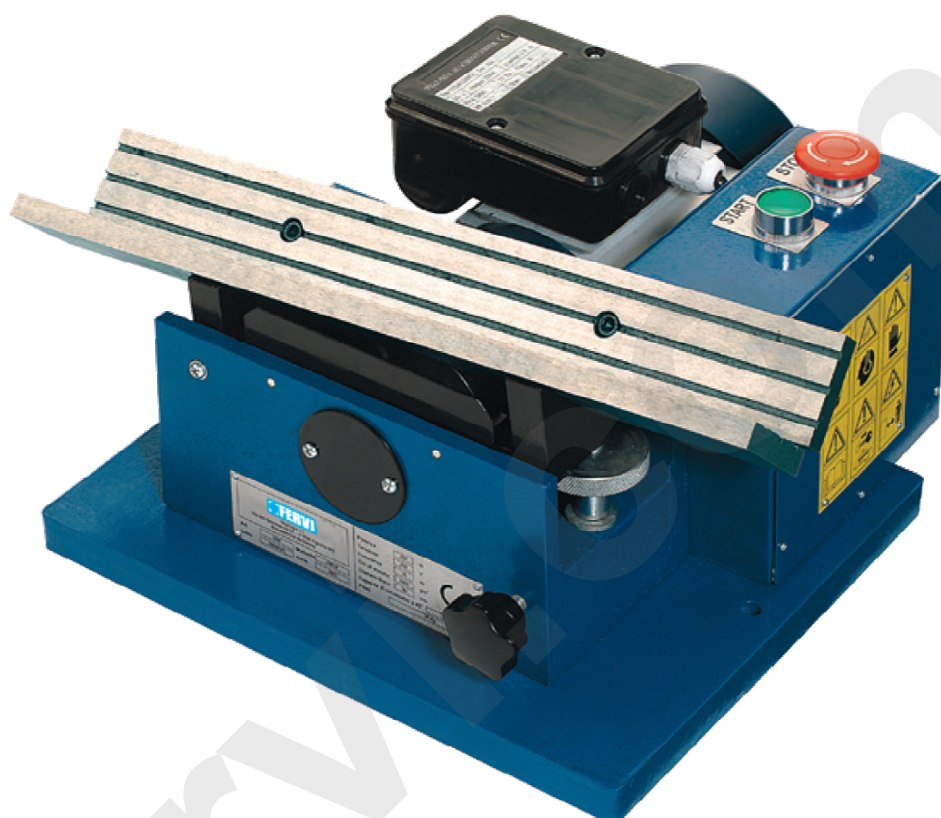


USE AND MAINTENANCE MANUAL



**Bench chamfering machine
Art. 0560**



ORIGINAL INSTRUCTIONS

PREFACE



Read this manual before operation

ORIGINAL INSTRUCTIONS

Before starting any operation it is compulsory to read this instruction manual. The guarantee of smooth operation and full performance of the machine is highly dependent on the application of all the instructions contained in this manual.



Qualifications of the operator

The operators assigned to using this machine must be supplied with all of the necessary information and instruction and should be provided with adequate training regarding safety in pertaining to:

- a) The conditions of use of the equipment;
 - b) Foreseeable abnormal situations;
- pursuant to art. 73 of Legislative Decree no. 81/08.

We guarantee the machine complies with the specifications and technical instructions described in this Manual on the date of issuance, listed on herein. However, the machine may undergo technical modifications in the future, which may also be significant, without the manual being updated.

Contact FERVI for information on any variations that may have been made.



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1 INTRODUCTION

This manual is designed to provide the knowledge required for the use and maintenance of the **BENCH CHAMFERING MACHINE ART. 0560** and to provide the operator assigned to the device with a sense of responsibility and knowledge of its possibilities and limitations.

As the machine is assigned to experienced and skilled operators, the operator must have a thorough knowledge of following machines if they are to be used safely and effectively.

Selecting personnel is an important factor for efficiency and safety in the workplace, and the people considered suitable to perform a specific job must have the sufficient physical and mental capacity to allow them to understand the instructions that they are given.

1.1 Graphic form of the alerts related to safety, operation, risk warnings

The following boxes are designed to attract the attention of the reader / user for the purposes of proper and safe use of the machine:



Pay attention

Highlights rules on behaviour to be followed to prevent damage to the machine and/or the occurrence of dangerous situations.



Residual risks

Highlights the presence of dangers that cause residual risks to which the operator must pay attention in order to prevent injury or material damage.



1.2 Preface

For the safe and simple operation of the Chamfering machine, this manual must be read carefully to gain the necessary knowledge. In other words, the lifespan and performance of the machine are dependent on how it is used.

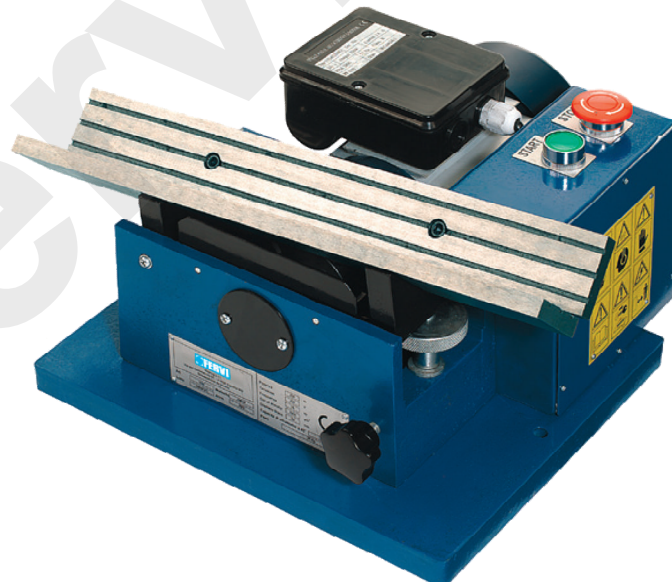
Even if already familiar with the Bench chamfering machine, it is necessary to follow the instructions contained herein, in addition to the general precautions to be observed while working.

- Acquire full knowledge of the machine.
- Read this manual carefully to learn about: operation, safety devices and all necessary precautions. All of this allows safe use of the machine.
- Wear appropriate clothing for the job.
- The operator must wear appropriate clothing to prevent the occurrence of unpleasant accidents.
- Take proper care of the machine.



Use of the machine

The machine must only be used by personnel who have been specially trained in its use by authorised personnel.



2 GENERAL SAFETY WARNINGS

2.1 General safety rules for machine equipment



Risks associated with the use of the machine

DO NOT underestimate the risks associated with the use of the machine and concentrate on the work that is taking place.



Risks associated with the use of the machine

Despite the implementation of all the safety devices for safe use of the machine, it is necessary to take note of all the requirements for the prevention of accidents detailed in the various sections of this manual.



Risks associated with the use of the machine

Each and every person responsible for the use and maintenance should have first read the instruction booklet and the chapter on safety in particular.

The person in charge of company safety in the workplace is advised to receive written confirmation of the above.



Protective equipment for the operator

Before starting any work on the machine, the operator must wear the appropriate personal protective equipment (PPE) such as goggles, gloves and non-slip shoes.



Qualifications of the operator

The operators assigned to using this machine must have all the necessary information and instruction and should be given adequate training in relation to safety regarding:

- a. the conditions of use of the equipment;
- b. foreseeable abnormal situations;

pursuant to art. 73 of Legislative Decree no. 81/08.

1. Read this manual carefully, in order to work safely.
2. Always check the efficiency and integrity of the machine.
3. Before connecting the machine to the mains, ensure that the rotating parts are not damaged or badly worn. Ensure that the switch is in the resting position.
4. Do not start the machine in an enclosed or poorly ventilated area and in the presence of flammable and/or explosive atmospheres. Do not use the machine in damp and/or wet areas and do not expose it to rain.
5. Avoid accidental starting.
6. Before starting the machine make a habit of checking that no adjustment or service keys have been left inserted.



7. Keep the work area tidy and free from encumbrances. Untidiness causes accidents.
8. Make sure that your work environment is forbidden to children, strangers and animals.
9. Do not subject the machine to performance levels above those for which it was designed. Only employ the machine in the manner and for the intended uses described in this instruction manual.
10. Remain balanced whilst working.
11. Only work with good lighting.
12. Always wear protective goggles and gloves while working. In the event dust is produced, use appropriate masks.
13. Wear appropriate clothing. Loose clothing, jewellery, long hair, etc., can catch on the moving parts, causing irreparable injury.
14. Do not grasp tools while they are in motion.
15. To stop the tools of the machine, always and only use the stop command device (red button).
16. Do not move away from the machine until the tools and other moving parts, have completely stopped.
17. Replace worn and/or damaged parts, check that the guards and protection devices work correctly before operating. You may, if necessary, have the machine checked by the service support personnel. Use only original spare parts.
18. **Unplug the power cord of the machine from the power outlet when:**
 - not using the machine;
 - it is left unattended;
 - performing maintenance or registration operations, because it does not work properly;
 - the power cord is damaged;
 - replacing the tools or the cutting inserts;
 - performing movement and/or transport operations;
 - cleaning.
19. It is recommended that users of this publication, for maintenance and repair, have a basic knowledge of the mechanical principles and procedures inherent in the techniques for the repair.
20. **The person responsible for company safety will establish that the personnel assigned to the use of the machine have read and understood this manual in its entirety.**
21. **Responsibility for verifying the risk status at the company remains with the person in charge of safety, according to Legislative Decree no. 626/94.**

2.2 Safety rules for electric machine-tools



Changes to the electrical system

- Do not modify the machine's electrical system in any way. Any attempt to do so may impair the operation of the electrical devices causing a malfunction or accident.
- Work on the electrical system of the machine must therefore be carried out by authorised personnel only.
- If you hear unusual noises, or notice anything strange, stop the machine immediately. After performing a check and, if applicable, the necessary repairs.

1. The supply voltage must correspond to that stated on the plate and in the technical specifications (230 V / 50 Hz). **Do not use any other type of power supply.**
2. The use of a life-saving device on the electric power supply for a nominal trip range of 10 to 30 mA is recommended. For detailed information, contact your electrician.
3. The mains socket must be double pole switched and grounded (10 / 16 A, 250 V), any extension cords must have the same or greater cross sections than those of the machine's power cord.
4. Ensure that the power cord does not come into contact with hot objects, surfaces that are wet, oily and/or have sharp edges.
5. The power cable must be checked regularly and before each use to check for signs of damage or wear. If not in a good condition, do not use the machine, and replace the cable.
6. Do not use the power cord to lift the machine or to remove the plug from the socket.

2.3 Technical support

For any problem or request for clarification, please do not hesitate to contact the Support Service of the dealer where the machine was purchased, with its competent and specialised staff, specific equipment and original spare parts.

2.4 Other provisions

The first thing to do when starting work is to check the presence and integrity of the guards and the operation of the safety devices.

If any defect is encountered do not use the Bench chamfering machine!!

It is absolutely forbidden, therefore, to modify or remove guards, safety devices, informative labels and plates.



3 TECHNICAL SPECIFICATIONS

	Model	Art. 0560
Technical data	Power (W)	250
	Voltage (V)	230
	Frequency (Hz)	50
	Rotation speed (rpm)	2,800
	Mill size (mm)	80
	Chamfering capacity 45° (mm)	5
	Weight (kg)	25
	Chamfer angle	45°
	Material input angle	90°
	Guide width (mm)	50
	Guide length (mm)	400
	Noise level (dB)	65
Motor data	Type	Single-phase, asynchronous
	Class	B
	Degree of protection	IP 44

4 DESCRIPTION OF THE MACHINE

The Bench chamfering machine is very simple to use and has been designed to chamfer the rough edges of metal parts and components. In particular, it is used to chamfer rough edges at 90°.

The characteristics that distinguish the Bench chamfering machine are the speed and ease of use.

The machine consists of a metal base, a guide on which to slide the piece and an electric motor on which is mounted an insertable milling cutter.

The guide is provided with two steel sliding planes, which are perpendicular to each other and inclined at 45° with respect to the vertical plane.

The milling cutter is almost entirely covered by the guide itself, which therefore acts as a protective guard.

The machine is able to perform a maximum chamfer of 5 mm.

The start and stop are controlled with two buttons located on the upper part of the electrical panel.

In the part of the machine opposite the working section, there is a drawer for the collection of filings that build up during the processing of the workpieces.



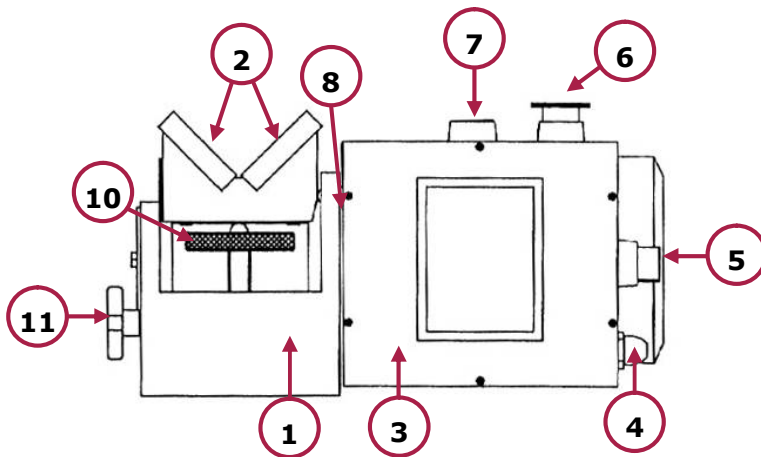
Moving parts

A part of the cutter used to perform the work is not protected.

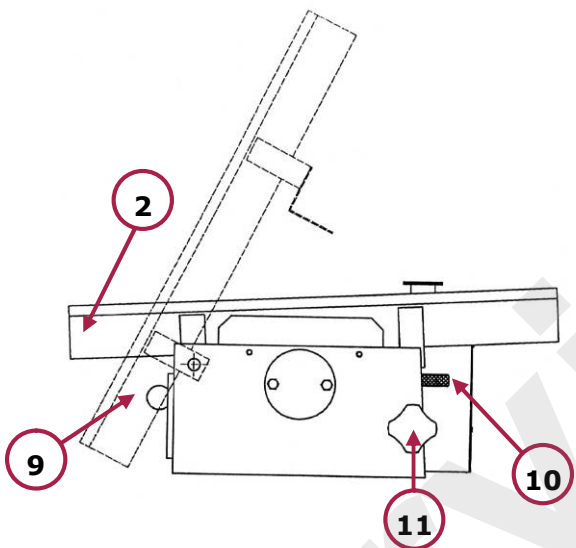
Therefore, appropriate PPE, such as goggles and gloves, must ALWAYS be used.



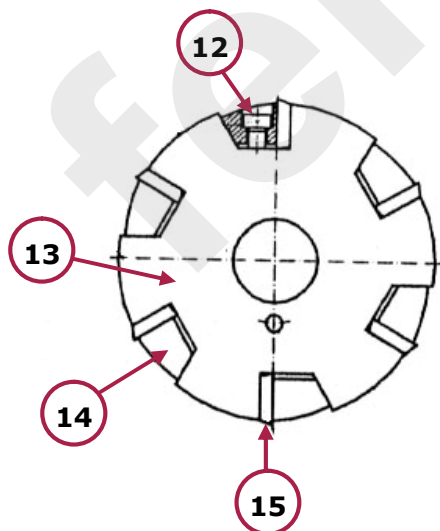
4.1 Description of the main parts



Side view (piece input side).



Side view (piece guide side).



Tool detail

Group of diagrams 1 - Main parts of the bench chamfering machine.



0560/01	Machine body	0560/06	Emergency stop	0560/11	Locking knob
0560/02	Guide rail	0560/07	Power switch	0560/12	Insert locking screw
0560/03	Electrical panel	0560/08	Locking micro-switch	0560/13	Milling cutter
0560/04	Power cord	0560/09	Drawer knob	0560/14	Wedge
0560/05	Main switch	0560/10	Chamfer adjustment screw	0560/15	Cutting insert

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4.2 Plates

The left side of the machine (guide rail side) features the following identification plate (Figure 2).

<p>Fervi s.r.l. Via del Commercio 81 - 41058 Vignola MO Smussatrice da banco</p>		Potenza <input type="text" value="250"/> W Tensione <input type="text" value="230"/> V Frequenza <input type="text" value="50"/> Hz Giri al minuto <input type="text" value="2800"/> g/m ¹ Diametro fresa <input type="text" value="80"/> mm Capacità di smussatura a 45° <input type="text" value="5 mm"/> Peso <input type="text" value="25 Kg"/>	<p>Made in PRC</p>
Art.	<input type="text" value="0560"/>	Modello	<input type="text" value="DM5-N"/>
Lotto	<input type="text"/>	Anno	<input type="text" value="2012"/>

Figure 2 – Identification plate.

4.3 Pictograms

The machine has the following signalling, warning, and prohibition pictograms (Diagram 3).

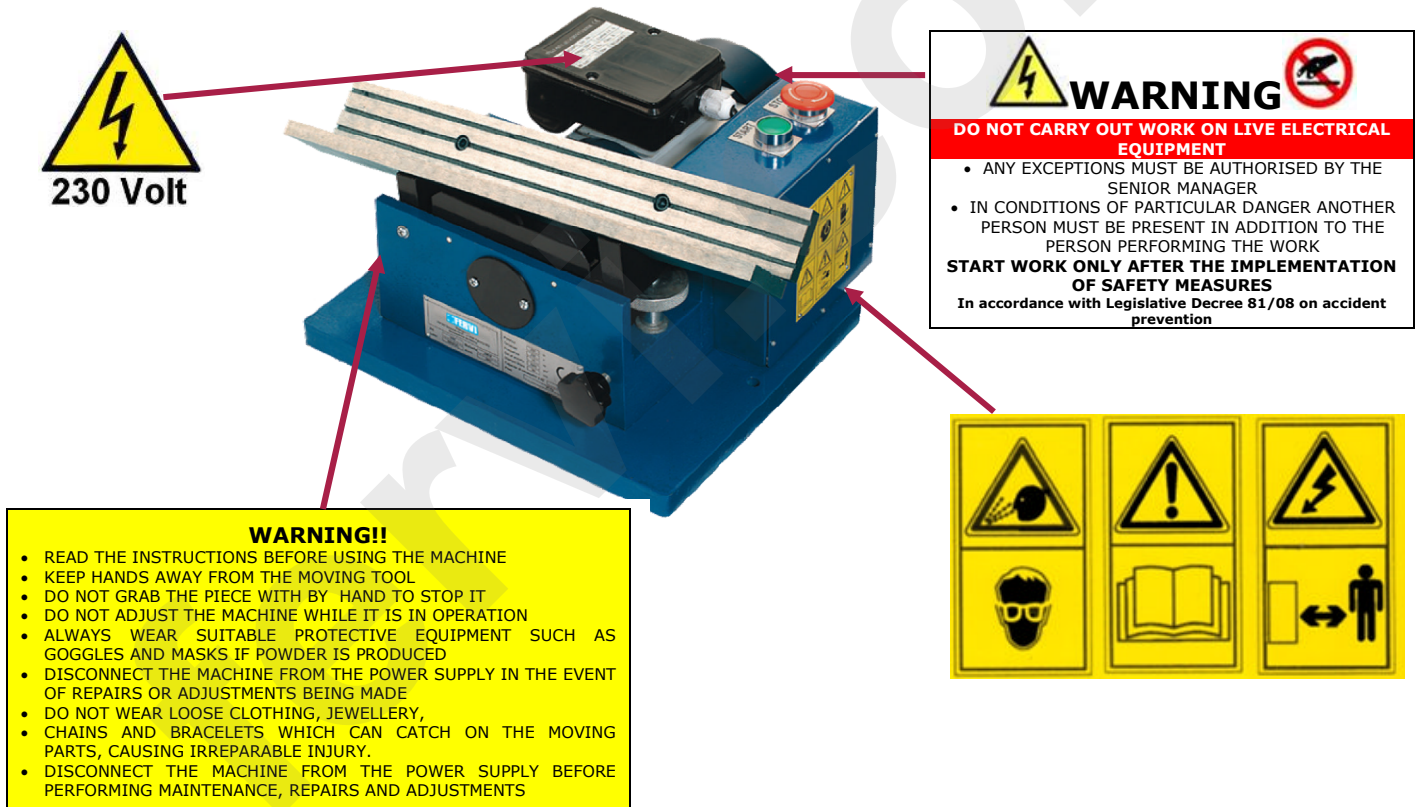


Figure 3 – Signalling, warning, and prohibition pictograms.

Caption

PLATE IN ITALIAN

PLATE IN ENGLISH




ATTENZIONE

È VIETATO ESEGUIRE LAVORI SU APPARECCHIATURE ELETTRICHE SOTTO TENSIONE

- EVENTUALI DEROGHE DEVONO ESSERE AUTORIZZATE DAL CAPO RESPONSABILE
- IN CONDIZIONI DI PARTICOLARE PERICOLO DEVE ESSERE PRESENTE UN'ALTRA PERSONA OLTRE A CHI ESEGUE IL LAVORO

INIZIARE I LAVORI SOLO AD AVVENUTA ATTUAZIONE DELLE MISURE DI SICUREZZA
In ottemperanza al Dgs.81/08 relativo alla prevenzioni infortuni

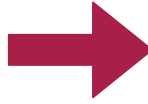


WARNING

DO NOT CARRY OUT WORK ON LIVE ELECTRICAL EQUIPMENT

- ANY EXCEPTIONS MUST BE AUTHORISED BY THE SENIOR MANAGER
- IN CONDITIONS OF PARTICULAR DANGER ANOTHER PERSON MUST BE PRESENT IN ADDITION TO THE PERSON PERFORMING THE WORK

START WORK ONLY AFTER THE IMPLEMENTATION OF SAFETY MEASURES
In accordance with Legislative Decree 81/08 on accident prevention

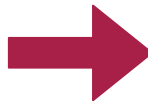


ATTENZIONE!!

- LEGGERE LE ISTRUZIONI PRIMA DI UTILIZZARE LA MACCHINA
- NON AVVICINARE LE MANI ALL'UTENSILE IN MOVIMENTO
- NON AFFERRARE IL PEZZO CON LE MANI PER ARRESTARLO
- NON REGOLARE LA MACCHINA MENTRE È IN FUNZIONE
- INDOSSARE SEMPRE IDONEE PROTEZIONI QUALI OCCHIALI E MASCHERINE QUALORA VENFA PRODOTTA POLVERE
- SCOLLEGARE LA MACCHINA DALL'ALIMENTAZIONE ELETTRICA IN CASO DI RIPARAZIONI O REGOLAZIONI
- NON INDOSSARE INDUMENTI SVOLAZZANTI, GIOIELLI, CATENINE E BRACCIALI CHE POSSONO AGGANCIARSI ALLA MACCHINA E CAUSARE DANNI IRREPARABILI
- SCOLLEGARE LA MACCHINA DALL'ALIMENTAZIONE ELETTRICA PRIMA DI ESEGUIRE MANUTENZIONE, REGOLAZIONI E RIPARAZIONI

WARNING!!

- READ THE INSTRUCTIONS BEFORE USING THE MACHINE
- KEEP HANDS AWAY FROM THE MOVING TOOL
- DO NOT GRAB THE PIECE BY HAND TO STOP IT
- DO NOT ADJUST THE MACHINE WHILE IT IS IN OPERATION
- ALWAYS WEAR SUITABLE PROTECTIVE EQUIPMENT SUCH AS GOGGLES AND MASKS IF POWDER IS PRODUCED
- DISCONNECT THE MACHINE FROM THE POWER SUPPLY IN THE EVENT OF REPAIRS OR ADJUSTMENTS BEING MADE
- DO NOT WEAR LOOSE CLOTHING, JEWELLERY,
- CHAINS AND BRACELETS WHICH CAN CATCH ON THE MOVING PARTS, CAUSING IRREPARABLE INJURY.
- DISCONNECT THE MACHINE FROM THE POWER SUPPLY BEFORE PERFORMING MAINTENANCE, REPAIRS AND ADJUSTMENTS





5 INSTALLATION OF THE MACHINE

The Bench chamfering machine is delivered fully assembled.

For full grip to the supporting surface and the stability of the machine during its use, there are certain precautions to take into account for installation, therefore proceed as follows:



Cleaning the machine

Before installing the chamfering machine, remove the protective product from the components.



Cleaning the work bench

Before placing the chamfering machine on the supporting surface, clean the bench of dirt and any objects that may be present.



Loss of stability

Place the Chamfering bench on a supporting surface that is:

- clean;
- solid and strong (to avoid it falling over and causing vibration);
- level (not tilted).

When using a steel bench, it is advisable to place a material able to reduce vibration (e.g. rubber) between the Chamfering machine and the supporting surface.



Installation of the machine

Do not install the machine outdoors to avoid deformation, loss of functionality and damage to the electrical control circuit.

5.1 Connection of the electric power supply plug and start test

1. Insert the power supply plug into a grounded double pole socket (10/16 A, 250 V).
2. Turn the main switch (see Figure 4) to position I.
3. Start the machine, by pressing the green start switch (see Figure 5) and make sure that the direction of rotation of the tool is in accordance with that indicated by the arrow affixed to the protective casing of the motor.
4. Before starting to chamfer, check the attachment and stability of the tool:
 - by making it spin freely for at least 5 minutes at a peripheral working speed;
 - with the protection devices closed and without the presence of personnel.



Collision of flying parts

During the test run, no operator or any other person should be in the operating range of the machine.

6 MAIN SWITCH AND CONTROL SWITCH

6.1 Main switch

The main switch is on the right side of the machine (motor side). The machine is powered with this button.

The switch can be positioned to "0" (no power to the machine), or "I" (machine powered, see Figure 4).



Figure 4 – Main switch.

6.2 Start switch

The green "START" button (ref. B in Figure 5) located on the control panel is used for starting (switching on) the Chamfering machine.

By pressing this button, the electric motor is powered and the tool (milling cutter) is put into rotation.

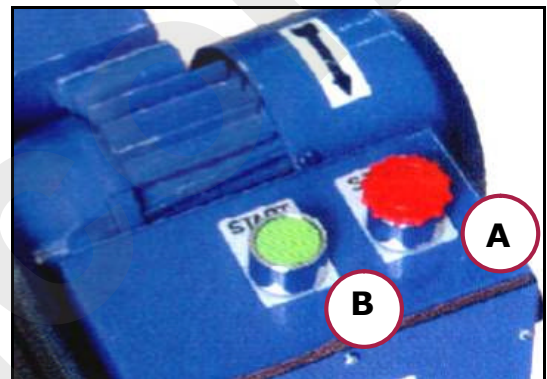


Figure 5 – Control switches

6.3 Stop switch

The red "STOP" button (ref. A in Figure 5) is used for shutting down the Bench chamfering machine, both under normal conditions of use, and in cases of emergency.

By pressing this button, power to the electric motor is switched off and the tool stops rotating.

NOTE: Due to the working area of the operator and the reduced overall dimensions of the machine, the stop switch also acts as the switch for emergency shut-down.



7 OPERATION

7.1 Precautions for use

The Bench chamfering machine is very simple to use, but always requires due attention by the operator.



Use of the machine

The Bench chamfering machine must only be used with tools that are suitable for the type of material to be processed.



Risk of abrasion and accident

- Before using the machine, ensure that it is stable on the work bench to prevent unwanted shifting or loss of stability.
- Wear appropriate personal protective equipment (PPE) such as gloves, goggles, overalls or aprons and safety shoes.

It is not recommended to extend the continued use of the machine for more than 10 minutes to avoid overheating of the machine (which could damage the motor) and the tool.

NOTE: The Bench chamfering machine can not operate in environments with potentially explosive atmospheres. It is therefore the responsibility of the operator to avoid using the Chamfering machine in an environment with flammable and/or explosive vapours.



Danger of explosion

The Bench chamfering machine has NOT been designed to operate in environments with a potentially explosive atmosphere.

7.2 Before using the Bench chamfering machine

For safe operation of the machine it is advisable to perform some checks:

1. check that the power cord does not have any flaws or damage;
2. verify the correct operation of the stop/emergency switch;
3. verify the correct operation of the machine.

7.3 Use of the Bench chamfering machine



Use of the machine

Use the machine for chamfering rough metal edges at 45°.
Use the machine for a maximum chamfer of 5 mm.

1. Press the green start button (ref. B in Figure 5).
2. Place the piece to be chamfered on the guide rail and push it towards the milling cutter without pressing excessively.



Risk of abrasion and accident

Hold the piece at the upper and rear part. DO NOT place fingers under the work piece for any reason!
NEVER grab the work piece with bare hands, it has a high temperature and sharp burrs.
Always wear appropriate personal protective equipment (PPE) such as gloves, to avoid injury.



Thin or small pieces

When working with very thin or small pieces, a special tool must be used to push the piece and hold it in place on the rail.

3. When finished, turn off the machine by pressing the red stop button (ref. A in Figure 5).



Risk of abrasion

- After pressing the stop switch, the milling cutter continues to rotate by inertia for a few seconds.
- Keep body parts away from the moving tool!

When a certain degree of roughness of the chamfer is detected at the end of processing, it is advisable to carry out more applications. Light chamfering is recommended for thin and narrow materials.



7.4 Adjusting the Bench chamfering machine

To set the desired depth of chamfer, the adjusting screw (ref. 10 in figure 6) should be operated as follows:

1. unlock the adjustment screw by unscrewing the locking knob (ref. 11 in figure 6);
2. rotate the adjustment screw (ref. 10), until the inserts of the milling cutter touch the workpiece;
3. turn the screw until it reaches the desired depth (each turn corresponds to approximately 0.5 mm);
4. once the depth of the chamfer has been determined, lock the locking knob (ref. 11).

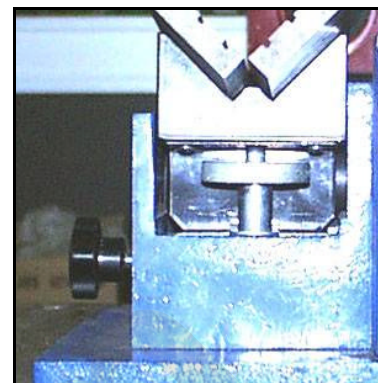


Figure 6 – Adjustment commands



Adjustment of the Chamfering machine

Any adjustments must be performed with the machine stopped and NOT powered.

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8 MACHINE SAFETY DEVICES

8.1 Electrical safety devices

The control switches inserted in the electrical circuit of the Bench chamfering machine are **magnetic** (see Chapter 6 of this manual). They guarantee against the danger the machine starting accidentally and/or when not desired since it can only be switched on by a voluntary action designed for the purpose and when the machine is receiving power.

Furthermore, the start button is equipped with a protective collar.

In the event of malfunction or breakdown, the Bench chamfering machine is equipped with a power cord and plug with a **grounding conductor** that provides a path of least resistance for the electric current by reducing the danger of electrocution.

The plug must be inserted into a suitable socket, grounded in accordance with regulations in force. Any extension cords must have the same or greater cross sections than those of the machine's power cord.



Electric shock

Improper connection of the grounding conductor of the machine can create the risk of electric shock.

The use of a **life saving device** on the electric power supply for a nominal trip range of 10 to 30 mA is recommended. For detailed information, contact your electrician.

If you do not understand the instructions for grounding or if you are not sure the machine is grounded properly, perform a check together with a qualified electrician.



8.2 "Mechanical" safety devices

8.2.1 Interlocking of the guide rails

The interlocking device (micro-switch) of the guide rail is designed to disconnect the supply to the electrical circuit when the guide is turned over to allow repairs or maintenance to be performed on the machine.



Checking Safety devices

- Each time the Bench chamfering machine is used, check the perfect functioning and positioning of the safety devices.
- Do not use the machine in the case of damage and/or breakage.



Use of PPE

In any event, ALWAYS use appropriate personal protective equipment (PPE) such as:

- Gloves;
- Goggles or face shields;
- Overalls or apron;
- Safety shoes.



PROTECTIVE
GLOVES



PROTECT YOUR
EYES



PROTECTIVE
SCREEN



PROTECTIVE
CLOTHING



PROTECTIVE
FOOTWEAR

9 MAINTENANCE

9.1 Routine maintenance



Electric shock

Before any inspection or maintenance, turn off the machine and ALWAYS remove the plug from the power socket. This is to prevent the risk of electric shock.

Clean and take care of the machine regularly to ensure perfect efficiency and a long lifespan.

Using a compressor, regularly blow away the powder and processing residue produced by chamfering that accumulates on the machine.



Working with compressed air

ALWAYS wear eye protection when using compressed air.

To clean the machine body and other external parts, use a cloth dampened with warm water only.

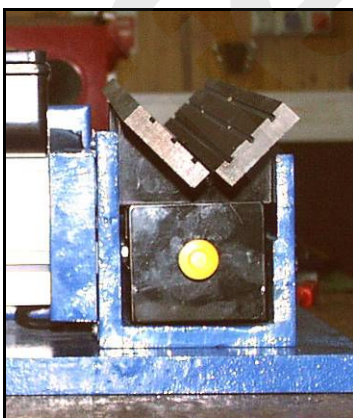


Cleaning the machine

DO NOT use detergents or any solvents as plastic parts are easily damaged by chemical agents.

Take care when emptying the filing collection drawer (see Figure 7) as after pulling the drawer out completely, the milling cutter can be reached through the opening where the drawer is inserted.

When emptying the drawer pay attention to the warning pictogram (Figure 11).



DO NOT PERFORM ANY INTERVENTION ON THE MACHINE BY HAND WHEN THE MACHINE IS RUNNING

Figure 7 – Filing collection drawer.

Furthermore, **every 6 months of life** of the machine, perform a thorough check of operation and wear; lubricate the rotating tool holder shaft with oil.



9.2 Replacement of cutting inserts

Periodically check the state of wear of the cutting inserts of the milling cutter and, if necessary, replace them.



Electric shock

Before replacing the inserts, turn off the machine and ALWAYS remove the plug from the power socket.



Characteristics of the inserts

Only use inserts with sizes and characteristics that correspond to those provided by the manufacturer.

To perform the replacement of the cutting inserts it is necessary to turn over the guide rail (ref. 2 in Figure 12), and perform the following steps:

1. unscrew the inserts locking screw (ref. 12);
2. extract the cutting insert (ref. 15);
3. replace it with the new insert;
4. position the locking wedge (ref. 14) and tighten the locking screw again (ref. 12).

Continue in this way for all the cutting inserts to be replaced.

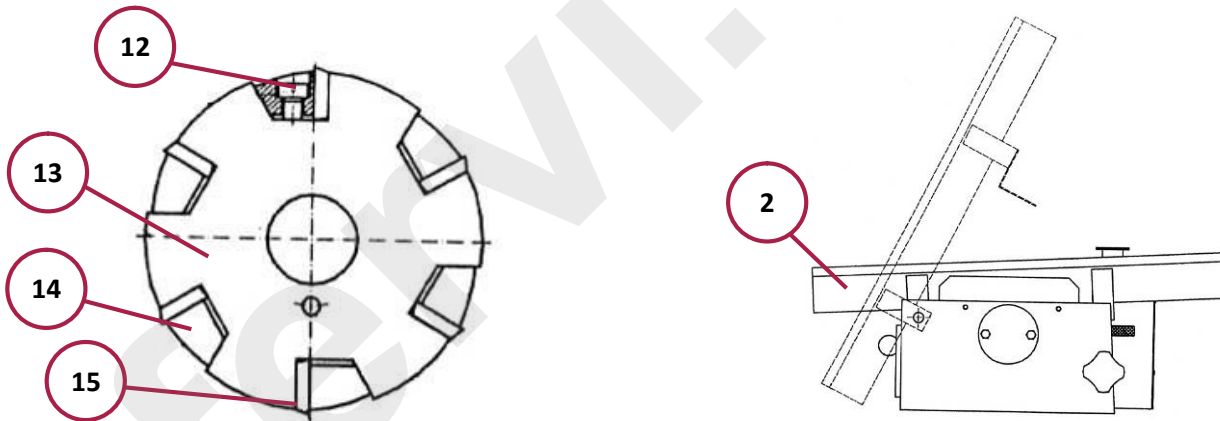


Figure 8 – Replacement of cutting inserts.

10 DISPOSAL OF COMPONENTS AND MATERIALS

If the machine is to be scrapped, its parts must be disposed of separately.

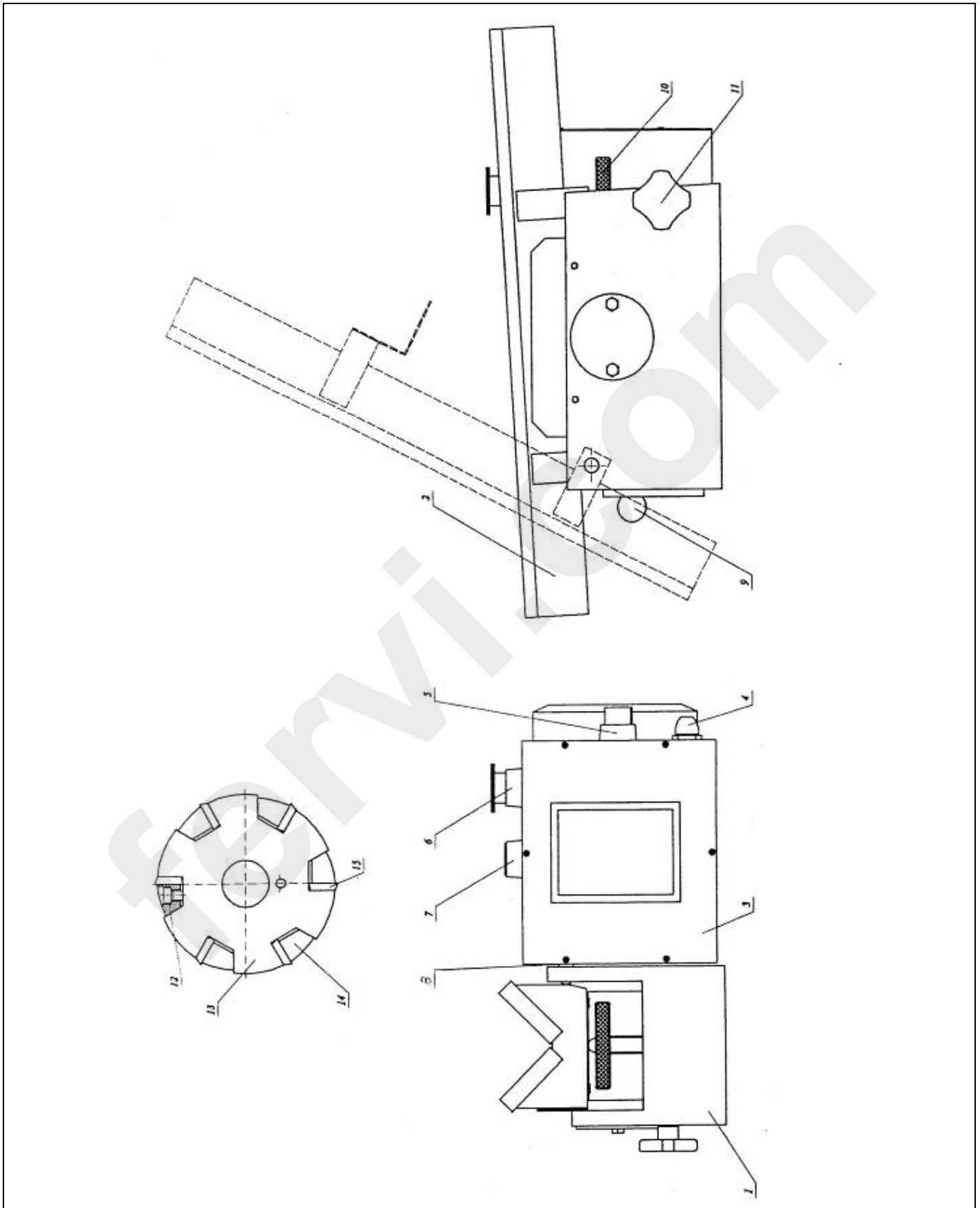


Respect the environment!

Contact a specialist centre for the collection of metallic materials.

In this regard, divide the materials according to their nature, employing specialist companies which are authorised for their disposal, in accordance with the requirements of law.

11 EXPLODED VIEW AND SPARE PARTS





PART NUMBER	DESCRIPTION
0560/01	MACHINE BODY
0560/02	GUIDES
0560/03	CONTROL BOX
0560/04	POWER CORD
0560/05	POWER SWITCH
0560/06	EMERGENCY
0560/07	START SWITCH
0560/08	START MICRO-SWITCH
0560/09	CHIPS COLLECTION TRAY
0560/10	CHAMFER ADJUSTMENT SCREW
0560/11	ADJUSTMENT LOCKING KNOB
0560/12	INSERTS LOCKING SCREW
0560/13	MILLING CUTTER
0560/14	WEDGE
0560/15	INSERT

12 DIAGRAM OF THE ELECTRICAL CIRCUIT

