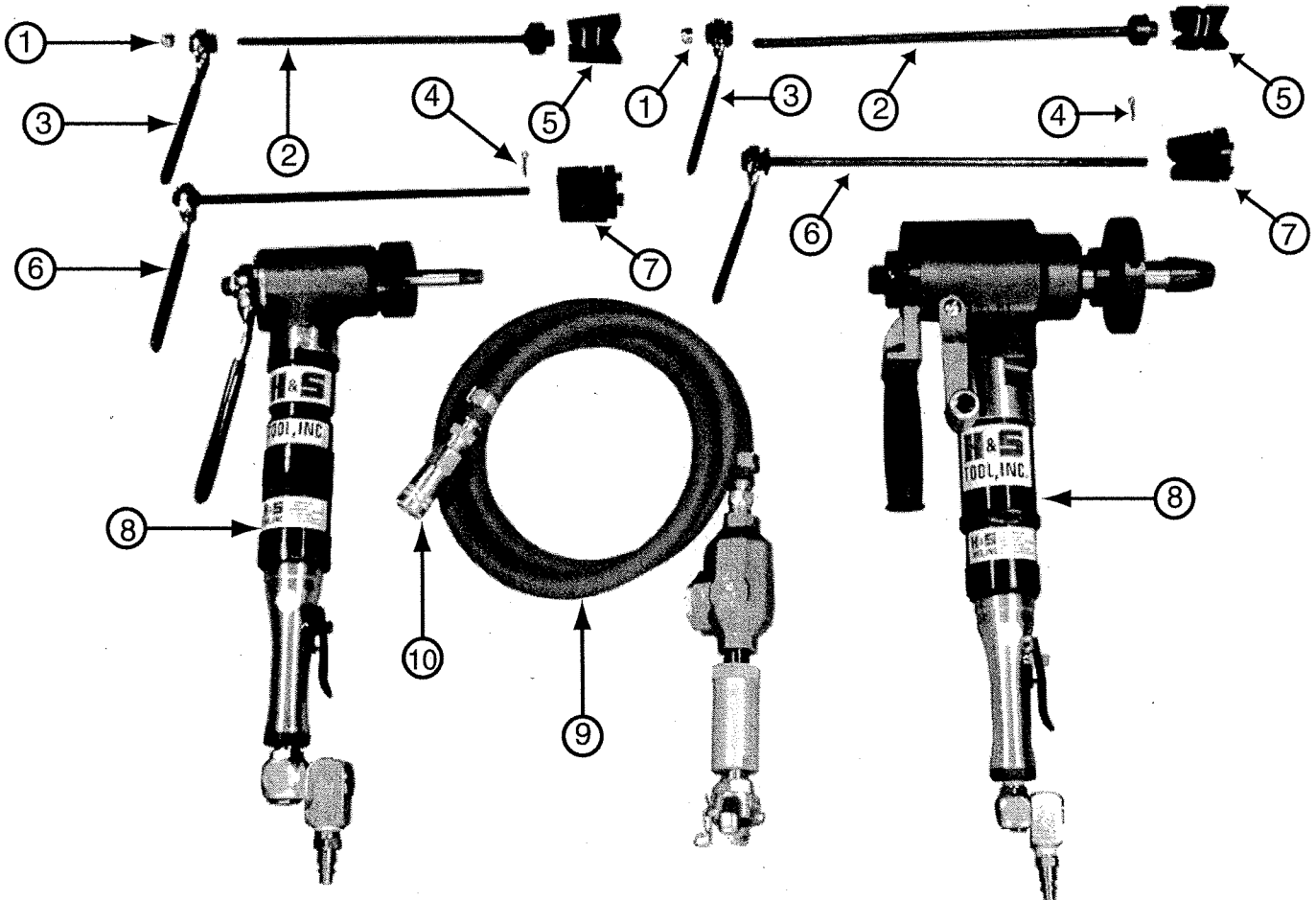




Smarter Tools for
Smarter Work

OPERATING INSTRUCTIONS BEVELLING MACHINES

MODEL 74805-0110



- 1— Lock Nut 2—Wedge Set Draw Rod 3—Locking Wrench 4—Cotter Pin 5—Wedge Set
6— Locking Wrench/Rod 7—Collet 8—Beveling Tool 9—Hose/Oiler Assembly 10—Quick Coupling



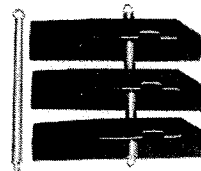
Collet/Draw Rod Assembly

Select the appropriate size of collet for the tube I.D. to be beveled. The I.D. size is stamped on the collet. Insert the collet rod through the centershaft from the rear of the tool. Thread the collet onto the draw rod until it touches the end of the center shaft. Insert the cotter

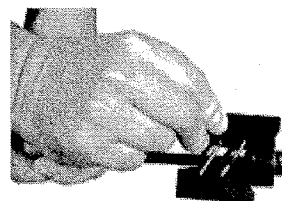
pin into the draw rod end and open the ends. This ensures that the collet will not be threaded off the end of the rod. Some centershaft ends have machined flats. If so, the tips of the collet ends must be aligned with the machined flats of the center shaft.

Wedge Set Assembly

Assemble the wedge sets by laying them on the flat side with the wedge guide grooves at the same ends. Place the springs through the holes



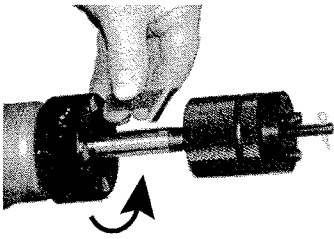
and connect the spring ends to form a circle. Once both springs are properly connected, slide



the assembly over the rod and hook the guide

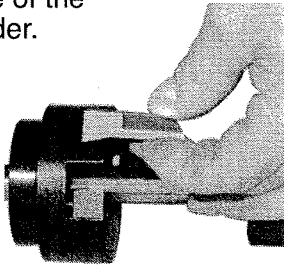
grooves into the cone slots. Insert the rod into the center shaft from the front. Thread on the draw nut/wrench assembly until it contacts the centershaft. The wedge ends are then aligned with the slots in the centershaft. Thread the self-locking nut onto the rod until it is flush with the rod end.





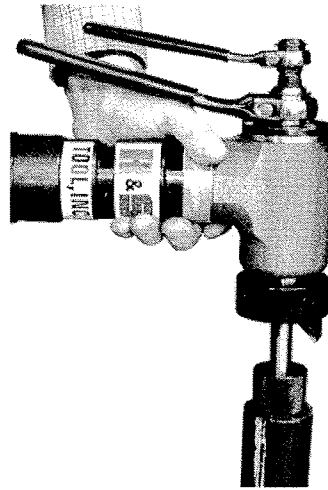
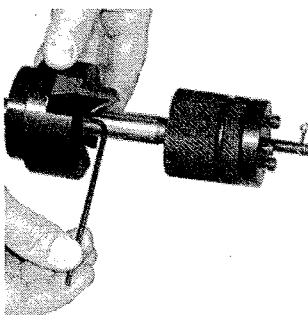
Tool Positioning, Fixed Tool Holder

The fixed position tool holders are designed to cover a wide range of tube diameters and beveling applications. Select the proper blade for the application to be performed. Place the shank in the proper tool holder location with the shoulder against the tool holder. The ground edge of the blade must be facing in the direction of the rotation. Lock the blade in position with the set screw on the side of the holder.



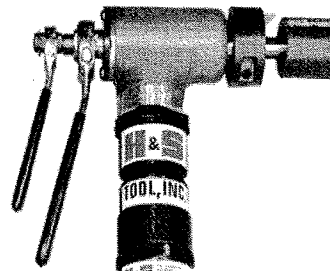
Blade Positioning, Sliding Tool Holder

Select the appropriate blade type for the application. Align the angled base of the blade with the angle of the tool holder blade lock. Slide the blade to the proper position for the tube size, lock the blade in position with the allen wrench provided.

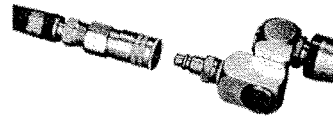
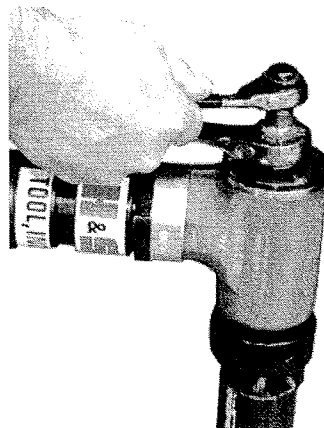


Place Into Tube

With the collet or wedge set properly assembled and the blades locked in position, make sure that the locking mechanism is retracted sufficiently to fit into the tube. Place the locking mechanism into the tube with the cutter safely away from the tube edge.

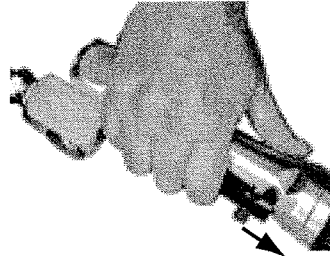


Lock the assembly in the tube with the draw rod locking wrench at the back of the tool. Tighten securely. (CAUTION: Over tightening can cause rod or locking mechanism failure!)

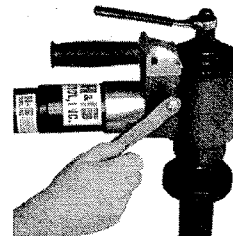
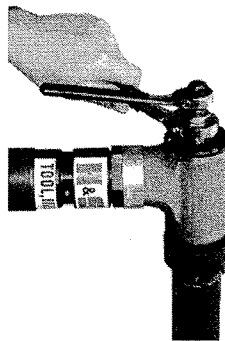


Tool Operation

Check to ensure that the wedge or collet is tightly locked in the tube and that the cutting blade is not touching the tube. Attach the air hose with the quick coupling provided.

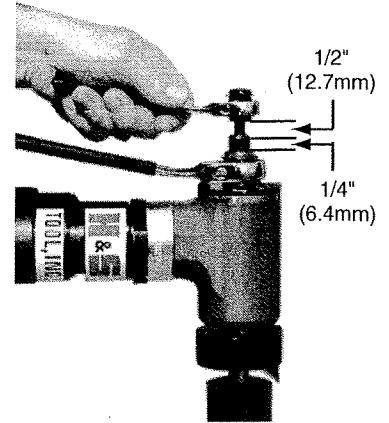


Make sure that there are no obstructions to the rotation of the head and blade, push the safety lock forward and squeeze the throttle handle.

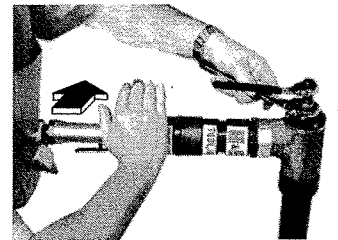


Depending upon the model being used, the blade is fed into the tube with the feed wrench or the crank feed. Once the blade engages the tube, gradually apply constant pressure until the desired bevel is achieved. If the tool stalls or RPM drops significantly, too much pressure is being applied to the blade.

Once the bevel is complete, reverse the feed wrench/crank and retract the tool to a position approximately 1/4" (6.4mm) from the end of the centershaft.



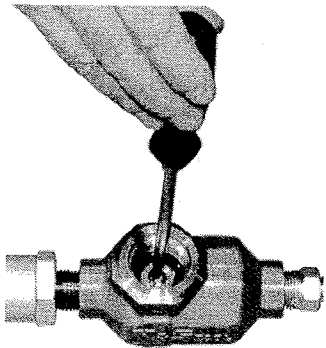
Reverse the locking wrench and loosen the draw rod until the nut is about 1/2" (12.7mm) away from the end of the centershaft.



The locking can be so secure that the tool must be jarred to release it. Use the heel of your hand to bump the tool laterally.

Never strike the tool holder, gear housing or air motor with a hammer or other hard object.

Safety Recommendations



Oiler Adjustment

An in-line oiler is provided with each tool. To ensure proper lubrication, start the machine and hold a sheet of paper up to the exhaust ports. There should be a mist of oil on the paper. If there is enough that the oil runs on the paper, it is too much. If there is no mist, it is not enough.

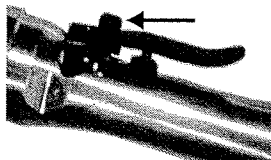
To adjust it, remove the cover from the oiler body. The adjusting screw is in the center. With a straight blade screwdriver, turn the screw clockwise to reduce the amount or counter clockwise to increase the oil feed.



General Safety

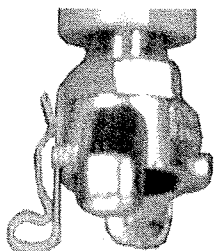
Always wear your head, eye, ear and hand protection.

Protective clothing should be worn. Avoid loose fitting clothes and long hair that may get caught in the rotating head and blade.



Do not operate the tool if the throttle safety lock is not functioning properly. Push the lock forward to operate the throttle.

Never lock the throttle open. Do not put anything on the tool that will interfere with the dead-man release operation.



A hitch pin is provided on the coupling for the supply line. When the coupling is secure, always use this pin to lock the coupling from accidental release.



Injury Potential

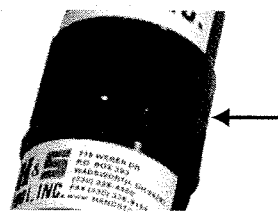
Keep hands, long hair and clothing away from rotating parts!

In most beveling applications, it is necessary for the cutting blades to be exposed and unguarded. The blades are sharp and can pose an injury hazard.

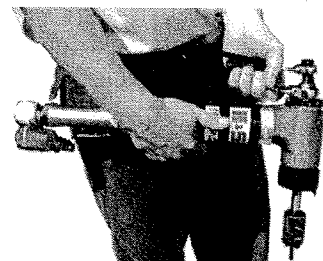


Injury Potential

The tool can rotate in the tube if the wedge/collet is not locked properly. Be aware of adjacent objects to avoid potential pinch points.



The exhaust ring on the air motor can be rotated 360°. Check this position prior to starting the tool to avoid spraying oil and air borne contaminants into you.



Never pickup or lower the tool by the air hose. Always grasp it firmly around the barrel of the motor.

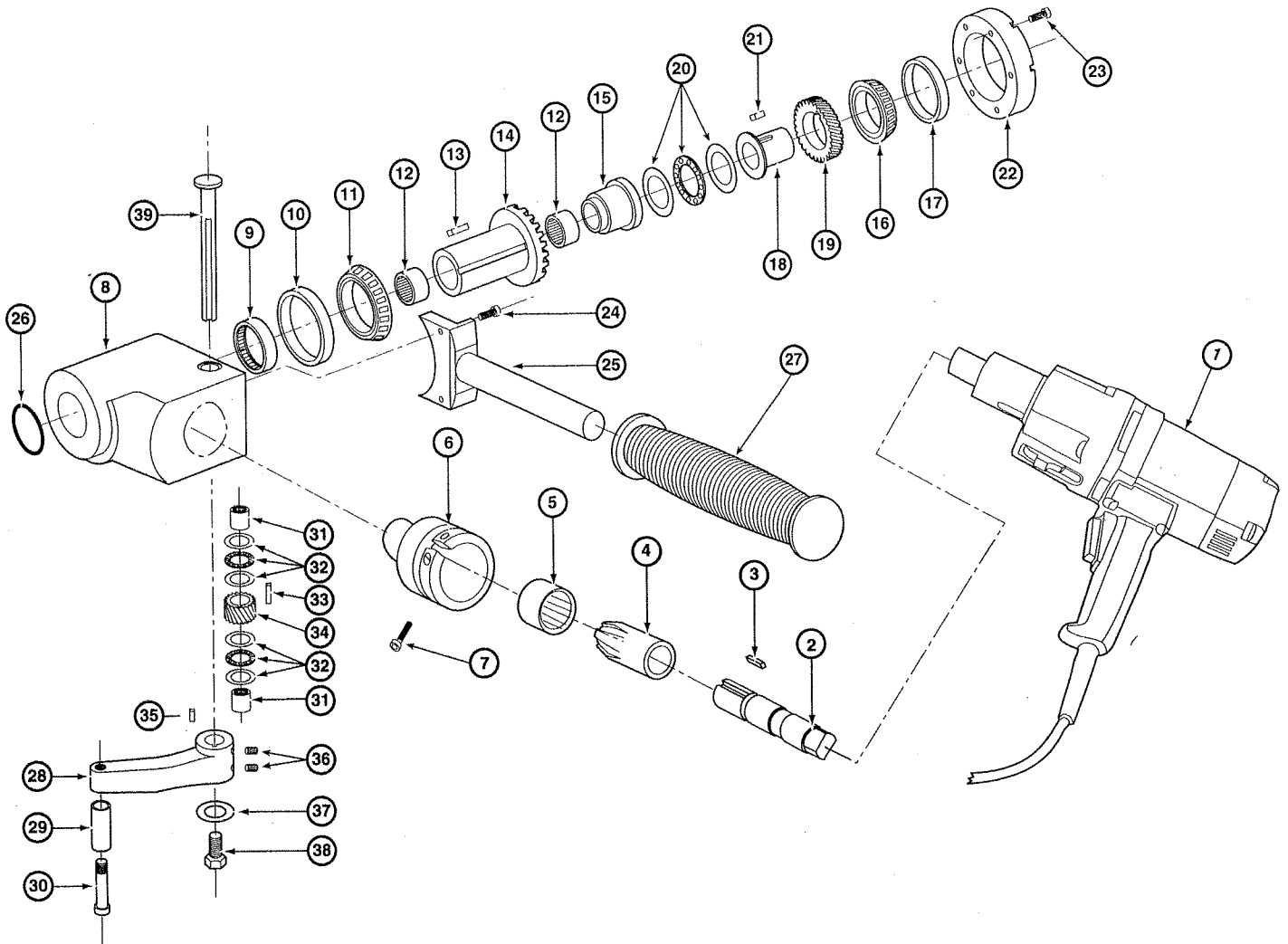


Smarter Tools for Smarter Work



Smarter Tools for Smarter Work

Parts List

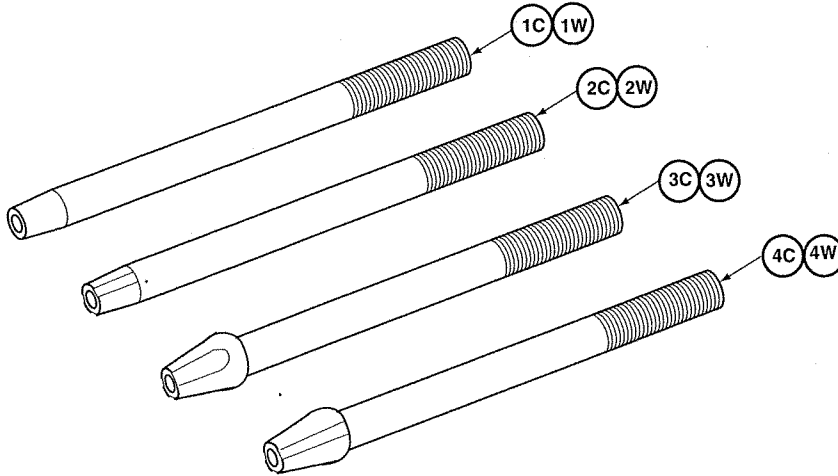


Reference No.	Part No.	Description
1	EMB 003610	Electric Motor
2	EMB 003611	Drive Shaft
3	EMB 003612	Key
4	MB 003490	Pinion Gear
5	MB 001816	Needle Bearing
6	EMB 003613	Adapter
7	EMB 003614	Socket Head Screw
8	MB 003520	Housing
9	MB 000228	Needle Bearing
10	MB 078310	Bearing Cup
11	MB 078349	Tapered Roller Bearing
12	MB 001412	(2) Needle Bearing
13	MB 003494	Keystock
14	MB 003495	Main Gear
15	MB 003521	Centerpiece

Reference No.	Part No.	Description
16	MB 067045	Tapered Roller Bearing
17	MB 067010	Bearing Cup
18	MB 003523	Feed Nut
19	MB 003524	Helical Gear
20	MB 000078	Thrust Bearing
21	MB 003522	Keystock
22	MB 003525	Centershaft Lock
23	MB 102410	(6) Socket Head Cap Screw
24	MB 142034	(2) Button Head Cap Screw
25	MB 003526	Handle
26	MB 000220	O-Ring
27	MB 078414	Rubber Grip
28	MB 003527	Feed Handle

Reference No.	Part No.	Description
29	MB 003528	Feed Handle Knob
30	MB 038100	Shoulder Bolt
31	MB 000068	(2) Needle Bearing
32	MB 000010	(2) Thrust Bearing
33	MB 003529	Keystock
34	MB 003530	Helical Gear
35	MB 003531	Keystock
36	MB 142014	(2) Socket Head Set Screw
37	MB 003533	Washer
38	MB 083212	Socket Head Cap Screw
39	MB 003532	Crank Shaft

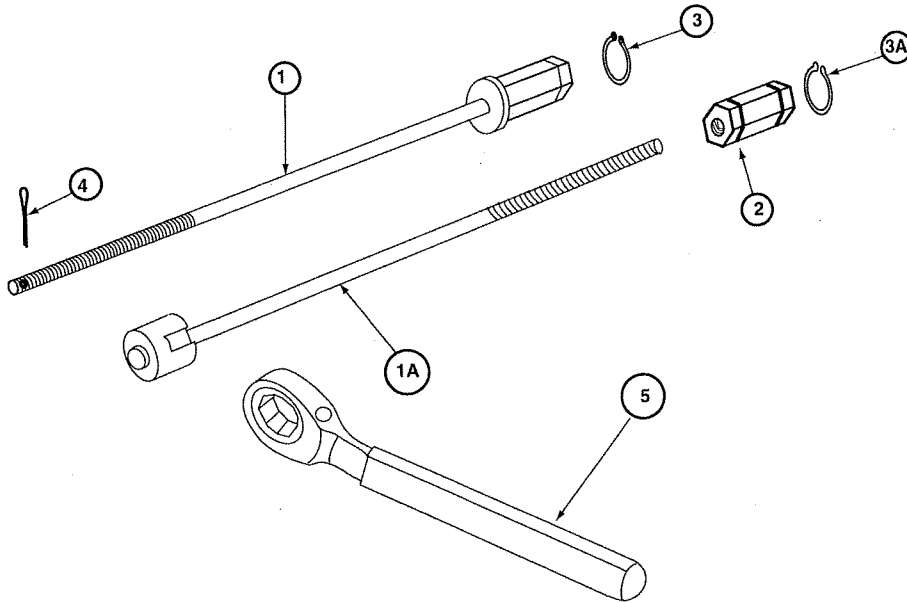
Center Shafts



Reference No.	Part No.	Description
1C	MB 003545	Crank Feed 7° Centershaft, Collet
1W	MB 003546	Wrench Feed 7° Centershaft, Collet
2C	MB 003547	Crank Feed 7/8" Centershaft, Wedge
2W	MB 003548	Wrench Feed 7/8" Centershaft, Wedge
3C	MB 003549	Crank Feed 10° Centershaft, Collet
3W	MB 003550	Wrench Feed 10° Centershaft, Collet
4C	MB 003551	Crank Feed 1-1/4" Centershaft, Wedge
4W	MB 003552	Wrench Feed 1-1/4" Centershaft, Wedge

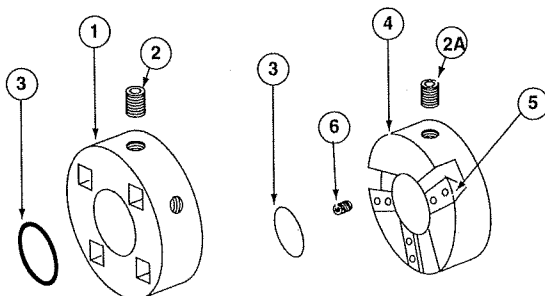
C = Crank Feed Model
W = Wrench Feed Model

Wedge and Collet Locking Rods



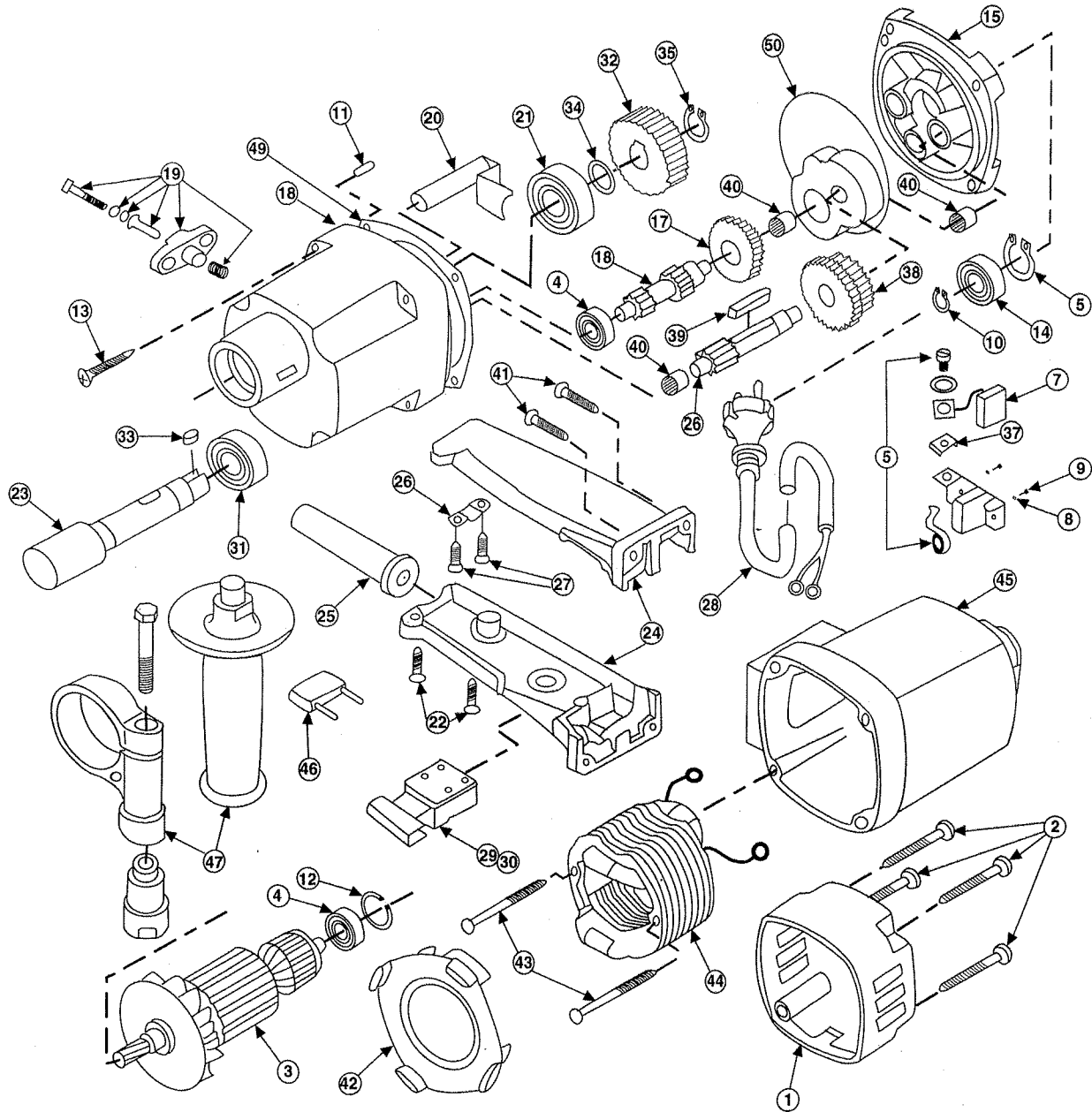
No.	Reference Part No.	Description
1	MB 003560	Collet Rod
1A	MB 003561	Wedge Rod, 7/8" O.D. Head
1A	MB 003562	Wedge Rod, 1-1/4" O.D. Head
2	MB 003563	Wedge Rod Nut
3	MB 003564	Retainer Ring, Collet
3A	MB003564	(2) Retainer Ring, Wedge
4	MB 003565	Cotter Pin, Collet
5	MB 003566	Rod Wrench
5	MB 003566	Rod Wrench

Standard Tool Holders



Reference No.	Part No.	Description
1	MB 003570	3" Tool Holder, Fixed
2	MB 003571	(5) Tool Holder Set Screw, Fixed
2A	MB 003571	Tool Holder Set Screw, Sliding
3	MB 003572	O-Ring, Tool Holder
4	MB 003573	3" Tool Holder, Sliding
5	MB 003574	(3) Blade Lock, Sliding
6	MB 003575	(3) Differential Screw

Electric Motor



Reference No.	Part No.	Description	Reference No.	Part No.	Description	Reference No.	Part No.	Description
1	7132A240	Cap, Motor	23	71323420	Drive Shaft	44	7132D150	Field
2	80201267	(4) Screw	24	80900097	Handle Halves	45	7132A200	Motor Housing
3	7132D100	Armature	25	71323255	Cable Sleeve	46	80500010	Condensor
4	80410011	Bearing	26	71540330	Locking Flange	47	7132A695	Handle Assembly
5	80201333	Safety Ring	27	80201270	(2) Screw	49	77324620	Seal, Gear Box
6	80201196	Brush Holder	28	80600060	Connection Cable	50	7132A625	Grease Chamber
7	80700013	Brush	29	80600143	Switch			
8	80201385	Lock Washer	30	80600140	Switch "S"			
9	80201180	Screw	31	80410152	Ball Bearing			
10	80201320	Safety Ring	32	71323430	Gear			
11	80200582	Notched Pin	33	80200601	Key			
12	83000036	O-Ring	34	80020504	Fitting Washer			
13	80291284	(4) Screw	35	80201322	Locking Ring			
14	80410031	Bearing	36	71223460	Gear Shaft			
15	7132A610	Gear Cap	37	73320210	Contact Washer			
16	71323400	Gear Housing	38	71323440	Gear			
17	7132A470	Gear	39	80200602	Fitting Spring			
18	71323500	Gear Shaft	40	80420110	(2) Needle Sleeve			
19	71540545	Gear Switch	41	80201280	(2) Screw			
20	71323520	Shift Arm	42	7132A140	Air Guiding Ring			
21	80410130	Bearing	43	80201226	(2) Screw			
22	80201271	(2) Screw						

