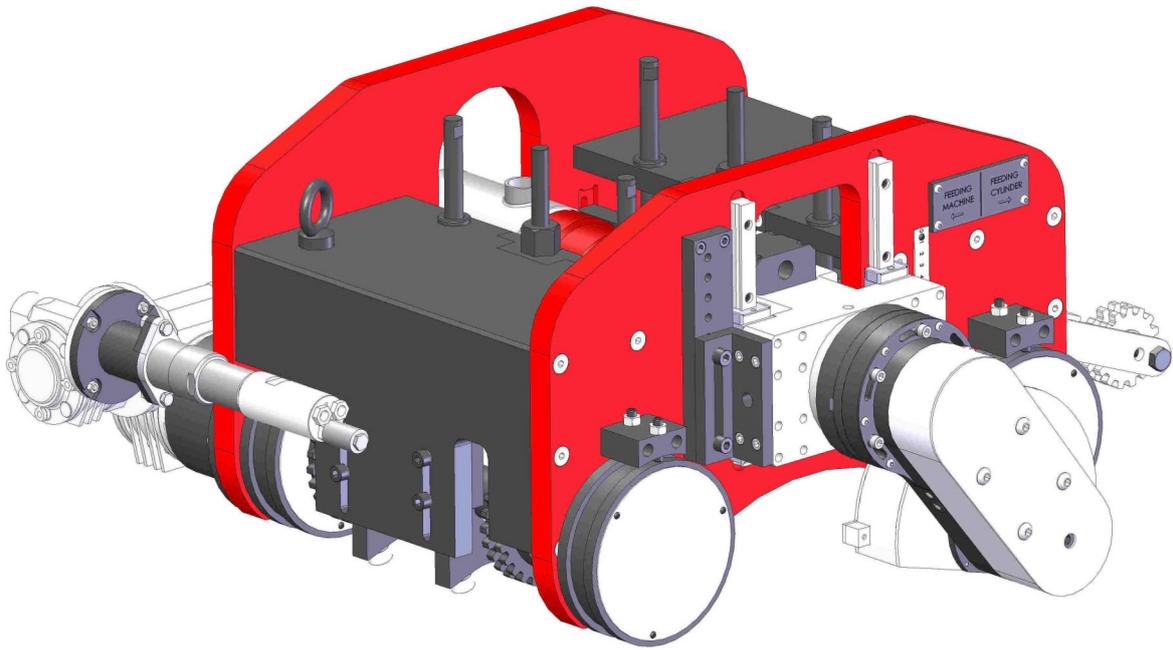




INSTRUCTION MANUAL

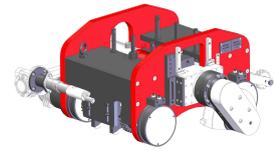


TAF (PNEUMATIC)

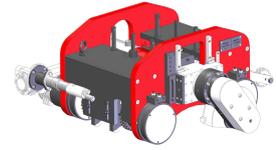
Versione 00-2017

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

Via Sandro Pertini 41/46 – 25046 Cazzago S.Martino (BS) – Italia – Tel. + 39 030 7451154 – Info: sales@gbcspa.com



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FOREWORD

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 Torbiato di Adro – Italy prior to proceed with any modification on the machine.

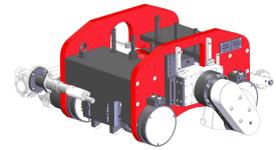
You are invited to scrupulously adhere to the information written on the identification tag.

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. 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.**.

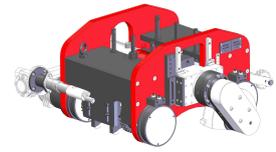
In case of any operational malfunction arising during the warranty period, **G.B.C.** And its Maintenance Service, hereinafter called **MSS**, will remedy this inconvenient free of charge, both for handwork and for eventual replaced parts, except when the malfunction is directly or indirectly imputable 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.** 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.** 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.** discretion only. The shipment to 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.** and **MSS**, otherwise the warranty will be void.

Any ordinary maintenance performed by the customer/user or by any service centre non recognized or approved by **G.B.C.** 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.** parts and damage for causes not specified by **G.B.C.** and for which **G.B.C.** declines any responsibility. **G.B.C.** 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.** The claim terms for defects and/or damages in the material or of the ordered quantities, are those pre-scribed by the Civil Code; the goods acceptance entails the buyer to automatically accept the above mentioned warranty clauses.

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

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USE OF THE TAF

THE TAF SHOULD BE OPERATED ONLY BY TRAINED PERSONNEL

IN VIEW OF A SPECIFIC EDUCATION ON THE USE OF THE MACHINE WE DO NOT ADVISE AGAINST ANY SPECIFIC MISUSE OF THE TAF.

The TAF represents a definitive evolution in the field of large diameter pipe cutting and beveling granting the advantages listed below:

- Processing time reduction.

- No chemical alteration of the material at the cut/beveling point thanks to the cold cut/beveling technique.

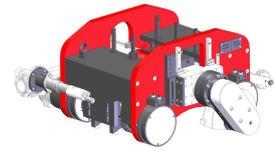
- Uniform processing thanks to the guiding belt.

- Improvement of the working conditions and of the safety.

- Use of a single machine for working the majority of pipe diameters.

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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.

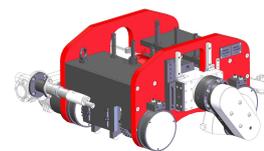
The authorized operator in any case will not have to disregard the basic safety rules such as:

- 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
- Maintain a safety distance from all the moving 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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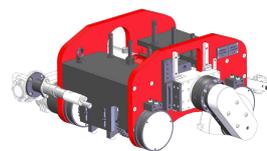


SAFETY PRESCRIPTIONS (SPECIFIC FOR THE TAF)

- PROTECTIVE GOGGLES AND GLOVES MUST BE WORN AT ANY TIME DURING ANY OPERATION PERFORMED WITH THE TAF.
- EAR PROTECTION MUST BE USED DURING ANY CUTTING BEVELLING SESSION.

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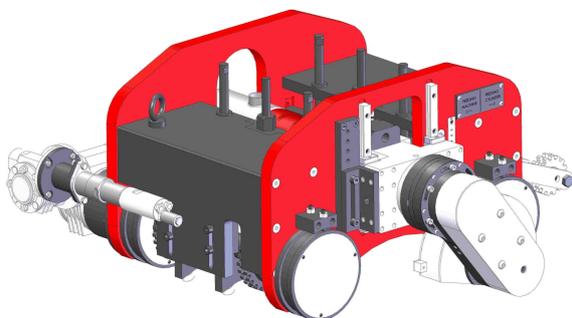


TAF STANDARD EQUIPMENT

La macchina viene fornita al cliente corredata di:

- 16" Guiding Belt
- 16" Feeding Chain
- PVC Hammer
- 2mm Allen Key
- 3mm Allen Key
- 4mm Allen Key
- 5mm Allen Key
- 5mm Allen Key with Handle
- 6mm Single Open end wrench
- 8mm Allen Key
- 10mm Allen Key
- 10mm Single Open end wrench
- 13mm Single Open end wrench
- 14/17mm Double Open end wrench
- 24/27mm Double Open end wrench
- 38mm Single Open end wrench
- 27mm Hex tubular socket wrench
- Long nose pliers
- Template for machine positioning
- Instruction Manual
- Drawings

TAF



GUIDING BELT



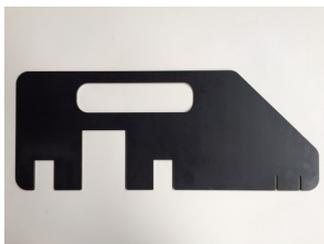
FEEDING CHAIN



SERVICE TOOLS



TEMPLATE FOR POSITIONING

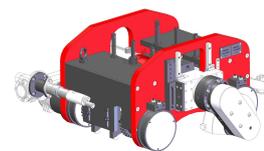


INSTRUCTION MANUAL



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TECHNICAL SPECIFICATIONS

TECHNICAL SPECS AND PERFORMANCE	UNIT OF MEASURE	VALUE
Main Motor Power	KW	3.1
Traction Motor Power	KW	0.160
Total Power	KW	3.260
Total air consumption	l/min	3000
Max pressure	bar	8
Ø160 cutting saw blade rotation speed	RPM (min/max)	75
Ø140 beveling saw blade rotation speed	RPM (min/max)	75
Machine feeding speed during cutting phase	mm/min (min/max)	75
Cutting depth in beveling configuration	mm	50
Bevel Angle α	°	0 ÷ 37°30'
Continuous noise during operation @ 5mt distance Max noise peak @ 5mt distance	(dB A) (dB B)	70÷75 80÷85
Machine Weight	Kg	150
Cutting Head Weight	Kg	9

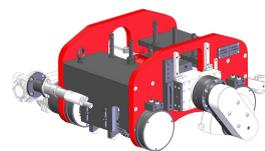
NOTES:

G.B.C. Industrial Tools S.p.A. declares that every machine is tested on steels commonly used in mechanical and metal work fabrication with 30mm wall thickness. The figures listed in the above chart are detected by a phonometer certified by an acoustic calibrator model DELTA HOM HD 9102 certificato LAT (former SIT) N. SIT 03229/09 and we confirm the figures recorder are in compliance with the regulation EN 60745.

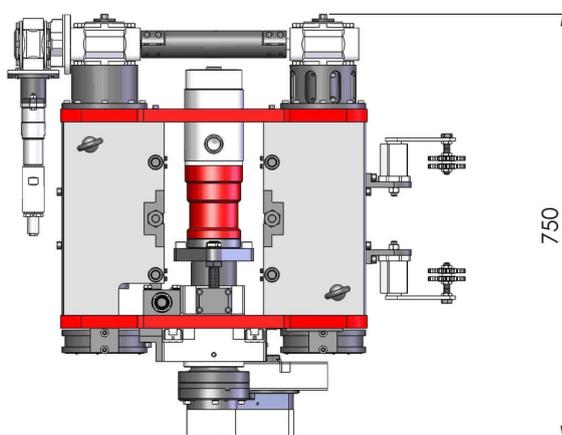
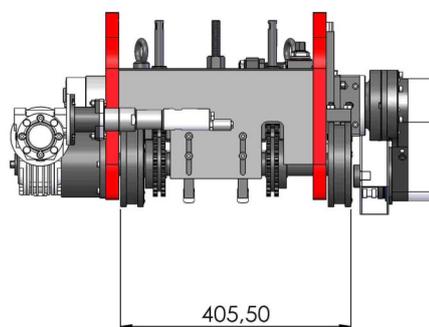
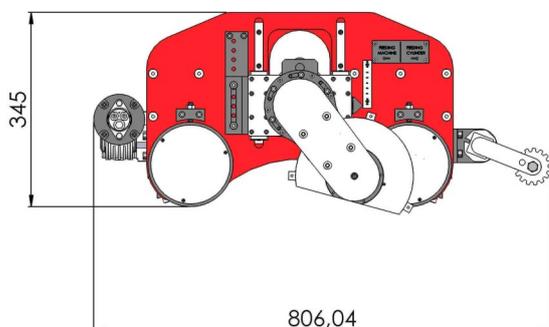
Therefore following the evaluation of the environmental risks on the workplace, regulated by the law decree 81/08 and following modifications, in compliance with the directive 2003/10/CE, and of the art.190

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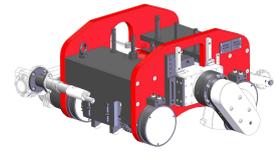


OVERALL DIMENSIONS



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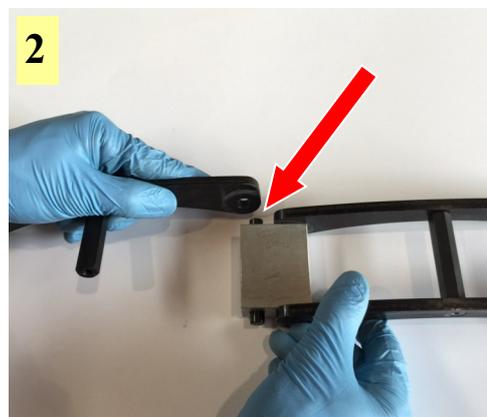
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TAF SETUP (Guiding Belt)

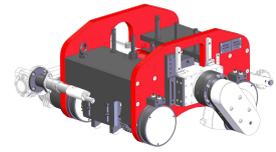
N.B. The guiding belt is supplied preassembled sectors as shown below and the specific length required can be obtained by following the chart contained in this manual.

- 1) Loose and remove the central screw that joins the two bars of the sector as shown in the picture below.
- 2) Connect the bar of the spacer to the pin of connecting block .



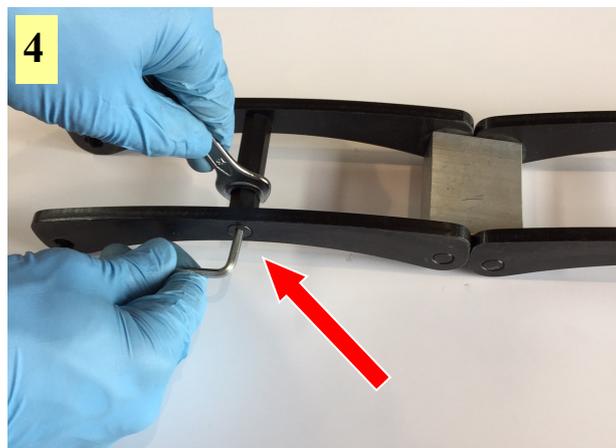
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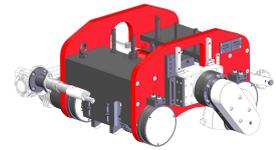
- 3) Connect the other bar to the other side of the block following the same procedure like shown in the picture below.
- 4) Screw back the bars together to recreate the sector. Make sure the screw is securely fastened.

N.B. Repeat the same operation until you have reached the desired length of the belt.



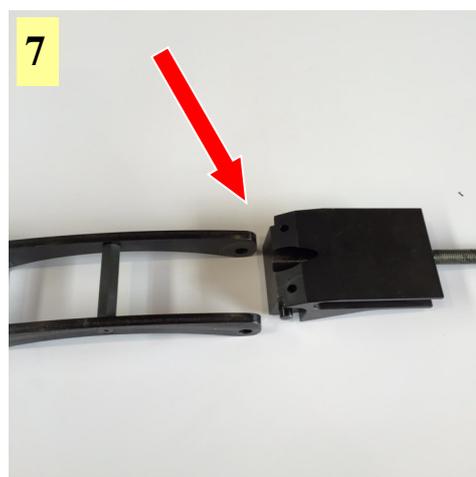
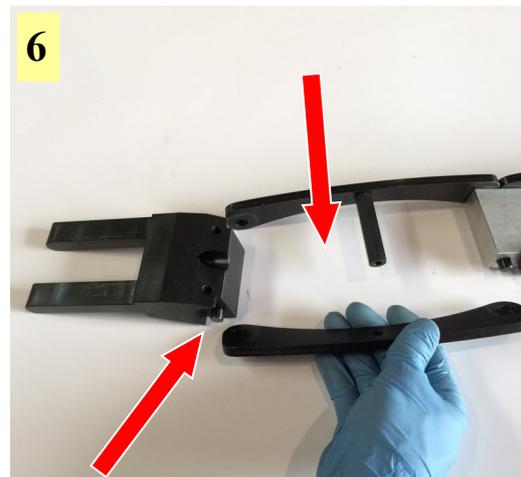
G.B.C. Industrial Tools S.p.A.

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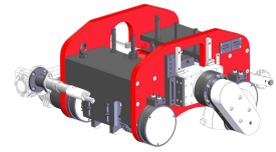
- 5) Retrieve traction joint from the guiding belt kit supplied with the machine.
- 6) Connect one of the two halves of the joint onto one end of the guiding belt by following the same procedure described earlier for assembling the belt.
- 7) Connect the other half of the joint onto the other end of the belt.

N.B. Repeat this operation until you have reached the desired length of the guiding belt.



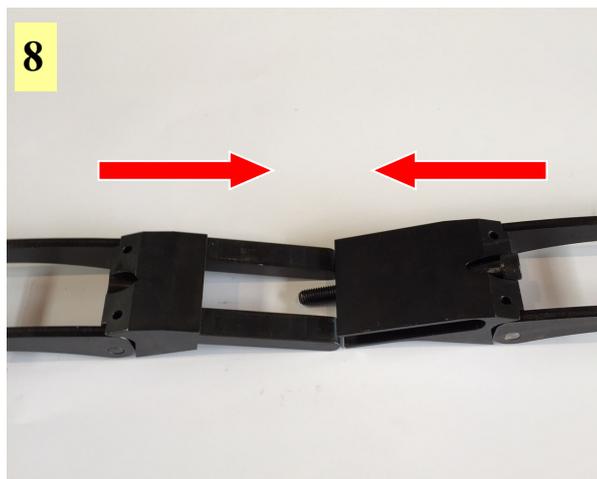
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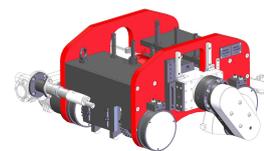
- 8) Retrieve the traction joint from the guiding belt kit.
- 9) The guiding belt coupling is achieved by wedging the two ends and by fastening the central screw with the appropriate Allen key until the parts are securely fastened as shown in the picture below.

N.B. Depending by the guiding belt length may be required several traction joints which will have to be assembled according to the instructions given in the chart on page 15.



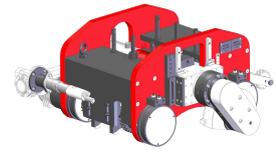
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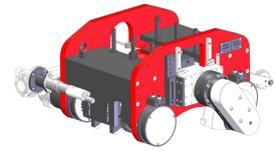
GUIDING BELT SECTORS ENCODING

Center-to-center distance (mm)	Guiding Belt Sectors Encoding
200	A
175	B
145	C
110	D
75	E
65	F



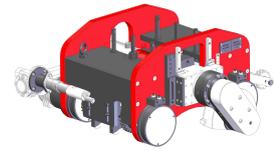
16" TO 42" GUIDING BELT COMPOSITION

Pipe diameter	Chain composition	Number of Sectors
16"	4A+2D+1 TRACTION JOINT	5
18"	6A+1 TRACTION JOINT	5
20"	6A+D+1 TRACTION JOINT	6
22"	7A+F+1 TRACTION JOINT	7
24"	8A+1 TRACTION JOINT	7
26"	8A+C+1 TRACTION JOINT	8
28"	9A+E+1 TRACTION JOINT	9
30"	9A+E+2 TRACTION JOINT	8
32"	10A+2 TRACTION JOINT	8
34"	10A+B+2 TRACTION JOINT	9
36"	11A+D+2 TRACTION JOINT	10
38"	12A+F+2 TRACTION JOINT	11
40"	13A+2 TRACTION JOINT	11
42"	13A+C+2 TRACTION JOINT	12



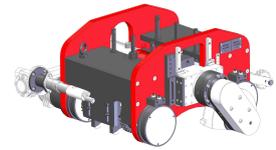
44" A 84" GUIDING BELT COMPOSITION

Pipe diameter	Chain composition	Number of Sectors
44"	14A+E+2 TRACTION JOINT	13
46"	15A+2 TRACTION JOINT	14
48"	15A+B+2 TRACTION JOINT	15
50"	16A+D+2 TRACTION JOINT	16
52"	17A+F+2 TRACTION JOINT	16
54"	18A+2 TRACTION JOINT	17
56"	18A+C+2 TRACTION JOINT	18
58"	19A+F+2 TRACTION JOINT	18
60"	20A+2 TRACTION JOINT	19
62"	20A+B+2 TRACTION JOINT	19
64"	21A+D+2 TRACTION JOINT	20
66"	22A+F+2 TRACTION JOINT	21
68"	23A+2 TRACTION JOINT	21
70"	23A+C+2 TRACTION JOINT	22
72"	24A+F+2 TRACTION JOINT	23
74"	25A+2 TRACTION JOINT	23
76"	25A+C+2 TRACTION JOINT	24
78"	26A+E+2 TRACTION JOINT	25
80"	27A+2 TRACTION JOINT	25
82"	28A+2 TRACTION JOINT	26
84"	28A+D+2 TRACTION JOINT	27



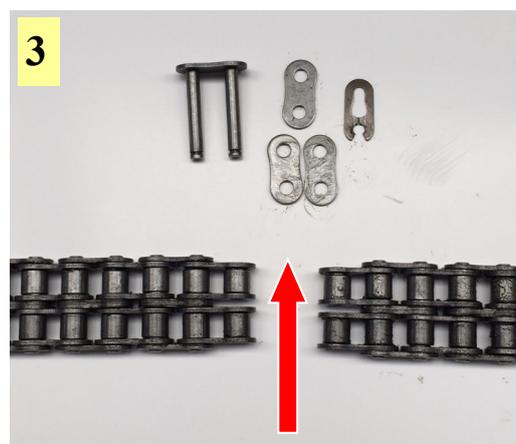
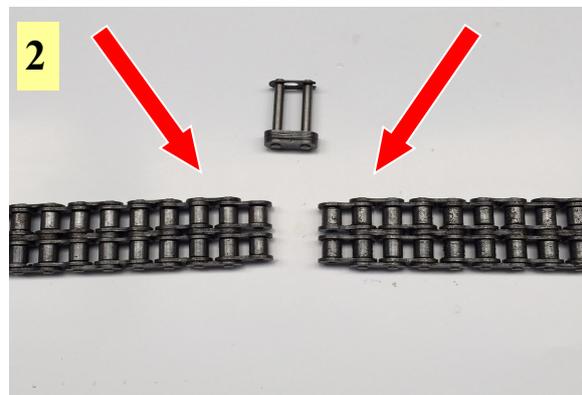
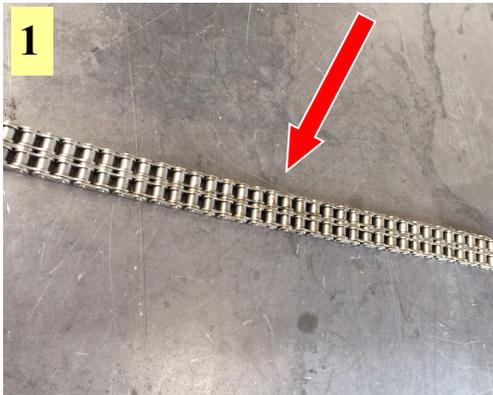
86" A 120" GUIDING BELT COMPOSITION

Pipe diameter	Chain composition	Number of Sectors
86"	29A+F+2 TRACTION JOINTS	28
88"	30A+2 TRACTION JOINTS	28
90"	30A+C+2 TRACTION JOINTS	29
92"	31A+E+2 TRACTION JOINTS	30
94"	32A+2 TRACTION JOINTS	30
96"	32A+B+2 TRACTION JOINTS	31
98"	33A+D+2 TRACTION JOINTS	32
100"	33A+D+3 TRACTION JOINTS	31
102"	34A+F+3 TRACTION JOINTS	32
104"	35A+3 TRACTION JOINTS	32
106"	35A+D+3 TRACTION JOINTS	33
108"	36A+F+3 TRACTION JOINTS	34
110"	37A+3 TRACTION JOINTS	34
112"	37A+B+3 TRACTION JOINTS	35
114"	38A+D+3 TRACTION JOINTS	36
116"	39A+F+3 TRACTION JOINTS	36
118"	40A+3 TRACTION JOINTS	37
120"	41A+3 TRACTION JOINTS	38



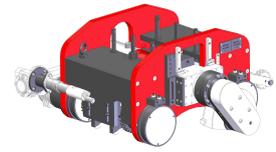
TAF SETUP (Feeding chain composition)

- 1) Retrieve the feeding chain from the kit and put it together as explained below.
- 2) The desired length is obtained by adding links.
- 3) Take apart the link as shown in the picture below.

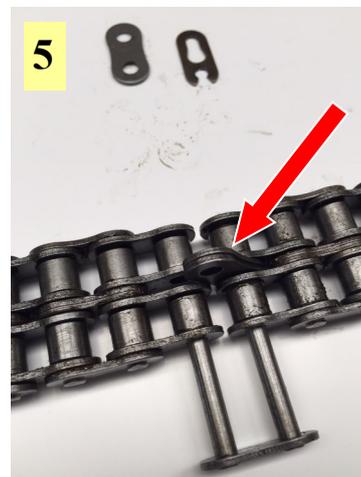
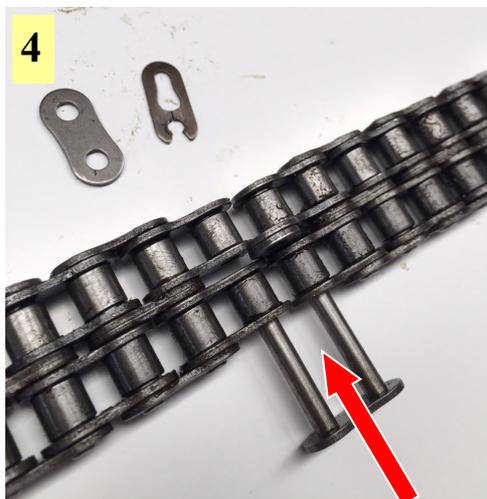


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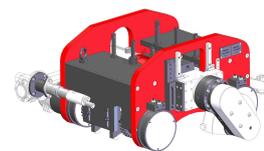


- 4) Pull close the two ends and slide the master link in the rollers.
- 5) **N.B. Insert two of the three spacers in the central part of the chain as shown in the picture.**
- 6) Insert the last spacer on the opposite side of the chain.
- 7) Apply the master link safety lock in its seat with pliers as shown in the picture 7.
N.B. You will have to assemble two equal feeding chains.



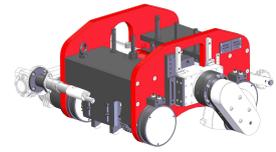
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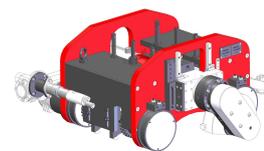
GUIDING BELT SECTORS ENCODING

Pieces	Sectors
124	A
12	B
24	C
36	D
5 (Connecting Links)	E



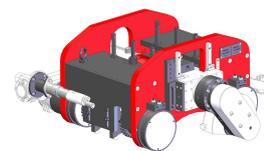
16" A 42" FEEDING CHAIN COMPOSITION

Pipe Diameter	Chain composition
16"	A+E
18"	A+B+E
20"	A+C+E
22"	A+D+E
24"	A+B+D+E
26"	A+C+D+E
28"	A+2D+E
30"	A+B+2D+E
32"	A+C+2D+E
34"	A+3D+E
36"	A+B+3D+E
38"	A+C+3D+E
40"	A+4D+E
42"	A+B+4D+E



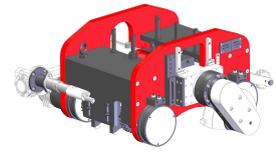
44" A 84" FEEDING CHAIN COMPOSITION

Pipe Diameter	Chain Composition
44"	A+C+4D+E
46"	A+5D+E
48"	A+B+5D+E
50"	A+C+5D+E
52"	A+6D+E
54"	A+B+6D+E
56"	A+C+6D+E
58"	A+7D+E
60"	A+B+7D+E
62"	A+C+7D+E
64"	A+8D+E
66"	A+B+8D+E
68"	A+C+8D+E
70"	A+9D+E
72"	A+B+9D+E
74"	A+C+9D+E
76"	A+10D+E
78"	A+B+10D+E
80"	A+C+10D+E
82"	A+11D+E
84"	A+B+11D+E



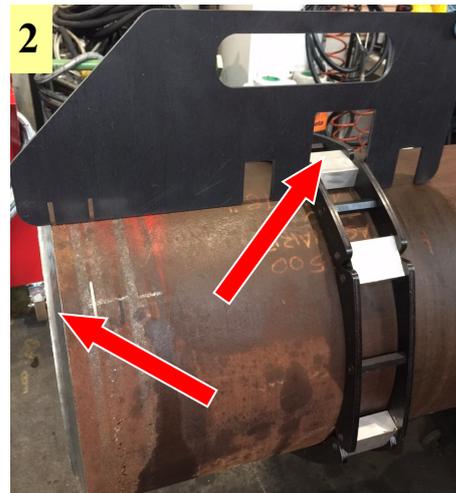
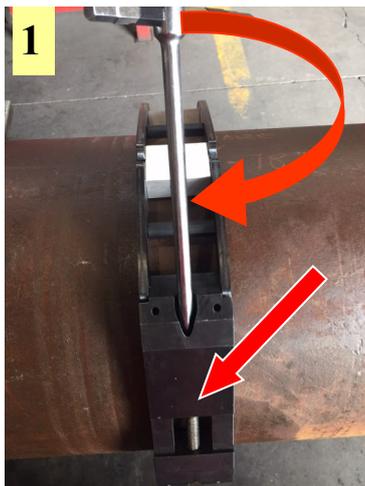
86" A 120" FEEDING CHAIN COMPOSITION

Pipe Dimension	Chain Composition
86"	A+C+11D+E
88"	A+12D+E
90"	A+B+12D+E
92"	A+C+12D+E
94"	A+13D+E
96"	A+B+13D+E
98"	A+C+13D+E
100"	A+14D+E
102"	A+B+14D+E
104"	A+C+14D+E
106"	A+15D+E
108"	A+B+15D+E
110"	A+C+15D+E
112"	A+16D+E
114"	A+B+16D+E
116"	A+C+16D+E
118"	A+17D+E
120"	A+B+17D+E



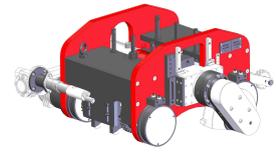
GUIDING BELT POSITIONING (Guiding Belt Mounting Procedure)

- 1) Place the belt you have previously assembled on the pipe, wedge the two ends of the belt and insert the central screw and screw it as long as required to keep the belt closed but do not screw it all the way down.
- 2) Use the positioning template to correct the belt position taking as reference one of the two notches **N.B. The suggested cutting point is the second notch (the one closer to the belt as shown in the photo.)**
- 3) Once the setting is done you can tighten the central screw all the way down tapping on the belt with a rubber hammer supplied with the machine to grant a uniform leaning all around the pipe outside diameter.



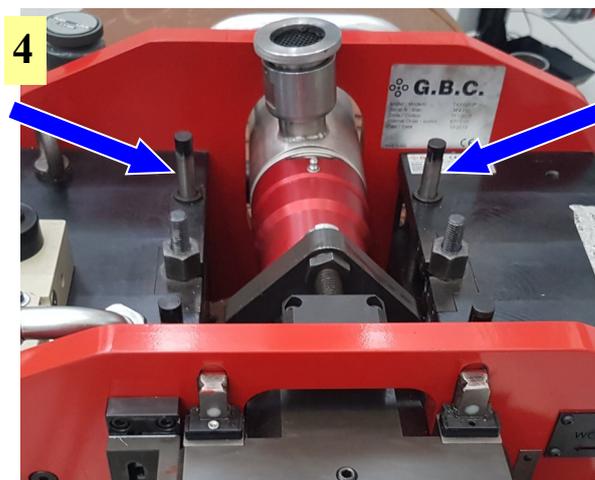
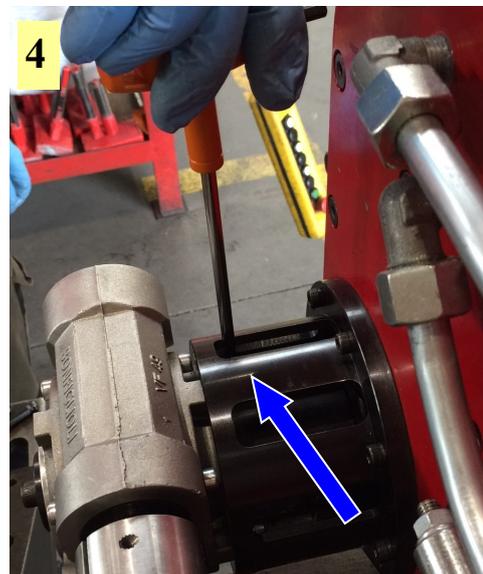
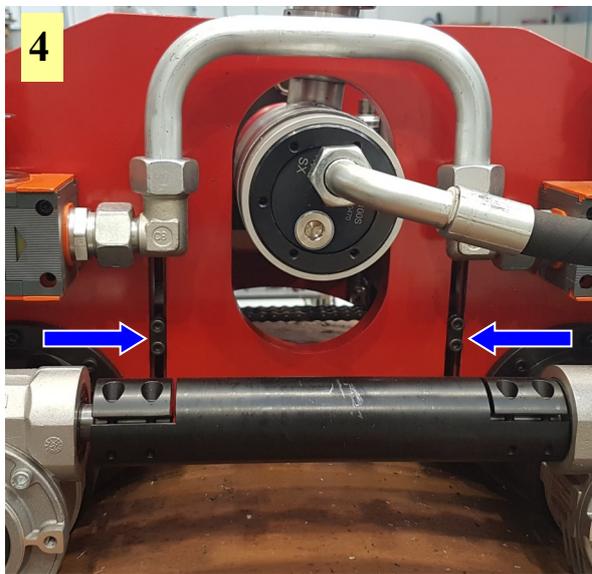
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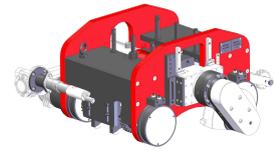
TAF POSITIONING

- 4) **N.B. Ensure that the four screws of the tensioners and the two screws of the joint highlighted in the picture are loose and in the high position as shown in the pictures below.**



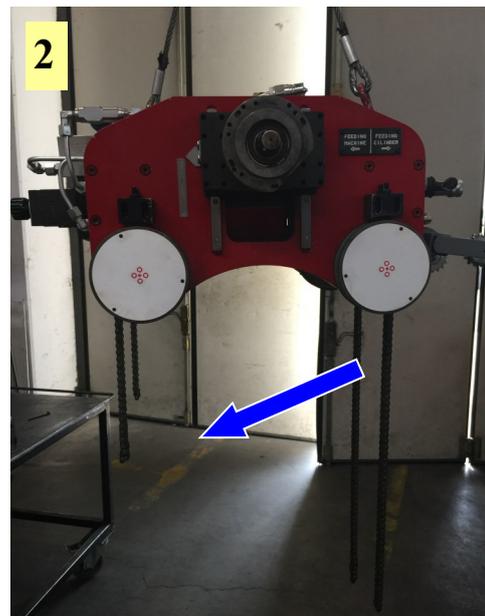
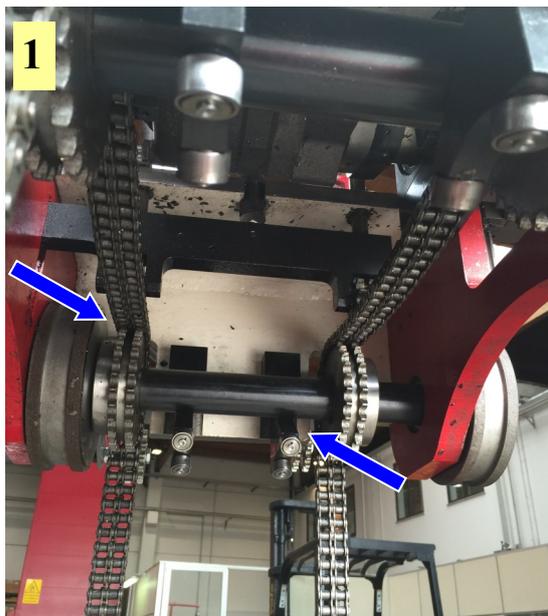
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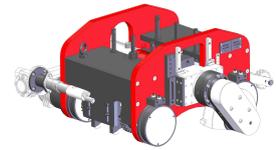
TAF POSITIONING (Feeding Chain Assembly Procedure)

- 1) Hoist the machine and keep it at a comfortable height to reach its bottom easily, then insert the two feeding chains previously assembled making sure you are correctly engaging the toothed wheels as shown in the picture #1.
- 2) The correct positioning of the chains is obtained by having two ends longer than the others as shown in the picture #2 in order to facilitate the coupling procedure once the machine is placed on the pipe.



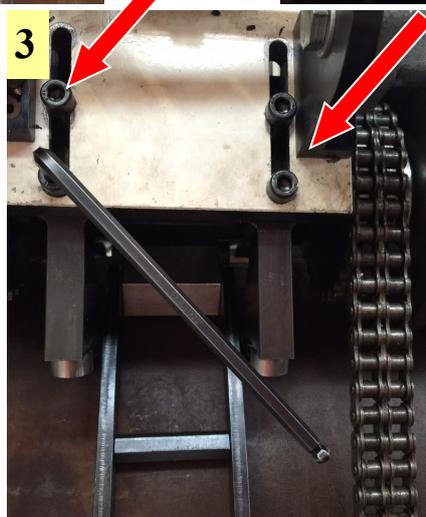
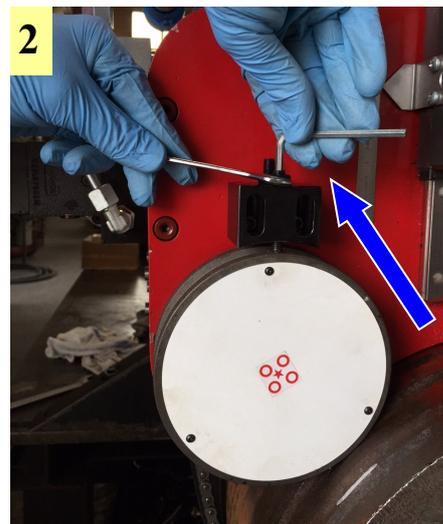
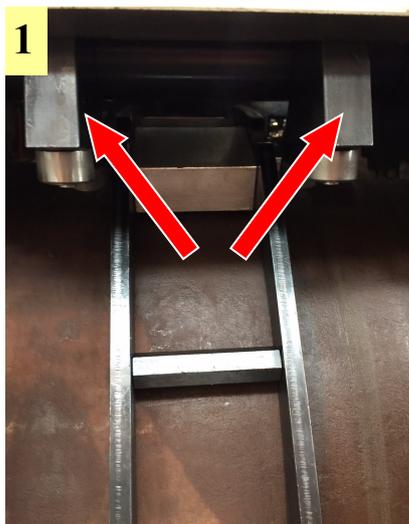
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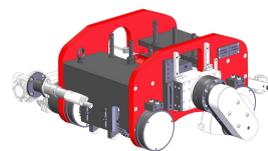
TAF POSITIOING (Positioning on the pipe)

- 1) Position the machine on the pipe so that the guiding rollers match and engage the guiding belt you have previously placed and securely fastened on the pipe OD.
- 2) Once the TAF is in the correct position you will want to block it using the brakes located above the two front wheels to prevent the machine to move during the setup.
- 3) Lower the guiding rollers on both sides of the TAF by using the Allen key part of the service tools supplied with the machine. Your aim is to have these rollers to match the guiding belt height and therefore to engage it on the sides so that the machine will be forced to follow the forced straight path of the guiding belt itself.

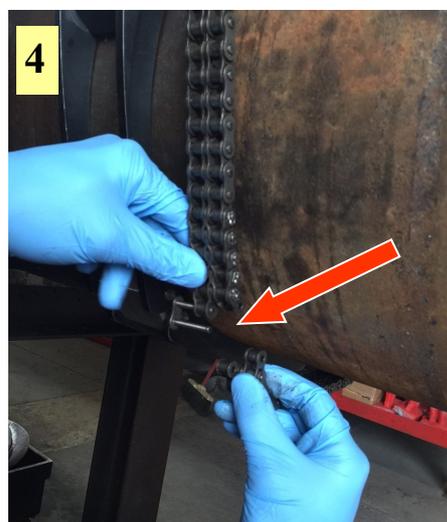
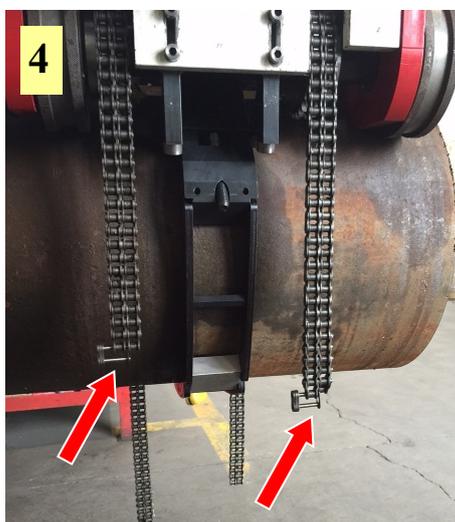


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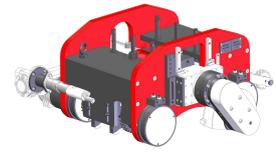


- 4) Join the ends of the two feeding chains with the connecting links as shown in the pictures below.

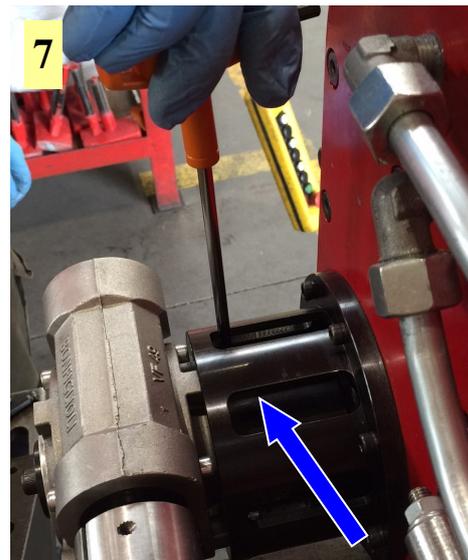
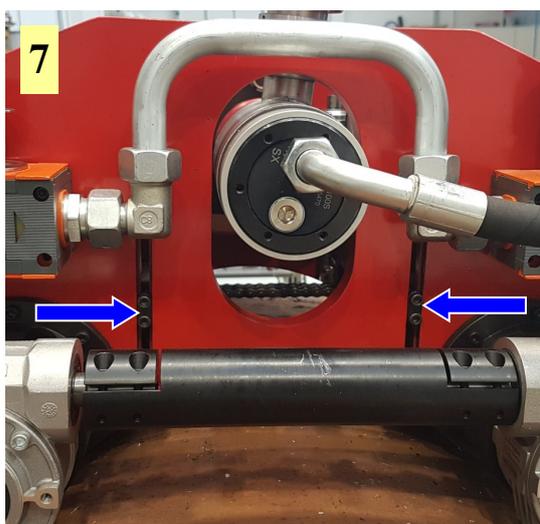
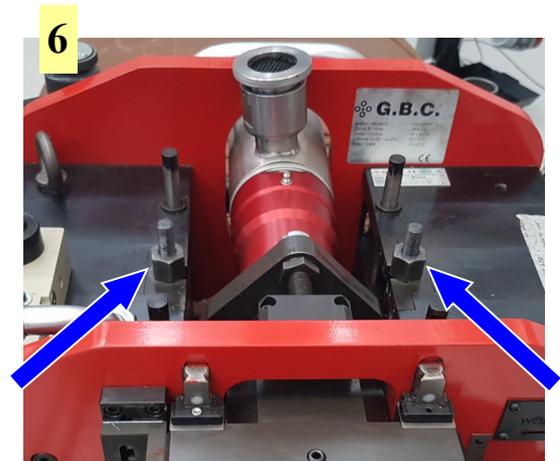
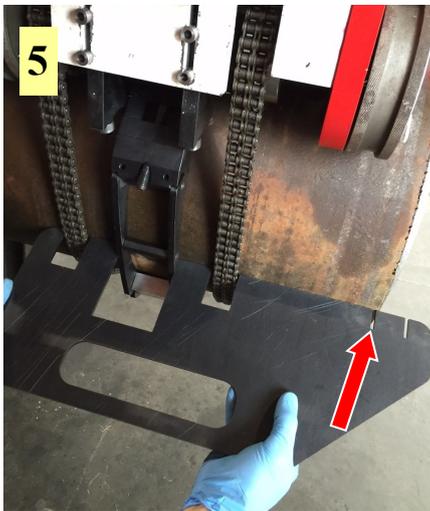


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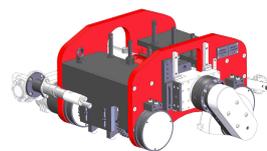


- 5) Use the template to check the machine correct position in relation to the feeding chains and the guiding belt.
- 6) Tighten the feeding chains by acting on the nuts of the tie rods located on the upper part of the TAF, being careful to tight them so that both will end up having the very same tension as shown in the picture #6.
- 7) **N.B. Once the feeding chains are tighten enough, remember to tighten the four screws of the tensioners and the two screws of the joint previously loose-ened.**

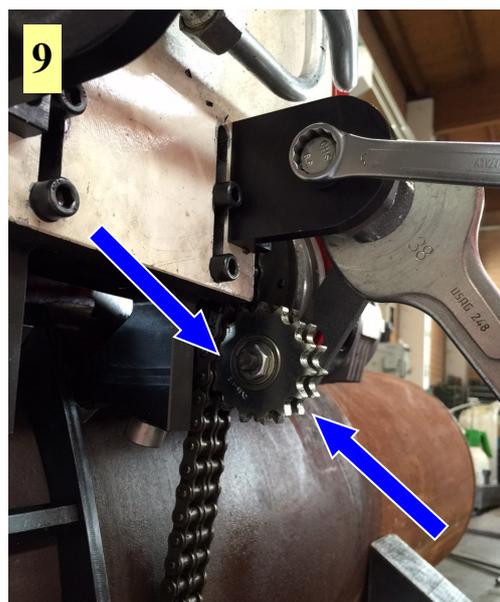
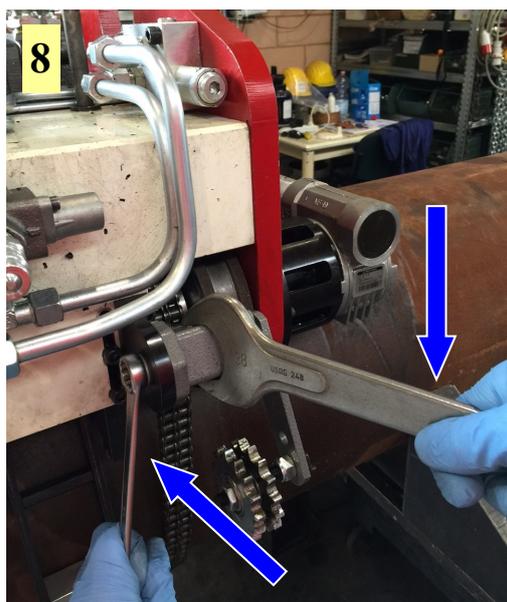


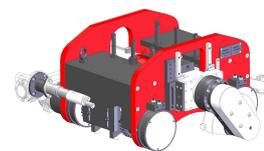
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- 8) The final stage of the positioning consists in lowering the two toothed wheels of the sprung tensioners onto the feeding chains up to the last notch by using the tools and wrenches provided with the machine as shown in the pictures #8 and #9 below.
This will grant a constant traction.





CUTTING BLADE INSTALLATION

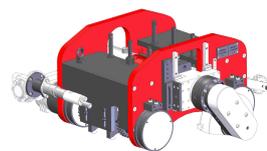
- 1) Choose from the cutting blade and the beveling blade of necessity.

N.B. The TAF can mount only one type of blade at a time or an assembly formed by the two blades paired together for a simultaneous cut + bevel process.



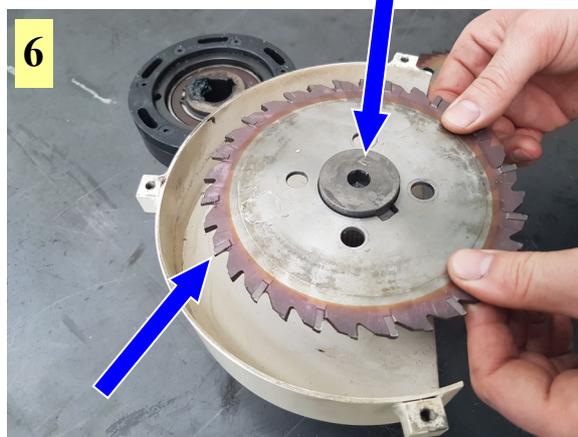
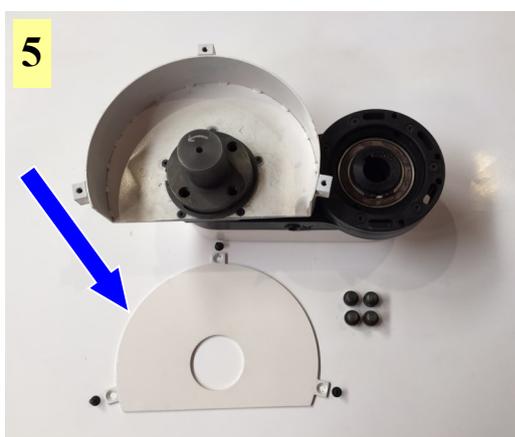
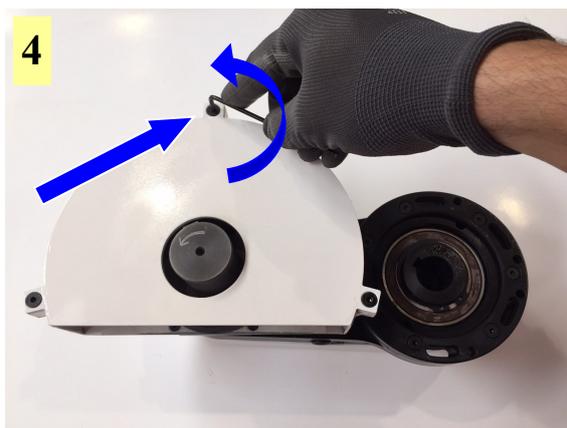
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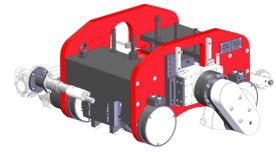
- 3) Identify the head assembly.
- 4) Remove the screws of the protection with the Allen key.
- 5) Remove the protection .
- 6) Install the selected blade on the spindle.

N.B. Ensure that the blade is being installed in the correct way of rotation, (see the arrow engraved on the hub), and align the seat of the key and the fixing holes as shown below.

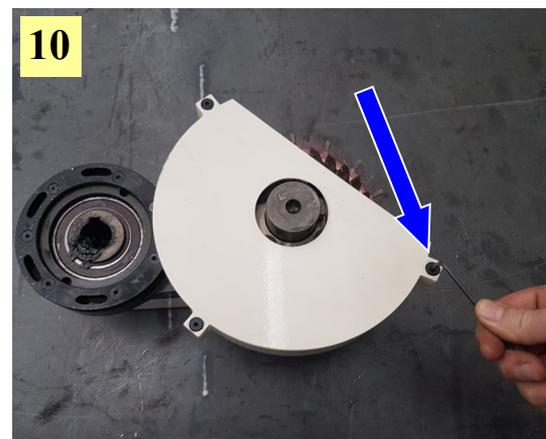
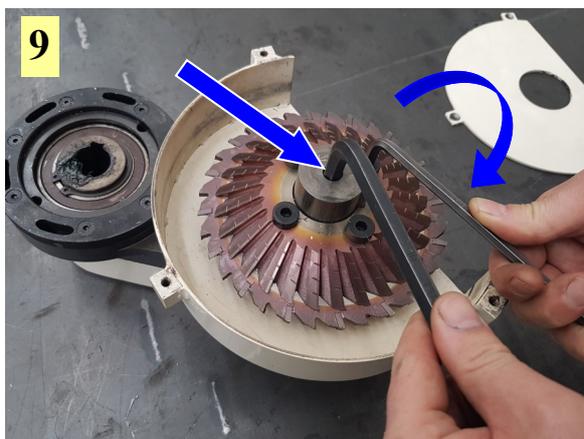
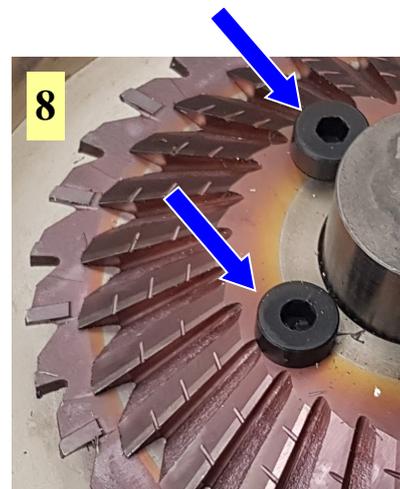


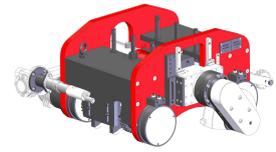
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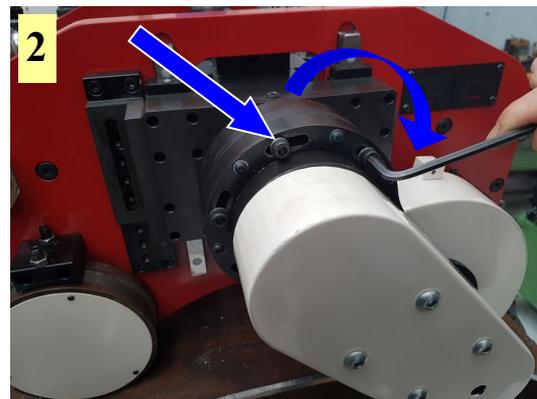
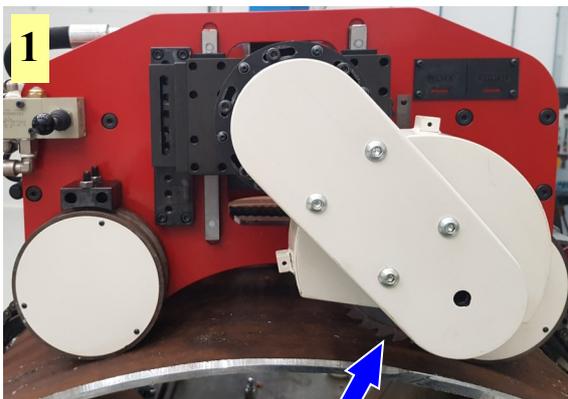
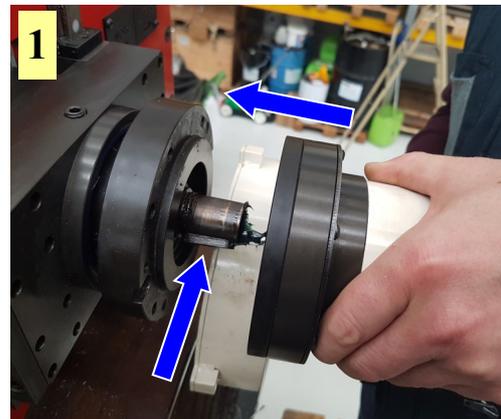
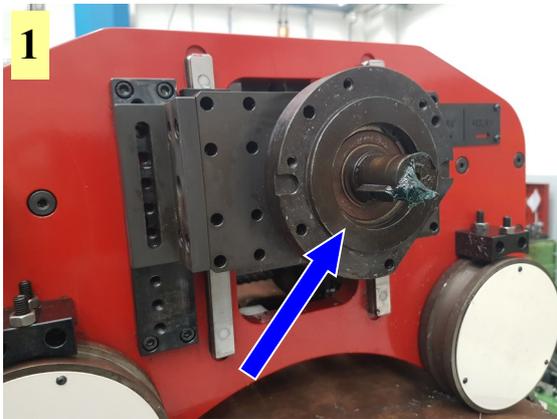
- 7) In case of simultaneous cut+bevel is required, install the beveling blade on top of the cutting blade as shown in the below picture.
- 8) Secure the assembly in position with the 4 locking screws.
- 9) To properly fasten the screws you will want to counteract on the hub with the specific Allen key to hold the spindle still during the operation.
- 10) Put the carter back in its original position and secure it with the three screws.





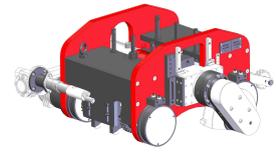
CUTTING HEAD INSTALLATION

- 1) Install the cutting head on the machine spindle like shown in the picture matching the fixing holes and notches with those located on the flange as shown in the picture #1 **N.B. Rotate the protection in the desired position in tangency with the pipe diameter.**
- 2) Lock the cutting head in position using the fixing screws.



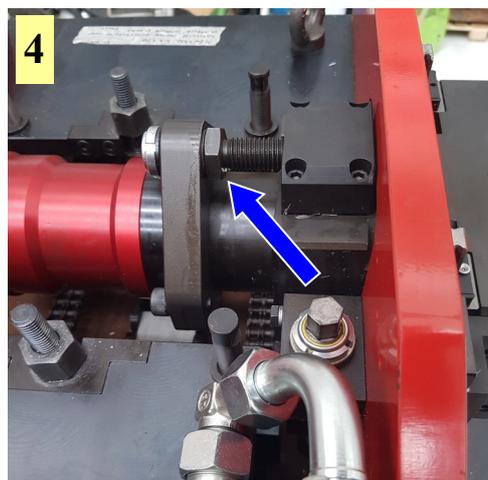
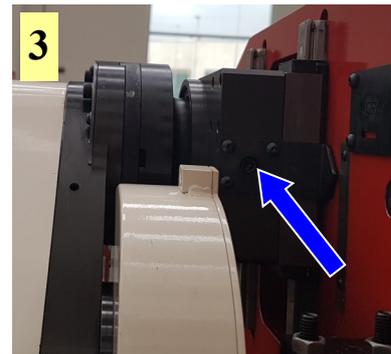
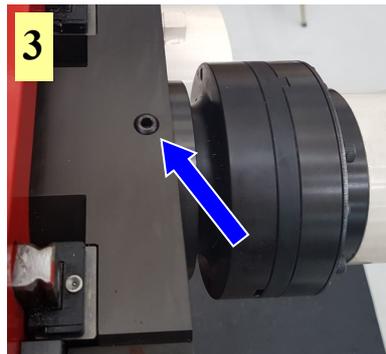
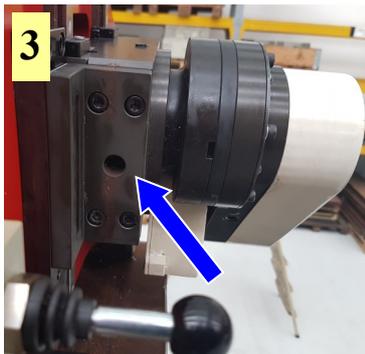
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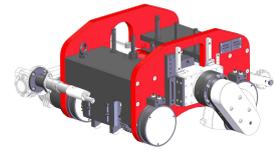
- 3) Loosen the set screws located on the squared flange, one located on the upper part and two located on the sides.
- 4) Turn the tie rod until the head reaches the point of cut selected with the help of the positioning template supplied with the TAF paying particular attention not to damage the O ring placed on the cylinder and that the cutting blade protection does not hit the squared flange.

N.B. Once achieved the required position tighten the three set screws previously loosen.



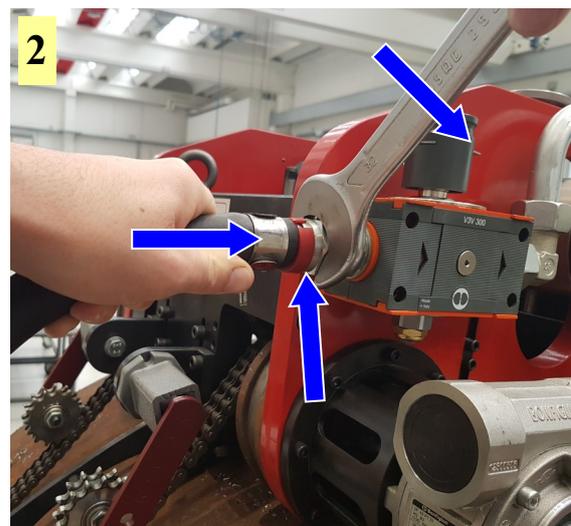
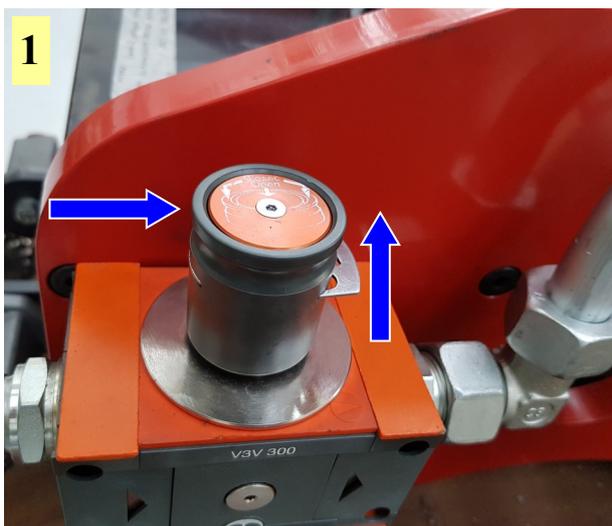
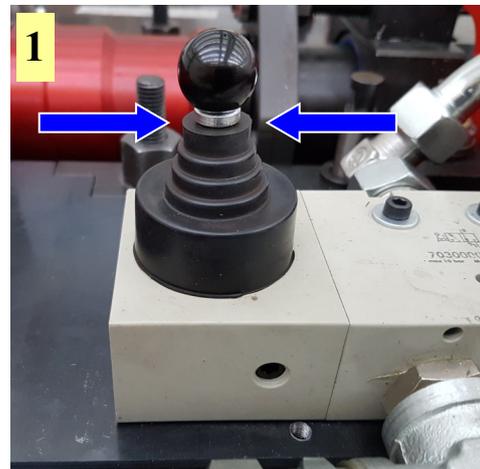
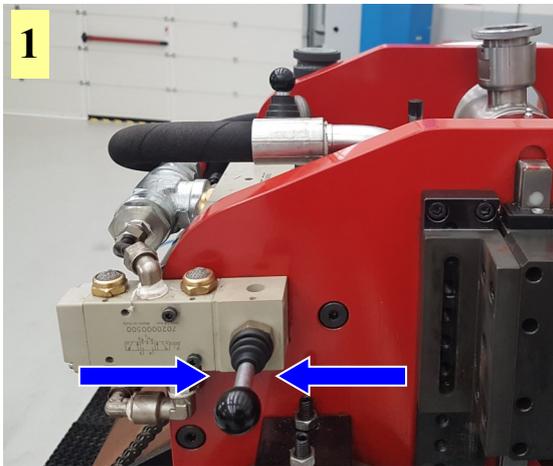
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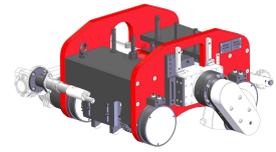
MACHINE START UP

- 1) **N.B.** Before connecting the hydraulic hoses to the machine you will want to make sure that the lever of the motion direction and the lever of the blade rotation are in neutral position and that the inlet valve is closed as shown in the photos below.
- 2) Connect the air hose to the inlet valve.



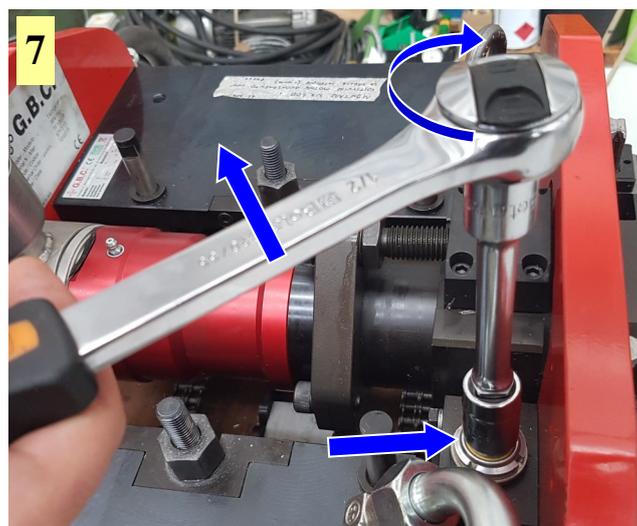
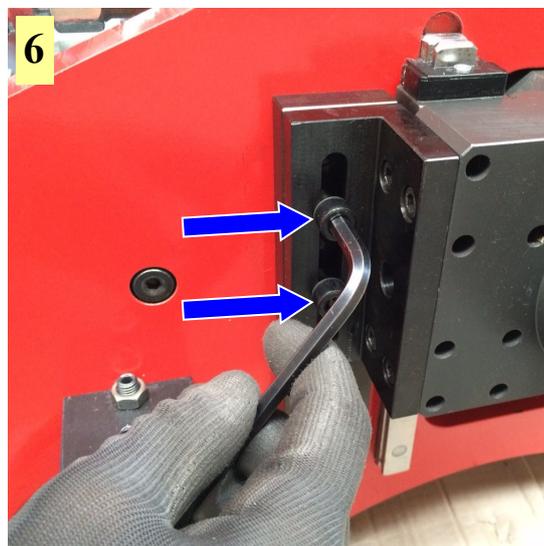
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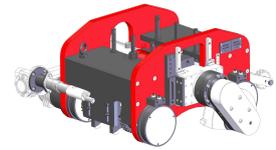
- 6) **N.B.** Ensure that the locking screws of the vertical slide mechanic lock are aligned.
- 7) By using the specific tool rotate the slide adjustment screw clockwise (as the arrows shows) and the blade will begin penetrating the pipe wall.

N.B. This operation has to be executed until the blade exits from the other side of the wall, inside the pipe.

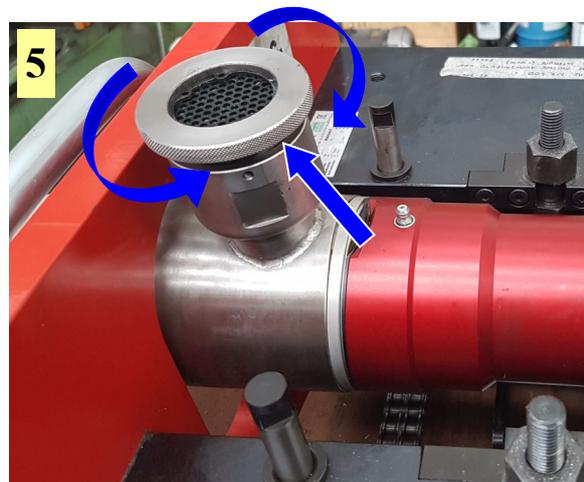
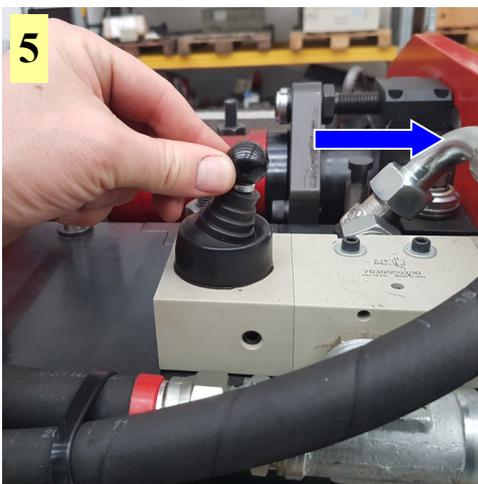
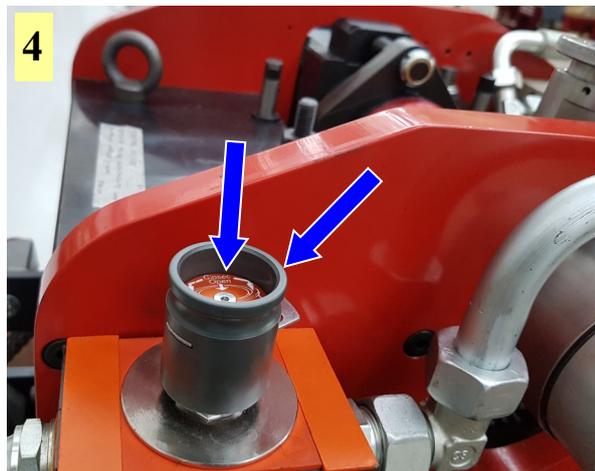
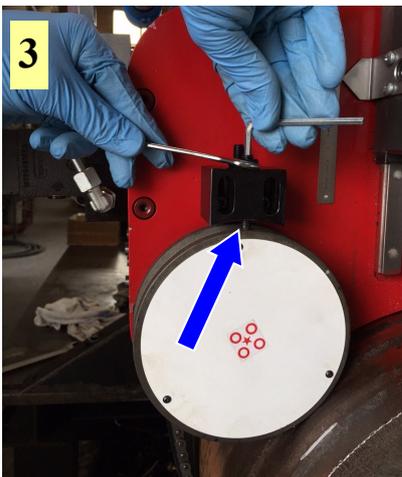


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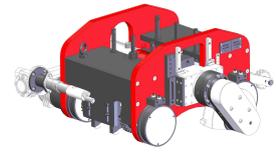


- 3) Release the machine safety breaks.
- 4) Open the air valve and press the red central button to allow the air in the machine.
N.B. This button also acts as EMERGENCY STOP BUTTON by pressing the external grey bezel.
- 5) Start the blade rotation by moving the lever as indicated by the arrow and adjust the RPM by acting on the motor air exhaust, according to the pipe material and wall thickness.
N.B. The blade direction of rotation cannot be inverted.



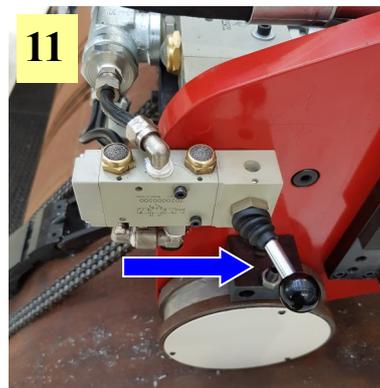
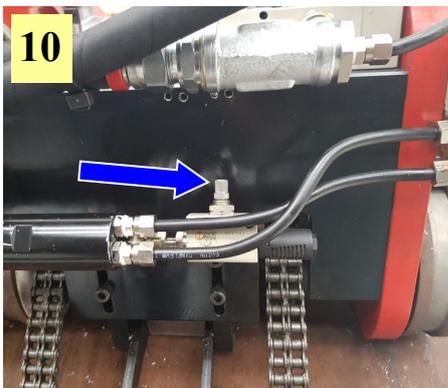
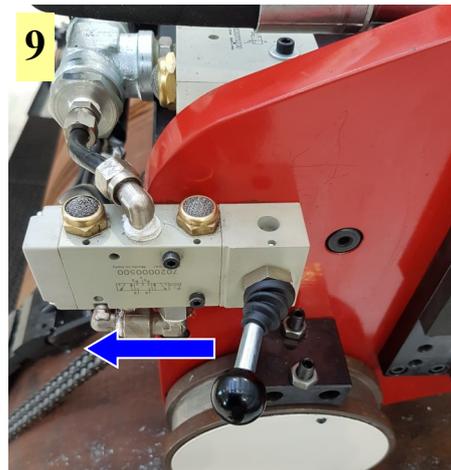
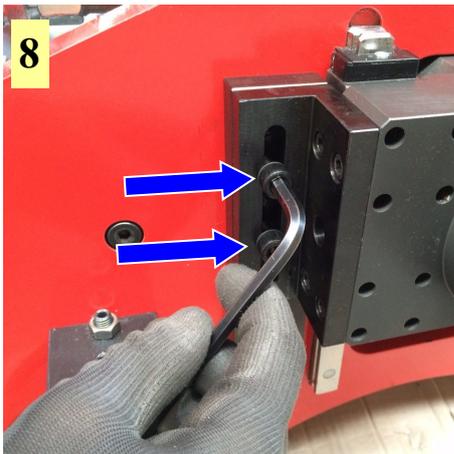
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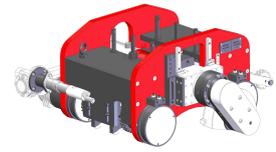
AVVIAMENTO MACCHINA

- 8) Once the blade has fully penetrated the wall, lock the screws of the mechanic lock.
- 9) Push the feeding lever in the direction shown by the arrow and the TAF will feed forward at the speed set on the speed regulator.
- 10) Adjust the feeding speed by rotating the speed selector either counter-clockwise or clockwise.
- 11) **WARNING!!!** Moving the lever in the opposite way at the maximum speed may damage the blade.



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TROUBLESHOOTING

- THE MACHINE DOES NOT START:
 - 1) Ensure that there is enough air pressure.
 - 2) Check the start up sequence explained in the previous paragraphs has been duly followed.
- MALFUNCTIONS:
 - 1) Check for eventual air leaks.
 - 2) If the machine does not move check the conditions of the blade and that the speed is correct.
 - 3) If the machine slips on the pipe check the tension of the feeding chains.

N.B. For any other malfunction experienced during any working phase that are not covered by this paragraph you are invited to contact the G.B.C. customer service.