

DynaPrep MDSF Split Frame



Slides feature Rapid Adjust and Micro Adjust



Slides accept 1in (25.4mm) square & all popular size tooling



V-Lock ring mating surface resists force distortion

Complete Machining System

E.H. Wachs DynaPrep® MDSF Split Frame redefines the category of cold cutting machine tools for pipe and vessels. Designed for cutting, beveling, facing, counterboring, and flange facing, it's offered in 18 standard models for popular nominal pipe sizes ranging from 2-72in OD (DN50-1800), with each machine covering a generous 6in range.

Engineered to be powerful, strong and lightweight, DynaPrep offers unmatched form tooling capability on heavy wall pipe including high alloy material. Sold as complete kits or individual components the DynaPrep MDSF is available with remote control options in your choice of pneumatic, hydraulic or electric drive.



DynaPrep MDSF Split Frame



DynaPrep MDSF offers enhanced form tool capabilities



Tool-free drive mounting on heavy duty pinion to handle more power



Aluminum stationary frame with steel rotating ring



DynaPrep MDSF tool slides with Rapid Adjust

Advanced Cutting with DynaPrep MDSF

As the needs of the field machinist have evolved, E.H. Wachs products have evolved to meet those needs. Our users asked for stronger form tooling capabilities and a more productive user experience, while delivering greater precision with faster and safer operation. The DynaPrep MDSF Modular Design Split Frame is the latest example of Wachs machine tool innovation that does just that.

The DynaPrep MDSF represents the pinnacle of cold cutting split frame technology. Retaining the class leading portability and versatility that distinguished our LCSF Low Clearance Split Frame, DynaPrep is built tougher to withstand additional torque to pull bigger chips. It offers so many patented features that make it so easy to use you'll wonder why nobody thought of them before.

The DynaPrep MDSF is another in a long string of innovations from the pioneer in portable, cold cutting machining technology. It started with the Trav-L-Cutter, then the industry standard reciprocating Guillotine saw, followed by the ground breaking LCSF split frame.

Portable, Easy to Operate

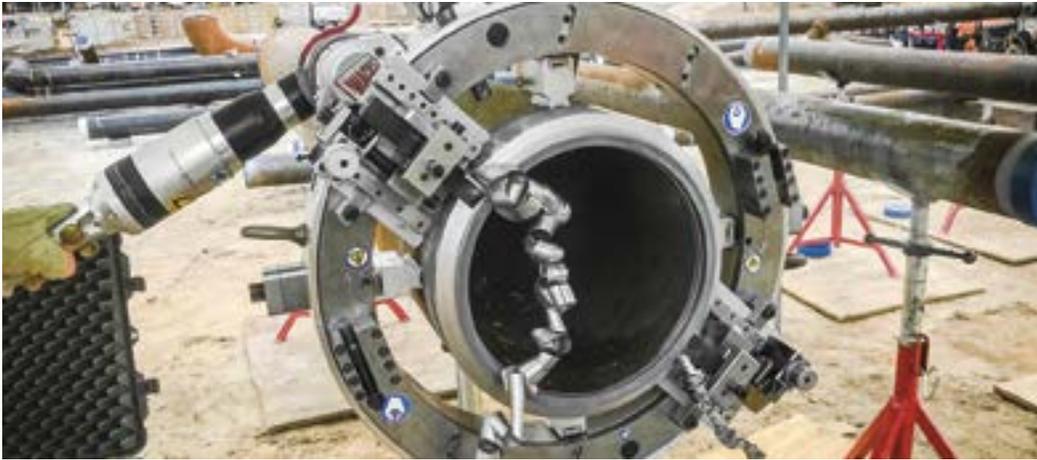
Unlike heavy steel machines, the DynaPrep MDSF retains the advanced light-weight aluminum and steel construction that maintains the portability and ease of setup and operation that characterized the LCSF. DynaPrep includes system indexing, where major assemblies are indexed to simplify setup and promote repeatability. The tool slides are indexed to the rotating ring, the trip is indexed to the tool slides, making the DynaPrep virtually crash proof.

The DynaPrep tool slides incorporate our exclusive Rapid Adjust™ feature, where a turn of a collar allows for large tooling movement during setup, a real time saver. The Micro Adjust feature on the slide allows fine hand positioning of the tooling, and a tooling spacer block arrangement accepts multiple tooling sizes and types.

Remote Control Options

The DynaPrep MDSF is the first machine designed from the ground up to accommodate remote control operation, conforming to the industry trend of moving operators out of hostile environments and away from rotating machinery. Remote options exist for all MDSF drive types, pneumatic, hydraulic and electric, including remote trip actuation.

DynaPrep MDSF Split Frame



Pipe Cutting

A Complete Pipe Machining System

Wachs DynaPrep MDSF can be used to cut, bevel, single point, counterbore, trepan, flange face and more. With ring sizes capable of machining from 2-72in OD (DN50-1800), it's used in a wide variety of industries including oil & gas, power generation, pipeline distribution, shipbuilding, mining, and anywhere pipe, tube or vessels are present. The DynaPrep MDSF sets the benchmark in portable machine tool systems.

Pipe Cutting

The MDSF is capable of cutting (parting), double parting (utilizing two cutting blades) or simultaneous cutting and beveling.

Pipe Beveling

The DynaPrep quickly and safely creates the more complex weld preps specified today that torching and grinding cannot. The MDSF can be configured to bevel, compound bevel, and create J-Preps with specific radius and precise lands.

Counterboring

Counterboring is the process of machining the ID of pipe, after the weld prep is completed and before the sections are welded. The DynaPrep MDSF offers multiple modules and accessories to perform any type of counterboring.

Flange Facing

The DynaPrep MDSF makes an excellent flange facer, with available modules designed for flat face, raised face, record grooving and machining RTJ grooves. Utilizing the MDSF as the platform saves time and the expense of bringing in dedicated facing machines.

Heavy Wall

With its robust construction and powerful drive motor options, the DynaPrep MDSF is the best choice for machining heavy wall pipe. Depending on the material, it can form tool up to 2.5in (63mm) wall.

Form tooling refers to an operation where the tooling is shaped to the final weld profile desired. This is opposed to single point tooling, where the tip of the tooling (the single point) cuts a narrow track that must travel axially and radially to create the desired profile.



Pipe Beveling

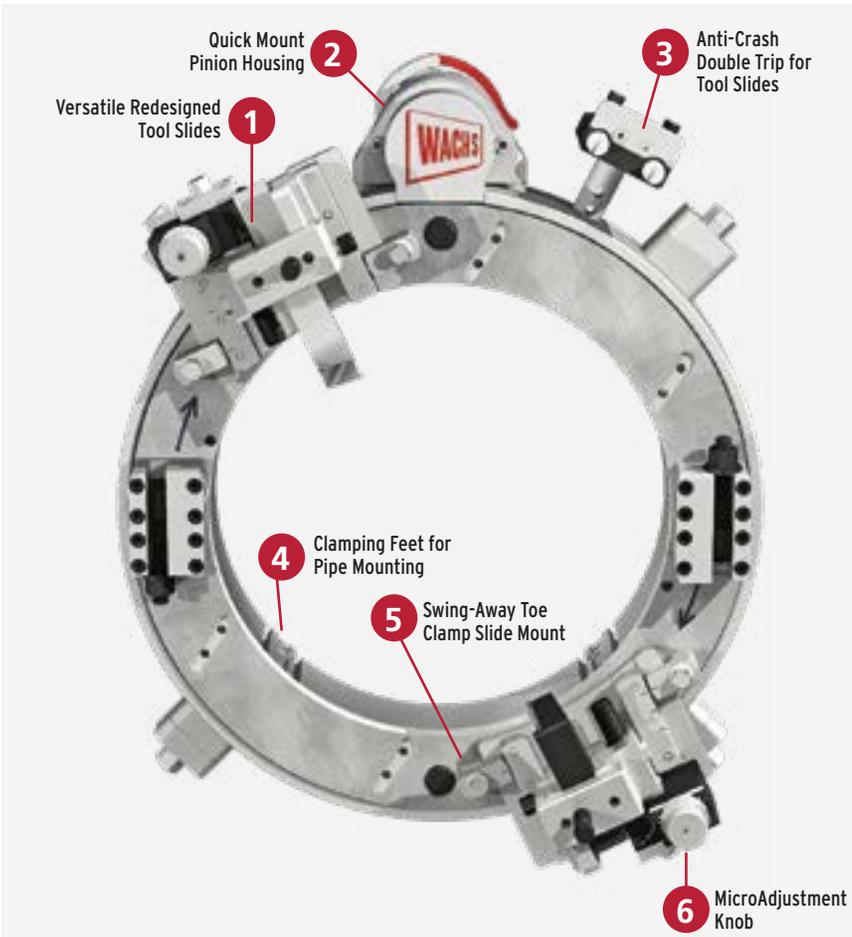


Counterboring



Flange Facing

DynaPrep MDSF Features



DynaPrep MDSF

- Rugged design with superior form tooling capability
- Gear design withstands force from larger more powerful drive motors
- Ring sizes 20in and below use four clamping feet for squaring
- V-Lock frame mating surfaces allow off-center setup for faster alignment.
- Aluminum fixed ring for portability, steel rotating ring for strength
- Advanced heat treating and anti-corrosion coatings for enhanced durability
- Dual row v-bearing construction for precision and durability
- V-bearings run in a unique hardened steel dual raceway
- Dual raceway design evenly distributes force loading no matter the direction
- Only two sockets, .5in (13mm) and .75in (19mm), needed for setup and operation



1

Accepts most common tooling sizes including 1in (25.4mm) square & .5x 3/4in (12.7 x 19mm)



2

Gear design withstands force from all drive types: Pneumatic, Hydraulic & Electric



3

Anti crash ramp on tool slides retracts dual trips if mispositioned



4

Ring sizes 20in & below use four clamping feet for squaring



5

Captivated, swing-away toe clamp for easier slide mounting



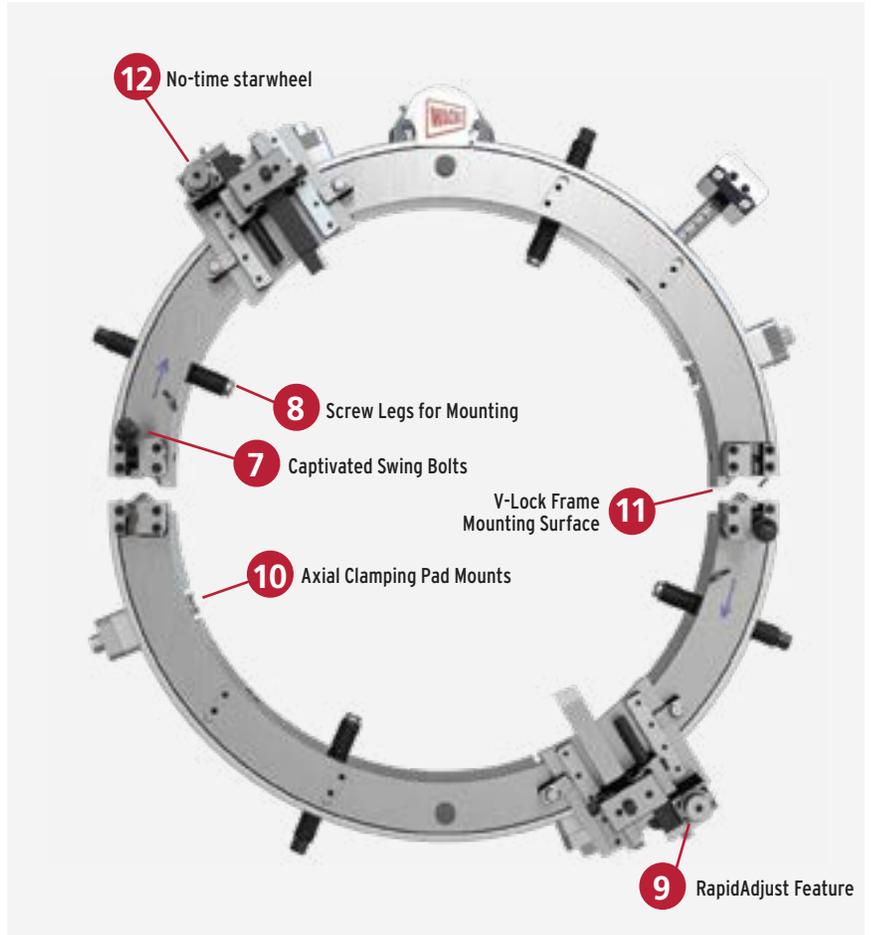
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Rapid Adjust and Micro Adjust knobs provide greater precision during setup & operation

DynaPrep MDSF Features

DynaPrep MDSF

- V-Lock frame mating surfaces feature angled captivated bolt and keyway
- Ring sizes 24in (610mm) up to 72in (1800dn) use eight clamping feet for squaring and stability
- Indexed, squaring clamping leg design features a 2in (50mm) stroke
- Single clamp pad extension covers a 6in (152mm) pipe diameter range
- Clamp pads mount axially without removing the machine from the pipe
- U shaped feet pair with push in buttons and points for miter or elbow mounting
- Screw feet reverse and accept push in buttons and points
- All models feature replaceable felt wiper for lubrication and to capture chip debris
- Captivated swing bolts allow for fast positioning over inline pipe



Swing bolts allow for fast positioning over inline pipe



Screw feet reverse and accept push-in buttons & pins



Rapid Adjust feature speeds positioning of tooling



Clamp pads mount axially without removing the machine from the pipe

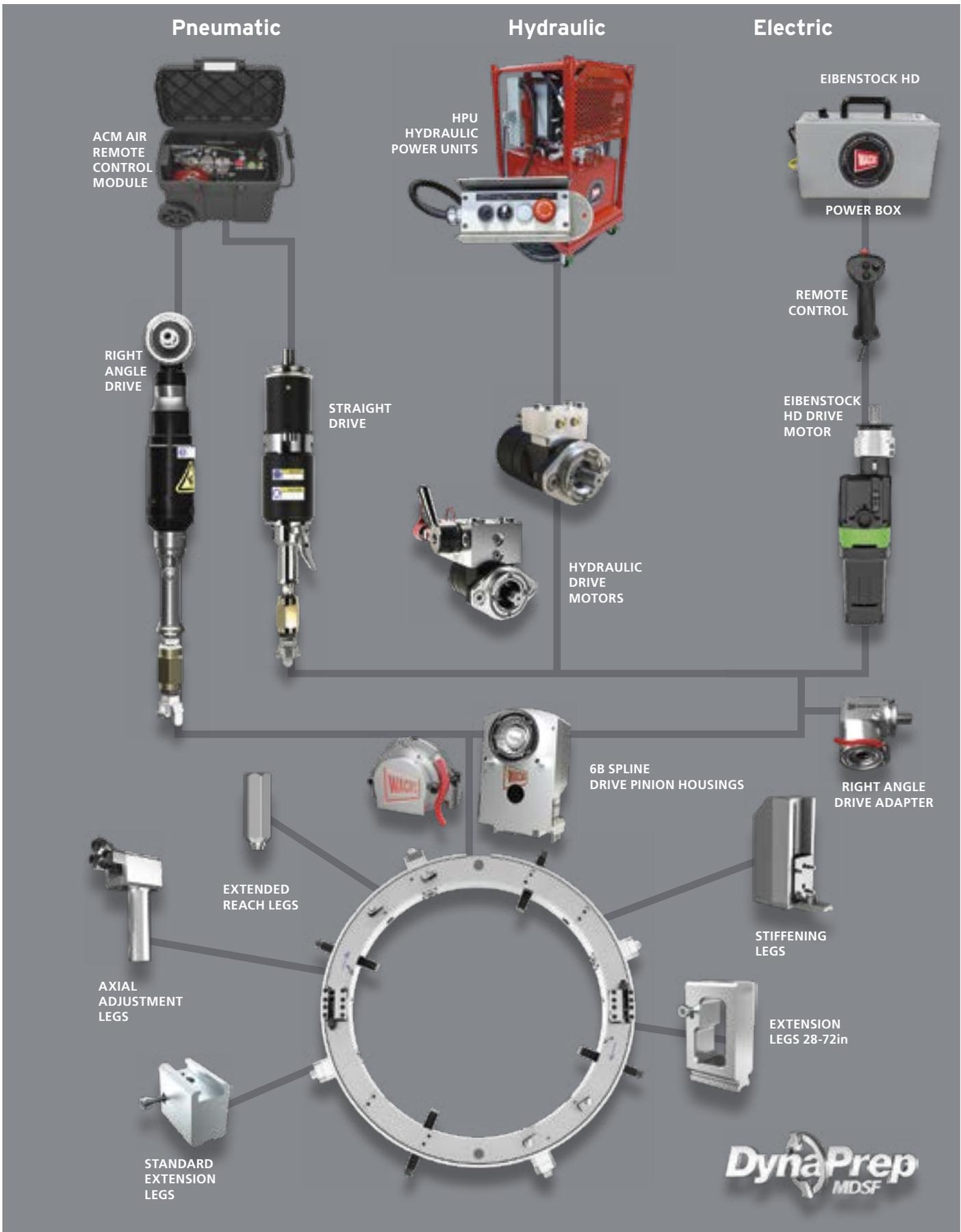


Patent pending V Lock ring mating surfaces are easier to join & stronger

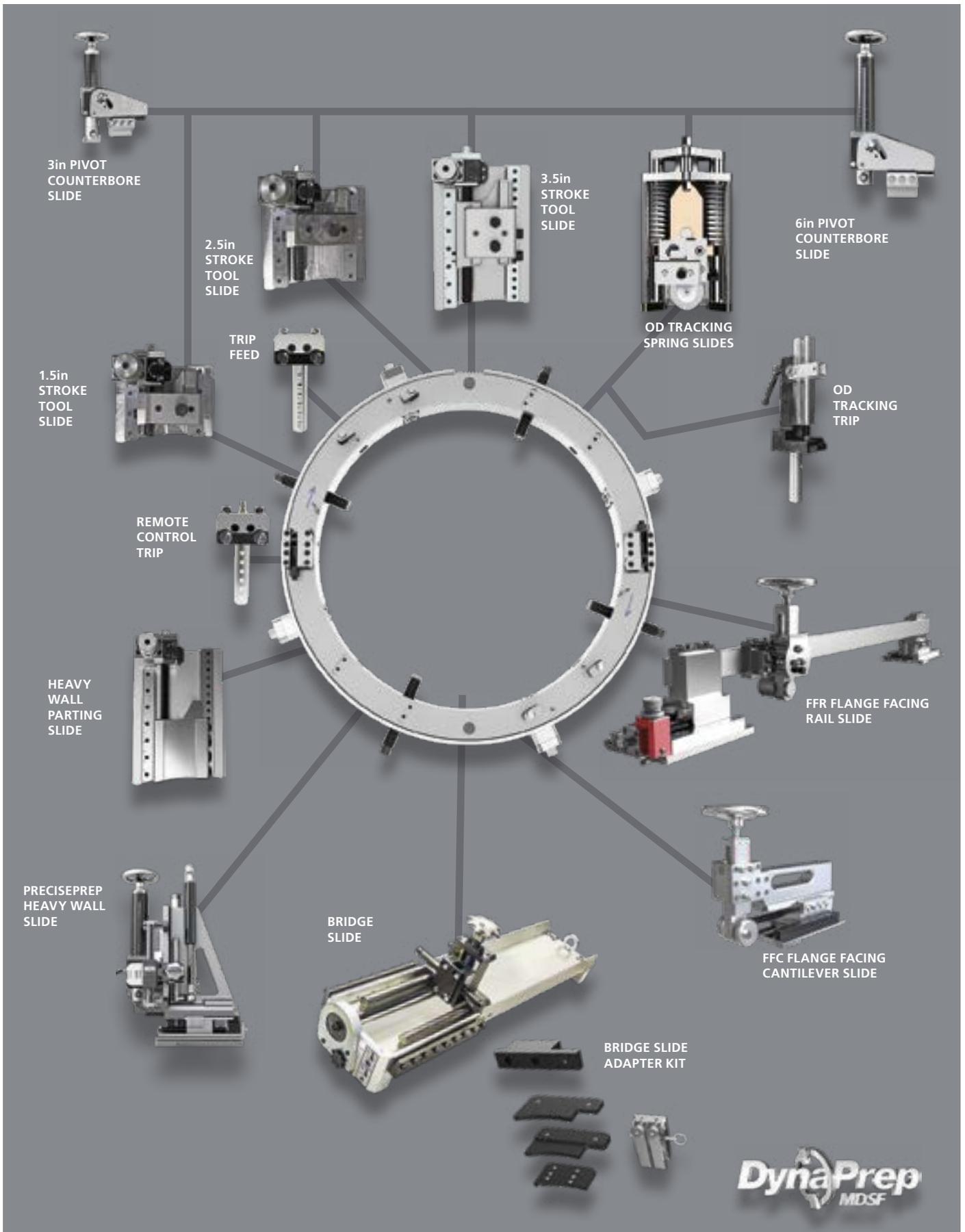


No-time starwheel tool advance is designed to work with the anti-crash trip

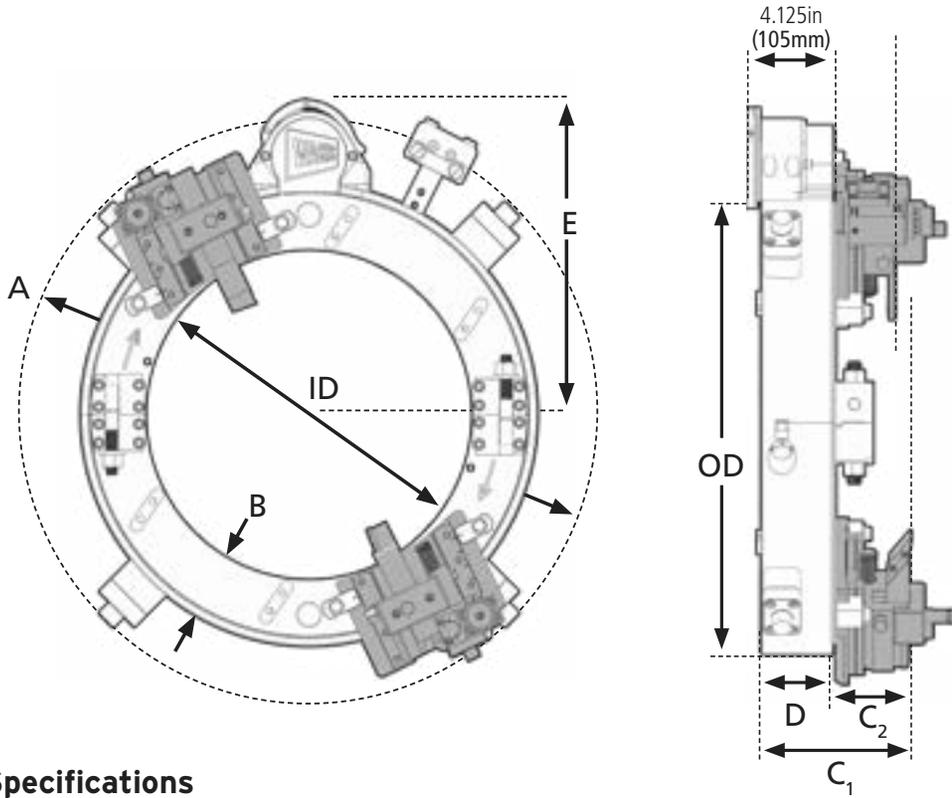
DynaPrep MDSF Split Frame



DynaPrep MDSF Split Frame



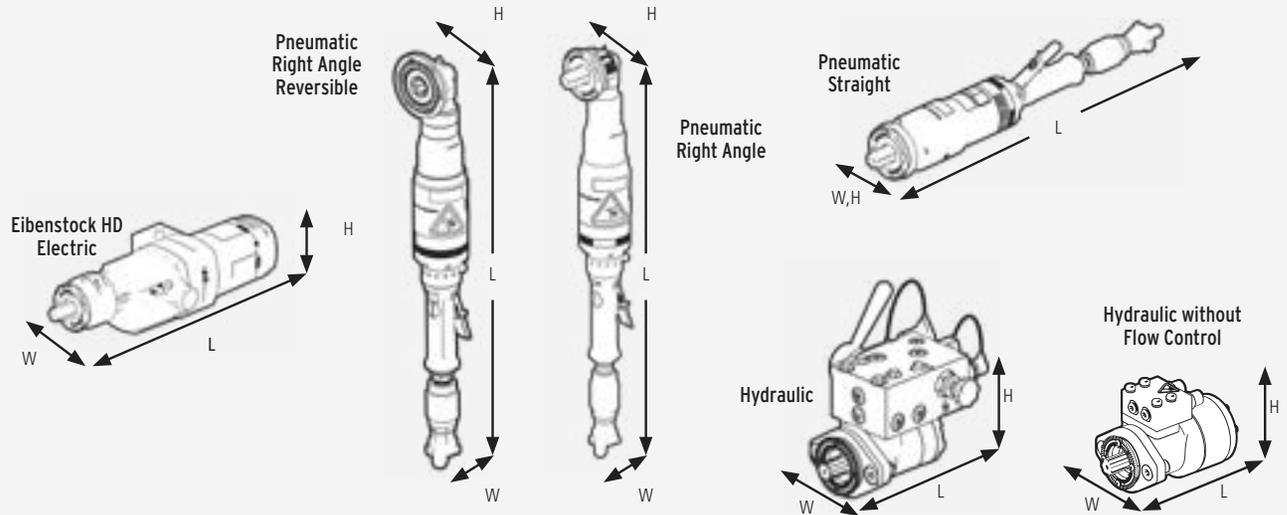
DynaPrep MDSF Specifications



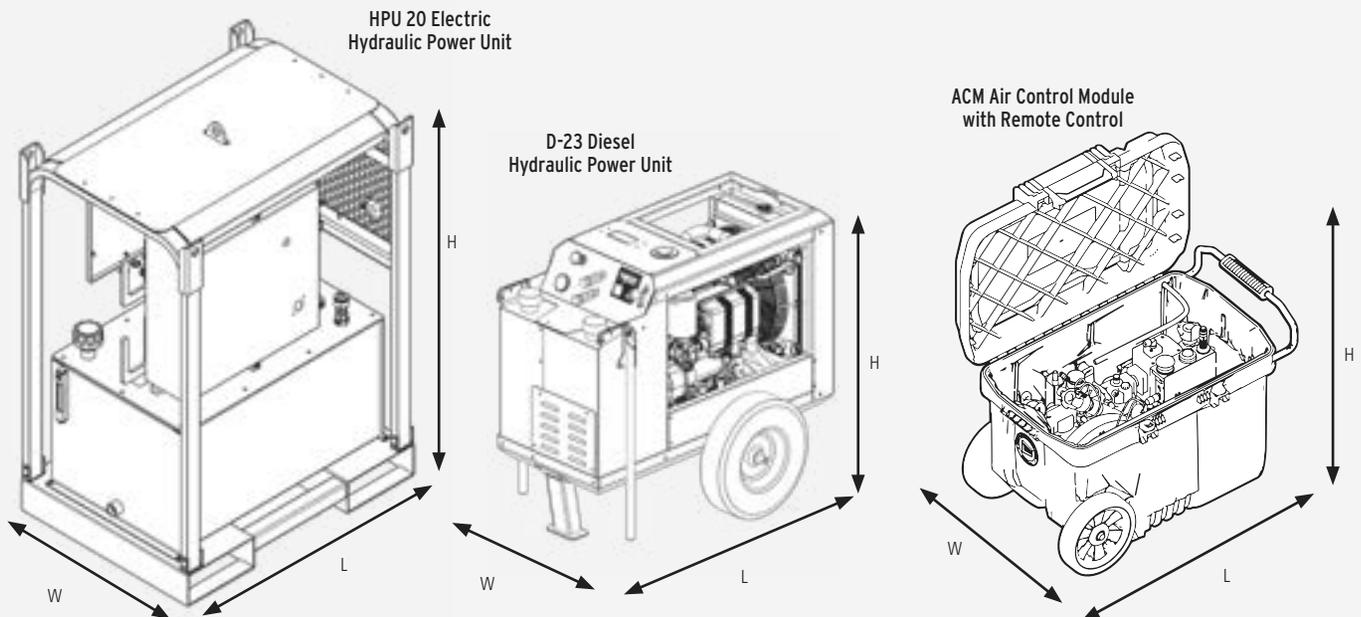
Dimensional Specifications

MODEL	ID	OD	A ROTATING PARTS DIAMETER			B FRAME THICKNESS	MDSF TOOLING		LEGACY TOOLING		D FRAME DEPTH	E PINION RADIUS STANDARD	PRODUCT WEIGHT		
			1.5IN SLIDES	2.5IN SLIDES	3.5IN SLIDES		C ₁ CUT LINE TO REAR	C ₂ CUT LINE TO FRONT	C ₁ CUT LINE TO REAR	C ₂ CUT LINE TO FRONT			HALF RING	FULL RING	RING & 2.5IN SLIDES
206	7.25in (184mm)	12.65in (321mm)	17.86in (454mm)	20.2in (513mm)	/	2.7in (69mm)	5.375in (136.5mm)	5.125in (130.2mm)	3in (76.2mm)	9.49in (241mm)	28lb (12.7kg)	54.5lb (24.7kg)	74.9lb (34kg)		
408	9.25in (235mm)	14.53in (369mm)	19.8in (503mm)	22.16in (563mm)	/	2.64in (67mm)				10.49in (266.4mm)	31lb (14.1kg)	57.5lb (26.1kg)	77.9lb (35.3kg)		
610	11.25in (286mm)	16.5in (419mm)	21.76in (553mm)	24.12in (613mm)	/	2.625in (67mm)				2.375in (60mm)	2.125in (54mm)	11.49in (291.8mm)	37lb (16.8kg)	70lb (31.8kg)	90.4lb (41kg)
612	13.25in (337mm)	18.5in (470mm)	23.74in (603mm)	26.1in (663mm)	32.04in (814mm)							12.49in (317.2mm)	41lb (18.6kg)	77lb (34.9kg)	97.4lb (44.2kg)
814	14.65in (372mm)	19.9in (506mm)	25.16in (639mm)	27.54in (700mm)	33.48in (850mm)							13.19in (335mm)	44lb (20kg)	81lb (36.7kg)	101.4lb (46kg)
1016	16.65in (423mm)	21.95in (558mm)	27.22in (691mm)	29.6in (752mm)	35.54in (903mm)							14.19in (360.4mm)	47lb (21.3kg)	88lb (39.9kg)	108.4lb (49.2kg)
1218	18.65in (474mm)	23.95in (608mm)	29.28in (744mm)	31.66in (804mm)	37.6in (955mm)							15.19in (385.8mm)	52lb (23.6kg)	97lb (44kg)	117.4lb (53.3kg)
1420	20.65in (525mm)	25.95in (659mm)	31.3in (795mm)	33.68in (856mm)	39.64in (1007mm)							16.19in (411.2mm)	54lb (24.5kg)	103lb (46.7kg)	123.4lb (56kg)
1824	25.05in (636mm)	30.35in (771mm)	35.78in (909mm)	38.16in (969mm)	44.14in (1121mm)							18.39in (467.1mm)	60.5lb (27.4kg)	116.5lb (52.8kg)	136.9lb (62.1kg)
2228	29.05in (738mm)	35.55in (903mm)	39.94in (1015mm)	42.32in (1075mm)	48.3in (1227mm)							2.65in (67mm)	5.625in (142.9mm)	5.375in (136.5mm)	20.99in (533.1mm)
2632	33.05in (840mm)	39.55in (1005mm)	43.92in (1116mm)	46.3in (1176mm)	52.28in (1328mm)		22.99in (583.9mm)	101lb (45.8kg)	191.5lb (86.9kg)						211.9lb (96.1kg)
3036	37.65in (956mm)	44.15in (1121mm)	48.56in (1233mm)	50.94in (1294mm)	56.94in (1446mm)		25.29in (642.4mm)	115lb (52.2kg)	218lb (98.9kg)						238.4lb (108.1kg)
3642	43.65in (1109mm)	50.15in (1274mm)	54.54in (1385mm)	56.94in (1446mm)	62.92in (1598mm)	28.29in (718.6mm)	127lb (57.6kg)	246lb (111.6kg)	266.4lb (120.8kg)						
4248	49.65in (1261mm)	56.15in (1426mm)	60.52in (1537mm)	62.92in (1598mm)	68.9in (1750mm)	31.29in (794.8mm)	139.5lb (63.3kg)	271lb (122.9kg)	291.4lb (132.2kg)						
4854	56.05in (1424mm)	63.75in (1619mm)	66.9in (1699mm)	69.3in (1760mm)	75.3in (1913mm)	34.99in (888.7mm)	174lb (78.9kg)	344lb (156kg)	364.4lb (165.3kg)						
5460	62.05in (1576mm)	69.75in (1772mm)	72.9in (1852mm)	75.3in (1913mm)	81.28in (2065mm)	38.99in (990.3mm)	190lb (86.2kg)	375lb (170.1kg)	395.4lb (179.4kg)						

DynaPrep MDSF Specifications



MODEL	(L) LENGTH	(W) WIDTH	(H) HEIGHT
Eibenstock HD Electric	18.7in (475mm)	10in (254mm)	6.2in (157mm)
Pneumatic Right Angle	24in (609mm)	3.23in (82mm)	3.29in (84mm)
Pneumatic Straight	22.32in (567mm)	3.5in (89mm)	3.5in (89mm)
Pneumatic Right Angle Reversible	25.89in (658mm)	3.84in (98mm)	3.29in (84mm)
Hydraulic Drive with Flow Control	10.87in (276mm)	7.96in (202.3mm)	6.98in (177mm)
Hydraulic Drive without Flow Control	8.83in (224mm)	5.27in (134mm)	5.87in (148mm)
ACM Air Control Module with Remote Control	24.5in (622mm)	16.0in (406mm)	16.5in (419mm)
D-23 Diesel Hydraulic Power Unit	39in (99cm)	29in (73.7cm)	36.5in (93cm)
HPU 20 Electric Hydraulic Power Unit	46.5in (104cm)	21in (53.3cm)	28in (71cm)



DynaPrep MDSF Base Kits

Simplified Ordering

The DynaPrep MDSF Base Kit includes most commonly specified components, just add a drive motor and tooling. Less expensive and easier than ordering components ala carte, these base model MDSF Kits are ideal where multiple ring sizes are required onsite. Highly upgradeable, these kits feature 1.5in stroke tool slides on sizes up to 10in, 2.5in stroke tool slides on sizes up to 48in, and 3.5in stroke tool slides on the larger ring sizes. All machines in this group offer a large range of optional tool slides.

All E.H. Wachs drives feature our tool-less quick mount system with positive face gear engagement. As part of a complete machining system, the modular design of the MDSF allows different modules to extend its capabilities to include multiple applications such as flange facing, casing cutting, trepanning, and deep counterboring. Like all E.H. Wachs split frames it comes complete with a heavy duty storage case to protect your machine tool investment.

Each Kit Includes

- Rotating Ring & Drive Pinion Set
- Tool Slide sets:
 - Rapid Adjust 1.5in Stroke (2-10in)
 - Rapid Adjust 2.5in Stroke (12-48in)
 - Rapid Adjust 3.5in Stroke (54-72in)
- Indexing Trip Assembly
- Spare Fastener Kit
- Operating Hand Tools
- Storage Case
- Operating Manual



DynaPrep MDSF Kit with pneumatic straight drive motor



Base Kits come complete, just add drive motor and tooling



DynaPrep MDSF Kit in standard shipping / storage case

MDSF BASE KITS	OPERATING RANGE	CLAMPING RANGE	OPERATING WEIGHT	PART #
Model 206	2-6in (51-152mm)	1.36-7.21in (35-183mm)	54.5 lb (24.7 kg)	69-5400-06
Model 408	4-8in (102-203mm)	1.67-9.21in (42-234mm)	57.5 lb (26.1 kg)	69-5400-08
Model 610	6-10in (152-254mm)	3.63-11.20in (92-284mm)	70 lb (31.8 kg)	69-5400-10
Model 612	6-12in (152-305mm)	5.6-13.2in (142-335mm)	77 lb (34.9 kg)	69-5400-12
Model 814	8-14in (203-356mm)	7-14.59in (178-371mm)	81 lb (36.7 kg)	69-5400-14
Model 1016	10-16in (254-406mm)	9-16.59in (229-421mm)	88 lb (40 kg)	69-5400-16
Model 1218	12-18in (305-457mm)	10.99-18.59in (279-472mm)	97 lb (44 kg)	69-5400-18
Model 1420	14-20in (356-508mm)	12.99-20.59in (330-523mm)	103 lb (46.7 kg)	69-5400-20
Model 1824	18-24in (457-610mm)	17.39-24.99in (442-635mm)	116 lb (52.8 kg)	69-5400-24
Model 2228	22-28in (559-711mm)	21.4-29in (544-737mm)	174.5 lb (79.2 kg)	69-5400-28
Model 2632	26-32in (660-813mm)	25.4-32.99in (645-838mm)	191.5 lb (86.9 kg)	69-5400-32
Model 3036	30-36in (762-914mm)	29.99-37.59in (762-955mm)	218 lb (98.9 kg)	69-5400-36
Model 3642	36-42in (914-1067mm)	35.99-43.59in (914-1107mm)	246 lb (111.6 kg)	69-5400-42
Model 4248	42-48in (1067-1219mm)	41.99-49.59in (1067-1260mm)	271 lb (122.9 kg)	69-5400-48
Model 4854	48-54in (1219-1372mm)	40.39-55.99in (1026-1422mm)	344 lb (156 kg)	69-5400-54
Model 5460	54-60in (1372-1524mm)	46.39-61.99in (1178-1575mm)	375 lb (170.1 kg)	69-5400-60
Model 6066*	60-66in (1524-1676mm)	CALL	CALL	69-5400-66
Model 6672*	66-72in (1676-1829mm)	CALL	CALL	69-5400-72

*CALL FOR AVAILABILITY

DynaPrep MDSF Pipeline Base Kits

Pipeline Base Kits

DynaPrep MDSF Pipeline Base Kits are configured with the components typically specified in pipeline MRO operations. Large diameter thin wall pipe used in pipelines tend to be out-of-round, which makes precision weld preps with standard tool slides problematic. Wachs included out-of-round spring tool slides track the outside of the pipe to maintain a perfect land and prep. These slides allow a 12in operating range.

These kits are complete, just add a drive motor and tooling. They are perfect for most pipeline applications, with an optional right angle drive available. Like all DynaPrep MDSF machines, their modular design means a machine configured for pipeline projects can be reconfigured for multiple applications, including deep counterboring and flange facing, making them highly versatile machines. These and all DynaPrep machines and accessories are available for purchase or rental at a regional Sales, Service and Rental Center near you.

Each Kit Includes

- Rotating Ring & Drive Pinion Set
- OD Tracking Tool Slide Set
- Manual Trip Assembly
- Extended Reach Reinforcement Legs (INCLUDED WITH SOME RING SIZES.)
- Spare Fastener Kit
- Operating Hand Tools
- Storage Case
- Operating Manual

MDSF PIPELINE BASE KITS	OPERATING RANGE	CLAMPING RANGE	OPERATING WEIGHT	PART #
Model 612	6-12in (152-305mm)	5.6-13.2in (142-335mm)	77 lb (34.9 kg)	69-5405-12
Model 814	8-14in (203-356mm)	7-14.59in (178-371mm)	81 lb (36.7 kg)	69-5405-14
Model 1016	10-16in (254-406mm)	9-16.59in (229-421mm)	88 lb (40 kg)	69-5405-16
Model 1218	12-18in (305-457mm)	10.99-18.59in (279-472mm)	97 lb (44 kg)	69-5405-18
Model 1420	14-20in (356-508mm)	12.99-20.59in (330-523mm)	103 lb (46.7 kg)	69-5405-20
Model 1824	18-24in (457-610mm)	17.39-24.99in (442-635mm)	116 lb (52.8 kg)	69-5410-24
Model 2228	22-28in (559-711mm)	21.4-29in (544-737mm)	174.5 lb (79.2 kg)	69-5410-28
Model 2632	26-32in (660-813mm)	25.4-32.99in (645-838mm)	191.5 lb (86.9 kg)	69-5410-32
Model 3036	30-36in (762-914mm)	29.99-37.59in (762-955mm)	218 lb (98.9 kg)	69-5410-36
Model 3642	36-42in (914-1067mm)	35.99-43.59in (914-1107mm)	246 lb (111.6 kg)	69-5410-42
Model 4248	42-48in (1067-1219mm)	41.99-49.59in (1067-1260mm)	271 lb (122.9 kg)	69-5410-48
Model 4854	48-54in (1219-1372mm)	40.39-55.99in (1026-1422mm)	344 lb (156 kg)	69-5410-54
Model 5460	54-60in (1372-1524mm)	46.39-61.99in (1178-1575mm)	375 lb (170.1 kg)	69-5410-60
Model 6066*	60-66in (1524-1676mm)	CALL	CALL	69-5410-66
Model 6672*	66-72in (1676-1829mm)	CALL	CALL	69-5410-72

* CALL FOR AVAILABILITY.



DynaPrep MDSF Pipeline are specially configured for MRO on thin wall, large diameter pipe



Available in sizes for 6-72in (152-1829mm) pipe



OD tracking slides follow out-of-round pipe & vessels.

DynaPrep MDSF Flange Facing

FFC Flange Facing Cantilever Module

E.H. Wachs new FFC flange facing is ideal where an MDSF is already onsite for pipe cutting and beveling. This kit adds counterboring capabilities and advanced flange facing and record grooving capabilities without the need for heavy and expensive dedicated facers.

The FFC module is used on flat face, raised face and applications where the FFR rail will not work, such as heat exchangers. It will machine 500 RMS, 250 RMS, 125 RMS and 63 RMS record groove finishes, plus machining of the smooth bolt face finish. Setting up the DynaPrep for flange facing is fast and easy with its new patent pending Axially Adjustable Legs featuring removable guides to quickly square the machine to the bolt face. Two FFC modules will simultaneously machine multiple surfaces in a single pass (as shown).

Specifications

- FFC uses the DynaPrep MDSF as the machining platform
- Radial auto feed crashproof starwheel
- Radial feed rate in inches per revolution .003-.048in
- Axial feed rate in inches per revolution manually variable .001-.025in with 2in of axial travel
- Optional remote trip actuation

FFC Kit Includes

- FFC module
- MDSF heavy wall tool slide
- Counterweight & holder
- Two trips
- Trip extensions
- Axial adjustable legs
- Magnetic base dial indicator set
- Complete starter tooling kit
- Heavy duty storage case
- Optional remote trip actuation

FRAME SIZE	MOUNTING Ø MAX	MOUNTING Ø MIN	ID REACH FFC	PART #
6-12in (152-305mm)	10.7in (272mm)	3.3in (84mm)	Full Reach	69-5260-00
8-14in (203-356mm)	11.9in (302mm)	4.6in (117mm)	Full Reach	
10-16in (254-406mm)	13.9in (353mm)	6.6in (168mm)	Full Reach	
14-20in (356-508mm)	17.9in (455mm)	10.6in (269mm)	Full Reach	
18-24in (457-610mm)	22.2in (564mm)	15.1in (384mm)	Full Reach	
22-28in (559-711mm)	26.2in (665mm)	19.1in (485mm)	13.6in (345mm)	
26-32in (660-813mm)	30.2in (767mm)	23.1in (587mm)	13.6in (345mm)	
30-36in (762-914mm)	34.4in (874mm)	27.6in (701mm)	13.6in (345mm)	
36-42in (914-1067mm)	40.4in (1026mm)	33.6in (853mm)	13.6in (345mm)	
42-48in (1067-1219mm)	46.4in (1179mm)	39.6in (1006mm)	13.6in (345mm)	
48-54in (1219-1372mm)	52.4in (1331mm)	45.6in (1158mm)	13in (330mm)	
54-60in (1372-1524mm)	58.4in (1483mm)	51.6in (1311mm)	13in (330mm)	
60-66in (1524-1676mm)	64.4in (1636mm)	57.6in (1463mm)	13in (330mm)	
66-72in (1676-1829mm)	70.4in (1788mm)	63.6in (1615mm)	13in (330mm)	



FFC Flange Facing Cantilever Module



FFC reaches up to 13.6in (345mm) in certain configurations.



Compact, the FFC can face flanges in any position or orientation



Two FFC modules simultaneously machine bolt face & record groove

DynaPrep MDSF Flange Facing

FFR Flange Facing Rail Module

The FFR module for flat face, raised face, and RTJ grooved flanges, machines 500 RMS, 250 RMS, 125 RMS and 63 RMS record groove finishes, plus it can machine the smooth bolt face finish and counterbore. The rail module is also adjustable in multiple axes to machine RTJ ring grooves.

Setting up the DynaPrep for FF flange facing is fast and easy with axially adjustable legs that feature removable guides to quickly square the machine to the bolt face. A single FFR module can machine the bolt face and record groove in two operations, or optionally two modules can be used to simultaneously machine multiple surfaces in a single pass (as shown) or machine RTJ grooves.

Specifications

- Uses the DynaPrep MDSF as the machining platform
- Full range machining from 0-72in (module specific)
- Radial feed rate inches per revolution .003-.048in
- Radial auto feed crashproof starwheel
- Radial travel 3.5-72in; kit dependent
- Axial feed rate in inches per revolution manually variable .001-.025in with 2in of axial travel
- Optional auto axial feed and remote trip actuation

FFR Kit Includes

- FFR module
- MDSF heavy wall tool slide
- MDSF slave slide
- FFR rail mounts
- 2 additional trips with trip extensions
- Axial adjustable legs
- Magnetic base dial indicator set
- Complete starter tooling kit
- Heavy duty storage cases

FRAME SIZE	MOUNTING Ø MAX	MOUNTING Ø MIN	ID REACH FFR	PART #
6-12in (152-305mm)	10.7in (272mm)	3.3in (84mm)	Full Reach	69-5270-16
8-14in (203-356mm)	11.9in (302mm)	4.6in (117mm)	Full Reach	
10-16in (254-406mm)	13.9in (353mm)	6.6in (168mm)	Full Reach	
14-20in (356-508mm)	17.9in (455mm)	10.6in (269mm)	Full Reach	69-5270-20
18-24in (457-610mm)	22.2in (564mm)	15.1in (384mm)	Full Reach	69-5270-28
22-28in (559-711mm)	26.2in (665mm)	19.1in (485mm)	Full Reach	
26-32in (660-813mm)	30.2in (767mm)	23.1in (587mm)	Full Reach	69-5270-36
30-36in (762-914mm)	34.4in (874mm)	27.6in (701mm)	Full Reach	
36-42in (914-1067mm)	40.4in (1026mm)	33.6in (853mm)	Full Reach	69-5270-48
42-48in (1067-1219mm)	46.4in (1179mm)	39.6in (1006mm)	Full Reach	
48-54in (1219-1372mm)	52.4in (1331mm)	45.6in (1158mm)	Full Reach	69-5270-60
54-60in (1372-1524mm)	58.4in (1483mm)	51.6in (1311mm)	Full Reach	
60-66in (1524-1676mm)	64.4in (1636mm)	57.6in (1463mm)	Full Reach	69-5270-72
66-72in (1676-1829mm)	70.4in (1788mm)	63.6in (1615mm)	Full Reach	



FFR Flange Facing Rail Module



Modules are clearly marked to indicate depth and prep angle



FFR tooling can be adjusted on multiple axes



Two FFR modules performing simultaneous operations

DynaPrep MDSF Accessories

DynaPrep MDSF Drive Motors

Wachs offers a wide range of pneumatic, hydraulic and electric drive motor options, offering the power and durability required to drive the MDSF to its full form tooling potential.



Multiple drive options are available for DynaPrep MDSF

DESCRIPTION	PART #
Pneumatic Right Angle Drive Motor w/Speed Control, Chicago Fitting, and ACM Air Control Module	69-5454-00
Pneumatic Right Angle Drive Motor w/Control Handle, Speed Control, Chicago Fitting, and ATM Air Treatment Module	69-5452-00
Pneumatic Right Angle Drive Motor w/Control Handle, Speed Control, Oiler, Filter, and Chicago Fitting	69-5450-00
Pneumatic Straight Drive Motor w/Speed Control, Chicago Fitting, and ACM Air Control Module	69-5455-00
Pneumatic Straight Drive Motor w/Control Handle, Speed Control, Chicago Fitting, and ATM Air Treatment Module	69-5453-00
Pneumatic Straight Drive Motor w/Control Handle, Speed Control, Oiler, Filter, and Chicago Fitting	69-5451-00
Right Angle Adapter for Pneumatic Straight Drive Motors	69-4359-00
Pneumatic Reversible Right Angle Drive Motor w/Handle	69-4353-01
Universal Hydraulic Drive Motor with Flow control	69-4358-00
Universal Hydraulic Drive Motor without Flow Control	69-4363-01
Eibenstock HD Electric Drive-110V, MDSF	69-4340-00
Eibenstock HD Electric Drive-220V, MDSF	69-4341-00
Eibenstock HD Electric Drive-110V w/remote pendant (requires controller)	69-4342-00
Eibenstock HD Electric Drive-220V w/remote pendant (requires controller)	69-4343-00
Eibenstock HD 110v w/remote pendant, electric remote trip, controller	69-4344-00
Eibenstock HD 220v w/remote pendant, electric remote trip, controller	69-4345-00
Eibenstock Drill-style Electric Drive Assembly-110V	SPG-489-4110
Eibenstock Drill-style Electric Drive Assembly-220V	SPG-489-4220



DynaPrep MDSF Tool-Free 6B Spline Drive Pinion

DynaPrep MDSF Pinion Drive

Advanced heavy duty 6B splined pinion drives are responsible for applying power with their stronger, heat treated gear sets.



Dual pin trip design eliminates starwheel timing

DESCRIPTION	MOUNT	PART #
1/2in Female to 6b Spline Male Adapter	1/2in (12.7mm) Square	69-3037-00
Spline Drive Pinion Standard (Tool Free)	6B Spline	69-4484-00
Spline Drive Pinion Front Drive (Tool Free)		69-4481-01

DynaPrep MDSF Trip Feed

Advanced dual pin design that eliminates the need to time the starwheel prevents crashes and is engineered to accommodate optional pneumatic and electric powered remote trip control.



Pneumatic Trip assembly for remote operation

DESCRIPTION	PART #
Manual Trip (Post sold separately)	69-3018-00
Pneumatic Trip (Post sold separately)	69-4741-00
Electric Trip (Post sold separately)	69-3084-00
Trip Bar/Post Positioning 6-24in (For 1.5in and 2.5in slides)	69-0071-00
Trip Bar/Post Positioning 28-60in (For 1.5in and 2.5in slides)	69-0232-00
Trip extension Adapter for (3.50in slide assembly)	69-3019-00
Trip Assembly, OD Tracking 12-60in	69-4744-01
Dual Trip Assembly. Required when Flange Facing with Bridge Slide	69-3046-00

DynaPrep MDSF Accessories

DynaPrep MDSF Tool Slide Options

Groundbreaking design with multiple features including Rapid Adjust & Micro Adjust tool depth, MDSF tool slides are available in standard and high feed models plus dedicated standard and deep counterboring slides.

DESCRIPTION	INCLUDES	PART #
Low Clearance Cutting & Beveling Worm Slide Kit* .003in Feed & 1.5in Stroke	(2) 69-4615-03 Slides Double Bevel Cover	69-5215-03
Standard Cutting & Beveling Worm Slide Kit* .003in Feed & 2.5in Stroke	(2) 69-4625-03 Slides Double Bevel Cover	69-5225-03
Extended Cutting & Beveling Worm Slide Kit* .003in Feed & 3.5in Stroke.	69-3019-00 trip extension (2) 69-4655-03 Slides Double Bevel Cover	69-5255-03
Low Clearance Cutting & Beveling Worm Slide Kit* .006in Feed & 1.5in Stroke.	(2) 69-4615-06 Slides Double Bevel Cover	69-5215-06
Standard Cutting & Beveling Worm Slide Kit* .006in Feed & 2.5in Stroke	(2) 69-4625-06 Slides Double Bevel Cover	69-5225-06
Extended Cutting & Beveling Worm Slide Kit* .006in Feed & 3.5in Stroke	69-3019-00 trip extension (2) 69-4655-06 Slides Double Bevel Cover	69-5255-06
OD Tracking Slide Kit 12-60in	(2) 69-4604-02 Slides (1) 69-4744-01 Spring Trip 54-60in Extension Leg Sets Storage Case, Toe Clamps, Hand Tools	69-5204-01
Deep Counter Bore Slide Assembly. 3in Depth.		69-4605-00
Deep Counter Bore Slide Assembly. 6in Depth.		69-4606-00
Heavy Wall Parting Slide Kit .003in Feed & 3.50in Stroke	Parting Slide & Trip Adapter	69-5235-03
Heavy Wall Parting Slide Kit .006in Feed & 3.50in Stroke	Parting Slide & Trip Adapter	69-5235-06

*TRIP NOT INCLUDED

DynaPrep MDSF Miscellaneous Accessories

Perform casing cutting and more with the line of DynaPrep MDSF Accessories.

DESCRIPTION	PART #
Axial Adjustment Legs with Removable Shoulders	69-4807-00
Casing Cutter, Internal/External 7-13in	69-4810-00
Dial Indicator Set	69-3082-00
Button Leg Pad Set	69-4802-00
Extension Leg Assembly (Single Leg)	69-4800-00
Extension Leg Assembly, 54-60in (Single Leg)	69-4801-00

Air Treatment & Air Control Modules

ATM Air Treatment Modules condition and regulate the incoming air to extend motor life. ACM Air Control Module adds remote control capability plus air treatment.

DESCRIPTION	PART #
ATM Air Treatment Module with Shipping Case (non-CE compliant) SUPERSEDES P/N (26-407-00). REQUIRED FOR USE WITH "CONTROL HANDLE" AIR MOTORS ONLY.	69-4102-01
ACM Air Control Module & Remote Trip Kit (CE Compliant) REQUIRED FOR "NO CONTROL HANDLE" AIR MOTORS	69-4100-00
ACM Air Control Remote REQUIRED FOR USE WITH "NO CONTROL HANDLE" AIR MOTORS	69-4101-01

DynaPrep MDSF Pneumatic Meter-Out Kits

Controls (meter) the exhaust (out) flow to yield higher torque, low rpm operation. Used where extra torque and precise speed control at slow speeds is required. Includes exhaust manifold, speed control and muffler.

DESCRIPTION	PART #
Meter-Out Adapter Kit	69-4366-00



DynaPrep MDSF 2.5in Stroke Slide



DynaPrep MDSF OD Tracking Slide for out-of-round pipe



ACM Air Treatment & Remote Control Module



Meter-Out Adapter Kit

DynaPrep MDSF Accessories

DynaPrep MDSF Modules & Templates

For single point beveling applications, counterboring, and flange facing.
(MDSF requires 69-5300-00 Adapter)

DESCRIPTION	PART #
PrecisePrep Tool Slide for Single Pointing and Heavy Wall Counterbore	CALL
Bridge Slide for SF 612, SF 814*	60-428-14
Bridge Slide for SF 612, SF 814, SF 1016*	60-428-16
Bridge Slide for SF 612, SF 814, SF 1016, SF 1218, SF 1420*	60-428-20
Bridge Slide for SF 1218, SF 1420, SF 1824*	60-428-24
Bridge Slide for SF 1824, SF 2228*	60-428-28
Bridge Slide for SF 2228, SF 2632*	60-428-32
Bridge Slide for SF 2632, SF 3036*	60-428-36
Bridge Slide for SF 3642*	60-428-42
Bridge Slide for SF 3642, SF 4248*	60-428-48
MDSF Bridge Slide Adapter Kit	69-5300-00
37.5° Bridge Slide Template	53-409-02
30° Bridge Slide Template	53-409-03
20° Bridge Slide Template	53-409-05
10° X 37.5° Bridge Slide Template	53-409-11
10° X 30° Bridge Slide Template	53-409-12
10° X 20° Bridge Slide Template	53-409-13

*REQUIRES MDSF ADAPTER KIT, ORDERED SEPARATELY.

DynaPrep MDSF Tooling

DESCRIPTION	PART #
HSS Standard 3/8 x 3/8in Tool Bit for Single Point Facing, Beveling, Socket Weld Removal & Flange Facing. For use with SDB 206/412, EP 424, FF, SWR & SDSF Machines. (2-PIECE MINIMUM ORDER)	52-701-01
Premium coated HSS 3/8 x 3/8in Tool Bit for Single Point Facing, Beveling, Socket Weld Removal & Flange Facing. For use with SDB 206/412, EP 424, FF, SWR & SDSF Machines. (2-PIECE MINIMUM ORDER)	52-701-01P
Single Point Tool Holder Kit for Facing & Beveling. UTILIZES P/N 81-701-XX HSS & 81-703-XX CARBIDE TOOL INSERTS	60-718-00
Single Point Tool Insert (HSS)	81-701-01
Single Point Tool Insert, 10-Pack (HSS)	81-701-10
Single Point Tool Insert (Carbide)	81-703-01
Single Point Tool Insert, 10-Pack (Carbide)	81-703-10
Premium Coated Single Point Tool Insert (HSS)	81-701-00P
Premium Coated Single Point Tool Insert, 10-Pack (Coated HSS)	81-701-10P
HSS 4:1 Taper Counterbore Tool; also for use with EP 424 machines. (2-PIECE MINIMUM ORDER)	60-700-04
HSS .094in (3/32in) Radiusing "J" Tool Insert for J-Prep	81-704-01
HSS .125in (1/8in) Radiusing "J" Tool Insert for J-Prep	81-705-01
HSS .188in (3/16in) Radiusing "J" Tool Insert for J-Prep	81-706-01
HSS 6mm Radiusing "J" Tool Insert for J-Prep	81-707-01



PrecisePrep Heavy Wall Slide



Bridge Slide with Adapter Kit for MDSF



Single Point Tooling
available in 10 packs



HSS DuoEdge Single Point
Tooling Insert

DynaPrep MDSF Tooling

DynaPrep MDSF Tooling

HSS blades, carbide tool insert holders & carbide inserts for straight cut-off

DESCRIPTION		PART #
HSS 3/16in Wide Parting Blade (3- 7/16in Long)		43-711-00
HSS 3/16in Wide Parting Blade (5in Long)		43-711-01
HSS 3/16in Wide Parting Blade (5in Long, T-15)		69-7111-01
HSS 1/4in Wide Parting Blade (6in Long)		60-711-00
HSS 1/4in Wide Parting Blade (6in Long, T-15)		69-7111-00
3/16in Carbide Parting Tool Kit	Holder, Extractor, (1) 60-717-00 Tool Insert	60-716-00
3/16in Carbide Tool Insert for Parting		60-717-00
1/4in Carbide Parting Tool Kit	Holder, Extractor, (1) 60-715-00 Tool Insert	60-714-00
1/4in Carbide Tool Insert for Parting		60-715-00
Heavy Wall Carbide Insert Tooling Kit	Holder, Extractor, (1) (60-713-00) .313in Insert	60-712-00
Carbide Cutting Tool Insert, .313in wide USED WITH 60-712-00 TOOL INSERT HOLDER KIT. (2-PIECE MINIMUM ORDER)		60-713-00
.314 Heavy Wall Carbide Tooling Kit.	10in Holder (69-7012-01), .314in wide Tool Insert (69-7013-00), & Extractor (60-712-02)	69-7012-00
Tool Insert, .314 Wide		69-7013-00
Tool Insert, 10-Pack .314 Wide Heavy Wall		69-7013-10
.374 Heavy Wall Carbide Tooling Kit	10in Holder (69-7012-01), .374in wide Tool Insert (69-7014-00), & Extractor (60-712-02)	69-7112-00
Tool Insert, .374 Wide		69-7014-00
Tool Insert, 10-Pack .374 Wide Heavy Wall		69-7014-10
DuoEdge HSS Tool Insert 10-Pack		81-701-10
DuoEdge Carbide Tool Insert 10-Pack		81-703-10
DuoEdge Triple Point Tool Insert		56-710-00

CONSULT THE FACTORY FOR OTHER APPLICATIONS OR CUSTOM TOOLING.

Bevel, Counterbore & Flange Facing Tooling Kits

(Each kit includes insert holder, insert screws, wrench, & storage container)

DESCRIPTION	PART #
Tool Holder Kit, 37.5° Inside Bevel	69-7000-00
Tool Holder Kit, 37.5° Outside Bevel	69-7001-00
Tool Holder Kit, 30° Inside Bevel	69-7019-00
Tool Holder Kit, 30° Outside Bevel	69-7029-00
Tool Holder Kit, 10 x 37.5° Compound Inside Bevel UTILIZES 69-7008-02 TOOL INSERT	69-7008-01
Tool Holder Kit, 10 x 37.5° Compound Outside Bevel UTILIZES 69-7009-02 TOOL INSERT	69-7009-01
Tool Holder Kit, 10-30° Compound Inside Bevel	69-7020-01
Tool Holder Kit, 4:1 Taper Counterbore UTILIZES 81-701-XX HSS & 81-703-XX CARBIDE TOOL INSERTS	69-7007-00
Tool Holder Kit, 30° Single Point Counterbore UTILIZES 81-701-XX HSS & 81-703-XX CARBIDE TOOL INSERTS	69-7007-01
Single Point Tool Holder Kit for Facing & Beveling UTILIZES P/N 81-701-XX HSS & 81-703-XX CARBIDE TOOL INSERTS	60-718-00
Tool Holder Kit, Flange Facing. UTILIZES 56-710-00 TOOL INSERT	69-7010-00
Tool Holder Kit, Counterbore.	60-708-00
DuoEdge J-prep Bevel Tool Insert	81-707-01



HSS 1/4in Wide Parting Blade



DuoEdge 30° Inside Bevel
Tool Holder & Tool



DuoEdge Triple Point Insert



DuoEdge 37.5° Outside Bevel
Tool Holder & Tool

Bevel, Counterbore & Flange Facing Inserts

DESCRIPTION	PART #
Tool Insert for 30 & 37.5° Inside Bevel	69-7006-00
Tool Insert for 30 & 37.5° Outside Bevel	69-7011-00
Tool Insert for 10 x 37.5° Inside Compound Bevel	69-7008-02
Tool Insert for 10 x 37.5° Outside Compound Bevel	69-7009-02
Tool Insert, 10° x 30° Inside Comp. Bevel	69-7020-00
Single Point Tool Insert (HSS)	81-701-01
Single Point Tool Insert, 10-Pack (HSS)	81-701-10
Premium Coated Single Point Tool Insert (HSS)	81-701-00P
Premium Coated Single Point Tool Insert, 10-Pack (Coated HSS)	81-701-10P
Single Point Tool Insert (Carbide)	81-703-01
Single Point Tool Insert, 10-Pack (Carbide)	81-703-10
HSS .094in (3/32in) Radiusing "J" Tool Insert	81-704-01
HSS .125in (1/8in) Radiusing "J" Tool Insert	81-705-01
HSS .188in (3/16in) Radiusing "J" Tool Insert	81-706-01
HSS 6mm Radiusing "J" Tool Insert	81-707-01
HSS Tool Insert for Flange Facing (3 Cutting Tips, High and Low Range)	56-710-00

CONSULT THE FACTORY FOR OTHER APPLICATIONS OR CUSTOM TOOLING.

DynaPrep MDSF Single Bevel Form Tools

DESCRIPTION	PART #
HSS 37.5° Inside Bevel Tool (3 1/8in long)	43-703-05
HSS 37.5° Outside Bevel Tool (3 1/8in long)	43-708-05
HSS 37.5° Double Bevel Tool (3 1/8in long)	43-710-05
HSS 37.5° Inside Bevel Tool (5in long)	53-703-00
HSS 37.5° Inside Bevel Tool (5in long), Premium Coated	53-703-00P
HSS 37.5° Outside Bevel Tool (5in long)	43-708-06
HSS 37.5° Double Bevel Tool (5in Long)	43-710-06
HSS 30° Inside Bevel Tool (3 1/8in long)	43-702-05
HSS 30° Outside Bevel Tool (3 1/8in long)	43-707-05
HSS 30° Double Bevel Tool (3 1/8in long)	43-709-05
HSS 30° Inside Bevel Tool (5in long)	53-703-01
HSS 30° Inside Bevel Tool (5in long). Premium Coated	53-703-01P
HSS 30° Outside Bevel Tool (5in long)	43-707-06
HSS 30° Double Bevel Tool (5in long)	43-709-06
HSS 45° Inside Bevel Tool (5in long)	60-719-00
HSS 45° Outside Bevel Tool (5in long)	60-720-00
HSS 60° Inside Bevel Tool (5in long)	60-719-01
HSS 60° Outside Bevel Tool (5in long)	60-720-01

DynaPrep MDSF Compound Bevel Form Tools

DESCRIPTION	PART #
HSS 10° x 37.5° Inside Bevel Tool (4in Long)	43-712-01
HSS 10° x 37.5° Outside Bevel Tool (4in Long)	43-712-02
HSS 10° x 37.5° Inside Bevel Tool, 5in long	53-705-00
HSS 10° x 30° Inside Bevel Tool, 5in long	53-704-00



DuoEdge Tooling 37.5° Outside Bevel



DuoEdge Compound Bevel Insert



DuoEdge Tooling Single Point Insert



Single Bevel Form Tool



Compound Bevel Form Tool