

For corners (R), straight lines and curves
One-touch Beveller

ChamfoAir

User Guide



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Specialized Manufacturer of Bevellers

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Safety Instructions for Air Tools

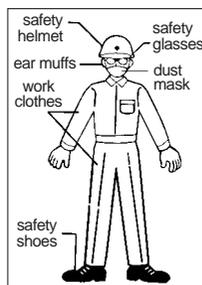
Warning Failure to follow these guidelines can result in death or serious injury.



Safety should be the first consideration when using air tools. Correct method of use and understanding is essential for using the tool safely. Read the guidebook and safety instructions to ensure correct use. Place the safety instructions in a visible place in the workplace for easy reference before and after operation. Do not remove the warning labels from the product.

Work clothes and safety wear

- ▶Wear appropriate clothing during operations (see diagram 1). Since moving parts spin rapidly, avoid loose clothing.
- ▶Wear a safety helmet that completely covers your hair.
- ▶Wear safety glasses. Normal glasses are not shock resistant and are not safety glasses.
- ▶Wear a dust mask. Fine dust can damage your health by absorption through the respiratory organs.
- ▶Wear earmuffs to protect your hearing from loud noise.
- ▶Wear safety shoes.
- ▶Discontinue operations when you feel tired.
- ▶Do not touch moving parts.



Correct method of use

- ▶Use cutting tools after you have confirmed that standard parts are in use and that they are securely fixed.
- ▶The tool must be used at the standard air pressure.
- ▶Ensure that the work item is securely fixed.
- ▶If the work item is not securely fixed, there is the danger of breakage due to the operational vibration.
- ▶When fixing parts to the tool, ascertain whether the tool in front is completely fixed or whether the bead is unfastened.
- ▶When handling parts, be careful to avoid touching hands or other parts of the body to sharp edges.
- ▶Cutting tools that are not standard or with defects such as wear or misshaping are extremely dangerous and should not be used. Breakage during use can cause harm to people and objects nearby.
- ▶Only change cutting tools after disconnecting the air hose.
- ▶Conduct operations in a correct and comfortable posture.
- ▶Unsafe and excessive operation can cause harm to hands, legs and back.
- ▶Do not drop or throw the tool, or expose to excessive shock.
- ▶The tool is assembled from fine parts. Breakdown can result from breakage or warping due to shock.
- ▶Avoid excessive operation.
- ▶Do not exceed the capabilities of the tool or parts. Avoid operations that overburden the tool or parts.
- ▶Do not use the tool for any purposes other than which it was intended.

Repair and examination

- ▶When repair is required, seek repair only from a maker with specialized training or a maker's designated agent. Wanton repair and remodeling by the operator can lead to tool breakdown and injury or death.
- ▶When changing parts, use only proper parts supplied by the manufacturer. Do not use parts that are self-made or that do not meet the necessary standards.
- ▶For disassembly and assembly, contact the maker's designated agent for the necessary tools.
- ▶For air purification, remove air from the air tank every day and fix a filter to the inflow opening.
- ▶Conduct periodical oiling (once per day). To avoid repeated acidification due to moisture and wear due to high-speed revolution in the interior of the motor and extend the life of the tool, inject with specialized AIR TOOL oil.
- ▶Do not use damaged or broken hoses or connectors.

Disposal

- ▶The tool is made of a variety of materials including steel, cast iron, cast bronze, aluminum alloy and rubber containing pliant substances. When disposing of this tool, avoid causing harm to people or the environment.

GT-06S One-touch Beveler Chamfo (air-operated) Instructions

1.External Construction and Function

- Corner (R) and straight line beveling



- Curved beveling



2.Uses

Suitable for beveling corners (R), straight lines, and the inside and outside diameters of various parts of castings, jigs and components made of steel, cast iron, metal, and nonmetal materials.

3.Characteristics

- The air flow is opened and closed by twisting the switch to the left and right.
- Fixed beveling depth for multi-use operations including corners (R), straight lines, and curves
- No loosening with adjustment of the beveling depth by one-touch spline
- Capable of rapid repeated operations with altered beveling depth (0.1mm - 1.5mm)
- One product capable of corners (R) straight lines and curves
- Easy to adjust beveling depth with one-touch system (adjustable to 0.1mm)
- For corner (R) operations, capable of operations to R1.

4.Replacement of operational tools and method of use (tip holder, carbide rotary burr)

• Replacement of operation tools

After removing the ④ base plate by rotating to the left, place the ⑨ tip holder and the ⑫ carbide rotary burr inside the ③ revolution axis bore and fix with the ⑭ tool fixing bolt. Use after reattaching and fixing the ④ base plate.

• Using the tip holder and carbide rotary burr

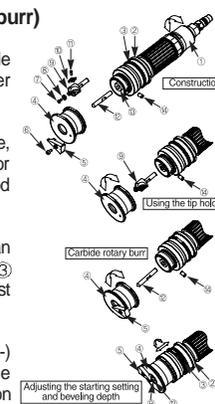
Use for beveling curves and straight lines after removing the ⑤ corner (R) and straight line guide, and replacing the ⑨ tip holder according to the method for the replacement of operation tools. Set for cutting corners (R) and straight lines by changing the ⑫ carbide rotary burr according to the method for the replacement of operation tools and replacing the ⑤ corner (R) and straight line guide.

• Adjusting the starting setting

Rotate the ③ gauge to the right (-) as far as it will go to the starting position, and conduct an operation using the bottom surface of the ④ base plate as the point of reference, shifting the ③ gauge to the left (+) by one calibration setting until the cutting edge of ⑨ and ⑫ reach the first cutting start position and then set the ② calibration setting at the calibration of 0 on the ③ gauge.

• Adjusting the beveling depth

Push the ③ gauge toward the bottom of ④ base plate, and while rotating ③ gauge to the left (-) or to the right (+), adjust the setting for the beveling depth. When released, the ③ gauge automatically returns to its original position (the one-touch method). (One mark on the calibration scale is equivalent to 0.1mm, with an adjustment range of 0.1 - 1.5mm.)



5.For attention during use

1. Air pressure: Use at an air pressure of 6kg/cm² (85PSI). Excessive air pressure can reduce the tool's lifespan.
2. Lubrication: For the tool's smooth operation and long life, oil with special oil for air tools or spindle oil before and after use.
3. Air hose and connector: Have the hose as short as possible. To avoid a drop in air pressure, a connector of appropriate size is necessary.
4. Air purification: Remove moisture from the air tank every day. (Fix a filter on the pipe.)
5. Disassembly and cleaning: For optimum performance, disassembly and cleaning are required once per month.
6. When changing operational tools, the air supply hose must be disconnected.
7. Handle with care immediately after operation, as the tip and the spindle will be very hot.



6.Product standards and standard parts

▶GT-06S Standard

- Base size diameter 54mm
- Total length: 201mm
- Hose diameter: 8mm
- Collet size diameter 6mm
- Weight: 1.2 kg
- Average air consumption: 0.30 m³/min
- Maximum speed of revolution: 25,000rpm
- Air intake screw size: PT 1/4 inch
- Appropriate operational air pressure: 6kg/cm²

▶Standard specifications

- tip holder bearing: MR74 (NSK) 674 (NTN) L-740 (NMB) ML4007 (KOYO)
- standard tip: DCMT070204
- tip fixing bolt: FTKA 02565-T7
- corner (R) and straight line guide bolt: M3X6L
- carbide rotary burr: SK-1M-GT (6mm shank) - available on demand
- tool fixing bolt: M5X6L (SET BOLT)
- tip holder bearing fixing bolt: M2.5X4L

▶Standard parts

- tip holder, carbide rotary burr, T7 wrench, 2.5mm L wrench, corner (R) and straight line guide, spanner