



Everwin

Multi-Directional Pipes & Fittings

by Sensible Solutions

Instruction manual: JR200-2 Groove Machine



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***Thank you for choosing the
JR200-2 Groove Machine!***

JR200-2 Groove Machine user manual

1 Caution

Before turning on the machine, please read the instruction manual carefully. Make sure you understand all the operational and safety precautions.

Follow this manual strictly for proper operation of this product.

- This machine is designed for grooving and cutting of Ø200mm plastic pipes. Please do not use for other than intended purpose and do not use on pipes made from other materials.
- This groove machine uses single-phase 220V/50HZ power. Make sure all power is disconnected before performing any adjustments and/or repairs.
- For safety sake, ensure that the wires do not make contact with the machine during or after the process.
- Do not store in humid places and avoid direct contact with water when cleaning.
- Although this machine runs at low speed, please pay attention to safety. Do not touch moving parts while the machine is operating, as this can cause serious injury. Special reminder: while machine is running, please keep hands away from the groove blade and cutter!
- If you encounter problems during maintenance, please contact our company immediately. Make sure you provide us with the production serial number and report the malfunction as accurately as possible. Our technicians will help you solve the problem

2 Operation

• Track-Position Sign Replacement

Stabilize the JR160-2 groove machine's track-position sign at location 160. Take off sign with scale then take out sign with 200 labeling from Ø200 tool kit. Allow the arrow on the tract to point at location 160 of the new sign. Drill in screws (M4) from the two holes on the new sign.

• Feed Component Installation

- Place JR160-2 groove machine with the 200-sign on a flat surface, make sure all four casters have secure contact with the ground then lock two casters. Set the feed track-position at Ø200 then secure the butterfly nuts (**Image 1**). Unscrew the feed handle screws with the supporting hex wrench (**Image 2**);
- Rotate feed handle clock-wise with the left hand and take out JR160-2 groove machine's feed component with right hand at the same time (Pack away in a clean plastic bag then place in the tool box securely behind the groove machine, to prevent loss) (**Images 3 and 4**);
- Take out Ø200 groove machine's feed device out of the 200 tool kit then insert feed sleeve. Rotate feed handle counter-clock-wise with left hand at the same time until feed component installs into the feed sleeve. Secure feed screws;



2 Operation (contd)

• Feed Component Installation (contd)

- iv Install cutter and groove blade into appropriate locations and tighten crews (**Image 5**).

3 Holder Installation

- Rotate impact plate clock-wise and allow the clips on the chuck to open to its largest position. Remove the Ø50 clip on the JR160-2 groove machine and place in the tool box; (**Image 6**);
- Aim the bolt on the holder to the dovetail groove in any clip then insert Ø200 holder into Ø75 clip (**Image 7**);
- Hold Ø200 holder with right hand, allowing Ø200 holder and Ø75 clip to push against each other. Rotate impact plate counter-clock-wise hardly with left hand to secure Ø200 holder (**Images 8 and 9**).

4 Piping Material Security

- i To provide secure support, position the four-leg support on the far end of the pipe;
- ii Lightly tighten holder screws with matching socket wrench from the back of the chuck. Adjust the height of the four-leg support so that the axis of the pipe and holder are the same height; tighten holder screws tightly.

5 Pipe-Cutting and Grooving

- i Plug in power supply and turn on the machine;
- ii Turn feed handle clock-wise to start cutting and grooving. Caution: Slow down while cutting and grooving!
- iii Wait until there are no more shavings around the groove blade, piping material rotates 3-5 more rounds, and the limit bearing beside the groove blades rotates counter-clock-wise, rotate feed handle counter-clock-wise;
- iv Loosen holder screws with a socket wrench behind the chuck, take down piping materials and finish grooving;
- v Clean shavings off the groove blade and cutter with a brush.

6 Maintenance

Refer to the JR160-2 groove machine's maintenance manual.

