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CZ NÁVOD K POUŽITÍ **PÁSOVÁ PILA NA KOV**

Překlad / Translation

EN USER MANUAL **HEAD BAND SAW**

BS 712TURN

Edition: 11.07.2018 – Revision - 00 – RAR - CZ/EN

2 BEZPEČNOSTNÍ SYMBOLY / SAFETY SIGNS

CZ BEZPEČNOSTNÍ SYMBOLY
VÝZNAM SYMBOLŮ

EN SAFETY SIGNS
DEFINITION OF SYMBOLS

CZ **CE-SHODA:** Tento výrobek odpovídá směrnicím ES

EN **EC-CONFORM:** This product complies with EC-directives

CZ **PŘEČTĚTE SI TENTO NÁVOD!** Přečtěte si řádně návod na obsluhu a údržbu Vašeho stroje a dobře se seznamte s ovládacími prvky stroje, aby byl tento řádně obsluhován a předešlo se ke škodám na stroji a zraněním osob.

EN **READ THE MANUAL!** Read the user and maintenance manual carefully and get familiar with the controls in order to use the machine correctly and to avoid injuries and machine defects.

CZ **VÝSTRAHA!** Dbejte bezpečnostních symbolů! Nedodržování předpisů a pokynů může vést k těžkým poraněním osob nebo dokonce smrtelným úrazům.

EN **ATTENTION!** Ignoring the safety signs and warnings applied on the machine as well as ignoring the security and operating instructions can cause serious injuries and even lead to death.

CZ **Všeobecný pokyn**

EN **General note**

CZ **Používejte ochranné prostředky!**

EN **Protective clothing!**

CZ **Před prováděním údržby a přestávkami vypněte stroj a odpojte zástrčku od sítě!**

EN **Stop and pull out the power plug before any break and engine maintenance!**

CZ **Výstraha před řeznými poraněními!**

EN **Warning about cut injuries!**

CZ **Výstraha před vymrštěnými částmi!**

EN **Warning against thrown-off items!**

CZ **Chraňte před vlhkem!**

EN **Protect from moisture!**

CZ **Dodržujte bezpečnou vzdálenost!**

EN **Keep safety distance!**

CZ **Obsluha s rukavicemi zakázána!**

EN **Operation with gloves forbidden!**

10 PREFACE (EN)

Dear Customer!

This manual contains information and important instructions for the installation and correct use of the head band saw BS 712TURN.
Following the usual commercial name of the device (see cover) is substituted in this manual with the name "machine".
This manual is part of the product and shall not be stored separately from the product. Save it for later reference and if you let other people use the product, add this instruction manual to the product.

Please read and obey the security instructions!
Before first use read this manual carefully. It eases the correct use of the product and prevents misunderstanding and damages of product and the user's health.

Due to constant advancements in product design, construction pictures and content may diverse slightly. However, if you discover any errors, inform us please.
Technical specifications are subject to changes!

Please check the product contents immediately after receipt for any eventual transport damage or missing parts.

Claims from transport damage or missing parts must be placed immediately after initial product receipt and unpacking before putting the product into operation.

Please understand that later claims cannot be accepted anymore.

Copyright

Customer service contact

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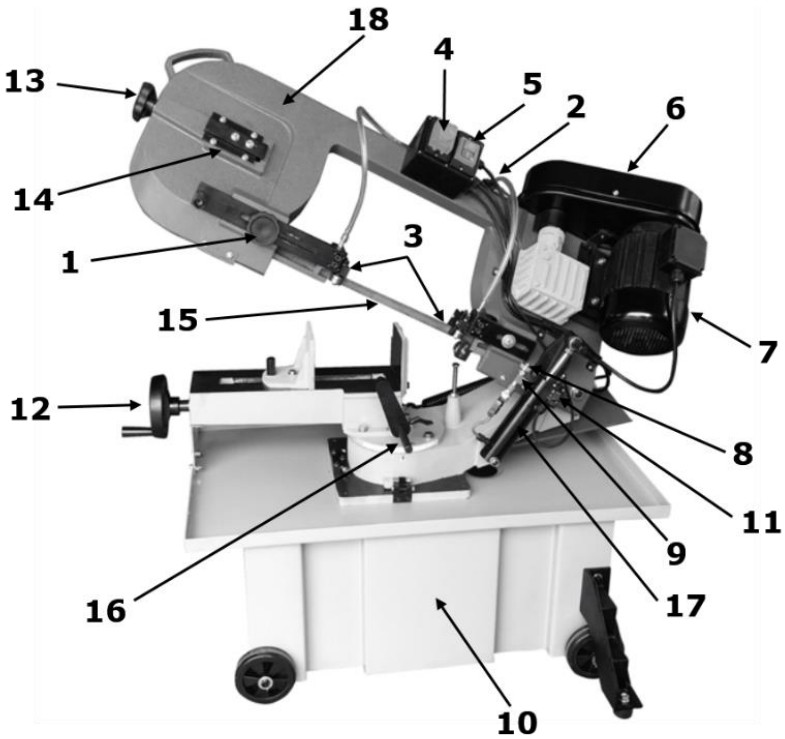
11 TECHNIC

11.1 Components

BS712TURN:

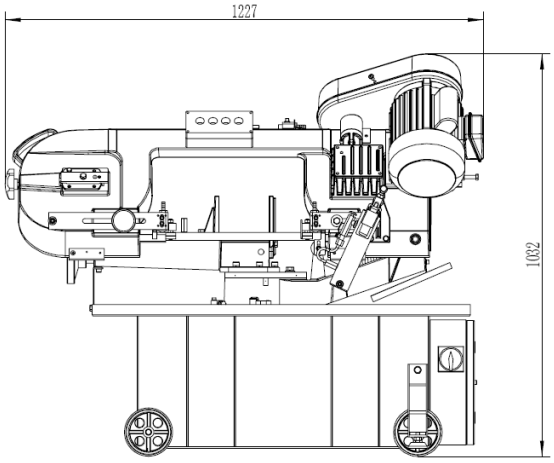


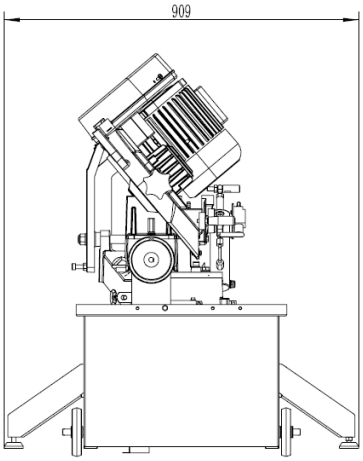
1	Blade guide adjustment knobs	**10**	Cabinet stand
2	Coolant controller	**11**	Automatic shut off switch
3	Blade guides	**12**	Vice handwheel
4	ON / OFF switch	**13**	Blade tension knob
5	Coolant pump ON / OFF switch	**14**	Blade tracking control
6	Belt housing	**15**	Blade
7	Motor	**16**	Work stop
8	Feed Rate Control knob	**17**	Hydraulic cylinder
9	Feed ON/OFF valve Lever	**18**	Saw arm

11.2 Technical details

	BT 712TURN
Voltage	230V 1p (50Hz) or 400V 3p (50 Hz)
Motor power	1,1 kW
Blade dimension	2360 x 20 x 0,9 mm
Cutting speed	22 / 33 / 45 / 65 m/min
Swivel range	-45° bis +45°
Cutting performance ⌀ mm	**0°:** 205/**-45°:** 150/**+45°:** 140
Cutting performance ▯ mm	**0°:** 205/**-45°:** 130/**+45°:** 90
Cutting performance ▭ mm	**0°:** 215x205 **-45°:** 100x200/**+45°:** 140x90
Weight (net)	140 kg

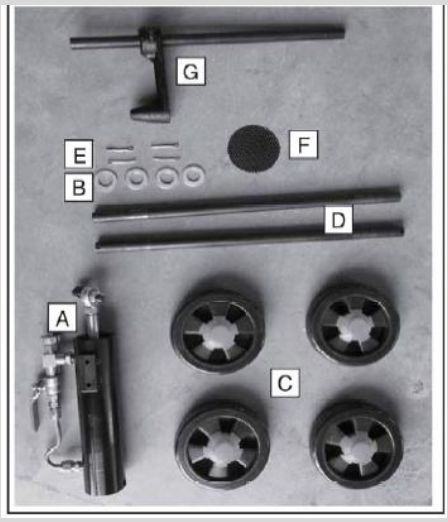
BS 712TURN:





11.3 Delivery content

Loose parts inventory



Pos	Bezeichnung	Menge
A	Hydraulic-cylinder	1
B	Washer	4
C	Wheels	4
D	Axle	2
E	Cotter Pin	4
F	Chip Screen	1
G	Work Stop	1

12 SAFETY

12.1 Intended Use

The machine must only be used for its intended purpose! Any other use is deemed to be a case of misuse.

To use the machine properly you must also observe and follow all safety regulations, the assembly instructions, operating and maintenance instructions lay down in this manual.

All people who use and service the machine have to be acquainted with this manual and must be informed about the machine's potential hazards.

It is also imperative to observe the accident prevention regulations in force in your area.

The same applies for the general rules of occupational health and safety.

The machine is used for:

To cut metal, cast iron and plastic materials

Any manipulation of the machine or its parts is a misuse, in this case HOLZMANN-MASCHINEN and its sales partners cannot be made liable for ANY direct or indirect damage.

WARNING

- **Use only blades allowable for this machine**
- **Never use damaged blades!**
- **Never use the machine with defective or without mounted guards**
- **The removal or modification of the safety components may result in damage to equipment and serious injury!**
- **The workpiece must be always clamped in the machine vice during cutting**
- **To remove sawdust and chippings from the machine when running is strictly prohibited!**

HIGHEST RISK OF INJURY!

12.2 Prohibited use

- The operation of the machine outside the stated technical limits described in this manual is forbidden.
- The machine shall not be operated in areas exposed to increased fire or explosion hazard.
- The use of the machine not being suitable for the use of the machine and not being certified is forbidden.
- The use of the machine not according with the required dimensions is forbidden.
- Any manipulation of the machine and parts is forbidden.
- The use of the machine for any purposes other than described in this user-manual is forbidden.
- The unattended operation on the machine during the working process is forbidden
- It is not allowed to leave the immediate work area during the work is being performed!

12.3 Security instructions

Missing or non-readable security stickers have to be replaced immediately!

The locally applicable laws and regulations may specify the minimum age of the operator and limit the use of this machine!

To avoid malfunction, machine defects and injuries, read the following security instructions!

- **Keep your work area dry and tidy! An untidy work area may cause accidents. Avoid slippery floor!**
- **Make sure the work area is lighted sufficiently!**
- **Work only in a well ventilated area!**
- **Do not overload the machine!**

- **Provide good stability and keep balance all times.**
- **Keep away from the running blade!**
- **Always stay focused when working. Reduce distortion sources in your working environment. The operation of the machine when being tired, as well as under the influence of alcohol, drugs or concentration influencing medicaments is forbidden!**

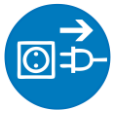
- **Only one person shall operate the machine**
- **The machine must be operated only by trained persons (knowledge and understanding of this manual), which have no limitations of motor skills compared with conventional workers.**

- **Do not allow other people, particularly children, to touch the machine or the cable. Keep them away from your work area!**
- **Make sure there is nobody present in the dangerous area. The minimum safety distance is 2m**

- **Wear suitable work clothes! Do not wear loose clothing or jewelry as they might be caught and cause severe accidents!**
- **Wear a hair net if you have long hair**
- **Loose objects can become entangled and cause serious injuries!**

- **Use personal safety equipment: ear protectors, safety goggles, safety shoes S1, work wear, safety gloves (EN 388, class 3111) when working with or on the machine!**
- **Never leave the machine running unattended! Before leaving the working area switch the machine off and wait until the machine stops!**

- **Always disconnect the machine prior to any actions performed at the machine!**
- **Avoid unintentional starting**
- **Do not use the machine with damaged switch**
- **The plug of an electrical tool must strictly correspond to the socket. Do not use any adapters together with earthed electric tools**



- **Each time you work with an electrically operated machine, caution is advised! There is a risk of electric shock, fire, cutting injury;**
- **Protect the machine from dampness (causing a short circuit)**

- **Use power tools and machines never in the vicinity of flammable liquids and gases (danger of explosion)**
- **Check the cable regularly for damage**
- **Do not use the cable to carry the machine or to fix the work piece**

- **Protect the cable from heat, oil and sharp edges**
- **Avoid body contact with earthed components**
- **Serious injuries caused by sharp edges on the hand are possible.**

12.4 Remaining risk factors

Even if the machine is used as required it is still impossible to eliminate certain residual risk factors totally. The following hazards may arise in connection with the machine´s construction and design:

- Risk of injury to the hands / fingers by the blade during operation.
- Risk of injury due to sharp edges of the workpiece.
- Risk of injury due to contacting with live electrical components.
- Risk of injury due to breakage or being thrown out of the saw blade or portions thereof, at overloading and incorrect direction of the saw blade..
- Risk of injury to the hearing by prolonged labor without hearing protection
- Risk of injury to the eye by flying debris, even with goggles..

13 ASSEMBLY

13.1 Preparatory activities

13.1.1 Delivery content

Please check the product contents immediately after receipt for any eventual transport damage or missing parts. Claims from transport damage or missing parts must be placed immediately after initial machine receipt and unpacking before putting the machine into operation. Please understand that later claims cannot be accepted anymore.

13.1.2 Workplace requirements

The workplace has to fulfill the requirements.
The ground has to be even, in level and hard. It must be suitable at least to weight it with double weight per square meter than the machines net weight.
The chosen workplace must have access to a suitable electric supply net hat complies with the machines requirements.

13.1.3 Transport

The machine can be transported in package with a forklift.

The machine is very heavy. The machine shall be lifted from crate with a suitable lifting device only that is certified to be able to carry the machines load.

	WARNING
	The lifting and transportation of the machine must only be carried out by qualified staff and must be carried out with appropriate equipment**.**

Note that lifting equipment used (crane, forklift, sling, etc.) must be in perfect condition.

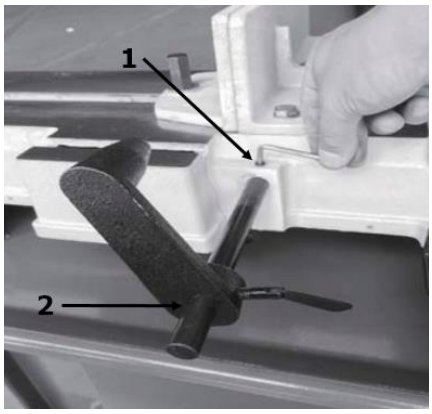
To maneuver the machine in the packaging can also a pallet jack or a forklift be used.

Uncoated metal machine parts have been insulated with a greasy layer to inhibit corrosion.

This layer has to be removed. You can use standard solvents that do not damage the machine surface.

13.2 Assembly

13.2.1 Workstop

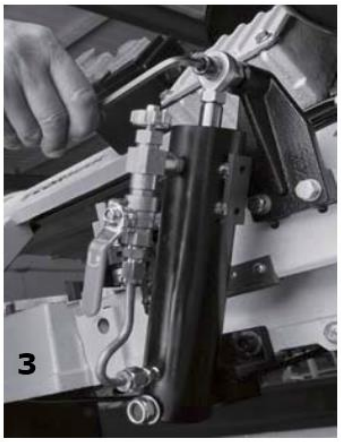


Insert work stop rod through hole in base and lock in place with screw (1).

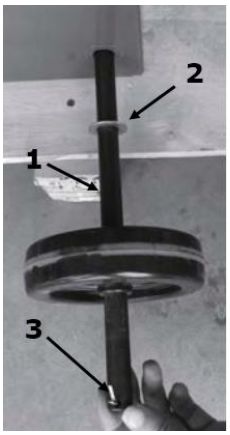
Slide work stop (2) over rod and tighten thumbscrew to set work stop at desired length.

13.2.2 Hydraulic cylinder

Follow steps 1 - 3 to install the Hydraulic cylinder



13.2.3 Wheels



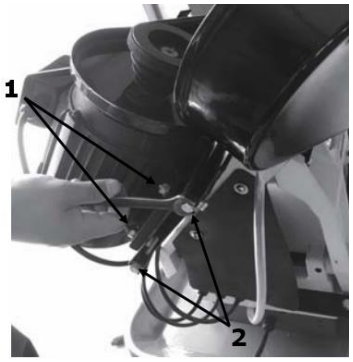
Slide axle (1) through holes in bottom of cabinet.
Slide a flat washer (2) and a wheel onto the axle. Secure with a cotter pin (3).

13.2.4 V-belt

The V-belt needs to be tensioned or repositioned for your desired RPM.

To tension or reposition V-belt:

1. Disconnect machine from power.
2. Loosen the two hex bolts on motor mount bracket (1)
3. Adjust the two hex bolts on motor mount plate to loosen / tension belt (2).
4. Slip V-belt over combination of pulleys to get desired RPM. Make sure belt is on parallel sheaves.



13.3 Power supply

ATTENTION

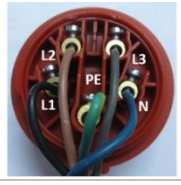
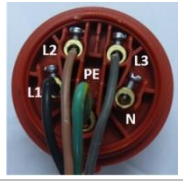
When working with non-grounded machines:
Severe injury or even death may arise though electrocution!
Therefore: The machine must be operated at a grounded power socket

The connection of the machine to the electric power supply and the following checks have to be carried out by a respectively trained electrician only.

1. The electronic connection of the machine is designated for operation with a grounded power socket!
2. The mains supply must be secured with 16A:
3. If the connector plug doesn't fit or if it is defect, only qualified electricians may modify or re-new it!
4. The grounding wire should be held in green-yellow.
5. A damaged cable has to be exchanged immediately!
6. Check, whether the feeding voltage and the Hz comply to the required values of the machine. A deviation of feeding voltage of ±5% is allowed (e.g.: a machine with working voltage of 380V can work within a voltage bandwidth of 370 till 400V.
7. After connecting, check the right running direction!
8. Make sure that a possible extension cord is in good condition and suitable for the transmission of power. An undersized cord reduces the transmission of power and heats up.
9. A damaged cable must be replaced immediately

NOTICE

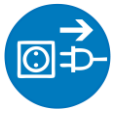
Operation is only allowed with safety switch against stray current (RCD max. stray current of 30mA)

Plug 400V:	5-wire: **with** N-conductor		4-wire: **without** N-conductor	

14 OPERATION

Device to be operated in a perfect state only. Inspect the device visually every time it is to be used. Check in particular the safety equipment, electrical controls, electric cables and screwed connection for damage and if tightened properly. Replace any damaged parts before operating the device.

14.1 Operation instructions



WARNING

Perform all machine settings with the machine being disconnected from the power supply!

NOTICE

Checks to carry out before each workshift:

- General technical condition of the machine
- Safety equipment available and in working order
- Check sawband for wear and replace if necessary
- Check the coolant level and top up if necessary
- Moving parts are not blocked
- All the components for correct fit and function, especially the screws on the blade guard and lever control!
- All the tools for service / maintenance from the machine.
- Set the blade guard as close as possible to the workpiece.
- Splash guard

Checks to carry out before each cut:

- Angle set correctly?
- Vice adequately fixed?
- Make sure that the material to be processed is fixed properly in the vice.
- Ensure that the coolant circulates properly.
- Running direction of saw blade.

- **Never switch the machine on while pressing the blade against the material!**
- **Wait until the sawband has reached full speed – then performing the cut!**
- **For the cooling of the blade fill the tank with coolant liquid (KSM5L)**
- **Always support long overhanging workpieces additionally**

14.2 Operation

14.2.1 Control panel

SB2	ON-switch	
SB1	OFF-switch	
SA2	Coolant switch	

14.3 Adjusting

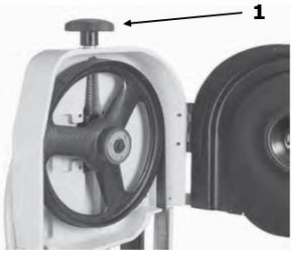
14.3.1 Blade tension and Tracking

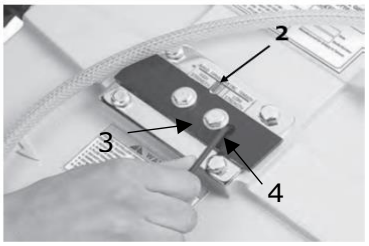
Proper blade tension is essential to long blade life, straight cuts and efficient cutting.

To tension blade on bandsaw:

1. Turn blade tension handle (1) clockwise to tension blade
2. Tension blade until blade tension guide indicator (2) is in green zone.

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

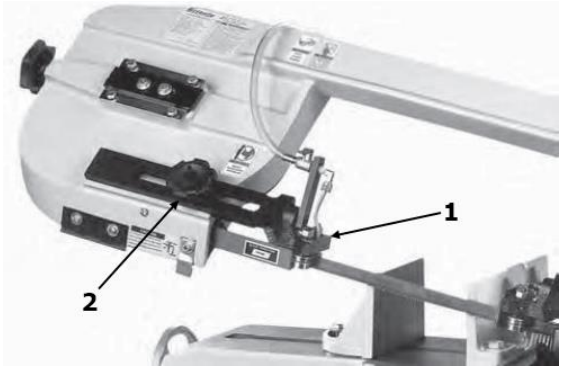




To adjust blade tracking on bandsaw:

1. Disconnect machine from power
2. Position bandsaw in vertical position
3. Open wheel access cover
4. Loosen, but do not remove lower hex bolt (3) in blade wheel tilting mechanism.
5. Relax blade tension
6. Adjust set screw with a 4mm hex wrench (4), then tighten hex bolt (3).
   a. Tightening set screw will move blade closer to shoulder of wheel.
   b. Loosening set screw will move blade away from shoulder
7. Tension blade
8. Check if blade tracks along shoulder of wheel adjustment is completed, if blade walks from shoulder of wheel or hits shoulder repeat steps 4-7 until blade tracks properly.

14.3.2 Blade guide



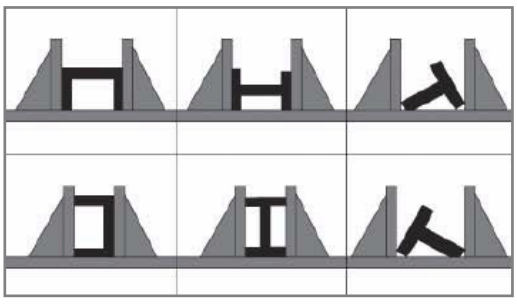
The blade guides should be positioned approximately 8mm away from workpiece. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.
To adjust blade guides:

Loosen blade guide adjustment knob (2)

Set blade guide (1) desired position

Tighten blade guide adjustment knob (2)

14.4 Clamping the workpiece

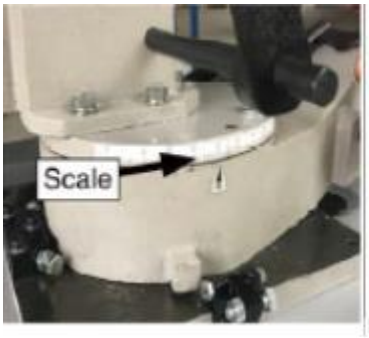


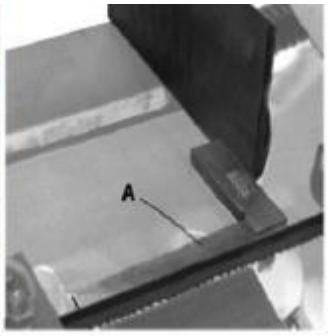
- Open the vice with the vice handwheel
- Insert workpiece in a way that it touches aligned the fixed jaw of the vice
- Take care to insert workpiece correctly (see figure)
- Overhanging workpieces must be supported additionally!
- Now clamp the workpiece with the vice handwheel
- Use the adjustable workpiece end stop, to cut long workpieces into even sections

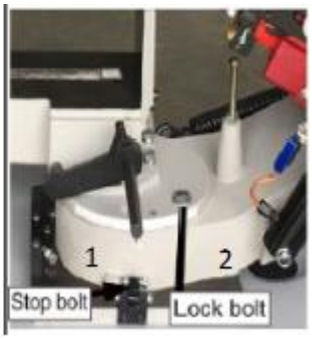
14.5 Cutting angle

To Square blade to vise:

1. Use scale to set the angle at 0°
2. Place a machinist`s square on the bed against the blade and the fixed vise jaw. The square should lie along entire length of jaw and blade without gap.
3. If adjustment is necessary, loosen lock bolt (2) holding swivel disc and turn the stop bolt over (1), swivel saw body until saw blade aligns with square.
4. Retighten the bolts.

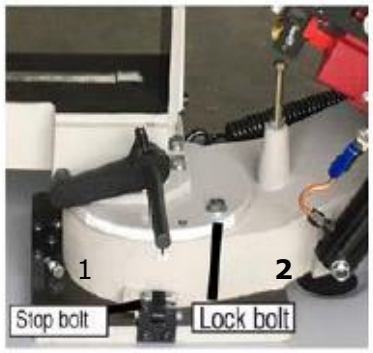






To swive saw body to 45°

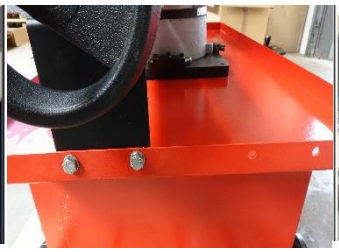
1. Loosen lock bolt (1) holding to swivel disc and turn the stop bolt (2) over.
2. Swive saw body to right side and use scale to set the angle at 45°.
3. Tighten lock nut (1).



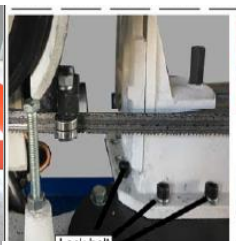
To swive saw body to -45°

1. Loosen and take off three lock bolts holding the vise (see picture 1&2).
2. Move the vise to locking position at right side and retighten three bolts at new position (see picture 3 &4)
3. Loosen lock bolt (1) holding the swivel disc and turn the stop bolt over (2).
4. Swive saw body to right side and use scale to set the angle at 45°.
6. Tighten lock nut (1).

Picture (1 & 2)



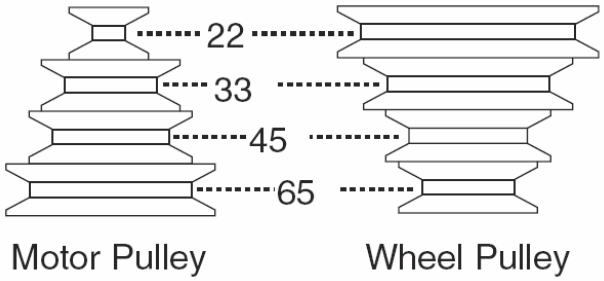
Picture 3



Picture (4 & 5)

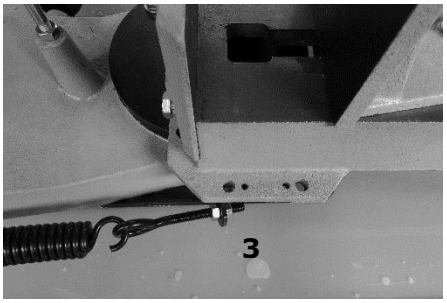
14.6 Cutting speed

- Loosen V-belt
- Adjust desired cutting speed
- Tighten V-belt



14.7 Cutting

1. Raise bow to maximum height to remove spring tension. Close On/Off valve (2) to lock bow in place.
2. Adjust feed pressure tension:
   Tension spring by adjusting the nut (3). Tighten enough to remove clearance but not enough to apply tension to spring. Note Increasing the spring tension will reduce the feed pressure.
3. Clamp the workpiece.
4. Open the On/Off valve (2) and position the saw blade a few mm above the workpiece.
5. Close the On/Off valve (3) again.
6. With the correct saw blade and blade speed selected, turn saw (push SB2) and lubricant pump on (push SA2)
7. Open the on/off valve (2) and adjust with the feed rate dial (1) the accurate feed rate (rotating feed rate dial clockwise slows the feed rate, by turning it counter clockwise feed rate increase.)
8. After cutting finished, machine can stopped automatically
9. The cutting procedure can be interrupted by pusching SB1



15 MAINTENANCE

ATTENTION

Perform all maintenance machine settings with the machine being disconnected from the power supply!

Serious injury due to unintentional or automatic activation of the machine!

The machine does not require extensive maintenance. If malfunctions and defects occur, let it be serviced by trained persons only:

NOTICE

Clean your machine regularly after every usage – it prolongs the machines lifespan and is a pre-requisite for a safe working environment.

Repair jobs shall be performed by respectively trained professionals only!

Check regularly the condition of the security stickers. Replace them if required.

Check regularly the condition of the machine!

Store the machine in a closed, dry location.

Before first operation you should lubricate all connecting parts.

15.1 Maintenance plan

After each workshift:

- Raise the saw arm in the most upper position, secure it and close the hydraulic flow regulation valve.
- Detension the saw band.
- Clean the machine entirely.
- Lubricate the gliding surface of the vice and the blade slightly with some machinery oil.
- Clean the coolant tank from metal chips.

After 50 hours of operation

- Change coolant liquid, clean coolant tank and filter entirely
- Lubricate all connecting parts (if required, remove beforehand with a brush all swarfs and dust)

After 100 hours of operation

- Change gear oil (ISO 220)

15.2 Changing saw blade

- Remove the saw blade protection cover by loosening and removing all screws.
- Loosen the saw band with the hand wheel entirely.
- Now remove cautiously the old saw band. Use cutting proof gloves.
- Install the new saw blade. Insert it first through both saw blade guide bearings and then lay them onto the flywheels.
- ATTENTION: Take care to install the saw band correctly! Check the direction of the teething.
- Tension the saw band with hand wheel.
- You can check the tension by applying in the middle of the free blade section a pressure of approx. 50Nm on the blade side. The blade is tensioned correctly, if it can be moved 3mm sidewards out of the straight cutting line.
- Turn by hand a flywheel and check the saw band for straight run

15.3 Gearbox

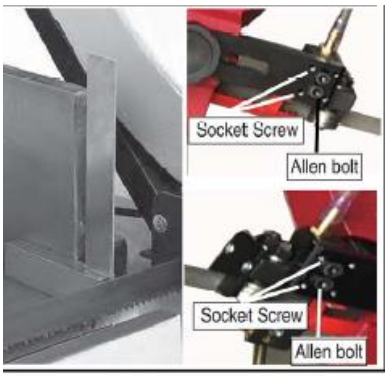
In normal conditions the gear oi (ISO 220) must be changed after 100 operation hours and after all changes of gears.

15.1 To Square Blade

To square blade to bed of table:

Lower head of the bandsaw until it contacts horizontal stop. Place a square on table bed and against edge of blade, and check different points along lenght of table between blade guides.

If adjustment is necessary loosen allen bolts and adjust four socket srews to rotate blade guide until blade is vertical against the bed. Note: both blade guides can be adjusted to achieve the results you want. Afterwards tighten allen bolts



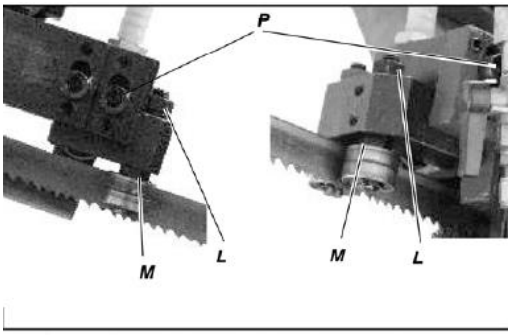
15.2 Adjusting Blade Guide Bearings

The blade is guided. The blade guide is adjusted by factory for a 0.9mm thick blade.

In the case of toothed blade with different thickness adjustment should be carried out as follows.

Loosen hex head screa (L), adjusting the eccentric shaft (M), and the adjustable bearing set will far away or close to the blade. Make sure that bearing smooth touch the blade. Then re-tighten hex head screw (L) .

Make sure that the top guide bearing has at least a gap (clearance) of at least 0.2~0.3mm. If necessary, loosen the allen screws (P) that fasten the block and adjust accordingly.



15.3 Cleaning

After each workshift the machine has to be cleaned. Remove chips etc. with a suitable tool. Do not remove them by hand (cutting injury!). Remove dust as well.

NOTICE

The usage of certain solutions containing ingredients damaging metal surfaces as well as the use of scrubbing agents will damage the machine surface!

Clean the machine surface with a wet cloth soaked in a mild solution

15.4 Disposal

Do not dispose the machine in residual waste. Contact your local authorities for information regarding the available disposal options. When you buy at your local dealer for a replacement unit, the latter is obliged to exchange your old.

16 TROUBLE SHOOTING

BEFORE YOU START WORKING FOR THE ELIMINATION OF DEFECTS, DISCONNECT THE MACHINE FROM THE POWER SUPPLY.

Trouble	Possible cause	Solution
Machine does not start	▪ Machine not connected to power supply ▪ Fuse of power circuit defect or not suitable ▪ Cable defect	▪ Check all power connections ▪ Change fuse ▪ Change cable
Saw band does not come to full speed, no power	▪ To long extension cord ▪ Power supply not matching with motor requirements. ▪ Weak, instable/volatile power supply	▪ change to suitable extension cord with sufficient cross-section, insulation and length ▪ Let check by electrician ▪ Contact electric power company
Motor gets hot very fast and has weak performance	▪ Motor does not receive power on one or even 2 phases	▪ Shut off machine immediately. Let the connection to supply circuit be checked by an electrician!
Saw band runs in opposite direction	▪ 2 of the 3 leading phases are switched whether in Plug or socket	Shut off machine immediately. Let the connection to supply circuit be corrected by an electrician!
Machine vibrates	▪ Placed on uneven underground ▪ Motor or any other parts loose	▪ modify ▪ check all screw joints if tightened
Bad cuts	▪ too high descent velocity ▪ unsuitable saw band for cutted material ▪ worn saw band ▪ saw band not tensioned correctly ▪ saw band guide outbalanced	▪ Reduce the descent velocity ▪ Use e.g. for stainless steel HQ Bi-Metal bands only ▪ replace ▪ tension saw band correctly ▪ readjust saw band guide

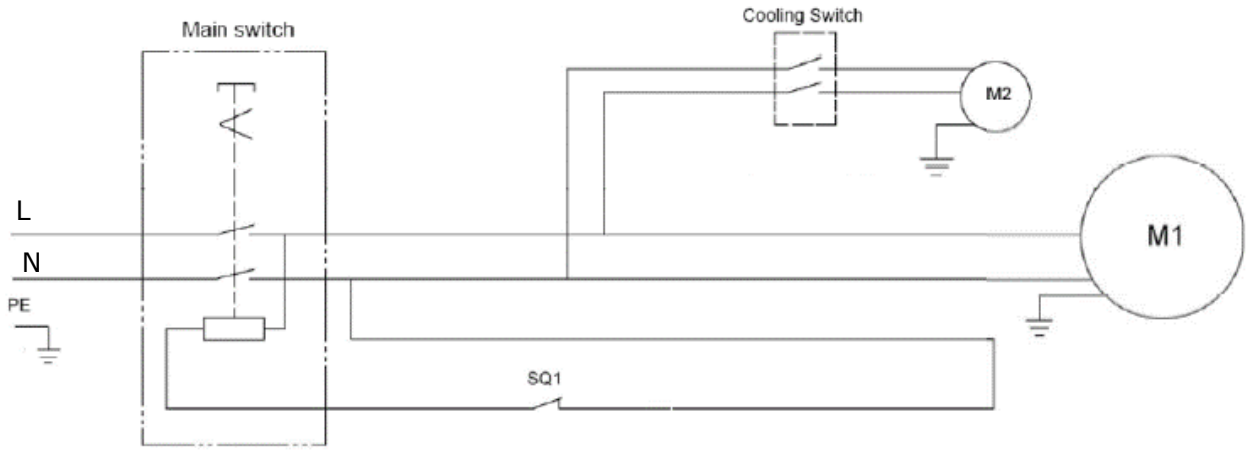
MANY POTENTIAL SOURCES OF ERROR CAN BE CLEARED BY THE EXPERTLY CONNECTION TO THE ELECTRICITY GRID.

NOTICE

Should you in necessary repairs not able to properly to perform or you have not the prescribed training for it always attract a workshop to fix the problem.

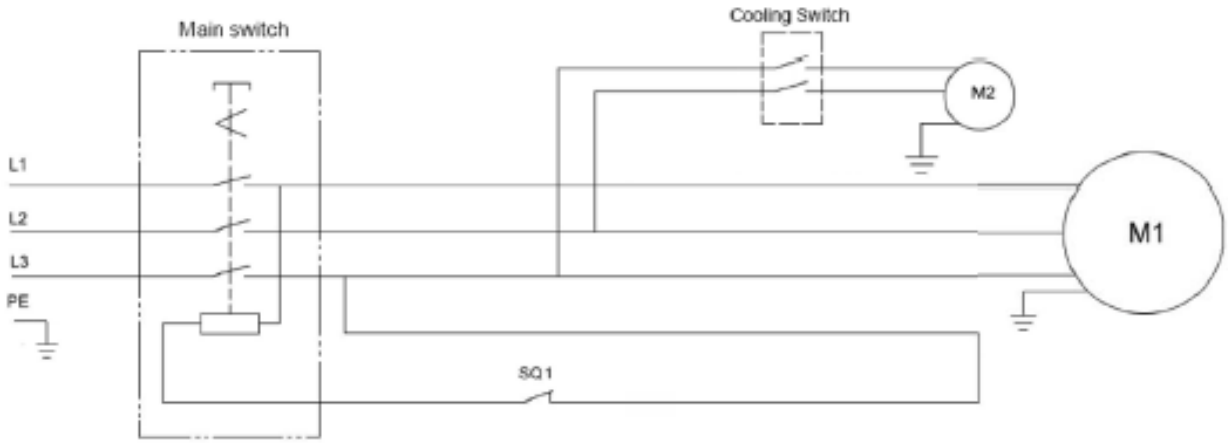
17 ELEKTROSCHÉMA / WIRING DIAGRAM

1-Phase (230V)



M1:Motor
M2:Cooling pump
SQ1:Cutting micro switch

3-Phase (400V)



M1:Motor
M2:Cooling pump
SQ1:Cutting micro switch

18 NÁHRADNÍ DÍLY / SPARE PARTS

18.1 Objednávka náhradních dílů / spare parts order

Použitím originálních dílů od společnosti Holzmann používáte díly, které spolu dokonale sedí a jejich montáž je časově méně náročná. Originální náhradní díly jsou zárukou delší životnosti stroje.

UPOZORNĚNÍ

Použití jiných než originálních náhradních dílů má za následek ztrátu záruky!

Platí: Při výměně komponent/dílů používejte pouze originální náhradní díly.

Při objednávání dílů použijte servisní formulář, který najdete na konci tohoto návodu na obsluhu. Vždy uvádějte typ stroje, číslo náhradního dílu a jeho název. Aby se předešlo neshodám, doporučujeme společně s objednávkou zaslat i kopii výkresu rozpadu náhradních dílů, na kterém Vámi požadované díly označíte.

Adresu pro objednání dílů naleznete v kontaktech na zákaznický servis.

With original HOLZMANN spare parts you use parts that are attuned to each other shorten the installation time and elongate your products lifespan.

IMPORTANT

The installation of other than original spare parts voids the warranty!

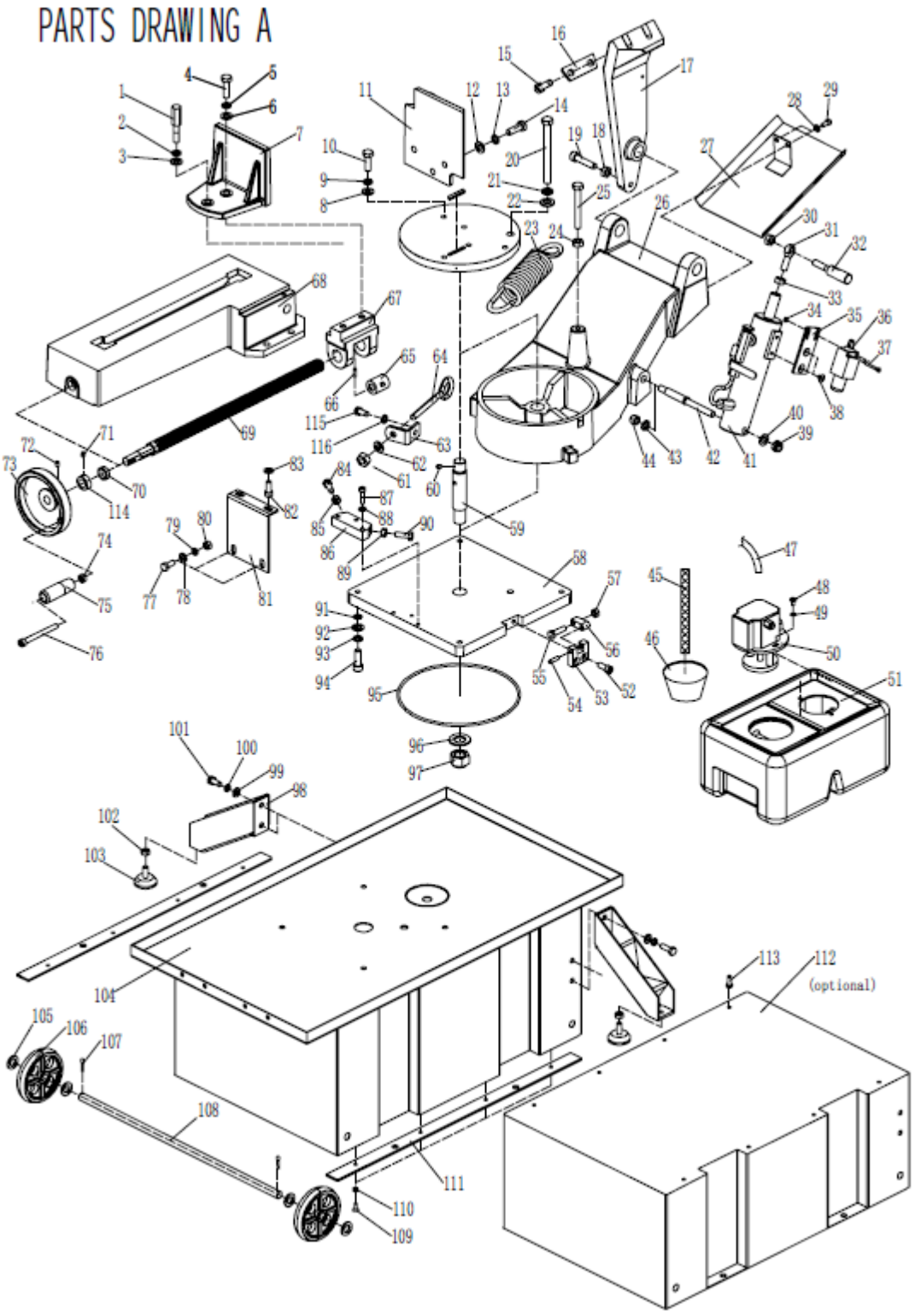
So you always have to use original spare parts

When you place a spare parts order please use the service formular you can find in the last chapter of this manual. Always take a note of the machine type, spare parts number and partname. We recommend to copy the spare parts diagram and mark the spare part you need.

You find the order address in the preface of this operation manual.

18.2 Výkres dílů / explosion drawing

BS712TURN:

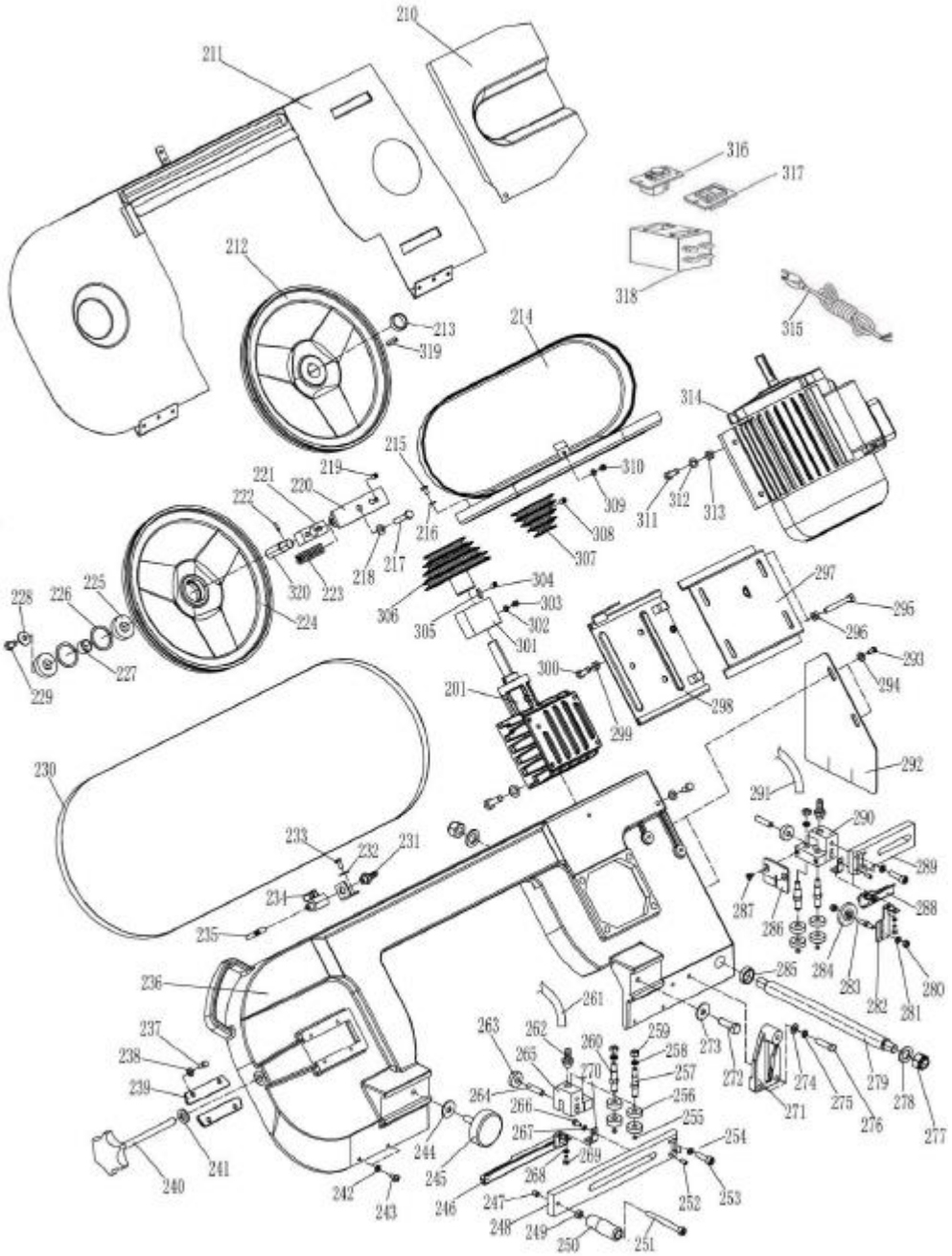


PART LIST A

PART	DESCRIPTION
1	DRAGGING HANDLE
2	SPRING WASHER 10
3	WASHER 10
4	HEX. BOLT M10X35
5	SPRING WASHER 10
6	WASHER 10
7	VISE JAW BRACKET (REAR)
8	WASHER 10
9	SPRING WASHER 10
10	HEX. BOLT M10X30
11	VISE JAW BRACKET (FRONT)
12	WASHER 10
13	SPRING WASHER 10
14	HEX. BOLT M10X30
15	HEX. BOLT M10X35
16	PLATE
17	PIVOT BRACKET
18	NUT M10
19	HEX. BOLT M10X45
20	HEX. BOLT M12X120
21	SPRING WASHER 12
22	WASHER 12
23	SPRING
24	NUT M10
25	HEX. BOLT M10X80
26	SWIVEL ARM
27	COOLANT AND CHIP TRAY
28	WASHER 6
29	ALLEN SCREW M6X12
30	NUT M10
31	JOINT BEARING
32	SPECIAL BOLT M10X40
33	NUT M10
34	NUT M4
35	SWITCH BRACKET
36	LIMIT SWITCH
37	ALLEN SCREW M4X30
38	SUNK HEAD SCREW M6X8
39	HEX. LOCK NUT M10
40	WASHER 10
41	HYDRAULIC CYLINDER
42	CYLINDER SUPPORT ROD
43	WASHER 10
44	HEX. LOCK NUT M10
45	RETURN PIPE
46	FILTRATION
47	FLOW PIPE
48	PAN HEAD SCREW M6X12
49	WASHER 6
50	COOLANT PUMP
51	COOLANT TANK
52	ALLEN SCREW M8X20
53	POSTION-LIMIT SEAT
54	PIN
55	HEX. BOLT M8X30
56	POSTION-LIMIT(ACTIVE)
57	NUT M8
58	SEAT

PART	DESCRIPTION
59	SWIVEL SHAFT
60	SET SCREW M8X10
61	NUT M10
62	WASHER 10
63	SPRING BRACKET
64	SPRING ADJUSTING ROD
65	QUICK NUT
66	SPRING PIN 6X20
67	BRACKET
68	TABLE
69	ACME SCREW
70	THIN-WALL BUSH
71	FIXED BUSH
72	SET SCREW M6X10
73	HAND WHEEL
74	NUT M8
75	HANDLE
76	ALLEN SCREW M8X80
77	HEX. BOLT M8X20
78	SPRING WASHER 8
79	WASHER 8
80	NUT M8
81	SUPPORT PLATE
82	ALLEN SCREW M8X20
83	WASHER 8
84	HEX. BOLT M8X25
85	NUT M8
86	POSTION-LIMIT(FIXED)
87	ALLEN SCREW M6X25
88	WASHER 6
89	NUT M8
90	HEX. BOLT M8X25
91	OIL SEAL 10X2.65
92	WASHER 10
93	SPRING WASHER 10
94	ALLEN SCREW M10X30
95	SPECIAL OIL SEAL
96	WASHER 20
97	HEX. LOCK NUT M20
98	SUPPORT BRACKET
99	WASHER 10
100	SPRING WASHER 10
101	HEX. BOLT M10X30
102	NUT M10
103	FOOT
104	FRAME
105	WASHER 16
106	ROLLING WHEEL
107	COTTER 2.5X25
108	WHEEL ROD
109	SUN HEAD SCREW M6X16
110	NUT M6
111	DECORATING PLATE
112	BOTTOM BOX (OPTIONAL)
113	HEX. BOLT M6X12
114	FIXED BUSH
115	HEX. BOLT M8X25
116	WASHER 8

PARTS DRAWING B

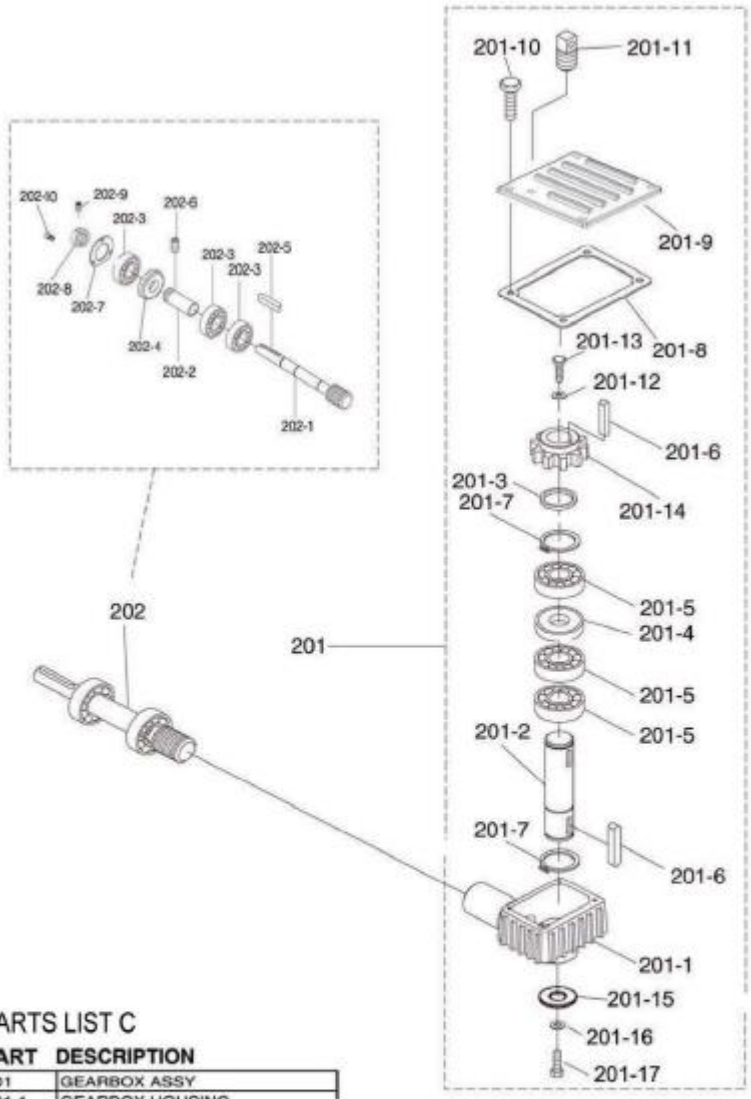


PART LIST B

PART	DESCRIPTION
201	GEAR BOX ASSY
210	DRIVE WHEEL COVER
211	BLADE BACK COVER
212	DRIVE WHEEL
213	SPACER
214	MOTOR PULLEY COVER
215	PAN SCREW M6X10
216	WASHER 6
217	HEX.BOLT M8x40
218	WASHER 8
219	SET SCREW M8x20
220	BLADE TENSION SLIDING BLOCK
221	IDLER WHEEL SEAT
222	COTTER 5X22
223	SPRING
224	IDLER WHEEL
225	BEARING 6203
226	CIRCLIP FOR HOLE
227	SPACER
228	BIG WASHER 8
229	HEX. BOLT M8X16
230	BLADE 0.9*19*2360
231	PIPE FITTING
232	WASHER 5
233	PAN SCREW M5X8
234	COOLANT SWITCH
235	Y VALVE
236	BODY FRAME
237	HEX.BOLT M6x16
238	WASHER 6
239	SLIDING PLATE
240	BLADE ADJUSTABLE KNOB
241	WASHER 10
242	WASHER 6
243	PAN HEAD SCREW M6x12
244	WASHER 10
245	KNOB BOLT
246	BLADE COVER,FRONT
247	SET SCREW M8x10
248	ADJUST BRACKET,FRONT
249	NUT M8
250	HANDLE
251	ALLEN SCREW M8X80
252	SET SCREW M6X12
253	ALLEN SCREW M8X25
254	SPRING WASHER 8
255	CIRCLIP FOR SHAFT
256	BEARING
257	BEARING SHAFT
258	SPRING WASHER 8
259	NUT M8
260	ECCENTRIC SHAFT
261	COOLANT PIPE A
262	PIPE FITTING
263	BEARING
264	PIN

PART	DESCRIPTION
265	GUIDE BLOCK, FRONT
266	ALLEN SCREW M5X10
267	WASHER 5
268	WASHER 5
269	ALLEN SCREW M5X10
270	JOINT PLATE
271	CYLINDER BRACKET
272	HEX. BOLT M10X35
273	BIG WASHER 10
274	WASHER 8
275	SPRING WASHER 8
276	HEX. BOLT M8*30
277	LOCK NUT M16
278	WASHER 16
279	SUPPORT ROD
280	LOCK NUT M8
281	WASHER 8
282	BRUSH BRACKET
283	BRUSH SHAFT
284	BRUSH
285	SPACER
286	SPLASH GUARD
287	SUNK HEAD SCREW
288	BLADE COVER,REAR
289	ADJUST BRACKET,REAR
290	GUIDE BLOCK, REAR
291	COOLANT PIPE B
292	SPLASH PLATE
293	PAN HEAD SCREW M6x12
294	WASHER 6
295	HEX.BOLT M8x60
296	NUT M8
297	MOTOR MOUNT
298	MOTPR MOUNT BRACKET
299	NUT M8
300	HEX. BOLT M8X35
301	SHAFT COVER
302	WASHER 6
303	PAN HEAD SCREW M6x12
304	SET SCREW M8X12
305	KEY 5*5*30
306	SPINDLE PULLEY
307	MOTOR PULLEY
308	SET SCREW M8X12
309	WASHER 6
310	PAN HEAD SCREW M6x12
311	HEX.BOLT M8x25
312	WASHER 8
313	NUT M8
314	MOTOR
315	POWER CABLE
316	MAIN SWITCH
317	PUMP SWITCH
318	ELECTRICAL BOX
319	KEY 6*6*20
320	WHEEL SHAFT

PARTS DRAWING C



PARTS LIST C

PART	DESCRIPTION
201	GEARBOX ASSY
201-1	GEARBOX HOUSING
201-2	TRANSMISSION WHEEL SHAFT
201-3	SPACER
201-4	OIL SEAL 25X47X10
201-5	BALL BEARING 6005
201-6	KEY 6 X 6 X 20
201-7	EXT RETAINING RING 25MM
201-8	GEARBOX GASKET
201-9	GEARBOX COVER
201-10	HEX. BOLT M6X12
201-11	VENT PLUG
201-12	WASHER
201-13	HEX. BOLT M8X16
201-14	WORM GEAR
201-15	SPECIAL WASHER

PART	DESCRIPTION
201-16	SPRING WASHER
201-17	HEX. BOLT M10X25
202	WORM GEAR SHAFT ASSEMBLY
202-1	WORM SHAFT
202-2	BEARING BUSHING
202-3	BALL BEARING 6003
202-4	OIL DEAL 17X35X7
202-5	KEY 5X5X30
202-6	SET SCREW M10X16
202-7	BEARING COVER
202-8	SPACER
202-9	SET SCREW M8X10
202-10	SCREW M5X10

19 CE-PROHLÁŠENÍ O SHODĚ/CE-CERTIFICATE OF CONFORMITY

CE

Prodejce / Distributor

HOLZMANN MASCHINEN® GmbH
4170 Haslach, Marktplatz 4, AUSTRIA
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www.holzmann-maschinen.at

Název / name
PÁSOVÁ PILA NA KOV / HEAD BAND SAW
Typ / model
BS 712TURN
Směrnice EU / EC-directives
▪2006/42/EG
Aplikované normy / applicable Standards
▪EN 13898:2003+A1:2009+AC:2010, ▪EN 60204-1:2006+A1:2009+AC:2010 ▪EN ISO 12100:2010

Tímto prohlašujeme, že výše uvedený typ stroje splňuje bezpečnostní a zdravotní požadavky směrnic ES. Toto prohlášení ztrácí svou platnost, pokud by došlo ke změnám nebo úpravám stroje, které námi nebyly odsouhlaseny.

Hereby we declare that the above mentioned machines meet the essential safety and health requirements of the above stated EC directives. Any manipulation or change of the machine not being explicitly authorized by us in advance renders this document null and void.

Technická dokumentace
HOLZMANN-MASCHINEN GmbH
4170 Haslach, Marktplatz 4

Haslach, 18.12.2017
Místo / Datum place/date

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