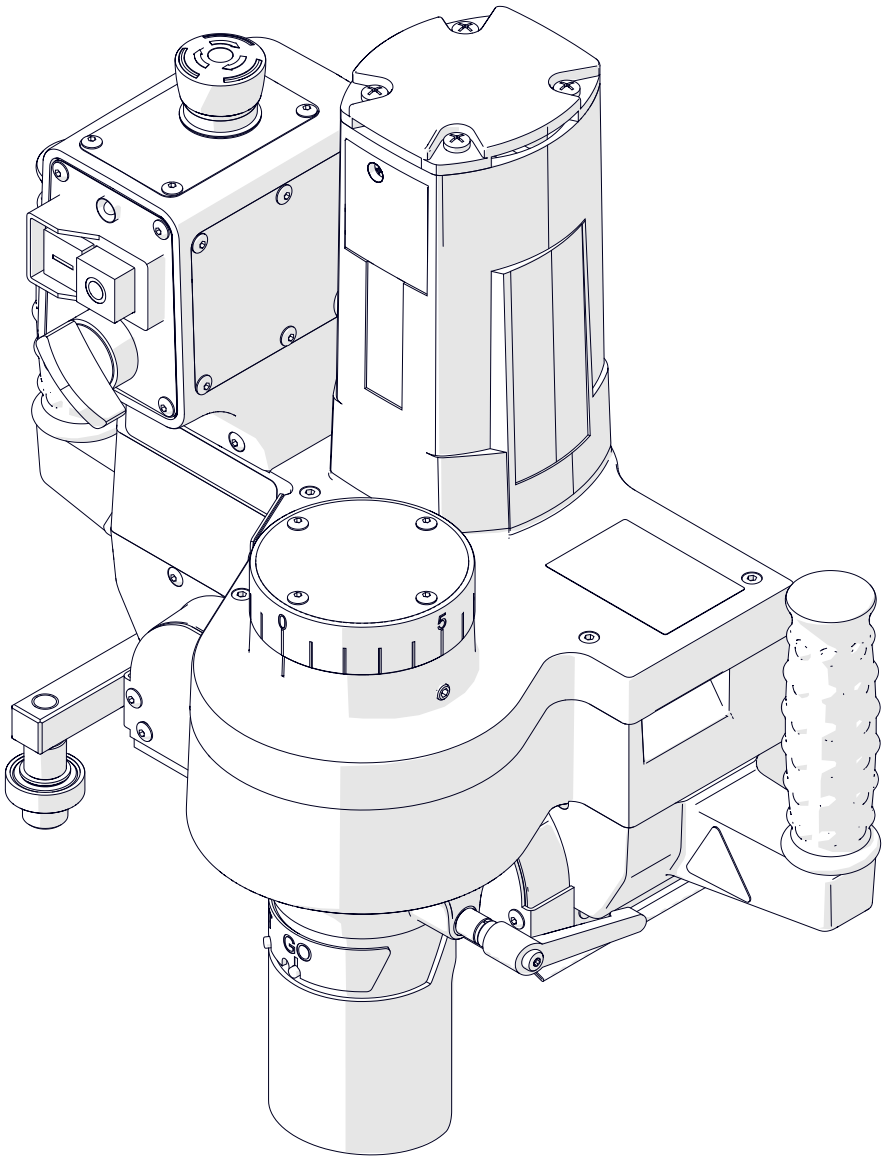
STEELBEAST®

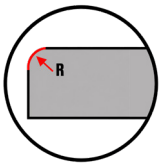
AUTO RAD

RADIUS AND BEVELLING MACHINE

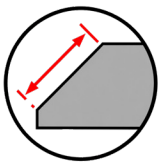
OPERATOR'S MANUAL

JEI Solutions
Built for Industry

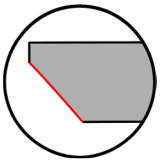




RADIUS
R2, R3, R4, R5



6 MM BEVEL
WIDTH



BOTTOM BEVELLING
(OPTIONAL)



ONLY 14 KG



1080 W MOTOR



JEI SOLUTIONS
UNIT 21
EMPIRE BUSINESS PARK,
ENTERPRISE WAY,
BURNLEY,
LANCASHIRE,
BB12 6LT

+44 1706 229490

sales@jeiuk.com

www.jeiuk.com

ISO 9001 Quality Management Systems CERTIFIED
FM 37982

OCTOBER 2026

STEELBEAST®

SAFETY INSTRUCTIONS

Read and understand this manual before using the machine. Operators must receive appropriate training in its safe use and relevant workplace health and safety procedures. Keep untrained persons away from the machine.

INTENDED USE AND WORK AREA

- Use the machine only for the applications described in this manual.
- Keep the work area clean, well lit and free from obstructions.
- Do not operate near flammable materials or in potentially explosive environments.
- Keep the machine dry. Do not expose it to rain, snow or frost.
- Ensure that the workpiece is stable before positioning the machine.

CHECKS BEFORE USE

- Check the machine, power supply, cable, plug, controls and cutting tools before each use.
- Ensure that all parts are present, genuine, correctly fitted and undamaged. Do not use the machine if any part is cracked, loose or defective.
- Check for any other condition that could affect safe operation.
- Ensure that the power supply matches the requirements shown on the machine's rating plate.
- Use only cutting tools specified in this manual. Never use blunt or damaged tools.
- Check that the milling head and cutting inserts are correctly fitted and secured.
- Remove all spanners and adjustment tools before connecting the machine to the power supply.

PERSONAL PROTECTION

- Wear eye protection, hearing protection, non-slip footwear and suitable close-fitting protective clothing.
- Do not wear loose clothing or allow anything to become caught in moving parts.
- Keep hands clear of cutting chips and moving components.
- Never remove chips with bare hands. Use the supplied chip removal tool.

SAFE OPERATION

- Operate the machine only in a horizontal position. Never operate it with the milling head pointing upwards.
- Never operate the machine without the cutter cover fitted.
- Continuously supervise the machine during operation. It may fall from the workpiece if left unattended.
- Switch off the feed before stopping the milling head. Stopping the milling head while the feed is running may damage the cutting inserts.
- Never carry the machine by its power cable or pull on the cable. This can damage the cable and create a risk of electric shock.
- If the machine is dropped, becomes wet or is damaged, stop using it immediately and ar range inspection and repair by an authorised service centre.

CUTTING TOOLS AND MAINTENANCE

- Disconnect the machine from the power supply before cleaning, maintenance, adjustments, or fitting and removing parts or cutting tools.
- When the cutting edges are worn, rotate all cutting inserts by 90° to expose fresh edges. If all edges are worn, replace the complete set with inserts specified in this manual.
- Repairs must be carried out by a service centre authorised by the supplier.

STORAGE

- When not in use, remove the machine from the work area and store it in a safe, dry place.
- Before extended storage, apply a suitable corrosion inhibitor to the steel parts.

SAFETY



Use hearing protection



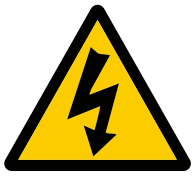
Use eye protection



Use hand protection

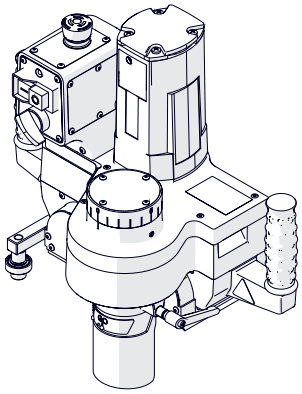


Read the Operator's Manual

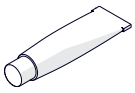


Caution! Warning of electric shock

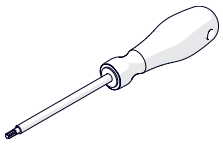
A EQUIPMENT SUPPLIED



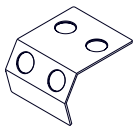
Auto Rad



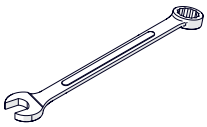
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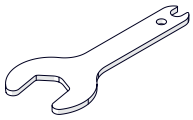
WKT-000004



NRZ-0762-0982-00-0



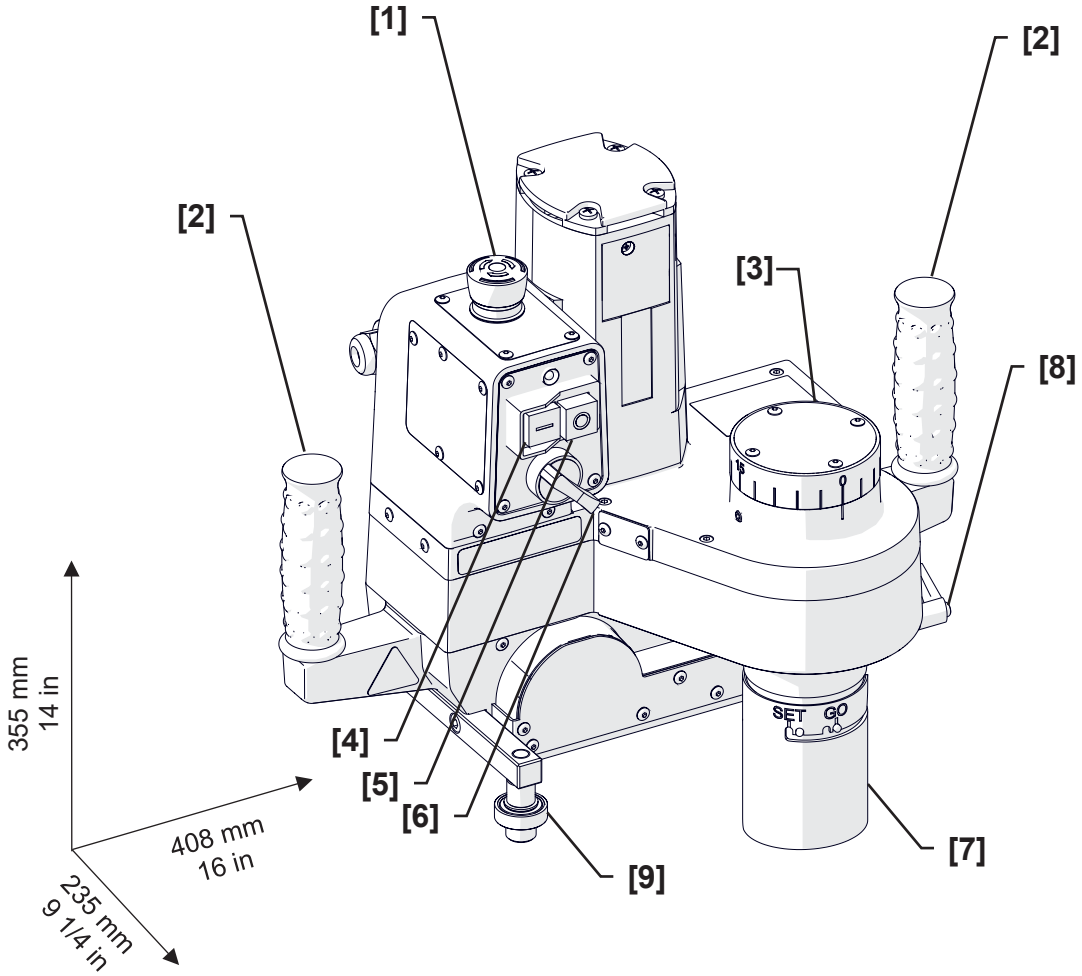
KLC-000097



KLC-0540-07-00-00-0

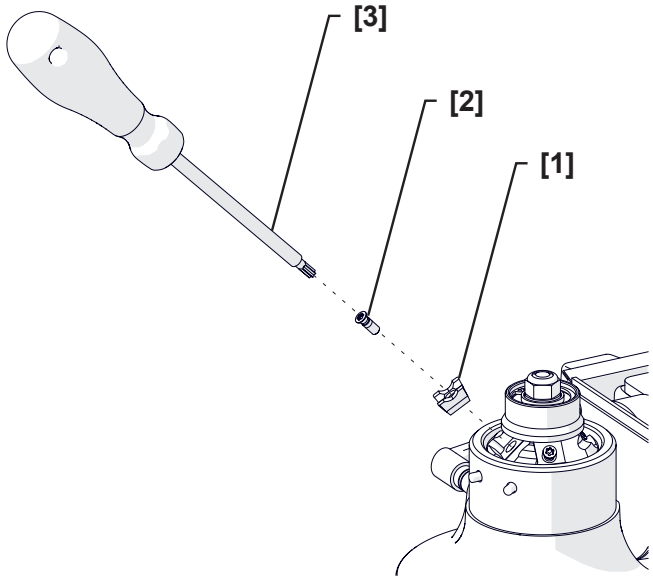
- Auto Rad - automatic radius and bevelling machine
- 22 mm combination spanner – KLC-000097
- Molykote 1000 grease, 5 g – SMR-000005
- T15 Torx screwdriver – WKT-000004
- Chip removal tool
- Special flat spanner – KLC-0540-07-00-00-0
- Box and outer carton
- Operator's manual

B EQUIPMENT SUPPLIED



1. Emergency stop switch
2. Carrying handles
3. Milling head height adjustment knob
4. Milling head start button
5. Milling head stop button
6. Feed switch
7. Cutter cover
8. Milling head height locking lever
9. Guide roller

C CUTTING INSERTS



DISCONNECT FROM POWER WHEN CHANGING INSERTS!

Fitting and replacing the cutting inserts

1. Disconnect the machine from the power supply before working on the cutting inserts.
2. Remove the cutter cover.
3. Turn the height adjustment knob to expose the milling head.
4. Use the Torx screwdriver [3] to remove the retaining screws [2] and cutting inserts [1].
5. Clean the insert seats thoroughly.
6. Fit the inserts, ensuring that the entire underside of each insert sits flat against its seat. Hold each insert firmly in position and tighten its retaining screw.

Using a fresh cutting edge

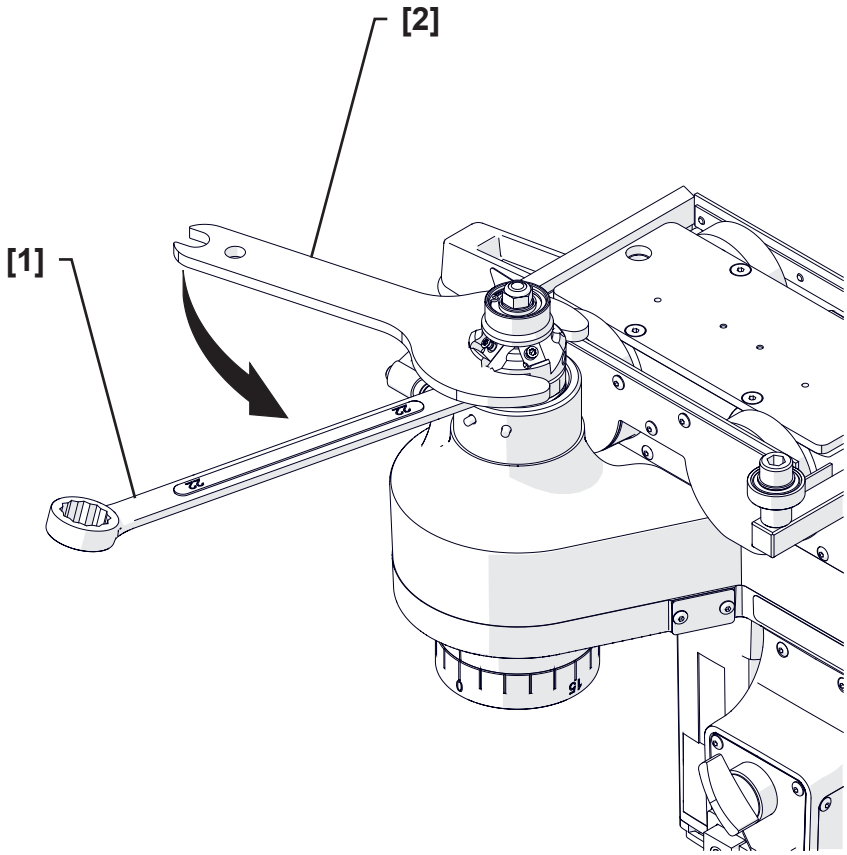
When the cutting edges are worn, remove all inserts and rotate each one by 90° to expose a fresh edge.

If all cutting edges are worn, replace the complete set with new inserts specified for this machine.

Part Number	Description
PLY-000737	Cutting insert R2 (sold 10 per set)
PLY-000738	Cutting insert R3 (sold 10 per set)
PLY-000739	Cutting insert R4 (sold 10 per set)
PLY-000740	Cutting insert R5 (sold 10 per set)
PLY-000391	Cutting insert for steel (sold 10 per set)

Bevelling inserts and accessories

D MILLING HEAD



Fitting and removing the milling head

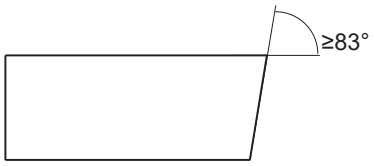
Disconnect the machine from the power supply before fitting or removing the milling head.

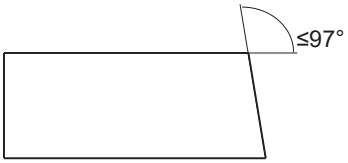
1. Remove the cutter cover.
2. Turn the height adjustment knob to expose the milling head.
3. Hold the spindle stationary using spanner [1].
4. Use spanner [2] to loosen and remove the milling head, or to tighten the replacement head.

Remove both spanners before reconnecting the machine to the power supply.

E WORKPIECE PREPARATION



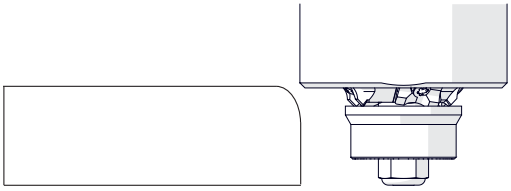




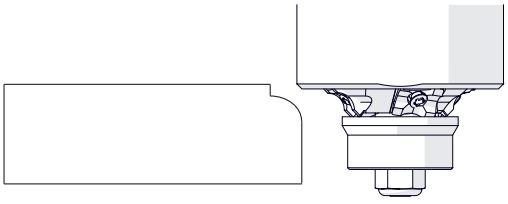
The workpiece surfaces must be smooth and should meet at 90°. The maximum permitted deviation from a right angle is ±7°, giving an acceptable range of 83° to 97°.

F MILLING HEAD HEIGHT

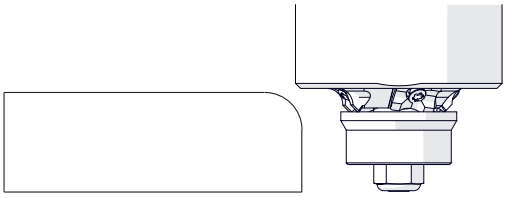
[1]



[2]



[3]



Setting the milling head height

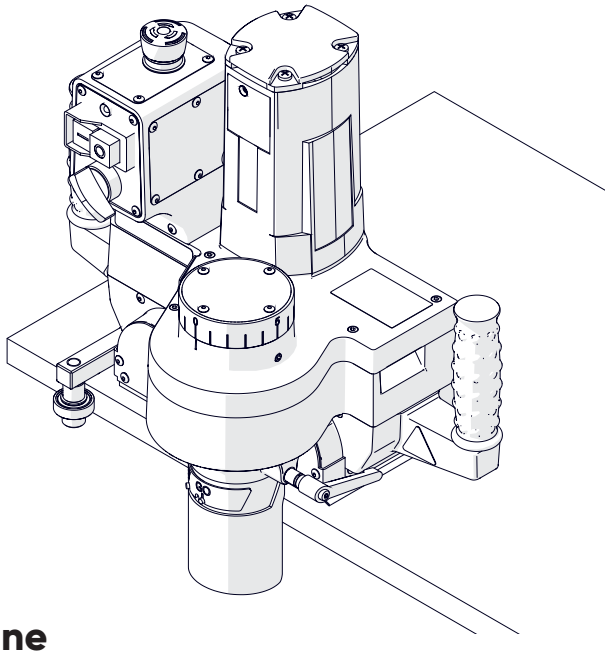
With the machine disconnected from the power supply, use the height adjustment knob to position the milling head.

[1] Incorrect setting - Incomplete radius
The milling head is set too low, leaving the radius unfinished.

[2] Incorrect setting -Excessive cutting depth
The milling head is set too high and cuts too deeply into the workpiece.

[3] Correct setting
The milling head produces a complete radius with a smooth transition between the adjoining workpiece surfaces.

G POSITIONING AND OPERATION



Positioning the machine

1. With the machine disconnected from the power supply, fit the required milling head and cutting inserts.
2. Set the cutter cover to SET, as shown in diagram H.
3. Ensure that the workpiece is stable.
4. Position the machine at the left-hand side of the workpiece, with the guide roller and cutter cover resting against the edge.
5. Ensure that the cutting edge of the insert is above the workpiece edge.
6. Move the cutter cover to GO before starting the machine.

Starting and operating

1. Connect the machine to the power supply.
2. Press the milling head start button.
3. Switch on the feed. The machine will travel to the right.

The machine must remain horizontal during operation. Never operate it without the cutter cover fitted.
Continuously supervise the machine throughout operation, as it may fall from the workpiece.

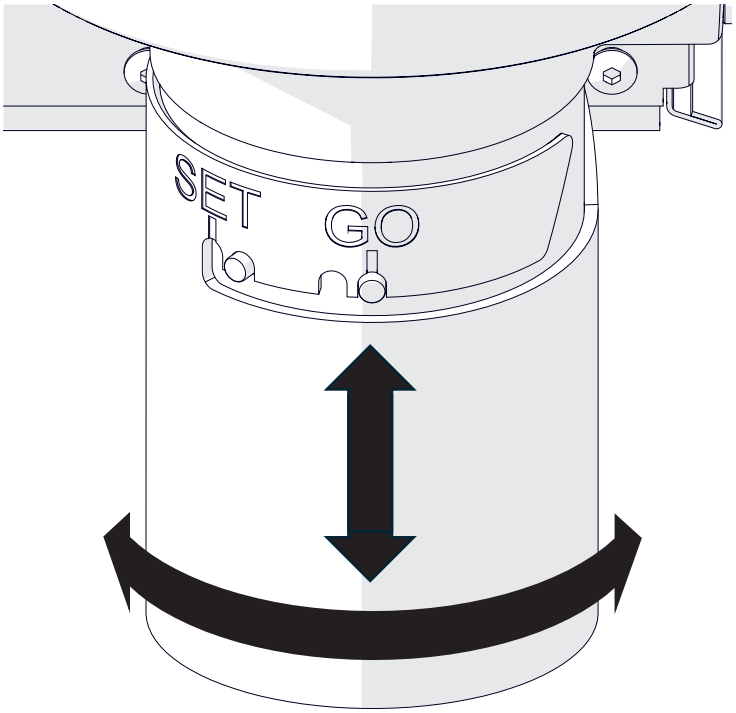
Stopping at the end of the workpiece

When the machine reaches the end of the workpiece, it stops travelling forwards and moves back slightly.

1. Switch off the feed.
2. Press the milling head stop button.
3. Remove the machine from the workpiece.

Do not stop the milling head while the feed is running. Doing so may damage the cutting inserts.

H CUTTER COVER POSITIONS



Setting the cutter cover

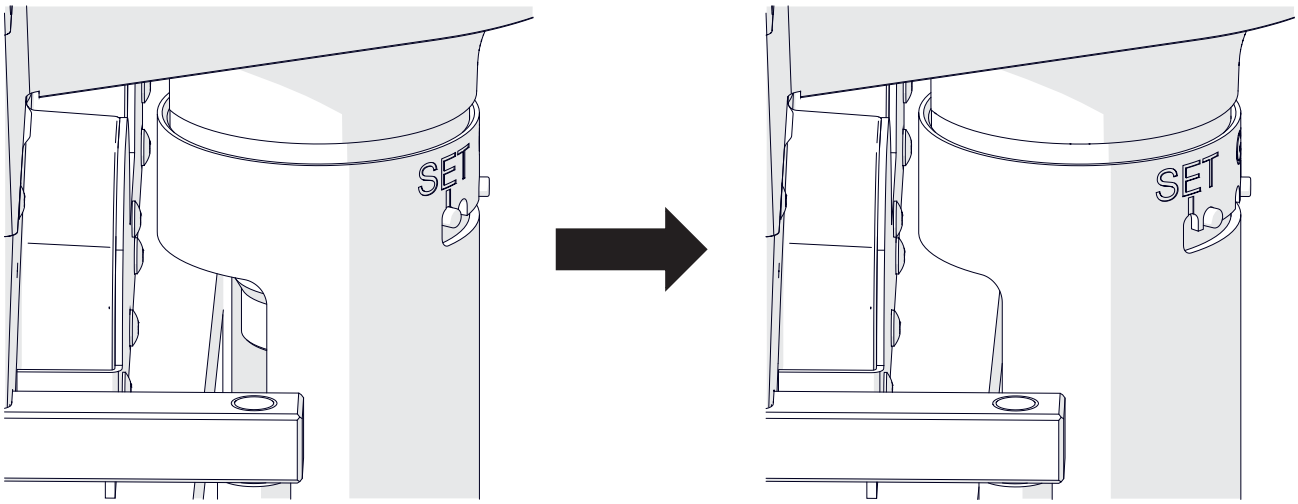
SET – Positioning

Set the cutter cover to SET before positioning the machine on the workpiece.

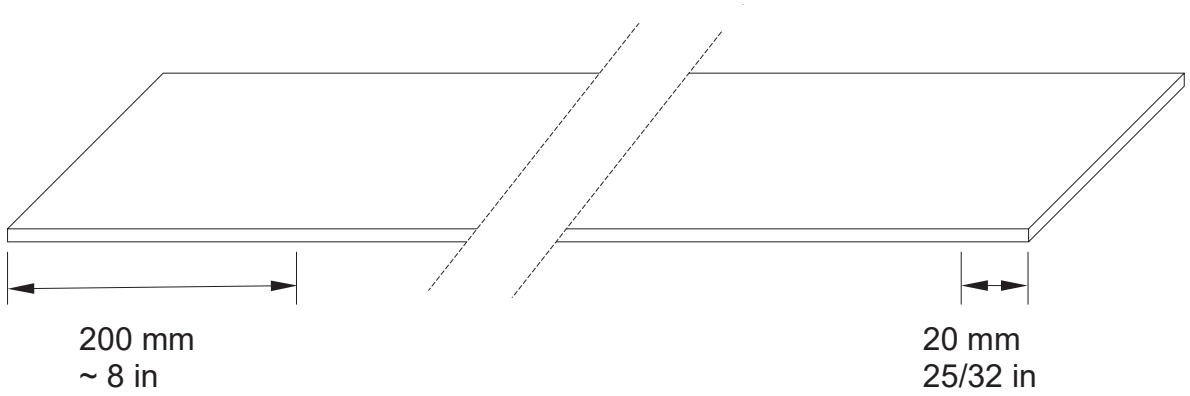
GO – Machining

Once the machine is correctly positioned, move the cutter cover to GO before starting the milling head and feed.

Never operate the machine without the cutter cover fitted.

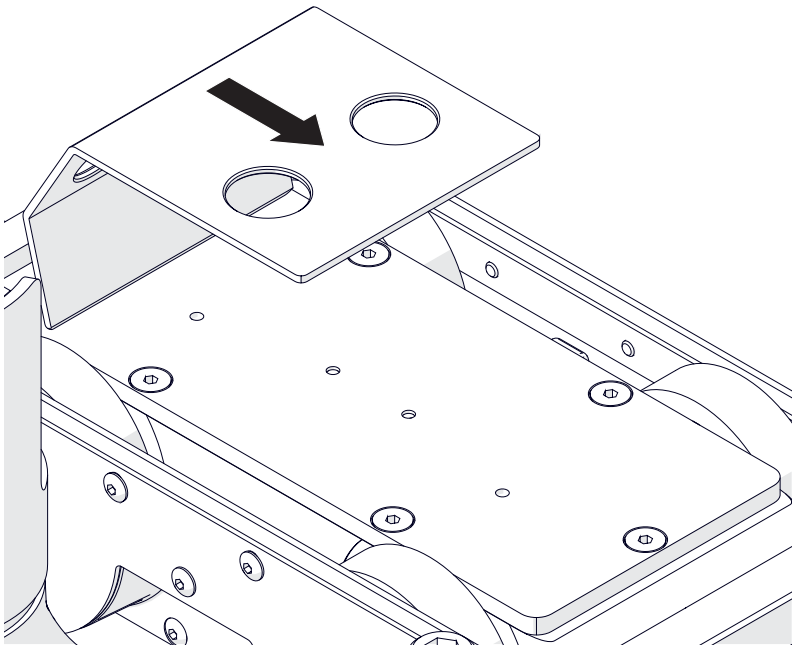


I WORKING RANGE



Machining begins 200 mm from the leading edge of the workpiece and ends 20 mm before the trailing edge, measured in the direction of travel.

J CHIP REMOVAL



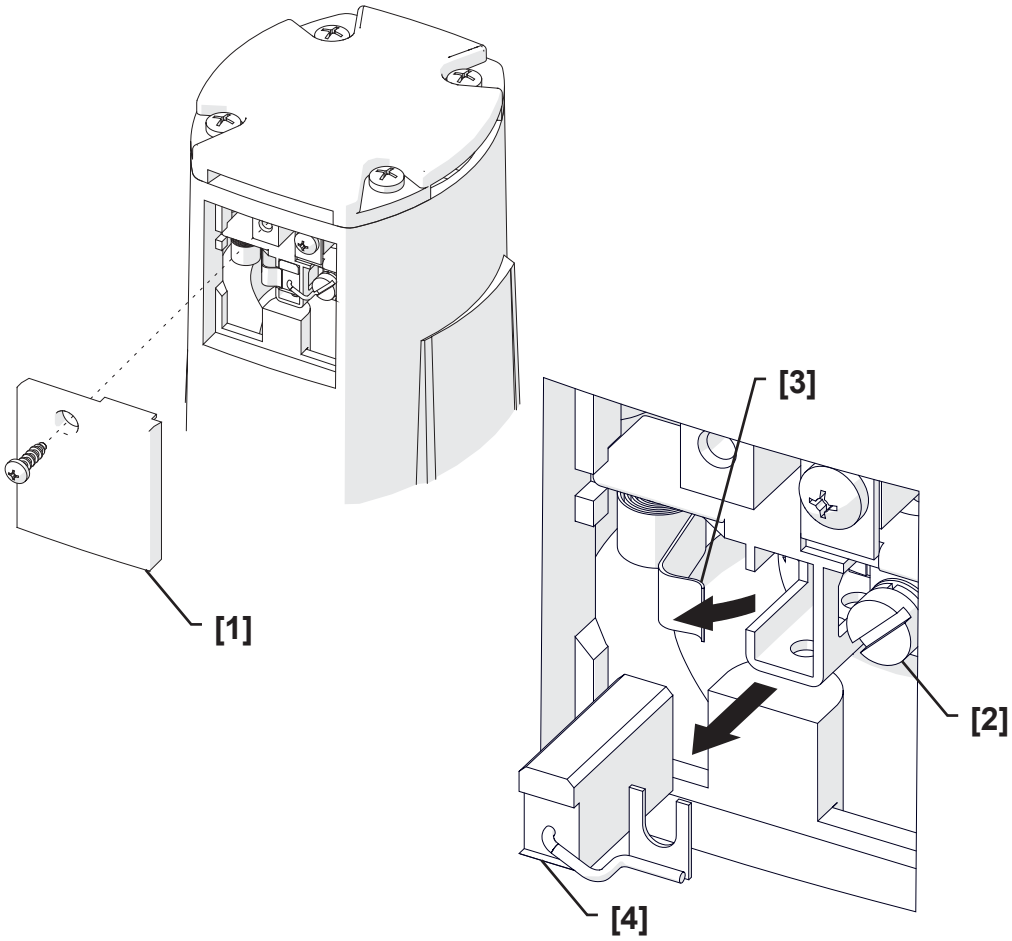
Removing chips

Disconnect the machine from the power supply before cleaning.

Use the supplied chip removal tool to clear chips from the underside of the machine.

Do not remove chips with bare hands.

K MOTOR BRUSHES



Check the motor brushes every 100 operating hours.

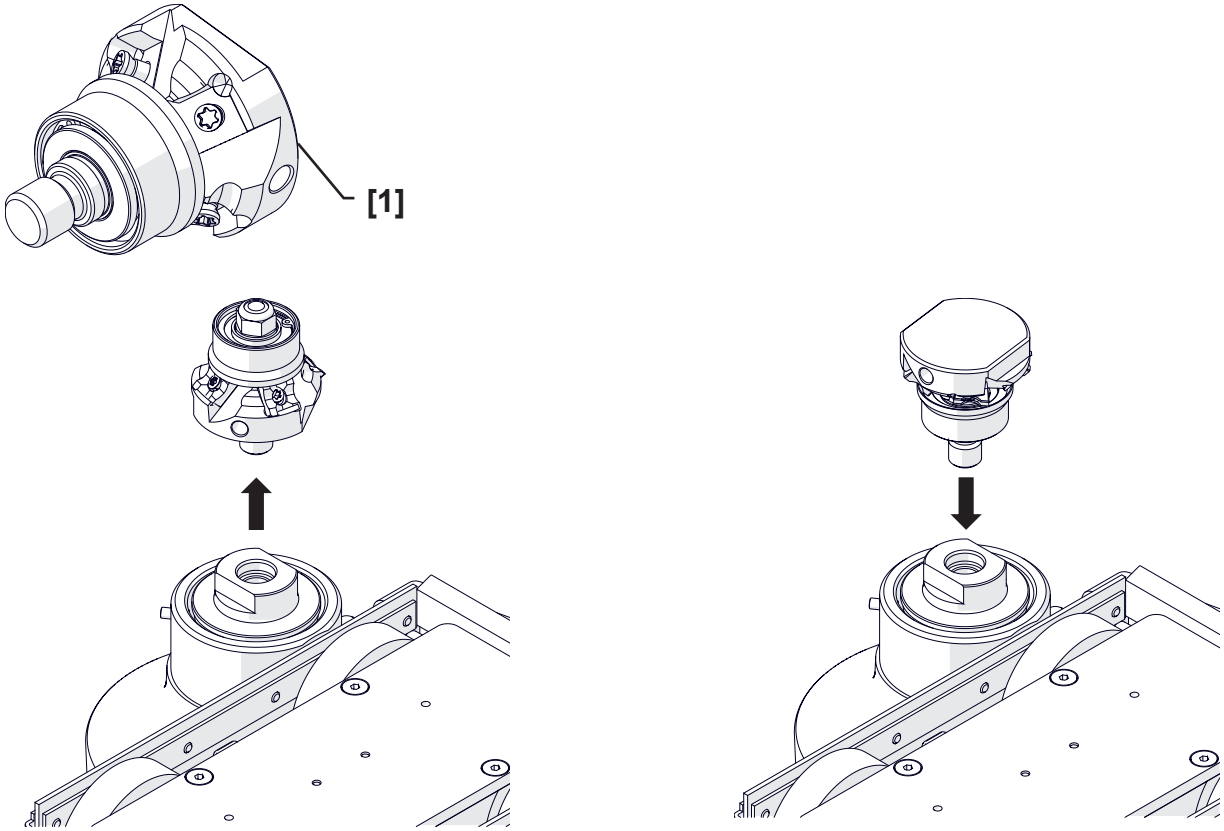
1. Disconnect the machine from the power supply.
2. Remove the access cover [1].
3. Loosen the screw [2], lift the spring [3] and remove the brush [4].
4. Check the brush length. If either brush is shorter than 5 mm, replace both brushes.
5. Reassemble in the reverse order and refit the access cover.

After fitting new brushes, run the motor without load for 20 minutes.

Need spare brushes?

Contact us on 01706 229 490 or email sales@jeisolutions.co.uk

L OPTIONAL MILLING HEAD



Optional CCW milling head

Part number: **GLW-0762-0075-00-0**

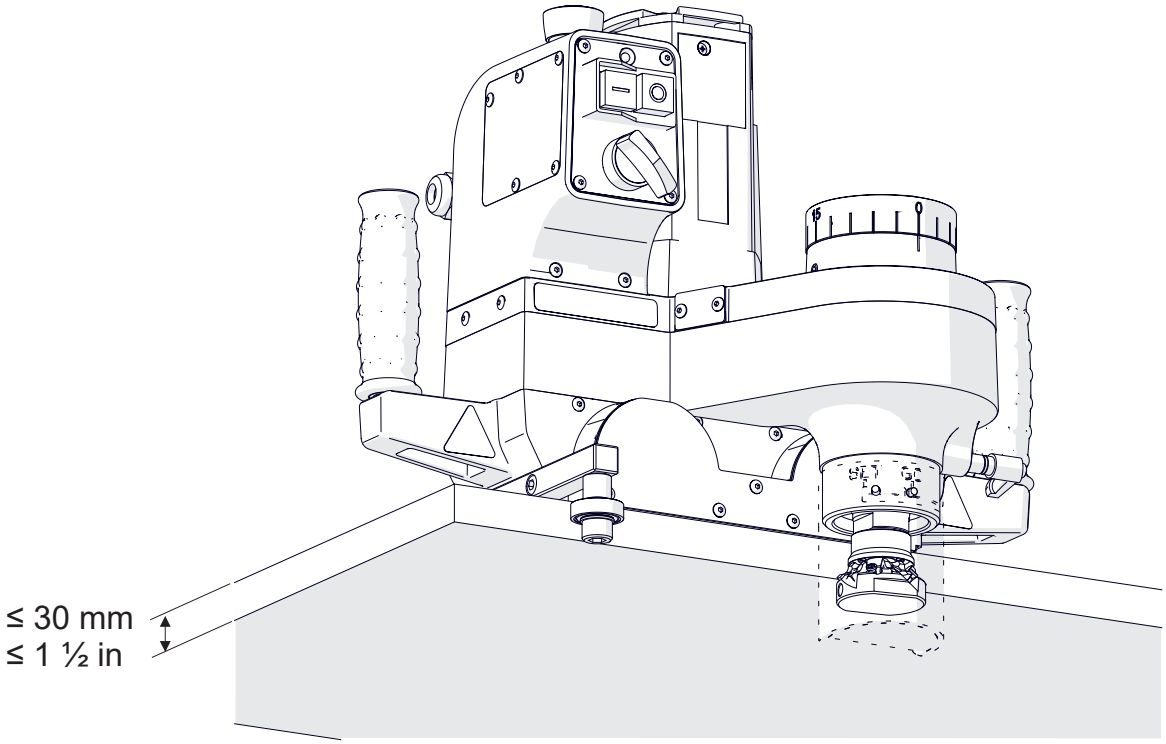
The optional counter-clockwise (CCW) milling head enables the machine to machine the underside edge of the workpiece.

Fitting the CCW milling head

Disconnect the machine from the power supply.

Remove the standard milling head and replace it with the optional CCW milling head, following the fitting and removal procedure shown in diagram D (page 6).

M MACHINING THE UNDERSIDE EDGE



With the optional CCW milling head fitted, the machine can machine the underside edge while remaining on top of the workpiece.

The maximum workpiece thickness for this application is 30 mm.

N TECHNICAL SPECIFICATIONS

Voltage	1~ 220-240 V, 50-60 Hz
Power	1080 W
Rotational speed without load	5900 rpm
Rotational speed with load	3950 rpm
Protection level	IP 20
Protection class	I
Maximum bevel width (b)	6 mm
Minimum workpiece thickness	8 mm
Minimum workpiece width	150 mm
Edge radius	2 mm, 3 mm, 4 mm, 5 mm
Noise level	More than 70 dB
Required ambient tempera-ture	0-40°C
Weight	14 kg

STEELBEAST®

EC DECLARATION OF CONFORMITY

We **JEI Cutting and Drilling Solutions Ltd**
Unit 21 Empire Business Park, Enterprise Way, Burnley, Lancashire. BB12 6LT, UK

Declare with full responsibility that product:

AUTO RAD Radius and Bevelling Machine

which the declaration applies to is in accordance with the following standard(s) placed below:

•PN-EN ISO 12100:2012
•PN-EN 60204-1:2010
•PN-EN ISO 13857:2010
•PN-EN ISO 13849:2016
•PN-EN 349+A1:2010

and satisfies safety regulations of guidelines:

2006/42/EC
•2014/30/EU
•2011/65/EU
•2012/19/EU

BURNLEY, 01/01/2026

Managing Director

WARRANTY

JEI Cutting and Drilling Solutions Ltd warrants the **AUTO RAD Radius and Bevelling Machine** to be free from defects in materials and workmanship under normal use for a period of 1 year (12 months) from the date of purchase.

This warranty does not cover tools and accessories as well as damage or wear that arise from misuse, accident, tem-pering, or any other causes not related to de-fects in workmanship or material.

Machine name .....
Serial number .....
Date of sale .....
Signature and stamp of the seller .....

REGISTER YOUR WARRANTY TODAY BY SCANNING THE QR CODE BELOW:

+44 1706 229490
sales@jeisolutions.co.uk
www.jeiuk.com

ENVIRONMENTAL PROTECTION

In accordance with the European Di-rective 2012/19/EU, this device is marked with the symbol of the crossed-out waste bin. This marking means that the equipment must not be disposed of with other household waste after the service life.
The user must return the product to a collection point for used electrical and electronic equipment. The collectors of used equipment, including local collection points, shops and municipal units, create an appropriate system for returning such equipment. Correct handling of used electrical and electronic equipment helps in avoiding damage to health and the environment, which may result from the presence of dangerous components and incorrect storage and pro-cessing of such equipment.