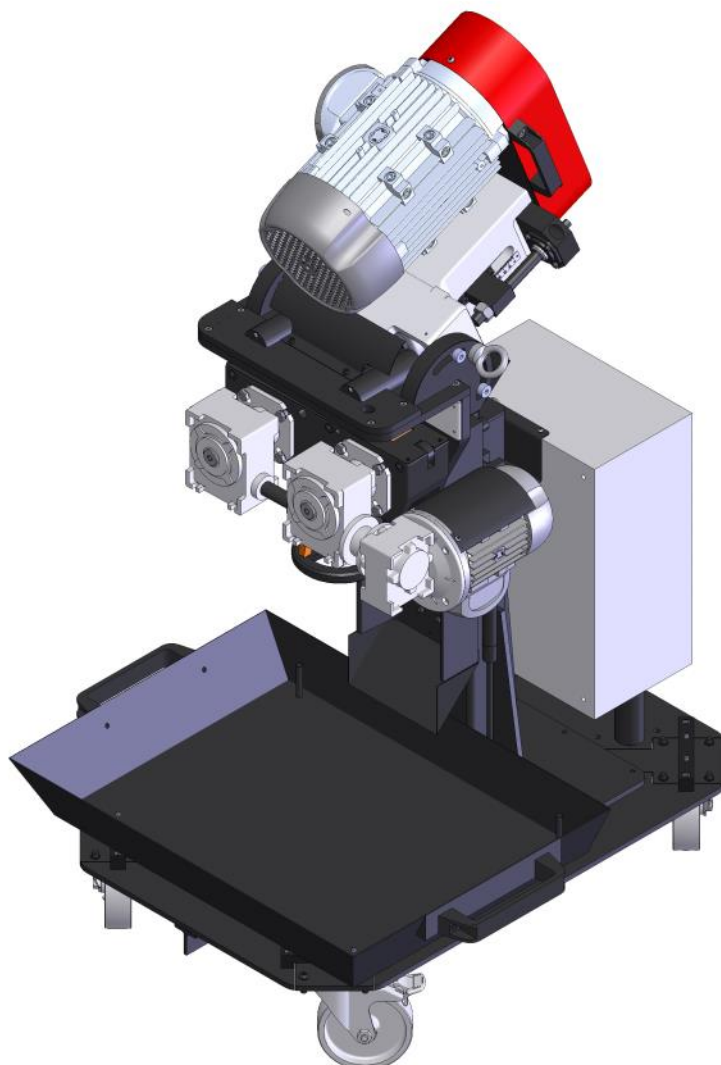




# INSTRUCTION MANUAL



## COMPACT EDGE

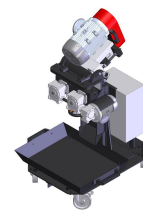
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini, 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph 1.7.4 of the Machine Directive  
2006/42/CE



## INDEX

Presentation of the company and introduction to the Instruction Manual	3
Warranty General Clauses	4
Intended Use Of The Machine	5
Technical Data	6
Machine Standard Equipment	7
Optional Equipment	8
Safety Prescriptions	9
Machine Stability	11
Emergency Stop	11
Machine Setup	12
Control Panel	19
Inserts Replacement	22
Warnings and troubleshooting	26
Installation and use of the Face Mill Speed Regulaor	27
Ordinary Maintenance	32

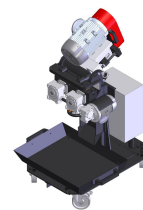
## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **PRESENTATION OF THE COMPANY AND INTRODUCTION TO THE INSTRUCTION MANUAL**

G.B.C. Industrial Tools S.p.A. is known worldwide for the quality of its machines and accessories for pipe cutting and beveling procedures of any sort and plate beveling machines..

The Headquarters are located in Cazzago San Martino (BS) where are currently operating the General Management, the sales de-partment, as well as the main workshop and the shipping de-partment.

QUALITY STANDARD—All our machines are assembled according to the highest quality standard. Since 1996 G.B.C. Industrial Tool S.p.a. has implemented management procedures in compliance with the quality system regulations UNI EN ISO 9001 (SGS ITALIA S.R.L. N° IT 96.088 / 1996).

This **Manual** is supplied together with the machine it makes reference to. The customer may apply for further copies to **G.B.C. Industrial Tools S.p.a.** Our company owns the copyright of this document and any partial or complete copy or distribution to natural persons or to corporate bodies is strictly forbidden unless our prior approval to do so is obtained.

**G.B.C. Industrial Tools S.p.a.** informs its customers that any operation carried out on the machines which is not prescribed in this manual entails the automatic invalidation of the warranty.

**G.B.C. Industrial Tools S.p.a.** recommends to contact the Maintenance Service in Cazzago San Martino – Italy prior to proceed with any modification on the machine.

**You are invited to scrupulously adhere to the information written on the identification tag.**

For any further information you are invited to contact us :at these numbers:

**Via Telephone (+39 - 030 -7451154)  
Via Email ( [www.gbcspa.com](http://www.gbcspa.com) )**

**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **WARRANTY GENERAL CLAUSES**

**G.B.C. Industrial Tools S.p.a.** guarantees the reliability of the machine and its con-formity to the specifications herewith reported. The warranty covers the machine in its whole for a time period of one year from the shipment date (ref. Delivery Note) for any flaw not imput-able to the user.

The parts subject to wear are excluded from the warranty at sole **discretion** of **G.B.C. Industrial Tools S.p.a.**

In case of any operational malfunction arising during the warranty period, **G.B.C. Industrial Tools S.p.a.**

And its Maintenance Service, hereinafter called **MSS**, will remedy this inconvenient free of charge , both for handwork and for eventual replaced parts, except when the malfunction is di-rectly or indirectly imputable to misuse or alteration. In any case the machine must not be disassembled or altered before the shipment. The warranty is valid only when the warranty document is duly signed by **G.B.C. Industrial Tools S.p.a.** and by a **G.B.C.** official distributor connected with the **MSS** maintenance service.

The shipment of the defective material must be performed within 8 (eight) days from the notification of the defect and/or the claim and/or the request of technical assistance. On the contrary the warranty will be void. **G.B.C. Industrial Tools S.p.A.** and **MSS** obligations will cover the defect resolution, the general maintenance and the inspection of the parts subject of the claim only. The component replacement is at **G.B.C. Industrial Tools S.p.A.** discretion only. The shipmen to costs from and to the **MSS** as well as the direct and indirect costs rising from repair of the product are at user's charge. Any warranty repair or extraordinary repair must be executed by **G.B.C. Industrial Tools S.p.A.** and **MSS**, otherwise the warranty will be void.

Any ordinary maintenance performed by the customer/user or by any service centre non recognized or approved by **G.B.C. Industrial Tools S.p.A.** will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials, power supply, negligence, unauthorized modifications, atmos-pheric events, acts of vandalism, incautious handling and/or transport, use of non original **G.B.C. Industrial Tools S.p.A.** parts and damage for causes not specified by **G.B.C. Industrial Tools S.p.A.** and for which **G.B.C. Industrial Tools S.p.A.** declines any responsibility. **G.B.C. Industrial Tools S.p.A.** reserves the right to modify and to improve its products without any obligation to modify equipment and components already supplied. Nobody is authorized to modify the conditions herewith contained or to issue any on behalf of **G.B.C. Industrial Tools S.p.A.** The claim terms for defects and/or damages in the material or of the ordered quantities, are those pre-scribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

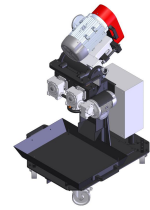
## **G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# G.B.C.® EDGE COMPACT

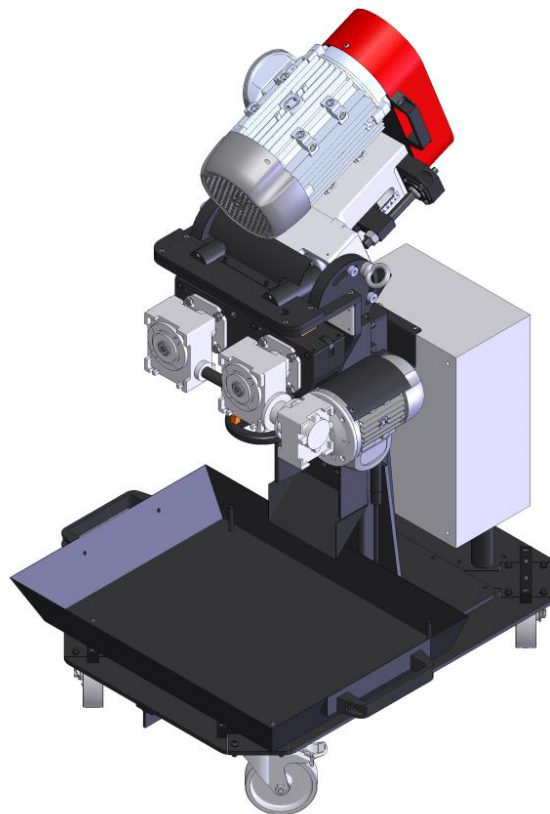
Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **INTENDED USE OF THE MACHINE**

GBC's plate bevellers, can perform a welding prep bevel on 90° edges. There are several models available depending by the wall thickness of the plate, usable for on-site jobs and for workshop daily production purposes.

All the machines are equipped with an automatic feeding system, therefore once they are positioned and locked on the plate edge (models for beveling the upside and models for beveling the down side of the plate), the beveling is performed automatically, with no need of any intervention by any operator. These machines can be equipped with a comfortable trolley designed ad-hoc, adjustable in height and particularly suggested when working large plate sheets so that no overhead cranes or other lifting devices are involved in the process.



THE MACHINE SHOULD BE OPERATED ONLY BY SPECIALIZED OPERATORS WHO HAVE BEEN DULY TRAINED ON THE UNIT.

FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTALBE MISUSE OF THE UNIT

**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



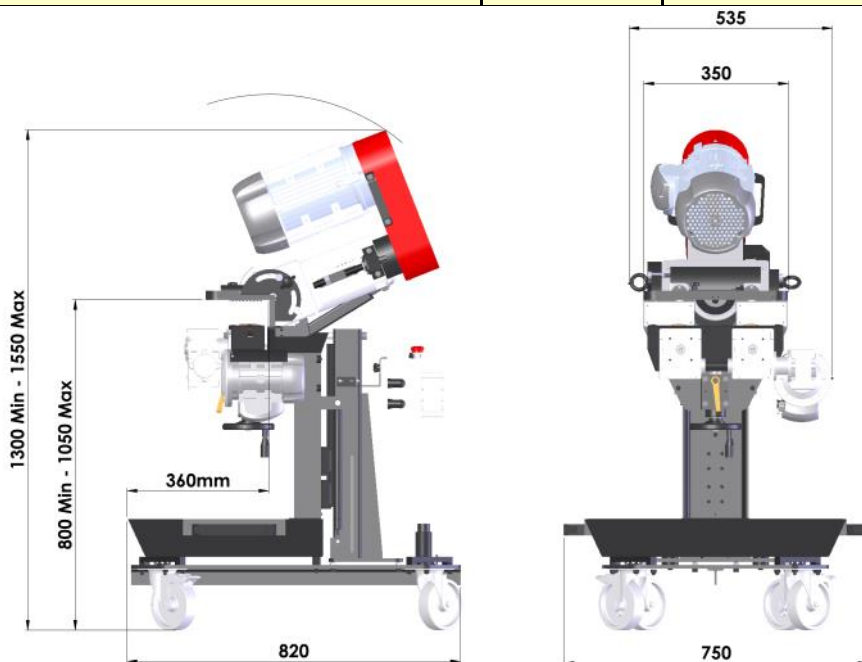
# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive 2006/42/CE



## ***TECHNICAL DATA***

		<b>ELECTRIC</b>
<b>Electric motor Power</b>	W	4000
<b>Tension</b>	Volt	230 / 400
<b>Frequency</b>	Hz	50 / 60
<b>Face Mill Speed</b>	RPM	800 (Opt. from 300 to 800)
<b>Face Mill Type</b>		Ø80mm - 9 inserts
<b>Bevel Angle</b>		Da 15° a 60°
<b>Plate Wall Thickness</b>	mm	Min. 6 - Max 60
<b>Bevel Length (Diagonal)</b>	mm	Min. 0 - Max 40
<b>Feeding Speed</b>	Mt/min	0 ÷ 1.6
<b>Machine Total Weight</b>	Kg	205
<b>Machine Weight Without Trolley</b>	Kg	138
<b>Trolley Weight</b>	Kg	67
<b>Maximum Acoustic Emission (Idle)</b>	dB	76
<b>Average Acoustic Emission In Operation</b>	dB	86



## **G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE

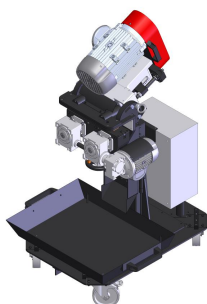


## **MACHINE STANDARD EQUIPMENT**

The machine is supplied with:

- 8mm “T” shape Allen Key
- 8mm Allen Key
- 6mm Allen Key
- 3/8” Male Socket
- 8mm Hexagonal Socket
- 9 Insert Face Mill
- Wooden Case
- Instruction Manual and Drawings
- Disegni esplosi della macchina nei quali vengono evidenziati i particolari costituenti

### **Compact EDGE**



### **Service Tools**



### **Face Mill**



### **Wooden Case**



### **Instruction Manual**



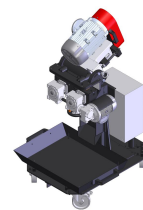
## **G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

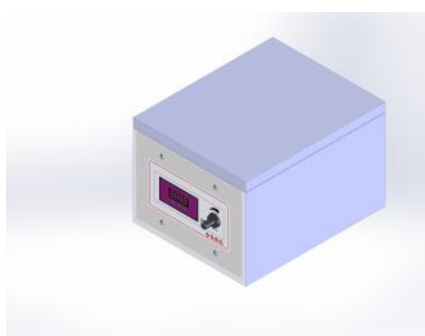


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **OPTIONAL EQUIPMENT**



### **Face Mill Speed Regulator**

**G.B.C. Industrial Tools S.p.A.**

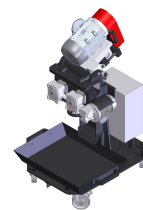
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



**G.B.C.**<sup>®</sup>

# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **SAFETY PRESCRIPTIONS**

G.B.C. Industrial Tools S.p.A. designs and assembles its machines in strict compliance with the safety regulations provided by the applicable EC directives and by the Italian laws regulating this matter.

G.B.C. Industrial Tools S.p.A. declines any responsibility for misuse of its machines and their use when in contrast with the regulation listed hereinafter and with the use and maintenance instructions hereto.

- Carefully read ALL the following regulations and the instructions herewith attached before starting any operation.
- Carefully ensure that the operator and the foreman using the machine are fully aware of all the regulations and all the instructions and that they are qualified to operate the unit.
- Strictly attain to the indications given by the international symbols applies on the machine and/or on its case.
- Do not perform any maintenance operation when the machine is plugged to the power supply.
- Before every use, ensure the power supply connections to be conform to the specs given by our manual.

The authorized operator in any case will not have to disregard the basic safety rules such as:

- Using gloves and goggles (safety gear supplied by the company responsible for the site or for the building)
- To properly illuminate the working area
- Ensure you are operating in an area which grants free movements (at least 1,5 metres around the operator)
- Do not replace the control system and do not replace parts with non original spare parts, and do not project violent water squirts on the machine
- Keep the hands away from hot and sharpened parts.

G.B.C. Industrial Tools S.p.A. remarks that for any non specified circumstances it is necessary to obtain the authorization of the manufacturer.

**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph 1.1.7.4 of the Machine Directive  
2006/42/CE



Using properly the safety gear entails the only risks to be generated by the user's system and not by inborn defects of our machines.

The acoustic emissions are within the limits provided by Machine Directive in force. Proof of this is recorder and stored by the production department which files all the acoustic tests performer on every single unit.

1. Always wear gloves and goggles during every operation
2. Any adjustment or inspection of the machine shall be done with the unit unplugged from the power source.
3. During the operations the hands of the operator must be kept on the handles located on the sides of the motor.
4. The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.



### Details For Transport

Weight of the Machine	kg	<b>214</b>	
Shipping Dimensions	mm	-	
Shipping Weight	kg	<b>306</b>	

## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph 1.7.4 of the Machine Directive  
2006/42/CE



## **MACHINE STABILITY**

Considering the mass of the machine no particular problem has been detected in regard to the operator safety.

## **EMERGENCY STOP INSTALLATION**

The machine is equipped with an emergency stop button — See the paragraph regarding the control panel.

**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

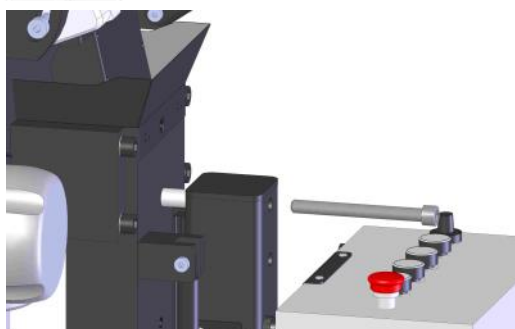
Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## **MACHINE SETUP**



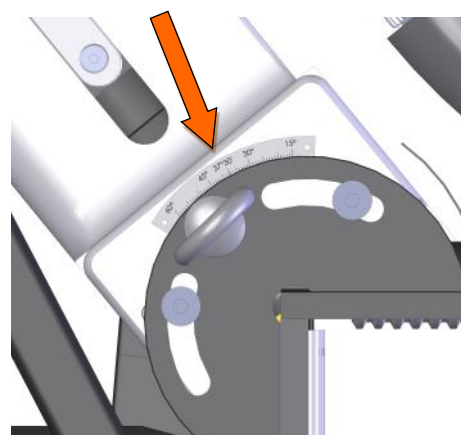
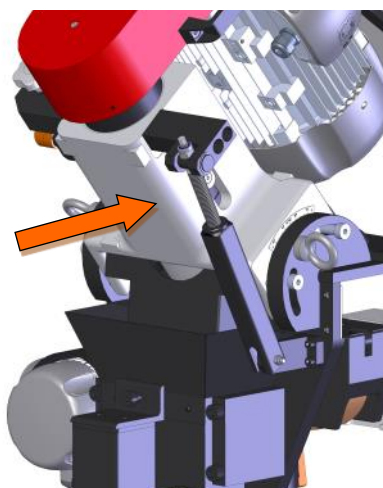
Before starting any setup operation make sure the unit is duly clean and that it is not connected to the main power supply. Ensure there is room enough around the area of operation.



**N.B.:** Remove the Transport Locking Screw to release the machine head from the base.



For bevel angle set up, loose the two screws on the main body (see picture above) .  
**N.B. : The main body central area shall always be duly cleaned and lubricated.**



With the tool supplied regulate the bevel angle making reference to the graduated scale.

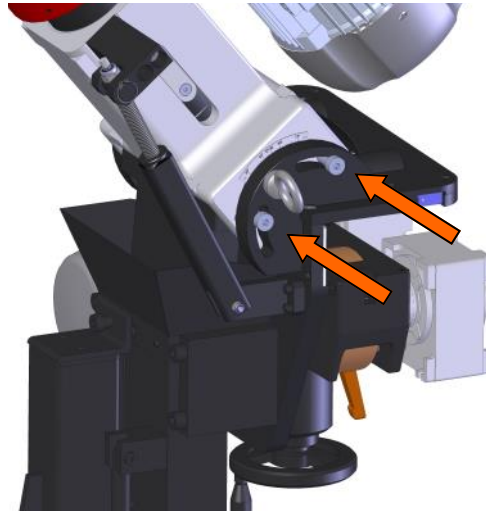
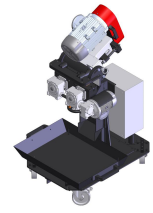
## **G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

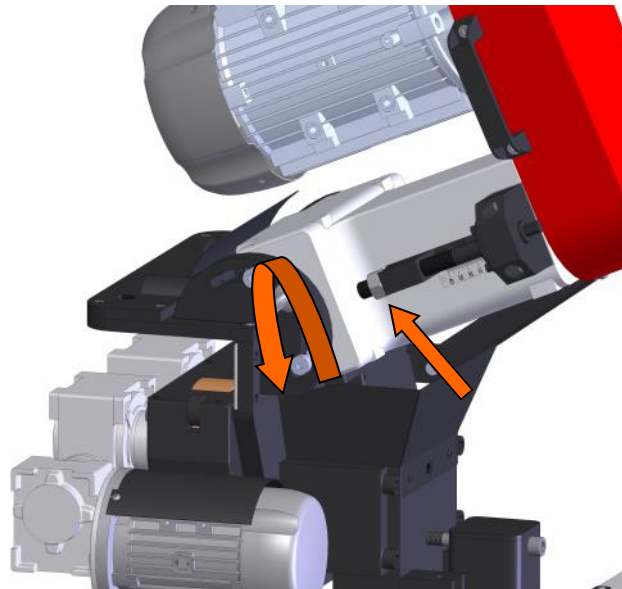


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



Now tight the two screws on the main body to secure the selected angle.



The bevel depth, thus the bevel length, can be adjusted by loosening the main shaft locking nut.

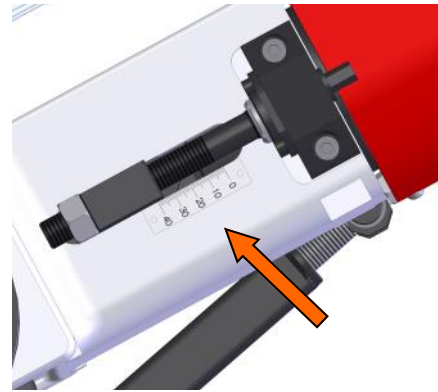
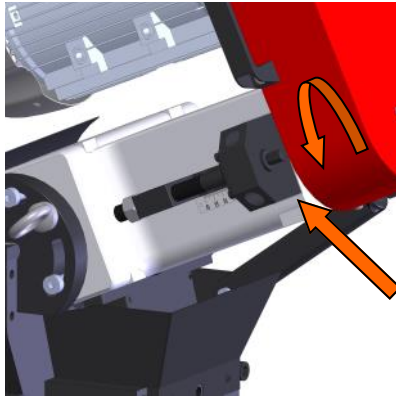
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive 2006/42/CE



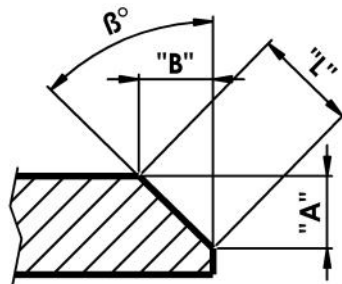
The pass depth can be adjusted by turning the depth screw until you reach the actual depth the required which value can check the gauge.

15° Angle				
Steps	Maximum Cutting Position	A	B	L
1	5	19.32	5.18	20
2	3	30.91	8.28	32
3	2	38.64	10.35	40

37.5° Angle				
Steps	Maximum Cutting Position	A	B	L
1	5	8.21	6.30	10.35
2	3	13.14	10.08	16.56
3	3	18.07	13.87	22.78
4	3	23	17.65	28.99
5	3	27.93	21.43	35.20
6	2.5	32.03	24.58	40.38

30° Angle				
Steps	Maximum Cutting Position	A	B	L
1	5	10	5.77	11.55
2	3	16	9.24	18.48
3	3	22	12.7	25.4
4	3	28	16.17	32.33
5	3.5	35	20.21	40.41

45° Angle				
Steps	Maximum Cutting Position	A	B	L
1	5	7.07	7.07	10
2	3	11.31	11.31	16
3	3	15.56	15.56	22
4	3	19.8	19.8	28
5	3	24.04	24.04	34
6	3	28.28	28.28	40



60° Angle				
Steps	Maximum Cutting Position	A	B	L
1	5	5.77	10	11.55
2	3	9.24	16	18.48
3	3	12.7	22	25.4
4	3	16.17	28	32.33
5	3.5	20.21	35	40.41

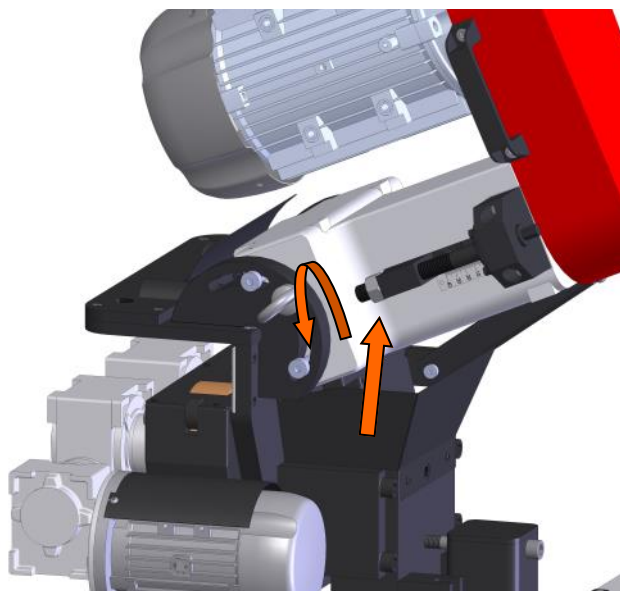
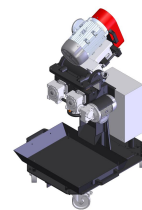
## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

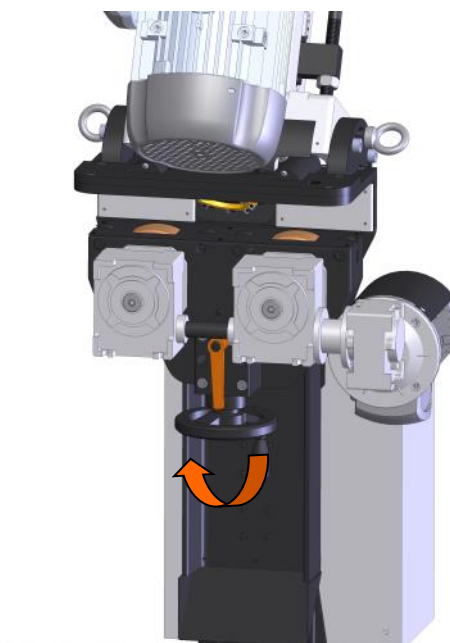


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



Once the required depth is reached, screw the locking nut to secure the mechanism in the position.



Loose the lifting assembly lever.

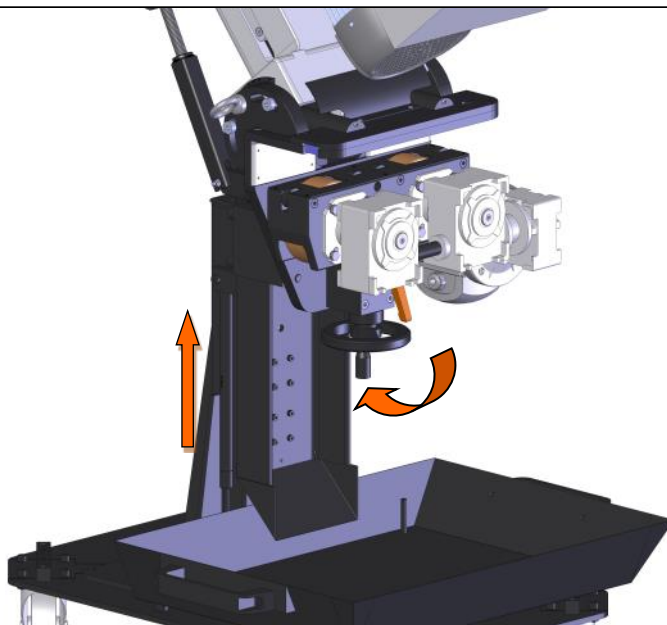
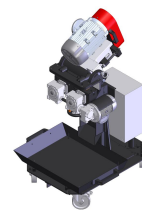
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

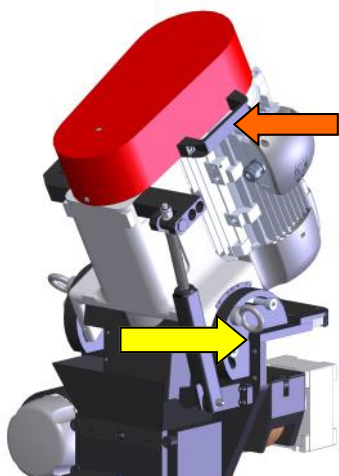


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive 2006/42/CE



By turning the hand wheel you can regulate the lifting assembly positioning according with the plate thickness.



Move and position the machine on the plate using the handles making sure you are approaching the plate with the side where the plate detecting sensor is located.

**Y  
E  
S**



While approaching towards the plate make sure that the wheels of the trolley are all facing the direction of motion so that they will not interfere with the linear movement.

**N  
O**



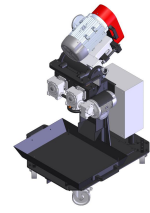
## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

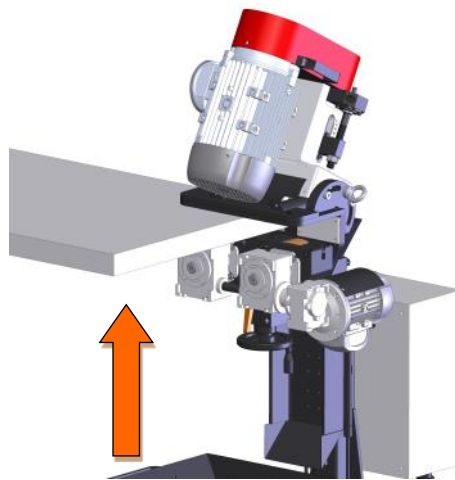


# EDGE COMPACT

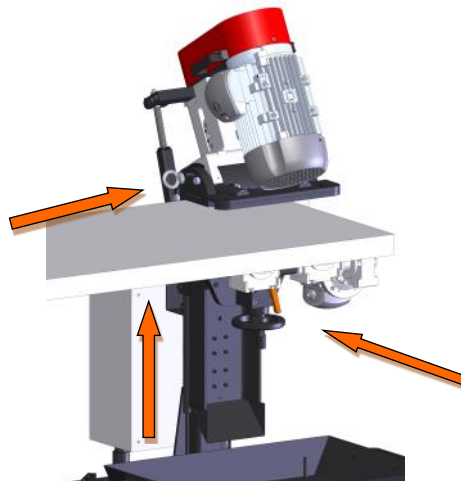
Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



**Ensure there is no oil or grease residue on the plate before the positioning phase and in case of any burr or imperfections caused by flame cutting, grind them off in order to grant the optimal locking position and smooth beveling process.**



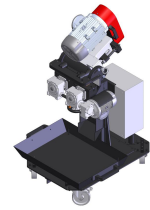
Place the machine so that the plate. The plate will have to run between the orange rubber wheels and the retaining rollers opposite to them.



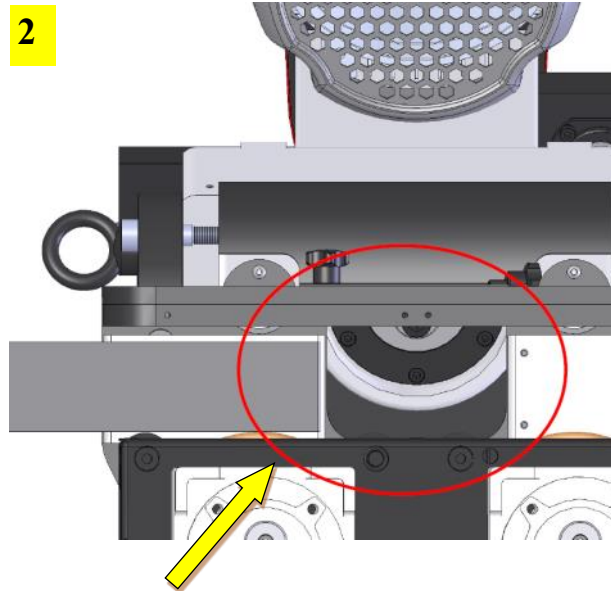
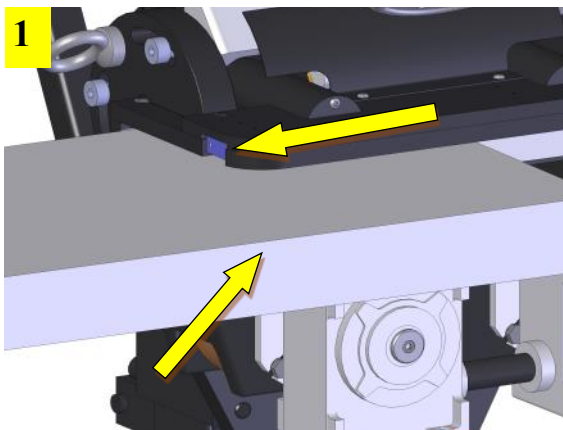
Move the lifting assembly by using the hand wheel until the machine is locked on the plate.  
Now turn the lifting assembly locking lever to secure the position of the assembly.

**G.B.C. Industrial Tools S.p.A.**

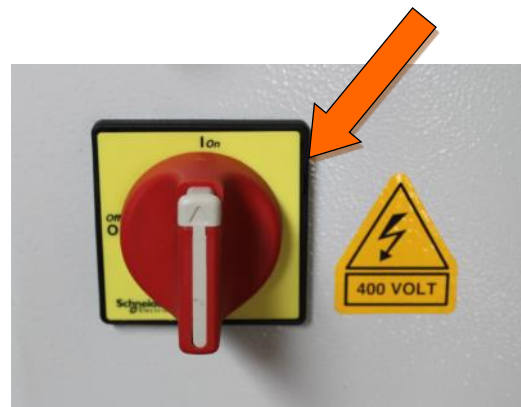
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



**Ensure the plate is parallel to the ground once it is locked.**



- When the machine is positioned on the plate, ensure that the plate intercepts the sensor as shown in the figure #1.
- Ensure that the plate is positioned right before the face mill working range.
- N.B. The plate has to be inserted so that the machine moves right to left as shown in the figure #2.



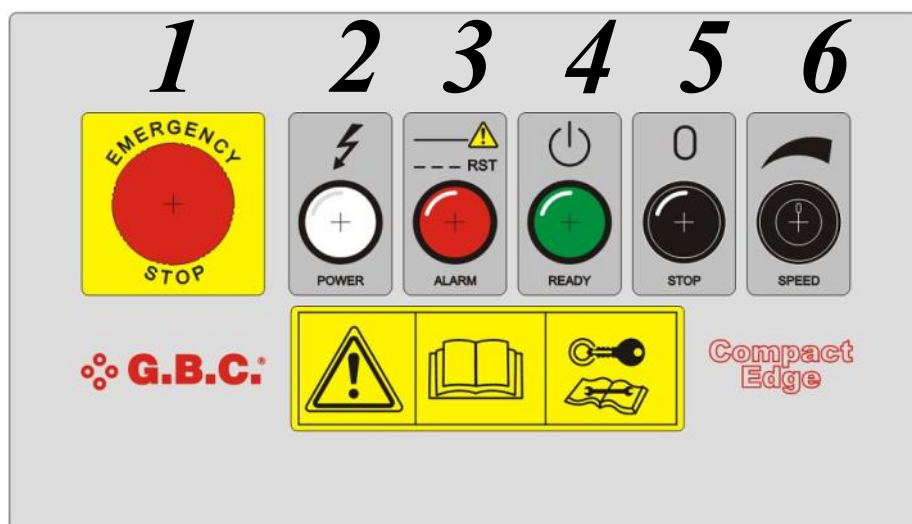
Plug the machine to the power supply and turn the switch to the “ON” position.

**G.B.C. Industrial Tools S.p.A.**

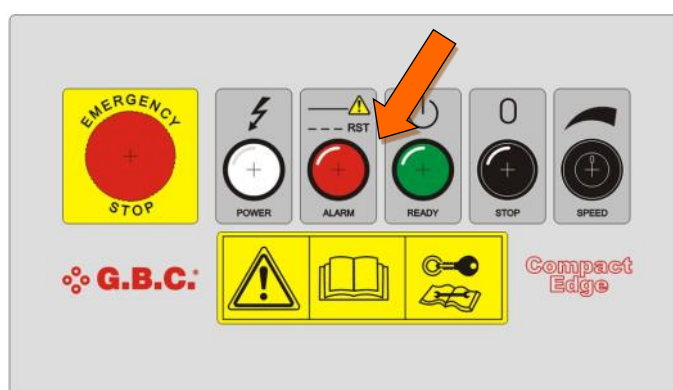
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



## CONTROL PANEL



- 1 - Emergency Stop
- 2 - Electricity Detector
- 3 - Phase / Inverter Alarm
- 4 - Plate Detection Sensor ( Active when light is on) / START/STOP Button
- 5 - Face Mill and Feeding STOP Button
- 6 - Feeding Speed Regulator



**A PULSATING RED LIGHT indicates the phase is wrong and has to be changed.**

**A STEADY RED LIGHT requires to restart the machine by switching OFF and oON the main POWER SWITCH.**

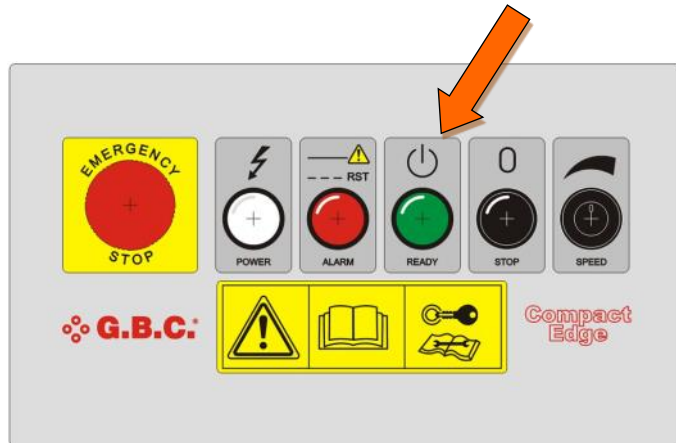
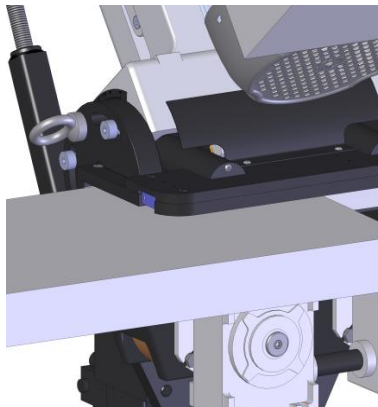
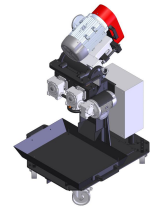
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



Once the plate is positioned and all is in order, the green light of the START button will turn ON.  
Start the machine by pressing the GREEN button as shown in the above figure.

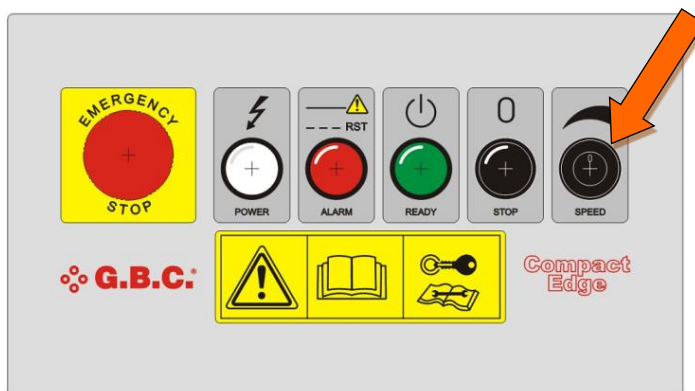
## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive 2006/42/CE



During the working process, the feeding speed can be adjusted by rotating the potentiometer indicated by the arrow in the above figure.



In case of emergency press the red button on the control panel. This will immediately stop the machine.

## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



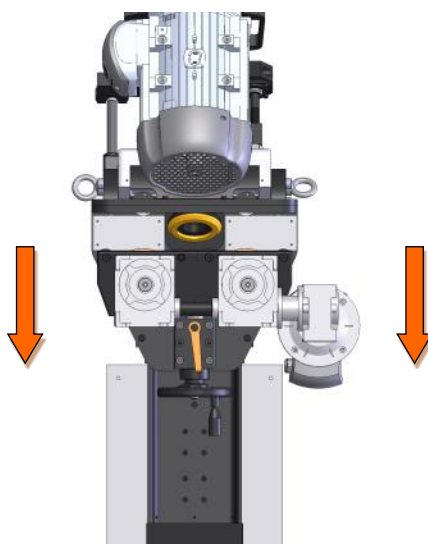
## **INSERTS REPLACEMENT**



Before starting this operation ensure that the machine is unplugged from the power supply and that the area in which the operation will be performed is clean and clear.



Set the machine to the maximum bevel degree (60°).



Lower the lifting assembly at the minimum height as previously explained.

**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

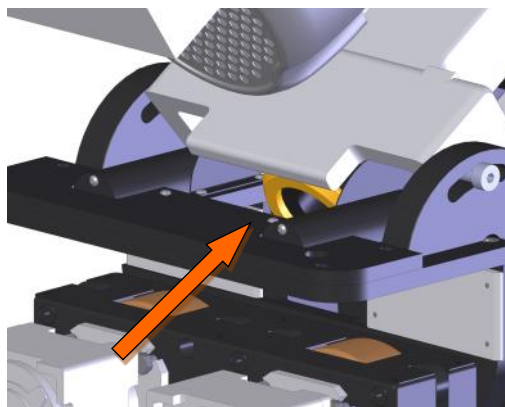
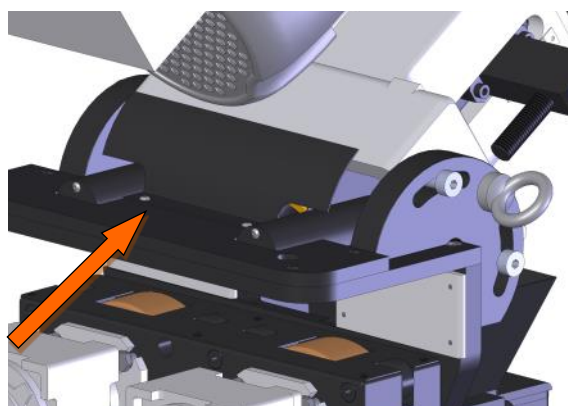


# EDGE COMPACT

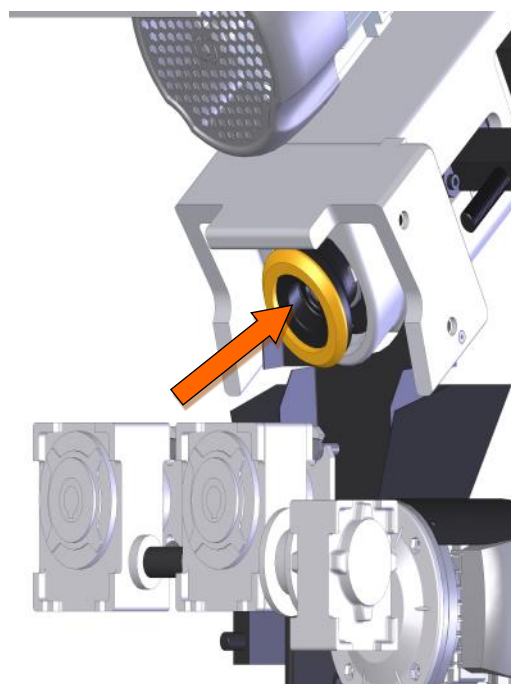
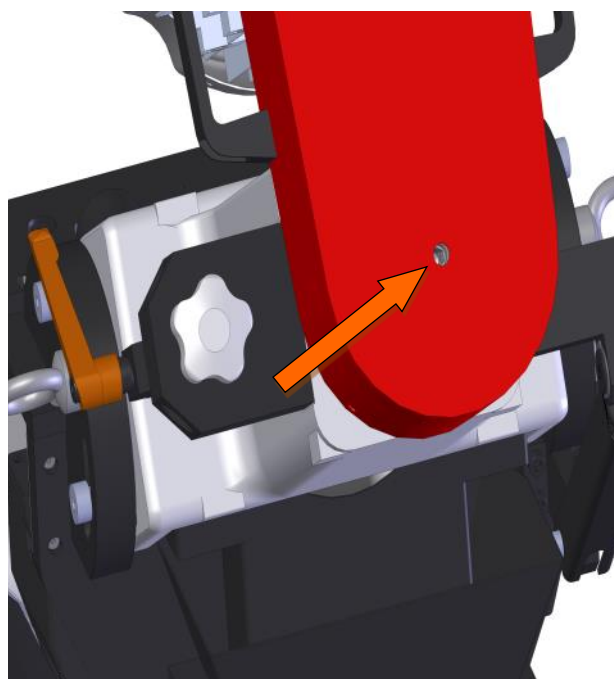
Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive 2006/42/CE



**WARNING :** This procedure requires the use of protective gloves to avoid injuries deriving from the insert blades or from the heat of the Face Mill in case the machine has been used right before replacing the inserts.



Remove the face mill protection.



Insert the Long T-Handle Allen Key in the hole located in the back of the machine on the red metal protection to engage the spindle (if by turning the Allen Key the Face Mill turns too it means that the spindle is engaged).

Insert the standard Allen Key in the central screw of the Face Mill and perform a counter-rotating movement of the Allen Keys as shown in the figure above.

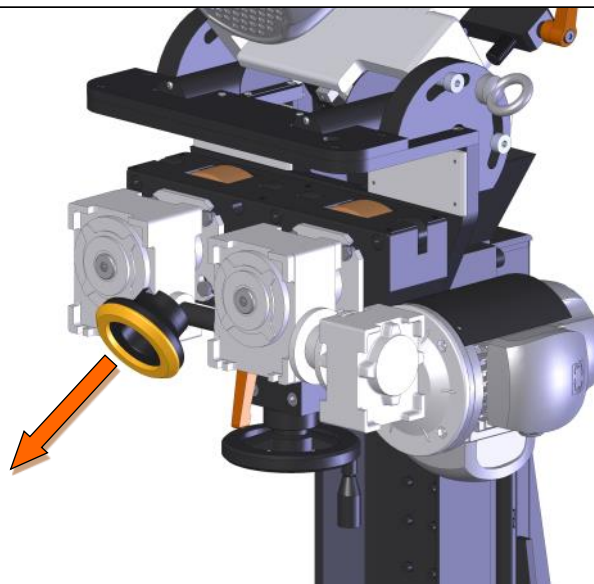
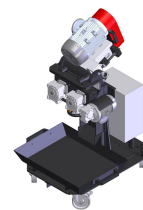
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



The Face Mill should come off the spindle with no effort so keep your hand on it to prevent it to fall. In case it does not come off, gently move it back and forth until it slowly comes off the spindle.



Loose the fixing screws of the inserts enough to allow them to rotate exposing the new blade and tighten the screws again to fix the inserts in position.

In case the insert is too damaged or all the 4 blades are worn-out, remove the fixing screw, replace the insert with a brand new one and use the same fixing screw to secure the new insert in position.

## G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE

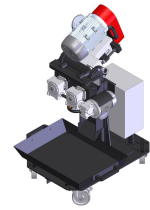


Once all the inserts have been rotated or replaced, install the face mill on the spindle following the above instructions backwards.



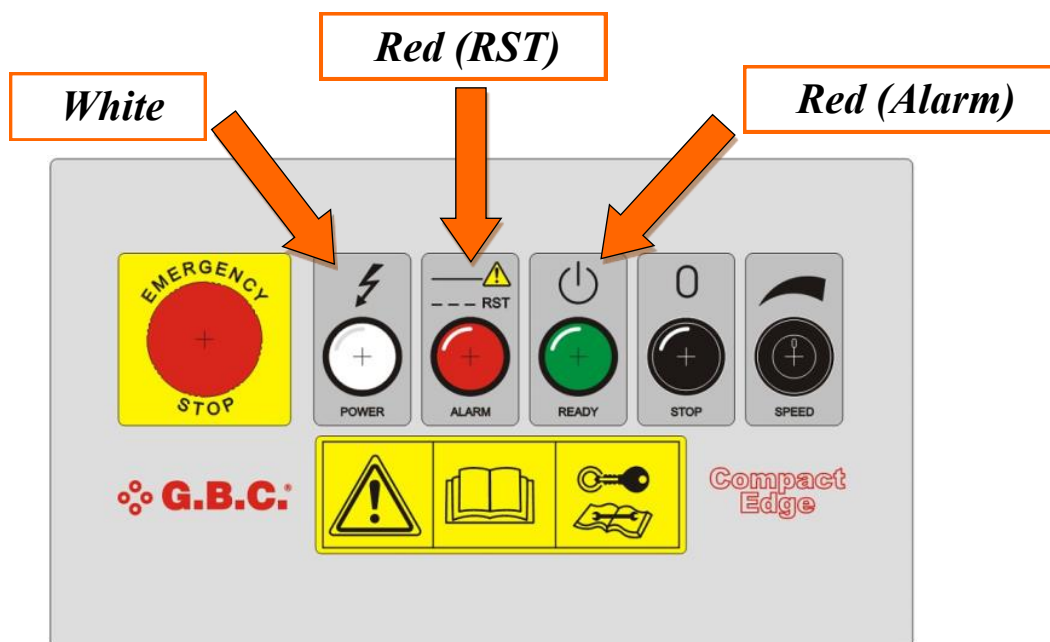
**WARNING** : during this process make sure to match the keyways of the spindle with the recesses present on the back of the face mill.

The face mill has to be abutted to the spindle and even when the keyways are in the proper seats, you will want to perform a visual check and a tactile check to ensure the correct installation of the face mill.



## **WARNINGS AND TROUBLESHOOTING**

The machine should be cleaned after every operation with compressed air, paying particular attention to the area nearby the cutter, blowing away all the chips resulting from the use.



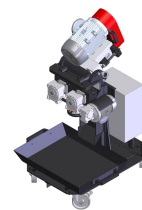
### **THE MACHINE DOES NOT WORK:**

- Check that the **white light** is lit.
- If the **red light (RST)** is pulsating, check the phase of the electric connections and reverse it.
- If the **red light (Alarm)** is lit, check the motor and/or the inverter thermal protectors.
- If the machine feeding system should sustain a mechanical stop, the **red light (Alarm)** will turn on. Turn off the machine using the main power switch. Check the cause of the stop, the feeding speed and the pass depth. Turn the machine on with the **main power switch** and run again the start-up sequence.

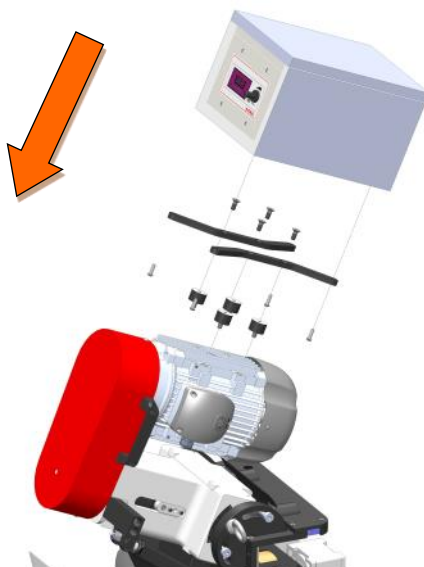


# G.B.C.® EDGE COMPACT

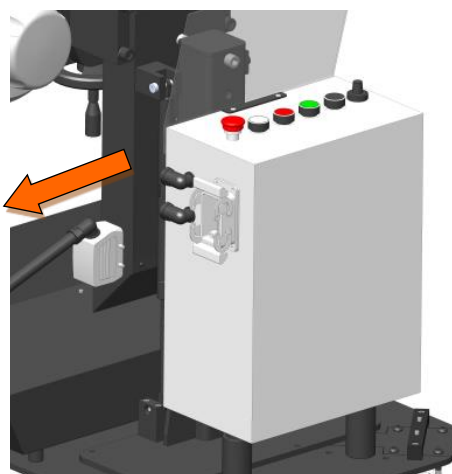
Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



## INSTALLATION AND USE OF THE FACE MILL SPEED REGULATOR



Install the Face Mill Speed Regulator on top of the motor as shown in the picture above.



Disconnect the connector from the control panel as shown in the above picture.

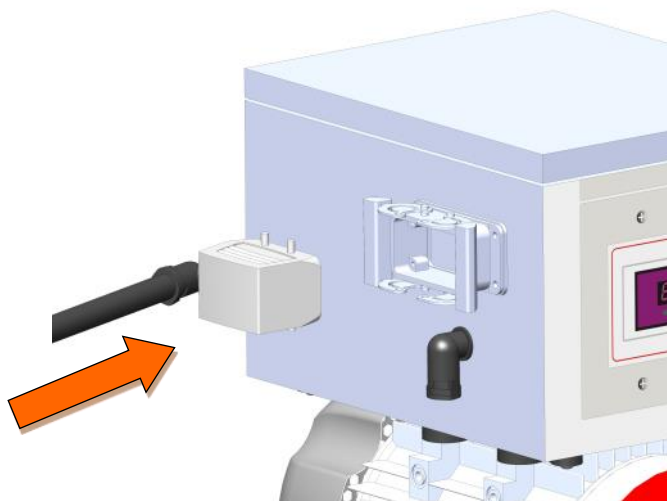
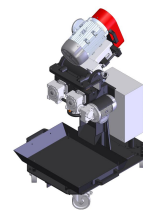
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

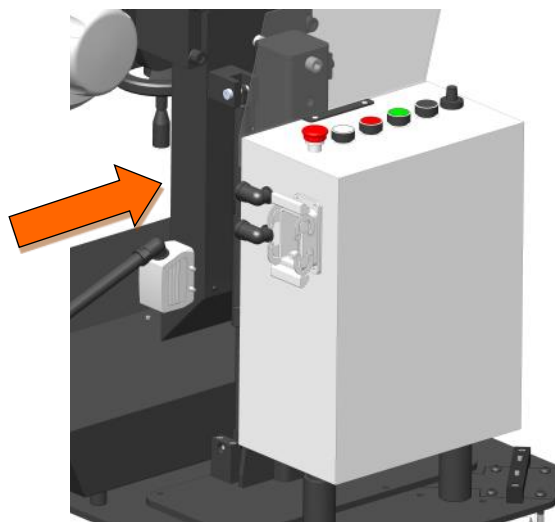


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



Now plug the same connector to the Speed Regulator



Plug the other end of the connector to the socket located on the left side of the power box as shown above.

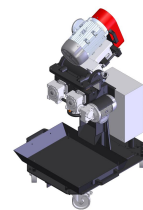
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



The speed of the Face Mill can now be adjusted by simply turning the knob counterclockwise to reduce it or clockwise to increase it.



Refer to the previous paragraphs for the use of the machine.

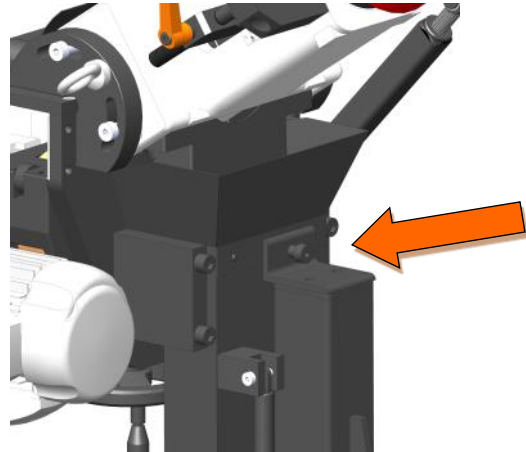
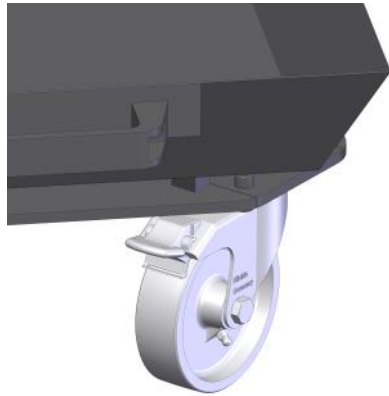
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



The wheels are equipped with brakes, in order to prevent the machine to move when working small plates.

The trolley has two locking positions:

- The lower position, used for the machine transportation in its wooden case.
- The higher position used during the normal working routine which allows the machine to “float” and automatically adjust its height during the beveling operations.



In case the machine is moved by cranes or any other lifting device ensure the trolley is locked in the lower position with the two screws supplied with the machine. Lifting the machine without this precaution may damage the pistons and the linear guide of the trolley and causing the warranty to be void.

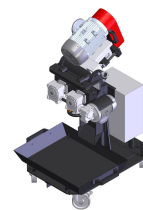
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629

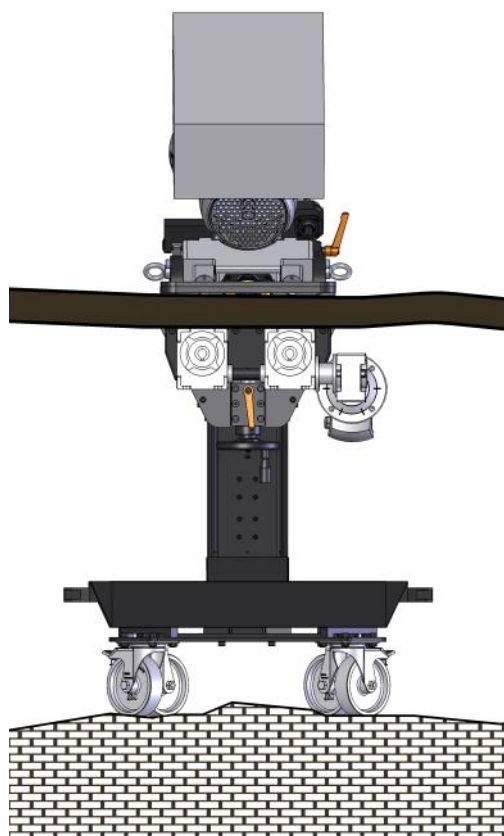


# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph I 1.7.4 of the Machine Directive  
2006/42/CE



Ensure that the floor over which the machine will be operated is not inclined and that there are no holes or obstacles that may prevent the correct feeding of the machine.



The trolley suspension system is designed in order to allow the machine to follow eventual imperfections of irregular plates as well as of irregular floor surfaces.

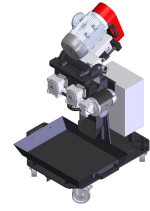
**G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



# EDGE COMPACT

Original Instructions—rev.2014— In compliance with the paragraph 1.7.4 of the Machine Directive  
2006/42/CE



## **ORDINARY MAINTENANCE**

We suggest to perform a service c/o G.B.C. Industrial Tools S.p.A. premises every 400 hours working cycles.

## **PERIODICAL CHECKS**

- Always check the machine general conditions
  
- Always use well sharpened inserts

G.B.C. Industrial Tools is at your disposal for any information you may require about the above mentioned procedures and for any general clarification you may need.

## **G.B.C. Industrial Tools S.p.A.**

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629