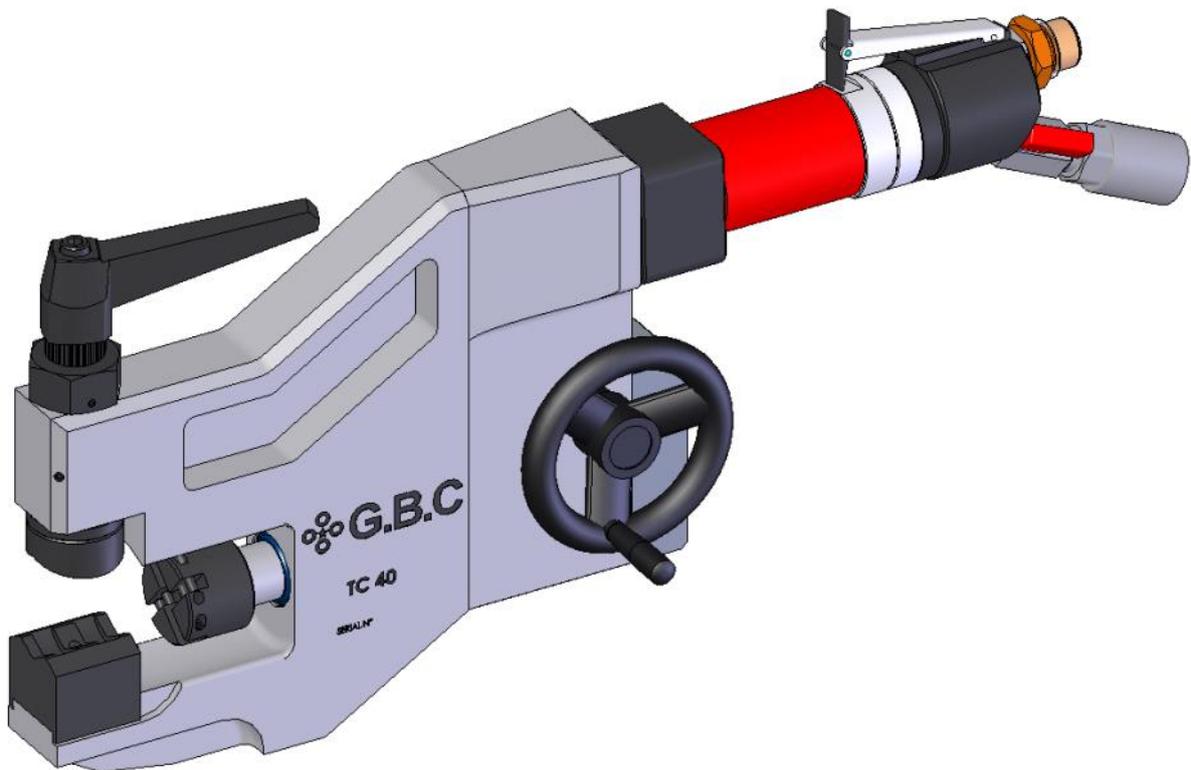




INSTRUCTION MANUAL

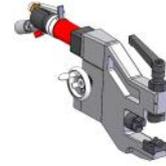


CE

TC 40

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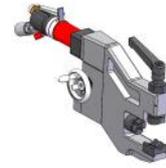
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Original Instructions - rev.1 - 2016 - in compliance with 1.7.4 Machine Directive 2006/42/CE



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-partment, as well as the main workshop and the shipping de-partment.

QUALITY STANDARD—All our machines are assembled according to the highest quality standard. Since 1996 G.B.C. Industrial Tool S.p.a. has implemented management procedures in compliance with the quality system regulations UNI EN ISO 9001 (SGS ITALIA S.R.L. N° IT 96.088 / 1996).

This Manual is supplied together with the machine it makes reference to. The customer may apply for further copies to G.B.C. Industrial Tools S.p.a. Our company owns the copyright of this document and any partial or complete copy or distribution to natural persons or to corporate bodies is strictly forbidden unless our prior approval to do so is obtained. G.B.C. Industrial Tools S.p.a.

informs its customers that any operation carried out on the machines which is not prescribed in this manual entails the automatic invalidation of the warranty. G.B.C. Industrial Tools S.p.a.

recommends to contact the Maintenance Service in Cazzago San Martino – Italy prior to proceed with any modification on the machine.

You are invited to scrupulously adhere to the information written on the identification tag.

For any further information you are invited to contact us at these numbers:

Tel. +39 - 030 -7451154
Fax +39 - 030 – 7356629

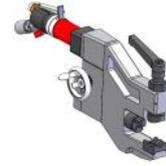
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Original Instructions - rev.1 - 2016 - in compliance with 1.7.4 Machine Directive 2006/42/CE



WARRANTY GENERAL CLAUSES

G.B.C. Industrial Tools S.p.a. guarantees the reliability of the machine and its con-formity 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 imput-able to the user.

The parts subject to wear are excluded from the warranty at sole discretion of G.B.C. Indus-trial Tools S.p.a.

In case of any operational malfunction arising during the warranty period, G.B.C. Industrial Tools S.p.a.

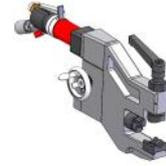
And its Maintenance Service, hereinafter called MSS, will remedy this inconvenient free of charge , both for handwork and for eventual replaced parts, except when the malfunction is di-rectly or indirectly imputable to misuse or alteration. In any case the machine must not be disas-sembled or altered 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 con-nected with the MSS maintenance service.

The shipment of the defective material must be performed within 8 (eight) days from the notifica-tion 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 shipmen to costs from and to the MSS as well as the direct and indirect costs rising from repair of the prod-uct are at user's charge. Any warranty repair or extraordinary repair must be executed by G.B.C. Indus-trial 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 recog-nized or approved by G.B.C. Industrial Tools S.p.A. will not be refunded and will make the war-ranty 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, atmos-pheric events, acts of vandalism, incautious handling and/or transport, use of non original G.B.C. Indus-trial 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. Indus-trial 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 con-ditions he-rewith contained or to issue any on behalf of G.B.C. Industrial Tools S.p.A. The claim terms for defects and/or damages in the material or of the ordered quantities, are those prescribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

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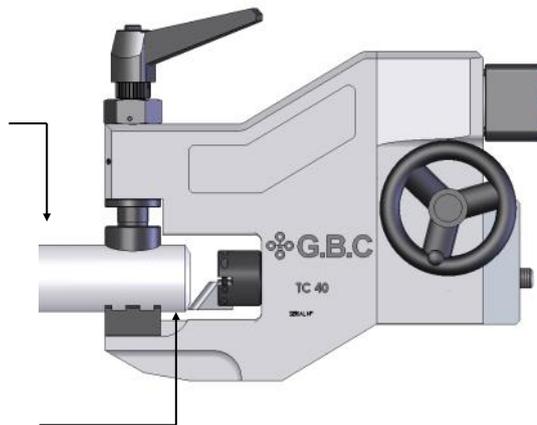
INTENDED USE OF THE MACHINE

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 OD of the pipe

Lavora inserita e bloccata all' esterno del tubo.

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

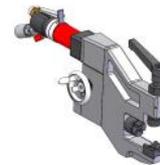


SOLO OPERATORI SPECIALIZZATI CHE ABBIANO RICEVUTO ADEGUATA FORMAZIONE POSSONO UTILIZZARE LA MACCHINA —

A FRONTE DI SPECIFICA FORMAZIONE, NON SI SEGNALANO USI SCORRETTI DELLA STESSA RAGIONEVOLMENTE PREVEDIBILI

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MACHINE CONFIGURATION MODELS

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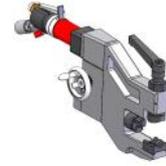


TC40 ELETTRICA



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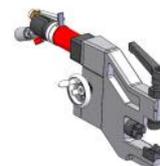


TECHNICAL DATA

FEATURES AND PERFORMANCE	UNIT OF MEASURE	PNEUMATIC	ELECTRIC
OD Locking Range	mm (inches)	10 - 48.3 (0.39 – 1.9)	10 - 48.3 (0.39 – 1.9)
Idle Speed	gg/min (Rpm)	215	360
Stroke	mm (inches)	30 (1.18)	30 (1.18)
Max Chuck Torque	Nm	29.5 (6 bar) 38 (8 bar)	14
Pneumatic Motor Power	Hp (W)	0.59 (435)	-
Air Consumption	NI/min (cfm)	615 (21.7)	-
Air Pressure	Bar (psi)	6 ÷ 8 (87 ÷ 116)	-
Air Hose Connection	Pollici (inches)	1/2" (1/2")	-
Electric Motor Power	W	-	720
Tension	Volt	-	110/230
Frequency	Hz	-	50/60
Max Acoustic Emission	Db	75	75
Machine Weight	Kg	10	10

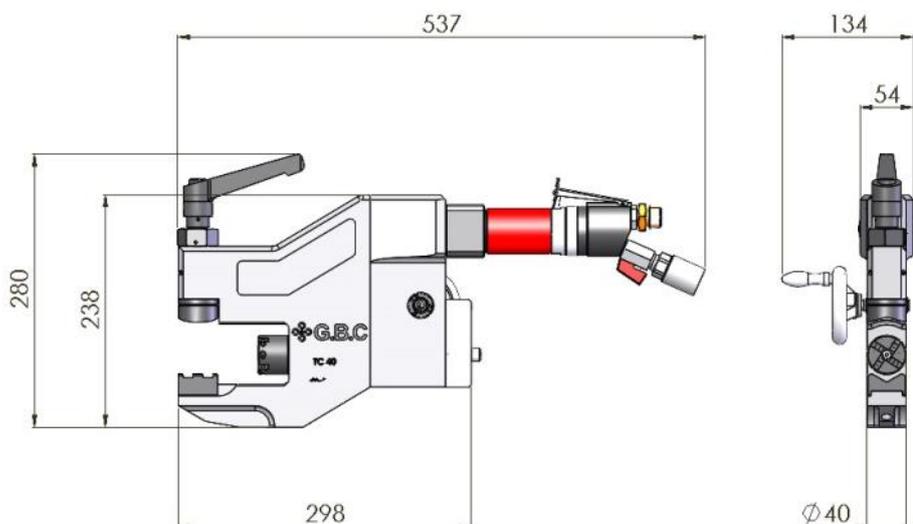
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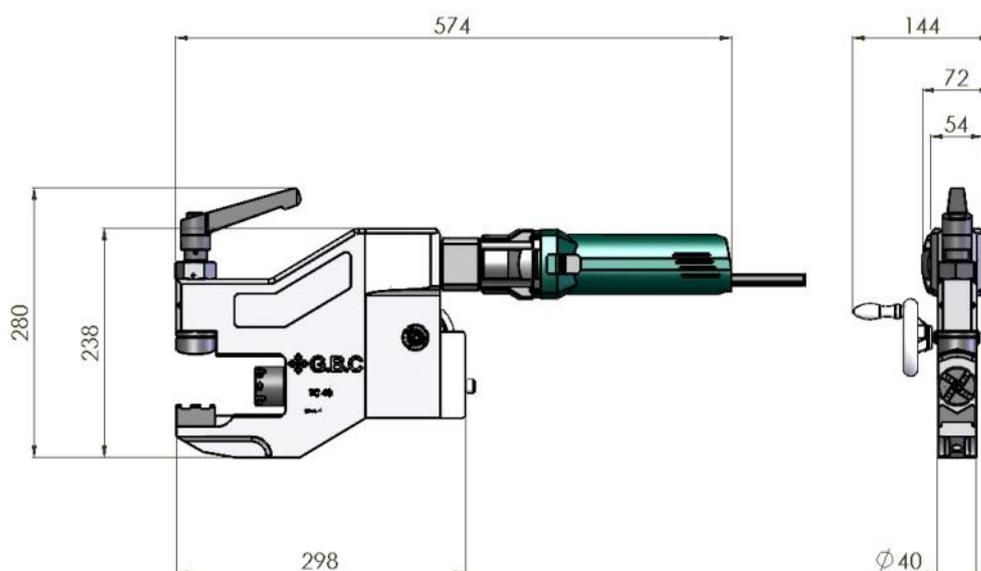


MACHINE DIMENSIONS

PNEUMATIC

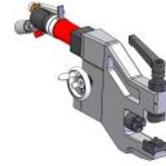


ELECTRIC



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Machine Standard Equipment

The machine is supplied with:

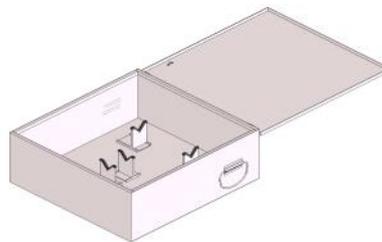
Series of 8 LOCKING JAWS (from 10.3 to 48.1mm)(every jaw is engraved with the specific locking capacity and must be chosen in relation of the pipe OD

- 2mm Allen Key
- 5mm Allen Key
- Case
- Instruction Manual
- Exploded Drawing

TC40



Case



Locking Jaws



Service Tools

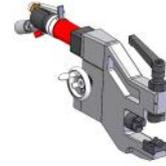


Instruction Manual



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SAFETY PRESAFETY 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 applied on the machine and/or on its case.
- Do not perform any maintenance operation when the machine is plugged to the power supply.
- Before every use, ensure the power supply connections to be conform to the specs given by our manual.

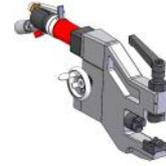
The authorized operator in any case will not have to disregard the basic safety rules such as:

- Using gloves and goggles (safety gear supplied by the company responsible for the site or for the building)
- To properly illuminate the working area
- Ensure you are operating in an area which grants free movements (at least 1,5 metres around the operator)
- Do not replace the control system and do not replace parts with non original spare parts, and do not project violent water squirts on the machine
- Keep the hands away from hot and sharpened parts.

G.B.C. Industrial Tools S.p.A. remarks that for any non specified circumstances it is necessary to obtain the authorization of the manufacturer.

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Using properly the safety gear entails the only risks to be generated by the user's system and not by inborn defects of our machines.

1. Always wear gloves and goggles during every operation
2. Any adjustment or inspection of the machine shall be done with the unit unplugged from the power source.
3. During the operations the hands shall be kept on the security valve and on the hand wheel.
4. The Use and Maintenance Manual as well as the drawings will always supply quick and adequate explanations.



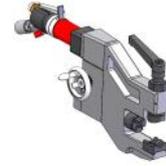
TRANSPORT RECOMMENDATIONS

Machine Weight	kg	10
Shipping Dimensions	mm	85x45x35
Shipping Weight	kg	28

Under 25 Kgs no lifting machines are required.

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MACHINE STABILITY

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

WORKPLACE

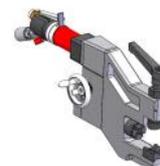
By always using both hands for operating the machine, the operator is unable to reach the bevelling tools as the unit would suddenly stop – motor brake –

EMERGENCY STOP INSTALLATION

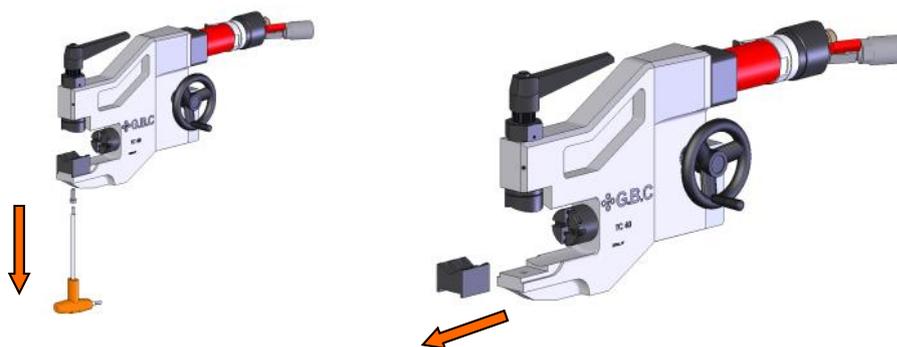
As provided for the paragraph 1.2.4.3. of the attachment 1 of the Machinery Directive, portable machines are exempt to have this feature.

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MACHINE SETUP



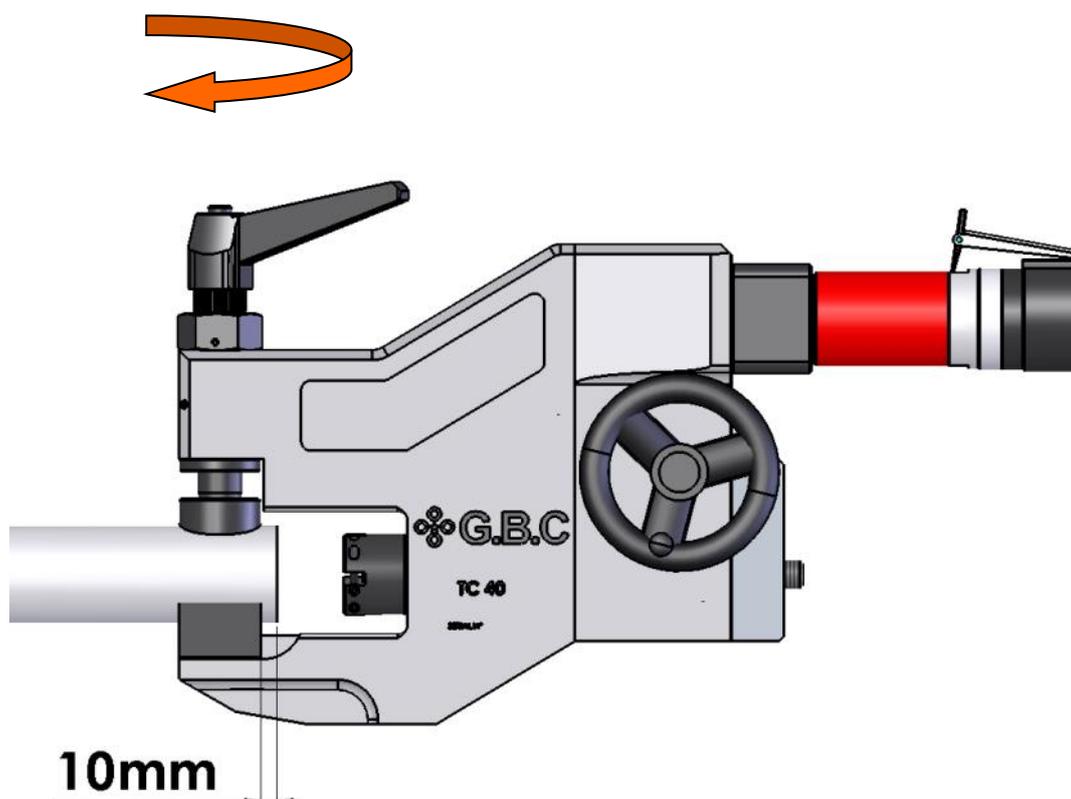
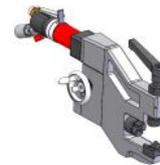
Remove the screw with the 6mm Allen Key and then remove the **LOCKING JAW**



Choose the appropriate **LOCKING JAW** in relation to the OD of the pipe you want to bevel and install it following the procedure in reverse

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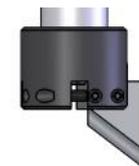
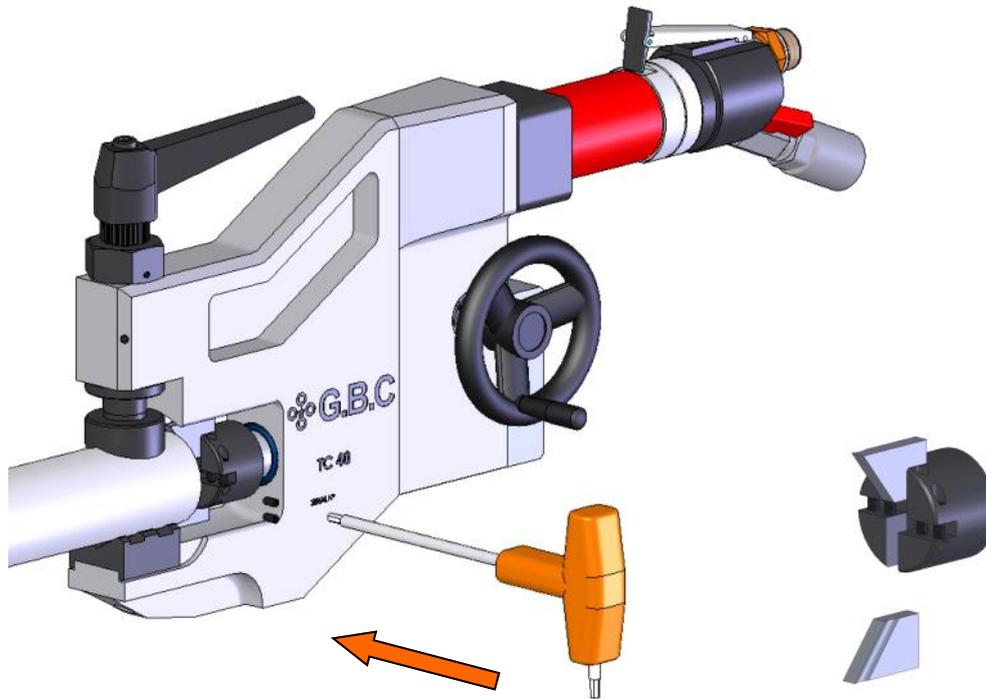
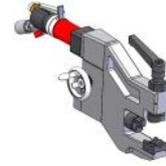


Locking the machine on the pipe:

- 1- Insert the machine so that the pipe end protrudes at least 10mm from the LOCKING JAW
- 2- Rotate the lever clockwise until the machine is properly locked.

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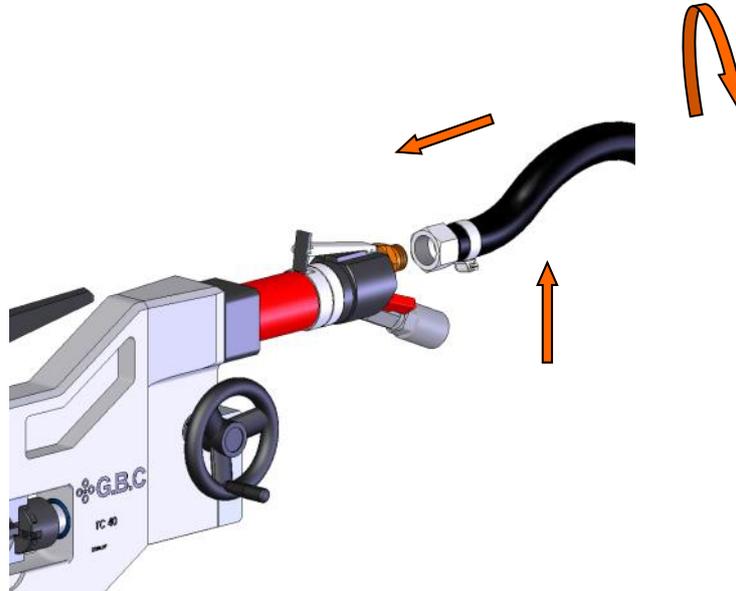
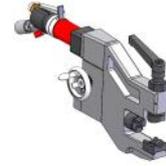
**SI !****NO !**

Select the beveling tool according to the bevel required and slide it into the chuck. Lock it in position with the two grub screws and the 2mm Allen key.

N.B.: When the tool is mounted, the tool profile must face outwards, and it is advisable to use two paired tools

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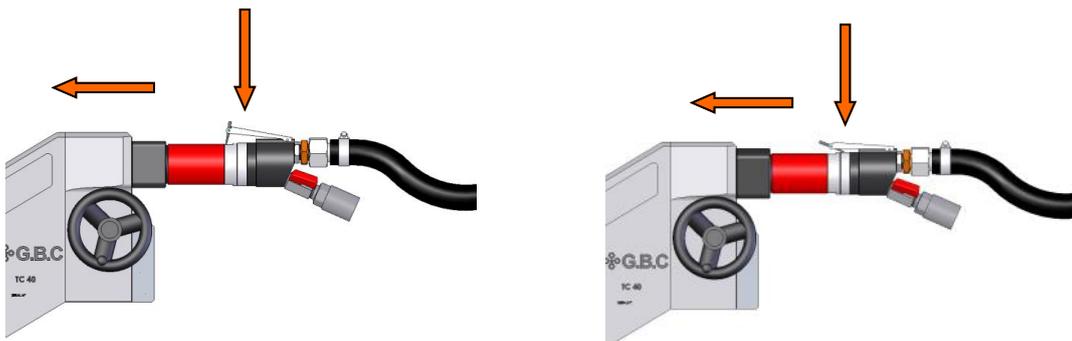
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Connect the machine to the air hose.

N.B.:ENSURE THAT THE AIR PRESSURE USED IS 6 BAR WITH AN AIR FLOW OF 1600 l/m

Hold the machine with one hand on the security switch and the other hand on the hand wheel.



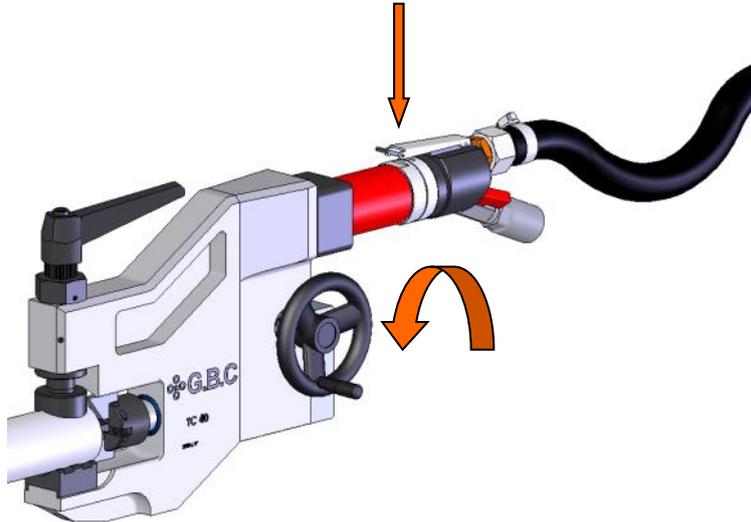
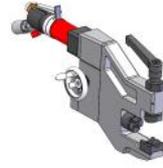
To start the machine press the button lever as shown in the above picture.

WARNING!

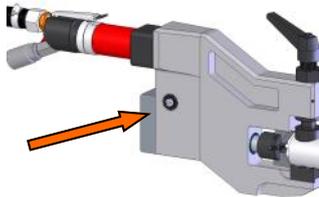
You will have to apply a constant pressure on the lever to keep the machine working.

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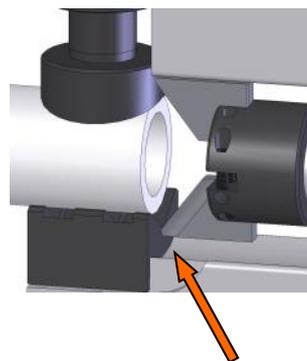
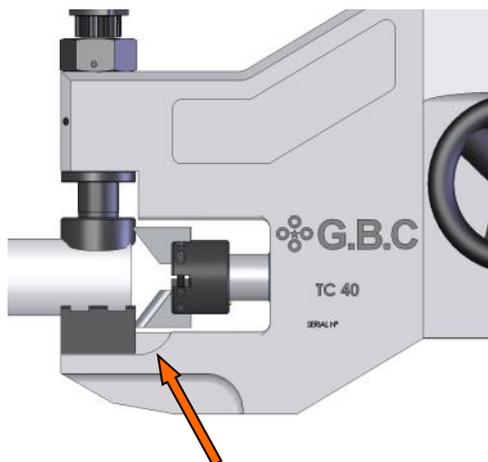
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The machine feeding is actuated by turning the hand wheel clockwise as shown in the picture. Maintain a constant and continuous action to obtain a uniform feeding.



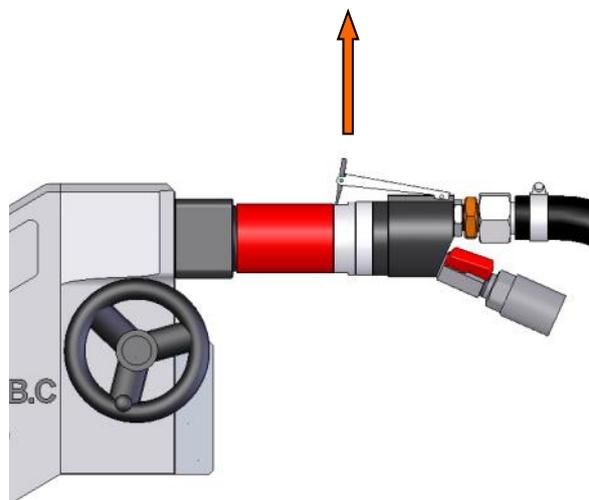
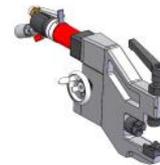
N.B.: THE HAND WHEEL CAN ALSO BE MOUNTED ON THE OPPOSITE SIDE OF THE MACHINE, IN RELATION TO YOUR WORKPLACE CONDITIONS



WARNING!
DO NOT LET THE TOOLS HIT THE LOCKING JAWS

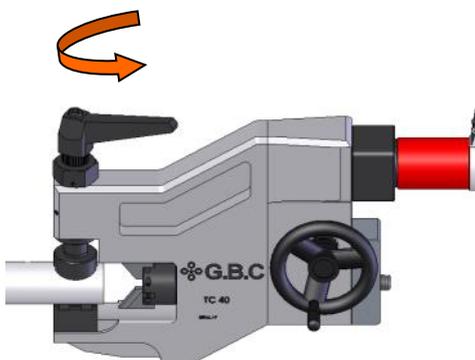
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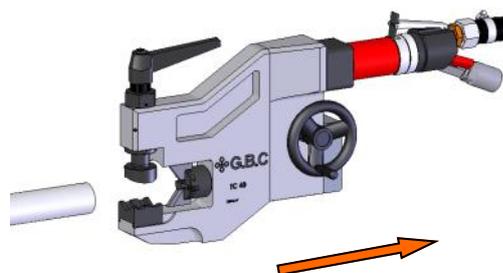


The machine will stop automatically as soon as the security lever is released.

Pic.1



Pic.2

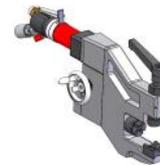


Removing the machine from the pipe:

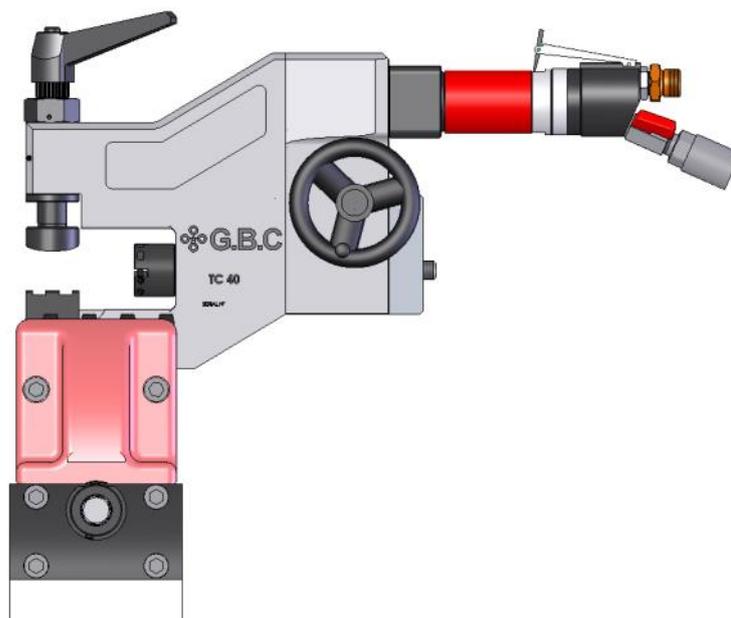
1. Rotate the lever counter-clockwise as shown in the Pic 1.
2. Remove the machine.

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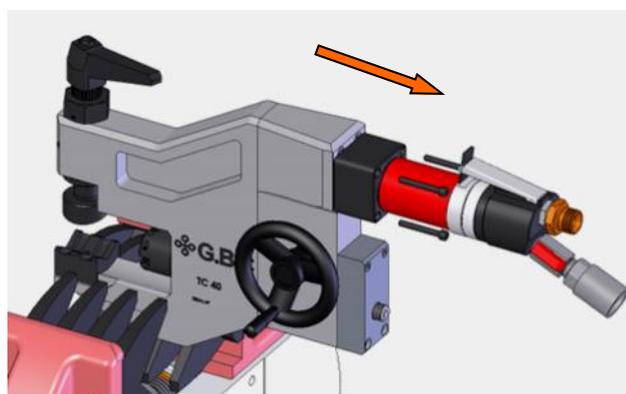
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Converting the machine from pneumatic to electric



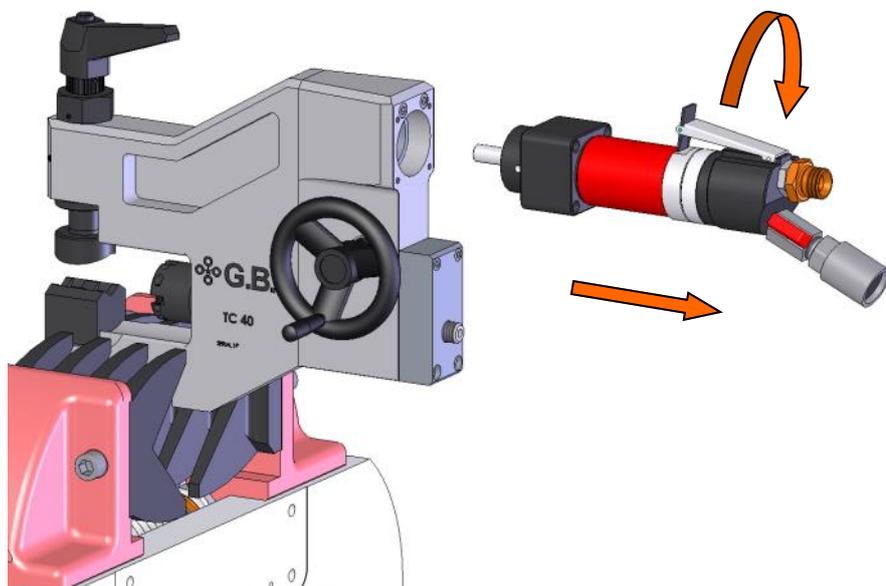
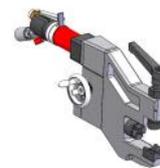
Clamp the machine body on an aluminum vice as shown in the above picture.



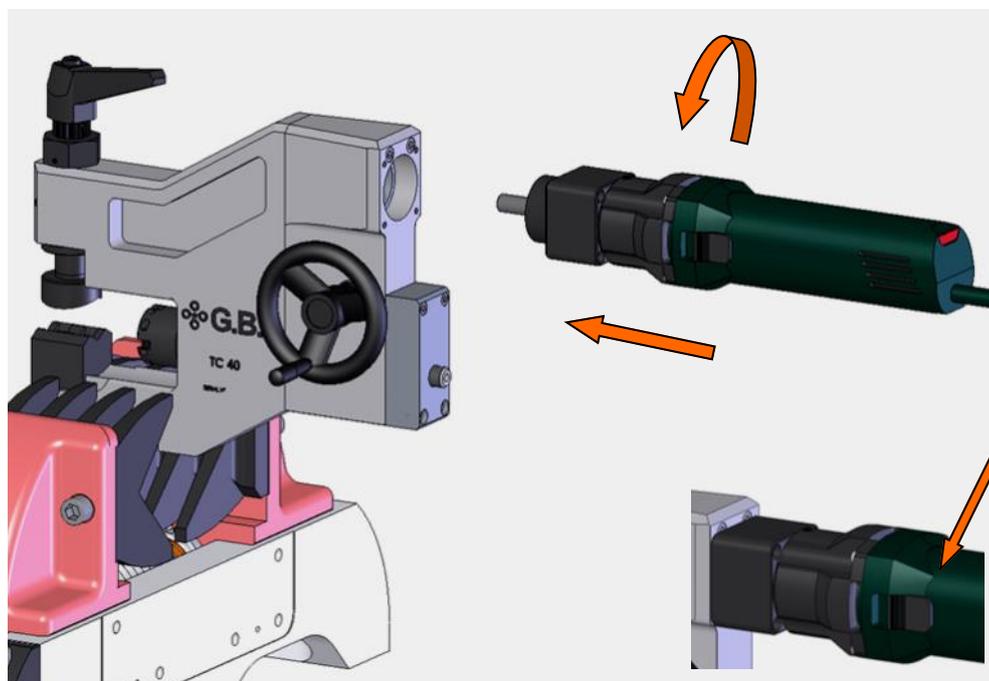
Unscrew and remove the 4 screws and washers.

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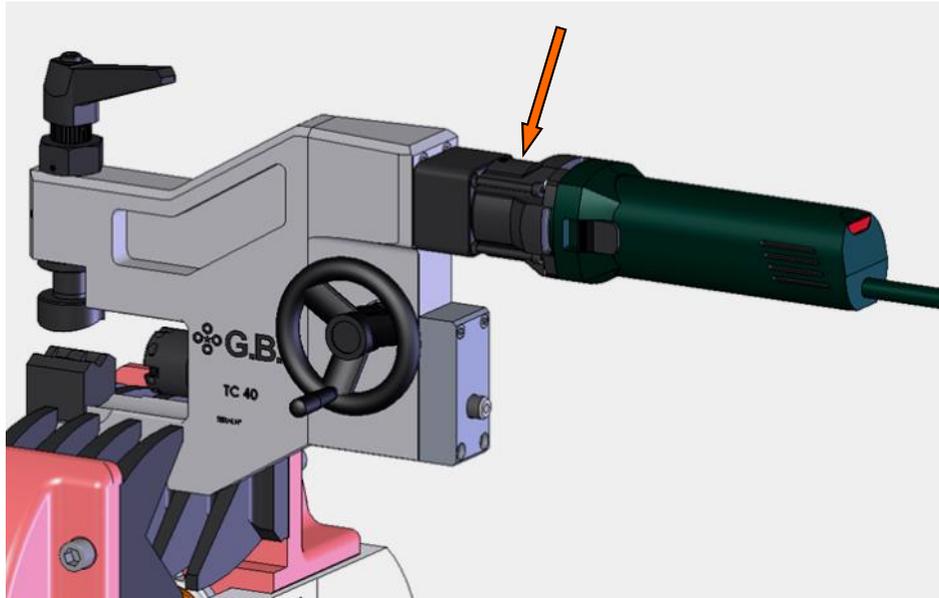
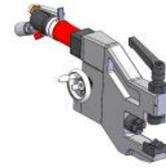
Grab the motor and pull it out with a rotatory motion until it comes out.



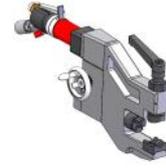
Insert the **ELECTRIC DRIVE KIT** in the machine body and fix it in position with the screws making sure it has been positioned as depicted in the picture.

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Lock the **ELECTRIC DRIVE ASSEMBLY** in position with the 4 screws



ORDINARY MAINTENANCE

We suggest to perform a service c/o G.B.C. Industrial Tools S.p.A. premises every 400 hours working cycles.

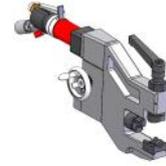
PERIODICAL CHECKS

- Verify the general conditions of the machine;
- Always use the filter + lubricator when using pneumatic machines
- Ensure the filter + lubricator is mounted the nearest possible to the machine and that the lubricant contained is supplied by G.B.C. Industrial Tools S.p.A. only.
- Perform a compressed air periodical cleaning on the threaded part of the guiding shaft and in the rear part of the machine.
- Always ensure that the seats of the tools on the chuck are clean
- Every 20 – 30 hours ensure the security valve has no air leaks
- Ensure no air leaks are present on the air supply system nearby the connection between the machine and the hose.
- Introduce some drops of gasoline or similar oily solvent in the air intake nipple of the pneumatic motor and start the machine in idle.
- Always use well sharpened tools to obtain the maximum result.

G.B.C. Industrial Tools is at your disposal for any information you may require about the above mentioned procedures and for any general clarification you may need.

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TROUBLESHOOTING AND ACOUSTIC EMISSION

The machine does not run : Check the power supply is connected and suitable in regard to the motor power consumption.

The machine does not 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.