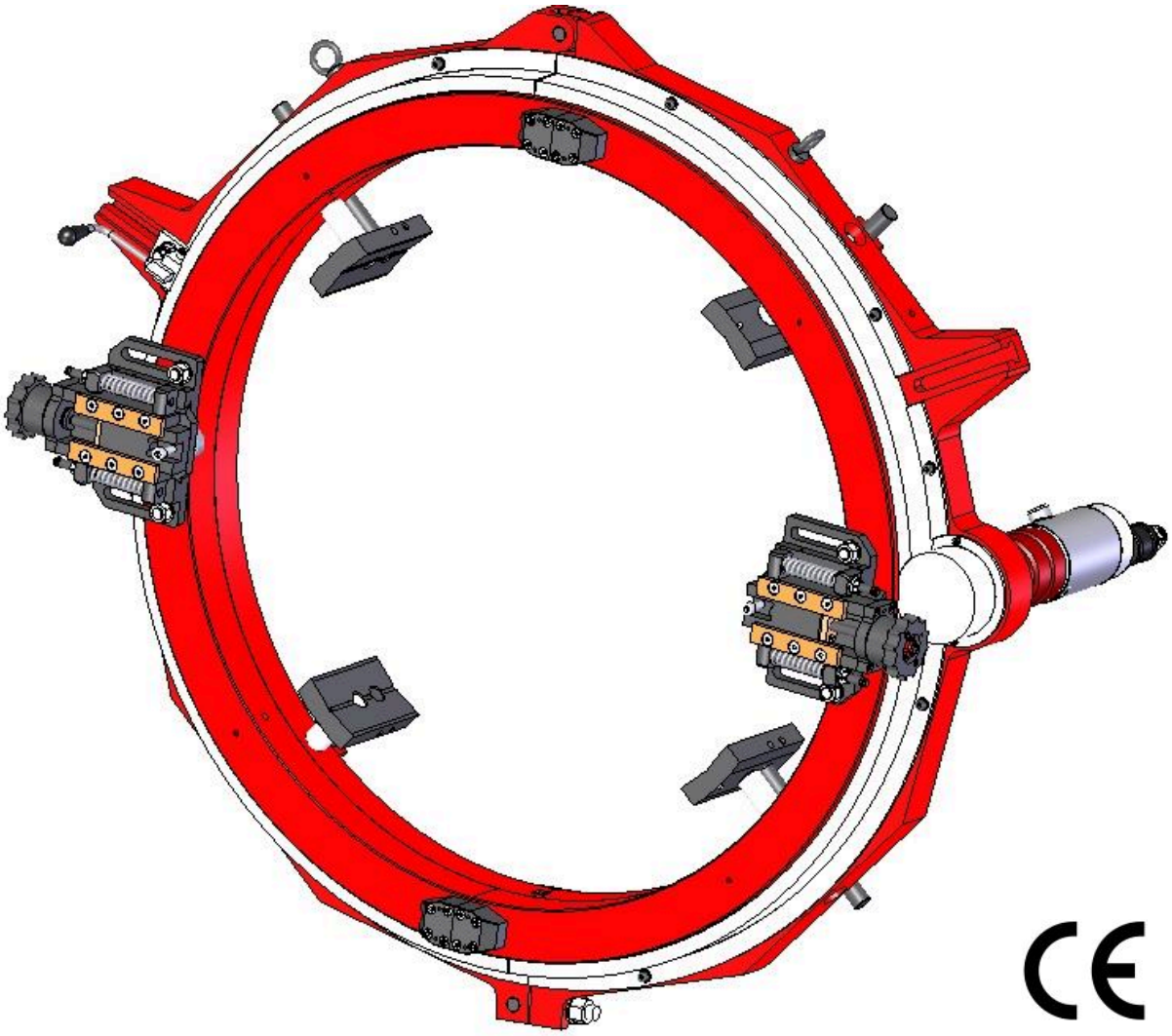
INSTRUCTION MANUAL



SUPERCUTTER

Version 03 - 2017

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

SUPERCUTTER 6”/60”

Original Instructions Rev. 03 - 2017 in compliance with the § 1.7.4 of the Machine Directive 2006/42/CE

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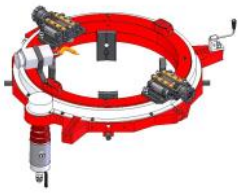


PRESENTATION OF THE COMPANY AND INTRODUCTION TO THE INSTRUCTION MANUAL

G.B.C. Industrial Tools S.p.A. is known worldwide for the quality of its machines and accessories **for pipe cutting and beveling preparations, plate beveling and back gouging processes,**
The Headquarters are in Cazzago San Martino (BS) - Italy, where the General Management, the Sales Department, the Shipping Department and the Manufacturing Plant operate under the very same roof.
QUALITY STANDARD—All our machines are assembled according to the highest quality standard. In 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 **Instruction Manual** is supplied in one original with the machine you have purchased . You may apply for further copies at any time using the contact number or email address stated below.

Any operation performed on the machines that is not described in this manual will automatically void the warranty.
G.B.C. Industrial Tools S.p.A. recommends to contact the Sales Department in Cazzago San Martino – Italy for any clarification needed .

Always make reference to the information written on the machine identification label.

Contact details:

Tel. +39 - 030 - 7451154
Email : sales@gbcspa.com

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 shipmen 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.

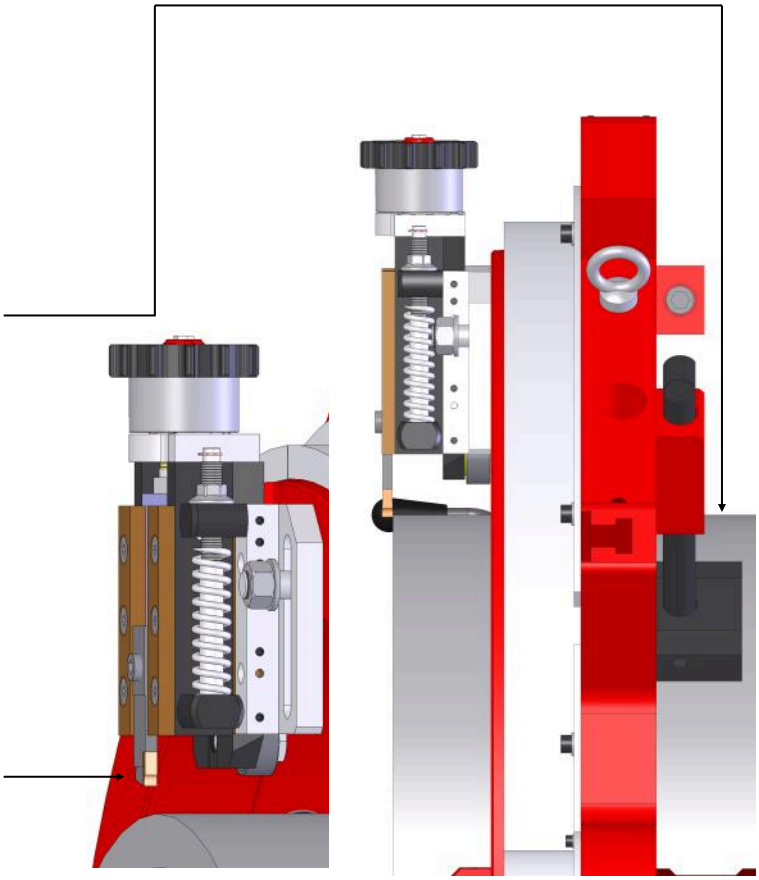
N.B.:Filter lubricator units are necessary accommodations for all pneumatic tools in an industrial environment in order to ensure maximum machine performance and to prevent premature motor breakdown. Failure to use a filter lubricator properly calibrated to this unit will void certain warranty claims.

INTENDED USE OF THE MACHINE

The Supercutter is normally employed for cutting and beveling pipes with OD up to 1530 mm and wall thickness up to 60mm, made of any kind of steel.

The unit has to placed on the OD of the pipe and it is fixed by specific locking feet.

The cutting and beveling operations are obtained through tools with different shape according to the specific preparation desired and by the type of material that has to be worked.



THE SUPERCUTTER 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 PREDICTALBE MISUSE OF THE UNIT

SUPERCUTTER 6”/60”

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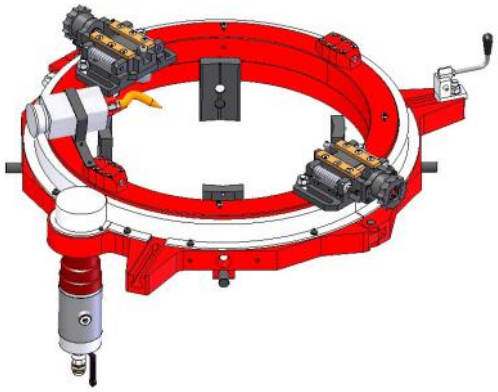
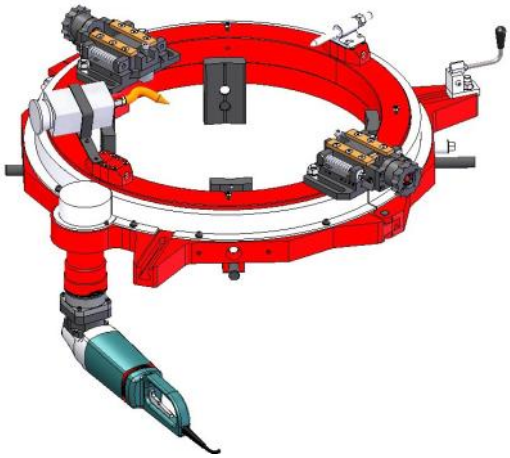
SUPERCUTTER CONFIGURATIONS

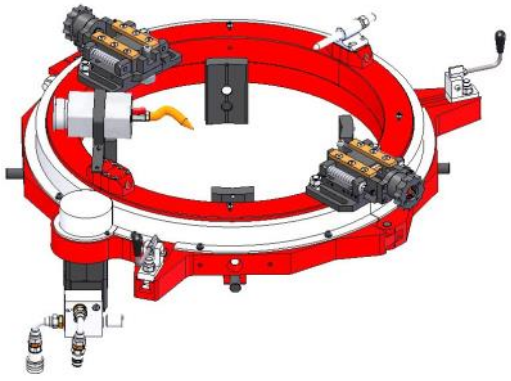
PNEUMATIC



ELECTRIC



HYDRAULIC



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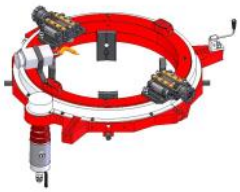
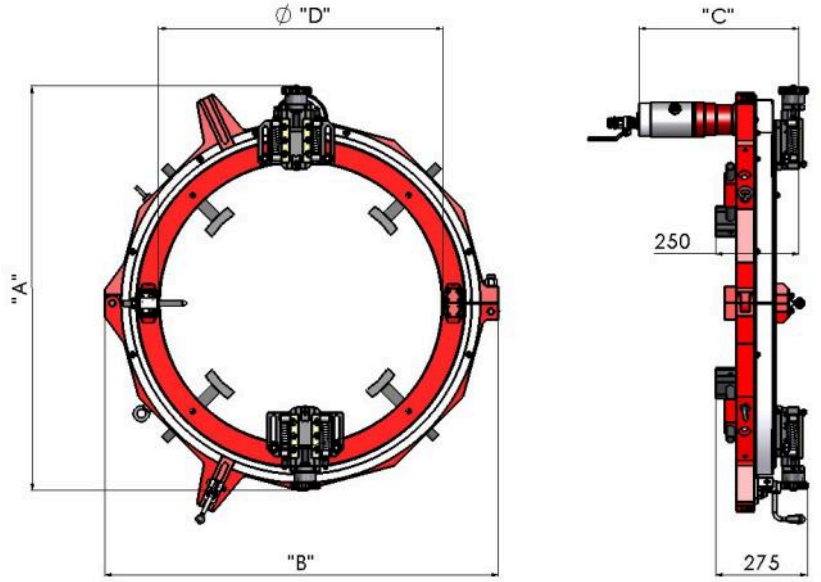


SUPERCUTTERS RANGE 06”-36”



Range	Power Source	Dimensions (mm)			
		“A”	“B”	“C”	“Ø D”
06”- 12”	Pneumatic	800	750	500	400
	Electric	800	750	500	400
	Hydraulic	800	750	370	400
12” - 18”	Pneumatic	917	863	500	527
	Electric	917	863	500	527
	Hydraulic	917	863	370	527
18” - 24”	Pneumatic	1099	1041	500	705
	Electric	1099	1041	500	705
	Hydraulic	1099	1041	370	705
24” - 30”	Pneumatic	1255	1193	500	857
	Electric	1255	1193	500	857
	Hydraulic	1255	1193	370	857
30” - 36”	Pneumatic	1610	1615	500	1010
	Electric	1610	1615	500	1010
	Hydraulic	1610	1615	370	1010

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SUPERCUTTERS RANGE 06”-36” TECHNICAL FEATURES

		SC06-12	SC12-18	SC18-24	SC24-30	SC30-36
Locking Range	mm (inches)	152.4-304.8 (6”-12”)	304.8 - 457.2 (12”-18”)	457.2-609.6 (18”-24”)	609.6-762 (24”-30”)	762-914.4 (30”-36”)
Tool Holder Stroke	mm (inches)	60 (2.4)	60 (2.4)	60 (2.4)	60 (2.4)	60 (2.4)
Radial Pitch	mm (inches)	0.125 (0.005)	0.125 (0.005)	0.125 (0.005)	0.125 (0.005)	0.125 (0.005)
Weight of the Unit	Kg	143	175	225	270	336
PNEUMATIC						
Pneumatic Motor Power	Hp (W)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)	4.2 (3100)
Air Consumption	Nl/min (cfm)	2800 (99)	2800 (99)	2800 (99)	2800 (99)	2800 (99)
Air Pressure	bar (psi)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)
Crown Max Torque	Nm	570 (6bar) 1066 (8bar)	690 (6bar) 1290 (8bar)	876 (6bar) 1637 (8bar)	1035 (6bar) 1935 (8bar)	1193 (6bar) 2231 (8bar)
Idel Speed	gg/min (rpm)	25	20	16	14	12
ELECTRIC						
Electric Motor Power	W	2400	2400	2400	2400	2400
Tension	Volt	230	230	230	230	230
Frequency	Hertz	50	50	50	50	50
Crown Max Torque	Nm	758	917	1163	1375	1587
Idel Speed	gg/min (rpm)	22	18	15	12	10
HYDRAULIC						
Hydraulic Motor Power	HP (kW)	6.8 (5)	6.8 (5)	6.8 (5)	6.8 (5)	6.8 (5)
GBC Power Pack Max Pressure	bar (psi)	180 (2610)	180 (2610)	180 (2610)	180 (2610)	180 (2610)
Oil Flow Rate	l/min. (cfm)	30 (1.05)	30 (1.05)	30 (1.05)	30 (1.05)	30 (1.05)
Crown Max Torque	Nm	2510	3035	3853	4553	5254
Idel Speed	gg/min (rpm)	29	24	19	17	14

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

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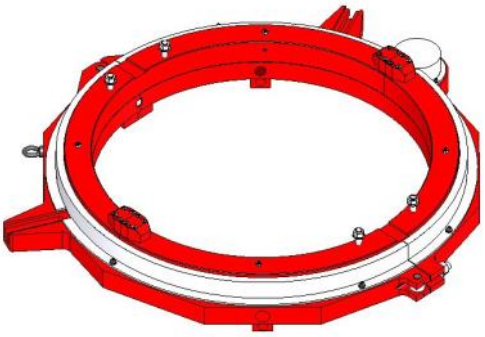
SUPERCUTTERS RANGE 06”-36” STANDARD EQUIPMENT

The units are suplied with the equipment listed below:

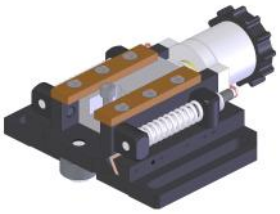
- N.1 Striker (Feeding Lever)
- N.2 Tool Holders
- N.1 Plastic Flask for Coolant
- N.1 Cut Point Indicator
- N.4 Locking Feet (each one with linear measurement markings)
- N.1 Motor
- N.1 Set of Service Tools
- N.1 Storage Wooden Box
- N.1 Instruction Manual and Drawings

Ring



Locking Feet

Tool Holders



Motor

Plastic Flask for Coolant

Cut Point Indicator

Striker

Service Tools

Storage Wooden Box

Instruction Manual and Drawings

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SUPERCUTTER 6”/60”

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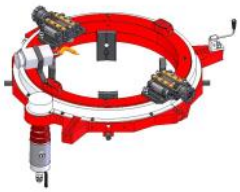
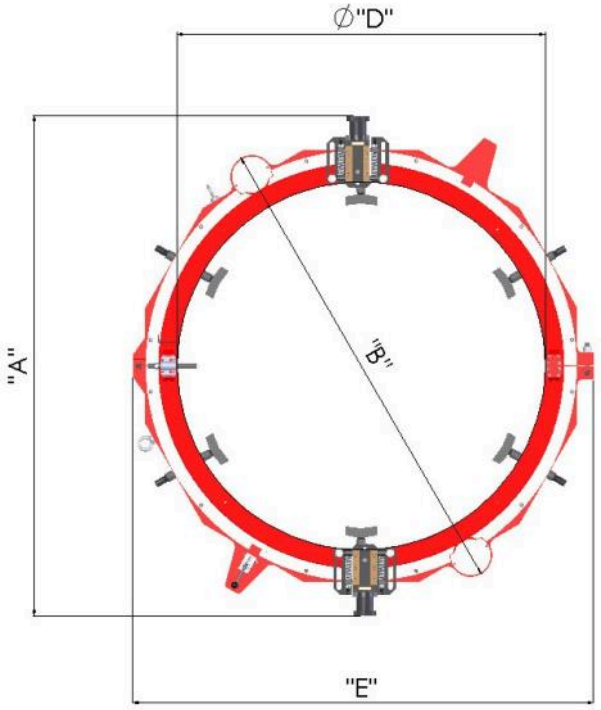
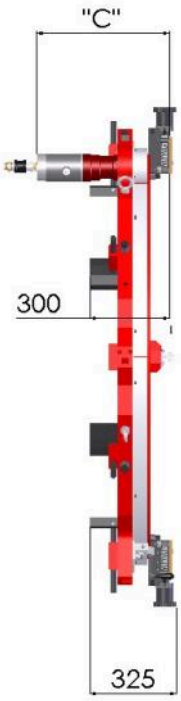


SUPERCUTTERS RANGE 36”-60”





Range	Power Source	Dimensions (mm)				
		“A”	“B”	“C”	“Ø D”	“E”
36” - 42”	Pneumatic	1610	1622	500	1207	1554
	Electric	1610	1622	500	1207	1554
	Hydraulic	1610	1622	370	1207	1554
42” - 48”	Pneumatic	1760	1770	500	1359	1706
	Electric	1760	1770	500	1359	1706
	Hydraulic	1760	1770	370	1359	1706
48” - 54”	Pneumatic	1910	1935	500	1512	1859
	Electric	1910	1935	500	1512	1859
	Hydraulic	1910	1935	370	1512	1859
54” - 60”	Pneumatic	2085	2090	500	1664	2011
	Electric	2085	2090	500	1664	2011
	Hydraulic	2085	2090	370	1664	2011

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SUPERCUTTER 6”/60”

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SUPERCUTTERS 36”- 60” TECHNICAL DATA

		SC36-42	SC42-48	SC48-54	SC54-60
Locking Range	mm (inches)	914.4-1066.8 (36”-42”)	1066.8-1219.2 (42”-48”)	1219.2-1371.6 (48”-54”)	1371.6-1524 (54”-60”)
Tool Holder Stroke	mm (inches)	60 (2.4)	60 (2.4)	60 (2.4)	60 (2.4)
Radial Pitch	mm (inches)	0.125 (0.005)	0.125 (0.005)	0.125 (0.005)	0.125 (0.005)
Weight of the Unit	kG	366	410	466	515
PNEUMATIC					
Pneumatic Motor Power	Hp (W)	2x4.2 (2x3100)	2x4.2 (2x3100)	2x4.2 (2x3100)	2x4.2 (2x3100)
Air Consumption	Nl/min (cfm)	2x2800 (2x99)	2x2800 (2x99)	2x2800 (2x99)	2x2800 (2x99)
Air Pressure	bar (psi)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)	6 ÷ 8 (87 ÷ 116)
Crown Max Torque	Nm	2x1394 (6bar) 2x2606 (8bar)	2x1532 (6bar) 2x2904 (8bar)	2x1712 (6bar) 2x3200 (8bar)	2x1865 (6bar) 2x3486 (8bar)
Idle Speed	gg/min (rpm)	10	9	8	8
ELECTRIC					
Electric Motor Power	W	2400	2400	2400	2400
Tension	Volt	230	230	230	230
Frequency	Hertz	50	50	50	50
Crown Max Torque	Nm	1850	2063	2275	2486
Idle Speed	gg/min (rpm)	9	8	7	7
HYDRAULIC					
Hydraulic Motor Power	HP (kW)	6.8 (5)	6.8 (5)	6.8 (5)	6.8 (5)
GBC Power Pack Max Pressure	bar (psi)	180 (2610)	180 (2610)	180 (2610)	180 (2610)
Oil Flow Rate	l/min. (cfm)	30 (1.05)	30 (1.05)	30 (1.05)	30 (1.05)
Crown Max Torque	Nm	6130	6830	7531	8231
Idle Speed	gg/min (rpm)	13	11	10	9

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

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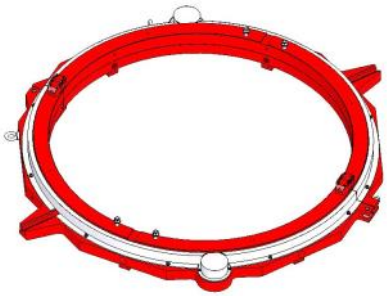
SUPERCUTTERS 36” A 60” STANDARD EQUIPMENT

The units are suplied with the equipment listed below:

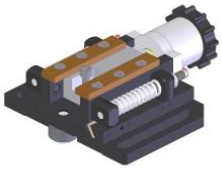
- N.2 Strikers (Feeding Levers)
- N.2 Tool Holders
- N.1 Plastic Flask for Coolant
- N.1 Cut Point Indicator
- N.6 Locking Feet (each one with linear measurement markings)
- N.2 Motors (Pneumatic Version) or 1 Motor (Hydraulic version)
- N.1 Set of Service Tools
- N.1 Storage Wooden Box
- N.1 Instruction Manual and Drawings

Ring



Locking Feet

Tool Holder

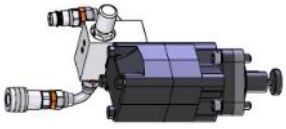


Air Motors (2x)

Plastic Flask for Coolant

Cut Point Indicator

Hydraulic Motor (1x)



Strikers

Set of Service Tools

Storage Wooden Box

Instruction Manual and Drawings

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SAFETY PRESCRIPTIONS

G.B.C. Industrial Tools S.pA. 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.

PERSONAL PROTECTIVE EQUIPMENT (PPE)

THE BELOW LISTED PPE MUST BE USED AT ALL TIME WHILE OPERATING THE SUPERCUTTER.

Residual risks are related only to the user’s system malfunctions and to the improper use of the machine for which G.B.C. Industrial Tools S.p.A. cannot be held responsible.

Gloves should be worn only during the cleaning operation of the Supercutter when the machine is disconnected from the power source.
Gloves must not be used while operating the machine as they may get entangled with the moving parts.

SHIPPING DETAILS

Weight of the Supercutter	Kg	Min 150 Max 515
Shipping Dimensions	mm	Min 800 x 750 x 500 Max 2065 x 2090 x 370
Shipping Weight	Kg	Min 160 Max 550

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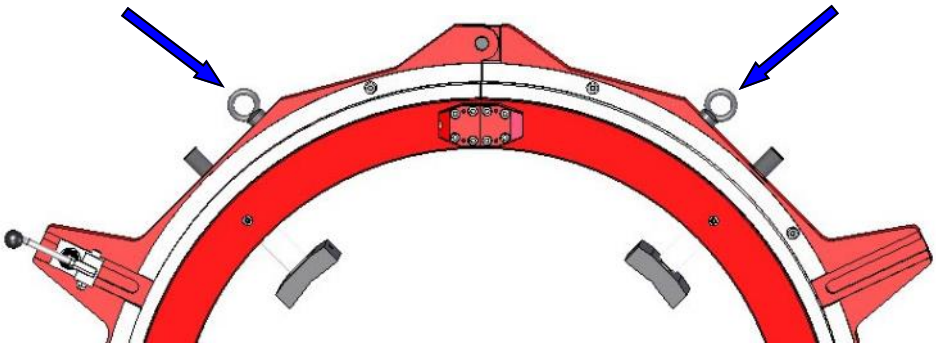
MACHINE STABILITY

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



Never try to remove swarfs or shavings with bare hands. Always use a suitable tool. Do not use hooks of any sort.

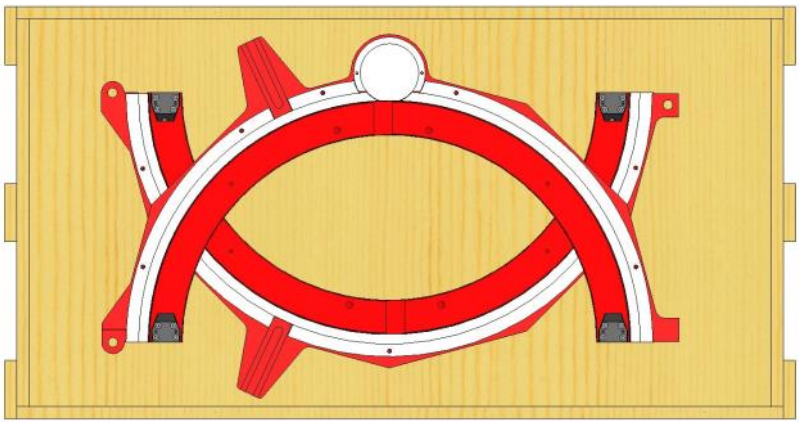
WORKPLACE

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.

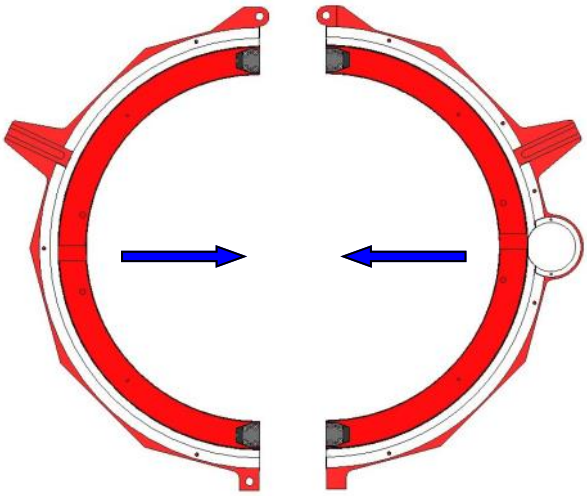
EMERGENCY STOP

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.

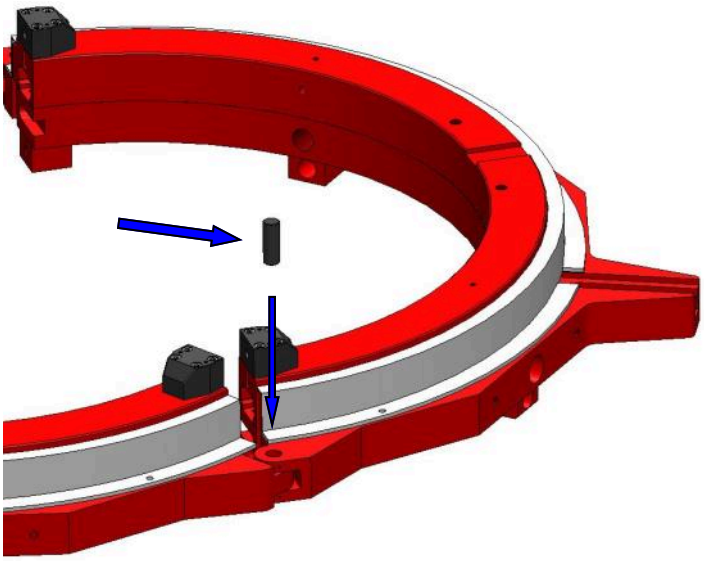
SETUP OF RANGES 24 “ - 30 “ AND 54”- 60”



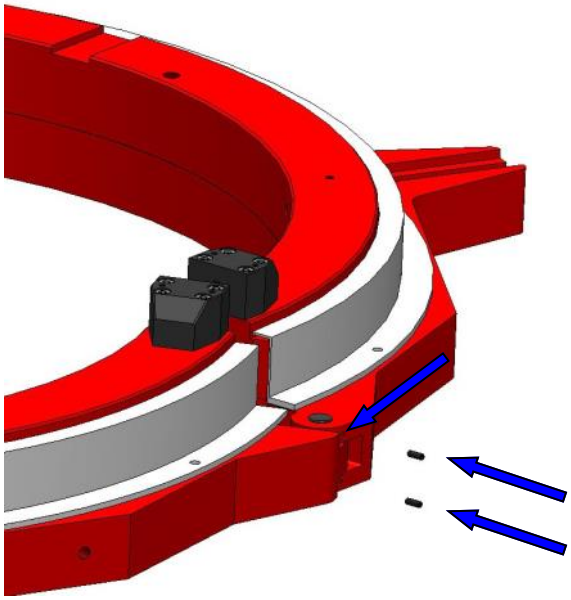
The SUPERCUTTER ranges from 24 “-30” to 54”-60”are split in two halves stacked one onto each other.



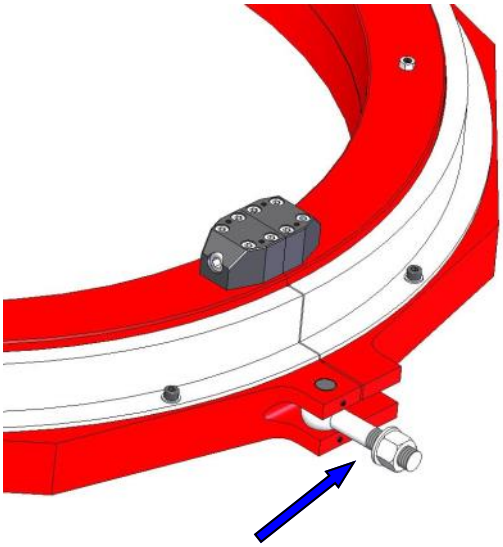
The two halves can be rejoined by placing them on a flat surface (i.e. a worktable).

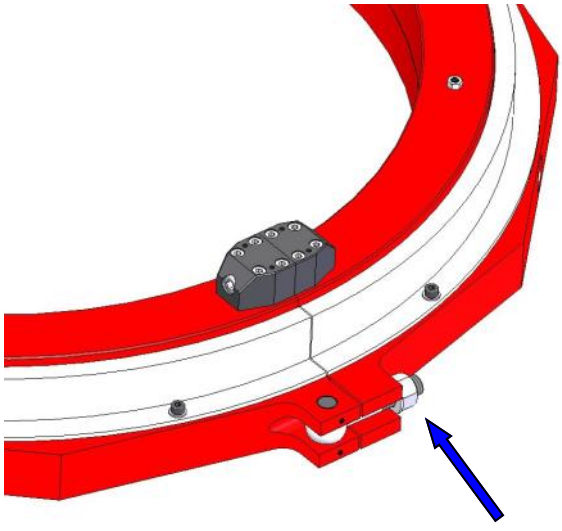


Align two halves in order to couple the joints as shown in th picture and insert the pin all the way down to form a hinge.

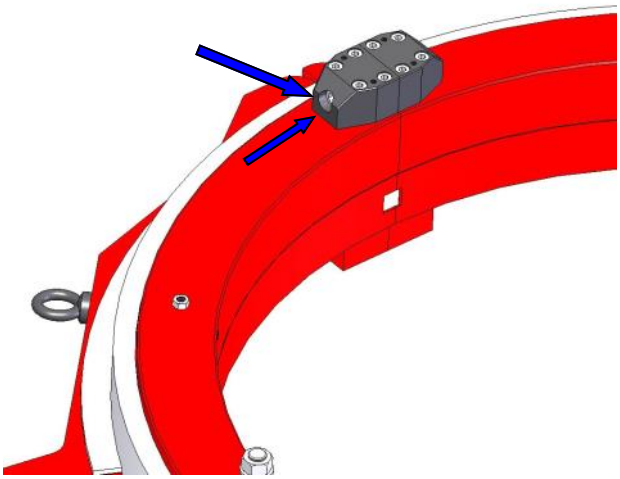


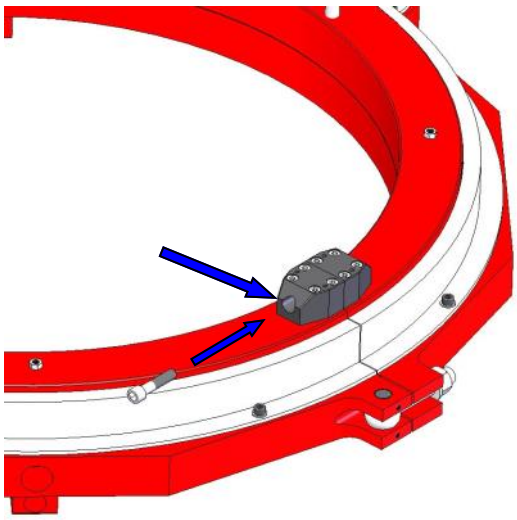
The pin has to be fixed in position by two grub screws that have to be inserted in the specific seats located on the upper part of the hinge.

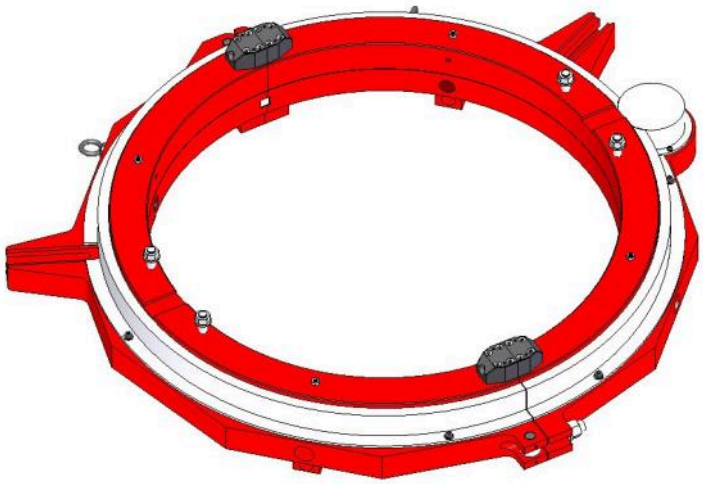




Now you can close the machine and lock the two haves together closing the latch, securing it in place by fastening the locking nut.

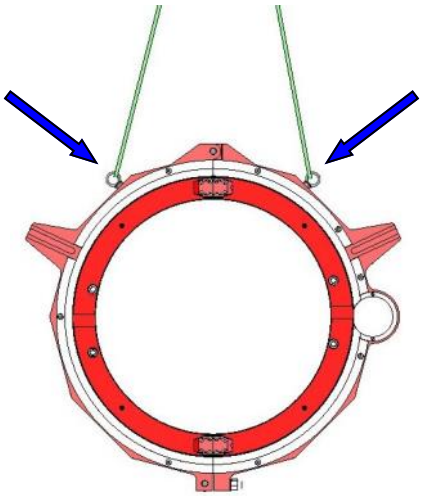




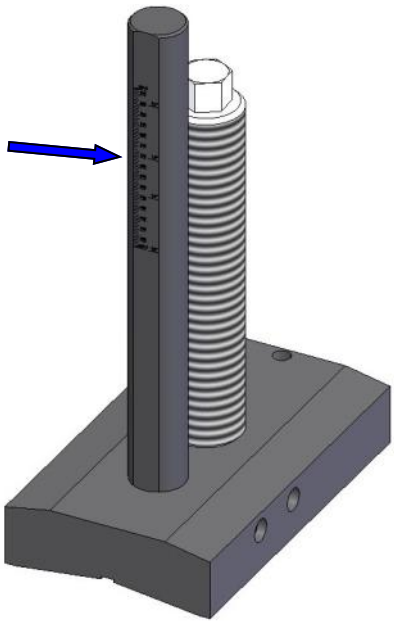


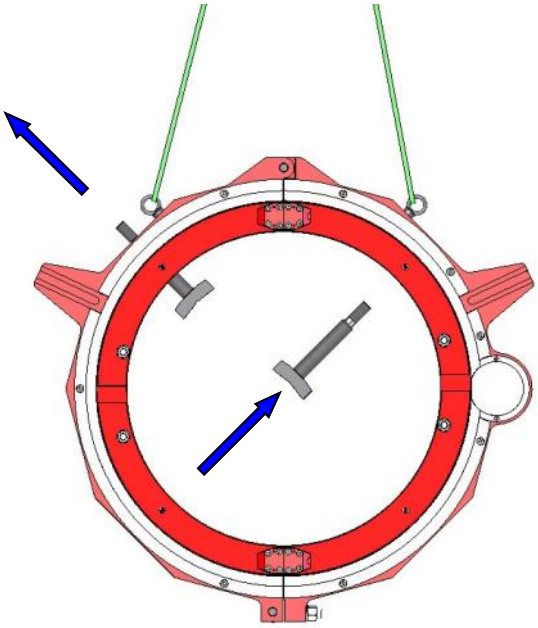
Insert the two locking screws in the coupling hubs in correspondence of the split points and fasten them using the Allen key supplied with the machine.

LOCKING FEET ASSEMBLY PROCEDURE



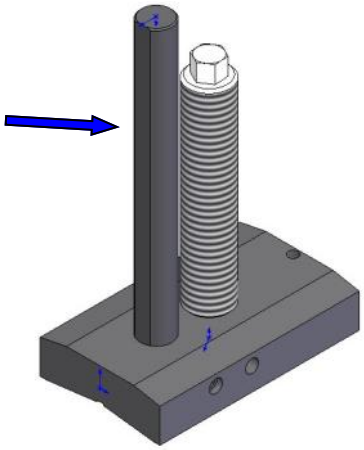
Now that the ring is assembled, hook a sling to each eyebolt and hoist the machine to continue the assembly procedure.

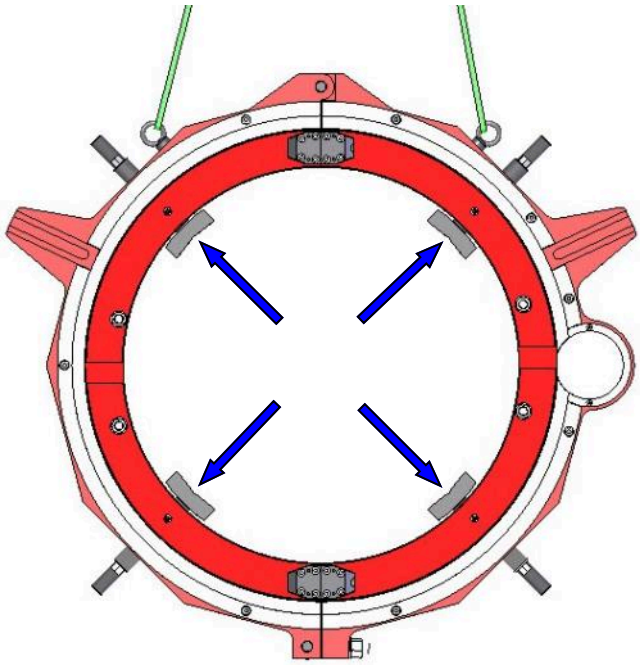




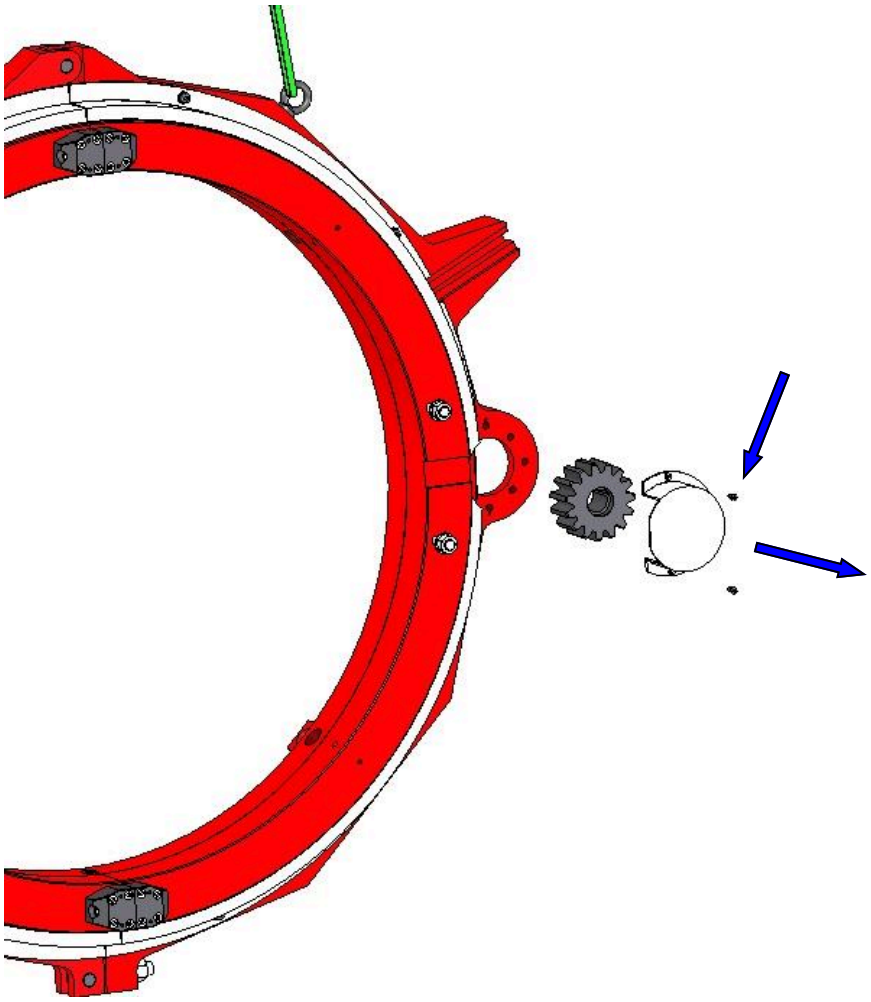
Install the locking feet keeping the scale facing the back of the ring and the threaded pin facing the front.

Now mont also the neutral locking feet.

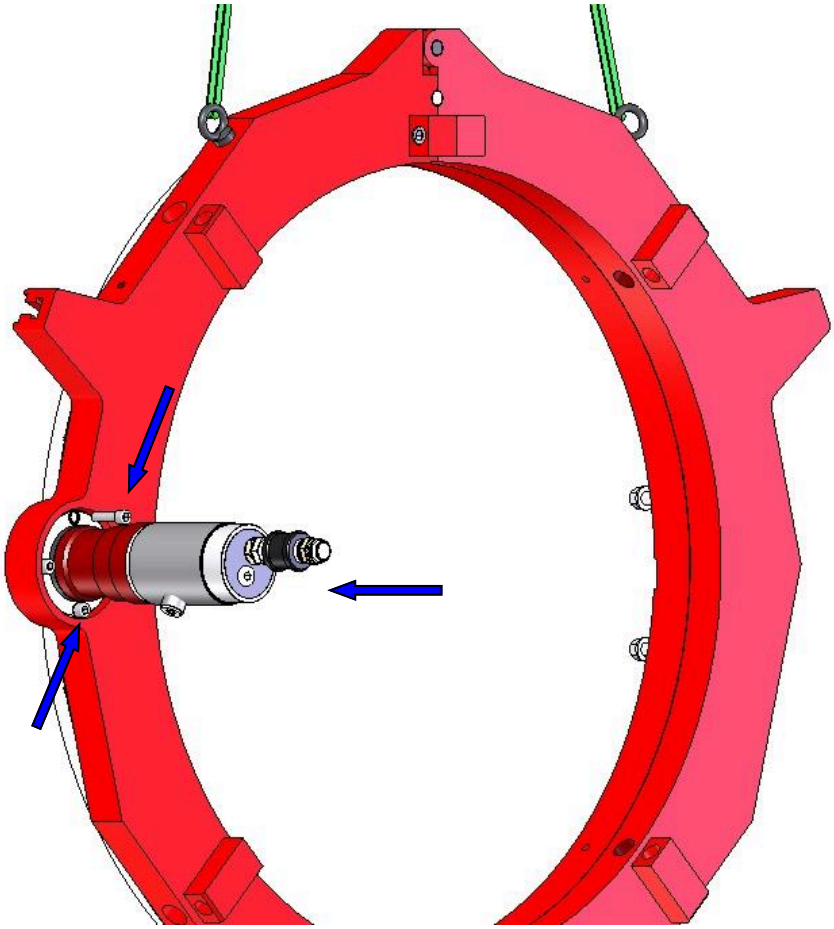




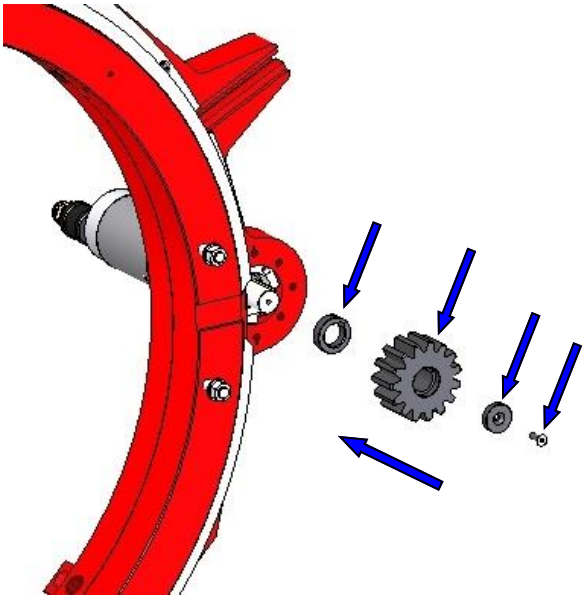
DRIVE DEVICE ASSEMBLY PROCEDURE



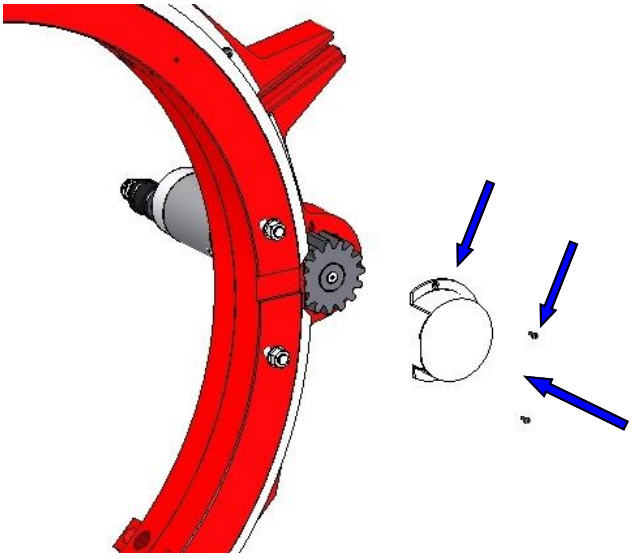
Remove the round protection by removing the two locking screws as shown above.



Take the drive device (pneumatic, electric or hydraulic) and insert it in the seat and fix it in place with the 4 screws as shown in the above picture.



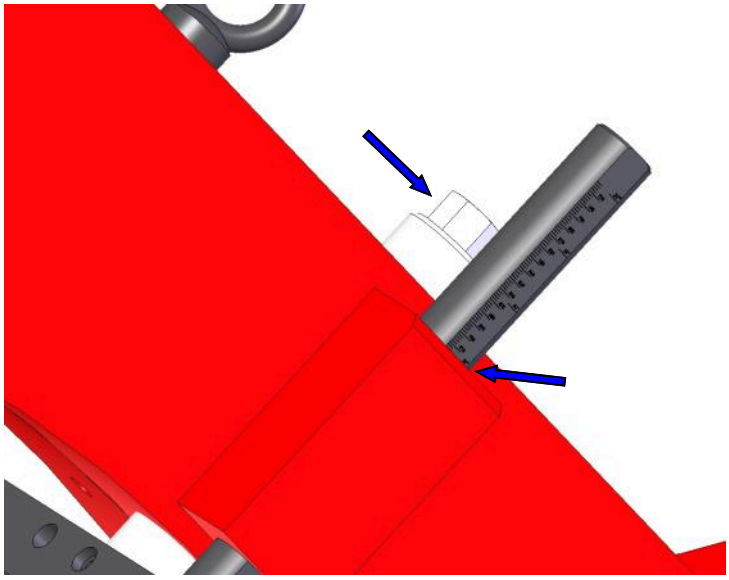
On the motor drive shaft, mount in sequence the spacer, the pinion, the washer and the locking screw that has to be screwed all the way down right on the motor drive shaft.



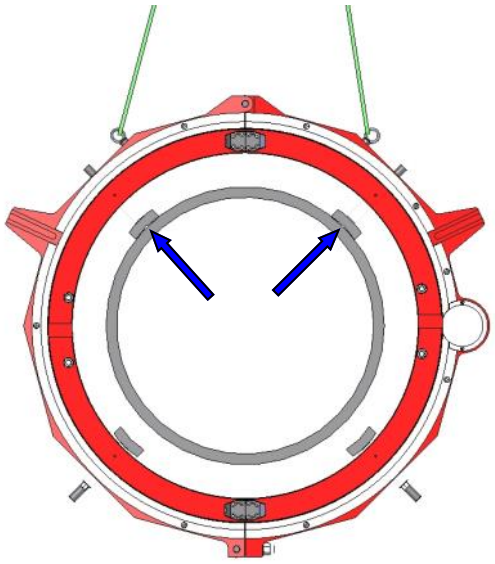
Put back the protection and secure it with the two screws previously removed.

N.B. THIS PROCEDURE IS VALID FOR EVERY TYPE OF DRIVE DEVICE

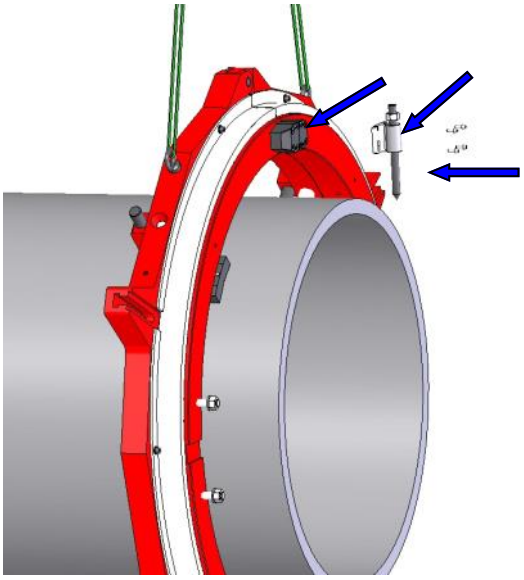
MACHINE POSITIONING

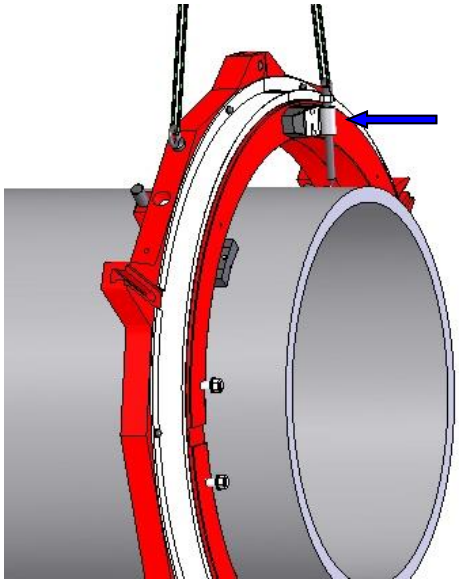


Adjust the upper locking feet by turning the adjusting screw with the specific socket tool supplied with the machine until the measurement on the guaged rod matches the diameter of the pipe that has to be worked.

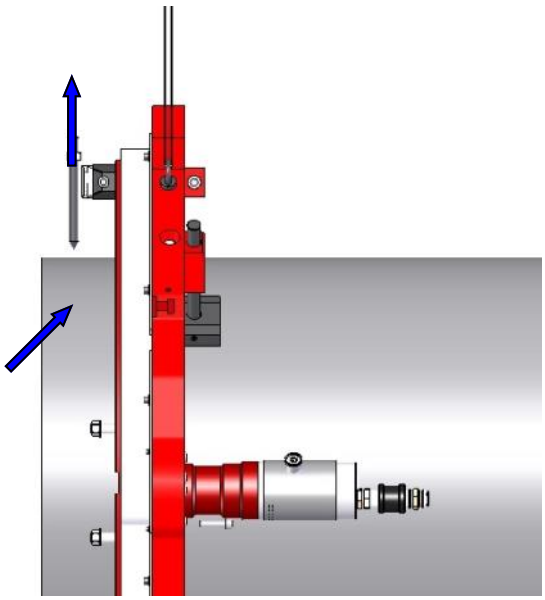


Place the machine on the pipe and slide it along the pipe axis up to the deisred cut point proximity.

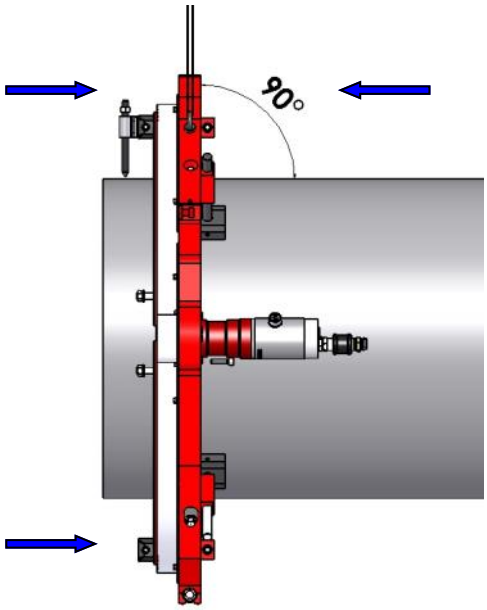




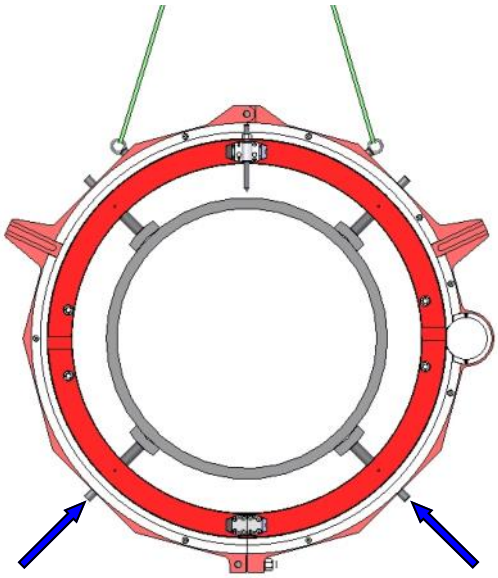
A precise cut point (if required) can be determined by mounting the Cut Point Indicator on the coupling block.



N.B. When the machine is in the desired position REMOVE THE CUT POINT INDICATOR as failing to do so may cause damage to the machine or to the pipe is the Supercutter should be operated.



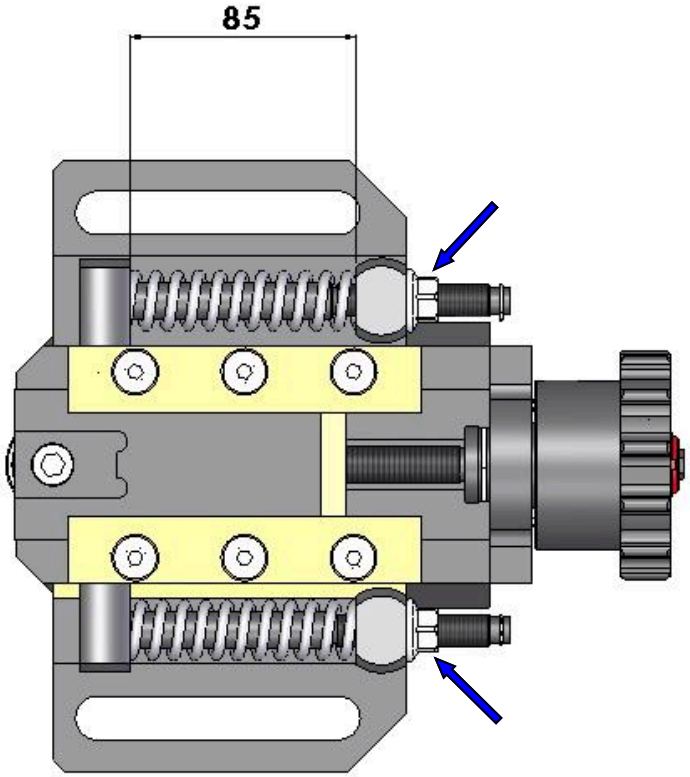
Ensure that the machine is perfectly perpendicular to the pipe using a 90° square placed in the proximity of each locking foot.



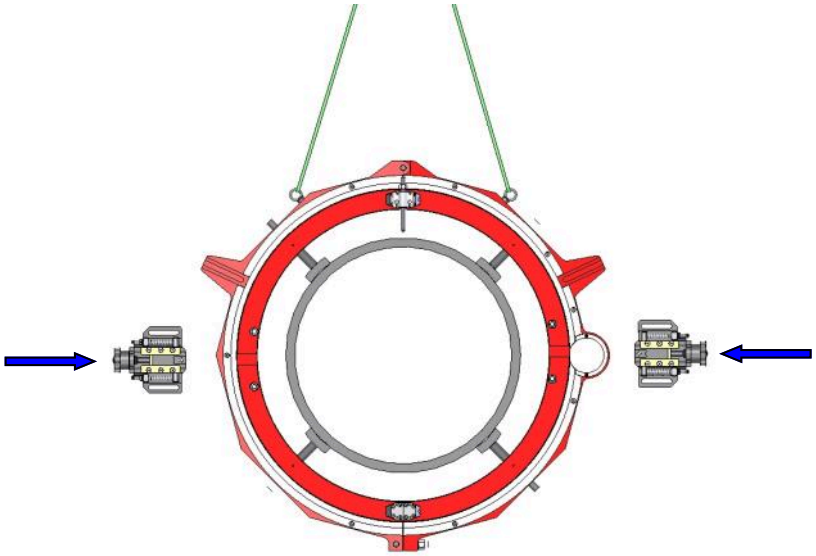
Now the lower feet can be closed to secure the machine in place.

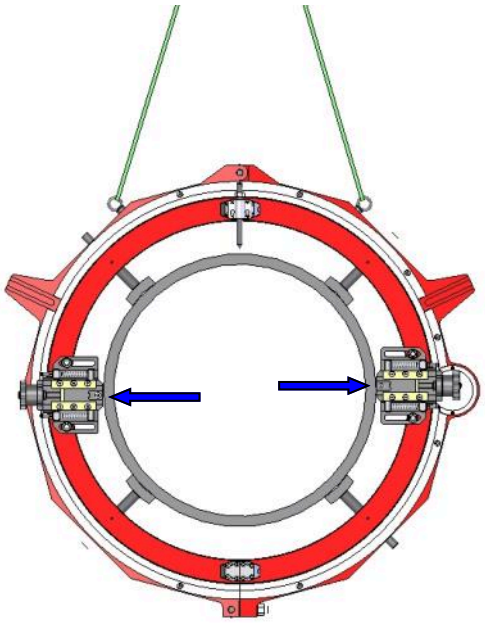
TOOLBOXES ASSEMBLY PROCEDURE

Adjust the length of the both springs of each tool holder by acting on the nuts located at the extremity of the assembly as shown in the picture below.
The required length in this case is 85mm.

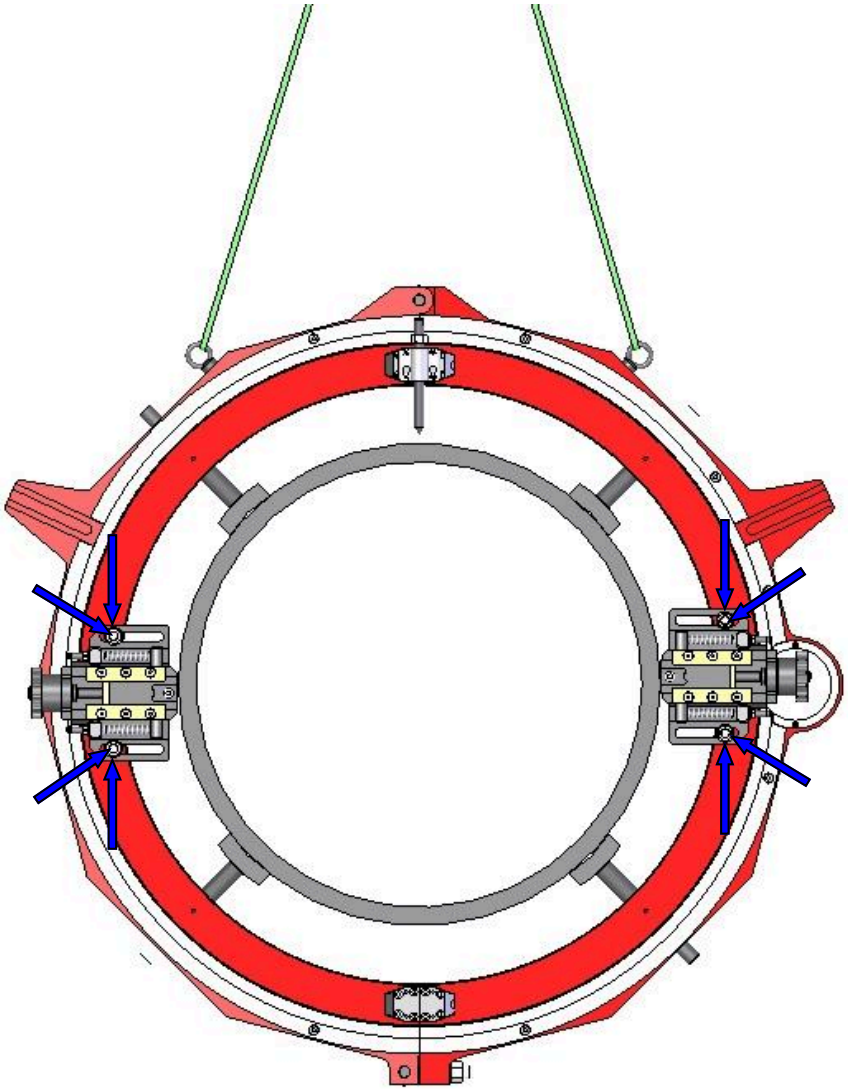


Install the tool holders on the supercutter in correspondence of the guiding pins located on the crown and slide them towards the pipe od until the copier beraing touches the pipe.
N.B. For the cutting procedure only it is not necessary for the bearing to touch the pipe.

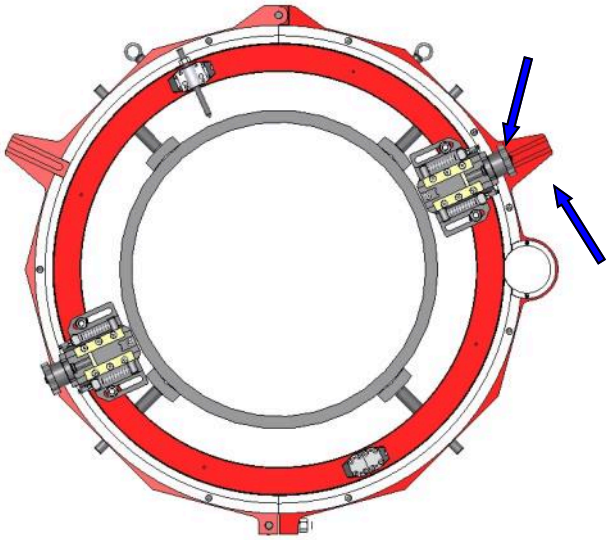


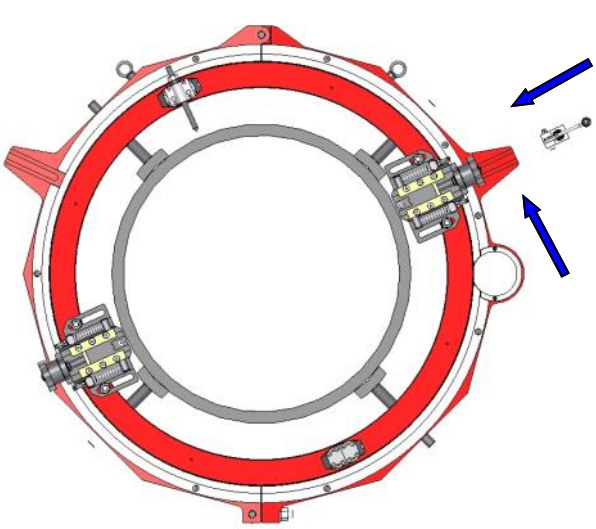


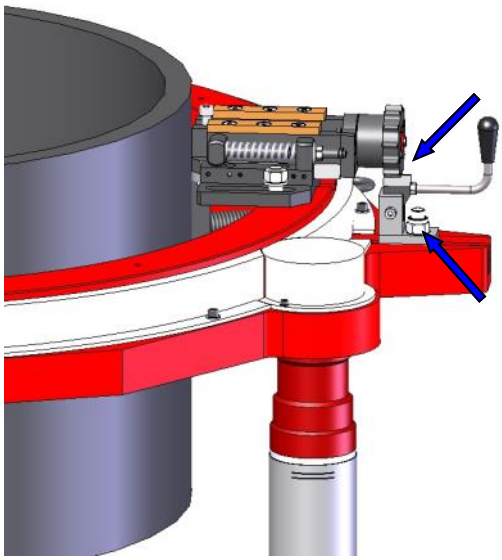
Now the tool holder can be fixed by the locking nuts, 2 for each one of them, making sure to use the place the washers.



Connect the machine to the power supply and run it until one of the two star wheels of a tool holder matches with the seat of the stiker as shown below.

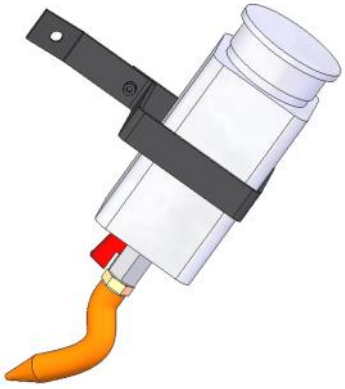




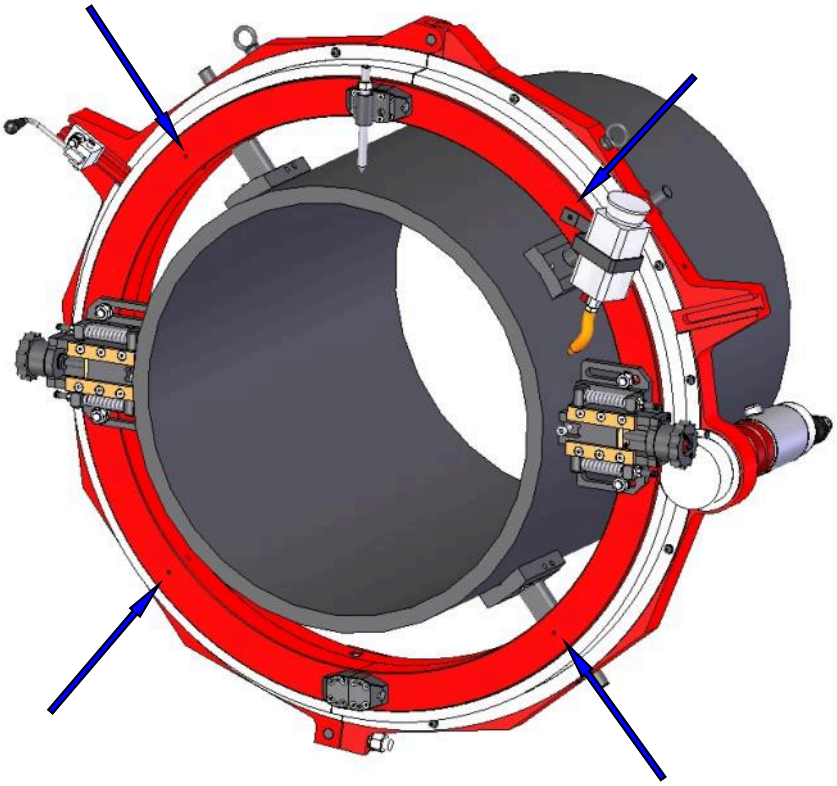


Insert the striker assembly in the seat and adjust its position so that the wedge of the striker engages the star wheel. Now fasten the locking nut to lock it in position.

FLASK ASSEMBLY PROCEDURE



Fill the flask with water emulsified cutting oil



Install the flask on one of the 4 pins located on the crown of the machine and fix it with the nut that is already fixed on the pins.

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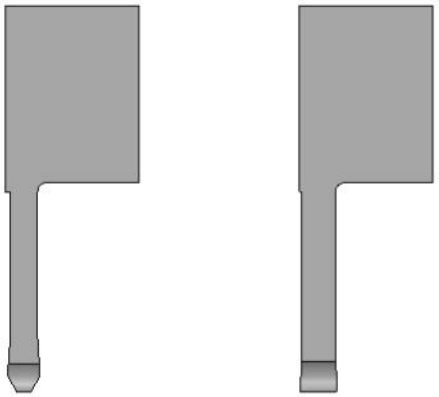
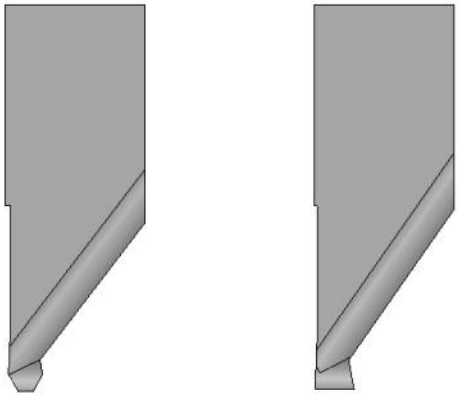
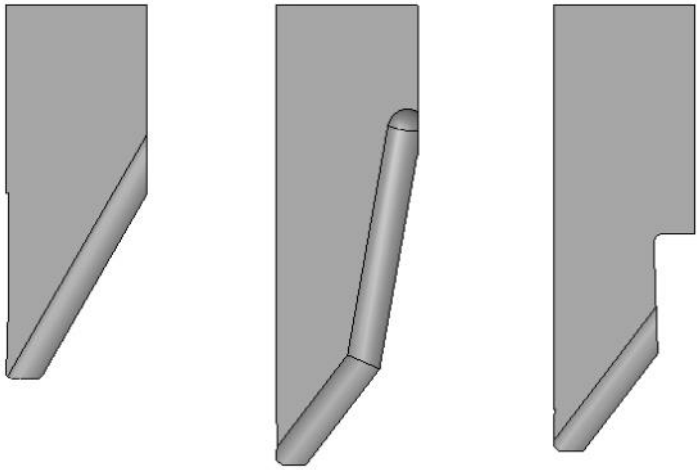
TOOLS TYPOLOGY



CUTTING TOOLS
(Forward+Backward)



CUTTING + BEVELING TOOLS
(Forward+Backward)

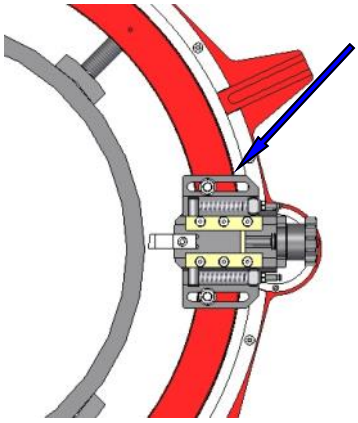


BEVELING TOOLS

For the SUPERCUTTER model there are 3 main couples of tools with different working features:

Cutting Tools
Cutting + Beveling Tools
Beveling Tools

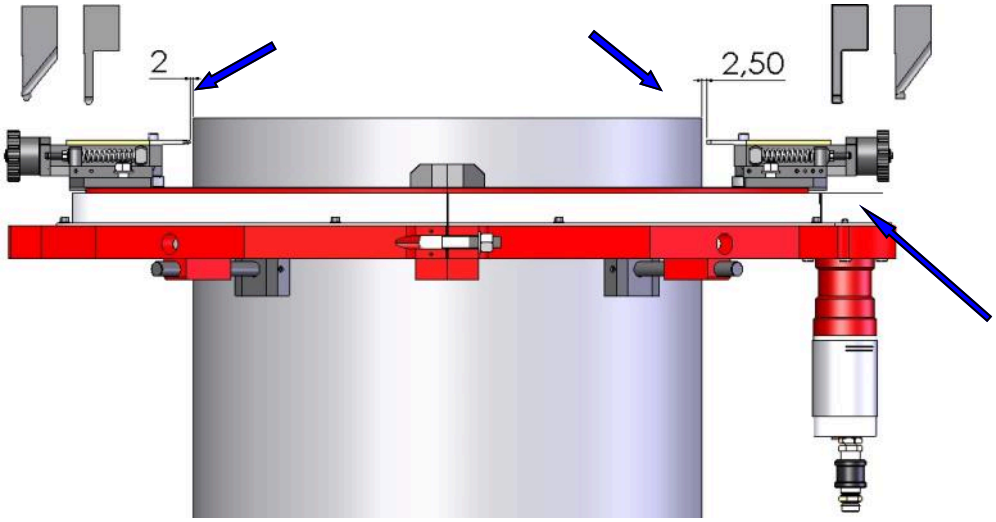
CUTTING TOOLS ASSEMBLY PROCEDURE AND SETTING



NB: The cutting process must be executed, with no exception, with 2 different cutting tools that are distinguishable by the shape of the cutting tip :
The FORWARD TOOL (with a pointed tip) and BACKWARD (with a squared tip).
This expedient grants the equal distribution of the workload on each tool and toolbox and keeps the machine balanced as much as possible.

THE CUTTING PROCESS MUST NEVER BE EXECUTED WITH TOOLS WITH THE SAME SHAPE.

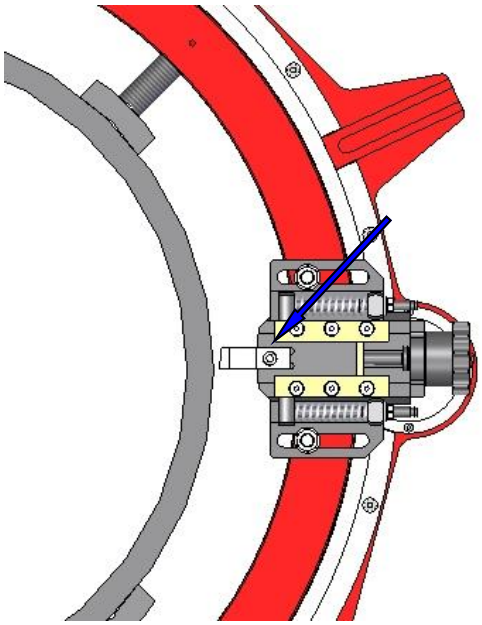
FORWARD TOOLS **BACKWARD TOOLS**



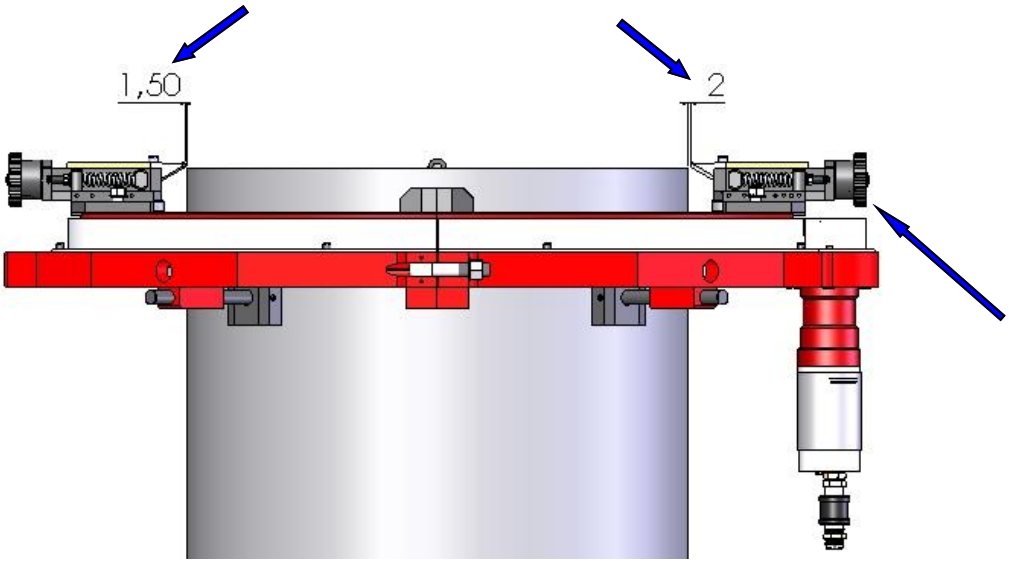
Manually feed the toolbox with the FORWARD tool and until it reaches a distance of about 2mm from the pipe OD.

Perform the same operation with the other toolbox but in this case the distance from the pipe OD must be of about 2,50mm

BEVELING TOOLS SETTING

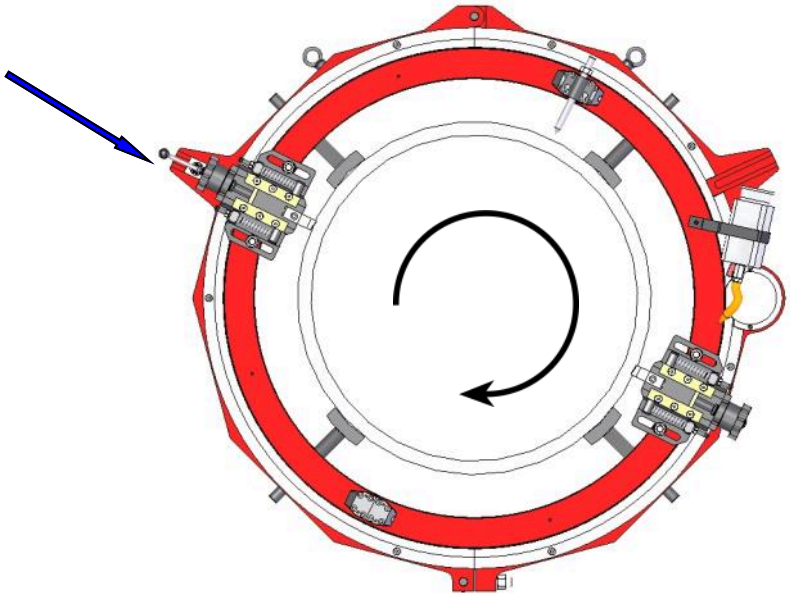


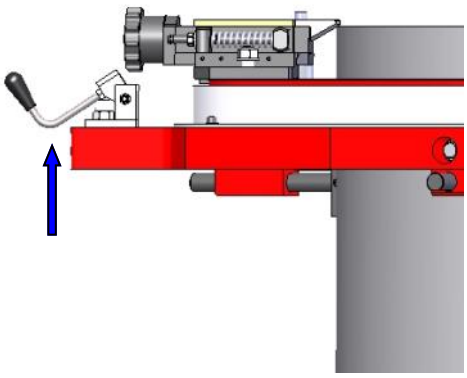
Install the tools in the seats located on the tool holders and fix them in place with the specific locking screw.

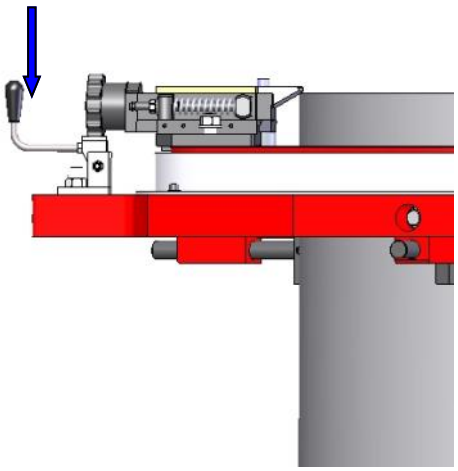


Adjust the positions of the tools as shown above by acting manually on the tool holder star wheels so that one tool is at 1,50mm from the pipe OD and the other is at 2mm.

USE OF THE MACHINE

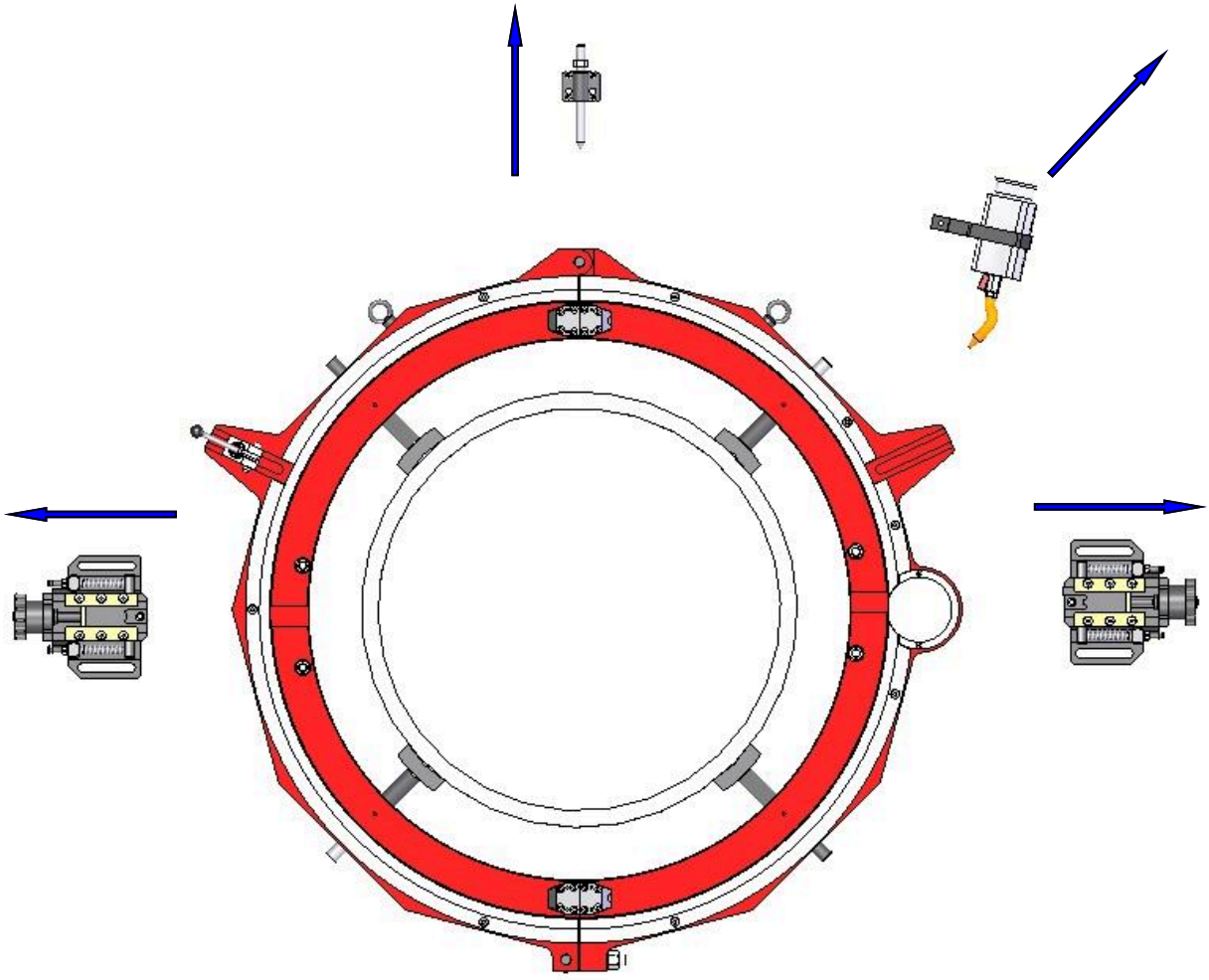




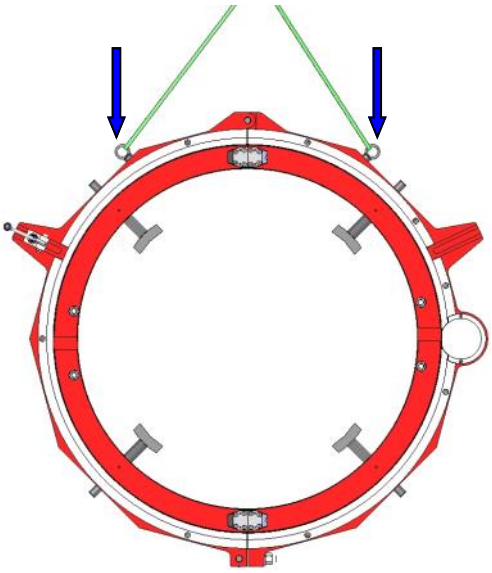


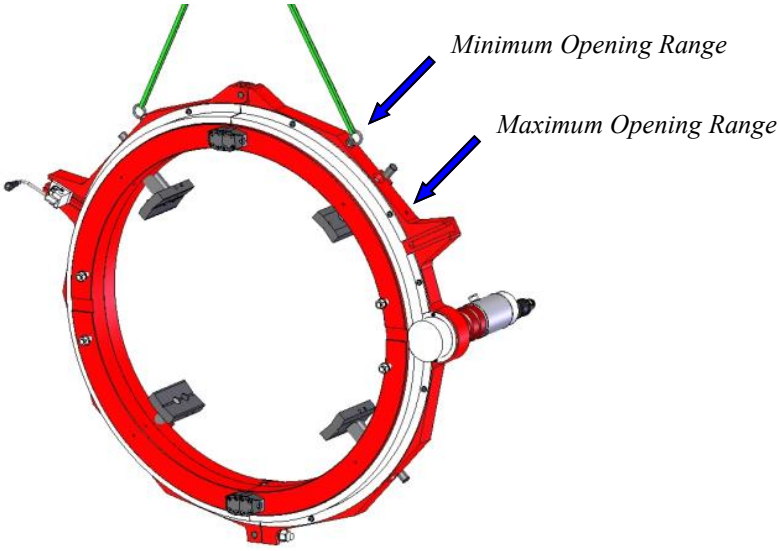
Start the machine at low speed and engage the striker. N.B. The operator’s task is to have both tools working simultaneously sharing the same workload, therefore as soon as the tool which is closer to the pipe OD starts to peel off some material leave the striker engaged until it hits the second tool holder star wheel and then disengage the striker. Engage the striker again only for hitting the star wheel of the tool that is not working yet. Repeat this procedure until also the second tool touches the pipe. When this happens leave the striker engaged.

MACHINE OPENING PROCEDURE

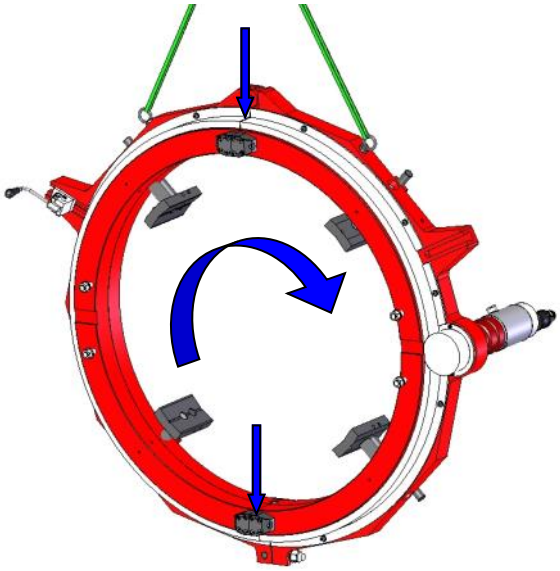


Remove every attachment from the machine (The tool holders, ther cut point indicator and the flask).

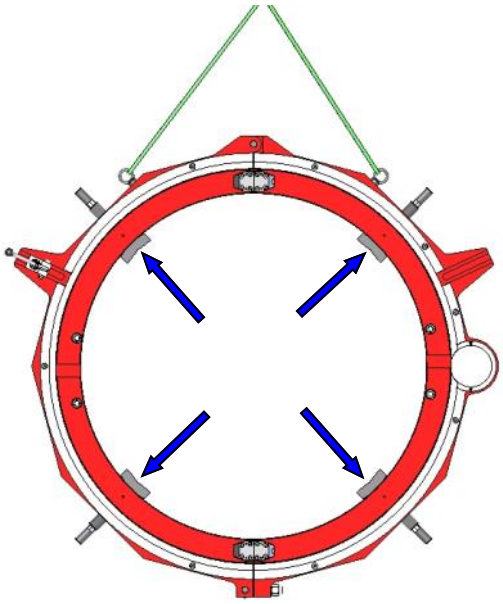




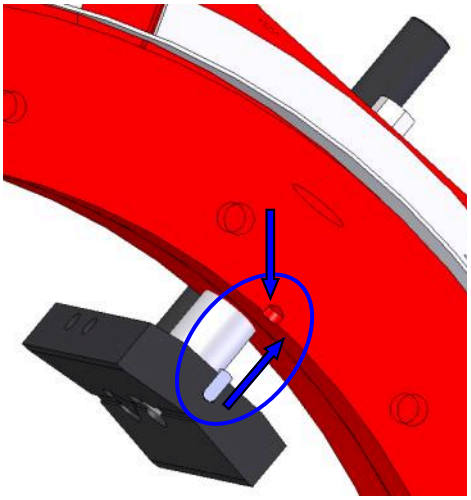
Hoist the machine by the eyebolts with slings suitable to sustain the weight of the unit as shown above.
N.B. You can place the eyebolts in two different positions to obtain a narrow opening or a wide opening to better accomodate the pipe.



Manually rotate the crown until the division line matches the division line of the machine body as shown in the picture above.

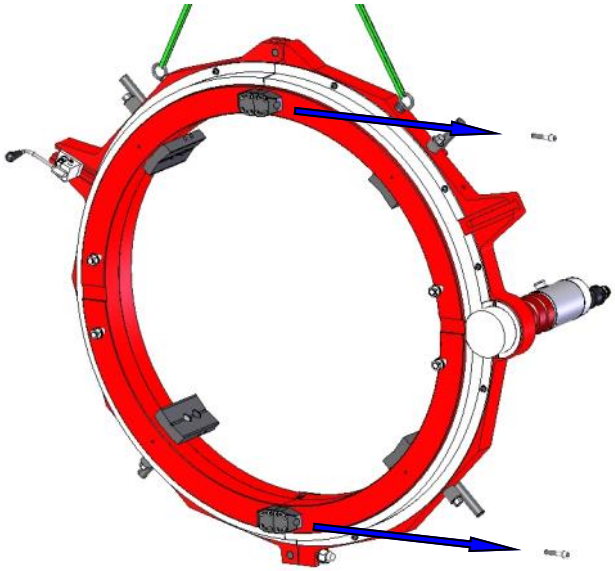


Withdraw the locking feet for the full stroke.

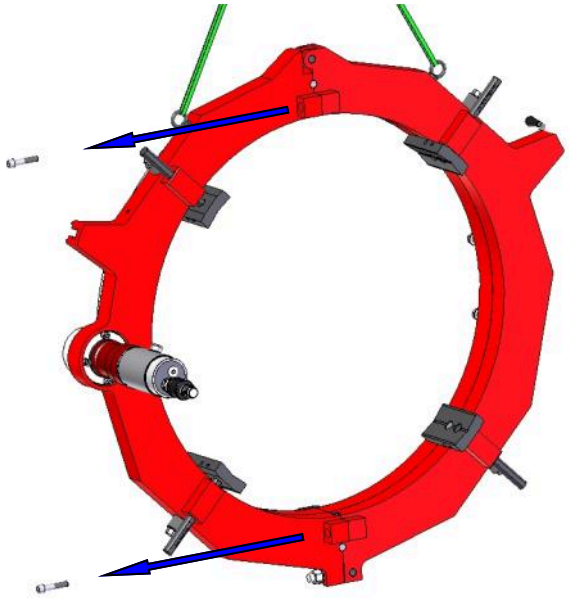


WARNING:

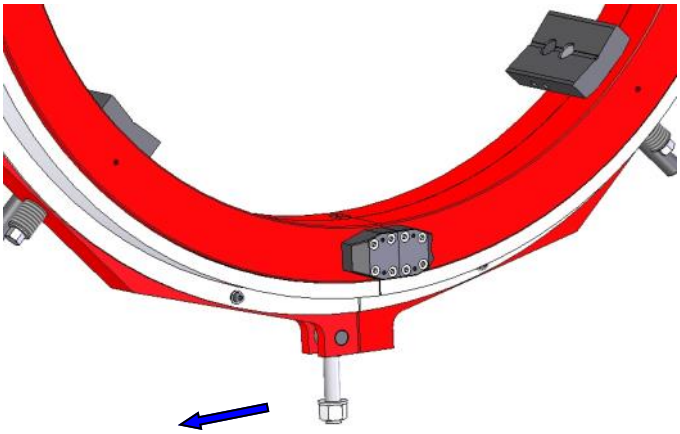
Make sure that the safety pins located on the locking feet enter the seats on the crown because **this will prevent the inner crown to fall out the machine**.



Unscrew and remove the two locking screws from the coupling blocks



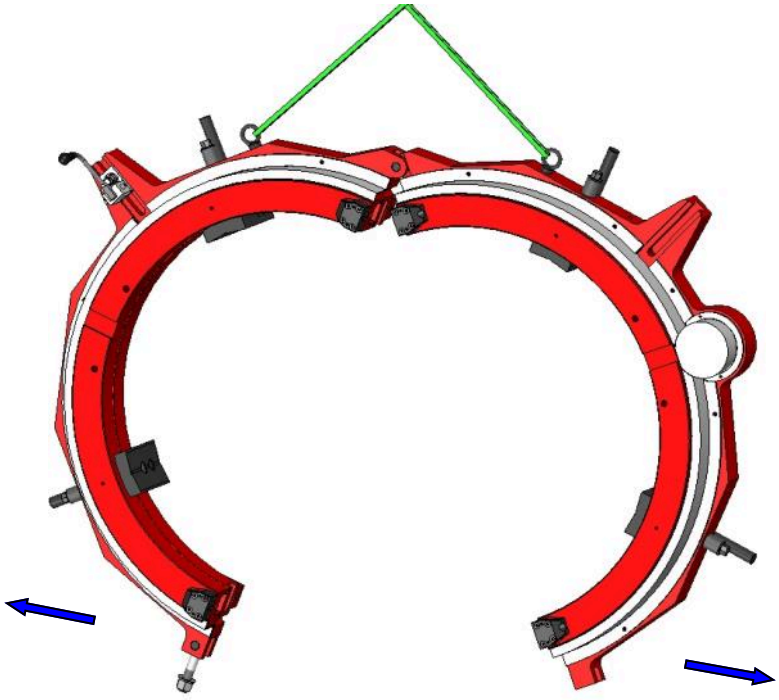
Unscrew and remove the screws on the back of the machine body as shown on the picture above.

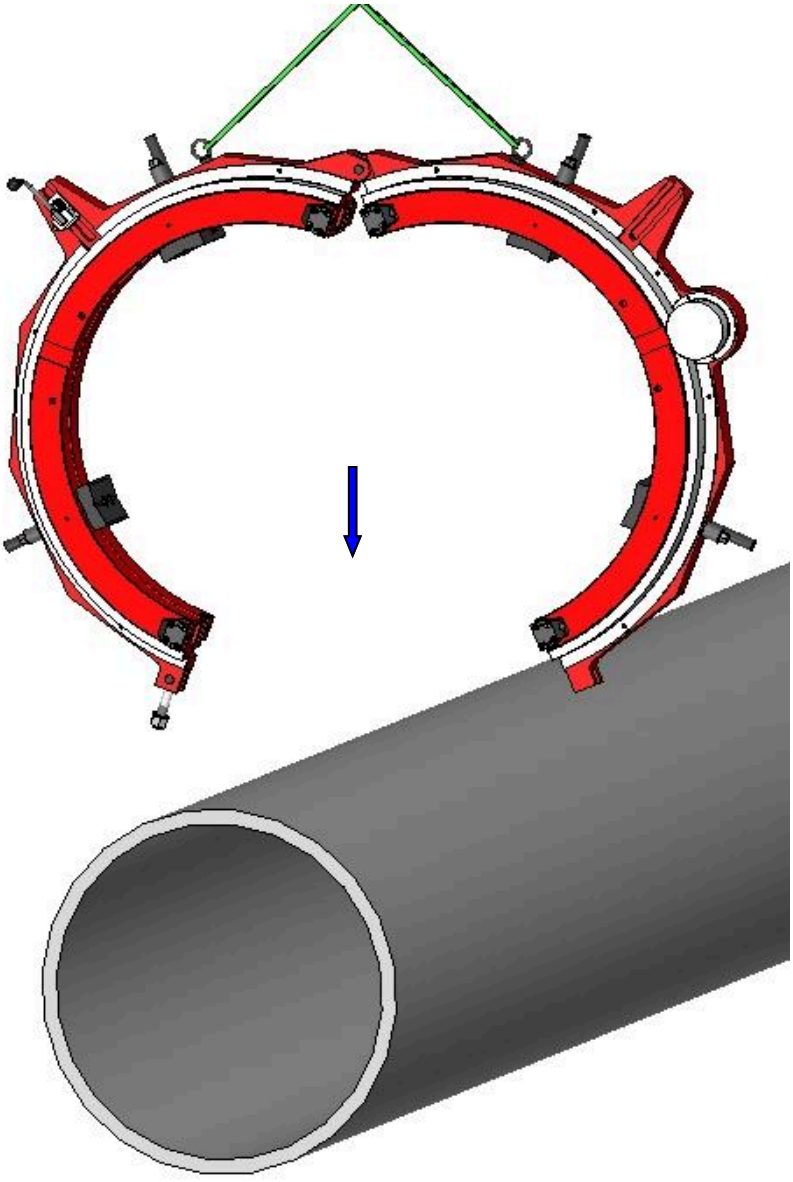


Loose the locking nut and unhook the latch located on the lower part of the machine.

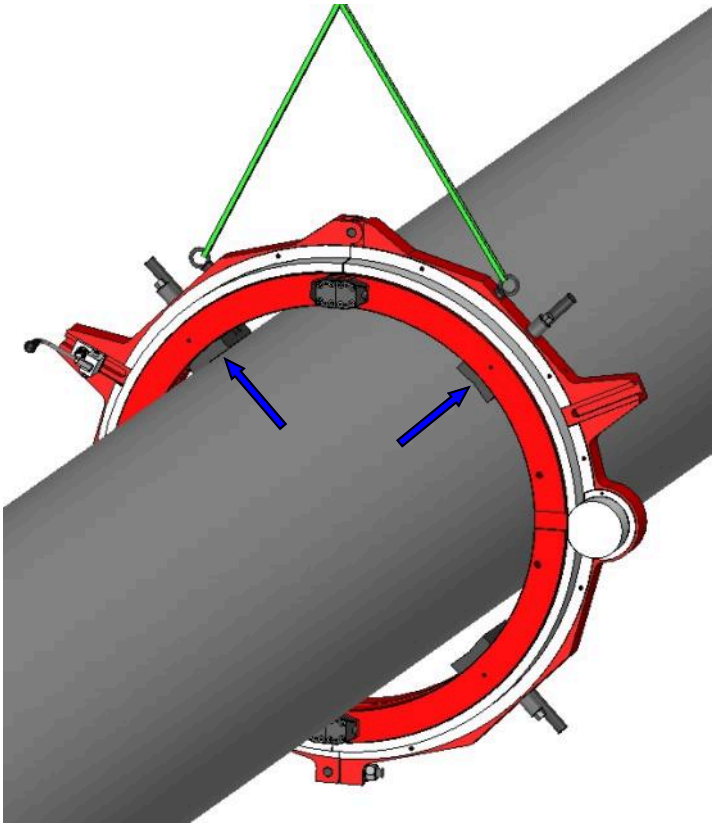
WARNING:

As soon as the latch is opened the machine may suddenly open therefore make sure that this operation is carried out in an area with enough clearance.





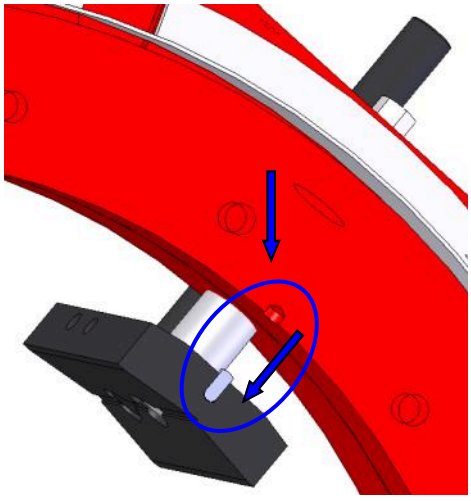
Position the machine on the desired cut point and lower it until its weight is fully sustaineed by the pipeline.



WARNING:

Close the machine and carry out the centering and squaring procedures.that **must necessarily be performed after the closing procedure**.

Ensure that the safety pins have successfully exited the seats located on the crown **to allow the crown rotation**.



ORDINARY MAINTENANCE

FOR OBTAINING A GOOD PERFORMANCE AND AN EXTENDED LIFESPAN, THE UNIT HAS TO BE INSPECTED AND SERVICED BY GBC OR BY A GBC SPECIALIZED TECHNICIAN OR AUTHORIZED DISTRIBUTOR EVERY 400 WORKING HOURS

PERIODICAL CHECKS

CHECK THE GENERAL CONDITIONS OF THE MACHINE.

IN CASE OF PNEUMATIC UNITS

THE USE OF THE FILTER LUBRICATOR IS MANDATORY. ENSURE THE FILTER LUBRICATOR IS ALWAYS WORKING AND PROPERLY SET.

THE FILTER LUBRICATOR HAS TO BE PLACED AS CLOSE AS POSSIBLE TO THE MOTOR AND HAS TO BE USED WITH GBC LUBRICATING OIL ONLY.

EVERY 20-30 WORKING HOURS ENSURE THAT THE RELIEF VALVE IS WORKING AND DOES NOT LEAK AIR.

IN CASE OF HYDRAULIC UNITS

ENSURE THAT THE HYDRAULIC POWER PACK IS CONNECTED TO A POWER SOURCE DELIVERING TENSION AND FREQUENCY COMPATIBLE WITH THOSE OF THE MOTOR OF THE UNIT

ENSURE THAT THE OIL LEVEL IN THE TANK STAYS BETWEEN THE MAXIMUM LEVEL AND THE MINIMUM LEVEL INDICATORS.

ENSURE THAT THE OIL TEMPERATURE DOES NOT EXCEED 45°

USE ONLY OILS SUGGESTETED BY GBC

GENERAL CHECKS

ENSURE THAT THE SEATS OF THE TOOLS ON THE TOOL HOLDERS ARE CLEAN AND THAT THE TOOLS USED ARE ALWAY SHARP ENOUGH.
DULL TOOLS WILL CAUSE EXCESSIVE OWRKLOAD AND IN A LONG TERM SCENARIO MAY CAUSE DAMAGE TO THE UNIT .

G.B.C. IS AT YOUR DISPOSAL TO PERFORM THE ABOVE STATED CHECKS AND FOR ANY FORM OF ASSISTANCE YOU MAY NEED.

TROUBLESHOOTING

THE MACHINE DOES NOT RUN. Ensure that it is connected to the power supply and that the power supply is suitable for the motor.

THE MACHINE DOES NOT CUT OR BEVEL. Check the conditions of the tools and make sure that the tools are suitable for working tha mateiral the pipe is made of. In case of doubt rely to your GBC contact person.

Any adjustment and maintenance operation must be executed after the unit has been disconnected from the power supply.

Any operation must be carried out by educated personnel only.

The tools are sharp. Handle them with caution in order to avoid injuries.

Do not move the tool position by hand while the machine is operating.

Maintain a safety distance of at least 2 meters during the working operation.

If possible, keep the tools lubricated during the whole cutting or beveling operations.