

PORTABLE PIPE BEVELING AND CUTTING MACHINES





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We developed the perfect machine for orbital cutting and orbital pipe bevel!

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PIPE COLD CUTTING AND BEVELING

The perfect machines for pipe cutting and beveling of heavy wall pipes. With our huge range of pipe cutting and pipe cutting and beveling machines every kind of pipe can be cut for further pipe edge preparation.



PIPE COLD CUTTING AND BEVELING MACHINE

n practice it has been proved that weld preparation of pipe ends influence in a high degree the quality of the welding junction. For welding applications of heavy wall pipes and for orbital pipe welding technology the welding engineer requires nowadays a perfect and effective weld preparation in pipe welding process by use of mechanized weld preparation. Our pipe cutting and beveling machines can machine diameters up to 66 inch outside diameter. Light in weight the machines are driven by pneumatic, electric or hydraulic motors and controllable by a single operator. The bevel cutting machines have a high metal removal rate, are easy to handle and constructed in a rugged and compact way.

The portable machine for steel pipe cutting type DLW has been developed in cooperation with European Offshore industry. The machine avoids any heat affected zone (haz) and is specially designed for heavy wall steel pipes in heavy duty applications. Their high working speed and quick readiness for use allow economic manufacture in on-site or off-site application.

Properties / Benefits:

- High cutting capacity
- Quick and secure clamping
- Rugged and compact construction
- Easy handling
- High quality weld prep
- Less noise, dust and sparks
- Ergonomic
- High metal removal rate

Quality control:

Without exception, all DWT pipe milling machines undergo strict quality checks in every production phase in order to be able to guarantee top-quality products at all times.

Delivery:

Professional transport case made of metal.

	Rai	nge	Wallthicknoss	Matorial	Drivo	Application
	mm	inch	Walteness	Material	Dilve	
DLW	60,3 - 1.219,2	2 - 48	max. 80 mm	steel, stainless steel, duplex, high alloys	Pneumatic Hydraulic Servo	Pipe cutting and beveling
DLW-HD	1.041,4 - 1.447,8	41 - 57	max. 80 mm	steel, stainless steel, duplex, high alloys	Pneumatic Hydraulic	Pipe cutting and beveling

PIPE COLD CUTTING MACHINE

Video of application

Pipe cold cutting machine typ DLW

Simultaneous cutting and bevelling of pipes

- Split-Frame Technology for endless heavy wall steel pipe
- Extremely low weight of the cold cutting machine for easy handling and lifting
- Compact dimensions for use in areas with limited access
- Quick and safe clamping and adjustment
- Cold cutting equipment developed with "On-Site Know-How"
- Perfect pipe cold cutter for machinery operations where cold cutting methods are often required



Split-Frame Technologie

Advantages

The portable pipe cutting machine for steel pipe machining of pipes on-site is able to perform beveling and cutting of steel pipes as well as stainless steel and high alloyed steel pipes.

The machines are reduced in weight and dimensions.

The accessories allow multiple operations, like beveling andcutting in one operation, inside beveling, flange repair of flange facing. The clamshell pipe cutter is available from 3 - 57^e. The pipe cutter can do all kind of pipe weld preparation by use of different tools.

Intended use of pipe cold cutting machine

The DLW pipe cold bevel machine is designed for cutting, beveling and counter boring of piping, pipelines for production and repairs. With a special adapter flange preparations are possible.

The transportable pipe cold bevel machine, type DLW for the preparation of pipes and pipelines, can be nearly used without limitations on site. The machines are extremely lightweight, do not require much space and convince by a simple installation. They distinguish by its numerous machinery application possibilities.

The drives of the clamshell pipe cold cutter are a basic component of the pipe cutting machine. All motors are west european standard. An adapter allows easy exchange of all motor types and sizes (pneumatic, hydraulic):

- Modular design
- Easy exchange on-site
- Reduced investment



TECHNICAL DATA







Typ No.	A (mm)	B (mm)	С	D	E	G	H (mm)	Weight (kg)	Pipe OD (mm)		max. WT
		_ ()	(mm)	(mm)	(mm)	(mm)			min.	max.	(mm)
DLW 2-6	319	182	88,5	68	120	202	188	23	60,3	168,30	80
DLW 4-8	366	232	88,5	68	120	224	188	27	88,9	219,1	80
DLW 5-10	420	286	88,5	68	120	249	188	30	114,3	273,1	80
DLW 6-12	470	340	88,5	68	120	261	188	34	141,3	323,9	80
DLW 8-14	496	368	88,5	68	120	262	188	38	193,7	355,6	80
DLW 10-16	550	421	88,5	68	120	317	188	42	244,5	406,4	80
DLW 12-18	604	470	88,5	68	127	341	188	45	298,5	457	80
DLW 14-20	655	525	88,5	68	127	369	188	50	330,2	508	80
DLW 18-24	759	625	88,5	68	127	420	188	60	431,8	610	80
DLW 24-30	920	775	88,5	74	127	496	188	83	584,6	762	80
DLW 30-36	1068	928	88,5	74	127	572	188	93	736,6	914,4	80
DLW 36-43	1250	1105	88,5	74	127	661	188	102	889	1092,2	80
DLW 40-48	1420	1245	95	89	151	731	194	194	990,6	1219,2	80
Heavy Duty Version											
DLW-HD 53	1609,7	1371,6	158,8	119,1	215,9	-	-	314	1041,4	1346,2	100
DLW-HD 55	1660,5	1422,4	158,8	119,1	215,9	-	-	325	1092,2	1397,0	100
DLW-HD 57	1711,3	1473,2	158,8	119,1	215,9	-	-	333	1143	1447,8	100

*other sizes on request, wall-thickness and pipe OD also depend on material and selected cutting tools

Operations & options DLW cold cutter

Field of application :

- Radial pipe cold cutting .
- Pipe beveling
- Simultanious cutting & beveling
- Beveling both end in one operation
- Inside machining of pipe ends .
- Flange facing
- Outside machining of weld seams •

Options drive of pipe cold cutter:

- Hydraulic motor (recommended), power 11.000 W •
- Pneumatic motor up to DLW 12" OD, power 1.700 W . (air consumption: 1,80 m3/min)
- Pneumatic motor up to DLW 57" OD, power 3.000 W • (air consumption: 3,10 m3/min)
- Electrical motor (max. WT=10 mm) on request •

All metal materials of pipe and pipeline:

- Duplex
- Hastelloy
- Superduplex .
- Stainless steel
- P91
- Carbon steel

DRIVES FOR DLW

The new motor option to get the best performance in the machining process, many parameters are important: material, outside diameter, wall thickness, weld prep type, operator skills etc. Usually the machines were equipped with pneumatic or hydraulic motors. Even though these drives deliver tremendous power, but due to lack of parameter control and information in the process the operator had to be very skilled and trained.

Nowadays, the cold cutting machines can be equipped with electrical driven servo drive motors, where speed, torque and current can be displayed, measured and stored during the cutting process. Additionally, this motor does not slow or strain under load. With this intelligent controller, the operator can work perfectly with different materials and pipe characteristics onsite, always choosing the correct settings by help of the controller.

Servo drive motor option

Suitable for pipe cold cutting machine type DLW

- Available in 230V and 240V
- For heavy wall cutting and beveling
- Shock proof and corrosion proof
- Big bright screen
- Emergency stop
- Speed, torque and current are controlled during the cutting & beveling process



Video of application

	Range (Typ DLW)	Wallthickness	Material	Tooling
230V / 1,5 kW	DLW 2-6 - DLW 12-18	40 mm	steel, stainless steel	HSS tool bits
400 V / 3,5 kW	DLW 14-20 - DLW 40-48	80 mm	steel, stainless steel, duplex, high alloys	Inserts + HSS tool bits

DRIVES FOR DLW

The drives are a basic component of the machine. All motors are West-European standard. An adapter allows easy exchange of all motor types and sizes (pneumatic, hydraulic). Further Advantages:

- Modular Design
- Easy exchange on-site
- Reduced investment

Pneumatic motors

Suitable for pipe cold cutting machine type DLW



Hydraulic motors

Suitable for pipe cold cutting machine type DLW



Тур	Power	max. oil flow I/min	Range (Typ DLW)	max. inlet pressure [cont./int.]	max. speed	Wall-thickness	Material	Tooling
OMR 100	13.000 W	60	DLW 2-6 - DLW-HD 57	175/200	600 r.p.m	100 mm	duplex, high alloys	Inserts + HSS tool bits
OMR 200	10.000 W	60	DLW 2-6 - DLW-HD 57	175/200	300 r.p.m	80 mm	steel, stainless steel	Inserts + HSS tool bits

SPECIAL EQUIPMENT FOR DLW

Special equipment for DLW

Pipe cold cutting machine

- Inside counterbore
- Flange facing
- Outside turning module
- Spring load holder
- Deck Cutter

Inside counterbore

DLW-CB:

Internal beveling device for calibration of inside diameter and inside boring of max. 200 mm depth (CB1: 200 mm, CB2: 90 mm depth), adjustable 0° - 25°.



Video of application





Flange facing

DLW-FF:

Flange facing device for DLW machinesto regroove the flange surface, automatic feed mechanism to be used together with DLW-CB. Suitable for DLW 5-10 up to max. DLW 30-36.



*Picture shows DLW-FF incl. DLW-CB

Video of application





SPECIAL EQUIPMENT FOR DLW

Outside turning module

DLW-ETM

The external turning module DLW-ETM can be used for external machining of heavy wall steel pipes. External insulation of pipelines as well as overlapping weld seams can be removed.

Travel: 188mm

Spring load holder



DLW-SLH

The spring load holder DLW-SLH is used for pipe cold cutting and fast beveling of out-of-round pipes. The spring load holder provides a perfect beveling result for this application.





Deck cutter

Application:

By using strong magnets and a special tool holder all DLW machines from 12 - 48 " can be converted to a deck cutter. This is a portable machine which is able to cut big holes in heavy wall plates.

Safety features







Safety maintenance unit with safety function (emergency stop, foot pedal)





Remote control to adjust the feed

TOOLING FOR DLW PIPE CUTTING AND BEVELING

eveloped with German universities our tool tip solutions for pipe cutting and beveling provide an outperforming result pipe cutting technologies:

- High metal removal rate .
- More durable cutter, reduction of consumables
- Low cost of tool tips







30° RH



37,5° RH 37,5°/10° RH Beveling tool tip holder



		Part Number	Description	Material	
FULL STEEL		091503975	HSS cutting tools 45 mm	HSS	
		091503976	HSS cutting tools 55 mm	HSS	
	J	091503977	HSS cutting tools 80 mm	HSS	
TOOL TIP SOLUTION	UTTIN	091506154	Tool tip holder cut-off 35 mm	Tooling steel	
	0	091505187	Tool tip holder cut-off 60 mm	Tooling steel	
		091505185	Tool tip holder cut-off 80 mm	Tooling steel	
		091505186	Tool tip standard steel	Hard metal coated	
	LING	091505182	Tool tip holder 30° standard	Tooling steel	
BEVE		091501416	Tool tip 30° standard	HSS coated	



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The DWT GmbH head office is in the industrial heart of Germany. The machines are produced by a competent team and are delivered in the whole world.

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