

# ***INSTRUCTION MANUAL***

READ ALL INSTRUCTIONS BEFORE OPERATING THIS TOOL

**HAND BEVELER Model HB-15B**

PROFESSIONAL TOOL

## **HB-15B**

### **Specifications**

<b>Power Source (Single Phase)</b>	<b>AC110V-120V 60Hz</b>	<b>AC 220V-240V 50Hz</b>
Rated Power Consumption	910W	
Rated Ampare	10.5A	4.0A
Rated Time	Continuous	
No Load Speed	3,340 r.p.m.	2,750 r.p.m.
Chamfering Capacity	0 ~ 15 C	
Chamfering Angle	15° ~ 45°	
Weight	14 kg	
Cabtyre Cord	5 m	
The Noise Level at user's position	64dB(A)	
The Noise Performance Level	66dB(A)	
Vibration Level	0.7m/sec <sup>2</sup>	

These specifications and the profile may be changed for improvement without prior notice.



Manufactured by:

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**SAVE THESE INSTRUCTIONS**

Thank you for purchasing **Nitto Kohki** product.

Before using this tool, please read this manual carefully to ensure proper, efficient operation.

**This instruction manual should be kept close at hand.**

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## PICTOGRAM



Warning: It might be dangerous to operate the power tool if the instructions supplied are not followed.



Before operating the tool, read and understand all instructions supplied. Keep it for future reference.



Personal protective equipment as eye and ear protection and protective gloves must always be used when operating the tool.

## **WARNING**

### **IMPORTANT SAFETY INSTRUCTIONS FOR ALL ELECTRIC TOOLS**

When using electric tools, basic safety precautions should always be followed to reduce risk of fire, electric shock, personal injury and the like, including the following.

**(1) Keep work area clean.** Cluttered work areas and benches invite accidents and injuries.

**(2) Consider work area environment.** Do not expose tools to rain. Do not use tools in damp or wet locations. Keep work area well lit. Do not operate near flammable liquids or in gaseous or explosive atmospheres.

**(3) Be cautious about electric shock.** When using electric tools, do not touch any which is earthed. (Ex. Pipe, heating apparatus, microwave oven, outside frame of refrigerator)

**(4) Keep children away.** Also all visitors should be kept away from work area. Do not let visitors contact the tool, compressor or connecting hoses.

**(5) Store idle tools.** When not in use, tools should be stored in dry, and locked-up places out of reach of children.

**(6) Do not force tool.** It will do the job better and safer at the rate for which it was designed.

**(7) Use right tool.** Do not force a small tool of attachment to do the job of a heavy-duty tool. Do not use tool for a purpose not intended.

**(8) Dress properly.** Do not wear loose clothing or jewelry. They can be caught in moving parts. Non-skid footwear is recommended. Wear protective hair covering to contain long hair.

**(9) Always wear eye protection.** Everyday eyeglasses only have impact resistant lenses. They do NOT protect eyes. Also use face or dust mask, if operations create dust.

**(10) Do not abuse cable.** Never carry tool by connecting cable or yank on hose to disconnect. Do not place a cable near a place with high heat oil, sharp edge.

**(11) Secure work.** Use clamps or a vise to hold work when practical. It is safer than using your hand and it frees both hands to operate tool.

**(12) Do not overreach.** Keep proper footing and balance at all times.

**(13) Cautions maintenance is necessary for electric tools.**

· Always maintain blades and keep it to work well so that safe and efficient work can be done.

· Follow the instruction manual for oiling or change of accessories.

· Check the cable regularly. Contact the sale agents to repair it when it is defective.

· When an extension cable is used, check regularly and change it when it is damaged.

· The grip should be kept dry and clean. Maintain it so well that it does not carry oil or grease.

**(14) Switch off and take off the plug for the following:**

· No use

· When you change blades, grinding stone and bit

· Any danger is anticipated.

**(15) Make sure that spanners, wrenches etc which are used for adjustment are removed before switching on.**

**(16) Always avoid unexpected start.**

· Do not carry the tool with a finger on the switch when the power supply is on.

· Make sure that the switch is off before plugging in.

**(17) Use a cabtire cable or a cabtire extension cable when it is used outside.**

**(18) Stay alert.**

Watch what you are doing. Bear in mind the way of handling/operation and the circumstances of the surrounding area.

Use common sense.

Do not operate tool when you are tired.

**(19) Check damaged parts.**

· Before further use of the tool, an accessory or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended functions.

· Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. An accessory or other part that is damaged or inoperable should be properly repaired or replaced. When a switch becomes out of order, repairs should be performed only by the sales agent from whom you purchased the tool.

· Do not use electric tools which cannot be activated or stopped with a switch.

**(20) Use recommended accessories.**

Consult this manual or the sales agent from whom you purchased the tool or our company for recommended accessories. The use of improper accessories may cause risk of injury to persons.

**(21) Repairs by authorized personnel.**

· This tool should not be modified as it meets safety requirements.

· Any repairs to the tool or installation of replacement parts should be performed only by the sales agent from whom you purchased the tool or our company. Use only genuine replacement parts.

· Failure to utilize the expertise of an authorized sales agent from whom you purchased the tool or our company or, failure to use genuine replacement parts, may result in an increased risk of injury to the user and may invalidate your warranty.

Do not use electric tools which cannot be activated or stopped with a switch.

**(22) If the supply cord is damaged, it shall be replaced by the manufacturer or its service agent in order to avoid a hazard.**

## 1 USAGE

This is a hand held electric tool for chamfering of mild steel(SS400)with throw away tips.

## 2 CHECK THE CONTENTS OF THE PACKAGE

Check the contents and make sure that the tool does not have any damage due to an accident during the transportation, if any. The contents should correspond to the list as follows. Just in case there are some damages or missing parts, contact the sales agent from whom you purchased the tool or an authorized dealer.

### THE CONTENTS OF THE PACKAGE AND ACCESSORIES

Package Contents	Part No.	Q'ty	check
HAND BEVELER	TB02266	1	
TIP 12.7 A'SSY (12PCS)	TA9A093	1	
ROLLER BRACKET	TA99834	1	
HEX. WRENCH 4	TP01939	1	
HEX. WRENCH 5	TP04004	1	
HEX. WRENCH 6	TP00170	1	
WRENCH 24X27	TP04309	1	
HOOK WRENCH 25X28	TP16410	1	
T SHAPE WRENCH 3	TP16613	1	
SPACER A	TP16600	1	
SPACER B	TP16601	1	
PLATE B	TQ00206	1	
INSTRUCTION MANUAL	TQ02984	1	

## 3 Caution for Use

### ⚠ WARNING

1) Check to see that the earth leakage breaker is installed. Even when using power supply in which the earth leakage breaker is set, it should be used after grounding for the purpose of more safety.

2) Use of power is limited to the power specified by the rating plate.

3) Note that power cord which is too long may cause a voltage drop. Do not use another electric tool together.

Extension Cable	
max. Length	Sectional Area
10 m	1.25 mm <sup>2</sup> Over
15 m	2 mm <sup>2</sup> Over
30 m	3.5 mm <sup>2</sup> Over

4) Do not remove a rating plate. Please contact sales agents for replacement if they are taken off or damaged.

## 4 PREPARATION

### ⚠ WARNING

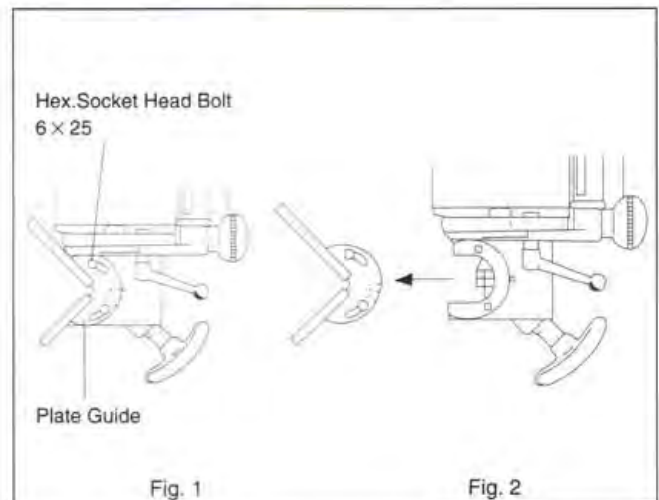
When the preparation is made, switch off and take off the plug.

#### 4-1 How to Replace Tip

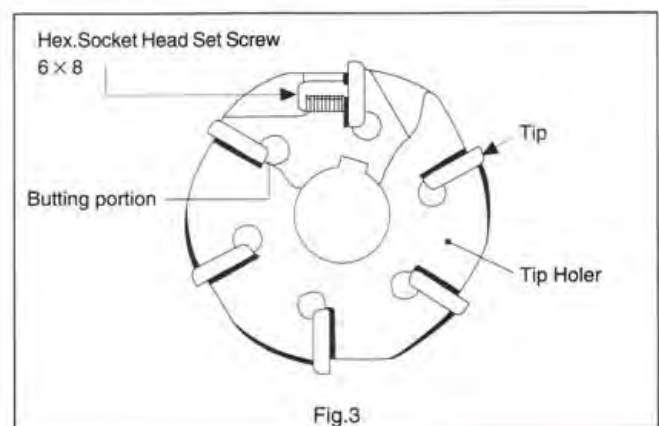
### ⚠ WARNING

Be aware that right after the operation a tip and tip holder become so hot.

1. Remove Hex. Socket Head Bolt (Fig. 1) and pull it out to the direction as shown of the arrow. (Fig. 2)

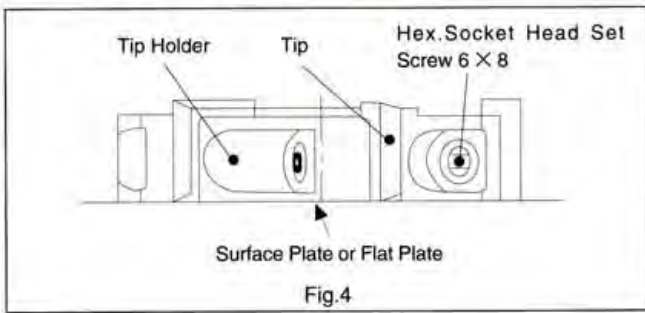


2. Loosen Hex. Socket Head set Screw with a wrench. Take out a tip.

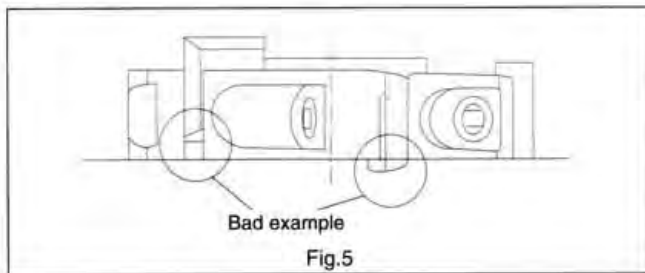


3. Remove chips. Insert Tips into Tip Holder, paying attention to the shape of Tips.

Fix Tips with Hex.Socket Head Set Screw 6 x 8. (Fig. 4)

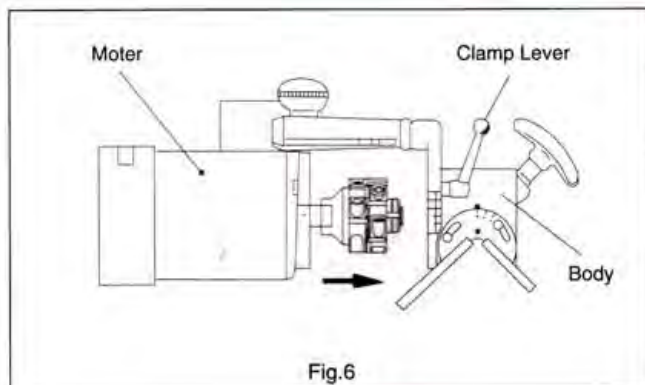


Recognize that the downward edges of Tips are exact on the flat surface of Tip Holder. Bad alignment may cause breakage of Tips. (Fig. 5)



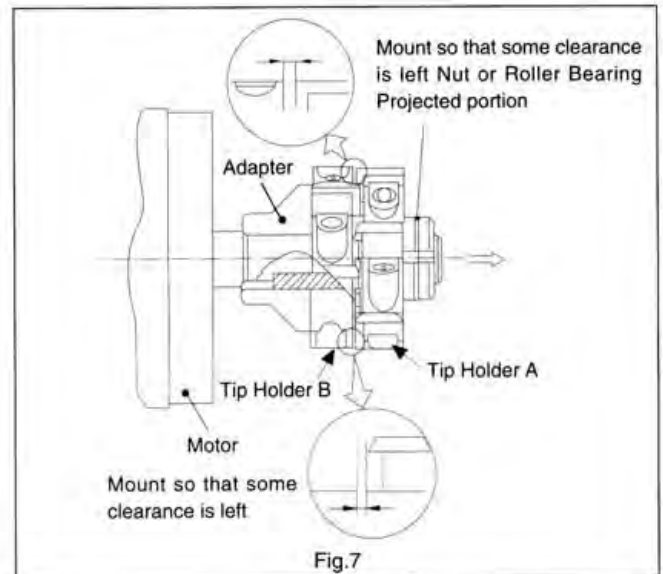
#### 4-2 How to Replace Tip Holder

(1) Separate the Motor Unit from the body as shown in Fig. 6. (Remove the Clamp Lever and then remove Hex. Socket Head Bolt 8 x 30 on the back side for this purpose.)



(2) Remove the Nut for Roller Bearing shown in Fig. 7 using the spanner and hook spanner included in the accessories, and then extract Tip Holders A and B in the direction of the arrow.

(3) Mount Tip Holders A and B in the proper direction (so that projected portions of Tip Holders A and B face each other), and then firmly tighten the Nut for Roller Bearing using a Hook Spanner. (Fig. 7)



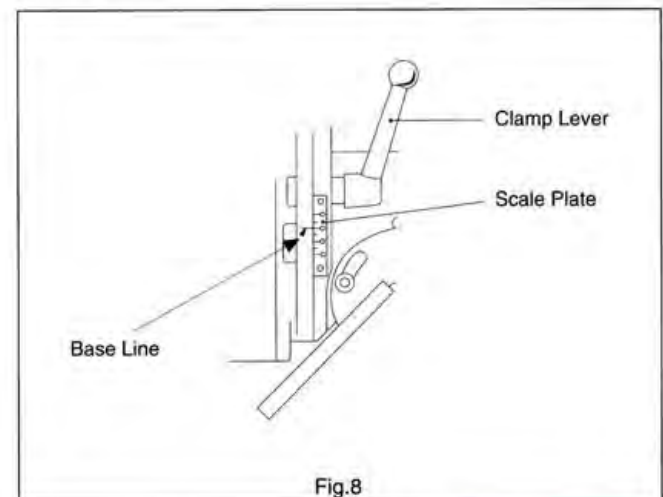
#### 4-3 Adjustment of chamfering width.

1. Loosen the clamp Lever (Fig. 8) Move the clamp Lever to a convenient position when a spline is used. Move it to a place where it will not obstruct work after use.

2. Move the base line to the desired location on the Scale Plate by operating the grip so that the specified chamfering width is obtained.

3. Perform firm locking by the clamp Lever on completion of adjustment, and turn the clamp Lever to a position where the operation is not obstructed.

\* The Clamp lever has been fixed at an arbitrary position when turned and lifted.



4. Suggestion for performing major chamfering. Carry out chamfering gradually with repeated actions rather than attempting to chamfer every thing at one time. This reduces the labor required as well as tip wear.

Chamfering	Work criteria
7C	7C 1 time
10C	7C → 10C 2 times in total
15C	7C → 10C → 12C → 15C 4 times in total

Table 1

#### 4-4 Process to adjust chamfering angle

1) loosen Hex. Socket Head Bolt 6 × 25 on plate Guides located on both sides of the body. (Fig. 9)

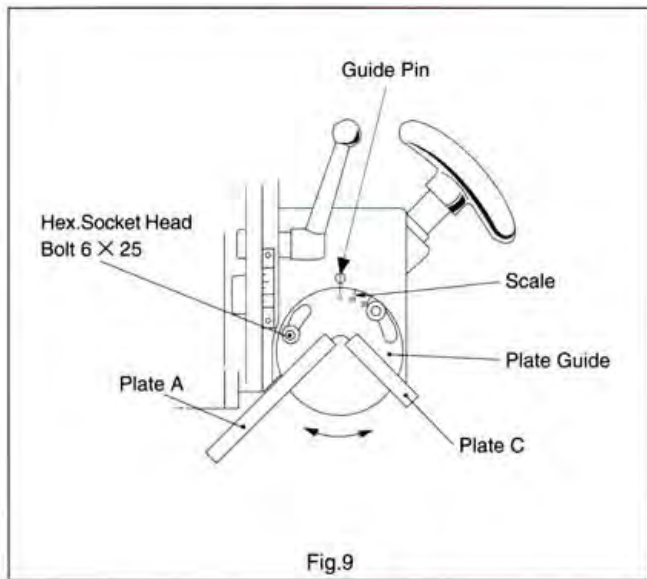


Fig.9

2) Hold the plates and set the scale of the Plate Guide at the desired angle (pointed at by the guide pin).

3) Fix the Plate Guide in position by tightening the Hex. socket head Bolt 6 x 25.

\* The applicable limit in chamfering width varies with the chamfering angle.

use Fig. 10 and table1 as references.

Chamfering Angle	A	B	C
45°	15	15	21
30°	9	15.5	18
15°	4	15.4	16

Table 1

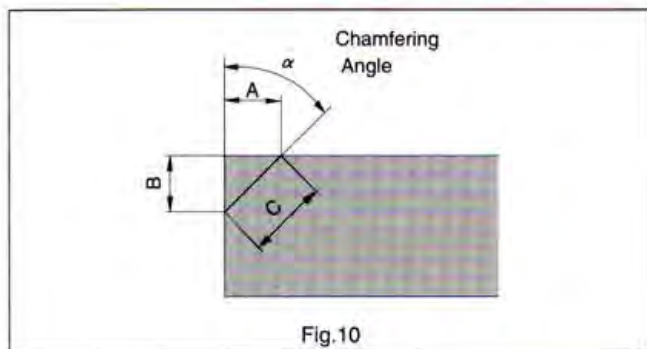


Fig.10

#### 4-5 Use of Spacers A and B Included in the Accessories

When Spacers A and B of the accessories are mounted as shown in Fig. 11, chamfering 7C or less can be performed using six "12.7 square tips".

\* If the setting is made in this manner, it is not possible to perform chamfering of more than 7C.

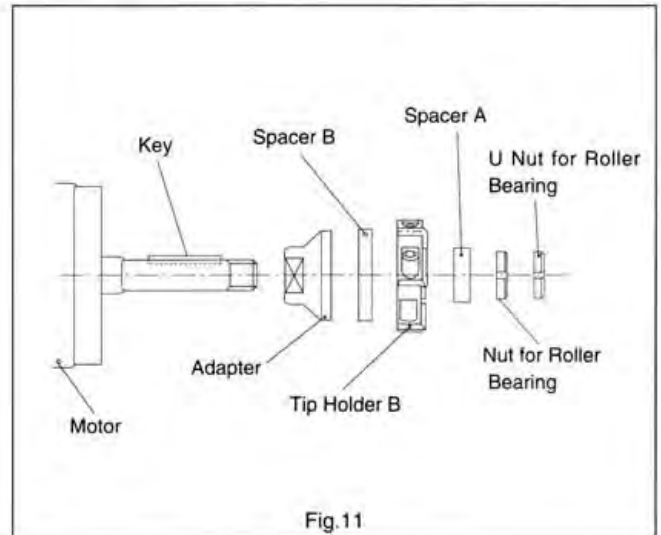


Fig.11

#### 4-6 Chamfering procedure for a column.

Replace Plate C attached to the body with Plate B (included in the accessories).

Mount the Roller Bracket to Plate B using a Hex. Socket Head Bolt 8 X 30 as shown in Fig. 12 and then adjust dimension A (Fig. 13). Chamfering of rounded portions can be performed to accurate finish.

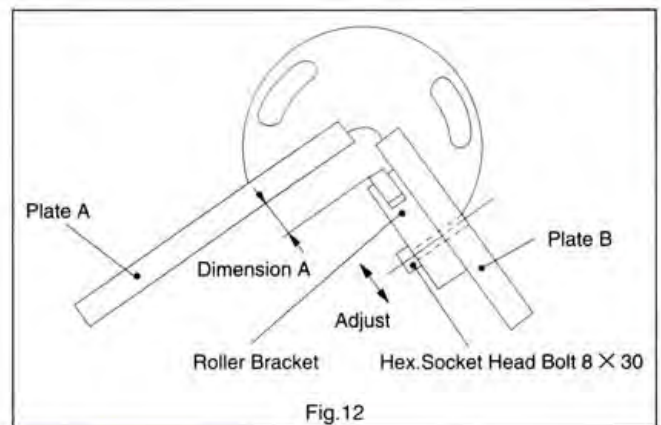


Fig.12

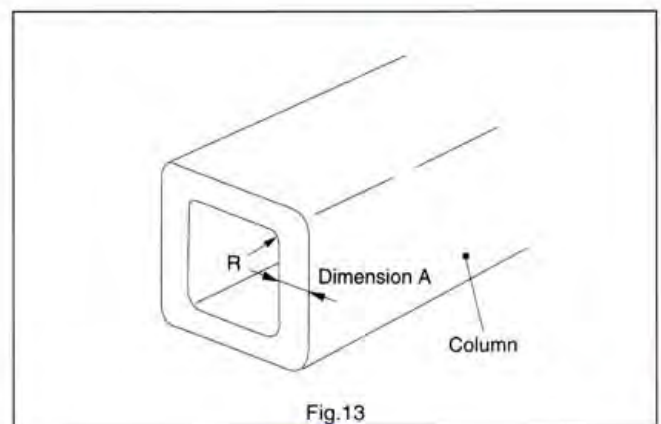


Fig.13

## 5. HOW TO OPERATE

### WARNING

**\*ALWAYS WEAR EYE PROTECTION.** Everyday eyeglasses only have impact resistant lenses. They do not protect eyes. Also use face or dust mask, if operation creates dust.

**\*DRESS PROPERLY.** Chips become a shape of a needle and are scattered. Wear protective clothes so that scattered chips do not stick to the body.

#### PREVENTION OF TIP BREAK.

Confirm that the tip had right rotation.. Then place and press the tool on the work piece slowly. When the switch is on after the tool is pressed or a tip is pressed suddenly, it will cause the tip damaged.

#### 5-1 START AND STOP

### WARNING

Always switch off before it is plugged in.

#### 5-2 SPEED

Operate it with an appropriate speed  
( 30cm/min for mild steel 7C bevelling).

If the work surface is burnt, it means the speed is not proper. The way of use with fast feed or shock will cause the damage of a tip or the tool. If tips are burnt with proper speed, check how far it has abrasion and replace it with a new one.

#### 5-3 BEVELLING

Hold T handle and sub handle tightly.

Press it to a work piece slowly and move with arrow direction shown in the rating plate.

## 6. MAINTENANCE AND INSPECTION

### WARNING

**\*When performing maintenance,inspection, replacement or adjustment of parts ,make sure to disconnect the attachment plug from the receptacle.**

**\*Check regularly if there is any place where fixed screw becomes loose. If there is some, fasten again.**

## 7. OPTIONAL ACCESSORIES

#### 7-1 TIP

Parts No.	Parts Name	Q'ty
TA9A093	tip 12.7 Ass'y (including12pcs.)	1set

#### 7-2 JIG for pipe bevelling

Parts No.	Parts Name	Q'ty
TA9A728	Plate Ass'y for pipe	1set

Work in the range of 125mm - 800mm is available.

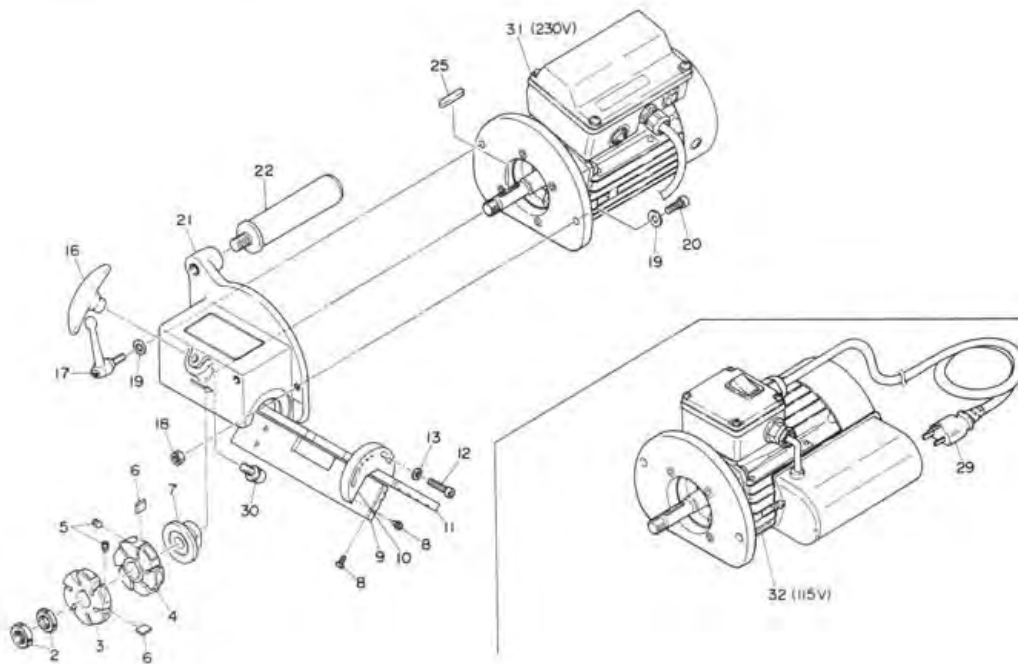
## 8. ORDERING SERVICE PARTS

In ordering parts and components, give the part number, part name and quantity to the sales agent from whom you purchased the tool.

## 9 ASSEMBLY AND PARTS LIST

### ⚠ CAUTION

The illustration is for information only. Users should never disassemble parts. Contact the sales agent from whom you purchased the tool or authorized dealer should the tool need service, repair or replacement of parts.



The parts numbers with ( ) are included in the Ass'y parts written above them.

No.	Parts No.	Parts Name	Q'ty	Price
2	TP04157	Nut for Roller Bearing AN03	2	
3	TA9A066	Tip Holder A Ass'y	1set	
4	TA9A067	Tip Holder B Ass'y	1set	
5	(TP04689)	Hex. Socket Head Set Screw 6x 8	12	
6	TP16594	Tip 12.7 sq.	12	
7	TP16152	Adapter	1	
8	TQ00208	Hex. Socket Head Screw 6 x 12	8	
9	TQ00207	Plate C	1	
10	TP16124	Plate Guide	2	
11	TQ00205	Plate A	1	
12	TP06217	Hex. Socket Head Bolt 6 x 25	4	
13	TP00092	Plain Washer M6	4	
16	TA9A074	T-Handle Ass'y	1set	
17	TP16159	Clamp Lever	1	
18	TP08584	Hex. Nut M8	1	
19	TP10978	Plain Washer M8	2	
20	TP07353	Hex. Socket Head Bolt 8 x 30	1	
21	TA99911	Body Sub Ass'y	1set	
22	TA92089	Sub Handle Ass'y	1set	
25	TP16151	Sunk Key 5 X 5 X 36	1	
29	TA9A757	Cabtyre Cable Ass'y	1set	

#### Accessories

No.	Parts No.	Parts Name	Q'ty	Price
30	TQ03353	Hex. Socket Head Cap Screw 10 X 30 with Spring Washer	1	
31	TB02203	Motor Ass'y (200-240V)	1set	
32	TB02204	Motor Ass'y (110-120V)	1set	
	TP16613	T Wrench Key 3	1	
	TP01939	Hex. Wrench Key 4	1	
	TP04004	Hex. Wrench Key 5	1	
	TP00170	Hex. Wrench Key 6	1	
	TP04309	Spanner 24 X 27	1	
	TP16410	Hook Spanner 25-28	1	
	TQ00206	Plate B	1	
	TA99834	Roller Bracket Ass'y	1set	
	TP16600	Spacer A	1	
	TP16601	Spacer B	1	
	TA9A093	Tip 12.7 sq. (12 pcs. each/sheet)	1set	
	TQ02984	Instruction Manual	1	

#### Optional Accessories

No.	Parts No.	Parts Name	Q'ty	Price
	TA9A093	Tip 12.7 sq. (12 pcs. each/sheet)	1set	
	TA9A728	Plate Ass'y for Pipe	1set	



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TQ02984-3-31102A