Huvema®

Tube and Profile End Grinder

II. TECHNICAL SPECIFICATIONS

PRS76C is a new model developed from PRS-76. with an additional work area, and more capacity. Except can be used for grinding ends of tube sections and deburring ground tube section ends, but also can be used for polishing surface of plate, square tube. Combination of the tube grinding, surface grinding and wheel grinding three functions.

A survey of the roller available: Roller diameters fromφ20 up to and incl. ¢ 60 mm increasing by 2 mm steps. Roller diameters ¢ 76mm;1/4",1/2"; 3/4"; 1",1 1/4; 1 1/2; 2" and 2 1/2" . Other diameters between ¢ 20 and ¢ 76mm are available on request from your dealer.

Type of grinding belt:

Diameter Grinding roller	STEEL		RVS		ALUMINIUM	
	TYPE	GRAIN	TYPE	TYPE	TYPE	GRAIN
¢ 20- ¢ 40	R822	36	R981	150	R822	36
¢ 40- ¢ 76	R845	36	R981	36	R822	36

Measurements of the grinding belt: length x width =2000 x100 (79" x4")
Survey of the switches and zero voltage coils for certain voltages:
Tension 230Volt switches: PKZM1-10 +coil U-PKZM1-230
Tension 400Volt switches: PKZM1-6 +coil U-PKZM1-400

III . Mechanical Operating

A. INSTALL

1. Remove the detachable parts (scrap bin, with the spare parts, box with grinding belts and the ordered grinding rollers) from the packing.
2. Dismount the two fixing bolts, by which the pipe notcher is fixed to the underframe of the packing. Remove also the four wooden screws by which the column and underframe are fixed to the crate.
3. Take the column and underframe out of the packing and mount these together. (See ill. No.2) Attention!! The grinding belts, scrap bin, sphere handle, fastening bolt, and lever are included in the column.
4. Take the pipe notcher from its packing by means of the rope connected to it. (See ill. No.1)
5. Open the side flap and position the pipe notcher by a rope (see ill.No.2) on the column. Fasten the machine to the column by the two M12 bolts. Place the scrap bin under the pipe notcher.

6. Mount the sphere handle A and the lever B to the front and under the clamp (ill. No3)

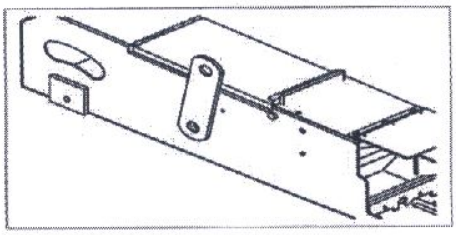


Illustration 1

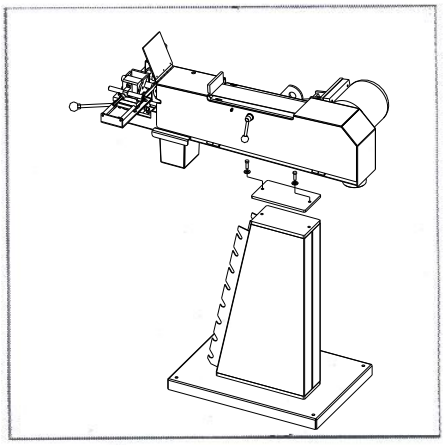


Illustration 2

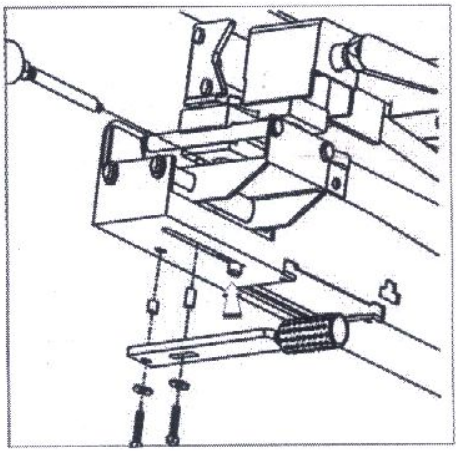


Illustration 3

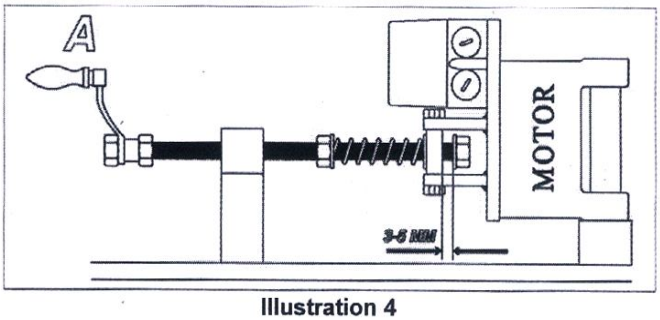


Illustration 4

7. Check the voltage, which is mentioned on the machine. When the voltage is not correct this has to be altered. See for instructions chapter “Connection of 230 or 400Volt”
8. A plug has to be mounted the the cable. Please check, after you have connected the plug, if the driving roller of Tube and Profile End Grinder rotates in the rotating direction indicated on the driving roller. If this is not the case, you have to change the threads in question in the plug.
9. Lead the cable to the power supply socket in a way that nobody can stumble over it.
10. To increase the stability of the machine an adjusting screw has been mounted underneath the underframe.To achieve an even better stability we advise you to anchor the machine to the floor.

B. (DIS) MOUNTING OF THE GRINDING BELT

=>Before removing the grinding belt, it must completely come to a standstill
=>Rotate the compound tables as far as possible from the machine
=>Open the side flap and the top flap.
=>Rotate handcrank A (see ill.no.4) to the left, to release the tension of the grinding belt.
=>Now position the grinding belt, please see to it, that the arrow on the inside of the grinding belt and the arrow on the power roller are heading the same direction. Start to replace the grinding belt at the side of the grinding roller. For the execution and type of a new grinding belt we refer to the technical information.
=>Then the grinding belt has to be brought to the correct tension. This can be achieved y rotating handcrank A to the right, so far, that the space between the cylinder and the plate is between the 3 and 5 mm.(see ill.no.4).

After this the adjustment has to be checked again, according to the procedure “Adjusting the grinding belt and grinding roller”.

C. (DIS) MOUNTING OF THE GRINDING ROLLER

Before changing the grinding roller the grinding belt has to be removed first, this is shown in the chapter “Changing of the grinding belt”.

=>Remove the grinding roller by pulling it to you. The grinding roller held by two springy balls (see ill.5)
=>Clean the bearing holders well, this prevents the problem that the grinding roller does not clamp.
=>Never adjust the glands, by which the bearings are held, these are adjusted correctly.
=>Position the new grinding roller. Remark: Additionally we can supply roller diameters. See the technical information for the different dimensions.

ATTENTION:
The bearings which are assembled on the grinding roller, must e handle very carefully, because they are very sensitive for damages.
We advise you, when you use a grinding roller smaller than φ30mm., to take a grinding belt which first has been used with a bigger grinding roller diameter. This is because otherwise the grinding belt will crack, because it is very tough.

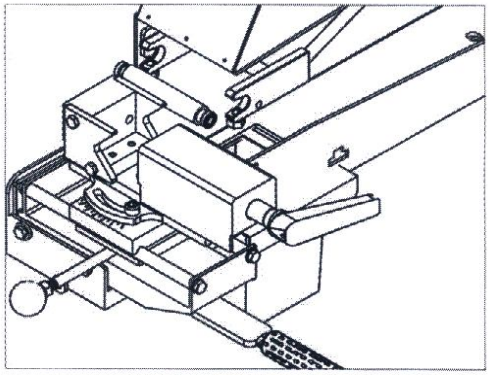


Illustration 5

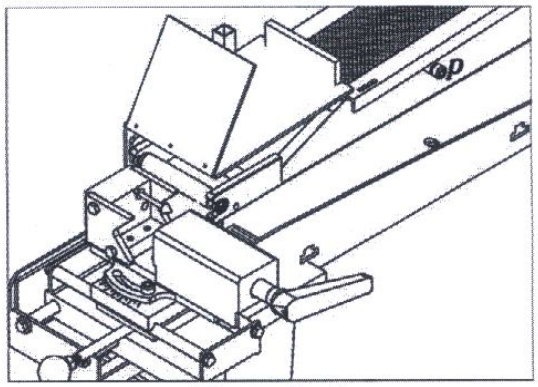


Illustration 6

D. **ADJUSING OF THE GRINDING BELT/-ROLLER**

When putting into use and changing a grinding roller you always have to check the following adjustments:
a. The sidewards movement of the grinding belt should be prevented.
b. The centerline height of the grinding roller has to be equal to the tube section, which has to be grounded.

When the adjustments are not correct, they have to be adjusted as follows to here by:
a. The sidewards movement of the grinding belt. : For the first rough adjustment the grinding belt has to be turned manually. For a more specific adjustment the motor can be turned on (see to it that sideflap E is closed). (see ill.6)
b. The height adjustment of the grinding roller: The height of the grinding roller has been adjusted well by the manufacturer. When the centerline of the tube section is not situated on the centerline of the grinding roller, the height of the grinding roller has to be adjusted by unscrew the hexagonal bolts and adjust the height. After this, the bolts have to be fastened again. (see ill.7)

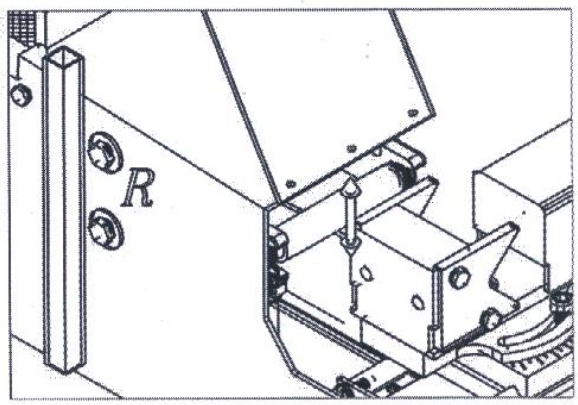


Illustration 7

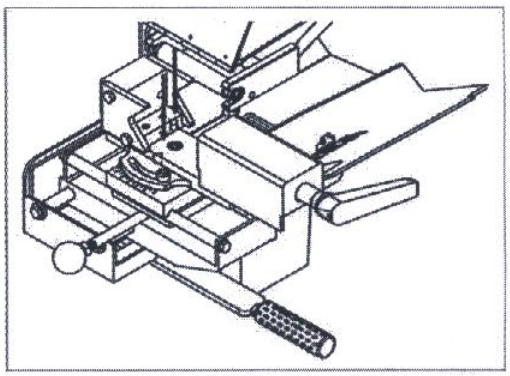


Illustration 8

E. OPERATING INSTRUCTION MANUAL

a. Operation of the compound table : You can move the compound table forwards and backwards by means of the lever. By moving the sphere handle a quarter turn to the left first you can move the clamp to the left or to the right.

b. To tighten the product :The clamp is suitable for the roller diameters from Ø18mm till Ø76mm. For the use of tubes you have to see to it, that the centerline of the tube is at the same height as the centerline of the pressure roller. It is possible to use a filling cheek. (see ill.8)

c. Adjusting the angle

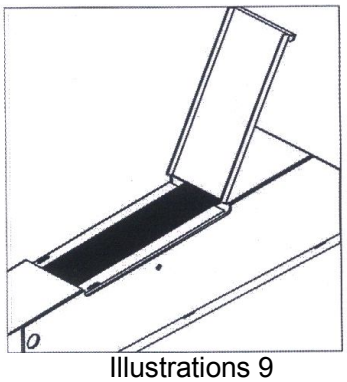
By means of the graduation on the compound table you can turn the stretch block simply and fast between 90°en 30°.During the adjusting of the angle the hollow-head bolts B and C have to be unscrewed, after which the right angle can be adjusted. The hollow-head bolts have to be fastened firmly.

d. Stop

Underneath the compound table of the clamp is a block, by which the standard stop can be adjusted (see ill.3). This stop is for moving the product towards the grinding roller. On the flat side of the stretch block there are two M8 threaded holes to which a length stop can be fixed.

e. Grinding

After the profile has been stretched the compound table is to be positioned in such so that the profile to be ground is straight in front of the pressure roller. Then the profile can be grounded by moving the lever B towards the machine. Attention: see to it that the grinding width is not exceeding that of the grinding belt.



Illustrations 9

f. Deburring

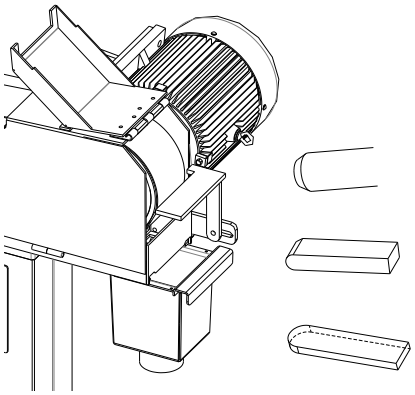
The machined pipe can be deburred at once.This is possible by opening the flap on top of the machine (ill.9), so that the grinding belt is free, on which the pipes can be deburred.

g. Added working area

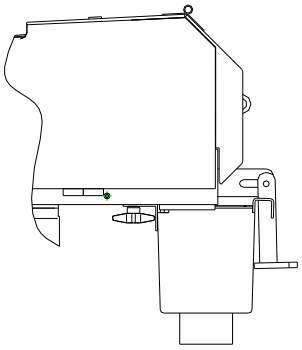
Open end cover, can be grinding ends of tube and deburred of round tube at once. also can be used for polishing surface of plate, square tube. (ill.10),

h. Safety

To keep safety, when not working, please turn worktable to a suitable position as draw. (ill.11), and put down end cover.



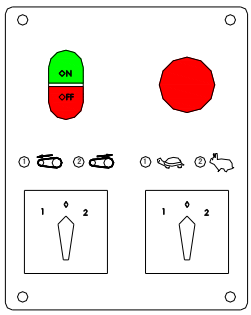
Illustrations 10



Illustrations 11

i. Switch

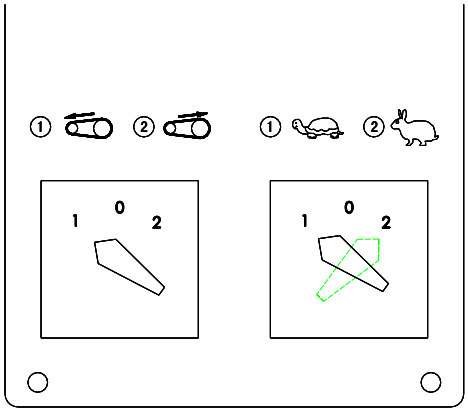
Usually the two switches all on position “o” when leave factory. (ill.12)



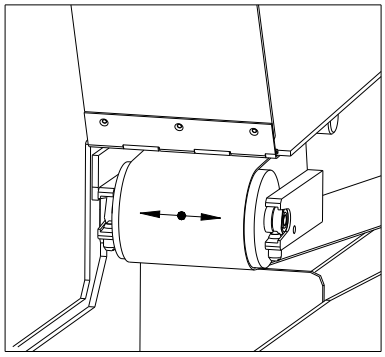
Illustrations 12

j. Cutting

For cut, the direction of belt is left when switch at left. Can select low or high speed on the right according to need. Usually, the running state is adjusted suitable when leave factory—that’s mean belt at middle of rear wheel. (ill.13 & ill.14)



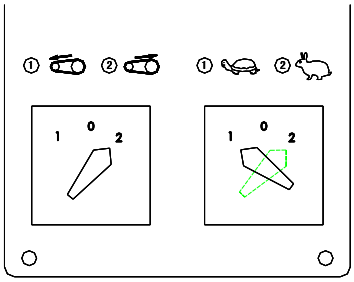
Illustrations 13



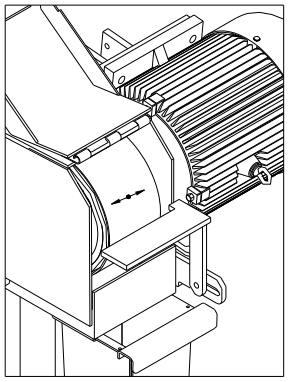
Illustrations 14

k. sanding

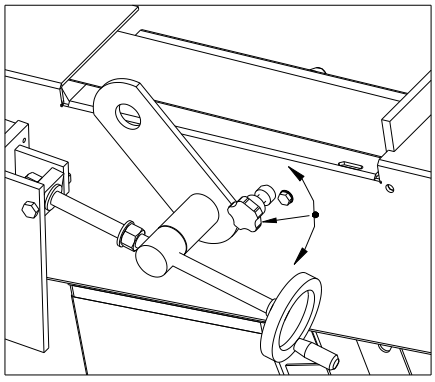
For sanding, the direction of belt is right when switch at right. Can select low or high speed on the right according to need. If the belt isn’t in middle of wheels, can adjust through pentagram handle as ill.17 (ill.15 & ill.16 & ill.17)



Illustrations 15



Illustrations 16



Illustrations 17

CE DECLARATION OF CONFORMITY

(in accordance with supplement II A of the Machinery Directive)

Industrie & Handelsonderneming Huberts bv, Kennedylaan 14, 5466 AA Veghel, the Netherlands, in the capacity of importer, is to be held responsible for declaring that the Huvema machine:

Tube grinder HU 100 PG-4

Machine S.No : ....

As described in the:

- Machinery Directive 2006/42/EG
- EMC Directive: 2014/30/EG richtlijn 2014/30/EG
- Low Voltage Directive 2014/35/EG

which this declaration relates to, is conform the following norms:

EN-ISO 12100:2010, EN-IEC 60204-1:2006/C11:2010, EN-IEC 61000-6-4:2007,
EN-IEC 61000-6-2:2007

Veghel, the Netherlands,

Datum:

L. Verberkt,
Managing director