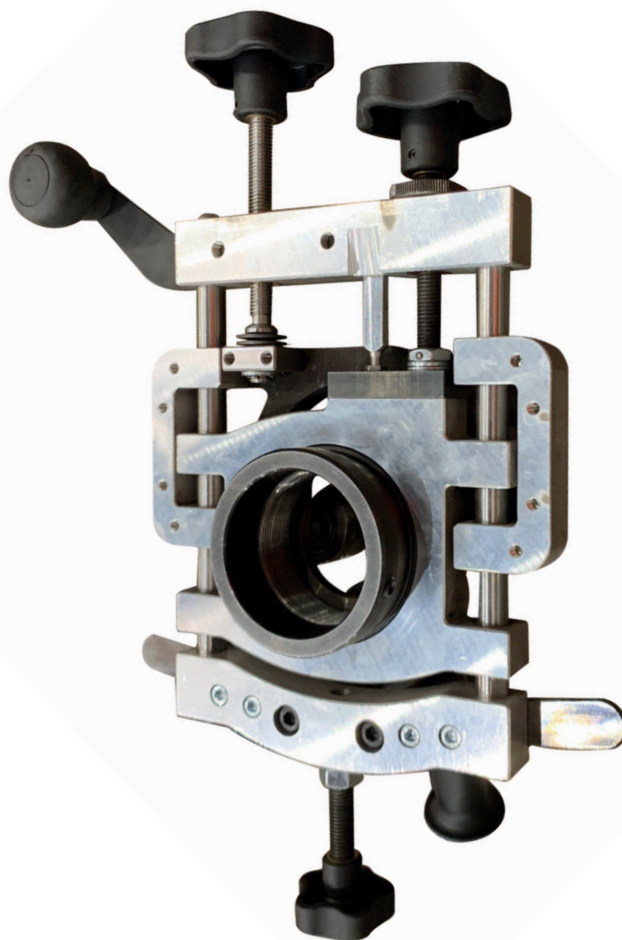


Xpipe Beveler
for beveling pipes and tubes
Order No. 25500

Instructions for use and maintenance

These instructions must only be used in conjunction with the official instructions for the machine

B10 Electra, B15 Electra, B15 INOX, or B15 AIR



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1. General information

1. Introduction

Thank you for purchasing one of our products. We hope you will be completely satisfied with it.

This manual contains all the instructions for installing, adjusting, operating, and maintaining the Xpipe Beveler for beveling pipes and sheets in accordance with applicable safety standards.

The information and data in this manual are subject to change as a result of further improvements to the machines and equipment. For the avoidance of doubt, please contact your supplier if you find any discrepancies.

Never perform any operations before reading and understanding the instructions in the manual. A large proportion of accidents that occur in the workplace are caused by failure to follow the instructions and recommendations contained in the manual.

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



Caution:

Important information for the personal safety of the operator.



Important:

Instruction that must be followed to ensure proper operation of the machine.

2. Warranty

The seller provides a warranty for the Xpipe Beveler product that the goods will be free from material and manufacturing defects for a period of 12 months from the date of delivery.

A warranty is provided for the proper functioning of the goods and the materials used for a period of 12 months from the date of delivery of the goods.

The seller undertakes to ensure the removal of any defects covered by the warranty free of charge and without undue delay so that the buyer can use the goods properly. If the buyer exercises their rights arising from liability for defects not covered by the warranty, they shall reimburse the seller for the costs associated with this.

The warranty period does not run from the date on which the buyer reported to the seller the existence of a defect covered by the warranty and for which the buyer cannot use the goods and exercised his rights under the warranty for defects, until the date of its removal by the seller.

The warranty does not cover natural and normal wear and tear of the goods and defects caused by improper use of the goods contrary to the training and documentation provided. Furthermore, the warranty does not cover defects caused by overloading the goods, nor defects caused by unprofessional intervention in the goods or unprofessional repair or modification of the goods. Improper intervention, repair, or modification means any intervention, repair, or modification that was performed contrary to the training and documentation provided, or was performed by a person other than the seller or a person authorized or approved by the seller.

Rights arising from liability for defects under the warranty must be exercised with the seller without undue delay after the buyer discovers the defect, but no later than the end of the warranty period, otherwise these rights shall expire.

A tax document must be presented in order to exercise rights arising from liability for defects under the warranty provided. Otherwise, these rights cannot be granted to the buyer.

The seller's liability for defects covered by the warranty does not arise if these defects were caused by external events. External events are understood to mean, in particular, natural disasters, force majeure, or the behavior of third parties.

N.KO spol. s r.o. (hereinafter referred to as the manufacturer) considers the warranty to be invalid in the following cases:

- improper use of the product;
- use contrary to national or international standards;
- incorrect installation;
- defective power supply;
- serious maintenance deficiencies;
- unauthorized modifications or interventions;
- use of non-original or incorrect spare parts and accessories for the model in question;
- complete or partial failure to follow instructions;
- exceptional events, natural disasters, or other events.

2. SAFETY

1. Safety recommendations



Caution:

Read the following instructions carefully to prevent personal injury and/or property damage.

- Never attempt to operate the product until you have thoroughly familiarized yourself with how it works. If you still have doubts after carefully and thoroughly reading this manual, contact your supplier.
- Ensure that all technical personnel who are to use and maintain the product are fully familiar with all relevant safety recommendations.
- The device must only be installed by authorized personnel in accordance with the instructions in this manual.
- Before starting work, the operator must ensure that all safety devices are functional and that all safety covers are in place.
- Never use the device for purposes other than those specified in the manual. Never process materials and workpieces other than those specified.
- Consult your supplier before using the device for purposes other than those specified and request permission.
- Replace parts considered defective with others recommended by the manufacturer. Never replace with parts other than original parts.
- Never wear clothing or jewelry that could get caught in moving parts.
- Always wear safety clothing, shoes with non-slip soles, gloves, ear protection, and safety glasses.



Important:

If any defects arise during the product's lifetime that cannot be repaired according to this manual, it is advisable to contact N.KO so that the problem can be resolved as quickly as possible.

2. Operator qualifications and protection

The employer is obliged to inform the operator about safety standards and, in addition, to ensure that they are observed and to make sure that the work area is sufficiently large and well lit.

The term "operating personnel" refers to persons who assemble, install, operate, adjust, maintain, clean, and repair the product.



Caution:

Before starting work, the operator must be familiar with the characteristics of the product and must have read this entire manual.

**Caution:**

The operator must always:

- ensure that all safety guards are in place and that safety devices are functioning before starting the machine with the product.
- Avoid wearing clothing or jewelry that could get caught in moving parts.
- Wear approved safety clothing, such as shoes with non-slip soles, ear protectors, gloves, and safety glasses.
- Apply safety standards, ensure that they are always followed, and if in doubt, refer to this manual before taking any action.
- Contact the supplier if you cannot remedy defects that cause the product to malfunction.

3. Safety equipment

The Xpipe Beveler is equipped with safety covers to isolate areas that could be dangerous to operators. These covers are bolted or screwed to the structure of the device and the machine. They can be removed using the appropriate tools. Their removal is only permitted during equipment maintenance activities.

**Caution:**

The cover must always be removed when the machine with the device is at a standstill and the power plug is disconnected. Never use the device without the safety covers in place.

4. Remaining risks

The Xpipe Beveler has been designed and manufactured with all the necessary devices and equipment to ensure the health and safety of the operator.

The device is completely covered to minimize the risk of contact with moving parts. parts is minimized as much as possible.

However, there is one remaining risk:

As mentioned above, the working area is protected as much as possible, but it must remain partially open so that the material to be machined can be inserted.

It is therefore possible that the operator could insert their fingers into this zone, where both the cutting tool and the guide rulers are located.

**Caution:**

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



Caution:

Always apply the safety regulations contained in the manual and ensure that they are observed and that all remaining risks are eliminated.



Caution:

Information labels with safety regulations and recommendations are located on the machine. Never remove these labels.

3. TECHNICAL SPECIFICATIONS

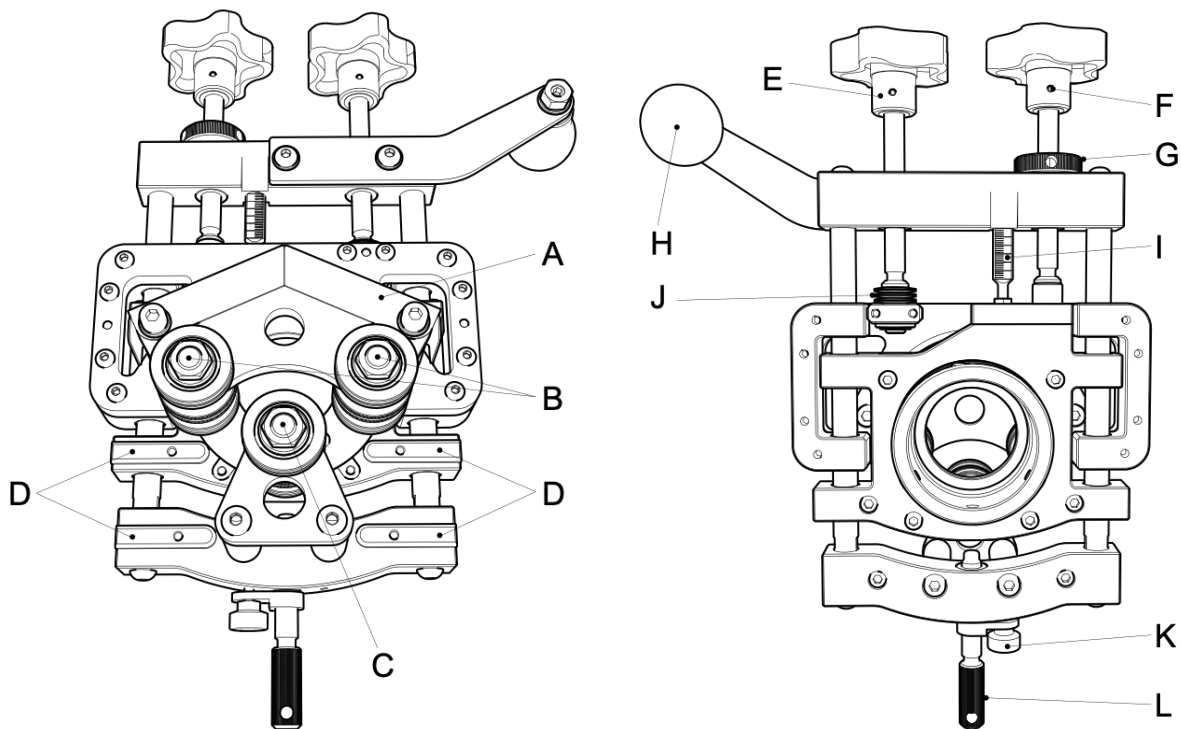
1. Description of the Xpipe Beveler

The Xpipe Beveler for beveling pipes, tubes, and sheets is designed exclusively for use with the B10 Electra, B15 Electra, B15 INOX, or B15 AIR machines manufactured by N.KO Machines. One of its main advantages is the ability to machine the ends of pipes and tubes to create weld surfaces or chamfer or round edges.

The Xpipe Beveler is reliable and requires minimal maintenance.

Detailed description in Figure 3.1.1. and Figure 3.2.2.

Fig. 3.1.1.



A	Protective cover against flying chips
B	Upper guide rollers
C	Lower guide roller
D	Auxiliary guide stones
E	Control knob for clamping mechanism
F	Chip removal adjustment control knob
G	Lock wheel, chip removal adjustment (lock nut)
H	Rotary handle for controlling the feed of the fixture
I	Chip removal adjustment scale
J	Disc springs with adjustable contact pressure characteristics
K	Repeated beveling stop lock
L	Adjustment screw for repeat beveling stop

2. Technical data

Bevel width (dimension P, Fig. 3.2.1.)	10 mm (when used with the B10 Electra machine) 15 mm (when used with the B15 Electra, B15 INOX, and B15 AIR machines)
Machining angle	30°, 45° and 60°
Rounding application	R 2.5 / R 3.5 / R4 mm
Minimum inner diameter of machined pipe (when machining the outer bevel)	> Ø 85 mm
Working range of wall thickness (when machining external chamfers)	2.5 - 15 mm
Minimum inner diameter of the machined pipe (when machining an internal bevel)	> Ø 500 mm (smaller diameters on request)
Working range of wall thickness (when machining internal bevel)	5 - 15 mm
Minimum clamping depth of the fixture	80 mm
Working range of material thickness (when chamfering flat workpieces and profiles)	3 - 20 mm
Feed	Manual (orbital movement around the pipe)
Dimensions of the fixture	Figure 3.2.2. (below in the text)
Weight of the fixture without the drive unit	8.4 kg.

Fig. 3.2.1.

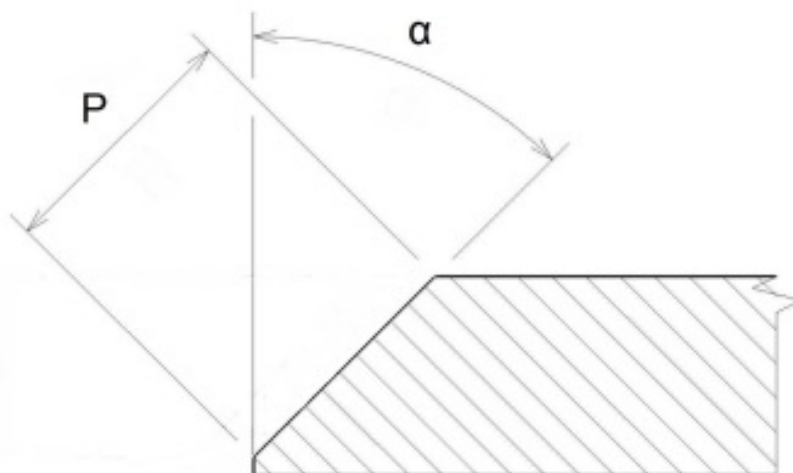
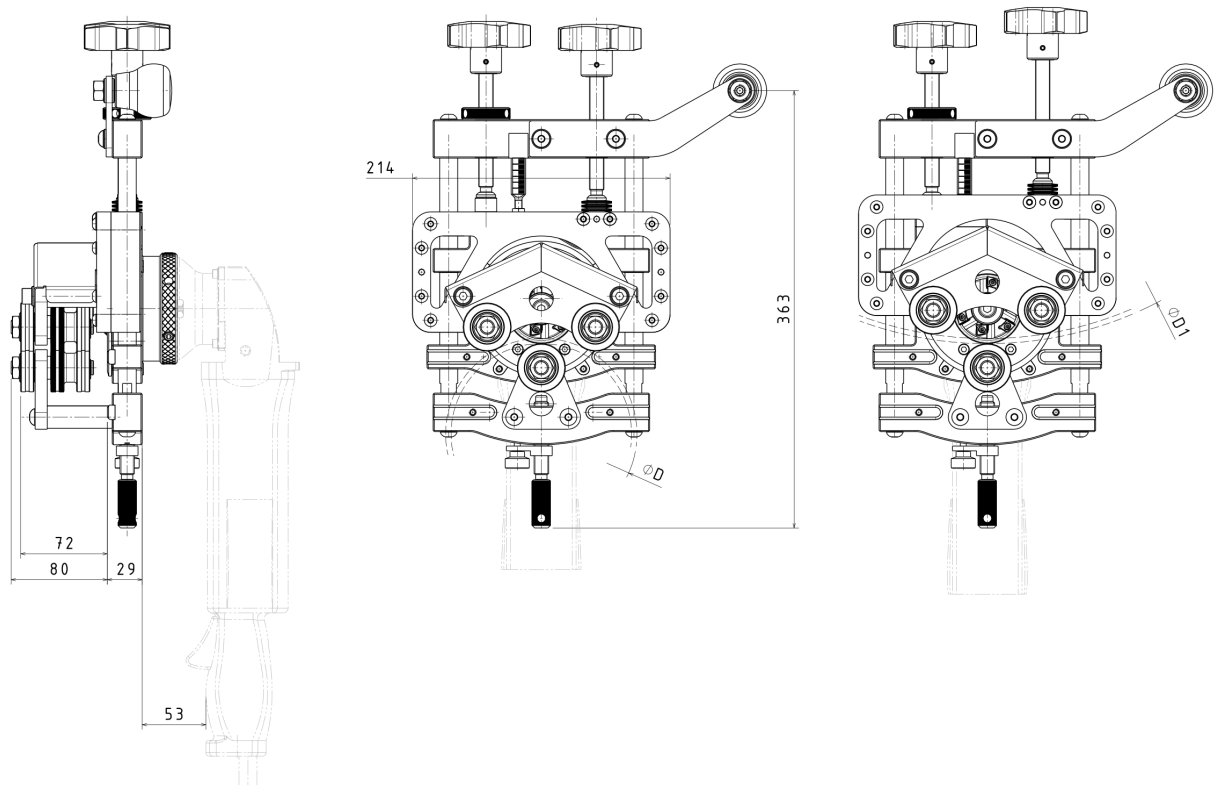


Fig. 3.2.2.



3. Working environment conditions

The environment in which the product is used must comply with the following values:

Temperature: 0° C - 50° C
Humidity 10% - 90% (non-condensing)

The machine with the product must be placed in a covered area and must not be exposed to rain.

Working conditions other than those listed above could cause serious damage.

When not in use,
it can be stored in a location where the temperature fluctuates between: -10°C and 70°C

all other values remain unchanged.

4. INSTALLATION AND PREPARATION OF THE Xpipe Beveler

1. Transport and handling



Important:

The activities described in this section must only be performed by qualified personnel.

When the Xpipe Beveler is delivered to its destination, make sure (while the carrier is still present) that it complies with the specifications in the order and that it has not suffered any damage during transport. Immediately inform the equipment supplier and the carrier in detail if damage is found or if parts are missing. Later complaints will not be considered.



Caution:

Follow these instructions to ensure safe handling of the device:

- Wear protective clothing such as work gloves, shoes with non-slip soles, a helmet, and safety goggles when handling the product and machine!
- If the product is in transport packaging, remove and dispose of it in accordance with the applicable laws of the relevant country.

2. Installation of the B10 Electra, B15 Electra, B15 INOX, or B15 AIR drive unit.



Important:

The activities described in this paragraph must only be performed by qualified personnel.

The Xpipe Beveler is supplied as standard in a cardboard box and in a folded state, ready for immediate use.

Selecting a tool/milling head for working with the Xpipe Beveler

The expected drive unit for the Xpipe Beveler, B10 Electra, B15 Electra, B15 INOX, or B15 AIR machine is always supplied without a milling head.

This must be purchased separately (see the relevant instructions for the B10 Electra, B15 Electra, B15 INOX, or B15 AIR machines).

For use of the B10 Electra, B15 Electra, B15 INOX, or B15 AIR with the Xpipe Beveler, milling heads are available in angles of 30°, 45°, and 60°. Alternatively, tools can be ordered (ask your supplier).

If you are using the B10 Electra, B15 Electra, B15 INOX, or B15 AIR machine on its own, without the Xpipe Beveler, the milling head is placed perpendicular (vertically) to the surface of the workpiece. The working angles of the milling heads are marked accordingly. For example, a 30° head creates an angle deviating 30° from the perpendicular to the surface of the material.

On the contrary, when used with the Xpipe Beveler, the milling head (due to its axis of rotation) is always parallel to the axis of the pipe or the plane of the sheet metal!

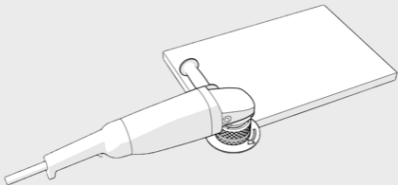
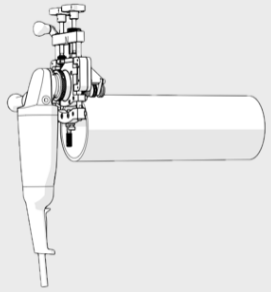


Important:

It follows from the above that when using the Xpipe Beveler, it is always necessary to use a milling head with a nominal angle of 60° to machine a 30° angle.

Conversely, for the required 60°, use a 30° milling head.

When beveling with a 45° milling head, the angle always remains the same.

						
	Using without Xpipe			Using with Xpipe		
Required bevelling angle	30 °	45 °	60 °	30 °	45 °	60 °
Use the cutter angle	30 °	45 °	60 °	60 °	45 °	30 °

Installation procedure for the B10 Electra, B15 Electra, or B15 AIR drive unit:

- Place the Xpipe Beveler on a suitable workbench with the mounting neck facing upwards (Fig. 4.2.4).
- On the beveling machine (B10 Electra, B15 Electra, or B15 Air), loosen the locking screws (item A, Fig. 4.2.3) and remove the entire assembly of the nut with the pressure guide plate (item B, Fig. 4.2.3). Follow the instructions for the relevant drive unit B10 Electra, B15 Electra, or B15 AIR.
- Mount the required milling head or grinding adapter on the B10 Electra, B15 Electra, or B15 AIR drive unit; see the relevant instructions for the B10 Electra, B15 Electra, or B15 AIR.
- Loosen the locking screws (item A, Fig. 4.2.4) to secure the drive unit in the Xpipe Beveler fixture.
- Screw the drive unit into the nut (item B, Fig. 4.2.4).

- Screw the drive unit with the cutting tool into the nut (item C, Fig. 4.2.5) only deep enough so that the lower edge of the cutting blade (item B, Fig. 4.2.5) is still below the level of the support plate (item A, Fig. 4.2.5). Otherwise, the device will not work properly.
- Tighten the three screws (item A, Fig. 4.2.4) securing the drive unit in the Xpipe Beveler fixture again.

Fig. 4.2.3.

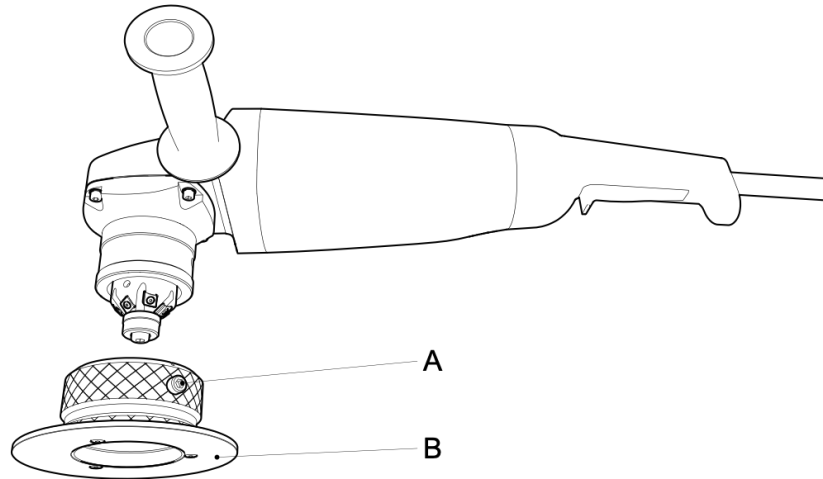


Fig. 4.2.4.

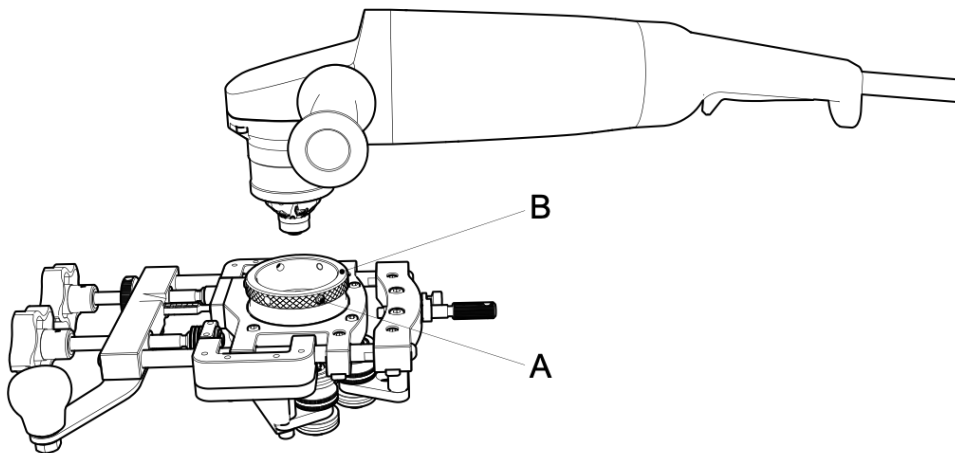
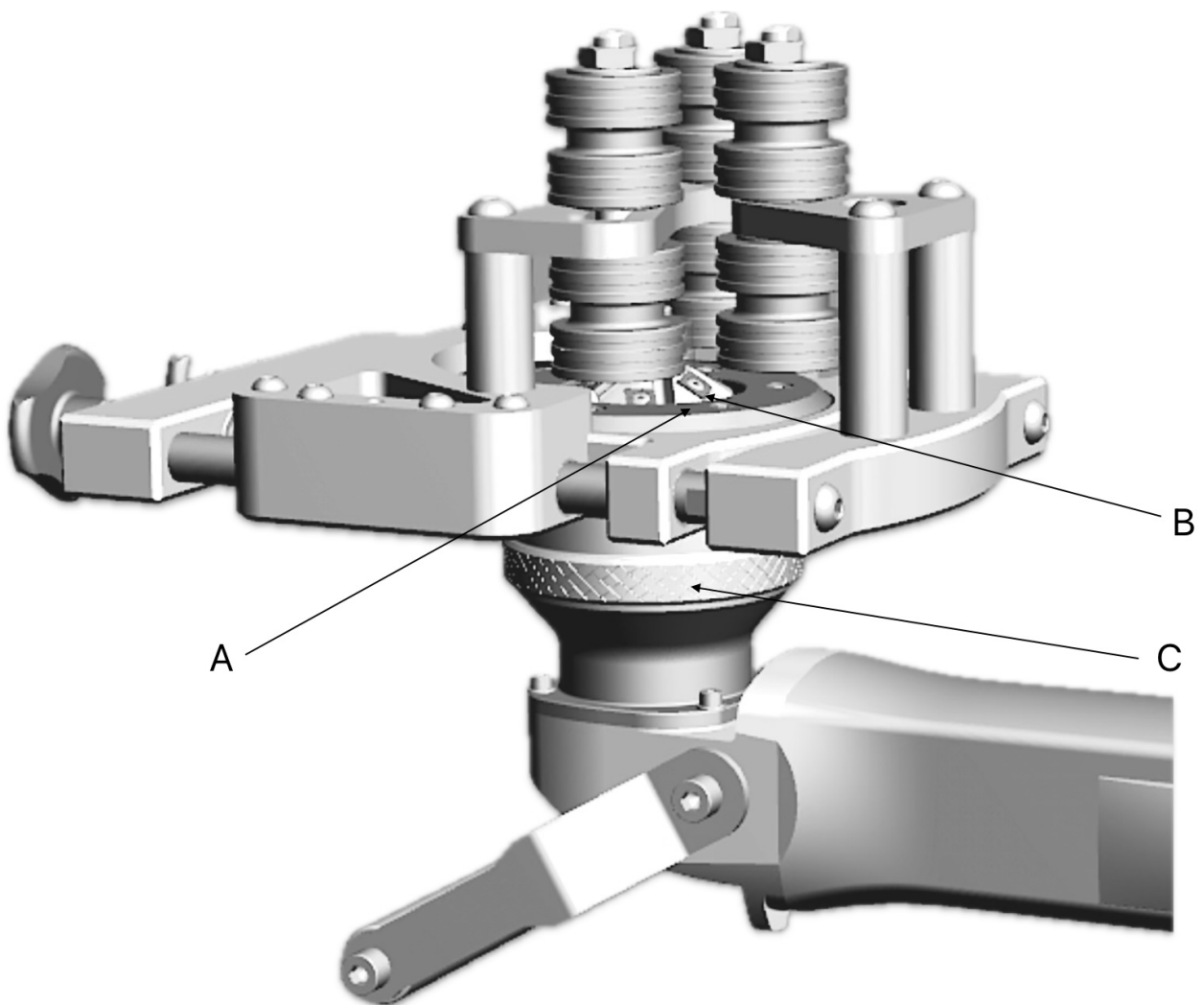


Fig. 4.2.5.



3. Checks before commissioning



Important:

Never start the Xpipe Beveler with the drive unit without performing the checks described in this section.

Before starting work, make sure that the Xpipe Beveler machine with the drive unit is operational by performing the following inspections and checks to achieve maximum efficiency and comply with safety regulations:

- Check that no screws or other parts are loose.
- Make sure that the fixture and its parts do not interfere with the cutting tool and that it rotates freely.
- To start and shut down the machine, follow the instructions in the B10 Electra, B15 Electra, B15 INOX, or B15 AIR operating manual.

4. Destruction and disposal

When disposing of the Xpipe Beveler, keep in mind that the materials from which it is made are not hazardous and mainly include:

- ferritic steel.
- ALU alloys
- plastic materials of various types.

Follow this procedure:

- Follow the applicable laws of your country relating to workplace safety.
- Disassemble the device and sort the components into groups according to their chemical nature.
- Scrap the parts of the device in accordance with the applicable laws of your country.
- Strictly observe applicable occupational safety regulations during the dismantling phases.

5. USE

1. Proper use

The Xpipe Beveler for beveling pipes and flat materials is designed exclusively for use with the B10 Electra, B15 Electra, B15 INOX, or B15 AIR machines manufactured by N.KO Machines.

One of its main advantages is the possibility of clamping the fixture with the B10 Electra, B15 Electra, B15 INOX, or B15 AIR drive unit directly onto the wall of a pipe or flat workpiece material. The advantage of this solution is maximum stability of the fixture on the machined material and elimination of the weight of the machine, which remains suspended on the workpiece thanks to the fixture.

All recommendations regarding use and types of permitted, machinable materials are the same as for the B10 Electra, B15 Electra, B15 INOX, and B15 AIR products (see the manuals for these machines).

The maximum and minimum bevel dimensions and thickness of the machined material are detailed in Chapter 3, Section 3.2 "Technical Specifications."

Any other uses different from those described above are considered inappropriate. More specifically, it is prohibited to:

- process products other than those for which the product is manufactured and sold
- modify the design of the product
- replacing parts with non-original ones
- removing or modifying protective covers



Caution:

It is strictly prohibited to chamfer edges on materials other than those specified, as processing them could pose a risk to operators and damage the equipment.

Before making any modifications, it is necessary to contact the manufacturer to obtain the relevant approval. If this is not done, the manufacturer declines all responsibility.

2. Preliminary settings



Caution:

Wear work gloves when adjusting. Operations must be performed on a machine that is stationary and disconnected from the power supply.



Important:

The Xpipe Beveler is only an accessory for expanding the capabilities of the B10 Electra, B15 Electra, B15 INOX, or B15 AIR machines. All settings for the B10 Electra, B15 Electra, or B15 AIR are listed in the user manual for these machines.

This document only lists the differences related to the operation of the Xpipe Beveler and the B10 Electra, B15 Electra, or B15 AIR machines.

Material preparation

The machined material must meet the conditions specified in Articles 3.2 and 5.1. The chamfered edges of the material must be straight, free of burrs, and free of slag residues after cutting. The ends of the pipes must be cut at a right angle (90°). Otherwise, the Xpipe will not function properly.

3. Machining pipes

- Use the adjusting screw (item E, Fig. 5.3.1) to set the space between the rollers for trouble-free attachment of the Xpipe beveler to the wall of the machined pipe.
- Place the Xpipe Beveler on the pipe.
- **To bevel the outer edge of the pipe**, position the pair of guide rollers (item B, Fig. 5.3.1) outside the pipe and the guide roller (item C, Fig. 5.3.1) inside the pipe.
- **To chamfer the inner edge of the pipe** so that a pair of guide rollers (item B, Fig. 5.3.1) are seated inside the pipe and the guide roller (item C, Fig. 5.3.1) is seated outside the pipe.
- Use the adjusting screw (item E, Fig. 5.3.1) to gradually tighten the Xpipe Beveler fixture to the pipe wall. The guide rollers must be in full contact with the pipe wall on both the outside and inside. The support plate (item A, Fig. 5.3.1.) and, if applicable, the support stones (item D, Fig. 5.3.1.) must touch the edge of the pipe.

- Tighten the Xpipe Beveler on the pipe using the adjusting screw (item E, Fig. 5.3.1) so that the Xpipe Beveler cannot be removed from the pipe and the guide rollers (items B and C, Fig. 5.3.1) are firmly fixed to the surface of the workpiece. The guide rollers are flexibly mounted. This means that when tightened, they exert constant pressure on the material and at the same time are able to adapt to any unevenness on the surface of the material or deviations in the declared wall thickness of the pipe. The characteristics of the flexible mounting can be adjusted by changing the combination of disc springs (item J, Fig. 5.3.1).
- **Caution!!! When installing the Xpipe Beveler on the pipe, pay close attention to the current position of the milling head. It must not come into contact with the workpiece. In case of a possible collision, adjust the position of the milling head using the adjusting screw (pos. F, Fig. 5.3.2).**
- Now you can turn on the Xpipe Beveler drive. When starting, the milling head must be away from the beveled material and must rotate freely! If your B10 Electra, B15 Electra, B15 INOX, or B15 AIR drive is equipped with a switch lock in the on position, you can take advantage of this feature and lock the switch in the on position.
- Using the adjusting screw (item F, Fig. 5.3.2), slowly move the milling head toward the workpiece until the rotating milling cutter touches the workpiece. When the milling head first touches the edge of the workpiece, read the value on the scale (item I, Fig. 5.3.2.). Memorize or note the position on the scale. CAUTION! Even though this undesirable effect is significantly eliminated by the one-way bearings installed in the rollers, be prepared for a possible kickback when the cutting tool comes into contact with the workpiece.
- Now set the desired chamfer size using the adjusting screw (item F, Fig. 5.3.2.). The chamfer height can be read off the scale (item I, Fig. 5.3.2.). Please note that the maximum possible removal of material cannot be achieved in a single step (in a single chip). The maximum possible removal must be divided into several steps. This usually involves 3-4 steps (chips). This issue is described in detail in the user manual for the specific machine B10 Electra, B15 Electra, or B15 AIR. The set removal must be secured with a lock nut (item G, Fig. 5.3.2.). This can be tightened by hand, but it is more convenient to use the holes around the circumference of the nut and a suitable mandrel to increase the tightening torque.
- If you intend to machine several identical bevels, it is possible to set a maximum removal stop on the Xpipe Beveler. The stop screw is located on the bottom of the Xpipe Beveler (item L, Fig. 5.3.2.). Secure the set stop value with a screw (item K, Fig. 5.3.2.).
- The Xpipe Beveler is now ready for machining. Grasp the device by the rotating handle (pos. H, Fig. 5.3.2.) and rotate the entire Xpipe Beveler device in a circular motion around the pipe counterclockwise (from the operator's perspective). At the same time, push the Xpipe Beveler towards the pipe. This will ensure optimal pressure and the machine will follow the edge of the pipe. We recommend holding the drive unit with your other hand, as it is loosely installed in the fixture and can be rotated.
- One or two rotations of the Xpipe Beveler around the pipe are usually sufficient to machine one chip. If the bevel is not as intended, check the settings and repeat the process.
- After machining the first chip, you can continue with further removal or remove the Xpipe Beveler from the pipe. Follow the steps in reverse order to those described above for installing the Xpipe Beveler on the pipe. Loosen the screw (item E, Fig. 5.3.1) and remove the Xpipe Beveler from the pipe.



Important:

We recommend using a suitable cutting oil during machining. For example, MolyInox Art. No. 27256. MolyInox cutting oil significantly extends the service life of the cutting blades and contributes to a better surface quality after machining.



Caution:

The Xpipe Beveler is designed so that most chips and metal waste are removed from the work area and cutting tool, and any metal chips that fly out are shielded by a safety cover. However, some chips may still be thrown towards the operator. Please always wear protective work equipment such as safety goggles, a helmet, and work gloves!



Important:

Always clean the clamping nut area (item B, Fig. 4.2.4.) and the threaded neck of the B10 Electra, B15 Electra, B15 INOX, or B15 AIR drive unit with compressed air to remove all dirt and machining chips. Failure to do so may result in damage to the threads.



Caution:

When using compressed air for cleaning, wear safety goggles and never use a pressure exceeding 2 bar.

Fig. 5.3.1.

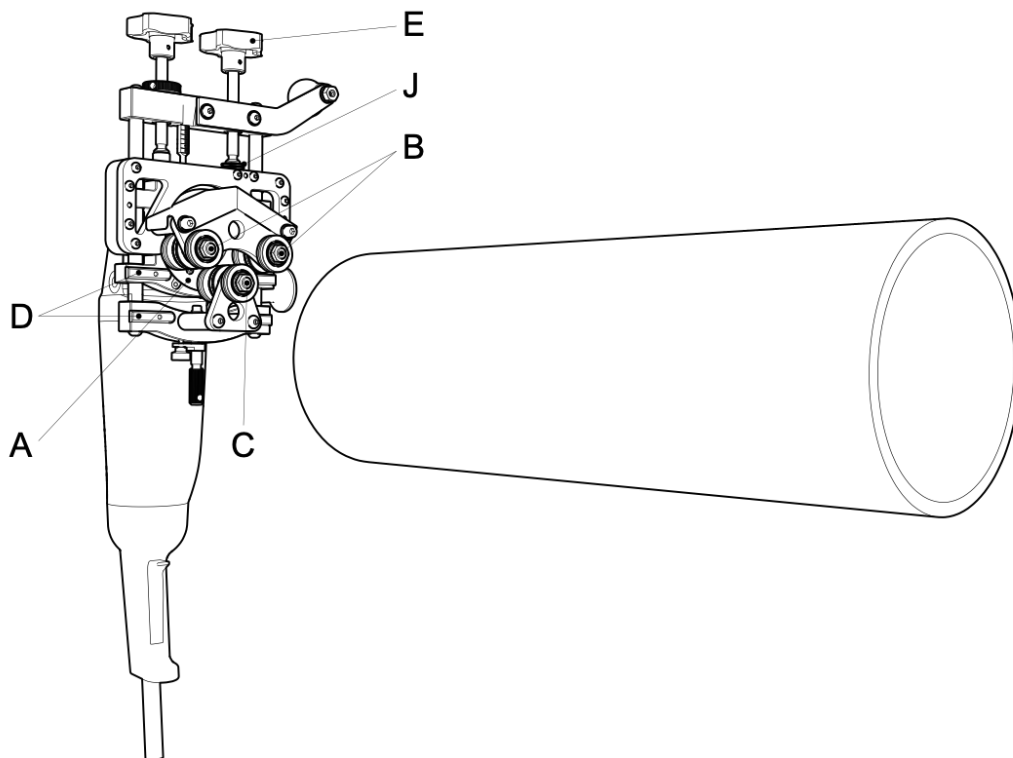
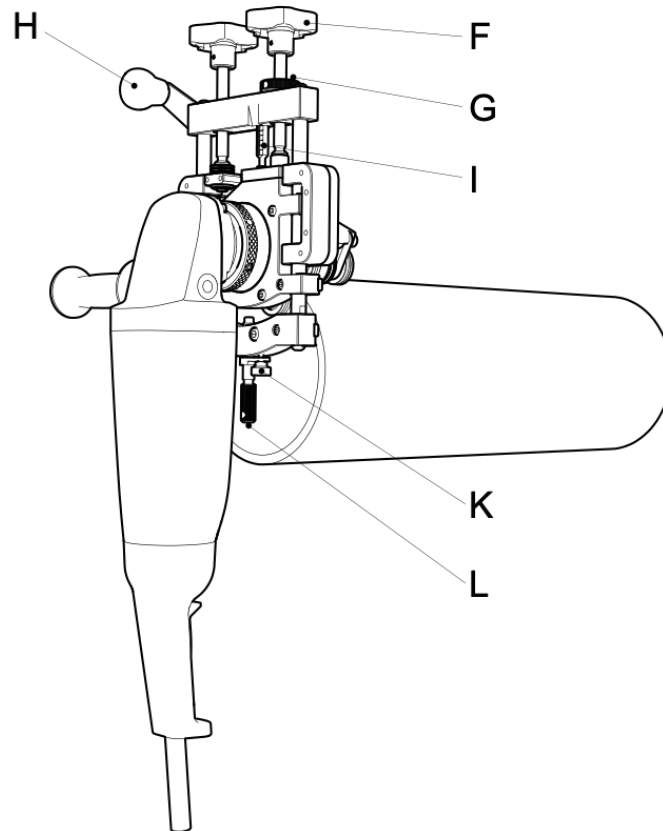


Fig. 5.3.2.



4. Sheet metal machining

The Xpipe Beveler also allows you to bevel sheet metal and other flat materials. When beveling sheet metal, the entire process is very similar. However, instead of rotating around the pipe, you need to apply pressure to the fixture in order to move forward. The second difference is in the mounting on the sheet metal. The Xpipe Beveler is mounted upside down on the sheet metal.



Important:

To use the Xpipe for machining sheet metal and flat materials, an auxiliary handle must be installed. The auxiliary handle (order no. 26252) was supplied with the device, or it can be purchased as an accessory. The auxiliary handle is installed on the Xpipe device using two screws (item E, Fig. 5.4.1).



Important:

The Xpipe is not designed for mounting and machining sheet metal directly from its edge. If you want to chamfer from the very beginning of the edge of the machined sheet metal, it is necessary to use a clamp for the approach plate. The clamp (item no. 26253) was supplied with the device, or it can be purchased as an accessory.

- Use the adjusting screw (item A, Fig. 5.4.2) to set the space between the rollers for trouble-free attachment of the Xpipe beveler to the sheet metal being machined.
- Place the Xpipe Beveler on the sheet metal anywhere along the length of the edge. When working on sheet metal, the Xpipe Beveler must be used upside down. In this position, the cutter is located

under the sheet metal and there is no risk of chips flying off or the cutter coming into contact with the operator's hand.

- **ATTENTION!** If you want to bevel the edges of the sheet metal itself, you must use a clamp for the guide plate. Use any rectangular piece of scrap sheet metal with dimensions of at least 100x100mm and a thickness equal to that of the sheet metal being machined (item B, Fig. 5.4.3.). Use the clamp (item A, Fig. 5.4.3.) to clamp this guide plate to the beginning of the sheet metal you are about to machine. This guide plate allows us to smoothly bevel the workpiece from the very beginning of the edge. The same sheet and clamp can also be used at the end of the sheet for safe removal from the workpiece. The guide plate can be used repeatedly.
- Use the adjusting screw (item A, Fig. 5.4.2) to gradually tighten the Xpipe Beveler fixture onto the sheet metal or the ramp plate. The guide rollers mentioned above must be in full contact with the sheet metal from both the top and bottom sides. The guide ring (item A, Fig. 5.3.1.) and, if applicable, the guide stones (item D, Fig. 5.3.1.) must touch the edge of the sheet metal.
- Tighten the Xpipe Beveler to the sheet metal using the adjusting screw (item A, Fig. 5.4.2) so that the Xpipe Beveler cannot be pulled off the sheet metal and the guide rollers (items B and C, Fig. 5.3.1) are firmly fixed to the surface of the workpiece. The guide rollers are flexibly mounted. This means that they exert constant pressure on the material and are also able to adapt to any unevenness on the surface of the material or deviations in the declared thickness of the sheet metal wall. The characteristics of the flexible mounting can be adjusted by changing the combination of disc springs (item J, Fig. 5.3.1).
- **Caution!!! When installing the Xpipe Beveler on sheet metal, pay close attention to the current position of the milling head. It must not come into contact with the workpiece. In the event of a possible collision, adjust the position of the milling head using the adjusting screw (pos. B, Fig. 5.4.2).**
- Now you can turn on the Xpipe Beveler drive. When starting, the milling head must be away from the beveled material and must rotate freely! If your B10 Electra, B15 Electra, B15 Inox, or B15 AIR drive is equipped with a switch lock in the on position, you can take advantage of this feature and lock the switch.
- Using the adjusting screw (item B in Fig. 5.4.2), slowly move the milling head toward the workpiece until the rotating milling cutter touches the workpiece. At the moment of first contact between the milling head and the edge of the workpiece, read the value on the scale (item I in Fig. 3.1.1).. Memorize or note the position on the scale. **CAUTION!** Even though this undesirable effect is eliminated by the one-way bearings installed in the rollers, be prepared for a possible kickback when the cutting tool comes into contact with the workpiece.
- Now set the desired chamfer size using the adjusting screw (item A, Fig. 5.4.2.). The chamfer height can be read off the scale (item I, Fig. 3.1.1.). Keep in mind that the maximum possible removal of material cannot be performed in a single step (in a single chip). The maximum possible removal must be divided into several steps. This usually involves 3-4 steps (chips). This issue is described in detail in the user manual for the specific machine B10 Electra, B15 Electra, B15 INOX, or B15 AIR. The set removal must be secured with a lock nut (item C, Fig. 5.4.2.). This can be tightened by hand, but it is more convenient to use the holes around the circumference of the nut and a suitable mandrel to increase the tightening torque.

- If you intend to machine several identical bevels, you can set the maximum removal stop on the Xpipe Beveler. Stop screw (item D, Fig. 5.4.2.). Secure the set stop value with the screw (item E, Fig. 5.4.2.).
- The Xpipe Beveler is now ready for machining. Hold the device with both hands by the auxiliary handles (pos. F and G, Fig. 5.4.2.) and push the device along the material from left to right.
- When using the ramp plate, smoothly move over to the final workpiece to ensure machining right from the edge of the sheet metal. When moving over the ramp plate, the rollers may get slightly stuck at the point where the sheets meet. It is usually sufficient to increase the pressure on the handle slightly or shake the entire device a little.
- Removing the Xpipe device from the sheet metal is usually very easy and requires only slight pressure on the front part of the handle (pos. G, Fig. 5.4.2) to keep the Xpipe device in a horizontal position. If you find this operation inconvenient, we recommend installing a clamp for the ramping or sliding sheet metal at the end of the workpiece as well. For this purpose, it is best to purchase an additional clamp for this purpose only.
- After machining the set bevel, you can continue with further removal. Proceed as described above until you achieve the desired bevel size.

Fig. 5.4.1.

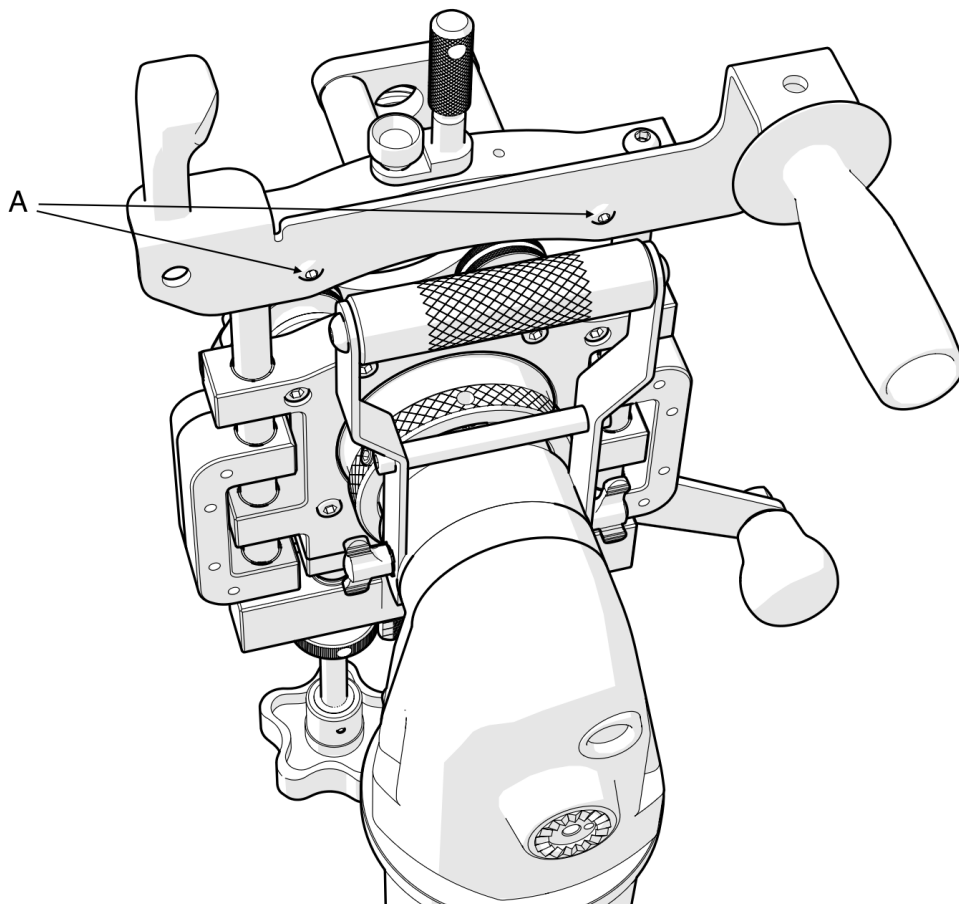


Fig. 5.4.2.

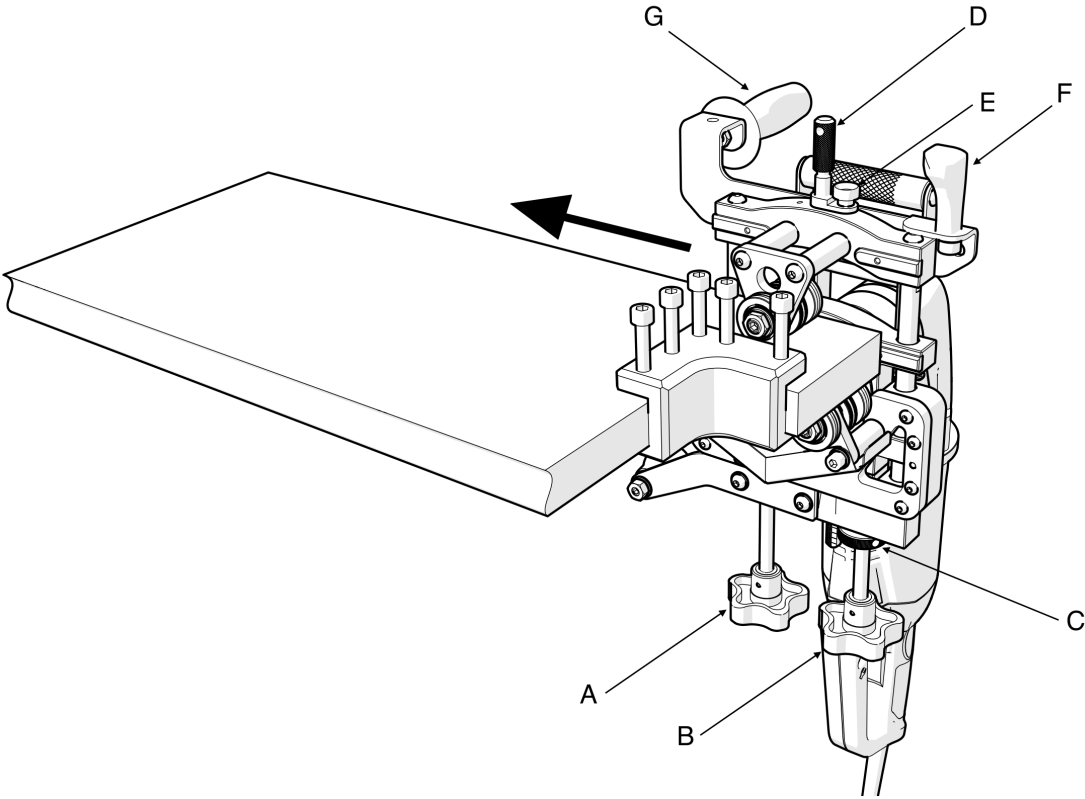
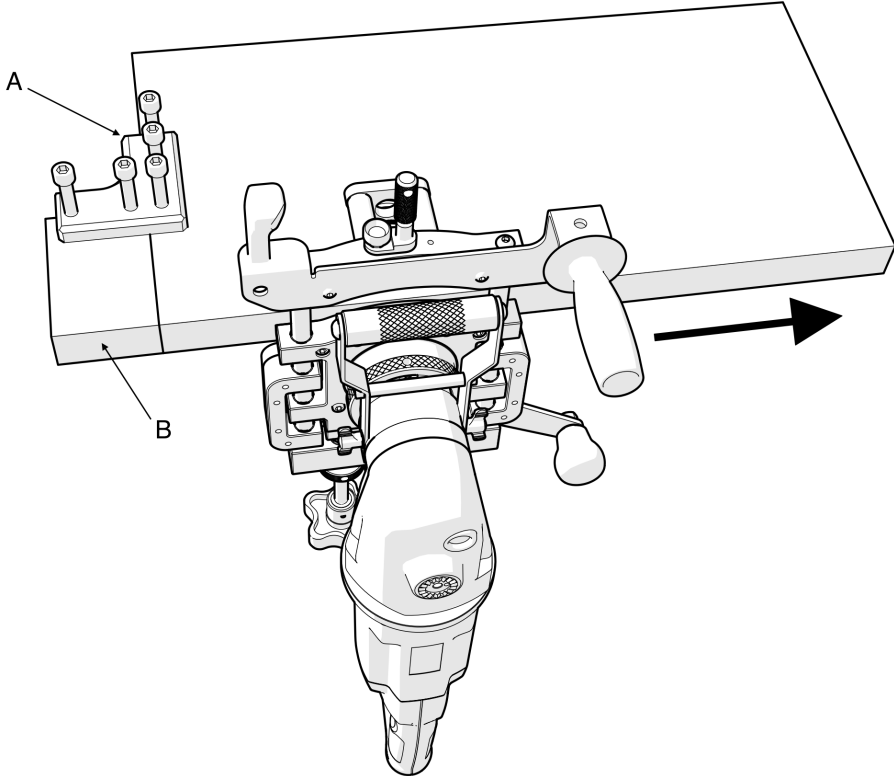


Fig. 5.4.3.





Important:

Keep the area in front of the travel rollers clean. Any forgotten chips or other obstacles can complicate the smooth movement of the Xpipe over the material.



Important:

We recommend using a suitable cutting oil for machining. For example, MolyInox Art. No. 27256. MolyInox cutting oil significantly extends the service life of cutting inserts and contributes to a better surface quality after machining.



Caution:

The Xpipe Beveler is designed so that most chips and metal waste are removed from the work area and cutting tool, and any metal chips are shielded by a safety cover. However, some chips may still be ejected towards the operator. Please always wear protective work equipment such as safety goggles, a helmet, and work gloves!



Important:

Always clean the clamping nut area (item B, Fig. 4.2.4.) and the threaded neck of the B10 Electra, B15 Electra, B15 INOX, or B15 AIR drive unit with compressed air to remove all dirt and machining chips. Failure to do so may result in damage to the threads.



Caution:

When using compressed air for cleaning, wear safety goggles and never use a pressure exceeding 2 bar.

6. MAINTENANCE AND ADJUSTMENT

1. Recommendations



Important:

Maintenance personnel must be qualified technicians.

Never work on moving parts, even with tools or other objects.

It is strictly forbidden to remove or modify safety devices or covers. In the event of such action, the manufacturer declines all responsibility for the safety of the machine and accessories.

Always use original spare parts (see Chapter 7 "Spare Parts").



Caution:

Always wear work gloves when performing maintenance on the machine. Perform maintenance operations on the machine when it is at a standstill and disconnected from the power supply.

Before or after each work shift, or as needed, clean the machine, fixture, and moving parts with compressed air.

It is advisable to lubricate moving parts occasionally with universal oil. For example, WD-40.



Caution:

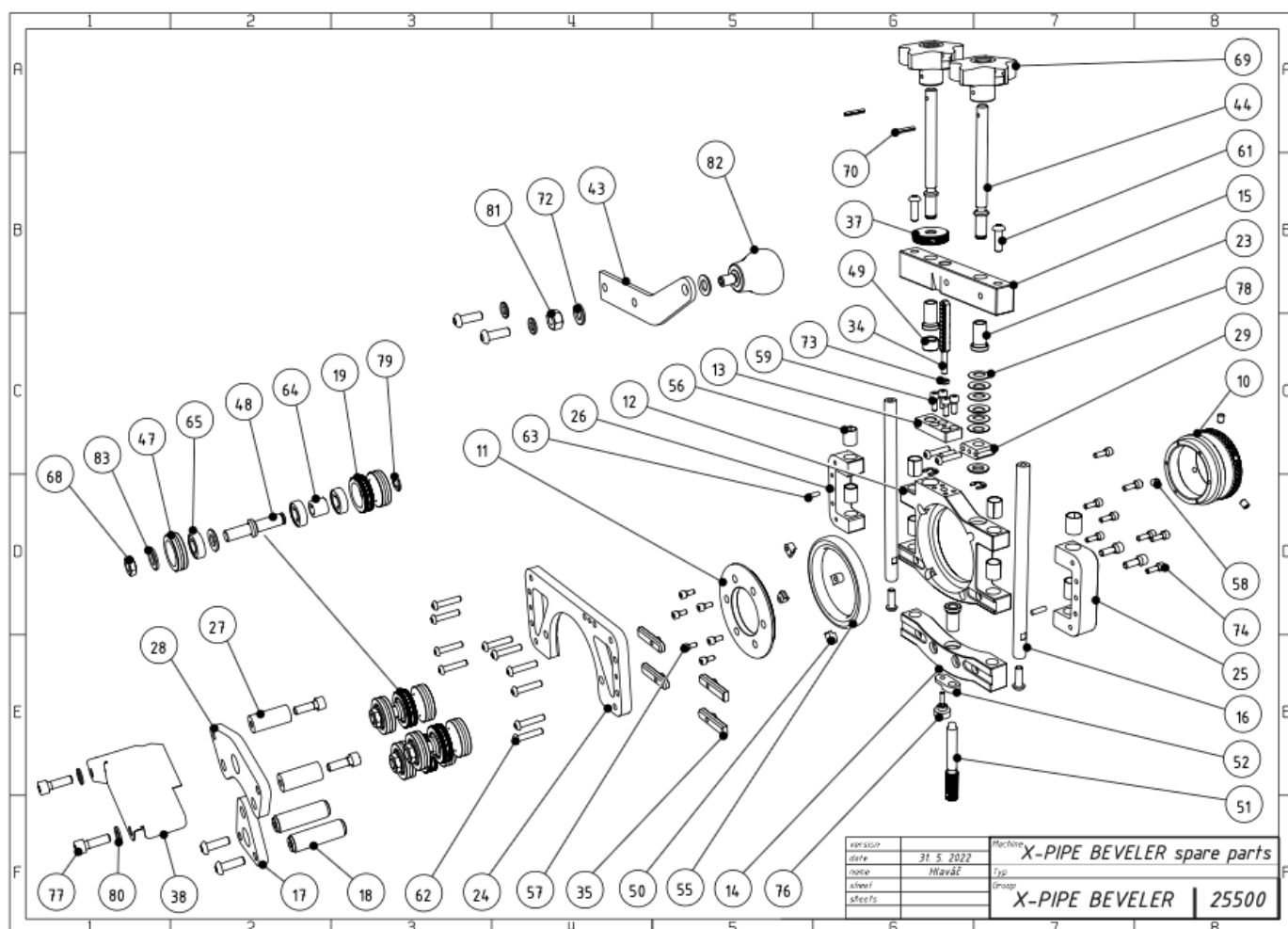
When using compressed air for cleaning purposes, wear safety goggles and never use a pressure exceeding 2 bar.

7. SPARE PARTS

7.1 How to order spare parts

Orders and requests for spare parts must include the following information:

- machine/device type
- description of the required part and its photo
- quantity.



X-PIPE BEVELER

drawing no. 25500 X-PIPE BEVELER

Number	Fig	Part name	Pcs	Number	Fig	Part name	Pcs
25500.10	10	nut	1	25500.56	56	KU housing	8
25500.11	11	ring	1	25500.57	57	screw	6
25500.12	12	drive bearing body	1	25500.58	58	screw	3
25500.13	13	attachement	1	25500.59	59	screw	4
25500.14	14	lower connector	1	25500.61	61	TORX screw	8
25500.15	15	upper connector	1	25500.62	62	TORX screw	12
25500.16	16	lead	2	25500.63	63	pin	3
25500.17	17	board	1	25500.64	64	rolling bearing	3
25500.18	18	column	2	25500.65	65	ball-bearing	9
25500.19	19	pulley	3	25500.68	68	low nut	3
25500.23	23	threaded housing	3	25500.69	69	wheel	2
25500.24	24	support board	1	25500.70	70	spring pin	2
25500.25	25	left support lead	1	25500.72	72	washer	2
25500.26	26	right support lead	1	25500.73	73	low nut	1
25500.27	27	support column	2	25500.74	74	screw	8
25500.28	28	pulley board	1	25500.76	76	hand wheel	1
25500.29	29	support hinge	1	25500.77	77	screw	6
25500.34	34	nonius	1	25500.78	78	disc spring	6
25500.35	35	lead	4	25500.79	79	lock ring	5
25500.37	37	safety nut	1	25500.80	80	washer	4
25500.38	38	cover	1	25500.81	81	nut	1
25500.43	43	swivel handle holder	1	25500.82	82	swivel handle	1
25500.44	44	moving screw	2	25500.83	83	washer	7
25500.47	47	low pulley	3				
25500.48	48	shaft	3				
25500.49	49	distance ring	1				
25500.50	50	bearing clamp	4				
25500.51	51	stop screw	1				
25500.52	52	safety pad	1				
25500.55	55	ball-bearing	1				

A copy of this manual is supplied with every Xpipe Beveler.

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