

BG38 BOILER GUN

The BG38 Boiler Gun™ is a combination of power, versatility, and ease of use in a compact and lightweight package. Designed to perform on-site machining on boiler tubes or other pipe applications with speed and accuracy, delivering the optimal speed and torque combination to make short work of your tube prep projects.



POWERFUL PERFORMANCE

Powerful drive motors make quick work of light-wall tubing and provide the torque needed for heavy-wall alloy tubes.

Multiple RPM ranges available with extra high-velocity (Plus), high-velocity (HV), low-velocity (LV), covers a wide range of applications.

Heavy duty gears increase machine longevity and provides the torque and speed required to perform a wide variety of end prep work.

Heavy duty tapered roller bearings for very rigid and smooth operation.

VERSITILE

Pneumatic, Electric, and Cordless motor options allow for machine use in any environment or facility.

Narrow head width enables use in tight spaces such as boiler water walls.

Two different locking systems available - Collet or Wedge, giving you the best clamping capability for any application.

Enhanced wedge design with an integrated wedge system and captured retaining springs allows quick change of wedge extensions and prevents loss of spring

'Speed Wheel' allows wedge expansion using a star-wheel, which is faster in confined spaces.

Anchor Grip™ collet system provides superior gripping for applications such as stub removal, light wall tubing that cannot be deformed and tubing that cannot be contaminated with falling debris.

Patented Multi-Prep® Tool Holder combines multiple machining operations into a single operation.

Corrosion resistant finish applied to all external components prevents machine weathering and extends the life of the components.

EASY TO USE

Finer feed screws make it easier to advance the feed, putting less burden on the operator and the machine.

Drop Swivel Air Fittings extend the life of the machine by reducing hose kinks and damage.

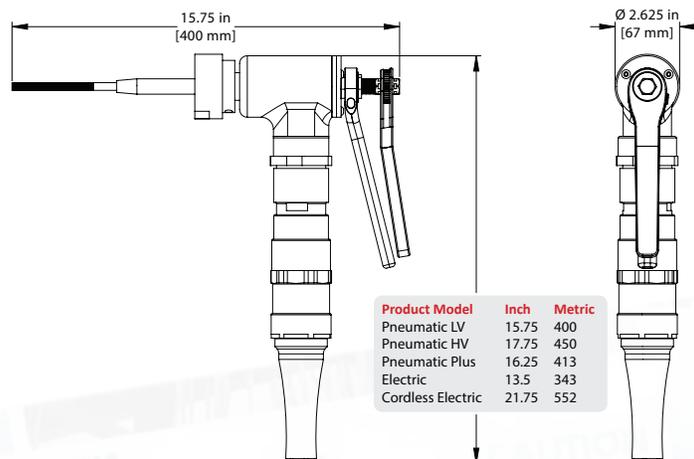
Air Lock option dramatically saves time on high-volume jobs by locking and unlocking the tool instantly with the flip of a valve.

Heavy-duty storage case with foam inserts protects the machine from damage on-site or in transit.

BG38 BOILER GUN

	INCH	METRIC
Machine Performance Ranges		
Working range inside diameter to outside diameter	0.625 ID-3.000 OD	15.8-76.2
Radial tool clearance	1.312	33.3
Head width	2.625	66.6
Travel	2.125	53.9
Rotational Drive System		
Pneumatic motor	1.3 Hp	0.97 kW
Recommended air pressure	90 PSI	6.2 Bar
Recommended volume	38 CFM	1.1 m ³ /min.
Speed LV	90 RPM	90 RPM
Speed HV	140 RPM	140 RPM
Speed PLUS	200 RPM	200 RPM
Electric motor	1 Hp, 110V / 6.7A or 220V / 3.4A	0.75 kW, 110V / 6.7A or 220V / 3.4A
Speed	0 - 270 RPM	0 - 270 RPM
Cordless electric (rechargeable Lithium Ion)	5.2 amp/hr	18720 coulomb
Speed	0 - 105 RPM	0 - 105 RPM
Measures		
Machine weight		
Pneumatic LV / HV	17 lbs	7.7 kg
Pneumatic PLUS	13 lbs	5.9 kg
Electric	14 lbs	6.3 kg
Cordless Electric	17 lbs	7.7 kg
Shipping weight		
Pneumatic LV / HV	43 lbs	19.5 kg
Pneumatic PLUS	39 lbs	17.7 kg
Electric	40 lbs	18.1 kg
Electric cordless	43 lbs	19.5 kg
Dimensions		
Length (L x W x H)	Refer to dimensional drawing below	
Crate dimensions (L x W x H)	22 x 17.5 x 5.5	559 x 445 x 140

DIMENSIONAL DRAWING



BG38 BOILER GUN

To order your **BG38 BOILER GUN™**, simply select from the options below.

To configure your machine, please follow these steps.

1. Select base model
2. Select mounting system
3. Select tool holder
4. Select optional tool holder bits

1. Base model

Pneumatic motor units include: pneumatic motor, wrench feed, hose with oiler, filter & swivel, tool kit, operator manual and storage case.

Pneumatic LV, 90 RPM motor	HS-BG38LV-R
Pneumatic HV, 140 RPM motor	HS-BG38HV-R
Pneumatic PLUS, 200 RPM motor	HS-BG38PL-R

Electric motor units include: electric motor, wrench feed, tool kit, operator manual and storage case.

110V Electric, 0 - 270 RPM motor	HS-BG22E110-R
220V Electric, 0 - 270 RPM motor	HS-BG38E220-R
110 V Cordless Electric, 0 - 105 RPM - (battery powered)	HS-BG38C110-R
220V Cordless Electric, 0 - 105 RPM - (battery powered)	HS-BG38C220-R

2. Mounting system

Includes center shafts, draw rod, and wedges or collets for full range

Wedge set, 0.625 - 3 in - (15.9 - 63.5 mm)	HS-BG38WSET
Collet set, 0.625 - 3 in - (15.9 - 63.5 mm)	HS-BG38CSET

3. Tool holder

Sliding tool holders

Full set 2.625 & 3 in (66.7 & 76.2 mm) - w/2-flute; 3 in (76.2 mm) w/3-flute	HS-BG38THS
2.625 in (66.7 mm) w/2-flute	HS-B002534
2.625 in (66.7 mm) w/3-flute	HS-B002565
3 in (76.2 mm) w/2-flute	HS-B002536

Fixed tool holders

2.625 in (66.7 mm)	HS-B002521
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4. Tool holder bits (optional)

Sliding Tool Holder Bits

S-37 Blade, 1/2 inch (12.7 mm) - wide 37° bevel	HS-BLS37
S-37 Wide Blade, 3/4 inch (19.1 mm) - wide 37° bevel	HS-BLS37W
SF Blade, 1/2 inch (12.7 mm) - wide facing/0° bevel	HS-BLSF
SF Wide Blade, 3/4 inch (19.1 mm) - wide facing/0° bevel	HS-BLSFW
SI-10 Blade, 1/2 inch (12.7 mm) - wide 10° ID counter bore	HS-BLSI
SI-10 Wide Blade, 3/4 inch (19.1 mm) - wide 10° ID counter bore	HS-BLSIW

Fixed Tool Holder Bits

D-Blade, left offset 37° bevel	HS-BLD
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C-Blade, right offset 37° bevel	HS-BLC
FL-Blade, left offset facing/0° bevel	HS-BLFL
FR-Blade, right offset facing/0° bevel	HS-BLFR
I-Blade, standard 10° ID counter bore	HS-BLI
HR-Blade, small ID 10° ID counter bore	HS-BLHR



Sliding tool holder



Fixed tool holder

The **BG38 BOILER GUN'S** enhanced wedge design comes with an integrated wedge system and captured retaining springs which allows for quick change of wedge extensions and prevents loss of spring.



Everything you need comes complete in a custom designed shipping container.



Membrane Multi-Prep head, round inserts

(removes membrane and bevels tube end at 37°)

1.000 in (25.4 mm)	HS-BM/MP1.00R
1.125 in (28.8 mm)	HS-BM/MP1.125R
1.250 in (31.8 mm)	HS-BM/MP1.250R
1.375 in (34.9 mm)	HS-BM/MP1.375R
1.500 in (38.1 mm)	HS-BM/MP1.500R
1.625 in (41.3 mm)	HS-BM/MP1.625R
1.750 in (44.5 mm)	HS-BM/MP1.750R
1.875 in (47.6 mm)	HS-BM/MP1.875R
2.000 in (50.8 mm)	HS-BM/MP2.000R
2.500 in (63.5 mm)	HS-BM/MP2.500R

Membrane head, round inserts

(removes membrane only, does not bevel)

0.875 in (22.2 mm)	HS-BM.875R
1.000 in (25.4 mm)	HS-BM1.000R
1.125 in (28.8 mm)	HS-BM1.125R
1.250 in (31.8 mm)	HS-BM1.250R
1.375 in (34.9 mm)	HS-BM1.375R
1.500 in (38.1 mm)	HS-BM1.500R
1.625 in (41.3 mm)	HS-BM1.625R
1.750 in (44.5 mm)	HS-BM1.750R
1.875 in (47.6 mm)	HS-BM1.875R
2.000 in (50.8 mm)	HS-BM2.000R
2.500 in (63.5 mm)	HS-BM2.500R

Diameter Clean-Up Multi-Prep head, round inserts

(lightly machines the OD of the tube and bevels tube end at 37°)

1.000 in (25.4 mm)	HS-BDC/MP1.00R
1.125 in (28.8 mm)	HS-BDC/MP1.125R
1.250 in (31.8 mm)	HS-BDC/MP1.250R
1.375 in (34.9 mm)	HS-BDC/MP1.375R
1.500 in (38.1 mm)	HS-BDC/MP1.500R
1.625 in (41.3 mm)	HS-BDC/MP1.625R
1.750 in (44.5 mm)	HS-BDC/MP1.750R
1.875 in (47.6 mm)	HS-BDC/MP1.875R
2.000 in (50.8 mm)	HS-BDC/MP2.00R
2.500 in (63.5 mm)	HS-BDC/MP2.500R

Diameter Clean-Up head, round inserts

(lightly machines the OD of the tube only, does not bevel)

0.875 in (22.2 mm)	HS-BDC.875R
1.000 in (25.4 mm)	HS-BDC1.00R
1.125 in (28.8 mm)	HS-BDC1.125R
1.250 in (31.8 mm)	HS-BDC1.250R
1.375 in (34.9 mm)	HS-BDC1.375R
1.500 in (38.1 mm)	HS-BDC1.500R
1.625 in (41.3 mm)	HS-BDC1.625R
1.750 in (44.5 mm)	HS-BDC1.750R
1.875 in (47.6 mm)	HS-BDC1.875R
2.000 in (50.8 mm)	HS-BDC2.00R
2.500 in (63.5 mm)	HS-BDC2.500R

Multi-Prep®

The patented Multi-Prep tool holder has proven to be effective in improving productivity and quality. It combines multiple machining operations into a single operation. With the Multi-Prep you can accurately clean the tube OD and remove membrane from panel tubes, while performing an outside bevel on the tube end.



H&S APPLICATIONS

The Boiler Guns are used by these industries

- Power Generation
- Fossil-Fuel Power Stations
- Gas Turbine Power Plants
- Pulp and Paper Plants
- Chemical Processing Plants
- Oil Refineries
- Ship Yards
- Water and Wastewater Treatment

Typical Applications

- Boiler tube repair
- Stud removal
- Pipe lines
- Seal weld removal

A Fast Three-Step Process

Ready to bevel in 7 minutes or less!

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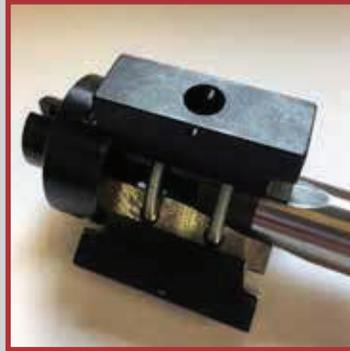
WEDGE SYSTEM

Thread the base wedge set onto the locking rod and install extensions as required. Install the locking rod wrench and nut on the locking rod.

or

COLLET SYSTEM

Slide the locking rod through the center shaft. Thread the required collet set onto the locking rod and install the cotter pin in the end of the locking rod end.



2

Mount the machine on the work piece. Be aware of the position of locking system in the work piece; allow approximately 1/2" (12.7mm) of material for machining. Tighten the locking system by turning the locking rod wrench.



3

Install the blades in the tool holder 180° apart. Position the blades for cutting by turning the feed wrench.

