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Metabo KFM 15-10 F

Instruction Manual

METABO 3/8-INCH METAL BEVELING TOOL, KFM 15-10 F

Model: KFM 15-10 F | Brand: Metabo

1. Introduction and Overview

This manual provides essential information for the safe and effective operation, maintenance, and troubleshooting of your Metabo 3/8-Inch Metal Beveling Tool, model KFM 15-10 F. This corded beveling tool is designed for precise weld preparation, edge preparation, beveling, chamfering, and radius applications on metal.

Key features of the Metabo KFM 15-10 F include:

- Metal Beveling tool for chamfer heights up to 10 mm for weld seam preparation.
- One-touch controller: Patented, tool-free setting of the cutting depth in 0.1" steps; stop points for short setting times, and protection against unintentional adjustment of the cutting depth when working.
- Precise setting of chamfer angle directly using the guide plate.
- Universal carbide burr with three carbide inserts for all chamfer angles from 0-90°.
- Controlled work with large-surface guide plates.
- Stop roller to guide along pipes for easy weld seam preparation.
- Bail handle adjusts without tools for secure, even guiding.
- Metabo Long-life motor with patented dust protection for long service life.
- Tacho-Constamatic (TC)-Full Wave Electronics: fast work progress by means of constant speed under load.
- Electronic overload protection, soft start and restart protection.



Figure 1: Overall view of the Metabo KFM 15-10 F Metal Beveling Tool, showcasing its compact design and ergonomic handle.

2. Safety Instructions

WARNING: Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

General Power Tool Safety

- Always wear appropriate personal protective equipment (PPE), including safety glasses, hearing protection, and gloves.
- Keep the work area clean and well-lit. Cluttered or dark areas invite accidents.
- Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.
- Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.
- Ensure the power cord is in good condition and positioned to avoid tripping hazards or contact with the cutting area.

Specific Beveling Tool Safety

- Secure the workpiece firmly before beginning any beveling operation. Unsecured workpieces can move unexpectedly.
- Ensure the carbide inserts are correctly installed and tightened before use. Loose inserts can be ejected at high speed.
- Do not force the tool. Allow the tool to work at its own pace for optimal results and to prevent overload.
- Be aware of flying chips and sparks. Direct them away from yourself and others.
- Disconnect the tool from the power supply before making any adjustments, changing accessories, or performing maintenance.

3. Setup

3.1 Unpacking and Initial Inspection

Carefully remove the tool and all accessories from the packaging. Inspect for any signs of damage. Ensure all components listed in the "Included Components" section of the specifications are present.

3.2 Attaching the Bail Handle

The bail handle provides secure and even guiding during operation. It can be adjusted without tools for optimal comfort and control.



Figure 2: The bail handle is designed for secure two-hand operation and can be quickly positioned.

3.3 Adjusting Cutting Depth (One-Touch Controller)

The KFM 15-10 F features a patented one-touch controller for fast, easy, and precise depth setting. This tool-free adjustment allows for setting the cutting depth in 0.1 mm (.004 inch) steps. Integrated detents protect against

unintentional adjustment during operation.

1. Locate the black knob on top of the tool.
2. Rotate the knob to adjust the cutting depth. The scale indicates the depth in millimeters and inches.
3. Ensure the desired depth is securely set before operation.



Figure 3: Adjusting the cutting depth using the one-touch controller for precise material removal.

Video: Demonstrates the fast, easy, and precise depth setting operation thanks to the patented one-touch controller, showing tool-free cutting depth setting in 0.1 mm/.004 inch steps and integrated detents protecting against unintentional adjustment.

Your browser does not support the video tag.

3.4 Adjusting Bevel Angle

The guide plates allow for precise setting of the chamfer angle directly. The universal carbide burr supports all chamfer angles from 0-90° without requiring additional cutter heads.

1. Loosen the screws securing the guide plates.
2. Adjust the guide plates to the desired bevel angle using the integrated scale.
3. Tighten the screws to secure the guide plates in position.



Figure 4: The adjustable guide plates allow for precise setting of the bevel angle from 0-90 degrees.

3.5 Installing/Replacing Carbide Inserts

The tool uses indexable carbide inserts for efficient and clean beveling. Replacement is straightforward.

1. Ensure the tool is disconnected from the power supply.

2. Using the appropriate Torx driver (included), loosen the retaining screws for the carbide inserts.
3. Carefully remove the old inserts.
4. Place new inserts into their respective slots, ensuring they are correctly oriented.
5. Tighten the retaining screws firmly.
6. Adjust the chip guards as needed for optimal chip evacuation.



Figure 5: Close-up of the milling head, showing the three indexable carbide inserts.

4. Operating Instructions

4.1 General Operation

1. Ensure the workpiece is securely clamped to a stable surface.
2. Hold the tool firmly with both hands using the main handle and the bail handle.
3. Connect the tool to a suitable power supply.
4. Press the lock-on switch to start the tool.
5. Gently guide the tool along the edge of the workpiece, maintaining consistent pressure and speed.
6. Allow the tool's electronics to maintain constant speed under load for optimal results.
7. Upon completion, release the switch to stop the tool.

4.2 Beveling Flat Edges

For flat edges, position the tool's guide plates flat against the workpiece surface. The large surface area guide plates offer maximum control, ensuring a stable and precise beveling process.



Figure 6: The tool in operation, demonstrating its use on a flat metal edge for weld preparation.

4.3 Beveling Pipes and Curved Surfaces

The integrated stop roller allows for perfect beveling of pipes and other curved surfaces, from an outer diameter of 75 mm (3 inches) and above. Position the roller against the curved surface and guide the tool smoothly around the circumference.

5. Maintenance

Regular maintenance ensures the longevity and optimal performance of your Metabo beveling tool.

- **Cleaning:** After each use, clean the tool, especially the milling head and guide plates, to remove metal chips and dust. Use a brush or compressed air. The Metabo Long-life motor features patented dust protection for extended service life.
- **Carbide Inserts:** Regularly inspect the carbide inserts for wear or damage. Replace them as described in Section 3.5 when they become dull or chipped to maintain cutting performance and prevent damage to the tool or workpiece.
- **Power Cord:** Check the power cord for any cuts, fraying, or damage. Do not use the tool if the cord is damaged.
- **General Inspection:** Periodically check all screws and fasteners for tightness. Tighten if necessary.
- **Storage:** Store the tool in a dry, secure location, out of reach of children and unauthorized users.

6. Troubleshooting

Problem	Possible Cause	Solution
Tool does not start.	No power supply; damaged cord; faulty switch.	Check power outlet and cord. If issues persist, contact authorized service.
Poor bevel quality / Rough finish.	Dull or damaged carbide inserts; incorrect depth/angle setting; improper feeding speed.	Replace carbide inserts. Re-adjust depth and angle. Maintain consistent, moderate feeding speed.
Excessive vibration.	Loose carbide inserts; damaged milling head; worn bearings.	Tighten carbide inserts. If vibration continues, contact authorized service.
Tool overheats.	Overloading the tool; blocked ventilation slots.	Reduce load. Clear ventilation slots. Allow tool to cool down. The tool has electronic overload protection.

For problems not listed here or if solutions do not resolve the issue, please contact a Metabo authorized service center.

7. Specifications

Attribute	Value
Manufacturer	Metabo
Part Number	KFM 15-10 F
Item Weight	10.8 pounds
Product Dimensions	14 x 3 x 3 inches
Item Model Number	KFM 15-10 F
Color	Green, Black, Silver
Power Source	Corded Electric
Voltage	120V
Wattage	1500 watts
Speed	500 RPM
Included Components	3 SQ4 carbide inserts, 4mm hex key, Tool, Torx 15 driver, roller guide for pipe

8. Warranty and Support

Warranty Information

All Metabo power tools have been carefully tested and inspected before shipment and are warranted to the original purchaser to be free from defects in workmanship and materials for a period of 3-years from the original user's date of purchase. This limited warranty does not apply to accessories or damage that Metabo determines to be from misuse, alteration, abuse, normal wear and tear, lack of maintenance, accidents or repairs made by or attempted by anyone other than Metabo authorized personnel. Sales receipt is required to qualify for warranty programs.

Customer Support

For technical assistance, spare parts, or warranty claims, please contact Metabo customer support or an authorized Metabo service center. You can find contact information on the official Metabo website or through your local dealer. Visit the official Metabo Store for more information: [Metabo Store](#)

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