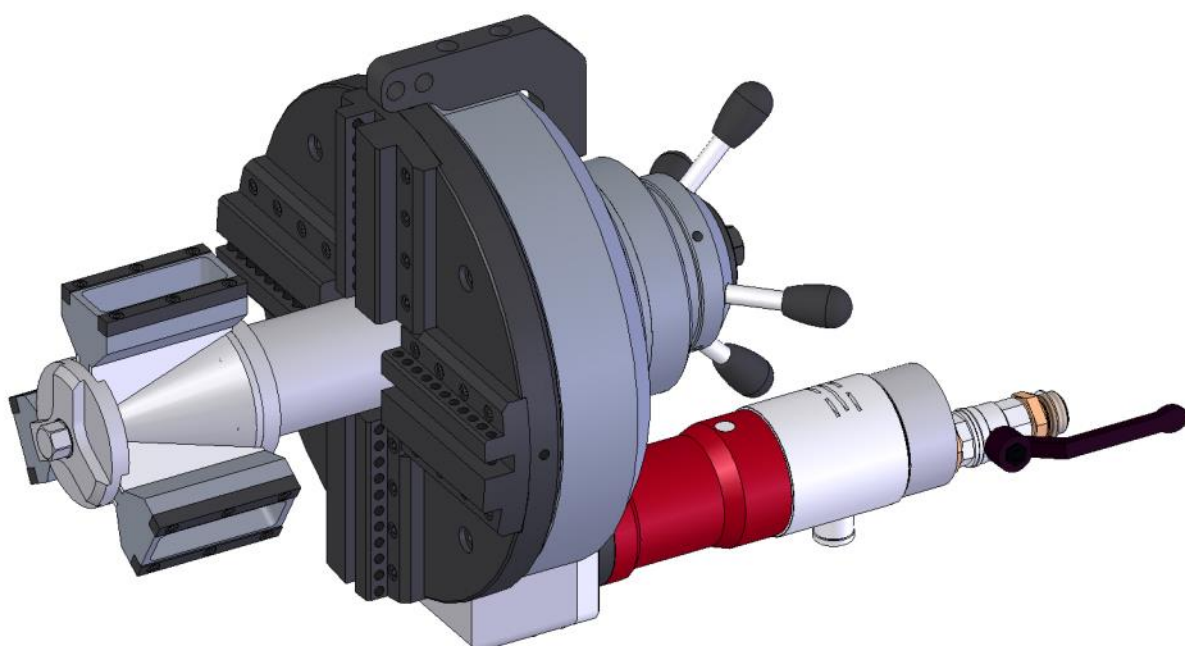




INSTRUCTION MANUAL



SUPERMAXI 4-16

G.B.C. Industrial Tools S.p.A.

Via Sandro Pertini 41/43 – 25046 Cazzago San Martino (Bs) – Italia – Tel. + 39 030 7451154 – Fax. + 39 030 73 56 629



SUPERMAXI 4-16

Original Instructions—rev.2015—in compliance with al 1.7.4 Machine Directive2006/42/1



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PRESENTATION OF THE COMPANY AND **INTRODUCTION TO THE INSTRUCTION MANUAL**

G.B.C. Industrial Tools S.p.A. is known worldwide for the quality of its machines and accessories for pipe cutting and beveling procedures of any sort and plate beveling machines..

The Headquarters are located in Cazzago San Martino (BS) where are currently operating the General Management, the sales de-department, as well as the main workshop and the shipping 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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WARRANTY GENERAL CLAUSES

G.B.C. Industrial Tools S.p.a. guarantees the reliability of the machine and its conformity to the specifications herewith reported. The warranty covers the machine in its whole for a time period of one year from the shipment date (ref. Delivery Note) for any flaw not imputable to the user.

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

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

And its Maintenance Service, hereinafter called **MSS**, will remedy this inconvenient free of charge, both for handwork and for eventual replaced parts, except when the malfunction is directly or indirectly imputable to misuse or alteration. In any case the machine must not be disassembled or altered before the shipment. The warranty is valid only when the warranty document is duly signed by **G.B.C. Industrial Tools S.p.a.** and by a G.B.C. official distributor connected with the **MSS** maintenance service.

The shipment of the defective material must be performed within 8 (eight) days from the notification of the defect and/or the claim and/or the request of technical assistance. On the contrary the warranty will be void. **G.B.C. Industrial Tools S.p.A.** and **MSS** obligations will cover the defect resolution, the general maintenance and the inspection of the parts subject of the claim only. The component replacement is at **G.B.C. Industrial Tools S.p.A.** discretion only. The shipment costs from and to the **MSS** as well as the direct and indirect costs rising from repair of the product are at user's charge. Any warranty repair or extraordinary repair must be executed by **G.B.C. Industrial Tools S.p.A.** and **MSS**, otherwise the warranty will be void.

Any ordinary maintenance performed by the customer/user or by any service centre not recognized or approved by **G.B.C. Industrial Tools S.p.A.** will not be refunded and will make the warranty void. The warranty is not valid for cases not listed in this certificate or for damage caused by a misuse of materials, power supply, negligence, unauthorized modifications, atmospheric events, acts of vandalism, incautious handling and/or transport, use of non original **G.B.C. Industrial Tools S.p.A.** parts and damage for causes not specified by **G.B.C. Industrial Tools S.p.A.** and for which **G.B.C. Industrial Tools S.p.A.** declines any responsibility. **G.B.C. Industrial Tools S.p.A.** reserves the right to modify and to improve its products without any obligation to modify equipment and components already supplied. Nobody is authorized to modify the conditions herewith contained or to issue any on behalf of **G.B.C. Industrial Tools S.p.A.** The claim terms for defects and/or damages in the material or of the ordered quantities, are those prescribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

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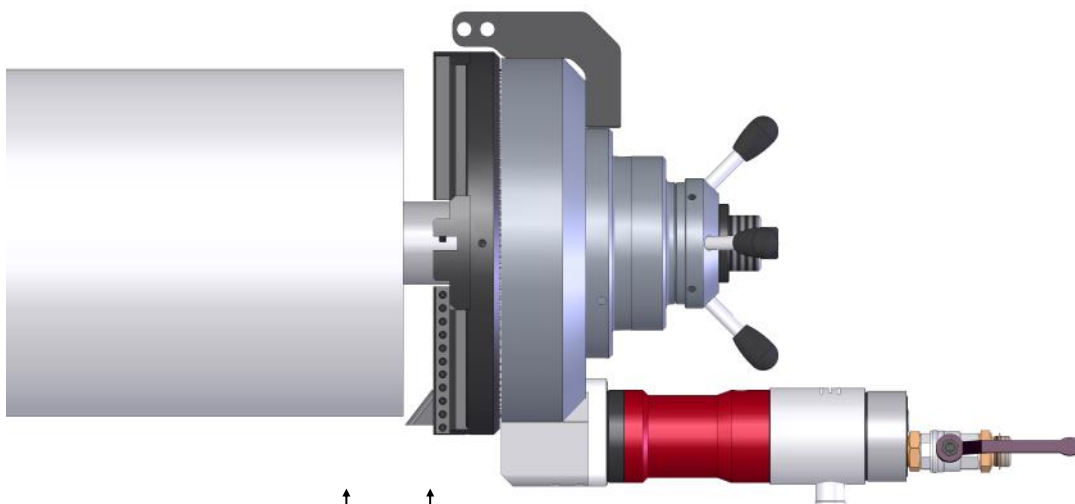
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INTENDED USE OF THE MACHINE

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 ID of the pipe



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

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

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

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

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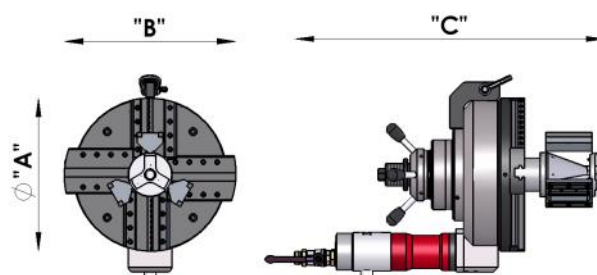
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TECHNICAL DATA

		PNEUMATIC	HYDRAULIC	ELECTRIC
Locking Range	mm	94,5 - 318,5	94,5 - 318,5	94,5 - 318,5
Idle Speed	rpm	17	17	14
Stroke	mm	50	50	50
Max Chuck Torque	Nm	1300 (6bar) 1650 (8bar)	2200	692
Pneumatic Motor Power	Hp (W)	2.85 (2100)	-	-
Air Consumption	NI/min (cfm)	1400 (49.43)	-	-
Air Pressure	Bar (psi)	6 ÷ 8 (87÷116)	-	-
Air Hose Connection	Pollici	3/4"	-	-
Hydraulic Motor Power	Hp (W)	-	6.8 (5000)	-
Max GBC Power Pack Pressure	Bar (psi)	-	130 (1885)	-
Oil Flow	L/min	-	30	-
Electric Motor Power	Hp (W)	-	-	2,95 (2200)
Tension	Volt	-	-	110/230
Frequency	Hz	-	-	50
Max Acoustic Emission	Db	75	75	75
Machine Weight	Kg	80	80	80



MACHINE DIMENSION

		PNEUMATIC	HYDRAULIC	ELECTRIC
Ø A	mm	330 (426 opt.)	330 (426 opt.)	330 (426 opt.)
B	mm	365 (475 opt.)	365 (475 opt.)	365 (475 opt.)
C	mm	750	610	630

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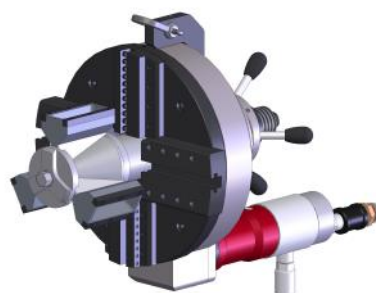
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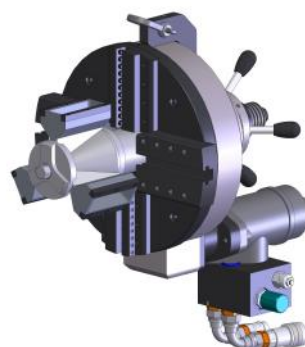


MACHINE CONFIGURATION MODELS

Pneumatic



Hydraulic



Electric



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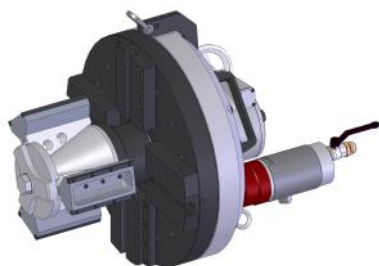


MACHINE STANDARD EQUIPMENT

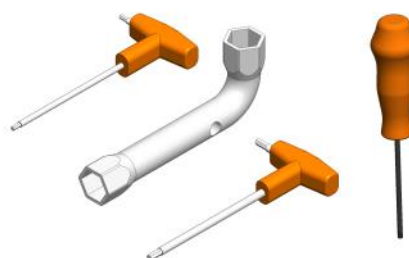
The machine is supplied with :

- Serie di alette completa 94.5 a 318.5 mm.
- 4mm Allen Key
- 5mm Allen Key
- 24mm Double Ended Hexagon Tubular Socket Wrench
- Torx Screwdriver Tx20
- Case
- Instruction Manual And Exploded Drawings.

SM4-16



Service Tools



Case



Instruction Manual And Exploded Drawings



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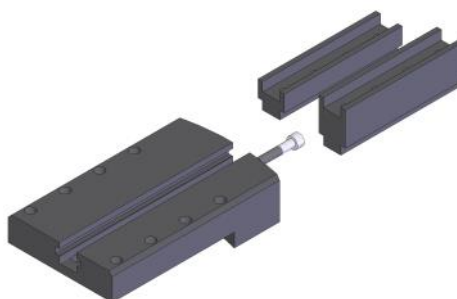
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OPTIONAL EQUIPMENT

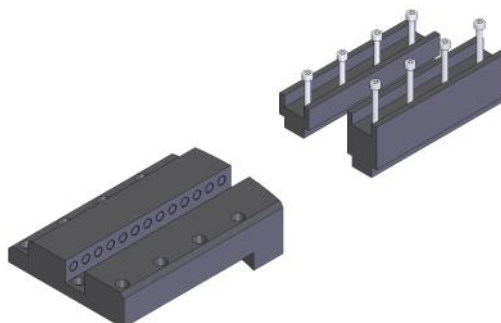
16” Extension Kit

Wedge Locking Tools.



16” Extension Kit

Grub Screws Locking Tools.



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SAFETY PRESCRIPTIONS

G.B.C. Industrial Tools S.p.A. designs and assembles its machines in strict compliance with the safety regulations provided by the applicable EC directives and by the Italian laws regulating this matter.

G.B.C. Industrial Tools S.p.A. declines any responsibility for misuse of its machines and their use when in contrast with the regulation listed hereinafter and with the use and maintenance instructions hereto.

- Carefully read ALL the following regulations and the instructions herewith attached before starting any operation.
 - Carefully ensure that the operator and the foreman using the machine are fully aware of all the regulations and all the instructions and that they are qualified to operate the unit.
 - Strictly attain to the indications given by the international symbols applies on the machine and/or on its case.
 - Do not perform any maintenance operation when the machine is plugged to the power supply.
 - Before every use, ensure the power supply connections to be conform to the specs given by our manual.
-
- The authorized operator in any case will not have to disregard the basic safety rules such as:
 - Using gloves and goggles (safety gear supplied by the company responsible for the site or for the building)
 - To properly illuminate the working area
 - Ensure you are operating in an area which grants free movements (at least 1,5 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

Weight of the Machine	kg	80	
Shipping Dimensions	mm	910x630x660	
Shipping Weight	kg	135	

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 cannot approach the tool while the machine is working.

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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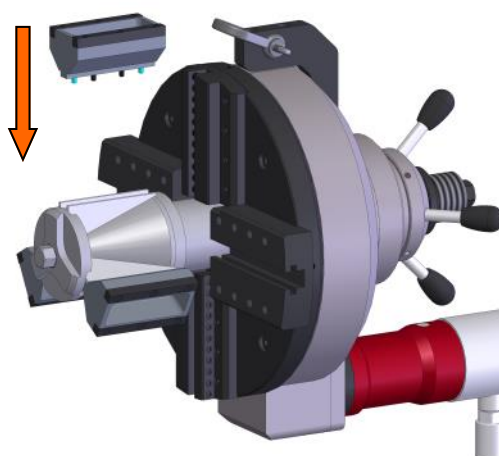
Original Instructions—rev.2015—in compliance with al 1.7.4 Machine Directive2006/42/1



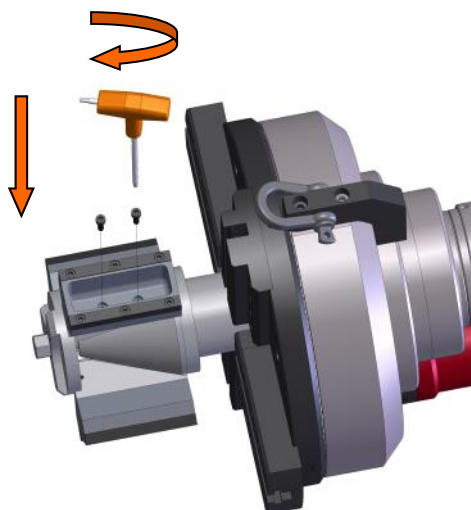
MACHINE SETUP FOR BEVELING



Before proceeding with the machine settning, verify the measure of the pipe you are going to bevel and select the most suitable locking segments.



Insert the locking segments in their seats.



Use the appropriate tool to fix the locking segments.

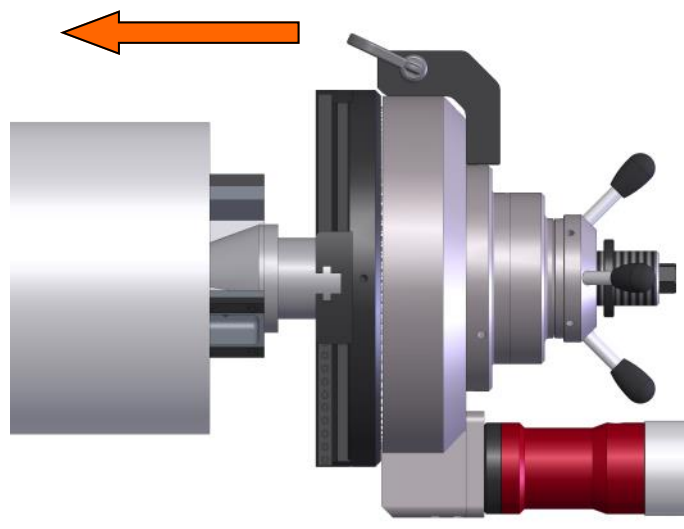
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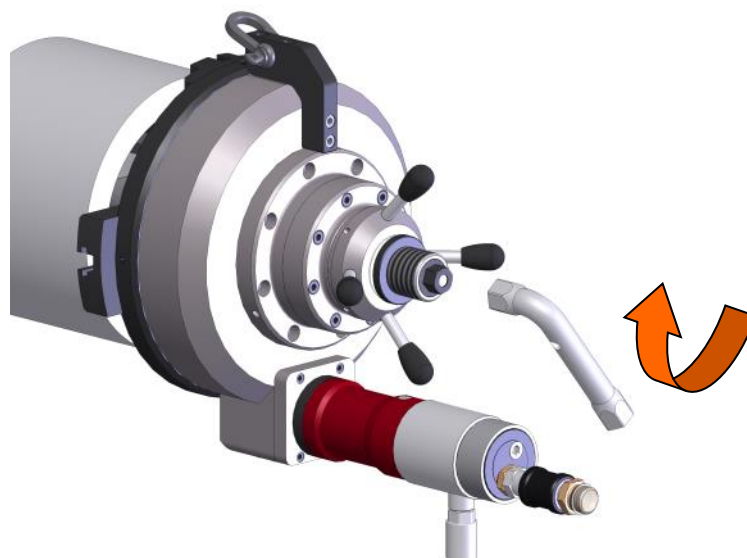


SUPERMAXI 4-16

Original Instructions—rev.2015—in compliance with al 1.7.4 Machine Directive2006/42/4



Position the machine inside the pipe.



Now you can lock the machine by using the appropriate wrench.

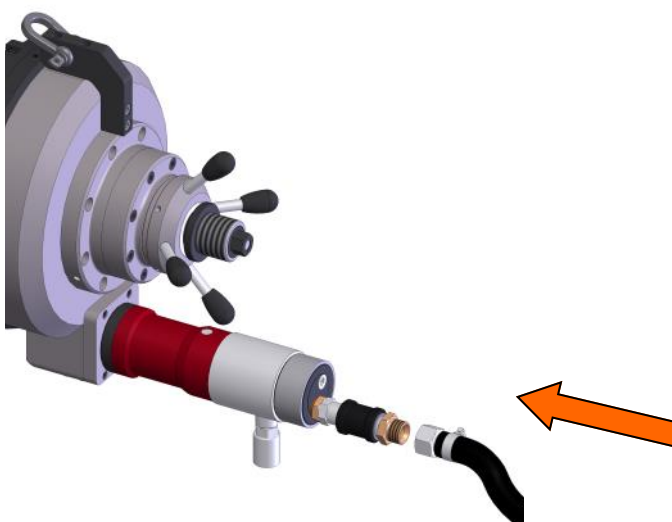
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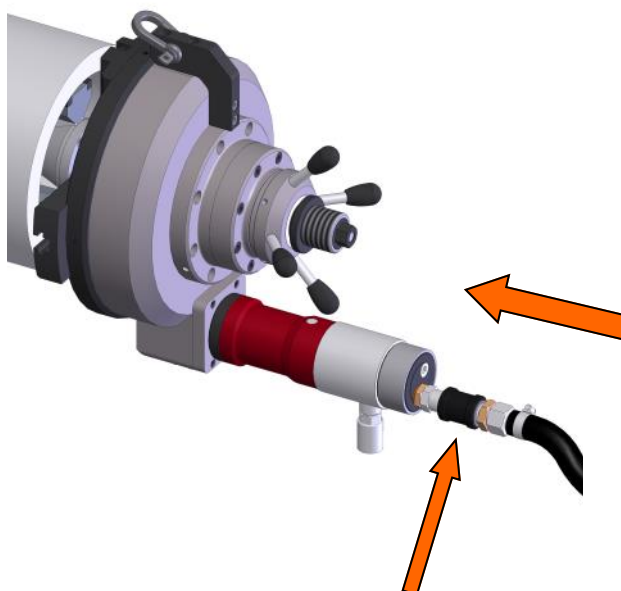


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Connect the air hose to the machine pneumatic motor.



Start the machine by acting on the air valve..

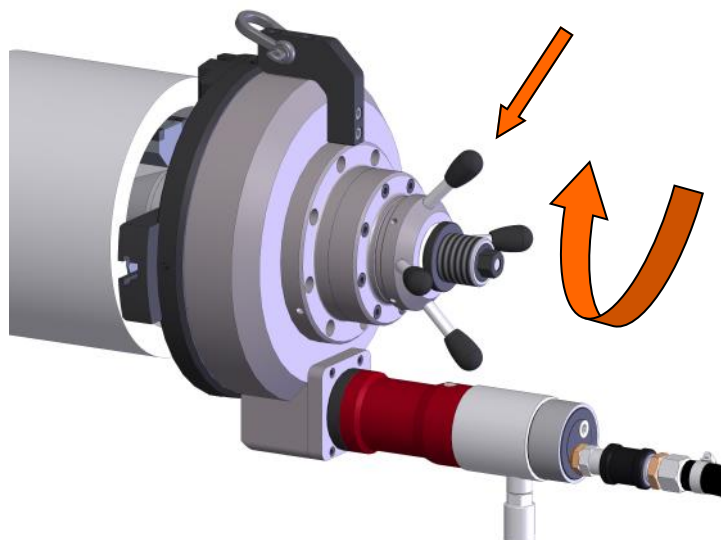
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By rotating the hand wheel, the chuck will advance forward and the machine will start working on the pipe..

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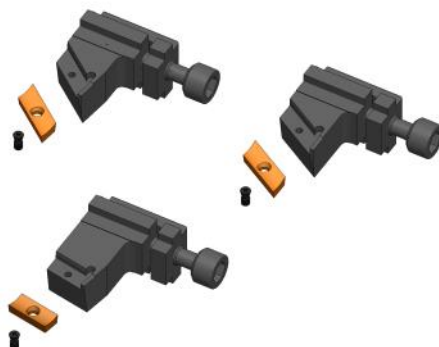


SUPERMAXI 4-16

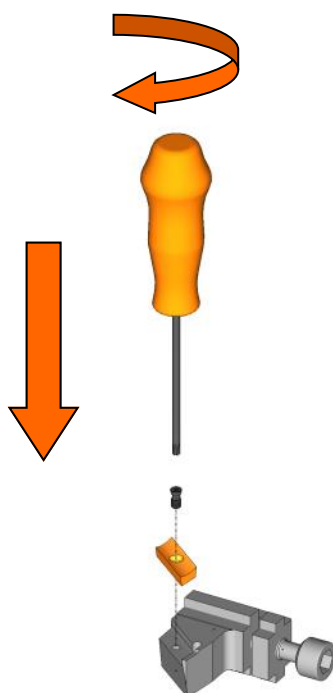
Original Instructions—rev.2015—in compliance with al 1.7.4 Machine Directive2006/42/4



TOOLS SETUP



Select the most appropriate wedge locking tools kit in relation to the job required.



By using the torx screwdriver supplied with the machine, fix the tip onto the tool holder.

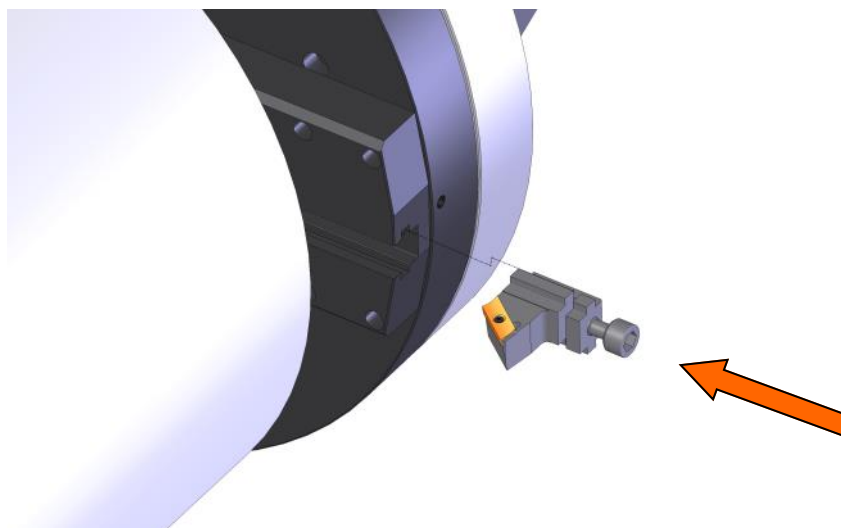
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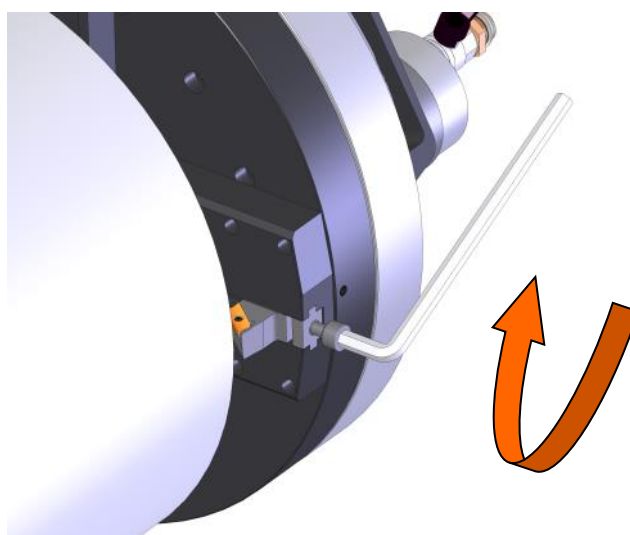


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Insert the conical locking tool kit in the appropriate T-shaped seat as shown in the above picture.



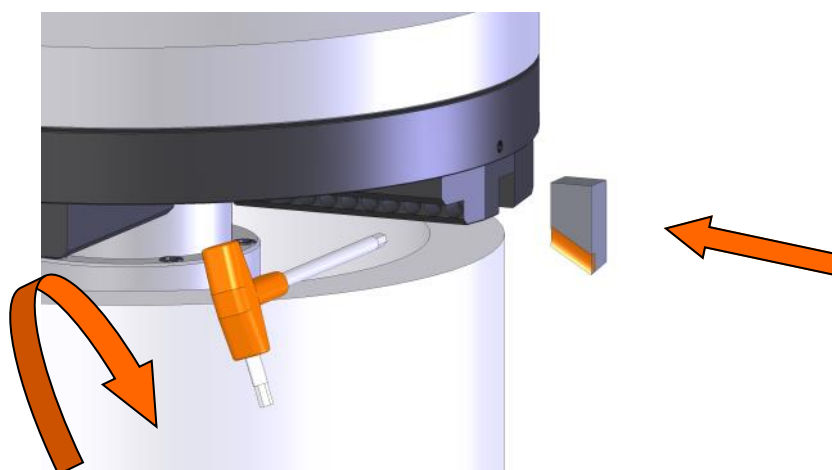
Place the conical locking tool kit in the proximity of the tube edge to be beveled and fasten the fixing screw using the allen key supplied with the machine. The wedge locking system will grant a perfect stability.

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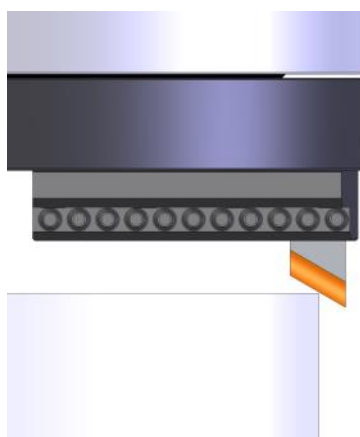


TOOLS SETUP

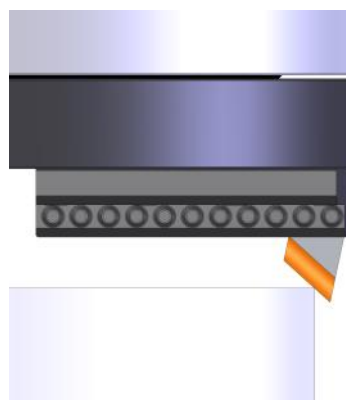


Select the tool in relation to the job required and position it in the appropriate seat located on the chuck, locking it with the grub screws using the allen key supplied with the machine.

N.B. Ensure that at least two grub screws are gripping on the tool.



Posizione utensile CORRETTA.



Posizione utensile ERRATA.

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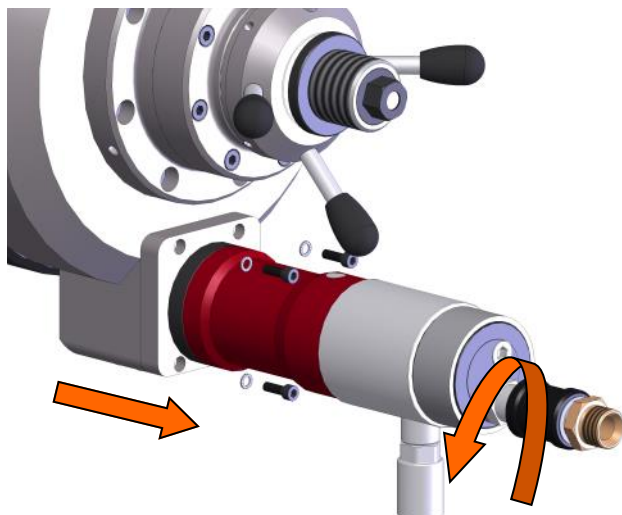


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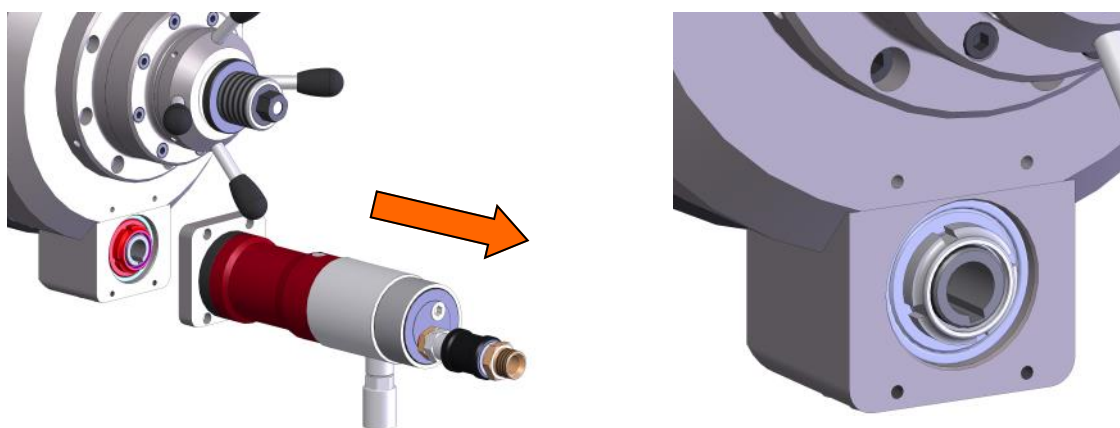
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DRIVE KIT REPLACEMENT



Remove the four screws and washer using the appropriate allen key.



Pull out the Drive Kit.

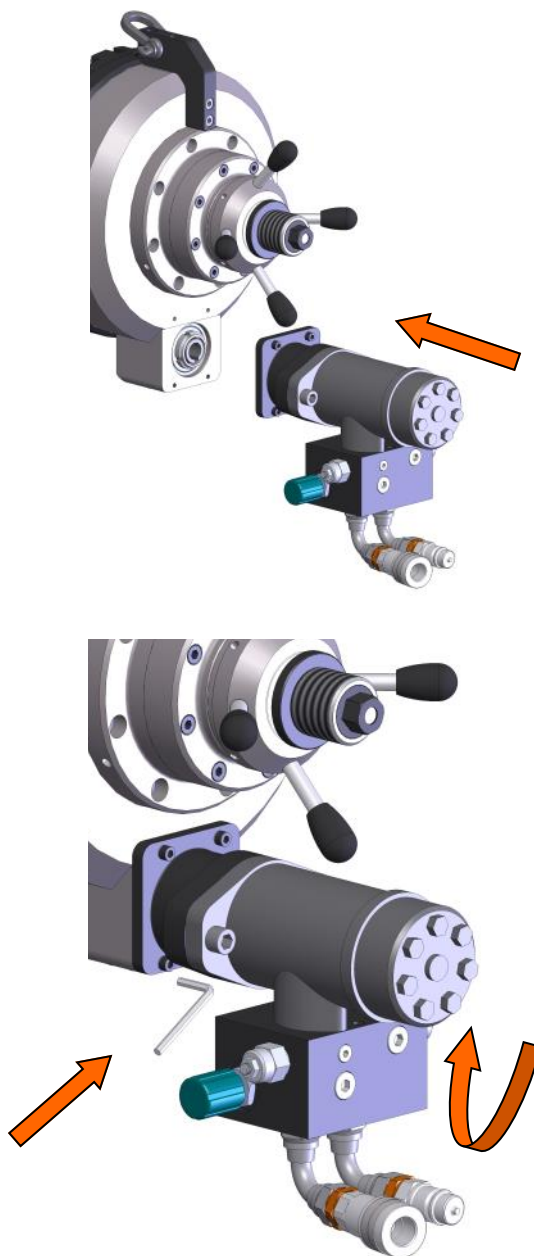
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Insert the hydraulic Drive Kit and fix it to the flange by using the appropriate allen key supplied with the machine.

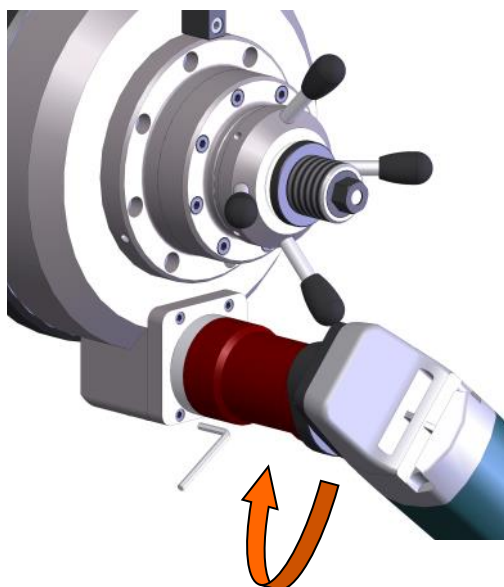
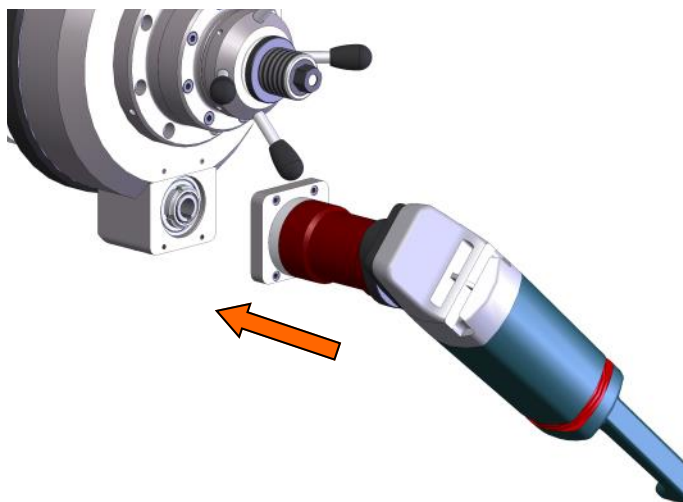
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Insert the hydraulic Drive Kit and fix it to the flange by using the appropriate allen key supplied with the machine.

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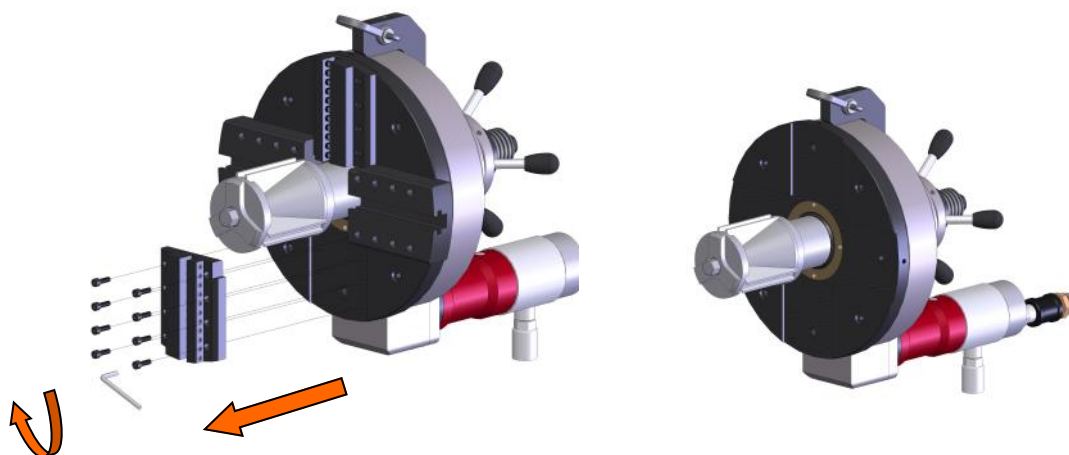


SUPERMAXI 4-16

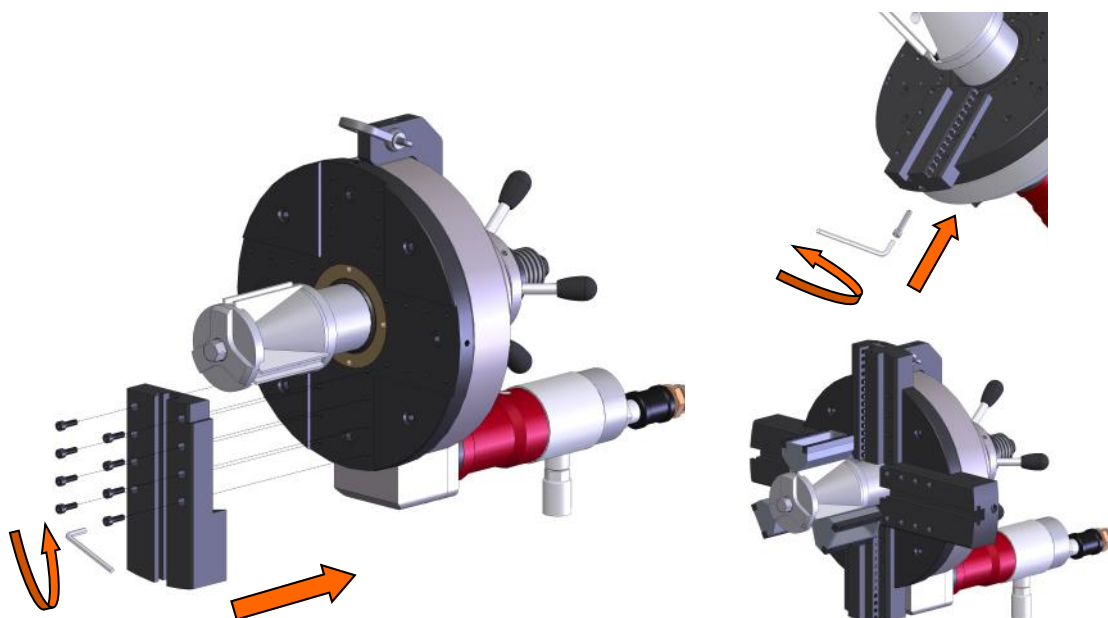
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16"EXTENSION KIT ASSEMBLY



Remove the 4 tool holders by using the allen key supplied with the machine.



Install and fix the 4 16" extensions fixing the screws with the allen key supplied with the machine.

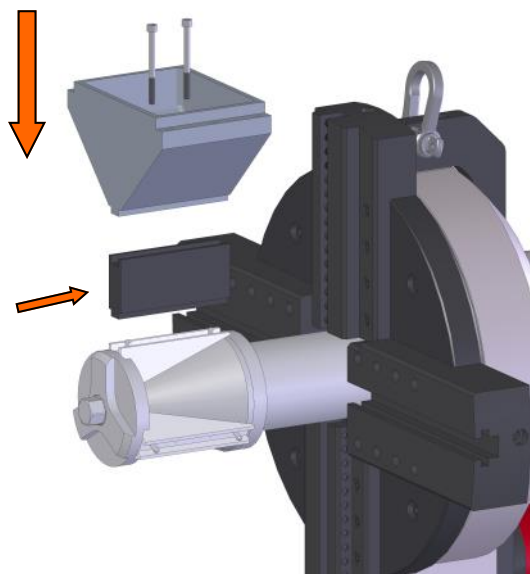
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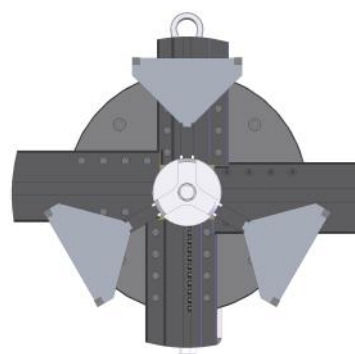
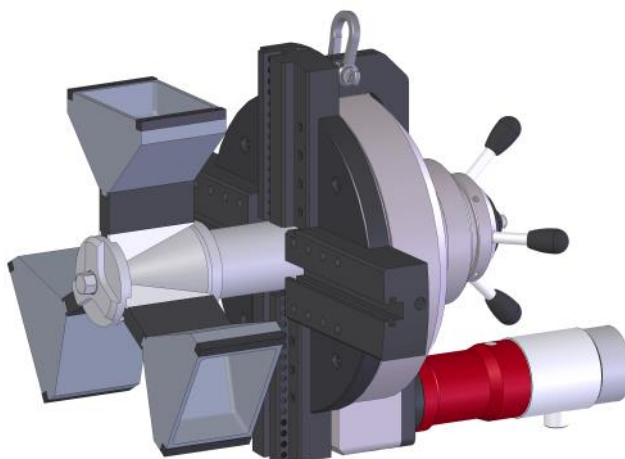


SUPERMAXI 4-16

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Locate the 3 extensions of the size required to lock the pipe ID, and install them on the shaft.
N.B.: All the extensions part of this kit have to be used exclusively with the biggest size of locking jaws (Part N#1374007), which is part of the standard jaws kit supplied with the machine.



G.B.C. Industrial Tools S.p.A.

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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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Periodical Checks

**THE MOVING PARTS OF THE MACHINE SHOULD BE ALWAYS MAINTAINED LUBRIFIED AND THE THRUST BEARING SHOULD BE MAINTAINED GREASED.
THE THRUST BEARING SHOULD BE LUBRIFIED IN RELATION TO THE WORKING HOUR SUBSTAINED BY THE MACHINE.**

The commonly used greases are lithium based (Ep)and correspond to these standards:

DIN 51825 K2K - 20

ISO L-X-BCHA2

You can also use equipollent greases. The working temperatures are included between -20° C and + 120° C.

Working at lower temperature will involve the utilization of special greases.

The below chart shows some of the greases utilized:

GREASES	
BRAND	NAME
ESSO	BEACON EP2
MOBIL	MOBILUX EP2
AGIP	GRMU EP2
SHELL	CALITHIA EP2

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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.

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