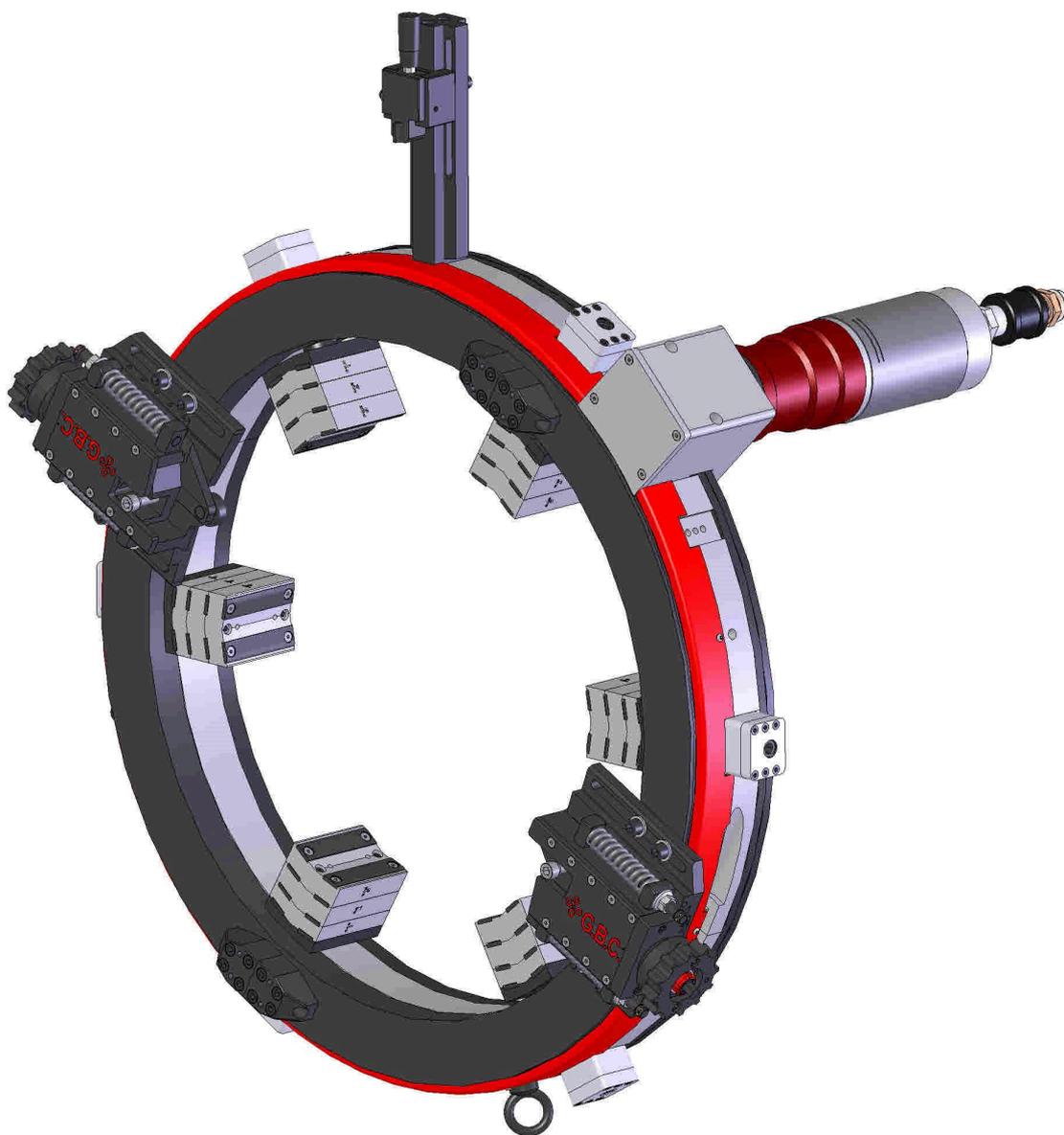




## INSTRUCTION MANUAL



# FAST06"-36"

**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



# *FAST 06"-36"*

Original Instructions — rev.2016—In compliance with the § 1.7.4  
Of the Machine Directive 2006/42/CE



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Declaration of Conformity (Attachment)

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## ***FAST 06"-36"***

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# **PRELIMINARY INFORMATION**

This Manual is supplied with the machine it pertains to. The customer may apply for additional 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 corporates is strictly forbidden unless our prior approval to do so is obtained.

**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.

*Always refer to the machine identification tag.*

For further information call or send a fax to the numbers below:

**Tel. +39 - 030 -7451154**

**Fax +39 - 030 – 7356629**

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

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## *FAST 06"-36"*

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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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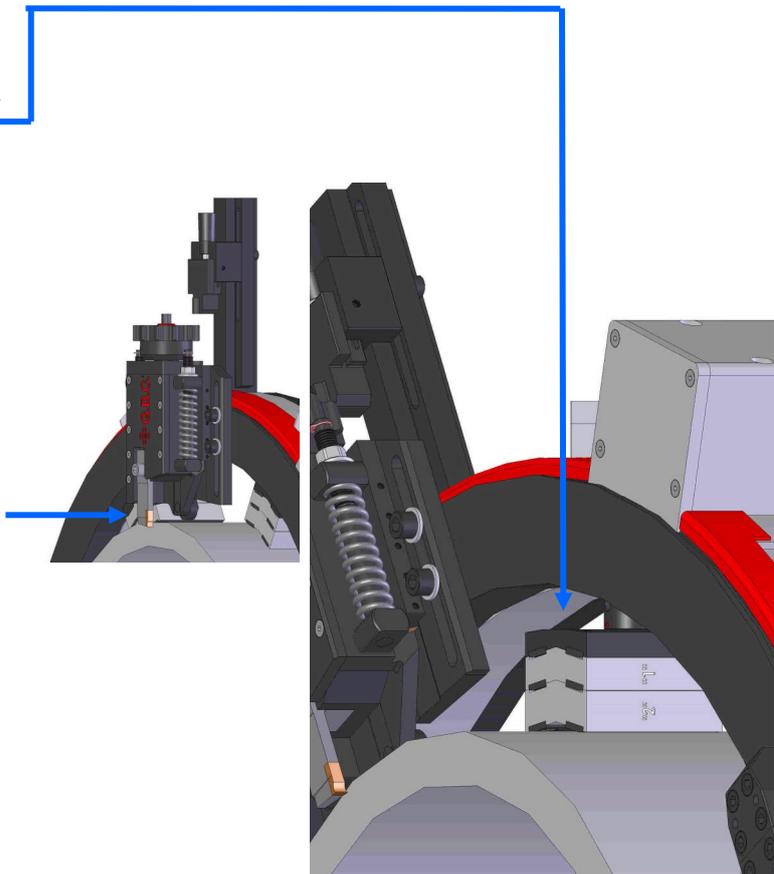


## INTENDED USE OF THE MACHINE

The pipe cutting and beveling machine model FAST is designed for cutting and beveling pipes with OD included between 168.3mm up to 914.4mm and a wall thickness of **60mm** made of any kind of steel.

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

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



THE MACHINE CAN BE USED ONLY BY SPECIALIZED OPERATORS WHO HAVE BEEN DULY TRAINED AND EDUCATED TO WORK WITH IT.

THERE IS NO SPECIFIC WARNING FOR MISUSE AGAINST DULY TRAINED OPERATORS.



## *FAST 06"-36"*

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# INTENDED USE OF THE MACHINE

- All the setting and maintenance operations shall be executed only when the machine is switched off and disconnected from the power supply, whichever it is.
- The maintenance work shall be executed by qualified and trained personnel only.
- Pay particular attention during the tooling replacement as you may accidentally cut yourself or bruise yourself.
- Do not get up close to the machine while it is running.
- Hand feeding the tools shall only be carried out when the machine is switched off.
- When possible the tools shall be lubricated with the specific cutting oil or cooling lubricant.
- The machine shall be operated only after having made sure it is safely and firmly clamped to the pipe OD.
- Using the machine differently than above stated is considered improper use, therefore **G.B.C. Industrial Tools S.p.A.** declines any responsibility to eventual damages sustained by individuals and properties when not operating under the above conditions.

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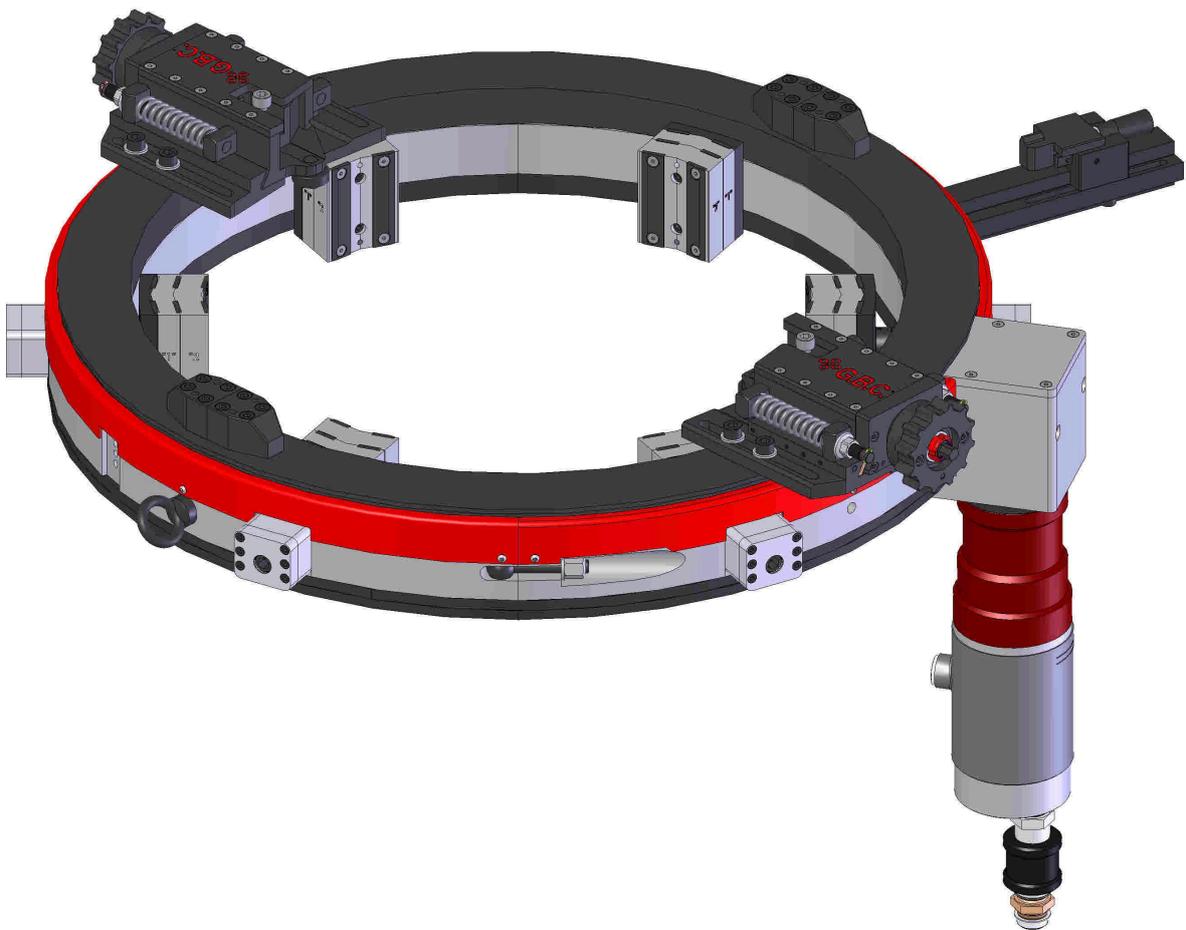
# *FAST 06"-36"*

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## **FAST MODELS**

### *PNEUMATIC*



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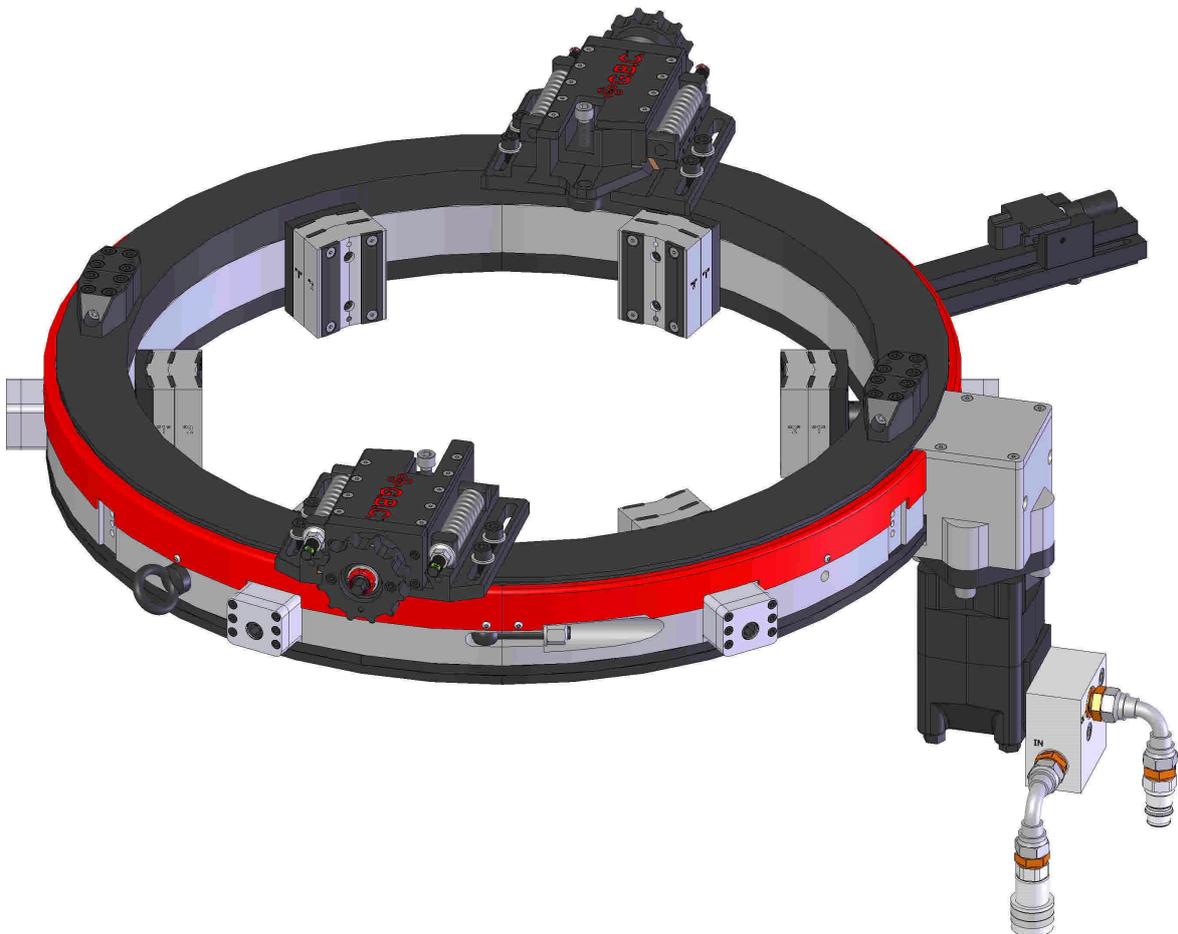


# *FAST 06"-36"*

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## HYDRAULIC



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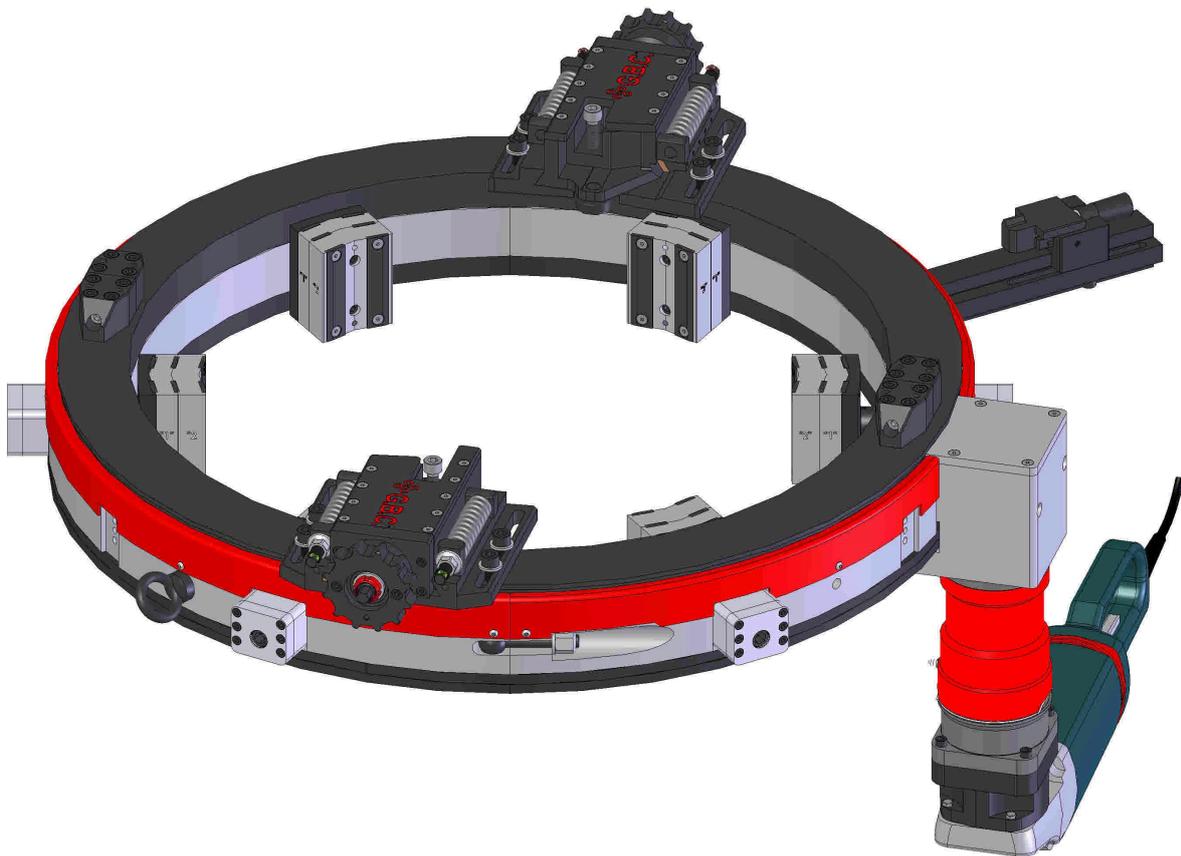


# ***FAST 06"-36"***

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## ***ELECTRIC***

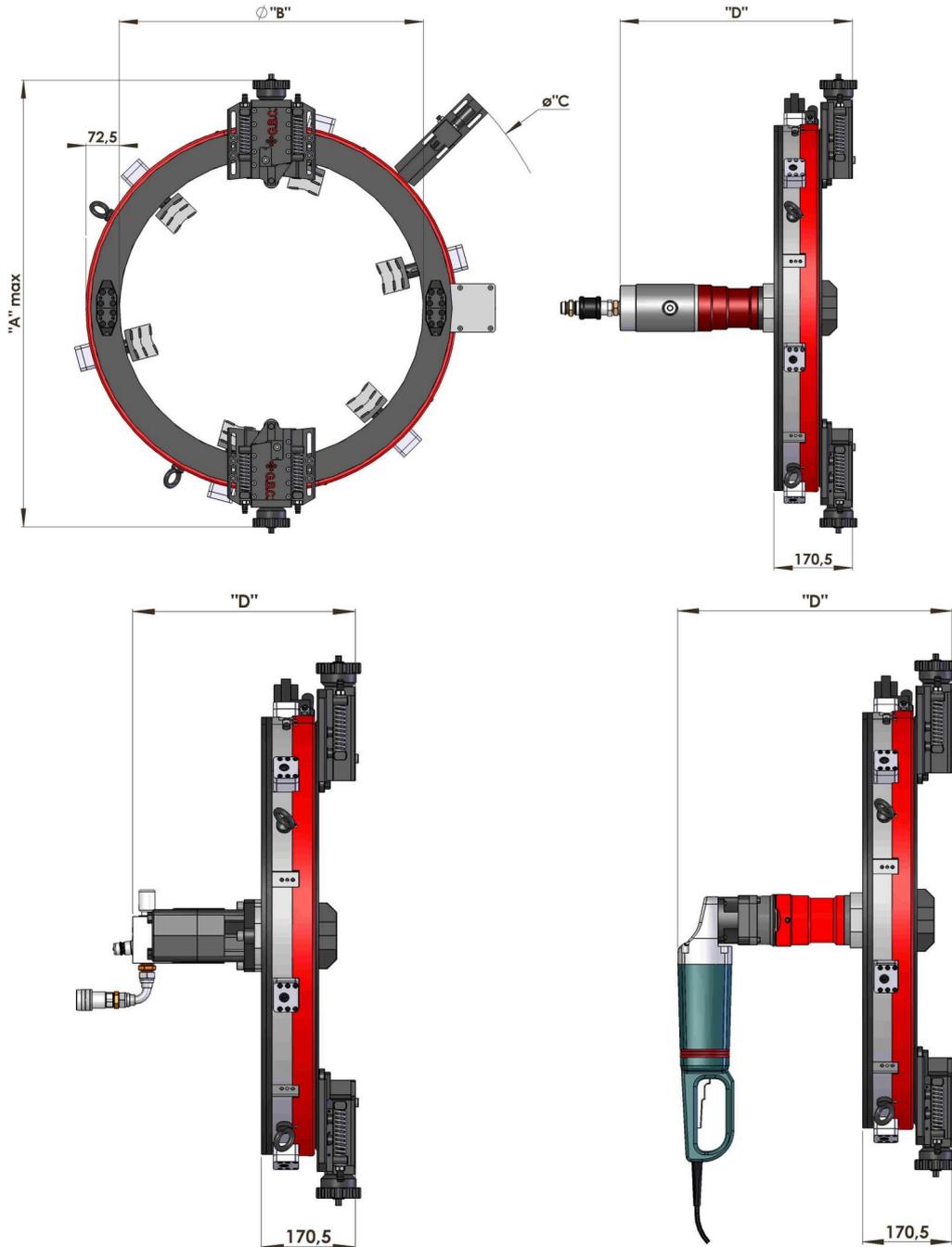


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## DIMENSIONS





<i>Modello</i>	<i>Aliment.</i>	<i>Range "</i>	<i>"A" (mm)</i>	<i>"B" (mm)</i>	<i>"C" (mm)</i>	<i>"D" (mm)</i>
<b>FAST 06"</b>	Pne.	<b>06"-12"</b>	<b>760</b>	<b>379</b>	<b>1000</b>	<b>506</b>
	Eletr.					<b>425</b>
	Hyd.					<b>430,5</b>
<b>FAST 12"</b>	Pne.	<b>12"-18"</b>	<b>907</b>	<b>510</b>	<b>1130</b>	<b>506</b>
	Eletr.					<b>425</b>
	Hyd.					<b>430,5</b>
<b>FAST 18"</b>	Pne.	<b>18"-24"</b>	<b>1059</b>	<b>660</b>	<b>1280</b>	<b>506</b>
	Eletr.					<b>425</b>
	Hyd.					<b>430,5</b>
<b>FAST 24"</b>	Pne.	<b>24"-30"</b>	<b>1217</b>	<b>817</b>	<b>1440</b>	<b>506</b>
	Eletr.					<b>425</b>
	Hyd.					<b>430,5</b>
<b>FAST 30"</b>	Pne.	<b>30"-36"</b>	<b>1375</b>	<b>967</b>	<b>1590</b>	<b>506</b>
	Eletr.					<b>425</b>
	Hyd.					<b>430,5</b>



# FAST 06"-36"

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## TECHNICAL FEATURES

		<b>FAST 06-12</b>	<b>FAST 12-18</b>	<b>FAST 18-24</b>	<b>FAST 24-30</b>	<b>FAST 30-36</b>
<b>Locking Range</b>	mm (inches)	152 - 327 (5.9"-12.8")	295 - 460 (11.6"-18.1")	445 - 609 (17.5"-24.0")	600 - 770 (23.6"-30,3")	750 - 914 (29.5"-36.0")
<b>Toolbox Stroke</b>	mm (inches)	60 (2.36)	60 (2.36)	60 (2.36)	60 (2.36)	60 (2.36)
<b>Feeding Pitch</b>	mm (inches)	0.104 (0.004)	0.104 (0.004)	0.104 (0.004)	0.104 (0.004)	0.104 (0.004)
<b>Weight</b>	Kg	110	130	150	170	190
<b>PNEUMATIC</b>						
<b>Motor Power</b>	Hp (W)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)
<b>Air Consumption</b>	Nl/min (cfm)	2800 (99)	2800 (99)	2800 (99)	2800 (99)	2800 (99)
<b>Air Pressure Req.</b>	bar (psi)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)
<b>Max Torque</b>	Nm	650 (6bar) 1216 (8bar)	820 (6bar) 1534 (8bar)	1010 (6bar) 1889 (8bar)	1210 (6bar) 2262 (8bar)	1398 (6bar) 2614 (8bar)
<b>Speed ( unloaded )</b>	gg/min (rpm)	21	17	14	12	10
<b>ELECTRIC</b>						
<b>Motor Power</b>	W	2400	2400	2400	2400	2400
<b>Tension</b>	Volt	230	230	230	230	230
<b>Frequency</b>	Hertz	50	50	50	50	50
<b>Max Torque</b>	Nm	865	1090	1340	1609	1860
<b>Speed ( unloaded )</b>	gg/min (rpm)	19	16	12	10	9
<b>HYDRAULIC</b>						
<b>Motor Power</b>	HP (kW)	6.79 (5)	6.79 (5)	6.79 (5)	6.79 (5)	6.79 (5)
<b>Hydraulic Power Pack Max Pressure</b>	bar (psi)	180 (2610)	180 (2610)	180 (2610)	180 (2610)	180 (2610)
<b>Oil Flow</b>	l/min. (cfm)	30 (1.06)	30 (1.06)	30 (1.06)	30 (1.06)	30 (1.06)
<b>Maximum Torque</b>	Nm	1453	1830	2257	2702	3951
<b>Speed ( unloaded )</b>	gg/min (rpm)	23	18	14	11	9

The measurement of the acoustic emissions was executed with a phonometer and calibrator LAT

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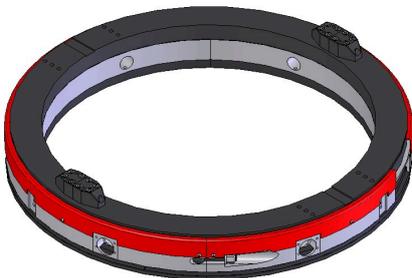
# FAST RANGE 06-36 STANDARD EQUIPMENT

(Pneumatic - Electric - Hydraulic)

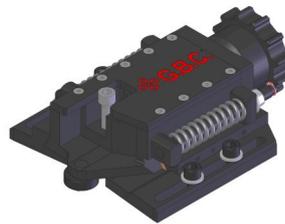
Every machine is supplied with the following equipment:

- 1 Striker Assembly
- 2 Toolboxes
- Cooling Water Flask
- Cut Positioner
- 4 Locking Pads (06")
- 6 Locking Pads (12"-30")
- Drive Assembly
- Service Tools

Ring



Toolbox (x2)

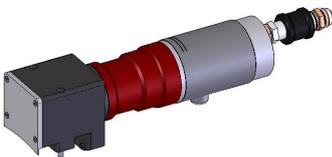


Locking Pads  
(4 or 6)

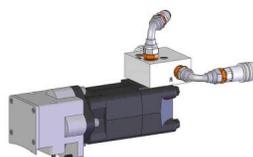


Drive Assembly

Pneumatic



Hydraulic



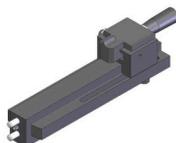
Electric



Service Tools



Striker Assmebly



Wooden Storage Box



Instruction Manual  
and Drawings



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## ***FAST 06"-36"***

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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 in case of misuse of the machines and their use in contrast with the regulations listed hereinafter and with the use and maintenance instructions hereto.

- Read carefully ALL the following regulations and the instructions herewith attached before starting any operation.
- Ensure that the operator and the foreman operating the machine are fully aware of all the regulations and instructions and that they are qualified to operate the unit.
- Strictly attain to the indications given by the international symbols applied on the machines and/or its packaging.
- Do not perform any maintenance operation when the machine is plugged to the power supply.
- Before every use ensure the power supply connections are in conformity with the specs given by this manual.

The authorized operator shall not in any circumstance disregard the basic safety rules such as:

- Using the required PPE (gloves, goggles and steel toe shoes).
- Provide proper illumination of the working area.
- Do not replace the control system and or use non original spare parts.
- Do not project violent water jets on the machine.
- Maintain an adequate distance from the machine during its functioning.

G.B.C. Industrial Tools S.p.A remarks that for any non specified circumstances it is necessary to obtain the authorization of the manufacturer.

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With a proper use of the PPE, the residual risks are generated by the user's system and not by inborn defects of our machines.

1. Gloves and goggles must be used during every operation.
2. Any setting or inspection of the machine must be performed only with the unit unplugged from the power source.
3. The instruction manual and the drawings will provide the necessary explanation for every operation.



## **TRANSPORT RECOMMENDATIONS**

Weight of the Machine	Kg	Min 110 Max 190
Shipping Dimensions	mm	Min 860 x 640 x 470 Max 1250 x 1300 x 470
Shipping Weight	Kg	Min 130 Max 250



## **MACHINE STABILITY**

The machine must be lifted **EXCLUSIVELY BY THE EYEBOLTS** as shown in the picture below.



Do not try to remove swarfs or shavings with bare hands. Always use a suitable tool. Do not use hooks of any sort.

## **WORKPLACE**

For setting the hydraulic unit use the wired remote control onboard the hydraulic power pack.

For setting the pneumatic version use the pneumatic valve located on the pneumatic motor housing.

## **EMERGENCY STOP**

For the hydraulic version the emergency stop is located on the wired remote control of the hydraulic power pack and it is a red mushroom shaped button.

For the pneumatic version the emergency stop is achievable by closing the pneumatic valve located on the pneumatic motor casing.



## **MACHINE SETUP**

Measure the pipe OD





Choose the appropriate locking pad set from the chart below

**Fig.A**

P17644

Min.

Max.

**Fig.D**

P17644  
P1766301  
Q6750  
P17665 Q6755 Q7025 Q7715 P1766303 Q6755 P1766302

Min.

Max.

**Fig.B**

P17644  
P17665 Q6750 Q7715 Q7025 P1766301

Min.

Max.

**Fig.C**

P17644  
Q7025 P17665 Q6755 Q7715 P1766302 Q6750 P1766301

Min.

Max.

FAST 06"-12"					FAST 12"-18"				
Bloccaggio		Locking		Fig.	Bloccaggio		Locking		Fig.
Min	Max	Min	Max		Min	Max	Min	Max	
283.4	334.7	11.15	13.17	A	466.58	414.94	18.36	16.33	A
245.79	297.01	9.67	11.69	B	428.65	377.08	16.87	14.84	B
198.34	249.55	7.8	9.8	C	380.86	329.39	14.99	12.96	C
150.88	202.09	5.94	7.95	D	333.16	281.66	13.11	11.09	D

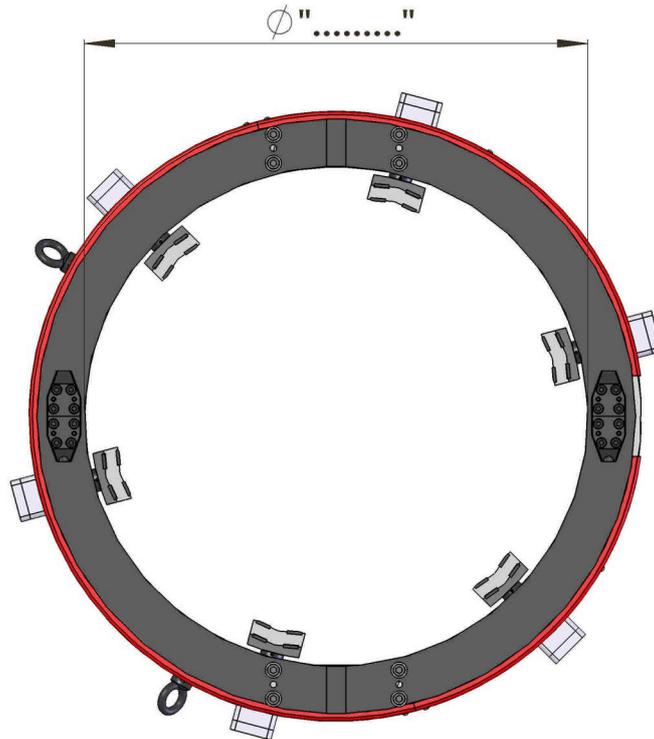
FAST 18"-24"					FAST 18"-24"				
Bloccaggio		Locking		Fig.	Bloccaggio		Locking		Fig.
Min	Max	Min	Max		Min	Max	Min	Max	
719.53	771.39	28.32	30.36	A	564.07	615.86	22.2	24.24	A
681.45	733.30	26.82	28.87	B	526.06	577.82	20.71	22.74	B
633.42	685.25	24.93	26.97	C	474.14	529.85	16.82	20.86	C
585.42	637.22	23.04	25.08	D	430	481.93	16.93	18.97	D

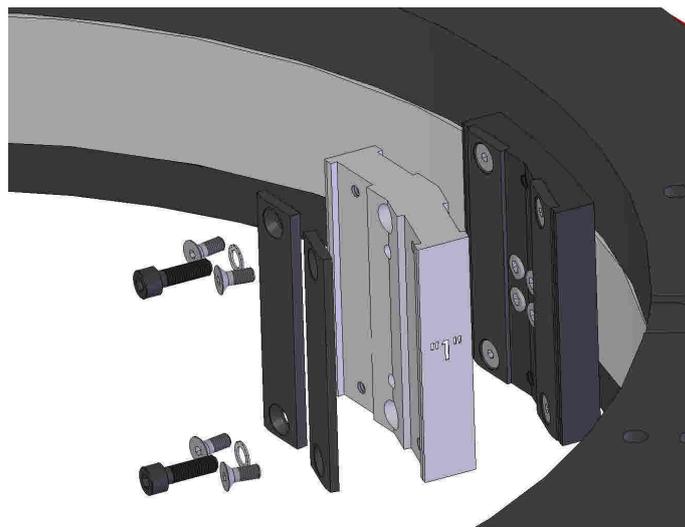
FAST 30"-36"				
Bloccaggio		Locking		Fig.
Min	Max	Min	Max	
869.18	921.09	34.21	36.26	A
681.45	733.3	32.71	34.76	B
633.42	685.25	30.82	32.86	C
585.42	637.22	28.93	30.97	D



Measure the internal diameter of the ring you are using a tape meter.



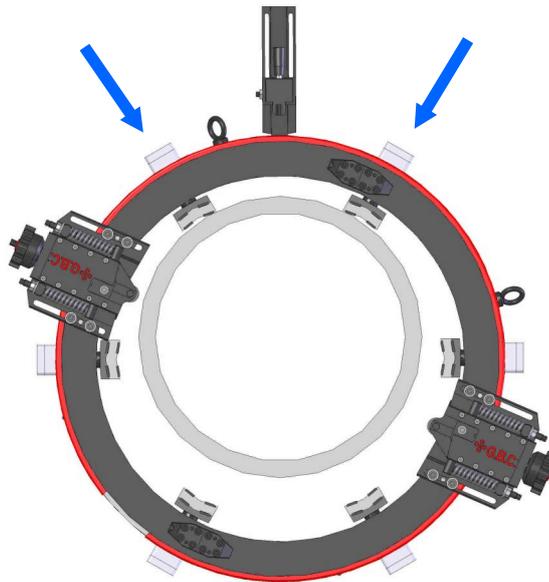
Install the selected set of locking pads as shown in the picture below.



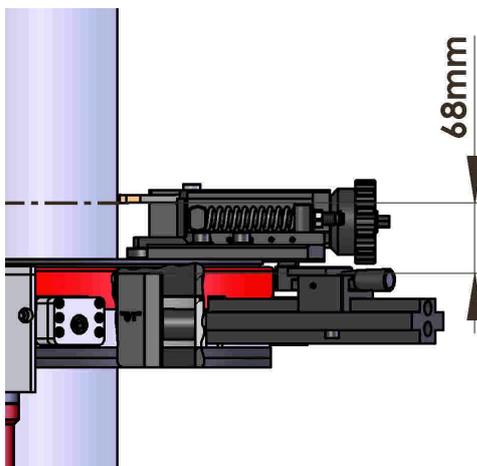


## Machine Positioning

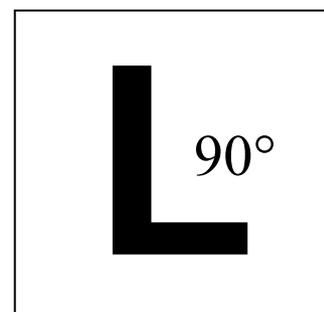
Place the machine on the pipe so that it sits on the upper locking pads



Slide the machine along the pipe axis until you reach the length you want to cut.  
The actual cut point can be located by measuring the distance of 68mm from the edge of the locking pads.

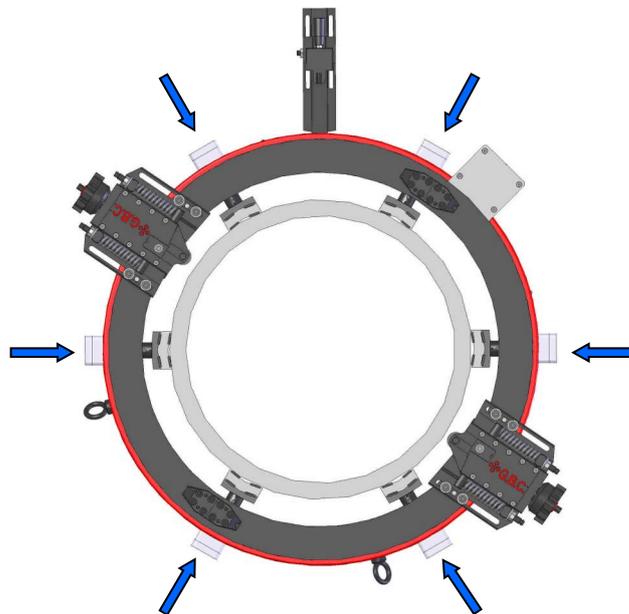
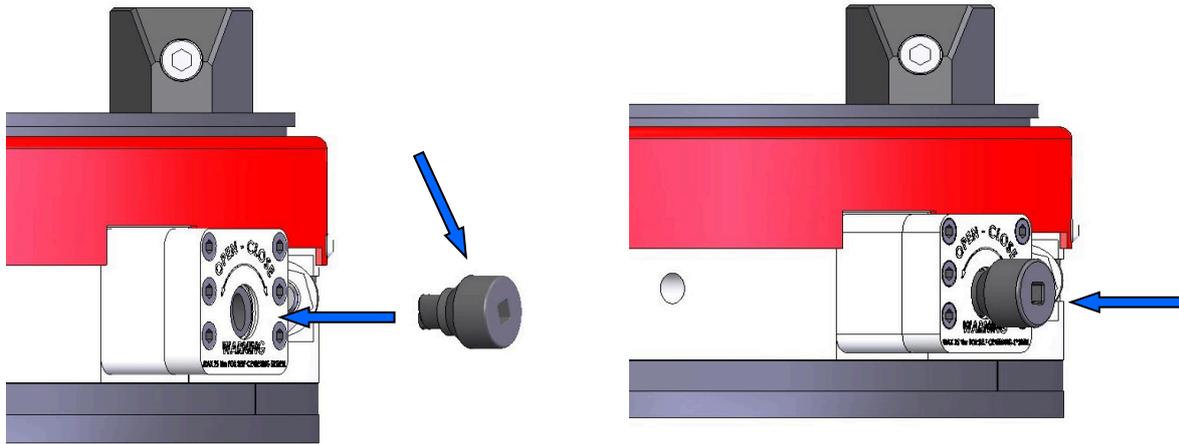


Make sure the machine is perpendicular to the pipe. The setting can be carried out by placing a square in correspondence to each locking pad making sure the square is evenly touching the pipe OD and the machine.





Insert the special socket in one of the locking blocks as shown in the pictures below.

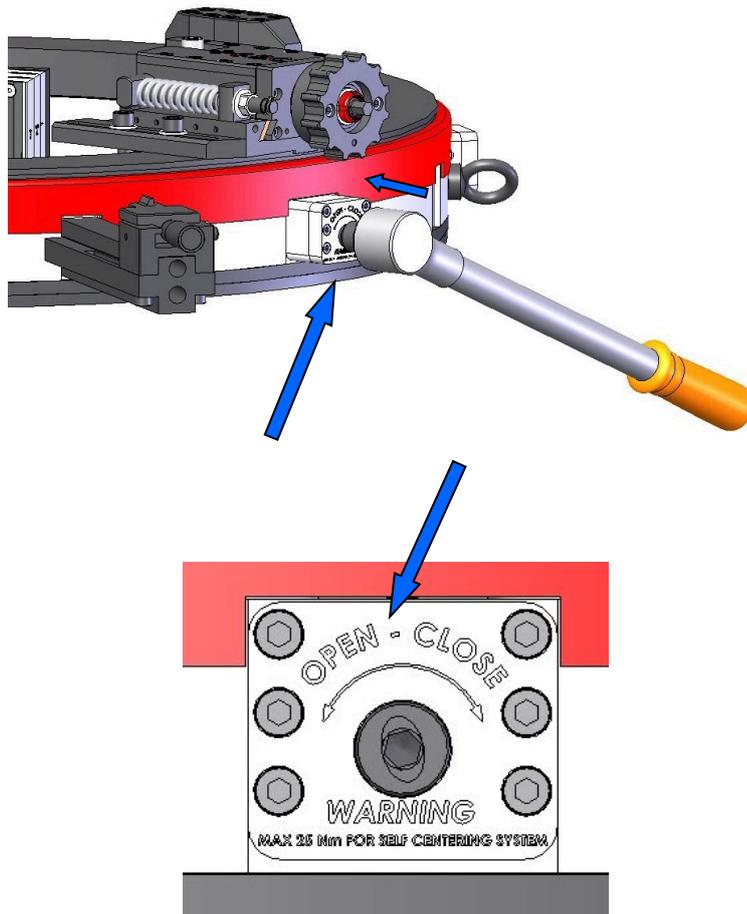




**N.B.!: THE PRELIMINARY LOCKING PHASE PURPOSE IS TO CENTER THE MACHINE TO THE PIPE THEREFORE THE OPERATOR SHOULD BE VERY CAREFUL TO NOT STRAIN THE DEVICE BY USING TOO MUCH FORCE IN THE PROCESS AS THE LOCKING SYSTEM MAY SUSTAIN DAMAGE.**

Insert the torque wrench in the locking system socket and turn the wrench in the direction indicated by the arrow printed on the socket cover until the wrench gauge indicates the reach of the maximum torque.

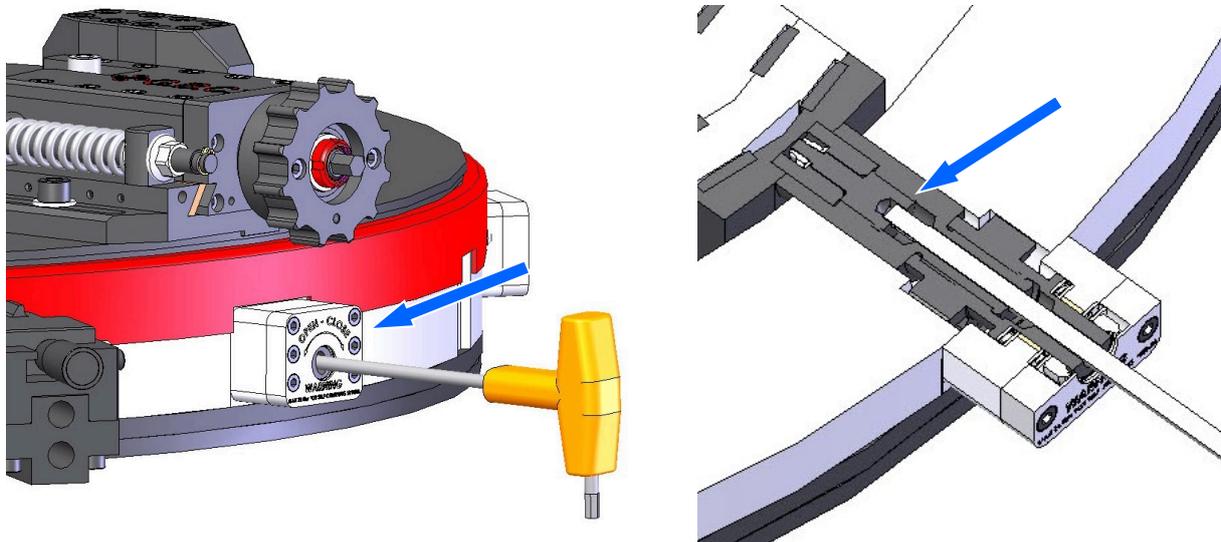
The machine is now centered to the pipe.





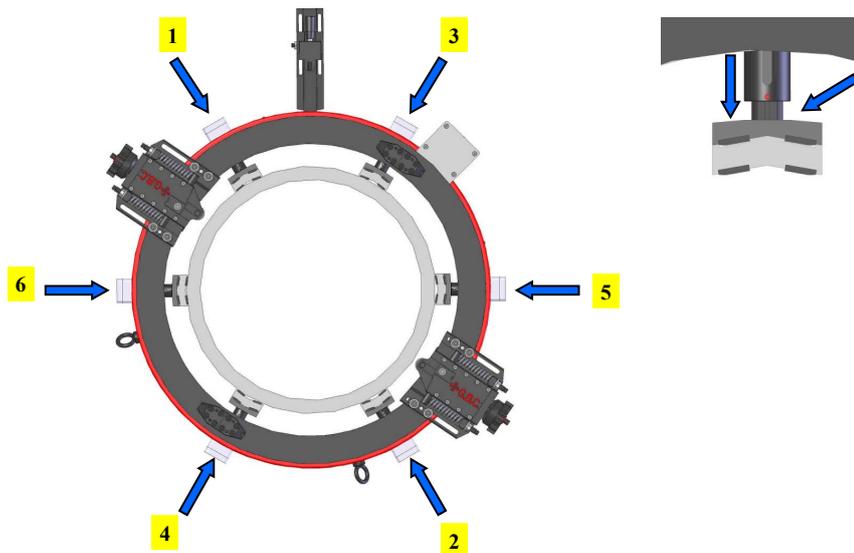
The actual locking procedure can now be carried out by inserting the hexagon key wrench inside every single locking block reaching the inner screws and fastening them tightly,

**N.B. This locking procedure shall be carried out following the tightening pattern as shown in the drawing below.**



**N.B. THIS IS THE MAIN LOCKING PROCEDURE THROUGH WHICH THE MACHINE WILL BE DULY FIXED ON THE PIPE OD.**

**TIGHTENING  
PATTERN**

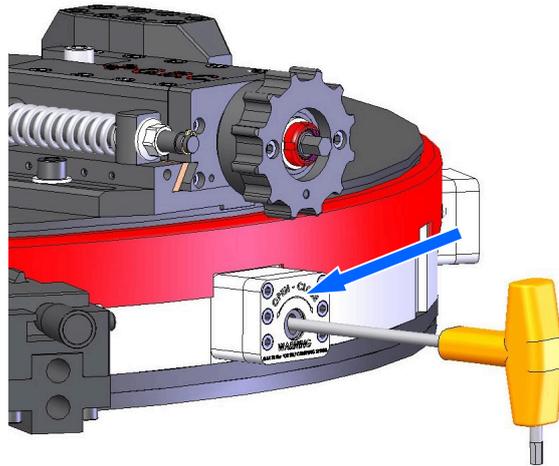


**G.B.C. Industrial Tools S.p.A.**

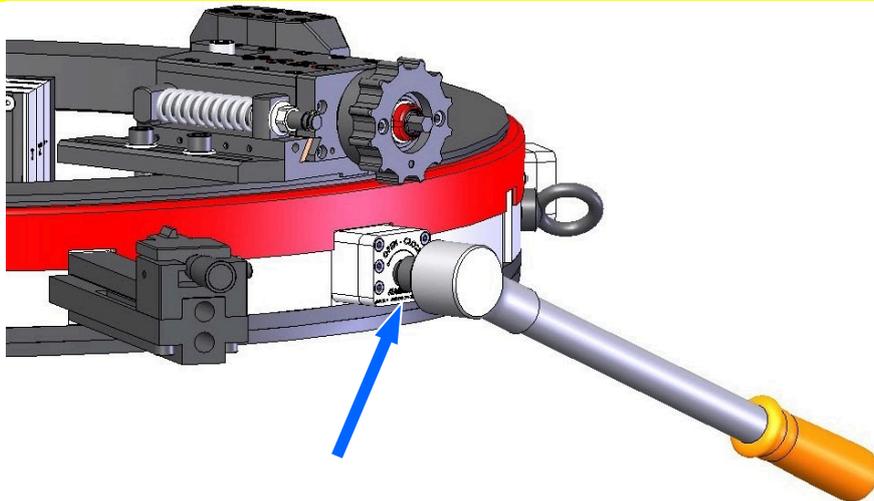
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**UNLOCKING PROCEDURE**

**WARNING:** For a correct unlocking procedure the operator will have to simply perform the procedure **in reverse** as shown in the picture below.



**FIRST OPERATION:** Insert the Allen key **in every single locking block** and unscrew all the internal locking screws making sure that every one of them is unscrewed **all the way back**.

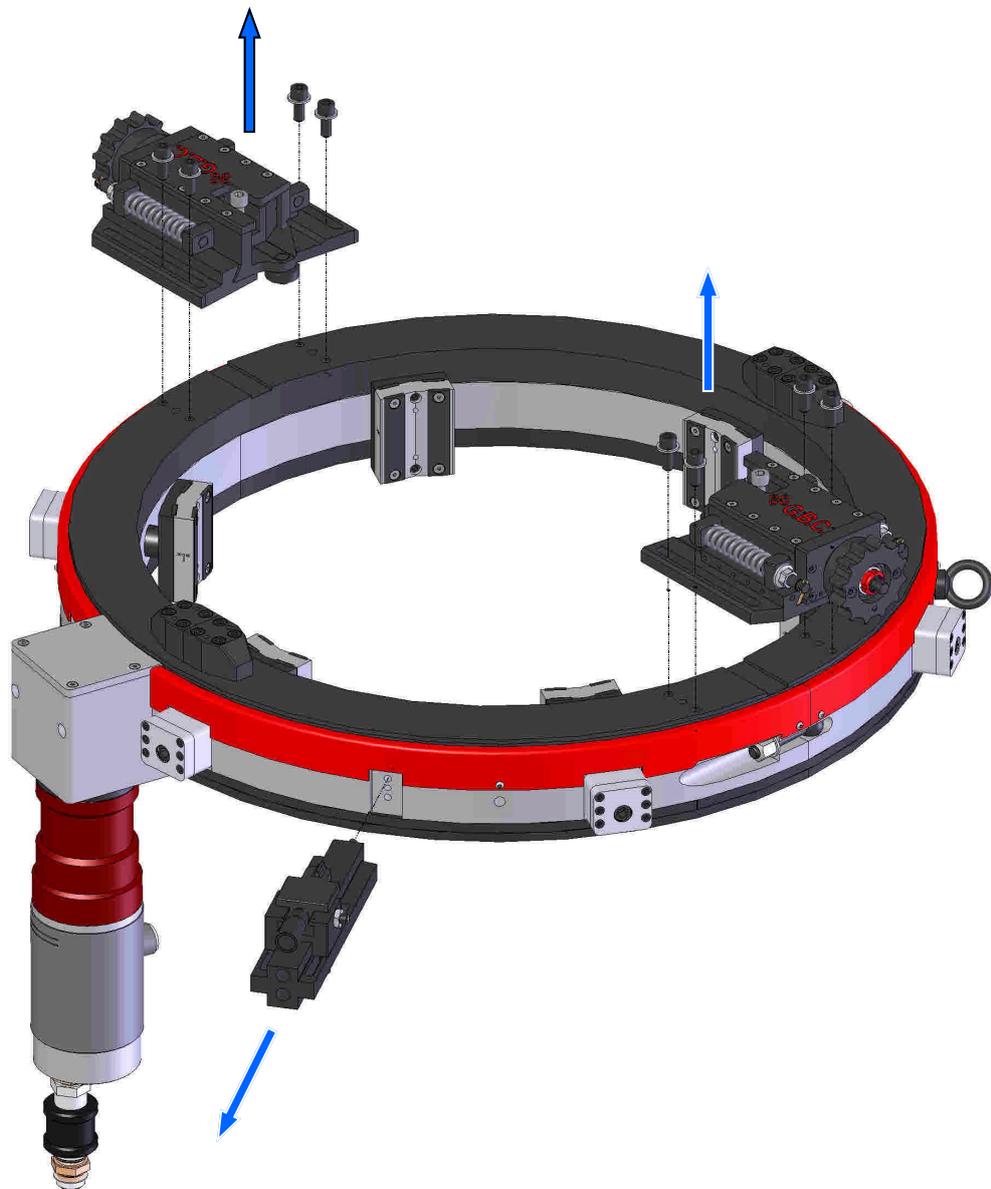


**SECOND OPERATION:** Insert the torque wrench in any locking block and turn it in the direction of the arrow indicating "OPEN".



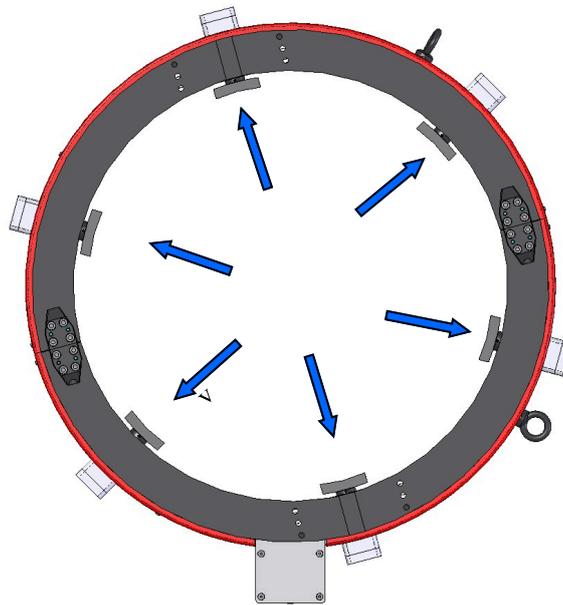
## **OPENING THE MACHINE** *(In case of Pipeline Maintenance)*

Remove the toolboxes and the Striker Assembly before proceeding any further.

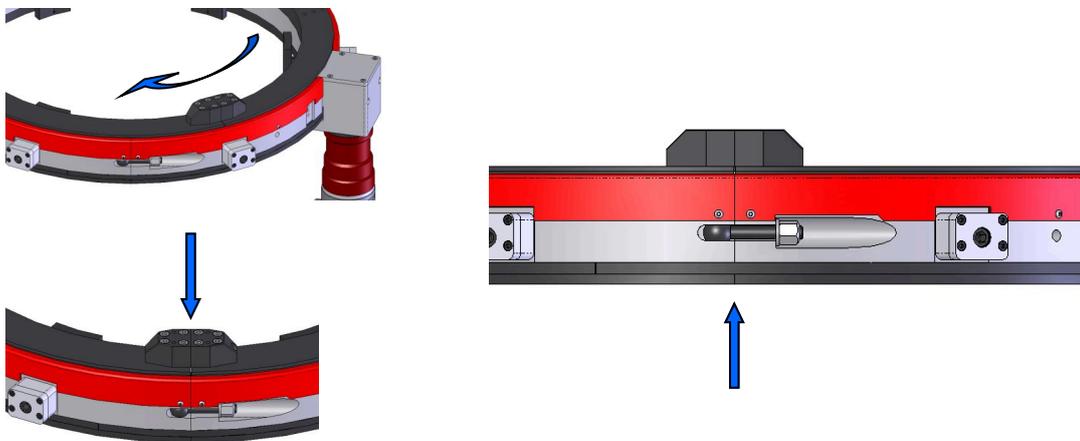




Withdraw the locking pads as much as possible.

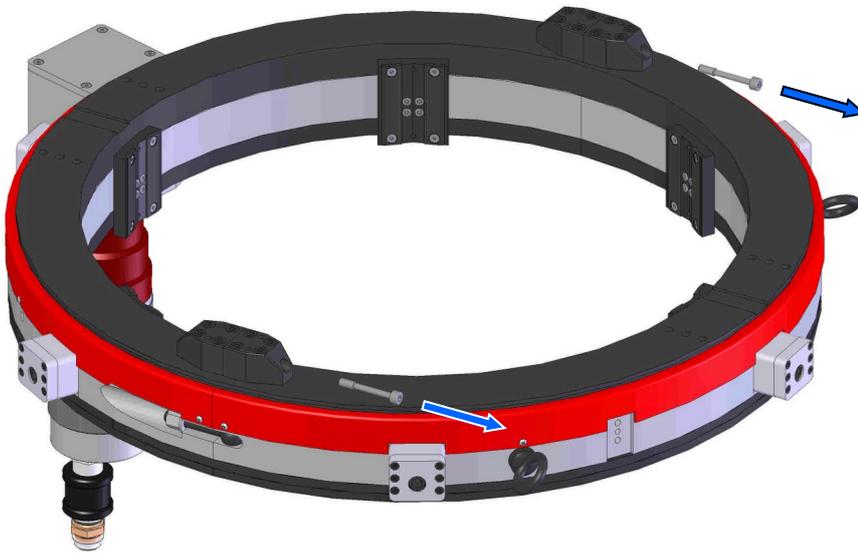


Rotate the crown of the machine until the seam of the two halves matches the seam of the machine red/gray casing as shown in the below pictures.

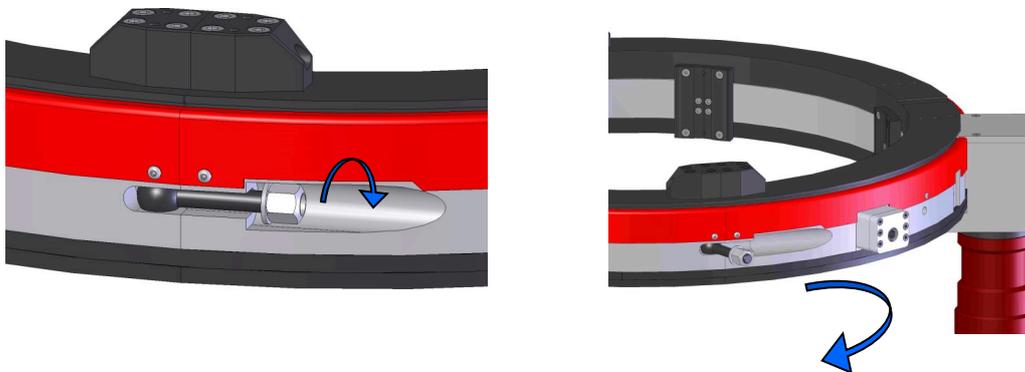




Unscrew and remove the locking screws

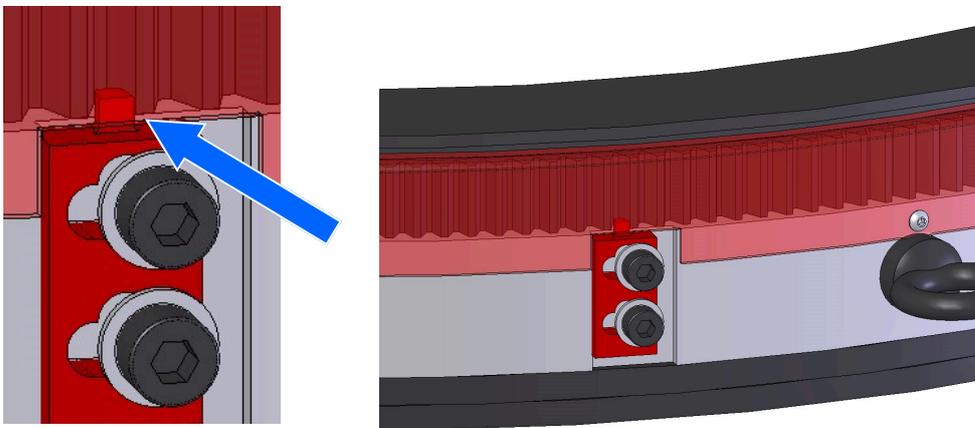


Loose the nuts of the tie rods located on both sides of the lower part of the casing.

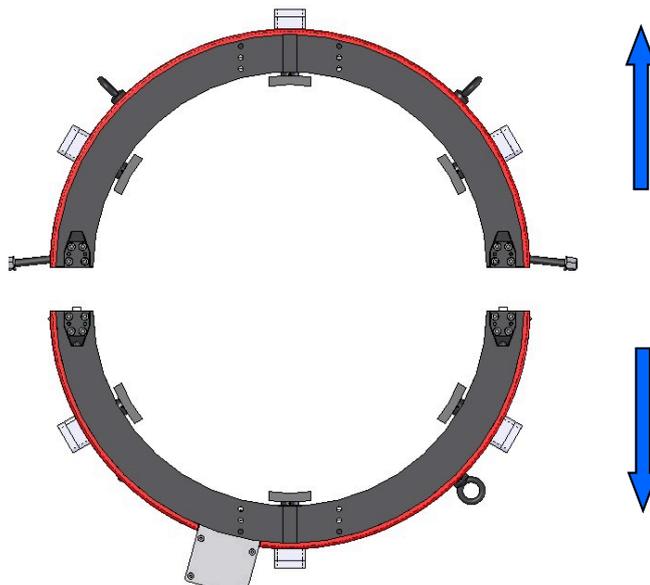




Place the CROWN STOPS in the notches located on each half making sure it sits right in between two teeth of the crown to prevent any movement.

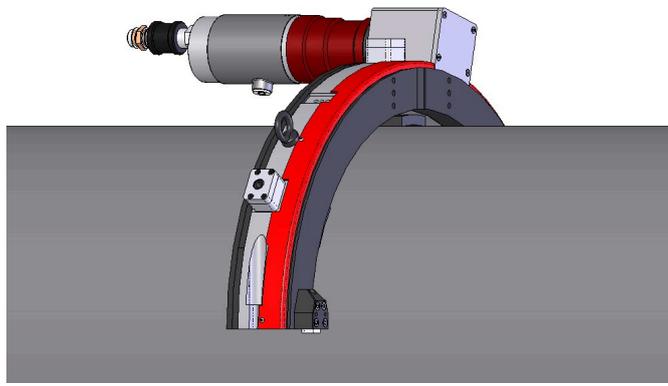


Now you can split the machine

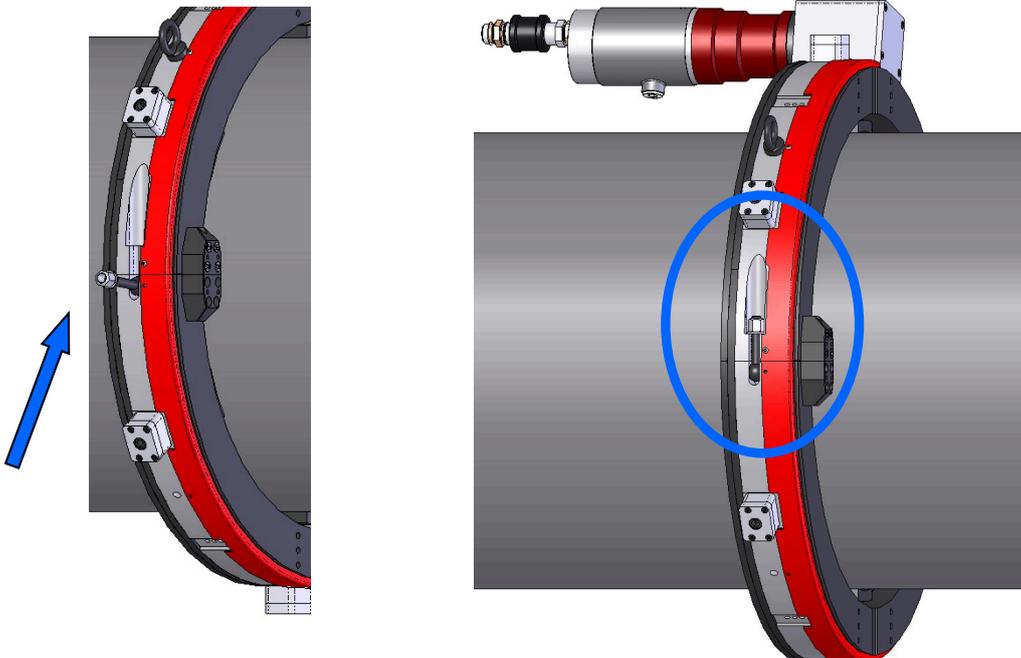


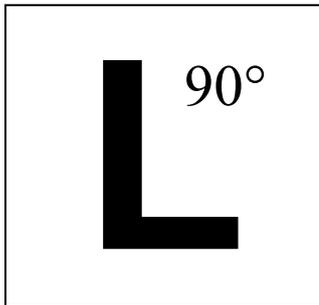


Position the first half of the machine onto the pipeline



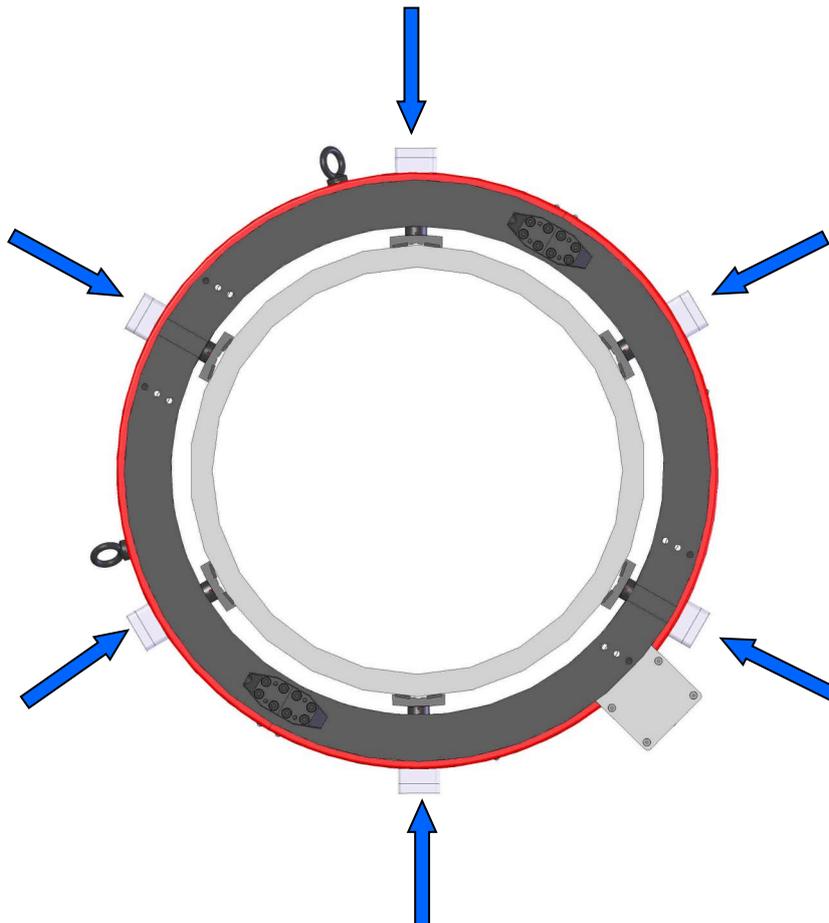
Position the second half and join the two halves by fastening the locking nuts  
loosen previously.





Make sure the machine to be perpendicular with the pipe using a square placed on the back of the machine in correspondence with every locking pad.

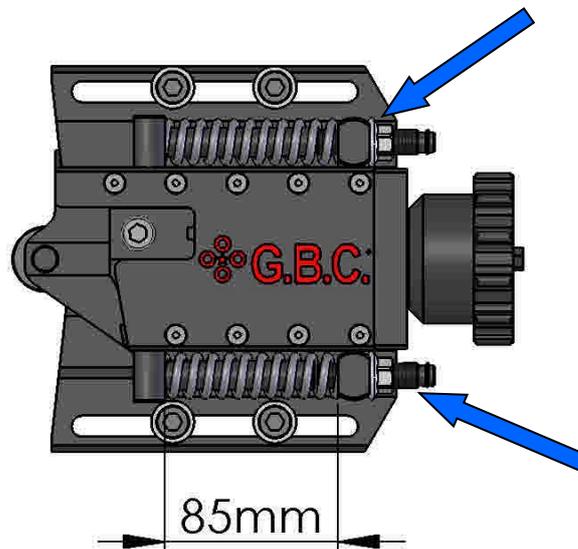
Fasten the locking pads as described from page 17 to.22



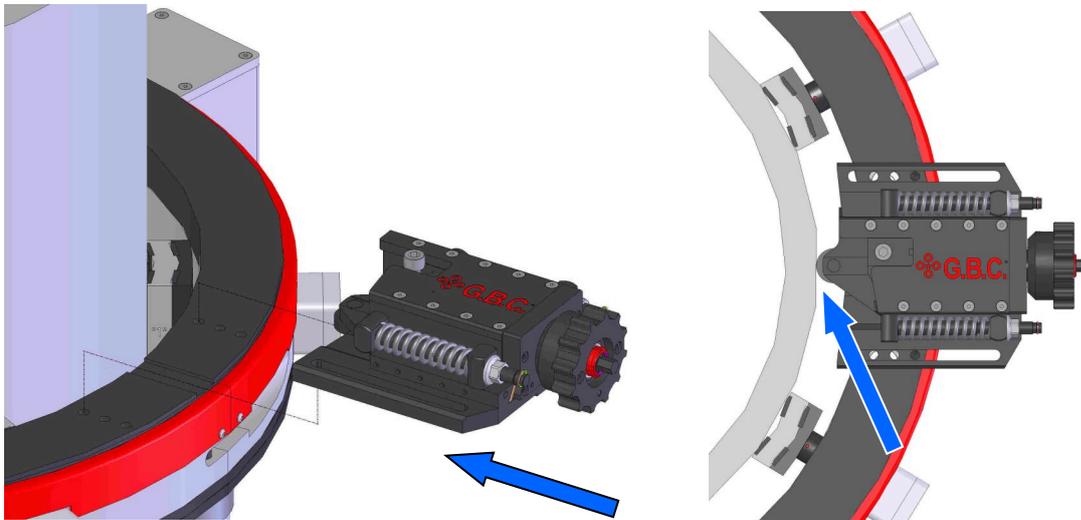


## TOOLBOXES MOUNTING

Adjust the toolbox springs to a length of 85mm by acting on the nuts located on the upper side of the assembly.

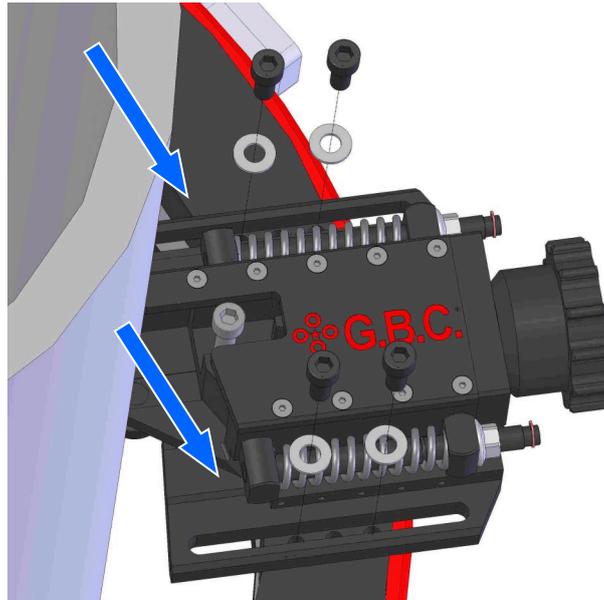


Install the toolboxes sliding them on the guiding grooves of the crown until the copier bearing touches the pipe OD.

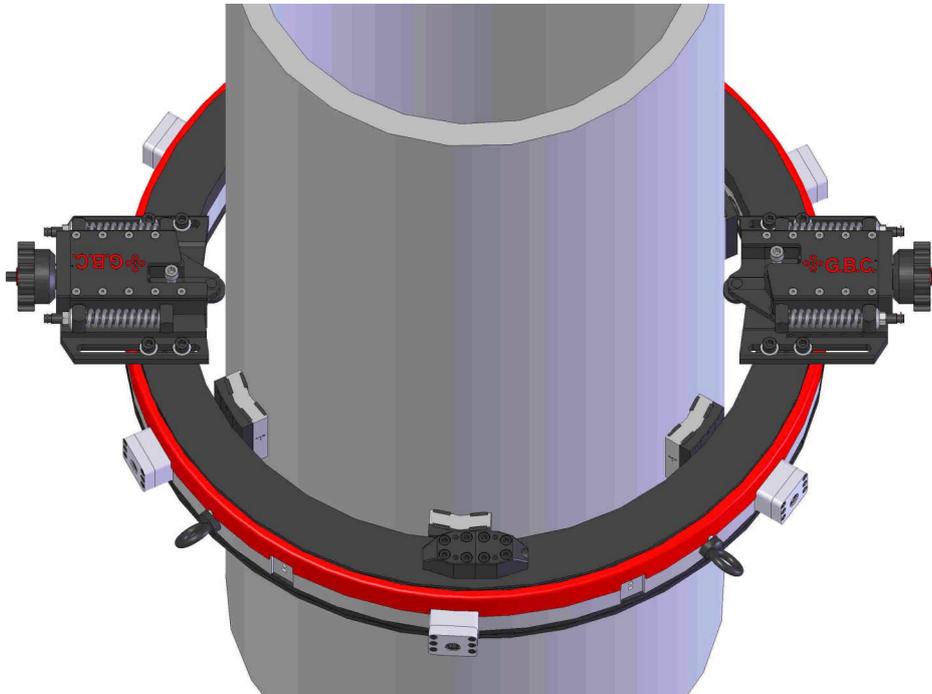




Secure the toolbox with the washers and screws which are part of the assembly.



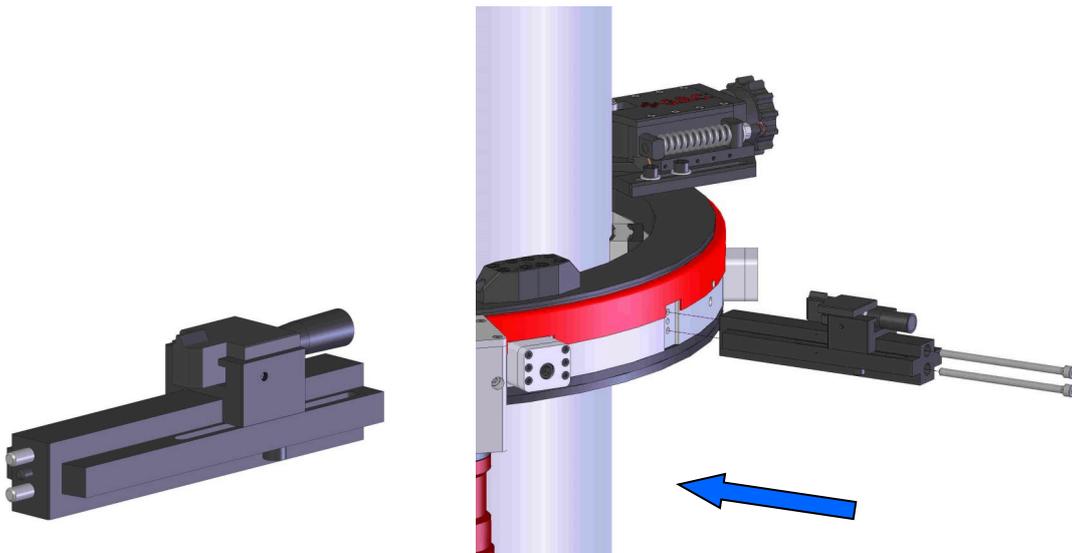
***NB: The machine must be used with 2 toolboxes installed.***



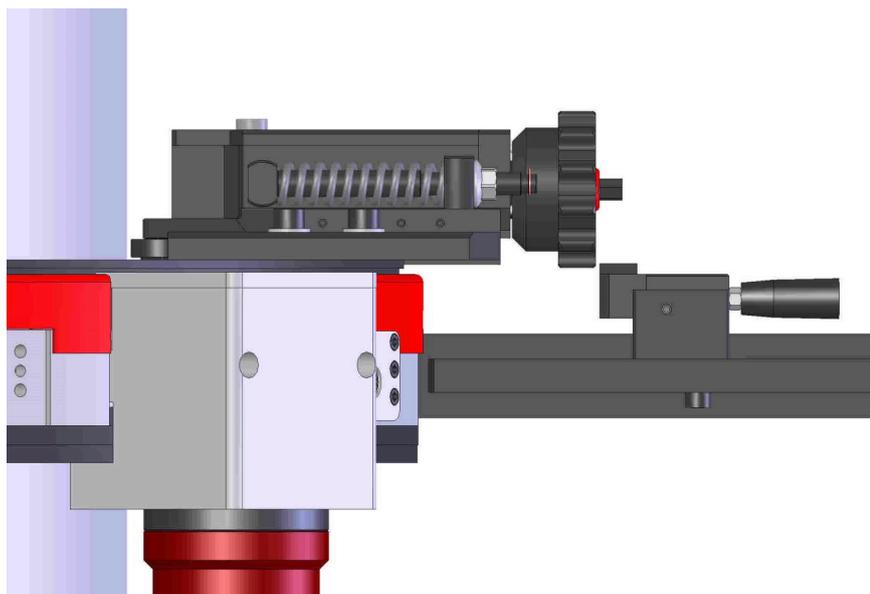


## **STRIKER ASSEMBLY INSTALLATION**

Position the Striker in its seat located on outer side of the machine using the screws part of the assembly.

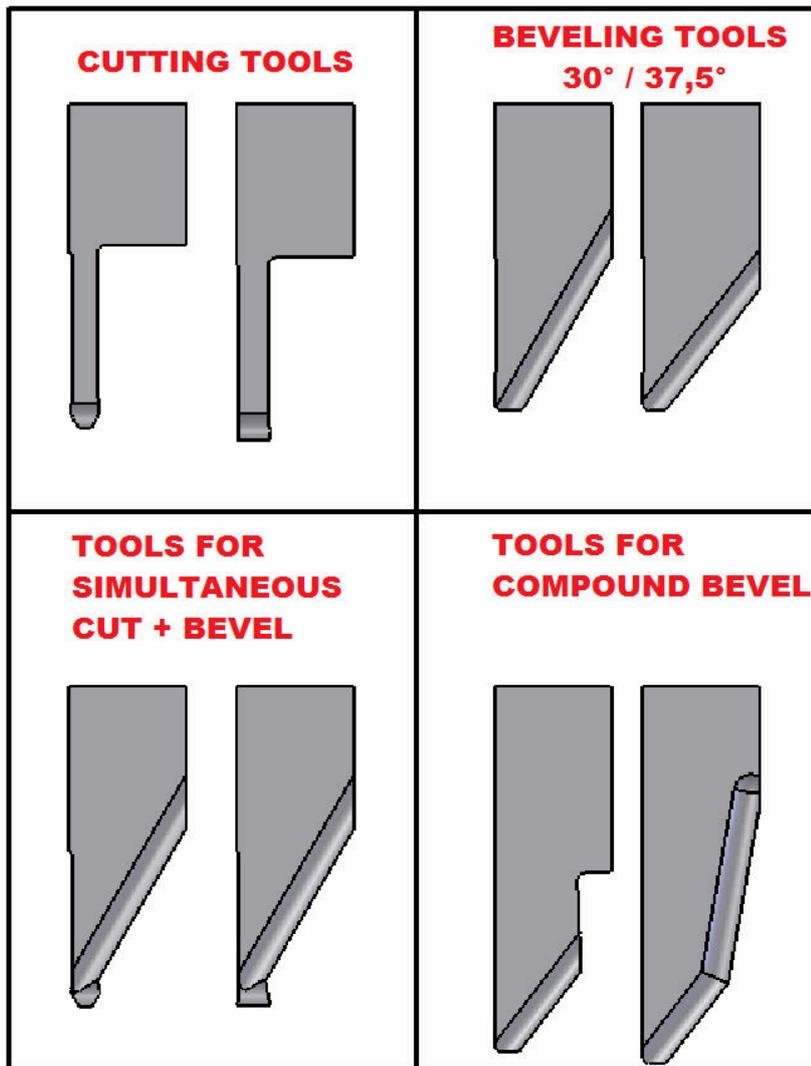


Install the Feeding Lever in the position required based upon the specific outside diameter of the pipe to be worked.





## Standard Tools



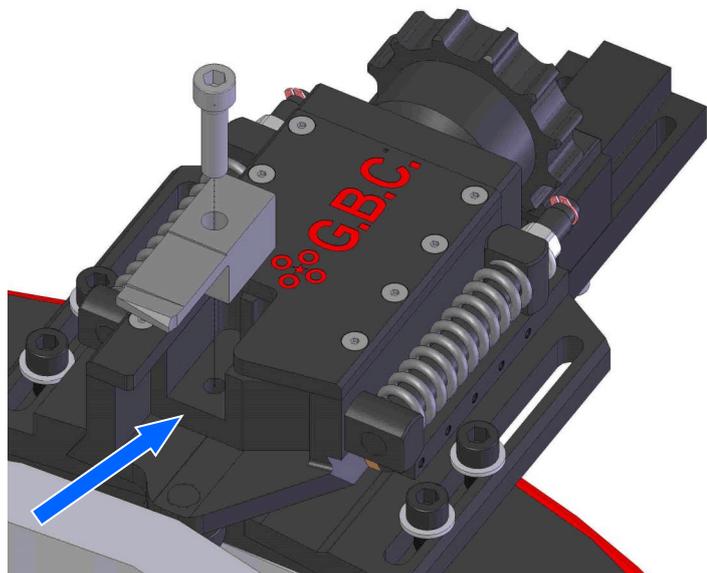
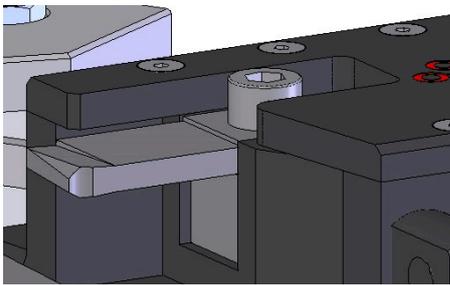
N.B. In the majority of cases the tools have to be used in couples:  
The FAST model can equip 4 typologies of tools each one for a different working purpose:

Cutting Tools  
Cutting + Beveling Tools  
Beveling Tools  
Beveling Tools for Compound Bevel

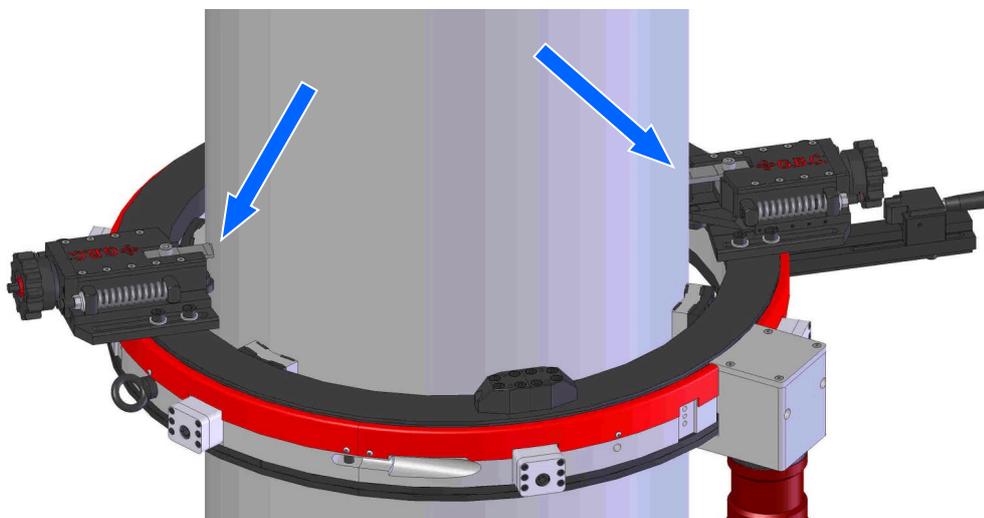


## TOOLS INSTALLATION AND POSITIONING

After you have selected the correct couple of tools install the first one on the toolbox. To do so you will have to slide the tool in its seat and secure it in place with the fixing screw as shown in the below pictures.

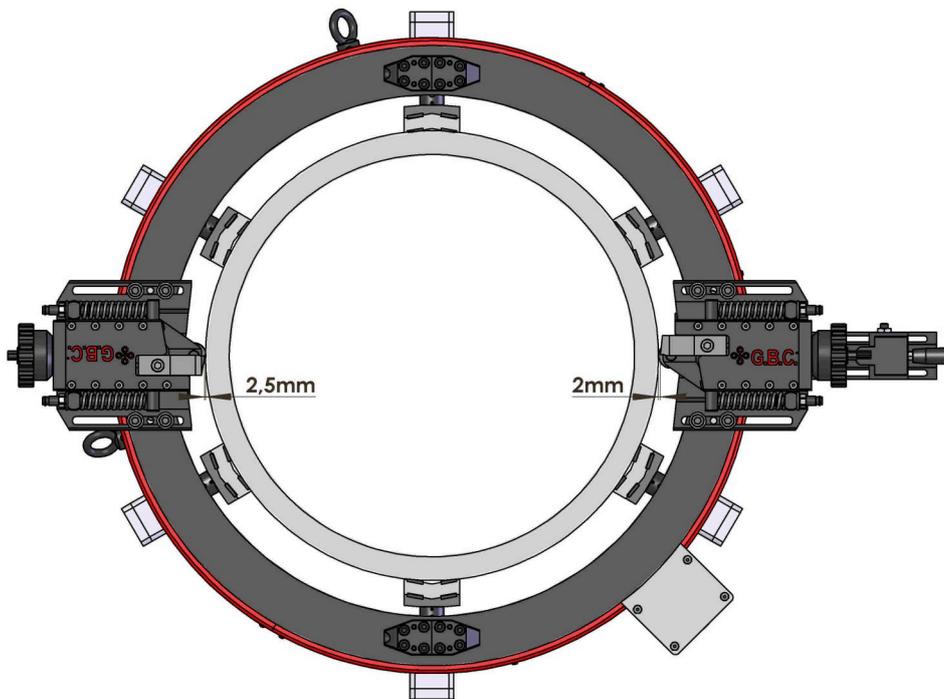
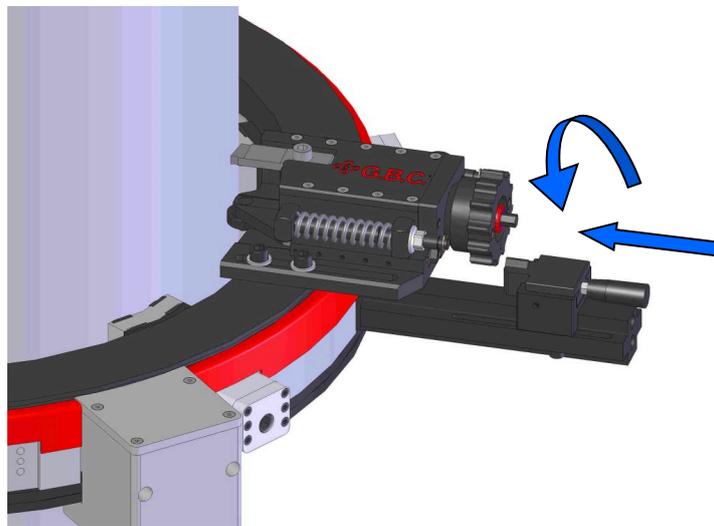


Follow the very same procedure for the second tool which will have to work in combination with the one you have just installed.





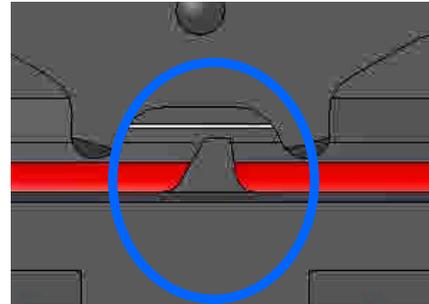
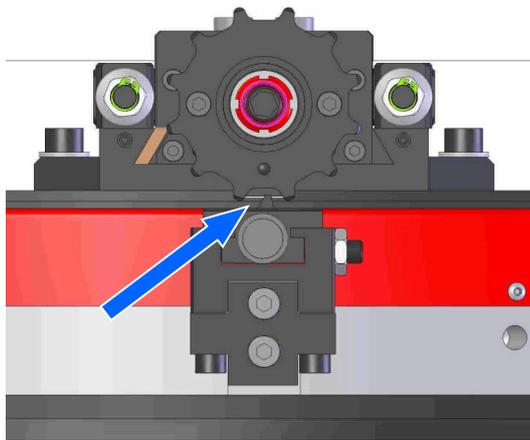
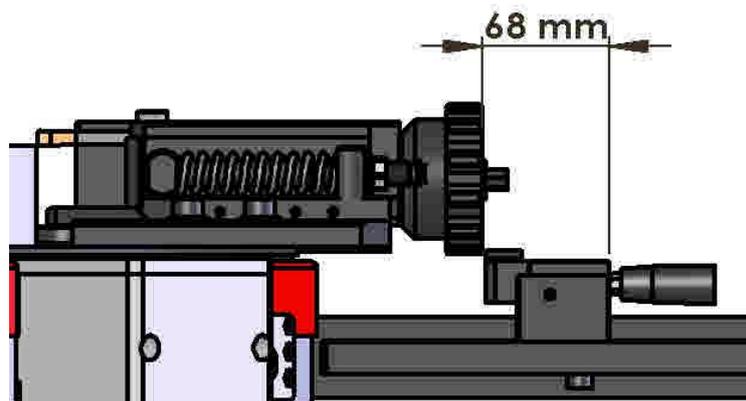
By manually turning the star wheel of the Tool Boxes move the tools towards the pipe OD until they respectively reach the distance of 2mm with the FORWARD TOOL and 2.5mm for the BACKWARD TOOL







Position the Feeding Pin in axis to the Star Wheel.  
You want to make sure that the Feeding Pin hits the Star Wheel on every rotation.

**STAR WHEEL INITIAL POSITION*****WARNING!***

*Before to engage the Striker Pin the Star Wheel must be positioned as shown in the above picture.*

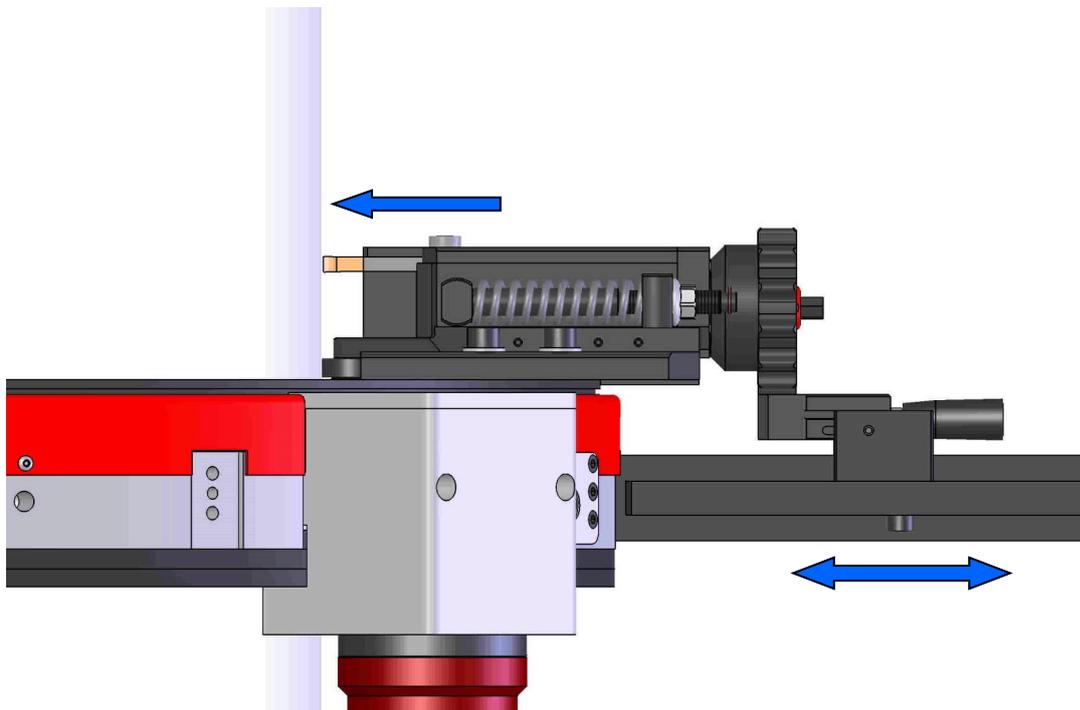


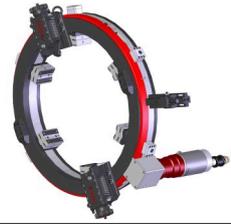
## USE INSTRUCTIONS

After you have positioned the tools as explained in the previous paragraph you can start the machine making sure the Striker is engaged.

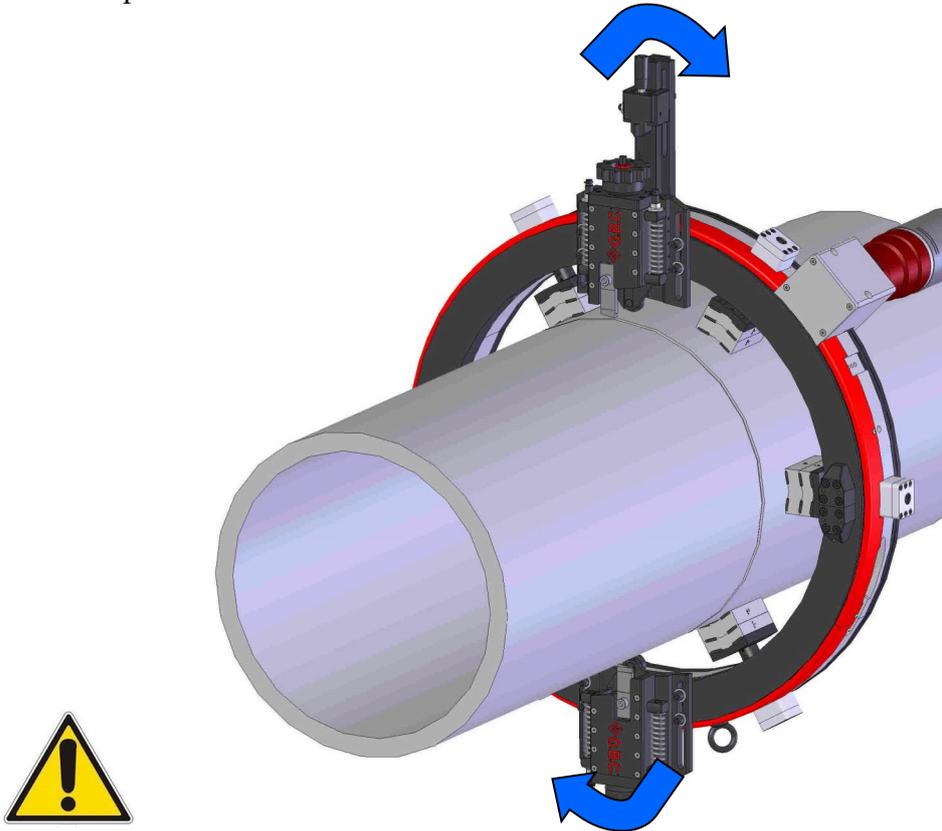
At some point the FORWARD TOOL will touch the pipe OD and when this happens you will have to disengage the Striker and engage it again only at the passage of the BACKWARD TOOL and continue with this procedure until this tool touches the pipe OD.

When this happens you have reached the perfect working configuration and the striker can be left engaged.

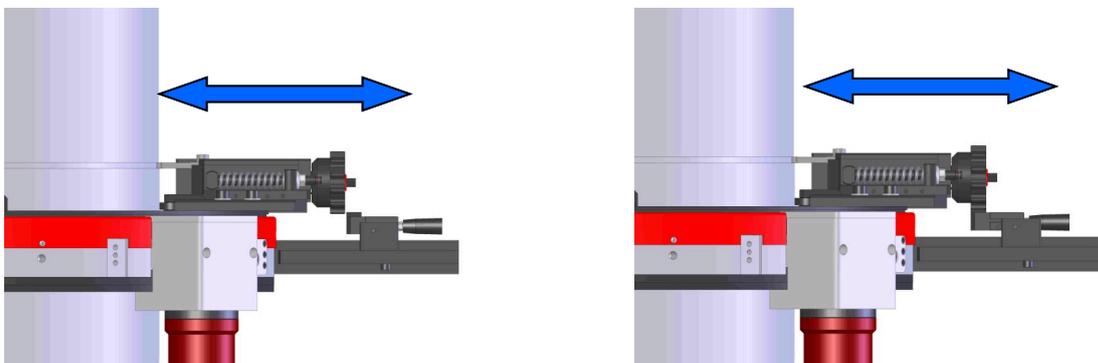




Now that both the tools are working you can increase the machine rotation speed.



**WARNING:** When cutting or beveling thick wall pipes the material removed may tend to bulk up on the tool blades and this may affect the finishing as well as the tools lifespan. If this happens you can temporarily disengage the striker and the accumulated swarfs will fall off. At this point the striker can be re-engaged paying attention to start with the FORWARD TOOL.





## ***FAST 06"-36"***

Original Instructions — rev.2016—In compliance with the § 1.7.4  
Of the Machine Directive 2006/42/CE



## **ORDINARY MAINTENANCE**

**WE SUGGEST TO HAVE THE MACHINE INSPECTIONED AND SERVICED BY GBC EVERY 400 WORKING HOURS.**

## **PERIODICAL CHECKS**

- CHECK THE GENERAL CONDITIONS OF THE MACHINE.
  
- WITH ELECTRIC UNITS ENSURE THE MOTOR TENSION AND FREQUENCY ARE COMPATIBLE WITH THOSE OF THE WORKING PLACE..
  
- WITH ELECTRIC UNITS CHECK THE CONDITIONS OF THE CARBON BRUSHED AND REPLACE THEM BEFORE THEY ARE COMPLETELY WOIN CASO DI MACCHINA ELETTRICA, VERIFICARE CHE LE SPAZZOLE AL CARBONIO DEL MOTORE SIANO SOSTITUITE PRIMA DEL LORO ESAURIMENTO COMPLETO.
  
- WITH PNEUMATIC UNITS IT IS IMPORTANT TO CHECK THE GEARS AND THE MOTOR SPINDLES EVERY 300 HOURS.
  
- KEEP CLEAN THE TOOL SEATS FROM SWARFS..
  
- EVERY 20-30 WORKING HOURS CLEAN THE TOOLBOXES THOROUGHLY AND CHECK THE CONDITION OF THE FEEDING GEARS OF THE ASSEMBLYS.
  
- FOR A CORRECT USE OF THE MACHINE ALWAYS USE **SHARP TOOLS**.

**G.B.C. IS AT YOUR TOTAL DISPOSAL FOR EXECUTING THE ABOVE STATED CHECKS AND FOR ANY NADDITIO-NAL CLARIFICACION YOU MAY NEED.**

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

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## *FAST 06"-36"*

Original Instructions — rev.2016—In compliance with the § 1.7.4  
Of the Machine Directive 2006/42/CE



## **TROUBLESHOOTING**

**The machine does not start.** Make sure the unit is connected to the power supply and that the power supply is adequate to the machine requirements.

**The machine does not bevel.** Check the condition of the tools and that the specific material of the pipe requires special tools. Always rely on GBC for any doubts or suggestions.

The acoustic emissions are within the limits established by the Machine Directive in force. The proof of this is filed in GBC's archives together with all the acoustic tests carried out on every single machine.

For hydraulic units the manual of the hydraulic power unit is supplied together with this CE instruction manual.

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

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