TRADITIONAL POLISHING MACHINES

POLISHING LATHES & BACKSTANDS

The traditional polishing lathe is an extraordinary robust and powerful machine with 3 HP or 5 HP motors. It consisted of a totally enclosed motor in a large housing with a threaded shaft on both ends. On the threaded shaft you can mount either parallel or tapered spindles, with tapered spindles being used on most machines. Speeds were mostly 2800 rpm but there were also 1450 rpm machines or even twin speed machines. ‘NON STOP’ versions have 2 motors in the same housing and can therefore be switched on and off independently. Even rarer are ‘NON STOP’ versions with 2 speeds for each end.

The most famous brands for these machines were Cannings, Morrisflex and Cruickshanks.

The fact that thousands of these machines, which are now between 30 and 50 years old, are still in service bears witness to their original brilliant design.

A typical polishing shop in the 1960’s. 30 to 40 polishers in rows were not uncommon.

We usually have several reconditioned machines in stock.

INTRODUCTION

At first sight these belt grinders all look the same.

On closer inspection you will find some significant differences which, if known, may help you choose the model that best suits your needs.

SURTECH were first to introduce horizontal belt grinders into the UK market and today offer a choice of more than 5 makes and designs to cover the needs of all customers.

Prices reflect the build quality, the available features and the after sales service.

If you want to see one of our machines or you want to test one visit our Abrasive Test Centre in Birmingham where we always have every model in stock.

Common features of all horizontal belt grinders

All horizontal belt grinders have a contact wheel at the front and a platen on the top. All are height adjustable.

SURTECH’s belt grinders also have optional fixtures to facilitate some grinding operations.

Model Range

5 SERIES DUAL PURPOSE HORIZONTAL ABRASIVE BELT GRINDERS

Model 531 is the most powerful horizontal belt grinder. 7 HP coupled with a high 38 m/sec belt cutting speed results in very high stock removal rates.

5 series machines are the only horizontal belt grinders with a hinged guard for the contact wheel. You can protect the contact wheel when you work on the platen. The guard also has a dust extraction spigot and it acts as a dust capture hood. No other machine has this feature.

Three other unique 5 series features are the separate dust channel, the three-part hinged platen cover and the replaceable platen.

The dust channel aids dust extraction and keeps the inside of the machine clean.

The hinged cover can be opened just sufficient for the work you do, adding to safety by not exposing the whole of the platen. Most other machines have a one piece hinged lid.

Many belt grinders simply have a platen as part of the machine body. Once the platen is worn you cannot replace it and either have to buy a new machine or carry out some costly repairs.

Belt Grinder Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>HP</th>
<th>No. of abrasives</th>
<th>Abrasive belt size</th>
<th>Contact wheel size</th>
<th>Belt speed</th>
<th>Platen size</th>
<th>Contact wheel size</th>
</tr>
</thead>
<tbody>
<tr>
<td>521</td>
<td>4</td>
<td>1 or 2</td>
<td>75 x 2000</td>
<td>32</td>
<td>75 x 585</td>
<td>200</td>
<td></td>
</tr>
<tr>
<td>522</td>
<td>4</td>
<td>1 or 2</td>
<td>150 x 2000</td>
<td>32</td>
<td>150 x 585</td>
<td>200</td>
<td></td>
</tr>
<tr>
<td>531</td>
<td>7</td>
<td>1 or 2</td>
<td>100 x 2500</td>
<td>38</td>
<td>100 x 735</td>
<td>250</td>
<td></td>
</tr>
</tbody>
</table>
## Dual Purpose Abrasive Belt Grinders

### Model Range SURTX - BS

### Model BS 75
- Twin speed
- Motor size: 3 KW
- Voltage: 230 only
- Abrasive Belt size in mm: 75 x 2000
- Abrasive Belt speed m/sec: 30
- Contact Wheel dia. in mm: 200
- Top Platen size: 75 x 460
- Weight: 72 kg
- Spigot diameter: Rear only, mm: 100

### Model BS 150
- Twin speed
- Motor size: 3KW
- Voltage: 400 only
- Abrasive Belt size in mm: 150 x 2000
- Abrasive Belt speed m/sec: 33
- Contact Wheel dia. in mm: 200
- Top Platen size: 150 x 460
- Weight: 90 kg
- Spigot diameter: Rear only, mm: 100

### Model BS 220
- Twin speed
- Motor size: 4KW
- Voltage: 400 only
- Abrasive Belt size in mm: 220 x 480
- Abrasive Belt speed m/sec: 29 / 15
- Contact Wheel dia. in mm: 200
- Top Platen size: 220 x 480
- Weight: 105 kg
- Spigot diameter: Rear only, mm: 75

### Model BS 100
- Single speed
- Motor size: 1.5 KW
- Voltage: 230 only
- Abrasive Belt size in mm: 100 x 1220
- Abrasive Belt speed m/sec: 19
- Contact Wheel dia. in mm: 125
- Top Platen size: 100 x 280
- Weight: 44 kg

---

To receive more information on any of the products shown visit [www.surtech.co.uk](http://www.surtech.co.uk)
INTRODUCTION

Abrasive belt grinders used to be called ‘backstands’ and polishing machines ‘polishing lathes’.

Many of our customers still use these descriptions even for the modern versions.

Our modern machines have state of the art motors which are smaller yet deliver the same hp as the traditional machines.

They are available single and double ended. With single speed or twin speed.

Unlike traditional motors the modern motors are compatible with variable speed inverters, motor brakes and interlocks.

The abrasive belt arms are fully integrated with tensioning and tracking controls and with complete guards, a dust capture hood and a dust extraction spigot.

**SERIES 6**

Best value polishing lathes
With 2 speeds. For continuous operation

**SERIES 5**

Best value Traditional Abrasive Belt Grinders
Available with one or two heads. For continuous operation.

**SERIES 56**

Two-in-one Grinding and Polishing Heads
Combined in one machine

**Series 5 Traditional abrasive belt grinders**

<table>
<thead>
<tr>
<th>Model No.</th>
<th>No. of heads</th>
<th>HP</th>
<th>No. of speeds</th>
<th>Abrasive belt size in mm</th>
<th>Max buff dia. in mm</th>
<th>Contact wheel dia. in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>503 Backstand</td>
<td>1</td>
<td>2.3</td>
<td>2</td>
<td>50 x 2500</td>
<td>n/a</td>
<td>250</td>
</tr>
<tr>
<td>553 Backstand</td>
<td>2</td>
<td>2.3</td>
<td>2</td>
<td>50 x 2500</td>
<td>n/a</td>
<td>250</td>
</tr>
<tr>
<td>506 Backstand</td>
<td>1</td>
<td>4</td>
<td>2</td>
<td>50/75 x 2500</td>
<td>n/a</td>
<td>250</td>
</tr>
<tr>
<td>556 Backstand</td>
<td>2</td>
<td>4</td>
<td>2</td>
<td>50/75 x 2500</td>
<td>n/a</td>
<td>250</td>
</tr>
</tbody>
</table>

With vertical heads. Heavy duty industrial design for continuous use.

**Series 6 Polishing machines**

<table>
<thead>
<tr>
<th>Model No.</th>
<th>No. of heads</th>
<th>HP</th>
<th>No. of speeds</th>
<th>Abrasive belt size in mm</th>
<th>Max buff dia. in mm</th>
<th>Contact wheel dia. in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>603 Polishing m/c</td>
<td>1</td>
<td>2.3</td>
<td>2</td>
<td>n/a</td>
<td>250</td>
<td>n/a</td>
</tr>
<tr>
<td>663 Polishing m/c</td>
<td>2</td>
<td>2.3</td>
<td>2</td>
<td>n/a</td>
<td>250</td>
<td>n/a</td>
</tr>
<tr>
<td>606 Polishing m/c</td>
<td>1</td>
<td>4</td>
<td>2</td>
<td>n/a</td>
<td>250</td>
<td>n/a</td>
</tr>
<tr>
<td>666 Polishing m/c</td>
<td>2</td>
<td>4</td>
<td>2</td>
<td>n/a</td>
<td>250</td>
<td>n/a</td>
</tr>
</tbody>
</table>

Heavy duty industrial design for continuous use.
To receive more information on any of the products shown visit www.surtech.co.uk
MULTI-PURPOSE BELT GRINDERS

Series 7
Our Dedicated Multi-Purpose Range

One of the most versatile abrasive belt machines on the market. With telescopic arms. For contact wheels from 20mm - 200mm dia. and from 12mm - 75mm wide. Ideal for turbine blades, surgical implants, etc.

What makes 7 series machines special?
Because the belt drive motor is at the rear of the machine you can fit any contact wheel size without changing the belt cutting speed.

The belt cutting speed is determined by the speed of the motor and the diameter of the rear drive wheel.

7 Series machines have telescopic belt tensioning. This means the abrasive belt length can be kept at a constant 2500 mm no matter what size contact wheel is mounted.

Telescopic tensioning also allows you to adjust the tensioning power finer and more accurate than any other manual tensioning system.

For even greater versatility 7 series machines can be equipped with variable speed inverters, foot pedals and interlocks.

Model 491 can carry out many of the same operations as the 7 series machines but it does not have all of the features of the 7 series and is therefore less versatile.

Model 491 is considerably cheaper than the 7 series machines.

FEATURES
• 3.5 HP 2 speed motor
• Abrasive belt size 25 to 75mm wide x 2500mm long.
• Standard contact wheels 50mm, 100mm, 150mm and 200mm dia.
• Special contact wheels 25mm to 200mm dia.
• Working height adjustable
• Large adjustable dust capture hood.

Model 491 ABRASIVE BELT GRINDER WITH EXTENDED CONTACT ARM

For unrestricted work. Contact wheels from 25mm to 200mm dia.

Some of the many contact arm assemblies which can be used on 7 series machines

Model 491 is considerably cheaper than the 7 series machines.

Some of the many contact arm assemblies which can be used on 7 series machines

Optional special contact arm

Optional special contact arms

Optional special contact wheels

Many of the contact arms and contact wheels used on the 7 series machines can also be used on Model 491

Some more special contact arms for use on Model 491

Series 7 Multi-purpose

<table>
<thead>
<tr>
<th>Model No.</th>
<th>No. of heads</th>
<th>No. of speeds</th>
<th>Abrasive belt size</th>
<th>Max buffer dia.</th>
<th>Contact wheel dia.</th>
</tr>
</thead>
<tbody>
<tr>
<td>706</td>
<td>1</td>
<td>4</td>
<td>12-75 x 2500</td>
<td>n/a</td>
<td>20 - 200</td>
</tr>
<tr>
<td>766</td>
<td>2</td>
<td>4</td>
<td>12-75 x 2500</td>
<td>n/a</td>
<td>20 - 200</td>
</tr>
</tbody>
</table>

Heavy duty industrial design for continuous use.
Modular Grinding and Polishing Cells
For Turbine Blades, Medical Implants, Precision Castings, etc.

Design your own and let us build it!

STEP 1 - Choose the heads, guards and dust capture hoods

a) Buffing Heads

Left handed
Right handed

3 - 4 HP twin speed or optionally with variable speed. Max. buff diameter 250mm. Max. buff width with tapered shafts 50mm, with parallel shaft and large guard 100mm.

Optional motor brake
Parallel or tapered shafts

Standard bolt on guard
Optional large bolt on guard

Optional inverter for variable speed control. Incorporates electronic motor brake.

Foot control

Floor mounted guard with sliding top to adjust for mop wear
Floor mounted guard with fixed top

Other guards made to order.

To receive more information on any of the products shown visit www.surtech.co.uk
b) Variable Speed heads for small diameters

F 5000 - 1.5 kW, 240 V motor with standard variable speed 500 - 5000 rpm motor. Double ended, with M33 spindle on right and M20 spindle on left.

F 1000 - 0.75 HP, 240 V motor with variable speed 800 - 10,000 rpm. Right handed only. No standard guards. Guards are made to order to suit requirements.

F 15,000 - 0.45 kW, 240 V motor with variable speed 2,500 - 15,000 rpm. Right handed only.

Standard guards for F 5000 - 1.5

Vast range of spindles to suit all abrasives and polishing consumables

With collets or chuck

c) Vertical Abrasive Belt Heads

3 - 4 HP twin speed or optional with variable speed. Abrasive belt length 2500mm. Widths from 25mm to 75mm.

Right handed

Optional inverter for variable speed control. Incorporates electronic motor brake.

Optional large dust capture hood

Left handed

Optional motor brake

Contact wheels 250mm dia. x 25, 50, 75mm wide. Plain or serrated. From 20 to 95 shore.

d) Horizontal Abrasive Belt Heads with Telescopic Arms

3-4 HP twin speed or optional with variable speed. Height adjustable.

Right handed

Foot control

Optional inverter for variable speed control. Incorporates electronic motor brake.

Optional large dust capture hood

Left handed

Optional motor brake

Quick change contact arms

Contact wheels from 25mm to 200mm dia. From 12mm to 75mm wide.
e) Horizontal Abrasive Belt Heads for Bespoke Solutions

Left handed only. 3.5 HP, twin speed.
Abrasive belt 2,000mm to 2,500mm long.
25mm to 75mm wide. Height adjustable.

Optional large dust capture hood

Optional motor brake

Optional inverter for variable speed control. Incorporates electronic motor brake.

f) Slack of Belt Heads

Left handed only. 0.75 HP.
Variable speed standard.
Abrasive belts 1,120mm x 12-50mm wide. Contact wheel diameters from 20mm to 100mm. Height adjustable.

Foot control

Optional motor brake

Optional inverter for variable speed control. Incorporates electronic motor brake.

For grinding, deburring and finishing edges.
For finishing and blending contours.

g) Turbine Head

Left handed only. 0.75 HP. Variable speed standard.
Abrasive belts 1,120mm x 12-50mm wide. Contact wheel diameters from 20mm to 100mm. Height adjustable.

Vast range of contact arms

Vast range of optional contact wheels.

From approx. 15mm dia. to approx. 100mm dia.
From 6mm to 50mm wide. Plain and serrated. Soft to hard.

h) Mini Abrasive Belt Head

Left handed only. 0.75 HP. Single speed.
Abrasive belt 1,120mm long. 6mm to 50mm wide.
Standard cutting speed slow at 24 m/sec.

Optional large dust capture hood

Optional inverter for variable speed control. Incorporates electronic motor brake.

Contact wheels from 25mm to 100mm dia. From 12mm to 50mm wide.

Visit www.surtech.co.uk for more information.
STEP 2 - Choose the Stand

We can offer several stand designs. For one or two machines. With door or open. Choice of colours.

STEP 3 - Choose the Dust Extractor

Stand alone extractor with 100% filtration
Bolt on extractor
Standard stand alone extractors in 3 sizes
Wet extractors in 5 sizes
Ducting

STEP 4 - Choose the Consumables

Aluminium Oxide Belts Zirconia Belts Ceramic Belts Compact Grain Belts Silicon Carbide Belts Engineered Belts
Nylon Wheels Elastomer Wheels Non Woven Belts Non Woven Wheels

Who are Surtech?

Surtech have been supplying the latest abrasive machines and materials from around the world for over 30 years.

Surtech Abrasive Test Centre

Here you will find a large selection of the very latest grinding, deburring, polishing, satin finishing and brushing machines. Bring your own parts and discuss your requirements with our skilled engineers, who will also set up practical demonstrations.

To receive more information on any of the products shown visit www.surtech.co.uk
MODEL 411
MINI ABRASIVE
BELT GRINDER

• With single or variable speed
• For grinding and polishing difficult to reach areas
• Ideal for turbine blades, surgical implants, surgical instruments, small castings, etc.
• For rectification of porcelain, earthenware and glass

1. Adjustable top guard
2. Adjustable bottom guard with dust capture hood and 80mm spigot
3. Optional inverter
4. Bench mount
5. Bench mount bracket with working height adjustment
6. Quick change contact wheel assembly
7. Hinged access door for belt change
8. Separate dust channel to rear spigot 80mm dia.

1. 100mm dia drive wheel
2. Belt tensioning wheel
3. Bracket for mounting contact wheel assemblies
4. Slots for adjusting height of contact wheel assemblies
5. Front belt tracking control

To receive more information on any of the products shown visit www.surtech.co.uk
The 2 Standard mounting systems for contact wheel assemblies

**For small contact wheels**
- Adjustable bracket
- Adjustable bracket with one of the many small contact arms. Incorporating abrasive belt tracking control.
- Small contact arm assemblies. 25mm dia.
- Small contact arm assemblies 12mm to 19mm dia.

**For large contact wheels**
- Adjustable bracket
- Adjustable bracket with one of the many large contact arms. Incorporating abrasive belt tracking control.
- Large contact arm assemblies. 50mm dia. 12mm to 50mm wide.
- Large contact arm assemblies 20mm to 100mm dia.

Special big wheels 50mm to 125mm dia. From 5mm wide.

Contact wheels for large contact arm assemblies

TECHNICAL SPECIFICATION

**Standard motor:**
Approx. 1.1 kW. Supply via inverter is 240V, single phase.

**Optional motor:**
3 phase, 400V without inverter.

**Standard abrasive belt sizes:**
1120mm long x 6, 12, 25, or 50mm wide.

**Optional abrasive belt sizes:**
Up to a maximum of 1500mm long.

Can also be mounted on a dust extractor

CONSUMABLES for the 411 MINI GRINDER

**General Purpose Aluminium Oxide Abrasive Belts**
Grit range: 36 - 600
Suitable for most metals but not as effective as zirconia or ceramic belts on harder metals.

**Zirconia Abrasive Belts**
Grit range: 36 - 120
Recommended for stainless steel and some of the harder metals.

**Structured Belts**
Grit range: A300 - A6
Equivalent to: 80 - 2500
Ideal for grinding and polishing of turbine blades and implants.
Can eliminate one or more finishing steps.

**Compact Grain Belts**
Grit range: A/O 60 - 240, SiC 80 - 600
Designed for finishing of turbine blades and implants.
Clusters of grain result in considerably longer belt life compared with standard abrasive belts.

**Ceramic Abrasive Belts**
Grit range: 24 - 120
Recommended for hard metals as often used for turbine blades and surgical implants.

**Superfinishing Belts**
Grit range: 180 - 2500
Recommended for extremely fine finishing of all metals.

**Silicon Carbide Abrasive Belts**
Grit range: 80 - 400
For some applications where SIC is specified in preference to A/O.

**Diamond Belts**
Grit range: 600 - 800 mesh
Will cut and polish any material.

**Non Woven Belts**
Grit range: Very fine, fine, medium
For blending, deburring and satin finishing.

**Cotton Polishing Belts**
For mirror polishing. Used with bar compo.

To receive more information on any of the products shown visit www.surtech.co.uk
MODEL L52 - PEDESTAL
MODEL L50 - BENCH
3 WHEEL ABRASIVE BELT GRINDERS

- For general grinding, deburring and finishing
- For flat and contoured parts in all metals and plastics
- For deburring sheet metal
- For removing die lines from castings
- For chamfering

Technical Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Motor</th>
<th>Abrasive belt</th>
<th>Cutting speed</th>
<th>Contact wheel</th>
<th>Weight</th>
<th>Dust extraction spigot</th>
</tr>
</thead>
<tbody>
<tr>
<td>L52</td>
<td>400V, 3 ph, 2-3 HP, Two speeds</td>
<td>50 x 2000mm</td>
<td>15 - 30 m/sec</td>
<td>50 x 200mm</td>
<td>Approx 60 kg</td>
<td>70mm dia</td>
</tr>
<tr>
<td>L50</td>
<td>400V, or 240V, 1 HP, Single speed</td>
<td>25 x 1060mm</td>
<td>30 m/sec</td>
<td>n/a</td>
<td>Approx 40 kg</td>
<td>n/a</td>
</tr>
</tbody>
</table>

Model L52
Combined support, guard and extraction spigot. Shown here open for work on contact wheel.

Model L52
Shown here closed for work on platen.

Model L50
Shown here with large support table. L50 has no contact wheel and can be used on platen or slack of belt.

High specification electrical controls with rotary on/off switch, indicator lamp and emergency stop. Thermal overload and no volt controls. All in steel case.

To receive more information on any of the products shown visit www.surtech.co.uk
ABRASIVE BELT FLATBED GRINDERS (LINISHERS)

INTRODUCTION

‘Linisher’ used to be the brand name of a flatbed abrasive belt grinder manufactured by Messrs. Turner Machine Tools Ltd. in Birmingham.

‘Linisher’ has now become a generic name for abrasive belt grinders with a platen.

Some people refer to any operation with abrasive belts as “linishing” because the English language only knows ‘grinding’.

‘Grinding’ does not tell you if wheels or belts are used.

The traditional linisher could be used on the platen only. Some of the more modern designs allow work on the platen or on a contact wheel.

Model L61
BENCH MODEL LINISHER

This is the most robust and versatile bench linisher we know. Model L61 is our smallest linisher.

FEATURES

- 400 V, 3phase, 2-3 HP motor
- 100 x 1000mm abrasive belt size
- Platen size 100 x 250mm
- Can be used on platen or contact wheel
- The abrasive belt head can be swivelled to a vertical position or a horizontal position and any angle in between
- The guard system is fully adjustable.

Model 303

Max. working width 150mm
1.7 - 2.3 HP two speed motor
Abrasive belt size: 150 x 1750mm
Can be mounted horizontally or vertically.
Size of platen: 150 x 500 mm.

Model 304

Basically the same machine as Model 306 but with a large horizontal table which slides in and out of the abrasive belt.
Guard with dust extraction flange.
Machine mounted on fabricated stand.

Model 306

Model 306 shown here with optional built in dust extractor
Max. working width 250mm.
3-4 HP two speed motor.
Abrasive belt size 250 x 2000mm.
Size of platen: 250 x 625mm.
Guard with dust extraction flange.
Mounted on fabricated stand.

Model 206

5.5 HP motor, single speed 1450 rpm
Abrasive belt size: 500 x 2680mm.

Model BS6 OSCILLATING EDGE GRINDERS

2.2 kW, 240V, single phase motor.
Abrasive belt size: 150 x 2500mm.
Cast metal table: 840 x 300mm.
Rise and fall by hand wheel.

To receive more information on any of the products shown visit www.surtech.co.uk
These machines are dedicated linishers with large flatbed platens. All have single speed 4 HP motors or optional 4,5/3,5 HP two speed motors and 200mm x 2000mm abrasive belts. All are for working on the platen only.

**MODEL RANGE F 33**

**Model 332**
- Horizontal position only.
- Platen size: 200mm x 535mm.

**Model 333**
- Side position only.
- Platen size: 200mm x 535mm.

**Model 334**
- Vertical position only.
- Platen size: 200mm x 535mm.

**INTRODUCTION**
All of the horizontal abrasive belt grinders on pages 3 and 4 have platens and can therefore be used as linishers.

They are often cheaper than dedicated linishers but they are also less versatile and available for horizontal operation only. Platen sizes are limited to max. 150mm width and 450mm length.

**WET OPERATION LINISHERS**
Wet linishers are used for all applications where the part needs to be kept cool or where hazardous materials are involved.

Aluminium, titanium and magnesium are three materials that have to be ground wet because they are liable to cause fires and explosions.

When hazardous materials are ground it may also be necessary to install non sparking guards. Instead of steel guards aluminium guards should be fitted.

Wet linishers must not be used with tap water alone as this will cause serious corrosion in a very short time.

A corrosion inhibitor and lubricant must be added. The ratio is normally 97% to 98% water and 2% to 3% additive.

**Model BS 200 W**
- 1.1 KW single speed motor.
- 16 m/sec cutting speed.
- Abrasive belt size: 100 x 950mm.
- Size of platen:
  - Vertical or horizontal position.

**Model BS 300 W**
- Same as Model BS 200 W but larger.
- 4 KW, single speed motor.
- 15 m/sec cutting speed.
- Abrasive belt size: 300 x 2000mm.
- Vertical or horizontal position.
ABRASIVE DISC MACHINES

INTRODUCTION
Abrasive disc machines are rarely used for metal finishing. They are more popular with woodworking Companies. The cutting speed of the disc is fastest on the outer area and slowest on the inner area. Discs do not remove metal as fast as belts.

Model 403 HORIZONTAL DISC GRINDER

FEATURES
4 HP single speed 1400 rpm motor.
Disc diameter 500mm.
Either self adhesive or Hook and Loop abrasive discs can be fixed to the aluminium plate.

Model 406 VERTICAL DISC GRINDER

FEATURES
5 HP single speed 1400 rpm motor.
Disc diameter 500mm.
Large support table: 550mm wide x 300mm deep.
Either self adhesive or Hook and Loop abrasive discs can be fixed to the aluminium plate.

Model SURTX J T WIRE WHEEL TUBE END DEBURRING MACHINE

For general deburring wire wheels are still the most popular, most effective and most economical tools.
This machine uses 250mm dia x 60mm wide wire wheels. It has a twin speed 2 - 3 HP motor.
Available with 3 phase or single phase motor.
There are adjustments for wheel wear and settings for deburring the ID or the OD of tubes.
Mild steel, stainless steel and abrasive impregnated fibre wheels are available to suit most materials and to produce most finishes.
With 100mm dia spigot to fit optional built in dust extractor.

Model SURTX J T set up for deburring tubes.

Optional built in dust extractor for Models Surtx J T and Model 250

Model 250 SHEET EDGE DEBURRER

Deburs top and bottom edge in one pass. With 2 abrasive flap wheels. For sheet up to 10mm thick.

Model 623 ABRASIVE BELT MACHINE

An unusual abrasive belt machine for grinding and deburring difficult parts.
With some unique features:
• Motor: 2 speed, 2-3 HP, three phase only.
• Abrasive belt size: 2000mm long x 6-75mm wide.
• Inclinable support table.
• Quick change flat, shaped or round contact arms.
• The only abrasive belt machine that can grind and deburr holes and rings.

Model 420 ABRASIVE BELT SHEET EDGE DEBURRER

• Faster than any other method
• Coarse to fine belts for all burrs & finishes
• 3.5 HP motor
• Abrasive Belt size: 2000mm x 25mm or 50mm
• Approx weight 90 kg
Manual operation. 3.5 HP motor.
Abrasve belt size 2000mm x 25mm or 50mm. Works on the slack of belt. The cutting angle can be set from 135 degrees to 45 degrees. This is the fastest and most economical sheet edge deburrer available. Abrasive belt will wrap around the edge to produce a radiused finish.

Adjustable belt angle

Abrasive belt can be angled to facilitate deburring action

To receive more information on any of the products shown visit www.surtech.co.uk
To receive more information on any of the products shown visit www.surtech.co.uk

Model 127
BELT EDGE GRINDER
3.5 HP, 400V, 3 phase.
Abrasive belt size: 2000mm x 75mm.
The large table can be fitted in both directions and moved up and down to make use of the entire belt width.
For grinding, deburring and chamfering edges on plate, flat bar, thermal cut blanks, hollow sections, castings, etc.

Range of quick change contact wheels from 25mm dia to 200mm dia

Model 213 AND 213 SP MULTI-PURPOSE ABRASIVE BELT GRINDING AND DEBURRING MACHINE
This is one of our most versatile machines. It can carry out grinding, deburring and polishing operations that are not possible on any other machine:
• Grinding on vertical platen
• Grinding on vertical slack of belt
• Grinding on contact wheel
• Grinding of flat surfaces
• Grinding of contoured surfaces
• Deburring of sheet metal edges
• Removal of die lines on castings
• Chamfering
• Grinding slots and bent parts

FEATURES
2.5/1.7 HP two speed motor.
Abrasive belt size 25mm to 100mm wide x 2000mm long.
Support table adjustable from -15 degrees to + 60 degrees.

Clearance top to bottom: 350mm.
Clearance back to front: 350mm.

Series 84 AUTOMATIC SHEET EDGE DEBURRERS
For deburring top and bottom edges of sheet simultaneously in one pass.

Model 844 has a twin head for deburring top and bottom straight edges of sheet.

Model 845 has a twin head plus a single head for deburring top and bottom straight edges of sheet plus blending the face.

Model 846 has a twin head plus a single head for deburring top and bottom straight edges of sheet plus grinding the face.

Model 844

Model 845

Model 846
Model TN 201 & Model TN 202

Tube Notchers

For round & square tube

**Model TN 201**
- 20 - 70mm dia.

**Model TN 220**
- 20 - 116mm dia.

- Abrasive belt sizes
  - Model TN 201 - 75 x 2000mm
  - Model TN 220 - 120 x 2000mm
- Range of quick change mandrels
- For straight and angled notches
- 4 HP motor on both models
- Emergency stop button
- Thermal overload
- No volt control
- Optional built-in or stand alone dust extractor

<table>
<thead>
<tr>
<th>Angle in degrees</th>
<th>Max. tube diameter in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td><strong>TN 201</strong></td>
</tr>
<tr>
<td>30</td>
<td>37</td>
</tr>
<tr>
<td>45</td>
<td>52</td>
</tr>
<tr>
<td>60</td>
<td>60</td>
</tr>
<tr>
<td>90</td>
<td>70.3</td>
</tr>
</tbody>
</table>

**Max Notch Dia (mm)**
- TN 201: 68.8
- TN 220: 114.5

**Only this machine has ALL of these features:**
- Solid steel vice with ‘V’-jaws
- Infeed control for depth of cut
- Slide bar for belt wear compensation
- Lead screw covers
- Depth of cut stop
- Swivel slide for angled cuts
- Protractor scale
KOMBI Belt Grinder / Notcher
Perfect for the jobbing shop

Two models are available:

**KOMBI 3075**
- Min/max. tube dia: 20mm / 70mm
- Motor size: 3kW, 4HP
- Abrasive belt size: 75 x 2000mm
- Top flatbed size: 100 x 390mm

**KOMBI 3150**
- Min/max. tube dia: 20mm / 145mm
- Motor size: 4kW, 5HP
- Abrasive belt size: 150 x 2000mm
- Top flatbed size: 150 x 390mm

**General Spec - both models**
- Min/max angle settings: 30° - 90°
- Mandrels made to order
- Twin motor speeds: 1400 & 2800
- Motor insulation & class: B/IP44
- Tube fed into belt by lever.
- Method of using total belt width:
  - Lead screw positioning.
- Working height: 1030mm
- Extraction spigots and size:
  - 1 off 75mm OD.

Selection of notched round and rectangular tubes

Changes from belt grinder to notcher in minutes
Take a belt grinder... add a notcher head...

and you have an Abrasive belt tube notcher

To receive more information on any of the products shown visit [www.surtech.co.uk](http://www.surtech.co.uk)
Model 131 Corner Radiusing Machine

- Automatic operation
- Perfect and consistent radiused corners in 2 - 5 sec.
- Various radii settings
- For max. 150mm long corners
- 3.2 HP, 2 speed motor
- Abrasive belt 2000mm x 150mm
- Optional built in extractor

Just place part on table. The machine will do the rest.

1. Table angle setting
2. Table
3. Scale for table angle
4. Table height setting
5. Locking handle for table setting

1. Guard door fixing screw
2. Guard door
3. Belt tension check area
4. Belt tension handle
5. Guide adjustment
6. Guide adjustment
7. Guide adjustment
8. Settings for size of radius
9. Settings for size of radius

Model 131 will automatically radius and blend these corners

Typical part with welded corners

To receive more information on any of the products shown visit www.surtech.co.uk
Model 126 ABRASIVE BELT SWING GRINDER

**FEATURES**
- 4HP single speed motor.
- 24V control voltage.
- Short stem adjustable handle bar.
- Suspension bracket.
- Abrasive belt size: 75 mm x 2000 mm.
- Abrasive belt cutting speed: 30 m/sec.
- Contact wheel size: 200mm dia x 75mm wide.
- Dimensions: 600mm x 1500mm x 1000mm high.
- Weight: 96 kg.
- With built in dust extractor: 0.75 KW, 700 cbm/hr.

A typical welded enclosure suitable for automatic corner radius finishing on Model 132

Model 125 ABRASIVE BELT FLOOR GRINDER

**FEATURES**
- 4HP single speed motor.
- With 24 V control voltage.
- With long stem adjustable handle bar.
- With 6 wheel carriage.
- Abrasive belt size: 75mm x 2000mm.
- Abrasive belt cutting speed 30 m/sec.
- Contact wheel size: 200mm dia x 75mm wide.
- Dimensions: 600 mm x 1600mm x 1700mm high.
- Weight: 100 kg.
- With built in dust extractor: 0.75 KW, 700 cbm/hr.

Model 122 ABRASIVE BELT HEAD

**FEATURES**
- 6HP single speed motor.
- Abrasive belt cutting speed 30 m/sec.
- Abrasive belt size: 75mm x 2000mm.
- Contact wheel dimensions: 200mm dia x 75mm wide.
- Machine dimensions: 400mm x 1150mm x 700mm high.
- Weight: 84 kg.

A typical welded enclosure suitable for automatic corner radius finishing on Model 132

Before After

**SWING GRINDERS AND FLOOR GRINDERS**

Model 126 ABRASIVE BELT SWING GRINDER

**FEATURES**
- 4HP single speed motor.
- 24V control voltage.
- Short stem adjustable handle bar.
- Suspension bracket.
- Abrasive belt size: 75 mm x 2000 mm.
- Abrasive belt cutting speed: 30 m/sec.
- Contact wheel size: 200mm dia x 75mm wide.
- Dimensions: 600mm x 1500mm x 1000mm high.
- Weight: 96 kg.
- With built in dust extractor: 0.75 KW, 700 cbm/hr.

To receive more information on any of the products shown visit www.surtech.co.uk
BENCH OR PEDESTAL MACHINES FOR GRINDING, DEBURRING AND POLISHING

INTRODUCTION
There are two distinct classes of bench machines:

1. DIY QUALITY
2. INDUSTRIAL QUALITY

DIY machines are mostly fractional horse power machines suitable for intermittent use only.

They range from ridiculously cheap Far Eastern imports which are not worth repairing to higher priced European manufactured machines which are of better build quality but still a long way off the industrial quality machines.

All the DIY machines get extremely hot after about 30 minutes use and are not recommended for all day use.

If you want a machine for intermittent use and you accept its limitations we can supply models at around £100. Anything below this price we do not touch.

If, however, you need an industrial quality machine which will run trouble free on shift work then you will have to spend between £500 and £1200.

All prices mentioned above are for double ended bench motors for grinding wheels or for polishing mops.

Bench mount abrasive belt machines are more expensive.

ABRASIVE BELT BENCH GRINDERS

BENCH Model L50

The best built bench top grinding and deburring machine on the market.

Now with improved features:
- Motor: two speed, 2-3 HP, three phase.
- Abrasive belt size: 2000mm long x 50mm wide. Larger belts last longer and are more economical.
- Lage support table.
- Can be used with platen behind belt or on slack of belt without platen.

Ideal for general grinding, for edge deburring and for grinding contours.

Model 616 DOUBLE ENDED POLISHER

Industrial rated double ended polisher.

FEATURES
- 0.8 / 1 HP, two speed motor 2800 and 1400 rpm.
- With parallel spindles Distance between spindles 520mm.
- With guards.
- Optional tapered spindles available.

Model 616 is available as bench machine when it is mounted on a bench plinth or as a pedestal machine mounted on a fabricated metal stand.

Model 413 BENCH MODEL ABRASIVE BELT MACHINE

Industrial rated abrasive belt machine with small contact wheels.

FEATURES
- 0.75 HP, single speed motor 2800rpm.
- 24 m/sec cutting speed.
- Abrasive belt size: 6 mm to 50 mm wide x 1100 mm long.
- Contact wheel diameters from 15mm to 100mm.

Model BG 150 XD DOUBLE ENDED BENCH GRINDER/DEBURRER

- 0.45 kW, 240V, 2850 rpm
- Shaft 12.7mm dia.
- Grinding wheels 150mm OD x 25mm wide x 16mm bore
- Machine fitted with 1 coarse wheel and 1 fine wheel
- Can also be supplied with wire wheels or nylon deburring and finishing wheels

Model AE 14000 VARIABLE SPEED POLISHING MACHINE

Model AE 14000 was designed for abrasive discs and wheels with very fast recommended operating speeds. Mainly used for turbine blades.

FEATURES
- Motor: 1.5 kW, 230V, single phase input, 800 - 14000 rpm.
- Shaft connection at motor end: M10/DIN30.
- Shaft length including collet: Up to 200mm.
- Shaft diameter: 10mm.

Model AE 14000 can be used as a bench machine or mounted on a stand with dust hood.
## Bench, Pedestal & Portable Polishing Machines

**Models 603, 606, 663, 666**
Double and single ended for heavy duty industrial non stop work

**Model 616**
Light to medium duty industrial work

**Models LBP7 & LBP9**
For light to medium industrial use

**Model DSM 200**
For light to medium industrial use

**Models Roto-Buffer R & SU**
Heavy duty portable polisher

**Used**
Polishing lathes in many configurations, refurbished

---

<table>
<thead>
<tr>
<th>Model</th>
<th>Motor Size</th>
<th>Motor Speed</th>
<th>Voltage</th>
<th>Max. Mop Size x Width in mm</th>
<th>B = Bench</th>
<th>T = Tapered</th>
<th>Guard and Extraction Spigot dia in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Model 603 - S</strong></td>
<td>2.3HP</td>
<td>1400/2800</td>
<td>400</td>
<td>250 x 50</td>
<td>P</td>
<td>T/P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model 663 - D</strong></td>
<td>2.3HP</td>
<td>1400/2800</td>
<td>400</td>
<td>250 x 50</td>
<td>P</td>
<td>T/P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model 666 - D</strong></td>
<td>4HP</td>
<td>1400/2800</td>
<td>400</td>
<td>250 x 50</td>
<td>P</td>
<td>T/P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model 616 - D</strong></td>
<td>1.1HP</td>
<td>1400/2800</td>
<td>400</td>
<td>200 x 25</td>
<td>P</td>
<td>P</td>
<td>Yes / 100</td>
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<tr>
<td><strong>Model LBP7 - D</strong></td>
<td>1HP</td>
<td>2800</td>
<td>230</td>
<td>175 x 25</td>
<td>B/P</td>
<td>P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model LBP9 - D</strong></td>
<td>1HP</td>
<td>2800</td>
<td>230</td>
<td>230 x 25</td>
<td>B/P</td>
<td>P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model DSM200 - D</strong></td>
<td>1.2HP</td>
<td>2900</td>
<td>230</td>
<td>200 x 30</td>
<td>B/P</td>
<td>P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model LAF - D</strong></td>
<td>2HP</td>
<td>2800</td>
<td>230</td>
<td>200 x 50</td>
<td>B/P</td>
<td>T</td>
<td>To order</td>
</tr>
<tr>
<td><strong>Model PS150 - D</strong></td>
<td>0.5KW</td>
<td>2950</td>
<td>230</td>
<td>150 x 20</td>
<td>B</td>
<td>P/T</td>
<td>No</td>
</tr>
<tr>
<td><strong>Model Roto-Buffer R - P</strong></td>
<td>2HP</td>
<td>6800</td>
<td>230</td>
<td>125 x 50</td>
<td>n/a</td>
<td>T</td>
<td>No</td>
</tr>
<tr>
<td><strong>Model Roto-Buffer AG - P</strong></td>
<td>2HP</td>
<td>4800</td>
<td>110/230</td>
<td>150 x 50</td>
<td>n/a</td>
<td>T</td>
<td>No</td>
</tr>
<tr>
<td><strong>Model Roto-Buffer SU - P</strong></td>
<td>2HP</td>
<td>2800-5800</td>
<td>110/230</td>
<td>150 x 50</td>
<td>n/a</td>
<td>T</td>
<td>No</td>
</tr>
<tr>
<td><strong>Model AE 5000 - D</strong></td>
<td>2HP</td>
<td>400-5000</td>
<td>230</td>
<td>200 x 50</td>
<td>B/P</td>
<td>T/P</td>
<td>Yes / 100</td>
</tr>
<tr>
<td><strong>Model AE 14000 - S</strong></td>
<td>2HP</td>
<td>800-14000</td>
<td>230</td>
<td>100 x 40</td>
<td>B/P</td>
<td>T/P</td>
<td>To order</td>
</tr>
<tr>
<td><strong>Model AE 10000 - S</strong></td>
<td>0.6HP</td>
<td>800-10000</td>
<td>230</td>
<td>50 x 25</td>
<td>B</td>
<td>T/P</td>
<td>To order</td>
</tr>
</tbody>
</table>

To receive more information on any of the products shown visit www.surtech.co.uk
## Abrasive Belt and Wheel Bench Grinders

**Model BS 100** Belt Grinder

**Model BDS** Belt/Disc Grinder

**Model 100/200 COMBI** Belt/Wheel Grinder

**Model L50** Belt Grinder

**Models DSM 150 GW**

**Models DSM 200 GW**

**Model L61** Belt Grinder

**Models 24 HD** Belt Grinder

**Model 411** Variable speed belt grinder. With interchangeable contact arms. Contact wheels from 15mm to 100mm dia.

### Models

<table>
<thead>
<tr>
<th></th>
<th></th>
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<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>100/200 combi - B/G</td>
<td>1.1 HP</td>
<td>230</td>
<td>W = 200 x 30mm</td>
<td>B = 100 x 915mm</td>
<td>B</td>
<td>Yes / 45mm</td>
<td></td>
<td></td>
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<tr>
<td>DSM200GW - W</td>
<td>0.9KW</td>
<td>230</td>
<td>W = 200mm</td>
<td>B</td>
<td>Yes / 45mm</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>DSM150GW - W</td>
<td>0.5KW</td>
<td>230</td>
<td>W = 150mm</td>
<td>B</td>
<td>Yes / 20mm</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>BS100 - B</td>
<td>2HP</td>
<td>240</td>
<td>B = 100 x 1220mm</td>
<td>B/P</td>
<td>Yes / 75mm</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>BDS - B/D</td>
<td>0.55KW</td>
<td>230</td>
<td>B = 150 x 1220mm</td>
<td>D = 225mm</td>
<td>P</td>
<td>Yes / 55mm</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L50 - B</td>
<td>1.5HP</td>
<td>230 or 400</td>
<td>B = 25 x 1360mm</td>
<td>B/P</td>
<td>No</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>L61 - B</td>
<td>3 HP</td>
<td>230 or 400</td>
<td>B = 100 x 1000mm</td>
<td>B</td>
<td>Yes / 70mm</td>
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<td></td>
<td></td>
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<tr>
<td>S50 - B/D</td>
<td>0.75 KW</td>
<td>240</td>
<td>B = 50 x 1000mm</td>
<td>D = 150mm</td>
<td>B</td>
<td>Yes / 35mm</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>24 HD - B</td>
<td>2HP</td>
<td>400</td>
<td>B = 50 x 1525</td>
<td>B</td>
<td>To order</td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>411 - B</td>
<td>0.75HP</td>
<td>240</td>
<td>B = 12 or 25 or 50 x 1120mm</td>
<td>B</td>
<td>Yes / 2 x 80mm</td>
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<td></td>
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</tbody>
</table>

To receive more information on any of the products shown visit [www.surtech.co.uk](http://www.surtech.co.uk)
AE Powertronic

Variable speed grinding, deburring, sanding, denibbing, finishing and polishing machine

- Suitable for all metals, wood, plastics, paint, ceramics, etc.
- For use with abrasive belts, abrasive wheels, abrasive discs, abrasive brushes, mops, buffs, etc.

<table>
<thead>
<tr>
<th></th>
<th>AE4000/0.5</th>
<th>AE 5000/0.55</th>
<th>AE 5000/1.5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor</td>
<td>Single phase, AC 220/240V, 50 Hz</td>
<td>AC 220/240V, 50 Hz</td>
<td>DC 220/240V, 50 Hz</td>
</tr>
<tr>
<td>kW</td>
<td>0.5</td>
<td>0.55</td>
<td>1.5</td>
</tr>
<tr>
<td>RPM</td>
<td>340-4000</td>
<td>400-5000</td>
<td>400-5000</td>
</tr>
<tr>
<td>Right hand</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Spindle thread</td>
<td>M33</td>
<td>M33</td>
<td>M33</td>
</tr>
<tr>
<td>Left hand</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Spindle thread</td>
<td>M20</td>
<td>M20</td>
<td>M20</td>
</tr>
<tr>
<td>Weight</td>
<td>30 kg</td>
<td>30 kg</td>
<td>30 kg</td>
</tr>
</tbody>
</table>

Available as pedestal model or bench model.

Pedestal model shown above with spindles and guards.
Bench model shown right without spindles and guards.

Mirror polishing lacquer with a wool mop.
Mirror polishing metals with cotton mops.
Superfinishing implants with diamond brush.
Superfinishing turbine blades with diamond brushes.
Finishing difficult areas with Sandex abrasives.
Polishing small radii.
Denibbing with abrasive sanding stars.
Satin finishing with abrasive nylon belts.

Shafts available for all abrasive wheels, mops and buffs.
Can be mounted on dust extractor.

To receive more information on any of the products shown visit www.surtech.co.uk
Model K 2003
Milling, sanding and polishing machine
- Column mounted and height adjustable
- 2 speed or variable speed
- Adjustable guard, foot control and emergency off button

Model K 2002
Milling, sanding and polishing spindle
- Built-in dust extractor
- 2 speed or variable speed
- Adjustable guard, foot control and emergency off button

Model K 2004
Bench top milling, sanding and polishing machine
- 2 speed or variable speed

Model A 275
Bench mount chuck spindle
- 3 speeds - 700, 1400, 2800 rpm

Model 704, Model 724
Single ended or double ended sanding and polishing machine with extended spindles
- 3.3 kW motor
- 2 speed or variable speed
- Adjustable working height

Model 3100
Double ended sanding and polishing machine
- 2 speed or variable speed
- Built-in dust extractor

Model 3400
Combination milling, grinding, sanding and polishing machine
- Flatbed platen and support table on left
- Spindle on right
- 2 speed or variable speed

Model 506
Combination grinding, sanding and polishing machine
- Abrasive belt head on left
- Buff head on right
- 3 - 4 HP
- 2 speed or variable speed
- Optional built-in dust extractor

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To receive more information on any of the products shown visit www.surtech.co.uk
To receive more information on any of the products shown visit www.surtech.co.uk

THE TABLE TOOLS
Shorter working time thanks to an ingenious rapid clamping system

The heart of the S4 systems is the universal ball bolt. Its carefully thought out mechanical design means that it can be reliably fixed in place with one hand in a second or so. This means that setting up or changeover time is greatly reduced.

Comparative tests with conventional work tables and screw clamps showed a potential saving in working time of up to 40 %.

The Clamps. For hollow sections and for tubes. Adjustable angles and interchangeable prisms.

The Stops.

The optional tool stand with some of the most popular clamps, stops, clamping bolts, etc.

Close up shows position of holes and grid.

SOME APPLICATIONS FOR OUR WELDING TABLES

Tubular Fabrications.

Balustrades.

Siegmond welding tables can handle all jiggling jobs. All sizes. All weights. All shapes. The modular system grows with you.

Several tables set up for extra heavy and large fabrications.

Ask for a copy of our 384 page catalogue.

For more details click on www.siegmund.eu
Then click on UK, then click on welding tables in left column. Then click on Service/Downloads

Then click on any of the following, either System 28 or System 16: Tables • Table legs • Stops • Squares • Bolts • Clamps and accessories • Prisms • Supports • Fast clamping equipment • Magnetic clamping technology • Accessories • Sets • Connecting elements • Anti spatter.

For most first time buyers Tables, Table legs and Sets (= tool sets) are the most important sections.

For an explanation of “System 16” and “System 28” click on Welding Tables in second top line and then click on System 28 or System 16 in left column.

For a drawing of the System 16 or System 28 grid click on System16 Grid in left column

For choice of welding table materials click on S4 surfaces in left column.
Bevelling Machines

With Rotary Shear Cutters

- Model CHP 6
- Model CHP 12
- Model CHP 12-G
- Model CHP 12-G REV
- Model CHP 21-G
- Model CHP 21-G INV

All CHP bevelling machines use rotary shears for cutting. Rotary shears cut faster than milling cutters used in many other bevelling machines, however the finish is not as smooth as produced by milling cutters but has a rippled surface.

Model CHP 12 is the most popular machine. It covers nearly 80% of all bevelling operations with portable and transportable machines. Model CHP 12 as well as Model CHP 21 can be mounted on wheeled carriages so that the machines self propel along the length of the plate.

CHP machines can also bevel tubes and small plates.

<table>
<thead>
<tr>
<th>Milling Cutters</th>
<th>CHP 6</th>
<th>CHP 12</th>
<th>CHP 12-G</th>
<th>CHP 21-G</th>
<th>CHP 21-G INV</th>
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<tbody>
<tr>
<td>1026</td>
<td>XX</td>
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<td>2003-A</td>
<td>XX</td>
<td></td>
<td>X</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- Motor Power
  - Model CHP 6: 0.75 HP
  - Model CHP 12: 3 HP
  - Model CHP 12-G: 3 HP
  - Model CHP 12-G REV: 4 HP
  - Model CHP 21-G: 3 HP
  - Model CHP 21-G INV: 4 HP
- Voltage
  - All models: 220/380 V
- Approx Feed Speed per minute
  - Mild steel
    - Model CHP 6: 1.8m
    - Model CHP 12: 2.6m
    - Model CHP 12-G: 2.6m
    - Model CHP 12-G REV: 1.7m
    - Model CHP 21-G: 1.3m
    - Model CHP 21-G INV: 0.9m
  - Stainless steel
    - Model CHP 6: 0.9m
    - Model CHP 12: 1.3m
    - Model CHP 12-G: 1.3m
    - Model CHP 12-G REV: 0.9m
    - Model CHP 21-G: 1.3m
    - Model CHP 21-G INV: 0.9m
- Max bevel width
  - Model CHP 6: 6mm
  - Model CHP 12: 12mm
  - Model CHP 12-G: 12mm
  - Model CHP 12-G REV: 12mm
  - Model CHP 21-G: 6mm
  - Model CHP 21-G INV: 6mm
- Bevel angle
  - Model CHP 6: 30°
  - Model CHP 12: 30°
  - Model CHP 12-G: 30°
  - Model CHP 12-G REV: 20-45°
  - Model CHP 21-G: 20-45°
  - Model CHP 21-G INV: 9-50mm
- Plate thickness
  - Model CHP 6: 3-16mm
  - Model CHP 12: 6-40mm
  - Model CHP 12-G: 6-30mm
  - Model CHP 12-G REV: 6-30mm
  - Model CHP 21-G: 6-30mm
  - Model CHP 21-G INV: 6-30mm
- Approx weight
  - Model CHP 6: 34 kg
  - Model CHP 12: 65 kg
  - Model CHP 12-G: 65 kg
  - Model CHP 12-G REV: 110 kg
  - Model CHP 21-G: 370 kg

To receive more information on any of the products shown visit www.surtech.co.uk
We can offer the largest range of chamfering and bevelling machines in the UK. From light to extra heavy duty portable, bench or pedestal mounted. Special designs for heavy plate as used in ship and bridge building.

The machines shown here are a selection of our most popular models.

<table>
<thead>
<tr>
<th>Portable Bevelling machines with milling cutters</th>
<th>Portable Radiusing machine</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model 2014 1.5 KW, 0 - 5mm chamfer</td>
<td>Model KaKi 2014-42 1.4 KW, 0.5 - 6mm radii</td>
</tr>
<tr>
<td>Model 2023 2.6 KW, 0 - 10mm chamfer</td>
<td></td>
</tr>
<tr>
<td>Model 760 1 KW, 0 - 15mm chamfer</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Pedestal and Bench Chamfering machines with abrasive discs</th>
<th>Pedestal and Bench Chamfering machines with milling cutters</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model 43 0 - 3mm chamfer</td>
<td>Model 43 0 - 3mm chamfer</td>
</tr>
<tr>
<td>Model 61 0 - 6mm chamfer</td>
<td>Model 61 0 - 6mm chamfer</td>
</tr>
<tr>
<td>Model 650 0 - 10mm chamfer (horizontal cutting head)</td>
<td>Model 650 0 - 10mm chamfer (horizontal cutting head)</td>
</tr>
</tbody>
</table>

### Bevel Finishes

- **Radiusing on one or both edges.** 2 - 6mm radii.
- **The slightly rippled bevel finish from machines with milling cutters.**
- **The smoothest finish produced by abrasive belts or discs.**

### Portable Bevelling machines with milling cutters

- **Model 2014**
  - Power: 1.5 KW
  - Chamfer range: 0 - 5mm
- **Model 2023**
  - Power: 2.6 KW
  - Chamfer range: 0 - 10mm
- **Model 760**
  - Power: 1 KW
  - Chamfer range: 0 - 15mm
- **Model KaKi 2014-42**
  - Power: 1.4 KW
  - Radii range: 0.5 - 6mm

### Portable Radiusing machine

- **Model 2014-42**
  - Power: 1.4 KW
  - Radii range: 0.5 - 6mm

### Pedestal and Bench Chamfering machines with milling cutters

- **Model 43**
  - Power: 0.5 KW
  - Chamfer range: 0 - 3mm
- **Model 61**
  - Power: 1.1 KW
  - Chamfer range: 0 - 6mm
- **Model 650**
  - Power: 1.1 KW
  - Chamfer range: 0 - 10mm
  - Cutting head: horizontal

### Pedestal and Bench Chamfering machines with abrasive discs

- **Model 43**
  - Power: 0.5 KW
  - Chamfer range: 0 - 3mm
- **Model 61**
  - Power: 1.1 KW
  - Chamfer range: 0 - 6mm
- **Model 650**
  - Power: 1.1 KW
  - Chamfer range: 0 - 10mm
  - Cutting head: horizontal

### Edge preparation for shipbuilders, bridgebuilders and the construction industry

- Edge grinding
- Corner radiusing
- Bevelling
- Removing primer and rust
- Removing hardened surface
- Straightening edges

A typical installation with infeed and outfeed handling. With multihed abrasive belt power grinders inside acoustic booth. With central control cabinet.

To receive more information on any of the products shown visit [www.surtech.co.uk](http://www.surtech.co.uk)
To receive more information on any of the products shown visit www.surtech.co.uk

# Dust Extractors for Surtech Abrasive Belt Grinding Machines

## Wet Extractors for non hazardous and hazardous dusts

<table>
<thead>
<tr>
<th>Model</th>
<th>Capacity Approx. CFM</th>
<th>Fan Motor HP / Voltage</th>
<th>Extraction Spigots in mm</th>
<th>W = Wet</th>
<th>D = Dry</th>
<th>H = Hazardous</th>
<th>NH = Non Hazardous</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASP 700</td>
<td>385</td>
<td>0.75 / 400 or 230</td>
<td>80 or 100 or 150</td>
<td>D</td>
<td></td>
<td></td>
<td>NH</td>
</tr>
<tr>
<td>DCP 25</td>
<td>350</td>
<td>0.5 / 400 or 230</td>
<td>2 x 100</td>
<td>D</td>
<td></td>
<td></td>
<td>NH</td>
</tr>
<tr>
<td>DVS</td>
<td>380</td>
<td>0.5 / 400 or 230</td>
<td>2 x 75</td>
<td>D</td>
<td></td>
<td></td>
<td>NH</td>
</tr>
<tr>
<td>DE 2000</td>
<td>1000</td>
<td>1.8 / 400</td>
<td>2 x 80, 2 x 100</td>
<td>D</td>
<td></td>
<td></td>
<td>NH</td>
</tr>
<tr>
<td>FX 3-294</td>
<td>400-3500</td>
<td>0.7-10 / 400</td>
<td>vary by model</td>
<td>D</td>
<td></td>
<td></td>
<td>NH or H</td>
</tr>
<tr>
<td>DUSTOMAT10</td>
<td>420</td>
<td>1.4 / 400 or 230</td>
<td>1 x 100</td>
<td>D</td>
<td></td>
<td>NH and H</td>
<td></td>
</tr>
<tr>
<td>W60-W220</td>
<td>500-6000</td>
<td>1.4-20 / 400</td>
<td>vary by model</td>
<td>W</td>
<td></td>
<td>NH or H</td>
<td></td>
</tr>
</tbody>
</table>

## Dry Extractors for non hazardous and hazardous metal dusts

- ASP 700
- DE 2000
- DVS
- DCP 250
- FX3-FX294

## Dust Benches
- Designed and built to order. From 1000mm to 2000mm wide.

## Spark Arresters
- Suitable for aluminium and very fine dust from wood, plastics and lacquer.

## Coolant Filters
- Automatic coolant filter. 75 litre capacity. With paper filter.

Do not forget capture hoods, ducting, connectors, gates and other optional accessories necessary for a complete installation.

Observe COSHH, ATEX, DSEAR regulations.

For more information and Health and Safety matters ask for a copy of our EASY GUIDE for dust.
You are Invited to visit the UK’s largest Abrasive Test Centre

At the Surtech Abrasive Test Centre where you will find the UK’s largest selection of the very latest grinding, deburring, polishing, satin finishing & brushing machines.

Bring your own parts and discuss your requirements with our skilled engineers who will also set up practical demonstrations. See for yourself how our machines can be used to solve problems and improve efficiency.

Surtech was formed in 1973 to specialise in the manufacture and distribution of mechanical surface finishing equipment and materials.

Within this field we aim to provide the latest available technology from anywhere in the world. We are constantly reviewing the needs of our customers and we tailor our product range accordingly.

HOW TO ARRANGE A VISIT

Please Ring our sales office on 0121 359 4322 and tell us when you want to visit. We can fit you in most days. Please give a brief outline of what you want to see so that we can arrange to have the most suitable machines available. Surtech trained engineers will be on hand to advise and demonstrate.

HOW TO FIND US

Coming from M6 North or South exit at ‘Junction 6’ (Spaghetti Junction) following signs ‘Birmingham Central A38 (M)’ stay in left lane. Ignore first A38 (M) exit signposted ‘Aston, Perry Barr’.

Follow overhead signs to ‘Ring Road, City Centre, Bromsgrove (A38)’. Stay in left lane to leave roundabout at first exit and follow signs ‘Wholesale and Indoor Markets’ then signs to ‘Convention Centre, National Indoor Arena’ and finally ‘Ring Road And Other Routes’, ‘Birmingham Airport, NEC, Lichfield’.

Stay in left lane to set of traffic lights outside ‘Fletchers Autostore’. Stay in left lane for approx another 100m and take first left turning into ‘Heneage Street’, also signposted ‘The Parkway Industrial Centre’.

Surtech are the first Company on the left after ‘Adams Street’. Park outside or opposite on the industrial estate.