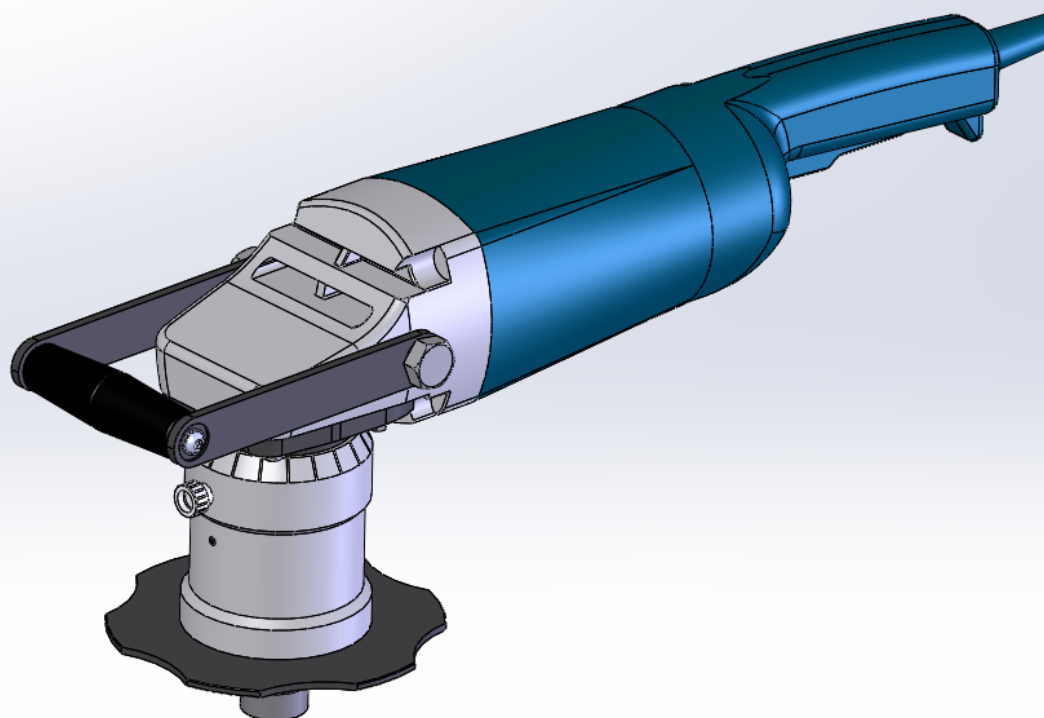




# INSTRUCTION MANUAL



# PLATE BEVELER MANUAL EDGE

Versione 09 .2015

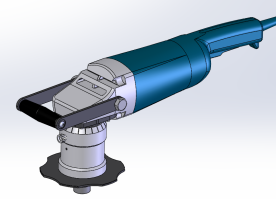
**G.B.C. Industrial Tools S.p.A.**

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# MANUAL EDGE

Original Instructions Rev.00-2015 in compliance with the § 1.7.4  
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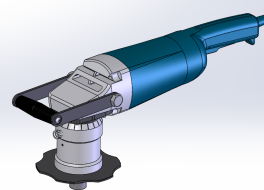
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# MANUAL EDGE

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## **FOREWORD**

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 forbid-den 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 pre-scribed 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 Torbiato di Adro – Italy prior to proceed with any modification on the machine.

**You are invited to scrupulously adhere to the information written on the identifica-tion tag.**

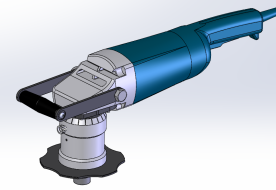
For any further information you are invited to contact us at these numbers:

**Tel. +39 - 030 - 7451154**  
**Fax +39 - 030 - 7356629**



# MANUAL EDGE

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## **WARRANTY GENERAL CLAUSES**

**G.B.C.** guarantees the reliability of the machine and its conformity 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 imputable to the user. The parts subject to wear are excluded from the warranty at sole discretion of **G.B.C.**.

In case of any operational malfunction arising during the warranty period, **G.B.C.** 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 directly 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.** and by a **G.B.C.** official distributor connected with the **MSS** maintenance service.

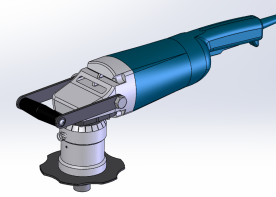
The shipment of the defective material must be performed within 8 (eight) days from the notification of the defect and/or the claim and/or the request of technical assistance. On the contrary the warranty will be void. **G.B.C.** and **MSS** obligations will cover the defect resolution, the general maintenance and the inspection of the parts subject of the claim only. The component replacement is at **G.B.C.** discretion only. The shipment 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.** 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.** 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, atmospheric events, acts of vandalism, incautious handling and/or transport, use of non original **G.B.C.** parts and damage for causes not specified by **G.B.C.** and for which **G.B.C.** declines any responsibility. **G.B.C.** 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.** 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.



# MANUAL EDGE

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## **INTENDED USE OF THE MACHINE**

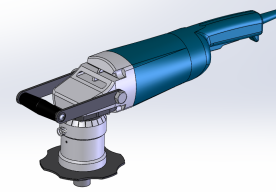
**THE MPB17 CAN BE USED ONLY BY SPECIALIZED OPERATORS WHO HAVE ATTENDED THE NECESSARY FORMATION**

**UPON SPECIFIC FORMATION WE DO ARE NOT IN POSITION TO WARN ABOUT ANY EVENTUAL IMPROPER USE OF THE MACHINE**



# MANUAL EDGE

Original Instructions Rev.00-2015 in compliance with the § 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

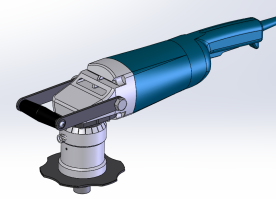
Keep the hands away from hot and sharpened parts.

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.



# MANUAL EDGE

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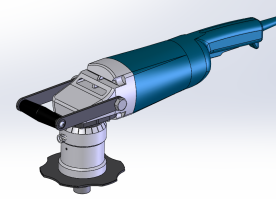
## **SPECIFIC SAFETY PRESCRIPTIONS FOR** **THE MPB17**

- WEAR SAFETY GLASSES.
- WEAR HEARING PROTECTION.
- WEAR HAND PROTECTION.



# MANUAL EDGE

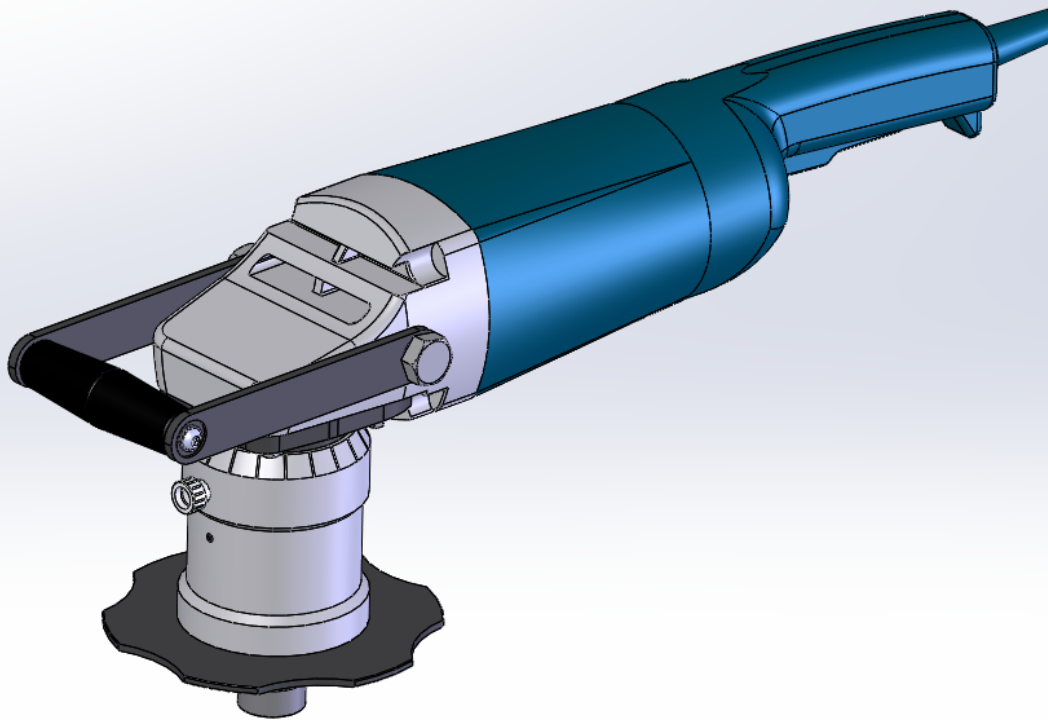
Original Instructions Rev.00-2015 in compliance with the § 1.7.4  
of the Machine directive 2006/42/CE



## **STANDARD EQUIPMENT**

The machine is supplied with:

- 6mm Allen Key
- Torx T15 Screwdriver
- Face Mill (upon your specific request)
- Inserts (upon your specific request)
- Instruction manual
- Exploded drawings

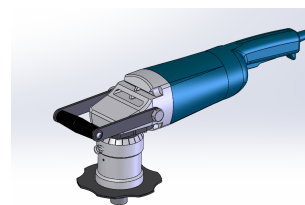


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# MANUAL EDGE

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## SERVICE TOOLS



## FACE MILL

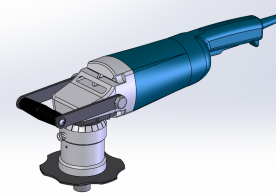


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## TECHNICAL FEATURES

FEATURES AND PERFORMANCE	UNIT MEASURE	VALUE	NOTES
Motor Power	KW	2.1	-
Tension	V	110/220	-
Frequency	Hz	50 / 60	—
Face Mill Speed	RPM	6500	-
Face Mill Type	n	5 inserts	-
Max Pass Step	mm	2	-
Max Diagonal Bevel	mm	17	-
Plate Minimum Thickness	mm	3	-
Angolo di smusso $\alpha$	°	22.5÷60°	See Chart
Radiuses Achievable in "R" Position	R	3÷4÷5	In "R" position
Constant Noise at 5mt from the machine Peak Noise at 5mt from the machine	(dB A) (dB B)	70÷75 80÷85	See Notes in the page
Weight	Kg	8,5	Without Face Mill

**NOTES:**

G.B.C. Industrial Tools S.p.A. declares that every machine is tested on steels commonly used in mechanical and metal work fabrication with 30mm wall thickness. The figures listed in the above chart are detected by a phonometer certified by an acoustic calibrator model DELTA HOM HD 9102 certified by LAT (former SIT) N. SIT 03229/09 and we confirm the figures recorder are in compliance with the regulation EN 60745.

Therefore following the evaluation of the environmental risks on the workplace, regulated by the law decree 81/08 and following modifications, in compliance with the directive 2003/10/CE, and of the art.190 of such law decree, the personnel authorized to operate the ManualEDGE must be trained and educated in regards to the above directive and must be equipped with the personal protective equipment (PPE) and acoustic detection system on request of the operator himself or if deemed necessary by the medical staff.

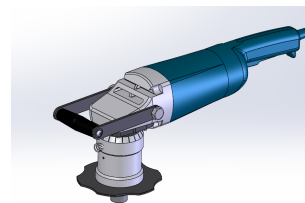
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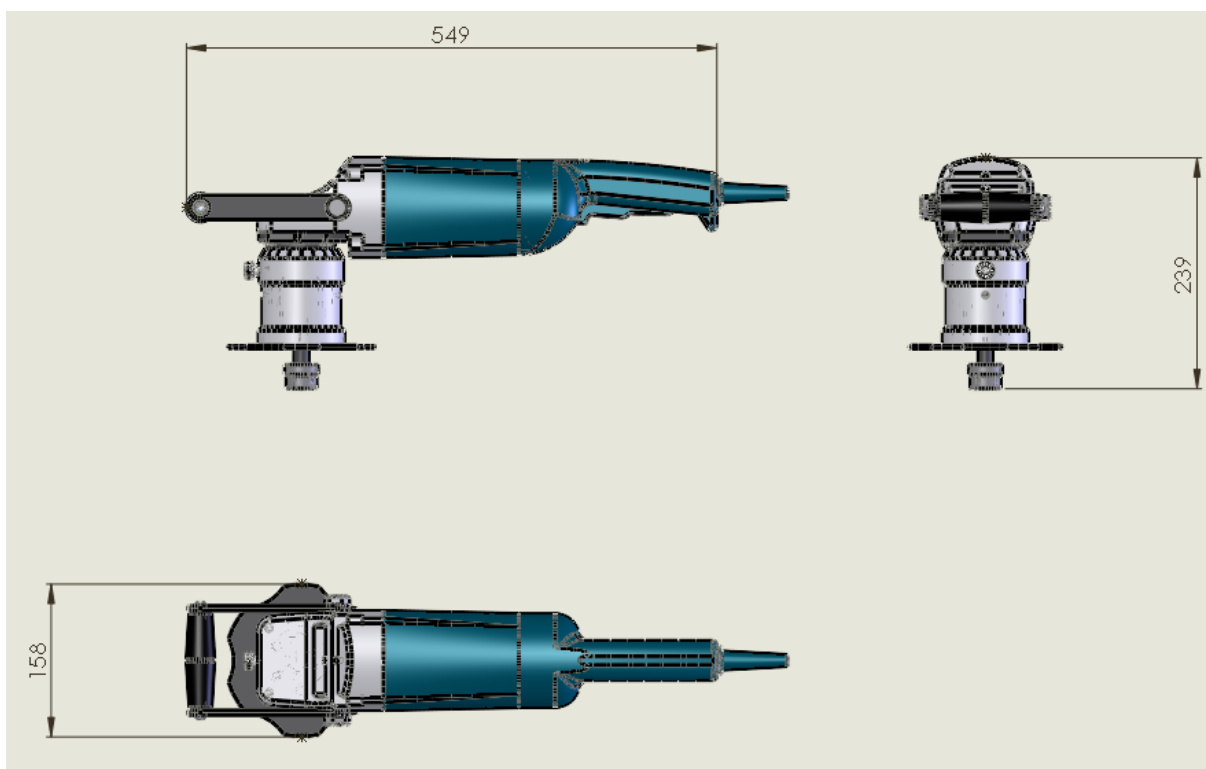


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## MEASURES



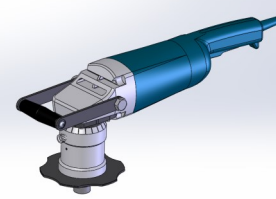
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## CUTTING PARAMETERS CHART

### CARBON STEEL

Feeding Speed (mm/min)	RPM (giri/min)	Inserts
Manual	6500	UTC10970

### ALUMINUM

Feeding Speed (mm/min)	RPM (giri/min)	Inserts
Manual	6500	UTC10970

### STAINLESS STEEL

Feeding Speed (mm/min)	RPM (giri/min)	Inserts
Manual	6500	UTX10970

### CAST IRON

Feeding Speed (mm/min)	RPM (giri/min)	Inserts
Manual	6500	UTX10970

### INCONEL

Feeding Speed (mm/min)	RPM (giri/min)	Inserts
Manual	6500	UTX10970

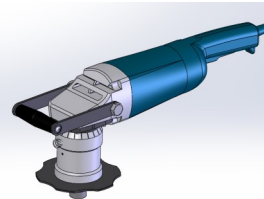
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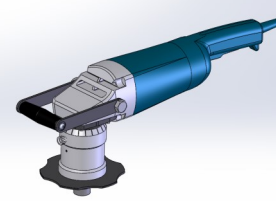


## BEVELING CHART

Angle (°)	Vertical Value for Single Pass (mm)
22,5	2,0
30	2,0
37,5	2,0
45	2,0
55	2,0
60	2,0

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

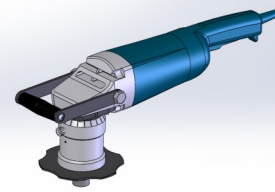
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## **BEVELING FACE MILL SETUP**

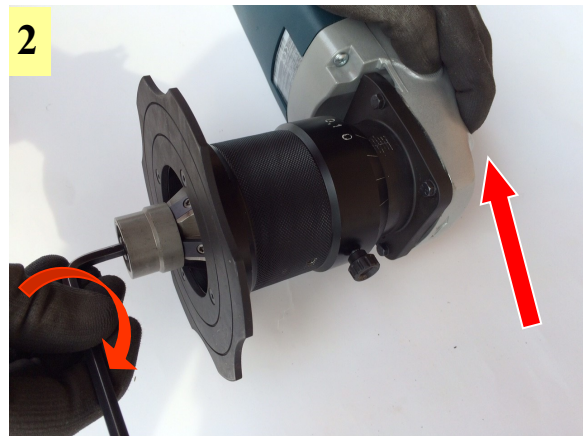
- 1) Use the torx screwdriver supplied with the machine to fix the inserts in their seats located on the face mill sides.

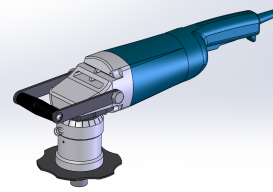




## **FACE MILL MOUNTING PROCEDURE**

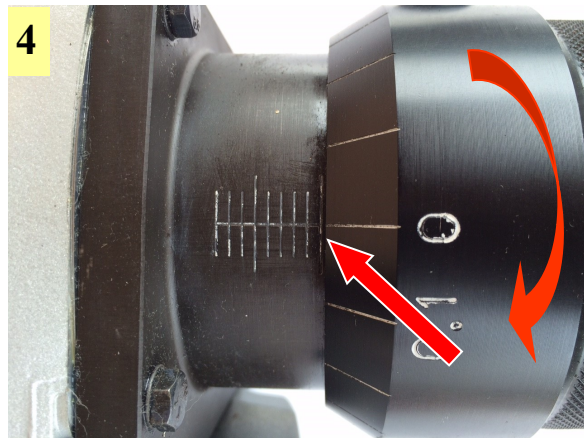
- 1) Place the face mill on the spindle.
- 2) Use the 6mm Allen key and keep pressed the spindle locking button so that you can easily fasten the central screw.

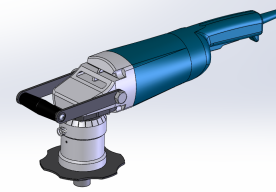




## GAUGE RESET

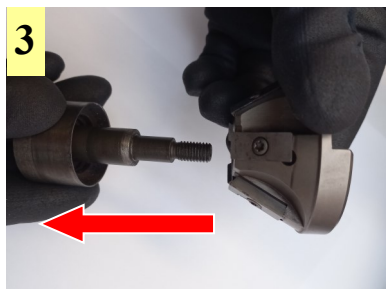
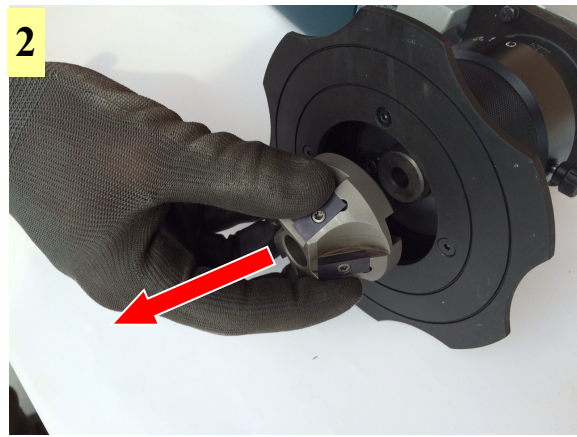
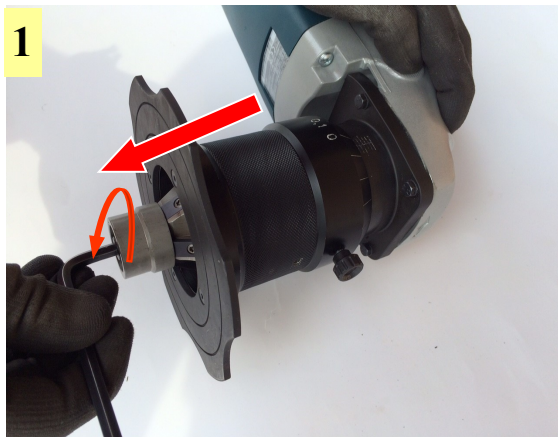
- 3) Loosen the set screw pointed by the arrow;
- 4) Bring the gauge to the position “zero”;
- 5) Fasten the set screw.

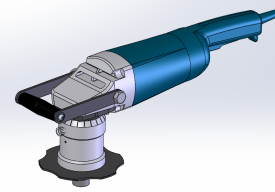




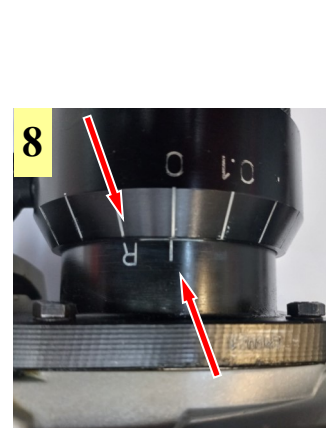
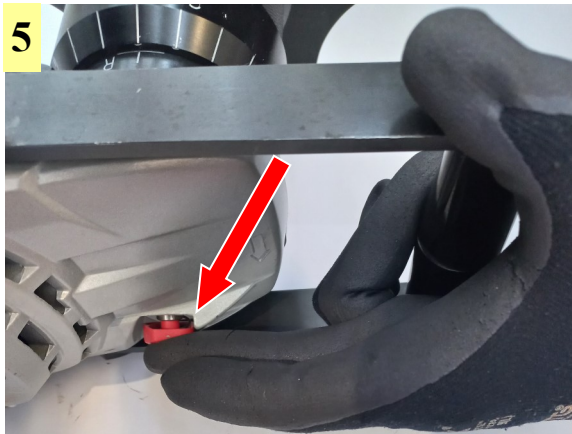
## **RADIUS FACE MILL MOUNTING PROCEDURE**

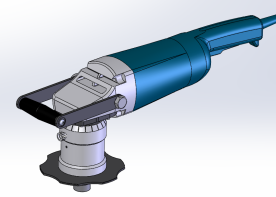
- 1) Remove the locking screw that is located at the center of the Face Mill.
- 2) Remove the standard Face Mill from its seat.
- 3) Slide the guiding pin off from the Face Mill.
- 4) Insert the guiding pin all the way in the Face Mill for Radius Bevel.





- 5) Place the Face Mill in its seat and press the red button shown in the photo to lock the rotation.
- 6) Tighten the Face Mill Locking Screw.
- 7) Loosen the Set Screw.
- 8) Rotate the Flange until the marker “R” matches with the value “0”.

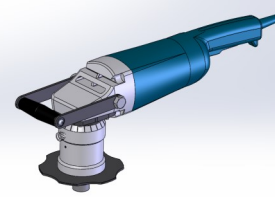




## **POSITIONING OF THE MACHINE**

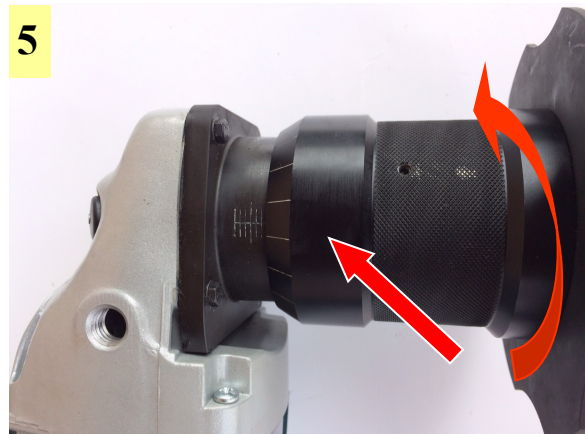
- 1) Before starting the machine pay attention to the round back-plate as the white arrows engraved on it show the direction you will have to move the machine once started.
- 2) Start the machine by pressing the security lever.
- 3) Get close the edge of the plate, advance slowly and complete the pass.





## **FOLLOWING PASSES**

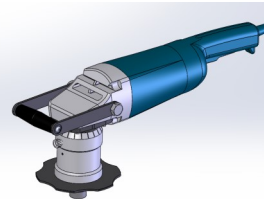
- 4) Loosen the set screw as you did for the gauge resetting procedure;
- 5) Make one full turn of the sleeve (gauge) which equals to a 2 mm feeding;
- 6) Fasten the set screw.





# MANUAL EDGE

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## **PASS COMPLETED**

- 7) Get away from the edge of the plate;
- 8) Turn off the machine by releasing the security lever.



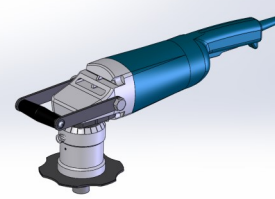
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## **EMERGENCY PROCEDURE**

**N.B. In case of any problem during the working operations release immediately the security lever to stop the stop the machine instantly.**



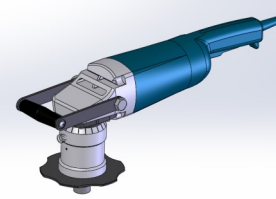
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## **TROUBLESHOOTING**

- The machine does not start:
  - 1) Check if there is electric current in the power supply.
  - 2) Check for any damage to the security lever.
  
- Malfunctions:
  - 1) Check for unusual vibrations;
  - 2) If the face mill is not beveling properly check the status of the inserts.

**N.B. For any other anomaly occurring during the working activity which is not described above you are invited to contact G.B.C.'s customer service.**

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