

## Manual Tooling Machine

### Delevery includes:

- 1 manual Tooling equipment
- 1 manual Machine GSR I GSB Professional
- 1 manual Battery charger AL1820 CV Professional
- 1 Tooling Machine with assembled tooling equipment
- 1 battery charger incl. 2 batteries
- 1 upper wheel (conical wheel for galvanized steel nr1)
- 1 upper wheel (conical wheel for Stainless Steel nr2)
- 2 lower wheels
- 1 guide plate
- 1 pipe wrench 19 mm

### Purpose Tooling Machine

The Tooling Machine is suitable for the seaming of Stainless Steel (thickness max. 1,0 mm) and galvanized steel (thickness max. 1,25 mm) piping and for all diameters.

**ATTENTION:** The machine is not suitable for the seaming of thicker material as mentioned above. When the machine breaks down due to incorrect use, the warranty expires.

### Commissioning the machine

1. Read the manuals attentively and maintain the safety and the operating instructions at all times.
2. Check the machine for any damage. Should this be the case, immediately inform your supplier.
3. Place the lower wheel on the non adjustable spindle. (photo 1)  
(with thicker plates, put the extra ring -to fill space-)
4. Place the guide plate till approx. 2 mm over the non conical wheel. (photo 2)
5. Place the upper wheel (photo 3 – pay attention for galvanized steel or Stainless Steel)



Photo 1



Photo 2



Photo 3

### Filtration and air handling components

### The making of an edge on a pipe

1. Make sure the pipe is the correct length and trim the edges (burr).
2. Put the tooling machine on the lowest speed and the direction of rotation of the upper wheel to the right.
3. Put the tooling machine on the pipe and turn the adjustable wheel against the pipe.
4. After every turn, tighten the upper wheel so it keeps pressing to the pipe with a little preload, until there is a complete edge generated.



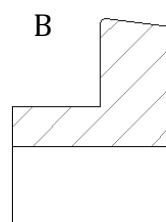
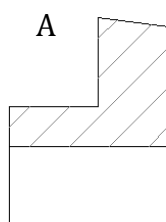
### List of break-downs

Problem	Possible cause	Solution
Machine runs of the pipe	Distance between guide plate and lower wheel is to small	Enlarge the distance between guide plate and lower wheel
	Upper wheel is worn out or the upper wheel for galva material is used (on Stainless Steel plate)	Replace the upper wheel
Edge is to wide	Distance between guide plate and lower wheel is to big	Decrease the distance between guide plate and lower wheel
Edge is to small	Distance between guide plate and lower wheel is to small	Enlarge the distance between guide plate and lower wheel

### List of wear and spare parts

Description	Order number
Lower wheel	ZFHBKM18V01
Set rolls #1 for Stainless Steel	ZFHBKM18V02
Set rolls #2 for galvanized steel	ZFHBKM18V03
Guide plate	ZFHBKM18V04
Tooling machine complete	ZFHBKM18V

### Difference between Stainless Steel wheel and steel wheel



Edge A is for the Stainless Steel wheel (= sharp)

Edge B is for the steel wheel (= rounded)

### Filtration and air handling components