SMG Rapid-Edge 100M Top Milling Type Plate Beveling Machine

Operation Manual

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1. Introduction

SMG Rapid-Edge 100M Top Milling Type Plate Beveling Machine is an automatic, self-propelled plate beveling machine designed to perform plate milling efficiently, reducing labour and operating costs. It uses a cold-cutting process to prevent surface oxidation during beveling. The resulting surface finish achieves Ra 3.2–6.3, meeting welding requirements across all industries. Plates can be welded directly after beveling, with no additional cleaning required. The machine offers clean operation, no pollution, and easy handling.

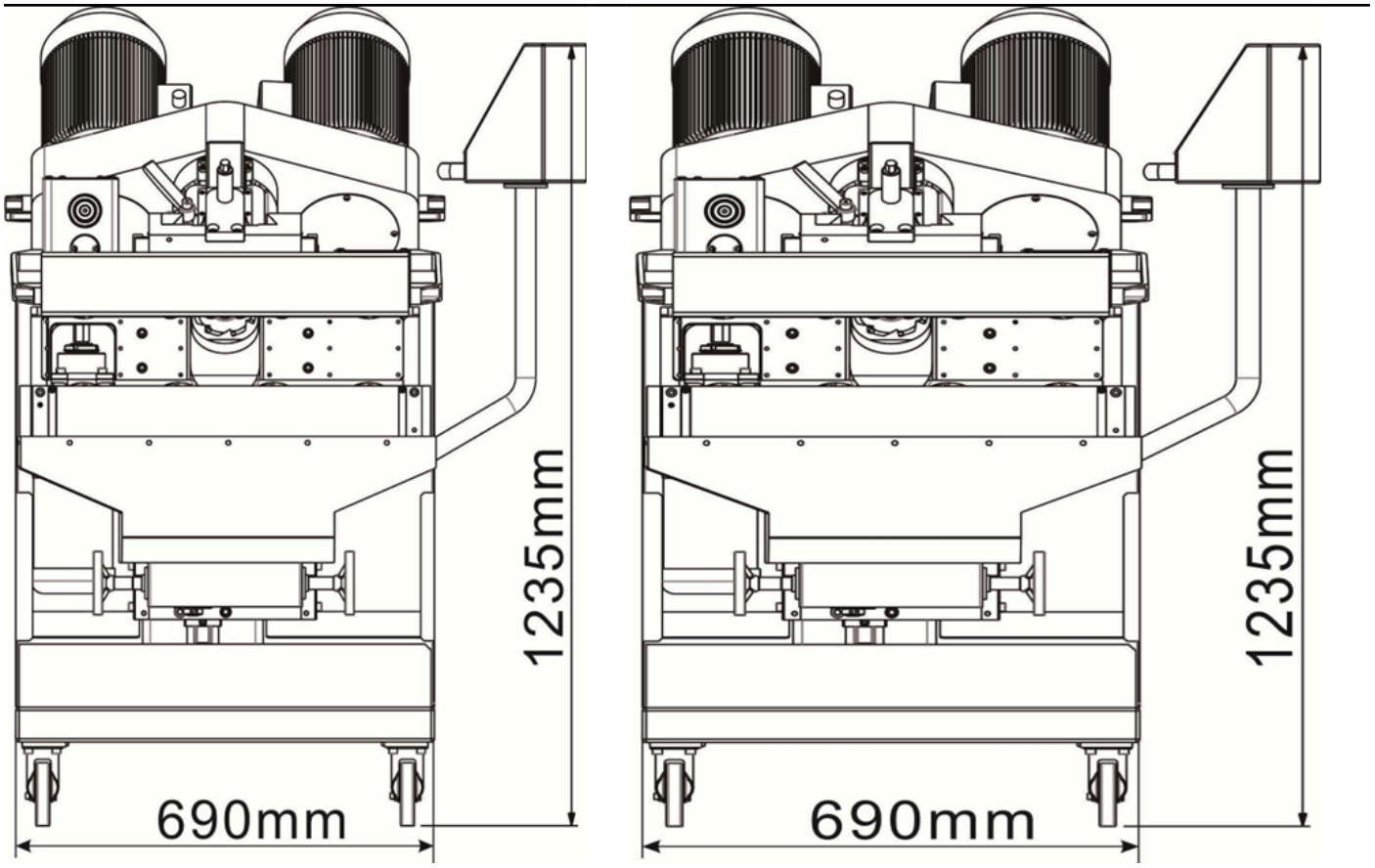
1.1 Applications

- Suitable for a wide range of materials, including steel, iron, stainless steel, aluminium alloys, copper, and more.
- Capable of processing various bevel types such as “J/U”, “K/X”, and “V/Y”.
- Commonly used across multiple industries, including:
    - Construction machinery
    - Steel structures and fabrication
    - Pressure vessel manufacturing
    - Shipbuilding and marine applications
    - Aerospace industry

1.2 Technical Parameters

Total Supply：AC 415V 50HZ	Total Power：6520W
Milling Power：2 * 3000W	Feeding Power：400W
Milling Speed：0～1500mm/min（Adjustable）	Bevel Angle ：0°~ 90 º（Adjustable）
Single Bevel Width：0~30mm（Like Q235）	Clamp Thickness：8~100mm（Customized Available）
Max. Bevel Width：100mm	Cutter Diameter.：Φ100mm
Processing Length：>300mm	Support Height：770~870mm
Clamp Width：>200mm	N.W：420kg

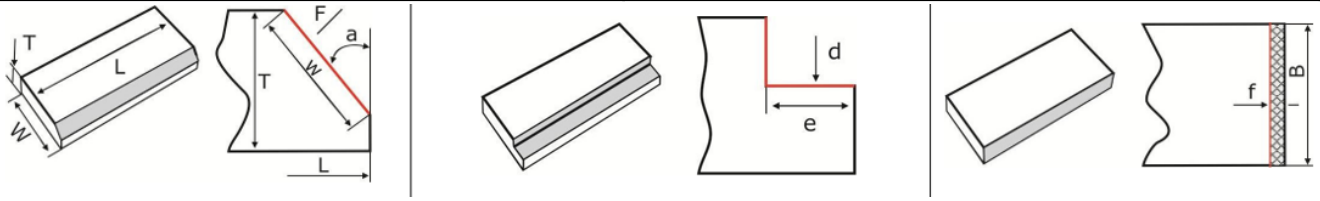
1.3 Machine Diagram



1.4 Models Specifications

Product		SMG Rapid-Edge 100M
Plate Size	Plate Length L(mm)	>300
	Plate Width W(mm)	>100
	Clamp thickness T (mm)	8~100
Working Capacity	Bevel Angel a(°)	0～90
	Bevel Width W(mm)	0～100
	Milling Depth d(mm)	20
	Miling Width e(mm)	100
	Feeding Depth f(mm)	30
	0°Milling Width B mm	100
Single Bevel Width (mm)		0~30
Spindle Speed (r/min)		500-1050
Feeding Speed (mm/min)		0～1500
Power Supply		415 vac

Total Power(w)	6400
Motor rotation(r/min)	1450
Machine Net weight(kg)	440



2. Safety & Warning

2.1 Safety Introduction

	• The electrical and rotating components of this machine may cause serious personal injury or property damage. • This machine operates on 415 Volts. Please read this operation manual carefully and familiarise yourself with all parts of the machine before installation, wiring, start-up, operation, or adjustment. • All electrical installation and maintenance work must be carried out by qualified and licensed personnel in accordance with relevant regulations and safety standards. • Failure to follow proper procedures may result in serious injury or damage to property.
	DANGER Improper operation could cause danger or even death!
	WARNING Improper operation could cause danger or serious injury!
	CAUTION Improper operation could cause moderate damage and property loss!

2.2 Safety Wear & Protectors

	• Before operating the machine, please check that you are wearing the proper protective gear: • Wear a well-fitted and comfortable work uniform. Long-sleeved clothing is recommended. • Do not wear sandals, high heels, loose shoes, or footwear with smooth soles. • Always wear a safety helmet during operation. • Wear safety goggles to protect your eyes. • Wear protective gloves when handling plates or sharp materials.
	**5.3 Protective Device** • Do not remove any protective covers or guards from the equipment. • The machine must not be modified or altered without prior authorisation from the manufacturer or qualified personnel.
	**5.4 Machine Operation and Shutdown Notes** • Before operation, ensure the work area is safe and clear of any obstructions. • Do not touch any rotating parts of the machine while it is operating. • After use, switch off the power and reset the machine before leaving the area. • Keep flammable and explosive materials away from the machine at all times. • Operate the machine only within the temperature range of 0°C to 40°C.
	**5.5 Safety Caution** • The manufacturer reserves the final right to interpret and modify any information related to this machine. • The manufacturer is not responsible for any issues or damage caused by the use of non-genuine accessories or parts not supplied by our factory. • Always disconnect the power supply before performing any maintenance or service work on the machine. • Inspect the plug, power cord, and machine for any signs of damage before each use.

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- Always disconnect the power supply before performing any maintenance or service work on the machine.
- Inspect the plug, power cord, and machine for any signs of damage before each use.

2.6 Security Identify

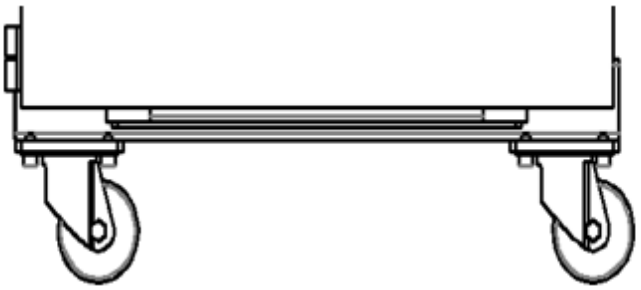
	**Caution – Risk of Burns:** After plate beveling, the iron pins and inserts become hot and sharp. Do not touch them with your hands**.**
	**Electric Shock Hazard:** If an issue occurs with the electrical box, it must be inspected by a qualified electrician. Always exercise caution and be aware of the risk of electric shock.
	**Hoisting Safety Notice:** During hoisting, do not stand beneath the machine to prevent the risk of injury.
	**Watch Your Hands** This warning is displayed on the plate feeding side, indicating a hand injury risk. Keep your hands and body clear of the machine while it is operating.
	**Caution – Hand Puncture Risk:** This warning is shown on the plate feeding side, indicating a risk of hand puncture. Do not touch the iron pins or plate with your hands after beveling.

3. Machine Inspection

3.1 Hoisting

	Step 1: Adjust the machine angle to 0 degrees (refer to Item 9). Step 2: Hoist the machine slowly from the designated lifting points. The height should not exceed 10 cm while suspended, except when crossing obstacles. Step 3: The packaging is non-recyclable and should be disposed of responsibly. Note: Use a high-quality lifting belt, and ensure the lifting capacity exceeds 500 kg.

3.2 Wheel Installation

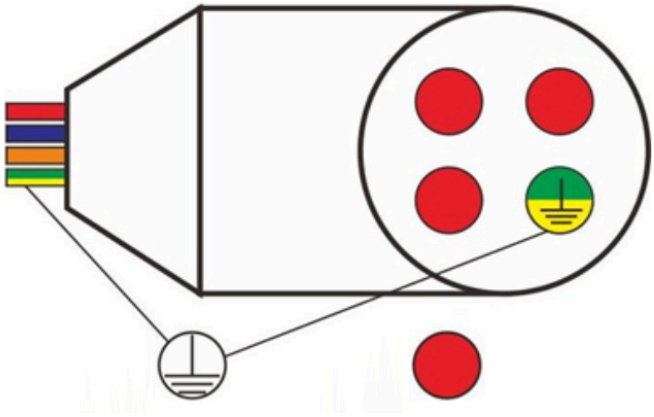
	When the machine is hoisted 200–250 mm above the ground, ensure that someone supports the machine while installing the wheels. Note: Maintain safe and stable hoisting at all times to ensure operator safety.

4. Installation & Diagram

CE Certified Requirements

External Ground Wire request wire size（Copper Conductor）	
Phase Line Diameter S（mm^2）	Ground Wire Diameter Sd（mm^2）
S≤16	S
16＜S≤35	16
S＞35	S/2

4.1 Electrical Installation

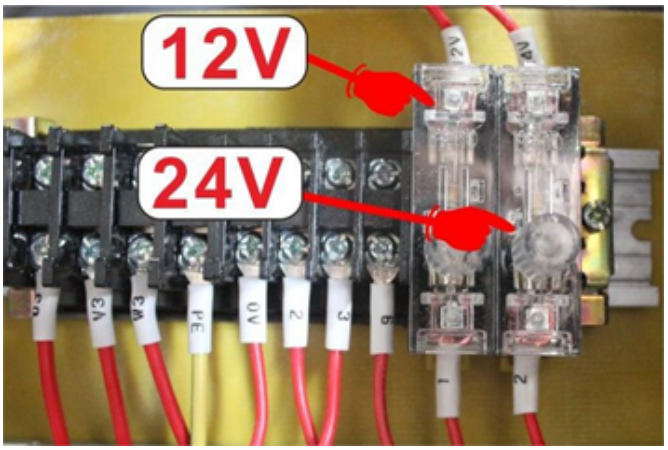


Wire Installation

- For safety, the machine uses three live wires and one ground wire. (Note: A neutral line may affect the inverter and should not be connected.)
- The electric wire size should be 1.5 mm² for three-phase power.
- Power supply: AC415V, 50Hz.
- All electrical connections must comply with local electrical standards and regulations.

Cutter Head Rotation

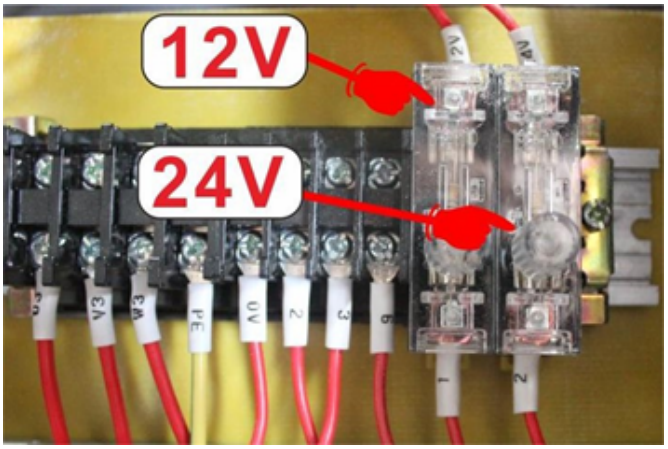
- After installation, check that the cutter head rotates in the correct direction.
- If the rotation is incorrect, swap any two of the active (live) wires to correct the direction



No data on digital display

- If no data on the digital display when power is on, Check the 12V fuse if blowout, or contact us directly.

Note: This operation is ONLY available when the troubleshooting is not solved.



No Power in Electrical Box

- If there is no power in the electrical box when the main power is switched on, check whether the 24V fuse has blown.

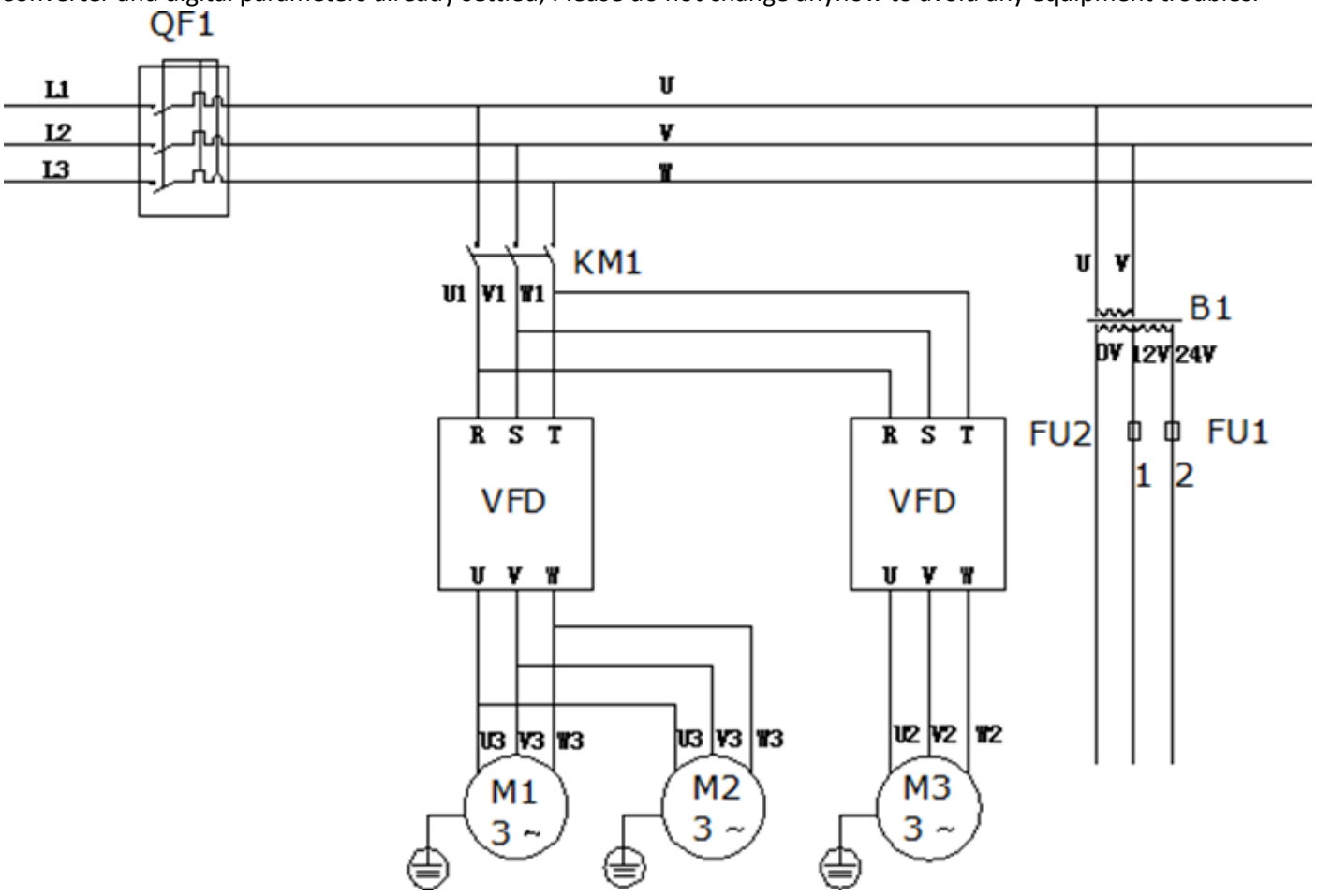
Note: This procedure should be performed only if the issue has not been resolved through standard troubleshooting steps.

4.2 Electrical Symbols

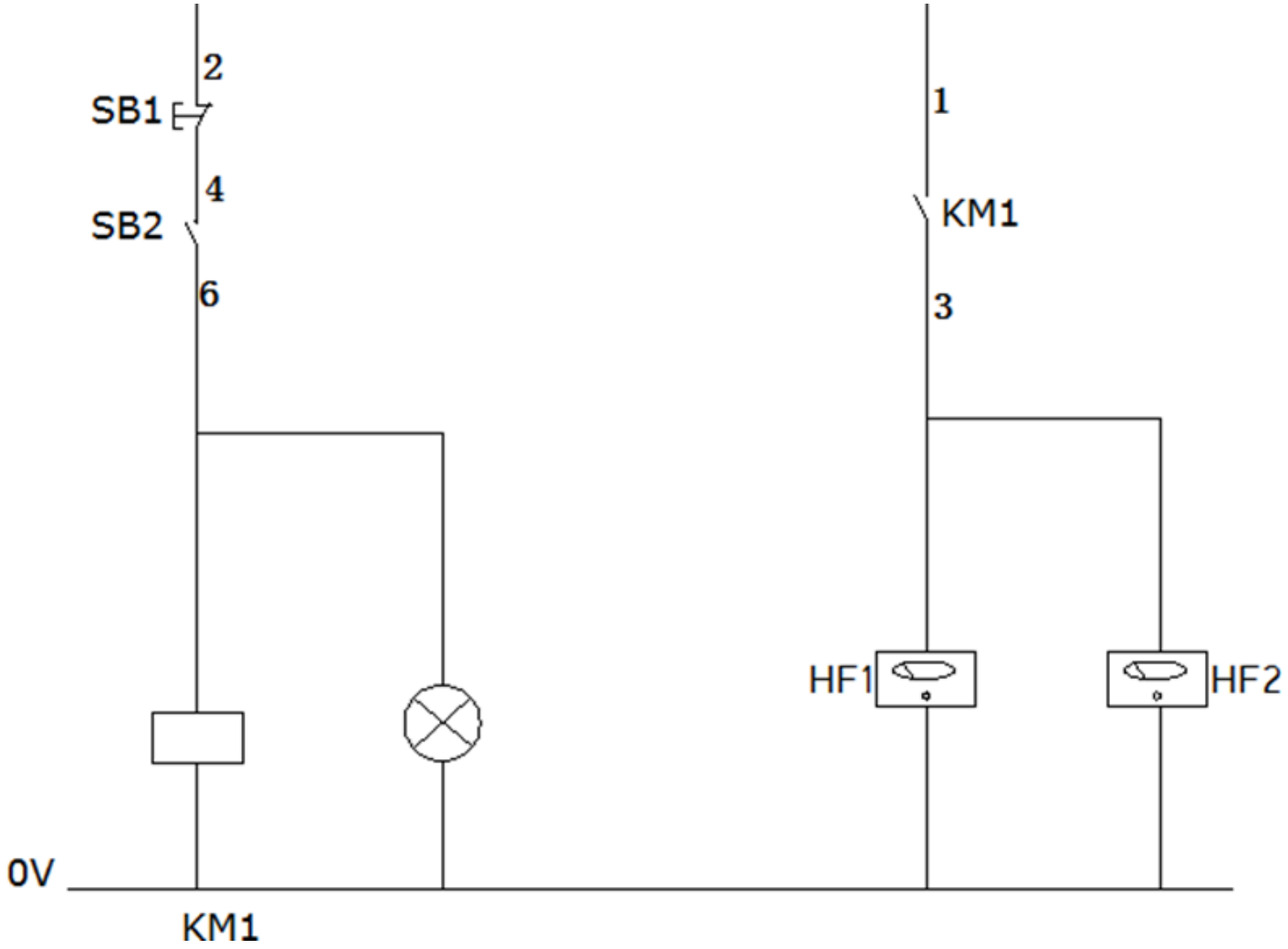
QF: Power Switch	SB1 : Emergency Stop	KM : AC Contractor	VFD: Converter
B: Transformer	SB2 : Power Switch	FU: Fuse	HF: Tachometer

4.3 Electric Box Diagram

Converter and digital parameters already settled, Please do not change anyhow to avoid any equipment troubles.



4.4 Control Box Diagram



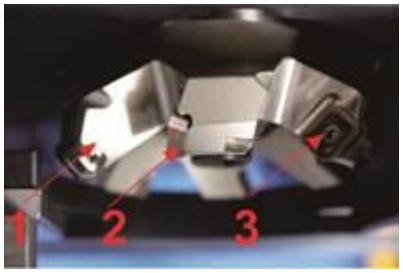
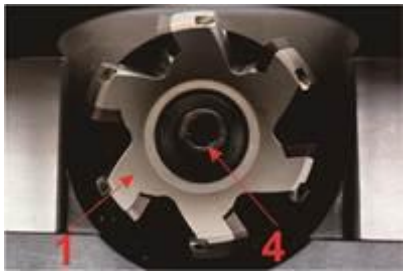
4.5 Common Protection Measures

1. Electrical connections and protective devices must comply with local regulations and standards.
2. The cable connection should have one side connected to the aviation plug and the other side connected to the power supply.
3. Do not operate the machine in a humid environment, as this may cause electrical hazards.
4. When feeding the plate, follow the operating instructions carefully — the inserts should only make contact with the plate after the cutter is rotating.

4.6 Cutter & Insert Replacement

<table>
<tr>
<td>  </td>
<td>Cutter Head and Insert Replacement

Ensure the power is switched off before replacing the cutter head or inserts.

● Be cautious of the sharp edges of the inserts and the high temperature of components immediately after operation to avoid injury.
● It is recommended to clean the area before replacement and to wear protective gauntlets (cut-resistant gloves).</td>
</tr>
<tr>
<td> 
</td>
<td>Insert Replacement
● Adjust the cutter head to a suitable angle for insert replacement. (Refer to the photo where “1” indicates the cutter head, “2” the inserts, and “3” the screws.)</td>
</tr>
<tr>
<td>  </td>
<td>Insert Replacement
● Using a T15 screwdriver, remove the screws (labelled “3”) to take out and replace the inserts (labelled “2”).</td>
</tr>
<tr>
<td> 
</td>
<td>Cutter Head Replacement

● Adjust the cutter head to a suitable angle for replacement.
Secure the cutter head (labelled “1”) in place with a supporting rod or stick to ensure it does not rotate during the process.</td>
</tr>
</table>

5. Coolant System

5.1 Coolant System

The cooling system is still under study and developing. We will update this range once machine with this function.

5.2 Use of Cooling System

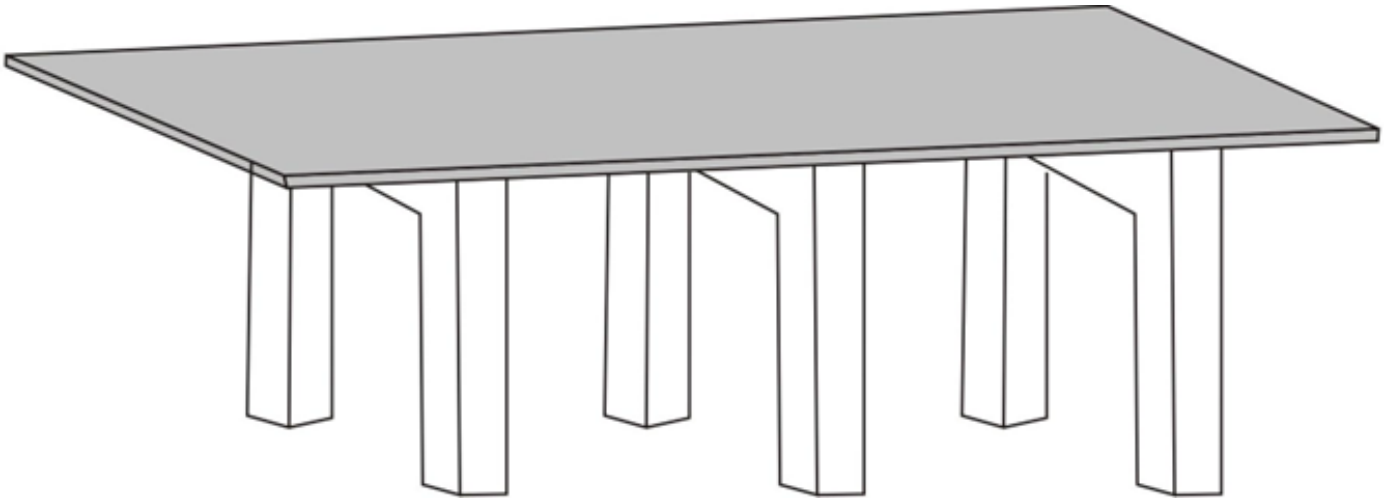
The cooling system for the SMG Rapid-Edge 100M Milling Type Plate Beveling Machine is currently under development. Details and installation instructions will be provided once the system is available.

6. Bevel Preparation

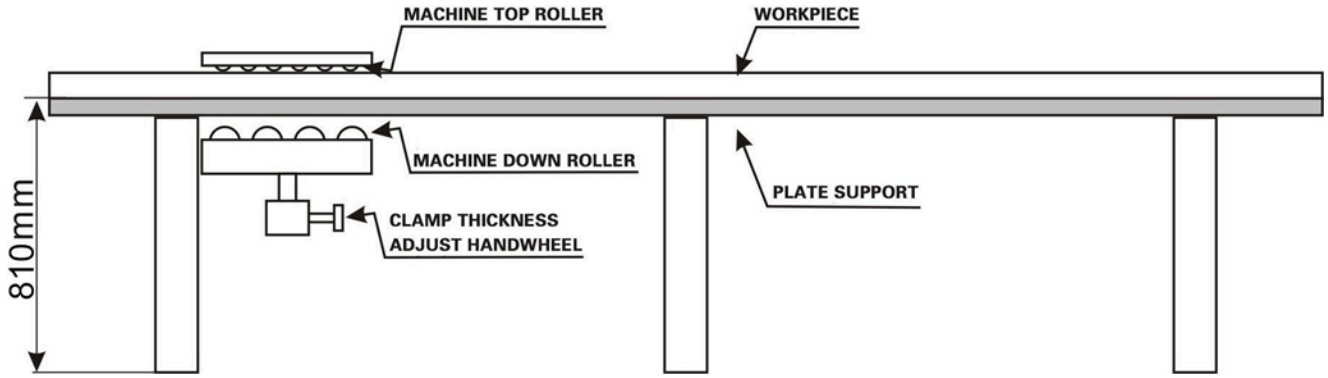
	**Operation and Feeding Depth Setup** During operation, the initial feeding depth must be set according to the type and properties of the plate material. Operating the machine beyond its designed performance range may cause serious issues such as gear wear, insert damage, or main shaft failure. When setting the bevel parameters, all plate characteristics must be carefully considered — particularly the increased hardness that occurs after oxygen cutting.

6.1 Placement

1. Prepare a simple plate support as shown in the reference image below. (Image is for illustration purposes only.)

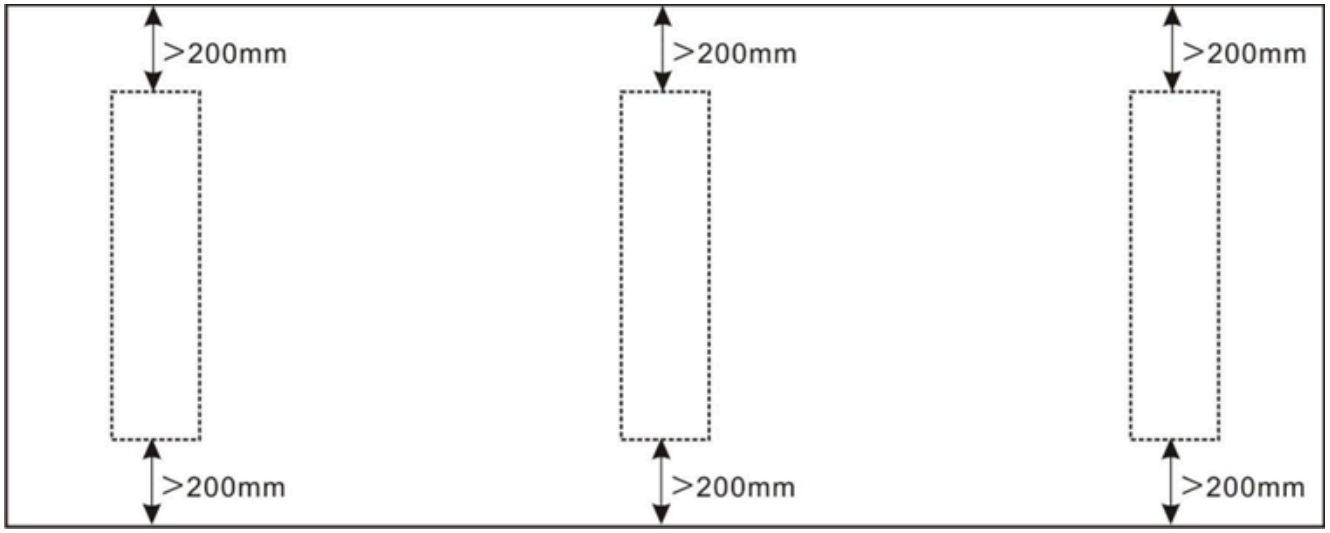


2. Support Height
    - It is recommended to set the support height between 790 mm and 810 mm for a plate thickness of 20 mm.
    - If the plate thickness range is uncertain, set the support height to 790–810 mm plus an additional 20 mm to allow for variation.



3. Workpiece Placement

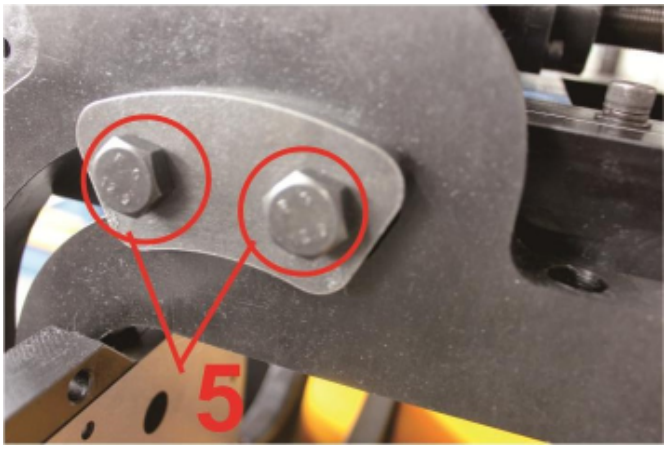
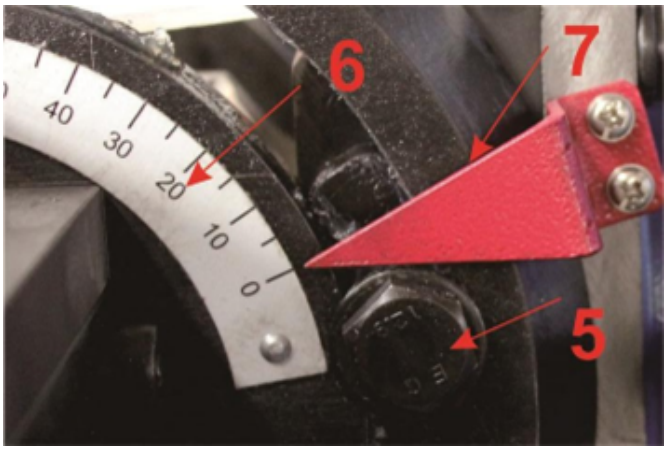
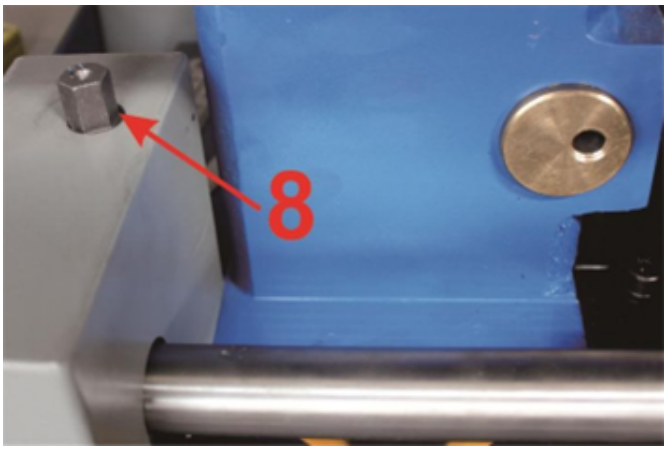
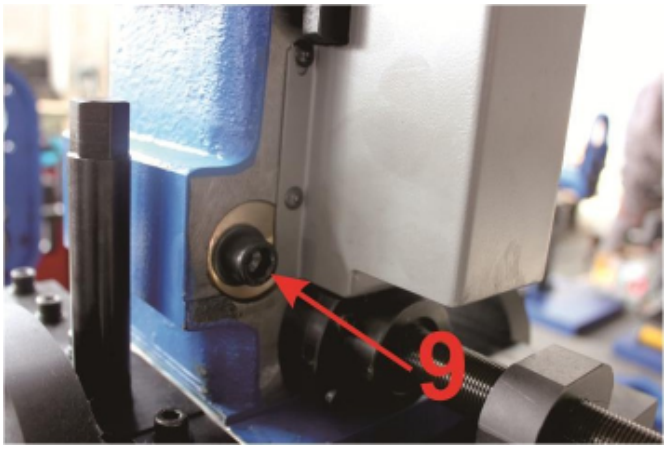
Place the metal plate on the support as shown below, ensuring the beveling edge extends approximately 200–250 mm beyond the support.

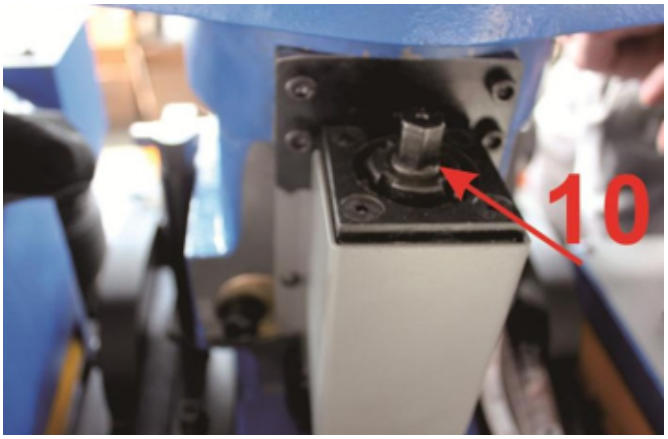


6.2 Plate Clearance

Clear up the plate surface to avoid any welding tumor and crater（Burrs,tumor and crater will affect the Inserts and machine life time)

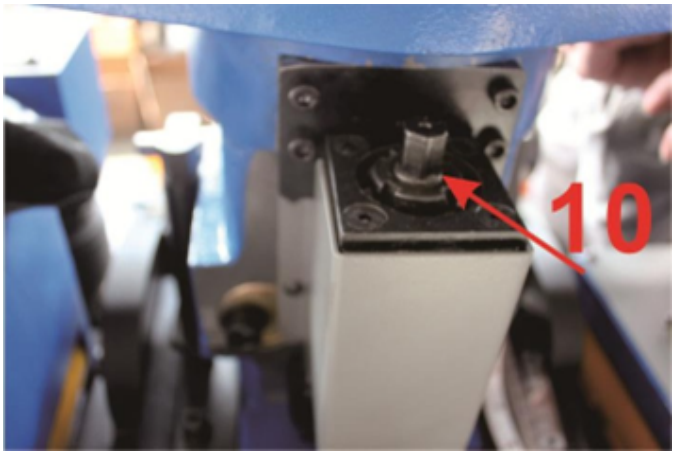
6.3 Bevel Angle & Bevel Depth Adjustment

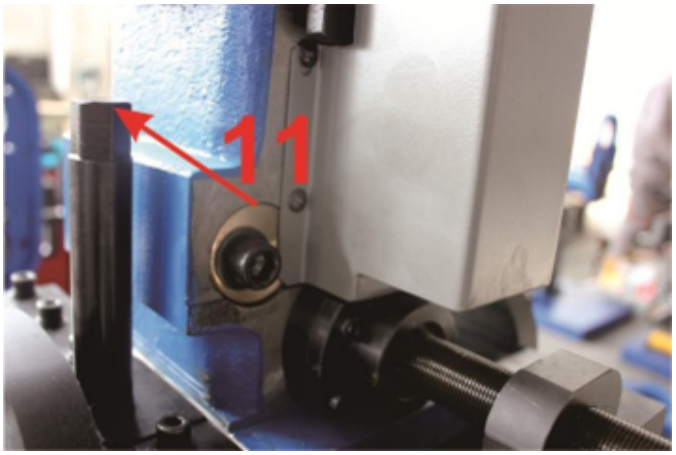
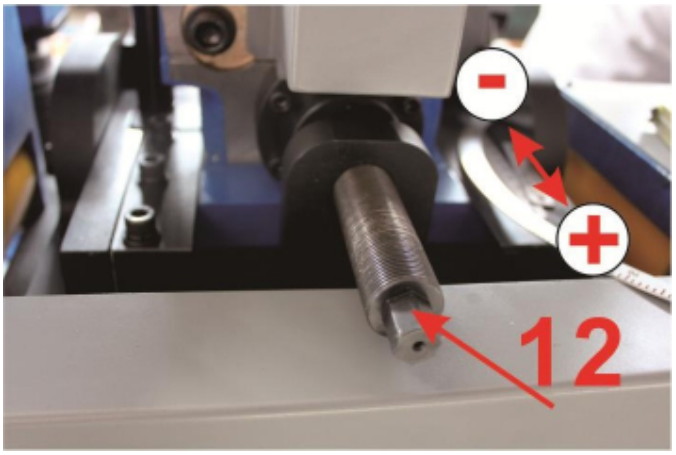
	**Bevel Angle Adjustment** 1.Loose bolt “5”
	**Bevel Angle Adjustment** “6”-Angle Ruler、“7”-Angle Indicator Arrow
	**Bevel Angle Adjustment** 2.Rotate the Ratchet Wrench “8” and adjust required angle. After that tighten the bolt “5” NOTE：Adjusting the “b” on the ratchet wrench can change the rotate direction of angle.
	**Bevel Depth Adjustment** 1. Loose bolt “9”

	**Bevel Depth Adjustment** 2. Rotate hand wheel “10”, and adjust to required bevel depth according to the scale parameter table and required bevel width. NOTE: Parameters for reference, Please refer to the actual bevel size after first testing.

6.4 Plate Clearance

- Before operation, clean the plate surface thoroughly to remove any weld spatter, burrs, or craters.
- These surface defects can damage the inserts and reduce the machine’s service life.

	**Feeding Depth (d) Adjustment** 1. Adjust the bevel angle to 90 degrees on the machine (refer to the photo). Note: This operation applies only when performing beveling at a 0-degree angle.
	**Feeding Depth【d 】Adjustment** 2. **Adjust the feeding of 1-3mm** by hand wheel(Stainless is 1-1.5mm).The feeding scale value of hand wheel to 19 for d=0(FOR REFERENCE ONLY, Subject to actual testing data.)

	**Feeding Width【e】Adjustment** 3. Loose four bolts fixed between spindle and literal adjustment plate【11】
	**Feeding Width【e】Adjustment** 4. Rotate Bolt【12】, 【e】is becoming smaller when the scale is turned to "-" direction. While turned to "+", become bigger.

6.5 Processing Bevel Type Of "0" Degree & "U"Type Adjustment:

	1. Adjust required bevel angle "a" of U type (Refer to 9.3 Bevel Angle Adjustment 2. Adjust width【e】(Refer to 9.4) 3. Adjust feeding depth【d】Refer to 9.3)

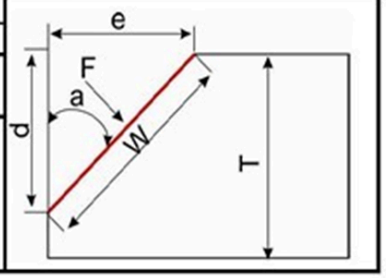
NOTE: When processing "U" bevel type, it only can process when the cutter head is higher than the lower surface of the workpiece.The single feeding depth at the bottom of "U" Type should be controlled between 2-5mm.

F / a / d	5°	10°	15°	20°	22.5°	25°	30°	35°	37.5°	40°	45°	50°	55°	60°	65°	70°	75°	80°	85°
4	6.3	5.7	4.8	4.2	3.7	3.7	3.8	3.8	4.0	4.4	5.0	6.1	7.3	8.7	10.6	12.6	14.7	16.9	19.4
6	6.5	6.0	5.4	4.9	4.5	4.5	4.8	4.9	5.3	5.7	6.4	7.6	8.9	10.4	12.4	14.4	16.6	18.9	21.4
8	6.7	6.4	5.9	5.5	5.3	5.4	5.8	6.1	6.5	6.9	7.9	9.1	10.6	12.1	14.3	16.3	18.5	20.9	23.4
10	6.9	6.7	6.4	6.2	6.0	6.2	6.8	7.2	7.7	8.2	9.3	10.7	12.2	13.9	16.1	18.2	20.5	22.8	25.4
12	7.0	7.1	6.9	6.9	6.8	7.1	7.8	8.4	8.9	9.5	10.7	12.2	13.8	15.6	17.9	20.1	22.4	24.8	27.4
14	7.2	7.4	7.4	7.6	7.6	7.9	8.8	9.5	10.1	10.8	12.1	13.7	15.5	17.3	19.7	22.0	24.3	26.8	29.3
16	7.4	7.8	7.9	8.3	8.3	8.8	9.8	10.7	11.3	12.1	13.5	15.3	17.1	19.1	21.5	23.8	26.3	28.8	31.3
18	7.6	8.1	8.5	9.0	9.1	9.6	10.8	11.8	12.6	13.4	14.9	16.8	18.7	20.8	23.3	25.7	28.2	30.7	33.3
20	7.7	8.5	9.0	9.6	9.9	10.5	11.8	13.0	13.8	14.7	16.3	18.3	20.4	22.5	25.1	27.6	30.1	32.7	35.3
24	8.1	9.2	10.0	11.0	11.4	12.1	13.8	15.3	16.2	17.2	19.2	21.4	23.7	26.0	28.8	31.4	34.0	36.6	39.3
28	8.4	9.9	11.0	12.4	12.9	13.8	15.8	17.6	18.6	19.8	22.0	24.4	26.9	29.4	32.4	35.1	37.8	40.6	43.3
30	8.6	10.2	11.6	13.1	13.7	14.7	16.8	18.7	19.9	21.1	23.4	26.0	28.6	31.2	34.2	37.0	39.8	42.5	
34	9.0	10.9	12.6	14.4	15.2	16.4	18.8	21.0	22.3	23.7	26.2	29.0	31.9	34.6	37.8	40.7	43.6		
38	9.3	11.6	13.6	15.8	16.7	18.1	20.8	23.3	24.7	26.2	29.1	32.1	35.1	38.1	41.4				
40	9.5	11.9	14.2	16.5	17.5	18.9	21.8	24.4	26.0	27.5	30.5	33.6	36.8	39.8					
44	9.8	12.6	15.2	17.8	19.0	20.6	23.8	26.7	28.4	30.1	33.3	36.7	40.0	43.3					
48	10.2	13.3	16.2	19.2	20.6	22.3	25.8	29.0	30.8	32.7	36.1	39.8	43.3						
50	10.4	13.7	16.7	19.9	21.3	23.1	26.8	30.2	32.0	33.9	37.6	41.3							
54	10.7	14.4	17.8	21.3	22.9	24.8	28.8	32.5	34.5	36.5	40.4								
58	11.1	15.1	18.8	22.6	24.4	26.5	30.8	34.8	36.9	39.1	43.2								
60	11.2	15.4	19.3	23.3	25.2	27.4	31.8	35.9	38.1	40.4									
64	11.6	16.1	20.4	24.7	26.7	29.0	33.8	38.2	40.6	42.9									
68	11.9	16.8	21.4	26.1	28.2	30.7	35.8	40.5	43.0										
70	12.1	17.2	21.9	26.7	29.0	31.6	36.8	41.7											
74	12.4	17.8	23.0	28.1	30.5	33.3	38.8												
78	12.8	18.5	24.0	29.5	32.0	35.0	40.8												
80	13.0	18.9	24.5	30.2	32.8	35.8	41.8												

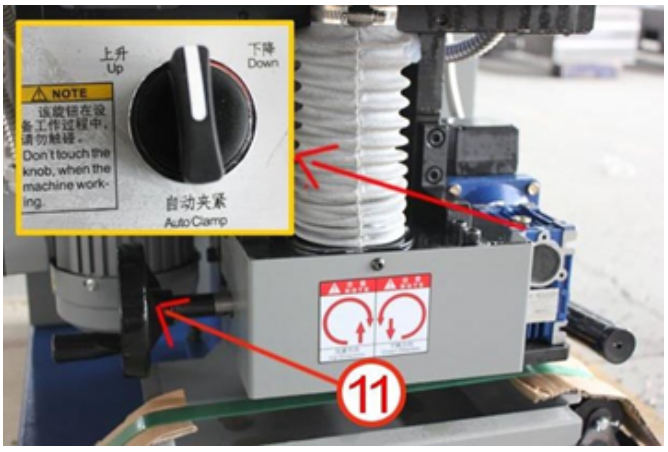
d：加工坡口深度　e：刻度值
a：坡口角度　W：坡口宽度

0度时：0位刻度值8
90度时：0位刻度值18

注：
1.参数仅供参考，以实际加工数值为准；
2.不同颜色代表分次进给。
3.材质不同适当减少进给量，本表格适用低碳钢和铝合金。



6.6 Clamp Thickness & Machine Height Adjustment:



Clamp Thickness Adjustment
Rotate hand wheel“11” to clamp the work piece

Machine Height Adjustment

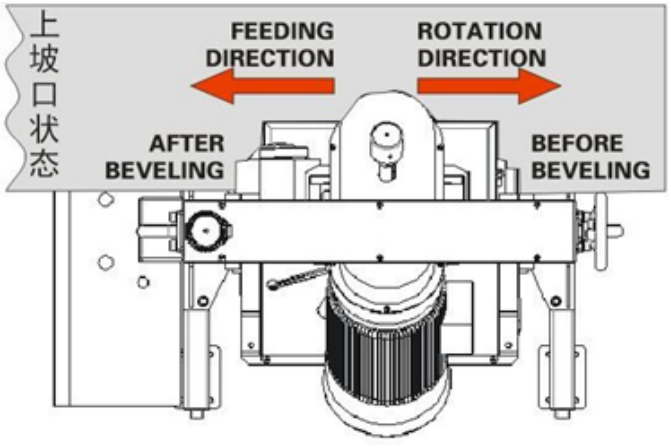
1. Lifting: Rotate bolt “12” clockwise and repeatedly press handle “13”.
2. Lower : Rotate bolt “12” counterclockwise to adjust required height and then rotate to the cut off position.

6.7 Speed Adjustment

Spindle Speed and Feeding Speed Adjustment
“4” is spindle speed adjust
“6” is feeding speed adjust

Note: Operator can do adjustment on the feeding speed and spindle speed on control panel when process different metal material

6.8 Feeding Route



1. Ensure the machine is operated on a flat and stable floor. If the surface is uneven, place a metal plate on the floor to provide a level path for the machine to move.

2. Confirm the feeding direction is correct before starting.

Note: Before feeding, make sure the cutter rotates in the correct direction, and the inserts do not contact the plate until feeding begins.

	 Machine beveling direction should walk along with the red direction.

7. Basic Operation

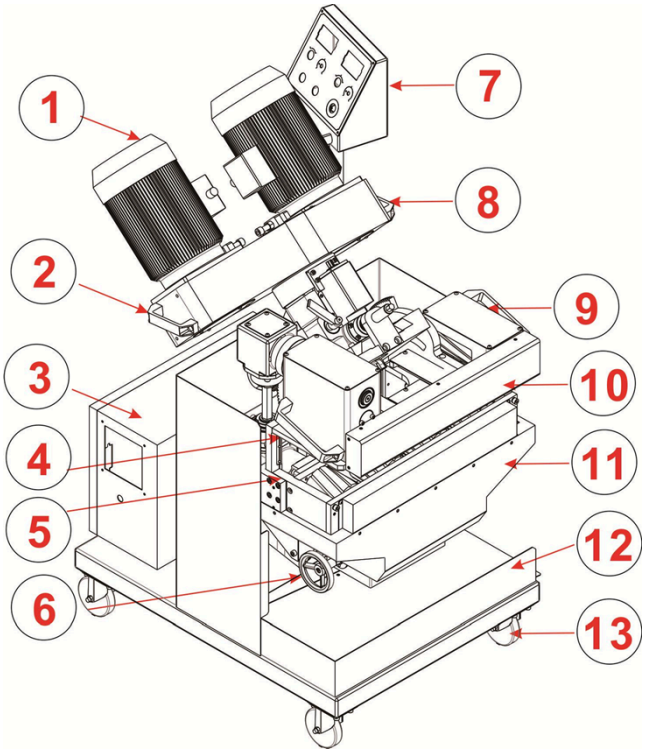
- Do not operate the machine continuously for more than 4 hours.
- After extended operation, the reducer temperature may rise. Allowing a cooling or idle period will help dissipate heat and maintain thermal balance within the mechanism.
- In the event of overloading, the thermal protection element in the electrical box will activate and cut off the power supply.
    - Wait until the machine has cooled sufficiently, then reset the thermal element.
    - If the element is reset too early, the machine will shut down again.

7.1 Machine Parts Introduction

1 Control Panel

- Feed Speed Meter – Displays the current cutting speed.
- Feeding Speed Display – Shows the current feeding speed.
- Spindle Switch – Controls the cutting spindle power.
- Spindle Speed Control Knob – Adjusts the cutting spindle speed (range: 750–1500 r/min, subject to actual testing).
- Direction Control Knob – Sets the feeding direction (forward or reverse).
- Feeding Speed Control Knob – Adjusts the feeding speed (range: 0–1500 mm/min).
- Power Indicator Light – White light illuminates when the machine is powered on.
- Safety Lock – Prevents unauthorised operation. The key should be kept by the operator or warehouse manager.
- Emergency Stop Button – Press immediately in case of an emergency to cut off all power to the machine.

2. Full Machine



1. Cutting Spindle Motor – Powers the cutting spindle.
2. Belt Cover – Protects the drive belt and enhances operator safety.
3. Electrical Box – Houses the machine's electrical components and controls.
4. Wear Block (Limit Block) – Prevents excessive movement and provides positioning limits.
5. Down Pressing Roller – Applies downward pressure to secure the workpiece.
6. Hand Wheel – Used to adjust the pressing force on the workpiece.
7. Control Box – Manages and controls the machine's operating functions.
8. Hand Wheel – Secondary hand wheel for fine adjustment (if applicable).
9. Upper Pressing Roller Set – Holds and guides the upper portion of the workpiece.
10. Upper Pressing Roller Drive System – Drives the upper rollers for consistent feed.
11. Lower Support Wheel Assembly – Provides stable support for the plate during operation.
12. Chip Flutes – Direct and remove metal chips during beveling.
13. Walking Wheel – Enables machine movement along the workpiece.

7.2 Speed Setting Reference Table

Parameters for reference only, Higher bevel width, lower speed, please refer to the actual situation)

- **The workpiece must not be positioned beyond the red line.**
- **The area between the red and green lines is the "Low Speed Area" for starting.**
- **After the green line (cutter head), it becomes the "Speed-Up Area."**
- **When the plate end approaches the red line, it enters the "Completion Area."**
- **Wend close to red line should be "Complete area".**

Material	Low Seed Area	Speed Up Area	Complete Area	Diagram

Q235	150-250	300-800	300-500	
45#	150-250	300-700	300-500	
16Mn	150-250	300-600	300-500	
AL	150-250	300-1000	300-800	
306	150-200	200-500	200-300	
316L	150-250	200-400	200-300	

7.3 Basic Operation

Small Plate Beveling:
This is a manual operation where you adjust the required bevel type, angle, depth, cutting speed, and feeding speed before starting the process. (Applicable only toSMG Rapid-Edge 100M)

Large Plate Beveling:
When beveling large metal plates, place the plate on the auxiliary support attachment. Then adjust the required bevel angle, depth, feeding speed, and cutting speed on the machine to complete the operation. (Applicable only to SMG Rapid-Edge 100M.)

7.4 Operation Steps

1. Workpiece Positioning:
    - Ensure the workpiece is placed firmly against the feeding limit block.
    - Keep a distance of 10–15 mm between the leading edge of the plate and the cutter head.

2. Workpiece Clamping:
    - Refer to Operation 9 for clamping instructions.

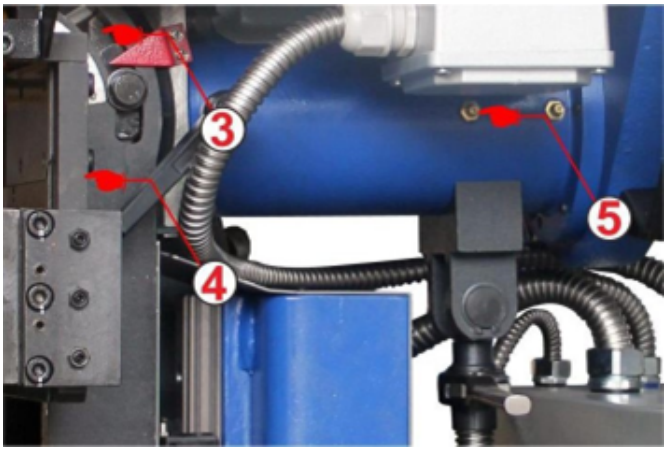
3. Start Milling:
    - Turn on the power, then start the spindle.
    - Allow 5–10 seconds for the spindle to reach a stable rotation speed before beginning the feeding operation.

	**After Beveling:** Stop the feed, turn off the spindle, and loosen the clamping wheel. Then, reset the feeding speed to “0.”

8. Lubrication & Cleaning

11. Lubrication & Cleaning		
Lubrication Location	**Lubricating Method**	**Lubricating Method**
Complete machine	Spray anti-corrosion oil, remove iron pin, and a dust-proof cover, straight in a dry place	3 months or a long time not to use
3 months or a long time not to use	Use a broom to clean up in time, so as to avoid excessive accumulation of equipment.	Clean up according to the actual situation
Reducer	Clean up the scraps by air compressor	While needed
	Add Gear oil	Life free maintenance
Control/Electric Box	Cover with dust and rain shield	When long time not to use
Inserts	Replace Inserts and screws in time when any broken found	Replace Inserts and screws in time when any broken found
Inserts Screw	If the knife is broken in the tray, please use the drill out	As per manual point 7
Main Shaft	Inject lubricating oil into the inlet on the side of spindle（Can not use grease instead)	Once every 3 months

	Lubricating Oil Injection and Scrap Cleaning: “1” Lead Screw: Adjust the thickness as needed, clean off any scraps, and spray anti-corrosion oil once a month. “2” Guide Rail: Clean iron scraps daily. If the machine will not be used for an extended period, spray lubricant to protect it. Note: You may use WD-40 as the anti-corrosion oil.

	Lubricating Oil Injection and Scrap Cleaning: “3” Angle Hole: Clean iron scraps before adjusting the angle, and spray anti-corrosion oil once a month. “4” Guide Rail: Clean iron scraps daily, and apply anti-corrosion oil once a month. “5” Lead Screw: Spray anti-corrosion oil once a month.

9. Common Troubleshooting, Repair and Maintenance

NO.	Fault		Maintenance & Repair
1	No response from electrical equipment	No electricity	Check the wire of electricity
		Broken Line, Poor Connect	Check if anywhere broken line or poor connection
2	Electrical OK, Still no response	Emergency on	Rotate the emergency button
		Power lock not open	Move the key on the panel
3	Rotation Error	Spindle Rotate Error	Change the wire line sequence
		Feed motor rotate Error	Check the "Feed switch "" L or R" on panel"
4	Abnormal Noise	From Motor	Power supply shortage
		From Gear	Gear wear, inject with lubrication oil
5	Spindle not run	Over load	Power off and reset on the "Disconnector" （Refer to point 7）
		Lock nut off	Lock up the Jam Nut (Overload)
		Bearing Broken in main shaft	Replace the Bearing
6	The compression can't be tightened		Check if any scraps stick on the rollers or plates
7	Workpiece ejected or deflected		Ensure if the feeding direction correct with request
8	Serious Spark during Operation	Overload	Reduce the bevel depth or speed,can add coolant properly when process stainless steel plate

		The Inserts wear	Replace Inserts
9	Inserts smashed with work piece		Check if the inserts already contact with plate before feeding
10	Can't process with thin plate		Specified Working range for machine, Contact with supplier
11	Inserts cracks once start beveling		Reduce feeding depth
12	Feed wheel not working		Check if any problem on the feeding gear
13	Artifacts Skid	Low friction coefficient	Increase the friction of feed wheel and add force to the conveyor
		Feed speed doesn't match	Reduce feeding speed
14	Electric control Error or any others		Contact with supplier in time

10. Packing List

NO.	Description	Model	Qty	Unit	Remark
1	Plate Beveling Machine	SMG Rapid-Edge 100M	1	Set	
2	Cutter Head	Φ100mm	1	PC	Including the set on the spindle
3	Insert	100M Use	2	Set	Including the set on cutter head
4	Insert Screws		2	Set	Including the set on cutter head
5	Hex Wrench		1	Set	
6	Hex Wrench	V12	1	PC	Use for install cutter head
7	Wrench	19	1	PC	Use for angle tighten screws
8	Ratchet Wrench	17/19	1	PC	
9	Ratchet Wrench	13/16	2	PC	
10	Knife Wrench	T15	1	PC	For Insert Replacement
11	Industrial Plug	4075	1	Set	Imported(On Electric Box)
12	Tool Kit	4111	1	PC	
13	Universal Wheel	5001	4	PC	Walking Wheel
14	Screws	M8*16	16	PC	For fixing universal wheels

15	Operation Manual		1	PC	
16	Package Box	Wooden	1	PC	Fumigation-Free Export Package