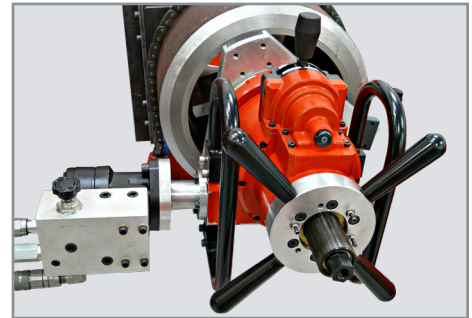
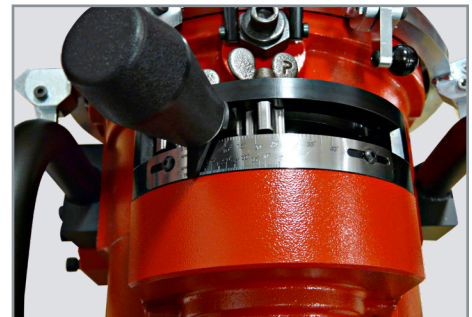




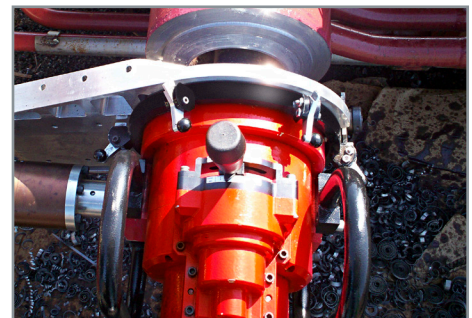
**Form Tool, Single Point and  
Flange Facing Machine Tool**



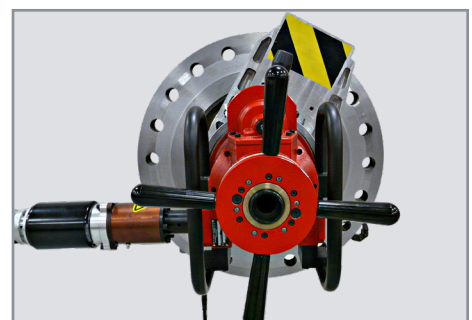
Single point model includes Wachs AutoFeed system. Form tool basic model also available.



Wachs innovative AutoFeed system allows you to set your desired weld profile with hands-free machining.



Wachs EP 424 power and precision are ideal for heavy wall and high-alloy steel applications.



Hydraulic, electric or pneumatic drive options are available. Wachs EP 424 is ideal for flange facing.

**PRODUCT HIGHLIGHTS**

- ◆ Innovative Hands-free AutoFeed Feature
- ◆ Best for Heavy Wall & High Alloy Materials
- ◆ Multiuse - Single Point, Form Tool, Flange Facing

**DESCRIPTION**

E.H. Wachs EP 424 with its available AutoFeed system is a precision ID mounted end prep machine tool designed to bevel, compound bevel, J prep, face and counterbore pipe, fittings and valves. Its revolutionary AutoFeed automatically feeds simultaneously in the axial and radial planes to machine any bevel or compound bevel without templates, incline tool slides or work stoppage. Ideal for heavy wall or high alloy materials, the EP 424 is powerful enough to form tool from 4 to 16" (DN100-400) through Schedule 160, and single point from 4 to 24" (DN100-600) up to a 6.5" (165mm) wall thickness. For form tooling or as a dedicated flange facer the Wachs EP 424 is also offered without AutoFeed. More versatile and powerful to use than any other machine of its kind, the Wachs

EP 424 sets the standard for a user-friendly, large diameter, heavy wall end prep machine.

**EP 424 FEATURES**

- AutoFeed mechanism automatically feeds in radial and axial planes
- AutoFeed lets you dial-in your weld prep profile without stopping
- AutoFeed eliminates bulky profile templates and incline tool slides
- Single point machining from 4 to 24 inches OD (DN100-600)
- Form tool machining from 4 to 16 inches OD (DN100-400)
- Mounts to pipe ID with easy to use self-centering mandrels
- Available without AutoFeed for basic form tooling and facing



**EP 424 SPECIFICATIONS**

**Models:** Form Tool Basic with standard mandrel (AutoFeed optional)  
AutoFeed Deluxe model with standard mandrel and AutoFeed  
AutoFeed Premium model with standard, elbow & independent mandrels & AutoFeed

**System Function:** ID mount end prep machine tool with available AutoFeed to bevel, compound bevel, counterbore, J Prep, and flange facing on pipe, fittings and valves. Also available as Form Tool Basic without AutoFeed for form tooling and flange facing

**System Capacity:** Preps large diameter pipe 4 - 24 inches OD (DN100-600), form tools 4 - 16 inches OD (DN100-400); varies by application and tooling

**Drive Options:** Hydraulic, pneumatic, 110V and 480V electric drive

**Power Requirements:** Hydraulic 10 GPM @ 1500 PSI (38 LPM @ 103 BAR)  
Pneumatic 95 CFM @ 90 PSI (2.7 Cubic Meters per Minute @ 6.2 BAR)  
Electric 110V 20A Eibenstock or 440V 20A 3 phase Servo Drive

**Feed:** AutoFeed system with dial control, or fully manual

**Feed Stroke/Rate:** 3.5" (88.9mm) useable stroke / variable feed rate, user adjustable

**Construction:** Lightweight aluminum housing, hardened steel main shaft, high capacity bearings and load surfaces, quick deploy mandrel legs, captivated hardware

**Finish:** Multistage powder coat red enamel finish with black oxide and clear coated components

**Tool RPM / Tooling:** 0 to 20 rpm / standard Wachs single point beveling and form tooling, high speed steel or carbide

**Tool Slots:** Rotating tool head with 3 tooling slots for simultaneous bevel, facing and counterboring. Optional single point/facing module with single slot and positive starwheel advance

**Packaging:** Heavy duty storage case - all models

**Weight:** Modular construction, each module under 70 lbs (31.75 Kg), total weight with storage case 178 lbs (80.7 Kg)

**PART NUMBERS**

Form Tool Basic Pneumatic (w/o AutoFeed)	<b>81-000-01</b>
Form Tool Basic Hydraulic (w/o AutoFeed)	<b>81-000-02</b>
Single Point Deluxe Pneumatic w/ AutoFeed	<b>81-000-05</b>
Single Point Deluxe Hydraulic w/ AutoFeed	<b>81-000-06</b>
Single Point Premium Pneumatic w/ AutoFeed	<b>81-000-03</b>
Single Point Premium Hydraulic w/ AutoFeed	<b>81-000-04</b>

**STANDARD EQUIPMENT**

- Standard Mandrel
- Extension Leg Kit
- Heavy Duty Storage Case
- Operating Hand Tools
- Operating Manual

**OPTIONAL EQUIPMENT**

- Electric Drive Motors
- Independent Mandrel
- Short Perch Mandrel
- AutoFeed Upgrade Kit for Basic Model
- Single Pointing 36" Slide
- Interchangeable Tooling Mounts
- Genuine Wachs Tooling

**EP 424 SINGLE POINT AUTOFEED**

