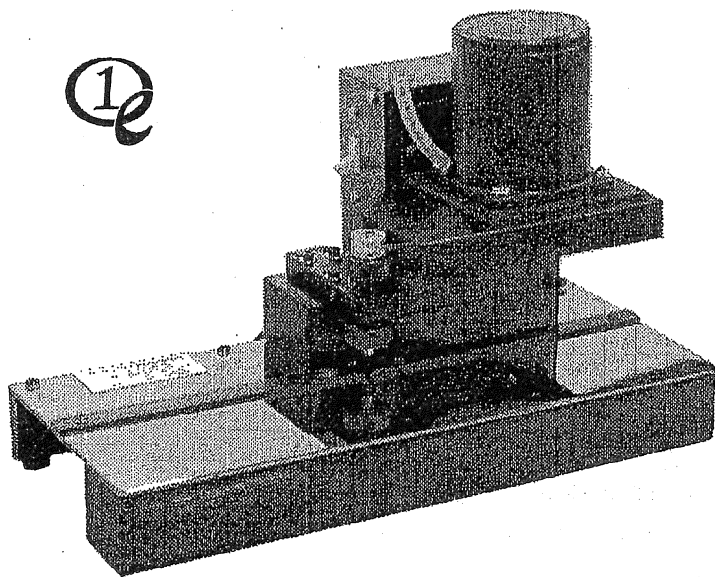


Quality One **ENGRAVERS, INC.**

For The High-Performance Engraver.™

Q1E Beveler



User's Guide

Getting Started

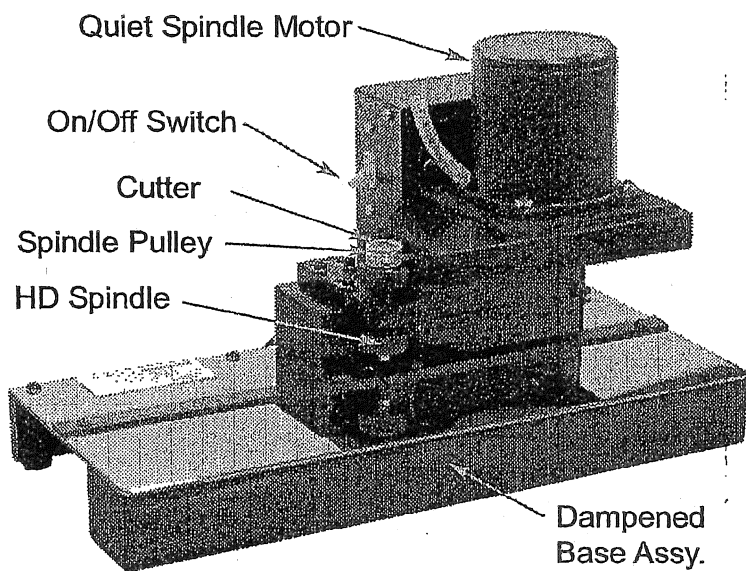
Congratulations on purchasing your new Quality One Quiet Industrial Beveler. The Q1E industrial beveler features a super-quiet, heavy-duty motor mounted on a strong, smooth-sliding, dampened base. An AC power inlet and switched outlet for integration with a vacuum chip removal system is included.

Package Contents

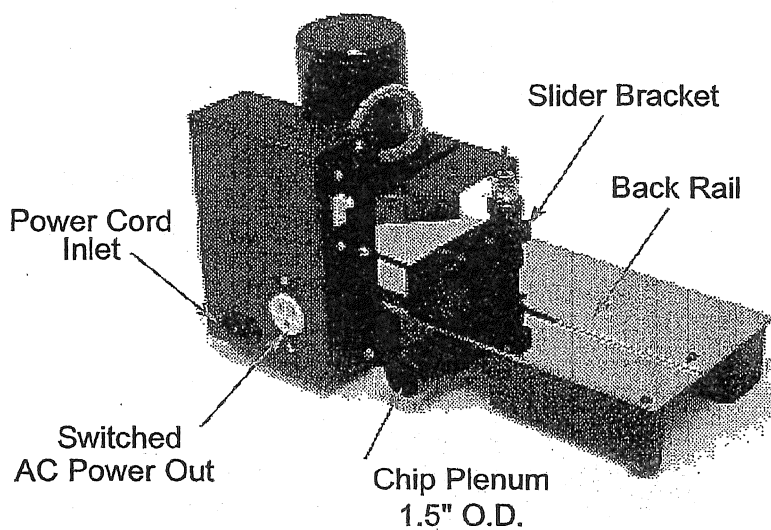
- (1) Industrial Beveler
- (1) 11/64" x 4 1/4" x 3-Fluted 45° Cutter
- (2) Spindle Belts
- (1) User's Guide

Your Q1E Industrial Beveler was carefully packed before shipping. Check for any damage that may have occurred during shipping. If any damage is evident, including damage to the outside of the box your beveler came in, contact the carrier that delivered the box, as well as Quality One or your Quality One Certified Distributor.

Beveler Front

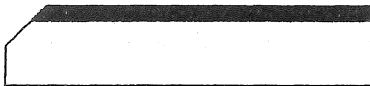


Beveler Rear



Setting Up Your Beveler

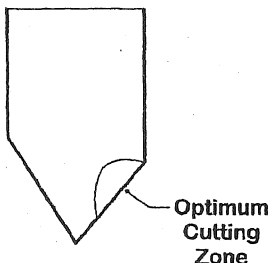
1. Remove your beveler from the box. Inspect for any damage.
2. Place on a flat, sturdy surface.
3. Install the spindle belt by placing it around the spindle motor pulley and then around the spindle pulley. *May be installed.*
4. Insert the cutter into the spindle and tighten. The cutter and spindle slide bracket are pre-set for beveling standard 1/16" material. *May be installed.*
5. If available, attach standard 1.5" ID vacuum hose to the vacuum attachment on the rear of the beveler.
6. Plug the vacuum system into the switched AC outlet on the rear of the beveler (7 amps max). This way, your vacuum system will turn on at the same time as your beveler.
7. Spin the motor pulley to insure all components rotate freely and that the cutter does not interfere with the back rail.
8. Plug your beveler into a 110V grounded AC outlet.
9. Turn the On/Off power switch On.
10. Test bevel on a sample piece of material.



Standard Bevel

Setting Cutter Depth

Set up the cutter to utilize the strongest and fastest moving portion of the cutter. See the view below.



Using a spline wrench, adjust cutter depth by loosening the set screw on the brass cutter knob. Raise or lower the cutter to the proper height. Be sure to re-tighten the set screw when adjustments are complete.

Often times people want to put a true full bevel on a plate or piece of acrylic. The physics of a cutter is: The maximum true 45° bevel obtainable is $\frac{1}{2}$ the diameter of the cutter. So an $\frac{1}{8}$ " diameter cutter will almost truly 45° bevel a $\frac{1}{16}$ " thick plate. I use the term "almost" because everything would have to be dead perfect to achieve the theoretical maximum. Use the 45% rule to be on the safe side. Use the chart below as a reference. Your Q1E beveler utilizes an $\frac{11}{64}$ " diameter cutter.

Cutter Size	Max Full Bevel
$\frac{1}{8}$ "	.045
$\frac{11}{64}$ "	.075
$\frac{1}{4}$ "	.11

How To Bevel

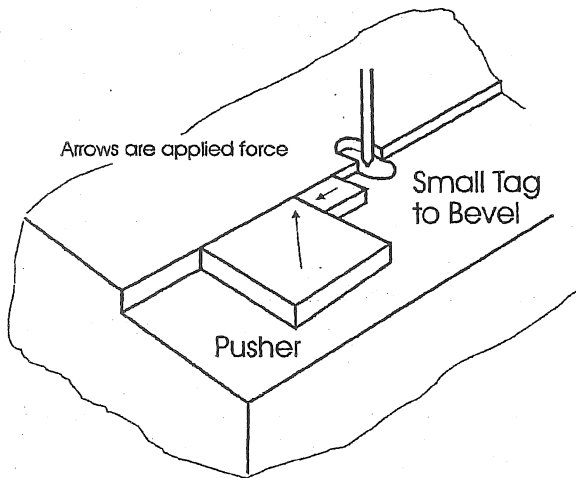
Beveling

Beveling is a term used incorrectly in our engraving industry. It is more correctly called ***chamfering***. However, beveling is a term that has stuck. Therefore, the term bevel will be used throughout this user's guide. Beveling is typically done on a plastic plate. The purposes are to obtain a finished edge to the tag or badge, hide shear marks, and to expose a border color for appearance reasons.

The standard bevel on a plate is 45° starting at the mid point of a $\frac{1}{16}$ " piece of engraving stock. Many engravers like a slightly broader bevel and will make a deeper cut.

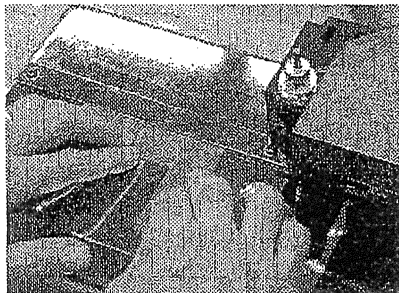
Beveling Small Plates

When beveling small plates, use what I call a "Pusher". A pusher is a piece of scrap material used to push small pieces of material across the cutter, keeping your fingers safe. The optimum size is approximately 1.25" x 3.5".



Beveling Multiple Plates

When beveling many plates of the same size (e.g. 1" x 3"), bevel two plates at a time by putting the 1" edge against the 3" edge. Push the parts past the beveler cutting the 1" edge first and using the 3" edge as the "Pusher". Rotate both parts always beveling the shorter edge first.

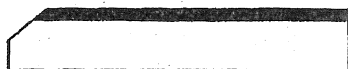


If you get a job that requires several .5 x 3" tags that require a bevel and are run in a matrix, you can bevel the .5" edge along several tags prior to engraving.

Beveling Different Thicknesses of Material

If you bevel more than one thickness of material, set up a second or third beveler cutter for the various thickness of materials. Use the splined set screw in the brass cutter knob to get a proper depth. The set up time for each cutter will be slightly longer the first time, but from thereafter setting up for a new thickness will be a 5 second cutter change. Mark the cutter tops with different colors or markings to avoid confusion. Set up a small cutter rack next to the beveler.

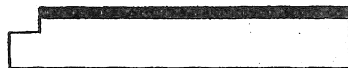
Avoid several different styles of bevel. The standard 45° is well suited for most all applications. Some shops offer a square cut border. This set up is very time intensive.



Standard Bevel



Full Bevel



Square Cut

Adjustments

The Q1E Beveler allows for several adjustments, often very redundant, but necessary to allow for the many possible uses of a beveler. For cutter depth adjustments, refer to the section on setting the cutter for the optimum cutting surface of the tool.

Adjustments included:

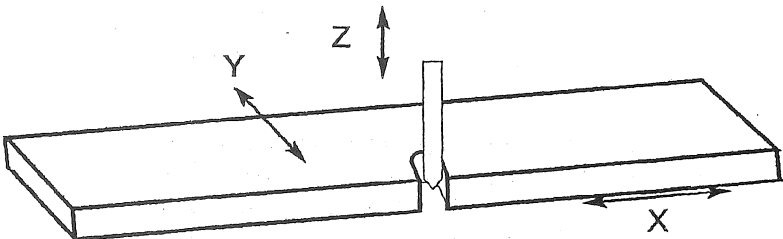
Back Rail - The chrome plated thin back rail has 4 slotted mounting holes (3/32" allen) to allow adjustment in the Y axis. To adjust loosen 3 and have just one snug. Move as required, test and tighten all places.

Slider Bracket - The black anodized aluminum slider bracket allows for both Y and Z adjustment.

Z Axis -For fine adjustment of the Z axis, loosen the allen head cap screw (3/16" allen) on the left side of the slide bracket and rotate the spindle up or down. The beveler will be somewhat noisy if this screw comes loose or if you attempt to make this adjustment with the motor running.

For coarse adjustments use a spline wrench on the brass cutter knob.

NOTE: Do not over adjust the Z axis using this rotation method. It is important that the motor and spindle pulleys are reasonably aligned. Proper alignment will increase belt life and decrease the level of noise.



General Maintenance and Safety

- Periodically check the belt for wear. If you notice any cracking, replace the belt immediately.
- Regularly clean your beveler. Use a brush to remove debris from cracks and crevices.
- Use a silicone or light machine oil spray to keep the beveler base clean and smooth. Apply a very light amount to the table surface and wipe dry.
- Depending upon the level of use, the beveler's cutter will last anywhere from 6 months to 6 years before resharpening or replacement is required.

Specifications

Weight

25 lbs. (11.3 Kg)

Shipping Weight

30 lbs. (13.6 Kg)

Electrical Requirements:

120V, 60 Hz, 1.2A (Beveler motor)

120V, 60 Hz, 10A max (Switched outlet)

Motor RPM

3200

Table Size

4" x 16.5" (102mm x 419mm)

Cutter Size

11/64" x 45° cutting angle

Overall Dimensions (D x W x H)

9.5" x 16" x 10.5" (241mm x 406mm x 267mm)

Replacement Parts

Part #	Description	Price
MSC-1400-005	Spindle Belt, Q1E Beveler (2)	\$16.00
ELM-2017-002	Capacitor	\$20.00
BBB-002-0664*	Bearings, 8 x 16 x 5mm (20,000 RPM)	each \$18.00
BBB-0020-0396	Bearings, 8 x 22 x 7 (20,000 RPM)	each \$15.00
MMC-6000-001	Center Shaft	\$75.00
MSC-1104	Rubber Feet (2) w/screw hardware	\$6.00
MSC-0003	Super Lube Spray	\$12.00

* Bearing for models manufactured prior to 6/97.

Prices as of 4/08. Prices subject to change without notice.

Cutter Information

Recommended Cutter Size: 11/64" x 4 1/4" lg

CCC-2000-001	Cutter, Beveler 3 Fluted 45° 11/64"	\$40.00
CCC-2000-003	Cutter, Parallel 11/64" x .171	\$22.00
CCC-2000-005	Cutter, Profile 70° included, 11/64"	\$22.00

Cutters may be ordered from Quality One Engravers or your local Q1E Beveler distributor.

Manufactured By: Quality One Engravers, Inc.
9749 Crescent Center Dr., Unit 202
Rancho Cucamonga, CA 91730
Phone: (909)989-3898
FAX: (909)989-8617
Email: info@Q1engravers.com
www.Q1engravers.com

Distributed By:

Service and Support

If you have any questions concerning the operation of your Q1E Industrial Beveler, you may speak directly to a customer support representative. Representatives are available from 8:00 a.m. to 5:00 p.m. (PST) Monday - Friday at (909)989-3898. You may also fax questions to (909)989-8617 or via email at info@Q1engravers.com

Should your beveler require service during the warranty period, contact Quality One for instructions and return authorization information. If your beveler requires service after the warranty period has expired, contact Quality One for assistance troubleshooting the problem and ordering replacement parts.

Warranty

Quality One Engravers warrants this equipment to be free from malfunctions and defects in both material and workmanship for two years from the date of purchase. Consumables are not covered under the warranty. The cutter/s and belt are considered consumables.

If the equipment does not function properly during the warranty period due to defects in either materials or workmanship, Quality One will, at its option, either repair or replace the equipment without charge, subject to the conditions and limitations stated herein. Such repair service will take place at Quality One and includes all labor, as well as, any necessary adjustments and/or replacement parts. Shipping charges both to and from Quality One are the responsibility of the customer. Quality One will return ship repaired or replaced equipment via the same shipping method as was used to ship the equipment to Quality One, unless otherwise specified by the customer.

If replacement parts are used in making repairs, these parts may be remanufactured, or may contain remanufactured materials. If it is necessary to replace the entire system, it may be replaced with a remanufactured system.

Quality One will provide telephone assistance during the warranty period.

Limitations

THIS WARRANTY BECOMES NULL AND VOID IF YOU FAIL TO PACK YOUR EQUIPMENT IN A MANNER CONSISTENT WITH THE ORIGINAL PRODUCT PACKAGING AND DAMAGE OCCURS DURING PRODUCT SHIPMENT. IF THE ORIGINAL PACKAGING HAS BEEN DISCARDED OR IS NOT AVAILABLE, PACKING WILL BE AT THE OWNER'S EXPENSE. QUALITY ONE IS NOT RESPONSIBLE FOR SHIPPING COSTS TO OR FROM A QUALITY ONE AUTHORIZED REPAIR FACILITY.

THIS WARRANTY DOES NOT COVER: CIRCUMSTANCES BEYOND QUALITY ONE'S CONTROL; SERVICE OR PARTS TO CORRECT PROBLEMS RESULTING FROM THE USE OF ATTACHMENTS, ACCESSORIES OR ALTERATIONS NOT MARKETED BY QUALITY ONE; LABOR AND TRAVEL EXPENSES FOR ON-SITE REPAIRS AND SERVICE; SERVICE REQUIRED AS THE RESULT OF UNAUTHORIZED MODIFICATIONS OR SERVICE; MISUSE, ABUSE; FAILURE TO FOLLOW QUALITY ONE'S OPERATING, MAINTENANCE OR REPACKING INSTRUCTIONS; OR FAILURE TO USE ITEMS SUPPLIED BY QUALITY ONE (SUCH AS ADAPTERS AND CABLES).

QUALITY ONE MAKES NO OTHER WARRANTIES, EXPRESS, IMPLIED OR OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE FOR THIS EQUIPMENT OR SOFTWARE.

REPAIR OR REPLACEMENT WITHOUT CHARGE ARE QUALITY ONE'S ONLY OBLIGATION UNDER THIS WARRANTY. QUALITY ONE WILL NOT BE RESPONSIBLE FOR ANY SPECIAL, CONSEQUENTIAL OR INCIDENTAL DAMAGES RESULTING FROM THE PURCHASE, USE, OR IMPROPER FUNCTIONING OF THIS EQUIPMENT REGARDLESS OF THE CAUSE. SUCH DAMAGES FOR WHICH QUALITY ONE WILL NOT BE RESPONSIBLE INCLUDE, BUT ARE NOT LIMITED TO, LOSS OF REVENUE OR PROFIT, DOWNTIME COSTS, LOSS OF USE OF THE EQUIPMENT, COST OF ANY SUBSTITUTE EQUIPMENT, FACILITIES OR SERVICES, OR CLAIMS OF YOUR CUSTOMERS FOR SUCH DAMAGES.

Depending on your geographical location, some limitations and exclusions may not apply.

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www.Q1engravers.com

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