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Originalfassung

**DE BETRIEBSANLEITUNG**

Übersetzung / Translation

**EN USER MANUAL**

**FR MANUEL D'UTILISATION**

**DRECHSELBANK**

**WOOD TURNING LATHE**

**TOUR À BOIS**
















**D510F\_230V**

**CE**  
**YOUR**  
**JOB.**  
**OUR**  
**TOOLS.**



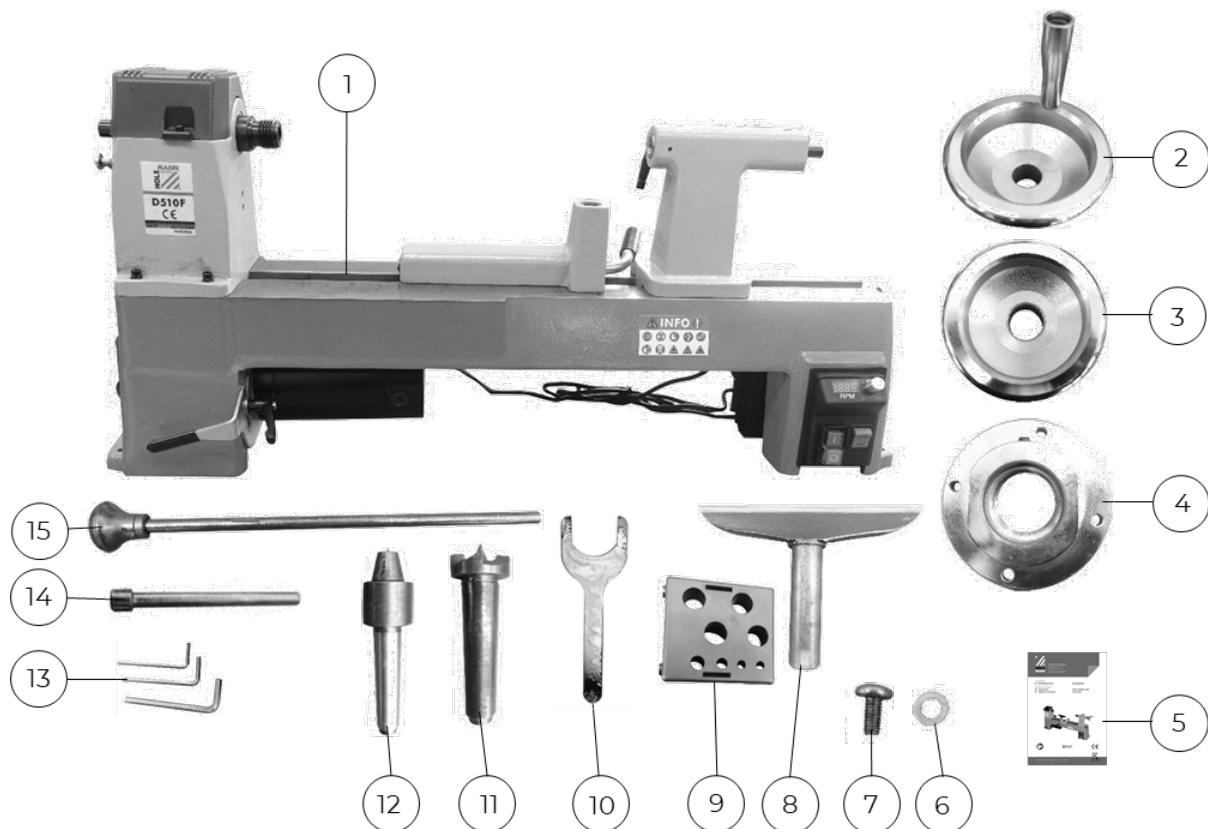
## 2 SICHERHEITSZEICHEN / SAFETY SIGNS / SYMBOLES DE SÉCURITÉ

DE	SICHERHEITSZEICHEN BEDEUTUNG DER SYMBOLE	EN	SAFETY SIGNS DEFINITION OF SYMBOLS	FR	SIGNALISATION DE SÉCURITÉ DÉFINITION DES SYMBOLES
		DE	<b>CE-KONFORM:</b> Dieses Produkt entspricht den EU-Richtlinien.		
		EN	<b>EC-CONFORM:</b> This product complies with the EC-directives.		
		FR	<b>Conforme CE:</b> Ce produit est conforme aux Directives CE.		
		DE	<b>BETRIEBSANLEITUNG LESEN!</b> 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.		
		EN	<b>READ THE MANUAL!</b> 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.		
		FR	<b>LIRE LE MANUEL!</b> 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.		
		DE	<b>WARNUNG!</b> Beachten Sie die Sicherheitssymbole! Die Nichtbeachtung der Vorschriften und Hinweise zum Einsatz der Maschine kann zu schweren Personenschäden und tödliche Gefahren mit sich bringen.		
		EN	<b>ATTENTION!</b> 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.		
		FR	<b>ATTENTION!</b> Ignorer les signes et avertissement de sécurité présent sur la machine ainsi que ignorer les instructions présentes dans ce manuel peut causer des blessures graves et même conduire à la mort.		
	   	DE	Persönliche Schutzausrüstung tragen!		
		EN	Wear protective equipment!		
		FR	Porter un équipement de protection individuelle!		
	 	DE	Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!		
		EN	Stop and pull out the power plug before any break and engine maintenance!		
		FR	Éteignez et débranchez la machine avant l'entretien ou de pause!		
		DE	Warnung vor wegschleudernden Teile!		
		EN	Warning against thrown-off items!		
		FR	Pièces solides peuvent être catapultées!		
		DE	Warnung vor Hand- und Schnittverletzungen!		
		EN	Warning of hand and cut injuries!		
		FR	Risque de coupures!		
		DE	Warnung vor gefährlicher elektrischer Spannung!		
		EN	Beware of dangerous electrical voltage!		
		FR	Risque de choc électrique!		
		DE	Bedienen mit Handschuhen verboten!		
		EN	Operation with gloves forbidden!		
		FR	Utilisation avec port de gants interdit!		
DE	<b>Warnschilder und/oder Aufkleber an der Maschine, die unleserlich sind oder entfernt wurden, sind umgehend zu erneuern.</b>				
EN	<b>Missing or non-readable security stickers have to be replaced immediately.</b>				
FR	<b>Les panneaux d'avertissement et/ou autocollants d'avertissement illisibles ou retirés sur la machine doivent être remplacés immédiatement</b>				



### 3 TECHNIK / TECHNICS / TECHNIQUE

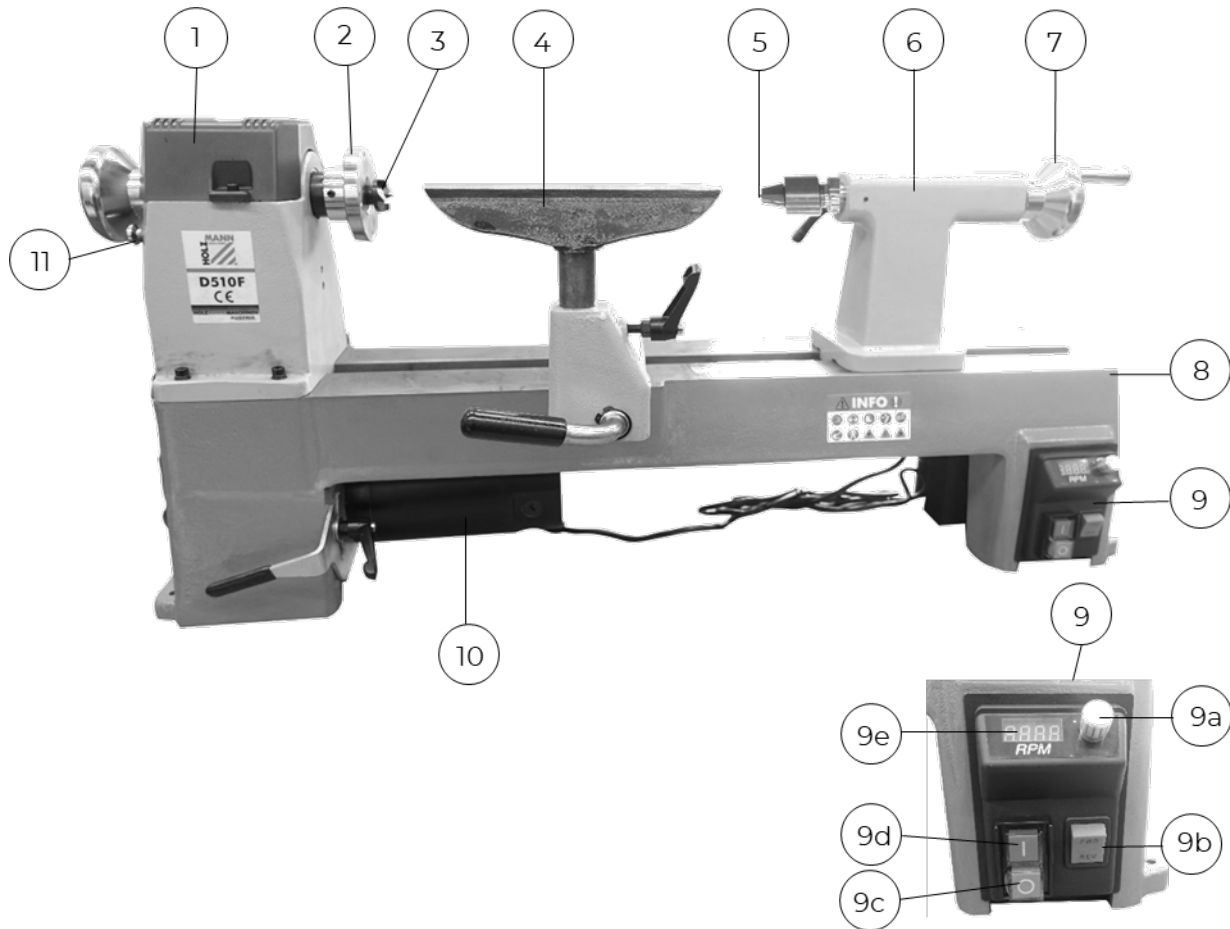
#### 3.1 Lieferumfang / Delivery content / contenu de la livraison



#	Beschreibung / Description	Qty.	#	Beschreibung / Description	Qty.
1	Maschinenbett / machine bed / Banc de machine	1	9	Werkzeughalter / tool holder / Porte-outil	1
2	Handrad Reitstock / handwheel tailstock / Volant	1	10	Gabelschlüssel / open end wrench / Clé à fourche	2
3	Handrad Spindelstock / handwheel headstock / Volant	1	11	4-Zack-Mitnehmer / spur center / Entraîneur à 4 taquets /	1
4	Planscheibe / face plate / Plateau porte-outil	1	12	Körnerspitze / centre punch tip / Contrepointes	1
5	Betriebsanleitung / manual / Mode d'emploi	1	13	Inbusschlüssel / Allen key / Clé Allen	3
6	Unterlegscheiben / washer / Rondelles	2	14	Fixierstange klein / fixing rod small / Tige de blocage	1
7	Schrauben / screws / Vis	2	15	Fixierstange groß / fixing rod long / Tige de blocage large	1
8	Werkzeugauflage / tool rest / support d'outils de forme	1			



### 3.2 Komponenten / Components / Components



	Beschreibung / Description		Beschreibung / Description
1	Spindelstock / headstock / Poupée fixe	9	Schalteinheit / switch unit / Unité de commutation
2	Planscheibe / face plate / Plateau porte-outil	9a	Drehregler Spindeldrehzahl / rotary regulator spindle speed / Régulateur de la vitesse de la broche
3	4-Zack-Mitnehmer / spur center / Entraîneur à 4 taquets	9b	Kippschalter Drehrichtung / toggle switch direction of rotation / Interrupteur à bascule du sens de rotation
4	Werkzeugaufnahme / tool rest / Support d'outil	9c	Ausschalttaste / switch-off button / Touche de désactivation
5	Körnerspitze / centre punch tip / Contrepointes	9d	Einschalttaste / switch-on button / Touche d'activation
6	Reitstock / tailstock / Contrepoupée	9e	Digitale Anzeige / display / Affichage numérique
7	Handrad Reitstock / handwheel tailstock / Volant de la contrepoupée	10	Motor / motor / Moteur
8	Maschinenbett / machine bed / Banc de machine	11	Indexierungsstift / indexing pin / Broche d'indexation



### 3.3 Technische Daten / Technical data / Données techniques

Spezifikation / Specification	
Spannung / voltage / Tension	230 V / 50 Hz
Motorleistung / motor power / Puissance du moteur	735 W
Spindeldrehzahl / spindle speed / Vitesse de broche	250–750 min <sup>-1</sup> 550–1650 min <sup>-1</sup> 1300–3850 min <sup>-1</sup>
Spitzenweite / distance between centers / Distancia entre puntas	510 mm
Spitzenhöhe über Maschinenbett / center height above machine bed / Hauteur de pointes au-dessus du banc de machine	160 mm
Spindelstock Gewindeaufnahme / headstock norm spindle / Poupée fixe, logement de filetage	M33
Morsekonusaufnahme / morse taper / Logement conique d'emmanchement /	MK2/MT2
Pinolenweg / tail spindle travel / Course du fourreau	90 mm
Planscheibe / face plate / Plateau porte-outil /	Ø 82 mm
Werkzeugaufnahme / tool rest / Support d'outils de forme	200 mm
Maschinenmaße (L×B×H) / machine dimensions (L×W×H) / Dimensions de la machine (L×l×H)	940(1060)×310(440)×440 mm
Verpackungsmaße (L×B×H) / packaging dimensions (L×W×H) / Dimensions d'emballage (L×l×H)	990×535×320 mm
Gewicht Brutto / weight gross / Poids brute	58 kg
Gewicht Netto / weight net / Poids net	55 kg
Schalldruckpegel / sound pressure level / Niveau de pression acoustique L <sub>PA</sub>	< 70 dB(A)



## 11 PREFACE (EN)

### Dear Customer!

This manual contains information and important instructions for the safe commissioning and handling of the wood turning lathe D510F\_230V, hereinafter referred to as “machine” in this document.



The manual is an integral part of the machine and must not be removed. Keep it in a suitable place easily accessible to users (operators) for future reference and enclose it with the machine if it is passed on to third parties!

### **Please read and note the safety instructions!**

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.**

### Copyright

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This documentation is protected by copyright. All rights reserved! In particular, the reprint, translation and extraction of photos and illustrations will be prosecuted.

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

### Customer service contact

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AUSTRIA

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## 12 SAFETY

This section contains information and important notes on the safe commissioning and handling of the machine.



For your safety, read this manual carefully before commissioning. This will enable you to handle the machine safely and thus prevent misunderstandings as well as personal injury and damage to property. Pay special attention to the symbols and pictograms used on the machine as well as the safety information and danger warnings!

### 12.1 Intended use of the machine

The machine is intended exclusively for the following activities:

For turning wood or materials with similar physical properties, such as horn, bone or plastic, within the technical limits.

#### 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.

#### 12.1.1 Technical restrictions

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

relative humidity	max. 70 %
temperature (operation)	+5 °C to +40 °C
temperature (storage, transport)	–25 °C to +55 °C

#### 12.1.2 Prohibited applications / Dangerous misuse

- Operating the machine outdoors.
- Operating the machine without adequate physical and mental fitness.
- Operating the machine without knowledge of the manual.
- Modifying the machine design.
- Operating the machine under fire or explosion hazardous conditions (machine can generate ignition during operation).
- Operating the machine outside the technical limits specified in this manual.
- Removing of the safety labels attached to the machine.
- Modifying, circumventing or disabling the safety devices of the machine.
- Machining of materials with dimensions outside the limits specified in this manual.
- Cleaning the machine with water, neither with the power switched on nor with the power switched off.

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.

### 12.2 Requirements for user

The machine is designed to be operated by one person. The prerequisites for operating the machine are physical and mental fitness as well as knowledge and understanding of the manual. Persons who, due to their physical, sensory or mental capabilities, inexperience or lack of knowledge, are unable to operate the machine safely must not use the machine without supervision or instruction by a responsible person.

Put on your personal protective equipment before working on the machine.

**Please note that locally applicable laws and regulations determine the minimum age of the operator and may restrict the use of this machine!**

**Work on electrical components or equipment may only be carried out by a qualified electrician or under the guidance and supervision of a qualified electrician.**





## 12.3 General safety instructions

To avoid malfunctions, damage and health impairments when working with the machine, the following points must be observed in addition to the general rules for safe working:

- Check the machine for completeness and function before starting. Only use the machine if the separating and other non-separating protective devices required for machining have are fitted.
- Make sure that the guards are in good working order and properly maintained.
- Select a level, vibration-free surface as the installation area.
- Ensure sufficient space around the machine. Keep the area around the machine free of obstacles (e.g. dust, chips, cut-off workpiece parts, etc.).
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects.
- Make sure you have a secure footing when working.
- Ensure a clean working environment.
- Only use tools that are in perfect condition and free of cracks and other defects (e.g. deformations).
- Remove tool keys and other setting tools before switching on the machine.
- Check the machine's connections for strength before each use.
- Never leave the running machine unattended. Switch off the machine before leaving the working area and secure it against unintentional or unauthorized restarting.
- The machine may only be operated, maintained or repaired by persons who are familiar and who have been informed about the dangers arising from this work.
- Ensure that unauthorized persons keep a safety distance from the machine and keep children away from the machine.
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine.
- Only work in well-ventilated rooms.
- Hide long hair under hair protection.
- Wear close fitting protective work clothing and suitable protective equipment (eye protection, dust mask, ear protection, safety shoes).
- Never wear loose jewellery, loose clothing or accessories (e.g. tie, scarf).
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!
- Ensure proper connection to the dust extraction system.
- Do not use the machine in areas where vapors of paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Shut down the machine and disconnect it from the power supply, before adjustment, changeover, cleaning, maintenance or repair work, etc. Before starting work on the machine, wait until all tools or machine parts have come to a complete standstill and secure the machine against unintentional restart.
- Warning signs and/or stickers on the machine that are illegible or have been removed must be replaced immediately!

## 12.4 Electrical safety

- Make sure that the machine is grounded.
- Only use suitable extension cables.
- A damaged or tangled cable increases the risk of electric shock. Handle the cable with care. Never use the cable to carry, pull or disconnect the machine. Keep the cable away from heat, oil, sharp edges or moving parts.
- Proper plugs and sockets reduce the risk of electric shock.
- Water entry into the machine increases the risk of electric shock. Do not expose the machine to rain or moisture.
- The machine may only be used if the power supply is protected by a residual current circuit breaker.
- Before connecting the machine always make sure that it is switched off.
- Use the machine only when the ON-OFF switch is in good working order.





## 12.5 Special safety instructions for this machine

- Never reach into the running machine.
- Never open covers or safety devices when the machine is running.
- Do not wear safety gloves when working (rotating parts).
- Remove chips and workpieces when the machine is at a standstill.
- Never brake the machine by hand when it is running down.
- Never take measurements on rotating workpieces.
- Always machine unshaped workpieces at low spindle speed to a round shape.
- Only work on safely clamped workpieces.
- Before clamping the workpiece between two centers, provide it with a centring hole on both sides.
- Remove nails and other foreign substances from the workpiece before machining.

## 12.6 Hazard warnings

### 12.6.1 Residual risks

Despite intended use, certain risk factors cannot be completely eliminated:

- Risk of injury to hands/fingers from freely rotating workpiece during operation and overrun until the machine comes to a complete standstill.
- Risk of injury from contact with moving machine parts.
- Risk of injury from sharp edges of the workpiece.
- Risk of injury from contact with live components.
- Risk of injury due to tipping of the machine.
- Risk of injury to hands or eyes from wood splinters.
- Risk of injury due to incorrect installation of the tool or ejection of tool inserts.
- Risk of injury due to dust emissions from workpieces treated with harmful agents.
- Risk of injury to the eye from flying parts, even with protective goggles.
- Risk of injury from kickback due to the tool.

### 12.6.2 Hazardous situations

Due to the design and construction of the machine, hazardous situations may occur which are identified in this manual as follows:

## DANGER



A safety instruction designed in this way indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

## WARNING



A safety instruction of this type indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

## CAUTION



A safety instruction designed in this way indicates a possibly hazardous situation which, if not avoided, may result in minor or moderate injury.

## NOTE



A safety notice designed in this way indicates a potentially hazardous situation which, if not avoided, may result in property damage.

Regardless of all safety regulations, your common sense and your appropriate technical aptitude/training are and remain the most important safety factor in the error-free operation of the machine. **Safe working depends on you!**



## 13 TRANSPORT

For proper transport, follow the instructions and information on the transport packaging regarding center of gravity, slinging points, weight, means of transport to be used and prescribed transport position, etc.

Transport the machine in its packaging to the place of installation. Ensure the correct body posture when lifting, carrying and setting down the load.

### Lifting/Setting down

- When lifting/setting down, ensure that you are standing firmly (legs hip-width).
- Lift/set down load with knees bent and back straight.
- Do not lift/set down load with a jerk.

### Carrying

- Carry load with both hands as close to body as possible.
- Carry load with straight back.
- When transporting the assembled machine, ensure to lift it only by the machine body and not by the attachments.

If you transport the machine with a vehicle, ensure that the load is secured appropriately!

## 14 ASSEMBLY

### 14.1 Preparation

#### 14.1.1 Delivery content

Check the delivery immediately for transport damage and missing parts. 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 note in accordance with the provisions of the warranty, otherwise the goods are deemed to have been properly accepted.

#### 14.1.2 Requirements for the installation site

The chosen installation site must ensure a suitable connection to the electrical power supply and have a connection to the extraction system. The installation site must meet the required safety regulations and ergonomic operating conditions, such as lighting, space requirements and working position. Place the machine on a level solid base with appropriate load-bearing capacity for machine and workpiece. When dimensioning the required space, take into account that the operation, maintenance and repair of the machine must be possible without restriction at all times.

#### 14.1.3 Preparation of the surface

Remove the preservative applied to protect the parts against corrosion without painting. This can be done with the usual solvents. Do not use nitro solvents or similar agents and in no case water.

### NOTE



The use of paint thinners, petrol, aggressive chemicals or scouring agents will cause damage to the surfaces!  
Therefore: Use only mild cleaning agents for cleaning!

### 14.2 Electrical connection

### WARNING



#### Dangerous electrical voltage!

Risk of injury due to dangerous electrical voltage!

- Connecting the machine to the power supply and the associated checks may only be carried out by a qualified electrician or under the guidance and supervision of a qualified electrician!!

- Check, whether the neutral connection and the protective grounding are working properly.
- Check, whether the supply voltage and the frequency correspond to the specifications of the machine.

### NOTE



#### Deviation of the supply voltage and frequency!

A deviation from the value of the supply voltage of  $\pm 5\%$  is permissible.

A short-circuit fuse must be provided in the power supply system of the machine!



- Use a supply cable of type H07RN (WDE282) or take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage.
- Make sure that the power supply is protected by a residual current circuit breaker.
- Connect the machine only to a properly grounded socket.
- When using an extension cable, make sure that the dimension matches the connected load of the machine. The connection power can be found in the technical data, the correlation of cable cross-section and cable lengths can be found in the technical literature or obtain information from a specialist electrician.
- A damaged cable must be replaced immediately.

### 14.3 Assemble

Parts of the machine have been disassembled for transport and must be reassembled before use. Follow the instructions below:

	<p><b>Tool rest</b></p> <ul style="list-style-type: none"> <li>• Position the tool rest base along the machine bed and fix it with the locking lever (1).</li> <li>• If the tool rest base cannot be moved, loosen the nut (2) on the underside.</li> <li>• Position the tool rest into the opening provided, set the desired height and fix it with the locking handle (3).</li> <li>• If necessary, rotate the tool rest.</li> </ul>
	<p><b>Headstock</b></p> <ul style="list-style-type: none"> <li>• Loosen the two opposite worm screws of the handwheel.</li> <li>• Position the handwheel onto the headstock shaft.</li> <li>• Make sure that the flat part of the shaft touches the worm screw.</li> <li>• Fix the worm screws (4).</li> </ul>
	<p><b>Tailstock</b></p> <ul style="list-style-type: none"> <li>• Loosen the two opposite worm screws.</li> <li>• Slide the handwheel onto the shaft of the tailstock.</li> <li>• Make sure that the flat part of the shaft touches the worm screw.</li> <li>• Fix the worm screw (5).</li> </ul>
	<p><b>Tool holder</b></p> <ul style="list-style-type: none"> <li>• Fix the tool holder with the two screws and washers to the holes provided (6).</li> </ul>

### 14.4 Anchor to the work table

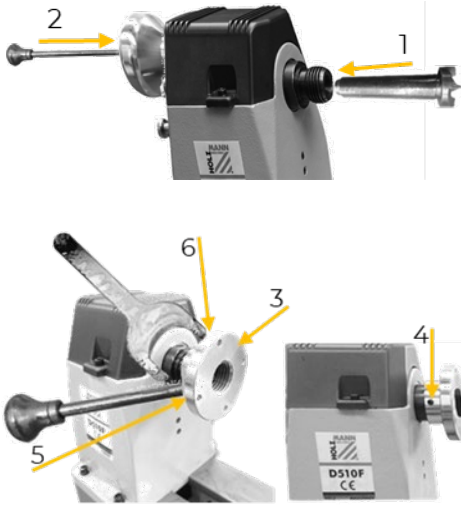
To prevent the machine from slipping while working, anchor the machine to the work table.

	<ul style="list-style-type: none"> <li>• Connect the machine to a flat work surface or work table with 4 screws.</li> </ul> <p><b>NOTE:</b> Required fixing material is not included in the delivery content.</p>
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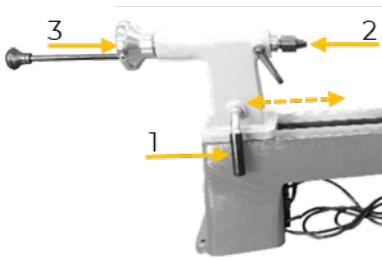


## 14.5 Settings

### 14.5.1 Headstock

	<p><b>Spur center</b></p> <ul style="list-style-type: none"> <li>• Push the spur center into the headstock receptacle (1) with a jerk.</li> <li>• To remove it, push the fixing rod into the rear end of the headstock shaft (2). The spur center comes out of the headstock receptacle.</li> </ul> <p><b>Face plate</b></p> <ul style="list-style-type: none"> <li>• Screw the face plate onto the thread of the headstock shaft (3).</li> <li>• Fix the face plate with the worm screw (4).</li> <li>• To loosen the face plate, loosen the worm screw (4), but do not remove it completely.</li> <li>• Fix the headstock shaft with the fixing rod (5) and at the same time unscrew the face plate with the open end wrench (6).</li> </ul>
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### 14.5.2 Tailstock

	<p><b>Position</b></p> <ul style="list-style-type: none"> <li>• Open the locking handle (1) and move the tailstock along the machine bed, depending on the workpiece size.</li> <li>• Fix the locking handle (1) again.</li> </ul> <p><b>Centre punch tip</b></p> <ul style="list-style-type: none"> <li>• Push the centre punch tip into the tailstock receptacle (2) with a jerk.</li> <li>• To remove it, push the fixing rod into the end of the tailstock shaft (3).</li> </ul>
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### 14.5.3 Spindle speed

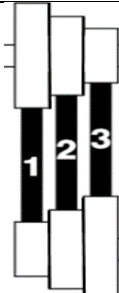

## CAUTION



#### Risk of injury from flying parts!

- Always set the lowest spindle speed for unknown types of wood, for new workpieces and for large workpieces!
- Carefully increase the spindle speed!

The machine has a 3-step pulley arrangement the drive belt position. Select the appropriate drive belt position and spindle speed depending on the diameter of the workpiece.

	<p><b>Spindle speed range</b></p> <p>1: 250–750 rpm 2: 550–1650 rpm 3: 1300–3850 rpm</p>
	<ul style="list-style-type: none"> <li>• Set the spindle speed, depending on the drive belt position, with the rotary regulator of the switch unit (1).</li> <li>• Read the set spindle speed on the digital display (2).</li> </ul>



### Changing the drive belt position

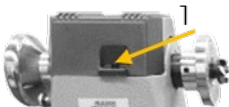
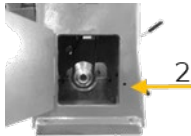
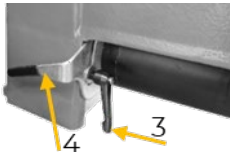
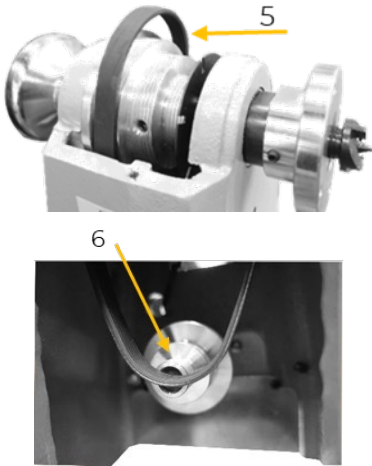
The drive belt position is set and changed as follows:

#### WARNING



##### **Risk of injury due to unintentional switching on the machine!**

- Always disconnect the machine from the power supply before carrying out setting, maintenance or servicing work and secure it against unintentional connection.

	<ul style="list-style-type: none"><li>• Loosen the screw of the spindle cover (1) and open the cover.</li></ul>
	<ul style="list-style-type: none"><li>• Open the side door by loosening the screw (2).</li></ul>
	<ul style="list-style-type: none"><li>• Release the locking lever of the motor plate (3).</li><li>• Lift the motor by the belt tensioning handle (4).</li></ul>
	<ul style="list-style-type: none"><li>• Position the drive belt on the spindle pulley (5) and on the motor pulley (6). Make sure the drive belt runs parallel.</li></ul> <p>Carry out the previously performed work steps in reverse order:</p> <ul style="list-style-type: none"><li>• Lower the belt tensioning handle (4). This tightens the drive belt.</li><li>• Fix the locking lever of the motor plate (3).</li><li>• Fix the side door with the screw (2).</li><li>• Close the spindle cover (1) and fix it with the screw.</li></ul>


When switching on the machine, listen for loud or unusual noises; if necessary, check and adjust the drive belt again.

#### 14.5.4 Direction of rotation

#### CAUTION



Only change the direction of rotation when the machine is at a complete standstill!

	<ul style="list-style-type: none"><li>• Change the direction of rotation on the toggle switch of the switch unit (1).</li></ul>
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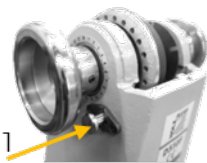
### 14.5.5 Spindle index

The headstock has 24 indexing holes with a spacing of 15°, which allows accurate working with patterns, such as straight grooves, slots or bores.

## CAUTION



- The indexing pin is only for positioning the workpiece!
- Never switch on the machine when the indexing pin is set, as damage to the machine may result!
- Only handle the indexing pin when the machine is at a complete standstill!



- Turn the spindle to the desired position.
  - Pull the indexing pin (1), turn it 90° and release it.
- The spindle is locked in the desired position.  
To unlock the spindle, reverse the procedure.

## 15 OPERATION

Only operate the machine when it is in a perfect condition. A visual inspection of the machine must be carried out before each operation. Safety devices, electrical cables and operating elements must be checked carefully. Check screw connections for damage and tight fit.

### 15.1 Operating instructions

When operating the machine, be sure to observe the following instructions:

- Take time to familiarise yourself with how the machine works, the tools and the types of wood.
- Ensure that the machine has a level and stable base.
- Before switching on, turn the workpiece by hand to ensure that it runs freely and does not touch the tool rest. Check that the workpiece is centered and firmly clamped.
- Check the tool rest for firmly seating before starting.
- Check the tailstock and centre punch tip for tight fit before starting! The centre punch tip should penetrate the workpiece by up to a few mm, depending on the size of the workpiece.
- Check the face plate and, if used, the spur center for tight fit before starting.
- Provide the workpiece with a centring hole on both sides before clamping between two centres.
- Check that the indexing pin is loosened.
- Hold and guide the woodturning tool securely and firmly when working.
- Only work with sharp turning tools.
- Observe the direction of rotation when positioning the turning tool.
- Only work on large and unbalanced workpieces at low spindle speed.
- Adapt the workpiece to its basic shape before turning, if possible.
- Use the face plate for large and unbalanced workpieces.
- Adjust the spindle speed to the material properties.
- Observe the specifications regarding workpiece dimensions.
- Only work on selected woods without defects.

### 15.2 Handling

#### 15.2.1 Deactivate spindle lock

The indexing pin must be in the deactivated position and the spindle must be rotatable before you switch on the machine.

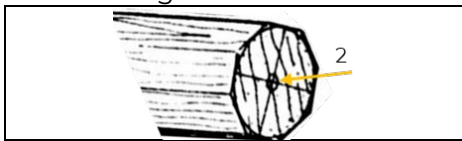


- Pull the indexing pin (1), turn it 90° and release it.



### 15.2.2 Mark the centre of the workpiece

The marking of the centre of the material enables exact clamping of the workpiece.

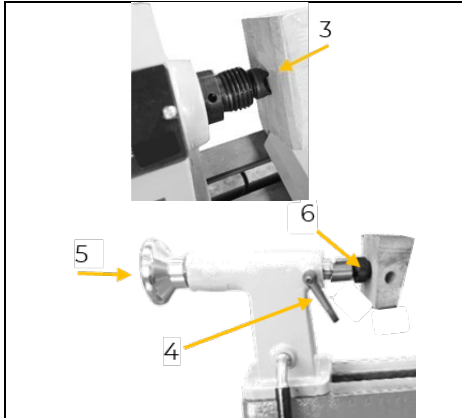


- Mark the center (2) on both faces of the workpiece.

### 15.2.3 Clamp workpiece

#### Longitudinal machining

For longitudinal machining, the workpiece is clamped centred.



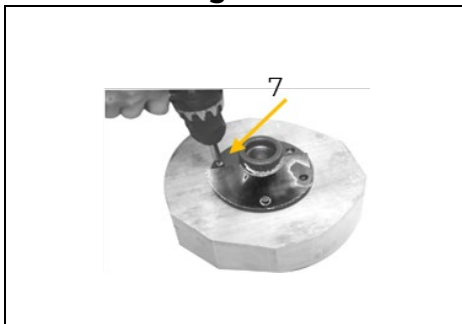
#### Spur center

- Attach the workpiece by drilling the claws of the spur center into the workpiece (3).

#### Centre punch tip

- Loosen the locking handle (4).
- Turn the handwheel (5) until the centre punch tip has bored a few mm into the workpiece (6).
- Fix the locking handle again (4).

#### Front machining



#### Face plate

- Fix the workpiece with suitable Spax screws, which are drilled into the workpiece through the holes in the face plate (7).

**NOTE:** The Spax screws are not included in the delivery content!

Make sure that the Spax screws do not penetrate the area of the workpiece where material is to be removed.

- Screw the face plate with the attached workpiece onto the thread of the headstock shaft.

With optionally available clamping devices you can clamp larger workpieces securely and firmly, see chapter ACCESSORIES.

### 15.2.4 Position the tool rest

- Position the tool rest, depending on the turning tool, just above or just below the centre line of the workpiece at a distance of 1–3 mm.
- Use the tool rest to safely guide and support the turning tool.

## WARNING



#### Risk of injury from parts flying off!

- Before switching on the machine, check whether the face plate and/or the spur center, the tailstock, the centre punch tip and the tool rest are fixed.
- Make sure that the workpiece is firmly clamped!

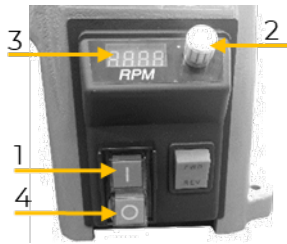
### 15.2.5 Switch the machine on and off

## NOTE



- Do not machine the workpiece with the tool until the machine has reached the set spindle speed.
- Do not increase the spindle speed until the workpiece has reached a regular runout in its basic shape.



**Switch on**

- Press the switch-on button (1) of the switch unit.
- If necessary, set the desired spindle speed with the rotary regulator (2) and read the set spindle speed on the digital display (3).

**Switch off**

- Set the lowest spindle speed with the rotary regulator (2).
- Press the switch-off button (4) of the switch unit.

**CAUTION****Machine overruns!**

- After switching off, stay with the machine until the workpiece has come to a standstill. Never stop the rotation by hand!

**16 CLEANING, MAINTENANCE, STORAGE, DISPOSAL****WARNING****Danger due to electrical voltage!**

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.

**16.1 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.

- Remove chips and dirt particles from the machine after each use with compressed air and a soft brush.
- Prepare the surfaces and lubricate the bare machine parts with an acid-free lubricating oil (e.g. WD40 rust inhibitor).

**16.2 Maintenance**

The machine is low-maintenance and only a few parts need to be serviced. Malfunctions or defects that could affect your safety must be repaired immediately!

- Before each operation, check the perfect condition of the safety devices.
- Regularly check the perfect and legible condition of the warning and safety labels of the machine.
- Use only original spare parts recommended by the manufacturer.

**16.2.1 Maintenance plan**

The type and degree of machine wear depends to a large extent on the operating conditions. The following intervals apply when the machine is used within the technical limits:

Interval	Components	Action
<b>before starting work</b>	• guide ways	• oil
	• spur center and centre punch tip	• Keep the tool, especially the threaded cone, free of dust and apply a thin layer of oil.
	• motor	• Check that the ventilation slots are free of contamination.
	• cable connection	• Check, replace if damaged.

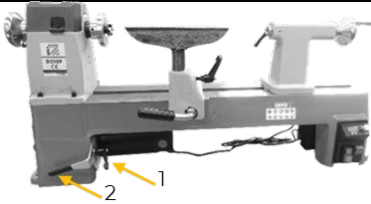


	<ul style="list-style-type: none"> <li>turning tool</li> </ul>	<ul style="list-style-type: none"> <li>Check for defects and sharpness; sharpen or replace if necessary.</li> </ul>
<b>after 50 operating hours</b>	<ul style="list-style-type: none"> <li>drive belt</li> </ul>	<ul style="list-style-type: none"> <li>Check for tight fit and defects (e.g. cracks); replace if necessary, see next chapter.</li> </ul>
	<ul style="list-style-type: none"> <li>check carbon brushes</li> </ul>	<ul style="list-style-type: none"> <li>Check, replace if necessary; see chapter Check/replace carbon brushes</li> </ul>

### 16.2.2 Tension/replace drive belt

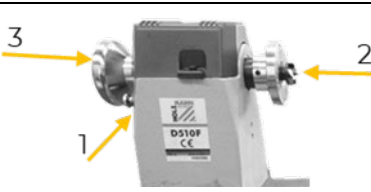
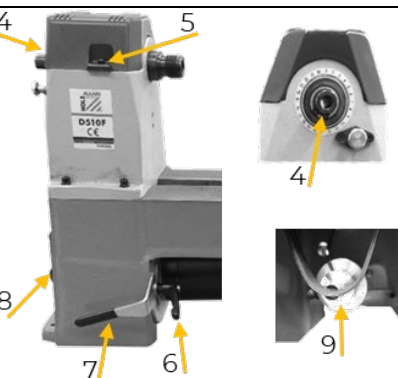

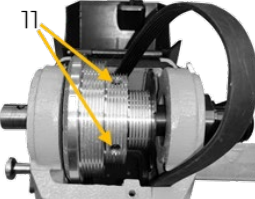
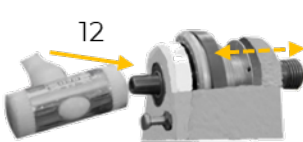
Regularly check the tension and condition of the drive belt. A loose drive belt leads to an increase in the stopping time of the tool. Tension or replace the drive belt as described below.

#### Tension drive belt

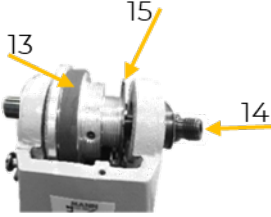
	<ul style="list-style-type: none"> <li>Release the locking lever of the motor plate (1).</li> <li>Lower the belt tensioning handle of the motor plate to tension the drive belt (2).</li> <li>Fix the locking lever (1) again.</li> </ul>
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#### Replace drive belt

Expanded or cracked drive belts must be replaced as follows.

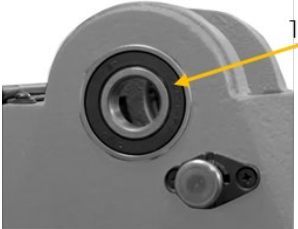
	<ul style="list-style-type: none"> <li>Disconnect the machine from the power supply.</li> <li>Make sure that the indexing pin is deactivated (1) and that the spindle can rotate.</li> <li>Remove the tools used from the spindle shaft (2).</li> <li>Loosen the worm screws and remove the handwheel (3).</li> </ul>
	<ul style="list-style-type: none"> <li>Remove the retaining ring on the headstock shaft (4).</li> <li>Loosen the screw and open the headstock cover (5).</li> <li>Release the locking lever of the motor plate (6).</li> <li>Lift the motor by the belt tensioning handle (7) to slacken the drive belt.</li> <li>Open the machine bed door sideways (8) and remove the drive belt from the motor belt pulley (9).</li> </ul>
	<ul style="list-style-type: none"> <li>Remove the two countersunk screws (10), this will separate the spindle speed measuring and the bracket from the spindle pulley inside.</li> </ul>
	<ul style="list-style-type: none"> <li>Loosen the 2 worm screws of the spindle pulley (11).</li> <li>Also remove the 2<sup>nd</sup> worm screws in each case, which are located directly under the first one.</li> </ul>
	<ul style="list-style-type: none"> <li>Carefully tap the spindle towards the tailstock (12) with a soft-face hammer.</li> <li>Pull out the spindle shaft while simultaneously holding the pulley with the drive belt.</li> <li>Remove the drive belt.</li> </ul>



	<ul style="list-style-type: none"> <li>• Thread the new drive belt onto the belt pulley (13). Carry out the previously performed work steps in reverse order:</li> <li>• Push the spindle shaft with pulley and drive belt into the headstock.</li> <li>• Carefully tap the spindle shaft into position (14) and fix the spindle shaft with the 2 worm screws (11). Make sure that the holes for the worm screw of the handwheel and the belt pulley are at the same height.</li> <li>• Fasten inner the rotational spindle speed measuring together with the bracket with the 2 countersunk screws (10). The segmented RPM plate (15) of the spindle shaft must fit into the u-shaped spindle speed measuring.</li> </ul> <p><b>NOTE:</b> The bracket must be positioned so that it can receive the two countersunk screws. To do this, use an awl or similar tool to align the tapped holes in the bracket with the countersunk holes in the headstock.</p> <ul style="list-style-type: none"> <li>• Slide the lower part of the drive belt onto the motor belt pulley (9). Make sure that the drive belt runs parallel.</li> <li>• Close and fix the side door of the machine bed (8).</li> <li>• Tension the drive belt by lowering the belt tensioning handle (7) and fix the locking lever (6).</li> <li>• Close the headstock cover and fix it (5).</li> <li>• Fix the retaining ring around the spindle shaft (4).</li> <li>• Mount the handwheel with the worm screw on the spindle shaft (3).</li> <li>• Fix the respective tool to the headstock (2).</li> </ul>
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### 16.2.3 Replace bearing

In case of loud and untypical noises, check the bearings and replace them, if necessary.

	<ul style="list-style-type: none"> <li>• Remove the spindle shaft, see previous chapter "Replace drive belt".</li> <li>• Replace the bearings on both sides (1) by carefully tapping them out and inserting new bearings. If necessary, use a wooden block to knock the bearings into position and prevent damage to the machine.</li> <li>• Reassemble the pulley with drive belt and spindle shaft, see previous chapter.</li> </ul>
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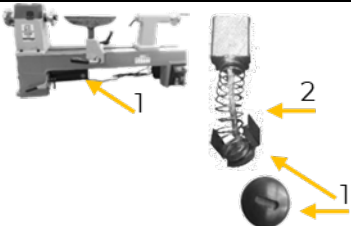
### 16.2.4 Check/replace carbon brushes

Check the carbon brushes for proper function after 50 operating hours of the new machine, subsequently every 10 operating hours. If the carbon is worn out or the spring is damaged, replace the carbon brushes as described below.

## CAUTION



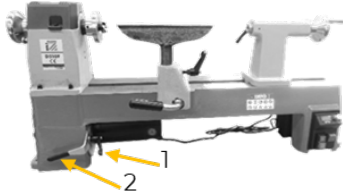
The carbon brushes may only be replaced by trained personnel!

	<ul style="list-style-type: none"> <li>• Disconnect the machine from the power supply.</li> <li>• Remove the cover (1) of the carbon brush on the motor and remove the carbon brush.</li> <li>• Insert the new carbon brush into the sleeve (2).</li> <li>• Fix the carbon brush by compressing the spring and closing the cover.</li> <li>• Repeat this procedure with the opposite carbon brush.</li> </ul>
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### 16.3 Storage

Store the machine including accessories in a dry, frost-proof and lockable place when not in use. Cover the machine or store it in the original box to protect it from dust. Make sure that unauthorized persons and especially children do not have access to the machine. Disconnect the machine from the power supply and slacken the drive belt.



- Slacken the drive belt by loosening the locking lever of the motor plate (1) and lifting the belt tensioning handle (2).

### NOTE



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

### 16.4 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.

## 17 TROUBLESHOOTING

### WARNING



#### **Danger due to electrical voltage!**

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

- Always disconnect the machine from the power supply before starting work to repair defects and secure it against unintentional reconnection.

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.

#### Possible Errors

Trouble	Possible cause	Solution
motor does not run	• switch defective	• repair switch
	• power supply switched off	• Check power supply, replace fuse or switch contactor if necessary.
motor overheated	• motor overloaded	• reduce motor load
	• air flow at the motor restricted	• Clean motor housing to regulate air flow.
excessive motor noise	• defective motor	• check the motor
	• loose belt pulley	• Tighten the adjusting screw of the belt pulley.
machine bogs down during cutting	• loose drive belt	• tighten drive belt
	• cutting depth too great	• reduce cutting depth
strong vibration	• defective or warped workpiece	• Only use material according to specifications.
	• worn spindle bearings	• Centre the workpiece more accurately.
		• change spindle bearings



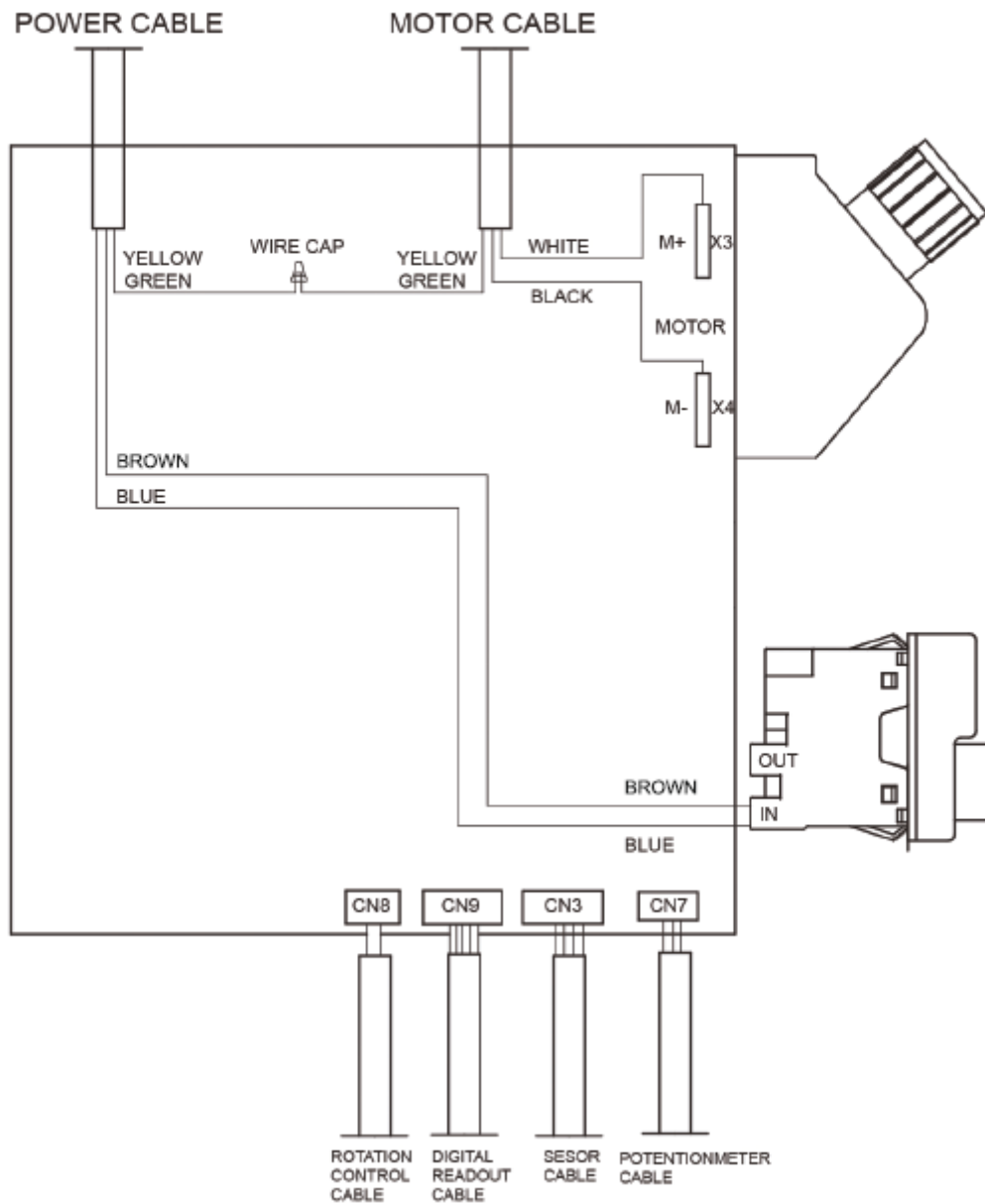
	<ul style="list-style-type: none"> <li>worn drive belt</li> </ul>	<ul style="list-style-type: none"> <li>replace drive belt</li> </ul>
	<ul style="list-style-type: none"> <li>tailstock, tool rest, motor, screws or handles loose</li> </ul>	<ul style="list-style-type: none"> <li>tighten machine parts, screws and handles firmly</li> </ul>
	<ul style="list-style-type: none"> <li>machine stands on uneven ground</li> </ul>	<ul style="list-style-type: none"> <li>Place the machine on an even ground.</li> </ul>
	<ul style="list-style-type: none"> <li>spindle speed too high</li> </ul>	<ul style="list-style-type: none"> <li>reduce spindle speed</li> </ul>
<b>poor turning result</b>	<ul style="list-style-type: none"> <li>blunt turning iron</li> </ul>	<ul style="list-style-type: none"> <li>sharpen turning tool</li> </ul>
	<ul style="list-style-type: none"> <li>wrong turning tool for the job</li> </ul>	<ul style="list-style-type: none"> <li>choose the right turning tool</li> </ul>
	<ul style="list-style-type: none"> <li>wrong tool rest setting</li> </ul>	<ul style="list-style-type: none"> <li>reposition tool rest distance and height</li> </ul>
<b>digital display does not work</b>	<ul style="list-style-type: none"> <li>sensor of the digital display is not in position</li> </ul>	<ul style="list-style-type: none"> <li>contact the customer service</li> </ul>

## 17.1 Error codes of the digital display

Error display	Possible cause	Action
<b>01</b>	<b>Hardware protection mode</b> Possible damage to the electronic control.	<ul style="list-style-type: none"> <li>Switch off the machine, wait until the display goes out and restart.</li> <li>If the error code is still displayed, the hardware controller may be damaged.</li> <li>Contact the customer service!</li> </ul>
<b>02</b>	<b>Software protection mode</b> possible damage to the software of the electronic control	<ul style="list-style-type: none"> <li>Switch off the machine, wait until the display goes out and restart.</li> <li>If the error code is still displayed, the software of the control unit may be damaged.</li> <li>Contact the customer service.</li> </ul>
<b>05</b>	<b>Speed sensor abnormality</b> The speed sensor cable has poor contact, is not mounted correctly or damaged.	<ul style="list-style-type: none"> <li>Check the speed sensor cable and make sure it is firmly connected.</li> <li>Check that the speed sensor and segmented RPM plate are mounted correctly.</li> <li>If the error code is still displayed after switching on the machine, change the speed sensor.</li> </ul>
<b>06</b>	<b>Protection mode for spindle direction</b> The spindle rotation direction has been changed during operation.	<ul style="list-style-type: none"> <li>Switch off the machine, wait until the display goes out and restart.</li> </ul>
<b>08</b>	<b>Protection mode for motor speed</b> The motor speed has been greatly increased, indicating a possible user error.	<ul style="list-style-type: none"> <li>Switch off the machine, wait until the display goes out and restart.</li> <li>If the error code is still displayed, the motor or controller may be damaged.</li> <li>Contact the customer service.</li> </ul>



## 25 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM / SCHEMA ELECTRIQUE





## 26 ERSATZTEILE / SPARE PARTS / PIÈCES DE RECHANGE

### 26.1 Ersatzteilbestellung / Spare parts order/ Commande de pièces détachées

**(DE)** Mit HOLZMANN-Ersatzteilen verwenden Sie Ersatzteile, die ideal aufeinander abgestimmt sind. Die optimale Passgenauigkeit der Teile verkürzen die Einbauzeiten und erhöhen die Lebensdauer.

#### HINWEIS



Der Einbau von anderen als Originalersatzteilen führt zum Verlust der Garantie! Daher gilt: Beim Tausch von Komponenten/Teile nur vom Hersteller empfohlene Ersatzteile verwenden.

Bestellen Sie die Ersatzteile direkt auf unserer Homepage – Kategorie ERSATZTEILE.  
oder kontaktieren Sie unseren Kundendienst

- über unsere Homepage – Kategorie SERVICE – ERSATZTEILANFORDERUNG,
- per Mail an [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at).

Geben Sie stets Maschinentype, Ersatzteilnummer sowie Bezeichnung an. Um Missverständnissen vorzubeugen, empfehlen wir, mit der Ersatzteilbestellung eine Kopie der Ersatzteilzeichnung beizulegen, auf der die benötigten Ersatzteile eindeutig markiert sind, falls Sie nicht über den Online-Ersatzteilkatalog anfragen.

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

#### NOTE



The installation of parts other than original spare parts leads to the loss of the guarantee! Therefore: When replacing components/parts, only use spare parts recommended by the manufacturer.

Order the spare parts directly on our homepage – category SPARE PARTS or contact our customer service

- via our Homepage – category SERVICE – SPARE PARTS REQUEST,
- by e-mail to [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at).

Always state the machine type, spare part number and designation. To prevent misunderstandings, we recommend that you add a copy of the spare parts drawing with the spare parts order, on which the required spare parts are clearly marked, especially when not using the online-spare-part catalogue.

**(FR)** Les pièces de rechange HOLZMANN sont conçues pour correspondre idéalement. La précision d'ajustage optimale des pièces réduisent les temps de pose et augmente la durée de vie.

#### AVIS



Le montage de pièces autres que les pièces de rechange d'origine entraîne la perte de la garantie ! Par conséquent, la règle est la suivante : Utiliser uniquement des pièces de rechange recommandées par le fabricant pour le remplacement des composants/pièces.

Commandez les pièces de rechange directement sur notre page d'accueil – catégorie PIÈCES DE RECHANGE. Ou contactez notre service client

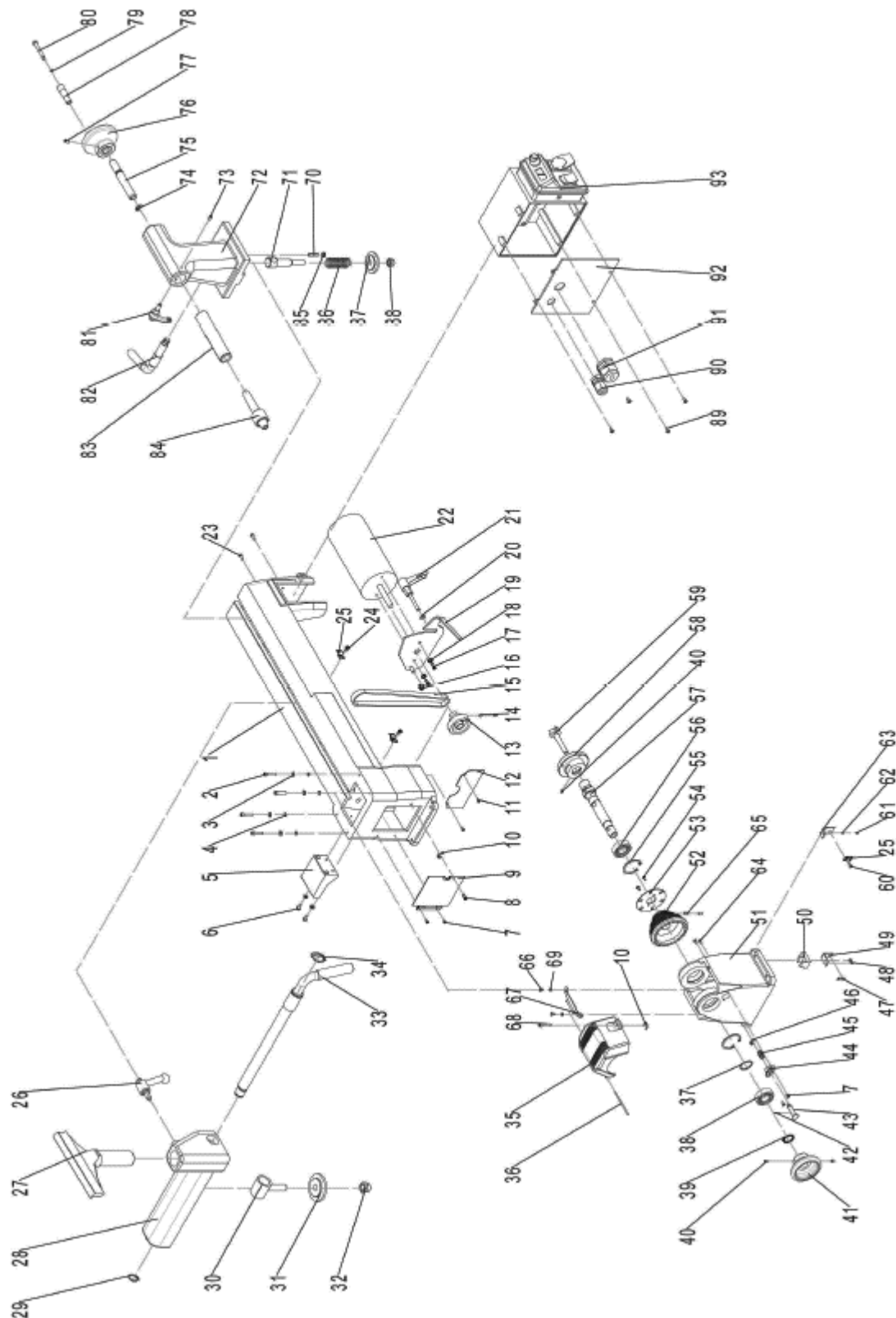
- via notre page d'accueil – Catégorie SERVICE – DEMANDE DE PIÈCES DE RECHANGE
- par e-mail à l'adresse [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at)

Toujours indiquer le type de machine, le numéro de pièce de rechange et la désignation. Afin d'éviter tout malentendu, nous vous recommandons de joindre une copie du plan des pièces détachées à la commande de pièces détachées, sur laquelle les pièces détachées requises sont clairement indiquées, si vous ne faites pas la demande via le catalogue de pièces de rechange en ligne





## 26.2 Explosionszeichnung / Exploded view / Vue éclatée



**26.3 Ersatzteilliste / Spare part list / Liste des pièces de rechange**

No.	Description	No.	Description	No.	Description
1	Machine bed	32	Self locking nut	63	Plate
2	Hex. socket cap screw	33	Locking lever	64	Cross pan head screw
3	Flat washer	34	Retaining ring	65	Socket head pan screw
4	Lock washer	35	Headstock cover	66	Screw
5	Tool holder	36	Hinge shaft	67	Hinge
6	Cross pan head screw	37	Wave washer	68	Hex. socket cap screw
7	Countersunk head screw	38	Bearing	69	Flat washer
8	Cylinder head hex. socket bolt	39	Retaining ring	70	Set screw
9	Bed cover plate door	40	Socket head cap screw	71	Threaded shaft
10	Split washer	41	Handwheel	72	Tailstock
11	Half-countersunk head screw	42	Roll pin	73	Set screw
12	Plate	43	Indexing pin	74	Retaining ring
13	Motor pulley	44	Locating sleeve	75	Tailstock shaft
14	Socket head cap screw	45	Spring	76	Handwheel
15	Drive belt	46	Split washer	77	Socket head cap screw
16	Self-locking nut	47	Threaded plate	78	Rotation handle
17	Hex. socket cap screw	48	Tapping screw	79	Spring coil
18	Lock washer	49	Support bracket	80	Screw
19	Motor connecting plate	50	RPM reader assembly	81	Locking handle
20	Big washer	51	Headstock	82	Tailstock locking lever
21	Locking handle	52	Spindle pulley	83	Tailstock locking shaft
22	Motor	53	Segmented RPM plate	84	Centre punch tip
23	Hex. socket cap screw	54	Hexagon socket cap screw	85	Nut
24	Cross head pan screw	55	Retaining ring C-clip	86	Compression spring
25	Cable plate	56	Bearing	87	Clamping plate
26	Locking handle	57	Spindle	88	Self-locking nut
27	Tool rest	58	3" Face plate	89	Tapping screw
28	Tool rest base	59	Spur center	90	M16 Pull off
29	Retaining ring	60	Cylinder head hex socket bolt	91	M20 Pull off
30	Threaded shaft & sleeve	61	Cross pan head screw	92	Switch box cover
31	Camping plate	62	Flat washer	93	Switch box

**27 ZUBEHÖR / ACCESSORIES / ACCESSOIRES**

**(DE)** Verwenden Sie Zubehörteile für die Adaptierung der Maschine und/oder für die exakte Bearbeitung Ihrer Werkstücke.

Genauere Informationen zu nachfolgenden und weiteren optional erhältlichen Zubehör finden Sie online auf der Produktseite, Kategorie EMPFOHLENES ZUBEHÖR ZUM Produkt.

[Drechselbank / D510F 230V / Drechselmaschinen - HOLZMANN Maschinen GmbH \(holzmann-maschinen.at\)](http://Drechselbank / D510F 230V / Drechselmaschinen - HOLZMANN Maschinen GmbH (holzmann-maschinen.at))

**(EN)** Use accessories to adapt the machine and/or for precise machining of your workpieces.

More detailed information on the following and other optionally available accessories can be found online on the product page, category RECOMMENDED ACCESSORIES FOR THE PRODUCT.

[wood lathe / D510F 230V / wood lathe - HOLZMANN Maschinen GmbH \(holzmann-maschinen.at\)](http://wood lathe / D510F 230V / wood lathe - HOLZMANN Maschinen GmbH (holzmann-maschinen.at))

**(FR)** Utiliser des accessoires pour adapter la machine et/ou usiner vos pièces avec précision.

Des informations détaillées sur les accessoires suivants et d'autres accessoires disponibles en option en ligne sur la page du produit, catégorie ACCESSOIRES RECOMMANDÉS POUR LE PRODUIT.

[Tour à bois / D510F 230V / Tour à bois - HOLZMANN Maschinen GmbH \(holzmann-maschinen.at\)](http://Tour à bois / D510F 230V / Tour à bois - HOLZMANN Maschinen GmbH (holzmann-maschinen.at))