



## INSTRUCTION MANUAL



# MOTORIZED 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



# PIPE 8

Original Instructions—rev.2014—in compliance with § 1.7.4 of the Machinery Directive  
2006/42/CE



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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 procedures of any sort and plate beveling machines..

The Headquarters are located in Torbiato di Adro (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 Torbiato di Adro – 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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## **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.

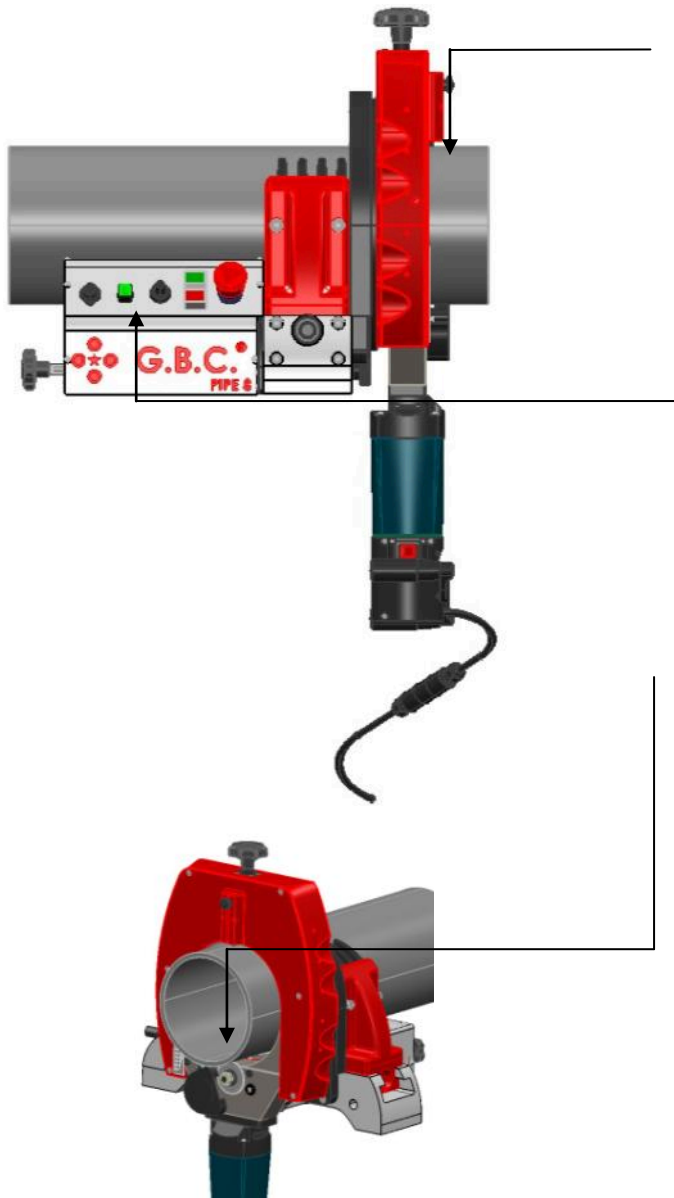
Any ordinary maintenance performed by the customer/user or by any service centre non recognized or approved by G.B.C. Industrial Tools S.p.A. will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials,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

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## **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.

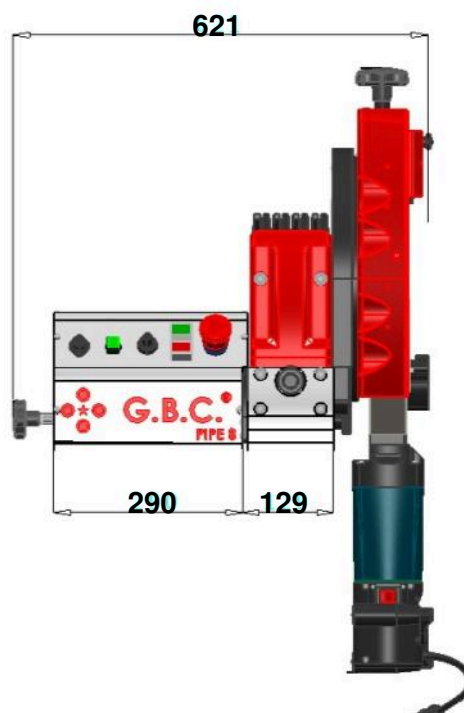
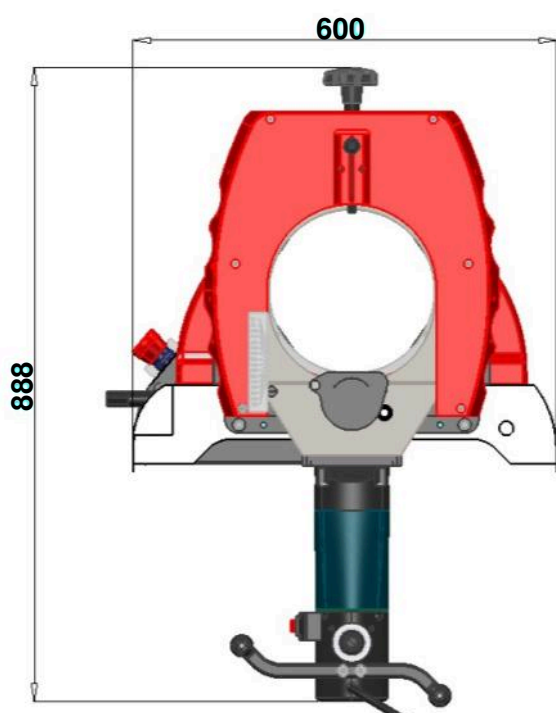
FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTABLE MISUSE OF THE UNIT

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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



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## **MACHINE STANDARD EQUIPMENT**

The machine is supplied with:

- N° 3 blades
- Lubricant Bottle and Brush
- 20-22mm Double Opened End Wrench
- 19mm Double Ended bi-hex Tubular Wrench
- 4mm Allen Key
- Wooden Case
- Instruction Manual and Exploded Drawings

### **Pipe 8**



### **Wooden Case**



### **Service Tools**



### **Instruction Manual and Exploded 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.

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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.

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	<b>130</b>	
Shipping Dimensions	mm	<b>1250x900x675</b>	
Shipping Weight	kg	<b>145</b>	

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

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## **MACHINE STABILITY**

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

## **WORKPLACE**

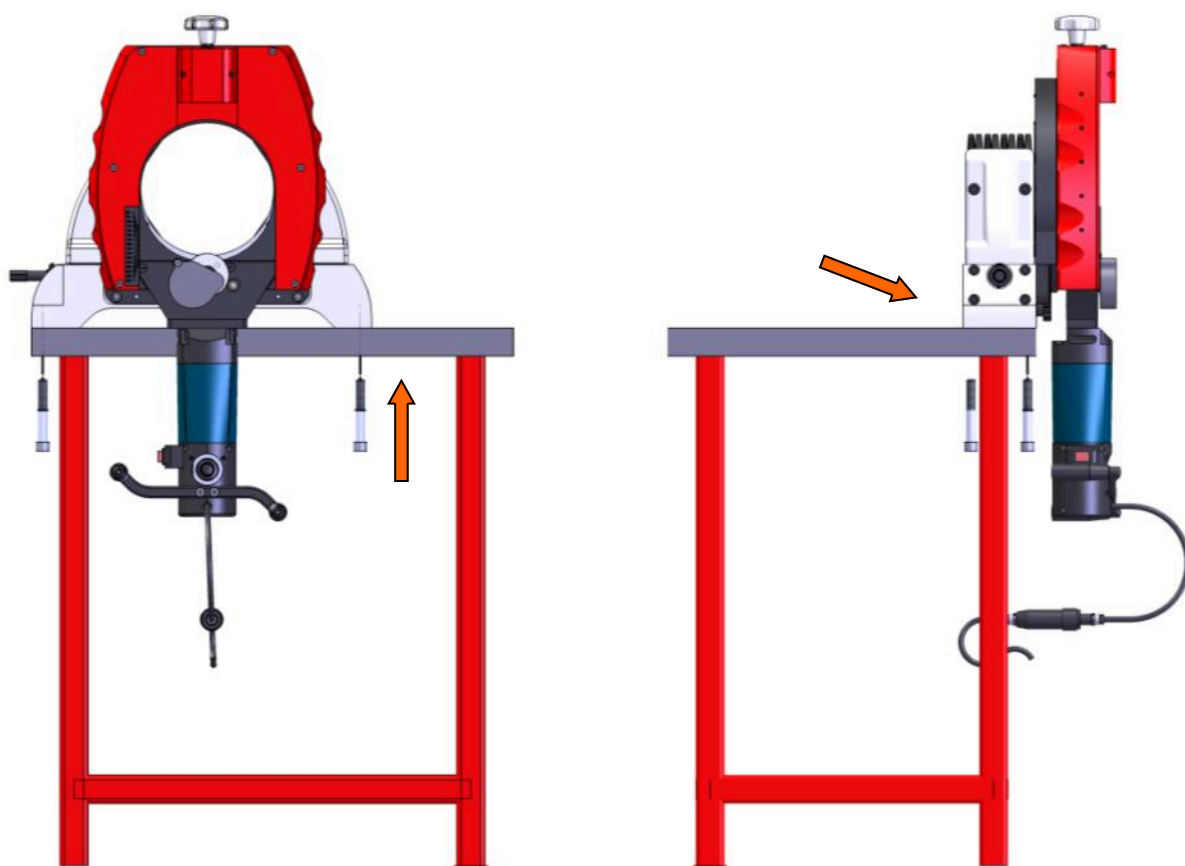
By always using both hands for operating the machine, the operator is unable to reach the bevelling tools as the unit would suddenly stop – motor brake –

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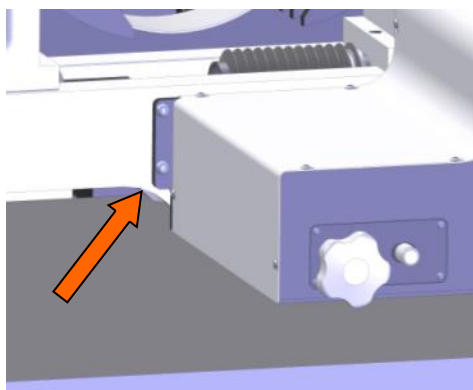
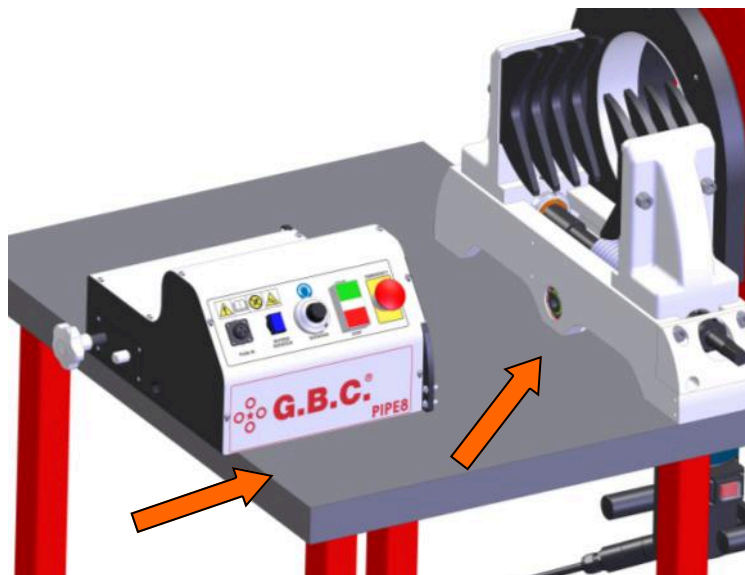
## **MACHINE SETUP**



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).

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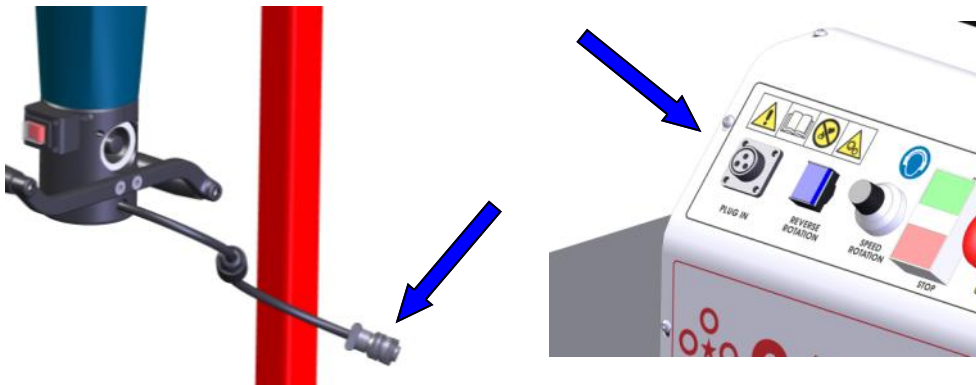
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Take the rotation motorized kit out of the package and place it on the workbench as shown in the above picture. Insert the motorized kit in the shaft seat, and once the position is definitely chosen, fix it in place with the 4 screws supplied with the kit itself.

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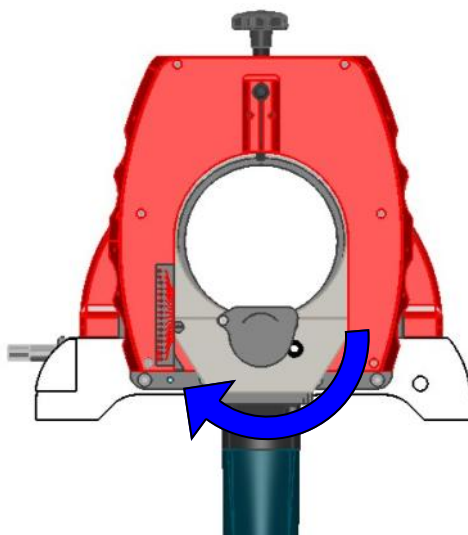
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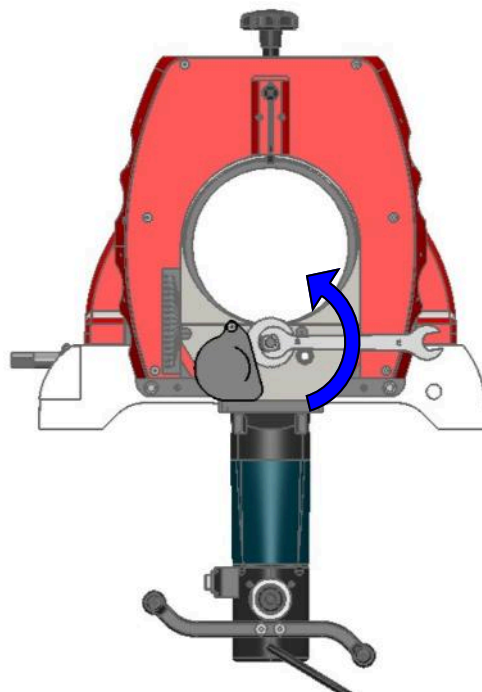
Plug the connection cable of the motor into the control pane socket as shown in the above picture, subsequently plug the machine to the electric grid.



## **MACHINE SETUP**



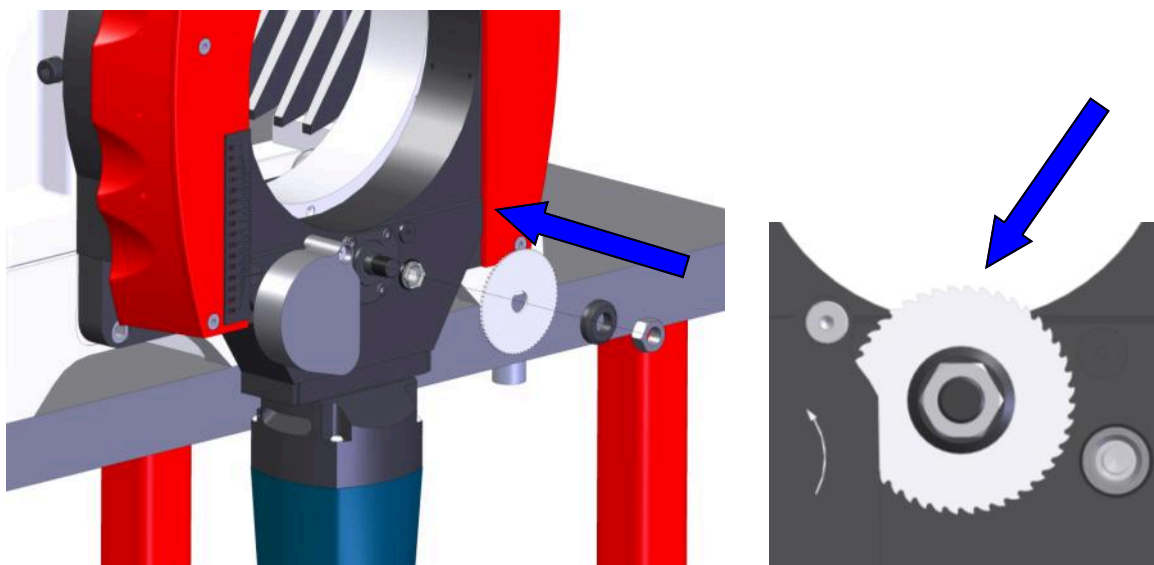
Rotate the blade guard as shown in the picture.



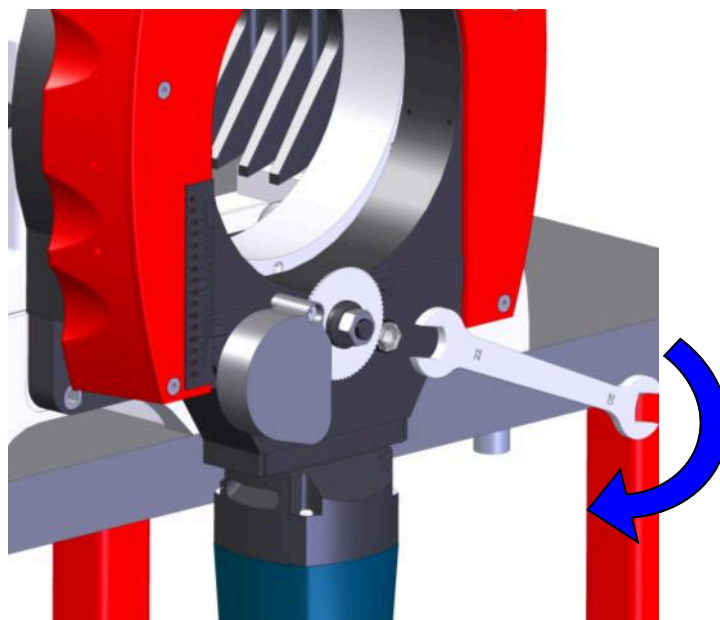
Unscrew the locking nut with a counter-clockwise movement using the wrench supplied with the machine.

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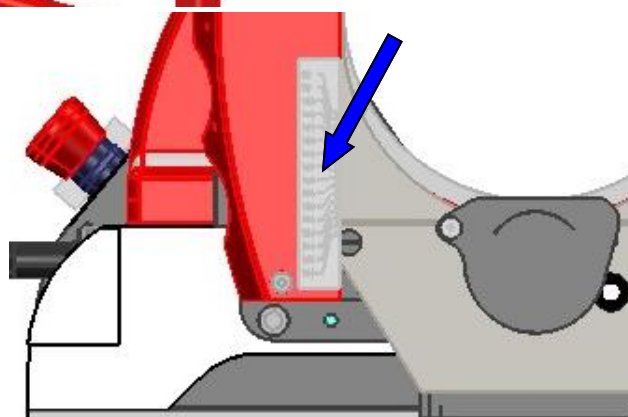
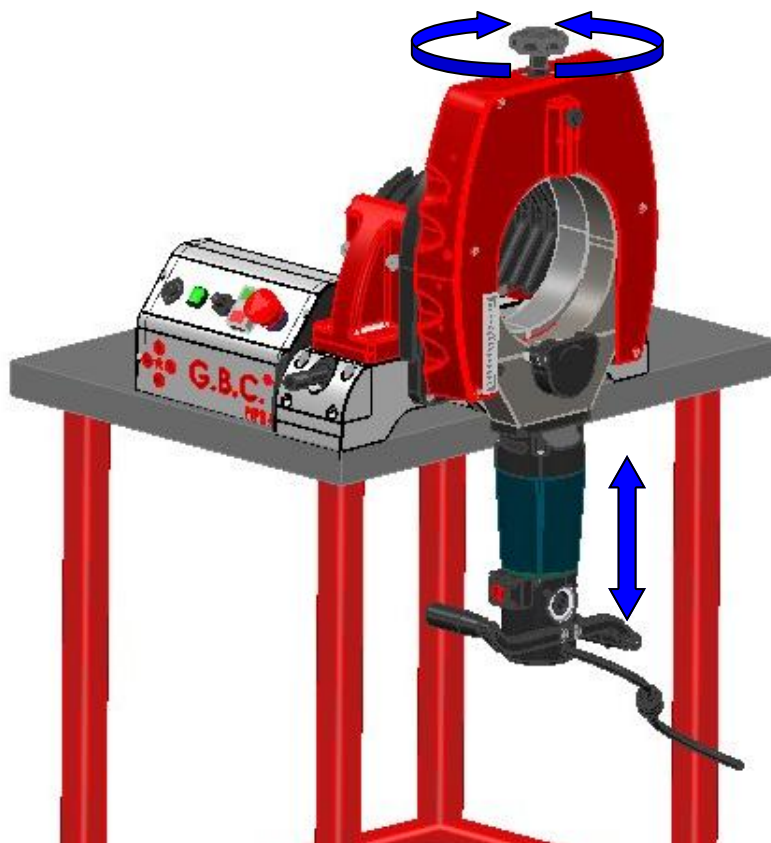
Install the milling tool suitable for the job making sure it is well greased for a better grip, paying attention to the direction of the cutting teeth which must be exactly as shown in the picture.



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

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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 gauge applied on the side of the machine will grant you the maximum accuracy.

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Turn counter-clockwise the knob located on the upper front part of the machine to release the cut point indicator. Now push the pipe into the machine until the cut point desired gets perpendicular to the cut point indicator. Lock the pipe by turning the screw on the side .

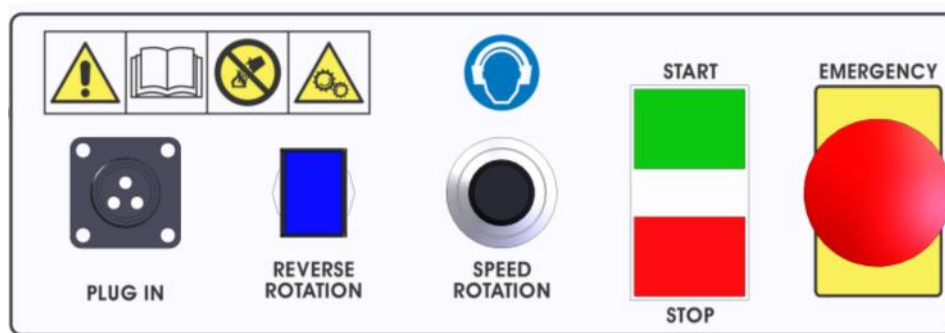
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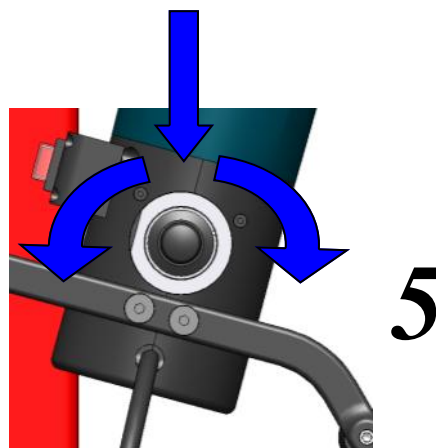


## MACHINE STARTUP

### CONTROLS



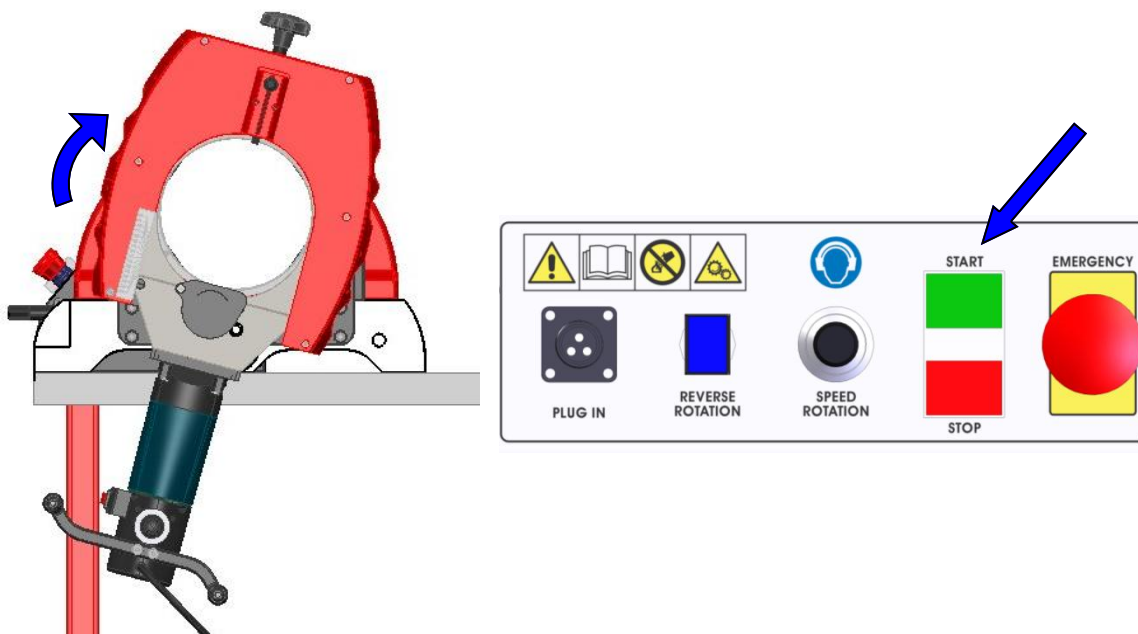
**1**      **2**      **3**      **4**



- 1 - Reverse Rotation**
- 2 - Speed Rotation Knob**
- 3 - START e STOP Button**
- 4 - EMERGENCY STOP**
- 5 - Blade Speed Regulator**

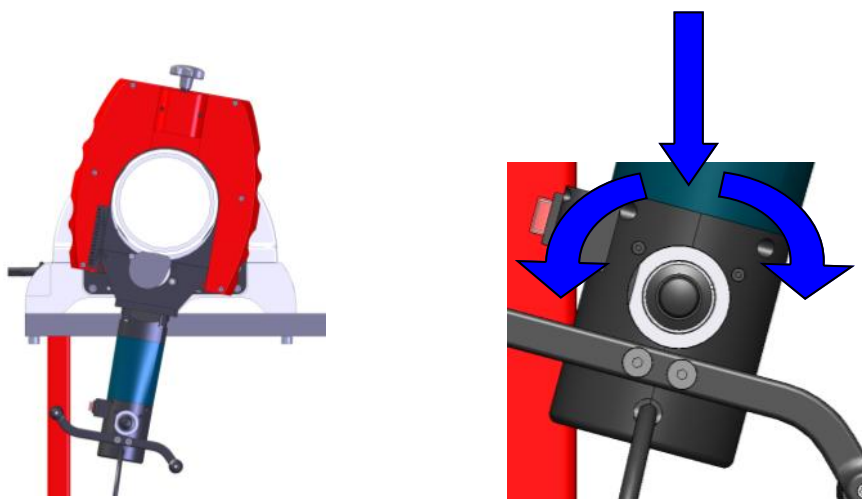
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N.B. Apply some lubricant on the blade with the brush before starting the machine when possible.

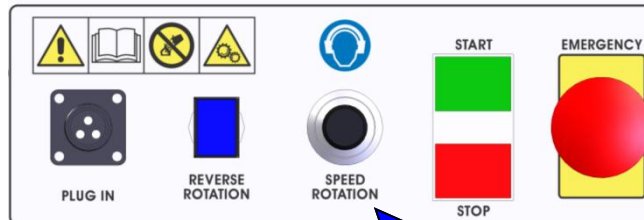
Start the machine by pressing the green button “START” shown in the above picture.



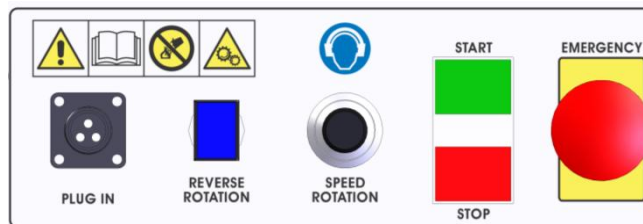
Adjust the blade speed according to the material and wall thickness of the pipe you are cutting by acting on the blade speed knob located at the base of the motor as shown above.

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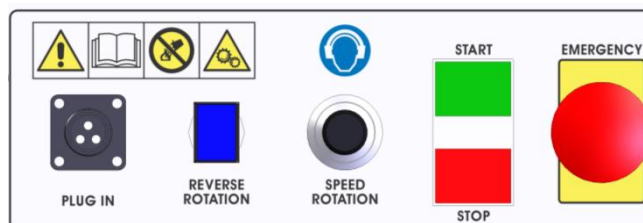
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The machine speed rotation can be adjusted during the cutting operation by acting on the SPEED ROTATION knob as shown above.



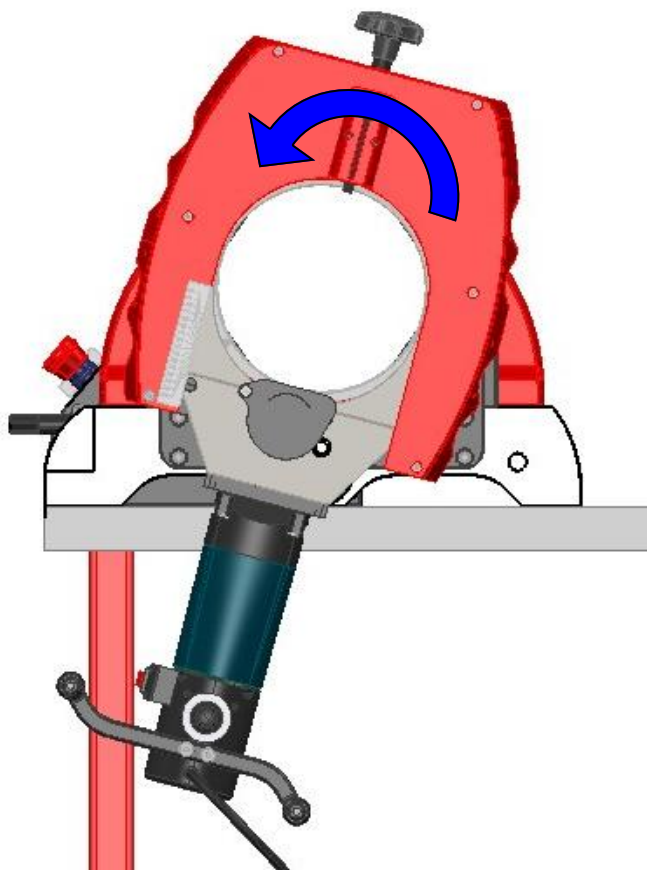
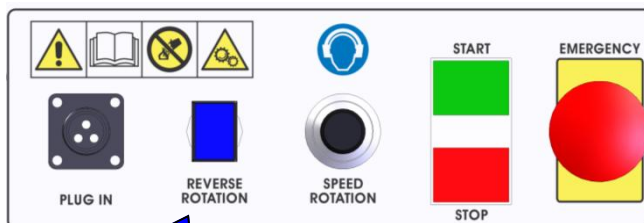
As soon as the cut is done, therefore the machine has completed the entire revolution. Press the red “Stop” button.



In case of emergency press the red “EMERGENCY” button to shut the machine down bringing it to a complete and immediate stop.

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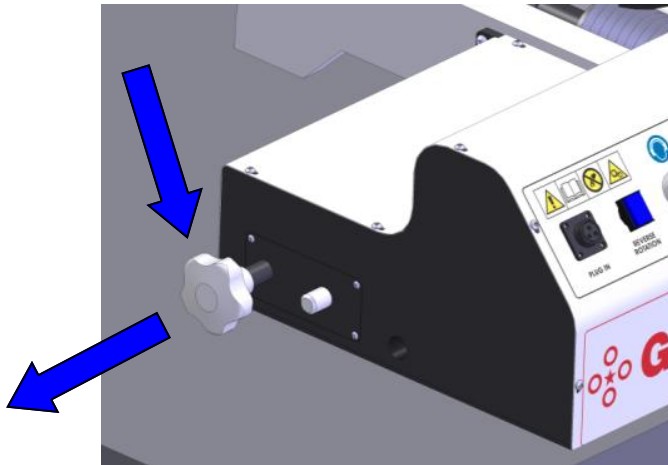
In case of any problem during the working process press the EMERGENCY STOP button to stop the machine.  
If necessary press “REVERS ROTATION” to unjam the machine if necessary.

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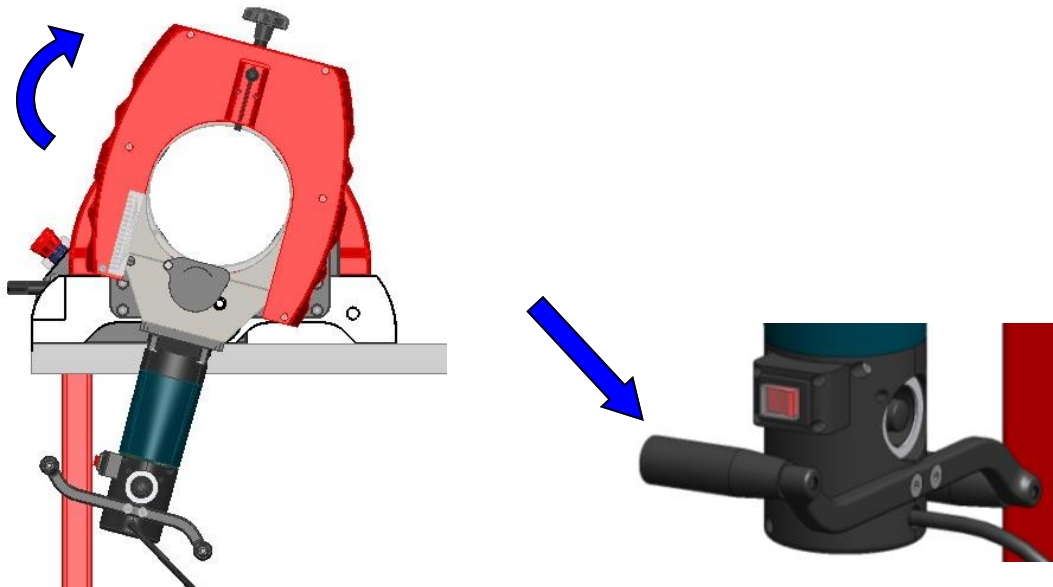
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## MANUAL SETUP



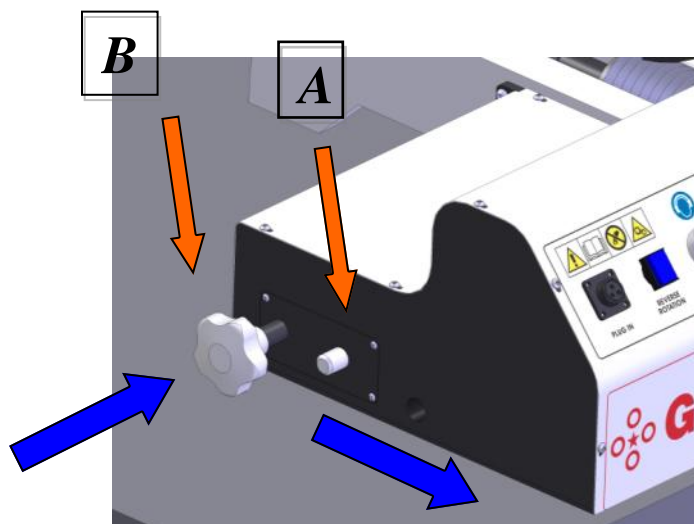
In case you want to cut manually you will have to pull out the knob indicated by the arrow in the above picture until the shaft is disengaged.



Now you can begin the manual cutting operation by rotating the machine on its axis as shown in the above picture.

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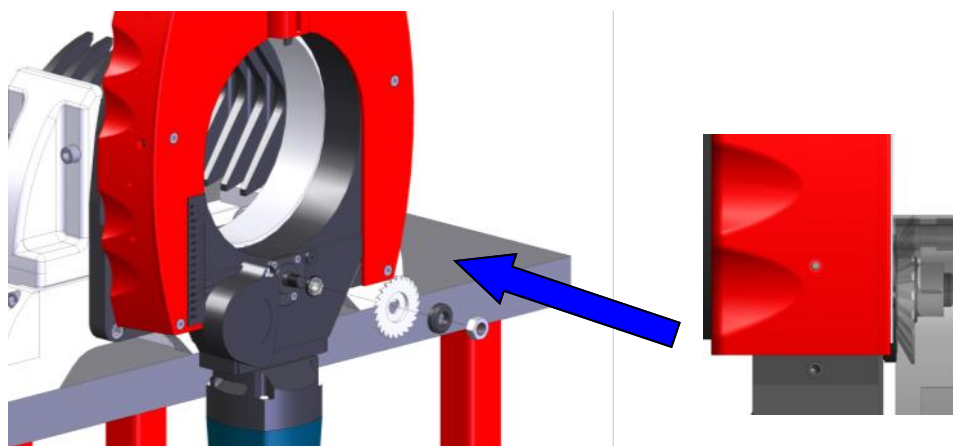
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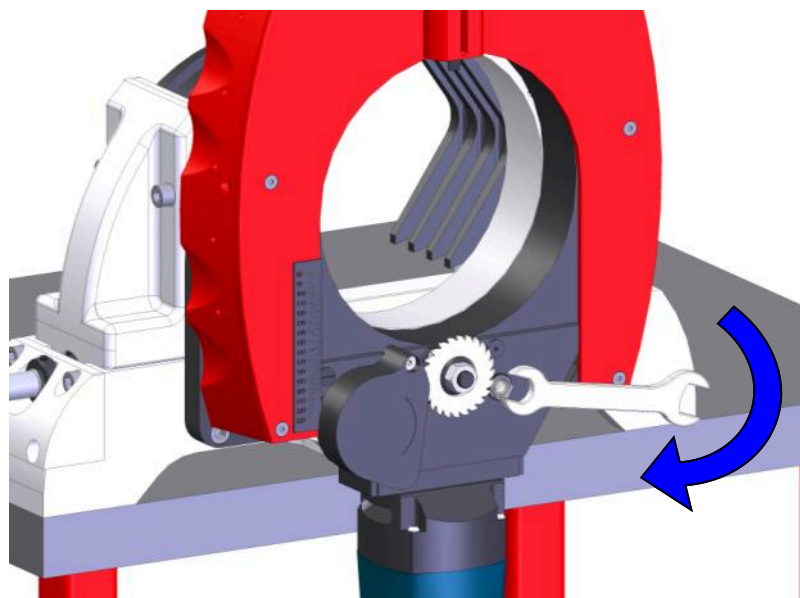
To reset the machine in automatic rotation configuration you will have to move the pin (A) in the direction of the arrow and at the same time push the knob (B) inward .



## Esecuzione smusso



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

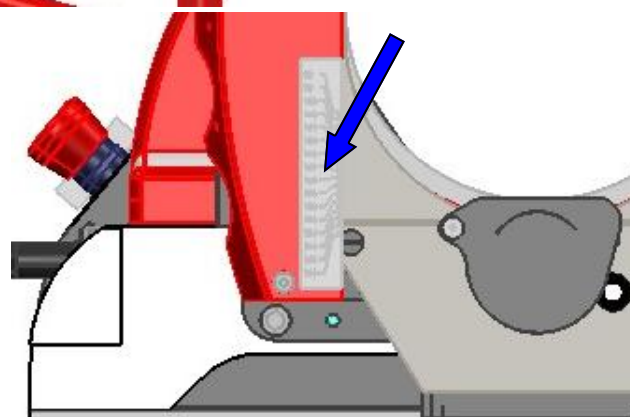
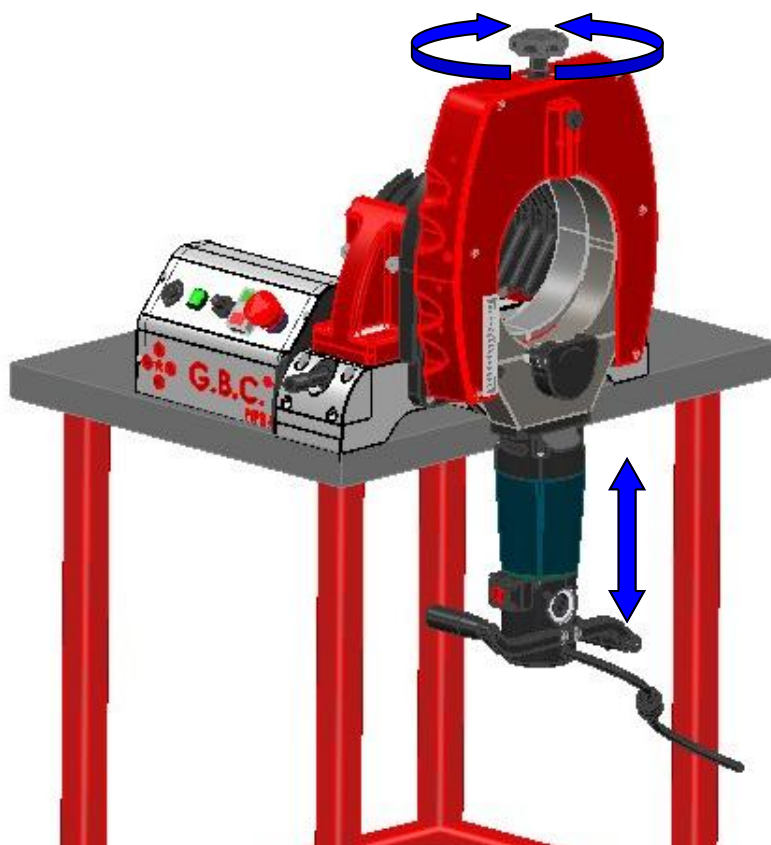


Inserita la fresa avvitare in senso orario il dado di bloccaggio serrandolo fino in fondo.

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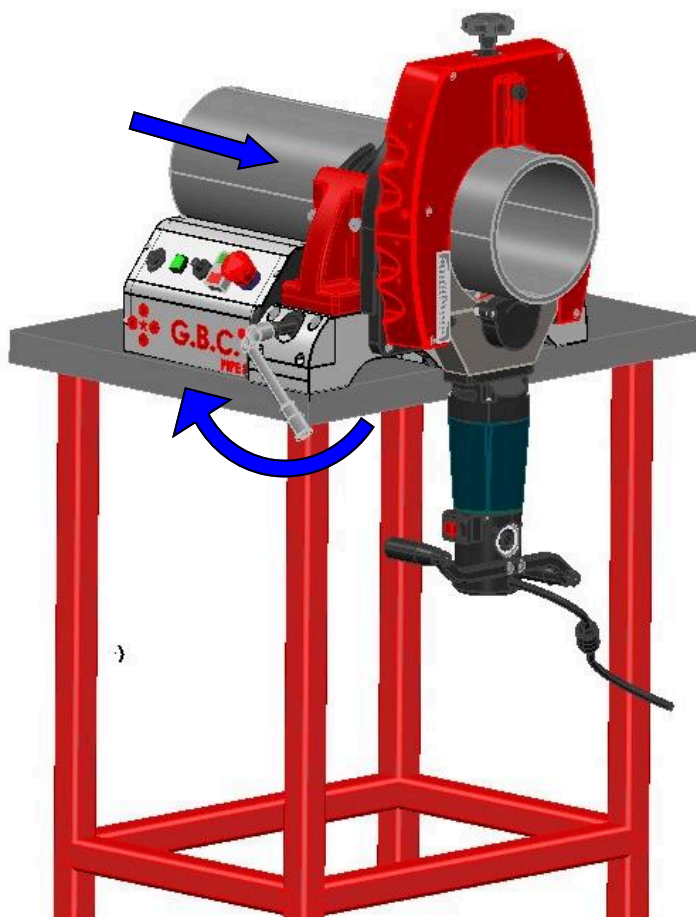




Ruotare il volantino superiore e posizionare l'asta graduata in corrispondenza del diametro desiderato da lavorare (range di bloccaggio 80 e 230mm)

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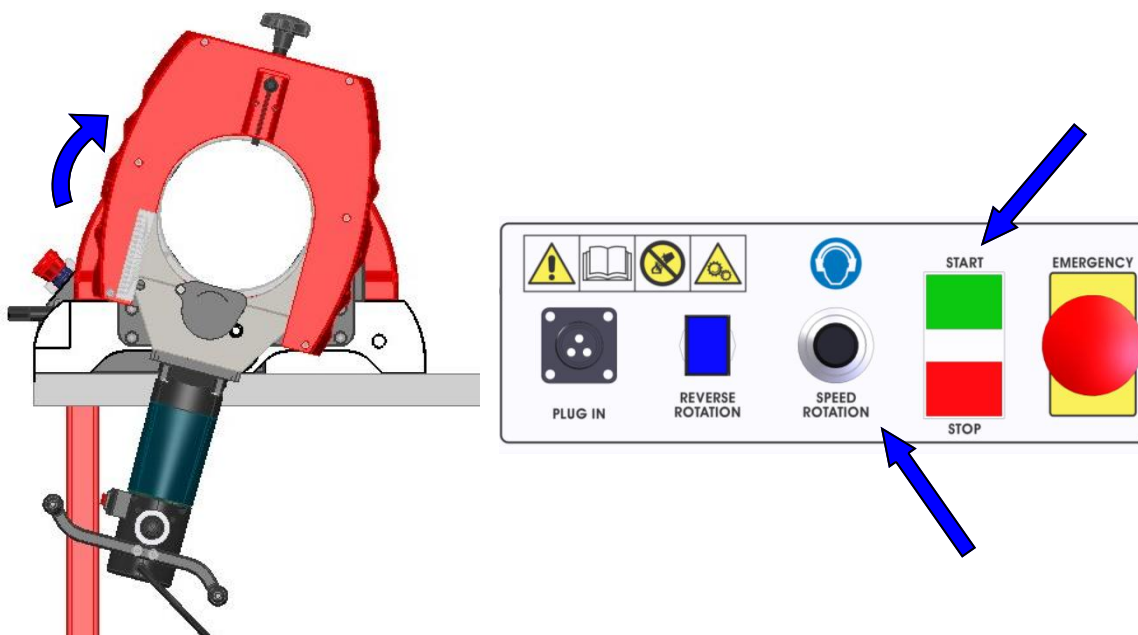
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Svitare in senso antiorario il volantino frontale e posizionare far scendere il cuneo di riferimento sul tubo fino alla misura del taglio desiderata e bloccare il volantino .  
Bloccare il tubo sul punto di taglio serrando a fondo la vite della morsa con la chiave in dotazione.

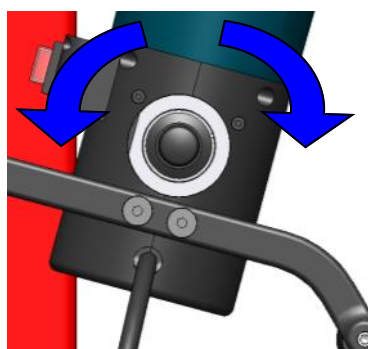
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Prima di procedere si consiglia di oliare opportunamente la fresa con olio e pennello in dotazione

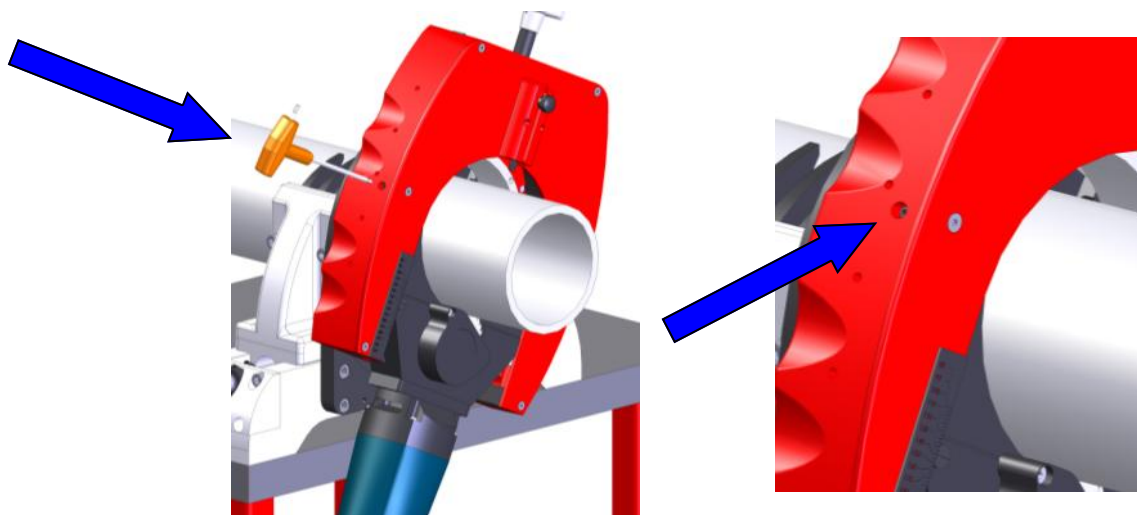
Accendere la macchina con il pulsante START (vedi figura) e iniziare ad eseguire lo smusso finché la fresa è penetrata completamente nel tubo e agendo sulla manopola “**SPEED ROTATION**” fermare la rotazione della macchina



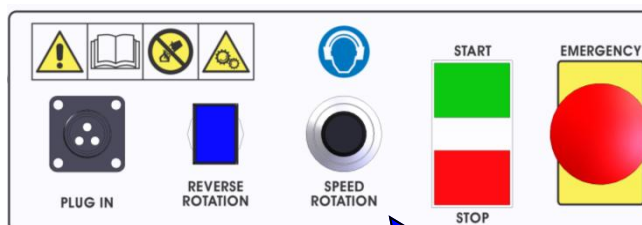
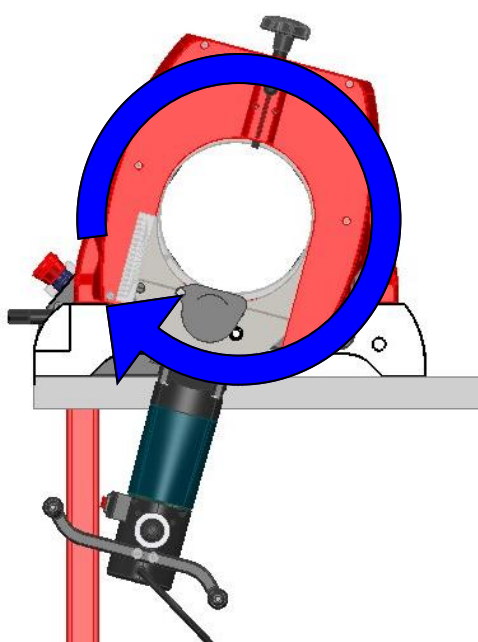
Variare la velocità di taglio della fresa in funzione del materiale e dello spessore del tubo, ruotando la manopola del regolatore di velocità, situato alla base del motore come evidenziato (vedi figura)

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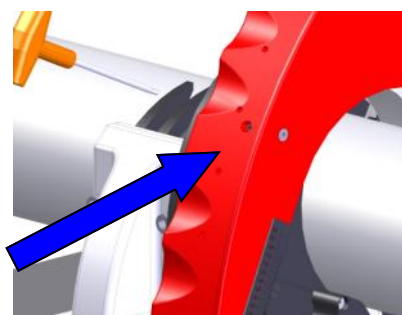
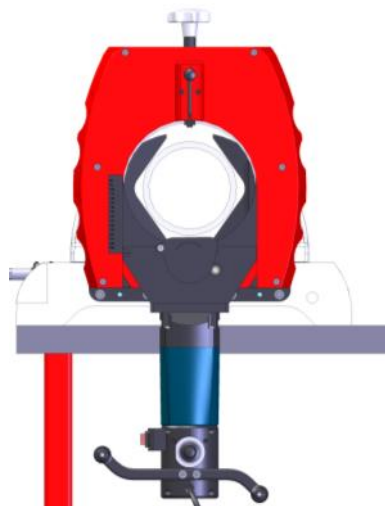
Bloccare il corpo fresa avvitando in senso orario il grano con la chiave in dotazione.



Agendo sulla manopola “**SPEED ROTATION**” riprendere la lavorazione eseguendo 1 giro e 3/4 per completare lo smusso e riportando la macchina nella posizione iniziale come precedentemente illustrato.

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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.**

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## **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.

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# PIPE 8

Original Instructions—rev.2014—in compliance with § 1.7.4 of the Machinery Directive  
2006/42/CE



## **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.

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