



OPERATOR'S MANUAL

Metal Working



PORTABLE PLATE AND RADIUS BEVELER MODEL: CM-060PR

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 30 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing, and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator's manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorneys' fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at sales@baileigh.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.



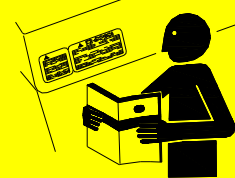
Note: *This symbol refers to useful information throughout the manual.*



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**

Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death.**

Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.

General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.



DANGER



WARNING



CAUTION

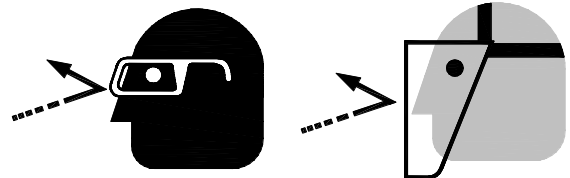


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



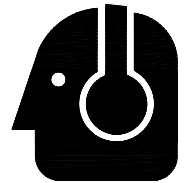
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



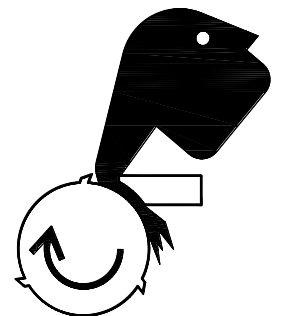
CUTTER HAZARD

Keep hands and fingers away from the rotating cutter blades. These rotating cutters can be extremely dangerous if you do not follow proper safety procedures. **NEVER place hands directly over or in front of the cutter. Keep hand at least 6" (150mm) from the cutter while operating.**



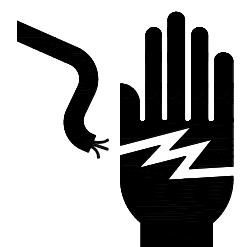
ENTANGLEMENT HAZARD – ROTATING BLADES

Contain long hair, **DO NOT** wear jewelry or loose fitting clothing.



HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.
FOLLOW PROPER LOCKOUT PROCEDURES.





STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **STOP** button (A) located on the control box face.



SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE! ...PLEASE ENJOY IT SAFELY!



1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
7. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
8. **Dressing material edges.** Always chamfer and deburr all sharp edges.
9. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machines rated capacity.
10. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
17. **Blade adjustments and maintenance.** Always keep blades sharp and properly adjusted for optimum performance.
18. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.



19. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
20. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
21. **Do not** cut where the atmosphere might contain flammable dust, gas, or liquid vapors such as from gasoline. Watch for fire and keep a fire extinguisher close by.
22. **Turn off** power before checking, cleaning, or replacing any parts.
23. Keep **all** cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!** **DO NOT** touch live electrical components or parts.
25. **DO NOT** bypass or defeat any safety interlock systems.
26. Keep visitors a safe distance from the work area.



TECHNICAL SPECIFICATIONS

Motor Power	1.5hp (1100W)	
Voltage	110V, 60hz, 15A	
No Load RPM	60Hz: 3600 (50Hz: 3000)	
Angular Adjustment	Angle	Maximum Bevel Width**
	60°	0.708" (18mm)
	45°	0.787" (20mm)
	37.5°	0.700" (17.8mm)
	30°	0.657" (16.7mm)
	15°	0.618" (15.7mm)
	0°	0.826" (21mm)
Minimum Material Dimensions	2.36" x 2.36" x .11" (60 x 60 x 3mm)	
Cutting Speed	5.8fpm (1800mm/min.)	
Milling Head	2 @ 2.5" (63.5mm) with 6 Inserts each	
Dimensions	18.7" x 11.6" x 9.73" (475mm x 296mm x 247mm)	
Net Weight	42.46lbs (19.3kg)	

**** Important:** The maximum 0.393" (10mm) per pass.

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990, and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileigh.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.



WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Cleaning



WARNING: **DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





INSTALLATION

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.



GETTING TO KNOW YOUR MACHINE





Item	Description
A	Back Handle
B	Cutting Depth Chart**
C	Cutting Depth Adjustment Knob
D	Front Handle
E	AC Induction Motor
F	Start Push Button
G	Stop Push Button
H	Side Handle
I	Depth Scale 0 – 12mm
J	Depth Lock Bolt. (2, one on each side)
K	Angle Scale 0° – 60°
L	Angle Lock Bolt. (2, one on each side)
M	Guide Roller

**** Important:** The maximum 0.393" (10mm) per pass.



ELECTRICAL



CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.



WARNING: Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Power Specifications

Your tool is wired for 110 volts, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.



WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

AMP RATING	LENGTH		
	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
WIRE GAUGE			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

Power cord connection:

1. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply in a way that does NOT create a trip hazard.
2. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
3. When the machine is clear of any obstruction. The power switch may be turn ON to test the operation. Turn the machine OFF when not in direct operation.



INTENDED USE

This shape beveling and deburring tool is an electrically driven portable machine: For machining workpieces in steel, stainless steel, chrome steel alloys, aluminum, aluminum alloys, brass and plastic. The machine is designed exclusively for adding beveled edges, rounding off edges, removing burrs, and removing sharp corners on workpieces. The machine is equipped with a graduated, depth and angle adjustable table plate.



WARNING: The machine should 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.

SETTING THE CHAMFER HEIGHT

1. Disconnect tool from power source.
2. Loosen the 2 Depth lock screws (A) of both sides with supplied M8 Hex Wrench.
3. Turn the Depth adjustor knob (B) clockwise or counter-clockwise to adjust to the desired chamfering height. Refer to the scale (C) on the side of the machine, maximum chamfering depth up to 12mm at 45 deg.
4. After making sure the chamfering blades are set to the desired height, fasten the 2 Depth lock screws.



ADJUSTING THE BEVEL ANGLE

1. Disconnect tool from power source.
2. Loosen the two Angular Adjustment Screws (D) using the L-hex wrench.
3. Adjust to the desired bevel angle using the scale. Refer to the angle scale on the body of the machine.
4. Tighten the screws.
5. It may be necessary to readjust the depth adjustment after changing the bevel angle.



CHANGING THE INDEXABLE CARBIDE INSERTS



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.



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



Note: Make sure the indexable carbide inserts are installed in the correct direction. Incorrect installation of indexable carbide inserts can cause the failure of chamfering or even rupture of the tool holders or the indexable carbide inserts. Please refer to the front of the machine for the rotation direction, and install the indexable carbide inserts accordingly.



1. Disconnect tool from power source.
2. Remove the 2 Depth lock screws and fully remove the support deck assembly.



3. Use the supplied M32 combination wrench to secure the spindle.
4. Use the supplied 27mm x 24mm wrench to unscrew the nut in front of the tool holder and loosen the tool holder from spindle.
5. Rotate, remove or replace the tool holders as needed.





6. Using the supplied M3 Hex wrench, loosen retaining screw and remove the carbide inserts.
7. Rotate the carbide insert to the next sharp edge or replace with a new insert when all edges have been used or if the insert is damaged in any way.
8. Fasten carbide inserts into the cutter head.

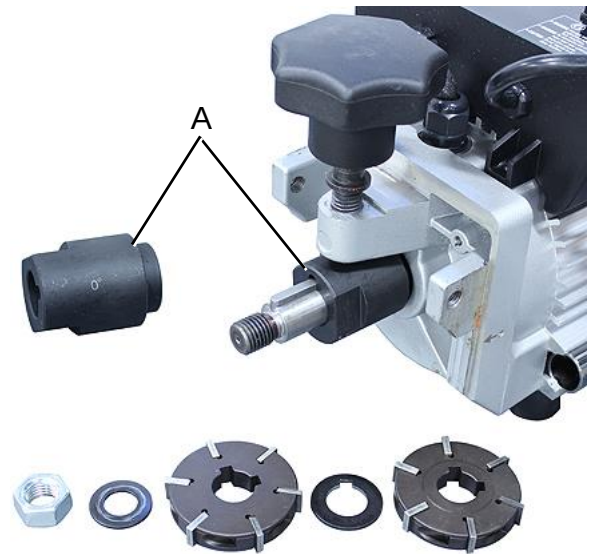


INSTALLING THE MILLING DISCS



Note: There are two different lengths of Milling Receiver (A) supplied with the machine. Use the long Milling Receiver for 0° facing off and use the short Milling Receiver (installed) for other angles.

1. Disconnect tool from power source.
2. First install the desired Milling Receiver to the spindle
3. Add the first Milling Disc, noting the correct orientation. Since the spindle rotates in the clockwise direction when viewed from the spindle end, the cutting faces of the carbide inserts should be facing the right.
4. Add the Intermediate Washer (with the keyway).
5. Add the second Milling Disc, orienting it so that it is staggered 90 degrees relative to the first Milling Disc.
6. Finally add the washer and nut and tighten the nut firmly.

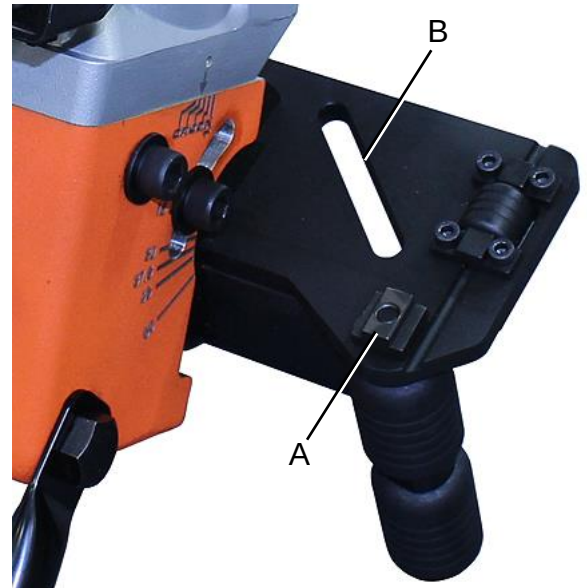




SWITCHING FROM PLATE BEVELING TO PIPE BEVELING MODE

The Table Plate has two possible modes. For plate beveling, keep the rollers mounted in the fixed position.

1. Disconnect tool from power source.
2. Adjust the chamfer material support to the 0 (zero) position.
3. For beveling of pipes 5.9" to 13.75" (150 to 350mm) diameter, remove the rollers and unscrew the T-nuts (A) from the rollers.
4. Engage the T-nuts into the slots (B), put the flat washers on the rollers and install the rollers finger tight.
5. Adjust the rollers so that the circumference of the pipe to be machines will have even and equally 3-point contact at both rollers, and back stop directly under the cutter head.
6. Tighten the rollers.
7. Every time you bevel a different sized pipe, you must readjust the rollers to match the circumference of the pipe to provide a 3-point contact.
8. When returning to plate beveling mode, screw the wedge nuts onto the rollers so that they will act as spacers.





OPERATION



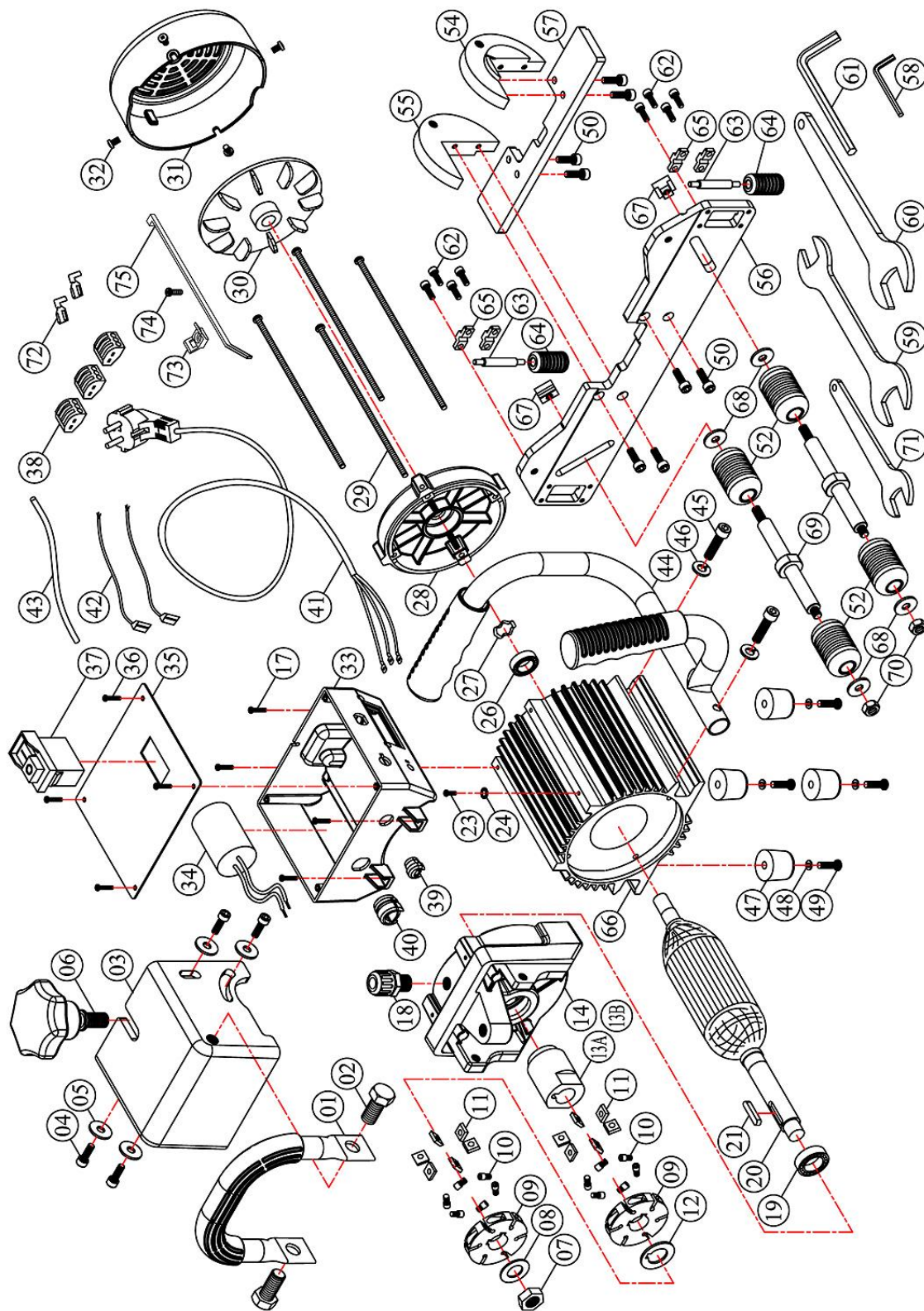
CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. Safe and effective control of this powerful tool requires two-handed operation at all times for maximum control and safety.

1. Verify that:
 - The input power supply is correct.
 - The cutter head is not in contact with or touching anything. Material or tools.
 - Material to be machined is properly supported and secured against movement or falling.
2. Following the adjustment procedures listed, set the bevel angle and depth.
3. Press the green ON button to start motor. Allow the motor to come to full RPM before beginning to machine material.
 - ALWAYS use two hand on the handles to hold, support and move the beveler.
 - Hold the beveler keeping the table plate flat and secure to the work piece.
 - The feed arrow indicated the direction the beveler should move in relation to the material. Right to Left as shown in the picture. When performing inside bevels, work in a clockwise direction only.
 - Always use light pressure when beginning the cut.
 - Do not bevel too much per pass. If more depth is needed, make multiple passes until the desired bevel height is reached
 - Do not use this tool continuously over 30 minutes.
4. To switch off the beveler, press the red motor OFF button. After the beveler has been switched off, the cutter will continue to rotate for a time. Take care that the cutter does not contact any body parts or material while it is still rotating!
5. Always switch off the beveler and unplug the plug from the power supply immediately after use, to prevent being operated by untrained personnel or accidents.





PARTS DIAGRAM





Parts List

No.	Description	Qty.
1	Front Handle	1
2	Screw M14 X 25	2
3	Bracket Head Cover	1
4	Socket Cap Bolt M10 X 20	4
5	Flat Washer Ø10 X Ø23 X 2	4
6	Depth Adjustor	1
7	Hex. Nut M16 X P2.0	1
8	Disc Spring Ø16 X Ø30 X 1.5	1
9	Milling Disc	2
10	Set Screw M6 X 6	12
11	Carbide Milling Insert	12
12	Intermediate Washer Ø20 X Ø35 X 2	1
13A	Milling Receiver 52.6mm for 0°	1
13B	Milling Receiver 50.6mm for 15~60°	1
14	Bracket Head	1
15	N/A	-
16	N/A	-
17	Screw M4 X 10	4
18	Cable Gland	1
19	Ball Bearing 6004-LLU	1
20	Armature	1
21	Parallel Key 6 X 6 X 30	1
22	N/A	-
23	Screw M4 X 8	1
24	Star Washer M4	1
25	N/A	-
26	Ball Bearing 6202ZZ	1
27	Wave Washer 6202	1
28	Motor End Casting	1
29	Socket Cap Screw M5 X 200	4
30	Fan PM-025	1
31	Fan Cover PM-025	1
32	Screw M5 X 8	4



33	Control Box Pm-025	1
34	Capacitor 250VAC, 20uf, 400VAC, 20uf	1
35	Switch Panel	1
36	Screw M4 X 10	4
37	Switch KJD17-AC230V	1
38	3 Wire Push In Connector	3
39	Cable Gland SB7R-3	1
40	Cable Gland SB8R-3	1
41	Power Supply Cable	1
42	Wire Lead	2
43	Wire Sheath 6mm X 15cm	1
44	Handle	1
45	Screw M8 X 40	2
46	Spring Washer M8	2
47	Rubber Foot 30L	4
48	Flat Washer Ø6 X Ø13 X 1	4
49	Screw M6 X 30	4
50	Socket Cap Screw M6 X 16	8
51	N/A	-
52	Guide Roller-Large	4
53	N/A	-
54	Slewing Bracket-Left	1
55	Slewing Bracket-Right	1
56	Horizontal Table Plate Ø150~Ø350, Ø300~Ø600	1
57	Vertical Table Plate	1
58	L-Hex Wrench 3mm	1
59	Wrench M24 X M27	1
60	Wrench M32	1
61	L-Hex Wrench 8mm	1
62	Socket Cap Screw M5 X 12	8
63	Roller Axle-Small	2
64	Guide Roller-Small	2
65	Axle Shackle	4
66	Stator Assembly 110V	1
67	Wedge Nut	2
68	Flat Washer Ø8 X Ø23 X 2	4



69	Roller Axle-Large	2
70	Nut M8	2
71	Wrench M22	1
72	Terminal	2
73	Saddle Type Tie Mount HC-4	1
74	Screw M5 X 8	1
75	TIE 4.7mm X 200mm	1

NOTES



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