Operating manual Euroboor Deburring and Chamfering Machine LKF.300 and LKF.450

List of contents:

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Carefully read this before putting the machine into operation

EC Attestation of conformity according to the machine recommendations 98/37 EG.

This product corresponds to the basic requirements of the relevant EC recommendations.
An assessment procedure regarding conformity has been carried out according to the recommendations.

EC recommendations: 98/37/EG
89/336/EWG
737237EWG

Harmonized standards: EN 61 000 – EN 55 014 –
EN 50 144

Euroboor provides the following technical documentation Evaluation

Operating Manual
Construction plans
Test documents
Other technical documentation

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1) Specification:

Motor voltage:	220-240 V AC
Output:	1500 Watt
Speed:	6000 min^{-1}
Overheating protection:	X
Overload control	X
Soft start	X
Feed:	manual
Chamfer angle:	45° optional 30°
Land width:	45° 0 - 8 mm continuously
	30° 0 -7 mm continuously
Size:	330 x 138 x 295 mm
Weight:	4.6 Kg

Scope of delivery:
1 Deburring and chamfering machine
1 Milling tool 45° optional 30° (depend. on the order No.)
2 Sintered carbide reversible disks **LKS.20**
1 Spanner SW 22
1 Sickle spanner
1 Torx screw driver T9
1 Carry case
1 Operating manual

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2) Application:

The **LKF** machine is ideally suitable for the deburring and chamfering of metal parts made of steel, stainless steel, nonferrous metals, brass and plastics.
The handy, compact design allows the use for straight edges, internal and external radii and bore holes from ø 22 mm. The fine adjustment allows slight chamfers for deburring up to the preparation of welding seams.
Two milling cutters with a chamfering angle of 45° or optionally 30° are available. The reversible disks can be used in 3 ways. Due to the small guiding roller, insertion into bore holes from ø 22 mm is possible without any problems.

The machine is suitable for the following fields of application:

Mould making:
Deburring of contours, radii, bore holes
Boiler and process plant construction: Preparation of welding seams on heat exchangers
(bores) Preparation of welding seams 30° up to 7 mm
Mechanical engineering: Deburring of machine parts.
Chamfering of edges as protection against peeling of the varnish after painting.
Making of visible edges.
Sheet metal working:
Deburring of cutting edges.

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Setting of the land height:

For setting the land height loosen the lateral clamping lever (picture 1) and set the desired dimension by rotating the complete machine head.
The set value can be read from the graduated collar (picture 2).

Picture 1

Picture 2

Switching-on and positioning of the machine:

Caution: Always wear eye protectors!

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Grip both handles and place the machine
exactly straight with the supporting plate onto the material.

Switch the motor on and wait until the maximum
speed is reached.
This will take about 3 seconds.

Now slowly and evenly immerge the milling tool into the material.

Always work exactly opposite the rotating direction of the tool.
Pay attention to the marks for the direction of rotation on the supporting plate.

Work with a steady feed and try to obtain a neatly milled surface.
Always take care that the machine is properly positioned with the supporting plate.

Switching the machine off:

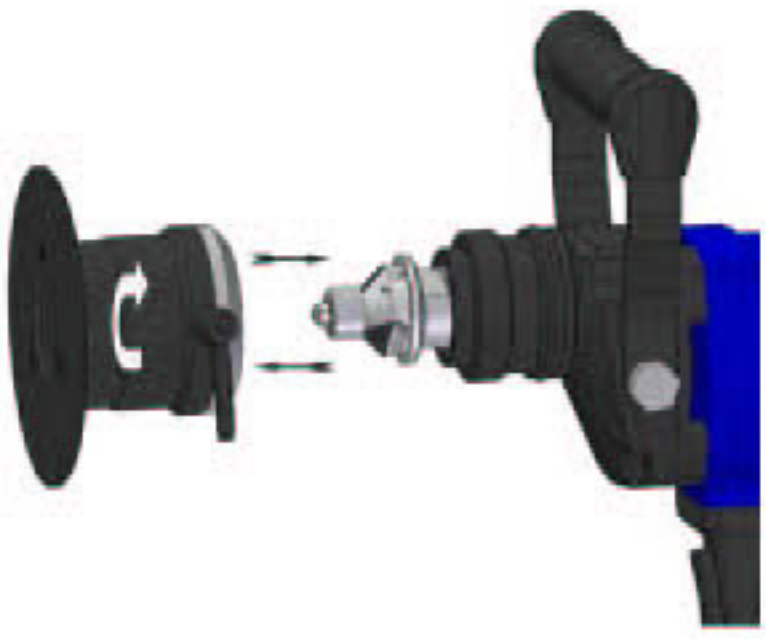
First remove the machine from the material.
Only switch the machine off when the milling tool is not working anymore in the material.

Caution: Never touch the rotating milling tool!

3.) Tool change:

For changing the milling tool, loosen the lateral adjusting screw.
Loosen the housing by twisting it off the motor.
Now, the milling tool can be removed by means of the tools, which are part of the delivery (spanner SW 22 , sickle spanner) (picture 3).

Picture 3



Now, screw the desired milling tool in.
Attach the housing onto the motor again.
Tighten the adjusting screw.

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4.) Maintenance:

> Clean and lubricate the machine at regular intervals, as required.

> Immediately replace defective clamping screws in the milling tool.

> Always check switches, cables and antikink protection for damages.
Defective parts must be replaced immediately.

> Check the carbon brushes for wear.
Worn carbon brushes leave fine dust in the upper part of the motor. Therefore, clean the upper part of the motor at regular intervals. When doing so, also remove the chip particles, which possibly entered the motor through the ventilation openings.

<u>Repairs may only be carried out by specialized personnel and by approved workshops.</u>

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