Jepson Power GmbH

Instruction Manual

Bevelling Machine 30°/45°

Bevelling Machine 10.6mm/45°

Bevelling Machine 0°/60°

Index

1 EG-Conformity Declaration

(According to Appendix IIA of the machine Directive)

We,

Routexport Agencies SA
Visserijstraat 25, rue de la Pêcherie
1180 Brüssel
Belgien

as the manufacturer declare herewith under our responsibility that the product:

Name: Bevelling Machine 30°/45° Bevelling Machine 10,6mm/45° Bevelling Machine 0°/60°
Serial No. :
Manufacturing Date: 2019

complies with the following standards, directives and referenced standard documents:

2006/42/EC **Machinery Directive**
2014/30/EU **EMC Directive**
2011/65/EC **RoHS Directive**
EN 60745-1:2009+A11:2010
EN 60745-2-17:2011
EN 62233:2008
EN 55014-1:2006+A1 :2009+A2 :2011
EN61000-3-2 :2014
EN61000-3-3 :2013

Pierre Michiels, Managing Director

Name, Position

Brussels, 01.01.2019

2 User Instructions

Notes for the customer

The instruction manual includes important instructions as to how to operate the plant safely, correctly and economically. Observing these instructions helps to avoid risks, repair costs and downtimes and to increase the reliability and lifetime of the machine.

The instruction manual must be read and used by each person who works with the electrical equipment. This applies in particular to the "Safety Instructions" chapter. It is too late to read the manual and safety instructions when work is actually being carried out at the machine.

Always keep one copy of this manual next to the machine so that it is at hand ready to be consulted!

In case of any doubt or questions, always contact the machine manufacturer.

In addition to the instruction manual, the accident prevention regulations which apply in the country of use and the user location must be adhered to. In addition, the recognised technical rules regarding accident prevention must be observed.

Liability and warranty

All the information contained in this instruction manual has been drawn up to the best of our knowledge and belief, taking our experience to date into consideration.

The original version of this instruction manual was drawn up in the German language and was checked by us for accuracy of content. The translation into the respective national/contractual language was carried out by a recognised translation agency.

This instruction manual has been put together with the greatest of care. However, if you should discover any incomplete items or mistakes, please inform us in writing. Your suggestions for improvement will help us to create a user-friendly manual.

Subsequent Orders and Copyright

Further copies of this instruction manual can be ordered from the address below. We ask for your understanding that further copies are subject to charge.

Jepson Elektrowerkzeuge
Ernst-Abbe-Straße 5
D-52249 Eschweiler
Phone: +49 (0)2403 – 6455-0
Fax: +49 (0)2403 – 6455-15
Mail: info@jepson.de

All rights are expressly reserved. Duplication or transfer on to third parties in any form whatsoever is not allowed without our prior written permission.

Abbreviations

V	Volt
Hz	Hertz
W	Watt
~	AC
/min	Revolutions per minute rpm
N	Newton

3 Safety Instructions

The basic prerequisite for safe handling and disturbance-free operation of this electric tool is knowledge of the basic safety instructions. In addition, the accident prevention rules and regulations which apply in the user location must be adhered to, as well as the recognised rules of the trade with regard to safety and correct working methods.

It is not permitted to use the electric tool for other purposes than those intended by the manufacturer. Such use could give rise to unforeseeable risks.

Local working and safety rules and laws must always be followed. The same applies to regulations which apply to the environment.

Safety equipment must never by remove or bridged over.

When using oils, greases and other chemical substances, the safety regulations which apply to the particular product must always be observed! Contact with chemicals should be avoided as far as possible. Before it is permissible to work with these substances the instructions for use on the packaging must be read and followed. This applies for all chemicals, therefore also for cleaning media.

All notes and signs regarding safety and possible risks must be kept in a fully legible condition.

3.1 Illustration of Safety Instructions

The following symbols are used in the instruction manual:

Warning against possible danger of injury or danger to life for persons

Warning

Warning against possible damage to property or the environment

Caution

Warning against dangerous electrical voltage

Warning against hot surfaces

Ignoring these instructions can lead to serious damage to health, up to life-threatening injuries!

This symbol indicates important information

Hazardous to the environment

3.2 General Safety Instructions

This electric tool fulfils the basic EC safety and health regulations. Nevertheless, dangerous situations can arise.

Warning

All safety equipment must be maintained in perfect condition.

Warning

Always pay attention to moving parts. These can cause injury because of their movement or by sudden movement.

Warning

Only use the electric tool when it is in perfect condition from the technical point of view, and only use it for intended purpose while being aware of safety issues and risks, and paying attention to the instruction manual! In particular, have any disturbances which could have a negative effect on safety corrected immediately!

WARNING! It is essential to read all the instructions. Mistakes which are made while attempting to follow the below instructions can cause electric shock, fire and/or serious injury. The following term "Electric tool", refers to mains-powered electric tools (with mains cable) and battery-powered electric tools (without mains cable).

Warning Caution

KEEP THESE INSTRUCTIONS IN A SAFE PLACE.

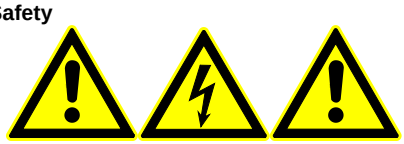
Work Area Safety

Keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.

Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquid, gases, or dust. Power tools create sparks, which may ignite the dust or fumes.

Keep bystanders, children, and visitors away while operating a power tool. Distractions can cause you to lose control.

Electrical Safety



Warning Caution

Earthed tools must be plugged into an outlet properly installed and earthed in accordance with all codes and ordinances. Never remove the earthing prong or modify the plug in any way. Do not use any adaptor plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly earthed. If the tools should electrically malfunction or break down, earthing provides a low resistance path to carry electricity away from the user.

Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.

Don't expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.

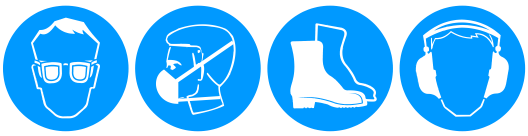
Don't abuse the cord. Never use the cord to carry the tools or pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged or entangled cords increase the risk of electric shock.

When operating a power tool outside, only use authorized cords for outdoor work. These cords are rated for outdoor use and reduce the risk of electric shock.

Personal Safety

Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

Use safety equipment. Always wear eye protection. Safety equipment such as dust mask, non-skid safety shoes, hardhat, or hearing protection used for appropriate conditions will reduce personal injuries**.**



Avoid accidental starting. Be sure switch is off before plugging in. Carrying tools with your finger on the switch or plugging in tools that have the switch on invites accidents.

Warning Caution

Remove any adjusting key or wrenches before turning the tool on. A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.

Do not overreach. Keep a proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations.

Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.

Tool use and care

Do not force tool. Use the correct tool for your application. The correct tool will do the job better and safer at the rate for which it is designed.

Do not use tool if switch does not turn it on and off. Any tool that cannot be controlled with the switch is dangerous and must be repaired.

Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool. Such preventive safety measures reduce the risk of starting the tool accidentally.

Store idle tools out of reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Tools are dangerous in the hands of untrained users.

Maintain tools with care. Keep cutting tools sharp and clean. Properly maintained tools, with sharp cutting edges are less likely to bind and are easier to control.

Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tools operation. If damaged, have the tool serviced before using. Poorly maintained tools cause many accidents.

Use the power tool, accessories and blades etc., in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.

Use clamps or other practical way to secure and support the work piece to a stable platform. Holding the work by hand or against your body is unstable and may lead to loss of control.

Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one tool may become hazardous when used on another tool.

Warning Caution

Service

Only qualified repair personnel must perform tool service. Service or maintenance performed by unqualified personnel could result in a risk of injury.

When servicing tool, use only identical replacement parts. Follow instructions in the Maintenance section of this manual. Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of electric shock or injury.

3.3 Specific Safety Rules

Never operate the tool in an area with flammable solids, liquids, or gases. Sparks from the commutator/carbon brushes could cause a fire or explosion.

WARNING! Risk of injury from high-temperature chips!

High-temperature chips are expelled at high speed. **Never touch the tool holder and keep all vulnerable body parts clear while the machine is running.**

Warning

Always guide the machine away from the body while working. Do not work holding the machine above your head.

WARNING! Some dust created by power grinding contains chemicals known to cause cancer, birth defects or other reproductive harm.

Warning

An example of these chemicals are: **lead from lead-based paint**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

WARNING! Never machine materials which contain asbestos. Use only recommended **carbide inserts, rated at the machines maximum rated cutting rate or higher.** Do not use dull or damaged carbide inserts. Dull inserts cause excessive friction and binding and excessive load on the motor, leading to possible damage.

Warning

Important: After completing the operation, Wait for coasting tool holder to stop rotating completely before putting the machine down.

Maintain labels and nameplates. These carry important information. If unreadable or missing, obtain a replacement

4 Spare Parts

For our actual spare part lists and Item numbers please visit:
www.routexport.com

5 Beveller 30° / 45° Functional Description

5.1 Specifications

Power input	1100W
Voltage	See machine nameplate
No load min^{-1}	3000~6000
Bevel angle	45 deg. (optional 30 deg.)
Max. Bevel high (45 deg.)	6mm
Min. diameter for inside bevels	20mm
Net weight	4.6 kg

5.2 Intended Use

This shape bevelling and deburring tool is an electrically driven portable machine: For machining work pieces in steel, chrome steel alloys, aluminium, aluminium alloys, brass and plastic. The machine is designed exclusively for adding bevelled edges, rounding off edges, removing burrs, and removing sharp corners on work pieces. The speed of the machine is variable to suit the needs of various materials and is equipped with a graduated, depth adjustable support deck. It comes with a standard 45°and 30° tool holder for use with triangle indexable carbide cutter inserts to achieve quick and easy bevelling. Total Extension Cord Length (feet) Cord Size (AWG)

WARNING: The machine must not be converted or modified, e.g. for any other form of use, other than as specified in these operating instructions. The user shall be liable for damages and accidents due to incorrect use.

Warning

5.3 Unpacking

Carefully remove the tool and all loose items from the shipping container. Retain all packing materials until after you have inspected and satisfactorily operated the machine.

1. Deburring and Champfering machine
2. L-Type torx wrench
3. Open-End wrench
4. Hook spanner wrench

Do not operate this too until you read and understand the entire instruction manual.

5.4 Setting the Bevel Height

1 Dial scale
2 Lock Nobs
3 Support deck

DISCONNECT TOOL FROM POWER SOURCE.

- Loosen the 2 lock knobs
- Referring to the fixed dial scale and the dial ring on the support deck, turn the entire support deck assembly to set the bevel height as desired.

  Retighten the 2 lock knobs

5.5 Zeroing the Bevel Height

DISCONNECT TOOL FROM POWER SOURCE.

Note: The machine's bevel height is set at zero from the factory. If the setting is disturbed, it must be zeroed in. Follow the instructions below for zeroing-in.

1 Carbide Insert
2 Impeller

1. Loosen the 2 lock knobs then loosen the support deck assembly so that the inserts are below flush level.
2. Use a steel ruler or other accurate device with a right angle. While keeping the ruler square with the impeller and the support deck, slowly adjust the support deck until the ruler just touches the carbide insert. This is the zero point.
3. Once the zero point is found, loosen the small set screw and turn the dial ring to indicate zero on the scale. Then retighten the set screw.

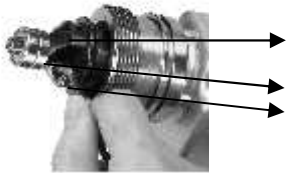
5.6 Changing the Indexable Carbide Inserts

DISCONNECT TOOL FROM POWER SOURCE.

WARNING: Danger of Burns! Tool holder and carbide inserts become hot in operation. Wear gloves and take precautions to prevent burns when working with this part of the machine.

Warning

Note: Triangle indexable carbide inserts have 3 edges. When one edge is dull simply rotate to the next sharp edge. Once all 3 edges are dull, replace with new inserts.



1. Tool holder
2. Carbide insert
3. L-typo torx wrench

1. Using the supplied L-type torx wrench, Loosen fixing screw and remove the carbide insert.
2. Index the carbide insert to the next sharp edge or insert a new one as needed.
3. Retighten carbide insert with its torx fixing screw.

5.7 Removing the Tool Holder

DISCONNECT TOOL FROM POWER SOURCE.

WARNING: Danger of Burns! Tool holder and carbide inserts become hot in operation. Wear gloves and take precautions to prevent burns when working with this part of the machine.

Warning

If it is necessary to change from the standard 45 deg. Tool holder to an optional 30 deg. Tool holder, the entire tool holder must be changed.

Loosen the 2 lock knobs and fully unscrew and remove the support deck assembly.

Using the supplied hook spanner wrench, engage one of the holes in the tool holder and loosen the tool holder from the spindle.

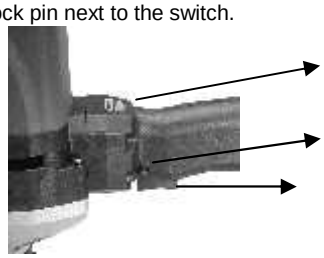
Assembly is the reverse of disassembly Replace and adjust the support deck assembly.

5.8 Starting and Stopping the Tool

Make sure that the power circuit voltage is the same as that shown on the specification plate of the machine and that switch is OFF before connecting the tool to the power circuit.

To switch on:

Press the trigger switch to start. To lock the switch on, press the lock pin next to the switch.



1. Speed control wheel
2. Lock pin
3. Trigger switch

Speed control wheel:

There is a progressive variable speed wheel. By turning the wheel to the left, the speed will gradually increase.

To switch off:

Squeeze and release the trigger switch to unlock the switch and switch off. After the machine has been switched off, the arbour will still rotate for a time. Take care that parts of your body do not come into contact with the rotating parts or set the machine down while it is still rotating!

5.9 Tool Usage

- Effective control of this powerful tool requires two-handed operation at all times for maximum control and safety.
- Do not use this tool continuously over 30 minutes.
- Protect your eyes from injury with safety glasses or goggles.

Operation

The machine must reach full speed before bevelling/deburring begins.

- Hold the machine keeping the support deck flat and securely to the work piece. From the operators perspective, the spindle is spinning clockwise, so and always operate in the direction from left to right (up mill).
- When performing inside bevels, work in a clockwise direction only.
- Do not bevel more than about 2 mm per pass. If more depth is needed, make multiple passes until the desired bevel height is reached.

Note: It will extend the life of the inserts to add cutting oil.

6 Maintenance and Repair

6.1 Keep Tool Clean

Periodically blow out all air passages with dry compressed air. All plastic parts should be cleaned with a soft damp cloth. NEVER use solvents to clean plastic parts. They could possibly dissolve or otherwise damage the material. Wear safety glasses while using compressed air.

6.2 Lubrication

Every 100 hours of operation, have the gearbox grease replaced by a qualified service technician.

6.3 Replace the Impeller when Worn

When the impeller becomes worn the work piece surfaces will be machined unevenly. Replace when worn as follows:

Using the supplied hook spanner wrench, engage one of the holes in the tool holder to immobilize it.

Using an appropriate sized wrench loosen the nut securing the impeller and remove.

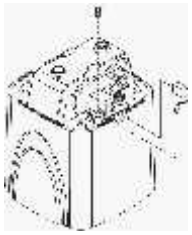
Replacement is the reverse of removal.

6.4 Replacing Carbon Brushes

The carbon brushes are a normal wearing part and must be replaced when they reach their wear limit.
CAUTION: Always replace the brushes as a pair.

To replace:

Remove the four screws and remove tail cover



Using pliers rotate the brush spring out of the way and slide old carbon brush out of the brush holder.

Unscrew the screw to remove the brush lead. The old carbon brush may now be lifted away.

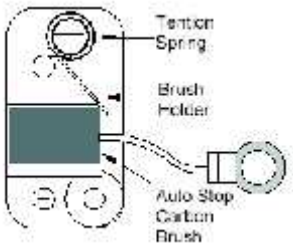
Install a new brush. Installation is the reverse of removal.

Replace the motor tail cover.

6.5 Auto Stop Carbon Brush

The Auto Stop feature stops the machine before the carbon brushes are finished and protects the motor. Therefore if the machine comes to a stop without any apparent reason the brushes need to be checked/replaced.

NOTE: To reinstall the same brushes, first make sure the brushes go back in the way they came out. Otherwise a break-in period will occur that will reduce motor performance and increase commutator and brush wear. It is recommended that, at least once a year, you take the tool to an Authorized Service Centre for a thorough cleaning and lubrication.



7 Standard Accessories

- L-type torx wrench
- Open-end wrench
- Hook spanner wrench

If the replacement of the power supply cord is necessary, this has to be done by the manufacturer or their agent in order to avoid a safety hazard.

8 Electric Beveller 10,6mm / 45° Functional Description

8.1 Specifications

Power input	1800W
Voltage	See machine nameplate
No load min^{-1}	2300~6500
Bevel angle	45 deg
Max. chamfer high	45 deg.: 10.6mm
Min. diameter for inside bevels	30mm
Net weight	6.5 kg

8.2 Intended Use

This shape bevelling and deburring tool is an electrically driven portable machine: For machining work pieces in steel, chrome steel alloys, aluminium, aluminium alloys, brass and plastic. The machine is designed exclusively for adding bevelled edges, rounding off edges, removing burrs, and removing sharp corners on work pieces. The speed of the machine is variable to suit the needs of various materials and is equipped with a graduated, depth adjustable support deck. It comes with a standard 45° tool holder for use with four-sided indexable carbide cutter inserts to achieve quick and easy bevelling. Total Extension Cord Length (feet) Cord Size (AWG)

WARNING: The machine must not be converted or modified, e.g. for any other form of use, other than as specified in these operating instructions. The user shall be liable for damages and accidents due to incorrect use.

Warning

8.3 Unpacking

Carefully remove the tool and all loose items from the shipping container. Retain all packing materials until after you have inspected and satisfactorily operated the machine.

Deburring and Chamfering machine

L-Type torx wrench

Open-End wrench

Hook spanner wrench

Do not operate this too until you read and understand the entire instruction manual.

8.4 Setting the Bevel Height

1 Dial scale

2 Lock Nobs

3 Support deck

DISCONNECT TOOL FROM POWER SOURCE.

- Loosen the 2 lock knobs
- Referring to the fixed dial scale and the dial ring on the support deck, turn the entire support deck assembly to set the bevel height as desired.

  Retighten the 2 lock knobs

8.5 Zeroing the Bevel Height

DISCONNECT TOOL FROM POWER SOURCE.

Note: The machine's bevel height is set at zero from the factory. If the setting is disturbed, it must be zeroed in. Follow the instructions below for zeroing-in.

1 Carbide Insert

2 Impeller

1. Loosen the 2 lock knobs then loosen the support deck assembly so that the inserts are below flush level.
2. Use a steel ruler or other accurate device with a right angle. While keeping the ruler square with the impeller and the support deck, slowly adjust the support deck until the ruler just touches the carbide insert. This is the zero point.
3. Once the zero point is found, loosen the small set screw and turn the dial ring to indicate zero on the scale. Then retighten the set screw.

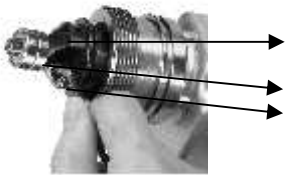
8.6 Changing the indexable Carbide Inserts

DISCONNECT TOOL FROM POWER SOURCE.

WARNING: Danger of Burns! Tool holder and carbide inserts become hot in operation. Wear gloves and take precautions to prevent burns when working with this part of the machine.

Warning

Note: Triangle indexable carbide inserts have 4 edges. When one edge is dull simply rotate to the next sharp edge. Once all 4 edges are dull, replace with new inserts.



4. Tool holder
5. Carbide insert
6. L-typo torx wrench

1. Using the supplied L-type torx wrench, Loosen fixing screw and remove the carbide insert.
2. Index the carbide insert to the next sharp edge or insert a new one as needed.
3. Retighten carbide insert with its torx fixing screw.

8.7 Removing the Tool Holder

DISCONNECT TOOL FROM POWER SOURCE.

WARNING: Danger of Burns! Tool holder and carbide inserts become hot in operation. Wear gloves and take precautions to prevent burns when working with this part of the machine.

Warning

If it is necessary to change Tool holder.

Loosen the 2 lock knobs and fully unscrew and remove the support deck assembly.

Using the supplied hook spanner wrench, engage one of the holes in the tool holder and loosen the tool holder from the spindle.

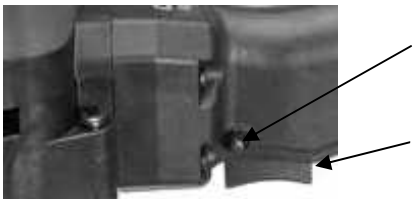
Assembly is the reverse of disassembly Replace and adjust the support deck assembly.

8.8 Starting and Stopping the Tool

Make sure that the power circuit voltage is the same as that shown on the specification plate of the machine and that switch is OFF before connecting the tool to the power circuit.

To switch on:

Press the trigger switch to start. To lock the switch on, press the lock pin next to the switch.



Speed control wheel:

There is a progressive variable speed wheel. By turning the wheel to the left, the speed will gradually increase.

To switch off:

Squeeze and release the trigger switch to unlock the switch and switch off. After the machine has been switched off, the arbour will still rotate for a time. Take care that parts of your body do not come into contact with the rotating parts or set the machine down while it is still rotating!

8.9 Tool Usage

- Effective control of this powerful tool requires two-handed operation at all times for maximum control and safety.
- Do not use this tool continuously over 30 minutes.
- Protect your eyes from injury with safety glasses or goggles.

Operation

The machine must reach full speed before bevelling/deburring begins.

- Hold the machine keeping the support deck flat and securely to the work piece. From the operators perspective, the spindle is spinning clockwise, so and always operate in the direction from left to right (up mill).
- When performing inside bevels, work in a clockwise direction only.
- Do not bevel more than about 2 mm per pass. If more depth is needed, make multiple passes until the desired bevel height is reached.

Note: It will extend the life of the inserts to add cutting oil.

9 Maintenance and Repair

9.1 Keep Tool Clean

Periodically blow out all air passages with dry compressed air. All plastic parts should be cleaned with a soft damp cloth. NEVER use solvents to clean plastic parts. They could possibly dissolve or otherwise damage the material. Wear safety glasses while using compressed air.

9.2 Lubrication

Every 100 hours of operation, have the gearbox grease replaced by a qualified service technician.

9.3 Replace the Impeller when Worn

When the impeller becomes worn the work piece surfaces will be machined unevenly. Replace when worn as follows:

Using the supplied hook spanner wrench, engage one of the holes in the tool holder to immobilize it.

Using an appropriate sized wrench loosen the nut securing the impeller and remove.

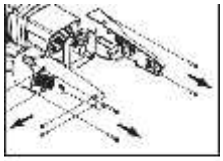
Replacement is the reverse of removal.

9.4 Replacing Carbon Brushes

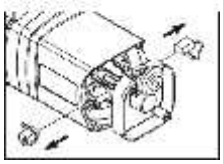
The carbon brushes are a normal wearing part and must be replaced when they reach their wear limit.
CAUTION: Always replace the brushes as a pair.

To replace:

First unplug the machine. Carefully remove the 4 screws to separate the rear handle halves and then remove the 4 screws which connect the handle to the motor housing. Lift away the left-hand handle half first. There will still be wires connected to the rear handle, so take care that these are not stressed. Simply hold the rear handle off to one side.



Using pliers, rotate the brush spring out of the way and slide old carbon brush out of the brush holder. Unplug the spade connector to remove the brush lead. The old carbon brush may now be lifted away.

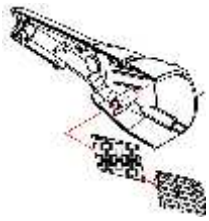


Replacing is the reverse of removal. When replacing the rear handle to the motor housing, take great care that all wires are in place and not in a position to be pinched when it is retightened.
NOTE: To reinstall the same brushes, first make sure the brushes go back in the way they came out. Otherwise a break-in period will occur that will reduce motor performance and increase commutator and brush wear. It is recommended that, at least once a year, you take the tool to an Authorized Service Centre for a thorough cleaning and lubrication.

9.5 Filter mats

The filter mats must be cleaned regularly or exchanged when it is no longer possible.
To remove the filter mats open the handle as shown in point 11.1 in the first paragraph. Take out the holding grille and the filter mats in both handle halves

.
Install in reverse order.



10 Standard Accessories

- L-type torx wrench
- Open-end wrench
- Hook spanner wrench

If the replacement of the power supply cord is necessary, this has to be done by the manufacturer or their agent in order to avoid a safety hazard.

11 Electric Beveller 0° / 60° Functional Description

11.1 Specifications

Power input	1100W AC Inductor Motor	
Voltage	See machine nameplate	
No load min^{-1}	60Hz 3600, 50Hz 3000	
	Angle	Chamfer height
	60 deg.	6.5mm
	45 deg.	11.5mm
	37,5 deg.	9,5mm
	30 deg.	7mm
	15 deg.	3mm
	0 deg.	0mm
Net weight	4.6 kg	
Radius:	150mm – 350mm Optional 300mm – 600mm	

11.2 Intended Use

The Electric Beveller comes with an AC induction motor which offers longer durability and lower noise, as well as its high torque.

The milling angle is adjustable progressively from 0° to 60° with a maximum land width of 23mm. The zero degree setting is perfect for facing off.

The two-in-one base plate allows both standard bevelling and pipe bevelling form 150mm up to 350mm. It is a very quick conversion: all that is needed is to reposition the rollers. (There is also an optional base plate for bevelling larger diameter pipes from 300mm up to 600mm). It's very handy, compact and robust design allows for easy handling and convenient operation.

WARNING: The machine must not be converted or modified, e.g. for any other form of use, other than as specified in these operating instructions. The user shall be liable for damages and accidents due to incorrect use.

Warning

11.3 Unpacking

Carefully remove the tool and all loose items from the shipping container. Retain all packing materials until after you have inspected and satisfactorily operated the machine.

Deburring and Chamfering machine

L-Type torx wrench

Open-End wrench

Hook spanner wrench

Do not operate this too until you read and understand the entire instruction manual.

11.4 Setting the Bevel Height

DISCONNECT TOOL FROM POWER SOURCE.

Loosen the depth lock screw of both sides with supplied M8 Hex. Wrench.

Turn the depth adjustor knob clockwise or counter-clockwise to adjust the desired chamfering height. Please refer to the reading on the side of the machine, maximum chamfering depth up to 12mm.

After make sure the chamfering blades are set to the desired height, tighten the depth lock screws.

11.5 Changing the Indexable Carbide Inserts and or removing the tool holder.

DISCONNECT TOOL FROM POWER SOURCE.

WARNING: Danger of Burns! Tool holder and carbide inserts become hot in operation. Wear gloves and take precautions to prevent burns when working with this part of the machine.

Warning

Note: Indexable carbide inserts have 4 edges. When one edge is dull simply rotate to the next sharp edge. Once all 4 edges are dull, replace with new inserts.

Loosen the 2 depth adjustment screws and fully unscrew and remove the support deck assembly.

Using the supplied M32 combination wrench to secure the spindle.

Using the supplied 27mm x 24mm wrench to unscrew the nut in front of the tool holder and loosen the tool holder from spindle.

Rotate, remove or replace the tool holders as needed.

Using the supplied M3 Hex wrench, loosen fixing screw and remove the carbide inserts.

Rearrange the carbide insert to the other sharp edge or insert a new one as needed.

Fasten carbide inserts.

Assembly is the reverse of the disassembly.

11.6 Starting and Stopping the Tool

Make sure that the power circuit voltage is the same as that shown on the specification plate of the machine and that switch is OFF before connecting the tool to the power circuit.

To switch on:

Press green motor button to start the motor. Use the handle to feed the machine to the desired working angle to work. Always use very light pressure when beginning the cutting.

To switch off:

To switch off the beveller, press the red motor off button.

11.7 Tool Usage

- Effective control of this powerful tool requires two-handed operation at all times for maximum control and safety.
- Do not use this tool continuously over 30 minutes.
- Protect your eyes from injury with safety glasses or goggles.

Operation

The machine must reach full speed before bevelling/deburring begins.

- Hold the machine keeping the support deck flat and securely to the work piece. From the operators perspective, the spindle is spinning clockwise, so and always operate in the direction from left to right (up mill).
- When performing inside bevels, work in a clockwise direction only.
- Do not bevel more than about 2 mm per pass. If more depth is needed, make multiple passes until the desired bevel height is reached.

Note: It will extend the life of the inserts to add cutting oil.

12 Maintenance and Repair

12.1 Keep Tool Clean

Periodically blow out all air passages with dry compressed air. All plastic parts should be cleaned with a soft damp cloth. NEVER use solvents to clean plastic parts. They could possibly dissolve or otherwise damage the material. Wear safety glasses while using compressed air.

12.2 Lubrication

Every 100 hours of operation, have the gearbox grease replaced by a qualified service technician.

12.3 Replace the Impeller when Worn

When the impeller becomes worn the work piece surfaces will be machined unevenly. Replace when worn as follows:

Using the supplied hook spanner wrench, engage one of the holes in the tool holder to immobilize it.

Using an appropriate sized wrench loosen the nut securing the impeller and remove.

Replacement is the reverse of removal.

13 Standard Accessories

- L-type torx wrench
- Open-end wrench

If the replacement of the power supply cord is necessary, this has to be done by the manufacturer or their agent in order to avoid a safety hazard.

14 Waranty

The warranty time (warranty according to the commercial code) is 12 months from the day of sale to the end consumer.
It covers and is limited to the free replacement of the defective parts or the free repair of defects that are demonstrably due to the use of imperfect materials during production or due to assembly errors. Incorrect use or start-up and unauthorised installations or repairs not specified in the operating instructions void the warranty. Parts that are subject to wear are also exclu- ded from the warranty. We expressly reserve the right to make decisions on the war- ranty application. The warranty is void if the device is opened by a third party. Transport damages, maintenance work as well as damage and malfunctions due to insufficient maintenance are not covered by the warranty.
For warranty claims, the proof of purchase of the device must be given by presenting the delivery note, bill, or cash receipt.
As far as it is legal, we assume no liability for any personal, material or consequen- tial damages, in particular if the device is used differently than for the purpose indi- cated in the operating instructions, not installed or repaired according to the opera- ting instructions, or repairs were executed by a layperson.
We reserve the right to perform repairs or maintenance over and above the ones spe- cified in these operating instructions at the factory.

The warranty excludes wear parts such as:
Switches, flanges, carbon brushes, supportings and
Cutting tools (saw blades, carbide inserts, drills and abrasive).

15 Quotation

When returning a defective machine for repair with cost estimate. We charge a handling fee of 50€, but does not apply if a repair order or purchase of a new machine is given.

16 Spare parts

For current spare parts list with order numbers please visit our website:
www.drycutter.com