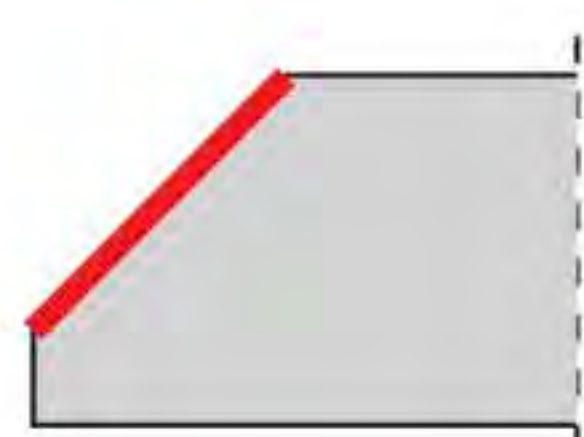


STEELBEAST®

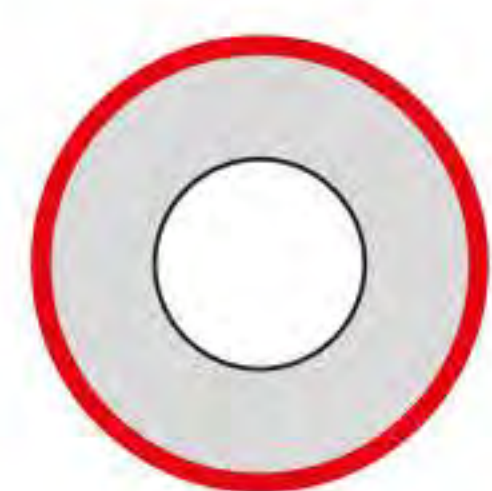
JEI
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ABM-14

PLATE AND PIPE BEVELLER



Top beveling



Pipe OD beveling Min. ID 100 mm (4")



Min plate width 55 mm (2-3/16")



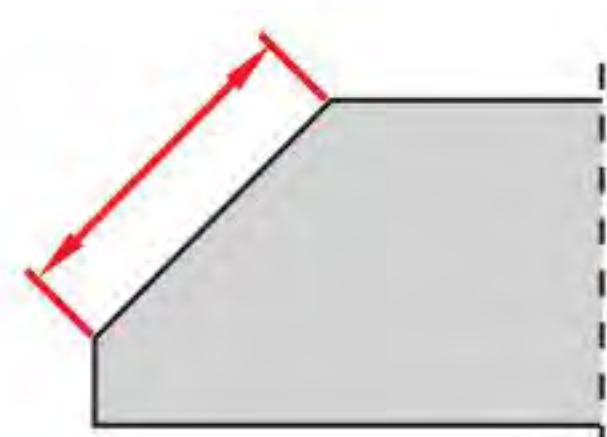
Bottom beveling



**Min plate thickness 6 mm
Max plate thickness 40 mm (1-9/16")**



**Bevel angles 30°, (option): 22.5°,
25°, 35°, 37.5°, 45°**



Bevel width up to 14 mm (9/16")

ABM-14 is a beveling machine designed to mill plates and pipes made of carbon steel, alloy steel, stainless steel or aluminum alloys.

In just one single run the machine can bevel up to 2.6 m/min. (8.5 ft/min.) to a width of 12 mm (1/2") in workpieces with tensile strength of $R_m \leq 392 \text{ MPa}$ (57,000 psi).

Maximum bevel width is 14 mm (9/16"). Depending on materials two or more runs are needed. Bevel angles incl. 30° (standard) and with optional angle variation devices also 22.5°, 25°, 35°, 37.5° or 45°. The machine can bevel plates from the top and bottom.

In the case of the milling tool getting stuck in the material and beveling cannot be continued the direction of rotation of the tool can be reversed to release the machine from the workpiece.

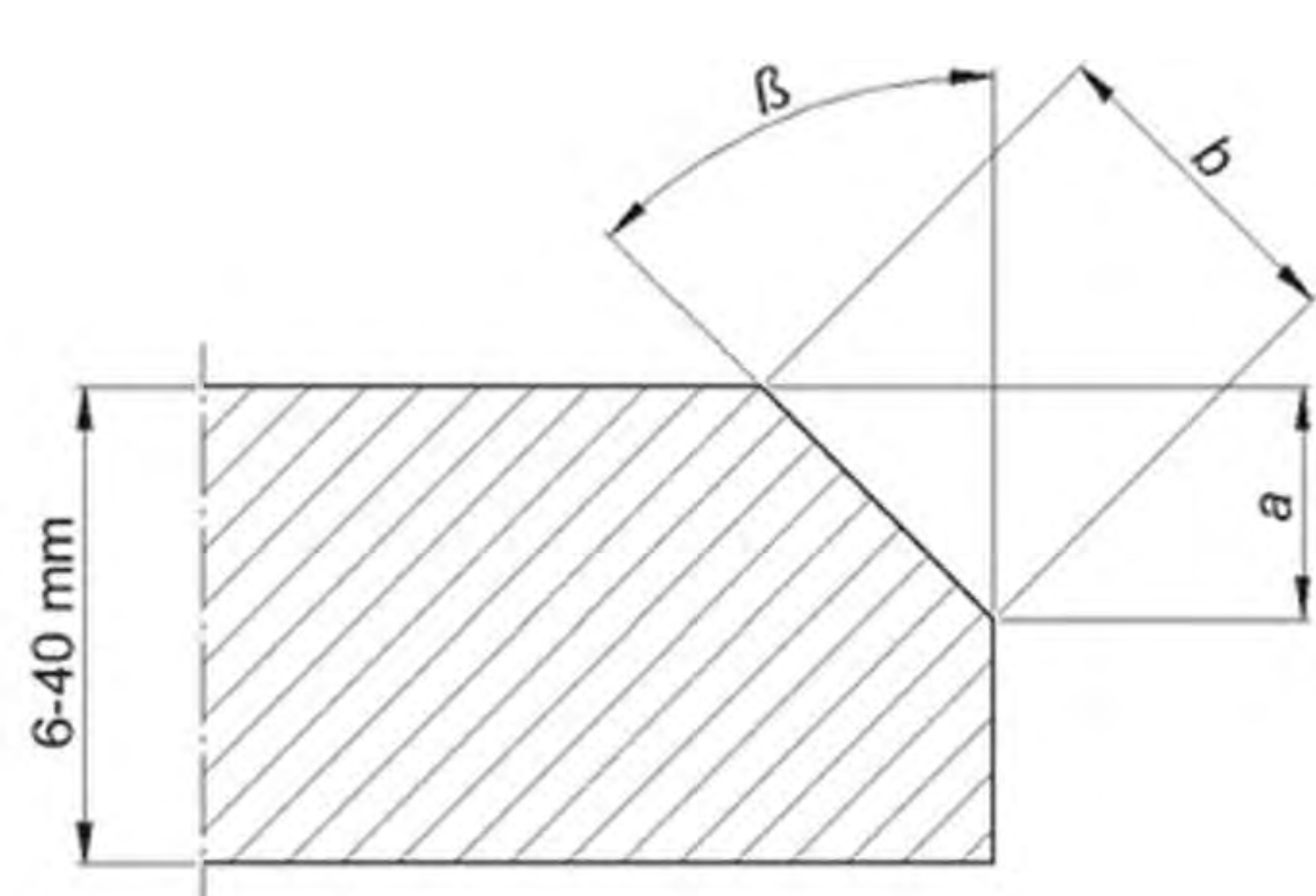
There is no need to wear acoustic protection equipment because the noise produced by the machine does not exceed 70 dB.

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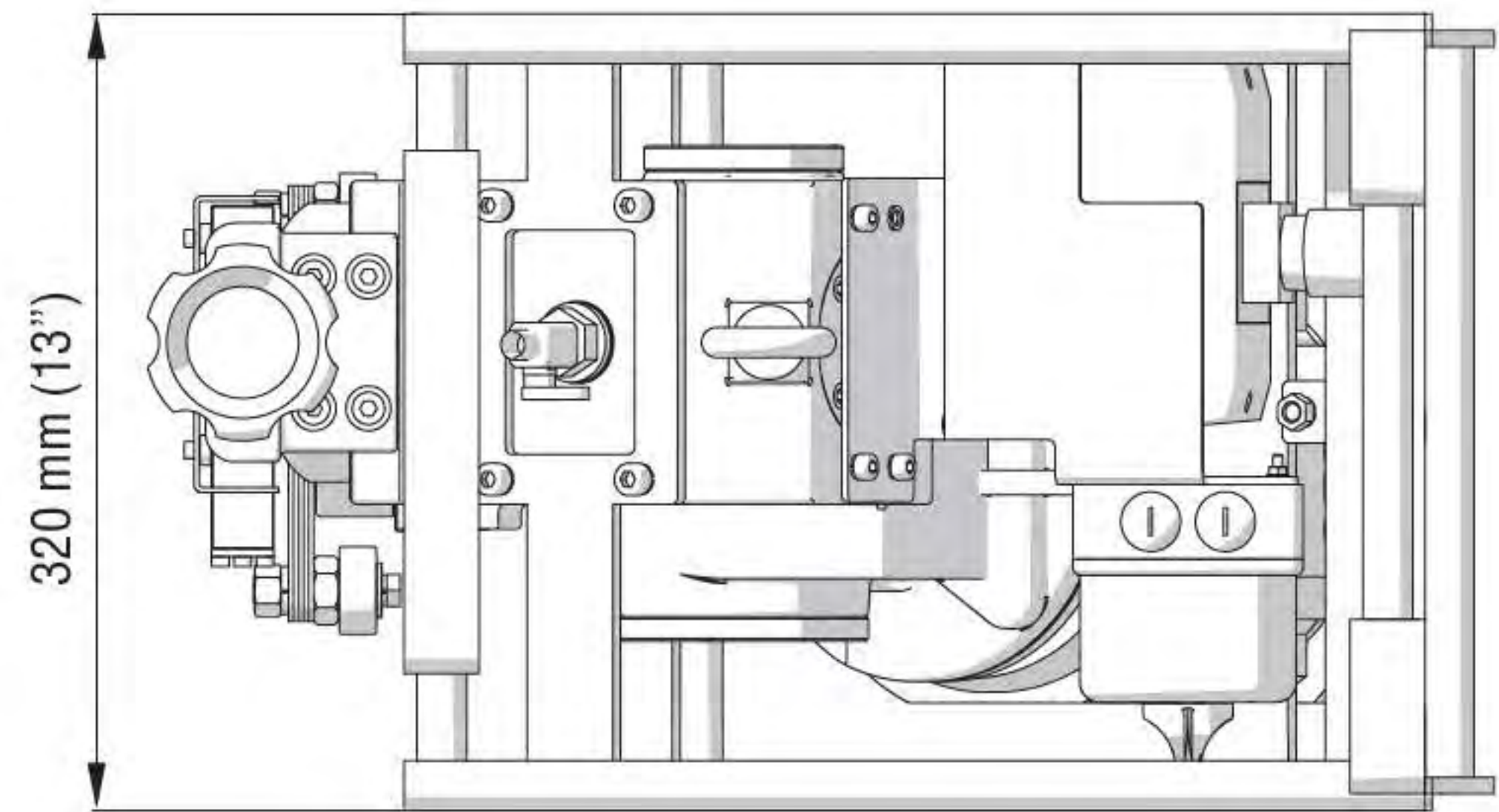
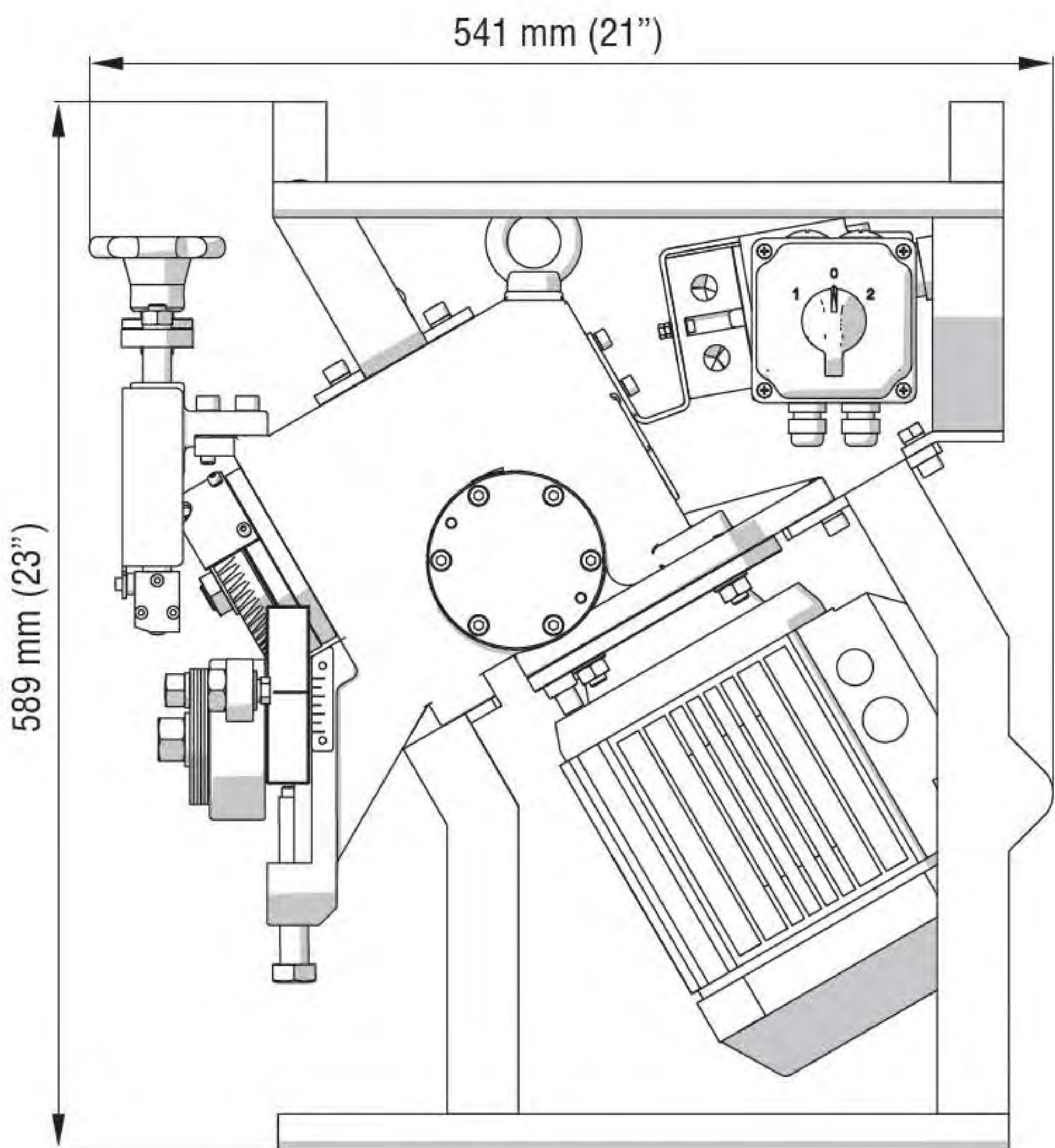
- ✓ Fast and efficient
 - ✓ Bevels both small and large pieces to cover most of the common applications for its type
 - ✓ Auto feed on large plates with optional trolley
 - ✓ Beveling of lower edge in inverted position
 - ✓ Low noise
- ✓ 2 optional shearing cutters dedicated to carbon steel and to aluminum
 - ✓ Standard shearing cutter for machining stainless/alloyed steel
 - ✓ Reversible spindle against stuck milling tool
 - ✓ Versatile and transportable on its own trolley

ABM-14 TECHNICAL SPECIFICATION	
Voltage	3~ 400 V + PE, 50-60 Hz
Power	2200 W
Spindle speed	9 rpm (for 50 Hz); 11 rpm (for 60 Hz)
Bevel angle range (β – depending on angle device in use)	30° 22.5°, 25°, 35°, 37.5°, 45° (options)
Bevel width (b)	up to 14 mm (9/16")
Maximum bevel in one single run	12 mm (in 40 Kg/ 392 MPa carbon steel)
Minimum plate thickness	6 mm (1/4")
Maximum plate thickness	40 mm (1-9/16")
Minimum plate width	55 mm (2-3/16")
Bevel length per minute	2.6 m (8.5 ft) for 50 Hz; 3.1 m (10.2 ft) for 60 Hz
Minimum pipe ID	100 mm (4")
Weight	65 kg (144 lbs)
Product Code:	ABM14



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SINGLE RUN BEVELLING - STAINLESS / ALLOY STEEL						
Rm	≤ 490 MPa (71,000 psi)		490–588 MPa (71,000–85,000 psi)		588–686 MPa (85,000–100,000 psi)	
β	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	6	5.5	5	4.5	4.2	3.8
30°	6	5	5	4.3	4.2	3.6
35°	6	5	5	4	4.2	3.5
37.5°	6	4.5	5	4	4.2	3.3
45°	6	4	5	3.5	4.2	3



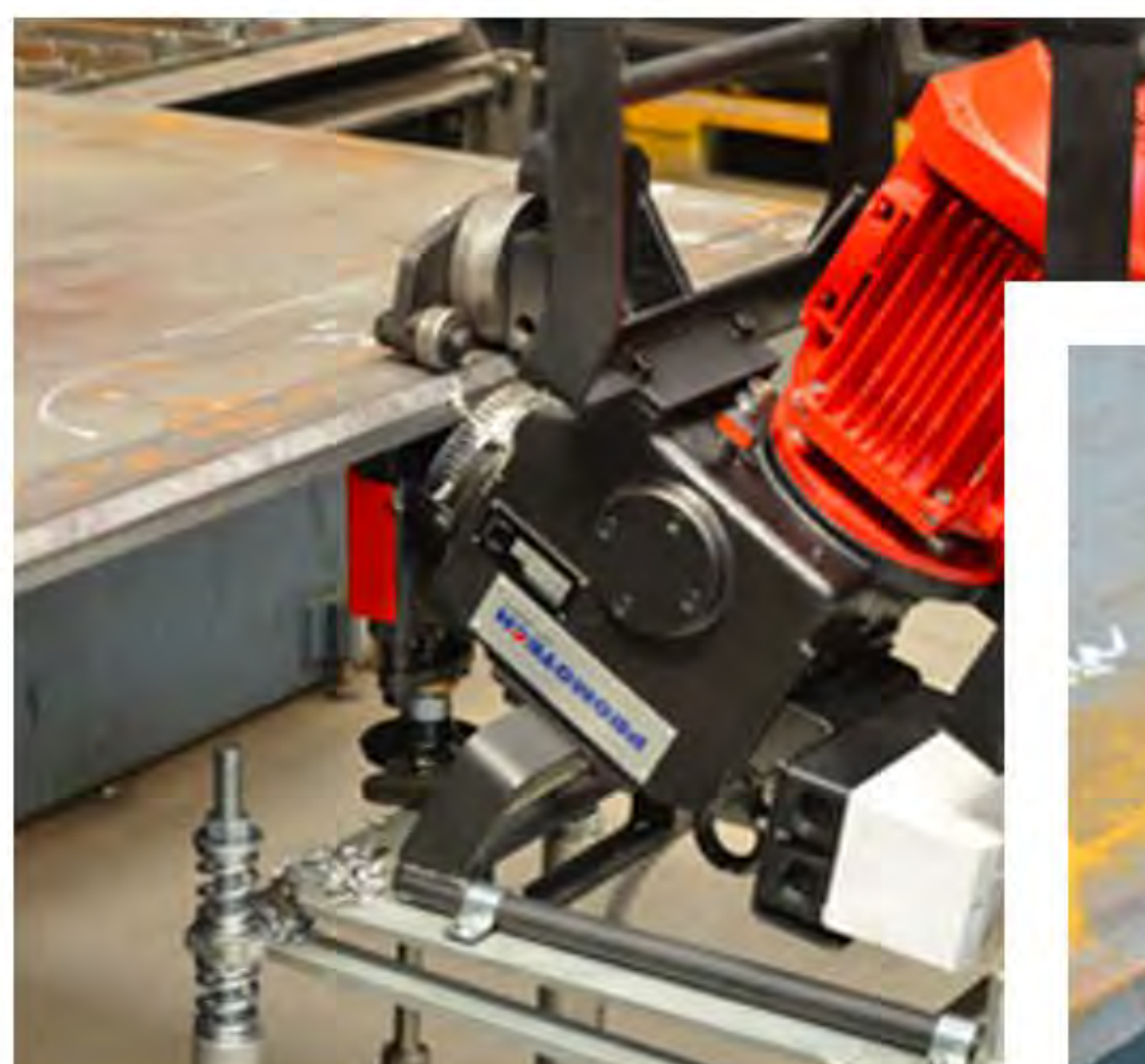
SINGLE RUN BEVELLING - CARBON STEEL						
Rm	≤ 392 MPa (57,000 psi)		392–490 MPa (57,000–71,000 psi)		490–588 MPa (71,000–85,000 psi)	
β	b [mm]	a [mm]	b [mm]	a [mm]	b [mm]	a [mm]
22.5°	12	11	10	9	8	7.5
30°	12	10	10	8.5	8	7
35°	12	9.5	10	8	8	6.5
37.5°	12	9	10	7.5	8	6
45°	12	8.5	10	7	8	5.5



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STANDARD SHIPPING SET

- ✓ ABM-14 beveller
- ✓ Milling cutter for stainless steel
- ✓ Cutter extraction tool
- ✓ Tube beveling shaft
- ✓ Tube beveling washer
- ✓ Flat wrenches: 12-13 mm, 18-19 mm, 24-26 mm
- ✓ Hex wrenches: 5 mm and 6 mm
- ✓ Operator's Manual



ACCESSORIES



ABM14-IS Milling cutter for carbon steel
ABM14-ISS Milling cutter for stainless steel
ABM14-IA Milling cutter for aluminum



ABM14-TBS Tube beveling shaft
ABM14-TBW Tube beveling Washer



ABM14-IEX Milling cutter extraction tool



ABM14-AVD22.5 Angle Variation Device 22.5o
ABM14-AVD25 Angle Variation Device 25o
ABM14-AVD30 Angle Variation Device 30o
ABM14-AVD35 Angle Variation Device 35o
ABM14-AVD37.5 Angle Variation Device 37.5o
ABM14-AVD45 Angle Variation Device 45o



ABM14-TROLLEY Adjustable trolley

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STEELBEAST®

MULTITUDE OF APPLICATIONS

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Top plate beveling



Bottom plate beveling



Oval workpiece and pipe beveling



Beveling at 30°



Beveling at 45°



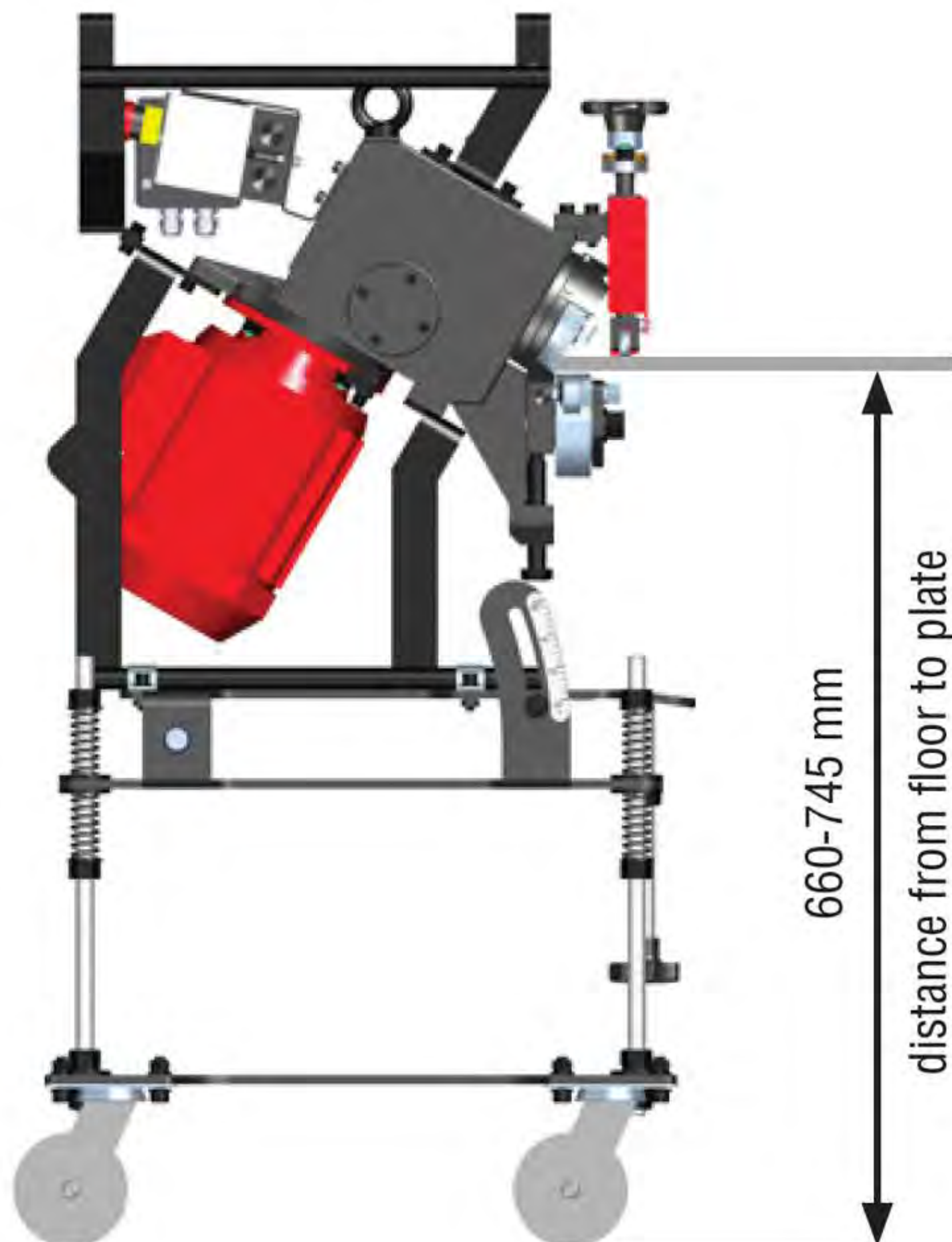
Maximum bevel width up to 14 mm



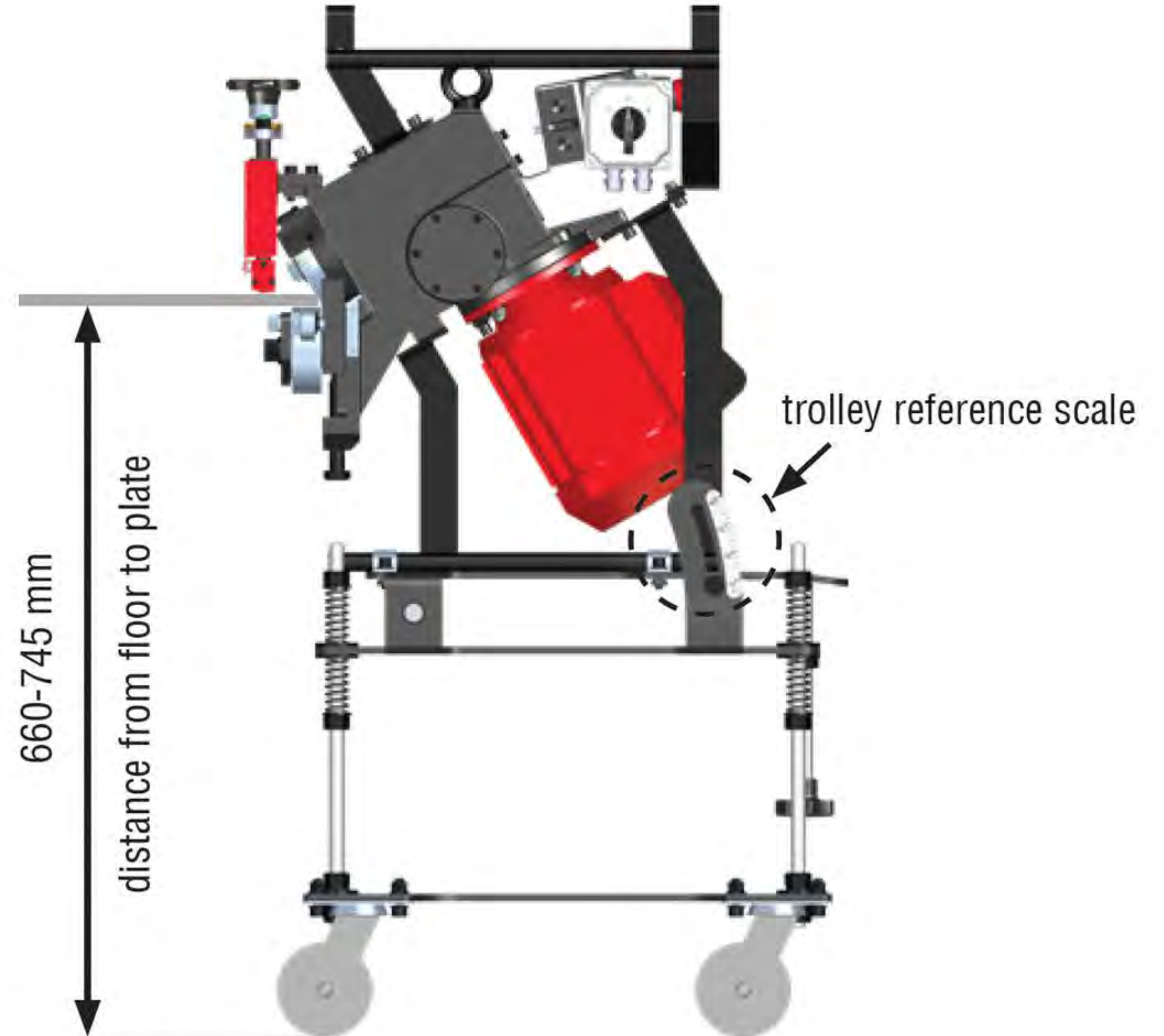
ABM-14 runs along a plate automatically

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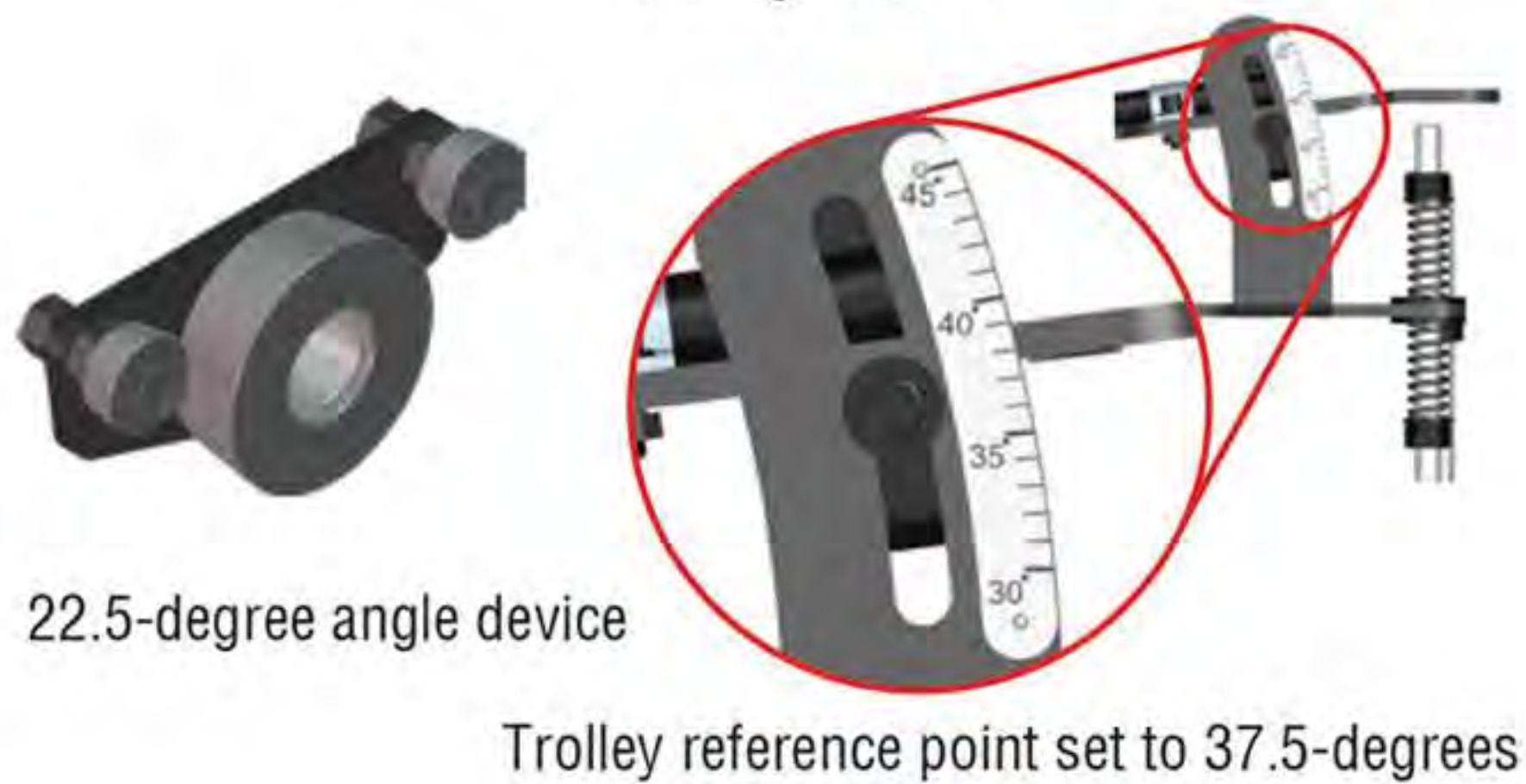


Configuration 1



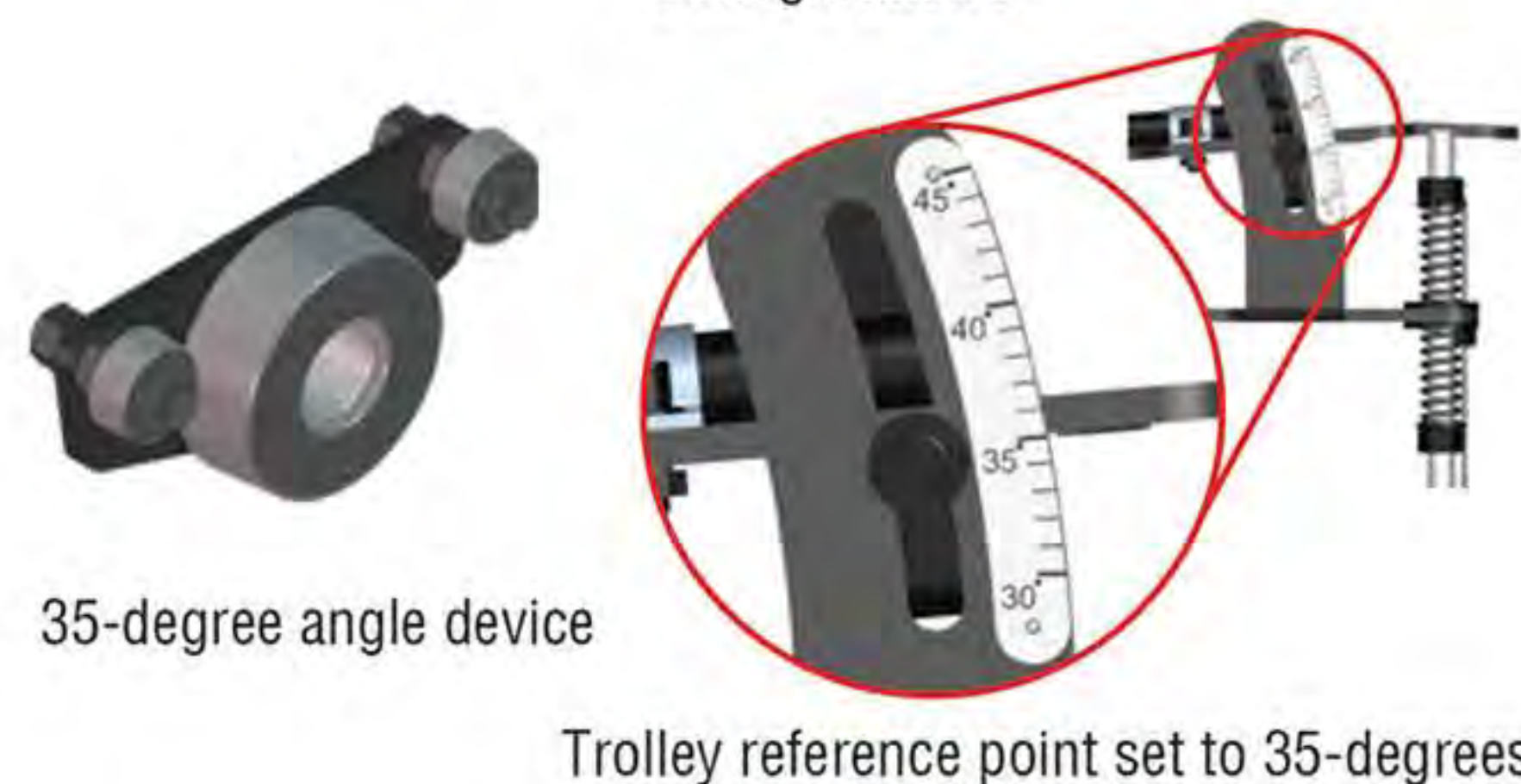
Configuration 2

Top beveling at 22.5 degrees
Configuration 1



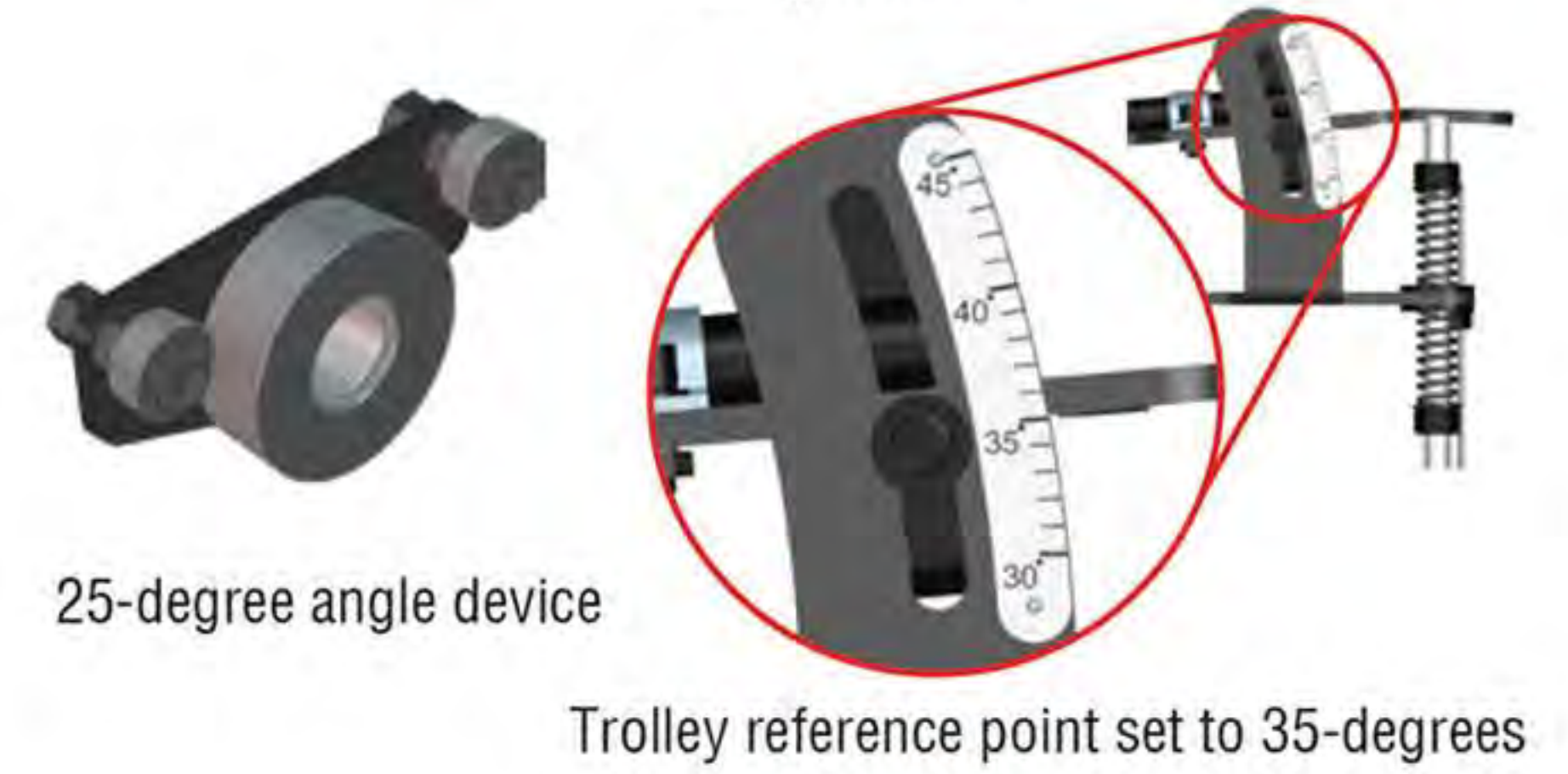
Trolley reference point set to 37.5-degrees

Top beveling at 35 degrees
Configuration 2



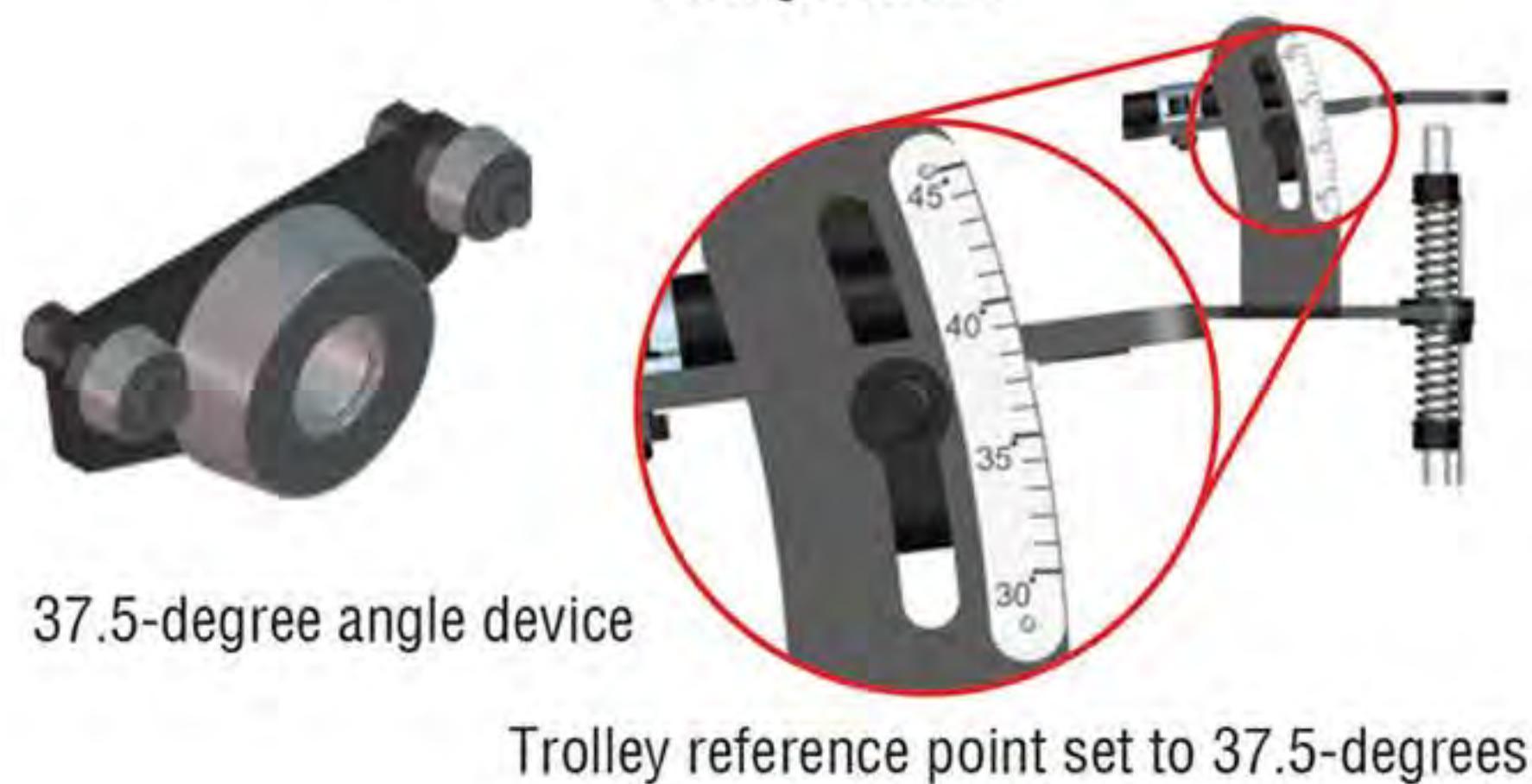
Trolley reference point set to 35-degrees

Top beveling at 25 degrees
Configuration 1



Trolley reference point set to 35-degrees

Top beveling at 37.5 degrees
Configuration 2



Trolley reference point set to 37.5-degrees

Top beveling at 30 degrees
Configuration 1 or 2



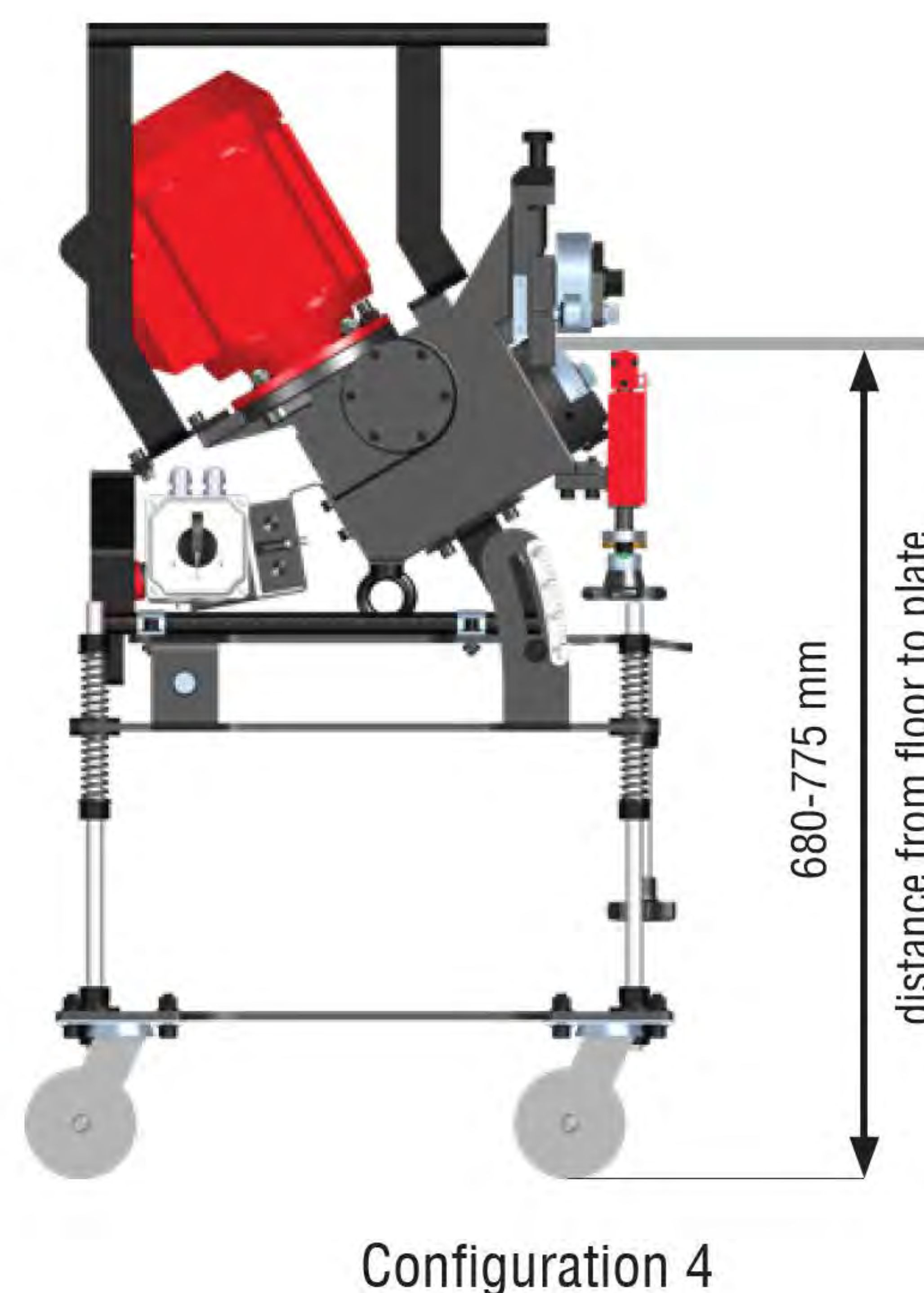
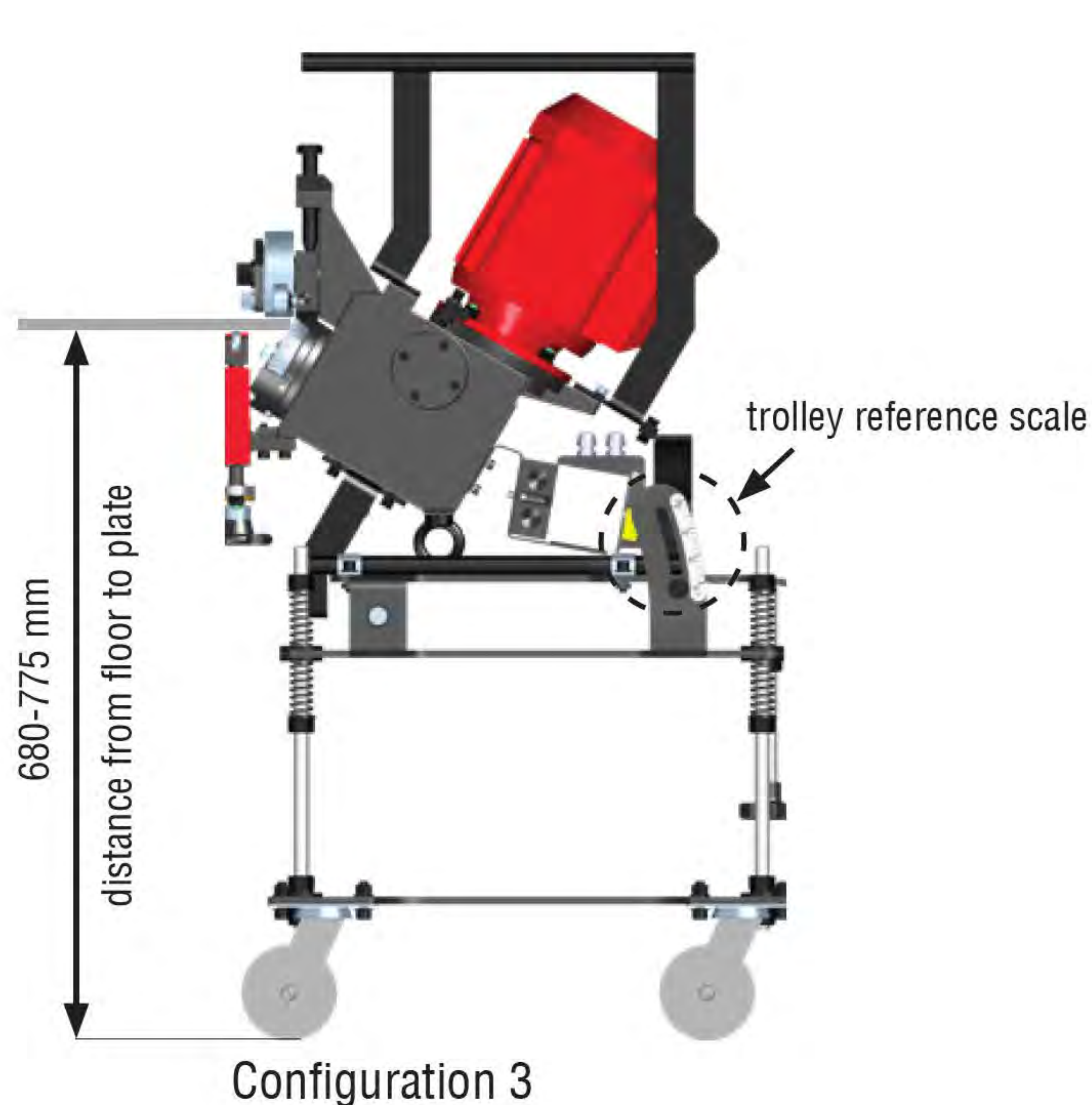
Trolley reference point set to 30-degrees

Top beveling at 45 degrees
Configuration 2



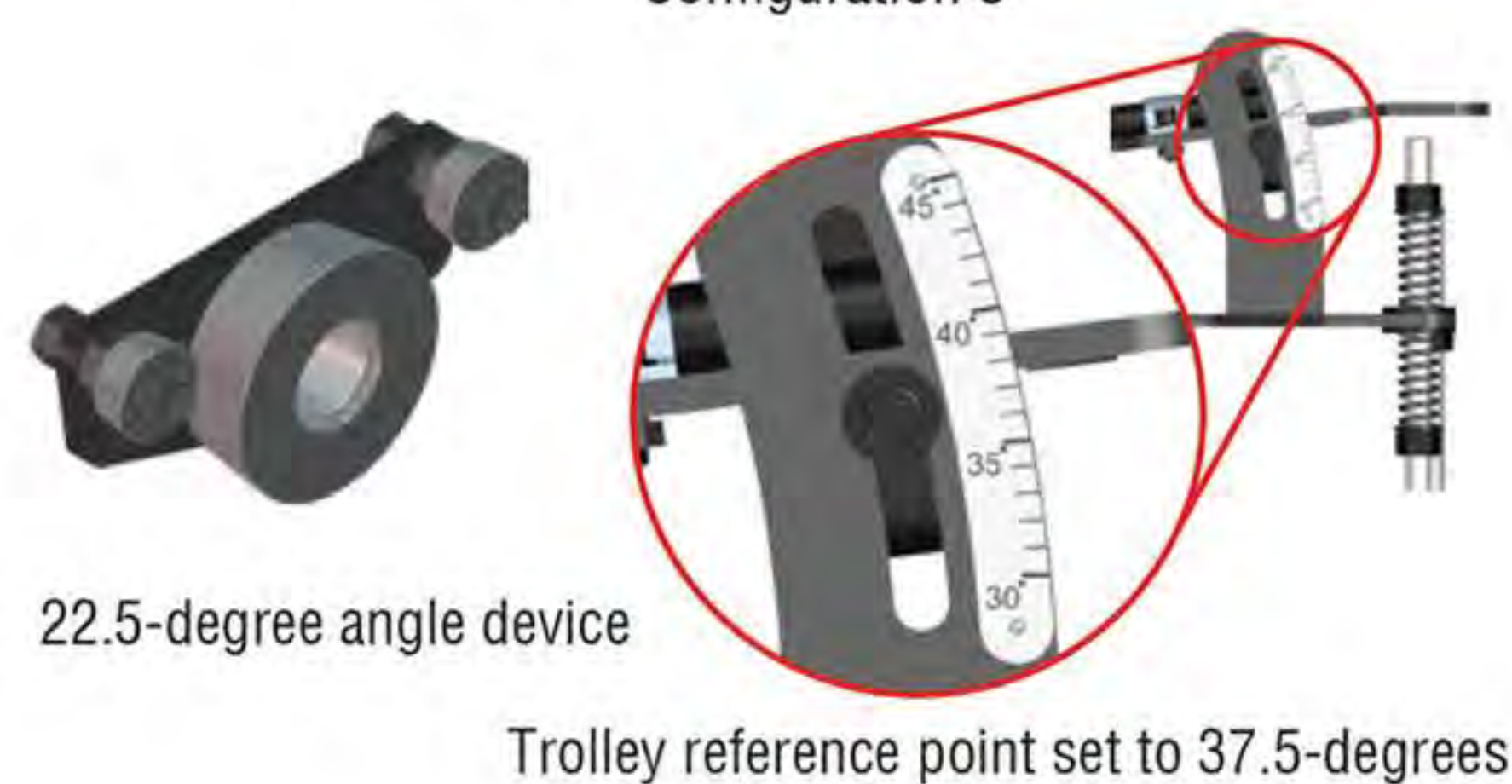
Trolley reference point set to 45-degrees

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Bottom beveling at 22.5 degrees

Configuration 3



Bottom beveling at 35 degrees

Configuration 4



Bottom beveling at 25 degrees

Configuration 3



Bottom beveling at 37.5 degrees

Configuration 4



Bottom beveling at 30 degrees

Configuration 3 or 4



Bottom beveling at 45 degrees

Configuration 4



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