



USER MANUAL



**Hand Skiver
HS1**

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WARRANTY CONDITIONS

1. Note that all machines undergo strict testing before shipment.
2. All machines are warranted against any defects for a period of 12 MONTHS starting from the date of delivery to the customer. The company reserves the right to require a copy of the sales invoice.
3. We must verify defects. Therefore, each defective item must be returned to our address with SHIPPING CHARGES PREPAID. We will return the item with CARRIAGE FORWARD. ANY DELIVERIES TO OUR COMPANY WITH CARRIAGE FORWARD WILL BE SENT BACK TO THE SENDER.
4. This warranty covers replacement and repair of any component found to be defective.
5. Replacements and repairs completed under this warranty cannot extend its 12 months validity.
6. This warranty does not cover any damages caused by deterioration from use.
7. This warranty is not valid for damage resulting from incorrect operation or use not in compliance with the machine instructions.
8. This warranty is not valid in case of unauthorised machine modification.
9. This Instruction Manual is also to be considered as a warranty certificate, with validity commencing from the date indicated on the freight bill.

GENERAL SALES TERMS AND CONDITIONS

For general sales terms and conditions, always refer to the catalogue **Technical data - General sales terms and conditions**, page 59.

SAFETY REGULATIONS

Always work in safe conditions and with the necessary space around the machine. Ensure that the machine is placed on a stable and appropriate working surface.

1. DO NOT USE the equipment before reading the user manual.
2. CAUTION! If improperly used, the equipment may be dangerous and may cause injury. Do not touch any moving parts.
3. CAUTION! It is absolutely essential that all working operations are carried out *by one operator only*
4. This manual must be provided for the machine operator. Ensure that the operator is aware of his/her responsibilities.
5. Guards must never be removed or tampered with.
6. (Where applicable) A fully trained and competent electrician must connect the machine to the appropriate electricity supply.
7. Always wear protective gloves, safety glasses and appropriate clothing.
8. (Where applicable) Disconnect the power supply before removing any covers, or attempting any maintenance of the machine
9. Only original spare parts can be used in the maintenance of the machine.

TECHNICAL / DIMENSIONAL DATA

TECHNICAL / DIMENSIONAL DATA	HS1
External skiving capacity	1/4" - 2"
Internal skiving capacity	5/8" - 2"
Blade material	HSS
Dimensions [mm]	520x65x220
Net weight [kg]	8

HANDLING / TRANSPORT

The machine will be shipped inside a cardboard box, wrapped in film and protections.

PRELIMINARY CHECKS

To operate the Hand Skiver, the unit must be held in a vice.

LIGHTING

The equipment does not have its own lighting and so it must be used in a suitably illuminated area.

ROUTINE MAINTENANCE

Ensure that moving parts are always lightly greased.

DESCRIPTION OF THE MACHINE

Internal/external skiving capacity of hoses up to 2".

OPERATING INSTRUCTIONS

To operate the Hand Skiver, the unit must be held in a vice.

EXTERNAL SKIVING

Position the Tool Post in the forward position for large hoses and the rear position for smaller hose sizes.

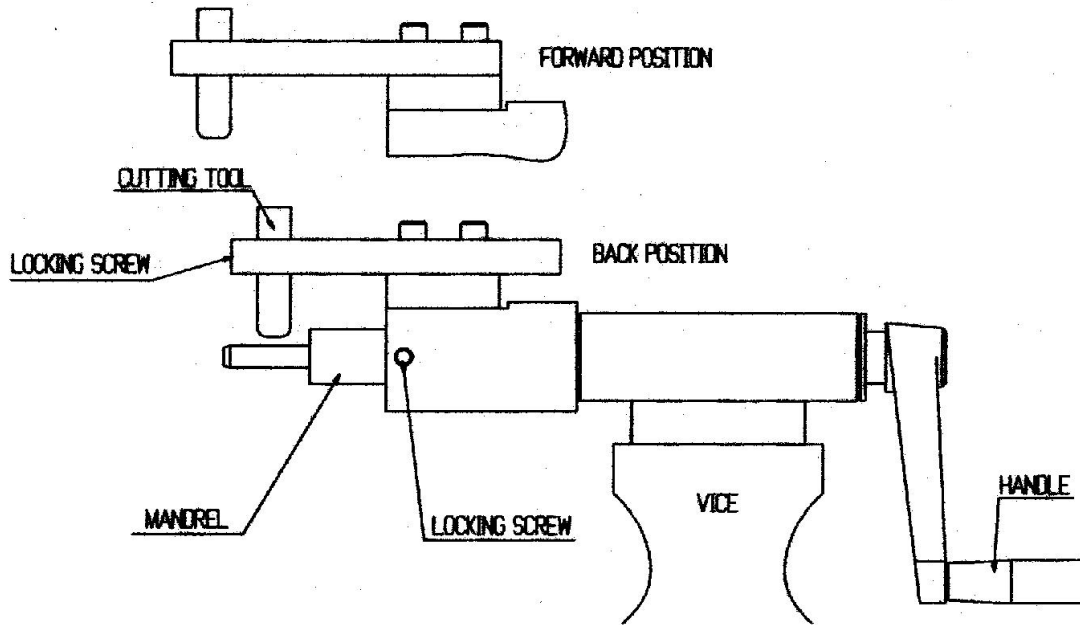
Select the correct mandrel to suit the size of hose to be skived and insert it into the head unit. Position the mandrel as indicated to give the required length of skive, and lock into position with the screw.

Place the hose onto the end of the mandrel and lower the tool to the position of the outside of the wire spirals, visible at the end of the hose. Clamp the tool in position.

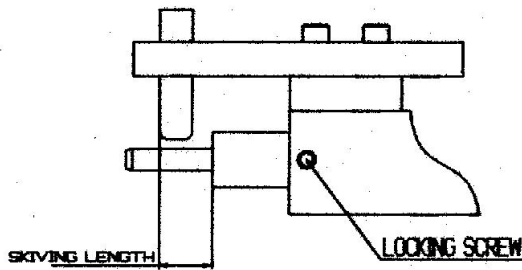
Holding the hose lightly against the tool, rotate the handle in a clockwise direction ie. top going and skive a short length of hose. Check the skive diameter and adjust the tool as required.

Complete the skive by rotating the handle in a clockwise direction while feeding the hose at a steady rate onto the tool. When the end of the hose reaches the shoulder of the mandrel the correct skive length should be achieved. Remove the hose and check the skive dimensions.

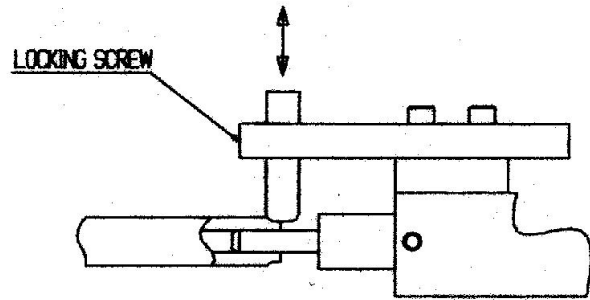
EXTERNAL SKIVING



LENGTH SETTING



DIAMETER SETTING



INTERNAL SKIVING

Remove the tool post and external mandrel from the head unit.

Select the correct internal skive tool to suit the hose size.

Fit the internal skive tool into the head unit.

Place the hose onto the mandrel and hold lightly against the tool. Adjust the tool using the jacking screw until it is inline with the inside of the wire spirals visible at the end of the hose and clamp the tool in position.

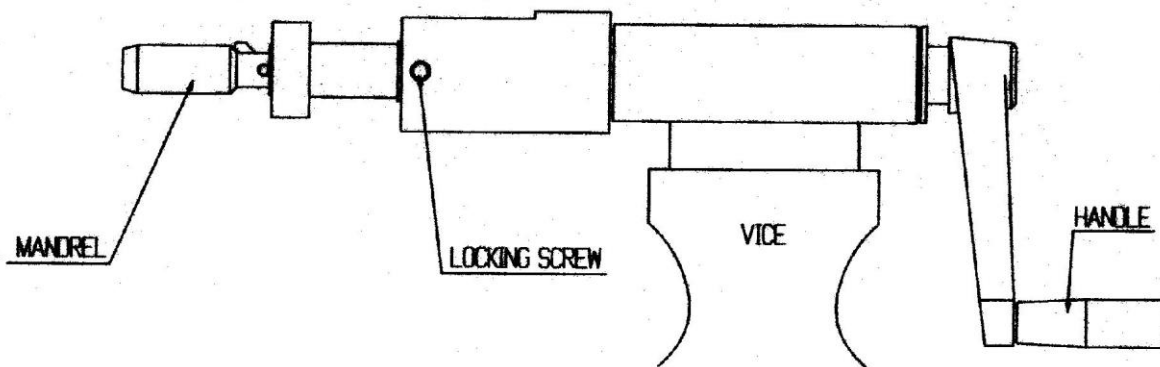
Holding the hose lightly against the tool rotate the handle in a counter clockwise direction i.e. top coming and skive a short length of bore.

Check the skive diameter and adjust the tool as required.

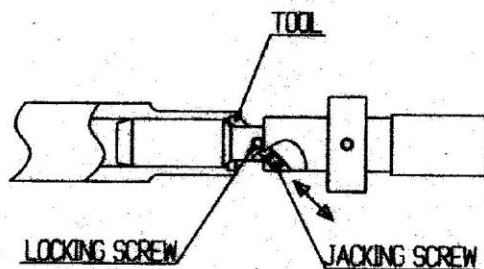
Set the length adjusting stop as indicated.

Replace the hose and complete the skive. Check the skive dimensions.

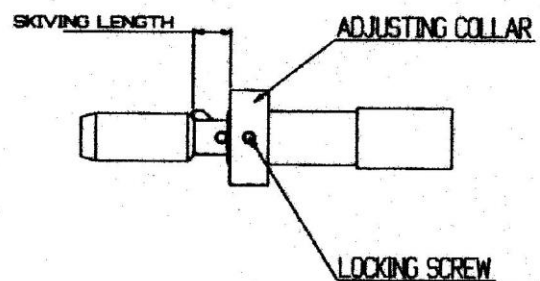
INTERNAL SKIVING



DIAMETER SETTING



LENGTH SETTING



SPARE PARTS

External Skiving

REPLACEMENT CUTTING TOOLS

TOOL	PART NO.
HSS Blade	HS10015

REPLACEMENT MANDRELS

MANDREL SIZE Ø	MANDREL
1/4"	HS1-PE04
3/8"	HS1-PE06
1/2"	HS1-PE08
5/8"	HS1-PE10
3/4"	HS1-PE12
1"	HS1-PE16
1 1/4"	HS1-PE20
1 1/2"	HS1-PE24
2"	HS1-PE32

Internal Skiving

MANDREL SIZE Ø	SKIVING KIT ^(*)	MANDREL	INT. BLADE	COLLAR
1/2"	HS1-PI08	HS10047	HS10048	HS10044
5/8"	HS1-PI10	HS10034	HS10035	HS10038
3/4"	HS1-PI12	HS10033	HS10035	HS10039
1"	HS1-PI16	HS10032	HS10036	HS10040
1 1/4"	HS1-PI20	HS10031	HS10036	HS10041
1 1/2"	HS1-PI24	HS10030	HS10037	HS10042
2"	HS1-PI32	HS10029	HS10037	HS10043

(*) Complete kit, with all parts included.