

Internal Debeading Tools



Cutting Head Assembly



Rod Spacers to Ensure Concentricity



Drive Handle



Supports



Universal Joints & Couplings

Internal Debeading Tools are used to remove the inner weld beads in PE pipes that are formed by the Butt Fusion process.

The tool is manually powered with a Drive Handle, it has proven to be very durable and reliable and is mainly constructed from stainless steel and aluminium. From the standard range, there are 5 x different sizes of Cutter Heads to cover pipe outside diameters from 90 – 450mm. The Rods are available separately and the system allows a maximum insertion depth of 24 metres.

Larger Internal Debeaders can also be offered for pipe sizes 500 – 900mm, whilst a smaller 32 – 75mm unit is also available for service pipe diameters.

Very large electrical Debeaders can also be offered for pipe sizes 800mm and above. These units require consultation with our design team to agree specification and optimal design.

Internal Debeaders for PE Pipes OD 90 – 450mm

Product Code	Description	Outside Diameter	Inside Diameter
700-000165	Internal Debeader Cutter Heads	90 – 110mm	70 – 105mm
700-000166	+ 2 x Supports	125 – 160mm	105 – 145mm
700-000167	Stainless Steel construction	160 – 200mm	123 – 190mm
700-000168	(Rods not included)	225 – 280mm	178 – 266mm
700-000169		315 – 450mm	265 – 420mm
700-000170	Rod Set (13 meters total). Set of, 6 x 2m and 1 x 1m C/w stainless steel drive handle and universal joints and couplings		
700-000171	Rods 2m incl. joints (up to 24m max)		
700-000172	Cutting blades 90 – 110mm		
700-000173	Cutting Blades 125 – 200mm		
700-000174	Cutting Blades 225 – 450mm		
700-000205	Large Diameter Internal Debeader	500 – 630mm	410-610mm
700-000206	Cutter Heads + 2 x Supports Stainless Steel construction (Rods not included)	710 – 900mm	610 – 840mm
700-000207	Rod set for Internal Debeaders (500mm+), complete with up to 13 meters insertion depth.		
700-000208	Rod (3m) incl joints, for Internal Debeader. Aluminium		
700-000209	Internal Debeader Blade 500-900mm		

Selection Table for correct Cutter Head based on PE Pipe OD/SDR and ID

OD	6	7,4	9	11	17	17.6	21	26	SDR
90	60	66	70	74	79	80	81	83	Note that actual inside diameter in joint can be smaller than nominal due to deformation etc.
110	73	80	86	90	97	98	100	102	
125	83	91	97	102	110	111	113	115	
140	93	102	109	115	124	124	127	129	
160	107	117	124	131	141	142	145	148	
180	120	131	140	147	159	160	163	166	
200	133	146	156	164	176	177	181	185	
225	150	164	175	184	199	199	204	208	
250	167	182	194	205	221	222	226	231	
280	187	204	218	229	247	248	253	258	
315	210	230	245	258	278	279	285	291	
355	237	259	276	290	313	315	321	328	
400	267	292	311	327	353	355	362	369	
450	300	328	350	368	397	399	407	415	
500	333	365	389	409	441	443	452	462	
630	420	460	490	515	556	558	570	582	
710	473	518	552	581	626	629	642	655	
800	533	584	622	655	706	709	724	738	
900	600	657	700	736	794	798	814	831	

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