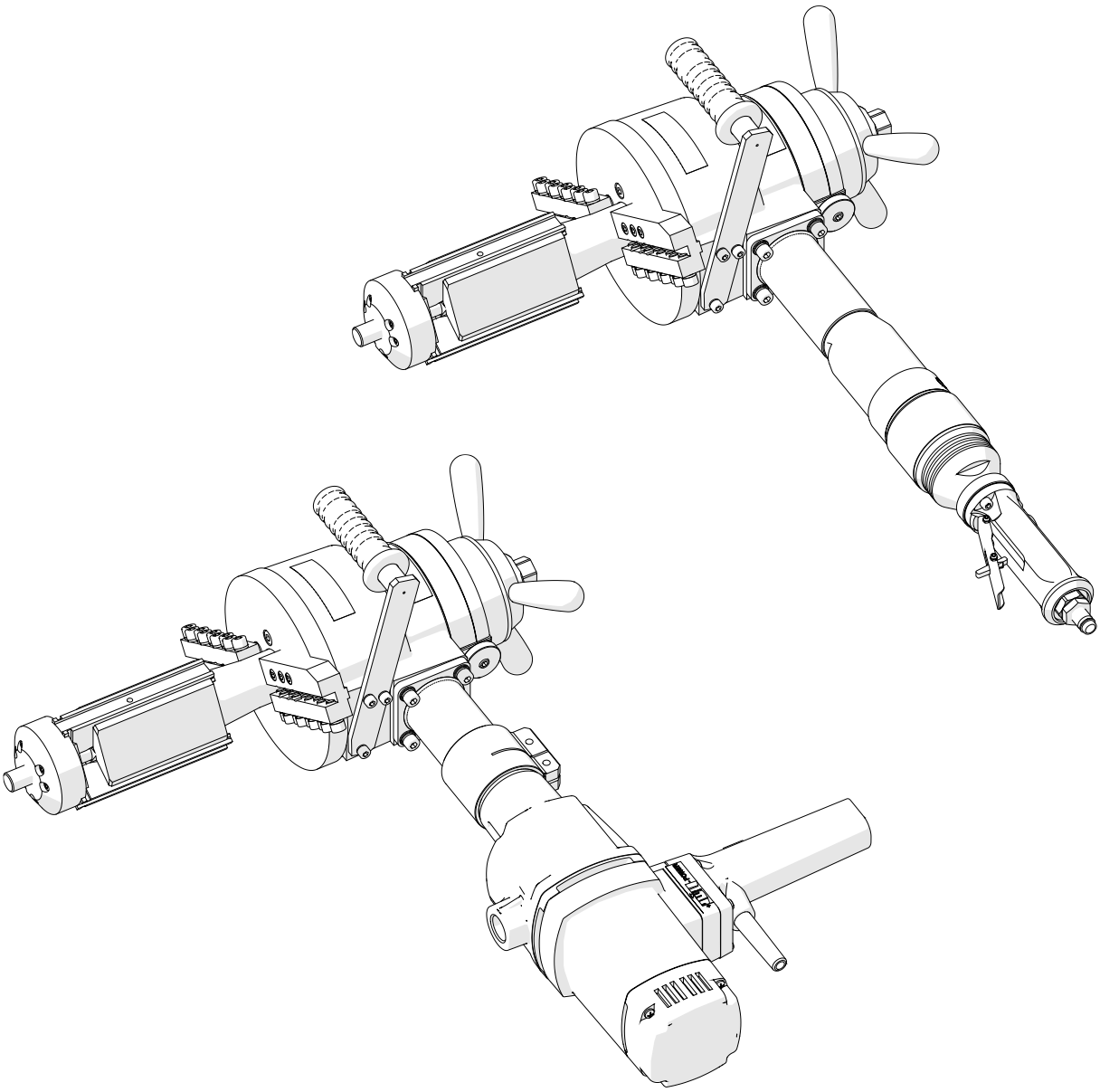
OPERATOR'S MANUAL

PIPE BEVELLING MACHINE

PRO 10 PB (PBE)



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1. GENERAL INFORMATION

1.1. Application

The PRO 10 PB (PBE) is a pipe bevelling machine designed to mill pipes made of carbon and stainless steel, aluminum alloys, and copper-nickels. Depending on the tool bit used, the machine allows external and internal bevelling, J-bevelling, internal calibration, and facing pipes of inner diameters of 84-269 mm (3 5/16-10 19/32″). You can install up to three tool bits at the same time.

An optional small expanding mandrel allows you to bevel pipes of inner diameters from 38 mm to 86 mm (1 1/2-3 25/64″). An extension set allows you to bevel pipes of diameters from 192 mm to 349 mm (7 9/16-13 47/64″). Attachments allow you to face pipe flanges of diameters from 90 to 508 mm (3 35/64-20″) and to bevel oval pipes from 126 mm to 296 mm (4 61/64-11 21/32″).

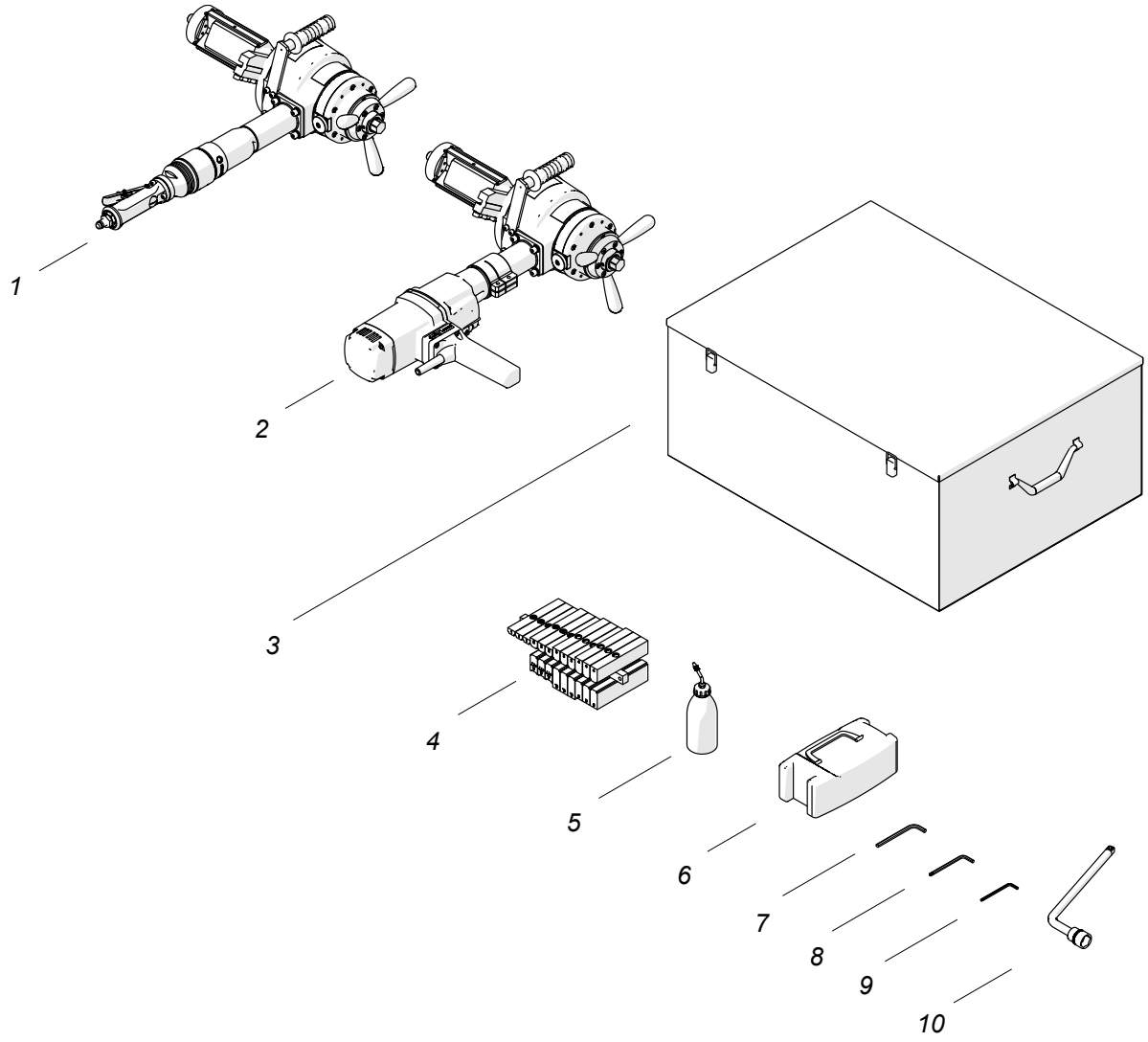
The machine is designed for professional use only.

1.2. Technical data

	PRO 10 PB	**PRO 10 PBE**
Pressure	0.6 MPa (87 psi)	-
Voltage	-	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Connection	CEJN 410 DN 10.4 R 1/2″ BSPT fitting for quick coupling	Electrical plug
Air consumption	1750 l/min (62 CFM)	-
Maximum power	1800 W	1800 W
Pipe inner diameter	84-269 mm (3 15/16-10 19/32″)	84-269 mm (3 15/16-10 19/32″)
Maximum pipe wall thickness	15 mm (19/32″)	15 mm (19/32″)
Rotational speed without load	17 rpm	-
Nominal rotational speed	9 rpm	12-29 rpm (gear I) 41-96 rpm (gear II)
Protection class	-	II
Required ambient temperature	0-40°C (34-104°F)	0-40°C (34-104°F)
Noise level	More than 70 dB	Less than 70 dB
Weight (with motor)	35 kg (77 lbs)	38 kg (84 lbs)

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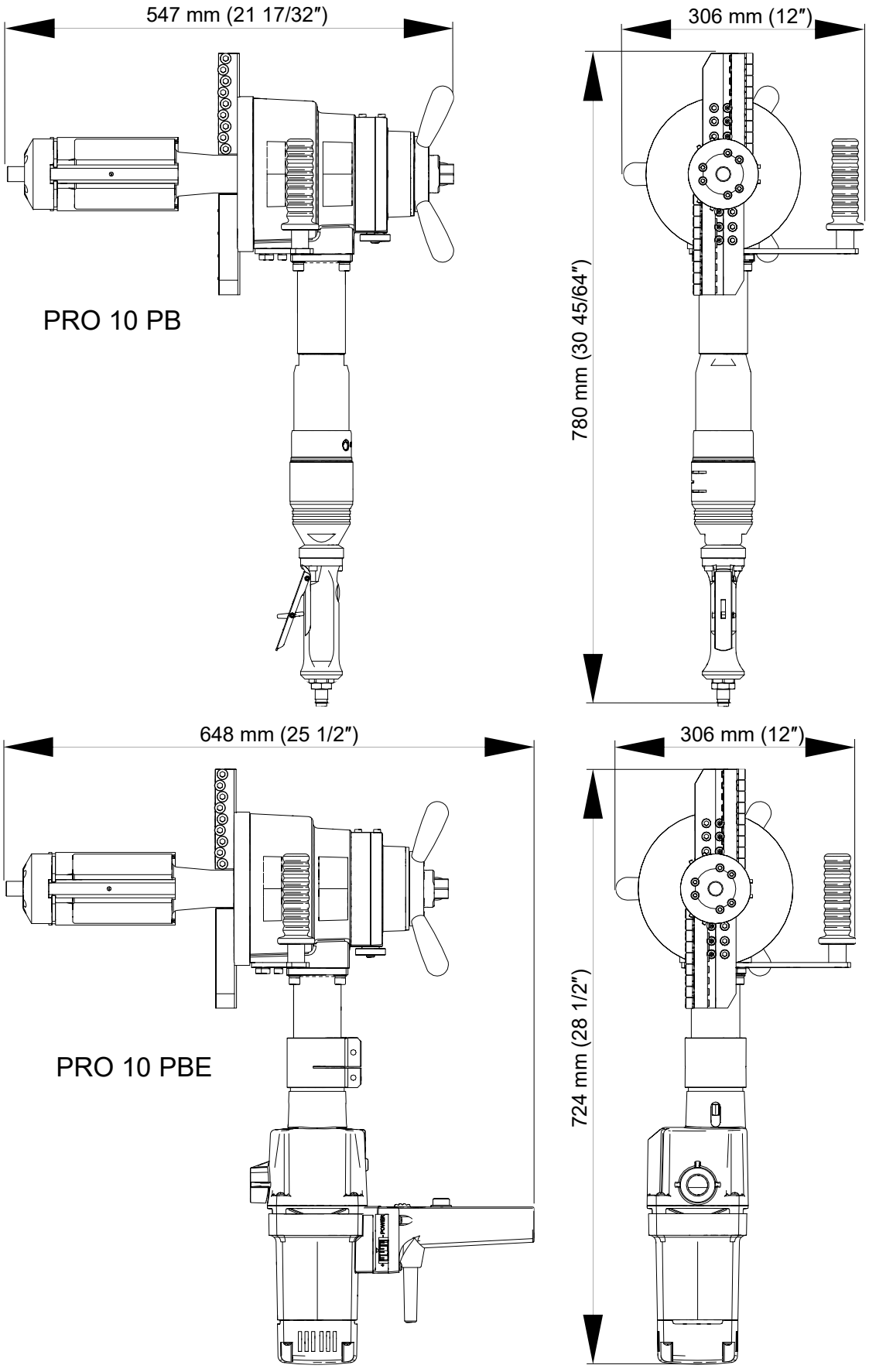
1.3. Equipment included



		PRO 10 PB	PRO 10 PBE
1	Bevelling machine with air motor (without tool bits)	1 unit	-
2	Bevelling machine with electric motor (without tool bits)	-	1 unit
3	Metal box	1 unit	1 unit
4	Jaw blocks (number 1, 2, 3, 4, 5, 6) and adapter	3 sets	3 sets
5	Coolant container	1 unit	1 unit
6	Tool container	1 unit	1 unit
7	6 mm hex wrench	1 unit	1 unit
8	5 mm hex wrench with ball	1 unit	1 unit
9	4 mm hex wrench with ball	1 unit	1 unit
10	24 mm socket wrench with handle	1 unit	1 unit
-	Operator's Manual	1 unit	1 unit

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1.4. Dimensions



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1.5. Design

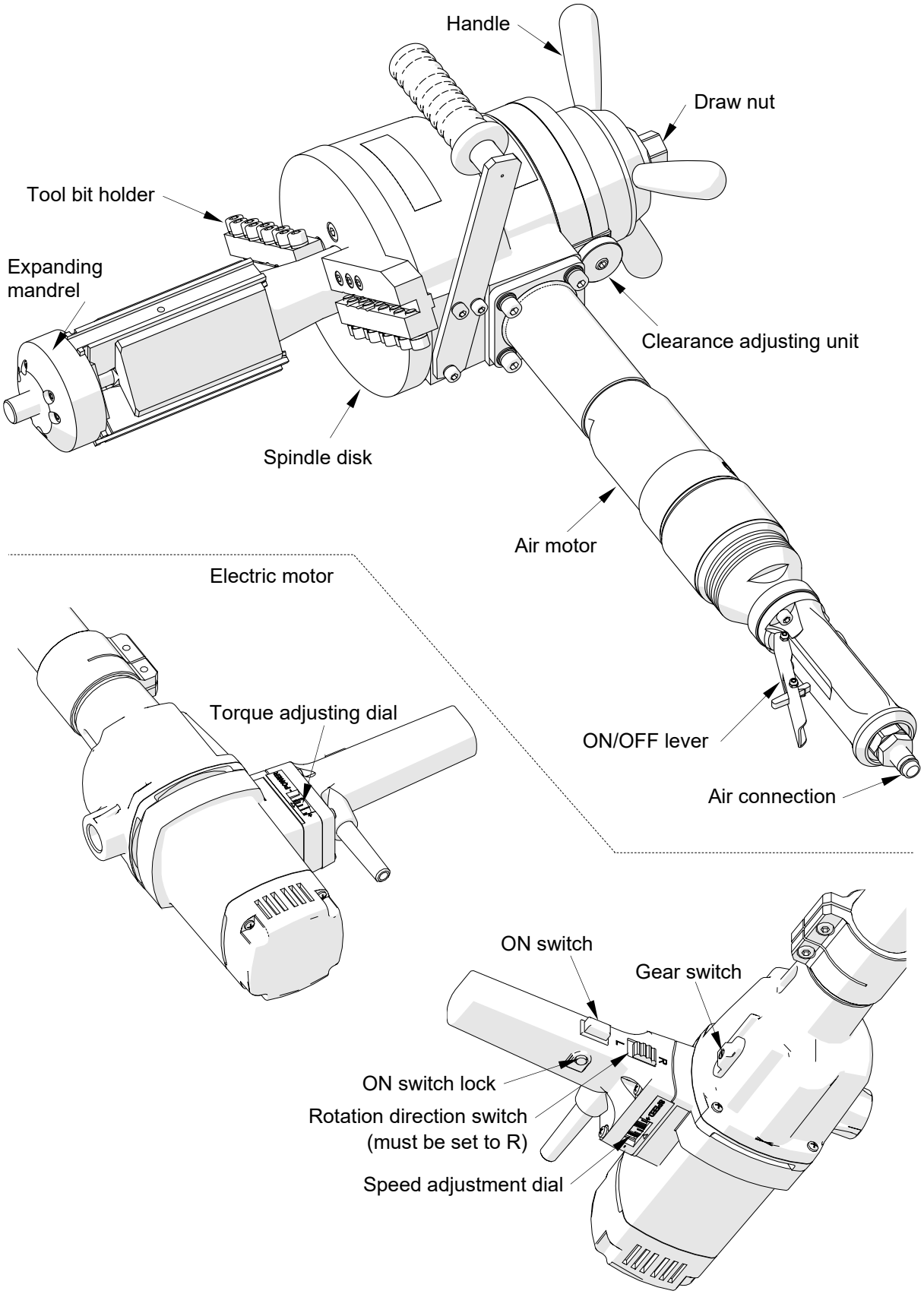


Fig. 1. View of the PRO 10 PB and of the PRO 10 PBE electric motor

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2. SAFETY PRECAUTIONS

1. Before use, read this Operator's Manual and complete a training in occupational safety and health.
2. Use only in applications specified in this Operator's Manual.
3. Make sure that the machine has all parts and they are genuine and not damaged.
4. Make sure that the specifications of the air (power) source are the same as those specified on the rating plate.
5. Supply the machine with air motor only with clean and lubricated air. Make sure that the air source has an air preparation unit that contains a filter, regulator, and lubricator.
6. Do not pull the hose (cord). This can cause damage and serious injury.
7. Keep untrained bystanders away from the machine.
8. Before each use, ensure the correct condition of the machine, air (power) source, supply hose (power cord), quick coupling (plug), control parts, and tools.
9. Before each use, make sure that no part is cracked or loose. Make sure to maintain correct conditions that can have an effect on the operation of the machine.
10. Avoid accidental starts. Do not put the machine so that the motor will start. Do not carry the machine with air motor by holding the ON/OFF lever.
11. Keep the machine dry. Do not expose the machine to rain, snow, or frost.
12. Keep the work area well-lit, clean, and free of obstacles.
13. Do not use near flammable materials or in explosive environments.
14. Attach the pipe so that it will not fall or roll.
15. Use only tools specified in this Operator's Manual.
16. Do not use tools that are dull or damaged.
17. Make sure that the tool is correctly attached. Attach each tool bit with two screws. Remove wrenches from the work area before you connect the machine to the air (power) source.
18. Use eye and ear protection, protective footwear, and protective clothing. Do not use loose clothing.
19. Use an electric motor only after you set the rotation direction switch to 'R'. Using left rotation (switch set to 'L') can damage the machine.
20. Do not touch chips or moving parts. Do not let anything catch in moving parts.

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21. After each use, clean the machine with a dry cotton cloth and no chemical agents. Do not remove chips with bare hands.
22. Unplug the supply hose (cord) before you do maintenance or install/remove parts.
23. Repair only in a service center appointed by the seller.
24. If the machine falls, is wet, or has any damage, stop the work and immediately send the machine to the service center for check and repair.
25. Do not leave the machine when it operates.
26. If you are not going to use the machine, remove the tools from the holders. Then, remove the machine from the work area and keep it in a safe and dry place.
27. If you are not going to use the machine for an extended period, put anti-corrosion material on the steel parts.

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3. SYMBOLS

Before using the machine, familiarise yourself with the following symbols:



Be careful when you are near moving parts of the machine



Refer to the operator's manual



Use ear protection



Use eye protection

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4. STARTUP AND OPERATION

4.1. Installing the jaw blocks, adapters, tool holders, and tool bits

Use the table to select jaw blocks and adapters for the diameter of the pipe.

Pipe inner diameter		Jaw block number	Adapter
[mm]	[inch]		
84-100	3 5/16-3 15/16	-	-
99-115	3 57/64-4 17/32	1	-
115-131	4 17/32-5 5/32	2	-
130-146	5 1/8-5 3/4	3	-
146-162	5 3/4-6 3/8	4	-
161-177	6 11/32-6 31/32	5	-
176-192	6 59/64-7 9/16	6	-
192-208	7 9/16-8 3/16	2	+
207-223	8 5/32-8 25/32	3	+
223-239	8 25/32-9 13/32	4	+
238-254	9 3/8-10	5	+
253-269	9 61/64-10 19/32	6	+

Use the 5 mm hex wrench to attach the adapters (*1*, Fig. 2) and jaw blocks (*2*) to the expanding mandrel.

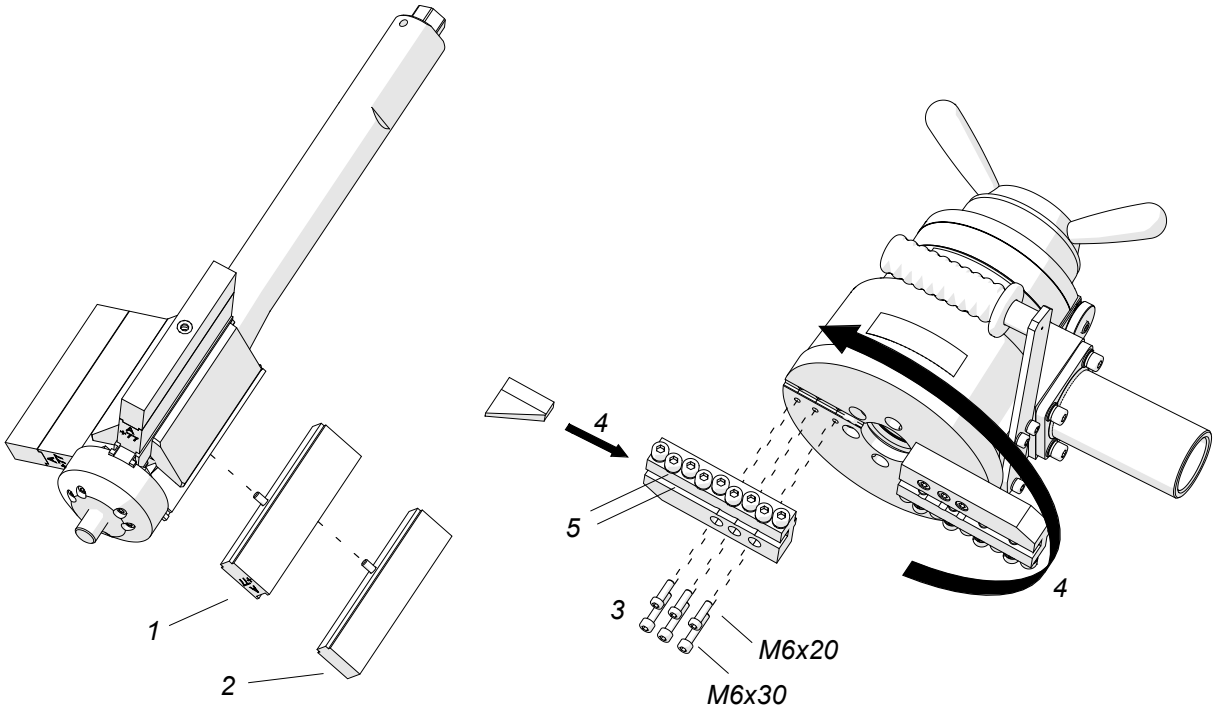


Fig. 2. Installing the jaw blocks, adapters, tool holders, and tool bits

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Use the same 5 mm hex wrench and six screws to attach the tool holders to the spindle disk (*3*). Then, select up to two tool bits suitable to planned use and put them in the holders. Point the blades in the rotation direction (*4*). Use the 4 mm hex wrench and two of the screws (*5*) to attach each tool bit. Make sure that the pressing surfaces of the screws are in full contact with the tool bits.

4.2. Installing (removing) the mandrel and adjusting the clearance

Loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3), and put the mandrel into the machine (*2*). Make sure that tool bits installed are not in contact with the mandrel. Next, turn the handles to the right (*3*) by at least 10 turns until the mandrel engages with the machine fully. Tighten the set screw (*4*) and check if you can easily turn the handles in both directions. If the screw is too tight, loosen it lightly. Finally, tighten the lock nut (*5*).

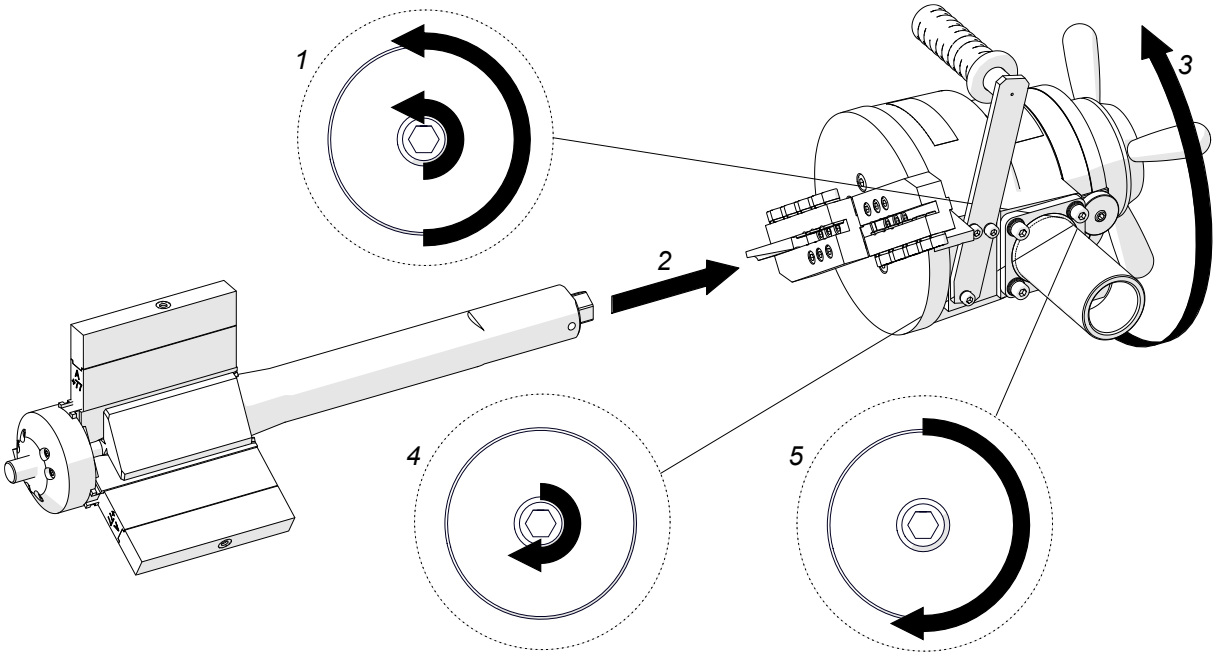


Fig. 3. Installing the mandrel into the machine

If the mandrel becomes loose causing vibrations of the tool bits during machining, do the above actions without removing the mandrel from the machine.

To remove the mandrel, loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3) by at least one turn. Then, turn the handles to the left to remove the mandrel.

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4.3. Installing the motor

When you use the air motor, put it into the machine (*1*, Fig. 4) so that the arbor is in the socket (*2*). Then, turn the motor to the left (*3*) to tighten it.

To attach the electric motor, put and press the MT3 arbor into the motor (*4*). Put the clamping ring (*5*) onto the motor and put the motor into the machine (*6*) so that the arbor is in the socket (*2*). Next, use the 6 mm hex wrench to tighten the clamping ring (*7*). Finally, set the rotation direction switch to R as shown in Fig. 1.

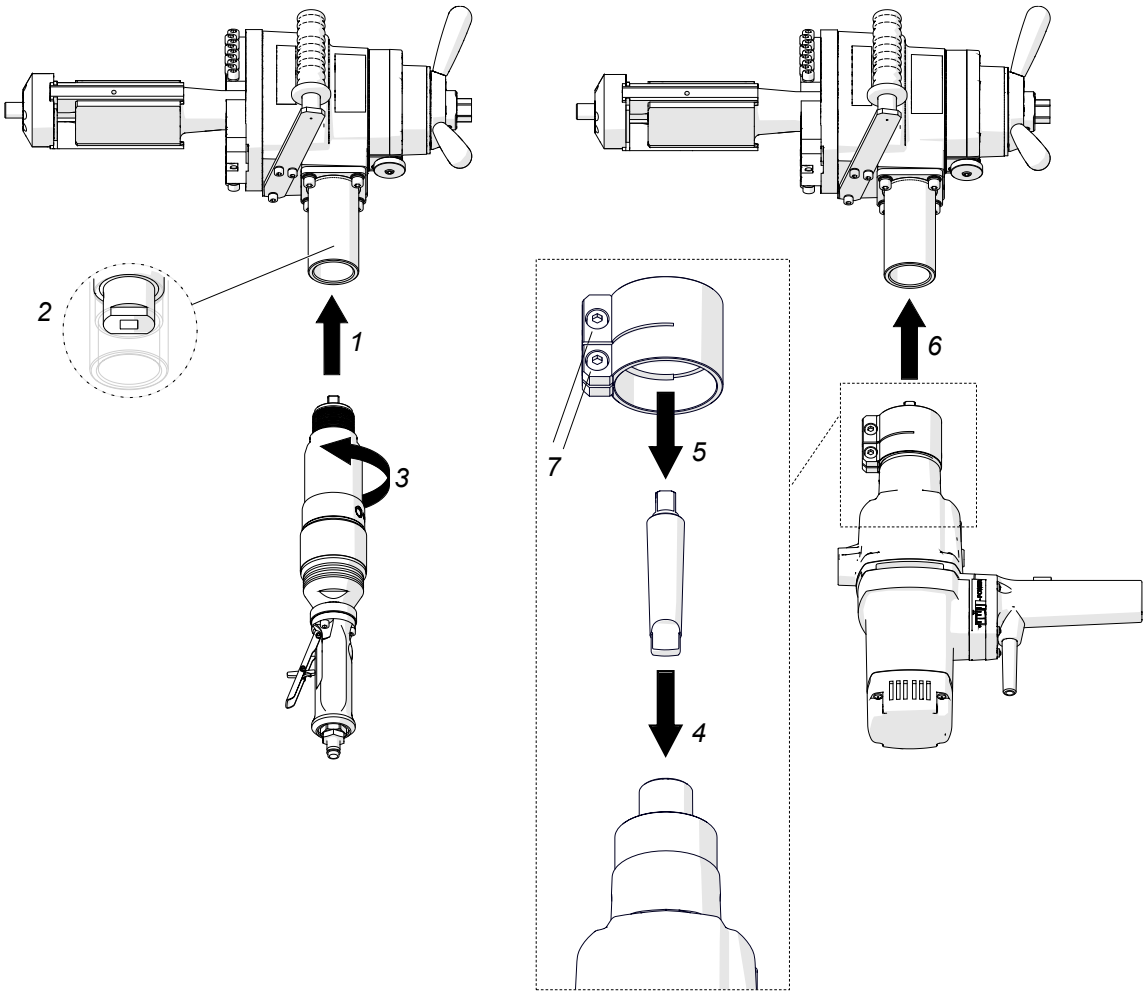


Fig. 4. Installing the air and electric motor

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4.4. Clamping the machine into the pipe

Put the machine into the pipe (*1*, Fig. 5) to set the tool bits at least 3 mm (1/8″) from the pipe end. Then, use the 24 mm socket wrench to turn the draw nut (*2*) to the right to expand the jaw blocks and clamp the machine into the pipe. Make sure that the jaw blocks are put further than the surface after machining (*3*).

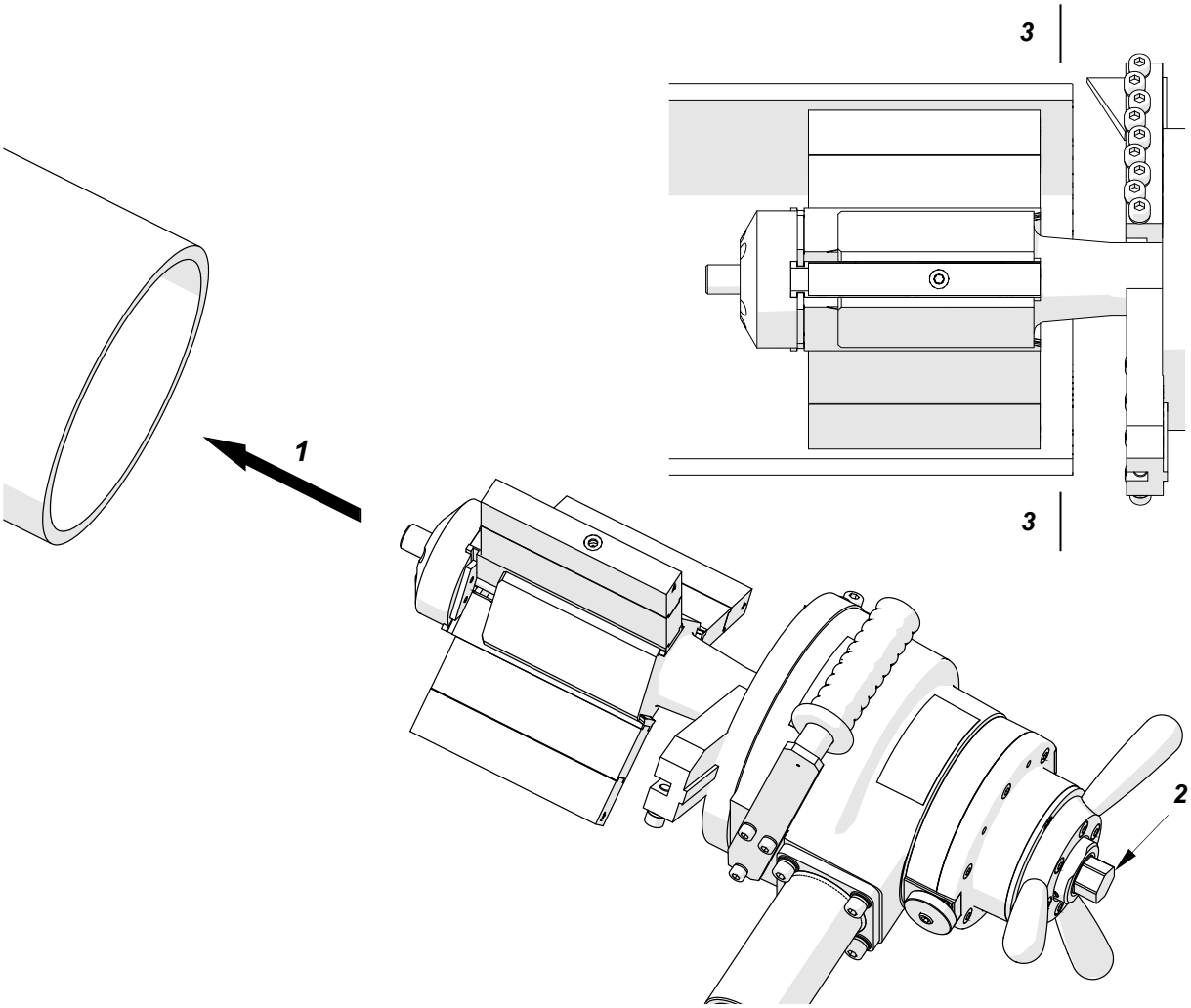


Fig. 5. Clamping the machine into the pipe

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4.5. Preparing the air (for machine with air motor)

Connect the machine to a correctly prepared air source of sufficient purity. Make sure that all inner diameters of the air source (including the supply hose and fittings) are of at least 12 mm (15/32″). Make sure that the air source has an air preparation unit that contains a filter, regulator, and lubricator (FRL).

Maintain the FRL unit as required. Keep the water trap drained, filter cleaned, and the lubricator oil reservoir filled so that there is a drop of oil every 2-5 seconds. Use oil whose ignition temperature is more than 260°C (500°F). If you are not going to use the machine for at least 24 hours, increase the supply of oil and let the motor operate for 2-3 seconds. This will prevent rusting and degrading of the rotor vanes.

4.6. Operating

After you connect the machine to the correct supply, use the torque adjusting dial to set the maximum torque. In the electric motor, use the gear switch to select gear ‘I’. To start, press the ON/OFF lever (air motor) or press and hold the ON switch (electric motor). To lock the switch in the position ON, press the ON switch lock before using the switch.

Apply the coolant on the working edge. Then, turn the handles to the right to bring the tool bits close to the pipe. If the pipe end is not perpendicular to the pipe axis, the tool bit will cut only a small part of the pipe during initial rotations. Thus, use a low feed rate until the tool bit is in continuous contact with the pipe during at least one rotation. The feed is 2 mm (5/64″) per one full turn of the handles (Fig. 6). The machine with electric motor allows you to change the gears between ‘I’ and ‘II’ after the rotation stops, and to adjust the rotational speed.

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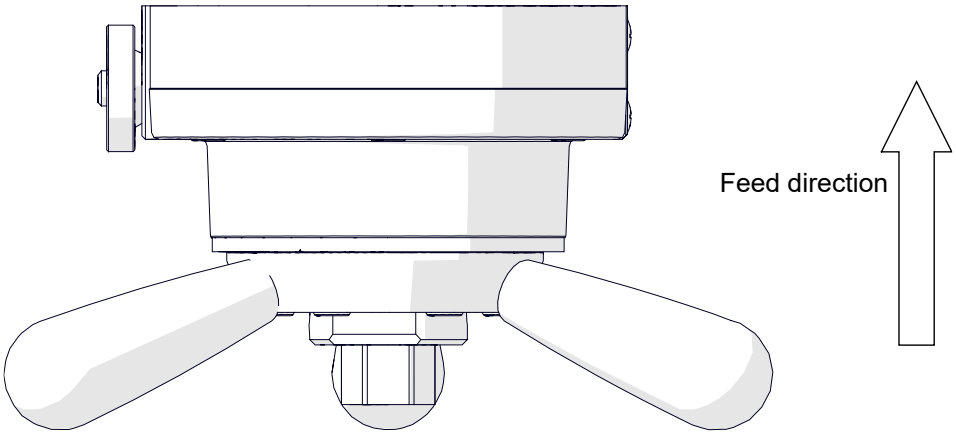


Fig. 6. View of the feed handles

Turn the handles to the right to continue machining. Use such a feed rate so that the chip is continuous. If the feed rate is too low, only small chips are removed. If the feed rate is too high, machining is difficult and the chips are rough or torn. Do not allow the tool bit to burnish the surface. If chatter problems occur, change the feed rate. Stainless steel can harden during work. Thus, cut stainless steel with a high enough feed, 0.08-0.15 mm (0.003-0.006″) per turn, to cut under the hardened surface.

After machining, stop turning the handles and allow several more turns of the spindle to improve the finish of the surface. Then, use the ON/OFF lever, or the ON switch in the machine with electric motor, to turn off the motor, and wait until the rotation stops. Turn the handles to the left to move the tool bits away from the pipe to at least 3 mm (1/8″). Then, turn the 24 mm socket wrench to the left to loosen the draw nut and release the clamping, and remove the machine from the pipe.

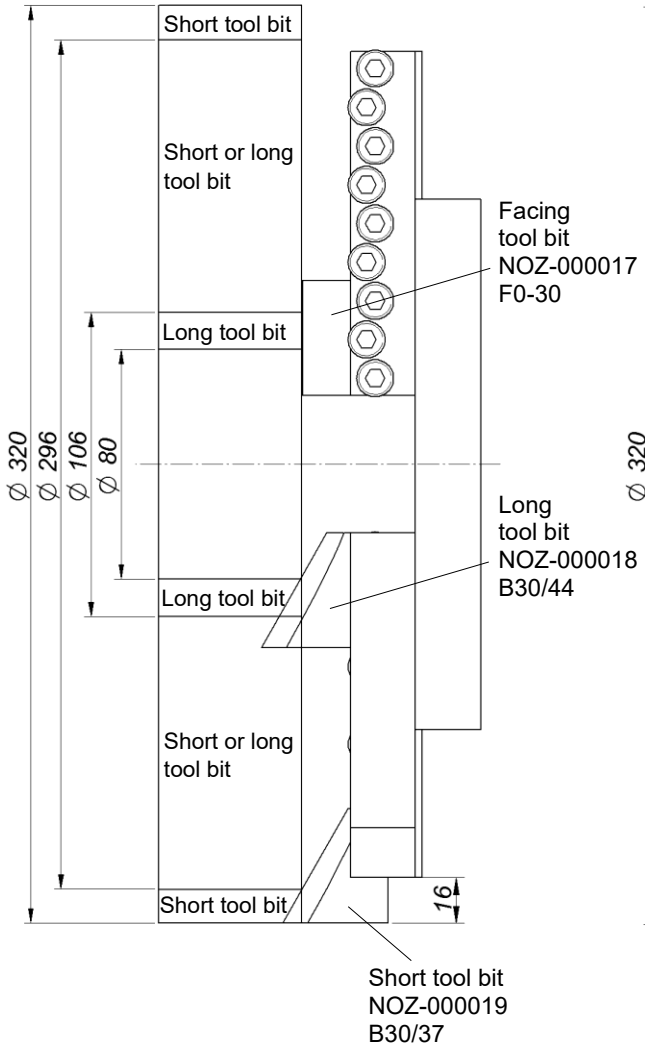
Clean the pipe with petroleum ether. Clean the machine with a dry cotton cloth and no chemical agents.

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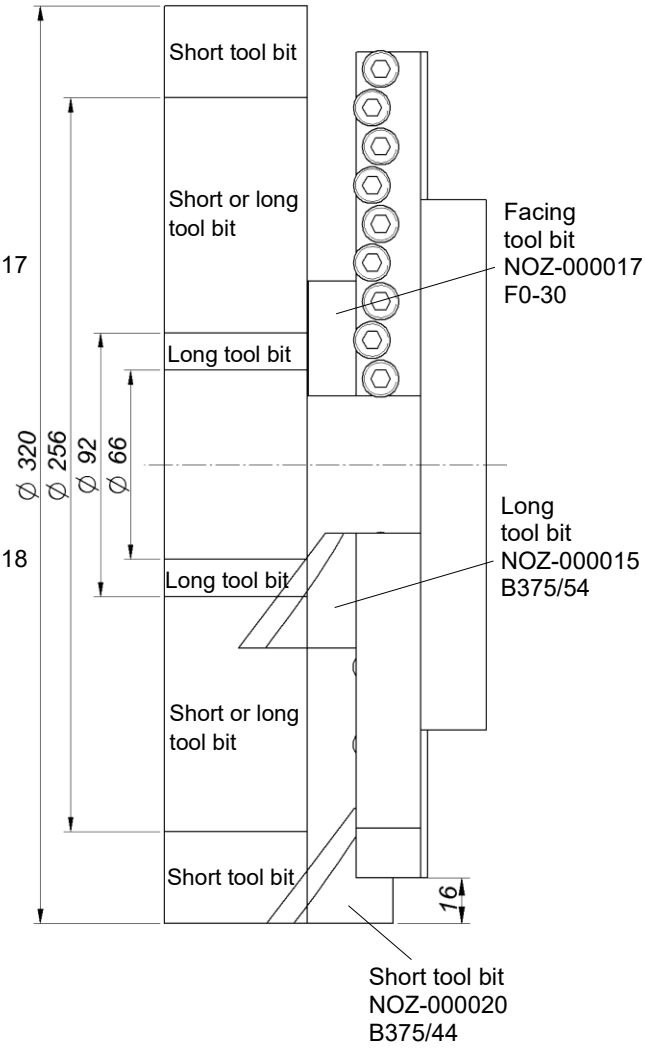
4.7. Facing and bevelling at the same time

When you face and bevel at the same time, use short or long bevelling tool bit depending on the pipe diameter as shown in Fig. 7.

Facing and external bevelling at 30°



Facing and external bevelling at 37.5°



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Facing and internal bevelling at 30°

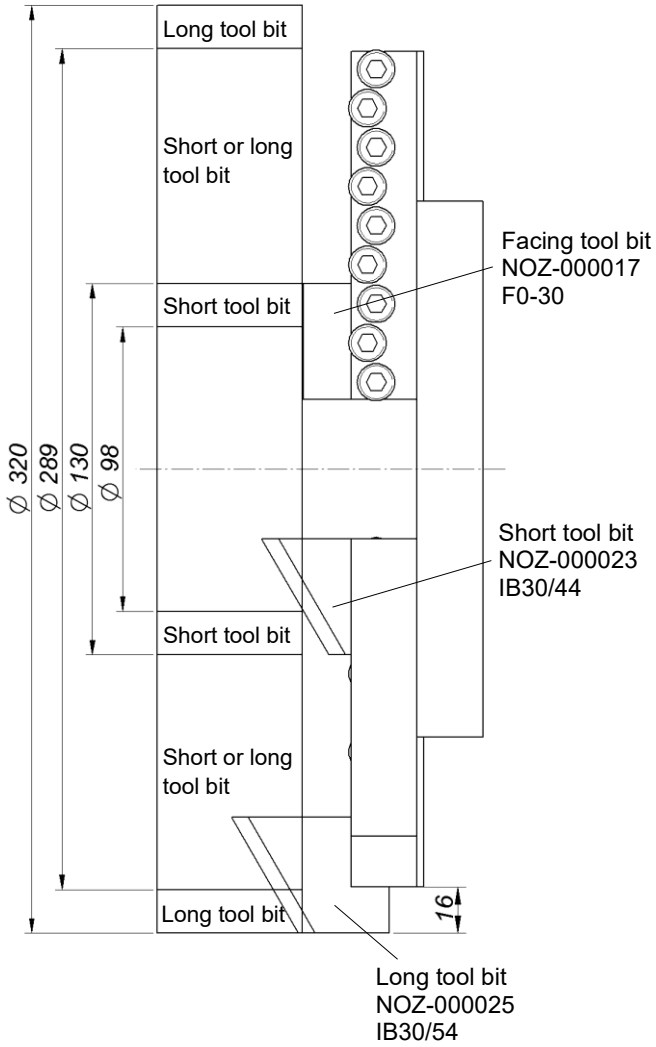
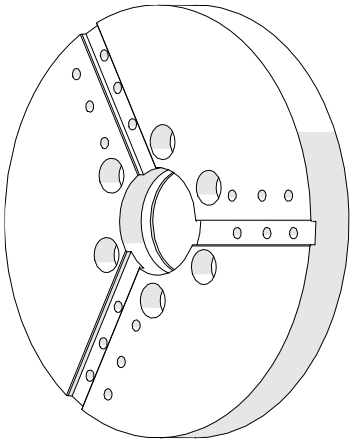


Fig. 7. Positioning the facing tool bit and a short or long bevelling tool bit

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5. ACCESSORIES

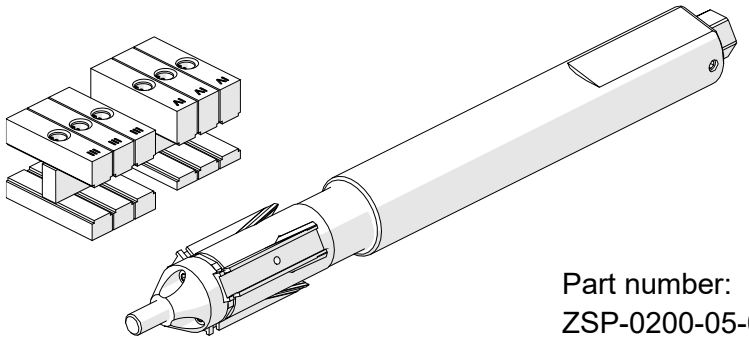
5.1. Disc for three tool bits



Part number:
TRC-0807-05-00-00-0

5.2. Small expanding mandrel set

Allows machining pipes of inner diameters from 38 to 86 mm (1 1/2-3 25/64″).



Part number:
ZSP-0200-05-00-00-2

Small expanding mandrel	1 unit
Jaw blocks (number I, II, III, IV)	3 sets
3 mm hex wrench	1 unit

Loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3) to at least one turn. Then, turn the handles to the left to remove the installed mandrel.

Use the table to select jaw blocks of the small expanding mandrel set for the inner diameter of the pipe to be machined. Use the 3 mm hex wrench to attach the blocks to the small expanding mandrel as shown in Fig. 2. Put the mandrel into the machine (*2*, *3*, *4*, *5*, Fig. 3).

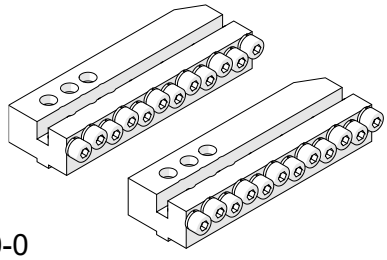
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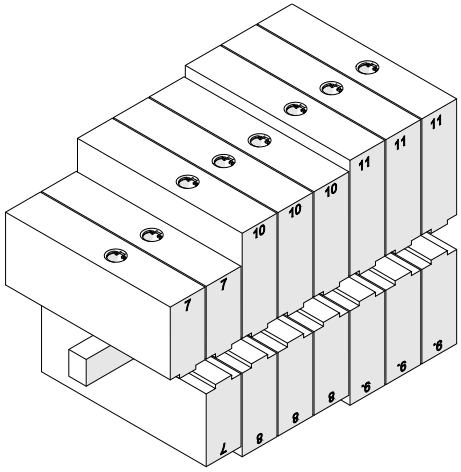
Pipe inner diameter with small expanding mandrel		Jaw block number
[mm]	[inch]	
38-47.5	1 1/2-1 7/8	-
47.5-57.5	1 7/8-2 17/64	I
57-67	2 1/4-2 41/64	II
66.5-76.5	2 5/8-3 1/64	III
76-86	2 63/64-3 25/64	IV

5.3. Extension set

Allows machining pipes of inner diameters from 192 to 349 mm (7 9/16-13 47/64″) in combination with the standard expanding mandrel. Clamping inside a pipe of the diameter of 349 mm will allow machining up to 8 mm (5/16″) of pipe wall.

Part number:
ZST-0807-08-00-00-0





Tool holder of extension set	2 units
Jaw blocks (number 7, 8, 9, 10, 11)	2 sets
Metal box	1 unit
5 mm hex wrench	1 unit
4 mm hex wrench	1 unit

Use the 5 mm hex wrench to remove the screws (*3*, Fig. 2) and remove the installed holders. Use the same screws to attach the tool holders of the extension set.

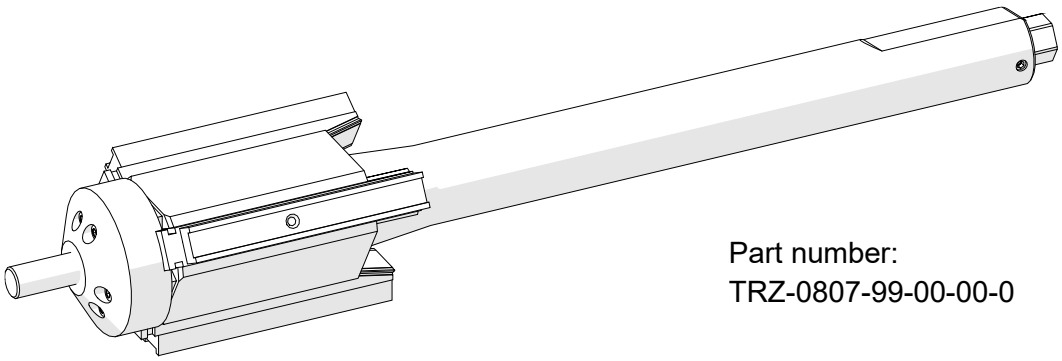
Use the table to select jaw blocks of the extension set for the inner diameter of the pipe to be machined. Use the 5 mm hex wrench to attach the blocks to the standard expanding mandrel as shown in Fig. 2. Use the 4 mm hex wrench to tighten the tool bits (*5*, Fig. 2).

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Pipe inner diameter with standard expanding mandrel and jaw blocks of extension set		Jaw block number	Adapter
[mm]	[inch]		
192-208	7 9/16-8 3/16	7	-
208-224	8 3/16-8 13/16	8	-
224-240	8 13/16-9 29/64	9	-
240-256	9 29/64-10 5/64	10	-
256-272	10 5/64-10 45/64	11	-
269-285	10 19/32-11 7/32	7	+
285-301	11 7/32-11 27/32	8	+
301-317	11 27/32-12 31/64	9	+
317-333	12 31/64-13 7/64	10	+
333-349	13 7/64-13 47/64	11	+

5.4. Large expanding mandrel

Allows machining pipes of inner diameters from 126 to 296 mm (4 61/64-11 21/32″) when used with standard jaw blocks. Also, when used with jaw blocks of the extension set, the large expanding mandrel allows the machine to be clamped inside pipes of diameters from 219 to 376 mm (8 5/8-14 51/64″) for flange facing.



Part number:
TRZ-0807-99-00-00-0

Loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3) to at least one turn. Then, turn the handles to the left to remove the installed mandrel.

Use the table to select standard jaw blocks for the inner diameter of the pipe to be machined or jaws blocks of the extension set for flange facing. Then, use the 5 mm hex wrench to attach the blocks to the large expanding mandrel as shown in Fig. 2. Put the mandrel into the machine (*2*, *3*, *4*, *5*, Fig. 3).

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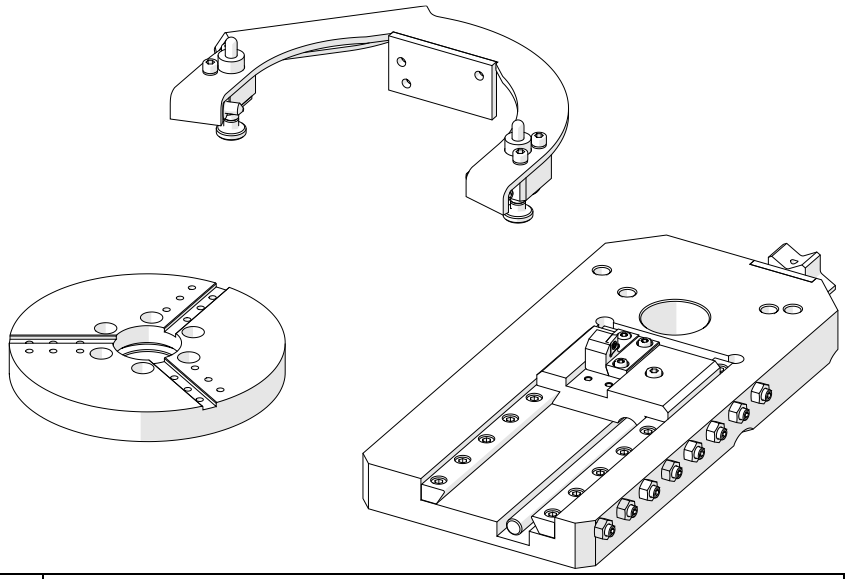
Pipe inner diameter with large expanding mandrel and standard jaw blocks		**Jaw block number**	**Adapter**	**Pipe inner diameter** with large expanding mandrel and jaw blocks of extension set		**Jaw block number**	**Adapter**
[mm]	[inch]			[mm]	[inch]		
126-142	4 61/64-5 19/32	1	-	219-235	8 5/8-9 1/4	7	-
142-158	5 19/32-6 7/32	2	-	235-251	9 1/4-9 7/8	8	-
157-173	6 3/16-6 13/16	3	-	251-267	9 7/8-10 33/64	9	-
173-189	6 13/16-7 7/16	4	-	267-283	10 33/64-11 9/64	10	-
188-204	7 13/32-8 1/32	5	-	283-299	11 9/64-11 49/64	11	-
203-219	7 63/64-8 5/8	6	-	296-312	11 21/32-12 9/32	7	+
219-235	8 5/8-9 1/4	2	+	312-328	12 9/32-12 29/32	8	+
234-250	9 7/32-9 27/32	3	+	328-344	12 29/32-13 35/64	9	+
250-266	9 27/32-10 15/32	4	+	344-360	13 35/64-14 11/64	10	+
265-281	10 7/16-11 1/16	5	+	360-376	14 11/64-14 51/64	11	+
280-296	11 1/32-11 21/32	6	+				

5.5. Flange facing attachment

5.5.1. General information

Allows facing flanges of diameters from 90 to 508 mm (3 35/64-20″) with the machine clamped inside a pipe of the inner diameter of 84-269 mm (3 5/16-10 19/32″) by using the standard expanding mandrel or of 219-376 mm (8 5/8-14 51/64″) by using the large expanding mandrel.

Part number:
PRK-0807-06-00-00-0



Flange diameter	90-508 mm (3 35/64-20″)
Automatic feed range	180.5 mm (7 7/64″)
Diameter of rotating parts	569.4 mm (22 27/64″)
Feed per rotation	0.33 mm (1/64″, with one tripper block engaged) 0.66 mm (1/32″, with two tripper blocks engaged)

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5.5.2. Equipment included

Milling unit for flanges	1 unit
Holder with two tripper blocks	1 unit
Cutting insert	8 units
Disc for three tool bits	1 unit
Fixing screw for cutting insert	2 units
Internal insert holder	1 unit
External insert holder	1 unit
Metal box	1 unit
M6x35 screw	3 units
M6x30 screw	3 units
M6x14 screw	3 units
5 mm hex wrench	1 unit
4 mm hex wrench	1 unit
3 mm hex wrench	1 unit
13 mm combination wrench	1 unit
T15 screwdriver	1 unit
Tool container	1 unit

5.5.3. Installing

Loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3) to at least one turn. Then, turn the handles to the left to remove the installed mandrel.

Use the 5 mm hex wrench to remove the screws (*3*, Fig. 2) and remove the installed tool holders.

Remove three screws with washers (*1*, Fig. 8) and remove the machine handle. Use the same screws to attach the holder with two tripper blocks (*2*). Use the 4 mm hex wrench to tighten the set screws (*3*) at both sides of the holder. Next, use the 5 mm hex wrench and six screws to attach the milling unit to the spindle disk (*4*).

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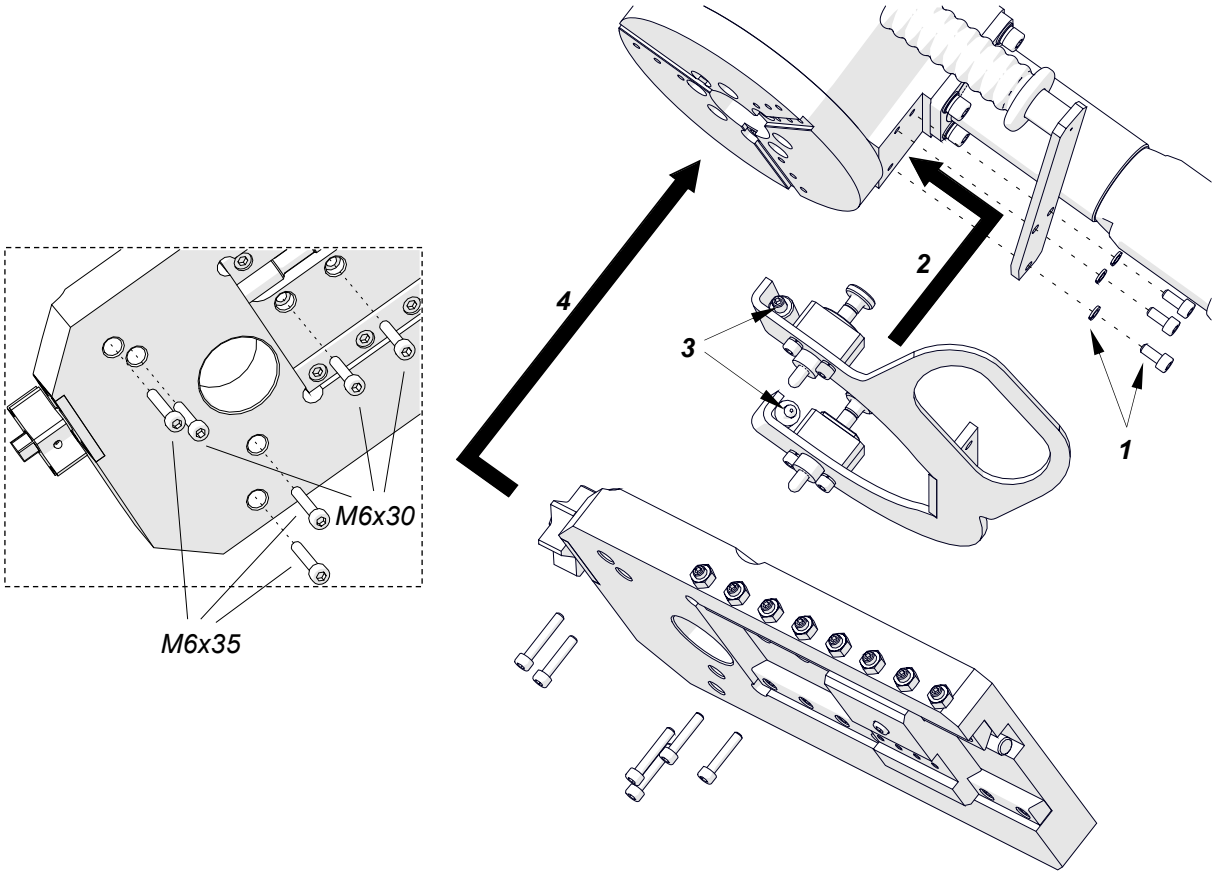


Fig. 8. Installing the flange facing attachment

Depending on the diameter of the flange to be machined, select the internal (Ø90-451, 3 35/64-17 3/4″) or external insert holder (Ø147-508, 5 25/32-20″). Then, use the supplied screwdriver to install a cutting insert onto the insert holder (*1*, Fig. 9). Next, use the 4 mm hex wrench to attach the clamp (*2*). Put the insert holder under the clamp (*3*) and tighten with the screws (*4*).

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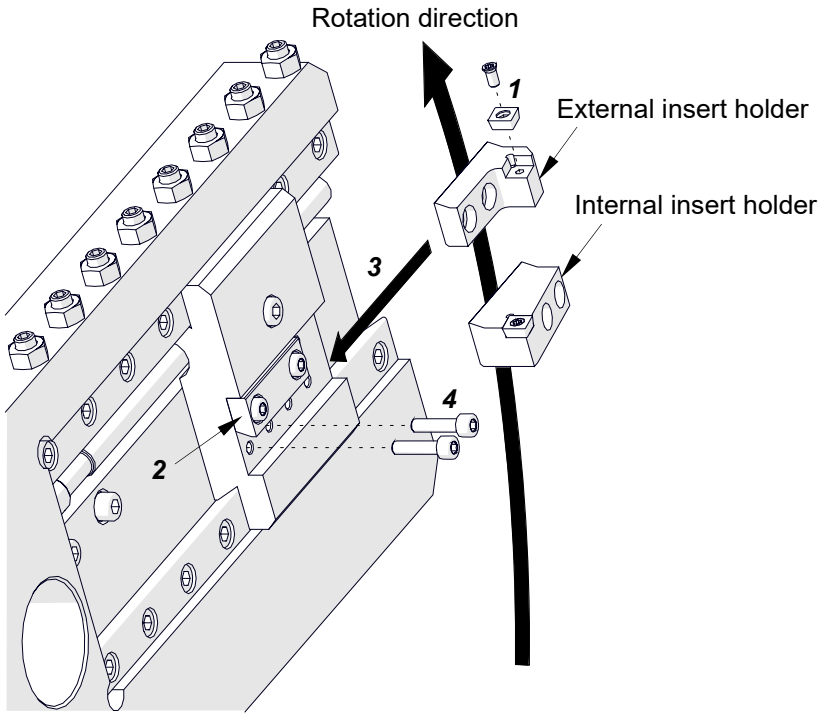


Fig. 9. Installing the tool

Use the table to select standard jaw blocks for the inner diameter of the flange to be machined. Attach the blocks to the standard expanding mandrel or select jaw blocks of the extension set and attach them to the large expanding mandrel (Fig. 2).

Pipe inner diameter with standard expanding mandrel and standard jaw blocks		**Jaw block number**	**Adapter**	**Pipe inner diameter** with large expanding mandrel and jaw blocks of extension set		**Jaw block number**	**Adapter**
[mm]	[inch]			[mm]	[inch]		
84-100	3 5/16-3 15/16	-	-	219-235	8 5/8-9 1/4	7	-
99-115	3 57/64-4 17/32	1	-	235-251	9 1/4-9 7/8	8	-
115-131	4 17/32-5 5/32	2	-	251-267	9 7/8-10 33/64	9	-
130-146	5 1/8-5 3/4	3	-	267-283	10 33/64-11 9/64	10	-
146-162	5 3/4-6 3/8	4	-	283-299	11 9/64-11 49/64	11	-
161-177	6 11/32-6 31/32	5	-	296-312	11 21/32-12 9/32	7	+
176-192	6 59/64-7 9/16	6	-	312-328	12 9/32-12 29/32	8	+
192-208	7 9/16-8 3/16	2	+	328-344	12 29/32-13 35/64	9	+
207-223	8 5/32-8 25/32	3	+	344-360	13 35/64-14 11/64	10	+
223-239	8 25/32-9 13/32	4	+	360-376	14 11/64-14 51/64	11	+
238-254	9 3/8-10	5	+				
253-269	9 61/64-10 19/32	6	+				

Finally, put the mandrel into the machine (*2*, *3*, *4*, *5*, Fig. 3) and clamp the machine into the pipe as shown in Fig. 5.

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5.5.4. Operating

After the machine with the attachment is clamped inside the pipe, use the 13 mm combination wrench to rotate the draw nut (*1*) so that the cutting edge of the tool is moved out of the flange outer diameter. Then, set the sprocket (*2*) as shown in Fig. 10, and push out the two pins of the tripper blocks (*3*) to engage them with the attachment. Turn the handles (*4*) to the right to set the machining depth to up to 0.5 mm (1/64″) from the pipe end, and start the motor.

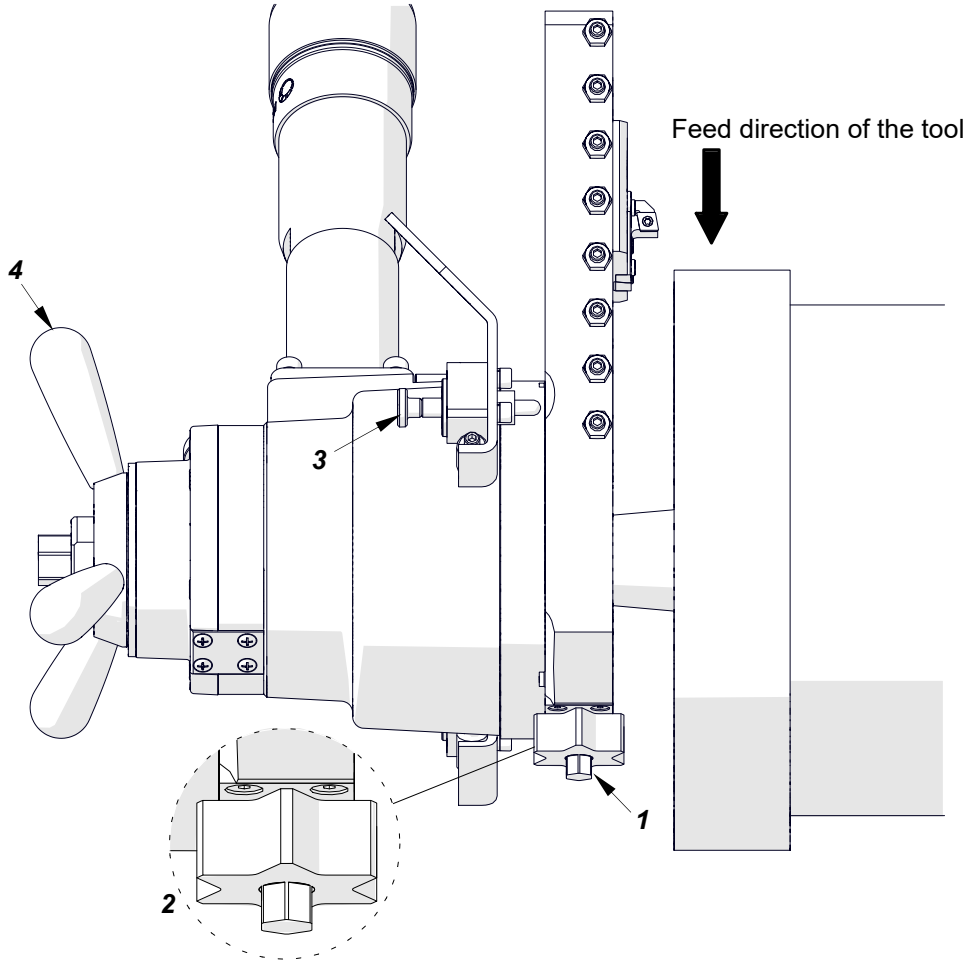


Fig. 10. Correct positioning of the flange facing attachment

After facing is finished, turn off the motor and wait until the rotation stops. Then, turn the handles to the left to retract the tool from the workpiece. Clean the face surface of the flange. Next, for finishing machining, retract the pin of one tripper block to leave only one tripper block engaged. Set the machining depth to up to 0.25 mm (1/128″) and turn on the motor to allow several more turns of the spindle.

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5.5.5. Adjusting the slider clearance

Use the 13 mm combination wrench to loosen the lock nuts (*1*, Fig. 11). Use the 5 mm hex wrench to loosen eight screws (*2*). To get access to the screws, use the 13 mm combination wrench to turn the draw nut (*3*) and change the slider position. Next, move the slider to the most outward position and tighten the adjusting screw (*4*) to lightly press the guide to the slider. Moving the slider to the most inward position, tighten the screws (*2*) lightly to 1.5-2.5 Nm (13-22 in-lbs) and the screws (*4*) put at the current position of the slider. Move the slider through the full length and if it moves smoothly and uniformly, maximally tighten the nuts (*1*).

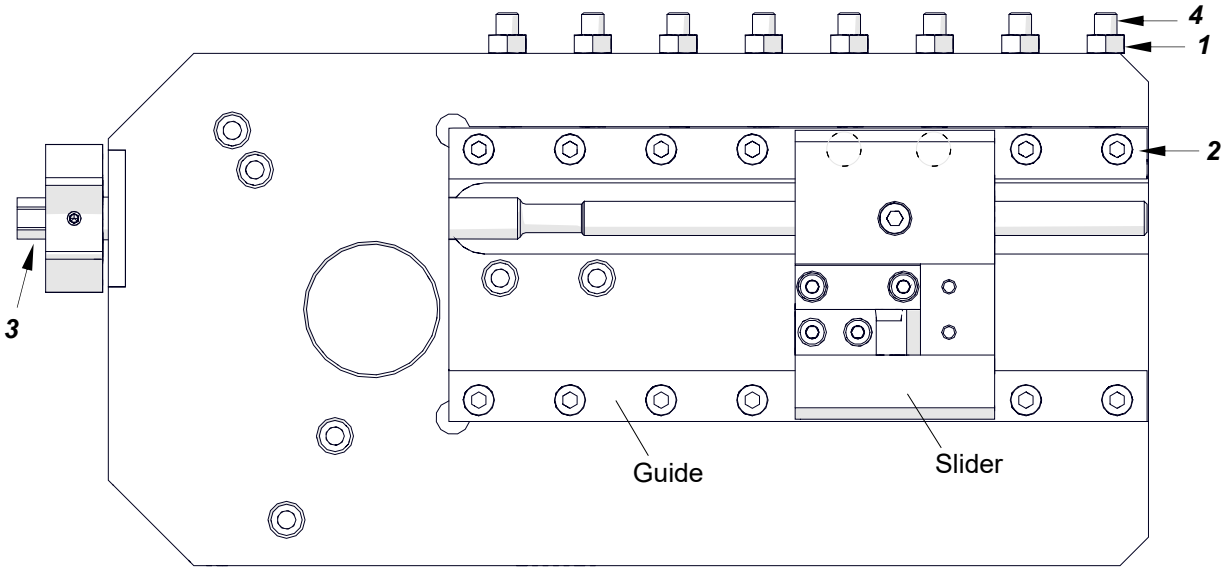


Fig. 11. Adjusting the slider clearance

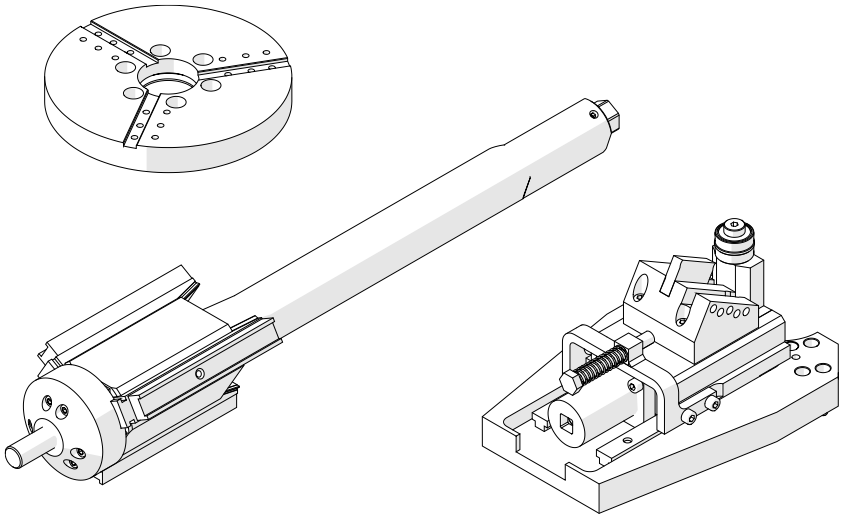
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5.6. Oval attachment

5.6.1. General information

Allows facing and bevelling oval pipes with diameters from 126 to 296 mm (4 61/64-11 21/32″) with the use of the large expanding mandrel.

Part number:
PRK-0807-07-00-00-0



5.6.2. Equipment included

Milling unit for oval pipes (including 0° tool holder; without tool bits)	1 unit
Large expanding mandrel	1 unit
Disc for three tool bits	1 unit
Metal box	1 unit
1/2″ ratchet wrench	1 unit
8 mm flat wrench	1 unit
6 mm hex wrench	1 unit
5 mm hex wrench	1 unit
4 mm hex wrench	1 unit
2.5 mm hex wrench	1 unit
Tool container	1 unit

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5.6.3. Installing

Loosen the nut and use the 5 mm hex wrench to loosen the set screw (*1*, Fig. 3) to at least one turn. Then, turn the handles to the left to remove the installed mandrel.

Use the same 5 mm hex wrench to remove the screws (*3*, Fig. 2) and remove the installed tool holders.

Use eight screws to attach the milling unit for oval pipes to the spindle disk (Fig. 12a). Use the 5 mm hex wrench to install the tool holder (Fig. 12b). Put a correct tool bit into the holder according to the rotation direction, and use the 4 mm hex wrench to tighten the tool bit.

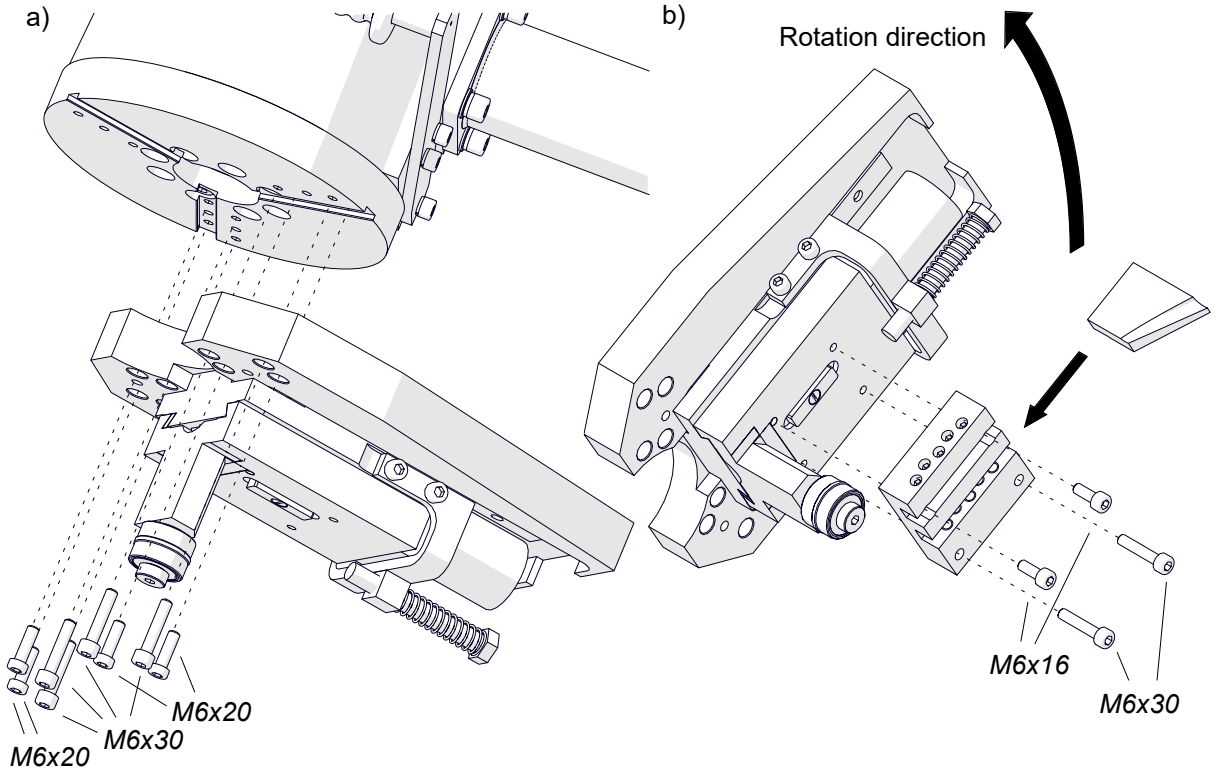


Fig. 12. Installing the attachment for oval pipes

Use the table to select standard jaw blocks and adapters and attach them to the large expanding mandrel (Fig. 2).

Pipe inner diameter with large expanding mandrel and standard jaw blocks		**Jaw block number**	**Adapter**
[mm]	[inch]		
126-142	4 61/64-5 19/32	1	-
142-158	5 19/32-6 7/32	2	-
157-173	6 3/16-6 13/16	3	-

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173-189	6 13/16-7 7/16	4	-
188-204	7 13/32-8 1/32	5	-
203-219	7 63/64-8 5/8	6	-
219-235	8 5/8-9 1/4	2	+
234-250	9 7/32-9 27/32	3	+
250-266	9 27/32-10 15/32	4	+
265-281	10 7/16-11 1/16	5	+
280-296	11 1/32-11 21/32	6	+

Finally, put the mandrel into the machine (*2*, *3*, *4*, *5*, Fig. 3) and clamp the machine into the pipe as shown in Fig. 5.

5.6.4. Operating

After the machine with the attachment is clamped inside the pipe, tighten the bumper screw to prevent movement of the tool bit holder (*1*, Fig. 13). Use the 6 mm hex wrench to loosen the guide screws (*2*). Put the attachment so that the roller is in contact with the pipe at the lowest inner diameter (*3*). Then, tighten the guide screws (*2*), loosen the bumper screw (*4*), and use the 1/2″ ratchet wrench to initially tighten the spring (*5*).

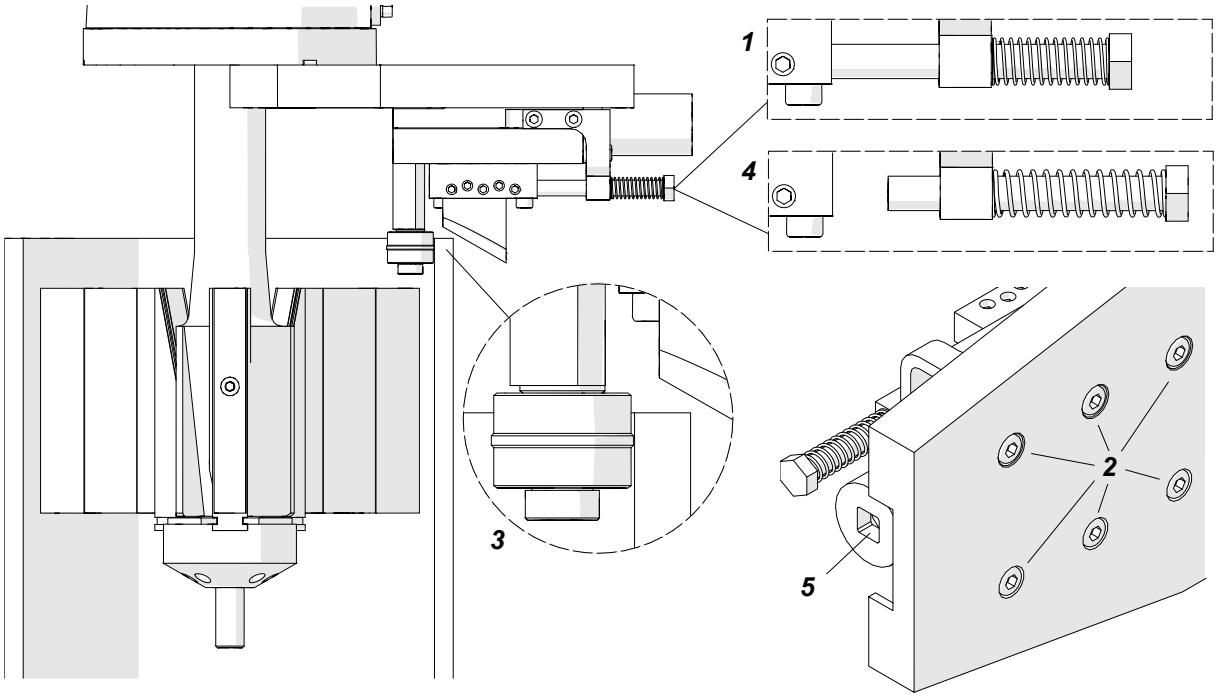


Fig. 13. Correct positioning of the oval attachment

Start the motor and turn the handles to the right. If the machining is difficult, stop the rotation and tighten the bumper spring (*5*) more.

After machining, stop rotating the handles and allow several more turns of the spindle to improve the finish of the surface. Stop the machine and separate the tool bits from the pipe. Next, release the clamping and remove the machine from the pipe.

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5.6.5. Adjusting the slider clearance

Use the 8 mm flat wrench to loosen the lock nuts (*1*, Fig. 14) and use the 2.5 mm hex wrench to lightly tighten the screws (*2*). If, after loosening the screws (*3*), the slider moves smoothly and uniformly, tighten the lock nuts (*1*).

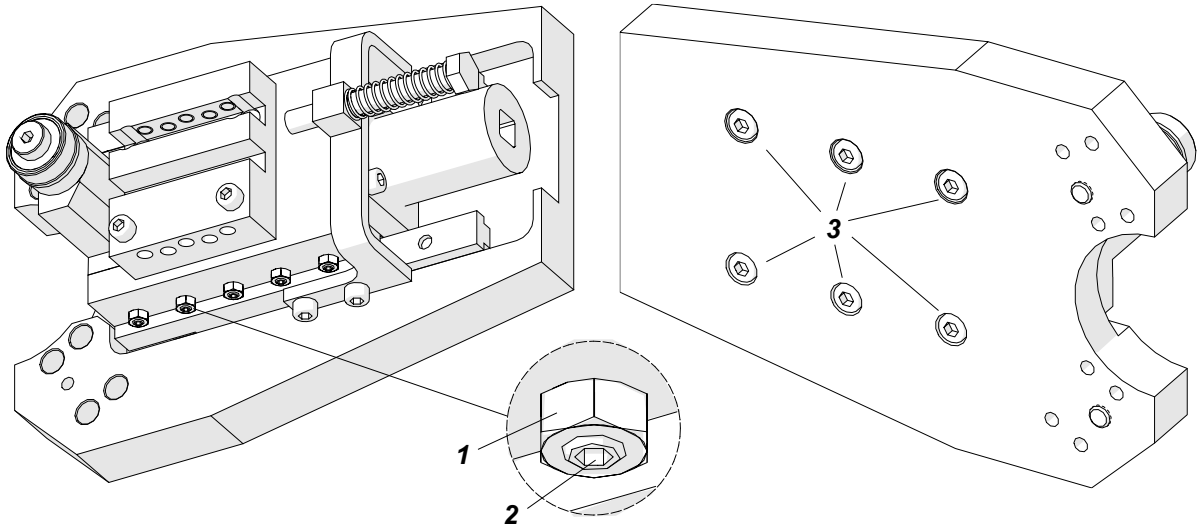
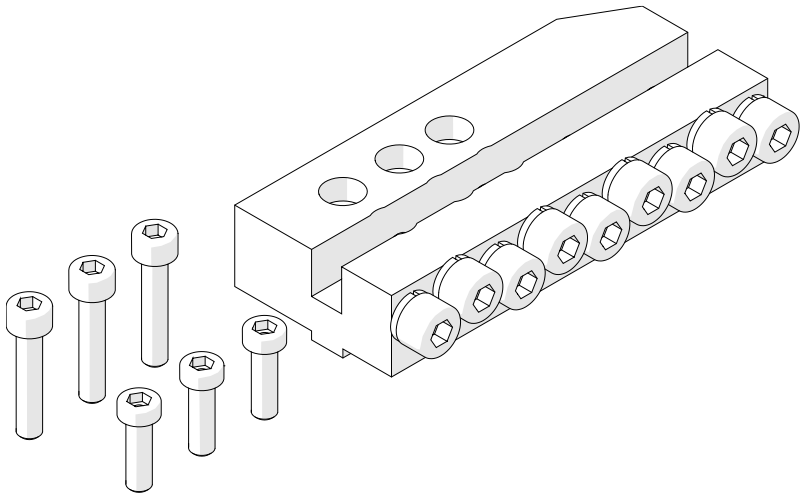


Fig. 14. Adjusting the slider clearance

5.7. Tool bit holder

Additional holder for standard range of diameters.

Part number:
OBS-0807-99-01-00-0

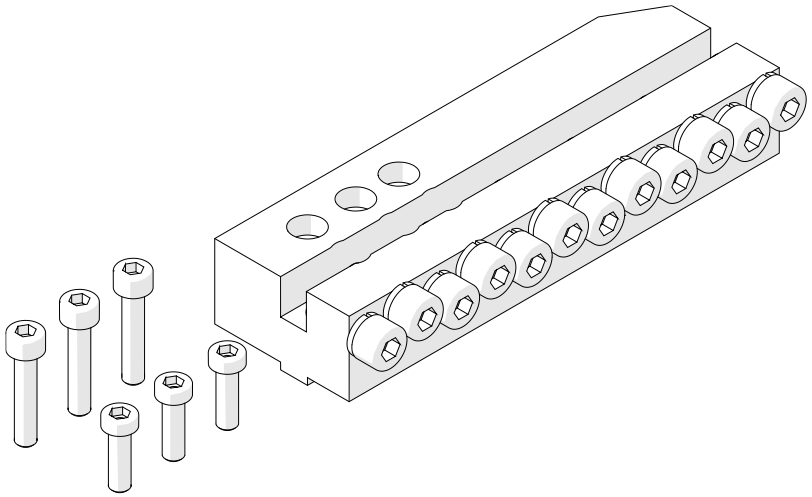


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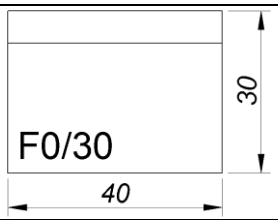
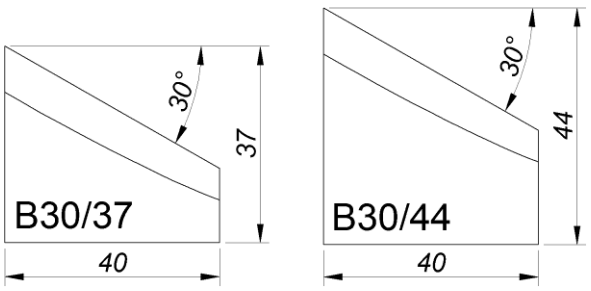
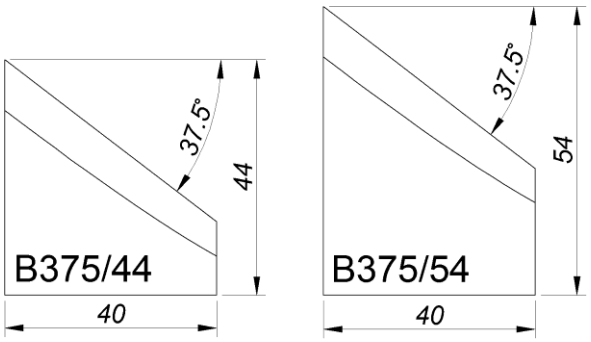
5.8. Tool bit holder for extension set

Additional holder for extension set.

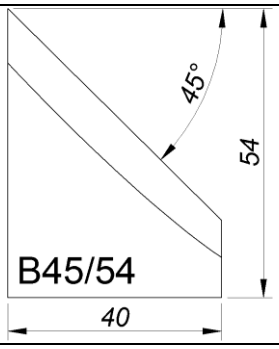
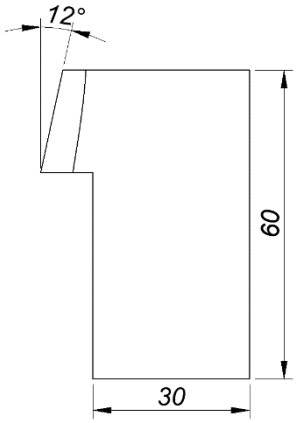
Part number:
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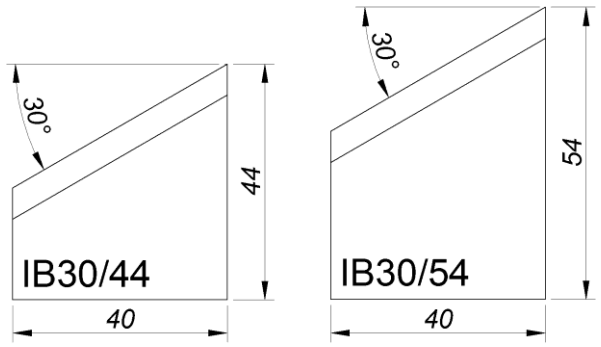
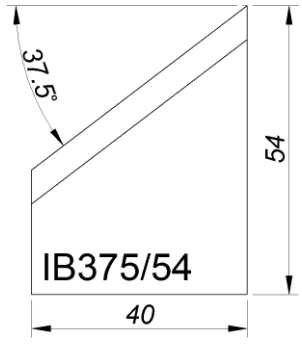


5.9. Tool bits

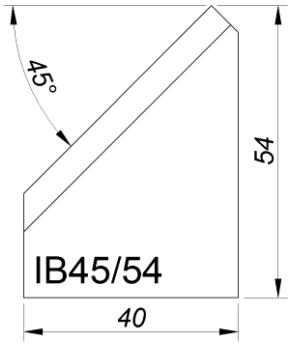
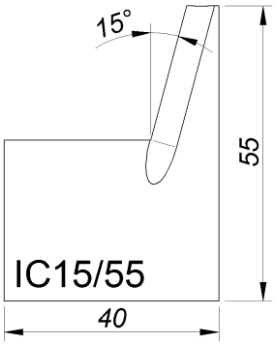
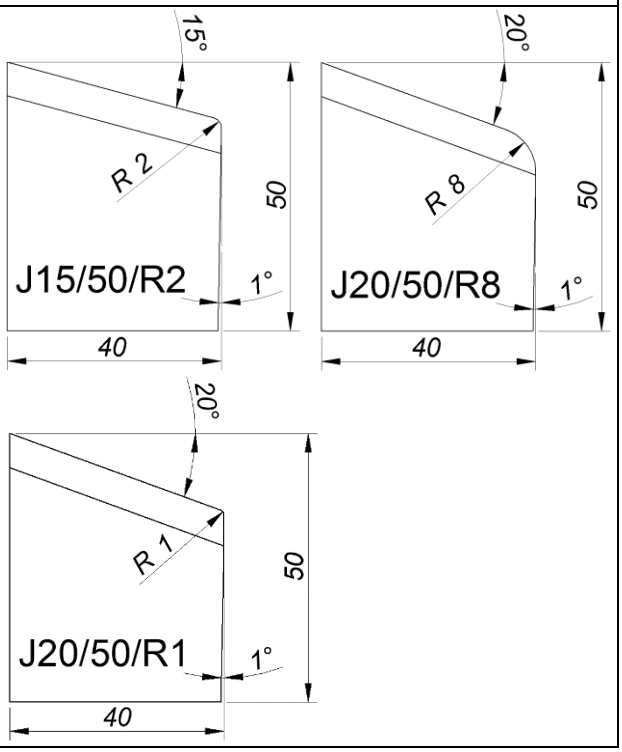
NOZ-000017	F0-30 0° facing tool bit	
NOZ-000019	B30/37 30° bevelling tool bit (for diameters over 106 mm, if works together with 0° facing tool bit)	
NOZ-000018	B30/44 30° bevelling tool bit (for diameters under 296 mm, if works together with 0° facing tool bit)	
NOZ-000020	B375/44 37.5° bevelling tool bit (for diameters over 92 mm, if works together with 0° facing tool bit)	
NOZ-000015	B375/54 37.5° bevelling tool bit (for diameters under 256 mm, if works together with 0° facing tool bit)	

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NOZ-000021	B45/54 45° bevelling tool bit	
NOZ-000086	12° special tool bit	

NOZ-000023	IB30/44 30° internal bevelling tool bit (for diameters under 289 mm, if works together with 0° facing tool bit)	
NOZ-000025	IB30/54 30° internal bevelling tool bit (for diameters over 130 mm, if works together with 0° facing tool bit)	
NOZ-000024	IB375/54 37.5° internal bevelling tool bit	

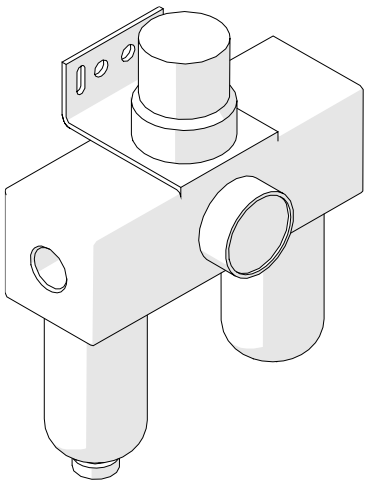
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NOZ-000026	IB45/54 45° internal bevelling tool bit	
NOZ-000001	IC15/55 15° internal calibration tool bit (for inner diameters up to 345 mm)	
NOZ-000022	J15/50/R2 15° J-bevelling tool bit (for outer diameters up to 315 mm)	
NOZ-000016	J20/50/R8 20° J-bevelling tool bit (for outer diameters up to 315 mm)	
NOZ-000085	J20/50/R1 20° J-bevelling tool bit (for outer diameters up to 315 mm)	

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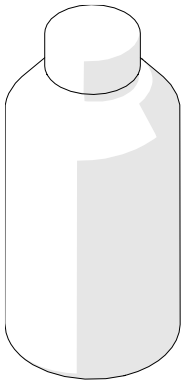
5.10. Air preparation unit

Part number (filter, regulator, lubricator):
ZST-000021



5.11. Coolant

Part number:
OLJ-0505-09-00-00-0 (0.5 kg, 1.1 lbs)
OLJ-0505-10-00-00-0 (1 kg, 2.2 lbs)
OLJ-0505-11-00-00-0 (5 kg, 11 lbs)



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6. DECLARATIONS OF CONFORMITY

Declaration of Conformity

JEI Cutting and Drilling Ltd
Unit 21, Empiure Business Park,
Burnley,
BB12 6LT

We declare with full responsibility that:

PRO 10 PB PIPE BEVELLING MACHINE

is manufactured in accordance with the following standard:

- EN ISO 12100: 2010

and satisfies the regulations of the guideline 2006/42/EC.

Person authorised to compile the technical file:

David McFadden, Unit 21 Empire Business Park, Burnley, BB12 6LT

31.10.2023

David McFadden
Managing Director

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Declaration of Conformity

JEI Cutting and Drilling Ltd
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BB12 6LT

We declare with full responsibility that:

PRO 10 PBE PIPE BEVELLING MACHINE

is manufactured in accordance with the following standards:

- EN ISO 12100: 2010
- EN 62841-1: 2015
- EN 55014-1: 2017

and satisfies the regulations of the guidelines: 2014/30/EU, 2006/42/EC, 2011/65/EU.

Person authorised to compile the technical file:

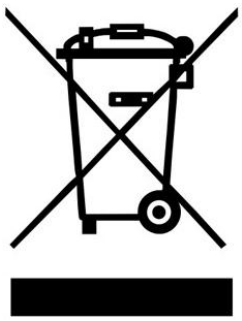
David McFadden, Unit 21 Empire Business Park, Burnley, BB12 6LT

31.10.2023

David McFadden
Managing Director

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7. ENVIRONMENTAL PROTECTION



In accordance with the European Directive 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 processing of such equipment.

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8. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the machine to be free of defects in material and workmanship under normal use for a period of 2 years (24 months) from the date of sale, except batteries (if applicable) which are covered with 2 years (24 months) warranty from their manufacturing date.

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

Serial number .....

Date of sale .....

Signature of seller.....

0.04 / 09 October 2025

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