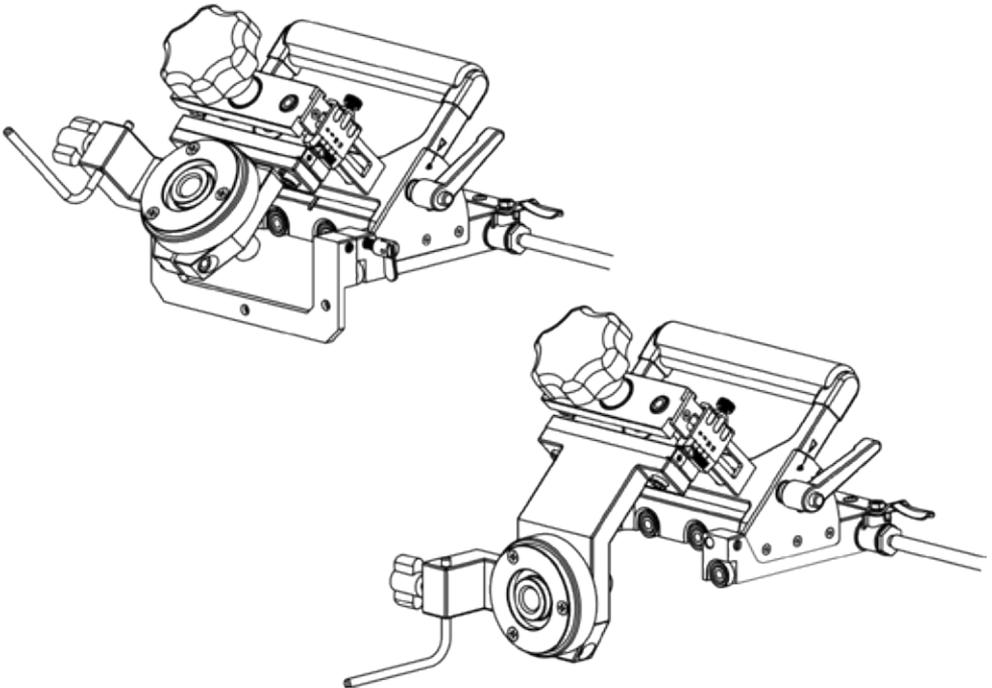

Alpha[®] Beveling Auxiliary Base Instruction Manual



Part No: BAB1590
Version 2

 **Alpha Professional Tools**[®]

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INTRODUCTION

Thank you for purchasing the Alpha® Beveling Auxiliary Base. To ensure correct use, read this Instruction Manual and the Instruction Manual for the power tool and follow the operating instructions. Keep this manual in a place where operators can access it easily whenever necessary!

► ABOUT THE SYMBOLS

According to the hazard level, all safety notes in this manual are classified into “DANGER”, “WARNING”, and “CAUTION”.

 **DANGER!** Death or serious personal injury is imminent when handling this polisher incorrectly.

 **WARNING!** There is a possibility of death or serious personal injury when handling this polisher incorrectly.

 **CAUTION!** There is a possibility of personal injury or property damage when handling this polisher incorrectly.

Note: In some situations, failing to observe **WARNING** notes could result in death or serious personal injury. Be sure to read and observe the safety notes to ensure safety and correct use of the beveling base.

► PRECAUTIONS FOR USING BEVELING AUXILIARY BASE

Although the rollers for the base are made of nylon, it is possible that they may cause minor scratches on the surface of granite. To prevent that from occurring, we recommend that the polished surface be covered with masking tape before using this product.

ALPHA® BEVELING AUXILIARY BASE OVERVIEW

(CLAMPING BASE FOR 15-45° ANGLE)

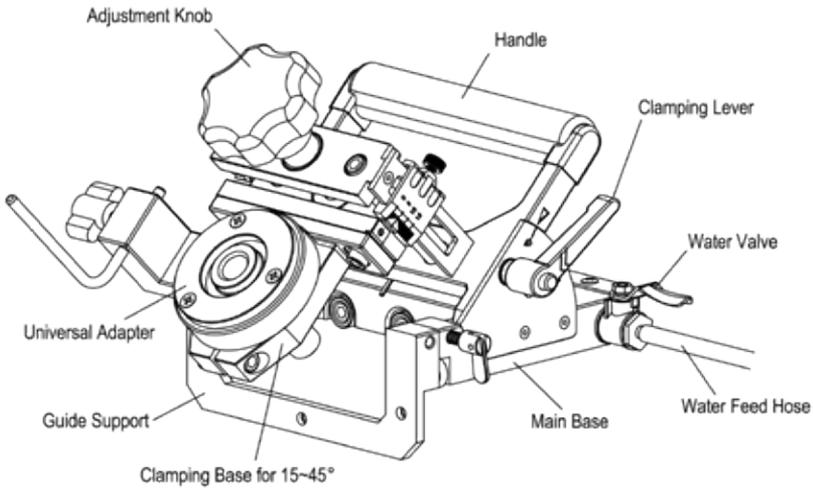


Figure-1

► SPECIFICATIONS

- Beveling Angle : 15 ~ 45°
- Beveling Depth : 3/8" (10mm Max)
- Straight Angle : 90°
- Max. Pad Size : 4" (100mm)
- Spindle : 5/8"-11
- Weight : 3.57 lbs. (1.62 kgs)

ALPHA® BEVELING AUXILIARY BASE OVERVIEW

(CLAMPING BASE FOR 90° ANGLE)

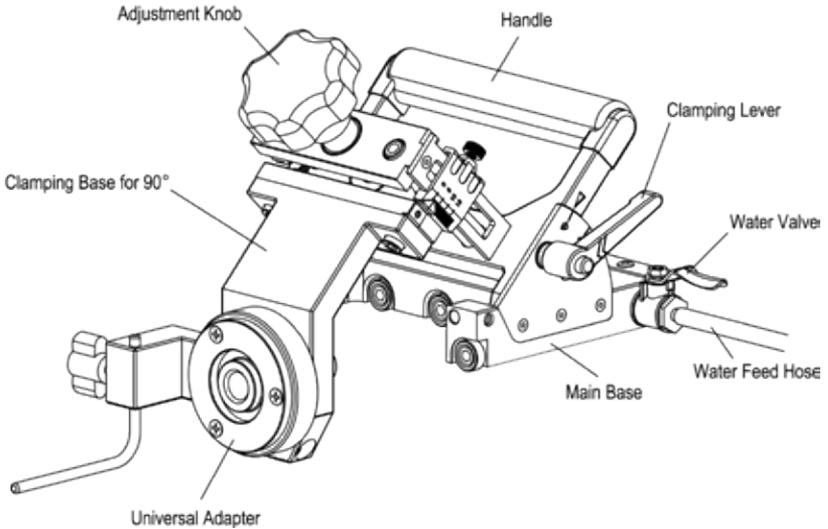


Figure-2

► FEATURES

- Simple Operation
- Perfect Finishing
- Time Saving
- Adjust the desirable bevel angle from 15 ~ 45°
- Adjust the beveling depth from 0.1~10 mm
- Micrometric scale to calibrate the chamfering depth
- 8 rolling wheels to facilitate moving.
- Designed to fit various sanders/polishers/grinders, simply by changing the clamp.
- Quickly change the abrasive / polishing pad while working.

ACCESSORIES

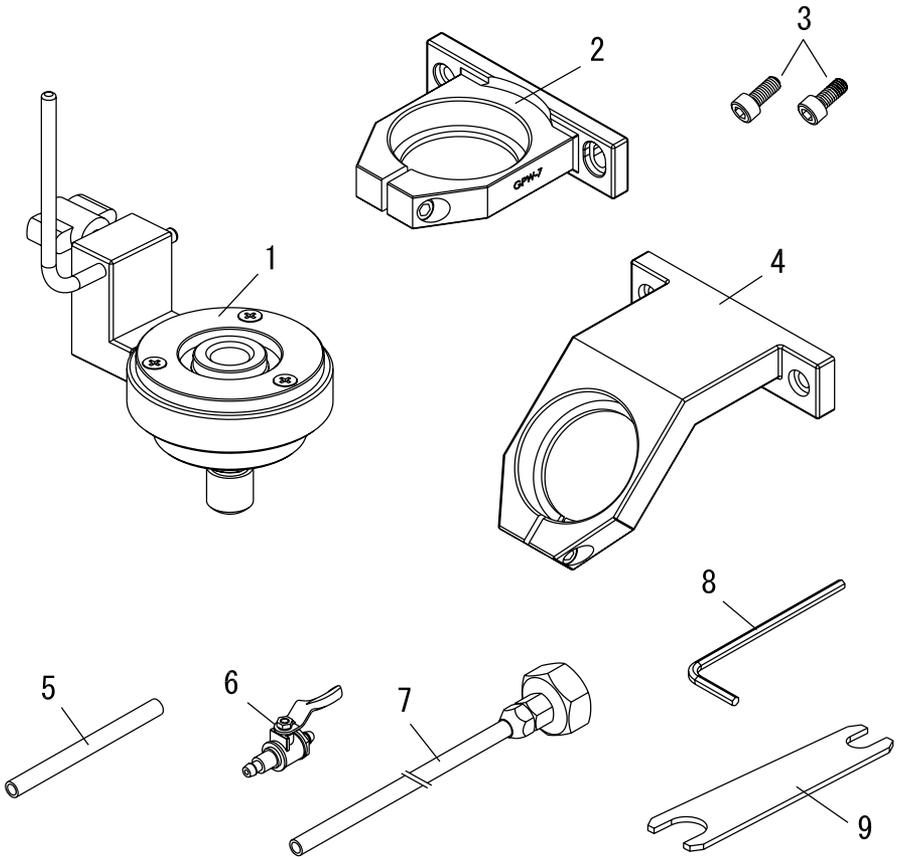


Figure-3

► COMPONENTS

1.	Universal Adapter Assembly	1 set
2.	Clamping Base for 15~45° Angle	1 pc
3.	Screws	2 pcs
4.	Clamping Base for 90° Angle	1 pc
5.	Water Hose	1 pc
6.	Water Valve	1 pc
7.	Water Hose Assembly (3M).....	1 set
8.	Hex. Wrench (5mm).....	1 pc
9.	Spanner	1 pc

ATTACHING CLAMPING BASE FOR 15~45° ANGLE

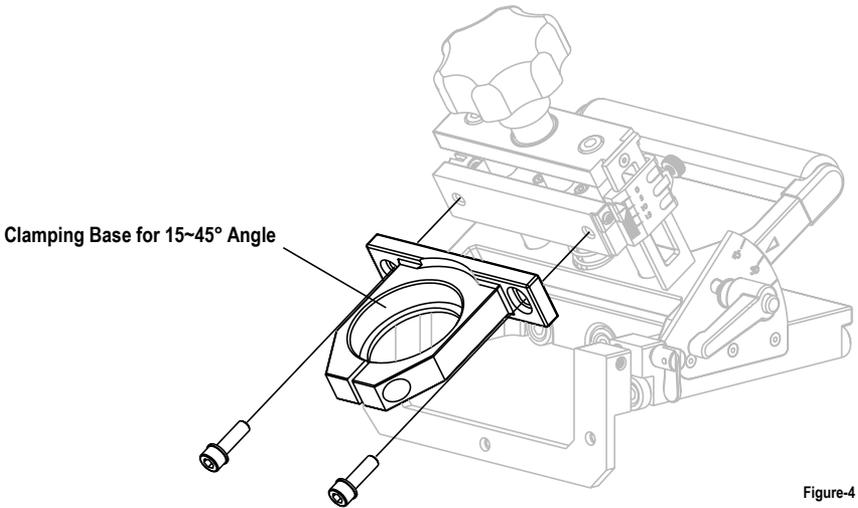


Figure-4

ATTACHING CLAMPING BASE FOR 90° ANGLE

1. Remove Support Assy. and two screws.

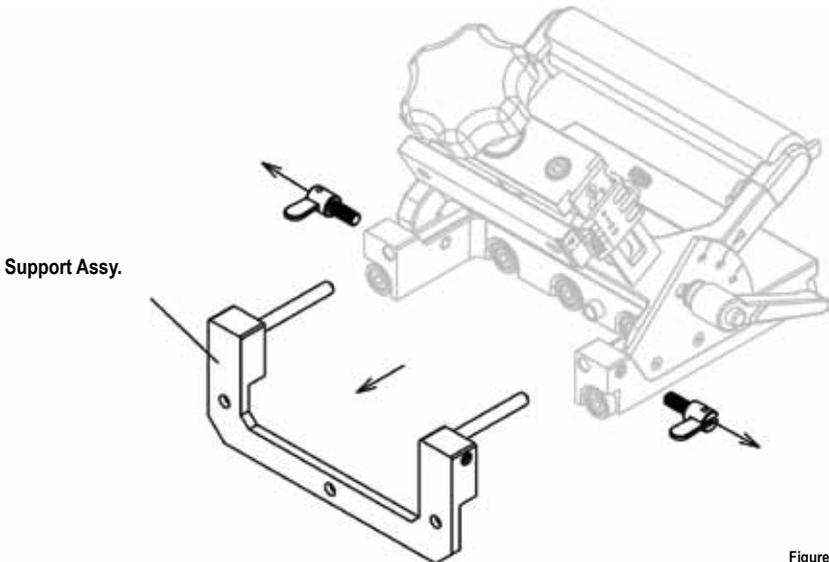


Figure-5

ATTACHING CLAMPING BASE FOR 90° ANGLE (CONT'D)

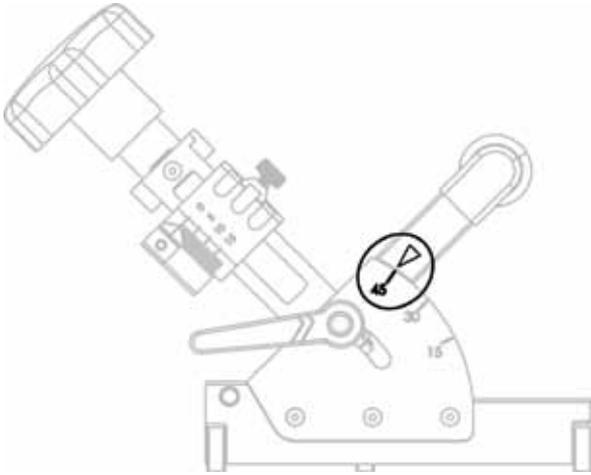
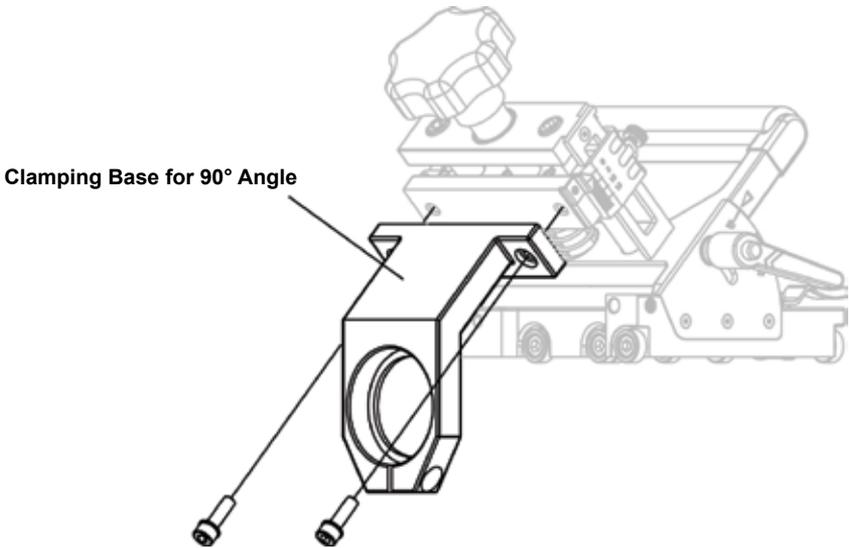


Figure-6

2. Set to 45°.



3. Attach 90° Clamping Base to Main Base.

Figure-7

ATTACHING THE UNIVERSAL ADAPTER

1. Attach to Clamping base for 15~45° Angle.

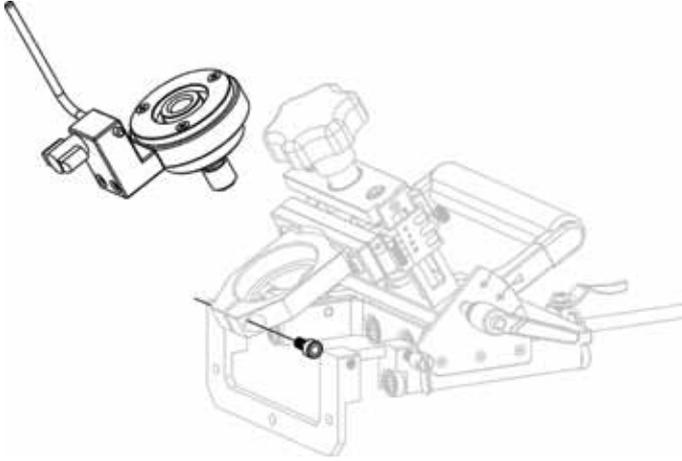


Figure-8

2. Attach to Clamping base for 90° Angle.

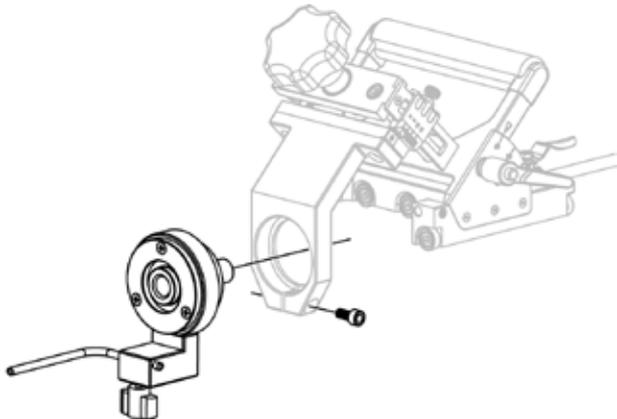
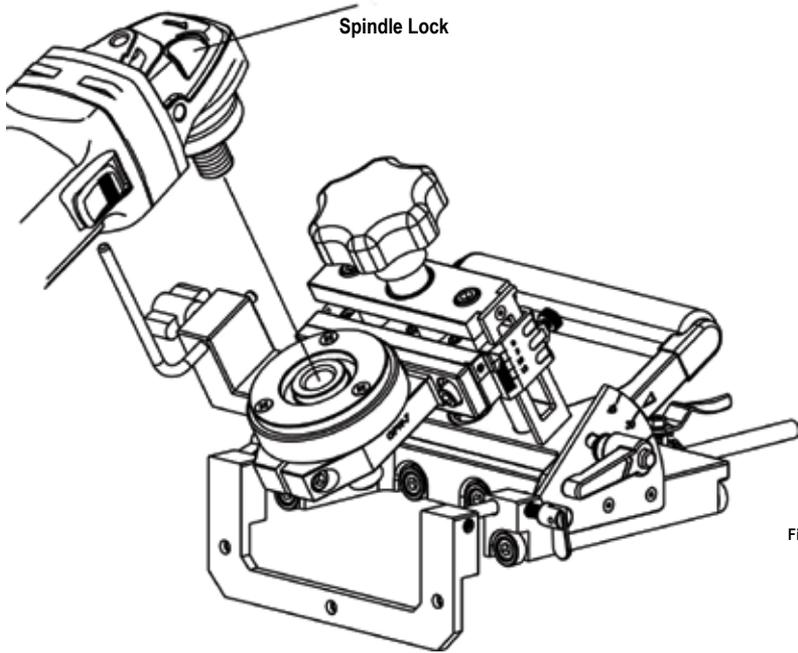


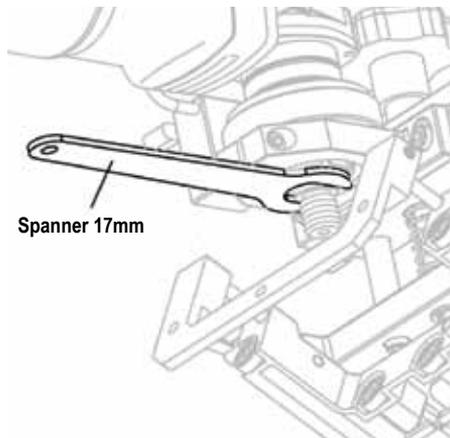
Figure-9

ATTACHING GRINDER/POLISHER TO MAIN BASE

1. Push Spindle Lock and turn Spindle of the Universal Adapter.

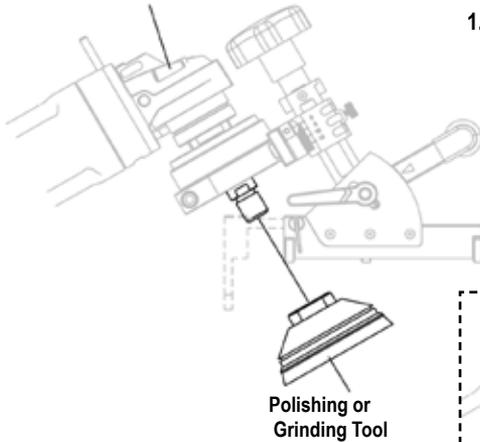


2. Tighten using Spanner.



INSTALLING GRINDER/POLISHER ACCESSORIES

Spindle Lock



1. Push the spindle lock and install the grinding or polishing accessory, then tighten it using the wrench.

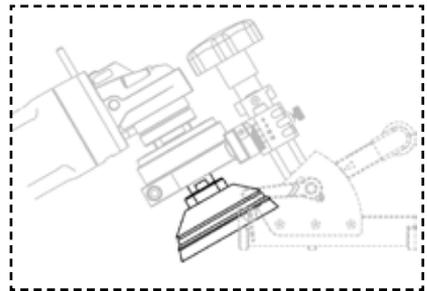


Figure-11

ATTACHING BEVELING BASE TO WORKPIECE

1. Place the beveling auxiliary base with grinder/polisher on the edge of the stone slab and push the Guide Support against the stone while the Guide Support is secured to the base.
2. Loosen up the Fixing Bolt to make the grinding wheel cutting depth adjustment available.

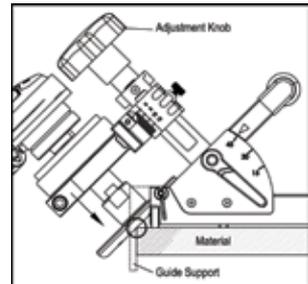


Figure-12

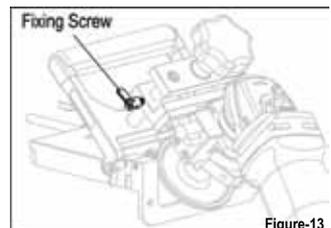


Figure-13

3. Turn the Adjustment Knob counterclockwise to lower the wheel until the wheel is lightly touching the corner of the stone.
4. Loosen up the Fixing Bolt on the Angular Measure then set the indicator to point "0", next secure the Angular Measure by tightening up the Fixing Bolt.

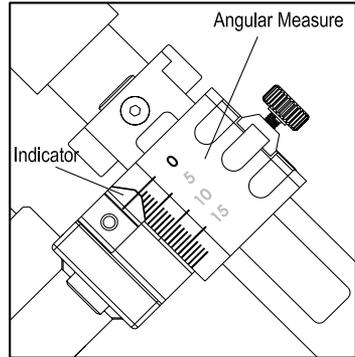


Figure-14

5. Turn the Adjustment Knob to lower to the desired cutting depth (5mm shown in Figure 15). Next secure the wheel position by tightening up the Fixing Bolt. It is now ready for the grinding application.

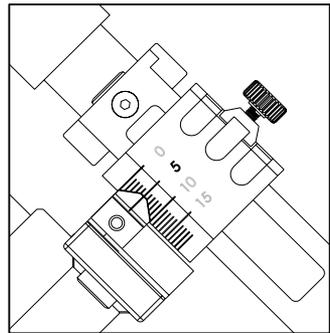


Figure-15

► REMARKS

When you start grinding the corner, the Guide Support is not touching the edge of stone. When you reached to the desired depth of grinding, the Guide Support touches against the edge of the stone and works as a stopper to create a uniform width of beveled edge.

BEFORE

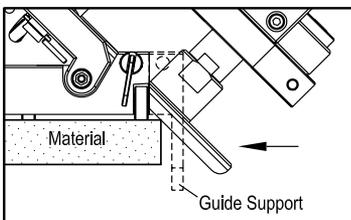


Figure-16

AFTER

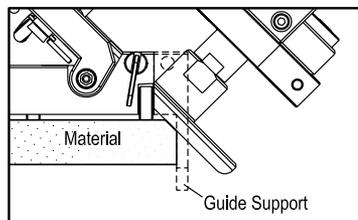


Figure-17

BEVEL GRINDING/POLISHING (15- 45°)

1. Attach the Turboshine Grinding Wheel, 60 grit (Part # TSV30060M) to the Universal Adapter. When attaching the grinding wheel make sure that the grinding wheel does not make contact to the main base of the BAB1590.
2. Adjust the Beveling Auxiliary Base to the desired angle to be performed.
3. Start grinding the edge of the material by moving the Beveling Auxiliary Base across the material in back and forth motions. Make sure that the Guide Support keeps in contact with the edge of the material to create a consistent width across the edge of the material.
4. When the desired thickness bevel has been created, the grinding process is complete.
5. Attach the Turboshine Dual Adapter to the Universal Adapter.
6. Attach either the #100 grit or #200 grit Turboshine (Rigid) to the Dual Adapter. Operator will choose which grit will work best for the application based on operator's experience.
7. Move the Beveling Auxiliary Base across the material in back and forth motions making sure that the Guide Support keeps in contact with the edge of material during polishing.
8. Continue the polishing process using the remaining grits of the Turboshine System.

► HELPFUL HINT:

- When the work piece requires a bevel polish and straight polish on the same edge, perform the bevel polish first before polishing the straight edge.
- Securing “dummy” pieces of stone on both ends of the work piece will assist the operator to achieve a successful polish to the end of the stones edge. Once the operator becomes experienced using the Beveling Auxiliary Base, they may choose not to add the “dummy” stones.

► SURFACE PROTECTION:

- To eliminate any potential scratching on the surface of the material you are grinding/ polishing, we recommend placing “Surface Protection” on the surface of the material. Surface protection will protect the top surface from any possible scratches when the roller wheels of the Beveling Auxiliary Base rolls across the surface. Flat plastic sheets are good examples of surface protection for this application.

STRAIGHT EDGE GRINDING (90°) USING “STRAIGHT EDGE GUIDE”

1. Attach the Turboshine Grinding Wheel, 60 grit (Part # TSV30060M). When attaching the grinding wheel make sure that the grinding wheel does not make contact to the main base of the BAB1590

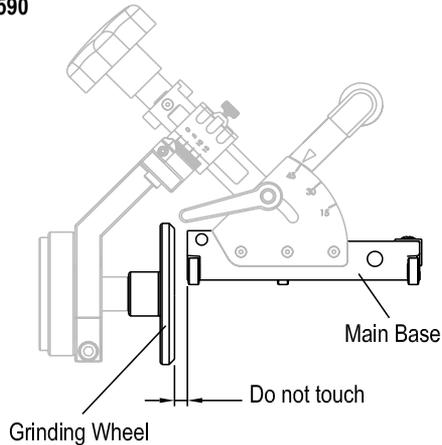


Figure-18

2. Lay the straight edge guide parallel to the edge of the material.
3. Determine the distance of the straight edge guide from the edge of material, measure the distance from the grinding wheel's surface to the back of the main base.
4. After the distance of the straight edge guide has been determined, secure it using clamps. (See Fig. 18 & 19 on page 14)
5. Move the Beveling Auxiliary Base across the material in back and forth motions
6. until the Main Base makes flush contact with the straight edge guide.

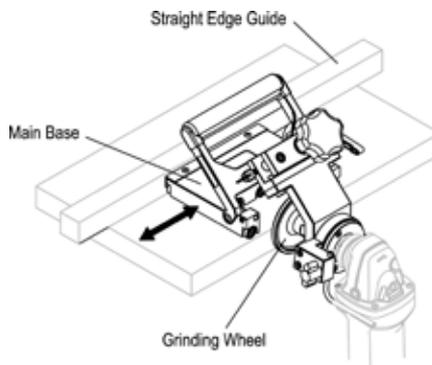


Figure-19

NOTE: Grinding of the material is complete when the operator no longer hears a grinding noise.

STRAIGHT EDGE POLISHING (90°) USING A “STRAIGHT EDGE GUIDE”

1. Attach the Turboshine Dual Adapter to the Universal Adapter.
2. Attach either the #100 grit or #200 grit Turboshine (Rigid) to the Dual Adapter. Operator will choose which grit will work best for the application based on operator's experience.
3. Lay the straight edge guide parallel to the edge of the material.
4. Determine the distance of the straight edge guide from the edge of material, measure the distance from the polishing wheel's surface to the back of the main base.
5. After the distance of the straight edge guide has been determined, secure it using clamps. (See Fig. 18 & 19 on page 14)
6. Move the Beveling Auxiliary Base across the material in back and forth motions making sure that the Main Base keeps in contact with the straight edge guide during polishing.
7. Continue the polishing process using the remaining grits of the Turboshine System.

NOTE: Operator can remove the straight edge guide after the #200 grit since the remaining grits are not aggressive enough to alter the stones straightness.

► HELPFUL HINT:

1. When the work piece requires a bevel polish and straight polish on the same edge, perform the bevel polish first before polishing the straight edge.
2. Securing “dummy” pieces of stone on both ends of the work piece will assist the operator to achieve a successful polish to the end of the stones edge. Once the operator becomes experienced using the Beveling Auxiliary Base, they may choose not to add the “dummy” stones.
3. Using the straight edge guide is optional, operator may choose not to use the straight edge guide based on their experience.
4. Straight Edge Guide can be used for calibrating the stone if the bridge saw cut is not a true 90° angle.

STRAIGHT EDGE PREPARATION (90°) FOR SEAMLESS COUNTERTOPS

1. Attach the Turboshine Dual Adapter to the Universal Adapter.
2. Attach either the #100 grit or #200 grit Turboshine (Rigid) to the Dual Adapter. Operator will choose which grit will work best for the application based on the operator's experience.
3. Lay the straight edge guide parallel to the edge of the material.

STRAIGHT EDGE PREPARATION (90°) FOR SEAMLESS COUNTERTOPS (Cont'd)

4. Determine the distance of the straight edge guide from the edge of material, measure the distance from the Turboshine wheel's surface to the back of the main base.
5. After the distance of the straight edge guide has been determined, secure it using clamps. (See Fig. 18 & 19 on page 14)
6. Move the Beveling Auxiliary Base across the material in back and forth motions making sure that the Main Base keeps in contact with the straight edge guide during polishing.
7. Continue the seamless preparation up the #500 grit Turboshine to complete the edge preparation for seamless countertops.

▶ HELPFUL HINT:

To create a seamless countertop, you will need to butt joint the stones. Prior to applying the adhesive to secure both pieces together a groove needs to be created. This groove provides an area for the adhesive to adhere in each stone to create a strong bond necessary for the perfect seamless countertop. The Alpha® Groove Cutter is the perfect item to create these grooves. Our patented design assures the grooves will be level to achieve maximum strength at each joint. The Groove Cutter works with the most popular high-speed angle grinders available on the market. A universal safety guard equipped with a water-feed and a Ground Fault Circuit Interrupter are the perfect accessories for this application and are available from Alpha®. For more information or to view an instructional video, visit us on the web at www.alpha-tools.com.

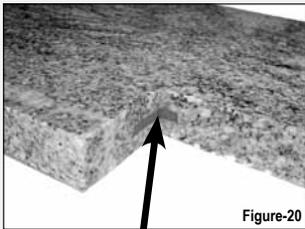


Figure-20
Cut-out Sample
Showing Joint Seaming



GCWKIT

Figure-22

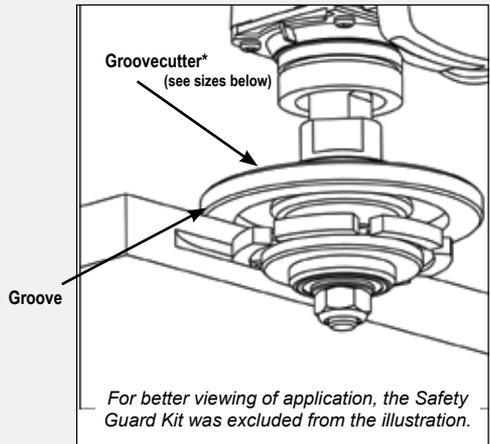
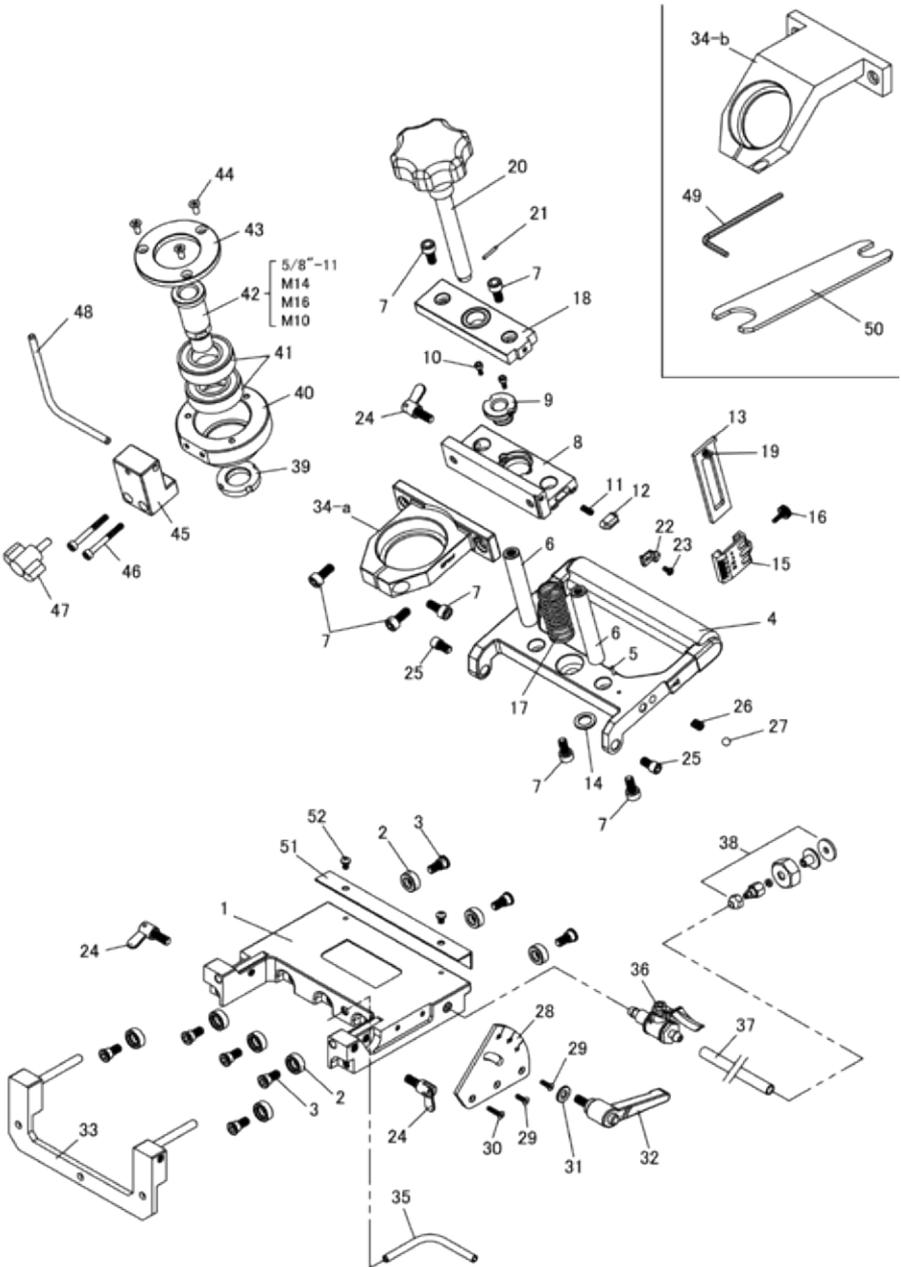


Figure-21

*Groovecutter sizes:

G CW258	4.2mm	3/4" Slab Granite
G CW358	7.5mm	1-1/4" Slab Granite
M CW258	4.6mm	3/4" Slab Marble

ALPHA® BEVELING AUXILIARY BASE SCHEMATIC



ALPHA® BEVELING AUXILIARY BASE PARTS LIST

DRAWING NO.	PART NO.	DESCRIPTION	QUANTITY
1	150001	Main Base	1
2	150002	Rolling Wheel	8
3	150003	Screw A01A10101	8
4	150004	Handle	1
5	150005	Pin P001	1
6	150006	Gliding Pin	2
7	150007	Hex. Screw CAP021	7
8	150008	Lift Base	1
9	150009	Screw A01A30100	1
10	150010	Hex. Screw CAP042	2
11	150011	Spring S064	1
12	150012	Gliding Spacer	1
13	150013	Guide Rail	1
14	150014	Washer T10X16X1.5	1
15	150015	Angular Measure	1
16	150016	Fixing Bolt	1
17	150017	Spring S074	1
18	150018	Bolt Base Assy.	1
19	150019	Screw MT005	1
20	150020	Bolt Assy.	1
21	150021	Spring Pin	1
22	150022	Indicator	1
23	150023	Screw MC006	1
24	150024	Screw MP6X14	3
25	150025	Fixing Screw	2
26	150026	Spring S070	1
27	150027	Steel Ball	1
28	150028	Angular Table	1
29	150029	Screw MT008	2
30	150030	Screw MT009	1
31	150031	Washer T6.5X13	1
32	150032	Clamping Lever	1
33	150033	Support Assy.	1
35	150036	Water Hose	1
36	150037	Water Valve Assy.	1

ALPHA® BEVELING AUXILIARY BASE PARTS LIST

DRAWING NO.	PART NO.	DESCRIPTION	QUANTITY
37	150038	Water Hose (3M)	1
38	150039	Coupling Assy.	1
39	150040	Bearing Nut	1
40	150041	Bearing Housing	1
41	150042	Ball Bearing (B6004LLU)	2
42	150043	Main Shaft (5/8"-11 UNC) *Other sizes available upon request	1
43	150044	Bearing Housing Cover	1
44	150045	Screw MT011	3
45	150046	Bracket	1
46	150047	Hex. Screw CAP044	2
47	150048	Screw with Knob	1
48	150049	Stopper	1
49	150050	Hex. Wrench 5mm	1
50	150051	Spanner Wrench	1
51	150053	Guide Bar	1
52	150054	Screw	2
34-a	150034	Clamping Base for 45° Angle	1
34-b	150035	Clamping Base for 90° Angle	1
Not Shown	150052	Builder's Plate	1

APPENDIX

NOTE: During the 90° Straight Edge Grinding/Polishing applications, water spray can be contained by attaching the Alpha® Splash Guard (Part # 210089*) on the Beveling Auxiliary Base. * Splash Guard Sold Separately

Without Splash Guard

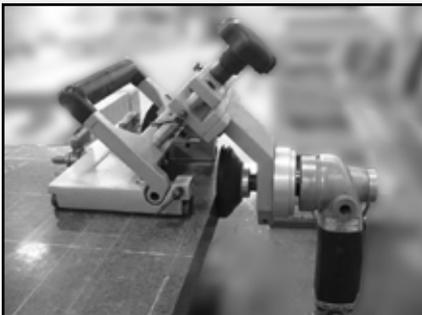


Figure-23

Splash Guard Attached

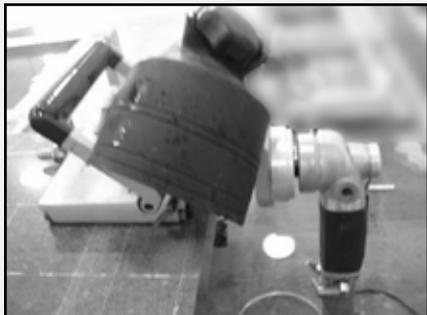


Figure-24



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06/2014
