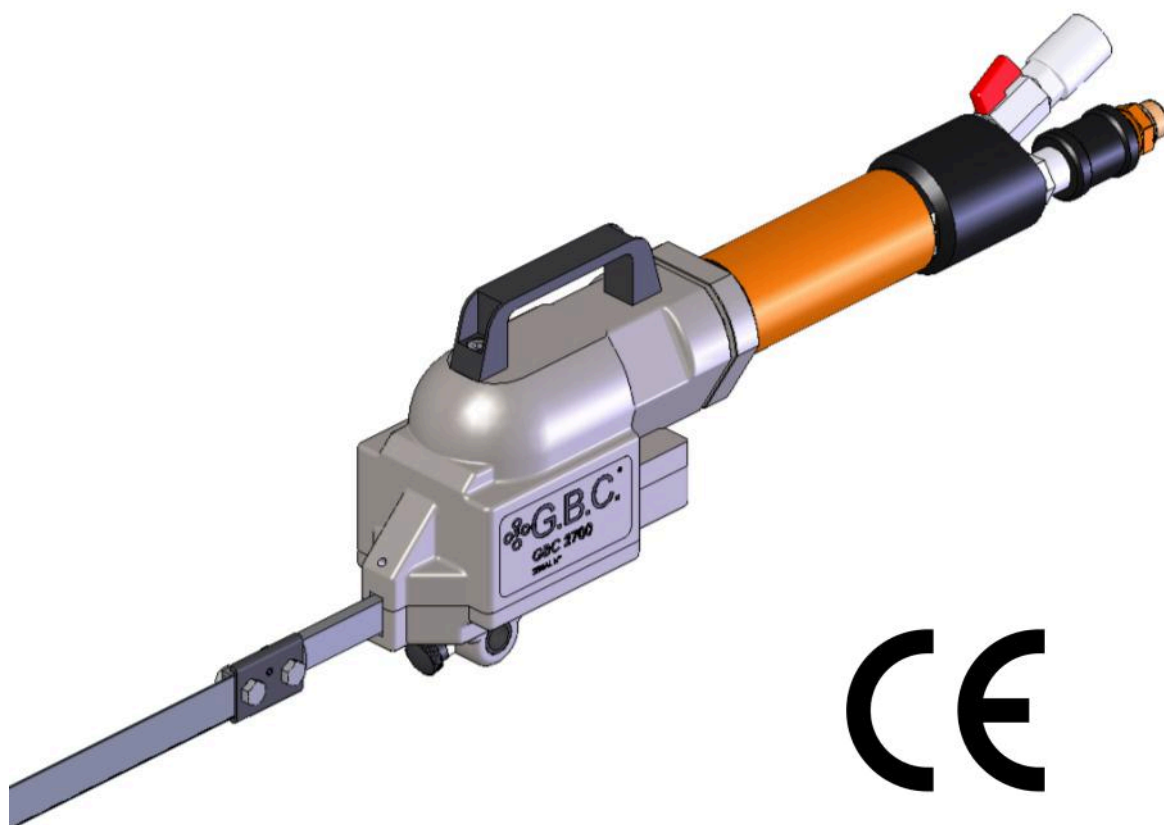




INSTRUCTION MANUAL



GBC 2700



GBC 2700

Istruzioni originali—rev.2011—in accordo al 1.7.4 della direttiva macchine 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 operanting the General Management, the sales de-department, as well as the main workshop and the shipping de-partment.

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 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 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 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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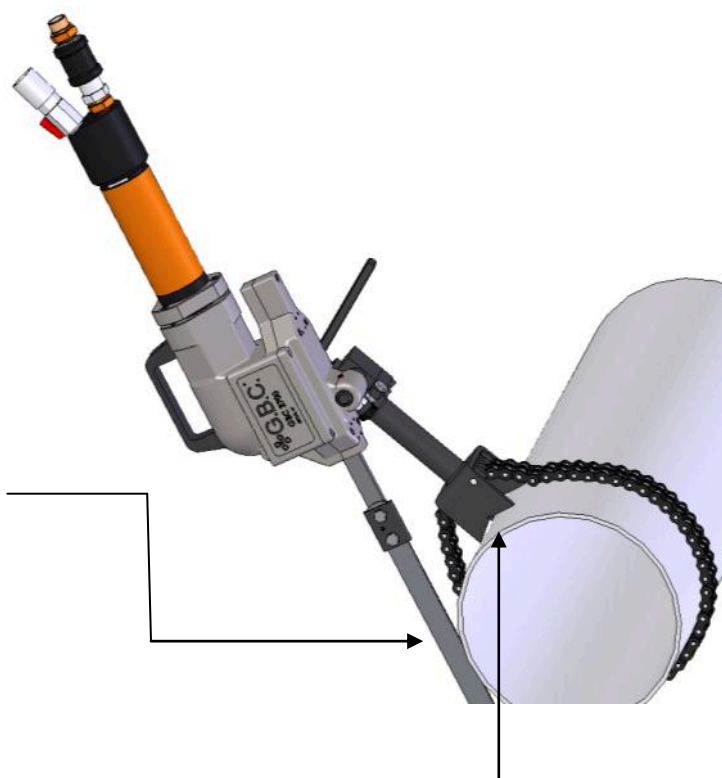
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INTENDED USE OF THE MACHINE

The machine subject of this manual is designed to obtain fine finishing quality of pipe cutting operations in uneasy environmental conditions and in limited space conditions.

The cut is obtained by a set of cutting blades which measure varies in fnction of the dimention of the pipe to be cut.



The machine operated while locked on the pipe OD by a chain locking kit.

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

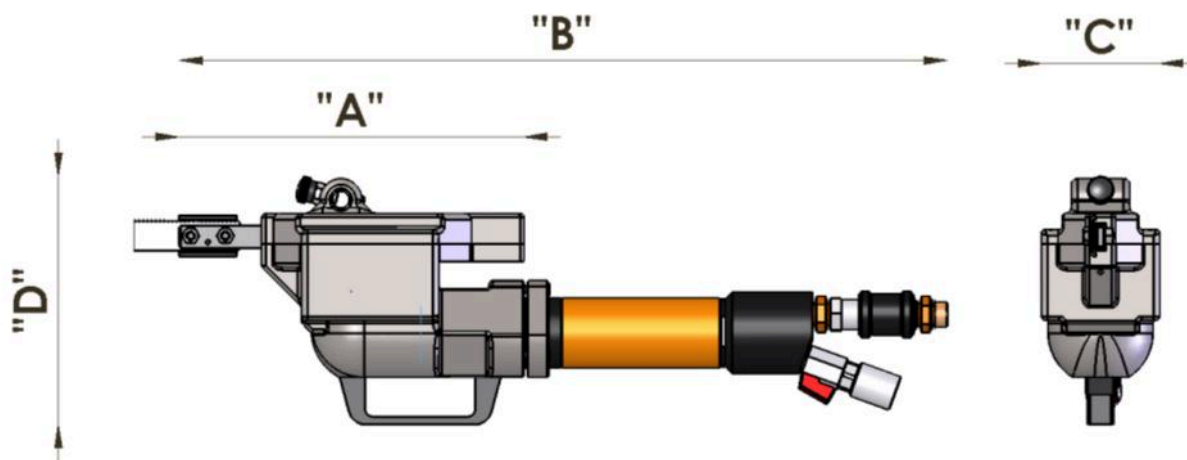
FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTALBE MISUSE OF THE UNIT

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TECHNICAL DATA			
		PNEUMATIC	ELECTRIC
OD Locking Range	mm (inches)	25 - 533 (1 - 21)	25 - 533 (1 - 21)
Blade Idle Speed	battute/min (stroke/min)	300 (300)	450 (450)
Pneumatic Motor Power	Hp(W)	1 (740)	-
Air Consumption	L/min (cfm)	1600 (55-60)	-
Air Pressure	Bar (psi)	6 (90)	-
Air Hose Connection	Pollici (inches)	3/4" (3/4")	-
Electric Motor Power	W	-	1400
Tension	Volt	-	110 / 220
Frequency	Hz	-	50/60
Maximum Acoustic Emission	Db	75	75



MACHINE DIMENSION			
		PNEUMATIC	ELECTRIC
A	mm (inches)	340 (13.38)	340 (13.38)
B	mm (inches)	690 (27.16)	590 (23.22)
C	mm (inches)	102 (4.01)	102 (4.01)
D	mm (inches)	212 (8.34)	212 (8.34)

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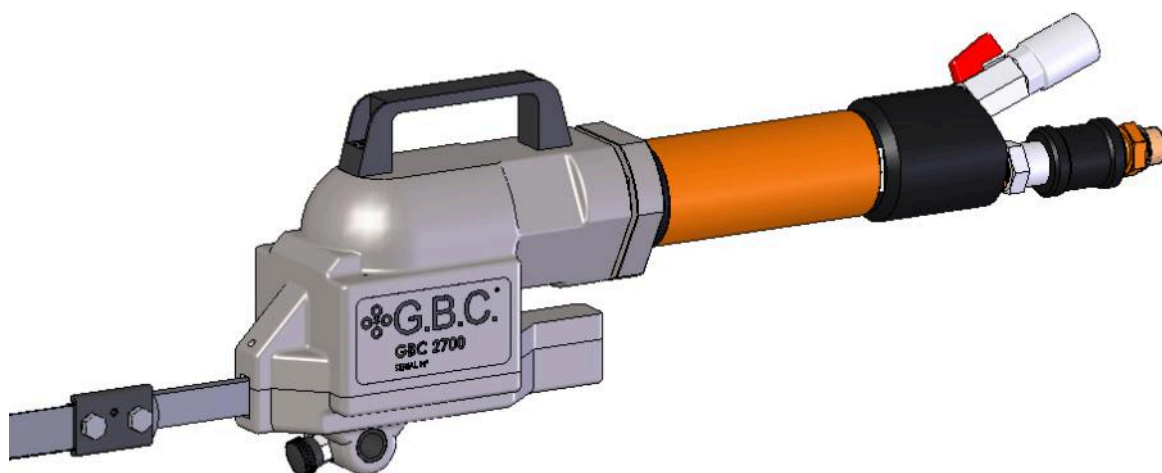
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MACHINE CONFIGURATION MODELS

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GBC 2700 “E”



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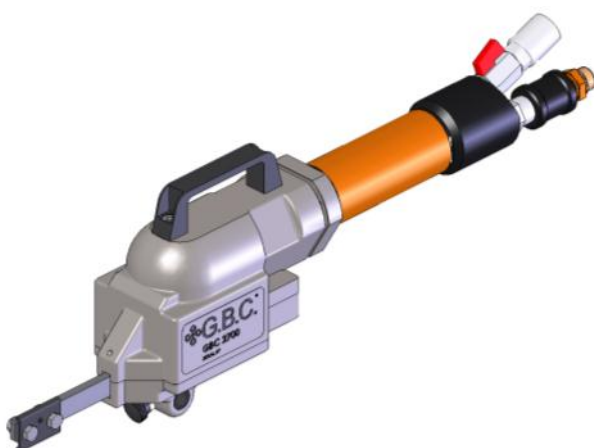


Machine Standard Equipment

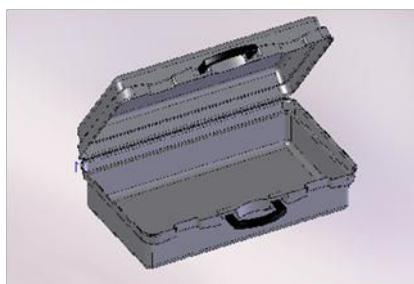
The machine is supplied with:

- 13mm Wrench
- Case
- Instruction Manual And Exploded Drawings

Pipe Saw



Case



Service Tools



Instruction Manual And Exploded Drawings



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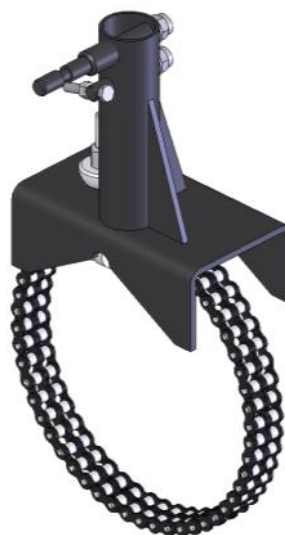


OPTIONAL EQUIPMENT

CHAIN LOCKING KIT 1"4"



CHAIN LOCKING KIT 4"21"



CUTTING BLADES



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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. During the operations the hands shall be kept on the security valve and on the hand wheel.
4. The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.



TRANSPORT RECOMMENDATIONS

		<i>PNEU.</i>	<i>ELET.</i>
Weight of the Machine	kg	18	18
Shipping Dimensions	mm	80x40x300	80x40x300
Shipping Weight	kg	28	28

Under 25 Kgs no lifting machines are required.

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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 –

EMERGENCY STOP INSTALLATION

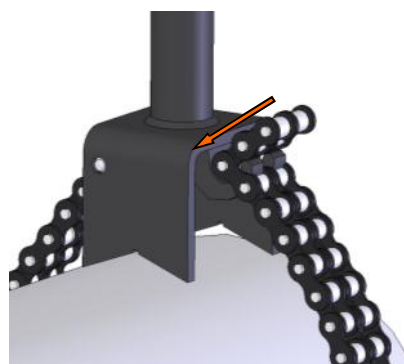
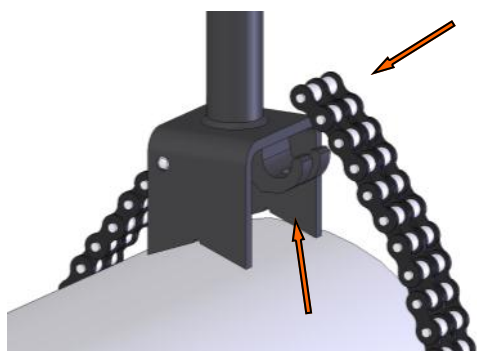
As provided for the paragraph 1.2.4.3. of the attachment 1 of the Machinery Directive, portable machines are exempt to have this feature.

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MACHINE SETUP FOR CUTTING



Place the chain locking kit on the pipe positioning the chain on the tie hook and rotate the handle clockwise to fix the locking kit firmly.

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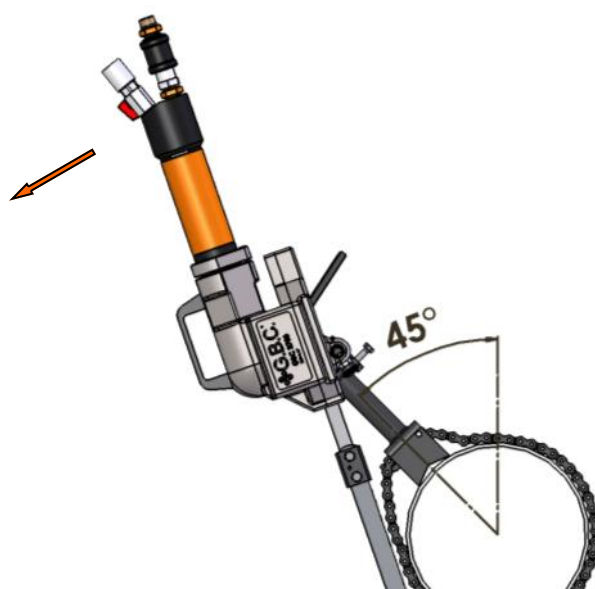


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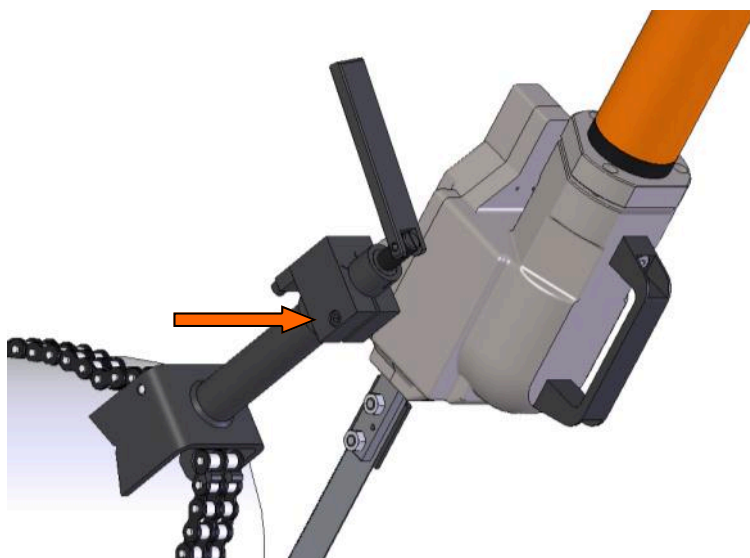


Install the Pipe Saw by inserting pin in the apposite seat in the unit body. While doing this ensure that the cutting blade is facing downwards and that the Pipe Saw has an inclination of 45° in relation to the axis of the pipe you need to cut as shown in the above picture.

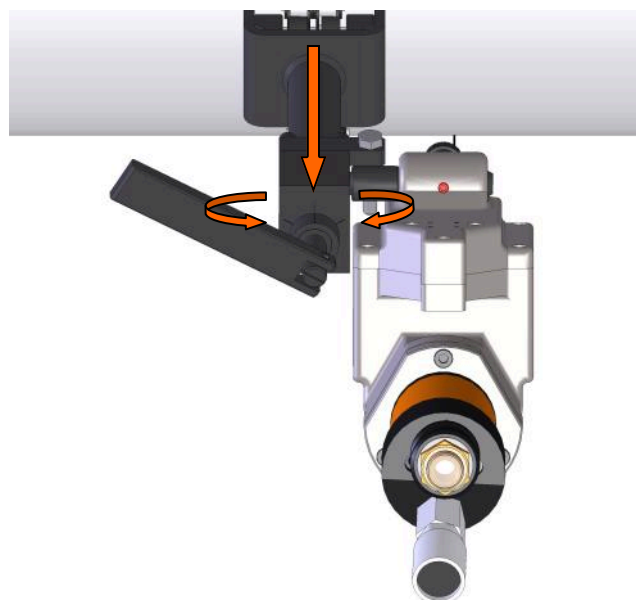


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To regulate the cutting angle you will need to loose the screw in the support as shown in the above picture and rotate the support itself.



N.B.: The Pipe Saw is capable of cutting from 0° to 45°.
In order to perform an angled cut you will have to regulate the Pipe Saw support in function of the positioning notches.

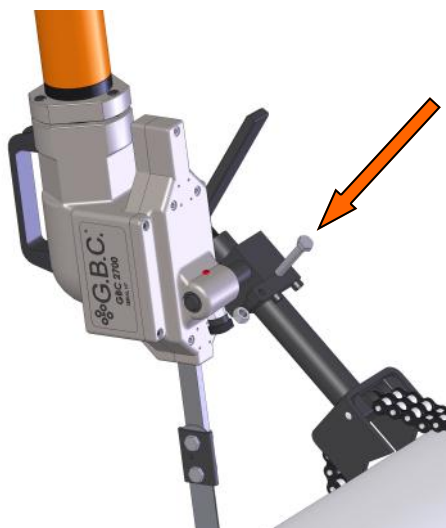
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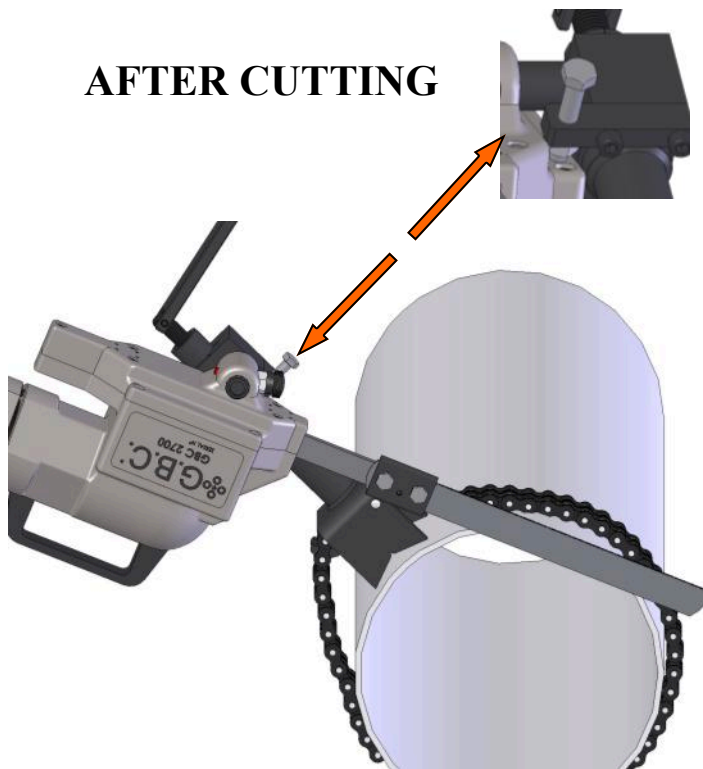


Fasten the end-cut screw in the required position.
This will stop the Pipe Saw rotation once the cut is executed.

WARNING!!! THE CUTTING BLADE WILL NOT STOP AUTOMATICALLY ONCE THE CUT IS FINISHED.

BEFORE CUTTING

AFTER CUTTING



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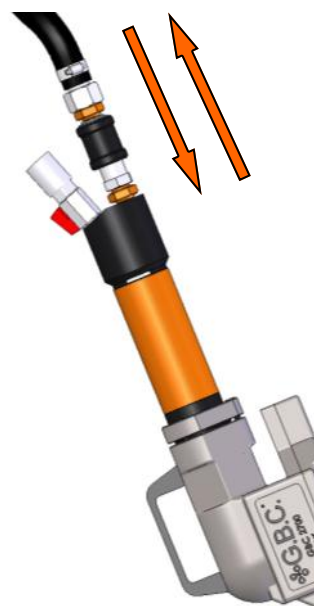


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Connect the unit to the external air system and open the valve of the pneumatic system.



- To actuate the machine you will have to push the valve body in the direction indicate by the arrow.
- To stop the machine you will have to push the valve body in the opposite direction.

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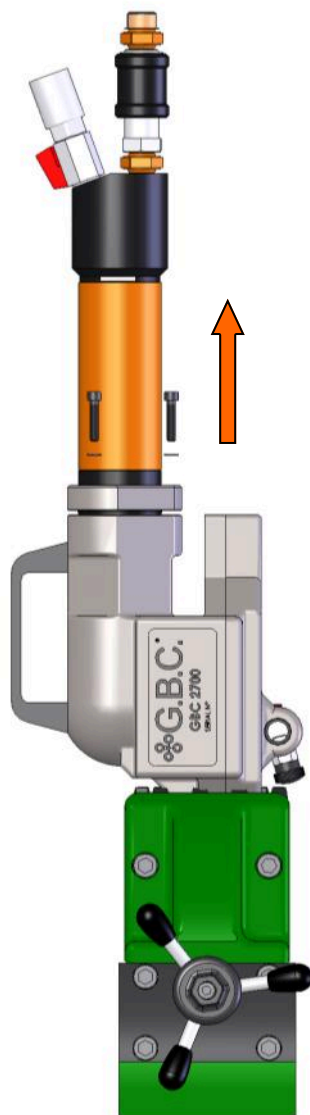


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CONVERTING THE MACHINE FROM PNEUMATIC TO ELECTRIC



Lock the machine body into a vice equipped with aluminum jaws , as shown in the above picture, then remove the three screws and the three washers.

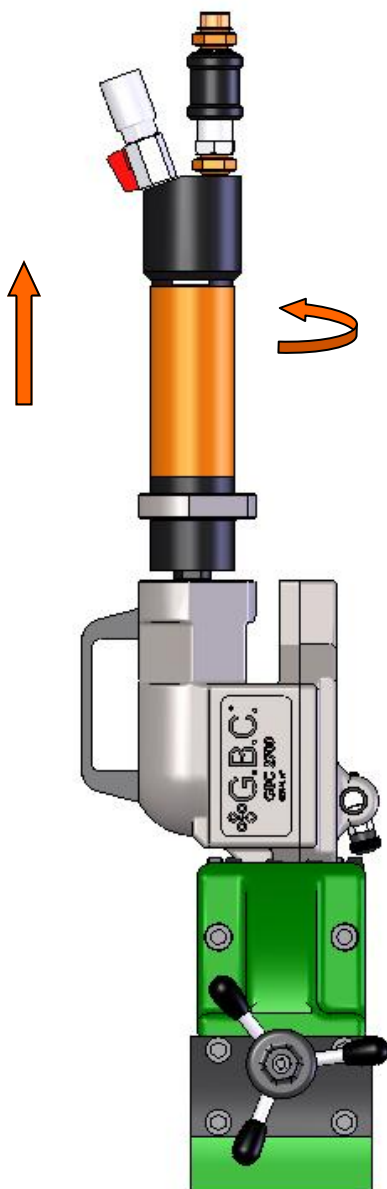
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Hold the pneumatic motor assembly by the motor and pull it outwards while rotating it until it comes out.

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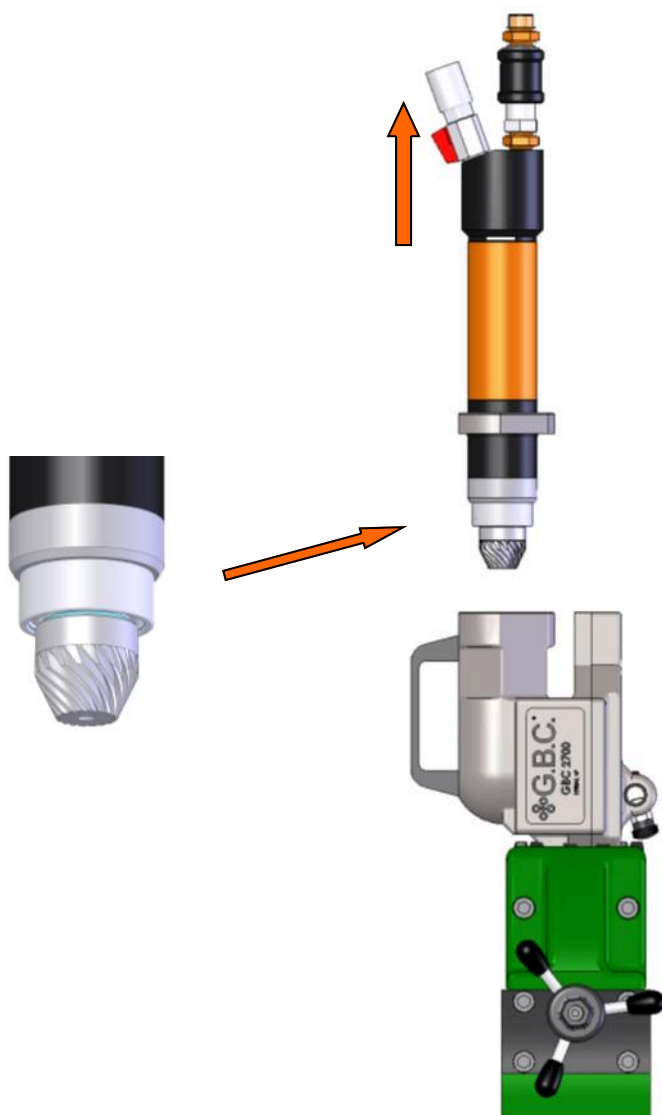
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WHILE PERFORMING THIS OPERATION YOU WILL FIND YOURSELF IN ONE OF THE TWO FOLLOWING SITUATIONS:

1° CASE

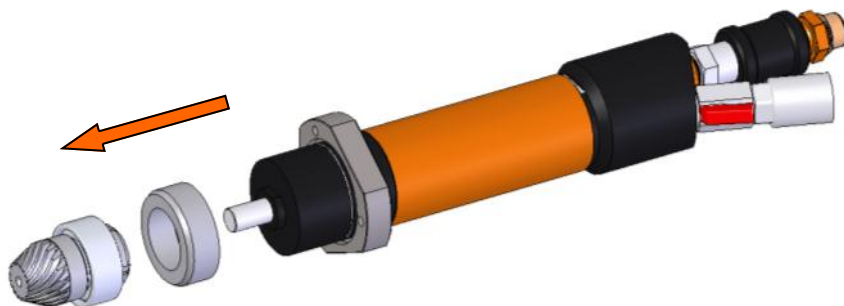
THE PINION ASSEMBLY REMAINS ATTACHED TO THE MOTOR.



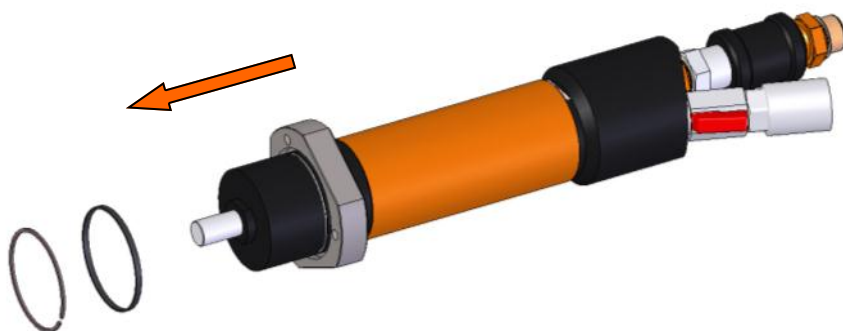
N.B.: Should you find yourself in this situation please proceed as follows:

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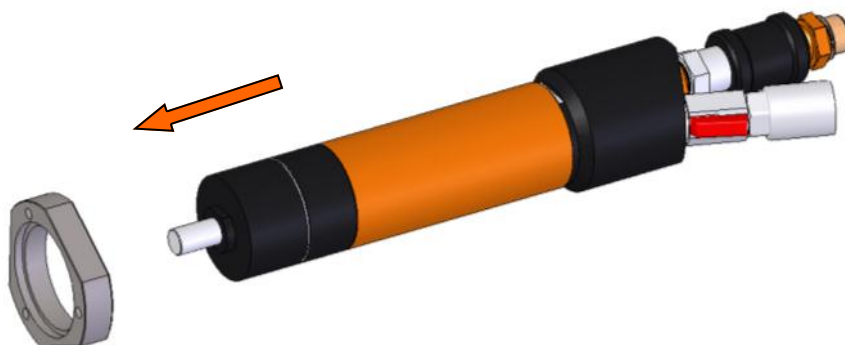
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Pull off the pinion assembly, formed by a pinion, a gasket and a ring. Once you have done this remove also the motor spacer.



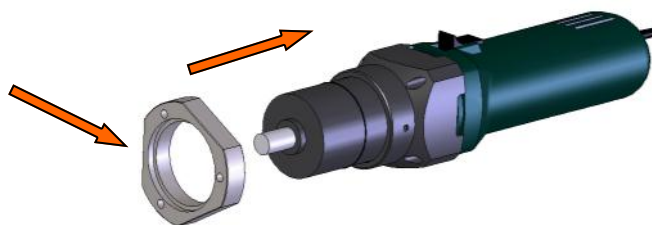
Subsequently you will have to remove the elastic ring and the spacer that keep the flange in position on the motor.



Now remove the motor flange.

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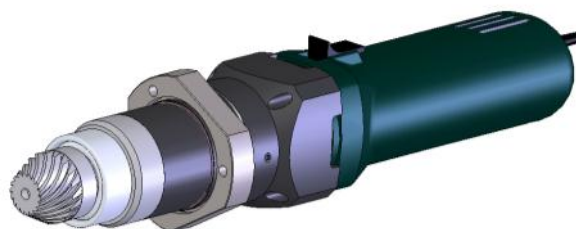
Install the motor flange on the end of the electric drive assembly making sure it is orientated as per the above picture.



Fix the motor flange in place by inserting the spacer and then the elastic ring.



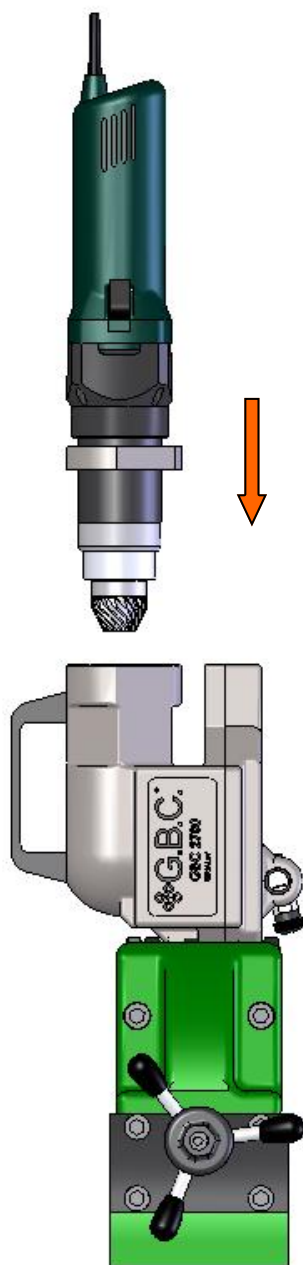
Install the motor spacer orientated as shown in the above picture and subsequently install the pinion assembly on the drive shaft, making sure its orientation matches with the key.





GBC 2700

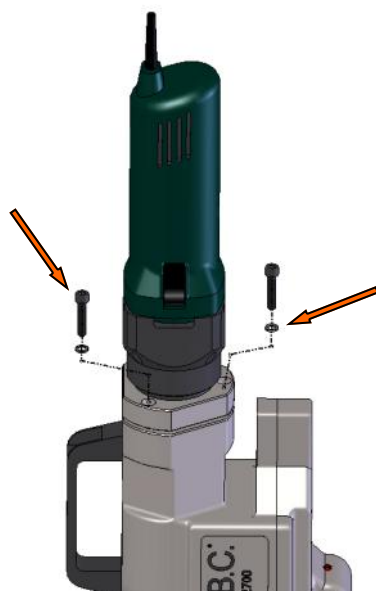
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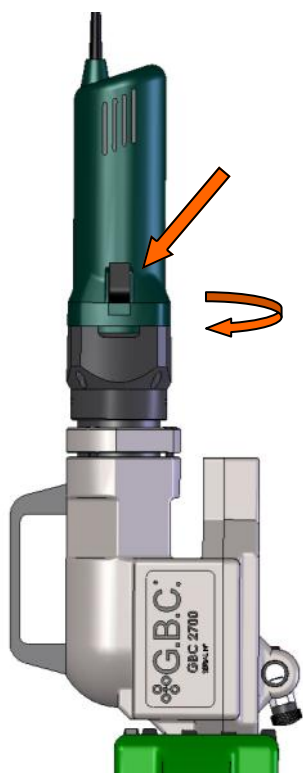
Install the electric drive assembly in the machine all the way down in order to engage the pinion with the crown.

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Fix the electric drive assembly to the machine by fastening the fixing screws with their washers very tight.



N.B. orient the start button on the side as shown in the above picture.

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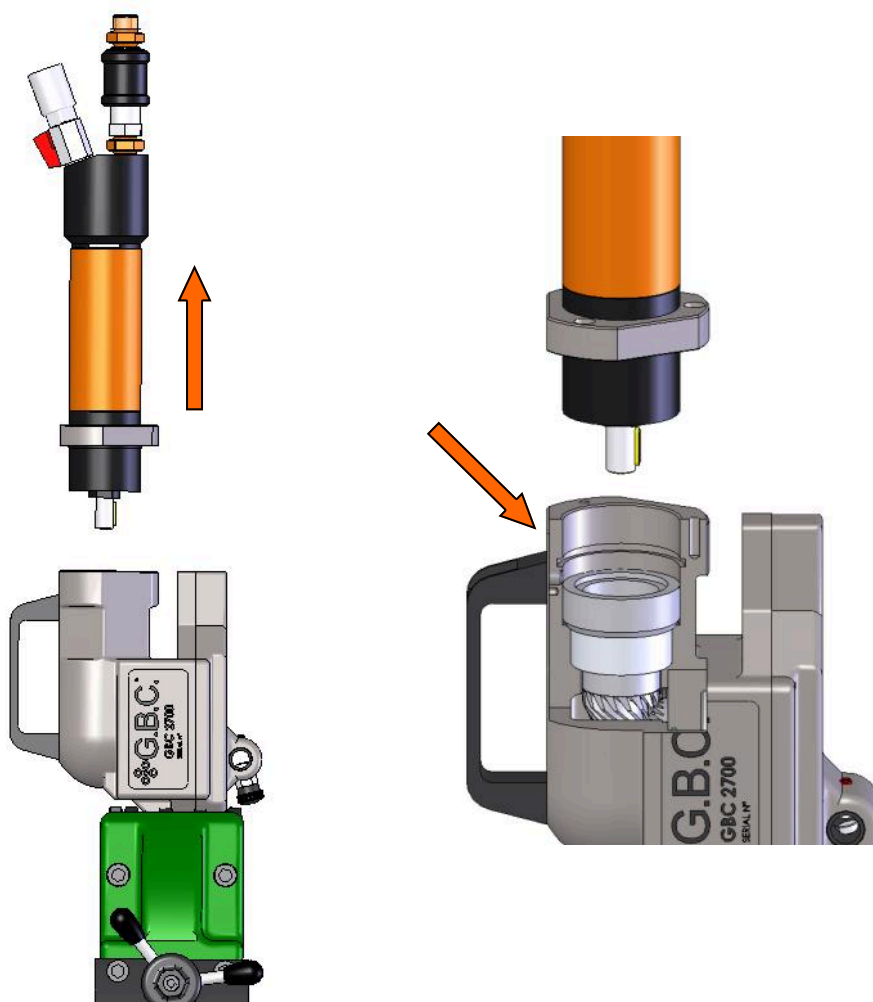
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2° CASE

THE PINION ASSEMBLY REMAINS INSERTED IN THE MACHINE BODY.



N.B.: Should you find yourself in this situation please proceed as follows:

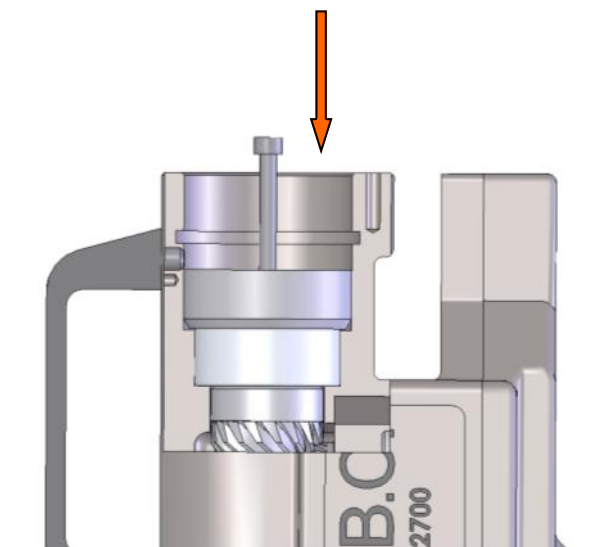
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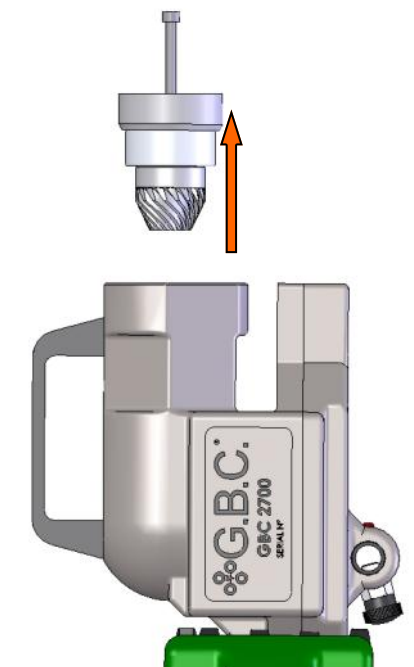


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Get an M6x60 screw or a longer one and screw it in the pinion so that it extends out of the machine body as shown in the picture. Now pull it until the pinion assembly comes off.



Now pull it until the pinion assembly comes off.

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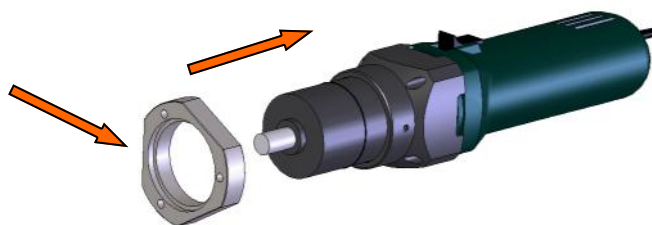
Remove the elastic ring and the spacer that keep the flange in position on the motor.



Now remove the motor flange.

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Install the motor flange on the end of the electric drive assembly making sure it is orientated as per the above picture.



Fix the motor flange in place by inserting the spacer and then the elastic ring.



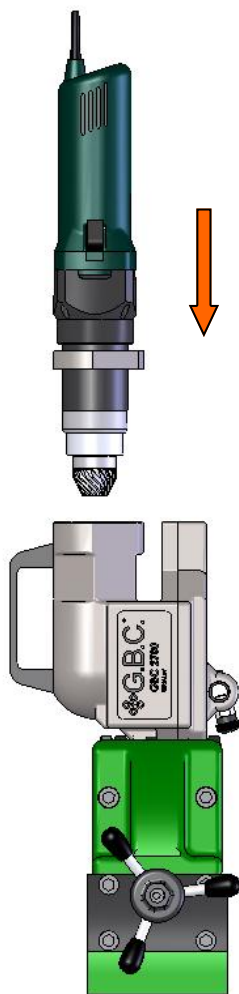
Install the motor spacer orientated as shown in the above picture and subsequently install the pinion assembly on the drive shaft, making sure its orientation matches with the key.





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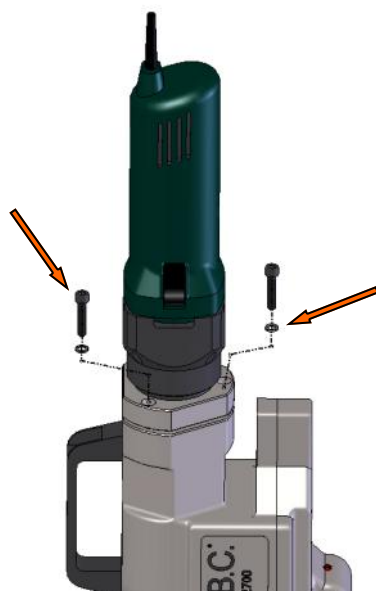
Istruzioni originali—rev.2011—in accordo al 1.7.4 della direttiva macchine 2006/42/CE



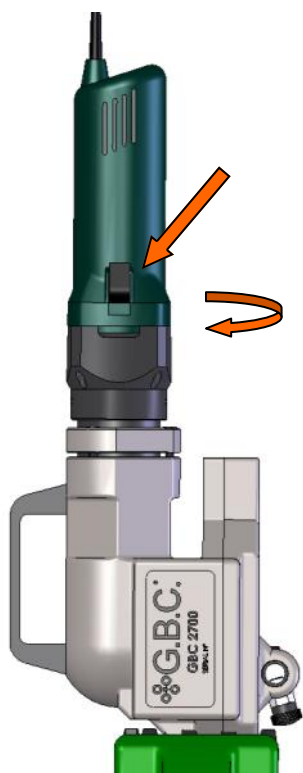
Install the electric drive assembly in the machine all the way down in order to engage the pinion with the crown.

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Fix the electric drive assembly to the machine by fastening the fixing screws with their washers very tight.



N.B. orient the start button on the side as shown in the above picture.

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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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TROUBLESHOOTING AND ACOUSTIC EMISSION

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 cutting blade status and ensure that the pipe you want to cut does not require special cutting blades due to its composition. 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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