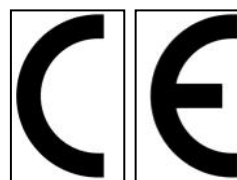




INSTRUCTION MANUAL



PIPE 6

Version 00. 2018

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



PIPE 6

Original Instructions - Rev.00-2014 - In compliance with the § 1.7.4 of the Machine Directive 2006/42/CE



INDEX

Presentation of the company and scope of this manual	3
General Warranty Clauses	4
Intended Use of the Machine	5
Technical Data	6
Machine Standard Equipment	7
Safety Prescriptions and Acoustic Emissions	8
Details for Transport	9
Machine Stability	10
Workplace	10
Emergency Button Installation Exemption	10
Machine Setup and Use Instructions	11
Execution of the Bevel	19
Ordinary Maintenance and Periodical Check	26
Troubleshooting	27

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PRESENTATION OF THE COMPANY AND INTRODUCTION TO THE INSTRUCTION MANUAL

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

is known worldwide for the quality of its **machines and accessories for pipe cutting and beveling applications of any sort and plate beveling machines.**

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

STANDARD QUALITATIVO

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:

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

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GENERAL WARRANTY CLAUSES

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

In case of any operational malfunction arising during the warranty period, **G.B.C. Industrial Tools S.p.a.**

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. Industrial Tools S.p.a.** 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. Industrial Tools S.p.A.** 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. Industrial Tools S.p.A.** 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. Industrial Tools S.p.A.** and **MSS**, otherwise the warranty will be void.

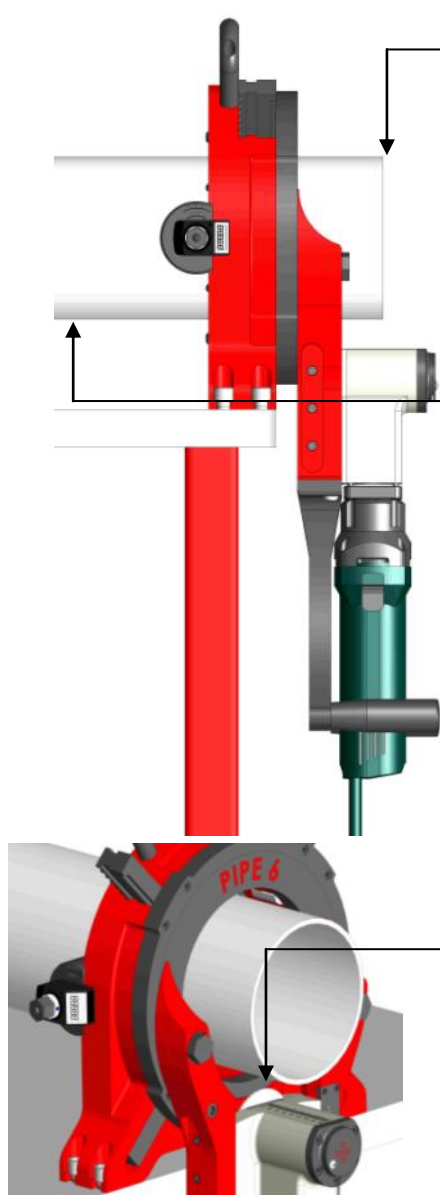
Any ordinary maintenance performed by the customer/user or by any service centre not recognized or approved by **G.B.C. Industrial Tools S.p.A.** will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials, power supply, negligence, unauthorized modifications, atmospheric events, acts of vandalism, incautious handling and/or transport, use of non original **G.B.C. Industrial Tools S.p.A.** parts and damage for causes not specified by **G.B.C. Industrial Tools S.p.A.** and for which **G.B.C. Industrial Tools S.p.A.** declines any responsibility. **G.B.C. Industrial Tools S.p.A.** 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. Industrial Tools S.p.A.** The claim terms for defects and/or damages in the material or of the ordered quantities, are those prescribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

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INTENDED USE OF THE MACHINE



The PIPE6 is an orbital pipe saw used for cutting and eventually beveling tubes and pipes with a moderate wall thickness with an OD range between 23mm and 170mm.

The workpiece is locked in the prismatic jaws of the PIPE6.

The cut is obtained through circular blades that can have different thickness, composition and number of teeth, that can be chosen in relation to the specific application of the moment.

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

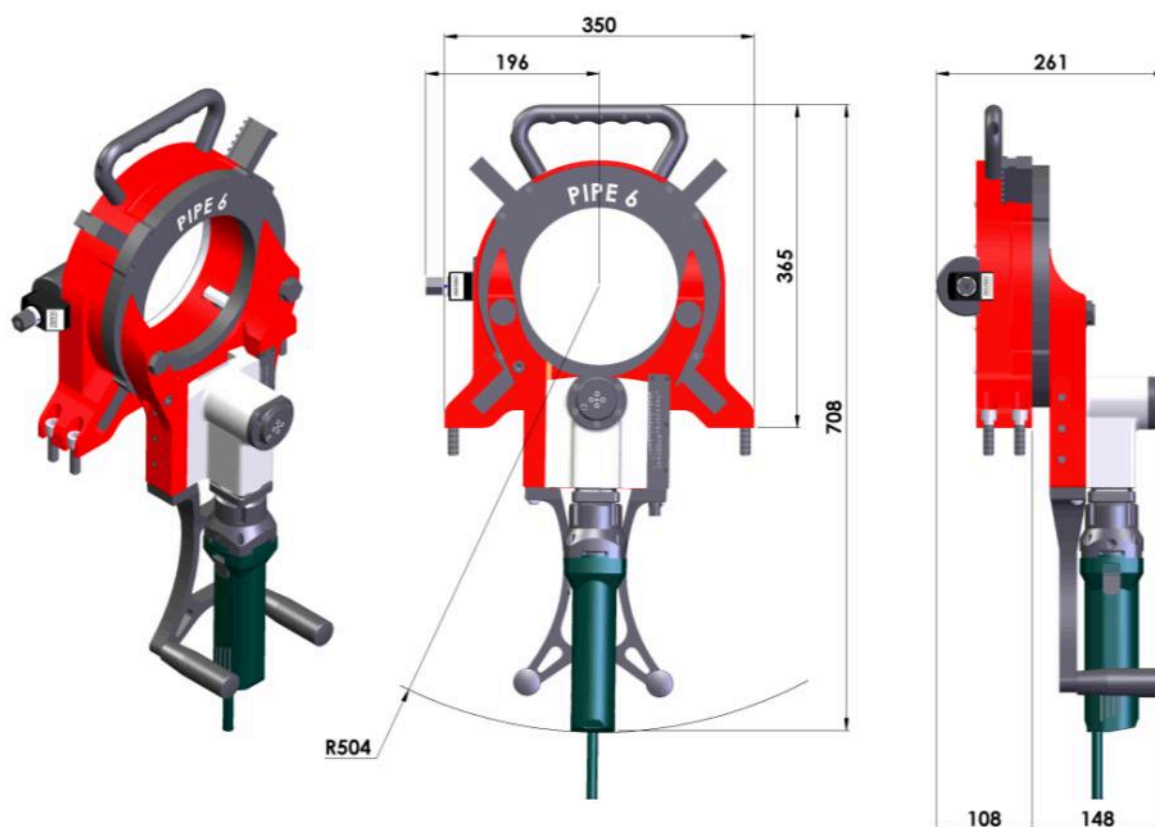
FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTABLE MISUSE OF THE UNIT

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TECHNICAL DATA		
		ELECTRIC
OD Locking Capacity	mm (inches)	23 ÷ 170 (0.90 ÷ 6.69)
Idle Speed	gg/min (Rpm)	74 ÷ 291
Tube/Pipe Thickness	mm (inches)	1 ÷ 11 (0.039 ÷ 0.43)
Electric Motor Power	Hp (W)	0.96 (720)
Tension	Volt	110 / 230
Frequency	Hz	50 / 60
Max Acoustic Emission	Db	75
Weight	Kg	28



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MACHINE STANDARD EQUIPMENT

The machine is supplied with:

- N° 1 Cutting Blade
- Brush and Lubricating Oil
- Service Tools
- Wooden Case for Storage
- Instruction Manual and Drawings

PIPE6



Wooden Case



Service Tools



Instruction Manual and Drawings



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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 hereinafter and with the use and maintenance instructions hereto.

- Carefully read ALL the following regulations and the instructions herewith 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 specs 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 non 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 non specified circumstances it is necessary to obtain the authorization of the manufacturer.

The acoustic emissions recorded values are within the maximum threshold of the Machine Directive . The evidence is available upon request and it is stored in the archives of the manufacturing department.

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Using properly the safety gear entails the only risks to be generated by the user's system and not by inborn defects of our machines.

The acoustic emissions are within the limits provided by Machine Directive in force. Proof of this is recorder and stored by the production department which files all the acoustic tests performer on every single unit.

- 1. Always wear gloves and goggles during every operation**
- 2- ALWAYS disconnect the PIPE6 form the power source before performing any manual operation on the unit.**
- 3-The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.**



DETAILS FOR TRANSPORT

Weight of the PIPE6	Kg	28	
Shipping Dimensions	mm	1000x610x570	
Shipping Weight	kg	60	

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MACHINE STABILITY

Considering the mass of the machine there is no specific problem related to the operator safety.

WORKPLACE

During the cutting / beveling operations the operator will have to stand on the side of the machine and control the manual rotation maintaining an adequate distance from the cut point

EMERGENCY STOP INSTALLATION

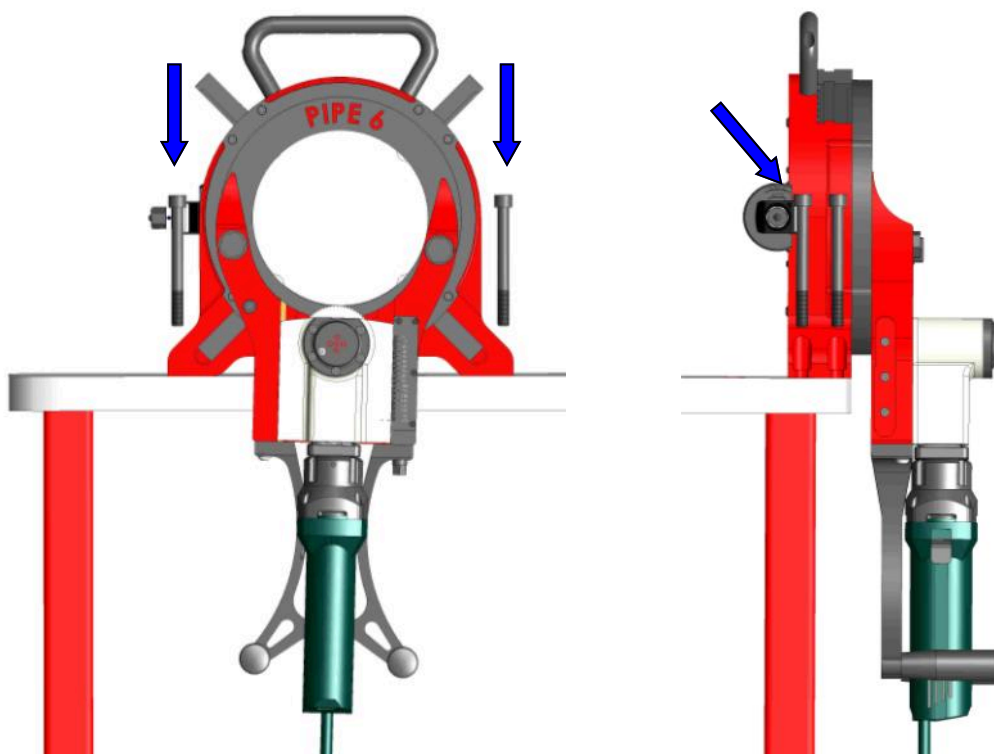
Portable machines or hand carried machines are not subjected to the emergency stop installation obligation as per the paragraph 1.2.3.4 of the Machine Directive

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MACHINE SETUP AND USE INSTRUCTIONS



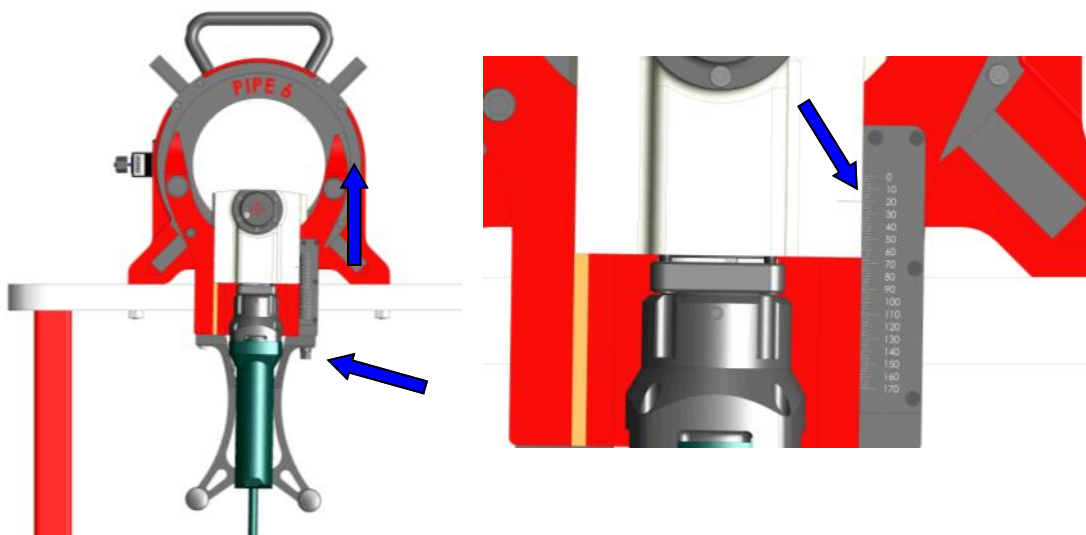
Place the machine on a workbench as shown on the above pictures and find the desired placement of the unit. Now fix the PIPE6 to the work bench with N° 4 M12 socket cap bolts (not included) long enough for the work bench.

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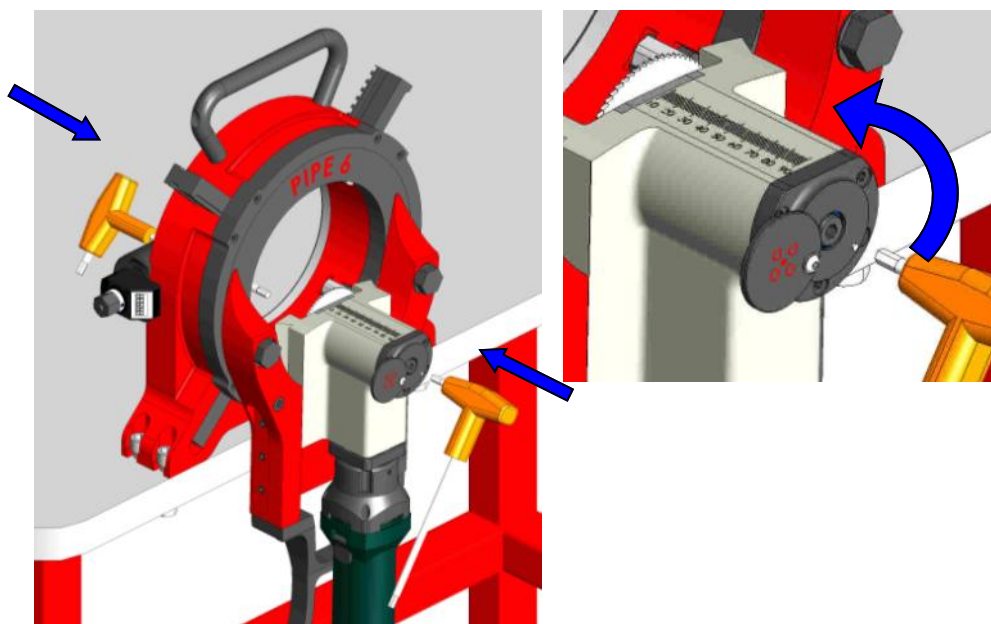
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Preparazione della macchina



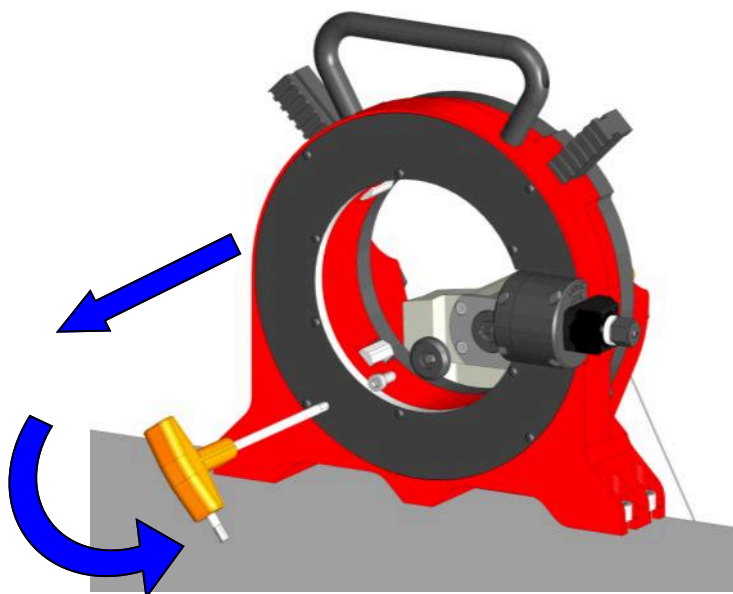
Raise the blade initial position by turning the screw until it reaches the 20mm notch printed on the gauge.



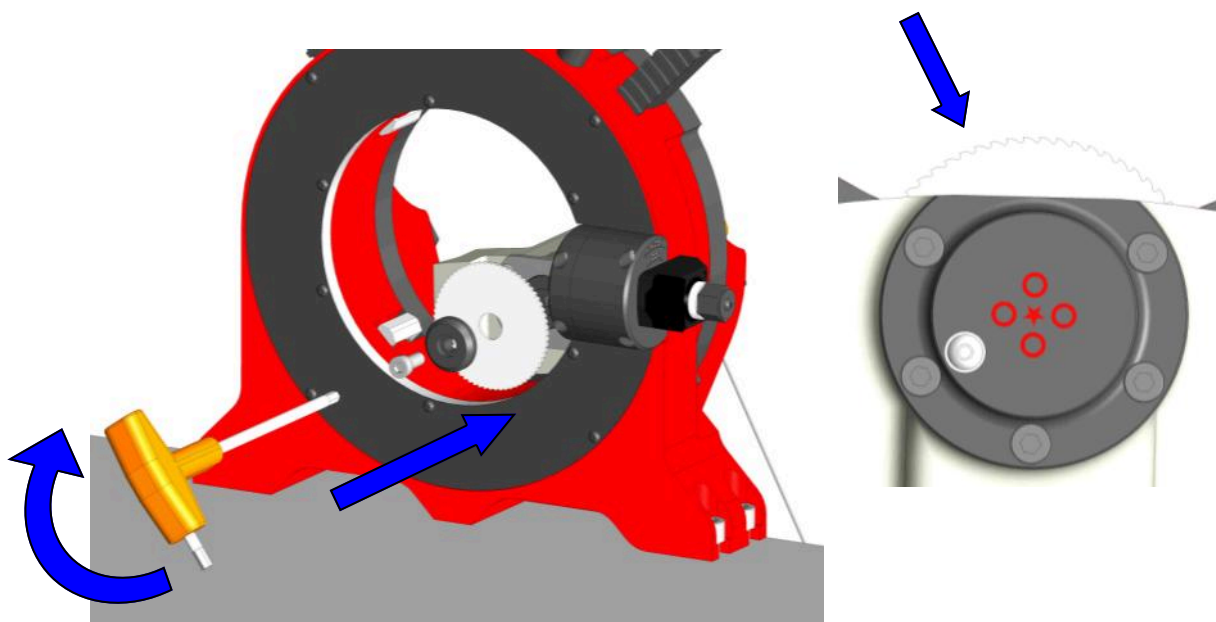
Open the round cover and use two Allen keys one on each opposite side of the central assembly.

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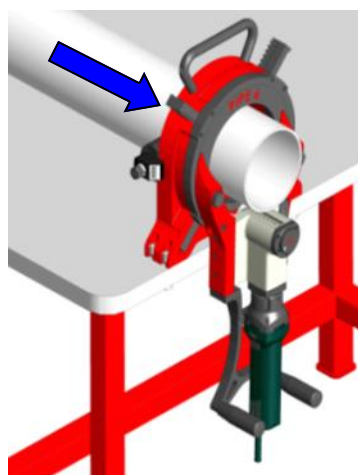
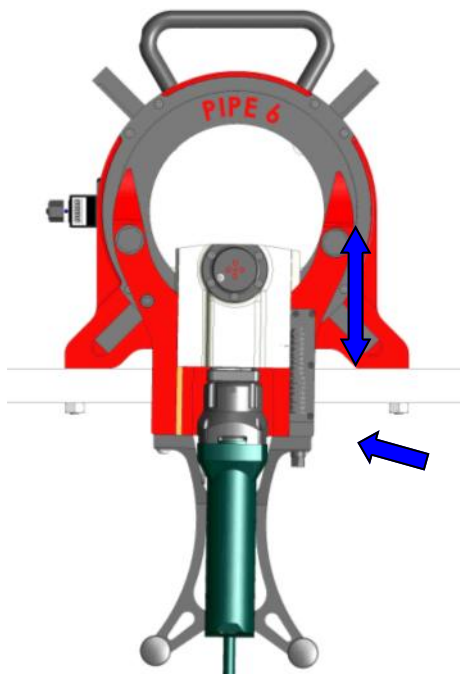
To install the blade remove the fixing screw and remove the blade locking pin.



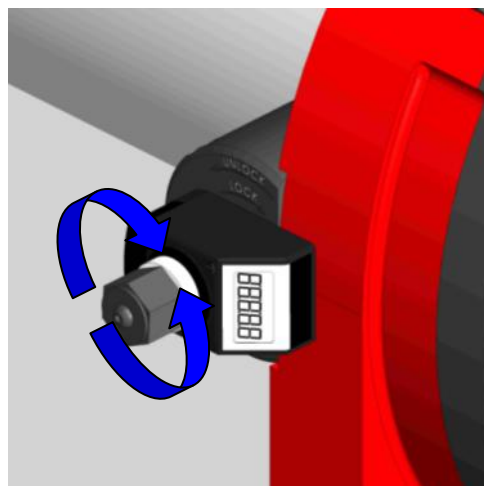
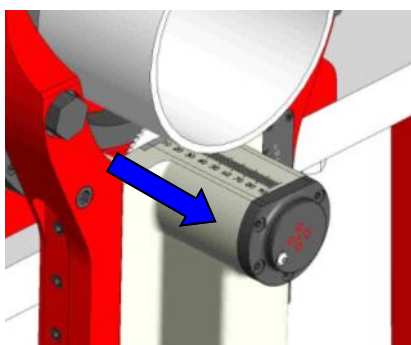
Insert the blade paying attention that it's placed in the correct direction of rotation as shown in the above picture and put back in place the locking pin and the fixing screw.

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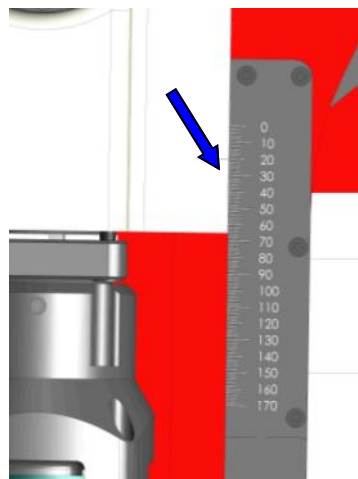
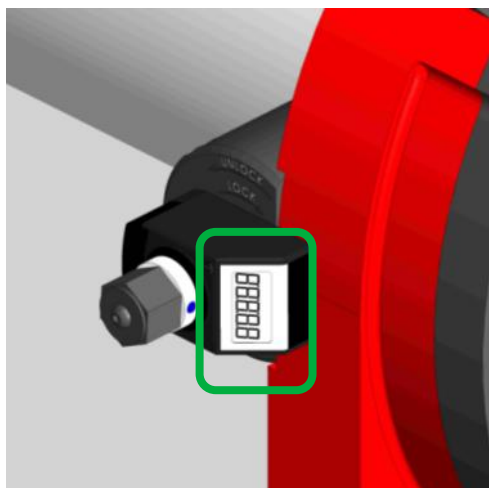
Turn the bolt indicated by the arrow to lower the blade position allowing an easy insertion of the workpiece in the prismatic jaws and through the machine as you don't want to hit the blade with it.



Insert the workpiece until you reach the desired cut length on the cut gauge turn the nut indicated in the picture to close the jaws around the workpiece until it is centered and well immobilized.

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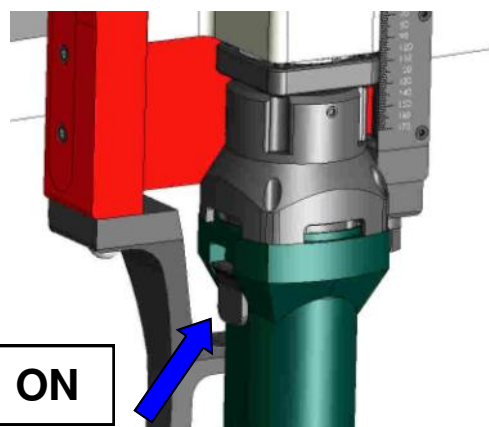
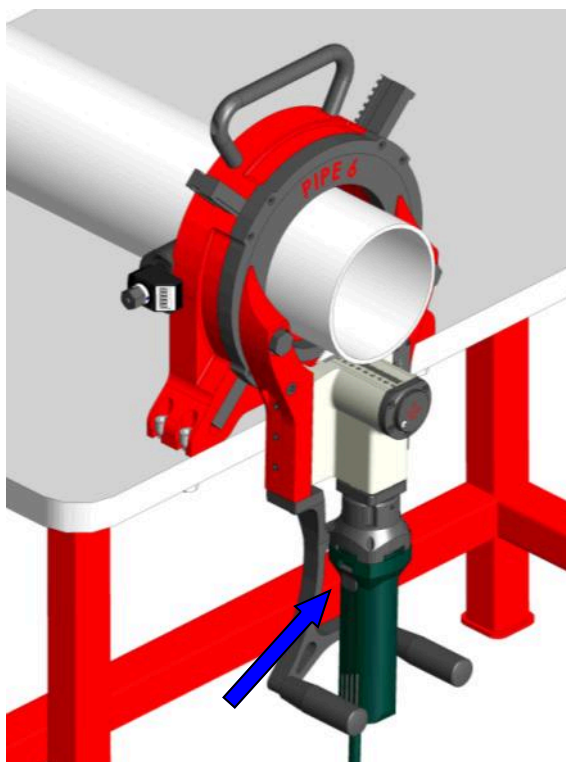


The reading visualized on the display is the measure that you will have to match on the side gauge which is slightly bigger than the actual workpiece OD to allow some clearance to the blade.

Ruotare, come indicato dalle frecce sulla macchina, il dado e bloccare il tubo.

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Before every cutting / beveling operation it is highly recommended (when possible) to apply some lubricant oil on the blade in order to preserve its life as much as possible.
Turn on the machine by pressing the ON button. (See the photo above)

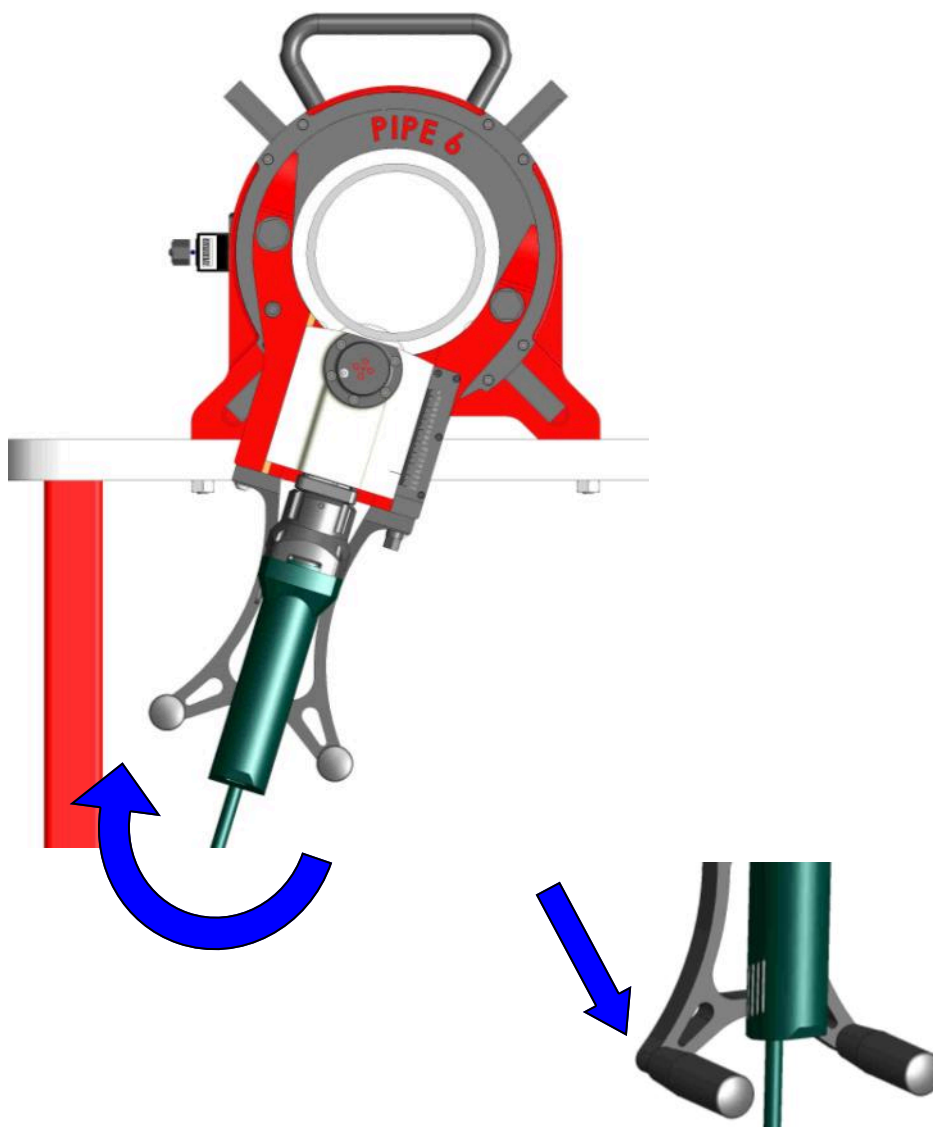
WARNING



THE MACHINE IS NOT EQUIPPED WITH A DEAD MAN SWITCH THEREFORE ON-CE THE “ON” BUTTON IS PRESSED YOU WILL NEED TO PRESS IT ON THE POSITION “OFF” TO TURN OFF THE MACHINE.

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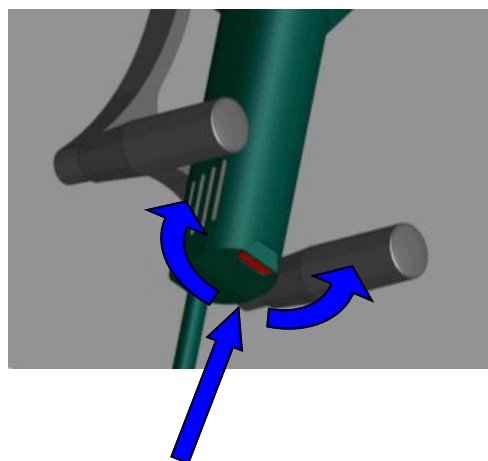
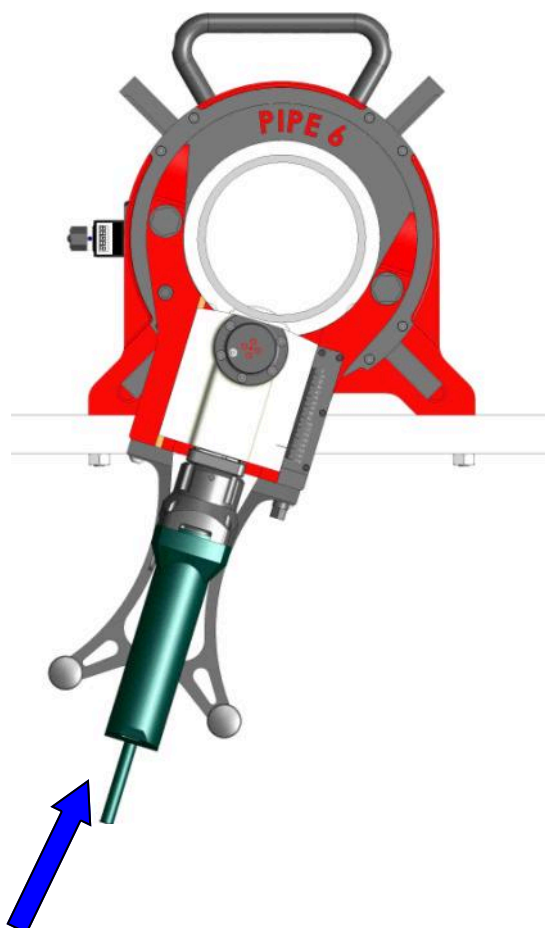
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Using the side handles indicated in the picture above you can start cutting by slowly rotate clockwise the machine.

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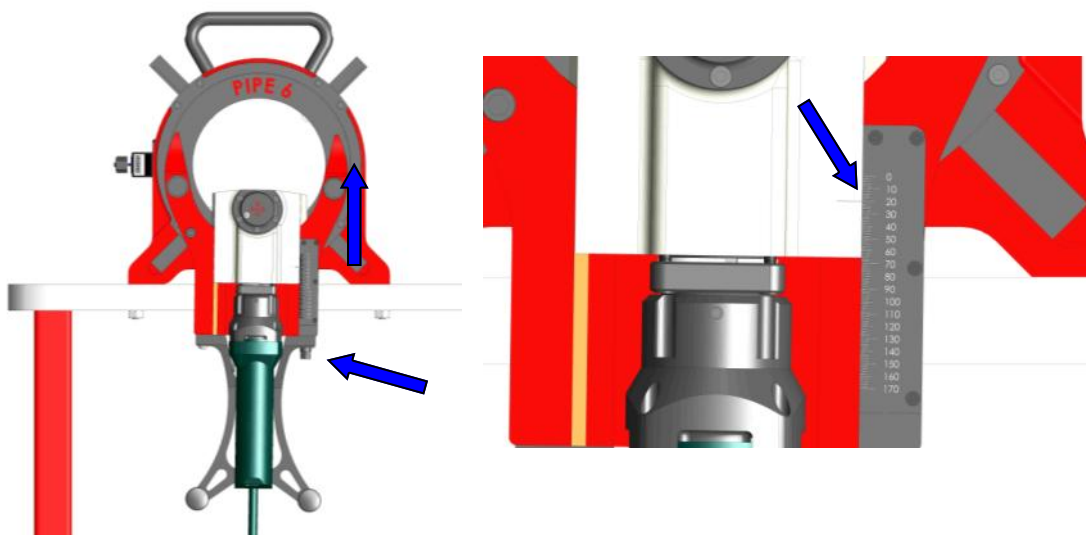
Adjust the blade RMP in relation to the material and to the wall thickness of the workpiece by rotating the speed regulator knob located on the rear end of the motor.

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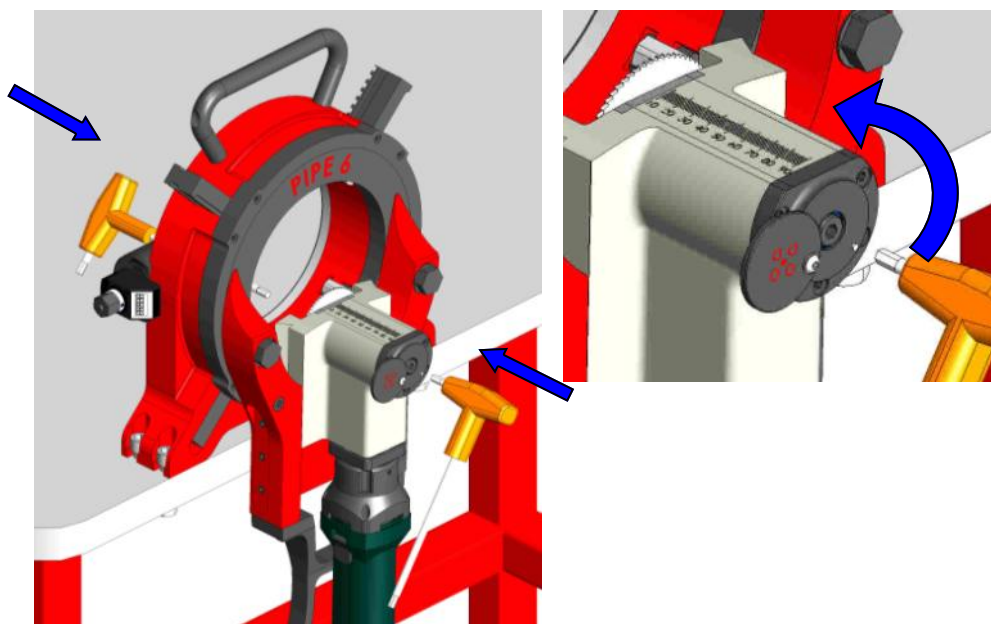
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



EXECUTION OF THE BEVEL



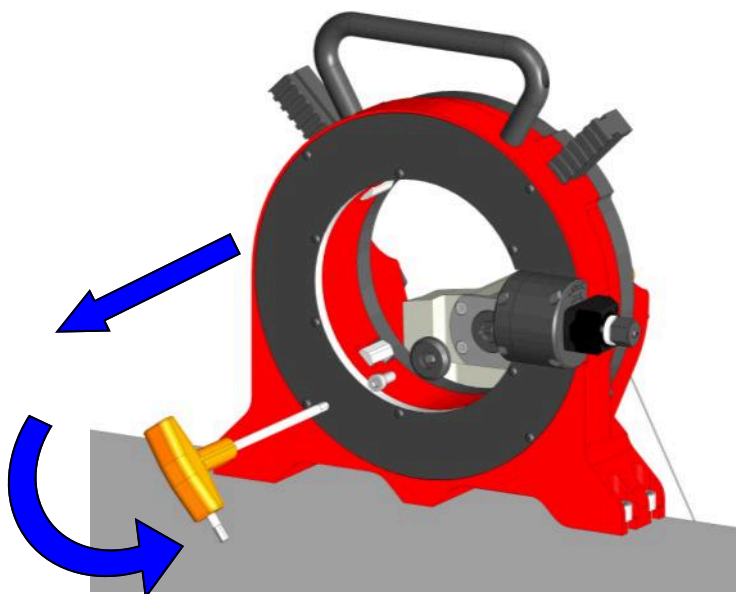
Raise the blade by turning the screw indicated by the arrow in the above drawing until you reach the 20mm notch on the side gauge.



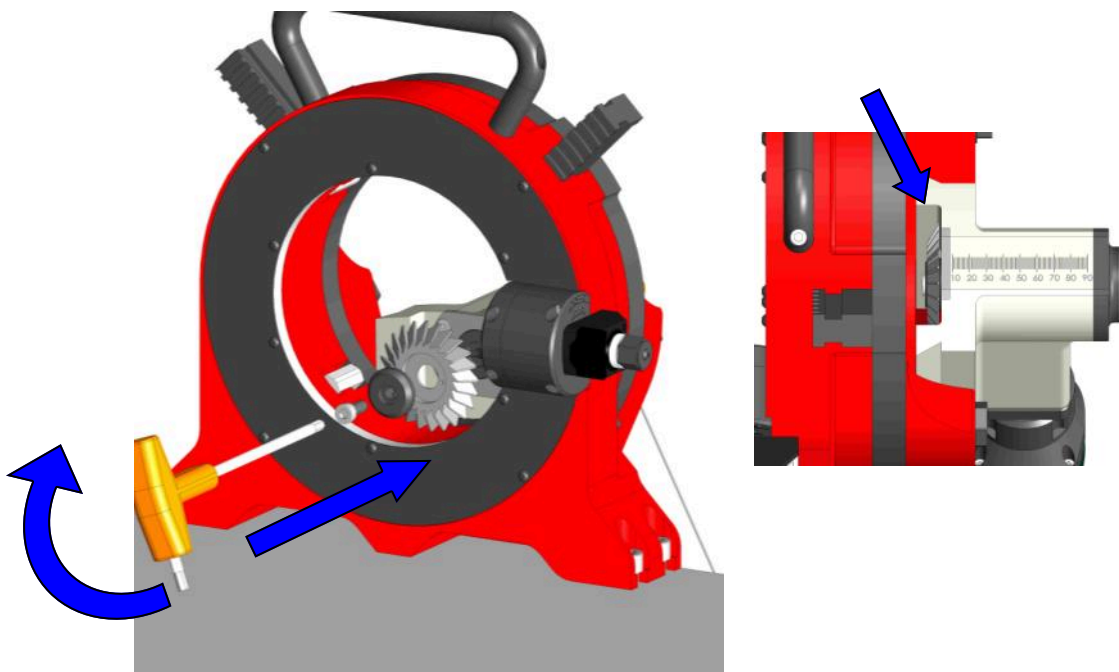
Open the round cover and use two Allen keys one on each opposite side of the central assembly.

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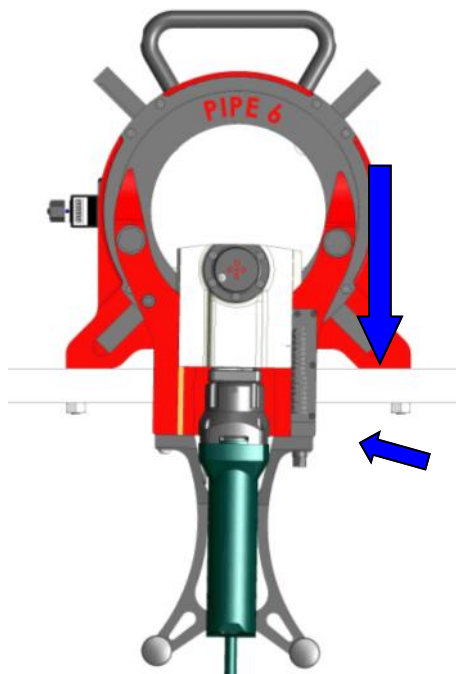
Remove the screw and the locking pin.



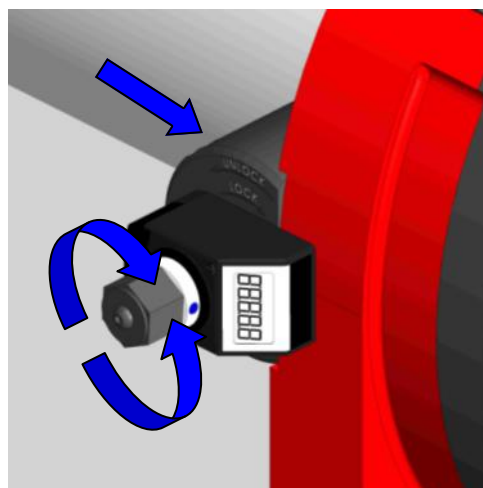
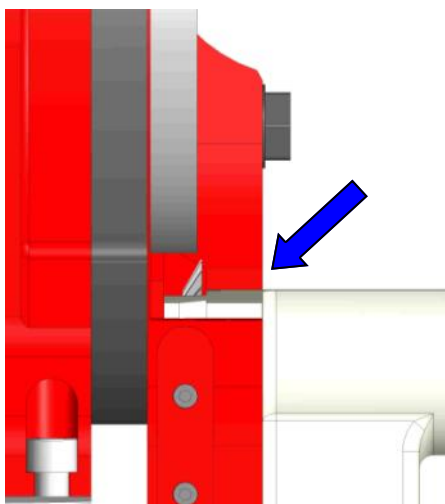
Install the beveling blade making sure it is installed in the correct direction of rotation as shown in the above picture. Put back in place the locking pin and the fixing screw.

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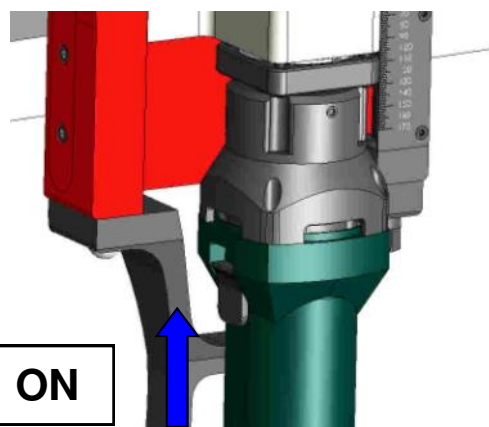
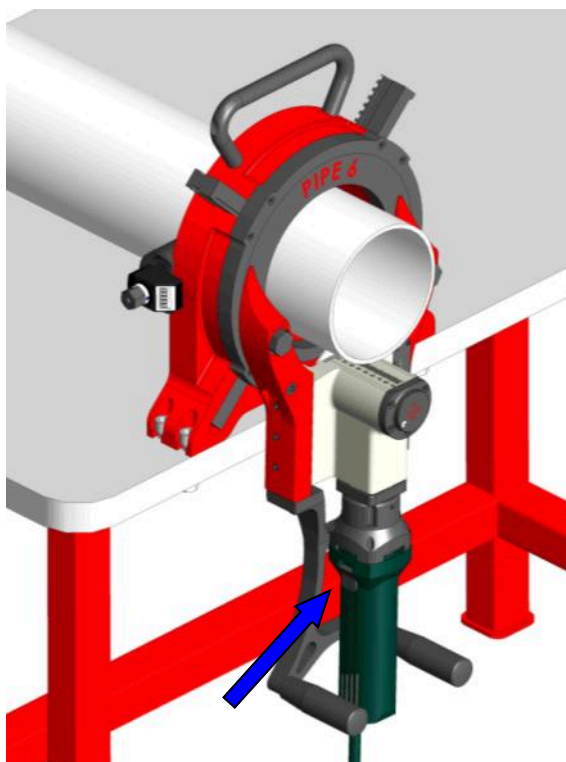
Turn the bolt indicated by the arrow to lower the blade position allowing an easy insertion of the workpiece in the prismatic jaws and through the machine as you don't want to hit the blade with it.



Insert the workpiece until you reach the position shown in the abovepicture and turn the nut to close the jaws around the workpiece until it is centered and well immobilized

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Turn on the machine by pressing the ON button. (See the photo above)

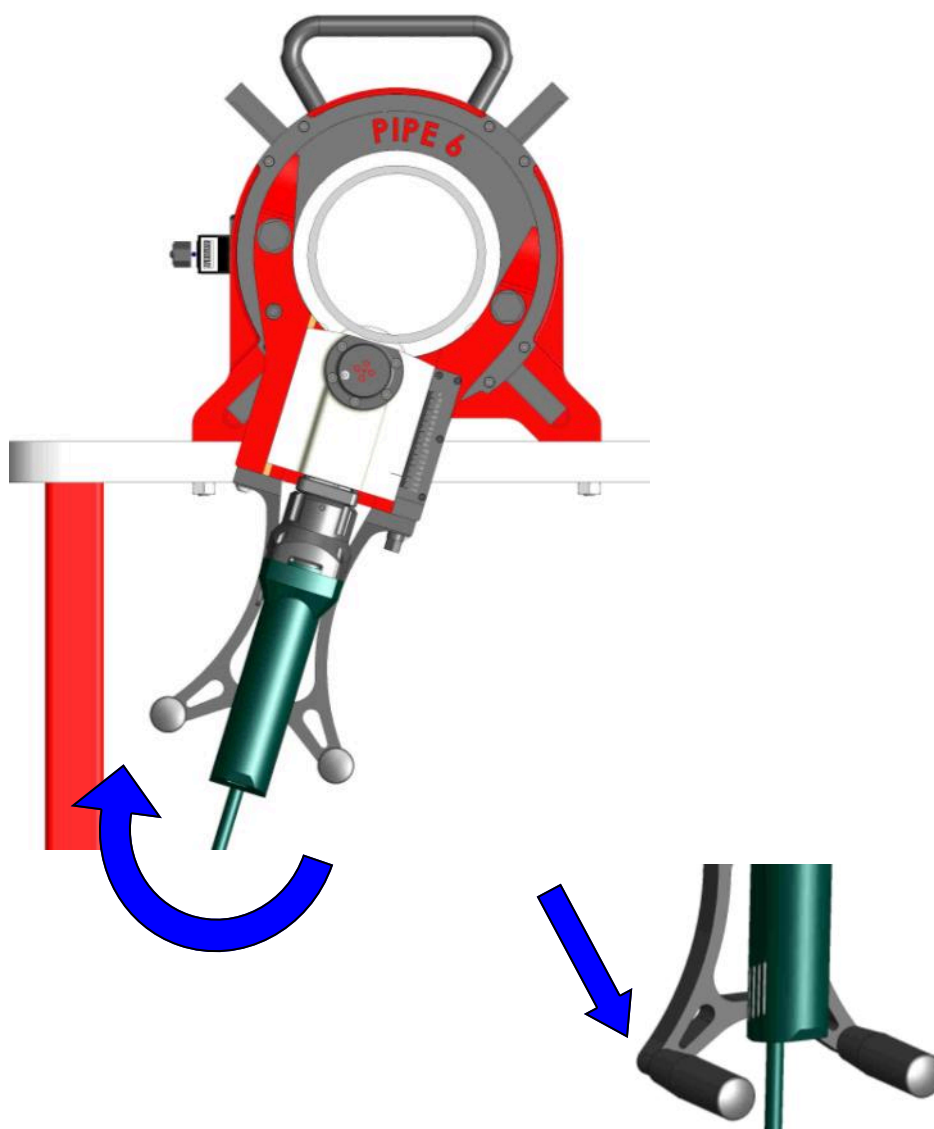
WARNING



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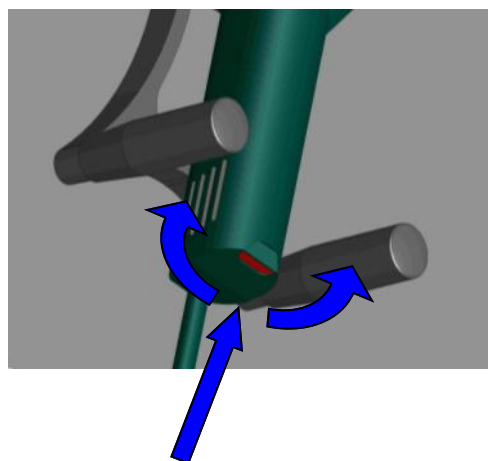
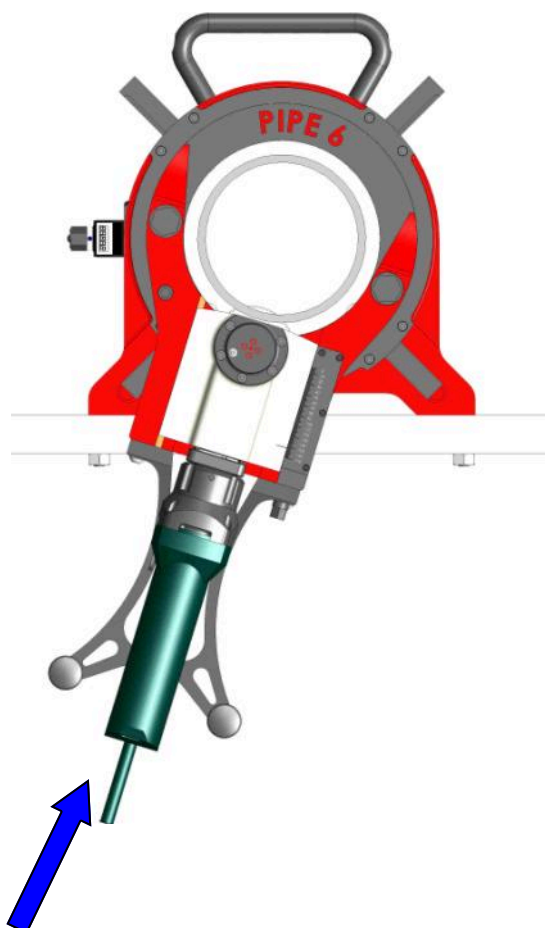
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Using the side handles indicated in the picture above you can start cutting by slowly rotate clockwise the machine.

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Adjust the blade RMP in relation to the material and to the wall thickness of the workpiece by rotating the speed regulator knob located on the rear end of the motor.

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ORDINARY MAINTENANCE

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

INSPECTION AND PERIODICAL CHECKS

- VISUALLY INSPECT THE MACHINE TO ESTABLISH THE GENERAL CONDITIONS OF THE UNIT.
- CLEAN THE BLADE AND THE MACHINE AFTER EVERY CUT OR BEVEL PERFORMED.
- ALWAYS USE SHARP BLADES AND IN GOOD CONDITIONS.

G.B.C. Industrial Tools is at your disposal for any information you may re-quire about the above mentioned procedures and for any general clarification you may need.

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PIPE 6

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TROUBLESHOOTING

The machine does not start.

Check that the machine is connected to the power supply.
Ensure that the electric power is compatible with the machine specifications.

The machine does not cut.

Check the conditions of the blade.
Check the workpiece specifications and ensure you are using the suitable blade type.

In case of any other problem you are invited to contact your reference person at GBC.

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