

Operation manual for DMM-1232 beveling machine





Attention!

Please be sure to read these instructions in detail before you do anything with the machine!

Preface

We are pleased to know that you have decided to use our DMM-1232 Upper and Lower Edge Simultaneous Processing Plate Bevelling Machine, and we are confident that this machine will yield great economic benefits in your company. We would be pleased to provide you with information on the safe use of this machine. We would like to help you to improve your working capacity and to keep the machine in a safe and stable condition with high efficiency. At the same time, we care about the safety of you and your colleagues. The machine can be a very safe tool to make money, but if you do not pay attention, it can also become very dangerous, so before using the machine, please be sure to read this instruction manual. Comply with the safety regulations contained therein to ensure the safety of both the person and the machine. We know that there is no limit to safety, and that the information provided in the manual may only be the basic requirements and may not cover all operating methods and applications. So please use your experience, common sense and good judgement to remind yourself and train your employees. Safety must be the highest priority in all operations. The design, manufacture and manuals of this machine are the result of the skill and wisdom of all our staff, and we are committed to providing safe and excellent machines for the user's use. However, due to certain factors that can not be completely mastered by the Company, I am afraid that it is inevitable that there will be a machine failure or injuries occur, in order to restore your normal operation as soon as possible to enhance the technical level of the Company we sincerely welcome you to record the situation at that time, immediately notify the Company or the nearest agent.

Thank you very much for purchasing our DMM-1232D series, please read this manual carefully and in detail before using this machine. This manual is useful for DMM-1232D
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model, DMM-1232D series automatic travelling plate bevelling machine, this series of products is a widely used in shipping, metallurgy, steel structure and other welding manufacturing industry welding and cutting auxiliary equipment, and other bevelling means compared with high efficiency, energy saving, environmental protection, easy to operate, easy to use and so on a number of advantages; especially suitable for difficult to process stainless steel, and high strength steel materials, and can greatly reduce the labour workload of workers. High-strength steel materials, and can greatly reduce the workload of workers, saving labour costs; at the same time in line with the current low-carbon, low-energy environmental protection trend and concept!

Thank you!

Contents

1. 概述	5
1.1 Machine Overview	
1.2 safety rule	
1.3 Safety rules for use of this equipment	
1.4 Safety rules for the use of electrical appliances	
2. Introduction of this machine	9
2.1 Machine parameters	
2.2 Principle of steel plate cutting	
2.2 The main purpose of this equipment.and processing range	
2.2 Machine illustration and external dimensions	
3. Safety and Warning	5
3.1 safety instructions	
3.2 Safety precautions	
3.3 Precautions for the use of electrical appliances	
4. Equipment acceptance	8

4.1 Test	
4.2 Unpacking and handling	
4.3 Tool accessories	
5. Installation and Adjustment.....	12
5.1 Electrical installation and equipment electrical capacity	
5.2 Electrical schematic	
5.3 Adjustment of spindle direction	
5.4 Belt tensioning and adjustment	
5.5 Plate thickness adjustment and bevel depth setting	
5.6 Installation and removal of blades	
6. Daily operations.....	16
6.1 Pre-operation inspection	
6.2 Safety matters for starting bevelling	
6.3 Notes on operation	
6.4 Notes when stopping	
6.5 Precautions for long-term storage and transport of equipment	
6. Bevel preparation.....	20
6.1 Commissioning (checking data)	
6.1 Plate placement and travelling trolley routes	
6.2 Steel plate cleaning	
6.5 Height and angle adjustment of the travelling trolley	
7. Basic operation.....	21
7.1 Usage method	
7.2 Process parameters	
8. Blade selection(suggestions).....	
8.1 Selection of circular blade discs	
8.2 Optional 45 degree blade cutter	

9. Care and routine maintenance of equipment.....	
9.1 Lubrication oil filling	
9.2 Maintenance and care of electrical appliances	
9.3 Failure causes and countermeasures	
10. Lubricity	23
11. Methods of resharpeneing and reuse of hobbing knives and precautions.....	28
12. List of random accessories.....	29
13. Wear parts parts illustration and preparation list.....	30
14. Record of Periodic Autonomous Inspection of Equipment (Schedule).....	

Machine Overview

Brief description of the machine

This machine is a series of automatic travelling steel plate bevelling machine, specially for metal cutting, if you want to use other materials of workpiece, please discuss with our company.

The DMM-1232D series is preset to work on metal materials such as iron, cast iron, aluminium, stainless steel and alloy steel, but excludes magnesium-containing materials.

Welcome to use the company's DMM-1232 series of automatic travelling flat plate upper and lower edge bevelling machine at the same time, this series of products is a widely used in the ship,

metallurgy, steel structure and other welding manufacturing industry welding and cutting auxiliary equipment, and other means of bevelling compared with high efficiency, energy saving, environmental protection, simple operation, easy to use and many other advantages; and can greatly reduce the workload of the workers, savingIt can also greatly reduce the workload of workers and save labour cost; meanwhile, it meets the current environmental protection trend and concept of low carbon and low energy consumption.

DMM-D type bevelling machine with a speed of 0.2-1.5 metres per minute, can be in the thickness of 80 mm or less, the material tensile strength of 60 kg / mm² or less of the steel plate on a once automatically processed slope width of less than 16 mm welding bevel, according to the actual needs of a number of times can be processed to the slope of 50 mm width.The bevel angle can be adjusted arbitrarily within the range of 0° to 60° (right headstock) and 0° to -45° (left headstock).

safety rule:

- 1. Machinery should be operated by trained personnel.**
- 2. Machinery shall be used in a manner that does not contravene the provisions of the operating instructions.**

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3. The factory floor should be kept clean to ensure that its operations can be carried out smoothly.
4. Work shoes should be worn in the factory to keep the operator's feet safe.
5. The operator should wear protective eyewear as well as gloves when working with this equipment.
6. Do not touch the machine with your hands in the area where it rotates.
7. Do not open electrical boxes, junction boxes or other protective covers without permission.
8. Don't use a cloth. Spanners or similar to touch parts that move.
9. Do not operate or service the machine while under the influence of alcohol or in poor health.

Safety rules for use of this equipment:

Any metal cutting equipment will always have high horsepower, sharp cutting tools, high voltage, rotating parts, they are all necessary or they can't fulfil your cutting requirements ----- but they all have potential crises!

During metal cutting, there will always be splashes of chips, high temperature chips and workpieces, sharp edges and burrs, etc. They will always be formed, otherwise it will not be possible to fulfil your task ----- But they are also all potential crises, and this machine is no exception.

In order to be able to use the machine safely, all operators and maintenance personnel who may be exposed to these potential crises should be vigilant and follow the safety instructions.

Anyone involved in the use of this machine must be properly trained and have the necessary knowledge and skills. If assistance is required, please contact our company or an agent or service centre.

Observing the following safety instructions will reduce the

chance of injury.

1. When starting the machine, please make sure that the direction of rotation of the spindle is correct.
2. Do not disassemble any protective devices (e.g. guards, emergency stop buttons, grounding wires, etc.) and notify us immediately if they are not functioning properly.
3. Please perform safety inspection and maintenance according to the operation manual.
4. Please know how to stop the machine before starting it.
5. Before starting the machine, please know what kind of action will happen when this button is pressed.
6. Never touch the tool before the spindle stops, (or change the blade)
7. Never open the guard plate before the spindle stops.
8. Iron chips on the cutter shall not be removed directly by hand. A brush should be used
9. Never use blunted blades.
10. The machine must not be rotated when the safety guard is removed.
11. Do not bring your body close to the operating panel of the machine, to prevent unintentional touching.
12. It is prohibited for two persons (including more than two persons) to operate the control panel and other buttons.

Safety rules for the use of electrical appliances

This machine uses 380V AC to directly connect to the quick socket of the electric cabinet, and it is strictly prohibited to plug in the socket with electricity.

Note: Touching the 380V voltage is enough to be fatal!

1. All electrical and electronic repairs or adjustments must be carried out by

trained electrical professionals.

2. Disconnect the power switch before removing or replacing electrical appliances.

3. Tools should be insulated.

4. Do not use more than the specified fuse, not to mention the metal wire to bypass it.

5. It is forbidden to place other objects inside the electrical box or on the operation panel.

6. Before switching on the electricity, it must be confirmed that no other person is engaged in operation on the machine.

Do not touch the switches or electrical components with wet hands.

2. Introduction of this machine

2.1 DMM-1232 equipment parameters

Motor power	3 kW 2
Motor voltage	380 volts
Motor speed	960 rpm
Bevel travelling speed	0.5-1.2 metres/minute
Volume of bevels processed in a single pass	15
mm bevel width	
Maximum bevel width (W) (multiple processing)	50 mm
Bevel angle	0° -60° 0° - -45° arbitrary adjustment
Thickness of bevelled steel plate	10-60mm
Narrowest width of steel plate	100 mm
Net weight of the machine	420kg

2.2 Principle of steel plate cutting

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The cutting principle of this equipment is a double motor through the multi-chisel connection, so that the spindle rotates, the spindle is equipped with a knife disc and knife feeding mechanism, you can easily adjust the size of the cutting bevel, the lower part of the equipment is equipped with a travelling mechanism, the travelling motor through the speed reducer, so that the two rubber wheels of the lower bracket rotate, which allows the equipment to walk so that it is easy to carry out the breaching and cutting, the equipment's height is adjusted through the lower bracket of the two gas springs equipped with floating support, it will automatically adjust with the height of the material. The height adjustment of the machine is made by the two gas springs of the lower bracket for floating support, and it will be adjusted automatically according to the unevenness of the material. According to the different materials can be replaced with different discs and blades to facilitate the cutting of different materials.

Pictures of cut chips



Pictures of cut steel plates



The main purpose of this equipment.and processing range

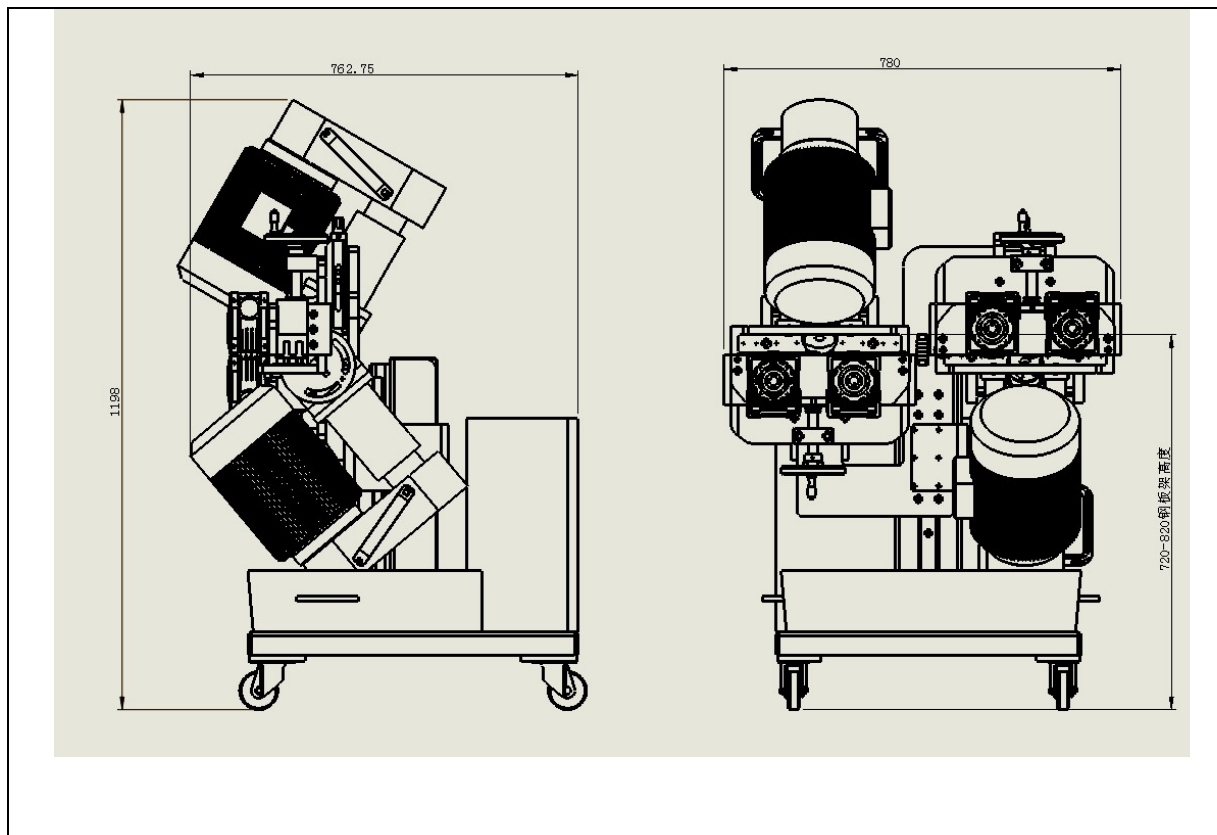
This series of products is a widely used in shipbuilding, metallurgy, steel structure and other welding manufacturing industry, welding and cutting auxiliary equipment, and other beveling means compared with high efficiency, energy saving, environmental protection, easy to operate, easy to use and many other advantages; and can greatly reduce the workload of the workers to save labour costs; at the same time, in line with the current trend of low-carbon, low-energy environmental trends

DMM-1232D type bevelling machine with a speed of 0.2-1.2 metres per minute, can be in the thickness of 80 mm or less, the material tensile strength of 60 kg / mm² or less of the steel plate at a time automatically travelling processing out the slope width of 12 (20)

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mm of the welding bevel, according to the actual needs of the number of times you can be processed to the slope of 50 mm width. And can be $0^{\circ} \sim 60^{\circ}$ $0-45^{\circ}$ range of arbitrary adjustment of the bevel angle

2.4 Machine illustration and external dimensions



3. Safety and Warning

3.1 safety instructions

Before installing, using and servicing this bevelling machine, you must take sufficient time to carefully read all operating instructions in this manual, electrical and rotating parts have the potential to cause serious injury to life or damage to property.

This machine operates on 380 volts, use this manual as a guide to identify the parts of the beveller before installing, wiring, starting, operating or making any adjustments. Electrical Address: Building B, Zhongshun Industrial Park, No. 434 Jiaqian Road, Fucheng Street, Longhua District, Shenzhen, China Web: www.kedesmachine.com Email: contact@kedesmachine.com Tel/Whatsapp/Wechat: 86 19166278852

wiring installers and maintenance personnel must be qualified by code to ensure that life and property are protected from injury damage.

3.2 Safety precautions

1. This machine should only be used for the work for which it was designed;
2. The person who installs and wires the machine must be certified as an electrician; the power supply wiring must be well protected by grounding;
3. Beveling of materials and materials that do not comply with machine recommendations and operating manuals is not permitted, and over-range beveling can damage or reduce the service life of equipment and tools;
4. The operator is not allowed to leave the site while the machine is working;
5. When the machine is out of service, the power connection must be cut off.
6. Replacement of tools, maintenance, cleaning, the machine must cut off the power supply;
7. At the same time, the use of special tools, protective gloves and other cleaning chips, so as to avoid high temperatures, sharp cutting and other injuries to the body; but never allowed to clean up when the machine is running.
8. When the machine is running, the operator must stand at the back of the machine, not at the left and right sides of the machine. Cutting tool rotating work process may strangle the operator's clothes, gloves, etc., resulting in serious personal injury.

3.3 Precautions for the use of electrical appliances

This machine uses 380V AC directly into the electrical cabinet on the quick socket, it is strictly prohibited to plug into the socket with electricity, the

Note: Contact with 380V is fatal!

1. All electrical and electronic repairs or adjustments must be carried out by trained electrical professionals.
2. Disconnect the power switch before removing or replacing electrical appliances.
3. The tools used should be insulated.

4. Do not use more than the specified fuse, not to mention the metal wire to bypass it.

5. It is prohibited to place other items in the electrical box or on the operating panel.

6. Before switching on the electricity, you must make sure that there is no other person engaged in the operation of the machine, and do not touch the switch or electrical components with wet hands.

4. Equipment acceptance

4.1. Test

When you take delivery of your bevelling machine, it is particularly important that you inspect it carefully for any signs of damage caused by improper handling by the carrier: if any damage is found, obtain the delivery person's signature, which will facilitate your future insurance claims.

Important notes

Liability for lost or damaged material

Goods should be opened as soon as the arrival of the inspection, because the user signed the bill of lading, our responsibility for the batch of goods will end, if the receipt of obvious shortages or damage, there are views on the important things you must do, is to immediately notify the carrier and insist that he states in the waybill that there is a shortage of or damage to the transport company will not be able to make a claim.

If a more hidden shortage or damage is discovered, notify the carrier immediately and request an inspection; it is absolutely essential to do so or the carrier will ignore your claim. The carrier should make an inspection and issue a certificate of hidden damage; if you issue a clean receipt for goods that have been shortened or damaged en route, you will have to take the risk and pay for it.

Our company is willing to do its best to help you get compensation for shortages or damaged materials. However, our assistance does not mean that we are responsible for representing you in your claim, and the actual filling out of forms and claim procedures need to be handled by you, the customer.

4.2 Unpacking and handling

This machine is normally transported in a wooden crate, and indicates the location of lifting and forklift loading and unloading, the positioning of the forklift and lifting position is very important, because the centre of weight of the machine is more upward, incorrect lifting and forklift may cause overturning, and may cause injury to personnel and damage to the goods.

4.3 Tool accessories

9. List of random accessories

No.	Name	Quantity	No.	Name	Quantity
1	Cutting discs (one of them on the spindle)	1 handle	7	Oil gun	1 piece
2	Accessory tool kit	1pc	9	Blade	6 pieces
4	Operation manual	1 set	10	Product Warranty	1 piece
5	Aviation plug	1 book	11	19 Open End Wrench	1
6	Certificate of conformity	1payment	12	T15 spanner	1
7	Hexagonal spanner set	1 set			

5. Installation and Adjustment

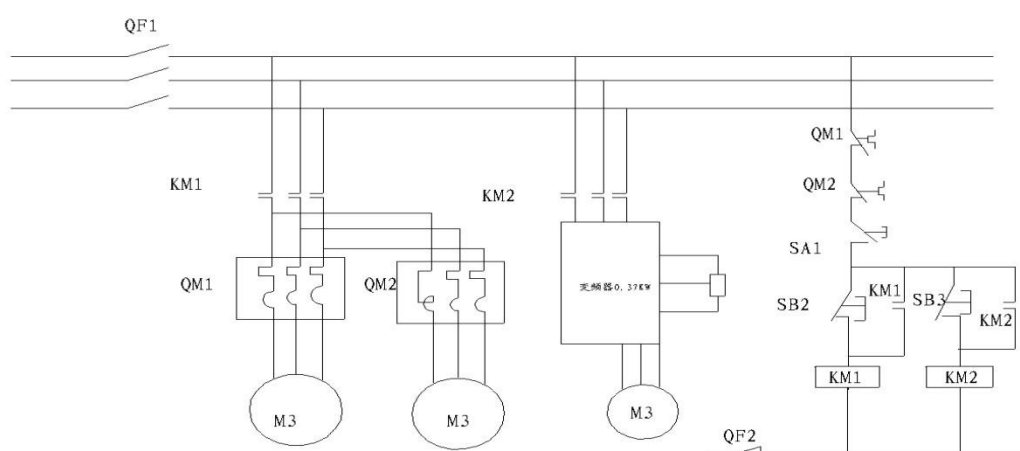
5.1 Electrical installation and equipment electrical capacity

When the whole machine reaches the user, there is an aviation plug on the right side of the electric box, please follow the following diagram to make electrical connections by a professional electrician to protect the safety of people and equipment. The connecting cable of this equipment should use a four-core cable larger than 2.5 square millimetres. It should be connected under AC380V 50HZ electric power electricity. The power supply should be less than 10% of the float below the normal work.

Electrical capacity of equipment

Equipment model	Total capacity	Insurance rating
DMM-1232	7.5KW	22A

5.2 Electrical schematic



5.3 Adjustment of spindle direction

Note: The correct direction of rotation of the spindle is sufficient for the safe operation of the machine, otherwise damage to the machine and the blades as well as injury to personnel can occur.

Please strictly follow the instructions on the nameplate to determine the direction of rotation of the spindle, check the direction of rotation of the tool:

check the direction of rotation after wiring and switching on the machine,

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the red mark on the front side indicates the correct direction of rotation during operation, If the direction of rotation is incorrect, it is necessary to turn the forward and reverse knobs set on the left hand side of the unit."

Safety instructions

1. Before starting the machine, please note that all safety covers are fitted and the safety devices work.
2. Avoid wearing clothing that could be caught by moving parts
3. Wear approved protective clothing such as shoes with non-slip soles, ear muffs and goggles.
4. Use safety standards, take care to observe them at all times and if in doubt, refer to this manual again before taking any action.
5. If the machine does not resolve the defect that caused the malfunction, contact the machine supplier.
6. If the defect in the machine involves defective parts or abnormal operation.

The machine is equipped with safety covers to isolate the area from potential dangers of saturation. These covers are screwed to the machine frame. They can fit a spanner. This operation may be necessary for some maintenance activities.

1. Electrical connections and protection should be made in accordance with local regulations;
2. The machine adopts 380 volts voltage, please make sure that it is compatible with your power supply.
3. Connect the electrical switch box of the machine to your main power supply with a

cable, the specification of the power cable is more than 2.5mm² three-phase cable.

4. Set the function of the switch box:

- Machine start switch and emergency stop button
- Pressure loss protection
- Overload protection

5. Check the direction of rotation of the tool: check the direction of rotation after wiring and switching on the machine, the red mark on the front side indicates the correct direction of rotation at work, if the direction of rotation is incorrect, it is necessary to rotate the forward and reverse knob set on the left hand side of the machine. "0" for the machine to stop, "1" and "2" for positive and negative respectively (positive or negative depending on the wiring phase sequence connection).

6. The unit of regulating speed of this equipment is frequency conversion speed regulation, in unclear parameters of this frequency converter shall not be adjusted when any of its parameters, (general equipment in the factory has been adjusted to the parameters, the user does not need to adjust)

7. The protection of the motor is a separate magnetic thermal protection, when its action indicates that the motor has been overloaded, at this time there is no need to rush to turn it on, it should wait more than 30 minutes to turn on its switch, it can work.

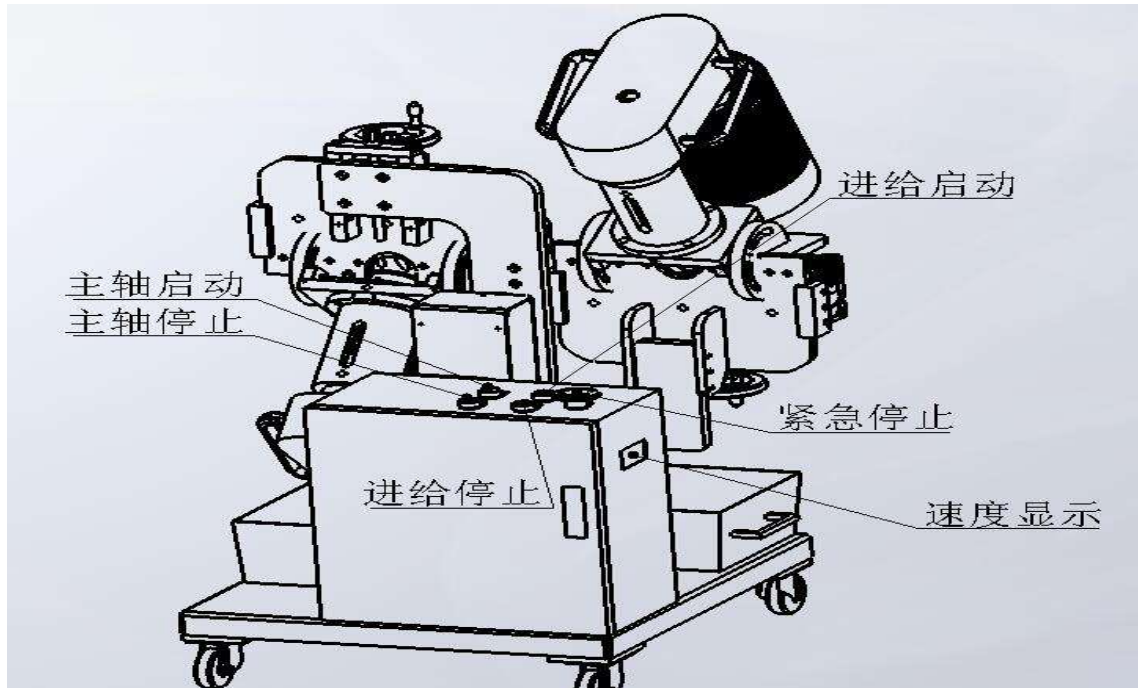
The machine is equipped with a mushroom-shaped red first aid button that stops inhibiting all other operations (position B, as in Figure 2.4.1).

Using the emergency button:

-In the event of an imminent danger or mechanical accident;

For short maintenance periods, when the machine has been stopped, to maintain the machine in this state. Please press the emergency stop button.

As in Fig. 2.4.1

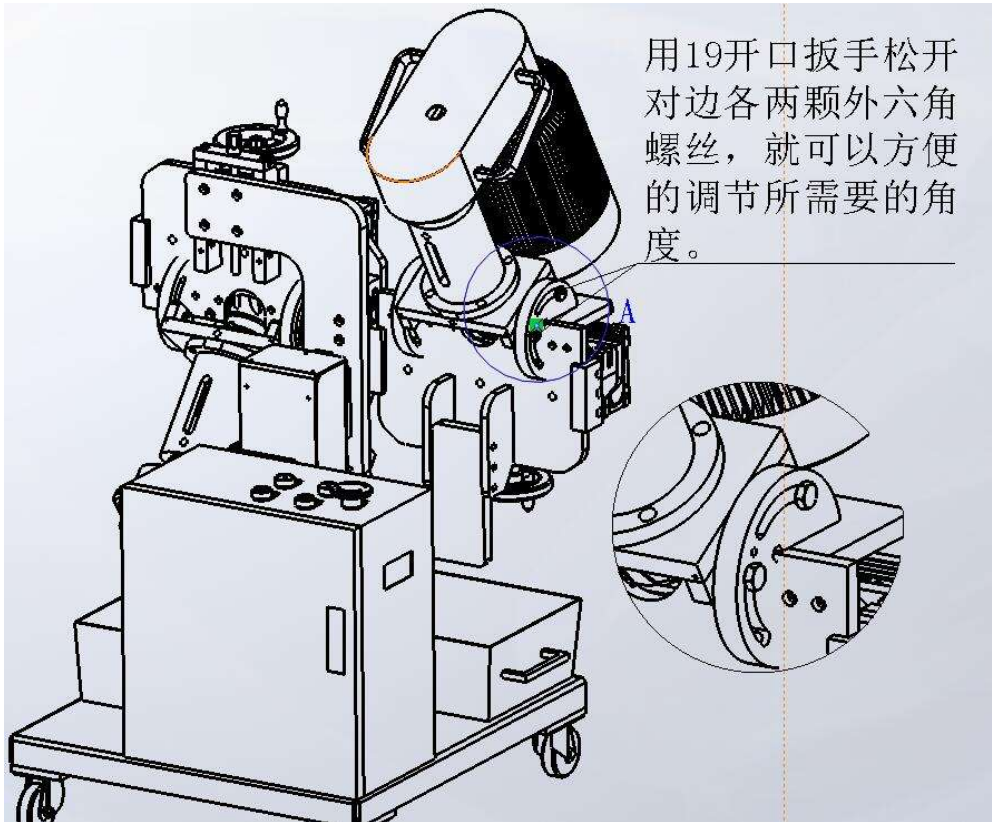


5.4 Angle adjustment

This equipment can easily adjust the cutting angle according to the requirements of the welding process (Note: Angle adjustment is strictly prohibited during the operation of the equipment) The angle of adjustment ranges from 0-60 degrees 0-60 degrees stepless.

1. Loosen the locking screws on both sides of the spindle.
2. According to the angle indication on the nameplate, rotate the adjusting handwheel to achieve the required angle.
3. Lock the locking screws on both sides of the spindle (Note: This step is very important, the screws are loose enough to injure the life and damage the equipment,)

The following is the picture of adjusting angle

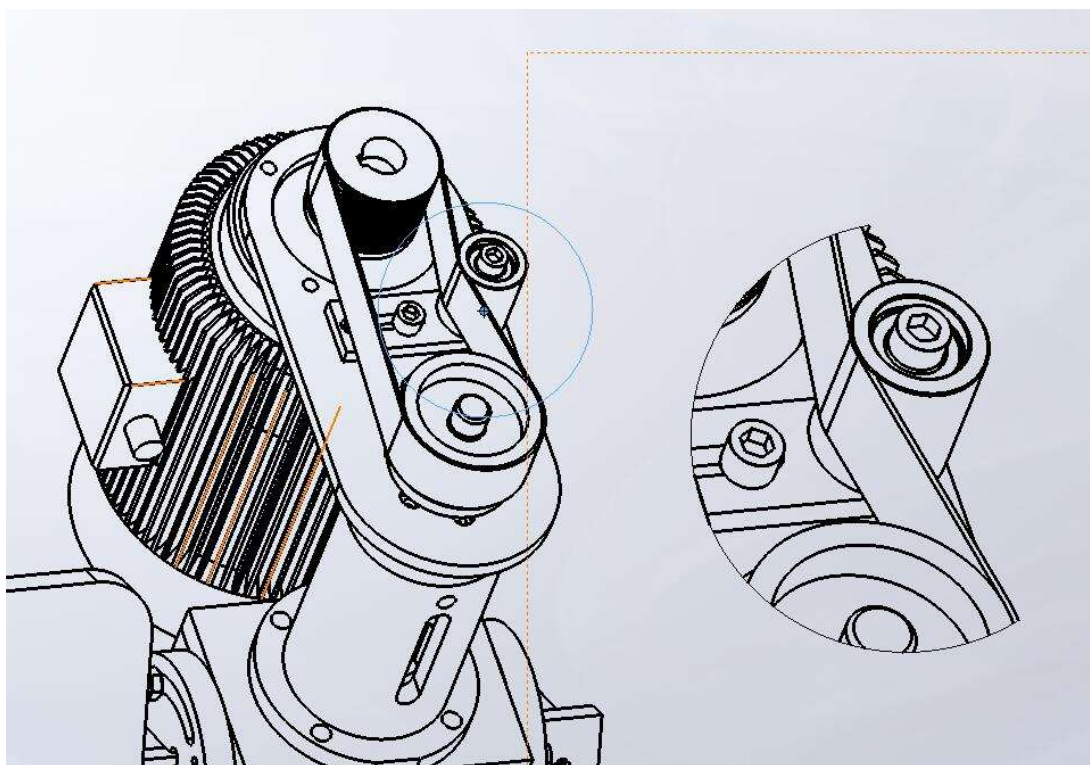


5.5 Belt tension and adjustment

This equipment spindle in the power of the motor connection for the PK10L980 multi-chisel belt connection, when the use of the process found that the power is not enough, most of the reasons for the use of the belt in the process of wear and natural elongation. When found this situation, need to adjust the belt tightening pulley.

With a hexagonal spanner to loosen the shield of the belt wheel, loosen the tightening wheel adjustment screw, push the tightening wheel inward, and then lock the tightening

wheel screws, (the degree of tension of the belt wheel to push the hand (400N or so) between the two motors belt, there is a distance of 10MM between the good)



5.6 Adjustment of steel plate thickness and bevelling depth

Plate thickness adjustment

This equipment can be adjusted at will within the range of 5-50MM thickness of steel plate, adjust the compression hand wheel counterclockwise rotation for the loosening of the material, clockwise rotation for the compression of the material, when cutting the material must be pressed tightly when the material, **otherwise it will injure the personnel, and damage to the equipment.**

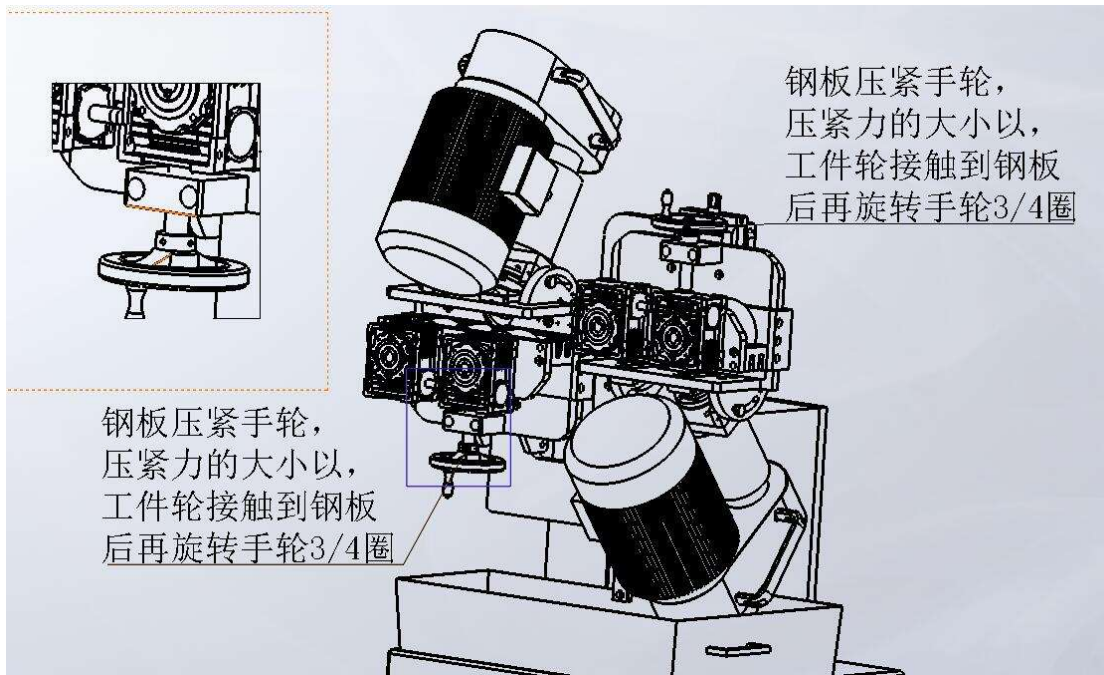
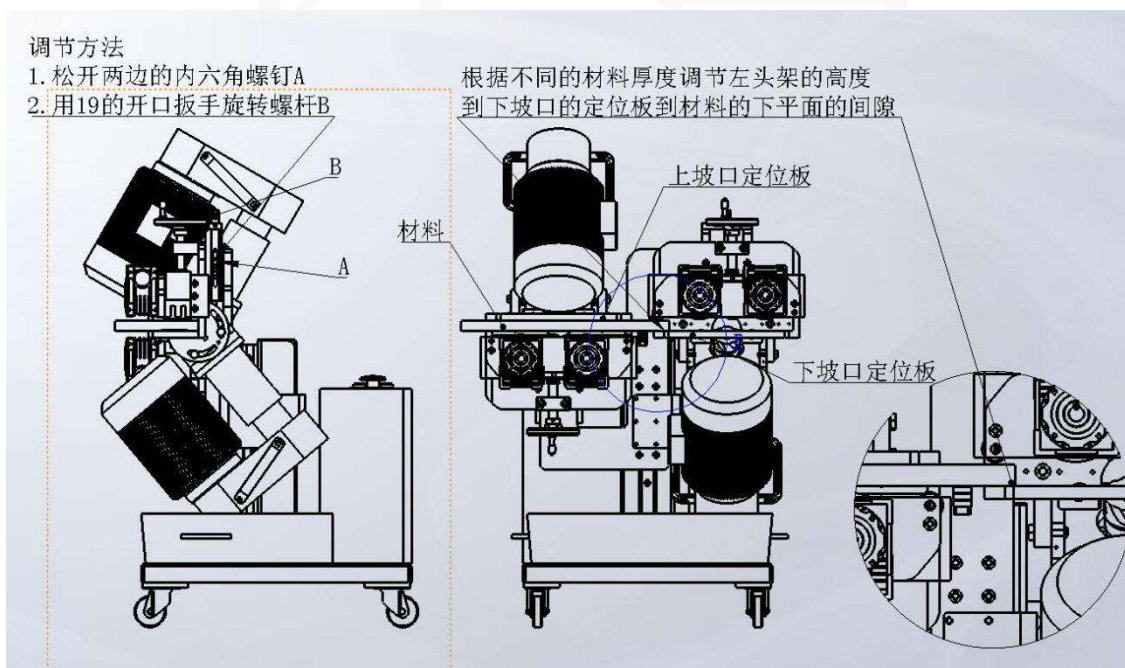
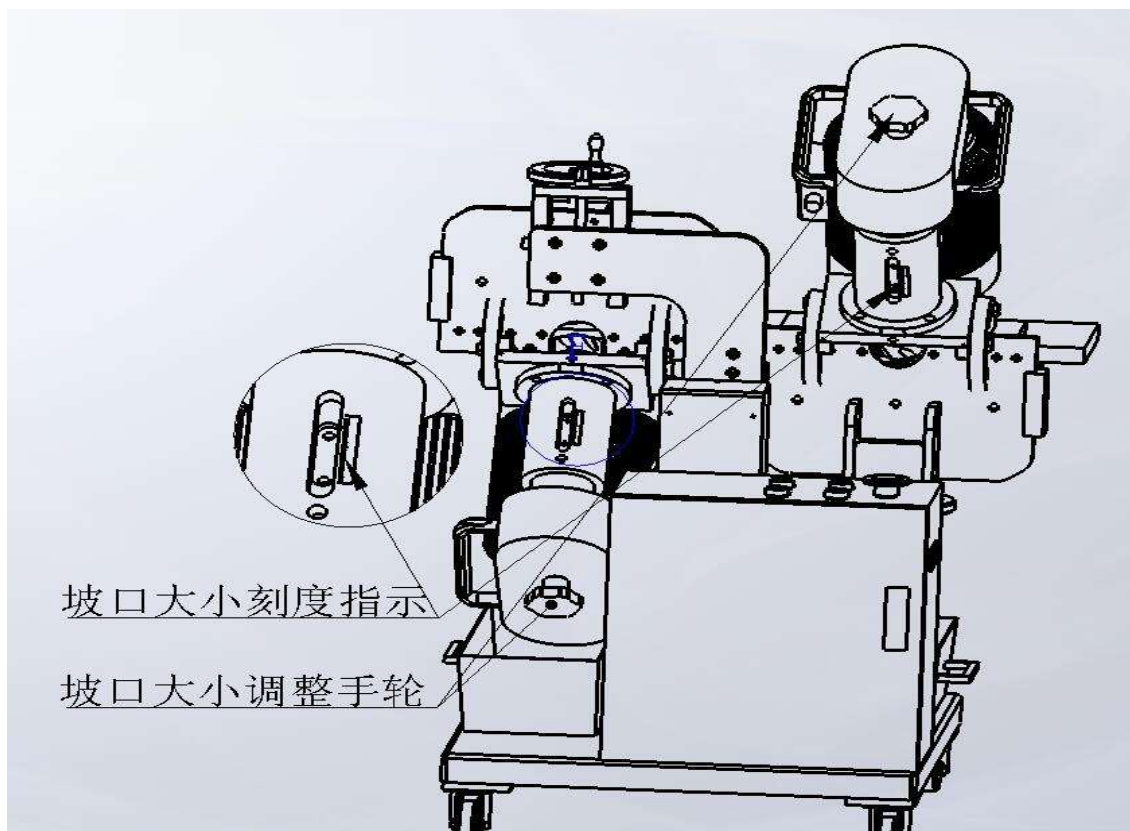


Plate material cutting thickness adjustment, due to the left headstock is processing the lower bevel, the right headstock is processing the upper bevel, positioning surface left headstock is the following plane, the right headstock is the above plane, so the height of the plate thickness needs to be adjusted, the adjustment method see the following figure



Bevel depth setting this equipment can be in a single bevelled edge length of 15 mm more than 32 MM for arbitrary adjustment, overloading is strictly prohibited overloading processing, **overloading will lead to equipment, as well as cutter discs, blades, damage, and injury to personnel.**



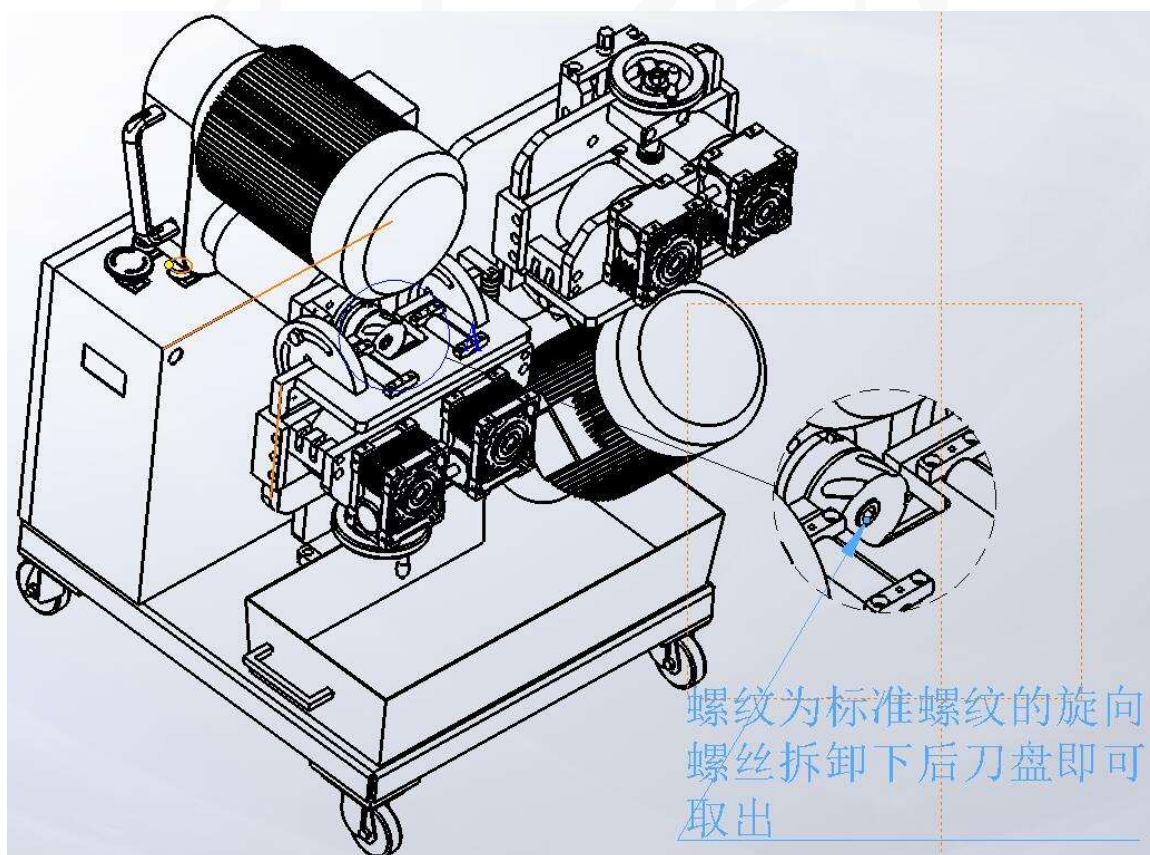
5.7 Tool mounting and dismounting

Note

When removing and installing knives, pay attention to the sharpness of the blade and the high temperature will cause scratches and burns to the hands, it is recommended to wear protective gloves.

1. Cut off the power supply of the machine; (It is strictly prohibited to replace the cutter discs and blades with the power supply.)
2. Remove the upper protective plate;
3. Counterclockwise loosen the blade screw on the lower disc, you can rotate the blade to determine the intact blade (strictly prohibit the installation of the blade does not comply with this installation of this disc);
4. Reinstall the upper guard.
5. Adjust the lower slide plate to the corresponding position according to the thickness of the sheet.

Knife removal illustration



6. Daily operations

6.1 Pre-operation inspection

1. Screw loosening check, every shift should check the equipment for loose screws, if found loose screws should be immediately locked with the appropriate spanner screws.
2. Check the looseness of the screw of the blade of the knife plate, if the screw is found to be loose, the screw should be tightened immediately with the corresponding wrench.
3. Lubricating oil check, the main shaft of this equipment are installed with grease filling holes, every shift should be filled with grease gun.
4. Power supply check, the power socket should be secure, power on the door of the power box should be closed, it is strictly prohibited to open the door of the power box for cutting operations. (Potential for injury to persons and damage to equipment when the door of the electrical box is opened)

6.2 Safety matters for starting bevelling

1. bevelling machine in the work operation, cutting steel plate should be kept clean, it is strictly prohibited steel plate when placing tools workpiece.
2. The ground should be kept clean, no debris and chips.
3. This equipment is strictly prohibited phase work (may damage the motor)
4. The end face of the steel plate to be bevelled should be kept flat, welding slag, cutting tumour should be removed.

1.3 Safety in operation

1. **It is strictly forbidden to touch the running parts of the machine with your hands while the machine is being processed.**

While operating this equipment for processing, please make sure that the operator must wear the necessary protective measures (e.g., protective glasses, work shoes, gloves, etc.). It is strictly prohibited to clean the iron chips and maintenance while the machine is running, as well as touching the running parts of the machine to avoid unnecessary injuries.

1.4 Notes when stopping

When stopping the machine work should first stop the travelling motor, and then stop the spindle motor, so that the remaining part of the blade processing the amount of cutting will not damage the blade, to wait until all the working part of the complete stop and then carry out the necessary cleanup, clean up the splash of iron filings, it is strictly prohibited to use the hand to touch the iron filings directly, the blade, the blade, and other parts of the blade disc, the application of brushes for the necessary cleanup! Compressed air can also be used for cleaning.

1.5 Precautions for long-term storage and transport of the equipment (In order to make this equipment operate trouble-free for a longer period of time, please strictly implement the following matters)

1. Open the shield to loosen the belt tensioner pulley so that the drive belt is in a loose state.
2. Desiccant should be placed in the electrical box. To prevent the appliance from moisture in the process of long-term storage.
3. Apply necessary anti-rust measures to all the machine parts.
4. The equipment should be stored in a dry place (covered with a dustproof sheath).

7. Bevel preparation

7.1 Commissioning (checking data)

1. Check that the screws on the cutter plate are the same as the warning label.
2. Make sure the feed motor is running in the correct direction.
3. Tighten the screws of the angle adjustment section.
4. Whether there is abnormal trembling and sound when the unit is running empty.

7.2 Plate placement and travelling trolley routes

1. Beveling small steel plate, you can use the main steel plate for manual feeding processing, large plate beveling, you need to place the plate at a height of 600MM, the machine will start from the left to the right for beveling, the processing volume when there is a gradual increase in small to large.
2. The travelling line of the trolley should be level without any obstacles affecting the normal travelling of the trolley, and when the processing of iron filings affects the travelling of the trolley, the trolley should be cleaned up immediately.

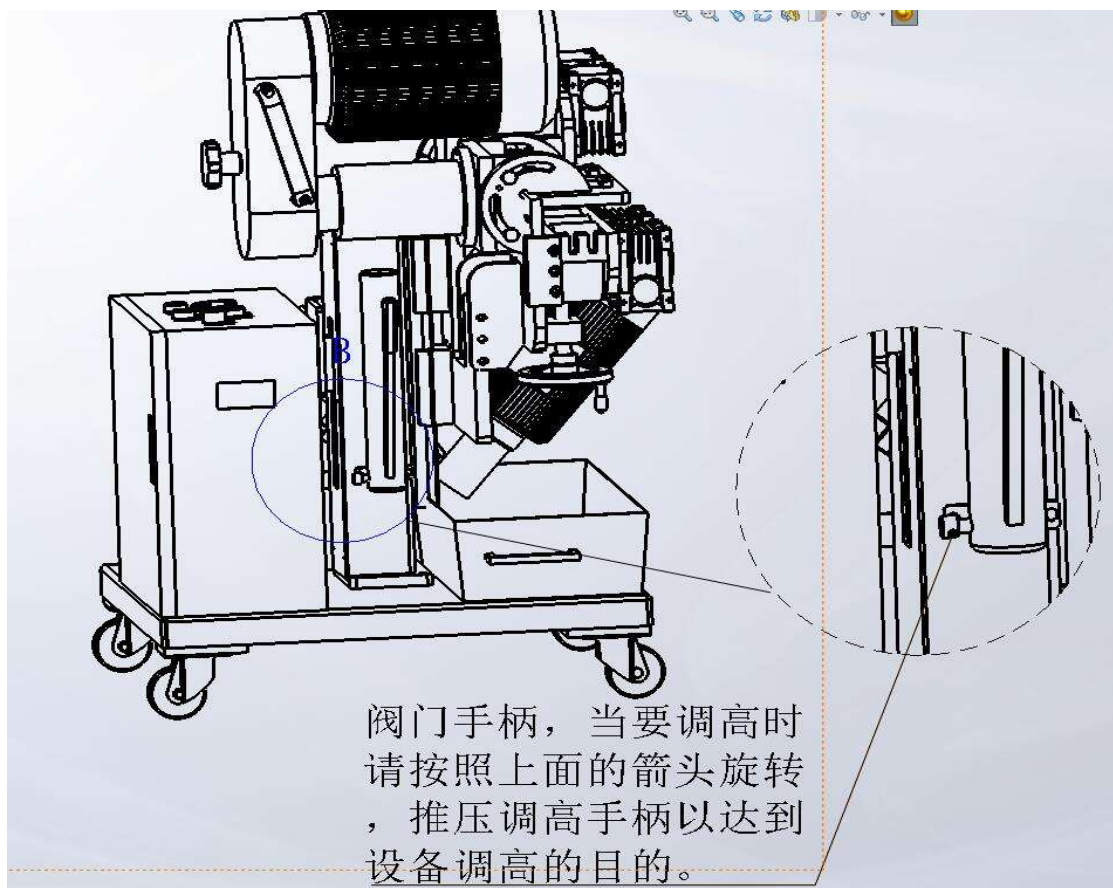
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7.3 Steel plate cleaning

The cut surface of the steel plate shall be cleaned of slag and cuttings before bevelling as necessary.

7.4 Height and angle adjustment of the travelling trolley

1. The height adjustment of the equipment relies on the support frame equipped with linear guides relying on gas springs to support the main body of the machine to achieve the purpose of automatically adjusting the height.
2. The angle adjustment step is to loosen the left and right locking bolts and turn the adjusting wheel to achieve the required bevelling angle.



8. Basic operation

8.1 Process parameters

This bevelling machine is used for processing welding bevels, first of all, according to the processing of different materials to choose different cutter discs and different carbide inserts, according to the size of the processing drawings and the bevel angle.

9.0 Blade selection

This machine can be configured with two kinds of cutter disc, (loaded with round blade and 45-degree blade), the general situation is determined by the material to choose which kind of cutter disc, the processing of hard materials generally choose round blade, processing of softer and non-metallic materials is the choice of 45-degree cutter disc. Generally, different carbide inserts are used for different materials.

For ordinary low alloy steel, use ----- (round) For high hardness alloy steel, use ----- (round) For non-ferrous and non-metallic materials, use ----- (square).

9.1 Selection of circular blade discs

When processing super-hard materials and high-strength materials, it is recommended to use a round blade cutter disc, round blade cutter disc is equipped with 4 pieces of tungsten carbide blades (the main difference is that after the installation of the blade and 45-degree blade impact resistance increased), so that the cost per unit of metre will be reduced, the effectiveness of an increase in the blade is strictly prohibited for the locking of the blade screw for the cutting operation, otherwise it will produce unnecessary injuries.

9.2 Optional 45 degree blade cutter

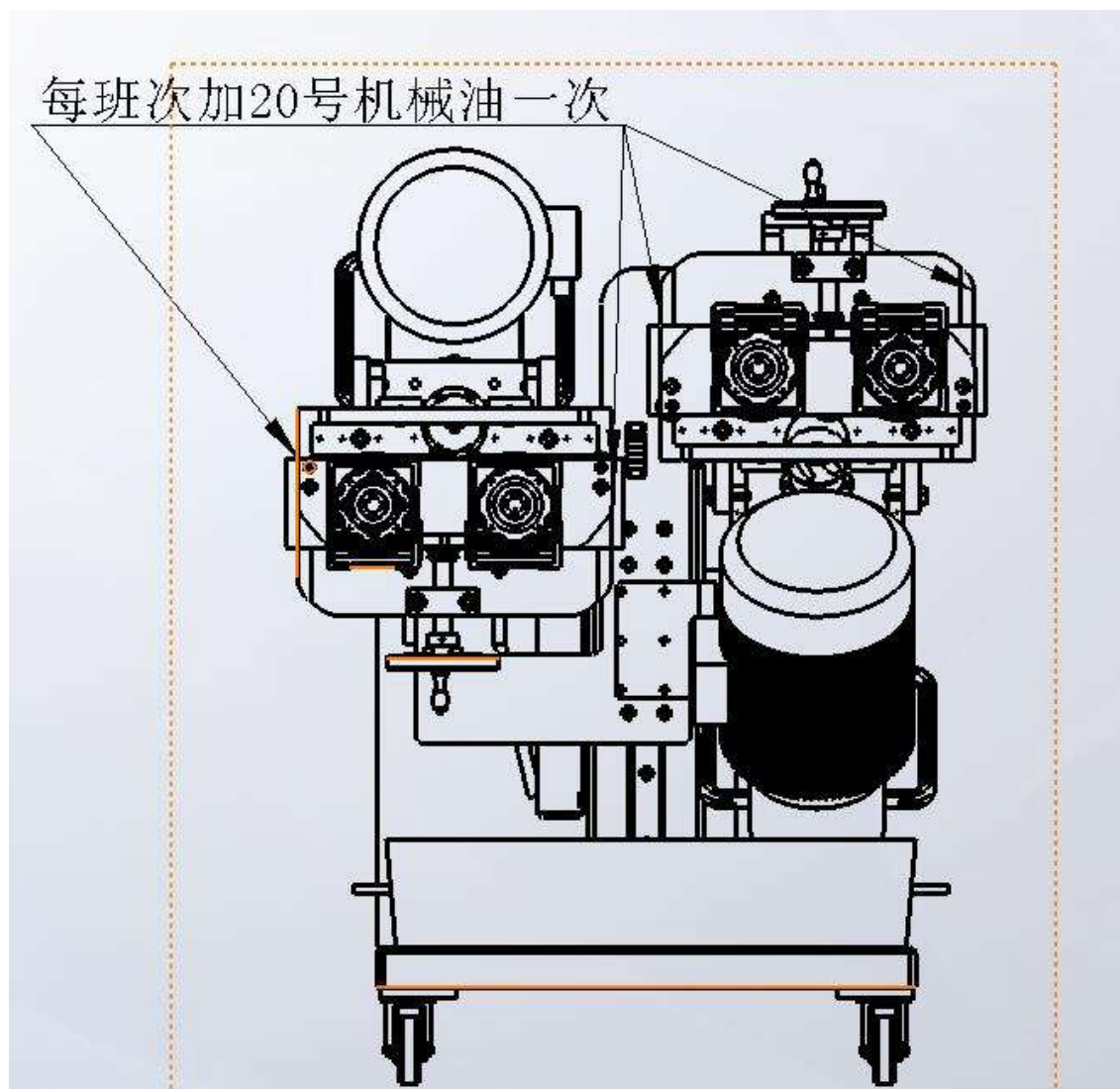
When machining non-ferrous metals, low alloy steel (e.g. Q235 Q345 Q345B) and non-metallic materials, a 45 degree cutter should be used (the power supply should be completely disconnected when changing the cutter).

10.Care and routine maintenance of equipment

1. Check the bolts of the equipment regularly.Whether the nut is loose

10.1 Lubrication oil filling

1. The spindle part is filled with grease at the factory and is normally not to be maintained.
2. The requirement for the transmission part is to fill 20# oil every shift.



10.2 Maintenance and care of electrical appliances

This equipment should be used for a period of time after the maintenance of the electrical box, the specific maintenance method is to cut off the power supply, open the electrical box to check the power box power lines have no aging, with a screwdriver to tighten all the screws for a time, with a brush will be inside the dust and iron debris to clean clean up!

10.3 Failure causes and countermeasures

Fault content	Reason	Method
Cannot walk automatically	1. The lower pressure plate is not pressed. 2. The travelling motor is not working. 3. Universal wheel is obstructed. 4. Material end surface is not flat	1. Adjust the lower press frame body. 2. Turn on the travelling motor button on the electric box 3. Clean the universal wheel. 4. Sand the material defects.
Spindle motor cannot be started	1. The main power supply is out of phase. 2. Spindle bearing is damaged 3. Insurance has burnt out 4. Belt is slack	1. Repair and replace the insurance. 2. Replace spindle bearing 3. Replace the insurance. 4. Raise the tensioner pulley of the belt
Blade damage	1. The feed amount is too big 2. Material has hard layer 3. Material is not fixed 4. The screws for fixing the blade have been loosened. 5. The blade has been shielded.	1. Reduce the feed rate 2. Clean the hard layer of sanding material. 3. Compress the material. 4. Tighten the blade screws after stopping the machine. 5. Replace the blade.

Abnormal sound, cutting vibration	1. Material is not fixed tightly. 2. Spindle bearing is damaged. 3. Angle adjusting screw is not fixed 4. Bevel end face is not tight against the leaning surface 5. Some screws of the machine are loose 6. Spindle locking screw not tightened.	1. Compacting material 2. Replacement of spindle bearings 3. Tighten the side angle screws after stopping the machine 4. Reinstallation of material surfaces after shutdown 5. Fully tighten all machine screws 6. Stop the machine and tighten the spindle screws
The set bevel amount cannot be reached when the machine is cutting.	1. The adjustment of the bevelling machine has not been adjusted for the feed knife. 2. Damaged blades.	1.Increase the amount of feed 2.Replacement of blades