

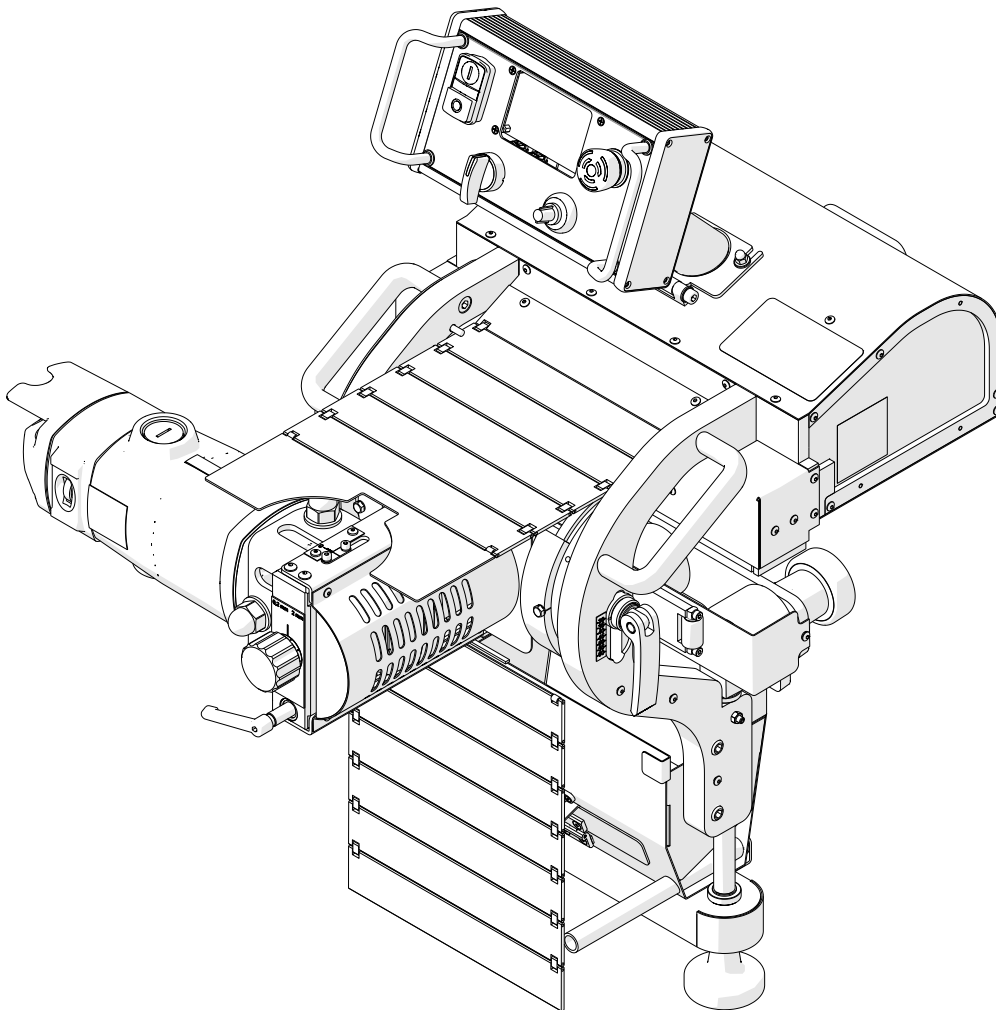


The tools of innovation.

OPERATOR'S MANUAL

AUTO FEED BEVELING MACHINE

ABM-30



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1. GENERAL INFORMATION

1.1. Application

The ABM-30 automatic feed beveling machine is designed to bevel long carbon steel sheets that are attached to a work table or supports.

The machine allows for beveling in two directions at angles ranging from -70° to 70° and at the bevel width of up to 1.18" (30 mm). It is also capable of facing in both directions with the milling head depth of 0.04" (1 mm).

1.2. Technical data

Voltage	1~ 110-120 V, 50/60 Hz 1~ 200-240 V, 50/60 Hz
Power	2200 W
Spindle rotational speed (without load)	1800-5850 rpm
Feed speed	0–6.5 ft/min (0-2 m/min)
Bevel angle (β , Fig. 1)	From -70° to 70°*
Maximum bevel width (b , Fig. 1)	1.18" (30 mm)
Sheet thickness	0.3–2.3" (8-60 mm)
Protection level	IP 20
Protection class	I
Required ambient temperature	40-104°F (5-40°C)
Weight	94.8 lbs (43 kg)

*) Incl. 0° for maximum depth of 0.04" (1 mm) and sheet thickness up to 1.18" (30 mm)

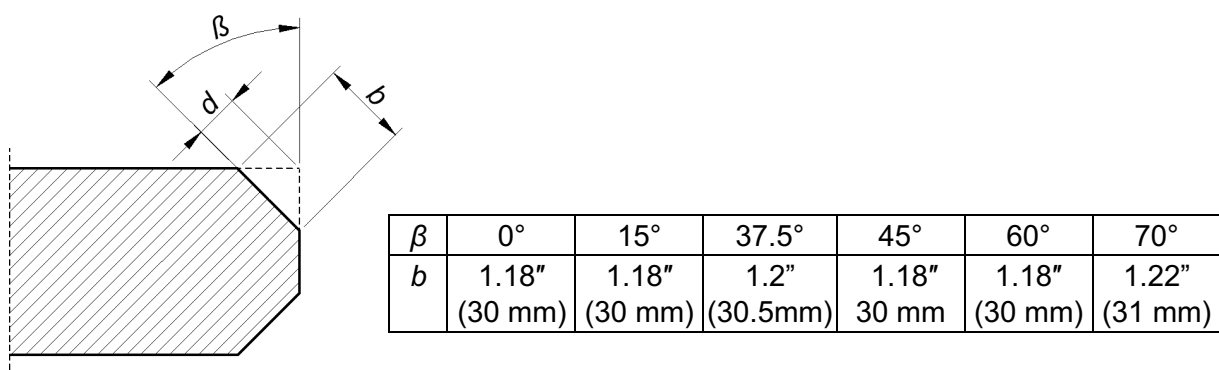
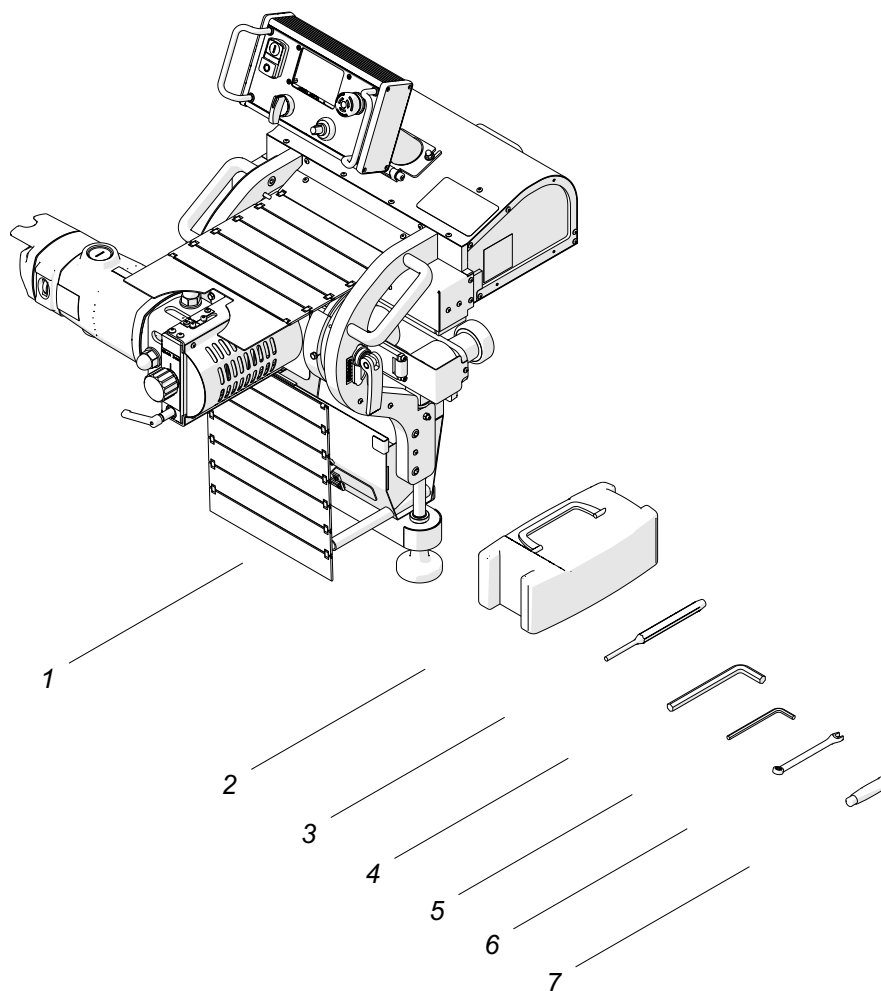


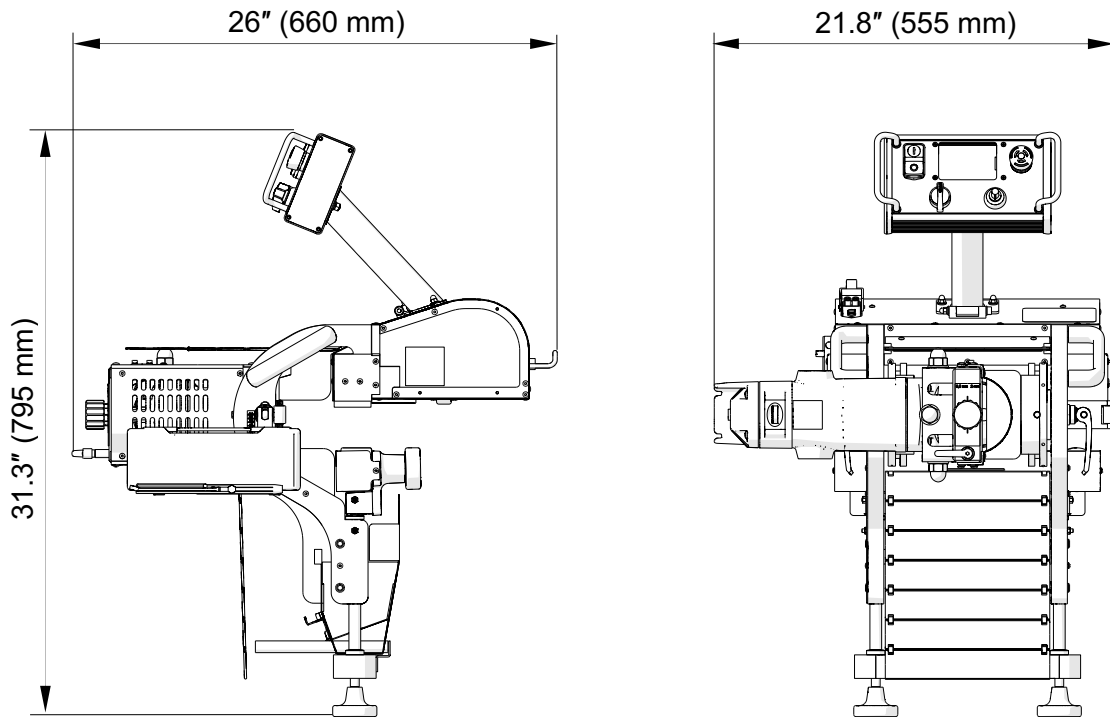
Fig. 1. Bevel dimensions; maximum bevel width depending on the angle

1.3. Equipment included

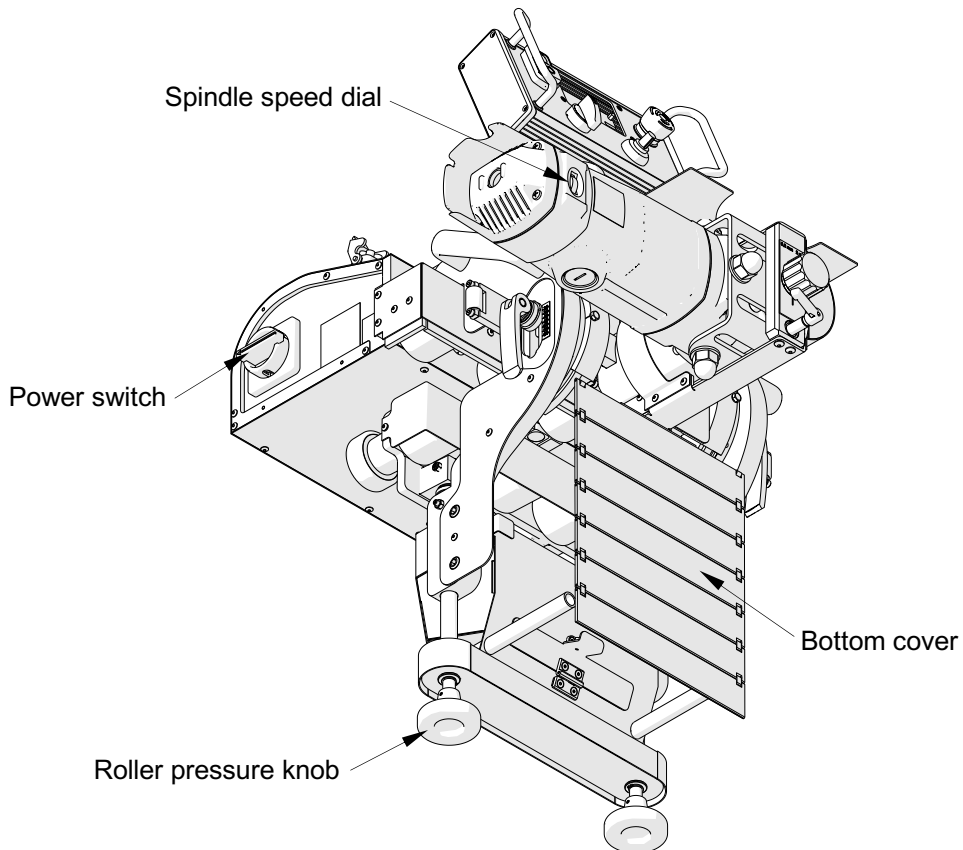
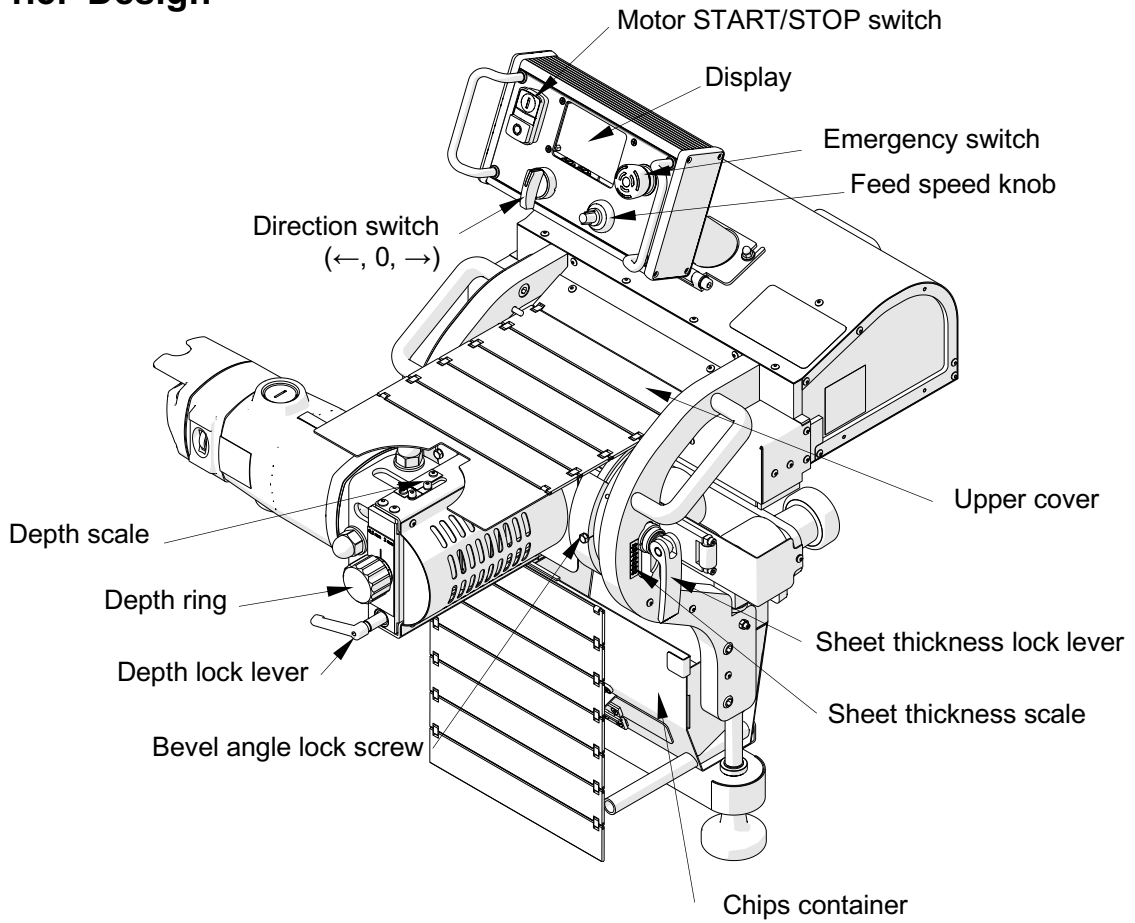


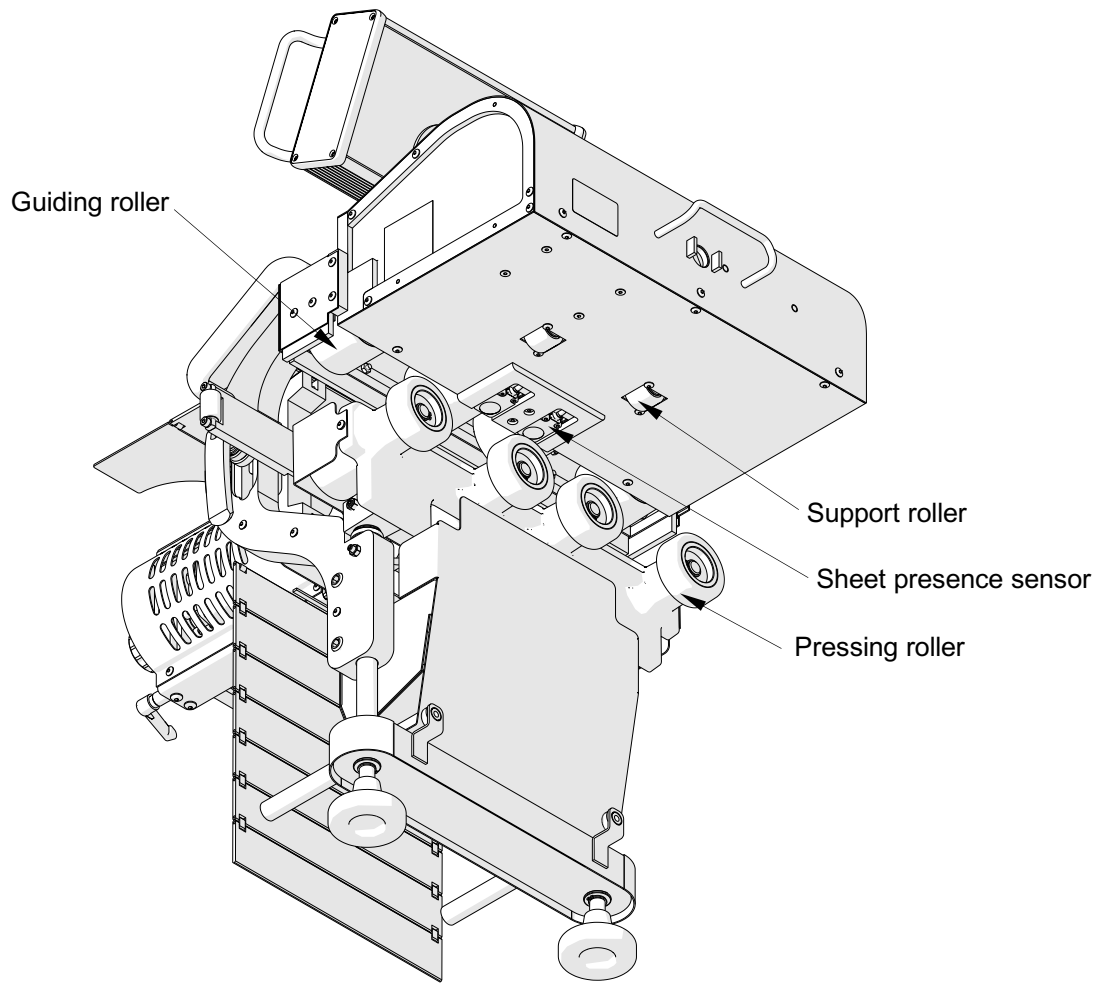
1	Beveling machine (with a milling head and 5 cutting inserts)	1 unit
2	Tool box	1 unit
3	Drift	1 unit
4	10 mm hex wrench	1 unit
5	3 mm hex wrench	1 unit
6	8 mm combination wrench	1 unit
7	Grease for screws Molykote 1000 (5 g, 0.17 oz)	1 unit
-	Operator's Manual	1 unit

1.4. Dimensions



1.5. Design





2. SAFETY PRECAUTIONS

1. The operator's health and qualifications must allow for safe operation of the machine.
2. The machine must be operated by trained persons only.
3. Before use, read this Operator's Manual and complete a training in occupational health and safety.
4. Use only in applications specified in this Operator's Manual.
5. Make sure that the machine has all parts and that they are genuine and not damaged.
6. Make sure that the specifications of the power source are the same as those specified on the rating plate.
7. Connect the machine to the correctly grounded power source.
8. Do not pull the cables. This can cause damage and electric shock.
9. Keep untrained persons away from the machine.
10. Before each use, ensure the correct condition of the machine, power source, cables, plugs, control parts, display, and tools.
11. 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.
12. Keep the machine dry. Do not expose the machine to rain, snow, or frost.
13. Keep the work area well-lit, clean, and free of obstacles.
14. Make sure that the cutting inserts and the milling head are correctly installed. Remove wrenches from the work area before you connect the machine to the power source.
15. Do not use cutting inserts that are dull or damaged.
16. 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.
17. Do not make bevels or machine sheets which parameters differ from those specified in the technical data.
18. Do not feed sheets by hand. This can cause serious injury. Put the machine on the sheet that is attached to a work table or supports. The machine must move along the sheet.
19. Do not use in explosive environments or near the flammable materials.

20. Use eye protection, ear protection, gloves, and protective clothing. The clothing must not be loose.
21. Do not touch chips or moving parts. Do not let anything being caught in the moving parts.
22. Keep your hands away from the rollers.
23. After use, clean the machine, milling head, and rollers with a dry cotton cloth and no chemical agents. Do not remove chips with bare hands.
24. Maintain the machine and install/remove parts and tools only after you unplug the machine from the power source.
25. Repair only in a service center appointed by the seller.
26. If the machine falls, is wet, or has any damage, stop work and immediately send the machine to the service center for check and repair.
27. Do not leave the machine when it operates.
28. If you are not going to use the machine for an extended period, put anti-corrosion material on the steel parts.

3. SYMBOLS

Before using the machine, familiarize yourself with the following symbols:



Read the Operator's Manual



Use eyes protection



Use hearing protection



Use protective gloves



Use protective clothing



Use protective shoes



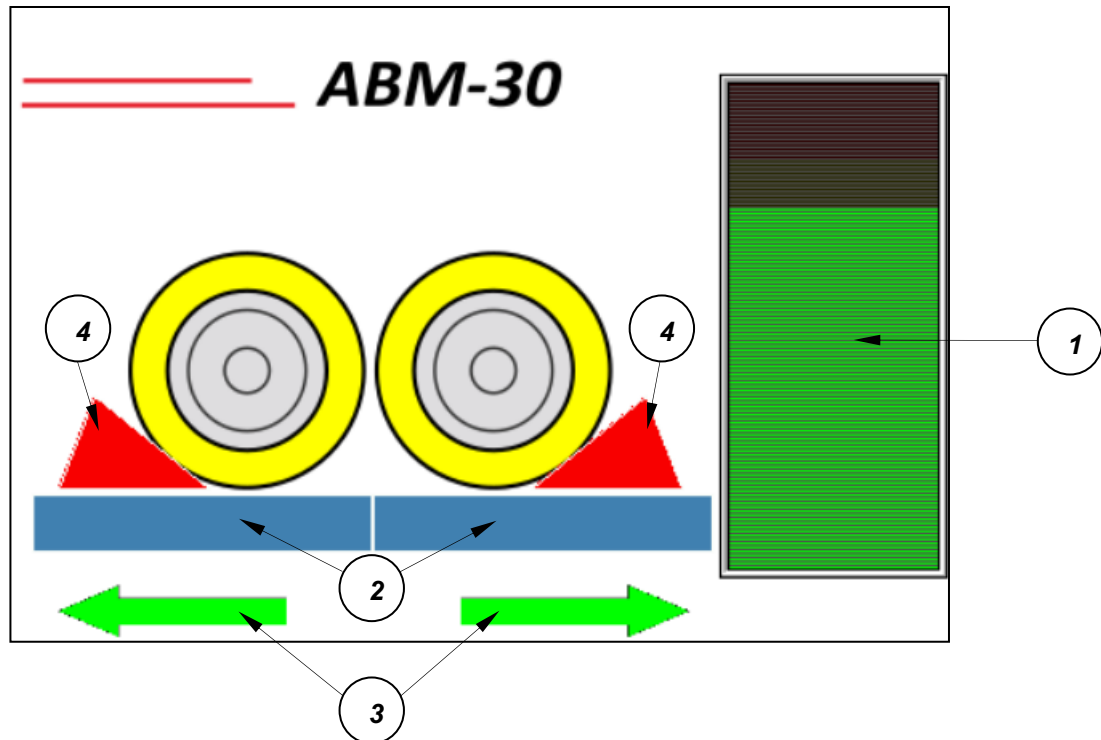
Warning against electric voltage

4. STARTUP AND OPERATION

4.1. Display


The beveling machine is equipped with the display, showing the basic information about the machine operation.

Description of display elements:

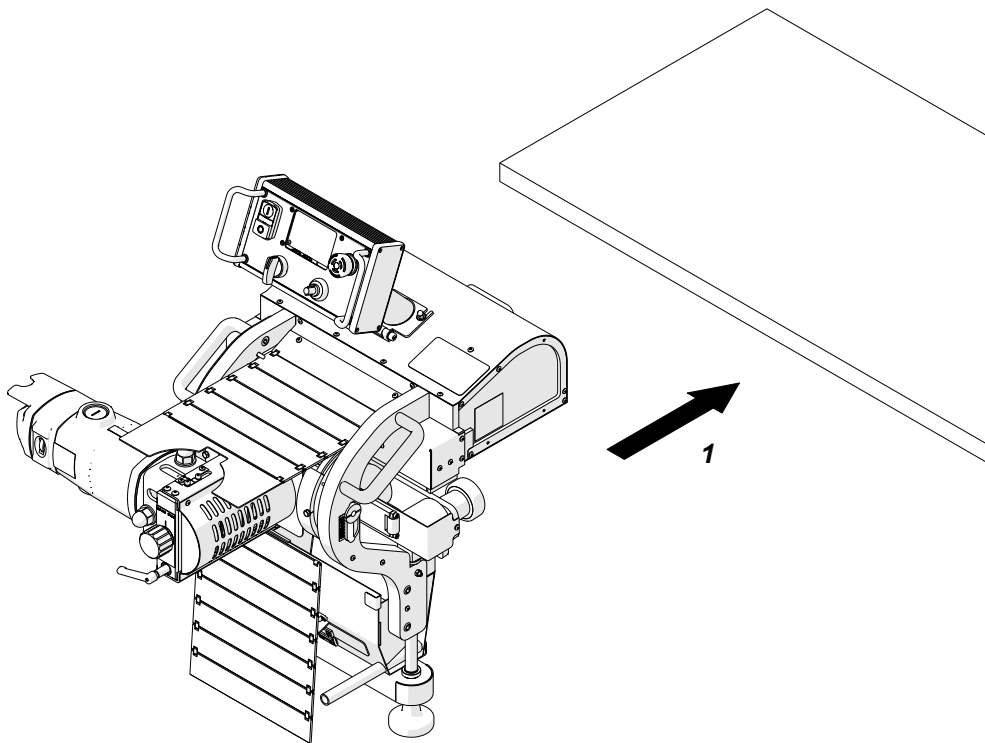


- 1 spindle load indicator
- 2 material detection sensor
- 3 machine feed direction indicator
- 4 machine feed lock indicator

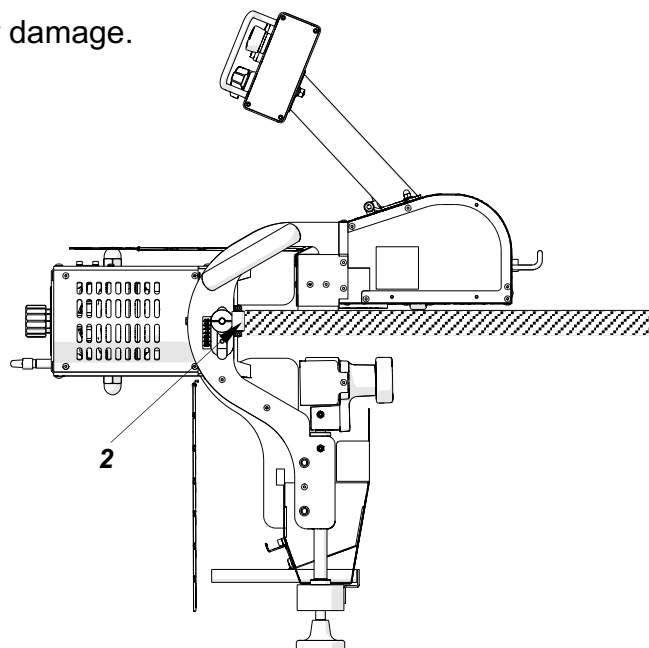
4.2. Putting the machine on the sheet

 Due to machine weight it must be positioned by two persons.
Individual work requires using the accessory trolley.

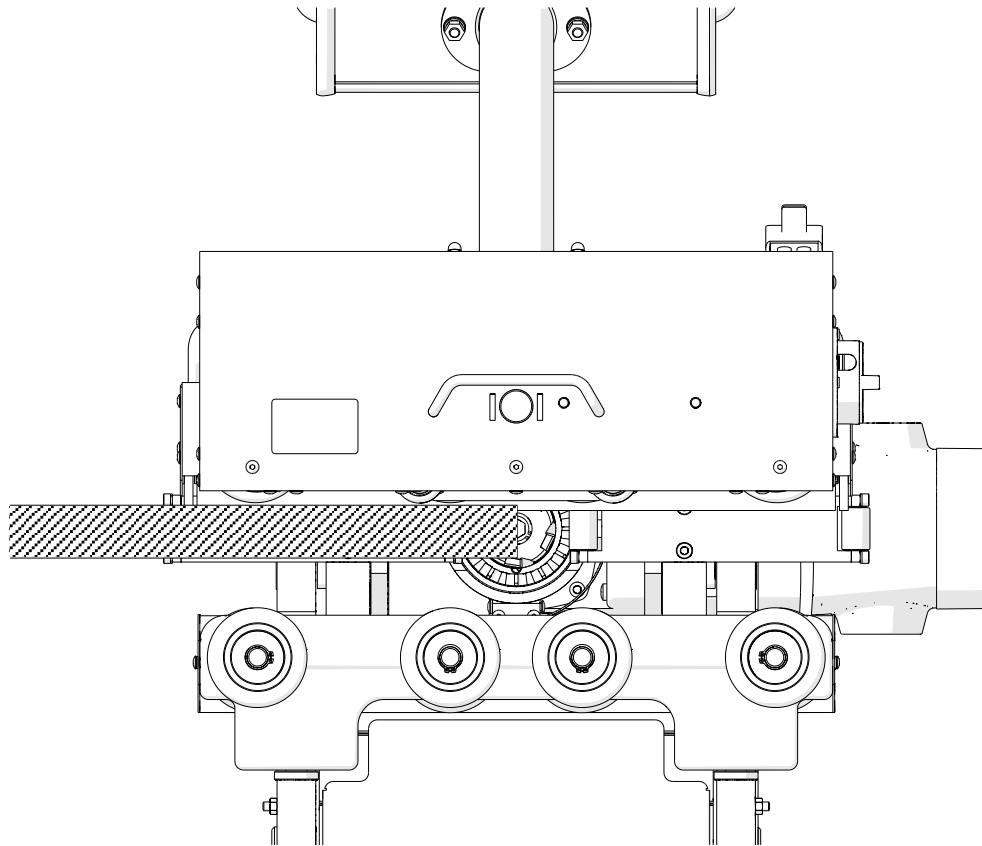
Attach the sheet to a work table or supports. To perform beveling to the right, place the machine on the left side of the sheet.



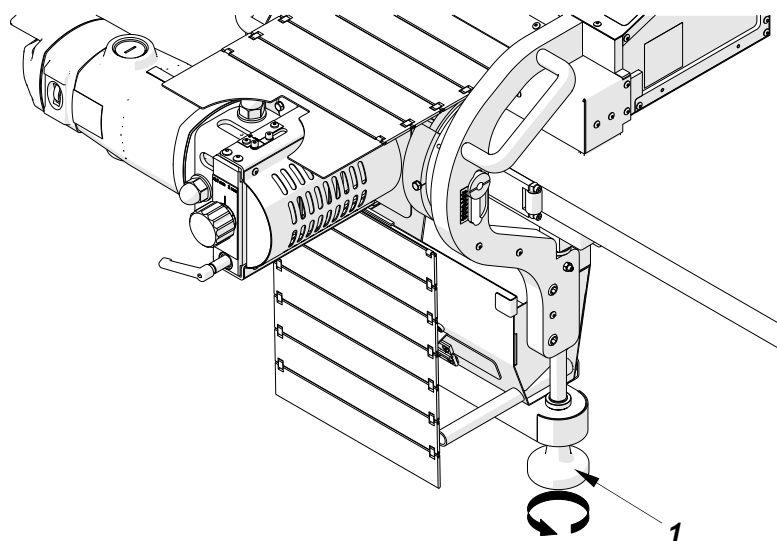
Push the machine in direction indicated by the arrow (1) so the face rollers (2) touch the sheet edge. The head should be retracted to avoid the collision between inserts and sheet and their damage.



The sheet edge should be aligned with the head axis.

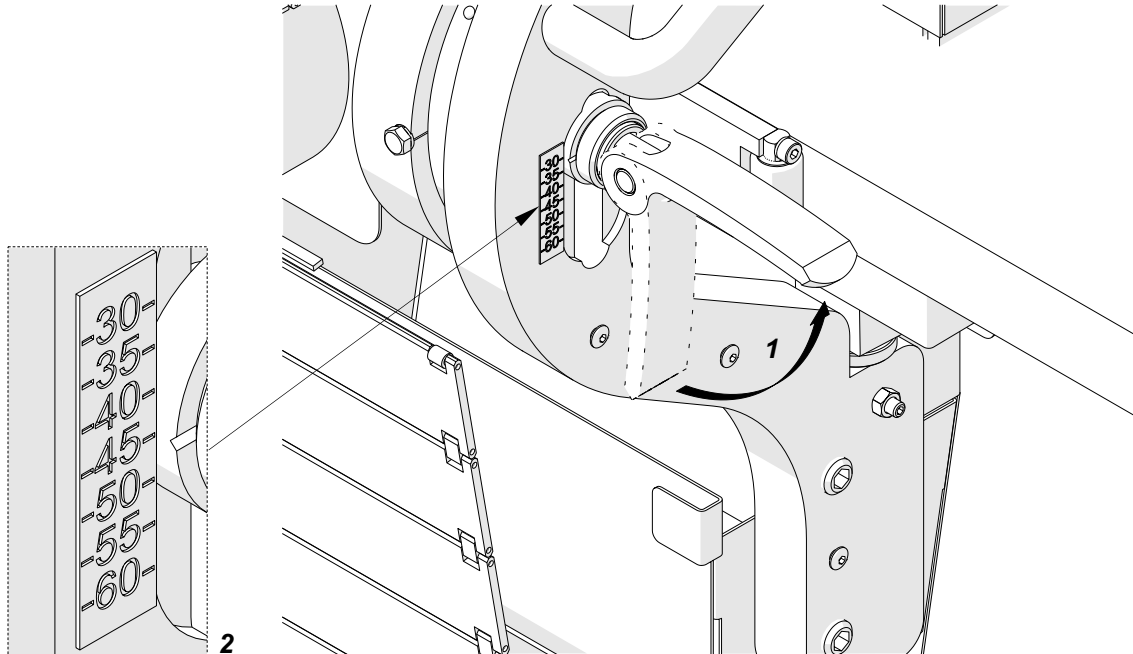


Turn the knob (1) clockwise until you feel resistance. Then tighten it by another 1-1.5 turn. You may use any knob or both of them simultaneously.



4.3. Setting the sheet thickness

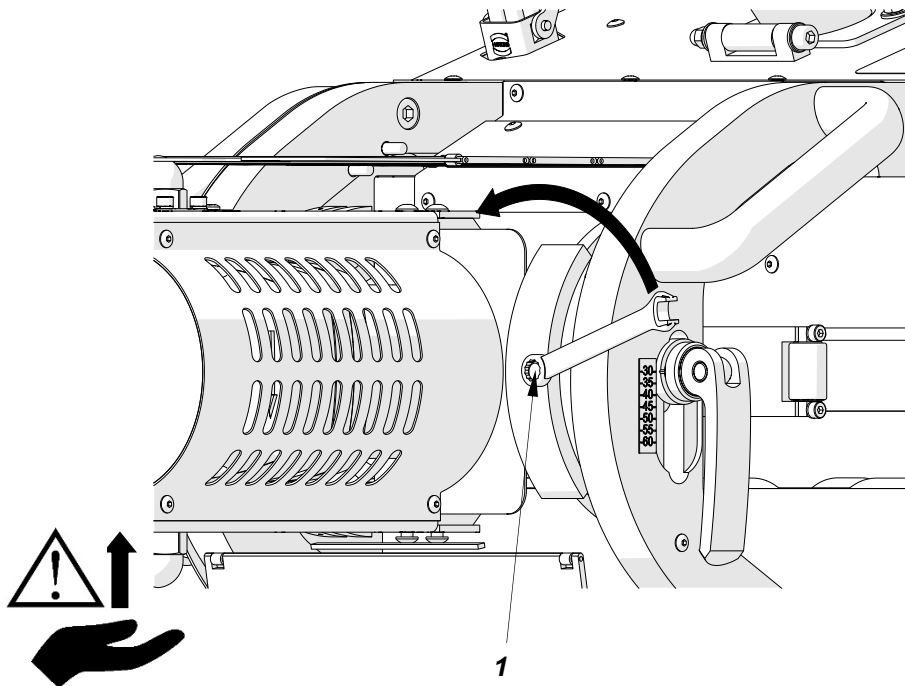
To bevel sheets of thickness of 1.18"-2.36" (30-60 mm) from the bottom, unlock the levers (1) on both sides of the machine. Then, lower the milling unit to set the value of sheet thickness on the scale (2). Lock the levers.



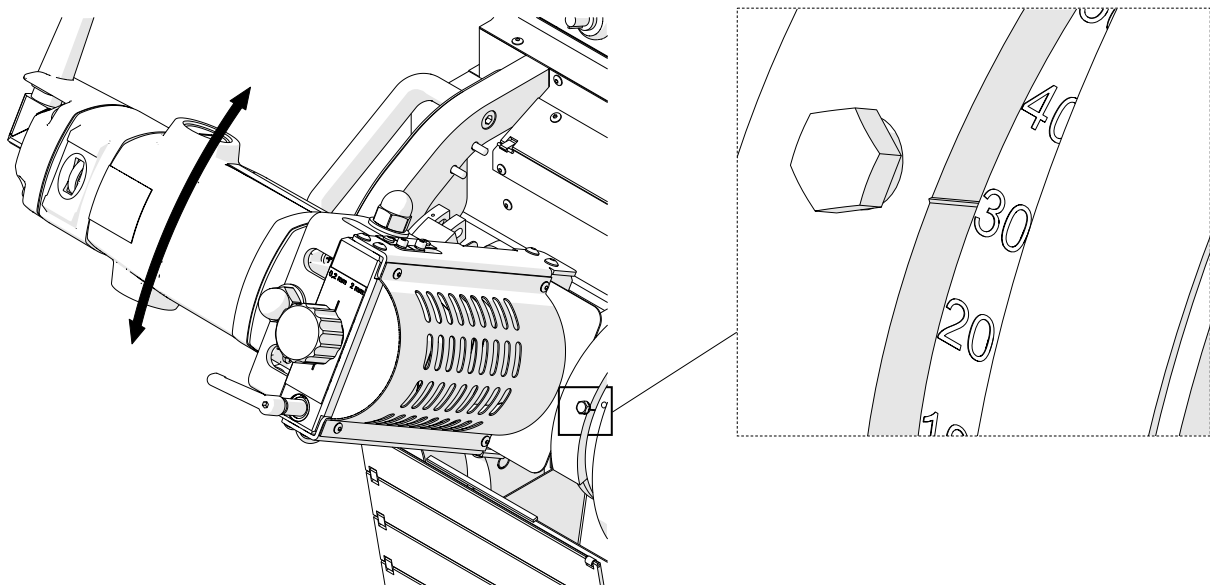
To bevel plates of thickness of 0.31"-2.36" (8-60 mm) from the top, set the value of "30" on the scale.

4.4. Setting the bevel angle

Hold the milling unit with your hand and loosen the bevel angle lock screws (1) with 10 mm flat wrench on both sides of the machine.


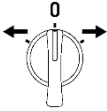
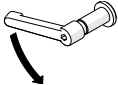


Turn the milling unit to set the required bevel angle on the scale.



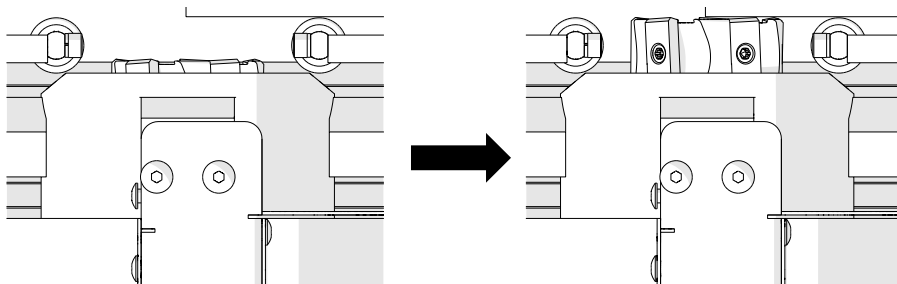
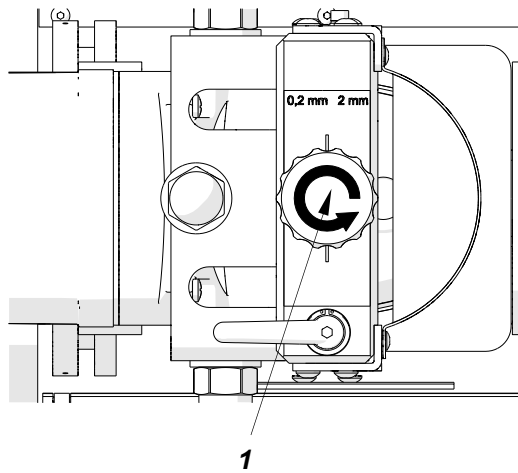
Tighten the loosen screws with 10 mm flat wrench.

4.5. Setting the milling head depth

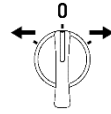
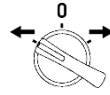
Set the power switch to "1"  Set the direction switch to "0"  . Unlock the depth lock lever  and turn it counterclockwise until a slight resistance is felt.

Press START  to turn on the spindle.

Turn the depth knob (1) counterclockwise until the milling head touches the sheet.



Use the direction switch to set the direction to the left

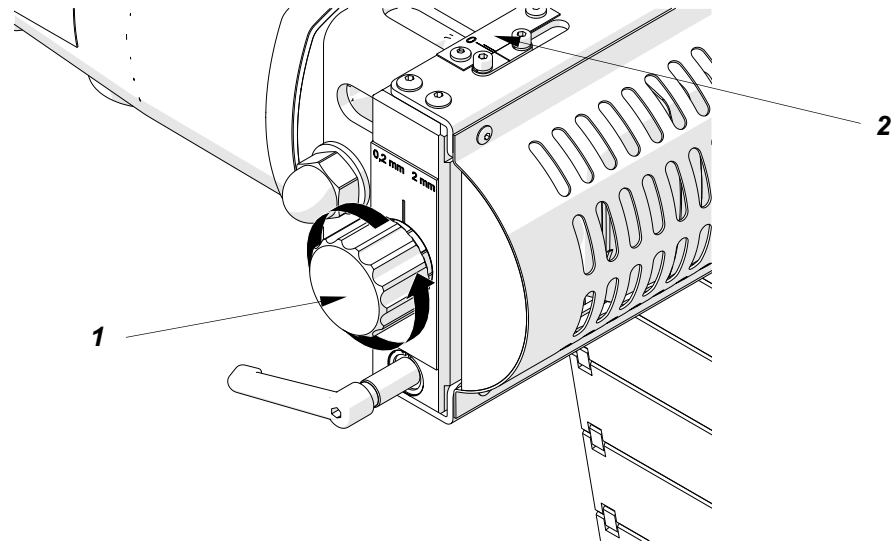


moves behind the sheet, set the direction switch to "0"

. Press STOP



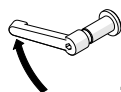
to turn off the spindle. Then, turn the depth knob (1) to set the depth "d" related to the required width "b".



One turn of the knob corresponds to depth of 0.08" (2 mm), which gives 0.008" (0.2 mm) per graduation. The depth value in mm is indicated by the depth scale (2):

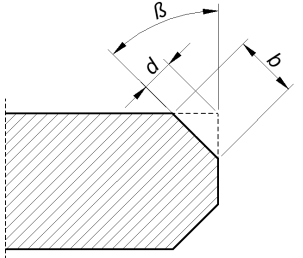


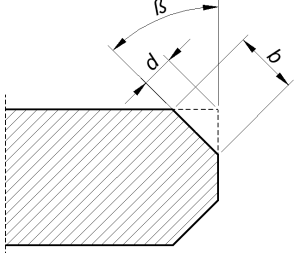
Lock the depth lock lever



, turning it clockwise and tightening.


The table below shows the bevel parameters values:

	Bevel angle (β)					
	15°	30°	37.5°	45°	60°	70°
Depth "d" [mm]	Width "b" [mm]					
0.5	2.0	1.2	1.1	1.0	1.2	1.6
1.0	4.0	2.3	2.1	2.0	2.3	3.1
1.5	6.0	3.5	3.2	3.0	3.5	4.7
2.0	8.0	4.6	4.2	4.0	4.6	6.2
2.5	10.0	5.8	5.3	5.0	5.8	7.8
3.0	12.0	6.9	6.3	6.0	6.9	9.3
3.5	14.0	8.1	7.4	7.0	8.1	10.9
4.0	16.0	9.2	8.4	8.0	9.2	12.4
4.5	18.0	10.4	9.5	9.0	10.4	14.0
5.0	20.0	11.5	10.5	10.0	11.5	15.5
5.5	22.0	12.7	11.6	11.0	12.7	17.1
6.0	24.0	13.8	12.6	12.0	13.8	18.6
6.5	26.0	15.0	13.7	13.0	15.0	20.2
7.0	28.0	16.1	14.7	14.0	16.1	21.7
7.5	30.0	17.3	15.8	15.0	17.3	23.3
8.0		18.4	16.8	16.0	18.4	24.8
8.5		19.6	17.9	17.0	19.6	26.4
9.0		20.7	18.9	18.0	20.7	27.9
9.5		21.9	20.0	19.0	21.9	29.5
10.0		23.0	21.0	20.0	23.0	31.0
10.5		24.2	22.1	21.0	24.2	
11.0		25.3	23.1	22.0	25.3	
11.5		26.5	24.2	23.0	26.5	
12.0		27.6	25.2	24.0	27.6	
12.5		28.8	26.3	25.0	28.8	
13.0		30.0	27.3	26.0	30.0	
13.5			28.4	27.0		
14.0			29.4	28.0		
14.5			30.5	29.0		
15.0				30.0		

	Bevel angle (β)					
	15°	30°	37.5°	45°	60°	70°
Depth "d" [inch]	Width "b" [inch]					
0.02	0.08	0.05	0.04	0.04	0.05	0.06
0.04	0.16	0.09	0.08	0.08	0.09	0.12
0.06	0.24	0.14	0.13	0.12	0.14	0.19
0.08	0.31	0.18	0.17	0.16	0.18	0.24
0.10	0.39	0.23	0.21	0.20	0.23	0.31
0.12	0.47	0.27	0.25	0.24	0.27	0.37
0.14	0.55	0.32	0.29	0.28	0.32	0.43
0.16	0.63	0.36	0.33	0.31	0.36	0.49
0.18	0.71	0.41	0.37	0.35	0.41	0.55
0.20	0.79	0.45	0.41	0.39	0.45	0.61
0.22	0.87	0.50	0.46	0.43	0.50	0.67
0.24	0.94	0.54	0.50	0.47	0.54	0.73
0.26	1.02	0.59	0.54	0.51	0.59	0.80
0.28	1.10	0.63	0.58	0.55	0.63	0.85
0.30	1.18	0.68	0.62	0.59	0.68	0.92
0.31		0.72	0.66	0.63	0.72	0.98
0.33		0.77	0.70	0.67	0.77	1.04
0.35		0.81	0.74	0.71	0.81	1.10
0.37		0.86	0.79	0.75	0.86	1.16
0.39		0.91	0.83	0.79	0.91	1.22
0.41		0.95	0.87	0.83	0.95	
0.43		1.00	0.91	0.87	1.00	
0.45		1.04	0.95	0.91	1.04	
0.47		1.09	0.99	0.94	1.09	
0.49		1.13	1.04	0.98	1.13	
0.51		1.18	1.07	1.02	1.18	
0.53			1.12	1.06		
0.55			1.16	1.10		
0.57			1.20	1.14		
0.59				1.18		



The most accurate method for obtaining the required width of finished bevel is to perform a trial machining and measuring.


4.6. Beveling

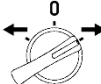
 **The operator’s psychical and physical condition must allow for safe operation of the machine. The operator must remain cautious during work.**

 **Never carry the machine with rotating spindle!**


Connect the cable of the milling unit to the socket on machine body.

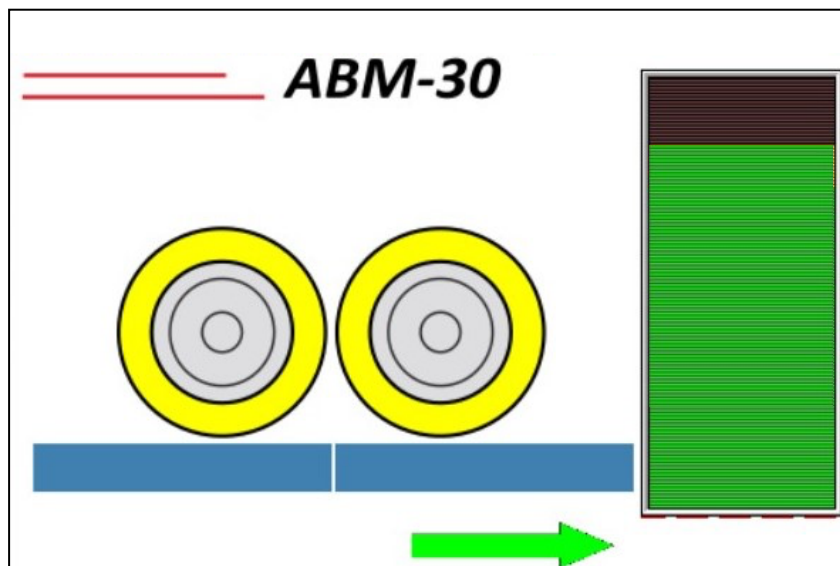
Set the power switch to “1” . Make sure that the emergency switch  is

unlocked. Press START  to turn on the spindle. If you bevel to the right, use the

direction switch to set the direction to the right . Use the spindle speed knob to set the rotational speed to 5-6.

The spindle speed dial allows continuous adjustment of the rotational speed.

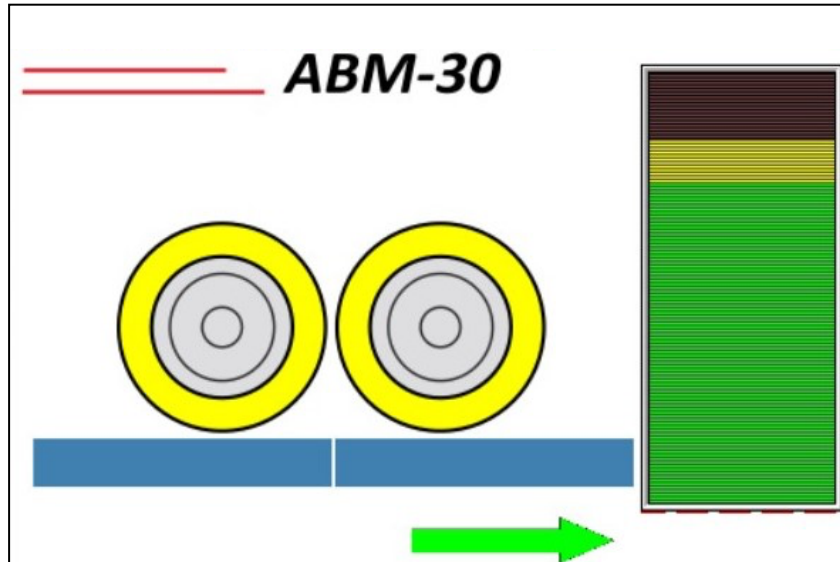
Use the feed speed knob  to set a speed so that the indicator on the display is green.



The correct speeds of the spindle and feed depend on the condition and quantity of material, bevel angle, milling head depth, and condition of the cutting inserts.

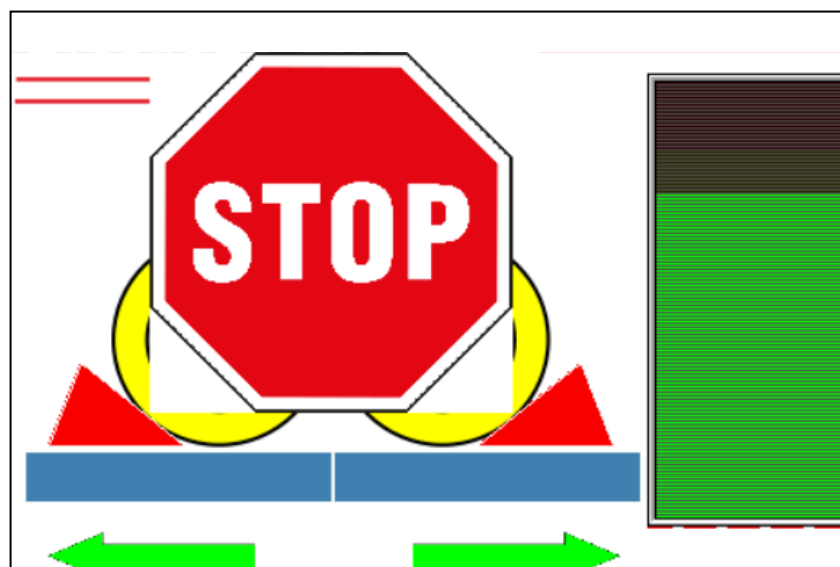
If the speeds are too high or too low for the hardness of material, the inserts will wear faster or will be unable to cut the material.

If the operation is optimal, the load indicator is green. If the machine operates near the overload, the indicator changes to yellow. It is then required to decrease the feed speed to make the indicator green again.

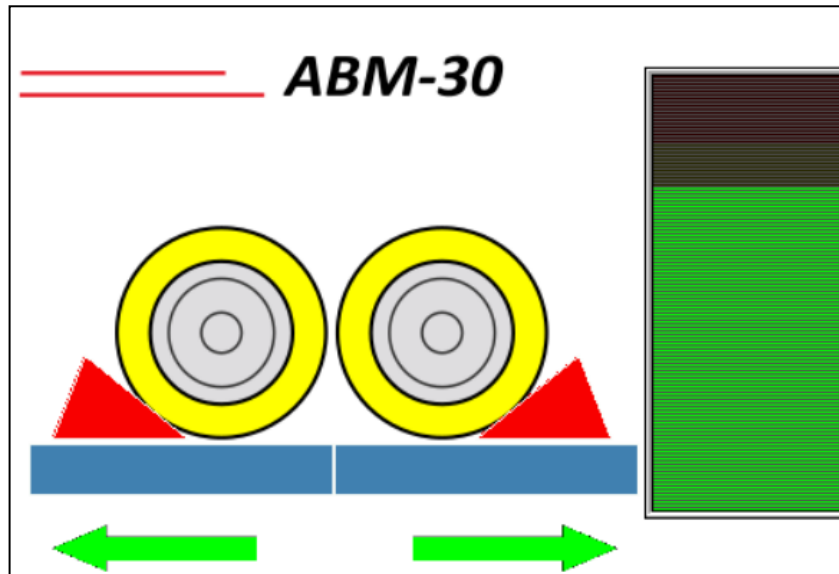


If an overload occurs, the feed stops. This may occur when the bevel width is too large for the hardness of material or when the cutting inserts are dull. Thus, to prevent overload, machine hard materials in multiple passes and replace the inserts before they become dull. Also, take periodic breaks during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

When the spindle rotation is turned off or when the spindle is stopped due to overload, the following screen is displayed:



When the feed motor is overloaded e.g. due to running into an obstacle, the following screen is displayed:




To get the bevel width of 1.18" (30 mm) we recommend doing at least the number of passes shown in the table.

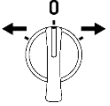

Pass	Bevel angle	15°	30°	37.5°	45°	60°	70°
1	Milling head depth <i>d</i> [mm]	4.5	6.5	7.2	7.5	6.5	5.5
2		+1.75	+2.6	+2.9	+3.0	+2.6	+2.6
3		+1.25	+2.2	+2.4	+2.5	+2.2	+1.6
4		-	+1.7	+1.9	+2.0	+1.7	-

Pass	Bevel angle	15°	30°	37.5°	45°	60°	70°
1	Milling head depth <i>d</i> [inch]	0,18	0,26	0,28	0,30	0,26	0,22
2		+0,07	+0,10	+0,11	+0,12	+0,10	+0,10
3		+0,05	+0,09	+0,09	+0,10	+0,09	+0,06
4		-	+0,07	+0,07	+0,08	+0,07	-

Monitor the travel of the machine near the sheet end. After the beveling is finished, the feed stops.


 In special cases the machine may not stop automatically at the end of the sheet. Therefore it is required to keep it supervised and use the emergency stop when necessary.

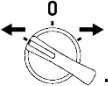
If the perpendicular edge of the plate has a bevel, the feed may stop before the plate end. In such case set the direction switch to "0" and then select the direction again to complete beveling. Then set the direction switch to "0" and press STOP.


To make another pass, press STOP  and unlock the depth lock lever .


Then increase the depth "d" as described before. Lock the depth lock lever .

and press START . If the first pass was to the right, use the direction switch to

set the direction to the left .

Make the successive passes until you get the required bevel parameters.

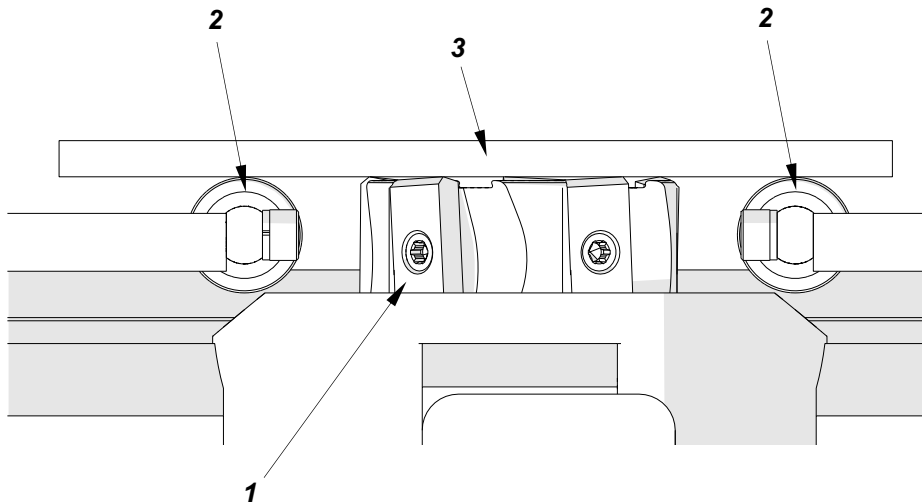
In case of danger press the emergency switch . To start the machine again,

remove the cause of the emergency. Then unlock the switch and press START .

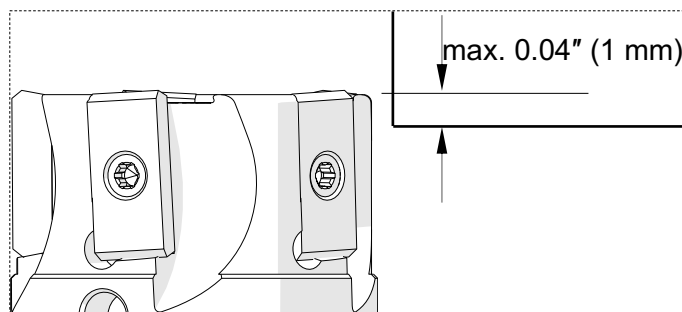
When the work is finished, unplug the power cord. Clean the sheet and sensors. Clean the machine with a dry cotton cloth and no chemical agents.

4.7. Facing

To make the face of the sheet smooth you can do facing with the milling head depth of 0.04" (1 mm). To do this, first equalize the heat position (1) with the face rollers (2) (it corresponds to depth of 0 mm), using e.g. short flat bar (3).



Put the machine on the left side of the sheet. Set the milling head depth to max. 0.04" (1 mm) as described before.



When facing, move the machine from left to right.

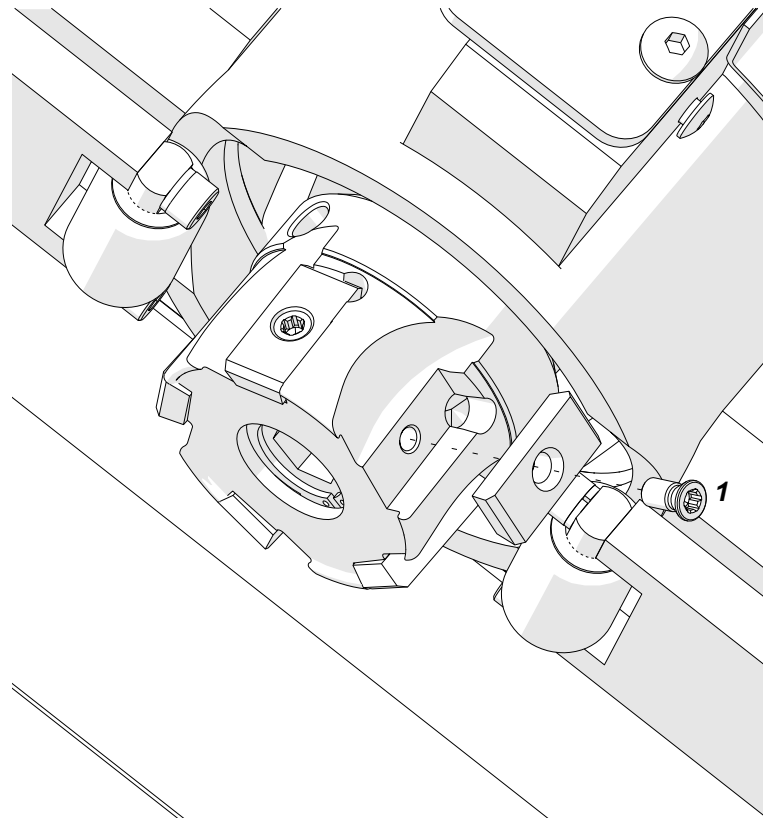
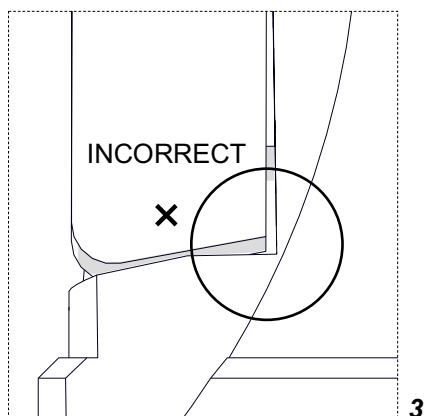
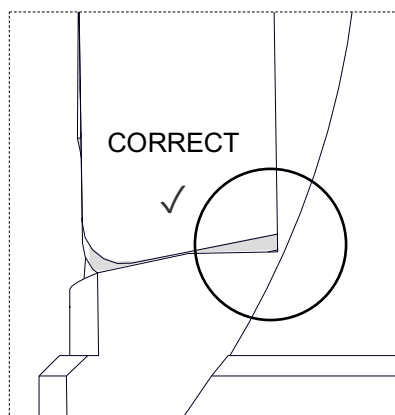


Facing will make the face of the sheet smooth. It will not make the edge straight, if the sheet is curved.

4.8. Replacing the cutting inserts

Unplug the power cord. Use T15 torx screwdriver to remove the cutting inserts (1, 2). Clean the sockets.

To change the cutting edge, remove the inserts and turn them 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 (3).



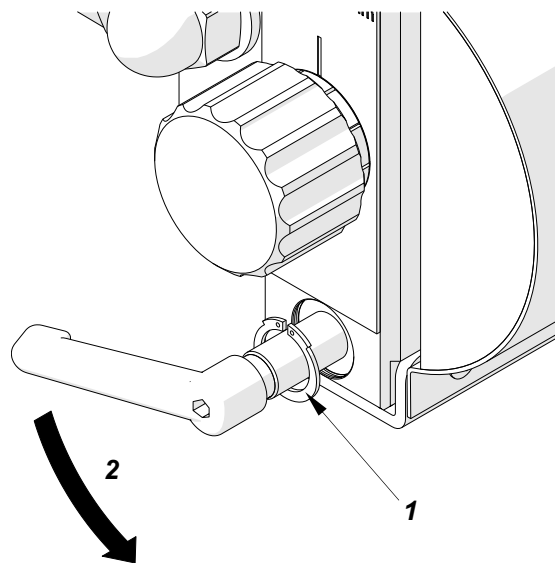
4.9. Removing and installing the milling head



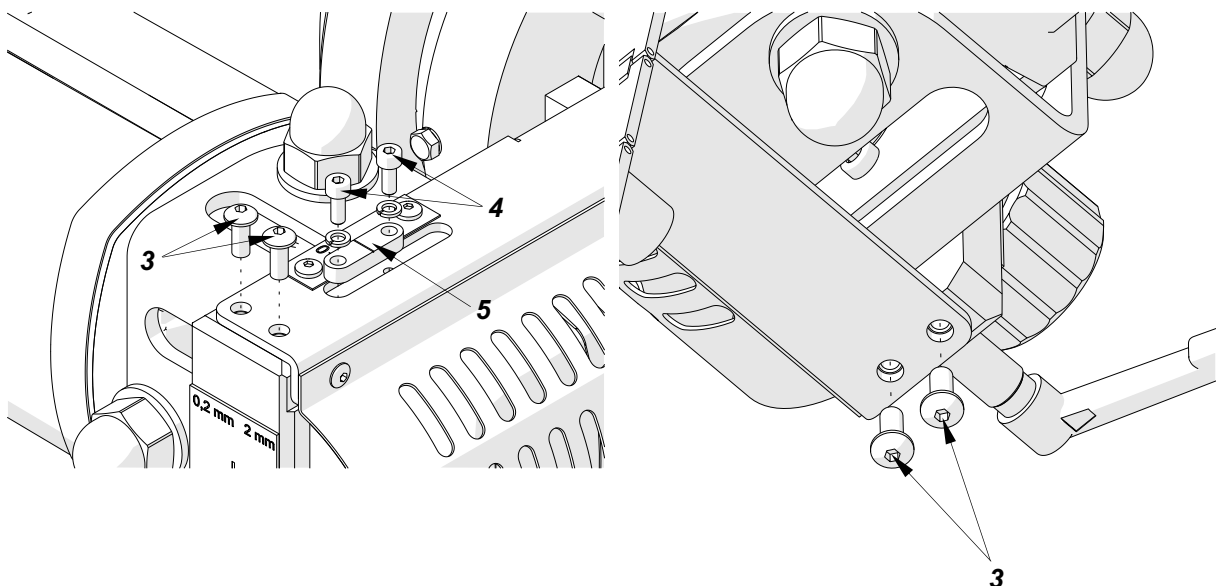
Due to sharp edges it is required to wear the protective gloves during replacement.

Unplug the power cord.

Start the head removal from disconnecting the milling unit from the beveling machine body. To do this, remove the Seeger ring (1) and unscrew the depth lock lever, rotating it counterclockwise (2).

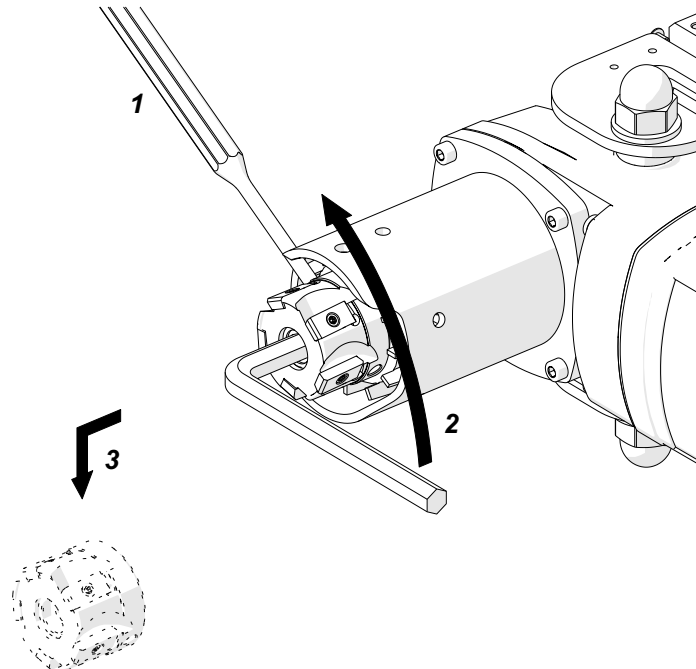


Then remove 4 mushroom head screws (3) at the top and bottom of the milling unit, 2 socket head cap screws (4), and remove the depth indicator (5). Finally remove the milling unit from the body.

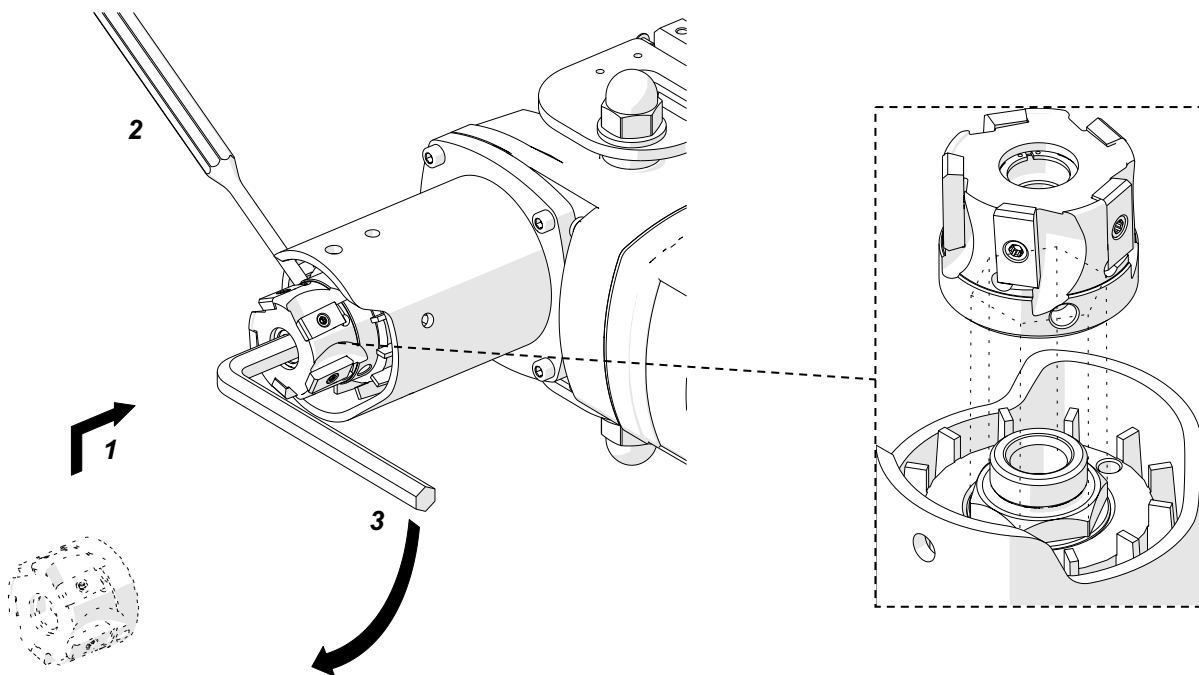


To remove the head proceed as below.

Position the milling unit in such way that the head is horizontal. Insert the tip of drift (1) into the milling head hole to stabilize it. Use 10 mm wrench to unscrew the milling head fixing screw (2). Remove the milling head from the spindle (3).



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



4.10. Milling tools

Part name	Part number
Milling head	GLW-000052
Cutting insert	PLY-000756
Insert screws	WKR-000577

4.11. Wearing parts

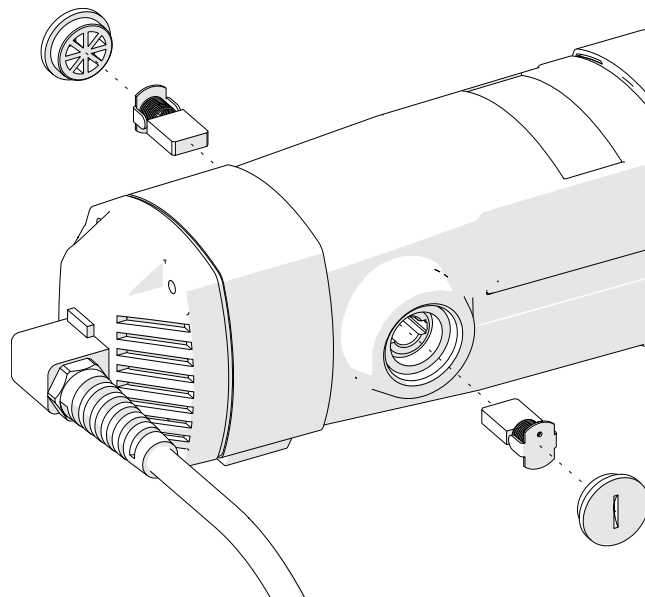
Part name	Part number
Carbon brush	SCZ-000030
Grease for screws	SMR-000005
Drift	WBJ-000003
Hex wrench 5 mm	KLC-000008
Hex wrench 10 mm	KLC-000004

5. MAINTENANCE ACTIVITIES

5.1. Replacing the brushes

Check the condition of the brushes every 200 work hours. To do this, unplug the power cord. Remove the cap and brush on one side. If the brush is shorter than 0.4" (10 mm), replace both brushes with new ones.

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



5.2. Lubricating the head screws

Every week lubricate screws fixing the head inserts with grease delivered with the machine.

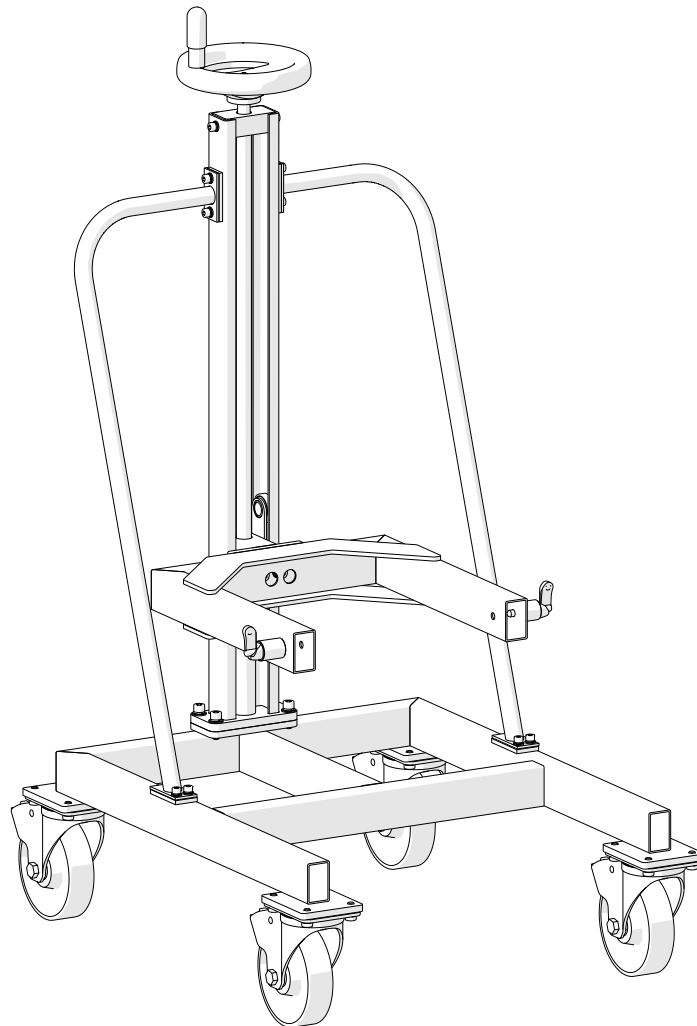
5.3. Checking the feed unit chain tightness

Every 3 months check smoothness of machine motion during work. In case of any anomalies order the inspection in the service center.

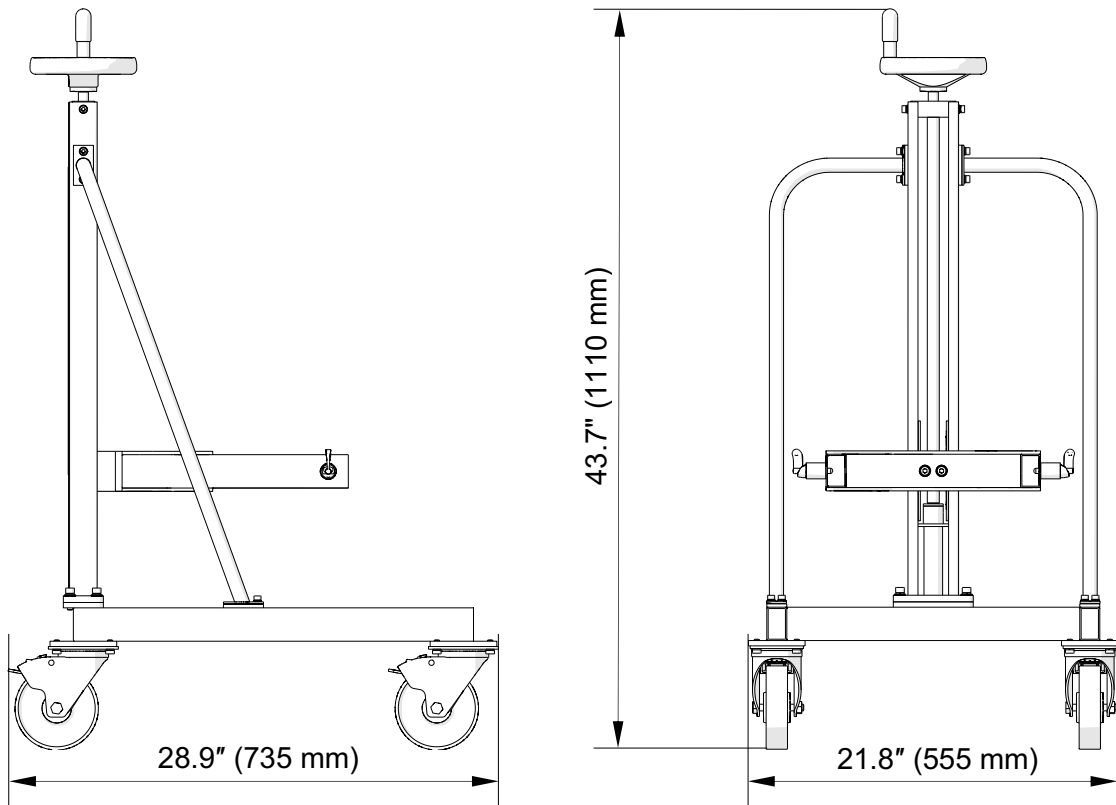
6. ACCESSORIES

6.1. Trolley

The trolley is available as an optional equipment, facilitating placing the machine on machined sheet. It allows for adjusting the beveling machine height.

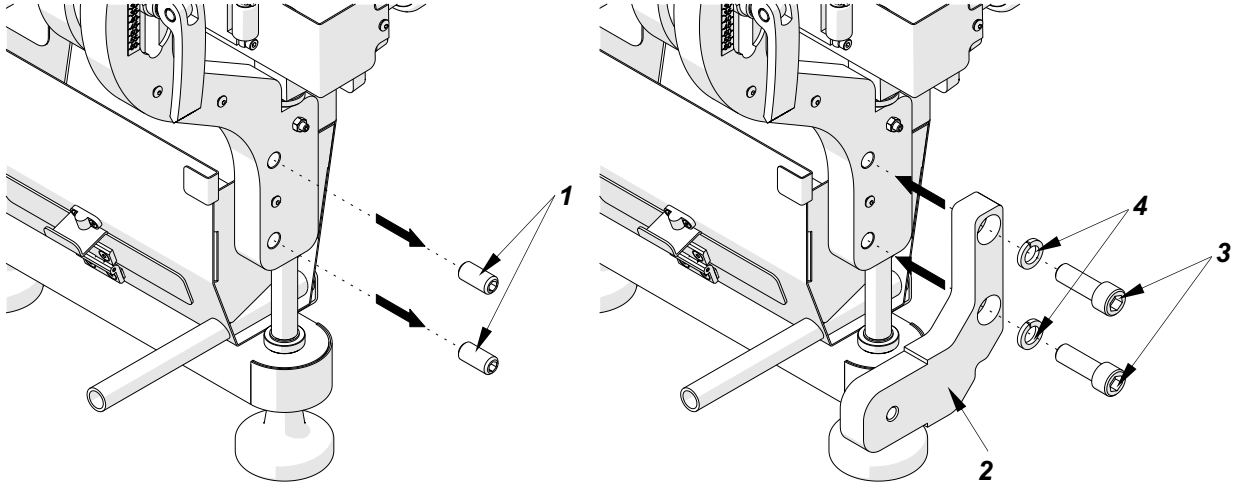


Trolley dimensions:

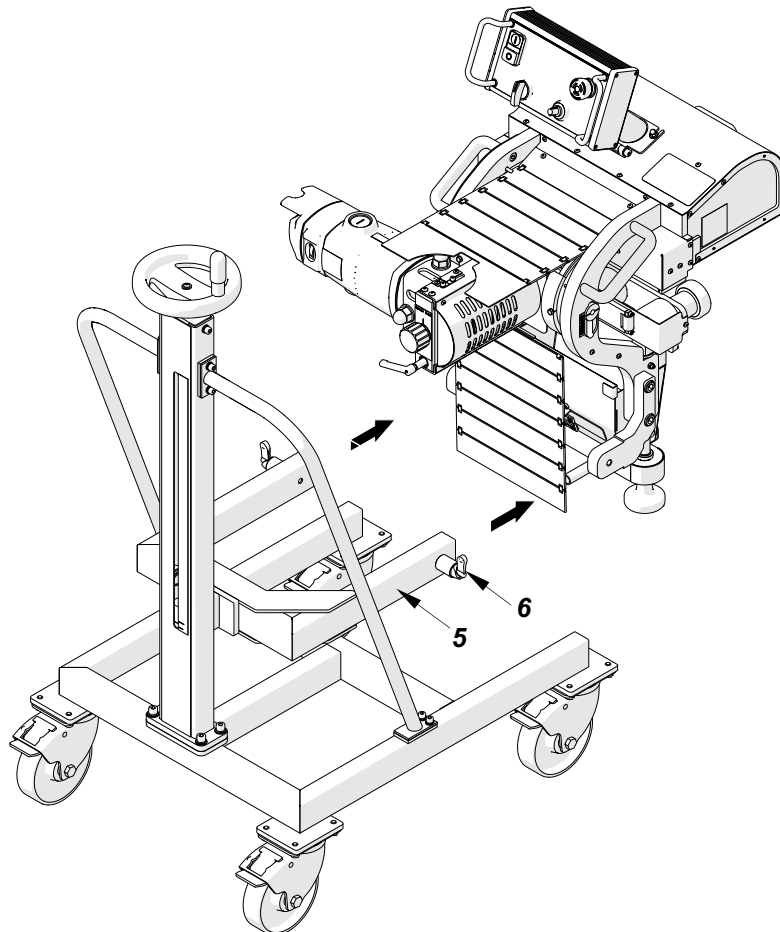


Preparing the beveling machine for using the trolley

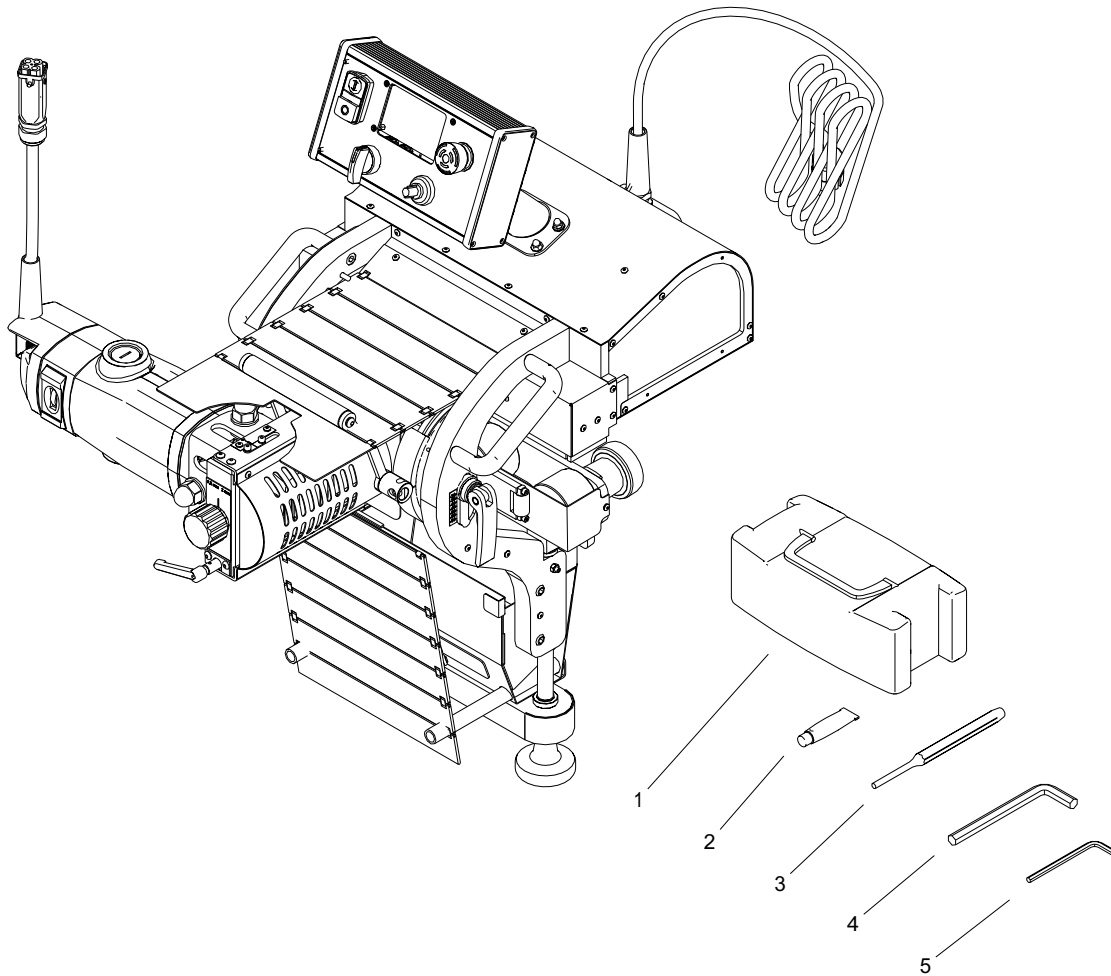
Remove the cylinder screws (1) on both sides of the machine using the hex wrench. Install the trolley brackets (2) with use of screws (3) and washers (4) delivered with the trolley.



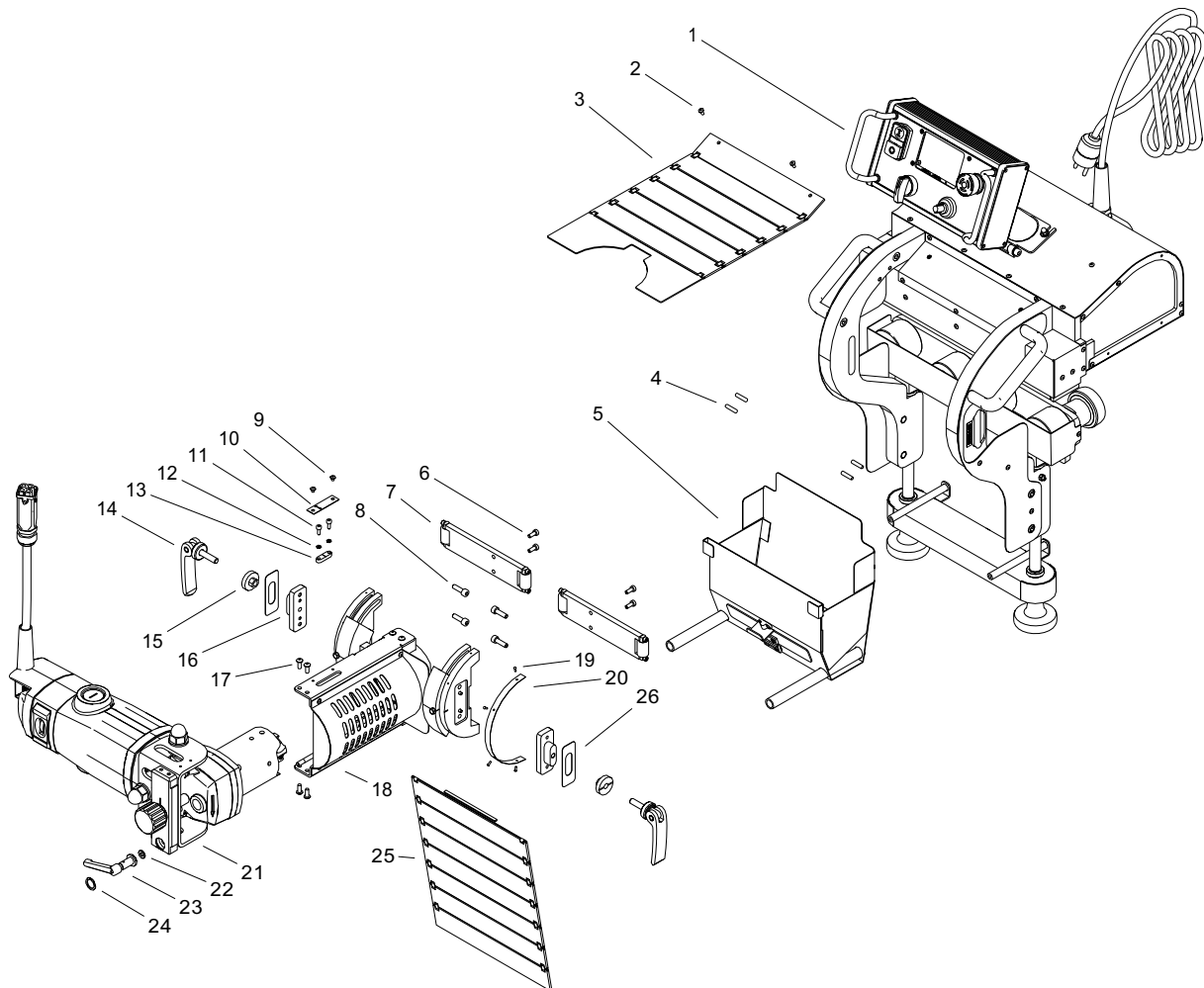
Insert the horizontal parts of brackets into the trolley profiles (5), pulling the spring pins outward (6). After inserting the brackets to the appropriate depth pins return to the initial position, assuring safe attachment.



7. EXPLODED VIEWS AND PARTS LISTS

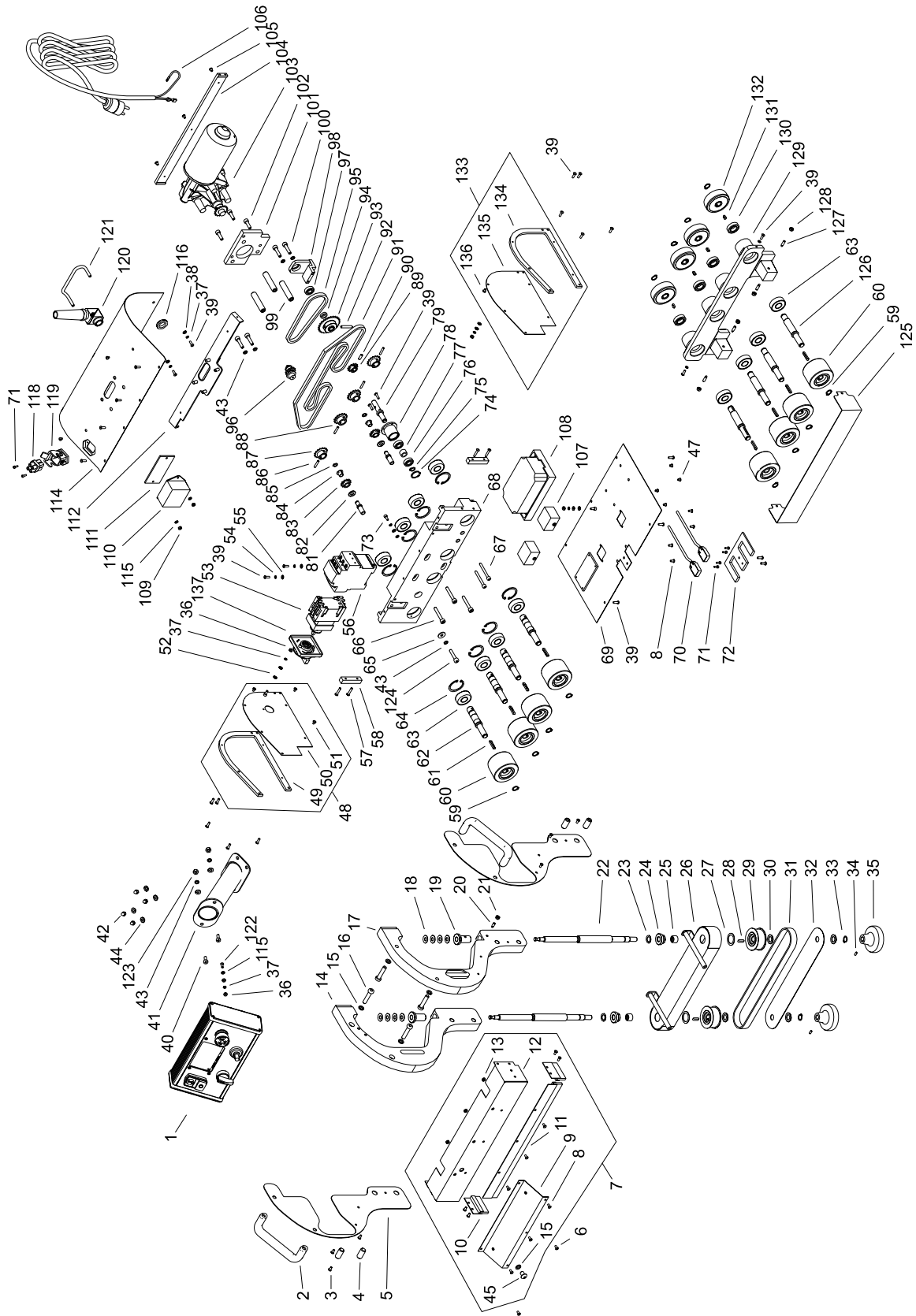


ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PJM-000010	TOOL CONTAINER	1
2	SMR-000005	GREASE FOR SCREWS	1
3	WBJ-000003	DRIFT	1
4	KLC-000004	HEX WRENCH 10 MM	1
5	KLC-000008	HEX WRENCH 5 MM	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	ZSP-0690-01-00-00-0	FEED ASSEMBLY - 230V	1
1	ZSP-0690-01-00-00-1	FEED ASSEMBLY - 115V	1
2	WKR-000091	HEX SOCKET BUTTON HEAD SCREW M4x8	2
3	OSL-0690-08-00-00-0	TOP CHIPS GUARD	1
4	KLK-000049	DOWEL PIN 5n6x20	4
5	ZBN-0690-11-00-00-0	CHIPS CONTAINER ASSY	1
6	SRB-000340	LOW HEAD SOCKET CAP SCREW M5x12	4
7	PRW-0690-03-00-00-0	FRONT ROLLER GUIDE ASSY	2
8	SRB-000114	HEX SOCKET HEAD CAP SCREW M6x20	4
9	WKR-000513	HEX SOCKET BUTTON HEAD SCREW M4x4	2
10	TBL-0690-50-xx-04-x	MILLING DEPTH SCALE	1
11	SRB-000061	HEX SOCKET HEAD CAP SCREW M4x10	2
12	PDK-000042	SPRING WASHER 4.1	2
13	WSK-0690-12-00-00-0	MILLING DEPTH GAUGE	1
14	DZW-000020	LEVER	2
15	TLJ-0690-10-00-00-0	MOUNTING SLEEVE	2
16	PRW-0690-04-00-00-0	VERTICAL GUIDE	2
17	WKR-000097	HEX SOCKET BUTTON HEAD SCREW M5x12	6
18	OBS-0690-05-00-00-1	MOTOR HOLDER ASSY	1
19	NIT-000014	ROUND HEAD RIVET 2x6	4

20	TBL-0690-50-xx-02-x	BEVEL ANGLE SCALE	1
21	ZSP-0690-02-00-00-0	MILLING SET ASSY - 230V	1
21	ZSP-0690-02-00-00-1	MILLING SET ASSY - 115V	1
22	PDK-000079	ROUND WASHER 6.4	1
23	NKR-0690-13-00-00-0	LOCKING LEVER ASSY	1
24	BLC-0690-14-00-00-0	RETAINING SHEET	1
25	OSL-0690-09-00-00-0	BOTTOM CHIPS GUARD	1
26	PDK-0690-15-00-00-0	DISTANCE WASHER	2



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PNL-0690-01-31-00-0	CONTROL PANEL ASSY 230V	1
1	PNL-0690-01-31-00-1	CONTROL PANEL ASSY 115V (US)	1

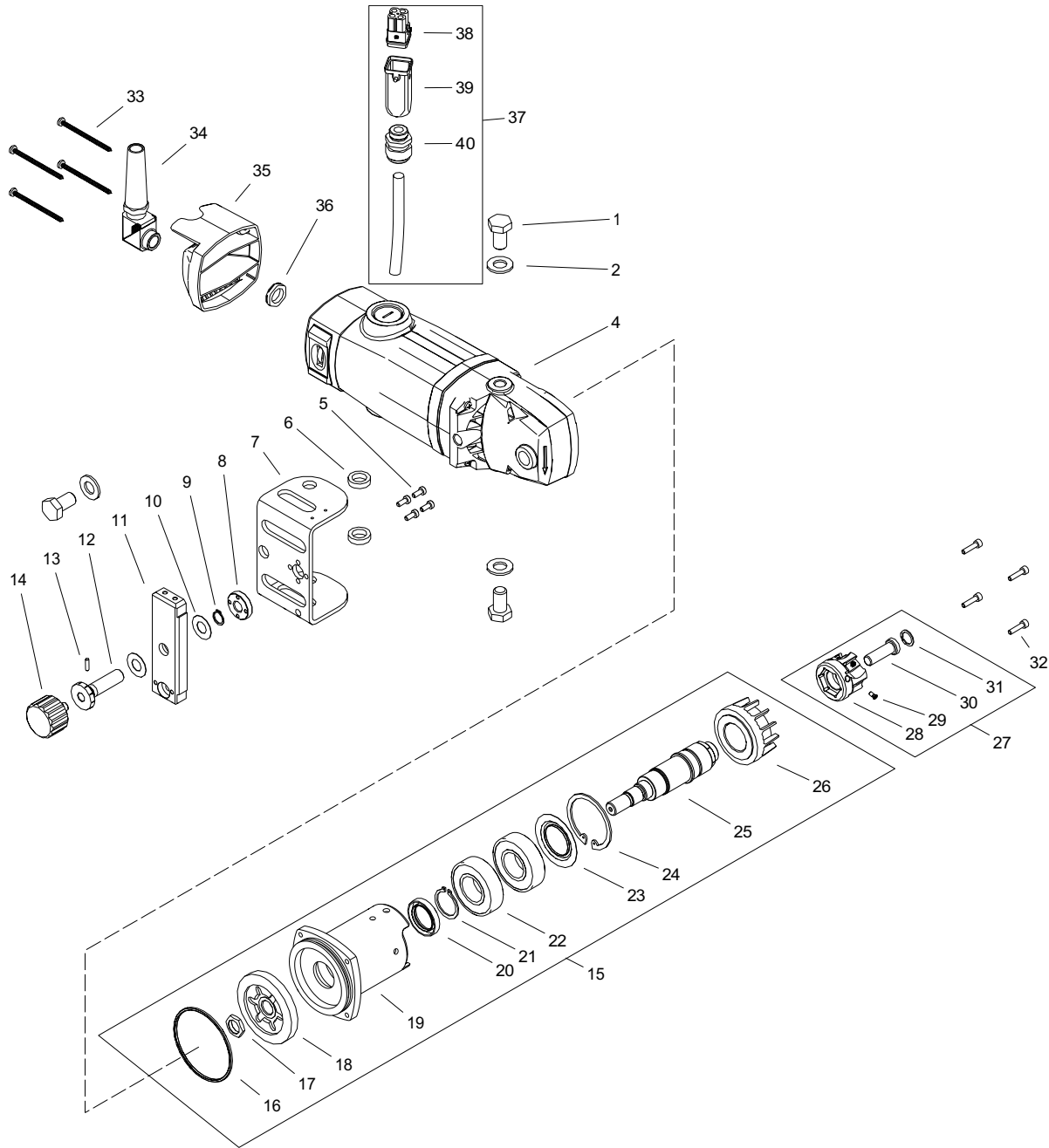
1	PNL-0690-01-31-00-2	CONTROL PANEL ASSY (AU)	1
1	PNL-0690-01-31-00-3	CONTROL PANEL ASSY 115V (UK)	1
1	PNL-0690-01-31-00-4	CONTROL PANEL ASSY 230V (UK)	1
1	PNL-0690-01-31-00-5	CONTROL PANEL ASSY 115V	1
1	PNL-0690-01-31-00-6	CONTROL PANEL ASSY 230V (US)	1
2	UCW-000214	HANDLE	2
3	WKR-000091	HEX SOCKET BUTTON HEAD SCREW M4x8	6
4	WKR-000345	HEX SOCKET SET SCREW WITH FLAT POINT M12x25	4
5	OSL-0690-01-25-00-0	SIDE CHIP GUARD	2
6	WKR-000091	HEX SOCKET BUTTON HEAD SCREW M4x8	2
7	OSL-0690-06-00-00-0	WHEEL COVER ASSY	1
8	WKR-000091	HEX SOCKET BUTTON HEAD SCREW M4x8	14
9	MSK-0690-06-04-00-0	COVER	1
10	OSL-0690-06-03-00-0	SHORT WHEEL COVER ASSY	2
11	OSL-0690-06-02-00-0	LONG WHEEL COVER ASSY	1
12	OSL-0690-06-01-00-1	WHEEL COVER	1
13	NKR-000014	HEX NUT M4	7
14	LCZ-0690-01-02-00-0	LEFT CONNECTOR	1
15	PDK-000051	SPRING WASHER 8.2	5
16	SRB-000515	LOW HEX SOCKET HEAD CAP SCREW M8x35	4
17	LCZ-0690-01-03-00-0	RIGHT CONNECTOR	1
18	SPR-000074	DISC SPRING 8.2x18x1	8
19	NKR-0690-01-17-00-0	SUPPORT NUT	2
20	WKR-000044	HEX SOCKET SET SCREW WITH FLAT POINT M5x12	2
21	NKR-000016	HEX NUT M5	2
22	SRB-0690-01-16-00-0	PRESSURE SCREW	2
23	PDK-000164	SPACER WASHER 12x18x1	2
24	PST-0690-01-18-00-0	BEARING HUB	2
25	LOZ-000167	NEEDLE BEARING 12x16x10	2
26	OBD-0690-01-24-00-0	BELT HOUSING ASSY	1
27	PDK-000219	WASHER 20x28x0.5	2
28	WPS-000109	PARALLEL KEY 4x4x16	2
29	KOL-0690-01-19-00-0	PULLEY	2
30	PDK-000104	SMALL ROUND WASHER 13	4
31	PAS-000035	TOOTHED BELT	1
32	PKR-0690-01-32-00-0	BELT COVER	1
33	PRS-000003	EXTERNAL RETAINING RING 12z	2
34	WKR-000518	HEX SOCKET SET SCREW WITH FLAT POINT M4x8	2
35	PKT-0690-01-34-00-0	KNOB	2
36	NKR-000013	HEX NUT M4	5
37	PDK-00004	SPRING WASHER 4.1	7
38	PDK-000015	ROUND WASHER 4.3	2
39	WKR-000093	HEX SOCKET BUTTON HEAD SCREW M4x12	24
40	SRB-000301	LOW HEAD HEX SOCKET CAP SCREW M6x14	2
41	WSP-0690-01-57-00-1	CONTROL PANEL SUPPORT ASSY	1
42	NKR-000065	CAP NUT M6	4

43	PDK-000046	SPRING WASHER 6.1	7
44	PDK-000021	ROUND WASHER 6.4	6
45	WKR-000366	HEX SOCKET BUTTON HEAD SCREW M8x12	1
47	WKR-000129	HEX SOCKET COUNTERSUNK HEAD SCREW M4x6	4
48	OBD-0690-01-27-00-0	LEFT SIDE HOUSING ASSY	1
49	WSP-0690-01-26-01-0	SIDE BRACKET	1
50	BLC-0690-01-27-01-0	LEFT SIDE SHEET ASSY	1
51	WKR-000292	HEX SOCKET BUTTON HEAD SCREW M4x6	3
52	PDK-000016	ROUND WASHER 4.3	6
53	RZL-000005	3-GEAR DISCONNECTOR 25A	1
54	PDK-000042	SPRING WASHER 4.1	2
55	PDK-000015	ROUND WASHER 4.3	2
56	STY-000012	CONTACTOR 25A, 24VDC	1
57	WKR-000330	HEX SOCKET BUTTON HEAD SCREW M4x20	4
58	KST-0690-07-00-00-0	WHEEL COVER SPACER	2
59	PRS-000003	EXTERNAL RETAINING RING 12z	12
60	KOL-0690-01-05-00-0	WHEEL ASSY	8
61	WPS-000102	PARALLEL KEY 4x4x25	8
62	WLK-0690-01-04-00-0	SHAFT	4
63	LOZ-000112	SEALED BALL BEARING 15x35x11	12
64	PRS-000150	INTERNAL RETAINING RING 35w	8
65	PDK-000037	ROUND WASHER 6.5	1
66	SRB-000124	HEX SOCKET HEAD CAP SCREW M6x40	3
67	SRB-000093	HEX SOCKET HEAD CAP SCREW M5x45	2
68	KRP-0690-01-01-00-0	MAIN BODY	1
69	OBD-0690-01-30-00-0	BOTTOM HOUSING ASSY	1
70	WZK-0690-01-39-00-0	INDUCTION SENSOR HARNESS	2
71	SRB-000538	HEX SOCKET HEAD CAP SCREW M3x8	6
72	OSL-0690-01-53-00-0	SENSOR COVER	1
73	SRB-000254	HEX SOCKET HEAD CAP SCREW M4x10	1
74	PRS-000417	INTERNAL RETAINING RING 22w	1
75	PRS-000002	EXTERNAL RETAINING RING 10z	1
76	LOZ-000079	BALL BEARING 10x22x6	2
77	TLJ-0690-01-38-00-0	SPACING SLEEVE	1
78	PST-0690-01-09-00-0	DRIVE SHAFT HUB	1
79	WLK-0690-01-08-00-0	SPROCKET SHAFT	1
81	TRZ-0690-01-07-00-0	SPROCKET MANDREL	2
82	PDK-000072	ROUND WASHER 8.4	2
83	KOL-0690-01-13-00-0	SPROCKET z12	2
84	TLJ-000089	SLIDE BUSHING 8x10x1x9,5	2
85	PRS-000041	EXTERNAL RETAINING RING 8z	2
86	KLK-000014	SPRING PIN 4x20	4
87	KOL-0690-01-60-00-0	SIDE SPROCKET z16	2
88	KOL-0476-01-02-02-1	SPROCKET z16	2
89	KOL-0690-01-28-00-0	DRIVE SPROCKET z12	1
90	KLK-000126	SPRING PIN 5x14	1

91	LNC-0690-01-21-00-0	CHAIN - LONG	1
92	KLK-000155	SPRING PIN 5x30	1
93	KOL-0690-01-23-00-0	SPROCKET z27	1
94	PDK-0690-01-36-00-0	SPACER WASHER 10x16x4	1
95	LNC-0690-01-20-00-0	CHAIN - SHORT	1
96	NPN-0690-01-06-00-0	CHAIN TENSIONER	1
97	LOZ-000079	BALL BEARING 10x22x6	1
98	PDP-0690-01-10-00-0	SHAFT SUPPORT	1
99	LCZ-0690-01-12-00-0	MOTOREDUCER PLATE CONNECTOR	3
100	SRB-000115	HEX SOCKET HEAD CAP SCREW M6x25	4
101	PLY-0690-01-11-00-0	MOTOREDUCER PLATE	1
102	SRB-000114	HEX SOCKET HEAD CAP SCREW M6x20	3
103	MTR-0690-99-00-00-0	MOTOR SET ASSY	1
104	WSP-0690-01-55-00-0	BACK SUPPORT	1
105	WKR-000292	HEX SOCKET BUTTON HEAD SCREW M4x6	5
106	KBL-0690-01-37-00-0	SUPPLY CABLE 230V	1
106	KBL-0690-01-37-00-1	SUPPLY CABLE 115V (US)	1
106	KBL-0690-01-37-00-2	SUPPLY CABLE 230V (UK)	1
106	KBL-0690-01-37-00-3	SUPPLY CABLE 230V (AU)	1
106	KBL-0690-01-37-00-4	SUPPLY CABLE 230V (INDIA)	1
107	RLK-0690-01-33-00-0	SUPPORT ROLLER ASSY	2
108	ZSL-0690-01-15-00-0	POWER SUPPLY UNIT ASSY	1
109	NKR-000013	HEX NUT M4	2
110	FLT-000038	INTERFERENCE ELIMINATOR	1
111	PLY-0690-01-56-00-0	INTERFERENCE ELIMINATOR PLATE	1
112	WSP-0690-01-54-00-0	UPPER HOUSING SUPPORT ASSY	1
114	OBD-0690-01-29-00-0	UPPER HOUSING ASSY	1
115	PDK-000060	EXTERNAL TOOTH LOCK WASHER 4.3	4
116	NKR-000132	GLAND NUT PG13.5	1
118	WKL-000199	4-PIN CONECTOR	1
119	GNZ-000106	CONNECTOR SOCKET	1
120	PRP-000026	BUSHING	1
121	OSL-0690-01-58-00-0	COVER	1
122	WKR-000131	HEX SOCKET COUNTERSUNK HEAD SCREW M4x12	1
123	NKR-000017	HEX NUT M6	2
124	SRB-000118	HEX SOCKET HEAD CAP SCREW M6x30	1
125	OSL-0690-01-14-05-0	BOTTOM WHEEL SHIELD	1
126	WLK-0690-01-14-03-0	BOTTOM ROLLER SHAFT LONG	4
127	WKR-000424	HEX SOCKET SET SCREW WITH DOG POINT M5x16	4
128	NKR-000016	HEX NUT M5	4
129	PLY-0690-01-14-01-1	PRESSURE PLATE	1
130	LOZ-000090	BEARING 15x28x7	4
131	WPS-000119	PARALLEL KEY 4x4x10	4
132	RLK-0690-01-14-04-0	BOTTOM SUPPORT ROLLER ASSY	4
133	OBD-0690-01-26-00-0	RIGHT SIDE HOUSING ASSY	1
134	WSP-0690-01-26-01-0	SIDE BRACKET	1

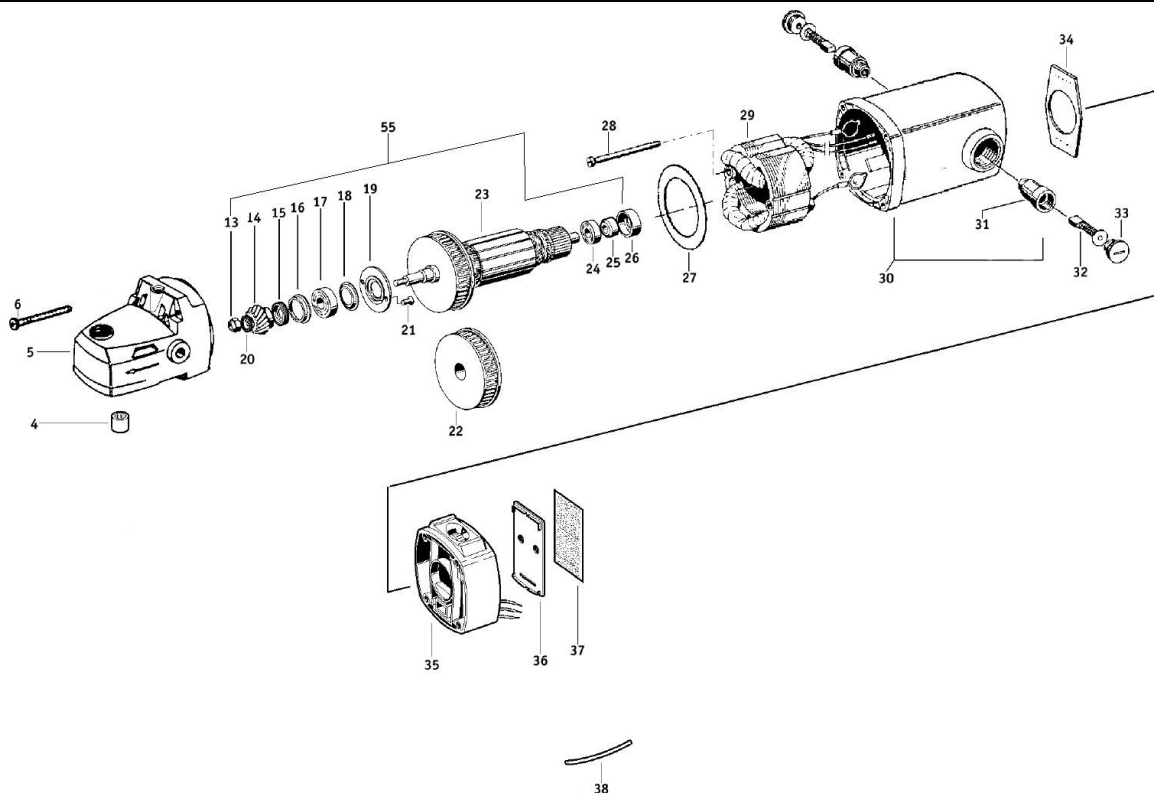
135	BLC-0690-01-26-02-0	RIGHT SIDE SHEET ASSY	1
136	WKR-000292	HEX SOCKET BUTTON HEAD SCREW M4x6	3
137	PKT-000024	RED-YELLOW HANDLE	1
138*	WZK-0690-01-42-00-0	MODULE AND MOTOR WIRE SET 24V	1
139*	WZK-0690-01-44-00-0	3-GEAR DISCONNECTOR – FILTER WIRE SET	1
140*	WZK-0690-01-45-00-0	CONTACTOR - POWER SUPPLY WIRE SET	1
141*	WZK-0690-01-46-00-0	START WIRE SET	1
142*	WZK-0690-01-47-00-0	START BUTTON WIRE SET	1
143*	WZK-0690-01-49-00-0	FILTER – CONTACTOR WIRE SET	1
144*	WZK-0690-01-50-00-0	CONTACTOR WIRE SET	1
145*	WZK-0690-01-31-02-0	CURRENT TRANSFORMER WIRE SET	1
146*	WZK-0690-01-51-00-0	GROUND WIRE SET	2
147*	WZK-0690-01-61-00-0	GROUND WIRE SET	2
148*	WZK-0690-01-63-00-0	FEED MOTOR PLUS WIRE SET	1

*not shown in the drawing

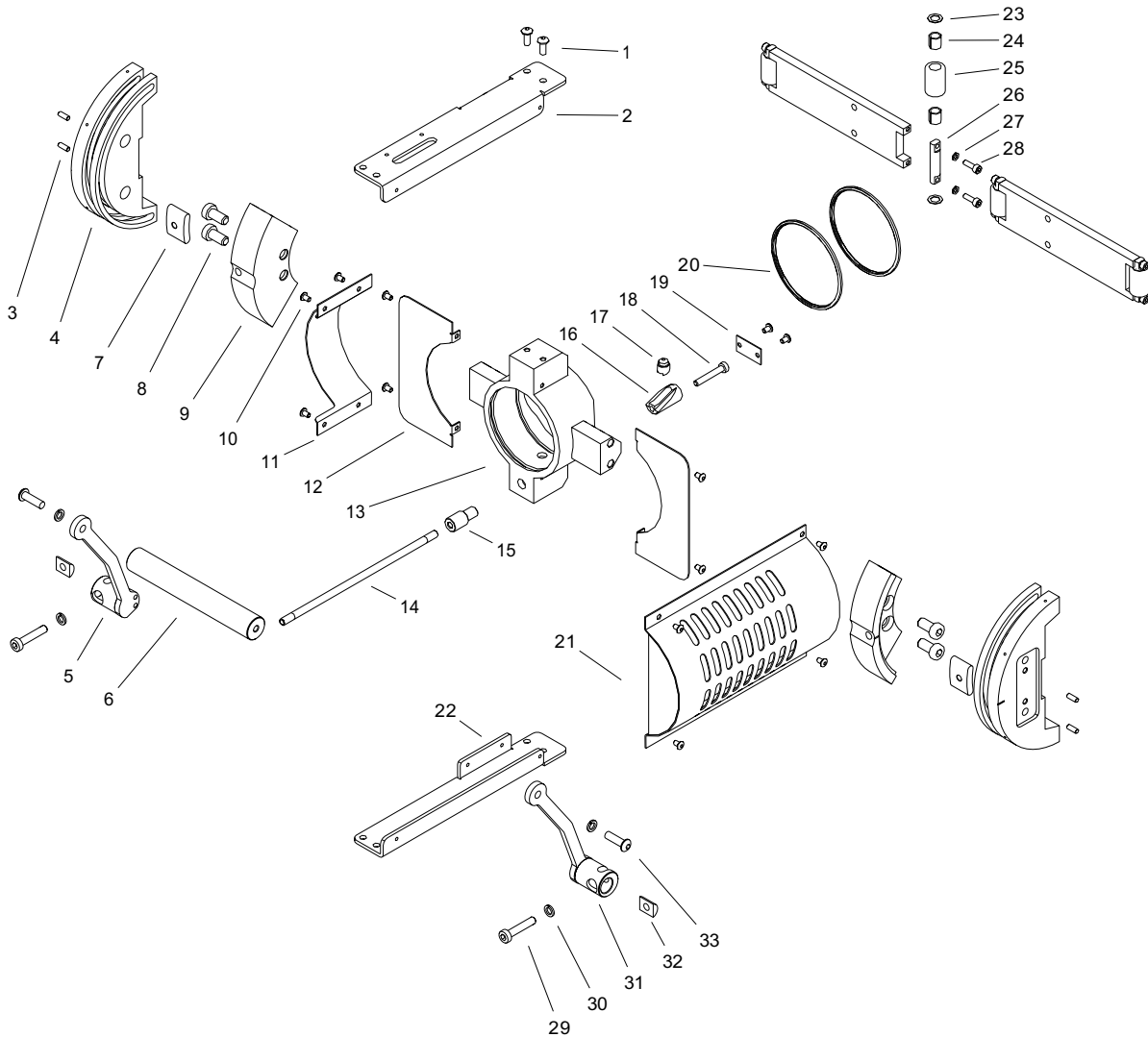


ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	SRB-000532	HEX HEAD CAP SCREW M14x25	3
2	PDK-000028	ROUND WASHER 15	3
4	NPD-0690-02-02-00-0	MOTOR - 230V	1
4	NPD-0690-02-02-00-1	MOTOR - 115V	1
5	SRB-000340	LOW HEAD SOCKET CAP SCREW M5x12	4
6	TLJ-0690-02-04-00-0	SPACING SLEEVE	2
7	JRZ-0690-02-03-00-0	MOTOR BRACKET	1
8	NKR-0690-02-05-00-0	NUT	1
9	PRS-000004	EXTERNAL RETAINING RING 14z	1
10	PDK-000228	WASHER 14x26x0.5	2
11	LCZ-0690-02-06-00-0	MOUNTING PLATE	1
12	SRB-0690-02-07-00-0	SCREW	1

13	KLK-000077	SPRING PIN 4x14	1
14	PKT-0690-02-08-00-0	DEPTH KNOB	1
15	WRZ-0690-02-01-00-0	SPINDLE ASSY	1
16	PRS-000286	SEAL RING 80x3	1
17	NKR-0509-01-05-00-0	LOCKING NUT	1
18	KOL-0509-01-04-00-0	GEAR	1
19	KRP-0690-02-01-01-0	SPINDLE BODY	1
20	PRS-000285	A-RING SEAL RING 28x42x7	1
21	PRS-000021	EXTERNAL RETAINING RING 30z	1
22	LOZ-000230	BALL BEARING 30x62x16	2
23	PRS-000416	SEAL RING	1
24	PRS-000035	INTERNAL RETAINING RING 62w	1
25	WLK-0690-02-01-02-1	SPINDLE	1
26	TLJ-0690-02-01-03-1	MASS SLEVE	1
27	GLW-0715-19-00-00-0	HEAD ASSY	1
28	GLW-000052	MILLING HEAD	1
29	WKR-000577	MOUNTING SCREW FOR INSERT	5
30	SRB-0715-19-01-00-0	HEAD SCREW	1
31	PRS-000381	INTERNAL RETAINING RING 18w	1
32	SRB-000086	HEX SOCKET HEAD CAP SCREW M5x20	4
33	SRB-000343	SCREW KT-KT 5x74	4
34	PRP-000026	CABLE GLAND WITH STRAIN RELIEF	1
35	PKR-0690-02-02-01-0	MOTOR CAP	1
36	NKR-000132	NUT PG13,5	1
37	KBL-0690-02-02-02-0	MOTOR CABLE	1
38	WKL-000198	4 PIN CONNECTOR	1
39	OBD-000043	CONNECTOR HOUSING	1
40	DLW-000066	CABLE GLAND M20x1.5	1

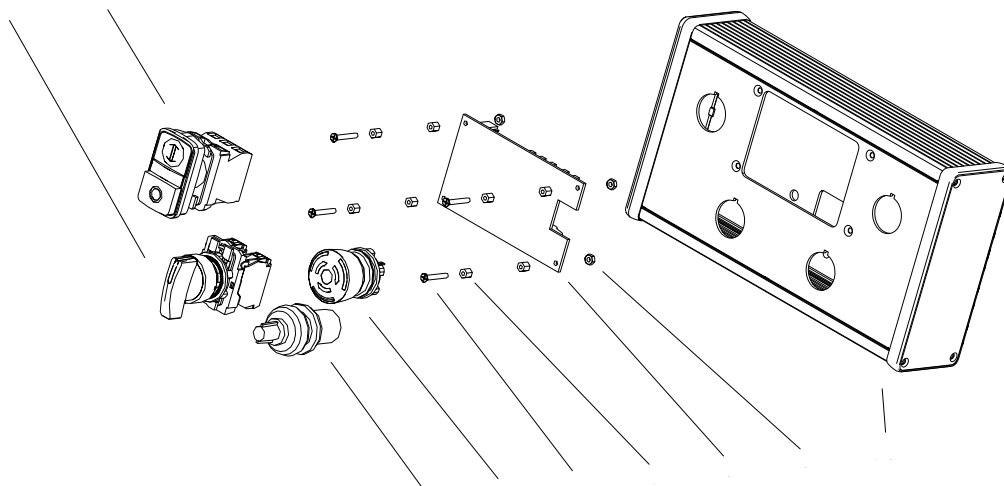


ITEM	PART NUMBER	DESCRIPTION	Q-TY
4	LOZ-000133	SLIDE SLEEVE HK 1512	1
5	KRP-0680-03-00-00-1	GEAR BODY	1
6	SRB-000338	HEAD SCREW TX25 M5x45	4
13	NKR-000145	NUT M8x1	1
14	KOL-000089	BEVEL GEAR MZ 1.5x12	1
15	DYS-000009	DISTANCE	1
16	USZ-000044	SEALING	1
17	LOZ-000135	BALL BEARING 15x35x11	1
18	USZ-000045	SEALING 6003JV	1
19	PKR-0680-12-00-00-0	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
55	WRN-0680-99-01-00-0	ROTOR ASSY – 120V	1
55	WRN-0680-99-02-00-0	ROTOR ASSY – 230V	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	WKR-000097	HEX SOCKET BUTTON HEAD SCREW M5x12	4
2	WSP-0690-05-04-00-0	UPPER BRACKET	1
3	KLK-000011	SPRING PIN 4x10	4
4	PRW-0690-05-03-00-2	ANGLE GUIDE	2
5	DZW-0690-05-17-00-0	LEFT LOCKING LEVER	1
6	RKJ-0690-05-19-00-0	LOCKING HANDLE	1
7	WPS-0690-05-10-00-1	LOCKING BLOCK	2
8	SRB-000421	LOW HEX SOCKET HEAD CAP SCREW M8x16	4
9	UST-0690-05-02-00-2	ANGLE SETTER	2
10	WKR-000292	HEX SOCKET BUTTON HEAD SCREW M4x6	14
11	OBD-0690-05-13-00-0	SHORT COVER	1
12	TRC-0690-05-06-00-0	FRONT CHIP GUARD	2
13	OBS-0690-05-01-00-0	MOTOR HOLDER	1
14	CGN-0690-05-11-00-0	LOCKING ROD	1
15	WDZ-0690-05-09-00-0	LOCKING ROD CONNECTOR	1
16	KLN-0690-05-08-00-0	LOCKING KEY	1
17	KMN-0690-05-07-00-0	LOCKING PIN	1

18	SRB-000507	LOW HEAD SOCKET CAP SCREW M5x30	1
19	ZLP-0690-05-14-00-0	CAP	1
20	PRS-000274	SEAL RING 72x3	2
21	OBD-0690-05-12-00-0	COVER	1
22	WSP-0690-05-05-00-0	BOTTOM BRACKET	1
23	PDK-000292	WASHER 8x12x0.5	8
24	TLJ-000048	SLIDE BUSHING 8x10x12	8
25	RLK-0690-03-03-00-0	FACE ROLLER	4
26	OSK-0690-03-02-00-0	FACE ROLLER AXLE	4
27	PDK-000042	SPRING WASHER 4.1	8
28	SRB-000062	HEX SOCKET HEAD CAP SCREW M4x12	8
29	SRB-000533	LOW HEX SOCKET HEAD CAP SCREW M6x30	2
30	PDK-000046	SPRING WASHER 6.1	4
31	DZW-0690-05-16-00-0	RIGHT LOCKING LEVER	1
32	PDK-0690-05-20-00-0	WASHER	2
33	WKR-000499	HEX SOCKET BUTTON HEAD SCREW M6x12	2

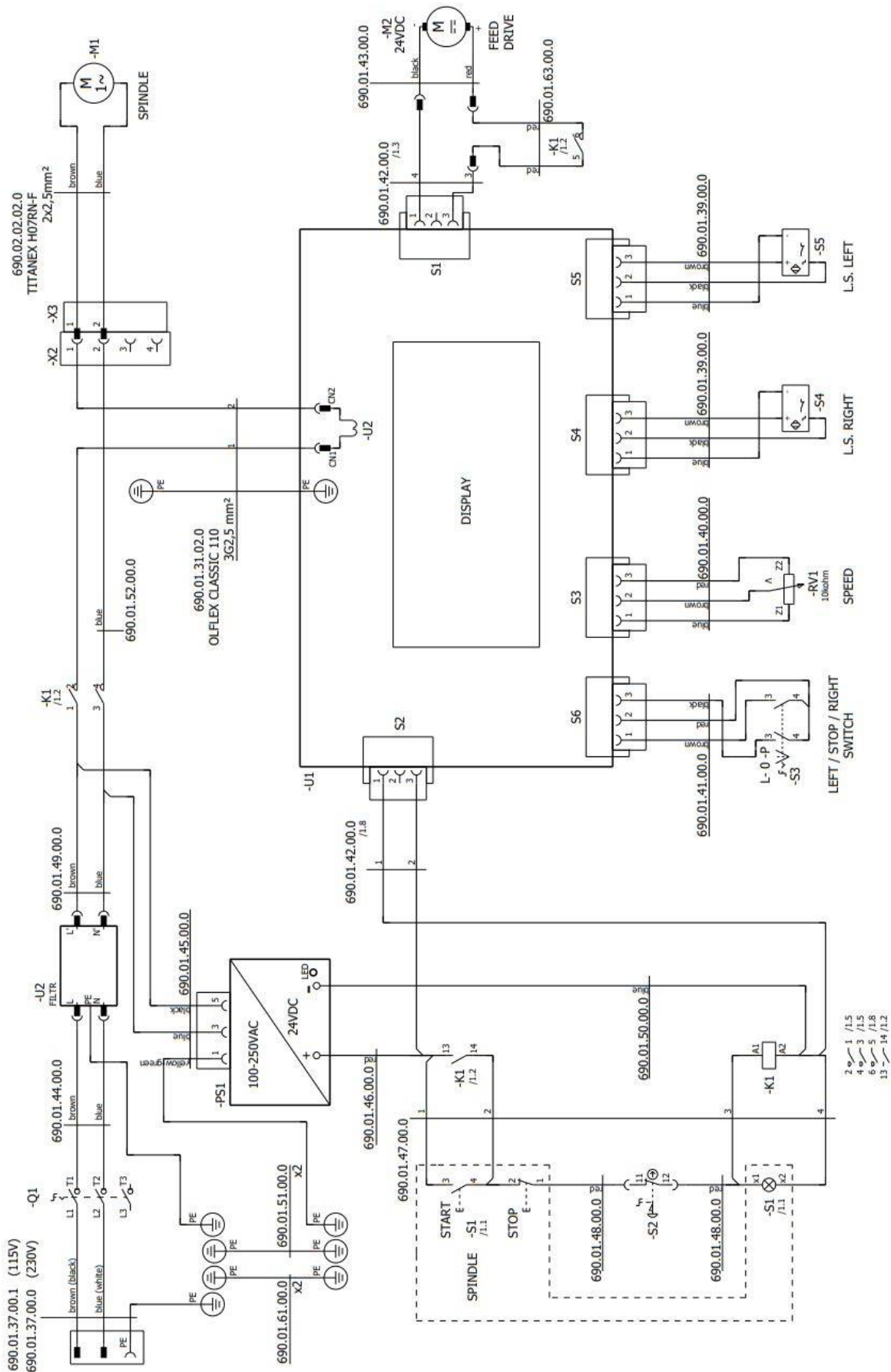


ITEM	PART NUMBER	DESCRIPTION	Q-TY
2	PNK-000071	3-POSITIONS SELECTOR	1
3	PRC-000044	START-STOP BUTTON	1
4	PTN-000037	POTENTIOMETER	1
5	PRC-000031	EMERGENCY BUTTON	1
6	WKR-000148	CROSS RECESSED COUNTERSUNK HEAD SCREW M3x20	4
7	TLJ-000026	SLEEVE M3x5	8
8	MDL-0690-80-01-00-0	ELECTRONIC MODULE ASSY	1
9	NKR-000010	HEX NUT M3	4
10	KRP-0690-01-31-01-0	CONTROL PANEL BODY	1
13*	WYS-0690-80-04-00-0	DISPLAY	1
13*	WYS-0690-80-02-00-0	DISPLAY (US)	1
13*	WYS-0690-80-03-00-0	DISPLAY (AU)	1
14*	WZK-0690-01-40-00-0	POTENTIOMETER WIRE SET	1

15*	WZK-0690-01-41-00-0	3-POSITIONS SELECTOR WIRE SET	1
16*	WZK-0690-01-48-00-0	EMERGENCY BUTTON WIRE SET	2
17*	TSM-000028	FFC CABLE	1

*not shown in the drawing

WIRING DIAGRAM



7. DECLARATION OF CONFORMITY

Declaration of conformity

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

We declare with full responsibility that:

ABM-30 Auto Feed Beveling Machine

is manufactured in accordance with the following standards:

- EN 60204-1: 2018,
- EN IEC 61000-6-2:2019
- EN IEC 61000-6-4:2019
- EN ISO 12100:2010,
- EN ISO 13857:2018,
- EN ISO 13849-1:2015,
- EN ISO 13854: 2019

and satisfies the regulations of the guidelines: 2014/30/EU, 2014/35/EU, 2006/42/EC, 2011/65/EU, 2012/19/EU.

Person authorized to compile the technical file:

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

Białystok, 30 August 2022



Wiktor Marek Siergiej
CEO

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

..... in the name of Manufacturer warrants the ABM-30 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

0.01 / 26 October 2022***WE RESERVE THE RIGHT TO MAKE CHANGES IN THIS MANUAL WITHOUT NOTICE***