

## ■ BM-25S | STAINLESS STEEL PLATE BEVELLER

The BM-25S is easy-to-use, portable heavy-duty machine designed to machine stainless steel.

The beveller is equipped with a powerful motor and fitted with face milling beveling head allowing smooth operation and exceptional efficiency.

BM-25S allows milling of straight edges with a bevel width up to 25 mm and the variable spindle speed makes it easy to optimize cutting conditions.

Continuously adjustable bevel angle between 0 and 90 degrees and milling depth for full control of the milling process.

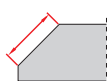
The beveller is equipped with a roller guide, which makes it easy and light to operate. All components of the guide are made of stainless steel to protect against contamination.

BM-25S has got a state-of-the-art electronic motor overload module protecting the operator, the machine and the tooling.



### ■ Features and benefits:

- contamination-free stainless steel processing
- maximum 25 mm bevel width (more than one pass could be required)
- continuously adjustable bevel angle between 0 and 90 degrees – one milling head in use only
- powerful motor with electronic speed control between 1800–5850 rpm to work with various materials
- a single head works with the face milling method, allowing less milling resistance and effort for the operator
- overload protection to prevent motor damage
- continuous milling depth adjustment to fully control the beveling process
- milling head is equipped with 5 pcs of 4-sided indexable cutting inserts
- adjustable handle and grip for comfort and ergonomics



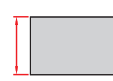
Max bevel width  
25 mm



Top beveling



Bevel angles 0° - 90°  
15°-75° (recommended)



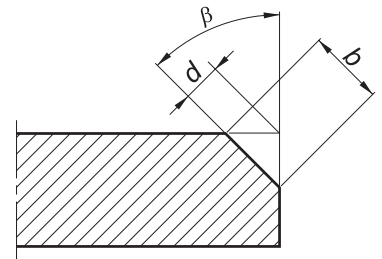
Min plate thickness  
2 mm



Pipe OD beveling  
min. OD 100 mm (4")  
(option)

**Bevel width up to 25 mm at 45 degrees:**

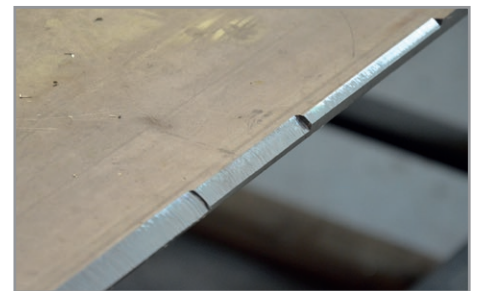
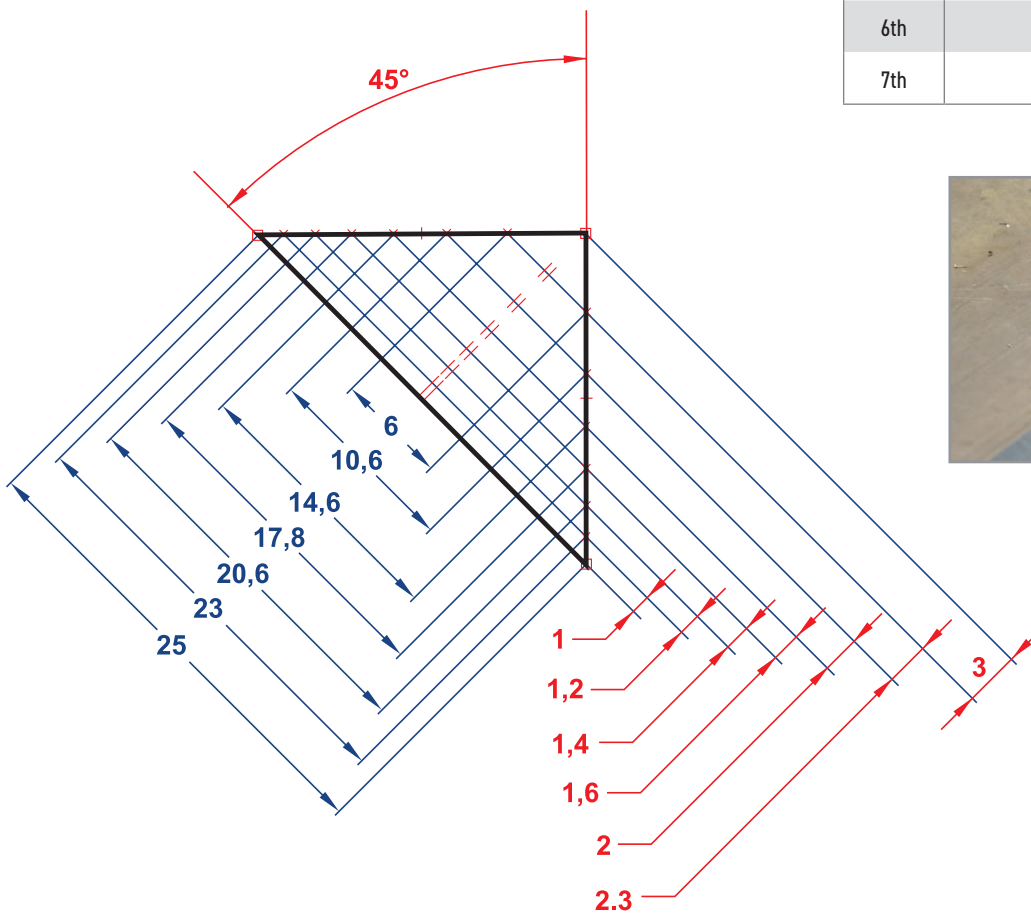
- Various bevel widths (b) are possible by means of BM-25S
- The final results depend on combination of bevel angle ( $\beta$ ) and bevel depth (d)



**Stainless Steel machining step-by-step:**

- Gradually increase the head penetration into the material to enlarge bevel width step-by-step
- Do not exceed the maximum head penetration in successive passes (see table below)
- It is recommended to remove a similar volume of stainless steel in each successive step

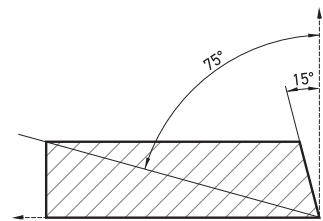
| BM-25S - recommended way of working with stainless steel |   |                           |
|--|---|---------------------------|
| Pass no.   | Max. In-depth progress of milling head [mm] | Bevel width obtained [mm] |
| 1st  | 3.0   | 6.0                       |
| 2nd  | 2.3   | 10.6                      |
| 3rd  | 2.0   | 14.6                      |
| 4th  | 1.6   | 17.8                      |
| 5th  | 1.4   | 20.6                      |
| 6th  | 1.2   | 23.0                      |
| 7th  | 1.0   | 25.0                      |





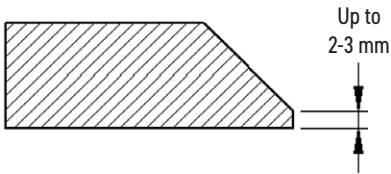
## Continuously adjustable bevel angle between 0 and 90 degrees:

- One milling head for full range of angles
- No need for separate milling heads for specific angles
- Recommended bevel angle from 15 to 75 degrees



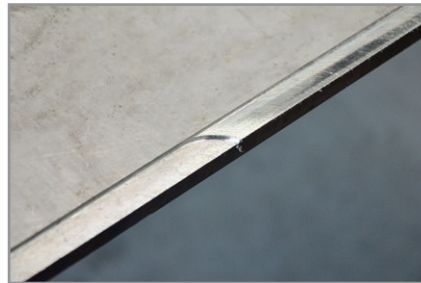
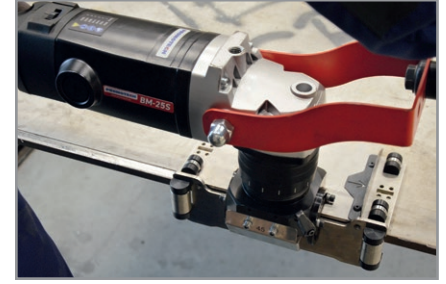
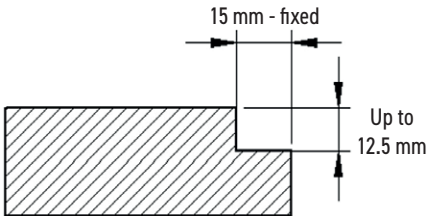
## Work at 0 degree:

- Facing process to produce a flat surface such as lands/root faces



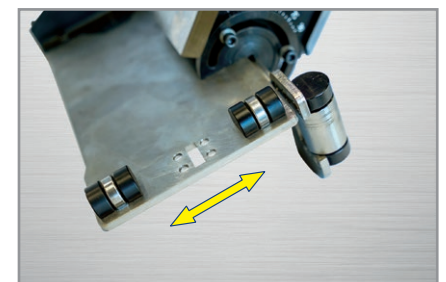
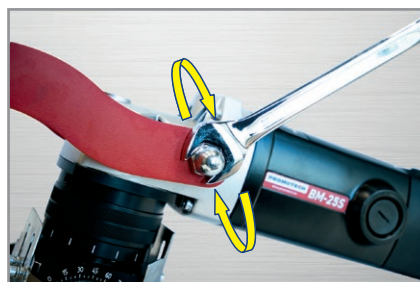
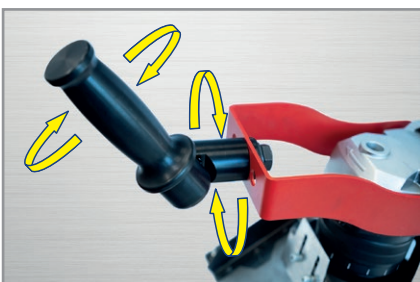
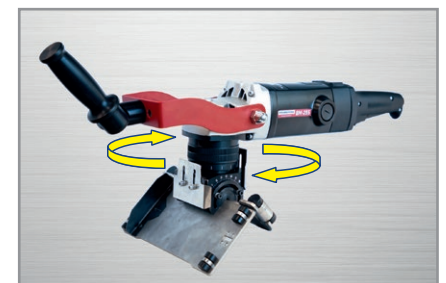
## Work at 90 degrees:

- Removal of the upper layer of 15 mm in width
- Lowering of the plate edge height



## Comfort and ergonomics of work:

- Each user can individually adjust the position of the grip and handle
- Grip can be rotated through 360 degrees
- The handle can be tilted to the desired angle
- Adjustable grip and handle enable comfort of work for both right and left-handers and operators of different heights
- Roller guide can be rotated through 360 degrees
- 2 possible positions of rollers (wide and narrow)



## BM-25S TECHNICAL SPECIFICATION

|                                  |  |
|----------------------------------|--|
| Voltage                          | 1- 110-120 V, 50-60 Hz<br>1- 220-240 V, 50-60 Hz |
| Power                            | 2200 W   |
| Spindle speed (without load)     | 1800-5850 rpm                                    |
| Maximum bevel width (b, Fig. 1)  | 25 mm (1")                                       |
| Maximum depth of cut (d, Fig. 1) | 12,5 mm (1/2")                                   |
| Bevel angle ( $\beta$ , Fig. 1)  | 0°-90°<br>15°-75° (recommended)                  |
| Minimum workpiece thickness      | 2 mm (0.08")                                     |
| Weight                           | 12,5 kg (27 lb)                                  |
| Product Code 110-120 V, 50-60 Hz | UKS-0825-10-10-00-0                              |
| Product Code 220-240 V, 50-60 Hz | UKS-0825-10-20-00-0                              |

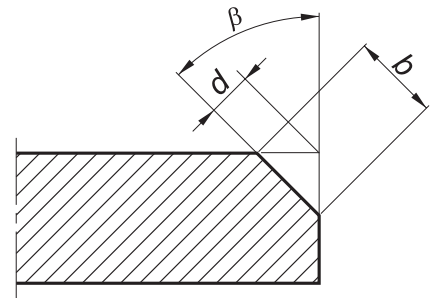
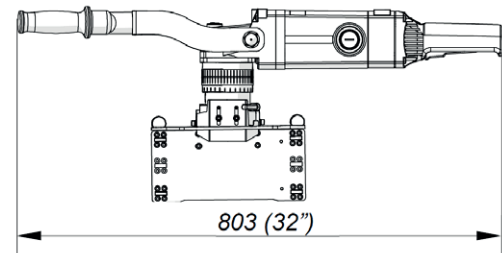
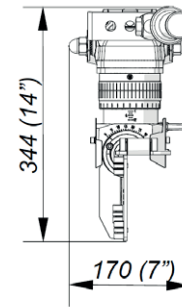


Fig. 1

## Dimensions

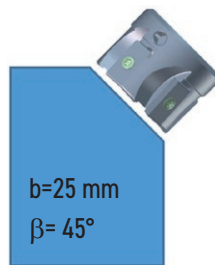


### Standard shipping set:

- Beveling machine incl. milling head with 5 cutting inserts
- Plastic box
- 3 chip guards (basic, 30°, 45°)
- Grease for screws (5 g, 0.17 oz)
- Drift
- 22 mm flat wrench
- 4 mm hex wrench
- 10 mm hex wrench
- Operator's manual

### BM-25S uses face milling head that features:

- Less milling resistance
- Less effort for the operator
- Increased range of bevel widths that can be made manually up to 25 mm



### Accessories:



ZST-0715-23-00-00-0  
Milling head for stainless steel



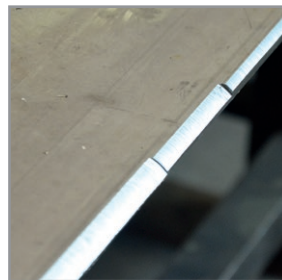
PLY-000849  
Cutting insert for stainless steel  
(sold 10 pcs/box)



WKR-000592  
Insert fixing screw for stainless steel



ZST-0715-25-00-00-0  
Set for external beveling of pipes made of stainless steel with a minimum diameter of 100 mm (4")



All information is subject to change without notice. 24.10



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