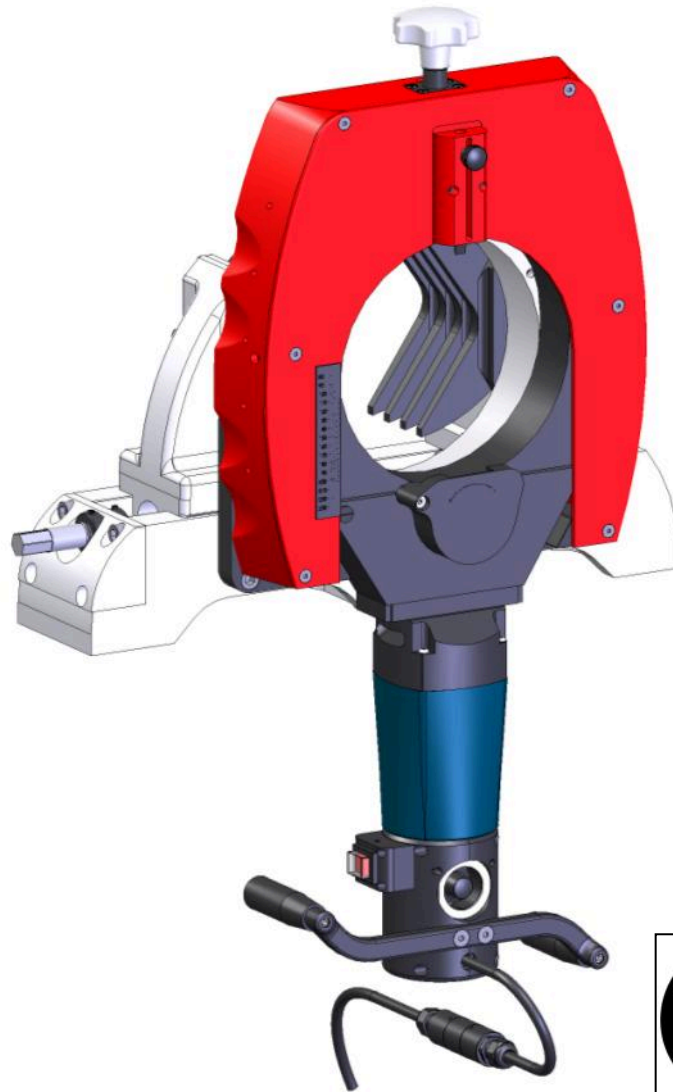




INSTRUCTION MANUAL



PIPE 8

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



INDEX

Presentation of the company and introduction to the Instruction Manual	3
Warranty General Clauses	4
Intended Use Of The Machine	5
Technical Data	6
Machine Standard Equipment	7
Safety Prescriptions	8
Transport recommendations	9
Machine Stability	10
Workplace	10
Emergency Stop Installation Exemption	10
Machine Setup and Instructions	11
Ordinary maintenance	18
Troubleshooting and Acoustic Emissions	19



PIPE 8

Istruzioni originali—rev.2013—in accordo al 1.7.4 della direttiva macchine 2006/42/CE



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 procedures 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 de-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 forbid-den 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

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 8

Istruzioni originali—rev.2013—in accordo al 1.7.4 della direttiva macchine 2006/42/CE



WARRANTY GENERAL 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.

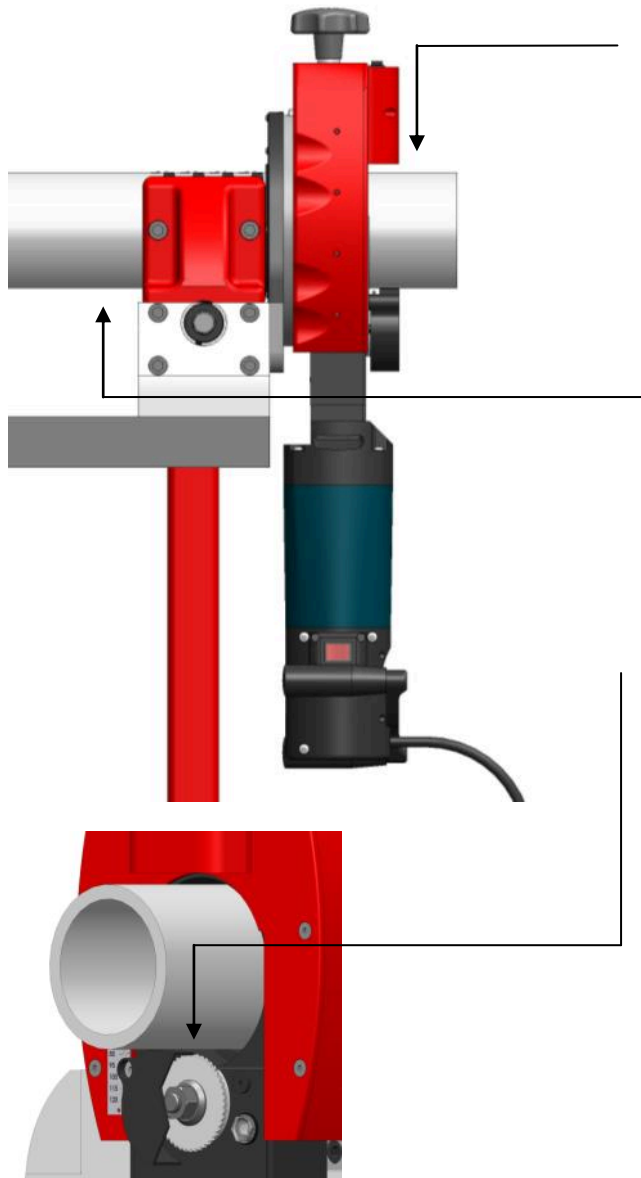
Any ordinary maintenance performed by the customer/user or by any service centre non recognized or approved by G.B.C. Industrial Tools S.p.A. will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials, 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.

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



INTENDED USE OF THE MACHINE



The machine shown in the drawing is intended to be used for cutting pipes with small diameters which are workable with this unit.

The pipe is loaded in the machine and locked in the jaw vice.

The cut is performed by circular milling tools having different thickness depending by the material the pipes are made of.

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

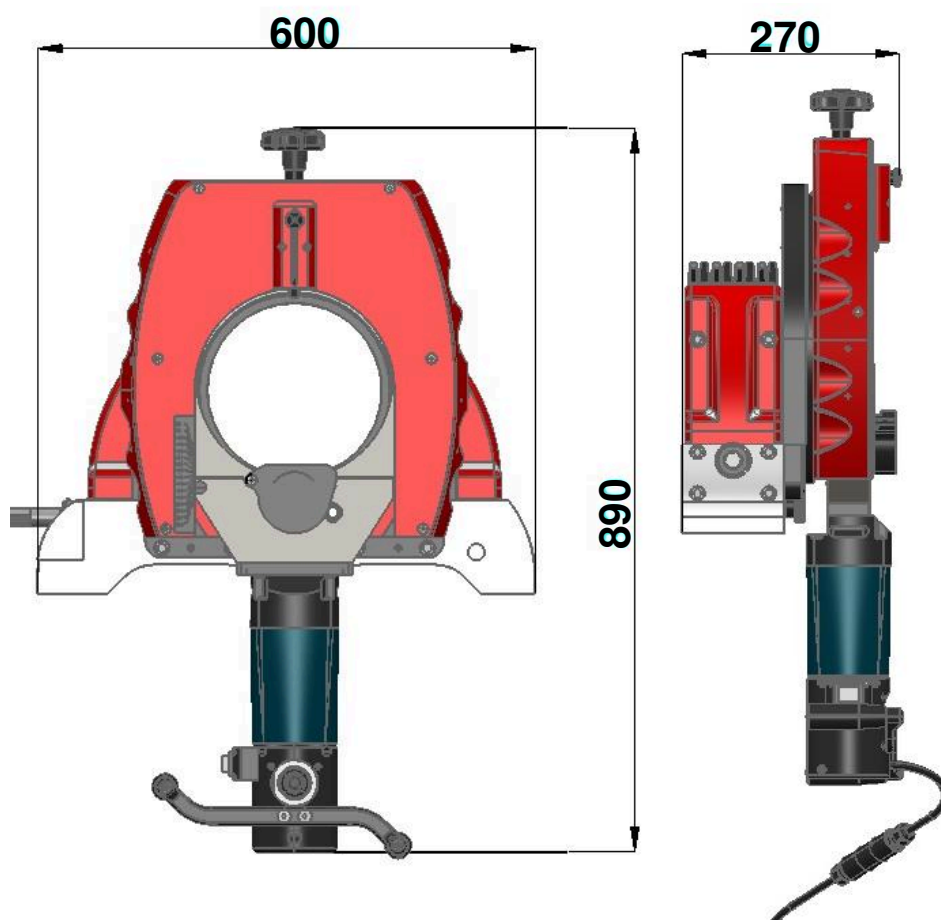
FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTABLE MISUSE OF THE UNIT

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



TECHNICAL DATA		
		ELECTRIC
OD Locking Range	mm	80 ÷ 230
Pipe Thickness	Mm	2 ÷ 10
Idle Speed	gg/min	170 ÷ 300
Electric Motor Power	Hp (W)	2200
Tension	Volt	110/230
Frequency	Hz	50/60
Max Acoustic Emission	Db	75
Machine Weight	Kg	130



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



MACHINE STANDARD EQUIPMENT

The machine is supplied with:

- N° 3 milling tools
- Brush and lubricating oil
- 20-22 mm Wrench
- 19 mm Double Ended Hexagonal Tubular Socket Wrench
- Wooden Case
- Instruction Manual and Exploded Drawings

Pipe 8



Wooden Case



Service Tools



Instruction Manual and Exploded Drawings



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



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.

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



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.

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. The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.



TRANSPORT RECOMMENDATIONS

Weight of the Machine	kg	130	
Shipping Dimensions	mm	1250x900x675	
Shipping Weight	kg	145	

Al di sotto dei 25 Kg non sono richiesti mezzi di sollevamento diversi dalla forza umana di un unico operatore

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



MACHINE STABILITY

Considering the mass of the machine no particular problem has been detected in regard to the operator safety.

WORKPLACE

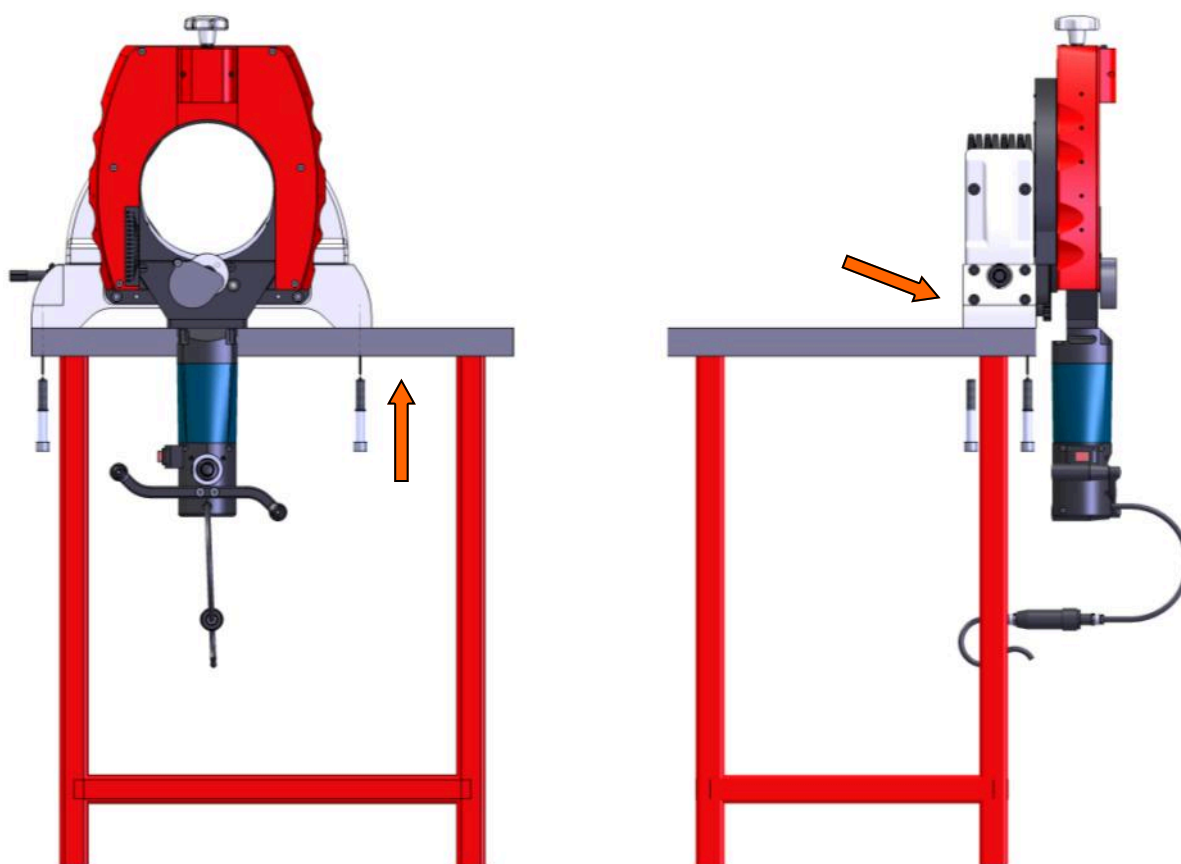
By always using both hands for operating the machine, the operator is unable to reach the bevelling tools as the unit would suddenly stop – motor brake –

EMERGENCY STOP INSTALLATION **EXEMPTION**

As provided for the paragraph 1.2.4.3. of the attachment 1 of the Machinery Directive, portable machines are exempt to have this feature.



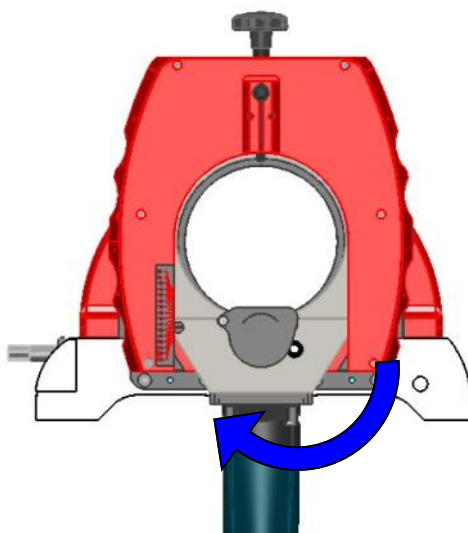
MACHINE SETUP



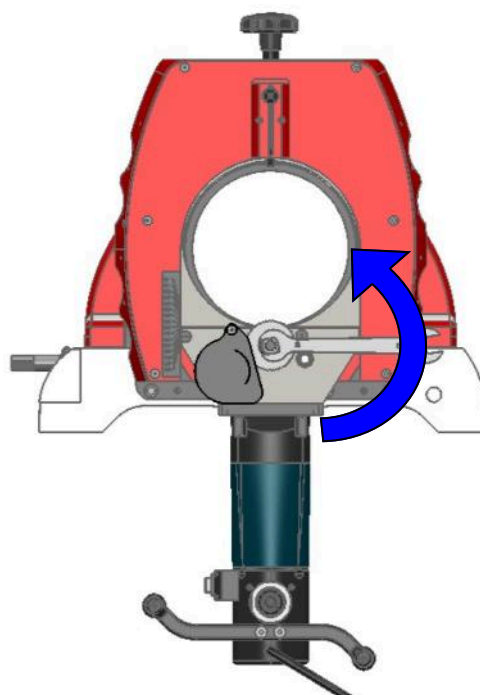
After the machine has been removed from its packaging, position it on top of a working bench as shown in the picture. Once found a satisfactory position fix it in place with N° 4 M16 nuts with suitable length (not included).

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



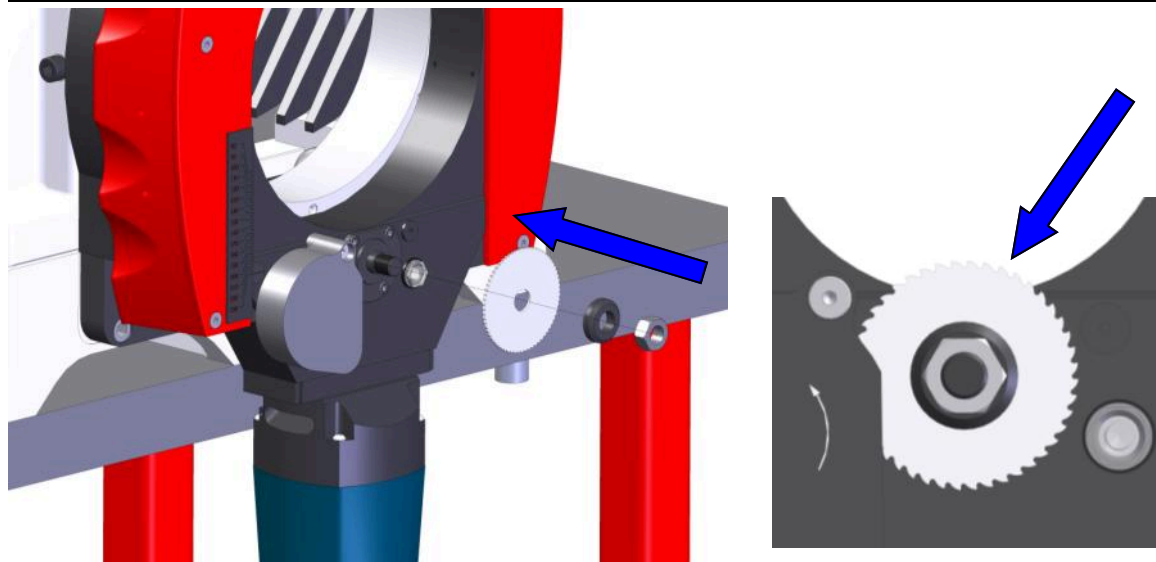
Rotate the protection as shown in the picture.



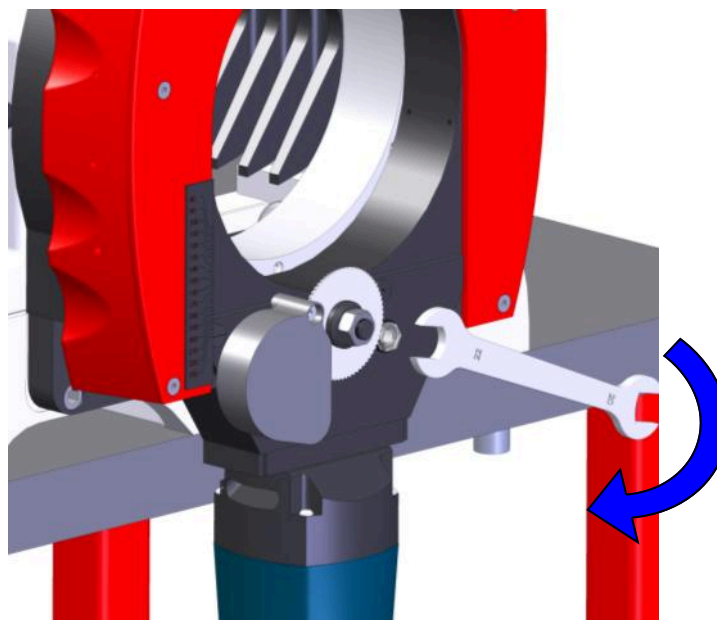
Unscrew the locking nut with a counter-clockwise movement using the wrench supplied with the machine.

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



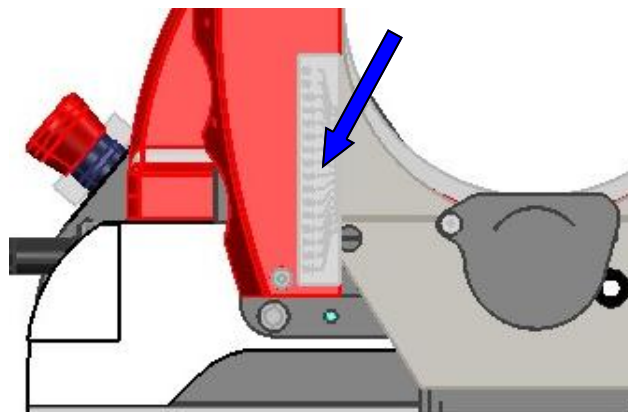
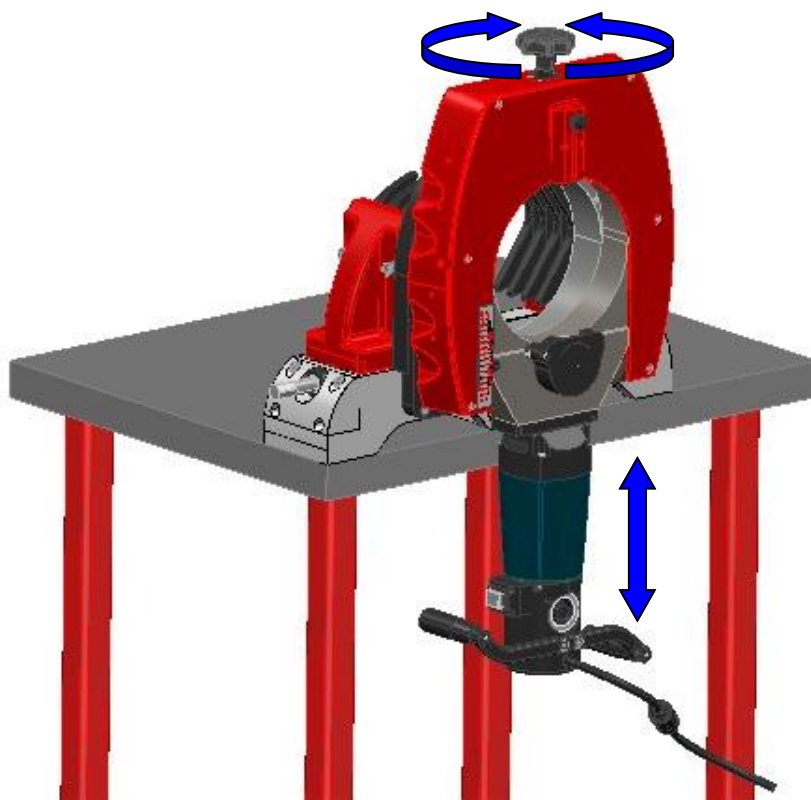
Install the milling tool suitable for the job making sure it is well greased for a better grip, paying attention to the direction of the cutting teeth which must be exactly as shown in the picture.



Once the milling tool is installed fasten the bolt with the wrench rotating clockwise.

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

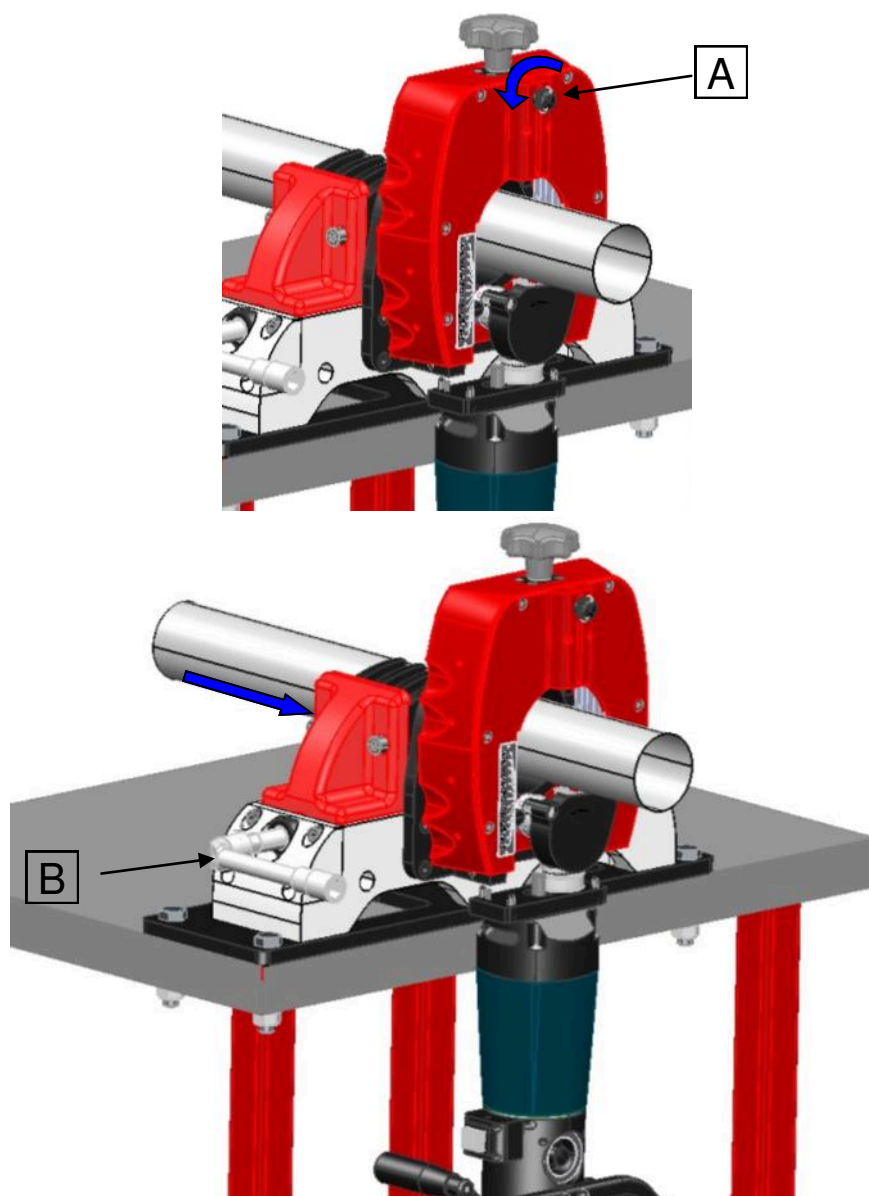
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



By rotating the hand wheel, position the machine in correspondence of the desired diameter of the pipe to be worked , in a scale value included between 80 and 230mm. The vernier applied on the side of the machine will grant you the maximum accuracy.

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

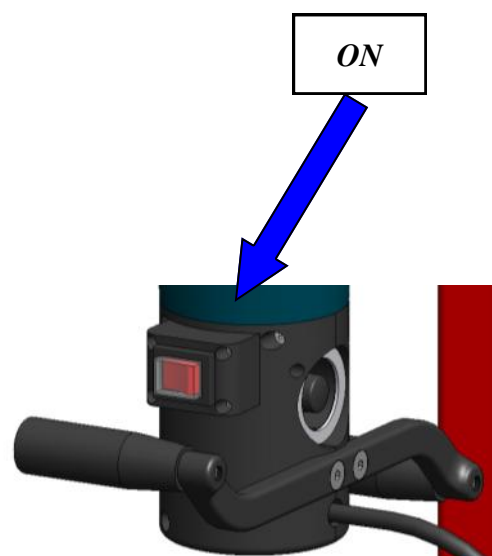
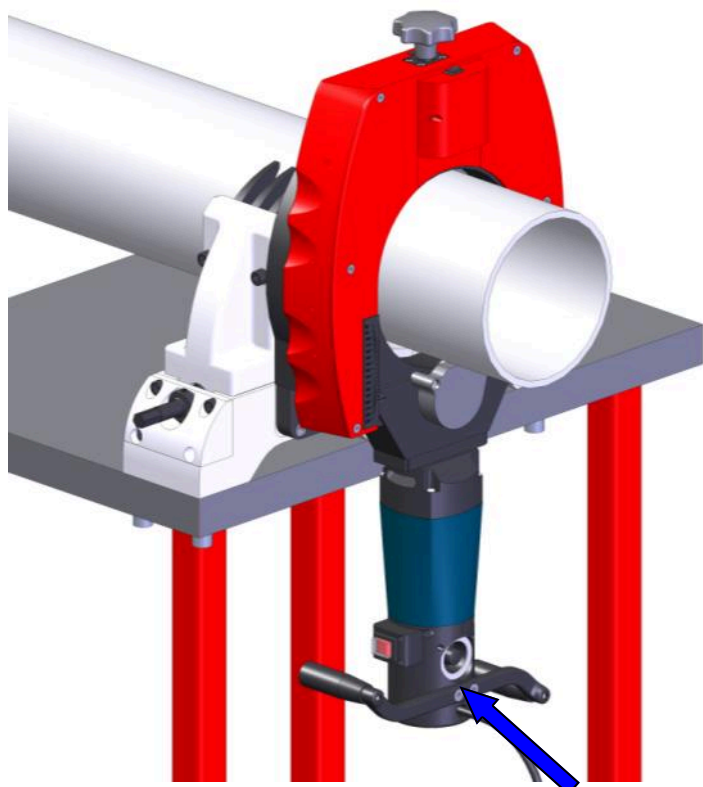
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



Svitare in senso antiorario il volantino frontale A e far scendere il cuneo di riferimento in appoggio sul tubo fino alla misura del taglio desiderata.
Successivamente, bloccare il tubo sul punto di taglio serrando, a fondo, la vite della morsa con la chiave in dotazione B.
Infine, riportare il volantino frontale A in alto e serrarlo in senso orario mettendo in posizione di sicurezza il cuneo di riferimento.

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



Before starting the machine, apply some lubricating oil on the milling tool with the brush supplied, but do not exceed with it.

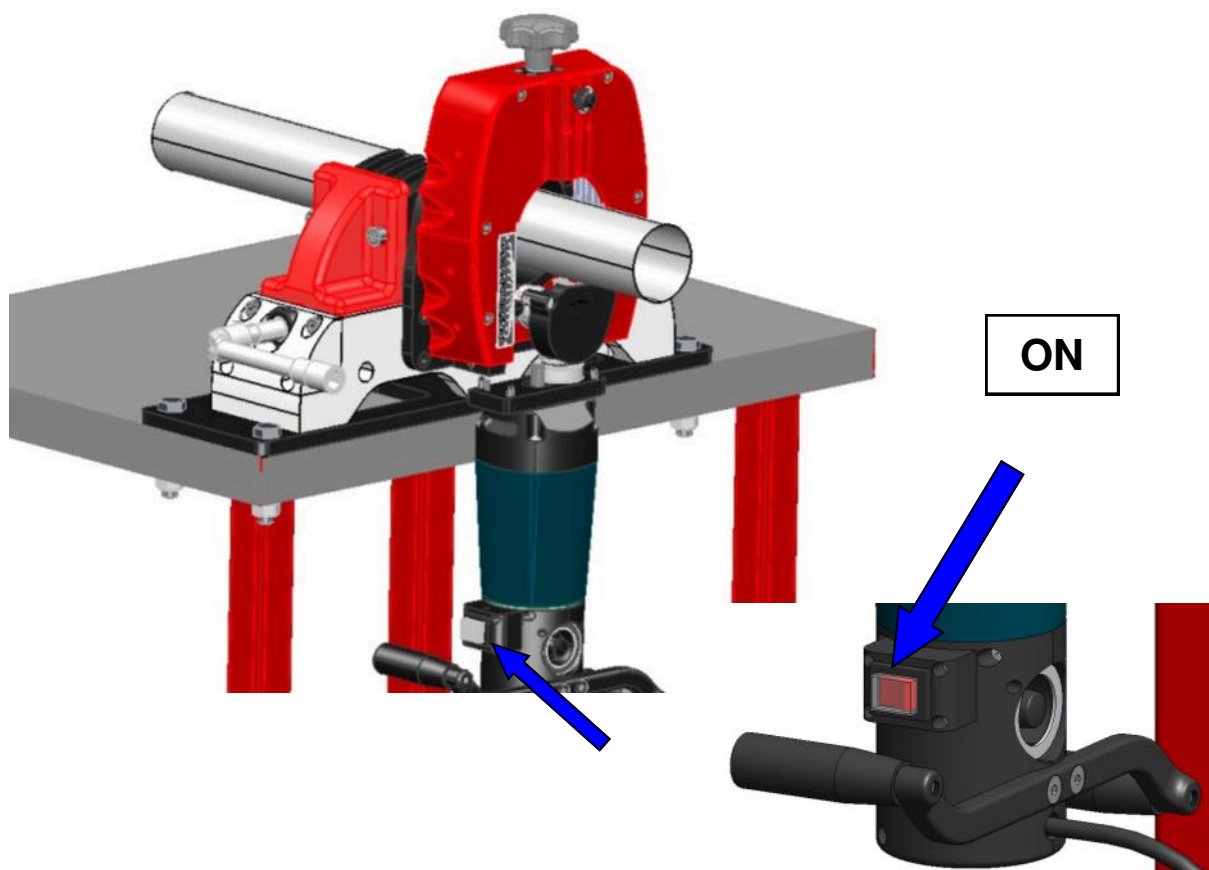
Start the machine with the red button on the side of the motor.



THE BUTTON WILL REMAIN IN “ON” POSITION UNTIL IT IS MANUALLY SWITCHED ON THE “OFF” POSITION.

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

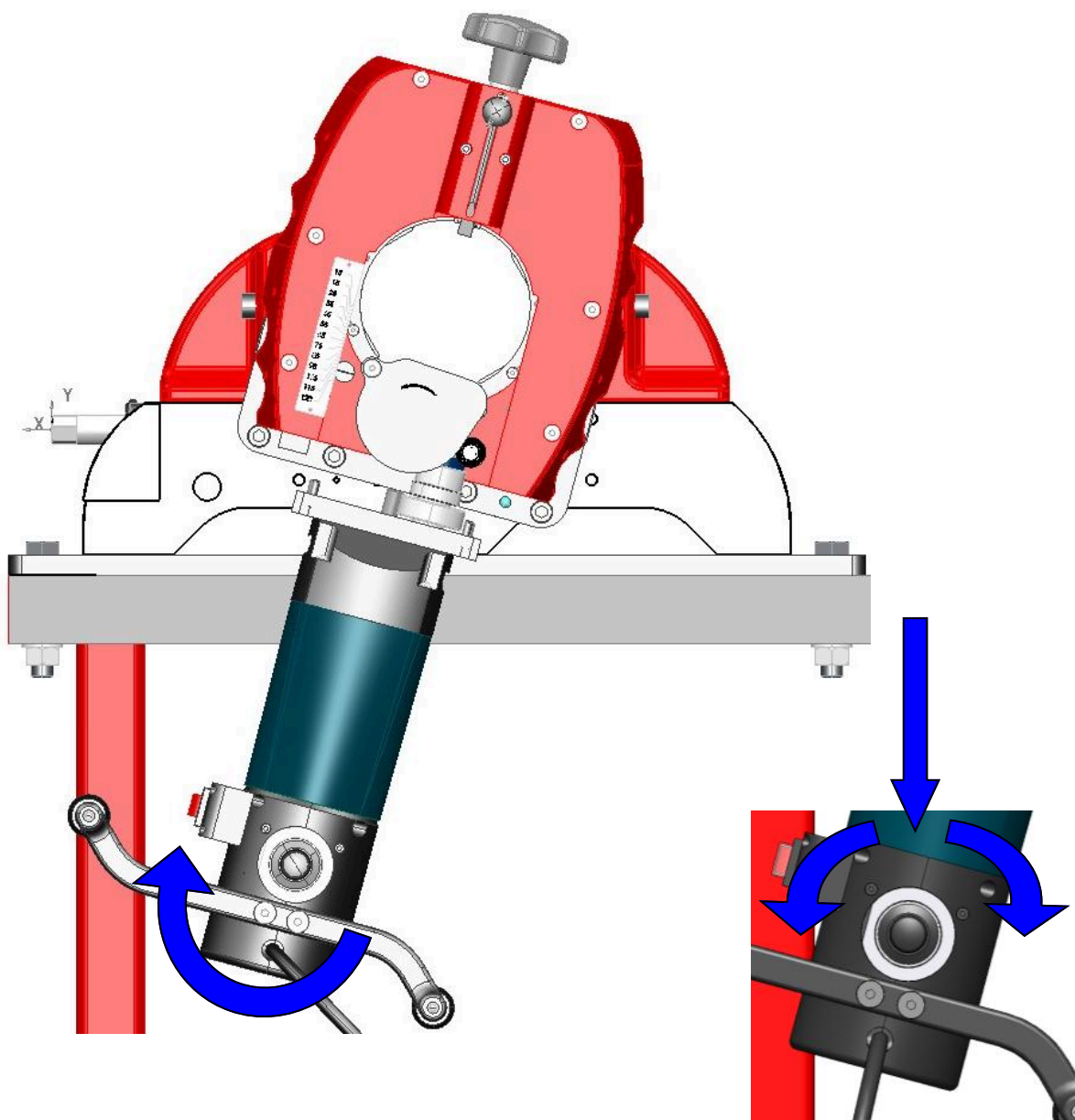
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



Begin the cutting operation by slowly rotating the machine clockwise on its axis. See the operation shown in the picture.

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



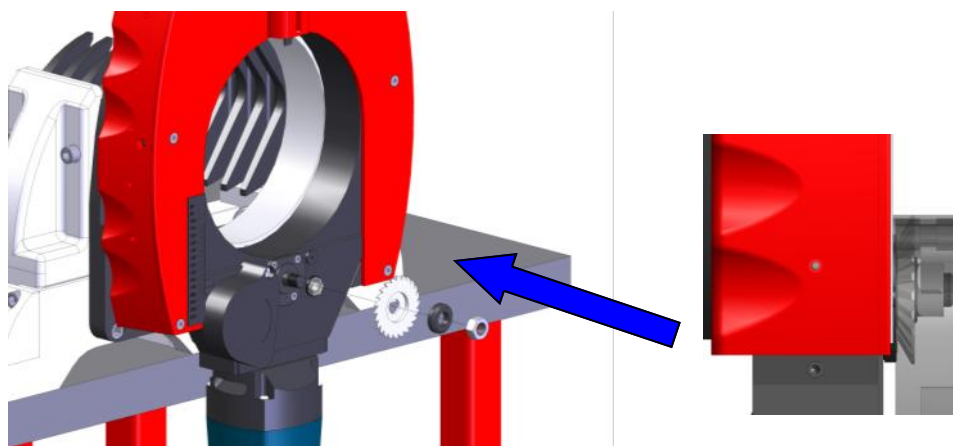
The milling tool speed can be adjusted in function of the type of material and the thickness of the pipe, by rotating the speed regulator knob located on the lower part of the motor.

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

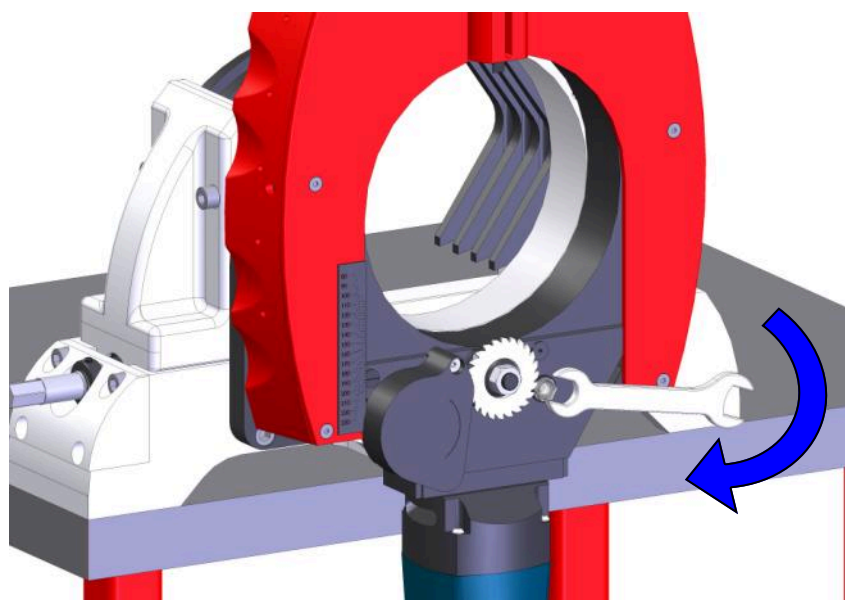
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



Esecuzione smusso



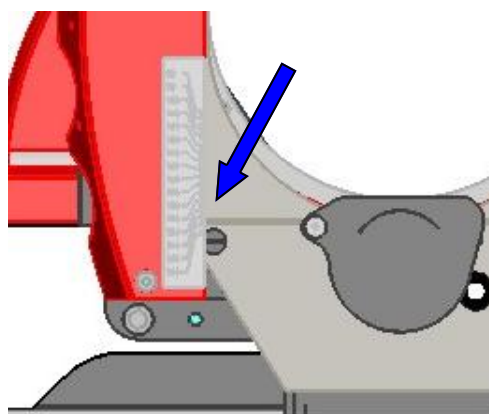
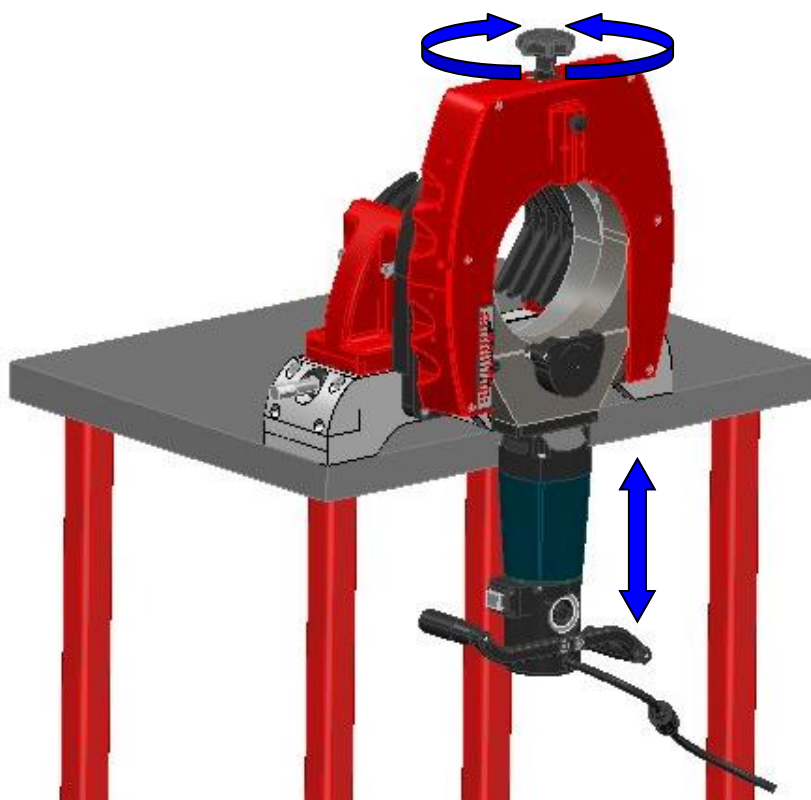
Inserire fresa da smusso prestando attenzione che la parte inclinata sia rivolta verso l'interno della macchina.



Inserita la fresa avvitare in senso orario il dado di bloccaggio serrandolo fino in fondo.

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

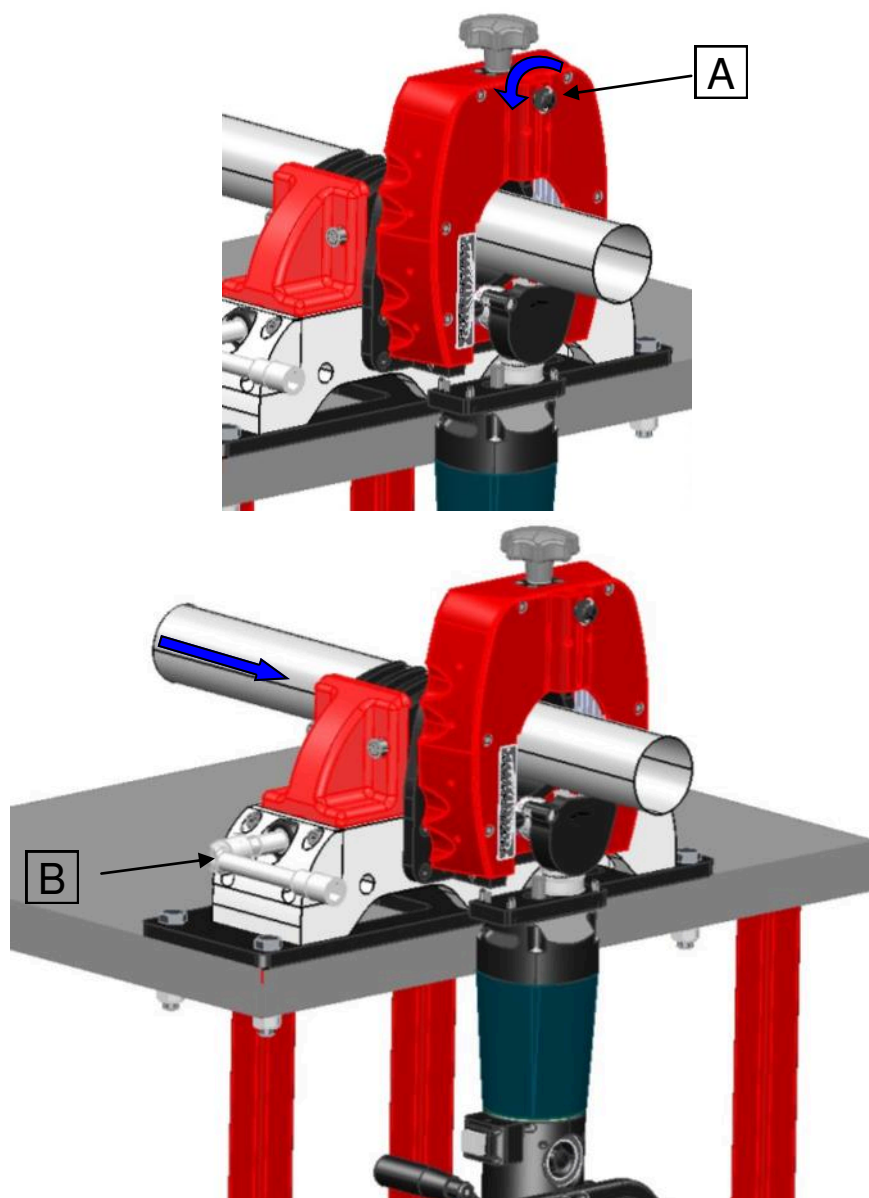
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



Ruotare il volantino superiore e posizionare l'asta graduata in corrispondenza del diametro desiderato da lavorare (range di bloccaggio 80 e 230mm)

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

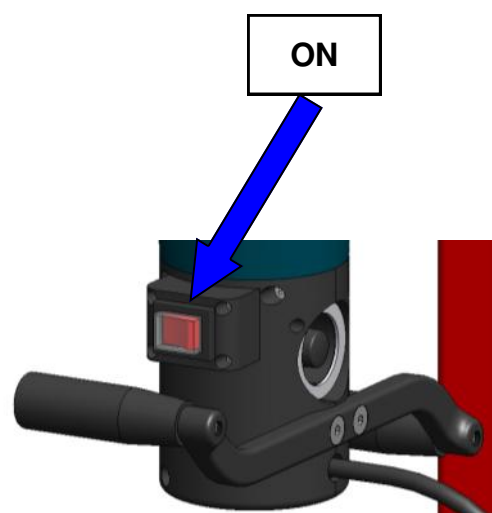
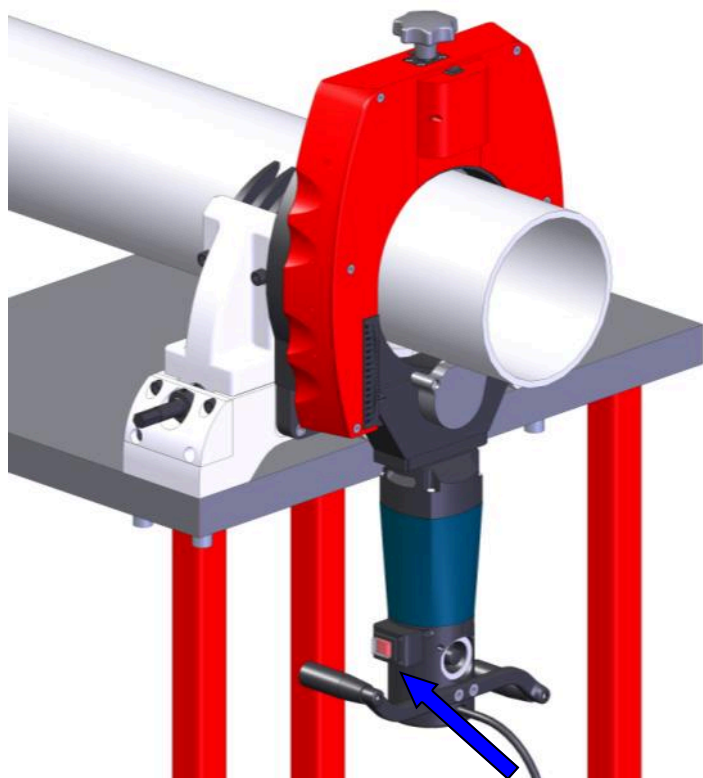
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



Svitare in senso antiorario il volantino frontale A e far scendere il cuneo di riferimento in appoggio sul tubo fino alla misura del taglio desiderata.
Successivamente, bloccare il tubo sul punto di taglio serrando, a fondo, la vite della morsa con la chiave in dotazione B.
Infine, riportare il volantino frontale A in alto e serrarlo in senso orario mettendo in posizione di sicurezza il cuneo di riferimento.

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



Prima di procedere si consiglia di oliare opportunamente la fresa con olio e pennello in dotazione

Accendere la macchina con il pulsante ON (vedi figura)

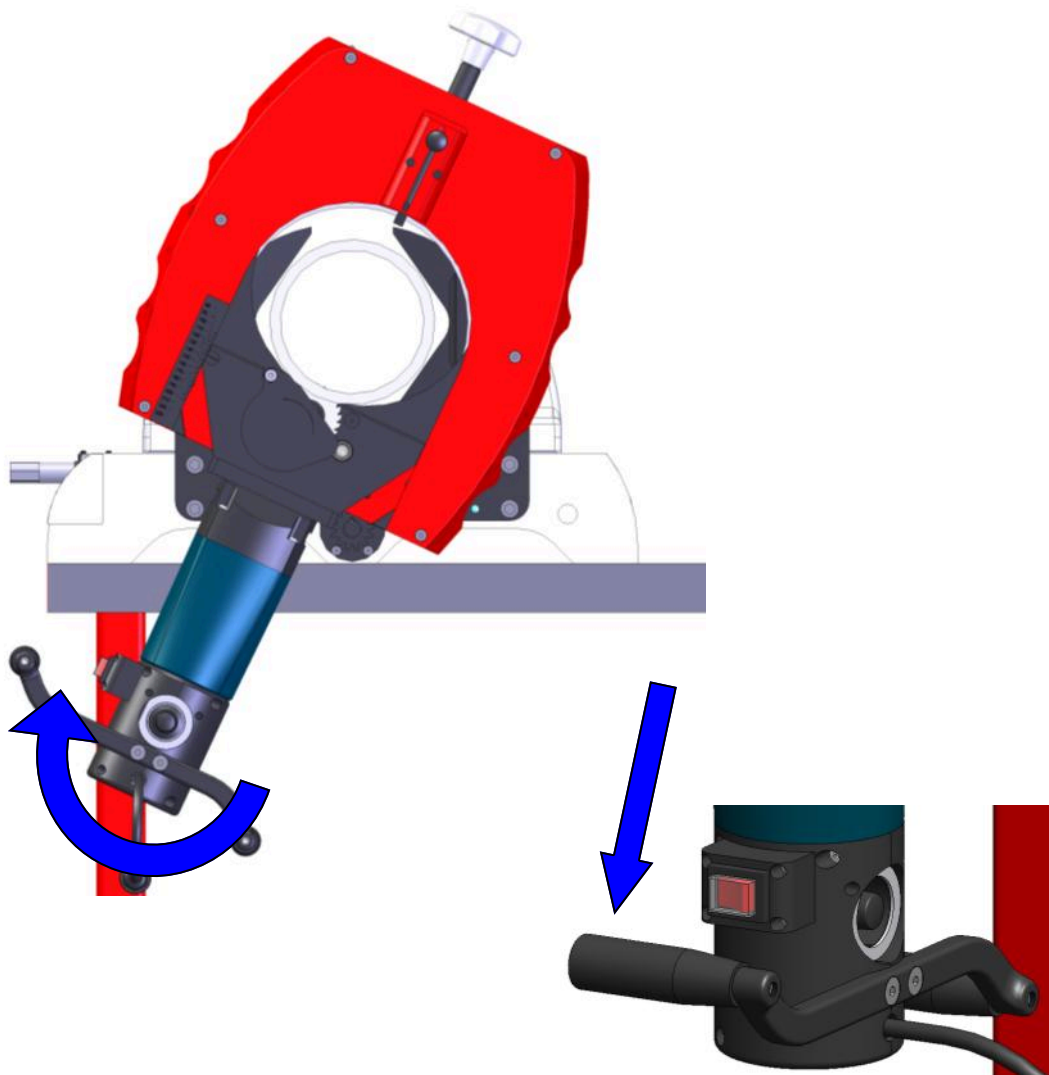
ATTENZIONE



L'INTERRUTTORE RIMANE NELLA POSIZIONE "ON"
FINCHE' NON VIENE PREMUTO MANUALMENTE NELLA POSIZIONE "OFF"

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

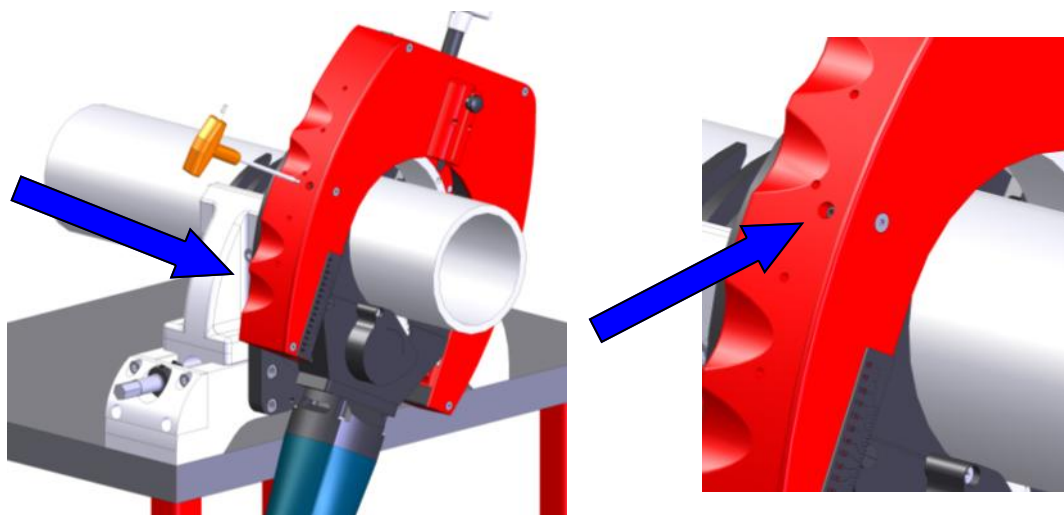
Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



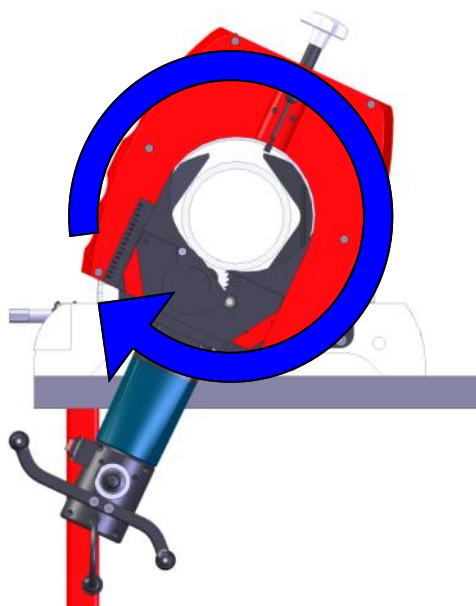
Utilizzando le manopole del motore, iniziare il taglio facendo ruotare molto lentamente, in senso orario, la macchina sull'asse del tubo (vedi figura) fino alla penetrazione completa della fresa nel tubo.

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



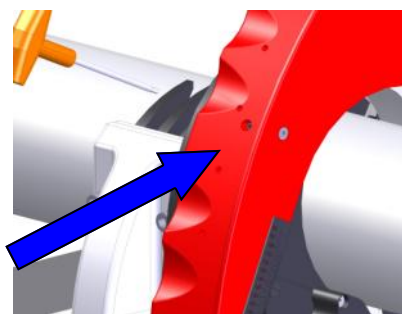
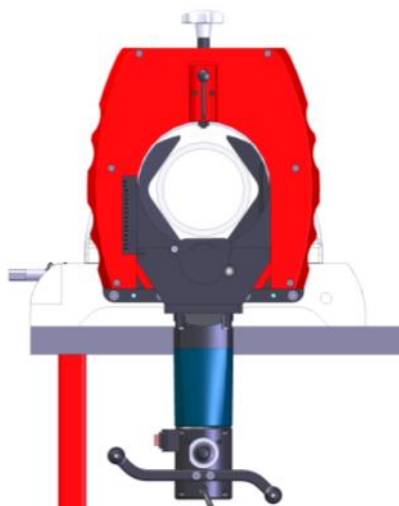
Bloccare il corpo fresa avvitando in senso orario il grano con la chiave in dotazione.



Eeguire 1 giro e 1/4 per completare lo smusso.
Se ritenete che la finitura della superficie non è soddisfacente eseguire un ulteriore giro completo della macchina.

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



Riposizionate la macchina come nella fase iniziale della lavorazione e sbloccate il grano precedentemente bloccato.



Verificare prima di procedere ad un'altra lavorazione che la macchina sia posizionata correttamente nella sua sede di inizio lavoro.

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



ORDINARY MAINTENANCE

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

PERIODICAL CHECKS

- Verify the general conditions of the machine;
 - Always use the filter + lubricator when using pneumatic machines
 - Ensure the filter + lubricator is mounted the nearest possible to the machine and that the lubricant contained is supplied by G.B.C. Industrial Tools S.p.A. only.
 - Perform a compressed air periodical cleaning on the threaded part of the guiding shaft and in the rear part of the machine.
 - Always ensure that the seats of the tools on the chuck are clean
 - Every 20 – 30 hours ensure the security valve has no air leaks
 - Ensure no air leaks are present on the air supply system nearby the connection between the machine and the hose.
 - Introduce some drops of gasoline or similar oily solvent in the air intake nipple of the pneumatic motor and start the machine in idle.
 - Always use well sharpened tools to obtain the maximum result.

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

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



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 cut. Check the conditions of the cutting blade and ensure the pipe you are trying to cut does not require special tools to be worked. Always ask suggestions to your referent in G.B.C. as we are at your complete disposal.

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.