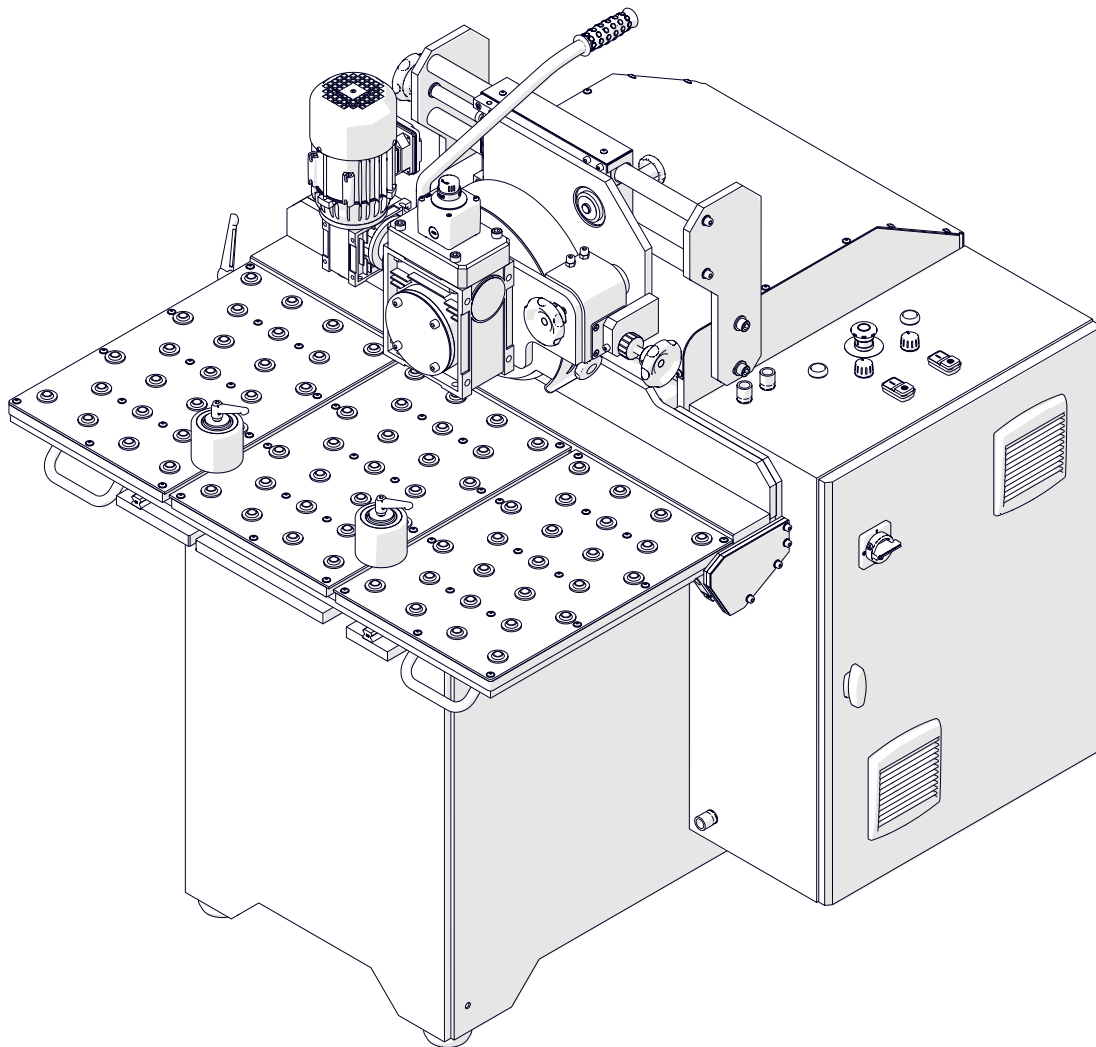


The tools of innovation.

## OPERATOR'S MANUAL

### **SBM-500**

### STATIONARY BEVELING MACHINE



112 Inverness Circle East Suite F Englewood, CO 80112

1-87STEELMAX, FAX 303-690-9172

[www.steelmax.com](http://www.steelmax.com) [sales@steelmax.com](mailto:sales@steelmax.com)

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## 1. GENERAL INFORMATION

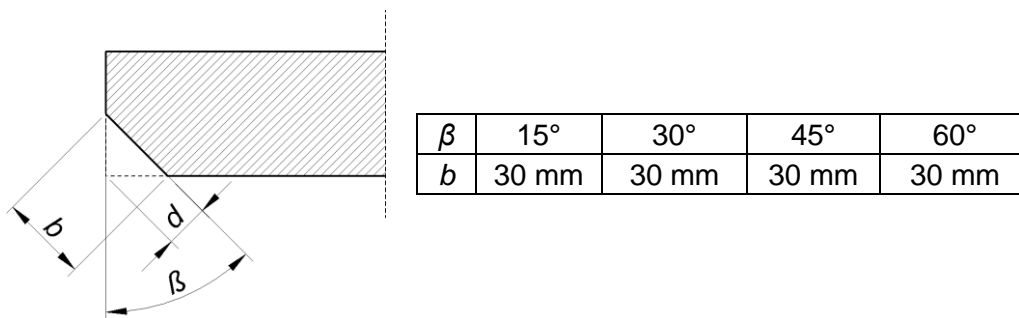
### 1.1. Application

The SBM-500 is a stationary machine designed to bevel plates made of carbon steel, stainless steel, or aluminum alloys. The workpieces can be machined at an angle of 15–60° and to the bevel width of up to 30 mm (1-3/16").

Accessories allow beveling pipes with outer diameters of 50–150 mm (2–6") and beveling longer plates.

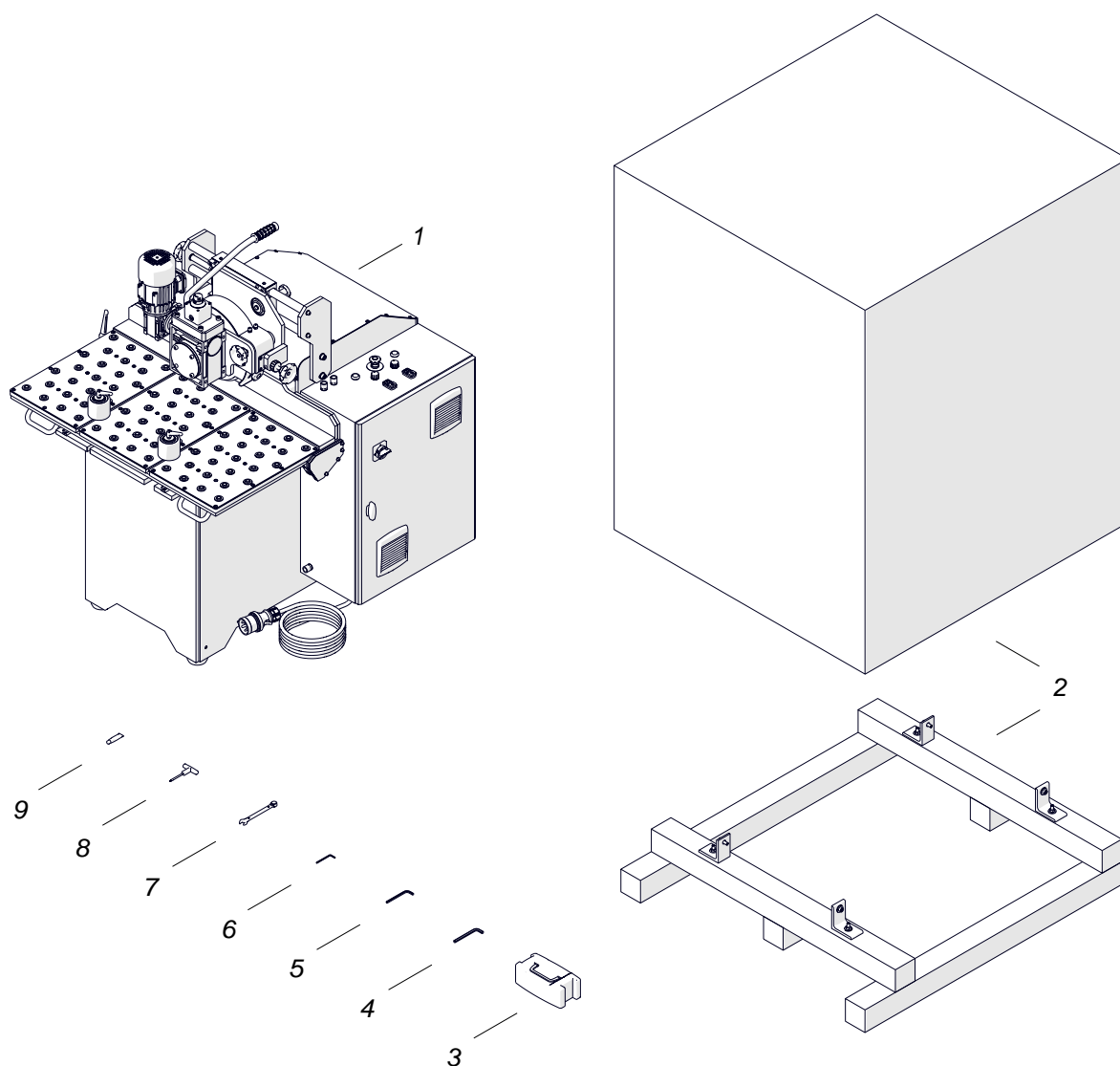
### 1.2. Technical data

Voltage	3~ 460V + PE, 50/60 Hz
Power	8 kVA
Spindle rotational speed (without load)	500–2920 rpm
Feed wheel rotational speed	0.2–3.5 rpm
Feed speed	0.2–3.3 m/min
Table load capacity	100 kg (220 lbs)
Bevel angle ( $\beta$ , Fig. 1)	15–60°
Maximum bevel width ( $b$ , Fig. 1)	30 mm (1-3/16")
Maximum milling head penetration ( $d$ , Fig. 1) allowed per a single pass	4 mm (5/32")
Workpiece thickness	3–100 mm (1/8–4")
Minimum workpiece length	150 mm (6")
Minimum workpiece width	50 mm (2")
Protection level	IP 20
Protection class	I
Required ambient temperature	0–40 °C (34–104°F)
Weight	865 kg (1910 lbs)



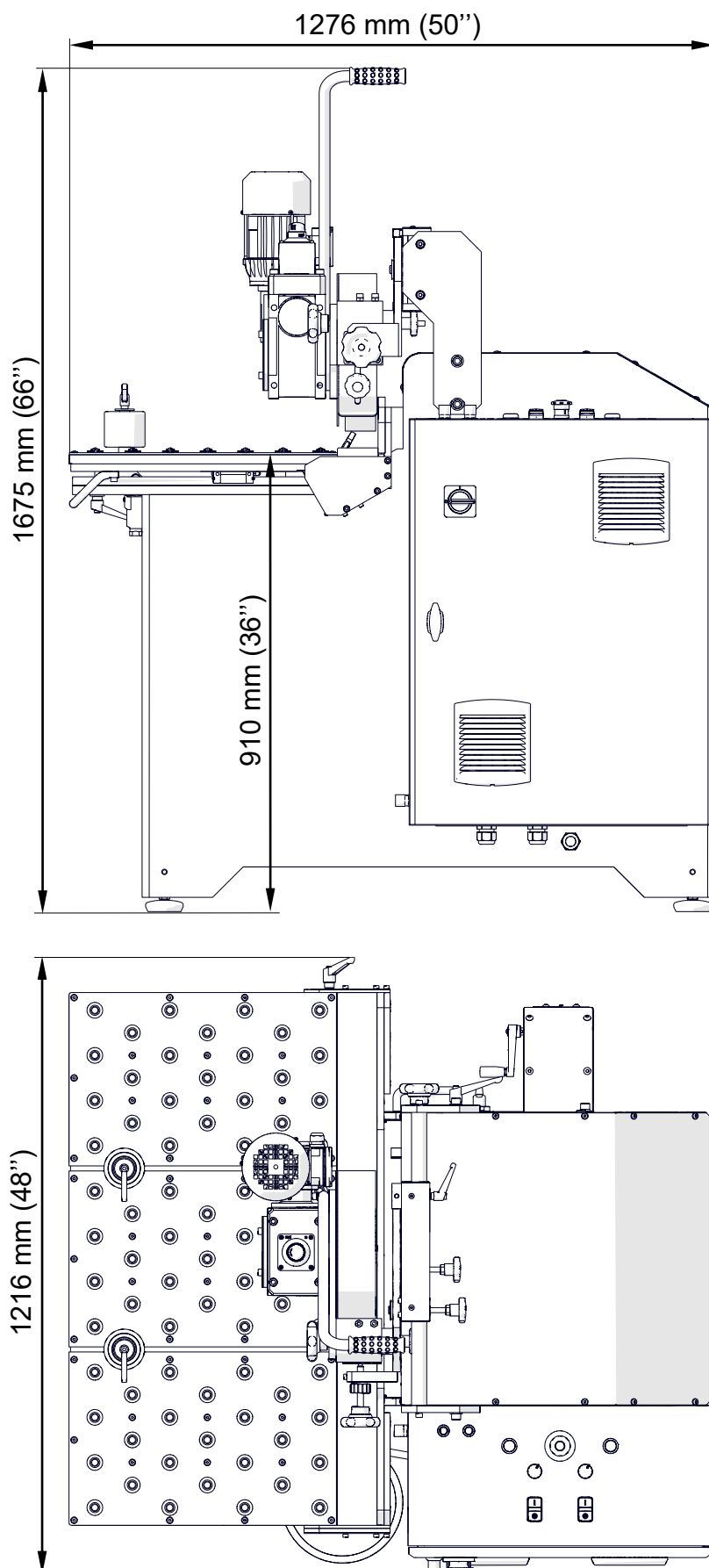
**Fig. 1.** Bevel dimensions; maximum bevel width depending on the angle

### 1.3. Equipment included

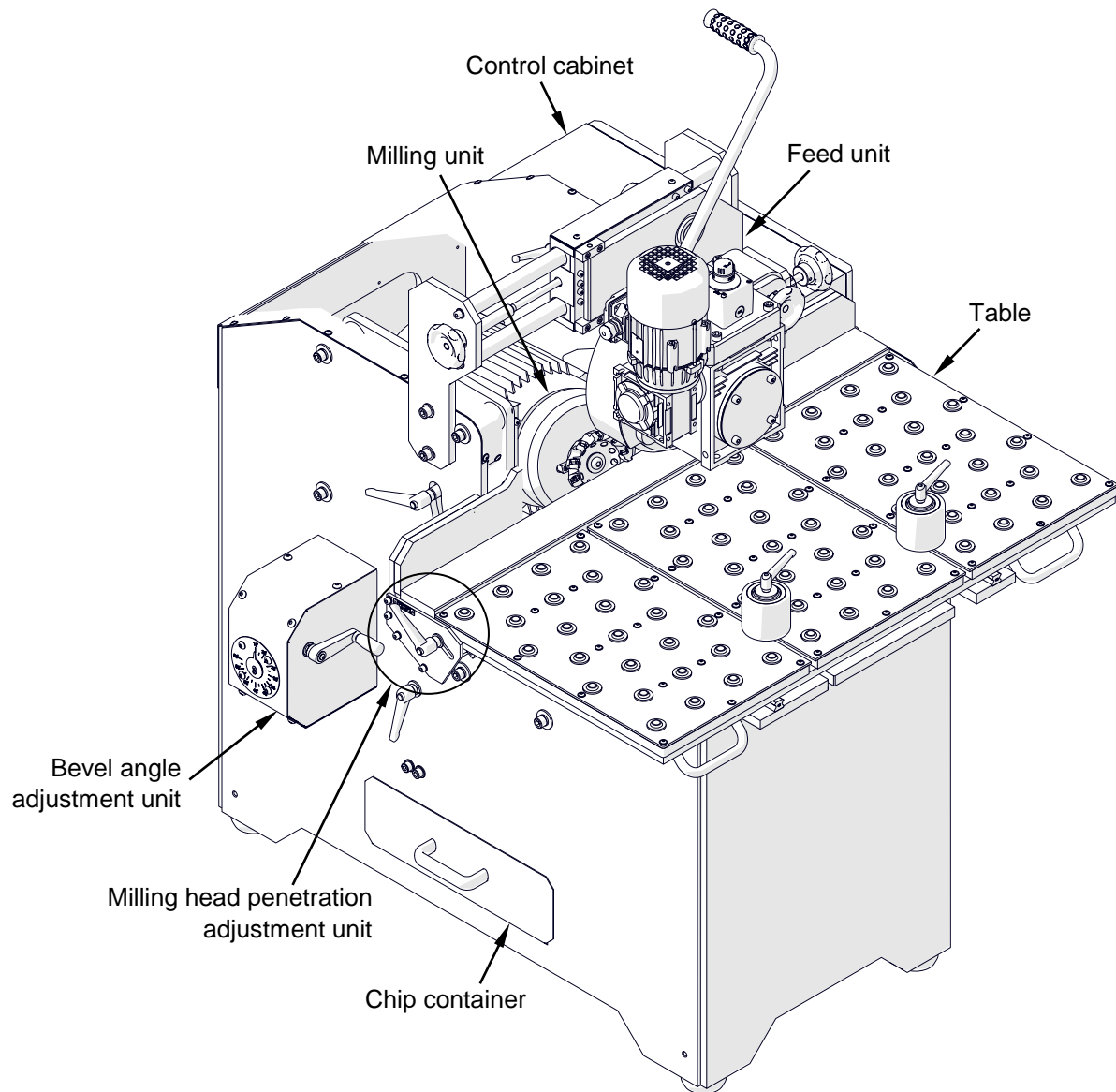


1	Stationary beveling machine (includes milling head with 10 cutting inserts)	1 unit
2	Wooden box with base and mounting brackets	1 unit
3	Tool box	1 unit
4	8 mm hex wrench	1 unit
5	6 mm hex wrench	1 unit
6	3.5 mm hex wrench	1 unit
7	14 mm combination wrench	1 unit
8	T15 torx screwdriver	1 unit
9	Grease for screws	1 unit
—	Operator's manual	1 unit

## 1.4. Dimensions



## 1.5. Design



## **2. SAFETY PRECAUTIONS**

1. Before starting, 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 functional.
4. The specifications of the power source must conform to those specified on the rating plate.
5. Connect the machine to a 3×460 V + PE power system. The supply line must be equipped with at a three-phase slow-blow fuse with rating of at least 25 A.
6. Never pull the cord because this may damage it and result in electric shock.
7. Keep the machine in vertical position during transport and work.
8. Place the machine on a surface that ensures balance and efficiently transfers the loads of the machine and workpiece. An improperly prepared surface may lead to damage, incorrect machine work, and injuries to persons nearby.
9. Untrained bystanders must not be present near the machine.
10. Before starting, ensure the correct condition of the machine, power source, power cord, plug, control panel components, and tools.
11. Keep the machine dry, and never expose it to rain, snow, or frost.
12. Keep the worksite well lit, clean, and free of obstacles.
13. Install the cutting inserts securely by tightening the set screws. Remove adjusting keys and wrenches from the work area before connecting the machine to the power source.
14. Never use cutting inserts that are dull or damaged.
15. If the cutting edge of the insert is worn, rotate the insert by 90° or, if all four edges are worn, replace with a new insert specified in this Operator's Manual.
16. Do not make bevels or use workpieces whose parameters differ from those specified in the technical data.
17. Never use near flammable liquids or gases, or in explosive environments.
18. Always use the feed wheel during work.
19. 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.

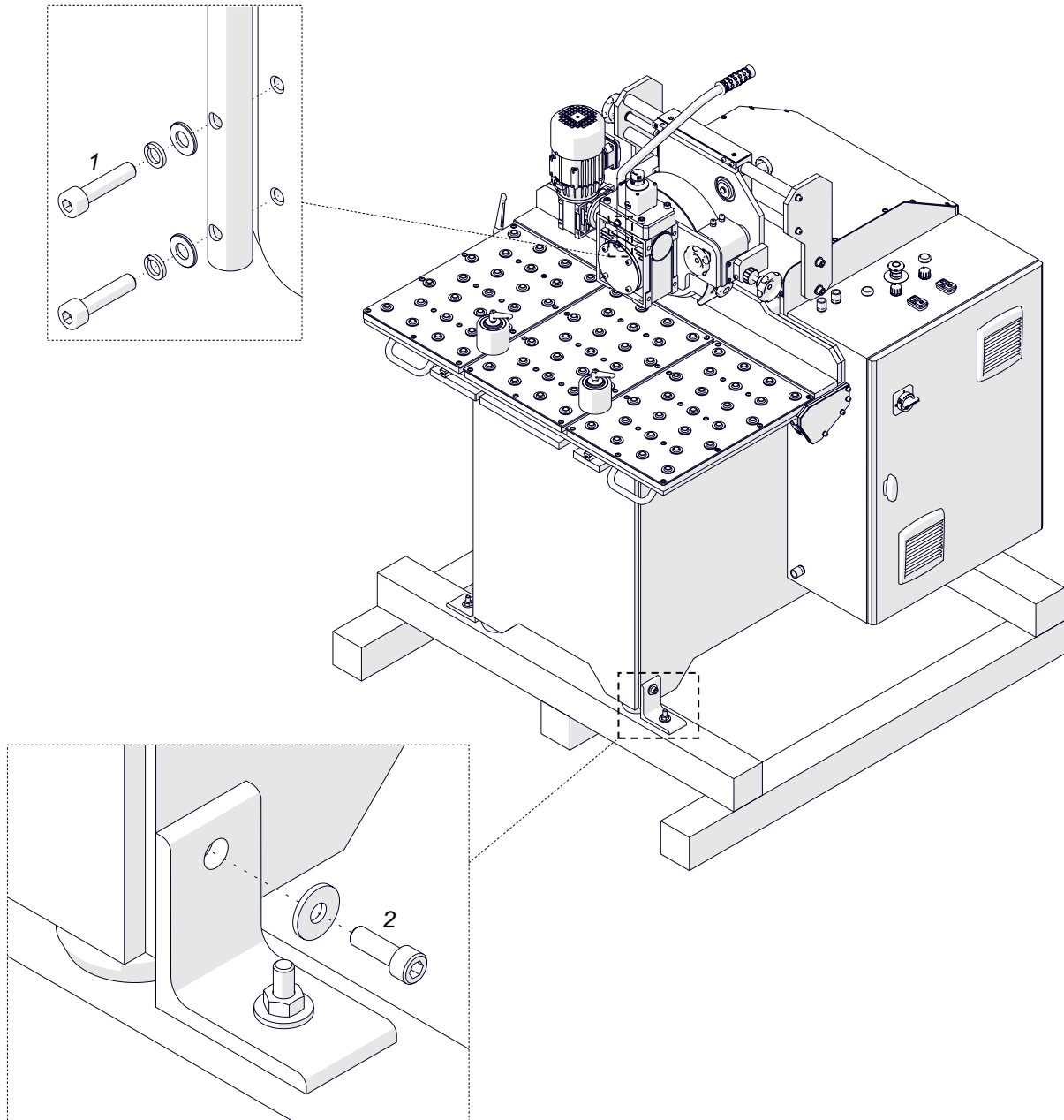
20. Always use eye and hearing protection, gloves, and protective clothing during work. Do not wear loose clothing.
21. Do not touch moving parts or metal chips formed during milling. Prevent anything from being caught in moving parts. Never put hands under the feed wheel.
22. After every use, remove metal chips from the machine and milling head. Never remove chips with bare hands. Clean the machine with a cotton cloth without using any chemical agents.
23. Cover steel parts with a thin anti-corrosion coating to protect the machine from rust when not in use for any extended period.
24. Maintain the machine and install/remove parts and tools only when the machine is unplugged from the power source.
25. Repair only in a service center appointed by the seller.
26. If the machine is wet or has any other damage that could affect the technical state of the machine, stop the work and promptly send the machine to the service center for inspection and repair.
27. Never leave the machine unattended during work.



### 3. STARTUP AND OPERATION

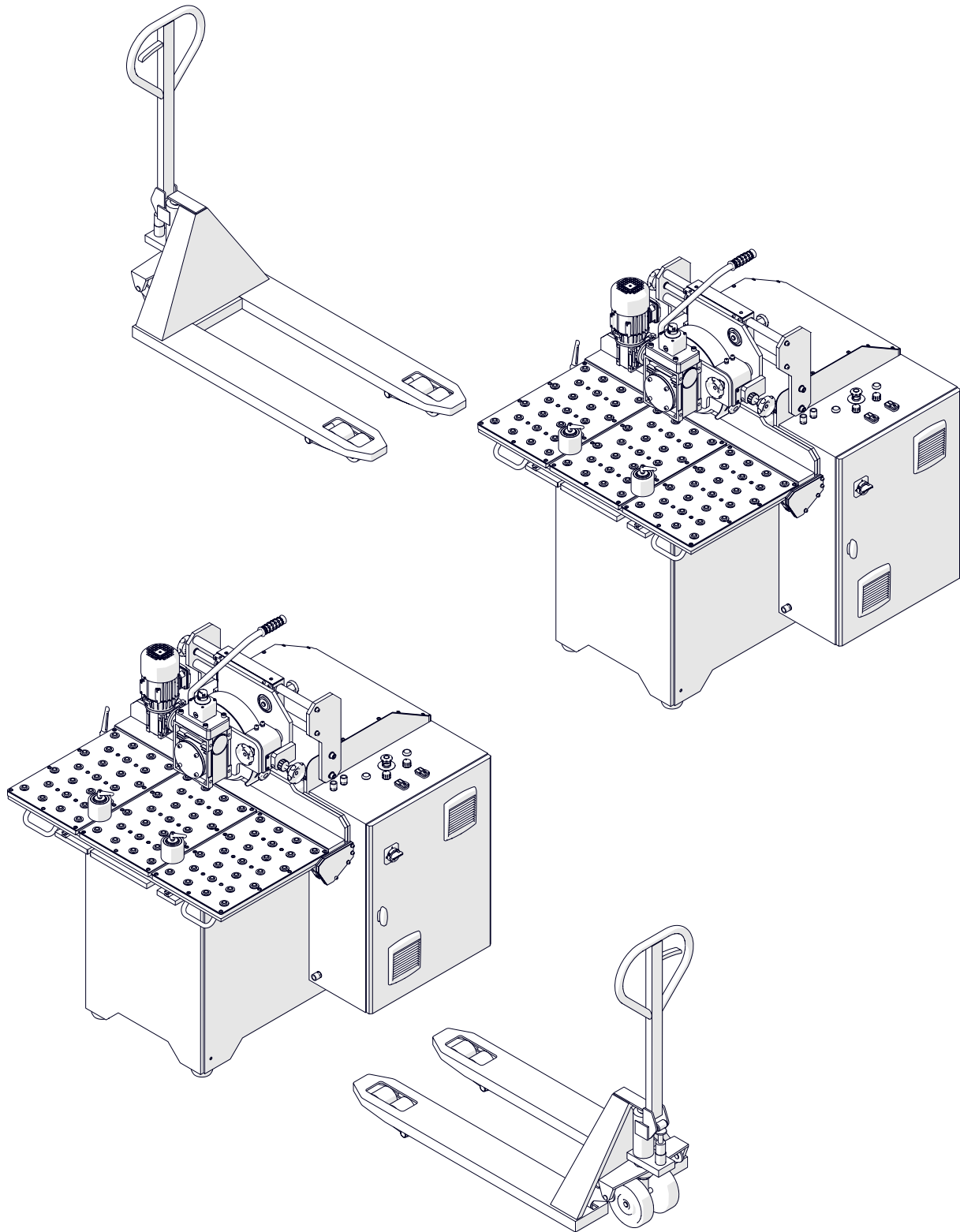
#### 3.1. Preparing

Use the 6 mm hex wrench to tighten the handle (1, Fig. 2), and then use the 8 mm hex wrench to detach the machine from the brackets (2).



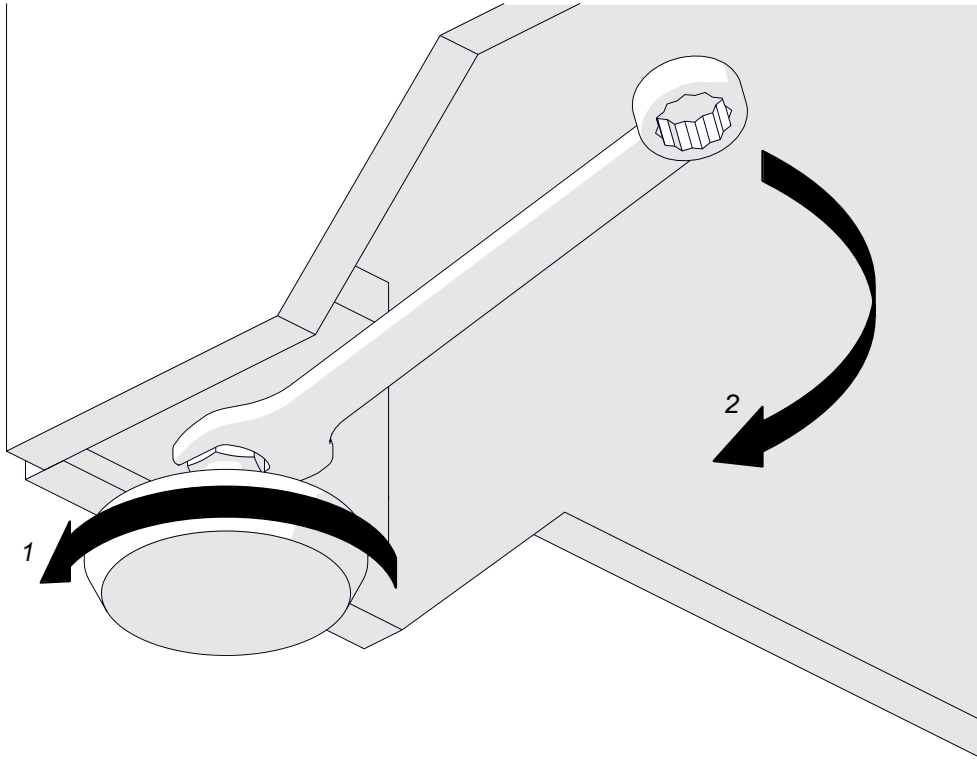
**Fig. 2.** Installing the handle and detaching the machine from the base

Use a pallet jack to lift the machine from left or right (Fig. 3), and then transport it to the workspace.



**Fig. 3.** Transporting the machine to the worksite

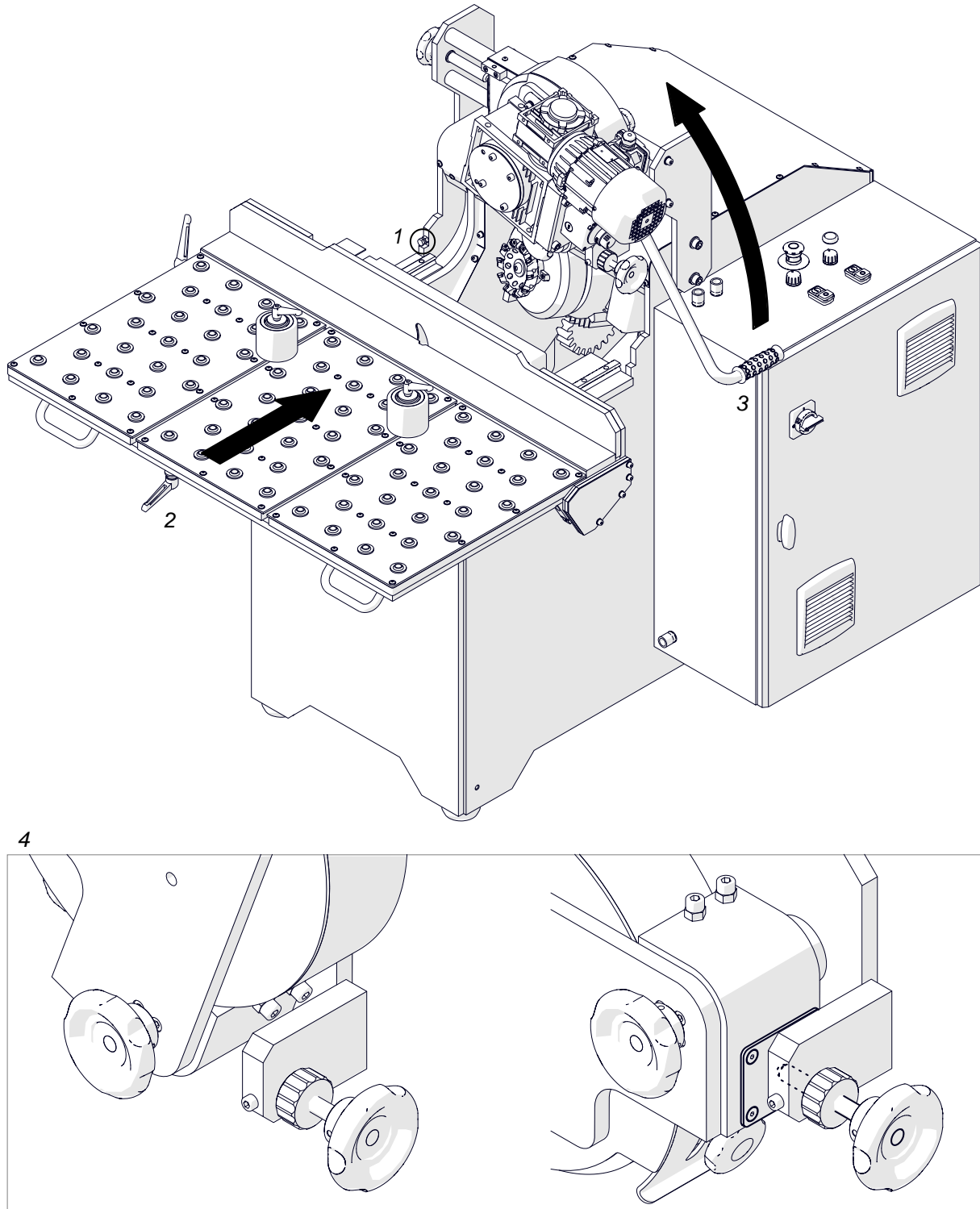
Place the machine on a surface that ensures balance and efficiently transfers the loads of the machine and workpiece. Rotate the feet that are not in contact with the surface so that they rest on it (1, Fig. 4), and then use the 18 mm flat wrench to tighten the nuts, which will lock the feet in this position.



**Fig. 4.** Levelling the machine on the surface

### 3.2. Setting the table and the feed unit

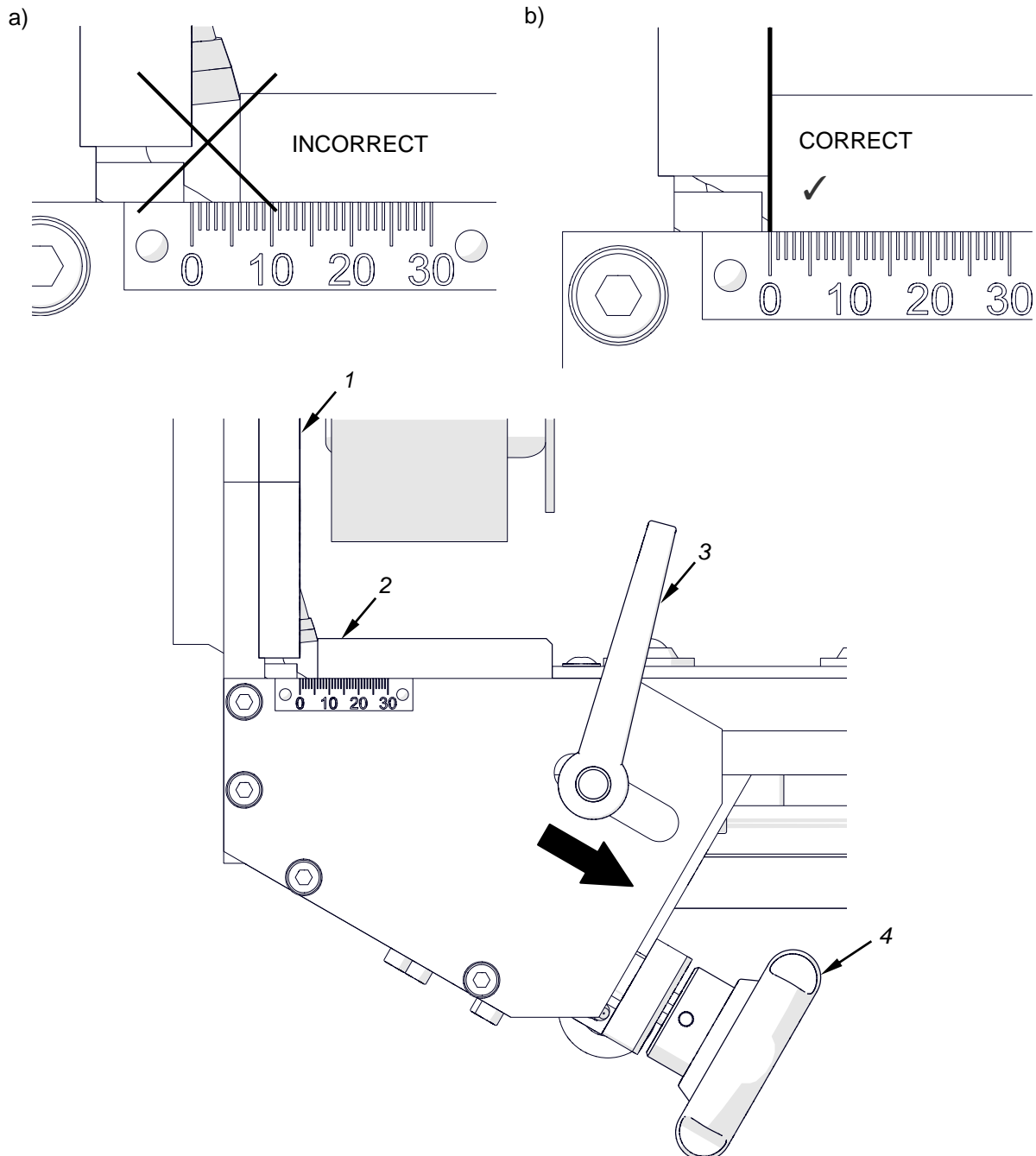
Move the table forward so that it makes contact with the bolt 1 (Fig. 5), and then use the lever 2 to lock the table in this position. Next, use the handle 3 to rotate the feed unit so that the screw makes contact with the bumper (4).



**Fig. 5.** Moving the table and lowering the feed unit

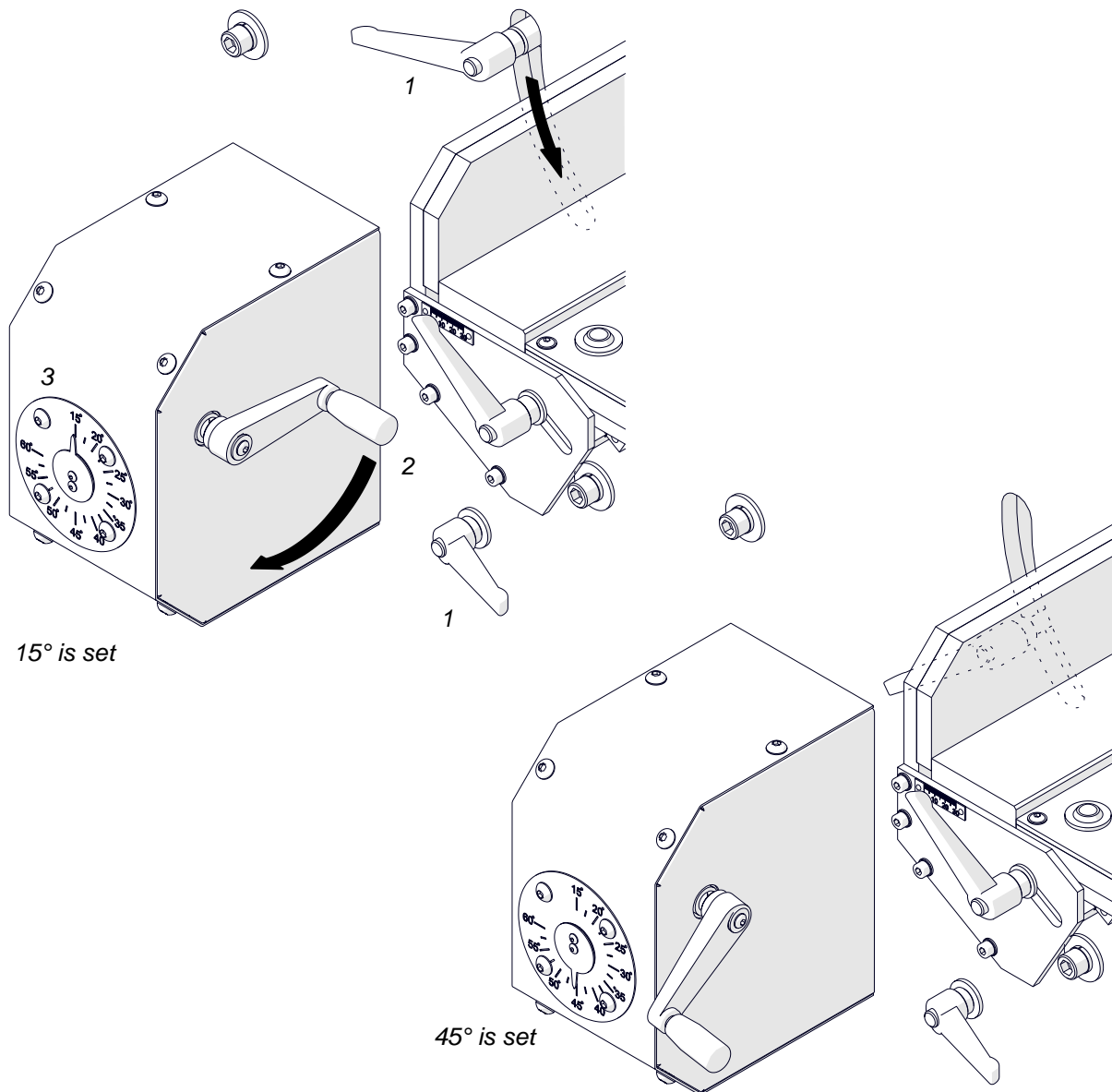
### 3.3. Setting the bevel angle and milling head penetration

Start with penetration of the milling head set to zero. If there is a gap between the vertical base 1 and horizontal base 2 (Fig. 6a), unlock the lever 3 and rotate the knob 4 so that the vertical base comes in contact with the horizontal base (Fig. 6b), and then lock the lever in this position.



**Fig. 6.** Setting the milling head penetration to zero: incorrect (a), correct (b)

To set the bevel angle (Fig. 7), unlock the levers 1, use the crank 2 to rotate the milling unit so that the scale 3 shows the required angle, and then lock the levers in this position.

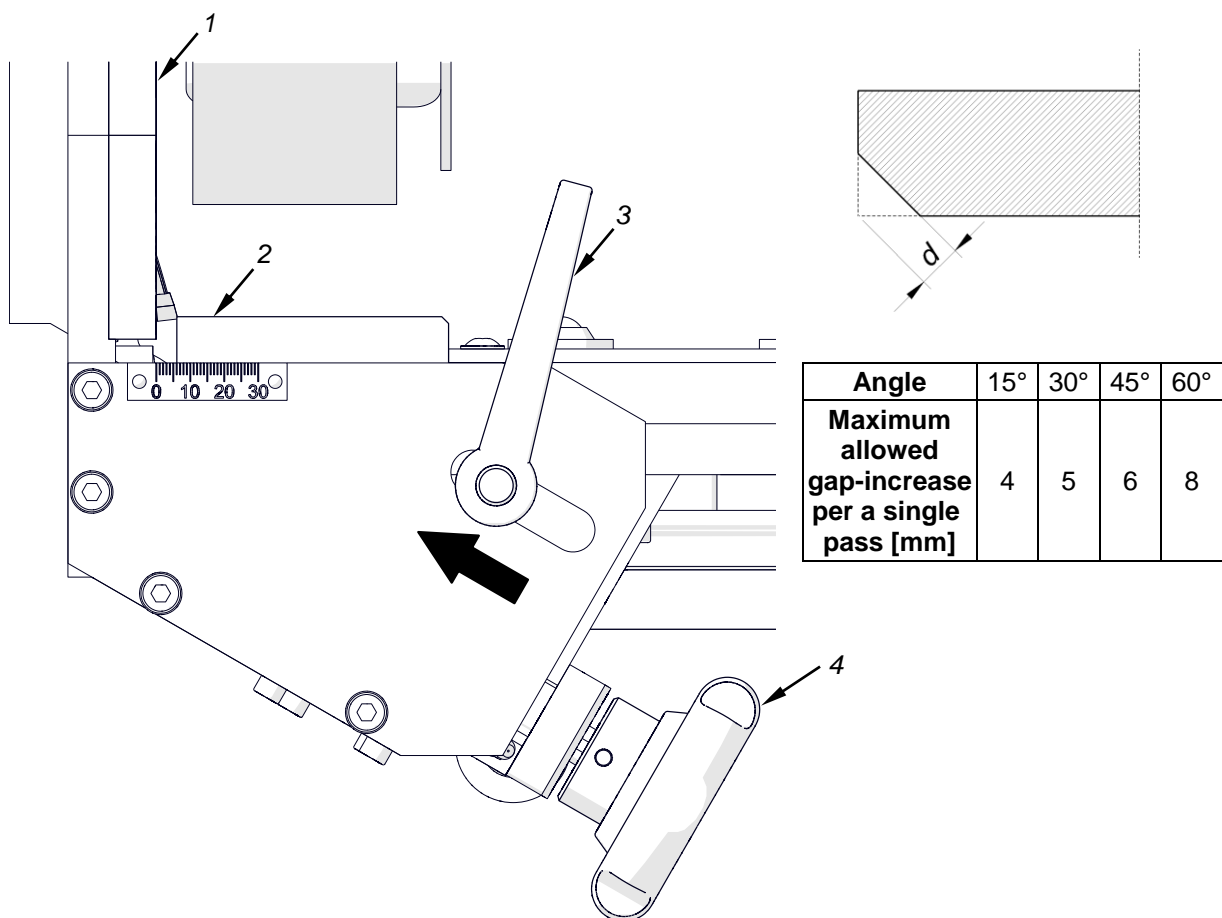


**Fig. 7.** Setting the bevel angle

Before the first pass, move the vertical base 1 away from horizontal base 2 (Fig. 8). To do this, unlock the lever 3, and then use the knob 4 to obtain a gap proper for a single pass. Next, make sure that the vertical base is not in contact with the milling head, and then lock the lever in this position.



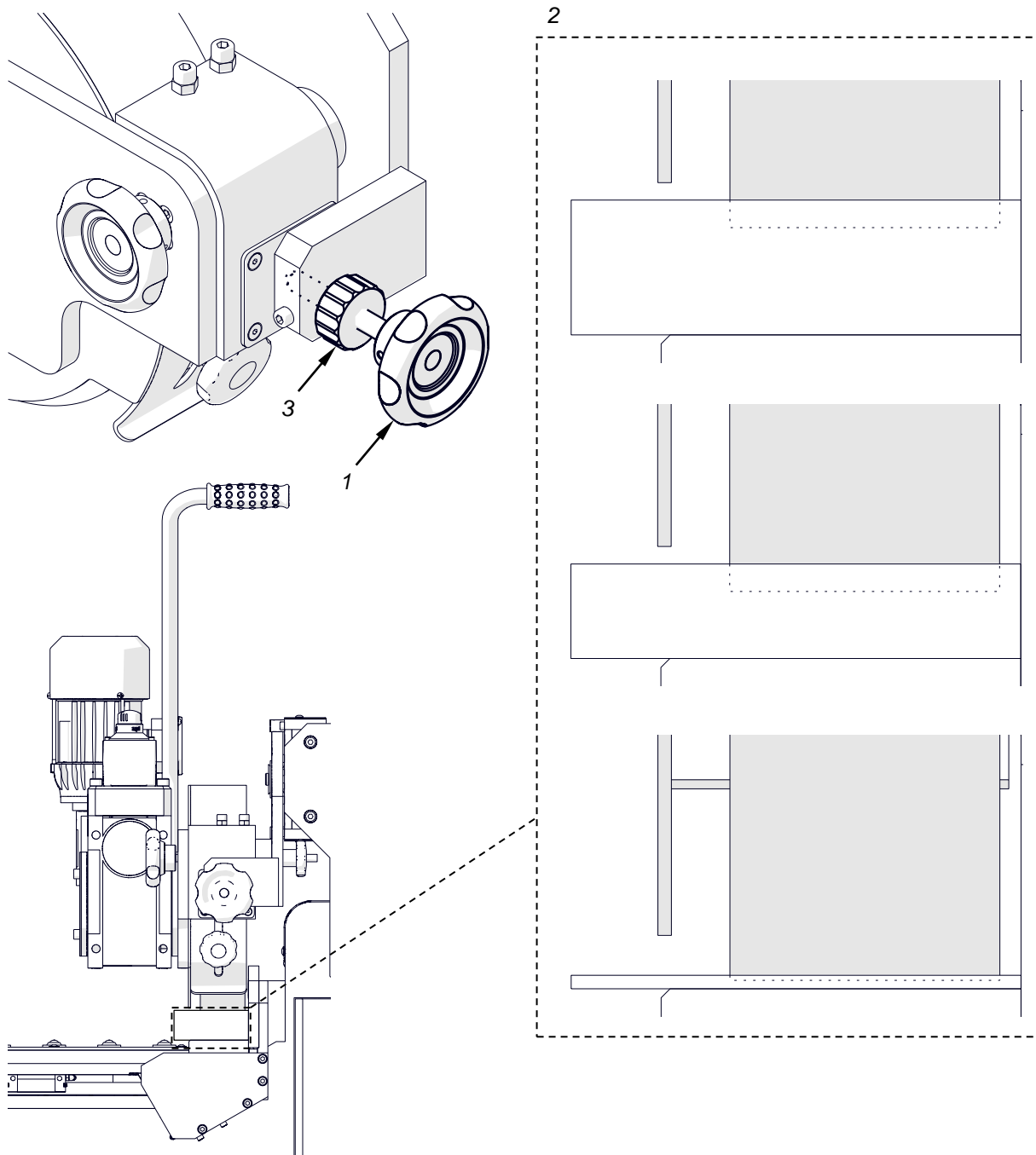
If the vertical base is moved away too far, it may come in contact with the milling head and thus damage the machine. Never exceed 4 mm (5/32") of the milling head penetration  $d$  (Fig. 8) per a single pass. The table shows how far you can move the vertical base per a single pass not to exceed the penetration  $d$  of 4 mm.



**Fig. 8.** Setting the milling head penetration before the first pass

### 3.4. Setting the feed wheel height

Use the knob 1 (Fig. 9) to set the feed wheel at such a height so that the workpiece is firmly pressed to the horizontal base (2) during rotation of the feed wheel. Then, use the nut 3 to lock the knob in this position.

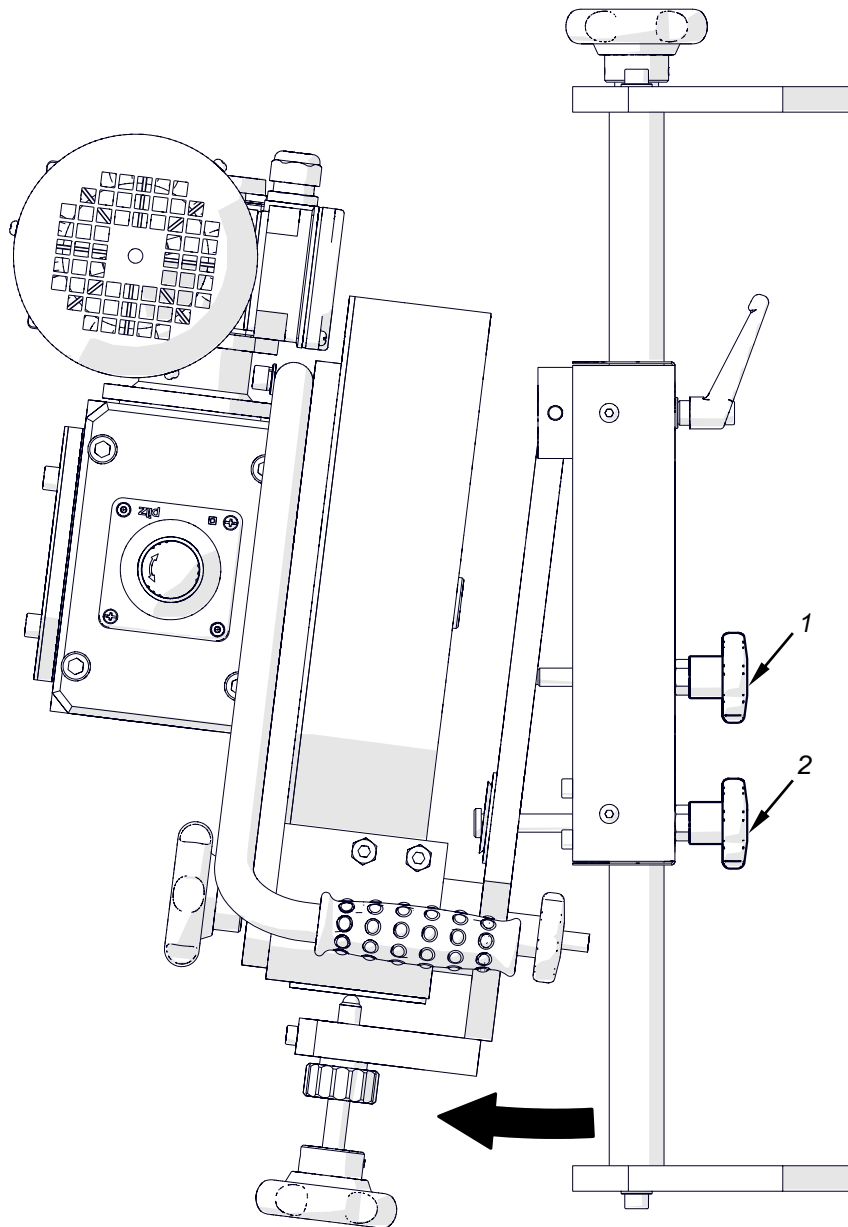


**Fig. 9.** Setting the feed wheel height



### 3.5. Tilting the feed unit

To ensure that the workpiece is sufficiently pressed to the vertical base, use the knobs 1 and 2 (Fig. 10) to tilt the feed unit. Do this when milling narrow workpieces or after moving the vertical base away from the horizontal base.



**Fig. 10.** Tilting the feed unit

Then, adjust the feed wheel.

### 3.6. Adjusting the feed wheel

Loosen the knob 1 and lever 2 (Fig. 11), and then use the knobs 3 and 4 to move the feed unit so that (5) the wheel comes as close to the milling spot as possible (6). Next, lock the knob 1 and lever 2 in this position. Pay close attention to prevent the feed wheel or its cover from coming in contact with the milling head or vertical base.

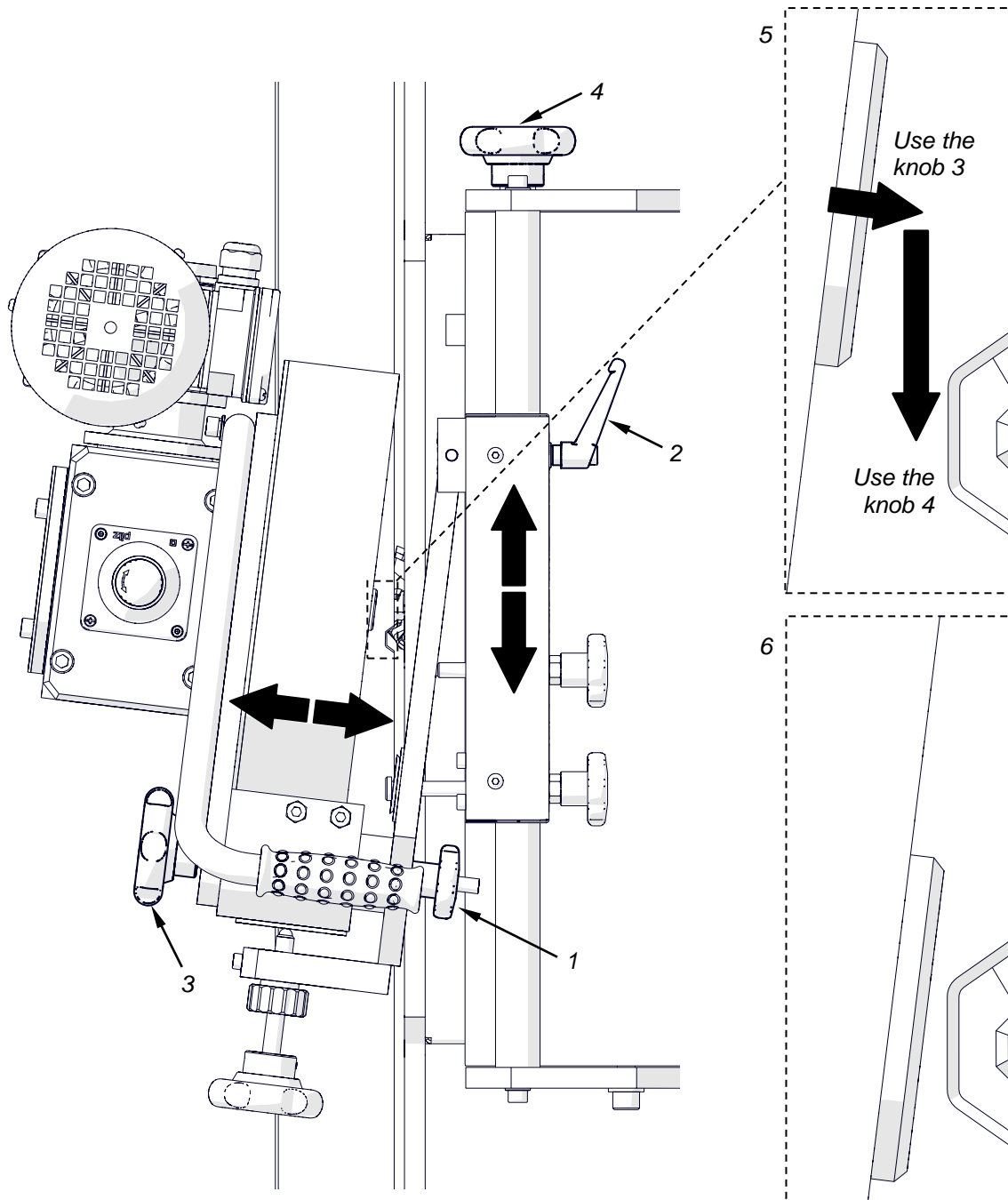
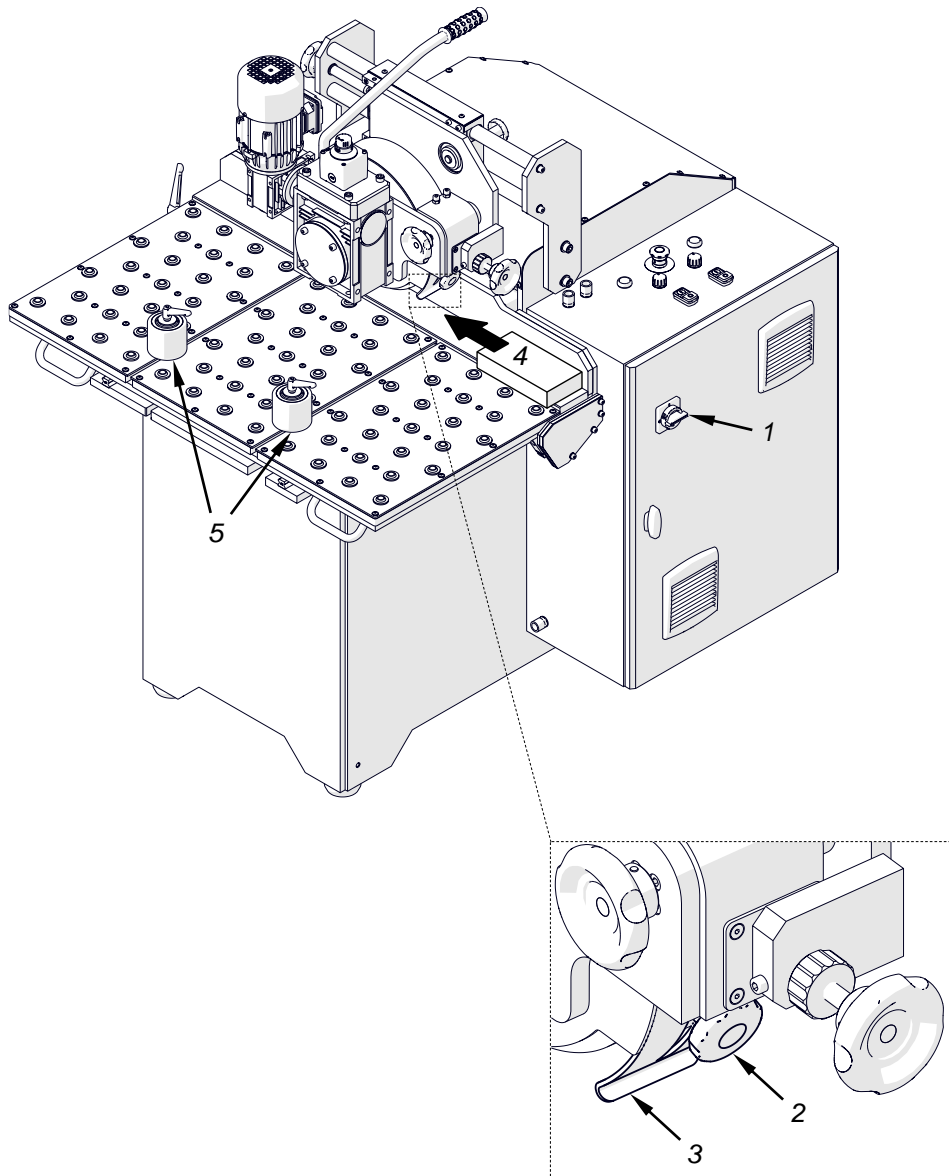


Fig. 11. Adjusting the feed wheel

### 3.7. Operating

Connect the machine to the power source and use the switch 1 (Fig. 12) to turn on the power. On the control panel, press START, and then start the SPINDLE and FEED. Use knobs to set the required spindle speed and feed speed. Next, loosen the knob 2 (Fig. 12), lower the chip guard 3, and then tighten the knob in this position.



**Fig. 12.** Starting the work

Place the workpiece on the right side, and then press the workpiece to the vertical and horizontal base and move it to the direction 4 (Fig. 12) to put it under the feed wheel. After the first pass, move the vertical base away so that a gap proper for the next pass is obtained, and then make sure that the vertical base is not in contact with the milling head.



**If the vertical base is moved away too far, it may come in contact with the milling head and thus damage the machine. Never exceed 4 mm (5/32'') of the milling head penetration  $d$  (Fig. 8) per a single pass. The table (Fig. 8) shows how far you can move the vertical base per a single pass not to exceed the penetration  $d$  of 4 mm.**

To obtain better contact between the workpiece and the vertical base, you may use the rollers 5 (Fig. 12) to press the workpiece.

Make several passes to obtain the required bevel parameters. Never move the vertical base away so that the gap is larger than specified in the following table.

Angle	15°	20°	25°	30°	35°	40°	45°	50°	55°	60°
Maximum allowed gap	9 mm	11 mm	14 mm	16 mm	18 mm	20 mm	22 mm	24 mm	25 mm	27 mm

If the maximum allowed motor load is exceeded, the OVERLOAD button will light. When this happens, lower the feed speed. If you continue operating when the motor is overloaded, the safety circuit will shut down the motor. To restart the machine in such a case, raise the feed unit, remove the workpiece, press the OVERLOAD, and then press START.

In an emergency, press any EMERGENCY switch. To restart the machine in such a case, unlock the switch and press START.

If the table is moved backward during work, the machine will be shut down. To restart the operation, move the table forward as far as possible and press START.

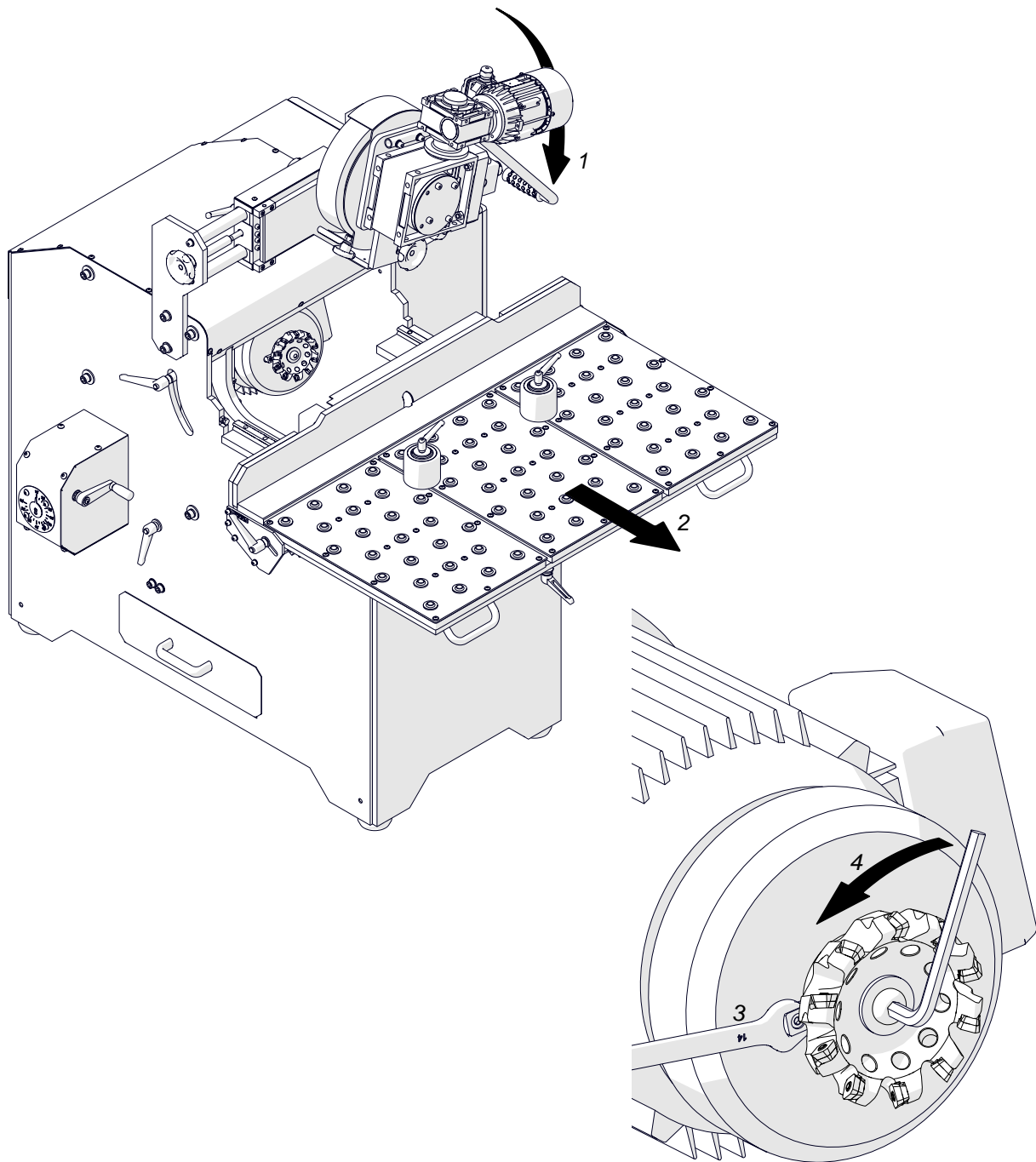
Set the angle as described before only when the machine is unplugged from the power source. Always start from penetration of the milling head set to zero. If needed, tilt the feed unit and adjust the feed wheel.

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

### 3.8. Removing and installing the milling head

Unplug the machine from the power source, raise the feed unit (1, Fig. 13), and move the table backward (2) to access the milling head. Use a 14 mm flat wrench to lock the spindle rotation (3), and then use the 8 mm hex wrench to unscrew the milling head (4).

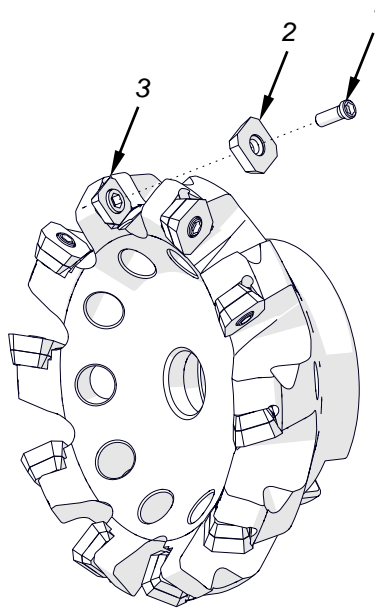
To install, place the milling head on the spindle, lock the spindle rotation, and then use the removed screw and washer to tighten the milling head.



**Fig. 13.** Removing the milling head

### 3.9. Replacing the cutting inserts

Remove the milling head as described before, use the supplied screwdriver to unscrew the fixing screw (1, Fig. 14), and then remove the cutting insert (2) and clean the shim (3). Rotate the cutting insert by 90° and reinstall it or replace with a new insert if all four edges are worn. Press the cutting insert so that its bottom is in full contact with the shim, and then tighten with the fixing screw.



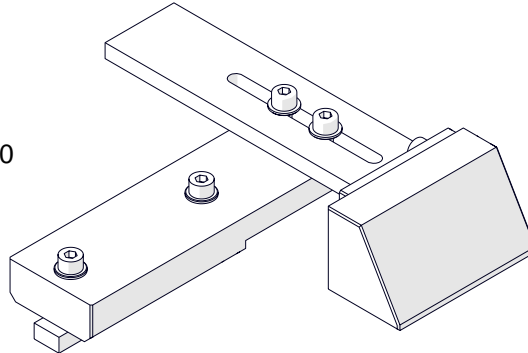
**Fig. 14.** Replacing the cutting inserts

## 4. ACCESSORIES

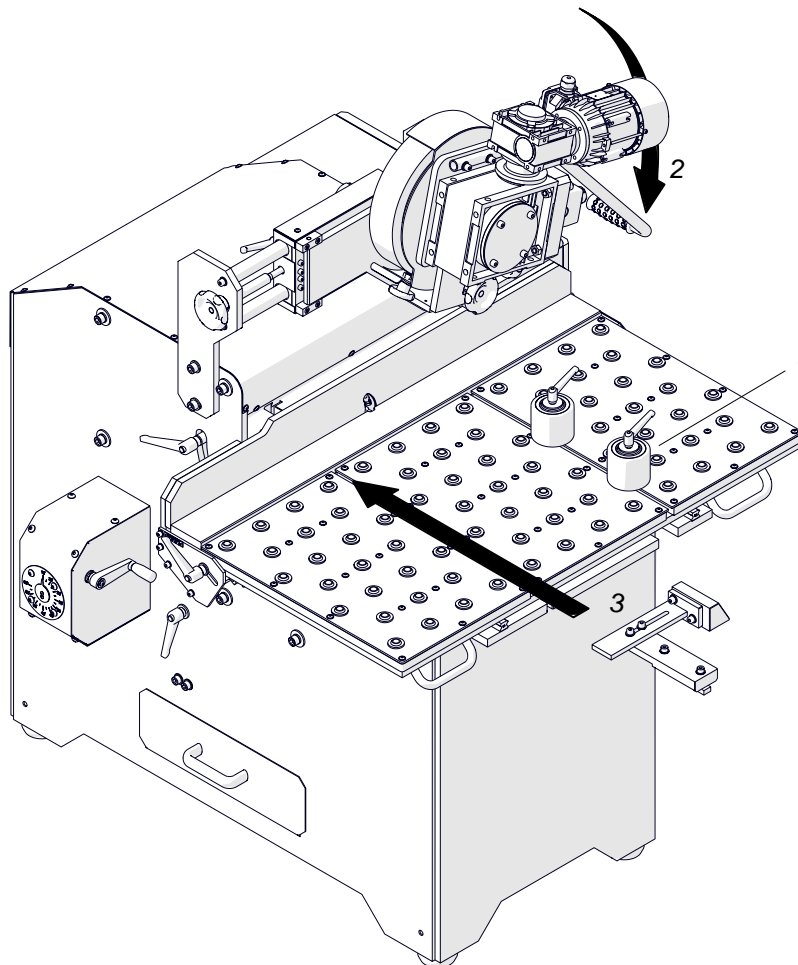
### 4.1. Pipe attachment

Allows the machine to bevel pipes with outer diameters of 50–150 mm (2–6”).

Part number:  
PRK-0573-36-00-00-0

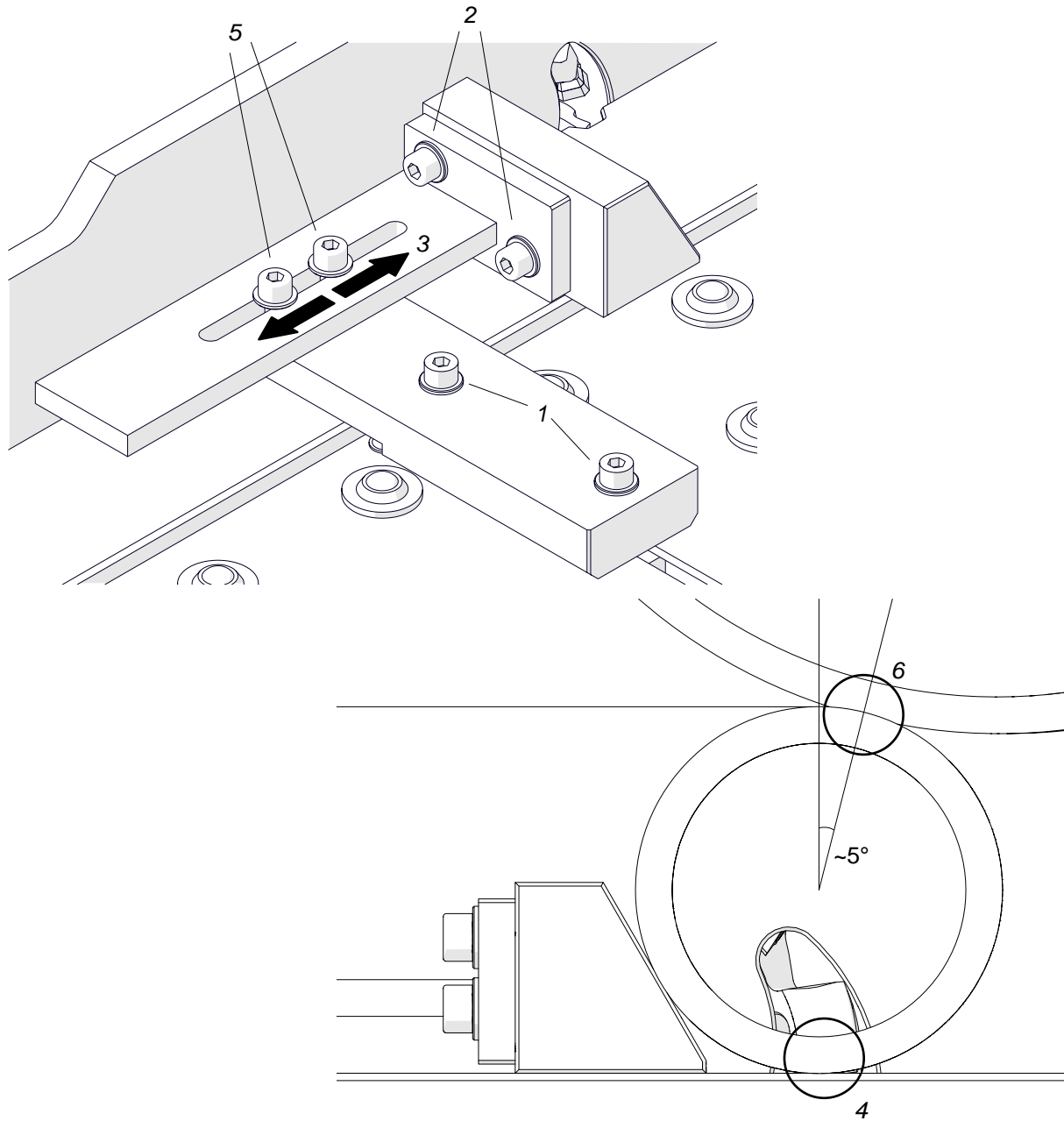


To install the attachment, set the milling head penetration to zero (Fig. 6b), move the roller from the left groove to right groove (1, Fig. 15), and then raise the feed unit (2) and slide the attachment into the left groove (3).



**Fig. 15.** Installing the pipe attachment

Make sure that the attachment is in contact with the vertical base and horizontal base, and then use the 6 mm hex wrench to tighten the screws 1 and 2 (Fig. 16). Next, adjust the attachment so that (3) the bottom of the pipe is as close to the milling spot as possible (4) and tighten the screws 5.

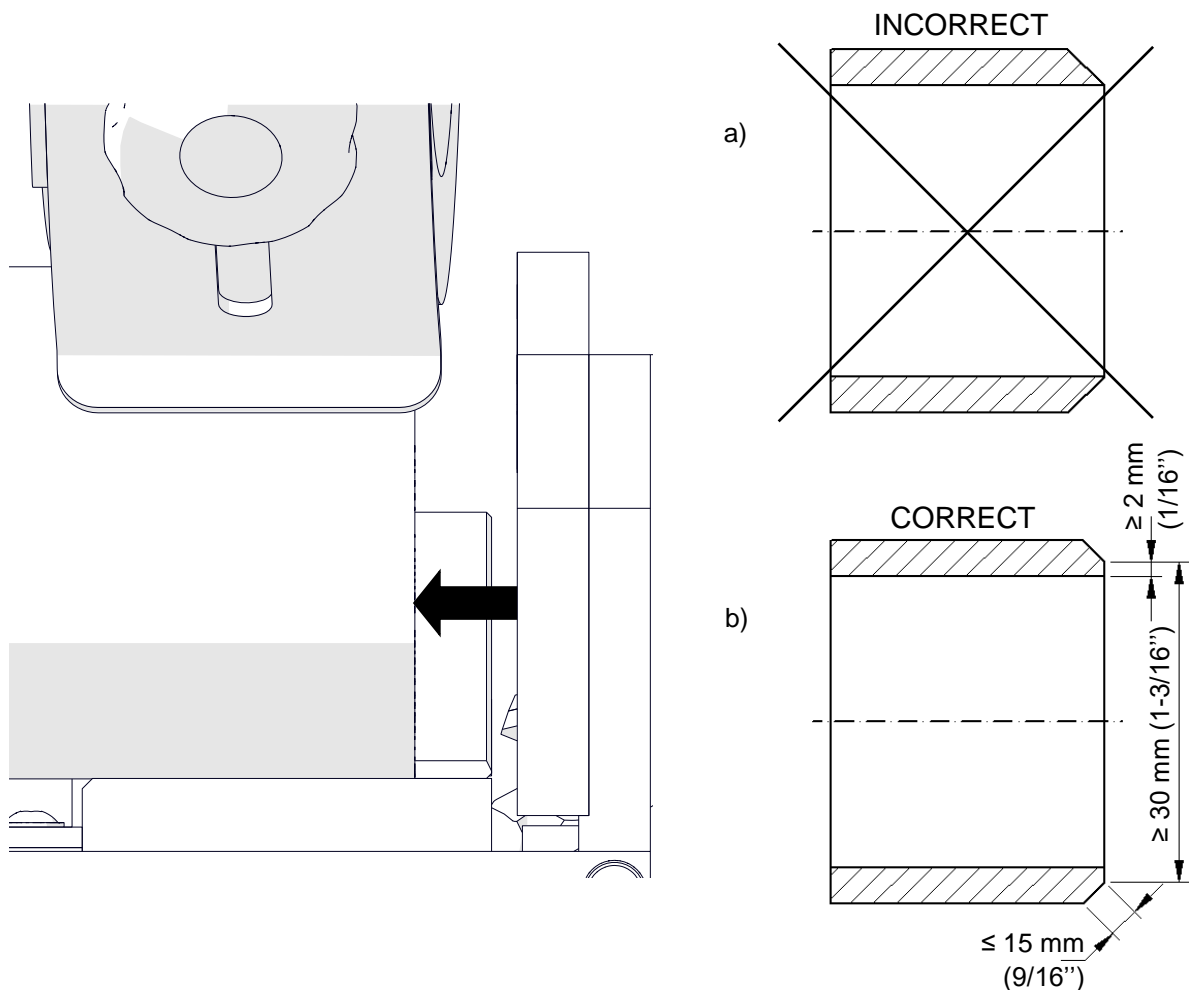


**Fig. 16.** Adjusting the attachment

Set the required bevel angle and milling head penetration (Fig. 6, 7, 8), and tilt the feed unit by about  $2^\circ$  (Fig. 10). Next, set the height feed wheel height and adjust the wheel (Fig. 9, 11) so that the pipe is pressed to the attachment and horizontal base when the feed wheel rotates (6, Fig. 16).



Before starting the machine, move the pipe away from the milling head (Fig. 17). Never make bevels without a root face (Fig. 17a). The root face must be at least 2 mm (1/16", Fig. 17b), and the bevel width must never be more than 15 mm (9/16").



**Fig. 17.** Placing the pipe

After the machine starts, the feed wheel moves the pipe toward the milling head.

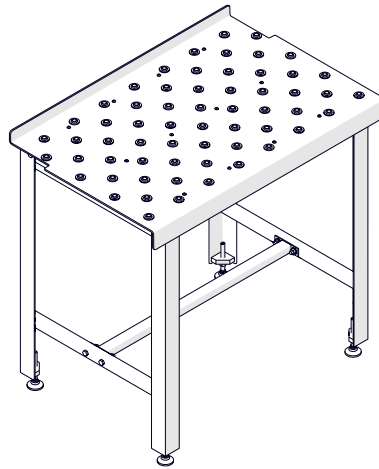
## 4.2. Cutting tools

Part number	Part name
PLY-000396	Cutting insert for steel (10 required, sold 10 per box)
PLY-000408	Cutting insert for aluminum (10 required, sold 10 per box)

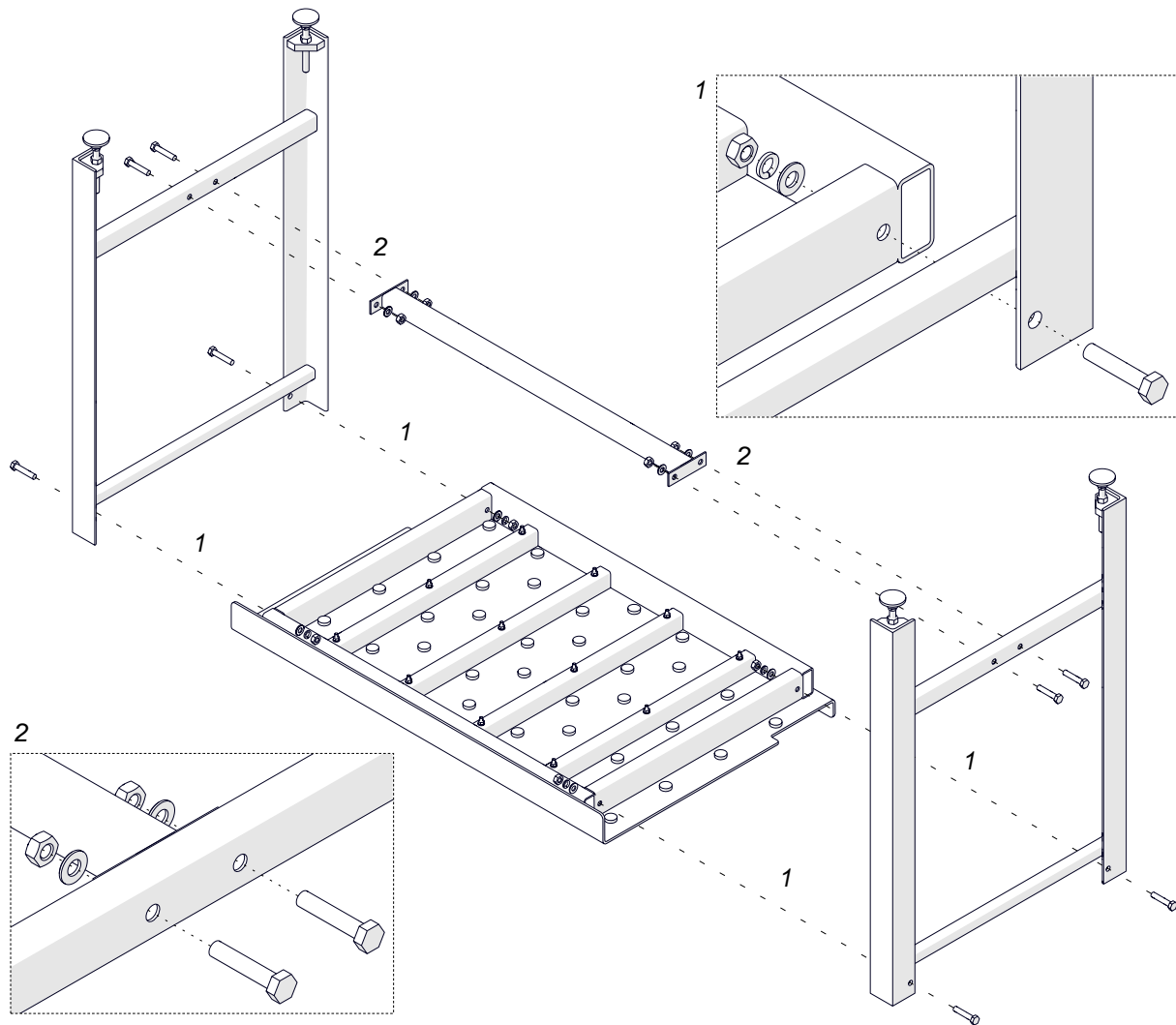
### 4.3. Table

Allows the machine to bevel longer plates.

Part number:  
STL-0573-37-00-00-0

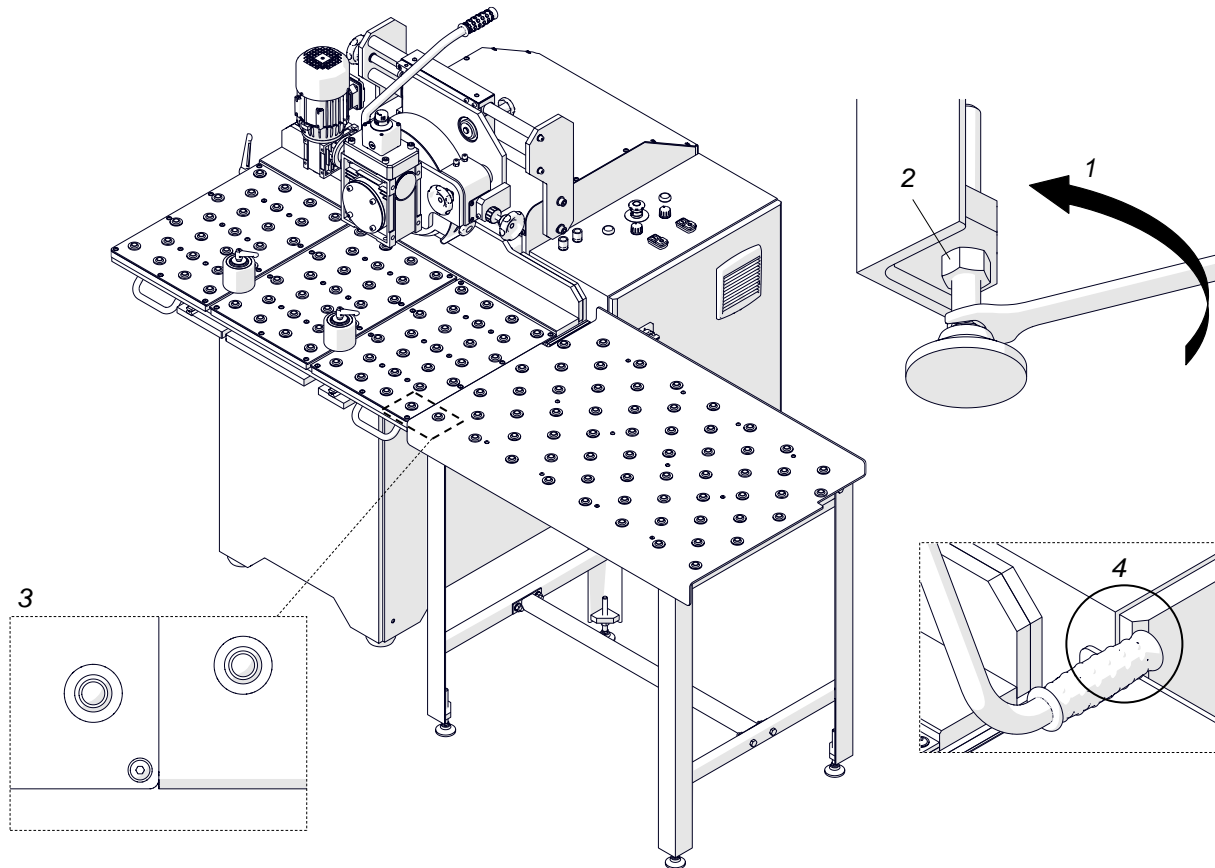


To assemble the table, place it upside down (Fig. 18). Use the 16 mm and 17 mm flat wrenches to attach the legs (1) and bracket (2).



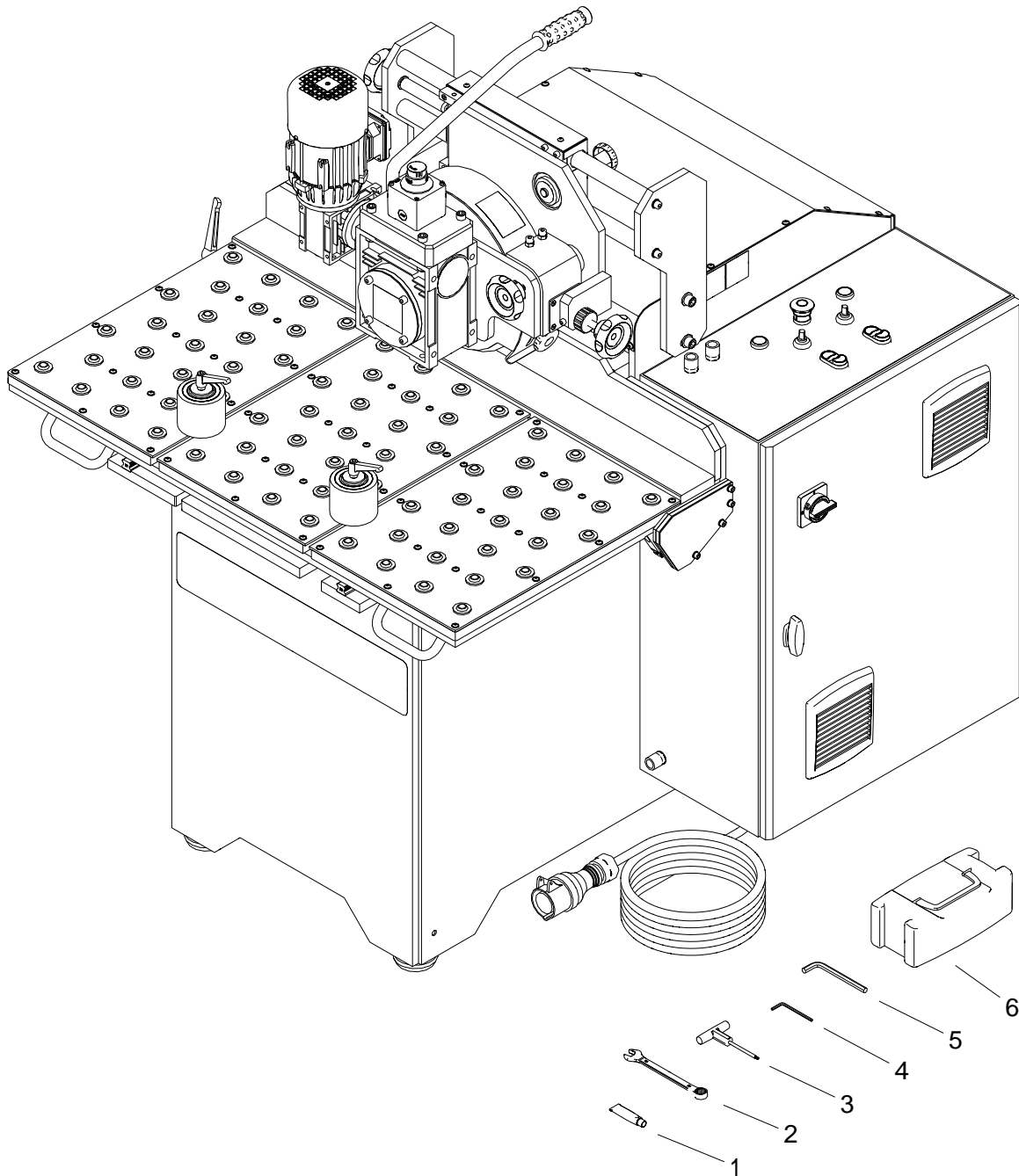
**Fig. 18.** Assembling the table

Use the 14 mm flat wrench to rotate the feet (1, Fig. 18) so that the height of the tables is the same. Next, use the 18 mm flat wrench to tighten the nuts (2) to lock the feet in this position, and then align the faces of the tables (3). Be careful not to catch your hands between the handle and table (4).

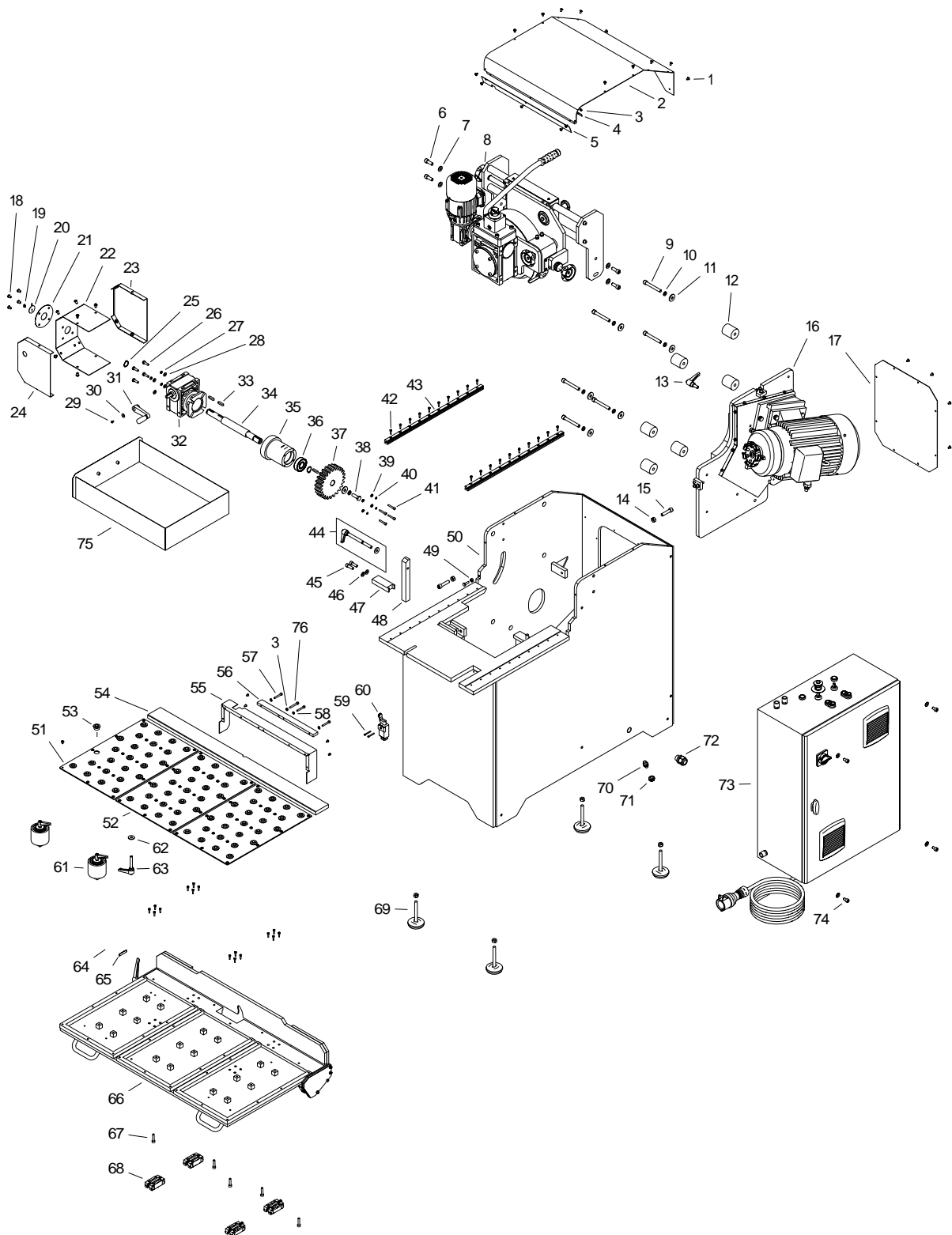


**Fig. 19.** Using the table

## 5. EXPLODED VIEWS AND PARTS LIST



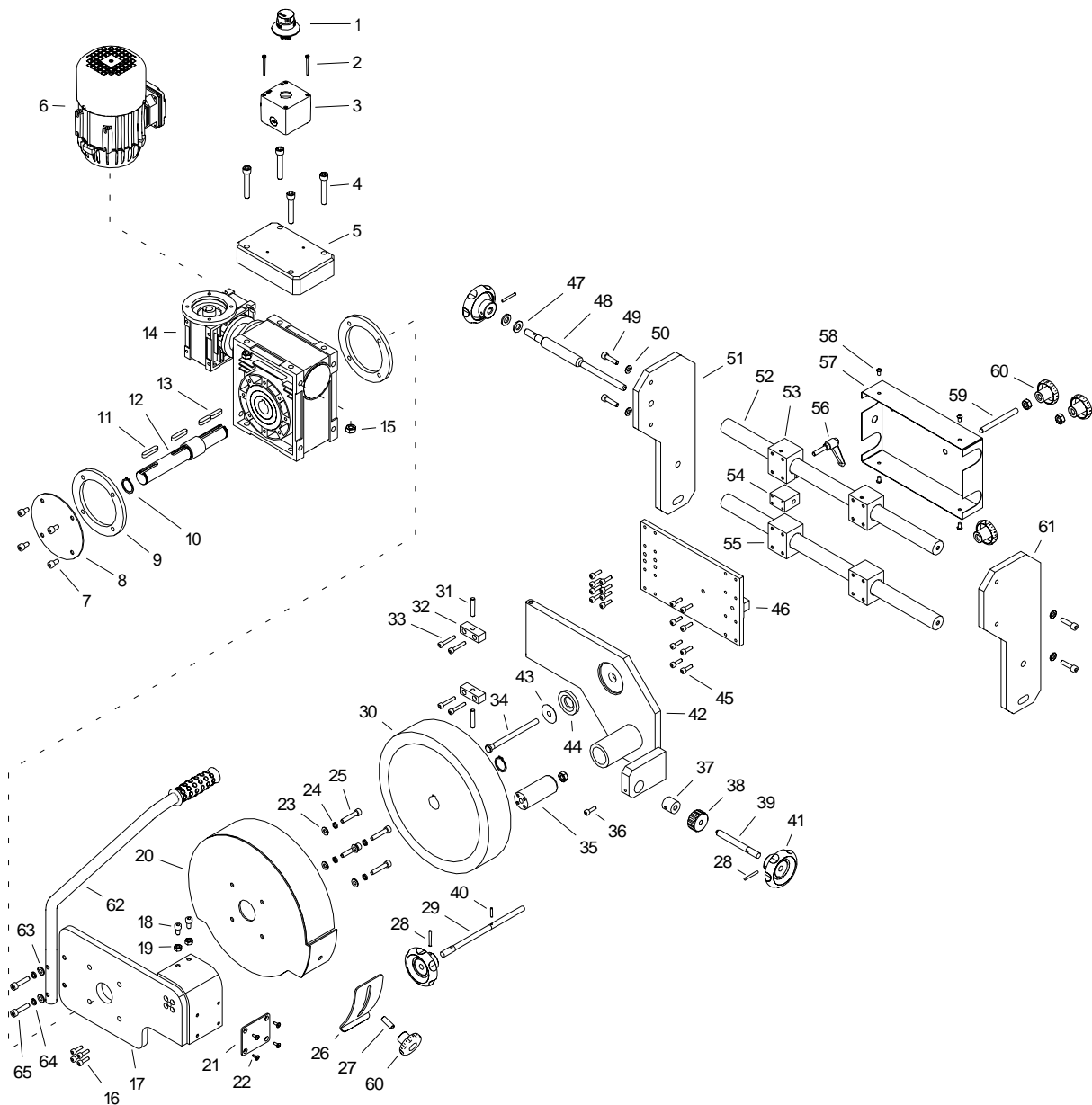
ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	SMR-000005	GREASE FOR SCREWS 5g	1
2	KLC-000061	14 MM COMBINATION WRENCH	1
3	KLC-000066	T15 WRENCH WITH HANDLE	1
4	KLC-000065	3.5 MM HEX WRENCH	1
5	KLC-000011	8 MM HEX WRENCH	1
6	PJM-000010	TOOL CONTAINER	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	WKR-000336	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M6x10	68
2	OSL-0573-16-00-00-0	TOP COVER	1
3	NKR-000017	HEX NUT M6	4
4	DCS-0573-26-00-00-0	SILICONE PLATE HOLDER	1
5	OSL-0573-25-00-00-0	SILICONE COVER	1

ITEM	PART NUMBER	DESCRIPTION	Q-TY
6	SRB-000053	HEX SOCKET HEAD CAP SCREW M12x30	4
7	PDK-000118	ROUND WASHER 13	4
8	ZSP-0573-04-00-00-0	FEED ASSY	1
9	SRB-000241	HEX SOCKET HEAD CAP SCREW M12x90	6
10	PDK-000053	SPRING WASHER 12.2	7
11	PDK-000103	ROUND WASHER 13	7
12	WSP-0573-12-00-00-0	FEED ASSY SUPPORT	6
13	RKJ-000056	HANDLEVER M12-25	1
14	NKR-000003	HEX NUT M12	8
15	SRB-000214	HEX SOCKET HEAD CAP SCREW M12x50	4
16	ZSP-0573-02-00-00-0	MILLING SET ASSY	1
17	PKR-0573-07-00-00-0	COVER	1
18	WKR-000366	HEX SOCKET BUTTON HEAD SCREW M8x12	12
19	WKR-000292	HEX SOCKET BUTTON HEAD SCREW M4x6	2
20	WSK-0573-19-00-00-0	INDICATOR	1
21	TRC-0573-18-00-00-0	ANGLE PLATE	1
22	OSL-0573-21-00-00-0	GEARBOX COVER	1
23	OSL-0573-22-00-00-0	LEFT GEARBOX COVER ASSY	1
24	OSL-0573-23-00-00-0	RIGHT GEARBOX COVER ASSY	1
25	PRS-000017	EXTERNAL RETAINING RING 25z	2
26	SRB-000028	FULL THREAD HEX HEAD SCREW M8x25	5
27	PDK-000051	SPRING WASHER 8.2	4
28	PDK-000022	ROUND WASHER 8.4	4
29	WKR-000058	HEX SOCKET SET SCREW WITH FLAT POINT M6x8	5
30	PDK-000037	ROUND WASHER 6.5	1
31	KBA-0573-17-00-00-0	WINCH ASSY	1
32	RDK-000010	WORM GEARBOX	1
33	WPS-000086	PARALLEL KEY 8x7x32	3
34	WLK-0573-14-00-00-0	SHAFT	1
35	OPR-0573-13-00-00-0	BEARING HOLDER	1
36	LOZ-000150	BALL BEARING 25x62x17	1
37	KOL-0573-15-00-00-0	GEAR z24	1
38	SRB-000195	FULL THREAD HEX HEAD SCREW M12x35	1
39	PDK-000021	ROUND WASHER 6.4	6
40	PDK-000046	SPRING WASHER 6.1	4
41	SRB-000123	HEX SOCKET HEAD CAP SCREW M6x35	4
42	SRB-000083	HEX SOCKET HEAD CAP SCREW M5x16	36
43	SNA-000041	GUIDE	2
44	SRB-0573-29-00-00-0	LOCKING BOLT ASSY	1
45	SRB-000047	HEX SOCKET HEAD CAP SCREW M10x30	2
46	PDK-000026	ROUND WASHER 10.5	6
47	WSP-0573-28-00-00-0	CLAMPING BLOCK SUPPORT	1
48	LPA-0573-27-00-00-0	CLAMPING BLOCK	1
49	NKR-000019	HEX NUT M8	1
50	KRP-0573-01-00-00-0	FRAME	1
51	OSL-0573-10-00-00-0	SIDE TABLE COVER	2
52	OSL-0573-11-00-00-0	CENTER TABLE COVER	1
53	RLK-000002	ROLLER	75
54	BZA-0573-08-00-00-0	HORIZONTAL BASE PLATE	1
55	OSL-0573-24-00-00-0	INTERNAL COVER	1
56	WSP-0573-30-00-00-0	VERTICAL BASE PLATE SUPPORT	1

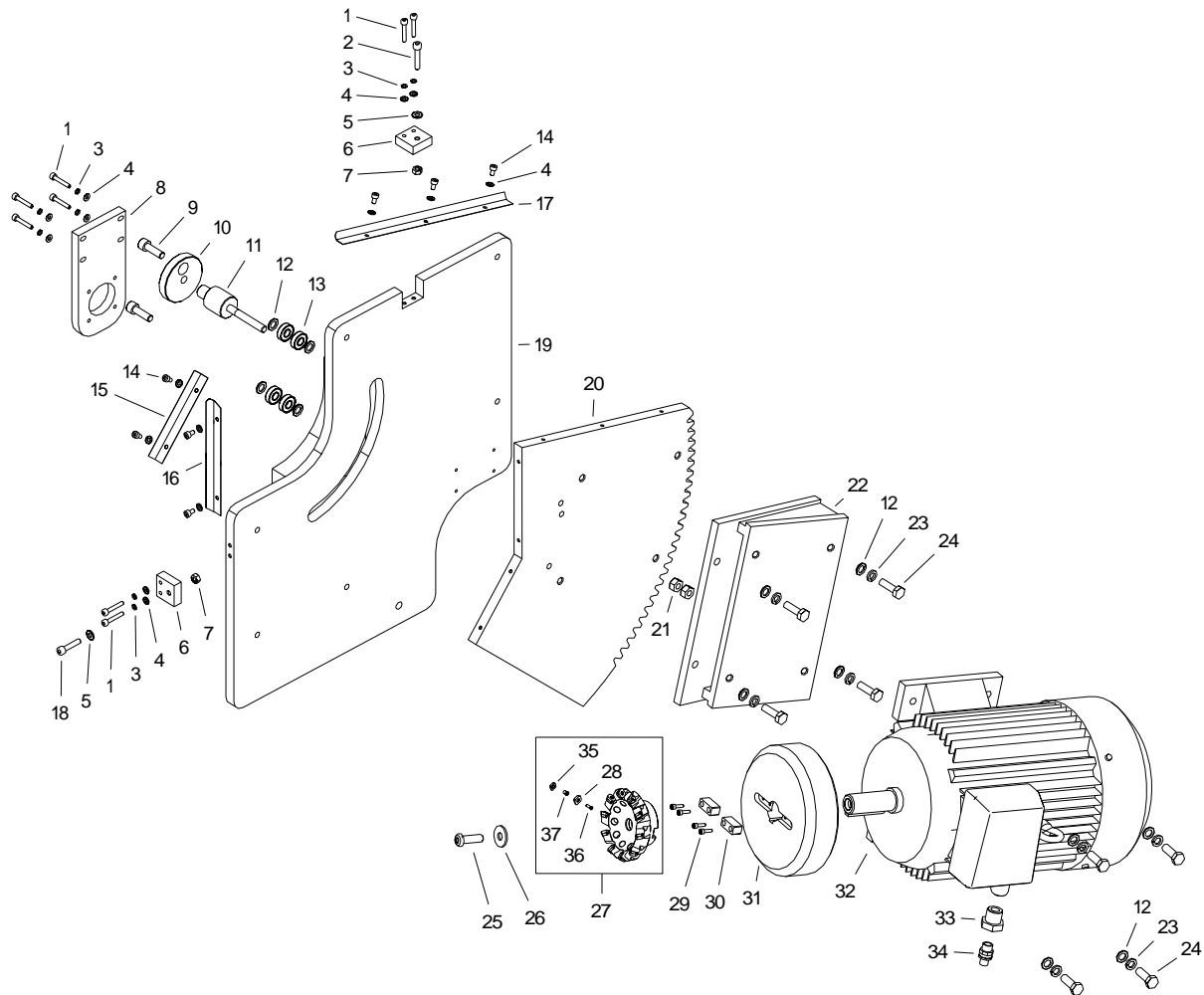
ITEM	PART NUMBER	DESCRIPTION	Q-TY
57	SRB-000124	HEX SOCKET HEAD CAP SCREW M6x40	3
58	NKR-000035	LOW HEX NUT M6	1
59	WKR-000452	CROSS RECESSED PAN HEAD SCREW M4x35	2
60	LCZ-000037	LIMIT SWITCH	1
61	RLK-0573-20-00-00-0	ROLLER ASSY	2
62	PDK-000109	ROUND WASHER 10.5	1
63	RKJ-000052	HANDLEVER M10-63	1
64	NIT-000010	RIVET 2x6	2
65	LNL-0573-09-00-00-0	STRAIGHTEDGE	1
66	STL-0573-03-00-00-0	TABLE ASSY	1
67	SRB-000156	HEX SOCKET HEAD CAP SCREW M8x35	5
68	PRW-000068	CARRIAGE	4
69	STP-000002	BRACKET D75	4
70	ZLC-000160	CABLE GLAND	1
71	NKR-000084	LOW HEX NUT M16x1.5	1
72	ZLC-000153	CABLE GLAND	1
73	SZF-0573-05-00-00-0	CONTROL BOX ASSY	1
74	SRB-000044	HEX SOCKET HEAD CAP SCREW M10x16	4
75	ZBN-0573-06-00-00-0	CHIP CONTAINER ASSY	1
76	SRB-000126	HEX SOCKET HEAD CAP SCREW M6x45	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PRC-000029	EMERGENCY SWITCH	1
2	SRB-000067	HEX SOCKET HEAD CAP SCREW M4x40	2
3	PSZ-000005	JUNCTION BOX	1
4	SRB-000051	HEX SOCKET HEAD CAP SCREW M10x60	4
5	OBC-0573-04-19-00-0	WEIGHT	1
6	SLN-000206	MOTOR	1
7	SRB-000141	HEX SOCKET HEAD CAP SCREW M8x14	4
8	OSL-0573-04-22-00-0	GEARBOX COVER	1
9	DYS-0573-04-21-00-0	GEARBOX COVER RING	2
10	PRS-000019	EXTERNAL RETAINING RING 28z	2
11	WPS-000045	KEY 8x7x40	2
12	WLK-0573-04-16-00-0	SHAFT	1
13	WPS-000077	KEY 8x7x30	2
14	RDK-000016	GEARBOX	1
15	NKR-000002	NUT M10	7

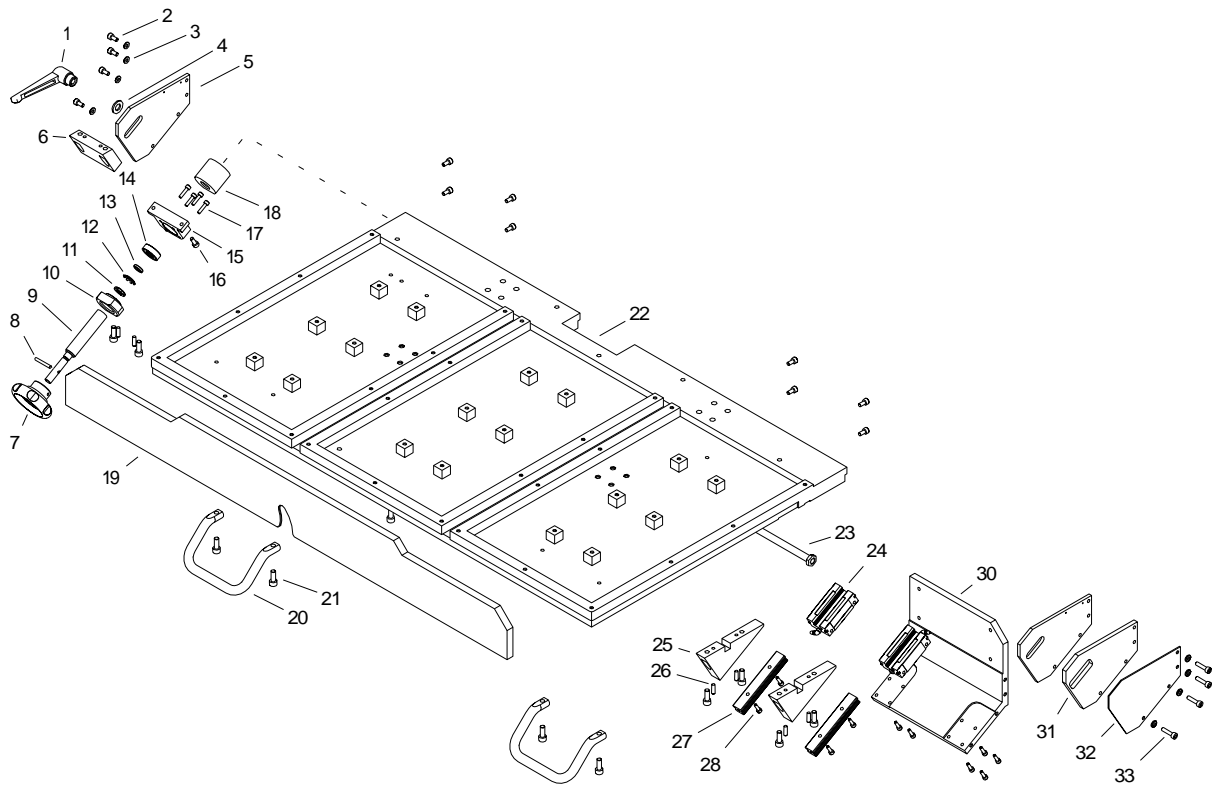


ITEM	PART NUMBER	DESCRIPTION	Q-TY
16	SRB-000114	HEX SOCKET HEAD CAP SCREW M6x20	4
17	PLY-0573-04-08-00-0	GEARBOX PLATE ASSY	1
18	SRB-000141	HEX SOCKET HEAD CAP SCREW M8x14	2
19	NKR-000019	HEX NUT M8	2
20	OSL-0573-04-24-00-0	WHEEL COVER ASSY	1
21	BLC-0573-04-27-00-0	PLATE	1
22	WKR-000134	HEX SOCKET COUNTERSUNK HEAD SCREW M5x12	4
23	PDK-000022	ROUND WASHER 8.4	4
24	PDK-000051	SPRING WASHER 8.2	4
25	SRB-000157	HEX SOCKET HEAD CAP SCREW M8x40	4
26	PON-0573-04-25-00-0	COVER LOCKING PLATE	1
27	PRT-0573-04-26-01-0	WHEEL COVER ROD	1
28	KLK-000111	DOWEL PIN 5n6x36	3
29	SRB-0573-04-13-00-0	DEPTH SETTING BOLT	1
30	KOL-0573-04-30-00-0	WHEEL	1
31	KLK-000073	DOWEL PIN 8n6x40	2
32	WSP-0573-04-18-00-0	ANGLE SETTING PLATE SUPPORT	2
33	SRB-000123	HEX SOCKET HEAD CAP SCREW M6x35	4
34	SRB-0573-04-12-00-0	ANGLE LOCKING BOLT	1
35	WLK-0573-04-10-00-0	SHAFT	1
36	SRB-000114	HEX SOCKET HEAD CAP SCREW M6x20	1
37	NKR-0573-04-23-00-0	NUT	1
38	NKR-0573-04-20-00-0	PLASTIC NUT	1
39	SRB-0573-04-15-00-0	WHEEL HEIGHT SETTING BOLT	1
40	KLK-000014	SPRING PIN 4x20	1
41	PKT-0573-03-08-00-0	KNOB	3
42	PLY-0573-04-09-00-0	ANGLE SETTING PLATE ASSY	1
43	TRC-573-04-06-00-0	CAP	1
44	PDK-0573-04-07-00-0	SPHERICAL WASHER	1
45	SRB-000114	HEX SOCKET HEAD CAP SCREW M6x20	16
46	PLY-0573-04-05-00-1	PLATE ASSY	1
47	PDK-000118	ROUND WASHER 13	2
48	SRB-0573-04-28-00-0	BOLT	1
49	SRB-000155	HEX SOCKET HEAD CAP SCREW M8x30	4
50	PDK-000022	ROUND WASHER 8.4	4
51	WSP-0573-04-31-00-0	LEFT SUPPORT PLATE	1
52	PRT-0573-04-02-00-0	FEED SHAFT	2
53	MCW-0573-04-04-00-0	MOUNTING BLOCK - LOCK	1
54	NKR-0573-04-32-00-0	NUT	1
55	MCW-0573-04-03-00-0	MOUNTING BLOCK	3
56	RKJ-000013	HANDLEVER M8-32	1
57	OSL-0573-04-17-00-0	COVER	1
58	WKR-000100	HEX SOCKET BUTTON HEAD SCREW M6x10	4
59	SRB-0573-04-14-00-0	ANGLE SETTING BOLT	1
60	PKT-000032	KNOB D50	4
61	WSP-0573-04-01-00-0	SUPPORT PLATE	1
62	RKJ-0573-04-33-00-0	LEVER ASSY	1
63	PDK-000022	ROUND WASHER 8.4	2
64	PDK-000051	SPRING WASHER 8.2	2
65	SRB-000156	HEX SOCKET HEAD CAP SCREW M8x35	2
66	KBL-0573-04-34-00-0	FEED MOTOR CABLE	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	SRB-000123	HEX SOCKET HEAD CAP SCREW M6x35	8
2	SRB-000157	HEX SOCKET HEAD CAP SCREW M8x40	1
3	PDK-000046	SPRING WASHER 6.1	8
4	PDK-000021	ROUND WASHER 6.4	15
5	PDK-000022	ROUND WASHER 8.4	2
6	BLD-0573-02-12-00-0	ANGLE LOCK PLATE	2
7	NKR-000019	HEX NUT M8	2
8	WSP-0573-02-07-00-0	GEAR SUPPORT	1
9	SRB-000308	HEX SOCKET HEAD CAP SCREW M12x35	2
10	KZK-0573-02-14-00-0	LOCKING PUCK	1
11	WLK-0573-02-15-00-0	LOCKING SHAFT	1
12	PDK-000118	ROUND WASHER 13	12
13	LOZ-000038	BALL BEARING 12x28x8	4
14	SRB-000101	HEX SOCKET HEAD CAP SCREW M6x10	7
15	ZGR-0573-02-10-00-0	CHIPS DRIFT FENDER II	1
16	ZGR-0573-02-09-00-0	CHIPS DRIFT FENDER I	1
17	ZGR-0573-02-08-00-0	TOP CHIPS DRIFT FENDER	1
18	SRB-000156	HEX SOCKET HEAD CAP SCREW M8x35	1
19	PLY-0573-02-04-00-0	MOUNTING PLATE ASSY	1
20	PLY-0573-02-03-00-0	MOVING PLATE	1
21	NKR-000003	HEX NUT M12	2

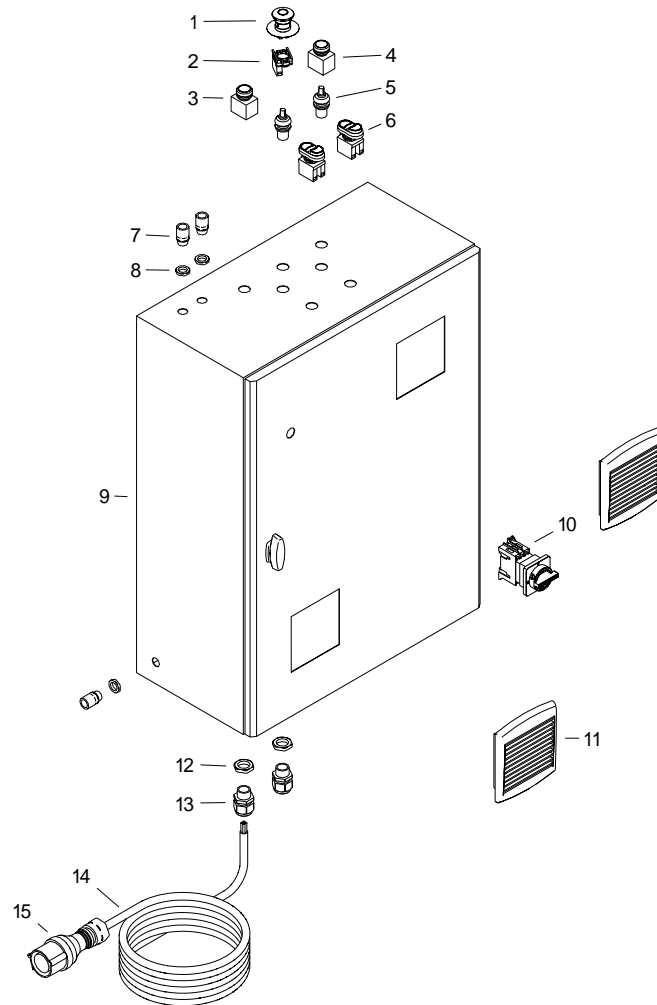
ITEM	PART NUMBER	DESCRIPTION	Q-TY
22	WSP-0573-02-05-00-1	MOTOR SUPPORT	1
23	PDK-000053	SPRING WASHER 12.2	8
24	SRB-000195	FULL THREAD HEX HEAD SCREW M12x35	8
25	WKR-000509	HEX SOCKET BUTTON HEAD SCREW M12x40	1
26	PDK-000103	ROUND WASHER 13	1
27	GLW-000030	MILLING CUTTER	1
28	PLY-000396	MILLING CUTTER INSERT	10
29	SRB-000083	HEX SOCKET HEAD CAP SCREW M5x16	4
30	WPS-0573-02-02-00-0	KEY	2
31	TRC-0573-02-01-00-0	MOTOR PLATE	1
32	SLN-000200	MOTOR 400V	1
33	PRZ-0573-02-06-00-0	NIPPLE	1
34	ZLC-000160	CABLE GLAND	1
35	PLY-000439	SHIM	10
36	SRB-000417	CLAMP SCREW	10
37	SRB-000418	SHIM SCREW	10



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	RKJ-000067	HANDLEVER M12	1
2	SRB-000103	HEX SOCKET HEAD CAP SCREW M6x12	12
3	PDK-000021	ROUND WASHER 6.4	8
4	PDK-000118	ROUND WASHER 13	1
5	WSP-0573-03-12-00-0	TABLE SUPPORT	2
6	WSP-0573-03-02-00-0	BEARING HOLDER SUPPORT	1
7	PKT-0573-03-08-00-0	KNOB	1
8	KLK-000111	DOWEL PIN 5n6x36	1
9	SRB-0573-03-07-00-0	BOLT	1
10	PKR-0436-03-06-00-0	COVER	1
11	NKR-000135	BEARING NUT M12x1	1
12	PDK-000179	BEARING TOOTHED WASHER MB-1	1
13	TLJ-0469-20-12-00-0	SCREW SPACER SLEEVE	1
14	LOZ-000062	BALL BEARING 12x32x10	1
15	OPR-0573-03-05-00-0	BEARING HOLDER	1
16	SRB-000106	HEX SOCKET HEAD CAP SCREW M6x16	2
17	SRB-000086	HEX SOCKET HEAD CAP SCREW M5x20	4
18	NKR-0573-03-06-00-0	NUT	1
19	BZA-0573-03-04-00-0	VERTICAL BASE PLATE	1
20	UCW-0573-03-03-00-0	HANDLE	2
21	SRB-000148	HEX SOCKET HEAD CAP SCREW M8x20	12
22	STL-0573-03-01-00-1	TABLE	1
23	PRT-0573-03-13-00-0	LOCKING ROD ASSY	1
24	PRW-000068	CARRIAGE	3
25	WSP-0573-03-09-00-0	GUIDE SUPPORT	3
26	KLK-000083	DOWEL PIN 6n6x18	8
27	SNA-000040	GUIDE	3
28	SRB-000083	HEX SOCKET HEAD CAP SCREW M5x16	22

ITEM	PART NUMBER	DESCRIPTION	Q-TY
29*	WSP-0573-03-10-00-1	LEFT VERTICAL BASE SUPPORT	1
30	WSP-0573-03-11-00-1	RIGHT VERTICAL BASE SUPPORT	1
31	BLD-0573-03-14-00-0	NUT LOCK	1
32	OSL-0573-03-15-00-0	NUT COVER	1
33	SRB-000117	HEX SOCKET HEAD CAP SCREW M6x25	4

\*not shown in the drawing



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PRC-000029	EMERGENCY BUTTON	1
2	STK-000010	CONNECTOR	1
3	PRC-000042	GREEN BUTTON	1
4	PRC-000043	RED BUTTON	1
5	PTN-000038	POTENTIOMETER	2
6	PRC-000044	START-STOP BUTTON	2
7	PRP-000006	STRAIN RELIEF	3
8	NKR-000040	STRAIN RELIEF NUT	3
9	SZF-0555-05-01-00-0	CONTROL BOX	1
10	RZL-000017	3-GEAR DISCONNECTOR 40A	1
11	FLT-000011	AIR FILTER	2
12	NKR-000165	STRAIN RELIEF NUT M25x1.5	2
13	DLW-000045	CABLE GLAND M25x1.5	2
14	KBL-000173	CABLE	1
15	WTK-000032	MALE SOCKET	1
16*	KBL-0573-05-02-00-0	EMERGENCY BUTTON WIRE SET	1
17*	KBL-0573-05-03-00-0	TABLE EMERGENCY BUTTON WIRE SET	1

\*not shown in the drawing

## 6. QUALITY CERTIFICATE

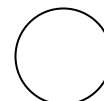
**Machine control card**  
**SBM-500 STATIONARY BEVELING MACHINE**

Serial number.....

**Electric test**

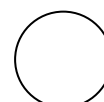
Type of test	Result	Name of tester
Insulation resistance test (500 V DC)	..... MΩ	..... Date
Continuity test of the protective earth system	..... Ω	..... Signature

Quality control .....



**Adjustments, inspections**

Quality control .....



## 7. DECLARATION OF CONFORMITY

### ***EC Declaration of Conformity***

We

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

declare with full responsibility that:

### **SBM-500 Stationary Beveling Machine**

is manufactured in accordance with the following standards:

- EN 60204-1
- EN ISO 12100
- EN ISO 14120
- EN ISO 13849-1

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

Person authorized to compile the technical file:

Marek Siergiej, ul. Elewatorska 23/1, 15-620 Białystok



Białystok, 2 September 2016

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Marek Siergiej  
CEO



## **8. WARRANTY CARD**

**WARRANTY CARD No.....**

..... in the name of Manufacturer warrants the SBM-500 Stationary 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.....

**1.01 / 17 July 2017**

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