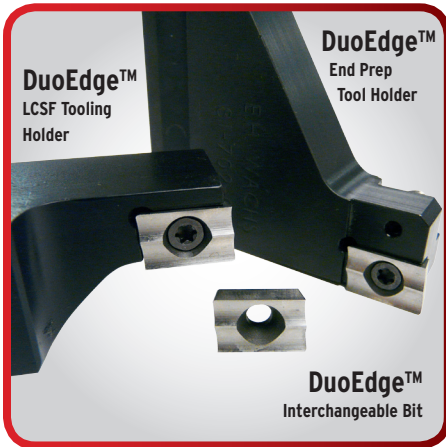


Less Than 1/3 the Cost of Conventional Tooling



DESCRIPTION

E.H. Wachs DuoEdge Insert Tooling is a system of portable machine tool holders and inserts designed to replace larger, more expensive traditional single edge tooling. It offers considerable cost savings over traditional tooling without sacrificing the longevity of the cutting edge or the quality of the finished prep.



DuoEdge utilizes reusable tooling holders where the user “inserts” a small, replaceable tool bit that has dual cutting edges. When the first cutting edge is worn away, the insert is rotated 180 degrees to the second cutting edge. When the second cutting edge is worn away, the insert is discarded and a new insert installed.

LONG LIFE

E.H. Wachs DuoEdge Insert Tooling is manufactured specifically to meet the needs of portable machining. Unlike some competitors who repurpose off the shelf CNC tooling, Wachs designs and manufactures our inserts with the profiles and finishes required for single point machining. DuoEdge insert tool bits are ground to a super smooth finish, reducing friction for longer tooling life.

DEEPER CUTS

Unlike repurposed CNC tooling that can only manage a relatively light depth of cut, DuoEdge tool inserts are designed specifically for portable machining and optimized for use in E.H. Wachs machines. The insert bits are cut with an R.02” tool radius for stronger edges and a chip curling feature that helps deliver a superior finish. DuoEdge allows the user to take a more aggressive cut than other designs without prematurely wearing out the bit.

THREE MATERIALS

DuoEdge inserts are designed to be interchangeable between our tool holders, making tool bit inventory easy to manage. Bits are offered in a choice of three materials, from least expensive to most expensive they are HSS (High Speed Steel), HSS Premium (Coated) and Carbide Steel. HSS is ideal for single pointing of ordinary carbon steel pipe. The HSS Premium coated version, which gives the insert a dark gunmetal appearance, is best for demanding applications such as stainless steel. For the absolute toughest material to single point (like service hardened P91) specify Carbide Steel inserts.

DuoEdge ADVANTAGES

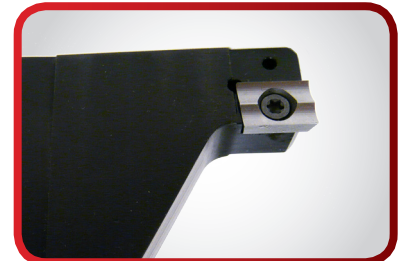
There are multiple advantages to Wachs DuoEdge Insert Tooling system, the primary advantage being cost. It is much less expensive to purchase a tiny tool insert than a large tool bit made from expensive hardened steel. Other advantages include:

- Two cutting edges instead of one, for minimal work interruption
- Each cutting edge costs on average one third the cost of a traditional bit
- No need to sharpen tooling, saving time, labor and shipping
- Small size of inserts makes them easy to store or carry in your pocket
- Holders are reusable, inserts are interchangeable between holders
- End prep holder is reversible to a high and low range position

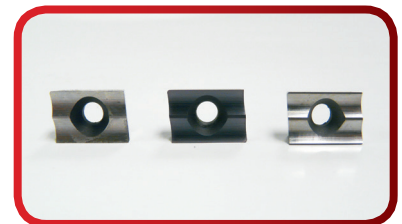
NEW DUAL CUTTING EDGES INTERCHANGEABLE BITS



LCSF DuoEdge reusable holder is designed for single point machining with LCSF Bridgeslide



End prep DuoEdge tool holder is two sided for high & low range single point machining



Inserts are available in HSS (left), HSS Premium (middle), & Carbide Steel (right)



Less than 1” (25.4mm) long, insert bits are easily changed and fit all DuoEdge holders

APPLICATIONS

- DuoEdge tooling system of reusable holders and interchangeable tool bits
- LCSF Insert Tooling for LCSF Bridge Slide Single Pointing
- End Prep Insert Tooling for EP424 and SDB series single pointing

FEATURES

- Precision ground, super smooth surface finish
- Reduced friction for longer life
- Chip curl edge designed to clear swarf
- Eliminates expensive and time consuming resharping of conventional tooling
- Two cutting edges per insert. Conventional tooling has only one cutting edge per tool.
- Less expensive per cutting edge, on average less than 1/3 the cost of conventional tooling
- Optimal mix of sharpness and durability
- Supplied with R.02" tool radius for stronger edges and a better finish
- Superior to competitors off the shelf repurposed CNC tooling
- CNC tooling only allows a light depth of cut, unlike DuoEdge Insert Tooling
- Three insert materials offered, HSS, Premium Coated HSS and Carbide Steel

INSERT HOLDER

- Durable heat treated steel with Torx fasteners
- Black oxide coated for rust and corrosion resistance
- End prep holder features a high and low range reversible design
- LCSF holder 1" (25.4mm) square bridge slide tooling compatible
- Includes T15 wrench for securing insert

INSERTS

- Inserts sold as singles and in 10 Packs
- Large cost savings with 10 Packs
- Ships in re-sealable plastic containers for storage, protects cutting edges from damage, helps prevent rust and corrosion.
- Sold as HSS, HSS-P Premium and Carbide
- HSS most affordable, suitable for most carbon steel applications or new P22 or P91 fabrications
- HSS-P Premium coated high speed steel for use on high alloy materials, stainless steel, and Duplex
- Carbide is the hardest material, suitable for single pointing materials normally associated with high tooling wear, for example in-service P91.



GENUINE WACHS TOOLING

Only Genuine Wachs Tooling is quality checked and tested for optimum performance in E.H. Wachs machine tools.

PART #	ITEMS/PACK	APPLICATION	MATERIAL
81-701-01	DuoEdge Insert Single Pack	Carbon Steel	High Speed Steel (HSS)
81-701-10	DuoEdge Insert 10-Pack	Carbon Steel	High Speed Steel (HSS)
81-701-01P	DuoEdge Premium Single Pack	Stainless Steel	Premium Coated HSS
81-701-10P	DuoEdge Premium 10-Pack	Stainless Steel	Premium Coated HSS
81-703-01	DuoEdge Insert Single Pack	High-Temp Alloys	Carbide Steel
81-703-10	DuoEdge Insert 10-Pack	High-Temp Alloys	Carbide Steel
81-704-01	DuoEdge J-Prep Insert Single Pack	R .094" J-Prep	High Speed Steel
81-705-01	DuoEdge J-Prep Insert Single Pack	R .125" J-Prep	High Speed Steel
81-706-01	DuoEdge J-Prep Insert Single Pack	R .188" J-Prep	High Speed Steel
60-718-00	LCSF Holder Single Pack	LCSF Single Point	Heat Treated Steel
81-702-00	End Prep Holder Single Pack	End Prep Single Point	Heat Treated Steel

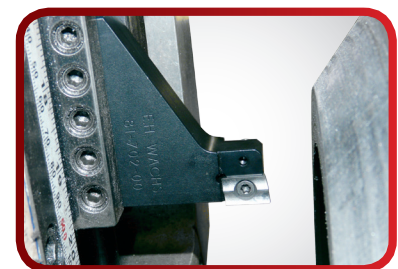
All dimensions shown for pipe diameters are US nominal diameters in inches, plus metric nominal diameters (DN) in parenthesis. Tubing and solid diameters if shown are actual US inches plus metric millimeter equivalents.



For additional cost savings many DuoEdge inserts are available in 10 Packs, offering 20 cutting edges per package



Inserts are small enough to carry in your pocket. Inserts come in Single Pack (shown) or 10 Packs



End prep tool holder can hold an insert on either side for high or low range machining. Low range shown.

CONTACT US FOR A DEMO OR QUOTE

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