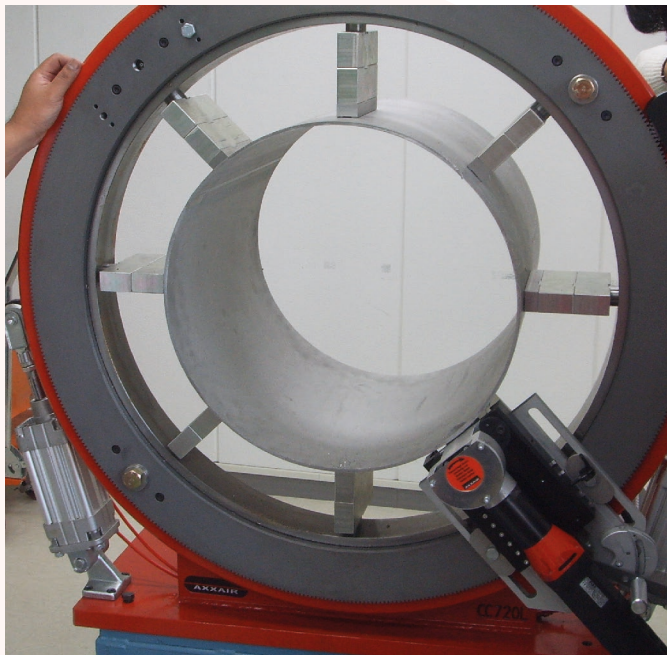


AXXAIR orbital cutting

A proper tube preparation is essential to produce a proper weld.

High quality cutting is guaranteed by AXXAIR's orbital cutting machines. The machines feature stainless steel concentric jaws to prevent the deformation of the tubes.

The perfect position of the tube within the machine also guaranty the perpendicularity of the cut as the saw travels around the tube and the consistency that perpendicularity cut after cut.

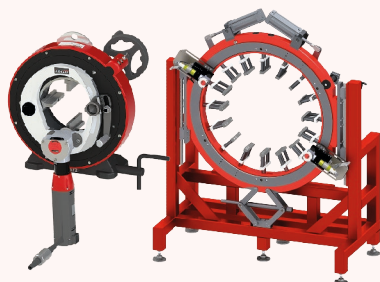


The precision of our cutting machine allow a perfect tube to tube alignment, with the smallest gap possible, removing the need to facing the tube therefore saving a significant amount of time and money.

AXXAIR's orbital cutting machines are an indispensable tool for any automatic and orbital welding.

AXXAIR has the **largest orbital cutting range in the world !**

11 different models to cut tubes from diameter **5 to 1100 mm!**



FLEXIBILITY, PRODUCTIVITY

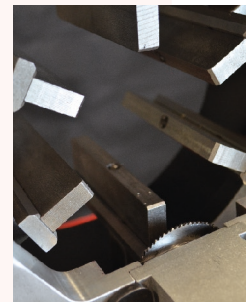
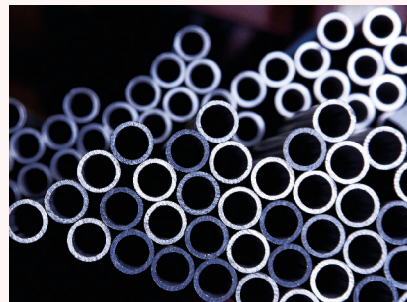
AXXAIR frames are quickly and easily scalable for bevelling and orbital welding.

QUALITY

Cutting with no tube distortion, (multi-contact concentric clamping) ideal for thin walled stainless steel tubes. High quality geometric cutting (perpendicularity of <math><0.25\text{ mm}</math>) and excellent surface quality (few burrs).

PORTABILITY

With the easy to remove sawing attachment, AXXAIR's cutting machines are easy to transport on site or move within a workshop. Perfect preparation for thick tubes before bevelling and welding with wire.

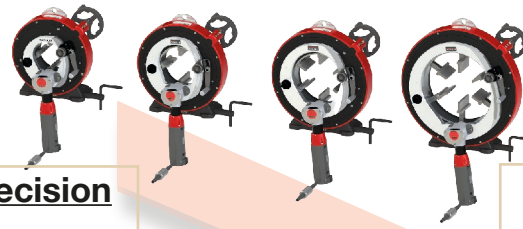


Please do not hesitate to contact us for all enquiries relating to orbital cutting technology.

We are glad to share our decades long experience in orbital cutting and helping you to select the solution that fits your needs.

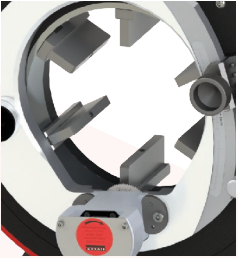


122 - 172 - 222 - 322



No tube deformation

Concentric clamping



Basic and extra stainless steel jaws: no pollution of stainless steel tubes

Cutting precision

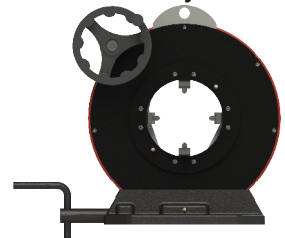
Perpendicularity of < 0.25 mm

Cutting quality

Rotation handle for controlled and continuous cutting speed

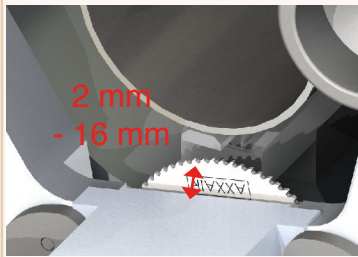
A perfect sealing against chips

All rotating parts are incorporated in the body



Reduced vibration and increased blade life

Optimised blade to jaw distance



Global Process

Can be transformed into an orbital bevelling and welding machine

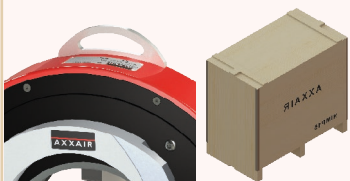
Uptake

feature a dual blade position allowing to cut elbows or flanges with no wasting of tube.

1200W motor or pneumatic motor (as required)

Cutting capacity: Up to 15 mm wall thickness*

Easy handling and transportation



Continuous use

Anti-twist cable with bearings. Protects the electric cable from damage resulting from rotation around the tube.

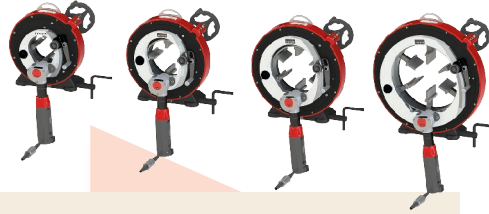
Opening capacity

122	ø5 - ø119 mm 0.25" - 4.5 "
172	ø16 - ø173 mm 0.625" - 6.625 "
222	ø55 - ø228 mm 2.375" - 8.625 "
322	ø141 - ø328 mm 5.563" - 12.750 "

*depending on the type of steel



122- 172 - 222- 322



AXXAIR
INNOVATIVE ORBITAL SOLUTIONS

Technical specifications:

Low speed motor:

120V or 230V, 1200W, electronic speed variator with a cutting compensator
Vibration level in accordance with standard EN 28662: <math>< 2.5\text{m/s}^2</math>, Protection class: IP 20

Rotation speed (6 speed variations): from 30 RPM to 75 RPM

Pneumatic motor:

60 to 110 rpm, air flow 1500 l/min at 6 bar

All motors are supplied in their own individual cases, including the necessary tools

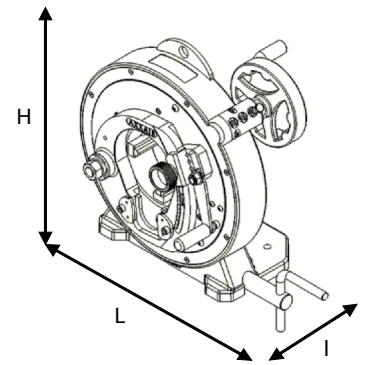
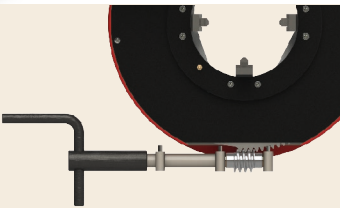


Robustness:

Very efficient clamping system thanks to a screw without end directly engaged on the clamping cam.

Easy maintenance and control:

- Lubrication of the inner parts with the grease nipples
- Quick access to the inner screw



	Product Code	Machine's jaw opening capacity in mm		Net weight	Dimensions (HxLxW in mm)
		With basic jaws	With extra jaws (included)		
120V 1200W low-speed motor	122FS15	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172FS15	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222FS15	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322FS15	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304
230V 1200W low-speed motor	122FS25	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172FS25	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222FS25	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322FS25	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304
Pneu- matic motor	122PD	Ø29 - Ø119	Ø5 - Ø99	44 kg	443 x 541 x 304
	172PD	Ø74 - Ø173	Ø16 - Ø116	51 kg	493 x 566 x 304
	222PD	Ø128 - Ø228	Ø55 - Ø155	59 kg	548 x 594 x 304
	322PD	Ø230 - Ø328	Ø141 - Ø239	71 kg	649 x 644 x 304

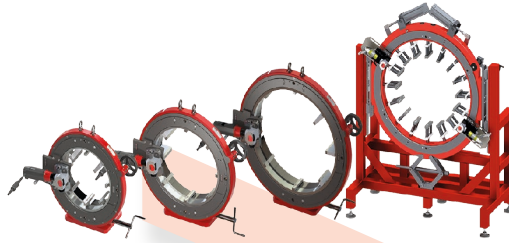


Join experience



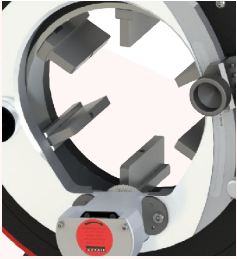
421- 521-721-1100

AXXAIR
INNOVATIVE ORBITAL SOLUTIONS



No tube deformation

Concentric clamping



Basic and extra **stainless steel** jaws: no pollution of stainless steel tubes

Cutting precision

Perpendicular cuts < 0.4 mm

Uptake

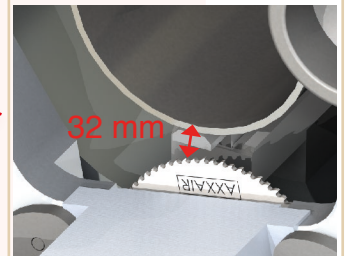
feature a dual blade position allowing to cut elbows or flanges with no wasting of tube.

Cutting quality

Rotation handle for controlled and continuous cutting speed

Reduced vibration and increased blade life

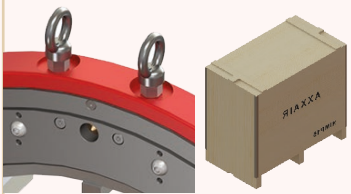
Optimised blade to jaw distance



Continuous use

Anti-twist cable with bearings. Protects the electric cable from damage resulting from rotation around the tube.

Easy handling and transportation



1200W motor or pneumatic motor (as required)

Cutting capacity:
Up to a wall thickness of 15 mm*

Opening capacity

421	ø212 - ø422 mm 8.625 - 16 "
521	ø312 - ø522 mm 12.75 - 20 "
721	ø447 - ø725 mm 18 - 28"
1100	ø711 - ø1016 mm 28 - 40 "

*depending on the type of steel



421-521-721-1100



Technical specification:

- Low-speed motor:

120V or 230V, 1200W, electronic speed variator with a cutting compensator

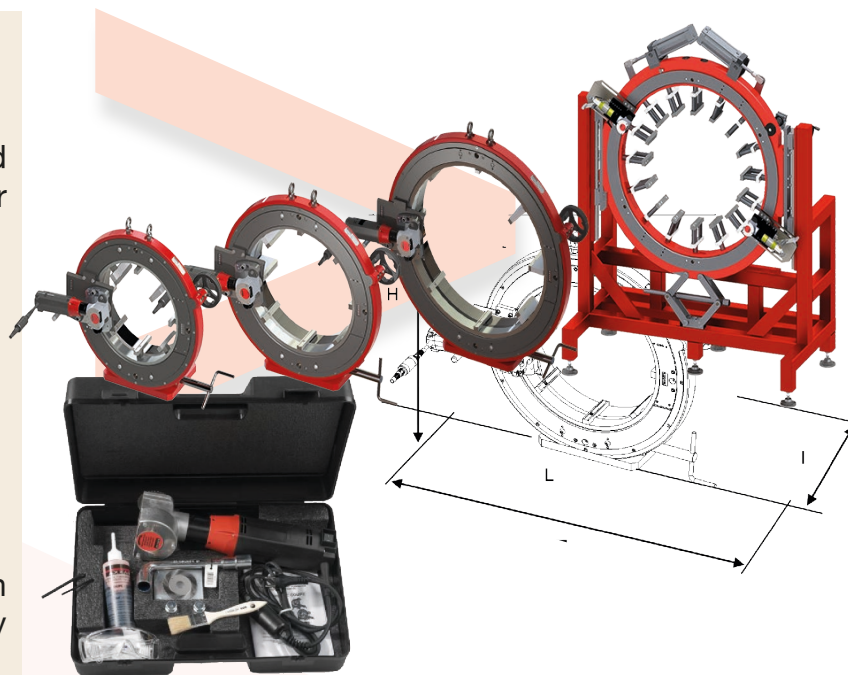
Vibration level in accordance with standard EN 28662: <2.5m/s², Protection class: IP 20

Rotation speed (6 speed variations)
from 30 RPM to 75 RPM

- Pneumatic motor:

60 to 110 rpm, air flow 1500 l/min at 6 bar

All motors are supplied in their own individual cases, including the necessary tools.



	Product Code	Machine's jaw opening capacity in mm		Net weight	Dimensions (HxLxW in mm)
		With basic jaws	With extra jaws (included)		
120V 1200W low-speed motor	421FS15	Ø350 - Ø422	Ø212 - Ø352	186 kg	802x838x315
	521FS15	Ø450 - Ø522	Ø312 - Ø452	223 kg	905x889x315
	721FS15	Ø653 - Ø725	Ø447 - Ø654	256 kg	1104x1077x315
230V 1200W low-speed motor	421FS25	Ø350 - Ø422	Ø212 - Ø352	186 kg	802x838x315
	521FS25	Ø450 - Ø522	Ø312 - Ø452	223 kg	905x889x315
	721FS25	Ø653 - Ø725	Ø447 - Ø654	256 kg	1104x1077x315
Pneu- matic motor	421PD	Ø350 - Ø422	Ø212 - Ø352	186 kg	802x838x315
	521PD	Ø450 - Ø522	Ø312 - Ø452	223 kg	905x889x315
	721PD	Ø653 - Ø725	Ø447 - Ø654	256 kg	1104x1077x315
	1100	On request			



Orbital Cutting - Accessories

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

Our support legs and stands have been designed to further facilitate cutting by ensuring that the machine is stable in different conditions: in a workshop or on site.

The great advantages of these products:

- lightness
- flexible handling
- easy to use



Product Code	Description	Net Weight	Dimensions (in cm)
CCPS21	Support legs	10 kg	103 x 32 x 11

Support legs for orbital cutting machines:

- quick assembly and dismantling
- height adjustment with screws
- storage box at the back
- optimum stability

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in cm)
CCSER1	Stand	10 kg	60 x 26 x 10

Simple stand for supporting tubes with height adjustment:

- quick assembly and dismantling
- height adjustment

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in cm)
CCSER2	Stand (with chrome steel bearings)	11 kg	60 x 26 x 10

Stand with chrome steel bearings for supporting tubes with height adjustment:

- quick assembly and dismantling
- height adjustment
- facilitates tube feeding after each cut

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Join **experience**



Orbital Cutting - Accessories

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

Our support benches help you to position and feed your tubes without the aid of stands. The height-adjustable table helps you easily and precisely set the height of your machine, for cutting tubes placed on the support bench.

The additional tube support bench allows you to position your longest tubes in a stable manner on all benches.

We also recommend that you support the cut section in front of your cutting machine using one or more additional benches, depending on the length of the tube.



Product Code	Description	Net Weight	Dimensions (in cm)
CCBSB-X1	Bench with height adjustment	57 kg	184 x 95 x 51

Height-adjustable support bench, 1.5m

- stainless steel rollers
- handle for height adjustment
- 1.5 m long
- maximum load: 350 kg
- ø min pipe: 5 mm
- ø max pipe: 321 mm
- compatible with machines 121 to 321

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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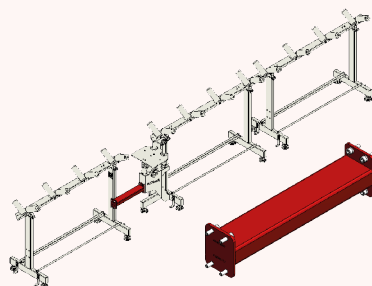


Product Code	Description	Net weight	Dimensions (in cm)
CCBSB-X2	Additional support bench	38 kg	150 x 95 x 51

Additional tube support bench:

- stainless steel rollers
- 1.5 m long
- maximum load 350 kg uniformly distributed
- min tube ø: 5 mm
- max tube ø: 321 mm
- compatible with machines 121 to 321

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in mm)
CCBSB-B005	Connecting bar	3 kg	100 x 80 x 402

Connecting bar for CCBSB-X1 and CCBSB- X2:

- Allows the height-adjustable table to be connected to a bench placed in front of the machine

✓ 122	✓ 172	✓ 222	✓ 322	421	521	721	1100
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Orbital cutting - Accessories (End stop)

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

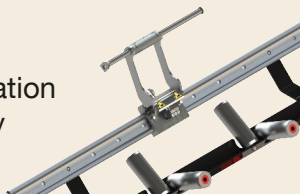
In addition to our CCBB-X1 and CCBB-X2 benches, we offer benches with an end stop system. These stops are very simple to use and avoid all measurement errors.

No pollution of the tube:

All parts that are in contact with the tube are made of stainless steel (the rollers but also the stop finger)

Retractable stop:

In order to facilitate the evacuation of the cut, the stop is manually retractable.



- Lengths available:
1500 - 3000 - 4500 - 6000 - 7500 and 9000 mm
- Working stroke: Length - 200 mm
- Delivered by module of 1500mm to be put together
- Max load per module: 350 kg (evenly distributed)
- Max push on the stop: 10 kg
- Operating temperature: 0 - 50 ° C
- Relative humidity: 35 - 85%

They can be assembled on the **feed-in or feed-out** section of the cutting machine

They are available **with a ruler or with an LCD display.**

Feed-in assembly



Feed-out assembly



LCD display

Possibility of selecting the direction of counting, the position of the decimal point, the unit of measurement (mm or inches), reset / preset of the measurement, absolute / relative dimension.

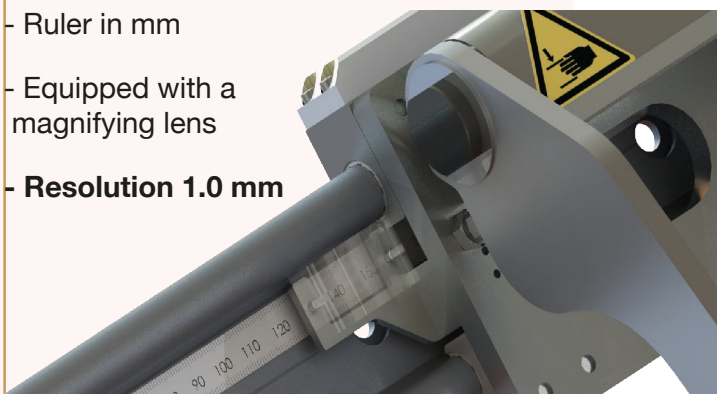
- Battery powered. Lifetime of about 4 years. The discharged battery icon appears when battery replacement is required. Replacement is easily done without loss of the value and configuration parameters.



- Resolution 0.1 mm

Ruler

- Ruler in mm
- Equipped with a magnifying lens
- Resolution 1.0 mm



✓ 122

✓ 172

✓ 222

✓ 322

421

521

721

1100



Orbital cutting - Accessories (End stop)

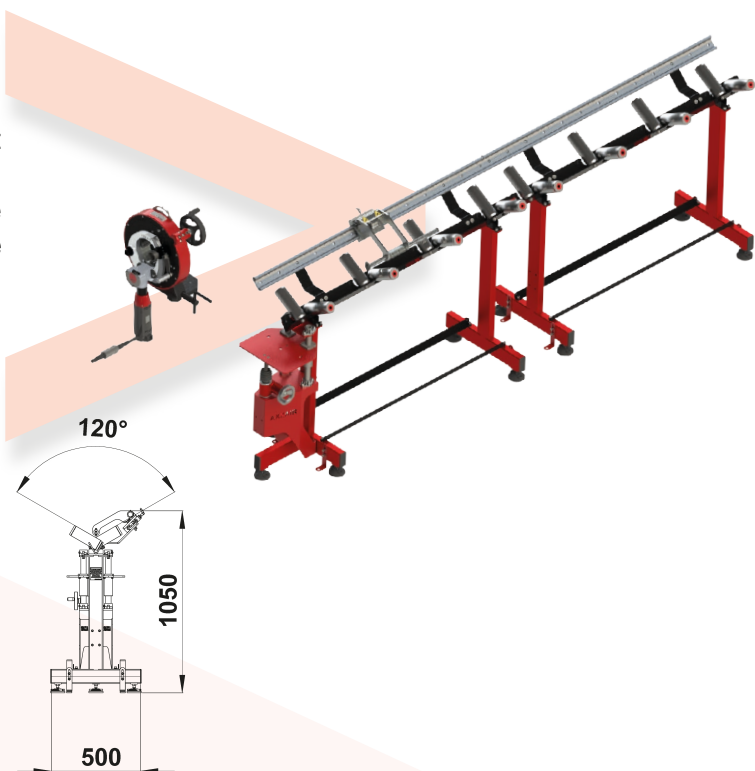
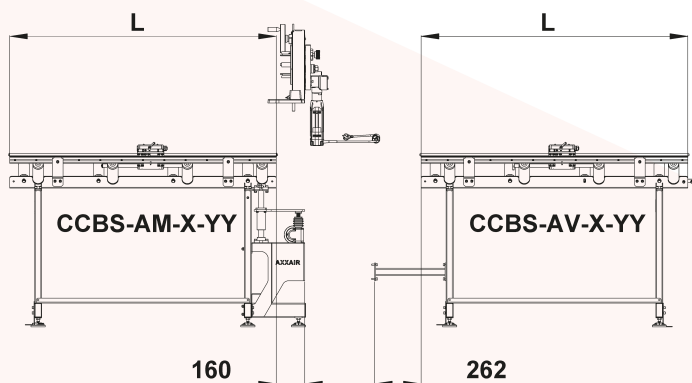
AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

Feed-in assembly

The parts are delivered unassembled in transport boxes, per module of 1,5 m.

They must be assembled, aligned and fixed to the ground. The magnetic ruler (with LDC display) or the ruler must be glued at the end of the assembly.



The system is delivered with the height-adjustable support bench (CCBSB-X1), additional support benches, the starting end stop module and its extensions.

Assembly	Reader	Length (in mm)	Working stroke (in mm)	Product code	Net weight		
on the feed-in section of the cutting line	Ruler	1500	1300	CCBSB-AM-R-15	65 kg		
		3000	2800	CCBSB-AM-R-30	104 kg		
		4500	4300	CCBSB-AM-R-45	143 kg		
		6000	5800	CCBSB-AM-R-60	163 kg		
		7500	7300	CCBSB-AM-R-75	200 kg		
		9000	8800	CCBSB-AM-R-90	238 kg		
	LCD display	1500	1300	CCBSB-AM-D-15	65 kg		
		3000	2800	CCBSB-AM-D-30	104 kg		
		4500	4300	CCBSB-AM-D-45	143 kg		
		6000	5800	CCBSB-AM-D-60	163 kg		
		7500	7300	CCBSB-AM-D-75	200 kg		
		9000	8800	CCBSB-AM-D-90	238 kg		
✓122	✓172	✓222	✓322	421	521	721	1100

You can add CCBSB-X2 modules to support the tube after the cutting process (in front of the cutting machine) with the CCBSB-B005 connecting bar (see previous pages).



Join experience

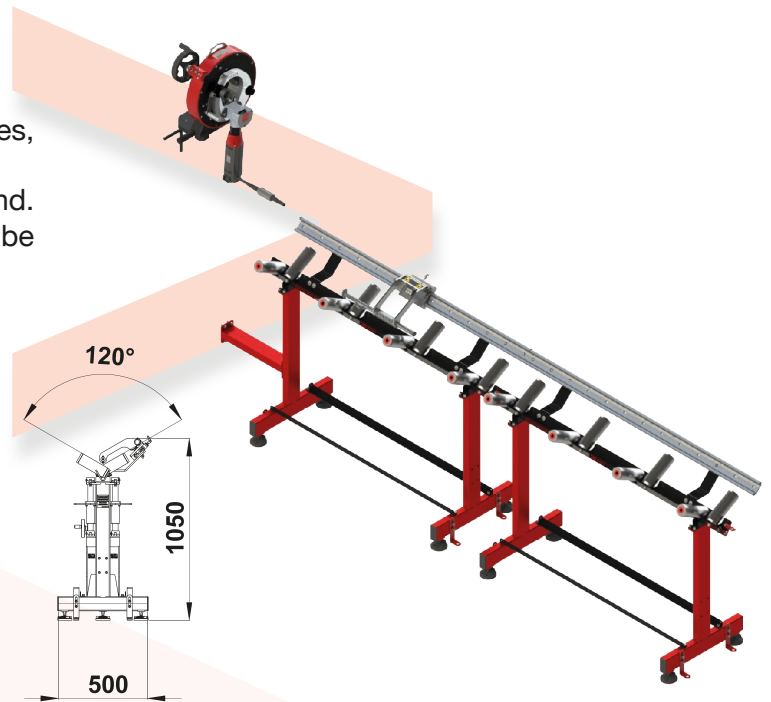
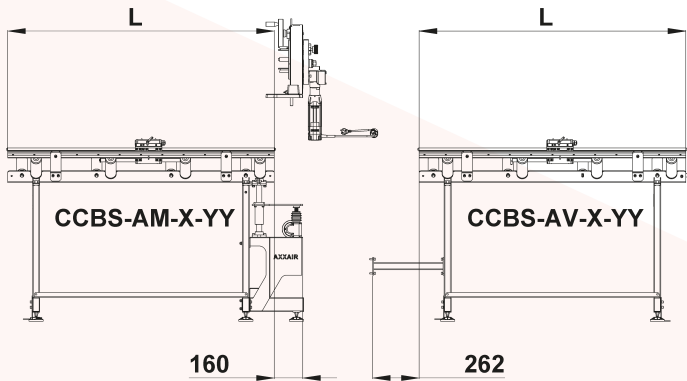


Orbital cutting - Accessories (End stop)



Feed-out assembly

The parts are delivered unassembled in transport boxes, per module of 1,5 m.
They must be assembled, aligned and fixed to the ground.
The magnetic ruler (with LDC display) or the ruler must be glued at the end of the assembly.



The system comes with: CCBSB-X2 support bench modules, the starting end stop module and its extensions, the CCBSB-B005 connecting bar.

Attention: For all references with AV (bench with end stop on the feed-out section) we must also deliver at least one CCBSB-X1 bench (height-adjustable support bench) to support the cutting machine.

Assembly	Reader	Length (in mm)	Working stroke (in mm)	Product code	Net weight		
on the feed-out section of the cutting line	Ruler	1500	1300	CCBSB-AV-R-15	46 kg		
		3000	2800	CCBSB-AV-R-30	85 kg		
		4500	4300	CCBSB-AV-R-45	124 kg		
		6000	5800	CCBSB-AV-R-60	163 kg		
		7500	7300	CCBSB-AV-R-75	201 kg		
		9000	8800	CCBSB-AV-R-90	240 kg		
	LCD display	1500	1300	CCBSB-AV-D-15	46 kg		
		3000	2800	CCBSB-AV-D-30	85 kg		
		4500	4300	CCBSB-AV-D-45	124 kg		
		6000	5800	CCBSB-AV-D-60	163 kg		
		7500	7300	CCBSB-AV-D-75	201 kg		
		9000	8800	CCBSB-AV-D-90	240 kg		
✓122	✓172	✓222	✓322	421	521	721	1100



Orbital Cutting - Accessories

AXXAIR

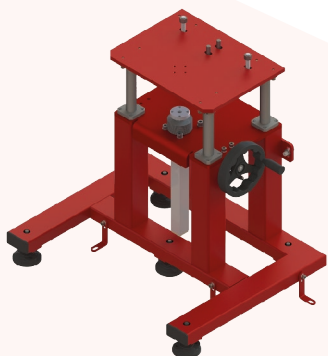
INNOVATIVE ORBITAL SOLUTIONS

Our support benches help you to position and feed your tubes without the aid of stands. The height-adjustable table helps you easily and precisely set the height of your machine, for cutting tubes placed on the support bench.

The additional tube support bench allows you to position your longest tubes in a stable manner on all benches.

We also recommend that you support the cut section in front of your cutting machine using one or more additional benches, depending on the length of the tube.

These products are available on request



Product Code	Description	Net weight	Dimensions
CCBSB2-003	Height-adjustable table	53.5 kg	75 x 73 x 54 mm

Height-adjustable table for 422 / 521 / 721:

- adjustable table height
- optimum stability

122	172	222	322	✓421	✓521	✓721	1100
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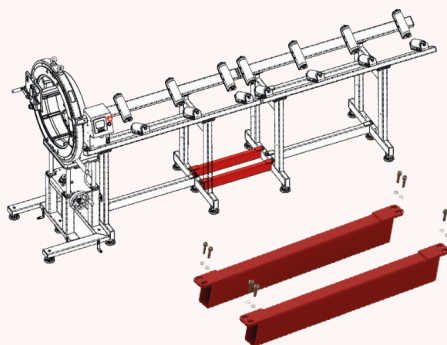


Product Code	Description	Net Weight	Dimensions
CCBSB2-004	Tube support bench	72.8 kg	97 x 71 x 150 mm

Tube support bench for 422 / 521 / 721:

- quick assembly and dismantling
- height adjustment
- 1.5 m long
- optimum stability

122	172	222	322	✓421	✓521	✓721	1100
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Product Code	Description	Net weight	Dimensions
CCBSB2-005	Connecting bar	6.5 kg	8.5 x 4 x 65 mm

Connecting bar between two CCBSB2 support benches:

- quick assembly and dismantling
- ensures optimum stability

122	172	222	322	✓421	✓521	✓721	1100
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Orbital Cutting - Accessories

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

New autoline electric rotation:

Measures and displays the cutting/bevelling motor's power consumption

- enables the motor and cycle to be stopped in the event of overconsumption
- protects the motor and frees the operator from watching the machine
- detects whether the motor is straining and whether the blade is worn

3.5 colour touch-screen allowing you to:

- enter the diameter and precisely adjust the feed speed in mm/min
- aid adjustment with a suggested motor speed and feed speed based on the type of material and the blade used
- perform quick and easy configuration
- display the cutting/bevelling motor's consumption
- display in English, French or German
- choose the unit of measure: mm or inch

Welding mode with prefab machine and SAXX generator: 4-button display (Start, Stop, Left, Right) with the addition of a power source connection cable

(Ref. SAEX-A02 for addition, more details in the "ORBITAL WELDING" section of the catalogue)

This rotation is compatible with our previous **121, 171, 221, 321, 421, 521 and 721** models.

The previous SAEP-00/000 rotation cannot be fitted to our new **122, 172, 222 and 322** models.



Product Code	Description	Net Weight	Dimensions(in mm)
SAEX-00	Autoline electric rotation	6.3 kg	320 x 261x 193

Autoline electric inverter for CC122 to 322:

- 110 V to 230 V
- even rotation
- easy to use
- precise adjustment

✓122	✓172	✓222	✓322	421	521	721	1100
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Product Code	Description	Net Weight	Dimensions (in mm)
SAEX-000	Autoline electric rotation	6.3 kg	320 x 261x 193

Autoline electric inverter for CC421 to 721:

- 110 V to 230 V
- even rotation
- easy to use
- precise adjustment

122	172	222	322	✓421	✓521	✓721	1100
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Join **experience**



Orbital Cutting - Consumables

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS



Orbital cutting blades

High quality blades (HSS + Cobalt) sold in boxes of 5

-The tooth pitch & design are essential for chip evacuation, in order to achieve a high quality cut. AXXAIR has produced the most efficient blade design possible for various cutting applications.

-Often preferred to our competitors' blades, AXXAIR blades are compatible with the majority of other orbital cutting machines.

Product Code	Cutting tubes with wall thicknesses of		Blade ø	Number of teeth
LS6844	2 to 7mm	0.08 – 0.28"	68 mm	44
LS8034	5 to 12 mm	0.20 – 0.47"	80 mm	34
LS8054	2 to 7 mm	0.08 – 0.28"	80 mm	54
LS9038	5 to 15 mm	0.20 – 0.59"	90 mm	38
LCA9028A (sold individually)	4 to 15 mm	0.15 – 0.59"	90 mm	28
For cutting carbon steel ONLY and ONLY with a FS29/ FS19 high-speed motor. Cutting is performed WITHOUT lubricant.				
LC300 (sold individually)	30 ° bevelling blade		78 mm	20
LC375 (sold individually)	37.5 ° bevelling blade		78 mm	20

✓ 122

✓ 172

✓ 222

✓ 322

✓ 422

✓ 521

✓ 721

✓ 1100



Product Code	Description	Volume
CCLUH	liquid lubricant	250 ml

High performance oil lubricant, sold in packs of 5:

- Recommended for all FS cutting motors
- Safety data sheet available on request

✓ 122

✓ 172

✓ 222

✓ 322

✓ 422

✓ 521

✓ 721

✓ 1100



1 machine - 3 applications

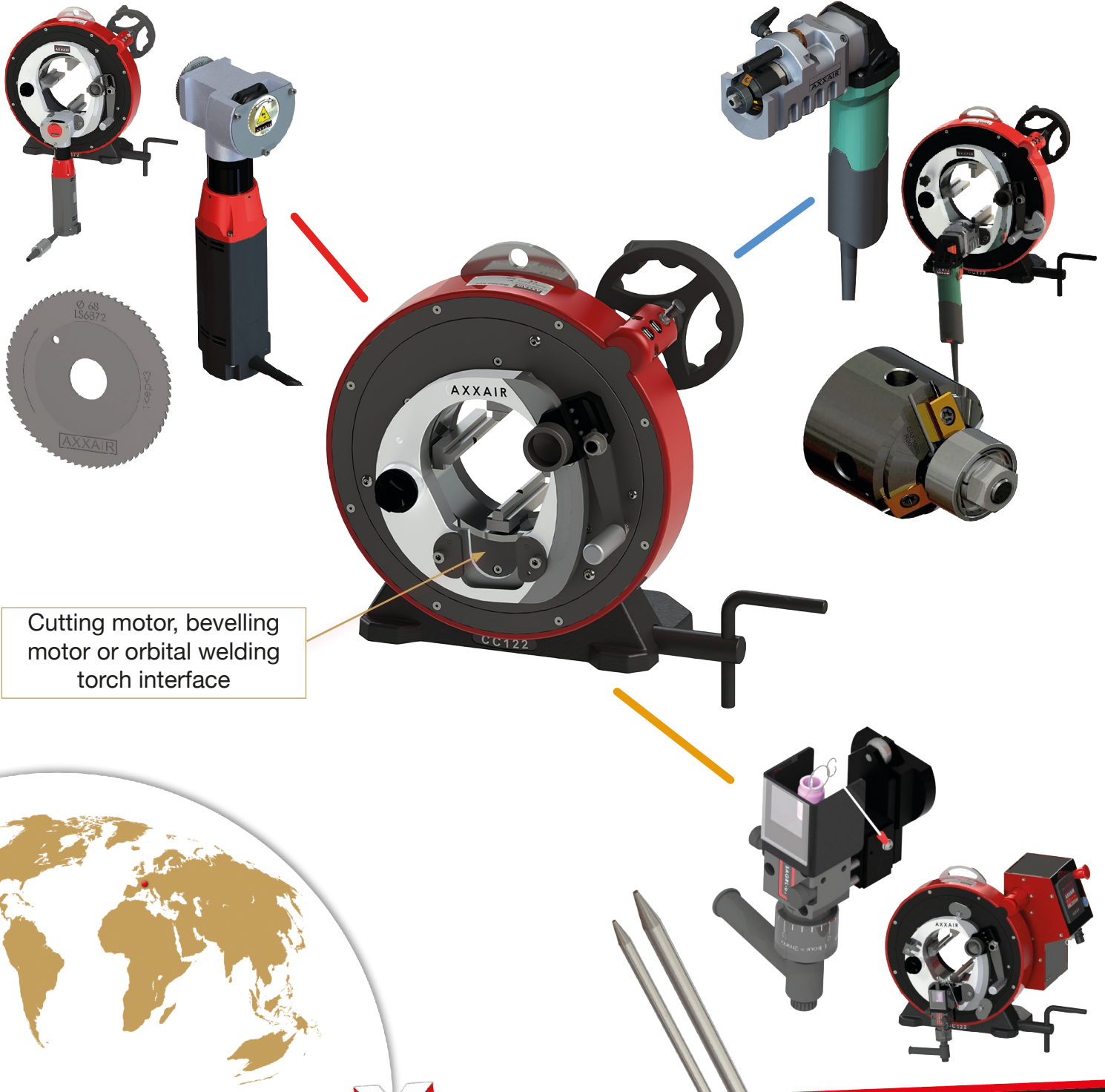
AXXAIR
INNOVATIVE ORBITAL SOLUTIONS

The AXXAIR Group was the first to offer a triple and exclusive solution, from preparation to orbital welding:

the global process

For more than 20 years, a single machine frame (122, 172, 222 and 322) has enabled three operations to be carried out:

Cutting, bevelling and orbital welding



Cutting motor, bevelling motor or orbital welding torch interface

AXXAIR

INNOVATIVE ORBITAL SOLUTIONS

Accessories (electric clamping)

NEW



You realize **important series** in your company and want to be more effective during your projects? Our electric clamping is the ideal answer for the preparation and / or welding of your tubes.

The electric clamping makes it possible to carry out a **repetitive and constant force tightening** on tubes with identical diameters and thicknesses.

The **clamping force is adjustable**, it prevents the tubes from being deformed or marked.

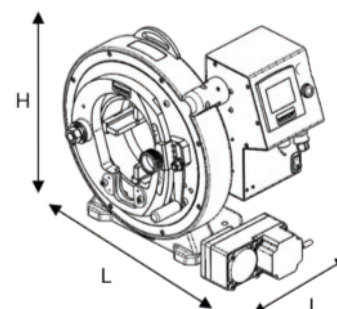
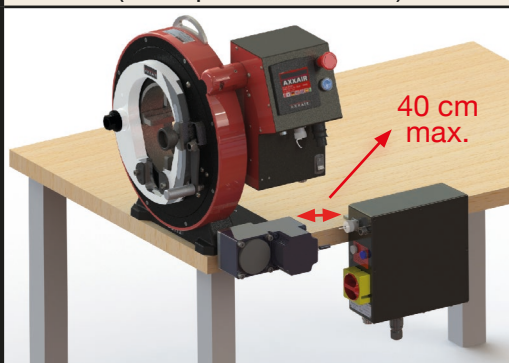
Technical specifications:

- 24Vdc brushless motor, motor torque: 34N.m
- Tightening force on the tube: 850 kg maximum, adjustable from 15 to 100%
- Clamping speed: 86 mm / min (diameter)
- The electric clamping is sold with the body frame and the automatic rotation

Fixation on an AXXAIR support bench



Fixation on an other support (example: workbench)



Product code	Body frame, automatic rotation and electric clamping		Net weight	Dimensions (HxLxl in mm)
	Machine's jaw opening capacity in mm			
	With basic jaws	With extra jaws (included)		
122-AU	Ø29 - Ø119	Ø5 - Ø99	51 kg	470 x 498 x 359
172-AU	Ø74 - Ø173	Ø16 - Ø116	58 kg	520 x 530 x 359
222-AU	Ø128 - Ø228	Ø55 - Ø155	66 kg	575 x 575 x 359
322-AU	Ø230 - Ø328	Ø141 - Ø239	80 kg	675 x 662 x 359

Caution: Remember to order one or more motors (cutting, bevelling or welding torch) and the consumables needed with the sets listed above.



Join **experience**



1 machine - 3 applications



Product Code	Description	Net weight
FS xx / MOPD	Cutting motor	5 kg
Low-speed / high-speed / pneumatic motor with dual output (uptake):		
120V	Low-speed motor: FS15	122
	High-speed motor: FS19	
230V	Low-speed motor: FS25	222
	High-speed motor: FS29	
Pneumatic	MOPD	322

To use this motor you will need to order: suitable cutting blades for the tube thickness you want to cut and, if necessary, lubricant.

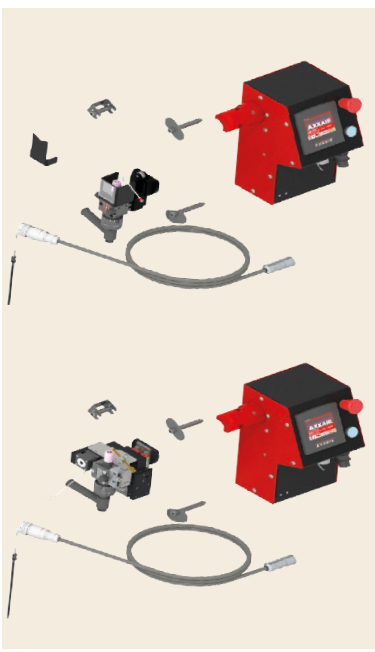
All information and relevant product codes appear in the orbital cutting accessories and consumables section of this catalogue.



Product Code	Description	Net Weight			
GA10 - x - xx	Beveling motor kit	5 kg			
120V / 230V beveling motor supplied with a chip shield and a workpiece guide tailored to the frame of your cutting / prefab welding machine:					
120V	Product Code	Frame	230V	Product Code	Frame
	GA10-M1-122	122		GA10-M2-122	122
	GA10-M1-172	172		GA10-M2-172	172
	GA10-M1-222	222		GA10-M2-222	222
	GA10-M1-322	322		GA10-M2-322	322

To use this motor and bevel your tubes you will need to order: one or more milling heads and carbide inserts.

All information and relevant product codes appear in the orbital beveling accessories and consumables section of this catalogue.



Product Code	Description	Net Weight
SX - KIT x	Torch kit	depending on the chosen product
KIT for upgrading a CC/GA to an SX Air / Water / AVC+OSC torch		
Cooling	Product Code	Frame
AIR	SX-2KITA	122
EAU	SX-2KITE	172
	SX-2KITNAOF (AVC/OSC)	222
		322
If you have acquired the electrical clamping (xx2-AU), please order the references below, they are delivered without automatic rotation:		
AIR	SX-3KITA	122
EAU	SX-3KITE	172
	SX-3KITNAOF (AVC/OSC)	222
		322

To use this KIT and to prefab weld, you will need to order: a suitable AXXAIR welding power supply for the tubes you want to weld.

All information and relevant product codes appear in the orbital welding section of this catalogue.

