

# MANUAL BEVELLING AND DEBURRING SYSTEM B10 ELECTRA



Ord. no. 25300 (1 Phase – 220V)

25301 (1 Phase – 110V)

## Operation manual for the device

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**Read the operation manual carefully prior to use**

## 1. General information

Thank you for purchasing one of our machines, and we hope that you will be fully satisfied.

This guide provides instructions for the installation, adjustment, operation and maintenance of the machine B10 ELECTRA in compliance with valid safety standards.

**The information and data contained in this document subject to changes due to further improvement of machinery. To eliminate any doubts, when differences are detected, please contact N.KO Machines.**

Never perform any operation on the machine before you read the instructions in the manual and understand them. Major part of accidents that happen in the workplace are due to the fact that the guidelines and recommendations contained in the manual are not complied with.

The graphic symbols used in the manual are intended to emphasize the important information regarding the safety and operation of the machine.



**Attention :**

**Information important for the personal safety of the operating staff.**



**Important:**

**Instruction that needs to be observed to ensure the proper function of the machine.**

## 2. Machine description B10 ELECTRA

**Machine B10 ELECTRA is designed solely for the activities below:**

B10 ELECTRA is designed solely for bevelling and fetch fettling of metal materials in the workshop or in the production hall.

This includes manual and manually managed machine. The main feature of the machine is the ability to machine flat and shaped workpieces, openings, and tubes. The machining angle can be changed by replacing the milling head. B10 ELECTRA can perform also the workpiece edge rounding. This application also requires a special tool, see the text below.

Use the machine in the environment protected from rain, snow, and other adverse weather conditions.

### 3. Identification data and CE Declaration of Conformity

The identification data of machine B10 ELECTRA are listed on the label placed on the drive unit.

#### EC Declaration of Conformity

1. Name and surname of the declaration issuer: N.KO spol s.r.o.  
Address of the declaration issuer: Tábořská 398/22  
CRN: 2616109
  
2. Subject matter of the declaration:  
Name: HAND HELD BEVELLING MACHINE  
Type: **B10 ELECTRA**  
Manufacturer: N.KO, spol. s r.o.
  
3. Intended use: Edge bevelling of sheets as preparation for welding
4. The above-stated subject matter of the declaration complies with requirements of the following documents:  
  
Directive 2006/42/EG: Machinery Safety – Basic Requirements  
  
Directive 2014/30/EU: Electromagnetic Compatibility  
  
Directive 2011/65/EU: Absence of hazardous substances  
  
EN ISO 12100: Safety of machinery - Basic concepts, general principles for design – Risk Assessment and Risk Reduction  
  
EN ISO 13857: Safety of machinery – Safety distances to prevent hazard zones being reached by upper and lower limbs  
  
EN 953: Safety of machinery – Guards – General requirements for the design and construction of fixed and movable guards  
  
EN 60204-1: Safety of machinery – Electrical equipment of machines  
  
EN 60745-2-17: Hand held electromechanic machinery – safety – Part1.: General requirements  
  
EN 50581:2012 Technical documentation for assessment of electrical and electronic products in terms of reduction of hazardous substances  
  
EN 61000-3-2 Electromagnetic-compatibility (EMC) - Part 3-2: Limits - Limits for harmonic current emissions-(device with input phase current ≤16 A)  
  
EN 61000-3-3 Electromagnetic-compatibility (EMC) part of the furnace 6-3: Generic standards - Emission standard for residential, commercial and light industry
  
5. Data on accredited / notified person:  
Date and place of issue: 1. OCTOBER 2017 Mladá Boleslav  
Name and position of the authorized person: Milan Richtr – managing director

Signature of the authorized person:



## 4. Tests

The machine for edges bevelling is tested in our test room.

During that test, the correct function of bevelling sheets and profiles by different types and sizes, are tested.

## 5. Warranties

The B10 ELECTRA is provided by the seller with a guarantee that the article shall not feature any material and production defects for a period of 12 months following the delivery date.

The machine is provided with a 12-months' guarantee from the delivery date for the faultless function of the article and the materials used.

The seller undertakes to make sure that any potential warranty defects are removed free of charge and without undue delay so that the buyer is able to use the article the way they desire. Should the buyer claim liability for warranty-unrelated defects, it shall reimburse the seller for any expenses associated with that.

### **The manufacturer considers the guarantee invalid if:**

- the machine is improperly used.
- used in conflict with national or international standards
- improper installation
- defective power supply
- severe shortcomings in maintenance
- unauthorised modifications or interventions
- other than the original or unapproved parts and accessories by the manufacturer are used for that model;
- full or partial failure to follow the instructions in this manual
- extraordinary events, natural disasters or the like.

## 6. Safety regulations



### Attention :

**In order to prevent the injury observe the below instructions**

Inspect the machine for mechanical and other damage prior to bevelling.

**Commission the machine solely if the electricity supply cable is not damaged.**

Check the supply cord regularly. In case of damage have it replaced in an authorised service shop authorised to perform the such repairs. Contact your supplier.

### Personal protection from injury

During the work use safety goggles, solid work footwear, hearing protection, suitable head cover, e.g. safety helmet.

- Connect the machine in electrical network solely if the machine is in off position.
- Prior to each use, check the device and electricity supply cord for damage. Do not use the machine in case of any damage.
- Do not use the machine in humid environment and protect from high moisture.
- Ensure good lighting at the workplace to prevent the risk of potential injury or eyesight damage.
- Caution, the tool (milling machine) is sharp with the risk of injury. During the replacement use safety gloves, **never touch the miller which moves.**
- The machined material must always be fastened and horizontal. Optimum workpiece height is 900 mm above ground.
- During work pay attention to the electricity supply cable; it should be loosely placed on the ground outside the worked material and other sharp objects.
- After work, disconnect equipment from the electricity supply.
- Do not overload the machine motor. The machine operates better if not overloaded.
- During work, hold the device by both hands.
- Attention is drawn to the injury hazard with hot metal shavings.



### Important:

In case of damage have the machine repaired in an authorised service shop authorised to perform the repairs. For more information on, contact your supplier.

## 7. Technical specifications

Bevel angle	Replacement head 30°, 37,5°, 45°, 50°. 60° other angles upon request
Bevel width (45°)	0 to 10 mm / 0 to 0,4 in < 400N/mm <sup>2</sup> / 58 015 PSI - 0 to 5 mm > 400N/mm <sup>2</sup> / 58 015 PSI
Rounding	max R 4 mm / 0,16 in
Motor	electric
Motor power	1700W/50Hz - 1500W/60Hz
Revolutions	2700 - 8500 rpm
Weight	6 kg/ 13.2 lb.
Number of indexable inserts	6 pcs (milling head for rounding edges 3pcs)

### 7.1. Beveling holes and openings – minimum dimensions

Bevel angle $\alpha^\circ$	Minimal diameter of the hole in mm	Minimal diameter of the hole in mm
	Type PREMIUM	Type ECO
30°	30 mm (*33 mm)	Ø 34 mm
37,5°	26 mm (*31 mm)	Ø 28 mm
45°	26 mm (*31 mm)	Ø 28 mm
50°	26 mm (*31 mm)	Ø 28 mm
60°	19 mm (*25,5 mm)	Ø 27 mm
R 2,5mm	-	Ø 41 mm
R 3,5/4mm	-	Ø 40 mm

## 8. Machine equipment

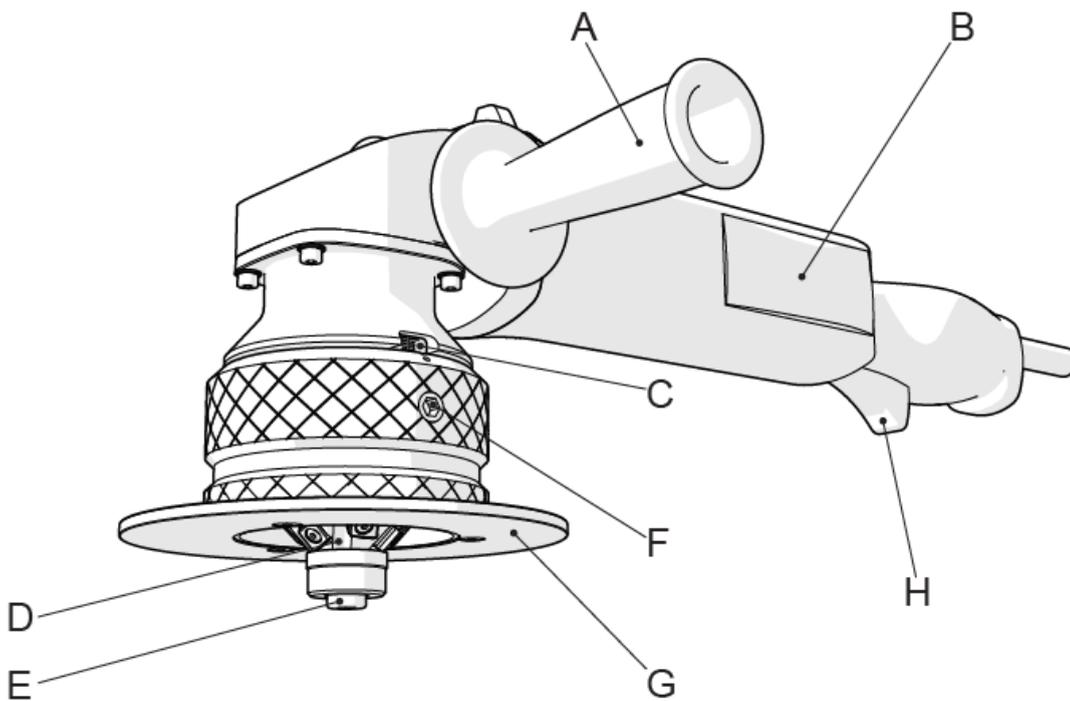
Unpack the machine from the cardboard box and check if the machine is ok and free from damage. If necessary contact the seller.

**Machine B10 ELECTRA is supplied with required tools for the operation without the tool.**

Purchase the tools. The review of tools is defined in chapter 8. Accessories or in the catalogue of N.KO Machines and contact your supplier.

## 9. Control elements B10 ELECTRA

Fig.10.0.1



- A. Handle
- B. Motor body
- C. Scale for reading the bevel size setting
- D. The miller unit with indexable inserts
- E. Guiding, stop miller roller and roller screw
- F. The arresting screws of the thrust plate sleeve – The set removal provision
- G. The thrust plate with sleeve
- H. Main switch

## 10. Use

### **Important:**

The device can be used solely if it is fitted with the original indexable inserts supplied by our supplier, i.e. the device manufacturer. It includes four-sided indexable inserts. The device can be fitted with 6 pieces of indexable inserts. It is prohibited to use other than original inserts.

### 1. Setting the removal size

### **Attention :**

**During the adjustment operation, wear gloves and other personal protective equipment. The operations must be carried out on the machine at rest and after disconnecting from the power supply.**

- Disconnect the machine from electricity supply.
- Release the setting arresting screws (fig.10.0.1 position F)
- Turn the guiding plate (fig.10.0.1 position G) for setting the reduction size. You can read the setting on the scale (fig.10.0.1 position C). The scale is just indicative. The final result bevel size can be little bit different according of the milling head you are using.
- After setting, fasten both screws (fig.10.0.1 position F).

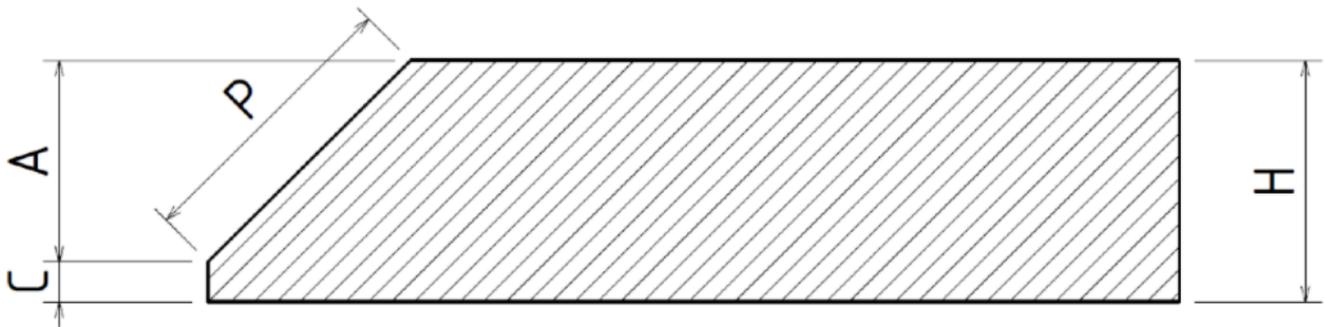
### **Important:**

Maximum reduction is 10mm of bevel width (dimension P fig.11.1.1). The reduction can be achieved in more steps. It depends on the material solidity. We recommend performing the test.

Start with lower reduction and gradually increase the value until the work with the machine is comfortable and the plates can achieve gradually reduction without increased vibrations. For orientation setting, use the tables below.

We recommend administering the work log for recording the measured value and the machining procedure.

Fig. 11.1.1



For orientation setting of the reduction size and the independent machining process, use the setting tables for individual bevel angles.

**● Important:**

**The values in the table are calculated from point 0. Point is the point when the miller touches the material edge for the first time. This point can be set by gradual turning of the thrust plate (fig.10.0.1 position G) and placing to the material edge.**

**45°** - For full bevel (P=10mm) is required, turn the thrust plate by 40 revolutions

Chip no.	Hypotenuse <b>P</b>	Bevel height <b>A</b>	Number of rpm of the thrust plate (Fig.10.0.1 pos. G)
I.	5mm/0,19 in	3.5mm/0,13 in	2 Revolutions
II.	10mm/0,39 in	7.7mm/0,30 in	+ 2 Revolutions

 **Important:**

The machine was constructed for the preparation of welded surfaces. Machining accuracy is within limit +/-1mm. The condition for reaching the satisfactory results is a perfect preparation of the material edges. Unfortunately the material is often burned or cut. The inaccuracy shall be reflected on the resulting machining.

 **Important:**

If it is difficult to machine the bevel within the recommended number of steps, we recommend dividing the process to more chips. The reason can be the wear of the cutting inserts or worse machining properties of material.

## 2. Beveling

- Connect the device in electricity distribution
- Set correct RPM in the range of 4 - 6 on the plastic regulation wheel.
- After careful setting of the first reduction, see clause 11.1, hold the device with both hands and use the main switch to switch on the device.
- Fit the machine on material in such way the thrust/contact plate (fig. 10.0.1 position G) was in contact with material at maximum possible surface.
- Slowly move the machine to the material until you feel the milling machine is in reduction. CAUTION!!! The rebound is possible at this moment, be careful.
- Press the machine in the direction into the material until the miller is embedded in the material in the full profile of the set chip. Contact roller (fig. 10.0.1 position E) must now touch the workpiece edge. The thrust plate (fig. 10.0.1 position G) must be placed with the surface on material.
- Now, you can start the machining from the left to the right. Shift the machine constantly; using only such speed the milling machine was able to remove material in the set chip profile. Otherwise, the milling machine will be pushed out from the material and the bevel will be unequal.

 **Important:**

**B10 Electra allows to adjust RPM continuously in the range 2700 - 8500 RPM. Current RPM is possible to check on the setting regulation wheel, which is located on the upper side of the motor house B10 Electra (values 1 - 6). For beveling of the steel is strictly recommended to use setting in the range 4 - 6 on that regulation wheel only. In the case of the setting lower RPM there is the risk of the damaging of the gearbox due to too high vibrations.**

 **Attention :**

**During work, wear gloves and other personal protective equipment.**

**The maintenance operations must be carried out on the machine at rest and after disconnecting from the power supply.**

**Important:**

The shift during machining is always from left to the right.

**Attention :**

The device operators must hold the device with both hands.

### 3. Bevel angle and shape change. Milling head replacement – Type ECO

Machine B10 ELECTRA is constructed for the use of more milling heads.

For the head replacement, proceed as follows.

- Disconnect the machine from electricity supply.
- Release the setting arresting screws (fig.11.3.1 position A) by the enclosed allen key (fig. 11.3.1 position C)
- Turn the guiding plate (fig.11.3.1 position B) for complete disassembly from the machine
- Secure the spindle against turning with the button, which is located on the top side of the gearbox (fig 11.3.2 position A) or by using the enclosed mandrel (fig. 10.3.3 position A)
- Use the allen key (fig.11.3.2 position D), release and disassemble the roller screw (fig. 11.3.2 position C) and roller (fig.11.3.2 position B)
- Now disassemble the milling head by enclosed special tube, double-sided spanner (fig.11.3.3 position B plus C)
- Use the same process to assemble new head and reassemble the machine.
- All connections must be appropriately fastened.

Fig. 11.3.1

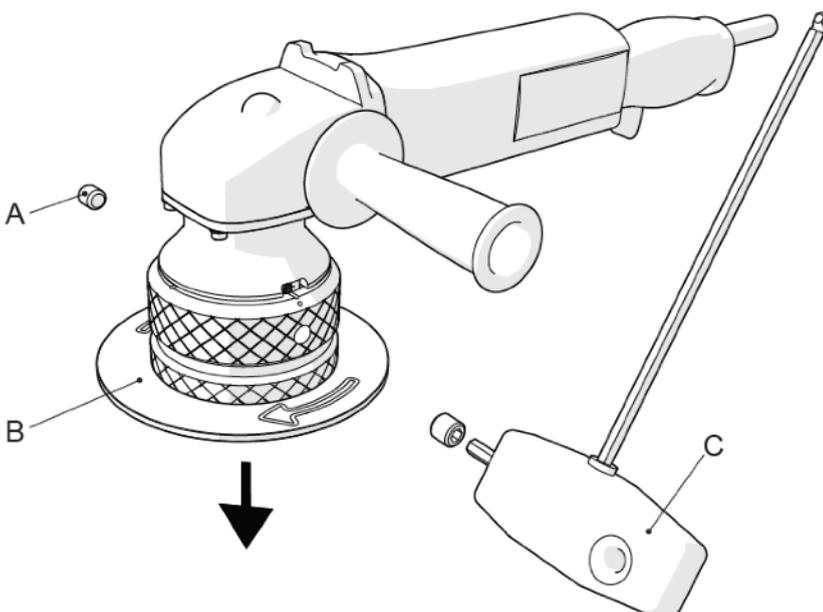


Fig. 11.3.2

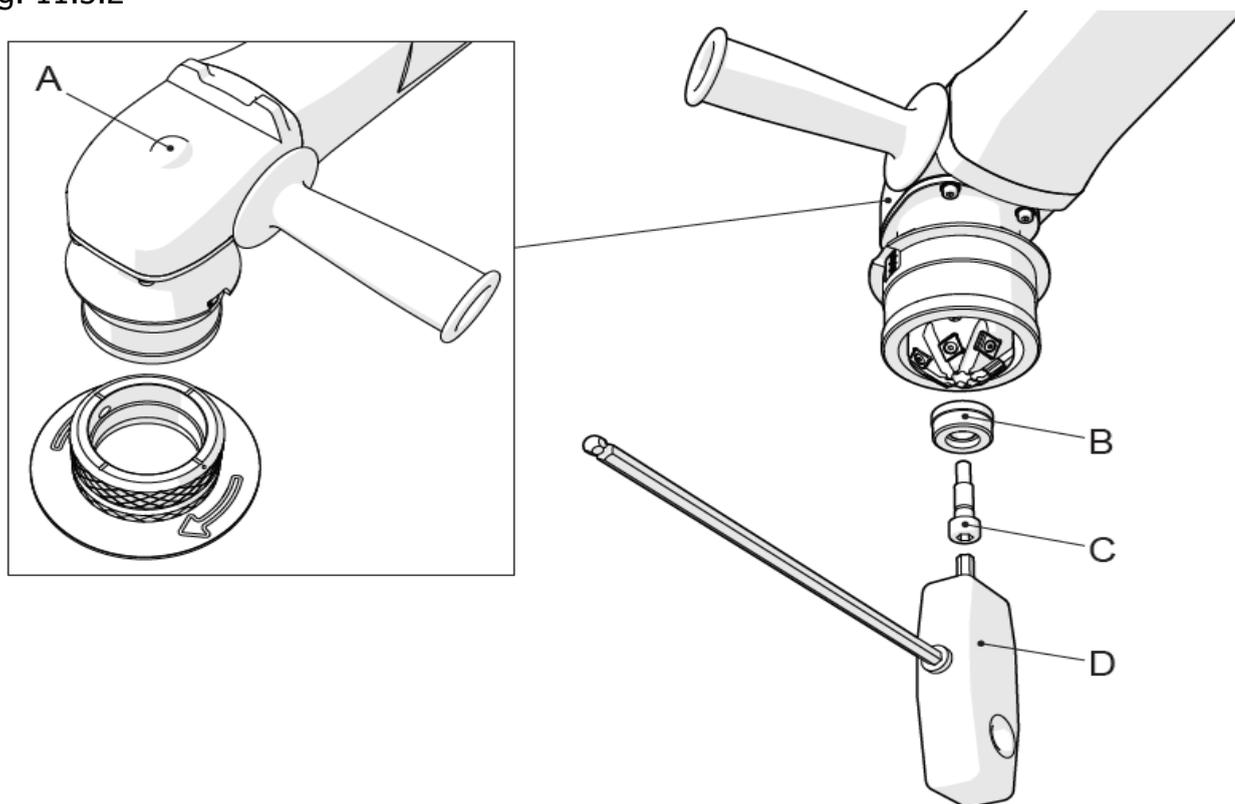
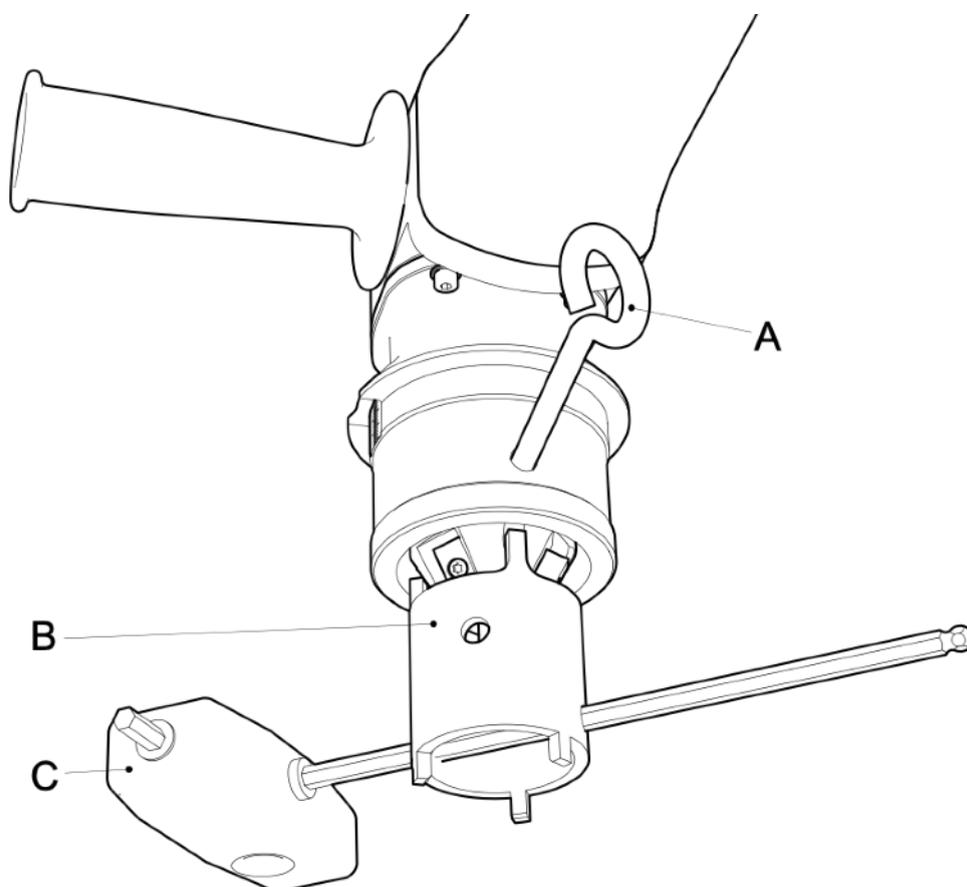


Fig. 11.3.3



**Important:**

**Always, when the milling head is replaced, treat the head thread and the screw with copper-containing grease (copper paste). This paste prevents the thread of the milling head from being jamed / sealed and facilitates future loosening.**

**Attention :**

**During the adjustment operation, wear gloves and other personal protective equipment. The operations must be carried out on the machine at rest and after disconnecting from the power supply.**

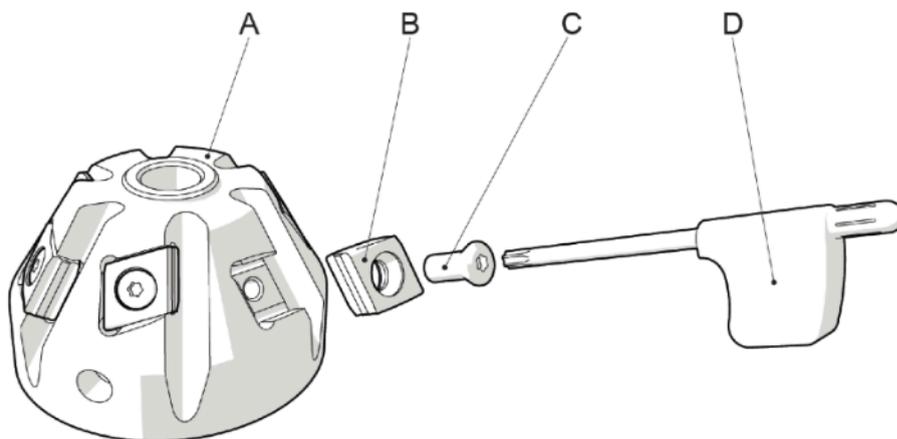
#### 4. Replacement of indexable inserts - ECO

**Important:**

**Work solely with sharp and not damaged indexable inserts. It prevents the machine damage. If the cutting inserts are worn or damaged or cracked, they must be replaced.**

- Attach the wrench (fig. 11.3.1 position D) release the screws used for fastening the indexable inserts (fig. 11.3.1 position C)
- Indexable inserts (fig. 11.3.1 position B) replace with new, different, or just turn them to use all cutting edges.. Attention! Considering the specific shape, focus on this operation.
- Indexable inserts must be appropriately fastened (fig. 11.3.1 position C).
- Assemble the guiding plate set according to chapter 11.3

Fig. 11.4.1



## 5. Bevel angle and shape change. Milling head replacement – Type PREMIUM

Machine B10 ELECTRA is constructed for the use of more milling heads.

For the head replacement, proceed as follows.

- Disconnect the machine from electricity supply.
- Release the setting arresting screws (fig.11.5.1 position A) by the enclosed allen key (fig. 11.5.1 position C)
- Turn the guiding plate (fig.11.5.1 position B) for complete disassembly from the machine
- Secure the spindle against turning with the button, which is located on the top side of the gearbox (fig 11.3.2 position A) or by using the enclosed mandrel (fig. 10.5.2 position A)
- Now disassemble the milling head by enclosed special tube, double-sided spanner (fig.11.5.2 position B plus C)
- Use the same process to assemble new head and reassemble the machine.
- All connections must be appropriately fastened.

Fig. 11.5.1

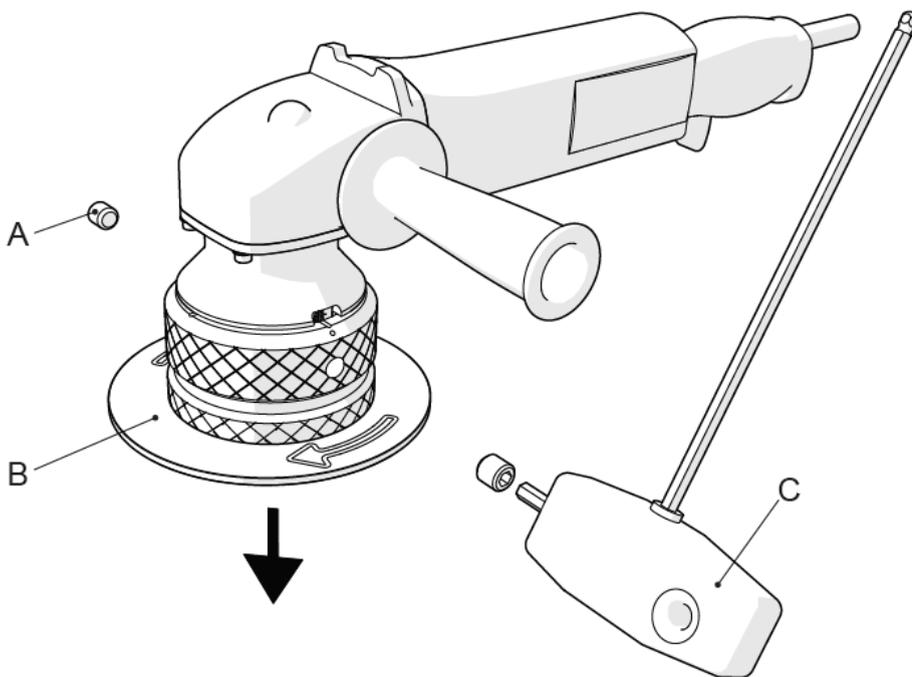
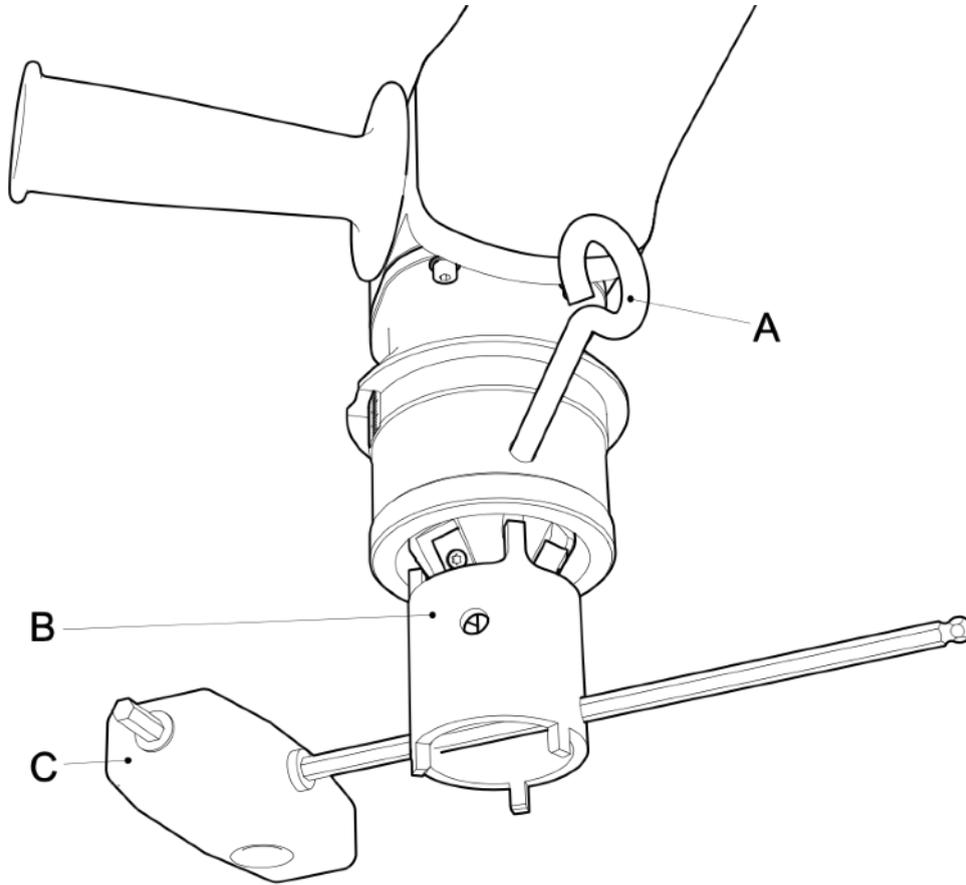


Fig. 11.5.2



**Important:**

**Always, when the milling head is replaced, treat the head thread and the screw with copper-containing grease (copper paste). This paste prevents the thread of the milling head from being jamed / sealed and facilitates future loosening.**

**Attention :**

**During the adjustment operation, wear gloves and other personal protective equipment. The operations must be carried out on the machine at rest and after disconnecting from the power supply.**

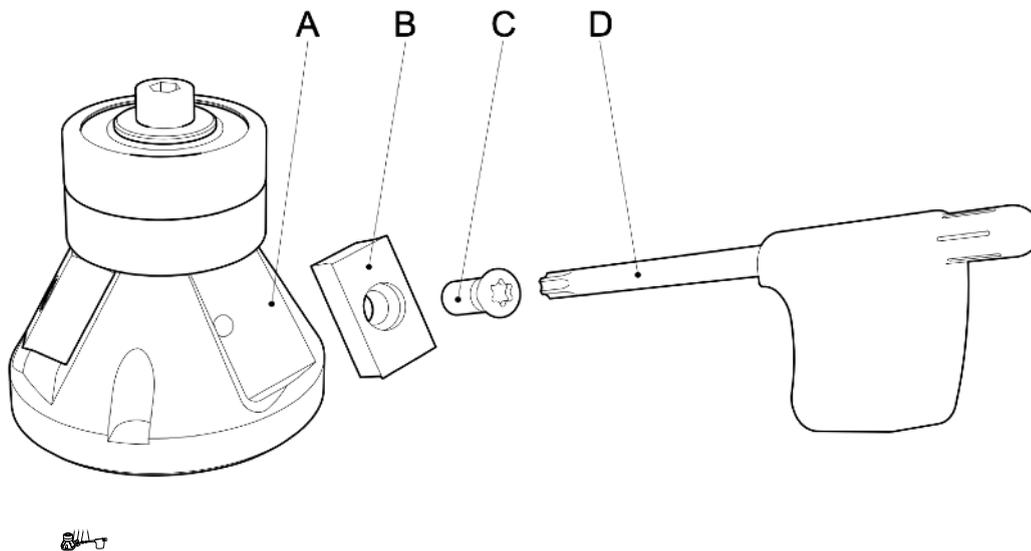
## 6. Replacement of indexable inserts - PREMIUM

### Important:

**Work solely with sharp and not damaged indexable inserts. It prevents the machine damage. If the cutting inserts are worn or damaged or cracked, they must be replaced.**

- Attach the wrench (fig. 11.6.1 position D) release the screws used for fastening the indexable inserts (fig. 11.6.1 position C)
- Indexable inserts (fig. 11.6.1 position B) replace with new, different, or just turn them to use all cutting edges.. Attention! Considering the specific shape, focus on this operation.
- Indexable inserts must be appropriately fastened (fig. 11.6.1 position C).
- Assemble the guiding plate set according to chapter 11.5

Fig. 11.6.1

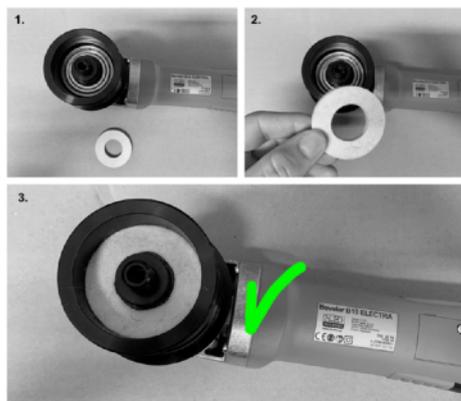


## 12. Maintenance and operation

Maintenance of machine B10 ELECTRA does not require any special tools and it is very simple. Keep the machine clean and replace the lubrication grease in the machine gearbox every 1000 working hours. This operation must be performed solely in authorised service N.KO Machines.

Regularly check the supply power cable. In case of damage have it replaced in an authorised service shop authorised to perform the such repairs. Contact your supplier.

When using the B10 Electra with or without the B-Dock accessory, we strictly recommend to instal the protection felt plug into the headstock. The felt plug ord.No. 25315 is needed to buy separately as a accessory. The plug protects the auxilliary bearing and the gear against to be damaged.



### **Important:**

**The moving parts, threads, and mechanical connections must be gradually cleaned using compressed, and must be preserved (greased).**

### **Attention :**

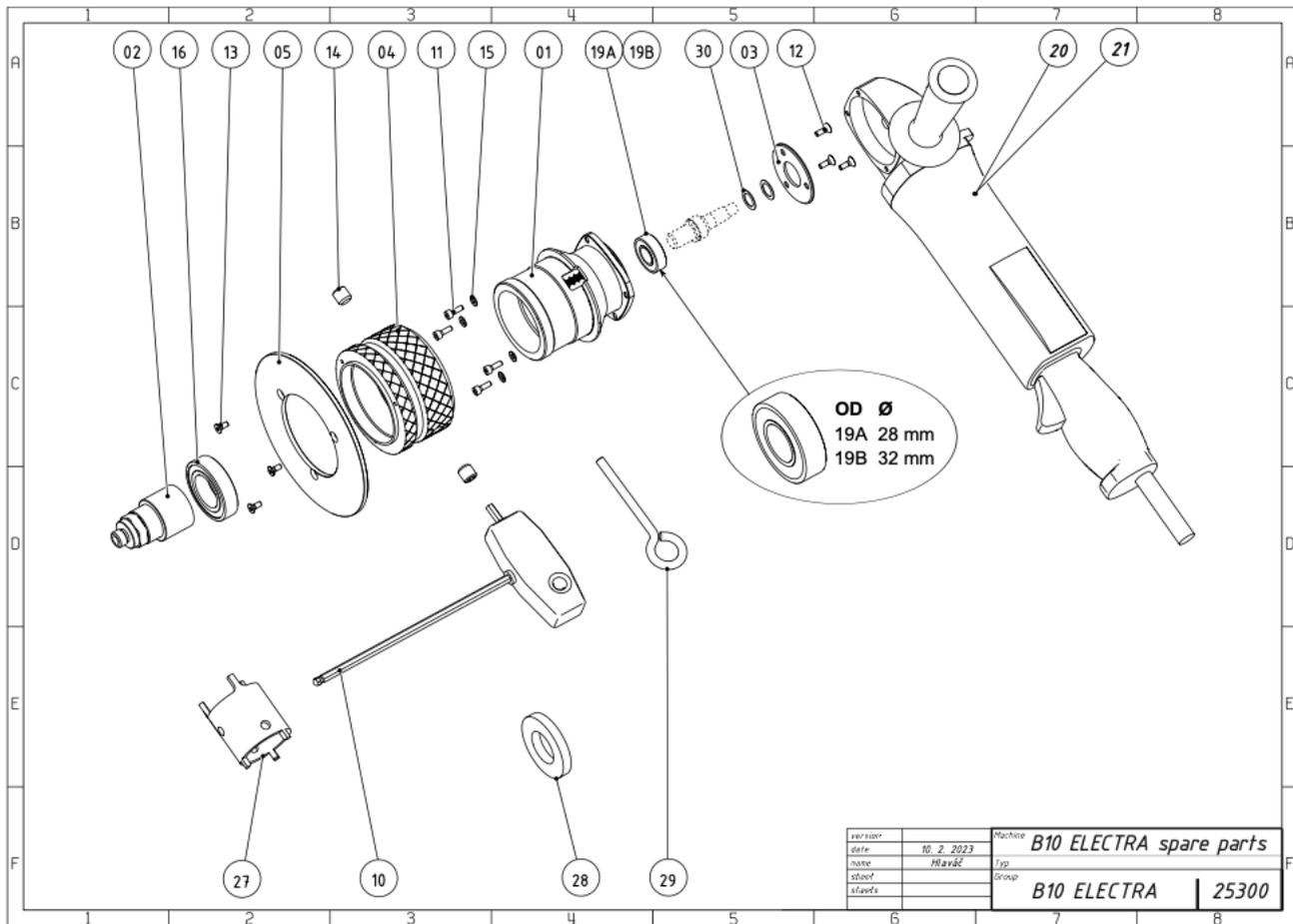
**When using compressed air for cleaning, wear safety goggles and never use a pressure exceeding 2 bar.**

## **13. Spare parts**

Orders of spare parts shall contain the following information:

- machine type;
- serial number;
- Description of required part and its number
- quantity.

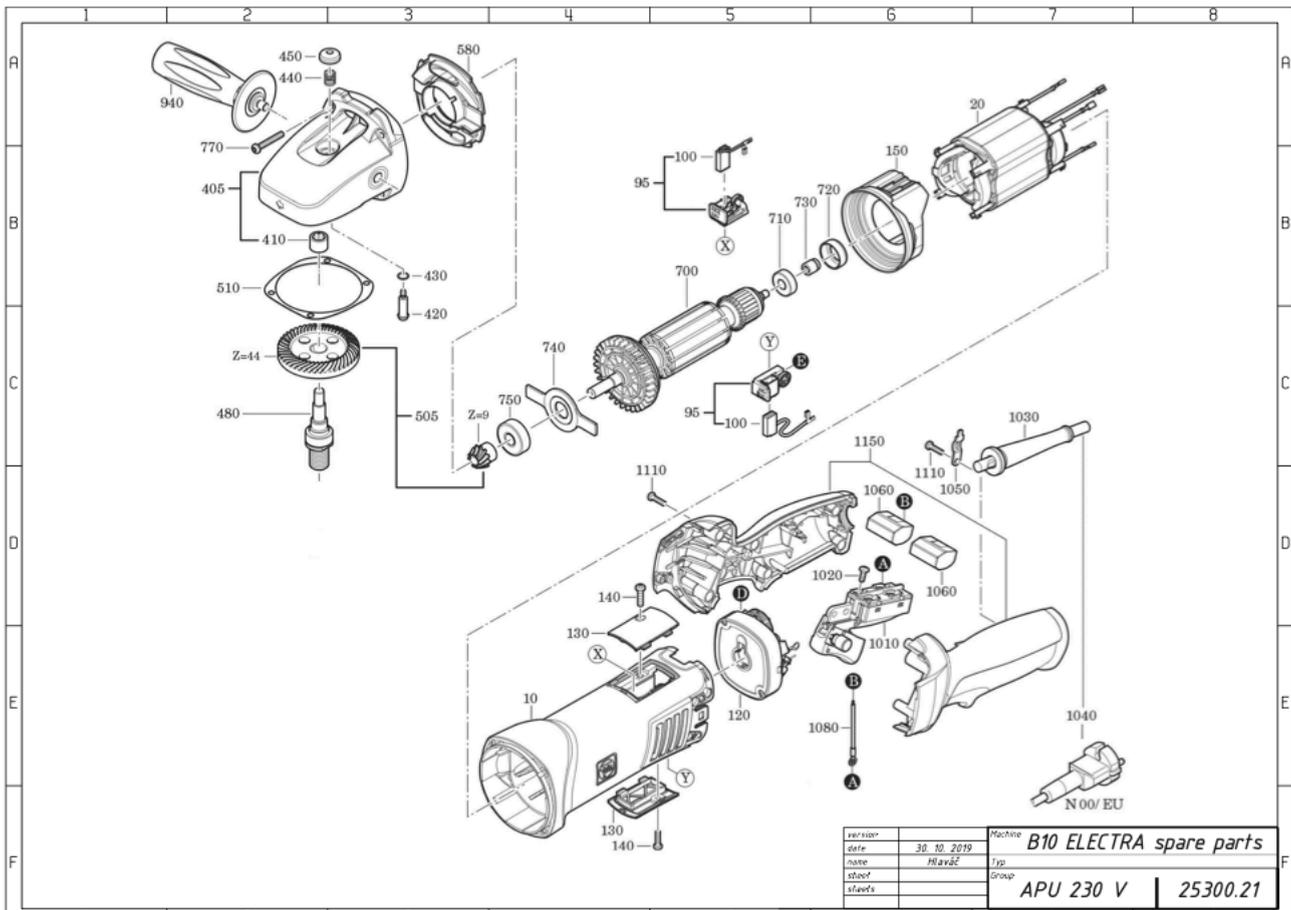
### **13.1 List of spare parts**



## B10 ELECTRA SPARE PARTS

drawing no. 25300 B10 ELECTRA

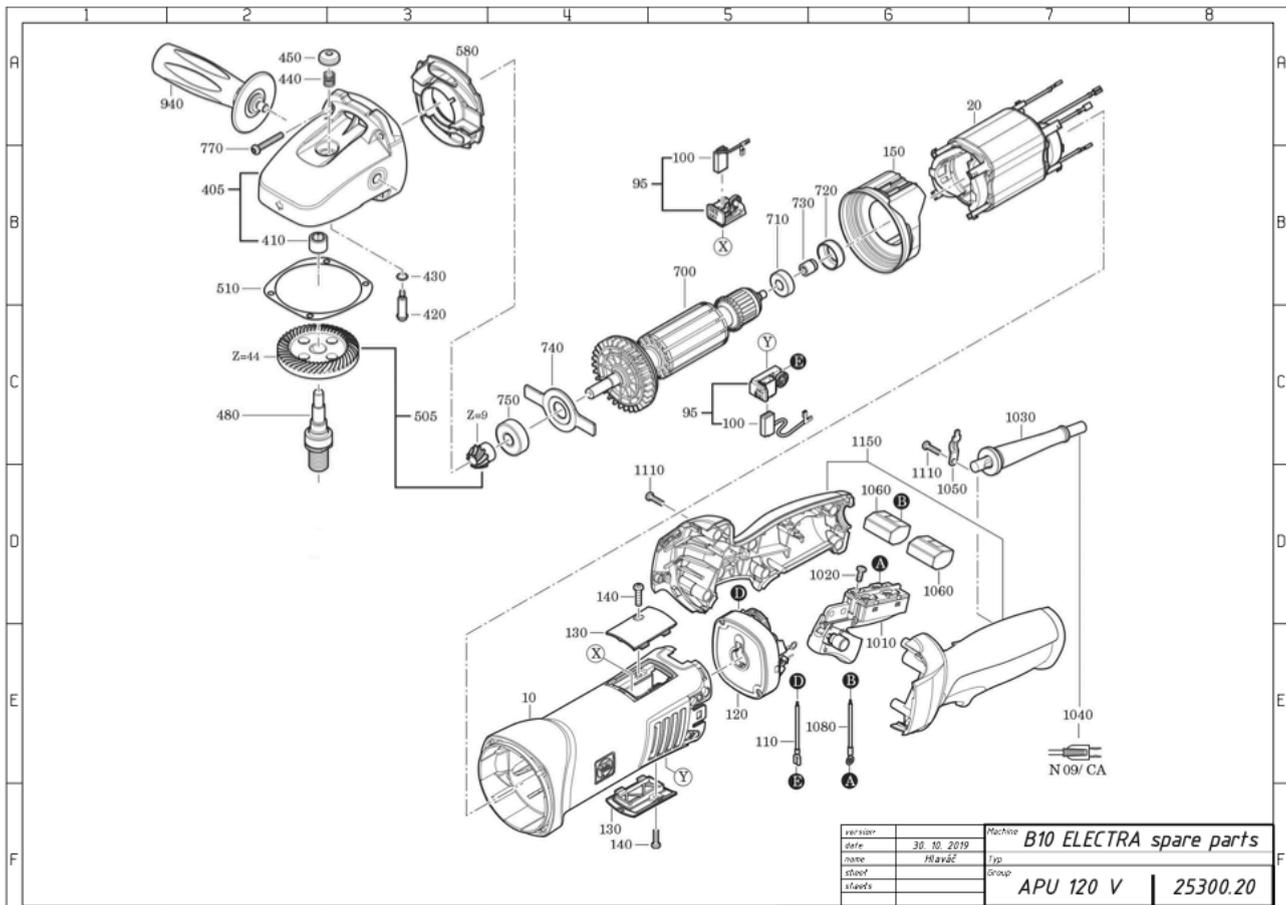
Number	Fig	Part name	Note	Pcs
25300.01	01	neck		1
25300.02	02	adapter		1
25300.03	03	disk		1
27220.50	04	backstop		1
27220.51	05	disk		1
27220.54	10	key		1
25300.11	11	screw		4
25300.12	12	screw		3
27220.58	13	screw		3
27220.57	14	screw		2
25300.15	15	washer		4
25300.16	16	ball bearing		1
25300.19A	19A	ball bearing		1
25300.19B	19B	ball bearing		1
25300.20	20	assembled power unit 120 V	see assembly list 25300.20 APU 120 V	1
25300.21	21	assembled power unit 230 V	see assembly list 25300.21 APU 230 V	1
25300.27	27	universal tube key		1
25315	28	protection felt plug		1
27220.52	29	stop pin with eye		1
25300.30	30	washer	The usual number of the spacers are two. Unique for every single machine. Needs to be determined by a service man.	2



## B10 ELECTRA SPARE PARTS

drawing no. 25300.21 Assembled Power Unit 230 V

Number	Fig	Part name	Number	Fig	Part name
31903228000	10	motor housing	30707544010	1040	cable with plug 230V
51279004230	20	stator 230V, 50Hz	32431043002	1050	cable clamping piece
30712096010	95	brush holder set 230V, 50Hz, pos. 100	31412063000	1060	terminal
30711158000	100	carbon brush 230V	30719886010	1080	cable
30762551990	120	speed setting switch 230V, 50Hz	43072000000	1110	screw
32427157000	130	cover	31204193010	1150	handle
43072000000	140	screw			
31428179000	150	air guide ring			
31206147030	405	gear box housing with pos. 410			
41705019001	410	needle sleeve			
30217335005	420	bolt			
40612137008	430	sealing ring			
30901357005	440	spiral spring			
32805200008	450	pushbutton			
33406284009	480	shaft			
33809247010	505	bevel gear Z=9/44			
32624123020	510	washer			
31428180000	580	air guide ring			
53279006230	700	armature 230V, 50Hz			
41701001260	710	grooved ball bearing			
30507236000	720	bearing bush			
32172014010	730	magnet			
32416117000	740	plate			
41701207260	750	grooved ball bearing			
43074012000	770	screw			
32119124010	940	anti-vibrations handle			
30701305010	1010	switch			
43041039999	1020	fillister head screw			
31413233000	1030	cable grommet			



## B10 ELECTRA SPARE PARTS

drawing no. 25300.20 Assembled Power Unit 120 V

Number	Fig	Part name	Number	Fig	Part name
31903228000	10	motor housing	31413233000	1030	cable grommet
51279004110	20	stator 120V, 60H	30707489010	1040	cable with plug 120V, 60Hz
30712096040	95	brush holder set 100-120V, 50/60Hz, pos. 100	32431043002	1050	cable clamping piece
30711160000	100	carbon brush 120V	31412063000	1060	terminal
30719888010	110	cable	30719886010	1080	cable
30762549990	120	speed setting switch 50/60Hz, 100-120V	43072000000	1110	screw
32427157000	130	cover	31204193010	1150	handle
43072000000	140	screw			
31428179000	150	air guide ring			
31206147030	405	gear box housing with pos. 410			
41705019001	410	needle sleeve			
30217335005	420	bolt			
40612137008	430	sealing ring			
30901357005	440	spiral spring			
32805200008	450	pushbutton			
33406284009	480	shaft			
33809247010	505	bevel gear Z=9/44			
32624123020	510	washer			
31428180000	580	air guide ring			
53279001360	700	armature 120V, 60Hz			
41701001260	710	grooved ball bearing			
30507236000	720	bearing bush			
32172014010	730	magnet			
32416117000	740	plate			
41701207260	750	grooved ball bearing			
43074012000	770	screw			
32119124010	940	anti-vibrations handle			
30701305010	1010	switch			
43041039999	1020	fillister head screw			

A copy of this manual is supplied with every  
machine B10 ELECTRA

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**Pittsburgh, PA 15205**

**Toll Free Number: 1-800-973-1138**  
**Phone Ambridge (PA) office: 1-412-452-2563**  
**email:[service@bevelerusa.com](mailto:service@bevelerusa.com)**