

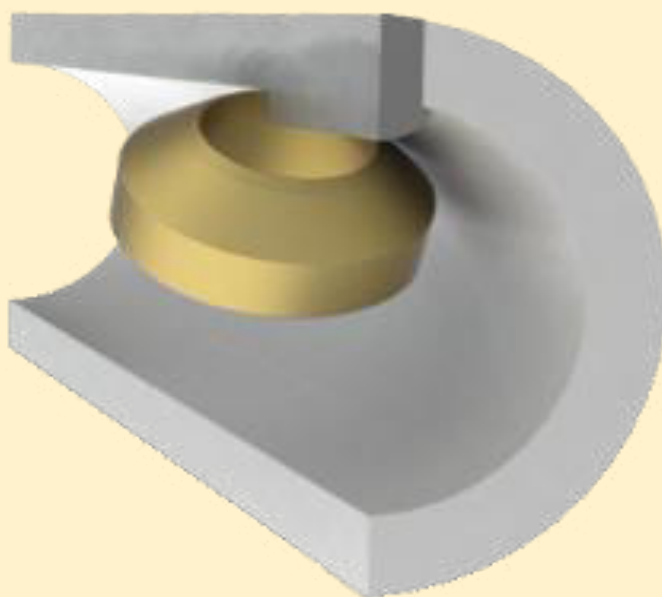
Zubehör für Rohrschweissanlagen Accessories for tube welding machines

Aussenentgraten / Aussenbearbeitung



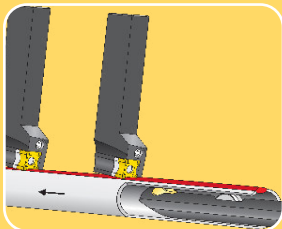
Outside deburring

Innenentgraten / Innenbearbeitung



Inside deburring

Inhalt / Content



Anwendung / Application

2



Aussenbearbeitung / Outside working

- Wendeplattenhalter / Insert holders

3

- Definition

4

- SNMX 15

5

- SNMX 19

6

- SNMX 25

7



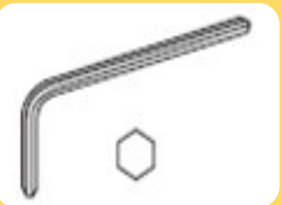
Innenbearbeitung / Inside working

- Definition

8

- Schneidringe / Scarfing rings

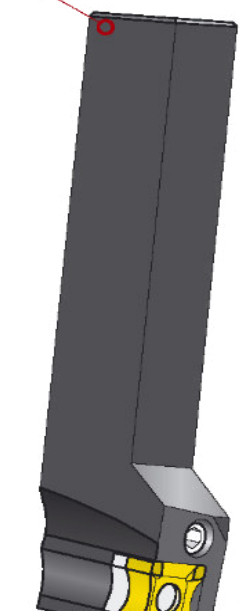
9



Ersatzteile / Spare parts

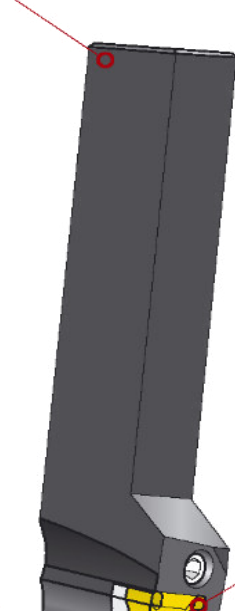
10

Schichtwendeplattenhalter Finishing holder



Rohr Tube

Schruppwendeplattenhalter Roughing holder



Schneidplatte
Cutting insert

Schneidring
Cutting ring

Schweissnaht

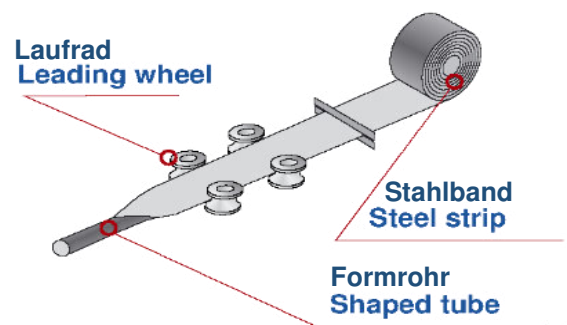
Laufrad
Leading wheel

Internal holder
Innenhalter

Laufrad Leading wheel

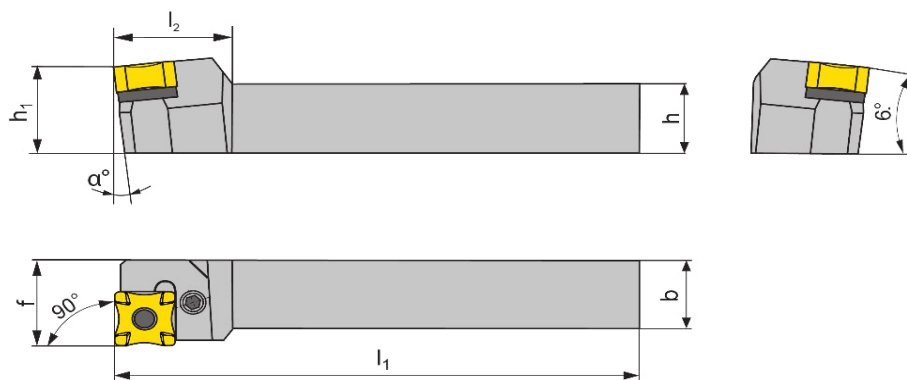
Stahlband
Steel strip

Formrohr
Shaped tube



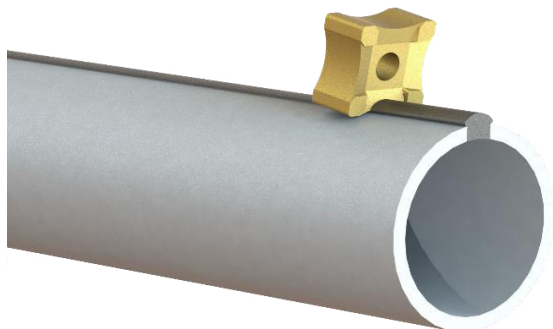
Wendeplattenhalter / Insertholder

SXFN



Artikel Order-No.	Beschreibung Description	Dimension (mm)						kg	WP Insert
		h = h1	b	f	l1	l2max	a°		
10008845	SXFN 15/6 - L	25	25	25	200	40	6	1.05	SNMX 15
10008846	SXFN 15/6 - R	25	25	25	200	40	6	1.05	SNMX 15
10008847	SXFN 15/20 - L	25	25	25	200	40	20	1.05	SNMX 15
10008848	SXFN 15/20 - R	25	25	25	200	40	20	1.05	SNMX 15
10008849	SXFN 19/6 - L	25	25	25	250	45	6	1.30	SNMX 19
10008850	SXFN 19/6 - R	25	25	25	250	45	6	1.30	SNMX 19
10008851	SXFN 19/20 - L	25	25	25	250	50	20	1.30	SNMX 19
10008852	SXFN 19/20 - R	25	25	25	250	50	20	1.30	SNMX 19
10008853	SXFN 25/6 - L	32	32	40	250	50	6	2.20	SNMX 25
10008854	SXFN 25/6 - R	32	32	40	250	50	6	2.20	SNMX 25

Technische Information / Technical Information



S > N > M > X > 15 > - > R10 > ; > P34

S	Plattenform (ISO) S = Vierkantplatte
N	Freiwinkel (ISO) N = neutral 0°
M	Toleranzklasse (ISO)
X	Spannfläche (ISO) X = Spezialausführung
15	Plattengrösse / Size 15 = 15.875 mm 19 = 19.050 mm 25 = 25.400 mm
R10	Radius erhältlich von R0 - 200
P35/P34	Ausführung P35 = TiN (goldig) P34 = Al2O3 (schwarz)

S	Insert shape (ISO) S = Square
N	Free angle (ISO) N = neutral 0°
M	Tolerance class (ISO)
X	Chip breaker (ISO) X = special execution
15	Insert size 15 = 15.875 mm 19 = 19.050 mm 25 = 25.400 mm
R10	Radius available from R0 - 200
P35/P34	Execution P35 = TiN (gold) P34 = Al2O3 (black)

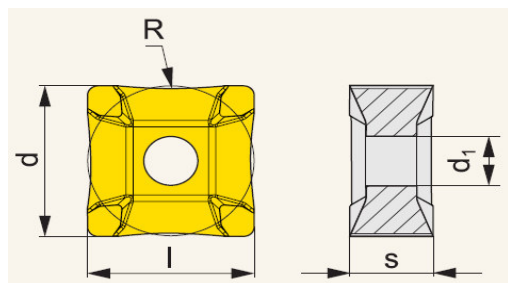
Wir empfehlen die TiN-Beschichtung, auf Wunsch Al2O3-Beschichtung
We recommend TiN-coating, according your request with Al2O3-coating

Aussenentgraten Outside deburring

Werkzeug- und Maschinenbau AG
Industriestrasse 13
CH - 9552 Bronschhofen
Tel.: +41 (0)71 911 12 22
Fax: +41 (0)71 911 49 32
E-Mail: swwil@sw-wil.com

WP Aussenentgraten / Inserts for outside scarfing

SNMX 15



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008823	SNMX 15 - R00	P35 / P34	15.875	5.16	8.15	0	0
	10006768	SNMX 15 - R07	P35 / P34	15.875	5.16	8.15	7	8 - 10
	10008781	SNMX 15 - R09	P35 / P34	15.875	5.16	8.15	9	10 - 13
	10008782	SNMX 15 - R11	P35 / P34	15.875	5.16	8.15	11	13 - 16
	10008792	SNMX 15 - R13	P35 / P34	15.875	5.16	8.15	13	15 - 19
	10008783	SNMX 15 - R15	P35 / P34	15.875	5.16	8.15	15	17 - 22
	10008784	SNMX 15 - R18	P35 / P34	15.875	5.16	8.15	18	21 - 26
	10008785	SNMX 15 - R20	P35 / P34	15.875	5.16	8.15	20	23 - 29
	10008786	SNMX 15 - R22	P35 / P34	15.875	5.16	8.15	22	25 - 32
	10008787	SNMX 15 - R25	P35 / P34	15.875	5.16	8.15	25	29 - 36
	10008793	SNMX 15 - R27	P35 / P34	15.875	5.16	8.15	27	31 - 39
	10008788	SNMX 15 - R30	P35 / P34	15.875	5.16	8.15	30	35 - 44
	10008794	SNMX 15 - R35	P35 / P34	15.875	5.16	8.15	35	40 - 51
	10008795	SNMX 15 - R40	P35 / P34	15.875	5.16	8.15	40	46 - 58
	10008796	SNMX 15 - R45	P35 / P34	15.875	5.16	8.15	45	52 - 65
	10008797	SNMX 15 - R50	P35 / P34	15.875	5.16	8.15	50	58 - 73
	10008798	SNMX 15 - R60	P35 / P34	15.875	5.16	8.15	60	63 - 80

Spezialgrößen / Special size

10008790	* SNMX 15 - R08	P35 / P34	15.875	5.16	8.15	8	9 - 11
10008789	* SNMX 15 - R10	P35 / P34	15.875	5.16	8.15	10	11 - 14

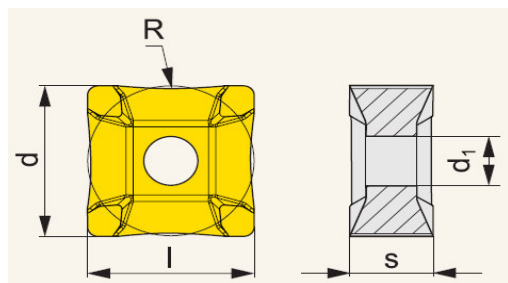
*andere Qualitäten und Sondergrößen auf Anfrage
different qualities and special sizes on request*

Aussenentgraten Outside deburring

Werkzeug- und Maschinenbau AG
Industriestrasse 13
CH - 9552 Bronschhofen
Tel.: +41 (0)71 911 12 22
Fax: +41 (0)71 911 49 32
E-Mail: swwil@sw-wil.com

WP Aussenentgraten / Inserts for outside scarfing

SNMX 19



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008824	SNMX 19 - R00	P35 / P34	19.050	7.95	8.15	0	0
	10008799	SNMX 19 - R10	P35 / P34	19.050	7.95	8.15	10	12 - 15
	10008800	SNMX 19 - R12	P35 / P34	19.050	7.95	8.15	12	14 - 17
	10008801	SNMX 19 - R15	P35 / P34	19.050	7.95	8.15	15	17 - 22
	10008825	SNMX 19 - R18	P35 / P34	19.050	7.95	8.15	18	21 - 26
	10008802	SNMX 19 - R20	P35 / P34	19.050	7.95	8.15	20	23 - 29
	10008826	SNMX 19 - R22	P35 / P34	19.050	7.95	8.15	22	25 - 32
	10008803	SNMX 19 - R25	P35 / P34	19.050	7.95	8.15	25	29 - 36
	10008804	SNMX 19 - R30	P35 / P34	19.050	7.95	8.15	30	35 - 44
	10008805	SNMX 19 - R35	P35 / P34	19.050	7.95	8.15	35	40 - 51
	10008806	SNMX 19 - R40	P35 / P34	19.050	7.95	8.15	40	46 - 58
	10008807	SNMX 19 - R45	P35 / P34	19.050	7.95	8.15	45	52 - 65
	10008808	SNMX 19 - R50	P35 / P34	19.050	7.95	8.15	50	58 - 73
	10008809	SNMX 19 - R55	P35 / P34	19.050	7.95	8.15	55	63 - 80
	10008810	SNMX 19 - R60	P35 / P34	19.050	7.95	8.15	60	69 - 87
	10008811	SNMX 19 - R65	P35 / P34	19.050	7.95	8.15	65	75 - 94
	10008827	SNMX 19 - R75	P35 / P34	19.050	7.95	8.15	75	86-108
	10008812	SNMX 19 - R80	P35 / P34	19.050	7.95	8.15	80	92 - 116
	10008828	SNMX 19 - R85	P35 / P34	19.050	7.95	8.15	85	92 - 116
	10008813	SNMX 19 - R90	P35 / P34	19.050	7.95	8.15	90	104 - 131
	10008814	SNMX 19 - R110	P35 / P34	19.050	7.95	8.15	110	127 - 160

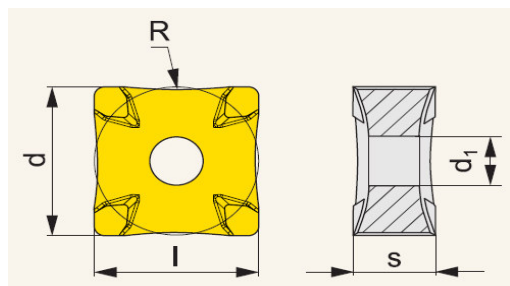
andere Qualitäten und Sondergrössen auf Anfrage
different qualities and special sizes on request

Aussenentgraten Outside deburring

Werkzeug- und Maschinenbau AG
Industriestrasse 13
CH - 9552 Bronschhofen
Tel.: +41 (0)71 911 12 22
Fax: +41 (0)71 911 49 32
E-Mail: swwil@sw-wil.com

WP Aussenentgraten / Inserts for outside scarfing

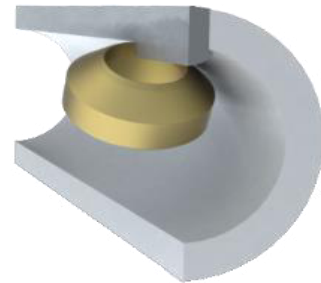
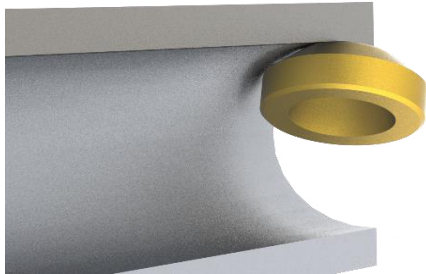
SNMX 25



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohraussen - Ø Tube outside - Ø
	10008829	SNMX 25 - R00	P35 / P34	25.400	9.12	12.20	0	0
	10008815	SNMX 25 - R50	P35 / P34	25.400	9.12	12.20	50	58 - 73
	10008816	SNMX 25 - R80	P35 / P34	25.400	9.12	12.20	80	92 - 116
	10008817	SNMX 25 - R100	P35 / P34	25.400	9.12	12.20	100	115 - 145
	10008818	SNMX 25 - R120	P35 / P34	25.400	9.12	12.20	120	138 - 174
	10008819	SNMX 25 - R140	P35 / P34	25.400	9.12	12.20	140	161 - 230
	10008820	SNMX 25 - R160	P35 / P34	25.400	9.12	12.20	160	184 - 232
	10008821	SNMX 25 - R180	P35 / P34	25.400	9.12	12.20	180	207 - 261
	10008822	SNMX 25 - R200	P35 / P34	25.400	9.12	12.20	200	230 - 290

andere Qualitäten und Sondergrössen auf Anfrage
different qualities and special sizes on request

Technische Information / Technical Information



SR

1

-

AR5

;

P34

SR **Ringtyp (Scarfing Ring)**

1 **Aussendurchmesser (d)**

1 = 13 mm 5 = 35 mm
2 = 19 mm 6 = 45 mm
3 = 22 mm 7 = 50 mm
4 = 30 mm 8 = 55 mm

AR5 **Arbeitsradius (R)**
y = in der Regel 26°

P34 **Ausführung**
P34 = Al2O3 (schwarz)

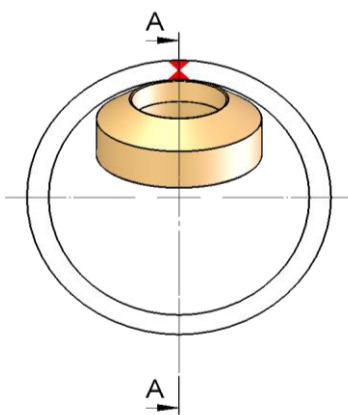
SR **Ring typ (Scarfing Ring)**

1 **Outside diameter (d)**

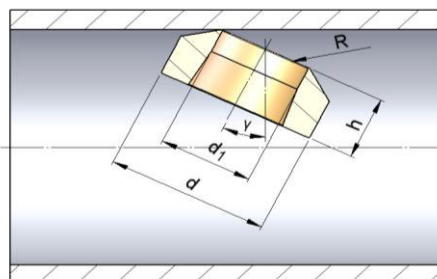
1 = 13 mm 5 = 35 mm
2 = 19 mm 6 = 45 mm
3 = 22 mm 7 = 50 mm
4 = 30 mm 8 = 55 mm

AR5 **Working radius (R)**
y = usually 26°

P34 **Execution**
P34 = Al2O3 (black)



A-A

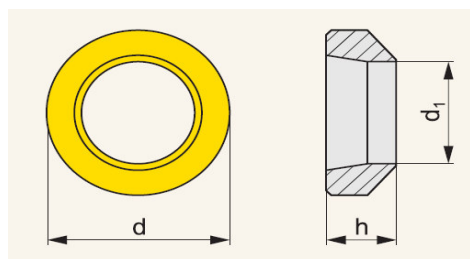


$$R = \frac{d_1}{2 * \sin \gamma}$$

andere Qualitäten und Sondergrößen auf Anfrage
different qualities and special sizes on request

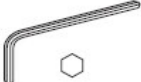
Schneidringe / Scarfing rings

SR - AR ; P34



	Artikel Order-No.	Beschreibung Description	Ausführung Execution	Dimension (mm)				
				l = d	d1	h	R	Rohrinnen - Ø Tube inside - Ø
	10008830	SR0 - AR3.5	3503 P34 CA	6.00	3.00	3.50	3.40	12 - 13.5
	10008831	SR0 - AR4	3503 P34 CA	6.00	3.50	3.50	4.00	12 - 14
	10008778	SR0 - AR4.5	421 P34 CA	8.00	4.00	4.00	4.60	13.5 - 19
	10008832	SR0/10 - AR4.5	421 P34 CA	10.00	4.00	4.00	4.60	13.5 - 19
	10008833	SR0 - AR5.5	3706 P34 CA	8.00	5.00	4.00	5.70	16 - 20
	10008770	SR0/10 - AR5.5	3706 P34 CA	10.00	5.00	4.00	5.70	16 - 20
	10008834	SR0 - AR6	421 P34 CA	10.00	5.50	4.50	6.30	17 - 20
	10008766	SR0 - AR6.5	421 P34 CA	10.00	6.00	4.50	6.80	17 - 21
	10008835	SR0/5 - AR6.5	421 P34 CA	10.00	6.00	5.00	6.80	20 - 22
	10006766	SR0 - AR7	421 P34 CA	10.00	6.50	4.50	7.40	17 - 22
	10008764	SR1 - AR7	421 P34 CA	13.00	6.00	5.00	6.80	20 - 22
	10008761	SR1 - AR8	421 P34 CA	13.00	7.00	5.00	8.00	22 - 24
	10008836	SR1 - AR9	421 P34 CA	13.00	8.00	5.00	9.10	24 - 26
	10006767	SR1 - AR10	421 P34 CA	13.00	9.00	5.00	10.20	25 - 28
	10008837	SR2 - AR9	421 P34 CA	19.00	8.00	8.00	9.10	24 - 26
	10008765	SR2 - AR10	421 P34 CA	19.00	9.00	8.00	10.20	26 - 28
	10008762	SR2 - AR11	421 P34 CA	19.00	10.00	8.00	11.40	28 - 30
	10008780	SR2 - AR12	421 P34 CA	19.00	11.00	8.00	12.50	30 - 34
	10008771	SR2 - AR14	421 P34 CA	19.00	12.50	8.00	14.30	32 - 41
	10008838	SR3 - AR12	421 P34 CA	22.00	11.00	10.00	12.50	30 - 34
	10008763	SR3 - AR14	421 P34 CA	22.00	12.00	10.00	13.70	32 - 41
	10008839	SR3 - AR17	421 P34 CA	22.00	15.00	10.00	17.10	41 - 50
	10008840	SR4 - AR20	421 P34 CA	30.00	17.00	12.00	19.40	45 - 60
	10008841	SR4 - AR23	421 P34 CA	30.00	20.00	12.00	22.80	48 - 72
	10008842	SR5 - AR25	422 P34 CA	35.00	22.00	12.00	25.10	70 - 85
	10008768	SR5 - AR28	422 P34 CA	35.00	25.00	12.00	28.50	85 - 100
	10008843	SR6 - AR34	422 P34 CA	45.00	30.00	15.00	34.20	100 - 130
	10008769	SR7 - AR39	422 P34 CA	50.00	35.00	15.00	39.50	125 - 140
	10008844	SR8 - AR46	422 P34 CA	55.00	40.00	18.00	45.60	150 - 400

Ersatzteile / Spare parts

	Artikel Order-No.	Beschreibung Description	Halter Holder
	10008855	Unterlagsscheibe / Shim	SXFN 15...
	10008856	Unterlagsscheibe / Shim	SXFN 19...
	10008857	Unterlagsscheibe / Shim	SXFN 25...
	10008858	Klemmstück / Clamp piece	SXFN 15...
	10008859	Klemmstück / Clamp piece	SXFN 19...
	10008860	Klemmstück / Clamp piece	SXFN 25...
	10008861	Spannschraube / Clamp screw	SXFN 15...
	10008862	Spannschraube / Clamp screw	SXFN 19...
	10008863	Spannschraube / Clamp screw	SXFN 25...
	10008864	Halbhohlriet / Half hollow rivet	SXFN 15...
	10008865	Halbhohlriet / Half hollow rivet	SXFN 19...
	10008866	Halbhohlriet / Half hollow rivet	SXFN 25...
	10008867	Spannstift / Clamp pin	SXFN 15...
	10008868	Spannstift / Clamp pin	SXFN 19...
	10008869	Spannstift / Clamp pin	SXFN 25...
	10008870	Schlüssel / Wrench	SXFN 15...
	10008871	Schlüssel / Wrench	SXFN 19...
	10008872	Schlüssel / Wrench	SXFN 25...

SW WIL
Werkzeug- und Maschinenbau AG
Industriestrasse 13
CH - 9552 Bronschhofen

Tel.: +41 (0)71 911 12 22
Fax: +41 (0)71 911 49 32
E-Mail : swwil@sw-wil.com
www.sw-wil.com



WORLD-WIDE