

## H&M Pipe Beveling

In 1934 we produced the industry's very first portable pipe cutting and beveling machine. Determined to be the leader, we continue to set precision, quality and portability standards for not only saddle-type pipe cutting and beveling machines, but also band-type beveling machines, shape cutting attachments and accessories.

We offer the industry's most comprehensive, factory one-year warranty on everything we manufacture. We also provide the industry with our exclusive five-year service guarantee on all H&M Models 0 through 4 Standard Beveling Machines. All of our equipment is produced in the USA.

Our goal is to continuously raise the pipe cutting and beveling machine industry's standard of quality by creating excellent products and providing superior service.



Each machine is constructed of lightweight, hard-anodized aluminum, assuring durability and easy transportation to every job site. Anywhere you go you will be able to cut and bevel 2" to 36" pipe accurately, swiftly and economically, even under the toughest conditions.

- Each ring gear and saddle is precisely machined, assembled and calibrated to  $\pm .015$  in concentricity and squareness.
- Each machine is equipped with a rear-mounted short saddle for cutting and beveling in tight locations.
- The rear-mounted saddle allows precise back-beveling operations without sacrificing the machine's integrity.
- The machines' unique split horseshoe design permits easy placement over pipe sections.
- A quick operating boomer assembly secures each machine to the pipe during the entire 360° rotation; no repositioning is necessary.
- The patented Cuboid Spacer System minimizes downtime by keeping the spacers on the machine.



Cuboid Spacer System



Stored Spacers

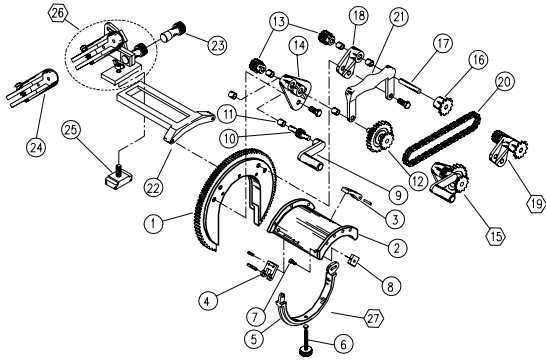


2DH Boomer Strap

Part No.	Model No.	Standard Pipe Size				Net Weight		Shipping Weight		Shipping Dimensions	Manual	Motorized	Cuboid Spacer (PATENTED)
		INCHES= Nominal Pipe Size	MILLIMETERS= Pipe O.D.	lbs.	kg.	lbs.	kg.						
HM00	0	2" 60.32	2.5" 73.02	3" 88.90	4" 114.30	7.50	3.37	12	5.40	9 x 11 X 11	Standard	Optional	Standard
HM01	1	3" 88.90	4" 114.30	6" 168.27	8" 219.07	16	7.20	23	10.35	13 x 16 x 17	Standard	Optional	Standard
HM02	2	7" 193.67	8" 219.07	10" 273.05	12" 323.85	23	10.35	35	15.75	15 x 22 x 22	Standard	Optional	Standard
HM03	3	14" 355.60	16" 406.40	18" 457.20	20" 508.00	51	22.95	77	34.65	13 x 34 x 34	Standard	Optional	Standard
HM04	4	20" 508.00	22" 558.80	24" 609.60	26" 660.40	81	36.45	118	53.10	14 x 36 x 45	Standard	Optional	Standard
HM30	30	24" 609.60	26" 660.40	28" 711.20	30" 762.00	92	41.40	133	59.85	14 x 38 x 48	Standard	Optional	Standard
HM05	5	30" 762.00	32" 812.80	34" 863.60	36" 914.40	145	65.25	250	112.50	16 x 48 x 61	Standard	Optional	Standard

## Beveling Machine Parts Lists

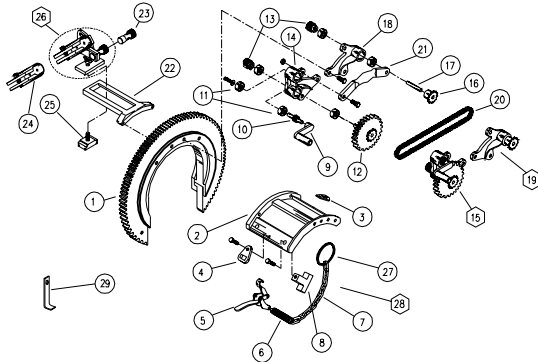
### Model 0



\* Cuboid Spacers are used on all Model 0 machines with SN#63337-C4 and up. For all other machines (unless modified with new saddle), old-style spacers will be required. Order part no. 36-0 Spacer Bolt Assembly (consists of two spacers each for 2" and 3" pipe).

Item. No	Model 0 Part No.	Description	Qty Req
1	2A3 & 4-0	Ring Gear Assembly	1
2	02-0	Saddle Assembly	1
3	2DP-0	Boomer Strap Eye (Pivot)	1
4	2DL-0	Boomer Strap Eye (Latch)	1
5	20-0	Boomer Strap	1
6	27-0	Boomer	1
7	13K-0	Knurled Thumb Screw	4
8	13C-0*	Cuboid Spacer	4
9	8-0-1	Crank	1
10	8C-0	Crank Pinion	1
11	26-0	Bearing	6
12	8A10 & 12-0	Crank Gear Axle Assembly	1
13	09-0	Pinion Gear	2
14	18-0	Double Bearing Bracket	1
15	18A-0	Double Bearing Bkt. Assembly (Items 9-14)	1
16	14-0	Sprockets	1
17	8A-0	Gear Axle	1
18	17-0	Single Bearing Bracket	1
19	17A-0	Single Bearing Bkt. Assembly (Items 11,13,16-18)	1
20	12A-0	Top Roller Chain	1
21	23-0	Handle	1
22	01-R	Torch Arm	1
23	007F	Knob and Cam Assembly	1
24	07CS	Torch Holder	1
25	0006	Base for 5C	1
26	005C	Torch Carrier	1
27	30-0	Boomer Assembly (Items 3-6)	1

### Model 1 and 2

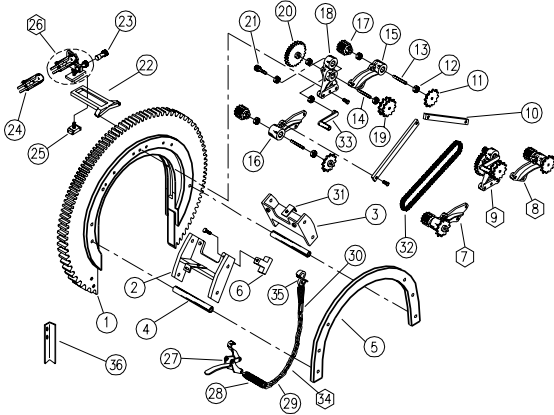


\* Cuboid Spacers are used on all Model 1 machines with SN#64577-C8 and up. For all other machines (unless modified with new saddle), old-style spacers will be required. Order part no. 36-1 Spacer Bolt Assembly (consists of four spacers each for 4", 6" and 8" pipe).

\*\* Cuboid Spacers are used on all Model 2 machines with SN#64709-C12 and up. For all other machines (unless modified with new saddle), old-style spacers will be required. Order part no. 36-2 Spacer Bolt Assembly (consists of four spacers each for 8", 10" and 12" pipe).

Item. No	Model 1 Part No.	Model 2 Part No.	Description	Qty Req
1	2A3 & 4-1	2A3 & 4-2	Ring Gear Assembly	1
2	02-1	02-2	Saddle Assembly	1
3	2DH-1-2	2DH-1-2	Boomer Strap Eye	1
4	2D-1-2	2D-1-2	Boomer Strap Eye	1
5	27-1-6	27-1-6	Boomer	1
6	24-1-2	24-1-2	Boomer Spring	1
7	20-1	20-2	Boomer Chain	1
8	13C-1*	13C-2**	Cuboid Spacer	4
9	8-0-1	08-2	Crank	1
10	8C-1-2	8C-1-2	Crank Pinion	1
11	26-1-3	26-1-3	Bearing	6
12	8A10&12-1-2	8A10&12-1-2	Crank Gear Axle Assembly	1
13	09-1	9-2-3	Pinion Gear	2
14	18-1	18-2	Double Bearing Bracket	1
15	18A-1	18A-2	Double Bearing Bkt. Assembly (Items 9-14)	1
16	14-1-2	14-1-2	Sprockets	1
17	8A-1-3	8A-1-3	Gear Axle	1
18	17-1	17-2	Single Bearing Bracket	1
19	17A-1	17A-2	Single Bearing Bkt. Assembly (Items 11,13,16-18)	1
20	12A-1	12A-2	Top Roller Chain	1
21	23-1	23-2	Handle	1
22	01-R	01-R	Torch Arm	1
23	007F	007F	Knob & Cam Assembly	1
24	07CS	07CS	Torch Holder	1
25	0006	0006	Base of 5C	1
26	005C	005C	Torch Carrier	1
27	21-1-2	21-1-2	Key Ring	1
28	30-1	30-2	Boomer Assembly (Items 5-7,27)	1
29	16-1	16-2	Foot	2

### Model 3



\* Cuboid Spacers are used on all Model 3 machines with SN#66260-C20 and up. For all other machines (unless modified with new saddle arms), old-style spacers will be required. Order part no. 36-3 Spacer Bolt Assembly (consists of four spacers each for 14", 16", 18" and 20" pipe).

Item No.	Model 3 Part No.	Description	Qty Req
1	2A3 & 4-3	Ring Gear Assembly	1
2	2FL-3	Saddle Arm (Left)	1
3	2FR-3	Saddle Arm (Right)	1
4	2E-3	Saddle Spacer Stud	2
5	2C-3	Back Saddle Ring	1
6	13C-3*	Cuboid Spacer	4
7	17AL-3	Single Bearing Bkt. Assembly-L (Items 11-13,16,17)	1
8	17AR-3	Single Bearing Bkt. Assembly-R (Items 11-13,15,17)	1
9	18A-3	Double Bearing Bkt. Assembly (Items 12,14,18-21,33)	1
10	29-3	Tie Rod	2
11	14-3	Sprockets	2
12	26-1-3	Bearing	8
13	8B-3	Pinion Gear Axle	2
14	8A-1-3	Gear Axle	1
15	17R-3	Single Bearing Bracket (Right)	1
16	17L-3	Single Bearing Bracket (Left)	2
17	9-2-3	Pinion Gear	2
18	18-3	Double Bearing Bracket	1
19	12-3	Sprocket (Double)	1
20	10-3	Crank Gear	1
21	8C-3	Crank Pinion	1
22	01-R	Torch Arm	1
23	007F	Knob & Cam Assembly	1
24	07CS	Torch Holder	1
25	0006	Base for 5C	1
26	005C	Torch Carrier	1
27	27-1-6	Boomer	1
28	24-3-6	Boomer Spring	2
29	20-3	Boomer Chain	1
30	0021	Boomer Strap Snap	2
31	2D-3-30	Boomer Strap Eye	2
32	12A-3	Top Roller Chain	2
33	8-3-6	Crank	1
34	30-3	Boomer Assembly (Items 27-30)	1
35	0025	Boomer Hook	1
36	16-3-30	Foot	2

## Band Type Pipe Cutting & Beveling Machine

The H&M Band-Type Pipe Cutting and Beveling Machine is fast, accurate and versatile. A single operator can position the band and beveling machine head on 48" diameter pipe in approximately five minutes. Each H&M stainless steel band overlaps numerous pipe sizes making the bands very economical.

- Automatically compensates for oversized or undersized pipe.
- Unaffected by dope or coating on the pipe.
- Accurate-Overlapping squares up the band.
- Band conforms to out-of-round pipe.

The H&M motorized beveling machine head incorporates a rugged, lightweight, cast aluminum chassis that offers the following features:

- Portable (weighs only 18 lbs.).
- Designed to work on all H&M stainless steel bands.
- Equipped with a 90-volt DC motor, (220 volt optional).
- Variable speed control box – forward and reverse.
- Speed range of 2 IPM to 24 IPM.
- Plasma speeds (optional).



Band Style Cutting 48" Pipe

### Bands

Each band includes a drive chain and a coupling – larger bands quoted upon request.

Part No.	Description	Pipe Sizes		Shipping Weight		Shipping Dimensions	
		Inches	mm	lbs	kg	Inches	mm
OBMH	Beveling Machine Head			20	9.05	18 x 12 x 10	450 x 300 x 250
BAND14	14" Band	10 to 14	250-350	6	2.71	12 x 12 x 10	300 x 300 x 250
BAND20	20" Band	14 to 20	350-500	8	3.62	12 x 12 x 10	300 x 300 x 250
BAND26	26" Band	20 to 26	500-650	9	4.07	12 x 12 x 10	300 x 300 x 250
BAND30	30" Band	26 to 30	650-750	10	4.52	12 x 12 x 10	300 x 300 x 250
BAND36	36" Band	30 to 36	750-900	12	5.43	20 x 20 x 13	500 x 500 x 325
BAND42	42" Band	36 to 42	900-1050	14	6.33	20 x 20 x 13	500 x 500 x 325
BAND48	48" Band	42 to 48	1050-1200	15	6.79	20 x 20 x 13	500 x 500 x 325
BAND56	56" Band	48 to 56	1200-1400	16	7.24	20 x 20 x 13	500 x 500 x 325
BAND60	60" Band	56 to 60	1400-1500	17	7.69	20 x 20 x 13	500 x 500 x 325
BAND64	64" Band	60 to 64	1500-1600	18	8.14	20 x 20 x 13	500 x 500 x 325
BAND68	68" Band	64 to 68	1600-1700	19	8.60	20 x 20 x 13	500 x 500 x 325
BAND72	72" Band	68 to 72	1700-1800	20	9.05	20 x 20 x 13	500 x 500 x 325
BAND76	76" Band	72 to 76	1800-1900	21	9.50	20 x 20 x 13	500 x 500 x 325
BAND80	80" Band	76 to 80	1900-2000	22	9.95	20 x 20 x 13	500 x 500 x 325
BAND84	84" Band	80 to 84	2000-2100	23	10.40	20 x 20 x 13	500 x 500 x 325
BAND90	90" Band	84 to 90	2100-2250	24	10.86	20 x 20 x 13	500 x 500 x 325
BAND96	96" Band	90 to 96	2250-2400	25	11.31	20 x 20 x 13	500 x 500 x 325
BANDBOX	Storage Box			38	17.25	24 x 24 x 10	600 x 600 x 250

### General Pipe Clamps

General Standard, Hydraulic and Ratchet Pipe Clamps for 2" to 60" diameter pipe. Each is hinged for easy positioning around the pipe and is available with flat or arched cross bars. The Standard Pipe Clamp features a lever and a cam to tighten the clamp around both ends of adjoining pipe.

General Pipe Clamps are designed for the sole purpose of aligning pipe ends while welding. They are NOT to be used to support the weight of the pipeline while lifting or moving, nor are they to be used with shims, wedges or cheaters.

**Note: All part numbers listed are General Standard Style with flat cross bars.**



Standard Pipe  
Clamp No Tack



Ratchet Pipe  
Clamp Flat



Hydraulic Pipe  
Clamp No Tack

Part No.	Size	Weight
GEN02	2"	12#
GEN02.5	2.5"	17#
GEN03	3"	17#
GEN04	4"	19#
GEN05	5"	33#
GEN06	6"	32#
GEN08	8"	33#
GEN10	10"	51#
GEN12	12"	53#
GEN14	14"	70#
GEN16	16"	102#
GEN18	18"	110#
GEN20	20"	120#
GEN24	24"	126#
GEN28	28"	148#
GEN30	30"	160#
GENDOLLY	from 3" to 30"	pipe diameter

### General Pipe Dolly

This one piece body with adjustable rollers easily accommodates pipe sizes 3" to 30". Using a pair of pipe dollies allows the pipe to be safely supported and rotated, assisting in multiple welding tasks.



## Band Boxes / Torch Holder / Cuboid Spacers

### Storage Boxes

Protect your investment during transportation and storage by using our lightweight aluminum storage boxes.

- Prevent damage to the machines and their precision parts.
- These storage boxes are for all Models No. 0 through No. 4 Standard Beveling Machines.



Part No.	Description
BOX00	0Mach Box
BOX01	1Mach Box
BOX02	2Mach Box
BOX03	3Mach Box
BOX04	4Mach Box

### Model "C" Adjustable Torch Holder

The Model "C" Adjustable Torch Holder features two rack-and-pinion driven, dove-tailed slide assemblies making horizontal and vertical movements easy. Its smooth, accurate torch adjustments eliminate blow holes, allowing the torch height to be altered even when the cutting torch is in motion.

- No special modifications are necessary with most torch lengths.
- A built-in protractor gives precise bevel angles every time.
- Model "C" fits all Standard H&M Beveling Machines except the Model No. 0, which requires a special adapter plate.



Part No. C-ADJ

### Motorization Kits

For large pipe work or fabrication H & M highly recommends its motorization kits where 115 AC power is available.

- Precise torch speed.
- Increased production and consistent, high-quality.
- Beveled edges with every pipe cutting or beveling operation.
- Speed ranges are sufficient for most plasma cutting applications.



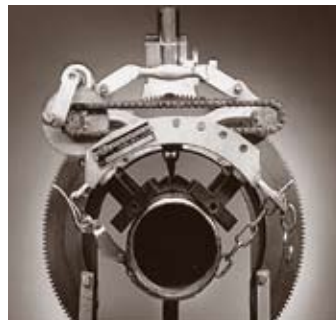
Part No.	Description
KIT00	Mach kit Model0
KIT01	Mach kit Model1
KIT02	Mach kit Model2
KIT03	Mach kit Model3
KIT04	Mach kit Model4
KIT06	Mach kit Model6

### Cuboid Spacer System

H&M's patented Cuboid Spacer System relieves frustration and downtime in looking for lost spacers, because the spacers never leave the machine.

- Six-sided form with rectangular sides.
- Three specific thicknesses conform to different pipe sizes.
- Four cuboids used to quickly set up machine.

Each size of every cuboid spacer is clearly stamped to ensure cutting the correct pipe size. When not in use the cuboid spacers are securely housed on the back of the saddle. It's a no-lose proposition in time-saving productivity.



Part No.	Description
13C-0	Mach Spacer0
13C-1	Mach Spacer1
13C-2	Mach Spacer2
13C-3	Mach Spacer3
13C-30	Mach Spacer30
13C-4	Mach Spacer4

## Adjustable Pipe Clamp

The adjustable pipe clamp is manufactured using ductile cast iron (APC16) or aluminum (APC16-A). The pipe alignment V's are cast into the clamp and precisely machined, assuring perfect alignment of pipe ends. The clamp is lightweight (APC16 - 31 lbs. net, APC16-A - 16 lbs.) and portable. A convenient carrying handle has been cast into the pipe clamp allowing easy, safe transportation to any job site. One person can position the clamp and start welding in about two minutes for most applications and pipe sizes. Comes complete and ready to align 2" to 16" diameter pipe. One adjustable clamp does the work of 12 cage-type pipe clamps. Acme 3/4-6" threaded bolts and nuts are used to tighten the chain around pipe. Each adjusting nut is fitted with its own handle. No extra wrenches or ratchet handles are required. The acme threaded bolts, nuts and chain are captive to the pipe clamp, eliminating lost or misplaced items.

**Part No. APC16-A** (Aluminum)

**Part No. APC16** (Cast Iron)



## Precision-Spacing Wedges

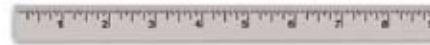
H&M's Precision Spacing Wedges are manufactured of high-grade carbon steel, precision ground and heat-treated. Available in two sizes, they accommodate small to large diameter pipe.

**Part No. PW-L**- Large Pipe Wedge- 1 3/4" X 8-3/4" X 1/4"

**Part No. PW-S**- Small Pipe Wedge- 3/4" X 4" X 3/16"



Part No. PW-L



Part No. PW-S

## Master Chain Clamp

A versatile clamping system designed to increase productivity. One person can quickly and safely perform perfect fit-ups of flanges, tees and elbows in minutes. Each Master Chain works 4" to 16" diameter pipe fittings. Additional chain links and jackbars can be added for larger pipe sizes. The clamp weighs 28 lbs. when fully assembled, but can be streamlined when working smaller sized pipe. Set up, positioning and alignment for welding is now faster.

**Part No. CC-HD**



## Magnetic Tool Release

This unique device utilizes two strong magnets securing tools and welding accessories to d-rings, belt loops or any area where quick access is required. Just tug on the tool to release it for use. When finished wave the magnet within an inch of the mating magnet. It will immediately jump to a secure position.

- Seven pounds of breaking force.
- Does not include striker.

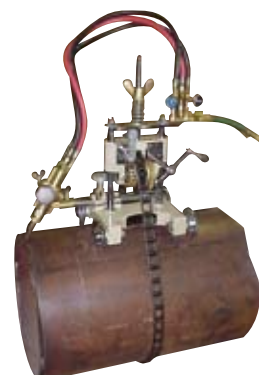
**Part No. MTR7**



## Chain-Type Pipe Machine

- Pipe capacity (4" to 24").
- Additional chain links can be purchased for larger pipe sizes.
- Cutting torch and three tips included.
- Control valves for fuel gas, pre-heat and cutting oxygen included.
- Manual drive (brass worm gears provide smooth motion).
- A handy clutch allows quick rotation of the machine around the pipe to verify position and square up the chain.
- Torch holder racks in, out, up and down.
- Torch holder can be positioned at any angle.

**Part No. HMC224**



## Flange Pins / Pipe Templates

### Quick-Acting Flange Pins

Welding occurs in minutes with very little fit-up time. Just tilt the knob to bypass the flange pin threads, then straighten the knob to grip the threads for tight, positive clamping. Removal is just as quick and easy. Loosen the knob, tilt it and remove. Endless threading and unthreading of the flange pins has been eliminated. H&M's precision, conical flange pins provide perfect centering on 5/8" to 1-1/2" bolt holes.

**Part No. QAFP** (Mild Steel)

**Part No. QAFP-S** (Stainless Steel)



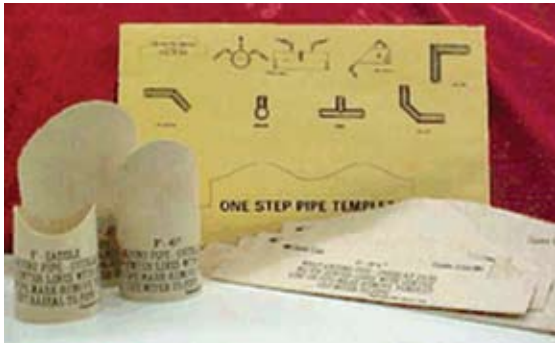
**Part No. QAFP (Mild Steel)**



### Pipe Template Sets

The complete wrap around templates from 1" to 42" pipe, with simple instructions imprinted on each template. There are 2 or 3 pipe sizes per set for diameters up to 6" and single pipe size templates for sizes 8", 10" and 12"

- Templates available for 22 1/2° angles, 45° angles and 90° risers or saddles for each pipe size listed below.
- Made of durable materials, so your templates will last and last for many uses.



**Part No.0001**

Part No.	Description	Pipe Size	O.D.	Wt. per Ft.
0000	For 1" to 1 1/2" pipe			
0114	For 1-1/4" pipe			
0001	For 2", 2-1/2" and 3" pipe	2"	2-3/8"	3.652
		2-1/2"	2-7/8"	5.790
		3"	3-1/2"	7.570
0002	For 4" and 6" pipe	4"	4-1/2"	10.790
		6"	6-5/8"	18.974
0008	For 8" pipe	8"	8-5/8"	28.544
0010	For 10" pipe	10"	10-3/4"	40.483
0012	For 12" pipe	12"	12-3/4"	48.995
0014	For 14" pipe	14"	14"*	53.941
0016	For 16" pipe	16"	16"*	61.746
0018	For 18" pipe	18"	18"*	69.753
0020	For 20" pipe	20"	20"*	77.619
0024	For 24" pipe	24"	24"*	93.509
0030	For 30" pipe	30"	30"*	117.267
0036	For 36" pipe	36"	36"*	141.017
0042	For 42" pipe	42"	42"*	164.640

\* The O.D. of pipe does not change – on different wall thickness, only the I.D. changes.