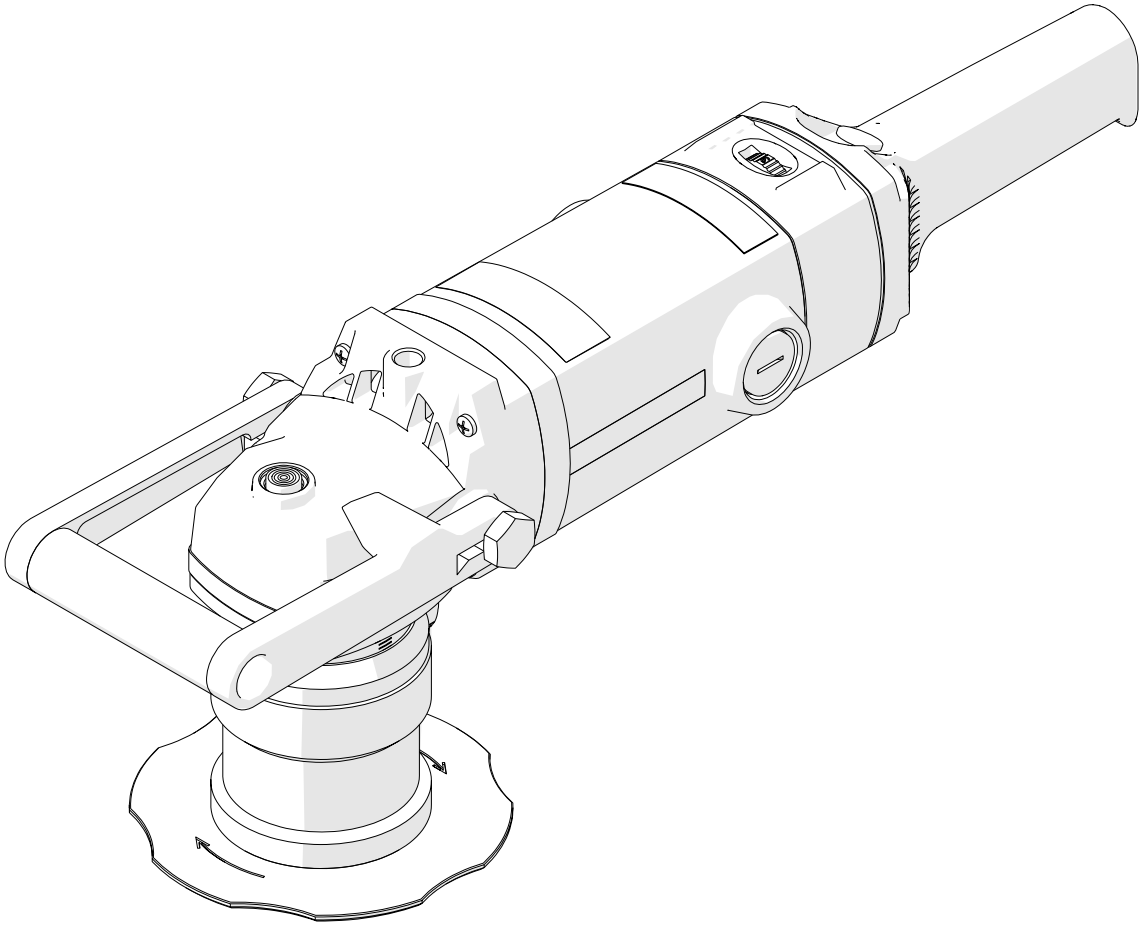
The tools of innovation.

OPERATOR'S MANUAL

SM-BM-16

BEVELING MACHINE



112 Inverness Circle East Suite F Englewood, CO 80112
1–87STEELMAX, FAX 303–690–9172
www.steelmax.com sales@steelmax.com

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1. GENERAL INFORMATION

1.1. Application

The BM-16 is a beveling machine designed to mill edges of plates and pipes made of steel, aluminum alloys, brass, or plastics.

Depending on the milling head used the machine allows beveling workpieces with a thickness of at least 1.5 mm (0.06'') at the angle of 20°, 22.5°, 27.5°, 30°, 37.5°, 40°, 45°, 50°, 55°, 60°, or 65° to the maximum bevel width of 16 mm (0.63''). A radius milling head allows beveling with a radius of 2, 3, 4, or 5 mm. The minimum diameter of a hole to be machined is 40 mm (1.57'').

An optional guide allows beveling pipes, and an optional sticker protects aluminum workpieces against scratches.

1.2. Technical data

Voltage	1~ 220–240 V, 50–60 Hz 1~ 110–120 V, 50–60 Hz
Power	2200 W
Rotational speed (without load)	1800–5850 rpm
Protection level	IP 20
Protection class	II
Maximum bevel width (*b*)	16 mm (0.63'', Fig. 1)
Bevel angle (*ß*, depends on the milling head used)	20°, 22.5°, 27.5°, 30°, 37.5°, 40°, 45°, 50°, 55°, 60°, 65° (Fig. 1)
Minimum workpiece thickness for beveling	1.5 mm (0.06'')
Minimum hole diameter	40 mm (1.57'')
Edge radius	2 mm, 3 mm, 4 mm, 5 mm (Fig. 1)
Noise level	More than 70 dB
Vibration level	2.3 m/s^2 (7.5 ft/s^2) Take periodic breaks during operation.
Required ambient temperature	0–40°C (34–104°F)
Weight (without milling head)	10 kg (22 lbs)

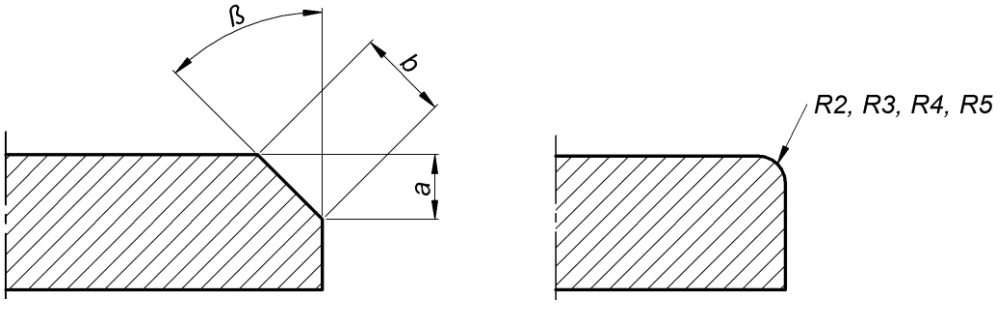
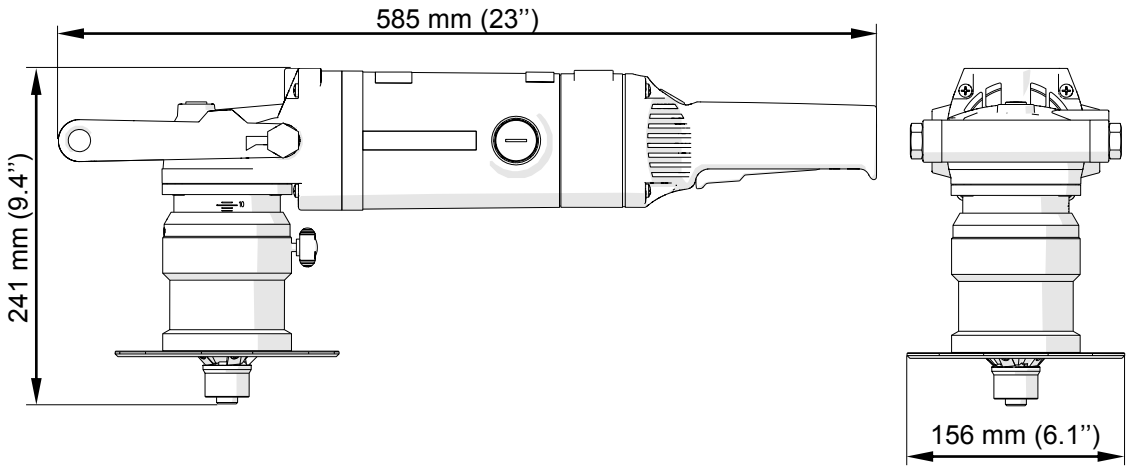


Fig. 1. Bevel dimensions



1.3. Design

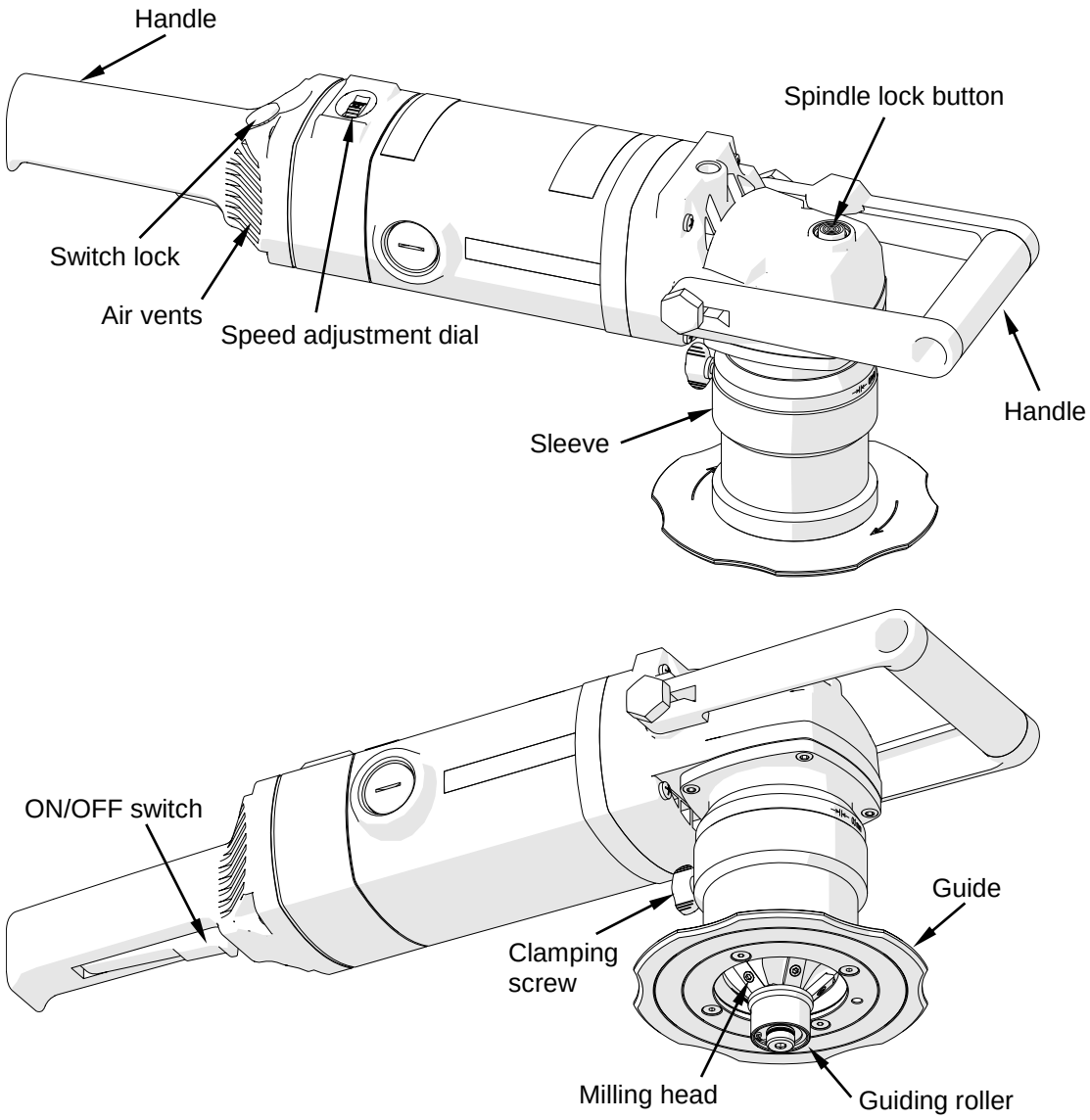


Fig. 2. View of the BM-16

1.4. Equipment included

The BM-16 is supplied including the following elements.

Beveling machine (without milling head)	1 unit
Metal box	1 unit
5 mm hex wrench	1 unit
14 mm hex wrench	1 unit
32 mm flat wrench	1 unit
Operator's Manual	1 unit

2. SAFETY PRECAUTIONS

1. Before beginning, read this Operator's Manual and complete proper occupational safety and health training.
2. Use the machine only in applications specified in this Operator's Manual.
3. The machine must be complete and all parts must be genuine and fully operational.
4. The specifications of the power source must conform to those specified on the rating plate.
5. Never carry the machine by the cord and never pull the cord because this may damage it and result in electric shock.
6. Untrained bystanders must not be present near the machine.
7. Before beginning, make sure that the correct is the condition of the machine, power source, power cord, plug, control components, and milling tools.
8. Keep the machine dry. Exposure to rain, snow, or frost is prohibited.
9. Keep the work area well lit, clean, and free of obstacles.
10. Never use near flammable liquids or gases, or in explosive environments.
11. Use only tools specified in this Operator's Manual.
12. Never use tools that are dull or damaged.
13. Install the cutting inserts and milling head securely. Remove adjusting keys and wrenches from the work area before connecting the machine to the power source.
14. Never use the machine in upside down position with the milling head facing up.
15. If the cutting edge of the insert is worn, rotate the insert in the socket by 90° or 180° or, if all possible to use edges are worn, replace with a new insert specified in this Operator's Manual.
16. Before every use, inspect the machine to ensure it is not damaged. Check whether any part is cracked or improperly fitted. Make sure to maintain proper conditions that may affect the operation of the machine.
17. Always use eye and hearing protection, non-skid footwear, and protective clothing during operation. Do not wear loose clothing.
18. Using the spindle lock button while either operating the machine or removing the milling head is prohibited because this may damage the machine.
19. Do not touch moving parts or metal chips formed during milling. Prevent objects from being caught in moving parts.

20. After every use, remove metal chips from the machine, especially from the milling head. Never remove chips with bare hands. Clean the machine with a cotton cloth without using any agents.
21. Cover steel parts with a thin anti-corrosion coating to protect them from rust when not in use for any extended period.
22. Maintain the machine and install/remove parts and tools only with the machine unplugged from the power source.
23. Repair only in a service center appointed by the seller.
24. If the machine falls from any height, is wet, or has any other damage that could affect the technical state of the machine, stop the operation and immediately send the machine to the service center for inspection and repair.
25. Remove from the worksite and store in a secure and dry location when not in use.

3. STARTUP AND OPERATION

3.1. Installing and removing the milling head

Unplug the machine from the power source. To install the milling head, place it on the spindle (*1*, Fig. 3), and then hold the spindle lock button *2* and tighten the head using the 14 mm hex wrench (*3*). Next, remove the nut (*4*) and assemble the roller with the pivot pin using washers (*5*), and then place the roller on the milling head (*6*), hold the button *2*, and tighten the roller with the 5 mm hex wrench (*7*). Use such a number of washers to keep a little gap between the roller and the cutting inserts (*8*). The number of 0.5-mm and 0.1-mm washers needed depends on the milling head used.

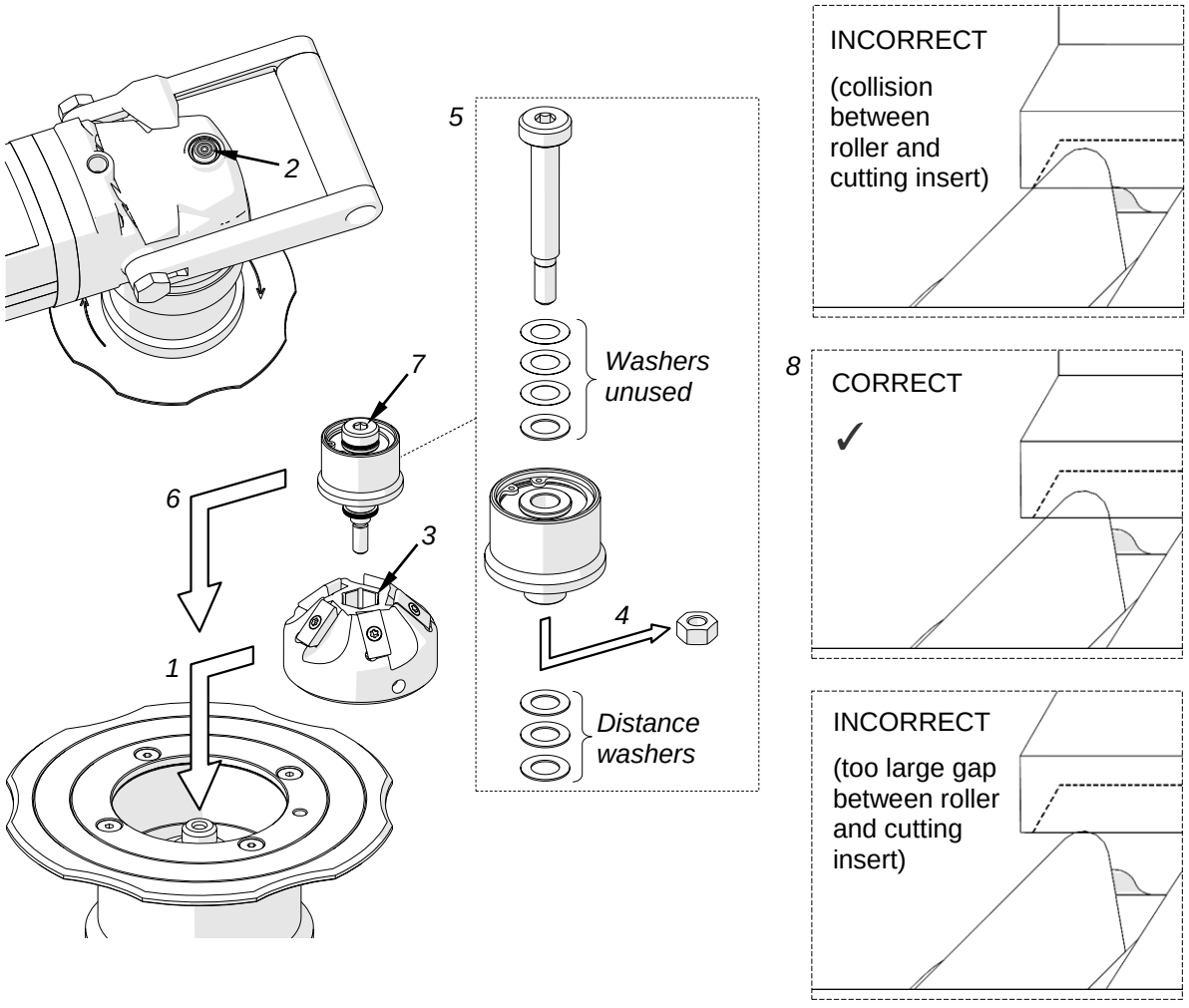


Fig. 3. Installing the milling head

Adjust the gap between the roller and the cutting inserts every time you replace the milling head. Place all unused washers between the pivot pin and the roller.

To remove the milling head, loosen the clamping screw (*1*, Fig. 4), and then unscrew the sleeve (*2*) and remove it (*3*). Next, hold the button *4*, and then use the 5 mm hex wrench (*5*) to unscrew the roller, and remove it (*6*). Lock the spindle with the 32 mm flat wrench (*7*, do not use the spindle lock button *4* because this may damage the machine), and then use the 14 mm hex wrench to unscrew the head (*8*), and remove it (*9*).

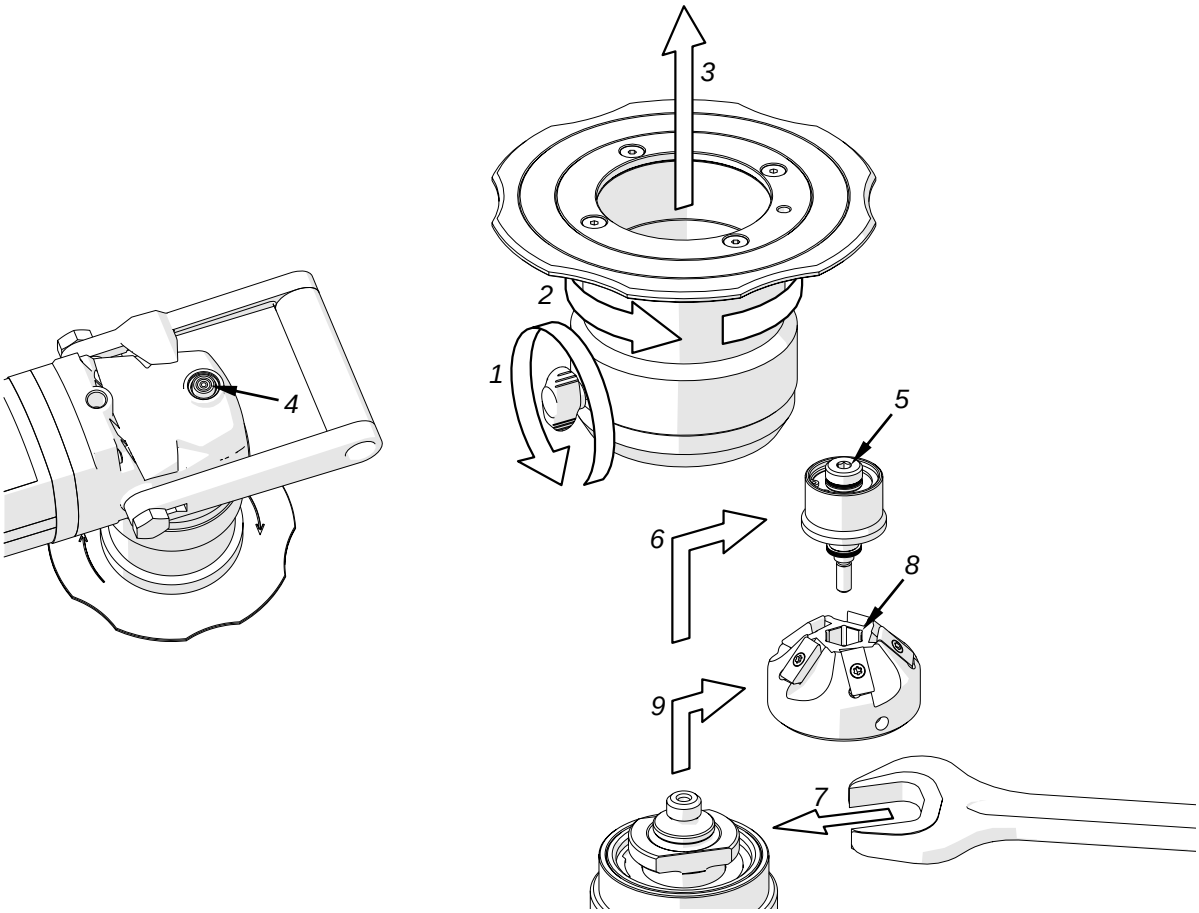


Fig. 4. Removing the milling head

3.2. Adjusting the bevel parameters

Unplug the machine from the power source. Next, loosen the clamping screw (*1*, Fig. 5), rotate the sleeve (*2*) in such a way that the scale *3* shows the required bevel height ‘a’ (Tab. 1), and then re-tighten the screw.

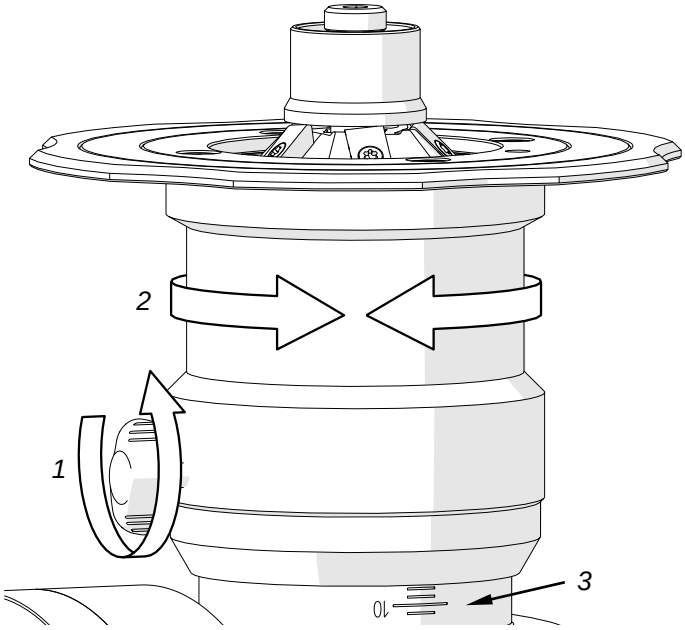
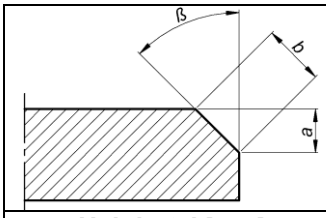


Fig. 5. Adjusting the bevel parameters

	**Milling head**										
	20°	22.5°	27.5	30°	37.5°	40°	45°	50°	55°	60°	65°
Height ‘a’ [mm]	**Width ‘b’** [mm]										
1	1.1	1.1	1.1	1.2	1.3	1.3	1.4	1.6	1.7	2.0	2.4
2	2.1	2.2	2.3	2.3	2.5	2.6	2.8	3.1	3.5	4.0	4.7
3	3.2	3.2	3.4	3.5	3.8	3.9	4.2	4.7	5.2	6.0	7.1
4	4.3	4.3	4.5	4.6	5.0	5.2	5.7	6.2	7.0	8.0	9.5
5	5.3	5.4	5.6	5.8	6.3	6.5	7.1	7.8	8.7	10.0	11.8
6	6.4	6.5	6.8	6.9	7.6	7.8	8.5	9.3	10.5	12.0	14.2
7	7.4	7.6	7.9	8.1	8.8	9.1	9.9	10.9	12.2	14.0	
8	8.5	8.7	9.0	9.2	10.1	10.4	11.3	12.4	13.9	16.0	
9	9.6	9.7	10.1	10.4	11.3	11.7	12.7	14.0	15.7		
10	10.6	10.8	11.3	11.5	12.6	13.1	14.1	15.6			
11	11.7	11.9	12.4	12.7	13.9	14.4	15.6				
11.5	12.2	12.4	13.0	13.3	14.5	15.0	16.3				
12	12.8	13.0	13.5	13.9	15.1	15.7					
13	13.8	14.1	14.7	15.0							

Tab. 1. Relation between bevel width and height of the available milling heads

3.3. Adjusting the guide for beveling with radius

Unplug the machine from the power source, and then in the manner described before loosen the clamping screw and rotate the sleeve to set the surface *1* (Fig. 6) on the same level as the radial cutting edge *2*. Next, re-tighten the clamping screw, and then bevel a test edge and readjust the position of the guide if necessary.

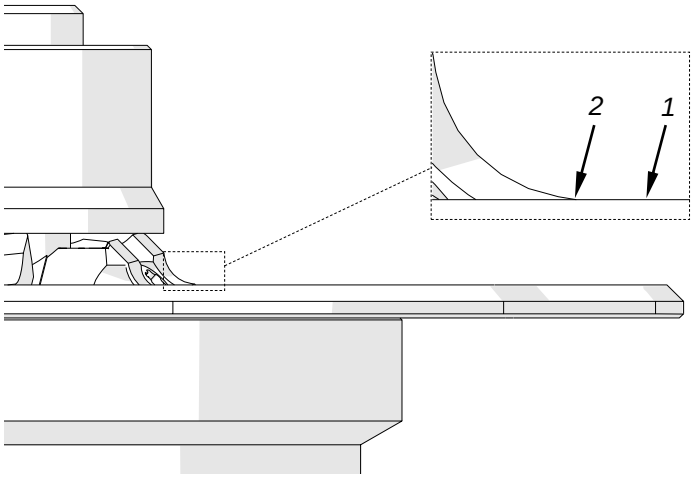


Fig. 6. Guide adjusted for beveling with radius

3.4. Preparing

Install a milling head with cutting inserts, and set the required bevel parameters. Then, use the speed adjustment dial to set the speed corresponding to the type of the workpiece (Tab. 2).

Material type	**Rotational speed**
Aluminum, brass, plastics	Setting 6 (5850 rpm)
Structural steel of standard quality, quality steel	Settings 3–5 (3100–4500 rpm)

Tab. 2. Recommended rotational speeds

The speed adjustment dial allows continuous control of the rotational speed in the range of 1800–5850 rpm (settings *1*–*6*). The relations between the setting and speed are as follows: setting *1* – 1800 rpm, *2* – 2400 rpm, *3* – 3100 rpm, *4* – 3800 rpm, *5* – 4500 rpm, *6* – 5850 rpm.

When using structural steel of standard quality or quality steel, set the speed to setting *4* and decrease the speed if intensive sparking occurs during operation.

3.5. Operating

Connect the machine to the power source and place the machine on the left side of the workpiece in the manner shown in Fig. 7. The milling head must not be in contact with the workpiece. The workpiece must be balanced and well fixed.

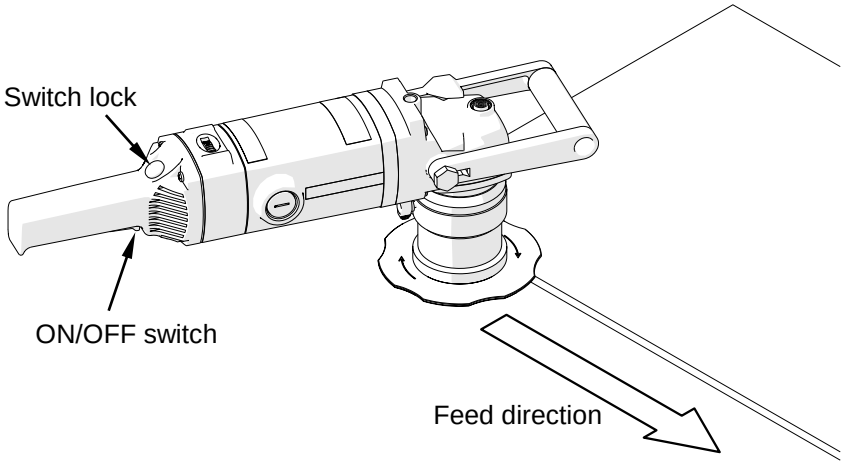


Fig. 7. Machine placed on a plate and proper feed direction

To start the motor, hold the switch lock and the ON/OFF switch, and then release the lock. Wait a few seconds until the machine reaches the required rotational speed, press the machine to the workpiece using both hands, and slowly slide toward the edge until the tool starts cutting into the metal. Operate according to the counter--rotation, by sliding the machine from left to right. The rotation direction of the milling head is indicated by the arrow on the guide.

Begin with making small bevels (3–4 mm, 0.12–0.16'') and increase the bevel width with gaining experience. Bevel in at least two or three passes. The bevel width should be set to a value that will allow the feed of one meter per minute without significant effort.

If the machine becomes overloaded, for instance when the bevel width is too large for the material being machined or when the cutting inserts are dull, the motor will automatically stop. However, prevent the motor from overloading by machining hard materials in multiple passes and replacing the inserts before they become dull. Additionally, take periodic breaks during operation, and keep the air vents unclogged to prevent the motor from overheating as this may lead to damage of the windings.

After the work is finished, turn off the motor by releasing the ON/OFF switch, wait until the rotation stops, and unplug the machine from the power source.

Clean the machine with a cotton cloth without using any agents.

3.6. Replacing the cutting inserts

Unplug the machine from the power source, and place the machine upside down. Next, loosen the clamping screw (*1*, Fig. 8) to access the milling head, and lower the sleeve as far as possible by rotating it to the right (*2*). Then, use the screwdriver supplied with the milling head to unscrew the screw (*3*), and remove the cutting insert (*4*). Clean the socket, and then rotate the insert and install again or replace with a new one if all possible to use edges are worn. Next, push and tighten the insert. The entire bottom of the insert must be in full contact with the surface of the socket (*5*).

Before replacing the cutting inserts of the radius milling head, hold the spindle lock button *6* and loosen the guiding roller with the 5 mm hex wrench (*7*).

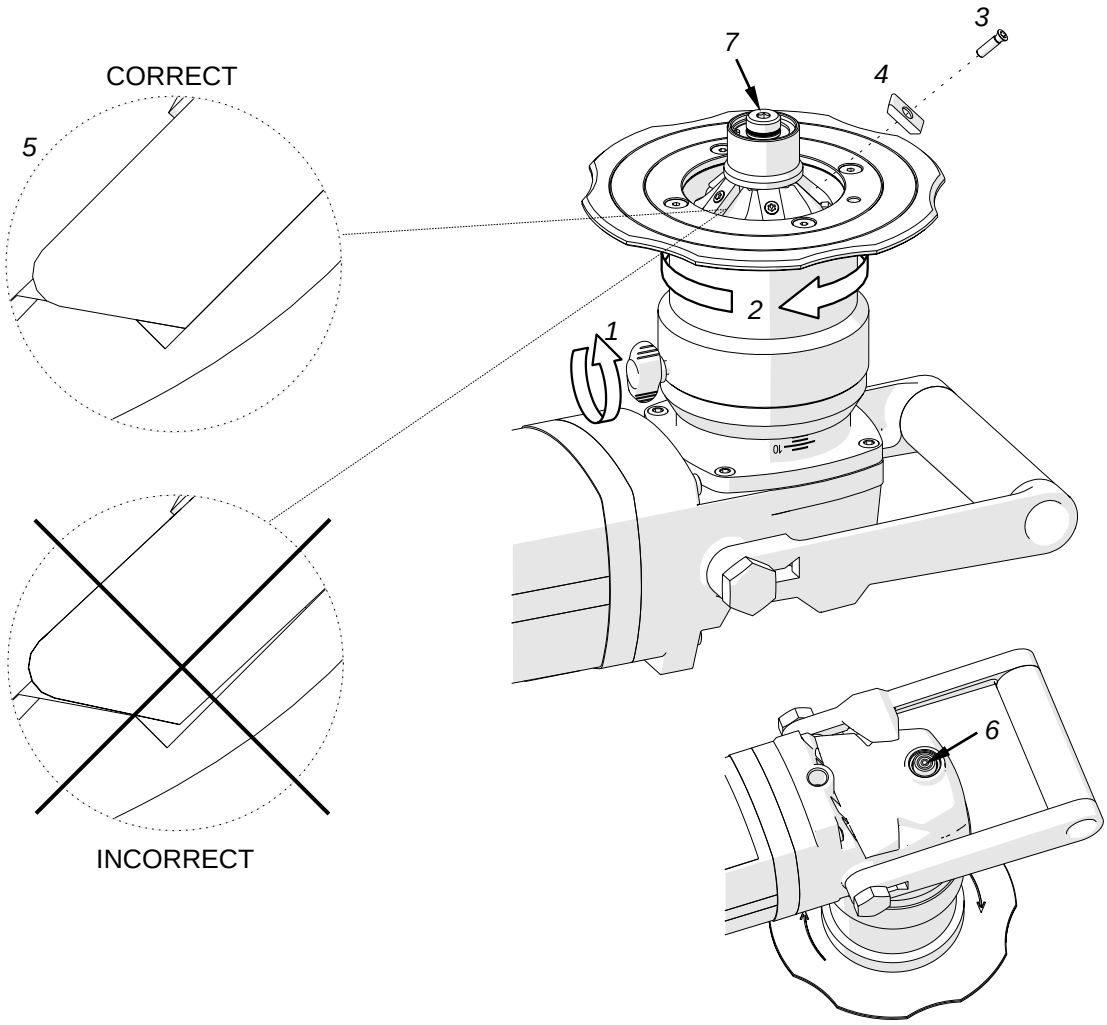


Fig. 8. Replacing the cutting inserts

Clean the threads once a week and, if necessary, grease the fixing screws for inserts using an agent (for instance copper paste) that will prevent the screws from blocking.

3.7. Replacing the roller

Unplug the machine from the power source, and place the machine upside down. Next, press the spindle lock button (*1*, Fig. 9), and then use the 5 mm hex wrench to unscrew the roller (*2*).

Remove the nut (*3*) and assemble the roller with the pivot pin using washers (*4*), and then place the roller on the milling head, hold the button *1*, and tighten the roller with the 5 mm hex wrench (*2*). Use such a number of washers to keep a little gap between the roller and the cutting inserts (*5*). The number of 0.5-mm and 0.1-mm washers needed depends on the milling head used. Place all unused washers between the pivot pin and the roller.

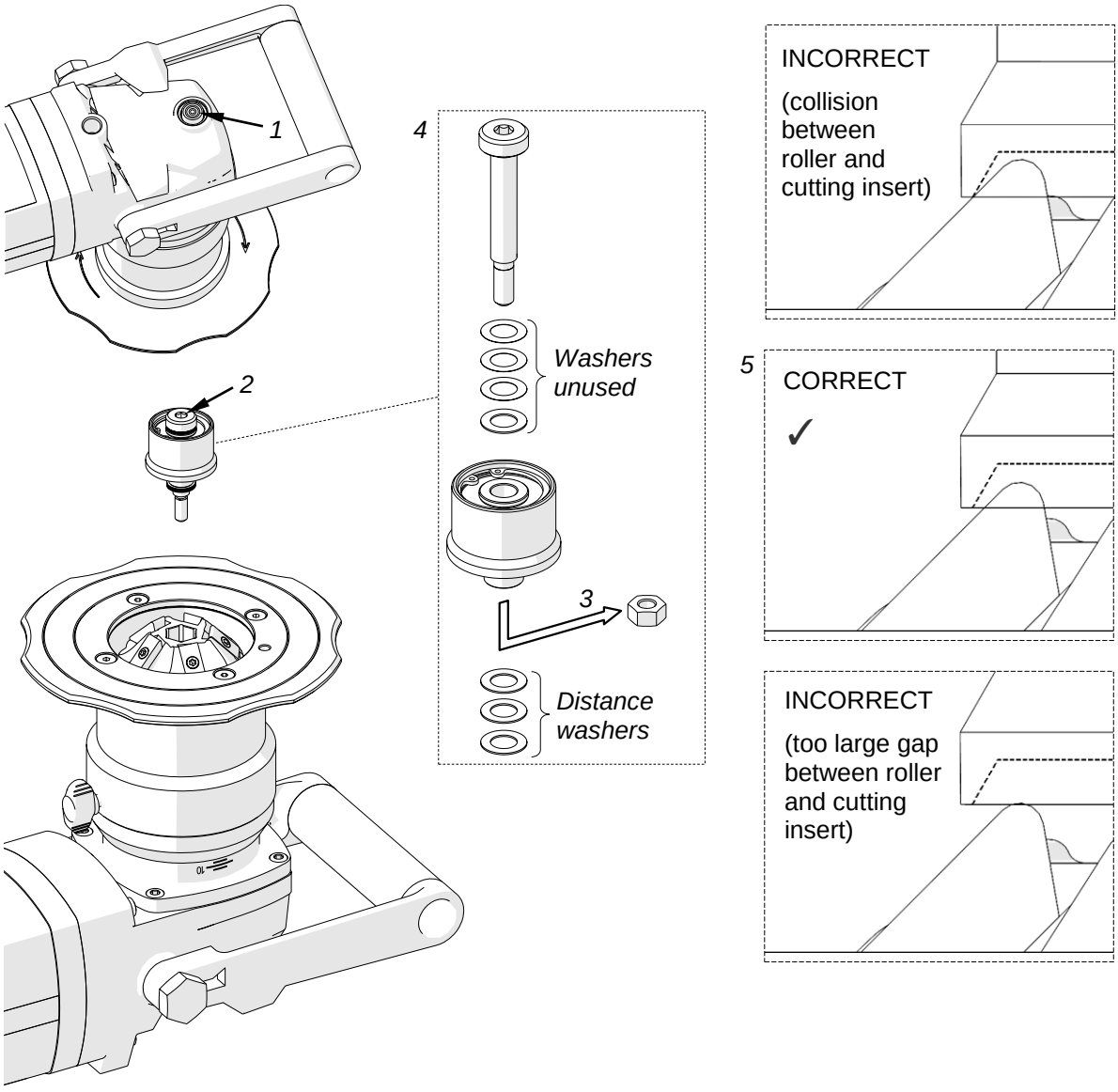


Fig. 9. Replacing the roller

3.8. Replacing the brushes

Check the condition of the carbon brushes every 200 operation hours. To do this, unplug the machine from the power source, unscrew the cap, and remove the brush (Fig. 10). If the length of the brush is less than 10 mm (0.4’’), replace both brushes with new ones. To install brushes, proceed in reverse order. After the replacement, run the motor without load for 20 minutes.

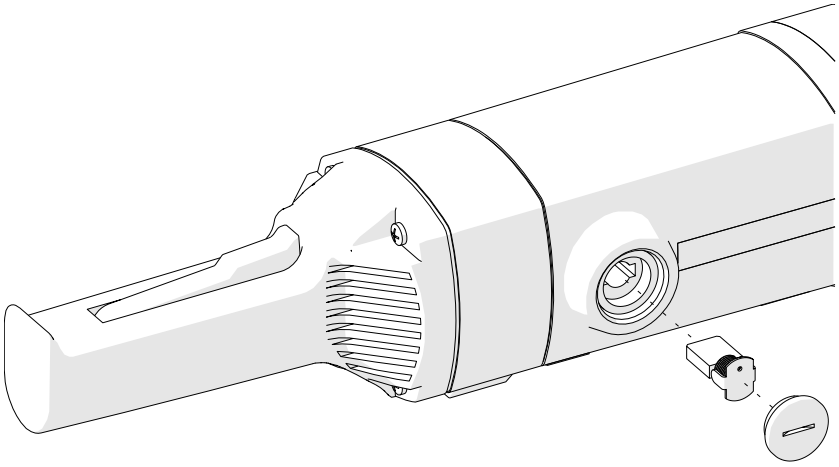


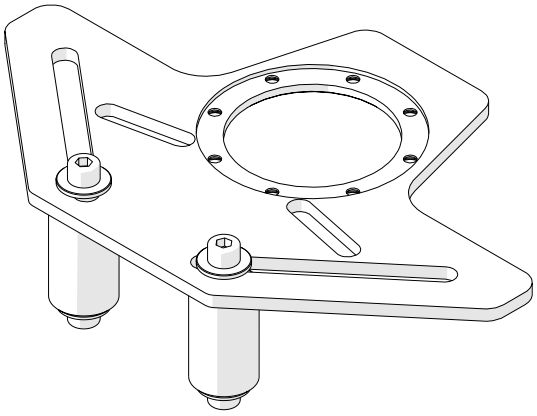
Fig. 10. Replacing the brushes

4. ACCESSORIES

4.1. Guide for beveling pipes

Allows external beveling of pipes with a diameter of at least 150 mm (5.9'') and internal beveling of pipes with a diameter of at least 110 mm (4.3'').

Part number:
PRW-0509-07-00-00-0
(includes: four M5x12 screws,
3 mm hex wrench, 6 mm hex wrench)



To install, unplug the machine from the power source, and place the machine upside down (Fig. 11). Then, use a 3 mm hex wrench to unscrew the standard guide and screw in the guide for pipes.

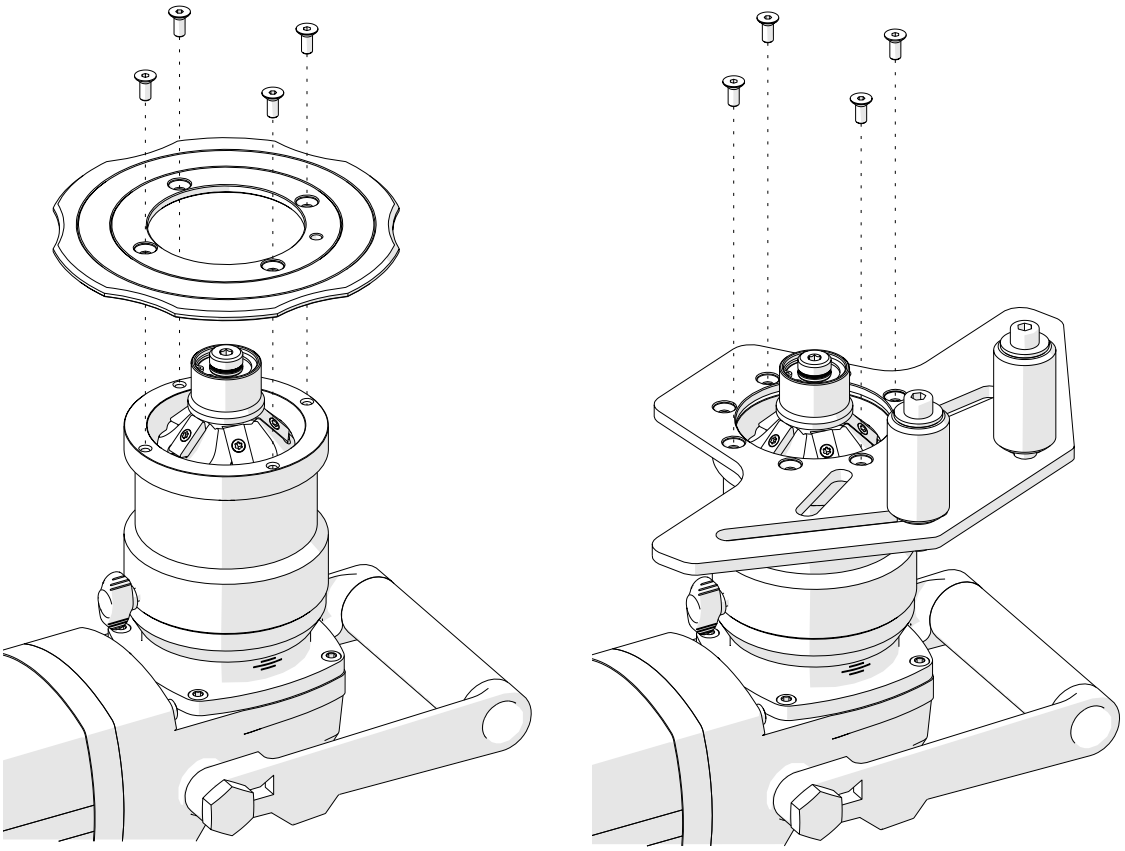


Fig. 11. Installing the guide for pipes

Rotate the sleeve to set ‘0’ on the pitch (*1*, Fig. 12), and then use the 6 mm hex wrench to loosen the guide rollers (*2*) and separate them from each other as far as possible. Place the machine on a vertically positioned pipe, pressing the roller *3* to the pipe, and then move the rollers *4* symmetrically to join them to the pipe and tighten in this position. Next, separate the machine from the pipe, and set the required parameters (*5*). Then, start the machine, slowly slide it toward the edge, and bevel according to the direction *6*.

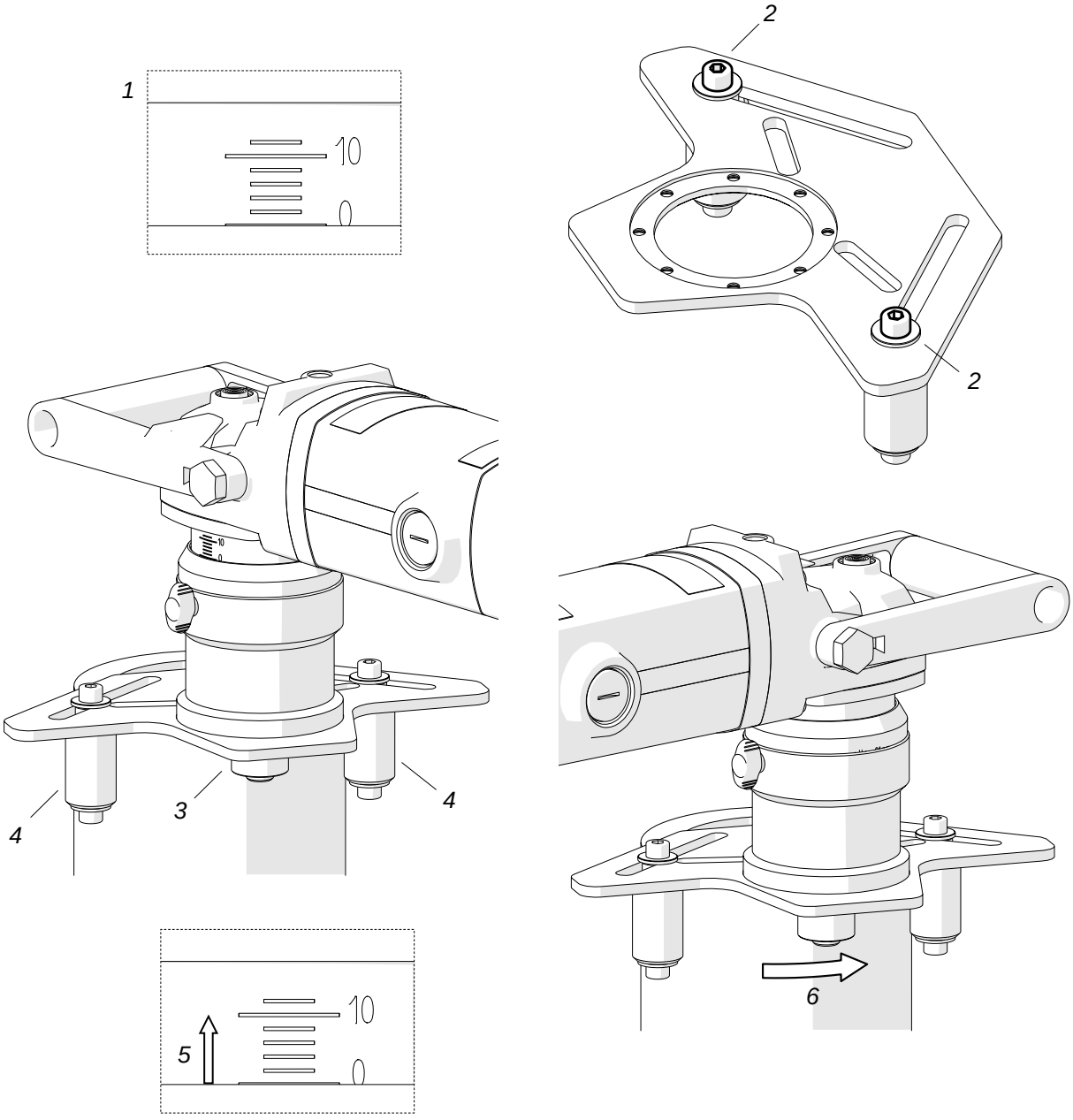
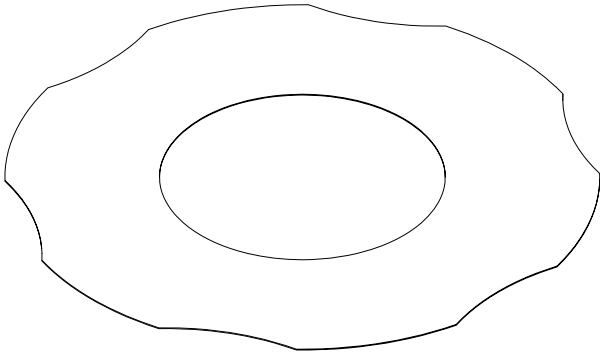


Fig. 12. Using the machine on a pipe

4.2. Guide sticker

Self-adhesive guide sticker against scratches is dedicated for aluminum beveling. If the sticker is removed, clean excess glue from the guide using petroleum ether.

Part number:
NKL-0509-05-00-00-0



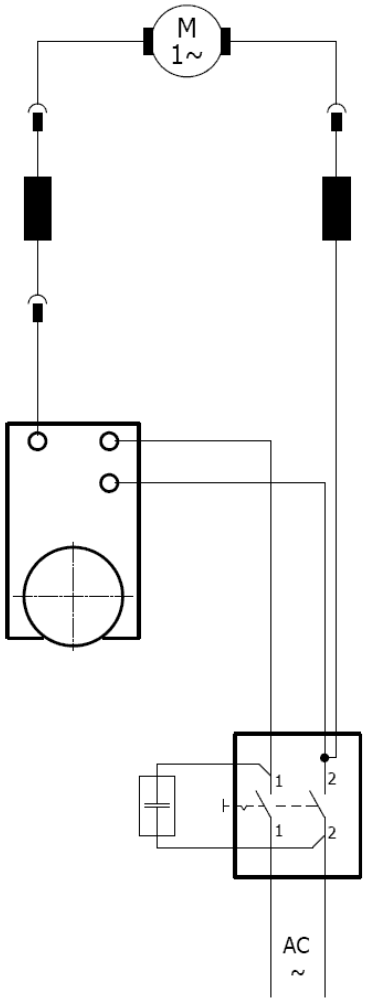
4.3. Milling tools

Part number	Part name
GLW-000016	Milling head 20°
GLW-000010	Milling head 22.5°
GLW-000023	Milling head 27.5°
GLW-000005	Milling head 30°
GLW-000009	Milling head 37.5°
GLW-000025	Milling head 40°
GLW-000006	Milling head 45°
GLW-000017	Milling head 50°
GLW-000008	Milling head 55°
GLW-000007	Milling head 60°
GLW-000018	Milling head 65°
PLY-000162	Beveling insert for steel (5 required)
PLY-000195	Beveling insert for aluminum (5 required)
SRB-000290	Fixing screw for beveling insert
GLW-000011	Radius milling head
PLY-000360	Radius insert R2 (4 required)
PLY-000159	Radius insert R3 (4 required)
PLY-000160	Radius insert R4 (4 required)
PLY-000161	Radius insert R5 (4 required)
SRB-000289	Fixing screw for radius insert

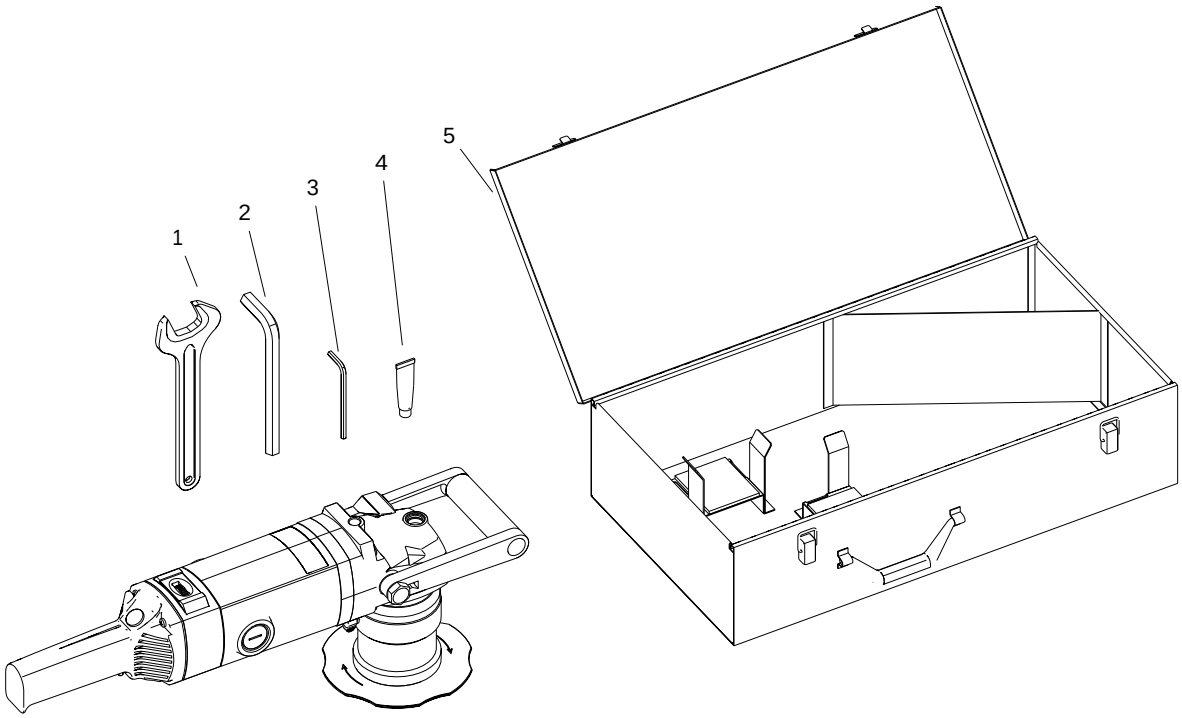
5. SPARE AND WEARING PARTS

Part number	Part name
RLK-0509-04-00-00-0	Guiding roller
SCZ-000031	Carbon brush for 110 V
SCZ-000030	Carbon brush for 230 V
KLC-000027	32 mm one-sided flat wrench
KLC-000008	5 mm hex wrench
KLC-000029	14 mm hex wrench
KLC-000028	T15 torx screwdriver
SMR-000005	Grease for screws (5 g, 0.17 oz)

6. WIRING DIAGRAM

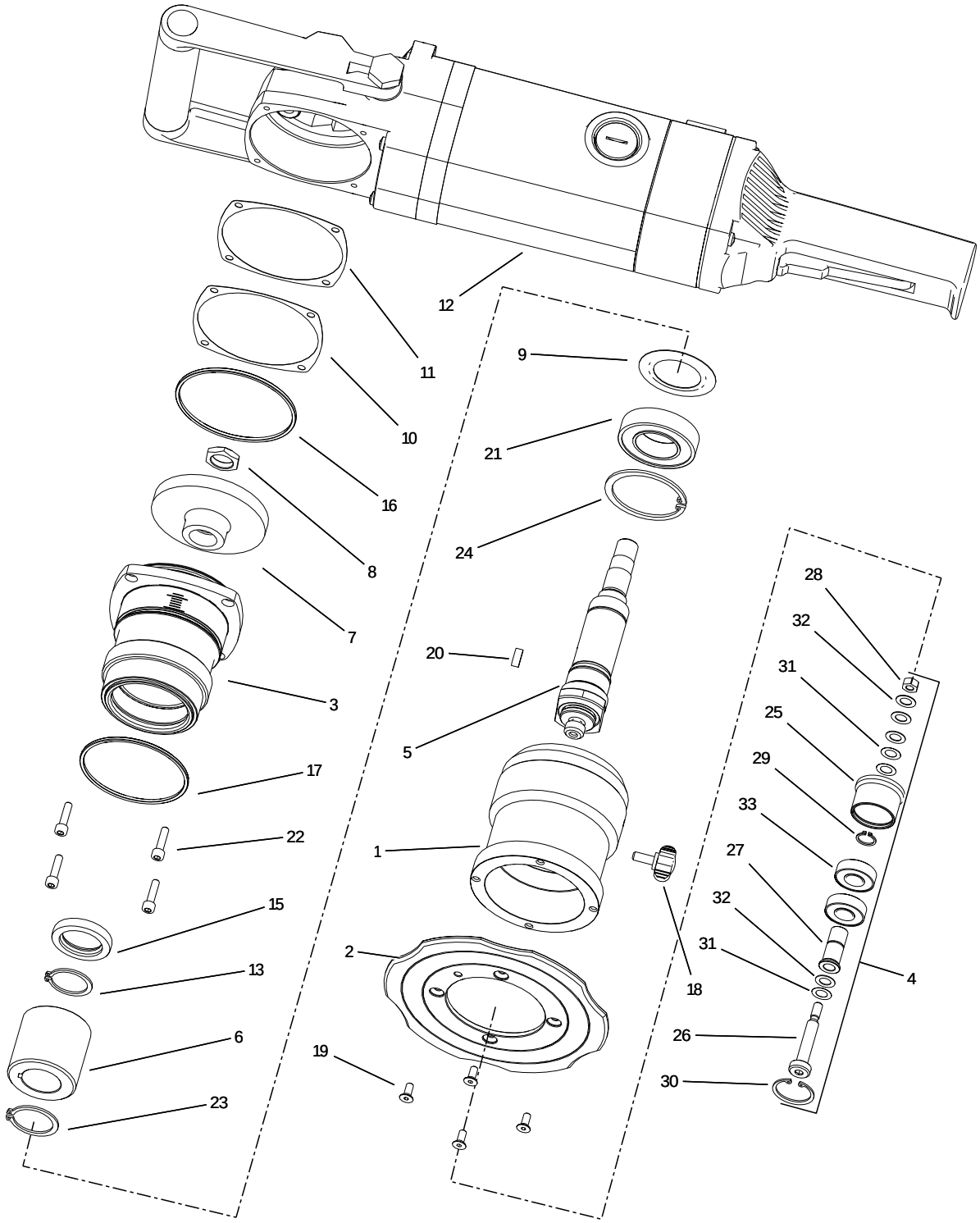


7. EXPLODED DRAWINGS AND PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	KLC-0427-11-01-00-0	32 MM SPECIAL FLAT WRENCH	1
2	KLC-000029	14 MM HEX WRENCH	1
3	KLC-000008	5 MM HEX WRENCH	1
4	SMR-000005	GREASE FOR SCREWS	1
5	SKR-0509-10-00-00-0	METAL BOX	1
–	GLW-000005	MILLING HEAD 30°	1
–	GLW-000006	MILLING HEAD 45°	1
–	GLW-000007	MILLING HEAD 60°	1
–	GLW-000008	MILLING HEAD 55°	1
–	GLW-000009	MILLING HEAD 37.5°	1
–	GLW-000010	MILLING HEAD 22.5°	1
–	GLW-000016	MILLING HEAD 20°	1
–	GLW-000017	MILLING HEAD 50°	1
–	GLW-000018	MILLING HEAD 65°	1
–	GLW-000023	MILLING HEAD 27.5°	1
–	GLW-000025	MILLING HEAD 40°	1
–	PLY-000162	BEVELING INSERT FOR STEEL	5
–	PLY-000195	BEVELING INSERT FOR ALUMINUM	5
–	SRB-000290	FIXING SCREW FOR BEVELING INSERT	5
–	GLW-000011	RADIUS MILLING HEAD	1
–	PLY-000159	RADIUS INSERT R3	4
–	PLY-000160	RADIUS INSERT R4	4
–	PLY-000161	RADIUS INSERT R5	4
–	SRB-000289	FIXING SCREW FOR RADIUS INSERT	4

– optional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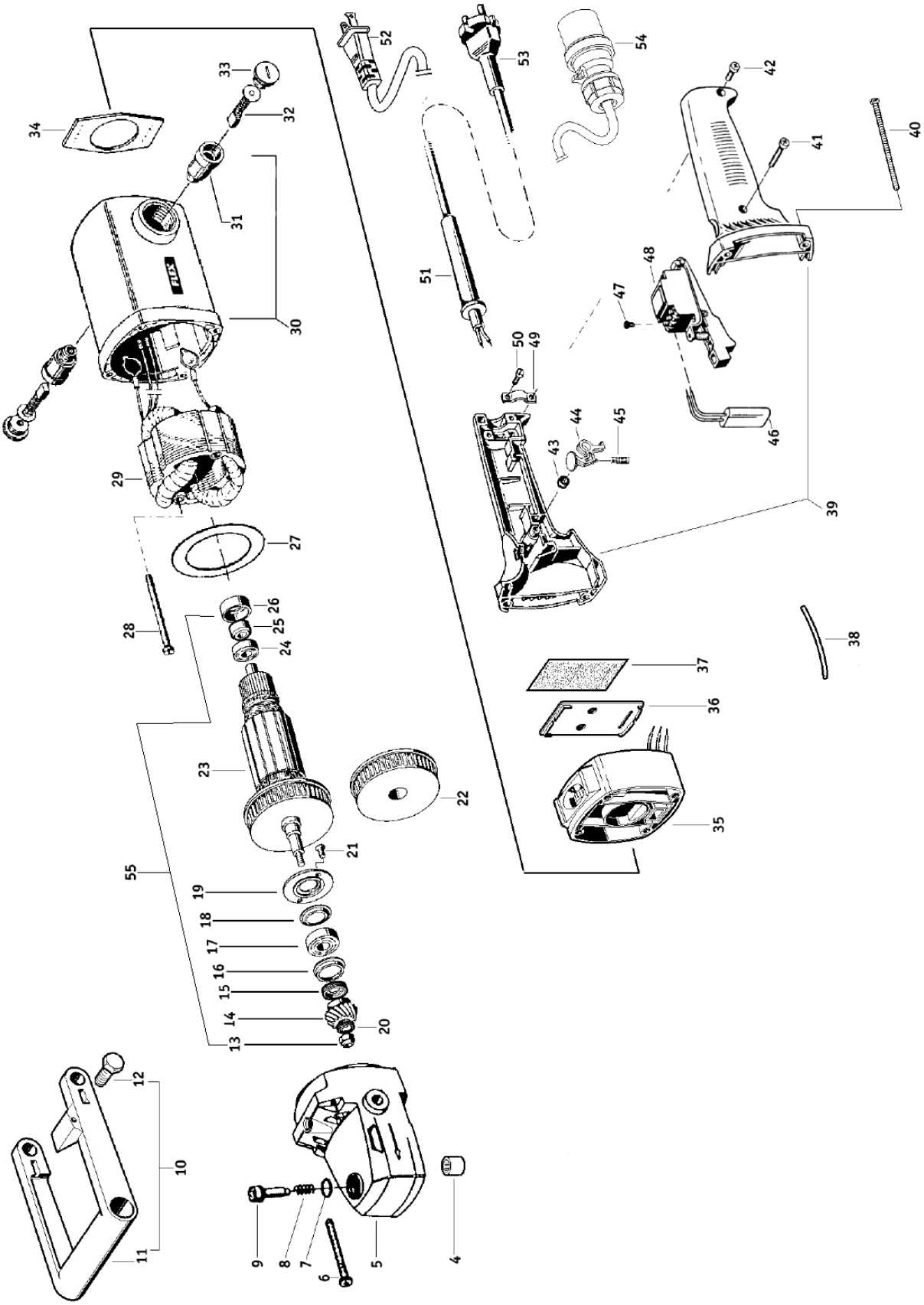
ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	TLJ-0427-01-03-00-1	SLIDING SLEEVE	1
2	PRW-0427-01-05-00-0	GUIDE	1
3	TLJ-0509-01-01-00-0	SPINDLE SLEEVE	1
4	RLK-0509-04-00-00-0	GUIDING ROLLER ASSY	1
5	WRZ-0509-01-02-00-0	SPINDLE	1
6	TLJ-0509-01-03-00-0	DISTANCE SLEEVE	1
7	KOL-0509-01-04-00-0	BEVEL GEAR z=53	1
8	NKR-0509-01-05-00-0	LOCKING NUT	1
9	OSL-0509-01-06-00-0	BEARING COVER	1
10	PDK-0509-02-00-00-0	DISTANCE WASHER 0.2	1
11	PDK-0509-02-00-00-1	DISTANCE WASHER 0.3	1
12	NPD-000011	MOTOR ASSY 110V (US)	1
12	NPD-000012	MOTOR ASSY 230V (CEE)	1
12	NPD-000013	MOTOR ASSY 110V (UK)	1
12	NPD-0509-15-00-00-0	MOTOR ASSY 230V (INDIA)	1
13	PRS-000019	EXTERNAL RETAINING RING 28z	1
15	PRS-000285	SEAL A-RING 28x42x7	1
16	PRS-000286	SEAL O-RING 80x3	1
17	PRS-000274	SEAL O-RING 72x3	1
18	PKT-000037	HANDLEVER	1
19	WKR-000134	HEX SOCKET COUNTERSUNK HEAD SCREW M5x12	4
20	WPS-000010	KEY 5x5x14	1
21	LOZ-000049	BALL BEARING 30x55x13	1
22	SRB-000086	HEX SOCKET HEAD CAP SCREW M5x20	4
23	PRS-000021	EXTERNAL RETAINING RING 30z	1
24	PRS-000033	INTERNAL RETAINING RING 55w	1
25	RLK-0427-14-02-00-1	ROLLER	1
26	SWR-0509-04-01-00-1	ROLLER PIVOT PIN	1
27	TLJ-0509-04-02-00-0	ROLLER SLEEVE	1
28	NKR-000018	HEX. NUT M6	1
29	PRS-000003	EXTERNAL RETAINING RING 12z	1
30	PRS-000018	INTERNAL RETAINING RING 28w	1
31	PDK-000174	WASHER 8x14x0.1	3
32	PDK-000010	WASHER 8x14x0.5	4
33	LOZ-000038	BALL BEARING 12x28x8	2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NPD-000011		MOTOR ASSY 110V (US)	
NPD-000012		MOTOR ASSY 230V (CEE)	
NPD-000013		MOTOR ASSY 110V (UK)	
NPD-0509-15-00-00-0		MOTOR ASSY 230V (INDIA)	
ITEM	**PART NUMBER**	**DESCRIPTION**	**Q-TY**
4	LOZ-000133	SLIDE SLEEVE HK 1512	1
5	KRP-000070	GEAR BODY	1
6	SRB-000338	HEAD SCREW TX25 M5x45	4
7	PRS-000291	SEALING RING 18W	1
8	SPR-000050	SPRING	1
9	SWR-000002	SPINDLE LOCK PIVOT PIN	1
10	RKJ-000059	FRONT HANDLE ASSY	1
11	RKJ-000060	FRONT HANDLE	1
12	SRB-000341	FULLY THREADED HEX CAP SCREW M14x25	2
13	NKR-000145	NUT M8x1	1
14	KOL-000089	BEVEL GEAR MZ 1.5x12	1
15	DYS-000009	DISTANCE	1
16	USZ-000044	SEALING	1
17	LOZ-000135	BALL BEARING 15x35x11	1
18	USZ-000045	SEALING 6003JV	1
19	PKR-000051	COVER	1
20	PDK-000189	WASHER NL8	1
21	WKR-000433	HEX SOCKET COUNTERSUNK HEAD SCREW M5x16	2
22	WNT-000009	FAN	1
23	WRN-000045	ROTOR 230V	1
23	WRN-000046	ROTOR 110V	1
24	LOZ-000136	BALL BEARING 12x28x8	1
25	PRS-000292	MAGNETIC RING	1
26	LOZ-000137	BEARING	1
27	OSL-000187	STATOR GUARD 230/CEE	1
28	SRB-000343	SCREW KT-KT 5x74	2
29	STN-000032	STATOR 230V	1
29	STN-000033	STATOR 110V	1
30	OBD-000035	STATOR HOUSING 230V	1
30	OBD-000036	STATOR HOUSING 110V	1
31	SCT-000010	BRUSH HOLDER 230V	2
31	SCT-000011	BRUSH HOLDER 110V	2
32	SCZ-000030	BRUSH 230V	2
32	SCZ-000031	BRUSH 110V	2
33	PKR-000046	BRUSH HOLDER COVER	2
34	PKR-000047	HANDLE COVER SB	1
35	ZSP-000014	ROTATIONAL SPEED CONTROLLER UNIT 230V	1
35	ZSP-000015	ROTATIONAL SPEED CONTROLLER UNIT 110V	1
36	PKR-000048	CONTROLLER BODY COVER	1
37	PDK-000193	INSULATION WASHER	1
38	OSL-000189	WIRE SHIELD GF	1
39	KRP-000075	HANDLE BODY	1
40	SRB-000343	SCREW KT-KT 5x74	4
41	SRB-000344	SCREW KT-KT 4x30	1
42	SRB-000345	SCREW KT-KT 4x20	1
43	TLJ-000108	LOCK SLEEVE	1
44	BLD-000016	SWITCH LOCK	1

45	SPR-000052	SPRING	1
46	KND-000138	CAPACITOR X2 0.22uF	1
47	SRB-000348	SCREW M3.5x7 DK4.1	1
48	WLC-000035	SWITCH	1
49	WSP-000059	WIRE BRACKET PA6	1
50	SRB-000345	SCREW KT-KT 4x20	2
51	OSL-000191	WIRE SHIELD fi9	1
51	OSL-000192	WIRE SHIELD fi11	1
52	PWD-000150	POWER CORD AWG 16/2 SJ 120 (US)	1
53	PWD-000151	POWER CORD H07RN-F 2x1Qx4M	1
54	PWD-000152	POWER CORD WITH PLUG BS 4343	1
55	WRN-000057	ROTOR 120V ASSY	1
55	WRN-000058	ROTOR 230V ASSY	1
56*	PWD-0212-10-02-00-6	POWER CORD 230V 3x1.5 WITH STRAIN RELIEF ASSY (INDIA)	1

* not shown in the drawing

8. DECLARATION OF CONFORMITY

EC Declaration of Conformity

We

PROMOTECH sp. z o.o.
ul. Elewatorska 23/1
15-620 Białystok
Poland

declare with full responsibility that:

BM-16 BEVELING MACHINE

is manufactured in accordance with the following standards:

- EN 60745-1
- EN 55014
- EN ISO 12100-1
- EN ISO 12100-2

and satisfies safety regulations of the guidelines: 2004/108/EC, 2006/95/EC, 2006/42/EC.

Białystok, 10 April 2013

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Marek Siergiej
CEO

9. QUALITY CERTIFICATE

Machine control card

BM-16 BEVELING MACHINE

Serial number .....

Quality control .....

Adjustments, inspections

Quality control .....

10. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the BM-16 Beveling Machine to be free of defects in material and workmanship under normal use for a period of 12 months from the date of sale.

This warranty does not cover cutting inserts as well as damage or wear that arise from misuse, accident, tempering, or any other causes not related to defects in workmanship or material.

Date of production .....

Serial number .....

Date of sale .....

Signature of seller.....

1.15 / 19 January 2016

WE RESERVE THE RIGHT TO MAKE CHANGES IN THIS MANUAL WITHOUT NOTICE