

Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN OPERATING MANUAL

ES INSTRUCCIONES DE SERVICIO

FR MODE D'EMPLOI

IT ISTRUZIONI PER L'USO

ABRICHT-DICKENHOBELMASCHINE

COMBINED PLANER AND THICKNESSER

GARLOPA MECÁNICA-REGRUESADORA

MACHINE A RABOTER ET A DEGAUCHIR

PIALLA COMBINATA A FILO E SPESSORE



HOB 260ABS



1 SICHERHEITSZEICHEN / SAFETY SIGNS / SEÑALES DE SEGURIDAD / SYMBOLES DE SÉCURITÉ / SEGNALI DI SICUREZZA

DE	SICHERHEITSZEICHEN BEDEUTUNG DER SYMBOLE	EN	SAFETY SIGNS DEFINITION OF SYMBOLS	ES	SEÑALES DE SEGURIDAD SIGNIFICADO DE LOS SÍMBOLOS
FR	SYMBOLES DE SÉCURITÉ SIGNIFICATION DES SYMBOLES	IT	SEGNALI DI SICUREZZA SIGNIFICATO DEI SIMBOLI		



- DE** **CE-KONFORM!** - Dieses Produkt entspricht den EG-Richtlinien.
- EN** **CE-Conformal!** - This product complies with the EC-directives.
- ES** **¡CONFORMIDAD CE!** - Este producto cumple con las directivas CE.
- FR** **CONFORMITÉ CE** - Ce produit répond aux directives CE.
- IT** **CONFORMITÀ CE!** - Questo prodotto è conforme alle direttive CE.



- DE** Anleitung beachten!
- EN** Follow the instructions!
- ES** ¡Observe el manual de instrucciones!
- FR** Respecter le manuel !
- IT** Osservare le istruzioni!



- DE** Benutzen von Handschuhen bei Arbeiten an rotierenden Teilen verboten!
- EN** Do not use gloves when working on rotating parts!
- ES** ¡Está prohibido usar guantes cuando se trabaja en componentes rotatorios!
- FR** Port de gants interdit lors des interventions sur des pièces en rotation !
- IT** Vietato utilizzare guanti quando si lavora su parti rotanti!



- DE** Persönliche Schutzausrüstung tragen!
- EN** Wear personal protective equipment!
- ES** ¡Use el equipo de protección individual!
- FR** Porter un équipement de protection individuelle !
- IT** Indossare i dispositivi di protezione individuale!



DE Warnung vor Schnittverletzungen!

EN Warning about cut injuries!

ES ¡Advertencia de sufrir lesiones producidas por cortes!

FR Attention aux coupures !

IT Attenzione alle lesioni da taglio!



DE Handverletzungen durch bewegte Teile!

EN Hand injury due to moving parts!

ES ¡Lesiones en las manos por las piezas móviles!

FR Blessures aux mains en raison des pièces mobiles !

IT Lesioni manuali dovute a parti in moto!

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

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

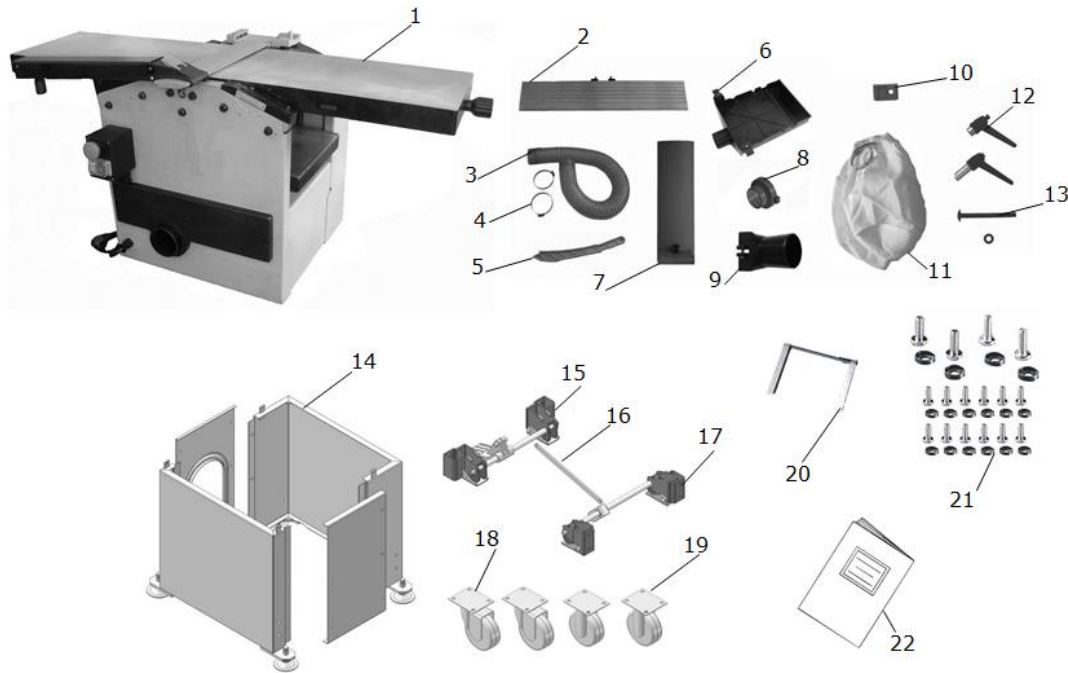
ES **¡Deben sustituirse inmediatamente los letreros de advertencia y/o las pegatinas que haya en la máquina, que se hayan vuelto ilegibles o se hayan retirado!**

FR **Les panneaux d'avertissement et/ou autocollants d'avertissement illisibles ou retirés sur la machine doivent être remplacés immédiatement !**

IT **I segnali di avvertimento e/o le etichette applicate sulla macchina, che sono illeggibili o sono stati rimossi, devono essere sostituiti immediatamente!**

2 TECHNIK / TECHNICS / TÉCNICA / TECHNIQUE / TECNOLOGIA

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



Nr.	Bezeichnung / Description / Denominación / Désignation / Denominazione	Nr.	Bezeichnung / Description / Denominación / Désignation / Denominazione
1	Abricht-/Dickenhobelmaschine / jointer & planer / Regruesadora / Raboteuse / Pialla combinata a filo e spessore	12	Fixierhebel / fixation handle / Palanca de fijación / Levier de fixation / Leva di fissaggio
2	Abrichtanschlag / planer fence / Tope de rectificado / Butée de dégauchissage / Arresto per pialla a filo	13	Stiftbolzen/ stud bolt / Tornillo prisionero / Goujon / Vite prigioniera
3	Absaugschlauch / cannulation / Tubo de aspiración / Tuyau d'aspiration / Tubo di aspirazione	14	Sockelelemente / base plates / Elementos de zócalo / Plaques de l'embase / Elementi di base
4	Schlauchschellen / hose clips / Abrazaderas / Colliers de tuyau / Fascette stringitubo	15	Vordere Lenkrollenhalterung / front caster support assembly / Soporte delantero de la rueda de dirección / Roulettes pivotantes avant / Supporto ruote orientabili anteriori
5	Schiebestock / sliding stick / Bastón de corredera / Bâton d'insertion / Spintore	16	Verbindungselement / connecting lever / Elemento de unión / Élément de connexion / Elemento di collegamento
6	Absauganschluss / dust collector / Conexión del sistema de aspiración / Raccord d'aspiration / Attacco aspirazione	17	Hintere Rollenhalterung / rear caster support assembly / Soporte trasero de la rueda fija / Support de roulettes arrières / Supporto ruote posteriori
7	Brückenschutzabdeckung / blade guard / Cubierta protectora del puente / Cache de protection de portique / Copertura di protezione ponte	18	Lenkrolle / swivel caster / Rueda de dirección / Roulettes d'orientation / Ruota orientabile

8	Schlauchadapter / hose adapter/ Adaptador de manguera / Adaptateur de tuyau / Adattatore tubo flessibile	19	Starre Rolle / rigid caster / Rueda fija / Roulette rigide / Ruota rigida
9	Absaugstutzen / suction socket / Tubuladuras de aspiración / Tubulure d'aspiration / Presa di aspirazione	20	Hobelmesserlehre/ planer knife gauge / Calibre para cuchilla recta / Gabarit de la lame de rabot / Dima per lame pialla
10	Platte / board / Placa / Plaque / Piastra	21	Schrauben Untergestell / screws base frame / Tornillos bastidor / Vis du châssis inférieur / Viti sottotelaio
11	Staubsaug / bag / Bolsa para el polvo / Sac à copeaux / Sacchetto raccogli-polvere	22	Bedienungsanleitung / manual / Instrucciones de uso / Mode d'emploi / Manuale d'uso

2.2 Komponenten & Bedienelemente / Componentes y elementos de mando / Composants et éléments de commande / Componenti ed elementi di comando



N°	Bezeichnung / description / Denominación / Désignation / Denominazione	N°	Bezeichnung /description / Denominación / Désignation / Denominazione
1	Abricht-Dickenhobelmaschine / combined planer and thicknesser / Garlopa mecánica-regruesadora / Machine à raboter et à dégauchir / Pialla combinata a filo e spessore	7	Dickenhobel-Tisch / thicknessing plane table / Mesa regruesadora / Table de la raboteuse / Banco pialla a spessore
2	Aufnahmetisch / entry planer table / Mesa de deposición / Table d'entrée / Banco di entrata	8	Handrad Dickeneinstellung / handwheel for thickness adjustment / Ajuste de grosor con volante / Volant de réglage de l'épaisseur / Volantino regolazione dello spessore
3	Abnahmetisch / back planer table / Mesa de retirada / Table de sortie / Banco di prelievo	9	Thermo-Schutzschalter (230V) / thermal circuit breaker (230V) / Disyuntor térmico (230 V) / Disjoncteur thermique (230V) / Interruttore termico di sicurezza (230V)

4	Brückenschutzabdeckung / blade guard / Cubierta protectora del puente / Cache de protection de portique / Copertura di protezione ponte	10	NOT-HALT-Taster / emergency stop switch / Pulsador de PARADA DE EMERGENCIA / BOUTON d'ARRÊT d'urgence / PULSANTE Arresto di emergenza
5	Abrichtanschlag / planer fence / Tope de rectificado / Butée de dégauchissage / Arresto per pialla a filo	11	Aus-Schalter / OFF switch / Interruptor de APAGADO / INTERRUPTEUR d'arrêt / INTERRUTTORE Off
6	Handrad Abrichttiefeintellung / handwheel for adjusting surface cutting depth / Ajuste de profundidad de rectificado con volante / Volant de réglage de la profondeur de dégauchissage / Volantino regolazione profondità di passata	12	Ein-Schalter / ON switch / Interruptor de ENCENDIDO / INTERRUPTEUR marche / INTERRUTTORE On

2.3 Technische Daten / Technical Data / Datos técnicos / Données techniques / Dati tecnici

Spezifikation / specification / Especificación / Spécifications / Specifica			
Spannung / voltage / Tensión / Tension / Tensione	V, Hz	230 V ~ 50	400 V ~ 50
Kabellänge / cable length / Longitud del cable / Longueur du câble / Lunghezza cavo	mm	1800	1800
Motor-Nennabgabeleistung / rated motor output power / Potencia nominal del motor / Puissance débitée utile absorbée du moteur / Potenza nominale del motore	kW	1.8	
Hobelmesseranzahl/ number of cutter knives / Cantidad de cuchillas rectificadoras / Nombre de lames de rabot / Numero lame pialla		2	
Hobelmesser Dimensionen / cutter block dimension / Dimensiones de las cuchillas rectificadoras / Dimensions de la lame de rabot / Dimensioni lame di piallatura	mm	258x2,5x20	
Messerwellen-Drehzahl / cutter block speed / Velocidad de las cuchillas rectificadoras / Vitesse de rotation d'arbre de lame / Velocità dell'albero portalamme	min ⁻¹	6700	
Absaugschlauch Länge / cannulation length / Longitud de la manguera de aspiración / Longueur du tuyau d'aspiration / Lunghezza tubo di aspirazione	mm	920	
Absaugstutzen Ø / suction socket Ø/ Ø boquillas de aspiración / Diamètre de la tubulure d'aspiration / Bocchettoni di aspirazione Ø	mm	75	
Dimension / overall dimensions / Dimensiones / Dimensions / Misura	mm	1160x590x600	
Nettogewicht / net weight / Peso neto / Poids net / Peso netto	kg	87	
Schallleistungspegel LWA (ISO 3746) / sound power level LWA / Nivel de potencia sonora LWA (ISO 3746) / Niveau de puissance acoustique L _{WA} (ISO 3746) / Livello di potenza sonora L _{WA} (ISO 3746)	dB(A)	96,2 k:3	
Schalldruckpegel LPA (ISO 11202) / sound pressure level LPA / Nivel de presión sonora L _{PA} (ISO 11202) / Niveau de pression acoustique L _{PA} (ISO 11202) / Livello di pressione sonora L _{PA} (ISO 11202)	dB(A)	83,2 k:3	

Abrichthobel / surface planer / Garlopa mecánica / Dégauchisseuse / Pialla a filo		
Max. Abrichthobelbreite / max. planing width / anchura máx. de rectificado / Largeur max. du rabot de dégauchissage / Max. larghezza pialla a filo	mm	254
Max. Abrichtdicke / max. cutting depth / profundidad máx. de corte / Épaisseur maximale de dégauchissage / Max. spessore a filo	mm	3
Schwenkbereich Abrichtanschlag / angle range of planer fence / zona de giro del tope de rectificado / Battement de la butée de dégauchissage / Area di rotazione arresto pialla a filo	°	90-45
Abrichttisch Dimension / working table dimension / dimensiones del tupí / Dimensions de la table de dégauchissage / Dimensioni banco piallatura a filo	mm	1050x260
Abrichtanschlag Dimension / planer fence dimension / dimensiones del tope de rectificado / Dimensions de la butée de dégauchissage / Dimensioni arresto pialla a filo	mm	643x126
Dickenhobel /thickness planer / Regruesadora / Rabot d'usinage en épaisseur / Pialla a spessore		
Max. Arbeitsbreite (Werkstückbreite) / max. cutting width / anchura máx. de corte (anchura de la pieza de trabajo) / Largeur max. de travail (largeur de la pièce à usiner) / Max. larghezza di lavoro (larghezza pezzo da lavorare)	mm	254
Max. Arbeitshöhe (Werkstückhöhe) / max. cutting thickness / altura máx. de corte (altura de pieza de trabajo) / Hauteur max. de travail (hauteur de la pièce à usiner) / Max. altezza di lavoro (altezza pezzo da lavorare)	mm	160
Max. Spanabnahme / max. cutting depth / retirada máx. de virutas / Profondeur max. de rabotage / Max. asportazione di truciolo	mm	2
Arbeitstisch Dimensionen / dimensions working table / dimensiones de la mesa de trabajo / Dimension de la table de travail / Piano di lavoro dimensioni	mm	480x254

(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.

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

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

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

12 PREFACE (EN)

Dear customer!

These operating instructions contain information and important notes for safe commissioning and handling of the HOB260ABS combined planer and thicknesser, hereinafter referred to as the "machine".



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

Please pay special attention to the chapter Safety!

Due to the constant further development of our products, illustrations and contents may differ slightly. If you notice any errors, please inform us.

Technical changes reserved!

Check the goods immediately after receipt and make a note of any complaints on the consignment note when the delivery person takes them over!

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

Holzmann cannot accept any liability for transport damage not noted.

Copyright

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13 SAFETY

This section contains information and important notes for safe commissioning and handling of the HOB 260ABS combined planer and thicknesser.



For your safety, please read these operating instructions carefully before start-up. This will enable you to handle the machine safely and prevent misunderstandings as well as personal injury and damage to property. In addition, observe the symbols and pictograms used on the machine as well as the safety and danger information!

13.1 Intended Use of the Machine

The planer thicknessing machine is designed for the processing of wood or wood-like materials (e.g. fibreboards, pressed wood boards, chipboards, plywood, laminated and unlaminated boards) with rectangular or square cross section.

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

13.1.1 Technical Restrictions

The machine is intended for use under the following ambient conditions:

Rel. Humidity:	max. 90 %
Temperature (Operation)	+1° C to +40° C

The machine is not intended for outdoor use!

13.1.2 Prohibited applications / Hazardous misapplications

- Operating the machine without adequate physical and mental aptitude
- Operating the machine without knowledge of the operating instructions
- Changes in the design of the machine
- Operating the machine in a potentially explosive environment
- Operating the machine outside the specified ambient conditions
- Remove the safety markings attached to the machine.
- Modify, circumvent or disable the safety devices of the machine.
- Machining of materials with dimensions outside the limits specified in this manual.
- Use tools that do not meet the safety requirements of the standard for woodworking machine tools (EN847-1).
- Cleaning the machine with water, neither with the power switched on nor with the power switched off.

The improper use or disregard of the versions and instructions described in this manual will result in the voiding of all warranty and compensation claims against Holzmann Maschinen GmbH.

13.2 User Requirements

The machine is designed to be operated by one person! The physical and mental suitability as well as knowledge and understanding of the operating instructions are prerequisites for operating the machine.

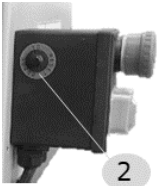
Please note that local laws and regulations may determine the minimum age of the operator and restrict the use of this machine!

Take off rings, bracelets, watches, chains etc. before working on the machine, tie long hair together if necessary, always wear closed, close-fitting clothing when working on the machine and always fold long sleeves inwards only.

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

13.3 Safety Devices

The machine is equipped with the following safety devices:

	• An EMERGENCY STOP button (1) to stop dangerous movements at any time.
	• Thermal circuit breaker (2) against overheating of the motor (for 230V). If the motor is overloaded or there is a power failure, the motor switches off automatically. The machine cannot be switched on again until the motor has cooled down or the power supply has been restored.
Blade guard (blade shaft cover)	• Separating protective device: Prevents contact with the rotating cutter spindle when planing workpieces.
Separating protective device behind planer fence	• Separating protective device (fixed): To be remove before changing to thicknesser mode
Belt and chain cover	• Separating protective device (fixed): This protective device must be removed before maintenance work.
	• Safety keys on the left and right of the dust collector: keys must be pressed in completely (a clear click sound must be heard) to allow the machine to start.
	• Safety lever left and right on the underside of the surface planing table (automatically engages when the table is folded up).

13.4 Safety instructions

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

- Before commissioning, check the machine for completeness and function. Only use the machine if the guards and other non-separating guards required for machining are fitted, are in good operating condition and have been properly maintained.
- Choose a level, vibration-free, non-slip surface for the installation location.
- Ensure sufficient space around the machine!
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects!
- Ensure a clean working environment!
- Only use suitable tools that are free of cracks and other defects (e.g. deformations).
- Remove setting tools from the machine before switching it on.
- Keep the area around the machine free of obstacles (e.g. dust, chips, etc.).
- Check that the machine is in perfect condition before each use.
- Never leave the running machine unattended.
- The machine may only be operated, maintained or repaired by persons who are familiar with it and who have been informed of the dangers arising in the course of this work.
- Ensure that unauthorised persons maintain a safe distance from the machine and keep children away from the machine.

- Wear suitable work clothing (eye protection, ear protection, dust mask, safety shoes) and close-fitting protective clothing - never loose clothing, ties, jewellery, etc. - danger of being drawn in!
- Work with gloves is not permitted!
- Hide long hair under hair protection.
- Do not remove splinters and chips by hand, use a sliding stick instead!
- Do not remove any sections or other parts of the workpiece from the cutting area while the machine is running!
- Use a sliding stick!
- Only operate the machine with an effective extraction system.
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine!
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!
- Do not use the machine in areas where vapours from 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)!
- Make sure that the main switch is in the "O" position before connecting the machine to the power source.
- Ensure that the machine is earthed.
- Only use suitable extension cords.
- Always shut down the machine before carrying out any conversion, adjustment, measuring, cleaning, maintenance or repair work and always disconnect it from the power supply for maintenance or repair work. 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 restarting.

13.5 Electrical Safety

- Make sure that the machine is earthed.
- Only use suitable extension cords.
- A damaged or tangled cable increases the risk of electric shock. Handle the cable with care. Never use the cable to carry, pull or disconnect the machine. Keep the cable away from heat, oil, sharp edges or moving parts.
- Proper plugs and sockets reduce the risk of electric shock.
- Water that enters the machine increases the risk of electric shock. Do not expose the machine to rain or moisture.
- The machine may only be used in humid environments if the supply is protected by a residual current circuit breaker.
- Do not use the machine if it cannot be turned on and off with the ON/OFF switch.

13.6 Special Safety Instructions for that machine

- Work with gloves on rotating parts is not permitted!
- Wood dust is generated when the machine is in operation. Therefore, connect the machine to a suitable extraction system for dust and chips during installation!
- Never remove chips or other parts of the workpiece from the cutting area while the machine is running.
- When using milling tools with a diameter of ≥ 16 mm and circular saw blades, these must comply with EN 847-1:2013 and EN 847-2:2013; tool carriers must comply with EN 847-3:2013;
- Excessive noise can cause hearing damage and temporary or permanent hearing loss. Wear hearing protection certified to health and safety regulations to limit noise exposure.
- Only use blades that are suitable for that machine.

13.7 Hazard Warnings

Despite the intended use of the machine, certain residual risks remain.

13.7.1 Residual risks:

- Risk of injury caused by tools, especially when changing tools
- Risk of injury caused by workpieces/workpiece parts that can be thrown away
- Risk of injury caused by kickback of the workpiece.

Due to the design and construction of the machine, hazardous situations may occur when handling the machines, which are identified as follows in these operating instructions:

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



Such a safety instruction indicates a potentially hazardous situation which, if not avoided, may result in serious injury or even death.

CAUTION



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

NOTE



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

Irrespective of all safety regulations, your sound common sense and corresponding technical suitability/training are and remain the most important safety factor in the error-free operation of the machine. **Safe working depends first and foremost on you!**

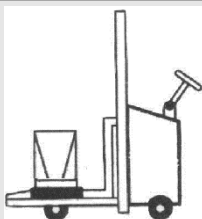
14 TRANSPORT

WARNING



Damaged or not sufficiently viable hoists and lifting devices can cause serious injury or even death. Always check hoists and load lifting devices for adequate load-bearing capacity and perfect condition, carefully fasten the loads and never keep them under suspended loads.

NOTE



You can use a pallet truck or forklift truck to transport the machine in the packaging.

To ensure proper transport, also observe the instructions and information on the transport packaging regarding centre of gravity, attachment points, weight, means of transport to be used and the prescribed transport position, etc.!

The machine is transported with the integrated castors, which can be folded up for the purpose of changing location.

15 ASSEMBLY

15.1 Preparatory Activities

15.1.1 Checking the delivery content

Check the machine immediately after delivery for transport damage, missing parts and loose screw connections. Report any damage or missing parts immediately to your dealer or freight forwarder. Visible transport damage must be noted immediately on the delivery note in accordance with the warranty provisions, otherwise the goods are deemed to have been properly taken over.

15.1.2 Selecting a suitable installation location

- Choose a suitable place for the machine.
- Pay attention to the safety requirements and the dimensions of the machine.
- The selected location must ensure a suitable connection to the electrical supply as well as the possibility of connection to an extraction system.
- Make sure that the floor can support the load of the machine.
- The machine must be levelled simultaneously at all support points.
- It is also necessary to guarantee a distance of at least 0.8 m around the machine.
- In front of and behind the machine, the necessary distance must be provided for the feeding of long workpieces.

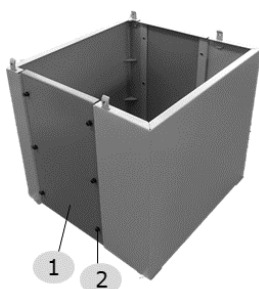
15.2 Assembly of the Parts Dismantled for Transport

The machine is pre-assembled. The parts that have been disassembled for transport must be assembled before use. Follow the instructions below:

NOTE

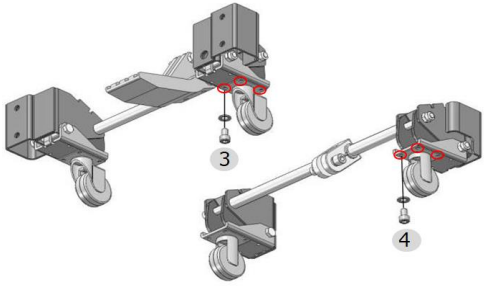
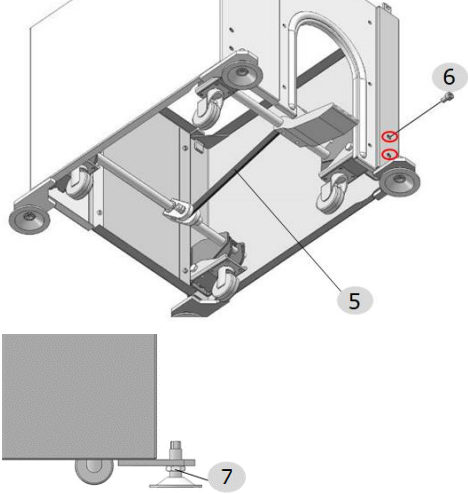
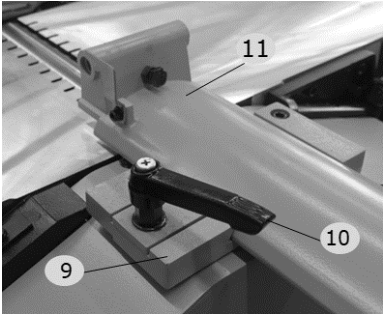


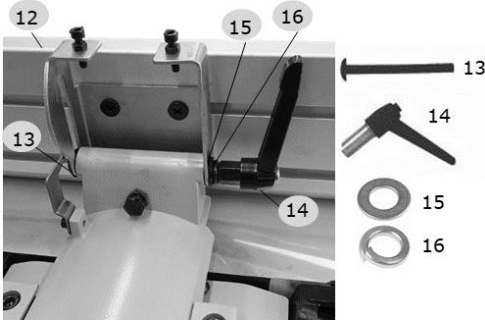
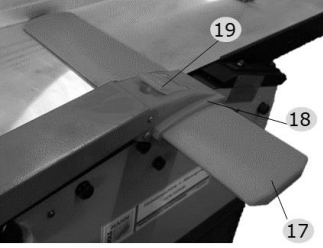
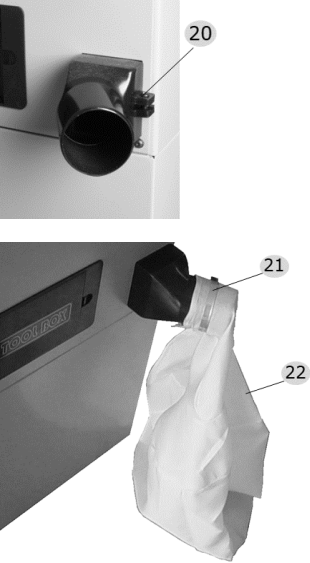
After assembly, fasten the planer thickening machine to the floor with screws.



1. Assembly socket

- Mount the red socket elements (**1**) between the grey elements.
- You need six screws and washers (**2**) for each element.

	2. Assembly of castors - Mount the two swivel castors on the front castor bracket using four screws and washers (3). - Mount the two rigid castors to the rear castor bracket using four screws and washers (4) each.
	- Mount the connecting element between the front and rear castor bracket (5). - Attach the front and rear castor bracket to the socket and fasten them with two screws (6) at each corner. - Place the socket with the castors on the floor. Make sure that the castors are folded up and adjust the foot height (7) if necessary.
	- Now lift the machine onto the socket. NOTICE: The machine is heavy - please get assistance from a second person when transporting the machine and ensure the correct body posture when lifting, carrying and setting down the load: <u>Lifting, Depositing</u> Ensure stability when lifting / setting down (legs hip width). Lift / lower load with bent knees and straight back (like weightlifter). Do not lift / lower the load jerkily. <u>Carrying</u> Carry load with both hands as close to body as possible. - The machine is fixed in this position with four screws and washers (8).
	3. Assembly planer fence - Screw the fixing lever (10) to the already mounted guide (9). - Insert the planer fence (11) into the guide (9). The fixing lever (10) must be opened for this purpose. - To fix the planer fence (11) in the desired position, the fixing lever (10) must be locked again.

	• Subsequently, the guard behind the planer fence (12) is attached to the planer fence (11). • For this purpose, the bolt (13) is inserted into the boreholes and the fixing lever (14) with a washer (15) and a spring ring (16) is screwed on.
	4. Assembly blade guard • Slide the orange blade guard (17) into the red support (18). The orange locking knob (19) must be released for this purpose. • The locking knob (19) is arrested to fix the blade guard in the desired position.
	5. Assembly dust bag • Attach the suction socket to the machine and fix it with the screw (20). • Attach the dust bag (22) with a hose clip (21).
	

15.3 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!

NOTE



Immediately after making the electrical connection, check the direction of rotation of the cutter spindles. The direction of rotation is correct if the cutter spindles rotate in the opposite direction to the feed direction. If this is not the case, change the connection points of the phase conductors and repeat the check until the direction of rotation of the shafts is correct.

The machine is operated with high voltage current (400 V, 3~, 50 Hz). The use of 16 A fuses is recommended.

15.3.1 Establishing a 400V connection

To connect the machine to the electrical mains, proceed as follows:

- Use a suitable device to check that the zero connection and earthing are working properly.
- Check that the supply voltage and its frequency correspond to the specifications on the machine nameplate. A deviation of $\pm 5\%$ from the value of the supply voltage is permissible. For example, a machine with a working voltage of 380 V can work in the voltage range from 370 to 400 V. The machine can be operated with a working voltage of 380 V in the voltage range from 370 to 400 V. The machine can also be operated with a working voltage of 380 V in the voltage range from 370 to 400 V. There must be a short-circuit fuse in the power supply of the machine!
- For the required cross-section of the supply cable, please refer to the current carrying capacity table.
- The use of a cable of type H07RN (WDE0282) is recommended, whereby measures must be taken to protect against mechanical damage.
- Connect the supply cable to the appropriate terminals in the input box (L1, L2, L3, N, PE) - see following figure. If there is a CEE plug, the connection to the mains is made by an appropriately supplied CEE coupling (L1, L2, L3, N, PE).

Plug connection 400V:	5-wire: with N-conductor 	4-wire: without N-conductor 
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15.4 Connecting to a dust collection system

NOTE



The machine must be connected to dust collection system. The system must start up at the same time as the motor of the band saw starts. The suction hoses used must be flame-retardant (DIN4102 B1), permanently antistatic (or grounded on both sides) and comply with the relevant safety regulations.

16 OPERATION

16.1 Operating Instructions

WARNING



Handling the machine while it is connected to the power source can result in serious injury or even death. Always disconnect the machine from the power supply before carrying out retrofitting work and secure it against unintentional restart!

CAUTION



Never start the machine with a workpiece pressed down!

NOTE

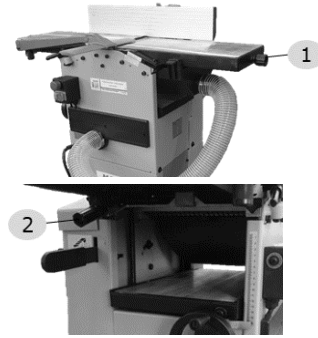
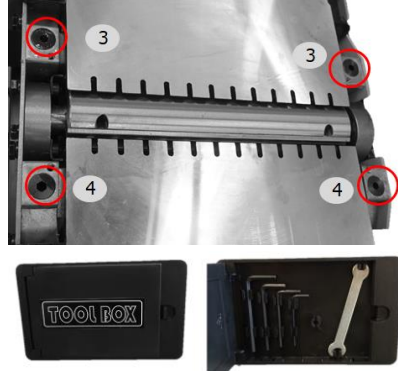
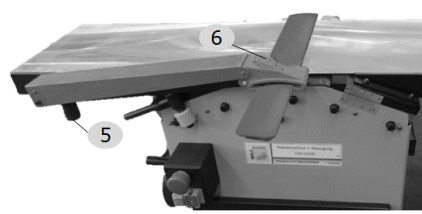


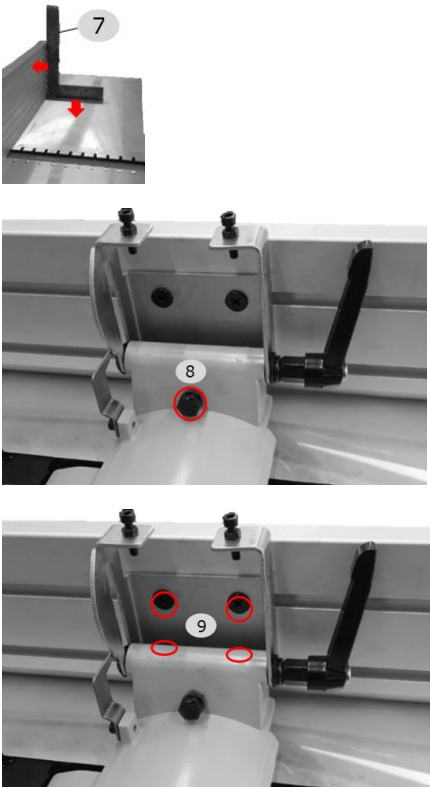
In the case of resin residues on the wood, it may be advisable to apply an appropriate lubricant to the machine table in order to ensure uniform sliding of the workpiece over the planing table.

16.2 Initial check before starting work:

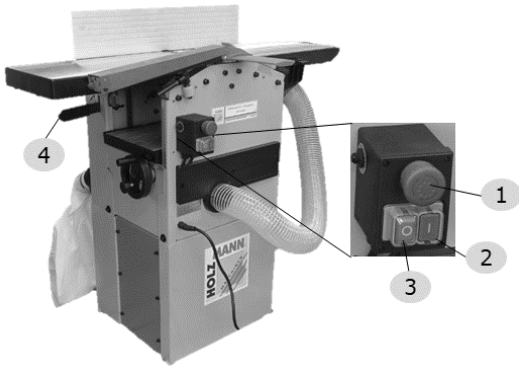
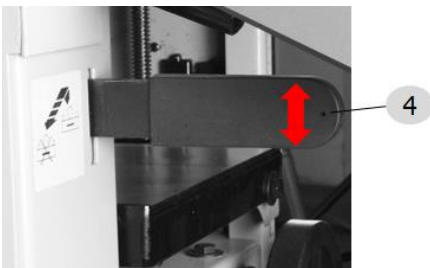
- Check that all guards are installed.
- Check whether suitable planing knives have been correctly assembled.
- Whether the planer shaft knives are worn out; replace knives if necessary (see Maintenance section)
- Check whether the connection to a dust collection system is available.
- Check that the planer shafts rotate in the correct direction.

16.3 Settings

	1. Height adjustment of the planing tables <u>Entry planer table</u> The cutting thickness is set with the adjusting screw (1). <u>Back planer table</u> The height of the back planer table can be adjusted with the adjusting screw (2).
	2. Setting infeed / outfeed roller The pressure force of the spring-mounted infeed and outfeed roller is factory-set. • If it is necessary to change the pressure force, it can be adjusted with the screws (3 and 4). • The Allen key required for the adjustment can be found in the toolbox, which is located at the rear of the machine.
	3. Setting arm and blade guard • The desired height of the blade guard is adjusted with the adjusting screw (5) below the arm. • After loosening the orange locking knob (6), the blade guard can be moved in horizontal direction and adapted to the size of the workpiece. • This orange locking knob is relocked when the desired position is reached.

	4. Setting planer fence The alignment of the planer fence at right angles should be checked again before initial operation and readjusted if necessary to achieve an exact planing result. • The angle is measured with a protractor (7). This is placed on the planer table and applied to the planer fence. • If it is not possible to place the protractor completely against the planer fence, the planer fence is not set exactly at right angles and an adjustment is necessary. • The angle is adjusted with the screw (8). NOTICE: If the planer fence cannot be moved back completely, the height can be adjusted with the four screws (9).
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16.4 Operation

	16.4.1 Starting the machine Switch on the motor by pressing the green ON-button (2). 16.4.2 Stopping the machine Switch off the motor by pressing the red OFF-button (3). 16.4.3 Emergency stop switch In emergencies, hazardous movements can be stopped at any time by pressing the emergency stop switch (1). NOTICE: The emergency stop switch is unlocked by turning it clockwise.
	16.4.4 Activating/Deactivationg the thicknesser feed <u>Ativate feed:</u> Swivel the lever (4) upwards. The feed is activated. <u>Deactivated feed:</u> Swivel the lever (4) downwards. The feed is deactivated.

16.5 The dust collecting port

Planer:

The dust collector is under the entry planer table.



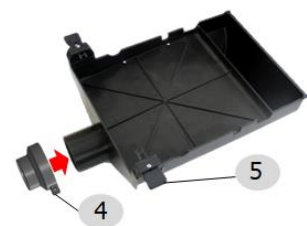
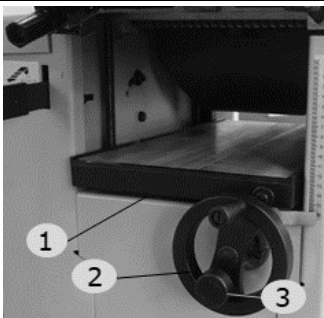
Thicknesser:

After conversion to thickness planing, the dust collector is folded upwards.



Do not operate the machine without a connected extraction system.

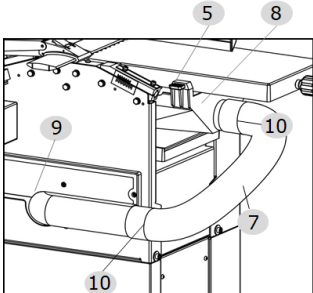
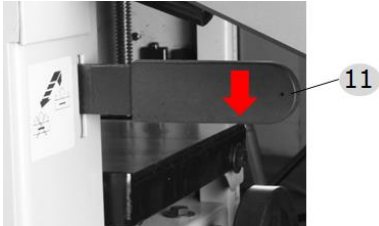
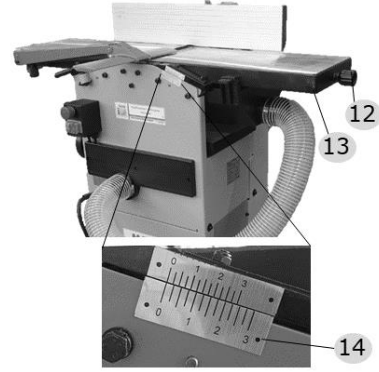
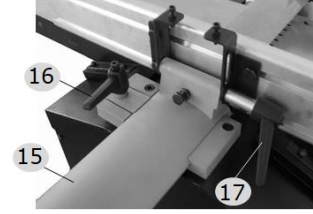
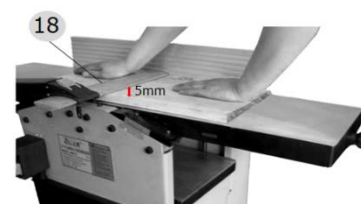
16.6 Conversion to planing



1. Assembly dust collector

- Loosen the clamp (3) and set the thickening table (1) with the hand wheel (2) in the lowest position.
- Retighten the clamp (3).
- Attach the adapter to the dust collector and fix it by tightening the screw (4).
- Pull out the brackets (5) on both sides of the dust collector.
- The dust collector is positioned so that the two brackets (5) are in line with the longitudinal boreholes (6).
- Then press the brackets (5) into the longitudinal boreholes (6) until you hear a clear clicking sound.

NOTICE: A safety switch is integrated in the longitudinal hole at the front of the machine, which guarantees that the machine can only be started when the brackets of the dust collector are fully engaged.

	• Attach the suction hose (7) both to the dust collector (8) and to the machine (9) and secure it with two hose clamps (10).
	• Before starting planing, the machine must be switched to the planing function. • To do this, the lever (11) is swivelled downwards to avoid unnecessary rotation of the feeding rollers.
	• The desired cutting depth is set with the adjusting screw (12), which is located at the front of the entry planer table (13). • With the aid of the scale (14), the set cutting depth can be read off. A cutting depth between 0.5 and 1.5 mm (1/64~1/16 in.) provide the best surface quality.
	• Fix the planer fence (15) in the desired working position with the fixing lever (16). • The angular adjustment of the planer fence is fixed with the angular fixing lever (17).
	• Adjust the blade guard (18) so that there is a distance of approx. 5 mm between the guard and the workpiece.

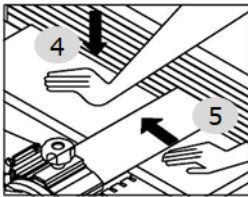
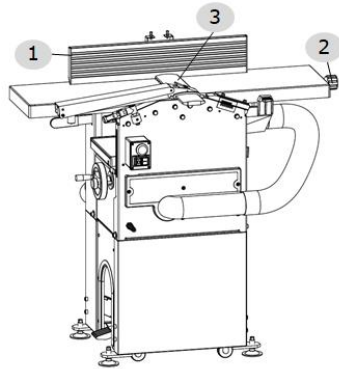
16.7 Planing

WARNING



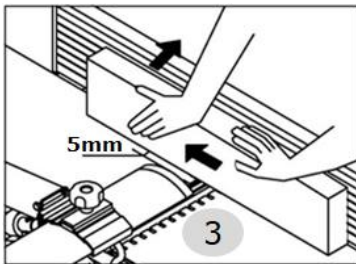
The unused part of the planing shaft must be covered by the cover. Never touch the edges of the workpiece with your fingers, but always leave both hands on the workpiece with your fingers when planing. If the workpiece is short and narrow, use the sliding stick.

Only plane workpieces that rest firmly on the machine and that can be guided safely!



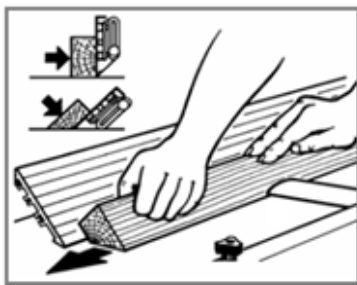
- Fix the planer fence (1) in the desired working position.
- Set the desired cutting depth on the adjusting screw (2).
- Adjust the blade guard (3) so that the distance between the cover and the workpiece is approx. 5mm.
- Start the machine on by pressing the ON-button.
- Press the workpiece against the entry planer table with one hand (4).
- With the second hand (5), push the workpiece slowly and evenly over the shaft.
- After finishing the operation, switch off the machine by pressing the OFF-button.
- Wait until the shaft has come to a standstill before carrying out any further work!

16.7.1 Planing of small workpieces



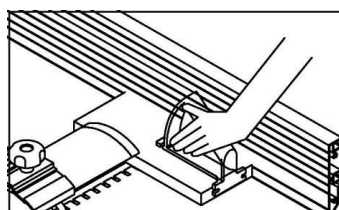
- Lower the blade guard (3) so that the shaft is covered.
- Move the blade guard to the workpiece and fix it with a distance of approx. 5mm.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.
- Push the workpiece slowly and evenly over the shaft with the second hand.

16.7.2 Planing of with tilted planer fence



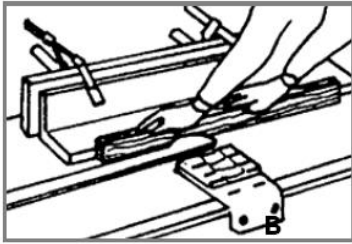
- Loosen the fixing lever of the planer fence (1).
- Place the workpiece against the planer fence.
- Adjust angle, fix planer fence.
- Lower the blade guard (3) so that the shaft is covered.
- Adjust blade guard, 5mm distance to workpiece.
- Switch on the machine.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.
- Push the workpiece slowly and evenly over the shaft with the second hand.

16.7.3 Planing of short workpieces



- When planing, workpieces with a small cross-section, an additional wood angle must be fitted!
- Adjust planer fence and blade guard to the size of the sliding wood.
- Place the workpiece on top and push it slowly and evenly over the shaft using the sliding wood.
- After use, the sliding wood must be reattached on his place on the side of the machine.

16.7.4 Surface planing of workpieces with a small cross section



- When planing workpieces with a small cross-section, an additional wood angle must be mounted!
- Fasten the wood angle to the planer fence as shown using lever clamps.
- When planing, place the workpiece on the planer table and press it against the additional wood angle and planer table.
- Place the workpiece on top and push it slowly and evenly over the shaft using the sliding wood.

16.8 Thicknessing

NOTICE



It is necessary to modify/adjust the machine before using as a thicknesser.

WARNING

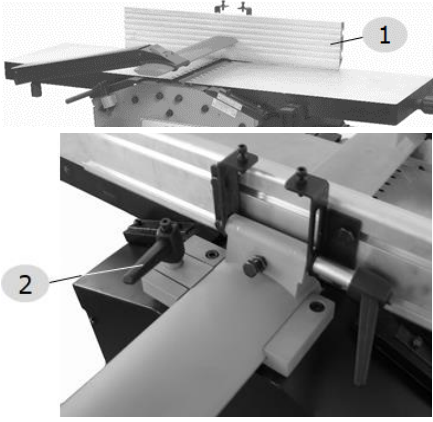
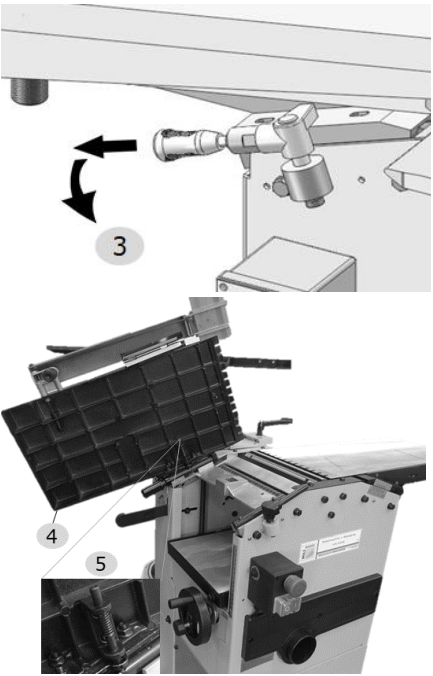
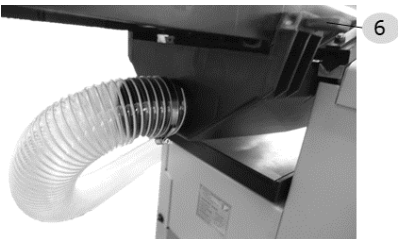


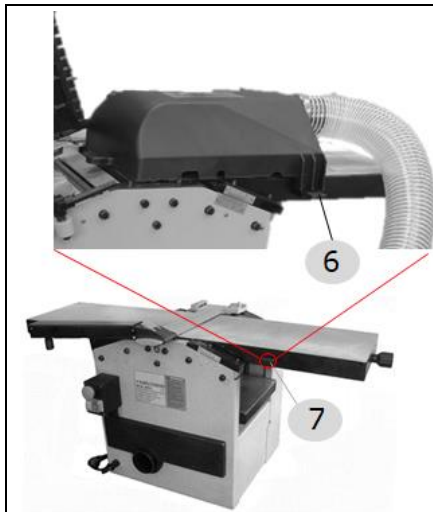
Before carrying out any modification, the machine must be switched off and secured against being switched on again.

16.8.1 Working conditions for thicknessing

- Long, protruding workpieces must be sufficiently supported! Use suitable aids such as roller blocks etc. for this purpose. If you do not follow these instructions, there is a danger of the workpiece being raised up quickly and/or the machine being tilted!
- Use the thicknessing function only to reduce the thickness of a workpiece with an already surface planed facing!
- For workpieces with a difference in thickness, the chip removal must be measured at the maximum thickness and the workpiece machined with this side first.
- Make sure that the workpiece to be machined is free of foreign objects and/or knots in order to avoid dangerous fractures.
- Only plane workpieces that rest firmly on the machine and can be guided safely!
- If several workpieces are to be processed in series, all pieces of the same thickness should be run through in succession without changing the setting.
- Perform the machining process from the beginning until the desired thickness is achieved.

16.8.2 Converting machine to thicknessing function

	1. Disassembly planer fence First remove the planer fence (1) by loosening the fixing lever (2).
	Pull out and turn the handle (3) to release the table lock and swivel the back planer table (4) upwards. NOTICE: To release the fixing of the back planer table (4) and tilt it down again, pull out the engaged safety lever (5).
	To dismantle the dust collector in the position for planing, pull out the two brackets (6).



- Now you need to install dust collector to the surface of the entry planer table.
- Both brackets (6) need to correspond in their position with the longitudinal boreholes (7) at the entry planer table.
- Then press both brackets (6) into the longitudinal boreholes until you hear a clear "clicking sound".

NOTICE: a safety switch is integrated in the longitudinal hole at the front of the machine. For this reason, the machine can only be started when the dust collector brackets are fully engaged.

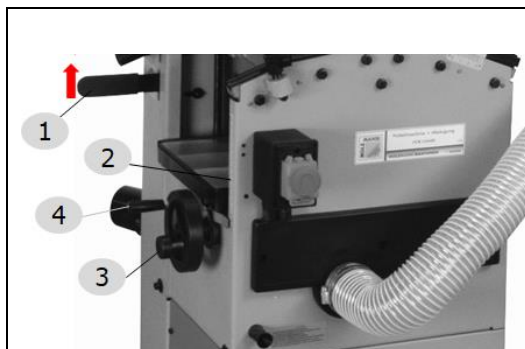
NOTICE: when converting to planing, proceed in reverse order.

NOTICE



For readjusting to planer mode please lower the thicknesser table to avoid any damages.

16.8.3 Thicknessing



- Loosen the clamp (3) and adjust the desired cutting depth (height of the planer table) with the hand wheel (4).
- The screw table height is displayed on the scale (2).
- Adjust table height to workpiece thickness minus the desired chip removal.
- Maximum chip removal: see technical data!
- Fix the adjusted cutting depth with table clamp (3).
- Switch on the machine by pressing the ON-button.
- Move the lever (1) to the upper position to the thicknessing-position.

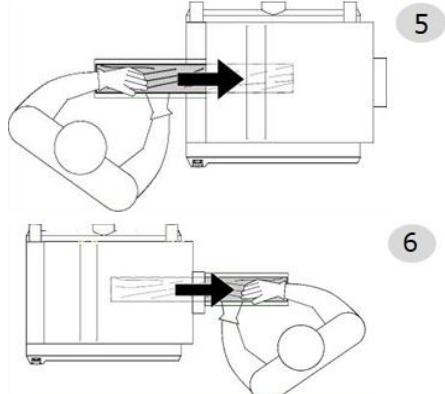
NOTICE: Activate the feed device only after the machine has reached full operating speed (approx. 5 seconds from start).

- Insert the workpiece so that the surface to be planed faces upwards and slide it forward.

NOTICE: Workpieces with less than 250 mm thickness must not be planed.

Wood feed device: The wood is automatically fed by two spring-loaded rollers. Press the workpiece against the thicknessing table only until the workpiece is gripped by the feed roller. Allow the workpiece to pass through without pushing.

A long workpiece should be supported both when entering and leaving the machine to avoid "heels" at the end of the wood.

	• Once half of the workpiece has been machined (5), change to the opposite operating side of the machine. • If the workpiece is no longer moved by the feed (6), pull out the workpiece manually. • After the work operation, switch off the machine with the OFF-button and move the feed lever to the lower position (feed deactivated). • Wait until the shaft has come to a standstill before carrying out further work! • For planing, the before described thicknessing procedure must be reversed.
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CAUTION



Long workpieces must be supported!
Property damage and injury by bouncing up the workpiece or tilting of the machine possible!

16.9 After working process

NOTICE



After the working process the machine must be turned off:

- Push OFF-button at the switch unit
- Disconnect the plug so the machine is disconnected from the power supply.
- Adjust the blade cover so that the shaft is completely covered.

17 CLEANING, MAINTENANCE, STORAGE, DISPOSAL

17.1 Cleaning

NOTICE



The use of solvents, aggressive chemicals or abrasives can lead to damage to paintwork and other property on the machine!

Free the machine from dust and other deposits after each use. Only use water and, if necessary, a mild detergent for cleaning! The use of compressed air or high-pressure cleaners is not recommended. The latter can reduce the operational suitability of the machine or shorten its service life, because water (moisture) could get inside the machine when it is used.

17.2 Maintenance and Repairs

WARNING



Danger due to electrical voltage! Always disconnect the machine from the power supply before servicing or maintenance work and secure it against accidentally re-activation!

The machine is low maintenance and only a few parts require maintenance. Malfunctions or defects that are likely to impair your safety must be rectified immediately!

- Check that the safety devices are in good condition before each operation.
- Check the connections at least once a week for a tight fit.
- Check the correct and readable status of the Machine's warning and safety labels on a regular basis.

17.2.1 Maintenanceplan

Wear of machine depends strongly on operation condition. The following intervals are valid when using the machine within the operation limits:

Interval	Componente	Activity
Before every usage	Anti-kick-back device	At least once per work-shift by inspection to verify that they are in good working condition, eg have no impact damages to the surface and that the anti-kick back device fall back freely due to its own weight after lifting.
	Machine	Cleaning (from dust and chips)
	Planing knife	Check the planing knives for perfect condition (no cracks, dents, bends etc.)
	Safety devices	Check the functionality of the safety devices.
Monthly	V-Belt	Check retighten or replace if necessary.
	Stopping time	Check the stopping time (braking effect). The stopping time must not exceed 10 seconds.
	Feed/Pull-out roller	Check and clean thoroughly
	Height adjustment	Control, lubrication
Half yearly	Chain-drive (feed)	Check for damage/wear, lubricate, replace if necessary
	Friction wheel (feed)	Check for damage/wear and replace if necessary.
	Planer table	Check the height adjustment of the entry planer table.
	Unpainted, moving parts	Clean the belt and pulley channels with a soft brush, wool or paper towel. Never use solvents or water! Apply a thin layer of oil or grease to the unpainted moving parts of the machine, but protect the belts and pulleys from contamination by oil, grease, solvents, paint, etc.

17.2.2 Check/clean anti-kick-back device

Check: after turning upwards, each individual gripper must return to its lower starting position only under the influence of its weight.

Cleaning: clean grippers that are soiled with resin or difficult to move with a brush and turpentine and then dry them with a compressed air jet.

Replace damaged grippers immediately!

17.2.3 Replacing / adjusting the cutter knives

NOTICE

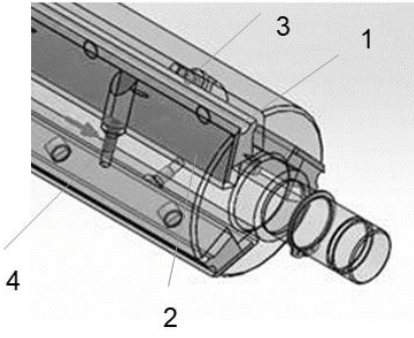


The planer shaft is suitable for strip knives. The machine is supplied with a strip knife as standard. If the planing surface is bad, the cutter knives must be replaced or reground for strip knives. The appropriate dimensions can be found in the technical data.

WARNING



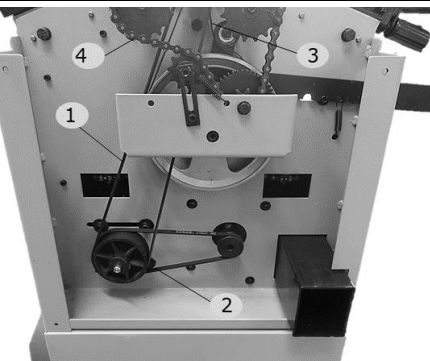
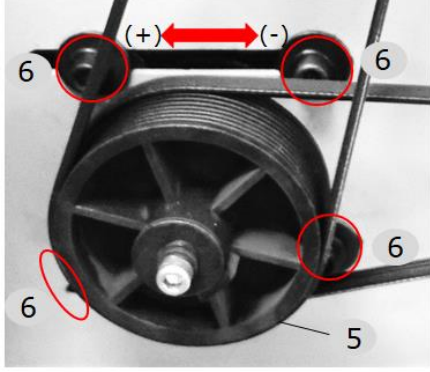
Danger from cutting edges! Always wear protective gloves when working on the planing shaft! Injuries to hands due to sharp cutting edges.

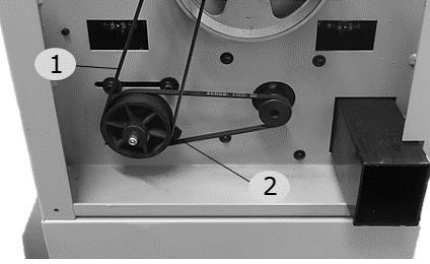
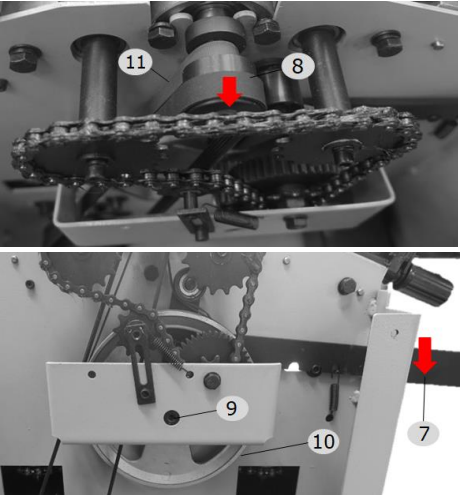
	• Adjust the machine to thickness planing mode. • The dust collection hood must be open in order to have access to the shaft. • Loosen the gib (1) and remove the cutter knives (2). • Clean gib (1) and knives (2). • Replace sharp/new cutter knife (2) and gib (1). • Slightly tighten the locking screw (3) and perform the adjustment procedure. • Place the setting gauge on the planning shaft and adjust the correct height for the knives using the 2 Allen-screws (4). The maximum blade overhang must not exceed 1.1 mm. • Tighten the gib (1). (Recommended minimum tightening torque 10Nm). • Do not use cutter knives with a height of less than 18 mm due to the too small clamping surface. • Repeat procedure for all cutter knives.
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17.2.4 Tensioning the belt checking/adjusting/replacing belts

The belt tension is set correctly for new machines by the manufacturer. Due to elongation of the belts over the running time, the belt must be retensioned.

To check/adjust or replace the belt, the belt/chain cover must be removed. Loosen the screws and remove the belt and chain cover.

	• The Allen keys required for tensioning or replacing the drive belts can be found in the toolbox.
	• You now have a clear view of the following V-Belts for: the shaft (1), the suction (2) and the feed (3) as well as on the chain (4).
	1. Check/replace V-belt (shaft) • The V-belt (shaft) is tensioned by means of the belt pulley (5) at the bottom left. <u>Increase belt tension:</u> now the pulley can be moved in direction (+) to increase the belt tension. <u>Decrease belt-tension:</u> now the pulley can be moved in direction (-) to decrease the belt tension. As soon as the correct belt tension is obtained, retighten the screws (6). <u>Changing the V-belt:</u> Completely relax the V-belt and pull it off over the pulleys and insert a new belt. Then reestablish the correct belt tension.

	NOTICE: Check the belt tension by squeezing the belt in the middle with your thumb and index finger. The correct belt tension is achieved when the belt yields 2-5 mm at a pressure of 2 kg. After finishing, replace the belt and chain cover and fix it with the screws (5 and 6).
	2. Check/replace V-Belt (suction) - Loosen the four screws (6) and slacken the V-belts for the knife shaft (1) and for the suction (2). - Pull the V-belt (shaft) (1) over the belt pulley (5). - Insert a new V-belt (suction) (2) and replace the V-Belt (shaft) (1). - Then reestablish correct belt tension, as described in paragraph one above.
3. Check/replace friction wheel (feed) and V-belt (feed) The friction surfaces of the wheel wear out over time. If there is excessive wear or the wheel tread is damaged, the wheel must be replaced. 	
- The feed lever (7) must be in the lower position (deactivated). - Slacken the V-belt (shaft) and remove the belt (8) from the pulley. <u>Changing the belt pulley (10):</u> unscrew the screw (9) for the belt pulley, remove the V-belt (feed) (11), replace the pulley and reattach the V-belt (feed). Fix the pulley again with the screw. <u>Changing the V-belt (feed) (11):</u> if the V-belt also needs to be replaced, it is removed after dismantling the pulley. - Then reinsert a new V-belt (feed) (11) and fix the belt pulley (10) again with the screw (9). - Replace the V-belt (shaft) (8) and reestablish the correct belt tension as described in paragraph one above.	

NOTICE: DO NOT over-tension the belts to avoid damage to the bearings and excessive heating.

Excessive belt tension leads to elongation, overheating and rapid belt wear.

The contamination of the belts with oil, grease, solvents, paint, etc. should be avoided.

Clean and dry the belts and the pulleys' ducts only with a soft brush or with a pure wool or paper towel.

Do not use solvents or similar cleaning agents and never use water.

17.2.5 Check/lubricate Chain-drive (feed)

Check the chain for any damage (cracks, break-outs). The chain can be moved by turning the friction wheel to view all parts. Lubricate chains with normal machine grease.

17.2.6 Lubricate height adjustment (thicknesser)

- Remove chips and dust from the machine.
- Remove the belt/chain cover (loosen the screws and remove the cover).
- Lower the thickness planing table completely.
- Clean spindle/height adjustment unit and then grease with machine grease.
- Move the thickness planing table 1x up and down to distribute the grease.
- Mount the cover again (hang in the cover and tighten the screws).

18 STORAGE

NOTE



If stored incorrectly, important components can be damaged and destroyed. Store packaged or already unpacked parts only under the intended environmental conditions.

Store the machine exclusively in a dry environment protected from external weather influences!

19 DISPOSAL



Observe national waste disposal regulations. Do not dispose of the machine, machine components or operating materials in residual waste. If necessary, contact your local authorities for information on available disposal options. If you buy a new machine or an equivalent machine from your retailer, he is obliged in certain countries to dispose of your old machine properly.

20 TROUBLESHOOTING



WARNING

Danger due to electrical voltage! Handling the machine while it is connected to the power source can result in serious injury or death. Disconnect the machine from the power supply and secure it against unintentional reconnection before taking any action to rectify the fault!

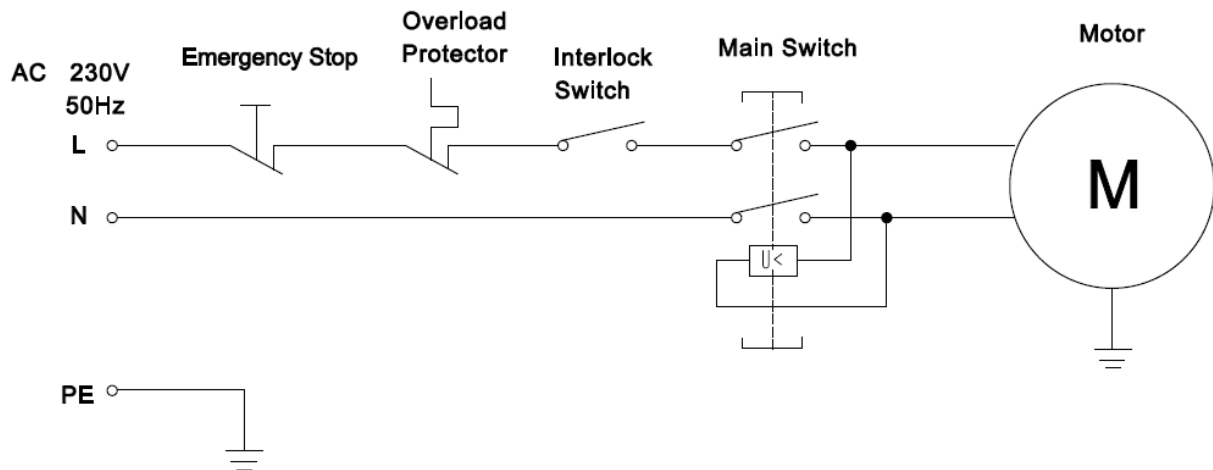
Many possible sources of error can be excluded in advance if the machine is properly connected to the mains. If you are unable to carry out necessary repairs properly and/or do not have the required training, always consult a specialist to correct the problem.

Problem	Possible cause	Solution
Machine does not start or shuts down automatically during idling	- Power supply outage - Damaged or incorrect connected extension cable - Damaged switch or motor	- Check fuse of the power supply - Check plug or extension cable - Contact customer support
Machine stops during operation	- Blunt blade - Feeding speed too high - Motor protection triggered	- Check blade - Work with lower feeding speed - Let the motor cool down
Planer knife stops rotating in contact with the workpiece, motor continues running	- Slackened V-belt - V-belts and pulleys are contaminated with grease or oil	- Retighten V-belt - Clean the V-belts and pulleys thoroughly or replace the belts
Machine vibrates during operation	- Wrong adjusted blade - Ground not flat or base feet wrong adjusted	- Check the setting of the blades - Set the base feet correct
Workpiece clamps during thicknessing	- Cutting depth too high - Dirty thicknessing table	- Set the correct cutting depth and operate in more steps - Clean and apply the table surface with lubricant
Bad surface condition after operating	- Blunt blade - Uneven feed of the workpiece	- Check blade - Feed workpiece evenly and with constant pressure
Rough surface after operating	Workpiece too moist	Use drier workpiece

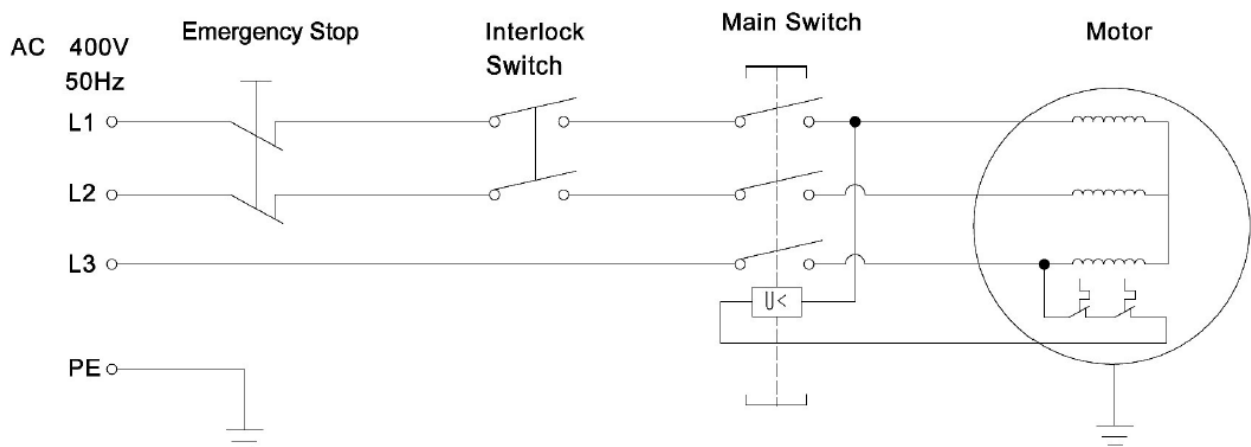
Cracked surface after operating	• Workpiece was processed against the direction of growth • Cutting depth too high	• Proceed the workpiece in opposite direction • Set the correct cutting depth and operate in more steps
Planed edges are not right-angled	• Incorrect angle set at the planer fence	• Adjust the dressing stop to 90°.

48 SCHALTPLAN / WIRING DIAGRAM / DIAGRAMA DE CABLEADO / SCHÉMA ÉLECTRIQUE / SCHEMA ELETTRICO

48.1 230 V



48.2 400 V



49 ERSATZTEILE / SPARE PARTS / PIEZAS DE RECAMBIO / PIECES DE RECHANGE / PARTI DI RICAMBIO

49.1 Ersatzteilbestellung / spare parts order / Pedido de piezas / Commande de pièces détachées / Ordinazione delle parti di ricambio

(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/Teilen nur Originalersatzteile verwenden

Beim Bestellen von Ersatzteilen verwenden Sie bitte das Serviceformular, das Sie am Ende dieser Anleitung finden. 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.

Oder nutzen sie die Online-Bestellmöglichkeit über den Ersatzteilkatalog bzw. Ersatzteilanforderungsformular auf unserer Homepage

Bestelladresse sehen Sie unter Kundendienstadressen im Vorwort dieser Dokumentation.

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

IMPORTANT

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

So you always have to use original spare parts

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

Or use the electronic ordering opportunity via the spare parts catalogue or spare parts request form on our homepage

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

(ES) Con las piezas de recambio de Holzmann, utiliza piezas de recambio que se ajustan perfectamente entre sí. El ajuste óptimo de los componentes acorta el tiempo de instalación y aumenta la vida útil.

AVISO

¡La instalación de piezas de recambio no originales lleva a la pérdida de garantía!

Por lo tanto: Al llevar a cabo la sustitución de componentes/piezas, utilice únicamente piezas de recambio originales

Para pedir piezas de recambio utilice el formulario del servicio de atención al cliente que encontrará al final del presente manual. Indique siempre el tipo de máquina, la referencia de la pieza de recambio y la denominación. Para evitar malentendidos, se recomienda adjuntar al pedido una copia del esquema de piezas de recambio en el que se marque claramente las piezas de recambio necesarias.

O utilice la opción de pedido online a través del catálogo de piezas de recambio o del formulario de solicitud de piezas de recambio que encontrará en nuestra página web

Encontrará la dirección de pedidos en las direcciones del servicio postventa que se encuentra en el prólogo de esta documentación.

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

AVIS

Le montage de pièces autres que les pièces de rechange d'origine entraîne la perte de la garantie !

Par conséquent, la règle est la suivante : Utiliser uniquement des pièces de rechange d'origine pour le remplacement des composants/pièces

Pour commander des pièces de rechange, veuillez utiliser le formulaire de service à la fin de ces instructions. Toujours indiquer le type de machine, le numéro de pièce de rechange et la désignation. Afin d'éviter tout malentendu, nous vous recommandons de joindre une copie du plan des pièces détachées à la commande de pièces détachées, sur laquelle les pièces détachées requises sont clairement indiquées.

Vous pouvez aussi utiliser l'option de commande en ligne via le catalogue de pièces détachées ou le formulaire de demande de pièces détachées sur notre page d'accueil.

Pour l'adresse de commande, voir Adresses du service à la clientèle dans l'avant-propos de la présente documentation.

(IT) Con le parti di ricambio Holzmann utilizzate pezzi di ricambio che combaciano e sono adatti tra loro. L'esattezza di adattamento ottimale dei pezzi accorcia i tempi di montaggio e aumenta la durata di vita.

NOTA

Il montaggio di altre parti di ricambio diverse da quelle originali causa la perdita della garanzia!

Pertanto vale la regola: Per la sostituzione di componenti/parti utilizzare solo parti di ricambio originali

Per ordinare parti di ricambio usare il modulo dell'assistenza che trovate al termine di queste istruzioni. Indicare sempre il tipo di macchina, il numero di parte di ricambio e la denominazione. Per evitare incomprensioni, si raccomanda di allegare agli ordini di parti di ricambio una copia del disegno delle parti di ricambio, su cui sono contrassegnate le parti di ricambio richieste.

Oppure utilizzate l'opzione di ordinazione online tramite il catalogo ricambi o il modulo di richiesta ricambi sulla nostra homepage

L'indirizzo per gli ordini si trova sotto gli indirizzi dei centri di assistenza clienti nella prefazione di questa documentazione.

(DE) Den elektronischen Ersatzteilkatalog finden Sie auf unserer Homepage (Ersatzteile)

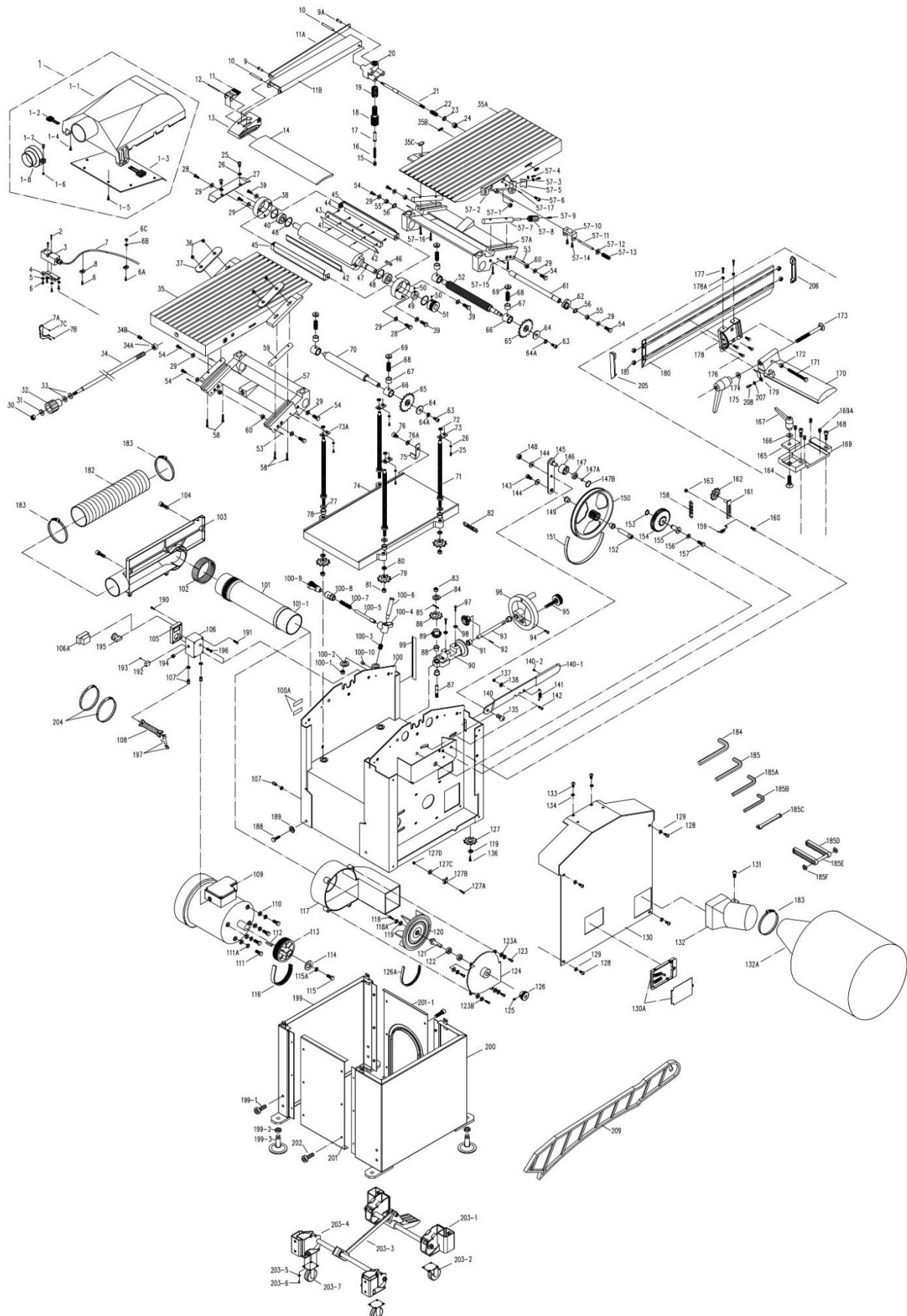
(EN) For electronic spare-parts catalogue please refer to our homepage (spare-parts)

(ES) Encontrará el catálogo electrónico de piezas de recambio en nuestra página web (piezas de recambio)

(FR) Vous pouvez trouver le catalogue électronique des pièces détachées sur notre page d'accueil (pièces détachées)

(IT) Potete trovare il catalogo elettronico dei ricambi sulla nostra homepage (ricambi)

49.2 Explosionszeichnung / explosion drawing / Vista de despiece / Vue éclatée / Disegno esploso



No.	Description	QTY.	No.	Description	QTY.
1	Dust chute assembly	1	34	Screw	1
2	Socket head screw	2	34A	Spacer ring	2
3	Interlock switch	1	34B	Set screw	2
4	Switch mounting plate	1	35	Infeed table	1
5	Flat washer	4	35A	Outfeed table	1
6	Socket head screw	7	35B	Insert	2
6A	Socket head screw	9	35C	Slot cover	2
6B	Lock washer	9	36	Lock nut	4
6C	Hex nut	9	37	Guide plate	2
7	Wire for interlock switch	1	38	Bearing house	2
7A	Wire clamber	1	39	Hex head bolt	4
7B	Self tapping screw	4	40	Ball bearing	2
7C	Self tapping screw	1	41	Adjusting screw	4
8	Wire clamber	12	42	Blade	2
9	Rivet	1	43	Blade clamp	2
9A	Screw	1	44	Blade lock screw	10
10	Pin	2	45	Deflector plate	2
11	Blade guard lock knob	1	46	Key	1
11A	Link plate	1	47	Cutterhead	1
11B	Support arm	1	48	Retaining ring	4
12	Pin	1	49	Bushing	1
13	Blade guard support	1	50	Set screw	2
14	Blade guard	1	51	Pulley	1
15	Set screw	1	52	Infeed roller	1
16	Spring	1	53	Pin	8
17	Rod	1	54	Hex head bolt	8
18	Adjusting knob	1	55	Nut	2
19	Spring	1	56	Retaining ring	2
20	Arm support bracket	1	57	Infeed table support	1
21	Shaft	1	57A	Outfeed table support	1
22	Spring	1	57-1	Flange nut	3
23	Flat washer	1	57-2	Connecting bracket	1
24	Lock nut	1	57-3	Flat washer	2
25	Socket pan head screw	2	57-4	Socket head screw	2
26	Flat washer	2	57-5	Support plate	1
27	Cover plate	1	57-6	Socket head screw	3
28	Hex head bolt	2	57-7	Shaft	1
29	Flat washer	14	57-8	Adjusting knob	1
30	Lock nut	1	57-9	Socket head screw	1
31	Flat washer	1	57-10	Pin guide bracket	1
32	Infeed table adjusting knob	1	57-11	Pin	1
33	Flat washer	2	57-12	Retaining ring	1

No.	Description	QTY.	No.	Description	QTY.
57-13	Spring	1	94	Socket head screw	1
57-14	Socket head screw	2	95	Lock knob	1
57-15	Socket head screw	2	96	Handwheel	1
57-16	Socket head screw	2	97	Hex head bolt	2
57-17	Pin	2	98	Flat washer	2
58	Socket head screw	4	99	Thickness scale	1
59	Guide rod	3	100A	Cut depth scale	1
60	Flange nut	6	100	Body	1
61	Shaft	1	100-1	Lock nut	1
62	Kickback plate	28	100-2	Flat washer	1
63	Socket head screw	2	100-3	Spring	1
64	Flat washer	2	100-4	Lock block	1
64A	Lock washer	2	100-5	Handle	1
65	Sprocket	2	100-6	Shaft	1
66	Roller bearing	4	100-7	Spring	1
67	Spring house	4	100-8	Bushing	1
68	Spring	4	100-9	Knob	1
69	Screw	4	100-10	Set screw	1
70	Outfeed roller	1	101	Tube	1
71	Screw	4	101-1	Extension Tube	1
72	Bushing	4	102	Tube nut	1
73	Screw fixed plate	2	103	Cover	1
73A	Screw fixed plate	2	104	Socket head screw	5
74	Table	1	105	Lower switch box	1
75	Pointer	1	106	Upper switch box	1
76	Socket head screw	1	106A	Switch	1
76A	Flat washer	1	107	Strain relief	3
77	Flat washer	4	108	Power cord	1
78	Bearing	4	109	Motor	1
79	Chain	4	110	Flat washer	4
80	Washer	4	111	Hex head bolt	4
81	Lock nut	4	111A	Lock washer	4
82	Chain	1	112	Key	1
83	Locket nut	1	113	Motor pulley	1
84	Flat washer	1	114	Flat washer	1
85	Spring pin	1	115	Hex bolt	1
86	Sprocket	1	115A	Lock washer	4
87	Shaft	1	116	V-belt	1
88	Bearing	2	117	Fan house	1
89	Bevel gear	2	118	Socket head screw	1
90	Bevel gear support bracket	1	118A	Lock washer	1
91	Bearing	2	119	Flat washer	2
92	Spring pin	1	120	Fan	1
93	Shaft	1	121	Shaft	1

No.	Description	QTY.	No.	Description	QTY.
122	Ball bearing	2	154-1	Gear	1
123	Self tapping screw	4	154-2	Sprocket	1
123A	Flat washer	4	154-3	Square bushing	1
123B	Lock washer	4	155	Gear shaft	1
124	Fan house cover	1	156	Flat washer	1
125	Set screw	1	157	Hex head bolt	1
126	Fan pulley	1	158	Chain	1
126A	V-belt	1	159	Spring	2
127	Sprocket	1	160	Hex head bolt	1
127A	Socket head screw	1	161	Sprocket support plate	1
127B	Cord clamp	1	162	Idler sprocket	1
127C	Flat washer	1	163	Lock nut	1
127D	Hex nut	1	164	Carriage bolt	1
128	Socket head screw	4	165	Lock block	1
129	Flat washer	4	166	Flat washer	1
130	Body cover	1	167	Lock handle	1
130A	Tool box	1	168	Socket head screw	2
131	Socket head screw	1	169	Guide bracket	1
132	Dust export	1	169A	Set screw	4
132A	Filt bag	1	170	Fence support	1
133	Socket head screw	2	171	Hex head bolt	1
134	Flat washer	2	172	Lock nut	1
135	Socket pan head screw	1	173	Carriage bolt	1
136	Socket head screw	1	174	Flat washer	1
137	Lock nut	1	175	Lock handle	1
138	Flat washer	1	176	Flat head screw	4
140	Belt tension lever	1	177	Socket head screw	2
140-1	Tension lever glove	1	178	Fence angle support plate	1
140-2	Flat head screw	1	178A	Hex nut	2
141	Spring	1	179	Angle pointer	1
142	Socket head screw	1	180	Fence	1
143	Hex head bolt	1	181	Square nut	4
144	Flat washer	2	182	Hose	1
145	Connecting plate	1	183	Hose clamp	3
146	Idler pulley	1	184	6mm Hex wrench	1
147	Ball bearing	1	185	5mm Hex wrench	1
147A	Retaining ring	1	185A	4mm Hex wrench	1
147B	Retaining ring	1	185B	3mm Hex wrench	1
148	Lock nut	1	185C	8-10mm Spanner	1
149	Bearing	2	185D	Guide block	2
150	Flat belt pulley	1	185E	Shaft	1
151	Flat belt	1	185F	Retaining ring	4
152	Shaft	1	188	Socket head screw	4
153	Retaining ring	1	189	Flat washer	4

No.	Description	QTY.	No.	Description	QTY.
190	Self tapping screw	4	202	Socket pan head screw	12
191	Self tapping screw	4	203-1	Front caster support	1
192	Terminal	1	203-2	Swivel caster	2
193	Self tapping screw	2	203-3	Connecting lever	1
194	Overload protector	1	203-4	Rear caster support	1
195	Emergency switch	1	203-5	Flat washer	16
196	Rubber bushing	1	203-6	Socket head screw	16
197	Quick connector	6	203-7	Rigid caster	2
199	Small leg plate	1	204	Cable tie	2
199-1	Socket head screw	8	205	Right fence cover	1
199-2	Hex nut	4	206	Left fence cover	1
199-3	Foot	4	207	Flat washer	1
200	Large leg plate	2	208	Socket head screw	1
201	Connecting plate	1	209	Push stick	1
201-1	Connecting plate	1			

50 KONFORMITÄTSERKLÄRUNG / CERTIFICATE OF CONFORMITY / DECLARACIÓN DE CONFORMIDAD / DÉCLARATION DE CONFORMITÉ / DICHIARAZIONE DI CONFORMITÀ

	Inverkehrbringer / Distributor / Dystrybutor HOLZMANN MASCHINEN® GmbH 4170 Haslach, Marktplatz 4, AUSTRIA Tel.: +43/7289/71562-0; Fax.: +43/7289/71562-4 www.holzmann-maschinen.at
Bezeichnung / Name / Denominación / Désignation / Denominazione	
Abricht- Dickenhobelmaschine / combined planer thicknesser / Garlopa mecánica- regresadora / Pialla combinata a filo e spessore	
Typ / Model / Modelo / Type / Modello	
HOB 260ABS	
EG-Richtlinien / EC-directives / Directivas CE / Directives CE / Direttive CE	
Maschinenrichtlinie / Machinery Directive 2006/42/EC	
Angewandte Normen / applicable Standards / Normas aplicables / Normes applicables / Norme applicate:	
- EN 61029-1:2009/A11:2010 - EN 61029-2-3:2011 - EN ISO 12100:2010	

(DE) Hiermit erklären wir, dass die oben genannten Maschinen aufgrund ihrer Bauart in der von uns in Verkehr gebrachten Version den grundlegenden Sicherheits- und Gesundheitsanforderungen der angeführten EU-Richtlinien entsprechen. Diese Erklärung verliert ihre Gültigkeit, wenn Veränderungen an der Maschine vorgenommen werden, die nicht mit uns abgestimmt wurden.

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

(ES) Por medio de la presente, declaramos que las máquinas arribas mencionadas debido a su concepción y construcción en la versión comercializada por nosotros cumplen todos los requisitos esenciales en materia de seguridad y de salud de las directivas UE mencionadas. Esta declaración perderá su validez en caso de que se lleven a cabo modificaciones en la máquina que no hayan sido acordadas con nosotros.

(FR) Nous déclarons par la présente qu'en raison de leur conception, les machines susmentionnées dans la version que nous commercialisons sont conformes aux exigences fondamentales de sécurité et de santé des directives CE mentionnées. Cette déclaration perd sa validité en cas de modifications non convenues avec nous apportées à la machine.

(IT) Con la presente dichiariamo che le macchine sopraindicate, nella versione da noi messa in circolazione, sono conformi nella loro struttura ai requisiti essenziali di sicurezza e salute delle direttive UE elencate. La presente dichiarazione è nulla se si apportano modifiche alla macchina che non sono state da noi autorizzate.

Technische Dokumentation
HOLZMANN-MASCHINEN GmbH
4170 Haslach, Marktplatz 4

Haslach, 03.06.2020
Ort / Datum place/date



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DI (FH) Daniel Schörgenhuber
Geschäftsführer / Director