

BEVELLING AND CHAMFERING SYSTEM WITH THE VARIABLE ANGLE B 3

Stationary desktop design

Order no. 28 220



User Manual



Customer _____
Model _____
Serial number _____
Year _____



Trick-Tools.com

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Pella, IA 50219
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E-mail: sales@trick-tools.com



Before use :



Before using, always carefully read the manual



Always follow the safety regulations applicable to your country!

The machine is designed only for the following activities

It is intended solely for bevelling and deburring of metal materials in a workshop.

Use only in an environment protected from rain, snow and other adverse weather conditions.



Safety Regulations

To avoid injury, observe the following

Before bevelling, check if the machine is not mechanically or otherwise damaged.
The machine can be commissioned only, if the supply or extension cable is not damaged. Check the cable regularly. If the cable is damaged, it must be repaired immediately in a workshop, which is authorized to perform these repairs.

The device is intended for a network with the voltage of 400 V 50 Hz or 110V 60 Hz.

Personal protection against injury

Wear safety goggles, safety boots, hearing protection, appropriate headgear (in case of long hair) or protective helmets during work.

- Plug the power cable into the socket only, when the power switch of the machine is in the off position.
- Provide adequate lighting of the workplace, so as to avoid injury or damage to the eyesight.
- Attention, the tool (cutter) is sharp. There is a risk of injury when replacing it, so always wear protective gloves and never touch the cutter when in motion.
- The machine must always stand steadily on a firm ground.
- During work, the power cable should always be freely positioned outside the material being worked.
- After work, unplug the power cable.
- Do not overload the machine engine. The machine works best, when it is not overloaded.

In case of damage, have the machine repaired in a workshop, which is authorized to perform these repairs.

Familiarize yourself thoroughly with the following instructions to avoid personal injury and/or property damage.

- Never attempt to operate the machine, until you are thoroughly acquainted with the way it works. If you are still in doubt even after carefully and completely reading this manual, contact the company N.KO
- Make sure that all the technical staff, who use the machine and carry out maintenance, are completely familiar with all relevant safety recommendations.
- Before starting the machine, the operator must make sure that all safety devices are operational and that all safety guards are installed.
- Never use the machine for purposes other than those specified in the manual. Never process other products than those listed.
- Contact the company N.KO, before you use the machine for purposes other than those listed, to ask for permission.
- The voltage values used to power the machines are dangerous: make sure that all connections are made correctly, and never perform maintenance of the machine, nor replace parts, when the machine is connected to a source of electricity, and never make any branches on electrical connections.
- Replace parts, which are considered faulty, with others that are recommended by the manufacturer. Never replace them with anything other than genuine parts.
- Never wear clothing or jewellery that could get caught in moving parts. It is advisable to wear safety clothing: shoes with non-slip soles, earmuffs and goggles.



Important:

If any defects occur during the life of the machine, which cannot be repaired based on this manual, it is advisable to contact the company N.KO, so that the problem can be solved as soon as possible.

Unpacking

Unpack the machine from the carton and check that everything is in order and undamaged. For inquiries, please contact the seller.

The device is supplied assembled.

Only connect the device to the network 400V - 50Hz or 110V – 60Hz.

Warranty

The seller provides a warranty for the bevelling system B 3, which guarantees that the goods will not have material or manufacturing defects for the period of 12 months from the date of delivery of the goods.

The warranty for the faultless functioning of the goods and used materials is for 12 months from the date of delivery of the goods.

The seller agrees to ensure removal of any potential defects covered by the warranty free of charge and without undue delay, so as to allow the buyer to use the goods properly. If the buyer exercises the rights from liability for defects, which are not covered under the warranty, the buyer shall pay the related costs to the seller.

The warranty period is interrupted on the date, when the buyer notified the seller about the existence of a defect covered by the warranty, owing to which the buyer cannot use the goods, and for which the buyer exercised his rights from liability for defects from the provided warranty. The warranty period then continues from the date of removal of such defect by the seller.

The warranty does not cover natural and normal wear and tear of the goods and defects caused by improper use of goods in contravention of the provided training, and documentation. This warranty does not cover defects caused by overloading of the goods and defects arising after improper tampering with the goods, or improper repair or modification of the goods. Tampering, repair or modification means any intervention, repair or modification, which was made in contravention of the provided training and documentation, or which was made by a person other than the seller or other than the person authorized or approved to perform it.

The rights from liability for defects under the provided warranty shall be submitted to the seller without undue delay, after the buyer discovers a defect, but no later than at the end of the warranty period, otherwise the rights expire.

You must submit the warranty card to be able to exercise rights from liability for defects under the provided warranty. Otherwise these rights of the buyer cannot be acknowledged.

The seller's liability for defects covered by the warranty arises, if these defects were caused after passing of the risk of damage to the goods by external events. External events include, in particular, natural disasters, Force Majeure or conduct of third parties.

N.KO. considers the warranty invalid in case of:

- Improper use of the machine;
- Use contrary to national or international standards;
- Incorrect installation;
- Faulty power supply;
- Serious shortcomings in maintenance;
- Unauthorized modifications and/or interventions;
- Use of non-original or wrong spare parts and accessories for the given model;
- Total or partial failure to comply with the instructions;
- Extraordinary events, natural calamities or other.

Technical information

Technical data:

Bevelling angle: 30° - 60°. Continuously adjustable
Width of bevelling: 0 - 3 mm 400N/mm²
Voltage: 380 V - 50 Hz or 110 V – 60Hz
Engine power: 1.3 kW or 0,375 kW
Speed: 3,600 rpm. / min
Feed: manual
Weight: 28 kg
Dimensions 530x420x410mm
The number of inserts 5pcs (tetrahedral)

The price includes:

A complete bevelling system - fitted with a head and cutting inserts. A supply cable without a plug.
Operation tool
Manual

Chamfering and bevelling system B3 Order. no. 28 220 (400V) or 28 211 (110V).
Spare milling head (fitted with cutting inserts - 5 pieces) obj. no. 28221
Cutting inserts, coated obj.no. 25909

CAUTION !!!

Before replacing the tools, setting the equipment, starting maintenance and cleaning, always first unplug the power supply cable from the mains.

Tool

The machining tool is a milling head equipped with cutting inserts.

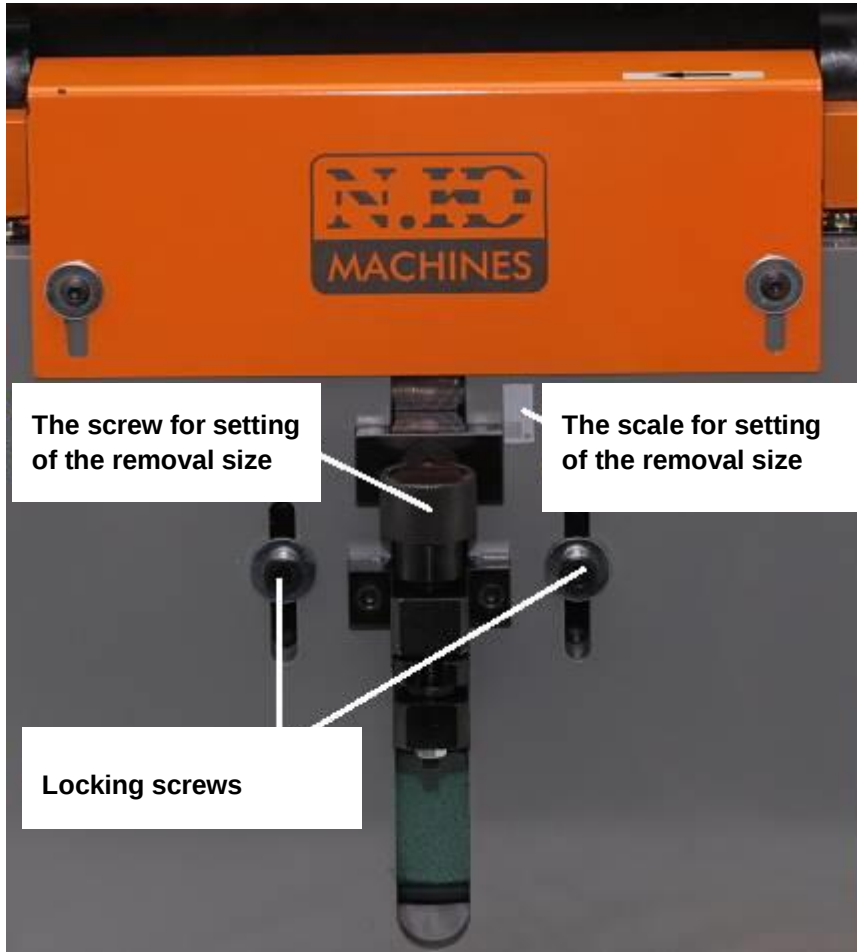


Replacing the cutting inserts

Remove the guide rails. Using the supplied wrench, loosen the screw securing the cutting inserts. Rotate or replace the cutting insert. Tighten the screw securing the insert. Repeat for the other inserts.

Setting the size of the removal

Loosen the locking screws and adjust the size of the removal. The size of the removal is visible on the approximate scale. After adjustment, retighten the locking screws, so that the set removal size is fixed.



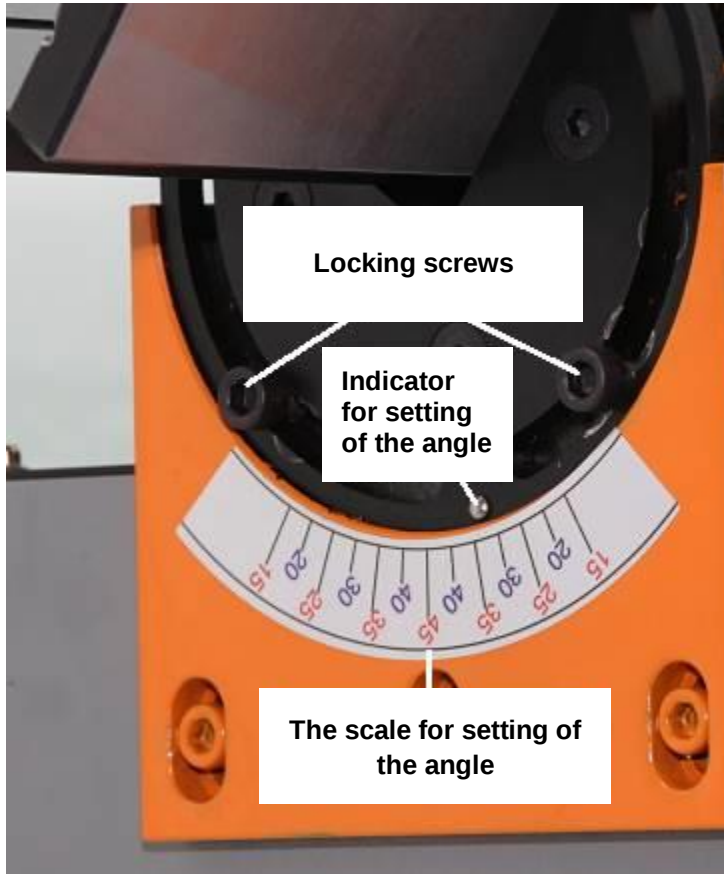
In case you need to use the maximum possible removal of the device, divide the required bevelling into several steps.

If the setting is wrong, it causes accelerated wear of the milling cutter. It may even lead to an immediate destruction of the tool. Therefore, you should pay maximum attention to correct settings of the removal and feed of the material for bevelling. Corrects settings will prevent premature wear or destruction of the tool.

Adjustment of the bevelling angle

CAUTION !!

Before changing the angle, lower the cutter head to the zero position (see the paragraph "Adjust the size of removal")



Loosen the screws on both sides. Tilt the prism to the desired angle and tighten the locking screws.

Use

- The bevelling system must always stand steadily on a firm ground.

Check, if the cutter head can rotate freely and does not hit the guide rails.

Turn the main switch to the position I.

Allow the device to run full speed.

Take the material with both hands and move it in the guide rails according to the arrow on the guard. Never the other way around. The speed of moving is based on the type of material being machined, bevel width, and other factors.

In principle, the larger the bevel, or rather the harder, the tougher the material is, the slower it is necessary to move the material, so as not to overload the machine, or it may be necessary to set a smaller removal and make the required bevelling in several steps by continuous enlargement of the removal size. Try to make the material follows the plate fences. Only in this way we can guarantee the quality of the bevel.



CAUTION !!!

Before you start the machine, make sure that the cutter head rotates freely and that it does not hit the bottom of the plate fences.

With each change of the angle, the distance between the milling head and the plate fences is changed as well.

In case you need to use the maximum possible removal of the device, divide the required bevelling into several steps.

If the setting is wrong, it causes accelerated wear of the milling cutter. It may even lead to an immediate destruction of the tool. Therefore, you should pay maximum attention to correct settings of the removal and feed of the material for bevelling. Correct settings will prevent premature wear or destruction of the tool.

Start bevelling always from the edge of the material. We do not recommend to start working by nesting into the material. This may lead to damage or blunting of the cutter.

Cleaning

If the machine is cleaned at regular intervals, you prolong its life and prevent a potential injury.

Keep the control buttons clean.

Blow out impurities from the wiring with dry air.

Check the individual parts of the machine to see, if they are loose or damaged.

Check if the power cable is not damaged.

Maintenance and repairs.

Maintenance and service of the machine must be performed only in a repair shop, which has authorization to perform these repairs.

After every 250 hours of operation, the machine must be sent to an authorized service centre, where the engine housing must be cleaned, bearings lubricated and other parts, which require regular maintenance, must be checked. In case of a failure to comply with the service interval, it is not possible to recognize any incurred damages as a warranty repair.

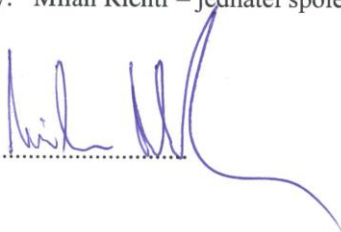
It is necessary to use only original parts.

CE Certificate of Conformity

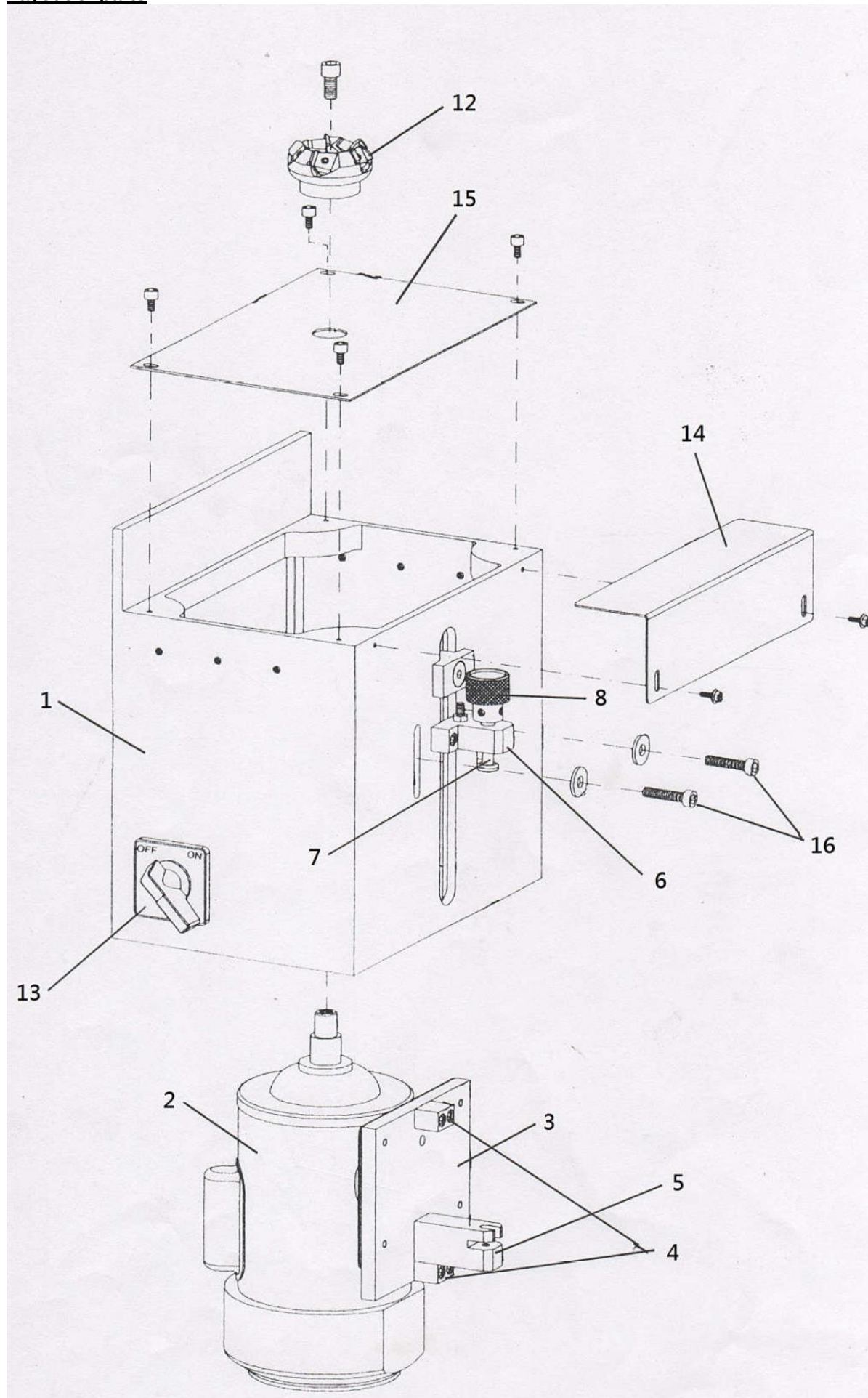
ES Prohlášení o shodě

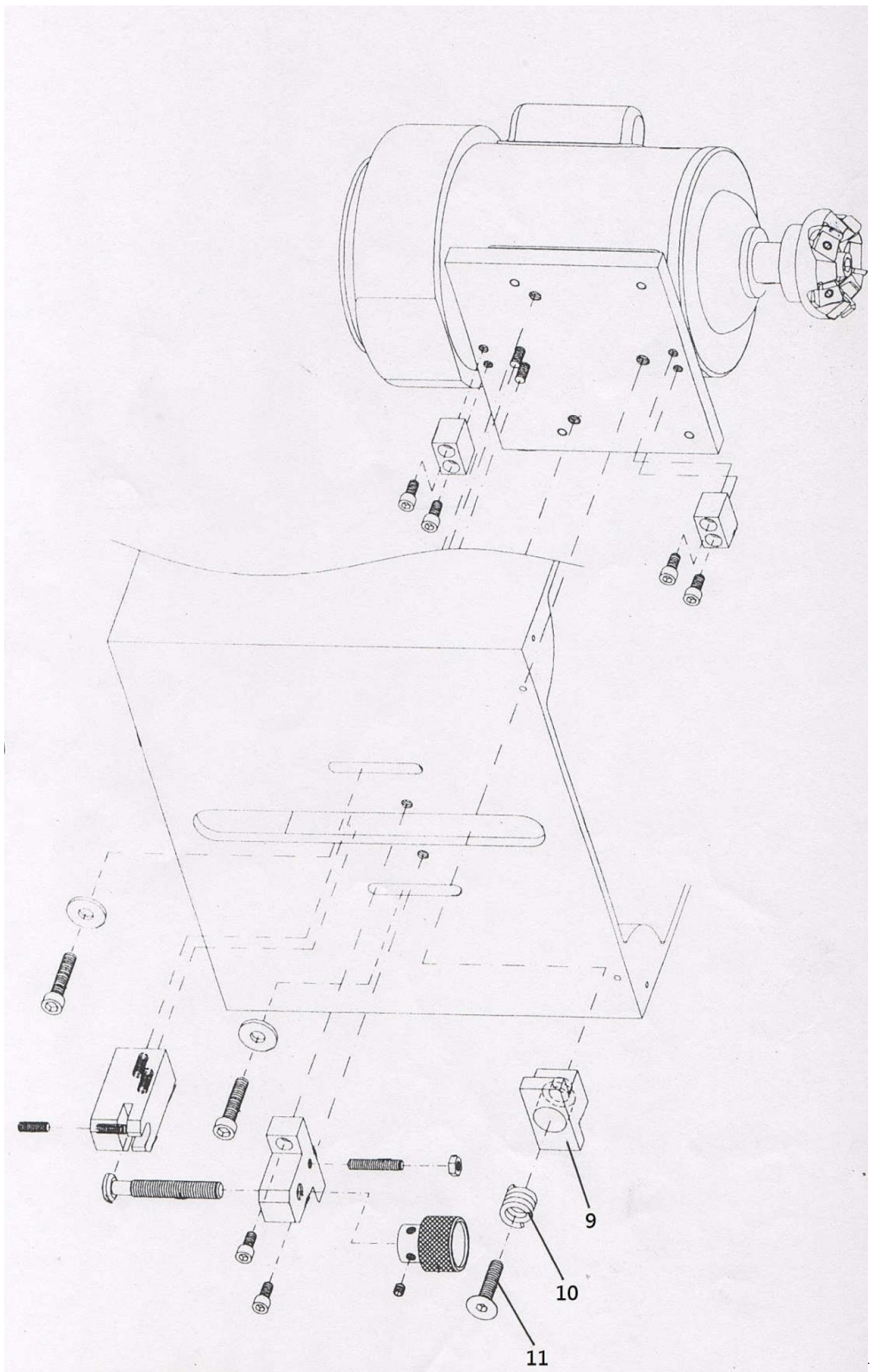
1. Jméno vydavatele prohlášení: N.KO spol. s r.o.
Adresa vydavatele prohlášení: Tábořská 398/22
IČO: 26161109
2. Předmět prohlášení:
Název: STACIONÁRNÍ ÚKOSOVACÍ A ODJEHLOVACÍ STROJ
Typ: B 3
Výrobce: N.KO spol. s r.o.
3. Účel použití: Úkosování a odjehlování hran plechů
4. Výše popsaný předmět prohlášení je ve shodě s požadavky následujících dokumentů
- Směrnice 2006/42/EC.: Bezpečnost strojních zařízení – základní požadavky
Směrnice 2004/108/EC.: Elektromagnetická kompatibilita
- EN ISO 12100: Bezpečnost strojních zařízení – Všeobecné zásady pro konstrukci.
Posouzení rizika a snižování rizika
EN ISO 13857:: Bezpečnost strojních zařízení – bezpečné vzdálenosti pro horní a dolní končetiny
EN 953: Bezpečnost strojních zařízení – požadavky na konstrukci ochranných krytů
EN 60204-1: Bezpečnost strojních zařízení – elektrická zařízení pracovních strojů
EN 61000-6-3: Elektromagnetická kompatibilita - kmenové normy - emise - prostředí obytné, obchodní a lehkého průmyslu
5. Údaje o akreditované /notifikované osobě:
- datum a místo vydání: 25. 6. 2015 Mladá Boleslav
jméno a funkce oprávněné osoby: Milan Richtr – jednatel společnosti

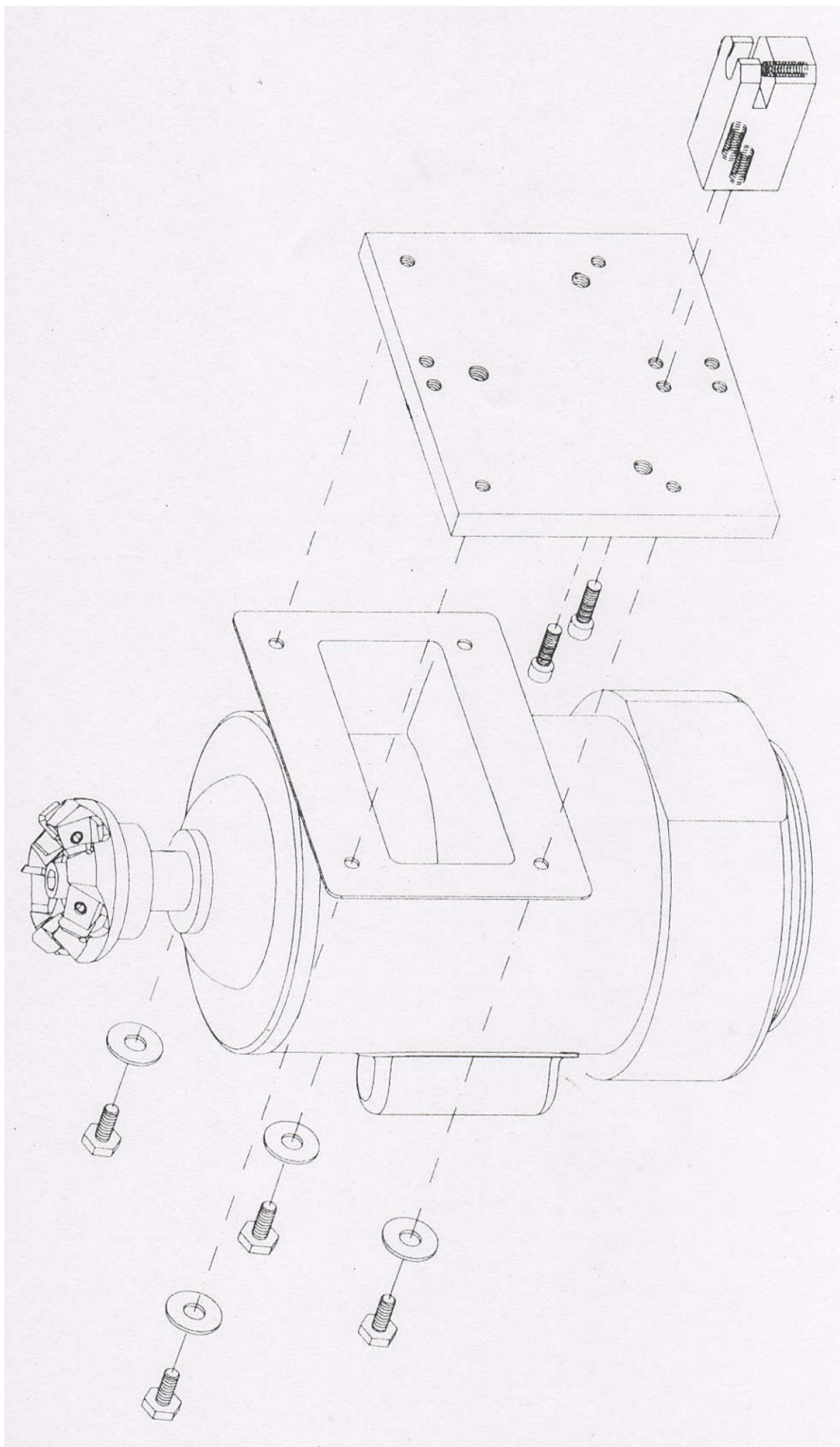
Podpis oprávněné osoby:

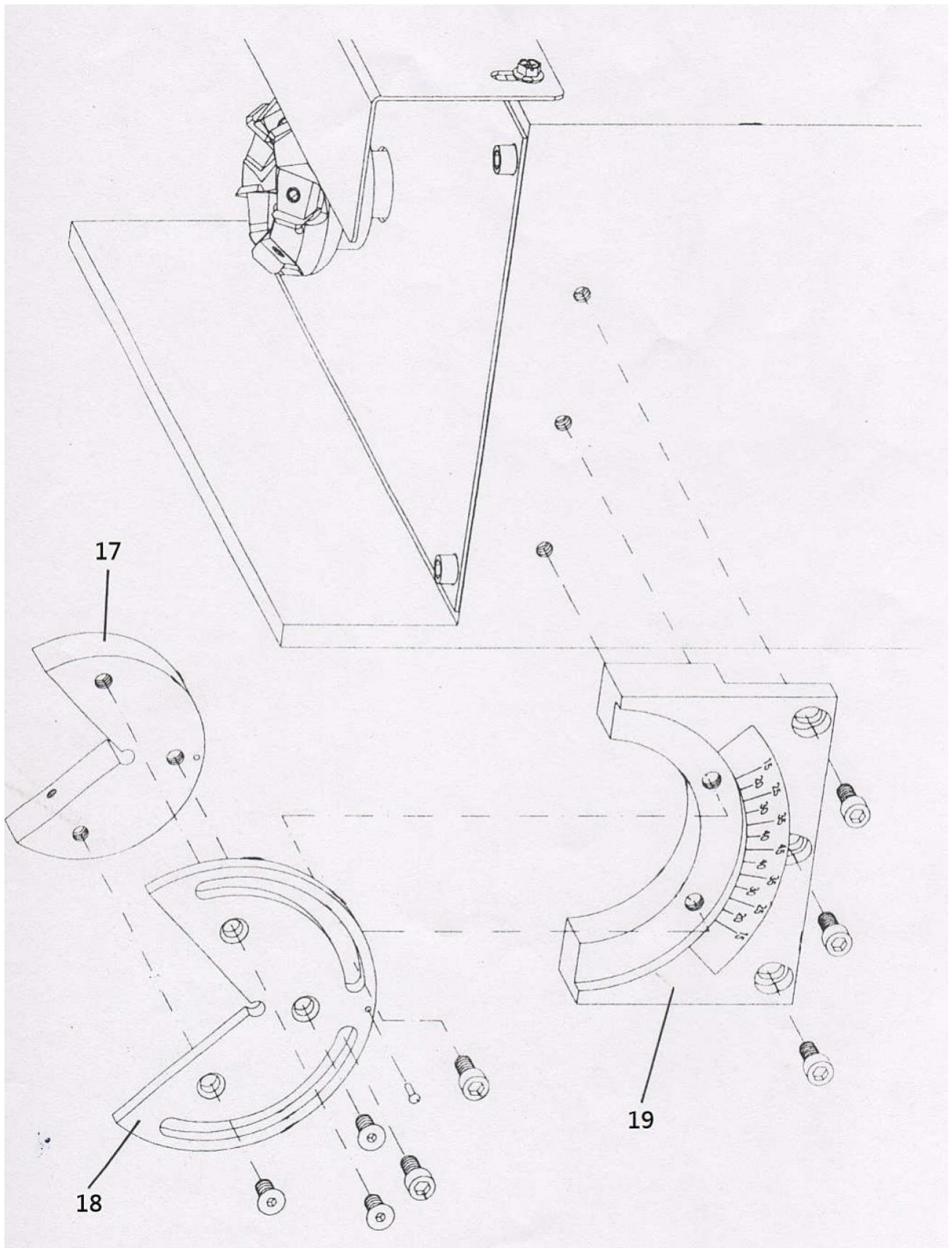


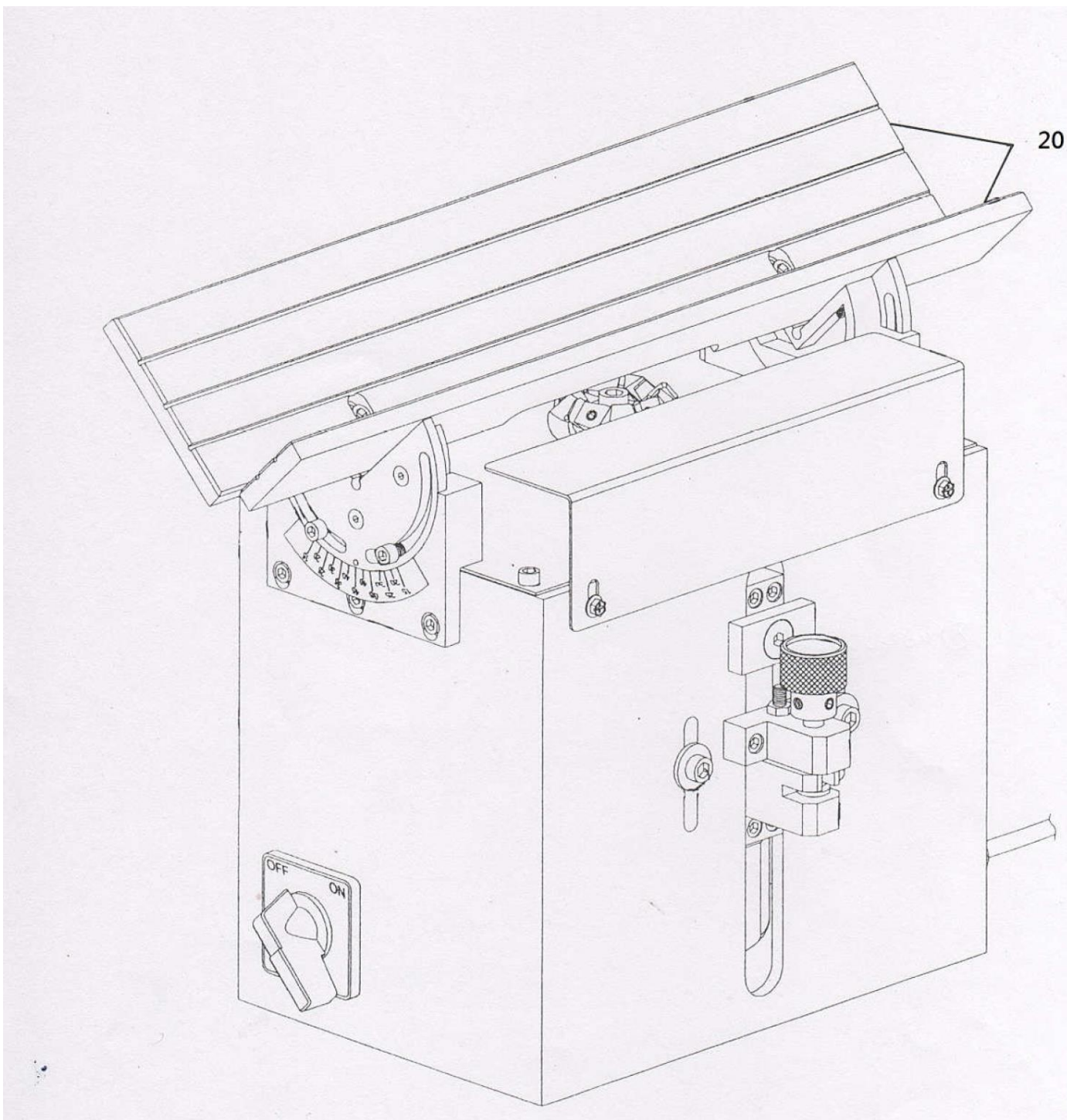
Layout of parts

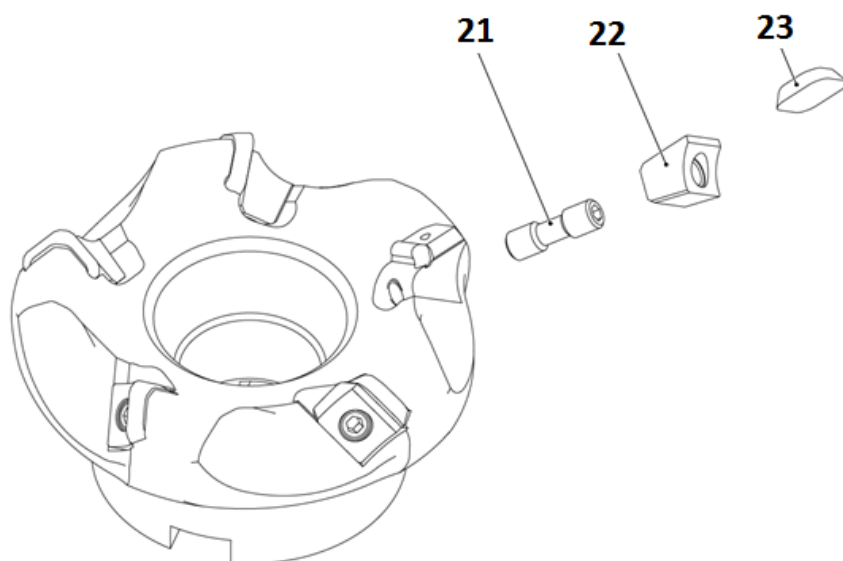












List of spare parts:

order no. 28220, order no. for spare parts – 28220_(number of position)

PART NO	DESCRIPTION	QTY	POPIS
1	MAIN BODY	1	NOSNÝ RÁM
2	MOTOR	1	MOTOR
3	MOTOR FIXED PLATE	1	DESKA MOTORU
4	GUIDE BLOCK	2	VODÍČÍ KOSTKA
5	SCREW ARBOR BASE A	1	NASTAVENÍ ÚBĚRU-A
6	SCREW ARBOR BASE B	1	NASTAVENÍ ÚBĚRU-B
7	SCREW ARBOR	1	ŠROUB NAST.ÚBĚRU
8	SCREW CAP	1	VRCH NAST.ÚBĚRU
9	COMPRESSION ADJUSTING BASE	1	VODÍTKO NAST. ÚB.
10	COMPRESSION SPRING	1	PRUŽINA NAST.ÚB.
11	SPRING SCREW	1	ŠROUB PRUŽINY
12	MILLING HEAD	1	FRÉZOVACÍ HLAVA
13	POWER SWITCH	1	SPÍNAČ
14	BLOCKING CHIP PLATE	1	KRYT
15	MOTOR BLOCKING CHIP PLATE	1	KRYT MOTORU
16	CLAMP SCREW	2	ZAJIŠŤOVACÍ ŠROUB
17	LUNE SLIDING BLOCK	2	LOŽE VOD. LIŠT - A
18	LUNE SLIDING BLOCK HOLDER	2	LOŽE VOD. LIŠT - B
19	ANGULAR COORDINATE	2	BLOK NASTÁV.ÚHLU
20	A+B PLATE	1	A+B VODÍČÍ LIŠTY
21	SCREW FOR SWELLING BLOCK	5	ŠROUBEK KLÍNU
22	SWELLING BLOCK	5	KLÍN DESTIČKY
23	INSERT	5	ŘEZNÁ DESTIČKA

Manufacturer's and Distributor's Address:

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a Member of Richtr Group
Táborská 398/22
293 01 Mladá Boleslav
Czech Republic – Europe Union
Phone: +420 326 772 001 fax: +420 326 774 279
email:nko@nko.cz

USA Distributor's Address:

BEVELER USA INC.
a Member of Richtr Group
Business Office, Workshop, Warehouse

328 14th Street
Ambridge, PA 15003

Toll Free Number: 1-800-973-1138
Phone Ambridge (PA) office: 1-412-452-2563
email:service@bevelerusa.com