

## Pipe Leveling Machine LPM Series

### Operation Manual



- Thank you for purchasing our products!
- Please read this manual carefully and keep the machine properly for later use.

# Catalogue

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## Part I: Safe operation

Portable pipe flat port machine LPM series machine is small in size, light in weight, easy to carry and suitable for field operation. Please refer to the instructions to use the machine correctly. If it is not operated according to the instructions, it will cause accidental injury and damage to the equipment.

- 1、 Ensure that the machine is in good operation condition and follow the following safety matters.
- 2、 Please confirm that the safety manual is located next to the machine.
- 3、 In order to prevent accidents, corresponding rules and regulations shall be established on the site.
- 4、 The machine can only be used for flat port handling of the pipe.
- 5、 The damage caused by the illegal operation shall be borne by the user.
- 6、 The machine can only specify the material and size of the pipe in the level opening manual. If the required flat material is not in the manual, please consult the manufacturer.
- 7、 Check the machine every day, timely find out and find out the hidden trouble of the machine failure, timely maintenance.
- 8、 Only the workers with the corresponding qualifications can operate the machine.
- 9、 Disconnect the power supply before moving or repairing the machine.

Keep a sense of safety

- For any abnormality, please report to the person in charge of the machine.
- Please wear protective glasses, protective gloves and ear guards when working
- Do not touch the machine when it is working

Pay attention to the surrounding environment, do not use the machine in a humid environment, ensure moderate lighting, do not use the machine near flammable and explosive products.

**DANGER**

Electric shock death danger

When the motor cable is damaged, the direct contact with the electric part will lead to death.

- Ensure that the motor cable is moved away from the blade.
- Ensure that the fittings are knocked safely off by iron cutting from the flat mouth.
- Do not make the pipe fittings be cut by the flat iron and fall off in an uncontrollable way.
- Run machine.
- Please pay attention to the position of the power cord.

## Cut damage

- Do not touch the machine when cutting.
- Wear protective gloves when cutting.

## clean up

- Recycling of useful materials.
- Disposal of unwanted debris.



## matters need attention

- The knob on the motor has been set, the customer only needs to plug in the power after the delivery, press the switch. Other knobs do not need to be rerotated. Self-rotation of the knob may cause the poor effect of the flat opening.
  
- Please use the blades delivered by our factory. Buy the blade from outside the factory by yourself, and we cannot guarantee the flat mouth effect. To purchase the blades, please contact us.

## Part two: Specification and parameters description

model	unit	LPM-1.0	LPM-1.5	LPM-2.0	LPM-2.5	LPM-3.0	LPM-4.5
Cut the range	mm	3-25.4	3.175-38.1	4.76-50.8	5.08-63.5	6.35-76.2	6.35-114.3
	Inch	1/8" -1.0"	0.125" -1.5"	0.1875" -2" .0	0.2"-2.5"	0.25"-3.0"	0.25" -4.5"
Maximum cut wall thickness	mm	3	3	3	3	5	5
Charging motor power	W	850	850	850	850	-	-
Charging motor voltage	V	18.8VDCLi	18.8VDCLi	18.8VDCLi	18.8VDCLi	-	-
Plug-in motor power	W	1300	1300	1300	1300	1300	1300
Plug-in motor voltage	V	220、110VAC	220、110VAC	220、110VAC	220、110VAC	220、110VAC	220、110VAC
Blade speed	R LPM	350	400	400	400	140	140
net weight	kg	2	3	4	4.5	15	19

## Part three: Each machine style diagram

## Charging pictures

**LPM-1.0DC****LPM-1.5DC****LPM-2.0DC****LPM-2.5DC**

Plug-in pictures



**LPM-1.0AC**



**LPM-1.5AC**



**LPM-2.0AC**



**LPM-2.5AC**

## Part 4: Packaging and installation instructions



### Packing list at delivery

A portable flat machine shall include the following parts: If missing or damaged, please notify the manufacturer or carrier.

1, two blades;	2. the inner hexagon wrench
3. Use instructions	4. A set of fixtures
5. One Machine	6. Several other spare parts

The above is the standard configuration. Please contact the manufacturer for other accessories

## installation instructions

When the machine leaves the factory, it has been installed, the customer only needs to take out the machine from the packaging box, according to the specifications of the required flat pipe, install the clamp of the required flat pipe, install the battery (charging) or plug in the power (plug-in), press the motor switch can carry out the flat operation.

How to replace the clamp is described as follows:

Step 1: one of the fixtures has been installed on the machine before the machine is delivered. First explain how to remove the fixture, rotate part of the fixing screw with the inner hexagonal plate hand, rotate the handle to the handle to release the upper fixture, and then remove the fixing screw of the fixture with the inner hexagonal wrench.



specifications of the required flat pipe, and install it according to the reverse method of removing the clamp

## Part five: Operation steps

After replacing the corresponding fixture, the flat port operation can be conducted. How to operate the flat port machine is described as follows:

Step 1: Install the tool, use the inner hexagon wrench in the supporting tool, release the pressure cutter screw shown in the following figure until the pad can slide freely, adjust the marking line on the pad according to the size of the flat pipe with the size line on the cutter tray, and tighten the pressure cutter screw with the inner hexagon wrench. When changing the blade. Take down the knife pad after removing the pressure screw. Remove the screws on the blade and replace them.



松开螺丝可移动刀片的位置，按管道大小，将刀垫上的标线与刀盘上相应尺寸线对齐即可

拆掉刀垫后，再拆开刀片螺丝，可更换刀片

And keep the pipe end surface and the blade surface of 1-2MM distance. Spin the press handle as shown in the figure below and clamp the pipe



position on the scale ring, and then rotate the feed for processing.

After the tool is 2mm forward and achieve the required cutting length and port effect, the reverse rotation leaves the blade edge from the end surface of the pipe and releases the motor switch. Press the handle, loosen the pipe, and complete the flat operation.



## Part VI: Maintenance and problem solving

### Maintenance overview

Matters need attention	Effects and requirements
Start the machine before	Clean the tool blade section
Before cleaning the machine and changing the blade	Do not use the air gun to blow iron cutting, which will make the cutting fragments into the machine, affect the accuracy of the machine, affect the cutting accuracy in the future.
weekly	Clean and lubricating oil

## Trouble Shooting

problem types	Causes	Rx
The blade cannot be cut if it is too loose	The knife shaft end press knife screw is not tightened	Tighten the press screw with an inner hexagon wrench
The tube cannot be cut	Blade inverse	When loading the knife, the blade faces the press knife screw
The pipe cannot be clamped	The clamp handle is not tightened.	Tighten the grip handle
	Mistakes selected.	According to the pipe size, select the corresponding fixture

## Part 7: Certificate of conformity

# certificate

## certificate

Product name: Pipe Leveling Machine

specifications and models \_\_\_\_\_

Perform the standard Q / YD 0-1-12

manufacturing No \_\_\_\_\_

This product is allowed to leave the  
factory after passing the inspection

examination clerk \_\_\_\_\_

examination date \_\_\_\_\_

Dear customers:

If you have any comments, suggestions and problems in the process, please feel free to contact our technical department for consultation, we sincerely serve you, thank you for your cooperation!

### Part 8: Purchase information

1. Order replacement parts: please indicate the name of the parts, the part number and other relevant information according to the part list provided in the manual, so as to meet your requirements quickly and accurately.
2. Maintenance information: Please call the manufacturer before sending any parts to be repaired. We will negotiate matters related to transportation and handover maintenance. The company will estimate the specific time and related costs of the maintenance needs. Please attach your specific contact information, fault description and services provided by our company.

**To order KEDES products or more information, please call**

**Sales:**

TEL/Whatsapp:+86 19166278852

Web: [www.kedesmachine.com](http://www.kedesmachine.com)

E-mail: [contact@kedesmachine.com](mailto:contact@kedesmachine.com)

I wish you all the best in your work!