

TOOLING CHART

SDB 206, SDB 412 & EP 424 END PREP MACHINES



BEVELING TOOLS

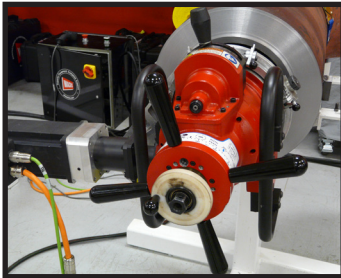
Description	Part Number	Application	Image
Form Tool Insert Holder Kit			
Low Range Holder ID 56-708-01 High Range Facing Insert Holder ID 56-708-02 37.5° Bevel Insert Holder 56-709-03	56-710-01	For completing facing and beveling of pipe with a 37.5° angle, both standard and J-prep; requires cutting tool sold separately	
Form Tool Insert Holder - Includes holder, two insert screws & wrench.			
30°	56-709-02	For beveling pipe; requires cutting tool insert sold separately	
37.5°	56-709-03		
Form Tool Cutting Tool - Insert for facing and beveling, double sided.			
HSS	56-711-01	Most materials up to 32 RC hardness	
Carbide	56-712-01	Materials harder than 32 RC	
Form Tool Cutting Tool - Radius 3/32 "J" bevel insert, double sided.			
HSS	56-711-02	Most materials up to 32 RC hardness	
Carbide	56-712-02	Materials harder than 32 RC	

COUNTERBORE TOOLING

Description	Part Number	Application	Image
4:1 Taper Counterbore Tool			
Minimum pipe ID size: Low Range	56-705-01	Most pipes Maximum counterbore depth 1 1/8" (28.5mm)	
Minimum pipe ID size: Medium Range	56-705-02		
Minimum pipe ID size: High Range	56-705-03		
Standard 3/8" x 3/8" (9.5mm x 9.5mm) High speed tool bit. Use with 56-424-00 and 56-424-01	56-713-00	Most pipes	
10° ID Deburring Tool			
Minimum pipe ID size: Low Range	56-702-01	10° ID taper, most pipes	
Used for ID chamfering. Minimum pipe ID size: Medium Range	56-702-02		
Used for ID chamfering. Minimum pipe ID size: High Range	56-702-03		
4:1 Counterbore Tool Kit			
Consists of tool insert holder 56-210-00 and 3 insert retaining screws. Requires insert 60-700-04 sold separately	56-715-00	Maximum depth 3 1/8" (79.4mm) Minimum ID 6" (152mm) Standard tooling (EP 424 only) Most pipes	
Counterbore Tooling Insert			
For use with 56-715-00 Tool Kit	60-700-04		




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Genuine Wachs Tooling is the best choice to maintain the peak performance of our I.D. mounted end prep machine tools. All tooling on this chart is interchangeable among Wachs SDB 206, SDB 412 and EP 424, and is manufactured with exclusive designs from premium tool steels to deliver consistent, precise bevels and counterbores. Single point tooling is the best choice for machining complex bevels on heavy wall applications.

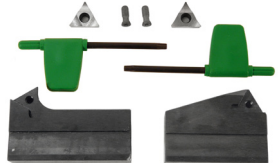
SINGLE POINT TOOLING

Description	Part Number	Application	Image
Single Point Holder Low range single point tool holder Requires tooling insert 52-701-01 sold separately.	56-424-00	Most materials less than 32 RC hardness	
Single Point Holder High range single point tool holder Requires tooling insert 52-701-01 sold separately.	56-424-01		
Single Point Insert Standard 3/8" x 3/8" (9.5mm x 9.5mm) HSS Tool Bit for single point facing, beveling Use with 56-424-00 and 56-424-01	52-701-01	Single point beveling most materials less than 32 RC hardness	



The SDB series and EP 424 are great tools for refinishing raised face flanges. Wachs tooling is designed with the necessary geometry to create a raised face record groove finish on most materials. Wachs flange facing tool kits include everything required to machine the full range of flanges within each machine's capacity. Replacement tooling inserts are ideal for this application and feature three cutting surfaces to maximize tool life.

SINGLE POINT FLANGE FACING TOOLS

Description	Part Number	Application	Image
Flange Facing Tool Holder Kit Kit includes a Low Range 56-714-03 and High Range 56-714-02 insert tool holder, two tool inserts, two insert retaining screws and two screw wrenches.	56-418-01	Complete flange facing	
Flange Facing Insert Tool insert for single point flange facing. Three-tipped insert for use with 56-418-01 Holder Kit	56-710-00	Flange facing and record grooving	