



The tools of innovation.

**Beveling machine with variable angle
and automatic feed
DOUBLE-SIDED BEVELLER DBM50**



3D adaptive system



Operating and maintenance manual

Customer _____

Model _____

Serial number _____

Year _____

A copy of this manual is delivered with every beveling machine.

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General information

1.1 Introduction

We thank you for buying one of our machines and hope you will be fully satisfied with it.

This manual contains all instructions for installation, adjustment, operation and maintenance of the machine.

DOUBLE-SIDED BEVELLER DBM50 in conformity with valid safety standards.

Information and data in this manual are subject to change as a result of further improvement of our machines. If you find any difference, please contact STEELMAX to remove any doubts.

Never perform any operations on the machine until you have read and understood the instructions in the manual. Most of the accidents occurring at the workplace are caused by non-observance of instructions and recommendations contained in the manual.

Graphic symbols are used in this manual to highlight important information regarding safety and operation of the machine.



Warning:

Important information for the operator's personal safety.



Important:

Instruction which must be followed for the correct machine operation.

1.2 Tests

The beveling machine is tested in our test room.

During this test, the correct function of the electric system and beveling of plates and sections of different types and sizes is verified.

1.3 Guarantee

The manufacturer grants the guarantee for the beveling system DBM50 covering defects of material and workmanship of the machine for the period of 12 months from the date of its delivery.

The Seller undertakes to remove all contingent defects covered by this guarantee, free of charge and without undue delay, so that the Purchaser can use the machine properly. If the Purchaser sets up a claim regarding the liability for defects which are not covered by the guarantee, s/he shall reimburse the related costs to the Seller.

The guarantee does not cover natural and common wear of the goods as well as defects resulting

from incorrect use of the goods in contradiction with the training and documentation provided. Further, the guarantee does not cover defects caused by overloading of the goods as well as

defects occurring after unqualified repair or modification of the goods. Unqualified repair or modification apply to any repair or modification executed in contradiction to the training or documentation provided, or executed by a person other than the Seller or a person entrusted or approved by the Seller.

The claim regarding the liability for defects must be made to the Seller without undue delay after the Purchaser has found the defect and before the end of the guarantee period at the latest, otherwise the claim expires.

To make a claim regarding the liability for defects on the basis of the guarantee granted, the Seller must present the guarantee certificate.

The Seller's liability for defects covered by the guarantee does not arise if the defects were caused after the transfer of risks of damage to the goods by external factors. The external factors particularly include natural disasters, force majeure or third persons' acts.

STEELMAX. considers the guarantee invalid in the event of:

- improper use of the machine;
- use in contradiction with national or international standards;
- incorrect installation;
- defective electric power supply;
- serious maintenance faults;
- unauthorized modifications or repairs;
- use of unoriginal or incorrect spare parts and accessories for the given model;
- partial or total infringement of the instructions;
- abnormal events, natural disasters, and others.

1.4 Identification data

The identification data of the beveling machine are indicated on the aluminium CE label located at the top of the bearing box.

1.5 Reference standards (CE-Declaration of Conformity)

Directive 2006/95/EC:	Electrical Equipment designed for use within certain voltage limits
Directive 2004/108/EC:	Electromagnetic compatibility
Directive 2006/42/EC:	Safety of machinery - Basic requirements
EN ISO 12100:	Safety of machinery – General principles for design
EN ISO 13857::	Safety of machinery – Safety distances to prevent hazard zones being reached by upper and lower limbs
EN 953 A1:	Safety of machinery – General requirements for the design and construction of fixed and movable guards
EN 60204-1:	Safety of machinery – Electrical equipment of machines
EN 61000-6-3:	Electromagnetic compatibility - Generic standards - Emissions - Residential, commercial and light-industrial environments

SAFETY**2.1 Safety recommendations****Warning:**

Read carefully the following instructions to prevent work accidents and/or property damage.

- Never try to operate the machine until you have thoroughly familiarized yourself with the way it functions. If you still have doubts after having read this manual carefully and fully, please contact the STEELMAX company.
- Make sure that all the technical workers who are to use and maintain the machine have been fully familiarized with all safety recommendations.
- The machine can only be transported and installed by specialized workers in conformity with the instructions in this manual.
- Before starting the machine, the operator must check that all safety devices are functional and all safety covers are in place.
- Never use the machine for purposes other than those specified in the manual. Never process other products than those specified.
- Before using the machine for other purposes, contact the STEELMAX company to ask for permission.
- Voltage values used for supplying the machine are dangerous: see that all connections are fixed properly; never maintain the machine or change parts unless you have disconnected the power supply; never connect any branch lines to electric connections.
- Only replace defective parts with those recommended by the manufacturer. Never use any unoriginal parts.
- Never wear clothes or jewellery which may get caught by the moving parts. Protective clothing is recommended: footwear with anti-slip soles, ear protectors and protective goggles.

**Important:**

If during the machine service life any defects occur which cannot be removed according to this manual, it is recommendable to contact the STEELMAX, company which will resolve the problem as soon as possible.

2.2 Safety labels

Safety labels are fixed on the beveling machine to protect the operators.

Meaning of the labels:

This label is fixed on the electric panel of the beveling machine and indicates presence of high voltage.



Do not remove this label from the machine.

2.3 Operator's qualification and protection

The employer is obliged to inform the operators on the safety standards; additionally, s/he must ensure their observance and see that the working area is sufficiently large and well illuminated.

The term "operator" designates a person who installs, operates, adjusts, maintains, cleans and repairs the machine.



Warning:

Before starting the work, the operators must be familiarized with the machine properties and must have read this manual.



Warning:

The operators must always:

1. See that all the safety covers are mounted and the safety devices are functional before starting the machine.
2. Avoid wearing clothes or jewellery which may get caught by the moving parts.
3. Wear the approved protective clothing, such as footwear with anti-slip soles, ear protectors and protective goggles.
4. Apply safety standards, see that they are observed at all times and, if in doubt, consult this manual again before taking any measures.
5. Contact the machine supplier if s/he unable to resolve the defects causing malfunction of the machine, if the defects concern to defective parts or irregular running.

Safety devices

The machine is equipped with safety covers to isolate the zones potentially dangerous for the operator. These covers are screwed onto the machine frame. They can be removed with suitable wrenches. This operation may be necessary during certain maintenance activities.



Warning:

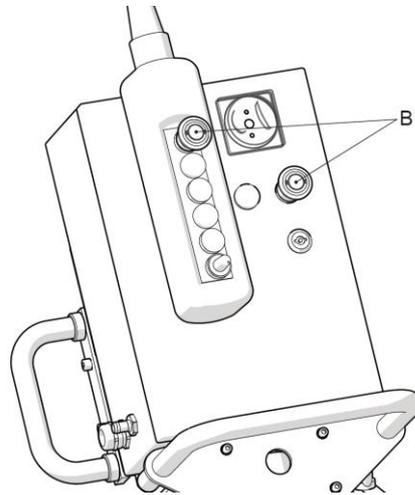
The cover can only be removed if the machine is stopped and the power supply plug removed from the socket. Never operate the machine without safety covers mounted.

The machine is equipped with a mushroom-like red emergency button which stops the machine immediately, suppressing all other operations (position B, Fig. 2.4.1).

This emergency button is used:

- in case of immediate danger or mechanical accident;
- for short interventions when the machine has already been stopped, to maintain the machine in this state.

Fig. 2.4.1



2.4 Residual risks

The machine has been designed and manufactured with all equipment and accessories providing for the operator's safety and health protection.

The machine is covered completely to eliminate the risk of contact with moving parts as much as possible.

There is, however, one residual risk.

As mentioned above, the working zone strongly protected; however, it must remain partly open so that the material bevelled can be inserted.

It is therefore possible for the operators to insert their fingers in this zone, in which both the cutting tool and work-piece holder are located.



Warning:

Always keep your hands as far from the cutting zone as possible.



Warning:

Always apply the safety rules contained in the manual and see that they are observed and all residual risks are eliminated.

TECHNICAL SPECIFICATIONS

3.1 Machine description

The beveling machine, model DBM50, has small dimensions. One of its main characteristics is the adjustable bevel angle and automatic material feed.

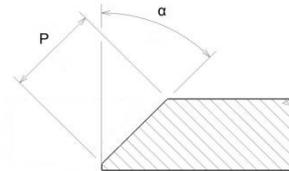
The machine is equipped with a milling cutter, sturdy work-piece holder, direct reading scale used for setting of values (bevel size, material thickness and machining angle adjustment), and a special guide which facilitates insertion of the material.

These characteristics enable easy adjustment of the working angle and precise control of the bevel size.

The DBM50 beveling machine is reliable and necessitates minimum maintenance only.

3.2 Technical data

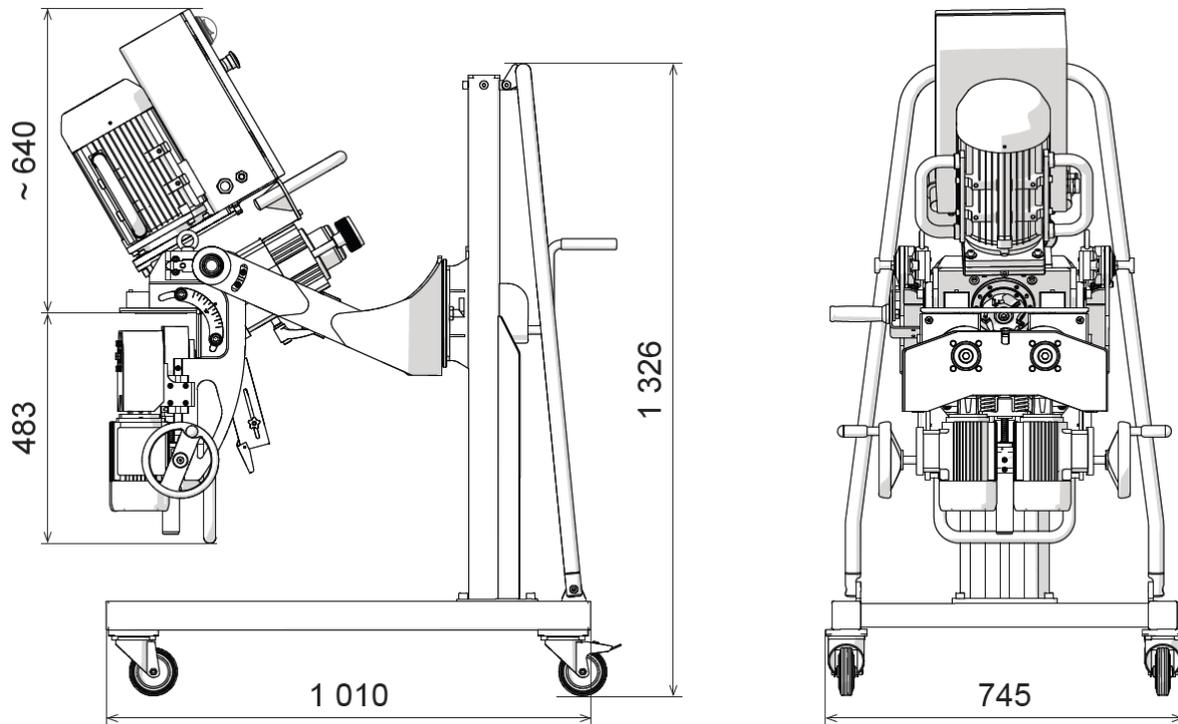
Tool drive	ACA1001C-4/HE	
Motor	1x	IP55
Motor output	4	kW
Motor speed	1435	rpm
Spindle speed	685	rpm
Tool diameter	85	Mm (3.35")
Tool teeth number	5	
Feed		
Motor	2x	FCA63B-6 IP55
Motor output	0.12	kW
Motor speed	890	rpm
Gearbox	2x	HF40
Gear ratio	1:200	
Feed range	0-1.2	m*min (according to cutting conditions)
Plate thickness	7 - 70 mm (0.28 – 2.76") (60 mm (2.36") with the first 8 machines)	
Angle range	15-60° (continuously)	


Bevel size for steel at the individual angles

angle	α	max. bevel width (P)
	15°	2.44"-62 mm (recommended machining in 3 steps)
	20°	2.44"-62 mm (recommended machining in 4 steps)
	25°	2.20"- 56 mm (recommended machining in 4 steps)
	30°	2.05"-52 mm (recommended machining in 5 steps)
	35°	2.01"-51 mm (recommended machining in 5 steps)
	40°	2.01"-51 mm (recommended machining in 5 steps)
	45°	1.97"-50 mm (recommended machining in 5 steps)
	50°	2.01"-51 mm (recommended machining in 5 steps)
	55°	2.01"-51 mm (recommended machining in 5 steps)
	60°	2.05"-52 mm (recommended machining in 5 steps)

Dimensions: Fig. 3.2.1.
Weight: 385 lbs. - 175 kg

(*) The exact values of voltage and frequency are indicated on the motor identification plate.

Fig. 3.2.1.


3.3. Noise level

The machine has been designed and manufactured to emit as little noise as possible.

In some cases and working conditions, the continuous sound pressure level according to measurement A exceeded 85 dBA. The worker must use ear protectors.

3.4 Working environment conditions

The working environment of the machine must conform to these values:

Temperature:	32°F - 122°F , 0 °C - 50 °C
Humidity.	10 % - 90 % (non-condensing)

The machine must be protected from rain and moisture.

Working environment conditions different from the above-mentioned ones can cause serious damage to the machine, especially to its electric equipment.

If the machine is out of operation, it can be stored at a place with the temperature within the range of:

14°F - 158°F , -10 °C to 70 °C

All the other values remain unchanged.

INSTALLATION

4.1 Transport and lifting

**Important:**

The activities described in this section can only be executed by qualified personnel.

Suitable unloading and setting devices (cranes, lift trucks, etc.) must be ready at the destination place).

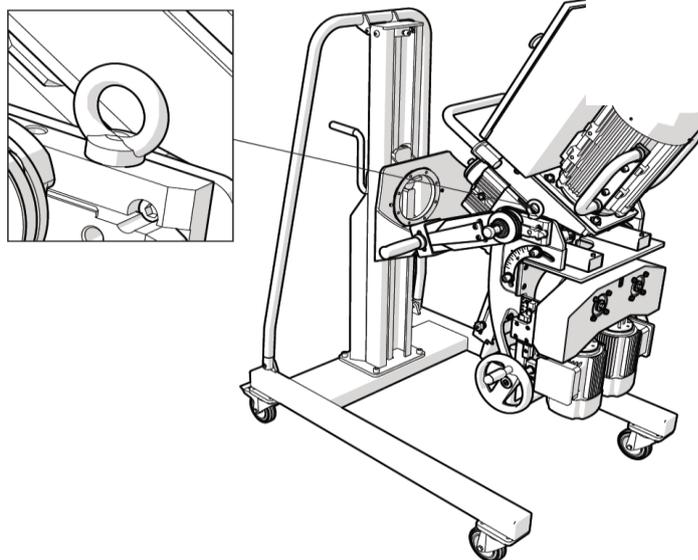
When the machine has arrived at the destination, check (in the carrier's presence) whether it meets the order specifications and was not damaged during transport. If you find any damage or parts are missing, immediately inform STEELMAX and the carrier in detail.

**Warning:**

Observe the following instructions and ensure safe handling with the machine:

- Keep your distance from hanging loads and make sure that the lifting device and pertinent tools are in perfect order and are suitable for the weights indicated in Par. 3.2.
- When handling the machine, wear protective clothes, like work gloves, footwear with anti-slip soles and a hardhat.
- If the machine is in its transport package, remove and dispose of it in conformity with valid laws of your country.
- If you are to lift the machine with a crane, use suitable textile or chain lifting devices. Lifting eyes are mounted on the machine (see Fig. 4.1.1.)

Fig. 4.1.1



4.2 Location and connection



Important:

The activities described in this section can only be executed by qualified personnel.

If the machine is used for machining small parts, it must be set on an even surface and secured with a brake against movement (Fig. 4.1.1).

If the machine is used for machining big parts, it must be located on the actual work-piece and move upon it during work by itself. If you will not use the 3D manipulator, it is suitable to suspend the machine on a band, see Fig. 4.1.1, during approach to the material and leaving it at the end.

During electric connection, proceed as follows:

- check the frequency and voltage value on the motor identification plate;

- connect the cable end to the power supply with a plug according to your local power network.

4.3 Checks before commissioning



Important:

Never start DBM50 without the checks described in this paragraph.

Before starting the machine, check that it is operational by means of the following inspections and checks to achieve maximum efficiency and meet the safety regulations:

- **check that all screws and other parts are tightened;**

- check that all electric connections have been made correctly and the electric cable is fixed in place with a cable tie;

- To start the machine, proceed as follows:
 - Unlock the machine with the red emergency lockable button (position B, Fig. 2.4.1.).
 - Start the motor with the green button. The milling cutter must rotate clockwise.**
 - If it does not, you must switch the phases in the plug.

- To switch off the machine, push the red button next to the start switch.

4.4 Scrapping and disposal

When disposing of the UZ15 machine, remember that the materials from which it is manufactured are not hazardous, comprising mainly:

- ferrite steel, painted or metalized;
- stainless steel, series 300/400;
- plastic material of different character;
- gearbox oil;
- electric motor;
- electric cables and pertinent jackets;
- electric monitoring and exciting devices.

Follow this procedure:

- observe valid laws of your country regarding the working environment safety;
- disconnect the machine from power supply;
- dismantle the machine and classify the parts according to their chemical characteristics;
- scrap the machine parts in conformity with valid laws of your country;
- during the dismantling phase, strictly observe valid regulations regarding labour safety.

USE

5.1. Correct use

The beveling machine, model DBM50, has been designed, manufactured and sold for beveling metal parts and rolled metals of these kinds: iron, steel, stainless steel, brass, copper, aluminium. DBM50 is designed for beveling materials of larger formats and thickness, located on supports or working tables. The plate must be placed at the height of 27.5" – 43.3" , 700 mm to 1100 mm.

To machine material of small dimensions, which you want to insert in the machine directly "by hand", you must install a special insert for processing small material formats (to be delivered in 2013 at the latest).

The maximum and minimum bevel dimensions and thickness of the material machined are indicated in detail in chapter 3, par. 3.2 "Technical specifications".

Other uses different from the above described are considered improper. Namely, it is forbidden to:

- machine products different from those for which the machine has been designed or sold;
- modify the machine operation;
- replace parts with unoriginal parts;
- modify electric connections, thus defeating the internal safety devices;
- remove or modify protective covers;
- use the machine at places with explosive atmosphere.



Warning:

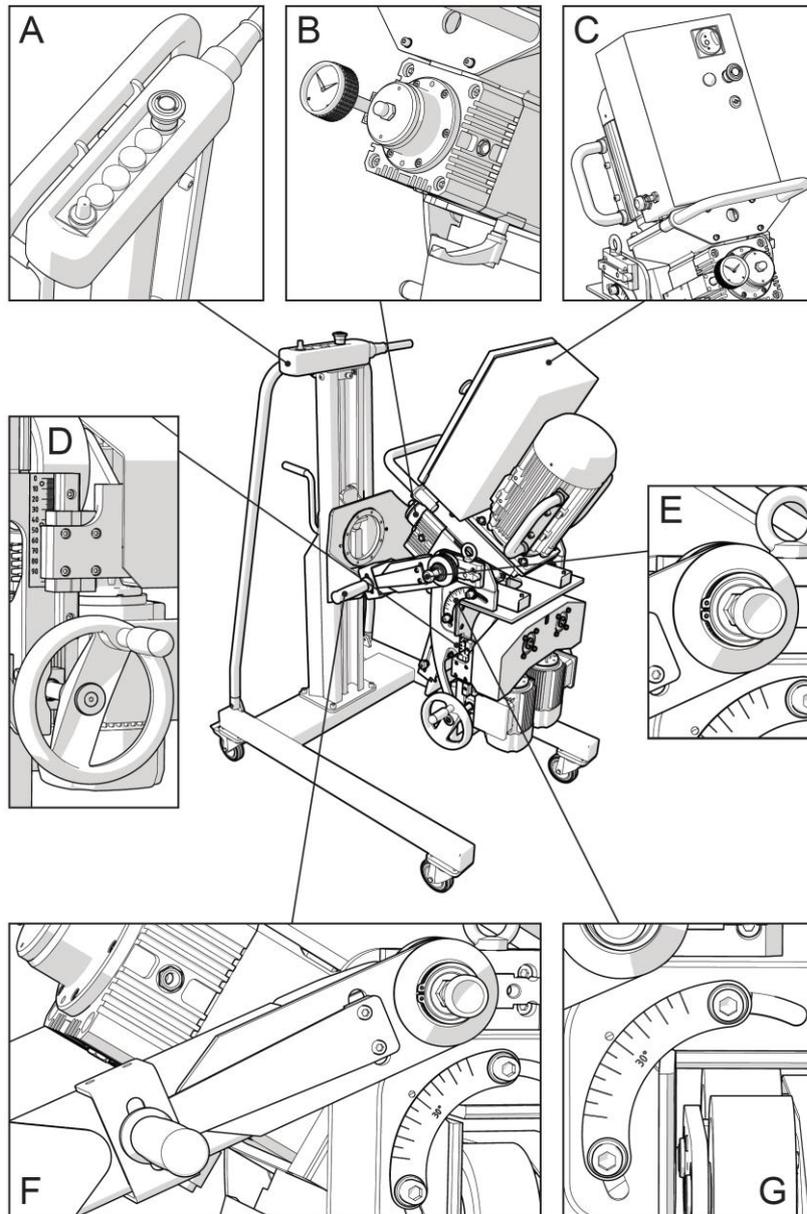
It is strictly forbidden to bevel materials different from those indicated because their processing may pose a risk to the operator and damage the machine.

Before making any modifications, you must ask the STEELMAX company for the pertinent approval. Otherwise the STEELMAX company disclaims any responsibility.

5.2. Description of controls

The beveling machine is controlled by means of control elements located on the distribution box and the remote controller.

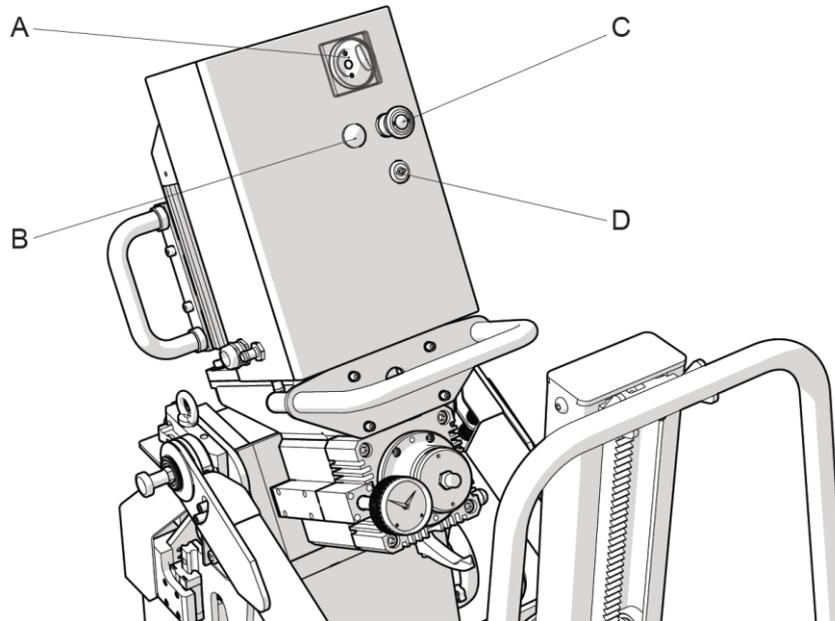
Fig. 3.1.1.



- A- Remote control with feed speed control and a magnetic holder
- B- Elements for adjusting the bevel size
- C- Distribution box with the main and emergency switch and standby mode button
- D- Elements for adjusting the lower slide
- E- Lock for disconnecting the 3D manipulator
- F- Control lever of the machine inclination
- G- Angle adjustment detail

Distribution box

Fig. 5.2.1.

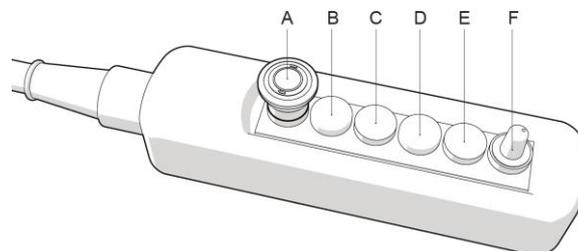


- a) Main on/off switch
- b) Standby mode button
- c) Safety emergency button which immediately stops the machine
- d) Distribution box lock

Remote controller

The remote controller is equipped with magnets and can be attached to the machine or held in hand according to current conditions.

Fig. 5.2.2.



- a) Safety emergency button which immediately stops the machine
- b) Switching the spindle on. Pushing the button switches the motor on. Heed the tool rotation direction.
- c) Switching the spindle off
- d) Switching the feed on
- e) Switching the feed off
- f) Feed speed control

5.3. Preliminary adjustments

**Warning:**

Wear protective work gloves when making the adjustment. The operations must be executed if the machine is stopped and disconnected from power supply.

Before starting your work, you must perform the following adjustments:

Adjust the bevel angle

The bevel angle can range from 15° to 60°.

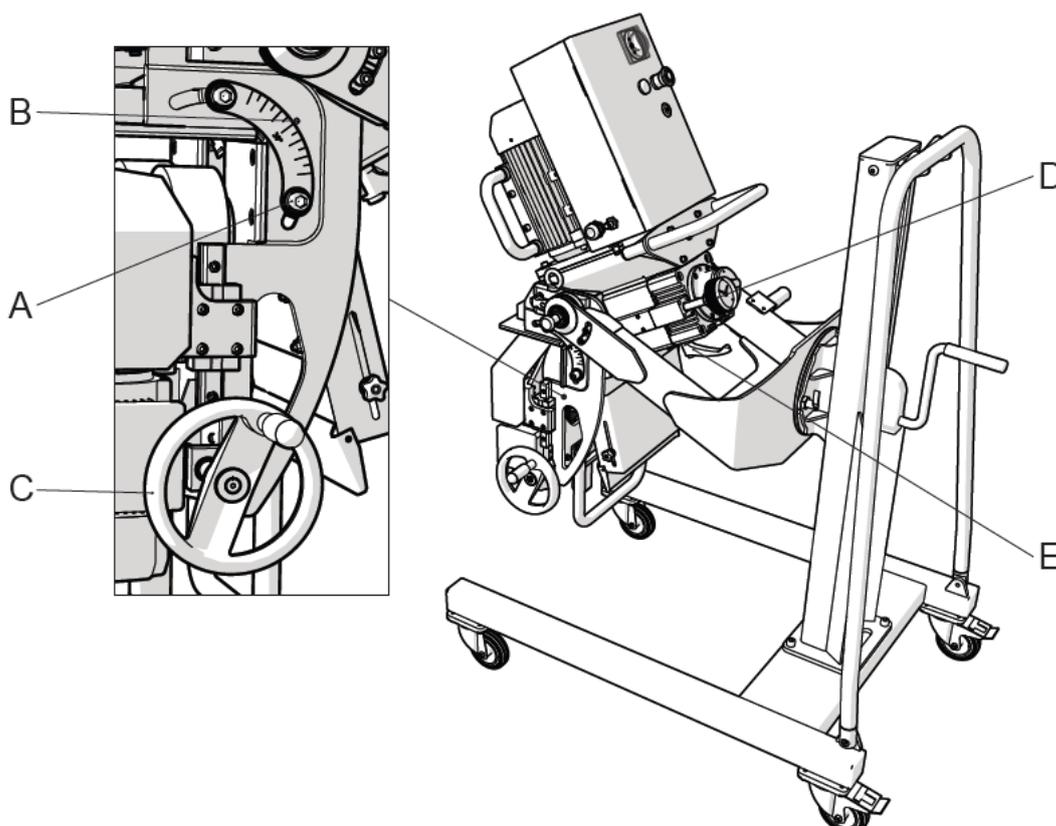
Make the adjustments as follows:

- Sufficiently loosen the 2 and 2 screws (position A, Fig. 5.3.1) located on both sides of the machine.
- Holding and pulling the upper handle, adjust the entire machine unit to the desired angle.
- You can view the adjusted angle value on the divided scale located at the side of the machine (position B, Fig. 5.3.1).
- Having completed the operation, properly tighten the 2 and 2 screws on both sides (position A, Fig. 5.3.1).

**Important:**

If you have problems with adjustment of the angles, the screws may not have been loosened sufficiently (position A, Fig. 5.3.1).

Fig. 5.3.1



Setting the zero value:

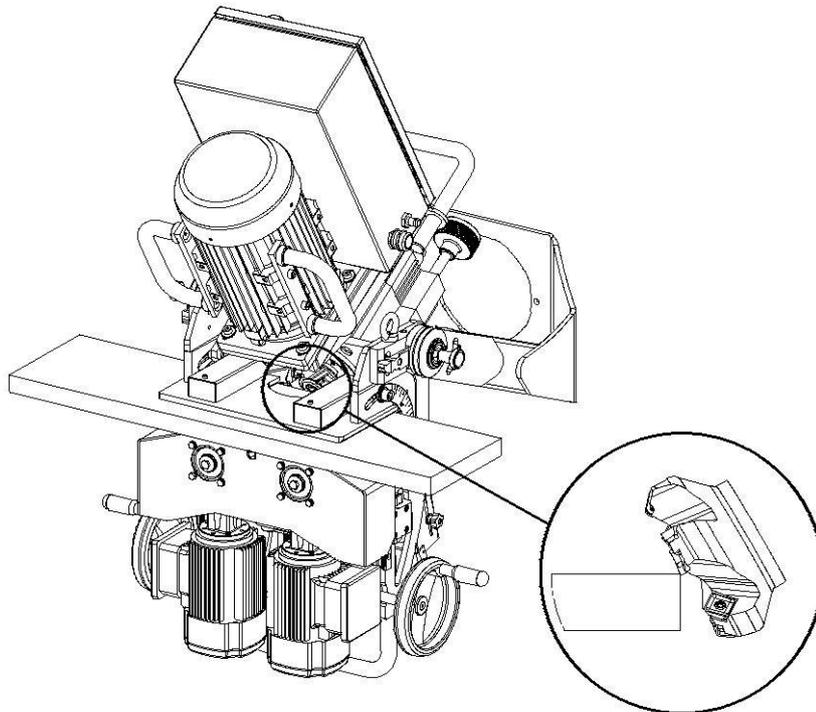
To set the cut-off size correctly, you must specify the zero point (point at which the cutter touches the material) for the specific angle before starting the work.

This point must be specified for every new bevel or changed angle.

Proceed as follows:

- Loosen the locking lever of chip adjustment (position E, Fig. 5.3.1).
- Move the cutter fully into the spindle by means of the chip setting wheel (position D, Fig. 5.3.1).
- Adjust the lowest position of the lower slide according to the picture (position C, Fig. 5.3.1.) by means of the adjusting wheel of the lower slide.
- Set the optimum working height, position and inclination of the machine by means of the 3D manipulator.
- Set the machine anywhere on the plate machined so that the vertical and horizontal ruler adjoins to the material along all of its length (Fig. 5.3.2).
- Start the cutter motor and check the tool rotation direction.
- By means of the chip adjusting wheel, gradually move the cutter towards the material up to the point at which it touches the material. Thus you have specified the zero point for the given angle (Fig. 5.3.2.).
- Retighten the locking lever of chip adjustment (position E, Fig.. 5.3.1).

Fig. 5.3.2.



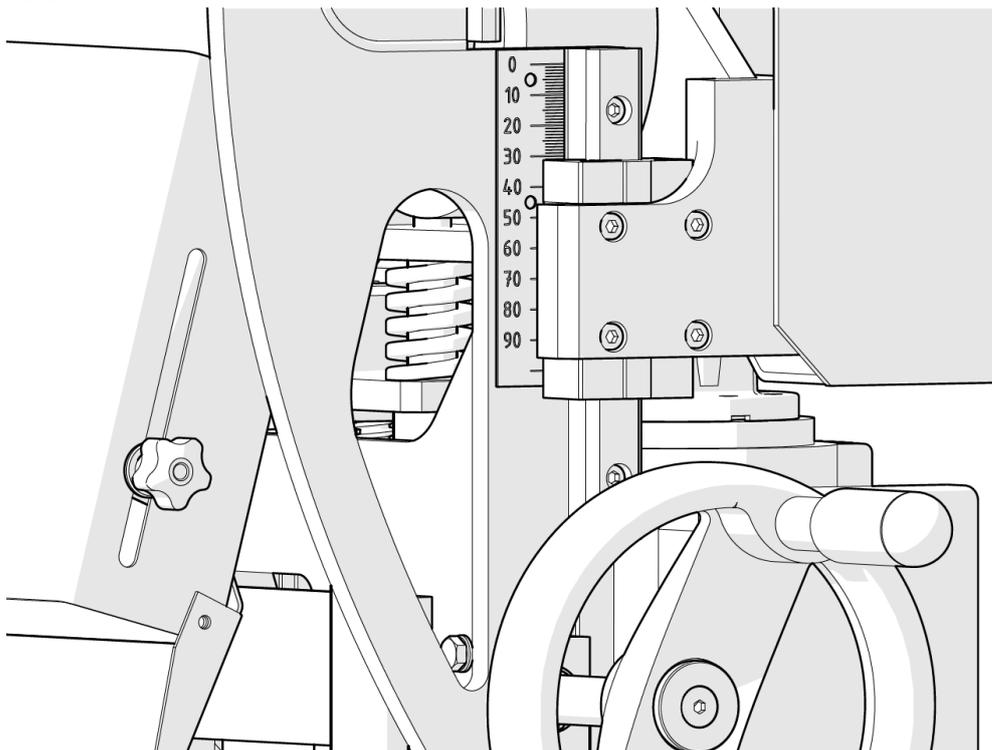
Lower slide adjustment:

The lower slides task is to continually move the machine along the material or move the material through the cutting tool if small parts are machined. The feed speed can be controlled with the remote controller.

The lower slide must be adjusted so that it properly ensures the material is fixed against its vibrations or loosening during cutting. For this reason, the lower slide has been designed so that it acts upon the material with the force of a spring mechanism with controllable pre-load. Another advantage of this solution involves cushioning and adaptability to sudden changes in the machined material thickness during cutting.

- The lower slide is adjusted according to the machined material thickness. Always set the scale value (Fig. 5.3.3.) 0.2" – 0.3" , 5-8 mm lower than the actual thickness of the material machined. The prescribed 0.2" – 0.3" , 5-8 mm stands for the spring pre-load. Adjust by means of the control wheel (position C, Fig. 5.3.1.). Thus control element is mounted at both sides of the machine for easier access.

Fig. 5.3.3.



5.4 Cut-off and machining setting

The DBM50 machine is able to make the bevel width of up to 62 mm at certain angles (see par. 3.2.). These values can only be achieved by gradually machining in several cut-offs.

Setting the first cut-off

Important: Correct setting of the cut-off is determined by previous setting of the zero point. Without this pre-setting, the cut-off may be set incorrectly and the cutter damaged.

- Loosen the locking level of chip adjustment (position E, Fig. 5.3.1).
- Adjust the first cut-off with the chip adjusting wheel (position D, Fig. 5.3.1) as required. To read the values correctly, use the table located on the machine distribution box (Fig. 5.4.1.)

Important: The maximum depth of the individual cut-off is 5 mm (cutter protrusion). Specifically, 25 divisions on the adjusting wheel scale. If you set more for a single cut-off, there is immediate risk of damaging the tool.

- Retighten the locking lever of chip adjustment (position E, Fig. 5.3.1).
- We recommend you to note down the values set on the adjusting wheel scale (position D, Fig. 5.3.1). This will help you to adjust the next cut-off.

angle	UZ50 bevel depth																											
	1		5		10		15		20		25		30		35		40		45		50		55		60			
	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark	mm	mark		
15	0,3	1,5	1,3	6,5	2,6	13,0	3,9	19,5	5,2	26,0	6,5	32,5	7,8	39,0	9,1	45,5	10,4	52,0	11,6	58,0	12,9	64,5	14,2	71,0	15,5	77,5		
20	0,3	1,5	1,7	8,5	3,4	17,0	5,1	25,5	6,8	34,0	8,6	43,0	10,3	51,5	12,0	60,0	13,7	68,5	15,4	77,0	17,1	85,5	18,8	94,0	20,5	102,5		
25	0,4	2,0	2,1	10,5	4,2	21,0	6,3	31,5	8,5	42,5	10,6	53,0	12,7	63,5	14,8	74,0	16,9	84,5	19,0	95,0	21,1	105,5	23,2	116,0				
30	0,5	2,5	2,5	12,5	5,0	25,0	7,5	37,5	10,0	50,0	12,5	62,5	15,0	75,0	17,5	87,5	20,0	100,0	22,5	112,5	25,0	125,0						
35	0,6	3,0	2,9	14,5	5,7	28,5	8,6	43,0	11,5	57,5	14,3	71,5	17,2	86,0	20,1	100,5	22,9	114,5										
40	0,6	3,0	3,2	16,0	6,4	32,0	9,6	48,0	12,9	64,5	16,1	80,5	19,3	96,5	22,5	112,5												
45	0,7	3,5	3,5	17,5	7,1	35,5	10,6	53,0	14,1	70,5	17,7	88,5	21,2	106,0	24,7	123,5												
50	0,8	4,0	3,8	19,0	7,7	38,5	11,5	57,5	15,3	76,5	19,2	96,0	23,0	115,0														
55	0,8	4,0	4,1	20,5	8,2	41,0	12,3	61,5	16,4	82,0	20,5	102,5	24,6	123,0														
60	0,9	4,5	4,3	21,5	8,7	43,5	13,0	65,0	17,3	86,5	21,7	108,5																
	first cut				second cut				third cut				fourth cut				fifth cut											

1mark=0,2mm 10mark=2mm
max depth of cut = 5mm = 25mark

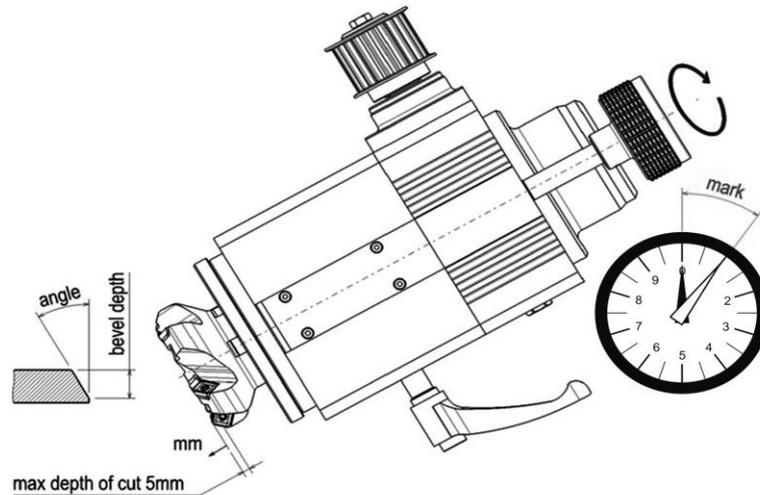


Fig. 5.4.1

Machining

- Set the machine at the plate edge. Adjust the optimum position and inclination of the inlet rulers by means of the adaptive 3D system. The machining direction is left-to-right in the standard position. In the case of upside-down work, the direction is right-to-left.
- Start the cutter and feed motors and set the feed speed to approx. 25 % of the total speed range. The maximum speed is 47^o/min. , 1.2 m/min.
- Slowly pulling the pertinent handles, guide the machine onto the material, checking its run onto the plate. The machine must run onto the plate simultaneously with the guide rules with which it must be in contact.
- After the machine fully runs onto the material, when the material is held by the two feed rollers, you can increase the feed speed. This speed is not calibrated in any way; it must be properly adjusted according to the state of the cutting plates, material quality and cut-off size.
- During beveling, a situation may occur when you need to adjust the position and inclination of the machine by means of the 3D manipulator. This happens if the machined plate is set on the supports incorrectly or if the working place floors are in a not level or damaged.

In this case, it is suitable to loosen the pertinent mechanisms on the 3D manipulator and fully exploit the advantages of the adaptive 3D system (Fig.5.4.3., pos. A, C). The lifting mechanism can be moved a little lower independently of the machine, thus enabling the machine to lay on the material at the moment to move along the vertical line freely (Fig. 5.4.3., pos. B).

- If the floors are damaged extremely, the machine, having fully run onto the material, can be disconnected from the 3D manipulator (Fig. 5.4.2.). In this mode, the machine runs on the material by itself without the need of any support. After disconnecting, you must release the 3D manipulator lock (Fig. 5.4.2., pos A).
Before running out of the material, you must connect the 3D manipulator again in the same way and adjust the machine position for running out of the material. The machine feed can be stopped or started by means of the feed control.
- The machine may also be used without the manipulator, suspended on a crane. The lifting eyes on the machine are used for that (see Fig. 4.1.1.)

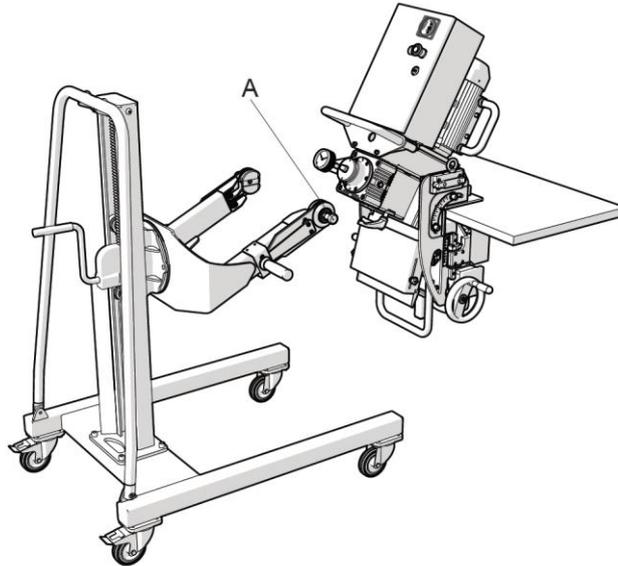


Fig. 5.4.2.

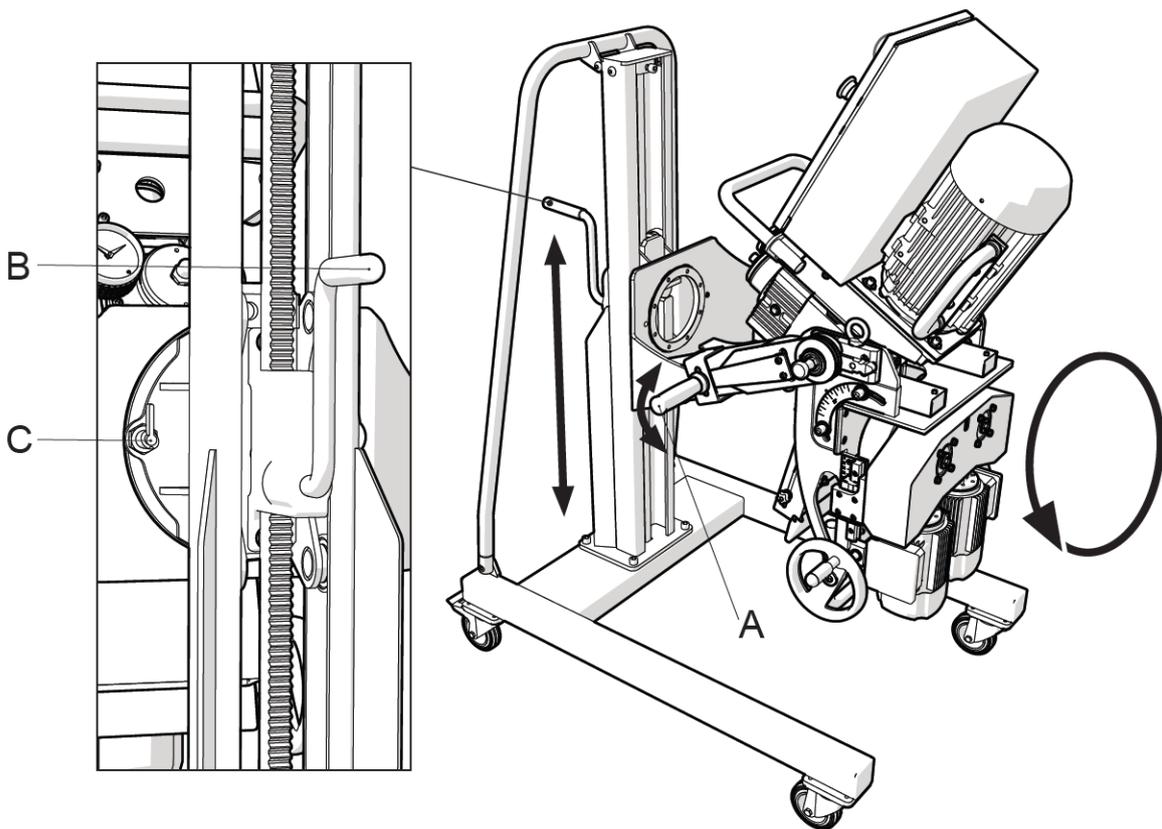


Fig. 5.4.3.

Further cut-off setting

The DBM50 is able to create bevels of the width of up to 62 mm at certain angles (see par.3.2.). These values can only be achieved by gradual machining in several cut-offs.

- Loosen the locking lever of chip adjustment (position E, Fig. 5.3.1).
- Adjust the next cut-off with the chip adjusting wheel (position D, Fig. 5.3.1) as required. To read the values correctly, use the table located on the machine distribution box (Fig. 5.4.1.)

Important: The maximum cutting depth of individual cut-off is 5 mm (cutter protrusion). Specifically, 25 divisions on the adjusting wheel scale. If you set more for a single cut-off, there is immediate risk of damaging the tool.

- Retighten the locking lever of chip adjustment (position E, Fig. 5.3.1).
- We recommend that you note the values set on the adjusting wheel scale (position D, Fig. 5.3.1). This will help you to adjust the next cut-off.

- Start cutting. Proceed in the same way as with the first cut-off.
- All further cut-offs repeat the above-mentioned in chapter 5.4

TIP: Calculate the individual cut-offs so that the last one is not too deep. Set a lower value of the feed. The final surface of the bevel will be better.

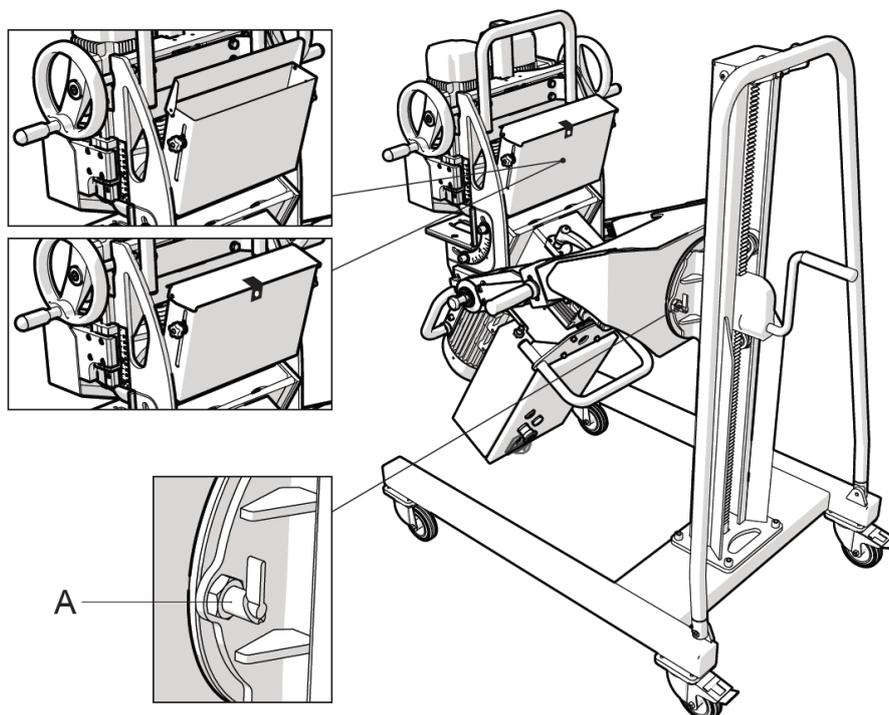
Upside-down work

One of the main advantages of the DBM50 machine and 3D manipulator is the possibility of upside-down work. Namely, the possibility to make double-sided bevels without the necessity of handling or flipping the material. Proceed as follows:

- Release the rotation lock (Fig. 5.4.4., pos.). Make sure that the machine is sufficiently high above the floor after being turned.
- Hold the machine by the pertinent handles and turn it by 180°.
- Relock the rotation lock.
- Close and secure the lid of the chip removal channel (Fig. 5.4.4).
- Set the machine in a suitable position and inclination according to the material position and situation at the workplace.
- Then specify the zero point again; see chapter 5.3. **Preliminary settings**, paragraph: **Zero value specification**.
- Then set the machine for the first and next cut-offs, see chapter 5.4.
- Start machining.

Important: The machined material must be located on supports at a sufficient height so that the machine electrical distribution box will not collide with the floor.

Fig. 5.4.4.



MAINTENANCE AND ADJUSTMENT

6.1 Recommendations

**Important:**

The maintenance workers must be qualified technicians.

Never work on machine parts in motion, not even with tools or other objects.

It is strictly forbidden to remove safety devices, modify them, or tamper with the safety devices of the machine. In such an event, the manufacturer disclaims any responsibility for the machine safety.

Always use original spare parts (see chapter 8 “Spare parts”).

**Warning:**

Always wear protective work gloves when maintaining the machine. The maintenance operations must be executed if the machine is stopped and disconnected from power supply.

Before every working shift, and then during it as necessary, clean the machine, tool and moving parts with compressed air.

**Warning:**

When using compressed air for cleaning, wear protective goggles, and never use pressure over 30 psi. , 2 bar.

For adjusting and maintenance, use the tools delivered with the machine.

6.2 Cutter and cutting blades disassembly

**Warning:**

When changing tools, use protective gloves.

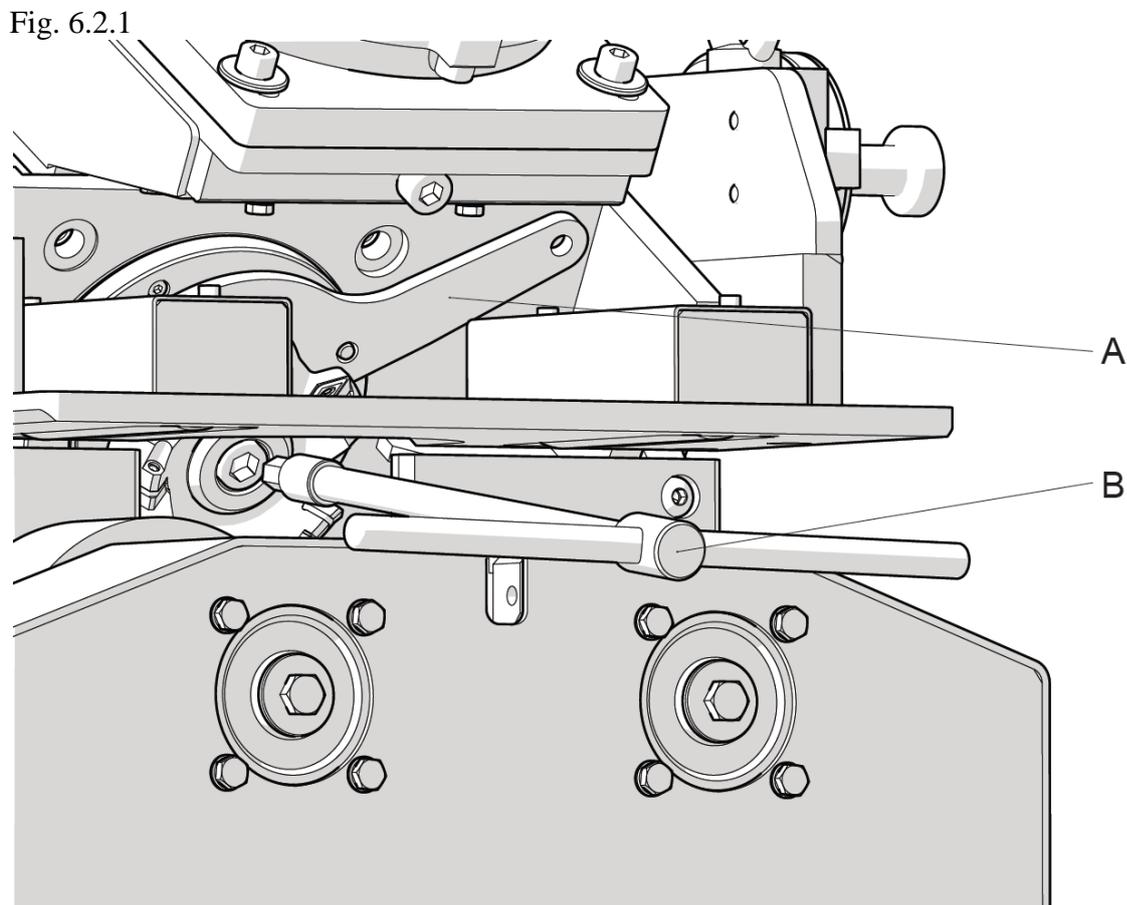
DBM50 uses for cutting a face mill of our own design with cutting plates with four cutting sides. To exploit the cutting plates fully, these must be turned when they are blunt. On the whole, 4 cutting sides are available.

The state of the cutting tips must be checked continuously; if they are worn, you must turn them.

Cutter head disassembly:

- Disconnect the machine from power supply.
- By means of the wheel for lower slide adjustment, set the lowest position of the lower slide according to the picture (position C, Fig. 5.3.1).

- Loosen sufficiently the 2 screws on each side (position A, Fig. 5.3.1) located at both sides of the machine.
- Holding and pulling the upper handle, adjust the entire machining unit to the angle which is most suitable for access to the cutter.
- Loosen the locking lever of chip adjustment (position E, Fig. 5.3.1).
- By means of the chip adjustment wheel (position D, Fig. 5.3.1), move the cutter to the position in which the access to it is most suitable.
- Lock the spindle against rotation. Use the enclosed hook wrench (position A, Fig. 6.2.1).
- With the enclosed wrench, loosen the main central screw which fastens the cutting head to the spindle (pos. B, Fig. 6.2.1)..
- Remove the screw including the central insert and pull the cutting head from the spindle manually. If it is tight, use the enclosed withdrawal tool.



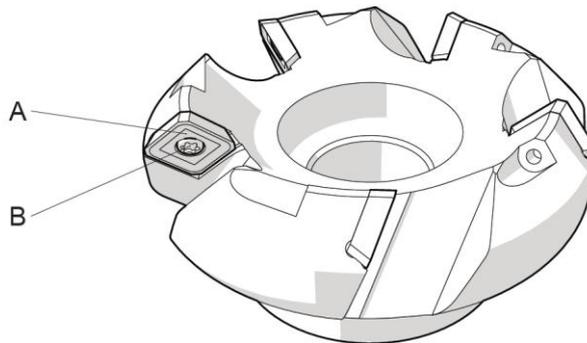
Replacement or turning of cutting plates:

- Put the cutting head on a suitable surface. The DBM50 cutter is equipped with 5 cutting inserts.
- Loosen the screw (Fig. 6.2.2., pos. B) of the cutting plate (Fig. 6.2.2., pos. A) with the enclosed wrench and then turn or replace it.
- Some DBM50 cutters can be equipped with so-called sub-plates. These are pads under the cutting plate. If your machine is equipped with them and if they are damaged, you must replace them as well.
- Mount the cutter back.

Important: Keep all parts of the cutter head (plates, screws, cutter screw) and the spindle clean.

Otherwise there is a risk that the cutting plates will be seated incorrectly and their service life reduced or the cutter head blocked on the spindle with subsequent problems during the next disassembly.

Fig. 6.2.2.



6.3 Headstock oil replacement and refilling

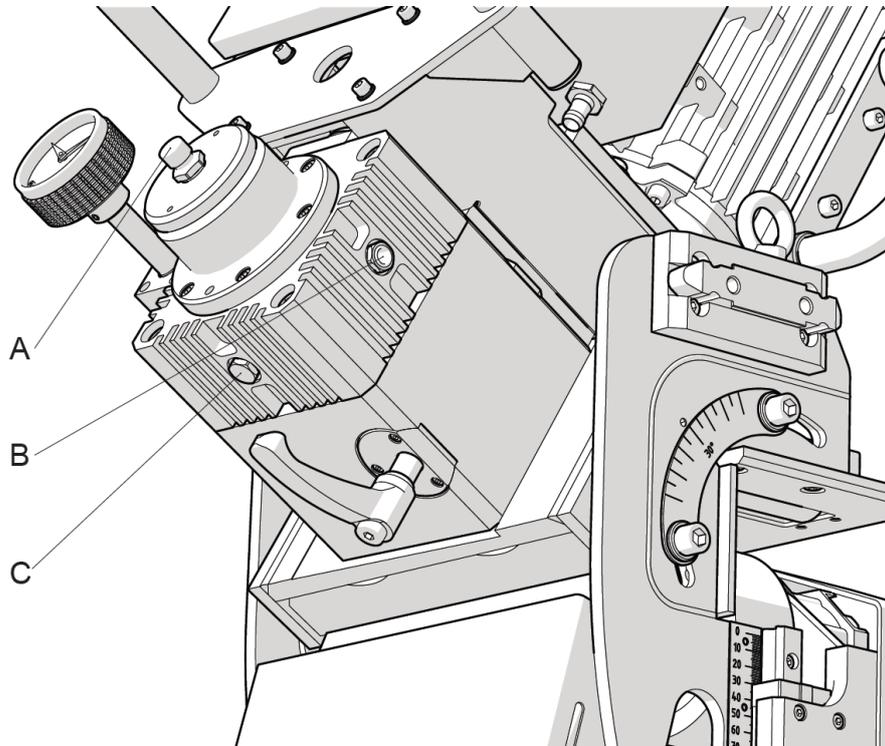
The DBM50 machine headstock contains oil which is subject to wear. The first change must be executed after 50 working hours. Then, the next changes after every 1,500 working hours.

Exchange the oil as follows:

- Stop the machine and disconnect it from power supply.
- Set the machine in an optimum position for discharging the oil. The discharge screw (Fig. 6.3.1. pos. C).
- Put a suitable vessel for the used oil under the discharge hole.
- Remove the discharge screw (Fig. 6.3.1., pos. C).
- Remove the bleed screw (Fig. 6.3.1., pos. A).
- Wait until all the oil has run out, and then mount back the discharge screw (Fig. 6.3.1., pos. C).
- Fill the headstock with new oil through the filling hole (Fig. 6.3.1., pos. A) (MOBILGEAR 600XP 150, SAP CODE 149640, ISO VG 150) – approx. 200 ml.

- Check the oil level in the oil gauge. The level must at least reach the middle of the gauge (Fig. 6.3.1., pos. B).
- Mount back the bleed screw (Fig. 6.3.1., pos. A).

Fig. 6.3.1.

**Important:**

The old oil must be collected and disposed of in conformity with valid local laws. Never pour the oil into drains, sewers or soil.

6.5. Drive belt replacement

The DBM50 machine is equipped with a toothed belt for force transmission from the motor to the spindle. At the same time, the belt serves as a safety element in case of machine overload.

In reality, the belt may be broken in some situations.

Exchange the belt as follows:

- Disconnect the machine from power supply.
- Loosen and remove the screws on the cover flange of the belt case (Fig. 6.5.1., pos. A).
- Lift off the case cover (Fig. 6.5.2.).
- Replace the belt with a new one.
- Mount back the cover.
- Tighten the belt with the tightening screw (Fig. 6.5.1., pos. B). The tightening force: 600-750 Newton Meters (440 – 553 ft. lbs).
- Tighten the cover screws (Fig. 6.5.1., pos. A).
- Check the machine function.

Fig. 6.5.1.

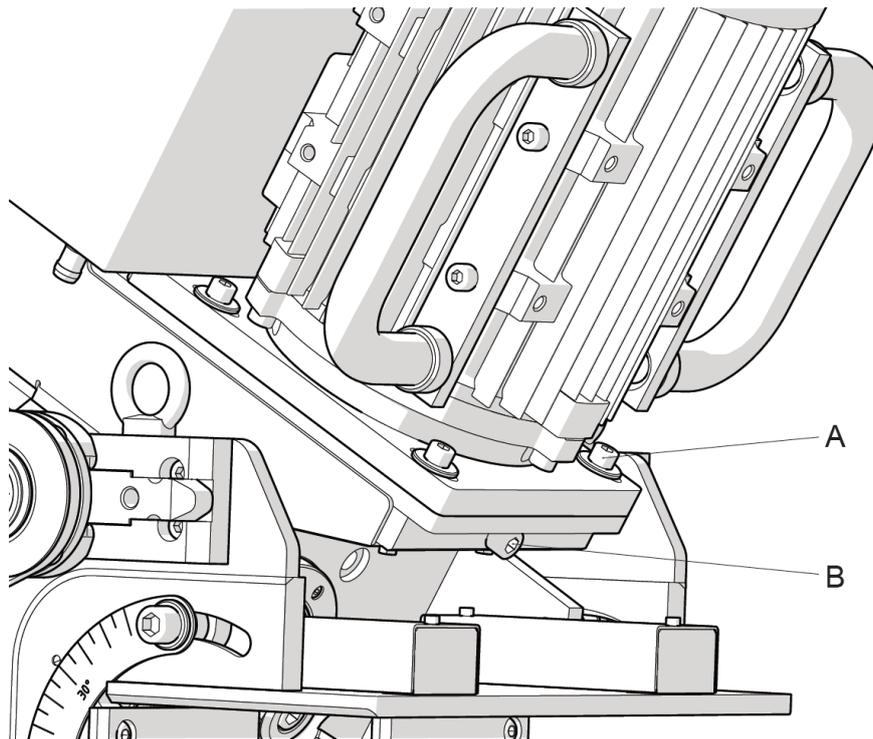
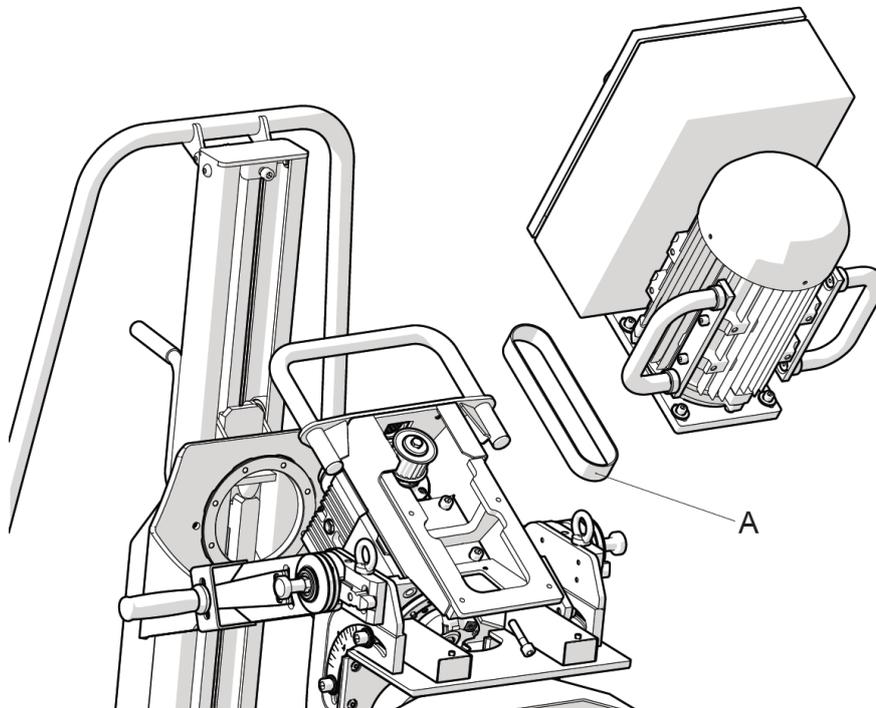


Fig. 6.5.2.



It is not advisable to operate the machine in high moisture conditions due to the increase in potential for electric shock!

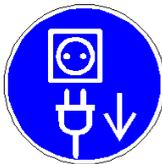
Electric energy - in case of a failure, immediately switch off the power supply.

Work on the electric equipment of the machine can only be done by a qualified person or subordinate persons under his/her supervision so that the work is done according to electric engineering regulations..



No part on which maintenance is performed can be under voltage. It is necessary to check with a two-pole measuring instrument that the disconnected parts are not under voltage, then connect them to ground and insulate the surrounding parts under voltage!

Disconnect the power supply by turning the main switch to position “0”.



The electric equipment must regularly be checked, or tested. Shortcomings, loose connections, charred cables must be replaced immediately.

SPARE PARTS

8.1 How to order spare parts

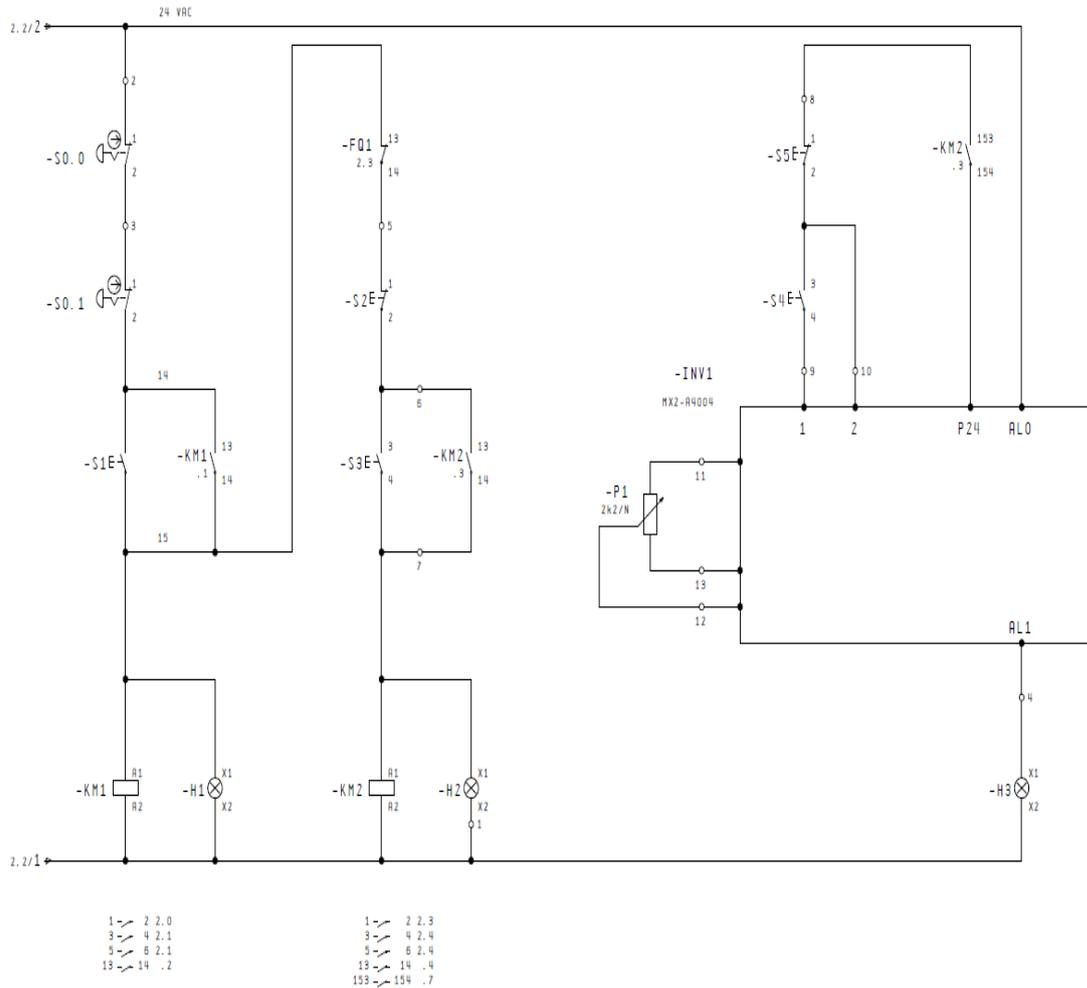
Orders of spare parts must contain this information:

- machine type;
- serial number;
- required part description and number
- quantity.

8.2. Parts most often liable to wear and tear:

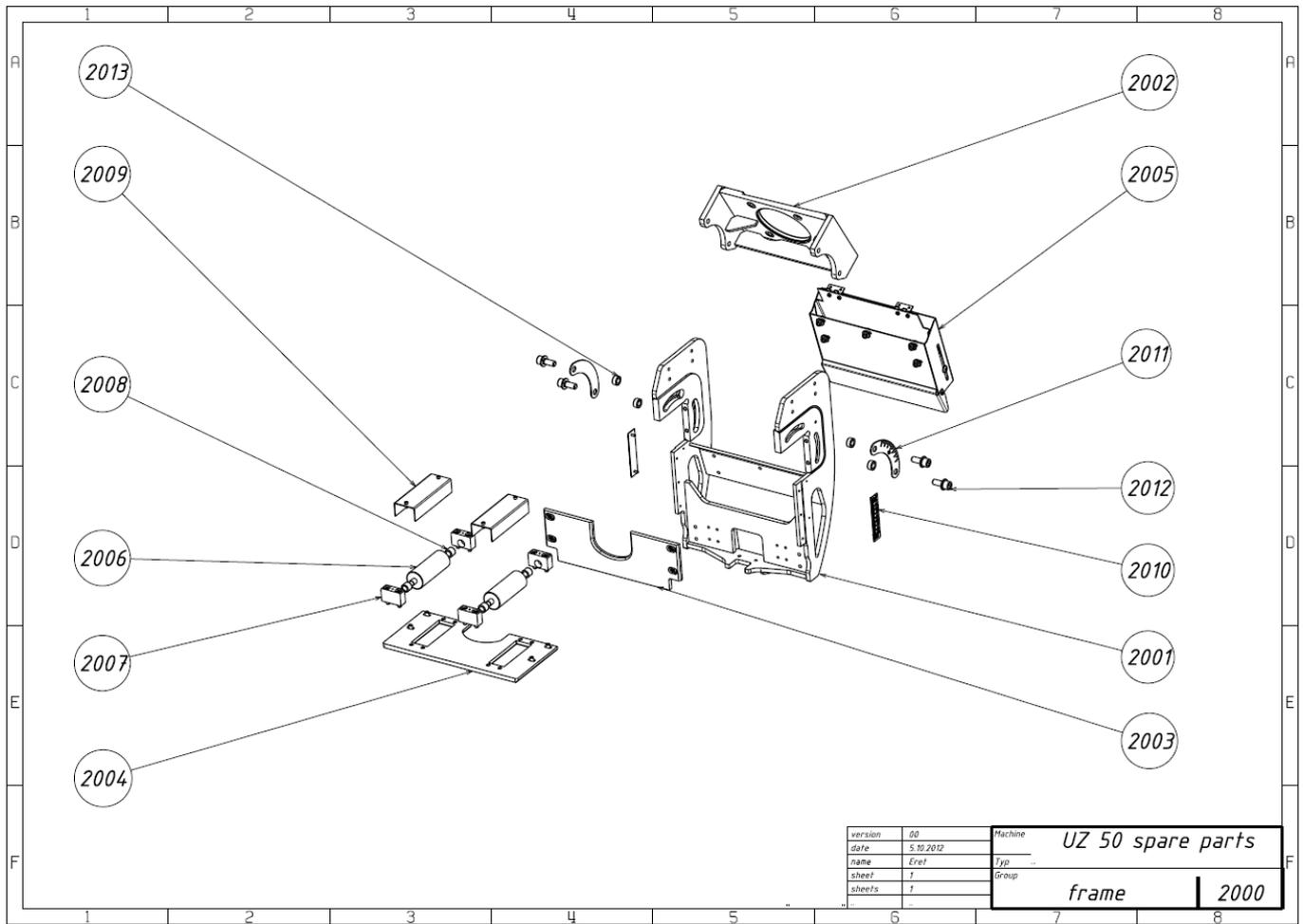
Order No.	Description	Illustration
1945	Cutting plates (10 in package)	
1946	Cutter head (without screws and cutting plates)	
1947	Plate screw	
	Drive belt UZ20	
Further accessories can be expected at the beginning of 2013.		

8.3 Electric connection drawing and spare parts drawing and list



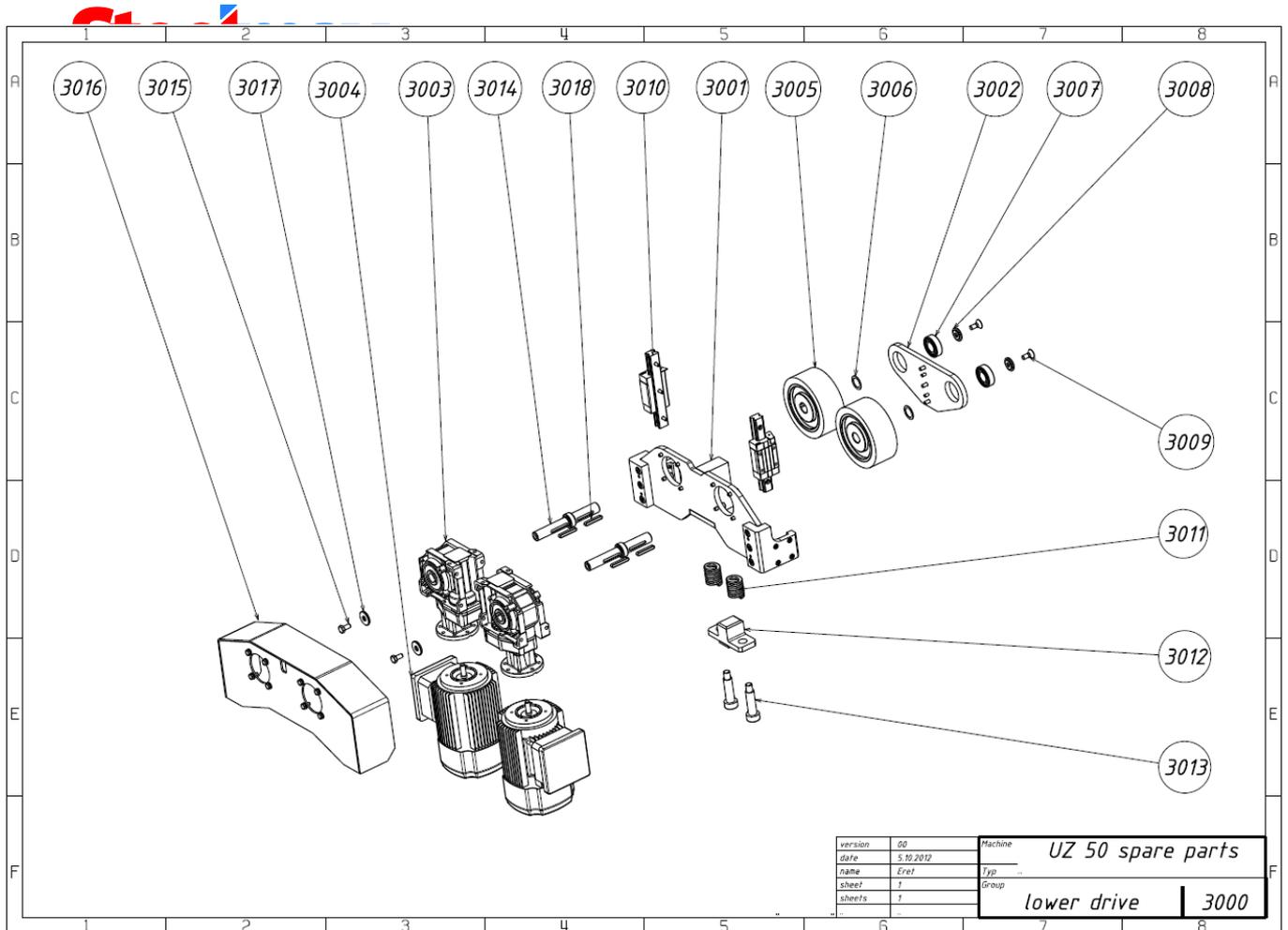
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		Zprac. PTH		UZ50	MILLING MACHINE	SCHEMATIC DIAGRAM	01		
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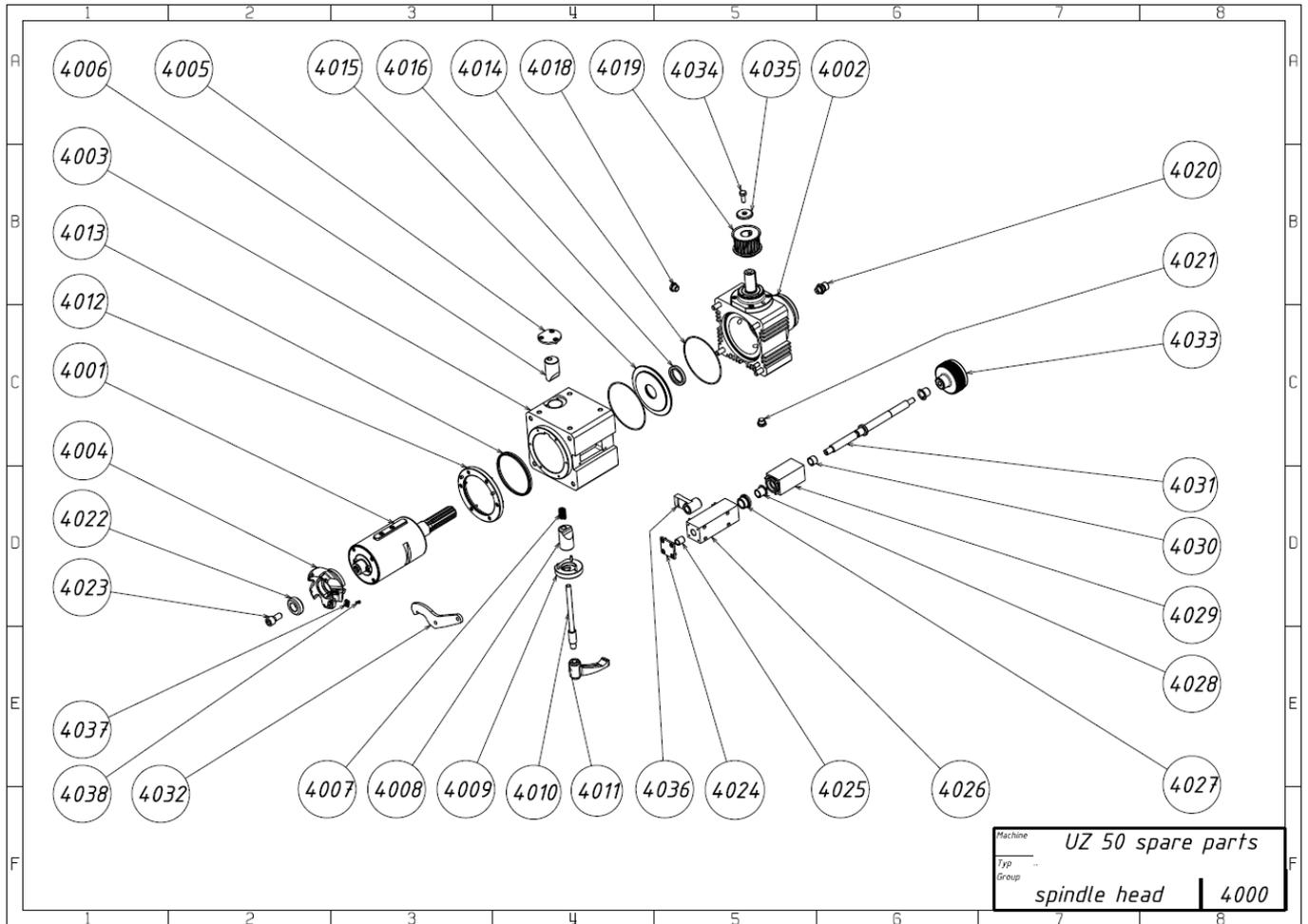
2000 FRAME - SPARE PARTS

Number	Fig	Part name
1940.2001	2001	frame
1940.2002	2002	folding bed
1940.2003	2003	vertical plate
1940.2004	2004	horizontal plate
1940.2005	2005	rectifier
1940.2006	2006	cylinder
1940.2007	2007	bearing housing
1940.2008	2008	plain bearing
1940.2009	2009	housing
1940.2010	2010	ruler
1940.2011	2011	protractor
1940.2012	2012	bolt with washer
1940.2013	2013	housing



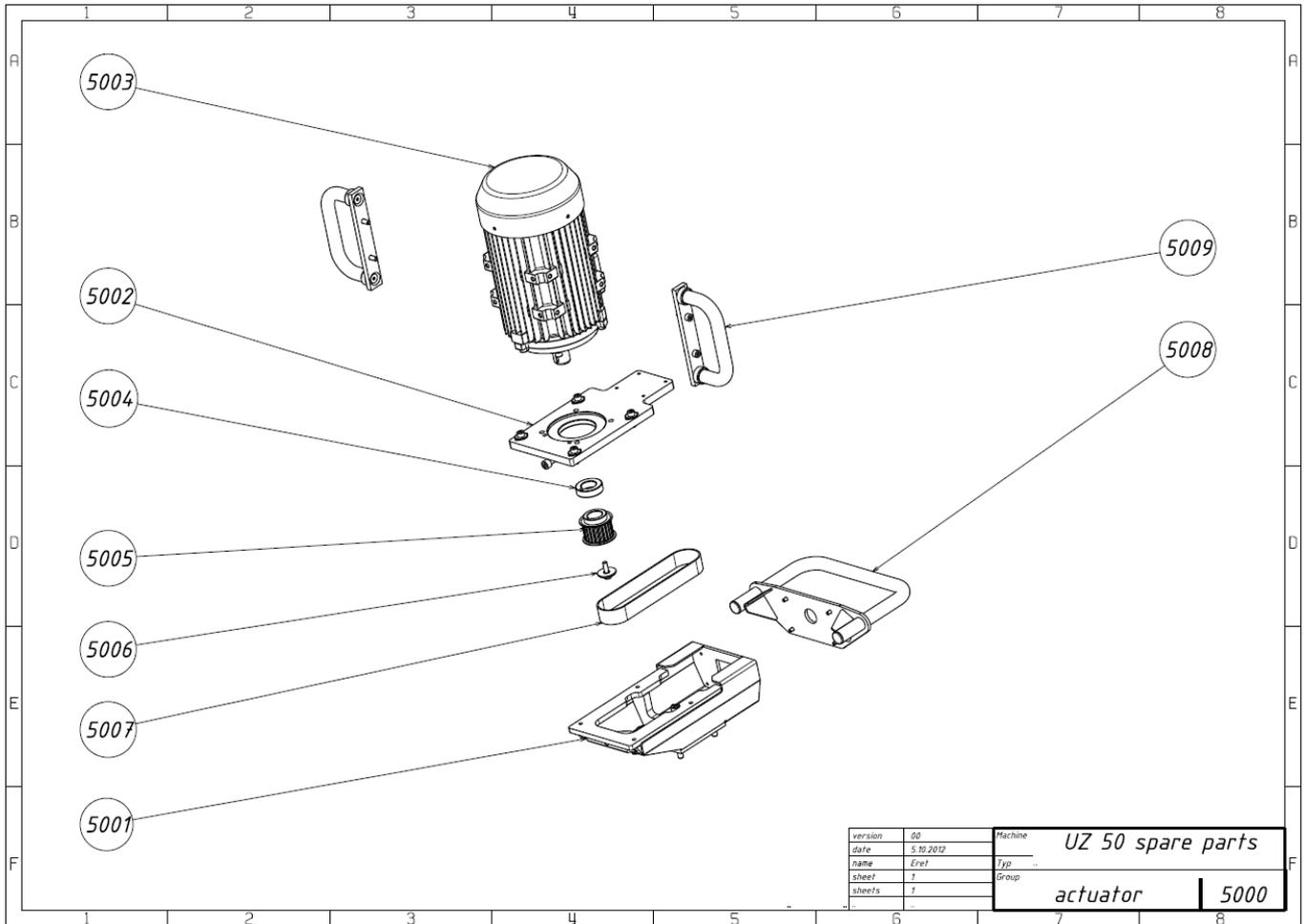
3000 LOWER DRIVE - SPARE PARTS

Number	Fig	Part name
1940.3001	3001	shoulder
1940.3002	3002	bearing plate
1940.3003	3003	gearbox
1940.3004	3004	electromotor
1940.3005	3005	pulley
1940.3006	3006	washer
1940.3007	3007	ball-bearing
1940.3008	3008	washer
1940.3009	3009	screw
1940.3010	3010	linear guides
1940.3011	3011	compression spring
1940.3012	3012	stop
1940.3013	3013	screw
1940.3014	3014	shaft
1940.3015	3015	screw
1940.3016	3016	casing
1940.3017	3017	washer
1940.3018	3018	keys



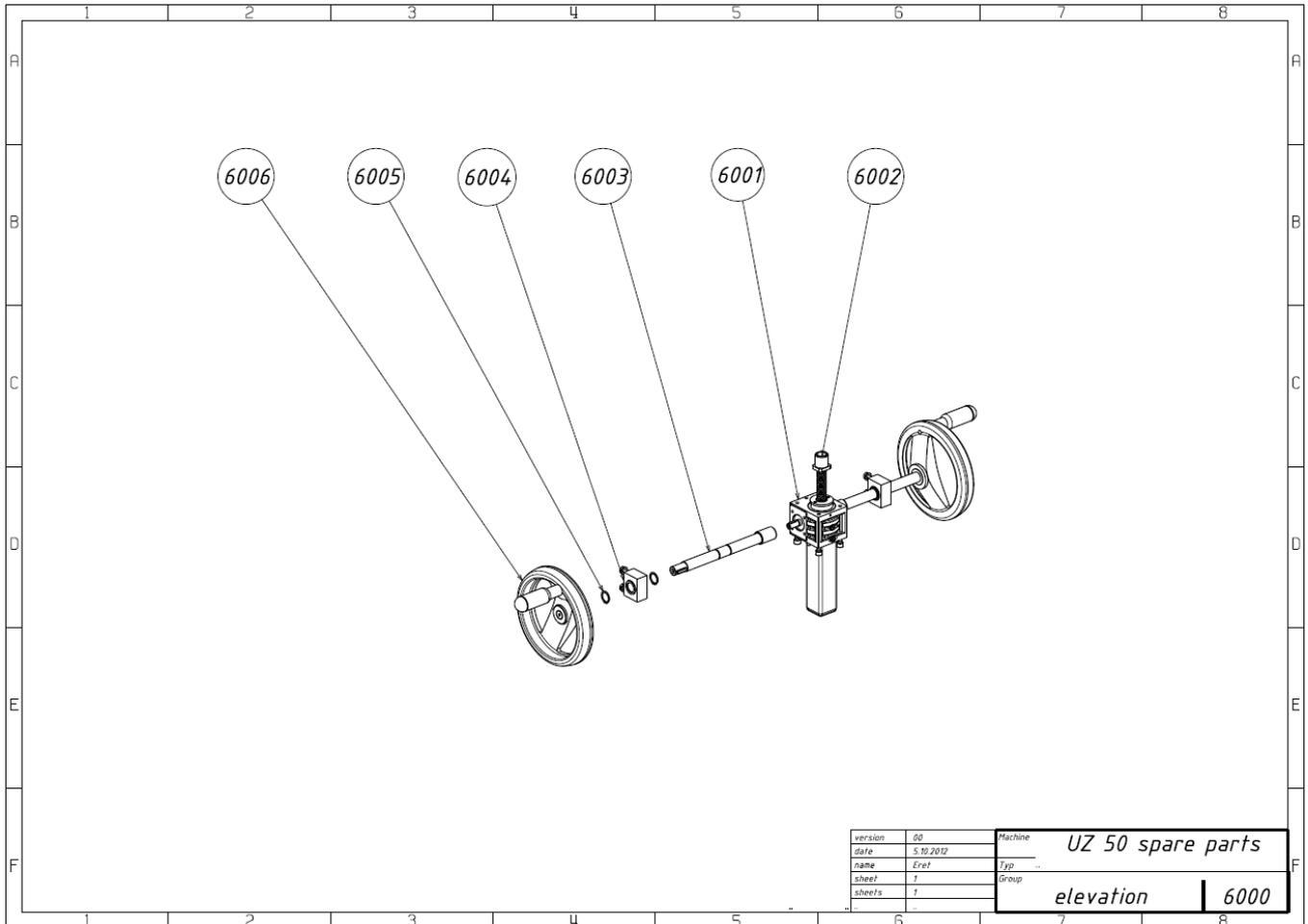
4000 SPINDLE HEAD - SPARE PARTS

Number	Fig	Part name
1940.4001	4001	spindle
1940.4002	4002	gearbox
1940.4003	4003	body
1940.4004	4004	milling head
1940.4005	4005	cover
1940.4006	4006	brake element
1940.4007	4007	spring
1940.4008	4008	brake element
1940.4009	4009	cover
1940.4010	4010	threaded shaft
1940.4011	4011	lever
1940.4012	4012	cover ring
1940.4013	4013	scraper ring
1940.4014	4014	seal
1940.4015	4015	counter
1940.4016	4016	seal
1940.4018	4018	lever gauge
1940.4019	4019	sheave
1940.4020	4020	bleder valve
1940.4021	4021	drain valve
1940.4022	4022	tool washer
1940.4023	4023	screw
1940.4024	4024	cover
1940.4025	4025	frictional bearing
1940.4026	4026	body
1940.4027	4027	bearing housing
1940.4028	4028	frictional bearing
1940.4029	4029	body
1940.4030	4030	frictional bearing
1940.4031	4031	arbor
1940.4032	4032	key
1940.4033	4033	indicator
1940.4034	4034	screw
1940.4035	4035	washer
1940.4036	4036	thumb
1940.4037	4037	insert
1940.4038	4038	screw



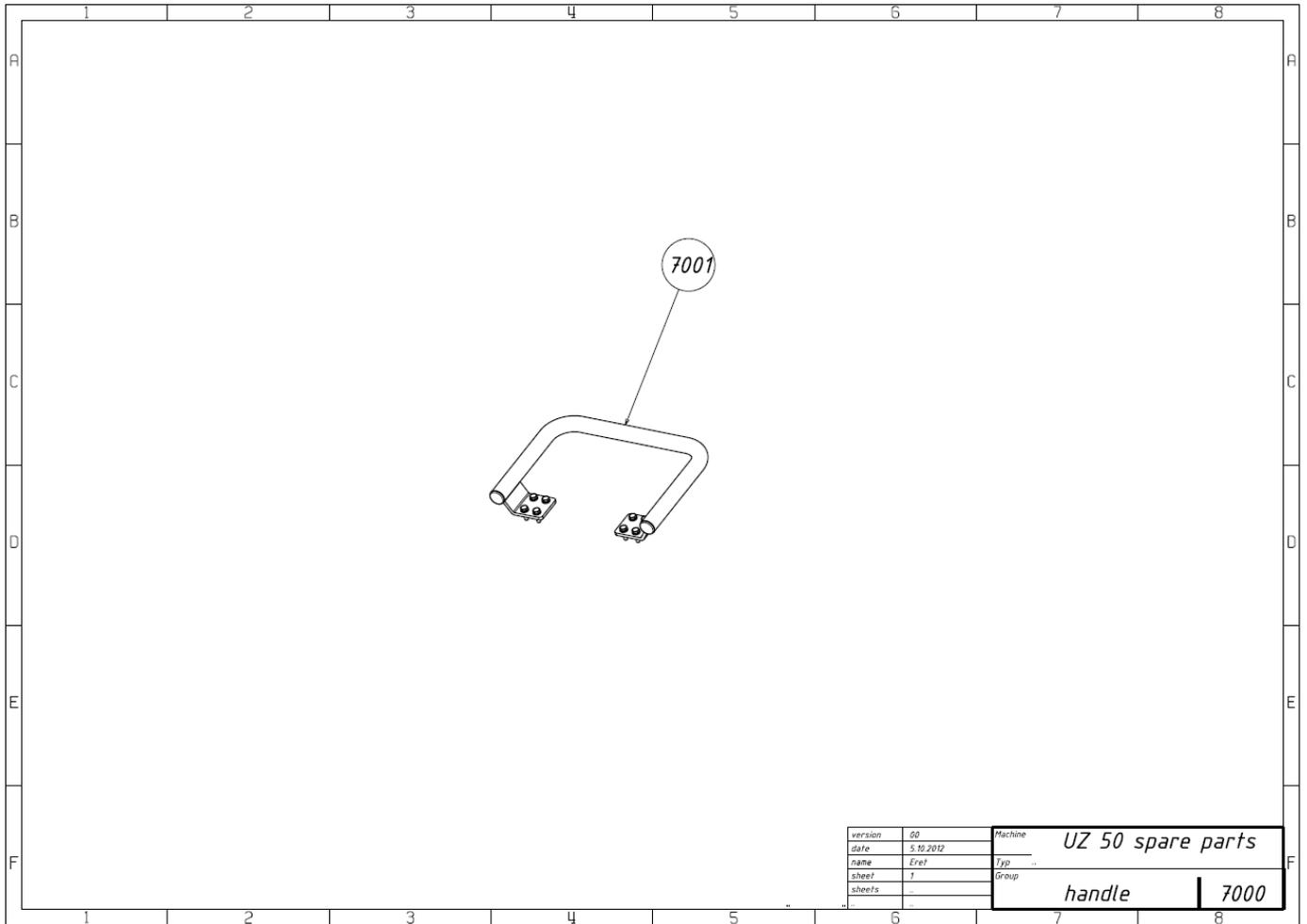
5000 ACTUATOR - SPARE PARTS

Number	Fig	Part name
1940.5001	5001	body
1940.5002	5002	plate
1940.5003	5003	electromotor
1940.5004	5004	washer
1940.5005	5005	sheave
1940.5006	5006	bolt with washer
1940.5007	5007	toothed belt
1940.5008	5008	handle
1940.5009	5009	handle



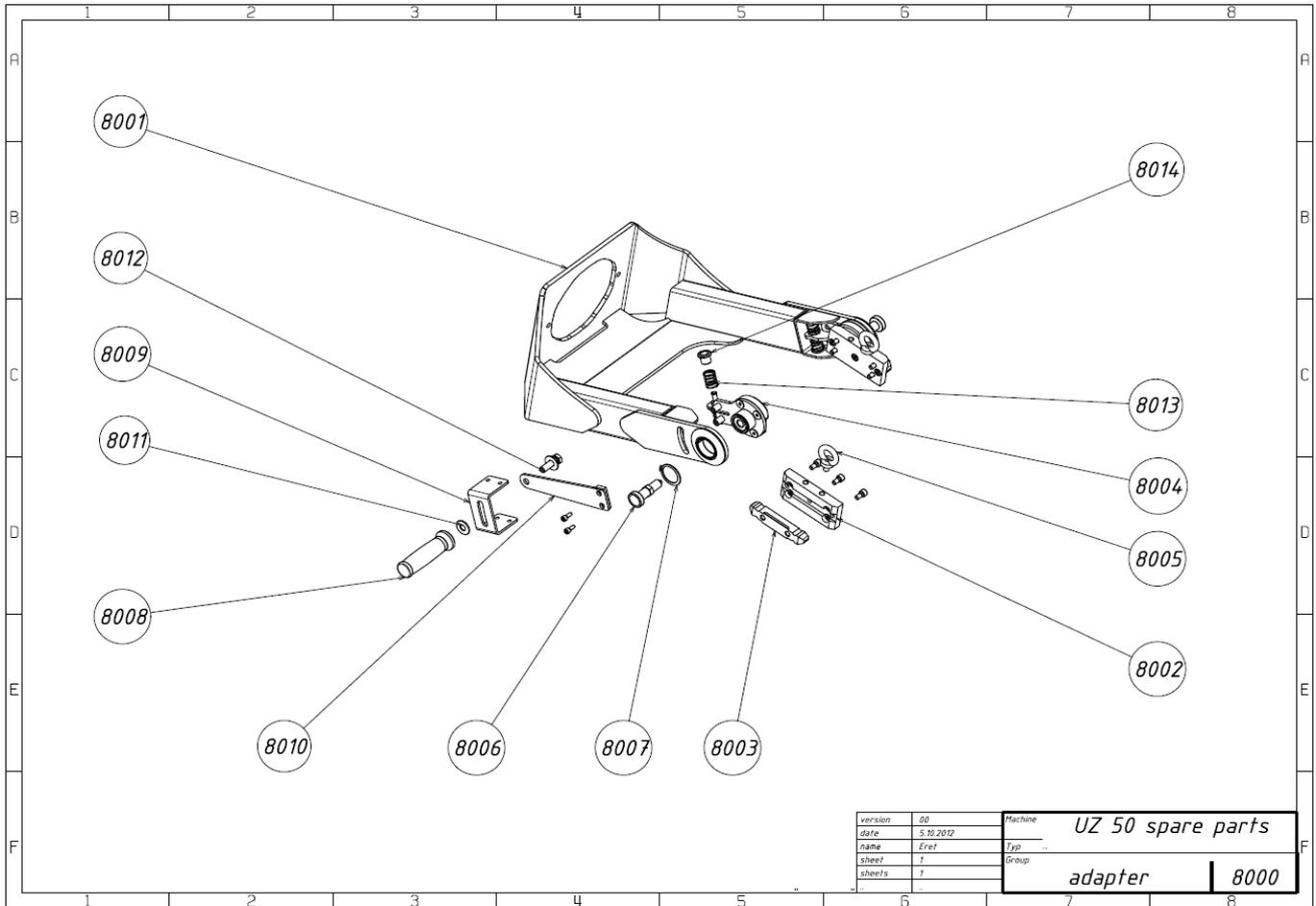
6000 ELEVATOR - SPARE PARTS

Number	Fig	Part name
1940.6001	6001	gearbox
1940.6002	6002	screw
1940.6003	6003	arbor
1940.6004	6004	bearing housing
1940.6005	6005	locking ring
1940.6006	6006	wheel



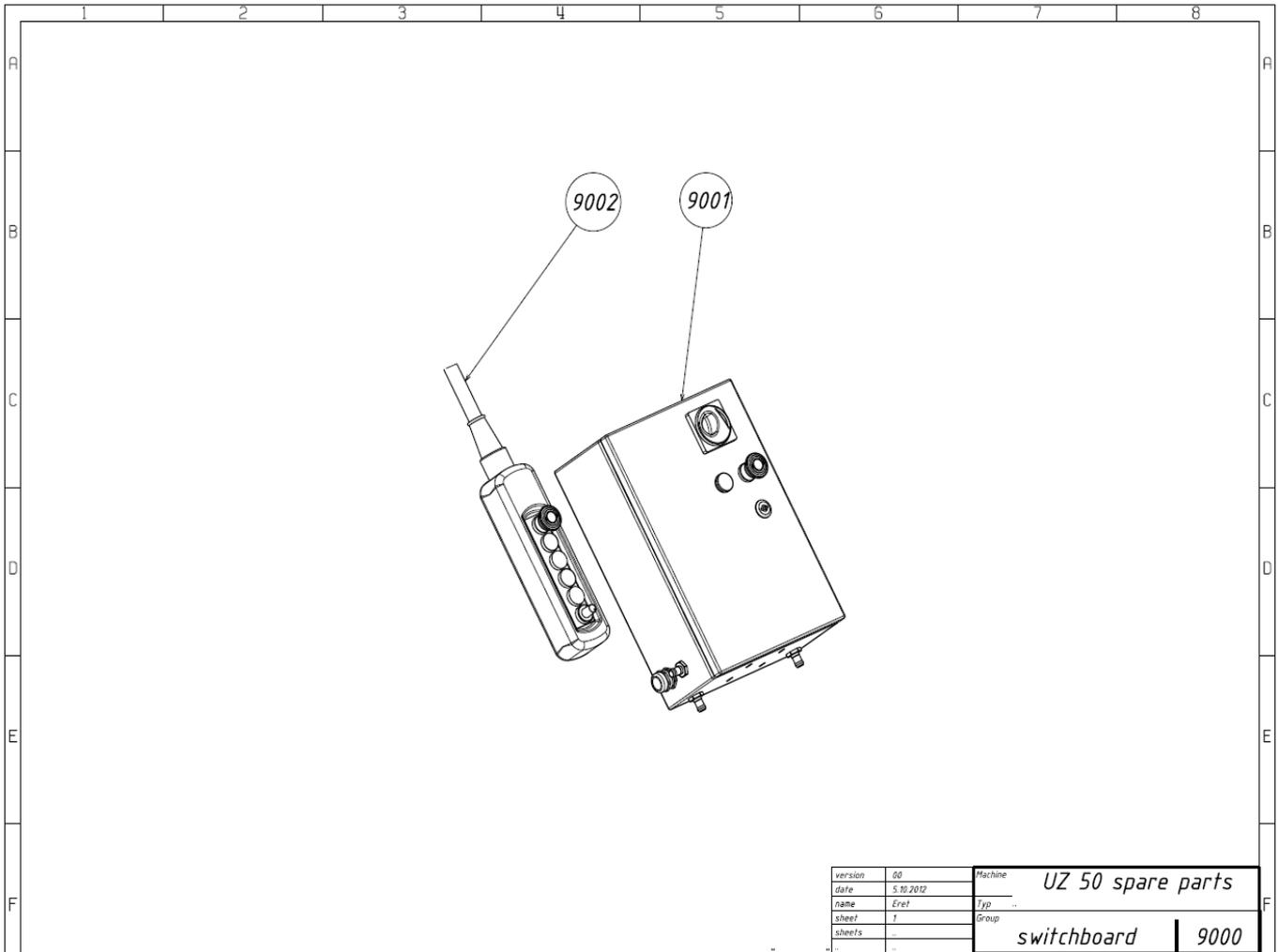
7000 HANDLE - SPARE PARTS

Number	Fig	Part name
1940.7001	7001	handle



8000 ADAPTER - SPARE PARTS

Number	Fig	Part name
1940.8001	8001	frame
1940.8002	8002	block
1940.8003	8003	key
1940.8004	8004	catcher
1940.8005	8005	lifting eye to
1940.8006	8006	locking pin
1940.8007	8007	lock ring
1940.8008	8008	grip
1940.8009	8009	holder
1940.8010	8010	lever
1940.8011	8011	washer
1940.8012	8012	screw
1940.8013	8013	spring
1940.8014	8014	stop



9000 SWITCHBOARD - SPARE PARTS

Number	Fig	Part name
1940.9001	9001	electrical switchboard
1940.9002	9002	remote control

A copy of this manual is delivered with every machine DBM50.

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