

- Welding Automations**
- Welding Positioners**
- Welding Rotators**
- Column Boom Systems**
- Portal Welding Lines**
- Special Projects**



Version:
B23.v01

MACHINE CATALOGUE



We are at your service upon tailor-made Projects

Export Countries; Germany, France, England, Poland, Russia, Czechia, Serbia, Egypt, Azerbaijan, Turkmenistan, Spain, Vietnam, kazakhstan, Bulgary, Syria, Macedonia, USA, Colombia, Kuwait, etc,

❖ All technical specifications are subject to change without prior notice.

Who is Birel Machinery ;

- Birel Machinery has been established by Mr.Mehmet Birel in 2014 with 15 years of machining experience and 12 years of welding automation machines production experience.
- It has been the reference of many companies since 2014 and has provided support for machinery and machine engineering in the realization of many special projects.
- She continues its activities on the local market and on the foreign markets by increasing her product range as standard catalog products and special machine manufacturing products in her 1000 m2 factory with a core staff.
- Birel Machinery takes 95 percent of its sales in foreign markets; Especially in Poland, Germany, Italy and France,Bulgaria etc. it mainly exports its products to European countries and many world countries by increasing its sales by reaching dealers channel and end users.
- In our targeted future plan, it is our first goal to place Birel Machinery among the leading companies in the World considered as solution partners in welding automation machines



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Section-A: Brief Overview of Welding Positioner Models Range;

A01- Mini-Stationary Types

Mini-BCP050-2AX



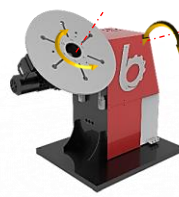
Mini Conv. Positioner-50 kg.

Mini-BCP010-2AX



Mini Conv. Positioner 100 kg.

Mini-BCP020-2AX



Mini-Conv. Positioner 200 kg.

Mini-BTT005-2AX



Mini-Turn Table 50 kg.

Mini-BCP010-5A



Mini-Turn Table 100 kg.
Semi-Automatic

A02 - Standard Stationary Types

BCP-2AX



Conventional Positioner

BHP-3AX



Hydraulic Elevating Positioner

BTT-1AX



Turn Table Positioner

A03 - L-Types

BLP-2AX



L-Type Positioner 2 Axis

BLPL-3AX



Light Duty L-Type Positioner 3 Axis

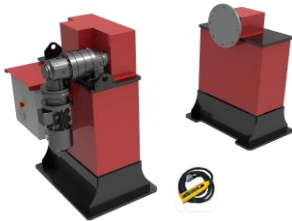
BLP-3AX

Heavy Duty L-Type Positioner 3 Axis



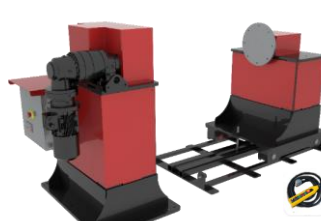
A04 - Head-Tail Stock Types

BEMS-1AX



Head-Tail Stock Positioner 1 Axis

BEMG-1AX



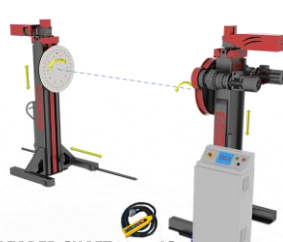
MOVABLE Positioner 2 Axis

BEMS-2AX



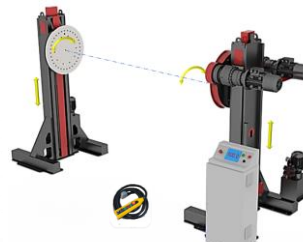
THREADED SHAFT LIFTING
STATIONARY Positioner- 2 Axis

BEMG-(2+1)AX



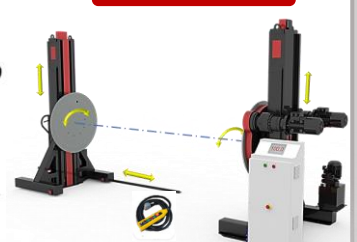
THREADED SHAFT LIFTING
MOVABLE Positioner- 2 Axis

BEMHS-2AX



THREADED SHAFT LIFTING
STATIONARY Positioner-2 AX

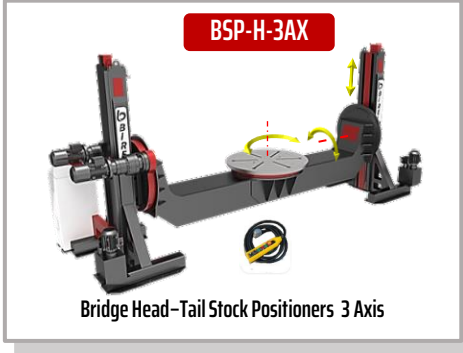
BEMHG-(2+1)AX



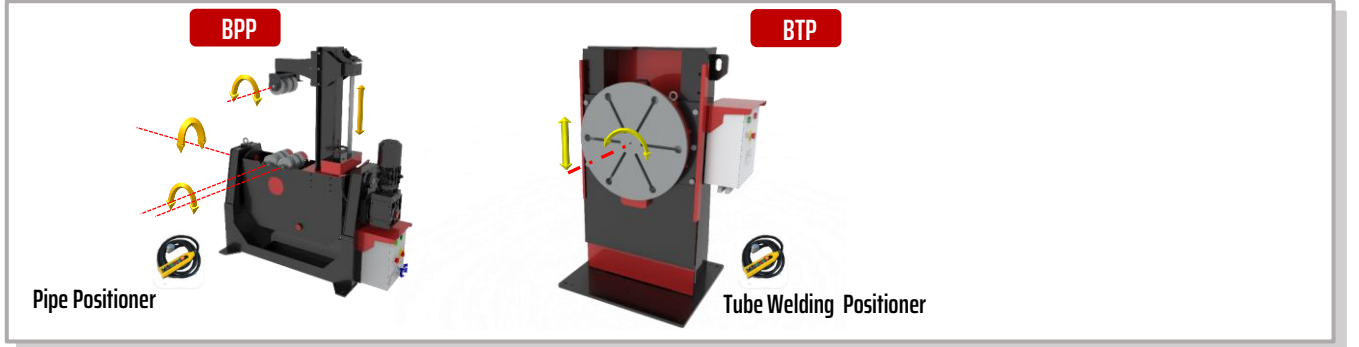
HYDRAULIC LIFTING
MOVABLE Positioner-2 AX

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A04-Head-Tail Stock Types



A05 - Pipe Types



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ABOUT PRODUCT

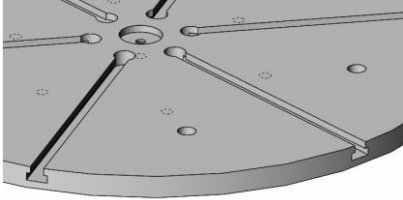
2
Axis

- ❖ ERGONOMIC
- ❖ Opportunity of Over Desktop Application.
- ❖ Opportunity of Attaching Manual Chuck
- ❖ Adjustment of Tilting Angle by means of Manuel HandWheel (0-90°)



OPTIONAL Modifications & Equipments ;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



MC : Manual Chuck



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed by Potentiometer
- Manual Mechanical gear movement for tilting by Handwheel. With opportunity of adjusting at every angle within range.
- 3 m. Power Cable
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply : 220V - (2 phase)
- Motor : DC Current
- One (1) Year Warranty (wearing parts out of warranty)



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Mini BCP

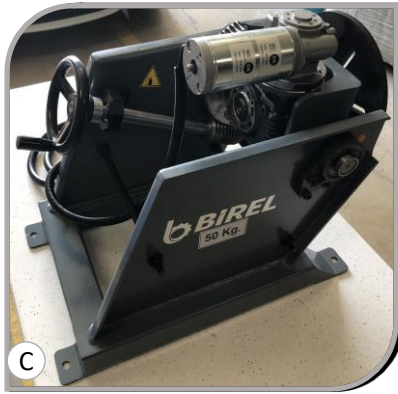
Section-A :WELDING POSITIONER MODELS | A01: Mini-Stationary Types
STANDARD Mini-Conventional Welding Positioner(2AX)



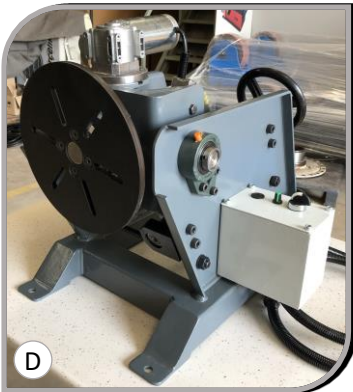
FEATURES



B

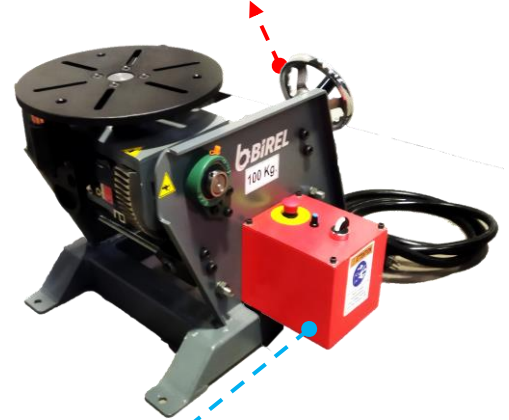


C



D

Handwheel Manuel Tilt Adjustment

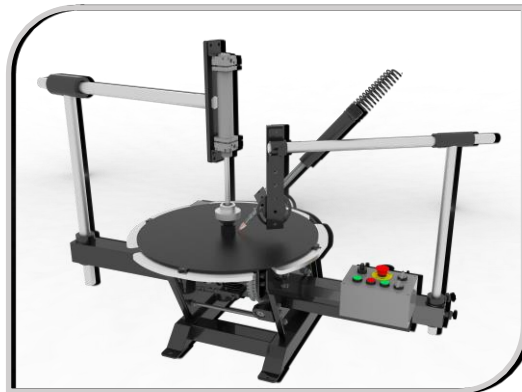


10-Emergency Stop

30-Table Rotation Direction
CW / CCW

20-Table Rotation
Speed Potentiometer

SPECIAL APPLICATIONS upon CUSTOMER REQUEST

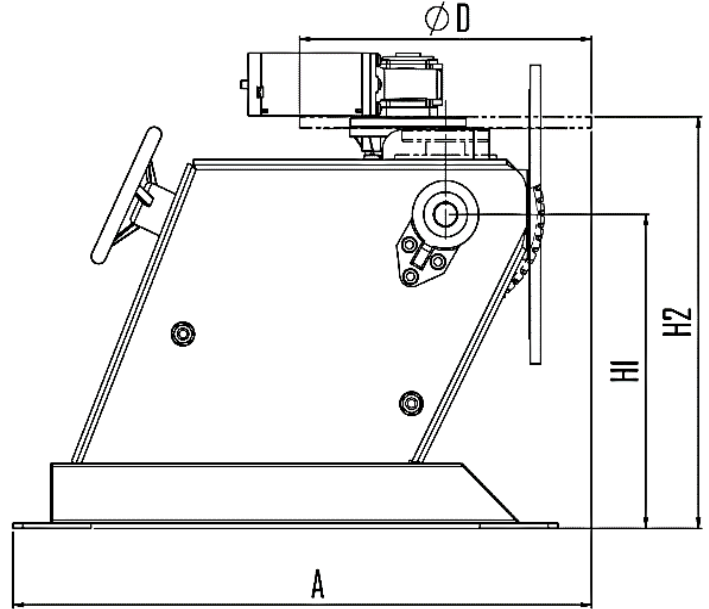
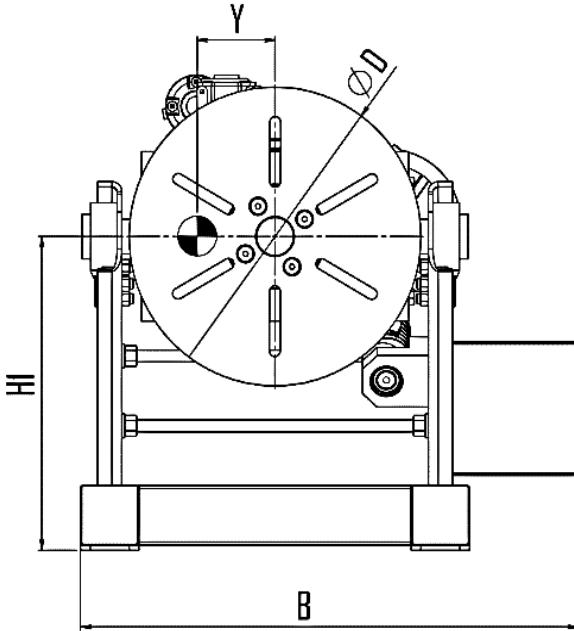


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TECHNICAL PROPERTIES

Mini-BCP-005 /Mini-BCP 010



Mini-BCP model	Symb.	Unit	Mini-BCP005	Mini-BCP010
Capacity		kg	50	100
Rotation Speed		rpm	0 - 2,3	0 - 2,3
Max. Rotational Torque		Nm	49	86
Tilting Angle		deg	0 - 90°	0 - 90°
Tilting Torque		Nm	Manual	Manual
Offset Distance	X - Y	mm	Y=50	Y=50
Table Diameter	ØD	mm	250	300
Height (Table Vertical)	H1	mm	315	315
Height (Table Parallel)	H2	mm	411	415
Length	A	mm	570	595
Width	B	mm	463	513
Motor Power of Table		kW	0,1 (DC)	0,1 (DC)
Tilting			Manuel	Manuel
Weight		kg	47	57

↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

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Mini

BCP-010-SA

Chapter-A : WELDING POSITIONER MODELS | A01: Mini-Stationary Types

STANDARD Mini-Conventional SEMI-AUTOMATIC Welding Positioner

BIREL
MÜHENDİSLİK MAKİNA A.Ş.

ABOUT PRODUCT



- ❖ Pneumatic Pressing,
- ❖ Overlapping of welding at the end of cycle by time delay.
- ❖ Adjustment of Tilting Angle by means of Manuel HandWheel (0-90°)
- ❖ Manual adjustment of Torch holder Angle and Height.
- ❖ Ergonomic Table.



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed by Potentiometer
- Manual Mechanical gear movement for tilting by Handwheel. With opportunity of adjusting at every angle within range.
- 3 m. Power Cable
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply : 220V - (2 phase) (DC Current)
- One (1) Year Warranty (wearing parts out of warranty)

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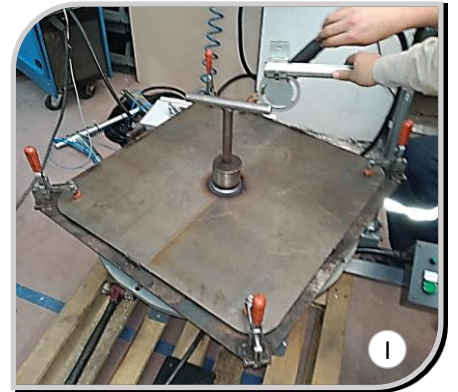
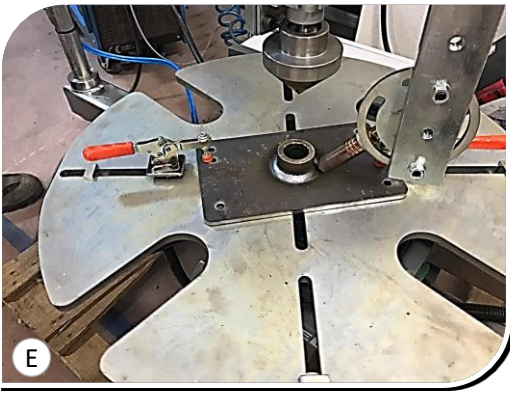
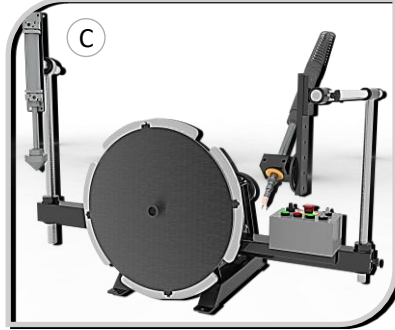
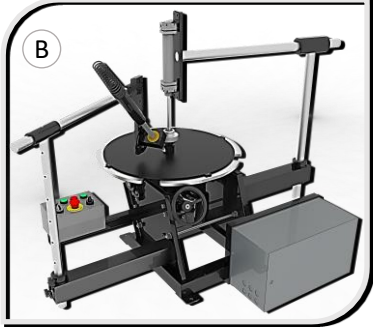
Mini

BCP-010-SA

Chapter-A :WELDING POSITIONER MODELS | A01: Mini-Stationary Types
STANDARD Mini-Conventional SEMI-AUTOMATIC Welding Positioners

BIREL
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FEATURES



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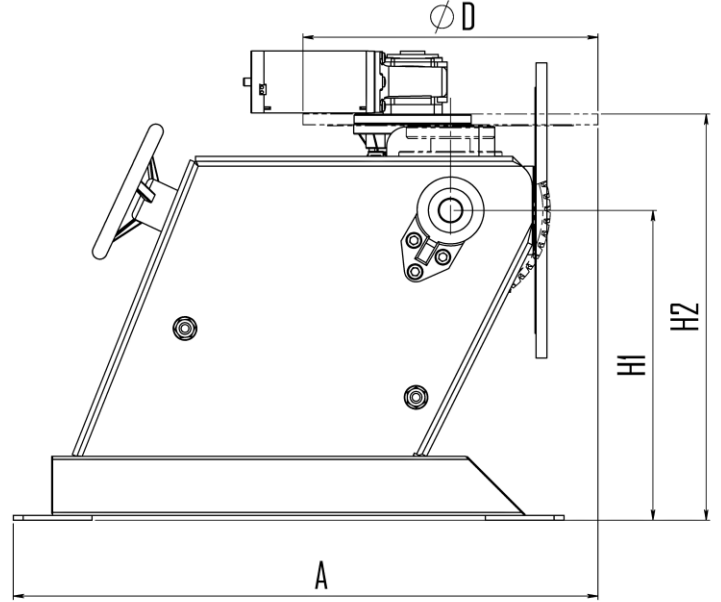
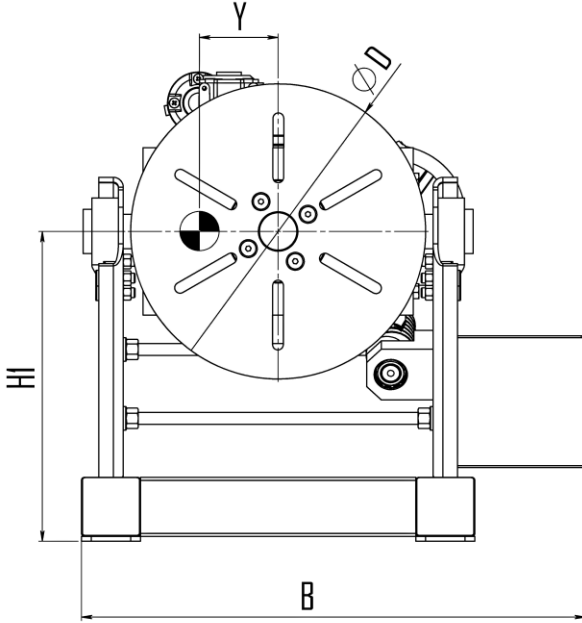
Mini

BCP-010-SA

Section-A :WELDING POSITIONER MODELS | A01: Mini-Stationary Types
Capacity-100kg. STAND. Mini-Conventional SEMI-AUTOMATIC Welding Pos.

BIREL
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TECHNICAL FEATURES



Technical Details :

Mini-BCP-SA model	Symb.	Unit	Mini-BCP010-SA
Capacity		kg	100
Rotation Speed		rpm	0 - 2,3
Max.Rotational Torque		Nm	86
Tilting Angle		deg	0 - 90°
Tilting Torque		Nm	Manual
Offset	X- Y	mm	Y=50
Work Plate Diameter	ØD	mm	300
Height (Table Vertical)	H1	mm	315
Height (Table Parallel)	H2	mm	415
Length	A	mm	595
Width	B	mm	513
Motor Power of Table		kW	0,1 (DC)
Motor Power of Tilting			Manual
Weight		kg	57

↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

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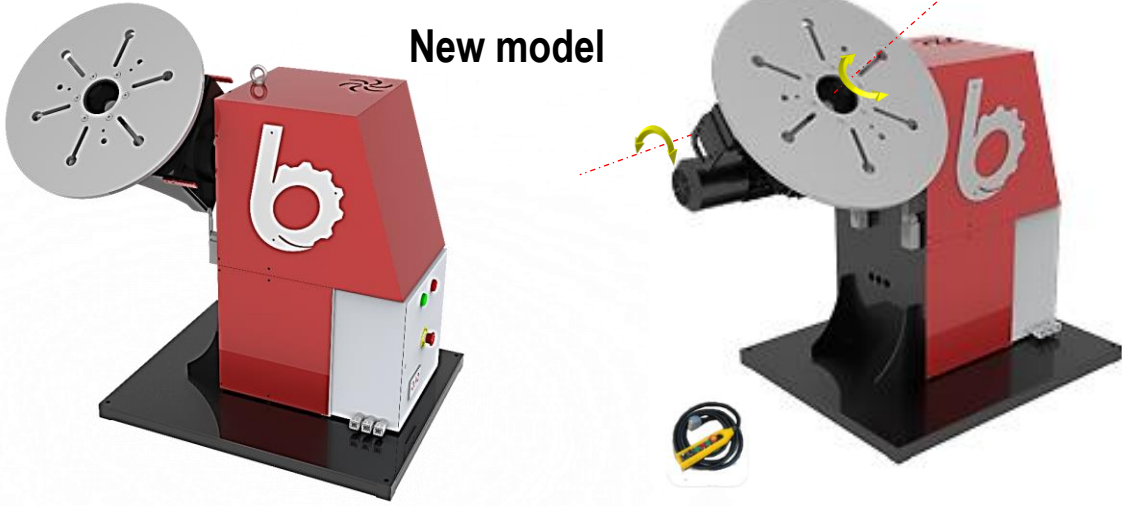
Mini
BCP-020
BCP-020-D

Chapter-A :WELDING POSITIONER MODELS | A01: Mini-Stationary Types
Capacity-200kg. STANDARD Mini-Conventional Welding Positioner(2AX)

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ABOUT PRODUCT STANDARD: with Slotted Table & HandBox Cable Remote Control

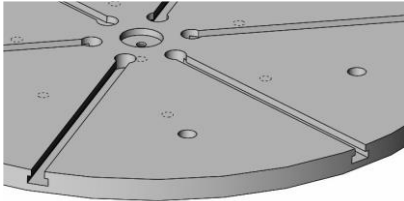
2
Axis



New model

OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved
Thick Table Plate



MC : Manual Chuck



General Features ;

- Mini-BCP model Conventional Positioner is designed at best suitable configuration to supply function of worktable rotation & tilting of worktable angularly.
- Mini-BCP model Conventional Positioner as structurally has the best protective system. Against heavy parts positioner should be anchored to the facility ground.
- Mini-BCP model Conventional positioner, without considering of any geometric shape, all parts within dimensions has capability of positioning & forming suitable welding edge.
- Mini-BCP model Conventional positioner, as structurally are constituted of Body, Motor, Worktable rotation and tilting systems, electric panel and cable remote operator control.
- The rotation & tilting movements of Mini-BCP model Conventional Positioner are done by means of gear transmission system.
- Enable quick connection of workpiece by means of Slot Groove or T-Grooved worktable.
- Mini-BCP Conventional positioner WorkTable is supplied as standard with T-Side Entry grooved. Optionally, If Worktable is requested as T-Grooved Thick Plate also can be manufactured as an option.

Technical Advantages ;

- Birel Machinery as standard provides Mini-BCP models in capacities of 50 - 100 - 200 kg..
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling
- Welding Arc Group
- For any special request or project, Please do not hesitate to contact with us.

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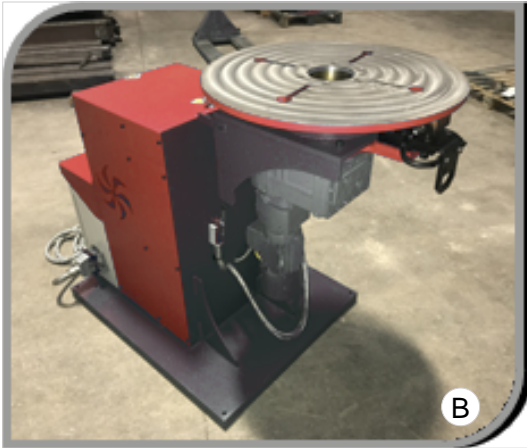
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Mini
BCP-020
BCP-020-D

Chapter-A :WELDING POSITIONER MODELS | A01: Mini-Stationary Types
Capacity-200kg. STANDARD Mini-Conventional Welding Positioner(2AX)

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MÜHENDİSLİK MAKİNA A.Ş.

FEATURES



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- Mechanical gear movement for tilting.
- Limit Switches to terminate movement.
- 3 m. Command Cable with Hand Control Unit.
- 3 m.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



SFP

Single Foot Pedal



WRC

Wireless Remote Control

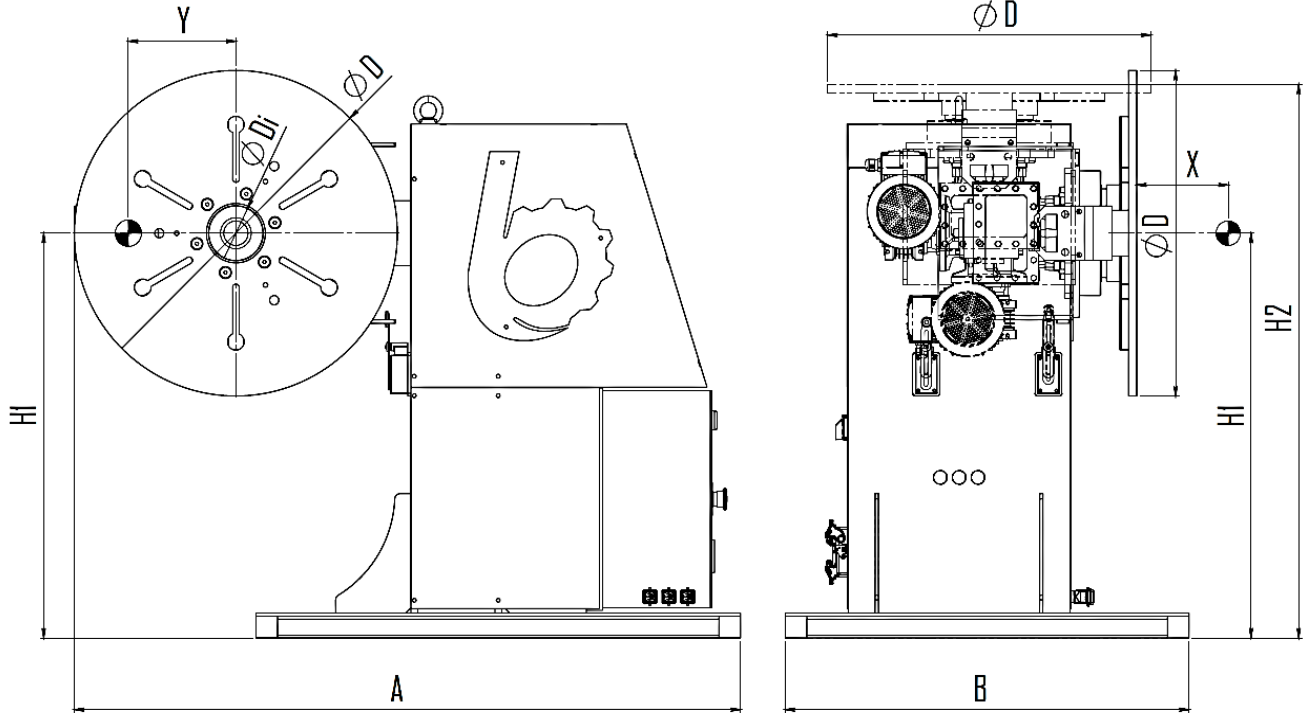


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TECHNICAL PROPERTIES

Mini-BCP-020 and Mini-BCP-020-D



Technical Details :

Mini-BCP model	Symb	Unit	Mini-BCP020	Mini-BCP020-D
Capacity		kg	200	200
Rotation Speed		rpm	0,22-2,2	0,38-3,8
Max.Rotational Torque		Nm	300	300
Tilting Angle		deg	90-0-90	90-0-90
Tilting Torque		Nm	685	685
Max.Welding Current		Amp	400	400
Offset Distance	X-Y	mm	150 - 150	150-150
Table Plate Diameter	ØD	mm	600	500
Hollow Shaft	ØDi	mm	100	100
Hollow Shaft Up to Depth		mm	60	Through all
Height (Table Vertical)	H1	mm	750	750
Height (Table Parallel)	H2	mm	1020	1020
Length	A	mm	1240	1240
Width	B	mm	750	750
Motor Power of Table		kW	0,25	0,25
Motor Power of Tilting		kW	0,25	0,25
Weight		kg	350	325

↪ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

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Special Application-1



Special Application-2



General Features ;

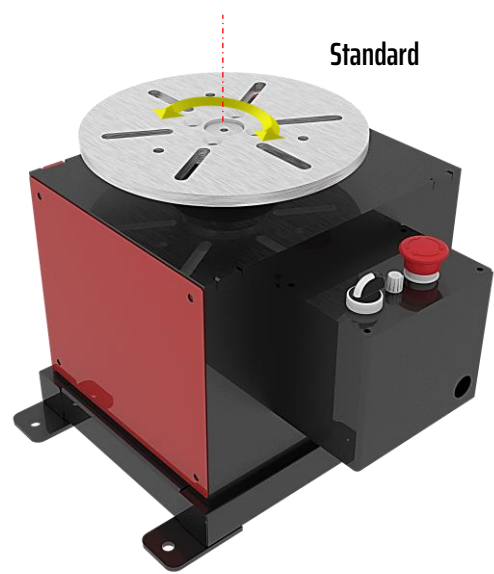
- Mini-BTT model Turn Table is widely used industrial, petro-chemical, energy power plant, chemical transmission, ship building, etc.sectors
- Mini-BTT model Turn Table is designed for easily mounting of cylindrical parts for twizzling of by means of worktable provided. Optional special quick mounting-detaching equipment provides easy working advantage.
- Mini-BTT model 1 axis Turn Table Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmostly capability of welding & likewise assembling at 360° degree of any required position .
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work..
- Mini-BTT-model Turn Table Positioner WorkTable is supplied as standard with Slot grooved. Optionally, If Worktable is requested as T-Grooved Thick Plate also can be manufactured as an option.

Technical Advantages ;

- Out of this standard capacity, Birel Machinery, according to customer standards and requirements, has the opportunity of anufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

FEATURES



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed
- Ability of 360 degree worktable rotation.
- 3 m. Power Cable
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power supply :220V - (2 phase) DC
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



SFP

Single Foot Pedal



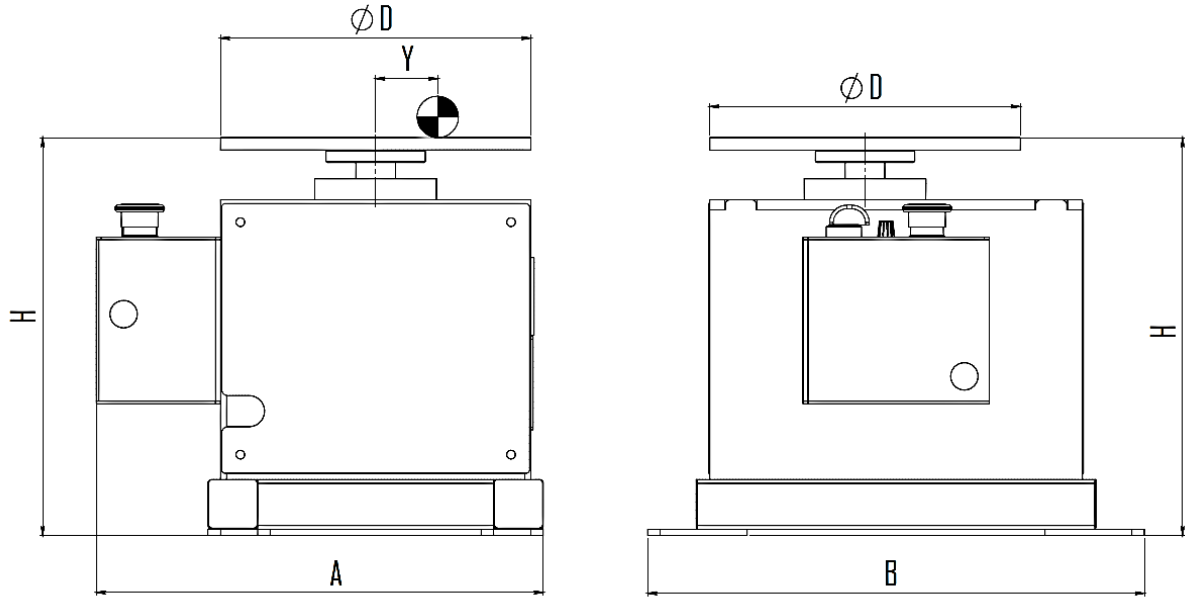
WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

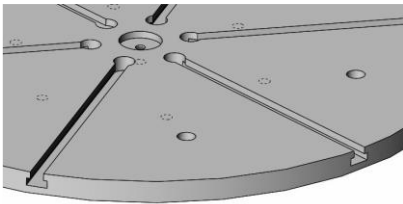
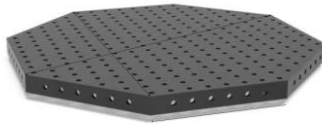
Model : Mini-BTT	Symb	Unit	Mini-BTT005
Capacity		kg	50
Rotation Speed		rpm	0 - 4
Offset	Y	mm	50
Table Plate Diameter	ØD	mm	250
Width	H	mm	320
Length	A	mm	360
Height	A	mm	360
Power of WorkTable		Watt	100
Weight		kg	30

↪ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate

OC-T:Octagonal Table

MC : Manual Chuck

BGR:3 Jaw Manual Pipe Gripper


General Features ;

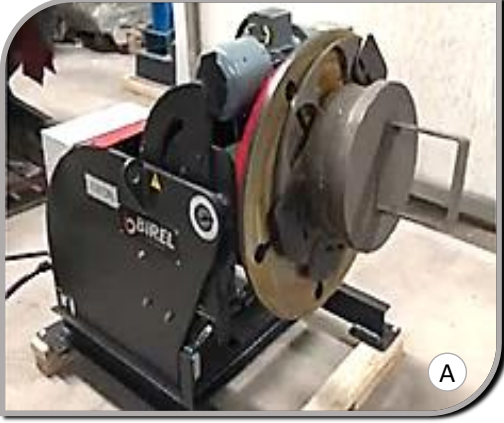
- BCP model Conventional Positioner is designed at best suitable configuration to supply function of worktable rotation & tilting of worktable angularly..
- BCP model Conventional Positioner as structurally has the best protective system. Against heavy parts positioner should be anchored to the facility ground.
- BCP model Conventional positioner, without considering of any geometric shape , all parts within dimensions has capability of positioning & forming suitable welding edge.
- BCP model Conventional Positioner, as structurally are constituted of body, motor ,worktable rotation and tilting systems, electric panel and cable remote operator control.
- The rotation & tilting movements of BCP model Conventional positioner are done by means of gear transmission system.
- Enable quick connection of workpiece by means of Slot Groove or T-Grooved worktable.
- BCP-model Conventional positioner WorkTable is supplied as standard with SLOT grooved. Optionally, If Worktable is requested as T-Grooved Thick Plate also can be manufactured as an option.

Technical Advantages ;

- Birel Machinery as standard provides BCP models in capacities of 0,25 - 0,50 - 1 - 2 - 3 - 5 - 8 - 10 - 20 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

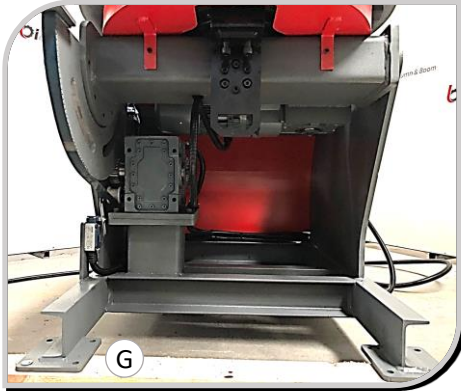
ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

FEATURES

Welding Arc Group



Mechanical gear movement for tilting.



Mechanical Angle Indicator



Electrical Cabinet



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed.
- Rotational Speed Dijital display on Electrical Cabinet
- Mechanical gear movement for tilting.
- Mechanical Angle Indicator
- Tilt gear protection bands.
- Limit Switches to terminate movement.
- 5 mt. Command Cable with Hand Control Unit.
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



SFP

Single Foot Pedal



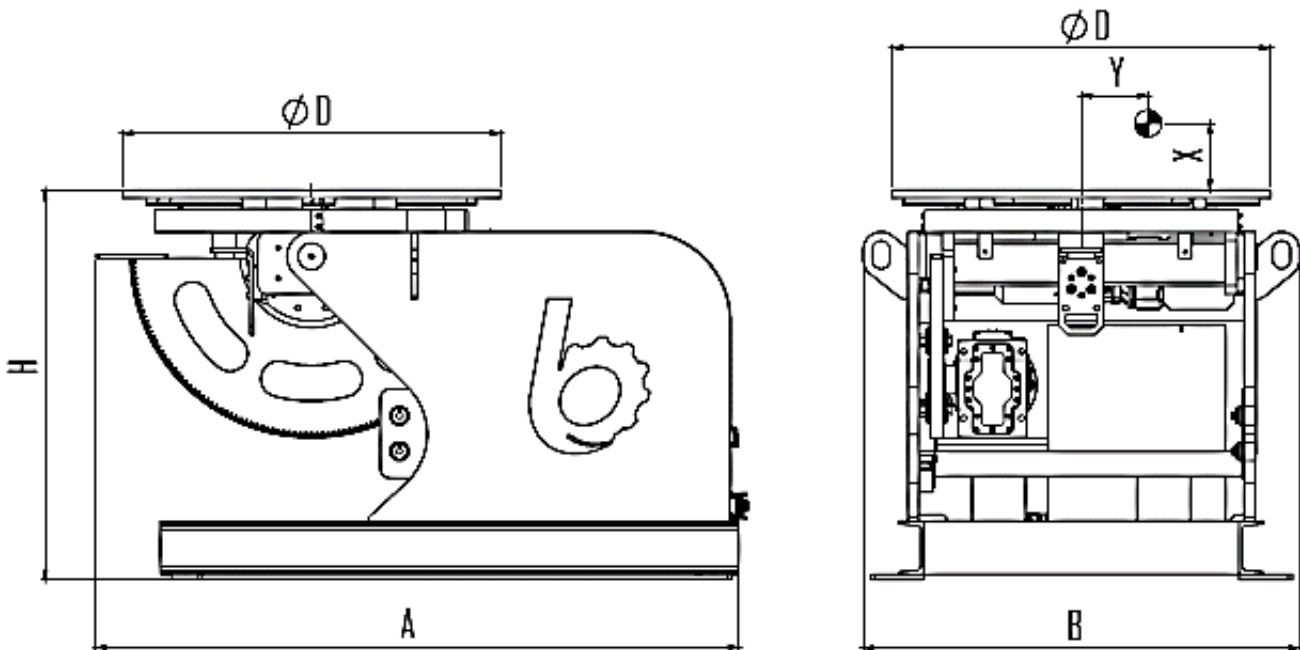
WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

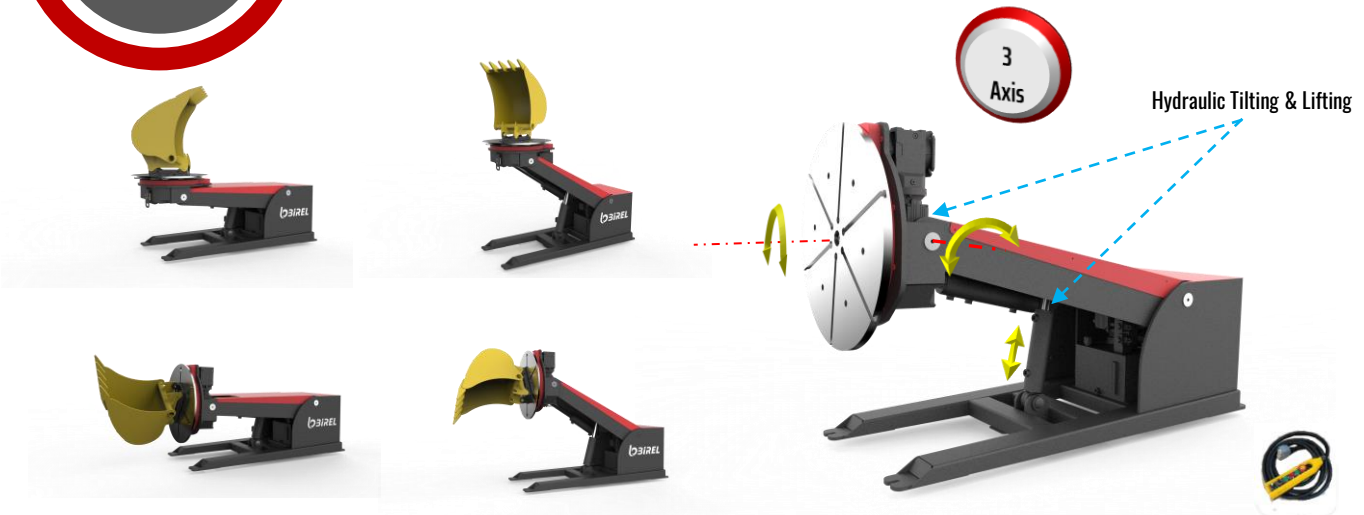


Technical Details :

BCP model	Symb.	Unit	BCP-025	BCP-050	BCP-1	BCP-2	BCP-3	BCP-5	BCP-8	BCP-10	BCP-20
Capacity		kg	250	500	1 000	2 000	3 000	5 000	8 000	10 000	20 000
Rotation Speed		rpm	0,15-1,65	0,15-1,75	0,15-1,4	0,15-1	0,10-0,70	0,1-0,78	0,1-0,66	0,1-0,5	0,05-0,5
Max. Rotational Torque		Nm	500	750	1570	3050	4500	7500	12050	15050	3500
Tilting Angle		deg	100	100	115	115	115	115	110	110	120
Tilting Torque		Nm	650	1360	2720	5130	8500	15500	25520	31580	108 800
Offset Distance	X-Y	mm	150-150	150-150	150-150	150-150	150-150	150-150	150-150	150-150	400-150
Max. Welding Current		Amp	700	700	700	700	700	1000	1000	1000	1000
Table Plate Diameter	ØD	mm	600	700	850	900	1000	1250	1500	1650	2150
Height	H	mm	725	765	880	1000	1100	1220	1420	1480	1910
Length	A	mm	1170	1180	1450	1620	1760	2120	2350	2410	3000
Width	B	mm	810	870	980	1150	1350	1725	1750	1790	2450
Motor Power of Table		kW	0,25	0,25	0,37	0,55	0,55	1,1	1,5	1,5	3
Motor Power of Tilting		kW	0,25	0,37	0,55	0,75	1,1	2,2	3	4	3 x 2
Weight		kg	320	390	710	1050	1120	1910	2980	3450	9630

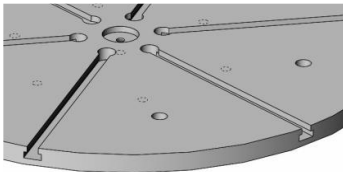
↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

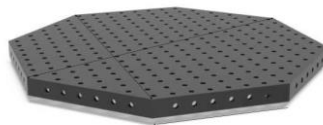


OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



OC-T:Octagonal Table



MC : Manual Chuck



BGR: 3-Jaw Manual Pipe Gripper



General Features ;

- BHP model Hydraulic Elevating Positioner is designed at best suitable configuration to supply function of worktable rotation & tilting of worktable angularly..
- Dissimilar to other positioners, Upon BHP model Hydraulic Elevating Positioner , Although the workpiece is mounted on the workplate, Height is adjustable hydraulically. Thus, Operators can work more effective & efficient.
- BHP model Hydraulic Elevating Positioner , without considering of any geometric shape , all parts within dimensions has capability of positioning & forming suitable welding edge.
- BHP model Hydraulic Elevating Positioner , as structuraly are constituted of Body, Motor ,Worktable rotation and tilting systems, electric panel and cable remote operator control.
- BHP model Hydraulic Elevating Positioner as structuraly has the best protective system. Against heavy parts positioner should be anchored to the facility ground.
- Rotation of BHP model Hydraulic Elevating Positioner's Worktable is done by means of gear transmission system and tilting and height movements are performed by hydraulic system.
- Enable quick connection of workpiece by means of Slot Groove or T-Grooved worktable.
- BHP-Hydraulic Elevating Positioner WorkTable is supplied as standard with Slot grooved. Optionally, If Worktable is requested as T-Grooved Thick Plate also can be manufactured as an option.

Technical Advantages ;

- Birel Machinery as standard provides BHP models in capacities of 0,5 - 0,75 - 1 - 1,5 - 2 - 3,5 - 5 - 8 - 10 - 15 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- Hydraulic movement for tilting.
- Hydraulic movement for elevating.
- Limit Switches to terminate movement.
- 5 m. Command Cable with Hand Control Unit.
- 5 m. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Earthing Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



SFP

Single Foot Pedal



OHC

Overhead Hangable Control



BHP-HMI

PLC-HMI Display Control



WRC

Wireless Remote Control

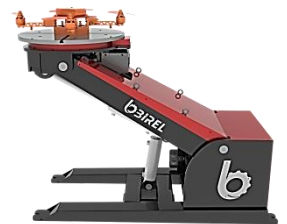
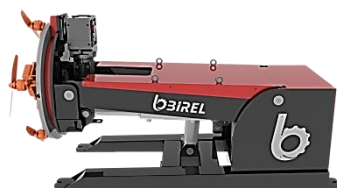
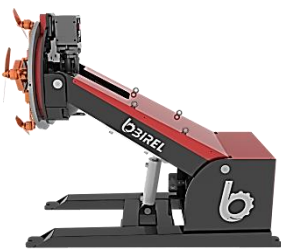
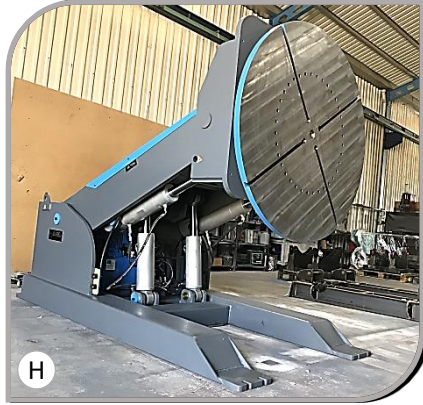


❖ All technical specifications are subject to change without prior notice.



STANDARD Hydraulic Lifting Welding Positioner Model (3AX)

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

Optional

PLC-HMI Display Controlled;

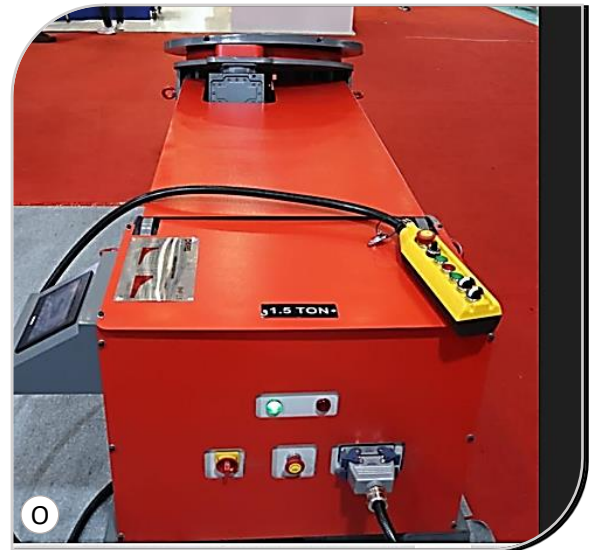
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	KAYDET					STOP	
	LIFT	9999	TILT	999	TILT HEDEF POZİSYONA GİT		TILT
	TILT	999	TILT	9999	TILT		TILT
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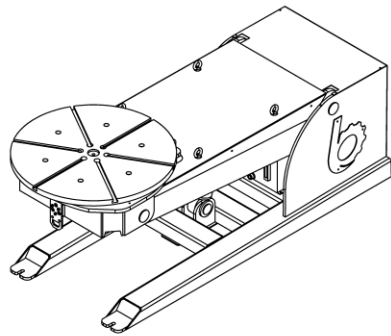
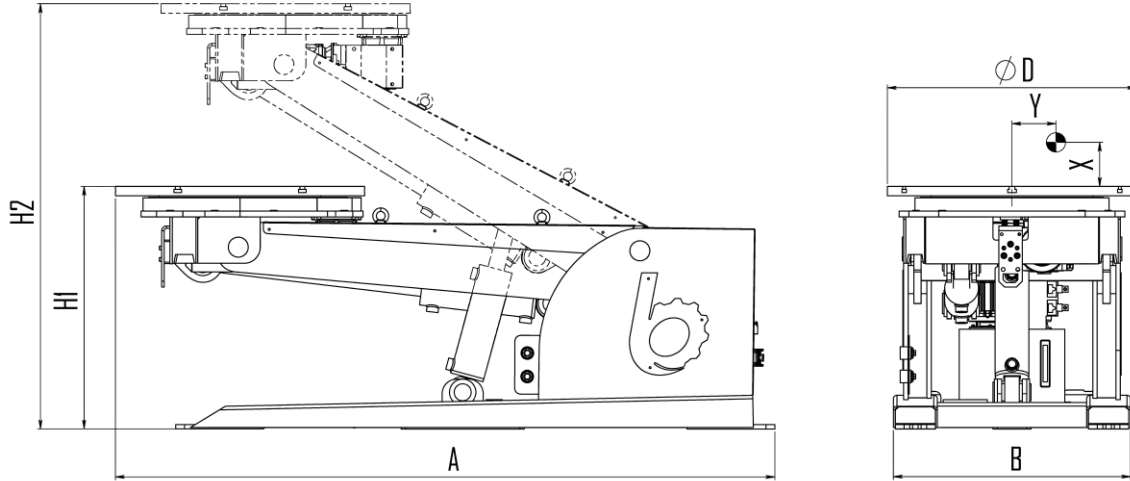
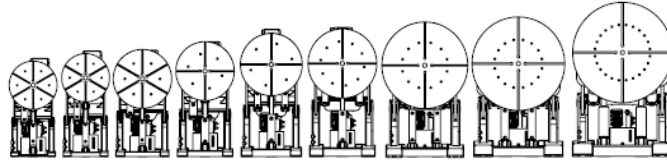


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❖ All technical specifications are subject to change without prior notice.

STANDARD Hydraulic Lifting Welding Positioner Model (3AX)

TECHNICAL PROPERTIES



Technical Details :

Model No : BHP	Symb	Unit	BHP-050	BHP-075	BHP-1	BHP-1,5	BHP-2	BHP-3,5	BHP-5	BHP-8	BHP-10	BHP15
Capacity		kg	500	750	1 000	1 500	2 000	3 500	5 000	8 000	10 000	15 000
Rotation Speed		rpm	0,15-1,75	0,15-1,5	0,15-1,4	0,15-1,3	0,15-1	0,15-1	0,15-0,78	0,1-0,66	0,1-0,5	0,06 - 0,63
Max.Rotational Torque		Nm	750	1150	1570	2290	3050	5300	7500	12050	15050	18000
Tilting Angle		deg	120	125	120	120	120	115	110	110	110	125
Tilting Torque		Nm	1350	2200	3300	4500	5600	11050	17300	28680	37050	76850
Max.Welding Current		Amp	400	700	700	700	700	700	1000	1000	1000	1000
Offset Distance	X-Y	mm	150 - 150	150 - 150	150 - 150	150 - 150	150 - 150	150 - 150	150 - 150	150 - 150	150 - 150	450-120
Work Plate Diameter	ØD	mm	700	700	850	850	900	1000	1150	1250	1350	1450
Height (Min-Max.)	H1-H2	mm	710-1200	760-1310	800-1340	825-1450	910-1545	960-1575	1000-1600	1050-1645	1160-1830	1300 - 2230
Length	A	mm	1900	1960	2240	2255	2375	2575	2900	3100	3200	3330
Width	B	mm	650	660	780	810	880	960	1130	1300	1460	1820
Motor Power of Table		kW	0,25	0,37	0,37	0,55	0,55	0,75	1,1	1,5	1,5	2,2
Motor Power of Hydraulic Unit		kW	0,75	1,1	1,1	1,5	1,5	2,2	2,2	3	5,5	5,5
Weight		kg	585	650	880	1300	1420	1650	2720	3500	4600	6820

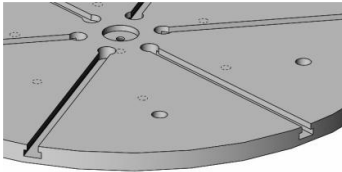
↪ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



BTT-M02: Fastening Apparatus



General Features ;

- BTT model Turn Table is widely used industrial, petro-chemical, chemical, energy power plant, transmission, ship building, etc.sectors
- BTT model Turn Table is designed for easily mounting of cylindrical parts for twizzling of by means of worktable provided. Optional special quick mounting-detaching equipment provides easy working advantage.
- BTT model 1 axis Turn Table Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmostly capability of welding & likewise assembling at 360° degree of any required position .
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work..
- Operators can control workpieces over BTT TurnTable Positioner whether in Counterclockwise(CW) or Counterclockwise(CCW)by means of cable command control. They can easily rotate at adjustable speeds.
- BTT-model Turn Table Positioner WorkTable is supplied as standard with Slot grooved. Optionally, If Worktable is requested as T-Grooved Thick Plate also can be manufactured as an option.

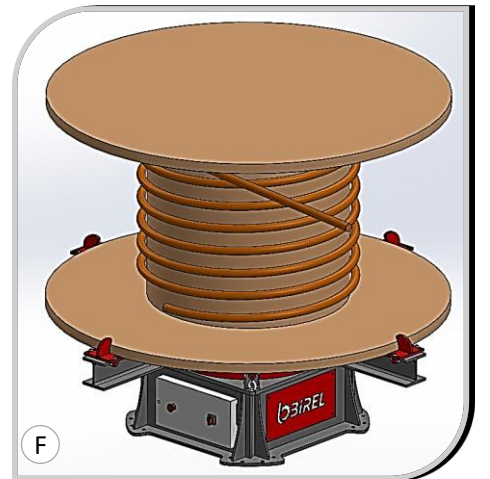
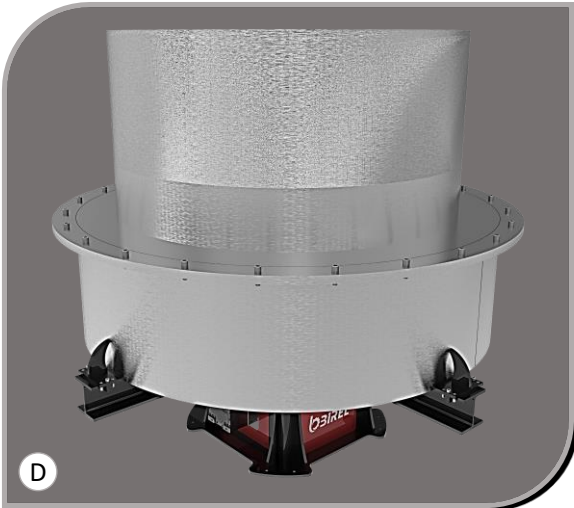
Technical Advantages ;

- Birel Machinery as standard provides BTT models in capacities of 1 - 2 - 3 - 5 - 10 - 25 - 50 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.



ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.



FEATURES



Standard Features

- Round Worktable with Slots.
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- Ability of 360 degree worktable rotation.
- Limit Switches to terminate movement.
- 5 m. Command Cable with Hanbox
- 5 m. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Earthing Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



SFP

Single Foot Pedal



WRC

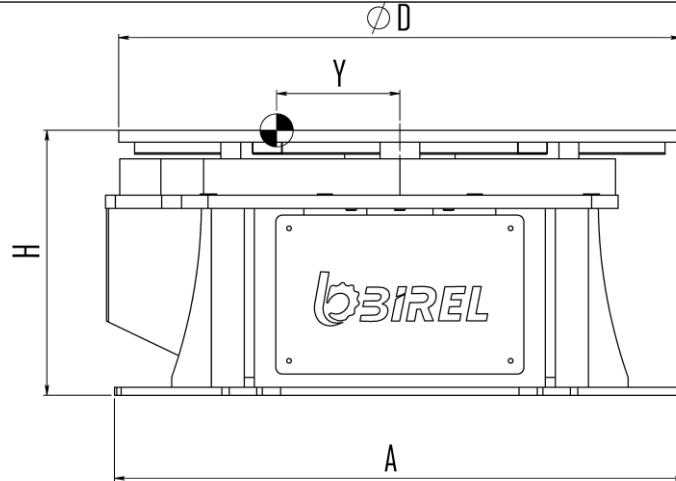
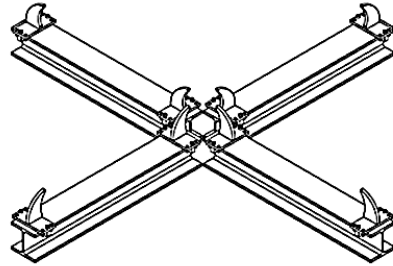
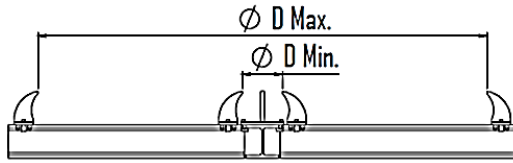
Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

OPTIONAL (BTT- M02)



Technical Details :

Model : BTT	Symb.	Unit	BTT-1	BTT-2	BTT-3	BTT-5	BTT-10	BTT-25	BTT-50
Capacity		kg	1 000	2 000	3 000	5 000	10 000	25 000	50 000
Rotation Speed		rpm	0.15-1.4	0.06-0.55	0,06-0,55	0.06 -0.55	0.05-0.33	0.05-0.20	0.05-0.20
Welding Current		Amp	700	700	700	1000	1000	1000	1000
Offset Distance	Y	mm	150	150	150	130	100	80	80
Table Plate Diameter	ØD	mm	850	900	1000	1250	1500	1800	2000
Diameter that can be fixed onto the apparatus BTT-M02	Ød- ØD	mm	200-2000	200-2000	200-2000	200-2200	600-4400	600-4400	600-4400
Height	H	mm	400	450	490	490	650	720	770
Length	A	mm	860	980	1020	1250	1350	1550	1660
Width	A	mm	860	980	1020	1250	1350	1550	1660
Power of WorkTable		kW	0.37	0.37	0,37	0.55	0.55	0.75	1.1
Weight		kg	360	570	570	685	1250	2100	3200

↪ Out of these stand.ard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

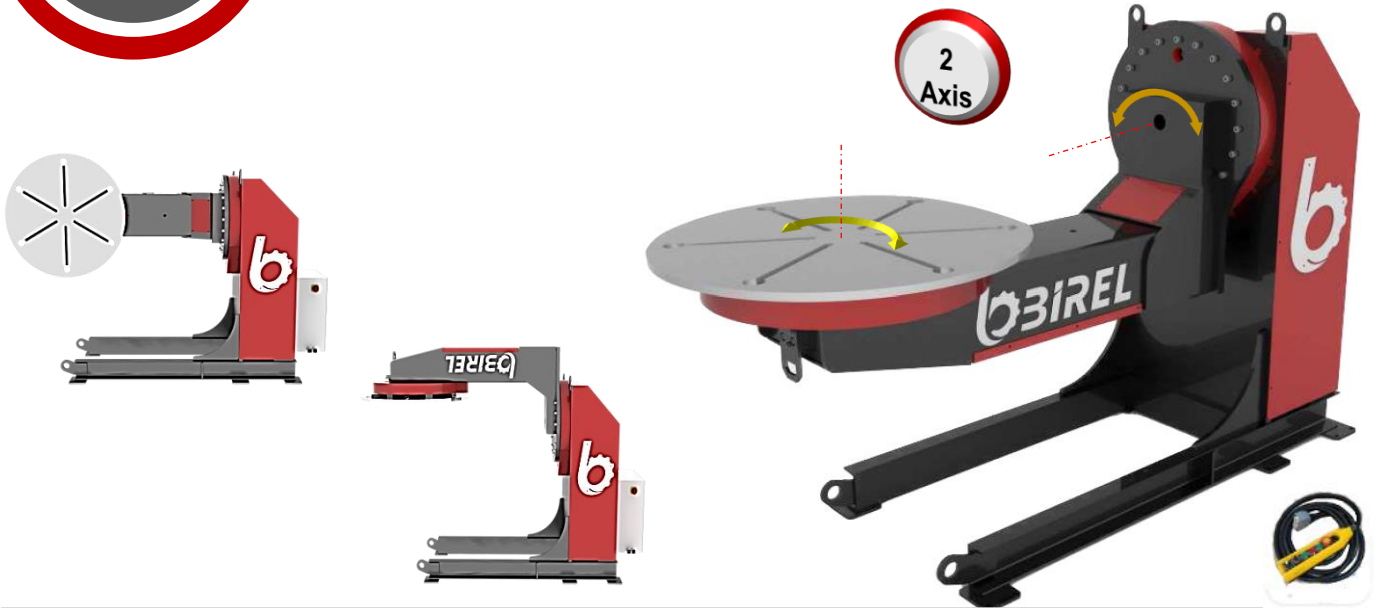
❖ All technical specifications are subject to change without prior notice.

BLP-2AX

STANDARD L-Type Welding Positioner Model (2AX)

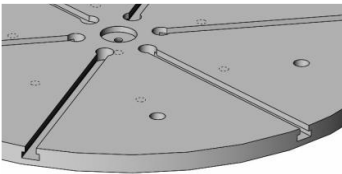
ABOUT PRODUCT

STANDARD: with Slotted Table & HandBox Cable Remote Control



OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



OC-T:Octagonal Table



MC : Manual Chuck



BGR: 3-Jaw Manual Pipe Gripper



General Features ;

- BLP-2AX model L-Type Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position.
- Designed in best suitable configuration to perform safe positioning of the workpieces having asymmetry & higher probability of overturn.
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work.
- BLP-2AX model positioner with robust construction & easy controlling ability, Provides the opportunity of comfortable working to operator & improves the quality of welding.
- The operators with BLP-2AX "L" type positioner, At center axis of worktable. workpiece can be precisely rotated over the command control at Clockwise (CW) or Counterclockwise (CCW) at specified speeds.

Technical Advantages ;

- Birel Machinery as standard provides BLP-2AX models in capacities of 0,5 - 1 - 2 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.



❖ All technical specifications are subject to change without prior notice.

FEATURES



Standard Features

- Capability of 360 degree worktable rotation.
- Round Worktable with Slots.
- Adjustable worktable rotation
- Rotational Speed Dijital display on Electrical Cabinet
- 5 m. Command Cable
- 5 m. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control

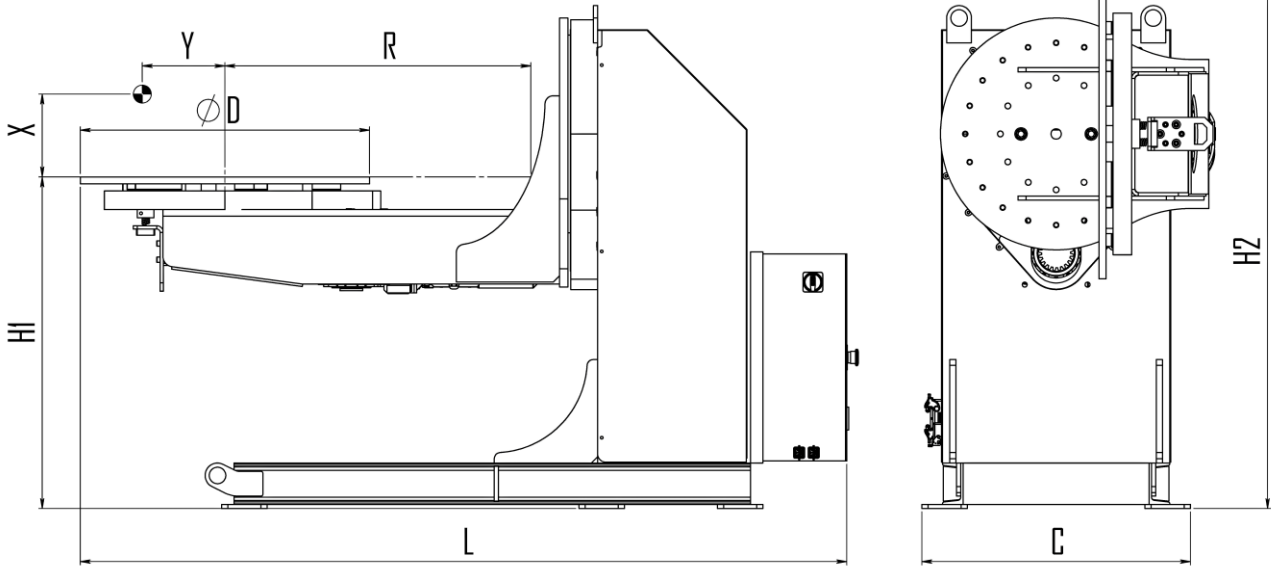


WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.


BLP-2AX
STANDARD L-Type Welding Positioner Model (2AX)
TECHNICAL PROPERTIES

Technical Details :

Model :BLP-2AX	Symb.	Unit	BLP0,5-2AX	BLP1-2AX	BLP2-2AX
Capacity		kg	500	1 000	2 000
Working Radius	R	mm	700	1000	1200
Offset Distance	X-Y	mm	300-150	300-150	300-150
Table Diameter	ØD	mm	700	850	900
Max. Rotational Torque		Nm	750	1500	3050
Work Table Speed		rpm	0,15-1,5	0,15-1,4	0,15-1
Max. Tilting Torque		Nm	1100	1750	4450
Tilting Speed		rpm	1,4	1	0,70
Max.Welding Current		Amp	400	700	700
Table Height (at 0°)	H1	mm	800	870	980
Total Height (at 90°)	H2	mm	1260	1450	1530
Total Length	L	mm	1860	2250	2720
Total Width	C	mm	650	720	850
Motor Power of Table		kW	0,37	0,37	0,55
Motor Power of Tilting		kW	0,37	0,37	0,55
Weight		kg	590	820	1240

✦ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

✦ All technical specifications are subject to change without prior notice.

BLPL 3AX

Chapter-A :WELDING POSITIONER MODELS | A03: Standard Stationary Types
STANDARD L-Type Welding Positioner Model- LIGHT DUTY Version(3AX)

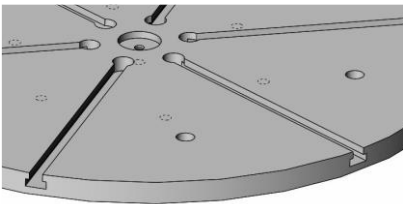
BIREL
MÜHENDİSLİK MAKİNA A.Ş.

ABOUT PRODUCT STANDARD: with Slotted Table & HandBox Cable Remote Control



OPTIONAL Modifications & Equipments;

T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



OC-T:Octagonal Table



MC:Manual Chuck



BGR:3 Jaw Manual Pipe Gripper



General Features ;

- BLPL-3AX model 3 axis Head Tail Stock Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- Designed in best suitable configuration to perform safe positioning of the workpieces having asymmetry & higher probability of overturn.
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work.
- BLPL-3AX model positioner with robust construction & easy controlling ability, Provides the opportunity of comfortable working to operator & improves the quality of welding.
- The operators with BLPL-3AX "L" type positioner, At center axis of worktable Workpiece can be precisely rotated over the command control at Clockwise (CW) or Counterclockwise(CCW) at specified speeds.

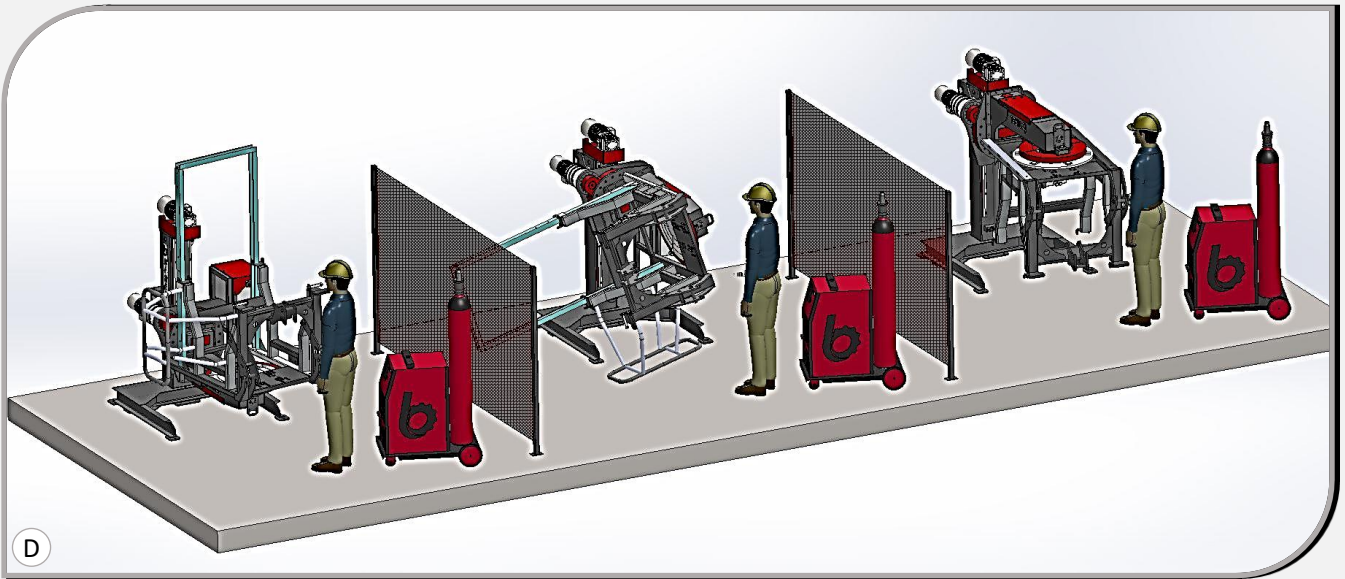
Technical Advantages ;

- Birel Machinery as standard provides BLPL-3AX models in capacities of 0,75 - 1,5 - 3 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

Birel Mühendislik Makine San. Tic. A.Ş. | Adresses: Yaylacik Mahallesi Dogancilar Mevkii 46. Sok. No:4/1 Nilüfer/Bursa – TURKEY
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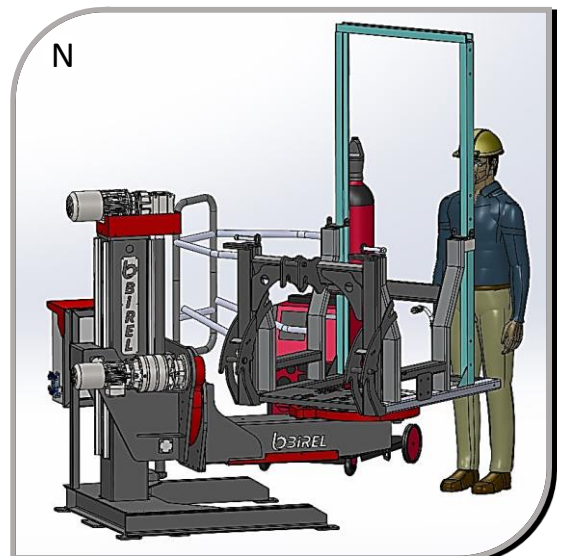
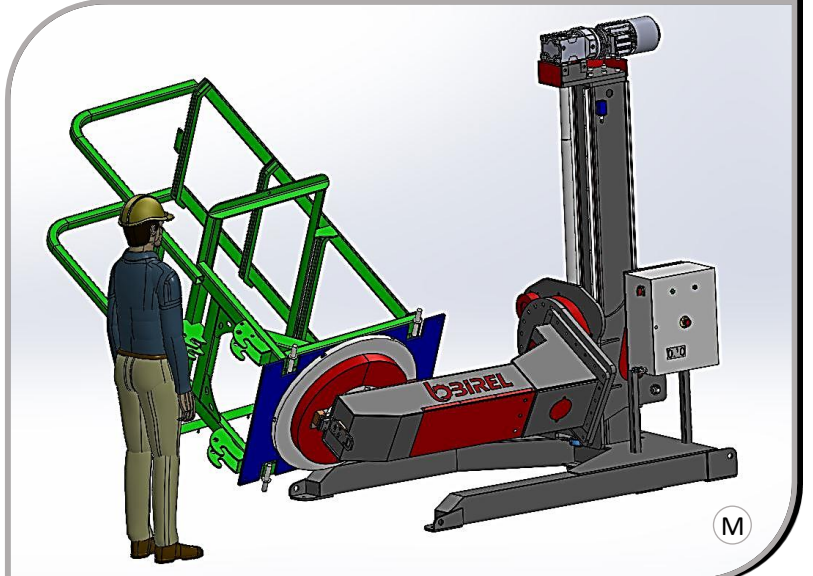
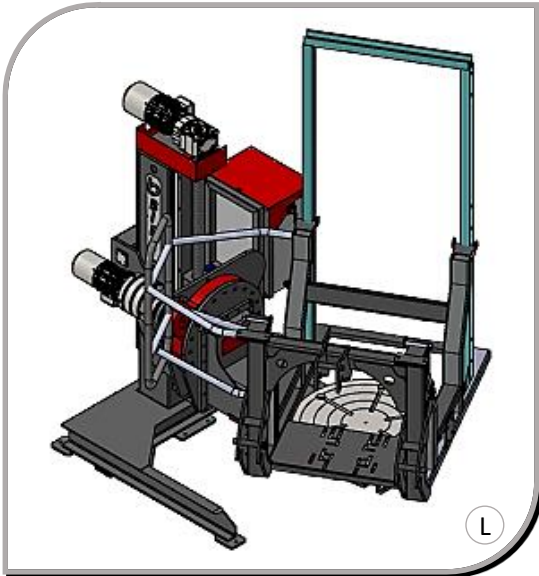
ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

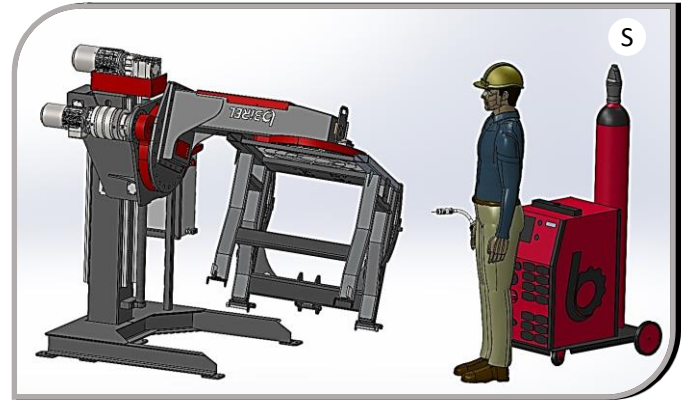
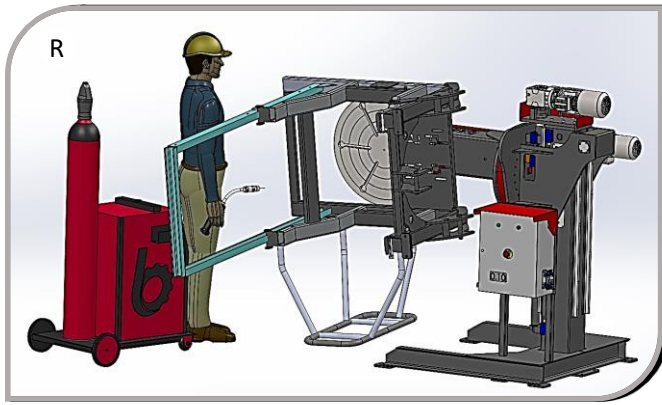
BLPL
3AX

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Features

- Capability of 360 degree worktable rotation.
- Round Worktable with Slots.
- Lifting of workpiece vertically by means of Threaded Shaft is presented as standard.
- Adjustable worktable rotation speed & Dijital display on Electrical Cabinet
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (Wearing Parts outside of Warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control

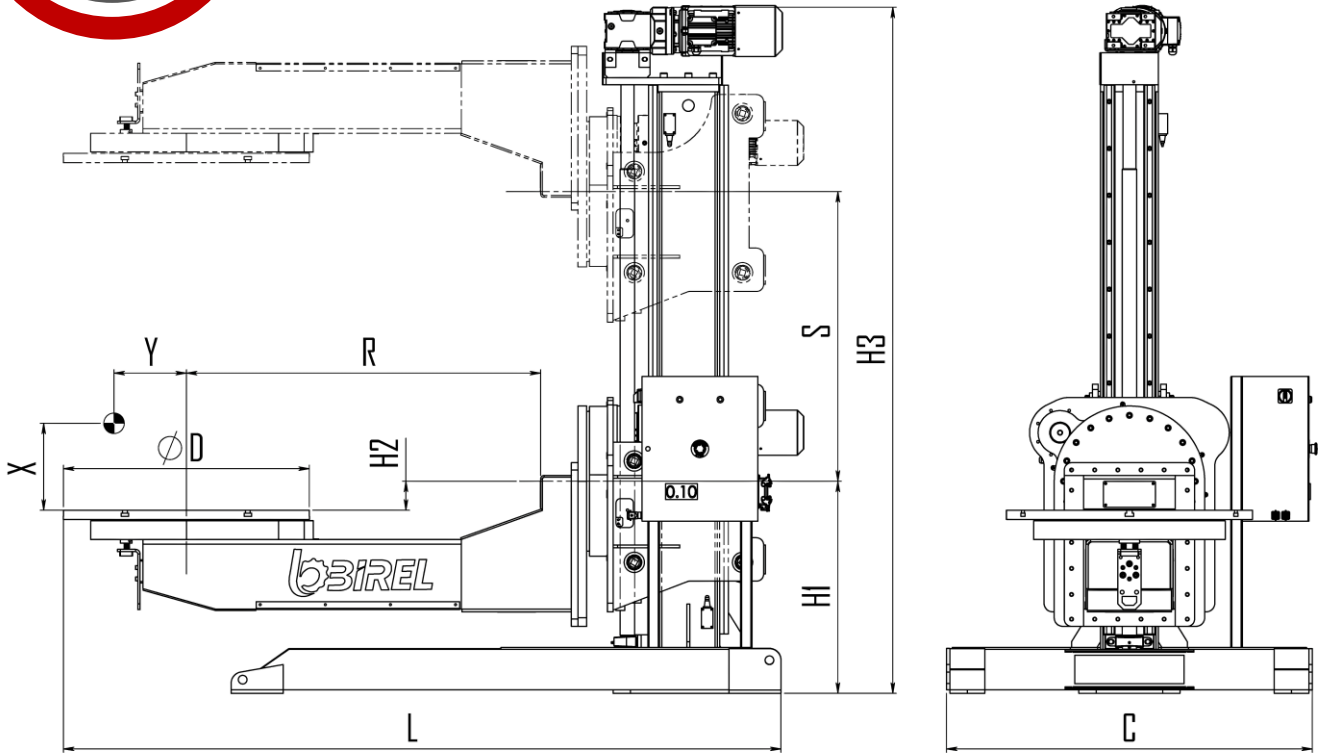


WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

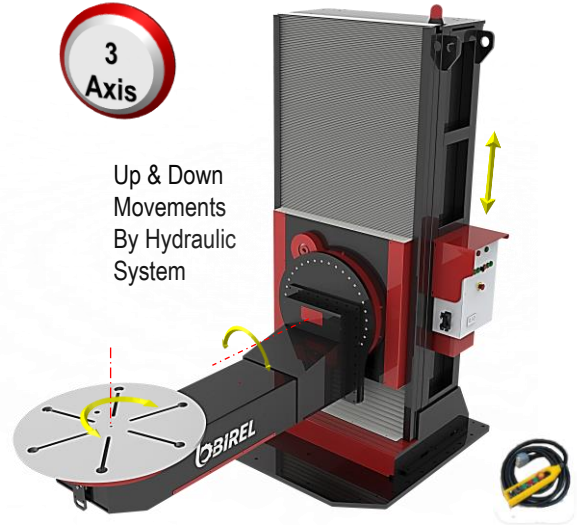


Technical Details :

Model : BLPL-3AX	Symb.	Unit	BLPL050-3AX	BLPL075-3AX	BLPL1,5-3AX	BLPL3-3AX
Capacity		kg	500	750	1 500	3 000
Lifting Stroke	S	mm	550	650	1000	1150
Working Radius	R	mm	1000	1000	1200	1600
Offset Distance	X-Y	mm	450-150	300 - 150	300 - 150	300 - 150
Table Diameter	ØD	mm	700	700	850	1000
Table Torque		Nm	750	1130	2260	4550
Table Speed		rpm	0,15-1,5	0,2 - 1,5	0,2 - 1,4	0,2 - 1
Tilt Torque		Nm	2100	2750	3340	6900
Tilt Speed		rpm	1	0.70	0.70	0.55
Lifting Speed		m/min	0,60	0.60	0.50	0.50
Max. Welding Current		Amp	700	700	700	700
Rotating Center Height	H1	mm	770	680	730	720
Plate Rotating Center Difference	H2	mm	50	144	100	100
Total Height	H3	mm	1900	1910	2380	2630
Total Length	L	mm	2170	2200	2480	3160
Total Width	C	mm	1170	1300	1265	1500
Motor Power of Table		kW	0,37	0,37	0.55	0.75
Motor Power of Tilting		kW	0,37	0,37	0.55	0.75
Motor Power of Lifting		kW	0,75	1.1	1.5	3
Weight		kg	730	1050	1390	2230

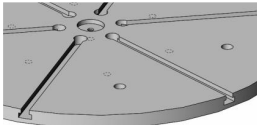
↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



OPTIONAL Modifications & Equipments;

T-SE: Round Worktable T-Side Entry Grooved Thick Table Plate



MC : Manual Chuck



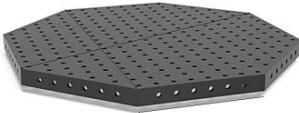
BGR: 3-Jaw Manual Pipe Gripper



SQ-T : Square Table



OC-T: Octagonal Table



General Features ;

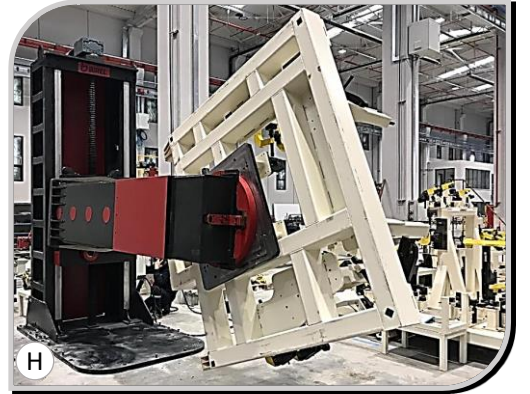
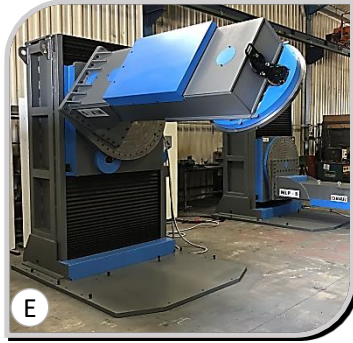
- BLP-3AX model 3 axis Heavy Duty L-Shape Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- Designed in best suitable configuration to perform safe positioning of the workpieces having asymmetry & higher probability of overturn.
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work.
- BLP-3AX model 3 axis Heavy Duty L-Tye positioner with robust construction & easy controlling ability, Provides the opportunity of comfortable working to operator & improves the quality of welding.
- The operators with BLP-3AX "L" type positioner, At center axis of worktable Workpiece can be precisely rotated over the command control at Clockwise(CW)or Counterclockwise(CCW) at specified speeds.

Technical Advantages ;

- Birel Machinery as standard provides BLP-3AX models in capacities of
- 1,5 - 3 - 5 - 7,5 - 10 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

FEATURES

Welding Arc Group



K

Electrical Cabinet



L

Warning Light



M

Standard Features

- Capability of 360 degree worktable rotation.
- Round Worktable with Slots.
- Vertical Hydraulic Lifting of workpiece is presented as standard.
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Warning Light
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



HMI

PLC-HMI Display Control



WRC

Wireless Remote Control

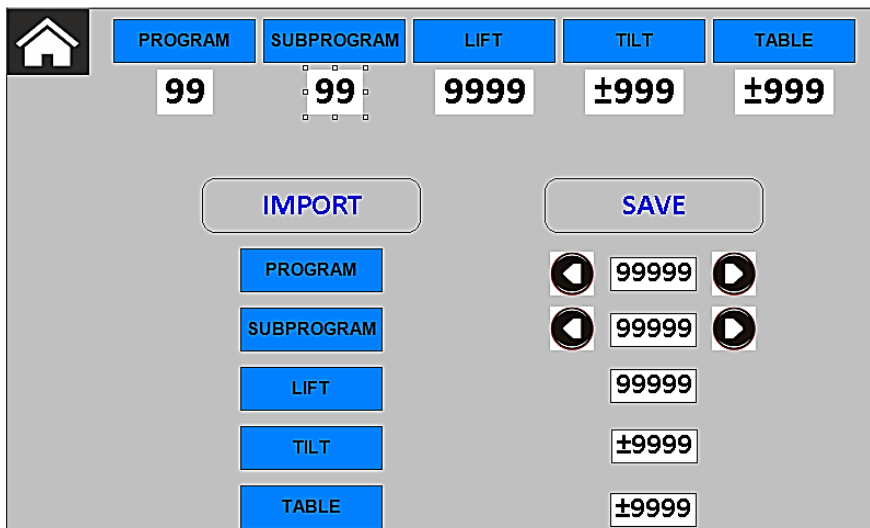


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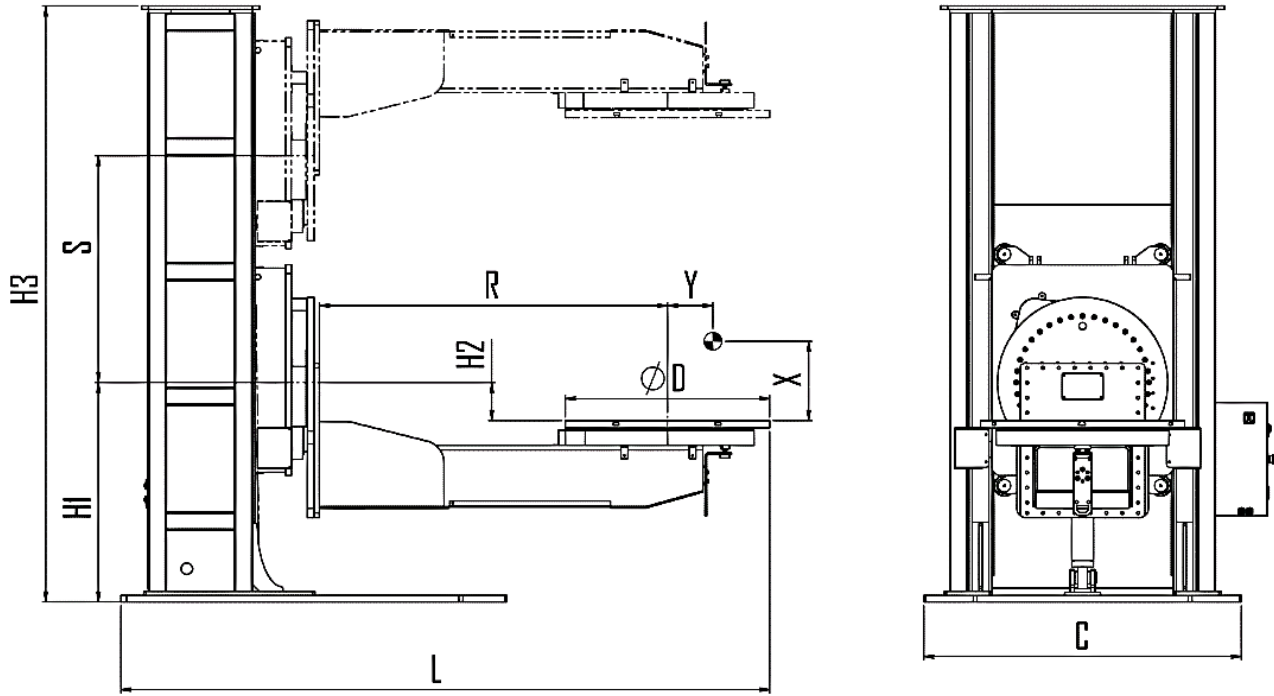
PLC-HMI Display Control



Manual Program (Recipe) Screen ;



❖ All technical specifications are subject to change without prior notice.



Technical Details :

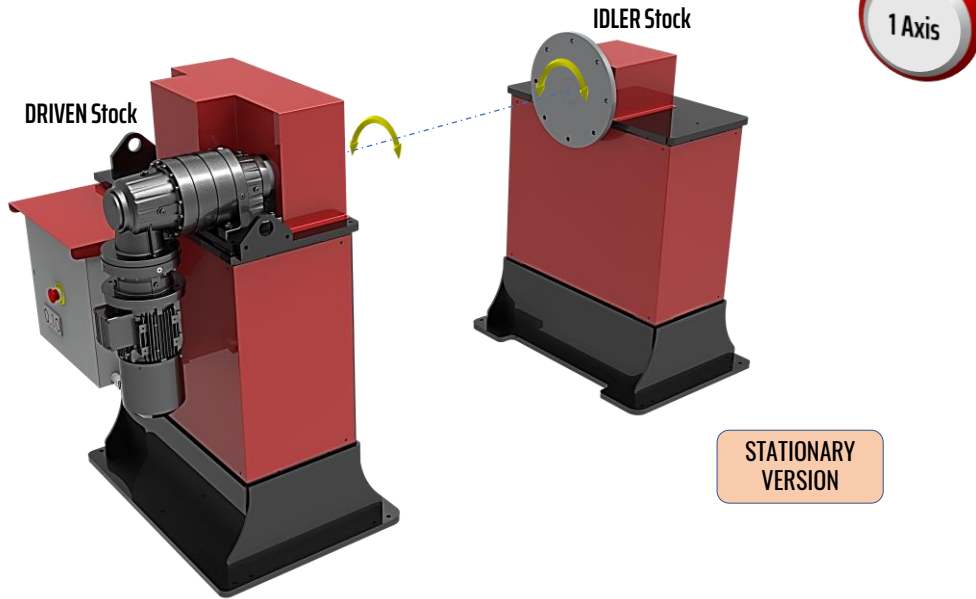
Model :BLP-3AX	Symb	Unit	BLP1,5-3AX	BLP3-3AX	BLP5-3AX	BLP7,5-3AX	BLP10-3AX
Capacity		kg	1 500	3 000	5 000	7 500	10 000
Lift Stroke	S	mm	1000	1100	1100	1200	1300
Working Radius	R	mm	1300	1600	1700	1850	2000
Offset Distance	X-Y	mm	300-150	300-150	450-150	450-150	450-150
Table Diameter	ØD	mm	850	1000	1150	1250	1350
Table Torque		Nm	2260	4550	7500	12050	15000
Table Speed		rpm	0,2-1,4	0,2-1	0,15-0,78	0,05 - 0,50	0,1 - 0,5
Tilt Torque		Nm	3340	6900	14750	19300	24700
Tilt Speed		rpm	0,80	0,55	0,55	0,45	0,45
Lifting Speed		m/min	0,96	0,92	0,67	0,65	0,50
Max.Welding Current		Amp	700	700	1000	1000	1000
Rotating Centre Height	H1	mm	850	1050	1130	1200	1300
Plate Rotating Centre Difference	H2	mm	100	100	230	260	280
Total Height	H3	mm	2720	2900	2960	3250	3480
Total Length	L	mm	2750	3300	3350	3780	4200
Total Width	C	mm	1380	1500	1740	1850	1920
Motor Power of Table		kW	0,55	0,75	1,1	1,1	1,5
Motor Power of Tilting		kW	0,55	0,75	1,5	1,5	1,5 x 2
Hydraulic Motor Power of Lifting		kW	1,1	1,5	1,5	3	3

↪ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

STANDARD: HandBox Cable Remote Control

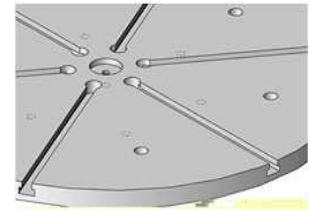


OPTIONAL Modifications & Equipments;

EFFA : Easy Fixture Fixing Apparatus



T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



General Features ;

- BEMS-1AX model 1 axis Head Tail Stock Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- By means of the equipment presented as optional that provides quick mounting-detaching opportunity and having 360° rotation capability provides ergonomical operation environment
- BEMS-1AX chassis positioner is constituted of mutually One(1) driven body & One(1) idler body.
- The operators with BEMS-1AX type positioner, At center axis of worktable Workpiece can be precisely rotated over the command control at Clockwise (CW) or Counterclockwise(CCW) at specified speeds.

Technical Advantages ;

- Birel Machinery as standard provides BEMS-1AX models in capacities of
- 1 - 2 - 3 - 5 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group (Optional)
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Features

- Capability of 360 degree worktable rotation.
- Round Worktable with Holes (Adaptable to EFFA .Apparatus)
- Adjustable worktable rotation.
- Rotational Speed Dijital display on Electrical Cabinet
- 5 m. Command Cable
- 5 m. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)

EFFA

Easy Fixing Fixture Apparatus



OHC

Overhead Hangable Control



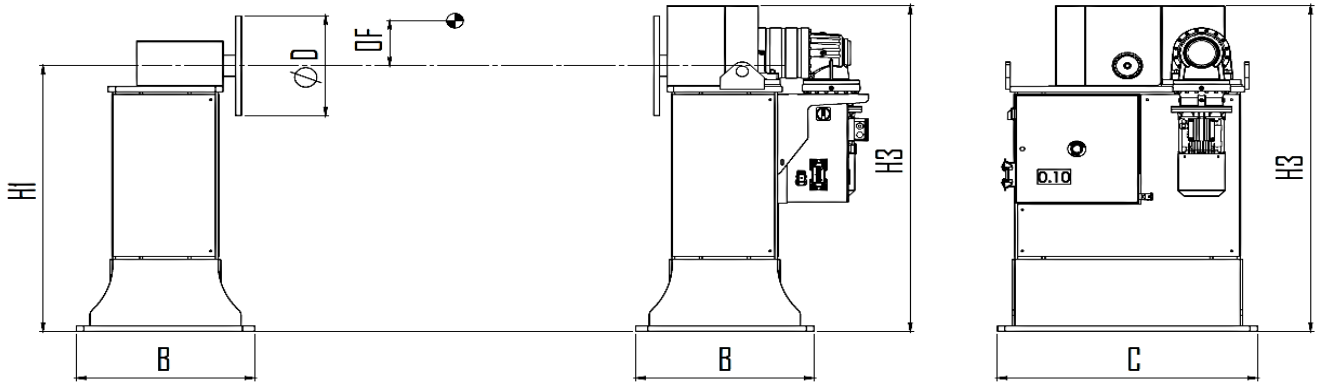
WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

Model : BEM(S)-1AX	Symb.	Unit	BEM1S-1AX	BEM2S-1AX	BEM3S-1AX	BEM5S-1AX
Capacity		kg	1 000	2 000	3 000	5 000
Rotation Speed		rpm	0,2-1,2	0,2-1,15	0,2-1	0,2-1,2
Max.Rotational Torque		Nm	1500	3000	4500	5000
Rotation Axle Height	H1	mm	1000	1000	1000	1250
Offset Distance	OF	mm	150	150	150	100
WorkTable Diameter	ØD	mm	375	375	375	500
Max.Workpiece Diameter		mm	2000	2000	2000	2500
Height	H3	mm	1220	1220	1250	1500
Length	B	mm	520	590	650	670
Width	C	mm	800	860	980	1060
Motor Power of WorkTable		kW	0,37	0,55	0,75	1,1
Weight		kg	590	760	890	1270

↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

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ABOUT PRODUCT

STANDARD: HandBox Cable Remote Control

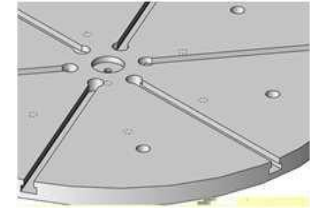
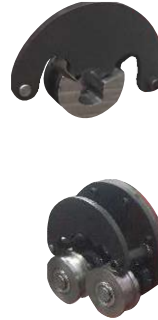


OPTIONAL Modifications & Equipments;

EFFA : Easy Fixture Fixing Apparatus



T-SE :Round Worktable T-Side Entry Grooved Thick Table Plate



General Features ;

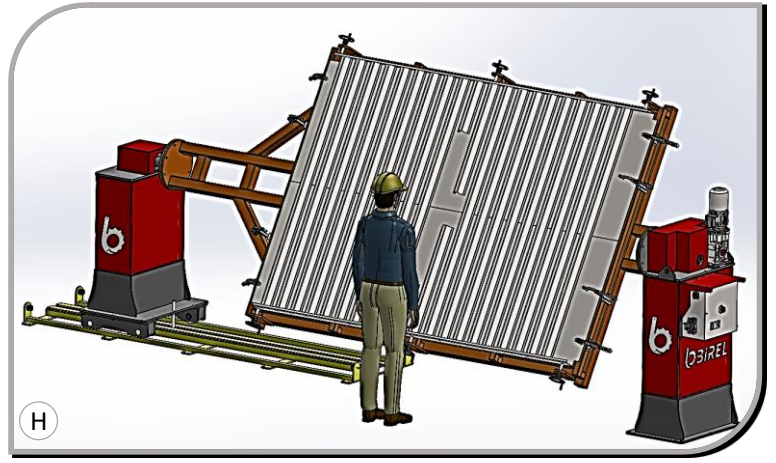
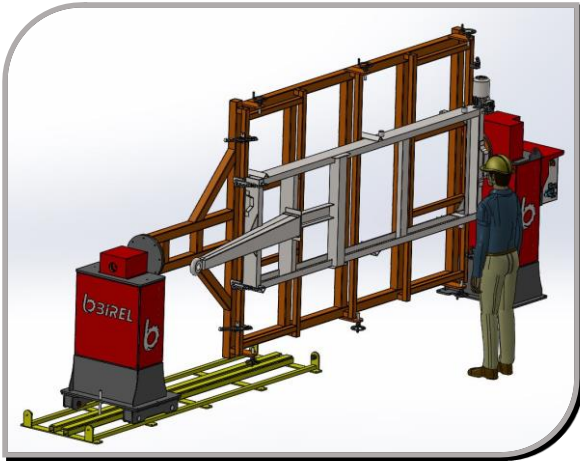
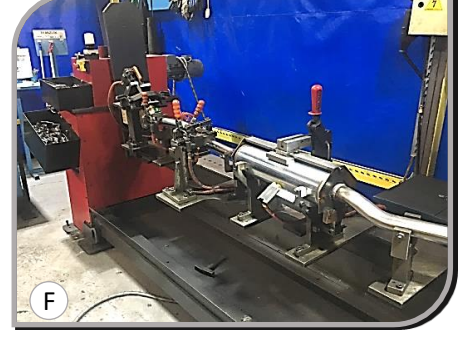
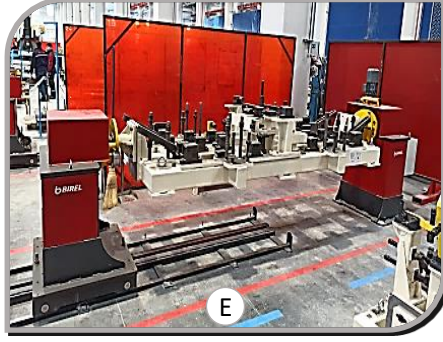
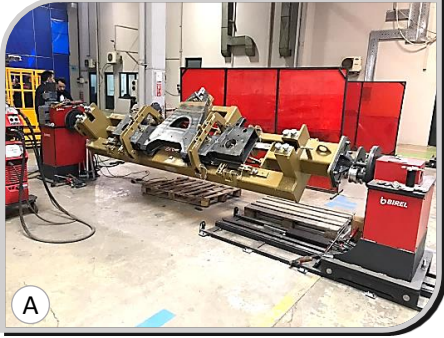
- BEMG-1AX model 1 axis Head Tail Stock Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- By means of the equipment presented as optional that provides quick mounting-detaching opportunity and having 360° rotation capability provides ergonomical operation environment
- BEMG-1AX chassis positioner is constituted of mutually One(1) driven body & One(1) idler body.
- The operators with BEMG-1AX type positioner, At center axis of worktable Workpiece can be precisely rotated over the command control at Clockwise (CW) or Counterclockwise(CCW) at specified speeds.

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Technical Advantages ;

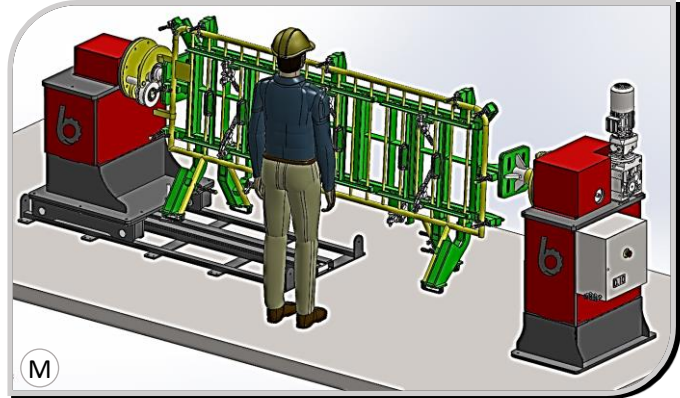
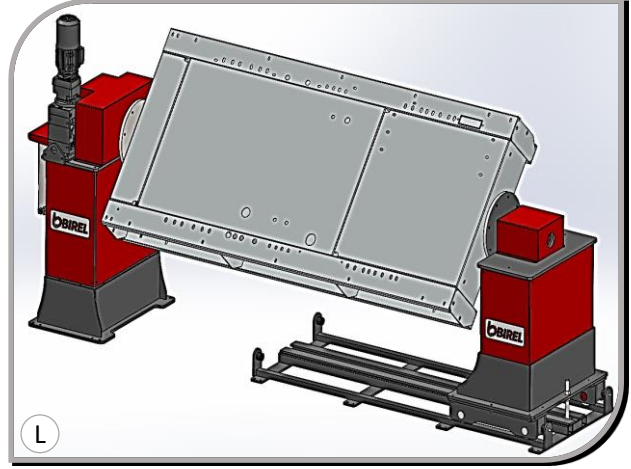
- Birel Machinery as standard provides BEMG-1AX models in capacities of
- 1 - 2 - 3 - 5 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Welding Arc Group (Optional)
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Features

- Capability of 360 degree worktable rotation.
- Round Worktable with Holes (Adaptable to EFFA .Apparatus)
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 m. Command Cable
- 5 m. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

 Double Foot Pedal+Stick+
 Emergency Stop (3 m)


EFFA

Easy Fixture Fixing Apparatus



OHC

Overhead Hangable Control



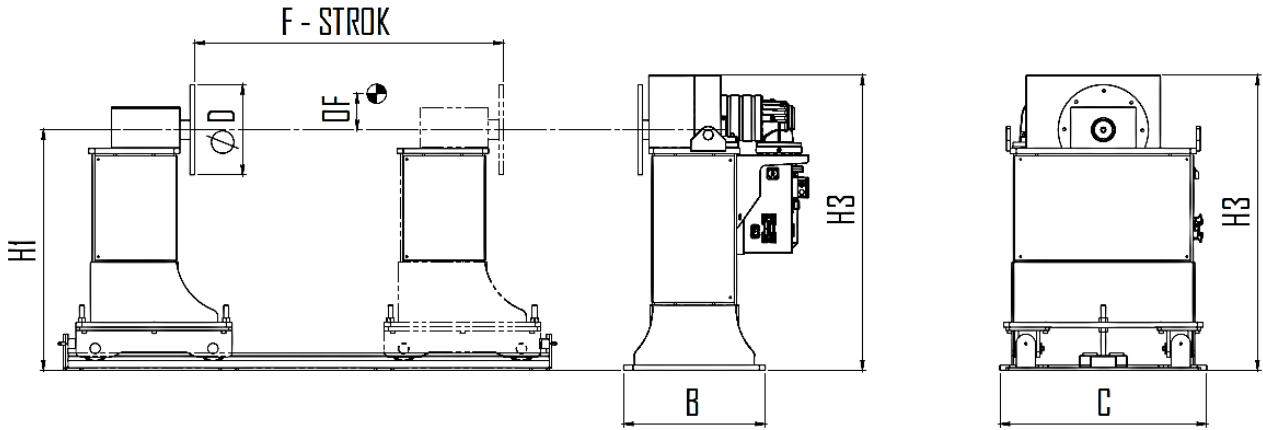
WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

Model : BEMG-1AX	Symb.	Unit	BEM1G-1AX	BEM2G-1AX	BEM3G-1AX	BEM5G-1AX
Capacity		kg	1 000	2 000	3 000	5 000
Rotation Speed		rpm	0,2-1,2	0,2-1,5	0,2-1	0,2-1,2
Max.Rotational Torque		Nm	1500	3000	4500	5000
Rotation Axle Height	H1	mm	1000	1000	1000	1250
Offset Distance	OF	mm	150	150	150	100
WorkTable Diameter	ØD	mm	375	375	375	500
Max.Workpiece Diameter		mm	2000	2000	2000	2500
Height	H3	mm	1220	1220	1250	1500
Length	B	mm	520	590	650	670
Width	C	mm	800	860	980	1060
Rail Type			By Birel			
Rail Stroke (F-STROKE)	F1 - F2	mm	1340	1250	1150	1100
Motor Power of WorkTable		kW	0,37	0,55	0,75	1,1
Weight		kg	590	910	1060	1460

↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

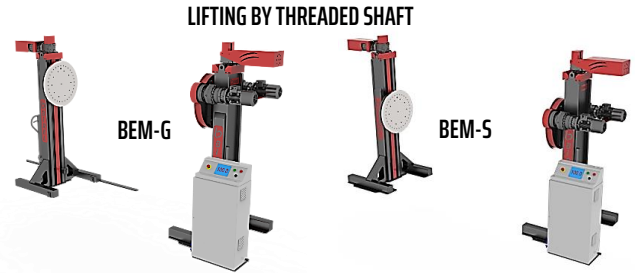
❖ All technical specifications are subject to change without prior notice.



ABOUT PRODUCT

General Features ;

- BEM model 2 axis Chassis Head Tail Stock Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- By means of the apparatus(EFFA) presented as optional that provides quick mounting-detaching opportunity and having 360° rotation capability provides ergonomical operation environment.
- BEM model 2 axis Chassis Head Tail Stock Positioner is constituted of mutually One(1) Driven Head Stock – One(1) idler Tail Stock..
- Mainly used in Railway wagon, truck chassis, trailer chassis and Die-Mold adaptation sectors.
- On HMI control unit Program (recipe) capacity available and under each different Set Values defining opportunity.



Technical Advantages ;

- Birel Machinery as standard provides BEM-2AX models in capacities of 1,5 - 3 - 5 - 6 - 8 - 10 - 12 ton.
- Birel Machinery, out of these standard capacities, according to customer weight & offset(OF) values , at different capacities and sizes, can offer.
- Motor with brake and forced fan cooling.
- Remote Wifi Service Support
- Easy Calibration
- For any special request or project, Please do not hesitate to contact with us.

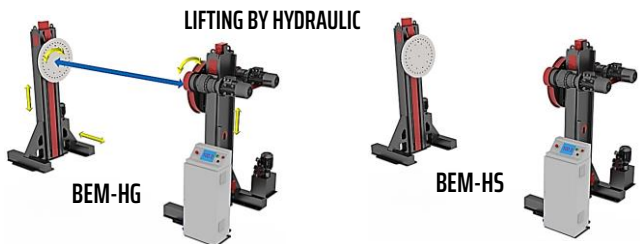
Chassis Positioner Models and Main Properties ;

Model	DESCRIPTION	Stocks		Up & Down Lifting Type		Control
		Driven Stock	Idler Stock	Threaded Shaft	Hydraulic	
BEM-G	Manual MOVABLE Model.....(2+1 Axis)	Stationary	Movable	✓	x	PLC -HMI
BEM-S	Ground STATIONARY Model(2 Axis)	Stationary	Stationary	✓	x	PLC –HMI
BEM-HG	Manual MOVABLE Hydraulic Lift Model..... (2+1 Axis)	Stationary	Movable	x	✓	PLC –HMI
BEM-HS	Ground STATIONARY Hydraulic Lift Model..... (2+1 Axis)	Stationary	Stationary	x	✓	PLC -HMI

① ✓ : Available x : Not Available

Standard Features

- Capability of 360 degree PLC controlled Worktable rotation.
- PLC control system
- On HMI control unit programmable recipe system
- In every location; Positioning & Adjustable worktable rotation speed.
- Light Warning Flip-Flop Siren.
- 5 mt. Command Cable with Handbox cable Control
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Remote Wifi Service Support
- Easy Calibration
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (Wearing Parts Outside of Warranty)



Optional Control Units

EFFA

Easy Fixture Fixing Apparatus

WRC

Wireless Remote Control Unit



❖ All technical specifications are subject to change without prior notice.

BEM

G

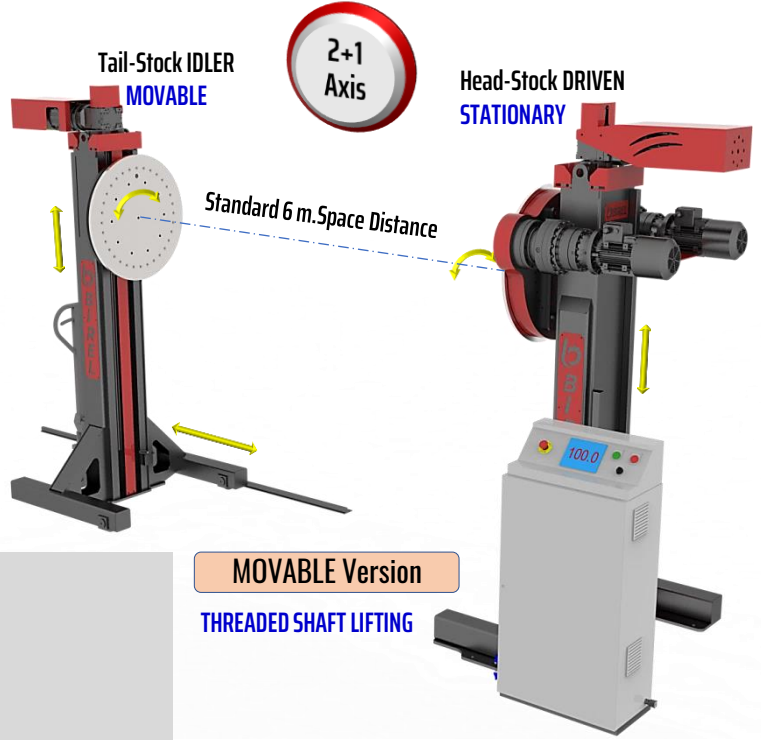
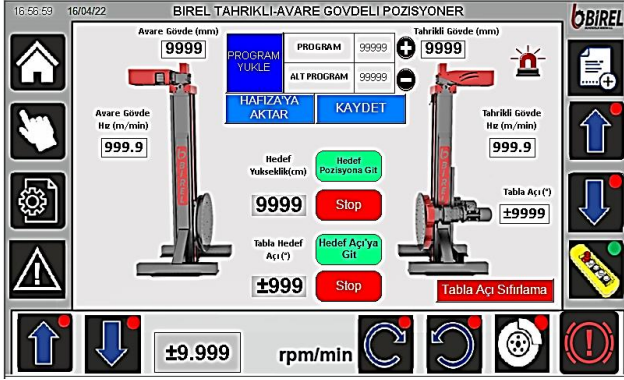
Chapter-A :Positioner Range | A04: Head-Tail Stock

STANDARD-Manual MOVABLE Model CHASSIS Welding Positioner (2+1 Axis)

BIREL
MÜHENDİSLİK MAKİNA A.Ş.

ABOUT PRODUCT

HMI Display :



BEM-G Standard-Manual Movable Model Intended Usage ;

- Suitable for different workpieces having various longitudinal dimensions.
- Low-cost investment.
- Silent Operation.
- Opportunity of Table Rotation Speed adjustment.
- On HMI control unit, program (recipe) capacity and under each different Set Values (Height and Angle) defining opportunity available.

BEM-G
Standard-Movable Type Model

	BEM-1,5G	BEM-3G	BEM-5G	BEM-6G	BEM-8G	BEM-10G	BEM-12G
Capacity (ton)	1,5t	3t	5t	6t	8t	10t	12t
Head Stock Driven	✓	✓	✓	✓	✓	✓	✓
Tail Stock idler	✓	✓	✓	✓	✓	✓	✓
Movable Rail	✓	✓	✓	✓	✓	✓	✓
Lifting by Threaded Shaft	✓	✓	✓	✓	✓	✓	✓

① ✓ : Available X : Not available

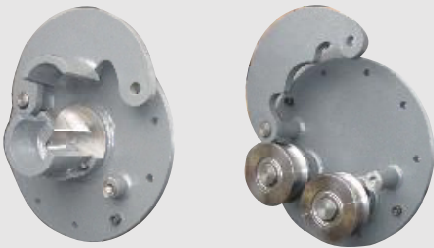
PLC-HMI Display Controlled with HandBox



Optional Control Units

EFLA

Easy Fixing Fixture Apparatus



WRC

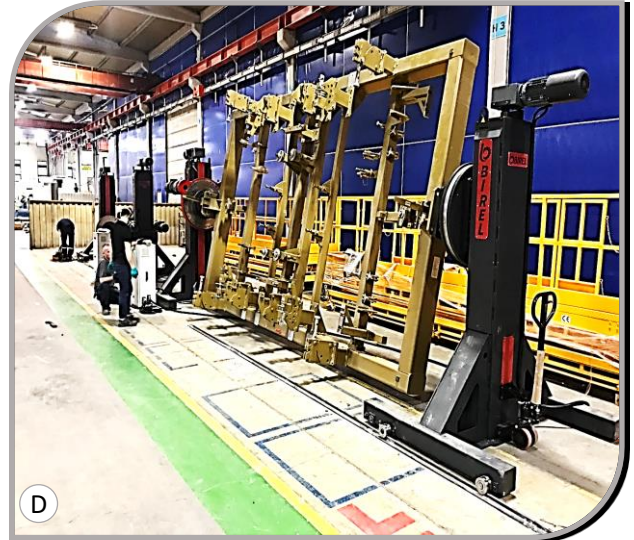
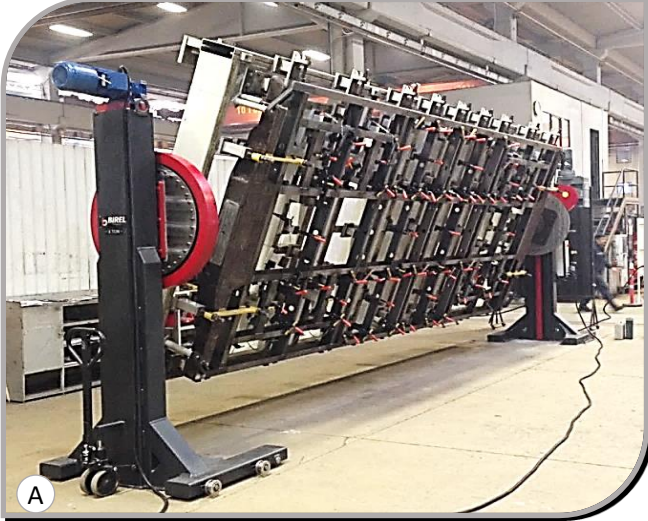
Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

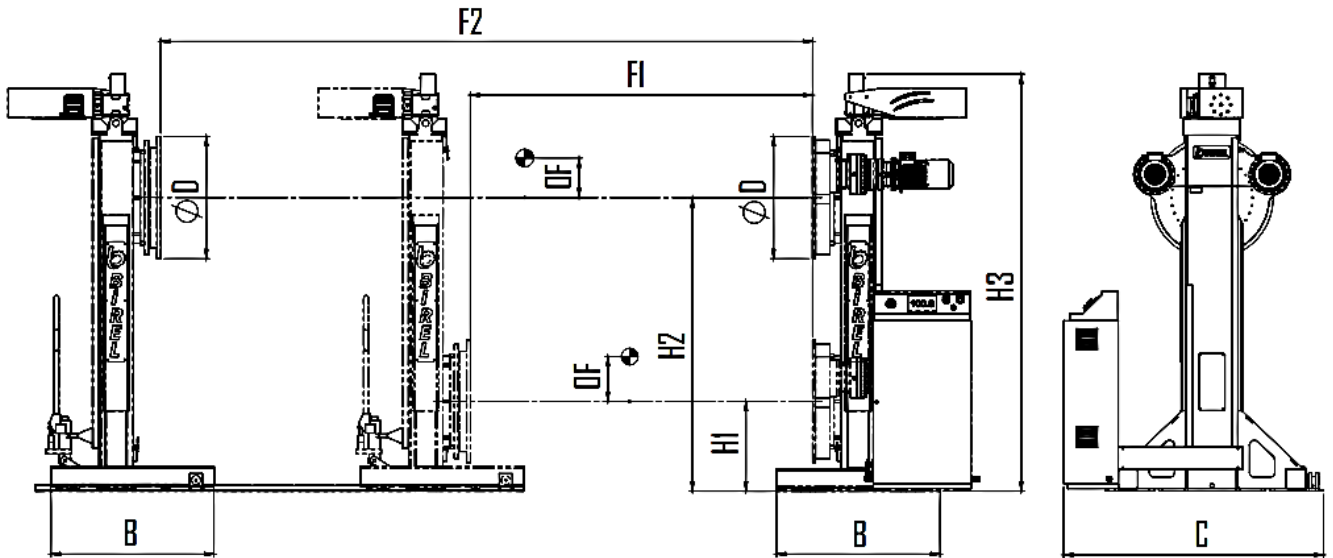
Birel Mühendislik Makine San. Tic. A.Ş. | Adresses: Yaylacık Mahallesi Dogancilar Mevkii 46. Sok. No:4/1 Nilüfer/Bursa – TURKEY
 Tel: +90 (224) 413 0617 Fax: +90 (224) 413 0618 Web : www.birelmuhendislik.com Contact Email : info@birelmuhendislik.com
 Sales: Email: sales@birelmakina.com Direct Mobil: +90.5462016491

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

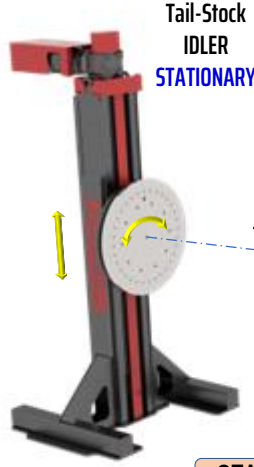
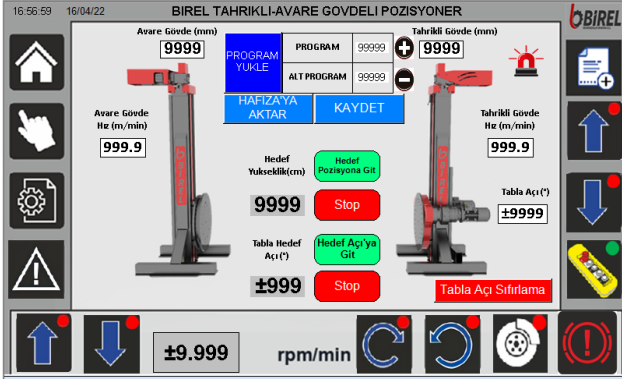
Model No : BEM-G	Symb	Unit	BEM-1,5G	BEM-3G	BEM-5G	BEM-6G	BEM-8G	BEM-10G	BEM-12G
Capacity		kg	1 500	3 000	5 000	6 000	8 000	10 000	12 000
Rotation Speed		rpm	0,2-0,9	0,2-0,9	0,2-0,9	0,2-0,9	0,1-0,68	0,1-0,62	0,1-0,67
Up & Down Speed		mm/min	540	500	500	450	500	450	450
Max.Rotational Torque		Nm	5.000	10.150	17.800	20.550	24.000	30.000	36.000
Up & Down Torque		Nm	200	326	446	490	862	950	950
min-max lifting height		H1-H2	550-1550	550-1550	550-1800	550-1800	550-1800	550-1800	550-2000
Offset Distance	OF	mm	300	300	300	300	300	300	300
Table Plate Diameter	ØD	mm	575	650	750	750	750	850	1.000
Max.Workpiece Diameter		mm	2.800	2.800	3.600	3.600	3.600	3.600	4.000
Height	H3	mm	2.240	2.260	2.560	2.560	2.580	2.580	2.790
Length	B	mm	850	850	1.000	1.000	1.000	1.000	1.000
Width	C	mm	1.530	1.530	1.570	1.570	1.570	1.640	1.680
Motor Power of Table		kW	0,75 x 1	1,5 x 1	1,5 x 2	1,5 x 2	1,5 x 2	1,5 x 2	2,2 x 2
Motor Power of Lifting		kW	0,75 x 2	1,1 x 2	1,5 x 2	1,5 x 2	3 x 2	3 x 2	3 x 2
Rail Type			By Birel						
Rail Stroke	F1 - F2	mm	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000
Weight		kg	1.400	1.570	2.000	2.030	2.220	2.400	2.630

↳ Out of these standard. capacities, Birel Machinery, according to customer weight & Offset (OF) values , can offer at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

HMI Display :



Head-Stock DRIVEN STATIONARY



STATIONARY Version

THREADED SHAFT LIFTING

BEM-5 Ground Stationary Model Intended Usage ;

- Suitable for workpieces not having different longitudinal dimensions.
- Low-cost investment.
- Silent Operation.
- Opportunity of Table Rotation Speed adjustment.
- On HMI control unit, program (recipe) capacity and under each different Set Values (Height and Angle) defining opportunity available.

BEM-5 Ground Stationary Model

	BEM-1,5S	BEM-3S	BEM-5S	BEM-6S	BEM-8S	BEM-10S	BEM-12S
Capacity (ton)	1,5t	3t	5t	6t	8t	10t	12t
Head Stock Driven	✓	✓	✓	✓	✓	✓	✓
Tail Stock idler	✓	✓	✓	✓	✓	✓	✓
Movable Rail	X	X	X	X	X	X	X
Lifting by Threaded Shaft	✓	✓	✓	✓	✓	✓	✓

① ✓ : Available x : Not available

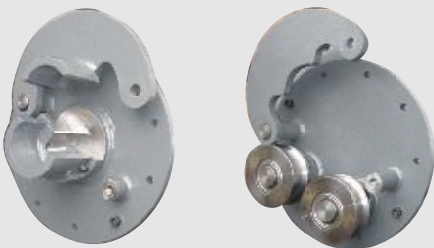
PLC-HMI Display Controlled with HandBox



Optional Control Units

EFFA

Easy Fixing Fixture Apparatus



WRC

Wireless Remote Control



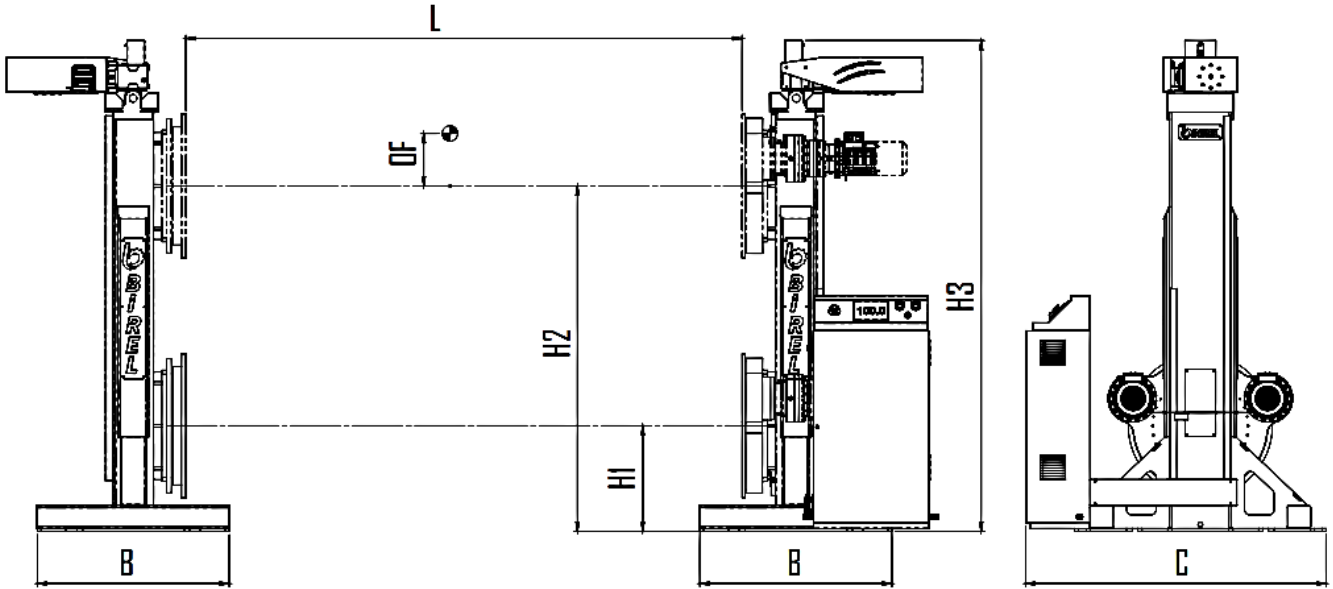
❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

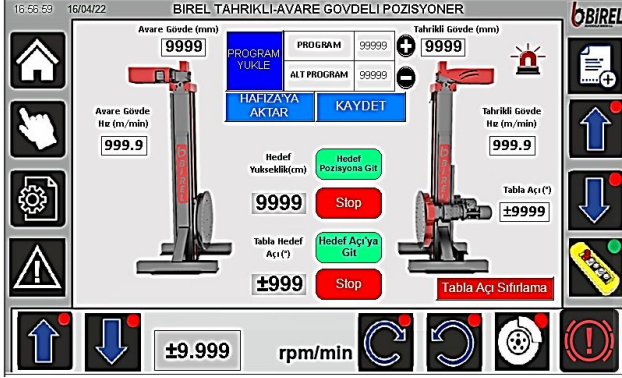
Model No : BEM-S	Symb	Unit	BEM-1,5S	BEM-3S	BEM-5S	BEM-6S	BEM-8S	BEM-10S	BEM-12S
Capacity		kg	1 500	3 000	5 000	6 000	8 000	10 000	12 000
Rotation Speed		rpm	0,2-0,9	0,2-0,9	0,2-0,9	0,2-0,9	0,1-0,68	0,1-0,62	0,1-0,67
Up & Down Speed		mm/min	540	500	500	450	500	450	450
Max.Rotational Torque		Nm	5.000	10.150	17.800	20.550	24.000	30.000	36.000
Up & Down Torque		Nm	200	326	446	490	862	950	950
min-max lifting height		H1-H2	550-1550	550-1550	550-1800	550-1800	550-1800	550-1800	550-2000
Offset Distance	OF	mm	300	300	300	300	300	300	300
Table Plate Diameter	ØD	mm	575	650	750	750	750	850	1.000
Max.Workpiece Diameter		mm	2.800	2.800	3.600	3.600	3.600	3.600	4.000
Height	H3	mm	2.240	2.260	2.560	2.560	2.580	2.580	2.790
Length	B	mm	850	850	1.000	1.000	1.000	1.000	1.000
Width	C	mm	1.455	1.530	1.570	1.570	1.570	1.640	1.680
Space Distance	L	mm	6.000	6.000	6.000	6.000	6.000	6.000	6.000
Motor Power of Table		kW	0,75x1	1,5x1	1,5x2	1,5x2	1,5x2	1,5x2	2,2x2
Motor Power of Lifting		kW	0,75x2	1,1x2	1,5x2	1,5x2	3x2	3x2	3x2
Weight		kg	1.370	1.540	1.970	2.000	2.190	2.370	2.600

↳ Out of these standard. capacities, Birel Machinery, according to customer weight & Offset (OF) values , Birel machinery can offer at different capacities, sizes.

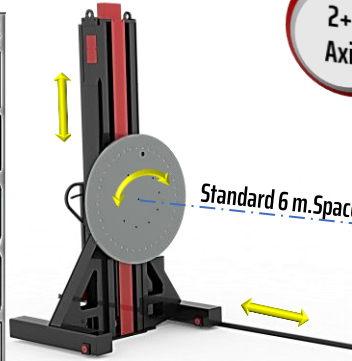
❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

HMI Display :



IDLER Stock
MOVABLE



DRIVEN Stock
STATIONARY



2+1
Axis

Standard 6 m.Space Distance

MOVABLE Version
HYDRAULIC Lifting

BEM-HG Standard MOVABLE Hydraulic Lift Model Intended Usage ;

- Hydraulic Model is long life.
- Suitable for different workpieces having various longitudinal dimensions.
- Suitable for dusty working environments.
- Silent Operation.
- Opportunity of Table Rotation Speed adjustment.
- On HMI control unit, program (recipe) capacity and under each different Set Values (Height and Angle) defining opportunity available.

BEM-H

**Ground Stationary Hydraulic
Lifting Model**

Capacity (ton)	BEM-5H	BEM-6H	BEM-8H	BEM-10H	BEM-12H
Head Stock Driven	✓	✓	✓	✓	✓
Tail Stock idler	✓	✓	✓	✓	✓
Movable Rail	✓	✓	✓	✓	✓
Lifting by Hydraulic	✓	✓	✓	✓	✓

✓ : Available x : Not available

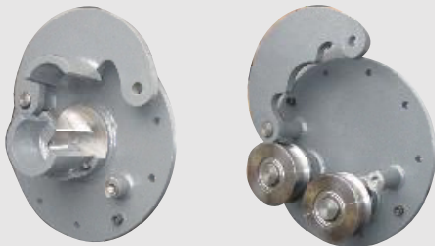
PLC-HMI Display Controlled with HandBox



Optional Control Units

EFFA

Easy Fixture Apparatus



DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



WRC

Wireless Remote Control



MP

Master Panel



OHC

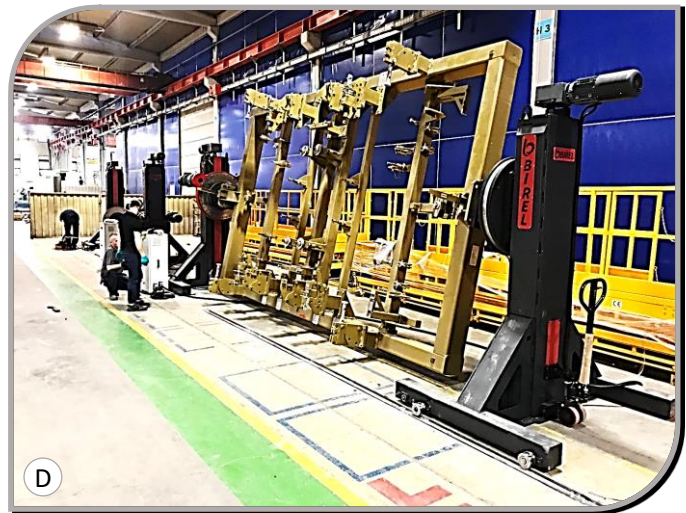
Overhead Hangable Control



❖ All technical specifications are subject to change without prior notice.

BEM**HG**

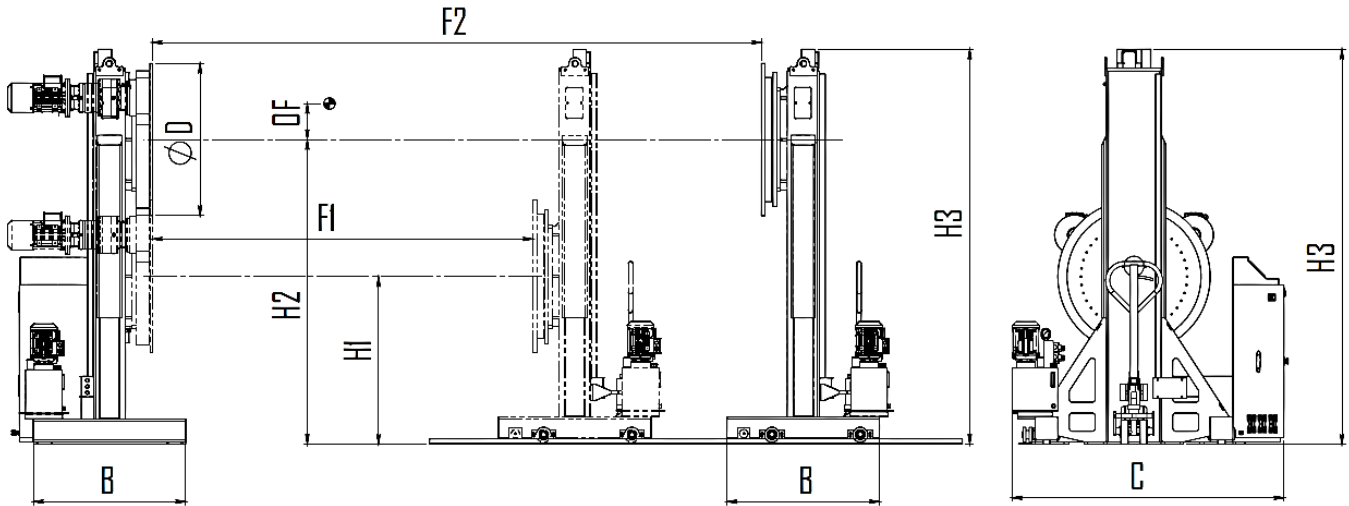
Chapter-A :Positioner Range | A04: Head-Tail Stock

STANDARD – MOVABLE HYDRAULIC LIFT Model CHASSIS Welding Positioner (2+1)AX**BIREL**
MÜHENDİSLİK MAKİNA A.Ş.**ILLUSTRATIONS**

❖ All technical specifications are subject to change without prior notice.

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Sales: Email: sales@birelmakina.com Direct Mobil: +90.5462016491

TECHNICAL PROPERTIES



Technical Details :

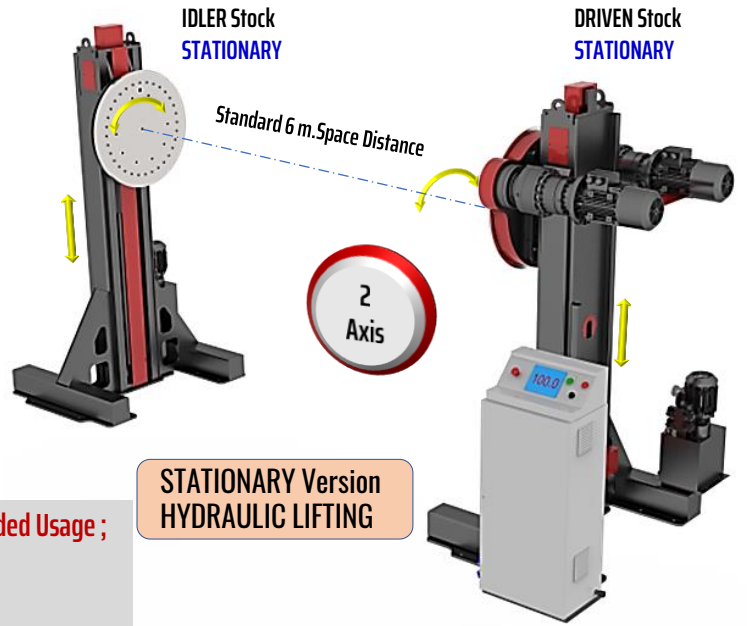
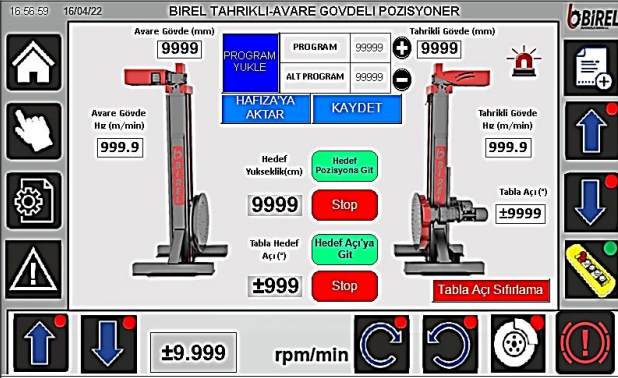
Model No : BEM-HG	Symb	Unit	BEM1,5HG	BEM-3HG	BEM-5HG	BEM-6HG	BEM-8HG	BEM-10HG	BEM-12HG	BEM15HG	BEM-20HG	BEM-30G
Capacity		kg	1 500	3 000	5 000	6 000	8 000	10 000	12 000	15 000	20 000	30 000
Rotation speed		rpm	0,2 -1	0,2 - 0,9	0,2 - 0,9	0,2 - 0,9	0,1 - 0,68	0,1 - 0,62	0,1 - 0,67	0,1 - 0,63	0,1-0,65	0,1-0,65
Up & Down Time		mm/min	2400	1500	930	930	770	770	770	770	570	495
Max. rotational torque		Nm	5000	10150	17800	20550	24000	30000	36000	42000	45000	45000
min-max lifting height	H1-H2	mm	550 - 1350	650 - 1550	900-1800	900-1800	900-1800	900-1800	1100-2000	1100-2000	1100-2000	1100-2000
Offset distance	OF	OF	300	300	300	300	300	300	300	250	200	150
Table plate diameter	$\varnothing D$	mm	575	650	750	750	750	850	1000	1000	1050	1100
Max workpiece diameter		mm	2700	3100	3600	3600	3600	3600	4000	4000	4000	4000
Height	H3	mm	2150	2350	2430	2430	2430	2430	2600	2600	2600	2850
Length	B	mm	850	850	1000	1000	1000	1000	1000	1000	1100	1500
Width	C	mm	1550	1600	1670	1670	1670	1740	1790	2120	2210	2290
Rail Stroke	F1 -F2	mm	4000 -6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000	4000-6000
Rail Type			By Birel									
Motor Power of Table		(kW)	0,75 x1	1,5x1	1,5 x 2	1,5 x 2	1,5 x 2	1,5 x 2	2,2 x 2	2,2 x 2	2,2 x 2	3 x 2
Motor Power of Hydraulic Unit		(kW)	1,1 x 2	1,1 x 2	1,1 x 2	1,5 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2

↳ Out of these standard. capacities, Birel Machinery, according to customer weight & Offset (OF) values , Birel machinery can offer at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

HMI Display :



STATIONARY Version HYDRAULIC LIFTING

BEM-H(S) Ground Stationary Version Hydraulic Lift Model Intended Usage ;

- Hydraulic Model is long life.
- Suitable for dusty working environments.
- Silent Operation.
- Opportunity of Table Rotation Speed adjustment.
- On HMI control unit, program (recipe) capacity and under each different Set Values (Height and Angle) defining opportunity available.

PLC-HMI Display Controlled with HandBox



BEM-H(S) Ground STATIONARY Version Hydraulic Lift Model

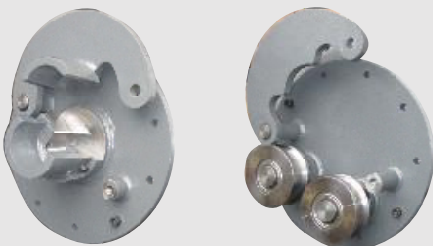
	BEM-5H(S)	BEM-6H(S)	BEM-8H(S)	BEM-10H(S)	BEM-12H(S)
Capacity (ton)	5t	6t	8t	10t	12t
Head Stock Driven	✓	✓	✓	✓	✓
Tail Stock idler	✓	✓	✓	✓	✓
Movable Rail	X	X	X	X	X
Lifting by Hydraulic	✓	✓	✓	✓	✓

① ✓ : Available x : Not available

Optional Control Units

EFFA

Easy Fixture Fixing Apparatus



DFPSE

Double Foot Pedal+Stick+ Emergency Stop (3 m)



WRC

Wireless Remote Control



MP

Master Panel



OHC

Overhead Hangable Control



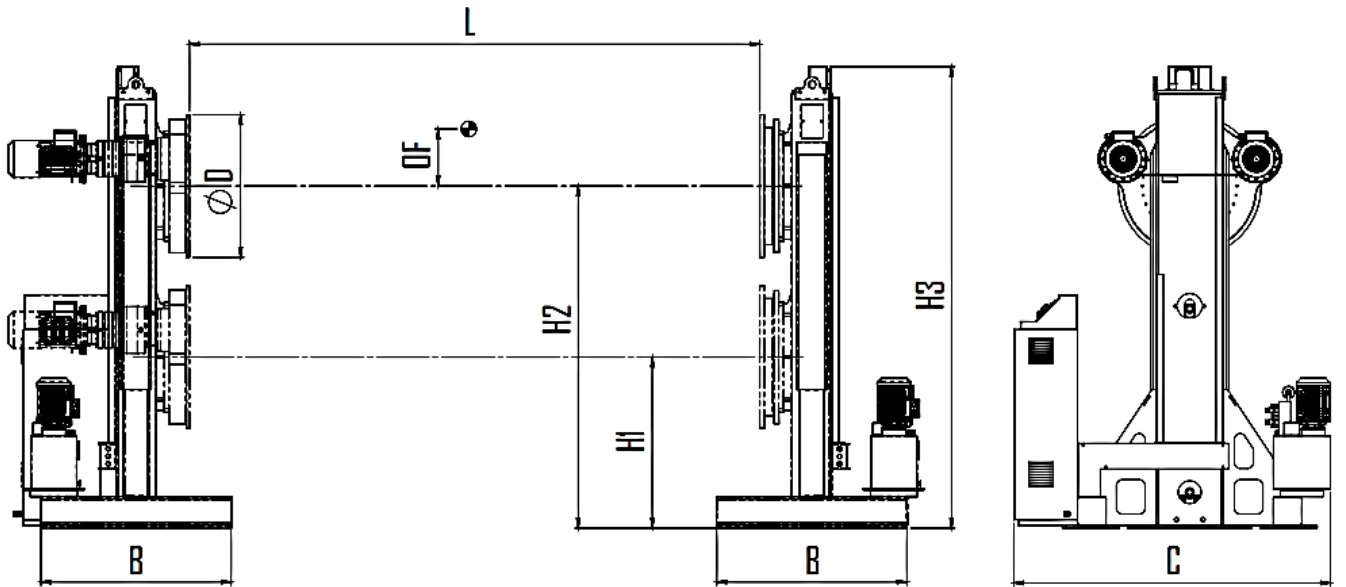
❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

Model No : BEM-HS	Symb	Unit	BEM-1,5HS	BEM-3HS	BEM-5HS	BEM-6HS	BEM-8HS	BEM-10HS	BEM-12HS	BEM15HS	BEM-20HS	BEM-30HS
Capacity		kg	1 500	3 000	5 000	6 000	8 000	10 000	12 000	15 000	20 000	30 000
Rotation speed		rpm	0,2 0,1	0,2 – 0,9	0,2 – 0,9	0,2 – 0,9	0,1 – 0,68	0,1 – 0,62	0,1 – 0,67	0,1 – 0,63	0,-0,65	0,1-0,74
Up&Down Time		mm/min	2400	1500	930	930	770	770	770	770	570	495
Max. rotational torque		Nm	5000	10150	17800	20550	24000	30000	36000	42000	45000	45000
min-max lifting height	H1-H2	mm	550-1350	650 – 1550	900-1800	900-1800	900-1800	900-1800	1100-2000	1100 -1200	1100-2000	1100-1200
Offset distance	OF	OF	300	300	300	300	300	300	300	250	200	150
Table plate diameter	ØD	mm	575	650	750	750	750	850	1000	1000	1050	1100
Max workpiece diameter		mm	2700	3100	2600	3600	3600	3600	4000	4000	4000	4000
Height	H3	mm	2150	2350	2430	2430	2430	2430	2600	2600	2600	2850
Length	B	mm	850	850	1000	1000	1000	1000	1000	1000	1100	1500
Width	C	mm	1455	1600	1670	1670	1670	1740	1790	2120	2210	2290
Space Distance	L	mm	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
Motor Power of Table		(kW)	0,75 x 1	1,5x1	1,5 x 2	1,5 x 2	1,5 x 2	1,5 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2
Motor Power of Hydraulic Unit		(kW)	1,1 x 2	1,1 x 2	1,1 x 2	1,5 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2	2,2 x 2

↳ Out of these standard. capacities, Birel Machinery, according to customer weight & Offset (OF) values , Birel machinery can offer at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

General Features ;

- BSP-H-3AX model 3 axis Head Tail Stock Positioner, Regardless of any geometric shape within dimensions of the machine, In favour of being able to position and generating remarkable welding edges to all workpieces are qualified & ideal solutions. Ensures utmost capability of welding & likewise assembling at 360° degree of any required position .
- Designed in best suitable configuration to perform safe positioning of the workpieces having asymmetry & higher probability of overturn.
- Avoids of crane operations that are part handling, rotating of parts, etc. during production, Provides the opportunity of using operator's working power to use more effectively by minimizing time loss and it increases the efficiency of work.
- BSP-H-3AX model positioner with robust construction & easy controlling ability, Provides the opportunity of comfortable working to operator & improves the quality of welding.
- The operators with BSP-H-3AX type positioner, At center axis of worktable Workpiece can be precisely rotated over the command control at Clockwise (CW) or Counterclockwise(CCW) at specified speeds.

Technical Advantages ;

- Birel Machinery as standard provides BSP-H-3AX models in capacities of 7,5 - 10 ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Lifting is hydraulically performed.
- Motor with brake and forced fan cooling.
- Allow quick connection of workpieces by using " T " slots on worktable (Optional)
- For any special request or project, Please do not hesitate to contact with us.

Standard Features

- Capability of 360 degree worktable rotation.
- BSP-H-3AX Vertical Movements by Hydraulic Lifting .
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt. Command Cable
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Welding Arc Group
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.

BSP-H 3AX

Chapter-A :Positioner Range | A03: Head-Tail Stock

Bridge Type Head-Tail Stock HYDRAULIC LIFT Positioner Model (3AX)



ILLUSTRATIONS

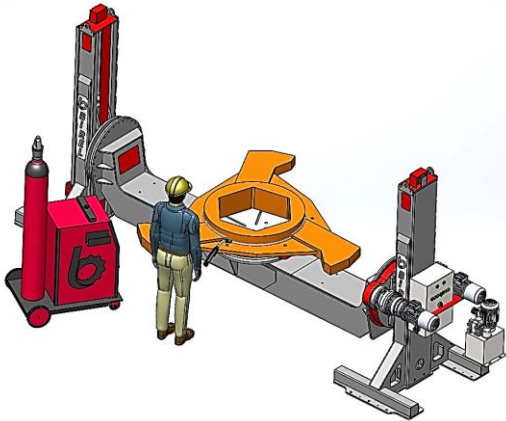
BRIDGE Type
HYDRAULIC LIFTING

3 Axis



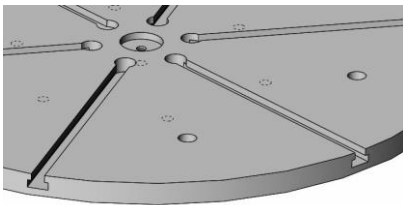
Up and Down Movements by Hydraulic

PLC-HMI Display Controlled with HandBox



OPTIONAL Modifications & Equipments

T-SE :Round Worktable T-Side Entry Grooved
Thick Table Plate



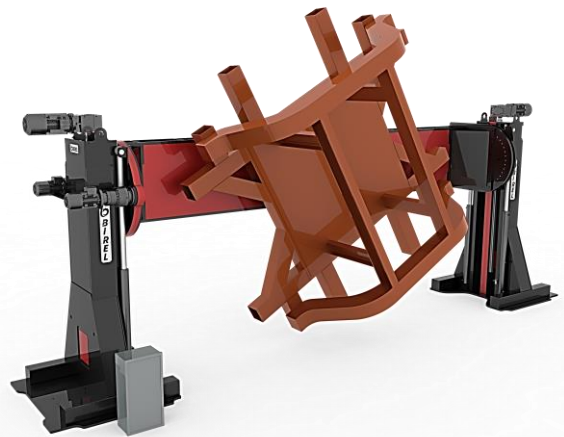
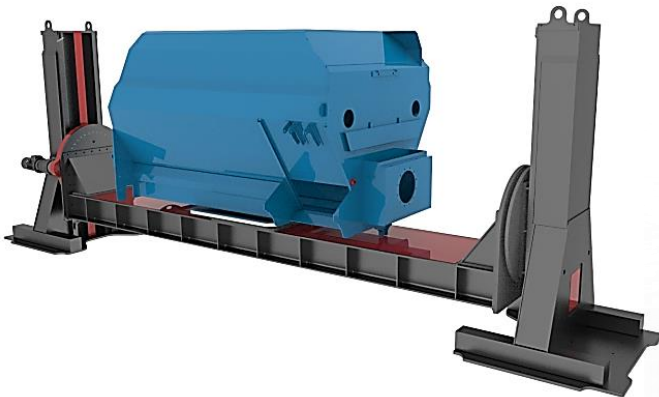
OC-T:Octagonal Table



MC:Manual Chuck



BGR-3 Jaw Manual Pipe Chuck



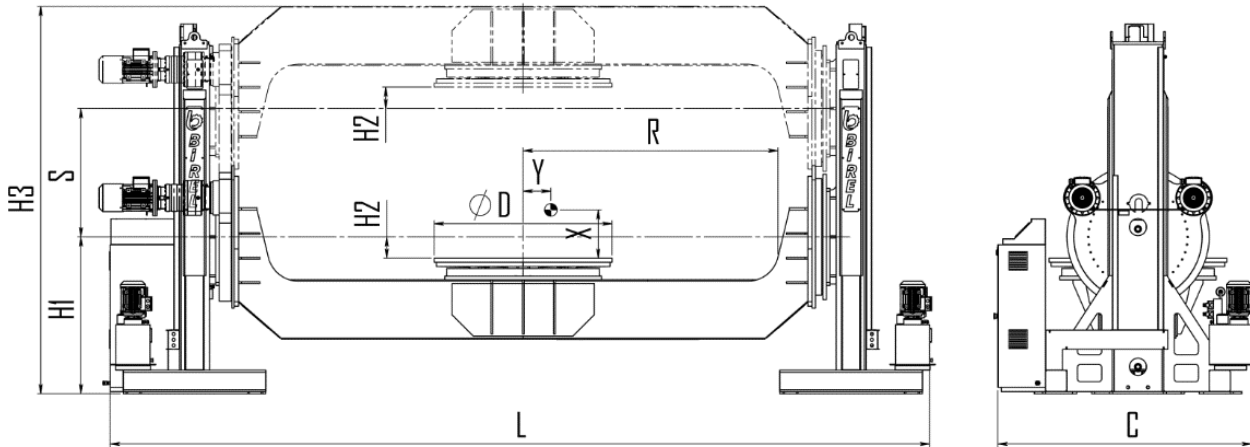
❖ All technical specifications are subject to change without prior notice.

BSP-H 3AX

Chapter-A :Positioner Range | A03: Head-Tail Stock

Bridge Type Head-Tail Stock HYDRAULIC LIFT Positioner Model (3AX)

TECHNICAL PROPERTIES



Technical Details :

Model : BSP-H	Symb	Unit	BSP-7,5H	BSP-10H
Capacity		kg	7 500	10 000
Rotation Speed		rpm	0,1- 0,66	0,1 - 0,50
Tilting Speed		rpm	0,5	0,5
Up & Down Time		sec	80	90
Rotational Torque		Nm	12050	15050
Tilt Torque		Nm	25100	33400
Offset	X - Y	mm	500 -150	500 - 150
Table Plate Diameter	ØD	mm	1250	1350
Working Radius	R	mm	3400 x 2	3400 x2
Tilt Center Height	H1	mm	1100	1100
Table-Rotating Center Difference	H2	mm	250	250
Lifting Stroke	S	mm	1000	1000
Height	H3	mm	2750	2800
Total Length	L	mm	9250	9290
Total Width	C	kW	1850	2000
Motor Power of Table		kW	1,5 x 1	1,5 x 1
Motor Power of Tilting		kW	1,5 x 2	2,2 x 2
Motor Power of Lifting (Hydraulic Lift)		kg	1,5 x 2	2,2 x 2

↪ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT



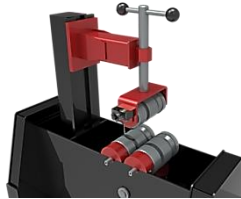
Height
Adjustable
By Handwheel



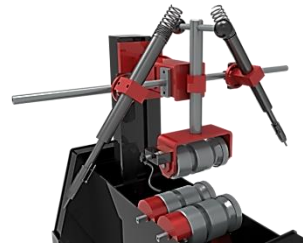
A

OPTIONAL Modifications & Equipments;

M01: Manual Upper Pressing



M02: Welding Torch Holder



General Features ;

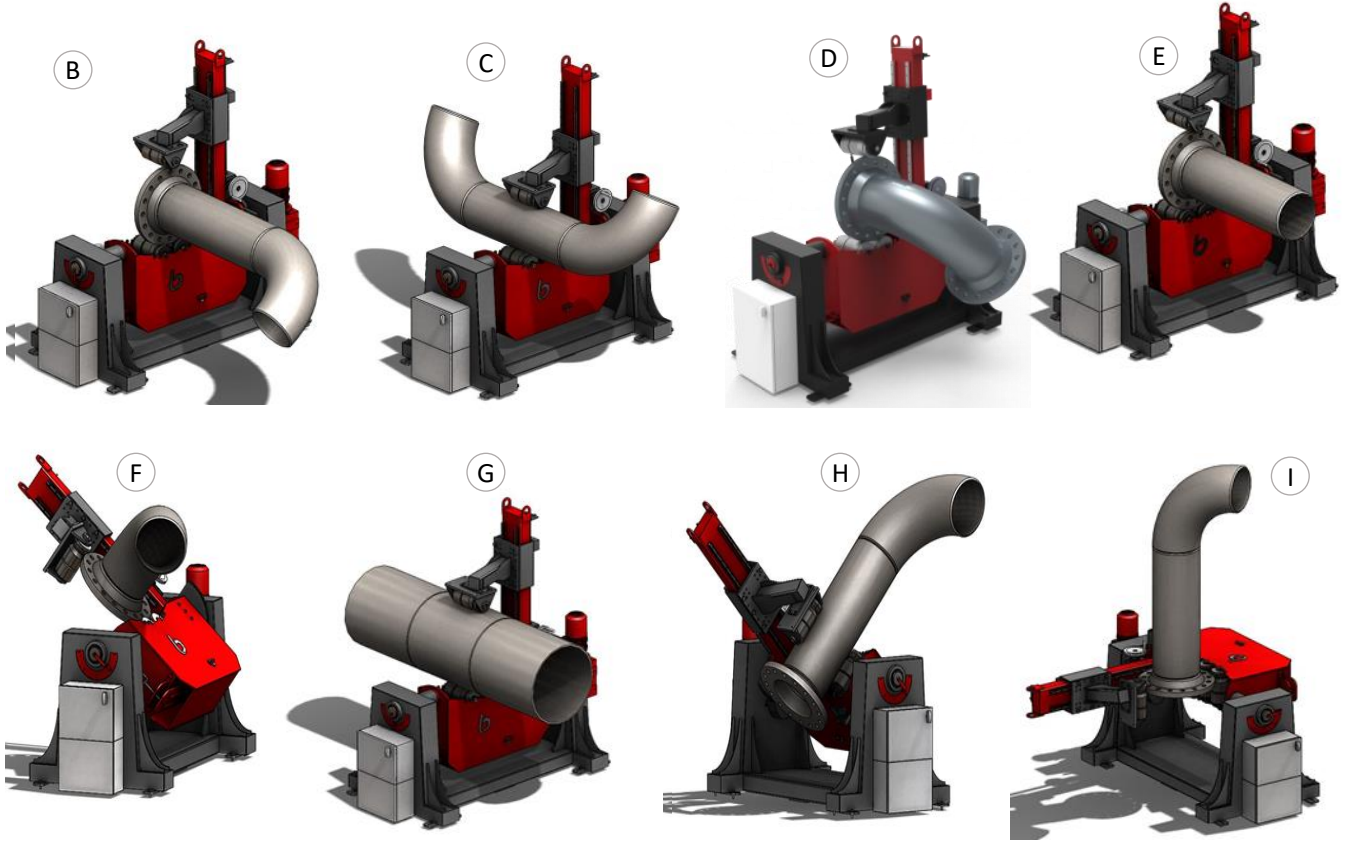
- BPP model Pipe positioner is used for the purpose of rotation and tilting of pipes with round profiles in manual or automatic welding, mainly in the field of pipe construction, prefabrication and assembly on site.
- Due to rotation of pipe, No interruption is observed in circumferential welding of pipe.
- BPP model Pipe Positioner, as standard, Up and down movement for diameter adjustment is performed mechanically by Manual Wheel. Upon request, Optionally, A quick mounting-detaching equipments can be provided.
- BPP model Pipe Positioner has the capability of tilting in both directions +90°-0°-90° degree (i.e : Opportunity of precisely controlled rotation speeds both in clockwise(CW) or Counterclockwise(CCW) directions.
- BPP model Pipe positioner includes One(1) driven unit as worktable and One(1) unit as idler, upper press.

Technical Advantages ;

- Birel Machinery as standard provides BPP models in capacities of 300 - 500 - 750 - 1500 - 3000 kg..
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

APPLICATION ILLUSTRATIONS



Standard Features

- Capability of +90-0-90 degree Worktable rotation.
- Up & Down movements for Diameter adjustment are provided by means of manually operated mechanical wheel as standard.
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control

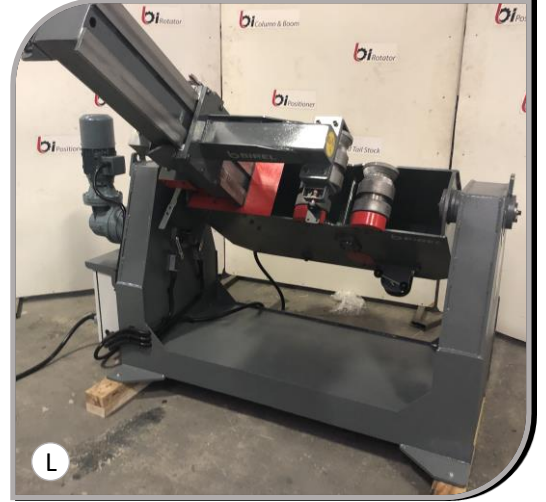


WRC

Wireless Remote Control



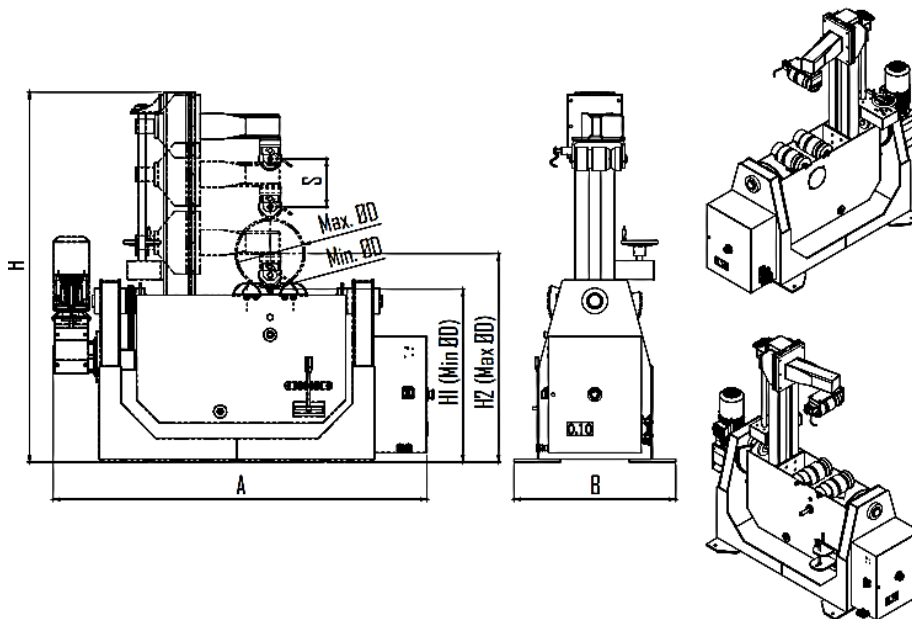
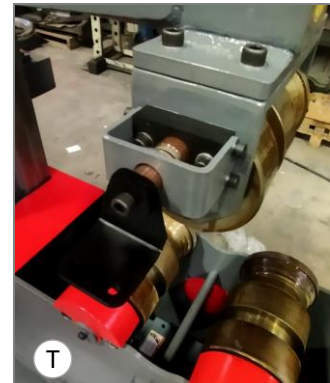
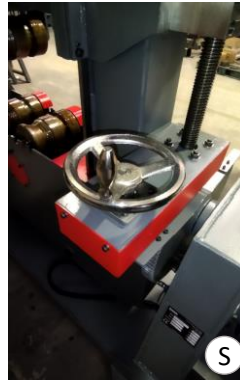
❖ All technical specifications are subject to change without prior notice.



❖ All technical specifications are subject to change without prior notice.

Birel Mühendislik Makine San. Tic. A.Ş. | Adresses: Yaylacık Mahallesi Dogancilar Mevkii 46. Sok. No:4/1 Nilüfer/Bursa – TURKEY
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Sales: Email: sales@birelmakina.com Direct Mobil: +90.5462016491

TECHNICAL PROPERTIES



Technical Details :

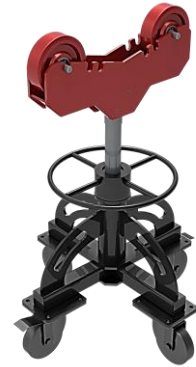
Model No : BPP	Symb	Unit	BPP-300	BPP-500	BPP-750	BPP-1000	BPP-1500
Capacity		kg	300	500	750	1 000	1 500
Rotation Speed		mm/min	200 - 1350	200 - 1350	200-1360	200 - 1360	200-1380
Rotation Torque		Nm	260	300	520	740	1050
Tilting Torque		Nm	1680	2130	3340	4150	6540
Pipe Diameter	Ø	mm	20 - 325	20 - 410	35- 460	60 - 510	60 - 610
Roller Material			Steel	Steel	Steel	Steel	Steel
Length	A	mm	1440	1500	1800	2020	2140
Width	B	mm	700	740	840	940	1150
Height	H	mm	1645	1730	1880	2050	2245
Height of Pipe Center - Min.ØD	H1	mm	800	800	890	1000	1095
Height of Pipe Center - Max.ØD	H2	mm	945	990	1090	1215	1360
Loading Strok	S	mm	200	200	200	200	200
Total Motor Power		kW	0,62	0,8	0,8	1	1,12

❖ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



•OPTIONAL: BBT-500 Tube Holder



Standard Features

- Capability of 360 degree Worktable rotation.
- Adjustable Height by Manual lift
- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt.Handbox Cable Remote Control
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power supply :380V - (3 phase+Neutral+Earthing)
- Welding Earthing Group
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control

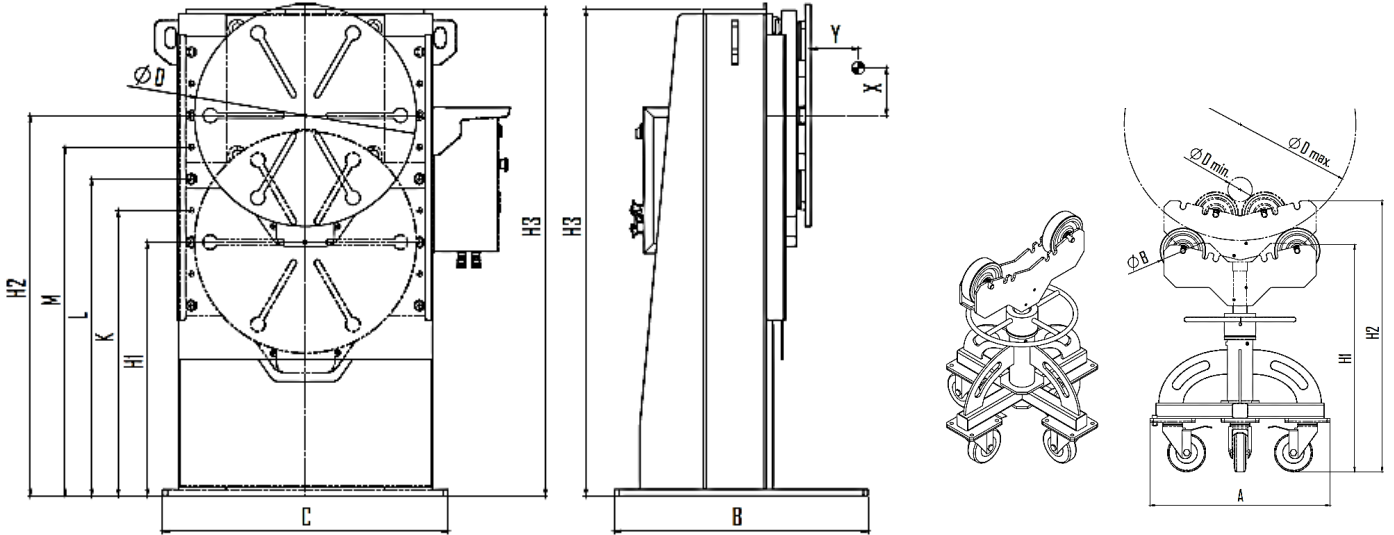


WRC

Wireless Remote Control



❖ All technical specifications are subject to change without prior notice.



Technical Details :

Model No : BTP	Symb	Unit	BTP1,5-2AX
Capacity		kg	1 500
Rotation Speed		mm/min	0,15 - 1,3
Max. Rotational Torque		Nm	2290
Max. Axial Run-Out	X - Y	Nm	150 - 300
Max. Welding Current		Amp	700
Table Plate Diameter	ØD		700
Height Min. (1st Level) - Max (5th Level)	(H1- H2)	mm	800 - 1200
Rotator Frame Height 2nd Level	K	Mm	900
Rotator Frame Height 3rd Level	L	Mm	1000
Rotator Frame Height 4th Level	M	mm	1100
Length	C	mm	900
Width	B	mm	800
Height	H3	mm	1535
Motor Power of Table	kW	mm	0,55
Weight	kg	kg	640

Model : BBT	Symb.	Unit	BBT 500
Capacity		kg	500
Rotating Diameter	Ødmin - ØDmax	mm	Ø80 - Ø710
Roller Diameter	ØB	mm	Ø150
Height	H1 - H2	mm	745 - 890
Length	A	mm	600
Weight		kg	65

❖ All technical specifications are subject to change without prior notice.

Section-B: Brief Overview of WELDING ROTATOR Models :

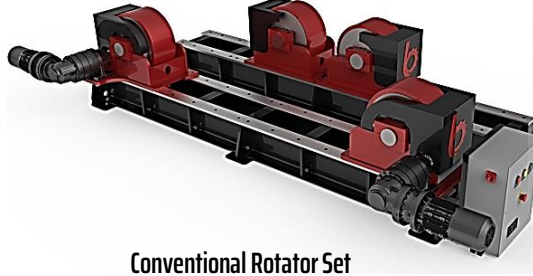
B01: Motorised Wheel Types

BSR



Self-Align Rotator Set

BCR



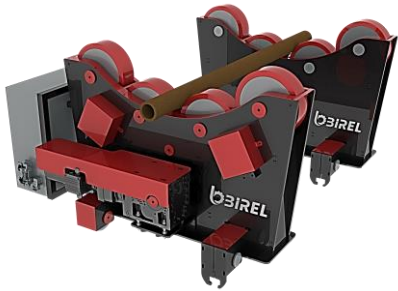
Conventional Rotator Set

BPRA



Pipe Rotator with Leg Set

BPR



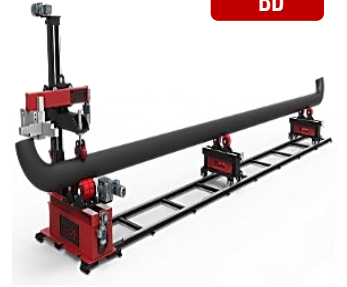
Pipe Rotator 4-Roller Driven Set

BTC



Long Pipe Rotator

BD



Elbow Welding Rotator

B02: Chain Types

BZC



Chain Rotator Set

BRR

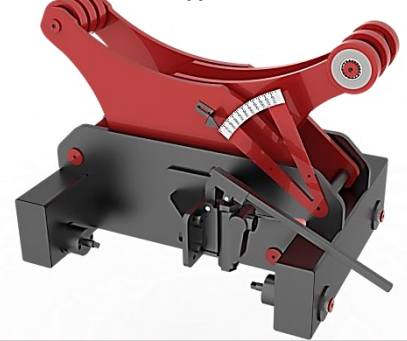


Section Rope Rotator Set

B03: Hydraulic Types

Adjustable Diameter
Hydraulic Manual Lift Support

BHML



B04: Support Types

BHSP



Pipe Feeding Guide

BBT



Pipe Holder

Mini-BCR



Mini-Conventional Rotator Set

BGR



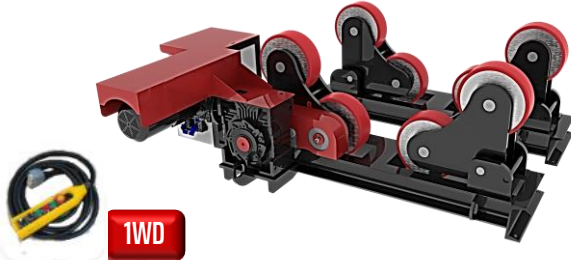
3-JAW Pipe Gripper

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

STANDARD: HandBox Cable Remote Control

BSR5-1WD



1WD

SINGLE Wheel Driven (1 pc.Motor+Reducer)

«1» SET

«1 pc.» DRIVEN Unit

«1 pc.» IDLER Unit

BSR10-15-20-2WD



2WD

DOUBLE Wheel Driven 2 pcs.Motor+Reducer)

BSR30-40-50-60-80-100-120-4WD

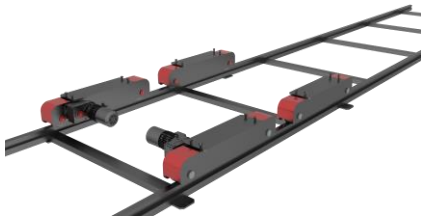


4WD

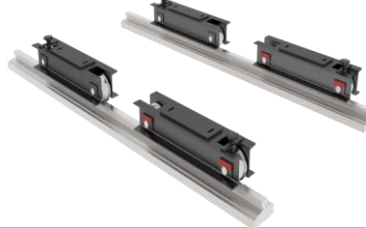
FOUR Wheel Driven with Gear Transmission (2 pcs.Motor+Reducer)

OPTIONAL Modifications & Equipments;

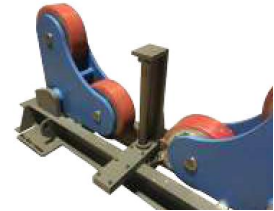
BCBS: Driven+idler Buggy System



MB-BSR: Manual Buggy System



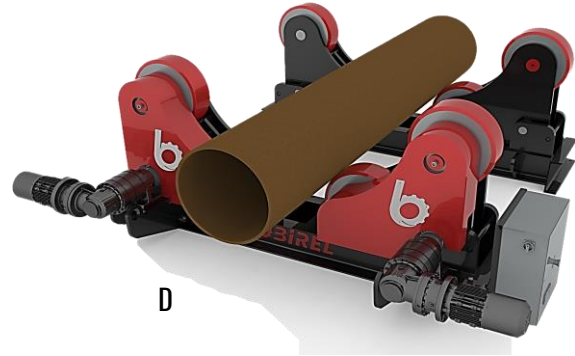
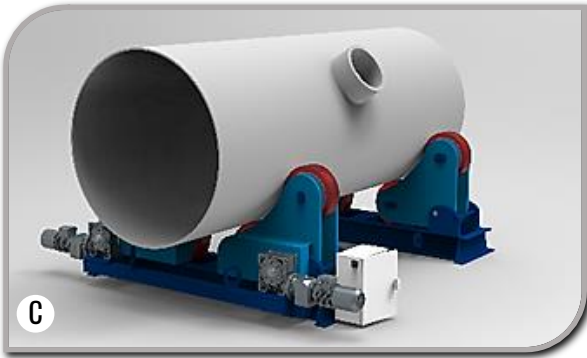
AD-BSR:Stoper Support



General Features ;

- BSR model Self -Align Rotators are used to rotate for the purpose of providing economical and practical circular welding solution to cylindrical parts having variable cylindrical diameters.
- BSR model Self-Align Rotators are used for rotating to perform circular welding of cylindrical parts, Such as Tanks, Pressure vessels, Tower Tubes, Boilers, Depots, Reactors, Depots, Fuel Barrels, WindPower, Petrochemical, PipeLines, Shipbuilding sector,etc.
- The unique design of BSR model Self-Align Rotator permits the rollers to align instantly themselves to the workpiece without any manual pre-adjustment.
- Robust steel welded construction.
- The cylindrical part remains central independent of diameter and frequent adjustment of the welding head becomes unnecessary.
- Operators with BSR model Self-Align Rotators can easily rotate workpieces clockwise(CW) or counterclockwise(CCW) at accurate controlled speeds by means of precise command control
- To start the rotation of workpiece, no extra time or no labour is needed. The rotators have an important place in steel construction workshops, because they reduce the use of a crane, as well as increase the speed and the efficiency of automatic or manual welding processes.

❖ All technical specifications are subject to change without prior notice.



Technical Advantages ;

- One(1)set of BSR model Self Align Rotator consists of two units, one(1) driven unit and one(1) for idler unit. According to specific applications, the number of driven and idler units can be changed.
- Birel Machinery as standard manufactures 5 • 10 • 15 • 20 • 30 • 40 • 50 • 60 • 80 • 100 • 120 ton, Additionally, Upon request over 120 ton models are manufactured as special productions.
- In Driven Units, up to 30ton capacities, Single driven roller is used in Roller Group, 30ton & above Double driven Rollers are used in Roller Group.
- Optionally, opportunity of moving over rails by means of Buggy carriers is available. Two Buggy carriers option are available. The first Buggy carrier choice is Rollers moved manually over rails and the second one is using driven movement of rollers over rails .
- Optionally, Single driven roller is present, as standard, within Roller holding group. Additionally, Double driven rollers choice is available optionally.

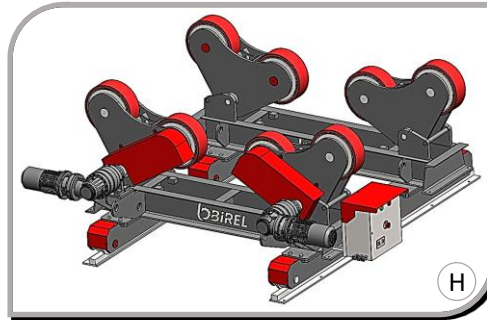
❖ All technical specifications are subject to change without prior notice.

FEATURES

Example : 2WD-2Wheel Driven



Example : 4WD-4Wheel Driven with Gear Transmission

Example :2WD-2Wheel Driven+
Motorised Buggy+Rail

Standard Features

- Adjustable Wheel rotation speed & digital display on Electr.Cabinet
- Self-Aligned Rollers
- Polyurethane Rollers absorbing shocks and vibrations
- 5 mt. Handbox Remote Cable Command
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)

SFP

Single Foot Pedal



MP

Master Panel



OHC

Overhead Hangable Control



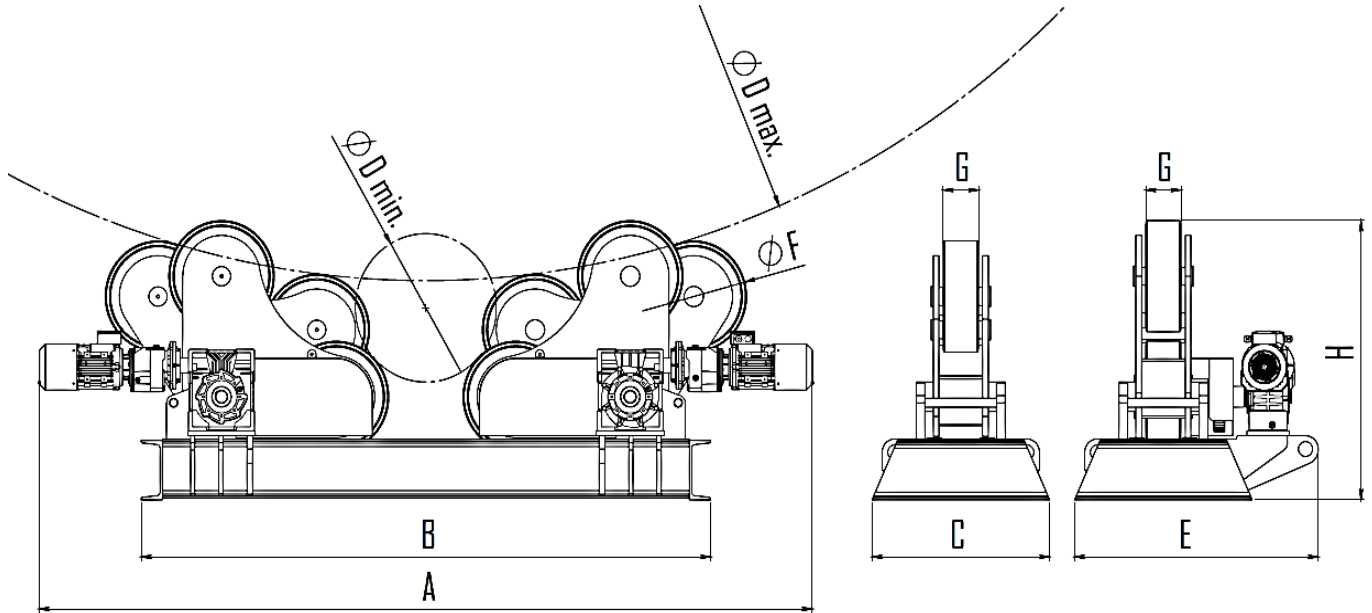
WRC

Wireless Remote Controller



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

Model : BSR	Symb	Unit	BSR-5	BSR-10	BSR-15	BSR-20	BSR-30	BSR-40	BSR-50	BSR-60	BSR-80	BSR-100	BSR-120
Capacity		ton	5	10	15	20	30	40	50	60	80	100	120
Max. Load (Drive Unit)		t/unit	2.5	5	7.5	10	15	20	25	30	40	50	60
Max. Load (idler unit)		t/unit	2.5	5	7.5	10	15	20	25	30	40	50	60
No. of Wheel Driven	WD	No.	1WD	2WD	2WD	2WD	4WD	4WD	4WD	4WD	4WD	4WD	4WD
Rotation Speed	min max	mm/ min	150 1130	150 1220	150 1230	150 1350	150 1300	150 1200	150 1230	150 1300	150 1230	150 1200	150 1230
Diameter Range	Ødmin ØDmax	mm	250 3000	450 3000	450 3300	450 4600	500 4600	500 4600	500 4600	550 5200	550 5500	600 5500	600 5500
Wheel Diameter	ØF	mm	240	340	340	375	415	440	440	500	550	550	550
Wheel Width	G	mm	75	100	110	125	125	130	130	150	175	220	240
Wheel Coating			PU	PU	PU	PU	PU	PU	PU	PU	PU	PU	PU
Length (Drive Unit)	A	mm	1540	2580	2400	2480	2680	2700	2830	3000	3200	3260	3380
Length (Idler Unit)	B	mm	1140	1970	1970	2020	2150	2330	2330	2740	2860	2880	2880
Width (Drive Unit)	E	mm	840	720	900	985	1050	1150	1150	1200	1280	1500	1630
Width (Idler Unit)	C	mm	350	500	520	560	580	700	700	700	700	900	900
Height	H	mm	517	880	880	940	1000	1040	1040	1260	1320	1330	1330
Motor Power	P	kW	0.37 x 1	0.25 x 2	0.37 x 2	0.55 x 2	0.55 x 2	0.55 x 2	0.55 x 2	0.75 x 2	0.75 x 2	1.1 x 2	1,5 x 2
Weight	W	kg	380	1100	1180	1360	1830	2540	2600	3760	5320	6200	6400

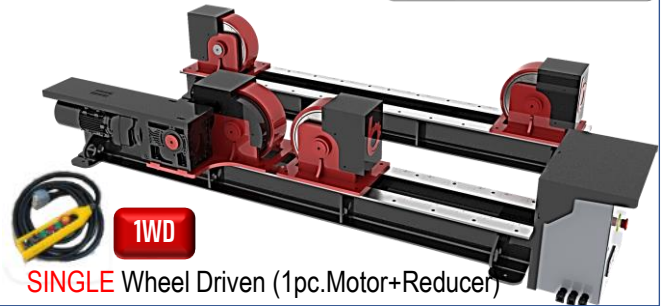
Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

All technical specifications are subject to change without prior notice.

- ❖ Adjustment of Diameter as Standard by Manual Holes Adjustment
- ❖ Economical
- ❖ Easily Operated

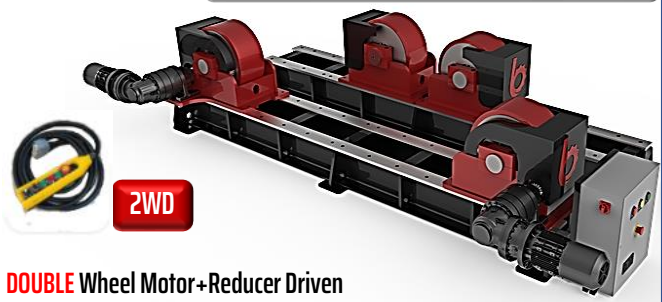
«1» SET	«1 pc.» DRIVEN Unit
includes	«1 pc.» IDLER Unit

BCR3- 5 - 10 -1WD



SINGLE Wheel Driven (1pc.Motor+Reducer)

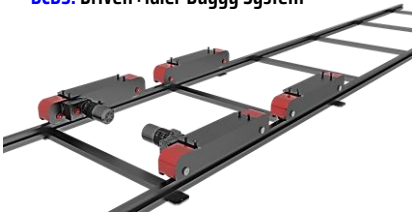
BCR15 - 20 -30 - 40 - 50 - 60 - 80 - 100 -2WD



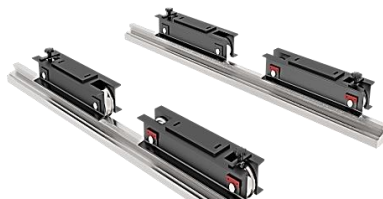
DOUBLE Wheel Motor+Reducer Driven

OPTIONAL Modifications & Equipments

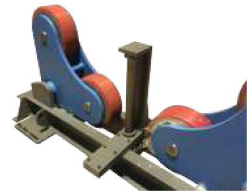
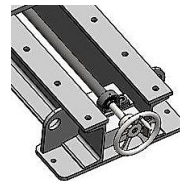
BCBS: Driven+idler Buggy System



MB-BCR: Manual Buggy System

4WD: Optional
«4»-Wheel Driven

AD-BCR : Anti-Drift

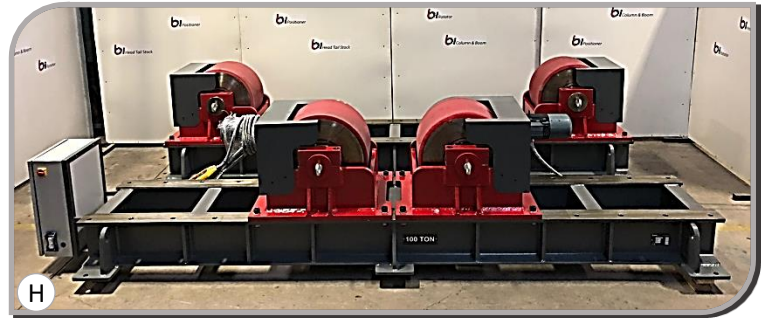
MDA-BCR: Adjustment Stroke **Motorised Driven**
by Forward Reward Threaded ShaftMHA-BCR : Adjustment Stroke by **Manual HandWheel**
with Forward-Reward Threaded Shaft

General Features ;

- BCR model Self -Align Rotators are used to rotate for the purpose of providing economical and practical circular welding solution to cylindrical parts having variable cylindrical diameters by means of Manual Hole Diameter adjustment..
- BCR model Self-Align Rotators are used for rotating to perform circular welding of cylindrical parts, Such as Tanks, Pressure vessels, Tower Tubes, Boilers,Depots, Reactors, Depots, Fuel Barrels, WindPower, Petrochemical, PipeLines, Shipbuilding sector,etc.
- BCR model Conventional Rotators requires pre-adjustment of diameters to contact with the workpiece. Adjustment is manually made on standard models by shifting the roller groups over slides and then fastened to the slide.
- Robust steel welded construction.
- The cylindrical part remains central independent of diameter and frequent adjustment of the welding head becomes unnecessary.
- Operators with BCR model Conventional Rotators by means of precise command control can easily rotate workpieces clockwise(CW) or counterclockwise(CCW) at accurate controlled speeds.
- The rotators have an important place in steel construction workshops because they reduce the use of a crane, as well as increase the speed and the efficiency of automatic or manual welding processes.

- ❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



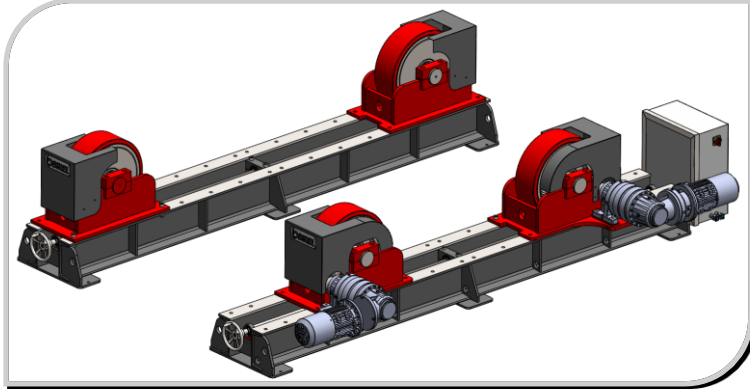
Technical Advantages ;

- One(1)set of BCR model Conventional Rotator consists of two units, one(1) driven unit and one(1) for idler units. According to specific applications, the number of driven and idler units can be changed.
- Birel Machinery as standard manufactures 3 • 5 • 6 • 10 • 15 • 20 • 30 • 40 • 50 • 60 • 80 • 100ton, Additionally, Upon request over 100ton models are manufactured as special productions.
- Within capacities of 3ton • 5ton•6ton • 10ton, Single driven Roller group is used, Above 10ton Double driven Rollers group is used.
- Optionally, Advantage of diameter adjustment by means of threaded Shaft that is operated by hand wheel over the slides forward and reward is available. Applicable to both driven and idler units.
- Optionally, For diameter adjusting, availability of moving forward and reward of roller group as motor driven by means of ththread shaft over slides on both units.
- Optionally, opportunity of moving over rails by means of Buggy carriers is available. Two Buggy carriers option are available. The first Buggy carrier choice is Rollers moved manually over rails and the second one is using driven movement of rollers over rails .
- Opportunity of placing additional stopper support to avoid slippage of workpiece from the rotator.

❖ All technical specifications are subject to change without prior notice.

FEATURES

Manual Diameter Setting by Handwheel Application



Elektrical Cabinet



Standard Equipments

- Diameter Range Fixing Holes on the slides.
- Adjustable wheel rotation speed & digital display on Electr.Cabinet
- Polyurethane Rollers absorbing shocks and vibrations
- 5 mt. Command Cable
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+Emergency Stop (3 m)



OHC

Overhead Hangable Control



MP

Master Panel

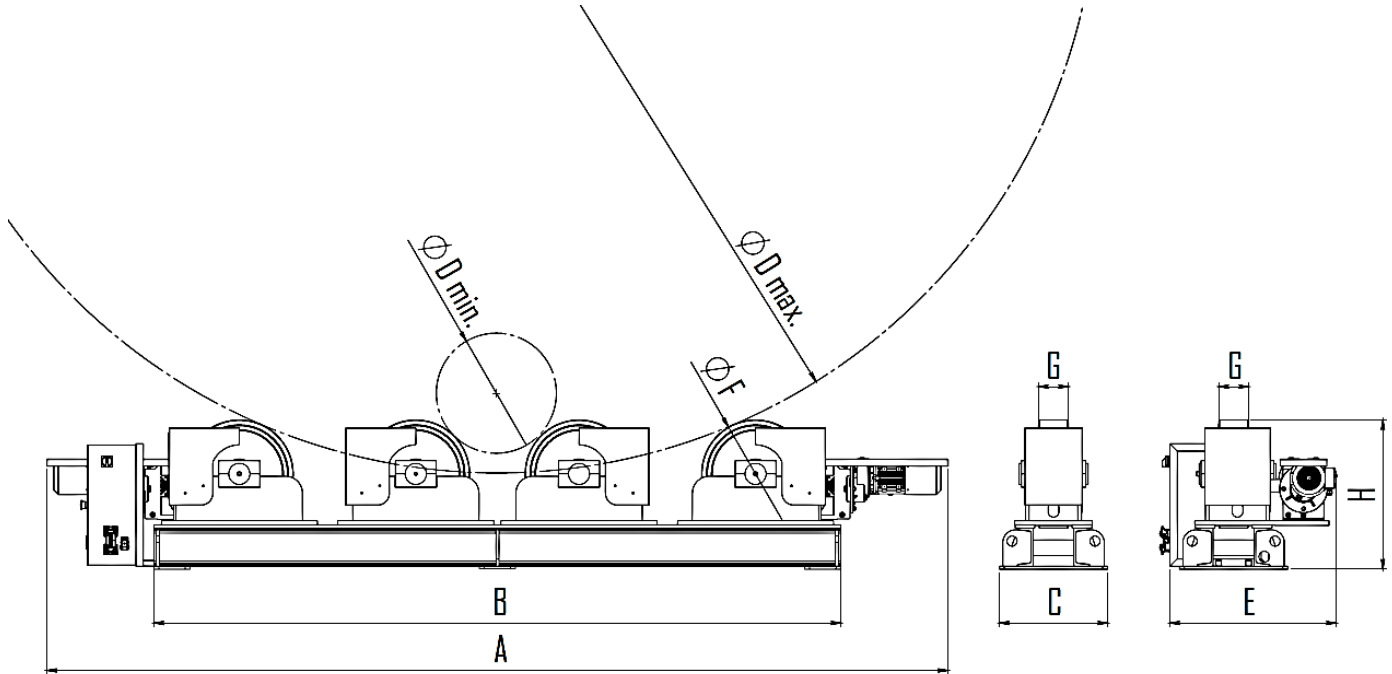


WRC

Wireless Remote Controller



❖ All technical specifications are subject to change without prior notice.



Technical Details :

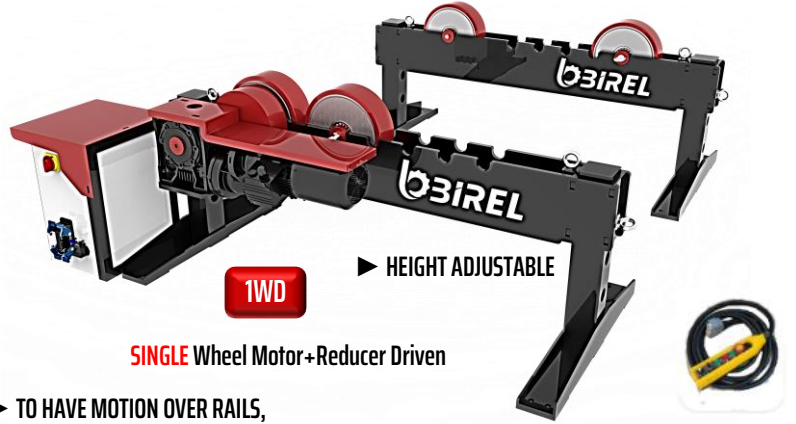
Model : BCR	Symb	Unit	BCR-3	BCR-5	BCR-6	BCR-10	BCR-15	BCR-20	BCR-30	BCR-40	BCR-50	BCR-60	BCR-80	BCR-100
Capacity		ton	3	5	6	10	15	20	30	40	50	60	80	100
Max. Load (Drive Unit)		t/unit	1.5	2.5	3	5	7.5	10	15	20	25	30	40	50
Max. Load (idler unit)		t/unit	1,5	2.5	3	5	7.5	10	15	20	25	30	40	50
No. of Wheel Driven		WD	1WD	1WD	1WD	1WD	2WD	2WD	2WD	2WD	2WD	2WD	2WD	2WD
Rotation Speed	min	mm/min	200	200	200	200	200	200	200	200	200	200	200	200
	max		1100	1150	1150	1150	1200	1150	1200	1200	1200	1200	1200	1250
Diameter Range (Ødmin-ØDmax)	Ødmin	mm	200	250	250	250	400	450	450	450	450	550	550	600
	ØDmax		2000	3000	3000	3000	3300	4600	4600	4600	4600	5200	5200	5500
Wheel Diameter	ØF	mm	230	300	300	300	360	450	450	450	450	500	500	550
Wheel Width	G	mm	75	90	90	100	110	125	150	170	200	230	300	350
Wheel Coating			PU	PU	PU	PU	PU	PU	PU	PU	PU	PU	PU	PU
Length (Drive Unit)	A	mm	1650	2550	2550	2570	3170	3360	3620	3620	3620	3950	4200	4500
Length (Idler Unit)	B	mm	1350	2000	2000	2000	2150	2860	2860	2860	2860	3350	3350	3650
Width (Drive Unit)	E	mm	730	500	520	550	670	670	870	900	920	1000	1070	1200
Width (Idler Unit)	C	mm	330	380	380	400	435	450	500	530	550	620	700	790
Height	H	mm	370	420	430	440	550	620	670	680	710	780	785	870
Motor Power		kW	0.25 x 1	0.25 x 1	0.25 x 1	0.37 x 1	0.25 x 2	0.37 x 2	0.55 x 2	0.75 x 2	0.75 x 2	1,1 x 2	1,1 x 2	1,5 x 2
Weight		kg	260	410	430	490	900	1120	1410	1600	1800	2400	3050	4350

↳ Out of these standard. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

- ❖ Adjustment of Diameter as Standard by Manual Slots Adjustment
- ❖ Economical
- ❖ Easily Operated

«1» SET	«1 pc.» DRIVEN Unit
includes	«1 pc.» IDLER Unit



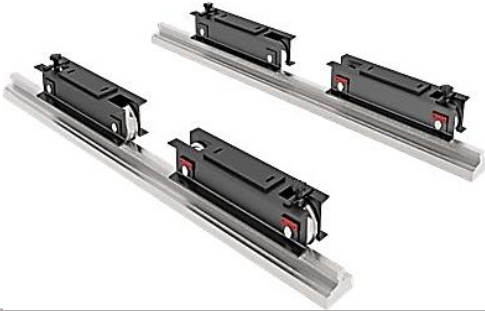
▶ TO HAVE MOTION OVER RAILS,
BUGGY ADAPTABLE VERSION

SINGLE Wheel Motor+Reducer Driven

▶ HEIGHT ADJUSTABLE

OPTIONAL Modifications & Equipments;

MB-BPRA: Manual Buggy System over Rails;



General Features ;

- BPRA model Pipe Rotator with Leg provides economical and practical circular welding solution to cylindrical parts having variable diameter.
- BPRA model Pipe Rotator with Leg are used for rotating to perform circular welding of cylindrical parts, Such as Tanks, Pressure vessels, Tower Tubes, Boilers, Depots, Reactors, Depots, Fuel Barrels, WindPower, Petrochemical, PipeLines, Shipbuilding sector, etc.
- BPRA model Pipe Rotator with Leg requires pre-adjustment of diameters to contact with the workpiece. Adjustment is manually made by placing idler rollers on the slot present on the casing and then fastened.
- Robust steel welded construction
- The cylindrical part remains central irrespective of diameter and frequent adjustment of the welding head becomes unnecessary
- Operators with BPRA model Pipe Rotator with Leg by means of precise command control can easily rotate workpieces clockwise(CW) or counterclockwise(CCW) at accurate controlled speeds.
- The rotators have an important place in steel construction workshops because they reduce the use of a crane, as well as increase the speed and the efficiency of automatic or manual welding processes.

Technical Advantages ;

- Birel Machinery as standard provides BPRA-3-5-8-10 ton model capacities.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- One(1)set of BPRA model Pipe Rotator with Leg consists of two units, one(1) driven unit and one for idler units. According to specific applications, the number of driven and idler units can be increased.
- Optionally, Application of movement over rails with manual Buggy system by means of rollers to both units.
- For operation performans, Availability of three(3) level manual adjustable height is available as standard.

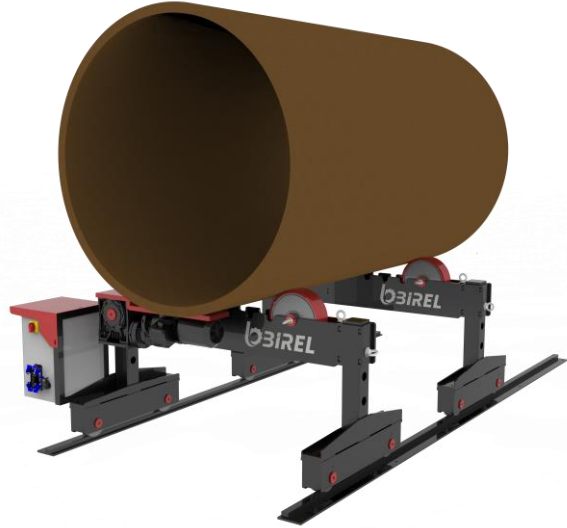
❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS

A



B



C



D

Standard Equipments

- Manual diameter range fixing slots on the frame.
- Adjustable Workpiece rotation speed & Digital display on Electr.Cabinet
- Polyurethane Rollers absorbing shocks and vibrations
- 5 mt. Command Cable
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



MP

Master Panel



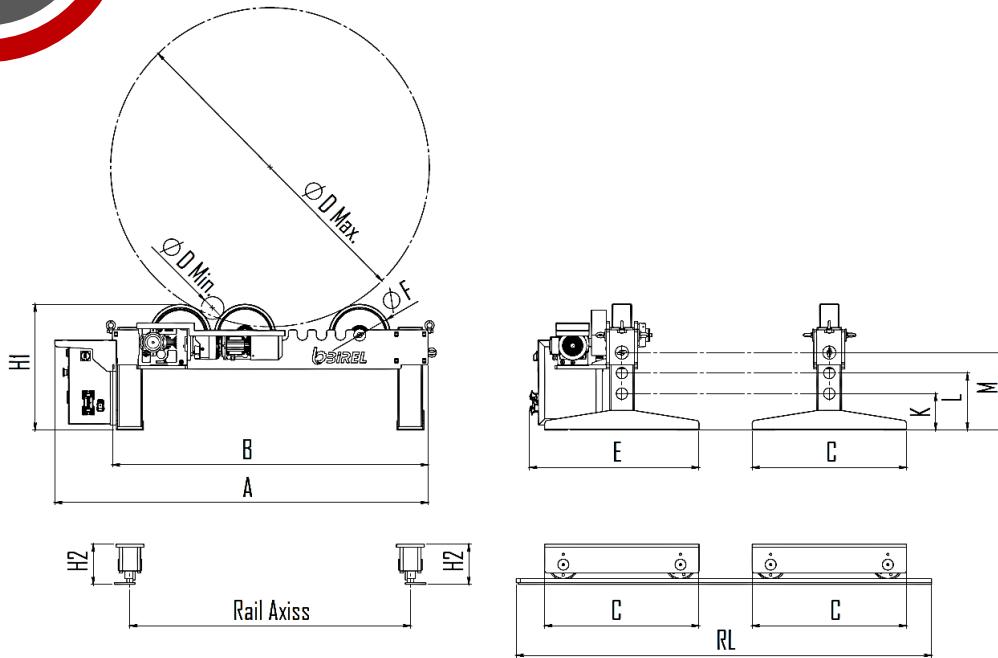
WRC

Wireless Remote Controller



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES



Technical Details :

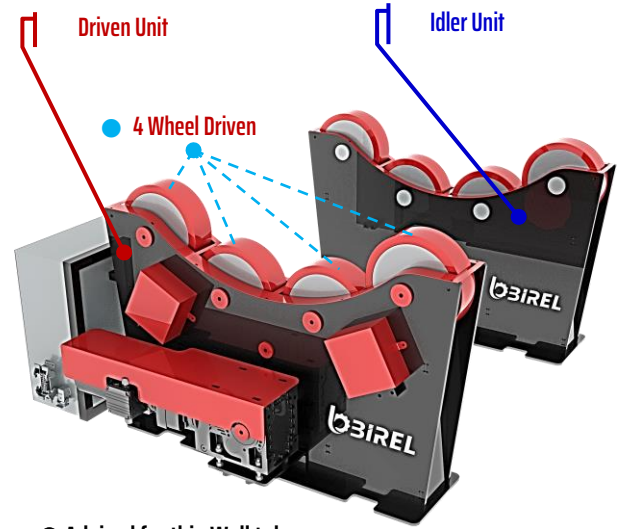
Model : BPRA	Symb.	Unit	BPRA-3	BPRA-5	BPRA-8	BPRA-10
Capacity		ton	3	5	8	10
Max. Load (Drive Unit)		t/unit	1.5	2.5	4	5
Max. Load (idler unit)		t/unit	1.5	2.5	4	5
No. of Wheel driven		WD	1WD	1WD	1WD	1WD
Rotation Speed		mm/min	150-1300	150-1360	150-1210	150 - 1430
Diameter Range	ØDmin-ØDmax)	mm	110 - 1200	110 - 1200	110 - 1420	110 - 1550
Wheel Diameter	ØF	mm	230	240	290	300
Wheel Material		mm	PU	PU	PU	PU
Length (Drive-idler Unit)	A	Mm	1625	1625	1710	1815
Length (Idler Unit)	B	mm	1340	1340	1430	1535
Width (Drive Unit)	E	mm	710	720	750	780
Width (idler Unit)	C	mm	650	650	700	750
Width (Buggy Unit)	C	mm	650	650	700	750
Height (Drive-idler Unit)	H1	mm	570	575	590	610
Height (Buggy Unit)	H2	mm	160	170	185	195
Rail Axis		Mm	1220	1220	1280	1365
Rail Length (optional)	RL	mm	3000	3000	3000	3000
Level - 1	M	mm	358	358	355	377
Level - 2	L	mm	258	258	255	277
Level - 3	K	mm	158	158	155	177
Motor Power		kW	0,25	0,25	0,37	0,37
Weight		kg	290	300	400	450
Weight (including Buggy)		Kg.	380	400	560	630

↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



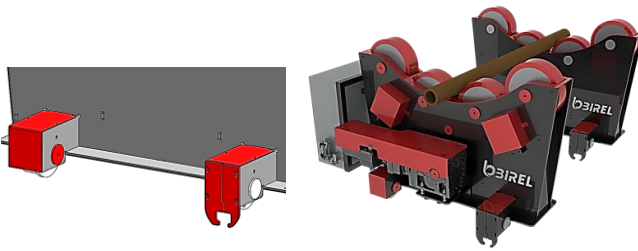
«1» SET includes	«1» pc. Driven Unit
	«1» pc. Idler Unit



● Advised for thin Wall tubes

OPTIONAL Modifications & Equipments;

MB-BPR: Manual Buggy Adaptation



MB-BPR+T.: Manual Buggy System with Table



T-BPR: Rail Table



General Features ;

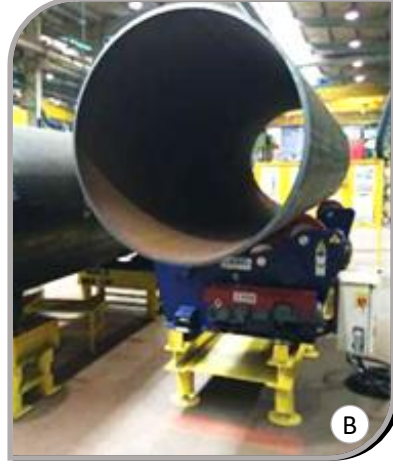
- BPR-4-Roller Driven Pipe Rotator Model provides economical and practical circular welding solution to cylindrical parts having variable diameter.
- BPR-4-Roller Driven Pipe Rotator Model are used for rotating to perform circular welding of cylindrical parts, Such as Tanks, Pressure vessels, Tower Tubes, Boilers, Depots, Reactors, Depots, Fuel Barrels, WindPower, Petrochemical, PipeLines, Shipbuilding sector, etc.
- BPR-4-Roller Driven Pipe Rotator Model requires no adjustment of diameters to contact with the workpiece. Adjustment is automatic touching due to design advantage.
- Robust steel welded construction
- The cylindrical part remains central irrespective of diameter and frequent adjustment of the welding head becomes unnecessary
- BPR-4-Roller Driven Pipe Rotator Model by means of precise command control can easily rotate workpieces clockwise(CW) or counterclockwise(CCW) at accurate controlled speeds.
- The rotators have an important place in steel construction workshops because they reduce the use of a crane, as well as increase the speed and the efficiency of automatic or manual welding processes.

Technical Advantages ;

- Birel Machinery as standard provides BPR-4 Roller Driven Pipe Rotator model in capacities. of BPR-3 - 6 Ton.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- One(1)set of BPR -4-Roller Driven Pipe Rotator model consists of two units, one(1) driven unit and one for idler units. According to specific applications, the number of driven and idler units can be increased.
- Optionally, Application of movement over rails with manual Buggy system by means of rollers to both units.
- Optionally Rail Table can be used on customer request.

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Equipments

- Diameter range fixed rollers on the chassis.
- Adjustable Workpiece rotation speed and Digital display
- Polyurethan Rollers absorbing shocks and vibrations
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)

SFP

Single Foot Pedal



MP

Master Panel



OHC

Overhead Hangable Control



WRC

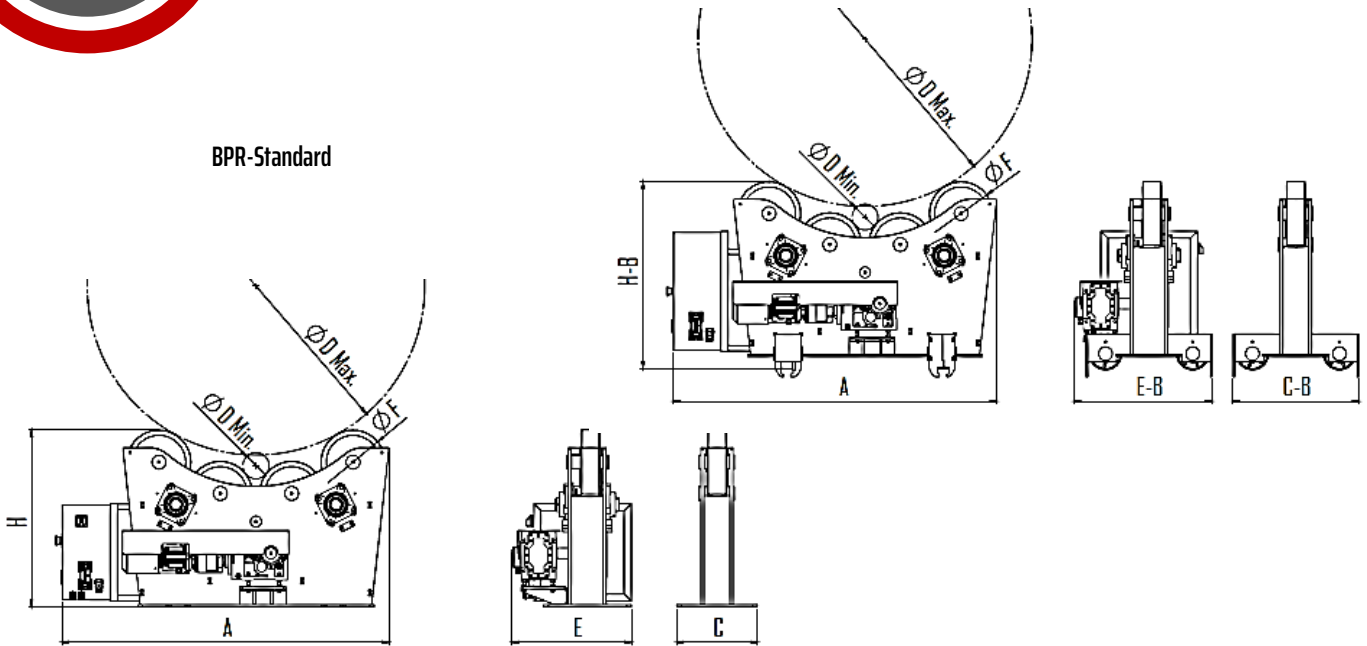
Wireless Remote Controller



❖ All technical specifications are subject to change without prior notice.

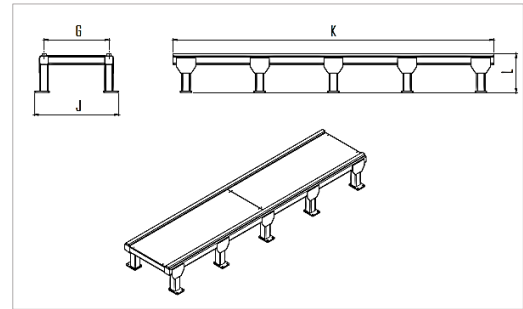
TECHNICAL PROPERTIES

BPR-Standard



Technical Details :

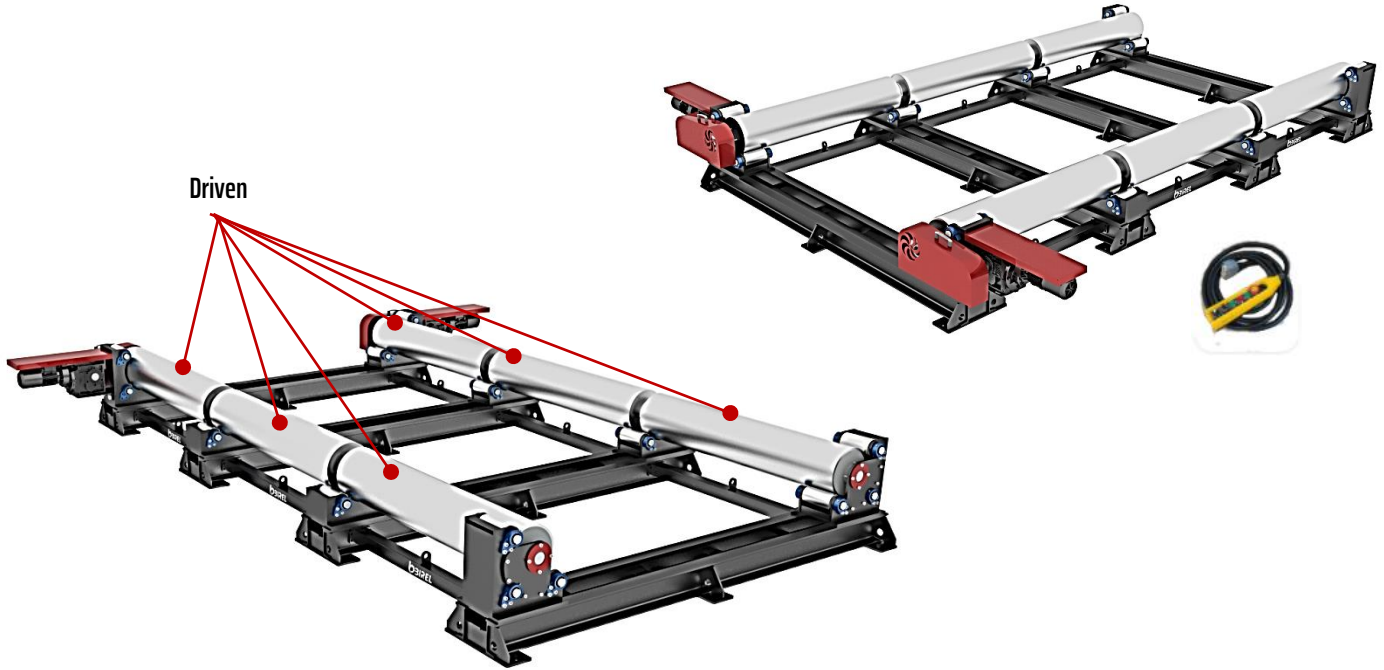
Model : BPR	Symb.	Unit	BPR-3	BPR-6
Capacity		ton	3	6
Max. Load (Drive Unit)		t/unit	1.5	3
Max. Load (idler unit)		t/unit	1.5	3
No.of Wheel Driven		WD	Standart	Standart
Rotation Speed		mm/min	200-1800	200-1550
Ø Range min-max 100% load	Ødmin	mm	60	90
	ØDmax	mm	1420	1420
Wheel Diameter	ØF	mm	200	270
Wheel Material			PU	PU
Length (Drive-idler Unit)	A	mm	1090	1375
Width (Drive Unit)	E	mm	410	500
Width - Buggy (Drive Unit)	E - B	mm	490	590
Width (idler Unit)	C	mm	220	340
Width - Buggy (Idler Unit)	C - B	mm	485	540
Height (Drive-idler Unit)	H	mm	510	750
Height-Buggy (Drive-Idler Unit)	H - B	mm	545	800
Buggy Rail Axis	G	mm	620	660
External Down Chassis Width	J	mm	790	920
External Down Chassis Length	K	mm	3000	4500
External Down Chassis Height	L	mm	360	460
Weight (Drive-Idler Unit)		kg	250	580
Weight-Buggy (Drive-Idler Unit)		kg	310	650
Weight-(External Down Chassis)		kg	230	480
Motor Power		kW	0,25	0,37



OPTIONAL
T-BPR :Table with Manual Buggy System

↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



General Features ;

- BTC model Long Pipe Rotators, are designed to disapper the effect of deformation of pipes that may come out due to the effect of middle section weight having thin wall section.
- BTC model Long Pipe Rotators are used for rotating to perform circular welding of cylindrical parts, Such as Tanks, Pressure vessels, Tower Tubes, Boilers,Depots, Reactors, Depots, Fuel Barrels, WindPower, Petrochemical, PipeLines, Shipbuilding sector,etc.
- BTC model Pipe Rotator with Leg requires pre-adjusment of diameters to contact with the workpiece.Adjustment is manually made.
- Robust steel welded construction
- Operators with BTC model Long Pipe Rotator by means of precise command control can easily rotate workpieces clockwise(CW) or counterclockwise(CCW) at accurate controlled speeds.
- The rotators have an important place in steel construction workshops because they reduce the use of a crane, as well as increase the speed and the efficiency of automatic or manual welding processes.

Technical Advantages ;

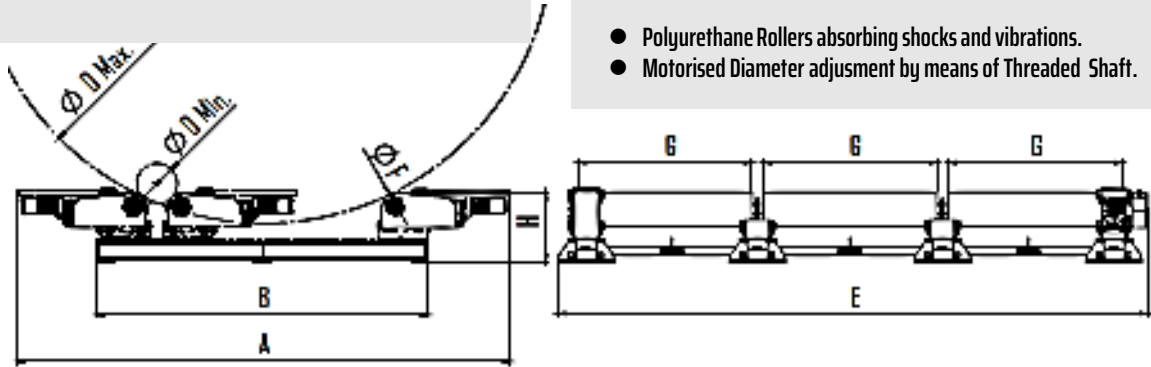
- Birel Machinery as standard provides BTC 5 - 10 ton model capacities.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- In special conditions up to 30 ton, we can manufacture.

❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

Standard Equipments

- Adjustable rotation speed & digital display on electrical cabinet
- Manual adjustment of diameter
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)



Technical Details :

Model : BTC	Symb.	Unit	BTC-5	BTC-10
Capacity		ton	5	10
Max. Load (Drive Unit)		t/unit	2.5	5
Max. Load (idler unit)		t/unit	2.5	5
2 Roller drive			standard	standard
Rotation Speed		mm/min	200 - 1620	200 - 1550
Diameter Range (ØDmax-ØDmin)		mm	350-5000	350-5000
Wheel Diameter	Ø F	mm	300	300
Wheel Width	G	mm	1500 x 3	1500 x 3
Wheel Material			Steel	Steel
Length (Drive Unit)	A	mm	4260	4340
Length (Idler Unit)	B	mm	2860	2860
Width (Drive Unit)	E	mm	5100	5100
Height	H	mm	600	600
Motor Power		kW	0,25 x 2	0,25 x2

↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



MP

Master Panel



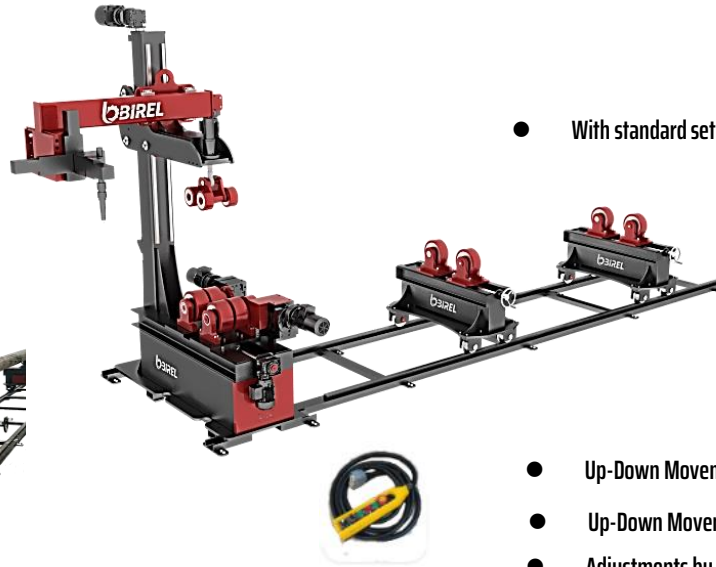
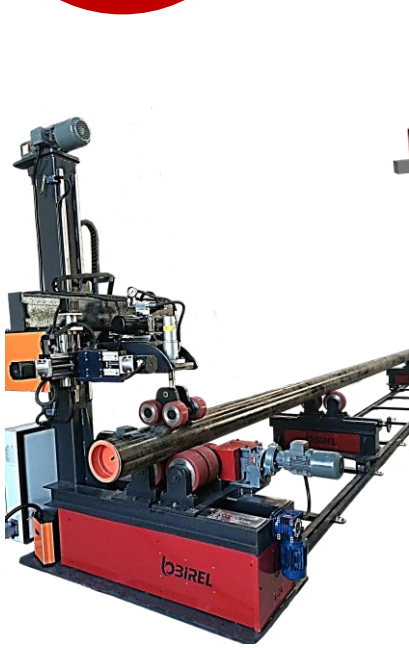
WRC

Wireless Remote Controller



- Polyurethane Rollers absorbing shocks and vibrations.
- Motorised Diameter adjustment by means of Threaded Shaft.

❖ All technical specifications are subject to change without prior notice.



- With standard set, 2 pcs.of Roller Carrier

- Up-Down Movement by Threaded Shaft.
- Up-Down Movement over Sliding guides.
- Adjustments by linear Measuring Scales,.
- Applying Hydraulic Pressing for holding pipe.

OPTIONAL Modifications & Equipments

M01: Additional Each Carrier more than 2 pcs. is optional.



General Features ;

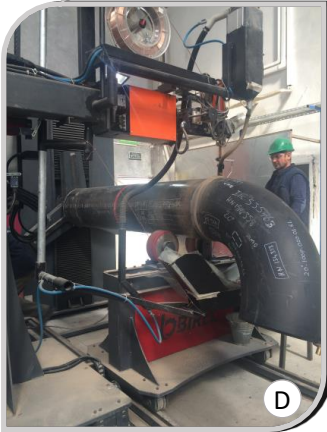
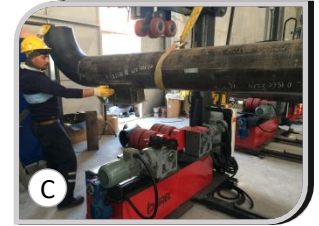
- BD Elbow Welding Rotator Model is used for the purpose of rotation and welding with round profiles in manual or automatic welding, mainly in the field of pipe construction, prefabrication and assembly on site.
- Due to rotation of pipe, No interruption is observed in circumferential welding of pipe.
- BD Elbow Welding Rotator Model, as standard, Up and down movement for diameter adjustment is performed mechanically by Manual Wheel. Upon request, Optionally, A quick mounting-detaching equipments can be provided.

Technical Advantages ;

- Birel Machinery as standard provides BD model in capacities of 6000 - 8000 kg.
- In special conditions, Out of these standard capacities, Birel Machinery, according to customer standards & requirements, has the opportunity of manufacturing possibility at different capacities.
- Motor with brake and forced fan cooling.
- Optionally, Welding Torch mounting equipment is provided
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



Standard Equipments

- Capability of rotation.
- Up & Down movements for Diameter adjustment are provided by means of manually operated mechanical wheel as standard.
- Adjustable rotation speed & digital display on electrical cabinet
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power supply :380V - (3 phase)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)

OHC

Overhead Hangable Control



MP

Master Panel



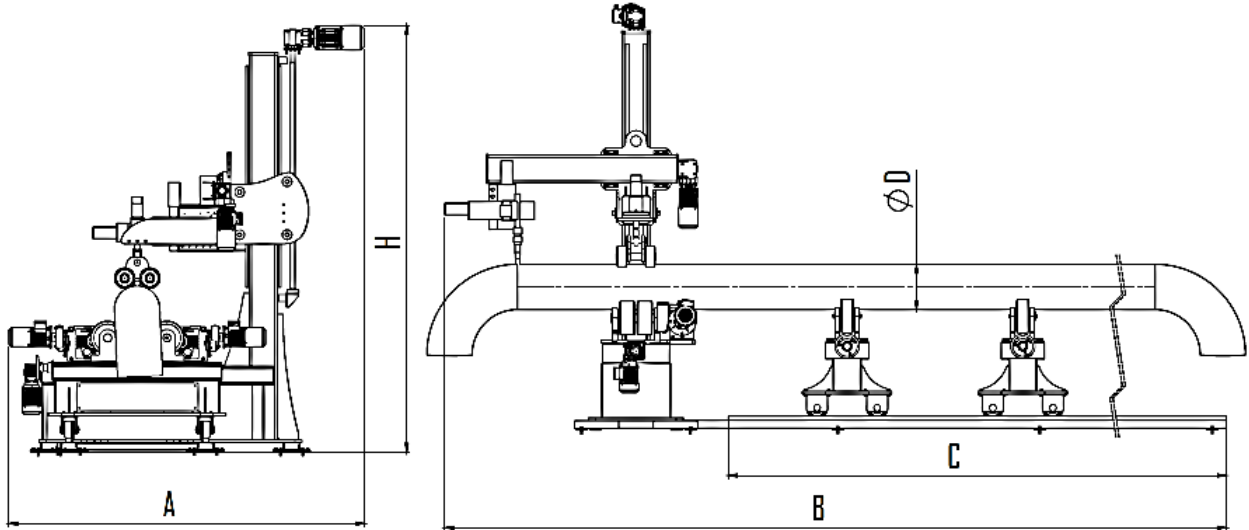
WRC

Wireless Remote Controller



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

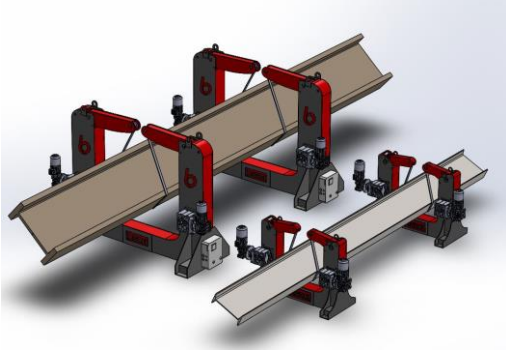


Technical Details :

Model No : BD	Symb.	Unit	BD(4 - 24)	BD(12 - 56)
Capacity		kg	6 000	8 000
Mountable Pipe Diameter Range	Dmin - Dmax	inch	4" - 24"	12" - 56"
Machine Length	A	mm	2600	3150
Rail Axis	C	mm	11000	11000
Total Length	B	mm	13 000	13 000
Height	H	mm	3050	4800
Welding Speed		mm / min	200 - 1250	200 - 1250
Weight		kg	3700	5250

↪ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



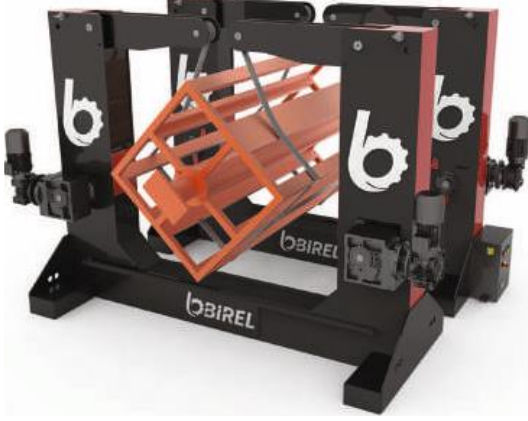
General Features ;

- Purpose of Chain Rotators is rotating and positioning work pieces with planar section
- The total handling and rotation tonnage of both unit is the capacity of the model.
- Both unit can be controlled seperately.
- Over an endless chain, Providing rotation movement to workpiece, together with suitable positioning ,required welding edge and assembly plane could be generated.
- It is possible to adjust the height of the piece placed on the machine. this provides more convenience to the operator during welding.
- Operators can easily rotate the workpiece placed on the chain clockwise (CW) or counterclockwise(CCW), accurately aligned. They can also be moved up-down to provide the intended height.
- Chain Rotators set includes of 2 pcs. driven units. Number of units can be augmented according to the application and weight terms.
- Both of the units which constitute the chain rotator set are driven and these two unit can be operated in synchronization or seperately. Thus, angular height setting of the work piece is enabled.
- Birel Makine manufactures 5 and 10 ton chain rotators in its standard, However, between these tonnages special custom production can be manufactured.

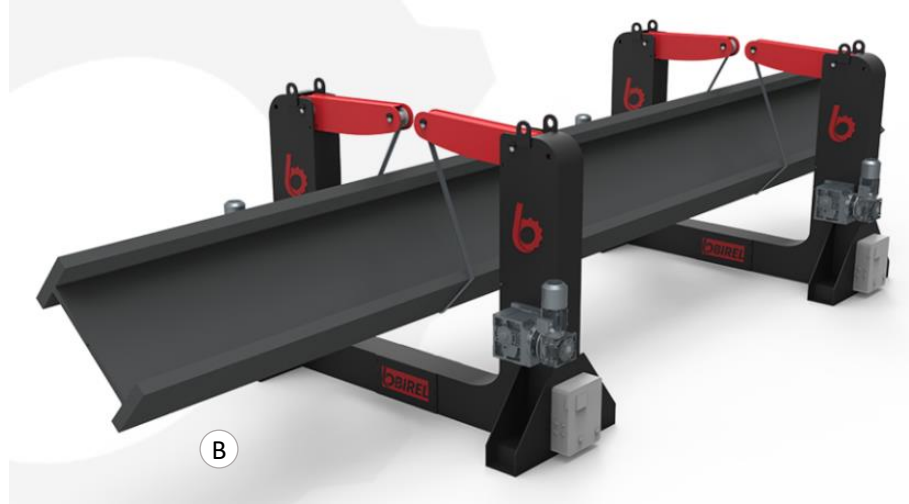
Technical Advantages ;

- Birel Machinery as standard provides BZC model, in capacity of 5 - 10 ton.
- Automatic closing of chain levers upon loading workpiece.
- Birel Chain Rotators allow easy loading by opening the chain arms.
- Both unit could function simultaneously by using Master Panel(Optional).
- Positioning of Up and Down Movement
- Robustchain gear structure
- Motor with brake and forced fan cooling.
- Birel Machinery, out of these standard capacities, according to customer standards & requirements ,can present quotation against the machine revision process or fulfill customer request against new designs.
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.



A



B

Standard Equipments

- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt.Handbox Command Cable
- 5 mt.Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)



OHC

Overhead Hangable Control



MP

Master Panel



WRC

Wireless Remote Controller



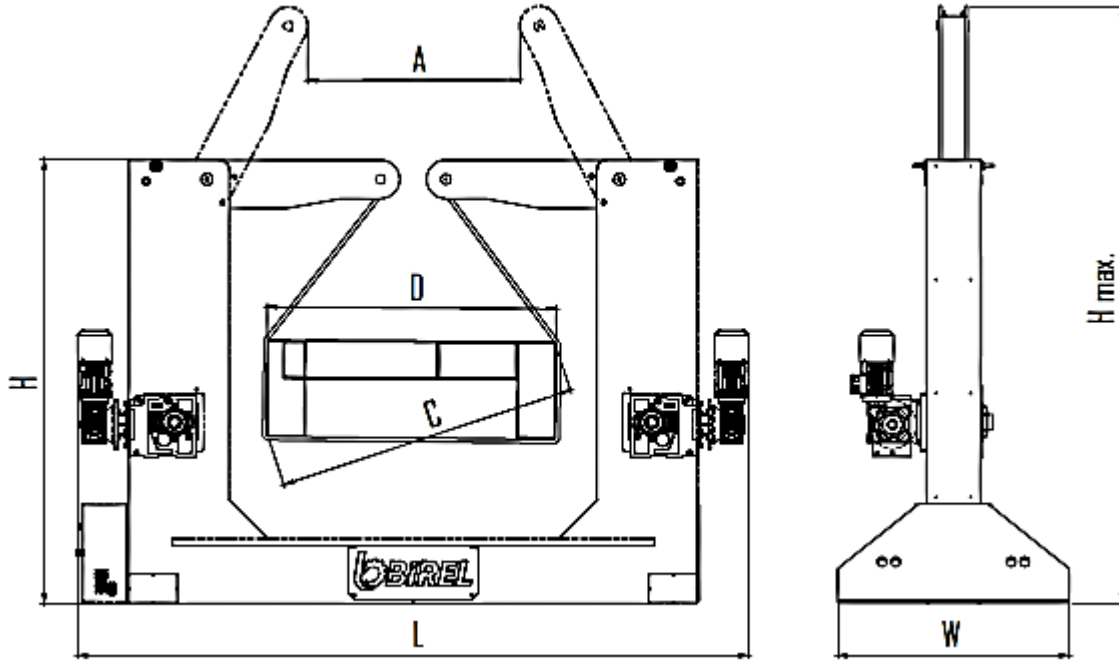
❖ All technical specifications are subject to change without prior notice.

ILLUSTRATIONS



❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

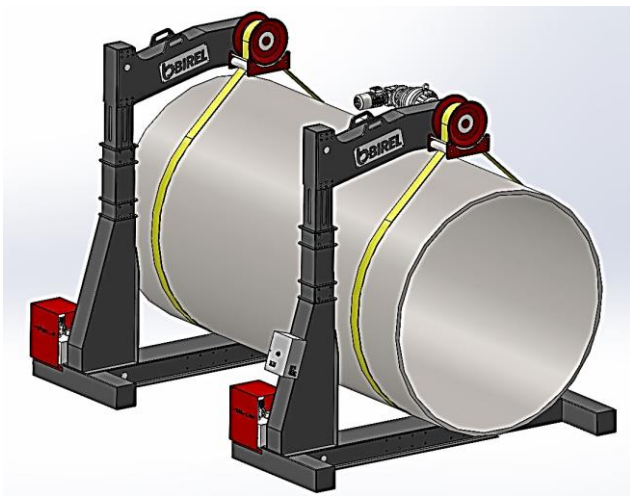


Technical Details :

Model : BZC	Symb	Unit	BZC-5	BZC-10
Capacity		ton	5	10
Max. Load (Drive Unit)		t/unit	2,5	5
Max. Load (idler unit)		t/unit	2,5	5
Rotation Speed		rpm	2	2
Workpiece Width	D	mm	500	1100
Max. Rotating Diagonal	C	mm	600	1500
Distance between Rolls	A	mm	600	1150
Base Overall Length	L	mm	1910	3500
Base Overall Width	W	mm	800	1200
Height (Legs Down)	H	mm	1300	2300
Height (Legs Upper)	Hmax	mm	1700	3100
Width (Drive Unit)	W1	mm	800	1200
Width (idler Unit)	W2	mm	800	1200
Motor Power		kW	1,1 x 4	1,5 x 4
Weight		kg	1220	3950

✎ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.



General Features ;

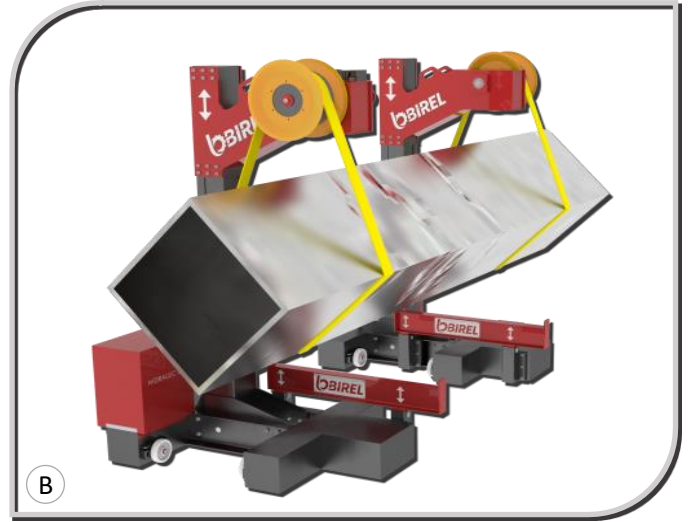
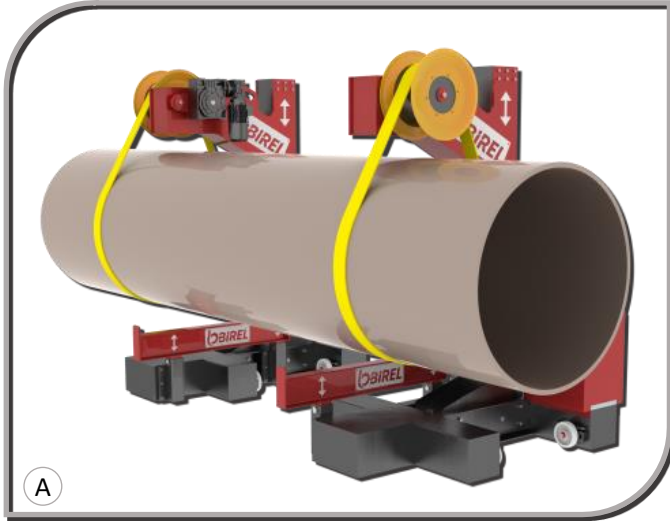
- Purpose of Section Rope Rotator is rotating and positioning work pieces with planar cross section.
- Over an endless rope, Providing rotation movement to workpiece , together with suitable positioning , required welding edge and assembly plane could be arranged.
- It is possible to adjust the height of the piece placed on the machine. this provides more convenience to the operator during welding.
- Operators can easily rotate workpieces mounted on the chain clockwise (CW) or counterclockwise (CCW) , precisely, well-aligned. They can also be moved up & down to provide the intended height.
- Rope Rotators set include of 2 pcs. driven units. Number of units can be augmented according to the operation and weight terms.
- Both of the units that builds BRR-Section Rope Rotator set are driven and these two unit can be operated in synchronization or separtely. Thus, angular height adjustment of the work piece is enabled.
- Birel Makine manufactures 5 , 6 and 10 ton chain rotators in its standard, However, between these tonnages special custom production can be manufactured.

Technical Advantages ;

- Birel Machinery as standard provides BRR model, in capacity of 5 - 6 - 10 ton.
- Birel Machinery, out of these standard capacities, according to customer standards & requirements ,can present quotation against the machine revision process or fulfill customer request against new designs.
- Birel Chain Rotators allow easy loading by opening the chain arms.
- Automatic closing of chain levers upon loading workpiece.
- Robust chain gear structure
- For any special request or project, Please do not hesitate to contact with us.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT



Standard Equipments

- Adjustable worktable rotation speed
- Rotational Speed Dijital display on Electrical Cabinet
- 5 mt. Command Cable
- 5 mt. Power Cable
- Brake & Fan Cooled Motor (Asynchronous)
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

DFPSE

Double Foot Pedal+Stick+
Emergency Stop (3 m)

OHC

Overhead Hangable Control



MP

Master Panel



WRC

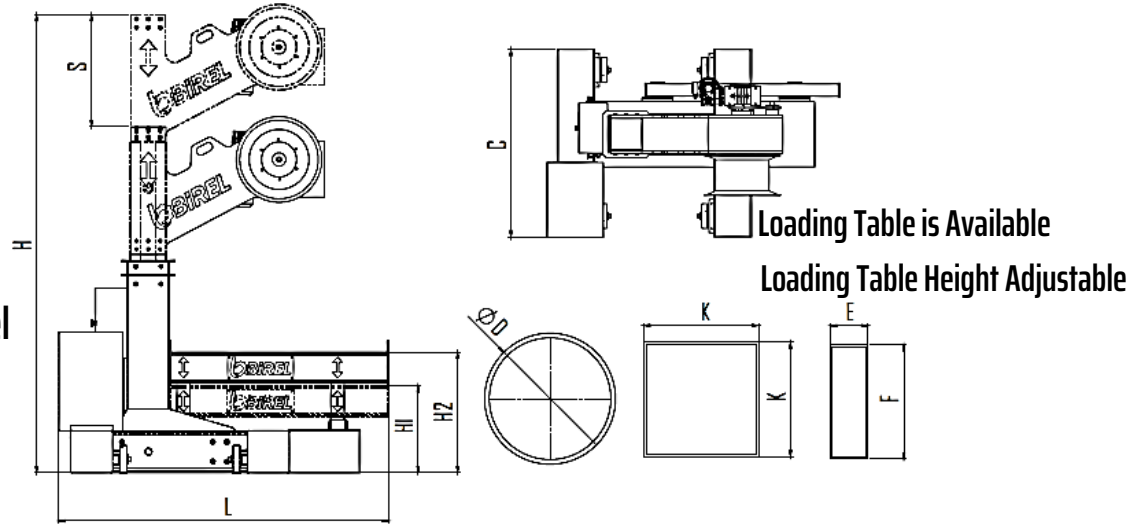
Wireless Remote Controller



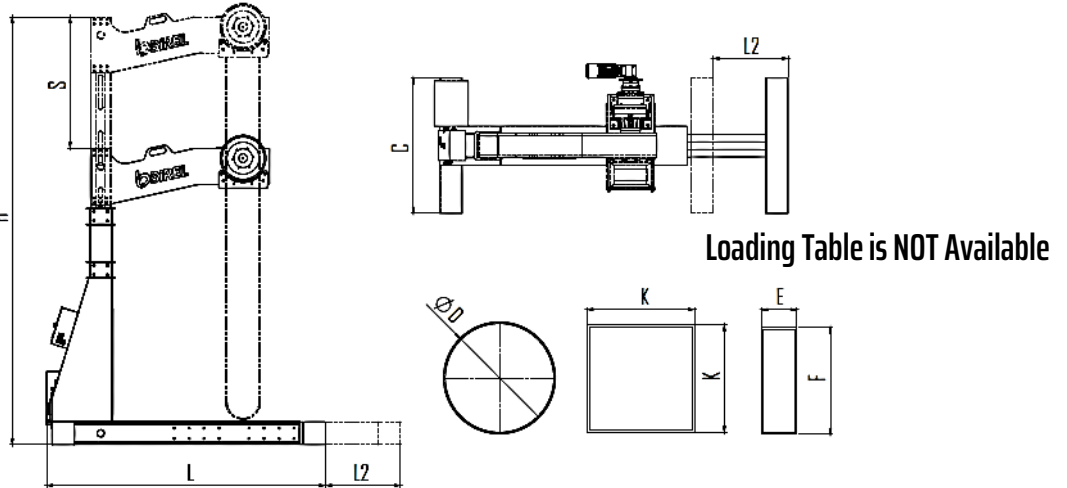
❖ All technical specifications are subject to change without prior notice.

TECHNICAL PROPERTIES

BRR-5 Model



**BRR-6 Model
BRR-10 Model**



Technical Details :

Model : BRR	Symb.	Unit	BRR-5	BRR-6	BRR-10
Capacity		kg	5 000	6 000	10 000
Rotation Speed	90°	sec	9 sec	30 sec	30 sec
Up & Down Time		sec	30sec	90 sec	90sec
Loading Stroke	S	mm	800	1300	1300
Max.Workpiece Round	ØD	mm	1415	3500	3500
Max.Workpiece Square	K	mm	1000	2500	2500
Max.Workpiece Rectangular	E-F	mm	1200 x 300	3200 x 1500	3200 x 1500
Height	H	mm	3265	5400	5400
Loading Chassis Height	H1 - H2	mm	620 - 860	--	--
Length	L	mm	2350	4070	4070
Length Stroke	L2	mm	-	1000	1000
Width	C	mm	1500	2250	2500
Total Motor Power		kW	5	11	14

↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

Standard Features

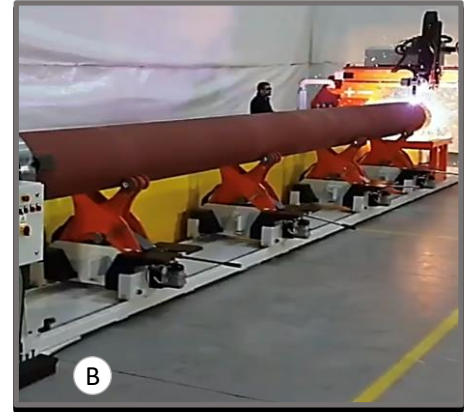
- One «1» idler unit.
- Manual Locking System
- Mechanical Diameter Scale Indicator
- Hydraulic Height Adjustment by Handle.
- Polyurethane Coated Rollers
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- One (1) Year Warranty (wearing parts out of warranty)



General Features ;

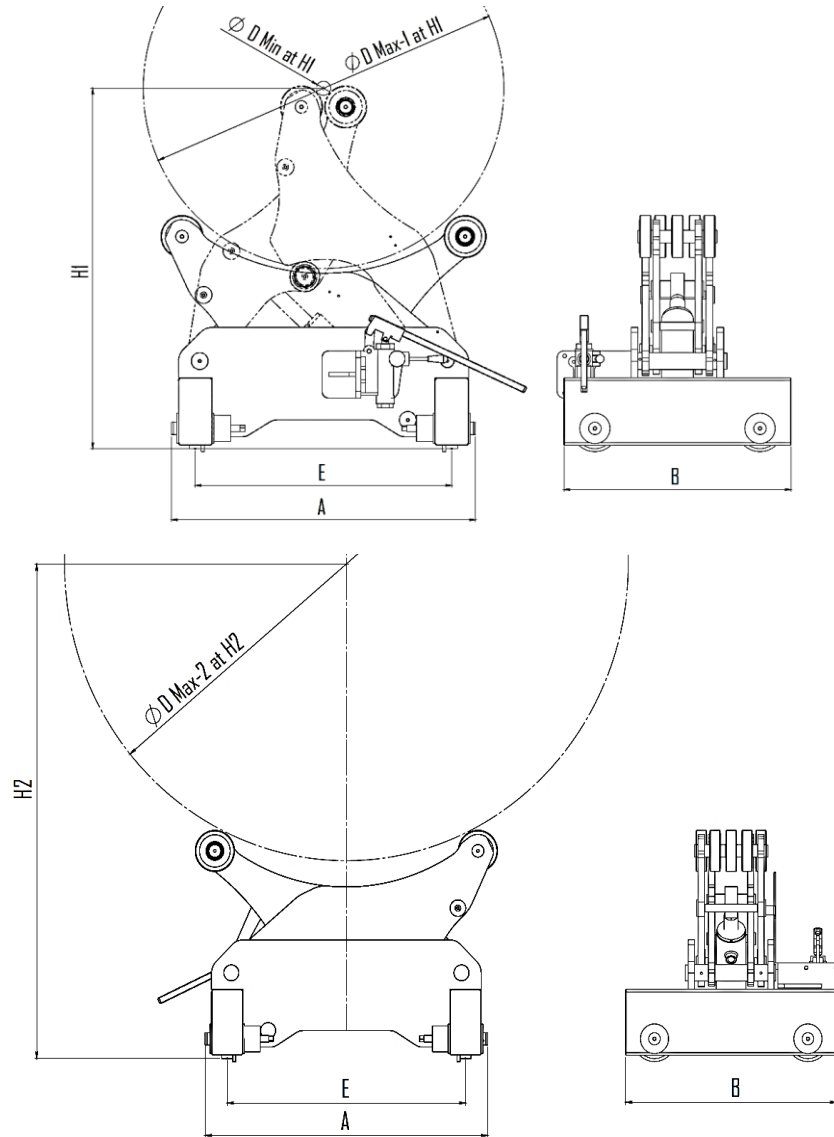
- BHML is designed as a suitable solution to qualified and proper circumferential welding of cylindrical parts according to diameter settings at suitable certain capacities..
- BHML Adjustable diameter Hydraulic Manual Lift minimizes the usage of Crane.
- By easier usage provides saving of time.
- In Pipe welding production , it has an irreplaceable design in centering between Head and Tailstock distances it has an irreplaceable designty
- Although BHML is constituted of single idler unit, If easy movement over a rail arrangement by means of a manual buggy system is requested, By increasing the number of BHML, we can easily provide positioning to more longer parts .
- BHML is produced as standard 3000kg. According to special diameter & load range, we present special customer design production.
- One (1) Year Warranty (wearing parts out of warranty)

Application illustrations ;



❖ All technical specifications are subject to change without prior notice.

TECNICAL PROPERTIES



Technical Details :

Model : BHML	Symb.	Unit	BHML-3
Capacity		kg	3 000
Min.-Max.Rolling Ø – H1 Height	ØDmin at H1-ØDmax-1 at H1	mm	50 – 1070
Max.Rolling Ø – H2 Height	ØD Max- at H2	mm	1800
Height	H1-H2	mm	1070-1500
Rail Axis	E	mm	770
Width	A	mm	900
Length	B	mm	670
Weight		kg	320

↳ Out of these std. capacities, Birel Machinery, according to customer requirements has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT



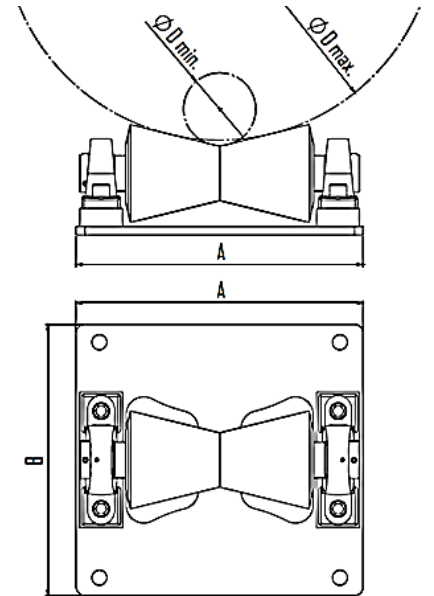
General Features ;

- BHSP model Pipe Feeding Housing is designed for rolling of pipe workpiece over it.
- BHSP model Pipe Feeding housing as standard 1000 kg. is presented.
- BHSP model, According to customer requests, Special productions are manufactured in various diameters & capacities..
- BHSP model equipment is predominantly designed as feeding of pipes in horizontal-vertical and angular regions in long distance laying of pipes.
- An indispensable solution in construction sites & working areas.
- Operators can work more effective and efficient.
- One (1) Year Warranty (wearing parts out of warranty)

Technical Details :

Model : BHSP	Symb.	Unit	BHSP-1
Capacity		kg	1 000
Min.-Max.Rotating Diameter	ØDmin - ØDmax	inch	4" - 24"
Width	A	mm	400
Length	B	mm	380
Weight		kg	37

↪ Out of these std. capacities, Birel Machinery, according to customer requirements has the manufacturing possibility at different capacities, sizes.

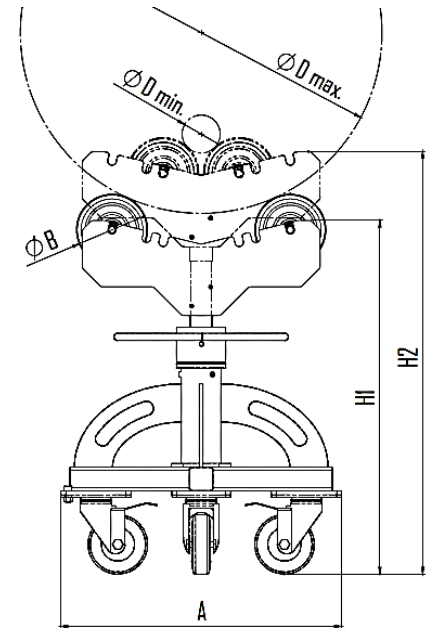
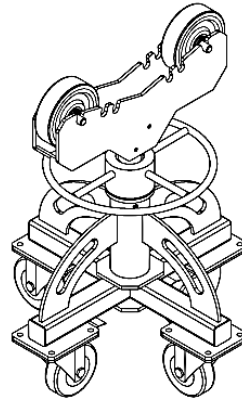
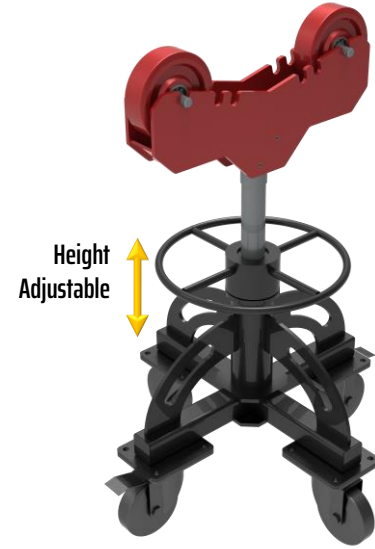


❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

General Features ;

- BBT model Pipe Holder is designed for rolling of pipe workpiece over it.
- Height is adjustable by Handwheel
- BBT model Pipe Holder as standard 250 and 500 kg. are presented.
- BBT model, According to customer requests, special productions are manufactured in various diameters & capacities..
- An indispensable solution in construction sites & working areas.
- Operators can work more effectively and efficiently.
- One (1) Year Warranty (wearing parts out of warranty)



Technical Details :

Model : BBT	Symb.	Unit	BBT 500
Capacity		kg	500
Rotating Diameter	ØDmin - ØDmax	mm.	Ø80 - Ø710
Roller Diameter	ØB	mm	Ø150
Height	H1 - H2	mm	745 - 890
Length	A	mm	600
Weight		kg	65

↪ Out of these standard. capacities, Birel Machinery, according to customer requirements has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT

- Economical
- Easily Operated
- Suitable for lower capacities & Smaller diameters
- Turning and Positioning of small tanks and cylindrical workpieces, etc.



- Application illustration

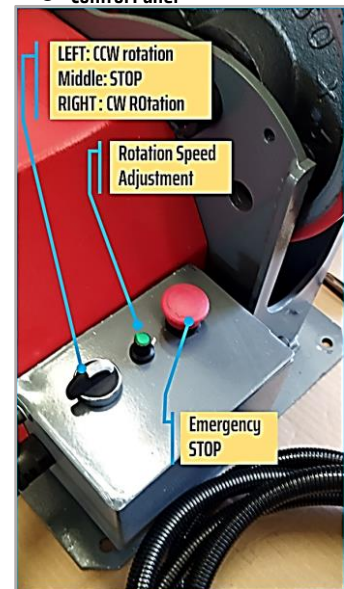


«1» SET	«1 pc.» DRIVEN Unit
includes	«1 pc.» IDLER Unit

Standard Features

- Manual Diameter Range Adjustment by means of two holes
- Adjustable Wheel rotation speed
- Polyurethane Wheels absorbing shocks and vibrations
- 3 mt. Power Cable
- DC Motor
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 220V - (2 phase)
- One (1) Year Warranty (wearing parts out of warranty)

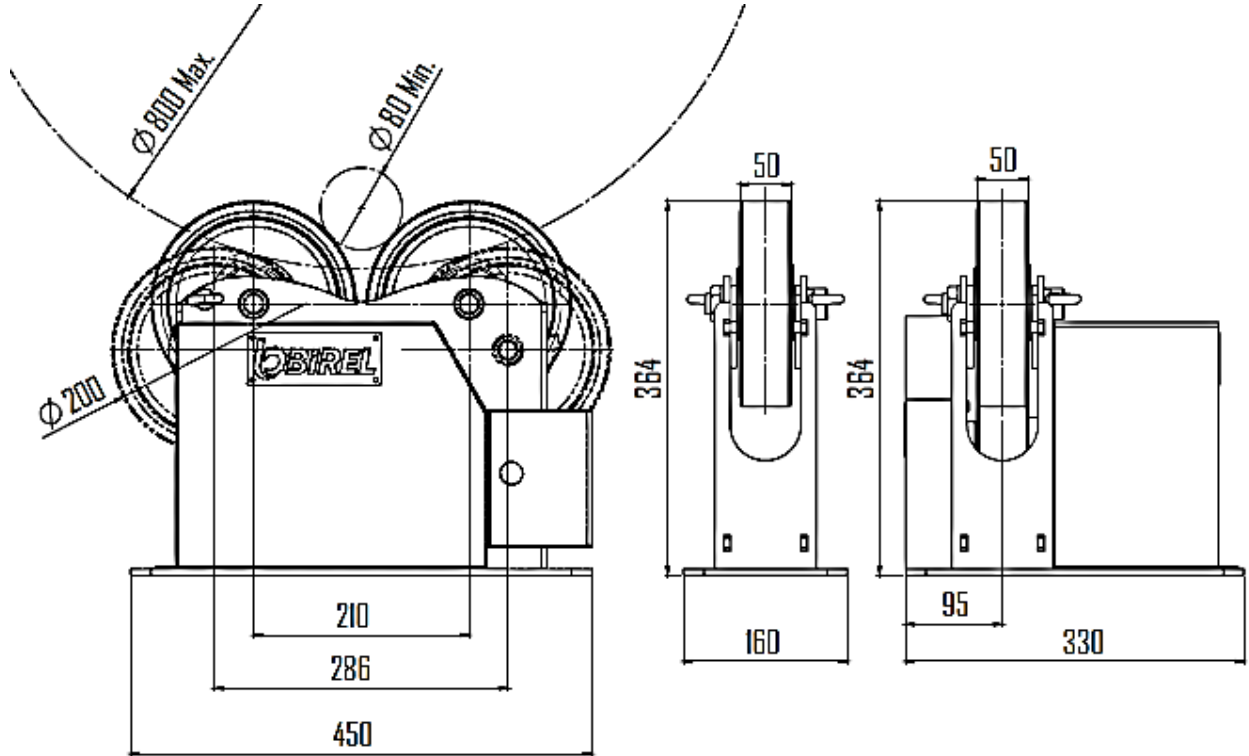
- Control Panel



↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT



Technical Details :

Model : Mini-BCR	Unit	BCR-1,2
Capacity	ton	1,2
Max. Load (Drive Unit)	t/unit	0,6
Max. Load (idler unit)	t/unit	0,6
2 Driven Unit		Optional
Rotation Speed	mm/min	80 - 1600
Diameter Range (ØDmin-ØDmax)	mm	60 - 800
Roller Diameter	mm	200
Roller Width	mm	50
Roller Material		PU
Length (Drive Unit)	mm	450
Length (Idler Unit)	mm	450
Width (Drive Unit)	mm	330
Width (Idler Unit)	mm	160
Height	mm	364
Motor Type		DC
Motor Power	Watt	100 W
Power Supply	V	220V
Weight	kg	60

↳ Out of these std. capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

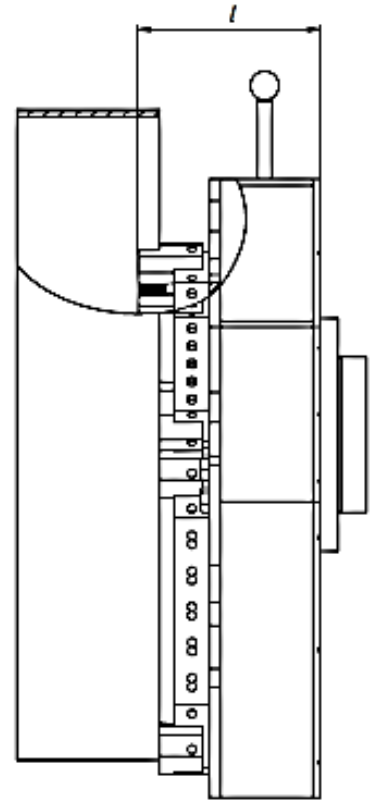
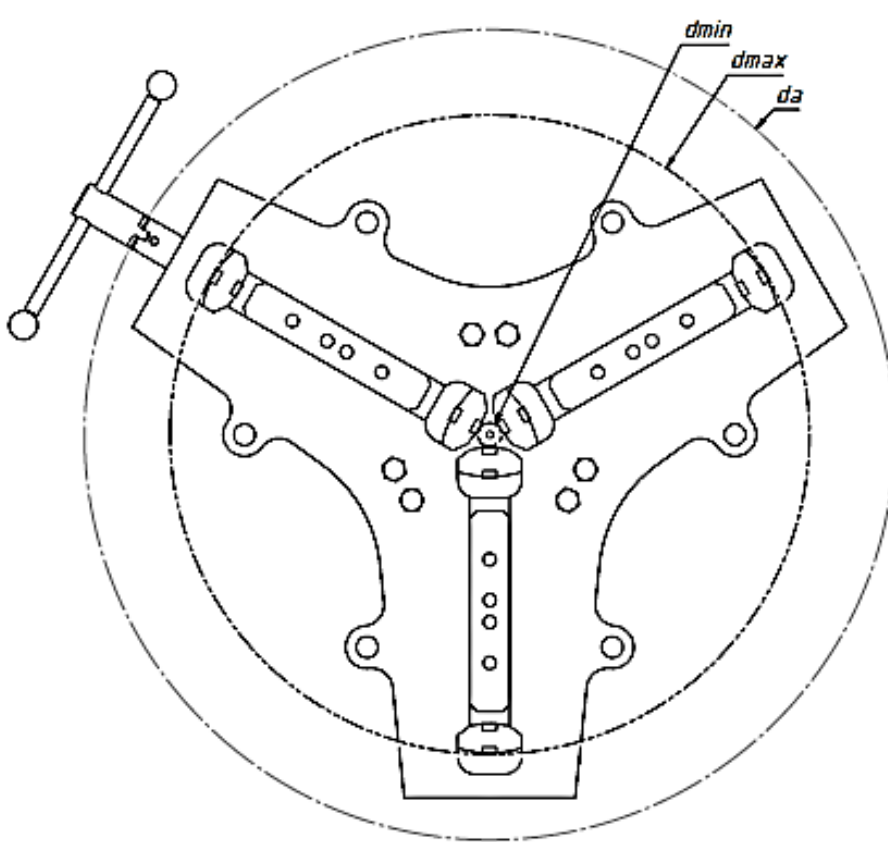
❖ All technical specifications are subject to change without prior notice.

ABOUT PRODUCT



Technical Details :

Model : BGR	Symb.	Unit	BGR-1
Chuck Diameter	$\varnothing da$	mm	1100
Min. Rotating Diameter	$\varnothing dmin$	mm	55
Max. Rotating Diameter	$\varnothing dmax$	mm	935
Height	L	mm	255
Weight		kg	200



❖ All technical specifications are subject to change without prior notice.

C01 : Stationary Version

BCBM-S (Stationary)

Stationary Column-Boom System



Stationary Version



C02 : Movable on Rail Version

BCBM-G (Movable on Rail)

Movable on Rail Column-Boom System



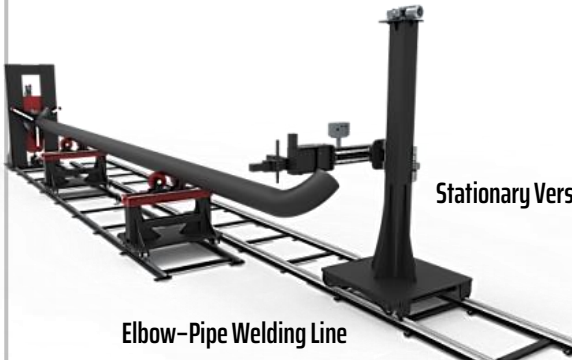
Movable Version



C03 : Elbow-Pipe Welding Line

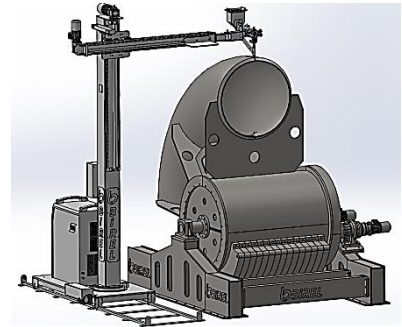
BCBM-BKP (Birel Elbow Welding With Column&Boom)

Elbow Welding Line



Stationary Version

Elbow-Pipe Welding Line



C04 : Mini Version Column-Boom

BCBM-mini

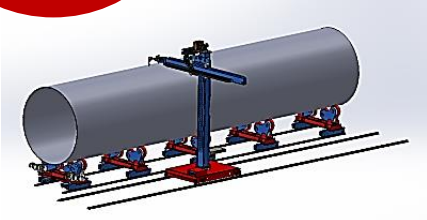
Mini Column-Boom System



❖ All technical specifications are subject to change without prior notice.



ABOUT PRODUCT



General Features ;

- Column-Boom systems, Although can perform welding independently for workpieces, it can also perform circular or lengthwise welding using rotator or positioner.
- Allow reducing the production time and getting tired of operator, as well as, Increase the accuracy and the amount of continuous welding that an operator can do.
- Welding types that can be used by the system; could be SAW, MIG, MAG, etc
- Column-Boom systems over ground ;
 - i) As standard Fixed to ground type is provided.
 - ii) Optionally Automatic Movement over Rails can be manufactured.
- Column Rotary System ;
 - i) As standard, Manual Rotation by means of Butt bearing is provided.
 - ii) Optionally, Automatic Motor Driven type can be manufactured.

Technical Advantages ;

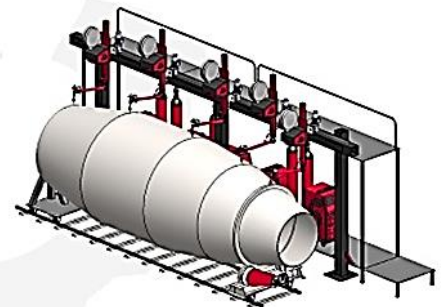
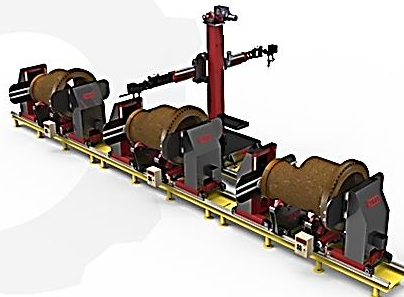
- Birel Machinery as standard provides the following models: BCBM-3x3 | BCBM-4x4 | BCBM-5x5 | BCBM-6x6
- Birel Machinery, out of these standard capacities, according to customer standards & requirements, can present quotation against the machine revision process or fulfill customer request against new designs.
- Motor with brake and forced fan cooling.
- For any special request or project, Please do not hesitate to contact with us.

Standard Equipments

- 360° degree Manually Rotating Column
- Adjustable linear Boom speed
- Boom speed digital display
- Against Anti-fall mechanical Locking System for boom.
- Limit switch for all movements.
- Welding power unit Table on the column.
- Cable channels on the Column – Boom.
- Torch mounting equipment on the boom end.
- 5mt. Hand Box Cable Remote Control.
- 5mt. Power Cable.
- Chassis Color (RAL 7011-Grey) and Covers(RAL 3020-Red)
- Brake & Fan Cooled Motor (Asynchronous)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One (1) Year Warranty (wearing parts out of warranty)

Optional Control Units

- Column and Boom System moving on Rail. (BCMB-M model)
- Master Command Panel
- Automatic Rotary Column
- Operator Chair
- Stairs
- Tandem Welding Apparatus
- Lighting.
- Synchronization opportunity of working with Rotators over Master Panel.
- Oscillator System (with MIG/MAG)
- Rail movement
- SAW, MIG/MAG Weldings
- Joint Tracking System – Laser
- Joint Tracking System – Mechanical Sensor.
- Automation Systems
- Wireless remote controller



❖ All technical specifications are subject to change without prior notice.

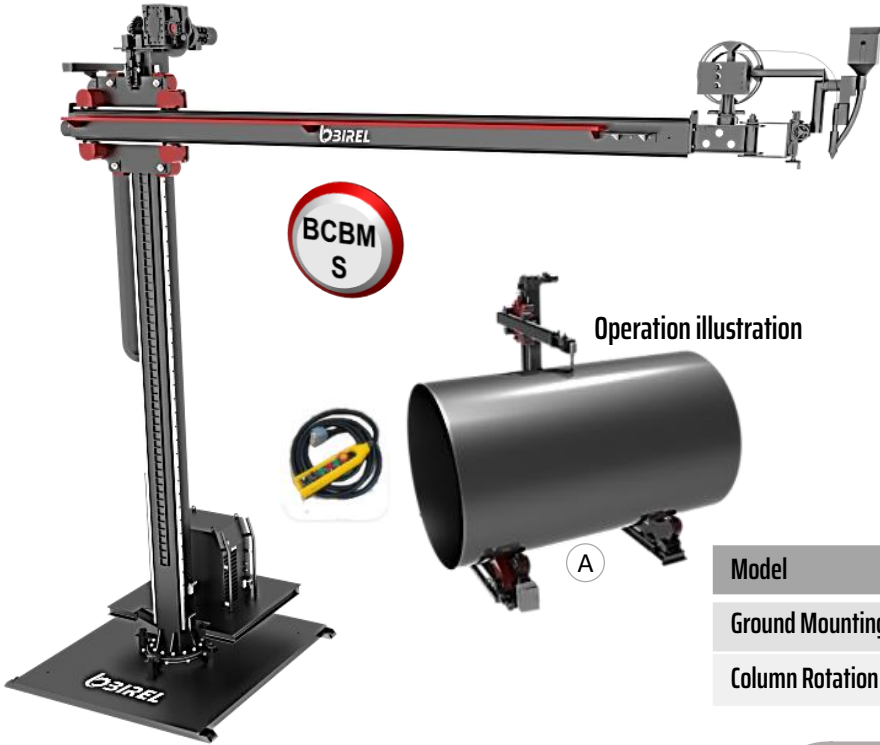
BCBM
S

Chapter-C : Column-Boom | C01 : Stationary Version

STATIONARY Version Column-Boom System

BIREL
MÜHENDİSLİK MAKİNA A.Ş.

STATIONARY VERSION



Model	BCBM-S Version STANDARD VERSION
Ground Mounting	Fixed To Ground
Column Rotation	Manual Rotation over butt bearing



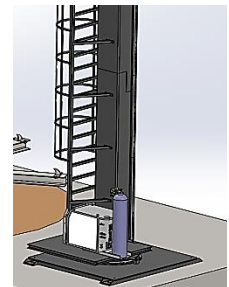
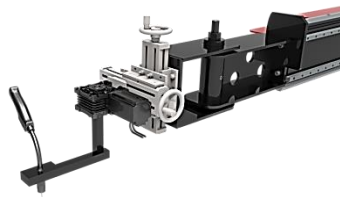
OPTIONAL Modifications & Equipments;

M01: Movable Chair

M02: Oscillator

M03: Motorised Column Rotation

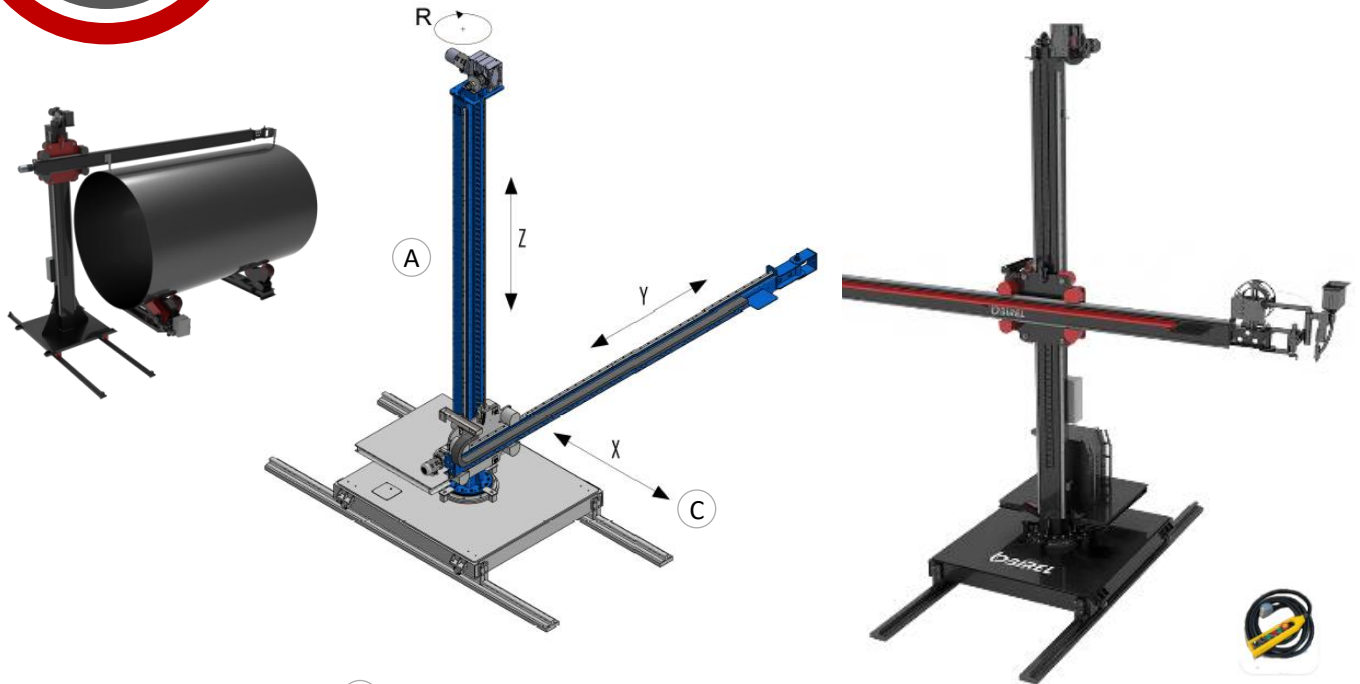
M04: Steel Stair



❖ All technical specifications are subject to change without prior notice.

Birel Mühendislik Makine San. Tic. A.Ş. | Adresses: Yaylacik Mahallesi Dogancilar Mevkii 46. Sok. No:4/1 Nilüfer/Bursa – TURKEY
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Sales: Email: sales@birelmakina.com Direct Mobil: +90.5462016491

MOVABLE ON RAIL VERSION



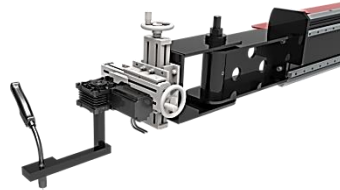
Model	RAIL VERSION
Ground Mounting	Movable on Rail
Column Rotation	Manual Rotation

OPTIONAL Modifications & Equipments;

M01: Movable Chair



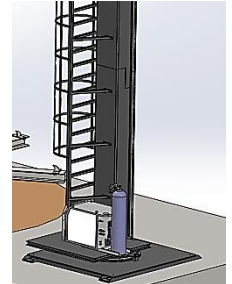
M02: Oscillator



M03: Motorised Column Rotation



M04: Steel Stair



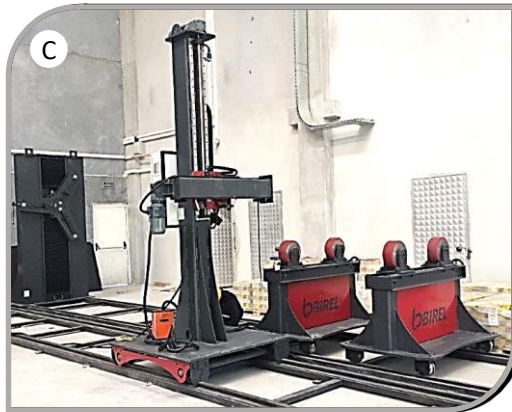
❖ All technical specifications are subject to change without prior notice.



ELBOW-PIPE WELDING LINE

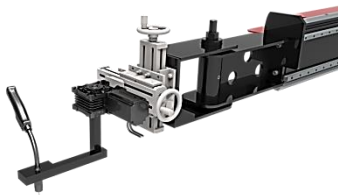


Model	ELBOW – PIPE Welding Line
Ground Mounting	Movable on Rail
Column Rotation	As standard not available (optional)



OPTIONAL Modifications & Equipments;

M01:Oscillator



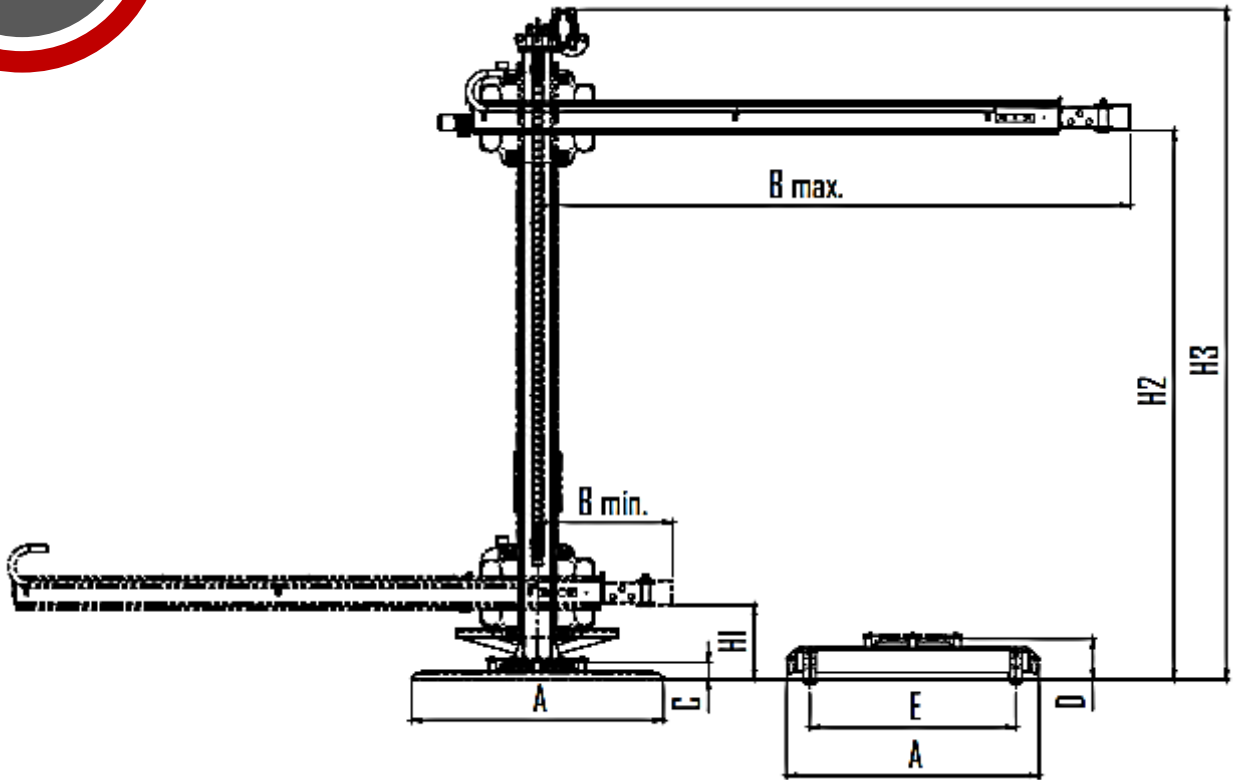
M02:Motorised Column Rotation



❖ All technical specifications are subject to change without prior notice.



TECHNICAL PROPERTIES



Technical Details :

Model : BCBM	Symb.	Unit	BCBM-3 x 3	BCBM-4 x 4	BCBM-5 x 5	BCBM-6 x 6
Working range		m	3 x 3	4 x 4	5 x 5	6 x 6
Max load (boom)		kg	200	200	150	150
Boom speed (welding) min/max		mm/min	200-1850	200-1850	200-1850	200-1850
Lifting speed min/max		mm/min	1.220	1.220	1.220	1.220
Column rotation			manual	manual	manual	manual
Column rotation motorized			option	option	option	option
Boom height Max (movable base)	H2+(D-C)	mm	4.000	5.000	6.000	6.920
Boom height Min (movable base)	H1+(D-C)	mm	850	850	980	920
Height (Moveable Type)	H3+(D-C)	mm	4.970	6.050	7.050	8.010
Boom height Max (stationary base)	H2	mm	3.800	4.800	5.800	6.800
Boom height Min (stationary base)	H1	mm	650	650	780	780
Height (Fixed Type)	H3	mm	4.770	5.850	6.850	7.850
Extension min/max	Bmax-Bmin	mm	1180-4180	1180-5180	1180-6180	1290-7290
Base size (width x length)	A	mm	2200x2200	2200x2200	2200x2200	2400x2400
Base speed (welding) min/max		mm / min	200-1770	200-1770	200-1770	200-1770
Track width (inside to inside)	E	mm	1.800	1.800	1.800	2.000
Rail type			A55	A55	A55	A55
Platform size (width x length)		mm	1230x1400	1230x1400	1230x1400	1230x1400
Total load on platform		kg	150	150	150	150
Weight (Moveable Type)		kg	2.790	3.060	4.100	4.900
Weight (Fixed Type)		kg	2.380	2.620	3.780	4.200
Total Motor Power		kW	1	1	1	1

↳ Out of these standard capacities, Birel Machinery, according to customer requirements, has the manufacturing possibility at different capacities, sizes.

❖ All technical specifications are subject to change without prior notice.

BCBM

Mini

Section-C : Column & Boom | C05 :Mini Column&Boom Welding Line

Manual MOVABLE Mini Version Column & Boom Welding Line

BIREL
MÜHENDİSLİK MAKİNA A.Ş.

Mini-VERSION



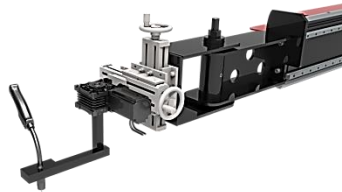
BCBM
Mini

Model	Mini Version Column – Boom Welding Line
Ground Mounting	MANUAL Movable on Rail
Column Rotation	NOT available (OPTIONAL)



OPTIONAL Modifications & Equipments;

M01:Oscillator



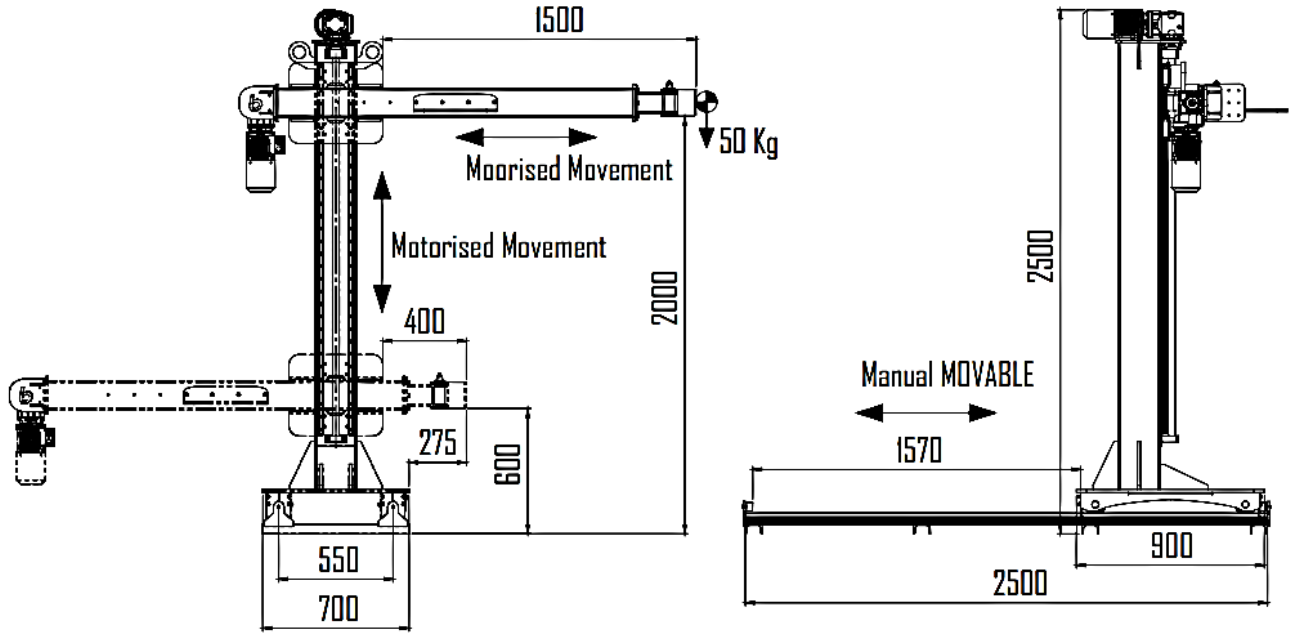
M03:Motorised Column Rotation



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Mini-BCBM VERSION TECHNICAL PROPERTIES



Standard Equipments

- Theaded Shaft Lifting
- Column and Boom on Linear Guides movement
- Ajustable linear Boom speed
- Boom speed digital display
- Limit switch for all movements.
- Cable channels on the Column – Boom.
- Torch mounting equipment on the boom end.
- 5mt.Cable Remote Handbox Control.
- 5mt.Power Cable
- Standard Machine Colors:
 - Chassis RAL 7011(Grey)
 - Sheet Covers:RAL 3020(Red)
- Power Supply: 380V - (3 phase+Neutral +Earthing)
- One(1) Year Warranty

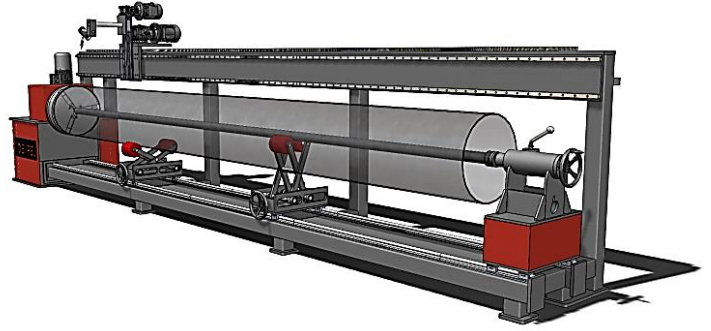
Technical Details :

Model : Mini-Column-Boom	Unit	Mini-BCBM 2x1,5
Working Range	m	2 x 1,5
Max. Load (Boom)	kg	50
Boom Speed (welding)	mm/ min	70 - 700
Boom Height Max (Movable Base)	mm	2000
Boom Height Min (Movable Base)	mm	600
Height (Movable Type)	mm	2500
Extension min/max	mm	400 – 1500
Base Size (width x length)	mm	700 x 900
Base Move Type		MANUAL
Track Width (Axis)	mm	550
Rail Type		A45
Total Motor Power	kW	1

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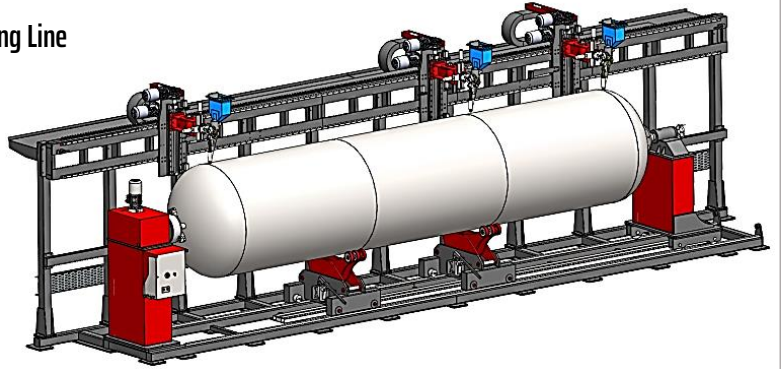
Project: D01-A

Circular SAW,GMAW Portal Welding Line



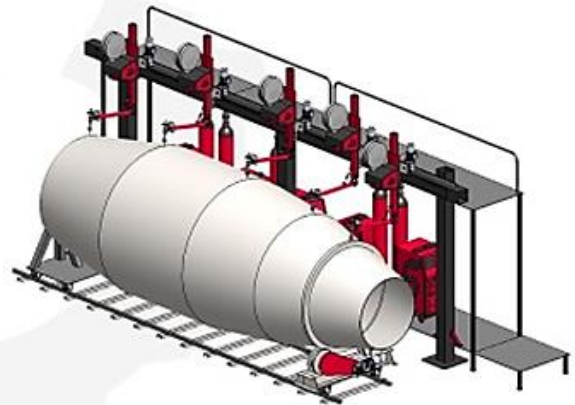
Project: D01-B

Circular SAW,GMAW Portal Welding Line



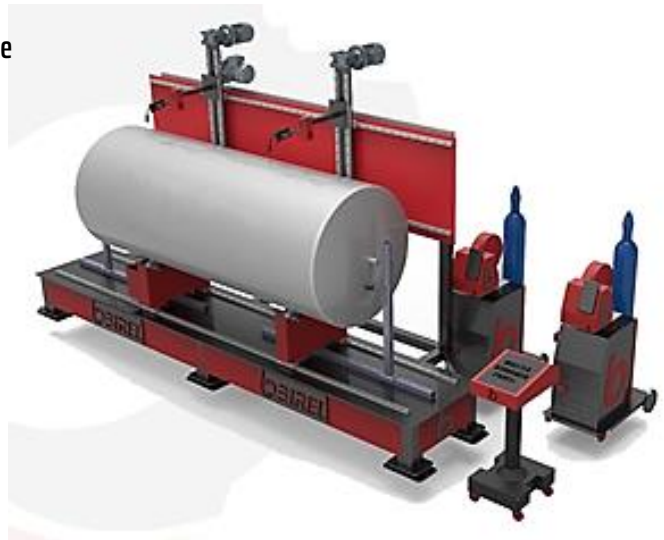
Project: D01-C

Circular SAW,GMAW Portal Welding Line



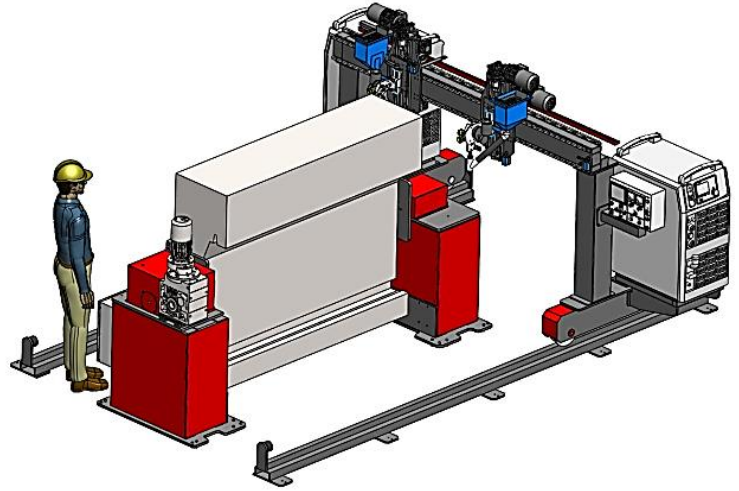
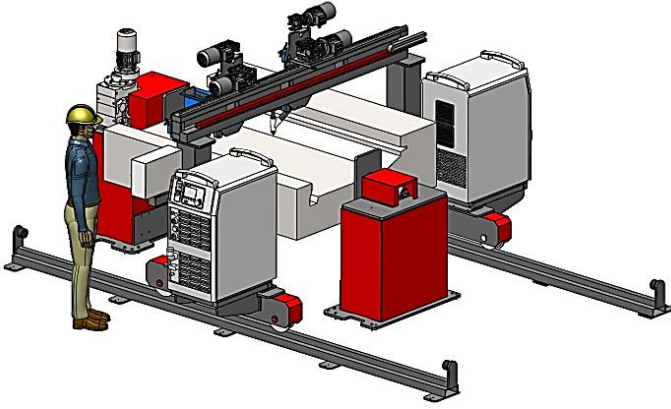
Project: D01-D

Circular SAW,GMAW Portal Welding Line

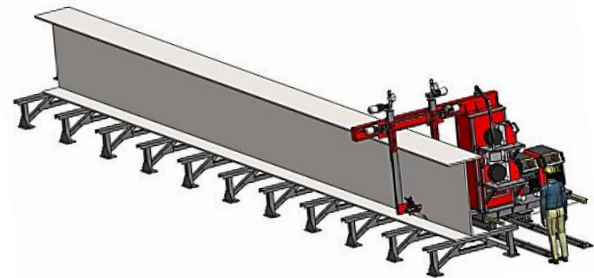
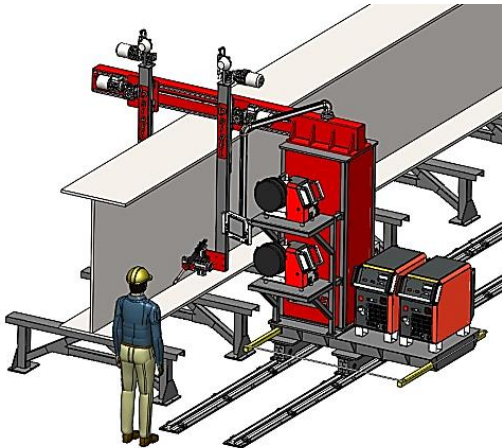
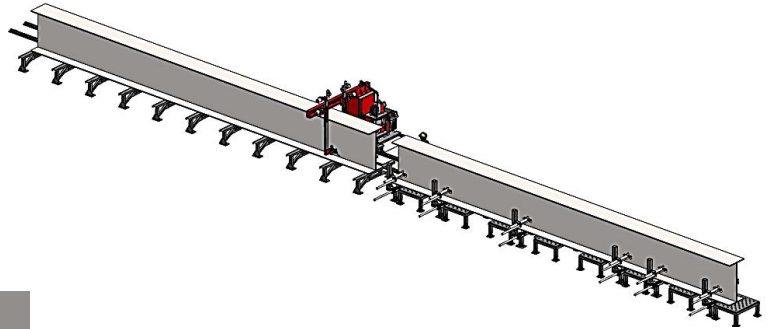


❖ All technical specifications are subject to change without prior notice.

Project: D02-A Gantry Tipi Kaynak Otomasyon Hattı



Project: D02-B H-Beam Kaynak Hattı



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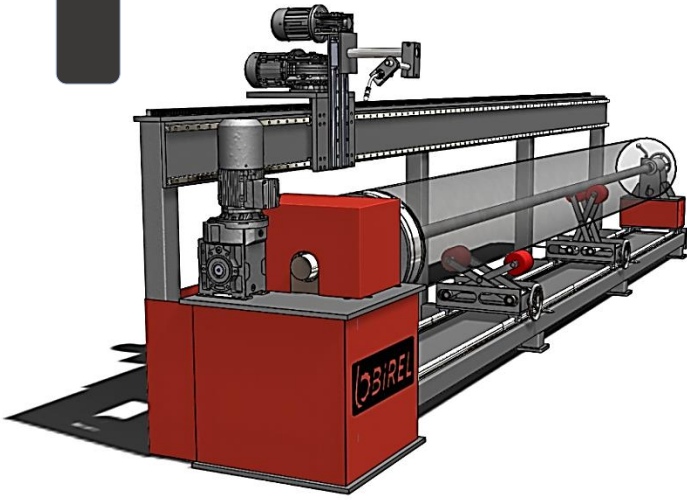
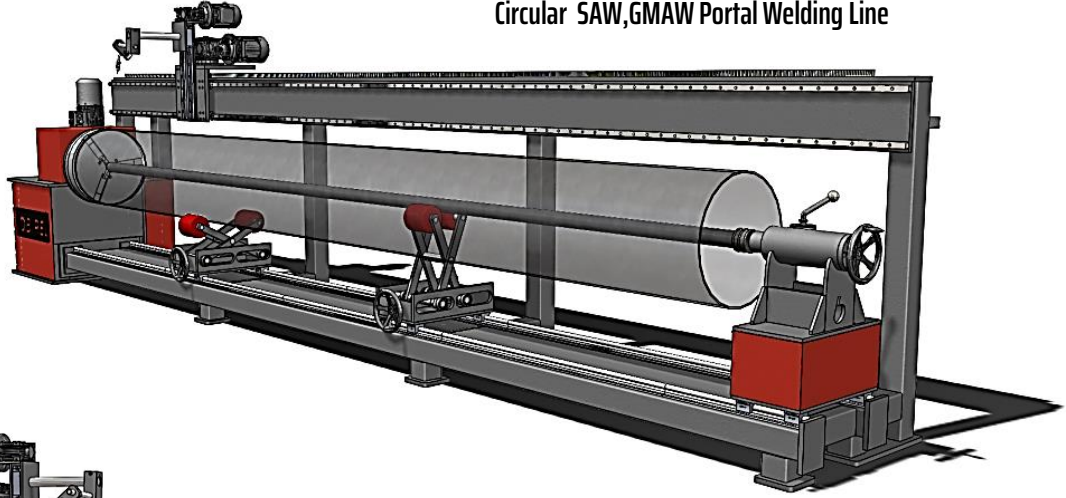
D01

Circular SAW,GMAW Portal Welding Lines

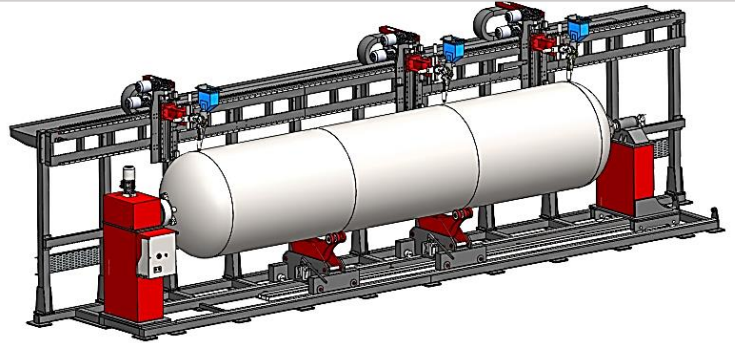
ÜRÜN HAKKINDA

Circular SAW,GMAW Portal Welding Line

Project: D01-A



Circular SAW,GMAW Portal Welding Line



Proje: D01-B



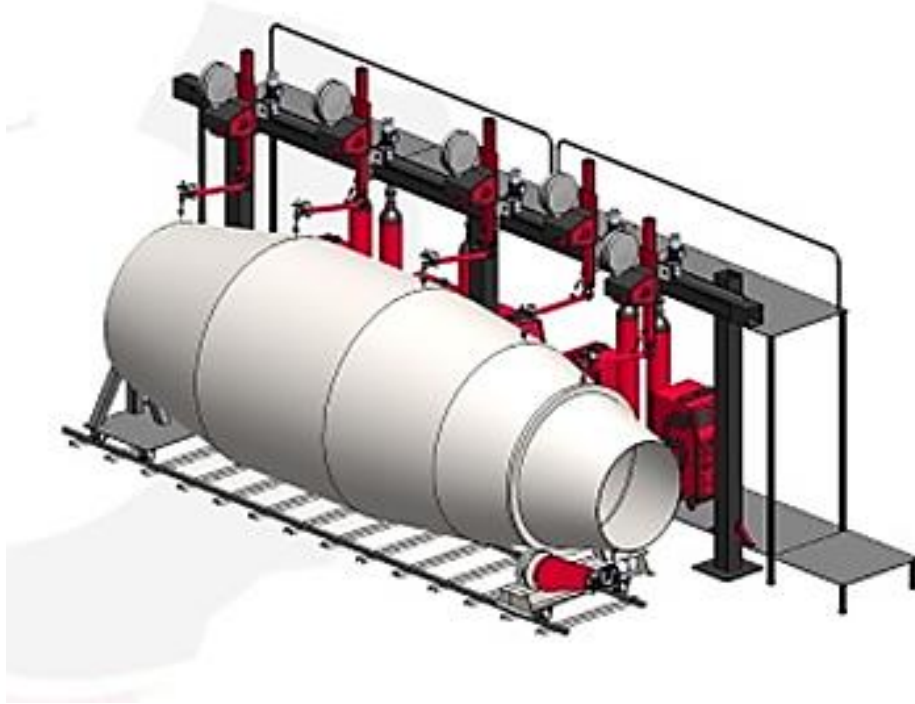
❖ All technical specifications are subject to change without prior notice.

D01

ABOUT PROJECT

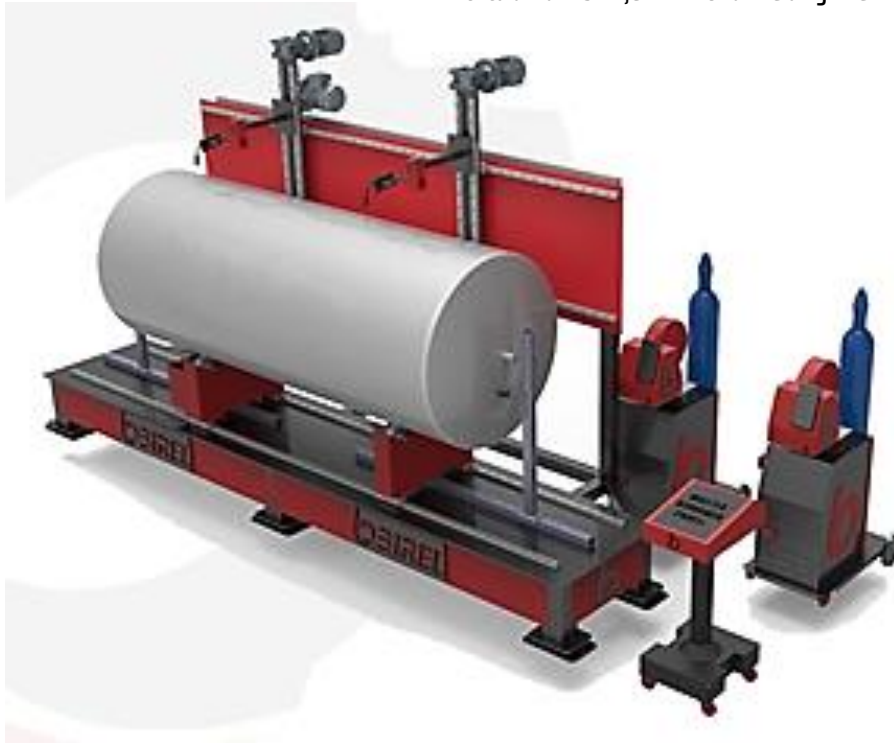
Circular Tank SAW,GMAW Portal Welding Line

Project: D01-C



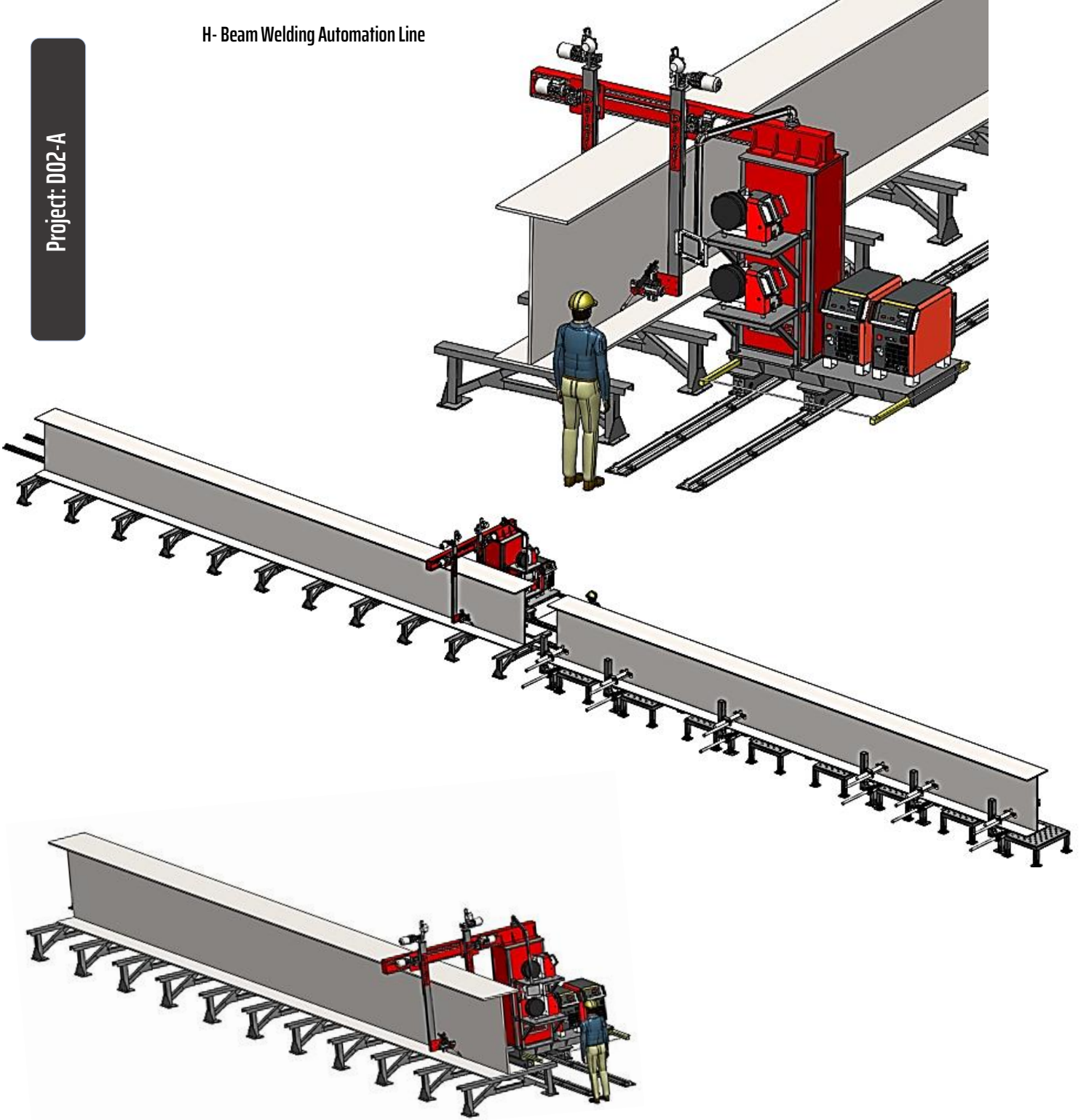
Circular Tank SAW,GMAW Portal Welding Line

Project: D01-D



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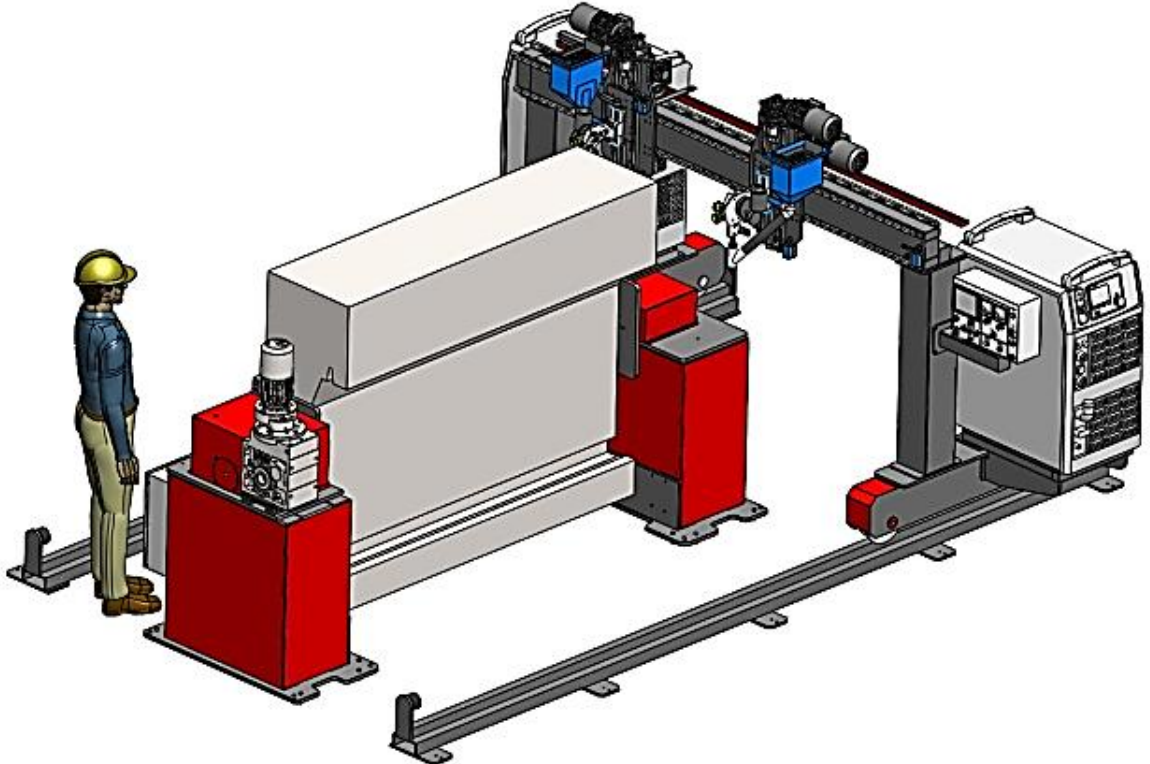
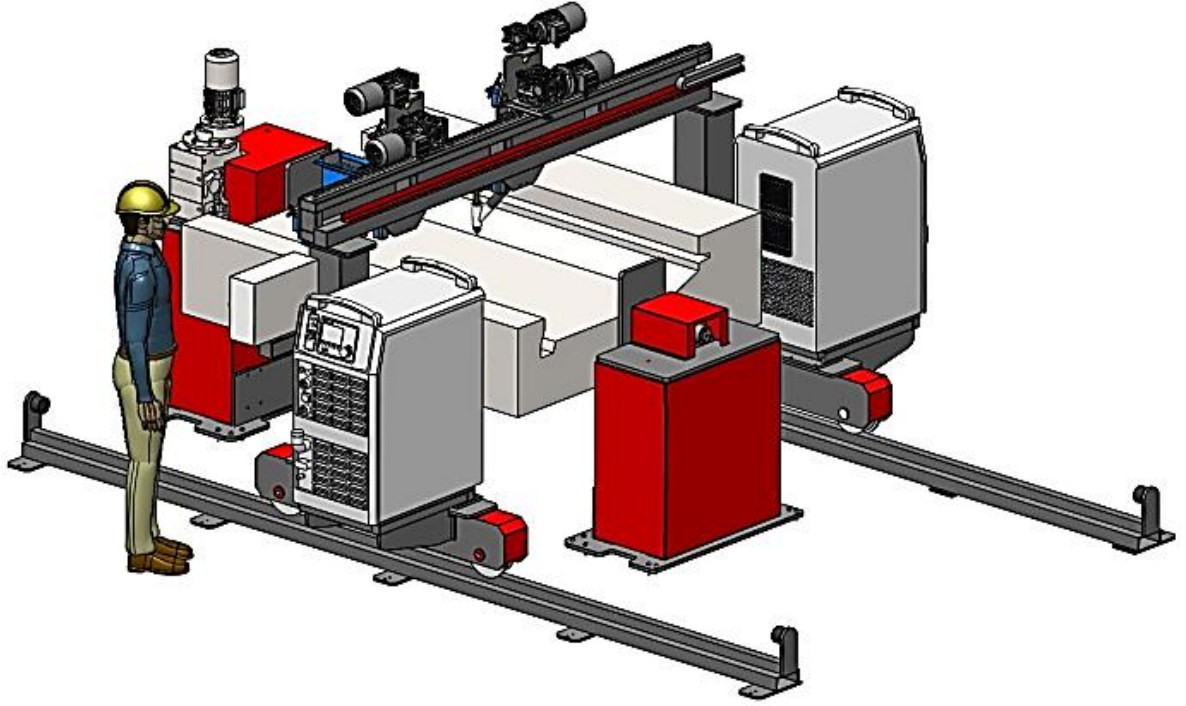
H- Beam Welding Automation Line



❖ All technical specifications are subject to change without prior notice.

Gantry Type Welding Automation Line

Project: D02-B

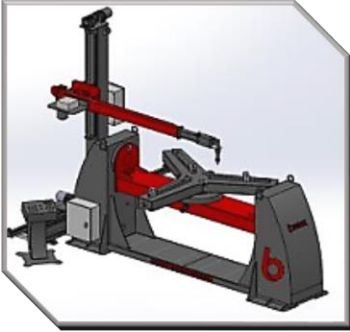


❖ All technical specifications are subject to change without prior notice.

E01: AFR-Axial Fan Rotator

AFR

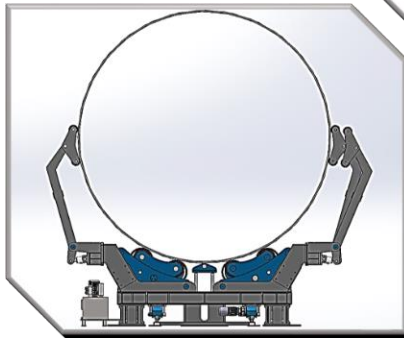
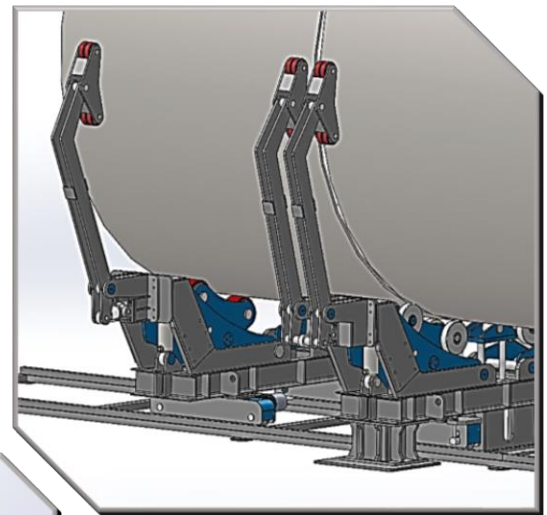
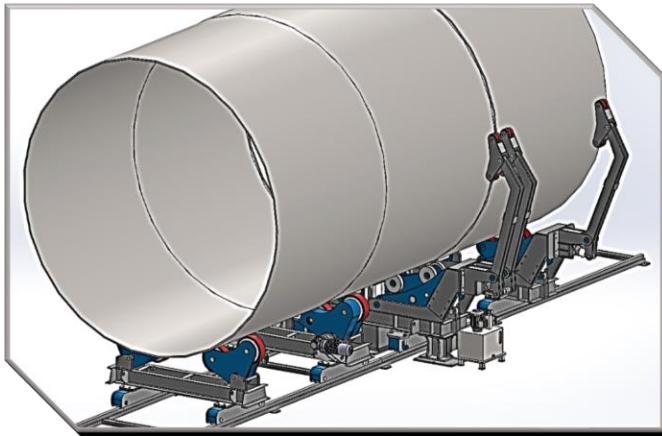
Axial Fan Rotator



E02: FIT-UP Thin Tube Systems

FIT-UP

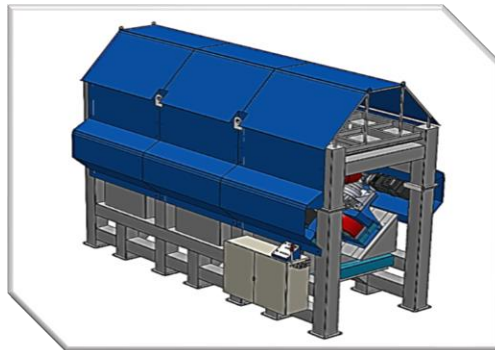
Thin Tube Systems



E03: Pipe Automatic Feeding

BB05

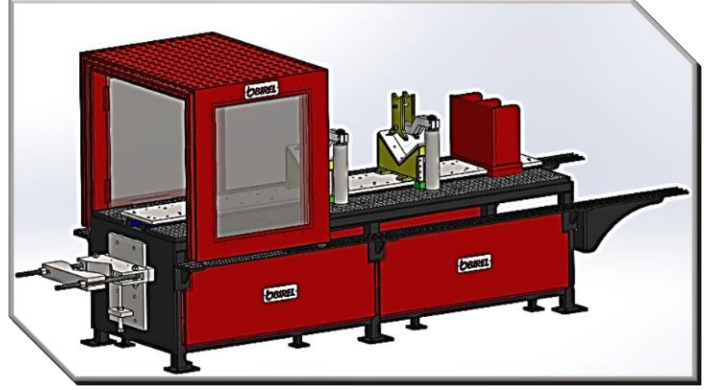
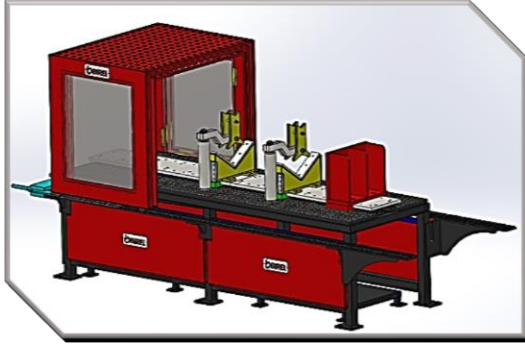
Pipe Automatic Feeding



❖ All technical specifications are subject to change without prior notice.

E04: Test Machine

BHST Hydraulic Cylinder Test Machine

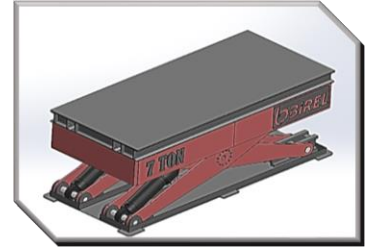


E05: Robot Room

Robot Room



E06: Scissor Type Hydraulic Lift



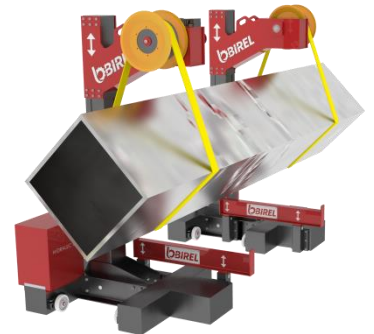
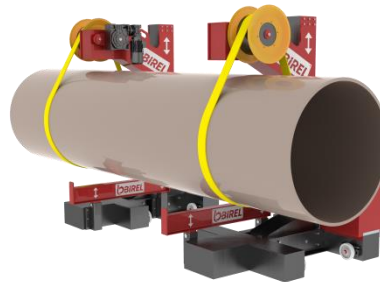
E07: Section Ring Rotator

Section Ring Rotator



E08: Section Rope Rotator

Planar Section Rope Rotator



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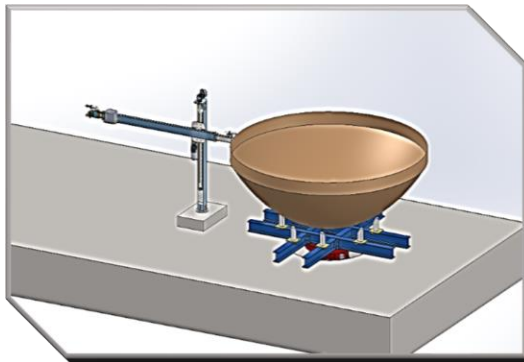
E09: Sheet Metal Lifter

Sheet Metal Lifter



E10: Half Sphere Edge Cutting

Dished Sheet Metal Edge Cutting

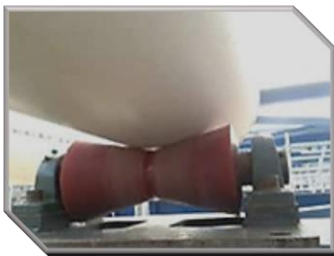


E11: Support Types

BHSP



Pipe Feeding Guide



BBT



Pipe Holder



Mini-BCR



Mini-Conventional Rotator



BGR



3-JAW Pipe Chuck



❖ All technical specifications are subject to change without prior notice.

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LET'S BE ONE HAND

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