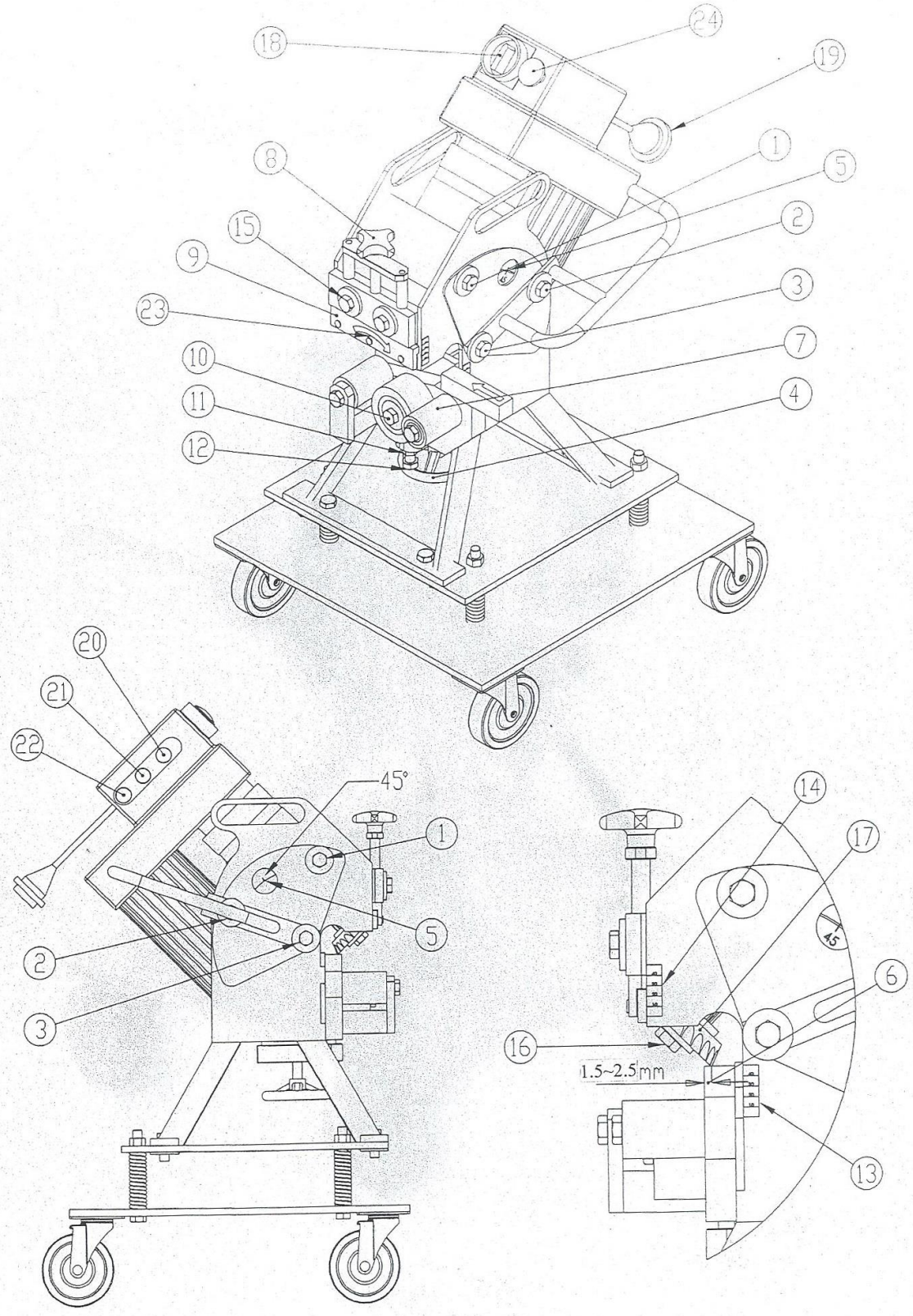
CHAMFERING
&
DEBURRING MACHINE

Model：SHG-W12

P1～P6　English
P7~ P12　中文
P13　零件表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1.5~2.5mm
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Before use

(一) Make sure the power cable and plug has good connection (Figure⑲)。

(二)Turn on switch (Figure⑱)。

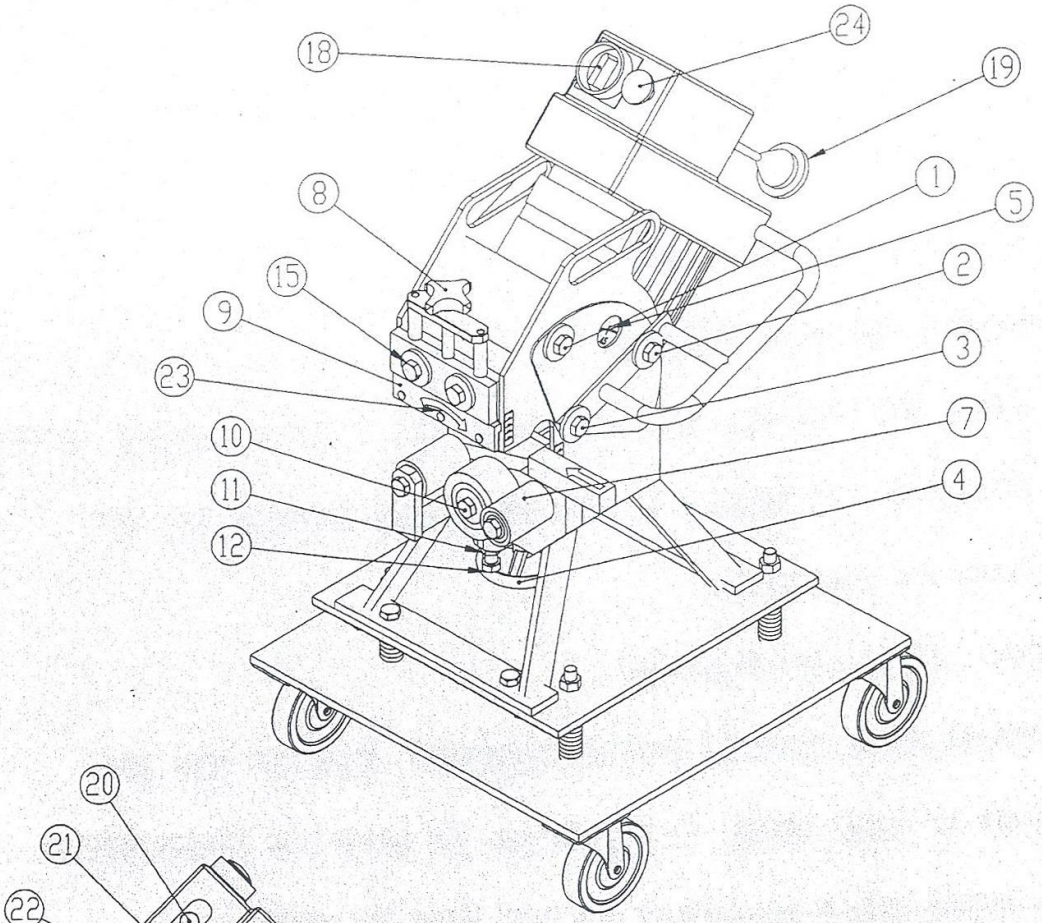
(三)To start the motor (Figure⑳)。

Check the cutting and make sure the correct running direction (Figure㉓), if there s no correct , please exchange any two wires for correction.

(四)Power off switch (Figure㉑)。

(五)Instantaneous reversal button (Figure㉒) . When the tool was stuck by large amount of chamfering. To press the instantaneous reversal button to release the tool from the workpiece.

To noticed, do not a long press, or it will breakdown the tools and damaged machine.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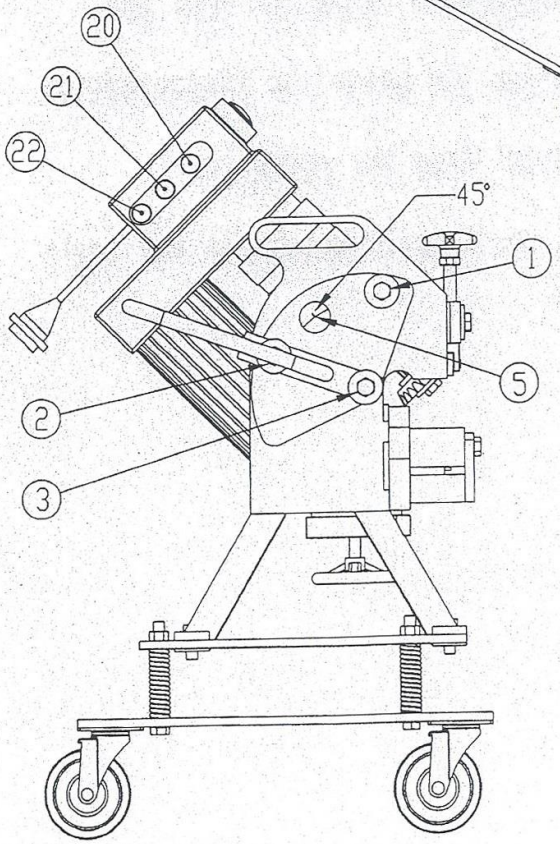
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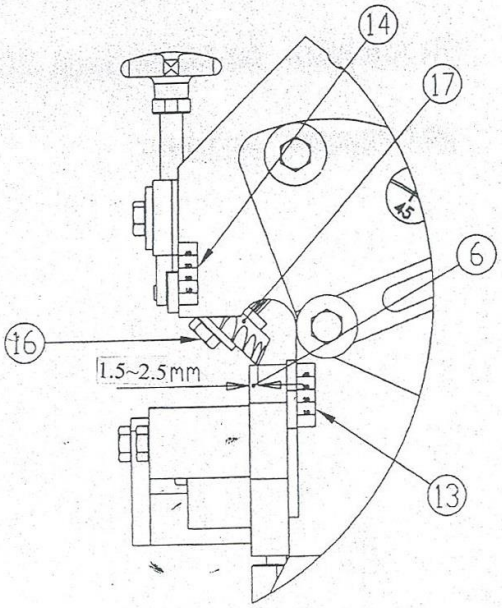
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1.5~2.5mm
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Operation Instruction

(一)The better height for processing of self-propelled chamfering machine：

1.1 To use table car: To put the workpiece on the platform, height 650~680mm for chamfering。

1.2 If you do not have a table car, the height of workpiece must at 400mm above for chamfering。

(二) Adjusting the chamfering angel of workpiece：

2.1 Release (Figure①②③) a total of six screws on both side, rotate the handle that under the machine(Figure④) To adjust the chamfering angle (Figure⑤) , 15°~45°, every 5 degrees grid。

2.2 To lock ①②③both side of the hexagonal screws。

2.3 Visual inspection of the tool tip position of about 1.5~2.5mm(Figure⑥) , Depending on the different chamfering angle the cutting point will be different. The accessories included:
Sheet metal: 4mmx1, 2mmx1, 1mmx1, 0.5mmx2 pcs.
Note: Sheet metal is for adjusting the height of tool tip.

(三)Chamfering amount adjustment：

3.1 Test：Take a small test piece (the same as thick as the mass production parts), put it on the roller bracket (Figure⑦) Rotating the top handle (Figure⑧) , press down the block wheel pressure (Figure⑨) , make sure the testing board was the level of state and check it can sliding smoothly for chamfering.

3.2 When the chamfering amount is too large or too small. You can adjust follow up instruction：

3.2-1 Loosen the nut (Figure⑩) +(Figure⑪)。

3.2-2 Rotating screws (Figure⑫) , Adjusting the bottom bracket up or down.

3.2-3 ex：When testing, if the original calibration is 20 (Figure⑬) , and chamfering amount is not enough to 5mm. You need to move up the calibration to 15, and the pressure block (Figure⑨) also need to increase 5mm (Figure⑭)

3.2-4 Locking nut (Figure⑪) and(Figure⑩) to complete the adjustment。

(四) Tool Replacement：

4.1 Recording the calibration (Figure⑬) and (Figure⑭)。

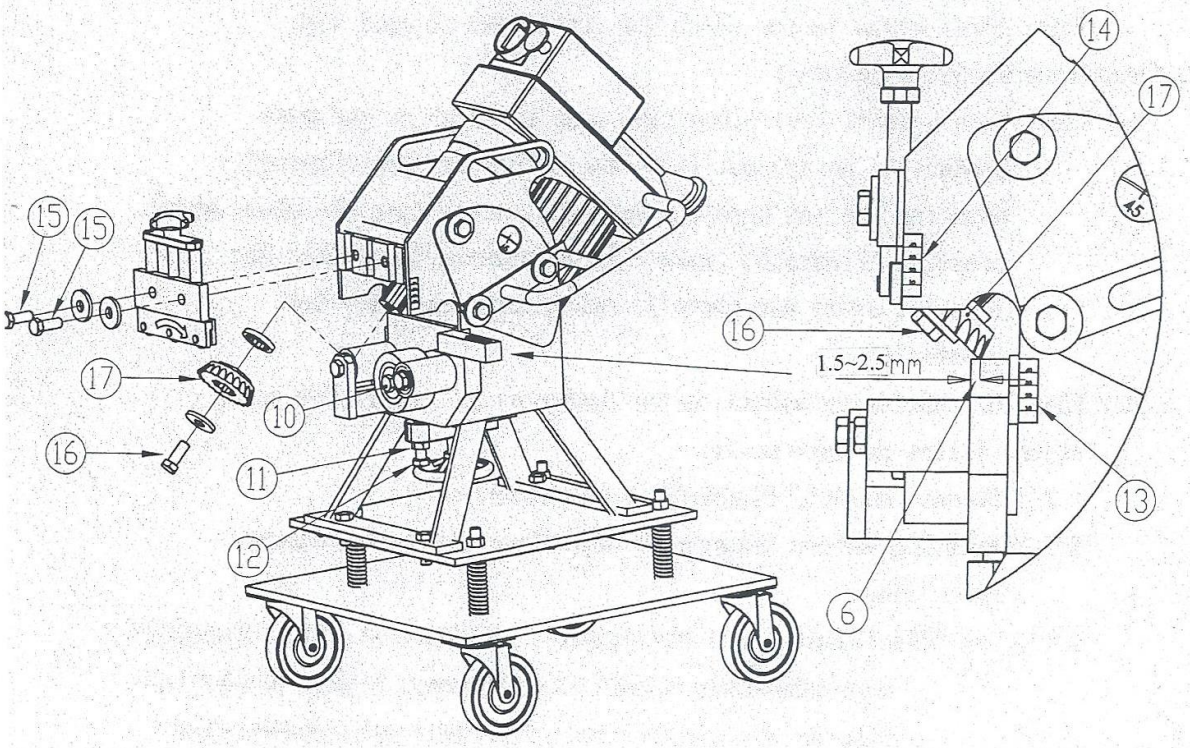
4.2 Loosing and remove screws (Figure⑮) , to remove the under pressure black sets.

4.3 Loosing the nut(Figure⑩) + (Figure⑪) and rotary screw (Figure⑫) to down the bottom bracket to the bottom.

4.4 Loosing the nut (Figure⑯) , and change tool(Figure⑰)。

4.5 Locking the new tool, to adjusted the bottom bracket to the original setting (Figure⑬) , then locking the screws (Figure⑩) + (Figure⑪)。

4.6 Lockineg the screw(Figure⑮) of under pressure block set, then adjusting the calibration (Figure⑭) location for completed setting.



Safety Warning

(一) Before maintenance the mode or change tool, make sure to power off and pull out the plug.

(二) Machine can be used outdoors, but is not weatherproof. Do not expose the rain, snow or frost.

(三) 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.

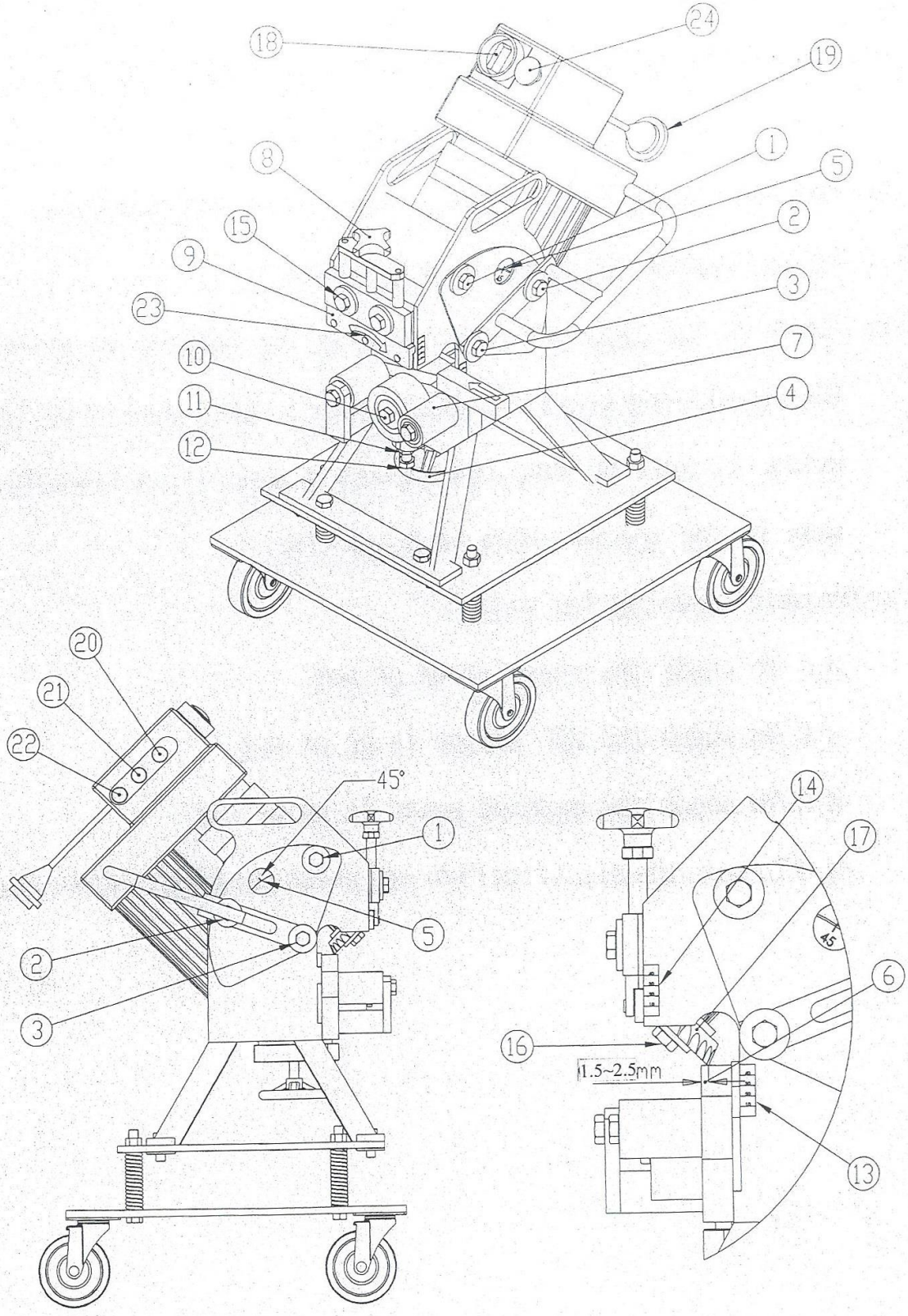
(四)Trouble shooting for motor:

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 To open the electrical box and press the RESET key to reset.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使用前注意事項

(一)接上電源線及插頭（指示⑲）。

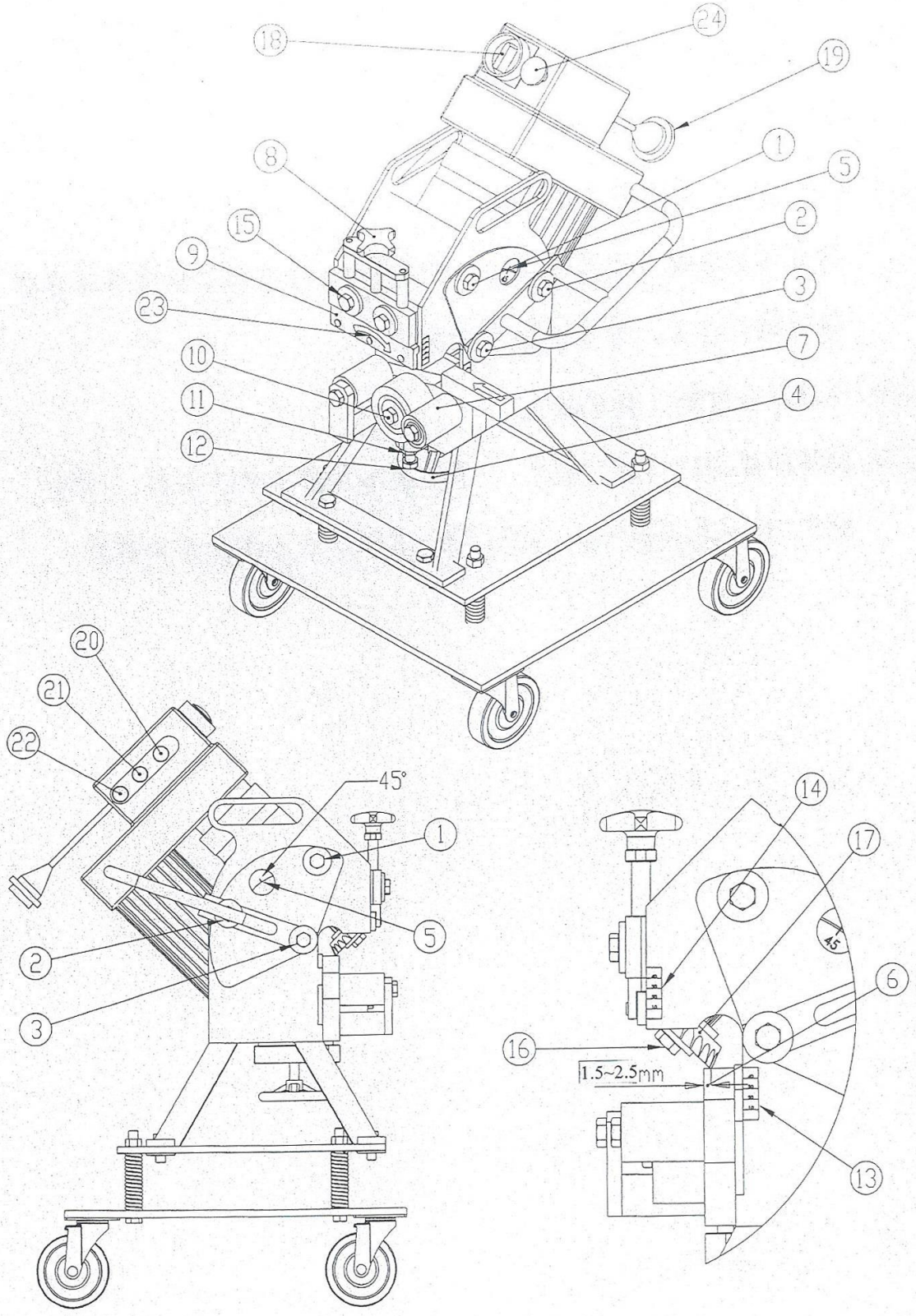
(二)啟動電源開關（指示⑱）。

(三)啟動馬達正轉開關（指示⑳）。

檢查刀具旋轉方向是否正確（指示㉓），若方向不正確請將電源總開關內任意二條電源線互換即可。

(四)運轉停止按鈕（指示㉑）。

(五)瞬間逆轉按鈕（指示㉒），一當刀具切削量太大卡住時，可瞬間按下，使刀具退出工件，切勿久按，會導至刀具破裂損傷機器。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操作步驟

(一)適合自走式倒角機使用的工作高度：

1.1 使用台車時,請將加工工件平放在 650~680 ㎜ 的平台上。

1.2 若不用台車,工件高度需在 400㎜ 以上即可使用。

(二)調整工件欲切削的角度：

2.1 鬆開（指示①②③）兩側共六個螺絲,旋轉機台下方把手（指示④）即可調整切削角度（指示⑤）,15°～45°每格 5 度。

2.2 鎖緊①②③兩側六角螺絲。

2.3 目視檢查刀具尖點（指示⑥）位置約1.5~2.5㎜,當切削角度不同時,切削點也會不同.配件中有墊片 4㎜x1 片、2㎜x1 片、1㎜x1 片、0.5㎜x2 片,可視需要更換墊片高度來調整刀具尖點位置。

(三)調整切削量：

3.1 試車：取一小塊試車工件（需與量產的工件一樣厚）放到下方托架滾輪上（指示⑦）,旋轉上方把手（指示⑧）將滾輪加壓座（指示⑨）往下壓至試車板材呈水平狀態且可以在下方托架滾輪上（指示⑦）與加壓座（指示⑨）中間順暢滑動,即可進行切削試車。

3.2 當切削量太大 or 太小時調整步驟：

3.2-1 鬆開螺帽（指示⑩）+（指示⑪）。

3.2-2 旋轉螺絲（指示⑫）可上下調整下方托架。

3.2-3 ex：試車時原來刻度（指示⑬）若為 20,但切削量仍不夠 5㎜ 時,則刻度（指示⑬）需往上移至刻度 15,同時加壓座（指示⑨）的刻度（指示⑭）亦需往上調 5㎜。

3.2-4 鎖緊螺帽（指示⑪）後再鎖緊（指示⑩）即完成調整步驟。

（四）更換刀具：

4.1 記錄刻度（指示⑬）與（指示⑭）。

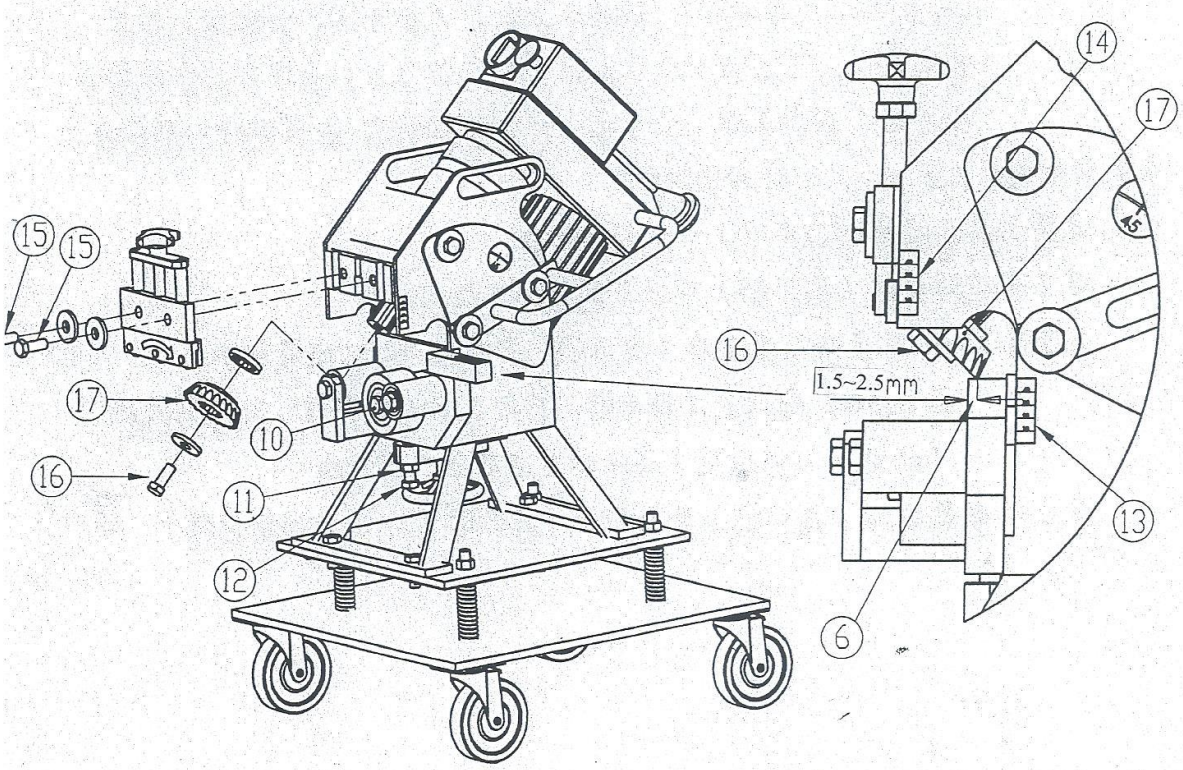
4.2 鬆開並取下螺絲（指示⑮），將下壓座整組拆下。

4.3 鬆開螺帽（指示⑩）＋（指示⑪）旋轉螺絲（指示⑫）將下方托架降到最低。

4.4 鬆開鎖刀具螺絲（指示⑯），即可更換刀具（指示⑰）。

4.5 鎖緊新刀具後，將下方托架往上調整至原來設定的刻度位置（指示⑬），鎖緊螺帽（指示⑩）＋（指示⑪）。

4.6 將下壓座整組用螺絲（指示⑮）鎖緊並調整回刻度（指示⑭）原來位置，即設定完成。



安全警告

(一)進行維修保養 or 更換刀具前,請先拔掉電源插頭,切斷電源。

(二)機器可於戶外使用，但不可暴露在雨中 or 危險地區。

(三)機器連接至電器箱總開關時,應有過載保護以防短路,當在工地使用時,必須經由分離式變壓器來供應做第二層保護。

(四)若切削量太大導致馬達無法運轉時：

4.1 請檢查總電源開關是否跳脫。

4.2 請檢查緊急開關是否放開。

4.3 請檢查機器電源開關是否轉到 ON。

4.4 拆開電器盒,重置電磁開關按下 RESET 鍵。

PARTS LIST

P/NO.	零件名稱	PART' S NAME	數量 (Q' TY)	備註 (REMARK)
1.2.3	調整角度用螺絲	Screw for swivel angle	6	
4	調整角度用把手	Handle for swivel angle	1	
5	切削角度指示	Point of cutting angle	1	
6	刀具切削點	Cutting point of pool	1	
7	下方托架	Bracket	1	
8	加壓座調整把手	Swivel handle of compression place	1	
9	加壓座	Compression place	1	
10	托架固定螺帽	Set nut of bracket	1	
11	托架調整螺帽	Adjustment nut of bracket	1	
12	托架調整螺絲	Adjustment screw of bracket	1	
13	托架設定刻度	Calibration of bracket	1	
14	加壓座設定刻度	Calibration of compression place	1	
15	加壓座固定螺絲	Fix screw of compression place	2	
16	鎖刀具螺絲	Screw for locking tool	1	
17	刀具	Tool	1	
18	機器電源開關	Switch	1	
19	電源插頭	Plug	1	
20	馬達正轉按鈕	Turn on button	1	
21	馬達停止按鈕	Stop button	1	
22	馬達瞬間逆轉按鈕	Instantaneous reversal button	1	
23	馬達旋轉方向	Around direction	1	
24	緊急停止開關	Urgent stop switch	1	