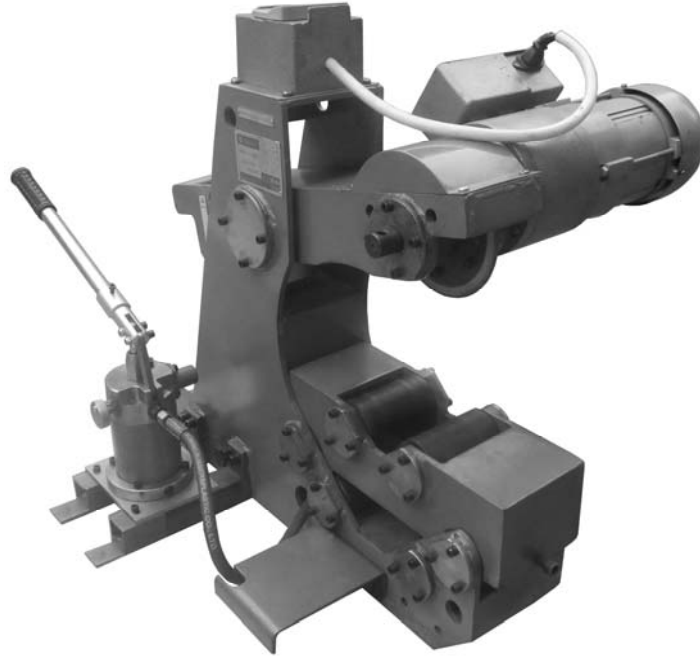




Please read this operation manual carefully before use.



## **QINGYANG Pipe Cutting Machine**

**QG325-A- II**

**QG325-MB- I**

**QG325-MB- II**

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# I General Safety Instructions



Warning! Please read and follow all the safety rules for operation, any violation of the safety rules may cause electric shock, fire or personal injury.

## 1. Safety Rules for Work Site

1.1 Keep the work site clean and bright, disordered and dark site may cause accident.

1.2 It is not allowed to operate the electric machine in an environment with flammable liquid, gas or dust, which may easily cause explosion. The spark generated by the electric machine will light up the dust or gas.

1.3 Unrelated personnel, children and visitors should be kept far away from the site of the electric machine. Absent-minded operation will make the operator lose control of the machine.

## 2. Electrical Safety

2.1 The plug of the electric machine must be matched with the socket. It is prohibited to refit the plug in any way. It is not allowed to use any adaptor plug for the electric machine which needs grounding. The original plug and matched socket could reduce the risk of electric shock.

2.2 It should be avoided that human body gets contact with the grounding surface, like pipe, heat sink . Human body grounding will increase the risk of electric shock.

2.3 It is not allowed to expose the electric machine in the rain or in the humid environment. It will increase the risk of electric shock in case water enters the electric machine.

2.4 It is not allowed to abuse the power line. It is forbidden to use the electric wire to carry or haul the electric machine or remove the plug by pulling the wire. Keep the power line away from the heat source, oil, sharp edge or moving parts. The damaged or winded flexible line will increase the risk of electric shock.

2.5 When operating the electric machine in the open air, please use the external flexible line which is suitable for use in the open air. It will reduce the risk of electric shock.

2.6 If it is inevitable to operate the electric machine in a humid environment, the residual

current protector device RCD (leakage protector) should be used to reduce the risk of electric shock.

2.6.1 For single 220V electric machine, 2-pol 2-line RCD should be used in priority.

2.6.2 For 3-phase 4-line 380V electric machine, 3-pol 4-line RCD or 4-pol 4-line RCD should be used in priority.

2.6.3 For 3-phase 3-line 380V electric machine, 3-pol 3-line RCD should be used in priority.

### **3. Personal Safety**

3.1 Keep alert. When operating the electric machine, pay close attention to the operation and keep clear-minded. When you feel tired, or have a drug, alcohol or treatment reaction, do not operate the electric machine. In the operation of electric machine, momentary negligence may cause serious personal injury.

3.2 Please use personnel protective device. Wear goggles during operation. Dust mask, antiskid shoes, safety helmet and hearing protection device must be used in corresponding situation.

3.3 Prevent unexpected start-up. Insure the switch is off when connecting the power supply, lifting up or moving the machine. It may cause danger if putting fingers on the alive switch or inserting the plug when the switch is on.

3.4 Before the electric machine is turned on, take off the tools (such as spanner, etc.) left on the rotary components of the electric machine to avoid personal injury.

3.5 Do not stretch your arms too far. Watch your foothold and keep body balance, so that the electric machine is well controlled in case of unforeseen circumstances.

3.6 Dress properly. It is not allowed to wear gloves, loose clothes or decorations. Keep clothes and hair away from the moving parts. Gloves, loose clothes, decorations or long hair may get involved in the moving parts to cause serious personal injury.

### **4. Operation and Points for Attention of Electric Machine**

4.1 Do not abuse the electric machine, use the proper electric machine according to your application. Choosing the properly designed electric machine will make your work more efficient and safer.

4.2 If the power can not be **turned on or off** by the switch, it is not allowed to use the electric machine. The electric machine which can not be controlled by the switch is dangerous, it must be repaired.

4.3 The power plug must be removed from the socket before any adjustment, or replacement of accessories, or storage of the electric machine. These protective measures will reduce the risk of unexpected start-up of the machine.

4.4 Store the unused electric machine out of the reach of children. And the person who is not familiar with the electric machine or does not understand the instructions is not allowed to operate the electric machine. If there is damage, the electric machine should be repaired before use. A lot of accidents are caused by poorly maintained machines.

4.5 Use the electric machine, its accessories and cutting tools according to the operation manual with consideration of the operation conditions and practical work. It may cause danger if the electric machine is used for the purpose other than its designed application.

### **5. Repair Service**

Send the electric machine to professionals for repair with original spare parts. This will ensure the safety of the repaired electric machine.

## 6. Safety Operation of Pipe Cutting Machine

6.1 The pipe cutting machine series are used for cutting welded and seamless steel pipes. please comply with the instructions of the operation manual. It will increase the risk of injury if it is used for other purposes.

6.2 Please fix the machine on the flat ground or working bench to prevent the machine from turnover.

6.3 Please use the pipe stand to support longer and heavier pipe to prevent the machine from turnover.

6.4 It is not allowed to wear gloves and loose clothes. Please do not bend over the machine because the clothes may get involved in the rotary parts to cause winding and injury.

6.5 Please tighten the chuck before turning on the machine to prevent the pipe from swinging.

## II Operation Instructions

QINGYANG cutting machines are manufactured as per Q/20193365-9.20

### 1. Function

QINGYANG pipe cutting machine series are used for cutting welded and seamless steel pipes. It can be also used for cutting ductile iron pipe of the same specifications. It is an ideal tool for pipe work in construction and installation sectors.

### 2. Main Parts

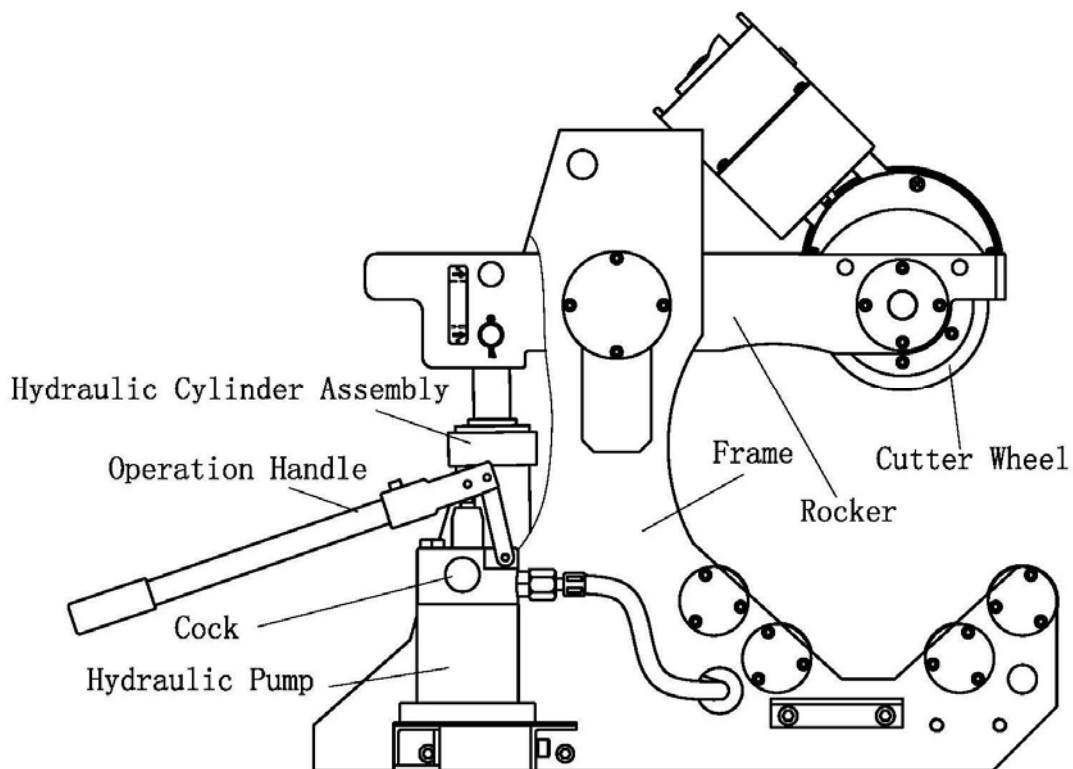


Fig.1  
3

### 3. Main Technical Parameters

Table 1

Model		QG325-A- II	QG325-MB- I	QG325-MB- II
Capacity	Pipe diameter	50-300 (2"-12")	50-300 (2"-12")	50-300 (2"-12")
	Wall thickness	3-7mm	3-10mm	3-10mm
Spindle speed		22 r/min.	22 r/min.	22 r/min.
Motor		YYT1000 1KW 220V 50Hz 2800 r/min	DOT9012GA(s) 1.5KW 220V 50Hz 3300r/min	DOT9012GAT 1.5KW 220V 60Hz 3300 r/min
Capacitor		450V 30 $\mu$ F	450V 60 $\mu$ F	450V 50 $\mu$ F
Hydraulic parameters	Hydraulic Pump Pressure	30Mpa	30Mpa	30MPa
	Cylinder Stroke	100mm	60mm	60mm
	Oil tank capacity	500mL	500mL	500mL
	Hydraulic Pump displacement	1.5mL	1.5mL	1.5mL
Cutter wheel working force		25000N	28000N	28000N
Weight		95kg	102kg	102kg
External dimensions		800×690×650	800×740×660	800×740×660

### 4. Operation Installation

#### 4.1 Preparation

4.1.1 The pipe cutting machine is required to be fixed on concrete ground for operation. The cutting machine and the pipe stand should be fixed with ground screw bolts.

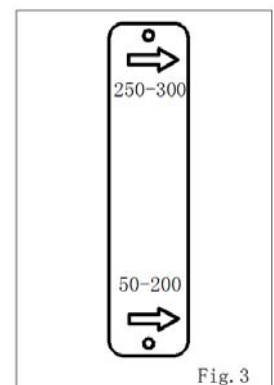
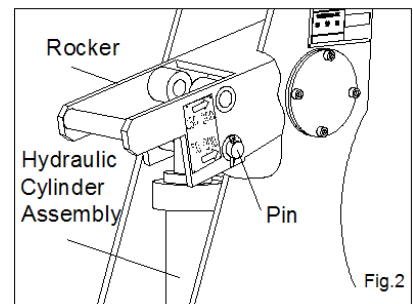
4.1.2 Before operation, operate the operation handle to check the hydraulic pump if it is normal or not. (See Fig.1)

4.1.3 Connect the power supply, turn on the switch to run the cutting machine without load to check if it is normal.

4.1.4 For QG325-A- II /MB- I /MB- II cutting machines, adjust the position of the rocker pin according to the pipe size to be cut (See Fig.2).The nameplate near the pin shows the instructions. (See Fig.3)

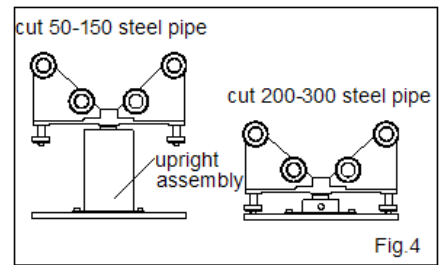
4.1.5 For the pipe stand of QG325-A- II / MB- I /MB- II , the upright assembly is used for 50-150 steel pipe cutting, remove the upright assembly for 200-300 steel pipe cutting. (See Fig.4)

4.1.6 The pipe stand is available for slight adjustment in height to make the pipe to be cut in a horizontal level. This adjustment can be done by putting a reinforced bar into the hole of the screw nut of the stand and turning the nut to make it touch tightly the base of the pipe stand so as to avoid shaking of the stand.



#### 4.2 Pipe Cutting

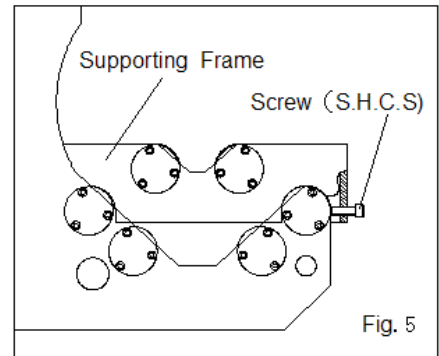
4.2.1 Tighten the cock of the hydraulic pump, operate the operation handle to make the cutter wheel touch the pipe with a little pressure, and then turn on the pipe cutting machine. It is suggested to operate the operation handle once in one or two pipe revolutions. For steel pipe with wall thickness thicker than 6mm, it is required to feed the cutter wheel slowly, otherwise it will cause a serious pipe mouth contraction, reduce the service life of the cutter wheel, or stop the rotation and have the motor burned.



4.2.2 Switch off the power to stop the cutter wheel.

4.2.3 Release the cock, the rocker (for QG325-A- II / MB- I /MB- II ) will bring the cutter wheel to return its original position automatically, and then take out the pipe.

4.2.4 The pipe cutting machine can not be used to cut bent steel pipes.



4.2.5 The pipe cutting machine is characterized by extrusion cutting, the end face of the pipe is cut with a slant, it is suggested that it should be trimmed before use.

4.2.6 For pipe end face grinding, the cut pipe can be pressed and made to roll with the aid of the wheel holder behind the cutter wheel, and then grind the pipe end face with a grinding machine.

4.2.7 For QG325-A- II / MB- I /MB- II cutting machines, the supporting frame can be mounted with hex screws (fixed slightly) to cut 50-125 steel pipes, as shown in Fig.5.

## 5. Points for Attention

5.1 The normal operation conditions for the pipe cutting machine: the height above the sea level is no more than 1000m; the environment temperature is from  $-5^{\circ}\text{C}$  to  $+40^{\circ}\text{C}$ ; the relative humidity is no more than 90% ( $25^{\circ}\text{C}$ ).

5.2 It is not allowed to open or adjust the relief valve of the hydraulic pump.

5.3 The pipe mentioned in this manual means the welded pipe or welded galvanized steel pipe under the standard GB/T3091 and GB/T13793. The service life of the cutter wheel will be shortened if the pipe cutting machine is used to cut seamless steel pipes.

5.4 The pipe cutting machine is characterized by extrusion cutting, so the demand that requires no pipe mouth contraction can't be met.

5.5 The mouth of the pipe should be cleaned of its burs with grinding machine.

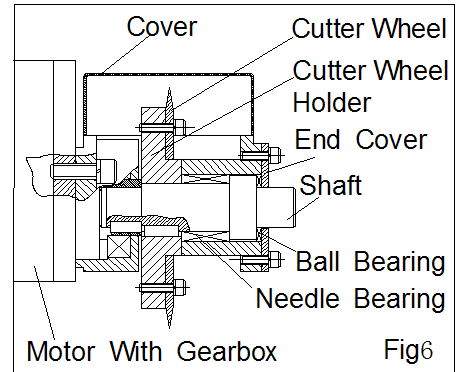
5.6 In maintenance and repair of the pipe cutting machine, it should be noted that no needle of the needle bearing is allowed to lose, even just one. If the needle is lost, it should be replenished. If the needle falls off, it is suggested that the needle should be stuck onto the bearing with grease for

assembly.

5.7 The replacement of the cutter wheel should be carried out as per Fig.6.

5.8 In the adjustment for different pipe diameter cutting, it is suggested to draw out the cylinder pin first. At this moment, the slide carriage must be held. When the cylinder pin is inserted, since the pin hole is invisible, it is suggested that this work should be done by cooperation of two persons so as to avoid damage of the parts and safety accident.

5.9 Special attention should be paid in cutting seamless steel pipe due to its high intensity and rigidity. Especially, it is easy for the cutter wheel to be nipped and damaged when the pipe is nearly cut off, which may possibly cause a serious result of turnover of the pipe cutting machine. So, the pipe cutting machine must be fixed with ground screw bolts on the ground.



## 6. Electrical Principle and Safety

The electrical principle diagram is shown in Fig.7.



### Warning!

6.1 The pipe cutting machine uses a capacitor motor, its starting torque is relatively small, so it should be started without load. But to avoid overheat caused by no-load running of the capacitor motor, the no-load running time should be less than 30 minutes.

6.2 It is not allowed to touch the rolling steel pipe with hand, and it is not allowed to operate the machine with gloves on.

6.3 The hex screw bolt at the vent hole of the hydraulic pump must be screwed up after work is finished so as to avoid environmental pollution.

## 7. Maintenance

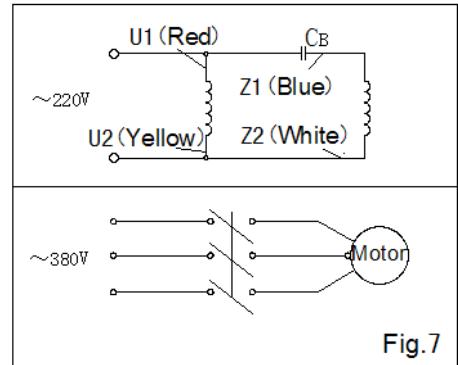
7.1 All the rotating and moving parts must be lubricated at least one or two times every shift.

7.2 The gearbox of a new machine should be cleaned after the first 600-hour running, and after that, it should be cleaned once every 1200-hour running. After each cleaning, the gearbox should be greased properly with clean No.3 lime grease.

7.3 After repair or maintenance, the grounding wire must be well connected. All the wire ends should be sleeved with wire conduits and fastened to the switch body with rubber rings.

7.4 For a new cutting machine, if the hydraulic pump is found failed to build up pressure, the possible causes may be as follows:

- (1) The cock is not tightened.
- (2) The oil in the oil tank is insufficient.





(3) There is possibly air in the cylinder. It is suggested to apply and release pressure repeatedly to expel the air in the cylinder.

7.5 The hydraulic oil should be checked frequently. The checking method is to screw out the hex bolt of the hydraulic pump, insert a piece of iron wire into it to check the oil depth. If it is insufficient, oil should be replenished. The hydraulic oil should also be replaced regularly (by means of siphonage).

#### 8. Tools and Accessories (Packing List)

For QG325-A- II / MB- I /MB- II [pipe cutting machines](#):

Table 2

<b>Description</b>	<b>Specifications</b>	<b>Quantity</b>
Screw Driver	75	2
Hexagonal Key	4, 5, 6, 8	1 each
Pipe Stand	-	1
Hydraulic Oil	(22#) 200ml	1 bottle
Supporting Frame	-	1

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