

# ***UZP30 Tool for Bevelling of Smaller Parts and Strap Steel, Order no. 1942***

***(order no. 1941 in a set with the bevelling machine  
DOUBLE SIDED BEVELER UZ 50 MANIPULATOR 3D)***

## **Operating and Maintenance Instructions**

**This operating manual is necessary to use only together with the official operation manual for the machine UZ50 Double sided beveler.**



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# 1. GENERAL INFORMATION

## 1.1. Introduction

Thank you for buying one of our products. We hope that it will serve you to your full satisfaction.

This manual contains all instructions for installation, set up, operation and maintenance of the tool for bevelling of smaller parts and strap steel in accordance with valid safety standards.

**Information and data contained in this manual are subject to changes due to continuing improvements of machines and tools. To eliminate any doubts, please contact N.KO if you find any differences.**

Never perform any operations before you read and understand instructions contained in this manual. Most of work accidents are caused by non-observation of instructions and recommendations contained in this manual.

Symbols used in this manual should bring your attention to important information concerning safety and operation of machines and tools.



**Attention:**

**Relevant information for personal safety of operators.**



**Important:**

**An instruction that must be observed in order to ensure correct operation of the machine.**

## 1.2. Tests

The UZP30 tool that you have bought was tested in our technical testing laboratory. This test verifies correct functioning of bevelling of sheet metal and profiles of various types and sizes.

## 1.3. Guarantee

The seller guarantees that the UZP30 tool will be free of material or production defects for 12 months from the day of delivery.

Faultless functioning of the goods and material used is guaranteed for 12 months from the day of delivery.

The seller undertakes to ensure elimination of any defects under the guarantee for free and without undue delay so that the buyer could use the goods. Shall the buyer exercise his rights arising from liability for defects not being covered by the guarantee, the buyer will pay related costs to the seller.

The guarantee period stops running from the day when the buyer informed the seller about a defect covered by the guarantee that prevents use of the goods and when the buyer exercised his rights arising from liability for defects in relation with the guarantee, until the day of elimination of the defect by the seller.

The guarantee does not cover natural and common wear of the goods and defects caused by incorrect use of the goods in conflict with provided training and documentation. Moreover, the guarantee does not cover defects caused by overloading of the goods, as well as defects caused by an unqualified intervention into the goods or unqualified repair or modification of the goods. An unqualified intervention, repair or modification means any intervention, repair or modification that were done in conflict with provided training and documentation or that were performed by another person than the seller or a person authorised by the seller.

Rights arising from liability for defects covered by the guarantee must be exercised at the seller without undue delay after identification of a defect by the buyer, at latest, however, until the end of the guarantee period, otherwise these rights lapse.

To exercise rights arising from liability for defects covered by the guarantee, it is necessary to submit an invoice. Failing this, the buyer's right cannot be recognised.

The seller is not liable for defects covered by the guarantee, if such defects were caused by external events. External events mean in particular natural disaster, force majeure or behaviour of third persons.

N.KO considers the guarantee invalid in case of:

- improper use of the product;
- use of the product in conflict with national or international standards;
- incorrect installation;
- faulty electric power supply;
- serious maintenance faults;
- unauthorised modifications and/or interventions;
- use of other than original spare parts or use of wrong spare parts and accessories for the model concerned;
- full or partial non-observance of instructions;
- exceptional events, natural disasters and other.

## **1.4. Identification data**

Identification data of the UZP30 tool are shown on a type plate attached to a stacker plate for remote control.

## **2. SAFETY**

### **2.1. Recommended safety precautions**



**Attention:**

**Read carefully the following instructions in order to prevent personal injuries and/or damage to property.**

- Never try to work with the tool until you have studied carefully the way how it works. If you have any doubts after having read carefully the entire manual, contact the N.KO Company.
- Make sure that all technicians who will use the tool and make maintenance are fully acquainted with all the relevant recommended safety precautions.
- The tool must be installed only by authorised workers in accordance with instructions contained in this manual.
- Before starting any work, operators must make sure that all safety devices are working and that all safety covers are installed.
- The tool must never be used for other purposes than for those mentioned in this manual. Never process other than mentioned products.
- Before you use the machine for other than mentioned purposes, contact the N.KO Company and ask for authorisation.
- Parts considered as defective can be replaced only by those recommended by the manufacturer. Never replace by other than original parts.
- Never wear clothing or jewellery that could be drawn in by moving parts. It is recommended to wear safety clothing: shoes with non-slipping soles, hearing protectors and protective goggles.



**Important:**

**If any defects occur during the service life of the tool that cannot be repaired following this manual, it is recommended to contact the N.KO Company so that the problem could be solved within the shortest possible time.**

## **2.2. Qualification and protection of operators**

The employer is obliged to inform operators about safety standards, ensure their observance and make sure that the working area is sufficiently big and well lighted.

An “operator” is a person who installs, operates, sets up, maintains, cleans and repairs the tool.



**Attention:**

**Before starting work, operators must be acquainted with characteristics of the tool and must have read the entire manual.**



**Attention:**

**The operator must always:**

1. make sure that all safety covers are mounted and that safety devices are functional before he runs the machine with the tool.
2. avoid wearing clothing or jewellery that could be drawn in by the moving parts of the machine.
3. wear approved safety clothing, such as shoes with non-slipping sole, hearing protectors and protective goggles.
4. apply safety standards, ensure their observance and, in case of any doubts, consult this manual before taking any measures.
5. contact the supplier if he is not able to eliminate defects causing bad operation of the tool, if defects concern faulted parts or if operation is not regular.

### **2.3. Safety devices**

The UZP30 tool is equipped with safety covers to isolate zones that could be dangerous for operators. These covers are screwed on the structure or with the structure of the tool and the machine. The covers may be removed using suitable wrenches. This operation may be necessary in order to perform some maintenance activities.



**Attention:**

**The cover may only be removed when the machine and the tool are not running and the electric plug is disconnected from power supply. Never use the tool without mounted safety covers.**

### **2.4. Residual risks**

The UZP30 tool was designed and manufactured with safety devices and safety equipment to ensure health and safety of operators.

The tool is fit with covers in order to eliminate the risk of contact with moving parts.

There is, however, a residual risk:

As it was already said above, the working zone is protected as much as possible, but it must stay partially open to make it possible to insert the material in order to bevel edges.

It is therefore possible that fingers could be inserted into this zone in which both the cutting device and the workpiece holder are located.



**Attention:**

**Keep your hands as far as possible from the cutting zone.**



**Attention:**

**Always apply safety instructions contained in this manual and ensure their observance so that all residual risks could be excluded.**

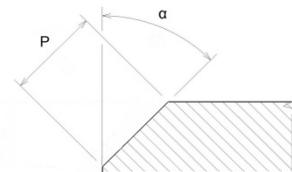
### 3. TECHNICAL SPECIFICATIONS

#### 3.1. Description of the UZP30 tool

The UZP30 tool for bevelling of smaller parts and strap steel is designed only for use with the DOUBLE SIDED BEVELER UZ 50 MANIPULATOR 3D. One of its main advantages is that the UZ50 machine together with this tool may bevel materials whose dimensions are too small and that could not be otherwise machined.

The bevelling tool UZP30 is reliable and requires only minimal maintenance.

#### 3.2. Technical data



#### Angle bevel size for steel at individual angles

$\alpha$	max. bevel width (P)	Nr. of passes
20°	10,5 mm (.41 in)	Recommended in 1 pass
25°	13 mm (.051 in)	Recommended in 2 passes
30°	19,5 mm (.76 in)	Recommended in 2 passes
40°	20,5 mm (.80 in)	Recommended in 3 passes
45°	24 mm (.94 in)	Recommended in 3 passes
50°	23 mm (.90 in)	Recommended in 3 passes
55°	26 mm (1.02 in)	Recommended in 3 passes
60°	24 mm (.94 in)	Recommended in 3 passes

#### Maximum and minimum dimensions of the machined material:

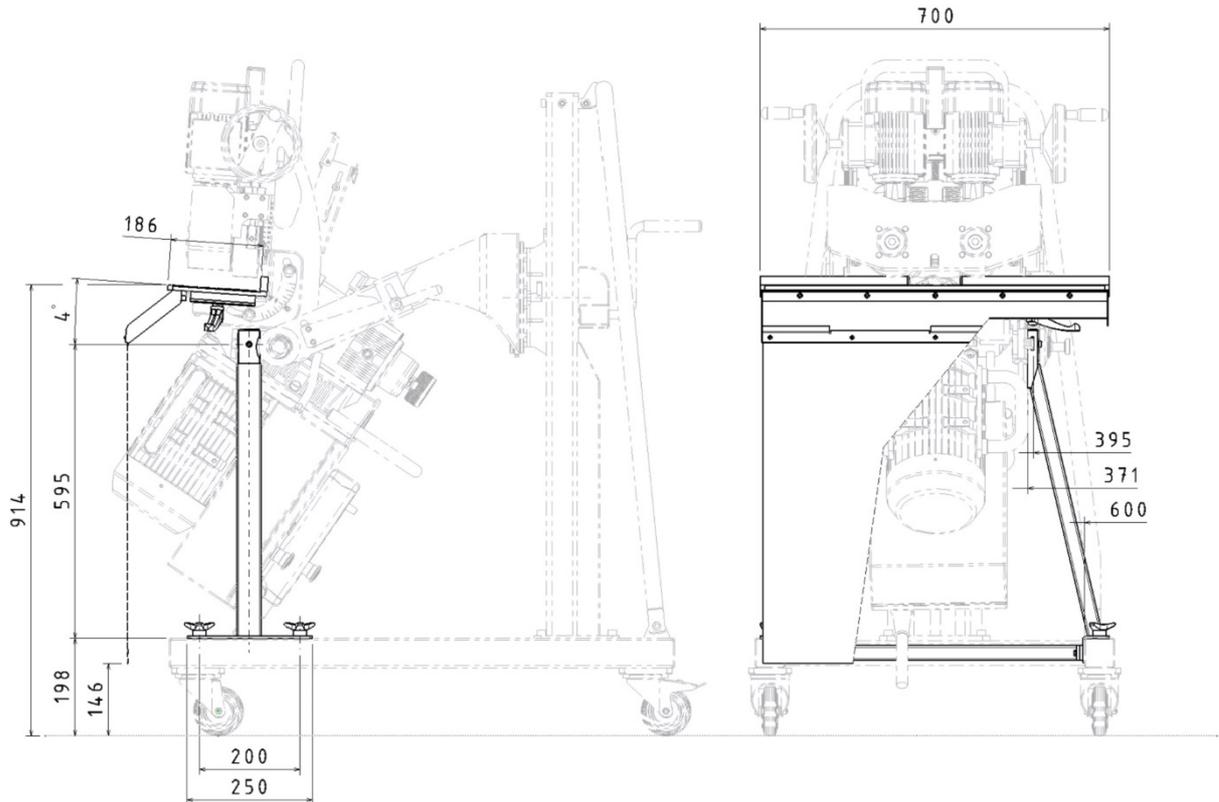
- Thickness.....7 – 60 mm (.27 in – 2.36 in)
- Width.....15 – 400 mm (.59 in – 15.7 in)
- Length.....min 250mm (10 in)– max without limitations\*\*
- Angle range.....20°-60° (continuous)
- Weight of workpiece.....max 30 kg (66 lb)

\*\* In case of too long pieces it is necessary to add a suitable roller bed to the machine.

Mind overloading of the feeding mechanism. It is necessary to choose a suitable ratio of the length and section of the workpiece depending on the total weight of the machined piece.

- Weight of the accessory..... 27 kg (60 lb)
- Dimensions..... Fig. 3.2.1.

**Fig. 3.2.1.**



### **3.3. Working environment conditions**

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

Temperature: 0 °C - 50 °C (32F – 122F)

Humidity: 10 % – 90 % (not condensed)

The machine and the tool must be located in a covered place and must not be exposed to rain.

Other working environment conditions than those mentioned above could cause serious damage.

If you are not using the tool, it may be stored on a place with temperature range between:

-10 °C and +70 °C (14F – 158F)

All other values remain unchanged.

## 4. INSTALLATION

### 4.1. Transport and handling



**Important:**

**Operations described in this section may be done only by qualified personnel.**

When the UZP30 tool arrives to the place of delivery, make sure (in the presence of the transporter) that it corresponds to specifications set in the order and that it did not suffer any damage during transport. In case of any damage or if any parts are missing, inform immediately and in detail the N.KO Company and the transporter. (fig. 4.1.1.)



**Attention:**

**Follow the following instructions and ensure safe handling with the tool:**

- During manipulation with the tool and the machine, wear protective clothing, such as work gloves, shoes with non-slipping sole and a helmet.
- If the tool is packed in the transport package, dispose the package in accordance with valid local regulations.
- In case that you order the tool as a set – order no. 1941 together with the DOUBLE SIDED BEVELER UZ 50 MANIPULATOR 3D, it may happen that you will receive the tool already mounted to the UZ50 machine.

### 4.2. Mounting of the tool and its connection to the machine

**DOUBLE SIDED BEVELER UZ 50 MANIPULATOR 3D (hereinafter UZ50)**



**Important:**

**Operations described in this section may be done only by qualified personnel.**

The UZP30 tool is commonly delivered dismantled in a cardboard box. Mounting and connecting of the tool to the UZ 50 machine shall be performed according to instructions (fig. 4.1.2).

Fig. 4.1.1.

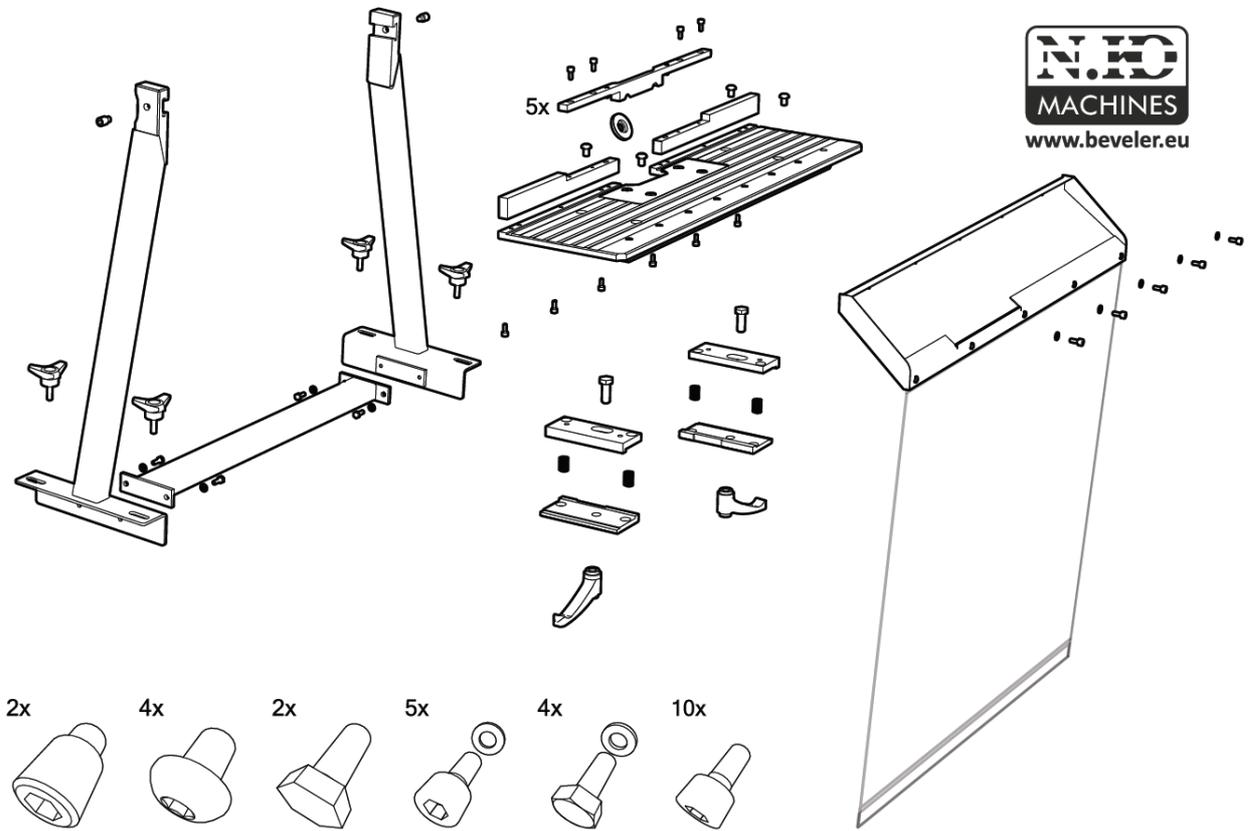
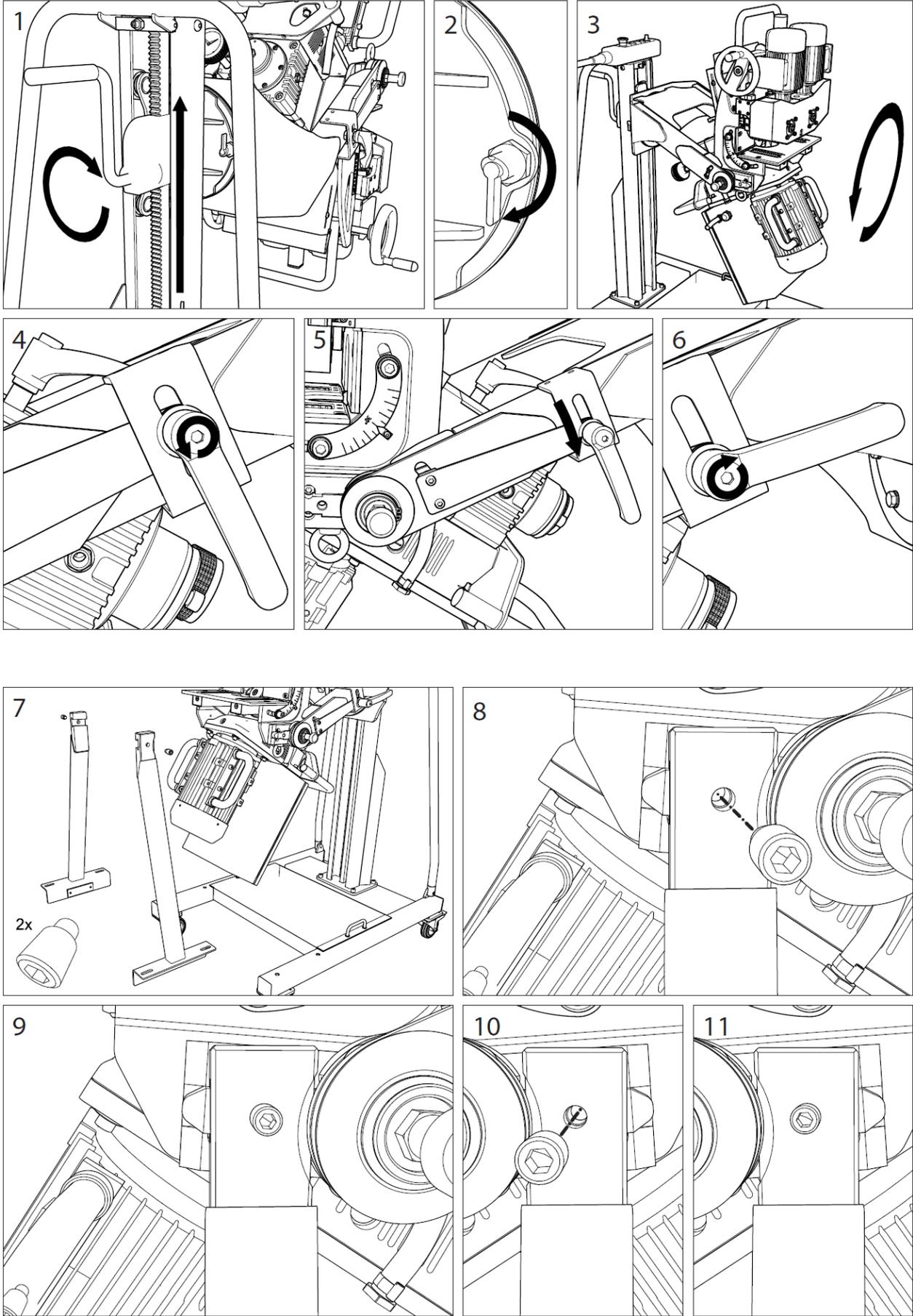
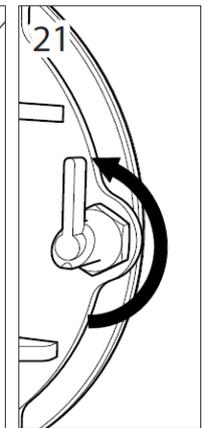
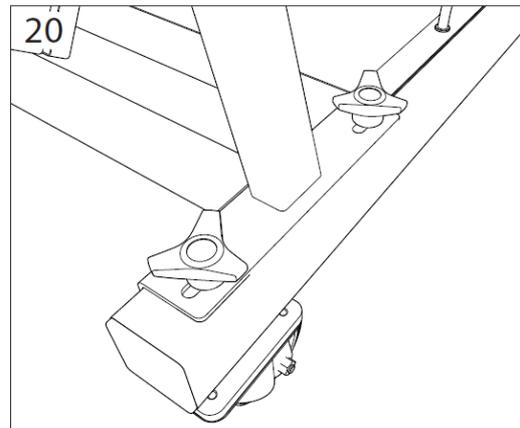
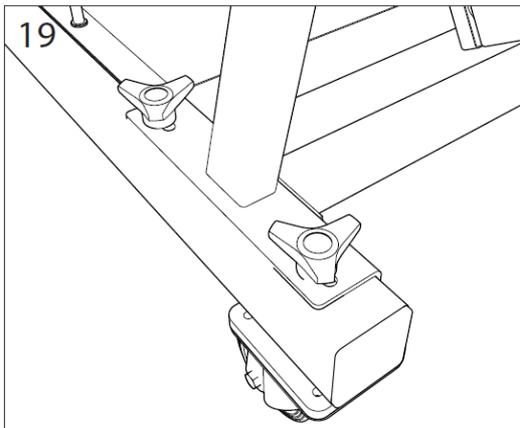
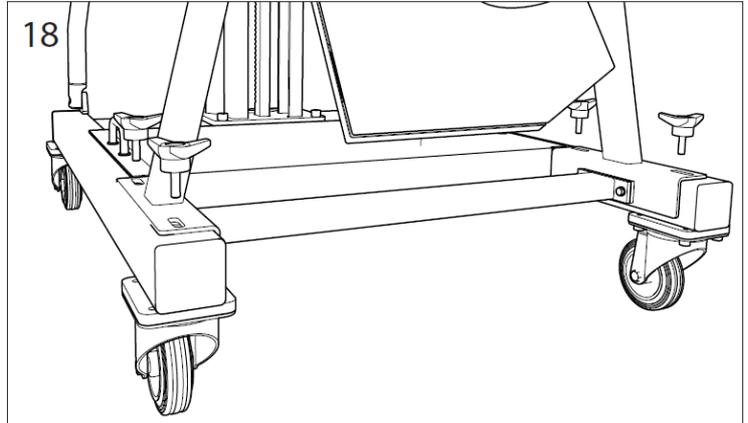
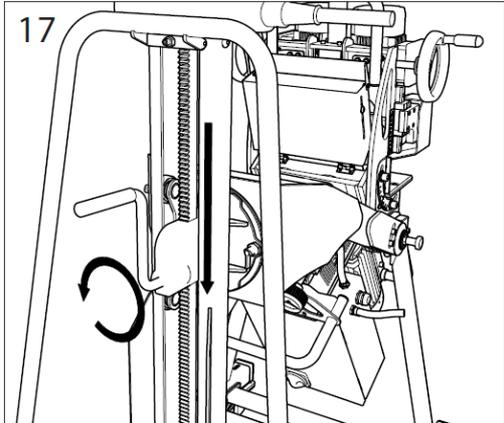
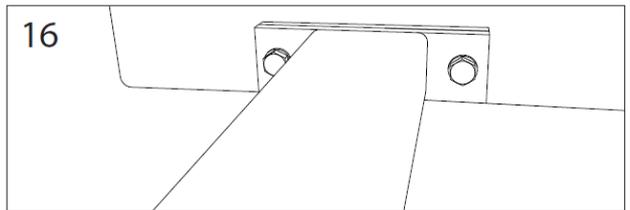
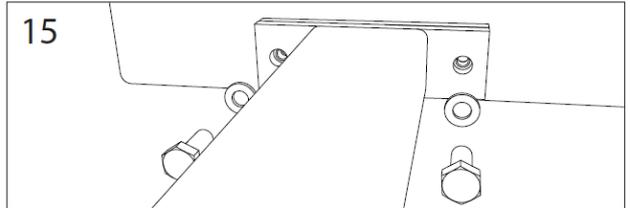
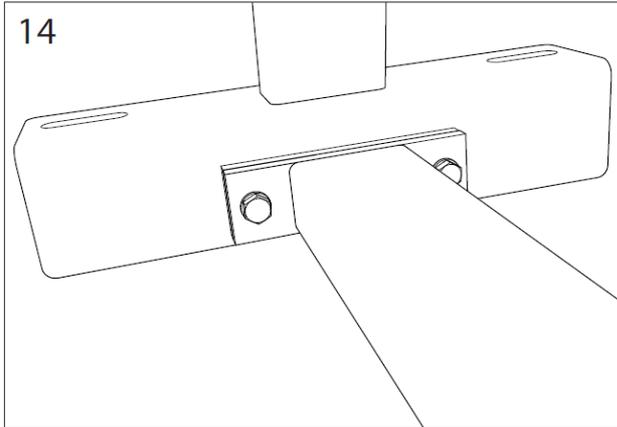
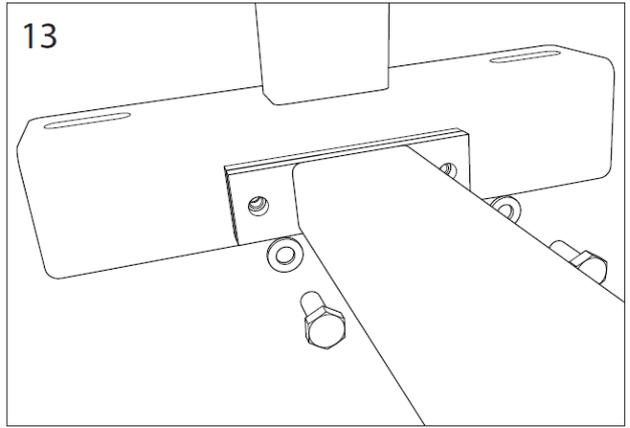
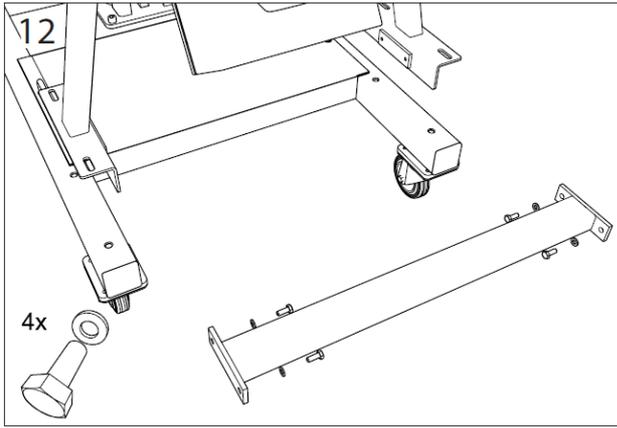
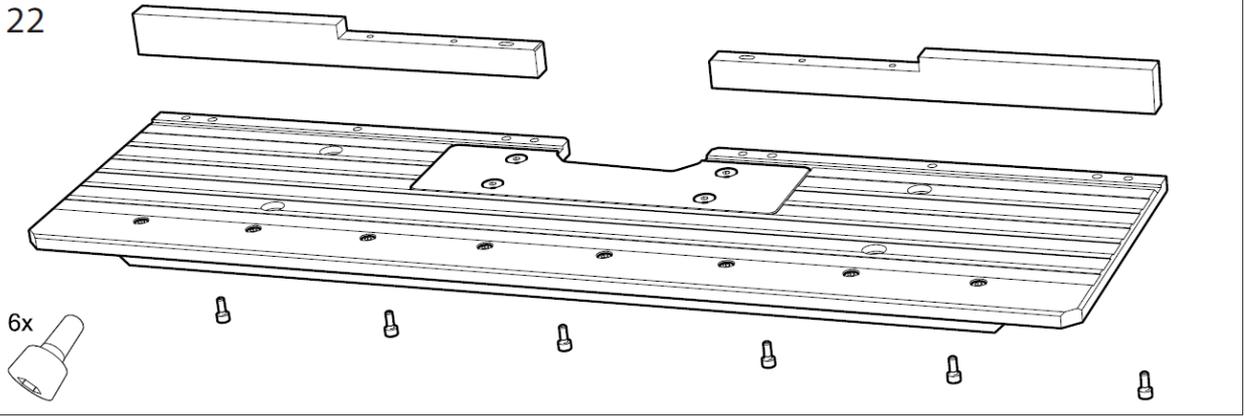


Fig. 4.1.2.

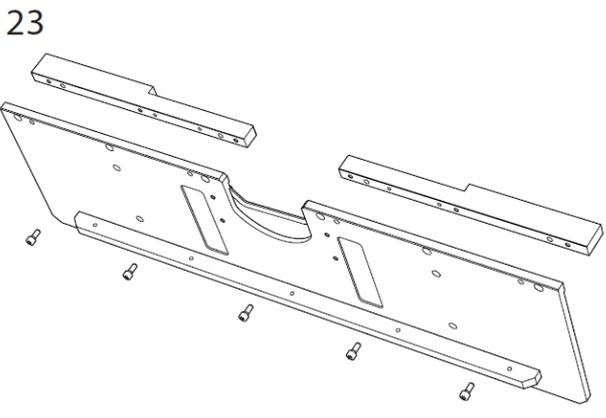




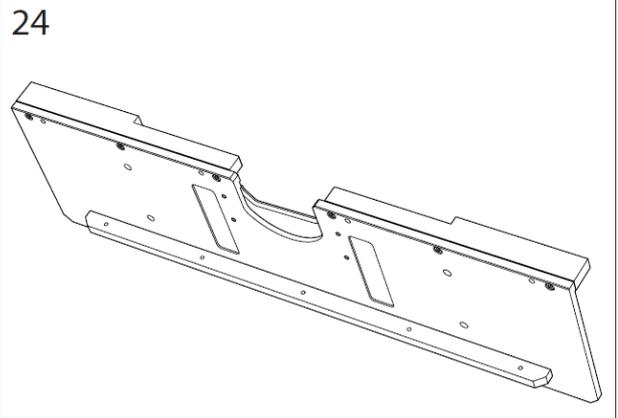
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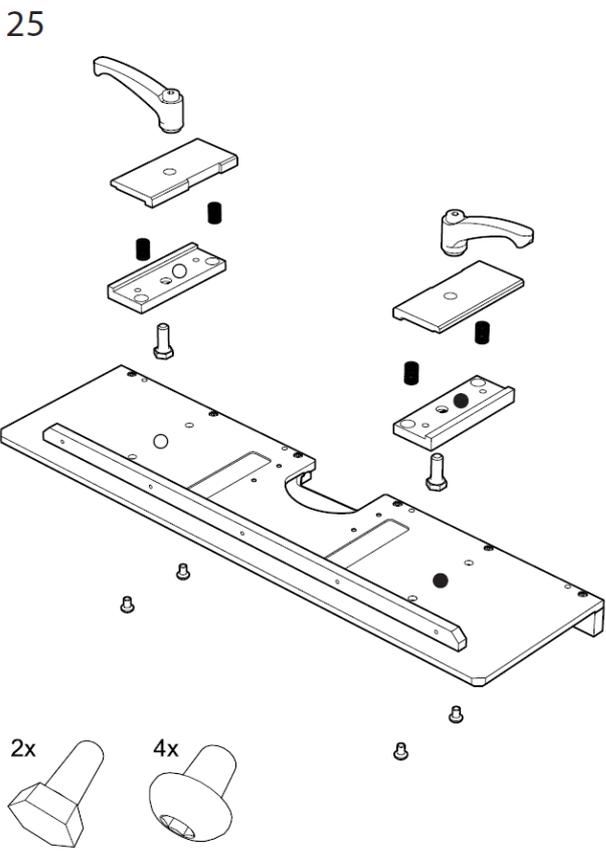
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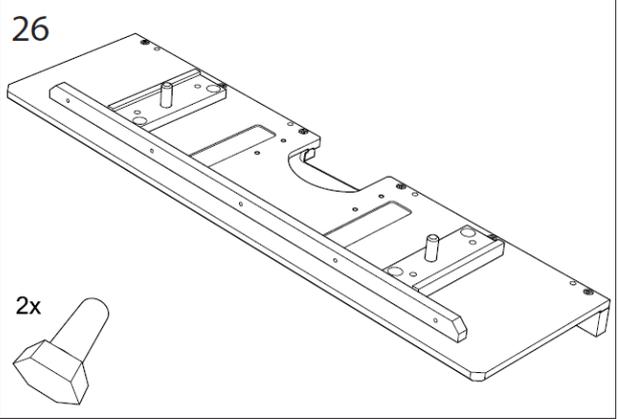
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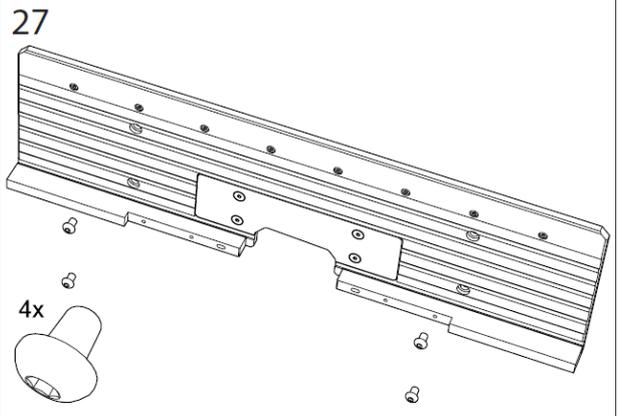
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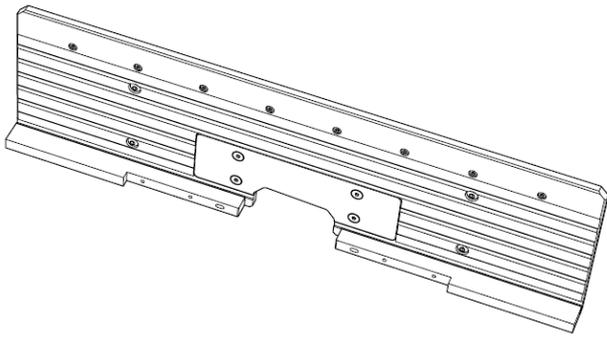
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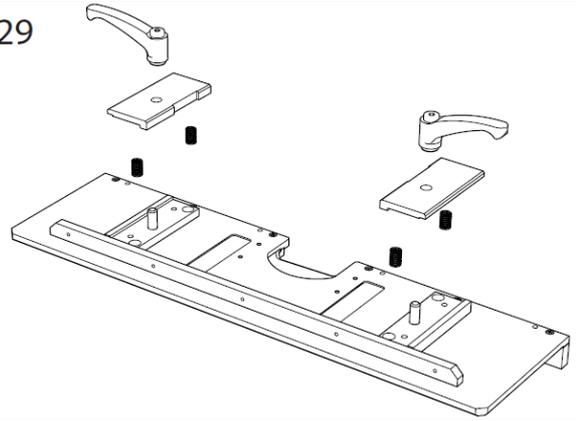
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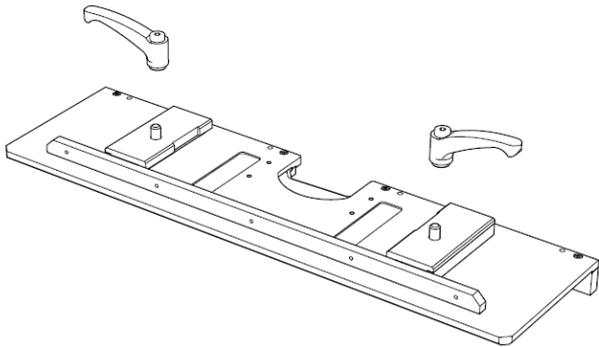
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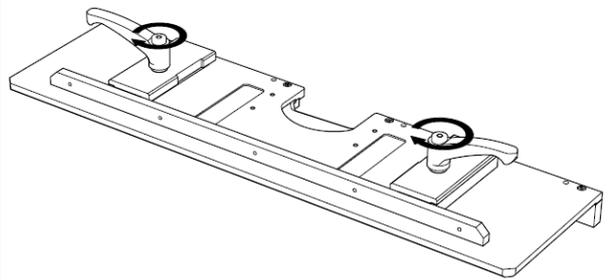
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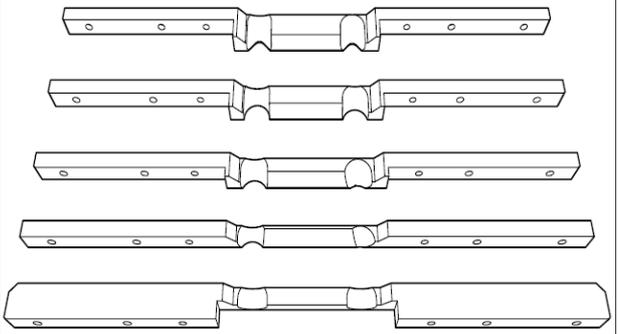


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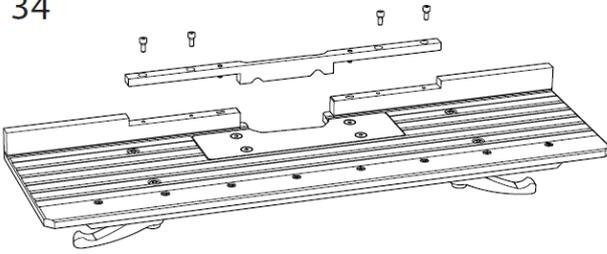


		
1	7-10mm	14-20mm
2	10-15mm	20-30mm
3	15-20mm	30-40mm
4	20-31mm	40-62mm
5	>31mm	>62mm

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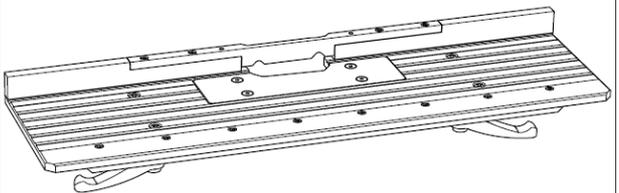
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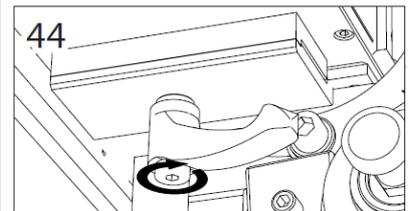
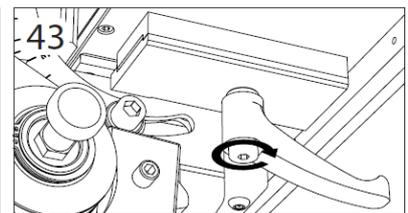
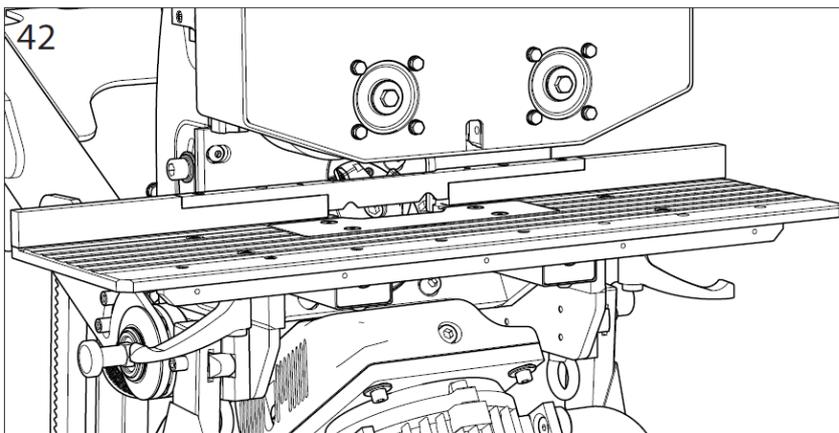
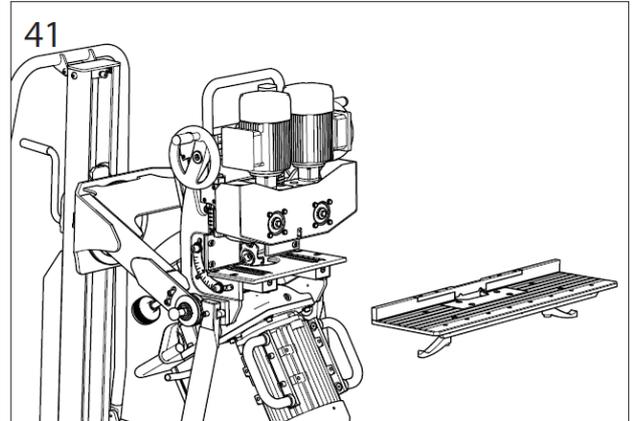
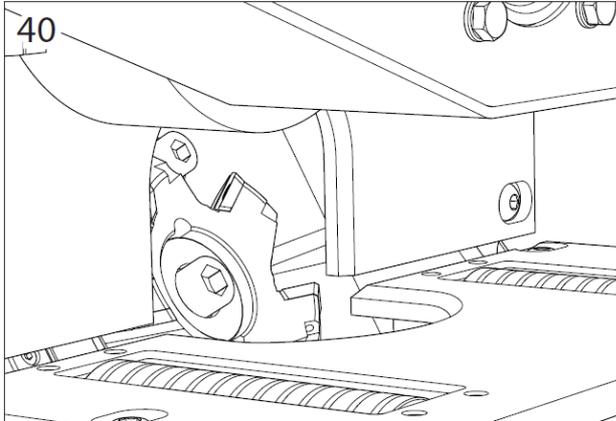
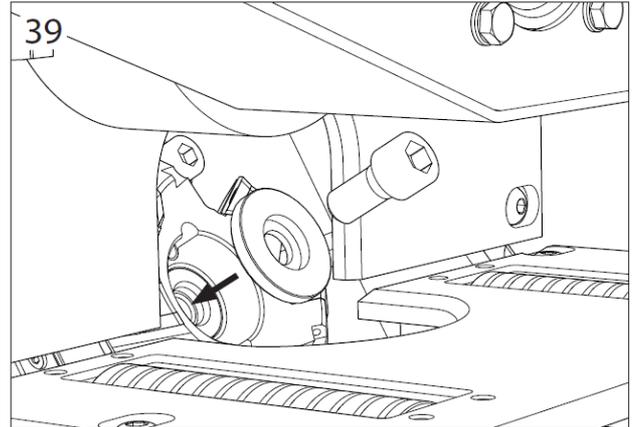
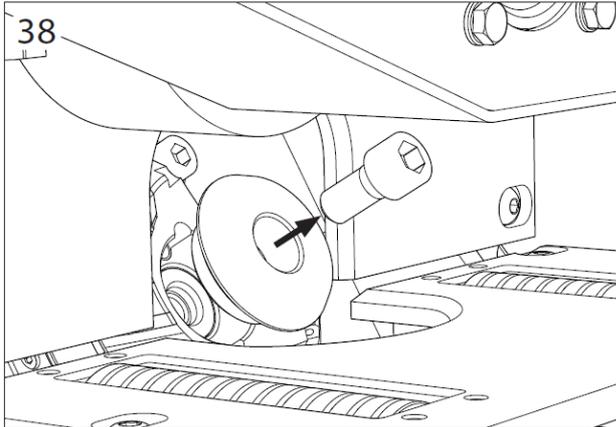
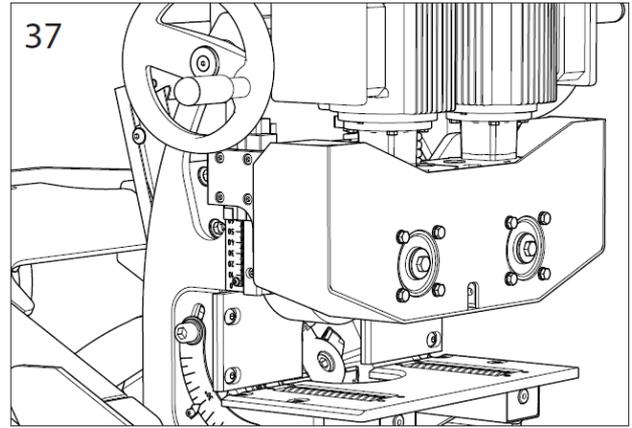
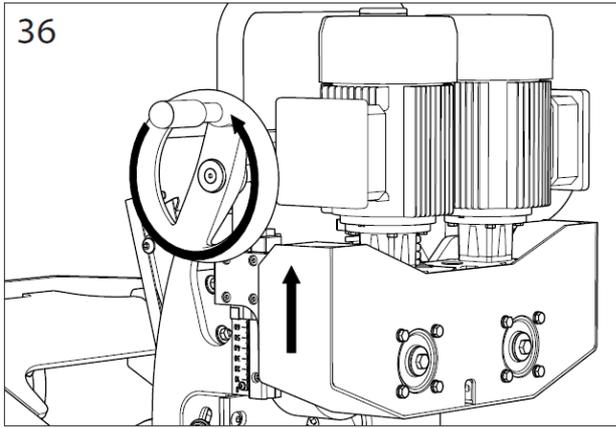


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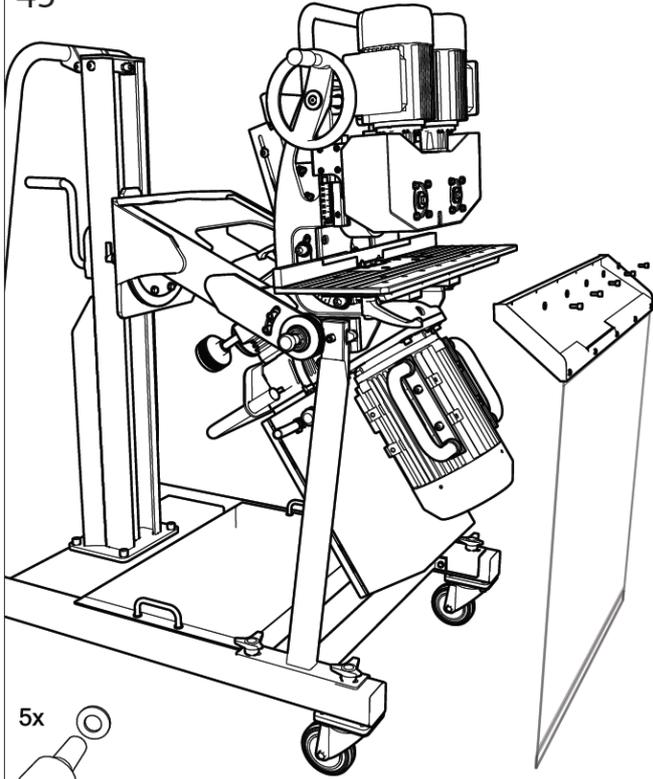


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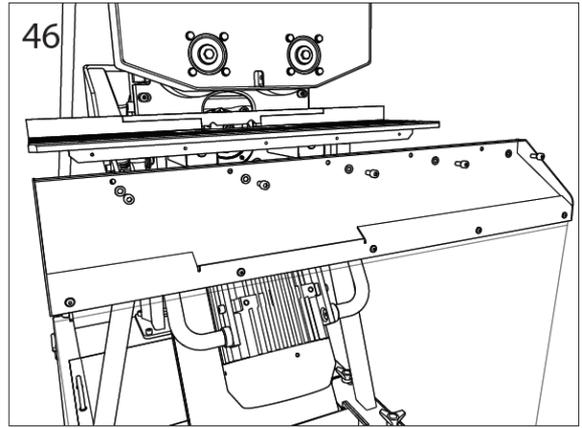


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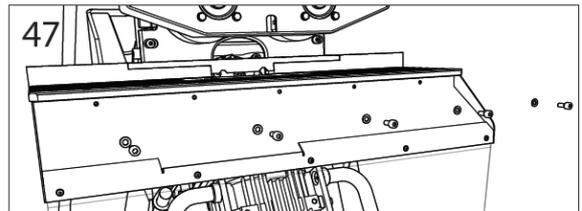


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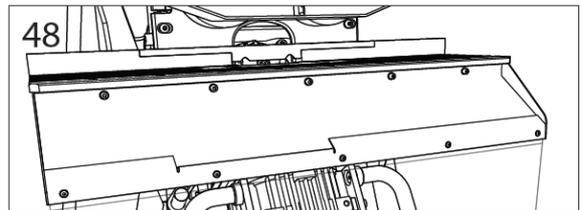
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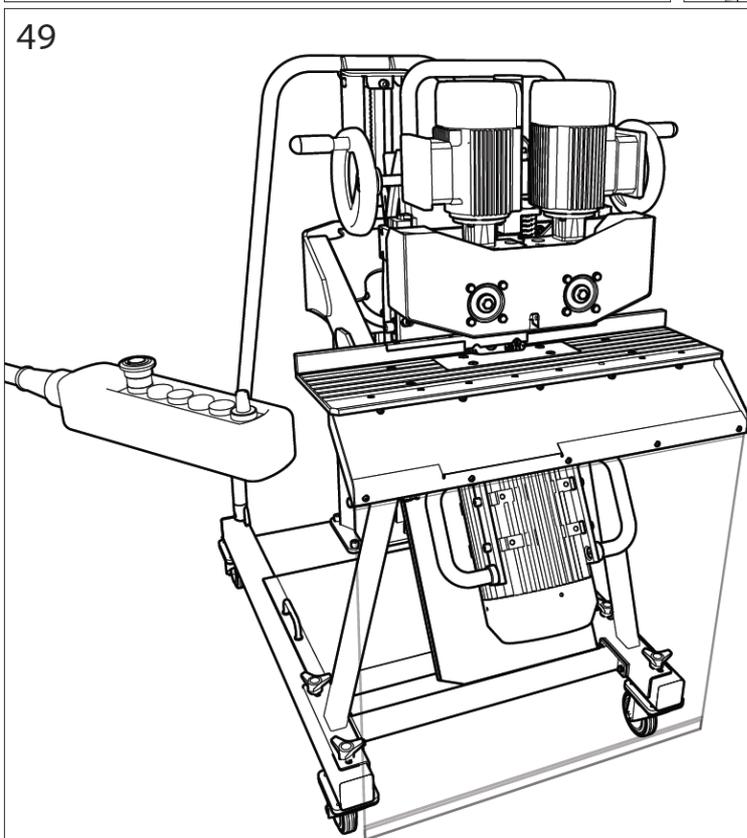
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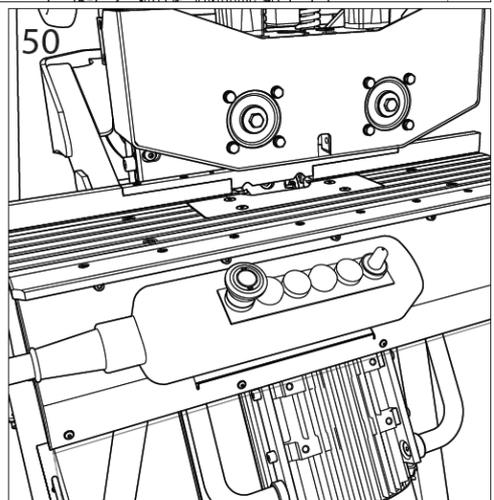
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## Checks before putting into operation



### **Important:**

**Never start the UZ50 machine with the UZP30 tool without performing checks described in this paragraph.**

Before starting the work, perform the following checks and inspections to make sure that the UZ50 machine with the UZP30 tool are in operating condition, to achieve the highest possible efficiency and to comply with safety regulations:



### **Important:**

**Don't forget to make exchanging of the washers of the milling head's screw. See position 38 and 39 - fig. nr.4.1.2**

- Check if all the screws and other parts are well tightened
- Make sure that the tool and its parts do not collide with the cutting tool and that the cutting tool is moving freely.
- The UZ50 controller must be placed on a stacker plate designed for this purpose and located next to the setup table.
  
- To run the machine, follow the instructions in the operating manual of the UZ50.
  
- Switch off the machine using the red button placed next to the start switch.

## 4.3. Disposal

When disposing the UZP30 tool remember that materials from which it is made are not dangerous and that they include in particular:

- painted or metal coated ferritic steel;
- stainless steel series 300/400;
- various plastic materials;

Follow the following procedure:

- observe valid national regulations concerning working environment safety;
- dismantle the tool and sort its parts into groups according to their chemical characteristics;
- scrap the parts of the tool in accordance with valid national regulations;
- observe strictly valid occupational safety regulations.

## 5. USE

### 5.1. Correct use

The UZP30 tool for bevelling of smaller parts and strap steel was designed, manufactured and sold only for use with the DOUBLE SIDED BEVELER UZ 50 MANIPULATOR 3D for bevelling metallic parts and rolled metals of the following types: **iron, steel, stainless steel, brass, copper and aluminium.**

Maximum and minimum dimensions of the bevel angle and thickness of the processed material are shown in detail in Chapter 3, section 3.2. "Technical specifications".

Other uses differing from those mentioned above are considered as unsuitable. More specifically, it is forbidden to:

- machine products differing from those for which the tool is manufactured and sold;
- modify operation of the machine;
- replace parts for other than original ones;
- remove or modify protective covers;



#### **Attention:**

**It is strictly forbidden to perform bevelling on materials differing from the mentioned materials because their processing could represent a risk for operators and could damage the machine.**

Before making any modifications, it is necessary to contact the N.KO Company to obtain the relevant approval. If the approval is not provided, the N.KO refuses any responsibility.

### 5.2. Preliminary set up



#### **Attention:**

**Wear working gloves during setting of the machine. Operations must be performed on the machine that is not running and is disconnected from power supply.**



#### **Important:**

**The UZP30 is only a tool that extends possibilities of the UZ50 machine. All setups of the UZ50 machine are contained in the UZ50 manual.**

**This manual mentions only differences relating to operation of the UZP30 tool and the UZ50 machine.**

#### **Preparation of material**

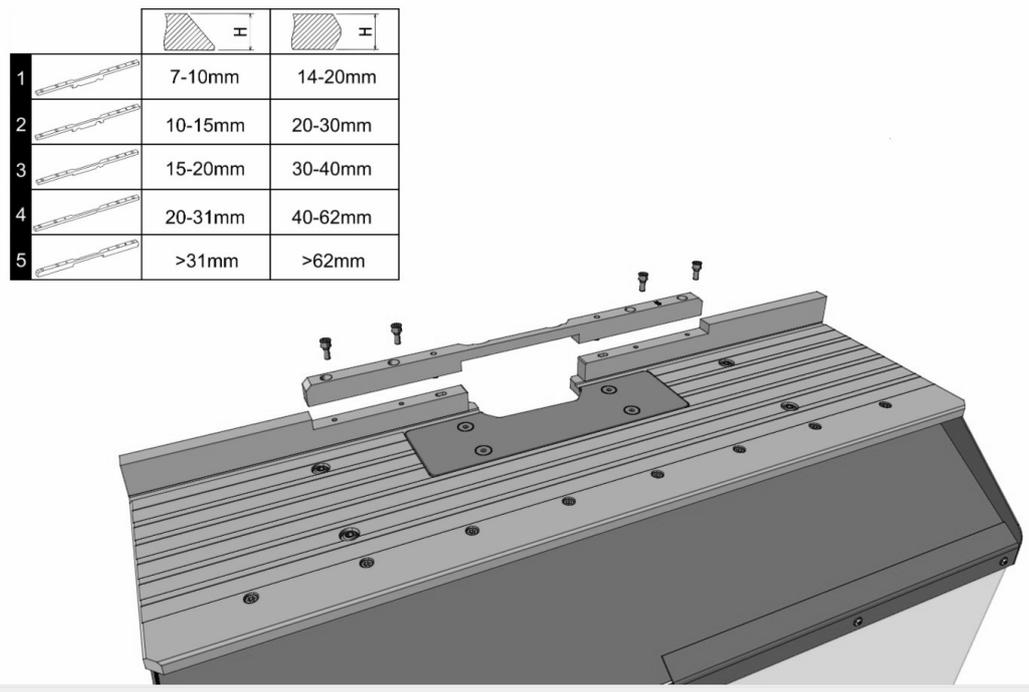
The machined material must comply with conditions mentioned in Section 3.2. Bevelled edges of the material must be even, without any burrs and rests of cinder after flame cutting.

**TIP:** It is recommended to condition the edge of the material by bevelling the edge using an angle grinder for trouble-free feeding into the machine.

### The supporting rails

For smooth and safe operation of the machine is necessary to install a suitable vertical bearing rail. Set of 5 pieces of rails is supplied with the machine. According to table (fig.n.5.2.1.) select a suitable rail according to the thickness of the material and the type of bevel, which you are going to create. The correct rail mount to the vertical basic guidance (fig.n. 5.2.2.) The bearing rails work to prevent unwanted penetration of the workpiece material into the milling tool. This is a safety feature. Is prohibited work without these rails.

Fig.n. 5.2.1.



### Adjustment of the bevel angle

The bevel angle may range from 20° to 60°.

**Adjust the angle according to instructions for the UZ50 machine.**

### Adjustment of the pressure of feed wheels:

The purpose of feed wheels is to ensure continuous movement of material through a milling tool. The movement speed may be regulated using a remote control.

The system of feed wheels must be adjusted in such a way that it sufficiently holds material to prevent its vibrations or loosening during machining. That is why the system of feed wheels is designed in order to exercise force of a spring mechanism to the material; initial stressing force may be regulated. Another advantage of this solution is spring loading and the ability to adapt to sudden changes in thickness of the material during machining.

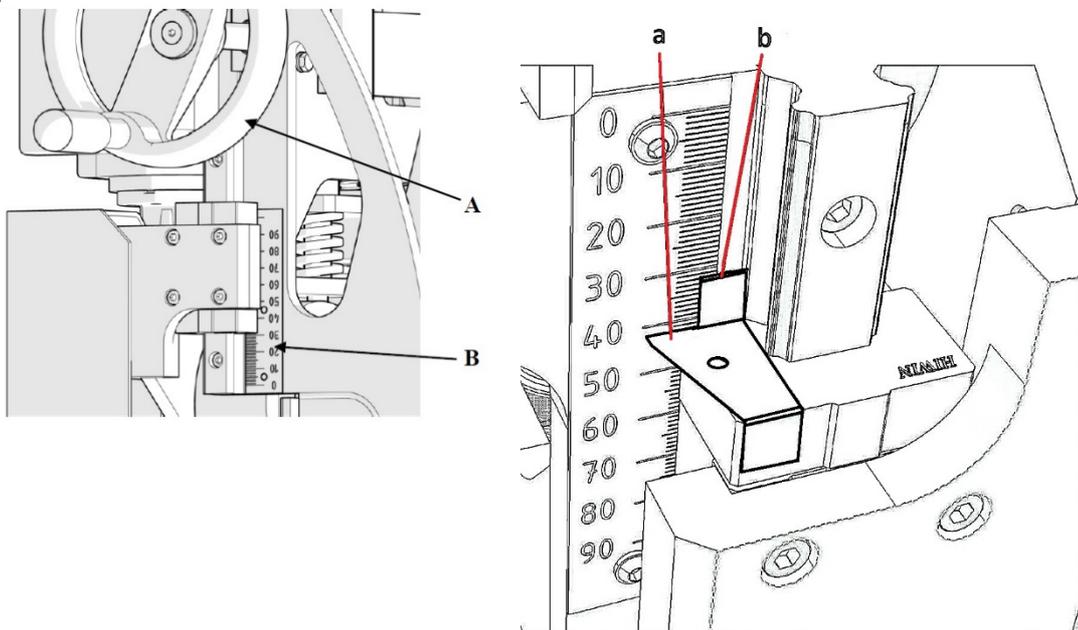
- Setting of the system of feed wheels depends on thickness of the machined material. It is necessary to set 5 – 8 mm less on the scale (pos. B, fig. 5.3.3.) than the real thickness of the machined material. The prescribed 5 – 8 mm is the initial stressing force. Setting is made using a control wheel (pos. A, fig. 5.3.3.). This control is installed on both sides of the machine for easier access.

**⚠ Attention:** The setup indicator has two reading places (see fig. 5.3.4.).

**When working with the UZP30 tool, we read a mark of pos. b on fig. 5.3.4.**

When working with the machine UZ50 alone, we read the mark of pos. **a** on fig. 5.3.4.

Fig. 5.3.4



### Determination of the zero value:

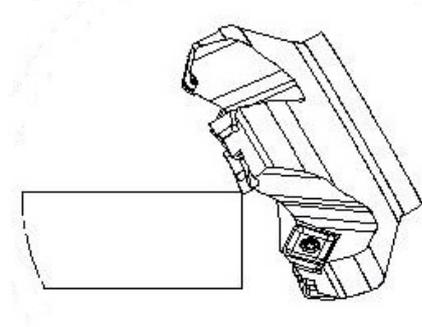
To set correctly the size of cut, it is necessary to set a zero point for the concrete angle before beginning of machining (zero point is a point when the milling machine touches the material).

This point must be set each time the bevel size or angle are changed.

**Follow the UZ50 manual as well.**

- Release the chip setting locking lever (pos. E, fig. 5.3.1.). **SEE THE UZ50 MANUAL**
- Using the chip setting wheel (pos. D, fig. 5.3.1.), **SEE THE UZ50 MANUAL**, insert the milling tool fully towards the milling head.
- Using the feed wheel pressure setting wheel (pos. A, fig. 5.3.3.) set up their correct position according to thickness of the machined material (see the section above).
- Start the engine of the milling tool and feeding. Set the feeding speed to the value 3 – 6. Check correct direction of turning of the milling tool and feed wheels. **SEE THE UZ50 MANUAL.**The material is inserted into the machine from the right to the left.
- Insert the workpiece into the machine and after it is gripped by feed wheels, let the machine drag it into the position when it is held by both feed wheels. Make sure that the material touches the vertical and the horizontal ruler along the entire length.
- Switch off feeding.
- Using the chip setting wheel (pos. D, fig. 5.3.1.), **SEE THE UZ50 MANUAL**, gradually move the milling tool towards the material until the milling tool is in contact with the material. In this moment, the zero point for a given angle is set (fig. 5.3.5.).
- Block the chip setting locking lever (pos. E, fig. 5.3.1). **SEE THE UZ50 MANUAL**
- Switch on feeding and remove the material from the machine.

fig. 5.3.5.



### 5.3. Set up of cut and machining

The UZ50 machine with a tool UZP30 for smaller workpieces is able to make a bevel of width up to 30 mm in some angles. (See section 3.2.). These values may be achieved only by gradual machining in several cuts.

## Setting of the first cut

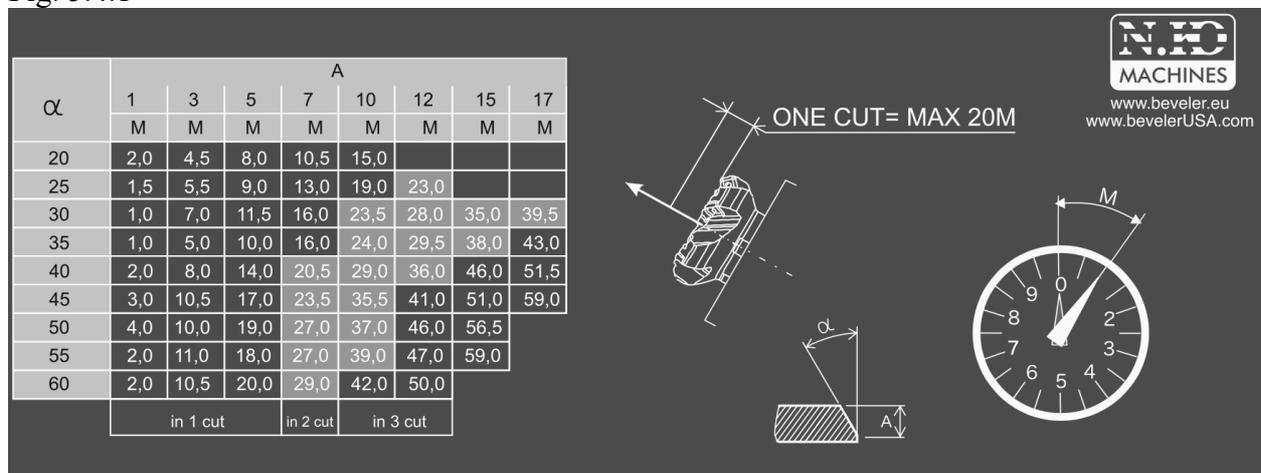
**Important:** The condition for correct setting of cut is predetermination of the zero point. Without this presetting, there is a risk of faulty setting of cut and damage of the milling tool.

- Release the chip setting locking lever (pos. E, fig. 5.3.1.). **SEE THE UZ50 MANUAL**
- Using the chip setting wheel (pos. D, fig . 5.3.1.), **SEE THE UZ50 MANUAL**, set the required first cut. Use a table located on the stacker plate of the UZP30 tool for correct reading of values (fig. 5.4.1)

**Important:** The maximum depth of an individual cut is 4 mm (moving of the milling tool). It means 20 division marks on the setup wheel. If you set more for one cut, there is a risk of immediate damage of the tool or the machine.

- Block the chip setting locking lever (pos. E, fig. 5.3.1). **SEE THE UZ50 MANUAL**
- It is recommended to note the values set on the scale of the setting wheel (pos. D, fig. 5.3.1.), **SEE THE UZ50 MANUAL**. This will help you to set the next cut.

Fig. 5.4.1



### How to understand the table:

In the table choose the angle and bevel height A according to your specification. In the M column you will find the needed number of division marks that you have to set on the chip setting wheel (pos. D, fig. 5.3.1) **SEE THE UZ50 MANUAL**.

The field with the found setup value helps you to find out what is the number of cuts necessary for making the required bevel.

In case that the bevel height A has such a value that cannot be found in the table, e.g. 18 mm, it is possible to calculate the size of cut using the column for the bevel height A = of 1 mm.

**Example:**

Bevel height 11 mm.

Bevel angle 45°

**Solution:**

Find in the table

1/ the value 41 division marks on the cross point of 45° and bevel height 12 mm.

2/ the value 3 division marks on the cross point of 45° and bevel height 1 mm.

3/ calculate the needed number of division marks to achieve the required bevel of height A of 11mm using the following equation:

41 division marks (12mm) – 3 division marks (1mm) = 38 division mark.

4/ the maximum number of division marks is 20, which means that we may cut as follows:

1<sup>st</sup> cut 20 division marks.

2<sup>nd</sup> cut 18 marks.

**TIP:** Divide individual cuts in such a way that the last cut is the smallest one.

Set the movement to lower values. This will result to better final surface of the bevel.

**Machining**

- Put the UZ50 machine with the UZP30 tool in the optimal position and secure brakes of transport wheels.
- Start engines of the milling tool and feeding and set the feeding speed to approximately position 3 of the speed range. The maximum speed of the machine is 1.2 m/min.
- Insert the workpiece under the feed wheel exercising a gradual force so that the workpiece was in contact with both the vertical and the horizontal ruler.
- The feed speed may be increased after full grip of the material by both feed wheels. The feed speed is not set and it must be adjusted according to cutting blades condition, material quality and cut size. But we recommend you strongly to use position 3 constantly.
- Set the speed position 3 before exit of the material from the machine and in all situations when only one feed wheel is active (entry/exit).
- During bevelling it may happen that it is necessary to adjust force of feed wheels.

**TIP:** Using the feed regulator it is possible to stop and start movement during machining.

 **Important:** In the event that the material feed is not smooth, use a suitable lubricant (eg Teflon spray) and lubricate the surface of the machine table.

## Setting of the next cut

The UZ50 machine with a tool UZP30 is able to make a bevel of width up to 30 mm in some angles. (See section 3.2.). These values may be achieved only by gradual machining in several cuts.

- Release the chip setting locking lever (pos. E, fig. 5.3.1.). **SEE THE UZ50 MANUAL.**
- Using the chip setting wheel (pos. D, fig . 5.3.1.), **SEE THE UZ50 MANUAL**, set the next required cut. Use a table located on the stacker plate of the UZP30 tool for correct reading of values (fig. 5.4.1)

 **Important: The maximum depth of an individual cut is 4 mm (moving of the milling tool). It means 20 division marks on the setup wheel. If you set more for one cut, there is a risk of immediate damage of the tool or the machine.**

- Block the chip setting locking lever (pos. E, fig. 5.3.1). **SEE THE UZ50 MANUAL**
- It is recommended to note the values set on the scale of the setting wheel (pos. D, fig. 5.3.1.), **SEE THE UZ50 MANUAL.** This will help you to set the next cut.
- Start machining. Continue in the same way as when machining the first cut.
- All other cuts means repetition of instructions mentioned in section 5.4.

## 6. MAINTENANCE AND ADJUSTING

### 6.1. Recommendations

 **Important:**  
**Maintenance personnel must be qualified technicians.**

Never work on moving parts, even if you use tools or other objects.

It is strictly forbidden to remove safety devices, to modify them or to manipulate with them. In case of such intervention, the manufacturer refuses any responsibility for safety of the machine and its accessories.

Always use original spare parts (see Chapter 7 “Spare parts”).

 **Attention:**  
**Always wear working gloves when performing maintenance of the machine. Perform maintenance operations when the machine is not running and is disconnected from power supply.**

Clean the machine, the tool and moving parts with compressed air before each shift and as needed.



**Attention:**

**Always wear protective goggles when using compressed air for cleaning and never exceed the pressure of 2 bar**

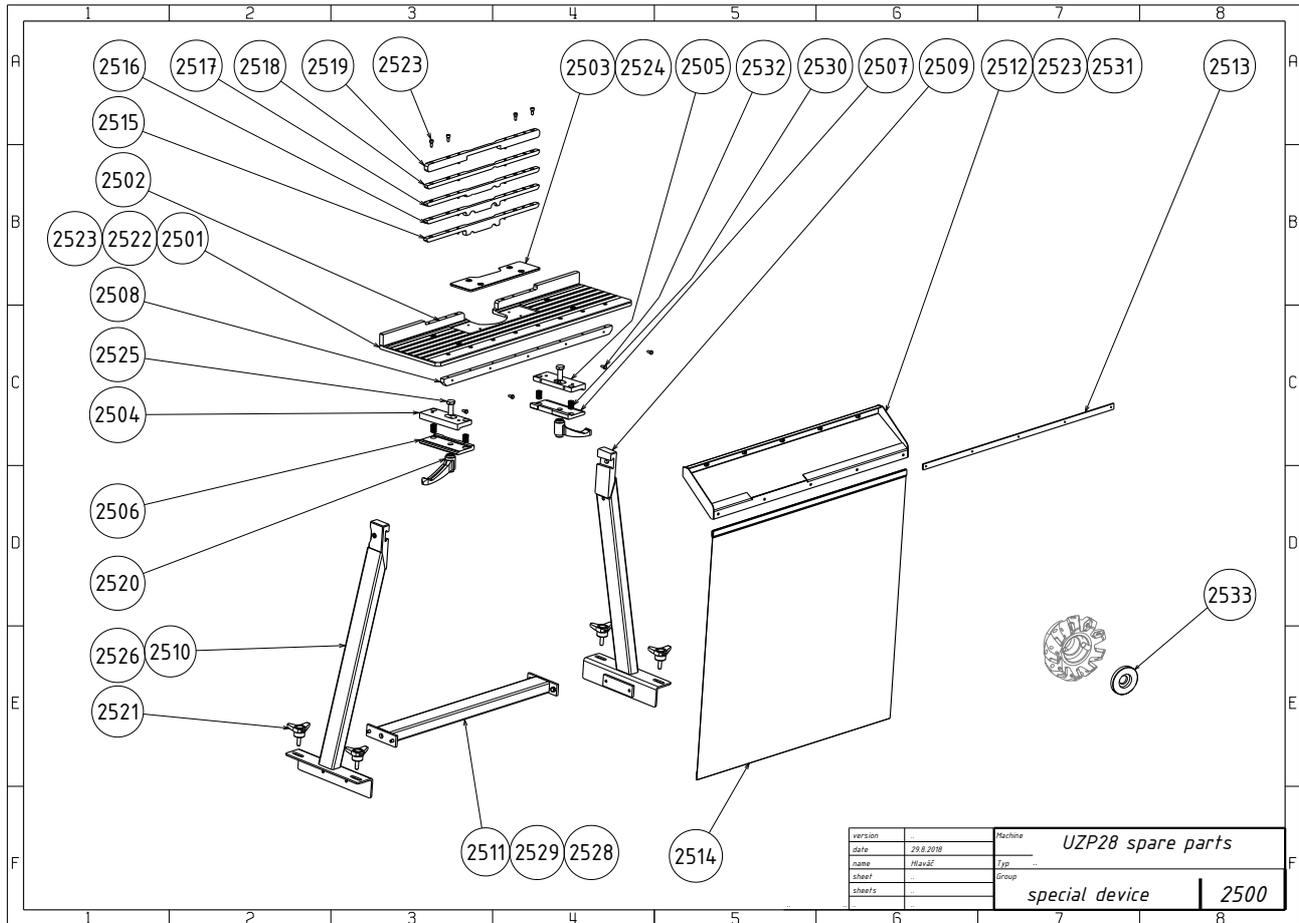
## **7. SPARE PARTS**

### **7.1. How to order spare parts**

Orders of spare parts must contain the following information:

- Machine type;
- Series number;
- Description of the required part and its number
- Quantity.

## 7.2. List of parts



### UZP30 SPARE PARTS

drawing no. 2500 Special Device

Number	Fig	Part name	Pcs	Number	Fig	Part name	Pcs
1940.2501	2501	plate	1	1940.2532	2532	screw M5x10	5
1940.2502	2502	backplate	2	1940.2533	2533	tool washer	1
1940.2503	2503	hardboard	1				
1940.2504	2504	clampbody left	1				
1940.2505	2505	clampbody right	1				
1940.2506	2506	clamp left	1				
1940.2507	2507	clamp right	1				
1940.2508	2508	strut	1				
1940.2509	2509	stem right	1				
1940.2510	2510	stem left	1				
1940.2511	2511	bar	1				
1940.2512	2512	sheetmetal	1				
1940.2513	2513	ribbon	1				
1940.2514	2514	flameproof cloth	1				
1940.2515	2515	insert 1	1				
1940.2516	2516	insert 2	1				
1940.2517	2517	insert 3	1				
1940.2518	2518	insert 4	1				
1940.2519	2519	insert 5	1				
1940.2520	2520	handspike	2				
1940.2521	2521	handscrew	4				
1940.2522	2522	screw M8X12 ISO7380	4				
1940.2523	2523	screw M5x12 ISO4762	23				
1940.2524	2524	screw M6x10 ISO10642	4				
1940.2525	2525	screw M12x30 ISO4017	2				
1940.2526	2526	adjusting screw M12x25	2				
1940.2528	2528	washer 6 ISO7089	4				
1940.2529	2529	screw M6x16 ISO4017	4				
1940.2530	2530	spring	4				
1940.2531	2531	washer ISO7089	5				

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