



Beveling Machines* Metal Cutting Specialists

Thank you for purchasing our products!

Please read this manual carefully before use and keep it in a safe place for future reference.

SHENZHEN KEDES MACHERY & EQUIPMENT CO.,LTD.

Address: Building B, Zhongshun Industrial Park

No. 434 Fuqian Road, Fucheng Street, Longhua District

Shenzhen, China

Operate Manual

·Read the instruction thoroughly before proceeding and keep it well for future referring.

Plate Beveling Machine



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Part1 : Equipment Introduction

A quick and easy edge beveling solution designed for edge preparation of plate.

The SKF-15 beveling machine can provide stable output power. The advantage of machine is light in weight (compare with similar product), safety in use, little vibration, easy operation and high efficiency in beveling process. The machine is suitable for metal plate beveling and deburring process before welding. It can process the plate which made from steel, cast iron, hard plastic, non-ferrous metals.

Feature:

- 1.The beveling surface of plate is smooth and flat, and oxidation layer in its surface, and easy for welding
- 2.Meet the pre-welding requirement for K, V, X, Y-type welded joint
- 3.Suitable to use on the steel plate, cast iron and hard plastics, and it also can be used on the chrome steel and other high-strength materials.

Technical Data:

Electric Motor: 220V/380V, 50/60HZ, single-phase electric power

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Power: 1.1KW

Rotation Speed: 2870 r/min

Bevel Angle : 30 -60 degree

Bevel width : 1-15mm (Q235)

Part 2: Safety Instructions

The Company strictly follows the principle of safety first and warns operator to comply with the following safety regulations when using this equipment:

1. Read the operating manual before installation, be sure to carefully read the installation and operation procedures. It can save valuable time and avoid personal injury and machine damage.
2. Check the machine and spare parts before installation.
3. Only allow trained personnel to the operation of the machine.
4. Must comply with the safety rules which developed by professional organizations and enterprises to avoid accidents.
5. Use the specified voltage.
6. Operate the machine under the dry and safety condition.
7. Operate the machine follow the direction of arrow on the machine.
8. Do not use cooling or lubricating fluid.
9. Wear protective glasses when operation.
10. Protect the power wire when operation.

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11. Cut off the power and pull out the power plug before adjust the cutting and beveling edge and angle.
12. Check the screw is tight before operation.
13. It must be carried out several times when the cutting and beveling width more than 15mm.
14. Do not allow to change the cutter before cutting off the power.

Part 3: Accessories List

Serial Number	Name	Quantity	Comment
0	Machine Cover	1	
1	Side Plate	1	
2	Side Plate	1	
3	Cover plate	1	
4	Support Column	1	
5	Support Column	1	
6	Cutter Spindle	1	
7	Motor Fixed Plate	1	
8	Bolt	1	
9	Left Turning Plate	1	
9A	Right Turning Plate	1	
10	Cutter Plate	1	
10A	Longer Cutter Plate	1	
11	Cutter Plate	1	
12	Bolt	1	
13	Bolt	2	
14	Washer	8	
15	Clip	4	
16	Pin	2	
17	Tooth Clamping	2	
18	Slot type Nuts	1	
19	Bolt	8	
20	Locking Block	2	
21	Spindle Motor	1	

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22	Motor Switch	1	
23	Connector	1	
24	Extension Cord	1	
27	Handle	1	
29	Nut M8		
30	Hex Bolt		
32	Pin		
33	Bolt		
34	Washer		
35	Headless Screw		
36	Cutter Blade		
37	Cir-clip		
38	Bolt		
39	Bolt		
40	Facing Cutter		
40A	Facing Cutter		

Part 4: Installation and Operation Procedures

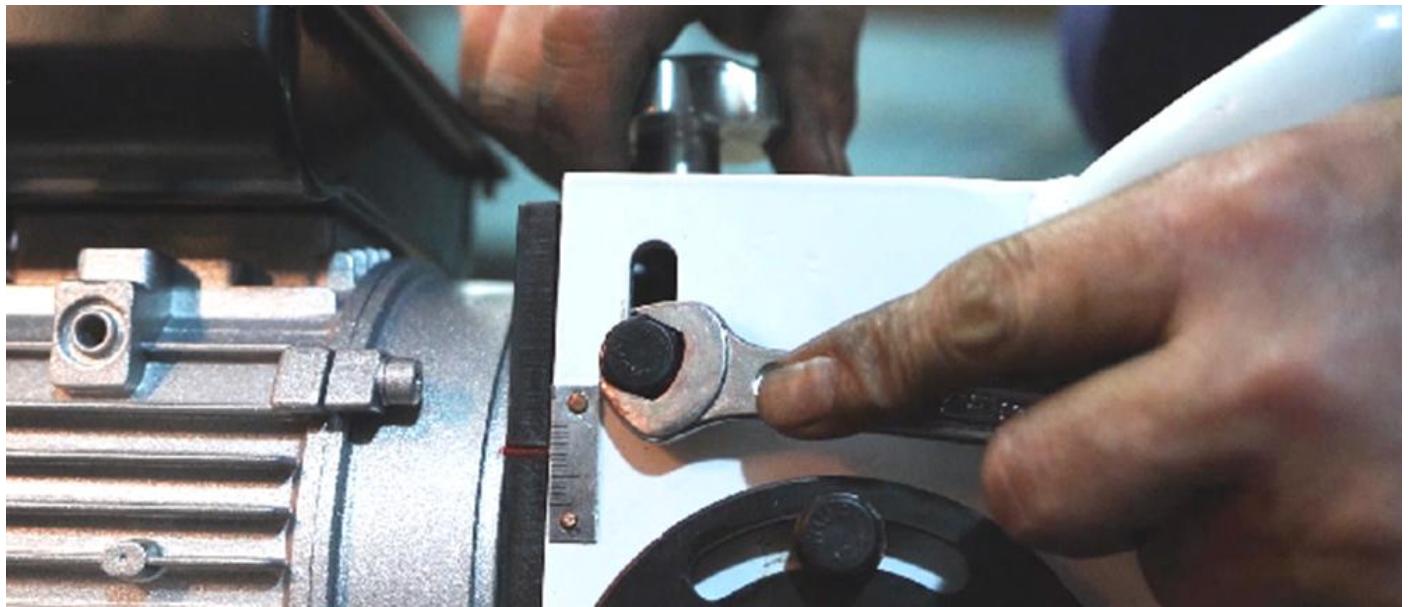
Milling Width Adjustment

The milling width of machine is adjusted to 2mm when leaving the factory. When the milling width need to be adjusted, release the fasten screw(13) first under the handle, then turn the handle(12), lift body case, the adjustment range is from 0mm to 15mm.

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We recommend that do not adjust the milling width more than 15mm, in order to protect the machine and tools, each adjustment is 5mm.

Scale I I I I corresponds to 0,5,10,15 mm, (under the milling width is completed in the case of 45°, the screw must be tighten)

Milling angle Adjustment

The milling angle of machine is adjusted to 45°when leaving the factory.

Loose and take off 4 fasten bolt (3) from left and right side of body case when adjustment.

The adjust angle is from 30°~60°, and the mark on the body case must align to white line on the cutter plate.

After milling angle adjustment, the bolt must be tighten.

The milling angle adjustment may affect the milling width.

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Operation

Before starting the machine and do milling process, please note that use different operation mode in different place.

If you want to mill the plate from the edge of it, place the milling machine on the surface of plate. And the cutter blade do not touch the workpiece (the 1/3 of cutter plate touch the workpiece).

Start the machine, move the machine forward follow the direction of arrow on the machine.

Replacement of cutter head

1. first unplug the power, release the two hexagonal screws, remove the cover.
2. remove the clip from slot type nut, and use 30mm wrench to remove slot type nut, remove the tooth clamping, remove the milling cutter blade, pay

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attention to the location of clip, place the cutter head on the plate.

3. loosen the screws on the clamping plate, remove the old milling cutter blade (turn the blade to 90 °), take off the milling cutter blade, place the milling cutter head on the plane, put the new cutter blade into the groove of cutter head.



4. tightening hexagonal screws, do the same treatment for the second cutter head.
5. the installation of milling cutter in the reverse order
6. pay attention to the location of the clip ring, check the cutter head is safe and do not loose. Unplug the power before inspection.
7. Pay attention to tool wear and change tools in time.
8. When beveling, you can add cutting fluid (coolant) to reduce tool wear and make the slope smoother.

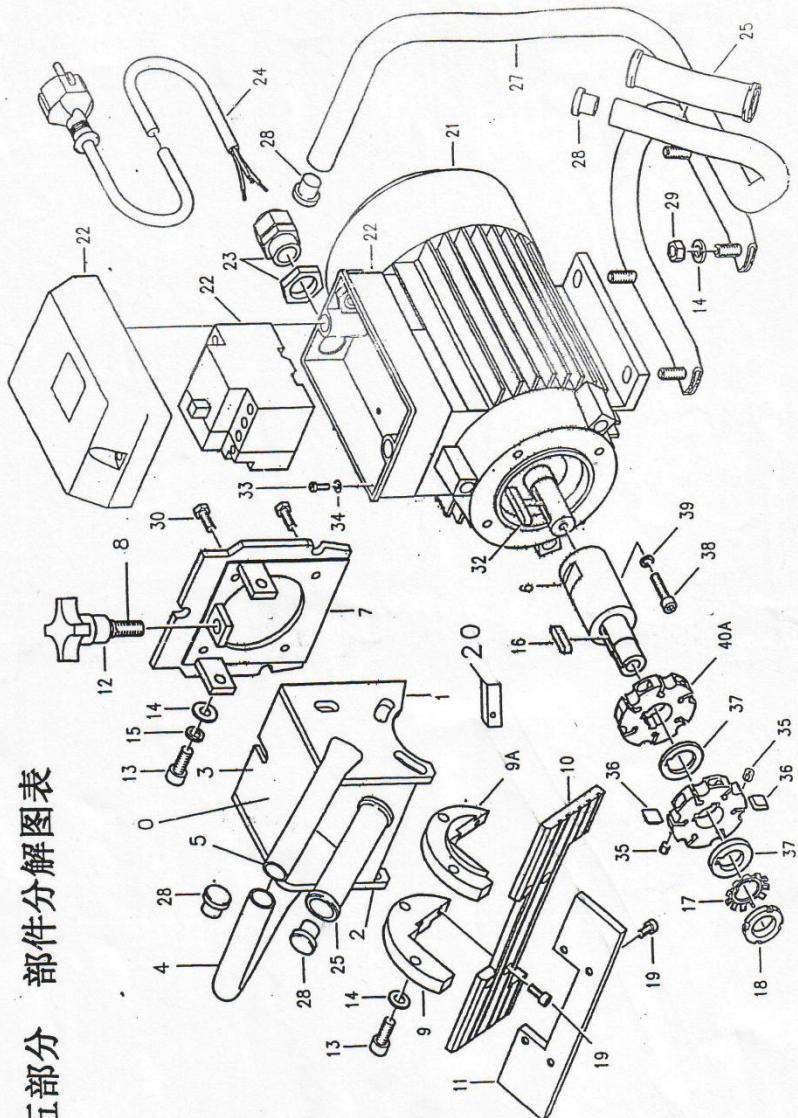
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Part 5 Exploded Views And Parts List

第五部分 部件分解图表



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