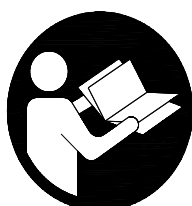
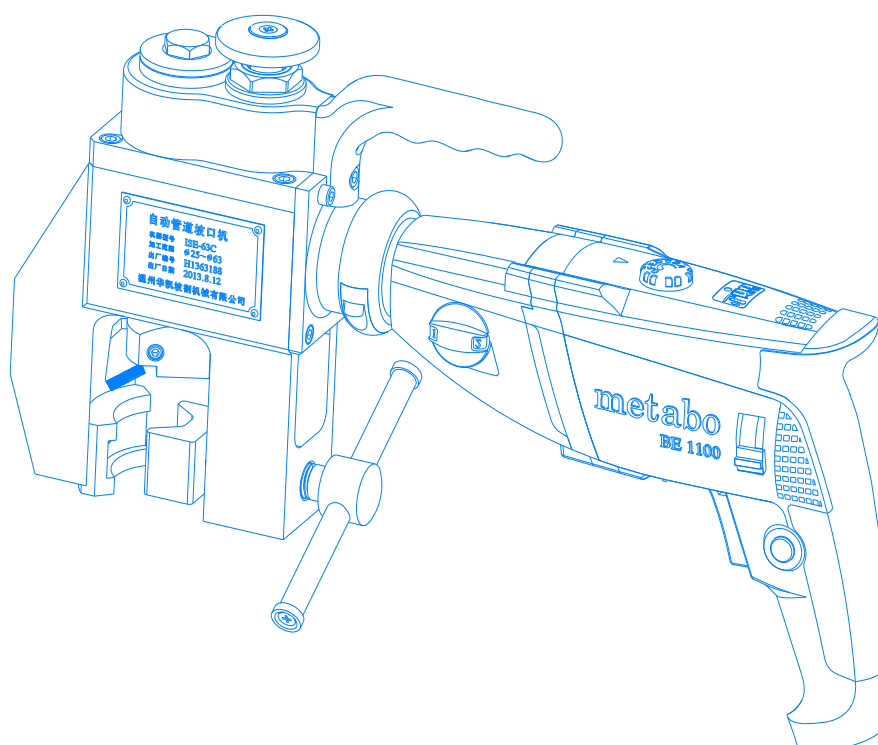


ISC Series Automatic pipe beveling machine

Operation Manual



Kindly read the operation manual
before using, and keep properly

Declare: We reserves the right to make changes in specification without notice.

PART ONE:EQUIPMENT INSTRUCTION

ISC series automatic beveling machine is a new design OD mounted electric beveling machine, equipped with Metabo long life electric driven motor. The machine compact structure, nice appearance, high reliability, easy dismounting, centering precision, easy operation, high efficiency, low noise, automatic feeding, small verticality deviation, can be widely used in beveling working of small-middle pipe, and work for maintain of pipe in narrow space.

PART TWO:SAFETY INSTRUCTIONS

For your safety and make sure the machine can work effective and reliability, kindly observe the security matters.

- ★ Power supply must meet the standard as nameplate, cable must have enough current capacity, keep away from heat, corrosive liquid and sharp things, using damaged and part-broken machine is not allowed.
- ★ The operator can't keep long hair or wear jewelry.
- ★ The machine can't be used in the condition of corrosive, wind & rain and inflammable, explosive.
- ★ Prohibited over loading operation, and there must some one watch over when the machine beveling.
- ★ Please take off the plug, turn off the power when the machine locked, replacing tools and measure on line.
- ★ Prohibited crash the machine or use the machine as a hammer.
- ★ Must use the block match the OD, so as avoid eccentric.
- ★ Edge or replace the tool when it's blunt.
- ★ Do maintain work and add lubrication oil termly, don't use inferior lubrication oil and waste fuel.
- ★ Keep about 2mm distance between tool bit and pipe end high point.
- ★ You can't force to start the machine when it's locked. Adjust the no loading distance and start the machine after it's cooling by itself.

★ Add the coolant when it's necessary and clear the scrap iron

PART THREE:MACHINE SPECIFICATION

Model	Work range	Angle	Thickness	Speed	Power supply
ISC-63	Φ28~63	30° (Customize)	≤12	100~260r/min	Rated voltage: 220V Rated frequency: 50/60Hz
ISC-76	Φ42~76		≤12	100~260r/min	
ISC-89	Φ63~89		≤12	100~260r/min	
ISC-114	Φ76~114		≤12	100~260r/min	

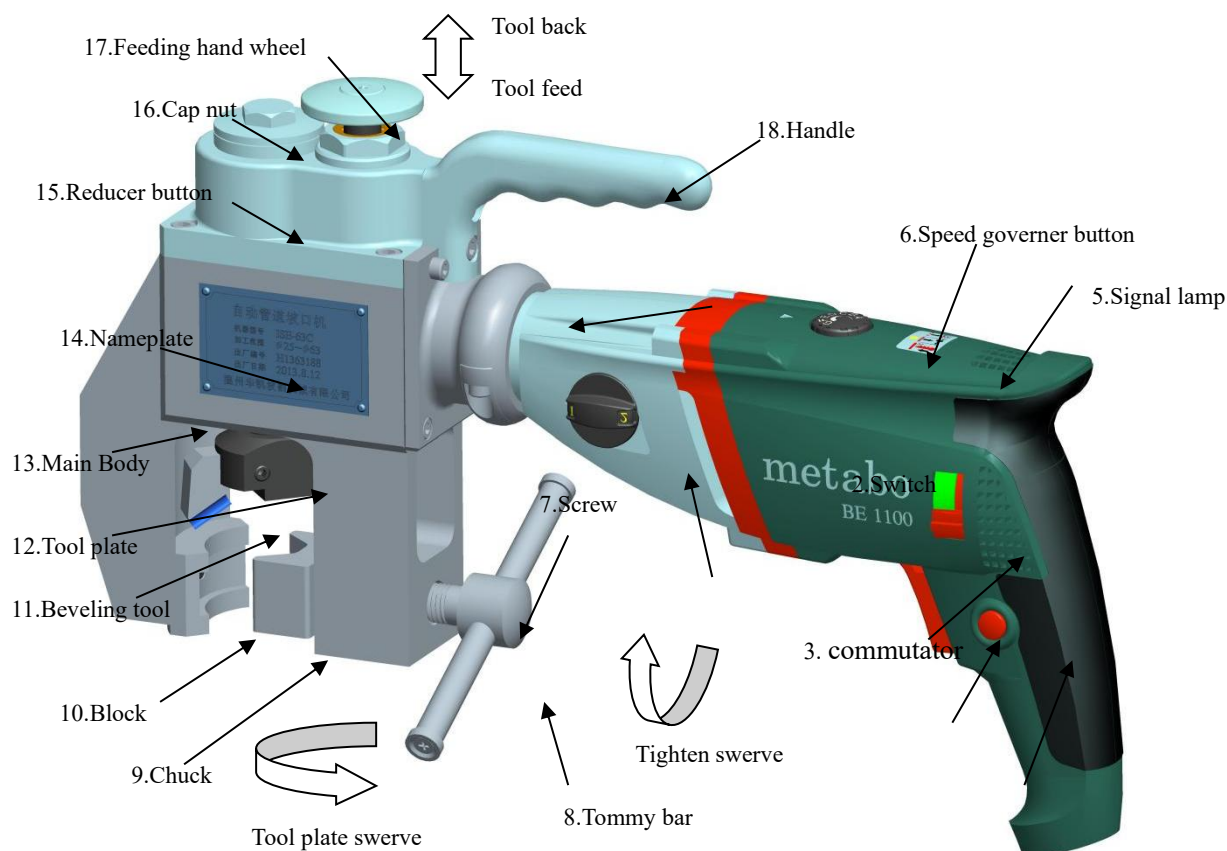
PART FOUR: BLOCK MEASUREMENT SHEET TABLE

Model	Specification of block	Remark
ISC-63	Φ28,Φ32,Φ38,Φ42,Φ45,Φ51,Φ54,Φ57,Φ60,Φ63	Customize
ISC-76	Φ42, Φ45, Φ51, Φ54, Φ57, Φ60, Φ63, Φ68, Φ76	
ISC-89	Φ63, Φ68, Φ76, Φ83, Φ89	
ISC-114	Φ76, Φ83, Φ89, Φ95, Φ102, Φ108, Φ114	

PART FIVE:OPERATION INSTRUCTION

The operator must learn the performance of machine, study the operation approach, then you can use the machine. The main parts of machine is as following:

Special note



1—Switch lock, press the switch, push down the switch lock then it will be locked, press the switch lock again to turn off the motor.

- (1) 3—commutator and 4-select button was set up before delivery, the operator don't need to adjust it again. If it's necessary, please do it when the motor is stop otherwise the motor will be damaged.

Position 1 is low speed big torque, position 2 is high speed small torque, as figure B



Figure B Select button

- (2) 5-is the signal lamp of machine, must pay attention when the machine is running. Yellow signal means brush wear out; always light means the motor work too long time, the temperature is too high, motor will protect itself for over loading, as figure C

6-Speed governor knob is available for speed, from position A~G7, speed from slow to fast, position E as in figure C, work for soft and thin wall thickness, you can choose position D,E,F.

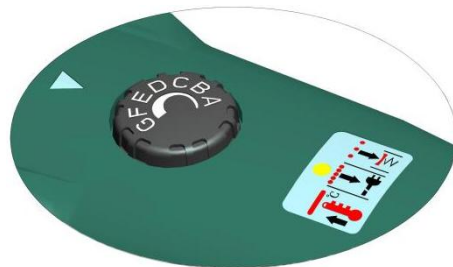


Figure C Speed governor and lamp

- (3) Keep about 2mm distance between tool bit and pipe end high point for no loading running, use power moderately for 8-handle, make sure the

clamp fasten but not too much then the pipe become out of shape.

- (4) Choose the right block depends on the pipe OD, otherwise it make too big eccentricity.
- (5) Adjust the position of beveling tool depends on the different pipe OD, make sure it is at the best beveling position. Clear the scrap iron otherwise the processing quality will become decline.
- (6) Specifical feed and back design, so the 12-tool plate works as feed slowly but back quickly, after beveling, pull 17-feeding hand wheel to back the tool. If the clutch sounds "Kaka" as knock, it means tool back completely, should turn off the power to protect the clutch.
- (7) 16-cap nut and 17-feeding hand wheel running oppositely, it means the tool is feeding.
- (8) The Man stroke of tool plate is $L_{max}=30mm$, if the axial beveling stroke is more than L_{max} , need to work multiple. The tool plate can't be longer than L_{max} avoid thread off.
- (9) Hold the handle to move the machine, it's not allowed to hold cable or feeding wheel.
- (10) Add the lubrication oil when it's necessary, take of 19- Motor coupling for it.

PART SIX: TROUBLE SHOOTING

Trouble	Possible reason	Remedy
Motor not work	The cable is not connect well ;	Check the power
	Over loading protection un remove	Remove the protection after cooling by it self
	Brush wear out	Replace the brush by professional worker
Electric motor abnormal sound	Motor gear wear too much or broken	Replace the gear by professional worker
	Motor bearing broken	Replace the bearing by professional worker

Metal cutting experts

Motor temperature high	Beveling too fast result in over loading	Turn to the low speed
	Fan broken or poor ventilation	Check the fan and air flue
Tool plate running reversed	Stir the motor commutator	Stir the commutator back
Noise in reducer	1.Bearing broken 2. Gear wear too much or broken	Check the gear and bearing then replace
Body violent vibration		
Feeding failure	Spiral clutch wear out	Check the clutch and replace
	Spring of clutch lose elasticity	Replace the spring
	Tool feed screw slide	Replace the tool plate or feeding cap nut
Stop feeding after a little feeding	Bar picker failure	Take apart the handle and fasten screw to check
Back tool too slowly or back failure	Clutch spring lose elasticity	Replace the spring
Back feed failure	Tool plate over Lmax result in screw relaxing	Take off the too, against the lower end with screwdriver, pull the feeding handle, make the motor run slowly and back tool automatic
Beveling edge rough	Tool become blunt or beveling too fast	replace tool/reduce motor speed

Tool can't be fasten	Screw or screw hole slide	Replace the screw or tool plate
Beveling edge with big eccentricity	Block is not right	Choose the right block

PART SEVEN:PACKING LIST

Item	Name	Modle	QTY
1	Automatic pipe beveling machine	ISC-76C	1 unit
2	Beveling tool	WGD-30°	2 pcs
3	Block	Φ28~63	1 set
4	Socket head wrench	S=6	1 pc
5	Operation manual		1 set
6	Warranty card		1 set
7	Cerfiticate		1 set

PART EIGHT:TESTING REPORT

Motor	<input type="checkbox"/> Qualified <input type="checkbox"/> Unqualified	Tester:
Beveling machine	<input type="checkbox"/> Qualified <input type="checkbox"/> Unqualified	Tester :
Beveling machine	<input type="checkbox"/> Qualified <input type="checkbox"/> Unqualified	Tester :
Block	<input type="checkbox"/> Qualified <input type="checkbox"/> Unqualified	Tester :
<p>Quality Dept (Stamp):</p> <p style="text-align: right;">Date:</p>		

Company		
Address		
Contactor		
Tel:		
Model:		
Series NO.		
Production date		
Quality Dept (Stamp)		Sale Dept (Stamp)

Over warranty period, spare parts charge at cost price. The following conditions are not included in guarantee:

1. Tool bits, brush and cable is not in the warranty period.
2. Operate it in wrong way.
3. User take apart by themselves or by un-professional people then damage the machine.
4. Damaged by natural cause or majeure.
5. Over warranty period.
6. Can not present this certificate