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Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN USER MANUAL

CZ NÁVOD K POUŽITÍ

FORMATKREISSÄGE

PANEL SAW

FORMÁTOVACÍ PILA



FKS400V32TOP_400V





2 SICHERHEITSZEICHEN / SAFETY SIGNS

DE SICHERHEITSZEICHEN
BEDEUTUNG DER SYMBOLE

EN SAFETY SIGNS DEFINITION OF
SYMBOLS

CZ VÝZNAM BEZPEČNOSTNÍCH
SYMBOLŮ



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

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

CZ CE-SHODNÉ: Tento výrobek odpovídá směrnicím ES.



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 OBSLUZE! Přečtěte si řádně návod na obsluhu a údržbu Vašeho stroje a dobře se seznámte s ovládacími prvky stroje, aby byl tento řádně obsluhován a předešlo se ke škodám na stroji a zraněním osob.



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! Dodržujte bezpečnostní symboly! Nedodržování předpisů a pokynů pro používání stroje může vést k vážnému zranění osob a smrtelnému nebezpečí.



DE Schutzausrüstung tragen!

EN Wear protective equipment!

CZ Používejte osobní ochranné pomůcky!



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 stroj vypněte a odpojte od sítě!



DE Warnung vor Schnittverletzungen!

EN Warning of crush injuries!

CZ Varování před řeznými poraněními!



DE Benutzen von Handschuhen verboten!

EN Do not use gloves!

CZ Používání rukavic zakázáno!

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

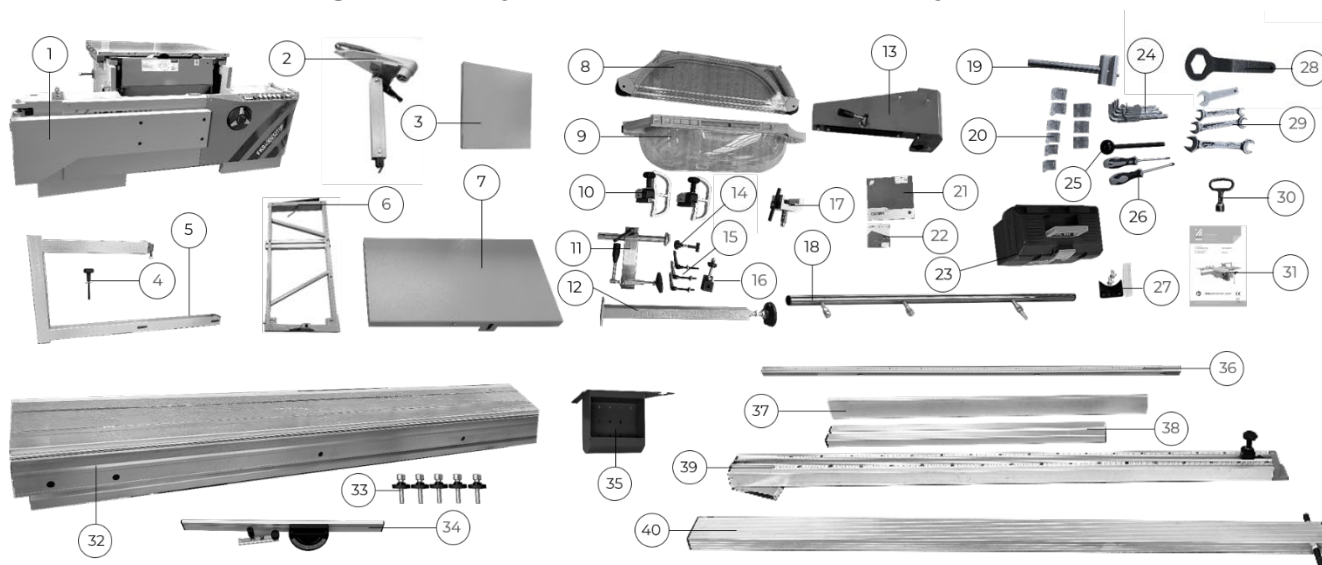
EN **Missing or non-readable security stickers have to be replaced immediately.**

CZ **Výstražné značky a/nebo nálepky na stroji, které jsou nečitelné nebo byly odstraněny, musí být okamžitě vyměněny!**



3 TECHNIK / TECHNICS / TECHNIKA

3.1 Lieferumfang / Delivery content / Obsah dodávky

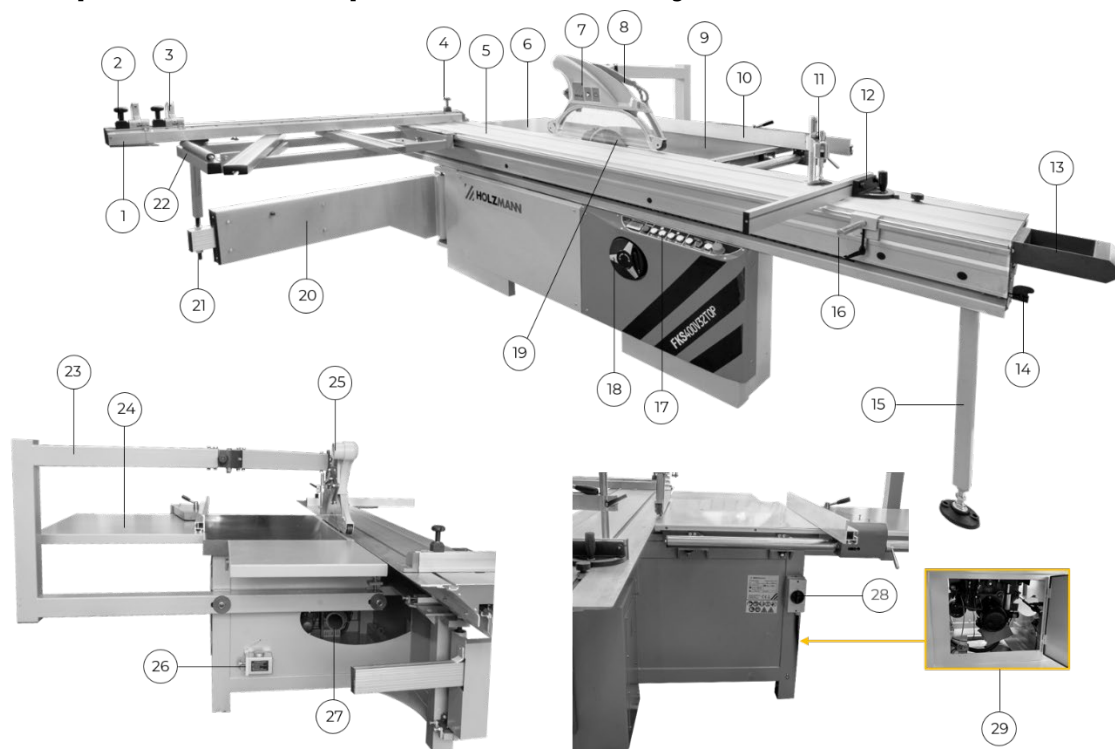


#	Beschreibung / Description	Qty
1	Maschine / machine / Stroj	1
2	Halterung Sägeblattschutz kurz / bracket saw blade guard short / Krátký držák krytu kotouče	1
3	Tischverlängerung / table extension / Prodloužení stolu	1
4	Positionsschraube / position screw / Zajišťovací šroub	1
5	Halterung Sägeblattschutz / bracket saw blade guard / Držák krytu kotouče	1
6	Auslegertisch / outrigger table / Podpěrný rám	1
7	Tischverbreiterung / table widening / Rozšíření stolu	
8	Sägeblattschutz gerader Schnitt / saw blade guard straight cut / Kryt kotouče pro přímý řez	1
9	Sägeblattschutz Winkelschnitt / saw blade guard angle cut / Kryt kotouče pro řezy pod úhlem	1
10	Kippanschlag / flip stop / Překlopný doraz	2
11	Niederhalter / down holder / Excentrický přítlak obrobku	1
12	Stütze Formatschiebetisch / sliding table support / Podpěra formátovacího stolu	1
13	Halterung Parallelanschlag / bracket rip fence / Držák podélného pravítka	1
14	Auflagenfixierung / support fixing / Zajištění podpěry	1
15	Klemmhebel / clamping lever / Zajišťovací páka	3
16	Klemmung 90° / clamping 90° / Zajištění 90°	1
17	Halterung Gehrungsanschlag / bracket mitre gauge / Držák úhlového pravítka	1
18	Führungsschiene Parallelanschlag / rip fence guide / Vedení podélného pravítka	1
19	Handriff Formatschiebetisch / handle sliding table / Rukojeť formátovacího stolu	1
20	Lupe (inkl. Ersatzlupen) / magnifier (incl. spare magnifier) / Lupa (vč. náhradní lupy)	9
21	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
22	Vorritzer Ø 120 x Ø 20 x 2,0-2,2mm Z: 2x12 / scoring saw blade Ø 120 x Ø 20 x 2,0-2,2mm T: 2x12 / Předřezový kotouč Ø 120 x Ø 20 x 2,0-2,2mm Z: 2x12	1
23	Werkzeugkoffer / tool box / Kufřík na nářadí	1
24	Inbusschlüsselset / Allen key set / Sada imbus klíčů	1
25	Fixierstift / fixing pin / Zajišťovací čep	1
26	Schraubendreher set / screw driver set / Sada šroubováků	1
27	Schmutzabstreifer / dirt wiper / Stěrka na nečistoty	1



28	Sägeblattschlüssel / saw blade wrench / Klíč na pilový kotouč	1
29	Gabelschlüsselset / wrench set / Sada plochých klíčů	1
30	Wartungstürschlüssel / key maintenance door / Klíč na servisní dvířka	1
31	Betriebsanleitung / user manual / Návod k použití	1
Colli II:		
32	Formatschiebetisch / sliding table / Formátovací stůl	1
33	Montageschrauben Formatschiebetisch / mounting screws sliding table / Montážní šrouby formátovacího stolu	5
34	Gehrungsanschlag / mitre gauge / Úhlovací pravítko	1
35	Endgriff Formatschiebetisch / end handle sliding table / Koncová rukojeť formátovacího stolu	1
36	Lineal Parallelanschlag / ruler rip fence / Teleskopické úhlové pravítko	1
37	Parallelanschlag / rip fence / Podélné pravítko	1
38	Auflage / support / Podpěra	1
39	Ablänganschlag / cross-cut fence / Úhlové pravítko	1
40	Schwenkarm / swivel arm / Podpěrné rameno	1

3.2 Komponenten / Components / Části stroje

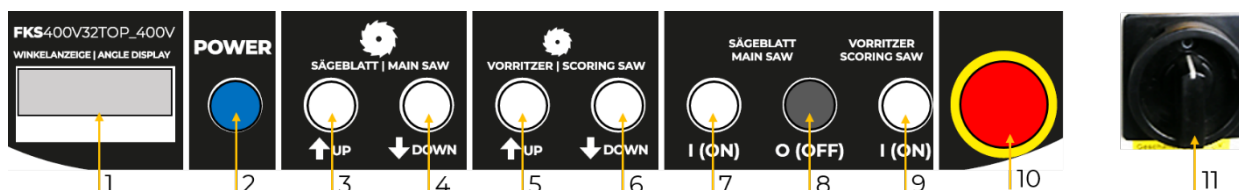


#	Beschreibung / Description	
1	Ablänganschlag (ausziehbar) / cross-cut fence (extendable) / Teleskopické úhlové pravítko	
2	Klemmung Kippanschlag / clamping flip stop / Zajištění překlopného dorazu	
3	Anschlag Ablänganschlag (Kippanschlag) / flip stop / Překlopný doraz	
4	Fixierknopf Ablänganschlag / fixing knob length cross-cut fence / Zajišťovací růžice úhlového pravítka	
5	Formatschiebetisch / sliding table / Formátovací stůl	
6	Tischverlängerung / table extension / Prodloužení stolu	
7	Sägeblattschutz / saw blade guard / Kryt kotouče	
8	Schiebestock / push stick / Podavač	
9	Arbeitstisch / work table / Pracovní stůl	
10	Parallelanschlag / rip fence / Podélné pravítko	
11	Niederhalter / down holder / Excentrický upínač	



12	Gehrungsanschlag / mitre gauge / Úhlové pravítko
13	Endgriff Formatschiebetisch / end handle sliding table / Koncový držák formátovacího stolu
14	Verriegelungshebel Formatschiebetisch / locking lever sliding table / Zajišťovací páka formátovacího stolu
15	Stütze Formatschiebetisch / sliding table support / Podpěra formátovacího stolu
16	Handriff Formatschiebetisch / handle sliding table / Rukojeť formátovacího stolu
17	Bedienpult / control panel / Ovládací pult
18	Handrad Sägeblattneigung / handwheel saw blade tilt / Ruční kolo náklonu kotouče
19	Sägeblatt und Vorritzer / saw blade and scoring saw blade / Pilový kotouč a předřezový kotouč
20	Schwenkarm / swivel arm / Podpěrné rameno
21	Schwenkarmstütze / swivel arm support / Podpěra rámu
22	Auslegertisch / outrigger table / Podpěrný rám
23	Halterung Sägeblattschutz / bracket saw blade guard / Držák krytu kotouče
24	Tischverbreiterung / table widening / Ruzšíření stolu
25	Absauganschluss Sägeblattschutz Ø 80 mm / dust collector port saw blade guard Ø 80 mm / Odsávací hrdlo krytu kotouče Ø 80 mm
26	Zentralschmierung / central lubrication / Centrální mazání stroje
27	Absauganschluss Sägeeinheit Ø 100 mm / dust collector port saw unit Ø 100 mm / Odsávací hrdlo pilového kotouče Ø 100 mm
28	Anschlussdose mit Hauptschalter / input box with main switch / Připojovací skříňka s hlavním vypínačem
29	Wartungstür / maintenance door / Servisní dvířka

3.2.1 Bedienelemente / control elements / Ovládací prvky



#	Beschreibung / Description
1	Winkelanzeige Sägeblattneigung / display saw blade tilt angle / Displej náklonu kotouče
2	Betriebskontrollleuchte / power indicator light / Provozní kontrolky
3	Taster Sägeblatthöhe höher / button saw blade height up / Tlačítko vysunutí kotouče vzhůru
4	Taster Sägeblatthöhe niedriger / button saw blade height down / Tlačítko zasunutí kotouče dolů
5	Taster Vorritzerhöhe höher / button scoring saw blade height up / Tlačítko předřezu vzhůru
6	Taster Vorritzerhöhe niedriger / button scoring saw blade height down / Tlačítko předřezu dolů
7	Taster Sägeblatt EIN / button saw blade ON / Tlačítko zapnutí pilového kotouče
8	Taster Sägeblatt und Vorritzer AUS / button saw blade and scoring saw blade OFF / Tlačítko vypnutí hlavního kotouče a předřezu
9	Taster Vorritzer EIN / button scoring saw blade ON / Tlačítko zapnutí předřezu
10	Not-Halt Schalter / emergency stop / Tlačítko nouzového vypnutí
11	Hauptschalter für Spannungsversorgung EIN-AUS / main switch für power supply ON-OFF / Hlavní vypínač stroje

3.3 Technische Daten / Technical data / Technická data

Spezifikation / Specification	
Spannung / voltage / Napájecí napětí	400 V / 50 Hz
Motorleistung Sägeblattmotor / motor power sawblade motor / Výkon hlavního motoru	5,5 kW
Arbeitstischgröße / worktable size / Rozměry pracovního stolu	1100 x 700 mm
Formatschiebetisch / sliding table / Formátovací stůl	3200 x 435 mm
Tischverbreiterung / table widening / Rozšíření stolu	900 x 830 mm



Tischverlängerung / table extension / Prodloužení stolu	610 x 600 mm
Arbeitstisch Höhe / work table height / Výška pracovního stolu	900 mm
Auslegertisch / outrigger table / Podpěrný rám	1200 x 550 mm
Ablänganschlag / cross-cut fence / Úhlové pravítko	1950 – 3300 mm
Sägeblattdimension / saw blade dimension / Rozměry pilového kotouče	Ø 250-400 x 30 x 3,4/2,4 mm
Drehzahl Sägeblatt / saw blade speed / Otáčky pilového kotouče	(I): 3000 min ⁻¹ (II): 4000 min ⁻¹ (III): 5000 min ⁻¹
Sägeblatt Neigung / saw blade tilt / Náklon pilového kotouče	0 – 45°
Schnitthöhe bei 90 ° / cutting height at 90 ° / Výška řezu při 90 °	80 mm (Ø300 mm)
Schnitthöhe bei 45 ° / cutting height at 45 ° / Výška řezu při 45 °	55 mm (Ø300 mm)
Vorritzersägeblattdimension / scoring saw blade dimension / Rozměry předřezového kotouče	Ø120 x 20 x 3,2 - 4,2/2,2 mm
Motorleistung Vorritzer / scoring unit power / Výkon motoru předřezu	750 W
Vorritzersägeblattgeschw. / scoring saw blade speed / Otáčky předřezového kotouče	8000 min ⁻¹
Max. Schnittbreite am Parallelanschlag / max. cutting width at rip fence / Max. šířka řezu k podélnému pravítku	1300 mm
Motorleistung Sägeblatthöhenverstellmotor / motor power saw blade height adjustment / Výkon motoru nastavení výšky	24 V (max. 6000 N)
Absauganschluss Durchmesser / dust collector port / Průměr odsávacích hrdel	1 x Ø 100 mm / 1 x Ø 80 mm
notwendiger Luftvolumenstrom Absauganlage / necessary air volume / Požadovaný objem vzduchu odsávání	2000 m ³ /h
notwendiger Unterdruck Absauganlage / vacuum dust collector / Požadovaný podtlak odsávání	1000 Pa
Maschinenmaße (LxBxH) / machine dimensions (LxWxH) / Rozměry stroje (DxŠxV)	4730 x 4860 x 1470 mm
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH) / Rozměry balení (DxŠxV)	Colli I: 2170 x 1315 x 1145 mm Colli II: 3450 x 540 x 340 mm
Gewicht Brutto / weight gross / Hmotnost brutto	1070 kg
Gewicht Netto / weight net / Hmotnost netto	930 kg
Schallleistungspegel L _{WA} / sound power level L _{WA} / Akustický výkon L _{WA}	90 dB(A).....k: 4 dB(A)
Schalldruckpegel L _{PA} / sound pressure level L _{PA} / Akustický tlak 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) Poznámka k emisím hluku: Uvedené hodnoty jsou emisní hodnoty, a proto nemusí být nutně bezpečnými hodnotami na pracovišti. Ačkoli existuje korelace mezi úrovní emisí a imisí, nelze spolehlivě odvodit, zda jsou nutná dodatečná preventivní opatření nebo nikoliv. Mezi faktory, které ovlivňují úroveň imisí skutečně přítomných na pracovišti, patří povaha pracovního prostoru a další zdroje hluku; tj. počet strojů a dalších pracovních procesů. Povolené hodnoty na pracovišti se mohou v jednotlivých zemích lišit. Tyto informace by však měly uživateli umožnit lepší odhad nebezpečí a rizik.



11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the panel saw FKS400V32TOP_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 extraction (a normal household Hoover is not suitable as an extraction device).
- 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 (3): 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.
	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.
	Interlocking movable guard: Maintenance door (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 extraction system when installing it.
- Always switch on the extraction 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 an extraction 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

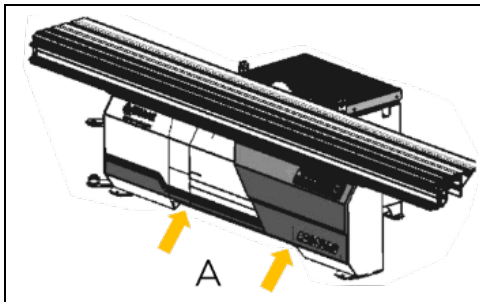
WARNING

**Risk of injury from suspended or unsecured load!**

Damaged or insufficiently strong hoists and load slings can result in serious injury or even death.

- Before use, therefore, check hoists and load slings for adequate load-bearing capacity and perfect condition.
- Secure the loads carefully.
- Never stand under suspended loads!

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 an extraction 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

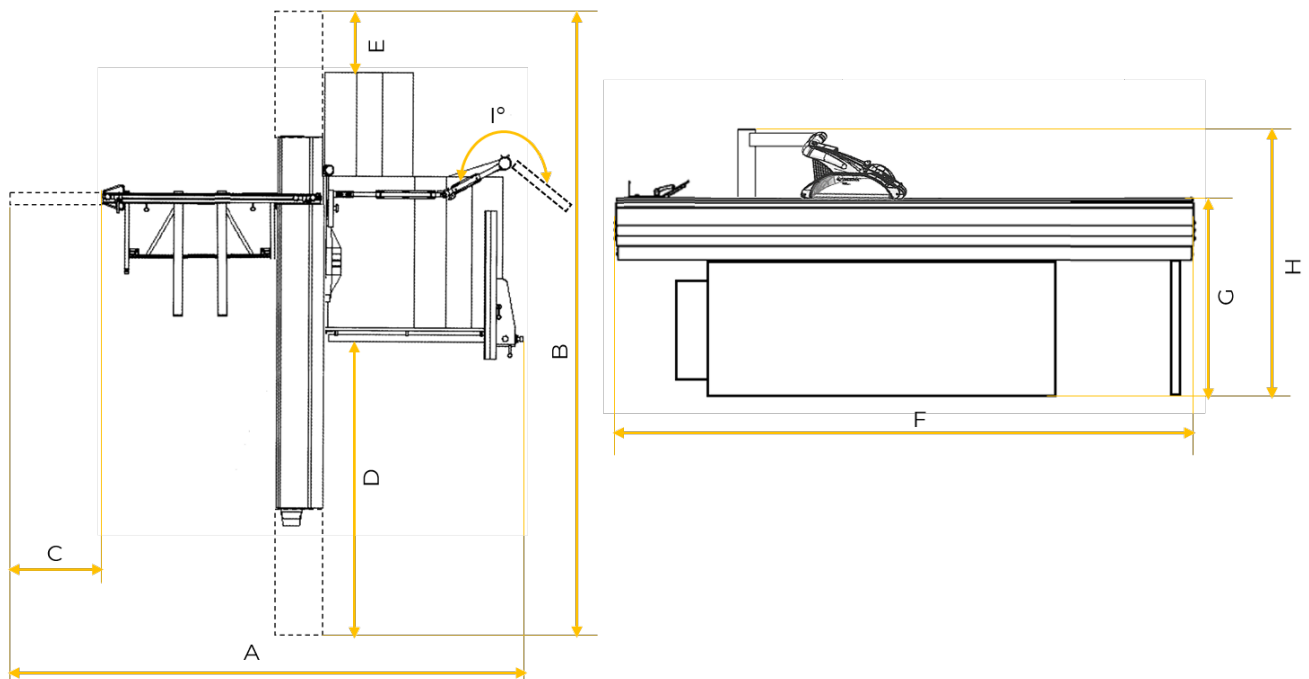


The floor at the installation site must be able to bear the load of the machine!

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	E	F	G	H	I
mm	4860	6850	1350	3030	2220	3200	900	1345	40°

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

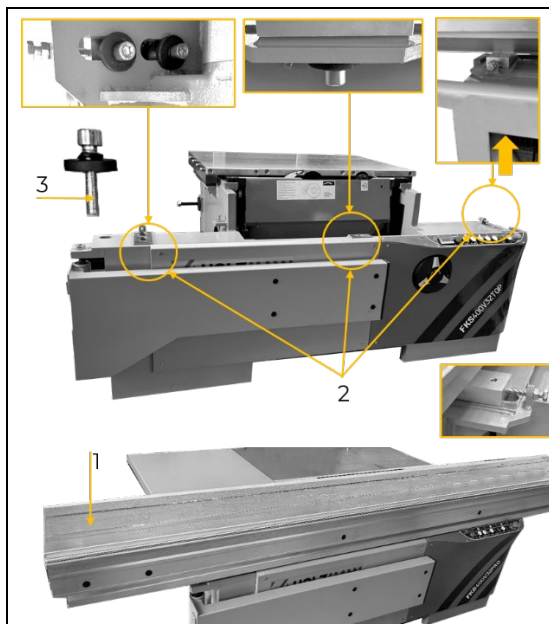


- The machine and machine parts are heavy!
- At least 2 people are required to set up the machine.

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



	1. Bracket saw blade guard - Mount the bracket saw blade guard (1) on the machine as shown. - To do this, first remove the screws and spacers (2) from the retaining bolts. - Place the bracket saw blade guard on the retaining bolts and fix it with screws and spacers (2). - Mount the bracket saw blade guard short (4) on the bracket. - To do this, first remove the bolt and nut (3) from the holder. - Position the bracket as shown. - Insert the bolt again and fix it with the nut (3). Saw blade guard: - Set the lock (7) to the "Open" position. - Slide required saw blade guard (6) onto saw blade guard holder (5). - Set lock (7) to "Lock" position
	2. Table extension / 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.
	3. 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 dirt wiper (9) as shown.

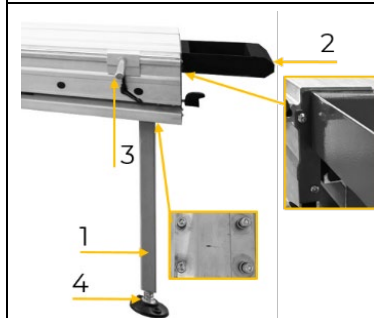


4. Sliding table

- Place the sliding table (1) on the machine and fix it at the fixing points (2) using screws, spring washers and washers (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.

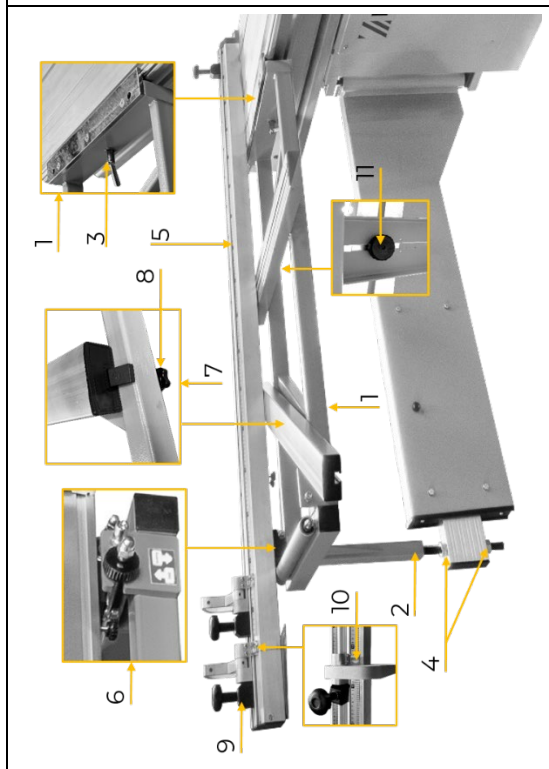
NOTE: Over the entire length, the distance between the two table edges must be within 12 mm. Furthermore, it should be aligned exactly to the rip fence / saw blade.

- Then tighten the screws.



5. Sliding table support/end handle/handle

- Fix the support (1) on the end of the sliding table with 4 screws, spring washers and washers as shown.
- Adjust the height (4) with the set screw.
- Fix end handle with 4 screws.
- Hook handle (3) in desired position and fix it with clamping lever.



6. Outrigger table

- Place the bracket of the outrigger table (1) on the sliding table as shown.
- Place the holder of the outrigger table on the swivel arm support (2).
- Tighten the clamping levers (3) of the outrigger table to fix the position.
- Adjust the horizontal alignment with the adjusting screws (4).
- Insert the pivot mount of the crosscut fence (5) into the front or rear hole of the outrigger table and fix it with clamping 90° (6).
- Insert the groove stone of the support fixing into the opening, push the groove stone into the groove of the support (7) and fix it in the desired position with the fixing screw (8).
- Push the flip stops (9) into the groove of the cross cut fence.
- Fix the magnifiers (10) with screws.
- Secure the crosscut fence in desired angle position with clamping screw (11).



	7. Saw blade - Adjust the cutting height to the maximum possible level. - Push the sliding table all the way forward. - Open the saw blade guard. - Fix the drive shaft with the supplied fixing pin (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 fixing pin (5). - Tighten the flange nut with the saw blade wrench (6) (left-hand thread!). NOTE: min. tightening torque: 50 Nm - Close the saw blade guard.
	8. Scoring saw blade - Adjust the cutting height to the maximum possible level. - Push the sliding table all the way forward. - 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), scoring 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: 25 Nm - Close the saw blade guard.
	9. Downholder - Insert the bracket of the downholder (1) into the groove of the sliding table and fix it in the desired position. 10. Mitre gauge - Insert the mitre gauge (2) into the groove of the sliding table and fix it in the desired position with the knurled screw (3).



14.3 Electrical connection

WARNING

**Dangerous electrical voltage!**

- The machine may only be connected to the power 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 $\pm 5\%$ is permissible.
A short-circuit fuse must be provided in the power supply system of the machine!

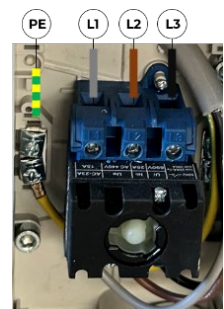
- Use a supply cable that fulfils the electrical requirements (e.g. H07RN, H05RN) and take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage..
- Make sure that the power supply is protected by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

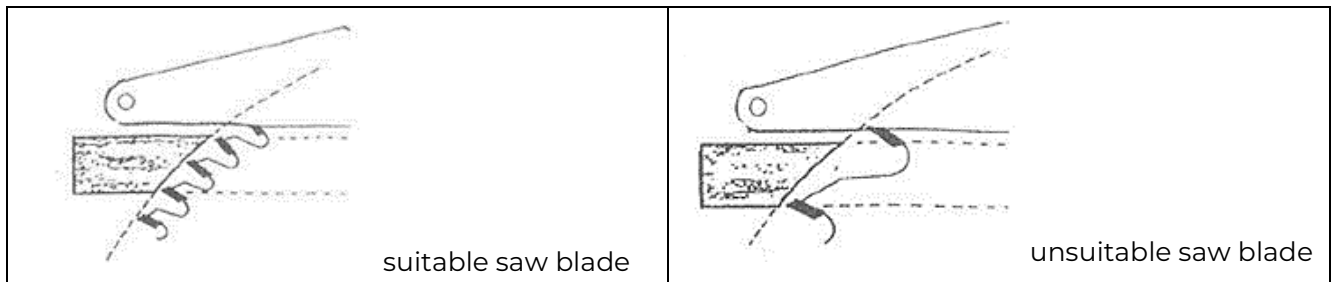
- Always disconnect the machine from the power supply before carrying out adjustment or maintenance work and secure it against reconnection.

14.5.1 Saw blade

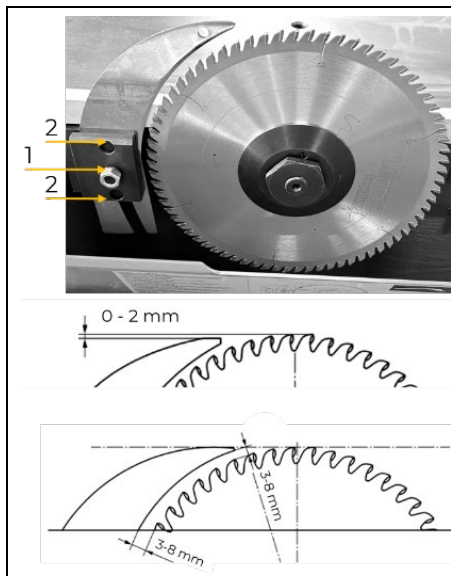
The material of the workpiece and the saw blade teeth are important criteria for a precise cutting result. Both the number of teeth and their shape, arrangement and position are associated with a specific function.

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!



14.5.2 Riving knife



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

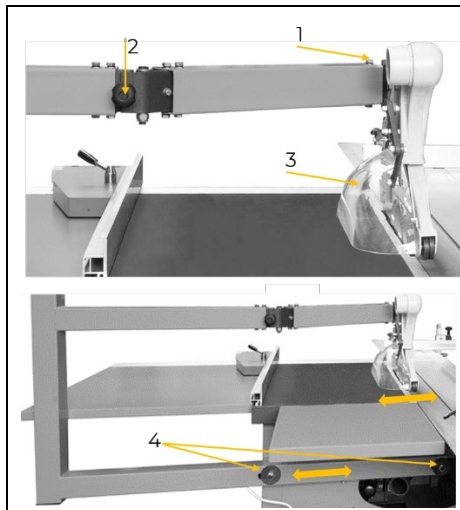
- To do this, loosen the nut (1) slightly.
- Make adjustments with setting screws (2).
- Retighten the nut.

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

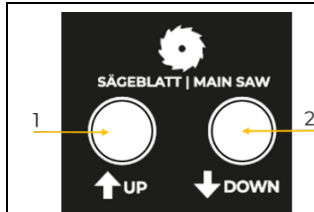


Adjust the saw blade guard so that the saw blade is protected. The distance between the saw blade guard and the workpiece should be max. 5 mm.

- Adjust the parallelism to the saw blade exactly with set screws on the bracket (1) or by the position of the arm and fix the position with position screw (2).
- Set the exact position above the saw blade. To do this, loosen the screws (4) slightly, move the bracket and tighten the screws again.

NOTE: For angle cuts on the rip fence always assemble the saw blade guard angle cut (3).

14.5.4 Saw blade height adjustment

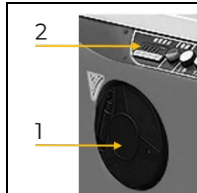


Push the button saw blade height up (1) to lift the saw blade upwards.

Push the button saw blade height down (2) 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



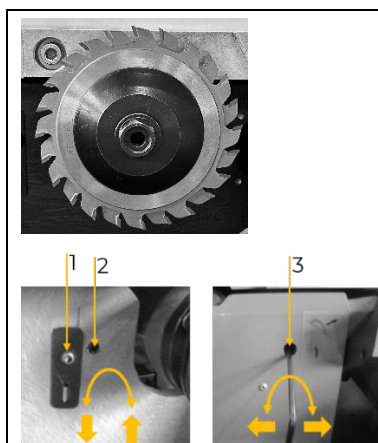
Turn the hand wheel (1) clockwise to tilt the saw blade. Turn the hand wheel counterclockwise to move the saw blade in a vertical position again. The saw blade can be tilted from 0° to 45°. The current position can be seen on the display (2).

NOTE



- Adjust the riving knife and the saw blade guard to the position of the saw blade!
- Adjust the rip fence or the cross-cut fence so that it does not touch the inclined saw blade.

14.5.6 Scoring saw blade basic adjustment



• Height of the scoring saw blade

- Loosen screw (1)
- Turning the setting screw (2) to the left ↓.
- Turning the setting screw (2) to the right ↑.
- Fix screw (1)

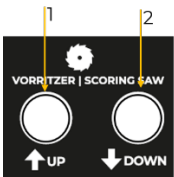
• Lateral adjustment of the scoring saw blade

- Turning the setting screw (3) to the left ←.
- Turning the setting screw (3) to the right →.

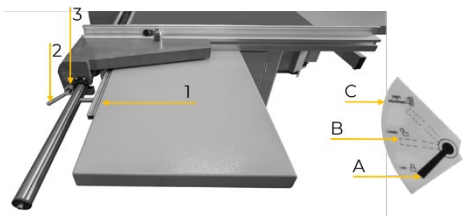
NOTE: When using the scoring blade, the height must be adjusted so that it cuts a slot with a depth of 1.5 – 2 mm.



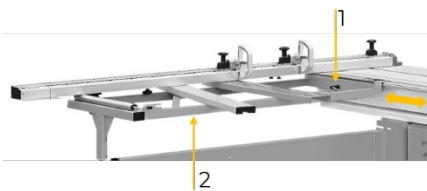
14.5.7 Scoring saw blade height adjustment

	Push the button scoring saw blade height up (1) to lift the scoring saw blade upwards Push the button scoring saw blade height down (2) to lower the scoring saw blade
---	--

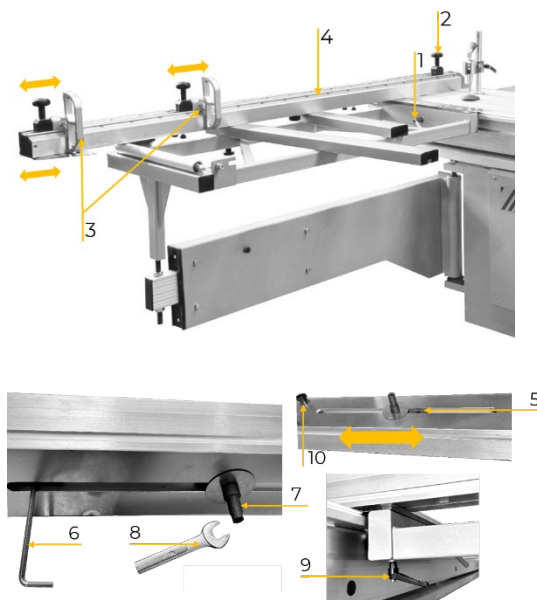
14.5.8 Adjustment of the cutting width at rip fence

	The cutting width can be adjusted on the rip fence and can be read off the ruler (1). - Clamping lever (2) in position A: Rip fence locked - Clamping lever (2) in position B: rip fence unlocked and moveable - Clamping lever (2) in position C: Make fine adjustment using knurled screw (3)
---	--

14.5.9 Adjustment outrigger table

	After losing 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.
--	--

14.5.10 Cross cut fence

	- Position the outrigger table by loosening the clamping lever (1) and pushing the outrigger table into position. - Adjust the crosscut fence by loosening the clamping screws and moving the flip stops (3) - Read off the set measurement from the scale (4). - Extend the cross-cut fence by loosening the locking knob (2) and pulling out the rail (2). - Tighten the locking knob again. NOTE: If the workpiece extends more than 1950 mm, 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)
---	---



14.5.11 Saw blade speed

	- Open the maintenance door - Rotate the rocker lever (1) downward with a wrench to the lock position - 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 Position III: see techn. data - Rotate the rocker lever upward - Close the maintenance door NOTE: Belt tension will be self-adjusted after flipping of the rocker lever, requiring no manual adjustment
--	---

14.5.12 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.

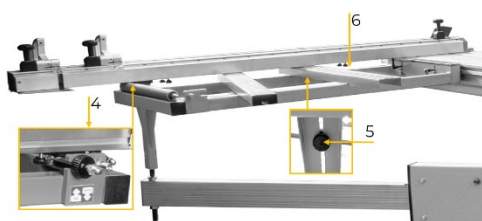
15.2.2 Mitre cuts

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



Mitre gauge

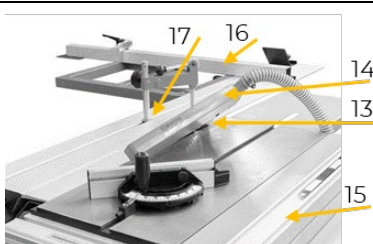
- Loosen the locking screw (1) and set the desired angle. Fix the locking screw again.
- Loosen the knurled screw (2) and position the mitre gauge. Tighten the knurled screw again.
- If necessary, loosen the clamping screws (3) and move the fence. Tighten the clamping screws again.



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 90° (4) and clamping screw (5).
- Adjust the angle of the cross cut fence
- Read off the set angle on the scale (6).
- Fix clamping screw (5).
- Fix the workpiece.
- Use the sliding table to move the workpiece evenly.

15.2.3 Angled cuts with inclined saw blade



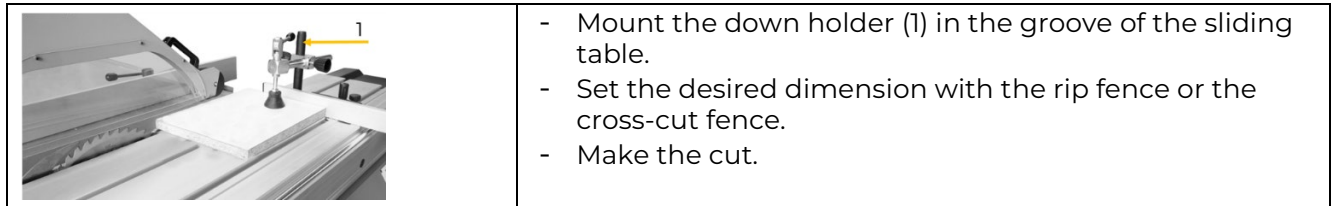
Symbolpicture

- 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).
- Make the cut.



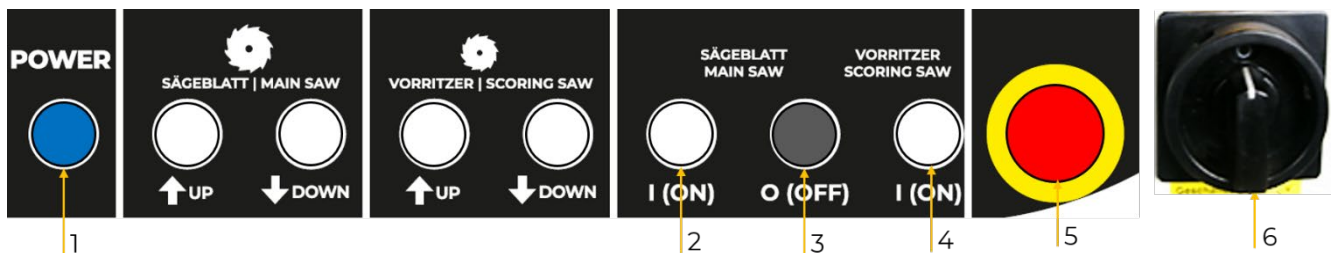
15.2.4 Longitudinal cut of boards

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



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 (1) lights on.

2. The main saw blade starts after pushing the button (2) I (ON).

3. The scoring saw blade starts after pushing the button (4) I (ON).

NOTE: The scoring saw 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 0 (OFF) button (3).

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 button (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 panel	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



	Central lubrication	Check oil level, pull the lever for 3-5 times
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 Central lubrication

NOTE



Lubricants are toxic and must not be released into the environment! Always follow the manufacturer's instructions and, if necessary, contact your local authority for information on proper disposal.



Fill in the machine oil with a viscosity of ISO 32 (recommended for ISO VG 32, DIN 51524/2 HLP, DIN 51517-3 CLP) via the filler opening (1).

Max. oil volume: 0,6 l

Oil level must always be between min and max.

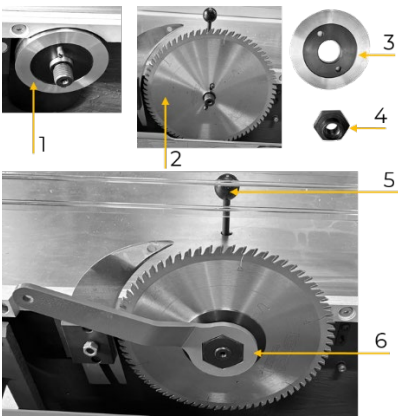
Pull the lever (2) to activate the lubrication.

16.2.3 Assembly / exchange saw blade



7

- Adjust the cutting height to the maximum possible level.
- Set the saw blade to 90°.
- Push the sliding table all the way forward.
- Open the saw blade guard (7).



1, 2, 3, 4, 5, 6

- Fix the drive shaft with the supplied fixing pin (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 the supplied fixing pin (5).
- Tighten the flange nut with the saw blade wrench (6) (left-hand thread!).

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

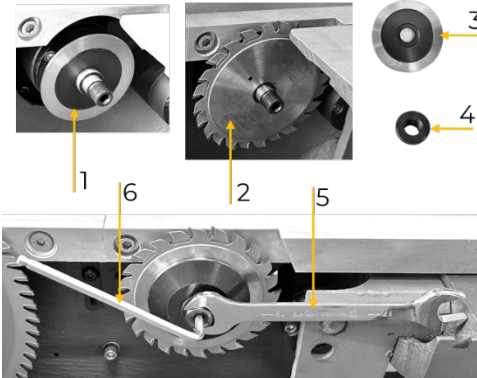
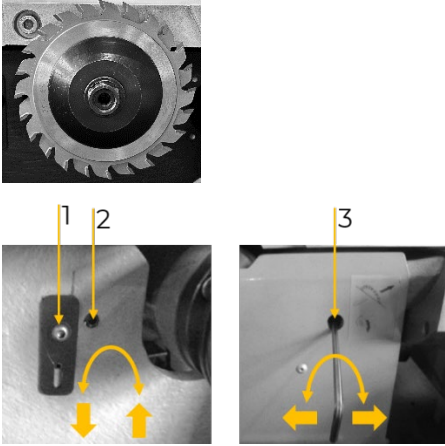
- Close the saw blade guard.
- Bring the sliding table back into position.

NOTE



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

16.2.4 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 forward. - 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: 25 Nm). - 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 – 2 mm. The scoring saw blade has to be oriented exactly to the main saw blade. Adjustments: - Adjust main saw blade to 90°. • Height of the scoring saw blade - Loosen screw (1) - Turning the setting screw (2) to the left ↓. - Turning the setting screw (2) to the right ↑. - Fix screw (1) • Lateral adjustment of the scoring saw blade - Turning the setting screw (3) to the left ←. - Turning the setting screw (3) to the right →.

16.2.5 Checking / adjusting / replacing V-belt

For optimum power transmission, the V-belt must be free of cracks and frays and have optimum tension. Check the condition of the V-belt at least every 3 months, more frequently if used daily. Broken or frayed V-belts must be replaced.



	Saw blade: - Open the maintenance door - Rotate the rocker lever (1) downward with a wrench to the lock position - Replace the old V-belt (2) with a new one. - 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 Position III: see techn. Data - Rotate the rocker lever upward - Close the maintenance door Scoring saw blade: - Open the maintenance door - Lift the motor (5) - Replace the old V-belt (6) with a new one. - Position new V-belt - Lower the motor - Close the maintenance door NOTE: Belt tension will be self-adjusted after flipping of the rocker lever / lower the motor, requiring no manual adjustment
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16.2.6 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
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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!

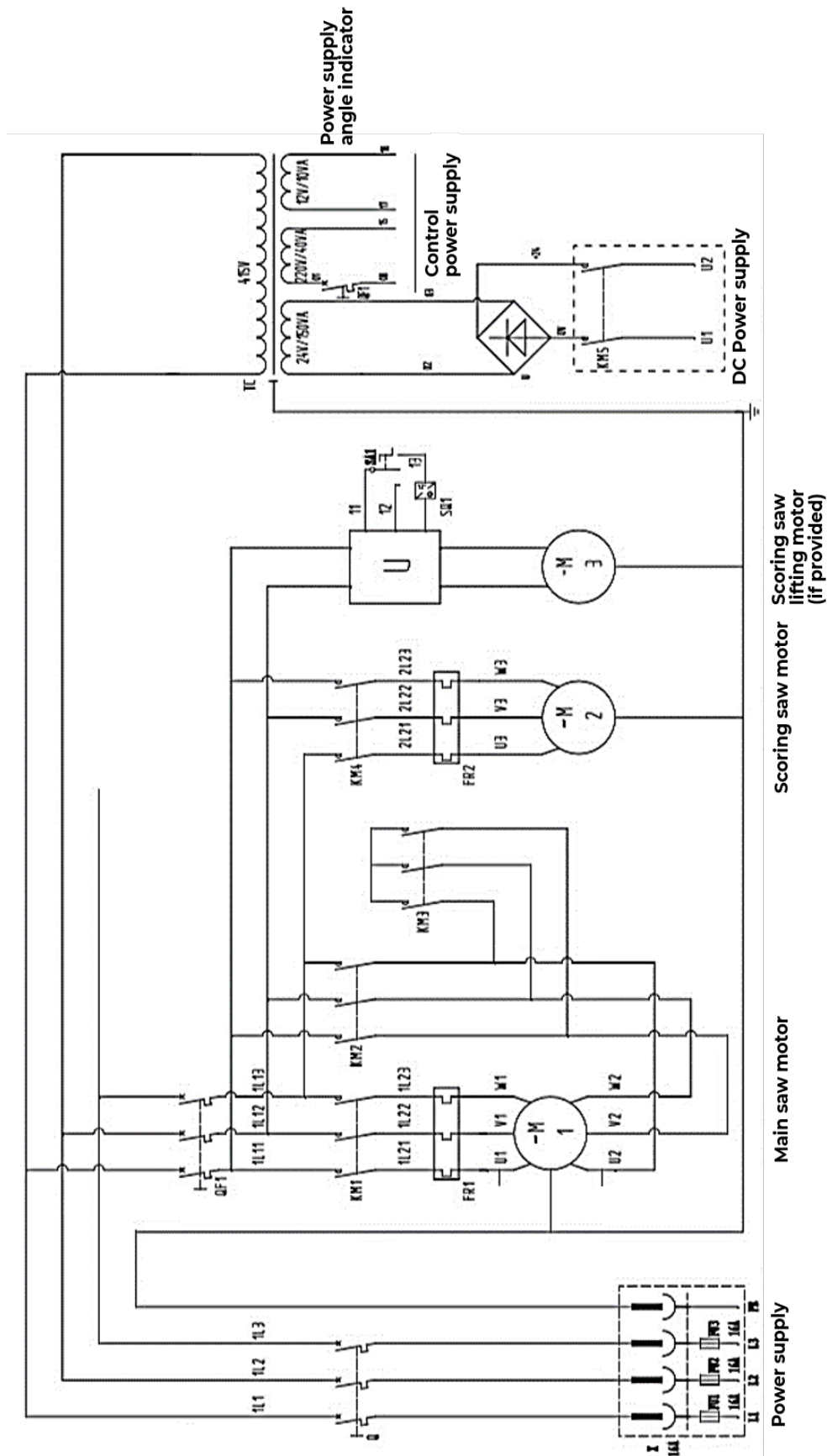
Many possible sources of error can be eliminated in advance if the machine is properly connected to the power supply.

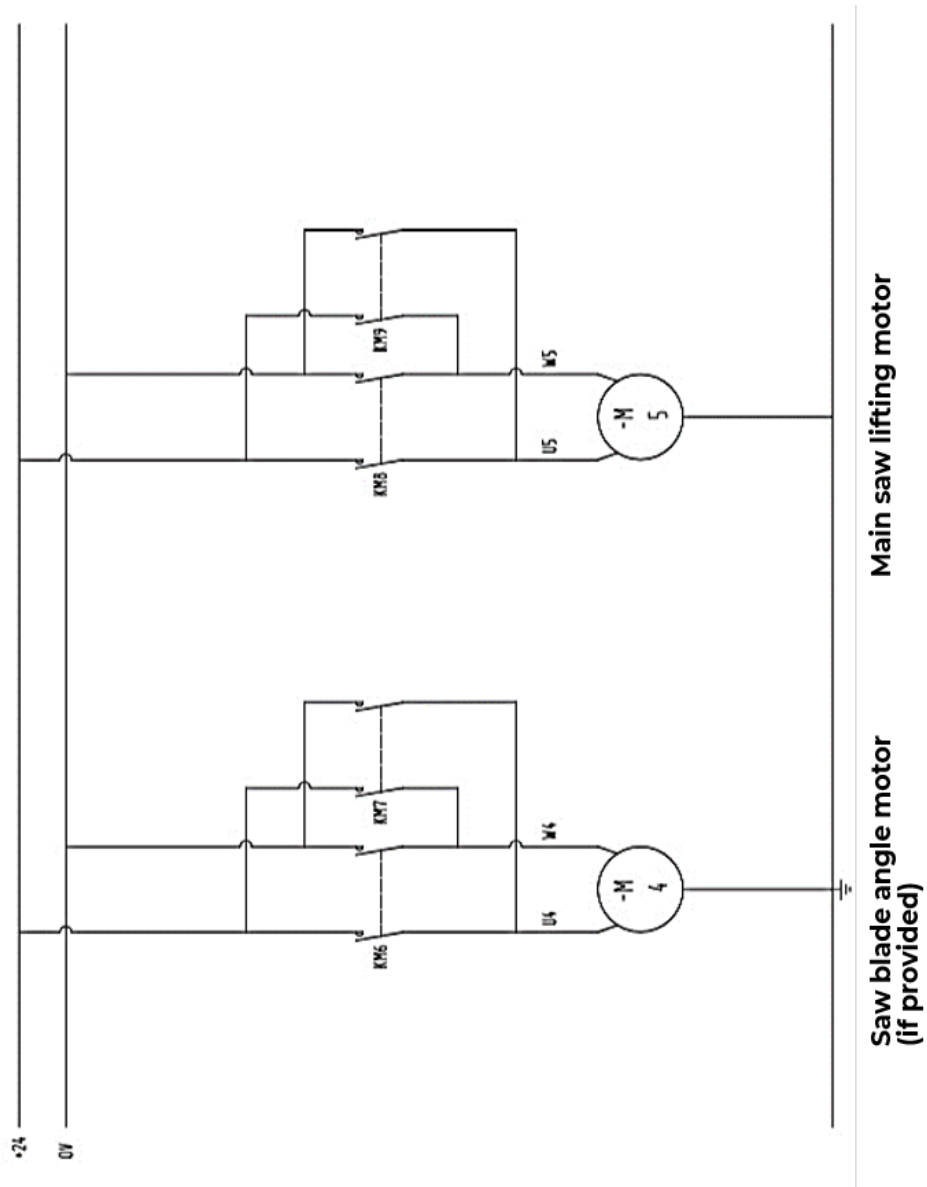
If you are unable to carry out the necessary repairs properly and/or do not have the required training, always consult a specialist to solve the problem.

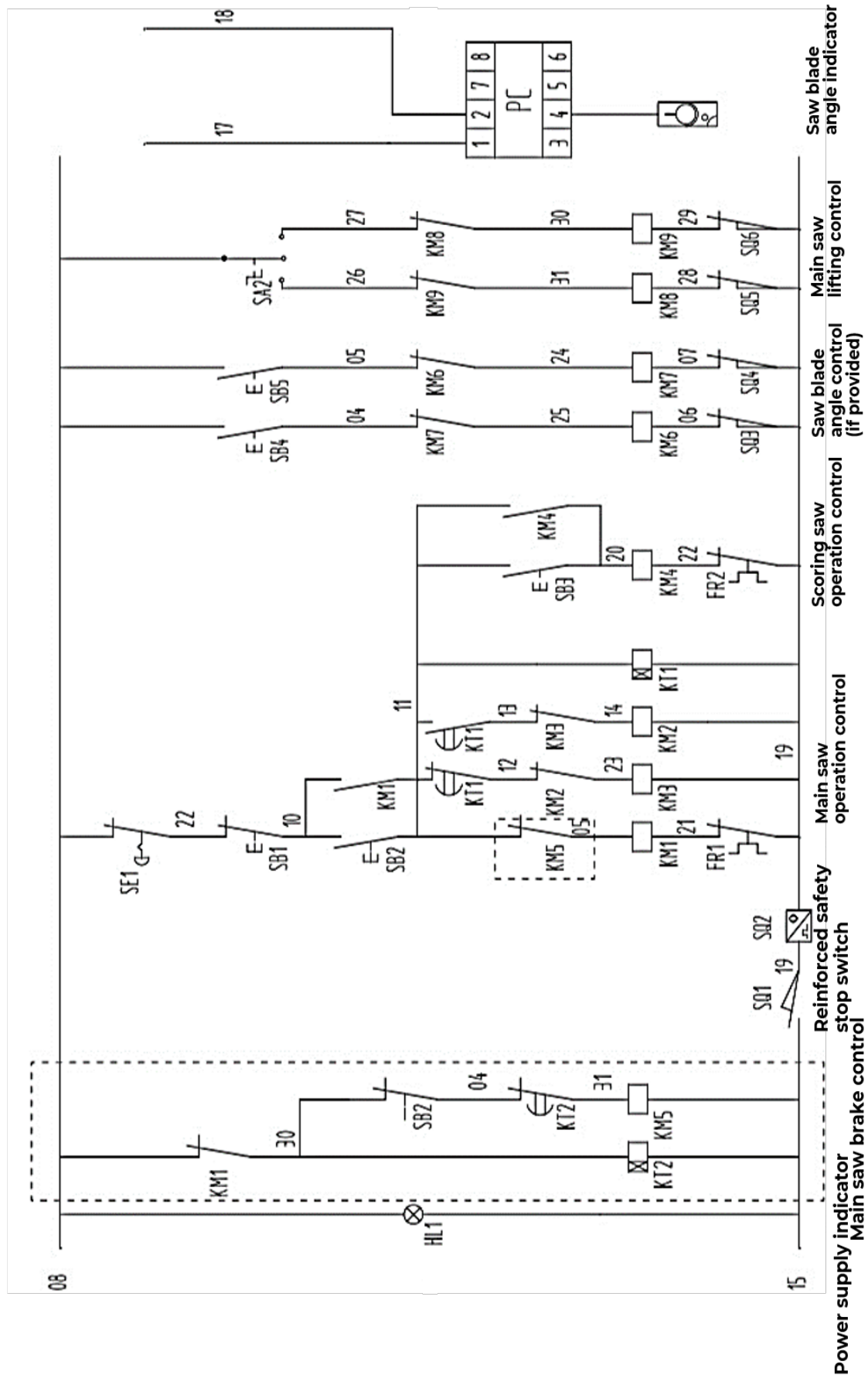
Trouble	Possible cause	Solution
Motor does not run	• Switch defective • Saw blade guard not completely closed – limit switch • Electrical system defective • Emergency stop is activated	• Repair switch • Close the saw blade guard well so that the limit switch is activated • Check main cable, plug and 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 / ELEKTRICKÉ SCHÉMA









26 ERSATZTEILE / SPARE PARTS / NÁHRADNÍ DÍLY

26.1 Ersatzteilbestellung / Spare parts order / Objednávka 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

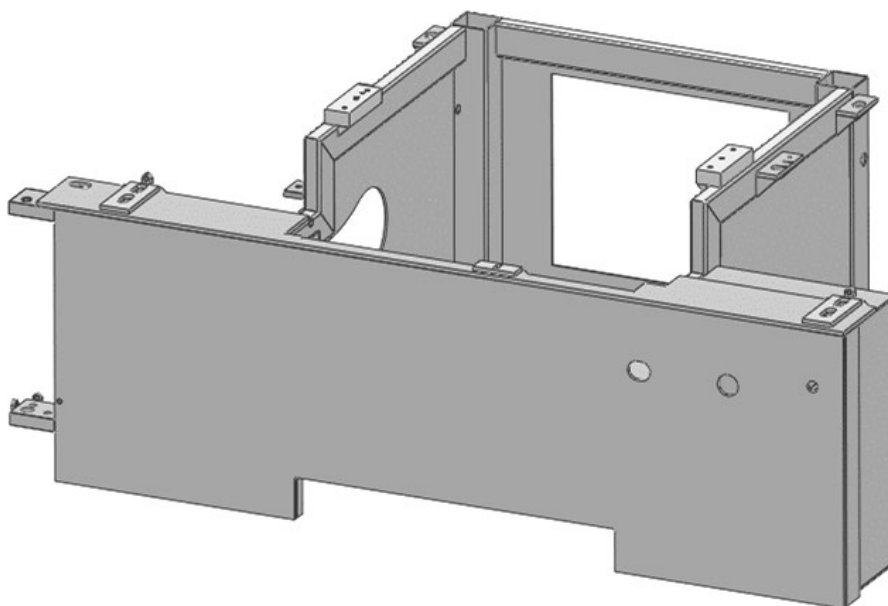
- přes naši domovskou stránku – kategorie SERVIS – POŽADAVEK NÁHRADNÍCH DÍLŮ,
- e-mailem na service@holzmann-maschinen.at.

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.

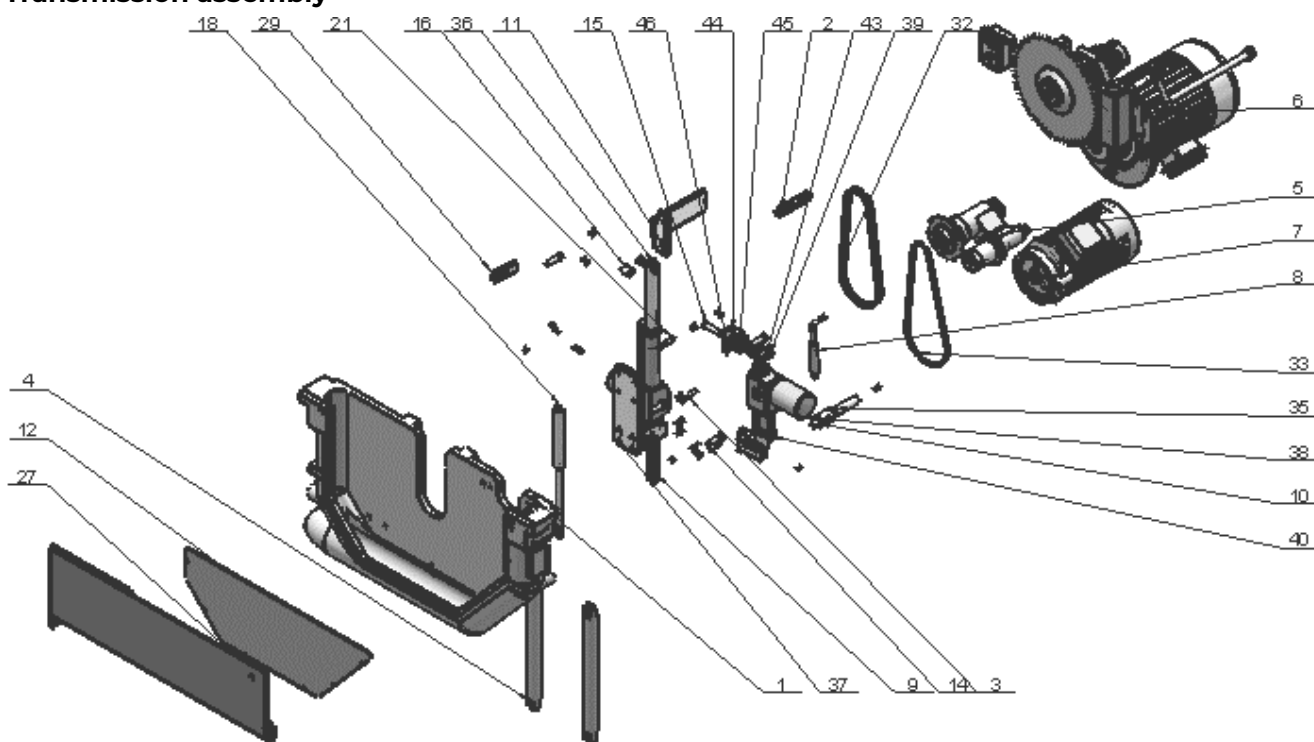


26.2 Explosionszeichnung / Exploded view / Výkres náhradních dílů

Machine body



Transmission assembly

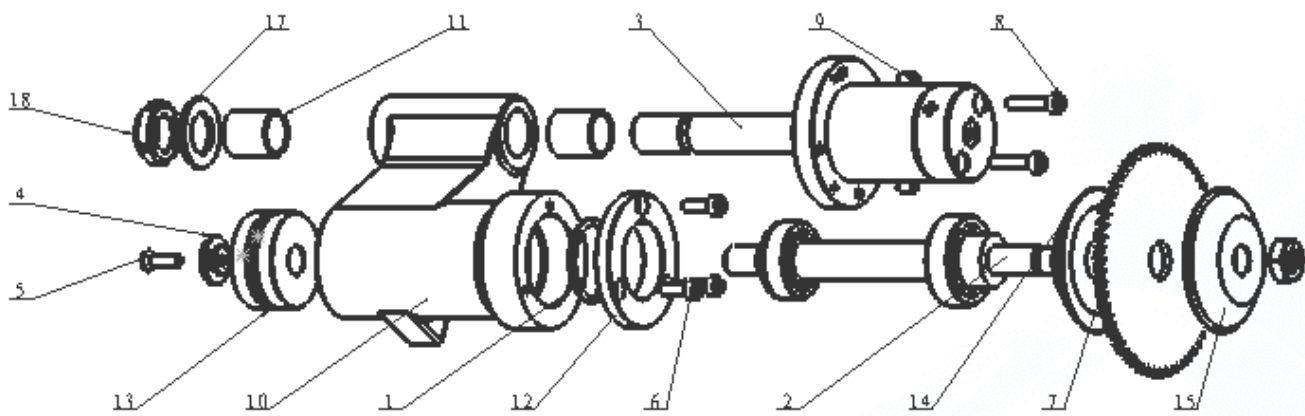


No.	Description	No.	Description
1	Connecting plate	24	Bolt
2	Gas spring	25	Nut
3	Screw	26	Hexagon half-round head screw
4	Guide post	27	Guard
5	Small saw assembly	28	Swivel bolt
6	Big saw lift base assembly	29	Fixed block



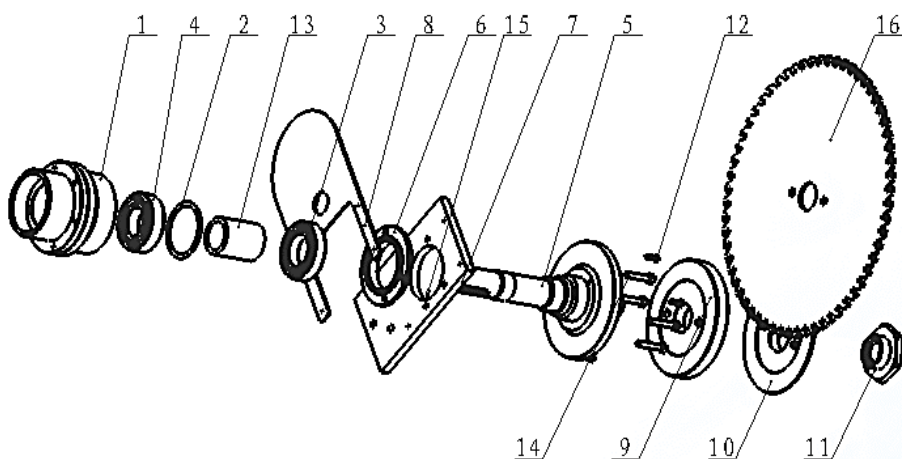
7	Small saw assembly	30	Bolt
8	Gas spring	31	Bolt
9	Fixing plate	32	Big saw poly V-belt
10	Fixing rod	33	Small saw poly V-belt
11	Stopper plate welded assembly	34	Screw
12	Connecting plate cover	35	Lock washer
13	Spacer	36	Big saw lift pusher
14	Bolt	37	Holder assembly
15	Bolt	38	Small saw lift pusher
16	Casing	39	Electric putter contact block
17	Bolt	40	Holder assembly
18	Gas spring	41	Locking cap
19	Bolt	42	Connection block
20	Nut	43	Lift flap
21	Bolt	44	Limit switch fixing plate
22	Flat pad	45	Eccentric block
23	Bolt	46	Guide plate

Scoring saw assembly



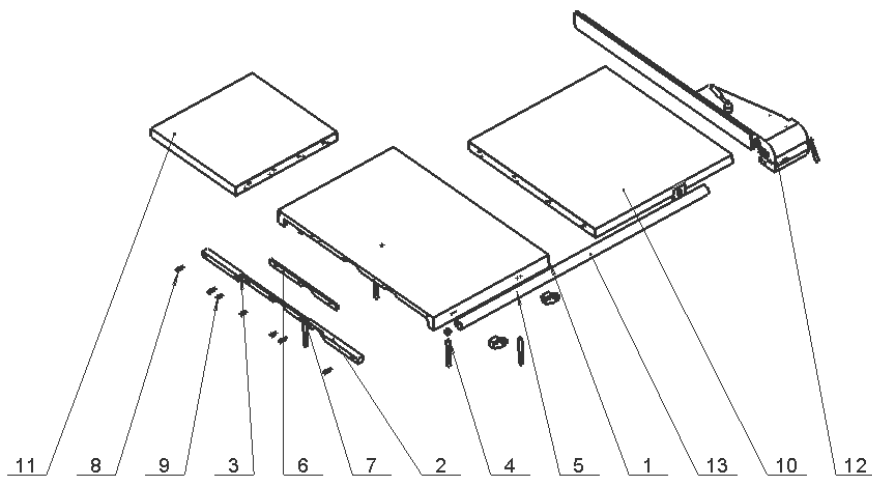
No.	Description	No.	Description
1	Snap ring	10	Scoring saw seat body
2	Spindle assembly	11	Copper bush
3	Adjustment shaft assembly	12	Scoring saw holder
4	Lock washer	13	Scoring saw pulley
5	Bolt	14	Chuck plate
6	Bolt	15	Chuck plate
7	Scoring blade	16	Nut
8	Bolt	17	Copper pad
9	Screw	18	Nylon locknut

Main saw assembly



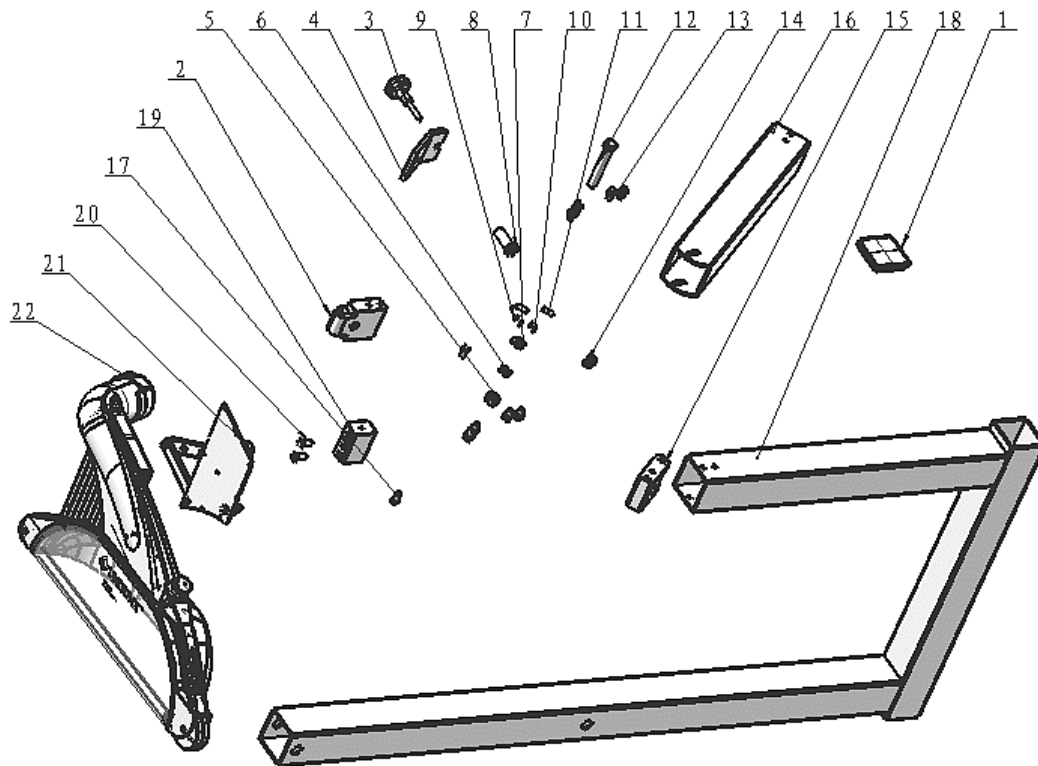
No.	Description	No.	Description
1	Main saw seat body	9	Inner plate
2	Wave washer	10	External splint
3	Bearing	11	Locking nut
4	Bearing	12	Bolt
5	Spindle	13	Bushing
6	Flange	14	Bolt
7	Fixing plate	15	Spindle assembly
8	Check plate	16	Saw blade

Fixed table assembly



No.	Description	No.	Description
1	Fixed table	8	Hexagon socket head cap screw
2	Saw aluminum guard A	9	Hexagon socket countersunk head screw
3	Saw aluminum guard C	10	Rear table
4	Screw	11	Side table
5	Hexagonal nut	12	Die holder assembly
6	Saw aluminum guard D	13	Die holder arbor
7	Saw aluminum guard B		

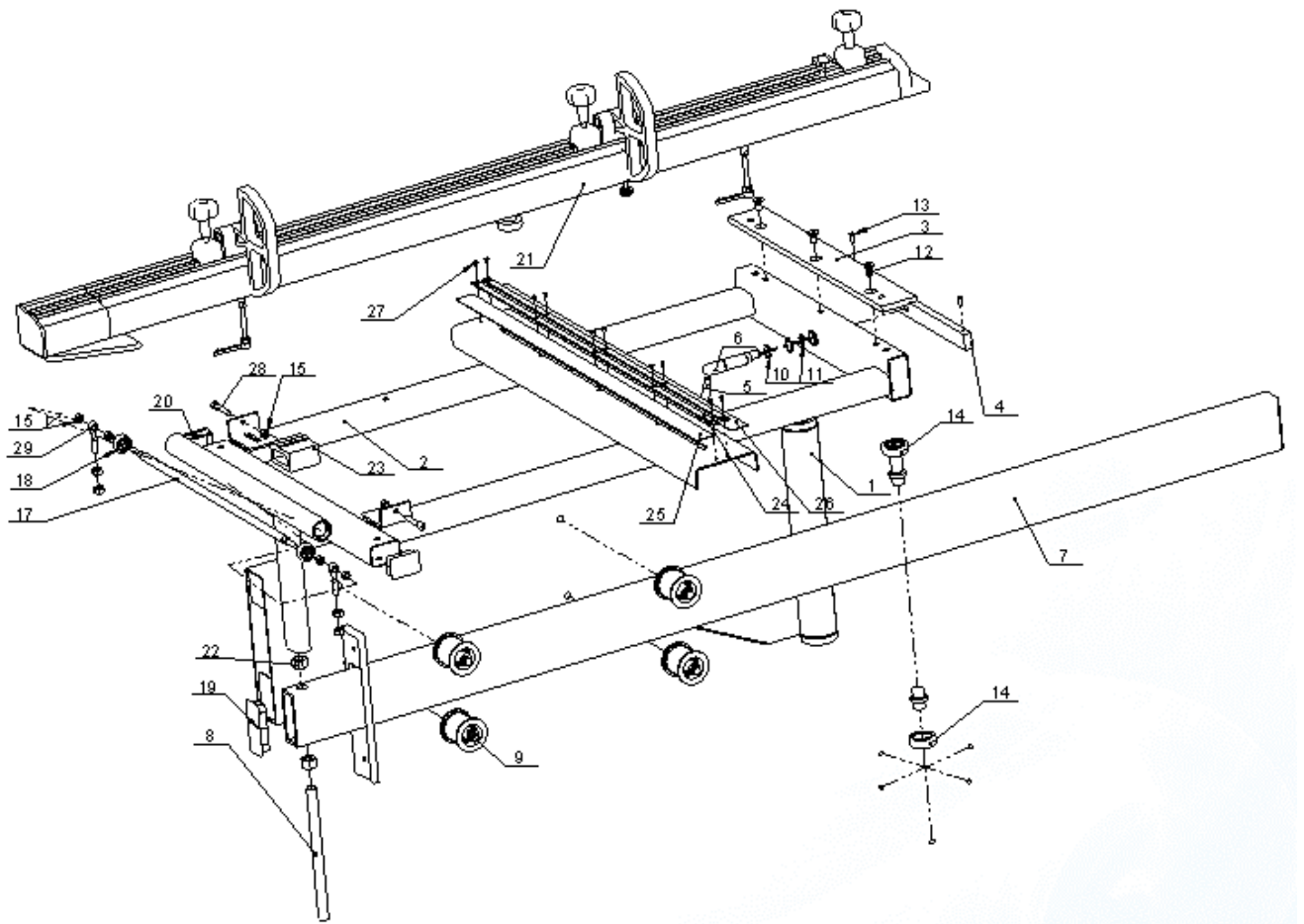
Dust hood assembly



No.	Description	No.	Description
1	Plastic plug	12	Bolt
2	Rotating block	13	Flat pad
3	Locking knob	14	Nut M20
4	Limit sheet	15	Rotating block B
5	Hexagon nut	16	Supporting rail B
6	Spring washer	17	Hexagonal bolt
7	Flat pad 16	18	Dust hood holder
8	Adjusting bolt	19	Dust hood block
9	Spring washer	20	Hexagonal bolt
10	Flat pad 8	21	Dust hood connecting rod
11	Hex head cap bolt	22	Dust hood assembly



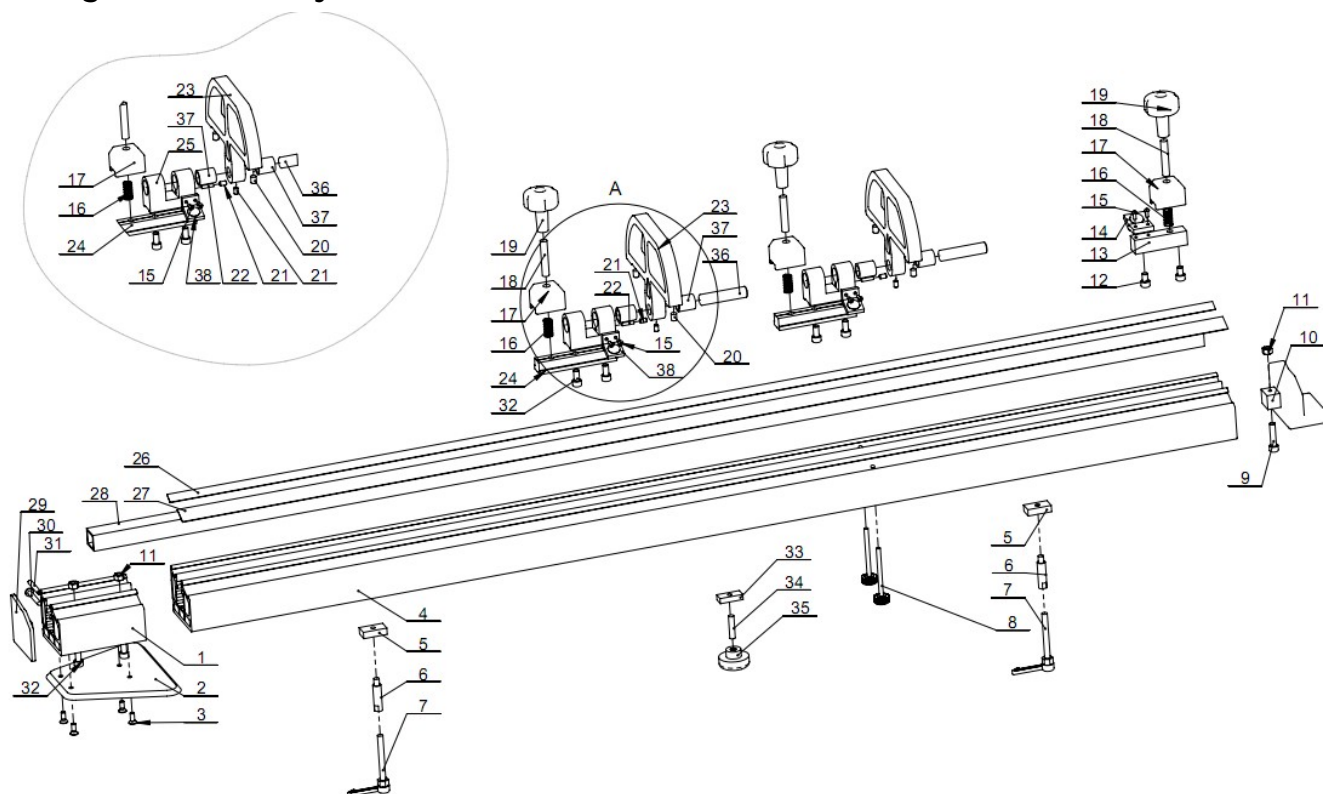
Bracket and arm



No.	Description	No.	Description
1	Tumbler weldment	16	Rotary drum
2	Auxiliary carriage	17	Drum shaft
3	Decorative board	18	Bearing
4	Locking block	19	Slide arm casing cap
5	Locking handle	20	Square tube casing cap
6	Eccentric shaft	21	Carriage ruler
7	Slide arm	22	Nut
8	Adjusting bolt	23	Block
9	Roller assembly	24	Aluminum strip
10	Ring	25	Left ruler
11	Retainer ring	26	Right ruler
12	Bolt	27	Bolt
13	Screw	28	Bolt
14	Bearing	29	Swivel bolt
15	Nut		



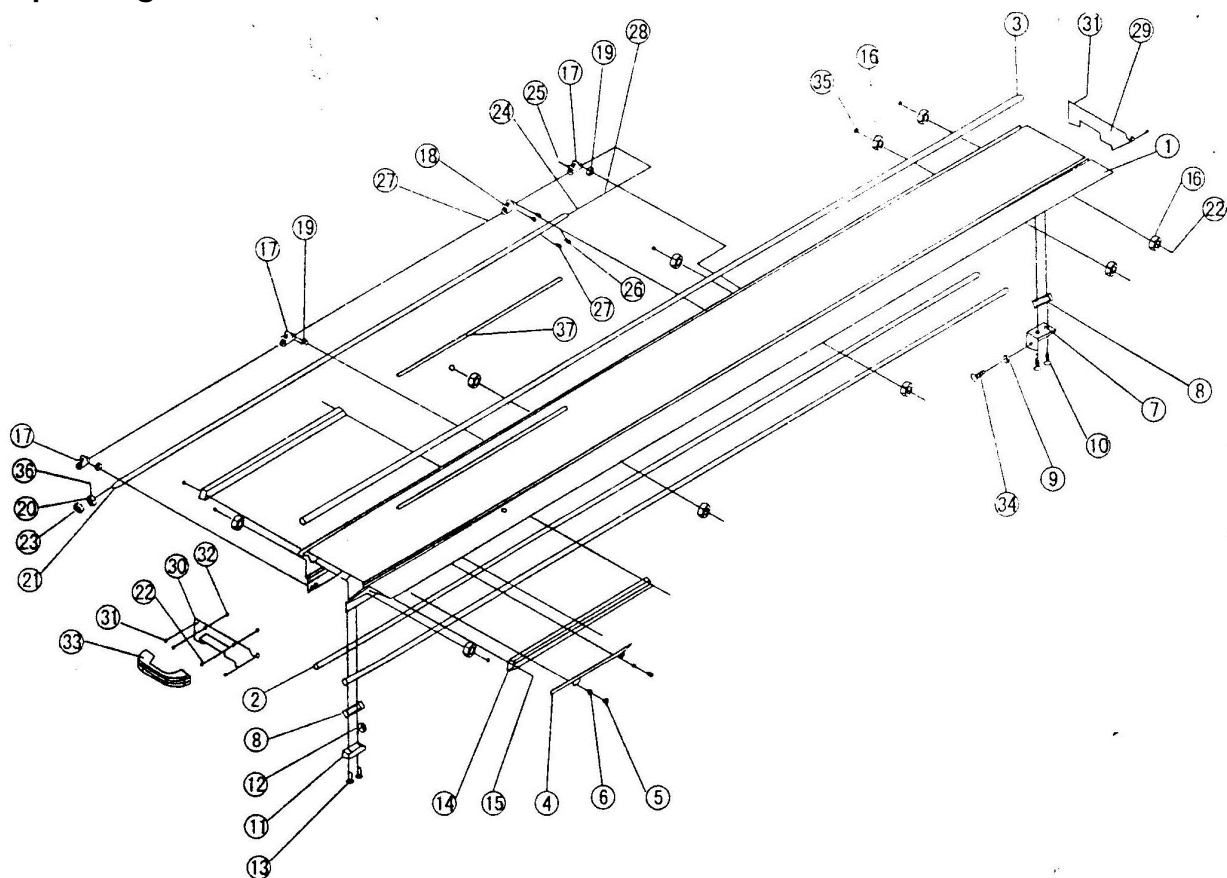
Carriage ruler assembly



No.	Description	No.	Description
1	Short rule table	20	Stop bolt
2	Tape measure pallet	21	Screw
3	Screw	22	Adjusting nylon rod
4	Ruler table	23	Baffle
5	Locking block	24	Base plate
6	Connecting bolt	25	Wheeling seat
7	Handle bolt	26	Scale
8	Bolt supporting ruler	27	Wide scale
9	Bolt	28	Inner tube of tape measure
10	Casing cap of tape measure	29	Front casing cap
11	Nut	30	Screw
12	Screw	31	Pin
13	Base	32	Bolt
14	magnifier 2	33	Angle locking block
15	Screw	34	Angle locking stud
16	Spring	35	Handle
17	Plastic base	36	Shaft
18	Stud	37	Copper sheath
19	Handle	38	Magnifier



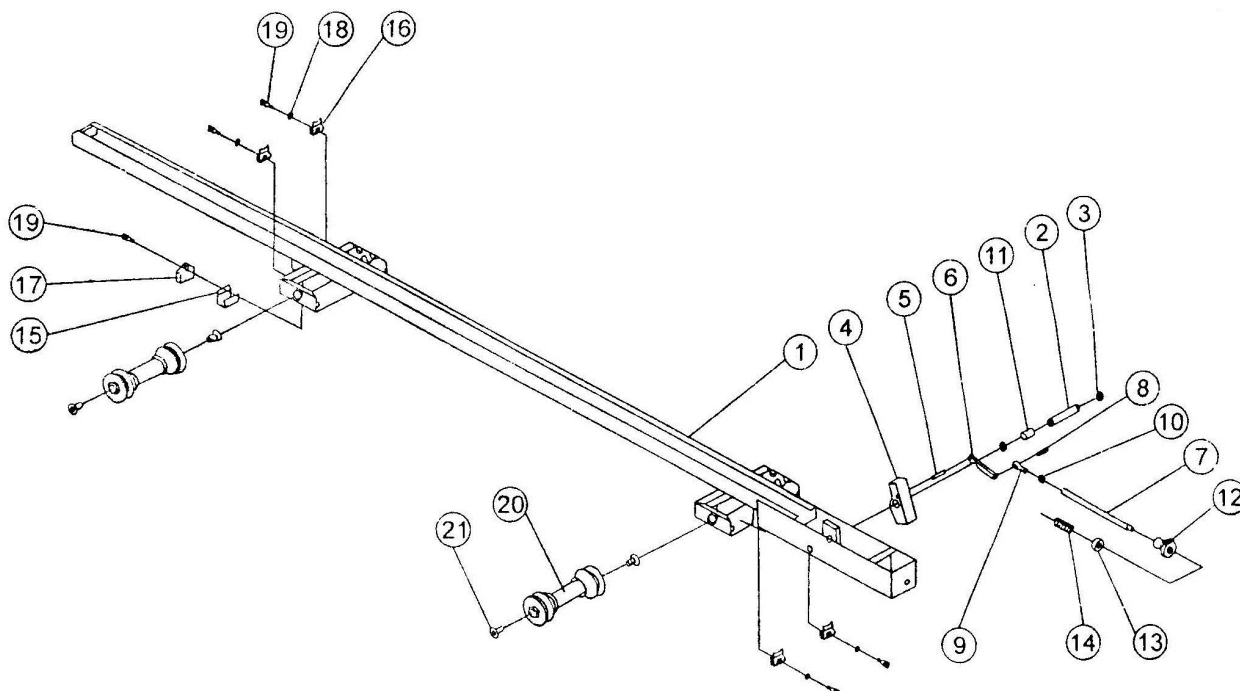
Top carriage



No.	Description	No.	Description
1	Top carriage 3200mm	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		



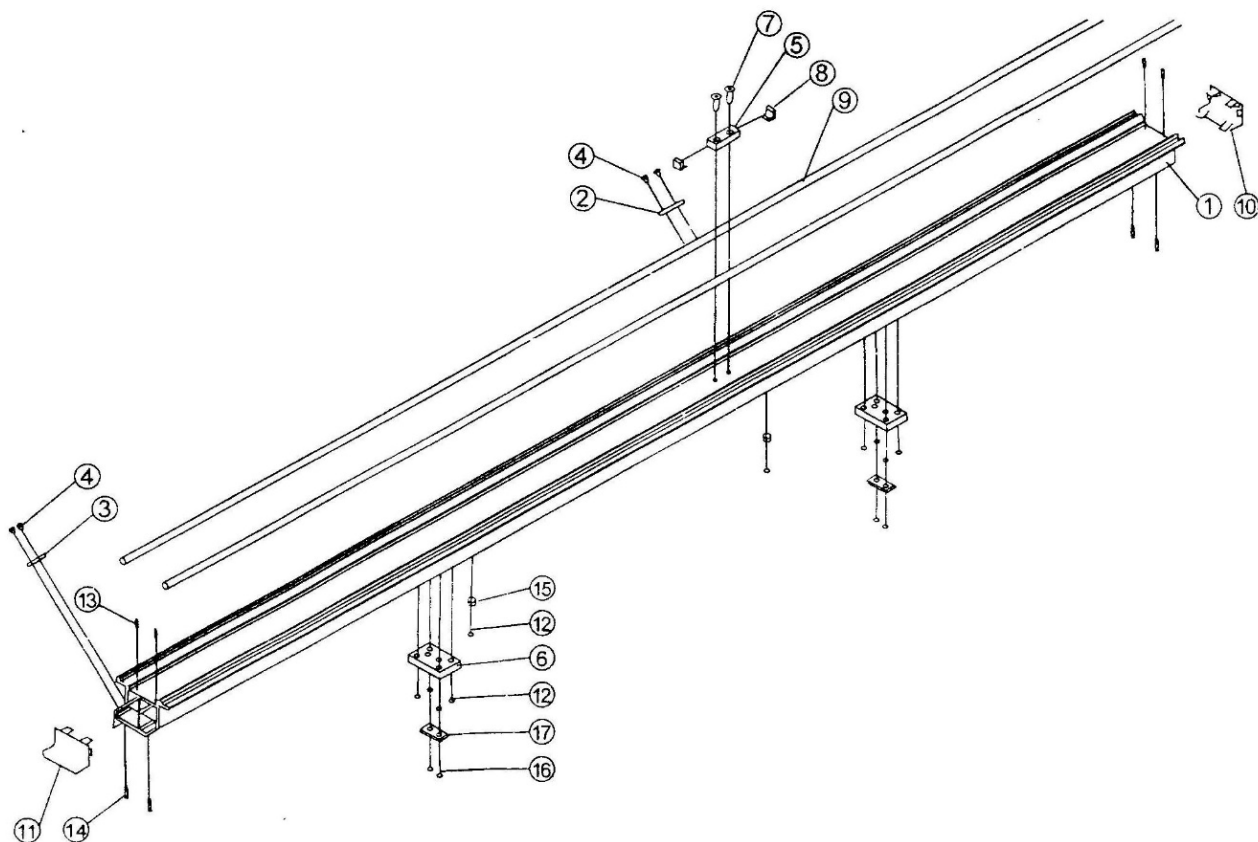
Middle carriage



No.	Description	No.	Description
1	Middle carriage	12	Mushroom knob
2	Eccentric shaft	13	Set collar
3	Washer	14	Pressure spring
4	Stop	15	Angle bracket
5	Slotted spring	16	Hair brush
6	Connection block	17	Bumper
7	Locking block	18	Washer
8	Slotted spring	19	Screw
9	Eye bolt	20	Roller
10	Hexagonal nut	21	Screw
11	Bush		



Bottom carriage



No.	Description	No.	Description
1	Bottom carriage	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

(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 naleznete online na stránce produktu v kategorii DOPORUČENÉ PŘÍSLUŠENSTVÍ PRO.