



“ROTHENBERGER Constant Force Technology (CFT®) guarantees a constant axial pressing force – an important prerequisite for manufacturing tightsealing pressing connections”



# Bonding

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# Bonding

## Expanding Manual

### ROCAM® EXPANDER Power Torque

For expanding, reducing and calibrating soft and semihard pipes Ø 8 - 42 mm (5/16 - 1.3/4"), as well as producing tapers



#### Product Profile

##### APPLICATION AREA

For efficient, fitting-free installation of pipes in sanitary heating, gas, refrigeration and air-conditioning systems

Suitable for pipes made of:

<b>Copper (soft and semi-hard):</b>	Ø 8 - 42 mm, 5/16 - 1.3/4" max. wall thickness 1.6 mm
<b>Aluminium (soft):</b>	Ø 8 - 28 mm, 5/16 - 1.1/8" max. wall thickness 1.6 mm
<b>Precision steel (soft):</b>	Ø 8 - 28 mm, 5/16 - 1.1/8" max. wall thickness 1.6 mm
<b>Stainless steel (soft):</b>	Ø 8 - 22 mm, 5/16 - 7/8" max. wall thickness 1.0 mm

##### KEY FEATURES

- Eliminates the cost of purchase and storage of fittings
- Converts deformed pipes into fittings; saves resources
- 50% reduction of labour, soldering materials, joints and energy
- Reliable pipe connection according to DVGW standards
- Tough, light and wear-resistant
- Fine adjustment of the capillary gap
- **EPT® – concealed bent lever**

#### Made in Germany!

The know-how from the pioneer of expanding technology and the leading manufacturer of expanding tools for over 40 years!

Expanding dimension and adjustment of capillary gap with the KSO fine adjustment screw



Long lever arms

Reduces effort required

Steel receptacle

Tough and wear-resistant

Extra long segments

Reliable pipe connection according to DVGW standards

Expanding

Up to 50% reduction in labour, soldering materials, joints and energy

High-performance, forged aluminium body

Light weight, optimal handling

Ergonomic handles

No slipping, no clamping

EPT®-Technology – concealed bent lever



ROCAM® EXPANDER Power Torque





No.



Expander tool (without expander heads) 1 1.0 12000  
for expander heads up to 42 mm / 1.3/4"

### ROCAM® EXPANDER Power Torque Sets

ROCAM® EXPANDER Power Torque sets include: Expander heads, ROCAM® EXPANDER Power Torque (No. 12000), internal and external deburrer (No. 11006), in a steel carrying case (No. 24022), plastic inlay (No. 11002)

ROCAM® EXPANDER Power Torque Sets			No.
Description			
12 - 15 - 18 - 22 mm	1	2.9	<b>12300</b>
10 - 12 - 15 - 18 - 22 mm	1	3.3	<b>12302</b>
12 - 15 - 18 - 22 - 28 mm	1	3.3	<b>12303</b>
10 - 12 - 16 - 18 - 22 mm	1	3.3	<b>12304</b>
10 - 12 - 16 - 22 - 28 mm	1	3.3	<b>12305</b>
12 - 14 - 16 - 18 - 22 mm	1	3.3	<b>12309</b>
12 - 14 - 16 - 18 - 22 - 28 mm	1	3.3	<b>12310</b>
10 - 12 - 14 - 16 - 18 - 22 mm	1	3.6	<b>12311</b>
3/8 - 1/2 - 5/8 - 3/4 - 1"	1	3.3	<b>12317</b>
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1.1/8"	1	3.6	<b>12318</b>
1/2 - 5/8 - 3/4 - 7/8"	1	2.9	<b>12321</b>
12 - 16 - 18 - 22 - 28 mm	1	3.2	<b>12322</b>
3/8 - 1/2 - 3/4 - 1"	1	3.2	<b>12323</b>
1/2 - 5/8 - 7/8 - 1.1/8"	1	3.0	<b>12324</b>
12 - 15 - 18 - 22 - 28 - 35 - 42 mm	1	4.2	<b>12326</b>
15 - 22 - 28 mm	1	2.9	<b>12327</b>
15 - 22 mm	1	2.5	<b>12328</b>
1/2 - 3/4 - 1"	1	2.9	<b>12335</b>
10 - 12 - 15 - 16 - 18 - 22 - 28 mm	1	3.6	<b>12337</b>
12 - 14 - 16 - 18 - 22 - 28 - 32 mm	1	3.7	<b>12338</b>
15 - 18 - 22 - 28 - 35 - 42 mm	1	4.0	<b>12339</b>



ROCAM® EXPANDER Power Torque Sets			No.
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1 - 1.1/8"	1	3.7	<b>12336</b>
3/8 - 1/2 - 5/8 - 3/4" - 22 - 28 mm	1	3.6	<b>12320</b>
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1.1/8 - 1.3/8"	1	4.5	<b>12341</b>

Quality protection against wear with the **TiN sealed pin drive**



For efficient, fitting-free installation of pipes



#### EPT®-Technology (Enclosed Power Transmission)

The expander head offers the following technical benefits:

##### Concealed bent lever:

Protection against dirt and external mechanical damage

##### Energy efficient through optimised force transmission:


Ergonomic, highly optimised force flow in relation to the hand force of the user, therefore reducing effort



### ROCAM® PE-X EXPANDER Power Torque

For expanding and calibrating PE-X and aluminium multi-layered composite pipe (MSR) up to Ø 42 mm or 1.3/4", as well as producing tapers

Expander heads coordinates with system pipes, for example the following systems: ROTEX, SCHELL, TECE / TECEflex, Vulkan-Lokring among others

Model		No.
ROCAM® EXPANDER PE-X without expander heads	1	<b>12005</b>



Article upon request\*

\* Feasibility, delivery times and price for custom pipe-Ø are available upon request

# Bonding

## Expanding Manual

### ROLOCK EXPANDER Power Torque

For expanding, reducing and calibrating soft and semi-hard pipes  $\varnothing$  8 - 42 mm (5/16 - 1.3/4"), as well as producing tapers



#### Product Profile

##### APPLICATION AREA

For efficient, fitting-free installation of pipes in sanitary heating, gas, refrigeration and air-conditioning systems

##### Suitable for pipes made of:

<b>Copper (soft and semi-hard):</b>	$\varnothing$ 8 - 42 mm, 5/16 - 1.3/4" max. wall thickness 1.6 mm
<b>Aluminium (soft):</b>	$\varnothing$ 8 - 28 mm, 5/16 - 1.1/8" max. wall thickness 1.6 mm
<b>Precision steel (soft):</b>	$\varnothing$ 8 - 28 mm, 5/16 - 1.1/8" max. wall thickness 1.6 mm
<b>Stainless steel (soft):</b>	$\varnothing$ 8 - 22 mm, 5/16 - 7/8" max. wall thickness 1.0 mm

##### KEY FEATURES

- Eliminates the cost of purchase and storage of fittings
- Converts deformed pipes into fittings; saves resources
- 50% reduction of labour, soldering materials, joints and energy
- Reliable pipe connection according to DVGW standards
- Tough, light and wear-resistant
- Fine adjustment of the capillary gap
- **EPT® – concealed bent lever**

#### Made in Germany!

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4



Toolless adjustment of expanding dimension and capillary gap

**Twist & lock system for screwable and twist-lock heads**

Long lever arms

Reduces effort required



Expanding

Up to 50% reduction in labour, soldering materials, joints and energy

Ergonomic handles

No slipping, no clamping



Steel receptacle

Twist and lock system  
Tough and wear-resistant

Extra long segments

Reliable pipe connection according to DVGW standards

High-performance, forged aluminium body

Light weight, optimal handling

ROLOCK EXPANDER Power Torque



No.

Expander tool (without expander heads) for expander heads up to 42 mm / 1.3/4"	1	1.0	12400
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### ROLOCK EXPANDER Power Torque Sets

ROLOCK EXPANDER Power Torque Sets include: Expander heads, ROLOCK EXPANDER Power Torque (No. 12400), internal and external deburrer (No. 11006), in a steel carrying case (No. 24022), plastic inlay (No. 11002)



New expander head for guide change between nominal diameters



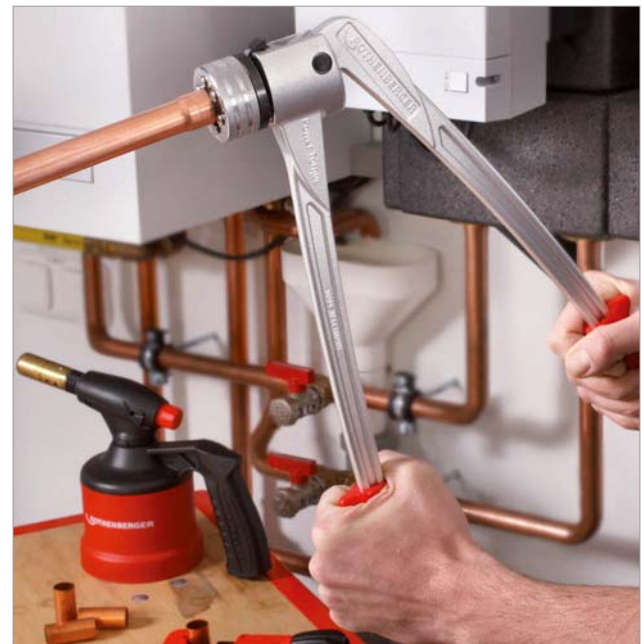
Expander heads with screw top applicable



#### ROLOCK EXPANDER Power Torque Sets

Description		kg	No.
12 - 15 - 18 - 22 mm	1	2.9	<b>12500</b>
12 - 15 - 18 - 22 - 28 mm	1	3.3	<b>12503</b>
10 - 12 - 16 - 22 - 28 mm	1	3.3	<b>12505</b>
12 - 14 - 16 - 18 - 22 mm	1	3.3	<b>12509</b>
10 - 12 - 14 - 16 - 18 - 22 mm	1	3.6	<b>12511</b>
10 - 12 - 15 - 16 - 18 - 22 - 28 mm	1	3.6	<b>12537</b>
12 - 14 - 16 - 18 - 22 - 28 - 32 mm	1	3.7	<b>12538</b>
3/8 - 1/2 - 5/8 - 3/4 - 1"	1	3.3	<b>12517</b>
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1.1/8"	1	3.6	<b>12518</b>
1/2 - 5/8 - 3/4 - 7/8"	1	2.9	<b>12521</b>
12 - 16 - 18 - 22 - 28 mm	1	3.2	<b>12522</b>
1/2 - 5/8 - 7/8 - 1.1/8"	1	3.0	<b>12524</b>
12 - 15 - 18 - 22 - 28 - 35 - 42 mm	1	4.2	<b>12526</b>
1/2 - 3/4 - 1"	1	2.9	<b>12535</b>
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1 - 1.1/8"	1	3.7	<b>12536</b>
3/8 - 1/2 - 5/8 - 3/4 - 7/8 - 1.1/8 - 1.3/8"	1	4.5	<b>12541</b>

For efficient, fitting-free installation of pipes



#### EPT®-Technology (Enclosed Power Transmission)

The expander head offers the following technical benefits:

##### Concealed bent lever:

Protection against dirt and external mechanical damage

##### Energy efficient through optimised force transmission:

Ergonomic, highly optimised force flow in relation to the hand force of the user, therefore reducing effort



#### ACCESSORIES



Description		Description	
Expander heads for ROLOCK EXPANDER Power Torque	<b>81</b>	Expander adaptor type S	<b>83</b>
Expander heads type S / riveted expander heads	<b>83</b>	Brazing solder	<b>169 - 171</b>
Pipe cutter	<b>10 - 21</b>	High-Performance torch (SUPER FIRE 3 with MAPP®-GAS)	<b>138 - 139</b>
Internal / External deburrer	<b>27</b>		

# Bonding

## Expanding Manual

### Standard Expander Head

For producing standard precision flares  $\varnothing 8 - 42 \text{ mm}$  (5/16 - 1.3/4") according to DVGW standards; as well as the specifications for the Gas de France

#### Product Profile

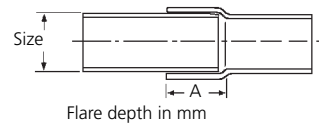
##### KEY FEATURES

- 50% reduction in labour, soldering materials and soldered joints
- Depth of the flare is consistent with DVGW standards
- Guide guarantees a perfect centred position and uniform capillary gap
- Tough and long lasting with the hardened segments

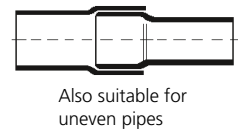
### Made in Germany!

The know-how from the pioneer of expanding technology and the leading manufacturer of expanding tools for over 40 years!

Expansion of pipe ends



Reduction



4



Fits similar expanders from other brands as well!

#### Specially hardened segments

Tough and long lasting

#### 6 Rivets and guide channels

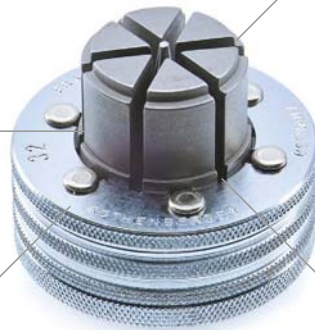
Guide guarantees a perfect centred position and uniform capillary gap

#### Step at the end of the segments

Enables re-calibration of irregular pipes and fittings

#### Extra long segments

Depth of the flare is consistent with DVGW standards



mm	Wall thickness mm				A mm	g	No.
	Cu	Al	Fe	Inox			
8	1.0	1.0	1.0	1.0	6.0	120	11008
10	1.0	1.0	1.0	1.0	10.0	120	11010
12	1.2	1.2	1.2	1.0	12.6	120	11012
14	1.2	1.2	1.2	1.0	12.6	120	11014
15	1.2	1.2	1.2	1.0	15.5	120	11015
16	1.2	1.2	1.2	1.0	15.5	120	11016
18	1.2	1.2	1.2	1.0	17.5	120	11018
20	1.2	1.2	1.2	1.0	17.5	140	11020
22	1.2	1.5	1.5	1.0	20.5	140	11022
28	1.5	1.5	1.5	-	18.5	390	11028
32	1.5	-	-	-	19.5	410	11032
35	1.6	-	-	-	19.5	430	11035
38	1.6	-	-	-	19.5	450	11038
40	1.5	-	-	-	19.5	470	11040
42	1.5	-	-	-	19.5	470	11042

inch	Wall thickness mm				A mm	g	No.
	Cu	Al	Fe	Inox			
5/16"	1.0	1.0	1.0	1.0	6.0	120	11008
3/8"	1.0	1.0	1.0	1.0	7.4	120	11052
1/2"	1.2	1.2	1.2	1.0	11.0	120	11053
5/8"	1.2	1.2	1.2	1.0	14.0	120	11054
3/4"	1.2	1.2	1.2	1.0	18.1	120	11055
7/8"	1.2	1.2	1.2	1.0	18.0	140	11056
1"	1.5	1.5	1.5	-	15.8	150	11057
1.1/8"	1.6	1.6	1.6	-	17.0	390	11058
1.1/4"	1.6	-	-	-	17.0	410	11059
1.3/8"	1.6	-	-	-	17.0	430	11035
1.1/2"	1.6	-	-	-	17.0	450	11038
1.5/8"	1.6	-	-	-	17.5	470	11062
1.3/4"	1.6	-	-	-	17.5	500	11063

Availability, delivery time and price of custom products for other pipe diameters available upon request

### Suitable for ROTHENBERGER Expander



Model		Model	
ROCAM® EXPANDER Power Torque	76	Electro-Hydraulic Expander Pistol H 2	88
ROMAX® EXPANDER Compact	85 - 86	COMBI KIT Expander / Tee-Extractor	90
Electro-Hydraulic Expander Pistol H 1	88		

### ROLOCK Expander Head

For producing standard precision flares  $\varnothing$  8 - 42 mm (5/16 - 1.3/4") according to DVGW standards; as well as the specifications for the Gas de France

#### Product Profile

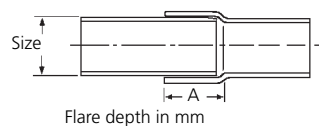
##### KEY FEATURES

- 50% reduction in labour, soldering materials and soldered joints
- Depth of the flare is consistent with DVGW standards
- Guide guarantees a perfect centred position and uniform capillary gap
- Tough and long lasting with the hardened segments

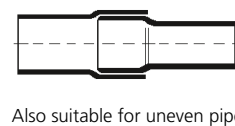
#### Made in Germany!

The know-how from the pioneer of expanding technology and the leading manufacturer of expanding tools for over 40 years!

Expansion of pipe ends



Reduction



Twist & lock heads for ROLOCK EXPANDER Power Torque

#### Specially hardened segments

Tough and long lasting

#### 6 Rivets and guide channels

Guide guarantees a perfect centred position and uniform capillary gap

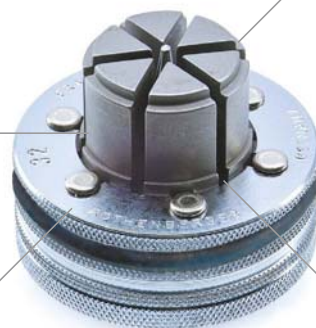
#### Step at the end of the segments

Enables re-calibration of irregular pipes and fittings



#### Extra long segments

Depth of the flare is consistent with DVGW standards



mm	Wall thickness mm				A mm	g	No.
	Cu	Al	Fe	Inox			
8	1.0	1.0	1.0	1.0	6.0	120	<b>12408</b>
10	1.0	1.0	1.0	1.0	10.0	120	<b>12410</b>
12	1.2	1.2	1.2	1.0	12.6	120	<b>12412</b>
14	1.2	1.2	1.2	1.0	12.6	120	<b>12414</b>
15	1.2	1.2	1.2	1.0	15.5	120	<b>12415</b>
16	1.2	1.2	1.2	1.0	15.5	120	<b>12416</b>
18	1.2	1.2	1.2	1.0	17.5	120	<b>12418</b>
20	1.2	1.2	1.2	1.0	17.5	140	<b>12420</b>
22	1.2	1.5	1.5	1.0	20.5	140	<b>12422</b>
28	1.5	1.5	1.5	-	18.5	390	<b>12428</b>
32	1.5	-	-	-	19.5	410	<b>12432</b>
35	1.6	-	-	-	19.5	430	<b>12435</b>
38	1.6	-	-	-	19.5	450	<b>12438</b>
40	1.5	-	-	-	19.5	470	<b>12440</b>
42	1.5	-	-	-	19.5	470	<b>12442</b>

inch	Wall thickness mm				A mm	g	No.
	Cu	Al	Fe	Inox			
5/16"	1.0	1.0	1.0	1.0	6.0	120	<b>12408</b>
3/8"	1.0	1.0	1.0	1.0	7.4	120	<b>12452</b>
1/2"	1.2	1.2	1.2	1.0	11.0	120	<b>12453</b>
5/8"	1.2	1.2	1.2	1.0	14.0	120	<b>12454</b>
3/4"	1.2	1.2	1.2	1.0	18.1	120	<b>12455</b>
7/8"	1.2	1.2	1.2	1.0	18.0	140	<b>12456</b>
1"	1.5	1.5	1.5	-	15.8	150	<b>12457</b>
1.1/8"	1.6	1.6	1.6	-	17.0	390	<b>12458</b>
1.1/4"	1.6	-	-	-	17.0	410	<b>12459</b>
1.3/8"	1.6	-	-	-	17.0	430	<b>12435</b>
1.1/2"	1.6	-	-	-	17.0	450	<b>12438</b>
1.5/8"	1.6	-	-	-	17.5	470	<b>12462</b>
1.3/4"	1.6	-	-	-	17.5	500	<b>12463</b>

Availability, delivery time and price of custom products for other pipe diameters available upon request

#### Suitable for ROTHENBERGER ROLOCK EXPANDER Power Torque

Model



Model



ROLOCK EXPANDER Power Torque

78

COMBI KIT Expander / Tee-Extractor

90





# Bonding

## Expanding Manual

### EXPANDER A0

For expanding, reducing and calibrating thick walled pipes  $\varnothing$  22 - 67 mm (1 - 2.1/2") as well as the production of tapers

#### Product Profile

##### APPLICATION AREA

For efficient, fitting-free installation of pipes in sanitary heating, gas, refrigeration and air-conditioning systems

Suitable for pipes made of:

**Copper and Aluminium:**  $\varnothing$  22 - 67 mm, 1 - 2.1/2"  
max. wall thickness 2.5 mm  
**Precision steel (soft):**  $\varnothing$  22 - 54 mm, 1 - 2.1/8"  
max. wall thickness 1.5 mm  
**and Stainless steel per DVGW-GW541**

#### Functional Elements:

Expander A0 with a tightly guided and reinforced, long expander head, matches to the expander head Type S!

#### KEY FEATURES

- Application and savings advantages similar to ROCAM® EXPANDER power torque
- Precise and exact flaring
- Full bearing of the expander head segments allows heavy loads
- Continuous adjustment of the socket size and capillary gap
- Optimized action principle with long handles

4



#### Strong pin guide

Full bearing of the expander head segments allow heavy loads

#### Reinforced expander head casing

Precise and exact flaring

EXPANDER A0 sets (No. 11400) include: Expander head Type S, special ratchet (No. 27181), in steel case (No. 27210)

EXPANDER A0 Basic Unit (No. 11004) scope of delivery: Square drive mechanism 3/4" with handle, without expander head and ratchet

Model	Size	kg	No.
EXPANDER A0 set	35 - 42 - 54 - 64 mm	8.12	11400
EXPANDER A0 basic unit		1.97	11004

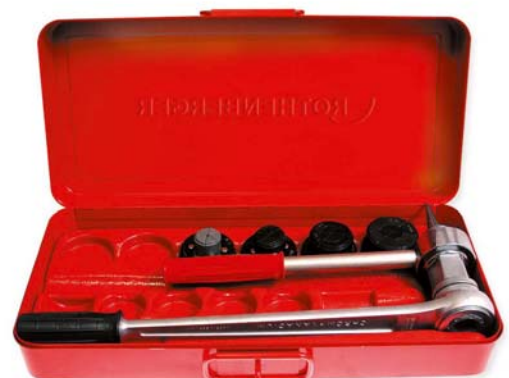
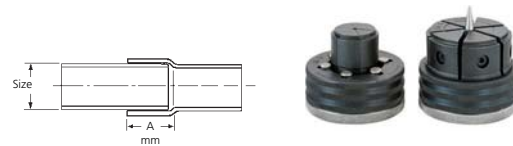


Fig. EXPANDER A0 Set

### Expander Head Type S

For the precise expansion of normal and thick walled pipes Ø 22 - 67 mm (1 - 2.1/2") and 2.5 mm wall thickness



Accurate guidance of the segments through the reinforced expander head casing

mm	max. Wall thickness				A - size mm	g	No.
	Cu	Al	Fe	Inox			
22	2.0	2.0	1.5	1.5	18.5	350	<b>11323</b>
25	2.0	2.0	1.5	1.5	18.5	350	<b>11325</b>
28	2.0	2.0	1.5	1.5	19.5	360	<b>11328</b>
32	2.0	2.0	1.5	1.5	19.5	380	<b>11332</b>
34	2.0	2.0	1.5	1.5	19.5	400	<b>11334</b>
35	2.0	2.0	1.5	1.5	19.5	400	<b>11335</b>
36	2.0	2.0	1.5	1.5	19.5	400	<b>11336</b>
40	2.0	2.0	1.5	1.5	19.5	430	<b>11340</b>
42	2.0	2.0	1.5	1.5	19.5	450	<b>11342</b>
52	2.5	2.5	1.5	1.5	19.5	540	<b>11345</b>
54	2.5	2.5	1.5	1.5	19.5	570	<b>11346</b>
64	2.5	2.5	-	-	19.5	690	<b>11348</b>
67	2.5	2.5	-	-	19.5	730	<b>11380</b>

inch	max. Wall thickness				A - size mm	g	No.
	Cu	Al	Fe	Inox			
1"	2.0	2.0	1.5	1.5	18.5	350	<b>11376</b>
1.1/8"	2.0	2.0	1.5	1.5	19.5	360	<b>11358</b>
1.1/4"	2.0	2.0	1.5	1.5	19.5	380	<b>11332</b>
1.3/8"	2.0	2.0	1.5	1.5	19.5	400	<b>11335</b>
1.1/2"	2.0	2.0	1.5	1.5	19.5	430	<b>11338</b>
1.5/8"	2.0	2.0	1.5	1.5	19.5	450	<b>11362</b>
2"	2.0	2.0	1.5	1.5	17.0	540	<b>11364</b>
2.1/8"	2.5	2.5	1.5	1.5	17.0	570	<b>11346</b>
2.1/2"	2.5	2.5	-	-	17.0	690	<b>11348</b>

Availability, delivery time and price of custom products for other pipe diameters available on request

### Expander Adaptor Type S

To increase the application area of the ROCAM® EXPANDER Power Torque and Expander Pistol H1



Allows the use of the expander heads Type S with copper pipe (soft) up to 67 mm and/or 2.1/2"!

Model	max.	max. mm	g	No.
Adaptor Type S, without expander head	67 mm - 2.1/2"	2.0	630	<b>11007</b>

### Flanged Riveted Expander Heads

For use with the ROCAM® EXPANDER, ROCAM® EXPANDER Compact Standard and Expander Pistol H1



**Product Profile**

**KEY FEATURES**

For producing exact hose connections, for example vibrating power units in

- Air-conditioning technology
- Auto manufacturing
- Industrial applications

mm	mm	outer dia.- Flange mm	Distance Flange pipe end mm	g	No.
15	1,5	18	4	110	<b>11955</b>
18	1,5	21	4	110	<b>11958</b>
22	1,5	25	6	120	<b>11962</b>
28	1,5	31	6	370	<b>11968</b>
35	1,5	38	6	400	<b>11975</b>
38	1,5	41	6	430	<b>11978</b>

Availability, delivery time and price of custom products for other pipe diameters available on request



# Bonding

## Expanding Electric

### STEP Expander A1

For expanding, reducing and calibrating thick walled pipes, Ø 35 – 108 mm (1.3/8 - 4.1/8"), as well as the production of tapers



Fig. similar  
Special ratchet  
(No. 27181)

Scope of delivery: STEP Expander with handle,  
without special ratchet

Size	kg	No.
42 - 54 - 64 - 76,1 - 88,9 - 108 mm	4,2	<b>11086</b>
35 - 42 - 54 - 64 - 76 - 108 mm	3,9	<b>11087</b>
35 - 42 - 54 - 67 - 80 - 104 mm	3,9	<b>11089</b>
1.3/8 - 1.5/8 - 2.1/8 - 2.5/8 - 3.1/8 - 4.1/8"	4,2	<b>11078</b>
1.1/4 - 4"	3,8	<b>11093</b>

Availability, delivery time and price of custom products for other pipe diameters available on request

### Product Profile

#### APPLICATION AREA

For efficient, fitting-free installation of pipes in sanitary, heating, gas, refrigeration and air-conditioning systems

Suitable for pipes made of:

**Copper and aluminium:** Ø 35 - 108 mm, 1.3/8 - 4.1/8"  
**(soft)** max. wall thickness 2.5 mm

#### KEY FEATURES

- Affordable alternative when laying larger pipe dimensions with a considerable saving of soldering materials
- Expand without changing tools with the 6 size step Expander
- Full bearing of the expander head segments allows heavy loads
- Optimum adjustment of the socket size and capillary gap with the positive fine adjustment
- Optimised force transmission with the trapezoidal screw thread with self-lubricating bronze socket
- Guide guarantees a perfect centred position and uniform capillary gap with 6 rivets and guiding ridge

4



### ROMAX® EXPANDER AC ECO MAXI

Electro-hydraulic expander with constant axial thrust, 230 Volt connection. For expanding and calibrating pipes up to Ø 108 mm (4.1/8"), as well as producing reductions



Made in Germany

### Product Profile

#### APPLICATION AREA

Suitable for pipes made of:

**Copper (soft, semi-soft)** Ø 35 - 108 mm (1.3/8" - 4.1/8")  
**Aluminium:** max. wall thickness 2.5 mm

#### KEY FEATURES

- Optimally suited for batch production and large building sites
- Constant thrust with CFT®
- User safety with the easy to reach emergency stop switch

#### KEY FEATURES

- Long service life and high functional safety
- The expansion / calibration takes place after pressing and holding the switch
- Large working radius with the 5 m long cable

#### TECHNICAL DATA

**Weight:** ca. 13.7 kg  
**Motor:** 230 V / 50 Hz

#### Balanced weight distribution

Secure hold in every working position,  
ideal for one-handed use

#### Emergency stop switch

High user safety due to the interruption of the feed and the discharge of the expander head

#### Fully automatic expanding process

#### 6-fold step expander

Expands without changing tools from  
35 up to 108 mm (1.3/8 - 4.1/8")

#### 2. Switch directly within reach

Various holding positions possible, even  
in confined spaces (over head)

Article available upon request\*!



CFT®  
(Constant Force Technology)

For a constant axial thrust

\*Availability, delivery time and price of custom products for other pipe diameters available on request

### ROMAX® EXPANDER Compact

Compact, electro-hydraulic expander with a constant axial thrust of 19 kN and 12 Volt battery for portable operation, for expanding, reducing and calibrating pipes up to Ø 67 mm (2.1/2")



**Made in Germany!**

#### Product Profile

##### APPLICATION AREA

Suitable for pipes made of:

**Copper, aluminium (soft):** max. Ø 67 mm and/or 2.1/2"  
max. wall thickness 2 mm

**Aluminium and Precision steel (soft):** max. Ø 67 mm or 2.1/2"  
max. wall thickness 1 mm

**Stainless steel:** max. Ø 15 mm  
max. wall thickness 1 mm

##### KEY FEATURES

- Portable operation with the battery and AC adaptor (accessories)
- Increases the operating life of the expander head
- Constant axial thrust with CFT®

##### KEY FEATURES

- Accurate adjustment of the capillary gap
- Specially matched for expander heads Type Standard, Type S or PE-X for excellent expansion results
- User safety with the easy to reach emergency switch
- Reliable hold in any position

##### TECHNICAL DATA

<b>Dimensions:</b>	only 370 x 70 x 90 mm
<b>Weight:</b>	approx. 2.6 kg
<b>Power supply:</b>	Li-ion battery 14.4 V / 2.6 Ah Mains adaptor 230 V / 50-60 Hz 110 V on request
<b>Working temperature:</b>	-10° up to +60° C

**Aluminium and precision steel (soft)  
up to max. 1 mm wall thickness!**



**CFT® (Constant Force Technology)  
for a constant axial thrust**

Expansion up to Ø 67 mm (copper)  
on Ø 15 mm (stainless steel)

##### Internal piston block

Increases the operating life of the expander head, only the actual power needed is conveyed to the expander head



##### Li-ion technology

Up to 100% more expansions\*

##### Toolless KSO adjustment possible

Accurate adjustment of the capillary gap

##### Matched pin for each type of expander head

Specially matched for the Expander heads, Type Standard, Type S or PE-X for excellent expansion results

##### Balanced weight distribution

Reliable hold in any position, ideal for one-handed operation

##### Emergency stop switch

High user safety with the immediate halt of the feed and reduction of the expander head load

##### Battery operation

Portable operation with battery and AC adaptor (accessories)

##### High savings potential

- Efficient, fitting-free installation of pipes in sanitary, heating, gas, refrigeration and air-conditioning systems
- Eliminates the cost of purchase and storage of fittings
- 50% reduction of soldering materials and energy

##### All-round application

- Expander head receiver is compatible with ROTHENBERGER expander heads
- Choice between the expander head standard, Type S or PE-X

\* in comparison to ROTHENBERGER NiMh battery



# Bonding

## Expanding Electric

### ROMAX® EXPANDER Compact Basic Sets

5-part Basic Set I includes: ROMAX® EXPANDER Compact, 1 Li-ion battery 14.4 V / 2.6 Ah (No. 15418), quick-charger (No. 15017), in plastic carrying case (without expander heads)



All ROMAX® EXPANDER Compact with a Li-ion battery!

DUAL-POWER 14.4 or 230 Volt!

5 m cable length!

Large working radius



Fig. Power supply unit 230 V (accessory) with 5 m long cable (No. 15037)

Fig. Similar, ROMAX® EXPANDER Set Basic

Universal adaptor for  
ROTHENBERGER Expander Heads



Compatible with  
ROTHENBERGER Expander Heads



Workbench function  
with the stable surface support



Emergency stop switch



Description	Description	☐	⚖️ kg	No.
ROMAX® Expander Compact Basic Set I	expander heads standard	1	1.11	<b>15714</b>
ROMAX® Expander Compact Basic Set II	expander heads type S	1	1.11	<b>15715</b>
ROMAX® Expander Compact Basic Set III	expander heads type PE-X	1	1.11	<b>15716</b>

Expander heads / PE-X expander heads see 89

### ACCESSORIES



Description	No.	Description		No.
ROMAX® EXPANDER Compact replacement battery	<b>15418</b>	Internal / External deburrer	<b>27</b>	
ROMAX® EXPANDER Compact charger 230 V	<b>15017</b>	Brazing (SUPER FIRE 3 mit MAPP®-GAS)	<b>138 - 139</b>	
ROMAX® EXPANDER Compact power supply	<b>15037</b>	Brazing solder	<b>169 - 171</b>	
Pipecutter	<b>15016</b>	Plastic case with formed inlay		<b>015016L</b>

### Hydraulic Expander System H 600

For expanding, reducing and calibrating normal and thick walled pipes in batch production, as well as the production of tapers

Made in Germany!



#### Product Profile

##### APPLICATION AREA

Suitable for normal and thick walled pipes made of:  
**Copper and aluminium:** Ø 8 - 110 mm, 5/16 - 4.1/4" max. wall thickness 3.0 mm  
**Precision and stainless steel:** Ø 8 - 110 mm, 5/16 - 4.1/4" max. wall thickness 3.0 mm

##### KEY FEATURES

- Individual modular design
- Industrial quality expansions
- Proper and efficient handling of material

##### TECHNICAL DATA

**Rated power:** 1.2 kW  
**Rated current:** 2.1 A  
**Operating pressure:** 80 - 600 bar  
**Max. operating pressure:** 700 bar  
**Delivery capacity:** 0.82 l / min  
**Safety category:** IP 54  
**Actuation:** 400 V / 1200 W

4



**On-off switch with control light**

Allows set-up and auto-mode

**Continuous, accurate and adjustable operating power with set-up and auto-mode**

Allows proper, efficient handling of material

**Individual modular design**

Connections for safety foot pedal, control wires for the expander pistol H 1 and/or H 2, quick coupling for hydraulic hose

**Powerful 400 V / 1200 W drive**

Quick expansion of large, thick-walled pipes

**Suitable for all types of expander heads**

Multi-functional

**Fine adjustment of the tube socket size**

Industrial quality expansions

Scope of delivery (No. 13100) includes: Electro-Hydraulic Expander System H 600 complete with hydraulic unit H 600 (No. 13002), expander pistol H 1 (No. 12001), control cable, hydraulic hose 2.5 m with circuit points, adjusting tool, tool rack (No. 13023), safety foot pedal and hydraulic oil 1 l (No. 58185). (without expander heads)  
 Scope of delivery (No. 13002) includes: Electro-hydraulic unit H 600 with safety foot pedal, adjusting tool, tool rack (No. 13023), and hydraulic oil 1 l (No. 58185). (Without expander heads)

Model	kg	No.
Hydraulic System complete, without heads	36.0	<b>13100</b>
Hydraulic Tool H 600	33.1	<b>13002</b>
Foot pedal H 600 with 3 m cable	0.5	<b>12013</b>

# Bonding

## Expanding Hydraulic

### Electro-Hydraulic Expander Pistol H1

#### Product Profile

##### APPLICATION AREA

**Expander heads Standard:** Ø 8 - 42 mm, 5/16 - 1.3/4"  
up to 1.6 mm wall thickness

**Expander heads Type S  
(with adaptor No. 11007)** Ø 22 - 67 mm, 1 - 2.1/2"  
up to 2.5 mm wall thickness

Expander Pistol H  
(No. 12001)



Adaptor (No. 11007)

Scope of delivery: 2.5 m control cable (No. F88928), hydraulic hose (No. 12023), Adjusting tool (No. 12017), hydraulic oil 1 l (No. 58185)

4



Model	kg	No.
Electro-Hydraulic Expander Pistol H 1	2.9	<b>12001</b>
S-Head adaptor for H 1	0.6	<b>11007</b>
Adjusting tool for H 1	0.9	<b>12017</b>

### Electro-Hydraulic Expander Pistol H2

For use with Electro-Hydraulic Unit H 600

#### Product Profile

##### APPLICATION AREA

**Expander heads Type S:  
with adaptor (No. 12097)** Ø 22 - 67 mm, 1 - 2.1/2"  
up to 2.5 mm wall thickness

**Expander heads H 2:  
Type 2** Ø 28 - 70 mm, 1.1/8 - 2.3/4"  
up to 2.5 mm wall thickness

**Expander heads H 2:  
Type 3** Ø 70 - 110 mm, 2.3/4 - 4.1/4"  
up to 3.0 mm wall thickness



Expander Pistol H 2  
(No. 12003) Fig. Similar

Adaptor  
(No. 12097)



Adjusting tool  
(No. 12018)

Scope of delivery: Electro-Hydraulic Expander Pistol, 2.5 m control cable, hydraulic hose with quick coupling for H 600 and adjusting tool (without expander heads)

Model	kg	No.
Electro-Hydraulic Expander Pistol H 2	7.5	<b>12002</b>
Expander heads H2/Type 2, 28 - 70 mm	2.5	<b>12078</b>
Expander heads H2/Type 3, 70 - 110 mm	3.0	<b>12080</b>
S-head adaptor for H 2	1.1	<b>12097</b>
Adjusting tool for H2	0.9	<b>12018</b>



H 2 / Type 2

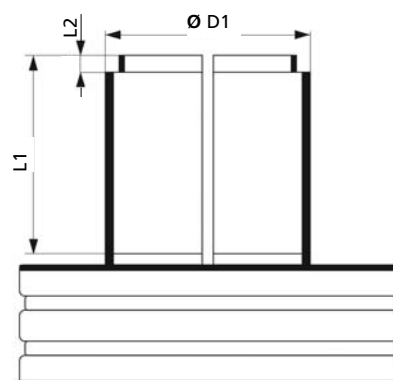
H 2 / Type 3

### Custom-Made Products\* Riveted Expander Heads H2

Only one head necessary for every pipe diameter.

**When ordering, please fill out form and state the applicable dimensions L1 / L2 / D1**

**\* Availability, delivery time and price available on request!**



Examples of a custom order

### Expander-Adaptor Type S

To increase the application area of the ROCAM® EXPANDER Power Torque, Expander Pistol H1/H2, EXPANDER A0/A1 and ROMAX EXPANDER Compact

Allows the use of the expander heads Type S with copper pipe (soft) up to 67 mm and/or 2.1/2"!



No. 11007 Expander adaptor for ROCAM® EXPANDER Power Torque or Expander Pistol H1



No. 12097 Expander adaptor for Expander Pistol H2

Model	max.	max. mm	kg	No.
Adaptor Type S, without expander heads	67 mm and/or 2.1/2"	2,0	0.6	<b>11007</b>
Adaptor Type S, without expander heads	67 mm and/or 2.1/2"	2,5	1.1	<b>12097</b>

	Expander Head ROLOCK	Expander Head Standard	Expander Head Type S	Riveted Expander Head	Expander Head PE-X	Expander Head H2, Type 2 & 3	Stepped Expander Head
<b>ROLOCK EXPANDER Power Torque</b> 	●	●		●	○	○	○
<b>ROCAM® EXPANDER Power Torque</b> 	○	●		●	● No. 12005	○	○
<b>EXPANDER A0</b> 	○	○	●	○	○	○	○
<b>EXPANDER A1</b> 	○	○	○	○	○	○	●
<b>ROMAX® EXPANDER Compact</b> 	○	● No. 15714	 No. 15714 ● No. 15715	● No. 15714	● No. 15716	○	○
<b>ROMAX® EXPANDER AC ECO MAXI</b> 	○	○	○	○	○	○	●
<b>Expander Pistol H1</b> 	○	●		●	○	○	○
<b>Expander Pistol H2</b>  Similar to photo	○	○		○	○	●	○

● Expander head without adaptor can be used

○ Expander head can not be used

Fig.: Can be used with the appropriate adaptor (pictured)





# Bonding

## Expanding & Extracting Manual

### COMBI KIT Expander / Tee-Extractor

Practical, compact and cost-saving set combinations with with ROCAM and ROLOCK EXPANDER Power Torque and Tee-Extractors. For all common pipe dimensions  $\varnothing$  12 - 28 mm (1/2 - 1.1/8")

#### Made in Germany!

The know-how from the pioneer of expanding technology and the leading manufacturer of expanding tools for over 40 years!



#### Product Profile

##### APPLICATION AREA

Suitable for pipes made of copper, aluminium and steel (soft):  $\varnothing$  12 - 28 mm and 1/2 - 1.1/8"

##### KEY FEATURES

- Increases safety by reducing the number of connections
- Suitable for making branches even in confined spaces through the compact design

##### KEY FEATURES

- Fine adjustment of the capillary gap using the KSO-screw
- Reduces effort required and increases work space
- Up to 67% reduction of soldering materials and soldered joints
- Accurate drilling
- Saves resources by converting scrap pipes into fittings
- Reliable pipe connections to DVGW standards

4



**EPT®-Technology**  
Concealed bent lever

Largest possible expansion size and capillary gap using the adjustable KSO-screw



#### Professional Extractions

Up to 67% reduction of soldering materials and soldered joints

#### Long handles

Reduces effort required and increases work space

#### Utilisation of material

Saves resources by converting scrap pipes into fittings

#### UNIDRILL® Automatic 28 / 42

Accurate drilling

No. 21583 /  
No. 21575

#### Scale and cam depth adjustment

#### Extractor Cam Pincer

Limits insertion depth for  $\varnothing$  12 - 42 mm (1/2 - 1.5/8")

No. 22080



COMBI KIT Set includes: ROCAM® EXPANDER Power Torque (No. 12000), Standard expander heads, tee-extractor, special ratchet (No. 22081), UNIDRILL® Automatic 28 (No. 21583), extractor cam pincer (No. 22080), steel carrying case (No. 24022)

COMBI KIT Set includes: ROLOCK EXPANDER Power Torque (No. 12400), ROLOCK expander heads, tee-extractor, special ratchet (No. 22081), UNIDRILL® Automatic 28 (No. 21583), extractor cam pincer (No. 22080), steel carrying case (No. 24022)

Model	Description	kg	📦	No.
COMBI KIT	12 - 15 - 18 - 22 mm	4.4	1	<b>011180X</b>
COMBI KIT	12 - 14 - 16 - 18 mm	2.6	1	<b>011186X</b>
COMBI KIT	1/2 - 5/8 - 7/8 - 1.1/8"	2.8	1	<b>011194X</b>

Model	Description	kg	📦	No.
ROLOCK COMBI KIT	12 - 15 - 18 - 22 mm	4.4	1	<b>12601</b>
ROLOCK COMBI KIT	12 - 14 - 16 - 18 mm	2.6	1	<b>12602</b>
ROLOCK COMBI KIT	1/2 - 5/8 - 7/8 - 1.1/8"	2.8	1	<b>12604</b>
ROLOCK COMBI KIT	1/2 - 3/4 - 1	2.5	1	<b>12605</b>

### Tee-Extractor Sets

For efficient production of T-branches (extractions) for fitting-free pipe installations, Ø 12 - 42 mm (3/8 - 2.1/8")

#### Product Profile

##### APPLICATION AREA

Suitable for pipes made of:

**Copper (soft, semi-, hard):** 12 - 42 mm, 3/8 - 2.1/8" max. wall thickness 2.5 mm

**Aluminium:** 12 - 42 mm, 3/8 - 2.1/8" max. wall thickness 2.5 mm

**Precision steel:** 12 - 42 mm, 3/8 - 2.1/8" max. wall thickness 2.5 mm

#### Made in Germany!

The know-how from the pioneer of expanding technology and the leading manufacturer of expanding tools for over 40 years!



##### KEY FEATURES

- Eliminates the cost for T-pieces, purchase and storage of fittings
- Extractions even on installed pipes possible
- Accurate drilling
- Optimal positioning with the cam pincher depth adjustment

#### Scale and cam depth adjustment



**Extractor Cam Pincer**

Limits insertion depth for Ø 12 - 42 mm (1/2 - 1.5/8")

No. 22081

#### Optimum capillary gap

Professional extractions

#### Limits the insertion depth

Optimal positioning

#### No pipe removal

Extractions even on installed pipes possible

#### UNIDRILL® Automatic 28 / 42

Accurate drilling



No. 21583 / No. 21575

Tee-Extractor sets include: Tee-Extractor according to chart, special ratchet (No. 22081), cam pincer (No. 22080) and special conical drill, UNIDRILL® Automatic 42 (No. 21575), in steel carrying case (No. 24022)



Model	Description	kg		No.
Tee-Extractor set 12 - 15 - 18 - 22 mm		3.4	1	<b>22100</b>
Tee-Extractor set 12 - 15 - 22 - 28 mm		3.6	1	<b>22101</b>
Tee-Extractor set 12 - 15 - 18 - 22 - 28 mm		3.9	1	<b>22103</b>
Tee-Extractor set 10 - 12 - 15 - 18 - 22 mm		3.5	1	<b>22102</b>
Tee-Extractor set 12 - 14 - 16 - 18 - 22 mm		3.6	1	<b>22109</b>
Tee-Extractor set 10 - 12 - 14 - 16 - 18 - 22 mm		3.7	1	<b>22111</b>
Tee-Extractor set 12 - 15 - 18 - 22 - 28 - 35 - 42 mm		5.5	1	<b>22126</b>
Tee-Extractor set 15 - 22 - 28 mm		3.6	1	<b>22127</b>
Tee-Extractor set 1/2 - 5/8 - 3/4 - 7/8"		3.4	1	<b>22121</b>
Tee-Extractor set 1/2 - 5/8 - 7/8 - 1.1/8"		3.7	1	<b>22124</b>
Tee-Extractor set 1/2 - 3/4 - 1"		3.3	1	<b>22135</b>



### Tee-Extractor

Tee-Extractor with double v-block for accurate 90° branches, Ø 10 - 54 mm (3/8 - 2.1/8")

#### Product Profile

#### KEY FEATURES

- Uniform and proper material extraction without scratches or burrs
- Burr-free operation with the specially polished extractor hooks
- Easy insertion into the drilled hole with the special trapezoidal screw thread
- Accurate and firm positioning for exact 90° branches

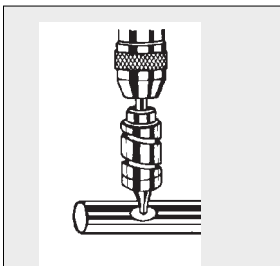
mm / inch	mm	Drill Ø mm	SW mm	g	No.
10	1.0	6	11	130	<b>22010</b>
12	1.0	7	11	150	<b>22012</b>
14	1.0	8	11	160	<b>22014</b>
15	1.0	8	11	160	<b>22015</b>
16	1.0	8	11	220	<b>22016</b>
18	2.0	10	11	220	<b>22018</b>
22	2.0	12	11	350	<b>22022</b>
28	2.5	15	11	470	<b>22028</b>
32	2.5	19	11	700	<b>22032</b>
35	2.5	22	11	700	<b>22035</b>
38	2.5	22	11	700	<b>22038</b>
42	2.5	26	11	890	<b>22042</b>
54	2.5	30	19	1380	<b>22054</b>
3/8"	1.0	6	11	110	<b>22060</b>
1/2"	1.0	7	11	140	<b>22061</b>
5/8"	1.0	8	11	220	<b>22016</b>
3/4"	2.0	10	11	220	<b>22062</b>
7/8"	2.0	12	11	350	<b>22063</b>

Hexagon ■ Square

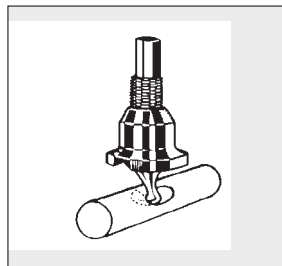
mm	g	No.
10	60	<b>22210</b>
12	70	<b>22212</b>
14	90	<b>22214</b>
15	90	<b>22215</b>
16	140	<b>22216</b>
18	140	<b>22218</b>
22	210	<b>22222</b>
28	220	<b>22228</b>
35	290	<b>22235</b>
38	290	<b>22268</b>
42	320	<b>22242</b>
54	560	<b>22254</b>

inch	g	No.
3/8"	60	<b>22260</b>
1/2"	70	<b>22261</b>
5/8"	140	<b>22216</b>
3/4"	140	<b>22263</b>
7/8"	200	<b>22264</b>
1"	210	<b>22265</b>
1.1/8"	220	<b>22266</b>
1.1/4"	270	<b>22267</b>
1.3/8"	290	<b>22235</b>
1.1/2"	290	<b>22268</b>
1.5/8"	320	<b>22270</b>
2"	520	<b>22246</b>
2.1/8"	560	<b>22254</b>

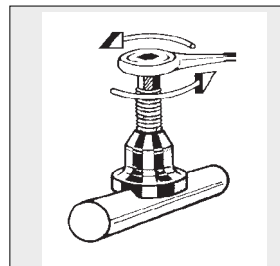
Precise drilling of the pipe without a centre punch – drill stop prevents perforation of the pipe



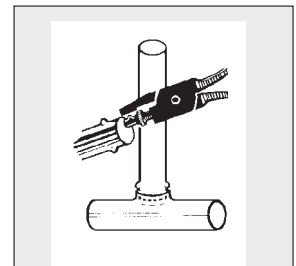
Insert extractor hook into the drilled hole and screw the bell firmly against the drill hole



Using the ratchet, turn the extractor to the left, while paying attention that the v-block is seated securely



After extraction, set correct insertion depth (dependant on pipe Ø) with cam pincer



Simply calibrate the tee Ø on the UNIDRILL® Automatic and the drilled hole Ø will automatically correspond to the extractor hook required



#### Double V-block

Accurate and firm positioning for exact 90° branches

#### Specially polished, forged and tempered extractor hooks

Burr-free operation

#### Special hook design

Easy insertion into the drilled hole

Ratchet adaptor (No. F80053 and F80054) with No. 22050 / 22054 included in scope of delivery (square, 3/4")



mm / inch	mm	Drill-Ø mm	SW mm	g	No.
1"	2.5	14	11	470	<b>22064</b>
1.1/8"	2.5	15	11	480	<b>22065</b>
1.1/4"	2.5	19	11	700	<b>22066</b>
1.3/8"	2.5	22	11	700	<b>22035</b>
1.1/2"	2.5	22	11	700	<b>22038</b>
1.5/8"	2.5	26	11	900	<b>22068</b>
2"	2.5	30	19	1380	<b>22050</b>
2.1/8"	2.5	30	19	1380	<b>22054</b>

#### Accessories

Socket 19 mm **F80053**  
Square connection 3/4" **F80054**

### Spare Extractor Hooks

Forged hooks, specially polished, tempered from Ø 10 - 54 mm (3/8 - 2.1/8")



Note: For copper pipes (soft), the use of an extractor support is recommended! ( 93)

### Tee-Extractor Ratchet

Chrome vanadium steel, fine toothed and right/left reversible



No. 22081



No. 27181

Model	SW	g	No.
10 - 42 mm, 3/8 - 1.3/4"	11 mm	435	<b>22081</b>
54 - 70 mm, 2 - 2.1/8"	3/4"	1140	<b>27181</b>

### Extractor Cam Pincer

#### KEY FEATURES

- Identification point marks insertion depth exactly and prevents over-insertion
- Cam depth adjustment wheel with scale



mm	inch	mm	g	No.
12 - 42	1/2 - 1.5/8"	150	170	<b>22080</b>

### EVERCOOL

Drill and extraction paste

#### KEY FEATURES

- Longer tool life
- All-purpose use except for drinking water installation
- Suitable for aluminium and precision steel
- Easy application with the integrated pen for applying the paste



Description	Content	g	No.
EVERCOOL	50 g	80	<b>21549</b>

### UNIDRILL® Automatic 28 / 42

HSS special conical drill

#### KEY FEATURES

- Fast, burr-free drilling
- Precise location without need for centre punch special drill tip
- Calibrated drill Ø automatically corresponds to the correct extractor hook and branch size
- Drill stop prevents damage to pipe walls

UNIDRILL® Automatic 28 / 42

Accurate drilling



No. 21583

No. 21575

Model	mm	inch	SW	g	No.
UNIDRILL® 28	10 - 28	3/8 - 1.1/8"	11	110	<b>21583</b>
UNIDRILL® 42	10 - 42	3/8 - 1.5/8"	11	430	<b>21575</b>

### Extractor Support

#### KEY FEATURES

- Prevents deformation during extraction, especially for soft pipe material

Extractor support plates

Prevents deformation during extraction



Mainpipe	Branchpipe	g	No.
22 mm	18 mm	250	<b>22157</b>
28 mm	22 mm	300	<b>22158</b>
1/2"	3/8"	120	<b>22170</b>
5/8"	1/2"	170	<b>22153</b>
3/4"	5/8"	250	<b>22172</b>
7/8"	3/4"	250	<b>22157</b>
1.1/8"	1"	300	<b>22158</b>



# Bonding

## Flaring

### Precision Double Flaring Press DB 10

For standard precision expands according to DIN 74234  
 Ø 4.75 - 10 mm, wall thickness 0.7 - 1.0 mm

#### Product Profile

#### APPLICATION AREA

On copper, aluminium and steel pipes, seamless pipes and double-walled pipes, for example Bundy® pipe, and KUNIFER brake pipes

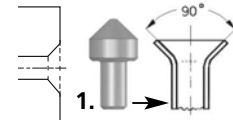
#### KEY FEATURES

- Ideal for endless pipes
- For several flaring profiles, wall thickness 0.7 - 1 mm
- Universal use with the pluggable pressure cone
- Accurate and reproducible results
- Clamping block for several pipe diameters
- Reliable hold with the 25 mm pipe clamping length
- Suitable for clamping in a vice

#### Formation of the various flares made possible with the appropriate flaring attachments

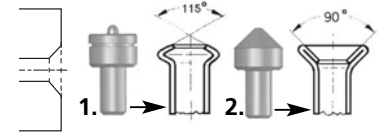
##### E- contour, simple flare:

- Standard flaring contour



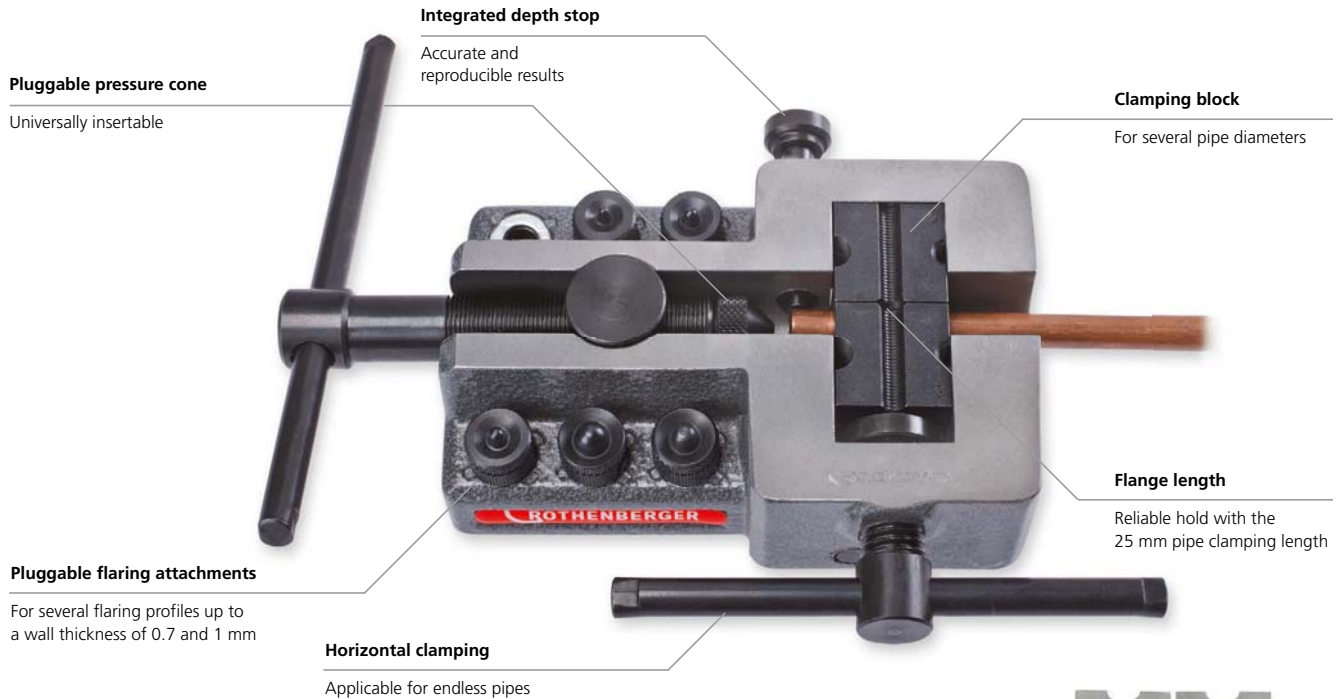
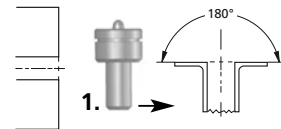
##### D-contour, double flare:

- Extension of brake and/or hydraulic lines
- Connection by means of coupling rings, sealed by means of flaring surface



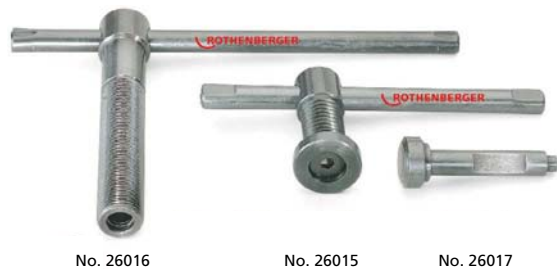
##### 180° flares:

- Mounting using coupling ring, for example hydraulic transmission valve and / or distributor block
- Seal between drill-hole and flaring surface



#### Pluggable flaring attachments

For several flaring profiles up to a wall thickness of 0.7 and 1 mm



Set (No. 26013) includes: Basic tool with pressure cone (No. 26010), flaring attachments, 1 set of clamping blocks (No. 26011)

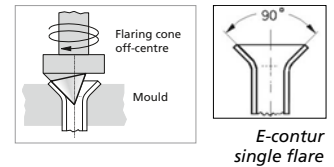
Description	mm	kg	No.
DB 10 set	4.75 - 5 - 6 - 8 - 9 - 10 mm	2.64	<b>26013</b>
Flaring attachments 4.75 / 5 mm		0.20	<b>26001</b>
Flaring attachments 6 mm		0.20	<b>26002</b>
Flaring attachments 8 mm		0.20	<b>26003</b>
Flaring attachments 9 mm		0.20	<b>26004</b>
Flaring attachments 10 mm		0.20	<b>26005</b>

Description	mm	g	No.
Pressure cone		20	<b>26010</b>
Clamping spindle		90	<b>26015</b>
Flaring spindle		300	<b>26016</b>
Distance bolt		30	<b>26017</b>
Set of clamping blocks (2 pc.) for Pipes 4,75 - 5 - 6 - 8 - 9 - 10 mm		190	<b>26011</b>

### ROFLARE REVOLVER

#### Revolver reeling flaring tool

For the reliable and fast production of standard single 45° flares in accordance with EN 14276-2 and JIS B8607:2008 on copper soft pipes Ø 6 - 18 mm and 1/4 - 3/4"



#### Product Profile

##### KEY FEATURES

- Guaranteed norm flares
- Produces leak free joints
- One-handed quick clamping system
- **Automatic depth stop:** perfect positioning of the pipe to the flaring cone



**Adaptor attachment**  
For ratchet & electric drive

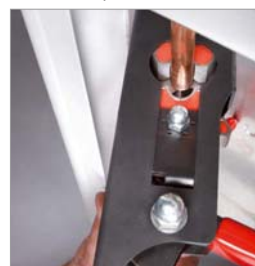
**High-quality revolver die**  
Highest fitting accuracy with long service life

**Box nuts**  
Simple retraction of the feed unit

Set (1000000230) includes: ROFLARE REVOLVER metric incl. ratchet adaptor, dies Ø 6, 8, 10, 12, 16 and 18 mm, pipe cutter ROTRAC 28 PLUS CHROM Limited Edition (1000000046), in blister pack  
Set (1000000231) includes: ROFLARE REVOLVER imperial incl. ratchet adaptor, dies Ø 1/4, 5/16, 3/8, 1/2, 5/8 and 3/4", pipe cutter ROTRAC 28 PLUS CHROM Limited Edition (1000000046), in blister pack

Model	No.
Set, metric with ROTRAC 28 PLUS CHROM Limited Edition (in blister pack)	<b>1000000230</b>
Set, imperial with ROTRAC 28 PLUS CHROM Limited Edition (in blister pack)	<b>1000000231</b>
Metric, Ø 6, 8, 10, 12, 16, 18 mm (in blister pack)	<b>1000000222</b>
Imperial, Ø 1/4, 5/16, 3/8, 1/2, 5/8, 3/4" (in blister pack)	<b>1000000223</b>

*Compact design enables use in confined spaces*



*Automatic depth stop: Perfect positioning of the pipe to the flare cone*



# Bonding

## Flaring

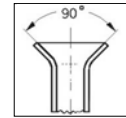
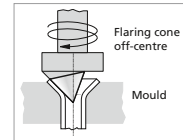
### Reeling Flaring Tool

For producing precision 45° single flares on copper pipes  
 Ø 6 - 18 mm (1/8 - 3/4")

#### Product Profile

#### KEY FEATURES

- Controlled expanding and shaping of the pipe without tearing
- No reduction in wall thickness
- No slipping of the pipe
- Sturdy and long lasting



No. 222401, No. 222402,  
No. 222403

#### Square connection

For manual operation, for example cordless screwdriver

#### Spring-loaded slide coupling

No reduction in wall thickness

#### Made from forged steel

Tough and long-lasting

#### Self-centring die

Highest flare precision

#### Adaptor for cordless screwdriver

Die available in metric and imperial sizes

Pipe will not slip



4



#### Flare cone rotates off-centre in needle bearings

Controlled expanding and shaping of the pipe end without tearing

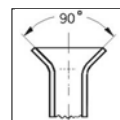
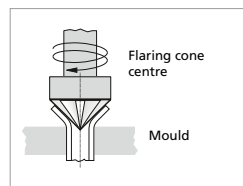
Reeling Flaring Tool set includes: Reeling Flaring Tool in plastic case with mould in metric and/or imperial format

Description	mm / inch	No.
Set EB 6 - 8 - 10 - 12 - 14 - 15 - 16 - 18 mm		<b>222401</b>
1/8 - 3/16 - 1/4 - 5/16 - 3/8 - 1/2 - 5/8 - 3/4"		
Set EB 1/8 - 3/16 - 1/4 - 5/16 - 3/8 - 1/2 - 5/8 - 3/4"		<b>222402</b>
Set EB 6 - 8 - 10 - 12 - 14 - 15 - 16 - 18 mm		<b>222403</b>
Dies		
metric 6 - 8 - 10 - 12 - 14 - 15 - 16 - 18 mm		<b>222413</b>
imperial 1/8 - 3/16 - 1/4 - 5/16 - 3/8 - 1/2 - 5/8 - 3/4"		<b>222412</b>

### Universal Flaring Tool

For producing precision 45° single flares on copper pipes  
 Ø 4 - 16 mm (3/16 - 5/8")

- Universal application and highest flare precision through self-centring pipe clamp for all diameters
- Controlled flaring without tearing, forming perfect surfaces
- Hardened flare cone with special geometry



Universal Flaring Tool set (No. 222601) includes: Universal Flaring Tool for pipe diameters 4 - 16 mm, 3/16 - 5/8", in plastic case

Model	mm	inch	kg	No.
Set EB	4 - 16 mm	3/16 - 5/8"	900	<b>222601</b>

### Flaring and Bending Set

Universal application in industry and small trade by sanitary and heating installations, refrigeration and air-conditioning technology, auto and hydraulic technology



Flaring and bending set (No. 26020) includes: MINICUT I, Ø 3 - 16 mm (No. 70401), internal and external deburrer, Ø 4 - 36 mm (No. 11006), double flare press DB 10 (No. 26013), TUBE BENDER set, Ø 4,75 - 10 mm (No. 24112), steel carrying case (No. 24022)

Model	mm	kg	No.
Flaring / Bending set	4,75 - 5 - 6 - 8 - 9 - 10	5.5	<b>26020</b>

## ROTORQUE AIRCON / REFRIGERATION

### Step-less torque wrench

#### Produkt-Profil

#### APPLICATION AREA

Self-locking rack and pinion drive enables quick and reliable fastening of flare nuts sizes 15 - 32 mm in accordance with EN 378-2:2012-08

#### KEY FEATURES

- Always fits, covers all flare nut sizes from 15 - 32 mm
- Won't slip thanks to the self-locking rack and pinion drive and ratchet function
- Simple and reliable: required torque in accordance with EN 378-2:2012-08 is embossed on the head for every size and can not be rubbed off
- Embossed torque data: easy tightening according to norm
- ROTORQUE REFRIGERATION is suitable for cylinder heads' work

#### Connection 9 x 12

Head can be exchanged between ROTORQUE AIRCON and ROTORQUE REFRIGERATION

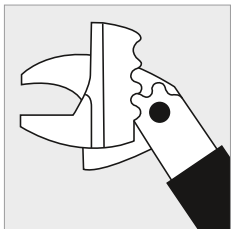
**All-In-One: One head fits all sizes!**



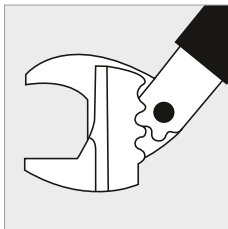
The torque can be read off

Always tighten according to the standard

Closed head



Fully opened head



#### ROTORQUE AIRCON Torque wrench

- 10 – 110 Nm
- ± 4% accuracy
- 1 Nm adjustment steps

#### ROTORQUE REFRIGERATION Torque wrench

- 10 – 70 Nm
- ± 3% accuracy
- 1/2 Nm adjustment steps
- Suitable for cylinder heads' work



Fig. ROTORQUE AIRCON torque wrench



Fig. ROTORQUE REFRIGERATION torque wrench

ROTORQUE sets include: Torque wrench, head, carrying bag

Model	kg	No.
ROTORQUE AIRCON	1.5	1000000224
ROTORQUE REFRIGERATION	1.4	1000000225

## Torque Wrench Set

### For proper tightening of flange connections

Set with adjustable torque wrench (10-70 Nm) and 6 spanner inserts sizes 17, 22, 24, 26, 27 and 29 mm for flange connections on 1/4", 3/8", 1/2" and 5/8" pipe lines according to DIN EN 378-2 : 2012-08



**Fix with torque urgently necessary!**



8 piece set (No. 1750.01) includes: spanner wrench sizes 17, 22, 24, 26, 27, 29 mm, torque wrench, carrying bag

Pipe-Ø	Spanner width	Locking torque
1/4" / 6 mm	17 mm	14-18 Nm
3/8" / 10 mm	22 mm	33-42 Nm
1/2" / 12 mm	24 mm	50-62 Nm
1/2" / 12 mm	26 mm	50-62 Nm
5/8" / 15/16 mm	27 mm	63-77 Nm
5/8" / 15/16 mm	29 mm	63-77 Nm

Model	kg	No.
Torque wrench set, 7 piece	3.5	175001



# Bonding

## System Overview Pressing Technology

### ROMAX® Press Machines – Made in Germany

For the bonding of pipes, ROTHENBERGER has developed a high-quality press technology system. Thanks to a platform strategy with high component similarity, the tools win over customers with their technology and safety. ROTHENBERGER pressing tools are developed and manufactured in Germany.

### ROTHENBERGER Pressing Technology Overview

	Compact	Standard
<b>4</b> 		
<b>Nominal size</b>	For press connections of Ø 12 - 40 mm (plastic/multi-layered) and/or Ø 12 - 28 mm (metal)	For press connections from Ø 12 - 110 mm (system dependant)
<b>Press machines</b>	<p><b>ROMAX® Compact</b></p>  <p>starting on  100</p>	<p><b>ROMAX® 3000</b></p>  <p>starting on  102</p> <p><b>ROMAX® AC ECO</b></p>  <p>starting on  104</p>
<b>Press jaws</b>	<p><b>Compact Press Jaws</b></p>  <p>Ø 12-28 mm (metal)</p> <p>Ø 12-40 mm (plastic/multi-layered)</p> <p>starting on  105</p>	<p><b>Standard Press Jaws</b></p>  <p>Ø 12-54 mm</p> <p>starting on  106</p>
<b>Interchangeable inserts / Pressing collars</b>	<p><b>Press Jaws with Interchangeable Inserts</b></p>  <p>Ø 12-32 mm</p> <p>starting on  105</p>	<p><b>Press Jaws with Pressing Collars</b></p>  <p>Ø 40-110 mm (system dependant)</p> <p>starting on  106</p>

## System Overview Pressing Technology

### ROTHENBERGER Constant Force Technology

The CFT® guarantees a constant axial pressing force over the entire service interval. A very important requirement for the production of sealed press connections CFT® guarantees:

**ROMAX® Compact**  
19-21 kN for 10,000 press cycles

**ROMAX® AC ECO**  
32-34 kN for 10,000 press cycles

**ROMAX® 3000**  
32-34 kN for 20,000 press cycles



### Safety lock

No accidental release, since a 180° rotation is required

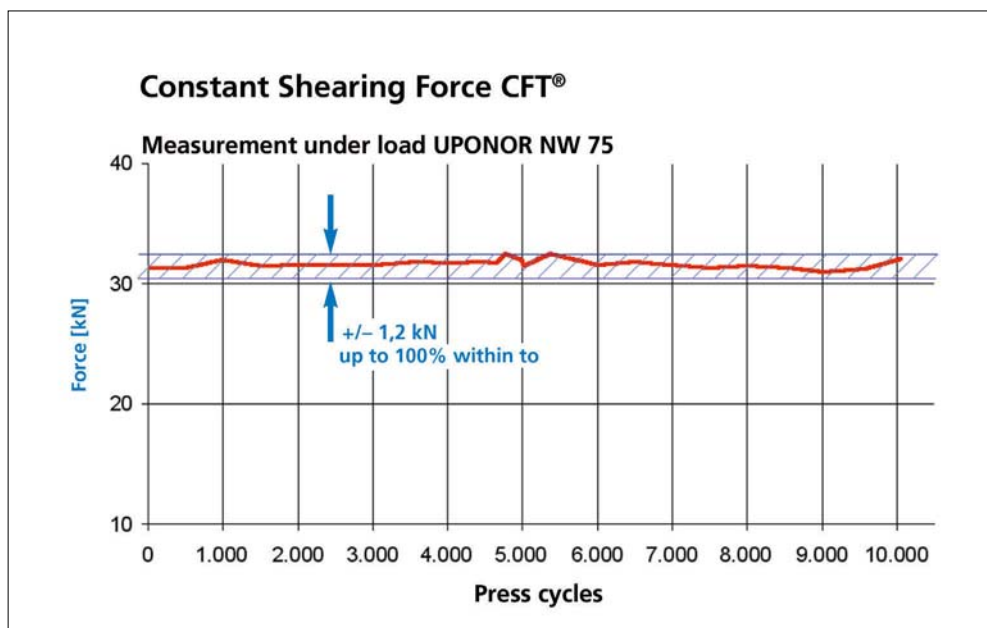


### Safe operation with the emergency stop switch

All ROTHENBERGER press machines are equipped with an easily accessible emergency stop switch. By pushing the switch, the press cycle is immediately interrupted and the piston retracts automatically.



4



### System obligation

The user **is not forced** to purchase different press jaws and/or press machines for each system from the same system manufacturer. No law, no DIN-standard nor the DVGW process sheet requires system dependence. No craftsman is obliged to use only the press tools or press jaws from one (fittings / pipe) system manufacturer



### ROTHENBERGER Li-Ion Technology

The pressing tools ROMAX® Compact and ROMAX® 3000 are equipped with the newest Li-ion technology. Li-ion batteries have many advantages compared to standard battery technology:

- High energy density - up to 100% more pressing per charge compared to the ROTHENBERGER NiMH battery
- Low weight - 30% weight savings
- Cold-resistant - even at near freezing temperatures
- Lowest self-discharge - can be stored up to 12 months
- No memory effect - can be charged at any time
- Constant energy from the first until the last pressing



### Controlled press cycle

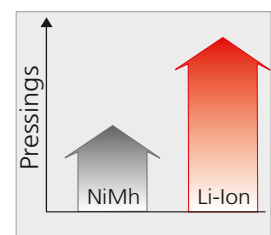
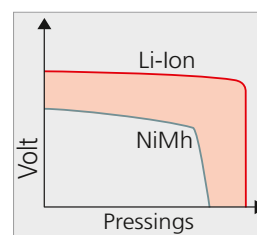
After reaching a predetermined pressing force the press cycle switches off automatically. The piston retracts after the necessary pressing force has been reached. This guarantees uniform and reliable pressings analogue to the requirement of leading system manufacturers.



### Electronic control

The electronics of the ROMAX® Compact and the ROMAX® 3000 provide for a safe pressing cycle:

- Control of the battery charge status
- Safety start-inhibitor when the battery is too low
- LED display of the service interval and any error messages



# Bonding

## Press Machines Compact

### ROMAX® Compact

Electro-hydraulic press machine, for battery and mains operation for the pressing of fittings up to Ø 40 mm (plastic/multi-layer) and/or up to Ø 28 mm (metal) with 19 kN

**Made in Germany**

Please observe system characteristics/benefits on pages 98 - 99!

#### Product Profile

##### APPLICATION AREA

The ROMAX® Compact is extremely light, easy to hold and with its compact design it is perfect for field use, especially in confined spaces

##### KEY FEATURES

- Extremely light: only 2.6 kg
- Ergonomic thanks to the rubberised handle and balanced weight distribution
- For battery and mains operation
- Work-bench function
- Controlled press cycle
- Electric control with service counter and battery status indicator
- CFT®
- Safety lock
- Emergency stop switch

##### TECHNICAL DATA

<b>Dimension:</b>	400 x 70 x 90 mm
<b>Weight:</b>	ca. 2.6 kg (without press jaw)
<b>Piston force / hub:</b>	19 kN / 30 mm
<b>Nominal size:</b>	Ø 12 - 28 mm (metal) Ø 12 - 40 mm (plastic/multi-layer)
<b>Press jaw fixture:</b>	270° rotation
<b>Power supply:</b>	Li-ion battery 14.4 V / 2.6 Ah Main adaptor 230 V / 50 - 60 Hz Main adaptor 110 V on request
<b>Operating temperature:</b>	-10° C up to +60° C
<b>Pressings:</b>	up to 140 with 28 mm stainless steel

##### PRESSING TOOLS

<b>Press jaws:</b>	ROTHENBERGER Compact press jaws starting on page 105
<b>Interchangeable press jaws:</b>	ROTHENBERGER Interchangeable press jaws starting on page 105

4



#### Light weight and balanced weight distribution

Fatigue-free and ergonomic use even over long periods of time

#### LED display

Electronic battery charge indicator, electronic counting of the press cycles (displays when service interval has been reached, further pressings are possible)

#### Powerful motor

Fast pressings in approx. 6 seconds

#### Wand-like

design enables use in installation shafts and by front-wall constructions

#### 270° rotatable jaw fixture

For easy use in confined spaces

#### Safety lock

No unintentional opening because a 180° rotation is necessary

#### Rubberised handle

Secure hold even in wet conditions

#### CFT® (Constant Force Technology) for a constant axial force of 19 kN

Constant pressing force for over 10,000 press cycles

#### Emergency stop switch

Immediate interruption of the feed and retraction of the piston

#### Li-ion battery technology

Up to 100% more pressings\*



\* compared to ROTHENBERGER NiMH batteries

### ROMAX® Compact Set Basic I

Set Basic I (No. 15020) includes: ROMAX® Compact press machine, 1x 14.4 V/2.6 Ah Li-ion battery (No. 15418), rapid charger (No. 15017), plastic carrying case (No. 15016), (without press jaws)

**DUO-POWER 14.4 V or 230 V**



All ROMAX® Compact have a Li-ion battery!

**Made in Germany**

5 m cable length

Large operating radius



Fig. Power supply (No. 15037)



Fig. ROMAX® Compact Set SV

Workbench function with stable supporting surface



Slim – compact wand-like design



Work above head



Model	Description	Press jaw mm			No.
ROMAX® Compact Set Basic I	in plastic carrying case with Li-ion battery and charger	(without pressing jaw)	1	5.0	<b>15020</b>
ROMAX® Compact Set Basic II	in plastic carrying case with power supply 230 V, without Li-ion battery and without charger	(without pressing jaw)	1	5.2	<b>015020R</b>
ROMAX® Compact Set M	Set Basic I with press jaw Type M (Mapress, u.a.)	15 - 22 - 28	1	7.5	<b>15023</b>
ROMAX® Compact Set SV	Set Basic I with press jaw Type SV (Viega, u.a.)	15 - 22 - 28	1	7.5	<b>15022</b>
ROMAX® Compact Set SV	Set Basic I with press jaw Type SV (Viega, u.a.)	14 - 16 - 22	1	7.5	<b>15033</b>
ROMAX® Compact Set TH	Set Basic I with press jaw Type TH (Henco, u.a.)	16 - 20 - 26	1	8.7	<b>15032</b>
ROMAX® Compact Set U	Set Basic I with press jaw Type U (UNICOR, u.a.)	16 - 20 - 25	1	7.0	<b>15024</b>
ROMAX® Compact Set WE Set RFz	in plastic carrying case with Li-ion battery, spare press jaws and inserts	16 - 20 - 25 - 32	1	8.7	<b>14820</b>
ROMAX® Compact Set WE Set U	in plastic carrying case with Li-ion battery, spare press jaws and inserts	16 - 20 - 25 - 32	1	8.7	<b>14830</b>

### ACCESSORIES

Model	No.
ROMAX® Compact spare battery (14.4 V / 2.6 Ah, Li-Ion)	<b>15418</b>
ROMAX® Compact charger (230 V)	<b>15017</b>
ROMAX® Compact main adaptor (230 V), can be used in lieu of the battery	<b>15037</b>
Plastic carrying case, empty	<b>015016L</b>
<b>Press jaws, interchangeable press jaws starting on  105</b>	



# Bonding

## Press Machines Standard

**Made in Germany**

Please observe system characteristics/  
benefits on pages 98 - 99!

### ROMAX® 3000

Electro-hydraulic press machine for battery and mains operation for the system dependant pressing of fittings up to Ø110 mm\* with 32 - 34 kN

#### Product Profile

##### APPLICATION RANGE

The ROMAX® 3000 is fast, light, handy and safe. It is ideally suited for use at the building site

##### KEY FEATURES

- **Fast**  
A pressing cycle only lasts approx. 5 seconds. The piston retracts automatically after every finished pressing
- **Safe**  
CFT® guarantees the necessary pressing force. The automatic controlled press cycles ensure that the piston retracts to the starting position after the necessary pressing force has been reached
- **Light**  
The extremely low weight, as well as the balanced weight distribution, ensure fatigue-free use even in continuous use

\*system dependant

##### KEY FEATURES

- **Reliable & economical**  
Highest quality service interval of 20,000 pressing cycles secures continuous economical use
- **Expanded operational temperature range**  
The ROMAX® 3000 works perfectly; even under adverse environmental conditions. Pressing is possible between -10° C and +60° C
- **Large range**  
The standard Li-ion technology allows up to 160 pressings (with 28 mm stainless steel), and/or 90 pressings (with 54 mm stainless steel) with each charge
- **Practical design**  
The compact, wand-like design allows pressings even in confined spaces

4



LED



#### Wand-like

Design allows use in installation shafts and by front-wall constructions

#### Rubberised handle

Secure hold even in wet conditions

#### 2-speed switch

Light pressure activates the LED, when pressed through the pressing cycle begins

#### LED display

Electronic flat battery detection, electronic counting of press cycles (notifies maintenance interval), further pressings possible

#### Safety lock

No unintentional opening because 180° rotation is required

#### Press jaw fixture can be rotated 270°

For easy operation even in confined spaces

#### Light weight and balanced weight distribution

Fatigue-free and ergonomic use even over long periods of time

#### Powerful motor

Fast pressings in approx. 5 seconds

#### Emergency stop switch

Immediate interruption of the feed and retraction of the piston



#### CFT® (Constant Force Technology) for constant axial pressing force of 32 kN

Constant pressing force over 20,000 press cycles



### TECHNICAL DATA

<b>Dimensions:</b>	445 x 125 x 75 mm
<b>Weight:</b>	approx. 3.6 kg (without press jaws)
<b>Piston force/-hub:</b>	32 kN / 40 mm
<b>Nominal size:</b>	Ø 12 - 110 mm (system dependant)
<b>Press jaw fixture:</b>	270° rotation
<b>Power supply:</b>	Li-ion battery 18 V / 3 Ah Main adaptor 230 V, 50 - 60 Hz, Main adaptor 110 V on request
<b>Operating temperature:</b>	-10° C up to +60° C
<b>Pressings:</b>	Up to 160 with 28 mm stainless steel Up to 90 with 54 mm stainless steel

### PRESSING TOOLS

<b>Press jaws:</b>	ROTHENBERGER standard press jaws, compatible with many other manufacturers starting on page 106
<b>Pressing collars:</b>	ROTHENBERGER pressing collars starting on page 106

#### High energy density

More pressing per charge, light weight <sup>1)</sup>



#### Cold-resistant

Can be used in even the lowest temperatures (-10° C up to +60° C)



#### No memory effect

A partially discharged battery can be fully recharged without any loss of capacity

#### Low self discharge

Very long shelf-life



Fig. ROMAX® 3000 set with press jaws

#### Light



#### Fast



#### Reliable



#### Slim



Basic set (No. 15800) includes: ROMAX® 3000, 18 V / 3.0 Ah Li-ion battery (No. 15810), rapid charger (No. 15811), plastic carrying case (No. 15816) (without press jaws)

Model	Description	Press jaws mm			No.
ROMAX® 3000 Set Basic	in plastic carrying case with Li-ion battery and charger (without press jaws)		1	9.8	<b>15800</b>
ROMAX® 3000 Set SV	with press jaws type SV (Viega, et al.), with Li-ion battery	15 - 22 - 28	1	14.5	<b>15840</b>
ROMAX® 3000 Set TH	with press jaws type TH (Henco, et al.), with Li-ion battery	16 - 20 - 26	1	14.5	<b>15845</b>
ROMAX® 3000 Set U	with press jaws type U (UNICOR, et al.), with Li-ion battery	16 - 20 - 25	1	14.5	<b>15850</b>
ROMAX® 3000 Set M	with press jaws type M (Mapress, et al.), with Li-ion battery	15 - 22 - 28	1	14.5	<b>15855</b>

### ACCESSORIES

Model	No.
ROMAX® 3000 Li-ion battery 18 V / 3 Ah	<b>15810</b>
ROMAX® 3000 charger for 110-230 Volt	<b>15811</b>
ROMAX® 3000 main adaptor 230 Volt	<b>15812</b>
Plastic carrying case, empty	<b>15816</b>

**Press jaws, pressing collars starting on 106**



<sup>1)</sup> Compared to the ROTHENBERGER NiMH battery

# Bonding

## Press Machines Standard

### ROMAX® AC ECO

Electro-hydraulic press machine for mains operation for system dependant pressing of fittings up to Ø 110 mm\* with 32 - 34 kN

**Made in Germany**

Please observe system characteristics/ benefits on pages 98 - 99!

#### Product Profile

##### APPLICATION AREA

The ROMAX® AC ECO is light, easy to handle and is suitable for the batch production of fitting joints in field operation

##### KEY FEATURES

- Ergonomic thanks to the rubberized handle and balanced weight distribution
- Controlled press cycle
- CFT®
- Safety lock
- Emergency stop switch
- 5 m cable

\*system dependant

##### TECHNICAL DATA

- Dimensions:** 415 x 180 x 80 mm  
**Weight:** approx. 4.5 kg (without press jaw)  
**Piston force/-hub:** 32 kN / 40 mm  
**Nominal size:** Ø 12 - 110 mm (system dependent)  
**Press jaw fixture:** 270° rotation  
**Power supply:** 230 V / 50-60 Hz, 110 V on request

##### PRESSING TOOLS

- Press jaws:** ROTHENBERGER standard press jaws, compatible with many other manufacturers starting on page 106  
**Pressing collars:** ROTHENBERGER Pressing collars starting on page 106

4



#### 270° rotatable jaw fixture

For easy use in confined spaces

#### Compatible jaw fixture

Suitable for many press jaws

#### Emergency stop switch

Immediate interruption of the feed

#### Safety lock

No unintentional opening because a 270° rotation is necessary

#### Two-switches within easy reach

Various holding positions possible. The controlled press cycle begins after pushing the hold-to-run control

#### Balanced weight distribution

Ergonomic use

#### CFT® (Constant Force Technology) for constant axial pressing force of 32 kN

Constant axial pressing force over 10,000 press cycles

#### 5 m cable length

Large operations radius

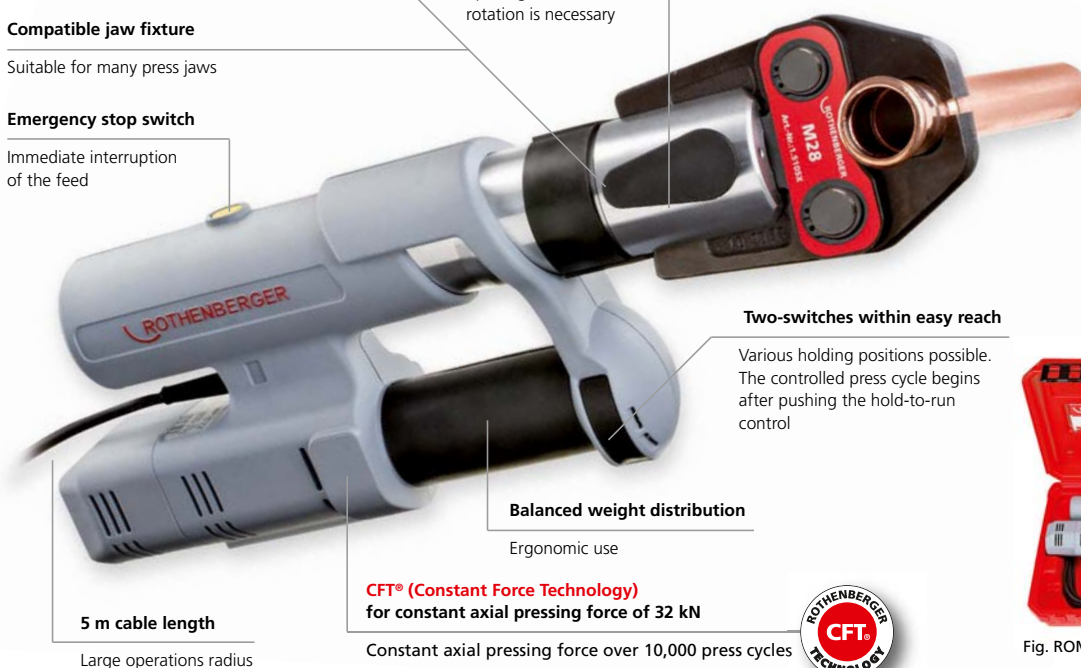


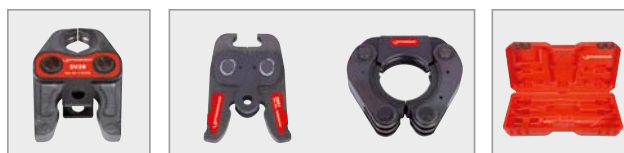
Fig. ROMAX® AC ECO Set with press jaws

Basic Sets (No. 15705) include: ROMAX® AC ECO Basic (230 Volt), plastic carrying case (No. F81664) (without press jaws)

Model	Description	Press jaws mm	kg	No.
ROMAX® AC ECO Set Basic I	in plastic carrying case	(without press jaws)	1 8.9	<b>15705</b>
ROMAX® AC ECO Set M	Set Basic I with press jaws type M (Mapress, et al.)	15 - 22 - 28	1 13.4	<b>15750</b>
ROMAX® AC ECO Set SV	Set Basic I with press jaws type SV (Viega, et al.)	15 - 22 - 28	1 13.4	<b>15740</b>
ROMAX® AC ECO Set TH	Set Basic I with press jaws type TH (Henco, et al.)	16 - 20 - 26	1 13.4	<b>15730</b>
ROMAX® AC ECO Set U	Set Basic I with press jaws type U (UNICOR, et al.)	16 - 20 - 25	1 13.4	<b>15760</b>

#### ACCESSORIES

Model	No.
Plastic carrying case, empty	<b>F81664</b>
Press jaws, pressing collars starting on	106



## Press Jaws & Interchangeable Press Jaws

### Press Jaws Compact

For ROMAX® Compact

ROTHENBERGER Press Jaws with proven material and manufacturing quality for system dependant pressing of fittings up to Ø 40 mm (plastic / multi-layer) and/or up to 28 mm (metal)

**Made in Germany**

#### Special hardening process

High degree of elastic force and expansion capability

#### 3-bolt synchronised mechanism

- Highest precision when pressing
- Synchronised run of the jaw lever
- Increased stability and durability
- Open the jaw with just 1 finger!

#### Batch numbering and individual testing

Secures the high quality standard of material and press contour

Product identification, simple to read, clear system and nominal size classification



#### Precision-manufactured contours

For optimum and reliable pressings

#### Made of forged, highly resilient special steel

Suitable for all press machines with a constant axial thrust of **19 kN** and compatible press jaw fixture

#### Permanent bolt

- Without potential weak points / no thread
- Considerable reduction of the breakage risk
- Increased safety

#### Long-term corrosion protection

Optimum for heavy-duty field operation

#### Optimised inlet contour

- Adapted power flow
- Less wear and tear

Press jaw overview starting on 107

4



### Interchangeable Press Jaws Compact

For ROMAX® Compact

ROTHENBERGER Press Jaws with proven material and manufacturing quality, for the attachment from interchangeable press jaws for system dependant pressing of plastic fittings Ø 16 - 32 mm

**Made in Germany**

**Combine various interchangeable inserts with only one press jaw!**



Set Interchangeable inserts

#### 3-bolt synchronised mechanism

Synchronised run of the jaw lever enables the jaw to be opened with just one finger

#### Batch numbering and individual testing

Secures the high quality standard of material and press contour



#### Guiding ridge

Safe admittance from inter-changeable press jaws

#### Made of casted, highly resilient special steel

Suitable for all press machines with a constant axial thrust of **19 kN** and compatible press jaw fixture

#### Special hardening process

High degree of elastic force and expansion capability

#### Long-term Corrosion protection

Optimum for heavy-duty field operation

Model	Description	No.	Model	Description	No.
Interchangeable inserts set RFz*	16 - 20 - 25 - 32 mm	<b>14849</b>	Interchangeable press jaws + set CO	12 - 16 - 20 mm	<b>15093</b>
Interchangeable inserts set U*	16 - 20 - 25 - 32 mm	<b>14869</b>	Interchangeable press jaws + set RFz	12 - 16 - 20 mm	<b>15094</b>
Interchangeable inserts set VP*	16 - 20 - 25 - 32 mm	<b>14879</b>	Interchangeable inserts set TH*	16 - 20 - 26 - 32 mm	<b>14895</b>

\*Can only be used with interchangeable pressing jaw No. 014800X!



# Bonding

## Press Jaws & Pressing Collars Standard

**Made in Germany**

### Press Jaws Standard

For ROMAX® PRESSLINER, ROMAX® PRESSLINER ECO, ROMAX® AC ECO

ROTHENBERGER Press Jaws with proven material and manufacturing quality, for system conforming pressing of fittings up to Ø 40 mm (plastic) and/or up to Ø 54 mm (metal)

#### Special hardening process

High degree of elastic force and expansion capability

#### 3-bolt synchronised mechanism

- Highest precision when pressing
- Synchronised run of the jaw lever
- Increased stability and durability
- Open the jaw with just 1 finger!

#### Batch numbering and individual testing

Secures the high quality standard of material and press contour

Product identification, simple to read, clear system and nominal size classification



Press jaw overview starting on 107

#### Precision-manufactured contours

For optimum and reliable pressings

#### Made of forged, highly resilient special steel

Suitable for all press machines with a constant axial thrust of 32 - 34 kN and compatible press jaw fixture

#### Permanent bolt

- Without potential weak points / no thread
- Considerable reduction of the breakage risk
- Increased safety

#### Long-term Corrosion protection

Optimum for heavy-duty field operation

#### Optimised inlet contour

- Adapted power flow
- Less wear and tear



4



### Pressing Collars Standard

For ROMAX® 3000, ROMAX® PRESSLINER ECO, ROMAX® AC ECO

Still suitable for press machines with a constant, axial pressing force of 32 - 34 kN and the appropriate compatible press jaw fixture. For the system conforming pressing of fittings from 42 mm up to 54 mm (metal) and/or from 40 mm up to 110 mm (multi-layer)

Using the pressing collar



Gripping the pressing collar with intermediate jaws



#### Limited weight

Power-saving work for any length of time

#### Batch numbering and individual testing

Secures the high quality standard of material and press contour

#### Long-term corrosion protection

Optimum for heavy-duty field operation

#### Special hardening process

High degree of elastic force and expansion capability

#### 2-joint technology

Simplifies use even in tight or over-head situations

#### Precision-manufactured contours

For optimum and reliable pressings

#### Special hardening process

High degree of elastic force and expansion capability

#### Made of forged, highly resilient special steel

Suitable for all press machines with a constant, axial thrust of 32 - 34 kN and compatible press jaw fixture

#### 3-bolt synchronised mechanism

Synchronised run of the jaw lever enables the jaw to be opened with just one finger



Fig. Pressing collar M54



Fig. Intermediate jaw ZBS1

Pressing collar sets include: Pressing collars according to the table, intermediate jaws ZBS1 (No.100000104), plastic carrying case (No. 150000782)

Model	Description	No.
Pressing collar set SV in plastic carrying case	press jaw ZBS1 / SV42 - 54	100000107
Pressing collar set M in plastic carrying case	press jaw ZBS1 / M42 - 54	100000110
Pressing collar set TH in plastic carrying case	press jaw ZBS1 / TH40 - 50	100000116

Pressing collars overview starting on 107

## Press Jaws Standard Set

### Press Jaws Standard Sets

ROTHENBERGER Press Jaws up to Ø 54 mm, in sturdy plastic carrying case

**Made in Germany**

**Professional set combinations!**

#### Variable and cost efficient

Universal for all ROTHENBERGER Press Jaws (Type Standard)

#### Various combinations possible

For example: 4 press jaws up to Ø 35 mm or 2 press jaws Ø 42 or 54 mm



#### Space for up to 6 Press Jaws

More than enough room for a complete press jaw system

Press Jaw sets include: Press Jaw according to chart, plastic case (No. 150000782)

Model			No.	Model			No.
M 15 - 18 - 22 - 28 mm	1	9.3	<b>015062X</b>	TH 16 - 20 - 26 mm	1	7.9	<b>015063X</b>
M 42 - 54 mm	1	11.8	<b>015081X</b>	VP 16 - 20 - 25 - 32 mm	1	9.4	<b>015072X</b>
SV 15 - 18 - 22 - 28 mm	1	9.3	<b>015060X</b>	Plastic jaw case, empty	1		<b>150000782</b>
SV 42 - 54 mm	1	9.5	<b>015080X</b>				
G 16 - 20 - 26 - 32 mm	1	11.4	<b>015068X</b>				














System	Nominal Size		 Use only in combination with interchangeable jaws No. 014800X		 Only to be used with intermediate jaw: ZB51 No. 100000104 for (SV, M, TH, U Ø 40, 42, 50, 63 mm), ZB52 No. 100000123 for (U Ø 75, 90, 110 mm)
<b>A</b>	<b>Metal / NE-Metal</b>				
	A1/2"	—	—	<b>015222X</b>	
	A3/4"	—	—	<b>015223X</b>	
	A1"	—	—	<b>015224X</b>	
	A1 1/4"	—	—	<b>015225X</b>	
	A1 1/2"	—	—	<b>015226X</b>	
	A2"	—	—	<b>015227X</b>	
<b>M</b>	M12	<b>015151X</b>	—	<b>015101X</b>	
	M15	<b>015152X</b>	—	<b>015102X</b>	
	M18	<b>015153X</b>	—	<b>015103X</b>	
	M22	<b>015154X</b>	—	<b>015104X</b>	
	M28	<b>015155X</b>	—	<b>015105X</b>	
	M35	—	—	<b>015106X</b>	
	M42	—	—	<b>015107X</b>	<b>100000108</b>
	M54	—	—	<b>015108X</b>	<b>100000109</b>
	<b>V / SV</b>	V/SV12	<b>015261X</b>	—	<b>015211X</b>
	V/SV14	<b>015269X</b>	—	<b>015219X</b>	
	V/SV15	<b>015262X</b>	—	<b>015212X</b>	
	V/SV16	<b>015260X</b>	—	<b>015220X</b>	
	V/SV18	<b>015263X</b>	—	<b>015213X</b>	
	V/SV22	<b>015264X</b>	—	<b>015214X</b>	
	V/SV28	<b>015265X</b>	—	<b>015215X</b>	
	V/SV35	—	—	<b>015216X</b>	
	V/SV42	—	—	<b>015217X</b>	<b>100000105</b>
	V/SV54	—	—	<b>015218X</b>	<b>100000106</b>
	<b>R(H)</b>	<b>PEX / Multilayer</b>			
	R12	—	<b>14863</b>	<b>015339X</b>	
	R14	<b>015370X</b>	<b>14864</b>	<b>015330X</b>	
	R16	<b>015371X</b>	<b>14865</b>	<b>015331X</b>	
	R17	<b>015378X</b>	<b>14866</b>	<b>015333X</b>	
	R18	<b>015379X</b>	<b>14867</b>	<b>015334X</b>	
	R20	<b>015374X</b>	<b>14868</b>	<b>015335X</b>	
	R25	<b>015380X</b>	<b>14707</b>	<b>015338X</b>	
	R26	<b>015376X</b>	<b>14708</b>	<b>015336X</b>	
	R32	<b>015377X</b>	<b>14709</b>	<b>015337X</b>	

Further information at [www.rothenberger.com](http://www.rothenberger.com)









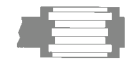
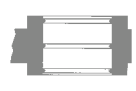

# Bonding

## Press Jaws Program Overview

System	Nominal Size	 Press Jaws Compact	 Interchangeable Insert Compact Use only in combination with interchangeable jaws No. 014800X	 Press Jaws Standard	 Pressing Collars Standard Only to be used with intermediate jaw: ZB51 No. 100000104 for (SV, M, TH, U Ø 40, 42, 50, 63 mm), ZB52 No. 100000123 for (U Ø 75, 90, 110 mm)
<b>RFz</b>		<b>PEX / Multi-layer</b>			
	RFz12	—	14822	1000000173	
	RFz16	015180X	14823	015161X	
	RFz18		1000000124		
	RFz20	015181X	14824	015162X	
	RFz25	015182X	14825	015163X	
	RFz26		1000000125		
	RFz32	015183X	14826	015164X	
<b>TH</b>	TH14	015395X	14842	015321X	
	TH16	015385X	14843	015322X	
	TH18	015398X	14844	015323X	
	TH20	015389X	14845	015324X	
	TH25	015399X	14846	015325X	
	TH26	015391X	14847	015326X	
	TH32	015393X	14848	015327X	
	TH40	015401X	—	015328X	1000000111
	TH50	—	—	—	1000000112
TH63	—	—	—	1000000113	
<b>THG</b>	THG32	1000000236	—	1000000235	
<b>THT</b>	THT32	015393H	—	015329X	
<b>U</b>	U14	015351X	14832	015311X	
	U16	015352X	14833	015312X	
	U18	015353X	14834	015313X	
	U20	015354X	14835	015314X	
	U25	015355X	14836	015315X	
	U32	015357X	14838	015317X	
	U40	015358X	—	015318X	1000000117
	U50	—	—	—	1000000118
	U63	—	—	—	1000000119
	U75	—	—	—	1000000120
	U90	—	—	—	1000000121
U110	—	—	—	1000000122	
<b>RC</b>	RC26	015277X	14837	015271X	
<b>VP</b>	VP14	015530X	14882	015230X	
	VP16	015531X	14883	015231X	
	VP20	015532X	14884	015232X	
	VP25	015533X	14885	015233X	
	VP32	015534X	14886	015234X	
	<b>B</b>	B3/8"	—	—	015251X
	B1/2"	—	—	015252X	
	B5/8"	—	—	015253X	
	B3/4"	—	—	015254X	
	B1"	—	—	015255X	
	B1 1/4"	—	—	015256X	
<b>BE</b>	BE16	015291X	—	015392X	
	BE20	015292X	—	015394X	
	BE26	015293X	—	015396X	
	BE32	015294X	—	015397X	
	<b>CO</b>	CO12	—	14852	015235X <sup>1)</sup>
	CO16	—	14853	015236X <sup>1)</sup>	
	CO20	—	14854	015237X <sup>1)</sup>	
	CO25	—	14855	015238X <sup>1)</sup>	
	<b>G</b>	G16	015362X	—	015302X
	G20	015364X	—	015304X	
	G26	015366X	—	015306X	
	G32	015367X	—	015307X	
	G40	015368X	—	015308X	
	<b>HA</b>	HA16	015580X	—	015280X
	HA20	015581X	—	015281X	
	HA26	015582X	—	015282X	
	HA32	015583X	—	015283X	
	HA40	—	—	015284X	

Further information at [www.rothenberger.com](http://www.rothenberger.com), <sup>1)</sup> Only available upon request

## Press Jaws Program Overview



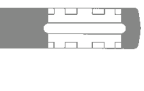






Image	Nominal Size	Press Jaws Compact No.	Press Jaws Pressliner and ROMAX® 3000 No.	Interchangeable Press Jaws Compact No. Use only in combination with interchangeable jaws No. 014800X	ANBO C-Press	APE Raccordi a pressare	BAMPI BALPED, BALPEX	Blansol Barbic easy press	Blansol Barbi multipress	Broen BALLOFIX PRES	BUCCHI tech MP	CO.E.S. Coesklima	COMAP Sudo-Press Multiskin	COMAP Sudo-Press Cu	Comisa Multi layer pipe	DALPEX LaserMulti Dalpex	EMPUR PEXPRESS	eurotherm, MULTISTRATO, Euro 2000	F.B.Q. BARONIO, BQ pres	Fimiso, HAKAPRES, HAKA, GERODUR	Fränkische, alpex F50	Frabo Pressfitting	Gabo, Gabopress H+5	GAROS
	M	M12	015151X	015101X																				
	M15	015152X	015102X		•					•														
	M18	015153X	015103X		•					•														
	M22	015154X	015104X		•					•														
	M28	015155X	015105X		•					•														
	M35		015106X		•																			
	M42		015107X		•																			
	M54		015108X		•																			
	V / SV	V12	015261X	015211X										•								•		
	SV14	015269X	015219X												•					•		•		
	SV15	015262X	015212X							•										•		•		
	SV16	015260X	015220X																	•		•		
	SV18	015263X	015213X							•										•		•		
	SV22	015264X	015214X							•										•		•		
	SV28	015265X	015215X																	•		•		
	SV35		015216X																	•		•		
	SV42		015217X																	•		•		
	SV54		015218X																	•		•		
	G	G16	015362X	015302X																				
	G20	015364X	015304X																					
	G26	015366X	015306X																					
	G32	015367X	015307X																					
	G40	015368X	015308X																					
	HA	HA16	015580X	015280X																				
	HA20	015581X	015281X																					
	HA26	015582X	015282X																					
	HA32	015583X	015283X																					
	HA40		015284X																					
	R (H)	R12		015339X	14863																			
	R14	015370X	015330X	14864																				
	R16	015371X	015331X	14865						•										•		•		
	R17	015378X	015333X	14866																	•			
	R18	015379X	015334X	14867																	•			
	R20	015374X	015335X	14868						•											•		•	
	R25	015380X	015338X	14707						•														
	R26	015376X	015336X	14708																	•		•	
	R32	015377X	015337X	14709						•											•		•	
	RFz	RFz12		1000000173	14822																			
	RFz16	015180X	015161X	14823						•														
	RFz20	015181X	015162X	14824						•														
	RFz25	015182X	015163X	14825						•														
	RFz32	015183X	015164X	14826						•														
	TH	TH14	015395X	015321X	14842		•	•					•			•	•						•	•
	TH16	015385X	015322X	14843		•	•				•		•		•	•	•	•				•	•	•
	TH18	015398X	015323X	14844		•	•				•		•		•	•	•	•				•	•	•
	TH20	015389X	015324X	14845		•	•				•		•		•	•	•	•				•	•	•
	TH25	015399X	015325X	14846																			•	•
	TH26	015391X	015326X	14847		•	•				•		•		•	•	•	•				•	•	•
	TH32	015393X	015327X	14848							•		•		•	•	•	•				•	•	•
	TH40	015401X	015328X											•			•						•	•
THG	THG32	1000000236	1000000235																					
THT	THT32	015393H	015329X										•											
	U	U14	015351X	015311X	14832																			
	U16	015352X	015312X	14833									•											
	U18	015353X	015313X	14834									•											
	U20	015354X	015314X	14835									•											
	U25	015355X	015315X	14836									•											
	U32	015357X	015317X	14838									•											
	U40	015358X	015318X										•											
RC	RC26	015277X	015271X	14837																				
	VP	VP14	015530X	015230X	14882																			
	VP16	015531X	015231X	14883																				
	VP20	015532X	015232X	14884																				
	VP25	015533X	015233X	14885																				
	VP32	015534X	015234X	14886																				

Further information at [www.rothenberger.com](http://www.rothenberger.com)

ROTHENBERGER offers press jaws for a variety of press fitting / pipe systems on the market today. The press contour of each particular system allows reliable pressing to approved standards.

# Bonding








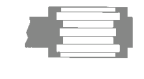


## Press Jaws Program Overview

		Nominal Size	Press Jaws Compact No.	Press Jaws Pressliner and ROMAX® 3000 No.	Interchangeable Press Jaws Compact No. Use only in combination with interchangeable jaws No. 014800X	Geberit Mepla	+GF+ PRESS FIT Nitro San	Giacomini, Giacomflex, Giaco Thermo	HAGE DOMINOX	Harden 2000, Polypex 2000	Henco PVDF	Herz pipefix	HIDROTEC KLIMATEC	Hifec Sistema, Multistrato	Hs System, Heizung	Hs System, Sanitär	IBP>B<-press, >B<-press Gas	Mi Woeste	IPA, IPANA-PRES	IPALPEX (Industry of Plastic and Access)	Jäger, Aquapres	Jaraflex-presssystem	Jupiter, Heizsysteme	KOHLER, InoxPress		
	<b>M</b>	M12	015151X	015101X																						
		M15	015152X	015102X			●												●						●	
		M18	015153X	015103X			●									●				●					●	
		M22	015154X	015104X			●			●										●					●	
		M28	015155X	015105X			●			●										●					●	
		M35		015106X			●			●										●					●	
		M42		015107X			●			●															●	
		M54		015108X			●			●															●	
	<b>V / SV</b>	V12	015261X	015211X			●																			
		SV14	015269X	015219X			●																			
		SV15	015262X	015212X			●																			
		SV16	015260X	015220X			●																			
		SV18	015263X	015213X			●																			
		SV22	015264X	015214X			●																			
		SV28	015265X	015215X			●																			
		SV35		015216X			●																			
		SV42		015217X			●																			
SV54		015218X			●																					
	<b>G</b>	G16	015362X	015302X		●																				
		G20	015364X	015304X		●																				
		G26	015366X	015306X		●																				
		G32	015367X	015307X		●																				
		G40	015368X	015308X		●																				
	<b>HA</b>	HA16	015580X	015280X																						
		HA20	015581X	015281X																						
		HA26	015582X	015282X																						
		HA32	015583X	015283X																						
		HA40		015284X																						
	<b>R (H)</b>	R12		015339X	14863																					
		R14	015370X	015330X	14864																					
		R16	015371X	015331X	14865												●							●		
		R17	015378X	015333X	14866																				●	
		R18	015379X	015334X	14867												●								●	
		R20	015374X	015335X	14868												●								●	
		R25	015380X	015338X	14707																				●	
		R26	015376X	015336X	14708												●								●	
		R32	015377X	015337X	14709												●								●	
	<b>RFz</b>	RFz12		1000000173	14822																					
		RFz16	015180X	015161X	14823																					
		RFz20	015181X	015162X	14824																					
		RFz25	015182X	015163X	14825																					
		RFz32	015183X	015164X	14826																					
	<b>TH</b>	TH14	015395X	015321X	14842			●		●	●	●	●	●												
		TH16	015385X	015322X	14843			●		●	●	●	●	●	●					●	●				●	
		TH18	015398X	015323X	14844			●		●	●	●	●	●	●					●	●				●	
		TH20	015389X	015324X	14845			●		●	●	●	●	●	●					●	●				●	
		TH25	015399X	015325X	14846			●		●	●	●	●	●	●					●	●				●	
		TH26	015391X	015326X	14847			●		●	●	●	●	●	●					●	●				●	
		TH32	015393X	015327X	14848			●		●	●	●	●	●	●					●	●				●	
		TH40	015401X	015328X									●								●	●			●	
		THG32	1000000236	1000000235						●																
	<b>U</b>	THT32	015393H	015329X							●															
		U14	015351X	015311X	14832																					
		U16	015352X	015312X	14833																					
		U18	015353X	015313X	14834																					
		U20	015354X	015314X	14835																				●	
		U25	015355X	015315X	14836																				●	
		U32	015357X	015317X	14838																				●	
		U40	015358X	015318X																					●	
		RC26	015277X	015271X	14837																					
		VP14	015530X	015230X	14882																					
		VP16	015531X	015231X	14883																					
VP20	015532X	015232X	14884																							
VP25	015533X	015233X	14885																							
VP32	015534X	015234X	14886																							

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ROTHENBERGER offers press jaws for a variety of press fitting / pipe systems on the market today. The press contour of each particular system allows reliable pressing to approved standards.

## Press Jaws Program Overview

 Nominal Size Press Jaws Compact No. Press Jaws Pressliner and ROMAX® 3000 No. Interchangeable Press Jaws Compact No. Use only in combination with interchangeable jaws No. 014800X LAVAGRUND, LAVAPRESS Mair Heiztechnik, Gomafix Mapress Edelstahl / Gas Mark KG, polymark MEGARO HAKAPRESS MULTITHERM- PRESSYSTEM NEUTHERM, MEKUPRESS Nupi MultiNupi Nussbaum, Cupress, Cupress G, Optipress Nussbaum, Optiflex Plus O.M.T. Heizungssystem Oventrop, Cofit Pavitherm, MULTISTABIL PIPELIFE RADOPRESS POLYSAN Press-System Prandelli, MULTYRAMA PRASKI BAVARIA-press Raccorderie Metalliche Inoxpress, Steelpres remo RIQUIERA A SERTIR	 M12 M15 M18 M22 M28 M35 M42 M54	015151X 015152X 015153X 015154X 015155X	015101X 015102X 015103X 015104X 015105X 015106X 015107X 015108X																							
	 V / SV V12 SV14 SV15 SV16 SV18 SV22 SV28 SV35 SV42 SV54	V12	015261X	015211X																						
SV14		015269X	015219X																							
SV15		015262X	015212X																							
SV16		015260X	015220X																							
SV18		015263X	015213X																							
SV22		015264X	015214X																							
SV28		015265X	015215X																							
SV35			015216X																							
SV42		015217X																								
SV54		015218X																								
 G G16 G20 G26 G32 G40	G16	015362X	015302X																							
	G20	015364X	015304X																							
	G26	015366X	015306X																							
	G32	015367X	015307X																							
	G40	015368X	015308X																							
 HA HA16 HA20 HA26 HA32 HA40	HA16	015580X	015280X																							
	HA20	015581X	015281X																							
	HA26	015582X	015282X																							
	HA32	015583X	015283X																							
	HA40		015284X																							
 R (H) R12 R14 R16 R17 R18 R20 R25 R26 R32	R12		015339X	14863																						
	R14	015370X	015330X	14864		•			•													•			•	
	R16	015371X	015331X	14865		•			•		•											•			•	
	R17	015378X	015333X	14866					•																•	
	R18	015379X	015334X	14867					•		•												•		•	
	R20	015374X	015335X	14868		•			•		•												•		•	
	R25	015380X	015338X	14707																					•	
	R26	015376X	015336X	14708		•			•		•												•		•	
	R32	015377X	015337X	14709		•			•		•												•		•	
 RFz RFz12 RFz16 RFz20 RFz25 RFz32	RFz12		1000000173	14822																					•	
	RFz16	015180X	015161X	14823																					•	
	RFz20	015181X	015162X	14824																					•	
	RFz25	015182X	015163X	14825																					•	
	RFz32	015183X	015164X	14826																					•	
 TH TH14 TH16 TH18 TH20 TH25 TH26 TH32 TH40	TH14	015395X	015321X	14842		•																				
	TH16	015385X	015322X	14843		•			•		•											•				
	TH18	015398X	015323X	14844							•															•
	TH20	015389X	015324X	14845		•			•		•												•			•
	TH25	015399X	015325X	14846																						
	TH26	015391X	015326X	14847		•			•		•												•			•
	TH32	015393X	015327X	14848		•			•														•			•
TH40	015401X	015328X			•																				•	
THG	THG32	1000000236	1000000235																							
THT	THT32	015393H	015329X																							
 U U14 U16 U18 U20 U25 U32 U40	U14	015351X	015311X	14832																						
	U16	015352X	015312X	14833																						
	U18	015353X	015313X	14834																						
	U20	015354X	015314X	14835																						
	U25	015355X	015315X	14836																						
	U32	015357X	015317X	14838																						
	U40	015358X	015318X																							•
 RC VP	RC26	015277X	015271X	14837																						
	VP14	015530X	015230X	14882																						
	VP16	015531X	015231X	14883																						
	VP20	015532X	015232X	14884																						
	VP25	015533X	015233X	14885																						
	VP32	015534X	015234X	14886																						








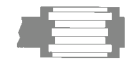


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# Bonding











## Press Jaws Program Overview

	Nominal Size	Press Jaws Compact No.	Press Jaws Pressliner and ROMAX® 3000 No.	Interchangeable Press Jaws Compact No. Use only in combination with interchangeable jaws No. 014800X	Roth Sistema Rothapress	Roth-Roth Rohr-Installationssysteme	SANHA Pressfittings, NiroSan Presssystem	Schlösser, Armaturen EUROPRESS SYSTEM	SCHÜTZ EHT Ropress	Seppelfricke Distributione MTSD	Seppelfricke System-technik SST Delphi Press	SIKO TYPRO Tyrotherm	Simplex SiRoCon Cu / E	Simplex SiRoCon PPSU H	Simplex SiRoCon PPSU TH	SST-Rolltec Delphi-Press	STS Systemtechnik	System PREXTO	THERMAGAS Espace Express	THERMOLUTZ Acular, Rapid	THERMOVAL, THERMOSMART	Tiemme, Serie PA / PG	Tiemme, Cobrapress
	<b>M</b>	M12	015151X	015101X																			
	M15	015152X	015102X																				
	M18	015153X	015103X																				
	M22	015154X	015104X																				
	M28	015155X	015105X																				
	M35		015106X																				
	M42		015107X																				
M54		015108X																					
	<b>V / SV</b>	V12	015261X	015211X																			
	SV14	015269X	015219X																				
	SV15	015262X	015212X																				
	SV16	015260X	015220X																				
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	SV22	015264X	015214X																				
	SV28	015265X	015215X																				
	SV35		015216X																				
SV42		015217X																					
SV54		015218X																					
	<b>G</b>	G16	015362X	015302X																			
	G20	015364X	015304X																				
	G26	015366X	015306X																				
	G32	015367X	015307X																				
	G40	015368X	015308X																				
	<b>HA</b>	HA16	015580X	015280X																			
	HA20	015581X	015281X																				
	HA26	015582X	015282X																				
	HA32	015583X	015283X																				
	HA40		015284X																				
	<b>R (H)</b>	R12		015339X	14863																		
	R14	015370X	015330X	14864																			
	R16	015371X	015331X	14865																			
	R17	015378X	015333X	14866																			
	R18	015379X	015334X	14867																			
	R20	015374X	015335X	14868																			
	R25	015380X	015338X	14707																			
	R26	015376X	015336X	14708																			
R32	015377X	015337X	14709																				
	<b>RFz</b>	RFz12		1000000173	14822																		
	RFz16	015180X	015161X	14823																			
	RFz20	015181X	015162X	14824																			
	RFz25	015182X	015163X	14825																			
	RFz32	015183X	015164X	14826																			
	<b>TH</b>	TH14	015395X	015321X	14842																		
	TH16	015385X	015322X	14843																			
	TH18	015398X	015323X	14844																			
	TH20	015389X	015324X	14845																			
	TH25	015399X	015325X	14846																			
	TH26	015391X	015326X	14847																			
	TH32	015393X	015327X	14848																			
	TH40	015401X	015328X																				
<b>THG</b>	THG32	1000000236	1000000235																				
<b>THT</b>	THT32	015393H	015329X																				
	<b>U</b>	U14	015351X	015311X	14832																		
	U16	015352X	015312X	14833																			
	U18	015353X	015313X	14834																			
	U20	015354X	015314X	14835																			
	U25	015355X	015315X	14836																			
	U32	015357X	015317X	14838																			
	U40	015358X	015318X																				
<b>RC</b>	RC26	015277X	015271X	14837																			
	<b>VP</b>	VP14	015530X	015230X	14882																		
	VP16	015531X	015231X	14883																			
	VP20	015532X	015232X	14884																			
	VP25	015533X	015233X	14885																			
	VP32	015534X	015234X	14886																			

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## Press Jaws Program Overview

	Nominal Size	Press Jaws Compact No.	Press Jaws Pressliner and ROMAX® 3000 No.	Interchangeable Press Jaws Compact No. Use only in combination with interchangeable jaws No. 014800X	TKM Fellingsbro TKM Press	Ulrich VARIOFLEX HAKA-PRESS	UFONOR UNIPipe, UNICORE, Airpipe	Valsir PEXAL	Vescal, Metallplast	Viega Profipress Therm press G, profipress Therm	Viega sanpress, sanpress INO	Viega sanfix FOSTA, P, PLU5	Viessmann	VSH CU-press, CU-press Gas	Watts MTR Art press	Wavin FUTURE 1/2, TIGRIS TIGRIS Alupex / Blue	WEFA PLASTIC, WEFA PRESS	WEM	Winkler	WKS	WOESTE "Yorkshire" RYW PRESS, RYW Gas press	
	M	M12	015151X	015101X																		
		M15	015152X	015102X											•							•
		M18	015153X	015103X											•							•
		M22	015154X	015104X											•							•
		M28	015155X	015105X											•							•
		M35		015106X											•							•
	M42		015107X											•								
	M54		015108X											•								
	V / SV	V12	015261X	015211X						•	•											
		SV14	015269X	015219X						•	•											
		SV15	015262X	015212X						•	•											
		SV16	015260X	015220X						•	•											
		SV18	015263X	015213X						•	•											
		SV22	015264X	015214X						•	•											
		SV28	015265X	015215X						•	•											
		SV35		015216X						•	•											
	SV42		015217X						•	•												
	SV54		015218X						•	•												
	G	G16	015362X	015302X																		
		G20	015364X	015304X																		
		G26	015366X	015306X																		
		G32	015367X	015307X																		
		G40	015368X	015308X																		
	HA	HA16	015580X	015280X																		
		HA20	015581X	015281X																		
		HA26	015582X	015282X																		
		HA32	015583X	015283X																		
		HA40		015284X																		
	R (H)	R12		015339X	14863																	
		R14	015370X	015330X	14864	•	•	•														
		R16	015371X	015331X	14865	•	•	•									•	•				
		R17	015378X	015333X	14866	•	•															
		R18	015379X	015334X	14867	•	•															
		R20	015374X	015335X	14868	•	•	•									•					
		R25	015380X	015338X	14707																	
		R26	015376X	015336X	14708	•	•	•										•				
	R32	015377X	015337X	14709	•	•	•										•					
	RFz	RFz12		1000000173	14822																	
		RFz16	015180X	015161X	14823																	
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		RFz32	015183X	015164X	14826																	
	TH	TH14	015395X	015321X	14842								•									
		TH16	015385X	015322X	14843								•		•							
		TH18	015398X	015323X	14844																	
		TH20	015389X	015324X	14845									•		•						
		TH25	015399X	015325X	14846																	
		TH26	015391X	015326X	14847									•		•						
		TH32	015393X	015327X	14848									•		•						
		TH40	015401X	015328X										•								
THG	THG32	1000000236	1000000235																			
THT	THT32	015393X	015329X																			
	U	U14	015351X	015311X	14832																	
		U16	015352X	015312X	14833																	
		U18	015353X	015313X	14834			•	•								•					
		U20	015354X	015314X	14835			•	•								•					
		U25	015355X	015315X	14836			•	•								•					
		U32	015357X	015317X	14838			•	•								•					
		U40	015358X	015318X				•	•								•					
RC	RC26	015277X	015271X	14837																		
	VP	VP14	015530X	015230X	14882							•										
		VP16	015531X	015231X	14883							•										
		VP20	015532X	015232X	14884							•										
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# Bonding

## Threading Manual

### SUPER CUT

#### Ratchet threader Ø 1/4 - 2"

For production of precise and reliable thread connections according to DIN EN 10226



#### Product Profile

##### APPLICATION AREA

For precision thread cutting of

**BSPT right:** Ø 1/4 - 2"

##### KEY FEATURES

- Slim, compact design with excellent overall size, ratchet angle of 22.5°
- Easy operation in hard-to reach places with the offset lever
- Convenient, lockable reversal of the ratchet direction
- Extremely long service life
- Simple insertion and removal of die heads
- Secure hold with retainer locking
- Perfect centering through the long pipe guide is ensured
- Optimised cutting geometry allows a gentle first cut and excellent chip discharge

**Power optimisation with the offset hand lever!**

#### Quick Change Die Heads

##### Secure hold

Positive octagonal universal drive with retainer locking

##### Fits all ROTHENBERGER Manual and Power Threaders

Simple insertion and removal of the die heads

4



#### Long lever

Optimum force transfer

#### Offset lever

Easy operation in hard-to-reach places

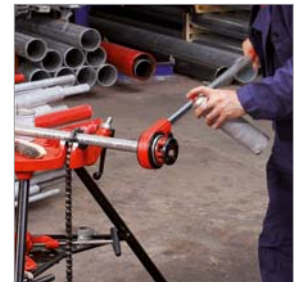
#### Quick adjustment

Convenient, lockable reversal of the ratchet direction

#### Precision Dies

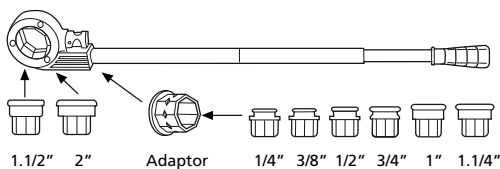
Made of high quality tempered steel  
Extremely long service life

*SUPER CUT when working at the building site*



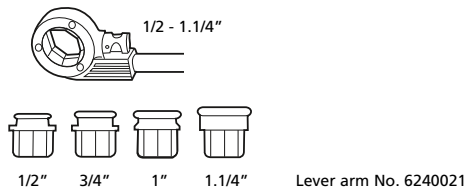
Monoblock - adaptor (No. 71273)

With ratchet handle 1/4" - 2" the attachment of the 1/4" - 1.1/4" die head results with the use of the adaptor (No. 71273)



### SUPER CUT – Sets Ø 3/8 - 1.1/4"

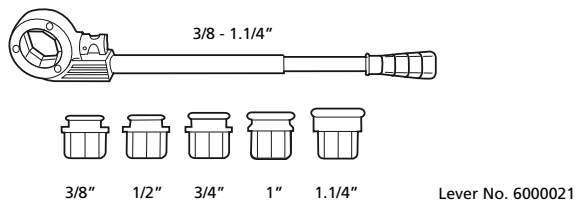
With ratchet handle (small octagonal drive, No. 070840X), die heads in plastic carrying case (No. 70780)



Model	Size	kg	No.
BSPT R	1/2" - 3/4" - 1" - 1.1/4"	5.1	<b>070781X</b>

### SUPER CUT – Sets Ø 3/8 - 1.1/4"

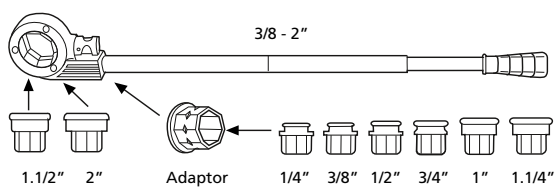
With ratchet handle (small octagonal drive, No. 070840X), and die heads in plastic carrying case



Model	Size	kg	No.
BSPT R	3/8" - 1/2" - 3/4" - 1" - 1.1/4"	6.2	<b>070790X</b>
BSPT R	1/2" - 3/4" - 1"	4.2	<b>070780X</b>

### SUPER CUT – Sets Ø 3/8 - 2"

With ratchet handle (large octagonal drive, No. 71272), die head adaptor (No. 71273), die heads in plastic carrying case (No. 070928X)



Model	Size	kg	No.
BSPT R	3/8" - 1/2" - 3/4" - 1" - 1.1/4" - 1.1/2" - 2"	11.4	<b>070891X</b>
BSPT R	1/2" - 3/4" - 1" - 1.1/4" - 1.1/2" - 2"	10.8	<b>070892X</b>

#### ACCESSORIES

Description	No.
Die heads 1/4 - 2"	<b>122</b>
Dies 1/4 - 2"	<b>122</b>
Cutting fluid	<b>123</b>
Pipe roughing wrench	<b>133</b>



# Bonding

## Threading Manual

### SANI KIT

Tool set in sturdy plastic carrying case

Ideal for repair and installation jobs requiring complete steel pipe processing



**Professional!**

#### Product Profile

##### APPLICATION AREA

<b>Cutting:</b>	up to Ø 1.1/4"
<b>Thread cutting:</b>	up to Ø 1"
<b>Assembly, screwing, loosening, sealing of thread connections:</b>	up to Ø 1.1/4"

##### KEY FEATURES

- Light and easy to use, always within reach
- Secure guiding of the cutter wheel on the pipe
- Reliable grip with the s-shaped jaw
- Firm grip even with heavy-duty use
- Long service life
- Precise thread cutting to approved standards
- Perfect alignment

4



### Steel Pipe Cutter Super 1.1/4"

Wide rollers

Secure guiding of the cutter wheel on the pipe

### Corner Pipe Wrench Super S

Slim, s-shaped jaw

Firm grip



### SUPER CUT Ratchet Threader

With SUPER CUT ratchet handle 1.1/4"

Perfect alignment

Small outer octagon, BSPT R 1/2 - 3/4 - 1"

Precise thread cutting to approved standards

### Water Pump Pliers Type SP

With heavy duty box joint, chrome vanadium steel, drop-forged, tempered

Long service life

Polished head and joint

Firm grip even with heavy-duty use

### SANI KIT

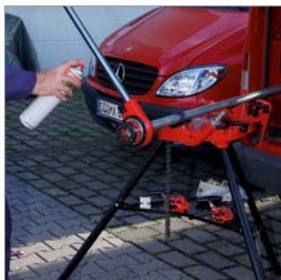
#### Tool carrying case

Ideal for repair and installation jobs requiring complete steel pipe processing



**The ideal installation set!**

SANI KIT when working at the building site with RONOL®



10-part set (No. 70600) includes: SUPER CUT ratchet threader 1.1/4" (No. 070840X), quick-change die heads BSPT R 1/2" (No. 070823X) - 3/4" (No. 070824X) - 1" (No. 070825X), steel pipe cutter SUPER 1.1/4" (No. 70040), water pump pliers type SP 10" (No. 70528), corner pipe wrench 1" (No. 070122X) as well as teflon tape (No. 855360), in plastic carrying case



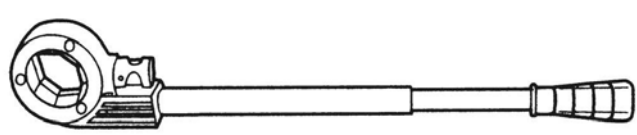
Description	kg	No.
SANI KIT Tool set	8.2	70600

### SUPER CUT Ratchet Arm

With offset adaptor



Direct seating for die heads	via adaptor for die heads	Handle	kg	No.
1/4" - 1.1/4"	-	2-piece	1.7	070840X
1.1/2" - 2" (no fig.)	1/4" - 1.1/4"	3-piece	2.5	71272



#### ACCESSORIES

Description	No.
Die heads 1/4 - 2"	122
Dies 1/4 - 2"	122
Cutting fluid	123
Pipe roughing wrench	133



# Bonding

## Threading Electric

### SUPERTRONIC® 1250

Power threader Ø 1/4 - 1.1/4"

For quick and effortless production of precise and reliable thread connections to approved standards



#### Product Profile

##### APPLICATION AREA

For threading of

<b>BSPT right:</b>	Ø 1/2 - 1.1/4"
<b>Optional:</b> (not included in set)	Ø 1/4", 3/8"
<b>NPT:</b>	Ø 1/4 - 1.1/4"

##### KEY FEATURES

- Ideal for confined spaces (corners, shafts)
- Sturdy and light, even with heavy-duty use
- Compact gear housing with excellent overall size
- High power transmission, quiet running with long service life
- Tough, rugged and durable
- Weight reduction and easy handling

##### KEY FEATURES

- Die can be used in both directions (left, right)
- Stable speed by forward and reverse motion

##### TECHNICAL DATA

<b>Threading speed:</b>	15 - 20 min <sup>-1</sup>
<b>Rapid reverse speed:</b>	27 min <sup>-1</sup>
<b>Performance:</b>	800 Watt
<b>Current:</b>	230 V/110 V
<b>Weight:</b>	4.9 kg
<b>Dimensions:</b>	456 x 168 x 76 mm



Compact design, only 4.9 kg, ideal for portable operation



Small head shape (11 cm)



Pipe roughing



### SUPERTRONIC® 1250 Set

Sets include: SUPERTRONIC® 1250 up to Ø 1.1/4" with forged pipe clamp (No. 71279), precision die heads complete in plastic carrying case (No. 995858100)

**Small – Fast – Light (1/4 - 1. 1/4")!**



Pipe clamp

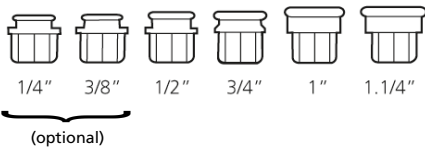
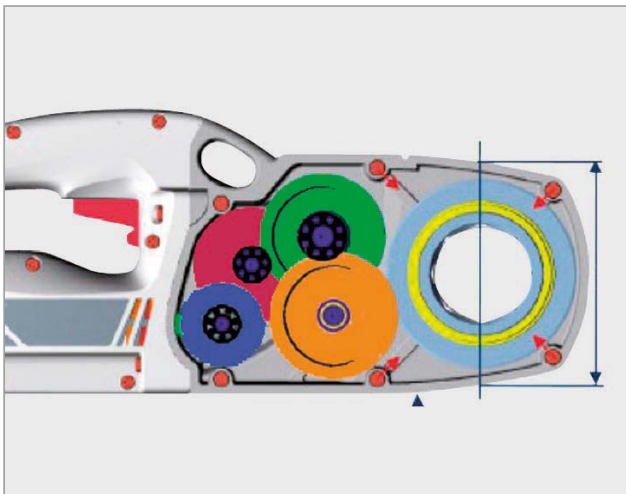


Fig. SUPERTRONIC® 1250 Set (No. 71450)



Model	Description	kg	Ⓛ	230 V	110 V
SUPERTRONIC® 1250 Set	BSPT 1/2" - 3/4" - 1" - 1.1/4"	14.5	1	<b>71450</b>	<b>71451</b>
SUPERTRONIC® 1250 Set	1/2 - 1.1/4" NPT	13.0	1	<b>71454</b>	<b>71453</b>
SUPERTRONIC® 1250	with forged pipe clamp, without die heads	3.9	1	<b>71470</b>	
Pipe clamp for SUPERTRONIC® 1250	up to max. 1.1/4"	1.6	1	<b>71279</b>	<b>71279</b>

Helical gears for maximum power (800 watt)



Steel pipe processing portable, fast and easy



### ACCESSORIES

Description	Ⓛ
Die heads 1/4 - 2"	<b>122</b>
Dies 1/4 - 2"	<b>122</b>
Cutting fluid	<b>123</b>
Pipe roughing wrench	<b>133</b>



# Bonding

## Threading Electric

### SUPERTRONIC® 2000

#### Power threader Ø 1/4 – 2"

For quick and effortless production of precise and reliable thread connections to approved standards



#### Product Profile

##### APPLICATION AREA

For threading of

**BSPT right, BSPT left:**

Ø 1/4 - 2"

**NPT:**

Ø 1/4 - 2"

**High reduction gears with spur wheel teeth**, induction tempered, 7 parallel gear shafts, each ball bearing mounted

**High, consistent power transmission** when fully loaded

##### Performance:

Strong 1010 W motor, double insulated with VDE and CEE, interference free for reliable long-term use

##### Threading speed:

15 - 25 min<sup>-1</sup>, rapid reverse 60 min<sup>-1</sup>

(4 x faster reverse with reverse drive)

**Maintenance friendly** with continuous lubrication

##### KEY FEATURES

- Secure grip in both turning directions with the hardened, interlocking prism pipe clamp
- Die heads are held firmly in place through direct seating with tension ring locking
- Off-set die head mounting allows for threading even close to walls
- Ideal for confined spaces (corners, shafts)
- User friendly work with the large mechanism for switching directions
- Reliable motor for long-term use

4



Easy insertion of the die heads



Use with roll grooving tool ROGROOVER



ROFIX adaptor (No. 71271)



High reduction gears



### SUPERTRONIC® 2000 Set

Sets include: SUPERTRONIC® 2000 with pipe clamp (No. 71280), ROFIX-Adaptor (No. 71271), and precision die heads, complete in plastic carrying case (No. 071274X)

**Can also be used in combination with a roll grooving tool!**



Pipe clamp

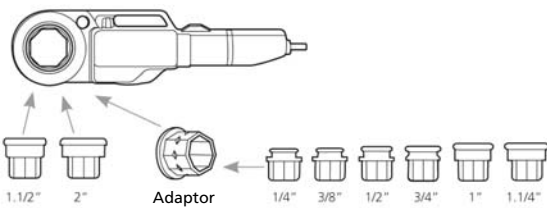


Fig. Similar, SUPERTRONIC® 2000 Set



Description	Model	kg		230 V	110 V
SUPERTRONIC® 2000 Set, BSPT R	1/2" - 3/4" - 1" - 1.1/4" - 1.1/2" - 2"	14.5	1	<b>71256</b>	<b>71258</b>
SUPERTRONIC® 2000 Set, NPT	1/2" - 3/4" - 1" - 1.1/4" - 1.1/2" - 2"	14.5	1	<b>71257</b>	<b>71259</b>
SUPERTRONIC® 2000	with forged pipe clamp, without die heads	6.8	1	<b>71250</b>	<b>71251</b>

#### Work in confined spaces



#### Die heads with the tripod universal workbench



### ACCESSORIES

Description	
Die heads 1/4 - 2"	<b>122</b>
Dies 1/4 - 2"	<b>122</b>
Cutting fluid	<b>123</b>
Pipe roughing wrench	<b>133</b>





# Bonding

## Threading Electric



### Precision Die Heads

#### With enlarged shaving discharge chambers

For faster threading, reinforced locking plate and precise die seating. Fits in ROTHENBERGER SUPERTRONIC® 1000, SUPERTRONIC® 1250, SUPERTRONIC® 2000 and SUPER CUT threaders

BSPT R	No.	NPT	No.
1/4"	<b>070821X</b>	1/4"	<b>070907X</b>
3/8"	<b>070822X</b>	3/8"	<b>070908X</b>
1/2"	<b>070823X</b>	1/2"	<b>070912X</b>
3/4"	<b>070824X</b>	3/4"	<b>070913X</b>
1"	<b>070825X</b>	1"	<b>070914X</b>
1.1/4"	<b>070826X</b>	1.1/4"	<b>070915X</b>
1.1/2"	<b>070842X</b>	1.1/2"	<b>070849X</b>
2"	<b>070843X</b>	2"	<b>070850X</b>

### Threading Dies

#### Precision Threading Dies

- Gentle first cut, extremely long life, 4 pieces / pack
- Optimum results are achieved with original ROTHENBERGER thread cutting fluid



BSPT R	No.	NPT	No.
1/4"	<b>070831X</b>	1/4"	<b>070916X</b>
3/8"	<b>070832X</b>	3/8"	<b>070917X</b>
1/2"	<b>070833X</b>	1/2"	<b>070918X</b>
3/4"	<b>070834X</b>	3/4"	<b>070919X</b>
1"	<b>070835X</b>	1"	<b>070920X</b>
1.1/4"	<b>070836X</b>	1.1/4"	<b>070921X</b>
1.1/2"	<b>070869X</b>	1.1/2"	<b>070945X</b>
2"	<b>070870X</b>	2"	<b>070946X</b>

### ROFIX Adaptor

Fits small external octagonal die heads from Ø 1/4" up to 1.1/4"

- Easy insertion of the die head with tension ring locking

*Tension ring locking*



Description	kg	No.
ROFIX Adaptor with locking ring	0.8	<b>71271</b>

### RONOL®

#### High-performance cutting oil

##### Product Profile

##### KEY FEATURES

- Excellent cooling and lubricating properties
- Durability of the threading die is increased considerably
- For perfect, clean threads
- Safe for skin contact
- Also suitable as cold lubrication when cutting metal

##### TECHNICAL DATA

##### Mineral oil basis

**For threading** of all materials including stainless steel

**Emulsifying agent** enables easy rinsing of the pipeline without unhealthy polychlorinated Biphenyl (PCB)

**Mineral-based cutting oil is not permitted for drinking water installations - Please check your national regulations!**

Model	Contents	kg	kg	kg	No.
RONOL® Spray can	600 ml	0.75	12	65008	
RONOL® Canister	5 l	5.20	4	65010	



4



### RONOL® SYN

#### High-performance cutting fluid

##### Product Profile

##### KEY FEATURES

- Excellent cooling and lubricating properties
- Able to handle high pressure
- Longer life for the cutting tool
- Safe for skin contact
- Also suitable as cold lubrication when cutting metal

##### TECHNICAL DATA

**No mineral oils**, purely synthetic:

Developed and approved for drinking water and plumbing installations. DVGW tested. SVGW tested (Reg. No. 9908-4126)

**100% water soluble**, physiologically neutral, silicone-free: easily washable

**Emulsifying agent** enables easy rinsing of the pipeline

**No build-up of shavings:** Perfect cooling quality

**Good corrosion protection:** No rusting

**Undiluted application**

**High polymer, without EP-additives** such as sulphur, phosphorus or chlorine: increased cutting performance

Model	Contents	kg	kg	kg	No.
RONOL® SYN Spray can	600 ml	0.75	12	65013	
RONOL® SYN Canister	5 l	5.20	4	65015	



# Bonding

## Threading Electric

### ROPOWER® 50 R

#### Portable compact threader Ø 1/4 - 2"

Quick and effortless production of precise and reliable pipe and bolt threads to approved standards



#### Product Profile

##### APPLICATION AREA

Use on building sites, for repairs and service, industrial use and for installation work

##### For threading of:

<b>BSPT right:</b>	Ø 1/4 - 2"
<b>NPT:</b>	Ø 1/4 - 2"
<b>BSPP:</b>	Ø 1/2 - 2"
<b>BSW:</b>	Ø 3/8 - 2"
<b>Metric:</b>	Ø 10 - 24 mm

##### KEY FEATURES

- Quick and reliable threading, trimming, deburring, and grooving
- Effortless and comfortable transport with the light, navigable working carriage, which also serves as workbench
- Complete pre- and post-processing of pipe
- Easy to maintain machine design
- Die head Type R (automatic with integrated oil feed)
- Portable transport frame (standard)

##### TECHNICAL DATA

<b>Performance:</b>	1,150 Watt
<b>Speed:</b>	40 m <sup>-1</sup>
<b>Weight:</b>	68 kg
<b>Dimensions (L x W x H):</b>	535 x 430 x 340 mm

4



#### Pre- and post-processing of pipe

##### Self-centering pipe cutter

Precise cuts

##### Internal deburrer, snap in, 3-blade

Burr-free work

##### Impact hammer chuck with maximal clamping-force

No pipe slippage

##### Self-centering rear chuck

Quick and precise alignment of the pipe

#### Easy to maintain machine design

##### Motor double insulated in accordance with VDE

Safe operation

##### Stable high torque motor

Constant power transferral

##### Off-set spindle lubrication

Easy maintenance

##### Machine slightly angled

Reduced oil consumption, oil coating in pipe interior is avoided

Original RIDGID<sup>1)</sup> threading dies can optionally be used!



##### Geared oil pump with filter system and adjustable fluid qualities

Constant oil flow quantities

##### Amplly dimensioned large plastic shavings collection trough

Easy to clean

1) RIDGID® is a registered trade mark of the Emerson Electric Co., St. Louis, USA

### ROPOWER® 50 R

Scope of delivery: ROPOWER® 50 R, automatic die head 1/2" - 2" (No. 56052), SS dies BSPT 1/2" - 3/4" (No. 056370X), 1" - 2" (No. 056371X), safety foot switch (No. 56335), collapsible stand (No. 56051), tool

#### Transportation Frame

(Included in delivery)

Carriage with storage space and a mount for the foot switch

Clearly arranged work

Collapsible undercarriage

Comfortable transport

With 2 plastic wheels

High mobility

Safety foot switch (No. 56335)

Increased safety

#### Die Head Type R

Automatic die head with integrated oil feed

Long life of the die heads

Optimal lubrication and cooling of the die heads

Long life



Fig. Collapsible stand (No. 56051) included in delivery!



Automatic die head with integrated oil supply



High mobility



Thread roughing



Cost-effective production of grooves



Model	Volt	⊞	kg	No.
ROPOWER® 50 R with automatic die head:				
BSPT R 1/2 - 3/4", 1-2"	230 V	1	88.5	<b>56050</b>
BSPT R 1/2 - 3/4", 1-2"	110 V	1	88.5	<b>56045</b>
BSPP R 1/2 - 3/4", 1-2"	230 V	1	88.5	<b>56057</b>
Collapsible Stand ROPOWER® 50 R		1	19.2	<b>56051</b>
Spare cutting wheel (PANDA 40, PANDA 90, PISET 3 SG, Nr. 6 SC 2 S, 2 SE, 3 S, 3 SE, 4 S, 4 SE)		1	0.02	<b>70074</b>
Supporting bolt for transport frame (contents 4 pieces)			0.7	<b>56049</b>
Supporting legs (contents 4 pieces)			5.0	<b>56488</b>

#### ACCESSORIES

Description	📖	No.
Cutting fluid	<b>123</b>	
Automatic die heads	<b>128</b>	
Dies	<b>128</b>	
NIPPLE MAX	<b>133</b>	
Pipe roughing wrench	<b>133</b>	<b>56500</b>
ROGROOVER 1-6"	<b>134</b>	<b>56505</b>



# Bonding

## Threading Electric

### SUPERTRONIC® 2 SE / 3 SE / 4 SE

Compact threader Ø 1/4 - 4"

Reliable and proven for constant professional use

Can also be used in combination with a roll grooving tool!



#### Product Profile

##### APPLICATION AREA

- Ideal for portable and stationary threading in the workshop, on-site, for repairs and service, trade and industry, pipeline construction, as well as for sanitary and heating installations
- Universal application, with or without stand, i.e. on a workbench

##### For threading of:

<b>BSPT right:</b>	Ø 1/4 - 4"
<b>NPT:</b>	Ø 1/4 - 4"
<b>BSPP:</b>	Ø 1/2 - 4"
<b>BSW:</b>	Ø 3/8 - 2"
<b>Metric:</b>	Ø 10 - 36 mm
	Ø 10 - 24 mm (2 SE)

##### KEY FEATURES

- Universal die head seating (standard or automatic)
- Precise guiding of the die head
- Low-wear and precise guiding
- Fast axial alignment of the pipe
- No pipe slippage with impact hammer chuck
- Burr-free work

4



Smooth action impact hammer chuck with maximal clamping force

No pipe slippage

Self-centering rear chuck

Axial alignment of the pipe

Working spindle with closed bearings on both sides

Low-wear and precise guiding

Dual-sided tool guide sled

Precise guiding of the die head

Tool / guide sled propulsion via turnstile

Finely controlled propulsion

Internal deburrer, snap in, 3-blade

Burr-free work



Modular system concept

Universal die head adaptor, optional in standard or automatic models

Sturdy oil pump with high flow power and adjustable fluid quantities, filter system integrated oil feed

Optimal lubrication and cooling

Large shavings collection trough made of plastic

Easy to clean

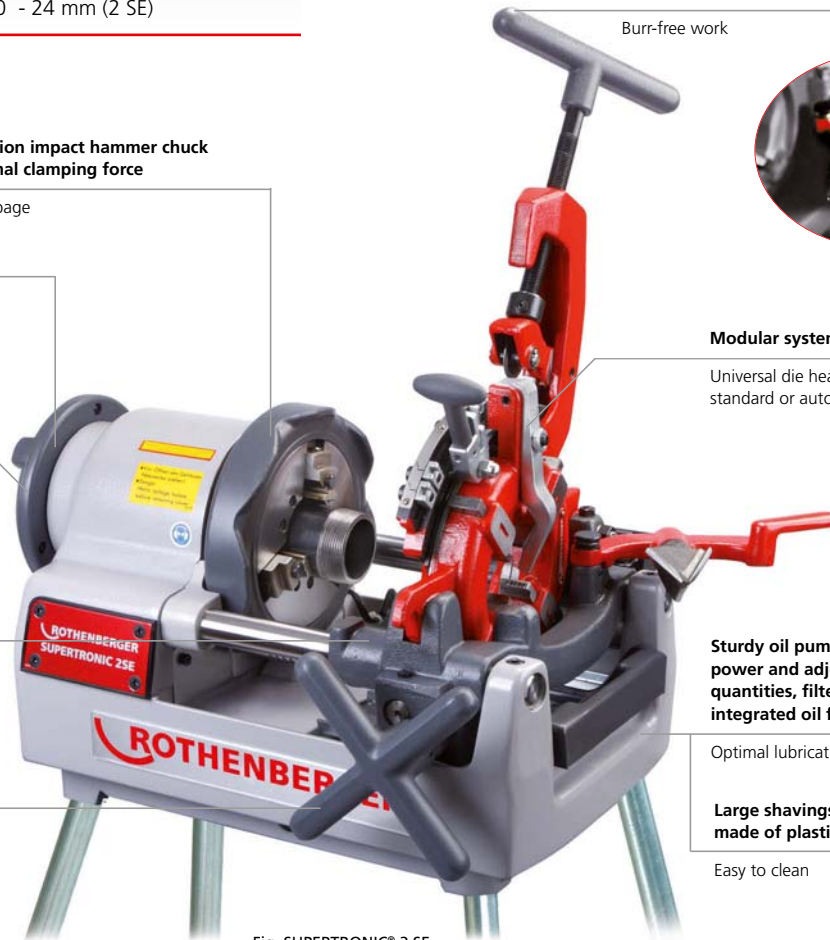


Fig. SUPERTRONIC® 2 SE

Impact hammer chuck with inter-changeable clamping jaw, optimal clamping properties through flexible adjustment and broad support



Automatic die heads with quick adjustment of thread size automatic thread length, finely adjustable thread depth without recentering

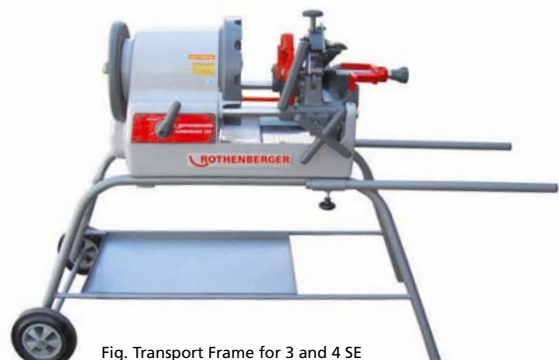


Fig. Transport Frame for 3 and 4 SE (No. 57050)

### SUPERTRONIC® 2 SE

Compact threader Ø 1/2 - 2"

Standard Die Head: 1/2 - 2" (No. 56156)  
Automatic Die Head 1/2 - 2" (No. 56266)

#### TECHNICAL DATA

Motor strength:	1,150 Watt
Speed:	40 m <sup>-1</sup>
Weight, with die heads:	68 kg
Dimensions (L x W x H):	535 x 430 x 340 mm

Scope of delivery: SUPERTRONIC 2 SE, automatic die head 1/2 - 2" (No. 56165) or automatic die head (No. 56266), SS threading dies 1/2 - 3/4" (No. 56003), 1 - 2" (No. 56007), safety foot switch (No. 56335), supporting legs (No. 56488), tool

SUPERTRONIC® 2 SE	kg	230 V	110 V
with Standard Die Head	68	56150	56120
BSPT R 1/2 - 3/4", 1 - 2"			
with Automatic Die Head	68	56175	56125
BSPT R 1/2 - 3/4", 1 - 2"			



SUPERTRONIC® 2 SE	230 V	110 V
Deburrer without holder 2 SE	56198	56198
Supporting legs (contains 4 pieces)	56488	56488

### SUPERTRONIC® 3 SE

Compact threader Ø 1/2 - 3"

Standard Die Head: 1/2 - 2" (No. 56156), 2 - 3" (No. 56104)  
Automatic Die Head: 1/2 - 2" (No. 56266), 2.1/2 - 3" (No. 56288)

#### TECHNICAL DATA

Motor strength:	1,700 Watt
Speed:	33 m <sup>-1</sup>
Weight, with die heads:	100 kg
Dimensions (L x W x H):	650 x 480 x 420 mm

Scope of delivery: SUPERTRONIC 3 SE, standard die heads 1/2 - 2" (No. 56156) or automatic die heads (56266), standard die head 2 - 3" (No. 56104) or automatic die head 2 1/2 - 3" (56288), SS threading dies 1/2 - 3/4" (No. 56003), 1 - 2" (No. 56007), SS threading dies 2 - 3" (No. 56006), SS threading dies 2 1/2 - 3" (No. 56489), safety foot switch (No. 56335), supporting legs (No. 56491), tool

SUPERTRONIC® 3 SE	kg	230 V	110 V
with Standard Die Head	100	56250	56253
BSPT R 1/2 - 3/4", 1 - 2", 2 - 3"			
with Automatic Die Head	100	56255	56254
BSPT R 1/2 - 3/4", 1 - 2", 2.1/2 - 3"			



SUPERTRONIC® 3 SE	kg	230 V	110 V
Deburrer without holder 3 SE		56199	56199

### SUPERTRONIC® 4 SE

Compact threader Ø 1/2 - 4"

SUPERTRONIC® 4 SE with Automatic Die Head

#### TECHNICAL DATA

Motor strength:	1,750 Watt
Speed:	22 / 50 m <sup>-1</sup>
Weight, with die heads:	120 kg
Dimensions (L x W x H):	750 x 540 x 480 mm

Scope of delivery: SUPERTRONIC 4 SE, BSPT automatic die head 1/2 - 2" (No. 56266), BSPT automatic die head 2 1/2 - 4" (No. 56289), SS threading dies 1/2 - 3/4" (No. 56003), SS threading dies 1 - 2" (No. 56007), SS threading dies 2 1/2 - 4" (No. 56294), safety foot switch (No. 56335), supporting legs (No. 56489), tool,

SUPERTRONIC® 4 SE	kg	230 V	110 V
with Automatic Die Head	120	56465	56475
BSPT R 1/2 - 3/4", 1 - 2", 2.1/2 - 4"			
Deburrer Blade 4 SE		56200	56200
Transport Frame for 3 and 4 SE	25	57050	



# Bonding

## Threading Electric



### Precision Die Heads

For machine types ROPOWER® 50 R, PANDA, PISET, SUPERTRONIC® 2 S, 2 SE, 3 S, 3 SE, 4 S, 4 SE

#### Product Profile

##### KEY FEATURES

###### Standard die heads

- Time saving with a simple and quick change of the threading dies
- User friendly with the locking positioning which eliminates complicated calibration
- Longer life of the dies with the integrated lubrication
- Guaranteed consistent cutting oil film on the pipe surface

#### Product Profile

##### KEY FEATURES

###### Automatic die heads


- Simple and clear operation with the quick-adjustment thread sizes
- Automatic adjustable thread length for serial production
- Flexible work: Each thread size offers individual fine adjustment of the thread depth without recentering dimension change

Please note the die heads do not include threading dies!

### Precision Threading Dies

High material quality and precise workmanship guarantee easy cutting, clean threads and extremely long service life with outstanding chip discharge. Manufactured from high-quality tempered steel. (only available in sets 4 or 5 pieces / pack)



For optimal threading results, use only with original ROTHENBERGER cutting fluid or cutting oil (see  123)!

#### Suitable for:

- **Conical pipe threads - NPT**  
Taper Pipe Thread: ASME B1.20.1  
External conical threads 1:16, 60° flank angle
- **Metric bolt threads - M**  
Metric threads: ISO 261, DIN 13  
Exterior threads, 60° flank angle
- **Conical pipe threads - BSPT**  
Whitworth pipe threads: ISO 7-1, DIN EN 10226 (DIN 2999)  
External conical threads 1:16, 55° flank angle
- **English bolt threads - BSW**  
British Standard Parallel Screw: Thread of Whitworth  
Form B.S.W, B.S 84: Exterior threads, 55° flank angle
- **Cylindrical pipe threads - BSPP**  
Whitworth pipe threads: ISO 228-1, DIN 259  
Exterior threads cylindrical, 55° flank angle

### Overview Die Heads / Threading Dies

Die heads			Threading dies			ROPOWER® 50 R	SUPERTRONIC® 2 SE	SUPERTRONIC® 3 SE	SUPERTRONIC® 4 SE
Thread type	Size	No.	Size	No. SS-Steel	No. HSS-Steel stainl. steel/inox pipe				

#### Automatic die heads suitable for RIDGID<sup>1)</sup> threading dies

BSPT R	1/4 - 2"	56052	1/4-3/8"	56369	56379	●			
			1/2-3/4"	056370X	56380	●			
			1-2"	056371X	N/A	●			

NPT	1/4 - 2"	56053	1/4-3/8"	56372	N/A	●			
			1/2-3/4"	56373	N/A	●			
			1-2"	56374	N/A	●			

#### Automatic die heads suitable for ROTHENBERGER threading dies

BSPT R	1/2-2"	56266	1/2-3/4"	56003	56235		●	●	●	
			1- 2"	56007	56236		●	●	●	
			2.1/2-3"	56288	2.1/2 - 3"	56291	56237		●	●
			2.1/2-4"	56289	2.1/2 - 4"	56294	56238		●	●

NPT	1/2-2"	56271	1/2-3/4"	56111	56180		●	●	●	
			1-2"	56112	56181		●	●	●	
			2.1/2-3"	56268	2.1/2- 3"	56295	56183		●	●
			2.1/2- 4"	56269	2.1/2- 4"	56296	56184		●	●

#### ROTHENBERGER standard / manual die heads

BSPT R	1/4-3/8"	56153	1/4-3/8"	56001	56135	●	●	●	●	
			1/2-2"	56156	1/2-3/4"	56003	56235	●	●	●
				56007	56236	●	●	●	●	
				56104	2- 3"	56006	56121		●	●
				56032	3.1/2- 4"	56008	56122		●	●

NPT	1/4-3/8"	56118	1/4- 3/8"	56110	N/A	●	●	●	●	
			1/2-2"	56156	1/2- 3/4"	56111	56180	●	●	●
				56112	56181	●	●	●	●	
				56104	2.1/2"-3"	56114	N/A		●	●

BSPP	1/2-1.1/4"	56076	1/2-3/4"	56095	N/A	●	●	●	●	
			1-1.1/4"	56096	N/A	●	●	●		
			1.1/2-3"	56077	1.1/2- 2"	56097	N/A		●	●
				56098	2.1/2-3"	56098	N/A		●	●

BSW	3/8-1"	56153	3/8"	56009	56161	●	●	●	●		
			1/2"	56010	56162	●	●	●	●		
			5/8"	56011	56163	●	●	●	●		
			3/4"	56012	56164	●	●	●	●		
			7/8"	56013	56165	●	●	●	●		
			1"	56014	56166	●	●	●	●		
			1.1/8-2"	56310	1.1/8-1.1/4"	56185	N/A	●	●	●	●
					1.1/2"	56186	N/A	●	●	●	●
					1.5/8-1.3/4"	56187	N/A	●	●	●	●
					1.7/8-2"	56188	N/A	●	●	●	●

Metric	10 - 24	56133	10	56081	56351	●	●	●	●		
			12	56082	56352	●	●	●	●		
			14 - 16	56083	56353	●	●	●	●		
			18 - 22	56085	56355	●	●	●	●		
			24	56088	56358	●	●	●	●		
			27 - 36	56315	27	56189	N/A	●	●	●	●
					30 - 33	56190	N/A	●	●	●	●
					36	56191	N/A	●	●	●	●

#### ROTHENBERGER die heads and threading dies for plastic coated pipes

BSPT R	1/2-2"	56266	1/2-3/4"	56002	N/A		●	●	●
			1-2"	56005	N/A		●	●	●
			1/2-2"	56156	1/2- 3/4"	56002	N/A	●	●

			1-2"	56005	N/A	●	●	●	●
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1) RIDGID® is a registered trade mark of the Emerson Electric Co., St. Louis, USA

N/A: not available



# Bonding

## Threading Electric

### COLLINS CLASSIC 22 / RHINO 4"

#### Stationary threader up to Ø 4"

Heavy-duty threading machine for professional mobile and stationary use



#### Product Profile

##### APPLICATION AREA

For the hardest, long term preparatory and serial production requirements in the workshop and on-site, in trade and industry, for pipeline construction as well as for sanitary and heating installations

For the threading of:

<b>BSPT right:</b>	Ø 1/2 - 4"
<b>NPT:</b>	Ø 1/2 - 4"
<b>BSPP:</b>	Ø 1/2 - 4"
<b>Metric:</b>	Ø 12 - 52 mm

##### KEY FEATURES

###### Standard Die Head

- Only one die head is needed to cut BSPT right / left, BSPP and metric thread types

###### Cost saving

- Easy to use with simple and quick change of dies

##### KEY FEATURES

###### Automatic Die Head

- Simple and clear operation, easy to use
- Versatile work with the adjustable auto thread length and thread depth
- Long service life with the HSS precision dies, with easy first cut
- Long life with the optimal cut geometry and outstanding chip discharge

##### TECHNICAL DATA

**Powerful universal motor**, runs R/L

**Motor is double insulated** in accordance with VDE

**High working speed**

**With 6 brush motor** for higher torque

**Overload protection**, security stop switch, over-run stop

**Operational hour counter**

**Motor control light**

4



#### SUPER GRIP Chucking System

Automatic quick grip chuck: R/L chucking, 4 double chucks at both front and rear of machine ensure that pipe is automatically gripped and centred with maximum gripping power

Centred and absolute no-slip grip

Precision pipe cutter, driven on both sides, with review panel, 5-blade deburrer

Precise cutting and deburring

Chuck jaws easy to exchange

Easy to maintain

#### Cooling / Lubrication

Central lubrication for spindle drive

Easy maintenance

Sturdy, largely dimensioned oil pump with integrated oil feed

Optimal cooling and lubrication

Large, well-positioned shavings collection trough

Easy to empty

Guide sled with rack-drive driven on both sides

Precise guiding



SUPER GRIP detailed view



SUPER GRIP pipe chuck system





### COLLINS CLASSIC 22 A

Threading up to Ø 2"

#### Product Profile

#### TECHNICAL DATA

Performance:	1,800 Watt
Speed:	72 m <sup>-1</sup>
Weight:	133 kg
Dimensions (L x W x H):	960 x 480 x 470 mm

**With Collins SUPER GRIP Chucking System!**

Scope of delivery: COLLINS CLASSIC 22 A Set with UNIQUAD die head 1/8 - 2" (No. 57015), HSS dies 1/2 - 3/4" (No. 57022), 1 - 2" (No. 57025), safety foot switch (No. 56335), tool, (without transport stand No. 57005)

Model	kg	230 V	110 V
with Standard Die Head	133	<b>57070</b>	<b>57071</b>



Model	kg	No.	Model	kg	No.
Deburrer up to 2", conical, with 5 blades	1.20	<b>57011</b>	Replacement cutting wheel for pipe cutter	0.04	<b>57010</b>
Transport stand, full rubber tyres	24.20	<b>57005</b>	Safety foot switch, 230 V	2.36	<b>56335</b>

### COLLINS RHINO 4" Set

Threader up to Ø 4"

#### Product Profile

#### TECHNICAL DATA

Performance:	2,800 Watt
Speed:	25 m <sup>-1</sup>
Weight:	216 kg
Dimensions (L x W x H):	1,050 x 610 x 560 mm

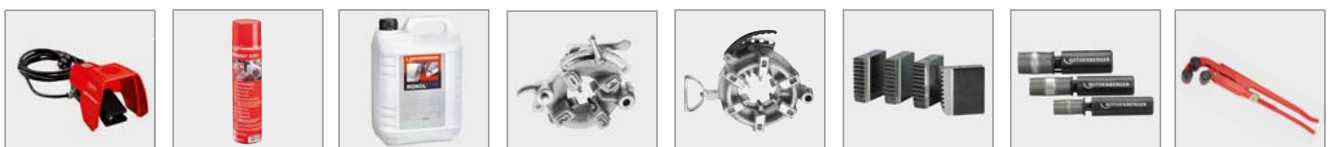
**With Collins SUPER GRIP Chucking System!**

Scope of delivery: COLLINS RHINO 4" Set with UNIQUAD die head 1/8 - 2" (No. 57015), Quadmatic Die Head 2.1/2 - 4" (No. 57016) HSS dies 1/2 - 3/4" (No. 57022), 1 - 2" (No. 57025), 2.1/2 - 4" (No. 57024), Safety foot switch, (No. 56335), tool (without transport stand No. 57105)

Model	kg	230 V
with Standard Head	216.00	<b>57100</b>
Transport stand, full rubber tyres	24.20	<b>57105</b>



#### ACCESSORIES



Description	kg	No.	Description	kg	No.
Safety foot switch, 230 V	2.36	<b>133 56335</b>	Pipe roughing wrench	1.15	<b>56500</b>
Cutting fluid	<b>123</b>		Deburrer up to 2", conical with 5 blades	1.20	<b>57011</b>
High-performance die heads	<b>132</b>		Deburrer up to 4", bladed with 2 blades	0.70	<b>57111</b>
Precision dies	<b>132</b>		Replacement cutting wheel for pipe cutter	0.04	<b>57110</b>
NIPPLE MAX	<b>133</b>		Transport stand, full rubber tyres	24.20	<b>57105</b>

# Bonding

## Threading Electric

### High-Performance Die Heads

For CLASSIC 22 A and RHINO 4"

For pipe threads Ø 1/8 - 4" and for bolt threads Ø M 6 - M 52

#### Product Profile

#### KEY FEATURES

- Simple and quick change of Dies without complication calibration
- Automatic lubrication through the Die head guarantees constant cutting oil film on the pipe surface and a long life for the dies



Model UNIQUAD



Model QUADMATIC



Model AUTOMATIC

Die head thread type	Cutting range	also suitable for dies	AM 300 PR Standard	AM 300 PR Auto	COLLINS CLASSIC Standard	COLLINS RHINO Standard	kg	No.
<b>BSPT UNIQUAD *</b>	1/8 - 2"	BSPP 1/8 - 2" M 6 - M 52 mm	●	○	●	●	5.1	<b>57015</b>
<b>BSPT QUADMATIC *</b>	2.1/2 - 4"	BSPP 2.1/2 - 4"				●	17.9	<b>57016</b>
<b>BSPT Automatic *</b>	1/2 - 2"	BSPP 1/2 - 2"	○	●	○	○	4.8	<b>57017</b>
<b>NPT UNIQUAD *</b>	1/8 - 2"		○	○	○	○	4.9	<b>57018</b>
<b>NPT Automatic *</b>	1/2 - 2"		○	○	○	○	5.1	<b>57019</b>

○ = included    ● = optional    \* = Threading dies not included

### Precision Threading Dies

CLASSIC 22 A / RHINO 4" (only available in 4 pc. / set)

- Technically perfect, high material quality and precise workmanship guarantee easy cutting, clean threads and extremely long service life
- Optimised cutting geometry and outstanding chip discharge

Thread type size	Thread per inch	for die head	g	No.
<b>HSS - Threading Dies, BSPT right with pivot</b>				
1/8"	28	57015	660	<b>57020</b>
1/4 - 3/8"	19	57015	660	<b>57021</b>
1/2 - 3/4"	14	57015 + 57017	630	<b>57022</b>
1 - 2"	11	57017	590	<b>57025</b>
2.1/2 - 4"	11	57016	2,800	<b>57024</b>
<b>HSS - Threading Dies, BSPT left</b>				
1 - 2"	11	57015	590	<b>57082</b>
<b>HSS - Threading Dies, NPT</b>				
1/8"	27	57018	460	<b>57060</b>
1/4 - 3/8"	18	57018	460	<b>57061</b>
1/2 - 3/4"	14	57018 + 57019	460	<b>57062</b>
1 - 2"	11	57018 + 57019	460	<b>57063</b>
<b>HSS - Threading Dies, BSPP</b>				
1/8"	28	57015	460	<b>57030</b>
1/4 - 3/8"	19	57015	460	<b>57031</b>
1/2 - 3/4"	14	57015 + 57017	460	<b>57132</b>
1 - 2"	11	57015 + 57017	460	<b>57133</b>
2.1/2 - 3"	11	57016	2,300	<b>57134</b>
3.1/2 - 4"	11	57016	2,300	<b>57135</b>

Thread type size	Thread pitch	for die head	g	No.
<b>HSS - Threading Dies, metric</b>				
8 mm	1.25	57015	690	<b>57032</b>
10 mm	1.50	57015	670	<b>57033</b>
12 mm	1.75	57015	660	<b>57034</b>
14 mm	2.00	57015	650	<b>57035</b>
16 mm	2.00	57015	650	<b>57036</b>
18 mm	2.50	57015	640	<b>57037</b>
20 mm	2.50	57015	640	<b>57038</b>
22 mm	2.50	57015	590	<b>57039</b>
24 mm	3.00	57015	620	<b>57041</b>
27 mm	3.00	57015	600	<b>57042</b>
30 mm	3.50	57015	580	<b>57043</b>
33 mm	3.50	57015	580	<b>57044</b>
36 mm	4.00	57015	560	<b>57055</b>
39 mm	4.00	57015	560	<b>57045</b>
42 mm	4.50	57015	500	<b>57046</b>
45 mm	4.50	57015	450	<b>57056</b>
48 mm	5.00	57015	450	<b>57057</b>
52 mm	5.00	57015	450	<b>57058</b>

### Pipe Supporting Column

Adjustable height, from 780 up to 1,200 mm with ball track. Maximum carrying capacity 120 kg



Model	Height / mm	kg	No.
For pipes up to 6"	780 - 1,200	5.8	<b>56047</b>

### Replacement Safety Foot Switch

For all ROTHENBERGER threading machines

- Complies with industrial associations' safety and accident prevention requirements
- With oil-proof rubber cable and plug
- Foot switch should not be pushed all the way down (OFF-ON-OFF)



Model	kg	No.
3 step, with emergency stop switch, 230 Volt	2.5	<b>56335</b>

4



### Pipe Roughing Wrench 3/8 - 2"

Wrench made of forged steel, with hardened rolls. Consistent, thread-saving roughing of the entire area



Model	L mm	kg	No.
Pipe Roughing Wrench	335	1.15	<b>56500</b>
Replacement roughing rolls (3 pc.)		0.30	<b>56501</b>

### NIPPLE MAX

#### NIPPLE MAX Ø 1/2 - 2"

For the production of nipples and double nipples, grips short pipe lengths from within; hardened, sharpened gripping jaws. For all stationary threading machines, PANDA, PISET, ROPOWER and SUPERTRONIC.

- Recycling pipe scraps saves money, material and time
- Automatic quick grip of the pipe piece without the need for additional tools
- Pipes are gripped from within and centred: No damage to pipe piece



Set (No. 56056) includes: Nipple chuck 1/2" (No. 56060), 3/4" (No. 56061), 1" (No. 56062), 1.1/4" (No. 56063), 1.1/2" (No. 56064), steel carrying case (No. 26410)

Model	kg	No.
NIPPLE MAX Set 1/2 - 3/4 - 1 - 1.1/4 - 1.1/2"	4.4	<b>56056</b>
Nipple chuck 1/2"	0.4	<b>56060</b>
Nipple chuck 3/4"	0.5	<b>56061</b>

Model	kg	No.
Nipple chuck 1"	0.7	<b>56062</b>
Nipple chuck 1.1/4"	0.8	<b>56063</b>
Nipple chuck 1.1/2"	0.9	<b>56064</b>
Nipple chuck 2"	1.2	<b>56065</b>

# Bonding

## Roll Grooving

### ROGROOVER 1 - 6"

Portable rolling groover for steel pipes up to Ø 6" (168 mm) for rapid rolling of grooves on standard and thin-walled steel pipes

Suitable for installations, sprinkler systems, larger heading units, industrial use and mining

#### APPLICATION AREA

**Standard and thin-walled steel pipes up to 6" (168 mm)**  
Light weight and compact design allows for use with the threaders:

SUPERTRONIC® 2000	ROPOWER® 50 R
SUPERTRONIC® 2 SE	SUPERTRONIC® 3 SE
SUPERTRONIC® 4 SE	

#### KEY FEATURES

- Quick connection of pipes anywhere where welding isn't allowed!
- Long life and little wear
- Easy to transport with the light-weight aluminium casing
- Adjustable and finely-controlled arrester for consistent groove depth
- Convenient, easy and time-saving operation

Model	kg		No.
ROGROOVER for SUPERTRONIC® 2000	14.5	1	<b>56509</b>
ROGROOVER for ROPOWER® 50 R, SC 2 SE, REX 2"	14.5	1	<b>56505</b>
ROGROOVER for SUPERTRONIC® 3 SE and REX 3"	14.5	1	<b>56506</b>
ROGROOVER for SUPERTRONIC® 4 SE	14.5	1	<b>56507</b>
ROGROOVER for Ridgid 300	16.0	1	<b>56504</b>
ROGROOVER for REX 4"	14.5	1	<b>56508</b>

Extremely light: 12 kg!



Model	No.
Support rail 2"	<b>56510</b>
Support rail 3"	<b>56511</b>
Support rail 4"	<b>56512</b>
Seating adaptor SUPERTRONIC®	<b>56514</b>
Pressure roller set 1" for ROGROOVER	<b>56521</b>
Pressure roller set for ROGROOVER 1.1/4 - 1.1/2"	<b>56522</b>
Pressure roller set for ROGROOVER 2 - 6"	<b>56523</b>
Tripod workbench	<b>70751</b>

### Hand Roll Groover 1 - 12"

Manageable and compact hand roll groover for producing of grooves on installed thin- and standard Steel pipes up to 12" (324 mm)

Suitable for installations, sprinkler systems, larger heating units, industrial use and mining.

#### APPLICATION AREA

For standard grooves on instelled pipes from 1 - 12"

#### KEY FEATURES

- For pipes from Ø 1"
- Quick connection of pipes anywhere where welding is not allowed!
- Easy transportation due to small dimension
- Adjustable and finely-controlled arrester
- ½" ratchet for both adjustment

#### TECHNICAL DATA

<b>Working range:</b>	1 - 12" (324 mm)
<b>Pipe wall-thickness:</b>	1 - 6" SCHL10 + SCHL40 4 - 6" SCHL40 8 - 12" SCHL10
<b>Weight:</b>	12.0 kg
<b>Depth gauge:</b>	2 distance plates included
<b>Dimensions:</b>	195 mm x 210 mm x 210 mm



Application on tripod workbench



Fixture for stabiliser



Model	kg		No.
Hand Roll Groover 2 - 6"	12.0	1	<b>100000212</b>
Roller-SET 1"	0.59	1	<b>100000720</b>
Roller-SET 1.1/4 - 1.1/2"	0.62	1	<b>100000721</b>
Roller-SET 2 - 6"	1.00	1	<b>100000850</b>
Roller-SET 4 - 6"	2.48	1	<b>100000722</b>
Roller-SET 8 - 12"	2.70	1	<b>100000723</b>

### ROGROOVER 2 - 12"

Electro-hydraulic rolling groover for steel pipes  
 Ø 2 - 12" (60 - 324 mm) for rolling of grooves on  
 thin-walled and standard steel pipes

#### Product Profile

##### APPLICATION AREA

Sprinkler systems, installations, larger heading units,  
 industrial use and mining

##### KEY FEATURES

- Sturdy hydraulic-pump with precisely formed grips for ideal handling
- Compact and very stable machine design
- Powerful yet quiet motor
- Fine adjustment for groove depth and regulation

##### TECHNICAL DATA

<b>Working range:</b>	2 - 12" (60 - 324 mm)
<b>Pipe wall-thickness:</b>	3 - 10 mm
<b>Weight:</b>	129 kg
<b>Dimensions:</b>	920 x 460 x 960 mm
<b>Current:</b>	230 / 240 V, 50 / 60 Hz
<b>Power:</b>	1,100 W
<b>Speed:</b>	23 U/min.
<b>Max. working pressure:</b>	8,000 kg



Sturdy hydraulic-pump with  
 precisely formed grips

For ideal handling

Powerful yet  
 quiet motor

Fine adjustment of the groove  
 depth and regulation

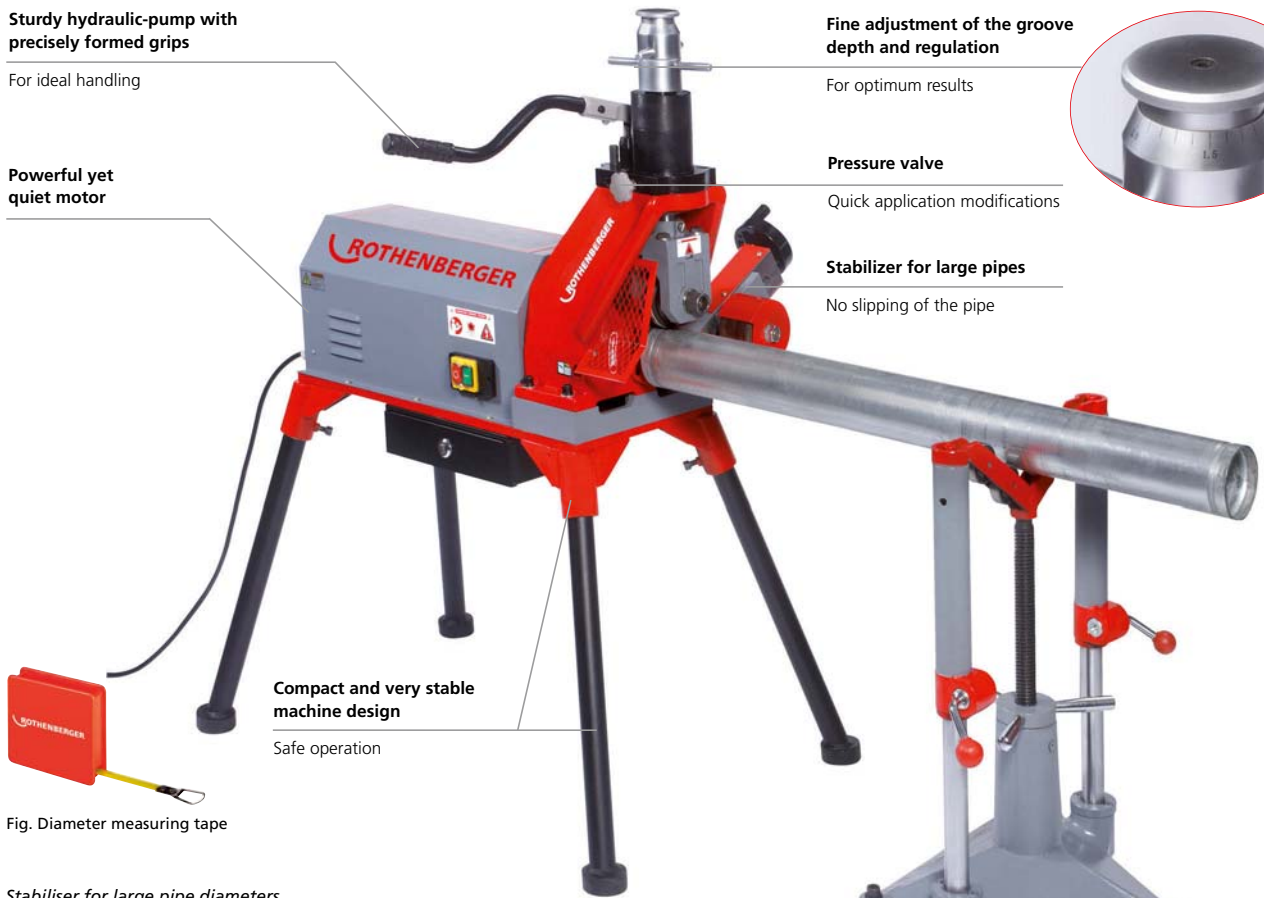
For optimum results

Pressure valve

Quick application modifications

Stabilizer for large pipes

No slipping of the pipe



Compact and very stable  
 machine design

Safe operation

Fig. Diameter measuring tape

Stabiliser for large pipe diameters  
 adjustable up to 12"



Tool compartment for accessories



Scope of delivery: ROGROOVER machine 2 - 12", roll groove set 2-6", roll groove set 3-6", roll groove set 8-12", pipe support stand, tools for installation, diameter measuring tape, installation and instructional CD

Model	kg		No.
ROGROOVER 2 - 12"	129.0	1	<b>100000087</b>
Roll Groove set 2 - 6"	1.5	1	<b>887307000</b>
Roll Groove set 3 - 6"	2.2	1	<b>887308000</b>

Model	kg		No.
Roll Groove set 8 - 12"	2.4	1	<b>887309000</b>
Pipe support stand	29.0	1	<b>1500000133</b>
Diameter measuring tape	0.05	1	<b>1500000134</b>































# Bonding

## Application Overview Soldering & Welding

### Application Table

Product listing according to application areas

4  


CARTRIDGE SOLDERING UNITS							
	<b>SUPER FIRE 3</b>	 138 - 139	  Ø 35 Ø 28	 Ø 22			
	<b>POWER FIRE COMPACT</b>	 140	  Ø 28 Ø 22	 Ø 22			
	<b>ROFIRE Swivel Pro</b>	 140	  Ø 42 Ø 18 Ø 64 Ø 28	  Ø 42 Ø 18 Ø 64 Ø 28			
	<b>ROFLAME PIEZO</b>	 140					 Ø 22
	<b>ROFIRE® PIEZO / ROFIRE® / EASYFIRE</b>	 141			  Ø 22 Ø 15	  Ø 22 Ø 15	

Disposable gas cartridges  142 - 143

Soft soldering  
up to 450°C






























Brazing, etc.  
450°C - 1100°C




Gas  
Welding  
> 1100°C



























### ACETYLENE AND PROPANE TORCHES

				
	<b>AIRAC®</b>	 148	<b>Acetylene</b>   Ø 54 Ø 35	<b>Propane / Butane</b>
	<b>ROCOLT HANDY PIEZO</b>	 144 - 145		  Ø 70 Ø 32
	<b>AIRPROP®</b>	 146		  Ø 54 Ø 22
	<b>TURBOPROP</b>	 147		  Ø 54 Ø 28
	<b>ROOFING-Set</b>	 151		 Basic
	<b>MULTI 300</b>	 150		 Basic
	<b>MULTI MOBILE</b>	 149		 Basic

Light steel cylinders  152, 162




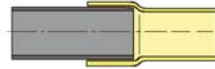
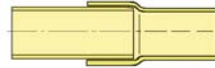

The bottle colours shown are without obligation!

## Application Overview Soldering & Welding

GAS-WELDING EQUIPMENT						
	<b>ROFLASH</b>	 159	 Welding 0.2-14 mm Cutting 3-75 mm			
	<b>RE 17</b>	 160 - 161	 Welding 0.5-14 mm Cutting 3-100 mm			
	<b>ALLGAS</b>	 155 - 158		 Welding 0.2-5 mm		 Welding 0.2-5 mm
	<b>ROXY 400 L</b>	 158			 Welding 0.5-2 mm	
			Light steel cylinders  152, 162	Disposable gas cartridges  140 - 141		
<b>ELECTRIC SOFT SOLDERING UNIT</b>			<b>230 V 50/60 Hz</b>		The bottle colours shown are without obligation!	
	<b>ROTHERM 2000</b>	 153 - 154	 Ø 54	Soft soldering up to 450°C 	Brazing, etc. 450°C-1100°C 	Gas Welding > 1100°C 



### Soldered Joints

Material	Required Hard Solder	Melting Range	Working Temperature	Standard
<b>Copper-Copper</b> 	S 34 Cu / S 34 Cu U S 94 / S 94 XN / S1 S 2 / S 5 S 15	630 °C - 730 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 800 °C	710 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Copper-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN 1044
<b>Copper-Brass</b> 	S 94 / S 94 XN / S1 S 2 S 5 S 15	710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Brass-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	600 °C - 690 °C 595 °C - 630 °C	680 °C 610 °C	DIN EN 1044
<b>Brass-Brass</b> 	S 94 / S 94 XN S 1 (not standardised) S 2 / S 5 S 15	710 °C - 880 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Carbon Steel-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN 1044



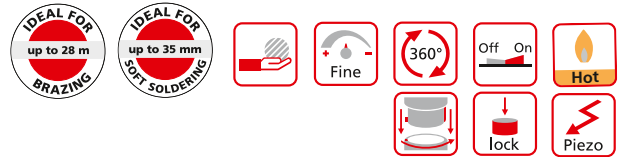
# Bonding

## Cartridge Brazing

### SUPER FIRE 3

Ergonomic HEAVY-DUTY brazing unit up to Ø 28 mm

For soft soldering, brazing and other applications such as loosening of colour or shrinking of hoses



#### Product Profile

##### APPLICATION AREA

**Brazing:** up to Ø 28 mm (with flame reflector in a wind protected environment)  
**Soft soldering:** up to Ø 35 mm

##### KEY FEATURES

- Versatile - for use in all positions (360°)
- Rapid heat-up, less consumption!
- Long service life
- "Twist 'N' Load" system (5 different nozzles available)
- Precise flame adjustment
- Up to 2.5 hours of brazing with one cartridge

##### KEY FEATURES

- Even more comfortable for longer jobs
- Reliable Piezo ignition (up to 30,000 ignitions)
- Double the safety because there is no gas leakage without locked nozzle (Piezo ignition)

##### TECHNICAL DATA

**Coupling:** 7/16" EU  
**Handle:** Aluminium, bolted  
**Burner:** Brass / stainless steel  
**"Twist 'N' Load":** 5 different nozzles for different applications

4



### SUPER FIRE 3 Nozzles

Quick exchange with the "Twist 'N' Load" system

#### "Twist 'N' Load"!



Soft soldering in heating installation



High flame temperature through cyclone swirl



Brazing in gas installation



Hard soldering in refrigeration and climate control



1) MAPP<sup>®</sup> is a registered trademark of MESSER GRIESHEIM GMBH, Frankfurt am Main

### Pin-point Nozzle (460 °C):



(No. 35455)

For fine soldering; precise and stable flame

### Standard Nozzle (700 °C):



(No. 35456)

For soft soldering and other jobs with lower heat application; precise, powerful and stable flame

### Cyclone Nozzle (950 °C):



(No. 35457)

For hand and soft soldering with an efficient swirl flame (allows pipe to heat up evenly)

### Hot air Nozzle (400 °C):



(No. 35458)

For the removal of paint and for shrinking work up to approx. 80 mm diameter; wind-stable, powerful current of hot air

### Shrinking Nozzle (720 °C):



(No. 35459)

For shrinking up to ø 300 mm and for heating; powerful, wind-stable soft flame

## SUPER FIRE 3 HOT BOX

### KEY FEATURES

- The ideal service kit
- For repairs, heating installations and refrigeration / air-conditioning technology



5 part set (No. 35490) includes: handle (No. 35445), cyclone nozzle (No. 35457), pin-point nozzle (No. 35455), flame reflector (No. 31043), universal torch support (No. 35461), 2 x MAPP® gas cartridges (No. 035551-A), carrying case (No. 30898)

Model			No.
SUPER FIRE 3 HOT BOX	1	4	<b>35490</b>

## SUPER FIRE 3 Basic Set

Set (No. 35436) includes:  
handle (No. 35445), cyclone nozzle (No. 35457)

## SUPER FIRE 3 MAPP®(1) Set

Set (No. 35432) includes:  
handle (No. 35445), cyclone nozzle (No. 35457),  
MAPP®(1) gas cartridge (No. 035551-A)



No. 035648X

**When placing your order, remember to order the universal torch support (No. 35461) for stationary soldering, too!**

Model			No.
SUPER FIRE 3 Basic Set	1	4	<b>35436</b>
SUPER FIRE 3 MAPP®(1) Set	1	10	<b>35432</b>
SUPER FIRE safety adaptor 7/16" to 1"	1	1	<b>035648X</b>



No. 35436



No. 35432

## ACCESSORIES



Model		Model	
Welding blanket	<b>165</b>	External brush for copper pipe	<b>165</b>
Internal brush for copper pipe	<b>165</b>	ROVLIES®	<b>165</b>
Solder	<b>167 - 171</b>	Soft-soldering paste ROSOL	<b>167</b>

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# Bonding

## Cartridge Brazing / Soft Soldering

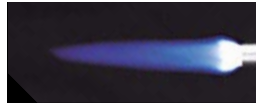
### POWER FIRE Compact

PROFESSIONAL brazing- Ø 22 mm  
and soft soldering unit up to Ø 28 mm



#### APPLICATION AREA

**Coupling:** 7/16" EU  
**Brazing:** up to Ø 22 mm  
**Soft soldering:** up to Ø 28 mm



#### KEY FEATURES

##### Characteristics

- With Piezo ignition button
- For use in all positions (MAPP®<sup>1</sup>) Gas
- Compact and 45% lighter (compared to POWER FIRE)



Model	No.
POWER FIRE Compact set (torch, MAPP® <sup>1</sup> ) Gas)	<b>35424</b>
POWER FIRE Compact, EU-handle	<b>30813</b>



No. 35424



**Can be used in any position (360°)!**

### ROFIRE Swivel PRO Piezo Cyclone

Cyclone burner with Piezo ignition

**Coupling:** 1" US / 7/16" EU  
**Brazing:** up to Ø 18 mm  
**Soft soldering:** up to Ø 42 mm



**Can be used in any position (360°)!**

Model	No.
-------	-----

ROFIRE SWIVEL PRO Cyclone Piezo EU **35015**  
ROFIRE SWIVEL PRO Cyclone Piezo US **35016**

### ROFIRE Swivel PRO Cyclone

Cyclone burner

**Coupling:** 1" US / 7/16" EU  
**Brazing:** up to Ø 18 mm  
**Soft soldering:** up to Ø 42 mm



**Can be used in any position (360°)!**

Model	No.
-------	-----

ROFIRE SWIVEL PRO Cyclone EU **35013**  
ROFIRE SWIVEL PRO Cyclone US **35014**

### ROFIRE Swivel PRO Twin

Twin cyclone burner

**Coupling:** 1" US / 7/16" EU  
**Brazing:** up to Ø 28 mm  
**Soft soldering:** up to Ø 64 mm



**Can be used in any position (360°)!**

Model	No.
-------	-----

ROFIRE SWIVEL PRO Twin EU **35011**  
ROFIRE SWIVEL PRO Twin US **35012**

### ROFLAME PIEZO

CLASSIC soft soldering unit Ø 22 mm



#### APPLICATION AREA

**Coupling:** Pluggable cartridge  
**Soft soldering:** up to Ø 22 mm



#### KEY FEATURES

- High-performance torch with stable, ergonomic handle, including Piezo ignition and fine flame adjustment
- Comfortable one-handed use and secure storage surface
- Piezo Ignition
- Precise adjustment of the flame
- Exchangeable torch nozzles in case of repair is needed



Model	No.
ROFLAME PIEZO 1800 °C (w/o gas cartridge C 200)	<b>750 35419</b>

1) MAPP® is a registered trademark of MESSER GRIESHEIM GMBH, Frankfurt am Main

Disposable gas cartridges can be found on pages 142 - 143

## Cartridge Soft Soldering

### ROFIRE®

ECONOMY soft soldering unit up to Ø 22 mm

#### APPLICATION AREA

**Coupling:** 7/16" EU  
**Brazing:** up to Ø 15 mm  
**Soft soldering:** up to Ø 22 mm



#### KEY FEATURES

- Torch with integrated support bracket
- Precise adjustment of the flame with the fine adjustment valve
- Exchangeable torch nozzles in case of repair is needed

Model	g	No.
ROFIRE® 1800 °C set (torch, Multigas 300)	760	35428
ROFIRE® 1800 °C handle		35506



### ROFIRE® PIEZO

CLASSIC soft soldering unit Ø 22 mm

Powerful soldering unit for CU-brazing joints up to Ø 15 mm and soft soldering up to Ø 22 mm

#### APPLICATION AREA

**Coupling:** 7/16" EU  
**Brazing:** up to Ø 15 mm  
**Soft soldering:** up to Ø 22 mm



#### KEY FEATURES

- Piezo Ignition
- Precise adjustment of the flame
- Torch head with integrated support bracket
- Exchangeable torch nozzles in case of repair is needed

Model	g	No.
ROFIRE® PIEZO set (torch, Multigas 300)	760	35429
ROFIRE® PIEZO handle		35556



### EASY FIRE

ECONOMY soft soldering up to Ø 22 mm

High performance torch with Piezo ignition

#### APPLICATION AREA

**Coupling:** 7/16" EU  
**Brazing:** up to Ø 15 mm  
**Soft soldering:** up to Ø 22 mm



#### KEY FEATURES

- Piezo ignition
- Precise adjustment of the torch flame
- Suitable for Multigas 300

Model	g	No.
EASY FIRE set (torch, Multigas 300)	730	35553
EASY FIRE torch without gas		35552



# Bonding

## Cartridge Brazing

### MAPP®<sup>1)</sup> Gas

Special gas mix for high-performance soldering work

Flame temperatures up to 2,700 °C and 35 % faster than propane



#### Product Profile

##### KEY FEATURES

- Extremely high flame temperature, utmost burning performance and guaranteed short working times
- Guaranteed constant top torch performance

##### KEY FEATURES

- Easy to use
- Increased user safety through the sandwich valves and aluminium mono-block cylinder
- Longer periods of use

4



Contains no BUTADIEN

Poses no health risks

ROTHENBERGER MAPP®<sup>1)</sup> Gas is produced in ultra-modern filling plants and processor-controlled batching systems

Guaranteed constant top torch performance

Special gas mixture with outstanding flame characteristics

Extreme flame temperatures, utmost torch performance and guaranteed short working times

7/16" Sandwich valve

Increased safety



Less weight compared to conventional steel cylinders (228g empty)

Easy to use

**MAPP®<sup>1)</sup> monoblock aluminium cylinder**

TÜV tested gas cartridge (drawn from solid material)

Increased safety for the user

**MAPP®<sup>1)</sup> Gas**  
Special gas mixture researched by ROTHENBERGER



Fig. MAPP®<sup>1)</sup> Gas



Burns approx. 1/3 longer than propane

Up to 2.5 hours of use

### Packaging Profile

Model	MAPP® <sup>1)</sup> Gas
No.	035551-A
EAN Code	4004625355510
Product size (mm) (W x H)	80 x 285
Contents (ml)	750
Weight (g)	410
Unit per PU	12
PU per layer / palette	8
Layer per palette	3
Units per palette	288
Number of palettes per truckload	60
Units per truckload	17,280
Palette weight (kg)	241
Palette size (mm) (L x W x H)	800 x 1,200 x 1,000
Carton size (mm) (L x W x H)	320 x 295 x 250

Model	Contents			No.
MAPP® <sup>1)</sup> gas cartridge	750 ml	12 / 360	<b>035551-A</b>	
Languages: DE, GB, FR, ES, IT, PT				
MAPP® <sup>1)</sup> gas cartridge	750 ml	12 / 360	<b>035551-B</b>	
Languages: DK, NL, SE, FI, FR, RU				
MAPP® <sup>1)</sup> gas cartridge	750 ml	12 / 360	<b>035551-C</b>	
Languages: CZ, PL, HU, BG, TR, GR				
Burners can be found starting on  138				

1) MAPP® is a registered trademark of MESSER GRIESHEIM GMBH, Frankfurt am Main

## Cartridge Brazing / Soft Soldering

### Maxigas 400

High-performance welding, cutting and brazing gas for flame temperatures up to 2,200 °C. Gas cartridge with 7/16" EU coupling thread



### Multigas 300

Propane / butane gas mixture for flame temperatures up to 1,900 °C. Gas cartridge with 7/16" EU coupling thread



Model	Maxigas 400
No.	035570-A/-B
EAN Code	4004625355701
Product size (mm) (W x H)	65 x 260
Contents (ml)	600
Weight (g)	352
Unit per PU	24
PU per layer / palette	9
Layer per palette	3
Units per palette	648
Number of palettes per truckload	60
Units per truckload	38,880
Palette weight (kg)	195
Palette size (mm) (L x W x H)	800 x 1,200 x 1,000
Carton size (mm) (L x W x H)	405 x 272 x 264

Model	Multigas 300
No.	035510-A/-B
EAN Code	4004625355107
Product size (mm) (W x H)	65 x 260
Contents (ml)	600
Weight (g)	332
Unit per PU	24
PU per layer / palette	9
Layer per palette	3
Units per palette	648
Number of palettes per truckload	60
Units per truckload	38,880
Palette weight (kg)	191
Palette size (mm) (L x W x H)	800 x 1,200 x 1,000
Carton size (mm) (L x W x H)	405 x 272 x 264

### Propane Gas

Gas cartridges for flame temperatures up to 1,900 °C. With EU coupling 7/16"



### C 200 Supergas

Pierceable butane cartridge with propane contents, also for working at low temperatures. Manufactured according to EN 417



Model	Propane Gas 2000
No.	035546-A/-B/-C
EAN Code	4004625355466
Product size (mm) (W x H)	80 x 285
Contents (ml)	750
Weight (g)	450
Unit per PU	12
VPE pro Lage / Palette	8
Layer per palette	3
Units per palette	288
Number of palettes per truckload	60
Units per truckload	17,280
Palette weight (kg)	198
Palette size (mm) (L x W x H)	800 x 1,200 x 1,000
Carton size (mm) (L x W x H)	320 x 295 x 250

Model	C 200 Supergas
No.	035900-A/-B
EAN Code	4004625359006
Product size (mm) (W x H)	90 x 95
Contents (ml)	314
Weight (g)	190
Unit per PU	36
VPE pro Lage / Palette	9
Layer per palette	3
Units per palette	972
Number of palettes per truckload	60
Units per truckload	58,320
Palette weight (kg)	251
Palette size (mm) (L x W x H)	800 x 1,200 x 1,000
Carton size (mm) (L x W x H)	405 x 272 x 264



# Bonding

## Cylinder Brazing

### ROCOLT HANDY PIEZO Set

Professional brazing system with quick-change torch

Three torch nozzles for different applications



#### Product Profile

##### APPLICATION AREA

**Brazing:** up to Ø 18 mm  
**Soft soldering:** up to Ø 32 mm  
**Warming-up:** up to Ø 60 mm

##### KEY FEATURES

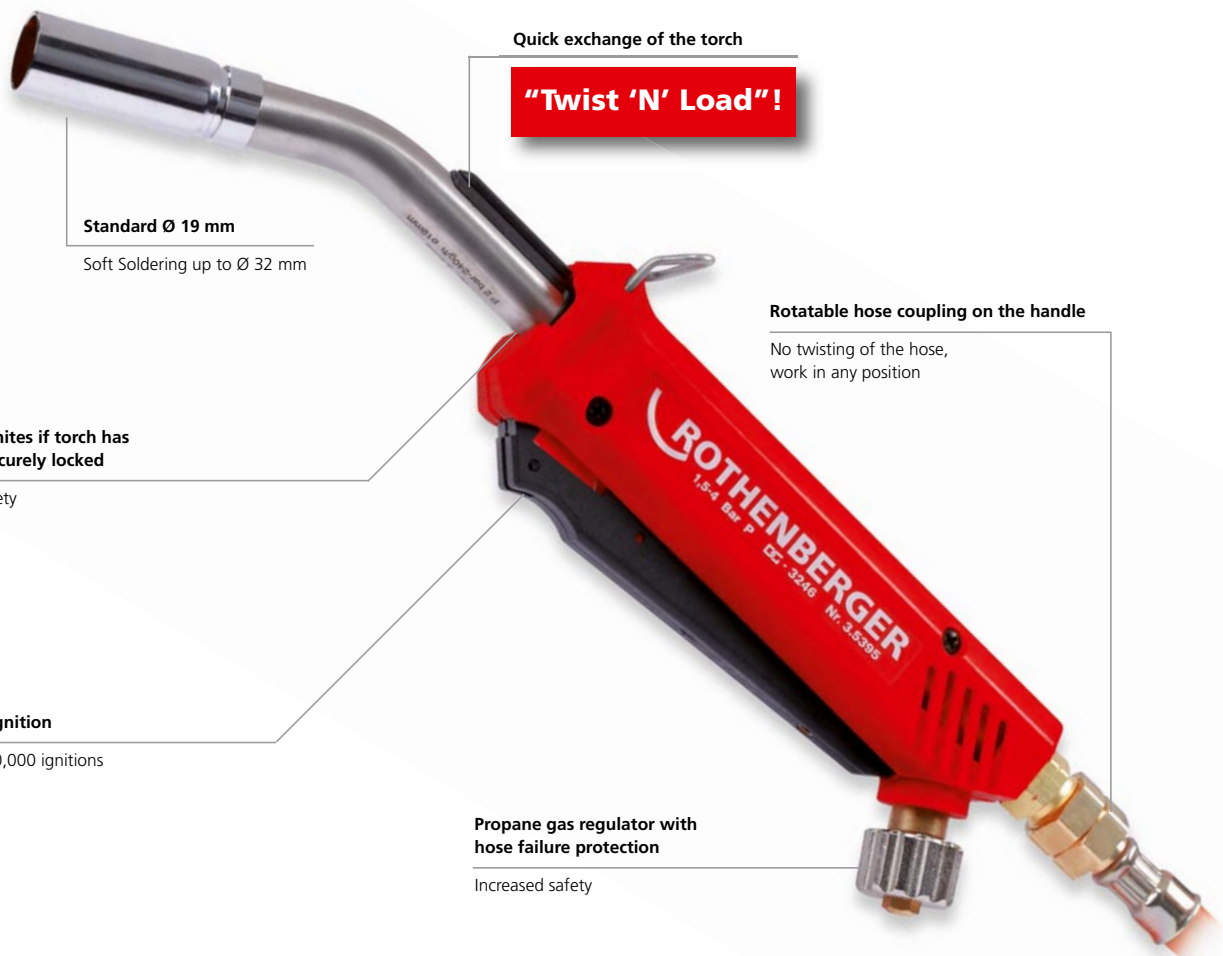
- Three torch nozzles for different applications
- Reliable PIEZO ignition for up to 30,000 ignitions
- Increased safety with the hose failure protection

##### KEY FEATURES

- No twisting of the hose, work in any position
- Tool-free nozzle exchange with the fast "Twist 'N' Load" system

##### TECHNICAL DATA

**Coupling:** G 3/8" left  
**Handle:** Plastic, with screws  
**Burner:** Brass / stainless steel



Quick exchange of the torch

**"Twist 'N' Load"!**

Standard Ø 19 mm

Soft Soldering up to Ø 32 mm

Rotatable hose coupling on the handle

No twisting of the hose,  
work in any position

Only ignites if torch has  
been securely locked

Dual safety

PIEZO ignition

Up to 30,000 ignitions

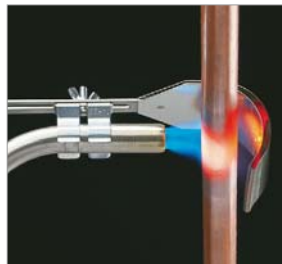
Propane gas regulator with  
hose failure protection

Increased safety

PIEZO ignition



Application with flame reflector



Brazing



Soft soldering



### ROCOLT HANDY PIEZO Set

8-part set (No. 35390) includes: Rocolt handle (No. 35395), standard torch 19 mm (No. 35378), cyclone torch (No. 35398), pressure reducer including rotatable hose failure protection (No. 35356), propane hose 3 m (No. 35383), flame reflector 65 mm (No. 31043), ROVLIES® (No. 45268), plastic carrying case (No. 30898)



**With flame reflector!**



Model	kg	No.
ROCOLT HANDY PIEZO Set	1.5	<b>35390</b>
ROCOLT HANDY Handle	0.3	<b>35395</b>

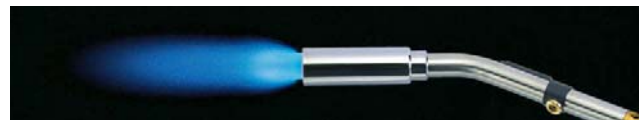
### ROCOLT HANDY PIEZO Standard Torch

Standard torch with extremely short, bundled flame for low consumption. Ideal burner for brazing, soft soldering, warming up, annealing, hardening, etc.



### ROCOLT HANDY PIEZO Cyclone Torch

Cyclone torch with optimum enveloping flame aspect when soldering pipes and fittings. Ideal burner for brazing, soft soldering, warming up, annealing, hardening, etc.



Soft soldering Ø 32 mm  
(No. 35378)



Soft soldering Ø 28 mm  
Brazing Ø 15 mm  
(No. 35397)

Soft soldering Ø 32 mm  
Brazing Ø 18 mm  
(No. 35398)

Soft soldering Ø 70 mm  
Brazing Ø 32 mm  
(No. 35399)

Model	Torch Ø mm	g	No.	Model	Torch Ø mm	g	No.
PIEZO Standard Torch	19	150	<b>35378</b>	PIEZO Cyclone Torch	14	180	<b>35397</b>
				PIEZO Cyclone Torch	19	150	<b>35398</b>
				PIEZO Cyclone Torch	25	180	<b>35399</b>

### ACCESSORIES



Model		Model	
Welding blanket	<b>165</b>	External brush for copper pipe	<b>165</b>
Internal brush for copper pipe	<b>165</b>	ROVLIES®	<b>165</b>
Solder	<b>167 - 171</b>	Soft-soldering paste ROSOL	<b>167</b>



# Bonding

## Cylinder Brazing

### AIRPROP®

Propane high-performance torches for brazing up to Ø 22 mm and soft soldering up to Ø 54 mm

For brazing and soft soldering of copper and steel pipes up to 2,000 °C without oxygen, as well as warming up, shrinking and flame cleaning



#### Product Profile

##### KEY FEATURES

- Bundled, concentrated and hot flame with the built-in gas turbine in brazing torch
- Absolutely gas-tight with the optimised valve technology
- Gas-saving operation with the smooth-running economy valve
- Fast burner exchange without tools

##### TECHNICAL DATA

**Self-induced air:** Turbine and combustion chamber  
**Torch:** Surface treated, chromed brass  
**Hose coupling:** G 3/8" L

##### Built-in gas turbine in brazing torch

Bundled, concentrated and hot flame

##### Smooth-turning economy valve

Gas-saving operation

##### Optimised valve technology

Absolutely gas tight

##### Shut-off valve

Prevents uncontrolled gas escape

**Absolutely gas-tight connection thanks to dual O-ring technology**

Fast burner exchange without tools



No. 31092

Sets include: Safety handle with push-in coupling (No. 211121116), brazing torch with push-in nipple Ø 14 mm (No. 221131416) / Ø 16 mm (No. 221131616) / Ø 19 mm (No. 221131916), 2.5 m propane hose with 3/8" L coupling (No. 32201), safety igniter (No. 32077), replacement flints (No. 32088), open-ended spanner (No. 32073), steel case (No. 31005)

Model	kg	No.
AIRPROP® Brazing set without propane regulator	2.8	<b>31092</b>
AIRPROP® Brazing set with propane regulator (as in set (No. 31092) but with regulator (No. 32081) (W 21.8 L – G 3/8 L))	3.1	<b>31091</b>
Flame cleaning torch 20/50 mm	0.2	<b>30922</b>



#### AIRPROP® brazing burner with threaded coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
14 mm	140	125	1.60 – 1,375 – 5,465	95	<b>30913</b>
16 mm	145	180	2.30 – 3,300 – 7,885	100	<b>30914</b>
19 mm	170	300	3.84 – 3,300 – 13,115	130	<b>30915</b>
22 mm	171	400	5.12 – 4,400 – 26,195	145	<b>30916</b>

#### AIRPROP® brazing burner with push-in nipple coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
14 mm	140	125	1.60 – 1,375 – 5,465	95	<b>221131416</b>
16 mm	145	180	2.30 – 3,300 – 7,885	100	<b>221131616</b>
19 mm	170	300	3.84 – 3,300 – 13,115	130	<b>221131916</b>
22 mm	171	400	5.12 – 4,400 – 26,195	145	<b>221132216</b>

### TURBOPROP

Propane high-performance torch for brazing up to Ø 28 mm and soft soldering Ø 54 mm

For brazing and soft soldering of copper and steel pipes up to 2,200 °C without oxygen, as well as for warming up, shrinking and flame cleaning



#### Product Profile

##### KEY FEATURES

- High flame temperature due to turbine with increased oxygen self-induced air and 4- to 5-fold flame chamber
- Fast burner exchange without tools
- Gas-saving operation with the smooth-running economy valve
- Shut-off valve prevents uncontrolled gas escape

##### TECHNICAL DATA

**Self-induced air:** Turbine and combustion chamber  
**Torch:** Surface treated, chromed brass  
**Hose coupling:** G 3/8" L

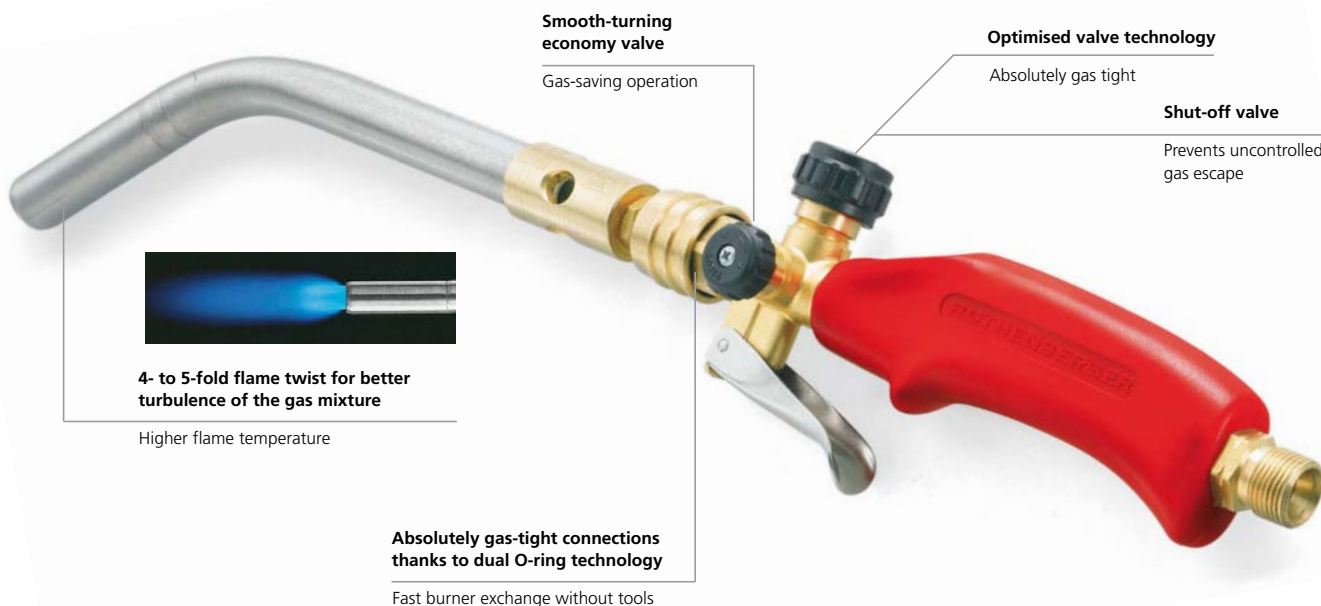


Fig. TURBOPROP torch with push-in nipple

Sets include: Safety handle with push-in coupling (No. 211121116), brazing torch with push-in nipple Ø 12 mm (No. 31032) / Ø 15 mm (No. 221031500) / Ø 18 mm (No. 221031800), 2.5 m propane hose with 3/8" L coupling (No. 32201), safety igniter (No. 32077), replacement flints (No. 32088), open-ended spanner (No. 32073), steel case (No. 31005)



No. 31090

Model	kg	No.
TURBOPROP set without propane regulator	2.8	<b>31090</b>
TURBOPROP set with propane regulator (as in set (No. 31090) but with regulator (No. 3.2081E) (W 21.8 L – G 3/8 L))	3.1	<b>31094</b>
TURBOPROP set with propane regulator (as in set (No. 31090) but with regulator (No. 3.2083) (POL 7/8 L – G 3/8 L))	3.1	<b>31037</b>
TURBOPROP set with propane regulator (as in set (No. 31090) but with regulator (No. 32084) (W 20 x 14 L – G 3/8 L))	3.1	<b>31036</b>

#### TURBOPROP brazing torch with push-in nipple coupling

Ø mm	L mm	g/h 2 bar	kWh – kcal – BTU	g	No.
10 mm	165	70	1.89 – 770 – 3,050	70	<b>31031</b>
12 mm	175	110	1.41 – 1,210 – 4,815	90	<b>31032</b>
15 mm	195	180	2.30 – 1,980 – 7,855	110	<b>221031500</b>
18 mm	230	240	3.07 – 2,640 – 10,485	160	<b>221031800</b>
24 mm	270	450	5.75 – 4,950 – 19,640	230	<b>31035</b>

# Bonding

## Cylinder Brazing

### AIRAC® Set

Acetylene brazing torch up to Ø 35 mm with 2,350 °C

Ideal brazing unit - efficient, weight-saving and fast compared to gas welding units (no additional oxygen cylinders needed)



#### Product Profile

##### KEY FEATURES

- Oxygen from the surrounding air and acetylene are fed without pressure into the burner and with the special construction of the burner produce a flame temperature of 2,350° C with a concentrated, pointed flame for precise and fast work
- Ideal for refrigeration installation

##### KEY FEATURES

- Scale build-up on the treated surface is prevented by the nitrogen that is introduced into the air flow (shielding gas effect)
- Light weight makes transporting easy (one-cylinder system)
- Maximal performance with the turbine and combustion chamber effect
- Shut-off valve prevents uncontrolled gas leaks
- Gas-saving use with the smooth-running economy valve

4



**High-performance injections burner only for acetylene 2,350 °C**  
Powerful operation

**Turbine and combustion chamber effect, self-induced air**  
Maximum performance

**Smooth running economy valve**  
Gas-saving operation

**Shut-off valve**  
Prevents uncontrolled gas leaks

**10-piece set (No. 31093) includes:** Safety handle (No. 211541116), brazing torch size 2 (No. 35022) / size 3 (No. 35023) / size 4 (No. 35024), 2.5 m acetylene hose (No. 35203), bend with nut 150 mm (No. 35110), torch spanner 14 x 19 mm (No. 32073), safety igniter (No. 32077), replacement flints (No. 32079), steel case (No. 35005)

Model	kg	No.
AIRAC® brazing set in steel case	2.9	<b>31093</b>

Further accessories can be found on **162**

### AIRAC® Safety Handle

Safety handle with economy, regulating and shut-off valve, threaded coupling M 16 x 1, hose coupling G 3/8" L



Model	g	No.
Safety handle	290	<b>211541116</b>
Repair kit for shut-off valve, complete	10	<b>30101</b>
Repair kit for regulating valve, complete	10	<b>30102</b>
Repair kit for economy valve, complete	10	<b>30103</b>



### AIRAC® Brazing Torch

Made of surface-handled brass, stable and concentrated flame

Model	Pipe Ø	g	No.
Bend with nut (150 mm)		80	<b>35110</b>
Size 2	12 - 15	40	<b>35022</b>
Size 3	18 - 22	50	<b>35023</b>
Size 4	28 - 35	70	<b>35024</b>

### MULTI MOBILE Set

A mobile soft-soldering cartridge tool for professional applications in sheet metal work and for soldering tin and lead

**Professional soft soldering with maximum mobility and safety!**

#### Product Profile

##### KEY FEATURES

- Ideal for mobile construction sites and service calls
- Titanium combustion chamber and light aluminium hand grip
- No flare-up effect thanks to special Multigas 110 gas cartridge
- Usable in any position (360°) with a constantly stable flame
- Special wind stability due to the combustion chamber's protective design
- Piezo ignition and exact adjustment with a fine regulator valve
- For sheet metal work such as roof gutters, panels and roof edges, ventilation shafts, etc.
- Robust metal case for safe transport

##### TECHNICAL DATA

<b>Copper piece temperature:</b>	600 °C
<b>Heat effect:</b>	945 W
<b>Ignition:</b>	Piezo
<b>Consumption:</b>	75 g/h at 2 bar
<b>Handle diameter:</b>	50 mm
<b>Weight incl. copper piece and cartridge:</b>	890 g

4



Professional soft soldering with high mobility and safety



Fig. MULTI MOBILE Set

Set (No. 100000390) includes: MULTI MOBILE soft-soldering cartridge tool incl. hammer shaped copper piece 250g (No. 100000514), 2 Multigas 110 gas cartridge (No. 1500000459), 2 Düsen (No. 1500000461), steel case (No. 1500000460)

Model	g	No.
Copper piece, hammer shape	250	<b>100000514</b>
Copper piece, pointed shape	245	<b>100000512</b>

Model		No.
MULTI MOBILE Set		<b>100000390</b>
Multigas 110 gas cartridge	12	<b>1500000459</b>

# Bonding

## Cylinder Soft Soldering

### MULTI 300 Propane Soft Soldering Kit

For soft soldering of copper pipes, for tin and lead soldering, for tinning, warming up, flame cleaning, etc.



#### Product Profile

##### KEY FEATURES

- For all types of fine soldering in the areas of electronics and telecommunications
- For working with lead (gutters, laminations and roof edging, ventilation shafts, etc.)

##### TECHNICAL DATA

Propane handle with heat insulated wooden grip  
 Rotatable air / rotary valve for the adjustment of an especially fine flame  
 Rotatable hose coupling M10 x 1 L  
 With longer ball spindle and dual spring control  
 Favourable working pressure with 1.5 bar



No. 35486

Fig. Similar



Fig. Similar

**3-part set** (No. 35486) includes: Soft soldering iron copper head with 350 g flat (No. 520849), 2 m propane hose (No. 30927), small propane cylinder 0.5 kg with hook (No. 33079)

**13-part set** (No. 35488) includes: Soft soldering iron with copper head 350 g flat (No. 520849), soft soldering torch Ø 17 mm (No. 520856) / Ø 20 mm (No. 520857), wide torch 45 mm (No. 520845), propane regulator 0-6 bar (No. 242206000), 2 m propane hose (No. 30927), small propane cylinder 0.5 kg with hook (No. 33079), refilling adaptor (No. 32207), torch spanner (No. 35530), open-ended spanner (No. 32073), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35487)

Model	kg	No.
MULTI 300 / Kit A without propane regulator	4.1	<b>35486</b>
MULTI 300 / Kit A with propane regulator (No. 242206000)	4.3	<b>35489</b>
MULTI 300 / Kit B	9	<b>35488</b>

#### ACCESSORIES



Description	g	No.	Description	g	No.
Soft soldering iron with handle, iron torch, Iron Holder, wind protector, copper head	940	<b>520849</b>	Copper Head 250 g pointed	270	<b>32099</b>
Soft soldering iron with handle, iron burner, Iron Holder, wind protector, without copper head	570	<b>520840</b>	Copper Head 350 g flat	370	<b>32075</b>
Handle with hose coupling M 10 x 1 L	300	<b>520850</b>	Soft soldering torch size 5, Ø 17 mm, M 15 x 1	70	<b>520856</b>
Iron Burner with coupling M 15 x 1	70	<b>520865</b>	Soft soldering burner size 7, Ø 20 mm, M 15 x 1	120	<b>520857</b>
Iron Holder with foot	100	<b>520866</b>	Steel case	3390	<b>35487</b>
Wind protector	100	<b>520867</b>	Torch spanner	60	<b>35530</b>
Copper Head 250 g flat	270	<b>32098 / 32075</b>	Safety igniter with rolling file	60	<b>32077</b>
			Replacement flints, tin with 5 pieces	15	<b>32088</b>

### ROOFING-Set

Propane surface-heating torch with Ø 63 mm high-performance torch nozzle



#### Product Profile

##### APPLICATION AREA

Ideal for roofing and asphalt work and for bonding of bituminous sheeting, large-scale burning of weeds, defrosting, insulation, shrinking, drying and warming up.

##### KEY FEATURES

- Large working range with 5 m propane hose
- Efficient use even in adverse weather conditions with the flame stabiliser
- High-performance burner with flame stabiliser chrome plated with a reinforced edge
- Burner support

##### TECHNICAL DATA

600 mm burner tube  
Burner support



4



Ø 63 mm



**Burner support included!**

5 m Propane hose

Large working range

Ideal for roofing and asphalt work



600 mm burner tube with support and 5.0 m propane hose



5-part set (No. 30954) includes: Propane handle (No. 21511216), 63 mm high-performance torch (No. 223216300), 600 mm torch pipe (No. 236010000), 5.0 m propane hose (No. 32203), torch support (No. 252010000)

Model	g	No.
ROOFING-Set	1,920	<b>30954</b>
ROOFING-Set (as 30954, with Piezo ignition)	1,960	<b>030955X</b>
ROOFING-Set (as 30954, with pressure regulator 30925)	2,300	<b>30957</b>
Burner support	60	<b>252010000</b>

### Extensions

Special tube, chrome plated, angled 40°, inlet M 14 x 1, outlet M 20 x 1



L mm	g	No.	L mm	g	No.
100	90	<b>231010000</b>	350	190	<b>233510000</b>
200	120	<b>232010000</b>	600	290	<b>236010000</b>

### Surface-Heating Torch Heads

High-efficiency torch heads with flame stabilisers, made of special chrome plated steel, reinforced edge. For warming up, shrinking, insulating, hardening, general repair work, etc. Threaded M 20 x 1 coupling




mm	L mm	g/h 2 bar	kWh - kcal - BTU	g	No.
45	102	2500	32.00 - 27,500 - 109,280	240	<b>32045</b>
51	112	3800	48.60 - 41,800 - 165,970	270	<b>32051</b>
63	138	6700	85.70 - 73,700 - 292,670	440	<b>32063</b>
closed					
45	102	2500	32.00 - 27,500 - 109,280	240	<b>223214500</b>
51	112	3800	48.60 - 41,800 - 165,970	270	<b>223215100</b>
57	126	5500	70.35 - 60,500 - 240,257	350	<b>223215700</b>
63	138	6700	85.70 - 73,700 - 292,670	440	<b>223216300</b>

# Bonding

## Accessories Cylinder Brazing / Soft Soldering

### Safety Propane Handles

With economy, regulating and shut-off valves, hose coupling G 3/8" L

Model		No.
Safety Propane handle with push-in coupling	350	<b>211121116</b>
Safety Propane handle with M 14x1 coupling	290	<b>211111116</b>
Repair kit with shut-off valve, complete	10	<b>30101</b>
Repair kit with regulating valve, complete	10	<b>30102</b>




No. 211121116



No. 211111116

### Propane Regulators

Brass, for 0.5 kg, 5 kg and 11 kg cylinders

Inlet	Outlet	Working pressure Bar	Performance kg/h		No.
W 21.8 x 1/14" L	G 3/8" L	0.5 - 4.0	8	240	<b>32081</b>
G 3/8" L	G 3/8" L	0 - 6	8	200	<b>242206000</b>
W 21.8 x 1/14" L	G 3/8" L		8	230	<b>30925</b>



No. 32081




No. 242206000



No. 30925

### Propane Hoses

Top quality, DIN / DVGW tested, with strong inlay, durable and flexible, mounted with sleeves and nuts in middle (DK 6) or high-pressure (DK 30) versions

L m	Inlet	Outlet	Pressure class	Interior-Ø mm Wall thickness		No.
2	G 3/8" L	M 10 x 1 L	DK 6	4.0 x 3.5	310	<b>30927</b>
2.5	G 3/8" L	G 3/8" L	DK 6	4.0 x 3.5	350	<b>32201</b>
5	G 3/8" L	G 3/8" L	DK 30	4.0 x 4.0	730	<b>33310</b>
10	G 3/8" L	G 3/8" L	DK 30	6.3 x 5.0	1,650	<b>32223</b>



No. 30927




No. 32223

### Propane Hose Failure Protection

Nominal pressure 1.5 - 4 bar, brass, DIN / DVGW tested.

Automatic interruption of gas supply if hose is damaged or loosened, push-button for resetting after interruption

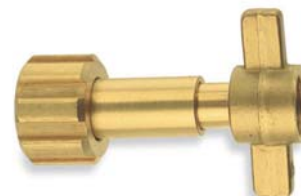
Inlet	Outlet	Performance kg/h	Push button		No.
G 3/8" L	G 3/8" L	10	blue	130	<b>35925</b>



### Refilling Adaptor


For refilling 0.5 propane cylinders from 3.5 or 11 kg propane cylinders, brass with guide pin

Inlet	Outlet		No.
W 21.8 x 1/14" L	G 3/8" L	160	<b>32207</b>



### Propane Lightweight Steel Cylinder

With cylinder valve, TÜV tested, according to TRG

Model	Outlet	Contents		No.
Small cylinder, 0.5 kg with foot	G 3/8" empty		2.75	<b>33079</b>
Protective collar for 33079				<b>35636</b>
Cylinder 5 kg, with foot and cap		filled	12.60	<b>31081</b>
W 21.8 x 1/14" L				



No. 33079

With 0.5 kg cylinder protective collar included in delivery



No. 31081

### ROThERM 2000

Electric soft soldering unit up to Ø 54 mm / 2.1/8"



#### Product Profile

##### APPLICATION AREA

For simple, safe and time-saving soft soldering without a flame. Particularly suitable for repair and modification work in surroundings or rooms with a fire hazard, as well as in building refurbishment

**Soft soldering of Copper pipes up to:**  
Ø 6 - 54 mm, 1/4 - 2.1/8"

##### KEY FEATURES

- Soldering without open flame
- Large working radius, also when working under ceilings
- Comfortable transport and convenient use
- High performance, short soldering times
- Thermal overload protection turns device off automatically

##### KEY FEATURES

- Handle shell will not overheat
- No purchasing on handling of gas cylinders necessary
- Equivalent with transport terms
- Problem-free connection on every 230 V outlet, 2 m connection cable
- Fast return on investment
- Power control lamp (red) and operating control lamp (green), equipment fuse accessible from outside

##### TECHNICAL DATA

<b>Power:</b>	2000 Watt
<b>Soldergun cable:</b>	4 m
<b>Dimensions (L x W x H):</b>	260 x 190 x 200 mm
<b>Weight:</b>	10.5 kg

4



### Soldering without open flame!

Generously dimensioned stainless steel cooling ribs on both shanks of the tongs

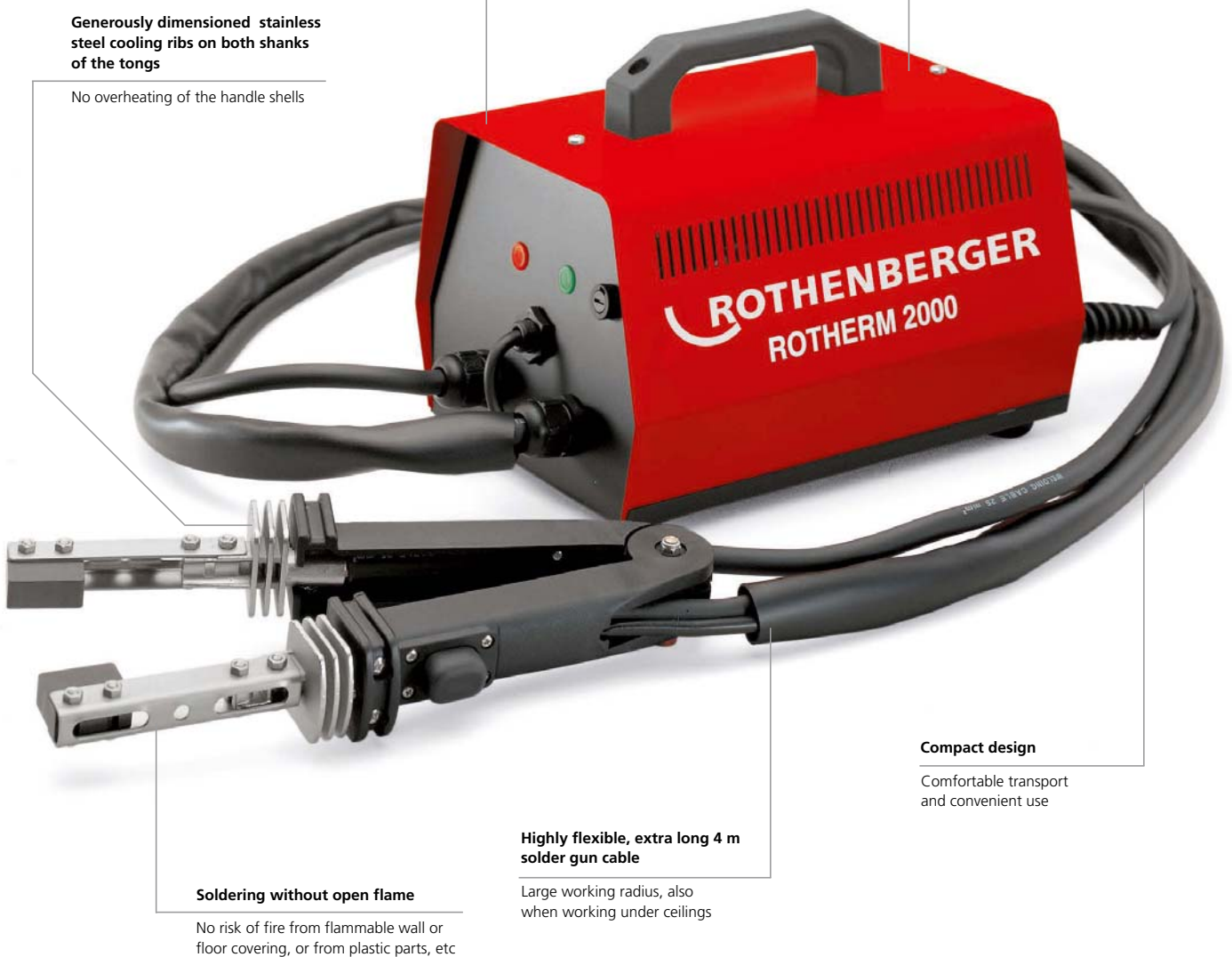
No overheating of the handle shells

Thermal overload protection

Automatic device shut-off

2000 W

High performance, short soldering times



Compact design

Comfortable transport and convenient use

Highly flexible, extra long 4 m solder gun cable

Large working radius, also when working under ceilings

Soldering without open flame

No risk of fire from flammable wall or floor covering, or from plastic parts, etc



# Bonding

## Electric Soft Soldering

### ROTHERM 2000 Soft Soldering Set

Electric soft soldering unit up to Ø 54 mm / 2.1/8"

Set (No. 36702 / No. 036704V) includes: ROTHERM 2000 soft soldering unit 230 V (No. 36700), Rosol 3 fittings soldering paste No. 45225), fitting solder 3 (No. 45255), ROVLIES® (No. 45268), Cu. Internal brushes 10 mm (No. 854180) / 12 mm (No. 854181) / 15 mm (No. 854183) / 18 mm (No. 854185) / 22 mm (No. 854186), steel case (No. 36715)

Particularly suitable for repair and modification work in surroundings or rooms with a fire hazard, as well as in building refurbishment!



4



Warming up of the soldering point without open flame



Rod electrodes for working near to the wall or between parallel running pipes with narrow gaps (can be ordered separately)



Flat electrode



Simple replacement of electrodes and electrode holders



### ACCESSORIES



Model	No.	Model	
Flat electrode (pair)	<b>36721</b>	ROVLIES®	<b>165</b>
Flat electrode with holder (pair)	<b>36711</b>	External brush for copper pipe	<b>165</b>
Rod electrodes (pair)	<b>36720</b>	Soft soldering flux	<b>167</b>
Rod electrodes with holder (pair)	<b>36710</b>	Solders	<b>167</b>
		Internal brush for copper pipe	<b>165</b>

### ALLGAS 2000 Set

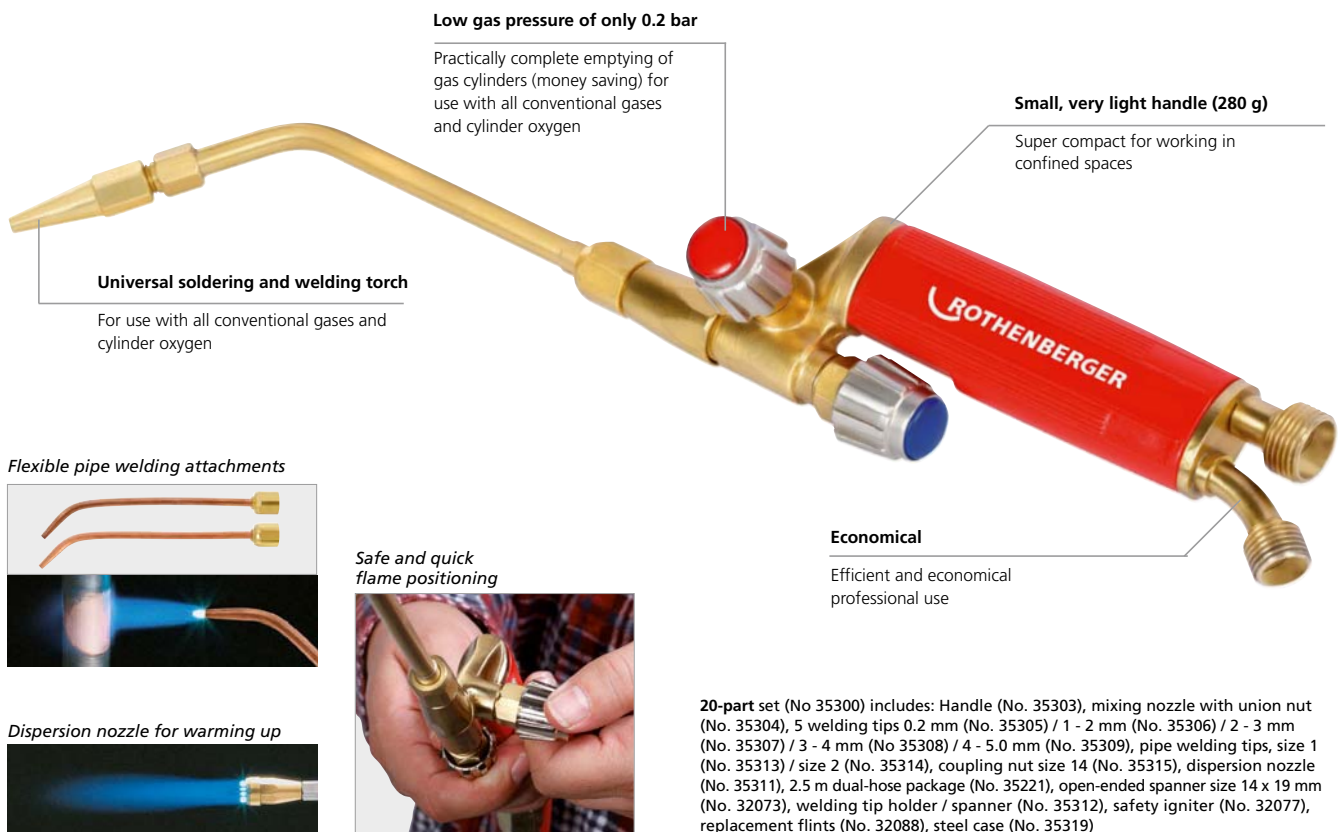
#### Mobile soldering and welding torch

Ideal mobile soldering and welding torch for plumbers, HVAC fitters, refrigeration technicians, automotive workshops and tinsmiths



Product Profile	
APPLICATION AREA	
<b>Soldering range:</b>	up to 2.5 mm material thickness
<b>Welding range:</b>	0.2 - 5 mm
<b>Suitable for use with:</b>	Oxy-Acetylene Propane and oxygen CNG and oxygen Town gas and oxygen

KEY FEATURES
● For use with all conventional gases and cylinder oxygen
● Practically complete emptying of gas cylinders (money-saving)
● Super compact for working in confined spaces
● Efficient and economical professional use



#### Low gas pressure of only 0.2 bar

Practically complete emptying of gas cylinders (money saving) for use with all conventional gases and cylinder oxygen

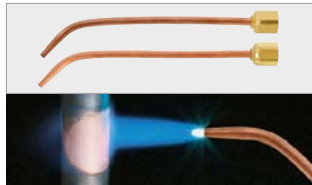
#### Small, very light handle (280 g)

Super compact for working in confined spaces

#### Universal soldering and welding torch

For use with all conventional gases and cylinder oxygen

#### Flexible pipe welding attachments



#### Safe and quick flame positioning



#### Dispersion nozzle for warming up



#### Economical

Efficient and economical professional use

**20-part set (No. 35300)** includes: Handle (No. 35303), mixing nozzle with union nut (No. 35304), 5 welding tips 0.2 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4 - 5.0 mm (No. 35309), pipe welding tips, size 1 (No. 35313) / size 2 (No. 35314), coupling nut size 14 (No. 35315), dispersion nozzle (No. 35311), 2.5 m dual-hose package (No. 35221), open-ended spanner size 14 x 19 mm (No. 32073), welding tip holder / spanner (No. 35312), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35319)

Model	Coupling oxygen	Coupling fuel gas	g	No.
ALLGAS 2000 Set			3,100	<b>35300</b>
Handle ALLGAS 2000	G 1/4" R	G 3/8" L	280	<b>35303</b>
Mixing nozzle with union nut			40	<b>35304</b>

#### Welding tips, Welding attachments

Size	Welding range mm	g	No.
Welding tip size 1	0.2 - 1.0	10	<b>35305</b>
Welding tip size 2	1.0 - 2.0	10	<b>35306</b>
Welding tip size 3	2.0 - 3.0	10	<b>35307</b>
Welding tip size 4	3.0 - 4.0	10	<b>35308</b>
Welding tip size 5	4.0 - 5.0	10	<b>35309</b>
Dispersion nozzle for warming up		20	<b>35311</b>
Welding tip holder, can be used as a spanner		20	<b>35312</b>
Flexible welding tip size 1	2.0 - 3.0	40	<b>35313</b>
Flexible welding tip size 2	4.0 - 5.0	40	<b>35314</b>
Coupling / union nut, size 14		10	<b>35315</b>

Further accessories can be found on 162



Fig. ALLGAS 2000 Set

# Bonding

## Gas-Welding

### ALLGAS 2000 PS 0.5 / 2 Compact

Portable fitter's brazing equipment with carrying frame

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



#### Product Profile

##### KEY FEATURES

- Secure transport in closed supporting frame
- Portable, light fitter's brazing equipment
- Ideal for mobile building-site and repair use
- Small propane cylinders can be refilled

##### TECHNICAL DATA

Gas:	Propane with oxygen
Flame temperature:	2,850 °C
Working temperature:	1,150 °C

**Transport safety according to DIN EN 962, BGV D34, GGVSE und TRG 280!**

24-part set (No. 35655) includes: Handle Allgas 2000 (No. 35303), 2.5 m propane hose (No. 32201), 2.5 m oxygen hose (No. 35210), propane regulator adjustable 0 - 6 bar (No. 242206000), oxygen pressure reducer 10 bar (No. 35634), mixing nozzle with union nut (No. 35304), welding tips 0.2-1 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4-5 mm (No. 35309), flexible welding tip size 1 (No. 35313) / size 2 (No. 35314), dispersion nozzle (No. 35311), welding tip holder / spanner (No. 35312), multi-size spanner (No. 35738), safety igniter (No. 32077), replacement flints (No. 32088), nylon safety goggles (No. 540620), small propane cylinder 0.5 kg, empty (No. 33079), steel oxygen cylinder 2.0 l, full (No. 35635), oxygen safety device (No. 1000000633), fuel gas safety device (No. 1000000631), carrying frame (No. 35629)

Model	kg	No.
ALLGAS 2000 PS 0.5 / 2 Set	21.4	<b>35655</b>
Carrying frame without accessories	10.3	<b>35629</b>

Further accessories can be found on 162

Carrying comfort



**Safety devices included**



The bottle colours shown are without obligation!

### ALLGAS 2000 Welding Tips

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



Welding Tips, Nozzle thread M8 X 1



Size	Welding range mm	g	No.
Welding tip size 1	0.2 - 1.0	10	<b>35305</b>
Welding tip size 2	1.0 - 2.0	10	<b>35306</b>
Welding tip size 3	2.0 - 3.0	10	<b>35307</b>
Welding tip size 4	3.0 - 4.0	10	<b>35308</b>
Welding tip size 5	4.0 - 5.0	10	<b>35309</b>
Dispersion nozzle for warming up		20	<b>35311</b>
Welding tip holder, can be used as a spanner		20	<b>35312</b>



No. 35311



No. 35312

### Flexible Pipe Welding Attachments

Size	Welding range mm	g	No.
Flexible welding tip size 1	2.0 - 3.0	40	<b>35313</b>
Flexible welding tip size 2	4.0 - 5.0	40	<b>35314</b>
Coupling / union nut, size 14		10	<b>35315</b>



### ALLGAS Mobile Pro

#### Mobile brazing equipment with safety devices

For brazing of iron, steel, sheet steel, pipes and non-ferrous metals



#### Product Profile

##### KEY FEATURES

- Mobile brazing set with a total weight lower than 6 kg incl. cartridges
- High quality safety devices for both gas hoses to prevent flashbacks
- MAPP®-gas pressure regulator with an adjustable range of 0 - 2 bar for a constant, low consumption and an efficient flame adjustment

##### TECHNICAL DATA

<b>Gas:</b>	MAPP®-gas with oxygen (disposable)
<b>Flame temperature:</b>	over 3,100 °C
<b>Working temperature:</b>	1,300 °C

#### Accessories included in the set



#### MAPP®<sup>1)</sup> and oxygen

Flame temperature above 3,100 °C

#### Welding and brazing torch

Including 5 interchangeable nozzles and a bendable welding attachment for a material thickness up to 5 mm

#### High quality safety devices

Reliable prevention of gas returns and flashbacks

#### Pressure reducer 0 - 2 bar

Constant, low consumption and efficient flame adjustment

#### Total weight < 6 kg

High mobility on construction site

#### High quality rubber hoses

20 bar, DIN EN ISO 3821 certified, length: 2,5 m



Model	kg	No.
ALLGAS Mobile Pro 1" US, w/o cartridges	3.86	1000000529
ALLGAS Mobile Pro 1" US, incl. cartridges	5.95	1000000743
ALLGAS Mobile Pro 7/16" EU, w/o cartridges	3.86	1000000642
ALLGAS Mobile Pro 7/16" EU, incl. cartridges	5.70	1000000558
MAP//Pro 1" US, 750 ml	0.90	35698
Oxygen, 110 L	1.20	35750



# Bonding

## Gas-Welding

### ALLGAS 2000 PS 0.5 / 2 Basic

#### Portable fitter's brazing equipment

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



#### KEY FEATURES

- Compact and handy construction for mobile building-site and repair use
- Job compatible combination, assembled and ready to use

#### Space saving storage in service vehicles!



**18-part set (No. 35651)** includes: Handle Allgas 2000 (No. 35303), 2.5 m propane hose (No. 32201), 2.5 m oxygen hose (No. 35210), propane regulator adjustable 0 - 6 bar (No. 242206000), oxygen pressure reducer 10 bar (No. 35634), mixing nozzle with union nut (No. 35304), welding tips 0.2 - 1 mm (No. 35305) / 1 - 2 mm (No. 35306) / 2 - 3 mm (No. 35307) / 3 - 4 mm (No. 35308) / 4 - 5 mm (No. 35309), welding tip holder / spanner (No. 35312) multi-size spanner (No. 35738), safety igniter (No. 32077), replacement flints (No. 32088), steel oxygen cylinder 2.0 l, filled (No. 35635), propane cylinder 0.5 kg (empty) (No. 33079), Allgas stand (No. 35628)

Model	kg	No.
ALLGAS 2000 PS 0.5 / 2 Set	14.4	<b>35651</b>
Further accessories can be found on  162		

The bottle colours shown are without obligation!

### ROXY 400 L

#### Standard gas-welding equipment for flame temperatures up to 3,100 °C

For brazing iron, steel, sheet steel, pipes and non-ferrous metals



#### Space saving storage in service vehicles!



**20-part set (No. 035780X)** includes: Handle with fine regulating valve (No. 35580), Maxigas 400 (No. 035570-A), oxygen cylinder 2.0 L (No. 35635), fine regulating valve (No. 263003700), oxygen pressure reducer according to DIN 0-315 / 200 bar 0-16 / 10 bar (No. 35634), hose set (3 m without handle (No. 35785), oxygen blowback protection (No. 35678), gas blowback protection (No. 35691), mixing nozzle with union nut (No. 35587), high-performance tips 1.5 mm (No. 263005600) / 2.0 mm (No. 263005400), micro-tips 0.3 mm (No. 35712) / 0.5 mm (No. 35696) / 0.7 mm (No. 35713), micro-tip adaptor (No. 35585), welding goggles A5 (No. 35621), safety igniter (No. 32077), multi-size spanner (No. 35738) carrying frame (No. 35727)

Model	kg	No.
ROXY 400 L Set	10.80	<b>035780X</b>
ROXY welding handle Profi	0.01	<b>35580</b>
Hose Set (3 m without handle)	0.95	<b>35785</b>
ROXY micro-nozzle adaptor	0.01	<b>35585</b>
ROXY micro-nozzle for 1-1.2 sheet metal	0.04	<b>263005700</b>
ROXY micro-nozzle for 0.7-0.9 sheet metal	0.06	<b>263005800</b>
ROXY micro-torch 0.4 mm	0.01	<b>35695</b>
ROXY micro-torch 0.5 mm	0.02	<b>35696</b>
ROXY micro-torch 0.6 mm	0.02	<b>35697</b>
ROXY micro-torch 0.3 mm	0.01	<b>35712</b>
ROXY micro-torch 0.7 mm	0.01	<b>35713</b>

The bottle colours shown are without obligation!

4



### ROFLASH Set

Welding and cutting kit  
Welding range: 0.5 - 14 mm, Cutting range: 3 - 75 mm

22-part set (No. 513300) includes: Handle (No. 513010), welding attachments 0.2 - 0.5 (No. 513030), 0.5 - 1 (No. 513031), 1 - 2 (No. 513032), 2 - 4 (No. 513033), 4 - 6 (No. 513034), 6 - 9 (No. 513035), 9 - 14 (No. 513036), spring-lever cutting attachment (No. 513310), cutting tips 3 - 6 (No. 513330), 6 - 20 (No. 513331), 20 - 75 (No. 513332), cutting burner guiding wagon, burner spanner (No. 510106), nylon safety goggles (No. 540621), 10 piece nozzle cleaning set (No. 510105)

Model	kg	No.
ROFLASH Set	4.2	513300



Exchange of the welding tip  
Can be used with all types of gas

Cutting oxygen valve with spring-lever  
Enables one-handed use for spray-free cutting, etc.

Fig. Similar



### ROFLASH Handle

Welding kit handle

#### KEY FEATURES

- The new monoblock valves enable the precise adjustment and accurate control of the flame
- Comfortable one-handed use with the v-formed valve arrangement

Model	g	No.
ROFLASH Handle	434	513010

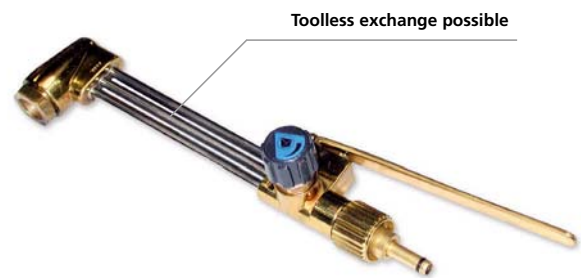


### ROFLASH Spring-lever Cutting Attachment

#### KEY FEATURES

- The solid torch nozzle is made from forged brass and can withstand the highest thermal demands and also enables use under extreme conditions, maintenance-free monoblock valve

Model	g	No.
ROFLASH spring-lever cutting attachment	582	513310
ROFLASH cutting tips 3 - 6 mm	97	513330
ROFLASH cutting tips 6 - 20 mm	97	513331
ROFLASH cutting tips 20 - 75 mm	98	513332



Toolless exchange possible

### ROFLASH Welding Attachments / Welding Tips



Model	g	No.
ROFLASH welding attachments 0.2 - 0.5 mm	96	513030
ROFLASH welding attachments 0.5 - 1.0 mm	96	513031
ROFLASH welding attachments 1.0 - 2.0 mm	104	513032
ROFLASH welding attachments 2.0 - 4.0 mm	117	513033
ROFLASH welding attachments 4.0 - 6.0 mm	128	513034
ROFLASH welding attachments 6.0 - 9.0 mm	148	513035
ROFLASH welding attachments 9.0 - 14.0 mm	171	513036



Model	g	No.
ROFLASH welding tips 0.2 - 0.5 mm	96	513040
ROFLASH welding tips 2.0 - 4.0 mm	126	513043
ROFLASH welding tips 4.0 - 6.0 mm	128	513044
ROFLASH welding tips 6.0 - 9.0 mm	147	513045
ROFLASH welding tips 9.0 - 14 mm	171	513046

# Bonding

## Three-Gas Welding

### RE 17 Three-gas System AMS 5/5

Assembly, welding, cutting and brazing system  
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



Including gas cylinders and dual-telescoping transport trolley!

The bottle colours shown are without obligation!

27-piece set (No. 35400) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), acetylene cylinder 5 l (filled) (No. 35178), oxygen cylinder 5 l (filled) (No. 35188), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354), 5 m dual-hose package A / S (No. 35222), heating nozzle 3 - 100 mm (No. 35339), steel case (No. 35800)

Model	kg	No.
RE 17 Three-gas System AMS 5/5	50	<b>35400</b>

### RE 17 Three-gas System AMS 5 and 10

Assembly, welding, cutting and brazing system  
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



Including dual-telescoping transport trolley!

25-part set (No. 35403) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), heating nozzle 3-100 mm (No. 35339), 5 m dual-hose package A / S (No. 35222), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354)

Model	kg	No.
RE 17 Three-gas System AMS 5 + 10	23	<b>35403</b>

### RE 17 Three-gas System AMS 10/10

Assembly, welding, cutting and brazing system  
Welding range 0.5 - 14 mm, Cutting range 3.0 - 50 mm



Including gas cylinders and dual-telescoping transport trolley!

27-part set (No. 35401) includes: Handle with coupling nut (No. 35324), welding attachments 0.5 - 1 mm (No. 35325) / 1 - 2 mm (No. 35326) / 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329) / 9 - 14 mm (No. 35334), wing-lever cutting attachment (No. 35338), cutting tips 12 - 25 mm (No. 35341) / 25 - 50 mm (No. 35344), heating nozzle 3 - 100 mm (No. 35339), 5 m dual-hose package A / S (No. 35222), acetylene pressure reducer 1.5 bar (No. 35794), oxygen pressure reducer 10 bar (No. 35634), 2 each - protective rubber caps, red (No. 511428) / blue (No. 511427), 10 piece nozzle cleaning set (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), acetylene cylinder 10 l (filled) (No. 35179), oxygen cylinder 10 l (filled) (No. 35189), Maxigas 400 (No. 035570-A), gas regulating valve Maxigas (No. 263003700), hose adaptor Maxigas (No. 35491), steel case (No. 35800), dual-telescoping transport trolley (No. 35354)

Model	kg	No.
RE 17 Three-gas System AMS 10/10	66	<b>35401</b>
RE 17 as in 35401, cutting range 3.0 - 25 mm	65	<b>35798</b>

The bottle colours shown are without obligation!

### RE 17 UNIVERSAL Pipe Welding Set

For welding, cutting, brazing and warming up  
Welding range: 0.5 - 14 mm, Cutting range: 3 - 100 mm



Set (No. 35479) includes: Handle with coupling nut (No. 35324), welding attachments 2 - 4 mm (No. 35327) / 4 - 6 mm (No. 35328) / 6 - 9 mm (No. 35329), flexible pipe-welding tips 2 - 4 mm (No. 35347) / 4 - 6 mm (No. 35348), wing-lever cutting attachment (No. 35338), Cutting tip 3 - 25 mm (No. 35341), Heating nozzle 3 - 100 mm (No. 35339), Nozzle cleaning set, 10 piece (No. 510105), torch spanner (No. 510106), safety igniter (No. 32077), replacement flints (No. 32088), steel case (No. 35800)



No. 35480



No. 35324

⊘ Nominal size	⚖ kg	No.
RE 17 Pipe welding set	4.3	<b>35479</b>
RE 17 Pipe welding set	4.8	<b>35480</b>
As in set (No. 35479), but also including with welding attachments 0.5-1 mm (No. 35325) / 1-2 mm (No. 35326), 9-14 mm (No. 35334) / 25-50 mm (No. 35344), without flexible pipe-welding tips 2-4 mm (No. 35347) / 4-6 mm (No. 35348)		
Steel case RE 17 (empty)	1.70	<b>35800</b>
RE 17 handle with burner coupling nut	0.47	<b>35324</b>
Coupling: oxygen G 1/4" R, gas G 3/8" L		



### RE 17 Welding Attachments

	Welding range mm	⚖ g	No.
Welding attachment	0.5 - 1	140	<b>35325</b>
Welding attachment	1 - 2	150	<b>35326</b>
Welding attachment	2 - 4	170	<b>35327</b>
Welding attachment	4 - 6	190	<b>35328</b>
Welding attachment	6 - 9	220	<b>35329</b>
Welding attachment	9 - 14	260	<b>35334</b>



### RE 17 Pipe Welding Attachment, Flexible

Pipe welding attachment, Flexible copper tips complete

Welding range mm	⚖ g	No.	Welding range mm	⚖ g	No.
			1 - 2	40	<b>35475</b>
2 - 4	140	<b>35347</b>	2 - 4	40	<b>35476</b>
4 - 6	150	<b>35348</b>	4 - 6	50	<b>35477</b>

Pipe welding attachment, front piece



Pipe welding attachment, complete



### RE 17 Wing-lever Cutting Attachment

Model	⚖ g	No.
Cutting attachment without tips	820	<b>35338</b>



### RE 17 Cutting Tips and Heating Nozzle

Model	Cutting range mm	⚖ g	No.
Cutting tip	12 - 25	10	<b>35341</b>
Cutting tip	25 - 50	20	<b>35344</b>
Cutting tip	50 - 100	20	<b>35345</b>
Heating nozzle	3 - 100	50	<b>35339</b>



No. 35338



No. 35341  
No. 35344  
No. 35345

No. 35339



# Bonding

## Accessories Soldering & Welding



### Oxy-Acetylene Hoses

Top quality in accordance with **DIN 8541**, with strong inlay, durable and flexible, rubber, mounted with sleeves and nuts



### Oxygen Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
2.5	G 1/4" R	G 1/4" R	6.0 x 3,5	0.5	<b>35210</b>
5	G 1/4" R	G 1/4" R	6.0 x 3.5	1.1	<b>33311</b>
10	G 1/4" R	G 1/4" R	6.0 x 3.5	1.9	<b>33314</b>

### Acetylene Hoses

L m	Inlet	Outlet	Internal Ø x wall thickness mm	kg	No.
2.5	G 3/8" L	G 3/8" L	6.0 x 3.5	0.5	<b>35203</b>
5	G 3/8" L	G 3/8" L	6.0 x 3.5	1.1	<b>33312</b>
10	G 3/8" L	G 3/8" L	6.0 x 3.5	1.9	<b>33315</b>

### Dual Hoses A/S

L m	Coupling Oxygen	Coupling Outlet	Internal Ø x wall thickness Oxygen / Acetylene	kg	No.
2.5	G 1/4" R	G 3/8" L	6.0 x 3.5	0.9	<b>35221</b>
5	G 1/4" R	G 3/8" L	6.0 x 3.5	2.0	<b>35222</b>
10	G 1/4" R	G 3/8" L	6.0 x 3.5	3.8	<b>35223</b>
40*	G 1/4" R	G 3/8" L	6.0 x 3.5	9.1	<b>35230</b>

\*40 m hose without sleeves and nuts



Included in delivery for steel cylinders without cap, protective bracket



The bottle colours shown are without obligation!

### Lightweight Steel Cylinders, filled

With cylinder valve, base and cap from 5 l, TÜV tested in accordance with TRGI

Model	Contents	Filling pressure bar	Height mm	Ø mm	kg	No.
Oxygen	2 l	200	420	110	4.6	<b>35635</b>
Oxygen	5 l	200	595	145	14.0	<b>35188</b>
Oxygen	10 l	200	980	145	17.0	<b>35189</b>
Acetylene	5 l	18	595	145	13.0	<b>35178</b>
Acetylene	10 l	18	980	145	23.0	<b>35179</b>



### Cylinder Transport Trolley

Portable and mobile, for 5 and 10 l acetylene / oxygen cylinders, 5 kg and 12 kg propane cylinders can be used with conversion kit (special accessory). Coupling for disposable MAXIGAS 400 cartridges, dual-telescoping for different cylinder heights, brackets for ALLGAS and RE 17 steel cases

Model	kg	No.
Transport Trolley for 5 / 10 l acetylene / oxygen cylinders	8.9	<b>35354</b>
Conversion kit for adaption of Propane 0.5 kg / oxygen 5 l and 10 l cylinders		<b>35342</b>



### Cylinder Pressure Reducer

Rugged pressed brass construction with large pressure gauge according to **DIN 8549** (Ø 63 mm), with shut-off and safety valves, one-stage design according to **DIN 8546** with test mark

**DIN**  
-Norm



No. 35634



No. 35794

Cylinder contents bar	Working pressure bar	Inlet	Outlet	kg	No.
Oxygen					
0 - 315 / 200	0 - 16 / 10	G 3/4"	G 1/4" R	1.4	<b>35634</b>
Acetylene					
0 - 40	0 - 2.5/1.5	G 3/4"	G 3/8" L	1.6	<b>35794</b>

### Blowback Prevention

Torch-mounted safety devices (flashback arrestors), type-tested, with flame trap, flow lock, non-return valve and dirt filter

Model	max. Operating pressure	Coupling-thread	g	No.
Handle-mounted, oxygen	25 bar	G 1/4" R	90	<b>540320</b>
Handle-mounted, acetylene	1.5 bar (Ace)	G 3/8" L	110	<b>540321</b>
	5 bar (propane/CNG)			
Reducer-mounted, oxygen	20 bar	G 1/4" R	150	<b>540360</b>
Reducer-mounted, acetylene	1.5 bar (Ace)	G 3/8" L	160	<b>540365</b>
	4 bar (propane/CNG)			
Reducer-mounted, oxygen	20 bar	G 1/4" R	120	<b>100000633</b>
Reducer-mounted, fuel gas	1.5 bar (Ace)	G 3/8" L	120	<b>100000631</b>
	5 bar (propane/CNG)			
Handle-mounted, oxygen	20 bar	G 1/4" R	100	<b>100000764</b>
Handle-mounted, fuel gas	1.5 bar (Ace)	G 3/8" L	100	<b>100000762</b>
	4 bar (propane/CNG)			



No. 540320



No. 540321



No. 540360



No. 540365



No. 100000633



No. 100000631



No. 100000764



No. 100000762

### Protective Guard for Pressure Reducer

Impact protection, rugged steel construction, mounts on connection coupling

Model	Colour	g	No.
For oxygen pressure reducer	blue	820	<b>35146</b>
For acetylene pressure reducer	yellow	820	<b>35140</b>



### Protective Rubber Cap

With slot, open

Model	Farbe	g	No.
For oxygen pressure reducer	blue	50	<b>511427</b>
For acetylene pressure reducer	red	50	<b>511428</b>



### Oxygen Refilling Bend

Suitable for all 0.67l, 2l, 3l, 5l, 10l, 20l and 50l bottles up to 200 bar

Model	g	No.
max. 200 bar, cylinder coupling G 3/4"	360	<b>35199</b>



### Safety Igniters

Powerful spark, wear-free hard alloy friction surface

Model	g	No.
Safety Igniter with rolling file	60	<b>32077</b>
Replacement flints, tin with 5 pieces	15	<b>32088</b>



No. 32077



No. 32088



# Bonding

## Accessories Soldering & Welding



No. 540850



No. 540855

### Hand-held Welding Mirror

Model	g	No.
Steel wire handle with clamp / ball joint	280	<b>540850</b>
Spare steel mirror	50	<b>540851</b>

### Magnet Welding Mirror

Model	g	No.
With flexible metal tube / ball joint	450	<b>540855</b>
Spare steel mirror	50	<b>540851</b>



### Nozzle Cleaner

Model	g	No.
10 piece, in folding case	20	<b>510105</b>



### Torch Spanner

Model	g	No.
With 11 SW	210	<b>510106</b>



### Soldering Flux and Container for Hydrochloric Acid

Model	g	No.
With screw cap retaining band	40	<b>530250</b>



### Salmiakstone

Model	L x W x H	g	No.
Pressed	65 x 45 x 40 mm	15	<b>530310</b>



### Soapstone Marker

Model	L x W x H	g	No.
White, heat-resistant	100 x 10 x 10 mm	30	<b>561550</b>



No. 540620

No. 540622



No. 540640

### Welding Goggles DIN EN 166

With thermal glasses as per DIN EN 169






Model	Glass	g	No.
Nylon safety goggles	A 4	60	<b>540620</b>
	A 5	60	<b>540621</b>
Replacement glass (pair)	clear, non-splintering	60	<b>540622</b>
	A 4	30	<b>540625</b>
	A 5	10	<b>540626</b>
	clear, non-splintering	30	<b>540627</b>
Screw-ring safety goggles	A 4	90	<b>540640</b>
	A 5	90	<b>540641</b>
Replacement glass (Ø 50 mm)	A 4	30	<b>540675</b>
	A 5	10	<b>540676</b>

### ROVLIES® Cleaning Pads

Metal-free, for fast, score-free cleaning of copper pipe soldering surfaces

#### KEY FEATURES

- Reduced corrosion damage
- No metal abrasion, can be used wet or dry
- Removes oxide layers, corrosion, surface dirt, oil and grease residues
- Solvent-resistant and flexible

Model				No.
ROVLIES®	1(10)		80	<b>45268</b>
ROVLIES® counter display		36(10)	2,180	<b>045268D</b>







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### Internal Brushes for Copper Pipe





For fast cleaning of the soldering surface, rugged plastic handle

	mm		No.		mm		No.
	8	60	<b>854179</b>		16	120	<b>854184</b>
	10	70	<b>854180</b>		18	120	<b>854185</b>
	12	80	<b>854181</b>		22	140	<b>854186</b>
	14	90	<b>854182</b>		28	140	<b>854187</b>
	15	100	<b>854183</b>		35	160	<b>854188</b>




### External Brushes for Copper Pipe

For fast cleaning of the soldering surface, tough housing

	mm		No.		mm		No.
	8	80	<b>854189</b>		16	130	<b>854194</b>
	10	90	<b>854190</b>		18	140	<b>854195</b>
	12	100	<b>854191</b>		22	150	<b>854196</b>
	14	110	<b>854192</b>		28	160	<b>854197</b>
	15	120	<b>854193</b>		35	170	<b>854198</b>



### Hand Wire Brushes

Model	Numbers of rows		No.
Standard steel	3 rows	130	<b>561351</b>
Standard steel	4 rows	130	<b>561352</b>




### Welding Blanket

Flame and heat resistant up to 1,000° C

- Permanent heat resistance up to 900° by direct flame contact and molten slag
- Good formability, long service life, asbestos-free and poses no health hazard
- Bonded edges

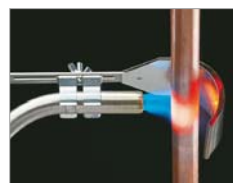
Thickness: 1.4 mm  
Weight: 1,000 g/m<sup>2</sup>




Model	L x W x H		No.
Welding Blanket	330 x 500 mm	300	<b>31050</b>

### Flame Reflectors

- Made of high-quality stainless steel
- Protects surrounding materials
- Better heat utilisation, saves time and energy



Model	Width mm	Adaptor Ø mm		No.
65 / 15	65	8 – 15	100	<b>31042</b>
65 / 22	65	15 – 22	100	<b>31043</b>

# Bonding

## Accessories Soldering & Welding

### Fitting Soft Solder to DIN EN

Standard type according to DIN EN 29 453	Solder composition in weight %	Melting range °C	Suitable for soft soldering in the plumbing industry			Recommended heat source
			Pipe Material	Fittings material	Recommended Flux according to DIN EN 29454	
<b>S -Sn97Cu3</b>	Sn 97 %, Cu 3 %	230 - 250°	Copper	Copper, gunmetal, brass	Part 1 - 3.1.1, 3.1.2, 2.1.2 or ROSOL 3	Cartridge burner, heat resistant soldering unit, Propane / induced-air burner, Acetylene / induced-air burner, Larger pipe diameters above 28 mm with propane / oxygen burner with dispersion nozzle
<b>S -Sn97Ag3</b>	Sn 96.7 %, Ag 3.3 %	221 - 240°	Copper	Copper, gunmetal, brass	Part 1 - 3.1.1, 3.1.2, 2.1.2 or ROSOL 1 S	




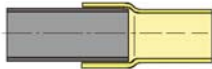
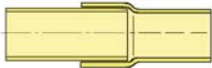

### Standard Solder according to DIN EN

Standard type according to DIN EN 1044	Solder composition in weight %	Melting range °C	Working temperature °C	Suitable for installation technology brazing			Recommended Flux according to DIN EN 29454	Recommended heat source
				Pipe Material	Fittings material	Flux		
<b>CP 203</b>	P 5.9 - 6.5 / Cu rest	710 - 880°	730°	Copper	Copper Gunmetal Brass	without flux with flux	F-SH 1 or LP 5	Cartridge torch with MAPP <sup>®1)</sup> Gas, Propane / induced-air torch, Acetylene / induced-air torch, Larger pipe diameters above 28 mm with propane / oxygen torch with dispersion nozzle
<b>CP 105</b>	Ag 1.5 - 2.5 / P 5.9 - 6.5 / Cu rest	650 - 810°	710°	Copper	Copper Gunmetal Brass	without flux with flux	F-SH 1 or LP 5	
<b>CP 104</b>	Ag 4.0 - 6.0 / P 5.7 - 6.3 / Cu rest	650 - 810°	710°	Copper	Copper Gunmetal Brass	without flux with flux	F-SH 1 or LP 5	
<b>CP 102</b>	Ag 14.0 - 16.0 / P 4.7 - 5.3 / Cu rest	650 - 800°	710°	Copper	Copper Gunmetal Brass	without flux with flux	F-SH 1 or LP 5	
<b>AG 106</b>	Ag 33 - 35 / Cu 35 - 37 Sn 1.5 - 2.5 / Zn rest	630 - 730°	710°	Stahl Copper	Steel, Copper Gunmetal Brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	
<b>AG 104</b>	Ag 44 - 46 / Cu 26 - 28 Sn 2.5 - 3.5 / Zn rest	640 - 680°	670°	Stahl Copper	Steel, Copper Gunmetal Brass	with flux (U = sheathed from 22 mm pipe-Ø)	F-SH 1 or LP 5	

4



### Soldered Joints

Material	Required Hard Solder	Melting Range	Working Temperature	Standard
<b>Copper-Copper</b> 	S 34 Cu / S 34 Cu U S 94 / S 94 XN / S1 S 2 / S 5 S 15	630 °C - 730 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 800 °C	710 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Copper-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN 1044
<b>Copper-Brass</b> 	S 94 / S 94 XN / S1 S 2 S 5 S 15	710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Brass-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	600 °C - 690 °C 595 °C - 630 °C	680 °C 610 °C	DIN EN 1044
<b>Brass-Brass</b> 	S 94 / S 94 XN S 1 (nicht genormt) S 2 / S 5 S 15	710 °C - 880 °C 710 °C - 880 °C 650 °C - 810 °C 650 °C - 810 °C	730 °C 730 °C 710 °C 710 °C	DIN EN 1044
<b>Carbon Steel-Carbon Steel</b> 	S 34 Cu / S 34 Cu U S 45 Cu / S 45 Cu U	630 °C - 730 °C 640 °C - 680 °C	710 °C 670 °C	DIN EN 1044

1) MAPP<sup>®</sup> is a registered trademark of MESSER GRIESHEIM GMBH, Frankfurt am Main


### Fittings Solders

Quality soft solders for joining copper pipes to copper, gunmetal and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 2 without flux, for use with corresponding ROSOL fittings solder paste

DIN  
-Norm

### Fitting Solder 1 S

Quality soft solder **S-Sn97Ag3**, melting range 221 °C – 240 °C, for use with ROSOL 1 S fittings solder paste


Solder wire Ø	Description	 g	No.
2 mm	250 g coil	270	<b>45252</b>
3 mm	250 g coil	270	<b>45250</b>



No. 45252

### Fitting Solder 3

Quality soft solder, **S-Sn97Cu3**, melting range 230 °C - 250 °C, for use with ROSOL 3 fittings solder paste

Solder wire Ø	Description	 g	No.
2 mm	250 g coil	270	<b>45257</b>
3 mm	250 g coil	270	<b>45255</b>



No. 45257

DIN  
-Norm

### ROSOL Soldering Paste

Quality soft soldering flux according to **DIN EN ISO 9453** and **DIN EN 29454-1, 3.1.1.C, with DVGW test mark Reg.-No. DV-0101AT2247**, for joining copper pipes to copper, gunmetal and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 7, metal content 60% by weight, flux residues are 100% water soluble

DIN  
-Norm




No. 45220

No. 45225

### ROSOL 1 S

#### Fittings solder paste


Quality soft soldering flux, metal content: **S-Sn97Ag3**, only for use with fitting solder 1 S

Model	 g	No.
ROSOL 1 S in plastic bottle 250 g	270	<b>45220</b>

### ROSOL 3

#### Fittings solder paste


Quality soft soldering flux, metal content: **S-Sn97Cu3**, only for use with fittings solder 3

Model	 g	No.
ROSOL 3 in plastic bottle 250 g	270	<b>45225</b>

### Fittings Soft Solder Flux

According to **DIN EN 29454-1 3.1.1.C**, flux residues are 100 % water soluble, for joining copper pipes to copper, gunmetal, and brass fittings for hot and cold-water plumbing in accordance with DVGW worksheet GW 2 + GW 7, also suitable for general-purpose soldering work.

DIN  
-Norm

Model	 g	No.
Fittings Soft Solder Flux in plastic tube 35 ml	45	<b>45266</b>





### Hard Solder Rings S 2

High-quality safety solder material with silver-phosphorus content, guaranteed according to DIN EN 1044, CP 105

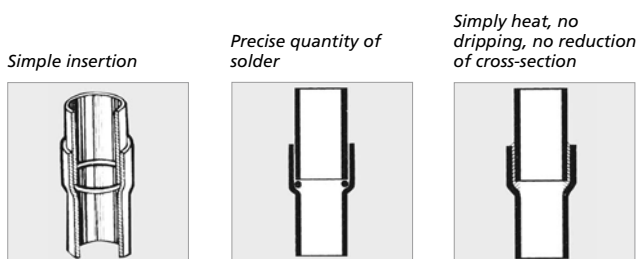
#### KEY FEATURES

- Ideal for capillary soldering with copper pipe installation in sanitary and heating systems
- Matched precisely to the inner pipe diameters of expanded sockets and fittings according to **EN 1254**
- Complete wetting of soldering gaps
- Particularly efficient working through precise solder quantity
- No preparatory or re-work of the soldered joint

#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 1.5 - 2,5 / P 5.9 - 6.5 / Cu rest
<b>Melting range:</b>	650 °C - 810 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Use of flux with:</b>	Gunmetal, brass, bronze with hard solder paste LP 5
<b>Package size:</b>	250 g plastic bag

4



Outside Ø mm	approx. Content rings	g	No.
Hard solder rings S 2, Ø 12 mm	395	260	<b>40512</b>
Hard solder rings S 2, Ø 14 mm	268	260	<b>40514</b>
Hard solder rings S 2, Ø 15 mm	244	260	<b>40515</b>
Hard solder rings S 2, Ø 16 mm	228	260	<b>40516</b>
Hard solder rings S 2, Ø 18 mm	186	260	<b>40518</b>
Hard solder rings S 2, Ø 22 mm	106	260	<b>40522</b>
Hard solder rings S 2, Ø 28 mm	79	260	<b>40528</b>



### Hard Solder Paste LP 5

Flux for hand soldering at working temperatures above 600 °C, according to **DIN EN 1045 - FH 10, DVGW tested Reg.-No. DV-0101-AT2245**, for gas and water installations with copper pipes, recommended by DVGW in accordance with Worksheets GW 2 and GW 7, hard solders with silver content and usable with any basic materials of steel, copper and copper alloys, brass and gunmetal, working temperature range 550 °C – 800 °C, flux residues must be removed carefully

Description	g	No.
LP 5 in plastic bottle 160 g	180	<b>40500</b>



### Hard Solder Powder HKM

Flux for hard soldering at working temperatures above 800 °C, according **DIN EN 1045 - FH 21**, working temperature 800 °C – 1,100 °C, for copper and copper alloys, brass, gunmetal, nickel silver, bronze, steel and galvanised steel, grey iron and malleable cast iron, for welding copper and brass in dry conditions, can be mixed with clean water to form a paste, flux residues must be removed carefully. Free of boric acid.

Description	g	No.
HKM in plastic bottle 160 g	180	<b>35611</b>



### Flux Brush

Description	Width mm	Length mm	g	No.
Flux Brush	13	140	20	<b>530261</b>

### Hard Solders

#### For copper pipe installation

ROTHENBERGER ROLOT special hard solders are particularly suited for copper pipe installations in cold and hot water systems, for open and closed heating systems, for gas installations in accordance with DVGW Worksheet GW 2 (liquid, natural and town gas), as well as for HVAC and refrigeration applications, and oil pipes. ROTHENBERGER ROLOT is especially suited for capillary soldering of copper pipes without fittings. Copper / phosphorus / silver solders are highly formable, and are therefore recommended for joints that are subjected to high thermal and mechanical alternating loads.

#### KEY FEATURES

- Non-foaming. Heat- resistant up to 200 °C
- No flux required with copper / copper joints
- Flux LP 5 is to be used when joining brass, gunmetal, copper, tin and copper / tin alloys
- Not to be used with materials containing sulphur, with iron / nickel alloys or with copper alloys containing nickel
- Manufactured with new, environmentally compatible technology, corrosion neutral, scale-free, improved flow properties



### ROLOT® S 94 CP 203

Quality hard solder **guaranteed according to DIN EN 1044**, due to low phosphorus content, the solder has a wide melting range, and gives soldered joints with increased strength. Standard solder for normally-stressed copper pipe installation, especially for capillary soldering with copper pipe installation without fittings

#### TECHNICAL DATA

<b>Alloy (weight %):</b>	P 5.9 - 6.5 Cu rest
<b>Melting range:</b>	710 °C – 880 °C
<b>Working temperature:</b>	730 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with LP 5

**Guaranteed according to DIN EN 1044!**



Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1,025	<b>40094</b>
1 kg carton	3 x 3	500	1,025	<b>40095</b>
5 kg plastic bag	2 x 2	500	5,025	<b>040094A</b>
400 g blister	2 x 2	500	420	<b>1000000133</b>

### ROLOT® S 94 XN CP 203

Quality brazing solder, **guaranteed according to DIN EN 1044**, due to the special manufacturing method it has excellent flow characteristics, uniform melting for perfect soldered joints, capillary and air-tight active, ideal for capillary gap soldering in sanitary, heating and gas installation

#### TECHNICAL DATA

<b>Alloy (weight %):</b>	P 5.9 - 6.5 Cu rest
<b>Melting range:</b>	710 °C – 880 °C
<b>Working temperature:</b>	730 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with LP 5

**Guaranteed according to DIN EN 1044!**



Contents	Squared section mm	Length mm	g	No.
1 kg carton	2 x 2	500	1,025	<b>040097X</b>

### ROLOT® S 1

Special quality brazing solder, not standardised, **similar to DIN EN 1044**, for normally-stressed copper pipes systems, also for gap soldering for copper pipe installations without fittings

#### TECHNICAL DATA

<b>Melting range:</b>	710 °C – 880 °C
<b>Working temperature:</b>	730 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Brass, gunmetal, bronze LP 5




Contents	mm	Length mm	g	No.
1 kg carton	2	500	1,025	<b>40102</b>



# Bonding


## Accessories Soldering & Welding




Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	<b>40202</b>
400 g blister	2 x 2	500	420	<b>1000000135</b>

**Guaranteed according to DIN EN 1044!**




Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	<b>40212</b>
1 kg carton	3 x 3	500	1,025	<b>40213</b>
400 g blister	2 x 2	500	420	<b>1000000134</b>



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	<b>40502</b>
400 g blister	2 x 2	500	420	<b>1000000137</b>

**Guaranteed according to DIN EN 1044!**



Contents	Square mm	Length mm		No.
1 kg carton	2 x 2	500	1,025	<b>40005</b>
400 g blister	2 x 2	500	420	<b>1000000136</b>

### ROLOT® S 2

Special quality hard solder, not standardised, **similar to DIN EN 1044**, with low silver content, matched to normally-stressed copper pipe system, ideal for capillary gap soldering

#### TECHNICAL DATA

<b>Melting range:</b>	710 °C – 820 °C
<b>Working temperature:</b>	720 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with hard solder paste LP 5

### ROLOT® S 2 CP 105

Silver / phosphorus safety hard solder, **guaranteed according to DIN EN 1044**, for higher-stressed copper pipe systems, ideal for capillary soldering in sanitary, heating and gas installations

#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 1.5 – 2.5 / P 5.9 – 6.5 / Cu rest
<b>Melting range:</b>	650 °C – 810 °C
<b>Working temperature:</b>	710 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with hard solder paste LP5

### ROLOT® S 5

Particularly high quality hard solder, not standardised, **similar to DIN EN 1044**, with low silver content, ideal for capillary and joint soldering in sanitary, heating and gas installations

#### TECHNICAL DATA

<b>Melting range:</b>	710 °C – 820 °C
<b>Working temperature:</b>	720 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with hard solder paste LP5

### ROLOT® S 5 CP 104

High-quality silver/phosphorus safety hard solder, **guaranteed according to DIN EN 1044**, for higher-stressed copper pipe systems, ideal for capillary and joint soldering in sanitary, heating and gas installations

#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 4 – 6 / P 5.7 – 6.3 / Cu rest
<b>Melting range:</b>	650 °C – 810 °C
<b>Working temperature:</b>	710 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with hard solder paste LP5



### ROLOT® S 15 CP 102

Particularly high quality silver hard solder, **guaranteed according to DIN EN 1044**, especially for capillary-gap soldering subject to high thermal and mechanical alternating loads in HVAC systems, as well as demanding sanitary and gas installations

**Guaranteed according to DIN EN 1044!**



#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 14.0 – 16.0 / P 4.7 – 5.3 / Cu rest
<b>Melting range:</b>	650 °C – 800 °C
<b>Working temperature:</b>	710 °C
<b>Joinable materials:</b>	Copper, gunmetal, brass, bronze
<b>Flux required with:</b>	Gunmetal, brass, bronze with hard solder paste LP5

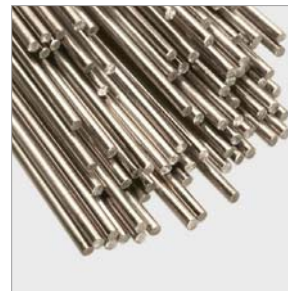
Contents	Square mm	Length mm	g	No.
1 kg carton	2 x 2	500	1,025	<b>40015</b>



### Silver Hard Solders Ag 106 S 34 Cu / S 34 Cu U flux-covered

**Free of cadmium**, quality silver hard solder **guaranteed according to DIN EN 1044**, plain (S 34 Cu) or flux-covered according to DIN EN 29454 F-SH 1 (S 34 Cu U), universal application areas for gap soldering, also for drinking water installations, heat-resistant up to 200 °C

**Guaranteed according to DIN EN 1044!**



#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 33.0 – 35.0 / Cu 35.0 – 37.0 Sn 1.5 – 2.5 / Zn rest
<b>Melting range:</b>	630 °C – 730 °C
<b>Working temperature:</b>	710 °C
<b>Joinable materials:</b>	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys
<b>Flux required:</b>	for S 34 Cu generally with hard solder paste LP 5

Contents	mm	g	S 34 No.	S 34 U No.
100 g plastic bag	2	110	<b>44910</b>	<b>44915</b>
250 g plastic bag	2	260	<b>44911</b>	<b>44916</b>
1000 g plastic bag	2	1,010	<b>44912</b>	<b>44917</b>

### Silver Hard Solders Ag 104 S 45 Cu / S 45 Cu U flux-covered

**Free of cadmium**, quality silver hard solder, **guaranteed according to DIN EN 1044**, plain (S 45 Cu) or flux-covered according to DIN EN 29454 F-SH 1 (S 45 Cu U), universal application areas for gap soldering, excluding drinking water installations, heat-resistant up to 200 °C

**Guaranteed according to DIN EN 1044!**



#### TECHNICAL DATA

<b>Alloy (weight %):</b>	Ag 44.0 – 46.0 / Cu 26.0 – 28.0 Sn 2.5 – 3.5 / Zn rest
<b>Melting range:</b>	640 °C – 680 °C
<b>Working temperature:</b>	670 °C
<b>Joinable materials:</b>	Steel, malleable cast iron, copper, gunmetal, copper and nickel alloys, stainless steel
<b>Flux required:</b>	for S 45 generally with hard solder paste LP 5

Contents	mm	g	S 45 No.	S 45 U No.
100 g plastic bag	2	110	<b>45050</b>	<b>45055</b>
250 g plastic bag	2	260	<b>45051</b>	<b>45056</b>
1000 g plastic bag	2	1,010	<b>45052</b>	<b>45057</b>