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M A N U F A C T U R E R S I N C E 1 9 8 6

PIPE BEVELING MACHINE PIPE CUTTING MACHINE - PIPE FACING MACHINE



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Easy Cut & Bevel

Pipe Dimensions Imperial/ Metric Pipe Chart

Nominal Pipe Inch					Schedule					Wall thickness mm				
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TUD + DE					TUD + DE					TUD + DE				
w1/8 6	0.405 10.3	6.8	10/10S	1.24	1-1/2 40	1.900 48.3	45.0	5/5S	1.65	5 125	5.563 141.3	135.8	5/5S	2.77
		7.8	STD/40/40S	1.73			42.8	10/10S	2.77			134.5	10/10S	3.40
		5.5	XS/80/80S	2.41			40.9	STD/40/40S	3.68			128.2	STD 40/40S	6.55
1/4 8	0.540 13.70	10.4	10/10S	1.65	2 50	2.375 60.3	38.1	XS/80/80S	5.08	6 150	6.625 168.3	122.2	XS 80/80S	9.53
		9.3	STD/40/40S	2.24			34.0	160	7.14			115.9	120	12.70
		7.7	XS/80/80S	3.02			28.0	XX	10.16			109.5	160	15.88
3/8 10	0.675 17.10	13.8	10/10S	1.65	2-1/2 65	2.875 73	57.0	5/5S	1.65	8 200	8.625 219.1	103.2	XX	19.05
		12.5	STD 40/40S	2.31			54.8	10/10S	2.77			162.8	5/5S	2.77
		10.7	XS 80/80S	3.20			52.5	STD/40/40S	3.91			161.5	10/10S	3.40
1/2 15	0.840 21.30	18.0	5/5S	1.65	3 80	3.500 88.9	49.2	XS/80/80S	5.54	BM14 + TU5 + TU6		154.1	STD 40/40S	7.11
		17.1	10/10S	2.11			42.8	160	8.74			146.4	XS 80/80S	10.97
		15.8	STD 40/40S	2.77			38.2	XX	11.07			139.8	120	14.27
3/4 20	1.050 26.7	23.4	5/5S	1.65	3-1/2 90	4.000 101.6	68.8	5/5S	2.11			131.8	160	18.26
		22.5	10/10S	2.11			66.9	10/10S	3.05			124.4	XX	21.95
		21.10	STD/40/40S	2.87			62.7	STD/40/40S	5.16			213.6	5S	2.77
1 25	1.315 33.4	18.9	XS/80/80S	3.91	4 100	4.500 114.3	59.0	XS/80/80S	7.01			211.6	10/10S	3.76
		15.6	160	5.56			53.9	160	9.53			206.4	20	6.35
		11.1	XX	7.82			45.0	XX	14.02			205.0	30	7.04
1-1/4 37	1.660 42.2	30.1	5/5S	1.65	TU6 + BM14		84.7	5/5S	2.11			202.7	STD/40/40S	8.18
		27.9	10/10S	2.77			82.8	10/10S	3.05			198.5	60	10.31
		26.6	STD/40/40S	3.38			77.9	STD/40/40S	5.49			193.7	XS/80/80S	12.70
		24.3	XS/80/80S	4.55			73.7	XS/80/80S	7.62			188.9	100	15.09
		20.7	160	6.35			66.6	160	11.13			182.6	120	18.26
		15.2	XX	9.09			58.4	XX	15.24			177.9	140	20.62
		38.9	5/5S	1.65			97.4	5/5S	2.11			174.6	XX	22.23
		36.7	10/10S	2.77			95.5	10/10S	3.05			173.1	160	23.01
		35.1	STD/40/40S	3.56			90.1	STD 40/40S	5.74					
		33.5	XS/80/80S	4.65			85.4	XS 80/80S	8.08					
		32.5	160	6.35			110.1	XX	16.15					
		32.5	160	6.35			108.2	10/10S	3.05					
		32.5	160	6.35			102.3	STD 40/40S	6.02					
		32.5	160	6.35			97.2	XS 80/80S	8.56					
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TU2 PIPE BEVELING MACHINE

INTERNAL CLAMPING

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18mm ID - 60.3mm OD



Machine delivered with :

- 2 standard tool bits of your choice
- Heavy duty plastic box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

COFIM® types **TU2 light portable** machine using internal clamping method, auto centered and auto maintained once clamped in the tube and design with a self torque design. The TU2 allows a safe operator work with high production and quality ready for orbital welding assembly compare to traditional methods as grinding or flame cutting. The TU2 shaft receives internal clamping jaws well marked with the ID size of the tube to ease the operator choice while preparing the machine. HSS tool bits or carbide bits can work simultaneously to achieve combined bevel (30°+ Facing ; 37°5 + Facing; 45° + Facing....). The standard TU2 can bevel from 18mm ID up to 60mm OD and with optional shaft can start at 12mm ID.

SAFETY is our priority: The TU2P & TU2E are equipped with 2 actions safe start handle motor for operator use friendly.

Machine TU2	Clamping Range	Machining Range	Wall Thickness	Stroke
TU2	18mm ID - 60.3mm ID	18mm ID - 60.3mm ID	6 mm	40 mm

Type	Motorization	Specifications		Weight
TU2E	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min	3,5KG
TU2P	Electric / 1 400Watt	230V/50 hertz	Speed Variator	4,0KG
		115V /50hertz	Speed Variator	4,0KG
		115V /60hertz	Speed Variator	4,0KG
TU2B	Battery	18 V		4,0KG

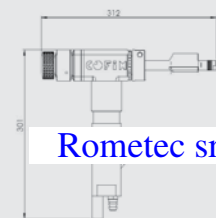
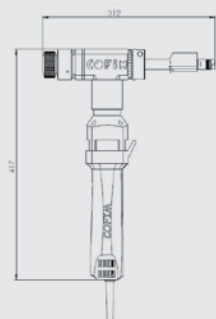
Options	Reduced Shaft 12mm ID to 18mm ID	Automatic clamping	TU2S Motor in line	Specific Milling head
	Envelopping Jaws	Feed lever	Carbide insert	Plate cover

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



TU2 can be equipped with option such as limit stop, milling head, carbide insert, stainless contact, Lift eye for balancer,...

TU2 ELECTRIC DIMENSIONS



TU2 equipped with special milling head for fin removal



TU2S Machine with RA90°motorization



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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU3 PIPE BEVELING MACHINE

INTERNAL CLAMPING

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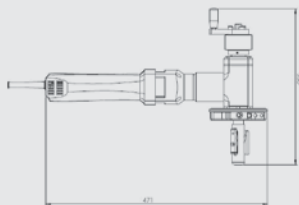
27mm ID - 114mm OD



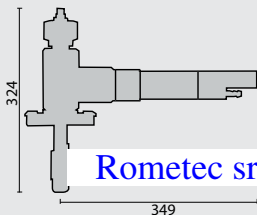
Machine delivered with :

- 2 standard tool bits of your choice
- Heavy duty plastic box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

TU3 ELECTRIC DIMENSIONS



TU3 PNEUMATIC DIMENSIONS



COFIM® types **TU3 light portable machine** using internal clamping method, auto centered and auto maintained once clamped in the tube and design with a self torque design.

The TU3 can bevel tube and pipe at a high quality ready for orbital welding assembly compare to traditional methods as grinding or flame cutting.

The TU3 shaft receives internal clamping jaws well marked with the ID size of the tube to ease the operator choice while preparing the machine.

HSS tool bits or carbide bits can work simultaneously to achieve combined bevel (30°+ Facing ; 37°5 + Facing; 45° + Facing....).

The TU3 machine is equipped with a tool holder able to bevel from 27mm ID up to 114mm OD and with optional shaft can start at 16mm ID .The TU3 is also equipped with a smaller tool holder of 59mm OD for tight clearance situation.

SAFETY is our priority: The TU3 is equipped with 2 actions safe start handle motor for operator use friendly.

Machine TU3	Clamping Range	Machining Range	Wall Thickness	Stroke
TU3	27mm ID - 107mm ID	27mm ID - 114mm OD	12 mm	60 mm

Type	Motorization	Specifications		Weight
TU3E	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min(35 Cfm)	5,5KG
TU3P	Electric / 1 400Watt	230V/50 hertz	Speed Variator	7,5KG
		115V /50hertz	Speed Variator	7,5KG
		115V /60hertz	Speed Variator	7,5KG
TU3B	Battery	18 V		7,5KG

Options	Reduced Shaft 16mm ID to 29mm ID	Automatic clamping	Flange facer 27mm-300mm	Milling head
TU3S Motor in line	Enveloping Jaws	Feed lever	Carbide insert	Plate cover

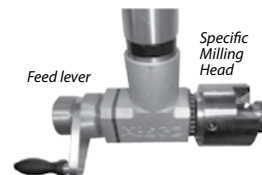
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Automatic clamping



Flang Facing
Attachment



Feed lever

Specific
Milling Head

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU4 PIPE BEVELING MACHINE

INTERNAL CLAMPING

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35mmID – 130mm OD



Machine delivered with :

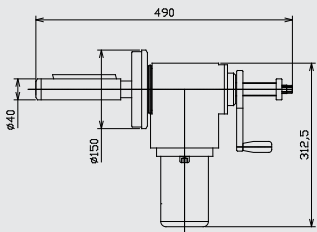
- 2 standard tool bits of your choice
- Heavy duty box
- Necessary tools to use with the machine (Allen keys, screws, ...)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE

Weight TU4P : 10 Kg
TU4P : Puissance 1HP /6 Bars

Weight TU4E : 11.5 Kg
TU4E : Puissance 1400W
 (110V/220V)

■ TU4 DIMENSIONS



COFIM® types **TU4 heavy duty portable machine** using internal clamping method, auto centered and auto maintained once clamped in the tube and design with a self torque design.

The TU4 can bevel tube and pipe at a high quality ready for orbital welding assembly compare to traditional methods as grinding or flame cutting.

The TU4 shaft receives internal clamping jaws well marked with the ID size of the tube to ease the operator choice while preparing the machine.

HSS tool bits or carbide bits can work simultaneously to achieve combined bevel (30°+ Facing ; 37°5 + Facing; 45° + Facing....).

The TU4 machine is equipped with a tool holder able to bevel from 35mm ID up to 130mm OD and can also be equipped with a 6" OD tool holder or a milling heads for specific jobs such as boiler tube removal.

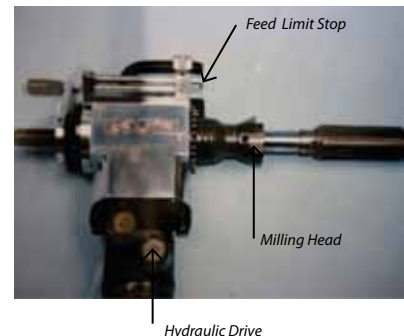
SAFETY is our priority: The TU4 is equipped with 2 actions safe start handle motor for operator use friendly.

Machine TU4	Clamping Range	Machining Range	Wall Thickness	Stroke
TU4	35mm ID - 125mm ID	35mm ID - 130mm OD	15 mm	60 mm

Type	Motorization	Specifications		Weight
TU4P	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min(35 Cfm)	10KG
TU4E	Electric / 1 400Watt	230V/50 hertz	Speed Variator	11,5KG
		115V /50hertz	Speed Variator	11,5KG
		115V /60hertz	Speed Variator	11,5KG
TU4B	Battery	18 V	Charger + 2 Batteries	11,5KG

Options	Reduced Shaft 16mm ID to 29mm ID	Automatic clamping	Feed limit stop (Heat exchanger job)	Milling head
	Enveloping Jaws	Hydraulic drive	Std Carbide insert	Plate cover

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■ OPTION



Enveloping jaws

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU5 PIPE BEVELING MACHINE

INTERNAL CLAMPING

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51mmID – 219mm OD



Machine delivered with :

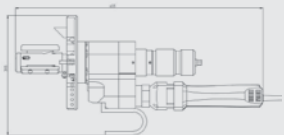
- 2 standard tool bits of your choice
- Heavy duty box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE

Weight TU5P : 14.5 Kg
TU5P : Puissance 1HP /6 Bars

Weight TU5E : 16 Kg
TU5E : Puissance 1400W
 (110V/220V)

■ TU5 DIMENSIONS



COFIM ® types **TU5 heavy duty portable machine** using internal clamping method, auto centered and auto maintained once clamped in the tube and design with a self torque design. The TU5 can bevel tube and pipe at a high quality ready for orbital welding assembly compare to traditional methods as grinding or flame cutting.

The TU5 shaft receives internal clamping jaws well marked with the ID size of the tube to ease the operator choice while preparing the machine.

4 HSS tool bits or carbide bits can work simultaneously to achieve combined bevel (30°+ Facing ; 37°5 + Facing; 45° + Facing....). The TU5 machine is equipped as standard equipment with a tool holder able to bevel from 51mm ID (2") up to 219mm OD (8") pipe and is also equipped with a 110mm (4") OD tool holder for tight clearance situation or as an option milling heads for specific jobs such as boiler tube removal.

SAFETY is our priority: The TU5 is equipped with 2 actions safe start handle motor for operator use friendly.

Machine TU5	Clamping Range	Machining Range	Wall Thickness	Stroke
TU5	51mm ID - 200mmID	51mm ID -219mm OD	2mm to 20 mm	60 mm

Type	Motorization	Specifications	Weight
TU5E	Pneumatic / 1HP	6Bars (90 PSI)	15KG
TU5P	Electric / 1 400Watt	230V/50 hertz	17KG
		115V /50hertz	17KG
		115V /60hertz	17KG
TU5B	Battery	18 V	16KG

Options	Reduced Shaft	Automatic clamping	Flange facer 70mm-300mm	Milling head
Right angle drive	Enveloping Jaws	Ratchet Feed lever	Carbide insert	Turning Plate cover

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



■ OPTION

Flange facing attachment



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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

Machine delivered with :

- 2 standard tool bits of your choice
- Heavy duty box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE

Weight TU6P: 40Kg

TU6P : 2HP/ 6 Bars

Weight TU6E : 42Kg

TU6E : 1400W (110V/220V)

Weight TU6 H: 40Kg

TU6H : 2HP/60Bars

■ TU6 DIMENSIONS

Beveling Machines COFIM® types TU 6 is a portable machine using an internal gripping method. The TU6 can bevel at a very high quality ready for orbital welding.

The TU6 allows a safe cold cutting with a high production and quality compare to traditional methods as grinding or flame cutting. The TU6 shaft receives internal clamping jaws to the ID size of the tube diameter to machine. The set of jaws are well marked to ease the operator choice while preparing the machine.

4 tools can work simultaneously to achieve combined bevel (30°, 37°, 45°, facing). The machine is auto-centering (± 0.1 mm) and auto maintained once clamped and has a self torque design. The TU6 machine is equipped as standard equipment with a tool holder able to bevel up to 16" (406mm) OD pipe.

Machine TU5	Clamping Range	Machining Range	Wall Thickness	Stroke
TU6	100mm ID -400mmID	100mm ID -406mm OD	2mm to 25mm	80 mm

Type	Motorization	Specifications		Weight
TU6P	Pneumatic	2 HP / 6 Bars (90 PSI)	2000 L/min	40KG
TU6H	Hydraulic	2 HP/ 60 bars	30 liters	42KG
TU6E	Electric	1 400Watt 230V/50 hertz	Speed Variator	44KG
		1 400Watt 115V /50hertz	Speed Variator	44KG
		1 400Watt 115V /60hertz	Speed Variator	44KG

Options	2 motors	Automatic clamping	Ovality tracker	Right angle drive
	Enveloping Jaws	Ratchet clamping	Carbide insert	Turning Plate cover

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU12

PIPE BEVELING MACHINE

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130mm ID - 610mm OD

INTERNAL CLAMPING



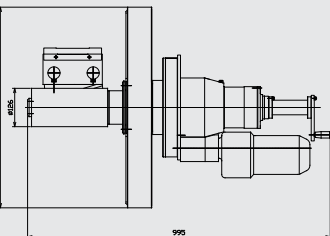
Machine delivered with :

- 2 standard tool bits of your choice
- Heavy duty box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE

Weight TU12: 120Kg

■ TU12 DIMENSIONS



COFIM ® types **TU12 heavy duty portable machine** using internal clamping method, auto centered and auto maintained once clamped in the tube and design with a self torque design. The TU12 can bevel tube and pipe at a high quality ready for orbital welding assembly compare to traditional methods as grinding or flame cutting. The TU12 shaft receives internal clamping jaws well marked with the ID size of the tube to ease the operator choice while preparing the machine. 4 HSS tool bits or carbide bits can work simultaneously to achieve combined bevel (30°+ Facing ; 37°5 + Facing; 45° + Facing...). The TU12 machine is equipped as standard equipment with a tool holder able to bevel up to 24" (610mm) OD pipe. The TU12 can be equipped with optional copying tool holder to machine pipe with very heavy wall thickness. A COFIM hydraulic driven TU12 machine can be supplied with a COFIM hydraulic power pack.

SAFETY is our priority: The TU5 is equipped with 2 actions safe start handle motor for operator use friendly.

Machine TU12	Clamping Range	Machining Range	Wall Thickness	Stroke
TU12	130mm ID -600mmID	130mm ID - 610mm OD	4mm to 25 mm	100 mm

Type	Motorization	Specifications		Weight
TU12P	2 x Pneumatic	3HP / 6 Bars (90 PSI)	4000 L/min	120KG
TU12H	2 x Hydraulic	4 HP/ 60 bars	60 liters	120KG
TU12E	1 x Electric	1400Watt 230V/50 hertz	Speed Variator	120KG
		1 400Watt 115V /50hertz	Speed Variator	120KG
		1 400Watt 115V /60hertz	Speed Variator	120KG
Options	Single point carriage with adjustable angle	Single Point carriage with template reproduction	ID Ovality tracker	
	from 200mm ID up to 900mm OD	from 400 ID mm up to 900mm OD	Automatic clamping	
		Enveloping Jaws	Carbide insert	

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

■ OPTION

The TU12 can be equipped with :

- Single point angular adjustable carriage (electric driven)from 200mm ID up to 900mm OD



- Single Point mechanical carriage by template reproduction from 400 ID mm up to 900mm OD. Using standard carbide insert



- TU12H with Hydraulic power unit type Beluga

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU14**PIPE BEVELING MACHINE****Rometec srl - www.rometec.it - Rometec srl - www.rometec.it - Rometec srl - www.rometec.it****500mmID – 914mm****INTERNAL CLAMPING****Machine delivered with :**

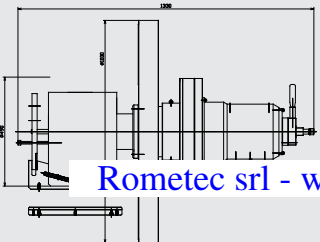
- 2 standard tool bits of your choice
- Heavy duty box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE**Weight TU14P:** 410Kg**Weight TU14H :** 410Kg

Manual clamping

Manual feeding

Heavy duty tool plate

■ TU14 DIMENSIONS

Beveling Machines COFIM ® types TU 14 is a transportable machine using an internal gripping method. The TU14 can bevel at a very high quality ready for orbital welding. The TU14 allows a safe cold cutting with a high production and quality compare to traditional methods as grinding or flame cutting. The TU14 shaft receives internal clamping jaws to the ID size of the tube diameter to machine. The set of jaws are well marked to ease the operator choice while preparing the machine.

4 tools can work simultaneously to achieve combined bevel (30 °, 37°, 45, facing). The machine is auto-centering ($\pm 0.1\text{mm}$) and auto maintained once clamped and has a self torque design.

The TU14 machine is equipped as standard equipment with a tool holder able to bevel up to 36" (610mm) OD pipe.

A hydraulic driven TU14 machine can be supplied with a COFIM hydraulic power unit.

Machine TU14	Clamping Range	Machining Range	Wall Thickness	Stroke
TU14	500mm ID -900mmID	500mm ID - 914mm OD	4mm to 25 mm	100 mm

Type	Motorization	Specifications		Weight
TU14P	2 x Pneumatic	6 HP/ 6 Bars	5000 L/min	410KG
TU14H	2 x Hydraulic	8 HP/ 90 bars	70 liters	410KG

Options	Single point carriage with adjustable angle	Single Point carriage with template reproduction	ID Ovality tracker	
	from 600mm ID up to 900mm OD	from 600 ID mm up to 1000mm OD	Automatic clamping	
	Hydraulic Power Unit	Enveloping Jaws	Carbide insert	

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

- Heavy duty tool plate
- Visual Access during machining



- Hydraulic power unit: 11 kW - 440 V/60 Hz

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

BM14

PIPE BEVELING MACHINE

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78mm ID -355mm OD

INTERNAL CLAMPING



Machine delivered with :

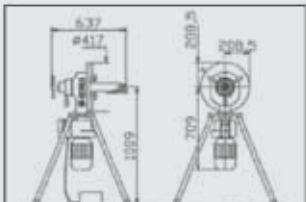
- 2 standard tool bits of your choice
- Transport box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE

Weight BM14: 105 Kg

- Very fast set up
- Quick tool holder adjustment
- Exceptional 8 sided insert tool bit
- 4 legged stand

■ BM14 DIMENSIONS



Beveling Machines COFIM ® types BM14 is the perfect pipe shop machine using an internal gripping method. The BM14 can bevel any preparation at a very high quality ready for orbital welding.

The BM14 allows a safe cold cutting with a high production and quality compare to traditional methods as grinding or flame cutting.

The BM14 shaft receives internal clamping jaws to the ID size of the tube diameter to machine. The set of jaws are well marked to ease the operator choice while preparing the machine. The BM14 has the easiest clamping jaws set up with no screws needed.

Stainless contact can be supplied to avoid carbon contact

4 tools can work simultaneously to achieve combined bevel (30 °, 37°5, 45, facing). 8 sided Insert can be used with the BM14 or standard HSS tool bits.

Machine BM14	Clamping Range	Machining Range	Wall Thickness	Stroke
BM14	78mm ID- 350mmID	78mm ID -355mm OD	2mm to 25 mm	80 mm

Type	Motorization	Specifications		Weight
BM14E	Electric/ 3 Phases	415V/50 hertz	Speed Variator	105KG
		415V/60 hertz	Speed Variator	105KG
BM14H	Hydraulic	4HP/ 60 bars	30 L/min	70KG
BM14P	Pneumatic	3HP/ 6 Bars (90 PSI)	2000 L/min	60KG

Options	Reduced Shaft	Automatic clamping	Ovality tracker	Pedal start
	Enveloping Jaws	Elbow shaft	Carbide insert	

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



• BM14 with Elbow shaft



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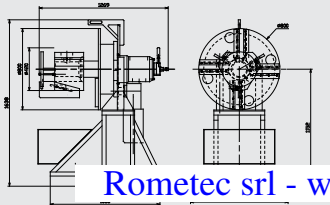
Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover / Pedal switch on request.

BM24**PIPE BEVELING MACHINE****Rometec srl - www.rometec.it - Rometec srl - www.rometec.it - Rometec srl - www.rometec.it****220mm ID -610mm OD****INTERNAL CLAMPING****Machine delivered with :**

- 2 standard tool bits of your choice
- Transport box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ FEATURE**Weight BM24: 320 Kg**

- Very fast set up
- Quick tool holder adjustment
- Exceptional 8 sided insert tool bit
- 4 legged stand

■ BM24 DIMENSIONS

Beveling Machines COFIM ® types BM24 is the perfect pipe shop machine using an internal gripping method. The BM24 can bevel any preparation at a very high quality ready for orbital welding.

The BM24 allows a safe cold cutting with a high production and quality compare to traditional methods as grinding or flame cutting.

The BM24 shaft receives internal clamping jaws to the ID size of the tube diameter to machine. The set of jaws are well marked to ease the operator choice while preparing the machine. To ease the set up of the jaws no screws needed for the BM24.

Stainless contact can be supplied to avoid carbon contact

4 tools can work simultaneously to achieve combined bevel (30 °, 37°5, 45, facing). 8 sided Insert can be used with the BM14 or standard HSS tool bits.

The BM 24 machine is equipped with a tool holder able to bevel up to 24" (610mm) OD pipe.

Machine BM14	Clamping Range	Machining Range	Wall Thickness	Stroke
BM24	220mm ID- 600mmID	220mm ID -610mm OD	2mm to 25 mm	100 mm

Type	Motorization	Specifications		Weight
BM24E	Electric/ 3 Phases	415V/50 hertz	Speed Variator	xxKG
		415V/60 hertz	Speed Variator	xxKG
BM24H	Hydraulic	8HP/60 bars	30 L/min	xxKG

Options	Reduced Shaft	Automatic clamping	Ovality tracker	Pedal start
	Envelopping Jaws	Elbow shaft	Carbide insert	

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

PBM PIPE REVELING MACHINE EXTERNAL CLAMPING



Machine delivered with :

- 2 standard tool bits of your choice
- Machine in Box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- The complete set of clamping jaws
- Technical hand book

■ OPTIONS



Chips Conveyor

The PBM series is the best solution for a pipe shop looking to improve their production by quantities and qualities.

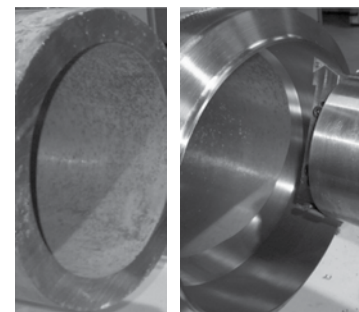
The OD clamping design leaves all the space in the middle of the pipe to do any inner machining. Because of clamping by means of a self-centering V prism it saves time when used on different pipe sizes. We can supply insert tool holders with inserts which are able to work the pipe in the whole range of the machine without adjusting the cutters.

We can supply various options with the PBM machines such as:

- ID ovality tracker
- OD cylindrical machining carriage stroke 350mm
- ID counter boring carriage stroke 350mm
- Copying carriage for thick wall and very thick wall up to 100mm.

Machine PBM	Clamping Range	Machining Range	Wall Thickness	Stroke
PBM3	0mm - 76mm	2mm - 114mm	Up to 5 mm	80 mm
PBM4	20mm - 116mm	10mm-116mm	Up to 13mm	100 mm
PBM6	46mm- 180mm	30mm- 180mm	Up to 25mm	100 mm
PBM16	60mm-410mm	40mm- 410mm	Up to 25mm	100 mm
PBM24	215mm-620mm	170mm-620mm	Up to 45mm	100 mm
PBM30	215mm-780mm	170mm-780mm	Up to 45mm	100 mm

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



Welding J prep on the tube end

+

Match boring

6" length ID cylindrical + 1/4 slope machining

A QUICK AND SIMPLE WAY TO IMPROVE YOUR MACHINING ON A TUBE END

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Health and safety Program. ROMM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

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PIPE BEVELING MACHINE EXTERNAL CLAMPING



■ OPTIONS



Tube Conveyor

Type	Motorization	Standard	OPTIONS
PBM3 PBM4 PBM6 PBM16	Electric 3 Phase Motors 415V/50hz/60Hz	Manual clamping + Manual feeding	Automatic clamping Automatic feeding
PBM24	Electric 3 Phase Motors 415V/50hz/60Hz	Automatic clamping + Automatic feeding	ID ovality tracker Copying carriage for thick wall pipe
PBM30	Electric 3 Phase Motors 415V/50hz/60Hz	Automatic clamping + Automatic feeding	Elbow clamping device Pipe stop Pipe Conveyors

Quick

See list of working times which have been measured by making a 30° bevel

Pipe	Diameter	Wall thickness	Material	Working time
4"	114,3 mm	6 mm	St. 37	appr. 5 sec
6"	168,3 mm	12 mm	St. 37	appr. 30 sec
6"	168,3 mm	25 mm	St. 37	appr. 1 min.
10"	273,0 mm	19 mm	Duplex - r.v.st	appr. ca. 2 min.
12"	323,9 mm	12 mm	Duplex - r.v.st	appr. ca. 1 min.
16"	406,4 mm	13 mm	St. 37	appr. ca. 45 sec.
20"	508,0 mm	20 mm	Duplex - r.v.st	appr. ca. 1 min.
24"	609,6 mm	25 mm	Duplex - r.v.st	appr. ca. 1,5 min.

Obviously more forms of end preparation can be done. It is also possible to make a combination of end preparations.

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



PBM24



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Health and safety Program: Rometec machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TU3D

PIPE BEVELING MACHINE EXTERNAL CLAMPING

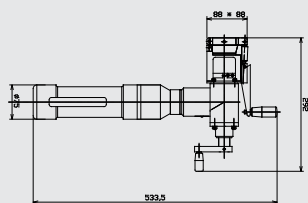
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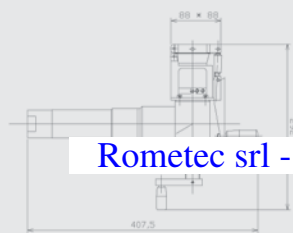
Machine delivered with :

- 2 standard tool bits of your choice
- Machine in Box
- Necessary tools to use the machine (Allen keys, screws, etc..)
- 1 collet to cover a range
- Technical hand book

■ TU3D ELECTRIC DIMENSIONS



■ TU3D PNEUMATIC DIMENSIONS



Beveling Machines COFIM ® types TU2D & TU3D are portable machines using an external gripping method. The TU2D can bevel at a very high quality ready for orbital welding. The TU2D & TU3D receive clamping collet to the OD size of the tube diameter to machine. The clamping collet jaws are well marked to ease the operator choice while preparing the machine. 2 tools can work simultaneously to achieve combined bevel (30 °, 37°5, 45, facing). The machine is auto-centering ($\pm 0.1\text{mm}$) and auto maintained once clamped and has a self torque design. The TU2D & TU3D machine can also be equipped with a milling heads to the exact size of your bevel needed then your tube is ready to apply an orbital welding process. The TU2D & TU3D can be supplied with a short clamping head, to prepare fittings.

Machine	Clamping Range	Machining Range	Wall Thickness	Stroke
TU2D	4mm ID - 26mm ID	4mm ID - 26mm OD	5 mm	25 mm
TU3D	4mm ID - 26mm ID	4mm ID - 26mm OD	5 mm	25 mm

Machine U3D	Clamping Range	Machining Range	Wall Thickness	Stroke
TU2D P TU3D P	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min(35 Cfm)	5,5KG
TU2D E TU3D E	Electric / 1 400Watt	230V/50 hertz	Speed Variator	7,5KG
		115V /50hertz	Speed Variator	7,5KG
		115V /60hertz	Speed Variator	7,5KG
TU2D B TU3D B	Battery	18 V	Charger + 2 Batteries	7,5KG

Options	Short Clamping Head	Milling head		
	TU2D Motor in line	Carbide insert		

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

TUD89 PIPE REVELING MACHINE EXTERNAL CLAMPING

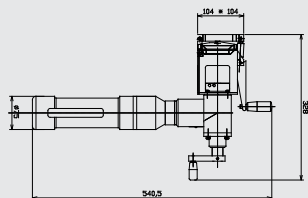
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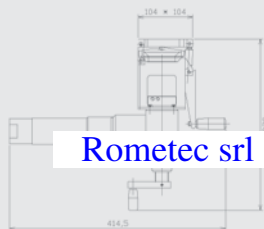
Machine delivered with :

- 2 standard tool bits of your choice
- Machine in Box
- Necessary tools to use with the machine (Allen keys, screws, etc..)
- 1 collet to cover a range
- Technical hand book

TUD ELECTRIC DIMENSIONS



TUD PNEUMATIC DIMENSIONS



Machine TUD	Clamping Range	Machining Range	Wall Thickness	Stroke
TUD	7mm ID - 61mm ID	7mm ID - 61mm ID	5 mm	35 mm
Type	Motorization	Specifications		Weight
TUD P	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min(35 Cfm)	7KG
TUD E	Electric / 1 400Watt	230V/50 hertz	Speed Variator	9KG
		115V /50hertz	Speed Variator	9KG
		115V /60hertz	Speed Variator	9KG
TUD B	Battery	18 V	Charger + 2 Batteries	8KG
Options	Short Clamping Head	Milling head		
	TUD Motor in line	Carbide insert		

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

Machine TUD89	Clamping Range	Machining Range	Wall Thickness	Stroke
TUD89	7mm ID - 89mm ID	7mm ID - 89mm ID	5 mm	35 mm
Type	Motorization	Specifications		Weight
TUD89 P	Pneumatic / 1HP	6Bars (90 PSI)	1000 L/min(35 Cfm)	10KG
TUD89 E	Electric / 1 400Watt	230V/50 hertz	Speed Variator	12KG
		115V /50hertz	Speed Variator	12KG
		115V /60hertz	Speed Variator	12KG
TUD89 B	Battery	18 V	Charger + 2 Batteries	11KG
Options	Short Clamping Head	Milling head		
	TUD2D Motor in line	Carbide insert		

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



Customized TU3D for special application



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Health and safety Program. ROMETEC machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

DE3-25 DE20-63

PIPE FACING MACHINE EXTERNAL CLAMPING

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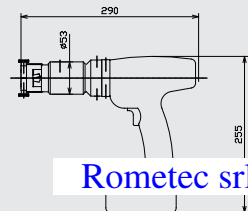
Machine delivered with :

- 1 collet of your choice
- 2 inserts 4 cutting sides
- Machine box
- Necessary tools to use the machine
- Hand book

■ FEATURE

- 1 collar per diameter (carbon or stainless)
- 0-400 rmp - 2 speeds
- Chip protection
- 4 sided Carbide Insert
- Chip deflector
- 2 batteries
- 1 charger
- 1 metalic box

■ DE3-25 DIMENSIONS



The Tube Facing Machines COFIM® types DE3-25 & DE20-63 & DE3-63 are very light portable machines using an external clamping method.

The DE series allow a safe cold cutting with a high production and high quality giving a tube ready to be orbital welded.

The set of clamping collet are well marked to ease the operator choice while preparing the machine.

The turning plate is equipped with 1 facing carbide insert with 4 cutting edges giving a preparation at a very low cost.

The motor of the DE series can be turned 4 times at 90°, giving you more access possibilities when used on site. A bench can be supplied to work in a clamping vice.

Machine DE	Clamping Range	Machining Range	Wall Thickness	Stroke
DE 3/25 DE RA3/25*	3mm OD – 25.4 OD	3mm OD – 25.4mm OD	1mm to 3 mm	20 mm
DE 20/63	20mm OD - 63m OD	20mm OD – 63mm OD	1mm to 3 mm	20 mm
DE 3/63	3mm OD - 63mm OD	3mm OD – 63mm OD	1mm to 3 mm	20 mm

Type	Motorization	Specifications	Weight
DE 3/25 P	Pneumatic	1HP / 6Bars (90 PSI)	1000 L/min(35 Cfm)
DE 3/25 E DE RA 3/25*	Electric	400Watt 230V/50 hertz	Speed Variator
		115V /50hertz	Speed Variator
		115V /60hertz	Speed Variator
DE 3/25 B DE RA 3/25*	Battery	18 V	Charger + 2 Batteries
			3 KG

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

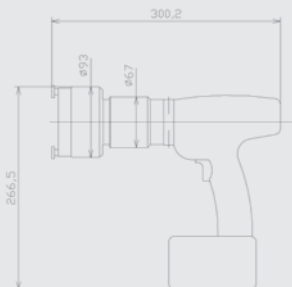


The DE series can cover from 3mm to 63 mm with 2 heads and 1 motor.

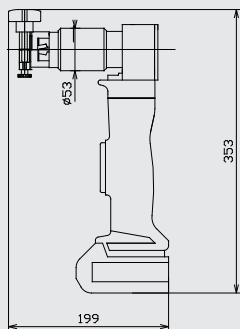
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Health and safety Program. COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

■ DE 20-63 DIMENSIONS



■ DE RA3-25 DIMENSIONS



Type	Motorization	Specifications		Weight
DE 20/63 P	Pneumatic	1HP / 6Bars (90 PSI)	1000 L/min(35 Cfm)	4,5 KG
DE 20/63 E	Electric	400Watt 230V/50 hertz	Speed Variator	4,5 KG
		115V /50hertz	Speed Variator	4,5 KG
		115V /60hertz	Speed Variator	4,5 KG
DE 20/63 B	Battery	18 V	Charger + 2 Batteries	4,5 KG
DE 3/63 P	Pneumatic	1HP / 6Bars (90 PSI)	1000 L/min(35 Cfm)	4,5 KG
DE 3/63 E	Electric	400Watt 230V/50 hertz	Speed Variator	4,5 KG
		115V /50hertz	Speed Variator	4,5 KG
		115V /60hertz	Speed Variator	4,5 KG
DE 3/63 B	Battery	18 V	Charger + 2 Batteries	4,5 KG

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



DE RA3-25 battery operated



Machine support



DE 20-63 pneumatic

TUDC 114 TUDC 168

PIPE FACING MACHINE EXTERNAL CLAMPING

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Machine delivered with :

- 1 collet of your choice
- 2 inserts 4 cutting sides
- Machine box
- Necessary tools to use the machine
- Hand book

■ OPTIONS:

- Automatic clamping
- Automatic feeding
- Feed Limit stops

The Tube Facing Machines COFIM® types TUDC are workbench mounted machines using an external gripping method.

The TUDC series allow a high quality preparation and high production for tube preparation before orbital welding. The clamping collets are well marked to ease the operator choice while preparing the machine. One collet per OD tube size is needed.

The turning plate is equipped with 1 facing carbide insert with 4 cutting edges giving a preparation at a very low cost.

Machine TUDC	Clamping Range	Machining Range	Wall Thickness	Stroke
TUDC 114	32mmOD - 114mmOD	32mmOD - 114mmOD	1mm to 4 mm	40 mm
TUDC 168	63mm OD- 168mm OD	63mm OD- 168mm OD	1mm to 4 mm	40 mm

Type	Motorization	Specifications		
TUDC 114P	Pneumatic	1HP/ 6Bars (90 PSI)	1000 L/min (35 Cfm)	
TUDC 114E	Electric	1 400Watt 230V/50 hertz	Speed Variator	
		1 400Watt 115V /50hertz	Speed Variator	
		1 400Watt 115V /60hertz	Speed Variator	

Type	Motorization	Specifications		
TUDC168	Pneumatic	1HP/ 6Bars (90 PSI)	1000 L/min (35 Cfm)	
TUDC168E	Electric	1 400Watt 230V/50 hertz	Speed Variator	
		115V /50hertz	Speed Variator	
		115V /60hertz	Speed Variator	

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO



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Health and safety Program: COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.



Flange facing machine with outside diameter clamping.
Automatic or manual feed motion.
Selection of: 2 ways feed motion and feed speed.
2 adjustable thrusts, with automatic release.
For all shape of face: flat ; raised face ; single or double groove ;
O ring groove ; RTJ.

FF 170: 0 to 170 mm

FF 310: 0 to 310 mm

FF 610: 0 to 610 mm



The TU machines can be equipped with flange facing arm as an option. Please consult us.



Portable in line boring and welding machine from diameter 25mm up to 600mm.

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Machine delivered with :

- Complete set of clamping jaws
- 1 set of cutting tool bits
- 1 standard beveling tool bit of your choice
- Wooden box
- All the necessary tools to operate the machine
- Hand book

■ MACHINE ROBUST:

- Perpendicular cut
- Able to machine thick wall pipe up to 110 mm
- Cut and bevel simultaneously
- Internal bevel or Internal machining with accessory

■ TOOL HOLDER:

- 45 mm stroke
- Star wheel system
- Tool holders available: 70mm Stroke

The COFIM **CTO Split Frame machines**, is an OD clamping design which can open in half to set on closed line or can be slipped over open end pipe. Their compact design and low radial clearance make the CTO an ideal tool for in-line pipe cutting.

The CTO machines are fast, reliable, and precise. Machining is performed with HSS tool bit or carbide insert as optional.

The CTO machine has a fix body to clamp on the OD of the pipe then an upper rotating ring holding 2 tool holders to cut, to bevel, or to cut & bevel simultaneously the pipe.

The CTO machine uses independent clamping jaw (chuck system) with extension leg sets, 2 starwheel feed tool holder and multi-hanging points to ease the set up.

The CTO can be pneumatic, hydraulic or electric driven 115 V, 220 V and 415 V.

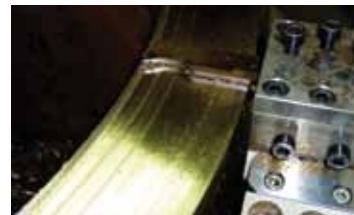
Options such as Single point machining tool holder, Ovality tracker, counter boring tool holder, Carbide cutting kit, can be used to match the need of specific pipe jobs.

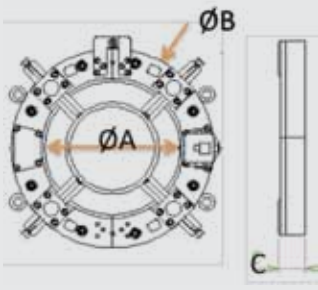
Type	Motorization	Specifications	Weight
CTO P	Pneumatic	3HP or 6 HP	2 200 L/min / 6Bars (90 PSI)
CTO H	Hydraulic	3HP or 6HP	To use with Hydraulic pack
CTO E	Electric	2 000Watt 230V/50Hertz	Speed Variator
		115V /50hertz	
		115V /60hertz	
CTO E	Electric	3 phase motor 415 V	Speed Variator

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CTO 900 in situ





■ OPTIONS:

- Tool holder for Carbide cutting process.
- Clutch system with no adjustment needed can feed in two directions
- OD ovality carriage
- Counter boring tool holder
- Single point machining for thick wall up to 150mm



OD Tracker Device

MACHINES	CTO50	CTO89	CTO114	CTO168	CTO219	CTO273	CTO323	CTO406	CT508
Ø RANGE	1/2"-2"	1"-3"	2"-4"	3"-6"	4"-8"	6"-10"	8"-12"	10"-16"	12"-20"
A mm	60	89	150	200	260	310	350	448	544
B mm	148	176	370	420	480	530	570	668	766
C mm	130	130	92	92	92	92	92	92	92
Power	1 HP	1 HP	1 HP	1 HP	2 HP	2HP	2 HP	6 HP	8HP
Weight	7Kg	10KG	15KG	25KG	35KG	40KG	65KG	78KG	95KG

MACHINES	CTO610	CTO760	CTO900	CTO1000	CTO1200	CTO1400	CTO1600	CTO1800
Ø RANGE	16"-24"	24"-30"	28"-36"	36"-42"	40"-48"	48"-56"	56"-63"	64"-73"
A mm	640	790	932	1130	1250	1450	1650	1850
B mm	910	1010	1202	1455	1575	1775	1875	2175
C mm	104	104	104	122	122	122	122	122
Power	10HP	10HP	15HP	20HP	30HP	30HP	30HP	40HP

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS - ASK FOR A DEMO

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Health and safety Program: Conim machines respect ISO 5549 to prevent vibration-induced white finger (VWF). Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request / Plate cover on request/ Pedal switch on request.

HPU delivered with :

- Oil necessary to run the HPU
- Hydraulic hoses filled in with oil
- Remote control
- Transport box
- Hand Book
- Maintenance book

Hydraulic power unit from 3KW à 75 KW can be supplied to go with your COFIM machine



Electric remote control

SERIE HEAVY	GH750 (75 kW)	GH550 (55 kW)	GH220 (22KW)	GH110SP (11KW)	GH050 (5.5 kW)	Beluga31 (3 kW)	Beluga51 (5KW)
Rotation	1 direction	1 direction	1 direction	2 directions	2 directions	1 direction	2 directions
Maxi pressure	160 bars	120 bars	140 bars	110 bars	90 bars	120 bars	120 bars
Flow	0-245 l/mn	0-245 l/mn	0-82 l/mn	0-65 l/mn	0-65 l/mn	0-29 l/mn	0-29 l/mn
Feed + clamping	included	included	option	option	no	no	no
Maxi pressure	200 bars	200 bars	no	no			
Flow	18 L/mn	18 L/mn					
Wooden box (dimension)	2100 mm	2100 mm	2100 mm	1350 mm	870mm	1000mm	2100 mm
	1250 mm	1250 mm	1250 mm	900 mm	500 mm	400 mm	1250 mm
	1850 mm	1850 mm	1850 mm	1250 mm	1050 mm	450 mm	450 mm
Heating resistor	included	included	option	option			
Hydraulic hoses & remote control length	15 meters	15 meters	8 meters	8 meters	5 meters	5 meters	5 meters
Quick connections	included	included	included	included	included	included	included

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SPECIAL EQUIPMENT FOR SPECIAL APPLICATION



Nuclear Industry



Chemical industry

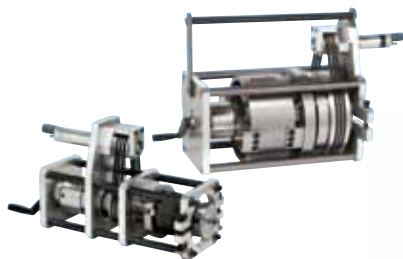


Navy Industry



PIPE Manufacturing Industry

COFIM designs products of quality, compliant to harder industrial inquiries.
Our goal : your satisfaction – COFIM designs your adapted machine under your request
Cofim is able to design specific machine to your specific need, customized your machine.
Cofim can also customized your standard equipment to reach your special request .
COFIM has 25 years experience in manufacturing toolings for the pipe and tube technology used in diverse industries . Our Engineering Office works with Autocad & Solid works for a scientific and industrial approach and offers its strong experience of the tube tooling technology
Please feel free to ask us for your special need.



Special machine for the Oil & Gas Industry



Special machine for the Nuclear Industry

ASK FOR A QUOTATION TO HAVE THE COMPLETE DETAILS



SHIPPYARD Industry



Civil Aviation & Aerospace Industry




OIL & GAS Industry

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Health and safety Program. COFIM machines respect ISO 5549 to prevent vibration-induced white finger (VWF).
Motors are all equipped with safe start handles & SJS burn out protection (electric) / ATEX certified on request /
Plate cover on request/ Pedal switch on request.

Pipe Dimensions Imperial/ Metric Pipe Chart

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CTO + TU12 + TU6 + BM14					CTO + TU12 + TU6					CTO + TU12 + TU14 + BM24					CTO + PBM + BM24 + BM14 + TU12 + TU6								
Nominal Pipe In/mm	OD in/mm	ID in/mm	Schedule	Wall thickness mm	Nominal Pipe In/mm	OD in/mm	ID in/mm	Schedule	Wall thickness mm	Nominal Pipe In/mm	OD in/mm	ID in/mm	Schedule	Wall thickness mm	Nominal Pipe In/mm	OD in/mm	ID in/mm	Schedule	Wall thickness mm				
10 250	10.75 273.1		266.2	55	3.40	16 400	16 406.4		396.8	10S	4.78	24 600	24 609.6		597.3	10/10S	6.35	30 750	30 762		746.2	10	7.92
			264.6	10S	4.19				393.7	10	6.35				590.9	STD/20/40S	9.53				742.9	STD/40S	9.53
			260.3	20	6.35				390.6	20	7.92				584.6	XS/80S	12.70				736.6	XS/20/80S	12.70
			257.4	30	7.80				387.3	STD/30/40S	9.53				581.5	30	14.27				730.2	30	15.88
			254.5	STD/40/40S	9.27				381.0	XS/40/80S	12.70				575.0	40	17.48				xxx.x	10	7.92
			247.6	XS/60/80S	12.70				373.1	60	16.66				560.8	60	24.61				xxx.x	STD/40S	9.53
			242.8	80	15.09				363.5	80	21.44				548.1	80	30.96				xxx.x	XS/80S	12.70
			236.5	100	18.26				354.0	100	26.20				532.2	100	38.89						
			230.1	120	21.44				344.5	120	30.96				518.0	120	46.02						
			222.2	140/XX	25.40				333.3	140	36.53				505.3	140	52.37						
			215.8	160	28.58				325.4	160	40.49				490.9	160	59.54						
12 300	12.75 323.9		315.9	55	3.96	18 450	18 457.2		447.6	10S	4.78	36 900	36 914.4		746.2	10	7.92				746.2	10	7.92
			314.7	10S	4.57				444.5	10	6.35				742.9	STD/40S	9.53				742.9	STD/40S	9.53
			311.1	20	6.35				441.4	20	7.92				736.6	XS/20/80S	12.70				736.6	XS/20/80S	12.70
			307.0	30	8.38				438.1	STD/40S	9.53				730.2	30	15.88				730.2	30	15.88
			304.7	STD/40S	9.53				434.9	30	11.13				xxx.x	10	7.92				xxx.x	10	7.92
			303.2	40	10.31				431.8	XS/80S	12.70				xxx.x	STD/40S	9.53				xxx.x	STD/40S	9.53
			298.4	XS/80S	12.70				428.7	40	14.27				xxx.x	XS/80S	12.70				xxx.x	XS/80S	12.70
			295.3	60	14.27				419.1	60	19.05												
			288.8	80	17.48				409.5	80	23.83												
			280.9	100	21.44				398.5	100	29.36												
		14 350	14 355.6		273.0			120/XX	25.40	20 500	20 508				387.3	120	34.93						
	266.6			140	28.58		377.9	140	39.67														
	257.2			160	33.32		366.7	160	45.24														
	346.0			10S	4.78		496.9	10S	5.54														
	342.9			10	6.35		495.3	10	6.35														
	339.8			20	7.92		488.9	STD/20/40S	9.53														
	336.5			STD/30/40S	9.53		482.6	XS/30/80S	12.70														
	333.3			40	11.13		477.8	40	15.09														
	330.2			XS/80S	12.70		466.8	60	20.62														
	325.4			60	15.09		455.8	80	26.19														
	317.5			80	19.05		442.9	100	32.54														
	307.9	100	23.83																				
			284.2	160	35.71				408.0	160	50.01												



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Z.I. LES BLANCHISSERIES 38500 VOIRON - FRANCE
Tel : +33 476 656 389 - Fax : +33 476 659 472

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Z.I. LES BLANCHISSERIES 38500 VOIRON - FRANCE

Tel : +33 476 656 389 - Fax : +33 476 659 472

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