REX

OPERATION MANUAL

N40AV · N40A
N50AV · N50A
N80AV · N80AⅢ · N80A

Ref. No. 198505
Ref. No. 199412
Ref. No. 199003

Important

For your own safety, best performance and a long tool life, read this Operation Manual carefully and completely before assembling and operating this unit.
Study the operation, application and potential hazards peculiar to this unit.

CONTENTS

Dear Customer

We congratulate you for having chosen a REX thread cutting machine.
To ensure a trouble-free operation, please read these operating instructions carefully before using the unit for the first time.

Introductory Information

The thread cutting machine N40A series, N50A series and N80A series are light-weight, portable and compact units with a wide range of technical features. These machines are ideally suited for shop or on-site use.

Safety Rules

* Make sure that the machine has been set up correctly and that the main voltage is as specified.
* Before using the machine for the first time, acquaint yourself with all operational steps and functions of the unit.
* Use the machine only for its intended purposes. The following operations are not allowed: thread sealing, mounting and removing of pipe fittings, the use of manual pipe cutters and manual slide calipers, as well as holding the material by hand instead of using the attachments.
* Make sure that the operator's work place is safe, with sufficient lighting and space around the machine.
* Please ensure that the necessary maintenance is performed in periodic intervals and by qualified personnel.
* Do not use the unit before all the safety devices have been set up and activated.
* Always interrupt the power supply to the unit before doing maintenance work or adjustments.
* When the machine is running, keep hands and arms away from the cutting tools.
* Juveniles may operate a power-driven thread cutting machine only if they are older than 16 years and this type of work is required in order to reach their training objective; supervision by a qualified person is also mandatory.
* Provide a safe standing place and take care not to lose your balance.
* If you plan to use short pipe lengths, make sure beforehand that they cannot jam the machine.
* Avoid loose clothing, it may get caught on moving parts.
* Safety first - don't take a chance.

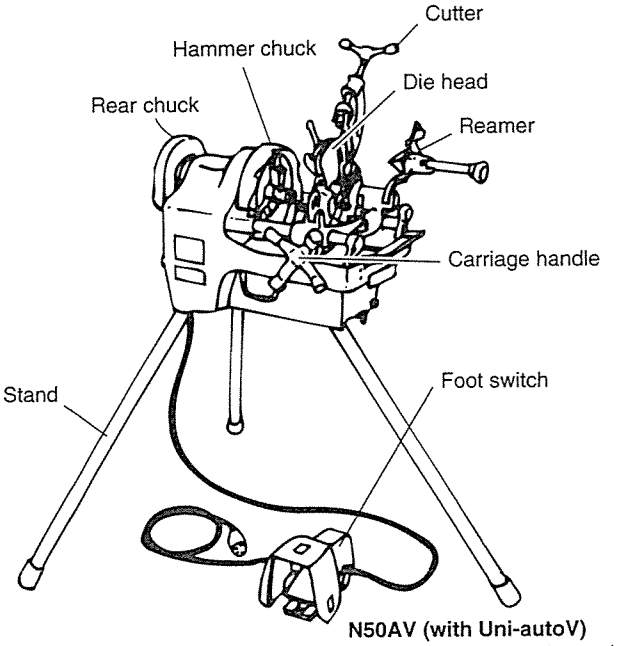
Supplied Items & Main Parts

Supplied Items

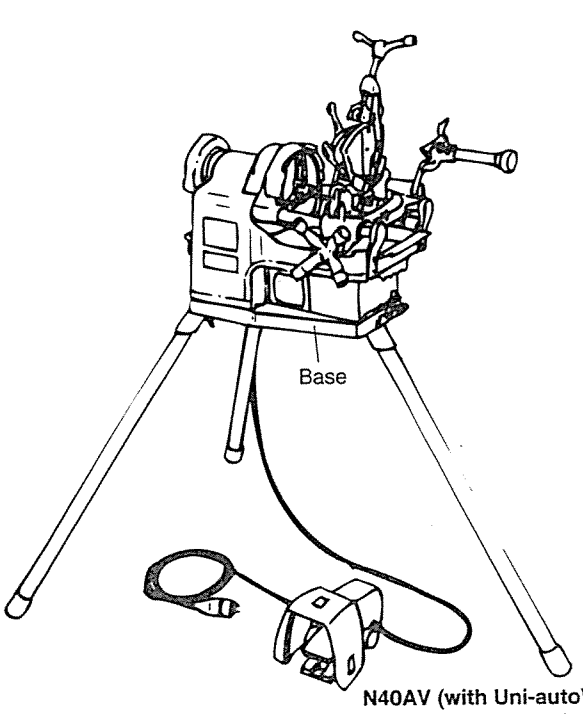
The main unit plus safety devices; three-stage safety foot switch, including NOT/AUS function (EMERGENCY/STOP); self-opening automatic die head (AV, AIII machine) or Manual die head (A machine); 2 sets of dies (N40A series and N50A series) or 3 set of dies (N80A series); pipe cutter; reamer; tool kit.

* Thread cutting machines must be connected to the main power supply only via a 30 mA fault current breaker, if installed on construction sites, open-air work places and similar locations.

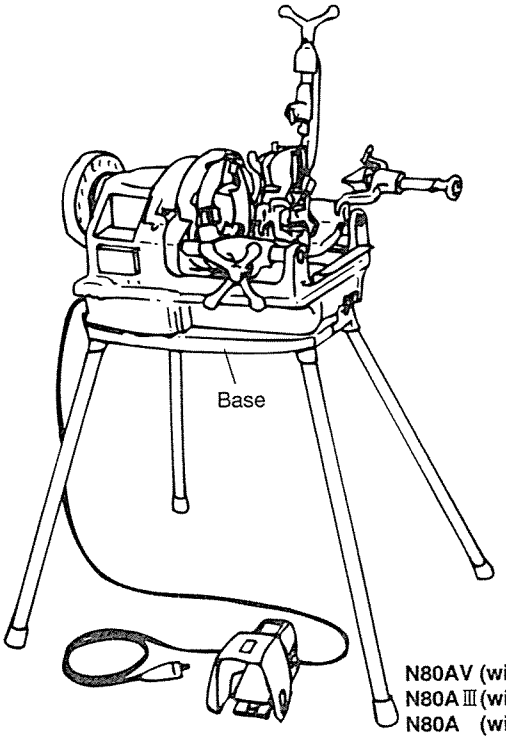
Main Parts



N50AV (with Uni-autoV)
N50A (with Manual-open)



N40AV (with Uni-autoV)
N40A (with Manual-open)



N80AV (with Uni-autoV)
N80A Ⅲ (with Self-opening)
N80A (with Manual-open)

Specifications & Standard Accessories

Specifications

N40AV N40A

Specifications

Capacity:	1/2–1 1/2″ (threading, cutting, reaming)
Voltage:	110V, 230V models available
Motor:	Single phase 500W series motor
Rotation speed:	58 r.p.m. (without load)
Net weight:	81 lbs (36.8kg)
Dimensions:	540 (L) × 345 (W) × 355 (H) mm
N40A:	Surface sound pressure level Lpf=86dB (A)
	101g (S/1m²) =13dB (A)
	Sound power Lw=99dB (A)

Standard Accessories

N40AV die head:	Uni-auto V (1/2–1 1/2″) one
N40A die head:	Manual-open (1/2–1 1/2″) one
Dies (BSPT or NPT):	(1/2–3/4″) (1–1 1/2″) one set each
Thread cutting oil:	2 liters 1 can
Machine cover:	1 pc
Tool box:	1 pc
Hexagonal keys:	3, 4, 5, 6 mm one each
Screw driver:	Cross point one
Bearing oil:	1 (with oiler)
Carbon brush:	1 set (with auto-stop)

N80AV, N80AIII, N80A

Specifications

Threading capacity:	1/2–3″ (threading, cutting, reaming)
Voltage:	110V, 230V models available
Motor:	Single phase 700W series motor
Rotation speed:	31 r.p.m. (without load)
Net weight:	131 lbs (59kg)
Dimensions:	785 (L) × 480 (W) × 405 (H) mm
N80A:	Surface sound pressure level Lpf=86dB (A)
	101g (S/1m²) =13dB (A)
	Sound power Lw=99dB (A)

Standard Accessories

N80AVM die head:	Uni-auto V (1/2–2″) Manual open (2 1/2–3″) one each
N80AVIII die head:	Uni-auto V (1/2–2″) Self-opening (2 1/2–3″) one each
N80AIII die head:	Self-opening (1/2–3/4″) (1–2″) (2 1/2–3″) one each
N80A die head:	Manual-open (1/2–2″) (2 1/2–3″) one each
Dies (BSPT or NPT):	(1/2–3/4″) (1–2″) (2 1/2–3″) one set each
Thread cutting oil:	4 liters 1 can
Base and stand:	1 set, 4 legs
Machine cover:	1 pc
Tool box:	1 pc
Hexagonal keys:	3, 4, 5, 6 mm one each
Screwdriver:	Cross and minus point one each
Single head wrench:	13mm 1 pc
Bearing oil:	1 pc (with oiler)
Carbon brush:	1 set (with auto-stop)
Cutter wheel:	1 pc

N50AV N50A

Specifications

Threading capacity:	1/2~2″ (threading, cutting, reaming)
Voltage:	110V, 230V, models available
Motor:	Single phase 600W series motor
Rotation speed:	40 r.p.m. (without load)
Net weight:	96 lbs (43kg)
Dimensions:	605 (L) × 375 (W) × 390 (H) mm
N50A:	Surface sound pressure level Lpf=86dB (A)
	101g (S/1m²) =13dB (A)
	Sound power Lw=99dB (A)

Standard Accessories

N50AV die head:	Uni-auto V (1/2–2″) one
N50A die head:	Manual-open (1/2–2″) one
Dies (BSPT or NPT):	(1/2–3/4″) (1–2″) one set each
Thread cutting oil:	2 liters 1 can
Stand:	3 legs
Machine cover:	1 pc
Tool box:	1 pc
Hexagonal keys:	3, 4, 5, 6 mm one each
Screwdriver:	Cross and minus point one each
Single head wrench:	13mm 1 pc
Bearing oil:	1 pc (with oiler)
Carbon brush:	1 set (with auto-stop)
Cutter wheel:	1 pc

Warranty

Warranty

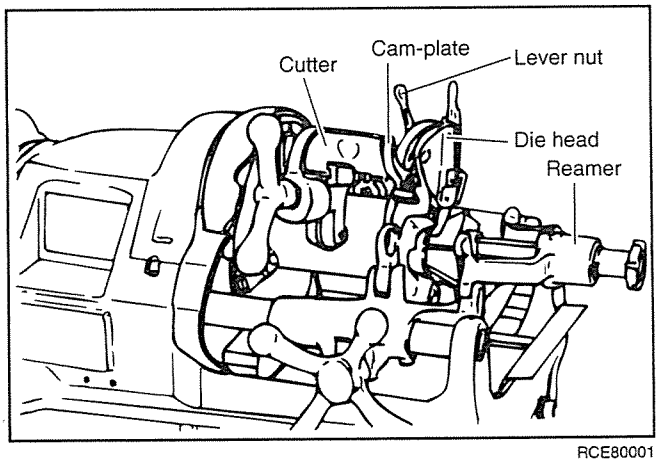
Thread cutting machines sold by us (REX agent) are covered by warranty for a period of ___ months, starting from the day of sale to the user, but not longer than ____ months after supplying the machine to the dealer. The user must supply proof of purchase by submitting the invoice.

Within the framework of the warranty we will repair free of charge any defects which are proven to be caused by faults in material or workmanship. Excluded from the warranty are all defects caused by normal wear and tear, incorrect use, non-compliance with operating instructions, operating with excessive load, use of unsuitable materials, as well as for all reasons which we holds no responsibility. The warranty is void if the machine has been tampered with or repairs have been performed by a third party, i.e. not by an agent authorized by us. Any warranty work must only be performed by us or a dealer which has been authorized by us to perform such repairs.

Warranty claims will only be recognized if the machine is supplied in an assembled state to us without prior repairs having been performed.

All charges for forwarding and returning the unit will be the responsibility of the user.

Preparation



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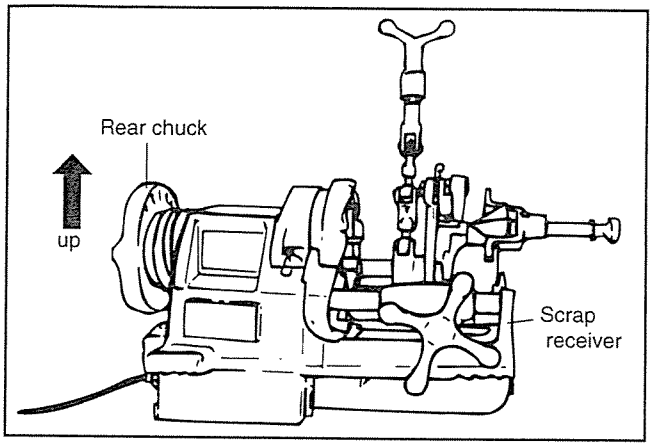
Transportation

It is not necessary to drain off the oil during transportation.

1. Insert a short pipe and close the chuck firmly.
   Caution:
   Make sure the length of the pipe is short enough to allow the die head to be lowered into position for transportation.
2. Manual-open die head and uni-auto die head:
   Release the lever nut, open the dies as far as they will go and then replace the setting lever on the corresponding pin.
   Self-opening die head:
   Set the cutting end of the pipe firmly in the chuck, remove the die head size setting lever from the pin and pull the cam-plate forward to fully open the dies.
3. Lock the reamer arm in the reaming position.
4. Lower the pipe cutter; turn the carriage handle clockwise to advance towards chuck side.
5. Turn the cutter handle, and secure the roller and pipe.
   The machine should then be secure during transportation.



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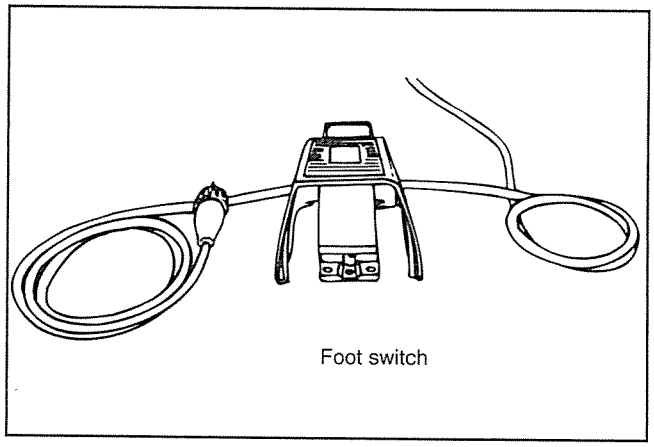
Machine set-up

This unit can be placed on any work bench. Just fill the tank located under the scrap receiver with about 2 liters of thread cutting oil. Now the machine is operational.



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Safe Operation

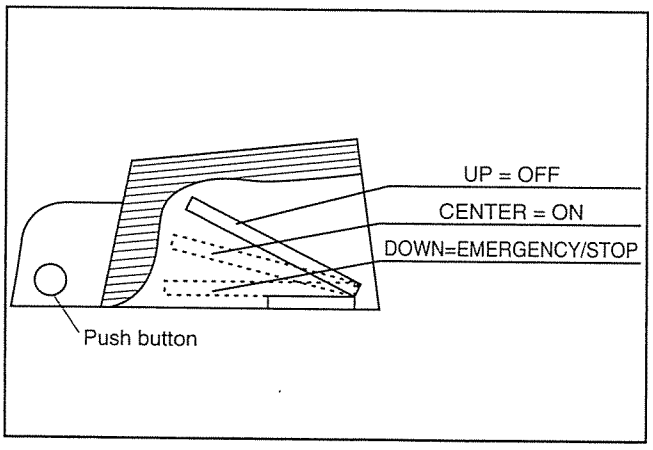
In compliance with the EU safety regulations, this machine must be equipped with a run-on limiter (after run) and a three-stage safety foot switch with NOT/AUS function (EMERGENCY/STOP) . The foot switch has three positions:

UP = OFF CENTER = ON DOWN = EMERGENCY/STOP

If the switch is vigorously pushed all the way down to the position NOT/AUS, the switch will be automatically locked and the power supply will be interrupted immediately to stop the machine. To turn on the machine again, it is necessary to push the button side of the foot switch housing.

Caution:

This machine is designed for cutting, threading and reaming of pipes, as well as for tapping solid work pieces. Thread sealing and the mounting/removing of pipe fittings are not permissible.



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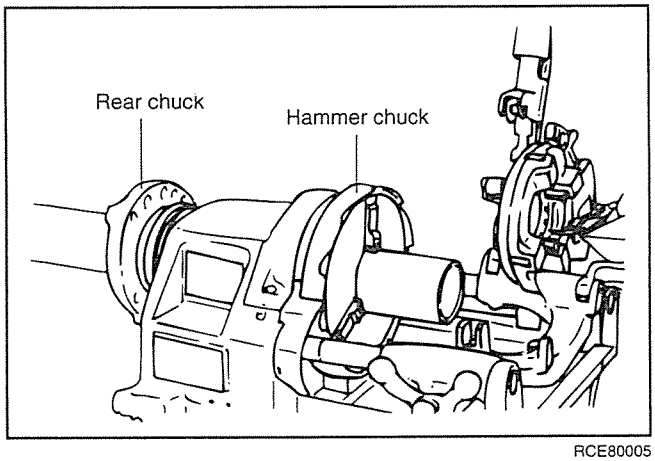
"The socket-outlet must be near this equipment and must be easily accessible."

If the danger zone formed by the machine and the rotating work piece does not allow a clear and unobstructed view, the rotating work pieces must be covered or encased over their full length, or the danger area must be roped off or secured by warning personnel. The protecting devices must be positioned and/or attached securely. If supports are used for this purpose, they must be stable, height-adjustable and set up in sufficient quantity.
Operators and helpers must wear tight-fitting clothes.
Gloves must be removed before the machine is switched ON; this also applies to necktie, jewellery, wrist watches and similar objects. It is dangerous to work on power-driven thread cutting machines with long, dangling hair.



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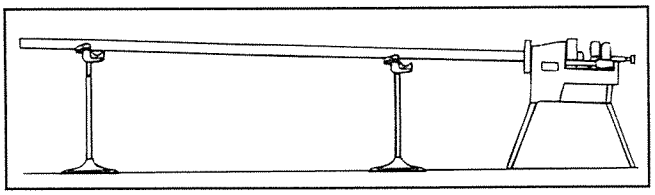
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Handling of the Unit

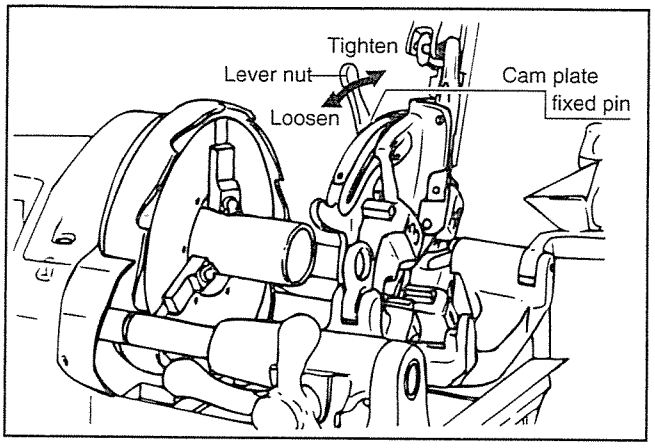
Insert the work piece into the self-centering and clamping chuck in such a way that the piece protrudes about 15 cm from the hammer chuck. After centering the pipe, it is clamped with the hand-operated chuck. Make sure that all three chuck jaw inserts are holding the pipe evenly. Then reverse the hand wheel by about half a turn and knock it towards the holding position.

Caution:

Long pipe must be stabilized by one or two pipe supports.
Make sure that the pipe is set on the supports in such a way that the material is adjusted to the height of the machine. It is recommended to use our pipe support, which is equipped with four ball casters; this enables an easy longitudinal and rotational movement of the pipes, thereby avoiding that the supports tip over.
Make sure that the chuck jaw inserts are always clean and free of metal chips. Clean the chuck jaw inserts in periodic intervals.

Thread cutting by using the Uni-auto V Die Head (N40AV, N50AV, N80AV)

Set the desired pipe dimension at the die head. To do this, the lever nut must be released. The cam plate fixed pin can then be set to the desired position.



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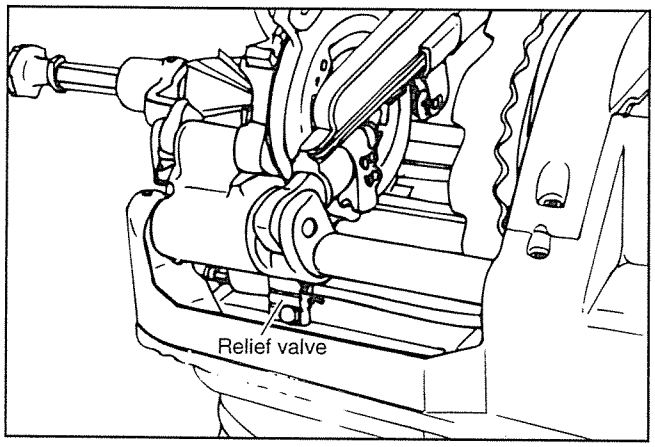
Turn on the machine with the foot switch. The thread cutting oil is now automatically flows through the die head on the pipe. The volume of oil can be regulated by using the thumb screw on the relief valve.



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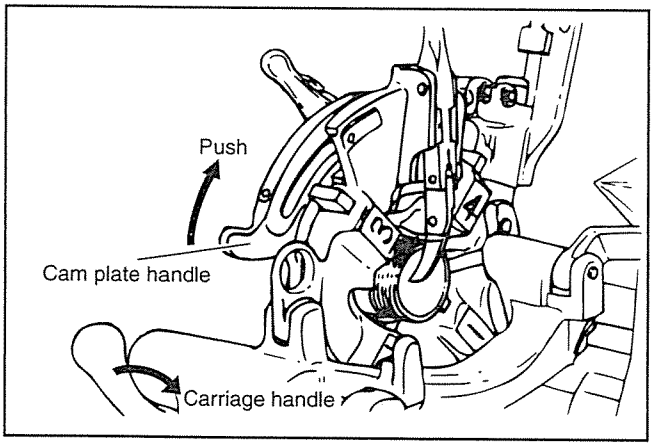
Now push the die head against the pipe by turning the carriage handle clockwise. Make sure that all three chuck jaw inserts are holding the pipe evenly and that the pipe moves parallel to the die head. After the first few threads have been cut, the die head continues cutting threads automatically. If the set thread length is reached, the die head will open and stop cutting threads automatically.



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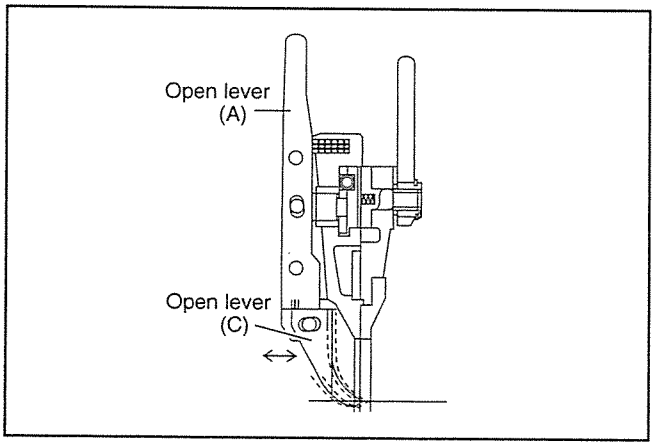
The stop lever (Open lever C) is equipped with an elongated hole, which allows a precise setting of the required thread length. If you are planning to cut long threads or bolts, this stop lever (Open lever C) must be removed. While the machine is still running, the die head can be opened by pushing the release lever (Open lever A).



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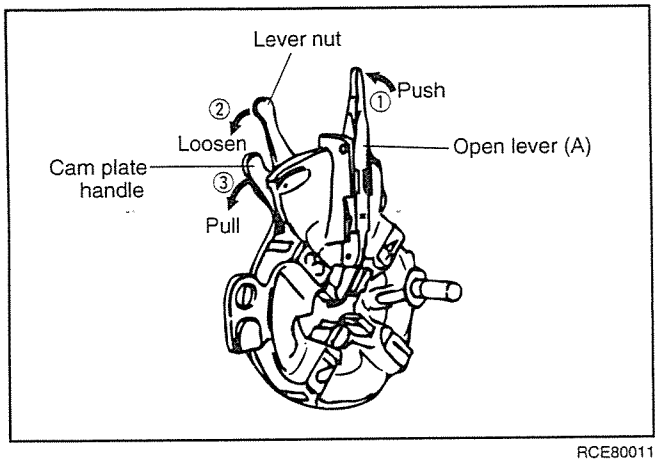
Uni-auto V Die Head



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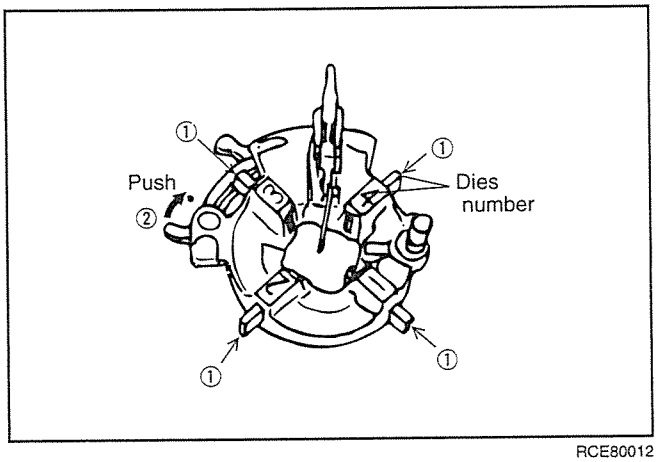
■ Changing the Dies

Pull the die head off the carriage and put it on a table.
Push the release lever (Open lever A) to open the die head.
Now loosen the lever nut by about one or two turns. The cam plate handle can now be moved beyond the maximum position.
The dies can now be pulled out of the housing.



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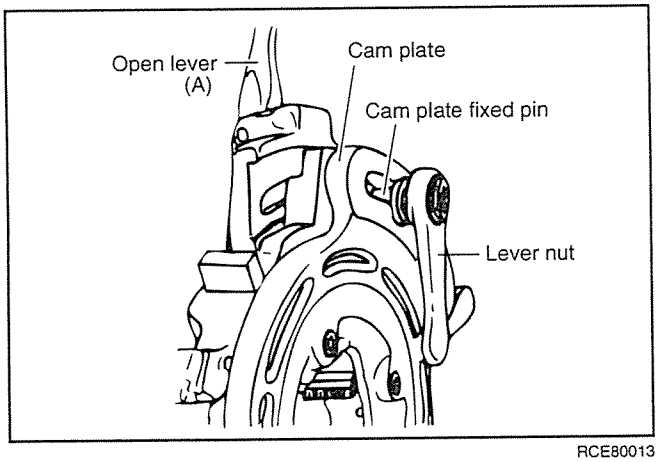
When inserting the new dies, make sure that the number on the dies corresponds to the number on the die head. Each of the dies is provided with a cross marker: slide the dies into the housing until these markings are still visible from the outside.



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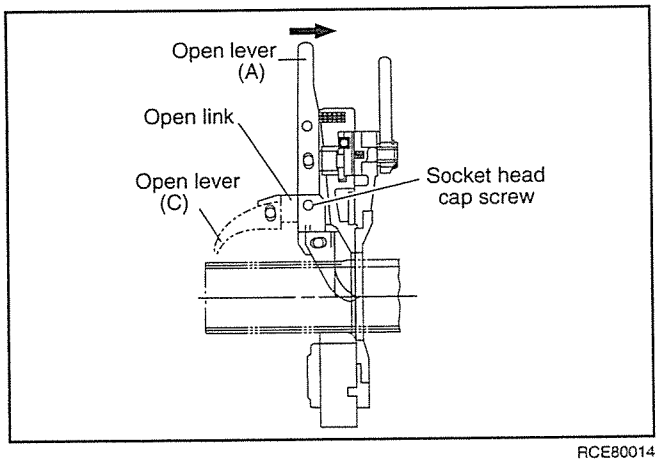
At this position, the dies will click audibly into place.
Slide the cam plate fixed pin to the desired thread size mark. Secure this setting by tightening the lever nut.
We recommend using an additional die head, in order to avoid having to replace the dies when cutting threads of 1/2–3/4″, then changing to 1–1 1/2″ (2″) or vice versa.



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■ Making Threads of Non-standard Length

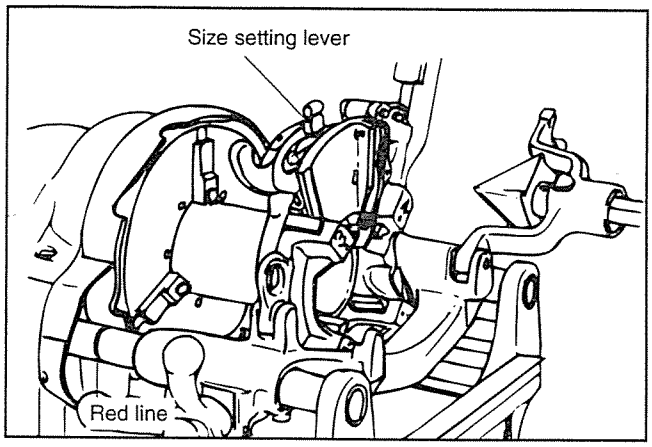
A device for manual threading is attached to enable threads of non-standard length to be made.
For manual operation, loosen the socket head cap screw on the open link.
Next, raise the open lever (C) 90°.
Then retighten the socket head cap screw.
Finally, select the desired position for threading, press the open lever (A) in the direction of the arrow and complete the threading.

Thread cutting by using the Self-opening Die Head

(N80AⅢ)

Be sure to start threading with the carriage right of (before) the red line on the front support bar.

1. Push the die head handle forward to set the open lever then set the thread size by fitting the size setting lever to the desired position.
2. Switch on the machine and thread cutting oil will automatically flow out from the die head.



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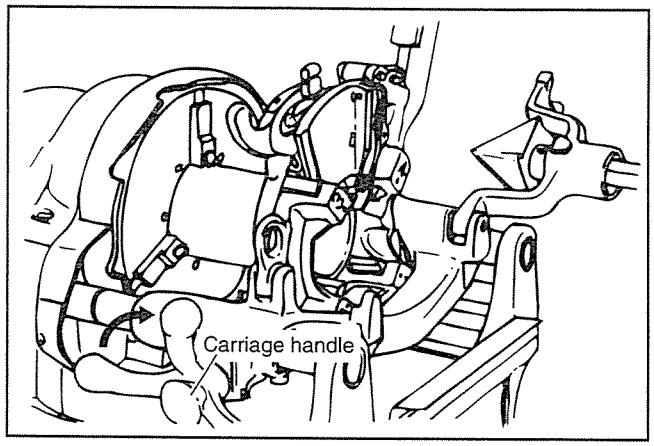
3. Turn the carriage handle to the right to advance the die head until the first two or three threads are cut. The rest is automatic.
4. The dies will automatically open when a perfect taper thread has been cut.



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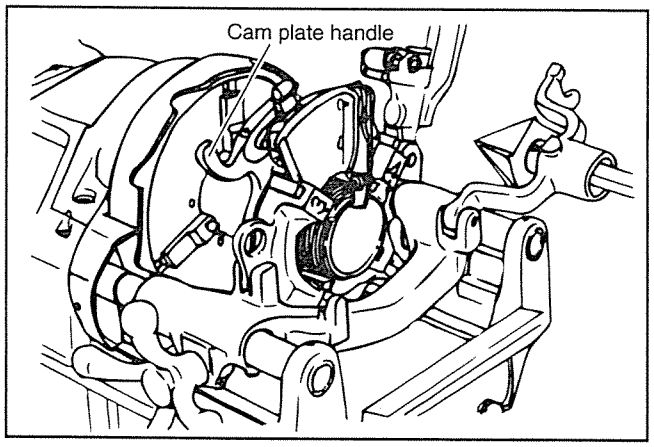
5. Turn the carriage handle to the left to clear the pipe.
6. Push the cam plate handle forward once again to set the automatic release. Reset the size if the next pipe is different diameter.



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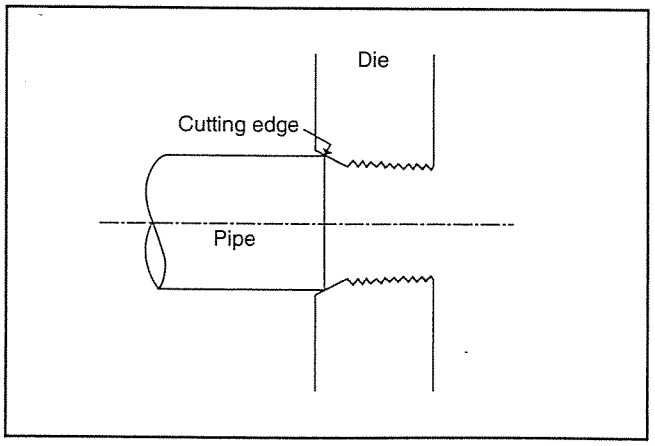
■ Precautions for Threading

1. As the dies come into contact with the pipe, the carriage handle should be turned with gradually increasing strength until the dies are biting firmly. After the dies fully engage the pipe they will travel smoothly by themselves, but optimum cutting will be assured if the carriage handle is turned with slight pressure to keep pace with die movement.
2. Be sure to start threading with the carriage right of (before) the red line on the front support bar. If threading starts left of (behind) the red line the die head can strike the chuck and damage the machine. The red line must be seen before starting thread cutting.



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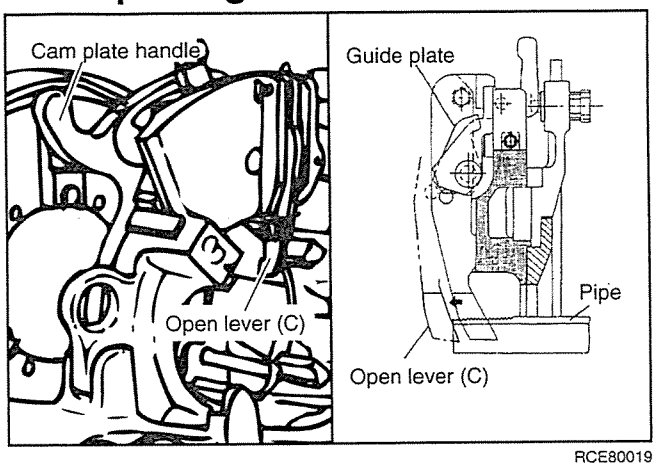
Operation Guide

Self-opening Die Head



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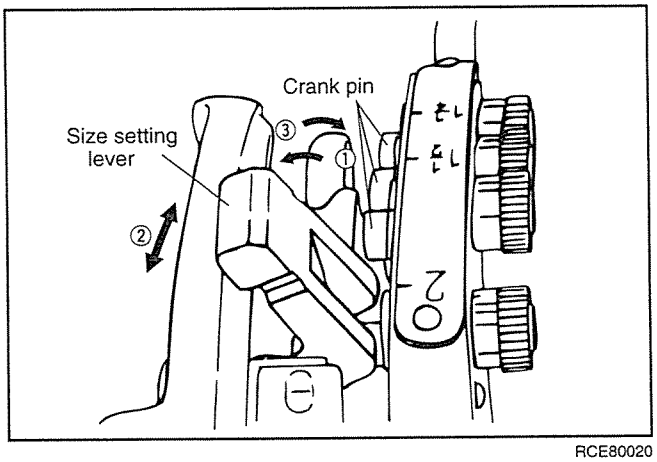
■ Self-opening Die Head

When the cam plate handle is pushed forward and set, the open lever slips into position in its groove. As the dies travel along the pipe, the end of the pipe comes into contact with and pushes the lever out of its groove to release the dies.



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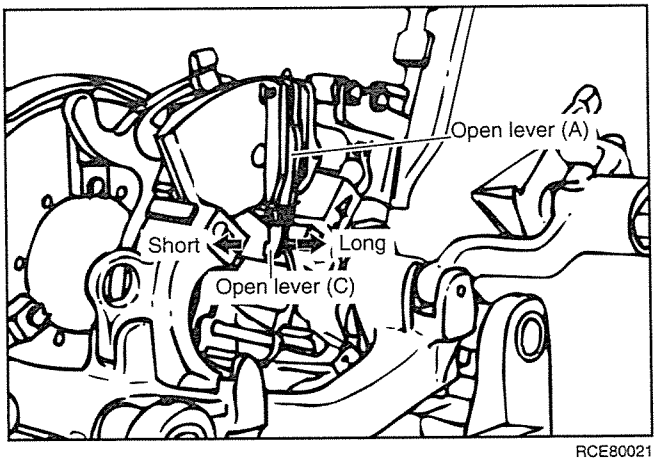
■ Change of Size

Size change is simple with the size setting lever.
Set the thread size by fittig the size setting lever to the desired position.



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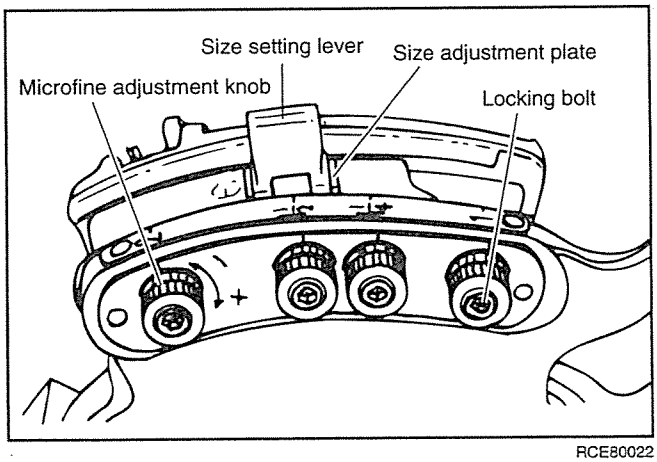
■ Adjustment Method of Thread Length

1. Loosen the socket head cap screw on the open lever (C).
2. Move the open lever (C) to the right for longer threads or to the left for shorter threads as indicated by the arrows.
3. Retighten the socket head cap screw.
   Adjustable capacity 1–3″ (1 thread)
   $^1/_2$–$^3/_4$″ (1.3 threads)



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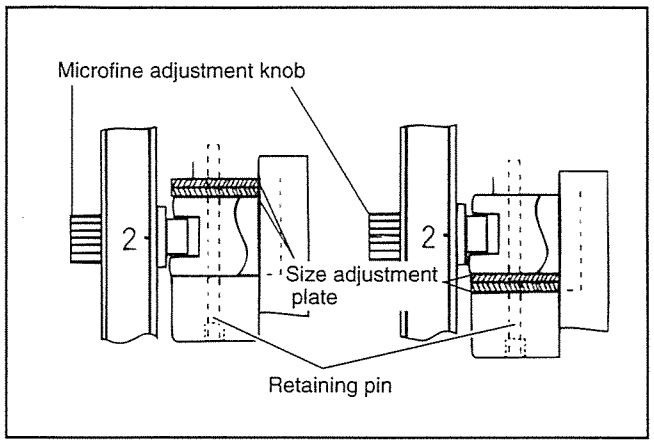
■ Microfine Adjustment of Thread Thickness

Microfine adjustment of thread thickness is possible to allow pipe to be cut exactly of your own requirements.
Simply turn the microfin adjustment knob to the left to decrease, and to the right to increase the thread thickness.
The knob is locked by a locking bolt which should be loosened with the hexagonal key provided and the knob turned three settings to the right before adjustments are made.

Adjustable capacity 1–3″ (1.5 threads)
$^1/_2$–$^3/_4$″ (2 threads)

Note:
Size should always be checked with a thread gauge after adjustment.

Self-opening Die Head



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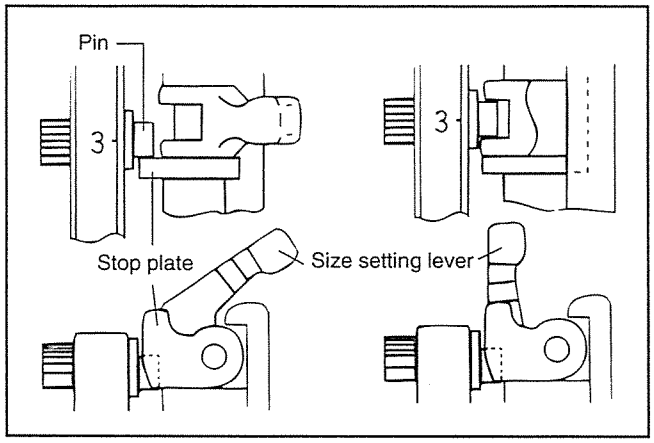

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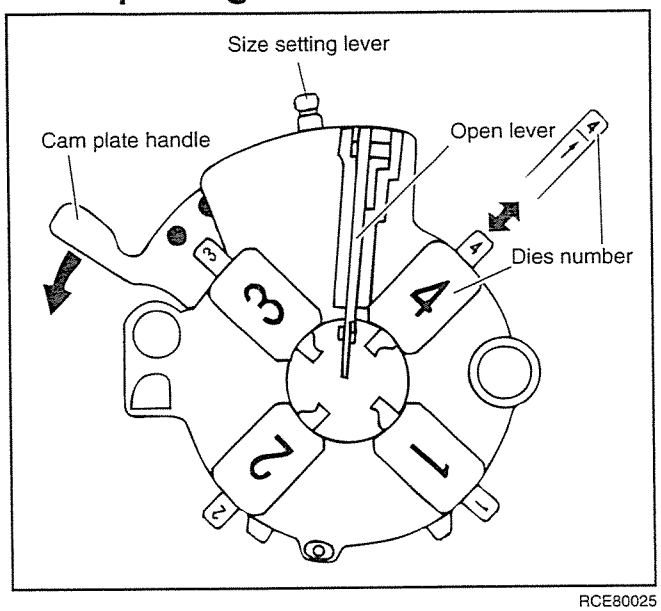
■ Size Adjustment Plate

If, even with full adjustment, thread size is not satisfactory, remove the retaining pin and reinsert the size adjustment plates.
Hold in place with the retaining pin.

■ Double Cutting with 3″ Die Head

The three inch die head is used in the same way as for other sizes but if the supplied voltage is low, double cutting may sometimes be necessary. After locking the die head in the usual way, the size setting lever should be opened and the double cutting lever lowered instead. After cutting the thread once, the die head should be reset, and the size setting lever put into position for the second cut.

Self-opening Die Head



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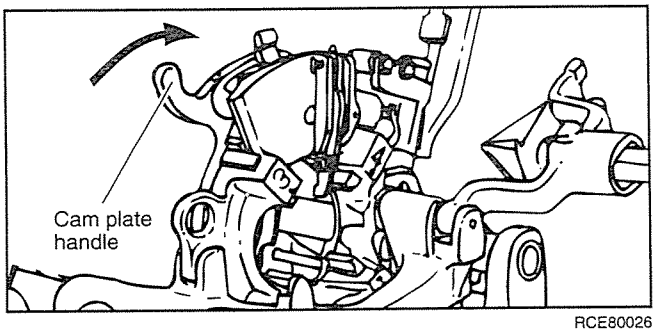


RCE80026

Changing the Dies

(**Note:** There is no need to remove the die head from the machine.)

Removal of the Dies:

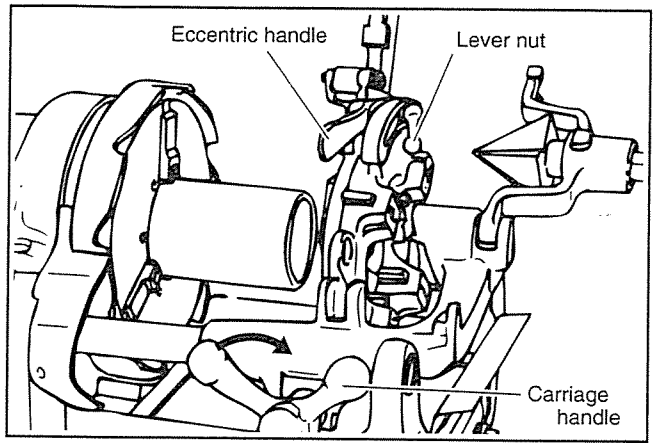
1. After opening the die head (ie with the open lever removed from the groove on the block and the dies in the open position) remove the size setting lever from the size setting pin.
2. Turn the cam plate handle in the direction of the arrow.
   No. 3 and No. 4 dies can be then be removed.
3. Raise the die head and remove No. 1 and No. 2 dies.

Replacing the Dies:

1. Raise the die head and insert the replacement No.1 and No.2 dies until the notch is engaged. Ensure that the number on the dies corresponds to the number on the die head; if dies are inserted incorrectly cutting will be impaired.
2. Lower the die head and replace No. 3 and No. 4 dies in the same way.
3. Turn the cam plate handle back in the direction of the arrow. The dies will then automatically fall into place for cutting. If the dies do not move into position properly, move them up and down a little and try again.

Caution:

Dies are made as a matched set of four, so be sure to use them as such and replace them all at the same time. Do not attempt to replace just one or two of the set as cutting will be adversely affected.

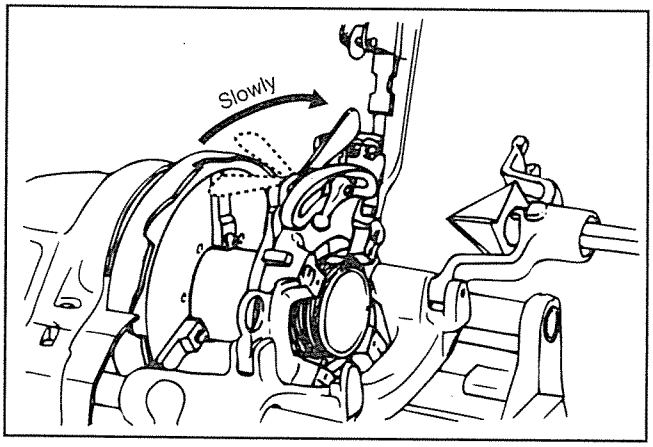


RCE80027

Thread cutting by using the Manual-open Die Head (N40A, N50A, N80A)

■ Threading Instructions

1. Install the correct set of dies in the die head and fit the die head on the carriage.
2. Loosen the lever nut and set the index line to the desired thread size.
   Refasten the lever nut to lock in position.
3. When the die head is securely engaged press the switch to start after setting the pipe.
4. Be sure the pipe is rotating forward. Turn the carriage handle clockwise to advance the die head towards the pipe. Be sure oil is flowing from the die head before starting to thread. (See oil flow adjustment knob.)



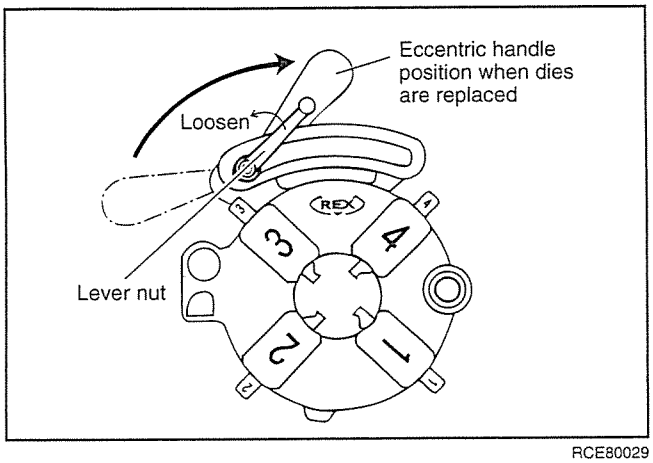
RCE80028

5. Apply clockwise pressure on the carriage handle until the dies engage the pipe to a distance of three or four threads.
   From this point the carriage handle may be released. A standard taper thread will be cut. If the dies are opened too rapidly, a stepped edge may appear on the thread, so be sure to open the eccentric handle slowly and smoothly. Then move the handle in the direction.
6. When threading is complete, switch off and move the carriage out of the way to the right. Then raise the die head to the rest position. This action will automatically stop the oil flowing.

■ Points to Watch During Threading

1. Before adjusting the size of the thread to be cut, bring the eccentric handle towards you, until it is in the position indicated.
2. It is sufficient to lightly tighten the lever nut by hand.
3. Adjustment of the thread size can be simply made with the lever nut. Move it towards you to increase, and away to decrease the thread size.

Manual-open Die Head



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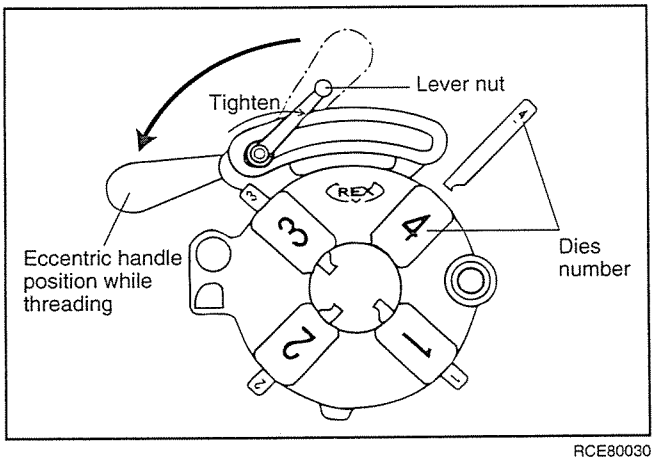
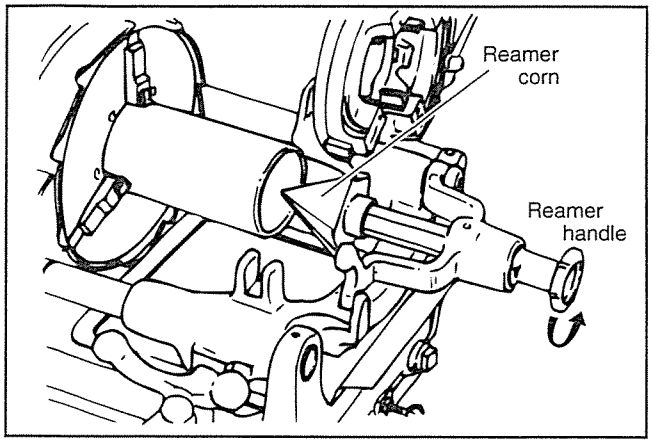


RCE80030

Changing the Dies

1. Remove the die head from the carriage with the eccentric handle in the threading position, loosen the lever nut and push the handle over to the far left. In this position, all the dies are easily removable.
2. Dies are made in a set of four pieces, be sure to replace and use them together as a set.
3. Replace the dies in order and check that the handle moves freely. If not, one or more of the dies are incorrectly positioned, and they should be reinserted one by one.
   Be sure that the numbers on the individual dies match the numbers on the slots in the die head or the pipe will not be threaded properly.
4. After replacing the dies properly, set the die head on the carriage in position. Select size of thread to be cut, then start threading.



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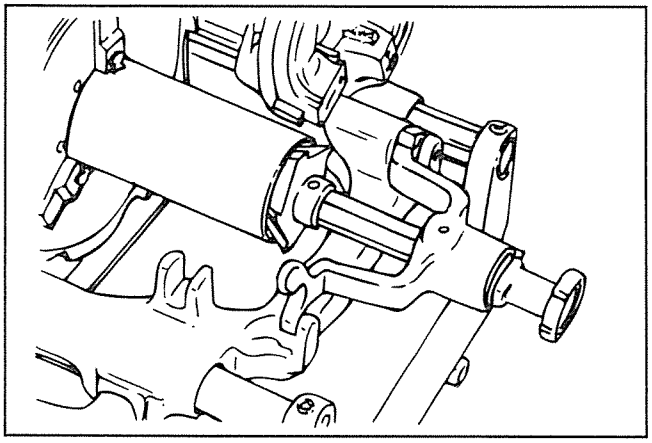
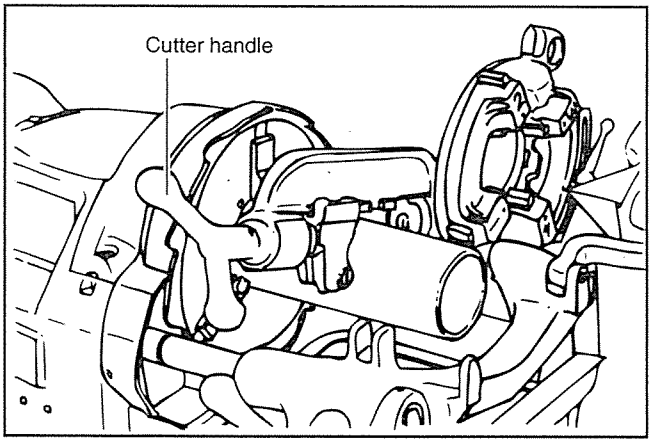


RCE80032

Reaming

Lower the reamer to its working position, then push the carriage to the left by using the carriage handle clockwise, until the pipe has been reamed cleanly. Make sure to apply an even pressure without any jerky movement.



RCE80033

Pipe Cutting

Tilt the pipe cutter to its workings position, then move the carriage to the position where the pipe should be cut.

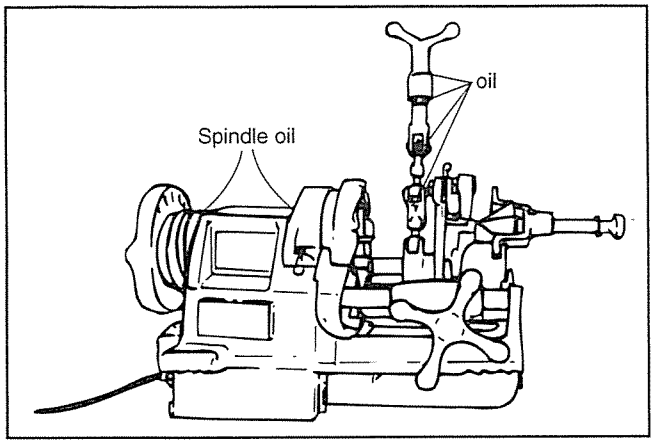
To perform cutting, turn the cutter handle counterclockwise against the pipe. Never cut into a thread, since this may damage the cutting wheel. Use common sense when cutting; do not apply too much pressure.

Warning:

If the cutter handle is turned too violently, when the cutter wheel cuts into pipe, it can distort the shape of the pipe.

Special Cut Grinder Precautions

We strongly recommend that only the pipe cutter attached to the machine be used to cut pipes that are to be threaded. If a grinder is used, make sure that the cut face is square and without steps.



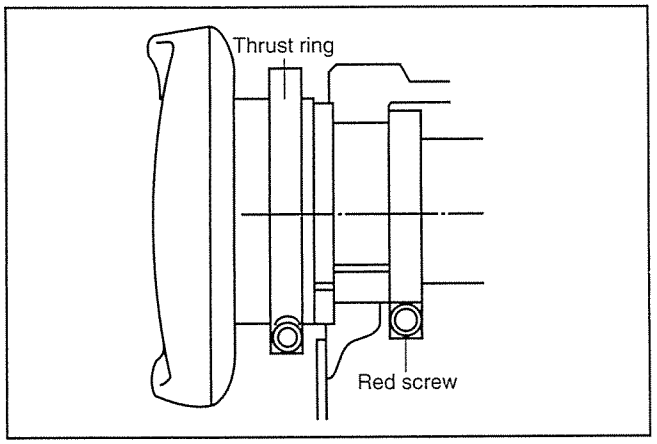
RCE80034

Maintenance and Care

a) Both spindle bearings must be oiled prior to each working session at both oiling nipples, using SAE 30 machine oil.

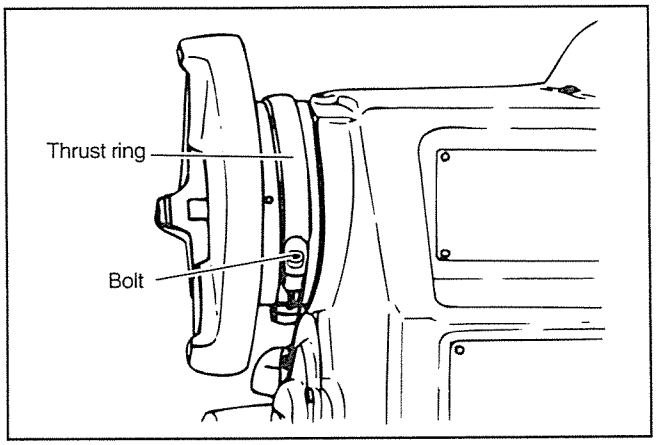
b) The carriage and carriage support bars, hammer chuck, die head and all moving parts as well as the automatic die heads or manual open die heads must be kept clean; lubricate these parts in periodic intervals with machine oil. This is especially important if mineral oil-free, synthetic cutting fluids are used.

c) To ensure perfect threads and keep a life of the dies longer, replace the thread cutting oil in periodic intervals. If the contact pressure of the die head becomes too high, the dies are dull. Have the dies resharpened as soon as possible or replace them with new dies.



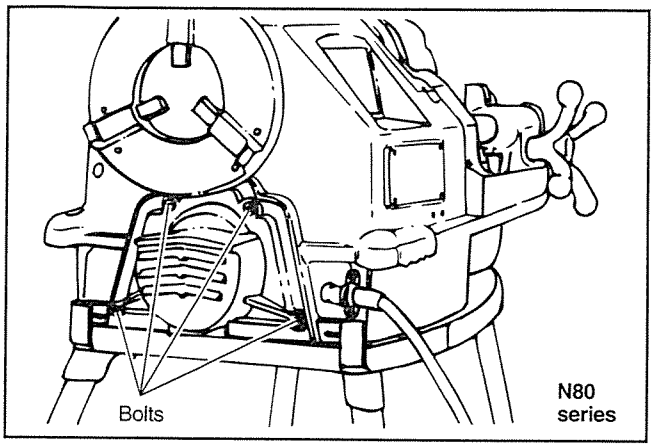
RCE80035

d) This machine is equipped with a run-on limiter (after-run), in compliance with EU safety regulations. When the run-on limiter (after-run) is activated, the main shaft — and also the pipe — will only rotate a maximum of one additional revolution after the machine has been switched off. — after an extended period of operating the machine — the run-on increases to more than one revolution, perform the following adjustment;
Remove the rear grip (N40A series and N50A series) and the rear cover, then retighten the adjustable red screw located inside of the machine housing.



RCE80036

e) **Self-adjusting Thrust Ring**
Automatically absorbs rattle due to wear in the thrust direction of the main shaft, for more stable thread cutting.



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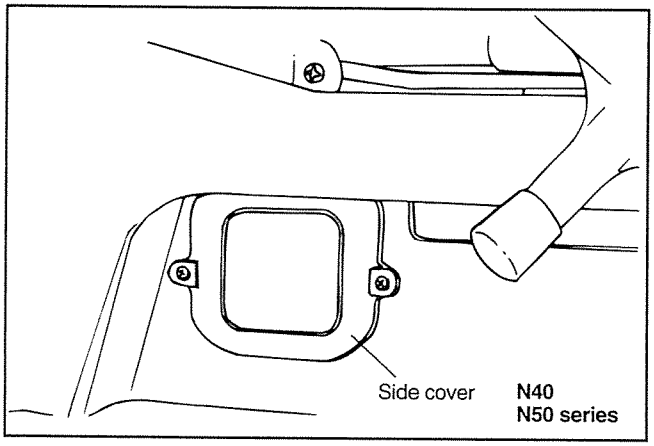

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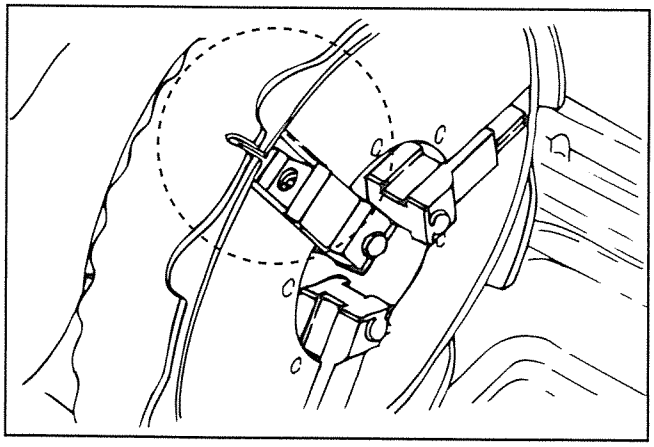

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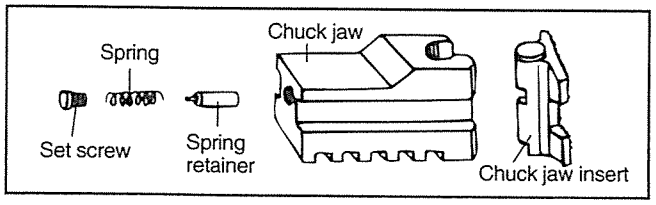


RCE80040

f) **Carbon Brushes with Automatic Stop**

These machines employs carbon brushes with an automatic stop. If the working life of the brushes (approx. 250 hours.) is exceeded, safe operation of the machine is assured as the motor will stop automatically.

■ Changing the Brushes:

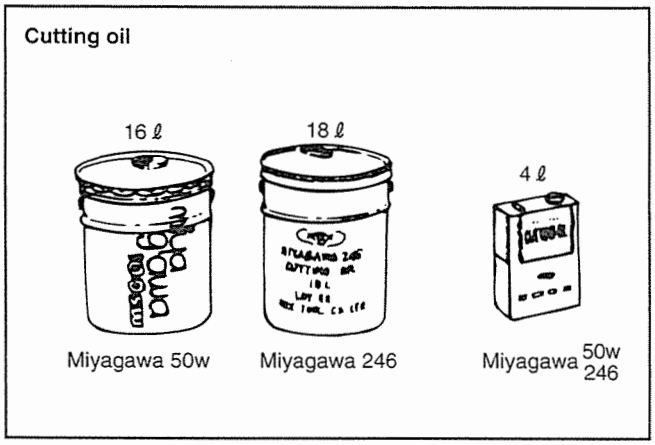
1. Ensure to unplug before changing the brushes.
2. Always change both carbon brushes at the same time.
3. Remove the side covers (N40, N50 series) or remove the four bolts of the head stock rear cover (N80 series), turn the carbon brush caps to the left using a screw driver (minus point) and remove the brushes.

g) Make sure that the chuck jaws and inserts of the hammer chuck are always clean and free of metal chips and dirt. Clean the chuck jaws and inserts from time to time with a wire brush. If it becomes difficult to hold the pipe in position, the chuck jaws inserts are worn. Always replace the chuck jaws inserts as a set. Each insert set consists of four parts: chuck jaw insert, Spring retainer, spring and set screw.

Optional Accessories

A) Thread cutting oils

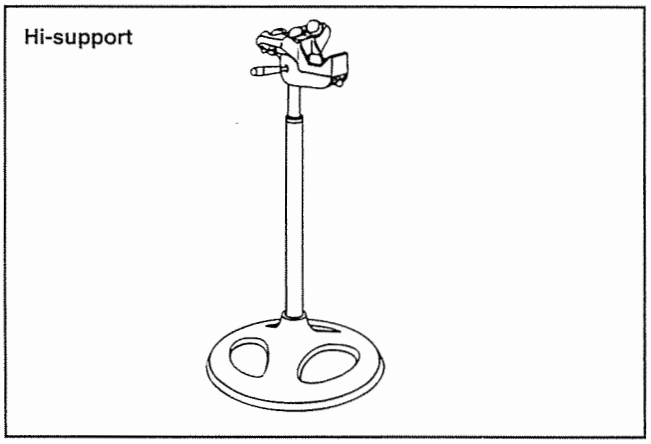
To ensure problem-free thread cutting and a long service life of the dies, we recommend using the following thread



RCE80041

B) Hi-support (pipe support for pipes up to 4″)

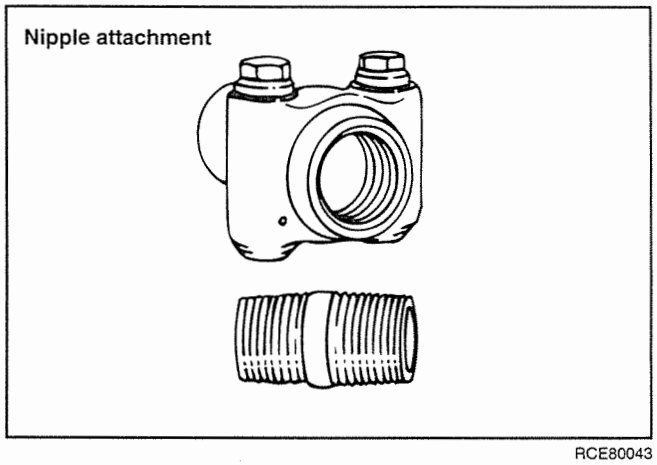
Long pipe and rod must be supported with height-adjusttable pipe support. Four ball casters ensure an easy longitudinal and rotational movement of the pipe.



RCE80042

C) Nipple attachment

This nipple attachment with internal tensioning allows clamping short pipe with or without thread. Make sure that the pipe ends are reamed on the inside, and that the pipe pieces are always inserted as far as they will go.



RCE80043

Nipple attachment size (inch)	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3
Minimum length of nipples (mm)	45	50	55	65	65	70	75	80

D) Die head: 1/4–3/8″
Bolt W5/16–7/8, W1–1 1/4,
UNC5/16–2
M8–52

Dies: 1/4–3/8″
Bolt W5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1, 1 1/4
UNC5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1, 1 1/4, 1 1/2, 2
M8, 10, 12, 14–16, 18–22, 24–27, 30–33, 36–39, 42–45, 48–52

Possible Causes of Malfunction

Symptom	Cause	Remedy
Machine dose not run	a) Poor contact at connecting plugs.	Have connection checked by qualified personnel.
	b) Brushes worn.	Replace brushes.
	c) NOT/AUS switch not released at foot switch.	Release NOT/AUS switch.
NO/ insufficient oil supply at die head	a) Insufficient cutting oil in tank.	Replenish cutting oil.
	b) Thumb screw at relief valve not opened.	Adjust oil supply quantity at thumb screw.
	c) Inlet strainer plugged.	Clean inlet strainer.
Uneven thread cutting	a) Die jaws are dull.	Resharpen or replace dies.
	b) Dies are incorrectly installed.	Insert dies according to the markings on the die head.
	c) Incorrect or contaminated cutting fluid.	Change cutting oil.
Pipe slides in the chuck	a) Clamping jaws are excessively dirty.	Clean clamping jaws with a wire brush.
	b) Clamping jaws are worn out.	Replace clamping jaws.

* In case of Uni-auto V and Self-opening die head only.

Die head dose not open in time (different thread lengths)	a) Stop lever loose.	Tighten screw.
	b) Die head is gummed up with cutting oil, or springs are weak.	Clean die head; replace springs.

⚠ Guarantee and Exemption from Liability

1. Should the machine happen to break down for no apparent reason, despite normal and correct use, repairs and service parts shall be provided free of charge as outlined below.

   Repairs shall be provided free of charge for a period of one year from date of purchase.
   Dates, procedures and methods for providing repairs and service parts shall be decided in consultation with the customer.
   After the one-year guarantee period, all repairs and service parts will be charged.
   Repairs may be charged even within the guarantee period under the following circumstances:
   - if the machine has not been used according to the instructions in the Operation Manual
   - if it has been used for anything other than its intended purpose
   - if it has not been repaired according to the Operation Manual or if it has been remodeled
   - if blades or consumables need replacing
   - if the machine has been handled in an inappropriate way.

2. REX will accept no responsibility under the following circumstances:
   - if a malfunction or accident occurs as a result of fire, abnormal fluctuations in voltage, damage from flood, earthquakes, lightning or other natural disasters, war, conflict, riot, terrorism or pollution, etc.
   - when the machine has not been operated according to the Operation Manual
   - when the machine has been used incorrectly, repaired or remodelled inappropriately
   - when a malfunction or accident results from using a thread made on the machine, or leaving it lying around and/or if it is exposed to the elements
   - when a malfunction or accident results from using a thread produced on the machine either while or after connecting it to a joint.

3. Any costs incurred by the manufacturer shall not exceed the purchase price of the machine.

REX

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