

# BIAX Power Scrapers

BIAX power scrapers from Dapra are many times faster and more accurate than hand scraping, making them ideal 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
<b>7ESM/BS-40 Heavy-duty, variable-speed electric scraper</b>	
Scraping Speed, <i>electronically variable</i> : Up to 1900 strokes/minute	Heavy roughing and work on large machines and equipment. Scraping of hardened steel guide ways. Large turbine housings, drives, pumps, valves. Extension handle included.
Length of Stroke, <i>infinitely variable</i> : 0" to 0.8" (0 to 20mm)	
Operating Voltage, Standard: 110 VAC, 60Hz (220 V available)	
Power Draw: 320 watts	
Weight: 11.5 lbs. (5.2kg)	
Dimensions: 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)	
<b>7ELM/BL-40 All-purpose, medium-weight, variable-speed electric scraper</b>	
Scraping Speed, <i>electronically variable</i> : Up to 1900 strokes/minute	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.  <b>Our all-purpose workhorse for medium to larger work.</b>
Length of Stroke, <i>infinitely variable</i> : 0" to 0.8" (0 to 20mm)	
Operating Voltage, Standard: 110 VAC, 60Hz (220 V available)	
Power Draw: 320 watts	
Weight: 9.3 lbs. (4.2kg)	
Dimensions: 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)	
<b>BL-10 All-purpose, lightweight, variable-speed electric scraper</b>	
Scraping Speed, <i>electronically variable</i> : Up to 1900 strokes/minute	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.  <b>Our all-purpose model for medium to smaller work.</b>
Length of Stroke, <i>infinitely variable</i> : 0" to 0.4" (0 to 10mm)	
Operating Voltage, Standard: 110 VAC, 60Hz (220 V available)	
Power Draw: 320 watts	
Weight: 7.0 lbs. (3.3kg)	
Dimensions: 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)	
<b>7DLM All-purpose, single-speed pneumatic scraper*</b>	
Scraping Speed, at 6 bar (90 psi): 1400 strokes/minute	<b>* AVAILABLE ON REQUEST.</b>  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.
Length of Stroke, <i>infinitely variable</i> : 0" to 0.8" (0 to 20mm)	
Power Draw: 350 watts	
Weight: 8.0 lbs. (3.6kg)	
Dimensions: 4.4" x 2.6" x 16.8" (110 x 65 x 425mm)	
Hose Connection: 3/8" pipe thread	
<b>HM-10 Half-moon pattern "flaker," variable-speed electric model</b>	
Scraping Speed, <i>electronically variable</i> : Up to 1900 strokes/minute	Scraping/flaking 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.
Length of Stroke: Fixed	
Pattern Size ( <i>depends on blade</i> ): Small, medium, large, extra large	
Operating Voltage, Standard: 110 VAC, 60Hz (220 V available)	
Power Draw: 320 watts	
Weight: 6.6 lbs. (2.8kg)	
Dimensions: 4.4" x 2.6" x 17.4" (110 x 65 x 440mm)	

# Blade Kits & Replacement Blades

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.

## Scraper Blade Kits

Catalog Number	Description
BB08000	<b>BLADE KIT, Assortment ALL-PURPOSE</b> Our most popular set includes general scraping blades, inserts and insert holders. For Models 7ELM, BL10 and 7ESM. 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.
BB08004	<b>BLADE KIT, Assortment FINISH</b> Long, flexible blades give a soft feel and are most suitable for semi-finish and finish work. This set greatly enhances all scraper models when semi-finish and finish scraping is desired. For Models 7ELM, BL10 and 7ESM. Contents: #10-150, 15-150, 20-150, 25-150, 30-150 carbide-tipped blades; 20-150ST steel scraping blades; control gauge.
BB08007	<b>BLADE KIT, Assortment DOVETAIL</b> 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. For Models 7ELM, BL10 and 7ESM. Contents: #30/25 HSS, 25/25, and #25/20 (qty 2) carbide inserts; KL170 blade extension for use on hard-to-reach areas, used with long finish blades.
BB00008	<b>BLADE KIT, Assortment #8/E (for Half-Moon Pattern Scraping)</b> 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.



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## Replacement Blades for Half-Moon Pattern Scraper Model HM10

Catalog Number	Radius	Description
<b>Half-Moon Pattern Scraper Blades (for holders)</b>		
R60	2-3/8"	Small pattern
R90	3-5/8"	Standard pattern
R120	4-3/4"	Large pattern
R150	6"	Extra-large pattern
<b>Tool Holders (for half-moon pattern scraper blades, Series R60-R150)</b>		
KL70	3"	Short holder
KL140	6"	Long holder
<b>Half-Moon Pattern Carbide Blades</b>		
R60KL	2-3/8"	Small pattern
R90KL	3-5/8"	Standard pattern
R120KL	4-3/4"	Large pattern
R150KL	6"	Extra-large pattern



# Replacement Blades, Inserts & Holders

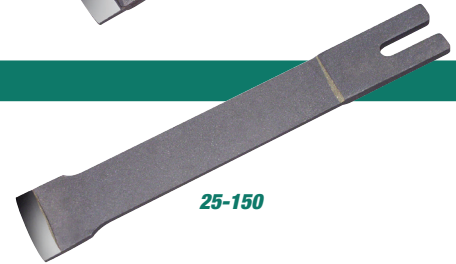
## Individual Replacement Blades

For Models 7ELM, BL10 and 7ESM. 3-1/2" and 6" blades are suitable for use with universal hand scraper Model BB20016 (see page 4).

Catalog Number	Width	Description
<b>Regular-Length (3-1/2") Scraper Blades</b>		
15	5/8"	Carbide-tipped, reversible, standard stiff type, regular length (3-1/2"), all-purpose
20	3/4"	
25	1"	
30	1-1/4"	
<b>Long-Length (6") Scraper Blades</b>		
10-150	3/8"	Carbide-tipped, reversible, special elastic type, long length (6"), for smooth semi-finishing and finishing
15-150	5/8"	
20-150	5/8"	
25-150	1"	
30-150	1-1/4"	
20-150ST	3/4"	<b>Special HSS Blade</b> for steel scraping
<b>Tight-Radius Scraper Blades for Point Scraping and Scraper Technique 40</b>		
20-R40	3/4"	Carbide-tipped, short type, 40mm radius
15-150-R20	5/8"	Carbide-tipped, long type, 20mm radius
<b>Reversible, Special 90° Twisted Stiff-Type Scraper Blades</b>		
30T	1-1/4"	Carbide-tipped, reversible, special 90° twisted stiff type, long length (6"), for dovetail work and hard-to-reach areas



15



25-150

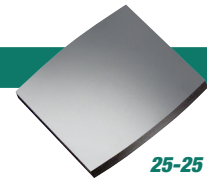


30T

## Individual Replacement Inserts & Holders

For Models 7ELM, BL10 and 7ESM or universal hand scraper Model BB20016 (see page 4).

Catalog Number	Width	Description
<b>Solid Carbide Scraper Blades</b>		
25/20	3/4"	All-purpose indexable insert type made of solid carbide. Ideal for scraping most materials. 1" length. Use with tool holders below or universal hand scraper Model BB20016.
25/25	1"	
25/30	1-1/4"	
<b>HSS Scraper Blades</b>		
30/25 HSS	1"	Indexable inserts 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 or universal hand scraper Model BB20016.
30/40 HSS	1-5/8"	
<b>Tool Holder (for Indexable Insert-Type Blades)</b>		
120M		Short (3"), stiff type
130M		Long (6")
<b>Tool Holder Extension</b>		
KL170		For scraping of dovetails and hard-to-reach areas. Use with the long special elastic scraper blade series – 150, 6-3/4" long.



25-25



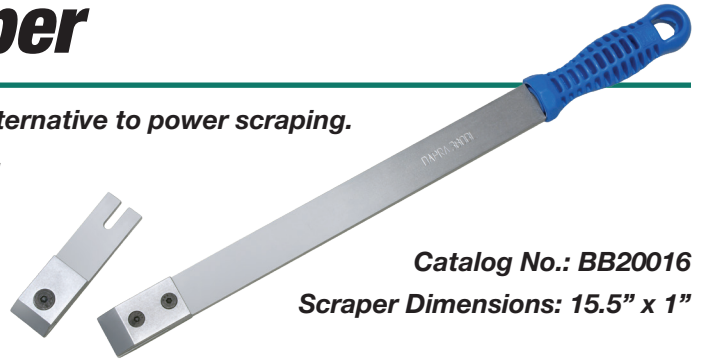
130M

# Universal Hand Scraper

Our universal hand scraper provides a cost-effective alternative to power scraping.

This scraper is for use with all BIAx scraper blades and includes an adapter for use with replacement inserts.

Use it with the compatible blades and inserts listed on page 3.



Catalog No.: BB20016  
Scraper Dimensions: 15.5" x 1"

## Scraping Accessories & Aids

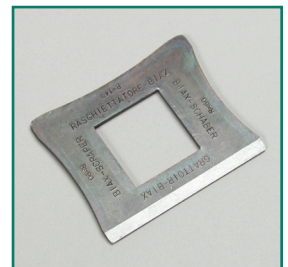
Catalog Number	Size	Description
<b>Water-Soluble Spotting Ink* – in plastic bottle dispenser</b>		
BB10000	1-1/2 oz.	Blue spotting ink
BB10007	8 oz.	
BB10005	1-1/2 oz.	Red spotting ink
BB10008	8 oz.	
BB10006	1-1/2 oz.	Yellow spotting ink
BB10009	8 oz.	

\* Other colors available, subject to minimum order requirements. Contact us for details.



Water-Soluble Spotting Ink

<b>Prussian Blue &amp; Spotting Ink Roller</b>		
BB10011-R / BB10010	0.55 oz. / 2.12 oz.	Prussian Blue (0.55 oz. tube or 2.12 oz.)
BB10019	2" dia. x 6"	Large ink roller
BB10015	1-1/2" dia. x 5"	Small ink roller
BB10016		Small ink pad



Control Gauge

<b>Control Gauge</b>		
BB20000		For checking of scraper blade radii, checking of carrying points per square inch and removal of scraping chips, dust, etc.

<b>Vertical Scraping Handle</b>		
BP82060		Vertical scraping handle

<b>Book &amp; DVD</b>		
BB50000		"Machine Tool Reconditioning," a 500+ page comprehensive, time-tested publication with many photos and illustrations.
BB50020		3-Part Scraping DVD



Prussian Blue and Spotting Ink Roller



Book



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