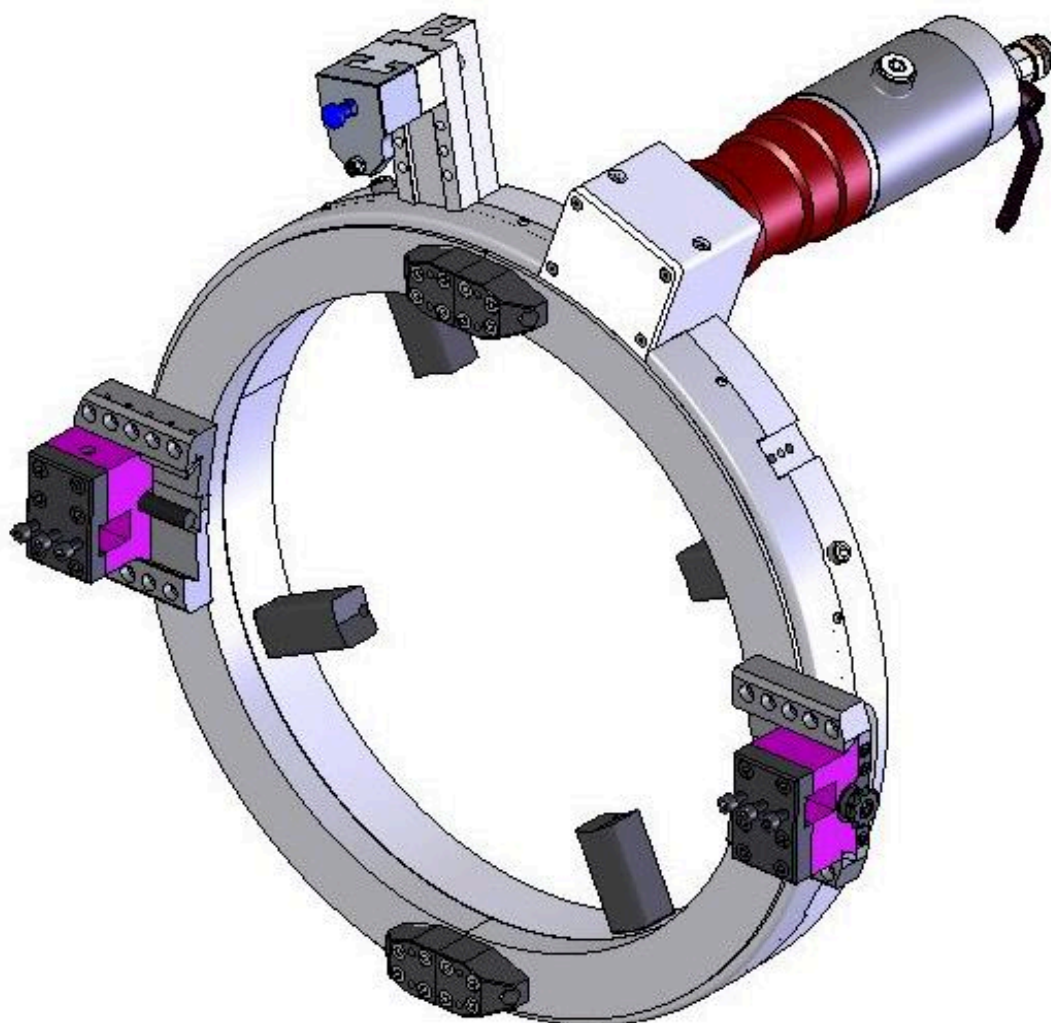




INSTRUCTION MANUAL



MCA CUTTER



MCA CUTTER

Original Instructions — rev.01 2014—In compliance with the
paragraph 1.7.4
Of the Machine Directive 2006/42/CE



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G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



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PRELIMINARY INFORMATION

G.B.C. Industrial Tools S.p.A. is known worldwide for the quality of the machines and accessories for pipe cutting and bevelling procedures of any sort and plate bevelling machines..

The Headquarters are located in Cazzago San Martino (BS) where are currently operating the General Management, the sales department, as well as the main workshop and the shipping department.

QUALITY STANDARD—All our machines are assembled according to the highest quality standard. Since 1996 G.B.C. Industrial Tool S.p.a. has implemented management procedures in compliance with the quality system regulations UNI EN ISO 9001 (SGS ITALIA S.R.L. N° IT 96.088 / 1996).

This Manual is supplied together with the machine it makes reference to. The customer may apply for further copies to G.B.C. Industrial Tools S.p.a. Our company owns the copyright of this document and any partial or complete copy or distribution to natural persons or to corporate bodies is strictly forbidden unless our prior approval to do so is obtained. G.B.C. Industrial Tools S.p.a.

informs its customers that any operation carried out on the machines which is not prescribed in this manual entails the automatic invalidation of the warranty. G.B.C. Industrial Tools S.p.a. recommends to contact the Maintenance Service in Cazzago San Martino – Italy prior to proceed with any modification on the machine.

You are invited to scrupulously adhere to the information written on the identification tag. For any further information you are invited to contact us at these numbers:

Per ulteriori informazioni, si prega di contattare:

Tel. +39 - 030 -7451154
Fax +39 - 030 – 7356629

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WARRANTY GENERAL CLAUSES

G.B.C. guarantees the reliability of the machine and its conformity to the specifications herewith reported. The warranty covers the machine in its whole for a time period of one year from the shipment date (ref. Delivery Note) for any flaw not imputable to the user. The parts subject to wear are excluded from the warranty at sole discretion of **G.B.C.**

In case of any operational malfunction arising during the warranty period, **G.B.C.** And its Maintenance Service, hereinafter called **MSS**, will remedy this inconvenient free of charge, both for handwork and for eventual replaced parts, except when the malfunction is directly or indirectly imputable to misuse or alteration. In any case the machine must not be disassembled or altered before the shipment. The warranty is valid only when the warranty document is duly signed by **G.B.C.** and by a **G.B.C.** official distributor connected with the **MSS** maintenance service.

The shipment of the defective material must be performed within 8 (eight) days from the notification of the defect and/or the claim and/or the request of technical assistance. On the contrary the warranty will be void. **G.B.C.** and **MSS** obligations will cover the defect resolution, the general maintenance and the inspection of the parts subject of the claim only. The component replacement is at **G.B.C.** discretion only. The shipment to costs from and to the **MSS** as well as the direct and indirect costs rising from repair of the product are at user's charge. Any warranty repair or extraordinary repair must be executed by **G.B.C.** and **MSS**, otherwise the warranty will be void.

Any ordinary maintenance performed by the customer/user or by any service centre non recognized or approved by **G.B.C.** will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials, power supply, negligence, unauthorized modifications, atmospheric events, acts of vandalism, incautious handling and/or transport, use of non original **G.B.C.** parts and damage for causes not specified by **G.B.C.** and for which **G.B.C.** declines any responsibility. **G.B.C.** reserves the right to modify and to improve its products without any obligation to modify equipment and components already supplied. Nobody is authorized to modify the conditions herewith contained or to issue any on behalf of **G.B.C.** The claim terms for defects and/or damages in the material or of the ordered quantities, are those pre-scribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

N.B.:“Filter lubricator units are necessary accommodations for all pneumatic tools in an industrial environment in order to ensure maximum machine performance and to prevent premature motor breakdown. Failure to use a filter lubricator properly calibrated to this unit will void certain warranty claims”

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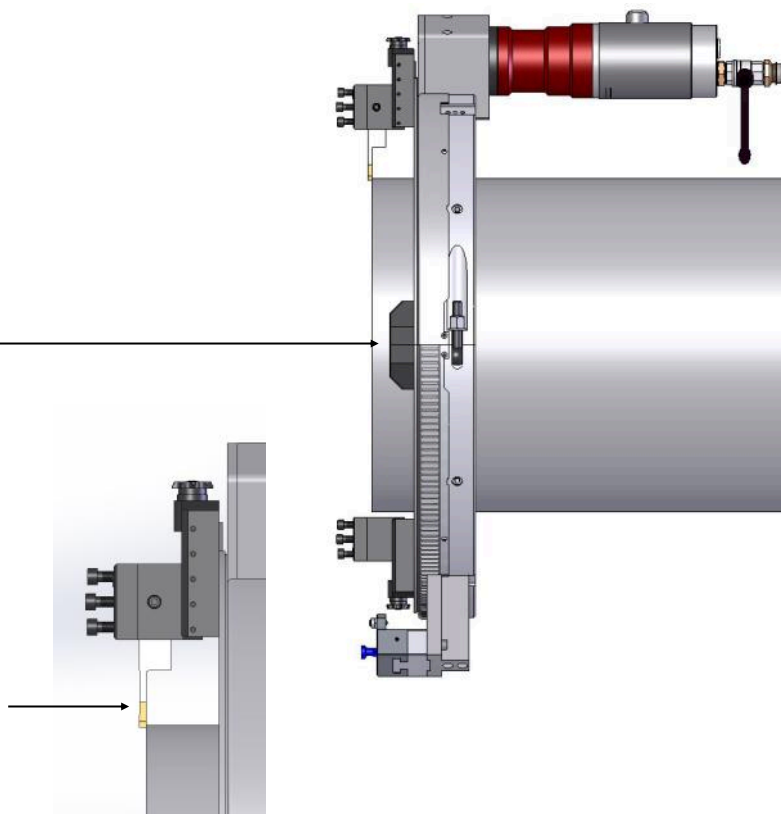


INTENDED USE OF THE MACHINE

The MCA is a machine designed for cutting and bevelling pipes with OD included between 23mm and 1066.8mm with a maximum thickness of 50mm

The machine operates while mechanically gripped on the pipe OD with locking pads.

The cut and bevel operations are obtained by tools having different shapes and different specifications in relation to the pipes to be machined.



THE MACHINE SHOULD BE USED ONLY BY OPERATORS WHO HAVE BEEN DULY TRAINED
ON THE SPECIFIC UNIT

FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PRE-
DICTABLE MISUSE OF THE MACHINE

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- All the setting and maintenance operations shall be executed when the machine is switched off and disconnected from the power supply, whether it is electric, pneumatic or hydraulic.
- The maintenance work shall be executed by qualified and trained personnel.
- During the replacement of the tools pay particular attention to avoid cuts and bruises.
- Do not get up close to the operating machine.
- The tools hand feeding shall be performed exclusively with the machine switched off.
- The tools shall be lubricated with the proper cutting oil or cooling lubricant.
- The machine shall be operated only when correctly gripped on the pipe OD.
- Using the machine in different ways other than those stated above shall be considered improper use.

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SAFETY PRESCRIPTIONS

G.B.C. Industrial Tools S.p.A. designs and assembles its machines in strict compliance with the safety regulations provided by the applicable EC directives and by the Italian laws regulating this matter.

G.B.C. Industrial Tools S.p.A. declines any responsibility for misuse of its machines and their use when in contrast with the regulation listed here in after and with the use and maintenance instructions hereto.

- Carefully read ALL the following regulations and the instructions here with attached before starting any operation.
- Carefully ensure that the operator and the foreman using the machine are fully aware of all the regulations and all the instructions and that they are qualified to operate the unit.
- Strictly attain to the indications given by the international symbols applies on the machine and/or on its case.
- Do not perform any maintenance operation when the machine is plugged to the power supply.
- Before every use, ensure the power supply connections to be conform to the specifics given by our manual.

- The authorized operator in any case will not have to disregard the basic safety rules such as:
- Using gloves and goggles (safety gear supplied by the company responsible for the site or for the building)
- To properly illuminate the working area
- Ensure you are operating in an area which grants free movements (at least 1,5 metres around the operator)
- Do not replace the control system and do not replace parts with not original spare parts, and do not project violent water squirts on the machine
- Keep the hands away from hot and sharpened parts.
- G.B.C. Industrial Tools S.p.A. remarks that for any not specified circumstances it is necessary to obtain the authorization of the manufacturer.

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The proper use of the safety gear leaves the only risks to be relegated to the user's system and not by inherent defects of the machines.

The acoustic emissions are within the maximum limits provided by the current Machinery Directive. The tests are performed on every single machine and the results are stored in our archives.

1. Always wear gloves and goggles during every operation
2. Any adjustment or inspection of the machine shall be done with the unit unplugged from the power source.
3. During the operations the hands shall be kept on the security valve and on the hand wheel.
4. The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.



DIMENSIONS

MACHINE WEIGHT	kg	Min. 18 Max. 180
SHIPPING DIMS	mm	-
SHIPPING WEIGHT	kg	Min. 35 Max. 210

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Model	POWER SUPPLY	Range	"A"	"B"	"C"	"D"	"E"	"F"	"G"
MCA 1	Pneumatic	1" - 31/2"	380	145	152,5	264,5	114	228	112
	Electric	1" - 31/2"	570	145	152,5	264,5	114	228	112
	Hydraulic								
MCA 2	Pneumatic	2" - 6"	450	167	195,5	342,5	145	290	174
	Electric	2" - 6"	590	167	195,5	342,5	145	290	174
	Hydraulic								
MCA 3	Pneumatic	3" - 8"	490	167	229	396,5	172	344	227
	Electric	3" - 8"	620	167	229	396,5	172	344	227
	Hydraulic								
MCA 6	Pneumatic	6" - 12"	490	167	283	511	226	452	335
	Electric	6" - 12"	620	167	283	511	226	452	335
	Hydraulic								
MCA 10	Pneumatic	10" - 16"	520	167	345,5	615,5	268	536	419
	Electric	10" - 16"	500	167	345,5	615,5	268	536	419
	Hydraulic	10" - 16"	350	167	345,5	615,5	268	536	419

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Model	Power	Range	"A"	"B"	"C"	"D"	"E"	"F"	"G"
MCA 14	Pneumatic	14" - 20"	520	167	396,5	717,5	319	638	521
	Electric	14" - 20"	500	167	396,5	717,5	319	638	521
	Hydraulic	14" - 20"	350	167	396,5	717,5	319	638	521
MCA 18	Pneumatic	18" - 24"	520	167	455	828	373	746	625
	Electric	18" - 24"	500	167	455	828	373	746	625
	Hydraulic	18" - 24"	350	167	455	828	373	746	625
MCA 24	Pneumatic	24" - 30"	520	167	532	980	450	900	775
	Electric	24" - 30"	500	167	532	980	450	900	775
	Hydraulic	24" - 30"	350	167	532	980	450	900	775
MCA 30	Pneumatic	30" - 36"	520	167	651	1198	547	1094	940
	Electric	30" - 36"	500	167	651	1198	547	1094	940
	Hydraulic	30" - 36"	350	167	651	1198	547	1094	940
MCA 36	Pneumatic	36" - 42"	520	169,5	732,5	1356,5	628	1256	1098
	Electric	36" - 42"	500	169,5	732,5	1356,5	628	1256	1098
	Hydraulic	36" - 42"	350	169,5	732,5	1356,5	628	1256	1098

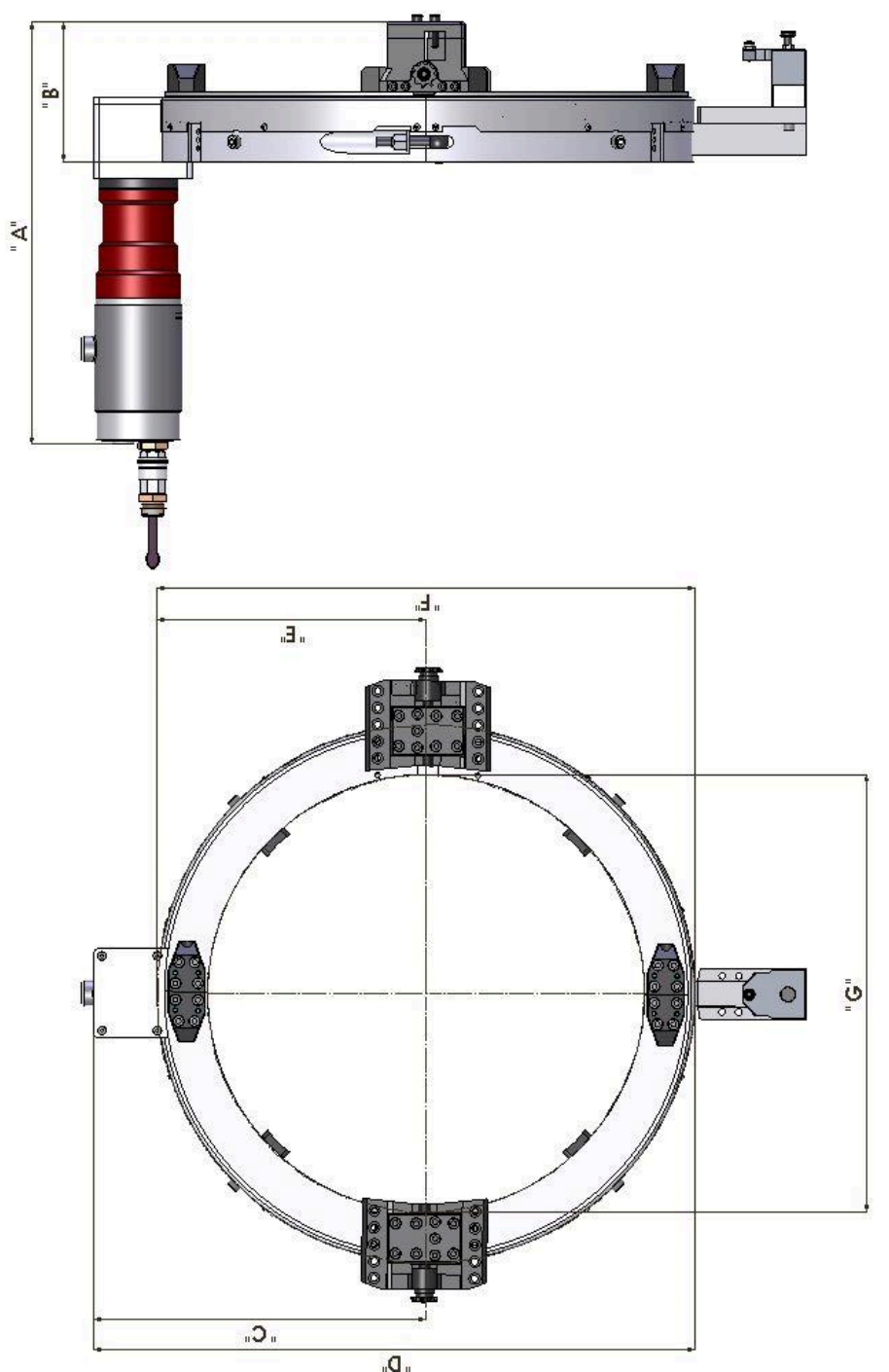
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MCA 01 to MCA 10 Technical Data

		MCA01	MCA02	MCA03	MCA06	MCA10
Locking Range	mm (inches)	33.4-108 (1.31"-4.25")	50-165 (1.96"-6.49")	67-220 (2.63"-8.66")	152-325 (5.98"-12.79")	254-410 (10"-16.1")
Toolholder Stroke	mm (inches)	25 (1)	35 (1.2)	50 (2.0)	60 (2.4)	60 (2.4)
Feeding Pitch	mm (inches)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)
Machine Weight	kG	18	22	26	44	57
PNEUMATIC						
Pneumatic	Hp (W)	1.1 (800)	0.9 (700)	1.7 (1300)	1.7 (1300)	4.2 (3100)
Air Consumption	Nl/min (cfm)	1000 (35)	1300 (46)	1300 (46)	1300 (46)	2800 (99)
Air Pressure	bar (psi)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)
Max Ring Torque	Nm	47 (6bar) 141 (8bar)	58 (6bar) 175 (8bar)	120 (6bar) 360 (8bar)	158 (6bar) 475 (8bar)	520 (6bar) 1320 (8bar)
Idle Speed	gg/min (rpm)	48	31	25	24	15
ELECTRIC						
Electric Motor Power	W	1200	1200	1200	1200	2200
Tension	Volt	230	230	230	230	230
Frequency	Hertz	50	50	50	50	50
Max Ring Torque	Nm	259	412	544	718	1142
Idle Speed	gg/min (rpm)	33	21	16	12	14
HYDRAULIC						
Hydraulic Motor Power	Hp (kW)	2.2 (1,6)	2.2 (1,6)	4.08 (3)	4.08 (3)	4.08 (3)
Max GBC Power Pack Pressure	bar (psi)	130 (1885)	130 (1885)	130 (1885)	130 (1885)	130 (1885)
Oil Flow	l/min. (cfm)	30 (0,1.06)	30 (0,1.06)	30 (1.06)	30 (1.06)	30 (1.06)
Max Ring Torque	Nm	370	454	953	1260	1892
Idle Speed	gg/min (rpm)	48	51	31	24	15

N.B. The measurement of the acoustic emissions was executed with a phonometer and clibrator LAT.

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MCA 14 to MCA 36 Technical Data

		MCA14	MCA18	MCA24	MCA30	MCA36
Locking Range	mm (inches)	338-510 (13.30"-20.07")	443-615 (17.44"-24.21")	596-768 (23.46"-30.23")	757-937 (29.80"-36.88")	895-1095 (35.23"-43.11")
Toolholder Stroke	mm (inches)	60 (2.4)	60 (2.4)	60 (2.4)	60 (2.4)	60 (2.4)
Feeding Pitch	mm (inches)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)	0.083 (0.003)
Machine Weight	kG	69	74	79	94	180
PNEUMATIC						
Pneumatic Motor Power	Hp (W)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)
Air Consumption	Nl/min (cfm)	2800 (99)	2800 (99)	2800 (99)	2800 (99)	2800 (99)
Air Pressure	bar (psi)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)
Max Ring Torque	Nm	622 (6bar) 1578 (8bar)	600 (6bar) 1523 (8bar)	722 (6bar) 1832 (8bar)	613 (6bar) 1556 (8bar)	704 (6bar) 1787 (8bar)
Idle Speed	gg/min (rpm)	13	14	11	13	11
ELECTRIC						
Electric Motor Power	W	2200	2200	2200	2400	2400
Tension	Volt	230	230	230	230	230
Frequency	Hertz	50	50	50	50	50
Max Ring Torque	Nm	1358	1315	1583	1444	1660
Idle Speed	gg/min (rpm)	11	11	10	11	10
HYDRAULIC						
Hydraulic Motor Power	HP (kW)	4.08 (3)	4.08 (3)	4.08 (3)	4.08 (3)	4.08 (3)
Max GBC Power Pack Pressure	bar (psi)	130 (1885)	130 (1885)	130 (1885)	130 (1885)	130 (1885)
Oil Flow	l/min. (cfm)	30 (1.06)	30 (1.06)	30 (1.06)	30 (1.06)	30 (1.06)
Max Ring Torque	Nm	2258	2185	2630	2229	2563
Idle Speed	gg/min (rpm)	13	14	11	13	11

N.B. The measurement of the acoustic emissions was executed with a phonometer and clibrator LAT.

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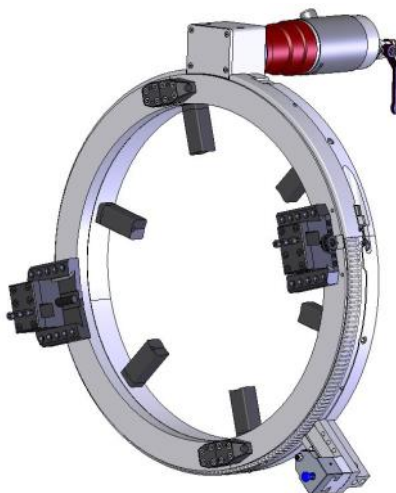
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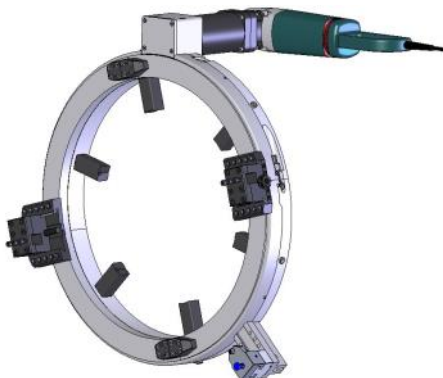


MCA MODELS

Pneumatic



Electric



Hydraulic



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MACHINE STANDARD EQUIPMENT

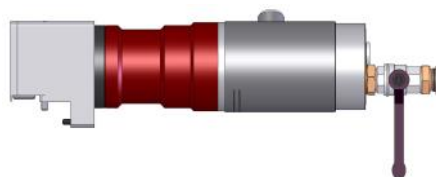
The machine is supplied including the following equipment:

- N. 1 Striker Assembly
- N. 2 Tool Holders
- N. 4 , 6 , 8 o 10 Locking Pads depending by the model (covering the whole range of the machine)
- N. 1 Drive Assembly (pneumatic, electric or hydraulic)
- N. 1 Set of Drawings.
- N. 1 Instruction Manual.

MCA



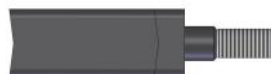
Drive Assembly



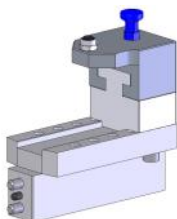
Tool Holders



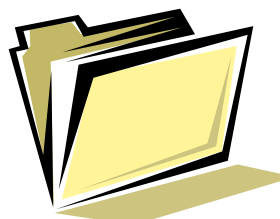
Locking Pads



Striker Assembly



Instruction Manual



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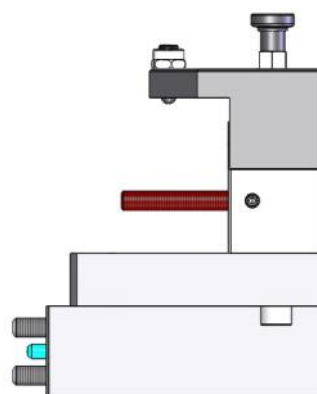


Optional Copier Toolboxes

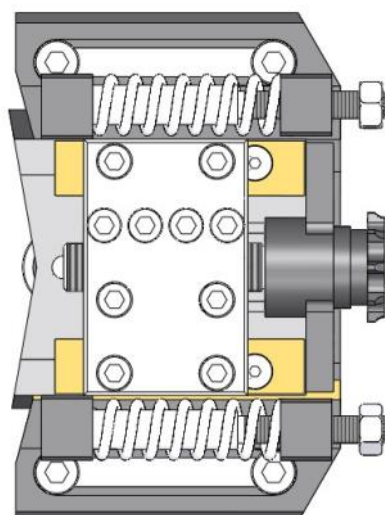
N. 1 Striker Assembly

N. 2 Copier Toolboxes

STRIKER ASSEMBLY



COPIER TOOLBOX



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MACHINE STABILITY

Considering its mass there is no specific stability problem detected that may compromise the operator safety.

WORKPLACE

The hydraulic version can be operated directly from the Hydraulic Power Unit (Item C20966) or via wired remote control supplied with the Hydraulic Power Unit (Item C20973).

The pneumatic version can be operated through a pneumatic valve located on the motor casing.

EMERGENCY STOP

The Hydraulic Power Unit C20966 can be stopped by moving the lever in the central position.

The Hydraulic Power Unit C20973 can be stopped by pressing the emergency stop button located on the wired remote control.

The pneumatic version is equipped with a pneumatic valve on the motor casing that shall be immediately closed in case of emergency.

The acoustic emissions are at the limit of the threshold. See the indications contained in the specific details chart.

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MACHINE GENERAL SETUP



Measure the pipe OD

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T04790/01-03			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	11015/00	43 - 23	1.69 - 0.90
	04738/02	62 - 42	2.44 - 1.65
	04738/01	81 - 61	3.18 - 2.40
		100 - 80	3.93 - 3.14
T04790/02-06			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/05	70 - 50	2.75 - 1.96
	04738/04	89 - 69	3.50 - 2.71
	04738/03	108 - 88	4.25 - 3.46
	04738/02	127 - 107	5.00 - 4.21
	04738/01	146 - 126	5.74 - 4.96
		165 - 145	6.49 - 5.70
T04790/03-08			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/07	87 - 67	2.63 - 3.42
	04738/06	106 - 86	4.17 - 3.38
	04738/05	125 - 105	4.92 - 4.13
	04738/04	144 - 124	5.66 - 4.88
	04738/03	163 - 143	6.41 - 5.62
	04738/02	182 - 162	7.16 - 6.37
	04738/01	201 - 181	7.91 - 7.12
		220 - 200	8.66 - 7.87
T04790/06-12			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/08	173 - 153	6.81 - 6.02
	04738/07	192 - 172	7.55 - 6.77
	04738/06	211 - 191	8.30 - 7.51
	04738/05	230 - 210	9.05 - 8.26
	04738/04	249 - 229	9.80 - 9.01
	04738/03	268 - 248	10.55 - 9.76
	04738/02	287 - 267	11.29 - 10.51
	04738/01	306 - 286	12.04 - 11.25
		325 - 305	12.79 - 12.00
T04790/10-16			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/07	277 - 257	10.90 - 10.11
	04738/06	296 - 276	11.65 - 10.86
	04738/05	315 - 295	12.40 - 11.61
	04738/04	334 - 314	13.14 - 12.36
	04738/03	353 - 333	13.89 - 13.11
	04738/02	372 - 352	14.64 - 13.85
	04738/01	391 - 371	15.39 - 14.60
		410 - 390	16.14 - 15.35
T04790/18-24			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/08	463 - 443	18.22 - 17.44
	04738/07	482 - 462	18.97 - 18.18
	04738/06	501 - 481	19.72 - 18.93
	04738/05	520 - 500	20.47 - 19.68
	04738/04	539 - 519	21.22 - 20.43
	04738/03	558 - 538	21.96 - 21.18
	04738/02	577 - 557	22.71 - 21.92
	04738/01	596 - 576	23.46 - 22.67
		615 - 595	24.21 - 23.42
T04790/14-20			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/08	358 - 338	14.09 - 13.30
	04738/07	377 - 357	14.84 - 14.05
	04738/06	396 - 376	15.59 - 14.80
	04738/05	415 - 395	16.33 - 15.55
	04738/04	434 - 414	17.08 - 16.29
	04738/03	453 - 433	17.83 - 17.04
	04738/02	472 - 452	18.58 - 17.79
	04738/01	491 - 471	19.33 - 18.54
		510 - 490	20.07 - 19.29
T04790/24-30			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/08	616 - 596	24.25 - 23.46
	04738/07	635 - 615	25.00 - 24.21
	04738/06	654 - 634	25.74 - 24.96
	04738/05	673 - 653	26.49 - 25.70
	04738/04	692 - 672	27.24 - 26.45
	04738/03	711 - 691	27.99 - 27.20
	04738/02	730 - 710	28.74 - 27.95
	04738/01	749 - 729	29.48 - 28.70
		768 - 748	30.23 - 29.44
T04790/30-36			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/08	777 - 757	24.25 - 23.46
	04738/07	797 - 777	31.37 - 24.25
	04738/06	817 - 797	32.16 - 31.37
	04738/05	837 - 817	32.95 - 32.16
	04738/04	857 - 837	33.74 - 32.95
	04738/03	877 - 857	34.52 - 33.74
	04738/02	897 - 877	35.31 - 34.52
	04738/01	917 - 897	36.10 - 35.31
		937 - 917	36.88 - 36.10
T04790/36-42			
CODICE	BLOCCAGGIO	LOCKING	
04739/00	04738/09	915 - 895	36.02 - 35.23
	04738/08	935 - 915	36.81 - 36.02
	04738/07	955 - 935	37.59 - 36.81
	04738/06	975 - 955	38.38 - 37.59
	04738/05	995 - 975	39.17 - 38.38
	04738/04	1015 - 995	39.96 - 39.17
	04738/03	1035 - 1015	40.74 - 39.96
	04738/02	1055 - 1035	41.53 - 40.74
	04738/01	1075 - 1055	42.32 - 41.53
		1095 - 1075	43.11 - 42.32

Select the correct set of locking pads helping yourself with the above chart

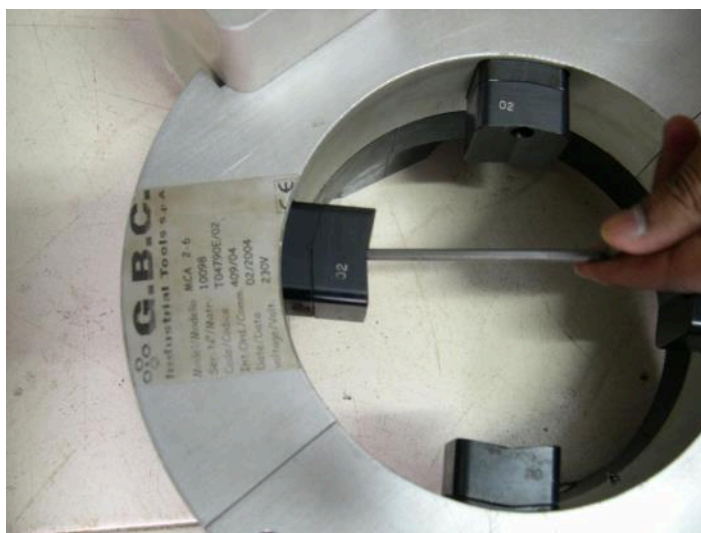
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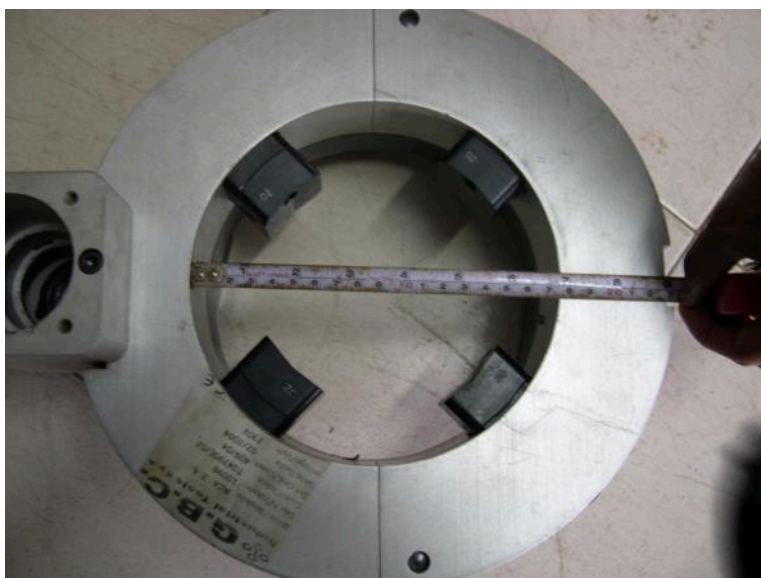


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Install the locking pads as shown in the above picture



Measure the machine ID and apply the page 20

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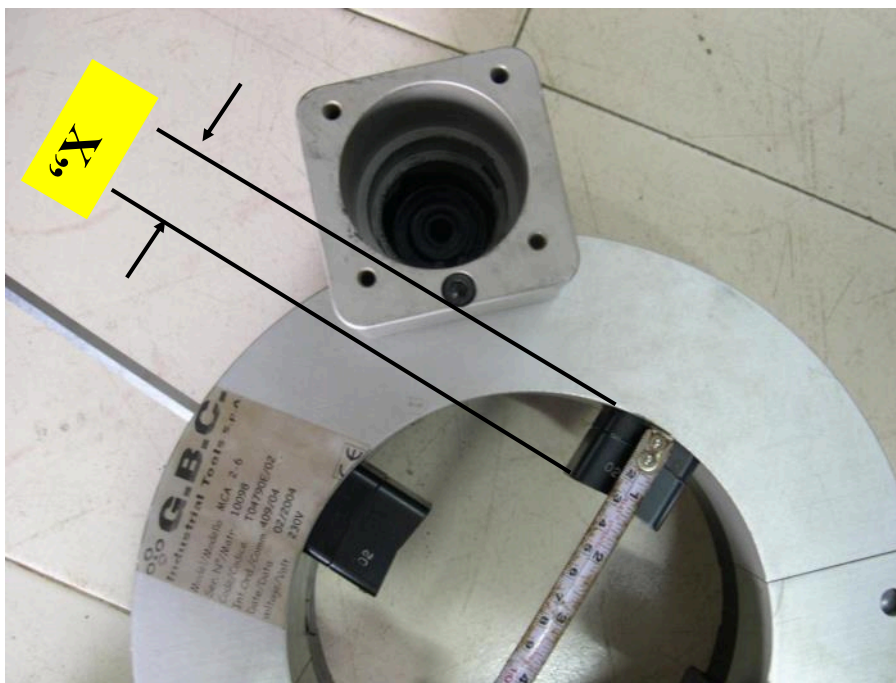


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- ” Position the locking pads according to the “X” derived from the formula



$$\frac{Dim - Det}{2} = X$$

Dim : Machine ID

Det : Pipe OD

X : Value required for the jaws positioning.

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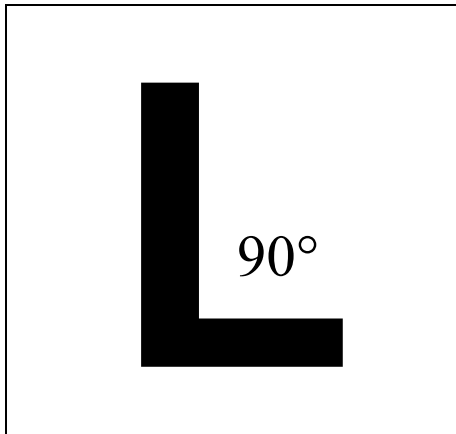
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MACHINE SETUP ON PIPE SECTION



The above picture shows the correct positioning of the machine which shall obviously be placed on the exact cut point required..



The machine should be placed to 90° angle on the pipe



The pad should be locked as shown above

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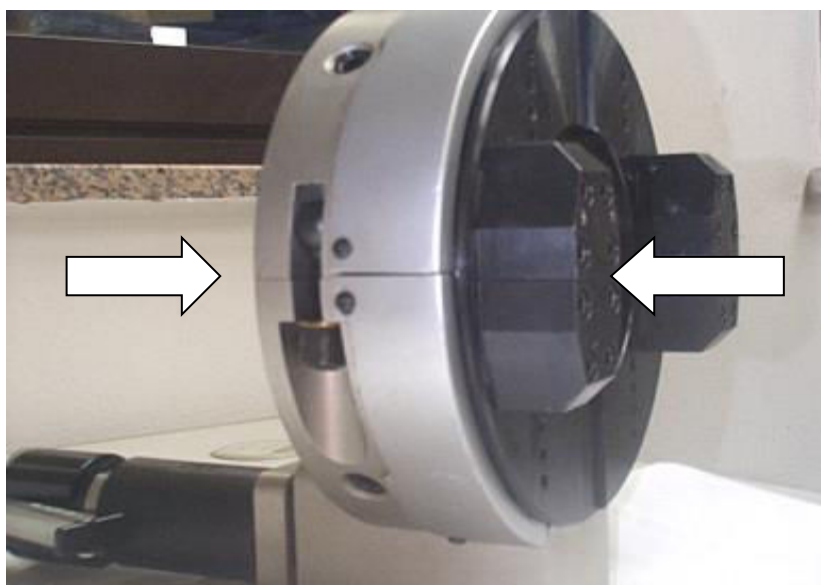
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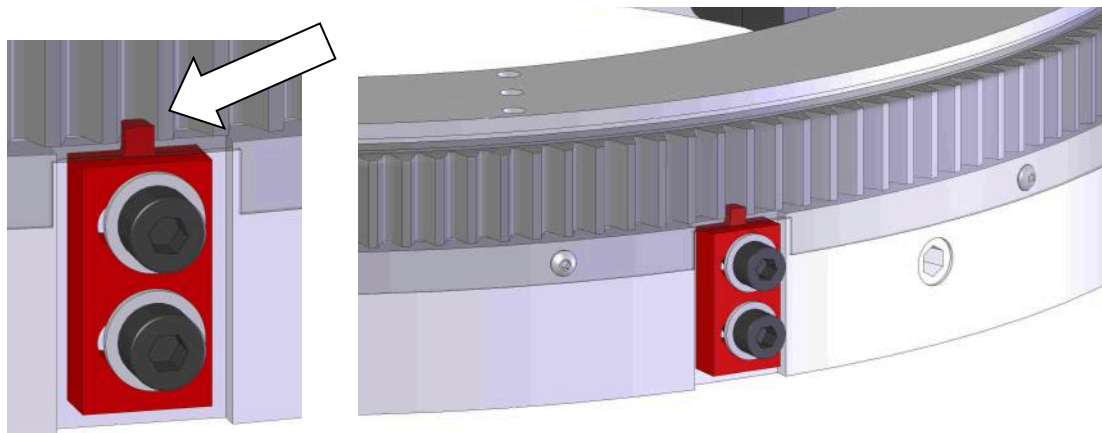


MACHINE SETUP FOR PIPELINE

Rotate the mobile part of the machine until the slit of the part matches with the slit of the fix part (the aluminum body).



Position the CROWN LOCKING TILES on the seat of the striker on both the halves and fix them in order to prevent the machine crown halves to fall out from the split machine during the handling and positioning phases.



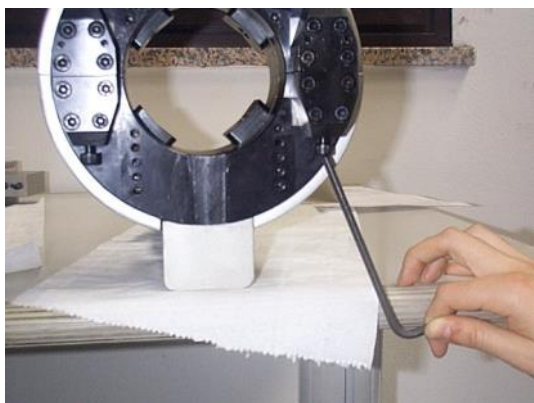
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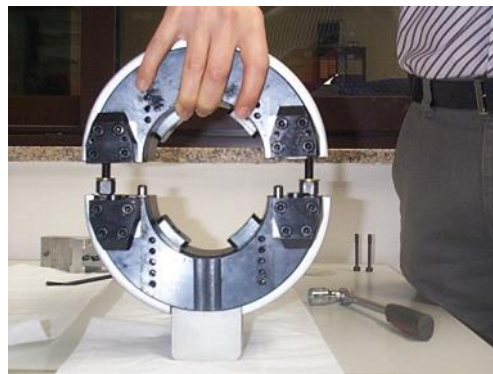
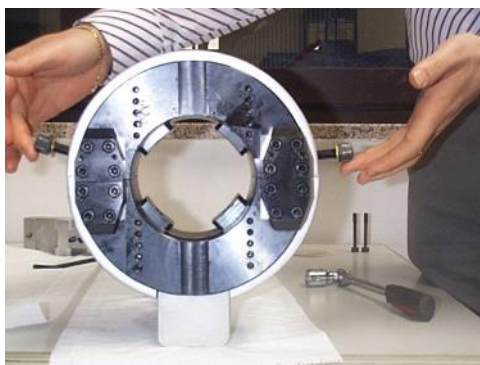
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Remove the screw with the appropriate tool
as shown above.



Use the ratchet wrench to loose the nuts
that hold in place the machine.



Now the parts can be split.

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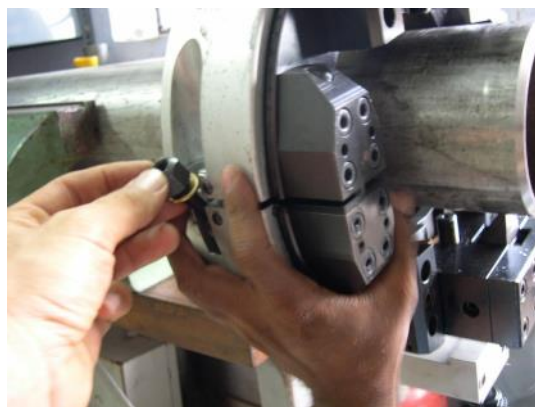


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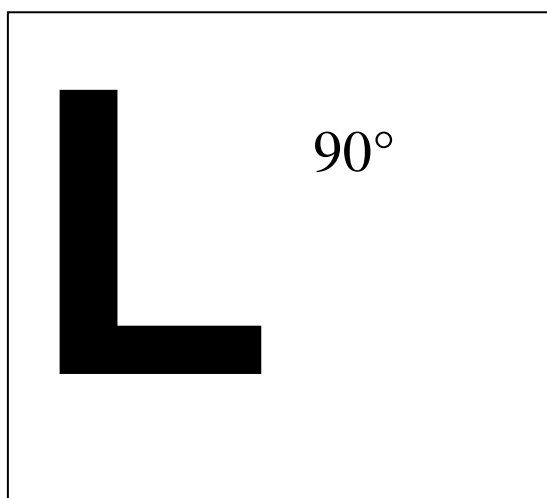
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Position the machine half with the motor flange on top of the pipeline.



Position the other half and fasten the locking nuts previously released



Make sure the machine to be at a 90° angle with the pipe.



Fasten the locking pads as shown in the above picture.



**Before proceeding further
remember to remove the
CROWN LOCKING TILES.**

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TOOL HOLDERS SETUP



Install the tool holders in its seat selecting its correct position in regard to the pipe OD and fix it with the 4 screws.



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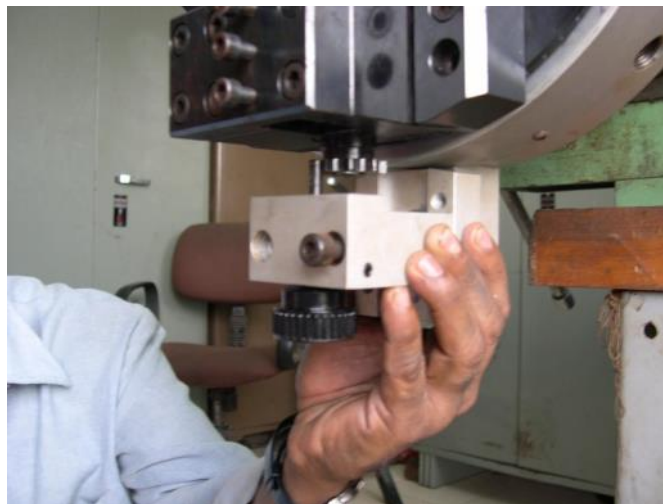
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STRIKER SETUP



Install the striker pod on the machine OD using the appropriate screws.



Now install
er on its pod
sure to set it
correct height considering the pipe OD.

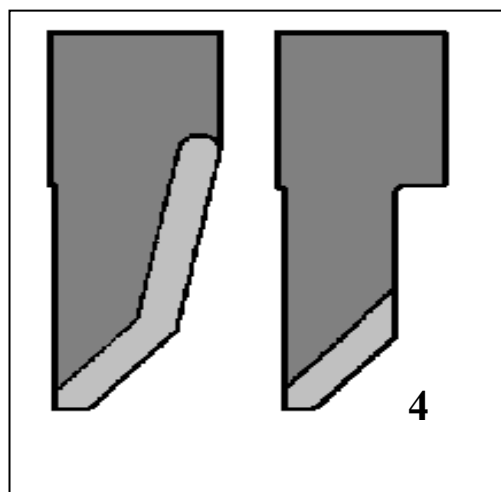
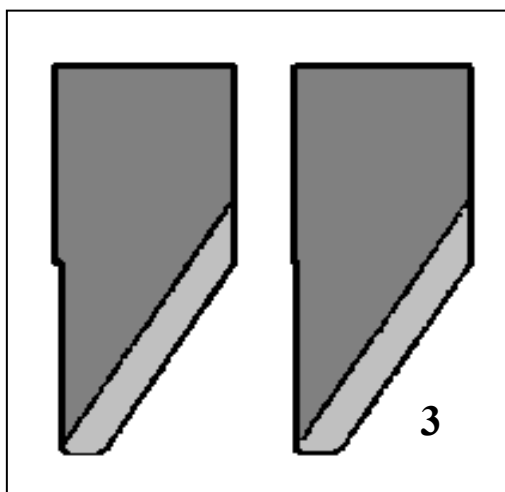
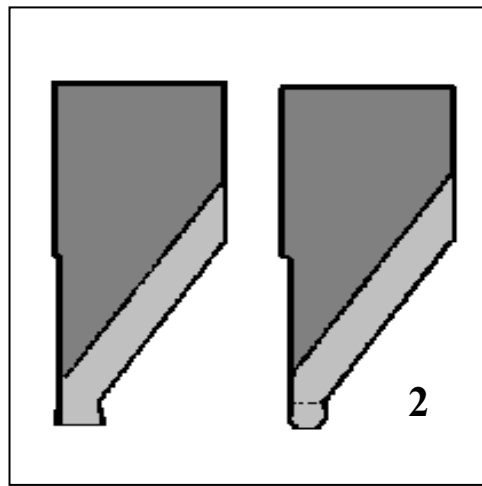
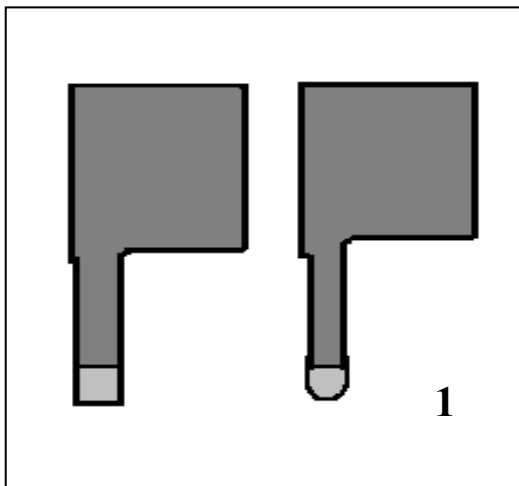
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STANDARD TOOLS SHAPE



There are 4 main couples of tools with different features:

- Cutting Tools
- Cut+Bevel Tools
- Beveling Tool
- Combined Bevel Tools

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TOOLS SETUP AND POSITIONING



Once the tool is selected, slide it in the squared seat located on the tool holders

proper tool



Fasten the screw located on holder side

tool in position.

screw lock the tool to lock the

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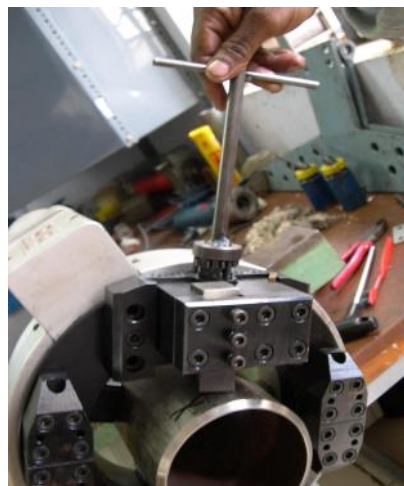
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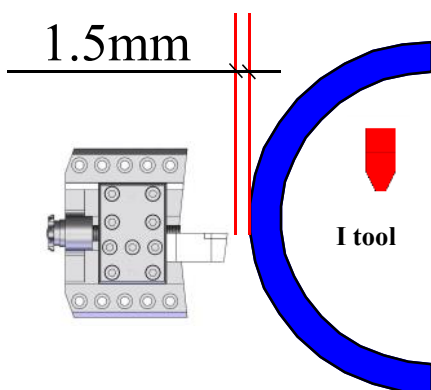
Fasten the three screws on the front side of the tool holder

N.B.: This procedure must be followed for both the Tool holders

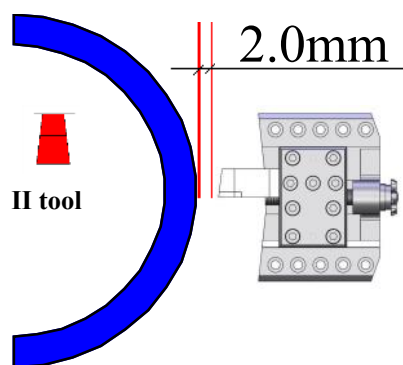


Set both tools in the initial position using the special tool supplied with the machine.

The drawings n°1 and n°2 show the correct position of the cutting tools and of the cut+bevel tools.



Drawing n° 1



Drawing n° 2

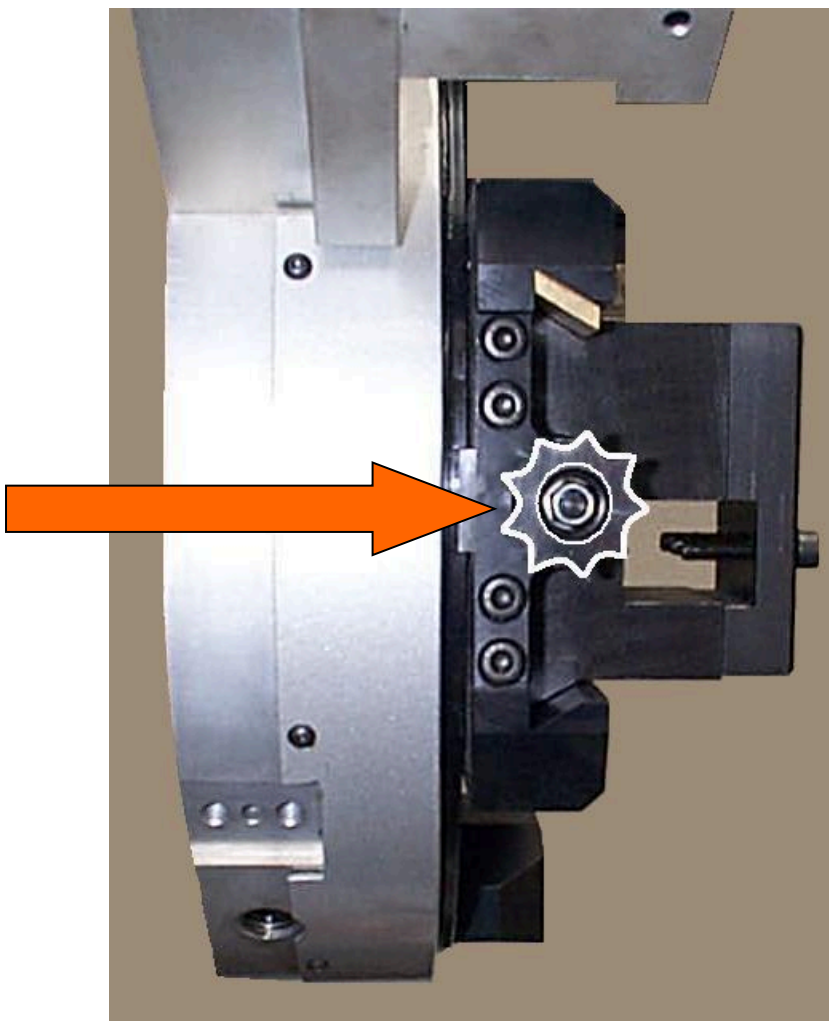
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STAR WHEEL POSITIONING

STAR WHEEL INI-
TIAL POSITION



WARNING!

*The star wheel shall be set in this position
before engaging the striker pin. The above
picture shows the exact position.*

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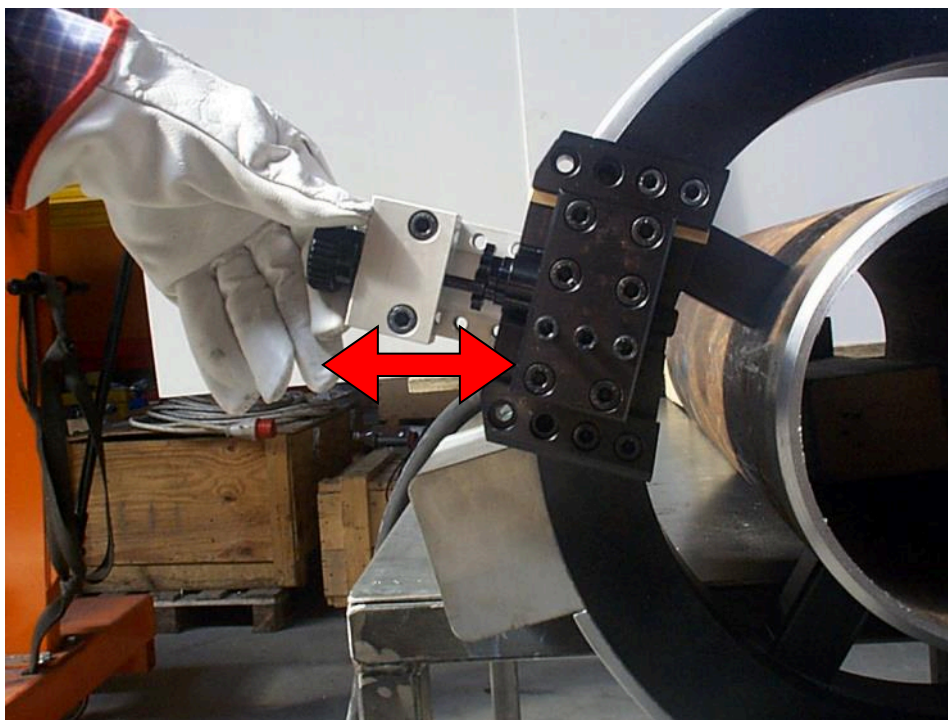


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USE INSTRUCTIONS



Once you have positioned and locked in place the tools following the indications of the previous paragraph you can run the machine.

When the first tool touches the pipe OD and therefore begins the cutting process you will have to disengage the striker pin every time this tool holder is about to return in this position and engage it in order to intercept the tool holder with the other tool.

This expedient allows to have both tools working at the same time so when this happens you can leave the striker pin engaged so that the machine will operate automatically.

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At this step you can increase the speed of rotation..

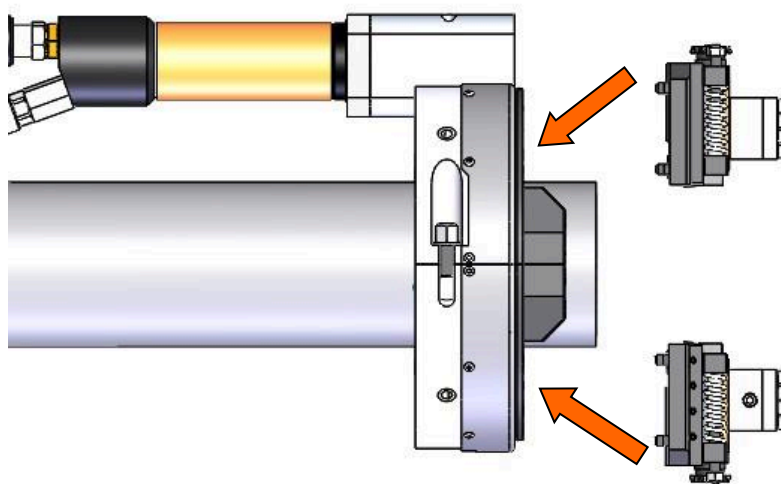
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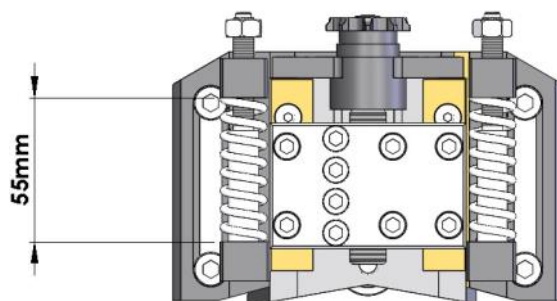


Copier Toolboxes Setup

- 1) Install the copier toolboxes in their seats making sure to place them at the correct height for the diameter of pipe that has to be worked.



- 2) N.B. At this stage the springs should be compressed to a length of 55mm. Check this value with a measuring tool and if necessary, adjust the springs compression by acting on the nuts located on the top of each spring.

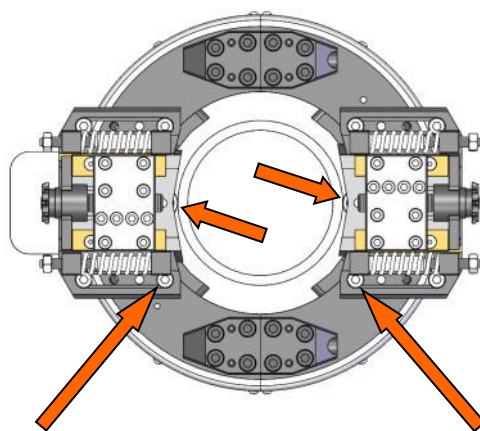


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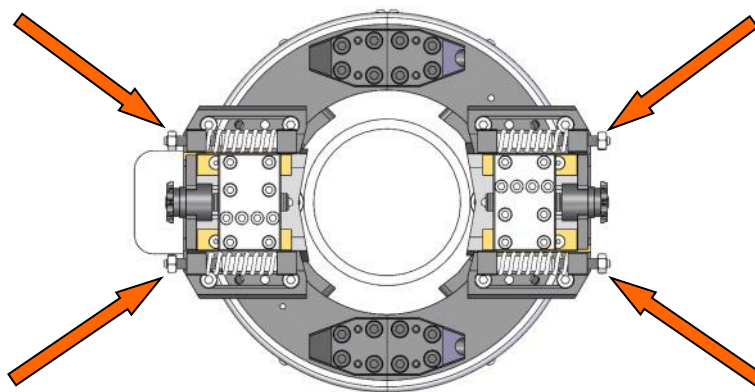
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- 3) N.B. Before securing the toolboxes, you want touch the pipe OD with the tracking bearing as shown in the picture below and only then you can secure them in position.



- 4) Now that the toolboxes are secured in position, loosen the 4 nuts located directly above the springs and bring them all the way up to the end-stops.
The nuts are indicated by the arrows in the picture below.



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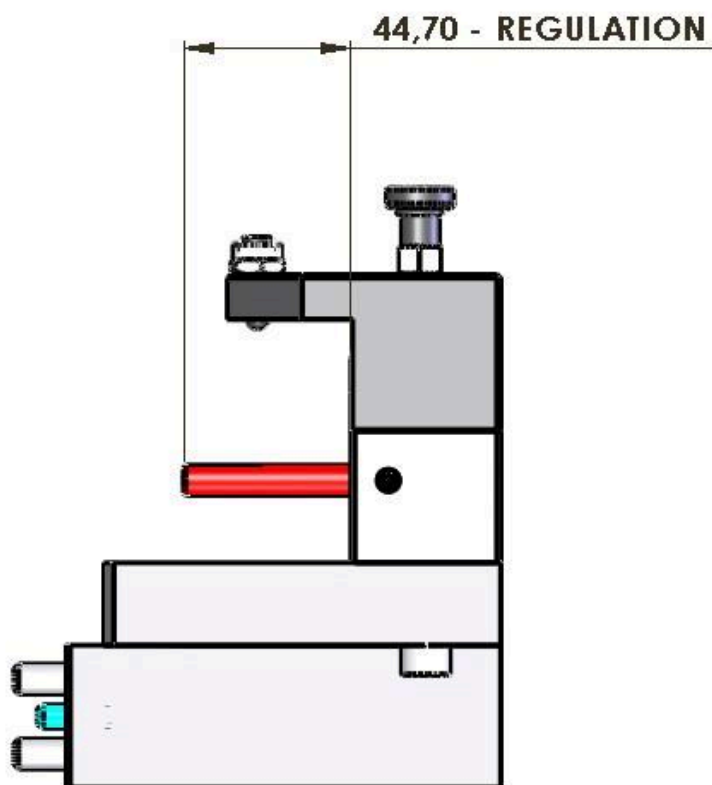
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Get the striker assembly and prior to install it on the machine, check the end-stop screw length which should be already preset to the measure of 44.70mm as shown in the picture below.

In case you will need to adjust its length you can do that by loosen the side grub screw and rotate the end-stop screw with your fingers until the length is reinstated to 44.70mm, then secure the grub screw.

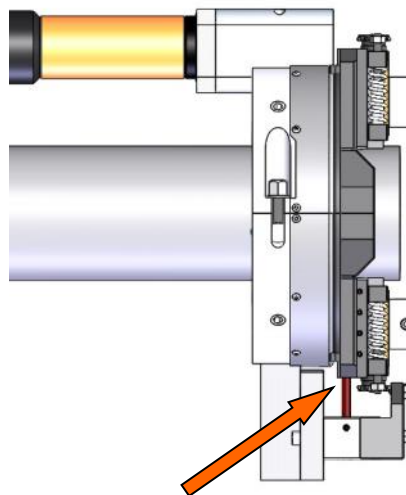
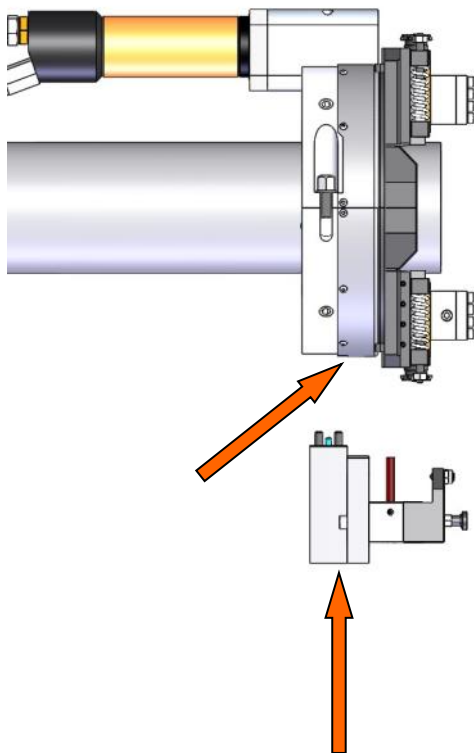


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- 6) Now you can install the assembly on the MCA making sure you are matching the pin seat.
N.B. : Make sure that the striker assembly end-stop screw sits on top of the toolbox base and touches it.



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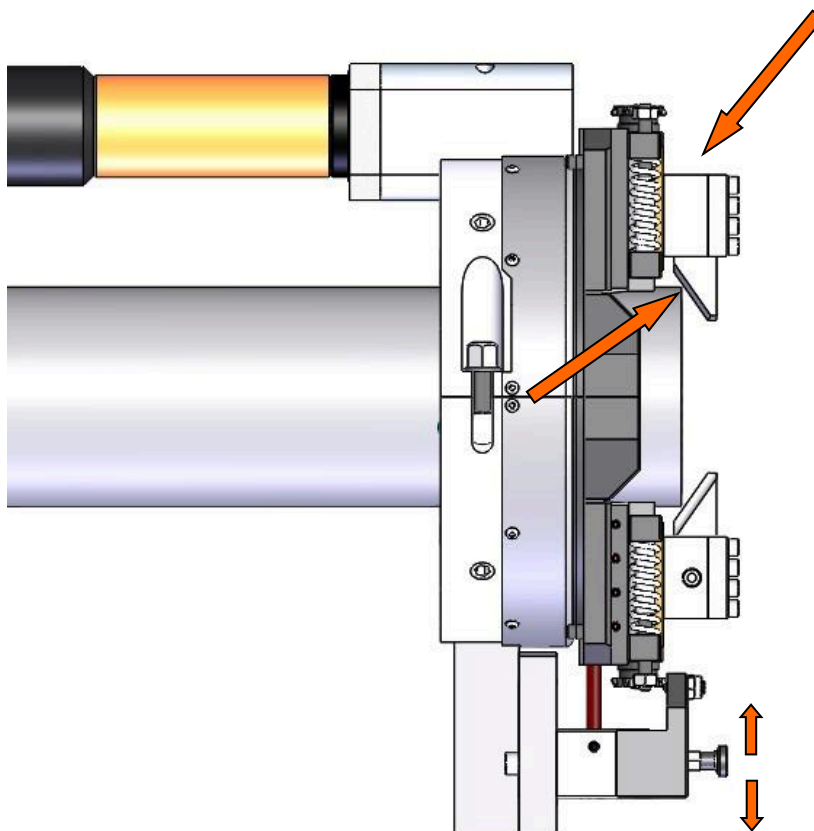


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- 7) Install one beveling tool on each toolbox so that they almost touch the pipe end, then start the machine and engage the striker to activate the automatic tool feeding.



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ORDINARY MAINTENANCE AND PERIODICAL INSPECTIONS

We suggest to perform a service c/o G.B.C. Industrial Tools S.p.A. premises every 400 hours working cycles.

Verify the general conditions of the machine

Ensure the motor tension and voltage is in conformity to the frequency and tension available on the site.

The carbon brushes of the motor shall be replaced before their total wearing.

Always make sure that the tools seats are clean

Clean the tool holders openings and check the conditions of the feeding gears.

Always use sharp tools to obtain the best performance from the machine.

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TROUBLESHOOTING

The machine does not run : Check the power supply is connected and suitable in regard to the motor power consumption.

The machine does not bevel : Check the bevelling tools condition and ensure that the pipe you are working does not require special bevelling tools due to its composition.

Always ask suggestions to your referent in G.B.C. as we are at your complete disposal.

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