



1409 4th Street  
Nisku, AB T9E 7M9  
Phone: 780-955-3907

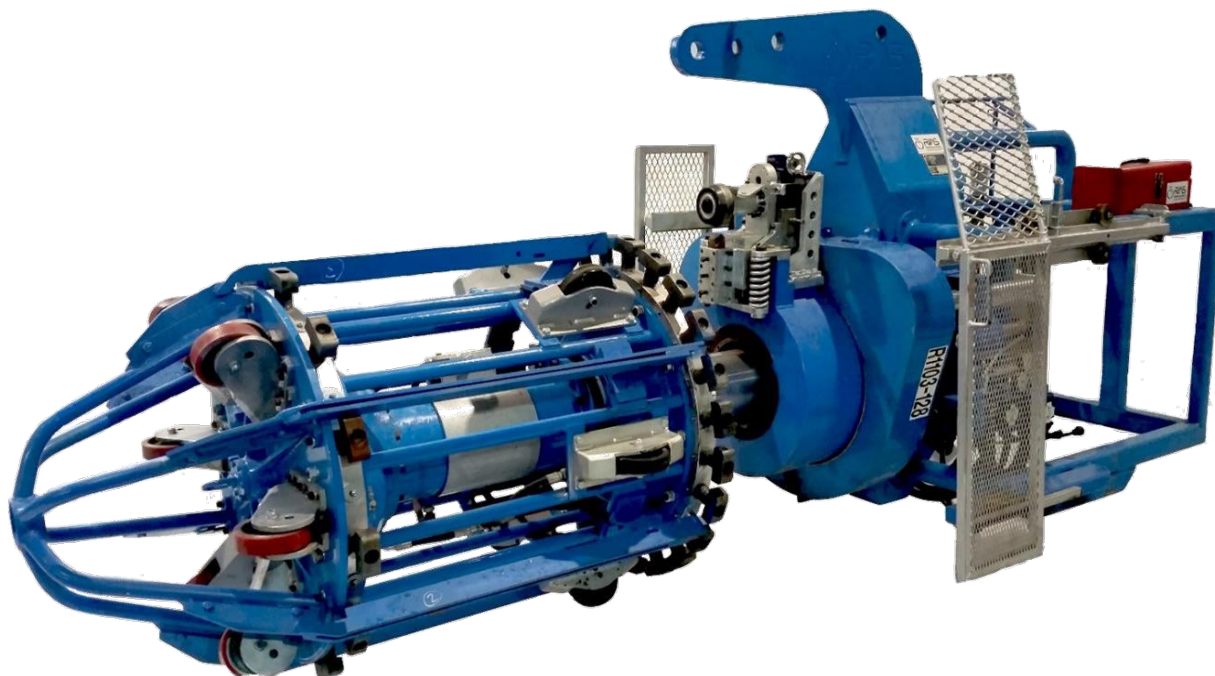


**RMS**  
Welding Systems



979 Drennan Road  
Conroe, Texas 77303  
Phone: 713-400-8660

# COUNTERBORE MACHINE - CBM



**The RMS Counterbore Machine (CBM) is used to machine internal transitions. This allows pipe of unequal wall thickness to be machined and matched.**

Hydraulically operated clamping shoes hold the machine square to the pipe from the inside while a rotating face plate equipped with a single carbide cutting tool is fed up to 150mm into the pipe end. The depth of cut can be adjusted to best suit needs in the field.

The counterbore operation takes between 15 to 30 minutes depending on the pipe wall thickness and operator experience. The cut is made in multiple passes

Power can be supplied using a portable Hydraulic Power Unit (HPU) or by simply adapting the carrying unit.

| Feature                                                                                                      | Benefits                                                                                                      |
|--------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"><li>Up to 150mm cutback</li><li>14° to 30° taper angle supported</li></ul> | <ul style="list-style-type: none"><li>Facilitates use of AUT</li><li>Match unequal wall thicknesses</li></ul> |





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| Counterbore Machine              |                     |                  |
|----------------------------------|---------------------|------------------|
| General Specifications           |                     |                  |
| <b>Number of Tool Holders</b>    | 1                   |                  |
| <b>Face Plate Rotation Speed</b> | 20 - 35 rpm         |                  |
| <b>Hydraulic Pressure</b>        |                     |                  |
| Maximum System                   | 3,300 psi           | 225 bar          |
| Rotation Operating               | 1,200 - 1,700 psi   | 80 - 120 bar     |
| Face Plate Feed                  | 350 psi max         | 25 bar max       |
| Expander                         | 350 psi max         | 25 bar max       |
| Return                           | 70 psi max          | 5 bar max        |
| <b>Hydraulic Oil Flow</b>        | 33.5 - 38.3 gallons | 127 - 145 liters |

| Machine Dimensions |  |        |          |           |          |
|--------------------|--|--------|----------|-----------|----------|
| Pipe Diameter      |  | Length |          | Weight    |          |
| 16" - 24"          |  | 120"   | 3,050 mm | 4,250 lbs | 1,900 kg |
| 28" - 32"          |  | 130"   | 3,300 mm | 5,100 lbs | 2,300 kg |
| 34" - 38"          |  | 140"   | 3,550 mm | 6,000 lbs | 2,700 kg |
| 40" - 44"          |  | 140"   | 3,550 mm | 7,000 lbs | 3,200 kg |
| 46" - 50"          |  | 140"   | 3,550 mm | 8,125 lbs | 3,700 kg |