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Originalfassung

DE BETRIEBSANLEITUNG **ABRICHT-DICKENHOBELMASCHINE (mit Spiralmesserhobelwelle)**

Übersetzung / Translation

EN OPERATING MANUAL **COMBINED PLANER AND THICKNESSER (with spiral cutter head)**

CZ NÁVOD K POUŽITÍ **SROVNÁVACÍ A TLOUŠŤKOVACÍ FRÉZA (s hoblovacím hřídelem se spirálovým ostřím)**

HOB260ECO_230V
HOB260ECO_400V
HOB260ECOSMW2_230V
HOB260ECOSMW2_400V

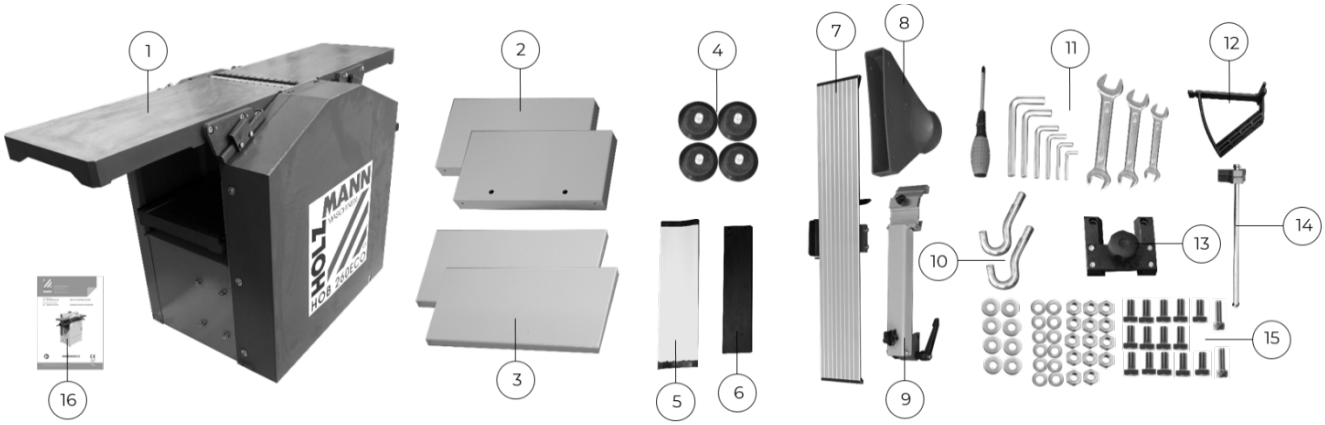
CE

YOUR JOB. OUR TOOLS.

Edition: 04.07.2023 – Revision - 00 – EcC - DE/EN/CZ

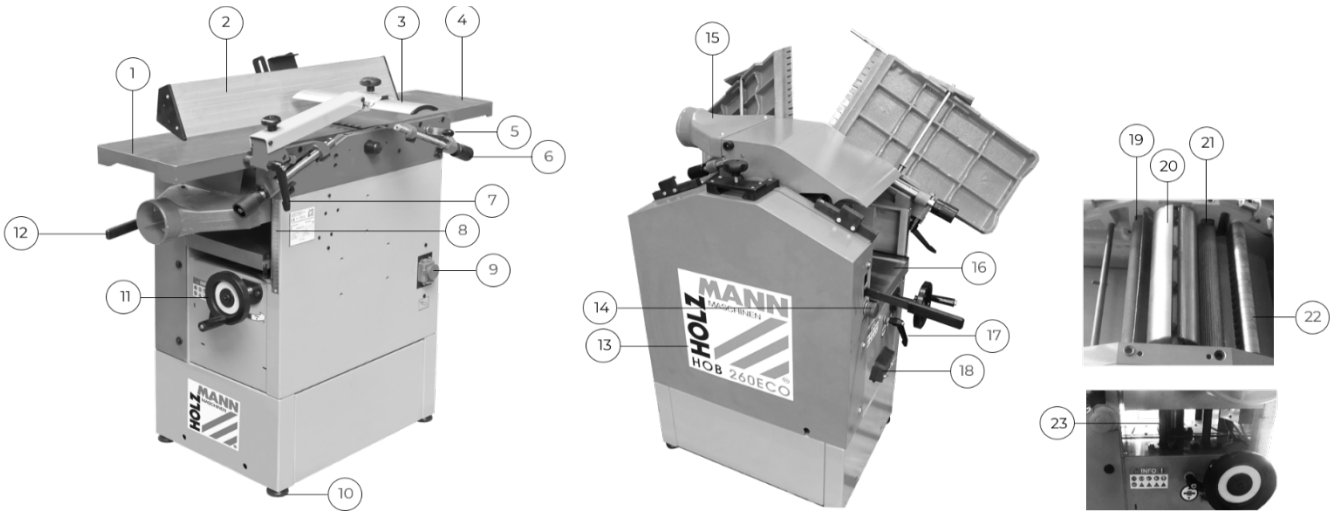
3 TECHNIK / TECHNICS / TECHNICKÁ ČÁST

3.1 Lieferumfang / Delivery content / Rozsah dodávky



#	Beschreibung / Description	Qty.
1	Maschine / machine / Stroj	1
2	Unterbauelemente (vorne, hinten) / base elements (front, rear) / Prvky spodní konstrukce (vpředu, vzadu)	2
3	Unterbauelemente (links, rechts) / base elements (left, right) / Prvky spodní konstrukce (vlevo, vpravo)	2
4	Standfüße / machine feet / Patky	4
5	Brückenschutzabdeckung / planer knife cover / Můstkový ochranný kryt	1
6	Führungsschiene Abrichtanschlag / guidance planer fence / Vodicí lišta srovnávacího dorazu	1
7	Abrichtanschlag / planer fence / Srovnávací doraz	1
8	Absaughaube / dust collector hood / Odsávací kryt	1
9	Arm Brückenschutzabdeckung / arm planer knife cover / Rameno můstkového ochranného krytu	1
10	Anschlaghaken / lifting hook / Dorazový hák	2
11	Werkzeug / tools / Nářadí	1
	HOB260ECOSMW2: Schlüssel für Wendeschneidplatten / key for cutter inserts / Klíč na vyměnitelné břitové destičky	1
12	Schiebeholz / sliding wood / Posuvný dřevěný blok	1
13	Halterung Abrichtanschlag / bracket planer fence / Držák srovnávacího dorazu	1
14	**HOB260ECO:** Einstelllehre Hobelmesser / setting gauge planer knives /Seřizovací měrka hoblovacího nože	1
	HOB260ECOSMW2: Wendeschneidplatten mit Schrauben (Ersatz) / cutter inserts with screws (replacement) / Vyměnitelné břitové destičky se šrouby (náhradní)	3
15	Montagematerial / mounting hardware / Montážní materiál	1
16	Betriebsanleitung / user manual / Návod k použití	1

3.2 Komponenten / Components / Komponenty



#	Beschreibung / Description
1	Abnahmetisch / exit planer table / Výstupní stůl
2	Abrichtanschlag / planer fence / Srovnávací doraz
3	Brückenschutzabdeckung / blade guard / Můstkový ochranný kryt
4	Aufgabetisch / entry planer table / Vstupní stůl
5	Klemmhebel Abrichttische / fixation handle planer tables / Upínací páka srovnávacích stolů
6	Einstellknopf Abrichthobeldicke / adjustment knob planer cutting depth / Tlačítko pro nastavení tloušťky srovnávacího hoblování
7	Klemmhebel Arm Brückenschutzabdeckung / clamping lever arm planer knife cover / Upínací páka ramena můstkového ochranného krytu
8	Skala Höhenverstellung / scale for height adjustment / Stupnice pro změnu nastavení výšky
9	EIN-AUS-Bedieneinheit / ON-OFF-control unit / Zapínání a vypínání ovládací jednotky
10	Standfüße / machine feet / Patky
11	Handrad Höhenverstellung Dickenhobel / handwheel height adjustment thicknesser / Ruční kolečko pro změnu nastavení výšky tloušťkovacího hoblíku
12	Hebel für Dickenhobelvorschub / handle for thicknesser feeder / Páka posuvu tloušťkovacího hoblíku
13	Riemen-Kettenantrieb Abdeckung / V-Belt, chain-drive guard / Kryt řemenovo-řetězového pohonu
14	Not-Halt Schalter / emergency stop button / Spínač nouzového zastavení
15	Absaughaube umklappbar / dust collector hood / Sklopný odsávací kryt
16	Dickenhobeltisch / thicknesser table / Tloušťkovací stůl
17	Klemmhebel Höhenverstellung Dickenhobel / clamping lever height-adjustment thicknesser / Upínací páka změny nastavení výšky tloušťkovacího hoblíku
18	Anschlussdose 400V / input box 400V / Připojovací krabice 400 V
19	Auszugswalze / pull-out roller / Vytahovací válec
20	Hobelwelle / planer shaft / Hoblovací hřídel
21	Einzugswalze / feed roller / Podávací válec
22	Rückschlaggreifer / anti-kick-back device / Zařízení proti zpětnému rázu
23	Höhenverstelleinheit Dickenhobeltisch / height adjustment unit thicknesser / Jednotka změny nastavení výšky tloušťkovacího stolu

3.3 Technische Daten / Technical Data / Technické údaje

3.3.1 HOB260ECO

Allgemein / general	HOB230ECO_230V	HOB230ECO_400V
Spannung / Voltage / Napětí	230 V/50 Hz	400 V/50 Hz
Motorleistung S1 (100%) / Motor power S1 (100%) / Výkon motoru S1 (100 %)	1,5 kW	
Hobelwelle / planer shaft / Hoblovací hřídel	Ø 75 x 250 mm	
Anzahl Hobelmesser / quantity of blades / Počet hoblovacích nožů	3	
Hobelwellendrehzahl / blade shaft speed / Otáčky hoblovacího hřídele	4000 min^{-1}	
Hobelmesserdimension (Streifenmesser) / planer knife dimension / Rozměry hoblovacího nože (plochého nože)	250 x 30 x 3 mm	
Absauganschluss / dust collector plug / Přípojka odsávání	Ø 100 mm	
notwendiger Luftvolumenstrom Absauganlage / necessary air volume / požadovaný systém odsávání objemového průtoku vzduchu	min. 1000 m^3/h	
notwendiger Unterdruck Absauganlage / vacuum dust collector / požadovaný podtlak (odsávací zařízení)	800 Pa	
Maschinenmaße (LxBxH) / machine dimensions (LxWxH) / Rozměry stroje (dxšxv)	1084 x 472 x 1050 mm	
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH) / Rozměry obalu (dxšxv)	1150 x 490 x 750 mm	
Gewicht Brutto / weight gross / Hmotnost brutto	167,5 kg	
Gewicht Netto / weight net / Hmotnost netto	146 kg	
Schallleistungspegel L_{WA} (ISO 3746) / sound power level L_{WA} / Hladina akustického výkonu L_{WA}	93,0 dB(A)	k: 4 dB(A)
Schalldruckpegel L_{PA} (ISO 11202) / sound pressure level L_{PA} / Hladina akustického tlaku L_{PA}	87,3 dB(A)	k: 4 dB(A)
Abrichthobel / planer / Srovnávací hoblík		
Tischgröße / planer table size / Velikost stolu	1085 x 256 mm	
Tischhöhe / table height / Výška stolu	850 mm	
max. Abrichtbreite / max planing width / Max. srovnávací šířka	250 mm	
Schwenkbereich Anschlag / angle range of angle stop / Otočný rozsah dorazu	0° - 45°	
max. Spanabnahme / max depth of cut / Max. úběr třísky	3 mm	
Abrichtanschlag Dimension / planer fence dimension / Rozměry srovnávacího dorazu	730 x 130 mm	
Dickenhobel / thicknesser / Tloušťkovací hoblík		
Tischgröße / table size / Velikost stolu	590 x 245 mm	
max. Hobelbreite / max. thicknessing width / Max. šířka hoblování	245 mm	
min. Werkstückdicke / min. thickness of workpiece / Min. tloušťka obrobku	6 mm	
max. Werkstückdicke / max. thickness of workpiece / Max. tloušťka obrobku	195 mm	
max. Spanabnahme / max. depth of cut / Max. úběr třísky	2 mm	
Vorschubgewschwindigkeit / feed speed / Rychlost posuvu	5,5 m/min	

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

(EN) Notice noise emission: The values given are emission values and therefore do not have to represent safe workplace values at the same time. Although there is a correlation between emission and immission levels, it cannot be reliably

deduced whether additional precautions are necessary or not. Factors influencing the actual immission level at the workplace include the nature of the workspace and other noise sources, i.e. the number of machines and other adjacent operations. The permissible workplace values may also vary from country to country. However, this information should enable the user to make a better assessment of hazard and risk.

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

3.3.2 HOB260ECOSMW2

Allgemein / general	HOB230ECOSMW2_230V	HOB230ECOSMW2_400V
Spannung / Voltage / Napětí	230 V/50 Hz	400 V/50 Hz
Motorleistung S1 (100%) / Motor power S1 (100%) / Výkon motoru S1 (100 %)	1,5 kW	
Hobelwelle / planer shaft / Hoblovací hřídel	Ø 75 x 250 mm	
Anzahl Rillen / amount of grooves / Počet drážek	2	
Wendeschneidplatten / cutter inserts set / Vyměnitelné břitové destičky	15 x 15 x 2,5 mm (30°)	
Anzahl Wendeschneidplatten / quantity cutter inserts set / Počet vyměnitelných břitových destiček	20	
Hobelwellendrehzahl / blade shaft speed / Otáčky hoblovacího hřídele	4000 min^{-1}	
Absauganschluss / dust collector plug / Přípojka odsávání	Ø 100 mm	
notwendiger Luftvolumenstrom Absauganlage / necessary air volume / požadovaný systém odsávání objemového průtoku vzduchu	min. 1000 m^3/h	
notwendiger Unterdruck Absauganlage / vacuum dust collector / požadovaný podtlak (odsávací zařízení)	800 Pa	
Maschinenmaße (LxBxH) / machine dimensions (LxWxH) / Rozměry stroje (dxšxv)	1084 x 472 x 1050 mm	
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH) / Rozměry obalu (dxšxv)	1150 x 490 x 750 mm	
Gewicht Brutto / weight gross / Hmotnost brutto	167,5 kg	
Gewicht Netto / weight net / Hmotnost netto	146 kg	
Schallleistungspegel L_{WA} (ISO 3746) / sound power level L_{WA} / Hladina akustického výkonu L_{WA}	83,0 dB(A) k: 4 dB(A)	
Schalldruckpegel L_{PA} (ISO 11202) / sound pressure level L_{PA} / Hladina akustického tlaku L_{PA}	77,3 dB(A) k: 4 dB(A)	
Abrichthobel / planer / Srovnávací hoblík		
Tischgröße / planer table size / Velikost stolu	1085 x 256 mm	
Tischhöhe / table height / Výška stolu	850 mm	
max. Abrichtbreite / max planing width / Max. srovnávací šířka	250 mm	
Schwenkbereich Anschlag / angle range of angle stop / Otočný rozsah dorazu	0° - 45°	
max. Spanabnahme / max depth of cut / Max. úběr třísky	3 mm	
Abrichtanschlag Dimension / planer fence dimension / Rozměry srovnávacího dorazu	730 x 130 mm	
Dickenhobel / thicknesser / Tloušťkovací hoblík		

Tischgröße / table size / Velikost stolu	590 x 245 mm
max. Hobelbreite / max. thicknessing width / max. šířka hoblování	245 mm
min. Werkstückdicke / min. thickness of workpiece / Min. tloušťka obrobku	6 mm
max. Werkstückdicke / max. thickness of workpiece / Max. tloušťka obrobku	195 mm
max. Spanabnahme / max. depth of cut / Max. úběr třísky	2 mm
Vorschubgewschwindigkeit / feed speed / Rychlost posuvu	5,5 m/min

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

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

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

12 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the combined planer and thicknesser (with spiral cutter head) HOB260ECO_230V, HOB260ECO_400V, HOB260ECOSMW2_230V and HOB260ECOSMW2_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 read and note the safety instructions!

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

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

We reserve the right to make technical changes!

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

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

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

Copyright

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13 SAFETY

This section contains information and important notices for safe commissioning and handling of machine.

For your own safety, read these operating instructions carefully before putting the machine into operation. This will enable you to handle the machine safely and prevent misunderstandings as well as possible damage to property and persons. Also observe the symbols and pictograms used as well as the safety instructions and hazard warnings!

13.1 Intended use of the machine

The machine is intended exclusively for the following activities:
The planing (wide and narrow side as well as chamfering of the edges of a workpiece) and thickness planing of sawn timber within the specified machine 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.

13.1.1 Technical Restrictions

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

Relative humidity:	max. 65 %
Temperature (for operation)	+5° C to +40° C
Temperature (for storage and/or transport)	-20° C to +55° C

13.1.2 Prohibited Use / Forseeable Misuse

- Operation of 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 under explosive conditions
- Operating the machine in closed rooms without chip and dust extraction device (a normal household vacuum cleaner is not suitable as an extraction device)
- Operating the machine outside the specified power range
- 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 of tools that do not meet the safety requirements of the standard for woodworking machine tools (EN847-1).
- Removal of the blade guard during planning.
- Synchronous planning
- Application work (workpiece only machined over a partial length)
- Planing of strongly curved workpieces

The prohibited/hazardous use or disregard of the information and instructions presented in this manual will result in the voiding of all warranty and damage claims against Holzmann Maschinen GmbH.

13.2 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 correlation of material, tool, feed and 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.

13.3 Safety devices

The machine is equipped with following safety devices:

	• A self-locking Emergency Stop button to stop dangerous movements at any time.
Blade guard (covering blade shaft)	• Separating protective device (fixed)
V-Belt / chain-drive guard	• Separating protective device (fixed)
Separating protective device behind planer stop(fixed)	• Separating protective device (fixed) To be remove before changing to thicknesser mode
Thicknesser  	• Moveable guard with safety switch for monitoring
Anti-kick-back device	• The anti-kickback device prevent the workpiece from kicking back
Drill chuck guard	• Separating protective device

13.4 General safety instructions

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

- Before connecting the machine to the main power supply, make sure all the safety items are in the working position and check their working conditions, if necessary, to remove the door or protective cover, cut off the main switch and lock it and cut off the power supply.
- 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 perfect tools that are free of cracks and other defects (e.g. deformations).
- Remove adjustment tools from the machine before switching it on.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut workpiece parts etc.).
- Check the strength of the machine connections before each use.
- Never leave the running machine unattended. The machine must be stopped if it is 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 protective equipment (eye protection, dust mask, respiratory protection, ear protection, gloves when handling tools) as well as close-fitting work protective clothing - never loose clothing, ties, jewellery, etc. - danger of being drawn in!
- Hide long hair under hair protection.
- Do not remove any sections or other parts of the workpiece from the cutting area while the machine is running!
- 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 it is 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 if the supply is protected by a residual current circuit breaker.
- Use the machine only when the ON-OFF switch is in good working order.

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!
- Always switch on the dust extraction device before you start machining the workpiece!
- 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.
- For handling short and narrow workpieces use sliding wood.

13.7 Hazard warnings

Despite its intended use, certain residual risks remain:

- Risk of injury to fingers and hands from the rotating blades if the workpiece is guided improperly.

- Injuries caused by the workpiece being thrown away by improper mounting or guidance, such as working without a stop.
- Danger to health from wood dust or chips. It is essential to wear personal protective equipment such as eye protection and a dust mask. Use a dust collection system!
- Injuries due to defective blades. Check the saw blade regularly for damage.
- Risk of injury from tools, especially when changing tools.
- Risk of injury due to kick back of the workpiece.
- Risk of electric shock if incorrect electrical connections are used.

Residual risks can be minimized if the "Safety instructions" and the "Intended use" as well as the operating instructions are observed.

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

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

Irrespective of all safety regulations, their 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

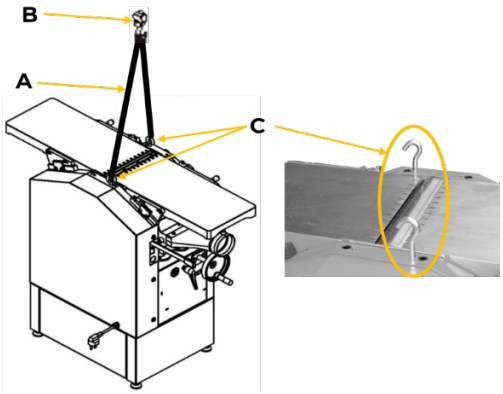
Damaged or not sufficiently viable hoists and lifting devices can cause serious injury or even death. Always check hoists and load lifting devices for adequate load-bearing capacity and perfect condition, carefully fasten the loads and never keep them under suspended loads.

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. Lifting and transporting the machine may only be carried out by qualified personnel with appropriate training for the lifting equipment used.

Transport the machine in its packaging to the installation site. To manoeuvre the machine in the packaging, a pallet truck or a forklift with appropriate lifting power can be used.

NOTE: To transport the machine, you need a forklift truck with the appropriate load capacity and a fork of at least 1200 mm length. The fork of the truck should be positioned under the machine.

If you are using a crane, proceed as follows:



- Prepare two pieces of ropes or belts (A) with appropriate load-bearing capacity and length
- Hook the ropes to the crane hook (B)
- Mount the lifting hooks (C) onto the machine diagonally as shown
- Attach the ropes to the lifting hooks
- Position the crane so that the machine can be lifted without tipping
- Gently lift the machine to avoid shocks and load fluctuations and carefully transport it to the installation site
- Remove lifting hooks

NOTE: Do not transport the machine at the work tables, these are not designed to withstand the tensile load of the machine weight.

15 ASSEMBLY

15.1 Check scope of delivery

Always note visible transport damages on the delivery note and check the machine immediately after unpacking for transport damage or missing or damaged parts. Report any damage to the machine or missing parts immediately to your retailer or freight forwarder.

15.2 Requirements for the place of installation

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 power 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.

15.3 Preparation of the surface

NOTE	
	The use of paint thinners, gasoline, corrosive chemicals or abrasive cleaners will result in damage to the surface! Therefore use only mild cleaning agents.

Before you install and commission the machine at the intended location, carefully remove the anti-corrosion protection and grease residues. This can be done with the usual solvents. Under no circumstances should you use nitro thinner or other cleaning agents that could attack the machine's paint.

15.4 Assembling the machine

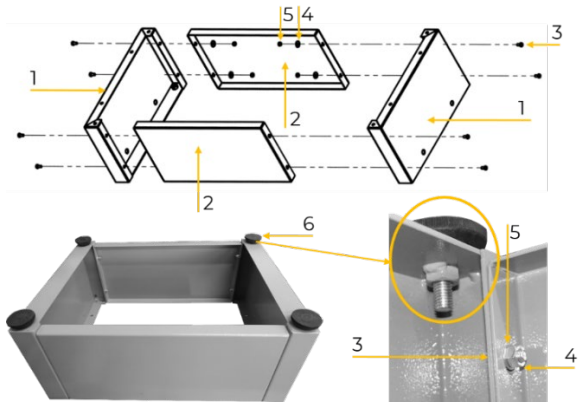
The machine is pre-assembled. The parts that have been disassembled for transport must be assembled before use. Follow the instructions below:

NOTE

The machine and machine components are heavy!
2 persons are required to assemble the machine.

WARNING

Handling the machine with the power supply intact can result in serious injury or death. Therefore, do not connect the machine to the power supply before completing the assembly.



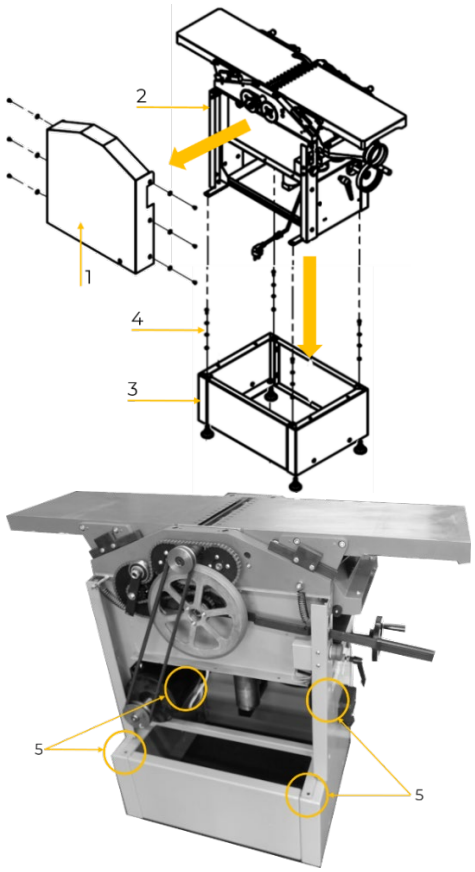
1. Assembly base

The base consists of 2 different elements (1, 2).

- The base elements are assembled with screws M6x12 (3), washers (4) and nuts (5)

NOTE: Make sure that the threads for the machine feet are located at the same side.

- Screw the machine feet (6) into the threads at the corners of the base

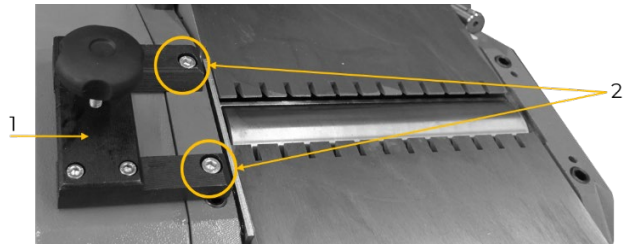


2. Assembly machine on base

- Loosen the screws and remove the V-Belt, chain-drive guard (1) from the machine (2)
- Place the machine (2) on the base and make sure that the holes of the machine are positioned exactly above the holes of the base (5)

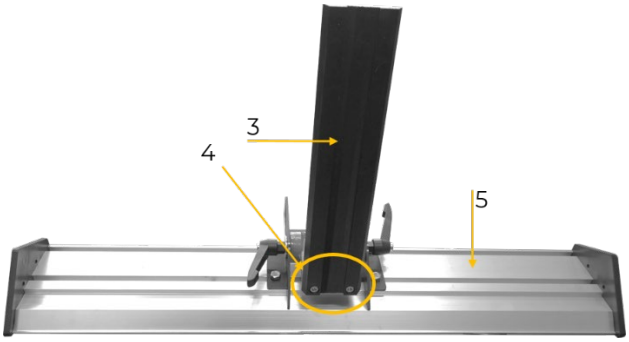
NOTE: To lift the machine observe the transport instructions.

- Fix the machine with screw M6x16 (4), washers and nuts
- Remount the V-Belt, chain-drive guard

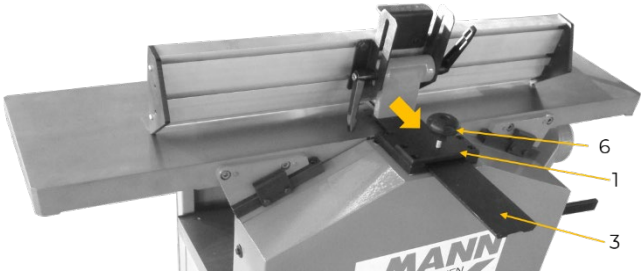


3. Assembly planer fence

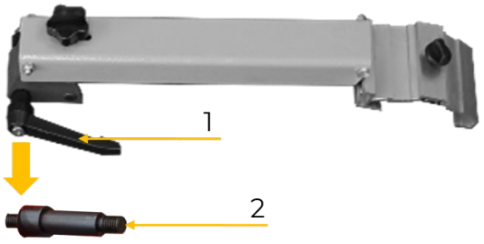
- Fix the bracket planer fence (1) with 2 screws (2) on the machine



- Fix the guidance planer fence (3) (guard behind the planer stop) with 2 screws (4) on the bracket on the planer stop (5)

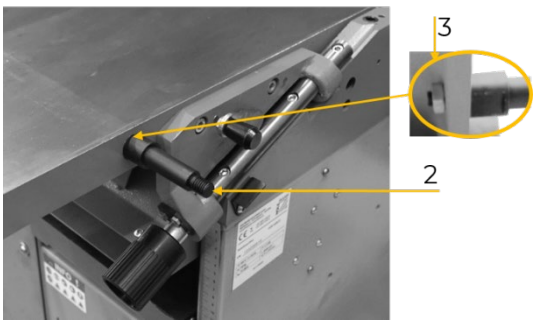


- Insert the guidance planer fence (3) of the assembled planer stop into the bracket planer fence (1)
- The planer stop is fixed in the desired position by means of the star screw (6)

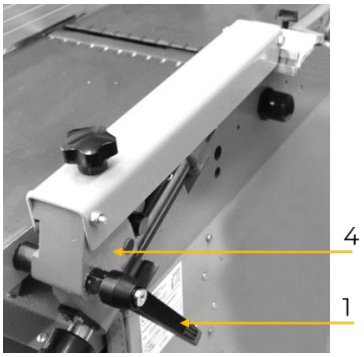


4. Assembly arm planer knife cover

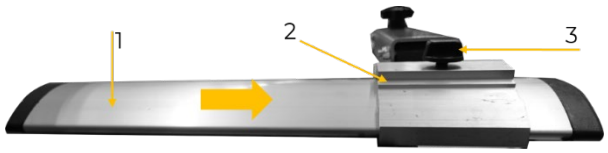
- Unscrew the clamping lever arm planer knife cover (1) and pull out the holder (2)



- Insert the holder (2) into the hole provided on the exit planer table and fasten it with the nut (3)

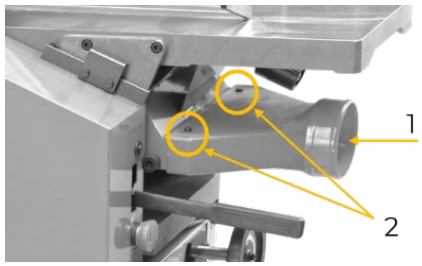


- Push the arm planer knife cover (4) onto the holder and fix it in the desired position with the clamping lever arm planer knife cover (1)



5. Assembly planer knife cover

- Insert planer knife cover (1) into the holder (2) and fix it in desired position with the fixing knop (3)



6. Assembly dust collector hood

- Put on the dust collector hood (1) and fix it with screws (2) on the upper and lower side

15.5 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 (if existing) and the protective grounding function properly.
- Check, whether the supply voltage and the frequency correspond to the specifications of the machine.

NOTE

Deviation of the supply voltage and frequency!

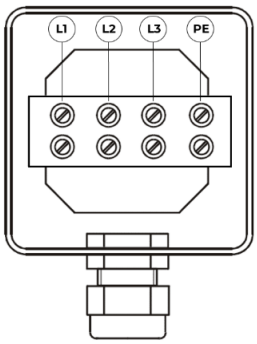
A deviation from the value of the supply voltage of ±5 % is permissible.
A short-circuit fuse must be provided in the power supply system of the machine!

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

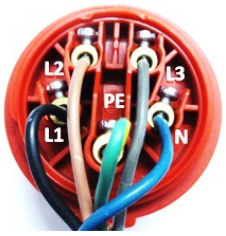
- When using an extension cable, make sure that the dimension matches the connected load of the machine. The connection power can be found in the technical data, the correlation of cable cross-section and cable lengths can be found in the technical literature or obtain information from a specialist electrician.
- A damaged cable must be replaced immediately.

15.5.1 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 mains is made through an appropriately powered CEE coupling (L1, L2, L3, N and PE).



5-wire:
with
N-conductor



4-wire:
without
N-conductor

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

NOTE

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

15.6 Connecting to a dust collection system

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

16 OPERATION

16.1 Operating instructions

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 carrying out any modification and secure it against unintentional reconnection.

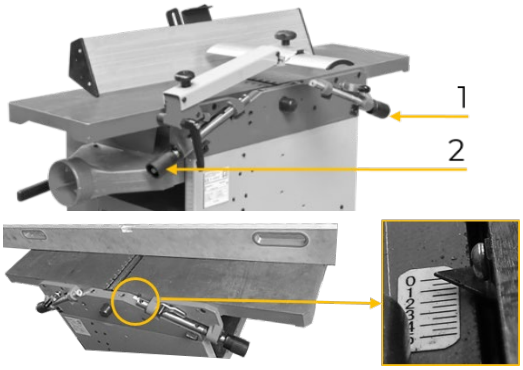
CAUTION

- Never start the machine with a workpiece pressed down!
- Long workpieces must be supported
- Property damage and injury by bouncing up the workpiece or tilting of the machine possible!

16.2 Initial check before start

- Check that all guards are installed.
- Check whether suitable planing knives have been correctly assembled.
- 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

Entry planer table

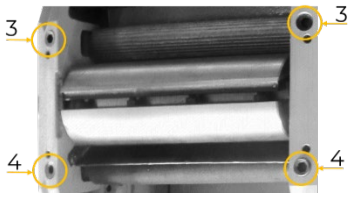
The cutting depth is set with the adjustment knob planer cutting depth (1)

Exit planer table

The height of the back planer table can be adjusted with the adjusting screw (2) and should only be adjusted to the planer shaft if necessary.

Check scale knife entry planer table = 0

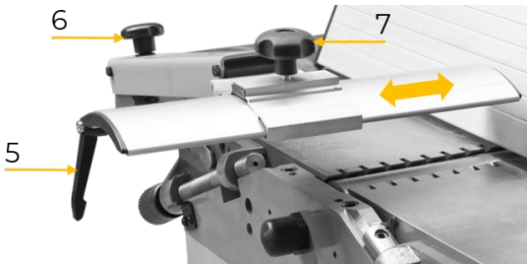
If necessary, adjust the arrow of the scale



2. Setting infeed / oufeed 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).



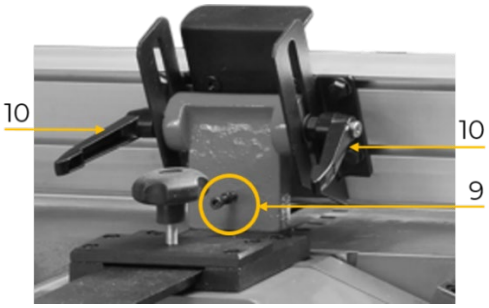
3. Setting arm and planer knife cover

Height

- Loosen the clamping lever arm planer knife cover (5) to move the arm
- Then fix the clamping lever (5) again
- Set the desired height with the adjusting screw (6)

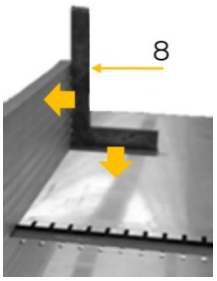
Planer knife cover

- Loosen the clamping screw (7)
- The planer knife cover can be moved and adapted to the size of the workpiece
- Relock the clamping screw (7) when the desired position is reached.



4. Setting planer fence

- Loosen clamping levers (10)
- Set planer fence to the desired position
- Relock the clamping levers (10) when the desired position is reached.

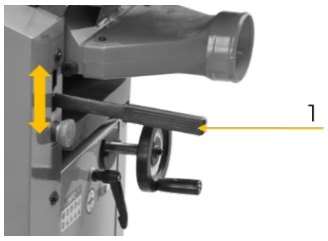
	The alignment of the planer fence at right angles should be checked again before initial operation and readjusted if necessary to achieve an exact planing result. • The angle is measured with a protractor (8). This is placed on the planer table and applied to the planer fence. • If it is not possible 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 (9).

16.4 Handling

16.4.1 Switch the machine on and off

	**Switch on** Push green ON-button (I) **Switch off** Push red OFF-button (0) or in emergency situations the emergency-stop button **CAUTION:** The emergency stop button can only be unlocked after the emergency situation has been eliminated.

16.4.2 Activating/Deactivating the thicknesser feed rate

	**Activate feed:** Swivel the lever for thicknesser feeder (1) upwards. Feed is activated **Deactivated feed:** Swivel the lever for thicknesser feeder (1) downwards. Feed is deactivated.

16.5 Dust collection plug

	**Planer:** The extraction connection (1) is under the planer tables (exit planer table)
	**Thicknesser:** After the conversion to thicknessing, fold down the dust collector hood (2).

Do not operate the machine without the dust collection system connected to it and switched on.

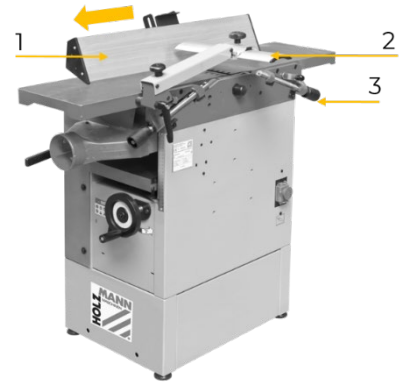
The dimensions of the dust collection plug can be found in the technical data.

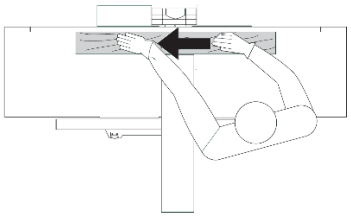
16.6 Planing

WARNING

The unused part of the planing shaft for machining the workpiece must be covered by the covers (planer knife cover, guidance planer fence). 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 wood.

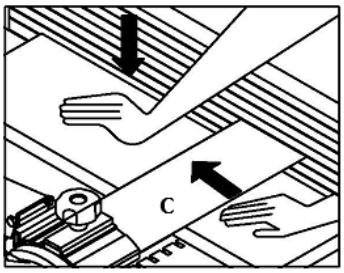
Only plane workpieces that rest firmly on the machine and that can be guided safely!





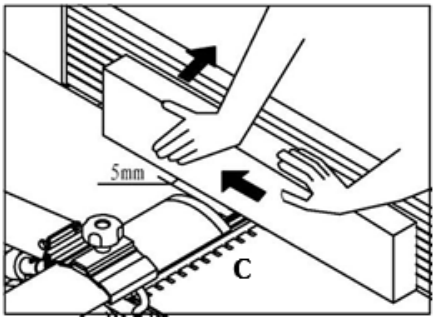
working direction

- Fix the planer fence (1) in the desired working position.
- Set the desired planing thickness on the adjusting screw (3).
- Adjust the planer knife cover (2) so that the distance between the cover and the workpiece is approx. 5mm.
- Start machine



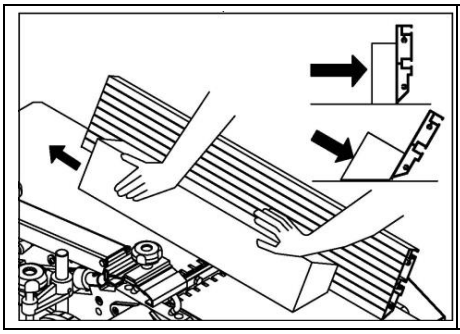
- Press the workpiece against the planer table with one hand.
- Push the workpiece slowly and evenly over the shaft with the second hand.
- After finishing the operation switch off the machine.
- Wait until the shaft has come to a standstill before proceeding with any further work!

16.6.1 Planing small workpieces



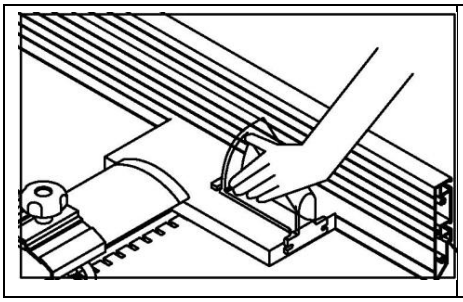
- Lower the planer knife cover (C) so that the planing shaft is covered.
- Move the planer knife cover to the workpiece and fix it with a distance of approx. 5mm.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.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

16.6.2 Planing with tilted planer fence



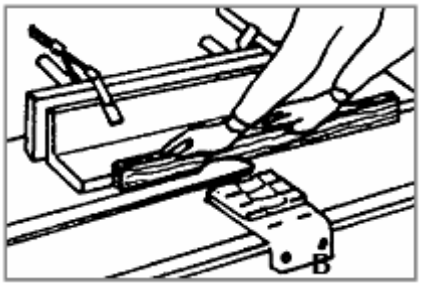
- Lower the planer knife cover so that the planing shaft is covered.
- Move the planer knife cover to the workpiece and fix it with a distance of approx. 5mm.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.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

16.6.3 Planing short workpieces



- When planing short workpieces, a sliding wood or similar device should be used!
- 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.

16.6.4 Planing the workpiece with 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.

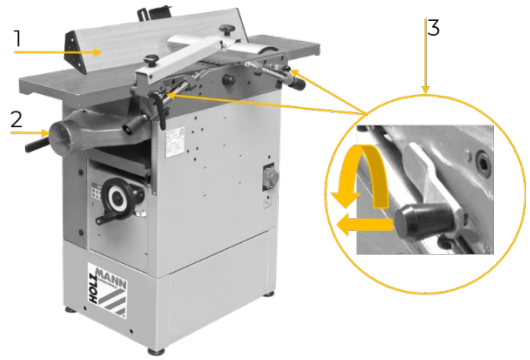
16.7 Thicknessing

NOTE

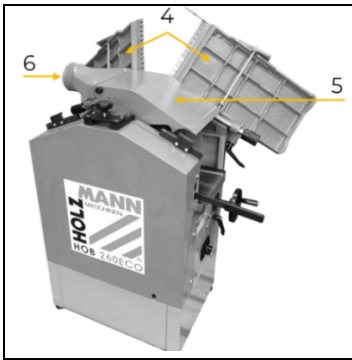
It is necessary to modify/adjust the machine before using as a thicknesser.

- 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.

16.7.1 Converting from planer to thicknessing



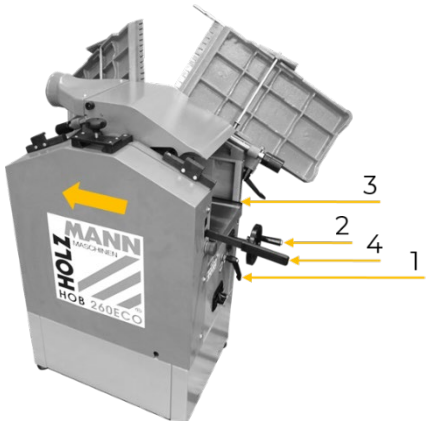
- Disassemble the planer fence (1) and slide the planer knife cover all the way to the back.
- Disassemble the hose of the dust collector plug (2).
- Unlock the fixation handles planer tables (3) of the planer tables. Therefore pull out and turn the handle
- Unfold the planer tables (4) completely.
- Turn down the dust collector hood (5).
- Mount hose to the dust collector plug (6).

	Proceed in reverse order to readjust to the planer mode.

NOTE

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

16.7.2 Thicknessing of workpieces

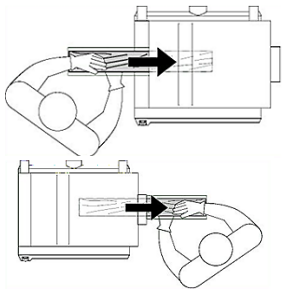


working direction

- Unlock the locking lever height adjustment thicknesser (1) and set the required height of the thicknessing table with the handwheel (2).
- The height will be shown on the scale (3).
- Set the thicknessing table height to the workpiece height minus the requested cutting depth.
- Maximum cutting depth refer to the technical data!

NOTE: At the beginning of the thicknessing process, the workpieces may still have very different thicknesses - this must be taken into account in the set cutting depth in order not to overload the machine.

- Fix the thicknessing table height with the locking lever height adjustment.
- Switch on the machine.
- Put the lever for thicknesser feeder (4) to the upper position to start the feed.



- Insert workpiece so that the surface to be machined facing upwards and push forward
- The workpiece is pulled through of the automatic feed
- As soon as the half of the workpiece has been processed change to the opposite operator side of the machine and take on the finished workpiece.
- After operation switch off the machine.
- Before further activities wait until blade shaft is at a standstill!

NOTE

- In the case of resin residues on the wood, it may be advisable to apply a thin layer of a special lubricant to the machine table in order to ensure that the workpiece slides evenly through the thickness planer.
- If the workpiece is no longer moved by the automatic feed, pull out the workpiece manually.
- After operation switch off the machine and set the lever for thicknesser feeder to position "OFF".
- Before further activities wait until blade shaft is at a standstill!

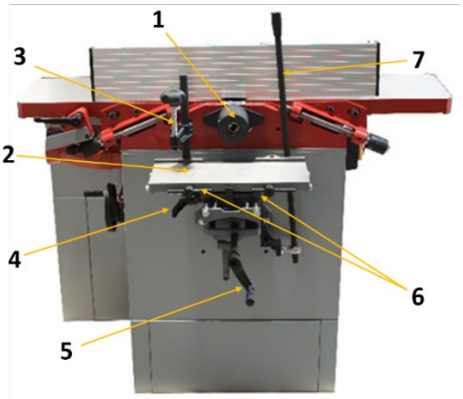
16.8 After working process

NOTE

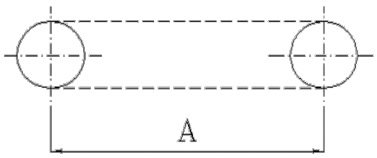
After the working process the planer and thicknesser must be turned off:

- Switch off the machine and disconnect the machine from the power supply.
- After operation set the lever for thicknesser feeder to position "OFF".
- Adjust the planer knife cover so that the planer shaft is completely covered

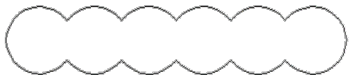
17 OPERATION MORTISING UNIT (OPTIONAL)



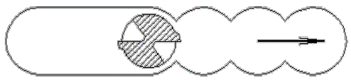
Step 1:



Step 2:



Step 3:



- Assembly see HOB260ECOLL or K5260LLL
- Clamp the milling tool required for drill chuck (1) of the planer shaft
- Lay up the workpiece on the mortising table (2)
- Tilt the downholder (3) to the middle of the workpiece
- Turn the knob of the downholder to clamp the workpiece
- Loosen the locking lever (4) and adjust the table height with the crank handle (5) to the requested height of the milling tool
- Adjust the horizontal travel of the table with both set bars (6)
- Start the machine (see operation planer and thicknesser)
- Move the table with the operating lever (7) in left direction to the limiter
- Press down the workpiece carefully on the milling tool and up to max. penetration depth of milling (depending on the milling tool)
- Move the operating lever carefully to the right direction to the limiter
- Repeat this process until the requested cutting depth has been reached
- Move the lever backwards to release the milling tool out of the workpiece
- After the working process switch of the machine (see operation planer and thicknesser)
- Before further activities wait until blade shaft is at a standstill!

17.1 After working process

NOTE

After the working process the planer and thicknesser must be turned off:

- Switch off the machine and disconnect the machine from the power supply.
- Dismount the milling tool.

18 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 maintenance or repair work and secure it against unintentional reconnection.

18.1 Cleaning

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

NOTE

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

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

18.2 Maintenance

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.

18.2.1 Maintenanceplan

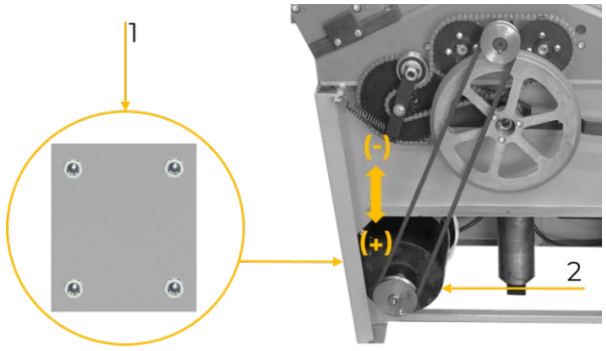
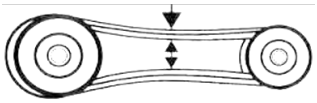
Wear of machine depends strongly on operation condition. The following intervals are valid when using the machine within the operation limits

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)
monthly	V-Belt	Check retighten or replace if necessary.
	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.

18.3 Checking/adjusting/replacing the V-Belt

The belt tension is set correctly for new machines ex factory. By stretching the belts over the running time, retensioning of the belt is necessary.

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

<table>
<tr>
<td> 
</td>
<td>NOTE
Do not over-tension the V-belt! Tension the V-belt only until sufficient power transmission is ensured.
max. 2-5mm
  </td>
</tr>
<tr>
<td>Increase belt tension:
Loosen nuts (1) and unscrew slightly. The motor (2) can now be shifted in the direction (+) of more belt tension.
When correct tension is reached. Tighten the nuts (1) firmly again.</td>
<td>Decrease belt-tension:
Loosen nuts (1) and unscrew slightly. The motor (2) can now be shifted in the direction (-) of less belt tension.
When correct tension is reached. Tighten the nuts (1) firmly again.</td>
</tr>
<tr>
<td colspan="2">For changing the V-belt, completely de-tension the belts and pull them over the tension pulleys and insert new belts. Then establish correct belt tension again.</td>
</tr>
</table>

After completion, remount the cover and fix it with the screws.

18.4 Lubricate height adjustment (thicknesser)

Remove chips and dust from the machine.
Remove the belt/chain cover (loosen the screws and remove the cover).
Set the thickness table all to the top.
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).

18.5 Check/clean anti-kick-back device

Check: Lift up Anti-kick back device, it must fall back on your own.
Cleaning: Remove dust and chips or resin residues.

18.6 Check/replace friction wheel (feed)

The friction surfaces of the wheel become worn over time. If the wear is too worn or damaged, the wheel must be replaced.

1. Remove V-Belt
2. Put the lever for the thicknesser planer feed to the lower position (deactiated)
3. Remove the screw for the belt-pulley and replace the wheel and fix it again.
4. Insert V-Belt and re-establish the correct belt tension.

18.7 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.

18.8 Replacing/adjusting the planing knife (HOB260ECO)

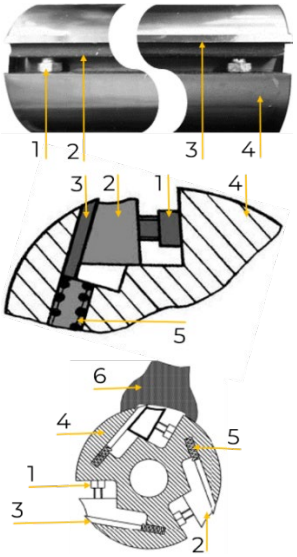
NOTE

The planer shaft is suitable for strip knives.

If the planing surface is bad, the planing knives must be replaced. 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



1. Adjust the machine to thickness planing mode
2. The dust collection hood must be open in order to have access to the shaft
3. Loosen the gib screws (1)
4. The planing kife (3) will be pushed up by the pressure springs (5)
5. Remove the gib (2) and the planing knife (3)
6. Clean the planer shaft (4) and gibs (2)
7. Replace sharpend/new planning knife (3) and gib (2)
8. Slightly tighten the gib screws (1) and and perform the adjustment procedure.
9. Place the setting gauge (6) on the planning shaft and adjust the correct height.
10. Tighten the gib screws (1) to fix the gib (2) (recommended minimum tightening torque 20Nm)
11. Do not use planning knives with a height of less than 19mm due to the too small clamping surface
12. Repeat procedure for all planing knives.

18.9 Replacing/turning the cutter insert (HOB260ECOSMW2)

NOTE

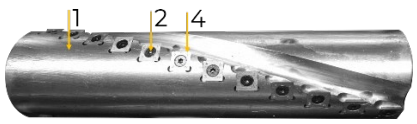
The spiral cutter head is suitable for cutter inserts.

If the planing surface is bad, only the damaged or blunt cutter insert needs to be replaced/turned.

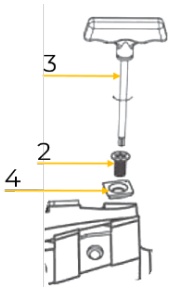
The appropriate dimensions can be found in the technical data.

WARNING

Danger from cutting edges! Always wear protective gloves when working on the spiral cutter head! Injuries to hands due to sharp cutting edges



1. Adjust the machine to thickness planing mode
2. The dust collection hood must be open in order to have access to the spiral cutter head (1)
3. Remove wood chips and dust from the heads of the screws for cutter inserts (2)
4. Unscrew the screw for cutter inserts with the key for inserts (3)
5. Remove the cutter insert (4)
6. Thoroughly clean the place of the cutter insert on the spiral cutter head



7. If the cutter insert will be turned, clean it thoroughly as well

NOTE: A cutter insert can be turned 3 times (refer to numbers (5) for help)

8. Now renew the cutter insert, or turn it over to the next number

NOTE: As an aid, it is advisable to always insert a new cutter insert with the starting point (6) at the same position

9. Fix the cutter insert with the screw for cutter inserts. (Recommended minimum tightening torque 4Nm)

18.10 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.

Prepare the surfaces and lubricate the bare machine parts with an acid-free lubricating oil (e.g. WD40 rust inhibitor).

NOTE

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

18.11 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.

19 TROUBLESHOOTING

WARNING

Danger due to electrical voltage!

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

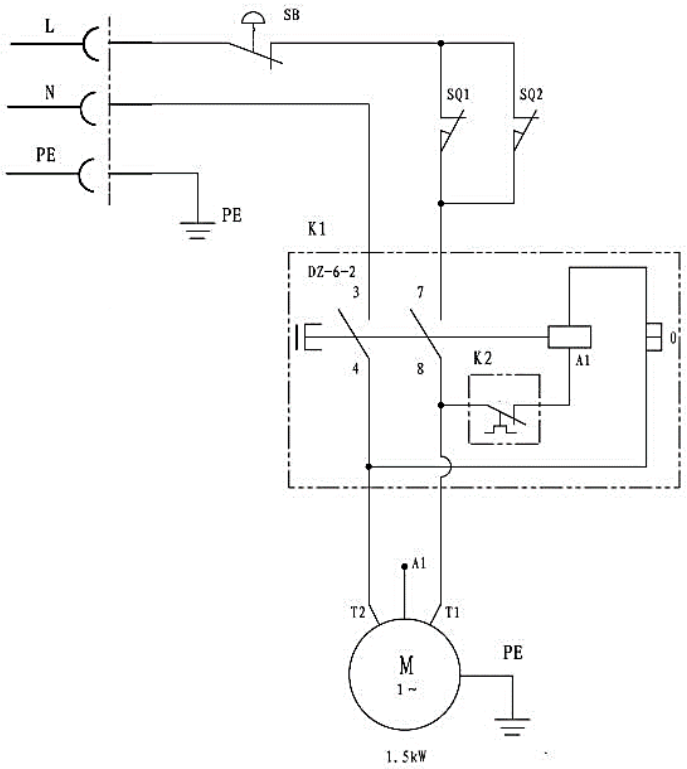
→ Always disconnect the machine from the power supply before maintenance or repair work and secure it against unintentional reconnection.

Many possible sources of error can be excluded in advance if the machine is properly connected to the power supply. 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 to high ▪ Motor protection triggered	▪ Check blade ▪ Work with lower feeding speed ▪ Let the motor cool down
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 to 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 to high	▪ Proceed the workpiece in opposite direction ▪ Set the correct cutting depth and operate in more steps

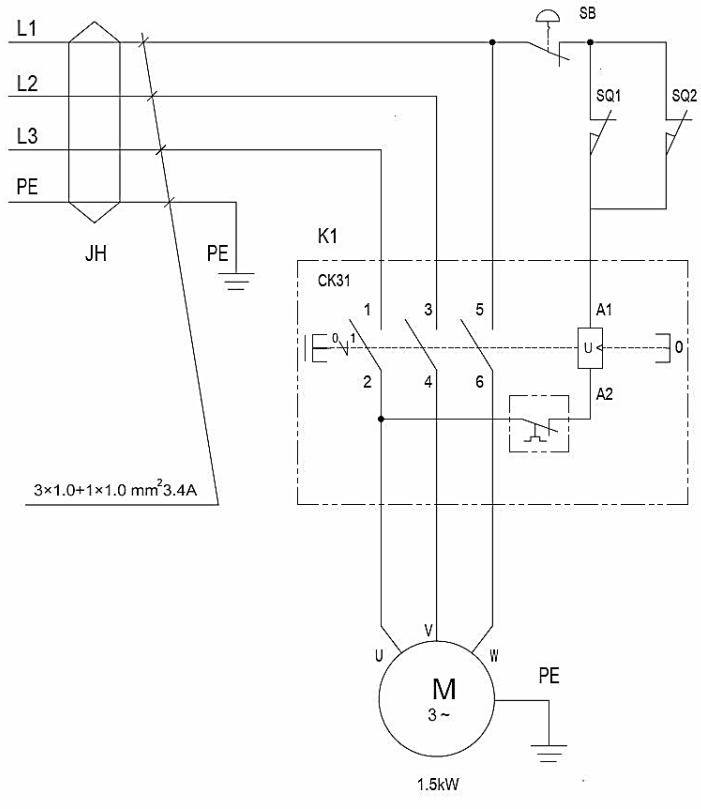
28 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM / SCHÉMA ELEKTRICKÉHO ZAPOJENÍ

HOB260ECO_230V, HOB260ECOSMW2_230V:



1	SB	HY57B (12A 250V AC)	1
2	SQ1-2	AZ8111 (10A 250V AC)	2
3	K1	DZ-6-2 (15A 250V AC)	1
4	M	1,5 kW	1

HOB260ECO_400V, HOB260ECOSMW2_400V:



1	SB	HY57B (12A 250V AC)	1
2	SQ1-2	AZ8111 (10A 250V AC)	2
3	K1	CK31 (380V)	1
4	M	1,5 kW	1
5	JH	MC6005	1

29 ERSATZTEILE / SPARE PARTS / NÁHRADNÍ DÍLY

29.1 Ersatzteilbestellung / spare parts order / Objednání náhradních dílů

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

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

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

- über unsere Homepage – Kategorie SERVICE – ERSATZTEILANFORDERUNG,
- per Mail an service@holzmann-maschinen.at.

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

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

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

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

- via our Homepage – category SERVICE - SPARE PARTS REQUEST,
- by e-mail to service@holzmann-maschinen.at.

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

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

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

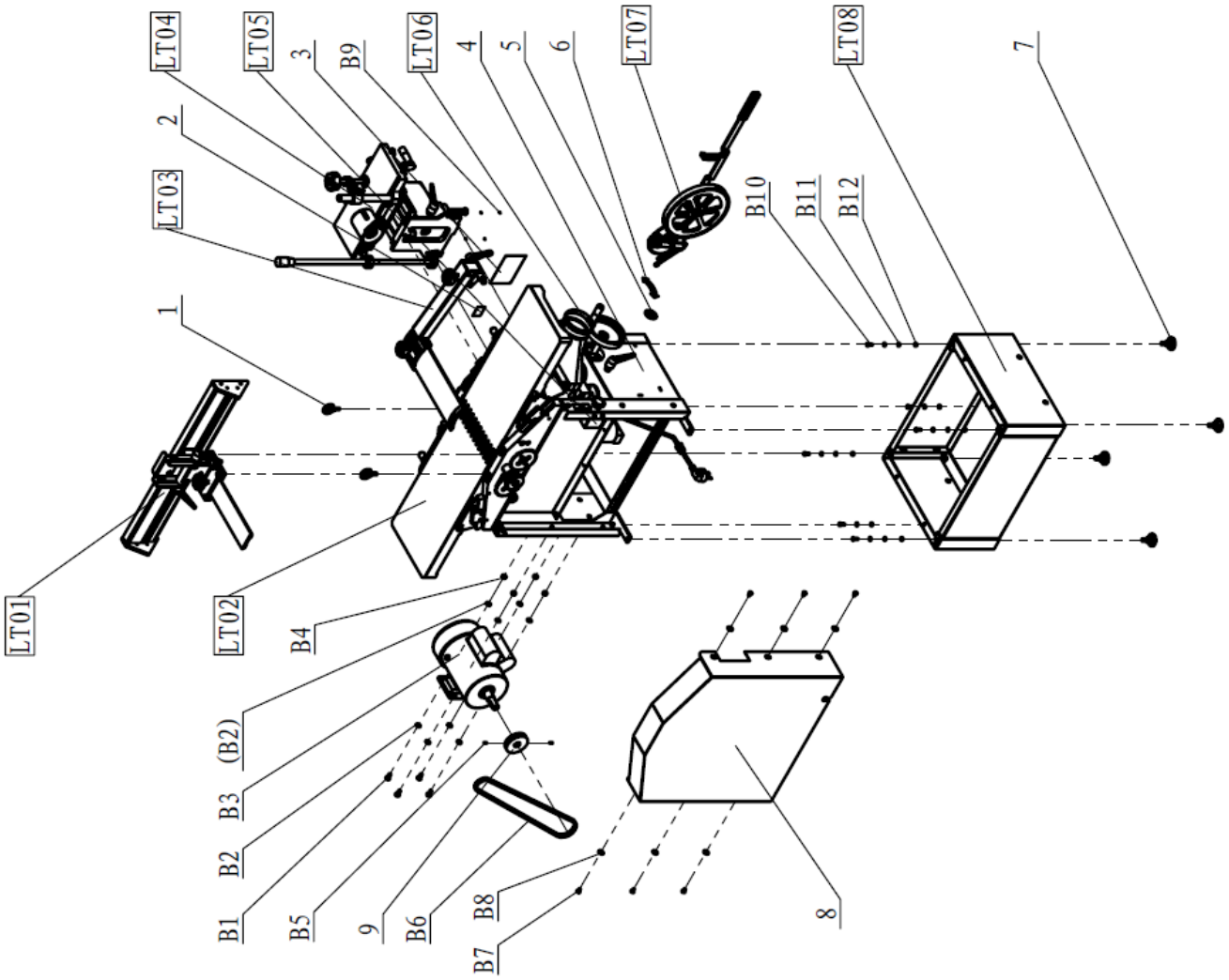
Náhradní díly objednávejte přímo na naší domovské stránce – kategorie NÁHRADNÍ DÍLY.
nebo kontaktuje náš zákaznický servis

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

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

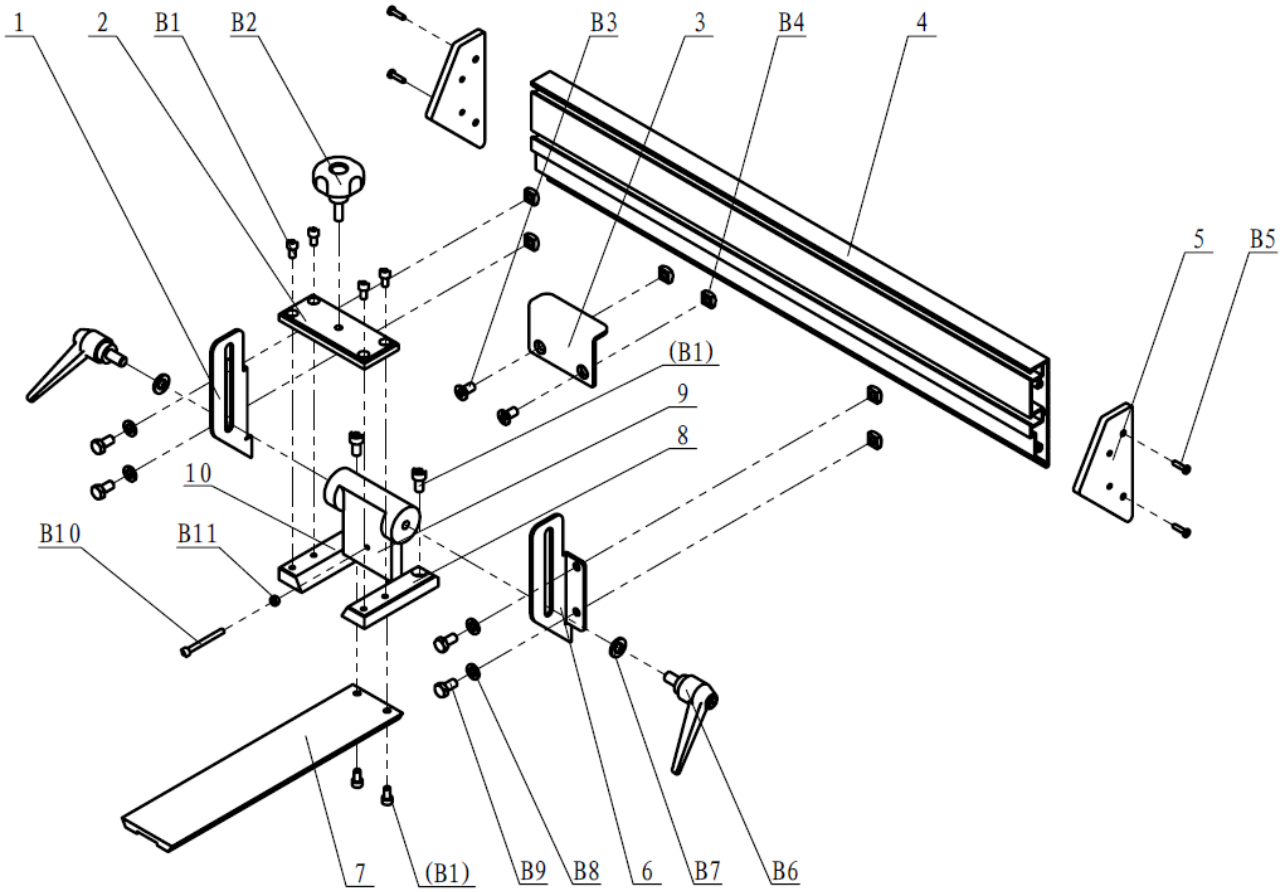
29.2 Explosionszeichnung / Exploded view / Výkres v rozloženém stavu

LT00:



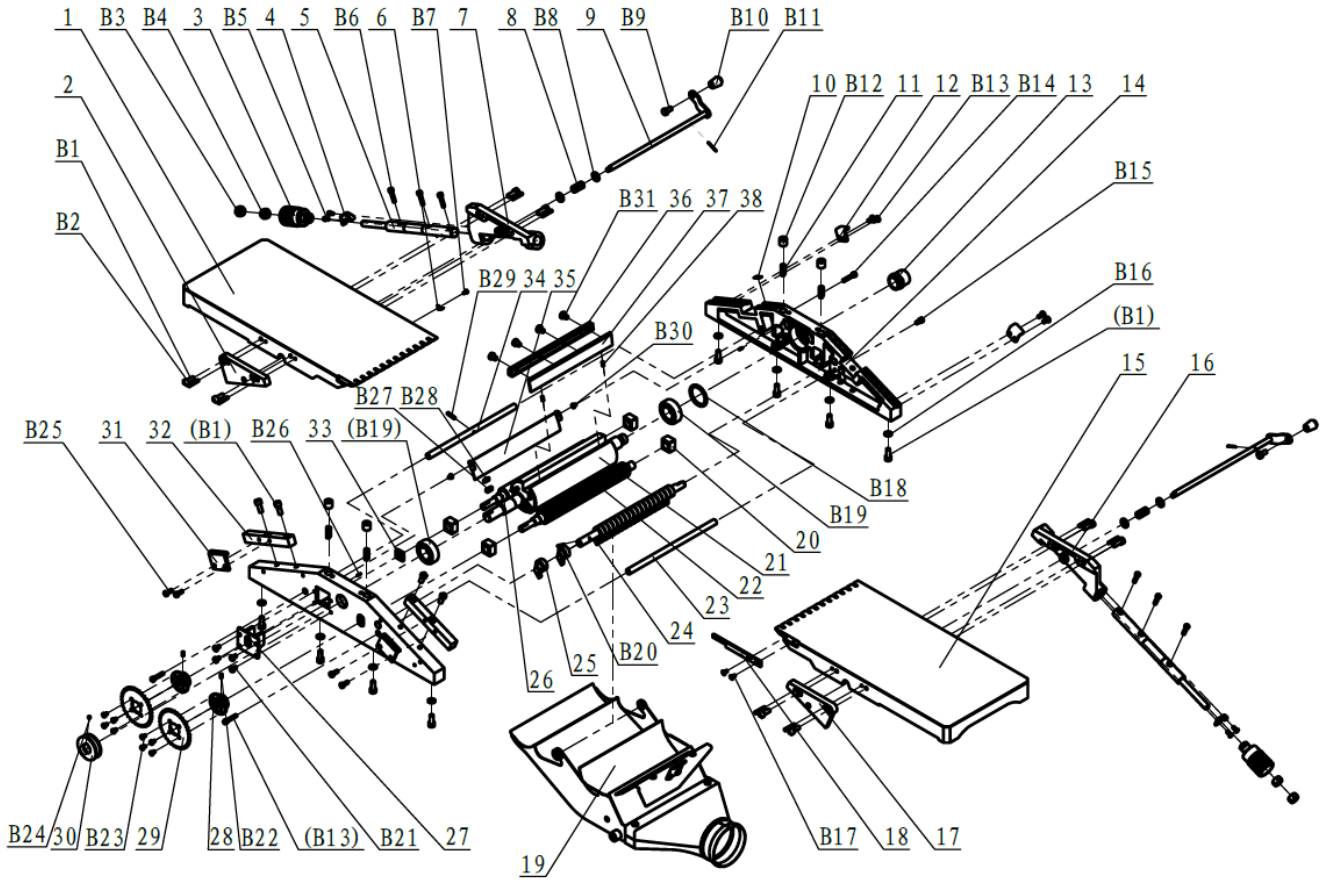
No.	Description	Qty	No.	Description	Qty
1	Lift hook	2	**B1**	Bolt M8x16	4
2	Planer operation symbol	1	**B2**	Flat pad 8-140HV	8
3	Nameplate	1	**B3**	Motor (YLG90S-2)	1
4	Planer body	1	**B4**	Nut M8	4
5	Press planer lock symbol	1	**B5**	Screw M5x10	2
6	Pressure plane lifting symbol	1	**B6**	V-belt (Z1120)	1
7	Adjustable foot	4	**B7**	Screw M6x10	6
8	Big hood	1	**B8**	Big spacer 6-140HV	6
9	Motor pulley	1	**B9**	Rivet of label 2x4	4
			B10	Bolt M6x16	6
			B11	Flat pad 6-140HV	12
			B12	Nut M6	6

LT01:



No.	Description	Qty	No.	Description	Qty
1	Right support	1	**B1**	Screw M6x12	8
2	Fixing board	1	**B2**	Four-star handle M8x50x25	1
3	Board	1	**B3**	Screw M8x16	2
4	Guiding board	1	**B4**	Square nut M8	6
5	End cap of guiding board	2	**B5**	Screw ST4.2x19	4
6	Left support	1	**B6**	Handle BM10x80	2
7	Sliding plate	1	**B7**	Flat pad 10-140HV	2
8	Right positioning block	1	**B8**	Flat pad 10-140HV	4
9	Support base	1	**B9**	Bolt M8×16	4
10	Left position block	1	**B10**	Screw M5×50	1
			B11	Nut M5	1

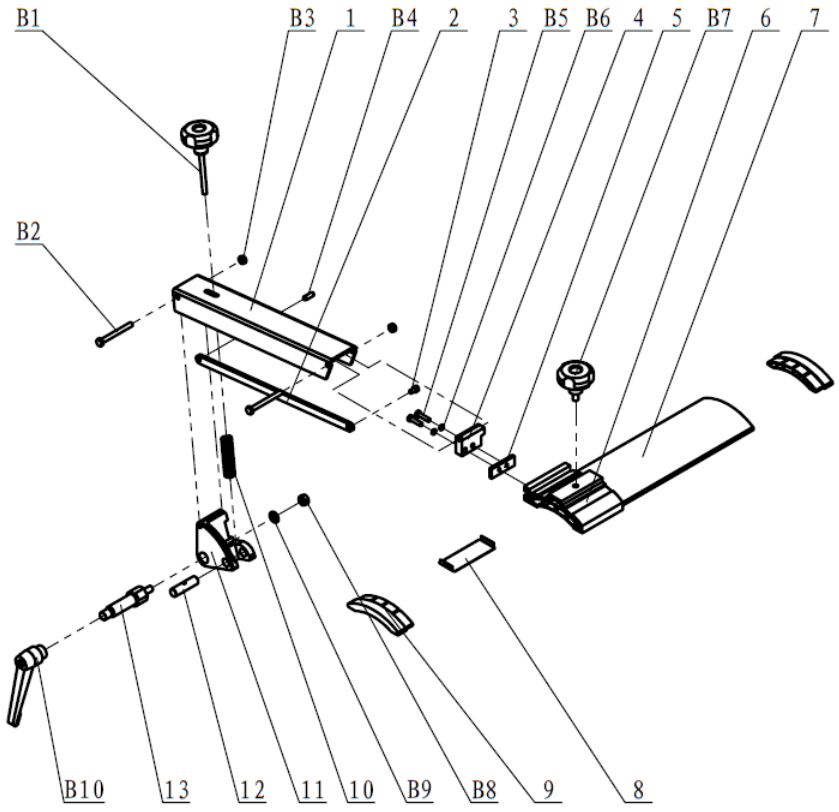
LT02:



No.	Description	Qty	No.	Description	Qty
1	Front table	1	**B1**	Screw M8x20	20
2	Left front sliding base	1	**B2**	Round pin A5x30	8
3	Knob case	2	**B3**	Nut M12	2
4	Retaining plate	2	**B4**	Fixed nut M12	2
5	Round trail	2	**B5**	Bolt M5x10	4
6	Staff pointer	1	**B6**	Screw M6x25	6
7	Right front sliding base	1	**B7**	Screw zinc M4x8	1
8	Spring	2	**B8**	Flat washer 10-140HV	4
9	Locking lever	2	**B9**	Bolt M8x16	2
10	Staff	1	**B10**	Knob case M8x25	2
11	Spring	4	**B11**	Cotter pin 2.5x20	2
12	Table turning plate	2	**B12**	Screw M6x16	4
13	Hood for spindle	1	**B13**	Screw M6x12	4
14	Right bearing	1	**B14**	Screw M6x30	3
15	Back table	1	**B15**	Screw M6x12	1
16	Right back sliding case	1	**B16**	Flat washer 8-140HV	8
17	Right back sliding case	1	**B17**	Screw M5x10	2
18	Limiting board	1	**B18**	Steel waveform spring steel D52	1

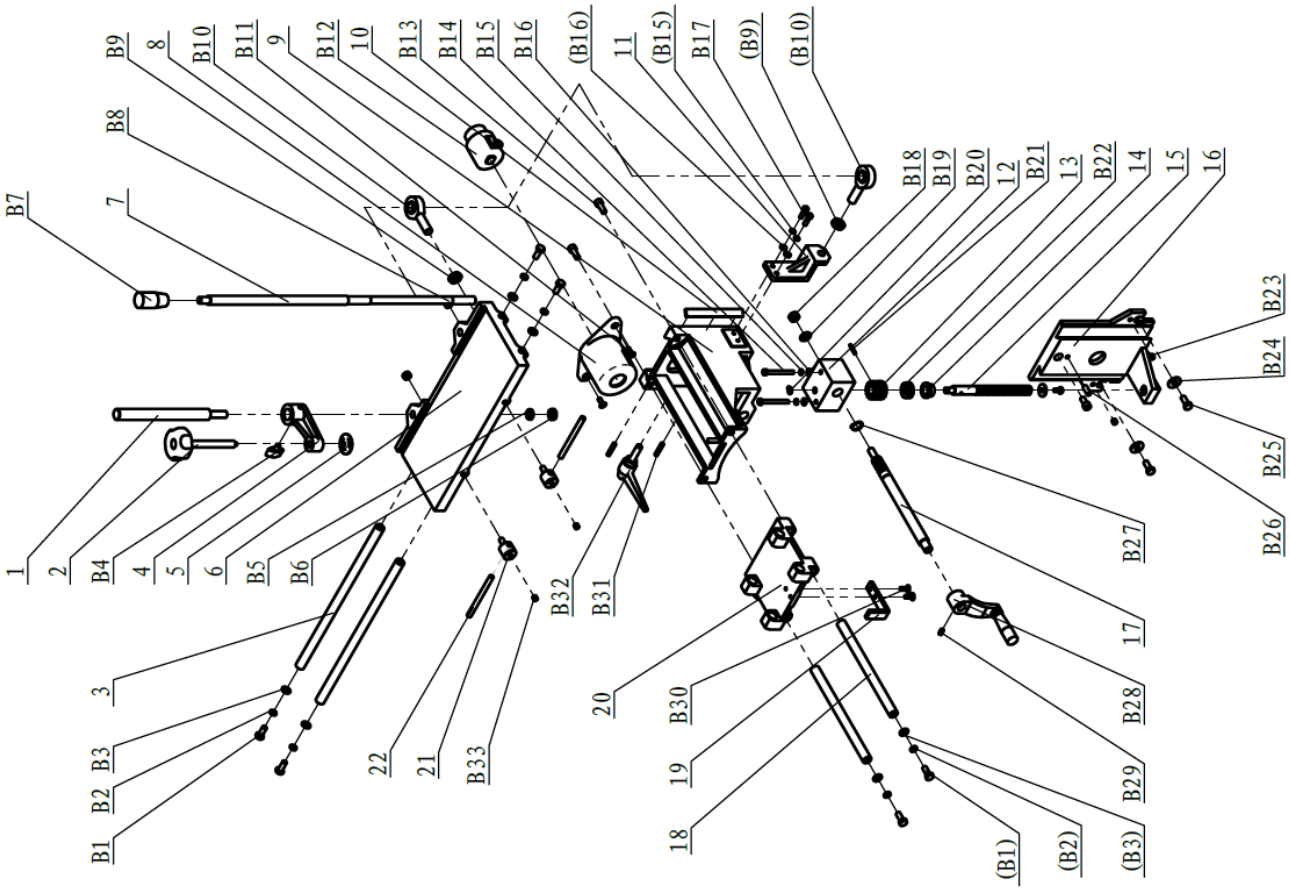
19	Hood of planing	1	**B19**	Bearing 6205-2RS	2
20	Bearing block	4	**B20**	Round pin 3x24	1
21	Planer tool	1	**B21**	Screw M6x10	4
22	Feed roller	1	**B22**	Screw M5x10	2
23	Enhance shaft	1	**B23**	Screw M5x8	8
24	Non-return device shaft	1	**B24**	Screw M5x4	1
25	Non-return claw	20	**B25**	Bolt M6x16	4
26	Discharge roller	1	**B26**	Round pin 3x10	2
27	Bearing limit board	1	**B27**	Flat key 6x25	1
28	Sprocket base	2	**B28**	Flat key 5x16	2
29	Feeding sprocket	2	**B29**	Round pin 5x22	1
30	Pulley	1	**B30**	Screw M5x6	2
31	Fixed board	2	**B31**	Bolt M8x10	12
32	Square guiding rail	2			
33	Adjusting pad	1			
34	Enhance shaft	1			
35	Baffle	1			
36	Pressing tool	3			
37	Knife	3			
38	Spring	6			

LT03:



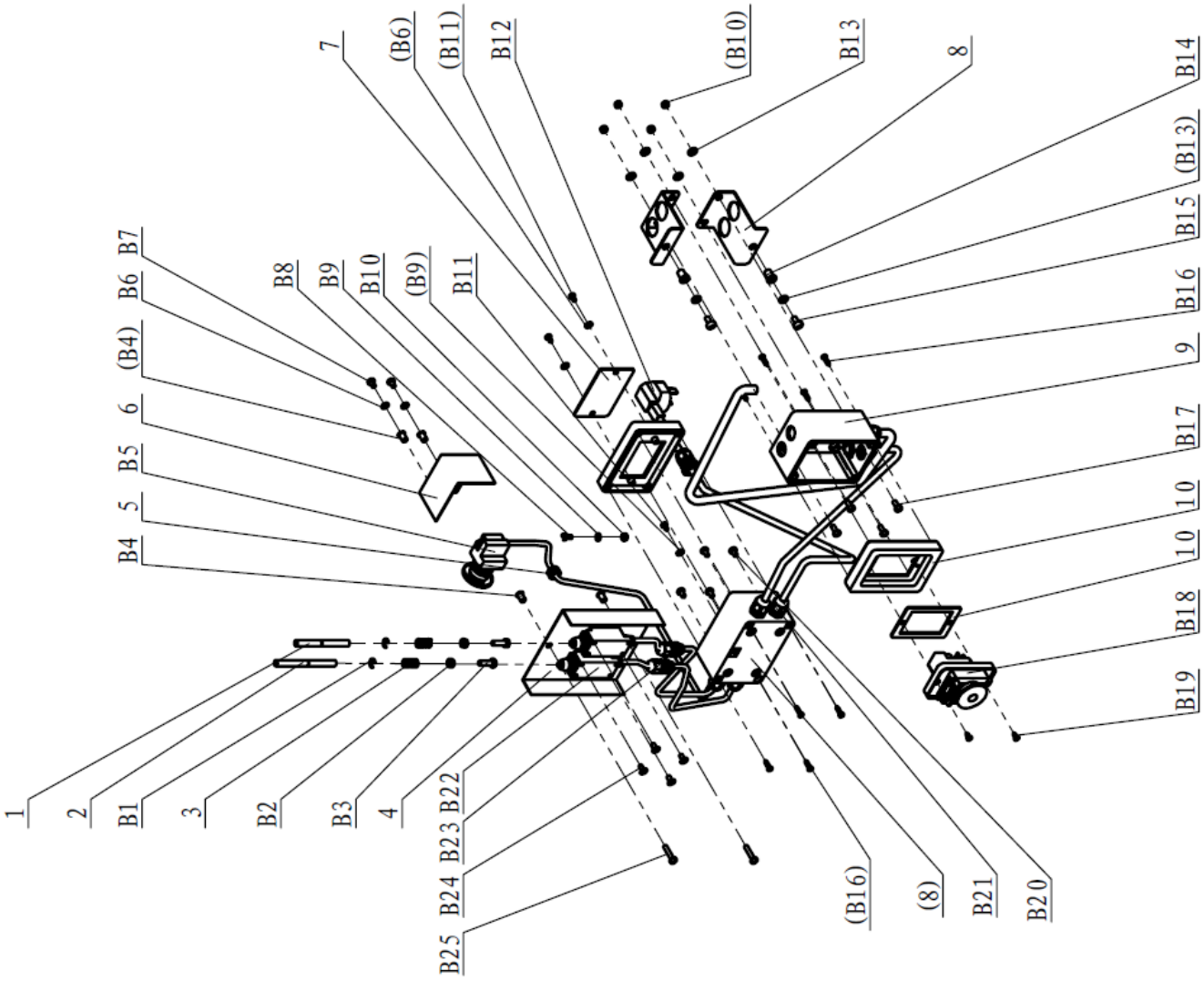
No.	Description	Qty	No.	Description	Qty
1	Support arm	1	**B1**	Knob M6x50x70	1
2	Parallel rod	1	**B2**	Bolt M6x60	2
3	Fixing block	1	**B3**	Fixed nut M6	2
4	Screw	1	**B4**	Round pin A6x16	1
5	Nut plate	1	**B5**	Bolt M5x20	2
6	Fender board base	1	**B6**	Spring spacer 5	2
7	Fender board	1	**B7**	Four-star knob M8x50x15	1
8	Press board	1	**B8**	Nut M8	1
9	End cap	2	**B9**	Flat washer 8-140HV	1
10	Spring	1	**B10**	Knob M12x95	1
11	Supporting arm base	1			
12	Small spindle	1			
13	Spindle	1			

LT04 (optional):



No.	Description	Qty	No.	Description	Qty
1	Lock pole	1	**B1**	Bolt M8x20	6
2	Lock screw	1	**B2**	Spring washer 8	6
3	Up track	2	**B3**	Flat washer 8-140HV	6
4	Locking support arm	1	**B4**	Knob M8x10	1
5	Press pan	1	**B5**	Spring washer 12	1
6	Drill table	1	**B6**	Nut M12	1
7	Operation lever	1	**B7**	Long knob case BM12x60	1
8	Chuck hood	1	**B8**	Nut M8	2
9	Down sliding base	1	**B9**	Thin nut M14	2
10	Wedge	1	**B10**	Ball head gimbal M14x40	2
11	Universal socket	1	**B11**	Screw M6x16	2
12	Dear room	1	**B12**	Chuck M20x1.5L/0-16	1
13	Spiral gear	1	**B13**	Screw M8x20	2
14	Sleeve	1	**B14**	Bolt M6x60	2
15	Lifting	1	**B15**	Spring washer 6	4
16	Sliding base	1	**B16**	Flat washer 6-140HV	4
17	Gear shaft	1	**B17**	Screw M6x20	2
18	Down sliding base	2	**B18**	Lock nut M10	1
19	Board	1	**B19**	Flat washer 10-140HV	1
20	Slide board	1	**B20**	Retainer 10	1
21	Fixed axis	2	**B21**	Round pin 4x22	1
22	Push rod	2	**B22**	Thrust ball bearing 51102	1
			B23	Screw M8x8	2
			B24	Big spacer 8-140HV	2
			B25	Bolt M8x25	2
			B26	Screw M8x20	1
			B27	Retainer 18	1
			B28	Handle B14x60x70	1
			B29	Screw M6x12	1
			B30	Screw M6x16	2
			B31	Screw M6x30	2
			B32	Handle BM10x80	1
			B33	Screw M8x8	2

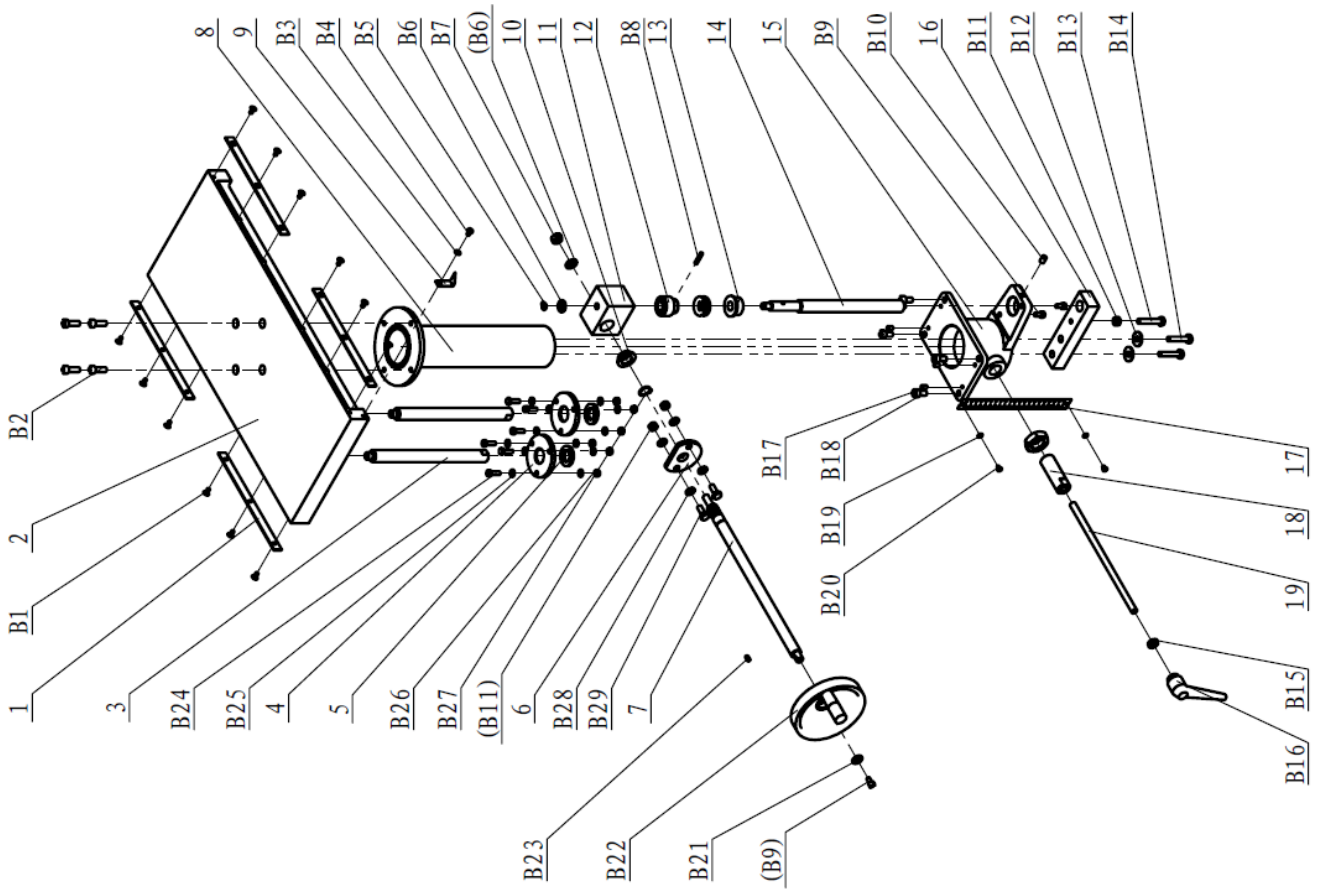
LT05:



No.	Description	Qty	No.	Description	Qty
1	Push rod	1	**B1**	Split washer 6	2
2	Push rod	1	**B2**	Bolt M6	2
3	Spring	2	**B3**	Bolt M6x20	2
4	Limit switch cover	1	**B4**	Insert nut M5x11	4
5	Thread sheat	1	**B5**	Emergency switch Y090	1
6	Button cover	1	**B6**	Flat washer 5-140HV	4
7	Electrical box cover	1	**B7**	Screw M5x8	2
8	Support plate	2	**B8**	Screw M5x10	1
9	Electrical box	2	**B9**	Copper flat washer 5-140HV	2
10	Electrical box cover	2	**B10**	Nut M5	5
11	Electrical box pad	1	**B11**	Tapping screw ST4.2x10	2
			B12	Single phase three pole plug 250V10A	1
			B13	Flat spacer 6-140HV	6

			B14	Insert nut M6x13.5	2
			B15	Screw M6x12	2
			B16	Tapping screw ST3.5x16	8
			B17	Screw M5x12	4
			B18	Switch DKLD-DZ-6-2	1
			B19	Tapping screw ST3.5x10	2
			B20	Screw M5x8	4
			B21	Cable fixed head PG9	7
			B22	Limit switch	2
			B23	Cable fixed head PG7	2
			B24	Screw M5x10	4
			B25	Screw M5x25	2

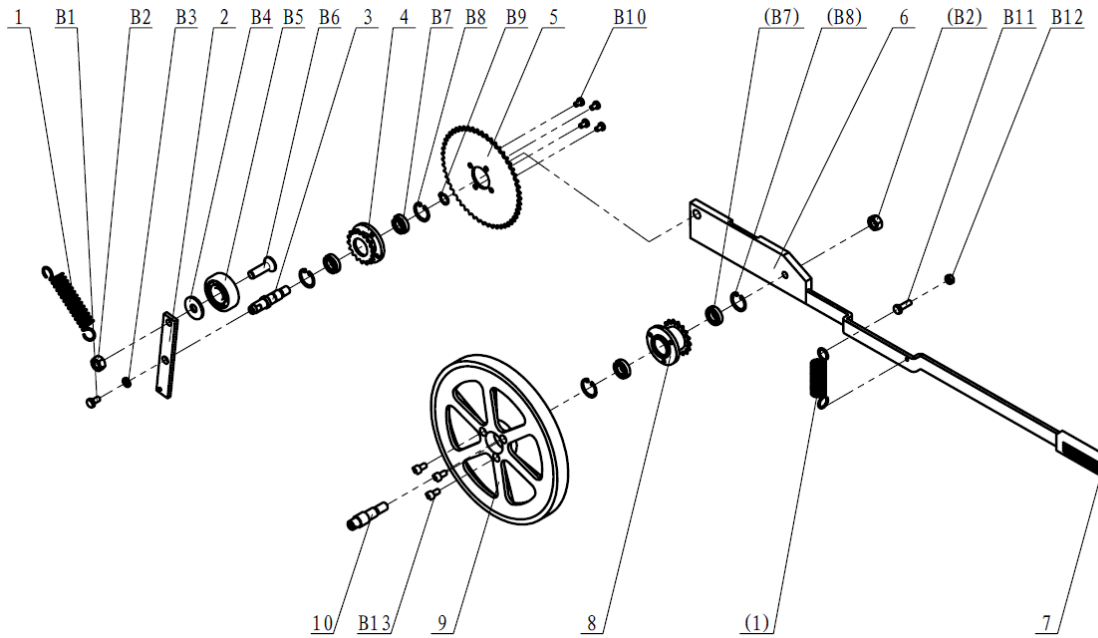
LT06:



No.	Description	Qty	No.	Description	Qty
1	Board	4	**B1**	Screw M5x10	12
2	Press planer worktable	1	**B2**	Screw M8x25	4
3	Assistant pole	2	**B3**	Flat spacer 5-140HV	1
4	Fixed disc	2	**B4**	Screw M5x10	1
5	Assistant guiding sleeve	2	**B5**	Retainer 10	1

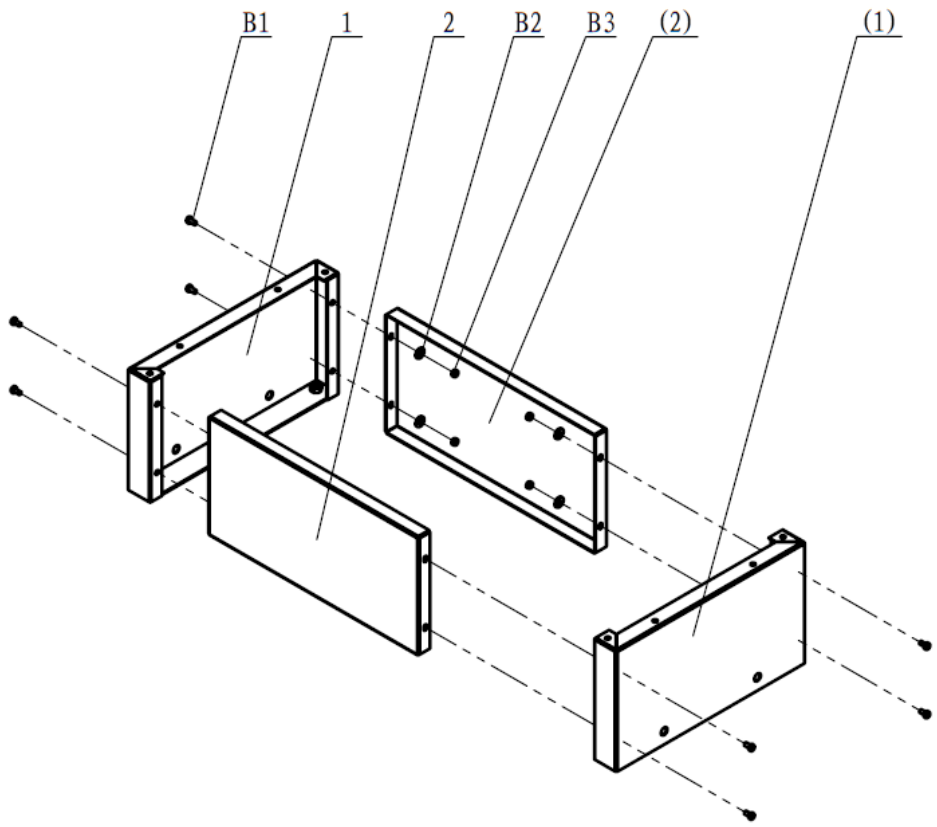
6	Hand wheel base	1	**B6**	Flat spacer10-140HV	2
7	Gear shaft	1	**B7**	Fixing nut M10	1
8	Guiding pole	1	**B8**	Round pin 5x24	1
9	Pressure plane cursor	1	**B9**	Screw M6x12	2
10	Guiding sleeve	1	**B10**	Screw M8x12	1
11	Gear room	1	**B11**	Nut M8	3
12	Spiral gear	1	**B12**	Big spacer 8-140HV	2
13	Locking sleeve	1	**B13**	Bolt M8x45	1
14	Elevating screw	1	**B14**	Bolt M8x40	2
15	Guiding pole base	1	**B15**	Thin nut M10	1
16	Nut plate	1	**B16**	Handle M10x80	1
17	Press planer staff	1	**B17**	Screw M6x10	4
18	Pole locking sleeve	1	**B18**	Screw M8x16	4
19	Lock screw	1	**B19**	Flat spacer 4-140HV	2
			B20	Screw zinc M4x8	2
			B21	Big spacer 6-140HV	1
			B22	Hand wheel	1
			B23	Flat key C4x10	1
			B24	Bolt M6x20	6
			B25	Spacer 6-140HV	12
			B26	Nut M6	6
			B27	Retainer 18	1
			B28	Flat pad	4
			B29	Screw M8x20	2

LT07:



No.	Description	Qty	No.	Description	Qty
1	Spring	2	**B1**	Bolt M6x12	1
2	Tension plate	1	**B2**	Nut M10	1
3	Support shaft	1	**B3**	Flat pad 6-140HV	1
4	Friction end sprocket	1	**B4**	Big spacer 10-140HV	1
5	Big sprocket	1	**B5**	Bearing 6303-2RS	1
6	Feed lever	1	**B6**	Screw M10x35	1
7	Handle	1	**B7**	Bearing 61901-RZ	4
8	Friction end sprocket	1	**B8**	Retainer 24	4
9	Friction wheel	1	**B9**	Retainer 12	1
10	Friction wheel	1	**B10**	Screw M5x8	4
			B11	Bolt M6x20	1
			B12	Nut M6	1
			B13	Screw M6x12	3

LT08:



No.	Description	Qty	No.	Description	Qty
1	Bases side plate	2	**B1**	Bolt M6x12	8
2	Base panel	2	**B2**	Big spacer 8-140HV	8
			B3	Nut M6	8