

WBM MODEL
Portable Plate Edge Milling Machine

MADE IN CHINA
High Efficiency & Energy Saving



WBM.80V

MANUAL OPERATION

必须认真阅读本操作手册，否则将造成不必要的损伤！
DON'T OPERATE THE MACHINE BEFORE READING THE MANUAL!





WBM Edge milling machine

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2. Preface		
Thank you for choosing our "Wenbach GmbH" machine, Hope it helps you on improving efficiency and saving more cost.WBM Series plate beveling machine mainly for plate edge beveling on weld preparation. For your benefit, Please read this operation manual and related instructions & symbols carefully before machine operation. We will not take the responsibility while defective machine or physical Injury caused by any operation under required. If you have any questions or problems on our machine or files, Please do not hesitate to contact us at " Contact@Wenbach.Com ". ➤ We have the right to the final interpretation of this information, We will not give further notice with any alteration. ➤ We have the copyright for this file, Please do not copy or amend without our approval. Thank You !		
		3. Service Wenbach Industrial Technology Wuxi Co., Ltd ADD: 12nd Building, No.9 Xingyang Road Wuxi-214082, China Tel : +86 510 85809585 Fax : +86 510 85808563 E-mail: Contact@Wenbach.Com Web: www.Wenbach.com



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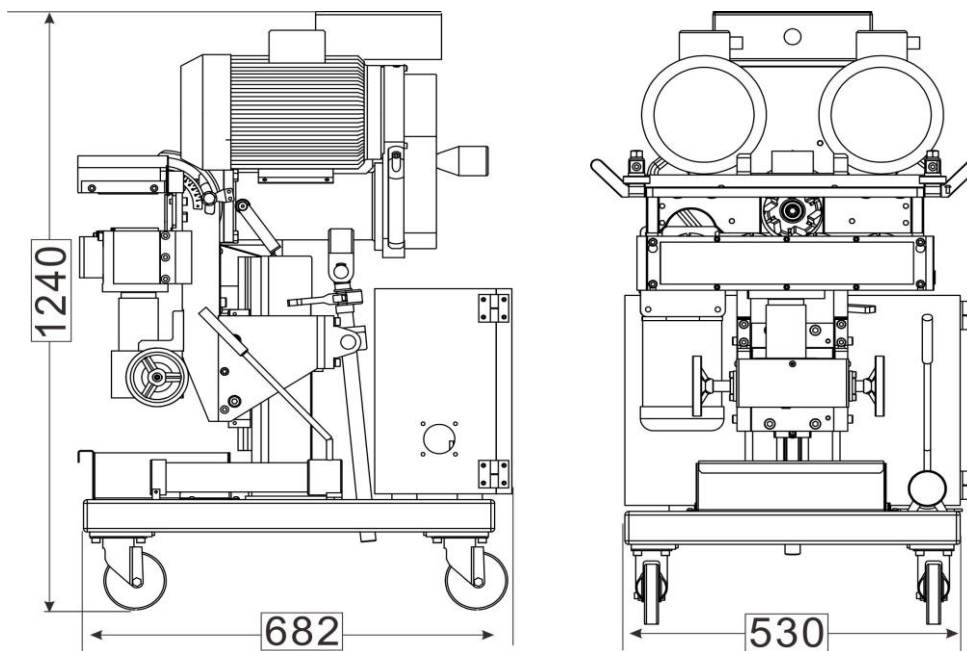
4. Summary

4.1 This machine is introduced This machine process plate automatically with high efficiency; completely cold cutting, non-oxidation on the surface; for the milling cutter, The radiance come to Ra3.2-6.3 the finish on the surface is satisfy with the requirement in welding industry; easily operate and non-pollution.	4.2 application fields Can be used for fine grain steel, aluminum, chromium, iron and steel products, copper and aluminum processing. Can be processed into a "v", or "y"-shaped bevel.
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4.3 Technical Parameters :

Total Supply : AC380V 50HZ	Total Power : 4920W
Milling Power : 2*2200W	Feeding Power : 400W
Milling Speed : 0~1500mm/min (Adjustable)	Bevel Angle : 0° ~ 60° (Adjustable)
Single Bevel Width : 15~20mm (Like Q235)	Plate Thickness : 8~80mm (Can Be Customized)
Max. Bevel Width : 70mm (On 37.5Degree)	Cutter Insert : 6 PCS
Min. Clamp Width : ≥1000mm(No processing side)	Net Weight : 245kg

4.4 Machine Diagram



4.5 Models Option :

Product Type	WBM	100VJ	80X	60VJ	60V	80V
Plate Size	L (mm)	>300				
	W (mm)	>100				
	T (mm)	8~100	6~80	6~60		6~80
Working Capacity	Bevel angle a (°)	0~-90	0~60	0~90	0~60	0~60
	Bevel width W (mm)	0~100	0~70	0~56	0~45	0~70
	d (mm)	0~20	0~15	0~15	无 No	0~15
	e (mm)	0~100	无 No	0~45	无 No	无 No
	f (mm)	0~30	0~15	0~15	无 No	0~15
	0° B mm	100	60	56	无 No	60
Single Bevel Width (mm)		30	15			20



WBM Edge milling machine

5. Safety And Warning

5.1 Safety instructions

	The parts of electrical and rotation may cause serious personal injury or property damage. This machine is powered by 380 Volts.PLEASE
	WARNING Improper operation could cause danger or serious injury
	WARNING Improper operation could cause danger or serious injury

5.2 Safty ware and protective equipment

Pls do check your wares before operation;Labour suit should be fit and comfortable and long-sleeved clothes suggested

Sandals, high heels, loose shoelaces, and smooth soles are all dangerous

Pls do ware helmet during operation and ware protective glasses and ware gloves to protect your hands during operation



CAUTION

5.3 Protective Device

Please DO NOT remove the protective cover on equipment.

Machine can not be modified without permission.



WARNING

5.4 Operation Cautions

- ✧ Before operation, Please ensure the safe site around. operate machine at 0~40°C.
- ✧ Before operation, Please do not touch rotation parts of machine by hands.
- ✧ After operation, Please do cut off the power and reset machine.
- ✧ Inflammable and explosive articles shall not be placed around the machine.

5.5 Safety precautions

	DANGER	1) We have the final right to interpret and modify all relevant information of this machine! 2) Do check whether any damages on plug, wire, and machine before use every time!
	WARNING	3) DO NOT move the machine by power cord ! 4) Please use trip circuit breaker to protect machine when out door operation! 5) Please let only skilled person for machine inspection and maintenance!
	CAUTION	6) Please do stop machine and wear gloves for iron cleaning to avoid any hurts by hot sharp iron pin. 7) Please place the power cord on machine or behind, do not put it on sharp objects.

5.6 Security identification parsing:

	Beware of burns After plate beveling, The Iron pins and Inserts are in hot and sharp, please do not touch by hands.:
	Electric Shock Risk It happens on the electric box, Means request professional electrician for inspection and pay attention on the electric shock risk..
	Hoisting Prompt During hoisting,Please DO NOT stand under machine to avoid any casualties.
	Watch Your Hands It marks on the plate feeding side, means dangerous for hands and please keep distance with machine.



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Be careful of prick on hands

It markets on the plate feeding side, means dangerous for prick on hands, please do not touch the iron pins or plate by hands after beveling.

6. Machine Inspection

1.1 Hoisting

Step 1: cut off the steel strip of the fixed machine.

Step 2: The machine is hoisted slowly based on its hoisting position and the height should not rise more 10cm while hanging up, Except crossing obstacles.

NOTE : Please use good quality hoisting belt and available lifting weight should be > 500KGS.



6.2 Wheel Installation :

Someone must support the machine while installing the wheels after the machine is hoisted 200-250mm from the ground.

NOTE : Please do not touch the lifting device while lifting and keep hoisting safety for machine stable to ensure person safety..



6.3 Check: Detailed Parameters On The Nameplate

WBM.80V 型自动平板铣边机
WBM.80V Self-propelled Plate Edge Milling Machine

型号 Model	WBM.80V	电压 Voltage	AC 380V	频率 Frequency	50Hz
总功率 Total Power	4920W	工作台高 Worktable Height	700~760mm	坡口角度 Bevel Angle	0~60°
夹持板厚 Plate Thickness	6~80mm	坡口宽度 Bevel Width	0~70mm	净重 Net Weight	245kg

本机加工坡口样式 THIS MACHINE CAN BE PROCESSING BEVE TYPE

温馨提示: 设备运行时操作人员请勿离开。
Note: Don't leave it when the machine is working.

严禁超载运转
No-over Load

WENBACH

主轴伸出刻度 Spindle Size F	坡口角度 Bevel Angel					
	5	25	30	35	45	60
0	11.1	4.9	3.7	2.7	1.3	0.4
4	11.5	6.6	5.7	5.0	4.1	3.9
8	11.8	8.3	7.7	7.3	6.9	7.4
12	12.2	10.0	9.7	9.6	9.7	10.8
16	12.5	11.7	11.7	11.9	12.6	14.3
20	12.9	13.4	13.7	14.2	15.4	17.8
24	13.2	15.1	15.7	16.5	18.2	21.2
28	13.6	16.8	17.7	18.8	21.0	
32	13.9	18.4	19.7	21.1	23.9	
36	14.3	20.1	21.7	23.4	26.7	
40	14.6	21.8	23.7	25.7	29.5	
44	15.0	23.5	25.7	28.0	32.4	
48	15.3	25.2	27.7	30.3	0度时, F=13mm	
52	15.7	26.9	29.7	32.6	示例如下	
56	16.0	28.6	31.7	a=30度、d=20mm时, 第一次F=9mm, 第二次F=13.7mm。		
60	16.4	30.9				

注: 参数仅供参考, 以实际加工为准。
Note: For reference only, should be based actual data

7. Installation



CE Standard

External ground wire diameter size should follow requirement (Copper wire)

Phase wire diameter S (mm²)

Ground wire diameter Sd (mm²)

S ≤ 16

S

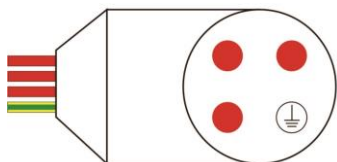
16 < S ≤ 35

16

S > 35

S/2

7.1 Electrical Installation :



● Fires

⊕ Wire

POWER SUPPLY LINE

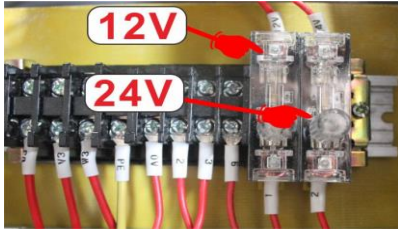
Electrical connection and protection should Consistent with local regulations.

Power supply.AC380V 50HZ



CUTTER ROTATION

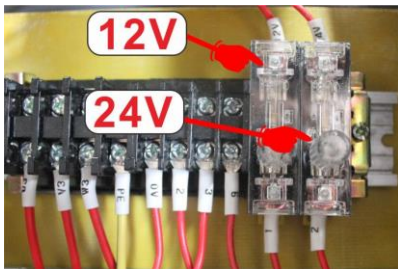
Check the direction of the rotation of the tool, if the rotation is not correct, it can change the variable steering by changing the position of any two fire lines.



No data on digital display

If no data on digital display when power is on, Check the 12V fuse if blowout, or contact with us directly.

NOTE : This operation is ONLY available when the troubleshooting not solved.



No power in Electric box

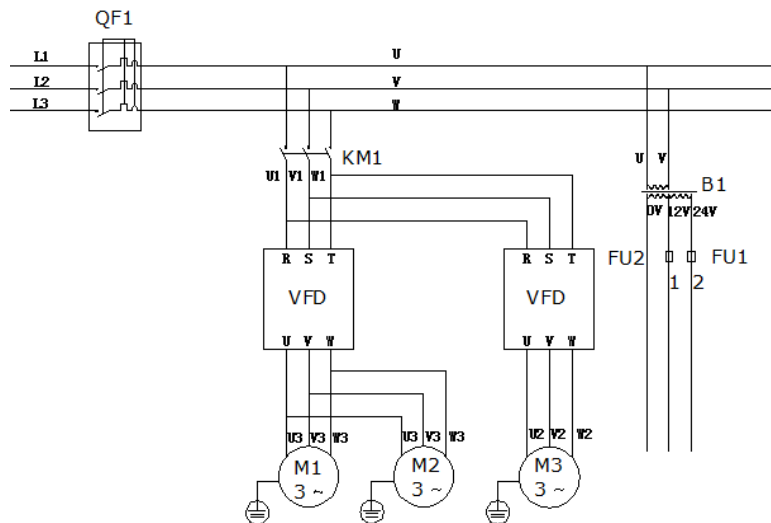
If no power in electric box when power is on, Check the 24V fuse if blowout.

NOTE : This operation is ONLY available when the troubleshooting not solved.

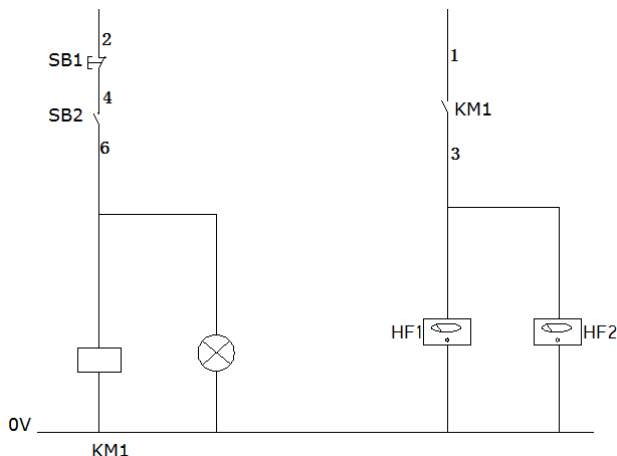
7.2 Electrical symbols

QF: Power switch
SB1: Emergency stop
SB2: Power switch
B: transformer
KM: AC
FU: Fuse
VFD: Frequency converter
HF: Tachometer

7.3 Electric wiring diagram



BOX wiring diagram



7.4 The protection measures

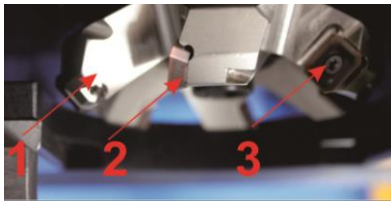
- 1) Electrical connection and protection should Consistent with local regulations.
- 2) Connect the air plug (the attachment with the machine) with one end of cable, the another end connect with the power supply.
- 3) Dangerous in the humid environment.
- 4) According to direction on the machine to feed plate, process work piece after cutter rotate.

7.5 Cutter & Insert Replacement :



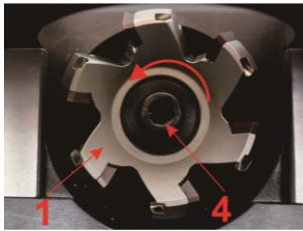
Ensure power off before replacing Cutter head or Inserts

- 1) Please pay attention on the sharp edge of inserts and high temperature when replacing Inserts or cutters to avoid any dangers.
- 2) Suggest to do cleaning before replacement and wear gauntlet.



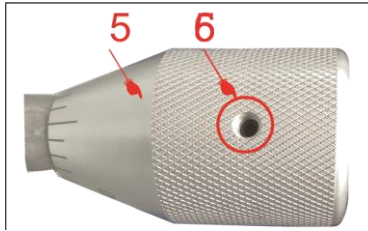
Change cutter

1. Adjust to require angle ("1" cutter head; "2" cutter; "3" screw)
2. Used the "T15" bolt driver to take off screw "3".



Install of bele

1. Take out in "5" parts screw "6" [Total 2]
2. Rotation hand wheel and take out it.

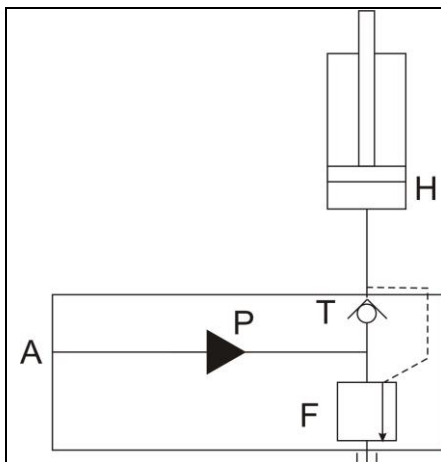


Change cutter head

1. Adjust the cutter head to require angle.
2. According to arrow shows rotary screw "4", can be take off the cutter head.

8. Hydraulic Diagram

8.1 Hydraulic Diagram :



A : Oil Intake Hole

T : Check Valve

H : Hydraulic Cylinder

P : Hydraulic Oil

P : Relief Valve

A, P, T, F are for manual pump units

- ◆ Hydraulic oil can be filled through "Oil Hole A" while low.
- ◆ The nozzle can be re wound by raw materials belt to achieve sealing when the outlet of "Check Valve T" leak out.
- ◆ If the equipment don't use it for long time, Slowly release "relief valve F" to make the "Hydraulic Cylinder H" to the lowest state.

See the troubleshooting page for details on problems

8.2 Use of Hydraulic System :



- ◇ Turn "Flow Valve 1" clockwise to the working state.
- ◇ The device will be lifted up by repeatedly press "Handle 2". On this process the Max. Height of "Handle 2" cannot up to "Thickness Compaction Hand wheel".
- ◇ When the device is not used, slowly turn "Flow Valve 1" counterclockwise to ensure the device to the lowest position.

NOTE : Do not use brute force to avoid damage to the hydraulic pump.

9. Bevel Preparation

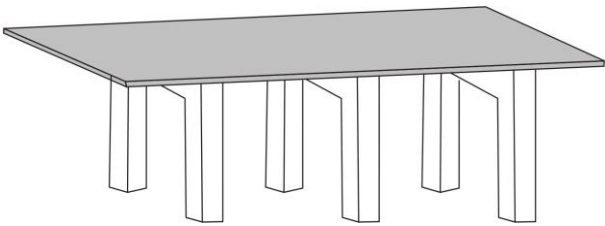
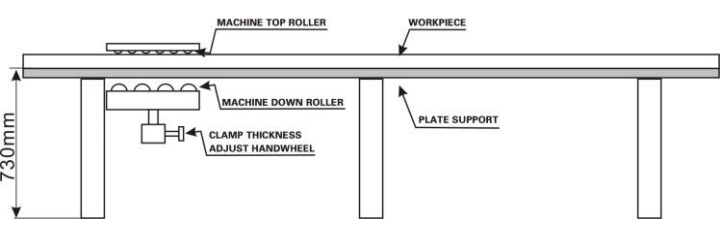
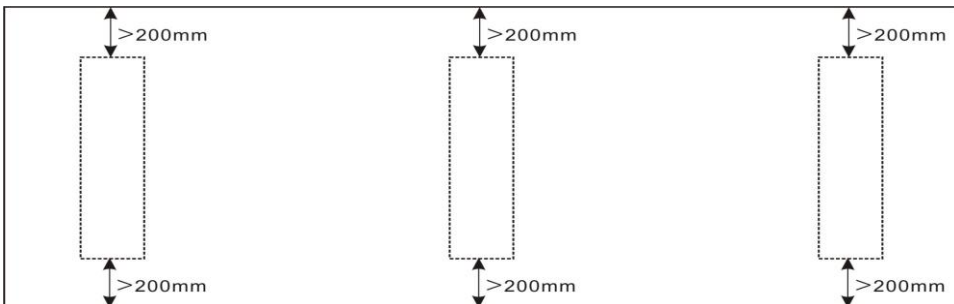


The hardness of machined Parts cut by oxygen increases after high temperature heating. This factor needs to be fully considered when setting groove process parameters.

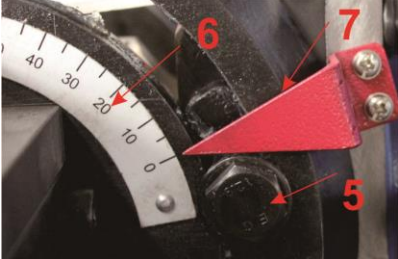



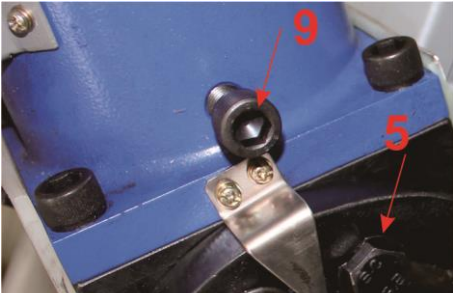
9.1 Steel plate placement & Plate cleaning:



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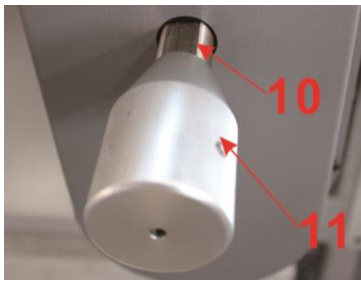
<p>1) make a simple plate support as below picture.(Picture for reference only)</p> 	<p>2) We suggest to set height at 730mm, Set table height refer to your plate thickness, Max height at 765mm.</p> 
<p>3) Put the metal plate on support showed as below, make the beveling edge about 200-250mm.</p> 	<p>Plate cleaning:</p> <ul style="list-style-type: none"> ✧ No welding slag on the bevel surface. ✧ Welding slag and bur will affect the cutter tools and reduce machine service life.

9.1 Bevel Angle & Bevel Depth Adjustment :

	<p>Bevel Angle Adjustment</p> <p>1. Loose bolt "5" (Picture Refers "6" for Angle Ruler, "7" for Angle Indicator Arrow</p>
	<p>Bevel Angle Adjustment</p> <p>2. Rotate the Ratchet Wrench "8" and adjust required angle. After that tighten the bolt "5"</p> <p>NOTE : Adjusting the "b" on the ratchet wrench can change the rotate direction of angle.</p> 
	<p>NOTE: For machine of tightening ratchet model, Hands should be put on the the position in GREEN mark, NOT in RED mark, which will damage the ratchet wrench.</p>
	<p>Bevel Depth Adjustment</p> <p>1. Loose bolt "9"</p>



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Adjust to bevel depth

2. According to "feed reference table" rotary handle "11", and look at the size "10", then lock screw "9".

Spindle Feeding Parameters Reference Tabled :

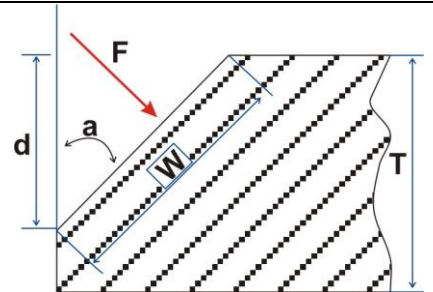
T : Clamp Thickness、 w : Bevel Width、 a : Bevel Angle、 F : Spindle Feeding

NOTE : 1. Parameters for reference, Please refer to the actual bevel size after testing.

2. Different Color means the max feed depth per cut.

3. Single cut max feed depth can be adjusted as per different material.

For example: IF a=30degree, d=10mm, F=8.7mm

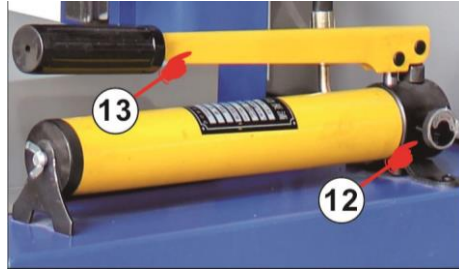
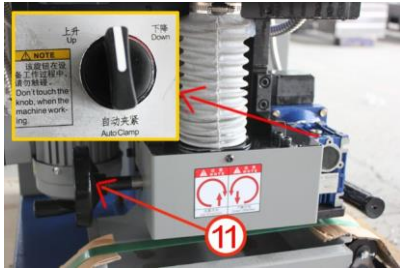


d \ F	a											
	5	10	15	20	25	30	35	40	45	50	55	60
0	11.1	9.4	7.8	6.3	4.9	3.7	2.7	1.9	1.3	0.8	0.5	0.4
4	11.5	10.1	8.8	7.6	6.6	5.7	5	4.5	4.1	3.9	3.8	3.9
6	11.7	10.4	9.3	8.3	7.5	6.7	6.2	5.8	5.5	5.4	5.4	5.6
8	11.8	10.8	9.8	9	8.3	7.7	7.3	7	6.9	6.9	7.1	7.4
10	12	11.1	10.3	9.7	9.1	8.7	8.5	8.3	8.3	8.5	8.7	9.1
12	12.2	11.5	10.9	10.4	10	9.7	9.6	9.6	9.7	10	10.3	10.8
14	12.4	11.8	11.4	11	10.8	10.7	10.8	10.9	11.1	11.5	12	12.6
16	12.5	12.2	11.9	11.7	11.7	11.7	11.9	12.2	12.6	13	13.6	14.3
18	12.7	12.5	12.4	12.4	12.5	12.7	13.1	13.5	14	14.6	15.3	16
20	12.9	12.9	12.9	13.1	13.4	13.7	14.2	14.8	15.4	16.1	16.9	17.8
22	13	13.2	13.4	13.8	14.2	14.7	15.3	16	16.8	17.6	18.5	19.5
24	13.2	13.5	14	14.5	15.1	15.7	16.5	17.3	18.2	19.2	20.2	21.2
26	13.4	13.9	14.5	15.2	15.9	16.7	17.6	18.6	19.6	20.7	21.8	23
28	13.6	14.2	15	15.8	16.8	17.7	18.8	19.9	21	22.2	23.5	
30	13.7	14.6	15.5	16.5	17.6	18.7	19.9	21.2	22.5	23.8	25.1	
32	13.9	14.9	16	17.2	18.4	19.7	21.1	22.5	23.9	25.3	26.7	
34	14.1	15.3	16.5	17.9	19.3	20.7	22.2	23.8	25.3	26.8		
36	14.3	15.6	17.1	18.6	20.1	21.7	23.4	25	26.7	28.4		
38	14.4	16	17.6	19.3	21	22.7	24.5	26.3	28.1	29.9		
40	14.6	16.3	18.1	19.9	21.8	23.7	25.7	27.6	29.5			
42	14.8	16.7	18.6	20.6	22.7	24.7	26.8	28.9	30.9			
44	15	17	19.1	21.3	23.5	25.7	28	30.2	32.4			
46	15.1	17.4	19.7	22	24.4	26.7	29.1	31.5	33.8			
48	15.3	17.7	20.2	22.7	25.2	27.7	30.3	32.8				
50	15.5	18.1	20.7	23.4	26.1	28.7	31.4	34				
52	15.7	18.4	21.2	24	26.9	29.7	32.6	35.3				
54	15.8	18.8	21.7	24.7	27.7							
56	16	19.1	22.2	25.4	28.6							
58	16.2	19.5	22.8									
60	16.4	19.8										

9.2 Clamp Thickness & Machine Height Adjustment :



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Clamp Thickness Adjustment

Rotate control box switch can be clamping the plate.
Rotate hand wheel "11" to clamp the work piece

Adjust to height:

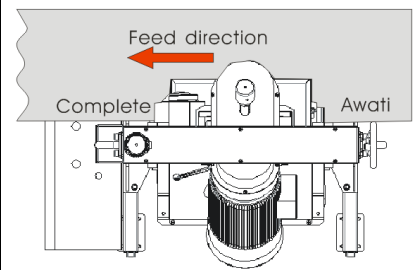
1. lift: clockwise rotation bolt "12", repeatedly press the handle "13".
2. reduction: reverse clockwise rotation bolt "12", turn to the required height after the clockwise rotation to the cut-off position.

9.6 Adjust to speed:

Adjust to spindle speed: Rotation "4".

Adjust to feed speed: Rotation "6".

Note: in the cutting process, the feed speed and the spindle speed can be adjusted properly on the control panel.



9.7 Route: If the ground is not flat, please lay on plate on ground.

Note: be sure to confirm the rotation direction of cutter and the feeding direction consistent with regulations, the blade cannot contact plate.

When equipment is processed, it is processed along the arrow direction.



10. Basic Operation

10.1 Feed speed table (the below parameter just for reference, please take the actual operation as standard)

No more than the red line of the work piece head is placed in the red line to the green line area as the "low speed area"; the end of the green line (more than a work piece cutter) after "speed"; "to complete the area close to the red line at the end of the work piece"

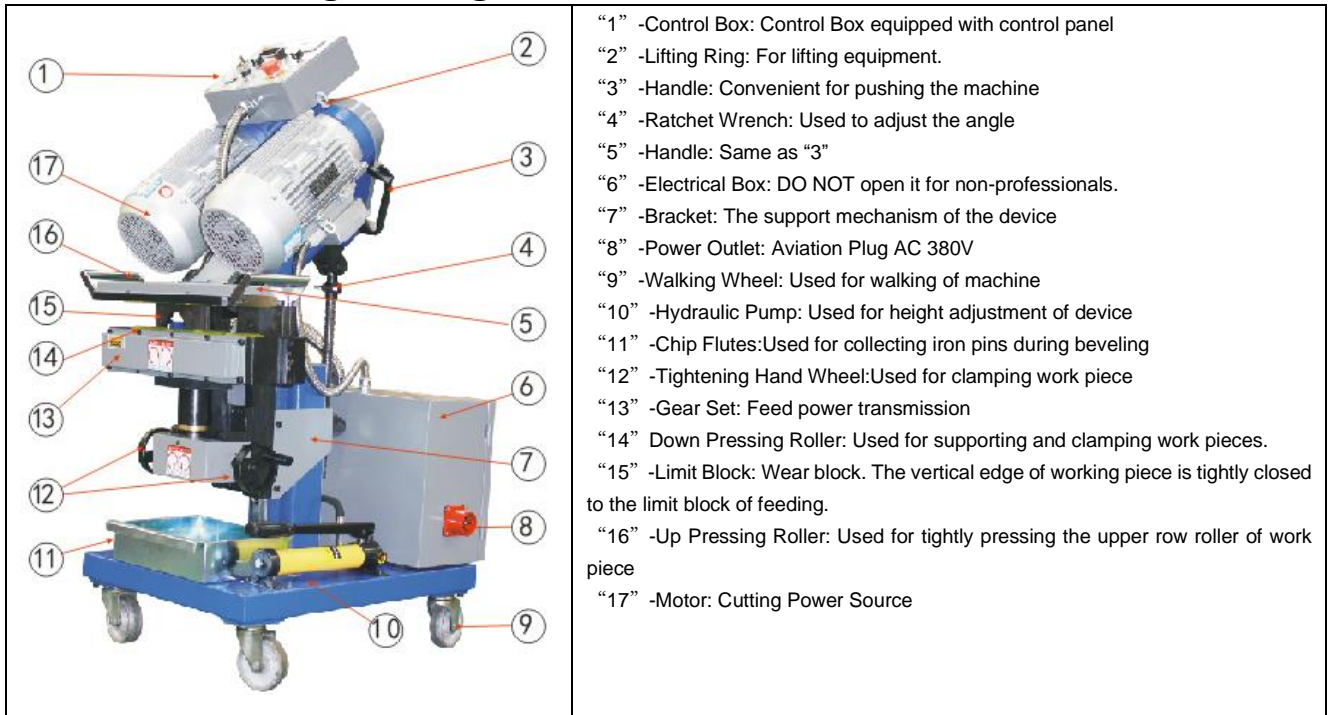
Material	thick	start	Speed up
Q235	150-250	300-800	300-500
45#	150-250	300-700	300-500
16Mn	150-250	300-600	300-500
AL	150-250	300-1000	300-800
306	150-200	200-500	200-300
316L	150-250	200-400	200-300



1) Full Machine



WBM Edge milling machine



2) Control Panel



10.3 Basic Operation

Small Plate Beveling.....As a manual operation to adjust the required bevel type, angle, depth, cutting speed and feeding speed, and then start to work

Large Plate Beveling.....When bevel large size metal plate, which need to put it on the auxiliary support attachment,and then adjust the required bevel angle,bevel depth, feeding speed and cutting speed on the machine to complete work.

10.4 Operation Steps :

- 1) Working Piece Location.....Workpiece should be stick along with the feeding limit block and Plate leading end should keep distance 10-15mm with cutter head.
- 2) Working Piece Clamping.....Please refer to operation 9 ;
- 3) Start to Milling.....Power On, Turn on Spindle 5-10 seconds to stable rotation speed and feeding speed.



After Beveling

Close the feed, close the spindle, and loosen the clamping wheel.

Make feeding speed back to "0"

11. Diagram

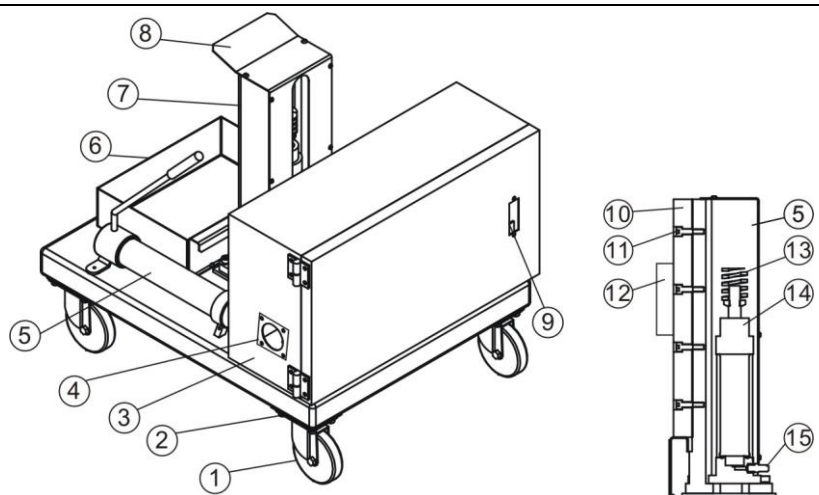
Part 1 :

No.	Name	Order no.	QTY	Diagram
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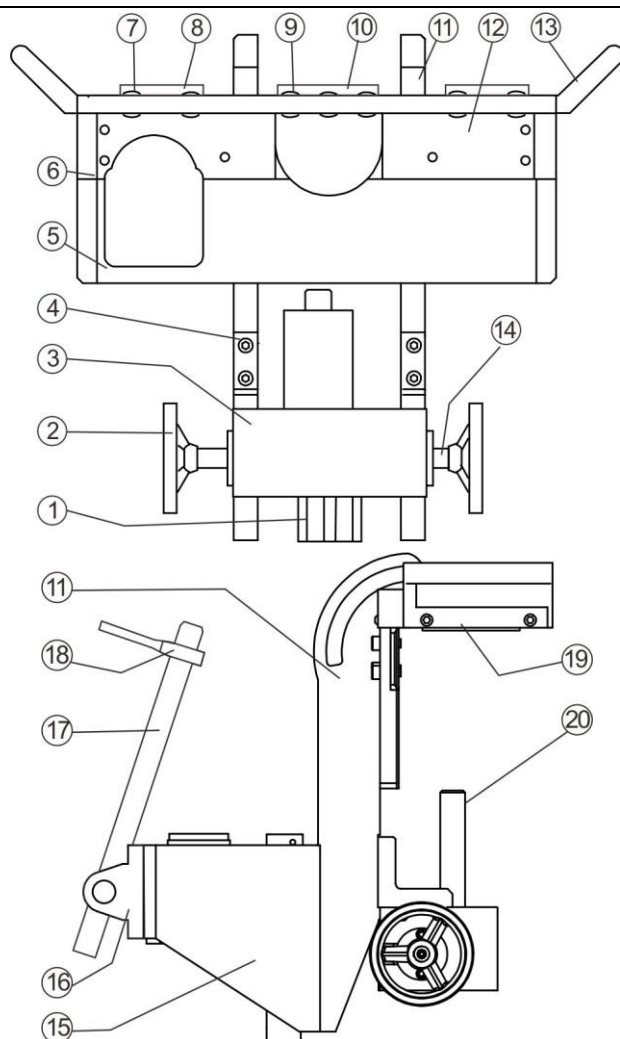
WBM Edge milling machine

1	Universal Wheel	80V01-001	4
2	Bolt	80V01-002	16
3	Electric Cabinet	80V01-003	1
4	Socket	80V01-004	1
5	Hand Pump	80V01-005	1
6	Scrap Box	80V01-006	1
7	Support Stand	80V01-007	1
8	Cover	80V01-008	1
9	Door Lock	80V01-009	1
10	Sliding Rail	80V01-010	1
11	Bolt	80V01-011	4
12	Slide Block	80V01-012	2
13	Spring	80V01-013	1
14	Hydraulic Cylinder	80V01-014	1
15	Hydraulic Tube	80V01-015	1



Part 2 :

No.	Name	Order NO.	QTY
1	Guide Rail	80V02-001	1
2	Hand Wheel	80V02-002	2
3	Reducer	80V02-003	1
4	Junction Plate	80V02-004	2
5	Fixed Plate	80V02-005	1
6	Wear Plate	80V02-006	1
7	Long Top Roller	80V02-007	4
8	Fixed Mount	80V02-008	4
9	Short top Roller	80V02-009	3
10	Fixed Mount	80V02-010	2
11	Angel Board	80V02-011	1
12	Wear Plate	80V02-012	1
13	Handle	80V02-013	2
14	Handle Wheel Shaft	80V02-014	2
15	Junction Plate	80V02-015	1
16	Connection plate	80V02-016	2
17	Screw	80V02-017	1
18	Ratchet Wrench	80V02-018	1
19	Top Board	80V02-019	1
20	Screw	80V02-020	1





WBM Edge milling machine

Part 3 :

No.	Name	Order no.	QTY	Diagram
1	Reducer	80V03-001	1	
2	Flange	80V03-002	1	
3	Main Shaft	80V03-003	1	
4	Bearing	80V03-004	8	
5	Driving Shaft	80V03-005	3	
6	Robber Roller	80V03-006	4	
7	Backer Plate	80V03-007	1	
8	Slide Block	80V03-008	2	
9	Junction Plate	80V03-009	2	
10	Gear Plate	80V03-010	1	
11	Cover	80V03-011	1	
12	Driven Gear	80V03-012	3	
13	Driven Shaft	80V03-013	3	
14	Driving Gear	80V03-014	4	
15	Bearing	80V03-015	6	
16	Raising Nut	80V03-016	1	
17	Bolt	80V03-017	4	

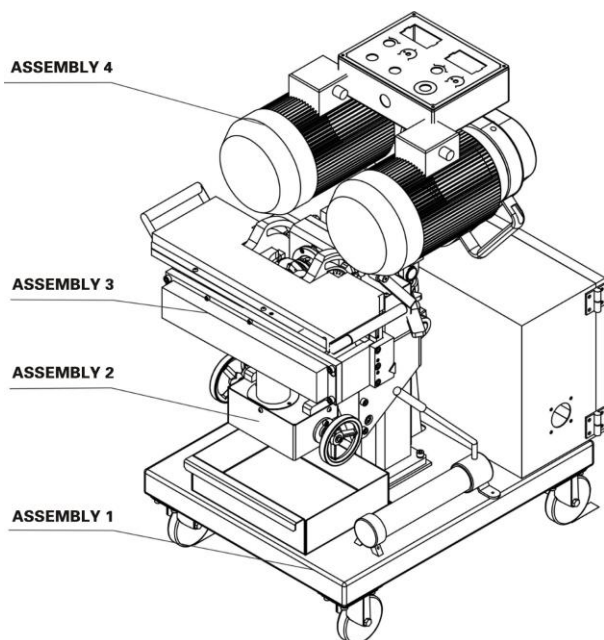
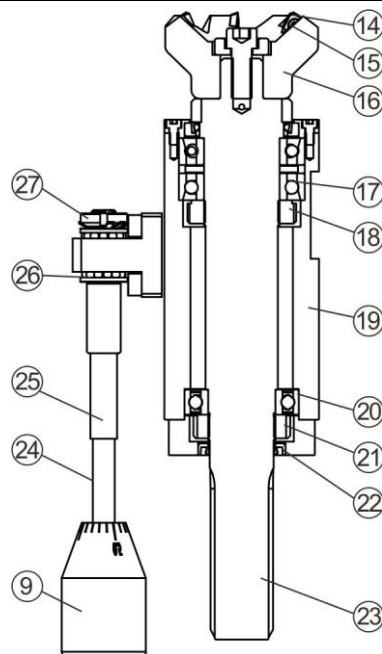
Part 4:

No.	Name	Order No.	QTY	Diagram
1	Rotator	80V04-001	1	
2	Spindle Housing	80V04-002	1	
3	Bearing	80V04-003	1	
4	Junction Plate	80V04-004	1	
5	Belt Sheave	80V04-005	1	
6	Cover	80V04-006	4	
7	Spline Hub	80V04-007	1	
8	Tighten Block	80V04-008	1	
9	Feed Wheel	80V04-009	1	
10	Belt	80V04-010	1	
11	Belt Sheave	80V04-011	2	
12	Motor	80V04-012	2	
13	Control Box	80V04-013	1	
14	Screw	80V04-014	6	
15	Inserts	80V04-015	6	



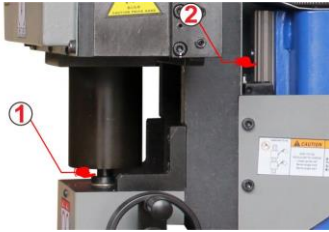
WBM Edge milling machine

16	Cutter Head	80V04-016	1
17	Bearing	80V04-017	2
18	Jam Nut	80V04-018	1
19	Spindle Sleeve	80V04-019	1
20	Bearing	80V04-020	1
21	Jam Nut	80V04-021	1
22	Seal Ring	80V04-022	1
23	Main Shaft	80V04-023	1
24	Calibration Set	80V04-024	1
25	Feed Screw	80V04-025	1
26	Bearing	80V04-026	2
27	Jam Nut	80V04-027	1



12. Lubrication & Cleaning

Lubrication Location	Lubricating Method	Period
Complete machine	Spray anti-corrosion oil, remove iron pin, and a dust-proof cover, straight in a dry place	3 months or a long time not to use
3 months or a long time not to use	Use a broom to clean up in time, so as to avoid excessive accumulation of equipment.	Clean up according to the actual situation
Reducer	Clean up the scraps by air compressor	While needed
	Add Gear oil	Life free maintenance
Control/Electric Box	Cover with dust and rain shield	When long time not to use
Inserts	Replace Inserts and screws in time when any broken found	As per manual point 7
Inserts Screw	If the knife is broken in the tray, please use the drill out	As per manual point 7
Main Shaft	Injet lubricating oil into the inlet on the side of spindle (Can not use grease instead)	Once every 3 months

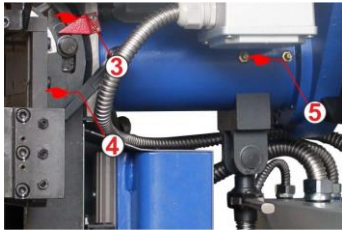


Lubricating Oil Injet and scraps cleaning

【 “1” Lead Screw】Adjust the thickness, Clean scraps, Spray anti-corrosion oil once a month;

【 “2” Guide Rail】Clean up the iron scraps every day, Spray lubricant if not use for a long time.

NOTE : Anti-corrosion oil can use [WD40]

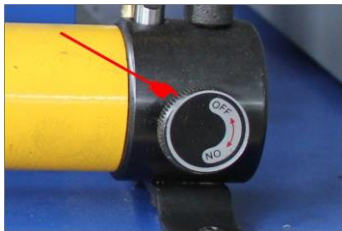


Lubricating Oil Injet and scraps cleaning

【 “3” Hole Angle】Clean up the iron scraps before adjust the angle,ad spray the anti-corrosion oil once a month;

【 “4” Guide Rail】Clean up the iron scraps everyday, spray the anti-corrosion oil once a month.

【 “5” Lead Screw】Spray the anti-corrosion oil once a month.

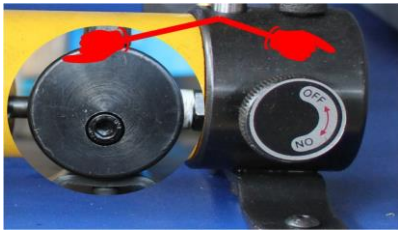
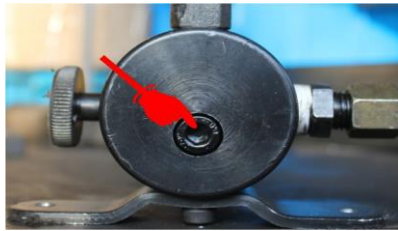
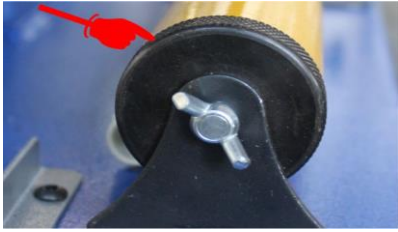
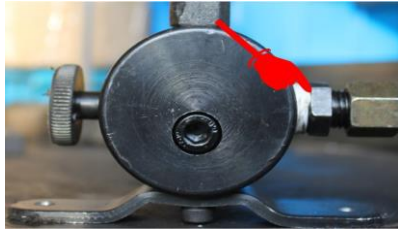


Hydraulic System Relief Pressure

Please rotate the relief valve knob to relieve the pressure on the hydraulic system after daily work or the machine is not used for a long time.

13. Common Trouble Repair And Maintenance


No.	FAULT		Maintenance & repair
1	No response from electrical equipment	No electricity	Check the wire of electricity
		Broken Line, Poor Connect	Check if anywhere broken line or poor connect
2	Electrical OK, Still no response	Emergency on	Rotate the emergency button
		Power lock not open	Move the key on the panel
3	Rotation Error	Spindle Rotate Error	Change the wire line sequence
		Feed motor rotate Error	Check the "Feed switch "" L or R" on panel"
4	Abnormal Noise	From Motor	Power supply shortage
		From Gear	Gear wear, inject with lubrication oil
5	Spindle not run	Over load	Power off and reset on the "Disconnect" (Refer to point 7)
		Lock nut off	Lock up the Jam Nut (Overload)
		Bearing Broken in main shaft	Change the Bearing
6	The compression can't be tightened		Check if any scraps stick on the rollers or plates
7	Workpiece ejected or deflected		Ensure if the feeding direction correct with request
8	Series Spark during operation	Overload	Reduce the bevel depth or speed,can add coolant properly when process stainless steel plate
		The Inserts wear	Replace Inserts
9	Inserts smashed with workpiece		Check if the inserts already contact with plate before feeding
10	Can't process with thin plate		Specified Working range for machine, Contact with supplier
11	Inserts cracks once start beveling		Reduce feeding depth
12	Feed wheel not working		Check if any problem on the feeding gear
13	Artifacts Skid	Low friction coefficient	Increase the friction of feed wheel and add force to the conveyor
		Feed speed doesn't match	Reduce feeding speed
14	Electric control Error or any others		Contact with supplier in time
15	Difficult to rotate the angel		Ensure if already loosen jam nut or any scraps in the rotate holes.

16	The hydraulic cylinder can't lift		
		Tap the manual pump head with a wooden rod	Remove the pump head and clean up the inner filter
			
	Oil Leaking	Open the back cover and fill into hydraulic oil	Rewind the raw tape for sealing
CAUTIONS			
<ul style="list-style-type: none"> ✧ Replace the direction of insert and fixing screws in time according to different factors of different processing materials, feeding depth, and cutting speed, etc. ✧ Recommend to replace the angle of insert cutting between 30-100m to protect the insert. ✧ Recommend to replace the screws of insert cutting between 30-100m to lower the risk of insert damage. <p>NOTE : The professional worker will decide if that can be taken out or not based on different situation if the screws are broken out, otherwise that may cause cutter head cannot work normally.</p>			

14. Packing List

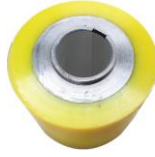


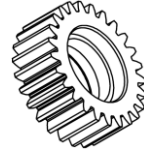
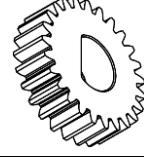
NO.	Description	Model	QTY	Unit	Remark
1	Plate Beveling Machine	WBM.80V	1	Set	
2	Insert	80V Use	2	Sets	Including the set on cutter head
3	Insert Screws	M3.5*8	2	Sets	Including the set on cutter head
4	Hex Wrench		1	Set	
5	Ratchet Wrench	19	1	PC	For angle adjustment
6	Knife Down Wrench	T15	1	PC	For insert replacement
7	Industrial Plug	4075	1	Set	Imported(On Electric Box)
8	Tool Kit	4111	1	PC	
9	Universal Wheels	5001	4	PC	Walking Wheel
10	Screws	M8*16	16	PCS	For fixing universal wheels
11	Operation Manual		1	PC	
12	Package Box	Wooden Box	1	Set	Fumigation-Free Export Package

15. Vulnerable Parts List

NO.	Part No.	Qty in set	Description	Picture	Remark
1	80VPCA300	6	Insert PDER-G		Replace period as per manual
2	80VM3508	6	Insert Screws M3.5*8		
3	80V0063	1	Cutter Head		When bolts break and can not take out, request to replace for new
4	80V005	4	Top Roller (Long)		Change period as per site situation
	80V006	3	Top Roller (Short)		



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5	80V007	4	Down Roller		Change period as per site situation
6	16006Z	8	Bearing (Market Standard)		Change period as per site situation
7	PK990	1	Belt PK750		Change period as per site situation
8	80 type	14	Copper Bush		For top Roller
9	25A10.03	3	Driven Gear		
10	25A10.02	4	Driving Gear		

NOTE: Inserts and screws are regular wear and tear parts which can stock accordingly. For other parts may need to replace, Please check as per your needs.