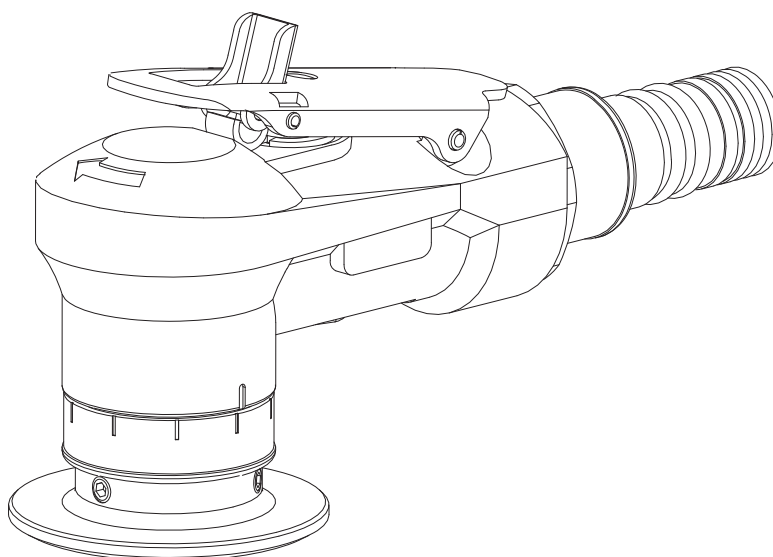


INSTRUCTION MANUAL

PNEUMATIC CHAMFERING TOOL

Please read this manual carefully before you attempt to use your tool so that you may use it properly and safely.

CIRCUIT BEVELER Model CB-01 **PROFESSIONAL TOOL**



Specifications

Model		CB-01
Maximum Operating Pressure	MPa	0.6
Air Consumption (No Load)	m ³ /min	0.15
Rated Speed (No Load)	min ⁻¹	28,000
Chanferring Capacity		mild steel 0 ~ C1
Chamfer Angle	°	45
Minimum workpiece thickness	mm	1.5 (C0.5)
Mass (Weight)	kg	0.5
Sound Pressure Level	dB(A)	88
Sound Power Level	dB(A)	99
Vibration Level [Uncertainty K]	m/s ² [m/s ²]	0.3 [0.5]
Thread Size of Air Inlet		Rc1/4

Due to continuous product development/improvement the specifications and configurations in this document are subject to change without prior notice.



Manufactured by :

NITTO KOHKI Co., Ltd.

2-9-4, Nakaikagami, Ohta-ku,
Tokyo, 146-8555, Japan

TEL : (81)-3-3755-1111

FAX : (81)-3-3753-8791

E-mail : overseas@nitto-kohki.co.jp

URL : www.nitto-kohki.co.jp

Keep the manual handy – so you can use it whenever necessary.

Original Instructions

Thank you very much for your purchase of this **Nitto Kohki products.**

Before using your tool, please read this manual carefully so that you may use it properly to get the most out of it.

Please keep the manual handy - so you can use it whenever necessary.

- **English** : Please ask your dealer or distributor for instruction manual in local language(s).
- **German** : Bitte fragen Sie Ihren Händler nach eine Betriebsanleitung in Landessprache.
- **French** : S'il vous plait, veuillez demandez à votre fournisseur de manuel instruction en langue locale.
- **Spanish** : Por favor, contacte con su distribuidor para el manual de instrucciones en español.
- **Portuguese** : Por favor pessa ao seu agente ou distribuidor o manual de instruções em linguagem local.
- **Italian** : Per Manuale Istruzioni in lingua locale Vi preghiamo di rivolgerci al rivenditore o distributore.
- **Dutch** : Vraag uw handelaar om een nederladstalige gebruiksaanwijzing.
- **Swedish** : Be er lokala Åtreförsäljare eller distributör om manualer på svenska.
- **Danish** : Venligst henvend Dem til den danske distributør for instructions manualer.
- **Polish** : Proszę pytać swojego dealera lub dystrybutora o instrukcje obsługi w języku lokalnym.
- **中文** : 請向當地供應商或經銷商詢問中文使用說明書

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PICTOGRAM



Warning: It might be dangerous to operate the tool if the instructions supplied are not followed.



Using this tool improperly could result in serious injury. Read the instruction manual before using.



Always wear suitable eye protection.



Always wear suitable hearing protection.



Always wear respiratory protective equipment (PPE).

The following Safety notations are used throughout the manual to highlight safety precautions for the user and for the tool.

WARNING:	Indicates a potentially hazardous situation which, if not avoided by following the instructions given, could result in death or serious injury.
CAUTION:	Indicates a potentially hazardous situation which, if not avoided by following the instructions given, could result in injury or material damage.

Please note, however, that failure to observe safety precautions under the “ **Caution**” category could result in a serious occurrence depending on the situation: please observe all safety precautions in the manual.

Caution: Important precautions for tool setup, operation and maintenance.

IMPORTANT SAFETY INSTRUCTIONS

When using the tool, please observe the safety precautions below to prevent possible accident or injury.

GENERAL: TOOLS

WARNING

TO OPERATORS

- **Wear proper clothing for the type of work being done.**
Take care so that clothing, ties, hair, etc. will not become entangled with the moving parts. If items become entangled, it will cause the operator to be pulled towards the tool and lead to possible cause of accident or injury.
- **Always wear suitable eye protection.**
Remember, regular glasses are not safety glasses. The lenses are only shock resistant, which will not give you sufficient eye protection you may need in your working environment.
- **Always wear suitable hearing protection.**
- **Wear respiratory protective equipment (PPE).**
Wear respiratory protective equipment (PPE) when working in an environment where dust particles are generated in operation.
- **Avoid working posture that is too stressful.**
Always ensure a firm footing and well balanced posture.
- **Do not operate the tool if you are too tired.**
- **Never touch any moving parts of the tool when running.**

ABOUT WORK AREA

- **Keep the work area clean.**
Cluttered work areas (e.g. workbench) invite accidents.
- **Carefully select the work area.**
Do not expose the tool to rain.
Do not use the tool in a wet or soaked area.
See that the work area is adequately illuminated.
- **Never work near inflammable liquid or in a potentially explosive atmosphere.**
- **Keep children away from the work area.**
Keep children and unauthorized people away from the work area to avoid accident or injury.
- **Some tools generate high noise levels.**
Check to be sure that the use of this tool conforms to all local noise regulations.

BEFORE OPERATION

- **Inspect tool before use.**
Before using, check that screws are securely tightened, that any protective cover or guard is securely in place, other parts are free from damage and that the tool runs as it should.
Check that moving parts are properly adjusted for positioning and tightened, that parts are free from damage and properly mounted, and that all other parts are in good condition for normal operation.
Should you find any damage to the protective cover or other part, replace it in accordance with the Operation Manual. If there are no instructions in the Manual, please contact the sales agent through which you have purchased your tool or an authorized dealer near you for repair.
Likewise, if a switch failure occurs, contact sales agent through which you have purchased your tool or an authorized dealer near you for repair. .
Do not use the tool if it does not start or stop with the start/stop switch.
 - **Securely mount cutter**
An improperly mounted cutter may fly out, causing possible damage to the tool or injury to the operator.
 - **Always remove spanner, wrench, etc., once adjustment has been made with them.**
 - **Use a tool appropriate for the application.**
Avoid heavy-duty application that is beyond the capacity of the tool.
 - **Do not use the tool for purposes other than what it is designed for.**
 - **Do not abuse tool.**
Use tool in accordance with the specifications: you'll get the most out of it while ensuring safety.
 - **Securely fasten workpiece in place.**
Use a vice or clamp to securely fasten the workpiece in place. It is much safer this way than holding it in your hand, allowing you to operate the tool with both hands.
- #### ABOUT HANDLING
- **How to store tool.**
When the tool is not used, store it in a dry area and out of reach of children.
 - **How to carry tool.**
Do not touch the start switch while the tool is being carried.
 - **Do not leave the tool unattended while it is running.**
Turn off the start switch and disconnect the tool from power source. Do not leave the work area until the tool comes to a complete stop.

MAINTENANCE/SERVICE

- **Do not take apart or modify tool.**

Disassembly or modification carried out without the supervision of a qualified or authorized service engineer could result in an accident or injury.

- **Inspect cutting tool and accessories, etc.**

Always check to see that cutting tool and accessories, etc. are in good operating condition without damage or deterioration before you mount them on the tool. Should you find any damage to an accessory or part, please contact sales agent through which you have purchased your tool or an authorized dealer near you for repair.

- **Check parts for damage.**

When you have found damage to accessory or other part, carefully check the damaged part to determine the extent of influence it has upon the functions of the tool – that is, determine whether it can still perform its normal functions.

Check to see that the linkage of the moving parts is OK, that all parts are OK without damage, that they are properly mounted, and that the tool functions normally. Should you find any damage to an accessory or part that may hamper proper functioning of the tool, please contact sales agent through which you have purchased your tool or an authorized dealer near you for repair.

- **Have your tool repaired at an authorized Nitto Service Center.**

For repair or parts replacement, please contact the sales agent through which you have purchased your tool or an authorized dealer near you.

- **Use only Nitto genuine parts.**

Use of improper parts may result in serious occurrence.

To obtain a Nitto genuine part, consult this Manual or contact the sales agent from which you have purchased your tool directly.

- **Do not detach label or nameplate from tool.**

When a label/nameplate gets damaged, worn or becomes missing, contact the sales agent through which you have purchased your tool or Nitto Kohki Co. Ltd, directly for a replacement.

DISPOSAL

- When a tool is taken permanently out of service, it is advised that the tool is disassembled, degreased and parts separated by material and recycled locally in the appropriate manner.

GENERAL: PNEUMATIC TOOLS

WARNING

- **Use appropriate air pressure.**

Excessively high air pressure will increase the number of revolutions or strokes causing not only potential premature failure/breakage but could also lead to an unexpected accident or injury.

- **Connect tool to air supply line.**

There are various types of pipes running in a factory in addition to the pneumatic line (such as oxygen, nitrogen, gas and water). For this reason, always ensure that you are connecting to the pneumatic line.

- **Start tool properly.**

Turn the start switch OFF before connecting to the air supply line.

- **Always disconnect the tool from the air supply line before putting on/taking off any accessory and prior to carrying out any maintenance work.**

- **Avoid exposure to exhaust air.**

Pneumatic tool exhaust air contains oil and contaminated moisture. Make sure the exhaust air is not directed towards your face or anyone else within the work area.

- **Keep tool off electricity.**

This pneumatic tool is not electrically insulated. To avoid a potential electric shock do not use where there is a possibility of coming into contact with live electricity.

CAUTION

- **Handle tool carefully.**

Abusive use of tool could invite failure or accident.

Do not throw, drop or shock the tool.

- **Handle connecting hose carefully.**

Do not carry the tool by the air hose.

Do not pull the air hose to disconnect.

INSTRUCTIONS FOR THIS TOOL

About Your Tool

WARNING

- **Protect your body from the chips/filings.**

Hot chips/filings may fly out from the work piece. Always wear safety glasses, dust mask, earplugs, gloves (except knitted gloves) and long-sleeved garment.

Keep your face well away from the work piece.

- **Use our original Indexable Inserts.**

- **Do not use the worn or damaged Indexable Insert.**

2 CHECK THE CONTENTS OF THE PACKAGE

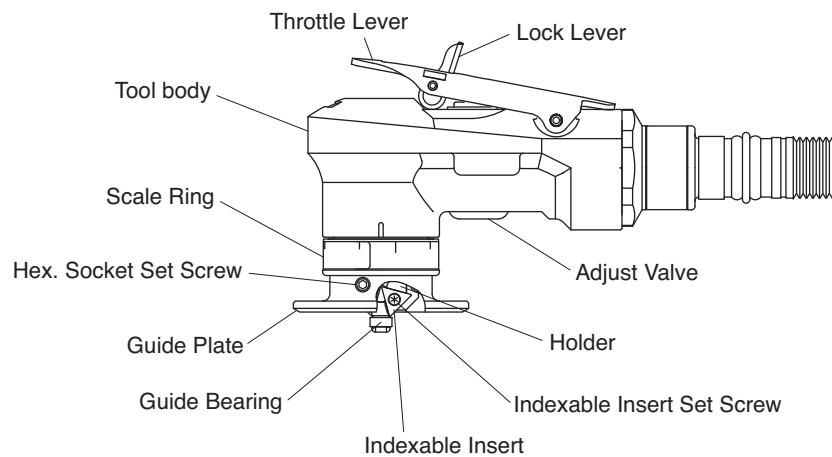
Check the contents and make sure that the tool does not have any damage which may have occurred during transportation. The contents should correspond to the list as follows. In case of damage/missing parts, please contact the sales agent from whom you purchased the tool.

Package Contents	Qty	check
CIRCUIT BEVELER CB-01	1	
SPANNER T-6F	1	
HEX. SOCKET SCREW KEY 2	1	
INDEXABLE INSERT SET SCREW	2	
BUSHING PT1/4×NPT1/4	1	
INSTRUCTION MANUAL	1	
DECLARATION MANUAL	1	

1 USAGE

This tool is designed for chamfering workpiece with Indexable Inserts.

3 NAME OF PARTS



4 AIR SUPPLY

CAUTION

- Draw off drainage before starting operation. If the drainage enters into the tool, it can freeze around the exhaust port of the tool and result in output power reduction.

4-1. Air Pressure

Adjust air pressure to 0.6MPa (or 6 kgf/cm²) with the air regulator. Lower pressure may result in insufficient performance. Higher pressure may result in premature wornout of parts. It is important to maintain the proper pressure with pressure regulator on air line.

4-2. Air Line (Fig.2)

Use a 9.5 mm (3/8") I.D. air hose between the compressor and the tool. Compressed air comes to be cooled down and its drain be separated, as soon as the air leaves the compressor. The drain, however, is condensed in the piping, and can enter into the tool mechanism, and may cause malfunction.

So, install an air filter and an oiler between the compressor and the tool.

4-3. oiler

Install an oiler between the compressor and the tool. Use machine oil ISO VG-10 for lubrication and rust prevention. Negligence of the oil supply may cause damages on the tool. Lubricating the tool with high viscosity oil reduces the tool performance.

4-4. Lubrication (Fig.2)

Before starting the tool, disconnect air hose from the tool and supply a few drops of machine oil ISO VG-10 to the air inlet port of the tool. Then reconnect and make idle running for a few seconds so that the oil should reach every part in the tool.

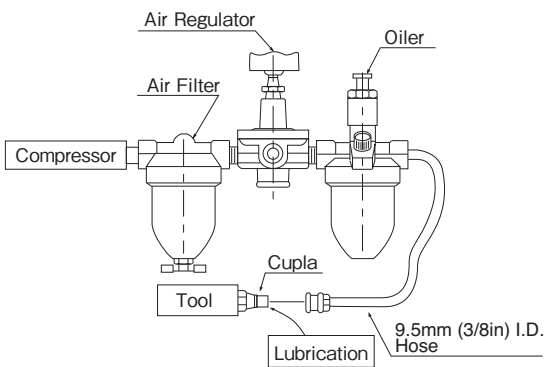


Fig.2

5 HOW TO OPERATE THE TOOL

! WARNING

- Always wear safety glasses during operating the tool. Wear respiratory protection when working in an environment where dust particles are generated during operation.
- Make sure the Throttle Lever is in the OFF position before connecting the air supply hose to the tool.
- Always disconnect the air supply hose from the tool before putting on/taking off indexable inserts or replacing parts.
- Never touch any moving parts of the tool when running.

5-1. Dimensions of material to be chamfered

Minimum chamfering dimensions are hole diameter 6.8mm, radius 3mm, and plate thickness 1.5mm. Also chamfering of groove, minimum depth required is 6mm. (Fig.3)

When chamfering a thin plate, adjust the chamfering amount so that the unchamfered thickness is 1 mm or more. If the unchamfered thickness is less than 1 mm, the plate may become caught in the gap between the Guide Plate and the Guide Bearing. (Fig.4)

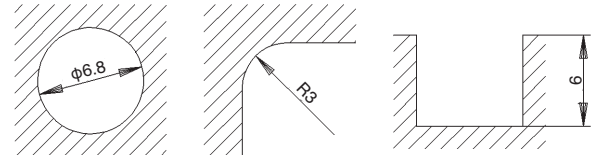


Fig.3

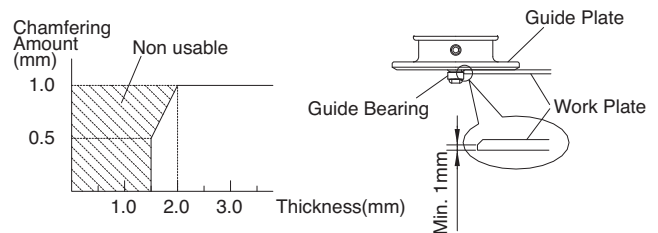


Fig.4

5-2. Start and Stop (Fig.5)

- (1) Check that the Throttle Lever is turned off and connecting the tool to the hose leading to air supply line.
- (2) Hold the tool, ① release the Lock Lever, and ② grasp the Throttle Lever to start.
- (3) When the Throttle Lever is released, it will automatically turn off.

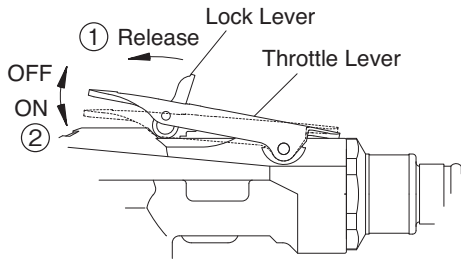


Fig.5

5-3. How to Adjust Chamfering Amount

⚠ WARNING

- Disconnect the air supply hose from the tool before adjusting the chamfering amount.

CAUTION

- If chamfering must be done exactly, chamfer the test piece and check the amount and condition of chamfering before actual chamfering on the workpiece.
- Maximum chamfering amount is C1.
- Alternately and gradually tighten two Hex. Socket Set Screws on the Guide Plate. If the one screw is tightened too much, the Guide Plate can be loosened.

- (1) Loosen two Hex. Socket Set Screws on the Guide Plate with the accessory Hex. Socket Screw Key 2.
- (2) Rotate the Guide Plate to align the Reference Line with a decimal for a desired chamfering amount. (Fig.6)

Chamfering amount increases or decreases by 1 mm with one turn of the Guide Plate.

- (3) Tighten two Hex. Socket Set Screws after adjusting the chamfering amount.
- (4) Chamfer the test piece and check the amount of chamfering. Repeat the above processes from 1 to 3 for fine adjustment of the desired chamfering amount.

CAUTION: Never loosen the Hex. Socket Set Screw on the Scale Ring.

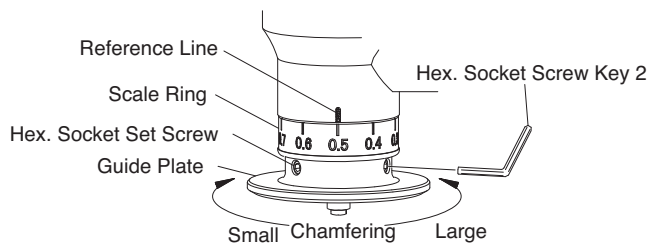


Fig.6

5-4. Feeding speed

CAUTION

- Be sure you should avoid quick feeding or heavy shock. Otherwise, this will cause damage to the Indexable Inserts or the tool failure.

Refer to Table 1 for appropriate feeding speed.

If the worked surface is burned, the feeding speed is inappropriate.

If the swarf is burned even at suitable feeding speed, replace the indexable insert.

Table 1

C0.5	10cm/sec
C1	5cm/sec

5-5. How to Replace Indexable Inserts

⚠ WARNING

- Always disconnect the air supply hose from the tool before replacing indexable inserts.
- Allow the indexable insert adequate time to cool off after use as indexable inserts can reach extreme temperatures.

CAUTION

- Replace all the two Indexable Inserts at the same time. When only one Indexable Insert is replaced, smooth chamfering surface cannot be obtained and the life of the replaced Indexable Insert can be shorter.
- Remove the swarf on the surface of the Holder before installing a new indexable insert.

- (1) Timing for replacement. (Three sides of each tip can be used.)

A dull Indexable Insert may be dangerous as it may chip off or damage the tool mechanism by vibration.

Therefore, it must be replaced with a new genuine Indexable Insert, when the following cases happen.

- a. Indexable Insert damaged.
- b. Sparks when chamfering.
- c. Chamfering surface became rough.
- d. Cutting ability is decreased.

- (2) Indexable Insert replacement method

- a. Loosen two Hex. Socket Set Screws on the Guide Plate with the accessory Hex. Socket Screw Key 2. (Fig.7)
- b. Unscrew the Guide Plate and loosen the Indexable Insert Set Screw with the accessory Spanner T-6F (Fig.8)
- c. Install the new Indexable Insert (or the indexable insert rotated to a fresh edge) making sure it is in the correct direction and tighten them with the Indexable Insert Set Screw.

- d. Also replace the other Indexable Insert in order of the above b and c.
- e. Install the Guide Plate, adjust the indexable insert for the desired chamfering amount, and tighten the two Hex. Socket Set Screws.

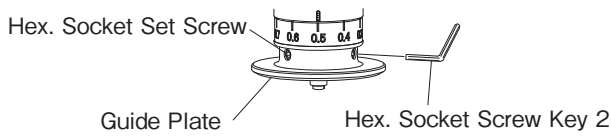


Fig.7

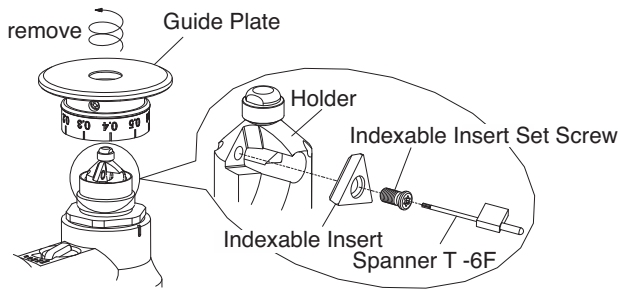


Fig.8

5-6. Adjusting the Rotation Speed

WARNING

- **Never touch any moving parts of the tool when running.**

When the adjust valve is turned, the amount of airflow is changed to adjust the rotation speed.

When the adjust valve is turned to the furthest counterclockwise position, the tool reaches the maximum rotation speed. (Fig.9) Adjust the rotation speed according to the chamfering work.

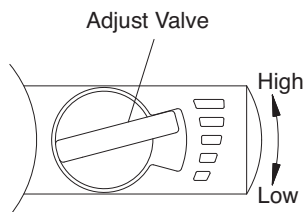


Fig.9

5-7. How to use

CAUTION

- **Always turn the Holder by depressing the Throttle Lever prior to contacting the workpiece then slowly engage the material. Never turn the Holder with pressing the tool against the workpiece, nor introduce the indexable inserts to the workpiece as abrupt or sharp actions. This can cause damage to the indexable insert or tool.**

- **If the initial cut is such an edge as in Fig.10, before chamfering, grind the edge off. Initially cutting an edge will give a heavy shock to the Indexable Inserts, malfunction of the tool, or injury to the operator.**

When chamfering, fix the workpiece firmly.

Especially, small parts must be held securely with a device such as a vice.

- (1) Hold the tool firmly, release the lock lever, and depress the throttle lever to start the tool.
- (2) Place the Guide Plate on the workpiece, and slowly pull the tool towards you or push it forward to introduce the indexable inserts to the material.
- (3) While holding the Guide Bearing against the workpiece, move the tool in a clockwise motion. (Fig.11)

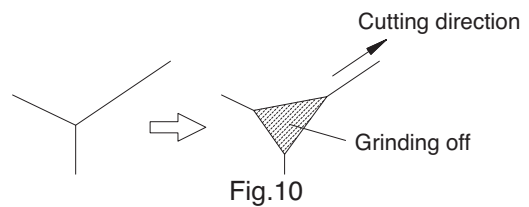


Fig.10

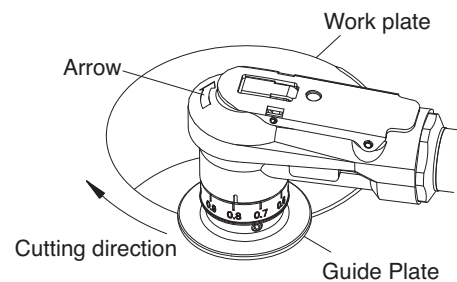


Fig.11

5-8. How to Handle or Replace the Guide Bearing

CAUTION

- **If the Guide Bearing is hit or pressed excessively to the workpiece, it can be damaged. Dust or the swarf can enter into the Guide Bearing. Blow it off frequently, otherwise it can reduce the life of the Guide Bearing.**

If the Guide Bearing becomes hard to turn, replace it with a new one in the following order. (Fig.12)

- (1) Refer to "5-5 How to Replace the Indexable Insert" in the instruction booklet and remove the Guide Plate and the Indexable Inserts.
- (2) Insert the accessory Hex. Socket Screw Key 2 or a 2 mm dia. needle into the hole in the Holder.
- (3) Loosen the Bearing Set Screw by turning the 4 mm spanner counterclockwise.
- (4) Place a new Guide Bearing on the Bearing Set Screw and tighten it by turning the 4 mm spanner clockwise.

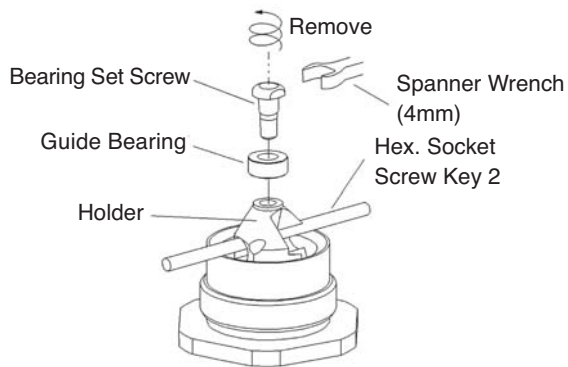


Fig.12

6 STORAGE AND MAINTENANCE

6-1. Storage

WARNING

- When tool is not used, store it out of reach of children.

Avoid storing the tool in a location subject to high humidity. If the tool is left as it is used, residual moisture on the inside can cause rusting. Before storing, and after operation, oil the tool at the air inlet with machine oil ISO VG-10 and run it for a short time.

6-2. Maintenance

With prolonged use, the Indexable Insert supporting section of the Holder will sag. The sag will cause damage to the Indexable Insert. Therefore, the sagged Holder should be replaced. (Fig.13)

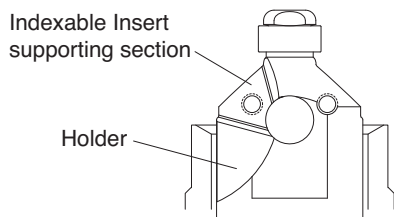


Fig.13

6-3. Maintenance of Guide Plate

If the swarf enters into the thread part of the main body or the Guide Plate, it may cause the Guide Plate not to turn and thus it may not be securely tightened. Blow the swarf off from the Guide Plate in the following cases. (Fig.14)

- After finishing operation
- When replacing the Indexable Insert
- When adjusting the chamfering amount

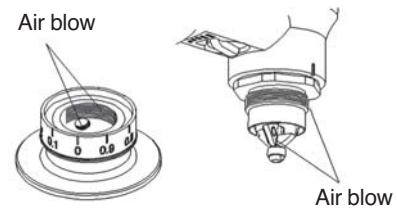


Fig.14

7 ORDERING SERVICE PARTS

- For further operational and handling information or for replacement of parts and components, contact the company from whom you purchased the tool or an authorized dealer.
- In ordering parts and components give each part number, part name and quantity required.
- Use only NITTO genuine parts.

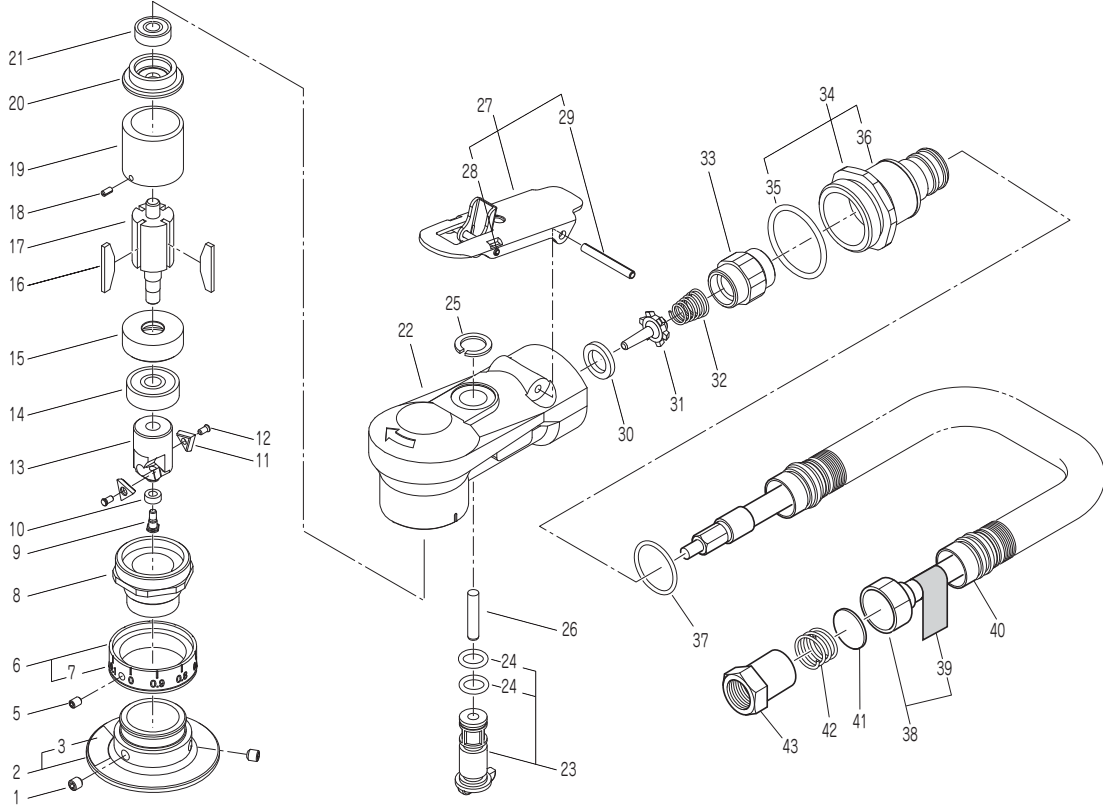
8 OPTIONAL PARTS

Part No.	Description	Qty
TB09097	Indexable Insert 8.4 Ass'y	10pcs
TB09320	Guide Plate 78 Ass'y	1 set
TB09323	Plate Ass'y for Straight edge use	1 set

10 EXPLODED DIAGRAM : CB-01

⚠ WARNING

This diagram is for your reference only. Do not attempt to service or repair the Tool. Do not take the Tool apart. Contact an authorized Nitto dealer for all service and repair of the Tool. Improper service and repair can cause accidents and service injuries. Never attempt to modify the Tool. Never attempt service or repair the Tool yourself.



The parts numbers with () are included in the Ass'y parts written above them.

No.	Parts No.	Parts Name	Qty
1	TP15643	Hex. Socket Set Screw 4X4	2
2	TB09245	Guide Plate	1set
3	(TQ13684)	Label Caution	1
5	TQ11146	Hex. Socket Set Screw 3X4	1
6	TB09086	Scale Ring Ass'y	1set
7	(TQ13371)	Label Scale	1
8	TQ13347	Lock Screw	1
9	TQ13354	Bearing Set Screw	1
10	TQ13355	Ball Bearing 630ZZ	1
11	TQ13368	Indexable Insert	2
12	TQ13369	Indexable Insert Set Screw	2
13	TQ13350	Holder	1
14	TP15408	Ball Bearing 626ZZ	1
15	TQ13345	End Plate B	1
16	TB09122	Blade Ass'y (4pcs)	1set
17	TQ13342	Rotor	1
18	TP04225	Spring Pin 2X 4	1
19	TQ13346	Cylinder	1
20	TQ13344	End Plate A	1
21	TQ07225	Ball Bearing 695ZZ	1
22	TQ13381	Housing	1
23	TB09123	Adjust Valve Ass'y	1set
24	(TP12003)	O-ring KS-5	2
25	(TQ13374)	Retaining Ring ISTW-10	1
26	TQ13454	Parallel Pin B4X20	1

No.	Parts No.	Parts Name	Qty
27	TB09088	Lever Ass'y	1set
28	(TQ13429)	SpringPin 2.5X25	1
29	(TQ13428)	SpringPin 3X25	1
30	TQ04671	Seal Sheet 9X13.9X2	1
31	TQ04664	Valve	1
32	TQ04665	Conical Spring 0.8X6.4X11.6X21.8	1
33	TQ13352	Connection	1
34	TB09246	Hose Holder Ass'y	1set
35	(TP08812)	O-ring S-25	1
36	(TQ13683)	Label Model	1
37	CP28152	O-ring JASO-1012	1
38	TB08130	Air Hose J Ass'y	1set
39	(TQ11519)	Label Lubrication	1
40	TQ04367	Exhaust Hose	1
41	TQ13625	Filter	1
42	TQ13621	Filter Spring	1
43	TQ04709	Bushing R1/4XRc1/4	1

Accessories

No.	Parts No.	Parts Name	Qty
	TQ13369	Indexable Insert Set Screw	2
	TQ13376	SPANNER T-6F	1
	TP13892	Hex. Socket Screw Key 2	1
	TP02236	Bushing PT1/4 XNPT1/4	1
	TQ13632	Instruction Manual	1



Overseas Affiliates / Offices

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NITTO KOHKI CO., LTD.,

SHENZHEN REPRESENTATIVE OFFICE

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EC DECLARATION OF CONFORMITY

We hereby declare that the following our product conforms with the essential health and safety requirements of EU Directives.

Product: PNEUMATIC CHAMFERING TOOL
Model: CIRCUIT BEVELER : CB-01
Serial No: In the case of 6 digits serial number.
XXXXXXXX
Consecutive numbers (00001~99999)
Last digit (0-9) of year (A.D.)
In the case of 7 digits serial number.
XXXXXXXXX
Consecutive numbers (00001~99999)
Last two digits (00-99) of year (A.D.)

Manufacturer: NITTO KOHKI Co., Ltd.
2-9-4, Nakaikegami, Ohta-ku, Tokyo, 146-8555, Japan

Authorised person to prepare the technical construction file(TCF) in the community:
Masatoshi Ogue
President
NITTO KOHKI EUROPE Co., Ltd.
Unit21, Empire Centre, Imperial Way, Watford Hertfordshire,
WD24 4TS, UK
Tel:(44)-01923-239668 Fax:(44)-01923-248815

Directive: 2006/42/EC Machinery Directive
The above product has been evaluated for conformity with above directives using the following European standards. The technical construction file (TCF) for this product is retained at the above manufacturer's location.

Machinery Directive: EN ISO12100:2010, EN ISO11148-7:2012, others
Sound Pressure/Power Level: EN ISO15744:2008, EN ISO4871:1996
Vibration Level: EN ISO20643:2008

Signature: K. Kishi

Date/Place: Nov. 7, 2012 /Tokyo, Japan

Name: K. Kishi

Title: GENERAL MANAGER MACHINE TOOLS DIV.

NITTO KOHKI Co., Ltd.
2-9-4, Nakaikegami, Ohta-ku, Tokyo, 146-8555, Japan

Being the responsible person appointed and employed the manufacturer.