

Complex High Speed Guide Rail Chamfering Machine SF-900DG

User Manual

Dear users,

Thank you for choosing our company product. Please read the manual carefully before assembling and using it.

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Machine Feature

1. SF-900DG Chamfering Machine widely used in chamfering all kinds of machinery,mould,automobile parts,hardware,etc.
2. The machine adopt composite structure: one side straight plate with 2 mode,fixed mode and sliding mode optional. Sliding Mode: workpieces and plate move together,does not damage workpieces,is the most ideal chamfering machine to processing aluminum and copper workpieces. Another side with a curved disc,realize one machine dual use. The curved part adjustment method adopts the rotary-rod principle,which is easy,convenient and size accurate.
3. The workbench panel is cast with high wear-resistant materials,which are durable and non-deformable.
4. The cutter head adopts the international advanced chip principle, no need clamping, simple operation, high chamfering regularity,easy adjustment, good finish and efficiency is 10-20 times of traditional equipment.
5. The use of fast machine chamfering is the trend of the machinery industry.
6. The design of this machine is different from the similar products in the market. The curved part can choose R2 cutter head cutting or 45°cutter head cutting.
7. The machine not only can chamfering workpieces straightly,but also suitable to chamfering curved workpieces,small molds and machine parts.

Safety use,Routine maintenance

1. Work site

- 1) Equipment should be placed in a level and solid place.
- 2) Places that children cannot reach

2. Personnel protection

- 1) Operators should wear protective glasses to prevent debris from entering the eyes when chamfering.
- 2) It is forbidden to wear long ties and clothes with long cuffs. If you have long hair, you need to wrap the hair to avoid damage caused by clothes, hair, etc drawn into machine when the equipment is running.

3. Precautions during use

- 1) Be sure to use the power cord that comes with the device itself.
- 2) When the device is running, keep your fingers or other external items away from the rotating area to avoid injury.
- 3) When not in use, please turn off the power switch and unplug the power plug. If the device makes an abnormal sound or smoke, please turn off the power immediately, unplug the power cord, and do not repair it. Contact the company in time. .
- 4) Do not use the device when there is a flaw in the power cord or other wires.

4. Post-use considerations

- 1) Turn off the power switch and unplug the power cord.

2) It is forbidden to use fingers and tools to test whether the cutter head is still rotating, to avoid injury to the personnel and damage to the equipment.

3) Please clean up and maintain after use.

5. **Routine maintenance**

1) Be sure to do the cleaning and maintenance work after turning off the power switch and unplugging the power plug, otherwise it is dangerous.

2) Do not use water to wet the device, otherwise it will cause a short circuit.

3) Clean the equipment with a cleaning tool regularly, such as a brush or a dry cloth. Do not use a blowing device.

4) When the equipment is dirty, please wipe it with a dry cloth. If it is water, the equipment will rust easily. It is forbidden to clean the equipment with organic solvents such as gasoline and alcohol.

Application and Specifications

1. Application

This product is a high-speed motor-powered chamfering machine, suitable for chamfering of various machinery, molds, automobile parts, hardware, etc.

2. Specification

Brand	Sanford	Model	SF-900DG	Type	High Speed Chamfering Machine
Voltage	380V	Frequency	50Hz	Power	750W
Application		Blade	R2 , 45°	Blade Quantity	Linear: 4pcs, Curved: 2pcs
Chamfering Angle	45°, R2	Chamfering Depth	Linear: 0-5mm Curved: 0-3mm	Plate Size	Linear: 320mm, Curved: 250mm
Speed	10000(rpm)	OEM	Yes	Weight	75kg

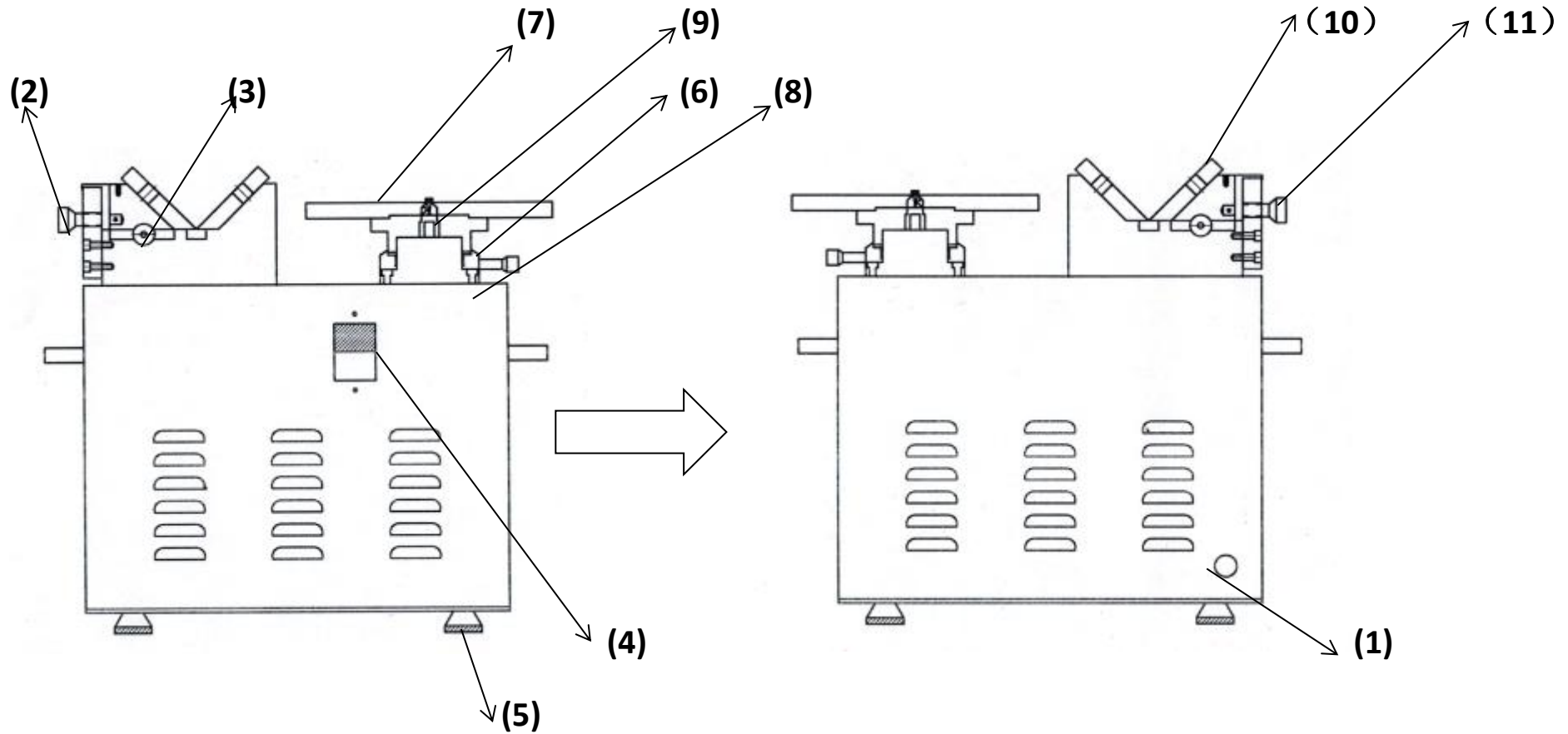
3. Standard Packing List

Name	Quantity
High Speed Chamfering Machine	1set
Power line	1pc
M6 hexagonal wrench	1pc
Blade screw wrench	1pc
M5 Cutter head wrench	1pc
User manual,warranty card	1pc

4. Optional device

Name	Quantity
Liner position block	1pc
300mm work plate disc	1pc
Cutter head R2	1pc
Sliding type work plate	1set
500mm extended work plate	1set

Operation Instruction:



- (1)** Power cord interface (2) Right part of adjustment hand wheel for linear blade feed (3) Linear blade feed lock screw
(4) Power Switch (5) Leg (6) Disc holder (7) Disc table (8) Curved blade feed adjustment base (9) Curved cutter head
(10) Linear working plate (11) Left part of adjustment hand wheel for linear blade feed

Curved Part Operation

1. Plug the power cord into the power cord interface(Fig 1), and then press the power switch (Fig 4) to make the machine curve part start work normally.
2. Loosen the disc holder (Fig.6), Adjust the disc table(Fig.7) to the chamfering size, and then fasten the disc holder (Fig. 6).
3. Place the workpiece on the working disc table (Fig. 7) and chamfer it in the direction of the indicator on the working disc table (Fig. 7).

Curved blade replacement and cutter head exchange

- 1) Loosen the disc holder (Fig. 6) and rotate the disc table counterclockwise (Fig. 7), remove the disc table, and align the blade screw handle to the cutter head (Fig. 9) and then unscrew the screw.
- 2) If you need to chamfering the R2 angle, take down the disc table at first, turn the cutter head handle counterclockwise to unscrew fixed cutter head (Fig. 9) , then turn the R2 cutter head clockwise and adjust to the chamfering size R2.

Linear Part Operation

1. Plug the power cord into the power cord interface(Fig 1), and then press the power switch (Fig 4) to make the machine

linear part start work normally.

2. Loosen the left & right blade feed lock screws (Fig.3), adjust the right & left feed adjustment handwheel (Fig. 2) (Fig. 11) to the chamfer size, and then tighten the blade feed lock screw (Fig. 3).

3. Place the workpiece on the work plate (Fig. 10) and chamfering according to the direction of the indicator on the fixed work plate (Fig. 10).

Maintenance

After use the equipment, it must be maintained regularly to keep machine well running continuously.

1) Check whether the blade is worn out. Using the worn blade during operation will result in poor finishing workpiece, high friction of the cutter head, and easy damage to the spindle bearing.

1) The discharge port should be cleaned regularly to prevent the iron filings blocking the discharge port.

2) Check tightness of the cutter head screws regularly to ensure stable of the cutter head spindle.