

# CHAMFERING & DEBURRING MACHINE

*Model: SHG-20W  
SHG-30W*





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## ➤ **Before Use**

### (1) Accessory:

1.1 Cutter

1.2 Electric wire 20dam

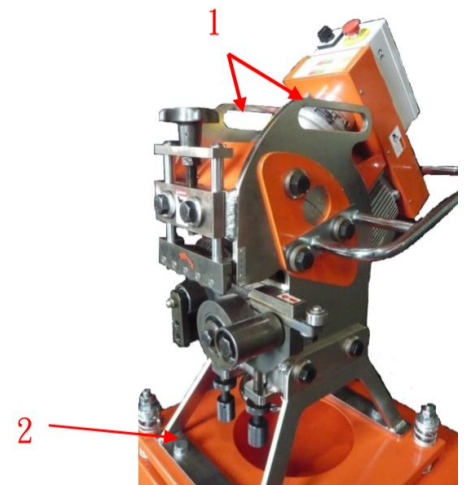
1.3 Cutter washer 8mm×2 2mm×1 1mm×1 0.5mm×2

1.4 Wrench

### (2) Machine and hydraulic lift table

2.1 Hang up the machine by crown from above hole(Figure 1)

2.2 After move to above lift table, confirm control box with hydraulic set the same side, locking four fix screws and nut. (Figure 2)

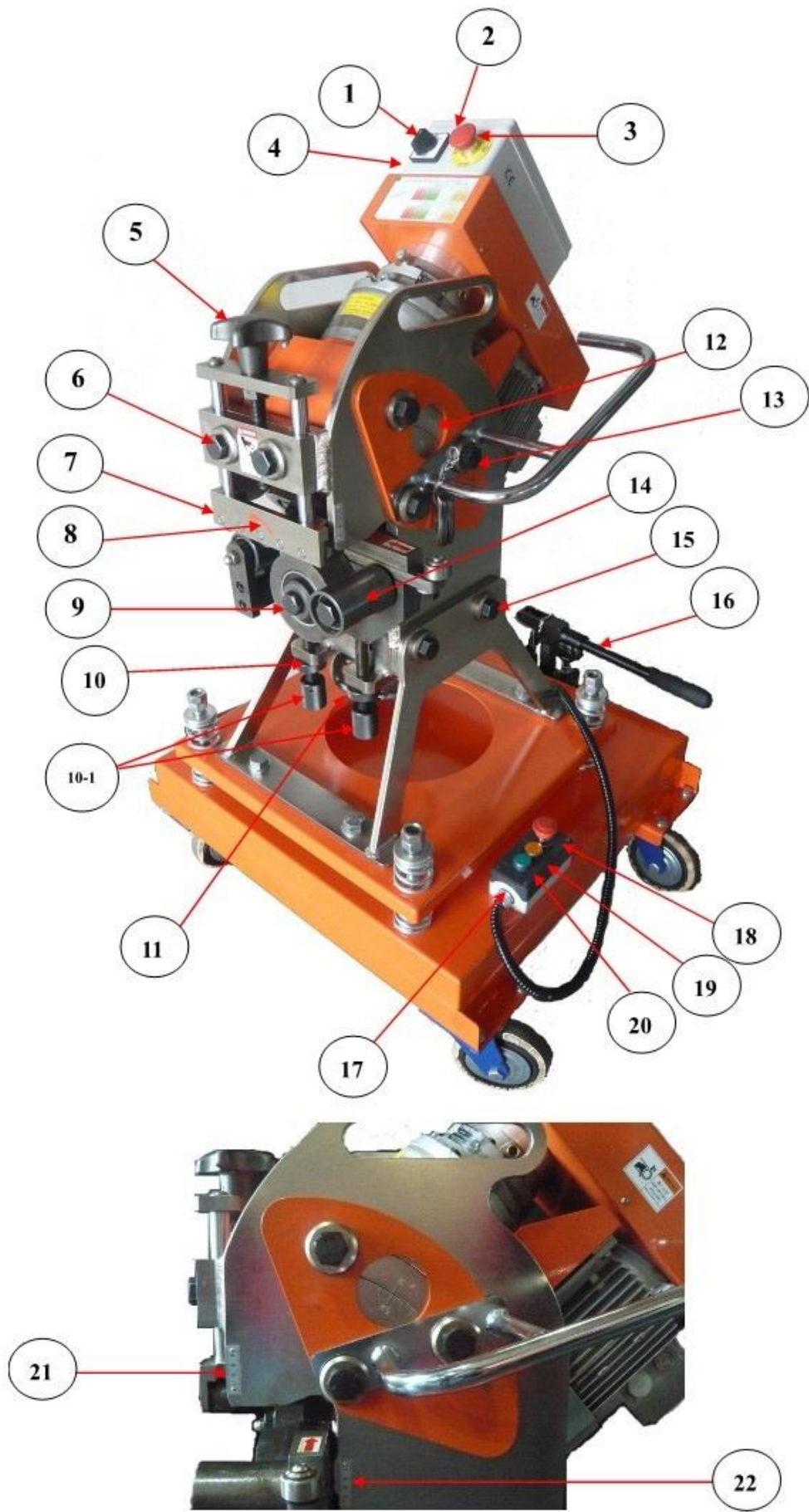


### (3) Before chamfer

3.1. Make sure the power cable and plug has good connection (as right image)

3.2. Motor volotage:230~400/3PH





## ➤ *Operation Instruction ~ Accessory Model*

(1) Release emergency stop button(Figure 3)

(2) Turn on corotation switch (turn left to FWD)(Figure 1)

Check the cutter and make sure the correct running direction

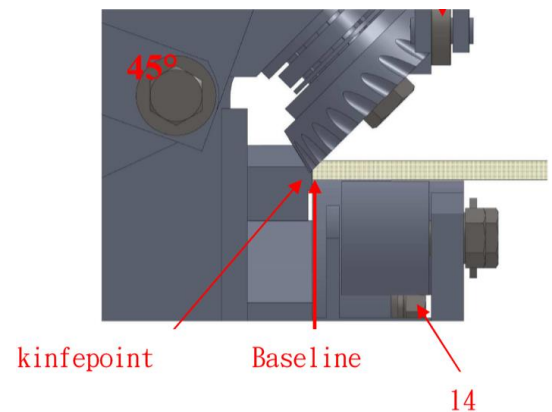
(3) Adjust chamfering angel:

3.1 Release on either side of six screw(Figure13),adjust angle of bevel by rotating the handle,  $15^{\circ} \sim 45^{\circ}$ , every  $5^{\circ}$  grid.

3.2 To lock on either side of six screw(Figure13)

3.3 Check the knifepoint(as right image)

The best chamfer point in baseline left 1~2mm,the chamfer point different depending on the angle of bevel. Please adjust the knifepoint use for fluctuating washer.



(4) Adjust height of bevel:

4.1 Test: Take a small test piece (the same as thick as the mass production parts),put it on the roller bracket(Figure 14), rotating the top handle(Figure 5)press down the compression place(Figure 7), make sure the testing board was the level of state and check it can sliding smoothly for chamfering.

4.2 Adjustment: when height of bevel incorrect

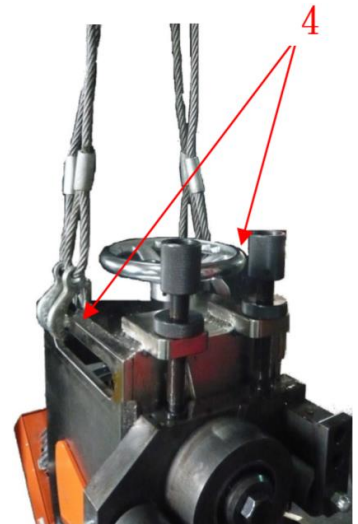
4.2-1 Release the nut(Figure 9)and(Figure 10), roate the handle of bracket 2pcs(Figure 10-1)to adjust the bracket up or down

4.2-2 when testing, if the original calibration is 20(Figure 20) and height of bevel is not enough to 5mm, you need to move up the calibration to 15 and the compression place(Figure 7) also need to increase 5mm(Figure 21)

4.2-3 Locking nut(Figure 9)and(Figure 10)to complete the adjustment

## ➤ *Adjustment to reverse model*

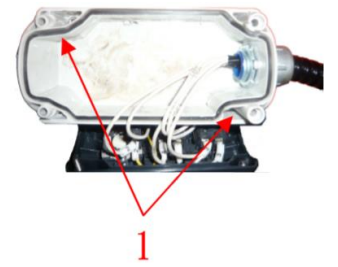
- (1) Hang up the machine by crown from above  
Hole, release a total of four screws on both side  
after fixed machine(Figure 2)+(Figure 3).  
Please release the screw near motor in first(Figure 2).
- (2) Hang up the machine by crown after release four  
screw(Figure 2+3),put in level ground, hanging under  
hole(Figure 4), slowly hang up and turnover machine.
- (3) Hang up the mahchine after complete adjust to reverse,  
confirm control box and hydraulic set the same side,  
slowly down until aimed the hole at screw hole, locking  
screw(Figure 2), confirm locking 4pcs screws to  
complete the adjustment.
- (4) Complete reverse model as below image.



## ➤ *Operation Instruction ~ Reverse model*

### (1) Before use:

- 1.1 To release four screw on the switch box cover, lock switch box in lift table(Figure 1)and lock the cover.
- 1.2 Plug the switch into a wall outlet, (Figure 2)(on the electric appliance box side)



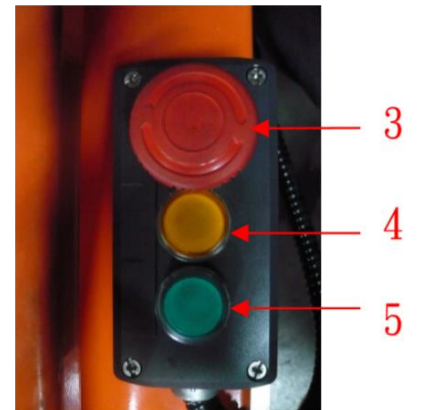
### (2) Turn on switch

- 2.1 To release emergency stop switch (Figure 3)and press turn on button (Figure 5)to start the motor.
- 2.2 Check the cutter and make sure the correct running direction.



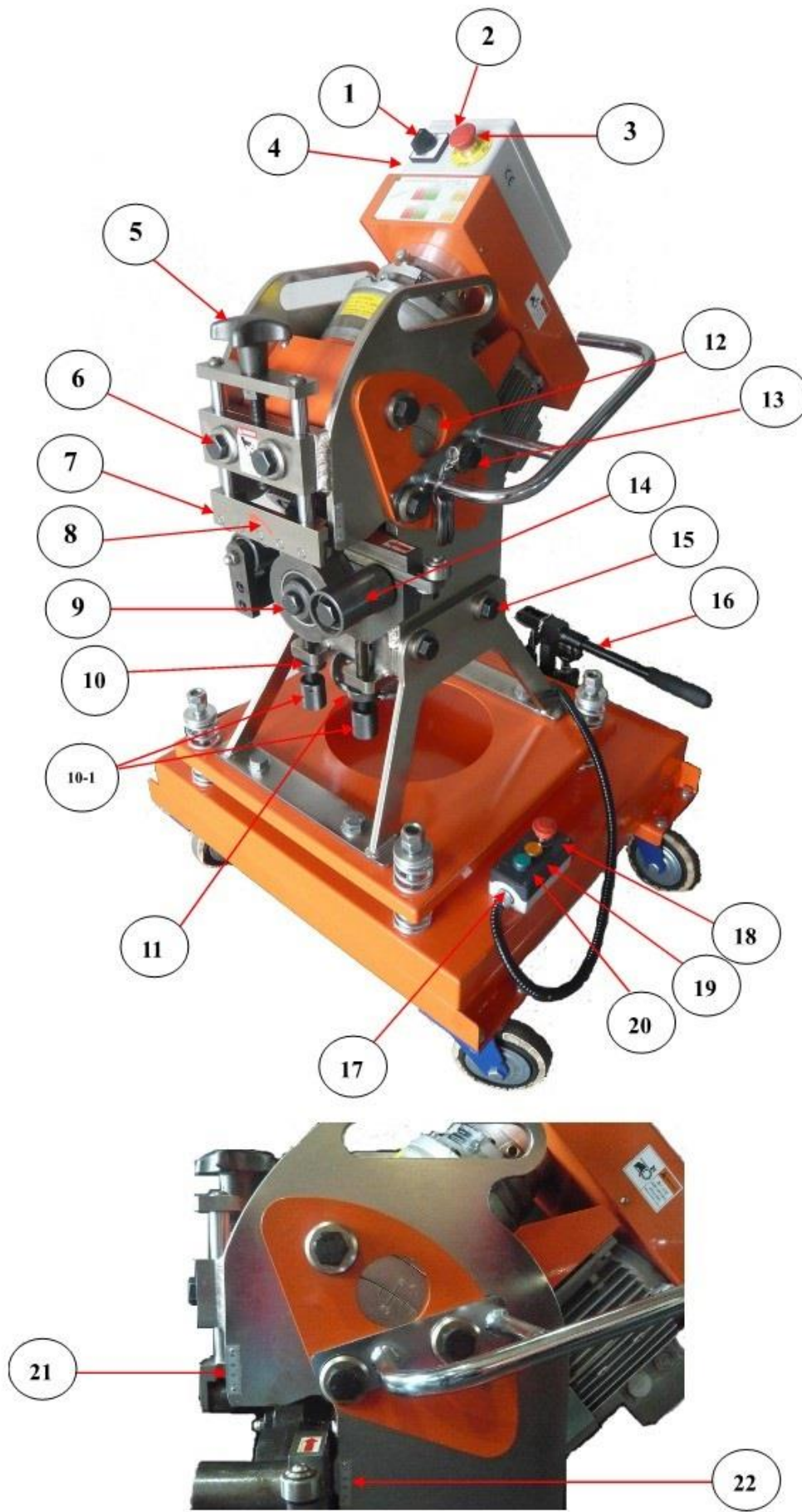
### (3) Adjust height of bevel:

Same as accessory model



### (4) When overload:

- 4.1 To release emergency stop switch (Figure 3)in first, and press reversal button(Figure 4) to release the tool from the workpiece.





## ➤ **Tool Replacement:**

- (1) Recording the calibration(Figure 22)and(Figure 23)
- (2) Loosing and remove screws(Figure 6),set the swivel handle of compression place in the top(Figure 5),to remove the compression place (Figure 7)
- (3) Loosing the nut(Figure 9) + (Figure 10)and rotary handle of bracket(Figure 10-1)to down the bracket to the bottom.
- (4) Loosing the nut and change tool.
- (5) Locking the new tool, to adjusted the bracket to the original setting(Figure 23), then locking the screws(Figure 9+10)
- (6) Put the compression place to original position and locking screws(Figure 6),then adjusting the calibration(Figure 22) location for completed setting.

★ 6.1 Note the direction of the compression Place,  
the whorl up when locking . (right image 1)



Image 1

★6.2 Enable compression place and machine  
the same level(right image 2)



Image 2

★6.3 Do not locking compression place screw  
when adjustment has not finished(as right image 3),  
the facets not consistent caused the handle can not  
locking and breakdown the whorl



Image 3

## ➤ **Safety Warning**

- (1) Before maintenance the mode or chamfer tool, make sure to power off and pull out the plug.
- (2) Machine can be used outdoors, but is not weatherproof.  
Do not expose the rain 、 snow or frost.
- (3) There is equipped with over load on the machine to protect The current and avoid the short circuit. When used on building sites, it must be supplied through a separation transformer made in the second class of protection.
- (4) Trouble shooting for motor:
  - 4.1 To check the power is on or not.
  - 4.2 To check the EMC switch is on or not.
  - 4.3 To check the machine power is on or not.
  - 4.4 Turn the switch to STOP in first, and press EMC switch.  
To open the electrical box and press the **RESET** to reset.( as below image)

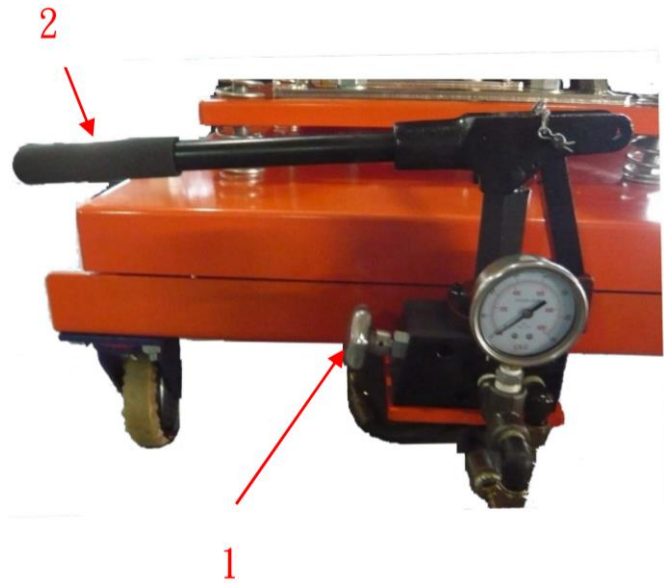


- (5) When overload:  
Please turn right the switch to REV, press instantaneous reversal button to release the tool from workpiece.  
***(To noticed, do not a long press or it will breakdown the tools and damaged machine)***

## ➤ Operation ~ Hydraulic lift table

### (1) Step up lift table:

Lock pressure relief valve  
(Figure 1) to step up the lift table  
with pressure handle(Figure 2)



### (2) Reduce the lift table:

Release pressure relief valve

(Figure1) and reduce the lift table

***Please confirm staff leave the lift table clearance before release pressure relief valve, and slowly release to avoid danger.***

### (3) Safety warning

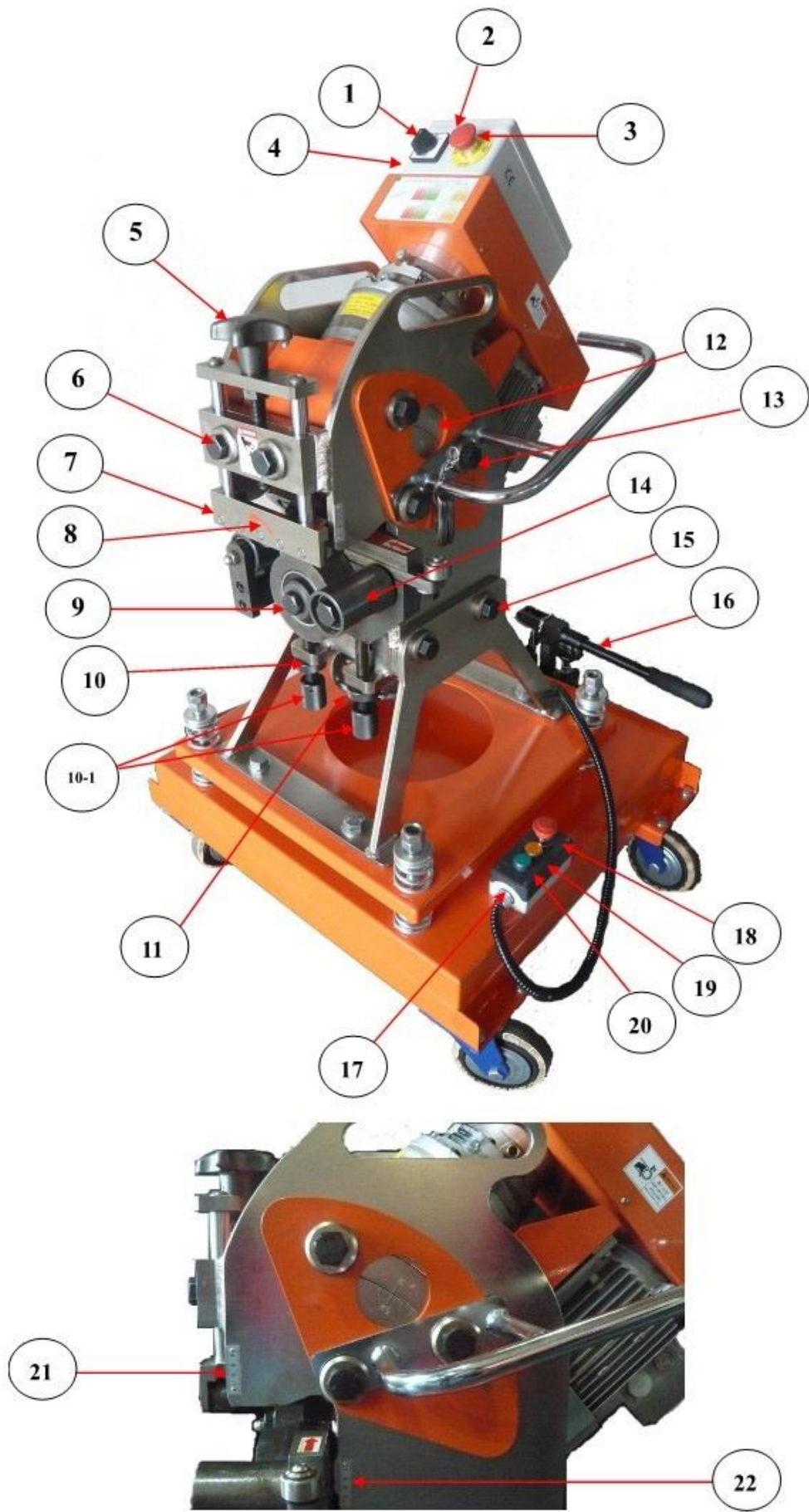
3.1 Please add 68# hydraulic oil when oil are low.

3.2 Hydraulic lift table load capacity below 300kgs.

3.3 Please do not pressure over 50kgs/cm<sup>2</sup>

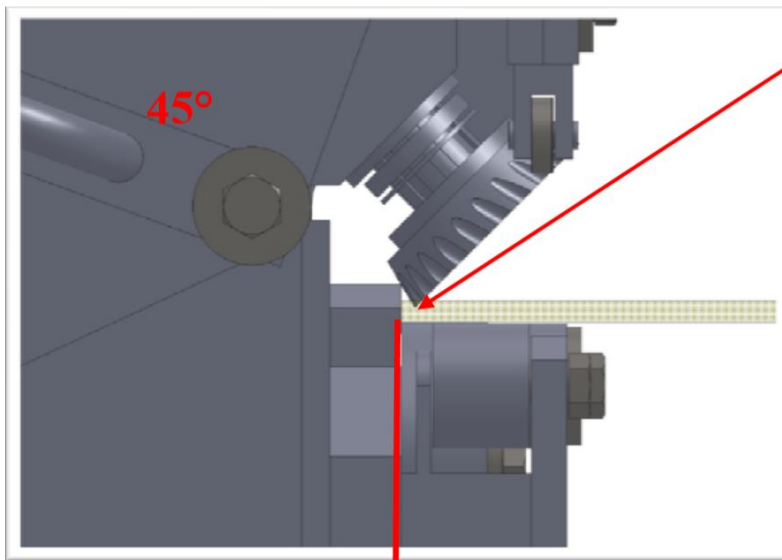
3.4 Please not wheel do not exceed the line (below image)





## PARTS LIST(零件表) JT-20C

P/NO	零件名稱	PART'S NAME	數量(Q'TY)	備註(REMARK)
1	機器電源開關	SWITCH	1PC	
2	瞬間逆轉按鈕	INSTANTANEOUS REVERSAL BUTTON	1PC	
3	緊急停止開關	URGENT STOP SWITCH	1PC	
4	反轉模式開關	REVERSAL MODEL SWITCH	1PC	
5	加壓座調整把手	SWIVEL HANDLE OF COMPRESSION PLACE	1PC	
6	加壓座固定螺絲	FIX SCREW OF COMPRESSION PLACE	1PC	
7	加壓座	COMPRESSION PLACE	1PC	
8	馬達旋轉方向	AROUND DIRECTION	1PC	
9	托架固定螺帽	SET NUT OF BRACKET	1PC	
10	調整把手頭螺帽	SCREW	2PCS	
10-1	托架調整把手頭	HANDLE OF BRACKET	2PCS	
11	調整角度用把手	HANDLE FOR SWIVEL ANGLE	1PC	
12	切削角度指示	POINT OF CUTTING ANGLE	1PC	
13	調整角度用螺絲	SCREW FOR SWIVEL ANGLE	6PCS	
14	下方托架	BRACKET	1PC	
15	機座固定螺絲	MACHINE SET SCREW	4PCS	
16	油壓裝置	OIL PRESSURE DEVICES	1SET	
17	反轉模式開關盒	MACHINE REVERSAL MODEL SWITCH	1SET	
18	緊急停止開關	URGENT STOP SWITCH	1PC	
19	馬達逆轉按鈕	REVERSAL BUTTON	1PC	
20	馬達正轉按鈕	TURN ON BUTTON	1PC	
21	加壓座設定刻度	CALIBRATION OF COMPRESSION PLACE	1PC	
22	托架設定刻度	CALIBRATION OF BRACKET	1PC	



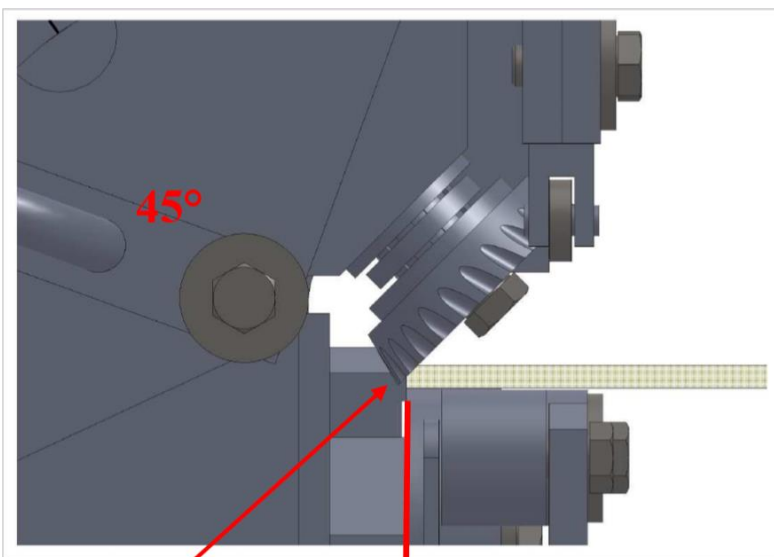
**BASE LINE**

- ◆ when the knifepoint inclines to the right:
  - A. It can't bite off with workpiece.
  - B. Cutter will be broke down or damage

- ◆ Exclusive method:
  - A. Reduce thickness of washer
  - B. Up the below bracket



Signs of the workpiece can't bite off



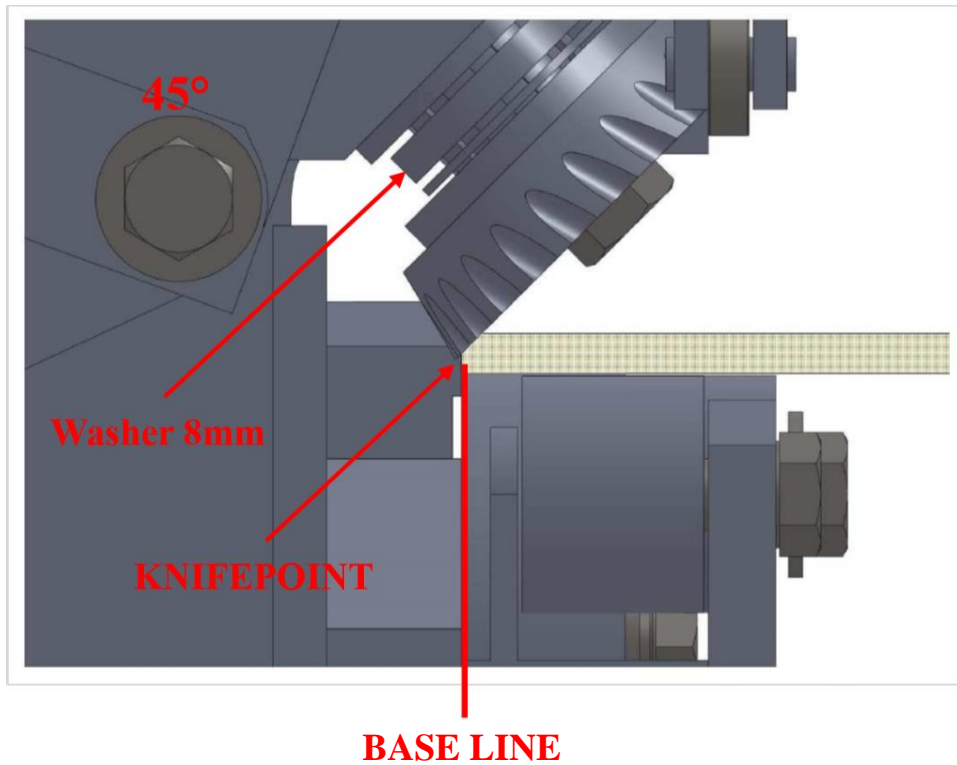
**KNIFEPOINT**

**BASE LINE**

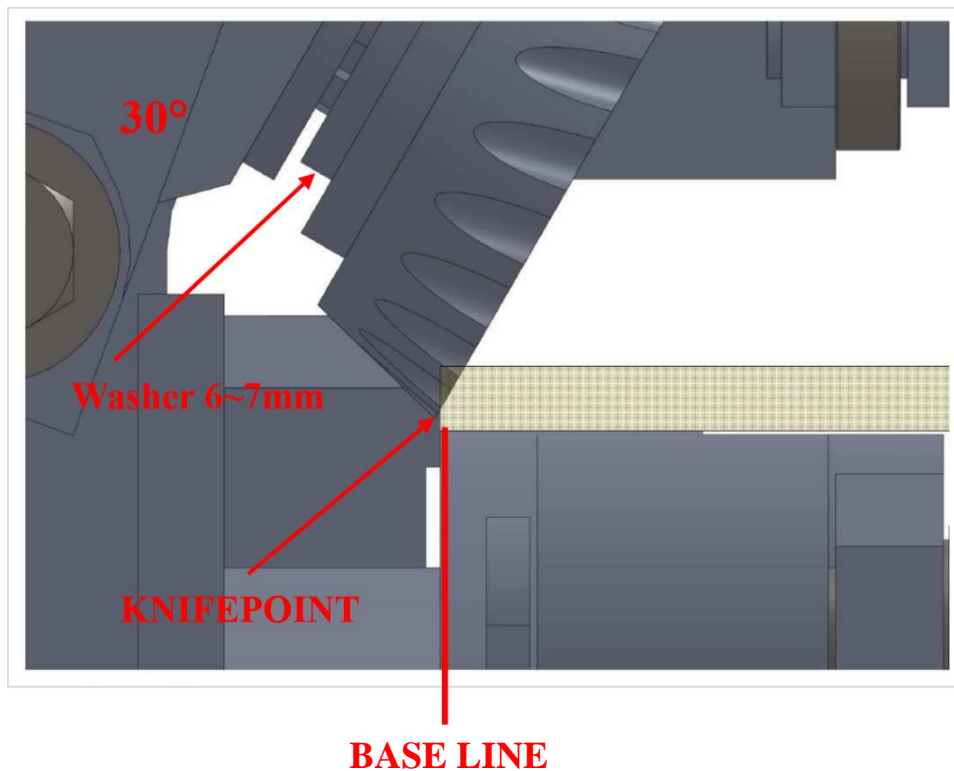
- ◆ when the knifepoint inclines to the right:
  - A. the machine isn't working well.
  - B. the machine moved have not thrust
  - C. knife serious abrasion

- ◆ Exclusive method:
  - A. add thickness of washer
  - B. down the below bracket

【The correct point of 45deg chamfer】



【The correct point of 30deg chamfer】

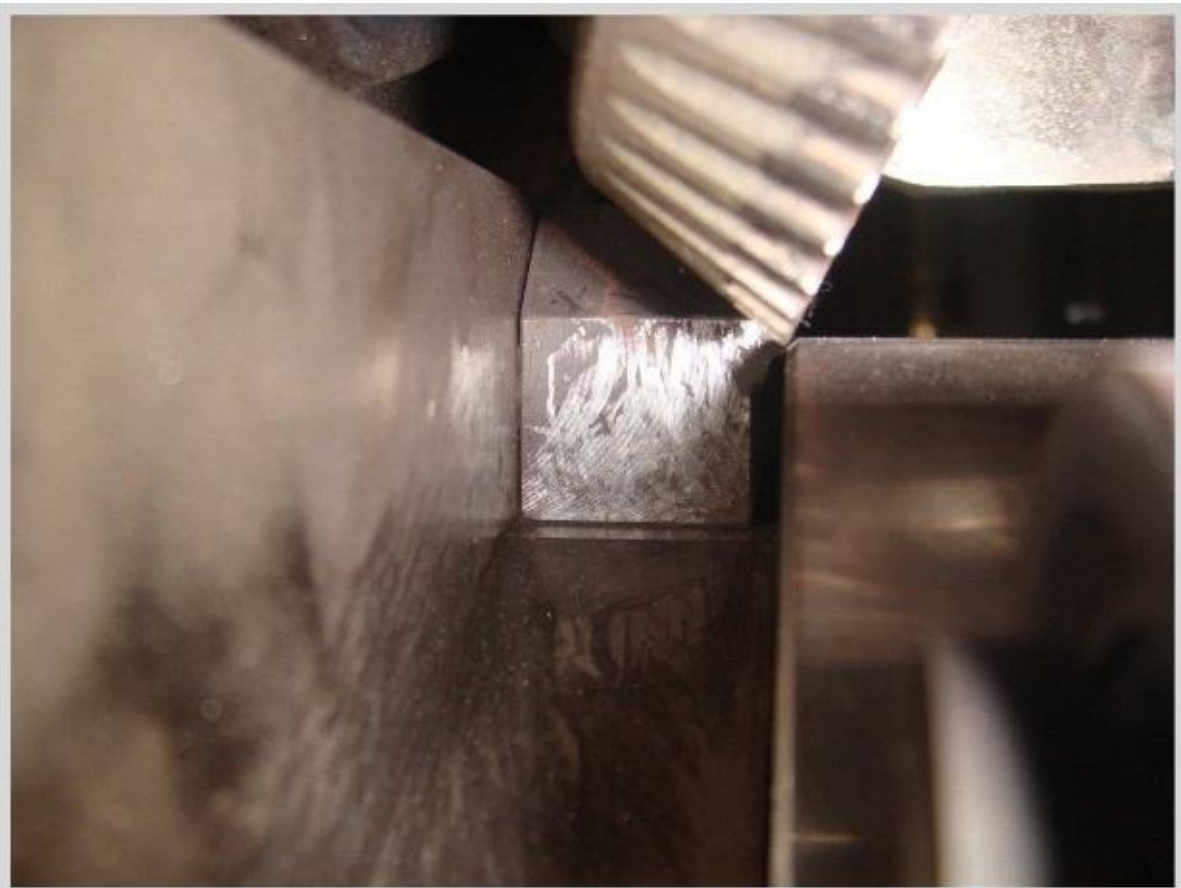


- ◆ A. The best chamfer point in baseline left 1~2mm
- ◆ B. Adjustment height of bevel before confirm chamfer point.
- ◆ C. The machine base on 45deg and washer 8mm in leave the factory, the knifepoint will move to the right when modify the angle to 30deg, please change the washer under 8mm, adjustment the knifepoint to baseline left.

**【The workpiece can't bite off graphic】**



**【Correct chamfer】**







**JT-100C+100R**



**JT-C3+R3**



**JT-250GS**



**JT-200A**



**SHG-W8**



**SHG-12W**



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