054	1	14	10" - 54" / 254 - 1,372 mm	300 lbs. / 136 kg
D251-1054SS	1	14	10" - 54" / 254 - 1,372 mm	300 lbs. / 136 kg
D251-1060	1	16	10" - 60" / 254 - 1,524 mm	328 lbs. / 149 kg
D251-1060SS	1	16	10" - 60" / 254 - 1,524 mm	328 lbs. / 149 kg
D251-1072	1	20	10" - 72" / 254 - 1,829 mm	387 lbs. / 176 kg
D251-1072SS	1	20	10" - 72" / 254 - 1,829 mm	387 lbs. / 176 kg
D251-1084	1	24	10" - 84" / 254 - 2,134 mm	442 lbs. / 200 kg
D251-1084SS	1	24	10" - 84" / 254 - 2,134 mm	442 lbs. / 200 kg
D251-1096	2	28	10" - 96" / 254 - 2,438 mm	498 lbs. / 226 kg
D251-1096SS	2	28	10" - 96" / 254 - 2,438 mm	498 lbs. / 226 kg
D251-10108	2	32	10" - 108" / 254 - 2,743 mm	554 lbs. / 251 kg
D251-10108SS	2	32	10" - 108" / 254 - 2,743 mm	554 lbs. / 251 kg
D251-10120	2	36	10" - 120" / 254 - 3,048 mm	610 lbs. / 277 kg
D251-10120SS	2	36	10" - 120" / 254 - 3,048 mm	610 lbs. / 277 kg
D251-1011F	2	39	10" - 132" / 254 - 3,353 mm	660 lbs. / 299 kg
D251-1011FSS	2	39	10" - 132" / 254 - 3,353 mm	660 lbs. / 299 kg
D251-1012F	2	42	10" - 144" / 254 - 3,658 mm	710 lbs. / 322 kg
D251-1012FSS	2	42	10" - 144" / 254 - 3,658 mm	710 lbs. / 322 kg
D251-1014F	2	48	10" - 168" / 254 - 4,267 mm	810 lbs. / 367 kg
D251-1014FSS	2	48	10" - 168" / 254 - 4,267 mm	810 lbs. / 367 kg
D251-1016F	3	54	10" - 192" / 254 - 4,877 mm	910 lbs. / 410 kg
D251-1016FSS	3	54	10" - 192" / 254 - 4,877 mm	910 lbs. / 410 kg
D251-1018F	3	60	10" - 216" / 254 - 5,486 mm	1,010 lbs. / 455 kg
D251-1018FSS	3	60	10" - 216" / 254 - 5,486 mm	1,010 lbs. / 455 kg
D251-1020F	3	66	10" - 240" / 254 - 6,096 mm	1,110 lbs. / 500 kg
D251-1020FSS	3	66	10" - 240" / 254 - 6,096 mm	1,110 lbs. / 500 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs. per square inch (3,164 kg per square centimeter).

SS - Indicates clamp is for stainless steel application.

**Note:** All double chain clamps with 16 or more jackbars include cable hoist. Smaller clamps include level and support device.

### Hydraulic Closure Mechanism

Perfect for clamping larger diameters and applying extra clamp load, Mathey Dearman's Hydraulic Chain Clamp Closure Mechanism uses a 5" (127 mm) stroke to apply up to 10,000 pounds (4535kg) of tension to the standard Double Chain Clamp. Hydraulic pressure is supplied to the closure mechanism's hydraulic cylinder by a hand pump with reservoir. Tension can be applied to close the clamp on the pipe. Using the Hydraulic Closure Mechanism, our Double Chain Clamp is able to align pipe up to Schedule 120 and reform pipe to Schedule 80.



### D251 Series Hydraulic Closure Mechanism

MODEL	DESCRIPTION	EST. SHIPPING WEIGHT
DD-580	Hydraulic closure mechanism for D251 Double Chain Clamp	43 lbs. / 20 kg
D104-KIT	Hydraulic kit includes manual hydraulic pump, reservoir and hoses needed for operation	12 lbs. / 5 kg



**Manual Hydraulic Pump Kit**



**DD-580 Hydraulic Closure Mechanism**

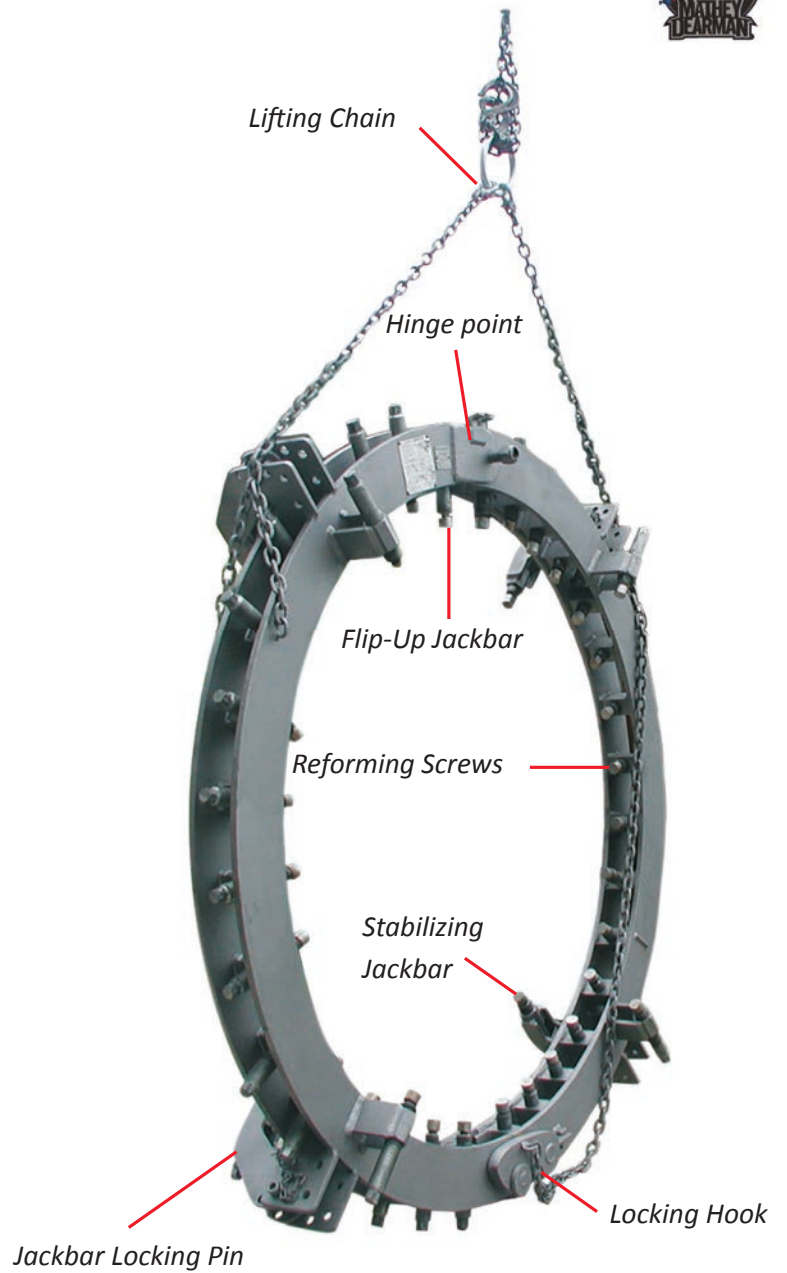
The Hydraulic Closure Mechanism can be added to a previously purchased Double Chain Clamp.



## Rim Clamps

Mathey Dearman Rim Clamps are built for tough reforming jobs and are ideal for applications requiring 100% weld and grind without releasing clamping pressure. Symmetrically placed Jackscrews apply pressure on high points to precisely reform and align pipe or shells. All surfaces of the Rim Clamp in contact with the pipe are made of stainless steel enabling the Clamp to be used on a variety of materials.

Mathey Dearman Rim Clamps will reform 45,000 PSI tensile strength pipe up to Schedule 80, with out-of-round conditions up to 2" (51 mm), depending on wall thickness.



- Accurate** | Apply reforming pressure exactly where required
- Strong** | Corrects out-of-round conditions up to 2" (51 mm)
- Easy** | Self-latching design, 14" (356 mm) and larger, makes installation simple and safe
- Versatile** | Handles a range of pipe sizes and materials

The 14" to 16" (356 mm to 406 mm) and larger Rim Clamp closes over the pipe automatically, for quick and simple operation.

## Mega Rim Clamps

For reforming high tensile strength pipe, there is nothing like a Mathey Dearman Mega Rim Clamp.

Our Mega Rim Clamps align and reform high tensile strength X65, X70 and X80 pipe with wall thicknesses up to 1 $\frac{3}{8}$ " (35 mm). Capable of reforming pipe with an out-of-round condition of up to 2" (51 mm), this clamp's performance comes from the heavy-duty oval shaped Side Plates, Latching Mechanism, and flip-up Jackbars for mating pipes and fittings.

The Mega Rim's hinged flip-up Jackbars are precisely positioned on the Clamp so they can be rotated away from the primary pipe for insertion of the mating pipe, valve or fitting and to facilitate welding and grinding. The independent pivoting pads of the Jackscrews compensate for uneven pipe surfaces. To avoid the risk of contamination, all surfaces of the Mega Rim Clamp that contact the pipe are made of stainless steel.

**EXTREME CAPACITY** | Reforms even high tensile strength pipe  
**ACCURATE** | Corrects out-of-round conditions up to 2" (51 mm)  
**VERSATILE** | Allows for 100% weld and grind without releasing clamp pressure

**WARNINGS:** CONTACT MATHEY DEARMAN WHEN PIPE IS CLAD WITH MATERIALS SUCH AS INCONEL OR TITANIUM. AS TEMPERATURES FALL BELOW 0 DEGREES FAHRENHEIT (-18 CELSIUS), REFORMING CAPABILITY RAPIDLY DECREASES.

### Reforming Capability - Maximum Wall Thickness for Specified Material Tensile Strength

CLAMP TYPE	PIPE TENSILE STRENGTH		PIPE DIAMETER							
	PSI	MPA	4" - 12" 102 - 305 mm	14" - 24" 356 - 610 mm	26" - 30" 660 - 762 mm	32" - 48" 813 - 1,219 mm	50" - 60" 1,270 - 1,524 mm	62" - 72" 1,575 - 1,829 mm		
RIM	45,000	310	PIPE WALL THICKNESS *							
			1/2" / 13 mm	3/4" / 19 mm	7/8" / 22 mm	1" / 25 mm	1 1/8" / 29 mm	1 1/4" / 32 mm		
MEGA RIM	65,000	448	1/2" / 11 mm	3/4" / 19 mm	1" / 25 mm	1 1/8" / 29 mm	1 1/4" / 32 mm	1 3/8" / 35 mm		
			70,000	483	5/8" / 11 mm	3/4" / 16 mm	3/4" / 19 mm	1" / 25 mm	1 1/8" / 29 mm	1 3/8" / 35 mm
			70,000	483	3/8" / 10 mm	1/2" / 13 mm	3/4" / 19 mm	7/8" / 22 mm	1" / 25 mm	1 1/4" / 32 mm
			80,000	552	3/8" / 10 mm	1/2" / 13 mm	5/8" / 16 mm	3/4" / 19 mm	1" / 25 mm	1 1/8" / 29 mm

\* Calculations based on material temperature of 72° F (22° C)

### Rim Clamp

RIM CLAMP ITEM NO.	PIPE SIZE RANGE	ESTIMATED SHIPPING WEIGHT
D711-0406	Standard Rim Clamp 4" - 6"	4 - 6 lbs. / 102 - 152 kg
D711-0608	Standard Rim Clamp 6" - 8"	6 - 8 lbs. / 152 - 203 kg
D711-0810	Standard Rim Clamp 8" - 10"	8 - 10 lbs. / 203 - 254 kg
D711-1012	Standard Rim Clamp 10" - 12"	10 - 12 lbs. / 254 - 305 kg
D711-1214	Standard Rim Clamp 12" - 14"	12 - 14 lbs. / 305 - 356 kg
D711-1420M	Mega Rim Clamp 14" - 20"	14 - 20 lbs. / 356 - 406 kg
D711-1824M	Mega Rim Clamp 18" - 24"	18 - 24 lbs. / 457 - 610 kg
D711-2026M	Mega Rim Clamp 20" - 26"	20 - 26 lbs. / 508 - 660 kg
D711-2632M	Mega Rim Clamp 26" - 32"	36 - 32 lbs. / 660 - 813 kg
D711-3036M	Mega Rim Clamp 30" - 36"	30 - 36 lbs. / 762 - 914 kg
D711-3440M	Mega Rim Clamp 34" - 40"	34 - 40 lbs. / 864 - 1,016 kg
D711-3844M	Mega Rim Clamp 38" - 44"	38 - 44 lbs. / 965 - 1,118 kg
D711-4248M	Mega Rim Clamp 42" - 48"	42 - 48 lbs. / 1,067 - 1,219 kg
D711-4450M	Mega Rim Clamp 44" - 50"	44 - 50 lbs. / 1,118 - 1,270 kg
D711-4652M	Mega Rim Clamp 46" - 52"	46 - 52 lbs. / 1,168 - 1,321 kg
D711-5056M	Mega Rim Clamp 50" - 56"	50 - 56 lbs. / 1,270 - 1,422 kg
D711-5460M	Mega Rim Clamp 54" - 60"	54 - 60 lbs. / 1,372 - 1,524 kg

Additional sizes available



- One clamp works on multiple pipe sizes
- Able to do light reforming to correct ovality in the pipe
- Able to push or pull the pipe joint together to attain the proper gap
- Works on Carbon Steels, Stainless Steels, and Alloys
- Clamp can work on multiple types of joints
- Split Frame Rim Style Clamp with turnbuckles, solid steel frames

### All SuperClamps Include:

- Parts and Operating Manual
- Jackscrews with Swivel Pads
- Jackscrew Breaker Bar and Socket



**Align, Reform AND SET  
THE WELD GAP with a  
few turns of a wrench**

### SuperClamp Reforming Abilities

DEARMAN SUPERCLAMP - HD			
MODEL PART NO.	REFORMS TO SCHEDULE	ALIGNS TO SCHEDULE	PIPE SIZE RANGE
SC-RC-0612HD	40	80	6" - 12" / 152 - 305 mm
SC-RC-1218HD	40	80	12" - 18" / 305 - 457 mm
SC-RC-1824HD	40	80	18" - 24" / 457 - 610 mm
SC-RC-2430HD	40	80	24" - 30" / 610 - 762 mm
SC-RC-3036HD	40	80	30" - 36" / 762 - 914 mm

SUPERCLAMP	PIPE OD	FOR MAX 1/16" OUT OF ROUND CONDITION					FOR MAX 1/8" OUT OF ROUND CONDITION				
		SCHEDULE					SCHEDULE				
		10	20	30	40	STD	10	20	30	40	STD
SC-RC-0612	6	---	---	---	---	---	---	---	---	---	---
SC-RC-0612	8	x	---	---	---	---	---	---	---	---	---
SC-RC-0612	10	x	x	---	---	---	---	---	---	---	---
SC-RC-0612	12	x	x	x	x	x	x	---	---	---	---
SC-RC-1218	12	x	x	---	---	---	---	---	---	---	---
SC-RC-1218	14	x	x	x	---	x	---	---	---	---	---
SC-RC-1218	16	x	x	x	---	x	x	---	---	---	---
SC-RC-1218	18	x	x	x	x	x	x	x	---	---	---
SC-RC-1824	18	x	x	x	---	x	---	---	---	---	---
SC-RC-1824	20	x	x	x	---	x	x	---	---	---	---
SC-RC-1824	22	x	x	x	---	x	x	---	---	---	---
SC-RC-1824	24	x	x	x	x	x	x	x	---	---	x
SC-RC-2430	24	x	x	x	---	x	x	---	---	---	---
SC-RC-2430	26	x	x	---	---	x	x	---	---	---	x
SC-RC-2430	28	x	x	x	---	x	x	---	---	---	x
SC-RC-2430	30	x	x	x	---	x	x	x	---	---	x
SC-RC-3036	30	x	x	x	---	x	x	---	---	---	x
SC-RC-3036	32	x	x	x	x	x	x	---	---	---	x
SC-RC-3036	34	x	x	x	x	x	x	x	---	---	x
SC-RC-3036	36	x	x	x	x	x	x	x	---	---	x

## The Dearman Hydraulic Sleeve Clamps

In THE DEARMAN SYSTEM tradition, we're excited to introduce a faster and safer way to install sleeves and fittings - Dearman Sleeve Clamps. Leveraging our industry-leading clamping technology, we've built these extreme-duty clamps to handle welded sleeves up to 3/4" thick and up to 70,000 PSI tensile strength. Unlike the common and unsafe application of a bottle jack and chain, our purpose-built clamps provide virtually 360 degrees of clamping force for perfect fit-ups. Our easy to operate hydraulic closure system makes set up and removal easy and quick.

Why risk the chance for flying jacks and falling sleeves when finally, there's a better solution?

All models feature 2-speed hydraulic hand pumps for quicker installation time and high-strength modular design for safer handling. Choose from 4 models of clamps for your specific need and application - 5,000 PSI or 10,000 PSI of clamping pressure and 6" to 24" or 6" to 48" range for sleeves up to 3/4" (19mm) thick. All clamps include a rugged steel transportation and storage box.



**DB-724**  
5,000 PSI



**DC-724**  
10,000 PSI

- Safe** | No unstable bottle jacks to suddenly slip and disengage
- Precise** | Equal clamping force provides better fit-up
- Easy to Handle** | Engineered to be installed by one person
- Adaptable** | Fits a wide range of pipe sizes and sleeve thicknesses
- Durable** | Rugged corrosion-resistant construction for years of use

### UNSAFE



### SAFE



### Dearman Sleeve Clamps Include:

- Nickel plated carbon steel duplex roller chain (DB models) or Nickel plated carbon steel leaf chain (DC models) for pipe size range
- High strength stainless steel Main Block with hydraulic cylinder
- 2-Speed hand operated hydraulic pump
- Heavy duty transportation and storage box
- Parts and Operating Manual

## Dearman Hydraulic Sleeve Clamp

MODEL	PIPE SIZE RANGE	CLAMPING PRESSURE	CHAIN	WEIGHT – SLEEVE CLAMP ONLY	SHIPPING WEIGHT
DB-724	6" - 24" (152 - 610 mm)	5,000 p.s.i.	DB-300	31 lbs. / 14 kg	76 lbs. / 34 kg
DB-748	6" - 48" (152 - 1,219 mm)	5,000 p.s.i.	DB-300	48 lbs. / 22 kg	93 lbs. / 42 kg
DC-724	6" - 24" (152 - 610 mm)	10,000 p.s.i.	DC-300	50 lbs. / 23 kg	94 lbs./ 43 kg
DC-748	6" - 48" (152 - 1,219 mm)	10,000 p.s.i.	DC-300	81 lbs. / 37 kg	125 lbs./ 57 kg

## Cage Clamps

Mathey Dearman Cage Clamps are available in Hand-lever, Ratchet, and Hydraulic models in either tack or no-tack versions, ranging in sizes for pipes 2" to 60" (51 mm to 1,524 mm). Our Cage Clamps will align pipe through Schedule 80. Cage Clamps are intended for alignment use only and are not designed to reform pipe. Each size Clamp fits one specific pipe diameter. If the O.D. of the pipe varies more than +/- 3/16" (5 mm) from the indicated clamp diameter, pipes may not align accurately.

## Hand Lever Cage Clamp

HAND-LEVER TACK MODEL	HAND-LEVER NO-TACK MODEL	PIPE SIZE
01.0505.001	---	2" / 51 mm
01.0505.002	---	3" / 76 mm
01.0505.003	01.0505.N03	3.5" / 89 mm
01.0505.004	01.0505.N04	4" / 102 mm
01.0505.005	01.0505.N05	5" / 127 mm
01.0505.006	01.0505.N06	6" / 152 mm
01.0505.008	01.0505.N08	8" / 203 mm
01.0505.010	01.0505.N10	10" / 254 mm
01.0505.012	01.0505.N12	12" / 305 mm
01.0505.014	01.0505.N14	14" / 356 mm
01.0505.016	01.0505.N16	16" / 406 mm
01.0505.018	01.0505.N18	18" / 457 mm
01.0505.020	01.0505.N20	20" / 508 mm
01.0505.022	01.0505.N22	22" / 559 mm
01.0505.024	01.0505.N24	24" / 610 mm
01.0505.026	01.0505.N26	26" / 660 mm
01.0505.028	01.0505.N28	28" / 711 mm
01.0505.030	01.0505.N30	30" / 762 mm
01.0505.032	01.0505.N32	32" / 813 mm
01.0505.034	01.0505.N34	34" / 864 mm
01.0505.036	01.0505.N36	36" / 914 mm
01.0505.038	01.0505.N38	38" / 965 mm
01.0505.040	01.0505.N40	40" / 1,016 mm
01.0505.042	01.0505.N42	42" / 1,067 mm
01.0505.048	01.0505.N48	48" / 1,219 mm
01.0505.054	01.0505.N54	54" / 1,372 mm
01.0505.060	01.0505.N60	60" / 1,524 mm

Clamps with stainless steel contact points or for odd-size pipe available on request. Add SS at end of part number for stainless steel.



No-tack cross bars are arched to permit a full-circle weld without removing the clamp. The no-tack clamp can help increase welding quality and efficiency.

## Cage Clamp Cross Bar Designs



Tack-type straight cross bars have flared ends so pipes can be moved easily into position and clamped. After the pipe is tack welded, the clamp is removed from the pipe and the weld is completed.



Tack and no-tack cross bars are available in stainless steel for stainless and other specialty alloy applications.

## Ratchet Cage Clamp

The ratchet closure system of Mathey Dearman's Ratchet Cage Clamp provides the extra force needed to align large pipe diameters. The Ratchet Cage Clamp is available for 14" to 60" (356 mm to 1,524 mm) pipe.



RATCHET TACK MODEL	RATCHET NO-TACK MODEL	PIPE SIZE
01.0505.R06	---	6" / 152 mm
01.0505.R08	---	8" / 203 mm
01.0505.R10	---	10" / 254 mm
01.0505.R12	---	12" / 305 mm
01.0505.R14	01.0505.RN14	14" / 356 mm
01.0505.R16	01.0505.RN16	16" / 406 mm
01.0505.R18	01.0505.RN18	18" / 457 mm
01.0505.R20	01.0505.RN20	20" / 508 mm
01.0505.R22	01.0505.RN22	22" / 559 mm
01.0505.R24	01.0505.RN24	24" / 610 mm
01.0505.R26	01.0505.RN26	26" / 660 mm
01.0505.R28	01.0505.RN28	28" / 711 mm
01.0505.R30	01.0505.RN30	30" / 762 mm
01.0505.R32	01.0505.RN32	32" / 812 mm
01.0505.R34	---	34" / 864 mm
01.0505.R36	01.0505.RN36	36" / 914 mm
01.0505.R38	01.0505.RN38	38" / 965 mm
01.0505.R40	01.0505.RN40	40" / 1,016 mm
01.0505.R42	01.0505.RN42	42" / 1,067 mm
01.0505.R48	01.0505.RN48	48" / 1,219 mm
---	01.0505.RN54	54" / 1,372 mm
---	01.0505.RN60	60" / 1,524 mm



### Ratchet Wrench

(Handle must be ordered separately)

#### 01-0505-R01

¾" Ratchet Wrench for 4" - 8" Ratchet Clamps

#### 01-0505-R02

⅞" Ratchet Wrench for 10" - 42" Ratchet Clamps

#### 01-0505-R03

1" Ratchet Wrench for 44" - up Ratchet Clamps

*Clamps with stainless steel contact points or for odd-size pipe available on request.*



No-tack cross bars are arched to permit a full-circle weld without removing the Clamp. The no-tack Clamp can help increase welding quality and efficiency.

## Cage Clamp Cross Bar Designs



Tack-type straight cross bars have flared ends so pipes can be moved easily into position and clamped. After the pipe is tack welded, the clamp is removed from the pipe and the weld is completed.



Tack and no-tack cross bars are available in stainless steel for stainless and other specialty alloy applications.



## Hydraulic Cage Clamp

Mathey Dearman's Hydraulic Cage Clamp utilizes a rugged hydraulic closure mechanism to create the extra force necessary to align large pipe diameters while also permitting the rapid release of the clamp from the pipe. The Hydraulic Cage Clamp is available for 16" to 60" (406 mm to 1,524 mm) pipe.

HYDRAULIC TACK MODEL	HYDRAULIC NO-TACK MODEL	PIPE SIZE
01.0505.H16	01.0505.HN16	16" / 406 mm
01.0505.H18	01.0505.HN18	18" / 457 mm
01.0505.H20	01.0505.HN20	20" / 508 mm
01.0505.H22	01.0505.HN22	22" / 559 mm
01.0505.H24	01.0505.HN24	24" / 610 mm
01.0505.H26	01.0505.HN26	26" / 660 mm
01.0505.H28	01.0505.HN28	28" / 711 mm
01.0505.H30	01.0505.HN30	30" / 762 mm
01.0505.H32	01.0505.HN32	32" / 812 mm
01.0505.H34	01.0505.HN34	34" / 864 mm
01.0505.H36	01.0505.HN36	36" / 914 mm
01.0505.H38	01.0505.HN38	38" / 965 mm
01.0505.H40	01.0505.HN40	40" / 1,016 mm
01.0505.H42	01.0505.HN42	42" / 1,067 mm
01.0505.H48	01.0505.HN48	48" / 1,219 mm
01.0505.H54	01.0505.HN54	54" / 1,372 mm
01.0505.H60	01.0505.HN60	60" / 1,524 mm
01.0505.H00	Hydraulic Jack	

Clamps with stainless steel contact points or for odd-size pipe available on request.

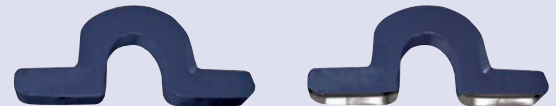


Hydraulic Cage Clamps permit faster pipe alignment and quick release of the clamp from the pipe after welding.

## Cage Clamp Cross Bar Designs



Tack-type straight cross bars have flared ends so pipes can be moved easily into position and clamped. After the pipe is tack welded, the clamp is removed from the pipe and the weld is completed.



No-tack cross bars are arched to permit a full-circle weld without removing the Clamp. The no-tack Clamp can help increase welding quality and efficiency.



Tack and no-tack cross bars are available in stainless steel for stainless and other specialty alloy applications.



This classic design high-low alignment clamp has been in use in the U.S. for years. With a durable, yet cost effective fabricated design, the PDQ Clamp fits up to 14" pipe and is available in three sizes. Sold with stainless steel contact points.

Note: PDQ clamps are not to be used as lifting devices.

### Specifications

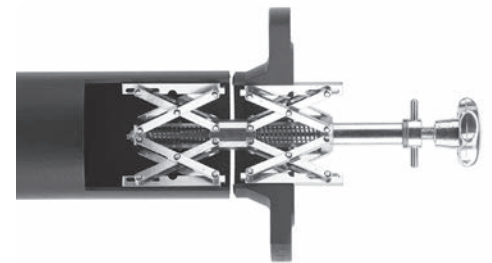
- Available in three sizes for 1" - 14" pipe fit-up.
- Durable Acme thread design used for years in the field.
- Lightweight design is great for overhead work.
- With stainless steel contact points standard, the PDQ is ready for exotic pipe fabrication out of the box.
- Great for most types of fit-ups. Pipe to pipe, pipe to elbow and pipe to flange amongst others.
- The most cost effective yet durable high-low fit-up clamp on the market.

### Quick-Fit PDQ Clamp | Specifications

ITEM NUMBER	DESCRIPTION	RANGE	WEIGHT
1220	Quick-Fit PDQ Clamp	1" - 3" / 25 - 76 mm	4 lbs. / 1.81 kg
1221	Quick-Fit PDQ Clamp	2" - 6" / 50 - 152 mm	11 lbs. / 4.99 kg
1222	Quick-Fit PDQ Clamp	6" - 14" / 152 - 355 mm	18 lbs. / 8.16 kg

# E-Z FIT SPIDER INTERNAL CLAMPS

This model has two independent expanding clamps, allowing independent alignment of two hollow cylindrical components of different diameters. The bottom expanding clamp is inserted and clamped in the pipe by means of the knob. Then the other part (e.g. a flange) is placed over the top expanding clamp and clamped by means of the hand-bar. This model is specially suited for heavy parts. All locating rails are in Stainless Steel.



### SPIDER CLAMP - SERIES 400

ITEM NUMBER	CLAMPING RANGE	WEIGHT
400-1SS*	2.13" - 5.51" / 54 - 140 mm	3 lbs. / 1.25 kg
400-2SS*	3.35" - 8.66" / 85 - 220 mm	8 lbs. / 3.6 kg
400-3SS*	4.72" - 13.78" / 120 - 350 mm	23 lbs. / 10.5 kg
400-4SS*	7.09" - 20.47" / 180 - 520 mm	60 lbs. / 27 kg
400-5SS*	15.75" - 35.43" / 400 - 900 mm	86 lbs. / 39 kg

\* SS = Stainless Steel



## FLANGE PINS



Mathey Dearman stainless steel Flange Line-up Pins (FLUPS) are available in two styles - Slide-lock and Wobble-nut. Both designs feature a spring-loaded arrangement that enables removal even when flanges expand from welding heat. The Slide-lock style features an easy to use locking lever for release, while the Wobble-nut style uses a clever design that requires less than one spin of the nut to disengage for removal. The wide profile supports a level or square solidly when used in pairs.

ITEM NUMBER	MODEL / ASSEMBLY DESCRIPTION	FLANGE HOLE DIAMETER RANGE
05.0100.000	Slide-lock FLUP	$\frac{3}{8}$ " - $1\frac{1}{8}$ " / 16 - 47 mm
05.0100.010	Wobble-nut FLUP	$\frac{3}{8}$ " - $1\frac{1}{8}$ " / 16 - 47 mm



Slide-lock FLUP

Wobble-nut FLUP



Easy and quick, our FLUPS are sturdy and extremely precise.



## PUSH-BUTTON CARBON STEEL FLANGE LINE UP PINS

Introducing the latest addition to the Mathey Dearman Flange Line Up Pins (FLUP) range, our new push-button carbon steel model. The new Flange Line Up Pin installs and removes quickly thanks to its convenient push-button operation. Rugged ACME thread and rust-resistant black oxide coated carbon steel means you can expect years of reliable use. Our most affordable FLUP still provides the accuracy and ease of use that you've come to expect from quality Mathey Dearman pipefitting tools.

ITEM NUMBER	MODEL / ASSEMBLY DESCRIPTION	FLANGE HOLE DIAMETER RANGE
05.0100.020	Push-button Carbon Steel FLUP	$\frac{3}{8}$ " - $1\frac{1}{8}$ " / 16 - 47 mm



Push-button FLUP



## FLANGE PINS

PN 2120



$\frac{1}{2}$ " -  $1\frac{1}{2}$ " Flange holes

PN 2124



$\frac{1}{4}$ " -  $\frac{3}{8}$ " Flange holes

### Features

B&B has two sizes of flange pins, aka "two hole pins" for precise flange leveling and alignment. The PN 2120 are steel pins with built in levels eliminating the need for two additional level tools. These flange pins fit-up  $1\frac{1}{2}$ " flange holes and have a "wobble" nut that acts as a quick release feature reducing time setting up and breaking down flange alignment. The PN 2124 are smaller stainless steel mini pins that fit flange holes up to 1". The knurled surfaces are an additional feature that allow snug flange hole fitting that increases accuracy during flange alignment.

### Specifications

- B&B Flange Pins are an economical and efficient way to align flanges.
- PN 2120 for use in  $\frac{1}{2}$ " -  $1\frac{1}{2}$ " holes, PN 2124 for  $\frac{1}{4}$ " -  $\frac{3}{8}$ " holes.
- PN 2120 are steel with a durable zinc coated finish.
- PN 2120 offers a quick release handle and a level built into each tool.
- PN 2124 are made of stainless steel for exotic flange fit-ups.
- Both flange pins offer knurled handles for increase grip and tightening ability.
- All items come in retail packaging.



# FAB BOLTS (FLANGE ALIGNMENT BOLTS)



**Step 2:** Place second bolt into mis-aligned holes and turn bolt to align both flange faces



Safe, fast, and effective solution for even the toughest flange alignment jobs. The tool's tapered shaft eliminates hammering and prying when lining up flange bolt holes.

- Safer** | Eliminates the need for wedges or hammers
- Protects** | Greatly reduces risk of damage to the flange face

**Step 1:** Place first bolt into pair of aligned holes

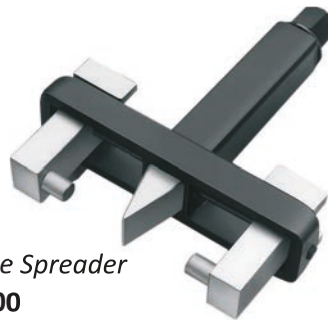
PART NUMBER	DESCRIPTION
FAB.138	1 3/8" FAB
FAB.114	1 1/4" FAB
FAB.118	1 1/8" FAB
FAB.100	1" FAB
FAB.078	7/8" FAB
FAB.034	3/4" FAB
FAB.BOX	Tool Box Only
FAB.KIT	FAB Kit Containing 1 SET of: 3/4", 7/8", 1", 1 1/8", 1 1/4" and 1 3/8"



# FLANGE SPREADER



Hydraulic Flange Spreader  
ITEM NO. D103



Mechanical Flange Spreader  
ITEM NO. D100

**Note:** Flange Spreaders are sold individually. Most applications require two (2) spreaders.



A pair of Flange Spreaders quickly separates flanges up to 1 1/4" (32 mm) without damage to the flange sealing area.

Mathey Dearman Flange Spreaders separate flanges safely and easily without hammering. The spreader, which attaches to the flange holes, spreads the flange faces without damaging flange sealing surfaces. The wedge action of the spreader widens the gap between flanges up to 1 1/4" (32 mm). 100 ft-lbs. of torque applied to the Flange Spreader yields up to 12,000 lbs. of spreading force.

Hydraulic Flange Spreaders are available for 2" - 36" (51 mm - 914 mm) flanges and use a Hydraulic Pump Kit (sold separately) to easily separate flanges.



ITEM NUMBER	STYLE	FLANGE SIZE	FLANGE CLASS
D100	Mechanical	2" - 12" / 51 - 305 mm	Up to 300 lbs.
D103	Hydraulic	2" - 12" / 51 - 305 mm	Up to 300 lbs.
D101	Hydraulic	12" - 24" / 305 - 610 mm	150 - 600 lbs.
D102	Hydraulic	26" - 36" / 66 - 914 mm	150 - 600 lbs.
D104-KIT	Hydraulic Pump Kit includes pump with reservoir, hoses and quick disconnects.		



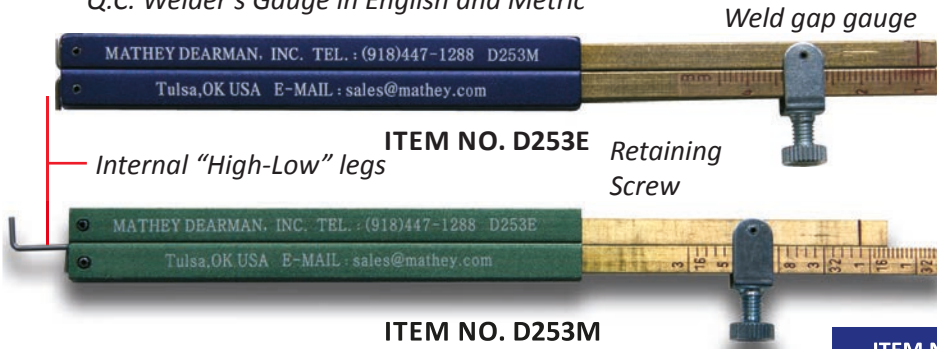
Hydraulic Pump Kit  
ITEM NO. D104-KIT



## Q.C. WELDER'S GAUGE



Q.C. Welder's Gauge in English and Metric



The Q.C. Welder's Gauge from Mathey Dearman rapidly and accurately measures inside "High-Low" and plate mismatch before and after welding, minimizing weld rejections. The gauge is available in English and Metric models.

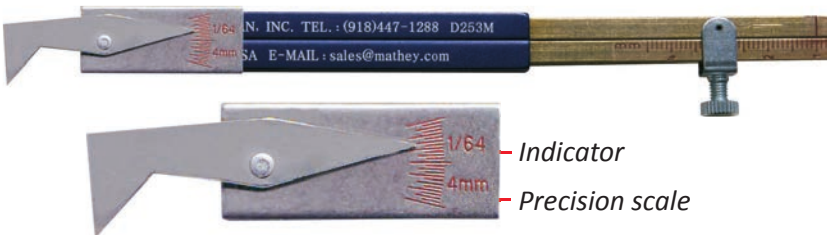
ITEM NUMBER	DESCRIPTION
D253E	English Q.C. Welder's Gauge
D253M	Metric Q.C. Welder's Gauge
BOX	
D253E-BOX	English Q.C. Welder's Gauge (10 ea)
D253M-BOX	Metric Q.C. Welder's Gauge (10 ea)



## PIT DEPTH GAUGE

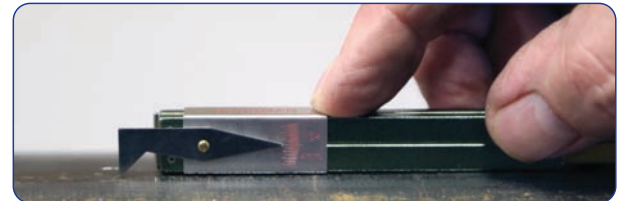
**PRECISE** | Measures as small as  $\frac{1}{64}$ " (.4 mm)

**EASY** | Simply slide the Pit Depth Gauge over the Q.C. Gauge and take the reading



Measurement  $\frac{1}{64}$ <sup>th</sup> or .4 mm increments.

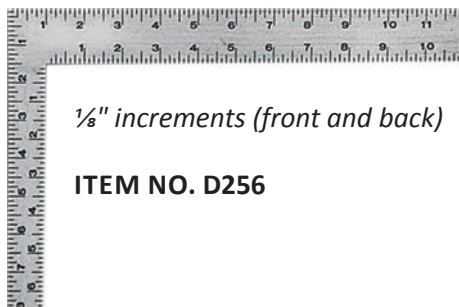
The Pit Depth Gauge accessory measures pit depth, weld height and outside "High-Low". The stainless steel Pit Depth Gauge mounts on the end of the Q.C. Welder's Gauge housing and displays in both English and Metric measurements.



The Pit Depth Gauge can be used to check weld undercut and misalignment of plate to plate or pipe to pipe.



## FRAMING SQUARE



$\frac{1}{8}$ " increments (front and back)

ITEM NO. D256

The Small Stainless Steel Framing Square from Mathey Dearman measures angles, squareness, and find pipe centerline. When used with a level, the Square measures drops in inches per foot to determine slope. The Square is marked in  $\frac{1}{8}$ " increments.

ITEM NUMBER	DESCRIPTION	BLADE LENGTH ST X LG X THICK
D256	Small Stainless Steel Framing Square	8" x 12" x $\frac{1}{16}$ " Thick (203 x 305 x 1.6 mm Thick)

*TAN chart is located on the back*

**ITEM NO. D248**

The Stainless Steel Pipefitter's Square from Mathey Dearman is THE ONLY precision Square designed specifically for pipefitters, boilermakers, welders and layout persons. After becoming familiar with the scales and tables of the Square, many complex problems encountered during pipe fit-up and layout work are easily solved.

*Set-backs for fit-up of pipe to elbow*

ITEM NUMBER	DESCRIPTION	BLADE LENGT ST X LG X THICK
D248	Pipefitter's Square	15½" x 24" x ⅛" Thick (394 x 610 x 3 mm Thick)

The Pipefitter's Square can be used to layout a variety of joint configurations, such as miters, tees and diagonals.

### Pipefitter's Square may be used to:

- Check the squareness of one surface to another
- Find pipe center line
- Determine the flange bolt length and diameter
- Find the number of bolt holes in a flange
- Measure center-to-end dimensions of pipe elbows and tees
- Find the through-hub length of a flange
- Determine the outside diameter of a weld neck flange
- Determine arc length for a given radius
- Measure angles off horizontal or vertical plane with level
- Measure in 12ths or 16ths of an inch
- Solve triangles or offsets
- Find decimal equivalents
- Layout a variety of weld joint configurations

The Large Protractor will measure squareness of pipe ends up to 40" (1,016 mm) diameter or can be used to check large pipe miter angles up to 180°. Leg lengths of 48" (1,219 mm) and 36" (194 mm).

The Small Protractor is an excellent tool for sheet metal layout, checking squareness of pipe ends up to 17" (432 mm) diameter. It has a large 18" (457mm) leg, a shorter 12" (305mm) leg and it is accurate to ± 1°.

The Mini Protractor can be used for a variety of applications including measuring bevel angle.

ITEM NUMBER	DESCRIPTION
DXX-250	Mini Stainless Steel Protractor
DK-239	Small Stainless Steel Protractor
DK-100	Large Aluminum Protractor

**ITEM NO. DXX-250**

*Length: 6" (152 mm)*



**ITEM NO. DK-239**





## PIPE WRAP

Mathey Dearman Pipe Wrap has double-ruled edges so it is never upside down or backwards. The Wrap can be used as a straight edge to mark straight lines around the pipe and to mark angles for pipe elbows. The Pipe Wrap is constructed of highly abrasion and solvent resistant materials to last under heavy use.

PIPE SIZE	SIZE	ITEM NUMBER	DESCRIPTION
3" - 15" 76 - 381 mm	Medium	D160	Wrap, 4" x 4' / 102 mm x 1219 mm
3" - 22" 76 - 559 mm	Large	D170	Wrap, 4" x 6' / 102 mm x 1829 mm
3" - 26" 76 - 660 mm	Extra Large	D177	Wrap, 4" x 7' / 102 mm x 2134 mm
Pipe size to be specified	---	D184	4" / 102 mm Width x Length Desired Sold in 1' / 305 mm Increments*
Pipe size to be specified	---	D185	5" / 127 mm Width x Length Desired Sold in 1' / 305 mm Increments*
Pipe size to be specified	---	D187	7" / 178 mm Width x Length Desired Sold in 1' / 305mm Increments*

### Pipe Wrap Includes:

- Table of tangents and straight edge
- Instructions for cutting elbows
- Sides marked in 1/8" (3.2 mm) increments to 36" (914 mm)
- Instructions for finding the length of an elbow
- 45-degree angle chart
- Degree markings

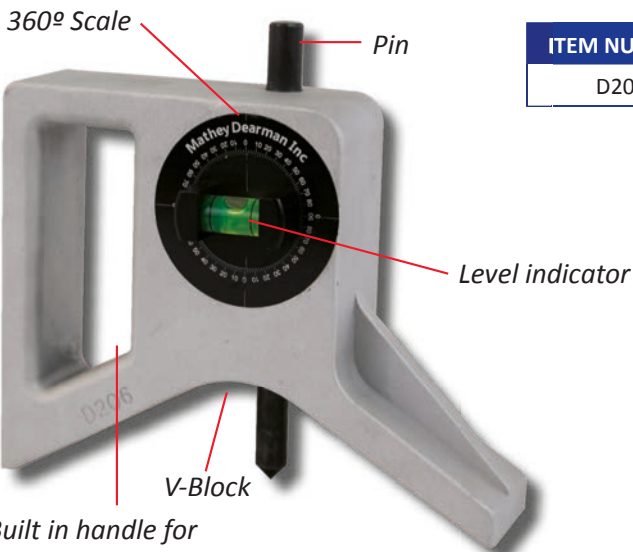


The Pipe Wrap is an excellent tool for aligning MagnaCut XM Guide Tracks on pipe over 18" (457 mm) to insure a square cut.  
\* Pipe Wrap sold per foot does not have any markings or instructions.



## CENTERING HEAD

Mathey Dearman's Centering Head provides a quick and accurate method for establishing pipe centerline, locating points on tanks or pipes, measuring slope, establishing angles and laying keyways. The Centering Head dial face is marked in 2 1/2 degree increments, and can also be used to measure and mark points around the pipe flange or fitting.



Built in handle for safe and easy use

ITEM NUMBER	DESCRIPTION
D206	Centering Head, pipe 1/2" (13 mm) and larger

**TRUE** | Precisely locates top dead center

**EASY** | Simple and quick to use

**VERSATILE** | Use to find points on shafts, tanks, or pipe

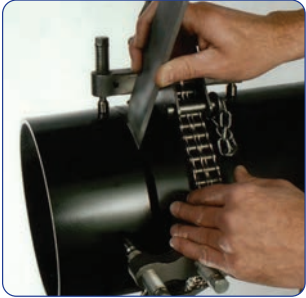




# SPACING WEDGES



When using Mathey Dearman Chain Clamps, Spacing Wedges enable better fit-up of pipe ends. Wedges are used to create precise weld gap. Simply move the pipe ends together, mount and tighten the chain clamp or cage clamp and spread the gap to the desired width using the Spacing Wedge. The wedge portion of the Spacing Wedge is case hardened for long life, while the upper part of the Wedge is soft enough to prevent splintering.



Purchase individually, or in boxes of ten (10) each.



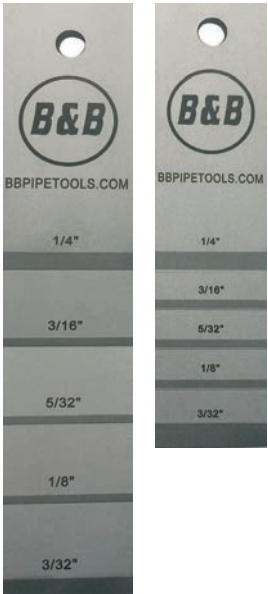
ITEM NUMBER	DESCRIPTION
D271	Spacing Wedge, 8" x 1½" x ¼" (203 mm x 38 mm x 6.4 mm)
D272	Spacing Wedge, 3½" x 1½" x ¼" (89 mm x 38 mm x 6.4 mm)
D274	Spacing Wedge, 4" x ¾" x ¼" (102 mm x 19 mm x 6.4 mm)
BOXES OF 10	
D271-BOX	D271 Spacing Wedge - Box of 10
D272-BOX	D272 Spacing Wedge - Box of 10
D274-BOX	D274 Spacing Wedge - Box of 10

Weld gap can be quickly set using our Spacing Wedges.

Clip to belt or hang in tool box.



# STEPPED WEDGES



PN 2130  
PN 2131  
PN 2132



### Features

The B&B Stepped Wedge is a patent pending design that merges two tools into one. A pipe wedge can be used to pry, push and pull pipe in many applications, while a pipe gauge is used to insure proper gap dimensions pre-weld. The Stepped Wedge accomplishes both functions in one tool. Many other features and uses make this a must have tool for the pipe fabricators tool box. An additional feature is the wedges stainless steel construction material. That means the pipe fabricator can use the wedges in steel or stainless steel fit-ups, and the stainless steels hard surface lends itself to extended use. Please note, product is compromised once used on steel materials.

### Specifications

- Two tools in one. Wedge and Gauge.
- Pull or push for gap width adjustments.
- Allows full line of sight during fit-up.
- Unique hole allows fall protection lanyard and wedge extraction.
- Landings can be measured quickly and accurately.
- Can be used with a standard wedge or alone.
- Efficient and easy to use.
- Available at a great price!

PN	DESCRIPTION	DIMENSIONS
2130	Stepped Wedge™ (Small)	¾" width x 4" length
2131	Stepped Wedge™ (Medium)	1 ½" width x 6" length
2132	Stepped Wedge™ (Large)	1 ¾" width x 8" length



Mathey Pipe Cradles and Slings are an effective way to move pipe, specifically designed for pipeline installation projects. Mathey currently offers cradles from 2" - 36" and all are equipped with 4 inch urethane "round cut" wheels with sealed anti-friction bearings. All spreader bar designs are third party tested and comply with industry standards. These models are equipped with 5/8" wire rope and all rope is swaged and certified at a wire rope rigging company partnered with Mathey.

### Features and Advantages

- Durable 95a urethane coating designed for multiple uses
- Sealed anti-friction bearings
- Measures 4" tread width x 4.5" diameter
- 5/8" wire rope, swaged by a partnered third party wire rope distributor
- Machined hub for smooth wheel rotation



2001



2002



2003



2004

Sealed Bearing wheels with protective metal end flange. Great urethane replacement roller for most other brands. 4" x 6" with radius cutout for pipe shape and designed for 5/8" wire rope.

4" Roller  
PN 90024



ITEM NUMBER	DESCRIPTION	LOAD CAPACITY
2001-3	Roller Sling 2" - 8"	1,300 kg / 3,000 lbs.
2001-4	Roller Sling 2" - 12"	1,300 kg / 3,000 lbs.
2001-5	Roller Sling 2" - 18"	1,300 kg / 3,000 lbs.
2001-7	Roller Sling 2" - 24"	1,300 kg / 3,000 lbs.
2002	2 Strand Roller Cradle 6" - 12"	7,710 kg / 17,000 lbs.
2003	2 Strand Roller Cradle 12" - 24"	7,710 kg / 17,000 lbs.
2004	4 Strand Roller Cradle 12" - 24"	12,700 kg / 28,000 lbs.
2005	2 Strand Roller Cradle 24" - 36"	12,813 kg / 28,250 lbs.
2006	4 Strand Roller Cradle 24" - 36"	25,700 kg / 56,500 lbs.

## Features

Mathey Beam Clamp Rollers have fully compatible parts that can change from a pipe rack clamping roller to a pipeline launcher in just a few minutes. The unique clamping system fastens the roller to an I-beam from both sides of the flange. This option is great for installing and fabricating pipe in pipe racks or other tight and enclosed areas. Also, the roller mechanism can be attached to a stand better suited for pipeline work and/or directional drilling.



PN 2115 - 2" - 24" - 2,500 lbs.



PN 2115 HD - 2" - 24" - 7,500 lbs.



PN 2126 - 4" - 48" - 10,000 lbs.



PN 2126 HD - 4" - 48" - 20,000 lbs.



PN 2136 - 16" - 60" - 10,000 lbs.



PN 2136 HD - 16" - 60" - 20,000 lbs.

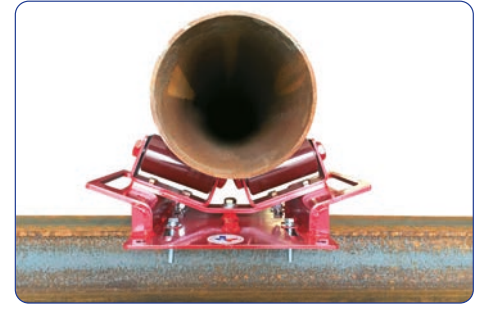
## Specifications

- Replaceable urethane roller wheels unbolt in seconds.
- Convenient and safe carry handles.
- Converts from pipe launcher to beam roller.
- Pipe Launchers nest and stack efficiently for shipping and storage.
- Easy part replacement with modular design.
- Add wheels to convert standard capacity to heavy-duty capacity.
- From 2" - 60" pipe capacity.
- Up to 20,000 lbs. weight capacity.

PART NO.	DESCRIPTION	PIPE CAPACITY	WEIGHT CAPACITY	SHIPPING WEIGHT	DIMENSIONS L X W X H1 - H2
2115	Pipe Launcher (Two Rollers)	2" - 24"	2,500 lbs.	89 lbs.	23" x 26" x 16" - 18"
2115HD	Pipe Launcher HD (Six Rollers)	2" - 24"	7,500 lbs.	125 lbs.	23" x 26" x 16" - 18"
2126	Pipe Launcher (Two Rollers)	4" - 48"	10,000 lbs.	162 lbs.	30" x 36" x 16" - 19"
2126HD	Pipe Launcher HD (Six Rollers)	4" - 48"	20,000 lbs.	213 lbs.	30" x 36" x 16" - 19"
2136	Pipe Launcher (Two Rollers)	16" - 60"	10,000 lbs.	178 lbs.	30" x 36" x 16" - 19"
2136HD	Pipe Launcher HD (Six Rollers)	16" - 60"	20,000 lbs.	229 lbs.	30" x 36" x 16" - 19"

Mathey Pipe Rack Rollers are used for a variety of industries and applications, typically for installation of pipes into racks at Refineries, Power Stations and other Industrial Plants.

All the Mathey Pipe Rack Rollers are designed to be light weight, with I-beam clamps for quick installation and various roller head options so that all sizes and weights of pipe can be easily, safely and efficiently installed.

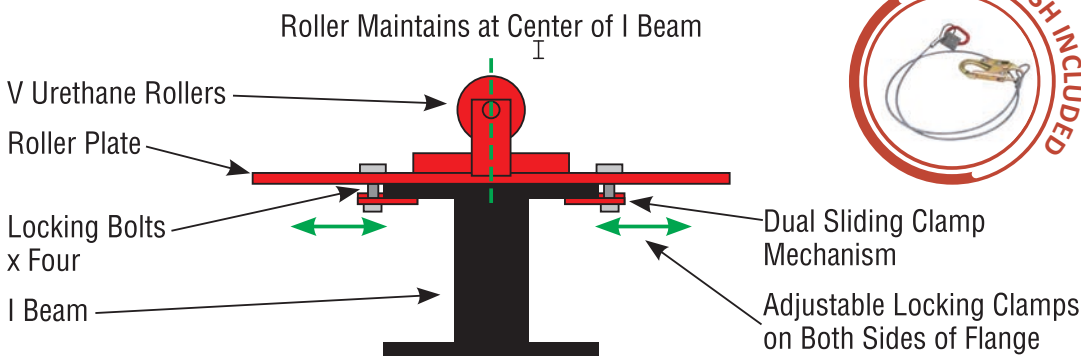


### Features and Advantages

- Six configurations from 1 - 10 tons capacity
- Three sizes for 2" - 60" pipe diameters
- Urethane wheels with sealed bearings
- Easy to replace wheels, bolt off and on in seconds
- Comes ready to use on Stainless Steel
- Convenient and safe carry handles on all models
- Safety Leash included with all models



PART NO.	2110	2110HD	2125	2125HD	2135	2135HD
Load Capacity	1 Ton 1,016 kg 2,240 lbs.	3 Tons 3,048 kg 6,720 lbs.	5 Tons 5,080 kg 11,200 lbs.	10 Tons 10,160 kg 22,400 lbs.	5 Tons 5,080 kg 11,200 lbs.	10 Tons 10,160 kg 22,400 lbs.
Pipe Diameter Range	2" - 24" 50 - 610 mm	2" - 24" 50 - 610 mm	4" - 48" 100 - 1,220 mm	4" - 48" 100 - 1,220 mm	16" - 60" 400 - 1,530 mm	16" - 60" 400 - 1,530 mm
Complete Unit Weight	27 kg 59 lbs.	43 kg 95 lbs.	59 kg 130 lbs.	82 kg 180 lbs.	66 kg 145 lbs.	91 kg 200 lbs.
Footprint L x W x H	16.5" x 20.5" x 8" 41.9 x 52 x 20.3 cm	16.5" x 20.5" x 8" 41.9 x 52 x 20.3 cm	19" x 30" x 8.75" 48.3 x 76.2 x 22.2 cm	19" x 30" x 8.75" 48.3 x 76.2 x 22.2 cm	21" x 34" x 8.75" 53.3 x 86.4 x 22.2 cm	21" x 34" x 8.75" 53.3 x 86.4 x 22.2 cm
Beam Flange Width Range	6" - 12" 150 x 300 mm	6" - 12" 150 x 300 mm	6" - 12" 150 x 300 mm	6" - 12" 150 x 300 mm	6" - 12" 150 x 300 mm	6" - 12" 150 x 300 mm



**Ball Transfer Model**

**PN 2145**  
4" - 36"  
4,000 lbs.

5mm Square Gridline

Our Brands:



**PIPE JACKS AND STANDS**



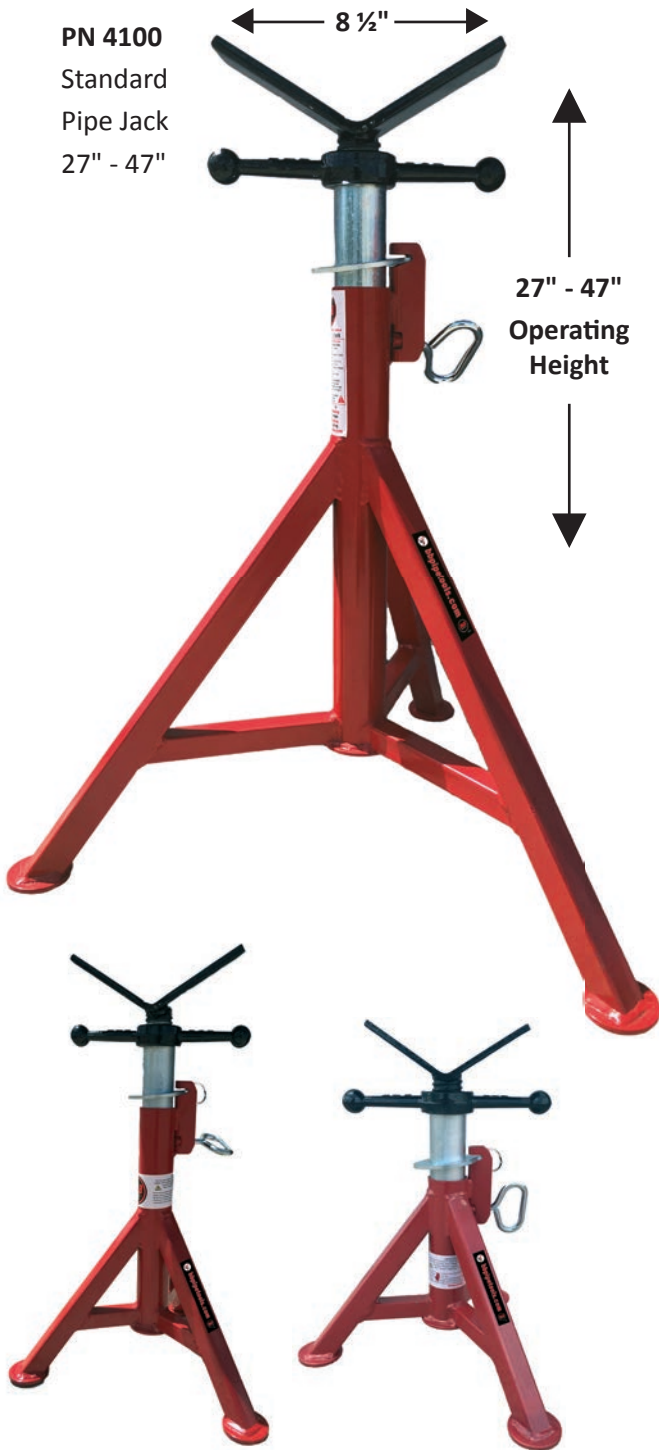
**MEGA JACKS AND ROLLERS**



**MATERIAL HANDLING EQUIPMENT**



**PN 4100**  
Standard  
Pipe Jack  
27" - 47"



### Features

B&B Pipe Jacks and Pipe Stands are backed with almost 20 years of manufacturing experience and all Pipe Jacks and Pipe Stands are rated with at least a 2:1 safety ratio that is 3rd party tested. With an increased dimension of our Acme threads to 1 1/2" and increased square tube legs to 1 1/4", we have made B&B Pipe Jacks the strongest, most durable product on the market. B&B also offers more head options than any other manufacturer, because we feel pipe fabricators can never have too many options. We are confident B&B has an available head style for any pipe fabrication application.

### Specifications

- 2,500 lbs. Standard V-Head capacity with higher load rating available.
- Three Sizes:
  - 27" - 47" Standard
  - 20" - 37" Low Profile
  - 16" - 26" Super Low Profile
- Third party tested with at least a 2:1 safety ratio.
- Oversized 10" V-Head for increased safety.
- Oversized square tube legs and braces for increased durability.
- 1 1/2" Acme rod is largest in the industry.
- Quick lock washer height adjustment for easy use.
- More head options than any other manufacturer.
- Increased width stance for better stability.
- Square tube bracing offers additional strength and rigidity.
- Safety washer can be locked on to base for increased operator safety.
- Our fixed leg pipe jacks have a recommended 12" pipe diameter capacity.

**PN 4200**  
Stubby  
Pipe Jack  
20" - 37"

**PN 4240**  
Super Stubby  
Pipe Jack  
16" - 26"

## Fixed Leg Head Options

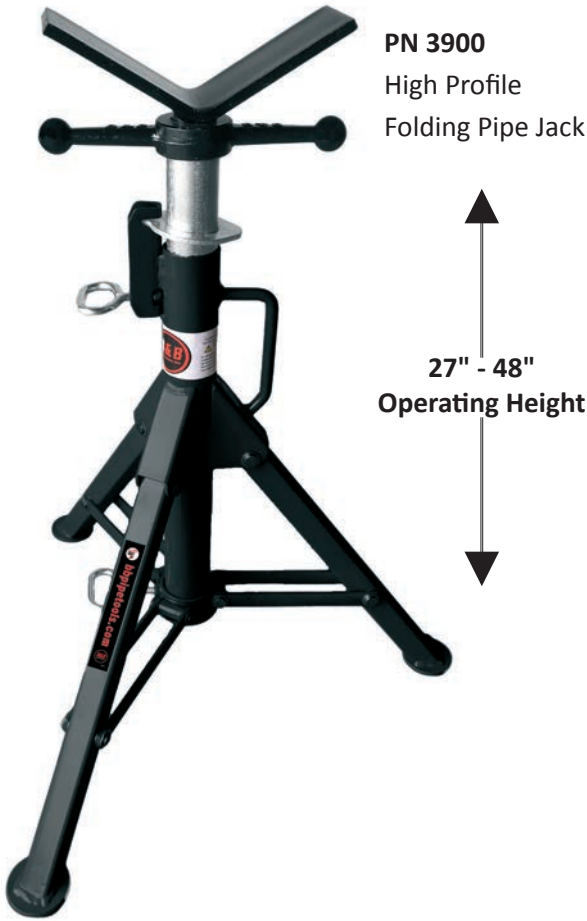


SEE PAGE 50  
FOR  
SAFETY HEAD  
SPECS



Above part numbers are head only. Below part numbers are complete unit.

PN	NAME	WEIGHT CAPACITY	DIMENSIONS (L x W x H)	ADJUSTMENT HEIGHT	SHIPPING WEIGHT
4100	V-Head Pipe Jack (Standard)	2,500 lbs. / 1,133 kg	24" x 21" x 27" 60 x 53 x 68 cm	27" - 47" / 68 - 120 cm	20 lbs. / 9 kg
4101	Super Duty Gusseted V w/ Solid Acme Rod (V-Gusset)	3,000 lbs. / 1,360 kg	24" x 21" x 28" 60 x 53 x 71 cm	28" - 49" / 71 - 124 cm	22 lbs. / 9.9 kg
4102	Pin Lock w/ Lock Washer, Safety Stop and Standard V-head	3,000 lbs. / 1,360 kg	24" x 21" x 28" 60 x 53 x 71 cm	28" - 48" / 71 - 121 cm	24 lbs. / 10 kg
4103	Safety Jack (See page 52)	2,500 lbs. / 1,133 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 49" / 73 - 124 cm	26 lbs. / 11.7 kg
4105	Roller Head w/ Steel Wheels	2,000 lbs. / 907 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	26 lbs. / 11.7 kg
4110	Roller Head w/ Rubber Wheels	1,000 lbs. / 453 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	26 lbs. / 11.7 kg
4135	Roller Head w/ Stainless Steel Wheels	2,000 lbs. / 907 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	26 lbs. / 11.7 kg
4115	Conveyor Roller Head	500 lbs. / 226 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 44" / 73 - 111 cm	20 lbs. / 9 kg
4120	Conveyor V Roller Head	500 lbs. / 226 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 44" / 73 - 111 cm	22 lbs. / 9.9 kg
4200	V-Head Pipe Jack (Stubby)	2,500 lbs. / 1,133 kg	15" x 14" x 21" 38 x 35 x 53 cm	21" - 36" / 53 - 91 cm	18 lbs. / 8 kg
4201	Gusset V-Head Pipe Jack	3,000 lbs. / 1,360 kg	15" x 14" x 23" 38 x 35 x 58 cm	23" - 36" / 58 - 91 cm	20 lbs. / 9 kg
4205	Roller Head w/ Steel Wheels	2,000 lbs. / 907 kg	15" x 14" x 23" 38 x 35 x 58 cm	23" - 40" / 58 - 101 cm	24 lbs. / 10 kg
4210	Roller Head w/ Rubber Wheels	1,000 lbs. / 453 kg	15" x 14" x 23" 38 x 35 x 58 cm	23" - 40" / 58 - 101 cm	24 lbs. / 10 kg
4235	Roller Head w/ Stainless Steel Wheels	2,000 lbs. / 907 kg	15" x 14" x 23" 38 x 35 x 58 cm	23" - 40" / 58 - 101 cm	25 lbs. / 11.3 kg
4240	V-Head Pipe Jack (Super Stubby)	2,500 lbs. / 1,133 kg	15" x 13" x 15" 38 x 33 x 38 cm	15" - 27" / 38 - 68 cm	14 lbs. / 6 kg
4241	Gusset V-Head Pipe Jack	3,000 lbs. / 1,360 kg	15" x 13" x 16" 38 x 33 x 40 cm	16" - 27" / 40 - 68 cm	18 lbs. / 8 kg
4245	Roller Head w/ Steel Wheels	2,000 lbs. / 907 kg	15" x 13" x 18" 38 x 33 x 45 cm	18" - 29" / 45 - 73 cm	22 lbs. / 9.9 kg



### Features

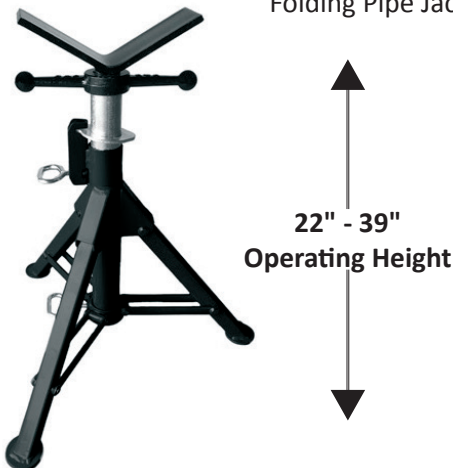
B&B Folding Pipe Jacks are backed with almost 20 years of manufacturing experience and all Pipe Jacks and Pipe Stands are rated with at least a 2:1 safety ratio that is 3rd party tested.

With an increased dimension of our Acme threads to 1½" and increased square tube legs to 1¼", we've made B&B Pipe Jacks the strongest, most durable product on the market. B&B also offers more head options than any other manufacturer, because we feel pipe fabricators can never have too many options. We are confident B&B has an available head style for any pipe fabrication application.

### Specifications

- 2,500 lbs. standard V-Head capacity with higher load rating available.
- Two Sizes, 27" - 48" Standard. 22" - 39" Low Profile.
- Third party tested with at least a 2:1 safety ratio.
- Oversized 10" V-Head for increased safety.
- Oversized square tube legs and braces for increased durability.
- 1½" Acme rod is the largest in the industry.
- Quick lock washer height adjustment for easy use.
- More head options than any other manufacturer.
- Increased width instance for better stability.
- Safety washer can be locked on to the base for increased operator safety.
- Unique bottom lock T-Handle reduces fit-up wobble.
- Fully welded carry handle doubles as security lock point.

PN 4000  
Low Profile  
Folding Pipe Jack



PN 3900 & PN 4000  
Folds to 8" footprint

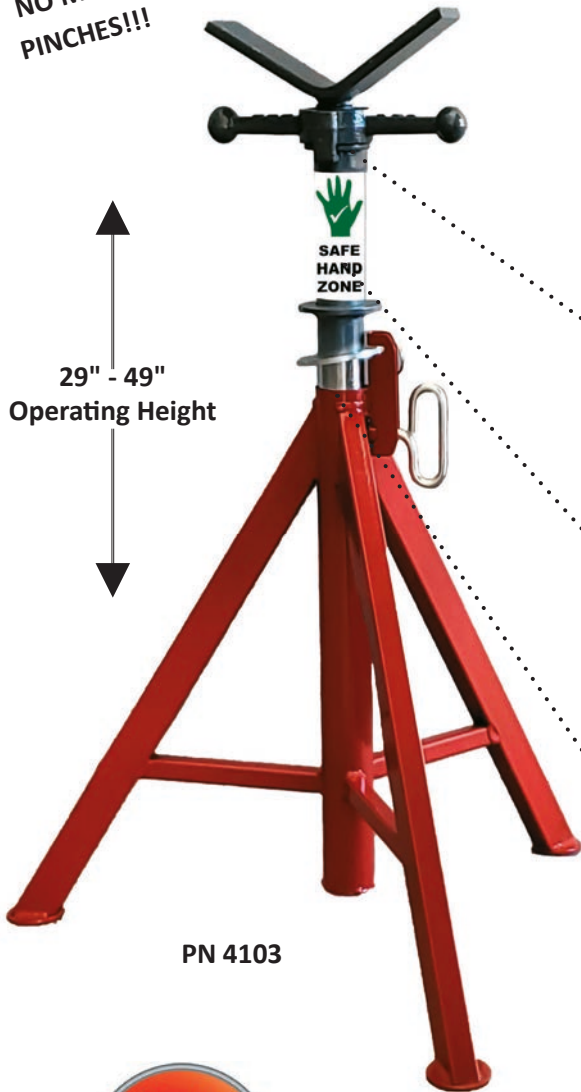




**Note: Above part numbers are head only. Below part numbers are complete unit.  
For additional part numbers please contact B&B.**

PN	NAME	WEIGHT CAPACITY	DIMENSIONS (L x W x H)	ADJUSTMENT HEIGHT	SHIPPING WEIGHT
3900	V-Head Pipe Jack	2,500 lbs. / 1,133 kg	24" x 21" x 27" 60 x 53 x 68 cm	27" - 48" / 68 - 121 cm	22 lbs. / 9 kg
3905	Roller Head w/ Steel Wheels	2,000 lbs. / 907 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	30 lbs. / 13 kg
3910	Roller Head w/ Rubber Wheels	1,000 lbs. / 453 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	30 lbs. / 13 kg
3915	Conveyor Roller Head	500 lbs. / 226 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 44" / 73 - 111 cm	24 lbs. / 10 kg
3920	Conveyor V Roller Head	500 lbs. / 226 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 44" / 73 - 111 cm	26 lbs. / 11 kg
3935	Roller Head w/ Stainless Steel Wheels	2,000 lbs. / 907 kg	24" x 21" x 29" 60 x 53 x 73 cm	29" - 50" / 73 - 127 cm	30 lbs. / 13 kg
4000	Low Profile V-Head Pipe Jack	2,500 lbs. / 1,133 kg	22" x 22" x 22" 55 x 55 x 55 cm	22" - 39" / 55 - 99 cm	23 lbs. / 10 kg
4005	Low Profile Roller Head w/ Steel Wheels	2,000 lbs. / 907 kg	22" x 22" x 22" 55 x 55 x 55 cm	22" - 39" / 55 - 99 cm	27 lbs. / 12 kg
4010	Low Profile Roller Head w/ Rubber Wheels	1,000 lbs. / 453 kg	22" x 22" x 22" 55 x 55 x 55 cm	22" - 39" / 55 - 99 cm	26 lbs. / 11 kg
4035	Low Profile Roller Head w/ Stainless Steel Wheels	2,000 lbs. / 907 kg	22" x 22" x 22" 55 x 55 x 55 cm	22" - 39" / 55 - 99 cm	27 lbs. / 12 kg
90000	Ball Transfer Sleeves - Pair - Stainless Steel	1,000 lbs. / 453 kg	n/a	n/a	2 lbs. / 0.90 kg

**NO MORE PINCHES!!!**



PN 4103



### Features

The B&B Safety Jack offers a capacity of 2,500 lbs. Several improvements including increased V dimensions make the V-Head safer. The lockable no slip washer with hand tab, wider stance, increased dimensions of square tube legs and square tube bracing make the Safety Jack stand out from the competition.

#### V-Head Clip Attachment



The V-Head clips and fastens the head to the tube reducing a pinch point and minimizing risk of fall injury, also reduces incidents of parts being lost.

#### Safe Hand Zone



Two metal rings restrict hand movement into pinch zones allowing safer height adjustment.

#### PN Locking Ring



The locking ring fastens the safety washer to the base, minimizing parts and reducing the risk of operator error.

### Specifications

- V-Head clip attachment.
- Safe hand zone.
- Ring washer lock.
- Wider footprint for stability.
- Increased V-Head dimensions for safety.
- Increased dimensions of leg and brace tubing for strength.

PN	NAME	WEIGHT CAPACITY	FOOTPRINT	WORKING HEIGHT	SHIPPING WEIGHT
4103	Safety Jack	2,500 lbs. / 1,133 kg	24" x 24" x 24" 60 x 60 x 60 cm	29" - 49" / 73 - 124 cm	26 lbs. / 11 kg



**PN 4300 (As Shown)**  
Adjustable Pipe Roller  
32" Working Height

### Features

The B&B Adjustable Pipe Roller is used in pipe fabrication facilities and job-sites around the world with thousands in use. The sturdy base and adjustable wheels are a favorite with medium size pipe fabrication projects allowing a stable work platform that allows pipe rotation.

### Specifications

- Stable 4 leg design with a 24" x 30" footprint.
- **1½" wide steel / rubber wheels to reduce instances of "pipe travel". WIDEST IN THE INDUSTRY.**
- Removable wheel housings for ease of shipment and replacement.
- T-Handle brake to stop pipe rotation.
- Wheels can be easily adjusted to accommodate pipe up to 36".
- 2,500 lbs. weight capacity (with steel wheels).

**PN 30045**

Ball Transfer



**PN 90010**

Steel Wheels



**PN 90011**

Rubber  
Wheels



**PN 90013**

Wheel Housing



**Low Profile**

**PN 4400**



**Bench Mount**

**PN 4500**



PN	NAME	WEIGHT CAPACITY	FOOTPRINT	WORKING HEIGHT	SHIPPING WEIGHT
4300	Adjustable Pipe Roller w/ Steel Wheels	2,500 lbs. / 1,133 kg	24" x 32" / 60 x 81 cm	32" / 81 cm	40 lbs. / 18 kg
4305	Adjustable Pipe Roller w/ Rubber Wheels	1,000 lbs. / 453 kg	24" x 32" / 60 x 81 cm	32" / 81 cm	40 lbs. / 18 kg
4310	Adjustable Pipe Roller w/ Stainless Steel Ball Transfer	1,000 lbs. / 453 kg	24" x 32" / 60 x 81 cm	32" / 81 cm	40 lbs. / 18 kg
4315	Adjustable Pipe Roller w/ Stainless Steel Wheels	2,500 lbs. / 1,133 kg	24" x 32" / 60 x 81 cm	32" / 81 cm	40 lbs. / 18 kg
4400	LOW PROFILE Adjustable Pipe Roller w/ Steel Wheels	2,500 lbs. / 1,133 kg	24" x 32" / 60 x 81 cm	24" / 60 cm	36 lbs. / 16 kg

For additional pipe roller part numbers and options, please contact B&B.

## Features

B&B introduces the new Multi-Roll Pipe Roller. The new and improved Multi-Roll can raise and lower pipe to fit up under load and accommodate up to 36" pipe with no width adjustment necessary, thereby saving time and increasing safety. Available with steel, rubber and stainless steel wheels. All wheels lock, restricting pipe rotation.

## Specifications

- Offers additional functions as compared to the fixed height model.
- All Acme adjustment allows pipe raising and lowering under load.
- 3,000 lbs. weight capacity (w/ steel wheels).
- Pipe capacity is 2" - 36".
- Pipe Brake System allows wheels on both sides of the Jack to lock, restricting pipe rotation.
- Extra wide wheels reduce pipe travel.
- Shipping weight 62 lbs.



**PN 4375**  
29" - 42"

Low Profile Version Available



**PN 90010**  
Steel Wheels



**PN 90011**  
Rubber Wheels



PN	NAME	WEIGHT CAPACITY	FOOTPRINT	WORKING HEIGHT	SHIPPING WEIGHT
4375	Adjustable Pipe Roller w/ Steel Wheels	3,000 lbs. / 1,360 kg	24" x 32" / 60 x 81 cm	29" - 42" / 73 - 106 cm (top of inside wheels)	62 lbs. / 28 kg
4380	Adjustable Pipe Roller w/ Rubber Wheels	1,000 lbs. / 453 kg	24" x 32" / 60 x 81 cm	29" - 42" / 73 - 106 cm (top of inside wheels)	62 lbs. / 28 kg
4390	Adjustable Pipe Roller w/ Stainless Steel Wheels	3,000 lbs. / 1,360 kg	24" x 32" / 60 x 81 cm	29" - 42" / 73 - 106 cm (top of inside wheels)	62 lbs. / 28 kg
4391	Adjustable Pipe Roller w/ Polyurethane Over Steel Wheels	3,000 lbs. / 1,360 kg	24" x 32" / 60 x 81 cm	29" - 42" / 73 - 106 cm (top of inside wheels)	62 lbs. / 28 kg



**PN 3510**  
5 Leg Giant Jack  
(with wheels and casters)  
34" - 45"



**PN 3500**  
5 Leg Giant Jack  
(no wheels, no casters)  
25" - 36"



**PN 3506**  
Hold Down Chain  
Locks Pipe to Jack

## Features

Ideal for large diameter pipe up to 36", B&B Giant Jacks come with V-Heads only or with multiple wheel options. The Five Leg Giant Jack has optional casters allowing pipe movement. Increased steel dimensions throughout, including 1 1/4" solid Acme rod make the B&B Giant Jacks the toughest on the market.

## Specifications

- Urethane over steel casters with solid hub increase safety and durability.
- 5,000 lbs. capacity without wheels and casters.
- 2,500 lbs. capacity with steel wheels and urethane casters.
- Operating height with swivel casters. 34" - 45".
- Operating height with Jack only. 25" - 36".
- Maximum Pipe Diameter 36".
- **Solid 1 1/4" Acme thread adjustment.**
- **1 1/2" wide steel / rubber wheels to reduce instances of "pipe travel". WIDEST IN THE INDUSTRY.**
- Can be purchased as a complete kit as shown. Jack, casters, and wheels.
- Turning wheels available in steel, stainless steel, and rubber.
- Multiple add-ons available, including stainless steel sleeves for contamination free fit-up, recommended Hold Down Chain for transport, ball transfer attachments for variation of pipe movement and more.

PN	NAME	WEIGHT CAPACITY	SHIPPING WEIGHT
3500	Five Leg Giant Jack (jack only, no wheels)	5,000 lbs. / 2,272 kg	80 lbs. / 36 kg
3502	Steel Wheel Kit (4 wheels) - 1 1/2" Wide Wheels	2,500 lbs. / 1,136 kg	18 lbs. / 8 kg
3503	Rubber Wheel Kit (4 wheels) - 1 1/2" Wide Wheels	1,000 lbs. / 454 kg	18 lbs. / 8 kg
3504	Caster Kit for PN 3500 (5 casters)	2,500 lbs. / 1,136 kg	75 lbs. / 34 kg
3507	Stainless Steel Sleeves	5,000 lbs. / 2,272 kg	10 lbs. / 4 kg
3508	Stainless Steel Wheel Kit	2,500 lbs. / 1,136 kg	18 lbs. / 8 kg
3509	Ball Transfer Kit	1,000 lbs / 454 kg	30 lbs. / 13 kg
3510	Giant 5 Package ST (jack, casters, and steel wheel)	2,500 lbs. / 1,136 kg	120 lbs. / 54 kg
3511	Giant 5 Package RU (jack, casters, and rubber wheel)	1,000 lbs. / 454 kg	120 lbs. / 54 kg
3514	Giant 5 Package SS (jack, casters, and stainless steel wheels)	2,500 lbs. / 1,133 kg	120 lbs. / 54 kg
3515	Giant 5 Package UR (jack, casters, and urethane coated steel wheels)	2,500 lbs. / 1,133 kg	120 lbs. / 54 kg

## Features

The B&B 3 Leg Giant Jack offers the same pipe diameter capacity of 36" and same capacity ratings as the 5 Leg Giant Jack, but is used in a static position. The solid 1¾" Acme rod height adjustment sets the B&B Giant Jack apart from our competitor's hollow Acme threads, along with increased leg tube dimensions. Multiple wheel options including steel, stainless steel and rubber are ideal for a variety of applications. B&B also offers stainless steel sleeves for fit-up involving exotic pipe that requires no rotation, ball transfer attachments that allow both rotation and feeding of rounds, or take the wheels off and you have oversized V-Head Pipe Jack ideal for heavy wall, large diameter steel pipe fit-ups.

## Specifications

- Rated at 5,000 lbs. capacity with no wheels and 2,500 lbs. w/ steel wheels.
- Operating height 33" - 44".
- Available with steel, stainless steel or rubber wheels.
- 32" wide stance increases stability.
- Recommended for up to 36" pipe.
- Increased leg wall thickness and increased tube dimension adds greater strength for bigger pipe fabrication.
- Solid 1¾" Acme Rod comes standard with all B&B Giant Jacks.
- Nylon washer allows smooth raising and lowering of the V-Head.

**PN 3512**

3 Leg Giant Jack  
33" - 44"



**PN 3506**

Hold Down Chain  
Locks Pipe to Jack

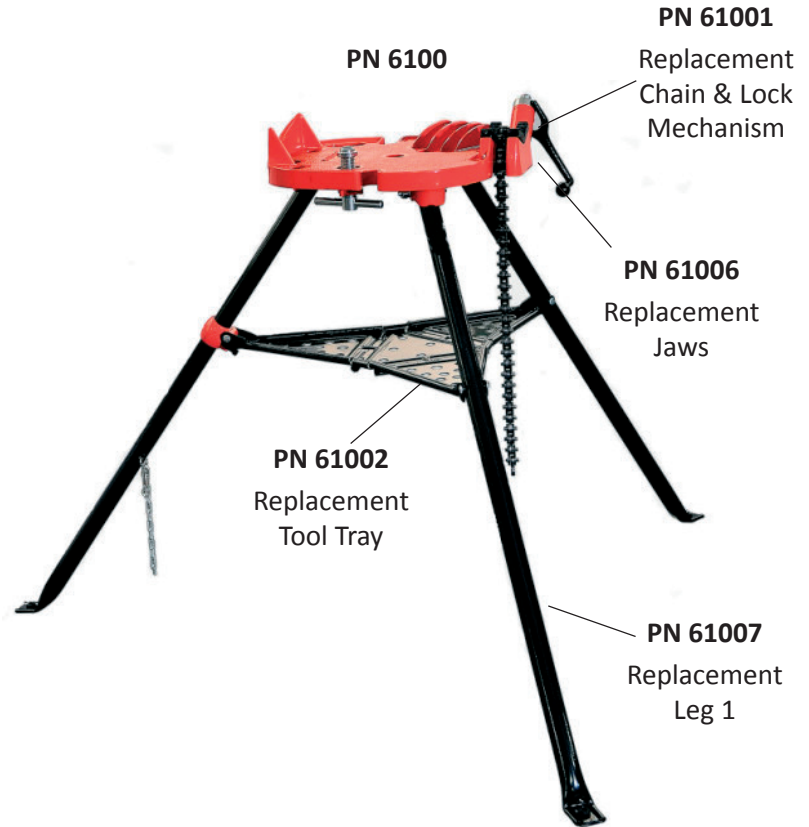
PN	NAME	WEIGHT CAPACITY	SHIPPING WEIGHT
3501	Three Leg Giant Jack (jack only)	5,000 lbs. / 2,267 kg	65 lbs. / 29 kg
3502	Steel Wheel Kit (4 wheels)	2,500 lbs. / 1,133 kg	18 lbs. / 8 kg
3503	Rubber Wheel kit (4 wheels)	1,000 lbs. / 453 kg	18 lbs. / 8 kg
3506	Hold Down Chain	n/a	10 lbs. / 4 kg
3507	Stainless Steel Sleeves	5,000 lbs. / 2,267 kg	10 lbs. / 4 kg
3508	Stainless Steel Wheel Kit	2,500 lbs. / 1,133 kg	18 lbs. / 8 kg
3509	Ball Transfer Kit	1,000 lbs. / 453 kg	30 lbs. / 13 kg
3512	Giant 3 Package ST (jack and steel wheels)	2,500 lbs. / 1,133 kg	70 lbs. / 31 kg
3513	Giant 3 Package RU (jack and rubber wheels)	1,000 lbs. / 453 kg	70 lbs. / 31 kg

## Features

The B&B Tri-Stand Chain Vise is a proven design used on construction sites around the globe. B&B offers the same features as many other brands at a very competitive price.

## Specifications

- Durable cast aluminum head balances lightweight and durability.
- Heavy-duty hold down tightening device with replaceable jaw.
- Folding legs with chain lock.
- Leg bracing doubles as a lipped shelf for holding additional tooling and machines.
- Up to 6" pipe capacity; the industry standard.
- Ships boxed and fully assembled, ready for immediate use.  
Box Dimensions - 46 x 18 x 16
- Heavy-duty jaws that are replaceable and fit most brands.
- 55" W x 35" H (Working Dimensions)
- 1000 lbs. Capacity
- Heavy duty jaws that are replaceable and fit most brands.
- 1000 lbs. Capacity



**Note: Chain Vise is comparable to other brands with interchangeable parts. Please contact us regarding which brands components are interchangeable.**

PN	NAME	SHIPPING WEIGHT
6100	Tri-Stand Vise	42 lbs. / 19 kg
61001	Replacement chain and lock mechanism (for most brands)	2 lbs. / 0.90 kg
61002	Replacement tool tray (for most brands)	8 lbs. / 3 kg
61006	Replacement jaws (for most brands)	2 lbs. / 0.90 kg
61007	Replacement leg 1 (for most brands)	4 lbs. / 1 kg

## Features

The B&B Six-Foot Jack is ideal for pipe holding and leveling in high places. With a top height of 72" tall and a bottom adjustment of 39", the Six-Foot Jack can be used in many applications. The Six-Foot Jack is foldable and can be carried with ease, fitting into tight spaces when transporting. All height adjustment is performed with a locking tube and 1½" Acme adjustment.

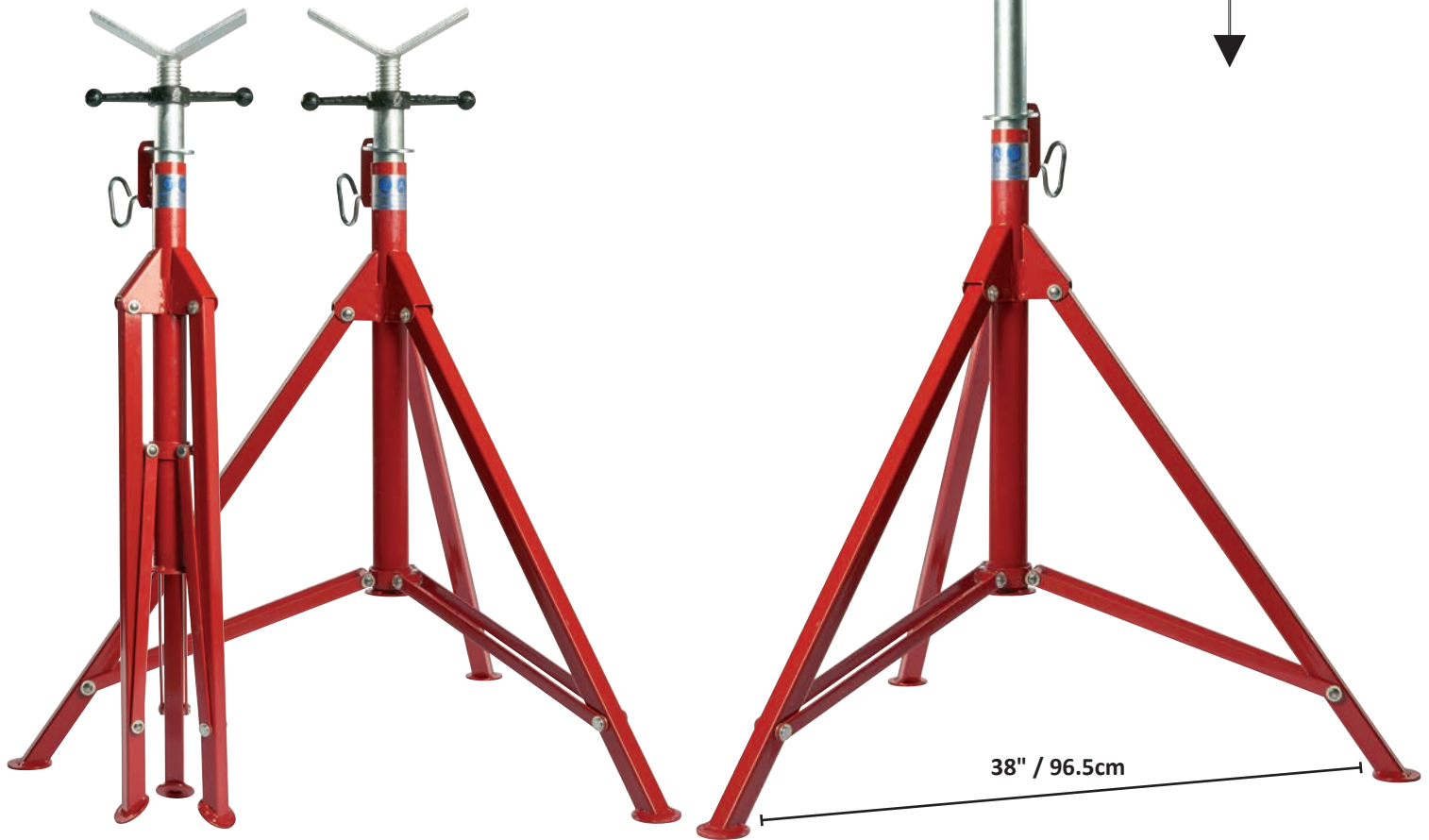
## Specifications

- Height adjustment from 39" - 72" tall.
- 1,000 lbs. weight capacity.
- Extra wide 38" footprint increases stability.
- Lock washer can be fastened to base for safety.
- 1½" Acme thread adjustment.
- Folding design allows easy access into tight work spaces.
- Bottom T-Handle locks folding base into fixed position.
- Recommended 12" pipe diameter.

PN 3610

39" - 72"

38" / 96.5cm



PN	NAME	WEIGHT CAPACITY	WEIGHT	ADJUSTMENT HEIGHT	FOOTPRINT
3610	72" Folding Jack	1,000 lbs. / 453 kg	45 lbs. / 20 kg	39" - 72" / 99 - 182 cm	38" / 96.5 cm



## Features

B&B Uno jacks are a cost effective and simple to use pipe jack option. Two parts consisting of a simple base and V-Head threaded adjustment mechanism make up for simple operation, sturdy design and lightweight transport. Please specify the low height adjustment and we will fabricate your Uno Jack to order.

## Specifications

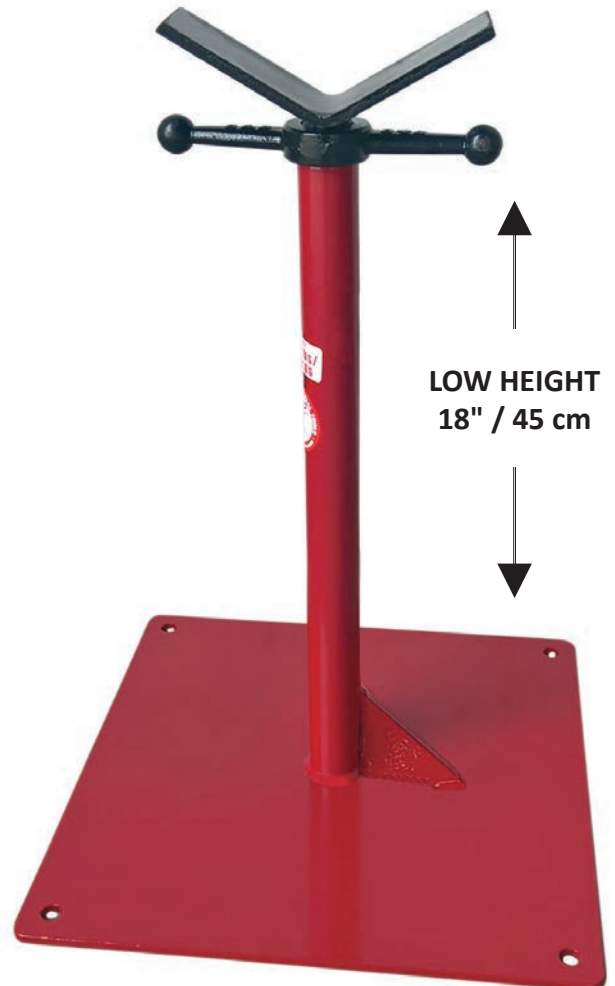
- Custom built to your height requirements.
- Six inch height adjustment - determined by low height specification.
- Simple design for most light duty, low height requirement, fab shop projects.
- Durable 1½" Acme thread for fine height adjustment.
- Oversized V-Head safely cradles up to 12" pipe.
- Manufactured with holes, allowing unit to be bolted to floor.



PN	WEIGHT CAPACITY	DIMENSIONS
4255	1,000 lbs. / 453 kg	12" x 12" / 30 x 30 cm Base - up to 20" tall
4255 RL	1,000 lbs. / 453 kg	12" x 12" / 30 x 30 cm Base - up to 20" tall
4260	1,000 lbs. / 453 kg	18" x 18" / 45 x 45 cm Base - up to 42" tall
4260 RL	1,000 lbs. / 453 kg	18" x 18" / 45 x 45 cm Base - up to 42" tall

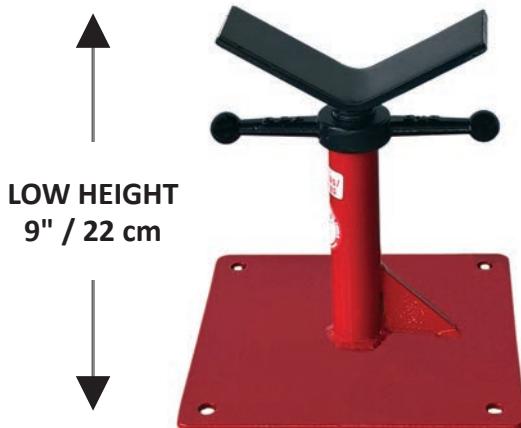
**PN 4260**

18" x 18" Base - up to 42" / 106 cm tall

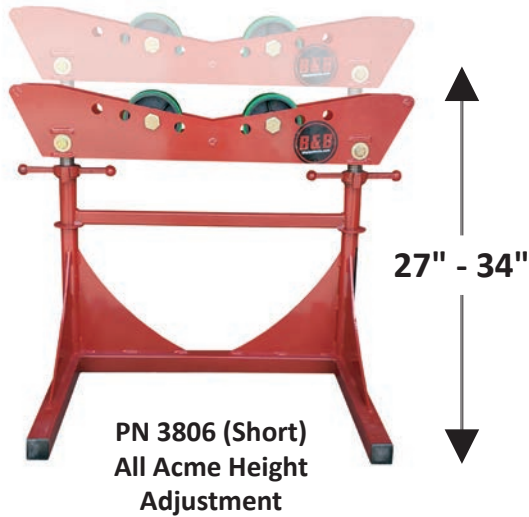


**PN 4255**

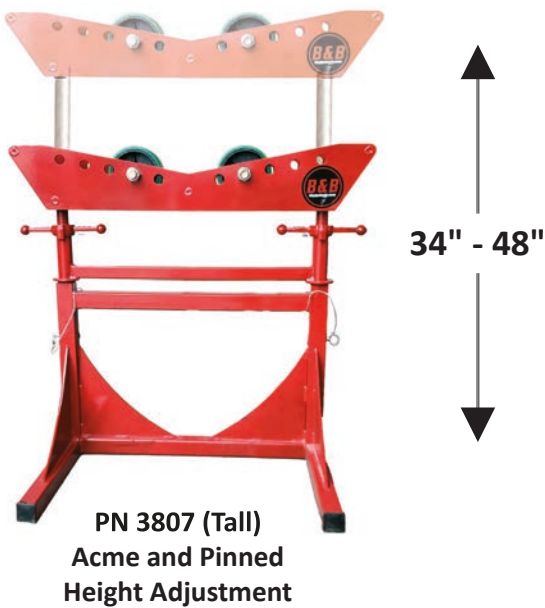
12" x 12" Base - up to 20" / 50 cm tall



### SHORT Version



### TALL Version



### Features

The new B&B 6K Mega Roller is an increased capacity pipe roller designed for heavy-duty job-site use. The oversized 6" x 3" wheels are a urethane over steel design offering numerous advantages over our competitors in this product price point category. They allow ultra smooth pipe rotation via heavy-duty sealed bearings, and urethane coating allows steel pipe rotation, as well as contamination free exotic pipe rotation.

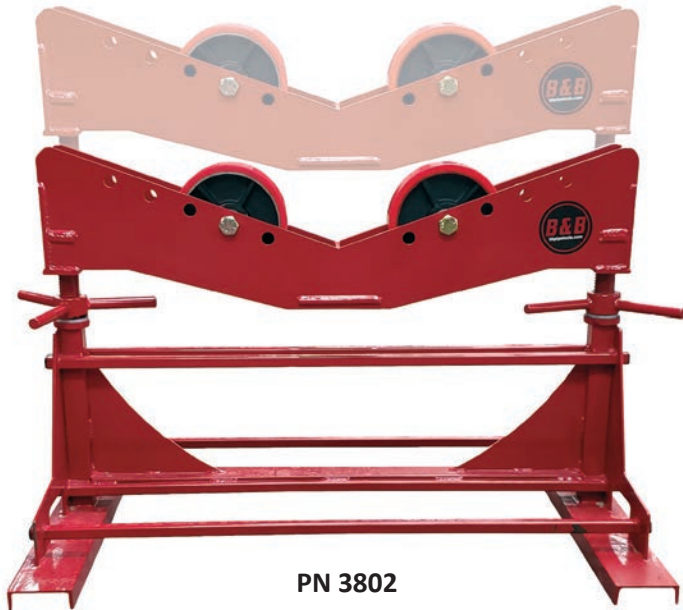
The unique head design also allows the removal of the wheels, transforming to a V-Head stand restricting pipe rotation. The robust construction and design is head and shoulders above other similar products on the market.

### Specifications

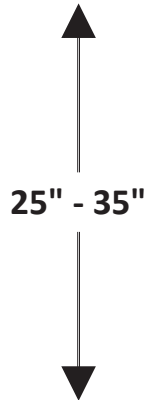
- 6,000 lbs. weight capacity.
- 4" - 48" pipe capacity.
- 6" x 3" heavy-duty urethane over steel wheels with sealed bearings ideal for smooth bump free pipe rotation.
- Contamination free wheels are ideal for steel or exotic pipe fabrication.
- Heavy gauge steel construction throughout. These mega rollers are made for years of job-site abuse.
- Powder coated safety red for high visibility.
- Expanded foot print at 36" x 32" increases pipe stability.



PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3806	6,000 lbs. / 2,721 kg	4" - 48" / 10 - 121 cm	106 lbs. / 48 kg	36" x 32" / 91 x 81 cm	27" - 34" / 68 - 86 cm
3807	6,000 lbs. / 2,721 kg	4" - 48" / 10 - 121 cm	118 lbs. / 48 kg	36" x 32" / 91 x 81 cm	34" - 48" / 86 - 121 cm



PN 3802



### Features

The new B&B 10,000 lbs. Mega Roller is built in the USA and made to last. Oversized 10" urethane over steel wheels with grease fittings allow smooth and safe rotation of various pipe sizes and materials. When you remove the wheels, the V block allows safe placement of pipe in application when rotation is not desired. Twin 1¾" solid Acme rods raise and lower the headstock and wheels for precise fit-ups even under load. All Mega Rollers are powder coated, have quick release axle pins, and are modular allowing additional feed wheels and casters for mega movement. All these features are available at a great price.



### Specifications

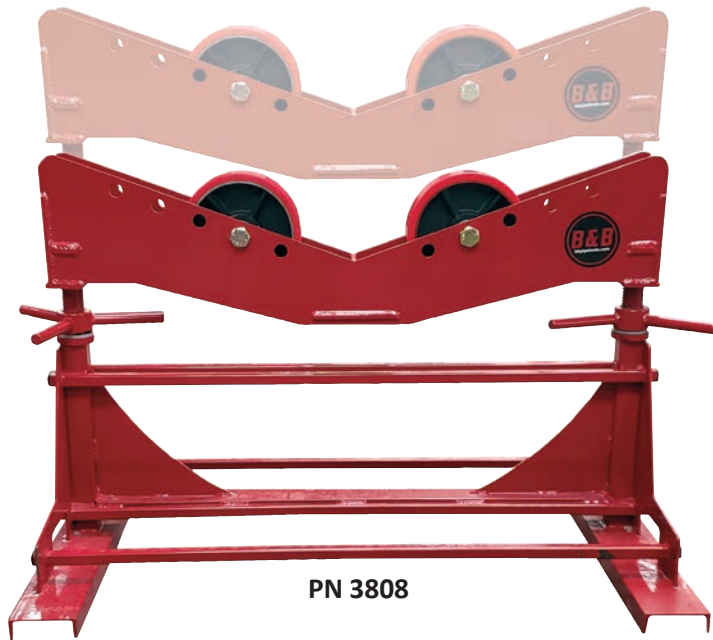
- 10,000 lbs. capacity per stand that is 3rd party tested.
- Twin 1¾" Acme rods for heavy-duty yet precise lifting.
- Four side fork lift access.
- Modular design allows caster and feed roller additions.
- 3" x 10" urethane over steel wheels with grease fittings allow smooth pipe rotation.
- 25" - 35" height adjustment. (custom height can be manufactured upon request)
- For use up to 60" pipe diameter!

Additional wheel types available upon request.

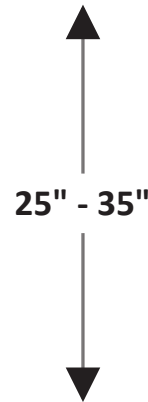
PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3802	10,000 lbs. / 4,535 kg	4" - 60" / 10 - 152 cm	263 lbs. / 119 kg	36" x 52" / 91 x 132 cm	25" - 35" / 63 - 88 cm

## Features

The B&B 15,000 lbs. Mega Roller is built on the same platform as the 10,000 lbs. roller, but an increased headstock width and two additional wheels are added. These wheels allow not only an increased capacity, but offer additional stability during pipe rotation when large diameter heavy wall pipe is being fabricated. Heavy-duty Acme rods, machined ergonomic height adjustment handle, and reinforced steel components make this pipe roller easy to use and durable enough for years of pipe fabrication.



PN 3808



**Dual wheel configuration increases weight capacity and stability!**

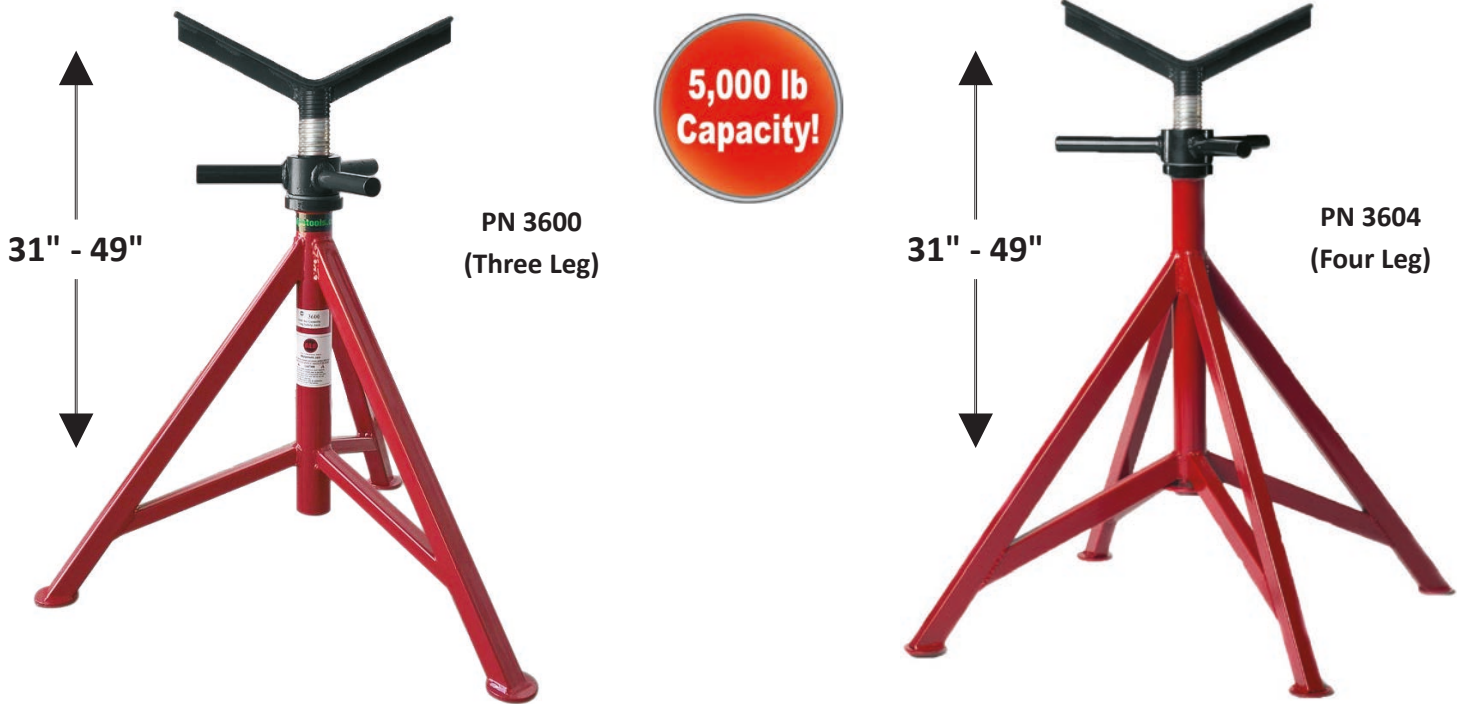
## Specifications

- 15,000 lbs. weight capacity.
- Twin 1¼" Acme rods for heavy-duty yet precise lifting.
- Four side fork lift access.
- Modular design allows caster and feed roller additions.
- Four 3" x 10" urethane over steel wheels with grease fittings.
- 25" - 35" height adjustment (custom height can be manufactured upon request).
- Up to 60" pipe diameter.
- Safe machined tri-handle height adjustment.
- Quick pinned axle release for faster pipe diameter adjustments.

PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3808	15,000 lbs. / 6,803 kg	4" - 60" / 10 - 152 cm	350 lbs. / 158.7 kg	36" x 52" / 91 x 132 cm	25" - 35" / 63 - 88 cm

## Features

B&B Mega Jacks are available with three or four legs with a wider and safer stance offering increased stability. All Mega Jacks offer a large 16" V-Head with reinforced V-Gussets for added strength, increasing the weight capacity to 5,000 lbs.! Height adjustment is 1¾" solid Acme thread and the elimination of the adjustment washer, inside tube and T-Handle simplify use and reduce instances of potential operator error.



## Specifications

- Double reinforced V-Head.
- Increased V-Head dimensions allows for up to 32" pipe diameters.
- Over-sized legs and braces for increased capacity.
- Third party tested with over a 3:1 safety ratio.
- Increased footprint for additional stability.
- Machined Acme nut with tri-handle increases durability and adjustment ability.
- 5,000 lbs. weight capacity!
- Heavy-duty 1 ¾" solid Acme rod adjustment.

PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3600	5,000 lbs. / 2,267 kg	2" - 32" / 5 - 81 cm	40 lbs. / 18 kg	30" x 30" / 76 x 76 cm	31" - 49" / 78 - 124 cm
3604	5,000 lbs. / 2,267 kg	2" - 32" / 5 - 81 cm	42 lbs. / 19 kg	26" x 26" / 66 x 66 cm	31" - 49" / 78 - 124 cm
3605	5,000 lbs. / 2,267 kg	2" - 36" / 5 - 91 cm	65 lbs. / 29 kg	26" x 26" / 66 x 66 cm	31" - 49" / 78 - 124 cm



**84" Pipe Capacity!**  
**20,000 lbs. Weight Capacity!**

### Features

The B&B Mega Block offers a safe and tested platform when setting and storing pipe. On many job-sites the pipe would either set directly on the ground, or be wedged between two pieces of wood to restrict rotation. The Mega Block accomplishes the same function, but in a safe, engineered and 3rd party tested product. Each Mega Block has fork lift slots and two lifting eyes for easy movement.

### Specifications

- Solid steel construction allows for heavy-duty job-site use.
- Fork lift and eye-bolts allow easy lifting and movement.
- Great way to safely store, fabricate, or stage pipe.

PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3816	20,000 lbs. / 9,071 kg	2" - 84" / 5 - 213 cm	261 lbs. / 118 kg	24" x 72" / 60 x 182 cm	Fixed



**12,000 lbs. Weight Capacity!**

### Features

The B&B Mega Horse is ideal for storing flats and rounds. Robust construction allows years of use and abuse in an engineered and tested design. Powder coating and clear capacity rated labeling makes this a long lasting and safe solid steel sawhorse.

### Specifications

- A-frame leg design bracing from center of beam to legs for three point support.
- I-beam top.
- Custom lengths and heights available.
- 3rd party load capacity tested.

PN	WEIGHT CAPACITY	UNIT WEIGHT	FOOTPRINT	STANDARD HEIGHT ADJUSTMENT
3820	12,000 lbs. / 5,443 kg	110 lbs. / 49 kg	53" x 37" x 36" / 134 x 93 x 91 cm	Fixed

# BABY PIPE BUGGY



## Features

B&B Baby Buggy is designed to help move pipe, fittings and other items with ease. Great for use in construction projects around the world, the B&B Baby Buggy ships in a cardboard box with 5 minute assembly of wheels and handle. 16" tires can move up to 1,000 lbs. payload and up to 12" diameter pipe. The Baby Buggy is shipped with a hold down strap free of charge.



PN 2013

## Specifications

- Transports pipe up to 20' in length.
- 1,000 lbs. capacity.
- Carries up to 12" diameter pipe, fittings, packages, and more.
- Comes with hold down strap.
- Shipping weight 118 lbs.

**Note: Flat free tires are standard.**

PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT
2013	1,000 lbs. / 453 kg	up to 12" diameter pipe	118 lbs. / 53 kg	28" x 28" x 21" / 71 x 71 x 53 cm

# BIGGY PIPE BUGGY

## Features

The B&B Biggy Buggy allows one man to move up to 24 foot long pipe and up to 2,000 lbs. of weight unassisted. The Biggy Buggy ships unassembled in a wooden crate for ease of shipment and can be assembled in less than 15 minutes.

## Specifications

- Transports pipe up to 24'.
- 2,000 lbs. capacity.
- Product dimension assembled: 12 Feet in Length X 35" W
- Carries up to 20" diameter pipe, fittings, boxes and more.
- Shipping weight 260 lbs. with some assembly required.
- Shipping dimension - Crated: 81" x 31" x 16".



PN 2014



PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT
2014	2,000 lbs. / 907 kg	up to 20" diameter pipe	175 lbs. / 79 kg	81" x 31" x 16" / 205 x 78 x 40 cm



### Features

Our new line of carts are modular and share identical dimensions and some features. The B&B Pipe Cart is a six wheeled, low height, narrow width cart that is strong enough to carry 2000 lbs., but agile enough to turn and fit through doorways with ease. The carts can be stacked for shipment and storage, and the casters ship assembled to the cart and are ready for rolling. The push handles and V-Block can be unassembled and stored in seconds when not in use. If you remove the V-Block attachment from the cart you have a 2,000 lbs. cart capable of moving just about anything within rated capacity.

### Specifications

- Transports pipe up to 24' in length.
- 27" pipe capacity.
- 6 wheels ideal for fab shop transport.
- Removable V for squares and flats.
- Removable handles for stacking and storage.
- Shipping weight 185 lbs.



**PN 2015 - Folds and Stacks**  
**Do not stack while in use**



PN	WEIGHT CAPACITY	PIPE DIAMETER CAPACITY	UNIT WEIGHT	FOOTPRINT
2015	2,000 lbs. / 907 kg	up to 27" diameter pipe	185 lbs. / 83 kg	57" x 34" x 20" / 144 x 86 x 50 cm

### Features

New in the B&B Stacker Cart Line is the Hanger Cart. The B&B Hanger Cart is a modular design that stacks and folds for efficient shipping and storage, just like all B&B Stacker Carts. These carts can be loaded with various clevises and pushed into the installation location with ease. Once the job is complete or the carts are no longer needed, fold them, stack them, and ship or store them.

### Specifications

- Proudly manufactured in the USA.
- Patented Gravity Lock System. Secures uprights in position. Simply lift uprights from folded position into place, and let gravity do it's job. Uprights securely locks into position without the need to disengage pull pin.
- Foldable and Stackable for efficient transportation and storage. The B&B Cup Stacking System ensures carts stay stacked and secured.
- Urethane over hub - EZ Glide Wheels on all carts.
- Red for Safety. Visible on the job or in the shop.



**PN 2036**  
**(Economy)**



**PN 2035**

PN	WEIGHT CAPACITY	UNIT WEIGHT	FOOTPRINT
2036	1,000 lbs. / 453 kg	192 - 206 lbs. / 87 - 93 kg	57" x 34" x 20" / 144 x 86 x 50 cm



## Features

The B&B Bundle Cart is similar to the B&B Pipe Cart, but is designed for the storage and transport of multiple smaller diameter pipe, tube, and/or conduit. The fold down brackets can rest in a lowered position allowing storage, stacking and transport efficiency. Robust 2" square heavy gauge tubing and oversized 6" caster make the B&B Bundle Cart a great addition to many job-sites across multiple trades.



## Specifications

- Heavy gauge solid steel construction and replaceable wheels for years of use.
- U-bracket folds down for storage and transport of the cart, and locks up in position for heavy-duty bundle storage of pipe, tubing and conduit.
- The Bundle cart utilizes a modular design which makes storage and transport of multiple cart types possible.
- 6" wheels standard.
- Shipping weight 130 lbs.
- 1,000 lbs. weight capacity.
- 57" L x 34" W x 39" H (Folded height - 20")

PN	WEIGHT CAPACITY	UNIT WEIGHT	FOOTPRINT
2031	1,000 lbs. / 453 kg	130 lbs. / 58 kg	57" x 34" x 39" / 144 x 86 x 99 cm

## Features

The B&B Crate Cart is a nice addition to the B&B cart line and works on the same modular platform. This simple, yet effective, four sided cart is a great storage and transport cart that handles a 1,500 lbs. weight capacity and yet still fits through a 36" door frame common on job-sites. Two fixed and two swivel 6" steel wheels are standard and shipped assembled.

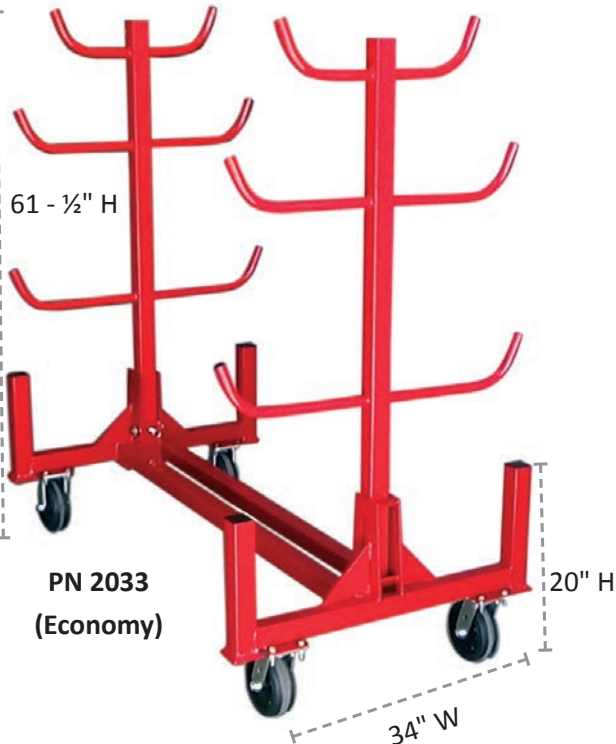


57" L x 34" W x 24" H - Storage Area

## Specifications

- Heavy gauge 2" square tubing means robust construction and lightweight transport.
- Great for storing pipe fittings and welding gear, or extension cords and electrical supplies, not to mention plumbing equipment or even carpentry tools and lumber.
- Stacks for shipment and transport to and from jobsites when empty.
- Modular design stacks with all B&B carts.
- Shipping weight 250 lbs.
- 1,500 lbs. weight capacity.

PN	WEIGHT CAPACITY	UNIT WEIGHT	FOOTPRINT
2034	1,500 lbs. / 680 kg	250 lbs. / 113 kg	57" x 34" x 24" / 144 x 86 x 60 cm



### Features

B&B Conduit Carts are not only for conduit. Any rounds that need to be stacked or separated fit into the 8 holding sections, and with four heavy-duty wheels the Carts allow easy movement around the job-site. The gravity lock hinge mechanism adds an increased safety feature by eliminating an instance of user error, and the stacking cups mean efficient storage and transport when the carts are not in use. All Carts are modular in construction and stack and store with one another.

### Specifications

- The B&B Conduit / Pipe Tree separates rounds, and the upright portions fold down for stacking, storage and transport.
- Two versions of Conduit Carts are available. PN 2032 offers increased base supports and flooring, while the PN 2033 (Economy) share functions of PN 2032, but designed for the price point consumer.
- The hinge mechanism gravity locks into place for set up, and a simple pull of the pin unlocks the uprights for easy folding.
- Two 6" static wheels, and two 6" swivel wheels allow easy movement through tight working environments.
- 1,000 lbs. weight capacity.
- 57" L x 34" W x 61-1/2" H (Folded height - 20")



**Patent Pending Gravity Lock System**  
safely secures tube uprights in position!



**PN 2031, PN 2032 and PN 2033 (Economy) all Fold and Stack** for efficient transport and storage!

**PN 2032 = Shipping weight 203 lbs.**

**PN 2033 = Shipping weight 160 lbs. (Economy)**

PN	WEIGHT CAPACITY	FOOTPRINT	SHIPPING WEIGHT
2032	1,000 lbs. / 453 kg	57" x 34" x 20" / 144 x 86 x 50 cm	203 lbs. / 92 kg
2033	1,000 lbs. / 453 kg	57" x 34" x 20" / 144 x 86 x 50 cm	160 lbs. / 72 kg

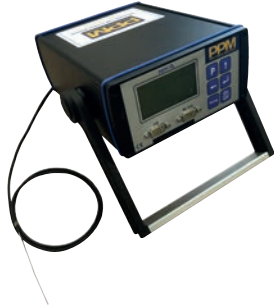
# PPM

PIPE PURGE MASTERS

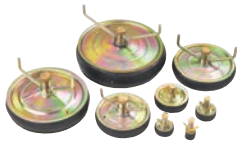
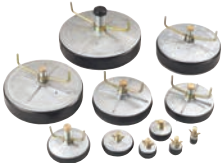
## PIPE PURGING SYSTEMS



## PURGE OXYGEN MONITORS



## PIPE STOPPERS



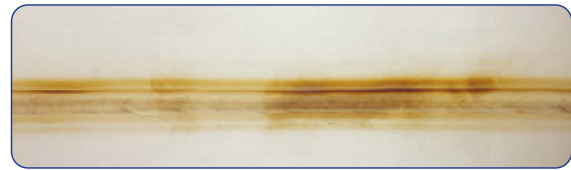


## WHY PURGE?

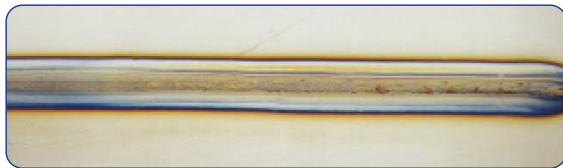
When welding stainless steel, titanium and other corrosion resistant materials, the perfect environment for welding is paramount to maintaining the corrosion resistant properties. During the welding process, the weld seam is subjected to heat and air, which causes oxidation, if the correct processes are not adhered to. For the best results, oxidation must be prevented. The quality of the exotic corrosion resistant material welding is dependent on the correct purging methods to minimize or eliminate oxidation.



Argon Purge 12ppm  
Vol. O<sup>2</sup> Content



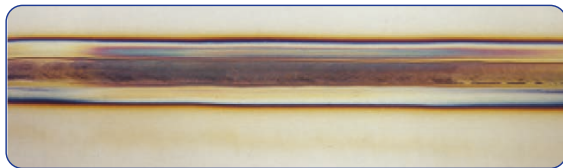
Argon Purge 60ppm  
Vol. O<sup>2</sup> Content



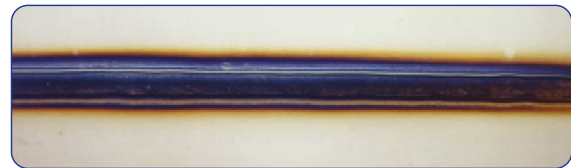
Argon Purge 70ppm  
Vol. O<sup>2</sup> Content



Argon Purge 200ppm  
Vol. O<sup>2</sup> Content



Argon Purge 250ppm  
Vol. O<sup>2</sup> Content



Argon Purge 500ppm  
Vol. O<sup>2</sup> Content

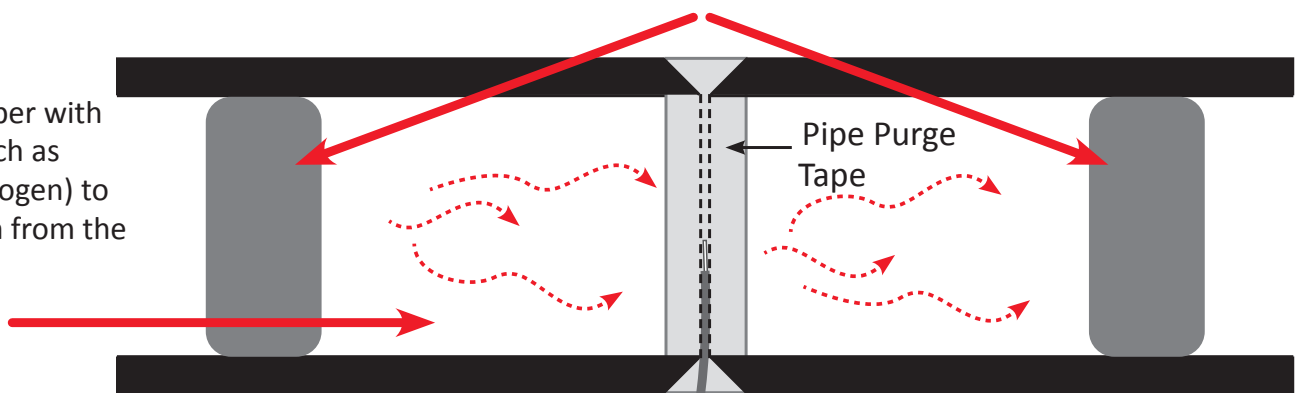
## Weld Quality

The effective welding of stainless steel, titanium and other exotic materials for the nuclear, petrochemical, pharmaceutical, semi-conductor, aerospace and food industries requires the proper tools to create a perfect weld environment. Purging equipment and its use has a major impact on preventing oxidation and improving final weld quality. The basic principles of purging can be seen below. PPM supplies a comprehensive range of systems to create the correct welding environment, whatever the application.

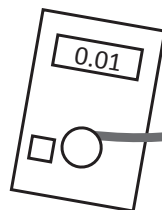
## Principles of Purging

1. Create a seal (dam) either side of the weld and close off the weld gap with E-Z Zone Purge Tape to create the weld chamber

2. Fill the chamber with inert gas (such as argon or nitrogen) to expel oxygen from the chamber



3. Use a weld purge monitor to recognize when the required level of oxygen has been met



4. Welding can then be carried out, guaranteeing no oxidation or discoloration of the weld

## Double Inflatable Pipe Weld Purging Systems

Used for 90% of the traditional pipe weld purging applications to provide bright, shiny, oxide free weld roots. The PPM Pipe Purge System is quick and easy to use providing a very rapid weld purge. High quality materials are used in the manufacture of these systems guaranteeing perfect oxide-free weld roots in very little time.



Luminous strip allows the operator to locate the centre of the bag system to the weld gap with ease



The Gas Release Valve is pre-set and sealed, so requires no adjustment

Due to the design of these systems, the volume of gas used to purge is minimized, resulting in significant savings in both time and the quantity of inert gas used. Return on investment can be achieved in as little as just one or two welds. These robust systems can be used over and over again paying for themselves in very little time.

## Features and Advantages

- PPM's Inflatable Pipe Purging Systems dramatically reduce purging times leading to significant savings in labor costs
- **Typical purge times for 4" pipe = 1½ mins; 8" pipe = 4 mins; 12" pipe = 8 mins**
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 20l a min. Through the pre-set purge valve
- Gas pressure control ensures an even positive root bead with no notching
- Quick and easy to install simplifying the process of inert gas purging
- Heat resistant up to 70°C continuously
- Use less inert gas. The volume of purge gas used is less than 2% of that required for a conventional purge

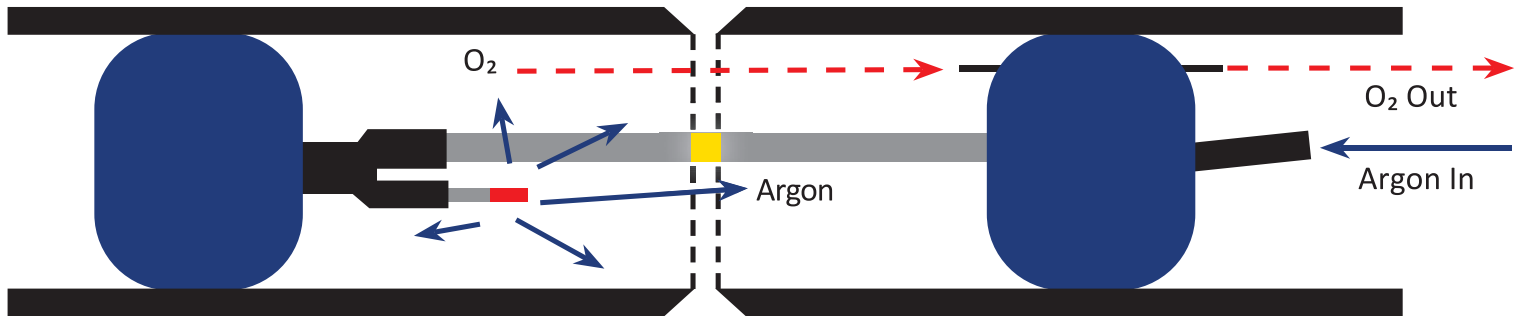


## How it works

The Purge Bag Systems in the range manufactured by PPM are designed around the principle of using 2 dams to create a seal either side of the weld, just far enough away from the weld not to be effected by heat but close enough to the joint to provide the fastest weld purge time. These dams are connected by an armoured spinal tube.

Once ready to start purging, the system is inserted into the bore of the pipe using the luminous strip to centre the system to the weld gap.

When the gas flow is started, the dams inflate and, upon reaching the pre-set pressure, the valve releases the gas gently into the weld chamber, to purge the interspace without turbulence. The Oxygen is removed from the weld chamber through the integral exhaust tubes in the bags. Used in conjunction with PPM's Oxygen Monitors to indicate when the required low level of oxygen has been reached, welding can then commence, with the inert gas enabling the welder to produce an even oxidation free penetration weld bead. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of these systems means that only one gas connection is required for both dam inflation and weld purging.



## Sizing and Specification

PART NO.	NOMINAL PIPE SIZE		WEIGHT	INTERNAL DIAMETER RANGE
PB02	50 mm	2"	1 lbs. / 0.34 kg	1.73 - 2.24 / 44 - 57 mm
PB03	75 mm	3"	1 lbs. / 0.34 kg	2.28 - 3.30 / 58 - 84 mm
PB04	100 mm	4"	1 lbs. / 0.34 kg	3.14 - 4.33 / 80 - 110 mm
PB05	125 mm	5"	1 lbs. / 0.38 kg	4.05 - 5.31 / 103 - 135 mm
PB06	150 mm	6"	1 lbs. / 0.38 kg	4.88 - 6.37 / 124 - 162 mm
PB08	200 mm	8"	2 lbs. / 0.90 kg	6.88 - 8.38 / 175 - 213 mm
PB10	250 mm	10"	2 lbs. / 1 kg	9.05 - 10.43 / 230 - 265 mm
PB12	300 mm	12"	2 lbs. / 1.1 kg	10.43 - 12.00 / 265 - 305 mm
PB14	350 mm	14"	2 lbs. / 1.3 kg	12.99 - 13.97 / 330 - 355 mm
PB16	400 mm	16"	3 lbs. / 1.7 kg	14.96 - 15.94 / 380 - 405 mm
PB18	450 mm	18"	3 lbs. / 1.8 kg	16.92 - 17.91 / 430 - 455 mm
PB20	500 mm	20"	4 lbs. / 1.9 kg	19.09 - 20.07 / 485 - 510 mm
PB22	550 mm	22"	4 lbs. / 2.2 kg	21.06 - 22.04 / 535 - 560 mm
PB24	600 mm	24"	5 lbs. / 2.5 kg	23.03 - 24.01 / 585 - 610 mm

*Larger sizes and specials available on request, however Rapid Purge on pages 72 and 73 strongly recommended over 12"*





# RAPID PURGE™ SYSTEM

Sizes: 8 - 80" (190 - 2,044 mm)



## Purge larger diameter pipes faster than ever!

Used for Stainless, duplex, chrome steels, titanium, nickel and other alloy materials, the PPM Pipe Purge Bag System™ systems enable high speed welding of larger diameter pipe joints that have to be purged.

Designed to enable the user to produce high quality, reliable and repeatable welding of stainless steel tube and pipe joints to ensure a very fast weld purge time and a very high quality weld root, free from oxidation and discoloration.

A 36" diameter pipe will purge to below 0.1% oxygen in less than 10 minutes and all smaller pipes correspondingly faster.

Dramatic savings of time, gas and money can be made by using these systems.

Due to the quality of the materials used, the Rapid Purge™ systems can be used over and over again further reducing manufacturing costs.

As with all of the PPM Pipe Purge Bag System inflatable purging systems, the Rapid Purge™ come with pre-set valves, so are ready to use 'straight out of the box'.

Rapid Purge™ has been developed specifically to enable high speed purging for any pipe welding application.



## Features and Advantages

- **Typical purge times of less than 10 minutes!!!**
- The unique "thru-bore" design of the central sleeve minimizes the area to be purged, dramatically reducing the volume of gas required
- Friction free coatings allow easy movement through pipes from one joint to another, even around bends and elbows
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 80l/min. through the twin pre-set purge valve
- A central (glow in the dark) strip allows fast and accurate alignment of the system to the center-point of the weld area
- The inflatable dams and umbilical hose are covered with a heat resistant material and insulated accordingly for use at temperatures up to 250°C





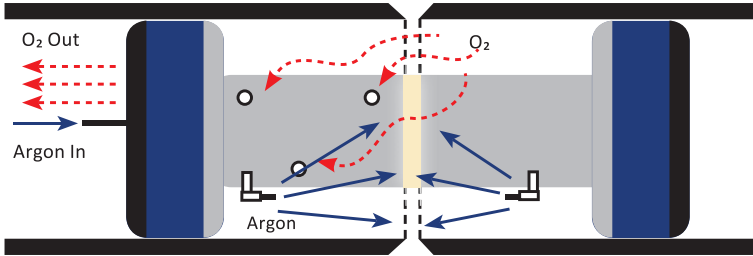
## How it works

The Rapid Purge™ Inflation Pipe Purging Systems for pipe and vessel purging comprises a tandem inflatable dam system connected by an umbilical hose and collar to reduce the volume being purged.

A gas exhaust valve is installed between the primary and secondary dam, along with an auxiliary argon purge line.

Each Rapid Purge™ System is covered with heat protective material, so that the higher temperatures closer to the weld do not damage the system.

The robust design of the Rapid Purge™ Inflation Pipe Weld Purging Systems allows for many years of repeatable trouble free use.



## Sizing and Specification

PART NO.	DESCRIPTION	PRODUCT SIZES		EXPANSION RANGE	WEIGHT
RP08	Rapid Purge™	200 mm	8"	7.48" - 8.46" / 190 - 215 mm	3 lbs. / 1.4 kg
RP10	Rapid Purge™	250 mm	10"	9.52" - 10.51" / 242 - 267 mm	3 lbs. / 1.7 kg
RP12	Rapid Purge™	300 mm	12"	11.45" - 12.44" / 291 - 316 mm	4 lbs. / 2.1 kg
RP14	Rapid Purge™	350 mm	14"	12.51" - 13.50" / 318 - 343 mm	5 lbs. / 2.5 kg
RP16	Rapid Purge™	400 mm	16"	14.52" - 15.51" / 369 - 394 mm	5 lbs. / 2.7 kg
RP18	Rapid Purge™	450 mm	18"	16.53" - 17.51" / 420 - 445 mm	6 lbs. / 3 kg
RP20	Rapid Purge™	500 mm	20"	18.54" - 19.52" / 471 - 496 mm	7 lbs. / 3.4 kg
RP22	Rapid Purge™	550 mm	22"	21.77" - 22.71" / 553 - 577 mm	7 lbs. / 3.6 kg
RP24	Rapid Purge™	600 mm	24"	22.51" - 23.50" / 572 - 597 mm	8 lbs. / 3.8 kg
RP26	Rapid Purge™	650 mm	26"	24.40" - 25.39" / 620 - 645 mm	9 lbs. / 4.5 kg
RP28	Rapid Purge™	700 mm	28"	26.41" - 27.40" / 671 - 696 mm	12 lbs. / 5.5 kg
RP30	Rapid Purge™	750 mm	30"	28.42" - 29.40" / 722 - 747 mm	13 lbs. / 6 kg
RP32	Rapid Purge™	800 mm	32"	30.39" - 31.37" / 772 - 797 mm	17 lbs. / 8 kg
RP36	Rapid Purge™	900 mm	36"	34.40" - 35.39" / 874 - 899 mm	20 lbs. / 9.1 kg
RP40	Rapid Purge™	1,000 mm	40"	38.97" - 39.96" / 990 - 1,015 mm	21 lbs. / 9.9 kg
RP42	Rapid Purge™	1,050 mm	42"	40.27" - 41.25" / 1,023 - 1,048 mm	29 lbs. / 13.2 kg
RP44	Rapid Purge™	1,100 mm	44"	44.29" - 45.27" / 1,125 - 1,150 mm	30 lbs. / 13.7 kg
RP48	Rapid Purge™	1,200 mm	48"	46.25" - 47.24" / 1,175 - 1,200 mm	33 lbs. / 15 kg
RP54	Rapid Purge™	1,371 mm	54"	53.50" - 54.48" / 1,359 - 1,384 mm	39 lbs. / 18 kg
RP60	Rapid Purge™	1,524 mm	60"	59.52" - 60.51" / 1,512 - 1,537 mm	44 lbs. / 20 kg
RP72	Rapid Purge™	1,828 mm	72"	71.49" - 72.48" / 1,816 - 1,841 mm	61 lbs. / 28 kg
RP80	Rapid Purge™	2,032 mm	80"	79.48" - 80.47" / 2,019 - 2,044 mm	66 lbs. / 30 kg

Larger sizes and specials available on request

## Systems for the fast Purging of High Temperature Pipework

The PPM Pipe Purge Bag and Rapid Purge Systems are both available as heat resistant versions.

Designed for use when high temperatures will be encountered during the process of pipe welding; such as pre-heated pipework, and pipes where very high temperatures are required for welding.

These versions of our inflatable pipe purging systems are heat resistant up to 350°C (572°F) for up to 24 hours, or up to 500°C for short periods of time, as with the standard systems, the heat resistant systems are available for all pipe diameters from 3 - 80" (63 - 2,035 mm).

Mirroring the features of the standard range of inflatable purging systems, the heat resistant range comes with a central band for rapid centering of the system to the weld root for the fastest set up times.

The welder can position these systems prior to pre-heating and leave them in place throughout the pre-heating, welding and post-heat treatment cycles, allowing the weld to be purged continuously for up to 24 hours if necessary.



*e.g. 7" Pipe will purge in less than 4 minutes!*

## Features and Advantages

- Heat resistant up to 350°C (572°F) for up to 24 hours, or up to 500°C for short periods
- Available for all pipe diameters from 3 to 80" (63 to 2,044 mm)
- Designed to be flexible, for ease of insertion, use and withdrawal from pipes, bends, elbows etc. Suitable for 24 hour cycles including pre-heat, welding and post-weld heat treatment
- A central strip allows fast and accurate alignment of the system to the center-point of the weld area
- Manufactured to Nuclear Quality Standards with nuclear approved materials, these systems guarantee bright, shiny, coke and oxide-free welds
- Designed and manufactured specifically for the power industry where high strength chrome alloy Steels are more frequently used
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate (Purge Bags - up to 20l/min/Rapid Purge up to 80l/min) through the twin pre-set purge valve

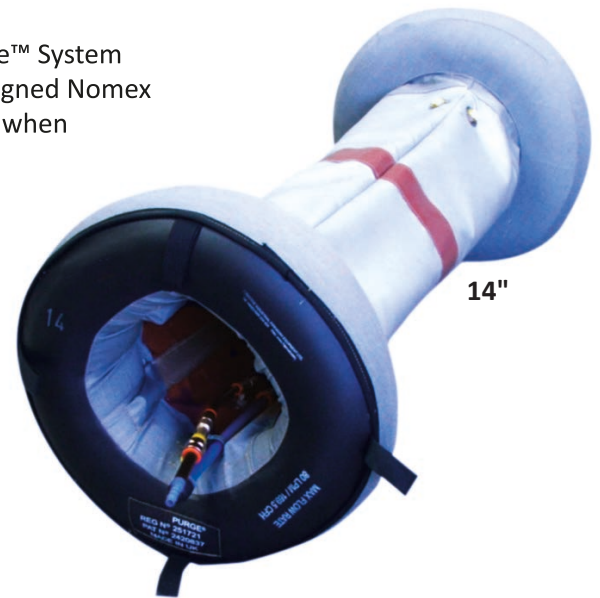
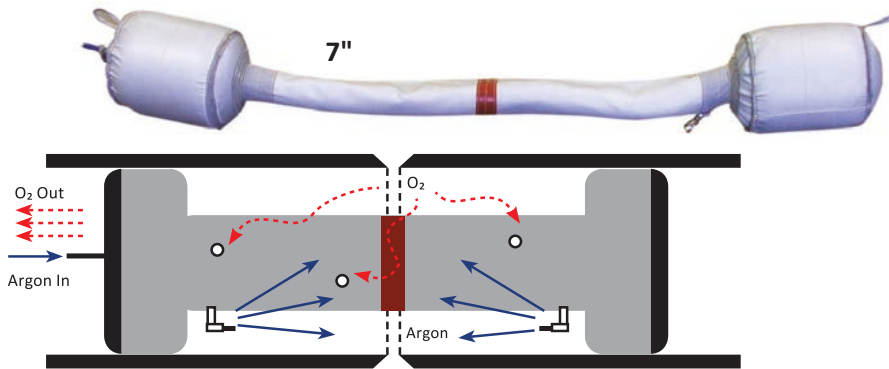


**Heat Resistant  
Rapid Purge**

*e.g. 36" Pipe will purge  
in less than 10 minutes!*

## How it works

Both the Heat Resistant Pipe Purge System and the Heat Resistant Rapid Purge™ System work identically to the standard systems, but are made using a purposely designed Nomex and Kevlar mix material to withstand the temperatures typically encountered when welding exotic materials.



## Sizing and Specification

PART NO.	DESCRIPTION	PRODUCT SIZES		EXPANSION RANGE	WEIGHT
PB03/HR	Purge Bag Heat Resistant	76 mm	3"	2.48" - 2.95" / 63 - 75 mm	2 lbs. / 1.1 kg
PB04/HR	Purge Bag Heat Resistant	100 mm	4"	3.62" - 3.93" / 92 - 100 mm	2 lbs. / 1.2 kg
PB05/HR	Purge Bag Heat Resistant	125 mm	5"	4.44" - 4.92" / 113 - 125 mm	2 lbs. / 1.25 kg
PB06/HR	Purge Bag Heat Resistant	150 mm	6"	5.43" - 5.90" / 138 - 150 mm	2 lbs. / 1.3 kg
PB07/HR	Purge Bag Heat Resistant	175 mm	7"	6.41" - 6.88" / 163 - 175 mm	3 lbs. / 1.4 kg
RP08/HR	Rapid Purge™ Heat Resistant	200 mm	8"	7.48" - 8.46" / 190 - 215 mm	3 lbs. / 1.4 kg
RP10/HR	Rapid Purge™ Heat Resistant	250 mm	10"	9.52" - 10.51" / 242 - 267 mm	3 lbs. / 1.7 kg
RP12/HR	Rapid Purge™ Heat Resistant	300 mm	12"	11.45" - 12.44" / 291 - 316 mm	4 lbs. / 2.1 kg
RP14/HR	Rapid Purge™ Heat Resistant	350 mm	14"	12.51" - 13.50" / 318 - 343 mm	5 lbs. / 2.5 kg
RP16/HR	Rapid Purge™ Heat Resistant	400 mm	16"	14.52" - 15.51" / 369 - 394 mm	5 lbs. / 2.7 kg
RP18/HR	Rapid Purge™ Heat Resistant	450 mm	18"	16.53" - 17.51" / 420 - 445 mm	6 lbs. / 3 kg
RP20/HR	Rapid Purge™ Heat Resistant	500 mm	20"	18.54" - 19.52" / 471 - 496 mm	7 lbs. / 3.4 kg
RP22/HR	Rapid Purge™ Heat Resistant	550 mm	22"	21.77" - 22.71" / 553 - 577 mm	7 lbs. / 3.6 kg
RP24/HR	Rapid Purge™ Heat Resistant	600 mm	24"	22.51" - 23.50" / 572 - 597 mm	8 lbs. / 3.8 kg
RP26/HR	Rapid Purge™ Heat Resistant	650 mm	26"	24.40" - 25.39" / 620 - 645 mm	9 lbs. / 4.5 kg
RP28/HR	Rapid Purge™ Heat Resistant	700 mm	28"	26.41" - 27.40" / 671 - 696 mm	12 lbs. / 5.5 kg
RP30/HR	Rapid Purge™ Heat Resistant	750 mm	30"	28.42" - 29.40" / 722 - 747 mm	13 lbs. / 6 kg
RP32/HR	Rapid Purge™ Heat Resistant	800 mm	32"	30.39" - 31.37" / 772 - 797 mm	17 lbs. / 8 kg
RP36/HR	Rapid Purge™ Heat Resistant	900 mm	36"	34.40" - 35.39" / 874 - 899 mm	20 lbs. / 9.1 kg
RP40/HR	Rapid Purge™ Heat Resistant	1,000 mm	40"	38.99" - 39.96" / 990 - 1,015 mm	21 lbs. / 9.9 kg
RP42/HR	Rapid Purge™ Heat Resistant	1,050 mm	42"	40.27" - 41.25" / 1,023 - 1,048 mm	29 lbs. / 13.2 kg
RP44/HR	Rapid Purge™ Heat Resistant	1,100 mm	44"	44.29" - 45.27" / 1,125 - 1,150 mm	30 lbs. / 13.7 kg
RP48/HR	Rapid Purge™ Heat Resistant	1,200 mm	48"	46.25" - 47.24" / 1,175 - 1,200 mm	33 lbs. / 15 kg
RP54/HR	Rapid Purge™ Heat Resistant	1,371 mm	54"	53.50" - 54.48" / 1,359 - 1,384 mm	39 lbs. / 18 kg
RP60/HR	Rapid Purge™ Heat Resistant	1,524 mm	60"	59.52" - 60.51" / 1,512 - 1,537 mm	44 lbs. / 20 kg
RP72/HR	Rapid Purge™ Heat Resistant	1,828 mm	72"	71.49" - 72.48" / 1,816 - 1,841 mm	61 lbs. / 28 kg
RP80/HR	Rapid Purge™ Heat Resistant	2,031 mm	80"	79.48" - 80.47" / 2,019 - 2,044 mm	66 lbs. / 30 kg

Larger sizes and specials available on request



## Purge pipes fast with minimal gas usage

PPM also manufactures The Silicone Double Seal purging system that has been designed to further reduce both inert gas use and purging time. These systems use silicon discs to form an airtight seal, reducing purge times, and gas usage for maximum efficiency.

There are 2 styles of silicon double seal systems available:

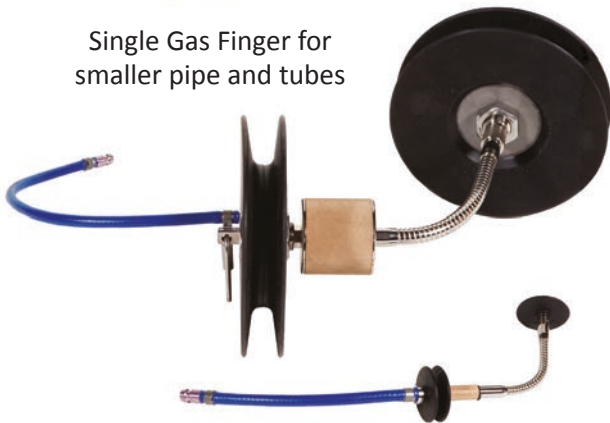
- The Gas Finger system is designed for small pipes and tubes from 16 - 38 mm i/d
- The Double Seal systems are made for pipes from ¾ - 12" (16 - 320 mm)

## Features and Advantages

- Typical purge times of less than 2 minutes (e.g. an 8" pipe will purge to below 0.01% Oxygen in less than 2 minutes)
- High quality silicon sealing disks that prevent them tilting or falling over inside the pipe
- Guaranteed gas tight seal
- UV and temperature resistant up to 330°C continuously or 450°C for short periods
- Suitable for purging pipes, elbows and fittings
- The silicon seal units can be separated and used as a gas finger and pipe stopper respectively



Single Gas Finger for smaller pipe and tubes



Shown with flexible hose connection for purging elbows and fittings.



Available as a kit (3 sizes)

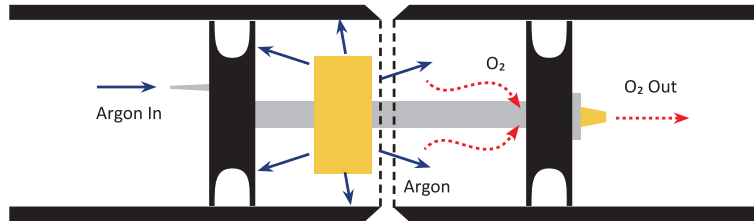
## How it works

The gas inlet and outlet are provided with twin sealing discs separated by a flexible, rigid or a spring-type tube. The design also guarantees that at least one disc will always remain tight to the pipe wall creating a 100% seal. The discs are UV and temperature-resistant up to 330°C continuously or up to 450°C for short periods. The gas is diffused into the chamber via the built in sintered diffuser and exits through the exhaust holes in the secondary twin disc unit.

This process of gas diffusion provides an even flow of gas and prevents any gas turbulence behind the weld, thereby minimizing the risk of oxygen in the welding chamber while, at the same time, achieving an extremely short purge time. These extremely short purge times result in valuable cost savings in gas and time.

Besides the very short purging time, the Silicon Seal System also offers the possibility to cover various nominal pipe diameters by one pair of baffles enabling highly economic use of the device.

The double seal system can be purchased individually or in kit form for a range of pipe diameters.



## Sizing and Specification

PART NO.	DESCRIPTION	PIPE I/D RANGE	HOSE LENGTH
DS16-19	Flex	0.62" - 0.74" / 16 - 19 mm	3.93" / 100 mm
DS19-24	Flex	0.74" - 0.94" / 19 - 24 mm	3.93" / 100 mm
DS24-29	Flex	0.94" - 1.14" / 24 - 29 mm	3.93" / 100 mm
DS29-34	Flex	1.14" - 1.33" / 29 - 34 mm	3.93" / 100 mm
DS34-38	Flex	1.33" - 1.49" / 34 - 38 mm	3.93" / 100 mm
DS38-43	Flexible or Rigid	1.49" - 1.69" / 38 - 43 mm	4.72" - 2.36" / 120/60 mm
DS43-48	Flexible or Rigid	1.69" - 1.88" / 43 - 48 mm	4.72" - 2.36" / 120/60 mm
DS47-53	Flexible or Rigid	1.85" - 2.08" / 47 - 53 mm	4.72" - 2.36" / 120/60 mm
DS52-58	Flexible or Rigid	2.04" - 2.28" / 52 - 58 mm	4.72" - 2.36" / 120/60 mm
DS64-72	Flexible or Rigid	2.51" - 2.83" / 64 - 72 mm	4.72" - 2.36" / 120/60 mm
DS78-86	Flexible or Rigid	3.07" - 3.38" / 78 - 86 mm	4.72" - 2.36" / 120/60 mm
DS90-101	Flexible or Rigid	3.54" - 3.97" / 90 - 101 mm	5.90" - 3.93" / 150/100 mm
DS100-112	Flexible or Rigid	3.93" - 4.40" / 100 - 112 mm	5.90" - 3.93" / 150/100 mm
DS120-130	Flexible or Rigid	4.72" - 5.11" / 120 - 130 mm	5.90" - 3.93" / 150/100 mm
DS124-138	Flexible or Rigid	4.88" - 5.43" / 124 - 138 mm	5.90" - 3.93" / 150/100 mm
DS144-155	Flexible or Rigid	5.66" - 6.10" / 144 - 155 mm	5.90" - 3.93" / 150/100 mm
DS150-165	Flexible or Rigid	5.90" - 6.49" / 150 - 165 mm	5.90" - 3.93" / 150/100 mm
DS197-206	Flexible or Rigid	7.75" - 8.11" / 197 - 206 mm	5.90" - 3.93" / 150/100 mm
DS209-220	Flexible or Rigid	8.22" - 8.66" / 209 - 220 mm	5.90" - 3.93" / 150/100 mm
DS246-257	Flexible or Rigid	9.68" - 10.11" / 246 - 257 mm	5.90" - 3.93" / 150/100 mm
DS260-280	Flexible or Rigid	10.23" - 11.02" / 260 - 280 mm	5.90" - 3.93" / 150/100 mm
DS290-320	Flexible or Rigid	11.41" - 12.59" / 290 - 320 mm	5.90" - 3.93" / 150/100 mm
DSK16-165	Complete Kit	0.62" - 6.49" / 16 - 165 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm
DSK16-220	Complete Kit	0.62" - 8.66" / 16 - 220 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm
DSK16-320	Complete Kit	0.62" - 12.59" / 16 - 320 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm

## Purge pipes fast with minimal gas usage

PPM also manufactures The Silicone Double Seal purging system that has been designed to further reduce both inert gas use and purging time. These systems use silicon discs to form an airtight seal, reducing purge times, and gas usage for maximum efficiency.

## Features and Advantages

- Typical purge times of less than 2 minutes (e.g. an 8" Pipe will purge to below 0.01% Oxygen in less than 2 minutes)
- High quality silicon sealing disks that prevent them tilting or falling over inside the pipe
- Guaranteed gas tight seal
- UV and temperature resistant up to 330°C continuously or 450°C for short periods
- Suitable for purging pipes to flanges



## Sizing and Specification

PART NO.	DESCRIPTION	PIPE I/D RANGE	HOSE LENGTH
FDS16-19	Flex	0.63" - 0.75" / 16 - 19 mm	3.93" / 100 mm
FDS19-24	Flex	0.75" - 0.94" / 19 - 24 mm	3.93" / 100 mm
FDS24-29	Flex	0.94" - 1.14" / 24 - 29 mm	3.93" / 100 mm
FDS29-34	Flex	1.14" - 1.34" / 29 - 34 mm	3.93" / 100 mm
FDS34-38	Flex	1.34" - 1.50" / 34 - 38 mm	3.93" / 100 mm
FDS38-43	Flexible or Rigid	1.50" - 1.69" / 38 - 43 mm	4.72" - 2.36" / 120/60 mm
FDS43-48	Flexible or Rigid	1.69" - 1.89" / 43 - 48 mm	4.72" - 2.36" / 120/60 mm
FDS47-53	Flexible or Rigid	1.85" - 2.09" / 47 - 53 mm	4.72" - 2.36" / 120/60 mm
FDS52-58	Flexible or Rigid	2.05" - 2.28" / 52 - 58 mm	4.72" - 2.36" / 120/60 mm
FDS64-72	Flexible or Rigid	2.52" - 2.83" / 64 - 72 mm	4.72" - 2.36" / 120/60 mm
FDS78-86	Flexible or Rigid	3.07" - 3.39" / 78 - 86 mm	4.72" - 2.36" / 120/60 mm
FDS90-101	Flexible or Rigid	3.54" - 3.98" / 90 - 101 mm	5.90" - 3.93" / 150/100 mm
FDS100-112	Flexible or Rigid	3.93" - 4.41" / 100 - 112 mm	5.90" - 3.93" / 150/100 mm
FDS120-130	Flexible or Rigid	4.72" - 5.12" / 120 - 130 mm	5.90" - 3.93" / 150/100 mm
FDS124-138	Flexible or Rigid	4.85" - 5.43" / 124 - 138 mm	5.90" - 3.93" / 150/100 mm
FDS144-155	Flexible or Rigid	5.67" - 6.10" / 144 - 155 mm	5.90" - 3.93" / 150/100 mm
FDS150-165	Flexible or Rigid	5.91" - 6.50" / 150 - 165 mm	5.90" - 3.93" / 150/100 mm
FDS197-206	Flexible or Rigid	7.76" - 8.11" / 197 - 206 mm	5.90" - 3.93" / 150/100 mm
FDS209-220	Flexible or Rigid	8.23" - 8.66" / 209 - 220 mm	5.90" - 3.93" / 150/100 mm
FDS246-257	Flexible or Rigid	9.69" - 10.12" / 246 - 257 mm	5.90" - 3.93" / 150/100 mm
FDS260-280	Flexible or Rigid	10.24" - 11.02" / 260 - 280 mm	5.90" - 3.93" / 150/100 mm
FDS290-320	Flexible or Rigid	11.92" - 12.60" / 290 - 320 mm	5.90" - 3.93" / 150/100 mm
FDSK16-165	Complete Kit	0.63" - 6.50" / 16 - 165 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm
FDSK16-220	Complete Kit	0.63" - 8.66" / 16 - 220 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm
FDSK16-320	Complete Kit	0.63" - 12.60" / 16 - 320 mm	4.72" - 2.36" / 120/60 mm    5.90" - 3.93" / 150/100 mm



# HANDY PURGE 100 SELF CALIBRATING WELD PURGE MONITOR

Measures oxygen levels down to 0.01% (100ppm)



## The entry level, welders' toolbox monitor

Inert gas welding requires the exclusion of oxygen from the weld zone during the welding process. Prior to the welding process, the residual oxygen concentration must be reduced to a required minimum. The Handy Purge is specifically designed to indicate oxygen concentration up to 0.01% and to exactly measure oxygen concentration up to 0.1%. Within this range, it is absolutely safe to weld and produce an oxygen-free weld seam (exceptions include special metals such as titanium, zirconium, etc.).

The Handy Purge can be used both for continuous monitoring during the welding process and for taking samples. Routine inspections for quality control are extremely simplified using this device. The analyser works with all purge systems and argon welding systems. It is small, easy to handle and has a rugged enclosure.

## Features and Advantages

- Self calibrating
- Minimum waiting time. The device tells you exactly when the residual oxygen concentration of a purge gas is low enough to start welding. You need no longer rely on rough estimations. This saves both time and gas.
- Reduced purge gas consumption. Exact monitoring of the residual oxygen avoids unnecessary purge gas consumption and allows you to produce oxygen-free weld seams
- Top-quality weld seams
- Top quality is guaranteed, as too early welding and hence porous, colored or even charred weld seams can be avoided
- Duplex / Stainless Steel. The Handy Purge Weld Purge Monitor can be used for all stainless steel, duplex and certain titanium welding applications
- Eliminates guess work



TECHNICAL SPECIFICATIONS	
Part No.	HP100SC
Measuring range	0.01 % - 20.9 % Oxygen (O <sup>2</sup> ) (10ppm - 209,000ppm)
Accuracy	at 20% ± 0.2% at 2% ± 0.02%
Dimensions	6" x 3" x 1" / 155 x 81 x 38 mm
Power source	Battery Type PP3 9V
Display	LCD (Liquid Crystal Display)
Weight	1 lbs. / 210 g
DIMENSIONS AND WEIGHT FOR SHIPMENT	
Dimensions	12" x 10" x 3" / 310 x 260 x 80 mm
Weight	2 lbs. / 870g

Replacement sensors and spares available from stock

### The kit consists of:

- Handy Purge Weld Purge Monitor
- 1m hose with flow adapter
- Stainless Steel probe
- Vacuum hand pump
- Plastic Carry Case
- Instructions
- Calibration Certificate



# HANDY PURGE PRO 5 WELD PURGE MONITOR

*The most accurate hand-held digital oxygen monitor  
Measures oxygen levels down to 0.0005% (5ppm)*

## For applications where minimal oxidation is critical

The Handy Purge Pro 5 is the ultimate hand-held Oxygen monitor, measuring the level of oxygen in the designated atmosphere down to 5ppm (parts per million)!!! The new Handy Purge Pro 5 Weld Purge Monitor is essential for reading oxygen levels for titanium welding.

The interface option enables the Handy Purge Pro 5 to be connected (via a cable or Bluetooth dongle) to a PC and printer to record the readings. A rechargeable battery pack and multi range power plug are standard features of the Handy Purge Pro 5, and its light weight and ergonomic shape make it the ideal portable instrument for all orbital welding applications.

The unit incorporates an internal pump and is designed for measuring rest oxygen in inert gases such as argon. This unit can be used up to 4 hours before recharging is necessary.

## Features and Advantages

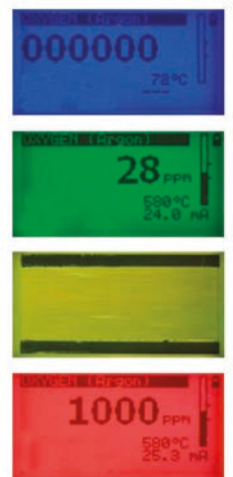
- Measures oxygen levels down to 5ppm (parts per million)
- Rechargeable batteries, standby life approx. 4hrs
- Temperature regulated zirconium cell (maintenance free)
- Graphic display screen changes color relative to process and function
- Built-in recognition for 110V/240V power sources
- Portable for remote and difficult access sites using rechargeable batteries (supplied)
- Integrated programmable sound function
- Multi language: English, French and German
- Low permeability measuring hose for accurate measurements
- Data logging of up to 250 entries - Connects via RS 232 interface or Bluetooth



TECHNICAL DATA	
Part No.	HPP5
Measuring Range	5 - 999ppm
Dimensions	11" x 5" x 2" (L x W x H) 290 x 130 x 60 mm
Weight	2 lbs. / 0.8 kg
Supply Voltage	7 VDC, 2850 mAh rechargeable batteries



Supplied in a durable carry case



Color changing display for quick reference to monitor status





# PRO PURGE 1 WELD PURGE MONITOR

Measures oxygen levels down to 0.00005% (0.5ppm)

## The top of the range portable, digital oxygen monitor

- Accuracy to 0.5 ppm
- Temperature regulated maintenance free zirconium cell
- Graphic display (blue and white)
- Built-in recognition for 110V/240V power sources
- Internal battery power for up to 90min
- Integrated programmable sound function
- Date and time function for data logging
- Easy to use software
- Low permeability measure hose (FPM) for accurate measurements

The Pro Purge 1 Weld Purge Monitor is the ideal tool for many welding applications where critical weld standards are required.

Used for Production of Semi-conductors, Nuclear, Aerospace, Pharmaceutical, Energy, Dairy, Brewery and Food processing where strict welding guide lines to eliminate weld-quality issues associated with atmosphere contaminated welds are required.

The Pro Purge 1 Weld Purge Monitor enables Welders and Welding Engineers on site or in the workshop to precisely monitor rest oxygen levels to the point where precision welding can take place, resulting in "perfect conditions" for consistent high-quality repeatable welds.

The Pro Purge 1 Weld Purge Monitor contains a stabilized zirconium oxide cell with a regulated heater to maintain a cell temperature of 750°C which enables it to accurately measure levels from 206,400 ppm down to as low as 0.5 ppm.

The zirconium oxide ceramic sensor in the Pro Purge 1 provides very accurate readings, with a deviation of less than 5% in the 1 to 10 ppm range. This means that its resolution is ½ a part per million (0.5ppm).

The Pro Purge 1 Weld Purge Monitor can be unplugged for up to one hour, before the internal battery must be recharged. Making it ideal for testing weld joints in the shop, or in the field.

TECHNICAL DATA	
Part No	PP1
Measuring Range	0.5 - 206,400ppm
Dimensions	8" x 6" x 3" 220 x 165 x 85 mm
Weight	7 lbs. / 3.3 kg
Supply Voltage	110V/240V

- Connects via RS 232 interface, Bluetooth, CAN-Bus, AUX (AMI)
- Can be calibrated to ambient oxygen
- Software updates available
- Multi language: English, French, German, Dutch, Czech, Danish
- Data logging up to 250 entries internally or externally on a PC



Connected via a Bluetooth Dongle with a range of up to 100m to a mobile phone.

Via the phone all relevant data including rest oxygen level, sensor temperature will be displayed. Using simple commands the PRO PURGE 1 can be operated remotely



Connecting a printer via the RS232 interface. Capable of readout documentation (per second) that can be logged via a printer



## Expandable test plugs for purging and general pipe blocking

Pipe stoppers, or drain plugs, as they are sometimes known, are used to temporarily seal the end of a pipe or opening for many different testing applications. Pipe stoppers are mainly used to seal off from water, gases and foreign objects in newly laid pipes, or pipework systems that are under repair. PPM Pipe Purge System range of pipe stoppers are available in a number of different styles to suit many applications for pipe sizes from 1½" - 72". Special Pipe stoppers are also available for pressure testing.



## Aluminium Plugs - 1½" - 36" (40 mm - 900 mm)

To complement the range of nylon expanding plugs, we offer all sizes of Aluminium plugs. These are provided in sizes from 1½" upwards and are suitable for more arduous duties such as immersion in chemicals and/or higher temperatures.

## How it works

A central spindle/shaft on which two plates are fitted with a natural rubber tire (ring) between them, a wing nut on the shaft moving the two plates together compressing the tire and making the seal in the pipe. These stoppers can also be supplied with a hollow shaft version for screwing on standard hose connections or for using fixed or free nipple caps.

Expandable Pipe Stoppers are available in three different types.

PART NO.	PIPE SIZE INTERNAL NOMINAL DIAMETER		WILL FIT PIPES WITH INTERNAL DIAMETER		MINIMUM INSERTION INTO PIPE	OVERALL LENGTH	DIAMETER OF WATERWAY	MAXIMUM ALLOWABLE BACK PRESSURE	APPROX. WEIGHT
	METRIC	IMPERIAL	MINIMUM	MAXIMUM					
<b>ALUMINIUM EXPANDING PIPE STOPPERS SPECIFICATION</b>									
AES1.5	40 mm	1½"	38 mm	50 mm	45 mm	94 mm	½"	30 p.s.i.	1 lbs. / 0.17 kg
AES2	50 mm	2"	49 mm	62 mm	43 mm	90 mm	½"	30 p.s.i.	1 lbs. / 0.22 kg
AES2.5	65 mm	2½"	62 mm	77 mm	43 mm	92 mm	½"	30 p.s.i.	1 lbs. / 0.27 kg
AES3	75 mm	3"	73 mm	89 mm	43 mm	94 mm	½"	20 p.s.i.	1 lbs. / 0.31 kg
AES3.5	90 mm	3½"	84 mm	103 mm	53 mm	96 mm	½"	15 p.s.i.	1 lbs. / 0.36 kg
AES4	100 mm	4"	94 mm	110 mm	47 mm	94 mm	½"	10 p.s.i.	1 lbs. / 0.36 kg
AES4.5	114 mm	4½"	112 mm	130 mm	56 mm	140 mm	½"	10 p.s.i.	1 lbs. / 0.47 kg
AES5	125 mm	5"	125 mm	142 mm	60 mm	95 mm	½"	10 p.s.i.	1 lbs. / 0.79 kg
AES6	150 mm	6"	146 mm	168 mm	48 mm	96 mm	½"	10 p.s.i.	1 lbs. / 0.70 kg
AES7	175 mm	7"	175 mm	200 mm	64 mm	100 mm	1"	7 p.s.i.	4 lbs. / 1.92 kg
AES8	200 mm	8"	193 mm	220 mm	64 mm	100 mm	1"	7 p.s.i.	3 lbs. / 1.59 kg
AES9	225 mm	9"	220 mm	240 mm	64 mm	170 mm	1"	7 p.s.i.	4 lbs. / 2.06 kg
AES10	250 mm	10"	245 mm	270 mm	73 mm	178 mm	1"	7 p.s.i.	5 lbs. / 2.52 kg
AES11	275 mm	11"	274 mm	328 mm	100 mm	200 mm	1"	7 p.s.i.	7 lbs. / 3.45 kg
AES12	300 mm	12"	295 mm	325 mm	77 mm	200 mm	1"	7 p.s.i.	7 lbs. / 3.42 kg
AES13	325 mm	13"	325 mm	360 mm	120 mm	230 mm	1"	5 p.s.i.	10 lbs. / 4.75 kg
AES14	350 mm	14"	350 mm	385 mm	110 mm	215 mm	1"	5 p.s.i.	15 lbs. / 6.95 kg
AES15	375 mm	15"	370 mm	410 mm	110 mm	225 mm	1"	5 p.s.i.	11 lbs. / 5.35 kg
AES16	400 mm	16"	390 mm	435 mm	110 mm	225 mm	1"	5 p.s.i.	13 lbs. / 5.9 kg
AES18	450 mm	18"	445 mm	495 mm	110 mm	225 mm	2"	5 p.s.i.	19 lbs. / 8.75 kg
AES20	500 mm	20"	495 mm	550 mm	145 mm	255 mm	2"	5 p.s.i.	24 lbs. / 11.3 kg
AES21	525 mm	21"	520 mm	575 mm	145 mm	255 mm	2"	3 p.s.i.	26 lbs. / 11.8 kg
AES24	600 mm	24"	595 mm	650 mm	145 mm	255 mm	2"	3 p.s.i.	34 lbs. / 15.85 kg

All plugs conform to British Standards BS8005 for low pressure testing and sealing of pipes.

Larger sizes available upon request



### Nylon Plugs - 1½ - 6" (38 mm - 150 mm)

Nylon plugs are the standard 'Drain Plugs' for testing leak tightness of foul water lines at the time of installation. Furthermore, the range of sizes make these plugs ideal for a number of other applications in the water and gas industries as well as applications in all other industries where pipes are used or where there are holes to be blocked.

PART NO.	PIPE SIZE INTERNAL NOMINAL DIAMETER		WILL FIT PIPES WITH INTERNAL DIAMETER		MINIMUM INSERTION INTO PIPE	OVERALL LENGTH	DIAMETER OF WATERWAY	MAXIMUM ALLOWABLE BACK PRESSURE	APPROX. WEIGHT
	METRIC	IMPERIAL	MINIMUM	MAXIMUM					
<b>NYLON EXPANDING PIPE STOPPERS SPECIFICATION</b>									
NES38	38 mm	1½"	38 mm	42 mm	36 mm	58 mm	n/a solid	15 p.s.i.	1 lbs. / 0.05 kg
NES50	50 mm	2"	48.5 mm	62.2 mm	36 mm	110 mm	0.5" bsp	15 p.s.i.	1 lbs. / 0.05 kg
NES63	63 mm	2½"	65 mm	77 mm	36 mm	110 mm	0.5" bsp	10 p.s.i.	1 lbs. / 0.10 kg
NES75	75 mm	3"	74 mm	86 mm	36 mm	110 mm	0.5" bsp	10 p.s.i.	1 lbs. / 0.10 kg
NES88	88 mm	3½"	82 mm	96 mm	36 mm	110 mm	0.5" bsp	10 p.s.i.	1 lbs. / 0.10 kg
NES100	100 mm	4"	95 mm	105 mm	36 mm	110 mm	0.5" bsp	5 p.s.i.	1 lbs. / 0.15 kg
NES115	115 mm	4½"	114 mm	124 mm	36 mm	110 mm	0.5" bsp	5 p.s.i.	1 lbs. / 0.20 kg
NES125	125 mm	5"	117 mm	127 mm	40 mm	110 mm	0.5" bsp	5 p.s.i.	1 lbs. / 0.20 kg
NES150	150 mm	6"	146 mm	155 mm	42 mm	110 mm	0.5" bsp	5 p.s.i.	1 lbs. / 0.25 kg



### Steel Plugs - 1½ - 36" (40 mm - 900 mm)

PPM Pipe Purge System also manufactures a range of Steel plugs from 1½ - 72" in diameter. These plugs are typically suitable for more arduous duties such as long immersion in water and use at higher temperatures or contact with acidic or alkaline environments for which the Nylon and Aluminium plugs may be unsuitable.

PART NO.	PIPE SIZE INTERNAL NOMINAL DIAMETER		WILL FIT PIPES WITH INTERNAL DIAMETER		MINIMUM INSERTION INTO PIPE	OVERALL LENGTH	DIAMETER OF WATERWAY	MAXIMUM ALLOWABLE BACK PRESSURE	APPROX. WEIGHT
	METRIC	IMPERIAL	MINIMUM	MAXIMUM					
<b>STEEL EXPANDING PIPE STOPPERS SPECIFICATION</b>									
SES1.5	40 mm	1½"	37 mm	50 mm	31 mm	81.5 mm	½"	30 p.s.i.	1 lbs. / 0.16 kg
SES2	50 mm	2"	50 mm	61 mm	32.7 mm	82.8 mm	½"	30 p.s.i.	1 lbs. / 0.18 kg
SES2.5	65 mm	2½"	61 mm	75 mm	33.2 mm	80.5 mm	½"	30 p.s.i.	1 lbs. / 0.26 kg
SES3	75 mm	3"	73 mm	85 mm	34 mm	80.5 mm	½"	20 p.s.i.	1 lbs. / 0.28 kg
SES3.5	89 mm	3½"	84 mm	100 mm	41 mm	81 mm	½"	15 p.s.i.	1 lbs. / 0.36 kg
SES4	100 mm	4"	94 mm	108 mm	37.5 mm	83.3 mm	½"	10 p.s.i.	1 lbs. / 0.41 kg
SES4.5	114 mm	4½"	110 mm	125 mm	40 mm	83.3 mm	½"	10 p.s.i.	1 lbs. / 0.58 kg
SES5	125 mm	5"	124 mm	139 mm	37 mm	83.3 mm	½"	10 p.s.i.	1 lbs. / 0.60 kg
SES6	150 mm	6"	145 mm	160 mm	39.7 mm	83.3 mm	½"	10 p.s.i.	2 lbs. / 0.75 kg
SES7	175 mm	7"	175 mm	200 mm	46 mm	130 mm	1"	7 p.s.i.	3 lbs. / 1.56 kg
SES8	200 mm	8"	195 mm	215 mm	37 mm	130 mm	1"	7 p.s.i.	3 lbs. / 1.47 kg
SES9	225 mm	9"	210 mm	230 mm	58 mm	150 mm	1"	7 p.s.i.	4 lbs. / 1.93 kg
SES10	250 mm	10"	245 mm	260 mm	55 mm	150 mm	1"	7 p.s.i.	6 lbs. / 2.55 kg
SES12	300 mm	12"	296 mm	320 mm	85 mm	150 mm	1"	7 p.s.i.	8 lbs. / 3.72 kg
SES14	350 mm	14"	340 mm	385 mm	85 mm	210 mm	1"	5 p.s.i.	14 lbs. / 6.54 kg
SES15	375 mm	15"	370 mm	415 mm	100 mm	210 mm	1"	5 p.s.i.	15 lbs. / 7.00 kg
SES16	400 mm	16"	390 mm	430 mm	95 mm	210 mm	1"	5 p.s.i.	19 lbs. / 8.45 kg
SES18	450 mm	18"	448 mm	495 mm	100 mm	210 mm	1"	5 p.s.i.	23 lbs. / 10.6 kg
SES20	500 mm	20"	495 mm	550 mm	145 mm	255 mm	2"	3 p.s.i.	25 lbs. / 11.3 kg
SES21	525 mm	21"	520 mm	575 mm	145 mm	255 mm	2"	3 p.s.i.	25 lbs. / 11.5 kg
SES24	600 mm	24"	595 mm	650 mm	145 mm	255 mm	2"	3 p.s.i.	35 lbs. / 15.85 kg

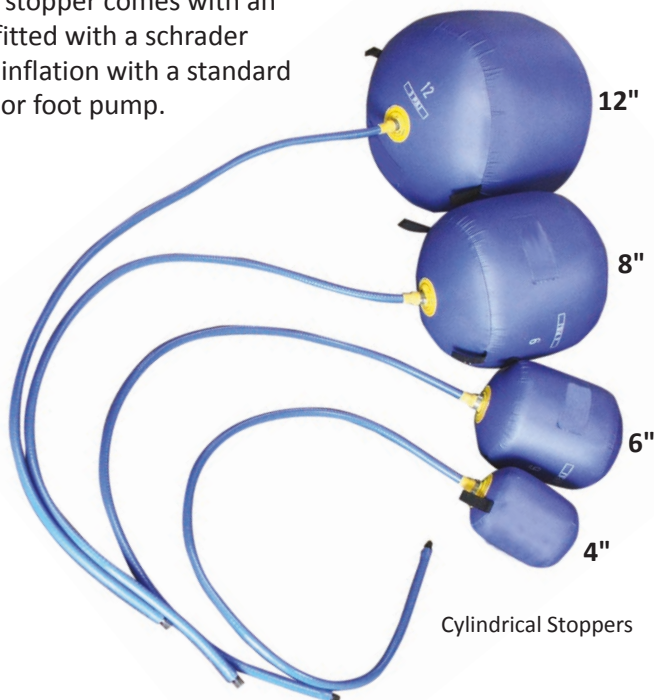
## Single inflatable dams for blocking and testing

PPM offers a range of shapes and sizes of inflatable stoppers, suitable for all applications. Made from a natural rubber bladder covered in waterproof polyurethane coated nylon to prevent friction and static electricity build up.

There are six different types available:

- **Cylindrical** - These are generally used for blocking pipes where access is restricted
- **Spherical** - These stoppers have less contact area than cylindrical stoppers, and are most suited to applications where access is further limited. Due to its shape the spherical inflatable stopper can be used at any angle
- **Square / Rectangular** - These stoppers have a variety of applications, including in air conditioning ducting and venting.
- **Doughnut** - These stoppers require minimal space and are perfectly suited to larger diameter pipes as there is less inflation required
- **Sausage** - The design of this type gives more contact area between the stopper and the pipe wall enabling these stoppers to hold back more pressure
- **Heat Resistant** - These stoppers are made from a specially designed kevlar and nomex mix material to withstand temperatures up to 500°C for applications involving higher temperatures such as pre heating

Each inflatable stopper comes with an inflation hose fitted with a schrader valve enabling inflation with a standard airline, bicycle or foot pump.



Cylindrical Stoppers



Heat Resistant Stopper



Doughnut Stoppers

PPM Pipe Purge System inflatable stoppers are supplied as standard with no through tube. Through tubes can be supplied when the stoppers are required for weld purging applications. When deflated, the inflatable stoppers can be inserted and withdrawn with ease.

## Sizing and Specification

PART NO.	INFLATABLE STOPPER SIZE ( mm / INCH)	MIN ID ( mm)	MAX ID ( mm)
IPS2	50 mm / 2"	1.77" / 45 mm	2.16" / 55 mm
IPS3	75 mm / 3"	2.75" / 70 mm	3.14" / 80 mm
IPS4	100 mm / 4"	3.74" / 95 mm	4.13" / 105 mm
IPS5	125 mm / 5"	4.72" / 120 mm	5.11" / 130 mm
IPS6	150 mm / 6"	5.70" / 145 mm	6.10" / 155 mm
IPS7	175 mm / 7"	6.69" / 170 mm	7.08" / 180 mm
IPS8	200 mm / 8"	7.67" / 195 mm	8.07" / 205 mm
IPS9	225 mm / 9"	8.66" / 220 mm	9.05" / 230 mm
IPS10	250 mm / 10"	9.64" / 245 mm	10.03" / 255 mm
IPS11	275 mm / 11"	10.62" / 270 mm	11.02" / 280 mm
IPS12	300 mm / 12"	11.61" / 295 mm	12.00" / 305 mm
IPS13	325 mm / 13"	12.59" / 320 mm	12.99" / 330 mm
IPS14	350 mm / 14"	13.58" / 345 mm	13.97" / 355 mm
IPS15	375 mm / 15"	14.56" / 370 mm	14.96" / 380 mm
IPS16	400 mm / 16"	15.55" / 395 mm	15.94" / 405 mm
IPS17	425 mm / 17"	16.53" / 420 mm	16.92" / 430 mm
IPS18	450 mm / 18"	17.51" / 445 mm	17.91" / 455 mm
IPS19	475 mm / 19"	18.50" / 470 mm	18.89" / 480 mm
IPS20	500 mm / 20"	19.48" / 495 mm	19.88" / 505 mm
IPS21	525 mm / 21"	20.47" / 520 mm	20.86" / 530 mm
IPS22	550 mm / 22"	21.45" / 545 mm	21.85" / 555 mm
IPS23	575 mm / 23"	22.44" / 570 mm	22.83" / 580 mm
IPS24	600 mm / 24"	23.42" / 595 mm	23.81" / 605 mm
IPS26	650 mm / 26"	25.39" / 645 mm	25.78" / 655 mm
IPS27	675 mm / 27"	26.37" / 670 mm	26.77" / 680 mm
IPS28	700 mm / 28"	27.36" / 695 mm	27.75" / 705 mm
IPS30	750 mm / 30"	29.33" / 745 mm	29.72" / 755 mm
IPS32	800 mm / 32"	31.29" / 795 mm	31.69" / 805 mm
IPS34	850 mm / 34"	33.26" / 845 mm	33.66" / 855 mm
IPS36	900 mm / 36"	35.23" / 895 mm	35.62" / 905 mm
IPS39	1,000 mm / 39"	39.17" / 995 mm	39.56" / 1,005 mm
IPS44	1,100 mm / 44"	43.11" / 1,095 mm	43.50" / 1,105 mm
IPS48	1,200 mm / 48"	47.04" / 1,195 mm	47.44" / 1,205 mm
IPS51	1,300 mm / 51"	50.98" / 1,295 mm	51.37" / 1,305 mm
IPS55	1,400 mm / 55"	54.92" / 1,395 mm	55.31" / 1,405 mm
IPS60	1,500 mm / 60"	58.85" / 1,495 mm	59.25" / 1,505 mm
IPS63	1,600 mm / 63"	62.78" / 1,595 mm	63.18" / 1,605 mm
IPS67	1,700 mm / 67"	66.73" / 1,695 mm	67.12" / 1,705 mm
IPS71	1,800 mm / 71"	70.66" / 1,795 mm	71.06" / 1,805 mm
IPS75	1,900 mm / 75"	74.60" / 1,895 mm	75.00" / 1,905 mm
IPS79	2,000 mm / 79"	78.54" / 1,995 mm	78.93" / 2,005 mm
IPS80	2,035 mm / 80"	79.92" / 2,030 mm	80.31" / 2,040 mm

Larger sizes available upon request



# CUSTOM STOPPERS

*Any inflatable stopper we can make*

PPM can manufacture to any size, shape and material dependant on the clients requirements any style or inflatable stopper, bag or system.

Please see examples below:





## PIPE EQUIPMENT SPECIALISTS LTD

**TAG Pipe Equipment Specialists Ltd** is another brand owned by the S.F.E. Group, TAG are innovators and manufactures of a comprehensive range of Pipe Cold Cutting and Beveling Machines.

***TAG Machines are offered direct to end users for sale and rental, however their common models are also available through our Distribution Network.***



TAG manufactures a large range of I/D Locking Portable End Prep Machines ranging from ½" to 24". TAG beveling machines can produce all types of weld preparations required on any kind of metals from standard carbon steel to tough material such as super duplex and Inconel.



TAG also manufactures a diverse range of small, medium and large diameter pipe cutting and beveling machines covering from 1" to 96" pipe, with designs available for both workshop and jobsite applications.

# TAG PIPE BEVELING MACHINES



**TAG Pipe Beveling Machine  
PREP 2**

**½" - 1½" (23 mm - 42 mm i/d)  
(optional 12.5 mm)**

The smallest in our range of i/d locking, direct in-line feed end prep machines. The PREP 2 is small, light weight, yet powerful, in electric (110v or 220v), pneumatic drive or battery form. Simultaneous external and internal beveling and facing of pipe or tubes is simple, ideal for accurate repetitive work. Its size, power and functionality, make it extremely popular in high volume heat exchanger work, tube facing, weld removal and J-prepping of the tube plate. Available in 110v or 220v power supply / Battery / Pneumatic.



**TAG Pipe Beveling Machine  
PREP 3**

**1" - 3" (28 mm - 76 mm i/d)  
(optional 20 mm)**

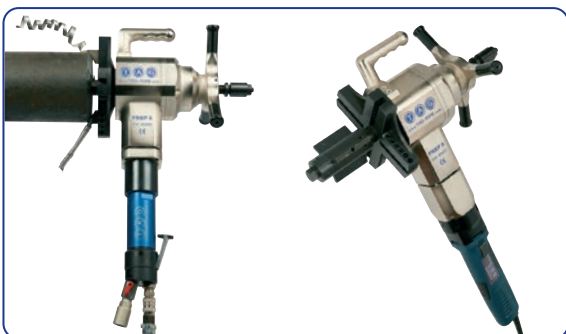
The PREP 3 is one of our most popular i/d locking, in-line feed end prep machines. The PREP 3's power to weight ratio, in electric (110v or 220v), pneumatic drive or battery form is unrivalled. Simultaneous external and internal beveling and facing of tubes can be performed with ease for accurate repetitive work. Its size, power and functionality, makes it extremely popular in high volume boiler repair and maintenance work, tube facing, weld removal, and J-prepping of the tube plate. Available in 110v or 220v power supply / Battery / Pneumatic.



**TAG Pipe Beveling Machine  
PREP 4**

**1" - 4" (23 mm - 112 mm i/d)**

The PREP 4 is a very popular versatile machine that is robust and extremely powerful. Used in many industries but commonly found in tough in-situ environments, such as power station shut downs. The PREP 4 boasts an increased locking range of 1" to 4" i/d and is available in pneumatic, electric or battery. Available in 110v or 220v power supply / Battery / Pneumatic.



**TAG Pipe Beveling Machine  
PREP 8**

**2" - 8" (50 mm - 207 mm i/d)**

One of our most powerful and popular small diameter i/d locking, in-line feed end prep machines. This is mainly due to its impressive 2" to 8" working range and unrivalled power. The PREP 8 is a portable, one man operation machine, its power to weight ratio, and offset 4 jaw tool holder (chuck) allows use of up to 4 insert or form tools to enable simultaneous external, internal beveling of even the heaviest wall pipe and tube, on site, or in the fabshop. Available in 110v or 220v power supply / Pneumatic.

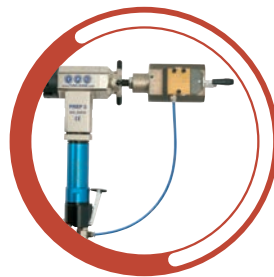
## OPTIONS:



**Battery Motor**



**Ratchet Handles**



**Auto Locking**



**Elbow Shafts**



# TAG PIPE BEVELING MACHINES



## TAG Pipe Beveling Machine PREP 16

**3" - 16" (72 mm - 385 mm i/d)**

The PREP 16 is the first in TAG's new range of a heavy duty large diameter beveling machines. Offering ratchet i/d jaw locking, as well as ratchet bevel feed control for effortless heavy wall preps. Offered with a 3 HP pneumatic or 1750 Watt electric motor any bevel geometry can be performed with in the impressive 3" to 16" range.

J-preps, counter boring, and facing can all be performed, simultaneously, due to its light weight, yet unrivalled power, the PREP 16 is ideal for on-site, off shore, nuclear, and other applications where precision welds are required.

Available with Servo Electric 220v or 110v / Pneumatic / Hydraulic.



## TAG Pipe Beveling Machine PREP 24

**7" - 24" (180 mm - 600 mm i/d)**

A powerful, heavy duty electric or pneumatic motor drives a reduction gearbox converting 3.5 HP into 12500 Nm of torque!! Rigidity and unrivalled beveling strength are ensured with a 5.9" Locking Shaft with built in plug jaws, a bolt in 6 point locking system allows the PREP 24 to cover an impressive range of 7" to 24"!

Both locking and feeding are controlled by ratchet, enabling the operator to lock into the pipe in seconds, and provide a consistent bevel feed, for the perfect surface finish, even on heavy wall pipes.

Available with Servo Electric 220v or 110v / Pneumatic / Hydraulic.

# TAG PIPE CUTTING MACHINES



## TAG E-Z Fab Pipe Cutting and Beveling Machine

**30 mm - 620 mm**

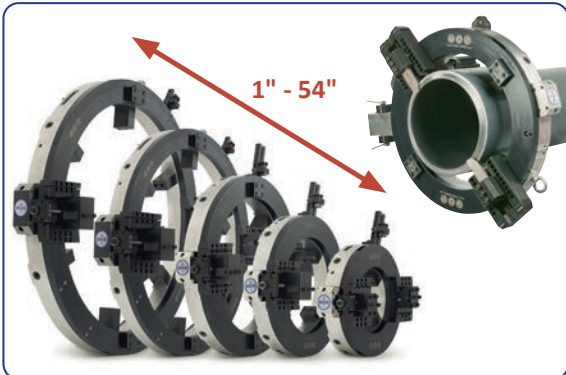
A self-centering, semi portable heavy duty dedicated Pipe Cutting and Beveling machine.

Operated via a Touch-Screen Delta Control, delivering signal to a heavy duty servo motor, giving the E-Z Fab unrivalled power and torque, for heavy duty material and wall thickness applications.

Never before has heavy duty process pipe cutting been so easy.

**6" Steel pipe with 22 mm wall thickness – loaded into machine, cut and beveled in 6 minutes 20 seconds!!!**

Available in 110v or 220v.



## TAG Aluminium Split Frame Clamshell Cutting and Beveling Machines

**25 mm - 1,372 mm**

The TAG Split Frame Clamshell range of portable cold pipe cutting and beveling machines are designed for ease of use, even in difficult situations.

Thanks to their low profile frame they are the perfect machines for use when access to the pipe is restricted.

The TAG range of Cut and Prep Split Frame Clamshells are available with Pneumatic, Servo Electric motors and Hydraulic Motors, and will cover a range from 1" to 54" o/d (6" range per ring).

Larger sizes are available on request. Cutting and beveling can be performed simultaneously; any type of weld prep can be achieved including compound angles and "J-preps".

Visit [www.TAG-PIPE.COM](http://www.TAG-PIPE.COM) for full TAG Machine Catalogues

5mm Square Gridline

Our Brands:

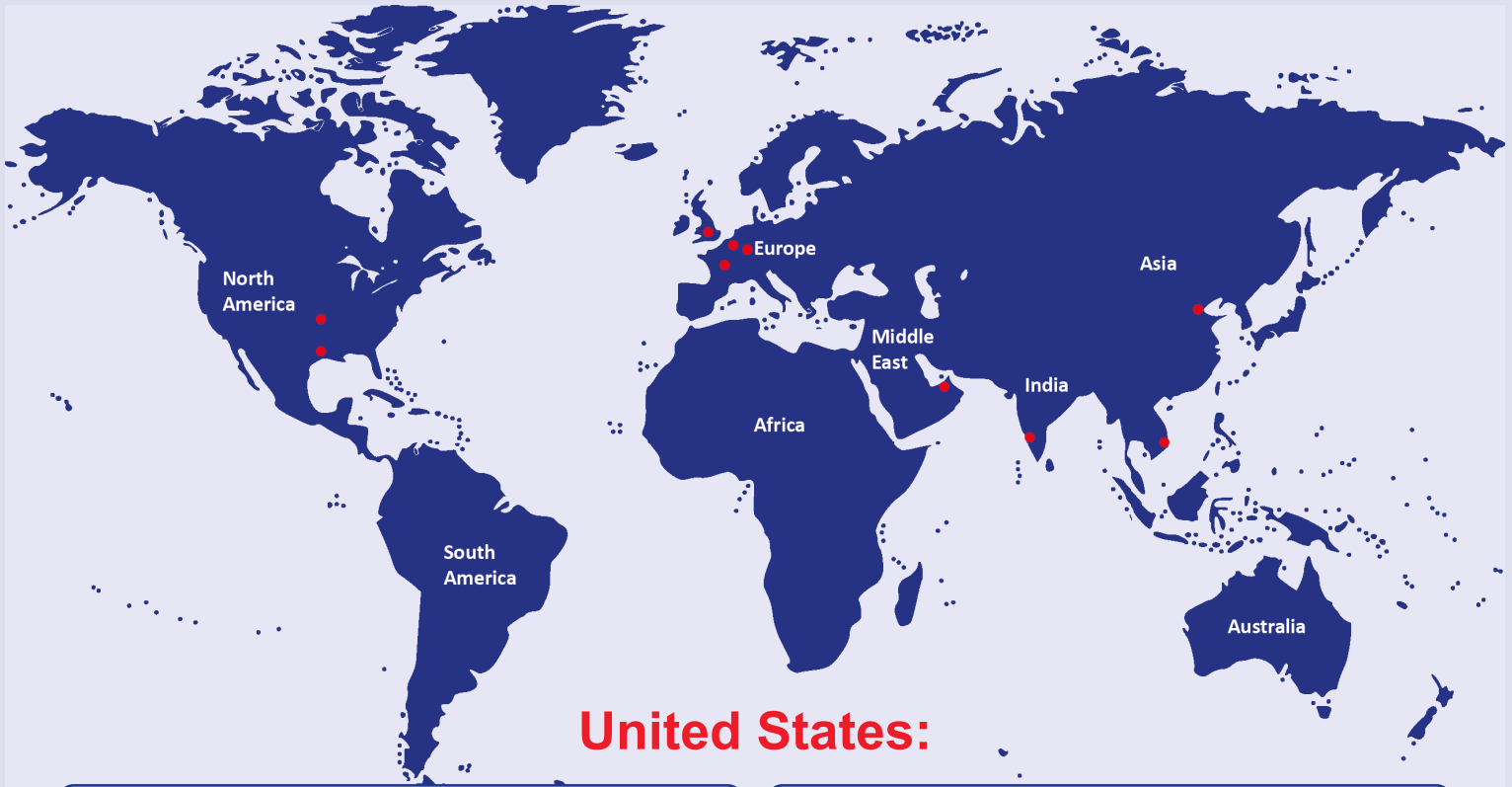


5mm Square Gridline

Our Brands:



# Global Locations:



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