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Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN USER MANUAL

FR MODE D'EMPLOI

IT ISTRUZIONI PER L'USO

ES INSTRUCCIONES DE SERVICIO

BAND - TELLERSCHLEIFER

BELT AND DISC SANDER

PONCEUSE A BANDE ET A DISQUE

LEVIGATRICE A NASTRO E A DISCO

LIJADORA DE CINTA-DISCO



BT1220TOP_230V



**YOUR
JOB.
OUR
TOOLS.**



2 SICHERHEITSZEICHEN / SAFETY SIGNS

DE	SICHERHEITSZEICHEN BEDEUTUNG DER SYMBOLE	EN	SAFETY SIGNS DEFINITION OF SYMBOLS	FR	SIGNALISATION DE SÉCURITÉ DÉFINITION DES SYMBOLES
IT	SEGNALI DI SICUREZZA	ES	SEÑALES DE SEGURIDAD DEFINICIÓN DE SÍMBOLOS		



DE **CE-KONFORM:** Dieses Produkt entspricht den EU-Richtlinien.

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

FR **CE-Conforme:** Ce produit est conforme aux normes CE

IT **CONFORMITÀ CE:** Questo prodotto è conforme alle direttive CE

ES **CONFORMIDAD CE:** Este producto cumple con las directivas CE.

BETRIEBSANLEITUNG LESEN! Lesen Sie die Betriebs- und Wartungsanleitung Ihrer Maschine aufmerksam durch und machen Sie sich mit den Bedienelementen der Maschine gut vertraut, um die Maschine ordnungsgemäß zu bedienen und so Schäden an Mensch und Maschine vorzubeugen.

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

EN **LIRE LE MANUEL!** Lire le manuel d'utilisation et de maintenance avec soin permet de se familiariser avec les fonctions en vue d'utiliser correctement la machine afin d'éviter les blessures et le dysfonctionnement de l'appareil.

FR **LEGGERE LE ISTRUZIONI!** Leggere attentamente le istruzioni d'uso e di manutenzione della vostra macchina e familiarizzare con gli elementi di comando della macchina per utilizzarla correttamente e per evitare di danneggiare le persone e la macchina stessa.

IT **¡LEER LAS INSTRUCCIONES!** Lea atentamente las instrucciones de servicio y de mantenimiento de su máquina y familiarícese con los elementos de mando de la misma para manejarla correctamente y, de este modo, evitar que se produzcan daños personales y en la máquina.

ES **WARNUNG!** Beachten Sie die Sicherheitssymbole! Die Nichtbeachtung der Vorschriften und Hinweise zum Einsatz der Maschine kann zu schweren Personenschäden und tödliche Gefahren mit sich bringen.

DE **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.

EN **ATTENTION!** Ignorer les signes et avertissement de sécurité présent sur la machine ainsi qu'ignorer les instructions présentes dans ce manuel peut causer des blessures graves et même conduire à la mort.

FR **AVVERTENZA!** Osservare i simboli di sicurezza! La mancata osservanza delle norme e avvertenze per l'uso della macchina può comportare danni personali gravi e pericoli mortali.

IT **¡ADVERTENCIA!** ¡Observe los símbolos de seguridad! El incumplimiento de las normas e indicaciones para utilizar la máquina puede dar lugar a daños personales de carácter grave y a peligros mortales.

ES **Schutz-ausrüstung tragen!**

DE **Protective clothing!**

EN **Porter un équipement de sécurité!**

FR **Indossare i dispositivi di protezione!**

IT **¡Use el equipo de protección!**

ES **Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!**

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

EN **Débrancher la machine du secteur avant chaque entretien, activités similaires ou pause!**

FR **Spegnere la macchina prima della manutenzione e delle pause e scollegare la spina di rete!**

IT **¡Apague la máquina y desconéctela de la red eléctrica antes de llevar a cabo trabajos de mantenimiento y antes de las pausas!**

ES **Feuer, offenes Licht und Rauchen verboten!**

DE **Fire, naked flame and smoking forbidden!**

EN **Interdiction de fumer proche de la machine. De même, feu, flammes,... sont aussi interdit proche de la machine!**

FR **Sono vietati fuoco, fiamme libere e fumare!**

IT **¡Prohibido fuegos, luces desprotegidas y fumar!**

ES **Gefährliche elektrische Spannung!**

DE



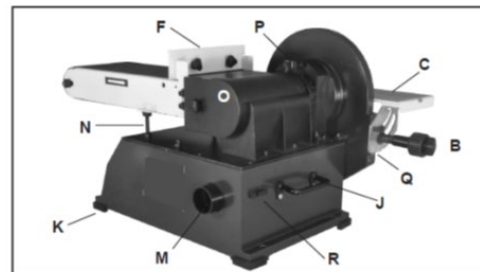
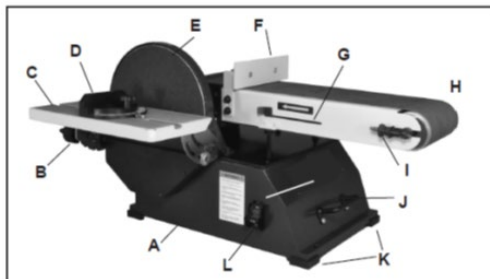


EN High voltage!
FR Haut voltage!
IT Tensione elettrica pericolosa!
ES ¡Tensiones eléctricas peligrosas!

DE Warnschilder und/oder Aufkleber an der Maschine, die unleserlich sind oder entfernt wurden, sind umgehend zu erneuern.
EN Missing or non-readable security stickers have to be replaced immediately.
FR Les panneaux d'avertissement et/ou autocollants d'avertissement illisibles ou retirés sur la machine doivent être remplacés immédiatement !
IT I segnali di avvertimento e/o le etichette applicate sulla macchina, che sono illeggibili o sono stati rimossi, devono essere sostituiti immediatamente!
ES ¡Deben sustituirse inmediatamente los letreros de advertencia y/o las pegatinas que haya en la máquina, que se hayan vuelto ilegibles o se hayan retirado!

3 **TECHNIK / TECHNICS** **CARACTERISTIQUES TECHNIQUES / TECNICHE / TECNICA**

3.1Komponenten Band / Tellerschleifer / Components disk/belt-sander **Composants / Componenti nastro / Componentes lijadora de cinta/lijadora de disco**

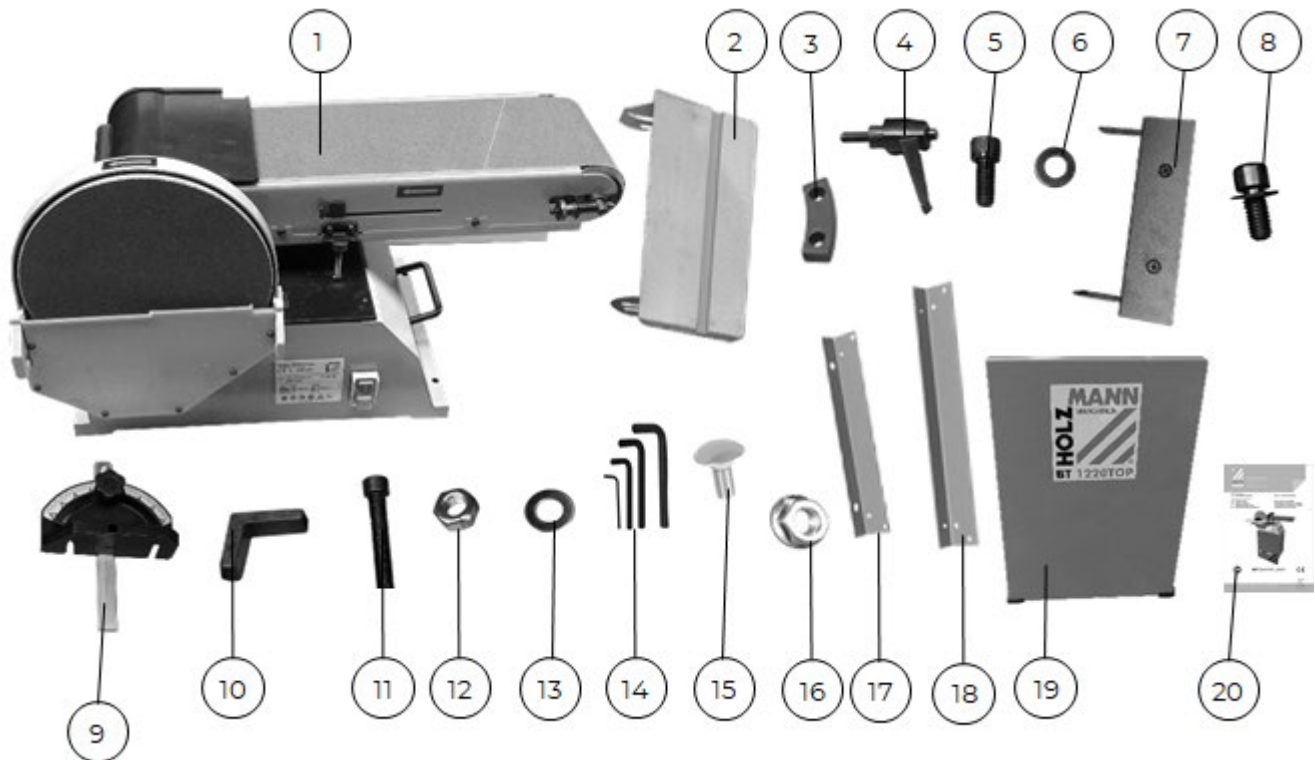


#	Beschreibung / Description	#	Beschreibung / Description
A	Maschine (Basisgestell) / Motor & Base Assembly) / Ensemble moteur et base / Macchina (telaio di base) / Máquina (bastidor)	J	Tragegriff / Carry Handle / Poignée de transport / Maniglia di trasporto / Asidero
B	Schleiftischverstellung (Teller) / Sanding table adjustment / Réglage de la table de ponçage / Regolazione del tavolo di levigatura (disco) / Ajuste de la mesa de lijado (disco)	K	Gummifüße / Rubber pads / Pieds en caoutchouc / Flangia in gomma / Pies de goma
C	Schleiftisch (Teller) / Sanding table / Table de ponçage / Piano di rettifica (levigatrice a disco) / Mesa de lijado (disco)	L	Ein/Ausschalter / ON/OFF-switch / Interrupteur Marche/Arrêt / Interruttore on/off / Interruptor On/Off
D	Gehrungsanschlag / Miter gauge / Guide d'onglet / Arresto per tagli obliqui / Tope de ingletes	M	Absauganschluss / Dust exhaust port / Buse d'aspiration / Attacco aspirazione / Conexión del sistema de aspiración
E	Tellerschleifscheibe / Disk sander / Disque de ponçage / TMola a disco / Disco para muela	N	Stütze Schleifband/ Support rod belt sander / Tige de support de ponceuse à bande / Supporto Nastro abrasivo / Soporte cinta abrasiva
F	Bandschleifanschlag / Fence / Butée / Finecorsa per la levigatura a nastro / Tope de lijado de la cinta	O	Abdeckung Bandschleifer / Belt sander cover / Couverture de ponceuse à bande / Copertura levigatrice a nastro / Cubierta lijadora de cinta
G	Schleifbandspannhebel / Tension Lever / Levier de tension de bande de ponçage / Leva di tensione del nastro abrasivo / Palanca de sujeción de la cinta abrasiva	P	Schleifbandverstellung / Frame Lock Screw / Vis de verrouillage du cadre / regolazione del nastro abrasivo / Ajuste de la cinta abrasiva
H	Schleifband / Sanding belt / Bande de ponçage / Nastro abrasivo / Cinta abrasiva	Q	Schleifteller Verstelleinrichtung / Disc table angle support & arrow indicator / Dispositif de réglage du patin de ponçage / Platorello Dispositivo di regolazione / Dispositivo de reajuste disco de lijado
I	Schleifbandeinstellschraube / Belt tracking knob / Vis de réglage de la bande de ponçage / Vite di regolazione del nastro abrasivo / Tornillo de ajuste de la cinta abrasiva	R	Werkzeughalter / Hex Wrench tool holder / Porte outil / Portautensili / Portaherramientas



3.2 Lieferumfang / Delivery content

Contenu de la livraison / Dotazione di fornitura / Volumen de suministro



	Beschreibung / Description	Qty.		Beschreibung / Description	Qty.
1	Maschine / Motor Base Assembly	1	11	Innensechskantschraube M8×55 / Hex. Socket Cap Screw M8×55	4
2	Schleiftisch mit Befestigungsmaterial (Teller) / Sanding table with mounting material	1	12	Hex. Nut M8 / Sechskantmutter M8	4
3-6	Schleiftischverstellung (Teller) / Sanding table adjustment (disc)		13	Unterlegscheibe / Flat washer 8	8
3	Führungsblock / Guide block	2	14	Werkzeug / Tools	4
4	Klemmgriff / Clamp handle	2	15	Vierkanthalsschraube M6×12 / Square Neck Bolt M6×12	16
5	Innensechskantschraube M5×15 / Hexagon Socke Cap Screws M5×15	4	16	Sechskantmutter M6 / Hex. Nut M6	16
6	Unterlegscheibe / Flat washer 8	2	17	Halterung oben / Top mount	2
7	Schleiftisch Band / Sanding table (belt)	1	18	Halterung unten / Under mount	2
8	Innensechskantschraube M8×16 mit Unterlegscheibe / Screw M8×16 with washer	4	19	Standbein / Leg	2
9	Gehrungsanschlag / Miter gauge	1	20	Betriebsanleitung / manual	1
10	Gummifüße / Rubber pads	8			



3.3 Technische Daten / Technical data Données techniques / Dati tecnici / Datos técnicos

Spezifikation / Specification	
Spannung / voltage / Voltage / Tensione di rete / Tensión de red	230 V / 50 Hz
Motorleistung / motor power / Puissance moteur / Potenza motore / Potencia del motor	750 W
Schleifbandgeschwindigkeit / Belt speed / Vitesse de la bande abrasive / Velocità del nastro abrasivo / Velocidad de la cinta abrasiva	8 m/s
Schleifbandabmessungen (L×B) / Belt size (L×W) / Dimension de la bande abrasive / Dimensioni del nastro abrasivo / Dimensiones de la cinta abrasiva	1219×150 mm
Schleiftellergeschwindigkeit / Disc speed / Vitesse du disque abrasif / Velocità platorello / Velocidad del disco de lijado	2980 min ⁻¹
Schleifteller Ø / Disc Size ø / Ø du disque abrasif / Disco abrasivo – Ø / Ø disco de lijado	254 mm
Schleiftisch (Tellerschleifer) / Table Size / Dimension table de ponçage / Piano di rettifica (molatrice a disco) / Mesa de lijado (lijadora de disco)	332×170 mm
Schleiftischneigung / table tilting range / Inclinaison de la table de ponçage / Inclinazione del tavolo di levigatura / Inclinação de la mesa de lijado	0°-45°
Schutzklasse / Protection class / Classe de protection / Classe di protezione / Clase de protección	IP 20
Absauganschluss / dust exhaust port outer / Buse d'aspiration / Attacco aspirazione / Conexión del sistema de aspiración	Ø 50 mm
Gewicht Brutto / weight gross / Poids brut / Peso lordo / Peso bruto	42,5 kg
Gewicht netto / weight net / Poids net / Peso netto / Peso neto	39,5 kg
Verpackungsmaße (L×B×H) / packaging dimensions (L×W×H) / Dimensiones del embalaje (L×A×H) / Dimensions d'emballage (L×l×H) / Dimensioni (L×P×A)	750×490×460 mm
Schallleistungspegel L _{WA} / Sound power level L _{WA} / Puissance acoustique L _{WA} / Livello di potenza sonora L _{WA} / Nivel de potencia acústica L _{WA}	93,3 dB(A)/K: 3 dB(A)
Schalldruckpegel L _{PA} / Sound pressure Level L _{PA} / Pression sonore L _{PA} / Livello di pressione sonora L _{PA} / Nivel de presión sonora L _{PA}	80,3 dB(A)/K: 3 dB(A)

(DE) Hinweis Geräuschangaben: Die angegebenen Werte sind Emissionswerte und müssen damit nicht zugleich auch sichere Arbeitsplatzwerte darstellen. Obwohl es eine Korrelation zwischen Emissions- und Immissionspegeln gibt, kann daraus nicht zuverlässig abgeleitet werden, ob zusätzliche Vorsichtsmaßnahmen notwendig sind oder nicht. Faktoren, welche den am Arbeitsplatz tatsächlich vorhandenen Immissionspegel beeinflussen, beinhalten die Eigenart des Arbeitsraumes und andere Geräuschquellen, d. h. die Zahl der Maschinen und anderer benachbarter Arbeitsvorgänge. Die zulässigen Arbeitsplatzwerte können ebenso von Land zu Land variieren. Diese Information soll jedoch den Anwender befähigen, eine bessere Abschätzung von Gefährdung und Risiko vorzunehmen.

(EN) Notice noise emission: The values given are emission values and therefore do not have to represent safe workplace values at the same time. Although there is a correlation between emission and immission levels, it cannot be reliably deduced whether additional precautions are necessary or not. Factors influencing the actual immission level at the workplace include the nature of the workspace and other noise sources, i.e. the number of machines and other adjacent operations. The permissible workplace values may also vary from country to country. However, this information should enable the user to make a better assessment of hazard and risk.

(FR) Avis Données sur le bruit : Les valeurs indiquées sont des valeurs d'émission et ne représentent donc pas nécessairement des valeurs de sécurité sur le lieu de travail. Bien qu'il existe une corrélation entre les niveaux d'émission et d'immission, il est impossible de déduire de manière fiable si des mesures de précaution supplémentaires sont nécessaires ou non. Les facteurs influençant le niveau d'immission réellement présent sur le lieu de travail comprennent les caractéristiques de la salle de travail et d'autres sources de bruit, c'est-à-dire le nombre de machines et d'autres processus de travail adjacents. Les valeurs autorisées sur le lieu de travail peuvent également varier d'un pays à l'autre. Toutefois, ces informations devraient permettre à l'utilisateur de mieux évaluer le danger et le risque.

(IT) Nota Dati sulla rumorosità: I valori indicati sono valori di emissione e quindi non devono rappresentare contemporaneamente valori di sicurezza sul posto di lavoro. Sebbene esista una correlazione tra i livelli delle emissioni e immissioni, non si può dedurre in modo affidabile se siano o meno necessarie ulteriori precauzioni. I fattori che influenzano il livello di emissioni effettivamente presente sul luogo di lavoro includono le condizioni tipiche dell'area di lavoro e altre fonti di rumore, come per es. il numero di macchine e la presenza di altri processi di lavoro adiacenti. I valori consentiti sul posto di lavoro possono anche variare da paese a paese. Tuttavia, queste informazioni permettono all'utente di stimare nel modo migliore pericoli e rischi.

(ES) Aviso sobre los valores de ruido: Los valores indicados son valores de emisión y, por lo tanto, no representan necesariamente al mismo tiempo valores seguros en el lugar de trabajo. Aunque hay una correlación entre los niveles de emisión y los de inmisión, no se puede deducir con certeza si es necesario adoptar medidas de precaución adicionales o no. Entre los factores que influyen en el nivel de inmisión real en el lugar de trabajo, se encuentran la naturaleza del espacio de trabajo y otras fuentes de ruido, es decir, el número de máquinas y otros procesos de trabajo adyacentes. Asimismo, los valores admisibles en el lugar de trabajo pueden variar de un país a otro. No obstante, esta información debe capacitar al usuario a evaluar mejor los peligros y los riesgos.



10 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the belt and disc sander BT 1220TOP_230V, hereinafter referred to as “machine” in this document.



This manual is part of the machine and must not be removed. Save it for later reference and if you let other people use the machine, add this manual to the machine.

Please pay special attention to the chapter safety!

Before first use read this manual carefully. It eases the correct use of the machine and prevents misunderstanding and damages of machine.

Due to constant advancements in product design, construction, illustrations and contents may deviate slightly. If you notice any errors, please inform us.

We reserve the right to make technical changes!

Check the goods immediately after receipt and note any complaints on the consignment note when taking over the goods from the deliverer!

Transport damage must be reported to us separately to us within 24 hours.

HOLZMANN MASCHINEN GmbH cannot accept any liability for transport damage that has not been reported.

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The place of jurisdiction is the regional court Linz or the court responsible for 4170 Haslach is valid.

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11 SAFETY

11.1 Intended use of the machine

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.

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

Even when the machine is used as prescribed it is still impossible to eliminate certain residual risk factors.

The machine is designed exclusively for the following activities:

Sanding wood or wood-like materials.

NOTE



HOLZMANN MASCHINEN GmbH assumes no responsibility or warranty for any other use or use beyond this and for any resulting damage to property or injury.

WARNING



- Use only abrasive allowable for this machine!
 - Never use a damaged abrasive!
 - Use the machine never with defective or without mounted guard!
- HIGHEST RISK OF INJURY!**

11.1.1 Technical restrictions

The machine is designed for the work under the following conditions:

Relative humidity	max. 70 %
Temperature (operation)	+5 °C to +40 °C (+41°F to +104°F)

The machine shall not be operated in areas exposed to increased fire or explosion hazard.

11.1.2 Prohibited applications / Dangerous misuse

- The operation of the machine outside the stated technical limits described in this manual is forbidden.
- Operation of the machine function without emergency device is prohibited.
- The use of the machine not according with the required dimensions is forbidden.
- The use of the machine not being suitable for the use of the machine and not being certified is forbidden.
- Any manipulation of the machine and parts is forbidden.
- The use of the machine for any purposes other than described in this 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.

The non-intended use or the disregard of the explanations and instructions described in this manual will result in the expiration of all warranty claims and compensation claims for damages against HOLZMANN MASCHINEN GmbH.

11.2 Safety instructions

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

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



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

- 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.
- Do not overload the machine.
- Provide good stability and keep balance all times.
- Avoid abnormal working postures! Make sure you stand squarely and keep balance at all times.
- Keep away from the running abrasive!
- Always stay focused when working. Reduce distraction 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.
- Respectively trained people only and only one person shall operate the machine.
- Do not allow other people, particularly children, to touch the machine or the cable. Keep them away from your work area.
- Make your workshop childproof.
- Make sure there is nobody present in the dangerous area. The minimum safety distance is 2 m.
- 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: dust mask, ear protectors and safety goggles when working with 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.
- When working with the machine outdoors, use extension cables suitable for outdoor use.
- 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.
- Before starting the machine remove any adjusting wrenches and screwdrivers.
- Hold the workpiece good with both hands.
- Rotating parts can cause severe cut injuries.
- Keep any machine that is not being used out of reach of children.

11.3 Remaining risk factors

WARNING



It is important to ensure that each machine has remaining risks. In the execution of all work (even the simplest) greatest attention is required. A safe working depends on you!

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: Despite of correct and proper use and maintenance there remain some residual risk factors:



- **Hazard of injury or machine damage due to undetected machine defect**

To minimize this risk, check the machine prior to every operation for loose screws and connections. Damaged parts have to be replaced immediately, no operation of the machine in the meantime!

- **Hazard of electric shock**

Undetected malfunctions in the power supply and/or the connected wood working machine might result in electric shock when touching the machine. Ensure proper electric installation, and let it check periodically by a trained electrician.

- **Danger due to unintended machine start-up**

Eliminate this risk by disconnecting the machine before you perform any checks or activities on the machine.

- **Hazard of inhaling toxic dust**

Especially wood dust arising from chemically treated wood and/or lacquer/paint are harmful when inhaled. Therefore wear a suitable breathing mask if required.

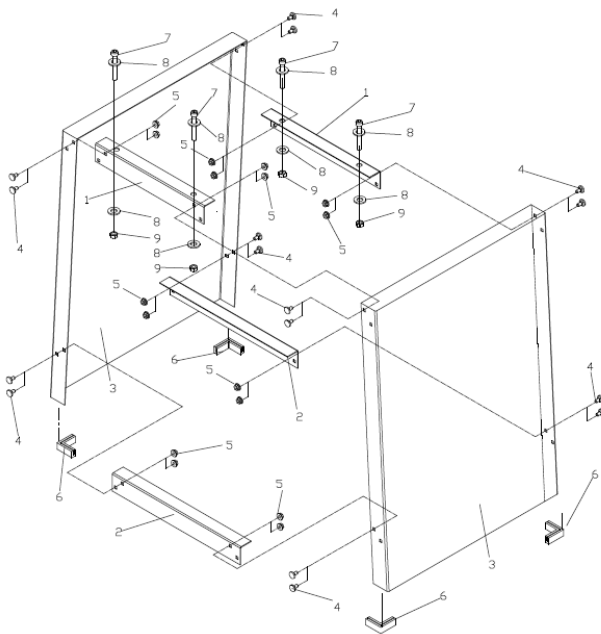
These risk factors can be minimized through obeying all security and operation instructions, proper machine maintenance, proficient and appropriate operation by persons with technical knowledge and experience.

12 ASSEMBLY

After receiving the delivery, check that all parts are in order. Report any damage or missing parts to your dealer or the shipping company immediately. Visible transport damage must also be noted immediately on the delivery bill in accordance with the warranty provisions, otherwise the goods are deemed to have been duly accepted.

12.1 Stand

Connect the individual parts of the frame with the screws provided see exploded drawing.



Stand Parts list(BT1220TOP)			
No	Name	Spec	Qty
1	Halterung oben/ Top mount	303mm	2
2	Halterung unten/ Under mount	357mm	2
3	Standbeine / Leg		2
4	Schrauben / Small half-round head low square neck bolt	M6X12	16
5	Mutter / Hexagon flange nut	M6	16
6	Füße / Foot		4
7	Hexagon socket head cap screw	M8X55	4
8	Scheiben / Washer 8	8	8
9	Hexagon nut	M8	4



12.2 Machine to stand

The machine is supplied with 4 rubber feet, which can be mounted to protect the working surface.

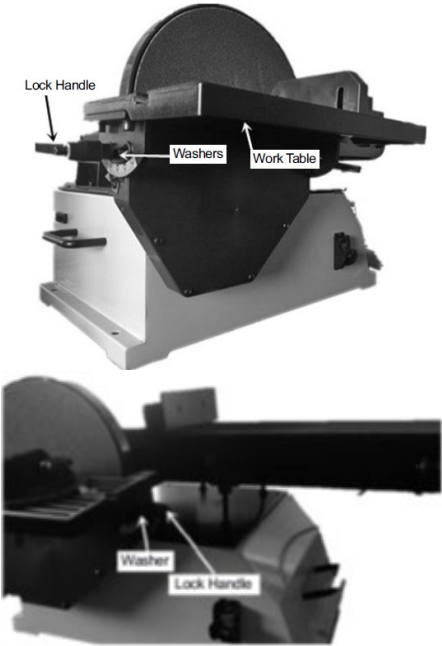


- Tilt the sander up and slide the feet onto each of the four corners of the sander.
- Then fix the machine with the 4 screws (7) and washers (8) on both sides and nut (9) on the assembled stand.

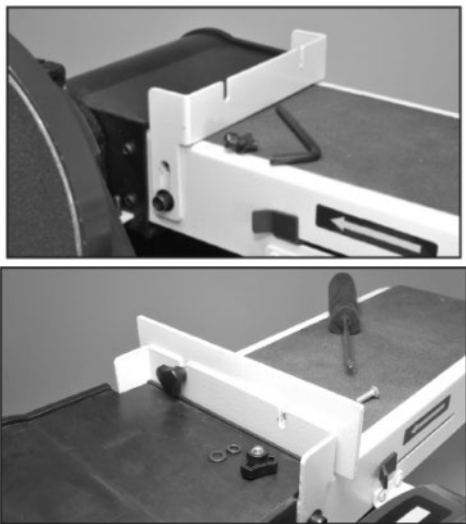


12.3 Sanding table / fence

12.3.1 Assembly on Disc-Sander

	The metal Sanding Disc is pre-installed on the machine and also the sanding Abrasive Disc (Grain 80).
	- The larger worktable is used with the sanding disc. It should be used to support workpieces in all sanding operations except inside curve applications. - Place the worktable onto the sander frame, aligning the semi-circle slot with the threaded hole. Place a washer on threaded shaft of each worktable handle, insert through semi-circular slot, and tighten into threaded hole. Repeat on other side of table.

12.3.2 Assembly on belt-Sander

	The sander includes 2 fences for use with the sanding belt. The small Fence/Platen (Part #56) attaches directly to the sanding Belt Frame (#52), and is used for supporting small items being sanded. The larger Fence/Platen (#55) attaches onto the small fence. It gives a larger support surface for sanding large work pieces. NOTE: These parts may be pre-assembled at the time of delivery. If not, follow the following parts assembly: - Install the small Fence onto the sanding Belt Frame with the 4 Hex Screws and washers (#27, 58). - Insert two star-head Screws (#54) through the countersunk holes in the large Fence and install the Knobs (#57) on their threaded ends. - Slide the large fence's 2 screws with knobs over the two slots in the small fence and fasten in place. Pending on the material being sanded, the large fence can easily be removed by just loosening the two knobs and sliding it off the small fence. CAUTION: To prevent fingers from being squeezed between the band and fence a minimum separation of 1.6 mm has to be maintained between the fence and Sanding band.
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12.4 Installing dust collection

The sander has one dust ports. Slide the hose of your dust collector over the outlet, and secure with a hose clamp (not in the delivery content). Outer Diameter of port is $\varnothing$ 50 mm.

13 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.

13.1 Operating instructions

Perform all machine settings with the machine being disconnected from the power supply! Please observe the following operating instructions so that their work can be performed safely and has the expected success.

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

Check before starting work:

- All cables and plugs
- Table and safety fence on tight fit
- The free and centered run of sanding belt and disc

The sanding:

- Always use the proper, located in perfect condition abrasives. (Change wear of abrasives immediately!) With abrasive in good condition you obtain a good grinding result.
- Do not exert too much pressure to the sanding abrasive.
- Maximum distance table - sanding disc: 4 mm
- Maximum distance between sanding belt - fence: 1.6 mm
- The machine has no clamp opportunity, so it is important, as the whole area hang up the work piece on the worktable and maintain a firm grip!

13.2 Adjustments

13.2.1 Sanding belt

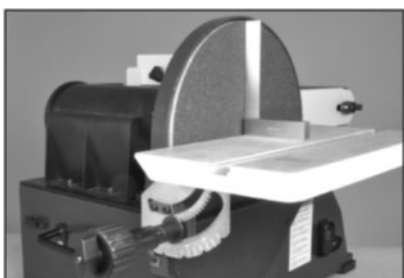


Belt tracking on the center of the drive wheels is pre-set at the factory. If an adjustment need to be made, the sander must be turned on.

- If the sanding belt moves toward the disc, slowly turn the Tracking Knob (#66) clockwise 1/4 turn.
- If the sanding belt moves away from the disc, turn the tracking knob slowly counterclockwise 1/4 turn.

Slowly turn the belt tracking knob noting the belt movement. Re-adjust the tracking knob, as necessary, until the belt runs true in the center of the drums.

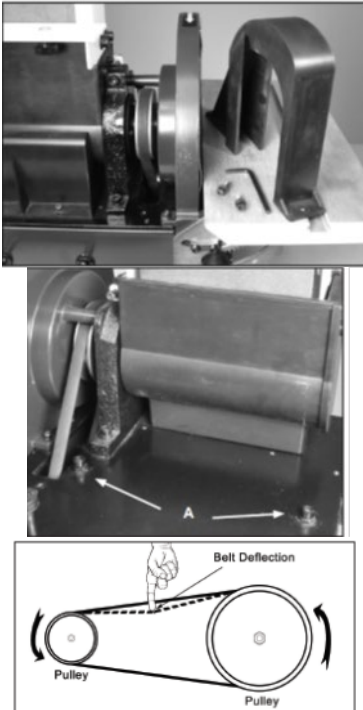
13.2.2 Sanding table



- To check the trueness of the 90° angle of the disc sanding table, place a square or other measuring device on the table with the other end against the sanding disc.
- Loosen the disc table adjustment handle (#111), and adjust table angle to 90°.
- Re-tighten the disc table adjustment handle.
- Adjust the Angle Scale Pointer (#103) to 0°.
- Set the table at the desired angle using the angle scale pointer.
- Re-tighten the disc table adjustment handle.

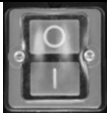


13.2.3 V-Belt

	Should the rotation of the sanding belt or disc slow down or stall, the cause may be that the V-belt is slipping on the two pulleys. This may be because the motor or frame have become loose from the base, or that the V-belt has stretched out due to the machine being used. In either case, re-adjustment of the V-belt is needed. 1. To gain access to the V-Belt (Part #8), the Belt Cover (#39) must be removed, by unscrewing the two hex head Screws (#112). 2. On the cabinet top, under the sanding belt frame, there are two hex head Bolts and Nuts (#18, 19) that extend up from the cabinet surface. These connect to the motor frame and will adjust the tension of the V-Belt by pivoting the motor. 3. Loosen the locking nuts and then rotate the bolts so that the motor frame is moved to put more, or less, tension on the V-Belt. 4. Tension, or the deflection of the V-belt should be about 6 mm to 9 mm when moderate pressure is applied onto the belt with your finger. 5. Once the proper belt tension is achieved, tighten the hex head bolts to secure the motor frame in its new position. 6. Re-install the safety belt cover over the V-belt, that was removed in step 1 above.
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13.3 Operation

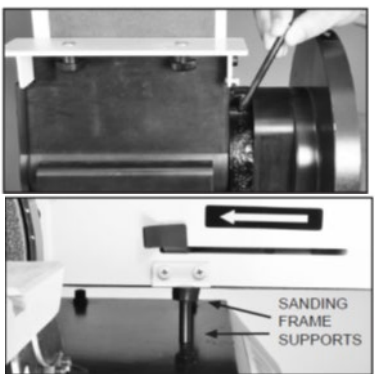
13.3.1 ON/OFF

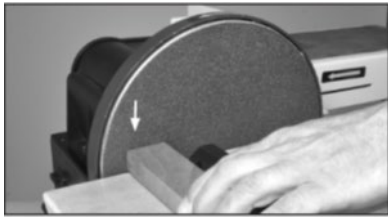
	To turn the machine on, press "I" (green). To turn the machine off, press "O" (red).
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13.3.2 Miter Gauge

 FIG. 32	The Miter Gauge (#110) can be used on the disc table, which has a slot to fit the miter gauge's bar. The miter gauge head can be set anywhere up to 45° (right or left) by loosening the lock-knob, setting the miter gauge head to the desired angle, and retightening the lock-knob.
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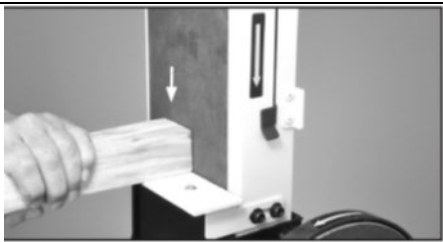
13.3.3 Horizontally / vertically operation of belt sander

	The sanding frame can be easily adjusted from a horizontal position to a vertical position, or any other position to assist your sanding operation. • Loosen the Hex Screw (#49) that pulls the split casting together. This allow the sanding belt frame to be moved to the work angle desired. • Once the sanding belt frame is at the desired work angle, re-tighten the hex screw to secure it in place. • In the horizontal position, there are two vertical padded Hex Screws (#32) that support the sanding belt frame. These should be checked and adjusted, if necessary, to make sure that they both touch the sanding frame Supports (#51). These screws will help relieve pressure on the casting during work.
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**13.3.4 Disc-Sanding**

- When sanding, always position your work on the downward, rotating side (left side) of the sanding disc. The sanding action will then force the wood down, safely towards the table, where it can be controlled.

Sanding on the right, upward rotating side of the disc is dangerous, as your work cannot be controlled and 'kick-back' may occur - the wood being forced up and out of your hands.

13.3.5 Belt-Sanding

1. Hold the work piece firmly, keeping fingers away from the sanding belt.
2. Keep the work piece against the backstop and move it evenly across the sanding belt. Use extra caution when sanding very thin pieces. FIG. 33 & 34.
3. For sanding long pieces, remove the fence.
4. Do not force the work piece into the sanding belt. Sand using light pressure, letting the sanding abrasives time to do their work!
5. Move your work piece slightly left and right on the belt. This will help prevent resin or debris from building up on one area of the belt, and also helps to prevent burning of the sanded surface from excessive abrasive-action heat build-up.

SANDING CURVED EDGES

Sanding inside curves on your work piece and be done on the idler drum as shown.

14 CLEANING, MAINTENANCE, STORAGE, DISPOSAL**WARNING**

Handling the machine with connected power supply may result in serious injury or death.

- Always disconnect the machine from the power supply before cleaning, maintenance or repair work and secure it against unintentional reconnection.

14.1 Cleaning

Regular cleaning guarantees the long service life of your machine and is a prerequisite for its safe operation.

NOTE

Incorrect cleaning products can attack the finish of the machine. Do not use any solvents, nitro thinners or other cleaning products that could damage the machine's finish.

Observe the specifications and instructions of the cleaning agent manufacturer.

- The machine and all its parts must be thoroughly cleaned after each use.
- Remove swarf and grinding dust from the machine regularly after work.



- Impregnate the machine's bare surfaces against corrosion using commercially available agents.

14.2 Maintenance

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

- Before first operation as well as later on every 100 operation hours you should lubricate all connecting parts (if required, remove beforehand with a brush all swarfs and dust).
- Check regularly the condition of the security stickers. Replace them if required.
- Check regularly the condition of the saw band and the saw band guide.

14.2.1 Maintenance plan

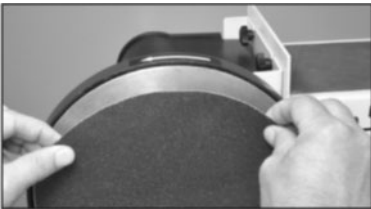
After each workshift: Remove chips and sanding dust from the device

After 10 hours of operation: Check all screw connections and tighten if necessary.

14.2.2 Changing Sanding Belt

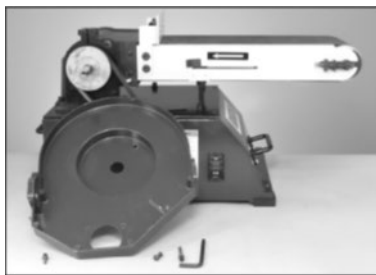
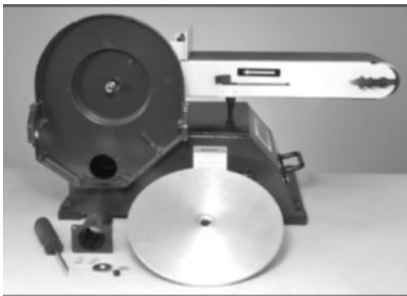
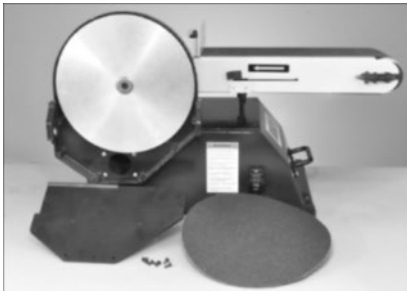
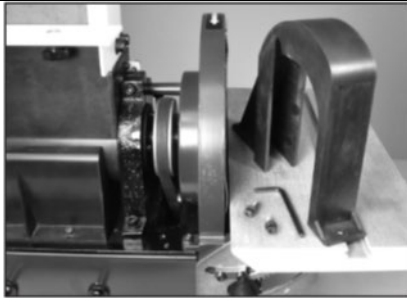
	1. Remove the plastic Side Cover (#60) from the frame by unscrewing the knob (#78). 2. Remove the Small Fence (#56). 3. Slide Tension Lever (#71) to the right to release the belt tension. NOTE: Above the Tension Lever, there is a direction arrow. The sanding belt must run in the direction of this arrow so that the splice does not come apart. 4. Remove the old belt by sliding it off to the left of the frame. Place the new sanding belt over the drums with the direction arrow pointing in the proper direction. Make sure the belt is centered on both drums. 5. Slide the tension lever to the left to apply tension to the belt. 6. Re-install the small fence and side cover onto the frame (removed in Step 1 & 2). Plug in the power cord. Turn the switch "ON" and note if the belt tends to move to the right or left on the drums. The belt should be running on the center of the drive drums. If it is not, the belt tracking needs adjustment.
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14.2.3 Changing Sanding Disc

	The sandpaper disc can be removed with the table installed, or with the table removed to give more working access to the disc, if needed. 1. Peel the used abrasive disc from the metal sanding disc plate. A putty knife may help in this process. 2. Make sure that the disc plate is clean of any residue. Mineral spirits will soften the PSA adhesives for its removal. Rotate the disc by hand may be necessary to get access to all of the disc surface. 3. Glue a new sanding disc onto the metal disc plate then center and press the sanding disc firmly onto the disc plate. 4. Replace the sanding table if it was removed.
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14.2.4 Changing V-Belt



Replacing the V-Belt requires that the Belt Cover, bottom Base Cover, and whole Sanding Disc Assembly be removed in order to gain access to the drive shafts and pulleys.

1. Remove the Belt Cover (Part #39) by unscrewing the two hex head Screws (#112).
2. Remove the complete Sanding Disc Table Assembly from the Disc Frame.

NOTE: Reverse the assembly steps for installing the Sanding Disc Table.

3. Remove the lower Disc Guard (#95) by unscrewing the six Phillips head Screws (#33), and also the Sandpaper from the metal Sanding Disc.
4. Remove the metal Sanding Disc (#100). Turn the center Screw (#98) counterclockwise to remove it. Pull the large Washer (#99) from the disc center and then pull the disc off from the Drive Shaft (#24). Note that the disc is positioned on the shaft with a small Key (#11).
5. Remove the Dust Connection Pipe (#102) from the lower section of the Disc Frame with the four Phillips head Screws (#33).
6. Unscrew the Disc Frame from the sander's cabinet. Remove three screws - two on top of the frame (#38) and one longer screw from the interior of the frame (#91).
7. On the cabinet top, under the sanding belt frame, there are two hex head Bolts and Nuts (#18, 19) that extend up from the cabinet surface. These connect to the motor frame and will adjust the tension of the V-Belt by pivoting the motor. Loosen the locking nuts and then rotate the bolts so that the motor frame is moved to release tension on the V-Belt. To gain access to the lower drive Pulley and V-Belt, the bottom Base Cover (#3) must be removed.
8. Carefully tip the sander to one side to avoid any damage to the machine. Unscrew the four retaining Screws (#1) and remove the base cover.
9. Remove the old V-Belt from the two drive pulleys, and install a new V-Belt. Make sure that there is some tension on the belt, so that it does not slip off as the sander parts are re-assembled.

NOTE: Both pulleys are pre-set at the factory and should be in-line with each other. If not, re-adjust one of the pulleys on their drive shaft. Loosen the hex set screw that holds the pulley to its shaft, move the pulley so that it is aligned with the other pulley, then re-tighten the set screw to lock it in position.

10. While the sander is still apart, set the belt tension. The sander will have to be tipped back up to its normal position for this step.
11. Once the tension on the V-belt is set, re-assemble the sander parts by reversing steps 8 to 1 above

14.3 Storage

Store the machine in a dry, frost-proof and lockable place when not in use. Disconnect the machine from the power supply. Make sure that unauthorised persons and especially children do not have access to the machine.

- Tension the sanding belt of the belt sander.

**NOTE**

Improper storage can damage and destroy important components. Only store packed or already unpacked parts under the intended ambient conditions!

14.4 Disposal

Observe the national waste disposal regulations. Never dispose of the machine, machine components or operating equipment in the residual waste. If necessary, contact your local authorities for information regarding available disposal options.

If you purchase a new machine or equivalent equipment from your specialist dealer, he is obliged in certain countries to dispose of your old machine properly.

15 TROUBLESHOOTING**WARNING****Danger due to electrical voltage!**

Handling the machine with connected power supply may result in serious injury or death.

→ Disconnect the machine from the power supply before starting work to eliminate defects!

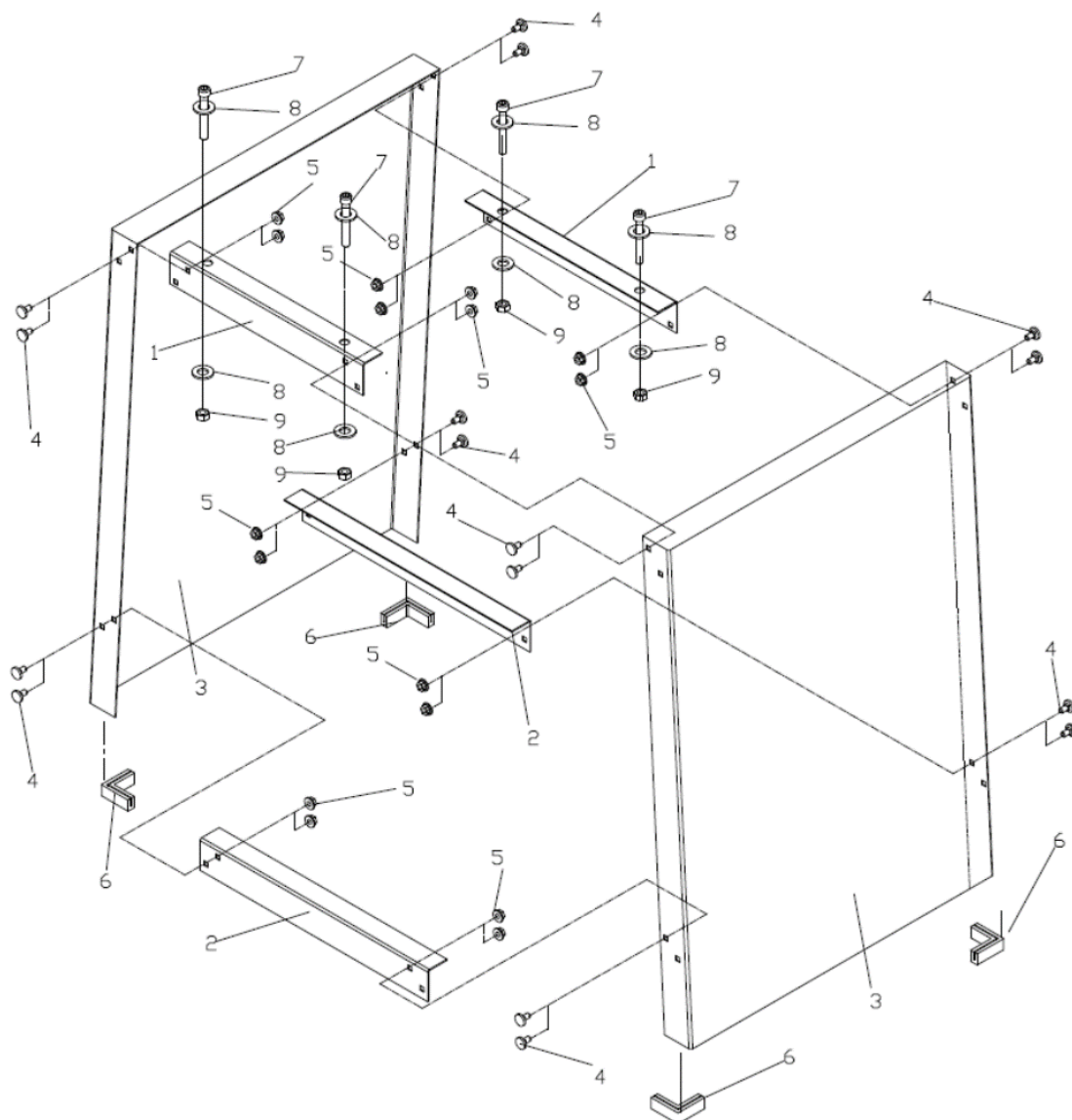
Many possible sources of error can be eliminated in advance if the machine is properly connected to the power supply.

If you are unable to carry out the necessary repairs properly and/or do not have the required training, always consult a specialist to solve the problem.

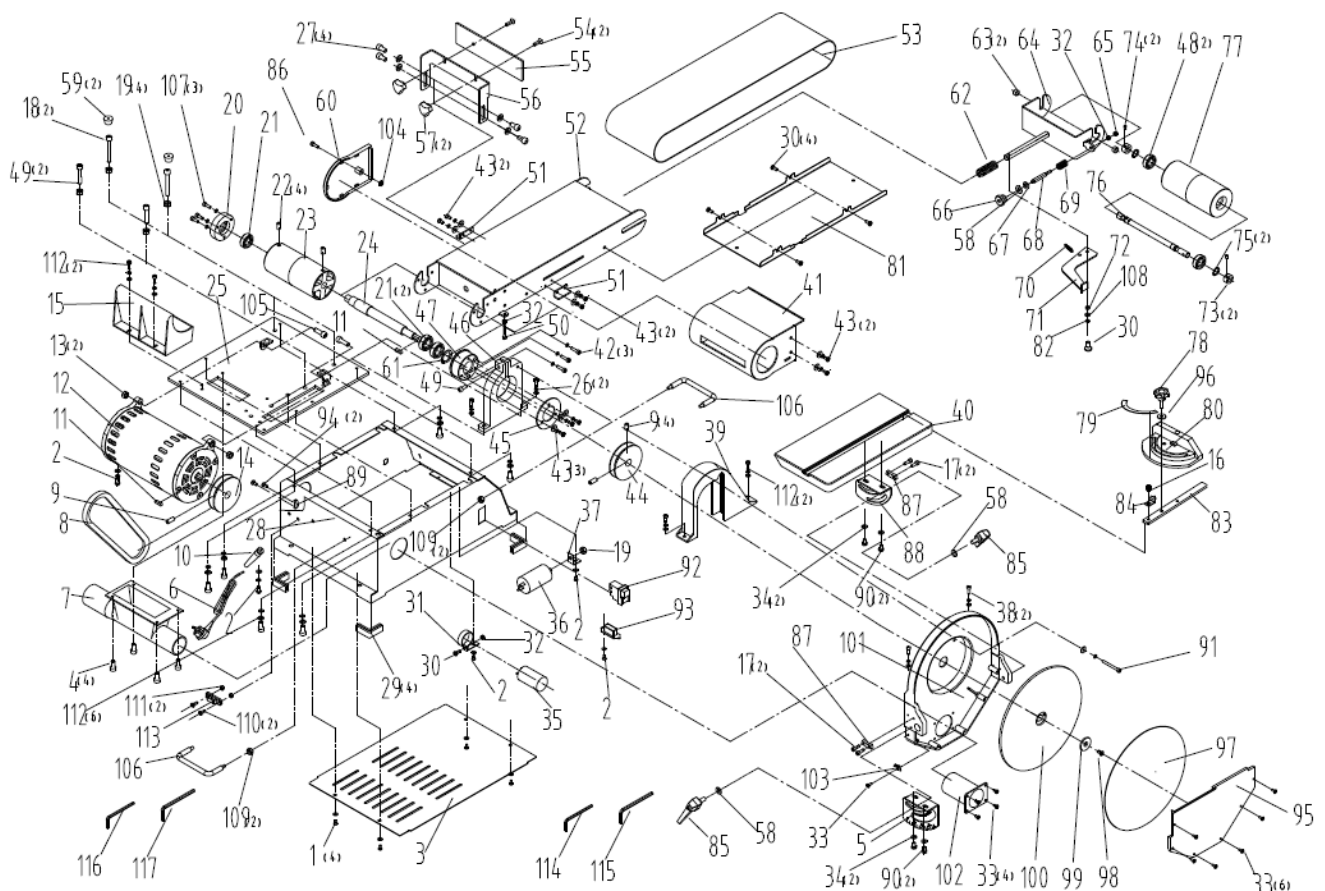
Trouble	Possible cause	Solution
Machine stops or will not start	- ON/OFF-switch damaged - Saw unplugged - Overload tripped - Fuse blown or circuit breaker tripped - Cord damaged	- Check the switch - Check all power connections - Allow motor to cool and reset by pushing off switch - Change fuse or reset circuit breaker - Change cable
Machine slows down during working	Exerting too much pressure to the sanding abrasive	Exert less pressure on the work piece
Bad grinding results	Abrasive too coarse-grained	Use less coarsed abrasive
To rapid wear of	Abrasive too fine-grained	Use more coarsed abrasive
Grinding angle is wrong	Adjusted angle is wrong	Readjust the angle
Sanding disc runs out of round	Sanding disc is eccentrically mounted	Mount the sanding disc centrally
Sanding belt runs out of sanding belt bed	Sanding belt is mounted wrong	Mount the sanding belt centrally
Work piece burns during the working process	- Abrasive is dirty from oil - Too much pressure	- Change abrasive - Reduce pressure



35.2 Explosionszeichnung / Exploded view



No.	Description	Qty.	No.	Description	Qty.
1	Halterung oben / Top mount 303 mm	2	6	Füße / Foot	4
2	Halterung unten / Under mount 357 mm	2	7	Hexagon socket head cap screw M8×55	4
3	Standbeine / Leg	2	8	Scheiben / Washer 8	8
4	Schrauben / Small half-round head low square neck bolt M6×12	16	9	Hexagon nut	4
5	Mutter / Hexagon flange nut M6	16			



No	Description	Qty.	No	Description	Qty.
1	Philips screw and flat washer assy (Galvanized) M4x6	4	60	Suction inlet cover	1
2	Philips screw,spring washer and flat washer assy (Galvanized) M4x8	5	61	Axial spring retainer D14	1
3	Baseplate	1	62	Strain spring	1
4	Philips screw M5x8	4	63	Sheath	2
5	Left dial	1	64	Guide frame assy	1
6	Cordline and Plug	1	65	Non-metallic insert nuts M5	1
7	Suction connection	1	66	Knurled high nuts M8	1
8	Vee belt A600	1	67	Rubber pad	1
9	Screw M6x8	5	68	Adjusting screw rod	1
10	Cable sheath	1	69	Adjusting spring	1
11	Flat key A5x15	2	70	Tension spring	1
12	Motor assy	1	71	Sanding belt strain lever	1
13	Non-metallic insert nuts M8	2	72	Powder metallurgy sheath	1
14	Driving wheel	1	73	Driven shaft positioning sleeve	2
15	Suction Hood	1	74	Screw M5x6	2
16	Philips screw,spring washer and flat washer assy (Galvanized) M5x8	1	75	Circlip for shaft D12	2
17	Hexagon socket head cap screw M5x16	4	76	Driven shaft	1
18	Hexagon socket head cap screw M8x55	2	77	Driven roller	1
19	Type I hexagon nut M8	5	78	Miter gauge knob	1
20	Bearing cap 6201	1	79	Miter gauge scale mark	1
21	Deep groove ball bearing	3	80	Miter gauge	1
22	Screw M8X12	4	81	Sanding belt guard plate	1
23	Driving roller	1	82	External gear lock washer Washer 5	1
24	Driving shaft	1	83	Mitre Joint pole	1
25	Support baseplate assay	1	84	Miter gauge pointer	1



26	Hexagon socket head cap screw, spring washer and flat washer assy M8x30	2	85	Lock knob assy M8x17	2
27	Hexagon socket head cap screw and flat washer assy M8x16	4	86	Hexagon socket head cap screw M6x28	1
28	Base assy	1	87	Guide block	2
29	Foot	4	88	Right dial	1
30	Philips screw M5x12	6	89	Strain relief plate	1
31	Capacitor bracket	1	90	Hexagon bolt (Galvanized) M6x8	4
32	Type I hexagon nut M5	3	91	Hexagon socket head cap screw, spring washer and flat washer assy M5x56	1
33	Philips screw M4x10	11	92	Magnetic switch	1
34	Flat washer (Galvanized) Washer 6	4	93	Electronic centrifugal switch	1
35	Capacitor	1	94	Philips screw (Galvanized) M4x12	2
36	Capacitor	1	95	Sanding disc cover	1
37	Capacitor bracket	1	96	Big flat washer Washer 6	1
38	Hexagon socket head cap screw, spring washer and flat washer assy M5x18	2	97	Sanding disc paper	1
39	Belt cover	1	98	Cross recessed countersunk head screw M6x20	1
40	Work table of disc	1	99	Sanding disc pad	1
41	Suction inlet	1	100	Sanding disc	1
42	Philips screw and spring washer assy (Galvanized) M5x25	3	101	Sanding disc cover	1
43	Hexagon socket head cap screw, spring washer and flat washer assy M5x12	9	102	Connecting pipe	1
44	Driven wheel	1	103	Pointer	1
45	Platen	1	104	Non-metallic insert nuts M6	1
46	Bracket pedestal	1	105	Philips screw (Galvanized) M8x25	2
47	Bearing pedestal	1	106	Handle	2
48	Deep groove ball bearing 6202	2	107	Philips screw and spring washer assy (Galvanized) M5x16	3
49	Hexagon socket head cap screw M8x30	3	108	Big flat washer 5	1
50	Hexagon socket head cap screw M5x30	1	109	Hexagon flange nuts M6	4
51	Support plate	2	110	Cross recessed countersunk head screw M5x10	2
52	Bracket assy	1	111	Hexagon flange nuts M5	2
53	Sanding belt	1	112	Hexagon socket head cap screw, spring washer and flat washer assy M5x10	10
54	Cross recessed countersunk head screw M6x14	2	113	Miter gauge clip	1
55	Auxiliary baffle	1	114	Allen wrench (S=6)	1
56	Baffle	1	115	Allen wrench (S=4*120)	1
57	Lock nut	2	116	Allen wrench (S=3*60)	1
58	Flat washer 8	3	117	Allen wrench (S=5*80)	1
59	Rubber foot (8WDD.100.002)	2			