

# INTERNAL DEBEADERS

## A simple and effective tool for removing internal beads

A manual kit for the simple and effective removal of internal beads formed during the butt fusion process for polyethylene pipes in the size range 110-450mm

### FEATURES

- Rods can be assembled to debeat pipe up to 13m in length - more on request
- Portable kit
- Bead retained in head after withdrawal
- Robust build quality
- Simple to assemble, easy to use
- National Grid approved

### Fusion's internal debeader allows:

- Quality control procedures from visual bead inspection (i.e. bend back test)
- Quality assurance records (i.e. archiving beads and data print-out for joint history)
- Removal of internal bead increases flow
- Protection for pipelines carrying sewage or other media where entrained solids could become attached to an internal bead and cause a blockage

### Selection chart - internal debeading head size and setting

| SDR | 44        | 32        | 26        | 17        | 11        | 7.3       |
|-----|-----------|-----------|-----------|-----------|-----------|-----------|
| O/D | HEAD SIZE | HEAD SIZE | HEAD SIZE | HEAD SIZE | HEAD SIZE | HEAD SIZE |
| 110 |           |           |           | 1(B)      | 1(A)      |           |
| 125 |           |           |           | 1(D)      | 1(C)      | 1(A)      |
| 140 |           |           |           | 1(A)      | 1(D)      | 1(C)      |
| 160 | 2(B)      | 2(B)      | 2(B)      | 2(B)      | 2(B)      | 1(D)      |
| 180 | 3(A)      | 2(C)      | 2(C)      | 2(C)      | 2(B)      | 2(B)      |
| 200 | 3(A)      | 3(A)      | 3(A)      | 3(A)      | 2(C)      | 2(B)      |
| 225 | 3(B)      | 3(B)      | 3(B)      | 3(B)      | 3(A)      | 2(C)      |
| 250 | 3(C)      | 3(C)      | 3(C)      | 3(C)      | 3(B)      | 3(A)      |
| 280 | 4(B)      | 4(B)      | 4(B)      | 3(C)      | 3(C)      | 3(B)      |
| 315 | 4(C)      | 4(C)      | 4(C)      | 4(B)      | 4(A)      | 3(C)      |
| 355 | 4(D)      | 4(D)      | 4(D)      | 4(C)      | 4(C)      | 4(A)      |
| 400 |           |           |           | 4(D)      | 4(C)      | 4(B)      |
| 450 |           |           |           | 4(D)      | 4(D)      |           |

Note: Each debeader head size has multiple settings. These are referred to in the table as A, B, C or D. To select the correct head size you will need to know the outer diameter of the pipe you wish to debeat (see first column) and its SDR (see top row).

If you have any questions please email Mill-Pro at [info@mill-pro.com.hk](mailto:info@mill-pro.com.hk)

### SPECIFICATION

| Product Code | Description                       | Weight |
|--------------|-----------------------------------|--------|
| IBRTKIT      | Kit supplied with heads 1,2, 3, 4 | 70kg   |
| IBRT1        | Kit with head 1 only              | 40kg   |
| IBRT2        | Kit with head 2 only              | 40kg   |
| IBRT3        | Kit with head 3 only              | 42kg   |
| IBRT4        | Kit with head 4 only              | 63kg   |
| 31681        | Spare blade for head 1 and 2      | N/A    |
| 32187        | Spare blade for head 3 and 4      | N/A    |



| Complete internal debeading kit (product code: IBRTKIT) comprises: |                                |
|--|--------------------------------|
| Product Code   | Description                    |
| 11769  | 1 x storage box                |
| 11560  | 1 x drive handle               |
| 21459  | 1 x no. 1 size head            |
| 21457  | 1 x no. 2 size head            |
| 21453  | 1 x no. 3 size head            |
| 21451  | 1 x no. 4 size head            |
| n/a  | Allen keys                     |
| n/a  | 1 x set operating instructions |
| 32740  | 3 x size 1 rod supports        |
| 31754  | 3 x size 2 rod supports        |
| 21803  | 3 x size 3 rod supports        |
| 21310  | 3 x size 4 rod supports        |
| 21859  | 3 x size 4b rod supports       |
| 69046  | 1 x rod bag                    |
| 21560  | 6 x 2 meter rods               |
| 21618  | 1 x 1 meter rod                |
| Extras   |                                |
| 91425  | Adaptor for 450mm SDR11        |
| 91474  | Adaptor for 450mm SDR17.6      |
| 51416  | 2 x screws                     |