

SDB Small Diameter Beveler



Box header beveling with SDB



SDB pipe end preparation



SDB end prepping pressure vessel

Fast, Easy Setup - Self-Centering Design

E.H. Wachs SDB line of small diameter bevelers have been engineered for fast, precise onsite facing, beveling, compound beveling and counterboring of light and heavy wall pipe, tube or casing. Proven workhorses, they set up quickly with a self-centering mandrel and chuck assembly mounting to the pipe ID.

Using high strength heat treated steel on the mandrel with aluminum components to save weight without sacrificing strength, one person can setup, operate and create a perfect weld prep in minutes. With optional conversion kits the SDB can be reconfigured to an FF series flange facer.



SDB 103 End Prep

Pipe End Preparation Machines

- Compact, lightweight design for one person set up and operation
- Self-centering ID mandrel assures perfect end preps
- Face, bevel, counterbore
- Convertible to FF series with optional flange facing kit

SDB 103

The SDB 103 end prep handheld beveling machine delivers maximum power and performance for fast, accurate weld preps on pipe and tube from ID 0.875in (22.2mm) to OD 4.5in (114.3mm). Face, bevel and counterbore simultaneously on carbon, stainless and high alloy steels.

Extremely versatile, the SDB 103 allows you to prep boiler tubes, heavy wall pipe, thick wall tubing, and elbows. With optional FF kit face flanges ID 2in (50.8mm) to OD 6in (152.4mm).



SDB 103

SPECIFICATIONS	SDB 103
Machine capacity	0.875in - 4.500in (22.2-114.0mm)
Standard equipment	<ul style="list-style-type: none"> • Heavy duty drive (air or electric) • Standard mandrel ID 1.16-4.18in (29.5-106mm) • 7 sets of leg extensions • Operating hand tools • Watertight storage case • Manual
Shipping weight (est.)	40lb (18kg)
Shipping dimensions (est., without accessories)	25 x 22 x 9in (635 x 558.8 x 228.6mm)

SDB 103 Beveler Kits

DESCRIPTION	DRIVE TYPE	PIPE ID TO OD	PART #
SDB 103	Pneumatic	0.88-4.5in (22-114mm)	16-000-01
SDB 103	Electric 110 V, 50 Hz	0.88-4.5in (22-114mm)	16-000-02
SDB 103	Electric 220 V, 50 Hz	0.88-4.5in (22-114mm)	16-000-03

SDB/FF Flange Facer Conversion Kits for SDB 103

DESCRIPTION	PART #
BEVELER CONVERSION KIT Converts FF 206 to SDB 103 end prep machine to face, bevel, compound bevel and counterbore pipes with Ø 1- 4in (25.4-101.6mm). Includes: <ul style="list-style-type: none"> • 1 standard rotating head • 1 standard mandrel ID 1.16in - 4.18in (29.5-106mm) • 7 sets of leg extensions • 1 felt wiper • Fasteners 	16-420-00
FLANGE FACER CONVERSION KIT Converts SDB 103 to FF 206 flange facing machine for flanges ID 2in (50.8mm) to OD 6in (152.4mm). Includes: <ul style="list-style-type: none"> • 1 single point flange facing tool slide • 1 independent "short perch" mandrel • 7 sets of leg extensions ID 1.95in - 4.11in (49.5-104.4mm) 	16-421-00



SDB to FF Conversion Kit: head, mandrel, legs, & fasteners

SDB 206 End Prep

SDB 206

The SDB 206 makes fast work of end preps on pipe and tube from ID 1.91in (48.5mm) to OD 6.625in (168.3mm). Compact and lightweight, its design requires only 2.25in (57mm) of radial clearance – making it the ideal tool for use in tight places.

No other machine of this type can perform as many different jobs: face, bevel, counterbore (simultaneously if desired), compound bevel and (with optional FF kit) faces flanges from ID 3in (76.2mm) to OD 13in (330.2mm).

SPECIFICATIONS	SDB 206
Machine capacity	1.910in - 6.625in (48.5-168.0mm)
Standard equipment	<ul style="list-style-type: none"> • Heavy duty drive (air, electric or hydraulic) • Standard mandrel ID 2.27-6.58in (57.7-167mm) • 10 sets of leg extensions • Operating hand tools • Watertight storage case • Manual
Shipping weight (est.)	115lb (52kg)
Shipping dimensions (est., without accessories)	12 x 32 x 21in (305 x 813 x 533mm)

SDB 206 Beveler Kits

DESCRIPTION	DRIVETYPE	PIPE ID TO OD	PART #
SDB 206/2	Pneumatic	1.91-6.63in (49-168mm)	56-000-01
SDB 206/2	Electric 110 V, 50 Hz	1.91-6.63in (49-168mm)	56-000-02
SDB 206/2	Electric 220 V, 50 Hz	1.91-6.63in (49-168mm)	56-000-04
SDB 206/2	Hydraulic	1.91-6.63in (49-168mm)	56-000-03

SDB/FF Flange Facer Conversion Kits for SDB 206

DESCRIPTION	PART #
BEVELER CONVERSION KIT Conversion kit FF 313 to SDB 206/6 end prep machine. Includes: <ul style="list-style-type: none"> • 1 standard rotating head • SDB 206 mandrel • 7 sets of leg extensions • 1 felt wiper • Fasteners 	56-420-00
FLANGE FACER CONVERSION KIT Converts model SDB 206/2 to FF 313 flange facing machine. For flanges with ID 3in (76.2mm) to OD 13in (330mm). Includes: <ul style="list-style-type: none"> • 1 single point flange facing tool slide • 3-jaw independent "short perch" mandrel • 18 sets of leg extensions ID 3.00in - 10.08in (76.2-256mm) 	56-421-00



SDB 206



Form tooling to single pointing conversion kit

SDB 412 End Prep

SDB 412

The SDB 412 is a portable pipe end prep machine designed to face, bevel, counterbore (simultaneously) and compound bevel ID 3.80in (96.5mm) to OD 12.75in (323.9mm) pipe, up to 1.125in (29mm) wall thickness.

Face flanges with optional FF kit ID 4in (101.6mm) to OD 24in (609.6mm). The heavy duty yet compact design of the SDB 412 requires minimal operating clearances. The SDB 412 is designed for one person handling, setup and operation.

SPECIFICATIONS	SDB 412
Machine capacity	3.800in - 12.750in (96.5-323.9mm)
Standard equipment	<ul style="list-style-type: none"> • Heavy duty drive (air, electric or hydraulic) • Standard mandrel ID 3.80-12.02in (96.5-305mm) • 8 sets of leg extensions • Operating hand tools • Watertight storage case • Manual
Shipping weight (est.)	308lb (140kg)
Shipping dimensions (est., without accessories)	25 x 47 x 18in (635 x 1.194 x 457mm)

SDB 412 Beveler Kits

DESCRIPTION	DRIVETYPE	PIPE ID TO OD	PART #
SDB 412/2	Pneumatic	3.8-12.75in (97-324mm)	66-000-01
SDB 412/2	Hydraulic	3.8-12.75in (97-324mm)	66-000-03
SDB 412/2	Electric 220 V, 50 Hz	3.8-12.75in (97-324mm)	66-000-02

SDB/FF Flange Facer Conversion Kits for SDB 412

DESCRIPTION	PART #
BEVELER CONVERSION KIT Converts FF 424 to SDB 412/2 portable pipe and tube prepping machine to face, bevel, compound bevel and counterbore pipes with Ø 4in - 12in (102-305mm) Includes: <ul style="list-style-type: none"> • 1 standard rotating head • 1 standard mandrel ID 3.8in - 12.02in (96.5-305mm) • 8 sets of leg extensions • 1 felt wiper • fasteners 	66-420-00
FLANGE FACER CONVERSION KIT Converts SDB 412/2 to FF 424 flange facing machine. For flanges with ID 4in (101.6mm) to OD 24in (609.6mm). Includes: <ul style="list-style-type: none"> • 1 single point flange facing tool slide • 3-jaw independent "short perch" mandrel • 23 sets of leg extensions ID 3.78in - 20in (96-508mm) 	66-421-00

Hydraulic Power Units

For available Hydraulic Power Unit options, see page 74.

Air Control Module

Air Control Module "ACM", see page 72.

Cutting Lubrication

Cutting lubrication "KSS-TOP", see page 51.



SDB 412



Diesel Powered HPU-20



Air Control Module ACM provides remote control for pneumatic operation