

BIAX POWER SCRAPERS



- Many times faster and more accurate than hand scraping
- Great for OEM remanufacturing and MRO applications
- Quick and easy to use – reduces fatigue
- Adapts to individual operator techniques
- Use on cast steel, hard cast iron, malleable cast iron, nonferrous materials and more

Five unique scraper models are available to suit your specific needs:

Technical Specifications

Applications

<p>7ESM/BS-40 Heavy-duty, variable-speed electric model*</p> <p>Scraping Speed, <i>electronically variable</i>..... Up to 1900 strokes/minute</p> <p>Length of Stroke, <i>infinitely variable</i>..... 0 to 0.8" (0 to 20mm)</p> <p>Operating Voltage, Standard..... 110 VAC, 60Hz (220 V available)</p> <p>Power Draw..... 320 watts</p> <p>Weight..... 11.5 lbs. (5.2kg)</p> <p>Dimensions 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)</p>	<p>Heavy roughing and work on large machines and equipment. Scraping of hardened steel guide ways. Large turbine housings, drives, pumps, valves. Extension handle included.</p>
<p>7ELM/BL-40 All-purpose, medium-weight, variable-speed electric model*</p> <p>Scraping Speed, <i>electronically variable</i>..... Up to 1900 strokes/minute</p> <p>Length of Stroke, <i>infinitely variable</i>..... 0 to 0.8" (0 to 20mm)</p> <p>Operating Voltage, Standard..... 110 VAC, 60Hz (220 V available)</p> <p>Power Draw..... 320 watts</p> <p>Weight..... 9.3 lbs. (4.2kg)</p> <p>Dimensions..... 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)</p>	<p>Specially designed for Scraping Technique 40. Roughing, semifinish and finish scraping. Oil-tight or steam-tight scraping. Dovetail and Vee-way scraping. Uprights, cross-rails and harder-to-reach areas. Machine tool maintenance and repair. <i>Our all-purpose workhorse for medium to larger work.</i></p>
<p>BL-10 All-purpose, lightweight, variable-speed electric model*</p> <p>Scraping Speed, <i>electronically variable</i>..... Up to 1900 strokes/minute</p> <p>Length of Stroke, <i>infinitely variable</i>..... 0 to 0.4" (0 to 10mm)</p> <p>Operating Voltage, Standard..... 110 VAC, 60Hz (220 V available)</p> <p>Power Draw..... 320 watts</p> <p>Weight..... 7.0 lbs. (3.3kg)</p> <p>Dimensions..... 4.4" x 2.6" x 12.6" (110 x 65 x 320mm)</p>	<p>The ideal scraper for square, Vee and dovetail ways. Highest-quality bearing points and finish on surface plates and master plates. Lightweight and compact design makes this model particularly suitable for finish scraping of cast steel, cast iron, brass and way-liner material. <i>Our all-purpose model for medium to smaller work.</i></p>
<p>7DLM All-purpose, single-speed pneumatic model*</p> <p>Scraping Speed, <i>at 6 bar (90 psi)</i>..... 1400 strokes/minute</p> <p>Length of Stroke, <i>infinitely variable</i>..... 0 to 0.8" (0 to 20mm)</p> <p>Power Draw..... 350 watts</p> <p>Weight..... 8.0 lbs. (3.6kg)</p> <p>Dimensions..... 4.4" x 1.8" x 16.8" (110 x 45 x 425mm)</p> <p>Hose Connection..... 3/8" pipe thread</p> <p><i>Model available on request.</i></p>	<p>Available on request:</p> <p>Used on applications where pneumatic power is desired or necessary (danger of explosion). Same applications as the 7ELM/BL-40 model. Single stroke speed. Often used for special applications in chemical, plastics and food industries to scrape off hardened resin or coating residue, etc. Muffler/air silencer not included.</p>
<p>HM-10 Half-moon pattern, variable-speed electric model*</p> <p>Scraping Speed, <i>electronically variable</i>..... Up to 1900 strokes/minute</p> <p>Length of Stroke..... Fixed</p> <p>Pattern Size (<i>depends on blade</i>)..... Small, Medium, Large, Extra Large</p> <p>Operating Voltage, Standard..... 110 VAC, 60Hz (220 V available)</p> <p>Power Draw..... 320 watts</p> <p>Weight..... 6.2 lbs. (2.8kg)</p> <p>Dimensions..... 4.4" x 2.6" x 12.6" (110 x 65 x 320mm)</p>	<p>Scraping of half-moon oil-pocket patterns for slide way lubrication, or to break up friction and "stick-slip" on precision-machined flat surfaces and ways. Pattern creates pleasing appearance and ensures good surface lubrication with better wear characteristics. Rescraping of worn ways to reestablish lubrication and prevent further wear. Our "Flaker" or "Spotter" model.</p>

* Blades not included. See pages 2 & 3 for blade selection.

BIAX POWER SCRAPERS **Blade Kit Selection**

Scraper blade kits, scraper blades and inserts with holders will fit all scraper models except Half-Moon Pattern Scraper HM10. The HM10 takes the #8/E kit as well as the separate blades listed below.

Blade Kits

Description	Order
<p>BLADE KIT, Assortment ALL-PURPOSE Our most popular set includes general scraping blades, inserts and insert holders. Contents: #15, 20, 25, 30 blades; #25/20, 25/25, 25/30 indexable carbide inserts; #30/40 HSS indexing inserts; #120M, 130M insert holders; control gauge.</p> <p>BLADE KIT, Assortment FINISH Long, flexible blades give a soft feel and are most suitable for semifinish and finish work. This set greatly enhances all scraper models when semifinish and finish scraping is desired. Contents: #10-150, 15-150, 20-150, 25-150, 30-150 carbide-tipped blades; 20-150ST steel scraping blades; control gauge.</p> <p>BLADE KIT, Assortment DOVETAIL This kit contains the proper blades for dovetail and hard-to-reach area scraping in horizontal and vertical positions. A perfect addition to the all-purpose blade kit. Contents: #25/20, 25/25 carbide inserts; 15T, 20T twisted long blades; 120MT, 130MT twisted insert holders; crimped insert holders; 30/25HSS insert; KL170 blade extension for use on hard-to-reach areas, used with long finish blades.</p> <p>BLADE KIT, Assortment #8/E This kit is used only for half-moon pattern scraping with Model HM10 and is the perfect complementary kit for this model. Contents: #R60, R90, R120, R150, KL70, KL140; control gauge.</p>	<p>Blade Kit ALL-PURPOSE</p> <p>Blade Kit FINISH</p> <p>Blade Kit DOVETAIL</p> <p>Blade Kit #8/E</p>

Replacement Blades for Half-Moon Pattern Scraper Model HM10

Description	Radius	Catalog Number
<p>Half-Moon Pattern Scraper Blades (for holders)</p> <ul style="list-style-type: none"> • Small pattern • Standard pattern • Large pattern • Extra-large pattern 	<p>2-3/8"</p> <p>3-5/8"</p> <p>4-3/4"</p> <p>6"</p>	<p>R60</p> <p>R90</p> <p>R120</p> <p>R150</p>
<p>Tool Holders for half-moon pattern scraper blades, Series R60-R150</p> <ul style="list-style-type: none"> • Short holder • Long holder 	<p>3"</p> <p>6"</p>	<p>KL70</p> <p>KL140</p>
<p>Half-Moon Pattern Carbide Blades</p> <ul style="list-style-type: none"> • Small pattern • Standard pattern • Large pattern • Extra-large pattern 	<p>2-3/8"</p> <p>3-5/8"</p> <p>4-3/4"</p> <p>6"</p>	<p>R60KL</p> <p>R90KL</p> <p>R120KL</p> <p>R150KL</p>

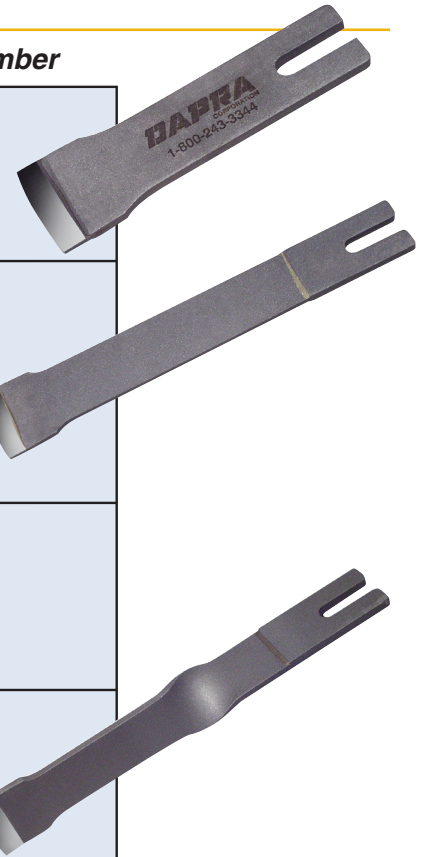


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Replacement Blade Selection

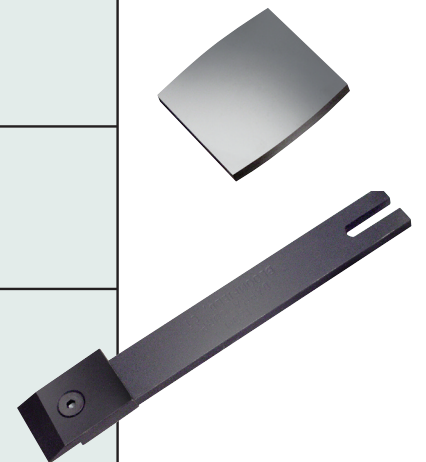
Individual Replacement Blades

Description	Width	Catalog Number
Scraper Blades Carbide-tipped, reversible, standard stiff type, regular length (3-1/2"), all-purpose	5/8" 3/4" 1" 1-1/4"	15 20 25 30
Scraper Blades Carbide-tipped, reversible, special elastic type, long length (6"), for smooth semifinishing and finishing	3/8" 5/8" 3/4" 1" 1-1/4"	10-150 15-150 20-150 25-150 30-150
* Special HSS Blade for steel scraping	3/4"	20-150ST
Scraper Blades Carbide-tipped, special tight radius for point scraping and Scraper Technique 40 <ul style="list-style-type: none"> • Short type, 40mm radius • Long type, 20mm radius 	3/4" 5/8"	20-R40 15-150-R20
Scraper Blades Carbide-tipped, reversible, special 90° twisted stiff type, long length (6"), for dovetail work and hard-to-reach areas	5/8" 3/4" 1" 1-1/4"	15T 20T 25T 30T



Individual Replacement Inserts and Holders

Description	Width	Catalog Number
Scraper Blades All-purpose indexable insert type made of solid carbide. Ideal for scraping most materials. 1" length. To be used with tool holders below.	3/4" 1" 1-1/4"	25/20 25/25 25/30
Scraper Blades Indexable insert made of special HSS. To be used with holder, positive cutting angle, 1-1/4" length. Used to scrape softer wrought and cast steels. Use with 120M and 130M holders.	1" 1-5/8"	30/25HSS 30/40HSS
Tool Holder For indexable insert type blades. <ul style="list-style-type: none"> • Short (3"), stiff type • Long (6") • Long (6"), 90° twisted 		120M 130M 130MT
Tool Holder Extension For scraping of dovetails and hard-to-reach areas. Use with the long special elastic scraper blade series – 150, 6-3/4" long.		KL170

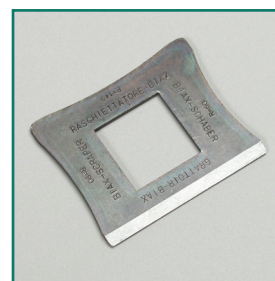


Scraping Accessories and Aids

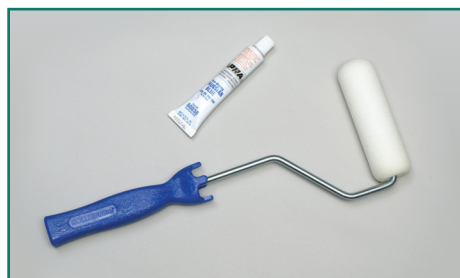
Description	Catalog Number
Water-Soluble Spotting Ink* In plastic bottle dispenser (other sizes & colors available upon request) <ul style="list-style-type: none"> • Blue spotting ink • Red spotting ink • Yellow spotting ink <i>*Other colors available, subject to minimum order requirements. Contact Dapra for details.</i>	1-1/2 oz. - BB10000 / 8 oz. - BB10007 1-1/2 oz. - BB10005 / 8 oz. - BB10008 1-1/2 oz. - BB10006 / 8 oz. - BB10009
Prussian Blue and Spotting Ink Roller <ul style="list-style-type: none"> • Prussian Blue [in tube, .75 oz. or 7" (on request)] • Large Ink Roller, 2" dia. x 6" • Small Ink Roller, 1-1/2" dia. x 5" • Small Ink Pad 	BB10011 / BB10010 (on request) BB10019 BB10015 BB10016
Control Gauge For checking of scraper blade radii, checking of carrying points per square inch and removal of scraping chips, dust, etc.	4 EAS/87
Hand Scraper Universal hand scraper for use with all Biax Scraper blades. Without extension: 15.75" x 1" With extension: 18" x 1"	BB20016
Book and DVD <ul style="list-style-type: none"> • "Machine Tool Reconditioning," a 500+ page comprehensive, time-tested publication with many photos and illustrations 	BB50000
<ul style="list-style-type: none"> • 3-Part Scraping DVD 	BB50020



Water-Soluble Spotting Ink



Control Gauge



Prussian Blue and Spotting Ink Roller



Hand Scraper Set



Book

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