

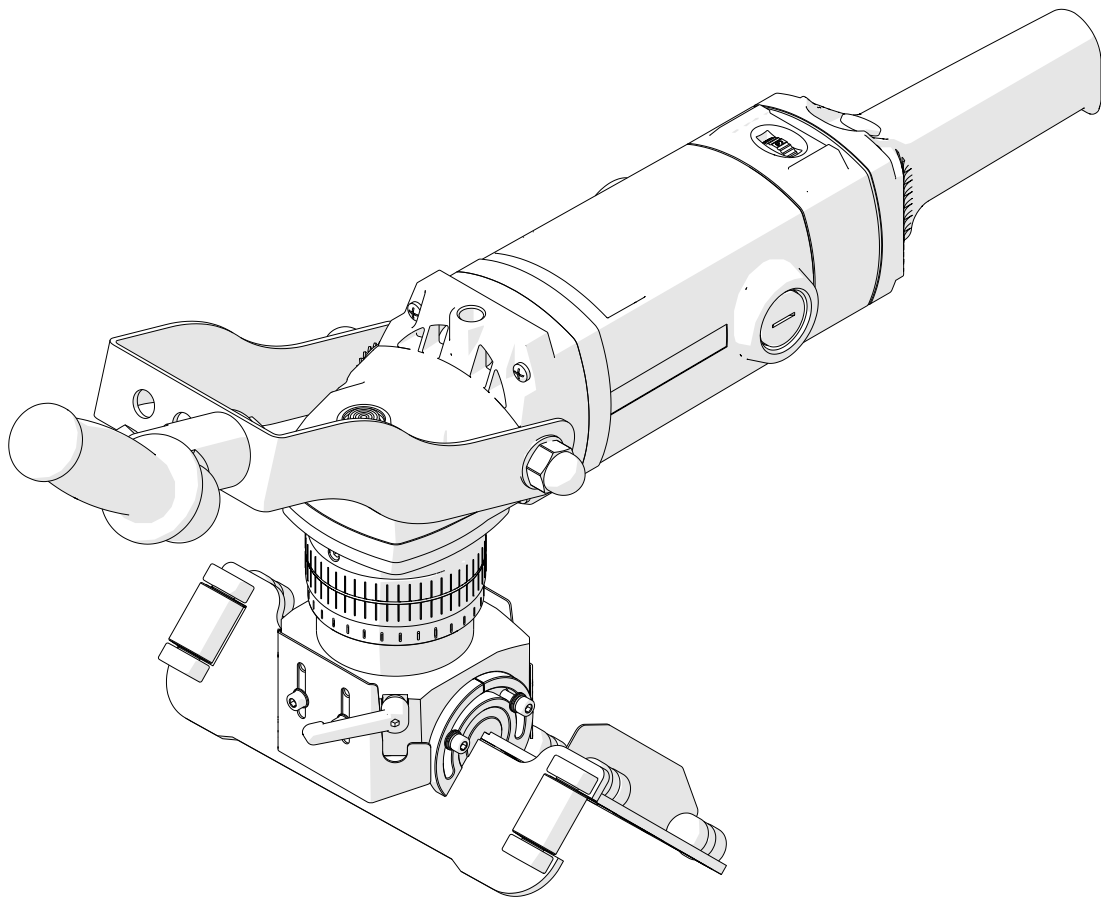
Steelmax®

The tools of innovation.

OPERATOR'S MANUAL

BEVELING MACHINE

BM-25



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1. GENERAL INFORMATION

1.1. Application

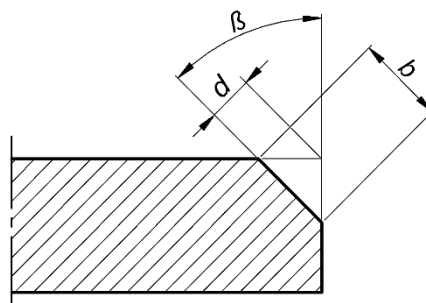
The BM-25 is a beveling machine designed to bevel plates made of non-alloy steel. It allows beveling at angles from 0° to 90° and has maximum bevel width of 25 mm, however, the recommended range is from 15° to 75°.

It is equipped with an ergonomic handle which allows the positioning of the machine in according to machining angle, workbench height, and operator’s body type, as well as considering optimal load distribution between the operator’s hands.

The horizontal guide rollers can be set in the position most suitable for the width of the workpiece.

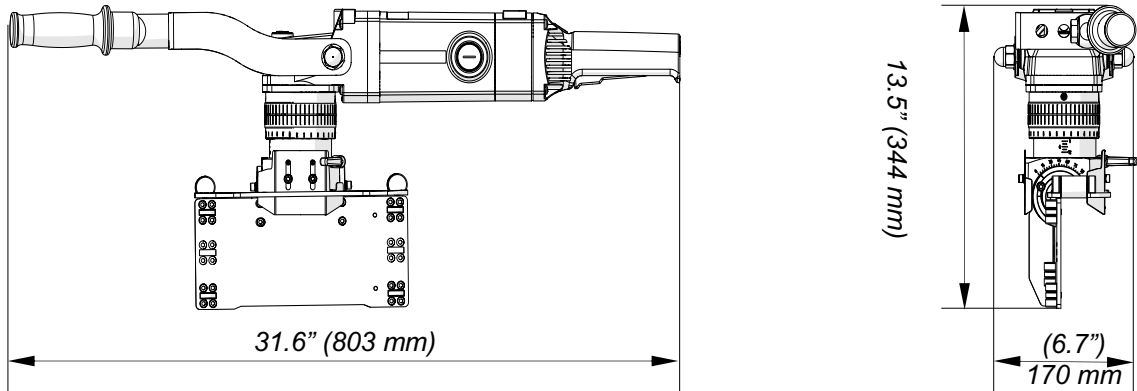
1.2. Technical data

Voltage	1~ 110-120 V, 50-60 Hz 1~ 220-240 V, 50-60 Hz
Power	2200 W
Rotational speed with no load	1800-5850 rpm
Protection level	IP 20
Protection class	II
Maximum bevel width (<i>b</i> , Fig. 1)	0.98" (25 mm)
Maximum milling head depth (<i>d</i> , Fig. 1)	½" (12.5 mm)
Bevel angle (β , Fig. 1)	0°-90°
Minimum workpiece thickness	.08" (2 mm)
Noise level	More than 70 dB
Vibration level	2.3 m/s ² (7.5 ft/s ²) Machine harmful for health. Take periodic breaks during work.
Weight	27 lbs (12.5 kg)
Required ambient temperature	32-104° (0-40°C)

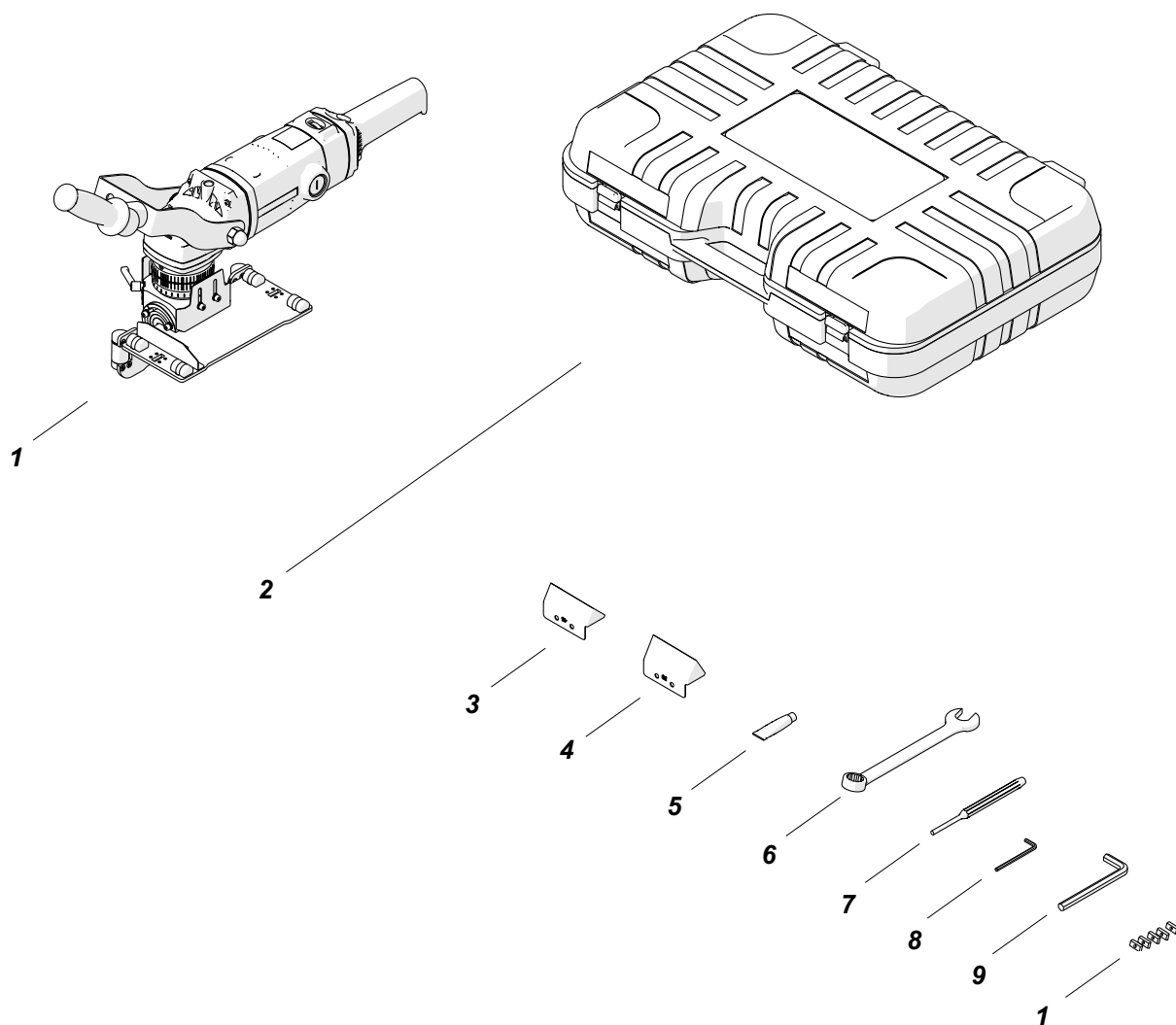


Rys. 1. Bevel dimensions

1.3. Dimensions

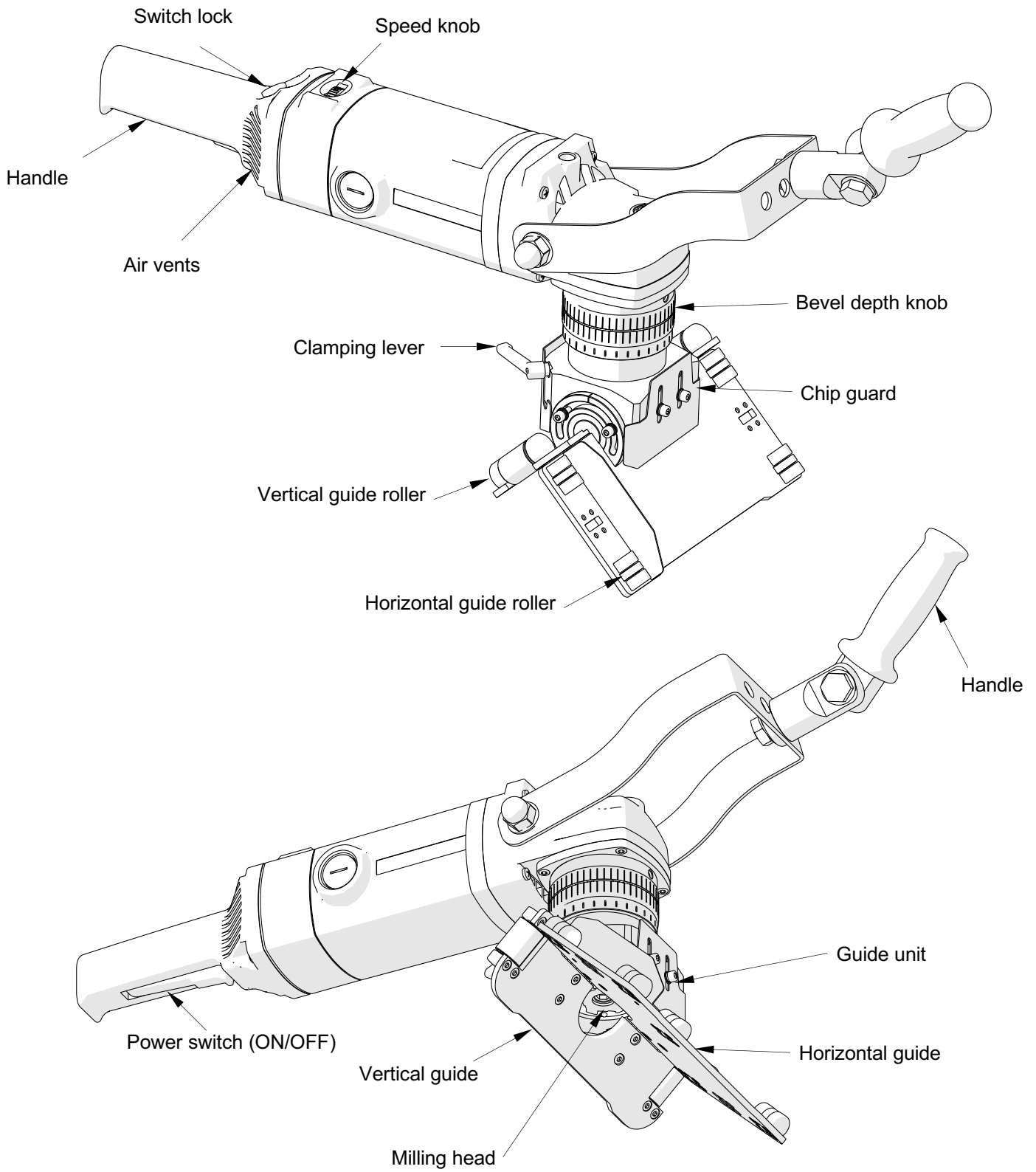


1.4. Equipment included



1	Beveling machine	1 unit
2	Plastic box	1 unit
3	Guard 45°	1 unit
4	Guard 30°	1 unit
5	Grease	1 unit
6	Drift	1 unit
7	Combination wrench 22 mm	1 unit
8	Hex wrench 4 mm	1 unit
9	10 mm hex wrench	1 unit
10	Cutting inserts	5 units
-	Operator's Manual	1 unit

1.5. Design



2. SAFETY PRECAUTIONS

1. Before use, read this Operator's Manual and complete a training in occupational health and safety.
2. Use only in applications specified in this Operator's Manual.
3. Make sure the machine has all parts and that they are genuine and not damaged.
4. Make sure that the specifications of the power source are the same as those specified on the rating plate.
5. Do not carry the machine by the power cord and do not pull the power cord. This may cause damage and electric shock.
6. Do not allow untrained persons to use the machine.
7. Before each use, ensure the correct condition of the machine, power source, power cord, plug, control parts, and tools.
8. Before each use, make sure that no part is cracked or loose. Make sure to maintain correct conditions that may influence the operation of the machine.
9. Keep the machine dry. Do not expose the machine to rain, snow, or frost.
10. Keep the work area well-lit, clean, and free of obstacles.
11. Do not use in explosive environments or near flammable materials.
12. Use only tools specified in this Operator's Manual.
13. Do not use tools that are dull or damaged.
14. Make sure that the cutting inserts and the milling head are installed correctly. Remove wrenches from the work area before you connect the machine to the power source.
15. Do not use the machine with the milling head pointing up.
16. Do not carry the machine with rotating head. Before carrying unplug the machine from the power source.
17. If the cutting edge of an insert is worn, turn all inserts by 180°. If all cutting edges are worn, replace all inserts with new ones specified in this Operator's Manual.
18. Use eye and ear protection, work boots, protective clothing, and heat-resistant gloves. The clothing must not be loose.
19. Due to high level of vibrations it is recommended to use the anti-vibration gloves.
20. Do not touch chips or moving parts with bare hands. Do not let anything catch in moving parts.

21. After use, clean the machine and the milling head with a dry cotton cloth and without any chemical agents. Do not remove chips with bare hands.
22. Maintain the machine and attach/remove parts and tool only after you unplug the machine from the power source.
23. Repair only in a service center appointed by the seller.
24. If the machine falls, is wet, or has any damage, stop working and promptly send the machine to the service center for check and repair.
25. If machine is not going to be in use, remove it from the work area and keep it in a safe and dry place.
26. If machine will not be in use for an extended period, put anti-corrosion agent on steel parts.

3. SYMBOLS

Before using the machine, familiarize yourself with the following symbols (tab. 1).



Use eyes protection



Use hearing protection



Read the Operator's Manual



Warning against electric voltage

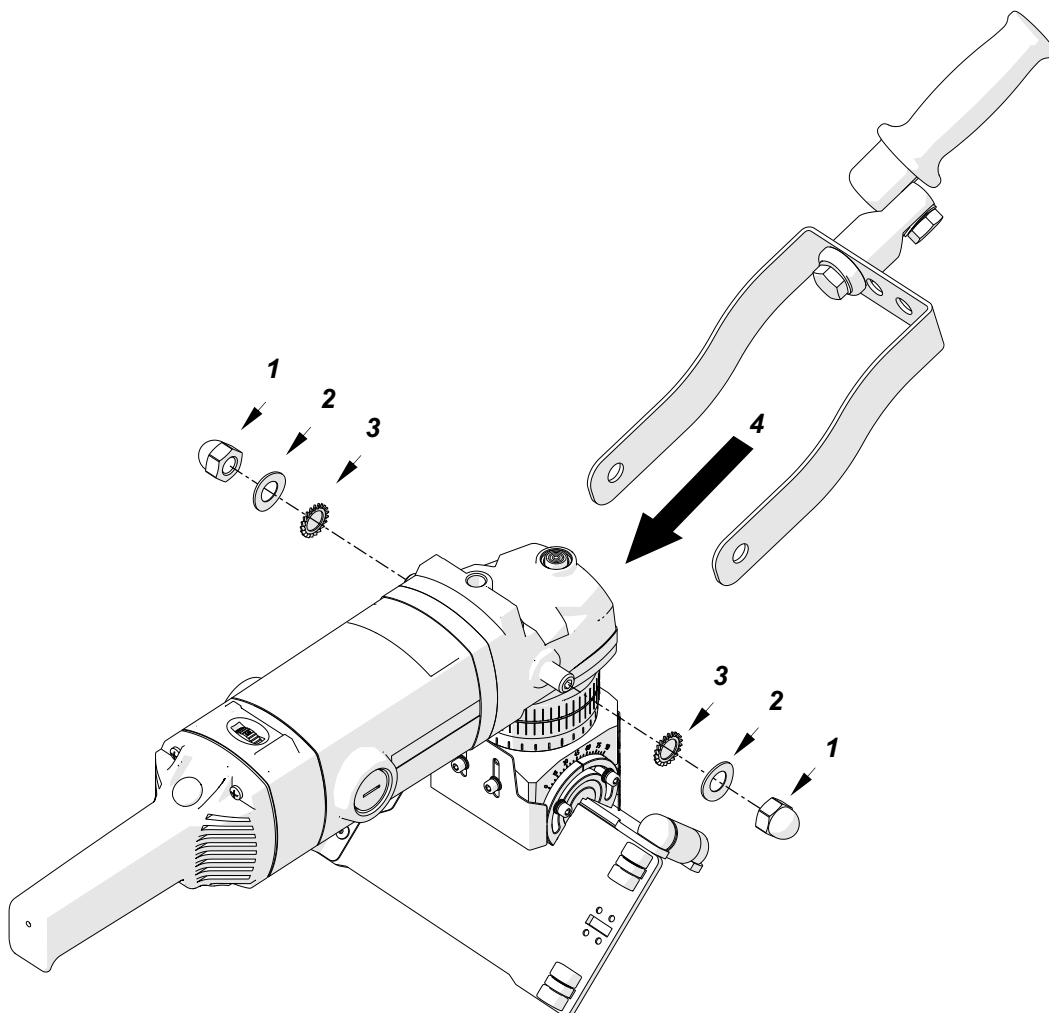
Tab. 1. Explanation of symbols

4. STARTUP AND OPERATION

4.1. Handle installation

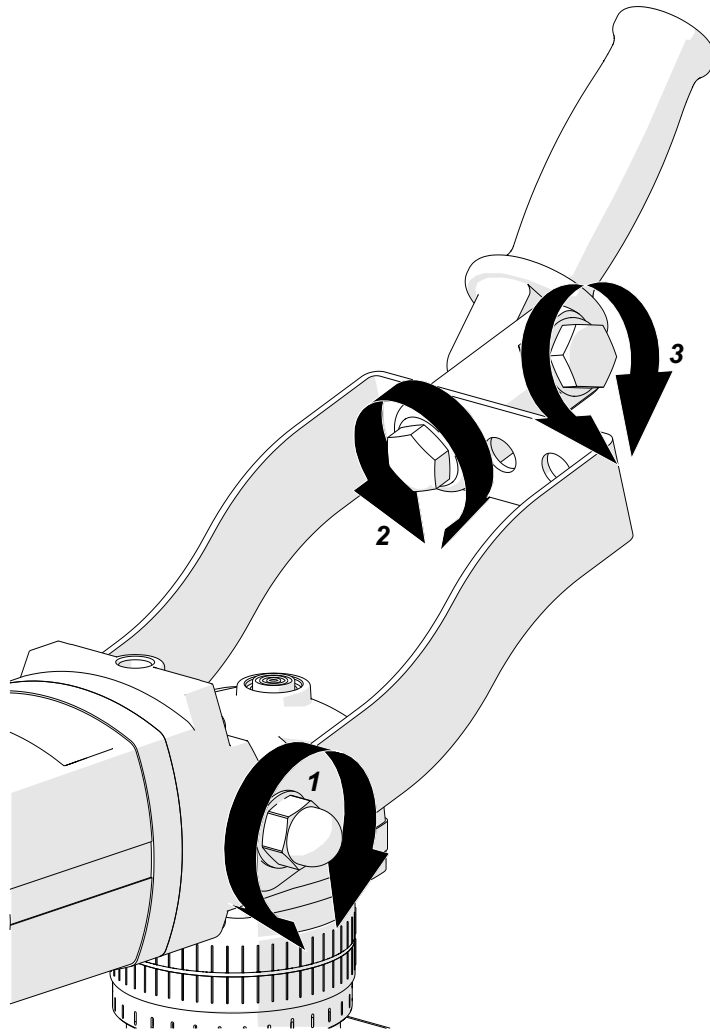
The beveling machine is delivered with dismantled handle. To install the handle after unpacking the machine, proceed as below.

Unscrew the domed nut from the threaded mandrels (1). Remove the spring washers from the threaded mandrels (2). Leave the teeth lock washers (3) in place. Put the handle (4) onto the threaded mandrels, bending it slightly out. Put the spring washers on and screw the domed nuts on using 22 mm flat wrench.



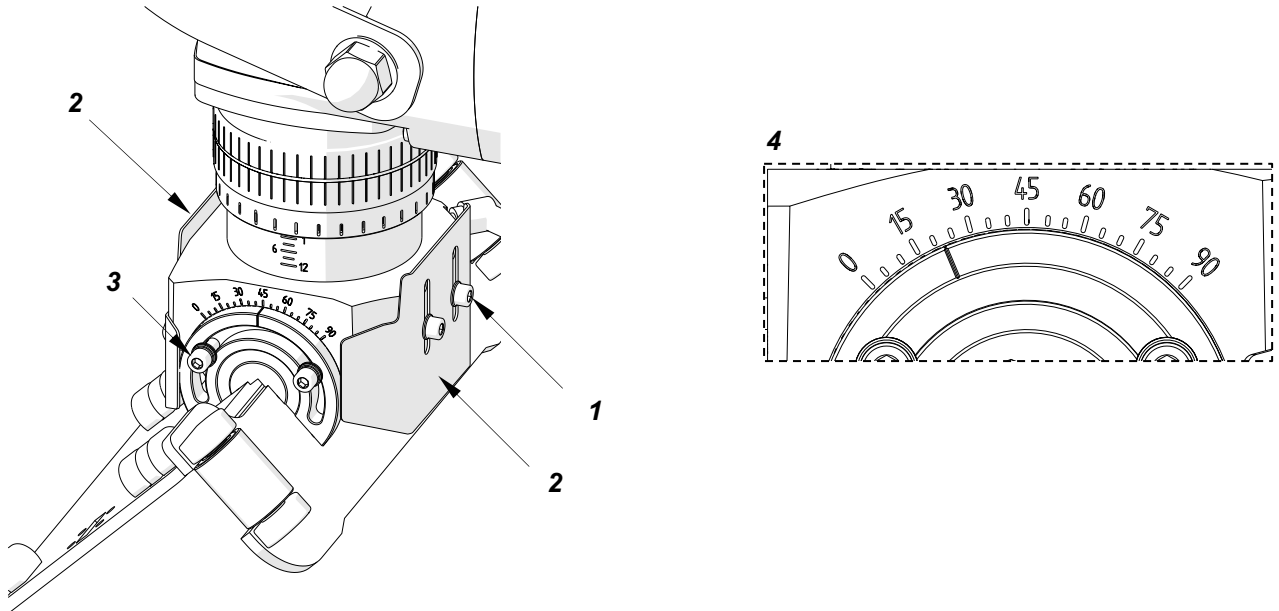
4.2. Handle adjustment

The beveling machine handle may be adjusted in three axis so the operator may adapt it to their needs. To adjust, loosen the domed nuts (1) and screws (2) and (3) using 22 mm flat wrench. Perform adjustment and tighten the loosened elements.

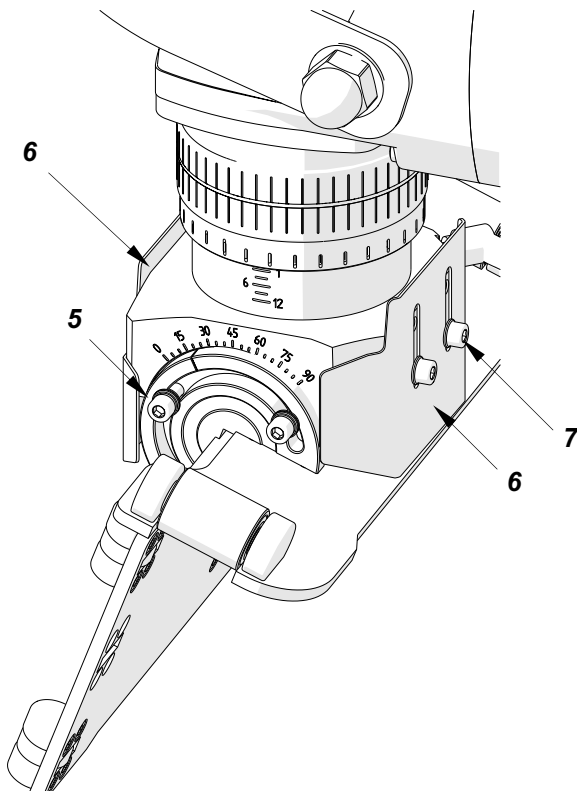


4.3. Beveling angle adjustment

Unplug the power cord. Loosen the screws (1) on both sides of the guide unit and lift the guards (2). Then loosen the screws (3) on both sides of the scale and guide unit and set the required bevel angle (4).



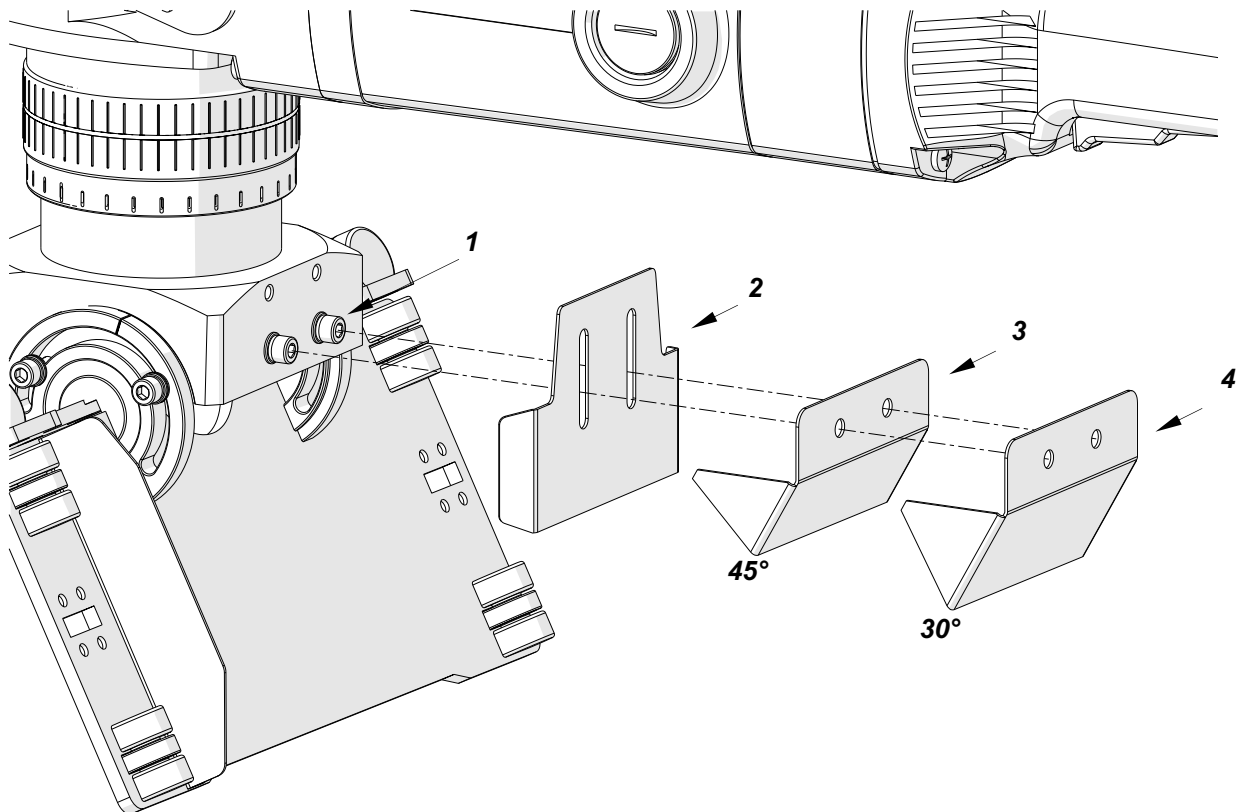
Tighten the screws (5) on both sides of the scale, lower the guards (6) completely, and tighten all screws of the guide unit (7).



4.4. Horizontal guide guards

During operation with beveling angles of 30° and 45° it is required to use the horizontal guide guards dedicated for those angles. To replace the guard proceed as below.

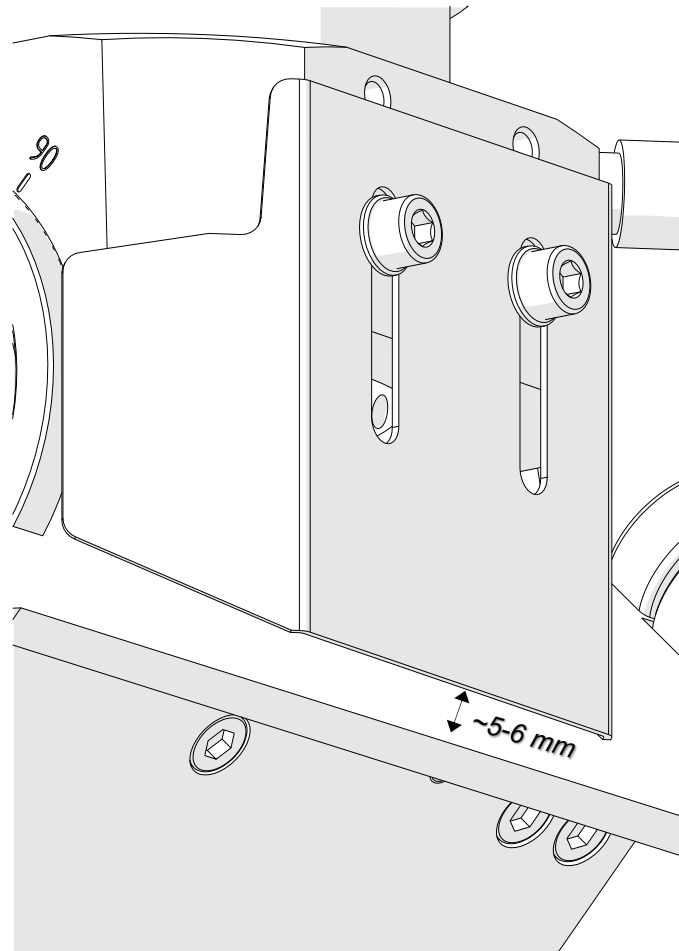
Remove the hexagon socket head screws (1). Remove the basic guard (2). Install guard (3) or (4) according to the machining angle. Tighten the hexagon socket head screws.



The guard should touch the guide so the chips are not ejected onto the workpiece surface.

4.5. Vertical guide guard

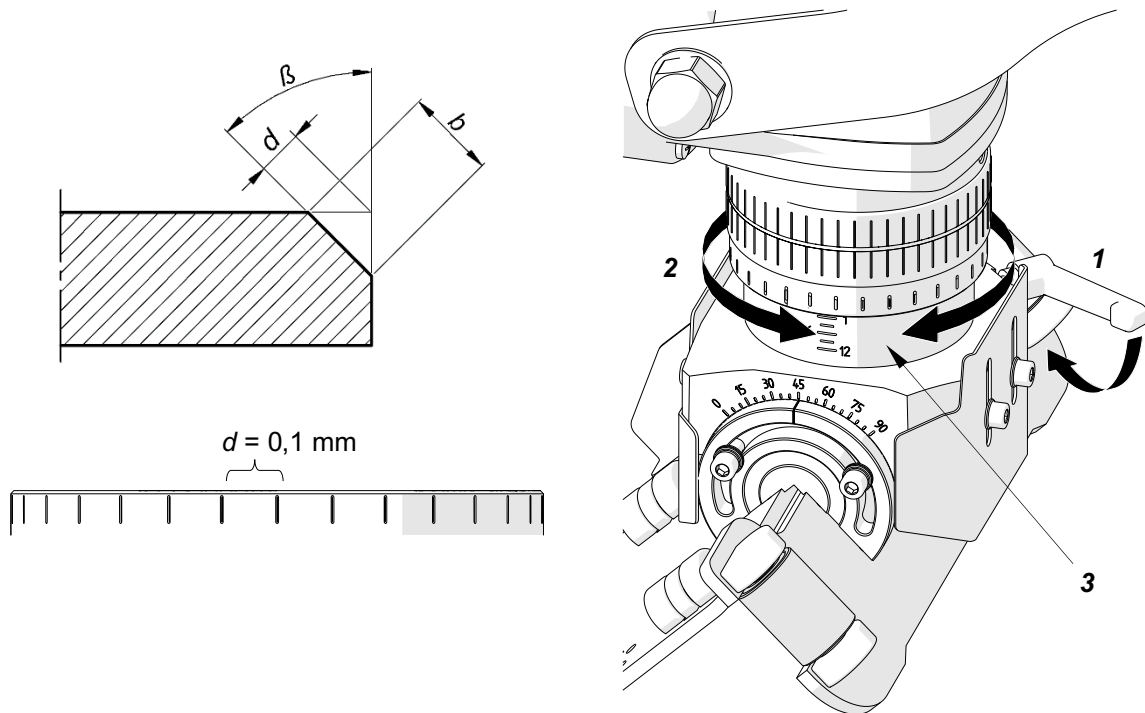
Pay attention during adjustment of the vertical guide guard that the distance between the guide and the guard should be approx. 5-6 mm. It allows for free falling of chips without their accumulation behind the guard.



4.6. Beveling depth adjustment

Unplug the power cord. Release the lever (1). Rotate the knob (2) so that the scale (3) shows the bevel depth “d” (max. ½”, 12.5 mm) related to the required bevel width “b” (1”, max. 25 mm). Lock the lever.

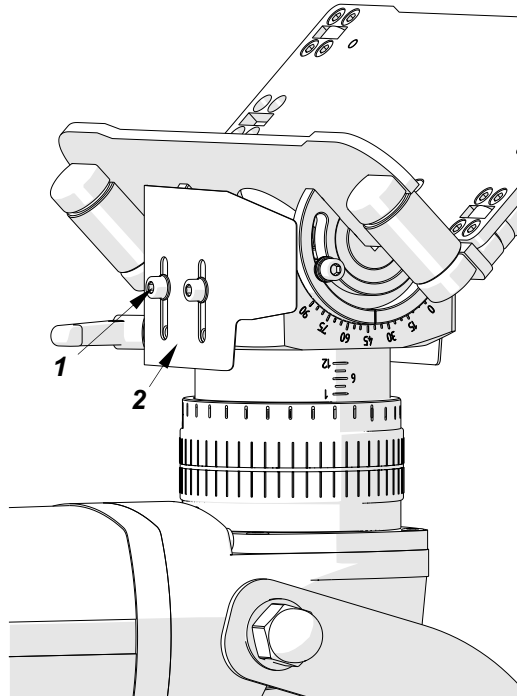
The depth change is 0.02” (0.1 mm) per graduation or 0.16” (3 mm) per one full turn of the knob.



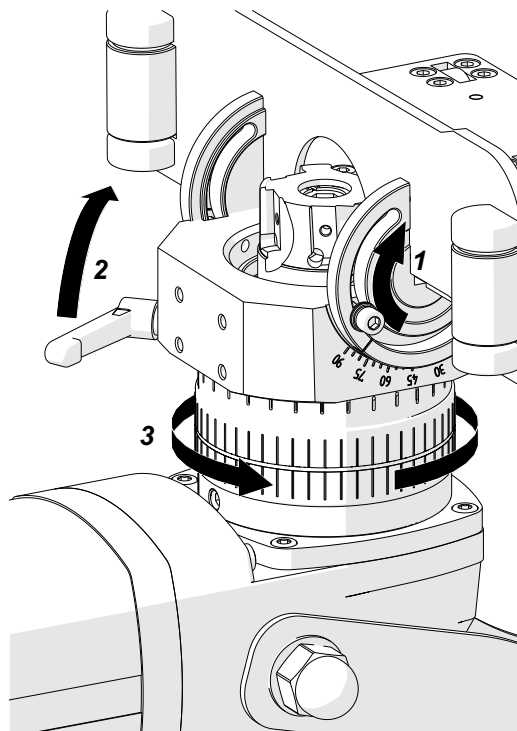
After adjusting the depth perform the test machining and correct the setting as required.

4.7. Cutting inserts installation

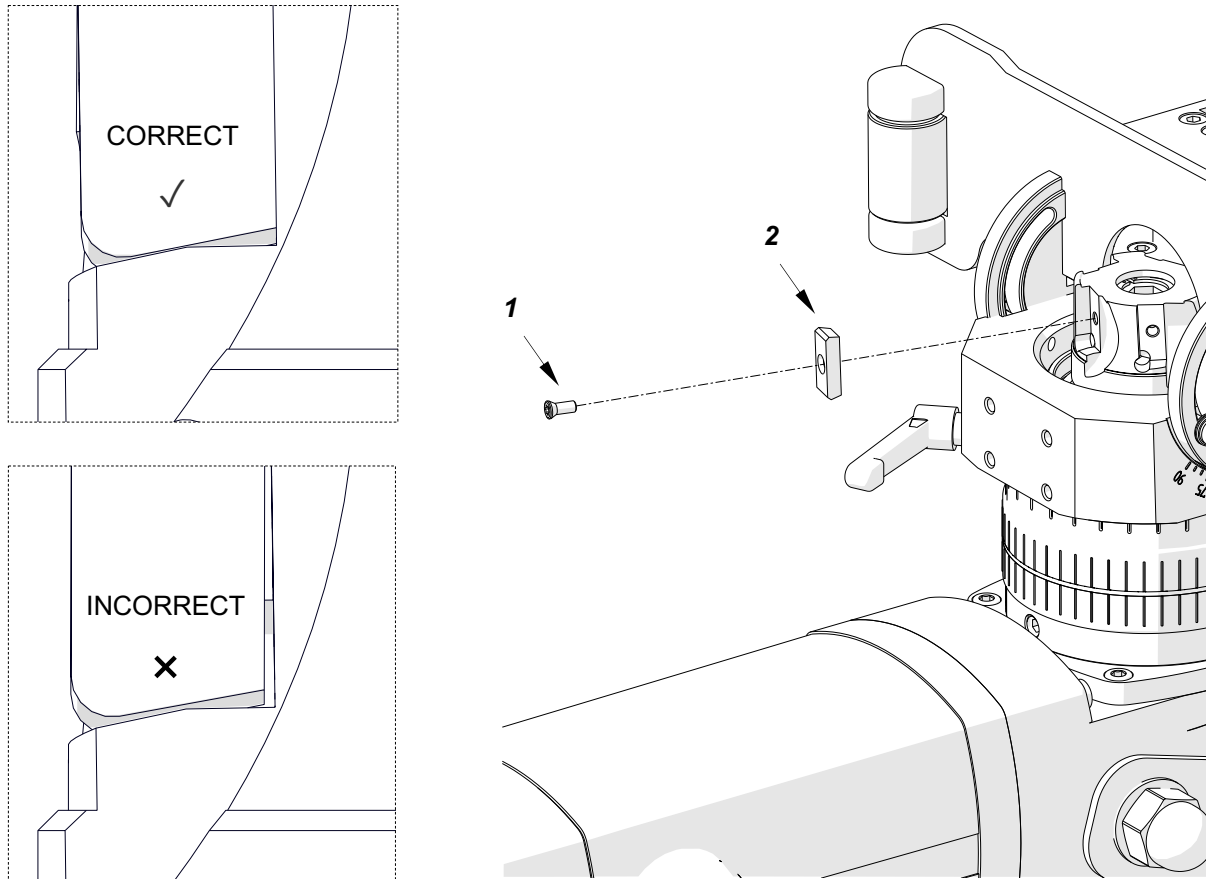
Unplug the power cord. Remove the screws (1) and guards (2) on both sides of the guide unit.



Position the guides in such way that the horizontal guide is parallel to the machine body (1) (value of 90° on the scale). Release the lever (2). Hold the guides by hand and rotate the bevel depth knob (3) until the head protrudes fully.



Prepare screws (1) covered with delivered grease. Put the insert (2) in the socket, press it down and fix with screw, using T15 torx screwdriver. Make sure that the whole bottom of the insert touches the socket.



At the end reinstall the guards and set the guides at appropriate angle.

4.8. Replacing the cutting inserts

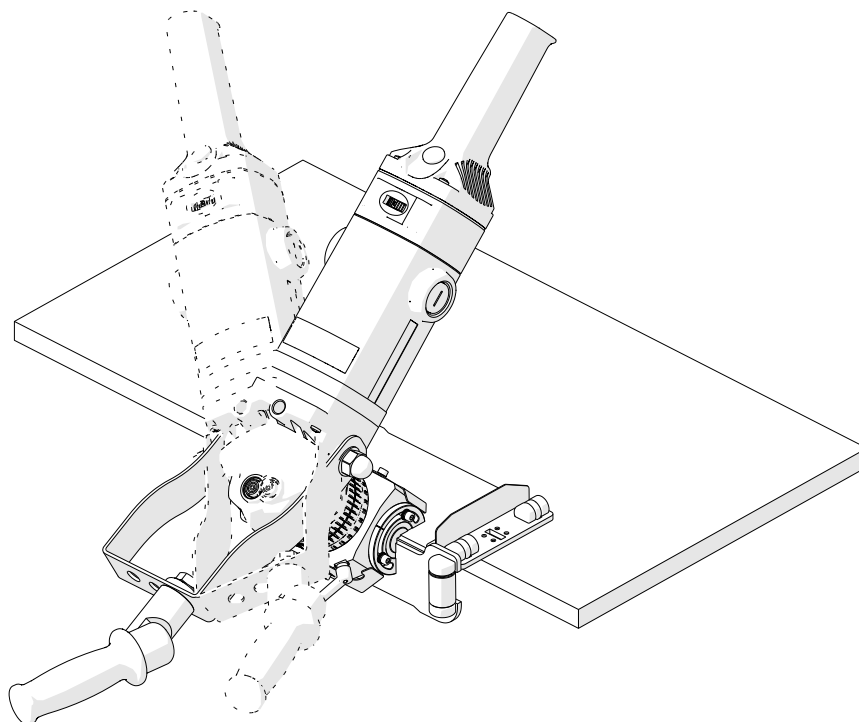
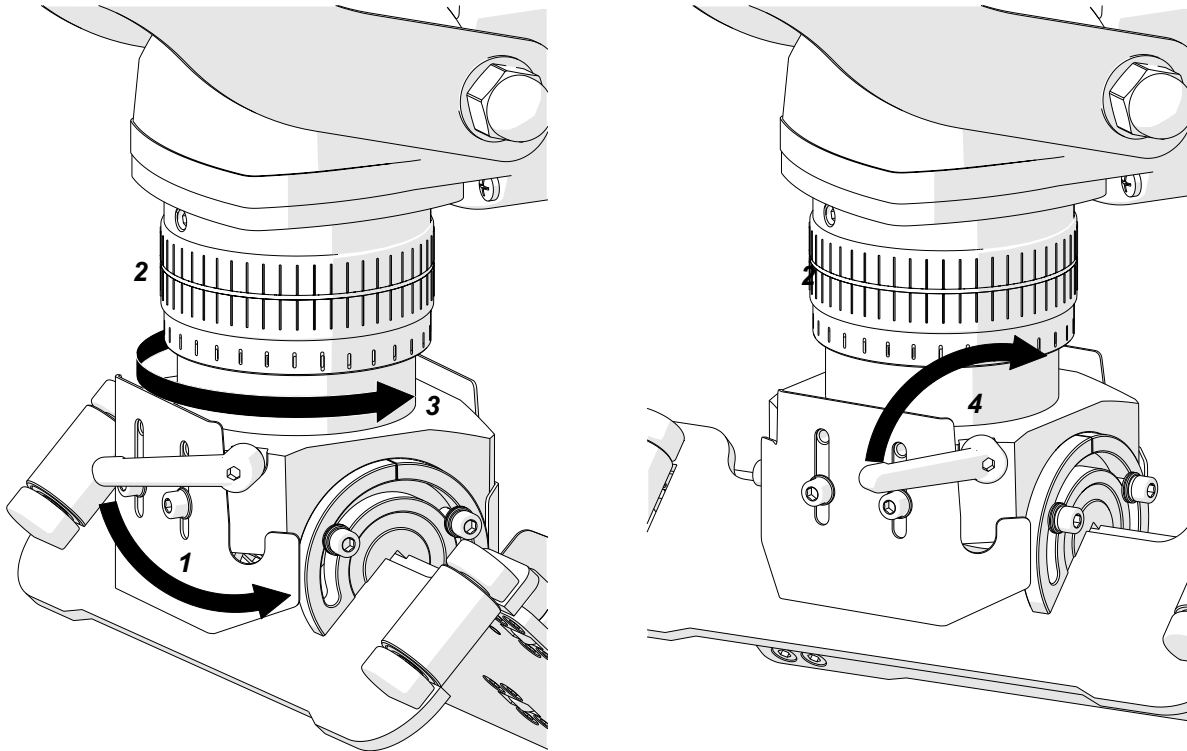
When inserts become dull, they should be rotated or replaced.

Unplug the power cord. Set the guides and head like during installation of new inserts. Use T15 torx screwdriver to remove the cutting inserts. Clean the sockets.

To change the cutting edge rotate the inserts by 180°. Press the inserts towards the sockets and tighten them. If all cutting edges are worn, replace the inserts with new ones. Make sure that the whole bottom of the insert touches the socket.

4.9. Turning the guide unit

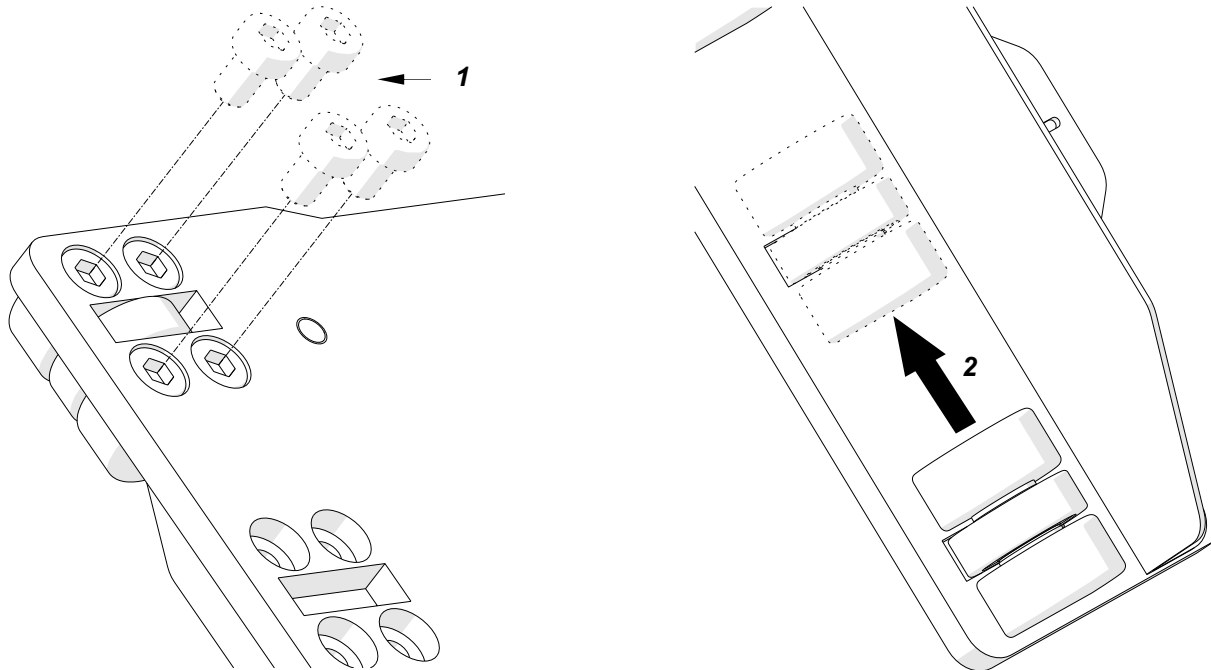
Unplug the power cord. Release the lever (1). Hold the bevel depth knob (2) so it does not rotate in relation to the guide unit and turn the guide unit to the desired position (3). Correct the bevel depth when required. Lock the lever (4).



4.10. Positioning the horizontal guide rollers

When width of the workpiece is below 110 mm, the rollers on the horizontal guide may be set in position suitable for that width.

Remove four hexagon socket head screws (1) of the roller to be moved. Move the roller (2) to desired position. Fix the roller with use of hexagon socket head screws.



4.11. Preparation for machining

Set the required bevel width. Then use the speed knob to set the rotational speed.

Material	Rotational speed
Structural steel of standard quality, quality steel	Setting 3-6 (3100-5850 rpm)

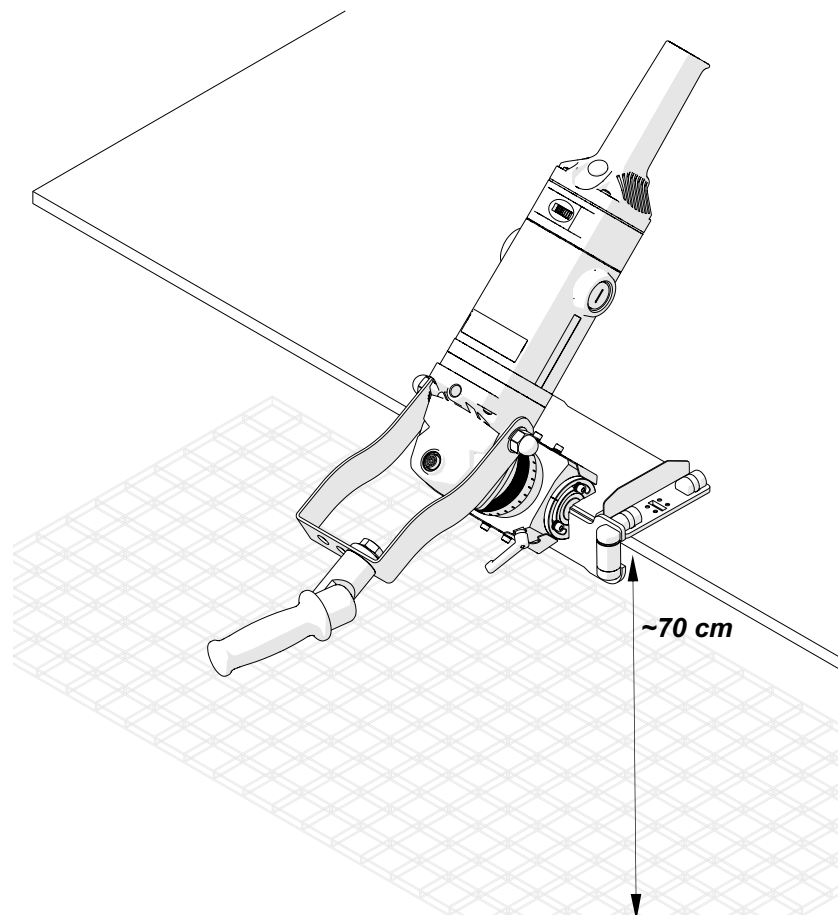
The speed knob allows for control of the rotational speed in the range of 1800-5850 rpm.

Setting	1	2	3	4	5	6
Speed	1800 rpm	2400 rpm	3100 rpm	3800 rpm	4500 rpm	5850 rpm

To machine the structural steel of standard quality or quality steel, set the speed to 6 and decrease the speed if much sparking occurs.

4.12. Operating

For the best results and optimum work, height of the workpiece above the surface on which the operator stands should be approx. 70 cm, however, it depends on the operator's height. It allows the operator to work with slightly bent arms for less tiredness and better pressing force.



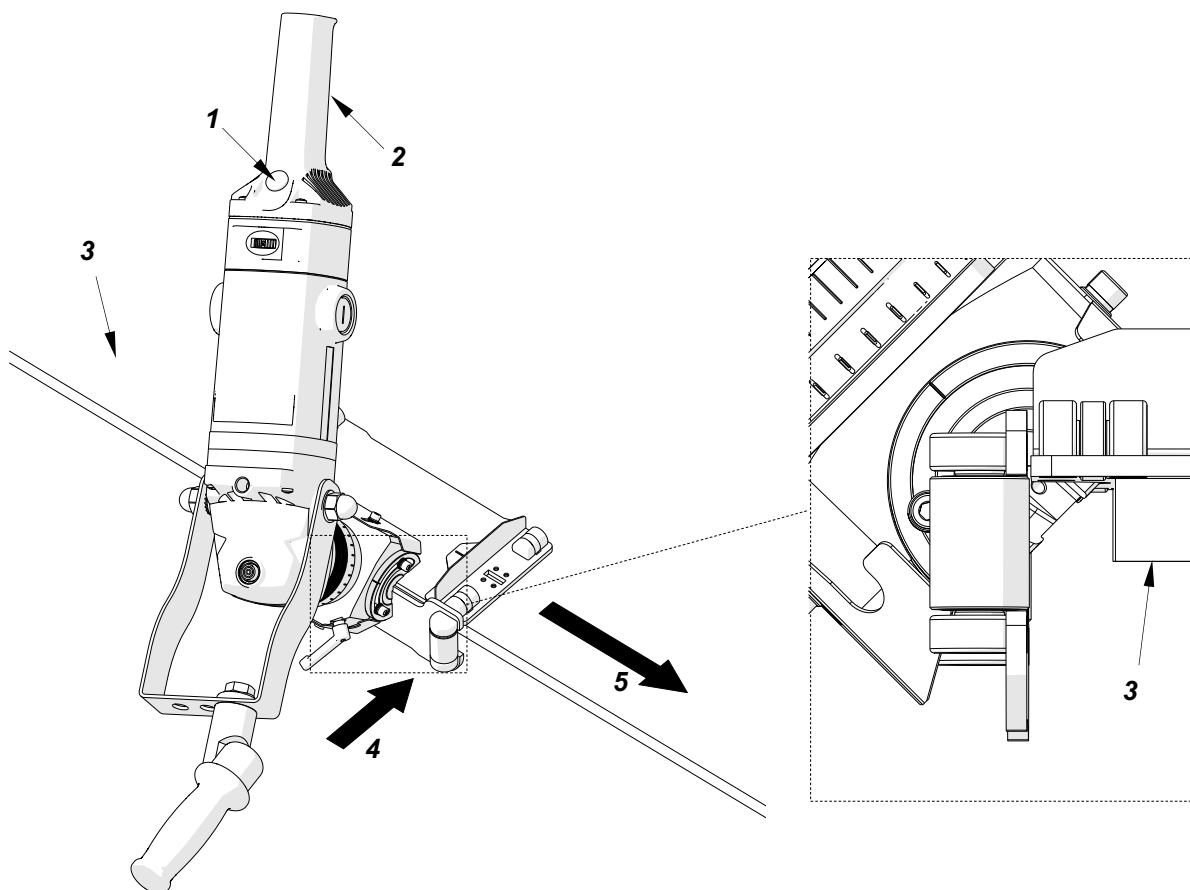
It is good to place the anti-slip mats on the floor in order to eliminate skid of operator's feet during stronger pressing. It is also favorable to use the perforated base to avoid operator's feet sliding on the chips.

Connect the machine to the power source. Make sure that the workpiece is stable. Remove all contamination from the workpiece surface. Put the machine on the left side of workpiece as shown in the figure.



Place the power cord in such way that it does not rub against the workpiece edge during work, as it may lead to its damage and electric shock.

To start the motor press and hold the switch lock (1) and the power switch (2), then release the lock (1). Wait a few seconds until the speed reaches the set value. Use both hands press to press the machine to the workpiece (3). Then slowly move the machine to the edge (4) until the tool starts cutting. Move the machine from left to right (5). Correct machining direction is indicated by the arrow on the horizontal guide.



Start with making small widths (0.12–0.16", 3-4 mm,) and increase them with experience. Refer to the table for the recommended maximum number of passes to do depending on the bevel width.

Bevel width 'b'	Number of passes
0.55" (14 mm)	1
0.83" (21 mm)	2
0.98" (25 mm)	3

If an overload occurs, the motor shuts off. This may occur when the bevel width is too large for the hardness of material or when the cutting inserts are dull. Therefore, to prevent overload, machine hard materials in multiple passes and replace the inserts before they become dull. Also, take periodic breaks during work and keep the air vents unclogged. This prevents motor overheating and damage to the windings.

After the work is finished, release the power switch to turn off the motor. Then, wait until the rotation stops and unplug the power cord.

Clean the machine with soft, lint-free cloth, without any chemical agents. Chips may be removed with use of soft brush.



Be careful during operation using bevel angle below 15° and above 75°. The beveling machine is then more susceptible to strong vibrations and kickback.

Kickback is a sudden reaction caused by catching or locking of rotating tool. Catching or locking causes the work tool to stop abruptly. As a result, the uncontrolled power tool gains acceleration in the direction opposite to the direction of rotation of the locked work tool.

If the milling head becomes jammed or blocked in the workpiece, the blocked edge of the cutting insert, when recessed into the workpiece, may cause it to break off or eject. The machine then moves in the direction of the operator or opposite direction, depending on the direction of rotation of the blocked insert. In such case the insert may also break.

Kickback is a consequence of incorrect or improper use of the power tool. By taking the appropriate precautions described below, one can prevent this from happening.

- a) Hold the machine firmly and keep your body and arms in a position to absorb the kickback force. By following the suitable safety measures the operator may control the kickback force.
- b) Maintain special caution when working in the area of corners, sharp edges, etc. Avoid situations in which the head jumps off the workpiece or becomes jammed. The rotating head easily becomes jammed in the workpiece in corners, on sharp edges, or in case of impact. It causes loss of control or kickback.
- c) Always insert the cutting head into the workpiece in the same direction in which the cutting edge exits the workpiece (the same direction the chips are ejected). Incorrect direction causes the cutting edge to break away from the workpiece, leading to the machine to be pulled in the direction of travel.
- d) Avoid locking the head or applying too much pressure. Do not set the bevel height above the maximum allowable value. Overloading the inserts increases their stress and susceptibility to jamming or locking, and thus the possibility of kickback or breaking.
- e) Avoid touching the area around the rotating head with your hands.

Rotate or replace dull cutting inserts and those with worn coatings in a timely manner. Dull cutting inserts increase risk of jamming and breaking.

4.13. Bevel width

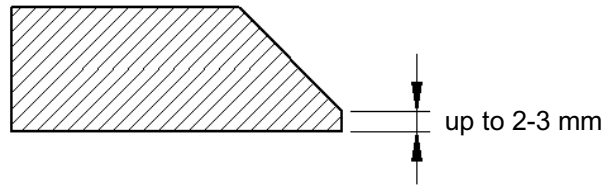
The following tables show the calculated bevel widths (in mm and inches) obtained for the individual angle of inclination and depth values. To determine the exact width, perform a test machining and correct the setting if necessary.

		Angle [°]													
		15	20	25	30	35	40	45	50	55	60	65	70	75	
Depth [mm]	0.5	2	1.6	1.3	1.2	1.1	1	1	1	1.1	1.2	1.3	1.6	2	
	1.0	4	3.1	2.6	2.3	2.1	2	2	2	2.1	2.3	2.6	3.1	4	
	1.5	6	4.7	3.9	3.5	3.2	3	3	3	3.2	3.5	3.9	4.7	6	
	2.0	8	6.2	5.2	4.6	4.3	4.1	4	4.1	4.3	4.6	5.2	6.2	8	
	2.5	10	7.8	6.5	5.8	5.3	5.1	5	5.1	5.3	5.8	6.5	7.8	10	
	3.0	12	9.3	7.8	6.9	6.4	6.1	6	6.1	6.4	6.9	7.8	9.3	12	
	3.5	14	11	9.1	8.1	7.4	7.1	7	7.1	7.4	8.1	9.1	11	14	
	4.0	16	12	10	9.2	8.5	8.1	8	8.1	8.5	9.2	10	12	16	
	4.5	18	14	12	10	9.6	9.1	9	9.1	9.6	10	12	14		
	5.0	20	16	13	12	11	10	10	10	11	12	13	16		
	5.5	22	17	14	13	12	11	11	11	12	13	14	17		
	6.0	24	19	16	14	13	12	12	12	13	14	16			
	6.5	26	20	17	15	14	13	13	13	14	15	17			
	7.0	28	22	18	16	15	14	14	14	15	16	18			
	7.5	30	23	20	17	16	15	15	15	16	17				
	8.0		25	21	19	17	16	16	16	17	19				
	8.5		26	22	20	18	17	17	17	18	20				
	9.0		28	24	21	19	18	18	18	19					
	9.5		30	25	22	20	19	19	19	20					
	10.0		31	26	23	21	20	20	20	21					
10.5		33	27	24	22	21	21	21	22						
11.0			29	25	23	22	22	22							
11.5			30	27	25	23	23	23							
12.0			31	28	26	24	24	24							
12.5			33	29	27	25	25	25							

		Angle [°]												
		15	20	25	30	35	40	45	50	55	60	65	70	75
Depth [inch]	0.5	0.1	0.1	0.1	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.1	0.1	0.1
	1.0	0.2	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.2
	1.5	0.2	0.2	0.2	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.2	0.2	0.2
	2.0	0.3	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.3
	2.5	0.4	0.3	0.3	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.4
	3.0	0.5	0.4	0.3	0.3	0.3	0.2	0.2	0.2	0.3	0.3	0.3	0.4	0.5
	3.5	0.6	0.4	0.4	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.4	0.4	0.6
	4.0	0.6	0.5	0.4	0.4	0.3	0.3	0.3	0.3	0.3	0.4	0.4	0.5	0.6
	4.5	0.7	0.6	0.5	0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.5	0.6	
	5.0	0.8	0.6	0.5	0.5	0.4	0.4	0.4	0.4	0.4	0.5	0.5	0.6	
	5.5	0.9	0.7	0.6	0.5	0.5	0.4	0.4	0.4	0.5	0.5	0.6	0.7	
	6.0	0.9	0.7	0.6	0.6	0.5	0.5	0.5	0.5	0.5	0.6	0.6		
	6.5	1.0	0.8	0.7	0.6	0.6	0.5	0.5	0.5	0.6	0.6	0.7		
	7.0	1.1	0.9	0.7	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.7		
	7.5	1.2	0.9	0.8	0.7	0.6	0.6	0.6	0.6	0.6	0.7			
	8.0		1.0	0.8	0.7	0.7	0.6	0.6	0.6	0.7	0.7			
	8.5		1.0	0.9	0.8	0.7	0.7	0.7	0.7	0.7	0.8			
	9.0		1.1	0.9	0.8	0.7	0.7	0.7	0.7	0.7				
	9.5		1.2	1.0	0.9	0.8	0.7	0.7	0.7	0.8				
	10.0		1.2	1.0	0.9	0.8	0.8	0.8	0.8	0.8				
10.5		1.3	1.1	0.9	0.9	0.8	0.8	0.8	0.9					
11.0			1.1	1.0	0.9	0.9	0.9	0.9						
11.5			1.2	1.1	1.0	0.9	0.9	0.9						
12.0			1.2	1.1	1.0	0.9	0.9	0.9						
12.5			1.3	1.1	1.1	1.0	1.0	1.0						

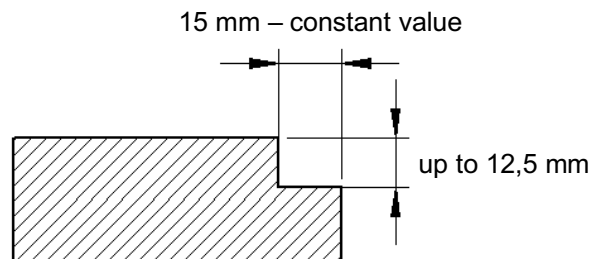
4.14. Working at angle of 0°

- Leveling in order to obtain the even surface



4.15. Working at angle of 90°

- Removing coatings from the surface
- Decreasing the sheet edge height



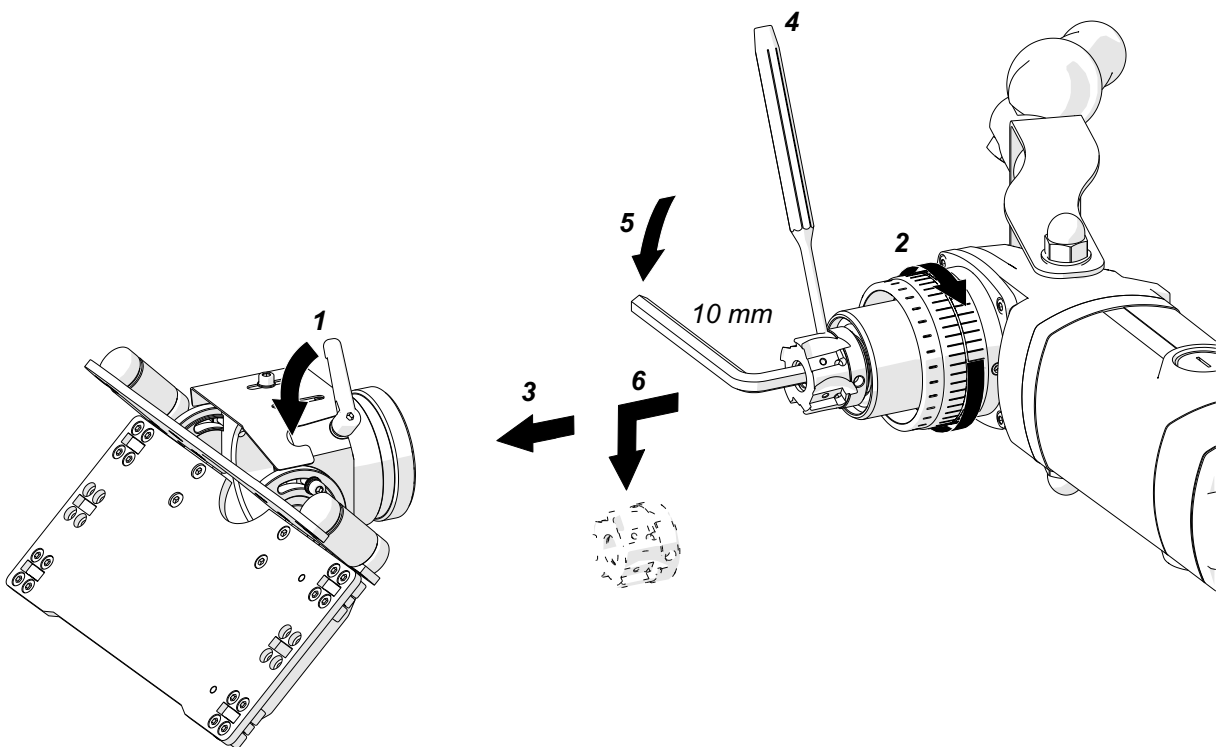
4.16. Head disassembly



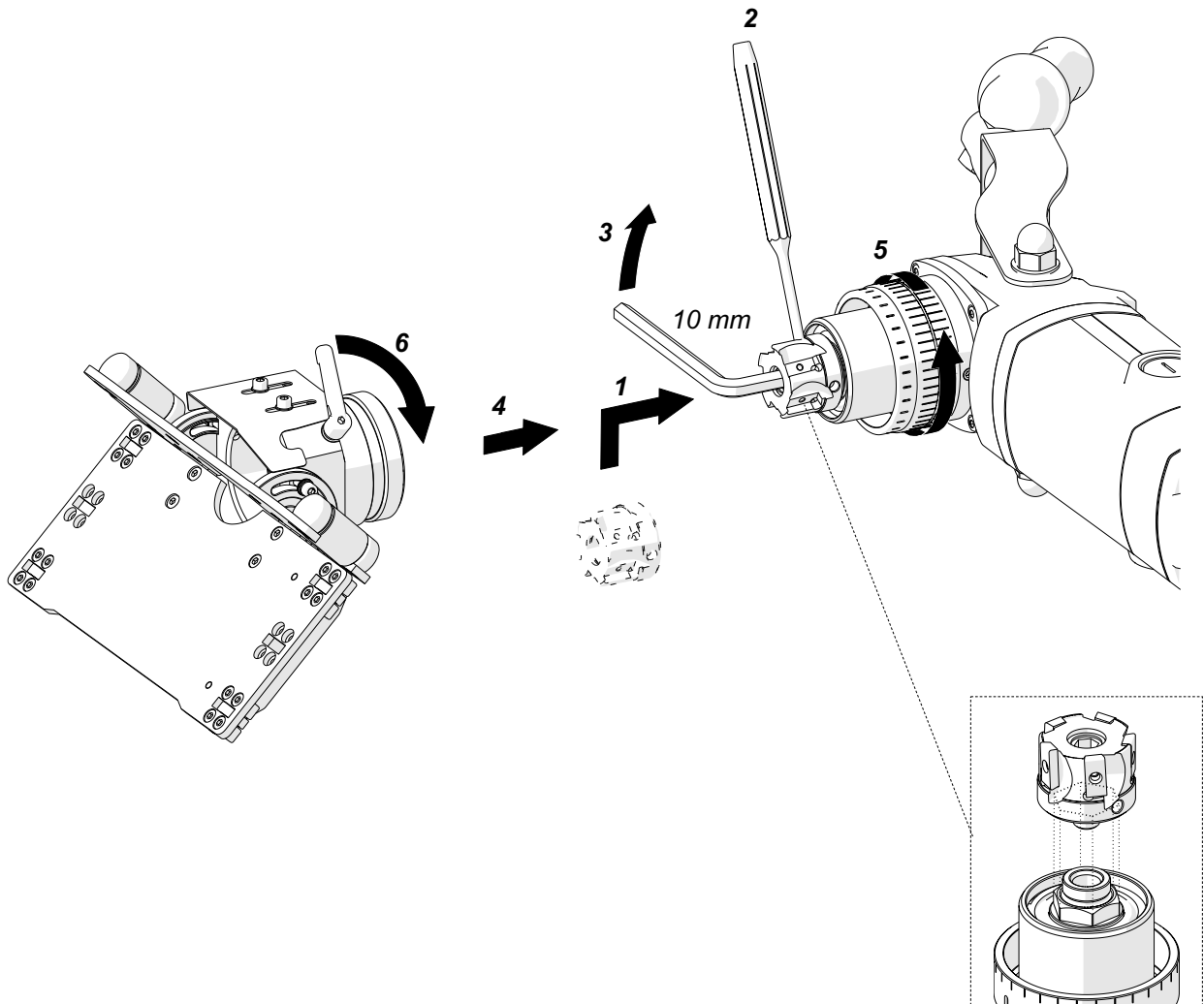
Before disassembly remove chips from the guides. Failure to do so may result in contamination of thread in the guide unit.

When it is required to disassemble the guide unit proceed as below.

Unplug the power cord. Position the machine in such way that the head is horizontal. Release the lever (1). Turn the bevel depth knob (2) to extend the guide assembly as far as it will go. Remove the guide unit (3). Insert the tip of MT3 drift (4) into the milling head hole to stabilize it. Use 10 mm wrench to unscrew the milling head fixing screw (5). Remove the milling head from the spindle (6).



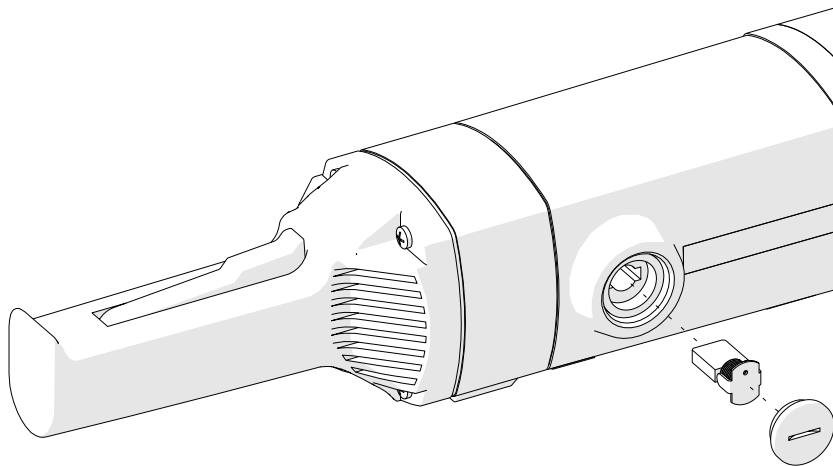
To assemble the head proceed in the opposite sequence as during the disassembly. Make sure that the milling head is aligned with the spindle.



4.17. Replacing the brushes

Every 200 work hours check the condition of the brushes. To do this, unplug the power cord and then remove the cap and the brush. If the brush is shorter than 10 mm (0.4"), replace both brushes with new ones.

Perform assembly in the opposite sequence. Then let the motor operate with no load for 20 minutes.

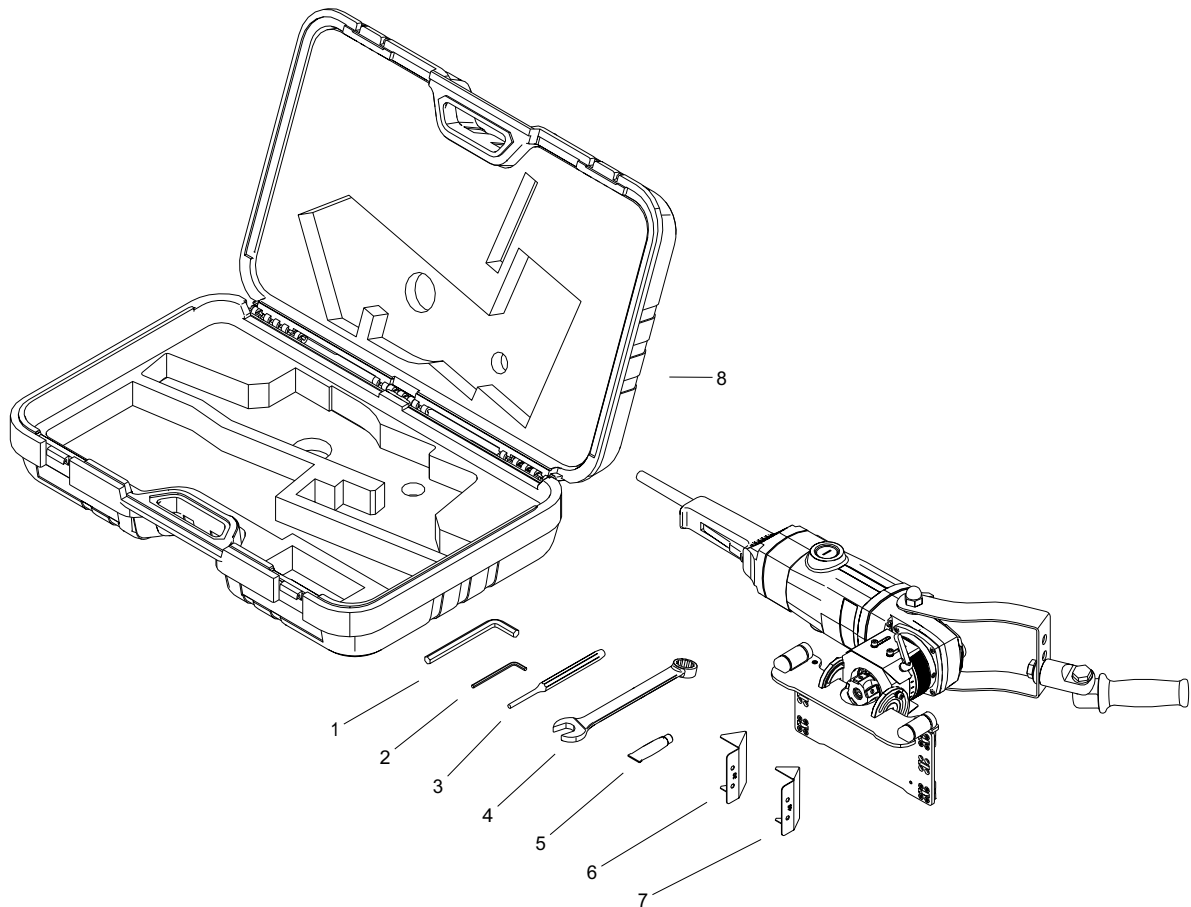


4.18. Cleaning

Clean the beveling machine after work. Position the machine so that the head is horizontal and remove chips with use of soft brush.

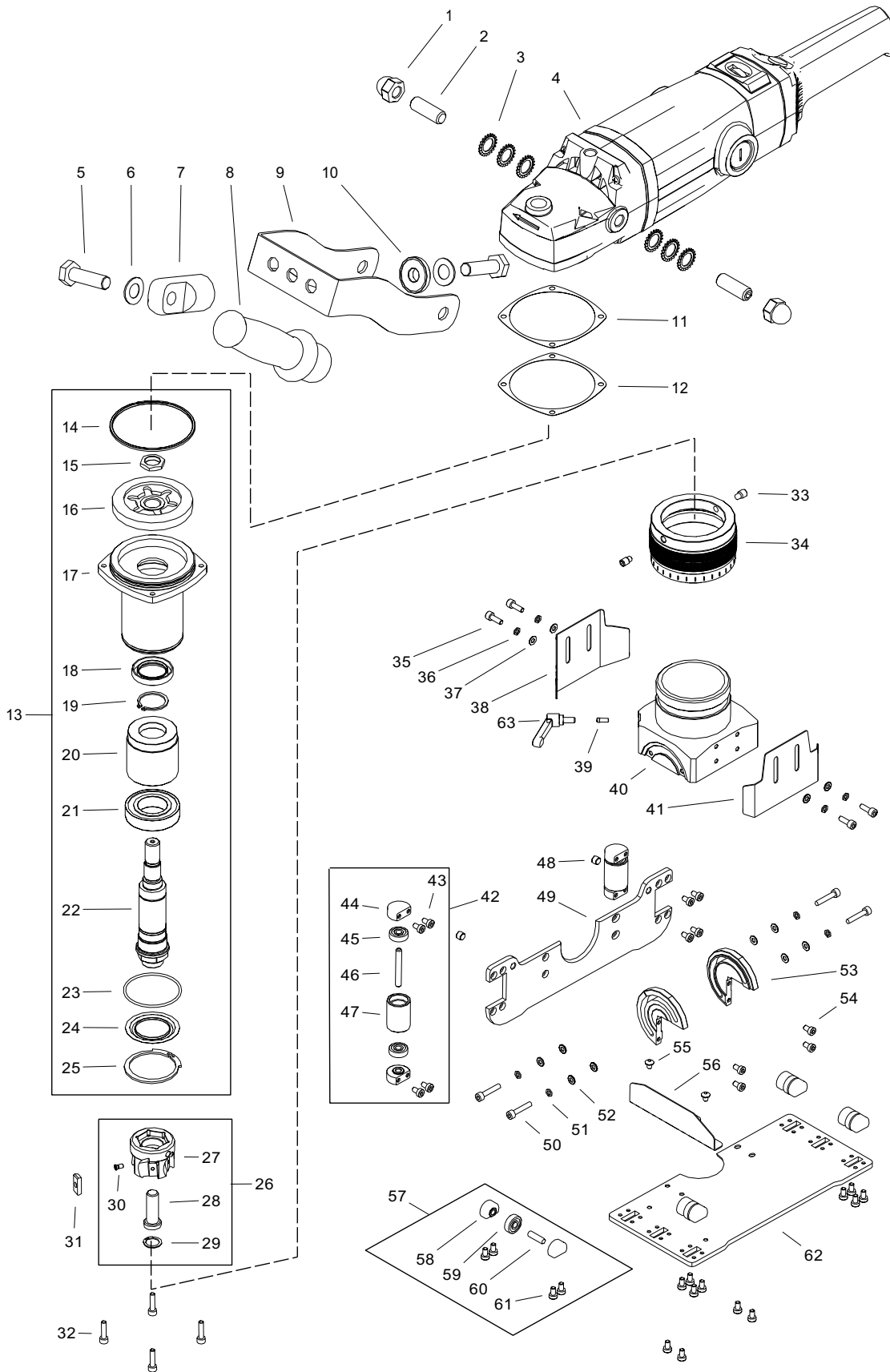
Clean the machine body with soft, lint-free cloth, without any chemical agents.

5. EXPLODED VIEWS AND PARTS LISTS



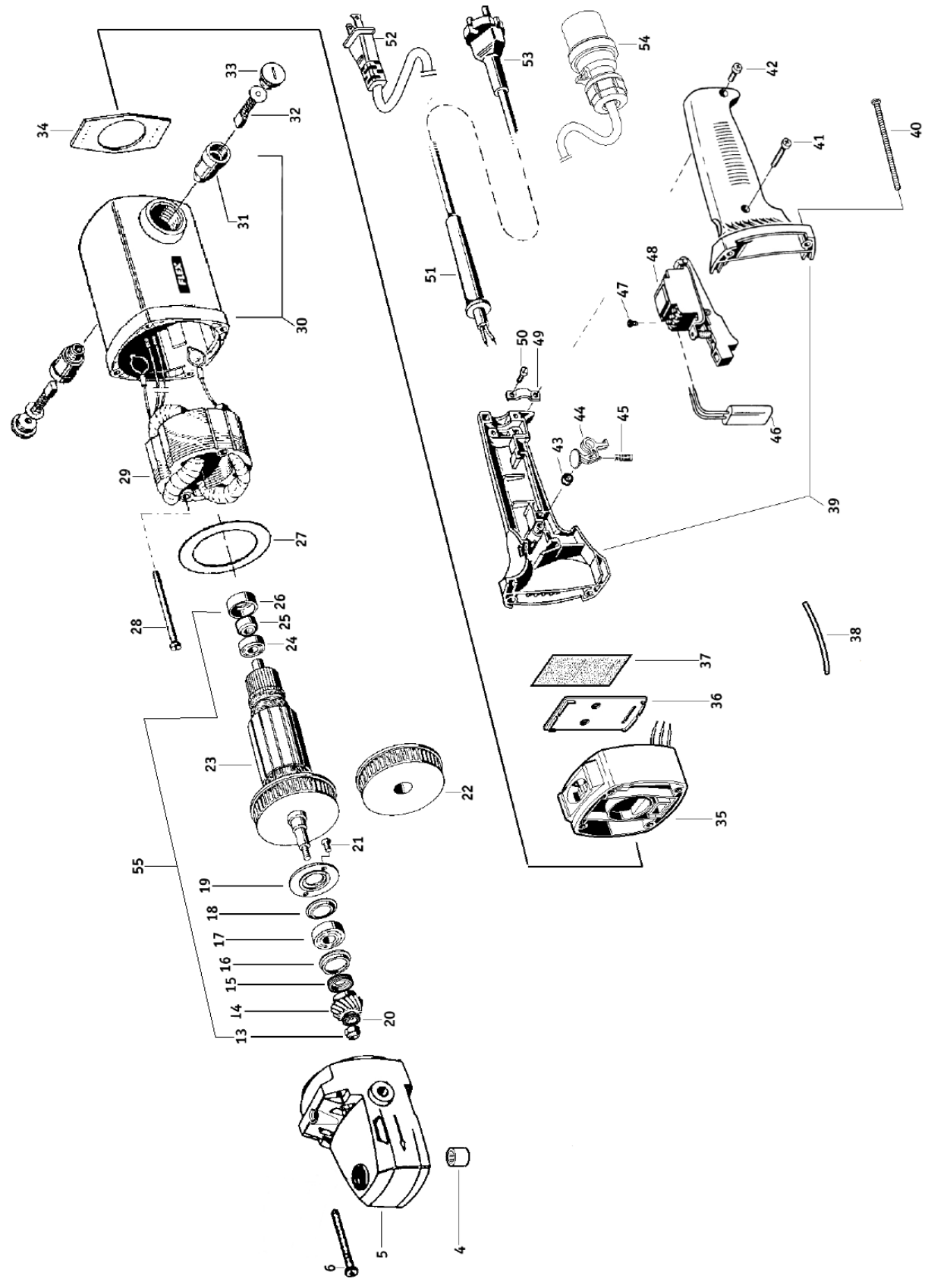
ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	KLC-000004	HEX WRENCH 10 MM	1
2	KLC-000007	HEX WRENCH 4 MM	1
3	WBJ-000003	DRIFT	1
4	KLC-000091	COMBINATION WRENCH 22MM	1
5	SMR-000005	GREASE FOR SCREWS	1
6	OSL-0715-10-00-00-0	COVER 2 30°	1
7	OSL-0715-09-00-00-0	COVER 2 45°	1
8	SKR-000024	PLASTIC BOX	1
9*	KLC-000094	WRENCH 15IP	1

*not shown in the drawing



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	NKR-000219	CAP NUT M14	2
2	WKR-000574	HEX SOCKET SET SCREW WITH FLAT POINT M14x40	2
3	PDK-000304	EXTERNAL TOOTH LOCK WASHER 15	6
4	NPD-0680-00-00-00-0	MOTOR ASSY 230V	1
5	SRB-000517	FULL THREAD HEX HEAD SCREW M14x1.5x45	2
6	PDK-000306	SPRING WASHER B14	2
7	LCZ-0715-15-00-00-0	CONECTING ROD	1
8	RKJ-0715-14-00-00-0	HANDLE	1
9	WSP-0715-17-00-00-0	HANDLE BRACKET	1
10	DCS-0715-16-00-00-0	CONNECTING ROD WASHER	1
11	PDK-000187	DISTANCE WASHER 0.2	1
12	PDK-000188	DISTANCE WASHER 0.3	1
13	ZSP-0715-01-00-00-0	SPINDLE ASSY	1
14	PRS-000286	SEAL RING 80x3	1
15	NKR-0509-01-05-00-0	LOCKING NUT	1
16	KOL-0509-01-04-00-0	GEAR z53	1
17	TLJ-0715-01-01-00-0	SPINDLE SLEEVE	1
18	PRS-000285	A-RING SEAL RING 28x42x7	1
19	PRS-000019	EXTERNAL RETAINING RING 28z	1
20	TLJ-0715-01-03-00-0	DISTANCE SLEEVE	1
21	LOZ-000049	BALL BEARING 30x55x13	1
22	WRZ-0715-01-02-00-0	SPINDLE	1
23	PRS-000275	SEAL RING 54x2.5	1
24	PRS-000342	BEARING COVER 35x55x2.5	1
25	PRS-000343	INTERNAL RETAINING RING 55w	1
26	GLW-0715-19-00-00-0	MILLING HEAD ASSY	1
27	GLW-000052	MILLING HEAD	1
28	SRB-0715-19-01-00-0	MILLING HEAD SCREW	1
29	PRS-000381	INTERNAL RETAINING RING 18w	1
30	WKR-000577	MILLING INSERT SCREW	5
31	PLY-000756	MILLING INSERT	5
32	SRB-000086	HEX SOCKET HEAD CAP SCREW M5x20	4
33	WKR-000315	HEX SOCKET SET SCREW WITH DOG POINT M8x12	2
34	NKR-0715-03-00-00-0	SLIDING SLEEVE	1
35	SRB-000081	HEX SOCKET HEAD CAP SCREW M5x14	4
36	PDK-000044	SPRING WASHER 5.1	4
37	PDK-000018	ROUND WASHER 5.3	4
38	OSL-0715-08-00-00-0	COVER 1	1
39	TRZ-0715-18-00-00-0	LOCKING PIN	1
40	KRP-0715-02-00-00-0	GUIDES BODY	1
41	OSL-0715-07-00-00-0	COVER 2	1
42	RLK-0715-11-00-00-0	VERTICAL ROLLER ASSY	2
43	SRB-000516	LOW HEAD SOCKET CAP SCREW M5x8	4
44	WSP-0715-11-01-00-0	VERTICAL ROLLER BRACKET	2
45	LOZ-000231	BALL BEARING 6x19x6	2
46	KLK-000064	DOWEL PIN 6n6x45	1
47	RLK-0715-11-02-00-0	ROLLER	1
48	WKR-000031	HEX SOCKET SET SCREW WITH FLAT POINT M8x6	2
49	PRW-0715-06-00-00-0	VERTICAL GUIDE	1
50	SRB-000253	HEX SOCKET HEAD CAP SCREW M5x25	4
51	PDK-000044	SPRING WASHER 5.1	4

ITEM	PART NUMBER	DESCRIPTION	Q-TY
52	PDK-000018	ROUND WASHER 5.3	8
53	WSP-0715-04-00-00-0	GUIDE SUPPORT	2
54	SRB-000516	LOW HEAD SOCKET CAP SCREW M5x8	8
55	WKR-000572	HEX SOCKET BUTTON HEAD SCREW M5x6	2
56	OSL-0715-13-00-00-0	COVER 3	1
57	RLK-0715-12-00-00-0	HORIZONTAL ROLLER ASSY	4
58	WSP-0715-12-01-00-0	ROLLER BRACKET	2
59	LOZ-000231	BALL BEARING 6x19x6	1
60	KLK-000060	DOWEL PIN 6n6x20	1
61	SRB-000516	LOW HEAD SOCKET CAP SCREW M5x8	4
62	PRW-0715-05-00-00-0	VERTICAL GUIDE	1
63	RKJ-000037	HANDLEVER M6-12	1



	NPD-0680-00-00-00-3	MOTOR ASSY 110V (US)	
	NPD-0680-00-00-00-0	MOTOR ASSY 230V (CEE)	
	NPD-0680-00-00-00-4	MOTOR ASSY 110V (UK)	
	NPD-0680-00-00-00-1	MOTOR ASSY 230V (INDIA)	
	NPD-0680-00-00-00-2	MOTOR ASSY 230V (AU)	
ITEM	PART NUMBER	DESCRIPTION	Q-TY
4	LOZ-000133	SLIDE SLEEVE HK 1512	1
5	KRP-0680-03-00-00-1	GEAR BODY	1
6	SRB-000338	HEAD SCREW TX25 M5x45	4
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-0680-06-00-00-0	ROTOR 230V	1
23	WRN-0680-05-00-00-0	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-0680-08-00-00-0	STATOR 230V	1
29	STN-0680-07-00-00-0	STATOR 110V	1
30	ZSP-0680-11-00-00-0	STATOR HOUSING 230V	1
30	ZSP-0680-10-00-00-0	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	MDL-0680-80-02-00-0	ROTATIONAL SPEED CONTROLLER UNIT 230V	1
35	MDL-0680-80-01-00-0	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	RKJ-0680-99-03-00-0	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

	NPD-0680-00-00-00-3	MOTOR ASSY 110V (US)	
	NPD-0680-00-00-00-0	MOTOR ASSY 230V (CEE)	
	NPD-0680-00-00-00-4	MOTOR ASSY 110V (UK)	
	NPD-0680-00-00-00-1	MOTOR ASSY 230V (INDIA)	
	NPD-0680-00-00-00-2	MOTOR ASSY 230V (AU)	
ITEM	PART NUMBER	DESCRIPTION	Q-TY
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-0680-09-00-01-0	POWER CORD AWG 16/2 SJ 120 (US)	1
53	PWD-0680-04-00-00-0	POWER CORD H07RN-F 2x1Qx4M	1
54	PWD-0680-09-00-02-0	POWER CORD WITH PLUG BS 4343	1
55	WRN-0680-99-01-00-0	ROTOR ASSY – 120V	1
55	WRN-0680-99-02-00-0	ROTOR ASSY – 230V	1
56*	PWD-0212-10-02-00-6	POWER CORD 230V 3x1.5 WITH STRAIN RELIEF ASSY (INDIA)	1
57*	PWD-0509-99-00-00-0	POWER CORD 230V ASSY (JAPAN)	1

6. DECLARATION OF CONFORMITY

Declaration of conformity

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

We declare with full responsibility that:

BM-25 Beveling Machine

is manufactured in accordance with the following standards:

- EN ISO 12100: 2010,
- EN 62841-1: 2015,
- EN 55014-1: 2017

and satisfies safety regulations of guidelines: 2014/30/EU, 2006/42/EC, 2011/65/EU.

The person authorised to compile the technical file:

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



Białystok, 13 May 2022

Chairman
Wiktor Marek Siergiej

7. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the BM-25 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 tools as well as damage or wear that arise from misuse, accident, tampering or any other causes not related to defects in workmanship or material.

Serial number

Date of sale

Signature and stamp of the seller

0.02 / 28 September 2022

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