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Originalfassung

DE BETRIEBSANLEITUNG **FORMATKREISSÄGE**

Übersetzung / Translation

EN USER MANUAL **PANEL SAW**

CZ NÁVOD K POUŽITÍ **FORMÁTOVACÍ PILA**

FKS305V16TOP_400V

YOUR JOB. OUR TOOLS.

Edition: 26.09.2023 – Revision – 00 – RaR – DE/EN/CZ

2 SICHERHEITSZEICHEN / SAFETY SIGNS / BEZPEČNOSTNÍ ZNAČKY

DE SICHERHEITSZEICHEN
BEDEUTUNG DER SYMBOLE

EN SAFETY SIGNS
DEFINTION OF SYMBOLS

CZ BEZPEČNOSTNÍ ZNAČKY
VÝZNAM SYMBOLŮ

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

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

CZ **CE SHODA:** Tento výrobek vyhovuje směrnicím EU.

DE **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.

EN **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.

CZ **PŘEČTĚTE SI NÁVOD K PROVOZU!** Přečtěte si pozorně návod k použití a údržbě stroje a dobře se seznamte s jeho ovládacími prvky, abyste mohli stroj správně ovládat, čímž zabráníte škodám na zdraví osob i poškození stroje.

DE **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.

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

CZ **VAROVÁNÍ!** Respektujte bezpečnostní symboly! Nedodržování předpisů a pokynů k použití stroje může způsobit vážné škody na zdraví osob a smrtelná nebezpečí.

DE Schutzausrüstung tragen!

EN Wear protective equipment!

CZ Používejte ochranné prostředky!

DE Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

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

CZ Před údržbou a přestávkami vypněte stroj a vytáhněte síťovou zástrčku!

DE Warnung vor Schnittverletzungen!

EN Warning of crush injuries!

CZ Varování před řeznými zraněními!

DE Benutzen von Handschuhen verboten!

EN Do not use gloves!

CZ Používání rukavic je zakázáno!

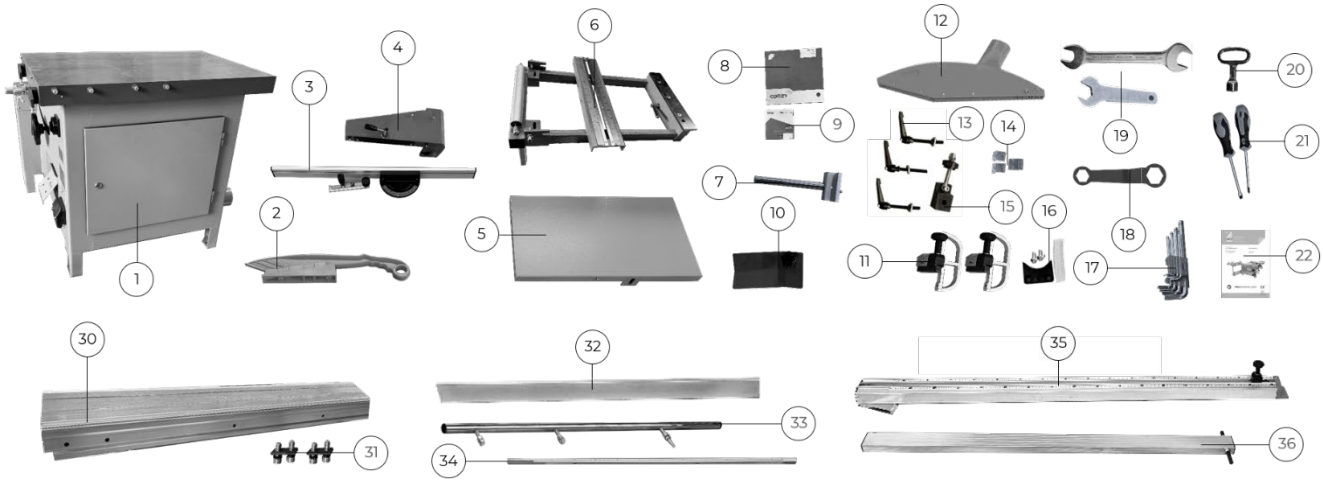
DE **Warnschilder und/oder Aufkleber an der Maschine, die unleserlich sind oder entfernt wurden, sind umgehend zu erneuern.**

EN **Missing or non-readable security stickers have to be replaced immediately.**

CZ **Výstražné štítky a/nebo nálepky na stroji, které jsou nečitelné či byly odstraněny, je nutné ihned obnovit!**

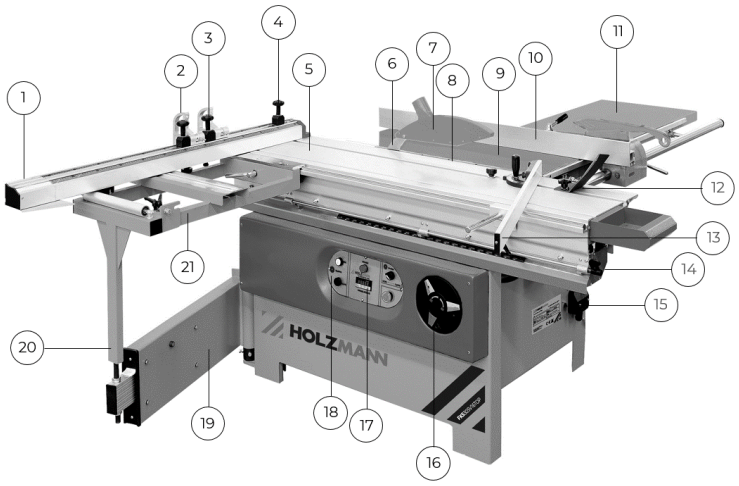
3 TECHNIK / TECHNICS / TECHNICKÁ ČÁST

3.1 Lieferumfang / Rozsah dodávky



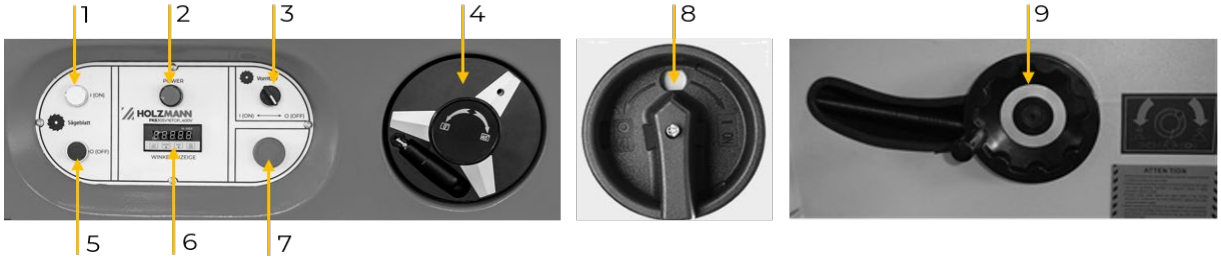
#	Beschreibung / Description	Qty
1	Maschine / machine / Stroj	1
2	Schiebestock / push stick / Posuvná tyč	1
3	Gehrungsanschlag / mitre gauge / Pokosový doraz	1
4	Halterung Parallelanschlag / bracket rip fence / Držák paralelního dorazu	1
5	Tischverbreiterung / table widening / Rozšíření stolu	1
6	Auslegertisch / outrigger table / Podpěrný stůl	1
7	Handriff Formatschiebetisch / handle sliding table / Držák formátovacího posuvného stolu	1
8	Sägeblatt Ø 300 x Ø 30 x 2,2-3,2mm Z: 72 / saw blade Ø 300 x Ø 30 x 2,2-3,2mm T: 72 / Pilový kotouč Ø 300 x Ø 30 x 2,2–3,2mm Z: 72	1
9	Vorritzer Ø 120 x Ø 20 x 3,1-2,2mm Z: 24 / scoring saw blade Ø 120 x Ø 20 x 3,1-2,2mm T: 24 / Předřezový pilový kotouč Ø 120 x Ø 20 x 3,1–2,2mm Z: 24	1
10	Besäumschuh / edging shoe / Zarážka	1
11	Kippanschlag / flip stop / Zarážka náklonu	2
12	Sägeblattschutz / saw blade guard / Ochrana pilového kotouče	1
13	Klemmhebel / clamping lever / Svěrací páka	3
14	Lupe / magnifier / Lupa	3
15	Klemmung 90° / clamping 90° / Upínání 90°	1
16	Schmutzabstreifer / dirt wiper /Škrabka na nečist	1
17	Inbusschlüsselset / Allen key set / Sada inbusových klíčů	1
18	Sägeblattschlüssel / saw blade wrench / Klíč na pilový kotouč	1
19	Gabelschlüsselset / wrench set / Sada otevřených klíčů	1
20	Wartungstürschlüssel / key maintenance door / Klíč ke dvířkám pro údržbu	1
21	Schraubendreherset / screw driver set / Sada šroubováků	1
22	Betriebsanleitung / user manual / Návod k použití	1
Colli II:		
30	Formatschiebetisch / sliding table / Formátovací posuvný stůl	1
31	Montageschrauben und Platten / mounting screws and plates / Montážní šrouby a profily	2
32	Parallelanschlag / rip fence / Paralelní doraz	1
33	Führungsschiene Parallelanschlag / rip fence guide / Vodicí lišta paralelního dorazu	1
34	Lineal Parallelanschlag / ruler rip fence / Pravítko paralelního dorazu	1
35	Ablänganschlag / cross-cut fence / Doraz pro řezání na délku	1
36	Schwenkarm / swivel arm / Otočné rameno	1

3.2 Komponenten / Components / Komponenty



#	Beschreibung / Description
1	Ablänganschlag (ausziehbar) / cross-cut fence (extendable) / Doraz pro řezání na délku (vytahovací
2	Anschlag Ablänganschlag (Kippanschlag) / flip stop / Zarážka pro řezání na délku (překlopný doraz)
3	Klemmung Kippanschlag / clamping flip stop / Upnutí dorazu
4	Fixierknopf Ablänganschlag / fixing knob length cross-cut fence / Fixace dorazu
5	Formatschiebetisch / sliding table / Formátovací posuvný stůl
6	Spaltkeil / riving knife / Rozvírací klín
7	Sägeblattschutz / saw blade guard / Ochrana pilového kotouče
8	Sägeblatt und Vorritzer / saw blade and scoring saw blade / Pilový a předřezový kotouč
9	Arbeitstisch / work table / Pracovní stůl
10	Parallelanschlag / rip fence / Paralelní doraz
11	Tischverbreiterung / table widening / Rozšíření stolu
12	Besäumschuh / edging shoe / Zarážka
13	Gehrungsanschlag / mitre gauge / Pokosový doraz
14	Hauptschalter (nicht abgebildet) / main switch (not shown) / Hlavní vypínač (není vyobrazen)
15	Anschlussdose / junction box / Připojovací krabice
16	Handrad Sägeblattneigung / handwheel saw blade tilt / Kolečko pro sklon pilového kotouče
17	Winkelanzeige Sägeblattneigung / display saw blade tilt angle / Ukazatel sklonu pilového kotouče
18	Bedienfeld / control panel / Ovládací panel
19	Schwenkarm / swivel arm / Otočné rameno
20	Schwenkarmstütze / swivel arm support / Podpěra otočného ramena
21	Auslegertisch / outrigger table / Podpěrný stůl

3.2.1 Bedienelemente / control elements / Ovládací prvky



#	Beschreibung / Description
1	Taster Sägeblatt EIN / button saw blade ON / Tlačítko spuštění pilového kotouče
2	Betriebskontrollleuchte / power indicator light / Kontrolka provozu
3	Schalter Vorritzer EIN-AUS / switch scoring saw blade ON-OFF / Páka předřezu ZAP-VYP
4	Handrad Sägeblattneigung / handwheel saw blade tilt / Kolečko pro sklon pilového kotouče
5	Taster Sägeblatt und Vorritzer AUS / button saw blade and scoring saw blad OFF / Tlačítko zastavení pilového kotouče a předřezu
6	Winkelanzeige Sägeblattneigung / display saw blade tilt angle / Ukazatel sklonu pilového kotouče
7	Not-Halt Schalter / emergency stop / Spínač nouzového zastavení
8	Hauptschalter für Spannungsversorgung EIN-AUS / main switch für power supply ON-OFF / Hlavní vypínač napájení ZAP-VYP

9	Handrad Sägeblatthöhe / handwheel saw blade height / Páka výšky pilového kotouče

3.3 Technische Daten / Technical data / Technické údaje

Spezifikation / Specification	
Spannung / voltage / Napětí	400 V / 50 Hz / 3Ph
Motorleistung Sägeblattmotor / motor power sawblade motor / Výkon motoru pilového kotouče	5,5 kW
Arbeitstischgröße / worktable size / Velikost pracovního stolu	935 x 600 mm
Formatschiebetisch / sliding table / Formátovací posuvný stůl	1600 x 370 mm
Tischverbreiterung / table widening / Rozšíření stolu	500 x 900 mm
Arbeitstisch Höhe / work table height / Výška pracovního stolu	900 mm
Auslegertisch / outrigger table / Podpěrný stůl	740 x 400 mm
Ablänganschlag / cross-cut fence / Doraz pro řezání na délku	1200 (+1080) mm
Sägeblattdimension / saw blade dimension / Rozměr pilového kotouče	Ø 250-315 x 30 x 3,4/2,4 mm
Drehzahl Sägeblatt / saw blade speed / Otáčky pilového kotouče	(I): 4000 min^{-1} (II): 6000 min^{-1}
Sägeblatt Neigung /saw blade tilt / Sklon pilového kotouče	0 – 45°
Schnitthöhe bei 90 ° / cutting height at 90 ° / Výška řezu při 90°	80 mm (Ø 300mm)
Schnitthöhe bei 45 ° / cutting height at 45 ° / Výška řezu při 45°	55 mm (Ø 300mm)
Vorritzersägeblattdimension / scoring saw blade dimension / Rozměry předřezového pilového kotouče	Ø120 x 20 x 3,1/2,2 mm
Motorleistung Vorritzer / scoring unit power / Výkon předřezového motoru	750 W
Vorritzersägeblattgeschw. / scoring saw blade speed / Rychlost předřezového pilového kotouče	8000 min^{-1}
Max. Schnittbreite am Parallelanschlag / max. cutting width at rip fence / Max. Šířka řezu u paralelního dorazu	1250 mm
Absauganschluss / dust collector port / Přípojka odsávání	Ø 100 mm
Absauganschluss Sägeblattschutz / dust collector port saw blade guard / Přípojka odsávání kryt pilového kotouče	Ø 60 mm
notwendiger Luftvolumenstrom Absauganlage / necessary air volumne / Požadovaný systém odsávání objemového průtoku vzduchu	2000 m^3/h
notwendiger Unterdruck Absauganlage / vacuum dust collector / Požadovaný podtlak (odsávací zařízení)	1000 Pa
Maschinenmaße (L×B×H) / machine dimensions (L×W×H) / Rozměry stroje (dxšxv)	2840 x 2795 x 1130 mm
Verpackungsmaße (L×B×H) / packaging dimensions (L×W×H) / Rozměry obalu (dxšxv)	Colli I: 1345 x 1155 x 1140 mm Colli II: 1905 x 490 x 315 mm
Gewicht Brutto / weight gross / Hmotnost brutto	588 kg
Gewicht Netto / weight net / Hmotnost netto	554 kg
Schallleistungspegel L_{WA} / sound power level L_{WA} / Hladina akustického výkonu L_{WA}	90 dB(A).....k: 4 dB(A)
Schalldruckpegel L_{PA}/sound pressure level L_{PA} / Hladina akustického tlaku L_{PA}	88,2 dB(A).....k: 4 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.

(CZ) Oznámení - údaje o hlučnosti: Uvedené hodnoty jsou emisní hodnoty, a proto nemusejí současně představovat i bezpečné hodnoty na pracovišti. Přestože existuje korelace mezi hladinami emisí a imisí, nelze z ní spolehlivě odvodit, zda jsou nutná další preventivní opatření, či nikoli. Mezi faktory, které ovlivňují skutečnou hladinu imisí na pracovišti, patří charakter pracovního prostoru a další zdroje hluku, tj. počet strojů a dalších sousedních pracovních procesů. Přípustné hodnoty na pracovišti se rovněž mohou v jednotlivých zemích lišit. Tato informace však má uživateli umožnit lépe posoudit ohrožení a riziko.

11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the panel saw FKS305V16TOP_400V, 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!

Adhere to the safety and danger instructions. Failure to do so may result in serious injury.

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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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 designed exclusively for the following activities:

Lengthwise and crosswise cutting of wood and materials with similar physical properties to wood using an effective suction device according to technical specifications and 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. 65 %
Temperature (operation)	+5 °C to +40 °C
Temperature (storage, transport)	-20 °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 in an explosive environment (machine can generate ignition sparks during operation).
- Operating the machine in closed rooms without chip and dust collection system (a normal household hoover is not suitable as a dust collection system).
- Operating the machine outside the technical limits specified in this manual.
- Machining materials with dimensions outside the limits specified in these instructions.
- Removing of the safety markings attached to the machine.
- Modifying, circumventing or disabling the safety devices of the machine.
- Using tools that do not comply with the safety requirements to the standard for machine tools for woodworking (EN847-1).

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 User requirements

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 operating instructions. 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.

Basic knowledge of woodworking especially the knowledge of the relationship between wood, tools, saw blade, cutting speeds and rotational speeds.

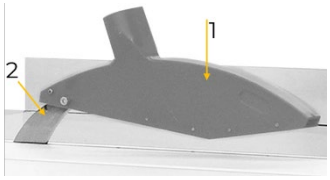
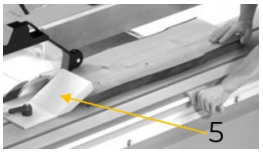
Please note that locally applicable laws and regulations determine the minimum age of the operator and may restrict the use of this machine!

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.

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

12.3 Safety devices

The machine is equipped with the following safety devices:

	A self-locking **Emergency Stop** on the control panel and on the machine backside to stop dangerous movements at any time.
	Safety guard (adjustable): **Saw blade guard** (1), to cover the saw unit. **Riving knife** (2), to reduce the risk of wedging the workpiece. The setting is in horizontal and vertical direction opposite to the saw blade.
	**Push stick** (4): For cutting operations where less than 120mm is cut, i.e. less than 120mm distance to the right of the saw blade to the rip fence. Do not feed the wood by hand, but with the push stick.
	Safety device for longitudinal cuts. Press the workpiece against the **edging shoe** (5). This prevents the workpiece from jumping up.
	Interlocking movable guard: **Safety cover of the saw blade** (equipped with a **safety switch**) This safety switch interrupts the power supply immediately when the cover is opened.

12.4 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.
- Ensure that the machine is on a firm footing.
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects.

- Ensure a clean working environment.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut-off workpiece parts, etc.).
- 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.
- Hide long hair under hair protection.
- Wear close fitting protective work clothing and suitable protective equipment (eye protection, dust mask, ear protection, safety-shoes, and work gloves only when handling tools).
- 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!
- Connect the machine to a suitable dust collection system.
- Do not use the machine in areas where vapours of paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Do not smoke in the immediate vicinity of the machine (fire hazard).
- 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!

12.5 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 power tool. Keep the cable away from heat, oil, sharp edges or moving parts.
- Proper plugs and outlets 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 the main switch is switches off.
- Use the machine only when the ON-OFF switch is in good working order.

12.6 Special safety instructions for this machine

- Working with gloves on rotating parts is not permitted.
- Wood dust is generated when operating the machine. Therefore, connect the machine to a suitable dust and chip collection system when installing it.
- Always switch on the dust collectionf system before you start machining the workpiece.
- Never remove sections or other parts of the workpiece from the cutting area while the motor is running.
- When using milling tools with a diameter ≥16 mm and circular saw blades, they must comply with EN 847-1:2013 and EN 847-2:2013; tool carriers must comply with EN 847-3:2013.
- Wear hearing protection certified to health and safety regulations to limit noise exposure.
- Replace cracked and deformed saw blades immediately; they cannot be repaired.

- Use a push stick for cutting operations where less than 120 mm is cut.
- Select the number of teeth of the saw blade so that at least 2-3 teeth cut through the workpiece at the same time. A lower number of teeth leads on the one hand to an unclean cut and on the other hand increases the risk of vibrations and noise pollution due to increased kickback.
- Never try to cut freehand. If the workpiece is not guided exactly parallel to the saw blade, kickback is to be expected.
- Always use the rip fence or crosscut fence to support the workpiece.

12.7 Hazard warnings

12.7.1 Residual risks

Despite intended use, certain residual risk factors remain.

- Risk of injury to fingers and hands from rotating saw blade if the workpiece is not guided properly.
- Risk of injury from the workpiece being flung away if not properly held or guided, such as working without a fence. Risk of kickback!
- Danger to health from wood dust or wood chips. It is essential to wear personal protective equipment such as eye protection and a dust mask and to use a dust collection system.
- Risk of injury from breakage or ejection of the saw blade or parts of it, especially in the event of overloading or incorrect direction of rotation.
- Risk of injury to the eye from flying parts, even with protective goggles.
- Hearing damage if hearing protection is not used.
- Injuries caused by a defective saw blade.
- Risk of electric shock, if improper electrical connections are used.

12.7.2 Hazardous situations

Due to the structure and construction of the machine, hazardous situations may occur which are identified in these operating instructions 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 designed in this way indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

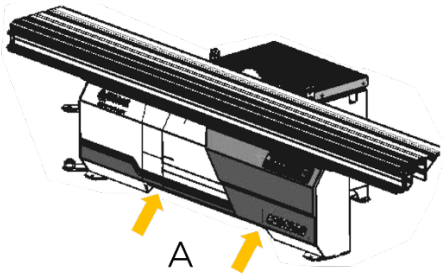
CAUTION
 A safety instruction designed in this way indicates a possibly hazardous situation which, if not avoided, may result in minor or moderate injury.

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

Transport the machine in its packaging to the installation site. To manoeuvre the machine in its packaging, e.g. a crane, pallet truck or forklift with appropriate lifting capacity and a fork length of at least 1200 mm can be used. The specifications can be found in the chapter Technical data. For proper transport, observe the instructions and information on the transport packaging regarding centre of gravity, lifting points, weight, means of transport to be used as well as the prescribed transport position etc. Make sure that the selected lifting equipment (crane, forklift, lift truck, load sling etc.) is in perfect condition. Only use tested transport and lifting devices that correspond to the weight and dimensions of the machine!

	A: Transporting points for forklift

14 ASSEMBLY

14.1 Preparation

14.1.1 Check 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

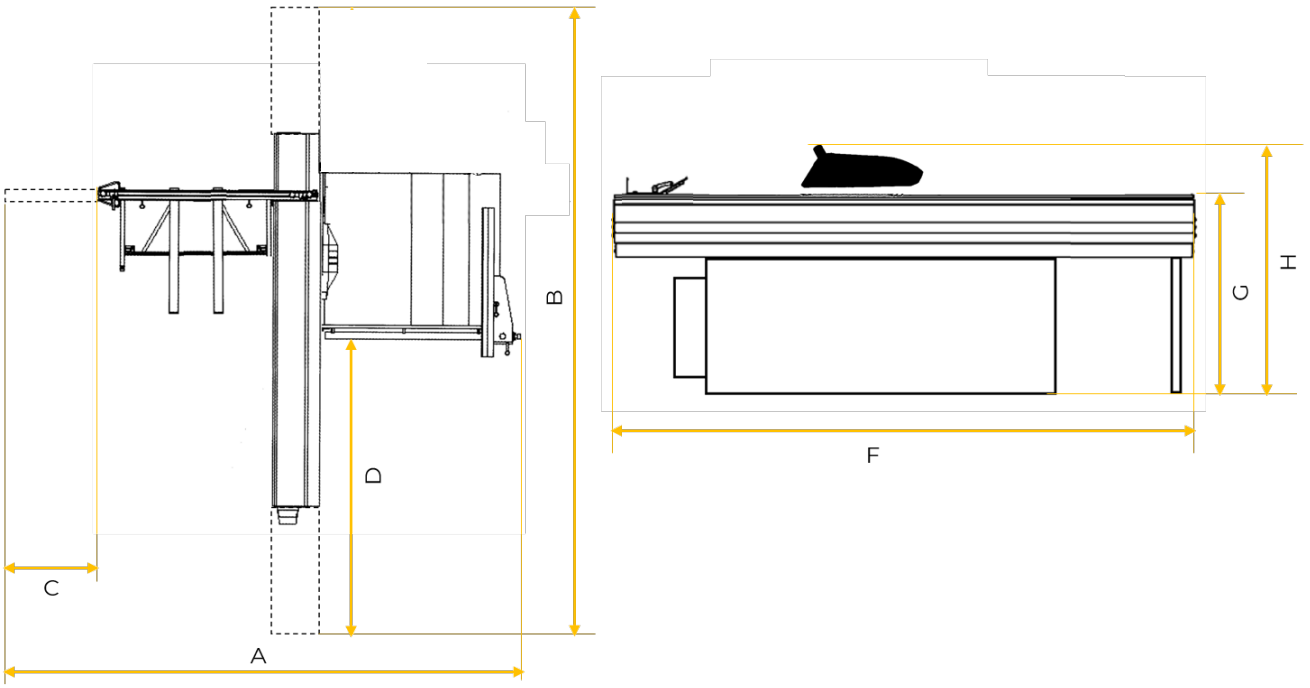
The chosen installation site must have a suitable connection to the power supply and a connection to a dust collection system. Observe the safety requirements and the dimensions of the machine.

Place the machine on a level, solid surface that can support the weight of the machine. The chosen installation site of the machine must comply with the local safety regulations as well as the ergonomic requirements for a workplace with sufficient lighting conditions.

NOTE	
	The floor at the installation site must be able to bear the load of the machine!

When dimensioning the required space, take into account that the operation, maintenance and repair of the machine must be possible without restrictions at all times. Also take into account the working areas of neighbouring machines.

The base of the machine has fixing holes by means of which the machine is firmly connected to the floor. This improves the stability of the machine.



	A	B	C	D		F	G	H
mm	3920	3780	1080	1460		1600	900	1130

14.1.3 Preparation of the surfaces

Before putting the machine into operation, carefully remove the corrosion protection or grease residues from the bare metal parts. This can be done with the usual solvents. Under no circumstances should you use nitro thinners or other cleaning agents, as these can attack the machine´s finish.

NOTE

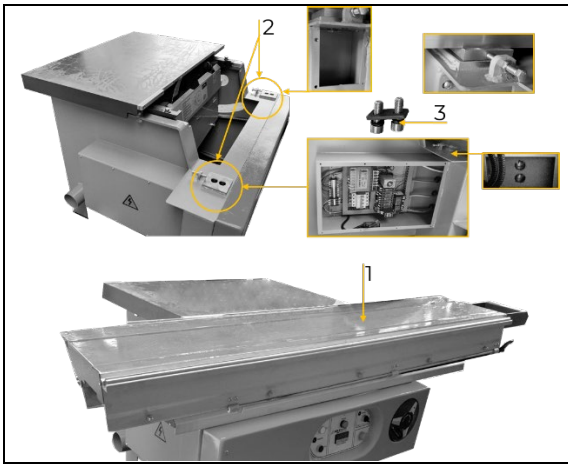
The use of paint thinners, petro, aggressive chemicals or scouring agents will damage the surfaces!
Therefore: Use only mild cleaning agents!

14.2 Assemble

NOTE

→ The machine and machine parts are heavy!
→ At least 2 people are required to set up the machine.

The machine has been disassembled for transport and must be reassembled before use.

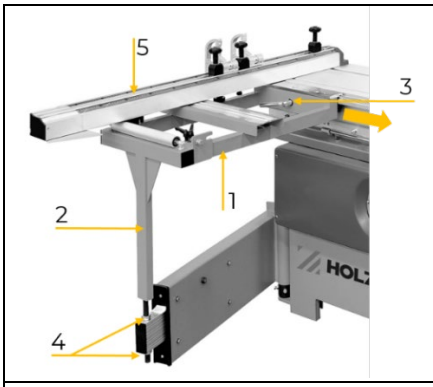


1. Sliding table

- Place the sliding table (1) on the machine and fix it at the fixing points (2) using screws, spring washers and plates (3). Do not tighten the screws before adjusting of the sliding table is finished.
- Level the edge of the sliding table with that of the work table (using a spirit level) until it is horizontally aligned without gaps.

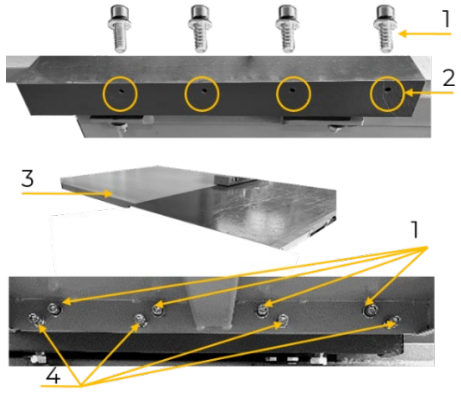
NOTE: Over the entire length, the distance between the two table edges must be within 12mm. Furthermore, it should be aligned exactly to the rip fence / saw blade.

- Then tighten the screws.



2. Outrigger table

- Push the groove stone of the outrigger table (1) into the groove of the sliding table.
- Place the holder of the outrigger table on the swivel arm support (2).
- Tighten the clamping lever (3) of the outrigger table to fix the position.
- Adjust the horizontal alignment with the adjusting screws (4).
- Align the pivot mount of the crosscut fence (5) with the front or rear hole of the outrigger table and fix it in desired position.

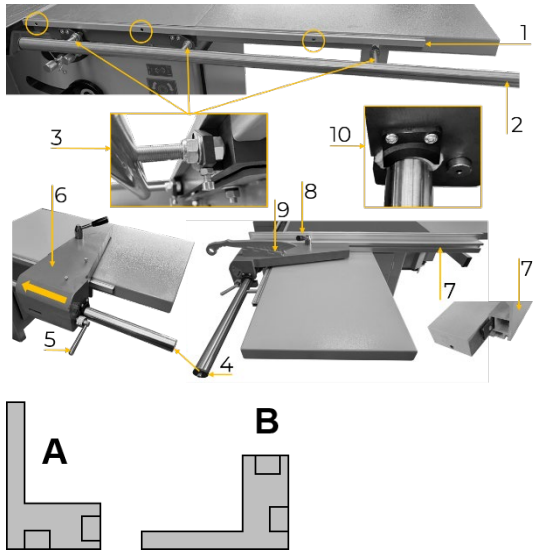


3. Table widening

- Remove the screws, spring washers and washers (1) from the threads (2) in the worktable
- Position the table extension (3) and table widening (3a) on the worktable as shown
- Fix screws, spring washers and washers
- Check alignment and adjust table if necessary

Table settings:

- Loosen the screws (1) slightly
- Adjust and fix plane and horizontal alignment with set screws (4)
- Tighten the screws firmly.

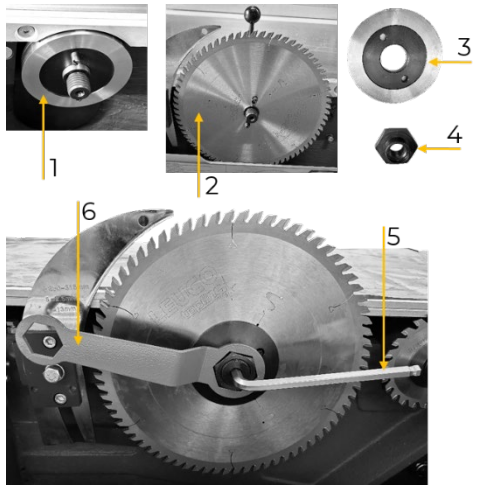


4. Rip fence

- Mount the ruler (1) and rip fence guide (2) as shown
- Adjust parallelism with screws and nuts (3)
- Disassemble the end stop (4)
- Set clamping lever (5) to position not fixed and slide the fence bracket (6) on the fence guide.
- Remount the end stop
- Slide the rip fence (7) on the guidance of the bracket.

NOTE: 2 possible positions.
Position A: for straight cuts
Position B: for angle cuts

- Fix the rip fence with the clamping lever (8) on desired position
- Mount the holder with the push stick (9)
- Mount the dirt wiper (10) as shown

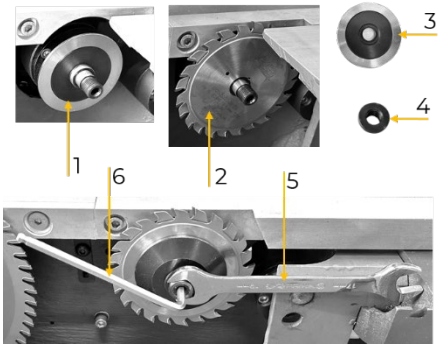


5. Saw blade

- Adjust the cutting height to the maximum possible level.
- Push the sliding table all the way foreward.
- Open the saw blade guard.
- Fix the drive shaft with the supplied Allen key (5) and loosen the flange nut (4) with the saw blade wrench (6) (left-hand thread!)
- Remove flange nut (4) and flange (3)
- Place the well cleaned shaft flange (1), saw blade (2), flange (3) and flange nut (4) on the drive shaft
- Fix the drive shaft with the supplied Allen key (5).
- Tighten the flange nut with the saw blade wrench (6) (left-hand thread!)

NOTE: min. tightening torque: 50Nm

- Close the saw blade guard.

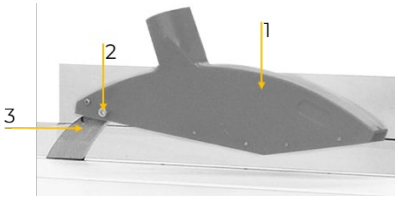


6. Scoring saw blade

- Adjust the cutting height to the maximum possible level
- Push the sliding table all the way foreward.
- Open the saw blade guard
- Fix the drive shaft with the supplied Allen screw (6) and loosen the flange nut (4) with the wrench (6) (right-hand thread!)
- Remove flange nut (4) and flange (3)
- Place the well cleaned shaft flange (1), saw blade (2), flange (3) and flange nut (4) on the drive shaft
- Fix the drive shaft with the supplied Allen screw (6).
- Tighten the flange nut with the saw blade wrench (5) (right-hand thread!)

NOTE: min. tightening torque: 25Nm

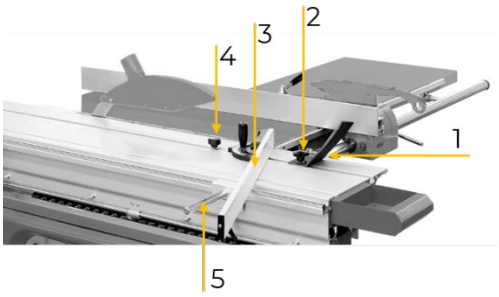
- Close the saw blade guard.



7. Saw blade guard

- Fix the saw blade guard (1) to the riving knife (3) with the locking screw (2).

NOTE: The saw blade guard should be positioned as close as possible to the workpiece.



8. Edging shoe

- Insert the edging shoe (1) into the groove of the sliding table and fix it in the desired position with star screw (2).

9. Mitre gauge

- Insert the mitre gauge (3) into the groove of the sliding table and fix it in the desired position with the knurled screw (4).

10. Handle sliding table

- Hook in the handle (5) and tighten it in desired position

14.3 Electrical connection

WARNING

Dangerous electrical voltage!

→ The machine may only be connected to the mains supply and the associated checks carried out by a qualified electrician or under the instruction and supervision of a qualified electrician!

- Check, whether the neutral connection and the protective grounding function 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 ±5 % is permissible.
A short-circuit fuse must be provided in the power supply system of the machine!

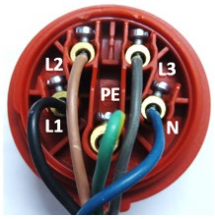
- Use a supply cable that fulfils the electrical requirements (e.g. H07RN, H05RN) and take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage.
- Make sure that the power supply is protected by a residual current circuit breaker.
- Connect the device only to a properly grounded outlet.
- 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.

14.3.1 Setting up a 400 V machine

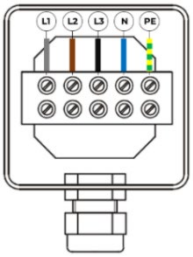
- The grounding conductor is yellow-green.
- Connect the supply cable to the corresponding terminals in the input box (L1, L2, L3, N and PE), see the figure below. If a CEE plug is available, the connection to the power supply is made through an appropriately powered CEE coupling (L1, L2, L3, N and PE).

Plug connection 400 V:

5-wire: **with** N-conductor



Input box:



- After the electrical connection, check the correct running direction. If the machine runs in the wrong direction, swap two conductive phases, e.g. L1 and L2, at the connection plug.

NOTE

→ Operation is only permitted with residual current device (RCD) with maximum residual current of 30 mA.

14.4 Connection to a dust collection system

The machine must be connected to a dust collection system for dust and chips. The dust collection system must start up at the same time as the machine's engine. The air speed at the suction connection and in the exhaust air lines must be at least 20 m/s for materials with a moisture <12 % (at least 28 m/s for moist chips with a moisture >12 %). The hoses used must be flame-retardant (DIN4102 B1) and permanently antistatic (or earthed on both sides) and comply with the relevant safety regulations. For information on air volume flow, negative pressure and suction connection, please refer to the technical specifications.

14.5 Settings

WARNING

Danger due to electrical voltage!

Handling the machine while it is connected to the power supply can lead to serious injuries or death.

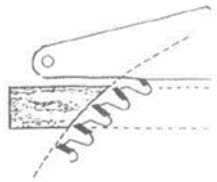
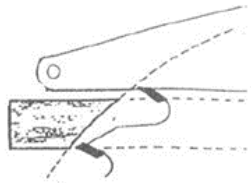
→ Always disconnect the machine from the power supply before carrying out adjustment or maintenance work and secure it against reconnection.

14.5.1 Saw blade

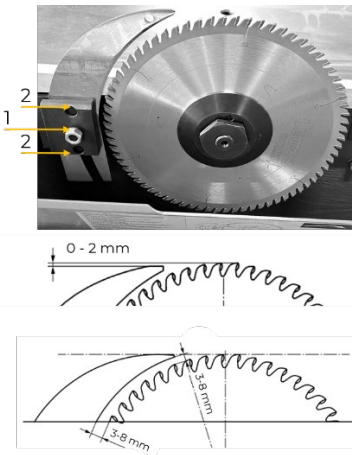
The material of the workpiece and the saw blade teeth are important criteria for a precise cutting result. Both the number of teeth and their shape, arrangement and position are associated with a specific function.

To improve the quality of the cut, always make sure that several teeth (at least 2-3) cut through the workpiece at the same time. If only one tooth is working, the result is a poor machining surface and the risk of kickback, vibrations and sound pollution increase.

Only work with a well ground saw blade!

 suitable saw blade	 unsuitable saw blade

14.5.2 Riving knife



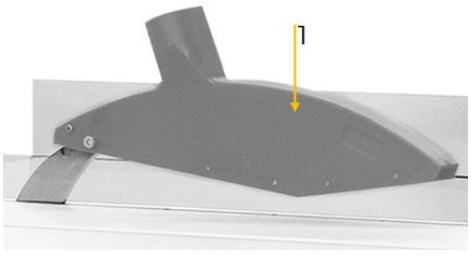
Adjust the distance and parallelism between the riving knife and the saw blade with the setting screws

- To do this, loosen the nut (1) slightly
- Make adjustments with setting screws (2)
- Retighten the nut

NOTE: The distance between the saw blade and the top of the riving knife must be within 0-2 mm.

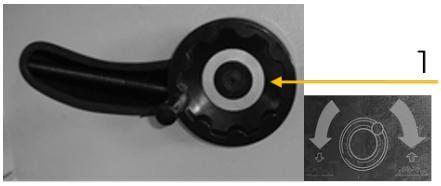
NOTE: The distance between the saw blade and the riving knife must be always within 3-8 mm.

14.5.3 Saw blade guard



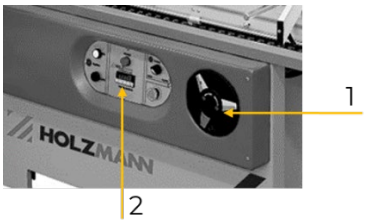
Adjust the saw blade guard (1) so that the saw blade is protected. The distance between the saw blade guard and the workpiece should be max. 5 mm.

14.5.4 Saw blade height adjustment



Turn the hand wheel (1) clockwise to lift the saw blade upwards. Turn the hand wheel counterclockwise to lower the saw blade. The height of the saw blade must be adjusted so that the teeth hit the top of the work-piece.

14.5.5 Adjustment of the saw blade tilt

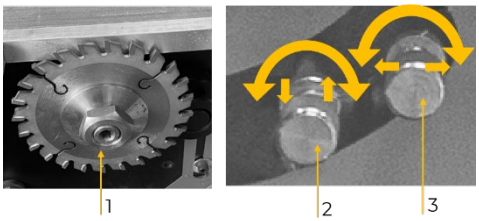


Turn the hand wheel (1) clockwise to tilt the saw blade. Turn the hand wheel counterclockwise to move the saw blade in a vertical position again. The saw blade can be tilted from 0° to 45°. The current position can be seen on the display (2).

NOTE

After adjusting the saw blade tilt, adapt the rip fence and/or the cross-cut fence so that they do not become contact with the tilted saw blade.

14.5.6 Scoring saw blade

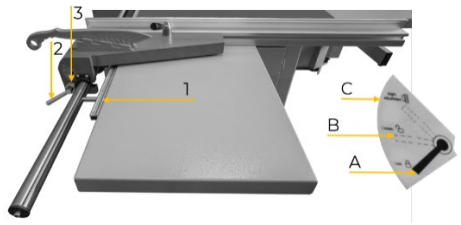


Heihght of the scoring saw blade (1)
- Turning the setting wheel (2) to the left ⬇.
- Turning the setting wheel (2) to the right ⬆.

Lateral adjustment oft he scoring saw blade(1)
- Turning the setting wheel (3) to the left ⬅.
- Turning the setting wheel (3) to the right ➡.

NOTE: When using the scoring blade, the height must be adjusted so that it cuts a slot with a depth of 1.5 - 2mm.

14.5.7 Adjustment of the cutting width at rip fence



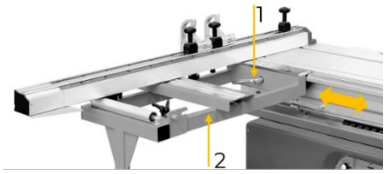
The cutting width can be adjusted on the rip fence and can be read off the ruler (1).
- Claming lever (2) in position A:

Rip fence locked
- Claming lever (2) in position B:

rip fence unlocked and moveable
- Claming lever (2) in position C:

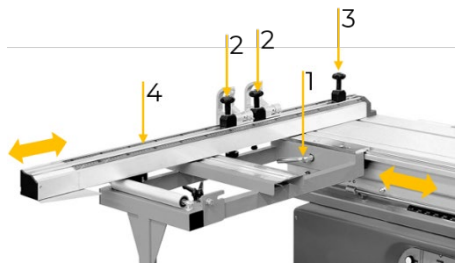
Make fine adjustment using knurled screw (3)

14.5.8 Adjustment outrigger table

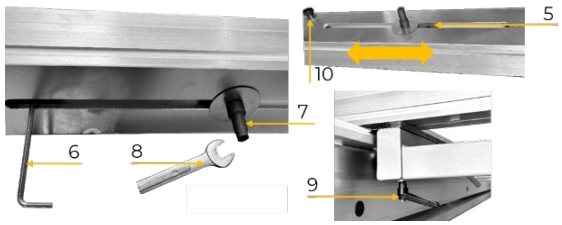


After loosing the clamping lever (1), the outrigger table (2) can be moved along the slot in the sliding table. After reaching the desired position, tighten the clamping lever again.

14.5.9 Cross cut fence



- Position the outrigger table by loosening the clamping levers (1) and pushing the outrigger table into position.
- Adjust the crosscut fence by loosening the clamping screws (2) and moving the flip stops.
- Read off the set measurement from the scale (4).
- Extend the cross-cut fence by loosening the locking knob (3) and pulling out the.
- Tighten the locking knob again.



NOTE: If the workpiece extends more than 1200 mm to the left beyond the saw blade, the cross-cut fence must be extended.

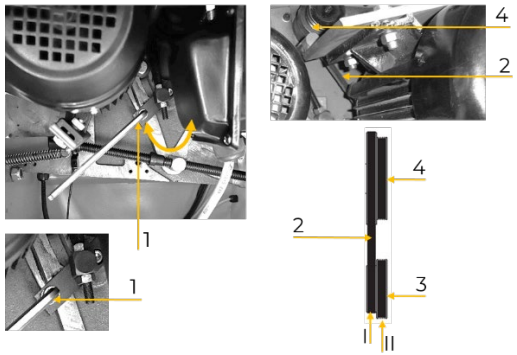
Adjusting the distance to the saw blade:

- Remove crosscut fence
- Loosen groove stone (5) and pivot mount (7) with Allen key (6) and wrench (8).
- Reassemble crosscut fence and fix in desired position with clamping lever (9).

NOTE: The groove stone can be fixed to define a specific position

- Adapt scales to the distance after loosening the fixing screws (10)

14.5.10 Saw blade speed



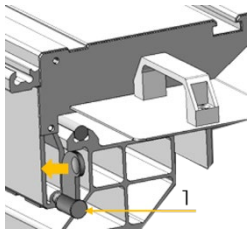
- Open the maintenance door
- Insert Allen key into motor tensioning screw (1), push tensioner to the left to release belt tension
- Position drive belt (2) on corresponding motor belt pulley (3) and drive belt pulley (4)

Position I: see techn. data

Position II: see techn. data

- Push the motor tensioner back to the right
- Check belt tension and adjust if necessary
- Close the maintenance door

14.5.11 Lock of sliding table



The sliding table is secured laterally with a lever (1) against accidental movement.

To loosen the locking, pull the lever out of the fixation.

15 OPERATION

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

15.1 Operating instructions

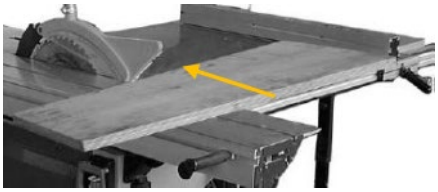
- Make sure that the saw blade used matches the set speed of the machine and that the diameter of the saw blade is compatible with the machine.
- Cracked and deformed saw blades cannot be repaired. They must be replaced immediately with new saw blades.
- Make sure that the machine works without vibrations.
- Always use the riving knife and the saw blade guard. Make sure that the riving knife, the saw blade guard and the height of the saw blade are positioned correctly. The riving knife must always be aligned with the workpiece. Otherwise there is a risk that the workpiece will stick and cause kickback.

- Make sure that the workpiece is in a stable position on the table and is supported by either the rip fence or the outrigger table during cutting.
- Make sure that the work table and the sliding table are parallel to the saw blade.
- Never stand in the direct cutting line of the saw blade, do not hold any parts of your body in the cutting line. Keep the side of the saw blade whenever cutting.
- Never reach over or behind the saw blade with your hand while cutting.
- Avoid awkward operations and hand positions where a sudden slip could cause your hand to get caught in the rotating saw blade.
- When using the cross-cut fence, the workpiece should not touch the rip fence at the same time as cutting.
- Use the push stick if the distance between the saw blade and the ruler of the rip fence is less than 120 mm.
- Use the downholder to secure the workpiece.
- Guide the workpiece smoothly until the end of cutting.
- Avoid jerky movements and changing direction.

15.2 Types of cut

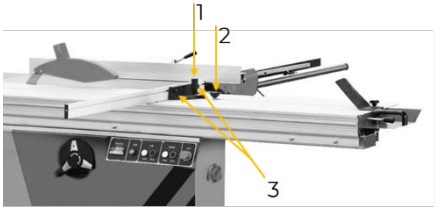
15.2.1 Workpiece size

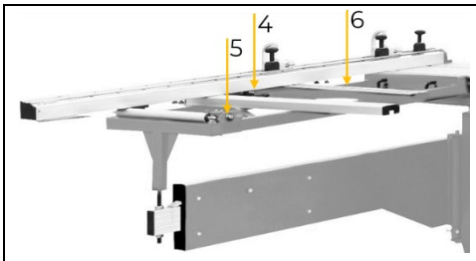
Larger workpieces are moved by pushing the sliding table with little effort. Smaller workpieces can be pushed over the stationary table top, as with a table saw.

 Symbolpicture	**Large workpieces** - Adjust the rip fence or the cross-cut fence. If necessary, pull out the cross-cut fence. - Use the downholder to fix the workpiece. - Use the sliding table to move the workpiece. - For removal widths less than 120 mm, use the push stick. - Angle: Adjust the angle with the cross-cut fence.
 Symbolpicture	**Smaller workpieces** - For smaller workpieces, use the mitre gauge. Set the mitre gauge to 90° to the saw blade and place the workpiece against it. The rip fence can be used to support this. - Use the pushing stick. - Push the workpiece evenly with the pushing stick. - Angle: Set the angle with the mitre gauge. You can fix the angle stop in the groove of the worktable or the sliding table.

15.2.2 Mitre cuts

Depending on the workpiece size, set the desired angle on the mitre fence or on the cross-cut fence.

 Symbolpicture	**Mitre gauge** - Loosen the locking screw (1) and set the desired angle. Fix the locking screw again. - Loosen the knurled screw (2) and position the mitre gauge. Tighten the knurled screw again. - If necessary, loosen the clamping screws (3) and move the fence. Tighten the clamping screws again.

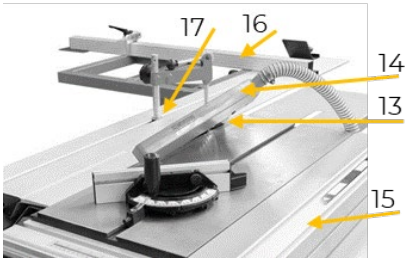


Symbolpicture

Cross cut fence

- Depending on the workpiece size and angle, select a rotation point in the outrigger table and fix the cross-cut fence.
- Loosen clamping lever (4) and star screw (5).
- Adjust the angle of the cross cut fence
- Read off the set angle on the scale (6).
- Fix clamping lever (4) and star screw (5).
- Fix the workpiece with the downholder.
- Use the sliding table to move the workpiece evenly.

15.2.3 Angled cuts with inclined saw blade

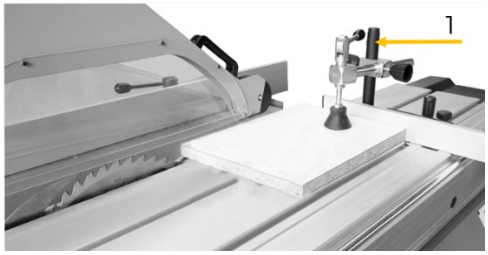


Symbolpicture

- Adjust the desired inclination of the saw blade (13).
- Adjust the saw blade guard (14).
- Adjust the rip fence (15) or the cross-cut fence (16).
- Fix the workpiece with the downholder (17).

15.2.4 Longitudinal cut of boards

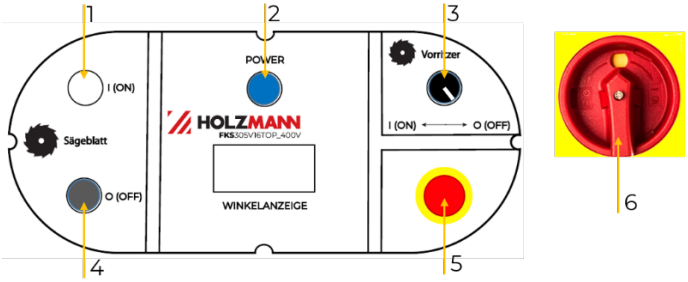
Use the down holder for cutting and fixing boards and avoiding a kickback.



- Mount the down holder (1) in the groove of the sliding table.
- Set the desired dimension with the rip fence or the cross-cut fence.

15.3 Operating

15.3.1 Switch the machine on and off



Switch on the machine:

1. Turn main switch (6) to position I (ON).

NOTE: Power indicator light (2) lights on.

2. The main saw blade starts after pushing the button (1) I(ON).
3. The scoring saw blade starts after turning the switch (3) to position I(ON).

NOTE: The scoring swaw blade can only be started when the main saw blade is activated.

Switch off the machine:

Normal switch-off:

1. After finishing cutting, switch off the saw by pushing the button (4) 0(OFF).and turning the switch (3) to positon 0(OFF).
2. After finishing work, turn the main switch (6) to position 0(OFF).

Switching off in emergency situations:

Press the emergency stop (5).

CAUTION: The emergency stop (5) can only be unlocked after the emergency situation has been eliminated.

15.3.2 Cutting

- Operating instructions read and followed
- Type of cut and appropriate machine setting selected.
- Switch on the machine
- Wait until saw blade has reached full speed (approx. 10 sec.)
- Carry out cut(s)
- Switch off the machine
- Wait until the machine has come to a complete standstill before moving any bodypart into the danger area (saw blade) or moving away from the machine.

15.3.3 End operation

NOTE

When the work is finished, the machine must be switched off.

→ Lower the complete saw blade and the scoring saw blade

→ Switch-off the main switch to disconnect the machine from the power supply.

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.

CAUTION

→ Wear protective cutting gloves when handling the saw blade and scoring blade to reduce the risk of injury!!

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.

- After each work shift, clean the machine and all its parts thoroughly.
- Vacuum the wood chips and sawdust. Wipe off any remaining dust with a dry cloth.
- Use a resin-dissolving cleaner for resin build-up.
- 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.

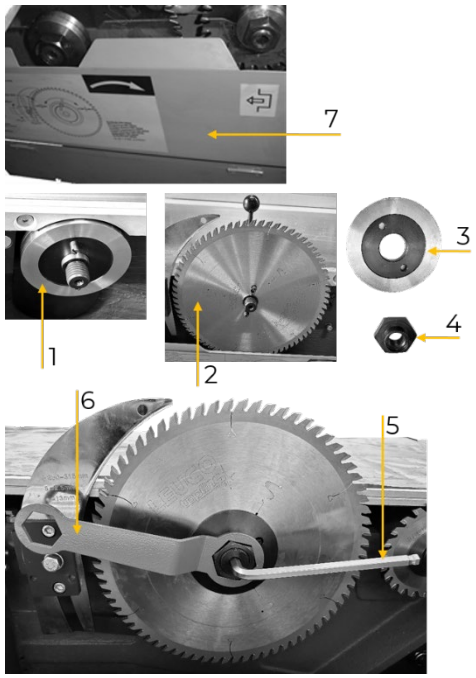
- Check the condition and tight fit of the saw blade and the saw blade guard before every operation.
- Regularly check the perfect and legible condition of the warning and safety labels of the machine.
- Use only proper and suitable tools.
- Use only original spare parts recommended by the manufacturer.
- Repair work may only be carried out by qualified personnel.

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
Before usage	• Machine	• Clean
	• Loose fixing bolts, screws	• Check for tight fit, tighten if necessary
	• Control panels, display	• Check for function, replace if necessary
Once a week	• Guide track and roller guide of sliding table and rip fence	• Clean, blow out
	• Moving parts	• Lubricate
Once a month	• Maintenance room	• Vacuum chips • Clean the motor housing
If necessary	• Saw blade, scoring saw blade	• Change
	• V-belt	• Change

16.2.2 Assembly / exchange saw blade



- Adjust the cutting height to the maximum possible level.
- Set the saw blade to 90°.
- Push the sliding table all the way foreward.
- Open the saw blade guard (7).
- Fix the drive shaft with an Allen key (5).
- Loosen the flange nut (4) with the saw blade wrench (6) (left-hand thread!)
- Remove flange nut (4), flange (3) and saw blade (2) from the drive shaft.
- Clean the drive shaft, shaft flange (1) and all parts thoroughly from impurities
- Replace the old saw blade with a new one.
- Make sure that the new saw blade is undamaged and not dirty.
- Place the saw blade (2), flange (3) and flange nut (4) on the drive shaft.
- Fix the drive shaft with an Allen key (5).
- Tighten the flange nut with the saw blade wrench (6) (left-hand thread!)

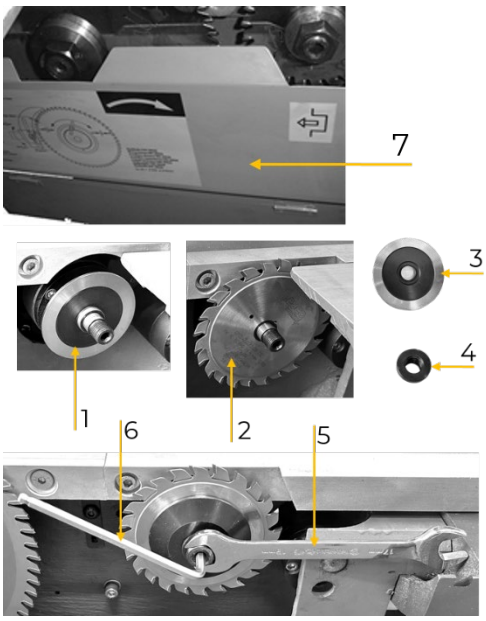
NOTE: Retighten the flangenut tightly to prevent the nut from loosening during operation.
(tightening torque: 50Nm)

- Close the saw blade guard.
- Bring the sliding table back into position.

NOTE

Adjust the riving knife and the saw blade guard after each saw blade change.

16.2.3 Assembly / exchange / adjustments scoring saw blade

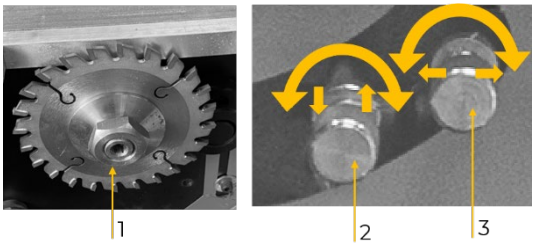


- Adjust the cutting height to the maximum possible level.
- Set the saw blade to 90°.
- Push the sliding table all the way foreward.
- Open the saw blade guard (7).
- Fix the drive shaft with the supplied Allen key (6).
- Loosen the flange nut (4) with the saw blade wrench (5) (right-hand thread!)
- Remove flange nut (4), flange (3) and scoring saw blade (2) from the drive shaft.
- Clean the drive shaft, the shaft flange (1) and all parts thoroughly from impurities
- Replace the old scoring saw blade with a new one.
- Make sure that the new scoring saw blade is undamaged and not dirty.
- Place the scoring saw blade (2), flange (3) and flange nut (4) on the drive shaft.
- Fix the drive shaft with the supplied Allen key (6).
- Tighten the flange nut with the saw blade wrench (5) (right-hand thread!)

NOTE: Retighten the flangenut tightly to prevent the nut from loosening during operation.

(tightening torque: 25Nm)

- Close the saw blade guard.
- Bring the sliding table back into position.



NOTE: The height of the scoring blade must be adjusted so that it cuts a slot of a depth of 1.5 - 2mm.

The scoring saw blade has to be oriented exactly to the main saw blade

Adjustments:

- Adjust main saw blade to 90°

Heihght of the scoring saw blade (1)

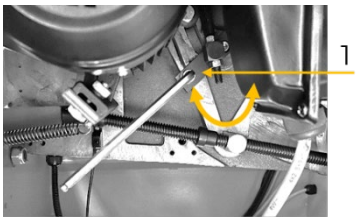
- Turning the setting wheel (2) to the left ⬇.
- Turning the setting wheel (2) to the right ⬆.

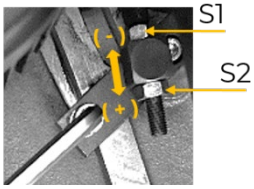
Lateral adjustment oft he scoring saw blade(1)

- Turning the setting wheel (3) to the left ⬅.
- Turning the setting wheel (3) to the right ➡ .

16.2.4 Checking / adjusting / replacing belt

For optimum power transmission, the belt must be free of cracks and frays and have optimum tension. Check the condition of the belt at least every 3 months, more frequently if used daily. Broken or frayed belts must be replaced. To check/adjust or replace the belt, open the maintenance door.

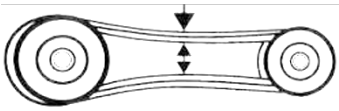




NOTE

Do not over-tension the belt! Tension the belt only until sufficient power transmission is ensured.

max. 2-5mm



Increase belt tension:

Loosen nut (S1) and unscrew slightly. With the nut (S2) the motor can now be shifted in the direction (+) of more belt tension.

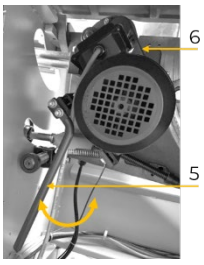
When correct tension is reached. Tighten the nut (S1) firmly again.

Decrease belt-tension:

Loosen nut (S2) and unscrew slightly. With the nut (S1) the motor can now be shifted in the direction (-) of less belt tension.

When correct tension is reached. Tighten the nut (S2) firmly again.

For changing the belt insert Allen key into motor tensioning screw (1), push tensioner to the left to release belt tension completely, pull the belt over the pulleys and insert new belt. Push the motor tensioner back to the right and establish correct belt tension again.

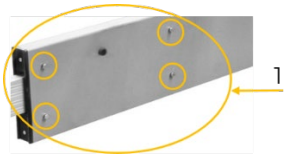


Scoring saw blade:

- Lift the motor (5)
- Replace the old belt (6) with a new one.
- Position new belt

After completion, close the maintenance door.

16.2.5 Swivel arm guide rollers



Cleand swivel arm
By turning the 4 screws (1) you can close or move away the eccentric guide rollers and adjust a smooth running

16.3 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.

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.

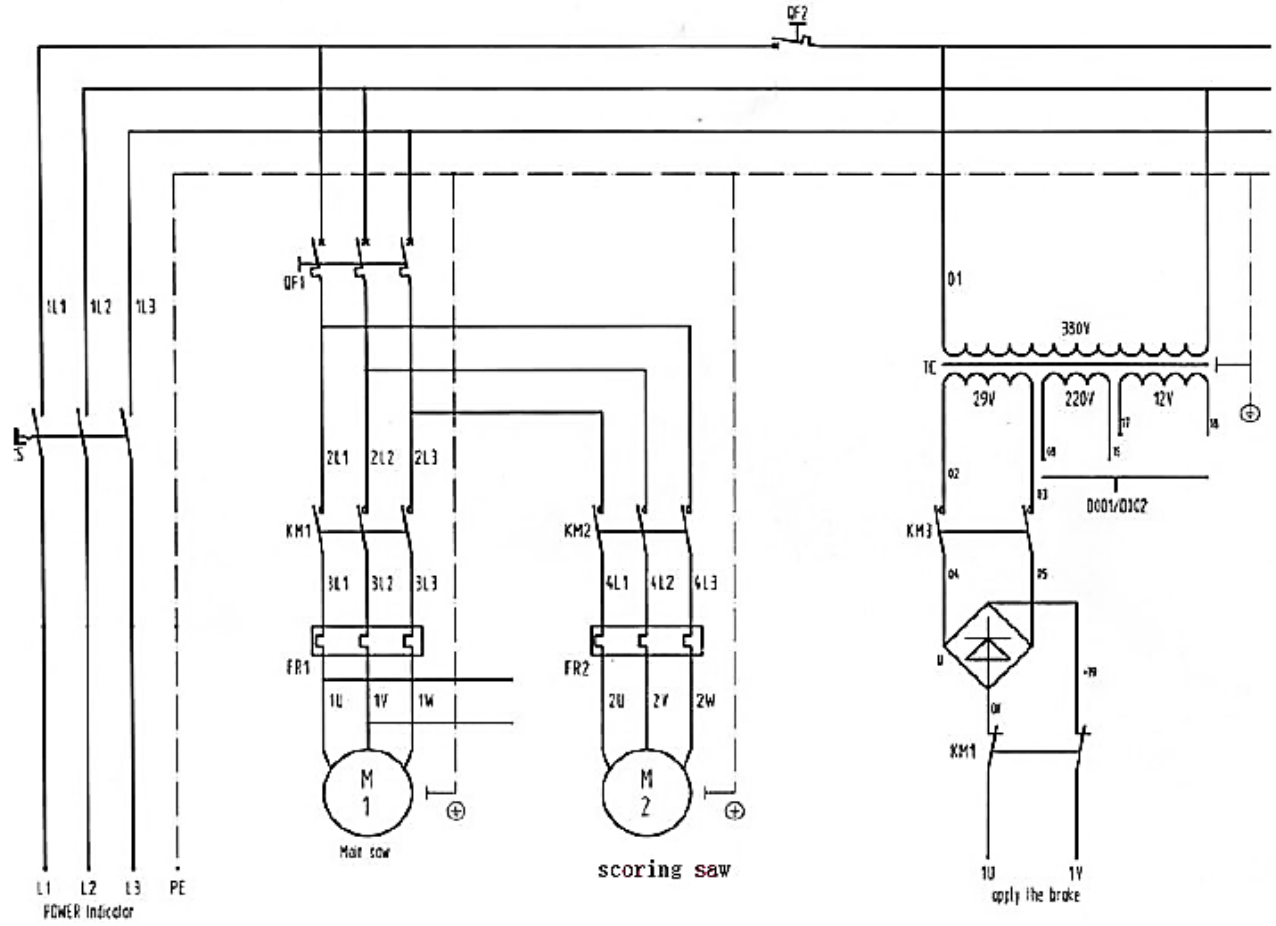
→ Disconnect the machine from the power supply before starting work to eliminate defects!

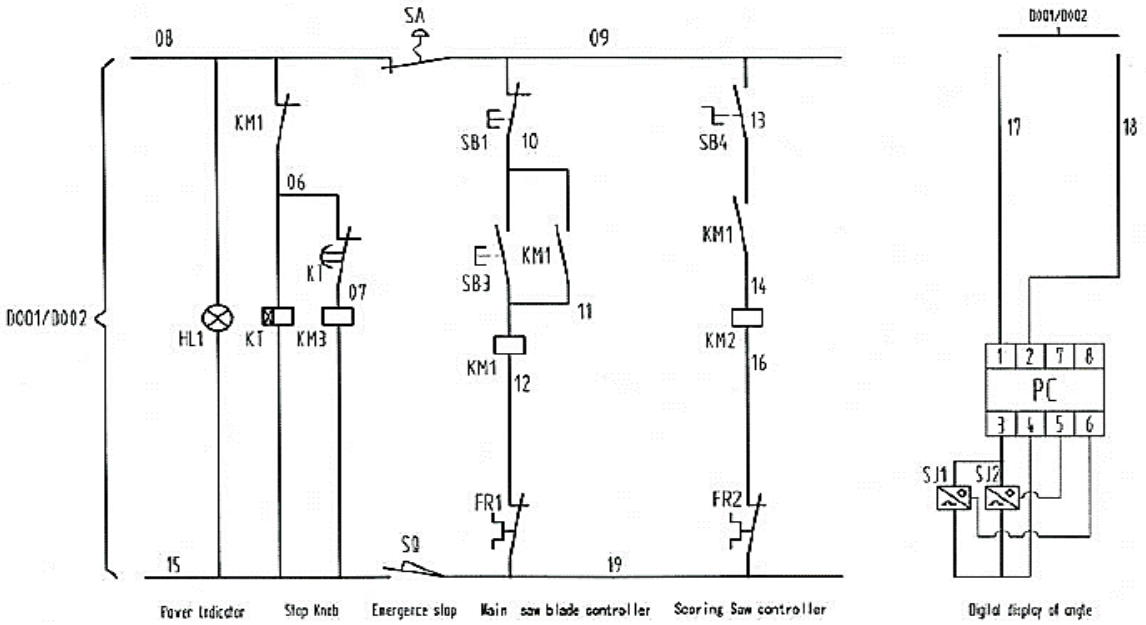
Many possible sources of error can be eliminated in advance if the machine is properly connected to the power supply.

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
Motor does not run	• Switch defective • Saw blade guard not completely closed – limit switch • Electrical system defective • Emergency stop is activated	• Repair switch • Close the saw blade guard well so that the limit switch is activated and push the reset button to confirm. • Check main cable, plug and motor; repair or replace, if necessary • Check fuse • Deactivate the emergency stop
Burn marks on the workpiece	• Blunt saw blade	• Change saw blade
Finished dimension of the workpiece does not correspond to the cutting width set on the rip fence	• Dimension scale for the cutting width misaligned	• Reset the zero point of the rip fence
Workpiece clamps when being pushed forward	• Blunt saw blade • Riving knife does not match to the saw blade used	• Change saw blade • Riving knife thickness must be equal to or greater than saw blade thickness
Loud, repetitive noises from the machine	• Set screws or keys are loose • Motor fan hits cover • V-belt defective	• Tighten or replace set screws or keys • Tighten motor fan and cover • Replace V-belt
Machine slows down during operation	• Too much pressure to the workpiece • Loose V-belt	• Feed the workpiece more slowly • Tension V-belt
Saw blade is not square or fence is not square to saw blade	• Table top or fence are not aligned parallel	• Align table parallel to saw blade
Scoring blade does not start	• Main saw blade is not started • V-belt defective	• Start main saw blade • Check V-belt and change if necessary

25 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM / SCHÉMA ELEKTRICKÉHO ZAPOJENÍ





26 ERSATZTEILE / SPARE PARTS / NÁHRADNÍ DÍLY

26.1 Ersatzteilbestellung / Spare parts order / Objednání náhradních dílů

(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.

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.

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.

(CZ) V podobě náhradních dílů HOLZMANN používáte náhradní díly, které jsou vzájemně zkoordinovány. Optimální přesnost lícování dílů zkracuje dobu montáže a prodlužuje životnost.

OZNÁMENÍ

Montáž jiných než originálních náhradních dílů způsobí ztrátu záruky! Proto platí: Při výměně komponent/dílů používejte jen výrobcem doporučené náhradní díly.

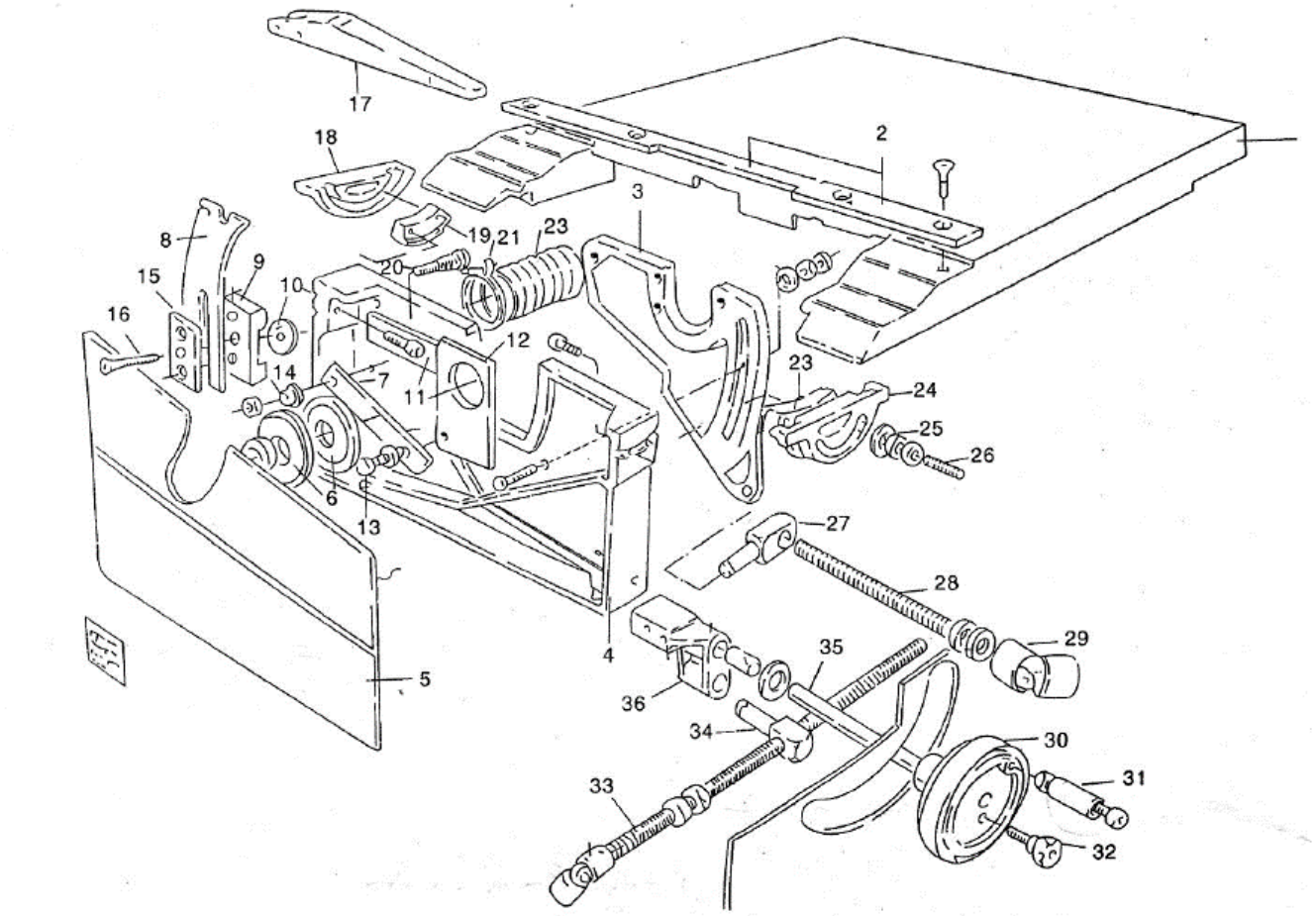
Náhradní díly objednávejte přímo na naší domovské stránce – kategorie NÁHRADNÍ DÍLY.
nebo kontaktuje náš zákaznický servis

- přes naši domovskou stránku – kategorie SERVIS – POŽADAVEK NÁHRADNÍCH DÍLŮ,
- e-mailem na service@holzmann-maschinen.at.

Vždy uveďte typ stroje, číslo náhradního dílu a označení. Abychom předešli nedorozumění, doporučujeme přiložit k objednávce náhradních dílů kopii výkresu náhradních dílů, na které jsou potřebné náhradní díly jasně označeny, pokud neprovádíte poptávku pomocí internetového katalogu náhradních dílů.

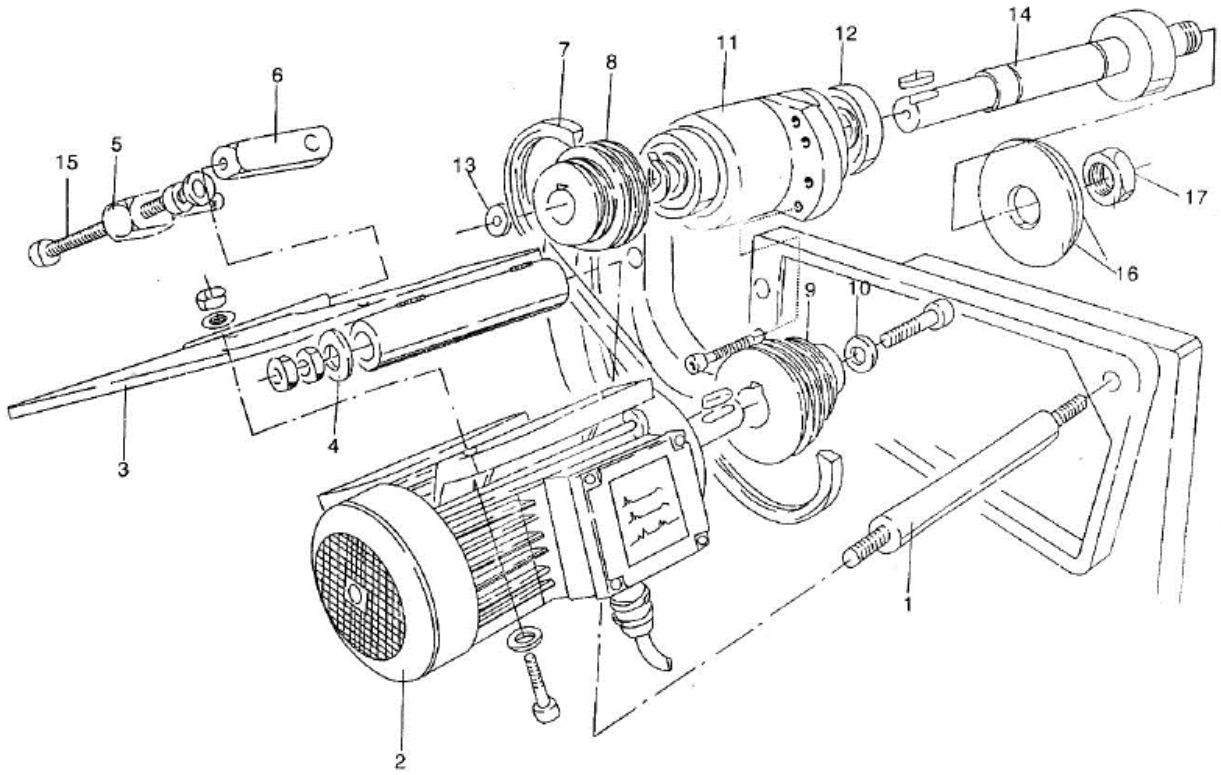
26.2 Explosionszeichnung / Exploded view / Výkres v rozloženém stavu

Fixed table and supporting and adjustment mechanism



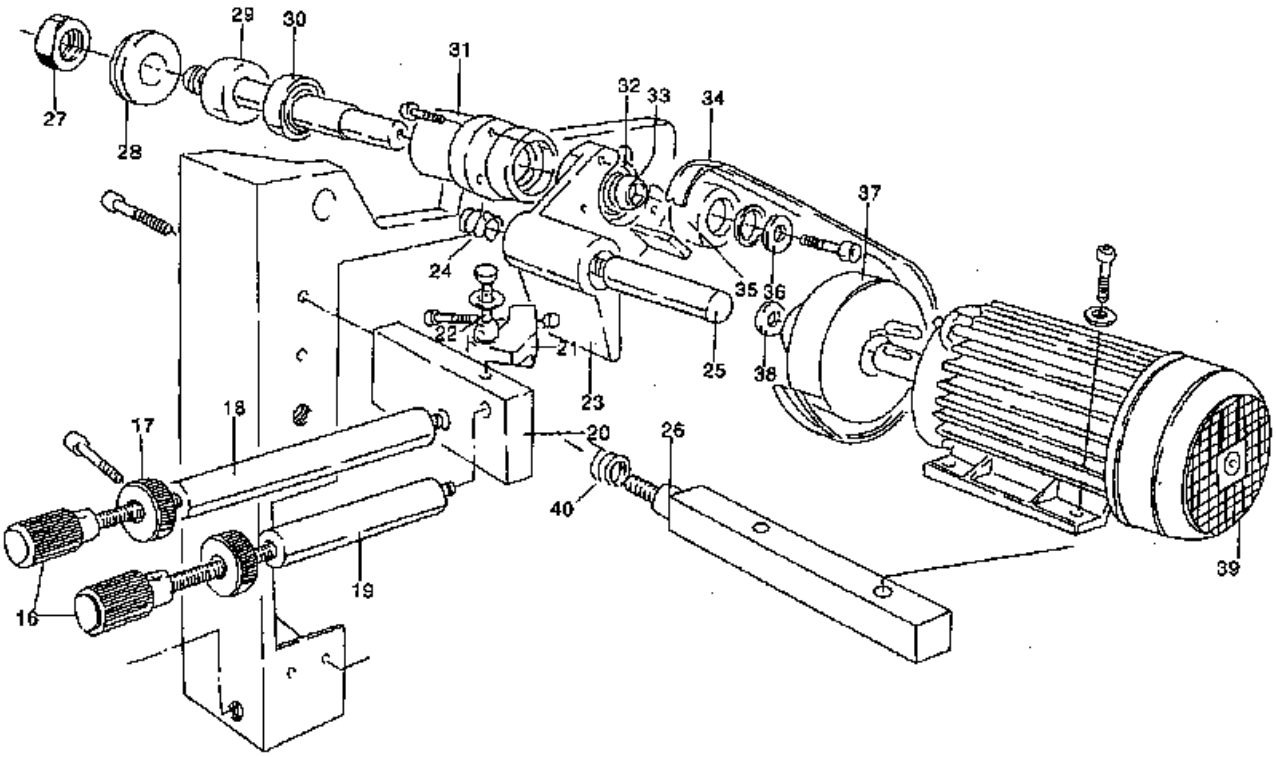
No.	Description	No.	Description
1	fixed table	**19**	guide track
2	protection boar	**20**	bolt
3	lift board	**21**	pipe block
4	connection board	**22**	dusct collection pipe
5	the cover of anti-dust	**23**	guide track
6	saw nipping plate	**24**	circumgyrating base
7	pulling board	**25**	cushion
8	riving knife	**26**	bolt
9	fixed board	**27**	lift nut
10	Nut	**28**	lift screw
11	connection board	**29**	gimbal
12	following action board	**30**	handwheel
13	bolt	**31**	handle
14	cushion	**32**	bolt
15	plate	**33**	angle bolt
16	bolt	**34**	angle nut
17	protection hood	**35**	lift adjusting spindle
18	circumgyrating base	**36**	adjusting base

Main saw



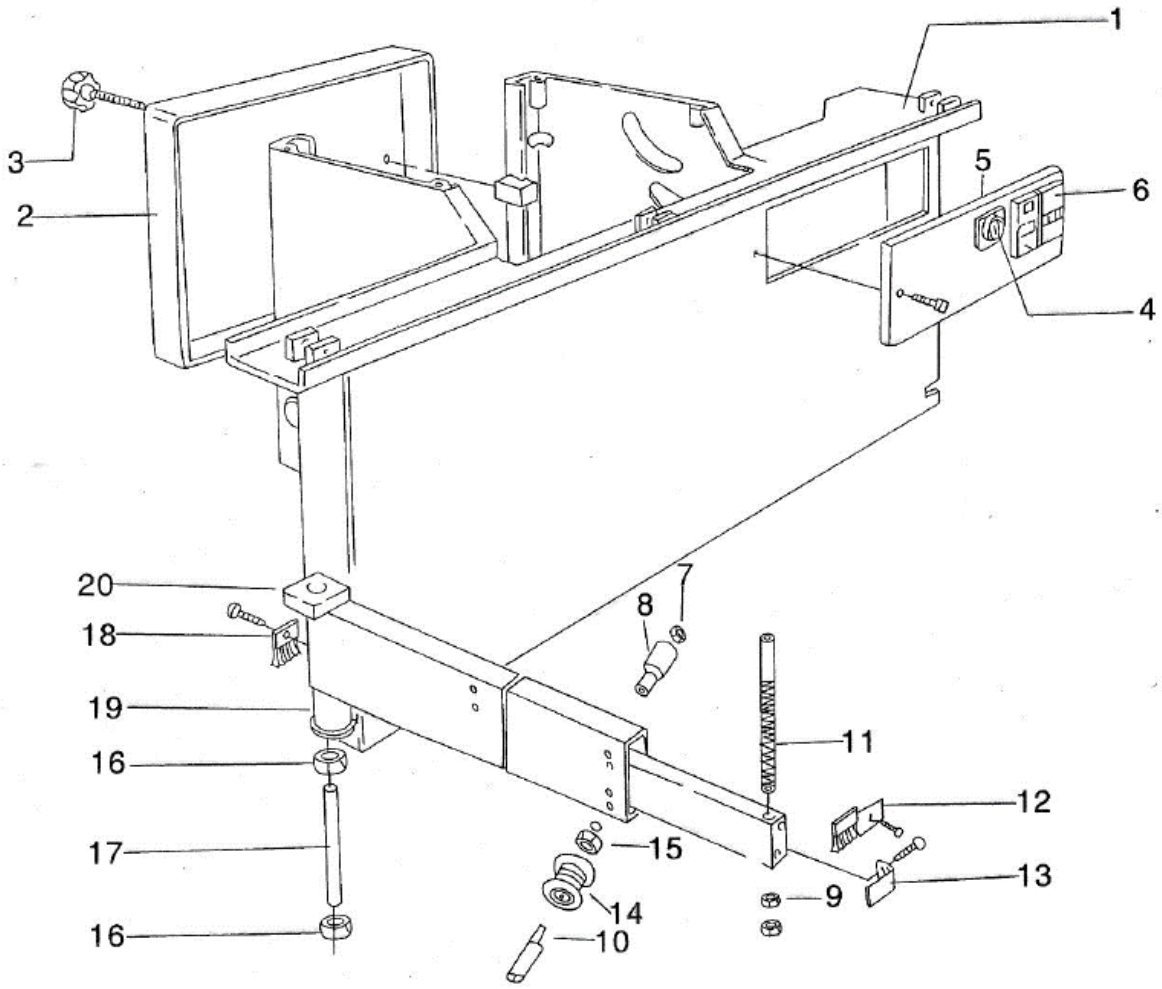
No.	Description	No.	Description
1	motor base spindle	**10**	pressure cushion
2	motor	**11**	main spindle sheath
3	motor base	**12**	bearing
4	cushion	**13**	pressure cushion
5	connection board	**14**	main spindle
6	adjusting sheath	**15**	adjusting screw
7	triangular belt	**16**	saw nip plate
8	main spindle wheel	**17**	nut
9	motor wheel	**18**	

Scoring saw



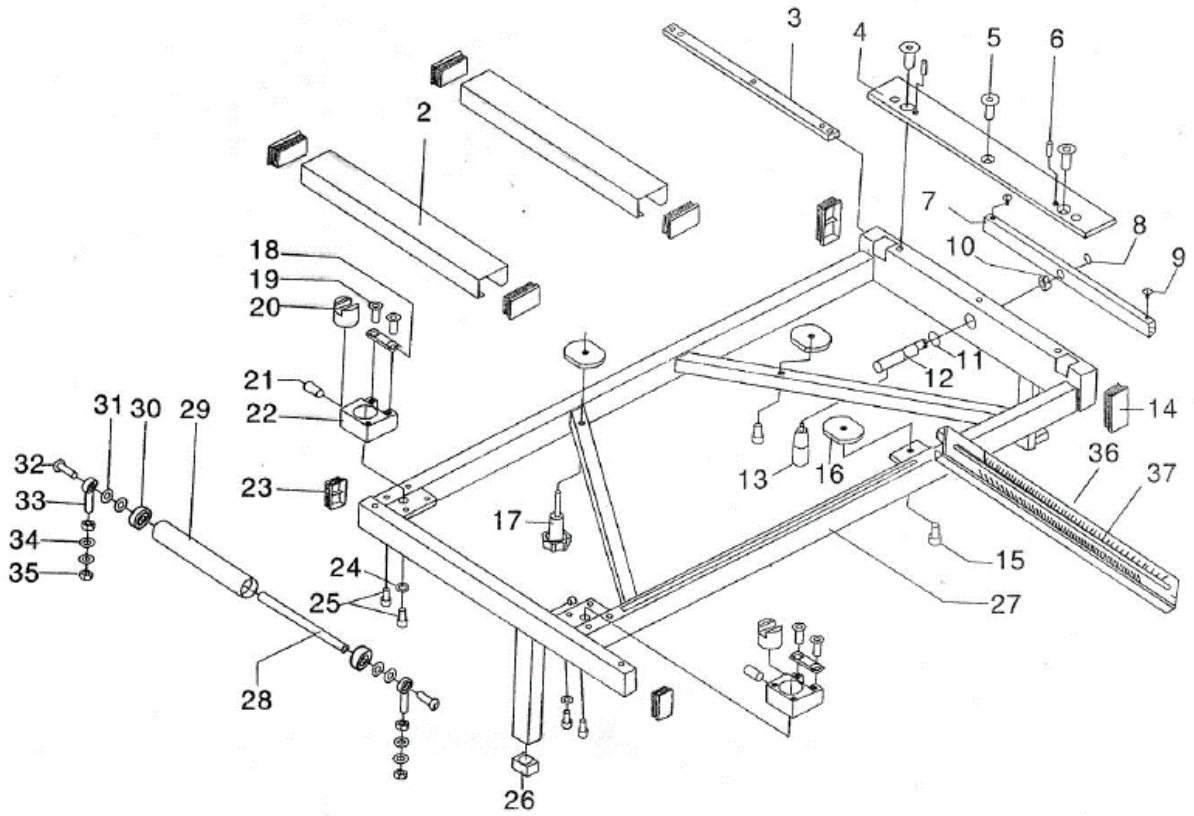
No.	Description	No.	Description
16	Inching handle	**29**	scoring saw spindle
17	lock nut	**30**	bearing
18	fixed sheath	**32**	scoring saw sheath
20	fixed base	**32**	bearing
21	feeding block	**33**	sheath
22	Bolt	**34**	driving belt
23	Scoring saw turning base	**35**	scoring saw wheel
24	Spring	**36**	pressure cushion
24	oriented spindle	**37**	motor wheel
26	motor base	**38**	pessure cushion
27	nut	**39**	motor
28	pressure cushion	**40**	torsion spring

Machine body and turning arm



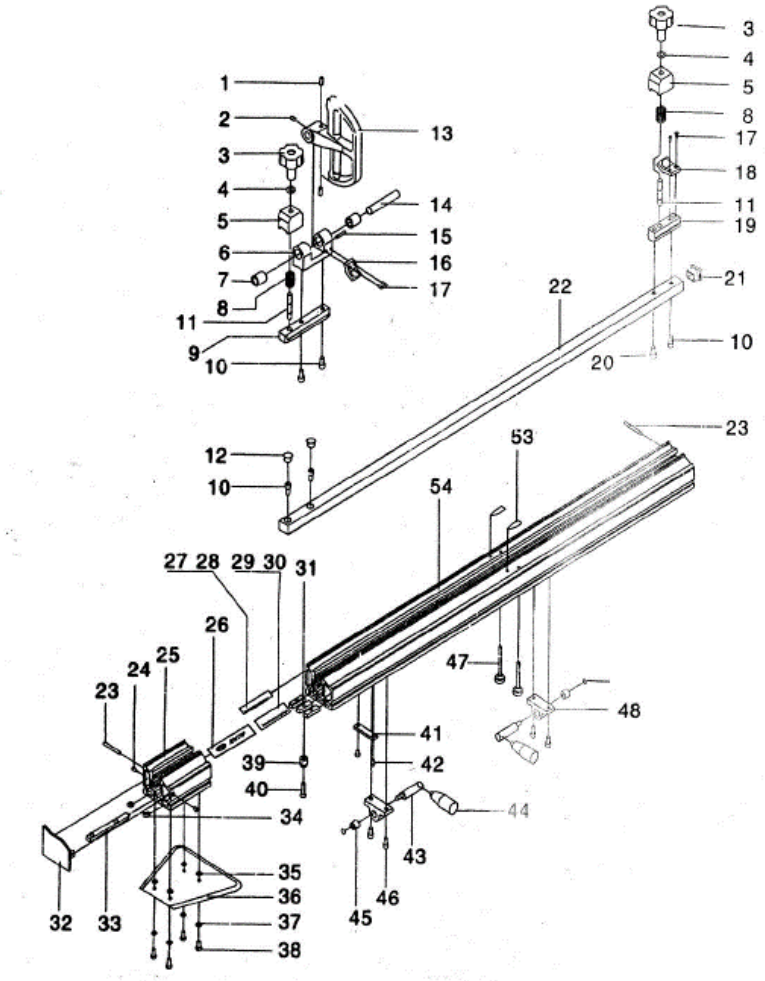
No.	Description	No.	Description
1	machine body	**11**	adjusting spindle
2	door cover	**12**	brush
3	Bolt	**13**	Stop head
4	Urgent stop switch	**14**	Roll wheel
5	Board base	**15**	Bearing
6	Operation button	**16**	Bearing
7	Nut	**17**	Spindle of turning arm
8	Sheath	**18**	Brush
9	Nut	**19**	Turning arm pipe
10	Eccentric spindle	**20**	lug

Outrigger-table



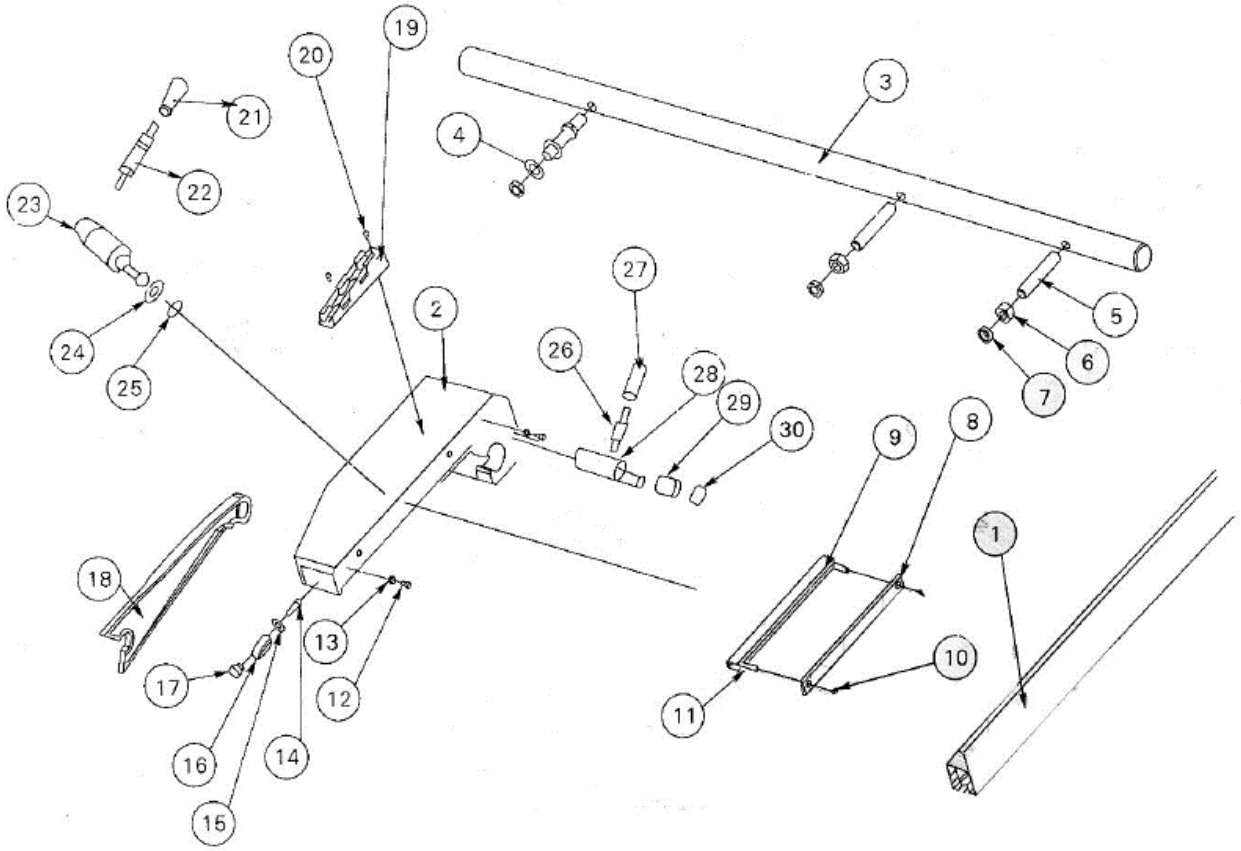
No.	Description	No.	Description
1	Plug	**20**	Adjustment screw
2	Holding plate	**21**	Limit shaft
3	Reinforcing plate	**22**	Seat board
4	V-groove	**23**	Cap
5	Screw	**24**	Pad
6	Stabilizer nail	**25**	Stud
7	Lock block	**26**	Ejector block
8	Clip	**27**	Bracket
9	Screw	**28**	Shaft
10	Pad	**29**	Carriage roller
11	Pad	**30**	Bearing
12	Eccenttric shaft	**31**	Nut
13	Handle	**32**	Cap
14	Plug	**33**	Support
15	Screw	**34**	Pad
16	Platen	**35**	Nut
17	Revolving shaft handle	**36**	Angle scale seat
18	Pad board	**37**	Angle scale
19	screw		

Crosscut fence + stop



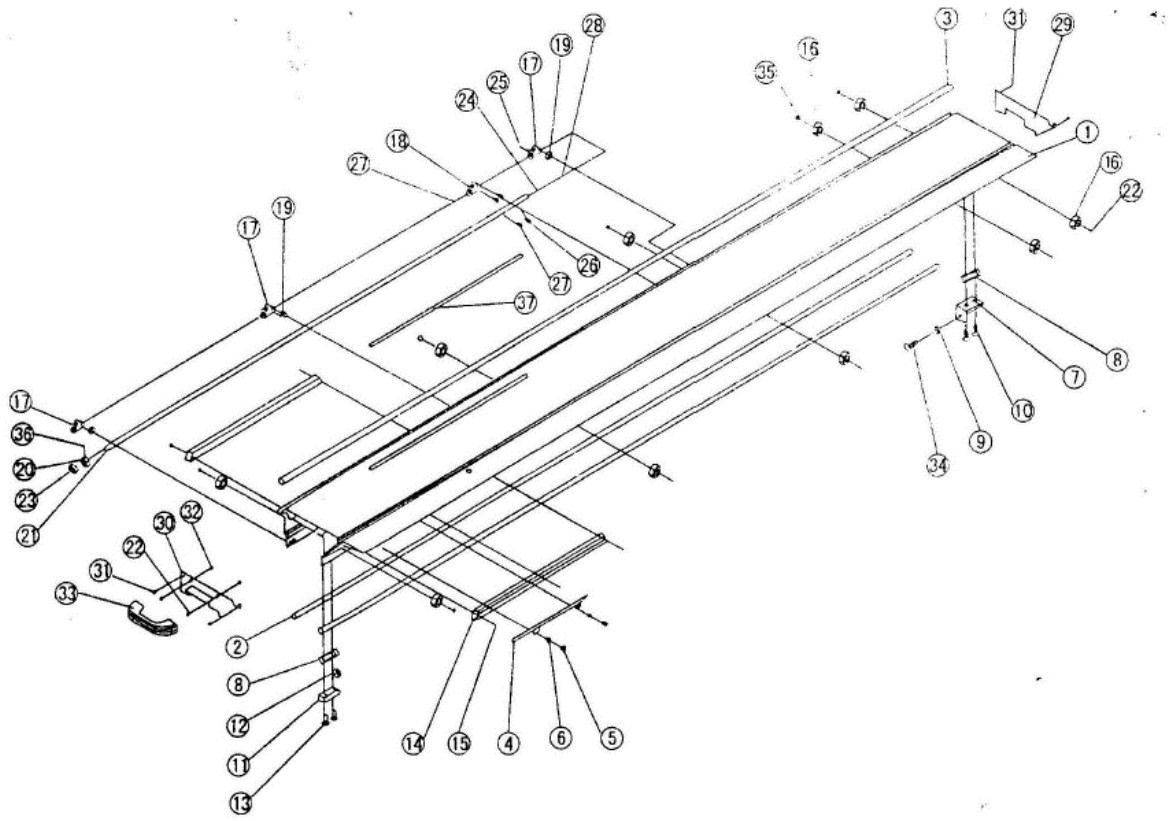
No.	Description	No.	Description	No.	Description
1	Adjustment bole	**17**	Screw	**35**	Pad
2	Fixing bolt	**18**	Magnifier	**36**	Holding plate
3	Locking handle	**19**	Fixing block	**37**	Pad
4	Pad	**20**	Screw bolt	**38**	Screw
5	Handle seat	**21**	Plug	**39**	Sleeve
6	Baffle seat	**22**	Draw rod	**40**	Screw
7	Copper sleeve	**23**	Stabilizer nail	**41**	Board
8	Spring	**24**	Screw	**42**	Screw
9	Fixing block	**25**	Extension ruller	**43**	Eccentric shaft
10	Screw bolt	**29**	Ruler	**44**	Handle
11	Shaft	**30**	Ruler	**45**	Sleeve
12	Plug	**31**	Fixing block	**46**	Screw
13	Stop board	**32**	Plug	**47**	Hand screw
14	Shaft	**33**	Fixing block	**48**	Lug
15	Screw	**34**	nut	**49**	lip
16	Magnifier				

Rip-fence



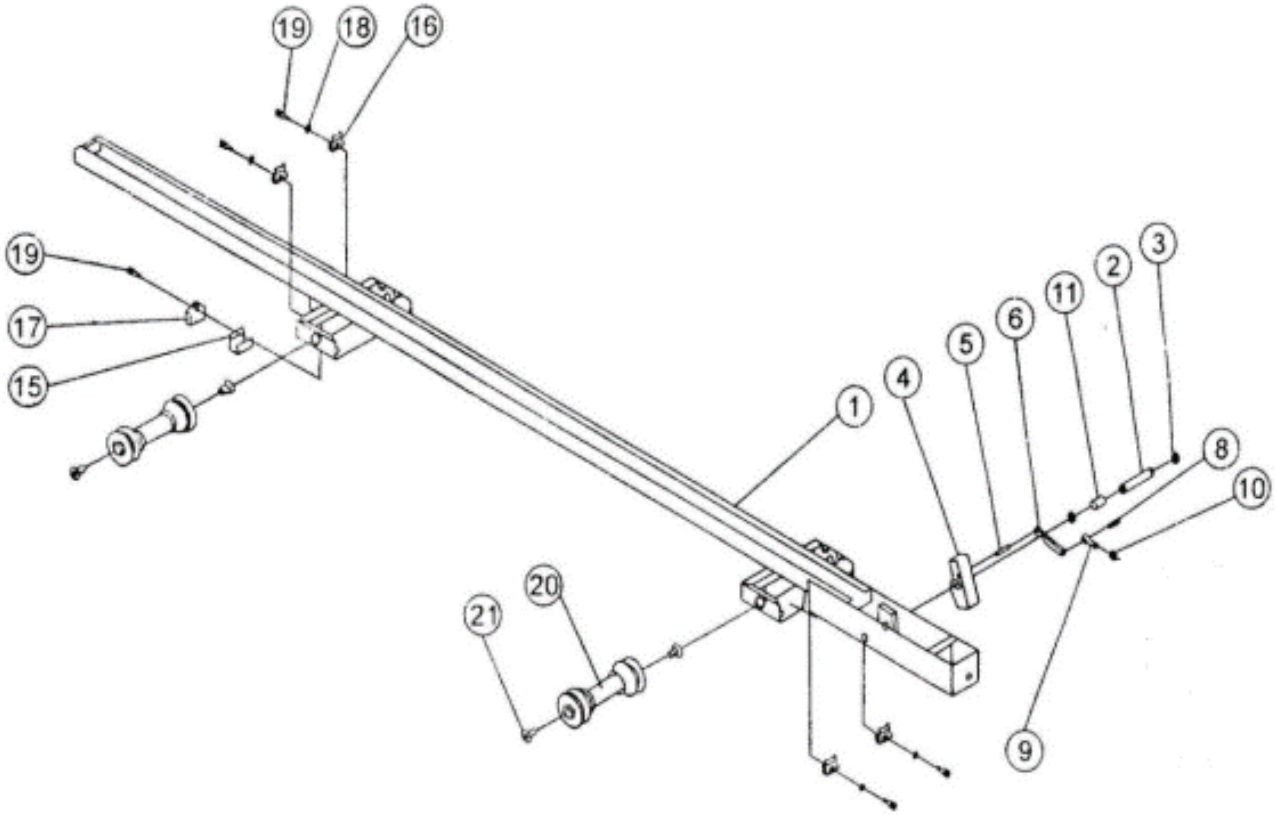
No.	Description	No.	Description
1	Rip-fence	**16**	Idler wheel
2	Cam axle (guide shaft axle)	**17**	Spacing sleeve
3	Cam seat (guide plate seat)	**18**	Push handle
4	Pad	**19**	Push handle seat
5	Supporting bolt	**20**	Screw
6	Screw cap	**21**	Handle
7	Screw cap	**22**	Handle shaft
8	Lock plate	**23**	Eccentric shaft
9	Board	**24**	Pad
10	Screw	**25**	Clip
11	Shaft	**26**	Handle shaft
12	Screw	**27**	Handle
13	Eccentric sleeve	**28**	Eccentric shaft
14	Small shaft	**29**	Sleeve
15	pad	**30**	clip

Sliding table (top carriage)



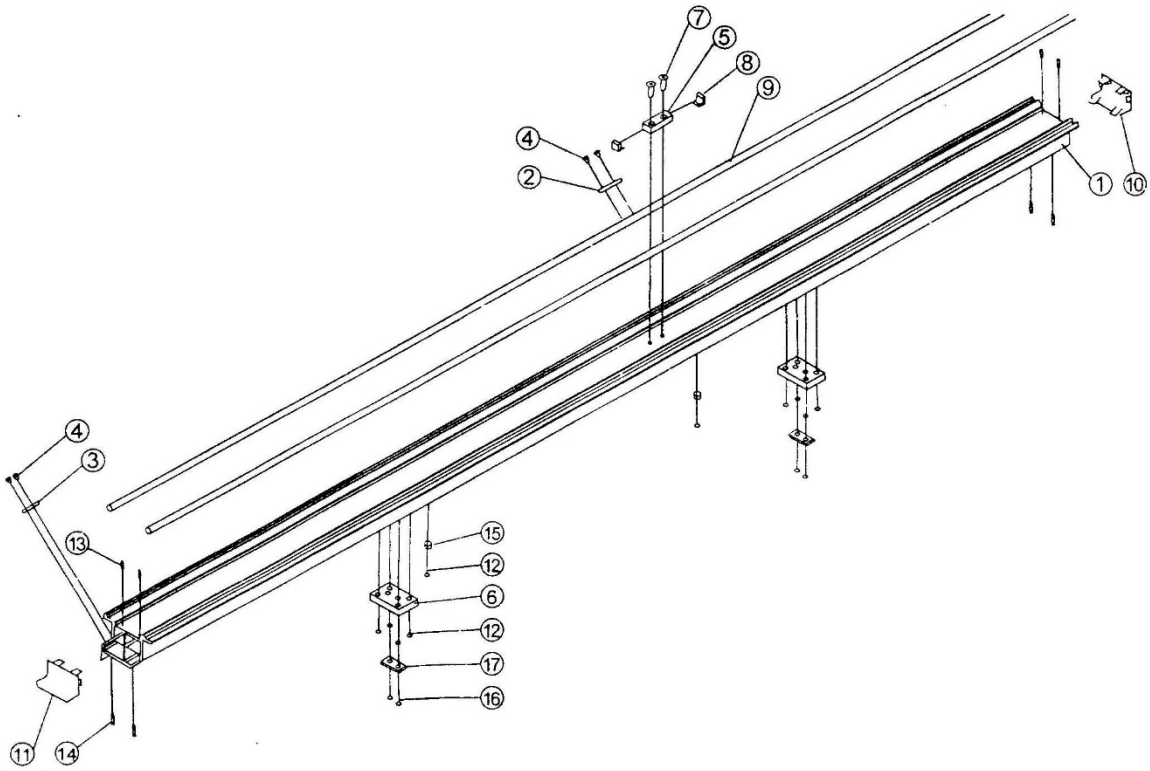
No.	Description	No.	Description
1	Top carriage 1600mm	20	Set collar
2	Round bar	21	Tube
3	Round bar	22	Hexagonal
4	Switching flag	23	Star grip screw
5	Cheese head screw	24	Slotted spring pin
6	Washer	25	Slotted spring pin
7	Stop	26	Parallel pin
8	Inlay	27	Slotted spring pin
9	Hexagonal nut	28	Tension spring
10	Cheese head screw	29	Cap cover right
11	Stop	30	Cap cover left with grip
12	Bumper	31	Button head socket screw
13	Counter sunk screw	32	Counter sunk screw
14	Fuller	33	Grip
15	Tapping screw	34	Hexagonal screw
16	Underflow roll	35	Nut
17	Holder bolt	36	Set screw
18	Holder bolt	37	Scale
19	Cheese head screw		

Sliding table (middle carriage)



No.	Description	No.	Description
1	Middle carriage	**11**	Bush
2	Axle stop	**15**	Angle bracket
3	Retaining ring	**16**	Wiper
4	Stop	**17**	Bumper
5	Slotted spring pin	**18**	Washer
6	Connection piece	**19**	Cheese head screw
8	Slotted spring pin	**20**	Double roller
9	Eye bolt	**21**	Countersunk screw
10	Hexagonal nut		

Sliding table (bottom carriage)



No.	Description	No.	Description
1	Bottom carriang	**10**	Cap cover left
2	Middle locking	**11**	Cap cover right
3	End locking	**12**	Cheese head screw
4	Counter sunk screw	**13**	Blind rivet
5	Stop	**14**	Blind rivet
6	Base	**15**	Distance bush
7	Counter sunk screw	**16**	Cheese head screw
8	Bumper	**17**	Plate
9	Round bar		

27 ZUBEHÖR / ACCESSORIES / PŘÍSLUŠENSTVÍ

(DE) Optionales Zubehör finden Sie online auf der Produktseite, Kategorie EMPFOHLENES ZUBEHÖR ZUM PRODUKT.

(EN) Optional accessories can be found online on the product page, category RECOMMENDED PRODUCT ACCESSORIES.

(CZ) Volitelné příslušenství najdete na internetu na stránce výrobku, kategorie DOPORUČENÉ PŘÍSLUŠENSTVÍ K VÝROBKU.