

MINI C40



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 fur-ther 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 modi-fication 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



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 pre-scribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.



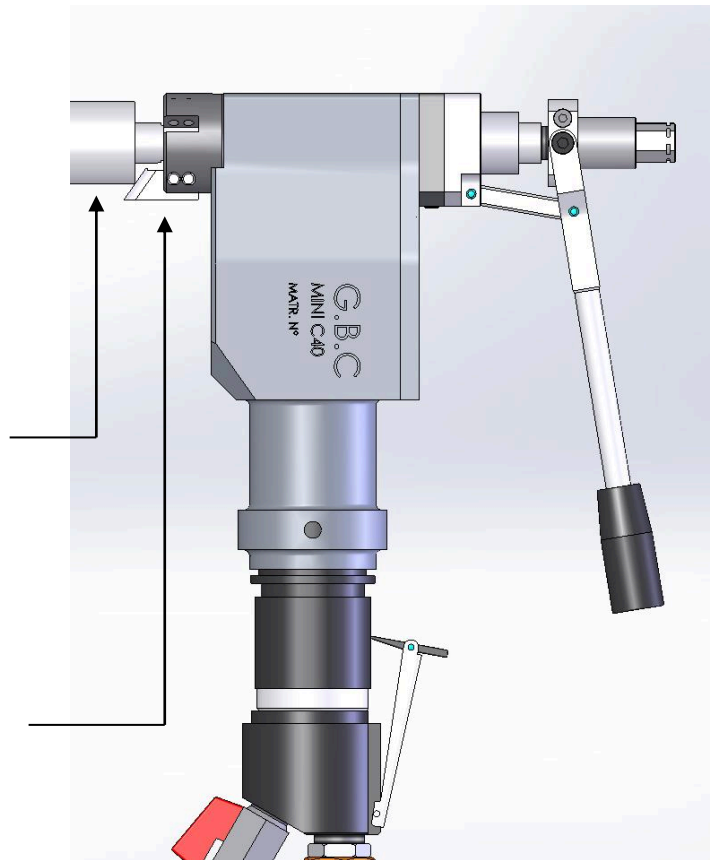
INTENDED USE OF THE MACHINE

The machine shown in the drawing is intended to be used for prepping pipes for the welding.

It works while inserted and locked into the ID of the pipe

It works while inserted and locked into the ID of the pipe.

The bevel is obtained by bevelling tools of various shape and materials, depending by the nature of the material to be bevelled.



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

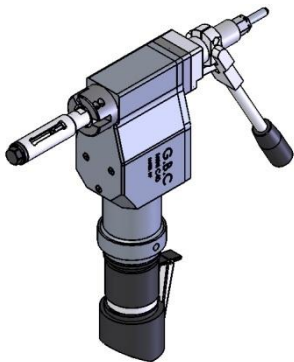
FOLLOWING TO A SPECIFIC FORMATION WE DO NOT ENVISAGE ANY REASONABLY PREDICTALBE MISUSE OF THE UNIT



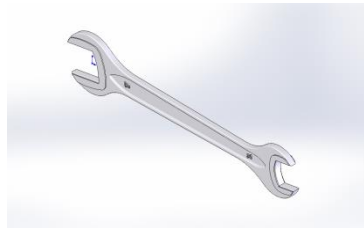
MACHINE STANDARD EQUIPMENT

The machine is supplied with:

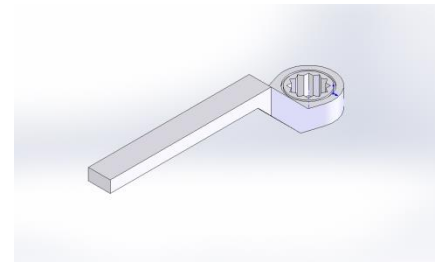
- Locking Jaws Complete series from 20 to 39 mm
- 2.5mm Allen Key
- 14mm Ratchet Wrench
- 14-17mm Double Open End Wrench
- Plastic Case
- Instruction Manual
- Exploded Drawings



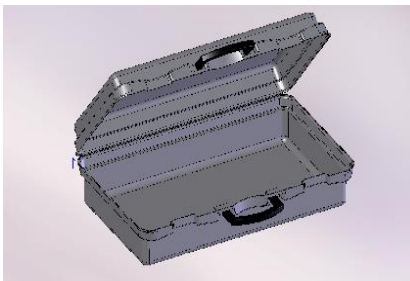
Mini C40



Double Open End Wrench



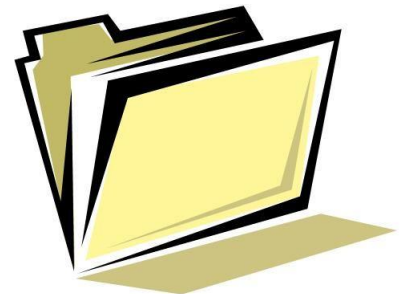
Ratched Wrench



Plastic Case



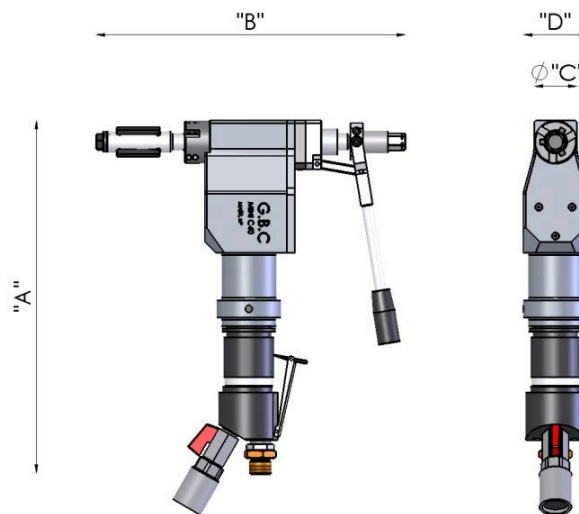
Allen Key



Instruction Manual And
Exploded Drawings



TECHNICAL DATA		PNEUMATIC	ELECTRIC	BATTERY
ID Locking Range	mm (inches)	20 - 39 (0.78-1.53)	20 - 39 (0.78-1.53)	20 - 39 (0.78-1.53)
Idle Speed	gg/min (Rpm)	243	290	152
Max Chuck Torque	Nm (Nm)	8 (6 bar) 13 (8 bar)	18	34
Axial Feeding	mm (inches)	20 (0.78)	20 (0.78)	20 (0.78)
Pneumatic Motor Power	Hp (W)	0.58 (430)	-	
Air Consumption	NI/min (cfm)	600 (21.18)	-	
Air Pressure	Bar (psi)	6 ÷ 8 (87 ÷ 116)	-	
Air Hose Connection	Pollici (inches)	1/2" (1/2")	-	
Electric Motor Power	W	-	720	720
Tension	Volt	-	110 / 230	18V
Frequency	Hz	-	50 / 60	
Max Acoustic Emission	Db	75	75	75
Machine Weight	Kg	4.8	5.5	5.5



DIMENSIONS		PNEUMATIC	ELECTRIC
A	mm (inches)	329 (12.79)	450 (16.14)
B	mm (inches)	289 (11.81)	480 (18.89)
Ø C	mm (inches)	40 (1.57)	40 (1.57)
D	mm (inches)	60 (2.36)	60 (2.36)



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 1,5metres 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.**



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

Weight of the Machine	kg	6
ShippingDimensions	mm	63x63x30
ShippingWeight	kg	12,5

Under 25 Kgs no lifting machines are required.



MACHINE STABILITY

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

WORKPLACE

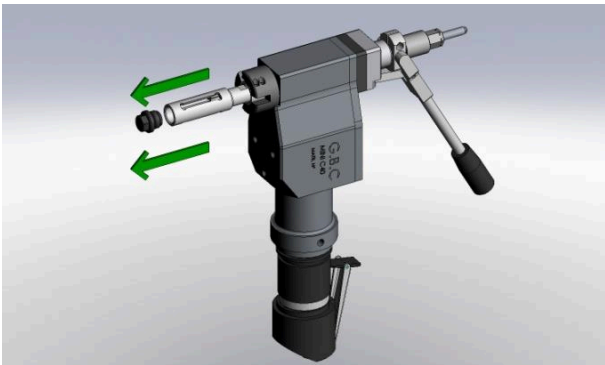
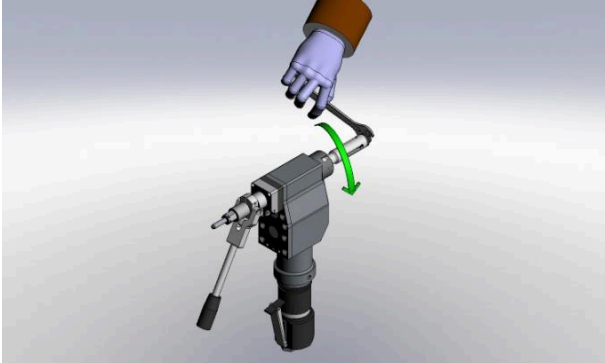
By always using both hands for operating the machine, the operator is unable to reach the bevelling tools as the unit would suddenly stop – motor brake –

EMERGENCY STOP INSTALLATION **EXEMPTION**

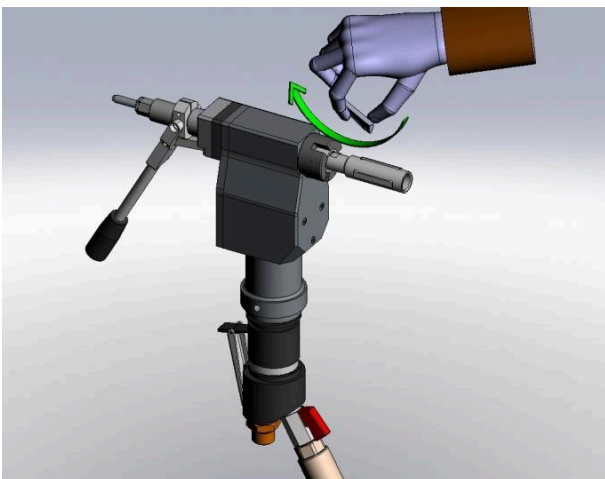
As provided for the paragraph 1.2.4.3. of the attachment 1 of the Machinery Directive, portable machines are exempt to have this feature.



MACHINE SETUP



Remove the Vane Abutment Cap after you have checked the vane expansion nut is not abutted.



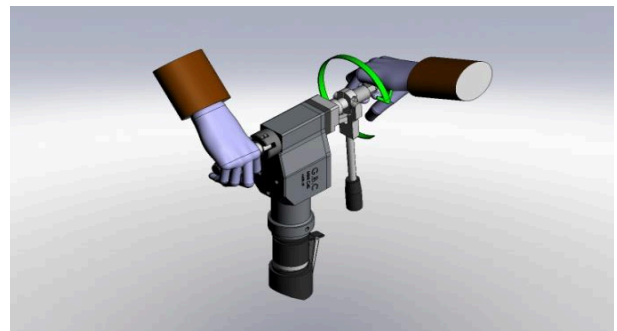
Remove the locking jaws currently installed.



DO NOT MOVE THE EXPANSION SHAFT! You can move it by the vane expansion nut after the locking jaws have been reassembled.

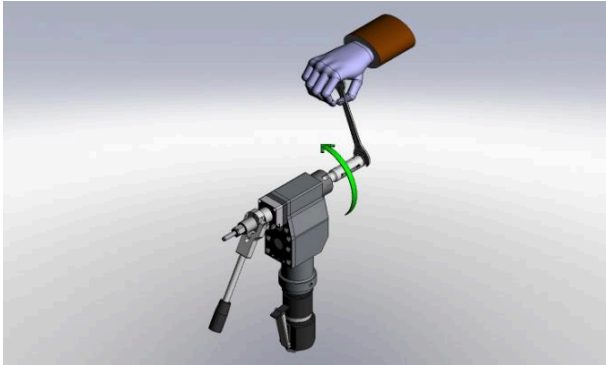


Select the appropriate locking jaws in relation to the ID of the pipe and install them on the shaft.

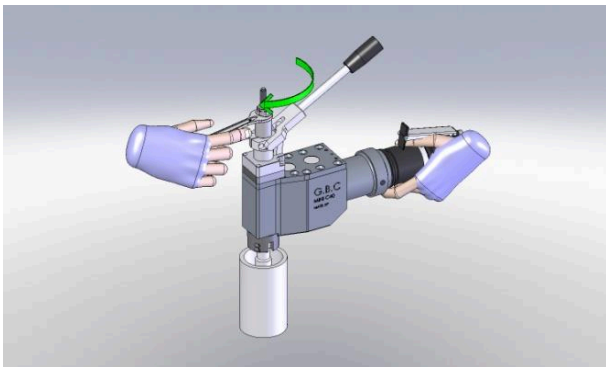




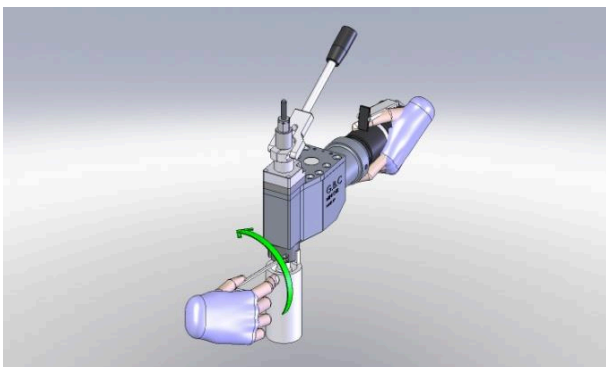
Hold in place the locking jaws with your hand while you unscrew the vane expansion nut to make them withdraw. If the assembling procedure was executed correctly they should have a little play in their seat.



Screw back on and abut the vane expansion bush and the vane expansion cap.

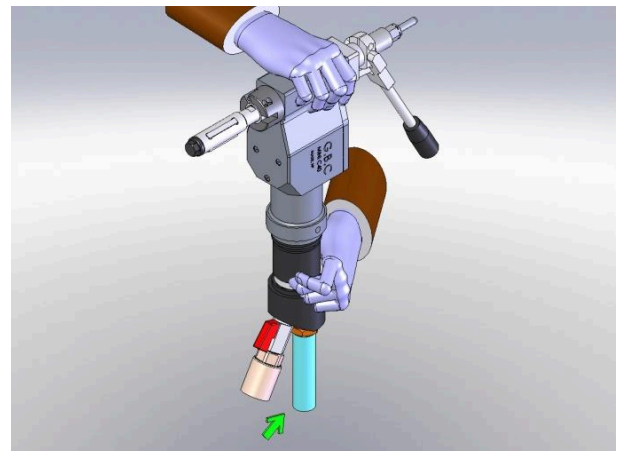
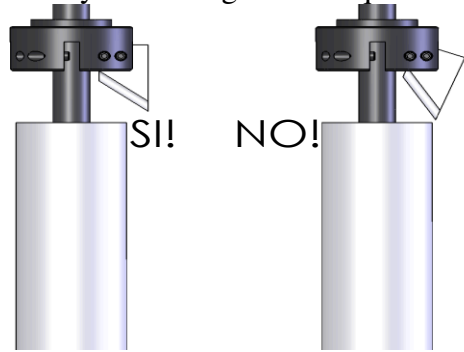


Keep the machine in axis with the pipe and insert the shaft in the pipe ID. Now turn the vane expansion nut. The locking jaws will expand locking the pipe. The locking should be very tight.

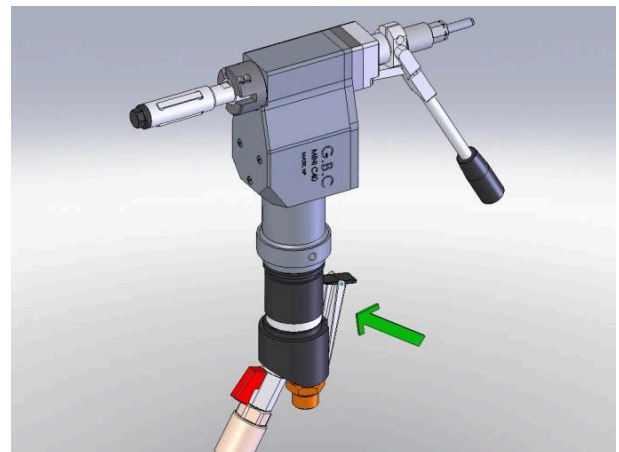


Choose the appropriate tool in regard to the job required and place it on the mandrel

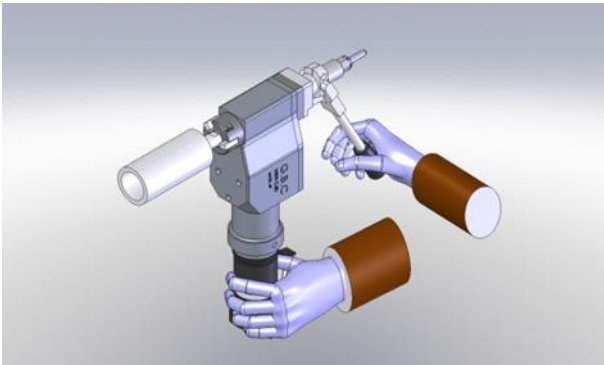
locking it by the grub screws. You will want to equip at least two opposite bevelling tools and eventually one facing tool if required.



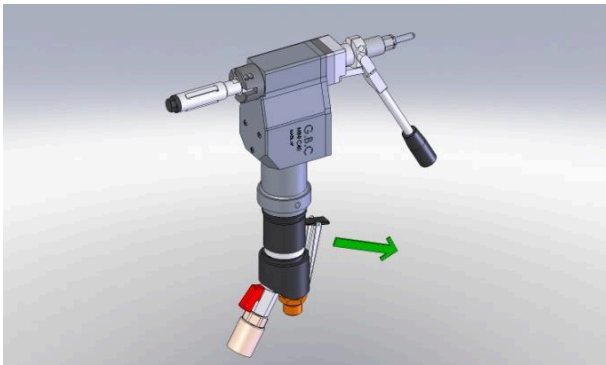
Connect the air hose to the air system.



Press the lever to start the machine. **N.B.:** This machine is equipped with a dead man switch, therefore you will have to apply constant pressure on the lever to keep the machine running.

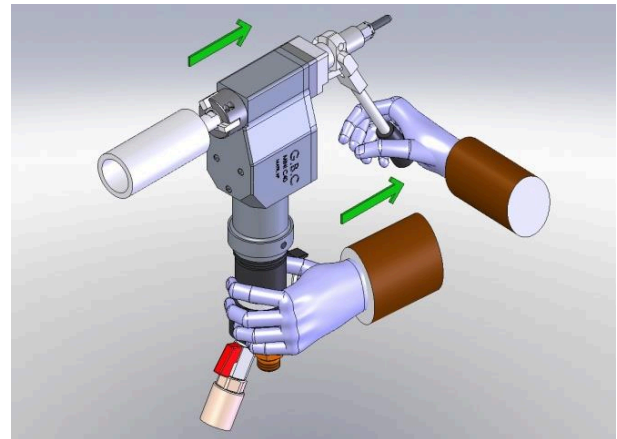


The feeding of the machine is obtained by pushing the lever located on the rear.



When finished, release the motor lever to stop the machine.

WARNING! ALWAYS MAKE SURE THE TOOLS DON'T TOUCH THE LOCKING JAWS DURING THE WORKING SESSION IN ORDER TO AVOID ANY POSSIBLE DAMAGE.

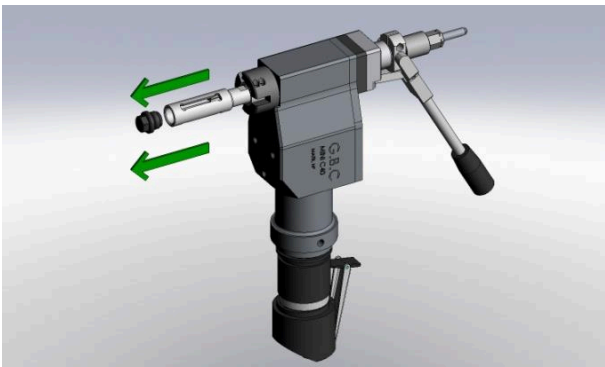
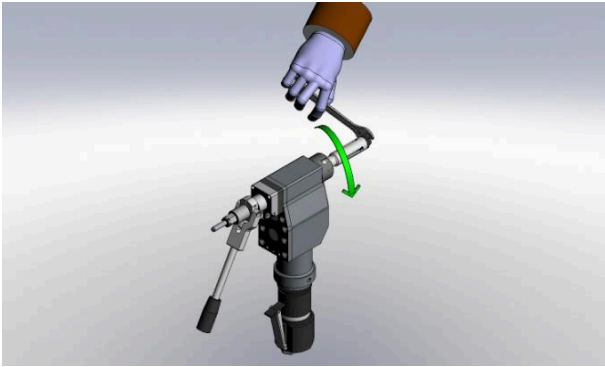


Remove the machine from the pipe:

- 1- Loose the vane expansion nut using the tool supplied with the machine.
- 2- Remove the machine.



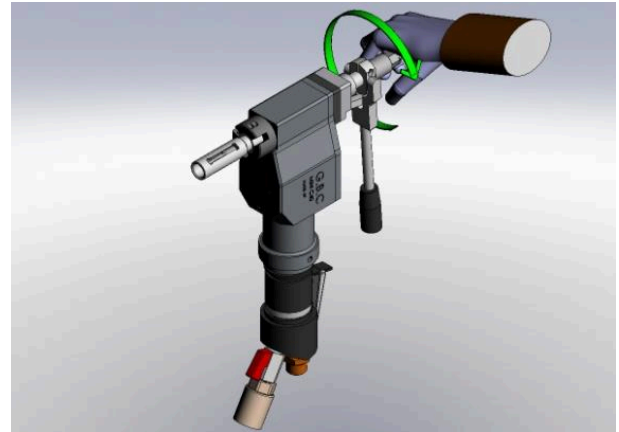
REDUCED SHAFTS ASSEMBLY



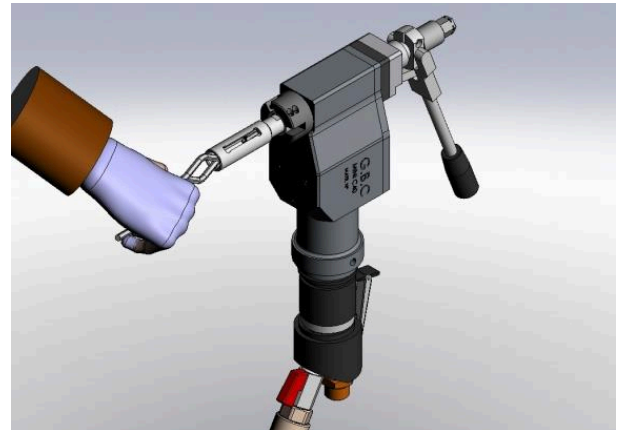
Remove the vane abutment cap after having checked the vane expansion nut is not abutted.



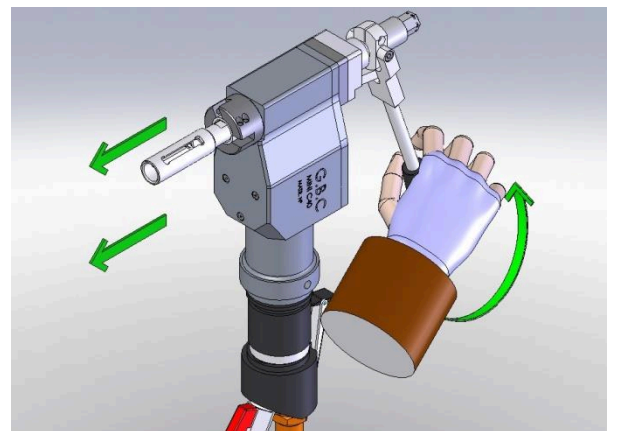
Remove the locking jaws.



Screw the vane expansion nut until it is abutted.

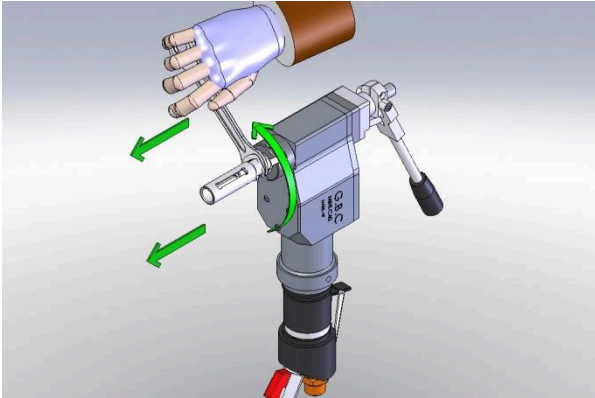


Rotate the expansion shaft clockwise helping yourself with long nose pliers until you can remove it.

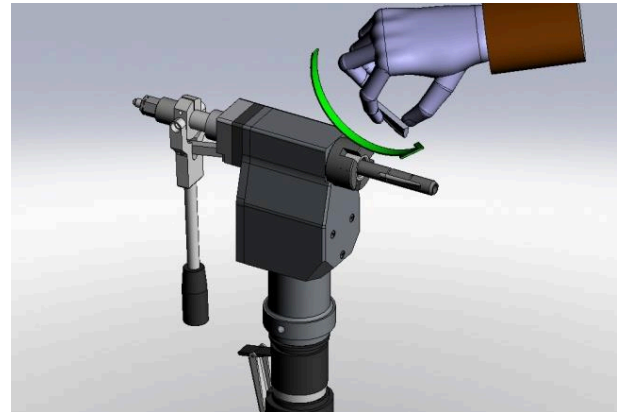




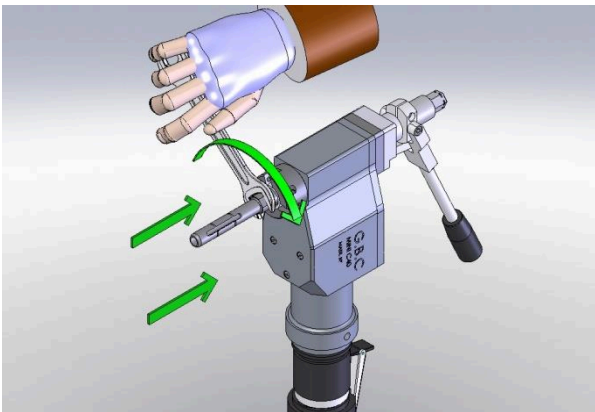
Advance the guiding shaft using the feeding lever



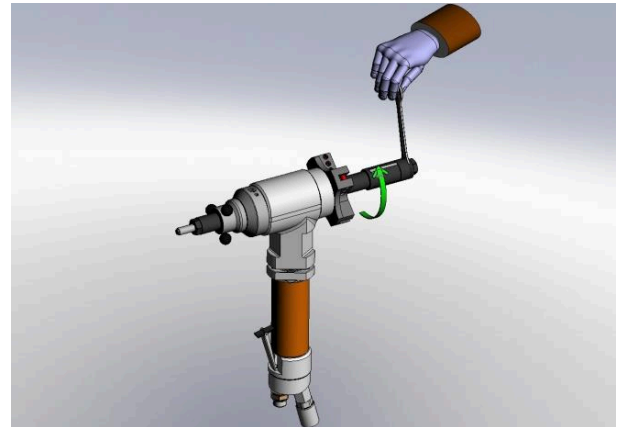
Insert the reduced shaft in the guiding shaft and screw it in helping yourself with a screwdriver until the notch is aligned with the pin located on the head of the guiding shaft.



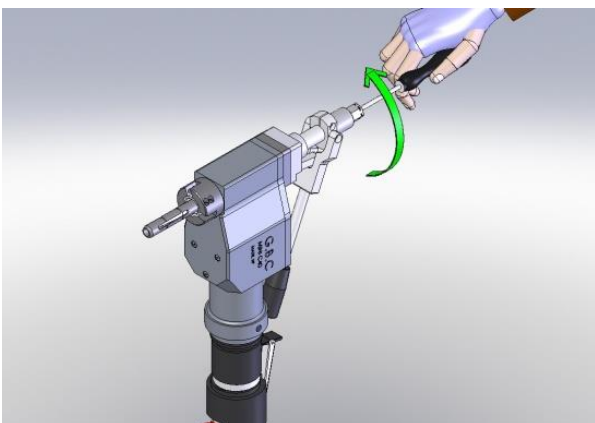
Remove the guiding shaft by unscrewing it by the extension.



Select the locking jaws in relation to the ID of the pipe to be worked and install them in the shaft as shown in the picture.



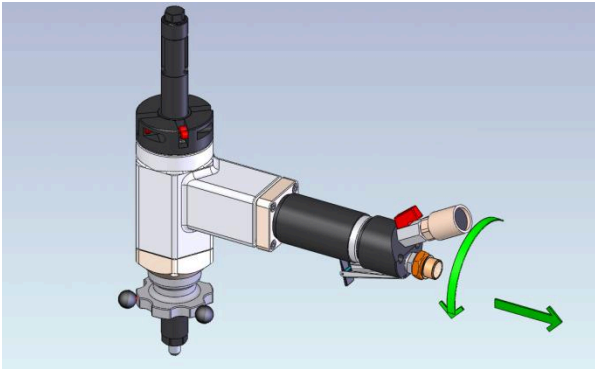
Once the appropriate head is selected screw it on the extension



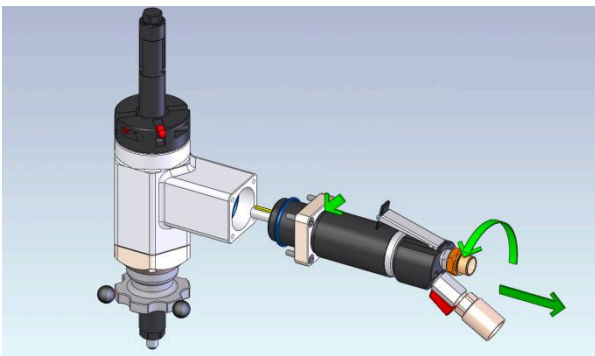
Screw back on the vane abutment nut..



REPLACING THE PNEUMATIC MOTOR WITH THE ELECTRIC MOTOR

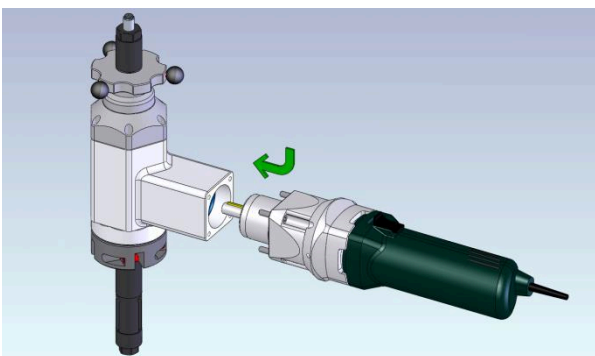


Remove the screws holding the motor support flange and remove the pneumatic motor.



Grab the motor and pull outwards applying small rotating movements until you can successfully remove it.

N.B.: Ensure that the pinion remains in its seat..



Insert the electric motor and secure the screws of the motor to the machine case.



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.



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 run properly :Check the condition of the shaft and verify it to perfectly spins around its axis of rotation.

The machine does not bevel :Check the beveling tools condition and ensure that the pipe you are working does not require special bevelling tools 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.