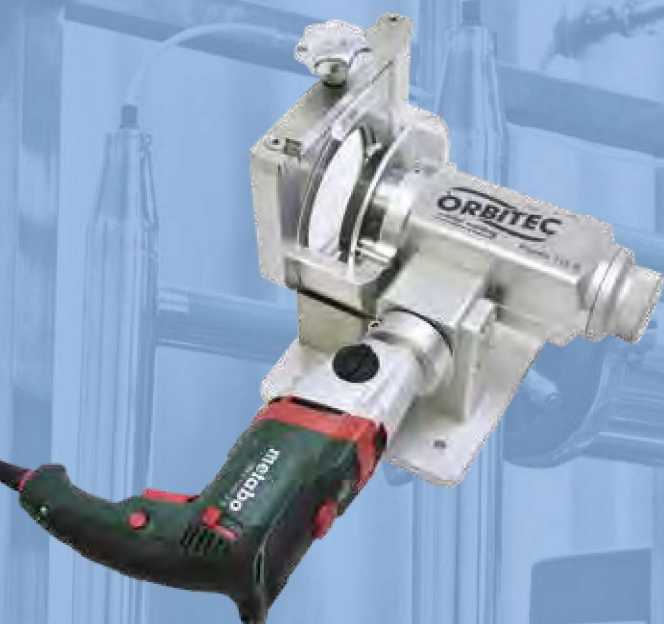


JOINT PREPARATION



TUBE SAWS

A precise 90° saw cut is a basic requirement for orbital weld preparation..

TUBE SAWS S-LT

- Robust saws for all wall thicknesses
- Powerful drive motor
- Uniform and easy feed control by means of handwheel
- Different chamfering blades mountable
- Right-angled saw cut
- 4, 5 or 6 clamping jaws made of stainless steel as well as reducing jaws
- 4 insert collets (just for S-100 LT)
- Due to concentric clamping no deformation with thin-walled pipes
- Also for cutting off pipe bends
- Quick-release fastener for easy changing of saw blades
- Chip removal during cutting by means of integrated brush
- Convenient adjustment of plunge depth by means of feed wheel



Technical data	S-100LT	S-150LT	S-200LT
Tube size range mm/ inch:	OD 6 - 120 mm / 0,236 - 4,724"	OD 20 -170 mm / 0.787 -6.693"	OD 60 -220 mm / 2.362 -8.661"
Wall thickness:	1 -8mm 0,039 - 0,315"	1 -8mm 0,039 - 0,315"	1 -8mm 0,039 - 0,315"
Electric drive:	Single-phase AC motor	Single-phase AC motor	Single-phase AC motor
Main voltage:	200/220 VAC (50/60 Hz)	200/220 VAC (50/60 Hz)	200/220 VAG (50/60 Hz)
Output:	1000 W / 4.5 A	1000 W / 4.5 A	1000 W / 4.5 A
Protection class:	II	II	II
Speed control:	6-step control	6-step control	6-step control
Dimensions:	143 x 366 383mm	143 x 466 x 483mm	145 x 525 x 542mm
Weight :	47kg	66kg	77kg
Item number	1.2.4513	1.2.4512	1.2.4511

Package includes:

- Tube saw with electric drive
- Insert collets 6-13 mm (just for S-100 LT)
- One saw blade
- One bottle of saw blade lubricating oil

TUBE SAWS

S-LT, ACCESSORIES



TRIPOD BASE FOR TUBE SAW S-100LT (AND ORS)

Item number

1.2.4510

Orbital
welding systems



MOBILE WORKSTATION S-LT WITH ADJUSTABLE TUBE SUPPORT

1.2.4515

Welding
tools

SAW BLADE

Standard saw blades are recommended for unalloyed and alloyed steels, premium saw blades for titanium, duplex and Inconel.

Welding
accessories



STANDARD SAW BLADE

STANDARD SAW BLADE for wall thicknesses of 1 – 3 mm, Ø 68 mm, 72 teeth, uncoated

1.3.4520

STANDARD SAW BLADE for wall thicknesses of 2.5 – 7 mm, Ø 68 mm, 44 teeth, uncoated

1.3.4521

Joint
preparation



STANDARD SAW BLADE for wall thicknesses of 0.5 – 3 mm, Ø 80 mm, 56 teeth, uncoated

1.3.4524



PREMIUM SAW BLADE

PREMIUM SAW BLADE for wall thicknesses of 1 – 3 mm, Ø 68 mm, 72 teeth, coated

1.3.4522

PREMIUM SAW BLADE for wall thicknesses of 2.5 – 7 mm, Ø 68 mm, 44 teeth, coated

1.3.4523

Purging
accessories



CHAMFERING SAW BLADES FOR S-LT TUBE SAW

Chamfering saw blades for 30°, Ø 90 mm, 20 teeth

1.2.4543

Measuring
devices



SAW BLADE LUBRICATING OIL, bottle, 250 ml

1.3.4525

Service/
general



TUBE SAW

CUTTING BLOCKS



Item number

CUTTING BLOCKS, quick lock system

- Locking mechanism, tool-free
- For quick and safe clamping during mounting work, without any additional clamping tools
- 90° kerf for separating tubes
- For saw blades measuring up to 1.0 mm thick
- Made of high-quality hardened tool steel

CUTTING BLOCK, DIN 11850/ ROW 1



CUTTING BLOCK, DIN 11850/ ROW 2

CUTTING BLOCK (INCH)

ISO CUTTING BLOCK

Other dimensions available on request

DN	mm
10	12
15	18
20	22
25	28
32	34
40	40
50	52
65	70
80	85
100	104
125	129
150	154
200	204

DN	mm
10	13
15	19
20	23
25	29
–	30
32	35
40	41
50	53

inch

1/4"
1/2"
3/8"
3/4"
1"
1 1/4"
1 1/2"
2"
2 1/2"
3"
3 1/2"
4"
5"
6"

mm

13.5
17.2
21.3
26.9
33.7
42.4
48.3
60.3
76.0
88.9
114.3
139.7
168.3

1.1.4601
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1.1.4647
1.1.4648



TUBE SQUARING EQUIPMENT

Tube squaring equipment is needed to achieve burr-free and perpendicular joint preparation for orbital welding. That's why Orbitec offers two machines – from the small and handy Planfix 40 S, to the large Planfix 115 S.

PLANFIX 40 S TUBE SQUARING EQUIPMENT

The Planfix 40 S is a powerful and handy facing device for cordless or mains-powered mobile or stationary use. It has a large inspection window, an indexable insert holder, indexable inserts that can be used on two sides and a feed with 0.1 mm scale graduation. Existing Orbitec planar steels can be used without an indexable insert holder as an alternative. The new indexable inserts are characterised by a long service life and can quickly and reliably machine unalloyed, low-alloyed and high-alloyed steels with high precision.

Scope of application					
Tube size range	OD 3 – 40 mm / 0.386" – 1.575"				
Wall thickness	max. 4 mm				
Technical data	Planfix 40 S 230 V battery	Planfix 40 S 120 V battery	Planfix 40 S 230 V mains	Planfix 40 S 120 V mains	Planfix 40 S (without drive)
Dimensions	275 x 250 x 135 mm	275 x 250 x 135 mm	415 x 200 x 135 mm	415 x 200 x 135 mm	155 x 75 x 135 mm
Weight	3.4 kg	3.4 kg	4.0 kg	4.0 kg	1.45 kg
Drive	Metabo	Metabo	Metabo	Metabo	
Idle speed	0 – 500 / 0 – 1.850 rpm	0 – 500 / 0 – 1.850 rpm	0 – 1,100 / 0 – 3.100 / rpm	0 – 1,100 / 0 – 3.100 / rpm	
Li-ion battery voltage	18 V / 5.2 Ah	18 V / 5.2 Ah			
Charger	ASC 30–36 V Air-cooled	ASC 30–36 V Air-cooled			
Mains voltage	230 – 240 V	115 V	230 – 240 V	110 – 120 V	
Mains frequency	50 – 60 Hz	60 Hz	50 – 60 Hz	50 – 60 Hz	
Max. current	3 A	3 A	5.1 A	10.5 A	
Package includes					
Clamping attachment	•	•	•	•	•
Drive	•	•	•	•	
Two Li-ion batteries	•	•			
Battery charging station	•	•			
Indexable insert holder					
Indexable insert					
Special cutting steel					
Tool kit	•	•	•	•	
Transport case	•	•	•	•	
Item number	1.3.41071	1.3.41072	1.3.41073	1.3.41074	1.3.4107



PLANFIX 40 S STAND

PLANFIX 40 S COLLETS

1 set per tube outer diameter = 2 half-shells

The OSK 38 weld head's collets can also be used.

Item number

1.3.41000

1.3.4102+Ø

Orbital
welding systems

Welding
tools

Welding
accessories

Joint
preparation

Purging
accessories

Measuring
devices

Service/
general



PLANFIX 115 S TUBE SQUARING EQUIPMENT

The Planfix 115 S is a powerful facing and chamfering device with an angular gearbox for mains-powered mobile or stationary use. It has a large inspection window, a chip collector and a feed with 0.1 mm scale graduation.

The equipment can be used with an indexable insert holder for indexable inserts that can be used on two sides or with the familiar Orbitec L planar steels as an option.

Scope of application			
Tube Size range	OD 9.53 – 114.3 mm 0.375" – 4.500"		
Wall thickness	max. 4 mm		
Technical data	Planfix 115 S 230 V mains	Planfix 115 S 120 V mains	Planfix 115 S (without drive)
Dimensions	530 x 315 x 295 mm	530 x 315 x 295 mm	300 x 320 x 300 mm
Weight	15 kg	15 kg	13 kg
Drive	Metabo	Metabo	
Idle speed	0 – 1,100 / 0 – 3.100 / rpm	0 – 1,100 / 0 – 3.100 / rpm	
Mains voltage	230 – 240 V	110 – 120 V	
Mains frequency	50 – 60 Hz	50 – 60 Hz	
Max. current	5.1 A	10.5 A	
Package includes			
Clamping attachment	•	•	•
Drive	•	•	
Indexable insert holder			
Indexable insert			
Special cutting steel			
Tool kit	•	•	
Transport box	•	•	
Item number	1.1.4200	1.2.4200	1.0.4200



PLANFIX 115 S COLLETS

1 SET per tube outer diameter = 2 half-shells

The OSK 115 weld head's collets can also be used.

Item number

1.3.4007+Ø



TUBE SQUARING SYSTEMS

PLANFIX ACCESSORIES



Item number



SPECIAL HSS CUTTING STEEL (WITH TIC COATING)

Special HSS cutting steel for chamfering 30° and 37.5° available on request.

1.2.4114

Orbital
welding systems

Welding
tools



PLANFIX INDEXABLE INSERT HOLDER

1.2.4105

Welding
accessories



INDEXABLE INSERT (WITH TIC COATING)

Characterised by a long service life and can quickly and reliably machine unalloyed, low-alloyed and high-alloyed steels with high precision.

1.2.4115

Joint
preparation

Purging
accessories

Measuring
devices

Service/
general



DEBURRING TOOLS

SEVEN-PIECE UNIVERSAL DEBURRING TOOL SET
OD 3 – 16 mm | 0.118" – 0.630"

1.2.4125



INTERNAL DEBURRER WITH NOZZLE

1.2.4122



TRIANGULAR INTERNAL DEBURRER

1.2.4123



EXTERNAL DEBURRER WITH INSERT

1.2.4124



DEBURRING TOOLS AS A SET IN THE CASE

1.2.4120



'UNIVERSAL' INTERNAL / EXTERNAL DEBURRER
Ø 10 – 56 mm | 0.394" – 2.205"

1.2.4121



FOR CLEANING THE WELD JOINT:

SUPERFINE ABRASIVE PAD, roll, 10 m | 393.701", 115 mm wide | 4.528"

1.1.4125



SC 80 WP POLISHING DISC, Ø 150 mm | 5.905"

1.1.4126



CLAMP SHAFT FOR POLISHING DISC

1.1.4127