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Originalfassung

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

Übersetzung / Translation

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

FR MODE D'EMPLOI **MACHINE À RABOTER ET À DÉGAUCHIR (avec arbre de rabotage à lames hélicoïdales)**

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

HOB410ECO_400V
HOB410ECOSMW2_400V

JOB. OUR TOOLS.

Edition: 04.12.2023 – Revision - 00 – EcC - DE/EN/FR/CZ

2 SICHERHEITSZEICHEN / SAFETY SIGNS / SYMBOLES DE SECURITE / BEZPEČNOSTNÍ ZNAČKY

DE SICHERHEITSZEICHEN
BEDEUTUNG DER SYMBOLE
EN SAFETY SIGNS
DEFINITION OF SYMBOLS
FR SYMBOLES DE SÉCURITÉ
SIGNIFICATION DES SYMBOLES
CZ BEZPECNOSTNI ZNACKY
VÝZNAM SYMBOLŮ

DE **CE-KONFORM!** - Dieses Produkt entspricht den EU-Richtlinien.
EN **CE-Conformal!** - This product complies with the EC-directives.
FR **CONFORMITÉ CE !** - Ce produit répond aux directives CE.
CZ **VYHOVUJE CE!** - Tento výrobek vyhovuje směrnicím EU.

DE **BETRIEBSANLEITUNG LESEN!** Lesen Sie die Betriebs- und Wartungsanleitung Ihrer Maschine aufmerksam durch und machen Sie sich mit den Bedienelementen der Maschine gut vertraut, um die Maschine ordnungsgemäß zu bedienen und so Schäden an Mensch und Maschine vorzubeugen.

EN **READ THE MANUAL!** Read the user and maintenance carefully and get familiar with the controls in order to use the machine correctly and to avoid injuries and machine defects.

FR **LIRE LE MODE D'EMPLOI !** Veuillez lire le manuel d'exploitation et de maintenance de votre machine avec assiduité en vous familiarisant bien avec les organes de commande de la machine pour l'utiliser correctement et prévenir ainsi des blessures corporelles et des dégâts sur la machine.

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

DE Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

EN Switch off the machine before maintenance and breaks and pull out the mains plug!

FR Éteindre la machine avant la maintenance et les pauses et débrancher la fiche secteur !

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

DE Persönliche Schutzausrüstung tragen!

EN Wear personal protektive equipment!

FR Porter un équipement de protection individuelle !

CZ Používejte osobní ochranné prostředky!

DE Warnung vor spitzem (scharfem) Werkzeug!
EN Warning of pointed (sharp) tool!
FR Avertissement contre les outils pointus (tranchants) !
CZ Upozornění na špičaté (ostré) nástroje!

DE Immer ausreichend Abstand zur Hobelwelle halten. Während des Betriebs ausreichend Abstand zu angetriebenen Bauteilen halten.

EN Always keep your hands well clear of the planer shaft. Keep sufficient distance to driven components when operating this machine.

FR Toujours garder une distance suffisante par rapport à l'arbre de rabotage. Pendant le fonctionnement, se tenir à une distance suffisante des éléments entraînés.

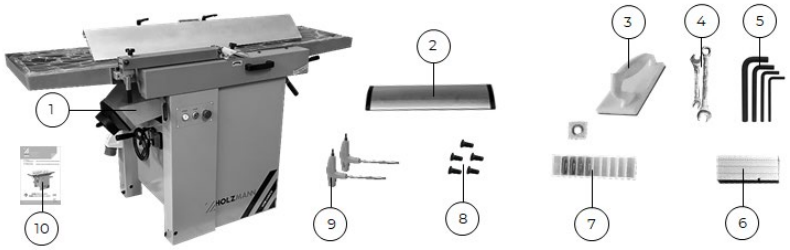
CZ Vždy udržujte dostatečnou vzdálenost od hoblovacího hřídele. Během provozu udržujte dostatečnou vzdálenost od poháněných součástí.

DE Benutzen von Handschuhen verboten!
EN Do not use wearing gloves!
FR Défense utilisait des gants !
CZ Používání rukavic je zakázáno!

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!**
FR **Les panneaux d'avertissement et/ou autocollants d'avertissement illisibles ou retirés sur la machine doivent être remplacés immédiatement !**
CZ **Výstražné štítky a/nebo nálepky na stroji, které jsou nečitelné či byly odstraněny, je nutné ihned obnovit!**

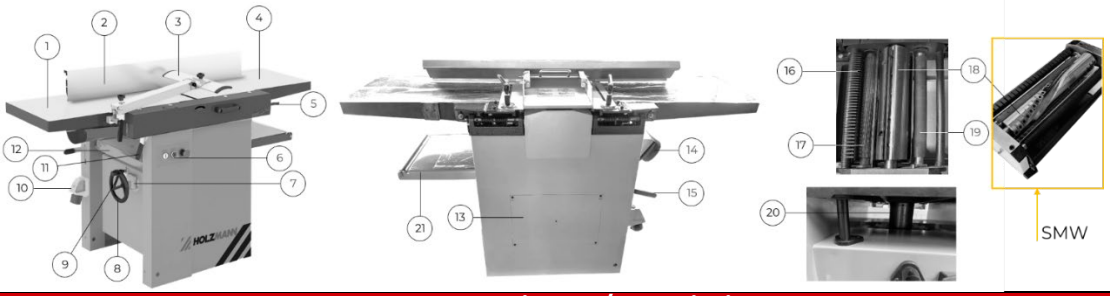
3 TECHNIK / TECHNICS / TECHNIQUE / TECHNICKÁ ČÁST

3.1 Lieferumfang / Delivery content / Contenu de la livraison / Rozsah dodávky



#	Beschreibung / Description	Qty.
1	Maschine / machine / Machine / Stroj	1
2	Brückenschutzabdeckung / planer knife cover / Cache de protection de portique / Můstkový ochranný kryt	1
3	Schiebeholz / sliding wood / Cale coulissante / Posuvný dřevěný blok	1
4	Gabelschlüssel / wrench / Clé à fourche / Vidlicový klíč	2
5	Inbusschlüsselset / Allen key set / Set de clés Allen / Sada inbusových klíčů	1
6	**HOB410ECO:** Einstelllehre Hobelmesser / setting gauge planer knives / Gabarit de réglage des lames de rabot / Seřizovací měrka hoblovacího nože	1
7	**HOB410ECOSMW2:** Wendeschneidplatten (Ersatz) / cutter inserts (spare) / Plaquettes de rechange (remplacement) / Vyměnitelné břitové destičky (náhradní díly)	5
8	**HOB410ECOSMW2:** Wendeschneidplattenschrauben (Ersatz) / cutter inserts screws (spare) / Vis des plaquettes de rechnage (remplacement) / Šrouby vyměnitelných břitových destiček (náhradní díly)	5
9	**HOB410ECOSMW2:** Schlüssel für Wendeschneidplatten / key for cutter inserts / Clé de plaquettes de rechange / Klíč na vyměnitelné břitové destičky	2
10	Betriebsanleitung / user manual / Mode d'emploi / Návod k použití	1

3.2 Komponenten / Components / Composants / Komponenty



#	Beschreibung / Description
1	Abnahmetisch / exit planer table / Table de sortie / Výstupní stůl
2	Abrichtanschlag / planer fence / Butée de dégauchissage / Srovnávací doraz
3	Brückenschutzabdeckung / blade guard / Cache de protection de portique / Můstkový ochranný kryt
4	Aufgabetisch / entry planer table / Table de chargement / Vstupní stůl
5	Einstellhebel Abrichthobeldicke / adjustment lever planer cutting depth / Levier de réglage de l'épaisseur de la dégauchisseuse / Páčka pro nastavení tloušťky srovnávacího hoblování
6	Bedienpult / control panel / Pupitre de commande / Ovládací pult
7	Zählwerk Höhenverstellung / counter block for height adjustment / Compteur de réglage en hauteur / Počítadlo pro změnu nastavení výšky
8	Handrad Höhenverstellung Dickenhobel / handwheel height adjustment thicknesser / Volant à main de réglage en hauteur du rabot d'usinage en épaisseur / Ruční kolečko pro změnu nastavení výšky tloušťkovacího hoblíku
9	Klemmhebel Höhenverstellung Dickenhobel / clamping lever height-adjustment thicknesser / Levier de blocage de réglage en hauteur du rabot d'usinage en épaisseur / Upínací páka změny nastavení výšky tloušťkovacího hoblíku
10	Anschlussdose 400V / input box 400V / Boîte de raccordement 400 V / Připojovací krabice 400 V
11	Klemmhebel Abrichttische / fixation handle planer tables / Levier de blocage de la table de dégauchissage / Upínací páka srovnávacích stolů
12	Dickenhobeltisch / thicknesser table / Table de la raboteuse / Tloušťkovací stůl
13	Riemen-Kettenabdeckung / belt-chain cover / Cache de courroie et de chaîne / Kryt řemenu
14	Absaughaube umklappbar / dust collector hood / Hotte d'aspiration rabattable / Sklopný odsávací kryt
15	Hebel für Dickenhobelvorschub / handle for thicknesser feeder / Levier d'avance du rabot d'usinage en épaisseur / Páka posuvu tloušťkovacího hoblíku

16	Rückschlaggreifer / anti-kick-back device / Pinces de dispositif anti retour / Zařízení proti zpětnému rázu	
17	Einzugswalze / feed roller / Rouleau d'alimentation / Podávací válec	
18	Hobelwelle / planer shaft / Arbre du rabot / Hoblovací hřídel	
19	Auszugswalze / pull-out roller / Rouleau d'extraction / Vytahovací válec	
20	Höhenverstelleinheit Dickenhobeltisch / height adjustment unit thicknesser / Unité de réglage de la hauteur du rabot d'usinage en épaisseur / Jednotka změny nastavení výšky tloušťkovacího stolu	
21	**Optional / En option / Volitelně: HOB410ECO-ET**	Erweiterungstisch / extension table / Table d'extension / Rozšiřovací stůl

3.3 Technische Daten / Technical Data / Données techniques / Technické údaje

Allgemein / general	HOB410ECO	HOB410ECOSMW2
Spannung / Voltage / Tension / Napětí	400 V/50 Hz	
Motorleistung S6 (40%) / Motor power S6 (40%) / Puissance moteur S6 (40 %) / Výkon motoru S6 (40 %)	4 kW	
Hobelwelle / planer shaft / Arbre du rabot / Hoblovací hřídel	Ø 70 x 410 mm	
Anzahl Hobelmesser / quantity of blades / Nombre de lames de rabot / Počet hoblovacích nožů	3	-
Anzahl Rillen / amount of grooves / Nombre de rainures / Počet drážek	-	2
Anzahl Wendeschneidplatten / quantity cutter inserts / Nombre de plaquettes de rechange / Počet vyměnitelných břitových destiček	-	44
Hobelmesserdimension (Streifenmesser) / planer knife dimension / Dimension des lames de rabot (lames striées) / Rozměry hoblovacího nože (plochého nože)	410 x 25 x 3 mm	-
Wendeschneidplatten / cutter inserts set / Plaquettes de rechange / Vyměnitelné břitové destičky	-	15 x 15 x 2,5 mm (30°)
Hobelwellendrehzahl / blade shaft speed / Vitesse de l'arbre de rabotage / Otáčky hoblovacího hřídele	5500 min^{-1}	
Absauganschluss / dust collector plug / Raccord d'aspiration / Přípojka odsávání	Ø 120 mm	
notwendiger Luftvolumenstrom Absauganlage / necessary air volume / Débit d'air nécessaire de l'installation d'aspiration / požadovaný systém odsávání objemového průtoku vzduchu	min. 1000 m^3/h	
notwendiger Unterdruck Absauganlage / vacuum dust collector / Dépression nécessaire de l'installation d'aspiration / požadovaný podtlak (odsávací zařízení)	800 Pa	
Maschinenmaße (LxBxH) / machine dimensions (LxWxH) / Dimensions de la machine (LxlxH) / Rozměry stroje (dxšxv)	1670 x 680 x 1000 mm	
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH) / Dimensions d'emballage (LxlxH) / Rozměry obalu (dxšxv)	1710 x 740 x 1150 mm	
Gewicht Brutto / weight gross / Poids brute / Hmotnost brutto	353 kg	
Gewicht Netto / weight net / Poids net / Hmotnost netto	295 kg	
Schallleistungspegel L_{WA} (ISO 3746) / sound power level L_{WA} / Niveau de puissance acoustique L_{WA} (ISO 3746) / Hladina akustického výkonu L_{WA} (ISO 3746)	107 dB(A)k: 4 dB(A)	104 dB(A)k: 4 dB(A)
Schalldruckpegel L_{PA} (ISO 11202) / Sound pressure level L_{PA} / Niveau de pression acoustique L_{PA} (ISO 11202) / Hladina akustického tlaku L_{PA} (ISO 11202)	89 dB(A)k: 4 dB(A)	86 dB(A)k: 4 dB(A)
Abrichthobel / planer / Dégauchisseuse / Srovnávací hoblík		
Tischgröße / planer table size / Dimension de table / Velikost stolu	1660 x 410 mm	
Tischhöhe / table height / Hauteur de table / Výška stolu	850 mm	
max. Abrichtbreite / max planing width / Largeur max. de dégauchissage / Max. srovnávací šířka	410 mm	
Schwenkbereich Anschlag / angle range of angle stop / Plage de pivotement de la butée / Otočný rozsah dorazu	90° - 45°	
max. Spanabnahme / max depth of cut / Profondeur max. de rabotage / Max. úběr třísky	4 mm	
Abrichtanschlag Dimension / planer fence dimension / Dimensions de la butée de dégauchissage / Rozměry srovnávacího dorazu	1100 x 150 mm	

Dickenhobel / thicknesser / Rabot d'usinage en épaisseur / Tloušťkovací hoblík	
Tischgröße / table size / Dimension de table / Velikost stolu	650 x 407 mm
max. Hobelbreite / max. thicknessing width / Largeur max. du rabot / max. šířka hoblování	405 mm
min. Werkstückdicke / min. thickness of workpiece / Épaisseur Min. de la pièce à usiner / Min. tloušťka obrobku	4 mm
max. Werkstückdicke / max. thickness of workpiece / Épaisseur max. de la pièce à usiner / Max. tloušťka obrobku	225 mm
max. Spanabnahme / max. depth of cut / Profondeur max. de rabotage / Max. úběr třísky	3 mm
Vorschubgewschwindigkeit / feed speed / Vitesse d'avance / Rychlost posuvu	7 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.

(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.

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

11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the combined planer and thicknesser (with spiral cutter head) HOB410ECO_400V and HOB410ECOSMW2_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.

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12 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!

12.1 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.

12.1.1 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

12.1.2 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 planing.
- Synchronous planing
- 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.

12.2 User requirements

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

12.3 Safety devices

The machine is equipped with following safety devices:

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

12.4 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.

12.5 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.

12.6 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.

12.7 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!

13 TRANSPORT

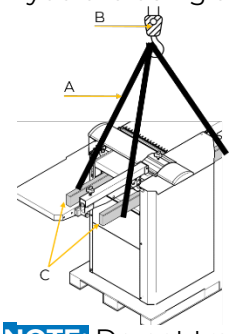
WARNING

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 ropes or belts (A) with appropriate load-bearing capacity and length
- Hook the ropes to the crane hook (B)
- Place 2 battens underneath the thicknesser bed
- Attach the ropes to the battens (C)
- 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

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

14 ASSEMBLY

14.1 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.

14.2 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.

14.3 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.

14.4 Assembling the machine

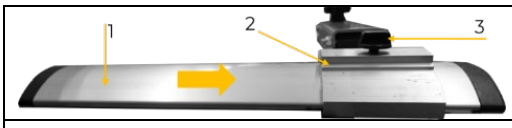
The machine is pre-assembled. The parts that have been disassembled for transport must be assembled before use. Follow the instructions below:

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 planer knife cover

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

14.5 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

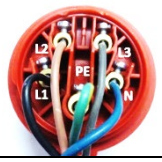
Deviation of the supply voltage and frequency!
A deviation from the value of the supply voltage of ±5 % is permissible.
A short-circuit fuse must be provided in the power supply system of the machine!

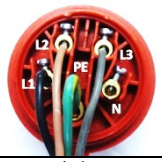
- Use a supply cable that fulfils the electrical requirements (e.g. H07RN, H05RN) and take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage.
- Make sure that the power supply is protected by a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

14.5.1 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).

Plug connection 400V:	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 at the phase inverter on the input box 400V.

NOTE

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

14.6 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.

15 OPERATION

15.1 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.

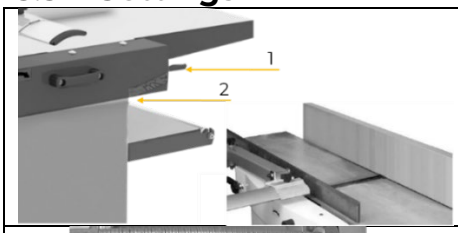
CAUTION

- 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!

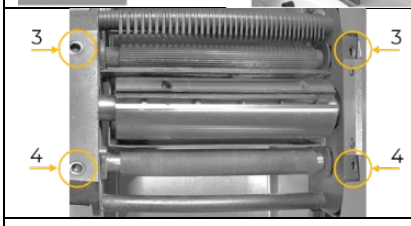
15.2 Initial check before start

- 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.

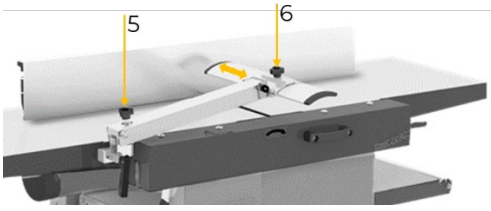
15.3 Settings



1. Height adjustment of the planing tables
Entry planer table
The cutting depth is set with the adjustment lever planer cutting depth (1)
Check scale knife entry planer table = 0
If necessary, adjust the arrow of the scale (2)

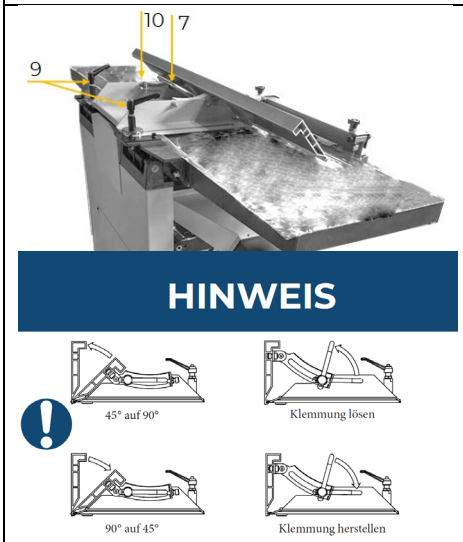


2. Setting infeed / oufeed roller
The pressure force of the spring-mounted infeed and outfeed roller is factory-set.
If it is necessary to change the pressure force, it can be adjusted with the screws (3 and 4).

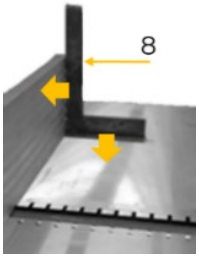


3. Setting arm and planer knife cover
Height
- Set the desired height with adjusting screw (5)

Planer knife cover
- Loosen the clamping screw (6)
- The planer knife cover can be moved and adapted to the size of the workpiece
- Relock the clamping screw (6) when the desired position is reached.



4. Setting planer fence
- Unlock the lock lever (7)
- Set planer fence to the desired angle position
- Relock the lock lever (7) when the desired position is reached
- Loosen the clamping levers (9)
- Adapt the planer fence to the workpiece width
- Relock the clamping levers

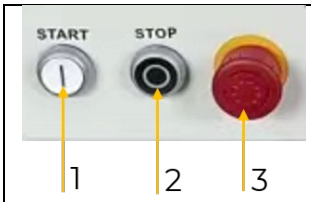


The alignment of the planer fence at right angles should be checked again before initial operation and readjusted if necessary to achieve an exact planing result.

- 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 of the scale (10) is necessary.

15.4 Operation

15.4.1 Switch the machine on and off



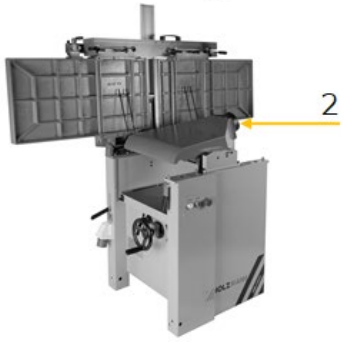
Switch on
Press the switch-on button (I).
Switch off
Press the switch-off (0) or in emergency situations the emergency-stop button (3)
CAUTION: The emergency stop button can only be unlocked after the emergency situation has been eliminated.

15.4.2 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.

15.5 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 colletor hood (2).

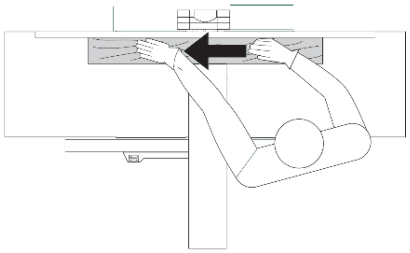
Do not operate the machine without the dust collection system connected to it and switched on.
The dimensions of the dust collection plug can be found in the technical data.

15.6 Planing

WARNING

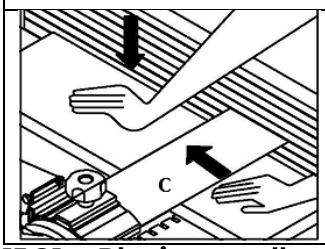
The unused part of the planing shaft for machining the workpiece must be covered by the covers (planer knife cover, guidance planer fence). Never touch the edges of the workpiece with your fingers, but always leave both hands on the workpiece with your fingers when planing. If the workpiece is short and narrow, use the sliding wood.

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



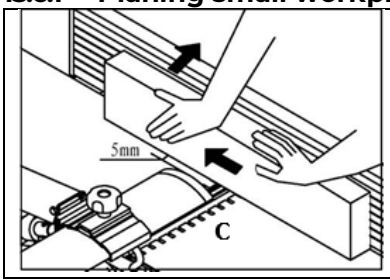
working direction

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



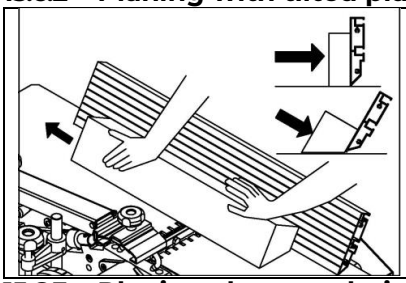
- Press the workpiece against the planer table with one hand.
- Push the workpiece slowly and evenly over the shaft with the second hand.
- After finishing the operation switch off the machine.
- Wait until the shaft has come to a standstill before proceeding with any further work!

15.6.1 Planing small workpieces



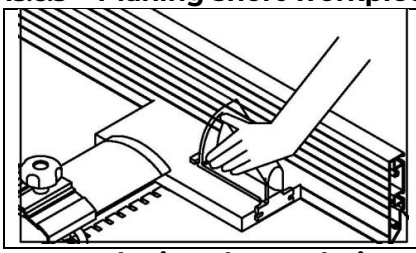
- Lower the planer knife cover (C) so that the planing shaft is covered.
- Move the planer knife cover to the workpiece and fix it with a distance of approx. 5mm.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.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

15.6.2 Planing with tilted planer fence



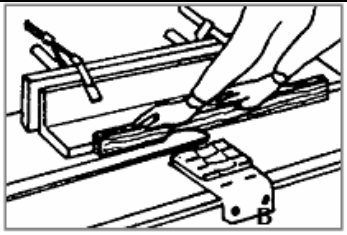
- Lower the planer knife cover so that the planing shaft is covered.
- Move the planer knife cover to the workpiece and fix it with a distance of approx. 5mm.
- When planing, place the workpiece with the small side on the planer table and press with one hand against the planer fence and planer table.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

15.6.3 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.

15.6.4 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.

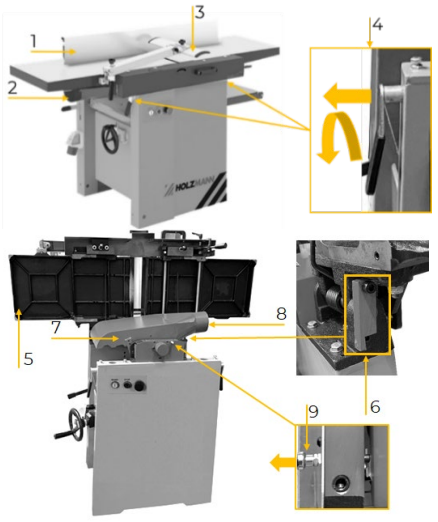
15.7 Thicknessing

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.

15.7.1 Converting from planer to thicknessing



- Slide the planer fence (1) and the planer knife cover (3) all the way to the back.
- Disassemble the hose of the dust collector plug (2).
- Unlock the fixation handles planer tables (4) of the planer tables. Therefore pull out and turn the handle
- Unfold the planer tables (5) completely and ensure that the lock (6) engages completely
- Turn down the dust collector hood (7).
- Mount hose to the dust collector plug (8).

Proceed in reverse order to readjust to the planer mode.

Lock dust collector hood:

- Pull out the lock pin (9) before turning back the dust collector hood

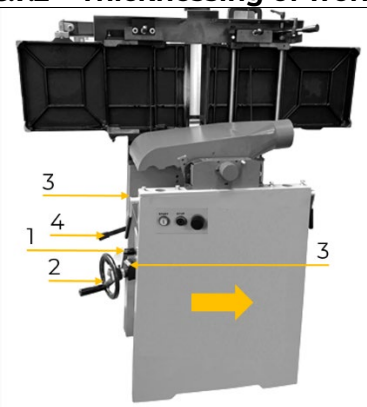
Lock planer tables:

- Lift the lock (6) on before closing the planer tables

NOTE

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

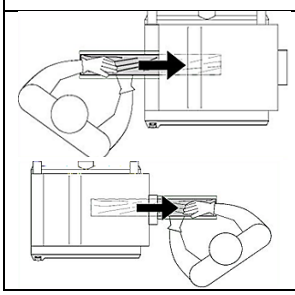
15.7.2 Thicknessing of workpieces



- 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) and counter block (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!

15.8 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

16 CLEANING, MAINTENANCE, STORAGE, DISPOSAL

WARNING

Danger due to electrical voltage!
Handling the machine with connected power supply may result in serious injury or death.
→ Always disconnect the machine from the power supply before maintenance or repair work and secure it against unintentional reconnection.

16.1 Cleaning

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

NOTE

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

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

16.2 Maintenance

The machine is low maintenance and only a few parts 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.

16.2.1 Maintenanceplan

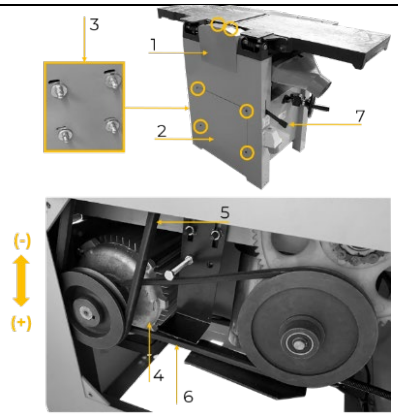
Wear of machine depends strongly on operation condition. The following intervals are valid when using the machine within the operation limits

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.

16.3 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.

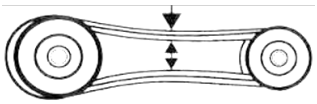
To check/adjust or replace the belt, remove the planer fence and the belt/chain covers (1, 2). Loosen the screws and remove the covers.



NOTE

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

max. 2-5mm



Increase drive-belt tension: Loosen nuts (3) and unscrew slightly. The motor (4) can now be shifted in the direction (+) of more belt tension. When correct tension is reached. Tighten the nuts (3) firmly again.	**Decrease drive-belttension:** Loosen nuts (3) and unscrew slightly. The motor (4) can now be shifted in the direction (-) of less belt tension. When correct tension is reached. Tighten the nuts (4) firmly again.
For changing the drive-belt, completely de-tension the belt (5), pull it over and insert new belt. Then establish correct belt tension again.	
For changing the feed-belt, pull over the drive-belt, completely de-tension the belt (6) (deactivate the feeding with handle for thicknesser feeder (7)) pull it over and insert new belt.	

After completion, remount the planer fence and the covers and fix it with the screws.

16.4 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).

16.5 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.

16.6 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.

16.7 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.

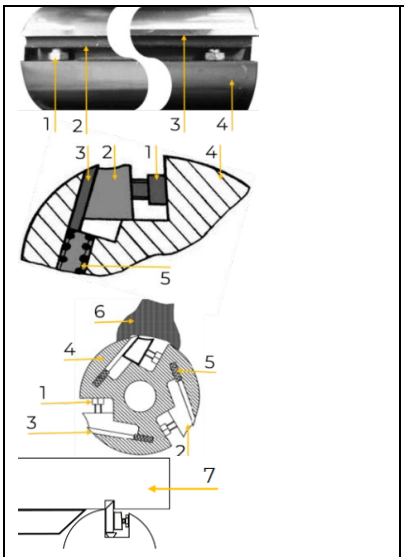
16.8 Replacing/adjusting the planing knife (HOB410ECO)

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: optional accessories: MEL2; 7: setting gauge of delivery content) on the planning shaft and adjust the correct height.
10. Tighten the gib screws (1) to fix the gib (2) (recommended minimium 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.

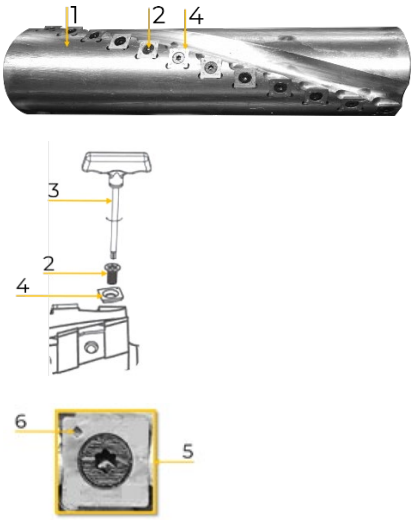
16.9 Replacing/turning the cutter insert (HOB410ECOSMW2)

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

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

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)

16.10 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!

16.11 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.

17 TROUBLESHOOTING

WARNING

Danger due to electrical voltage!
Handling the machine with connected power supply may result in serious injury or death.
→ Always disconnect the machine from the power supply before 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

33 ERSATZTEILE / SPARE PARTS / PIECES DE RECHANGE / NÁHRADNÍ DÍLY

33.1 Ersatzteilbestellung / spare parts order / Commande de pièces détachées / 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.

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

AVIS

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

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

- via notre page d'accueil – Catégorie SERVICE – DEMANDE DE PIECES DE RECHANGE,
- par e-mail à l'adresse service@holzmann-maschinen.at.

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

(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.

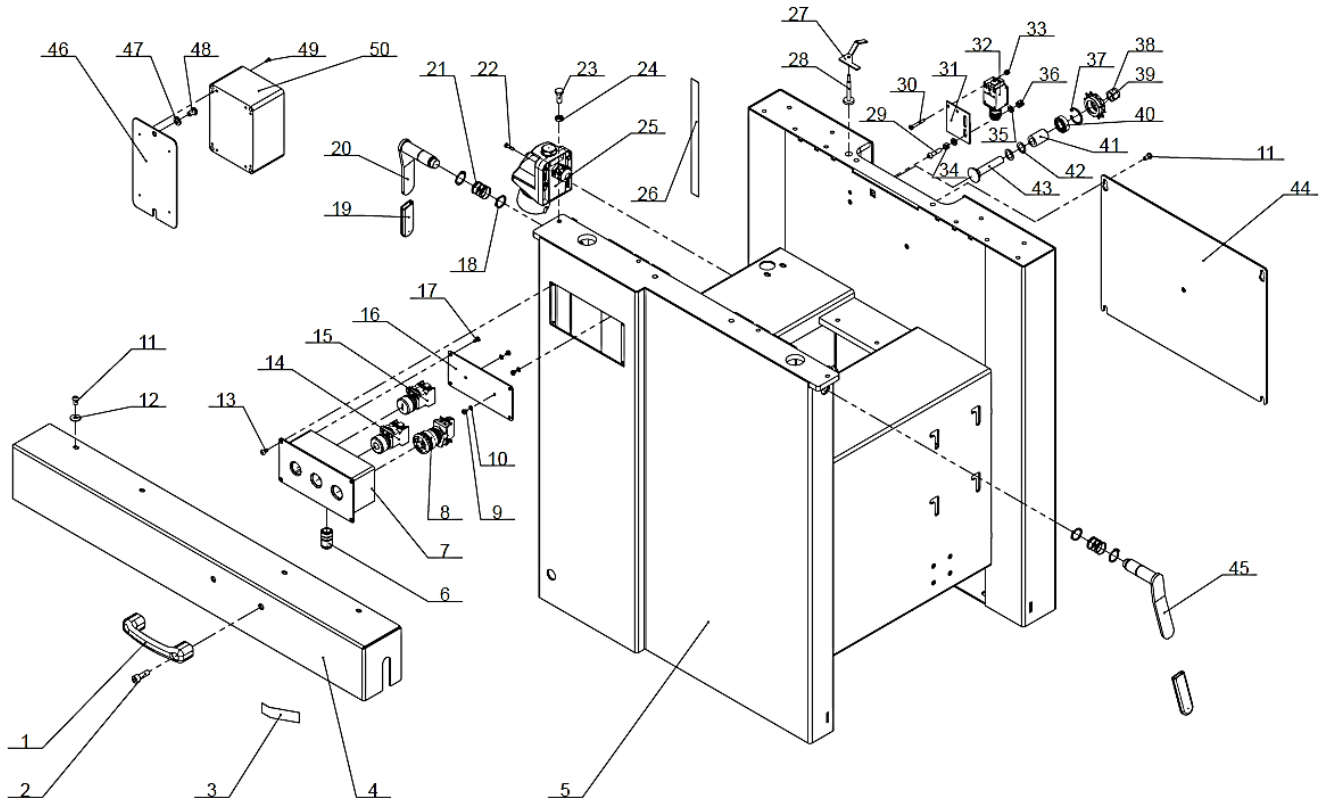
Náhradní díly objednávejte přímo na naší domovské stránce – kategorie NÁHRADNÍ DÍLY,
nebo kontaktuje náš zákaznický servis

- 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.

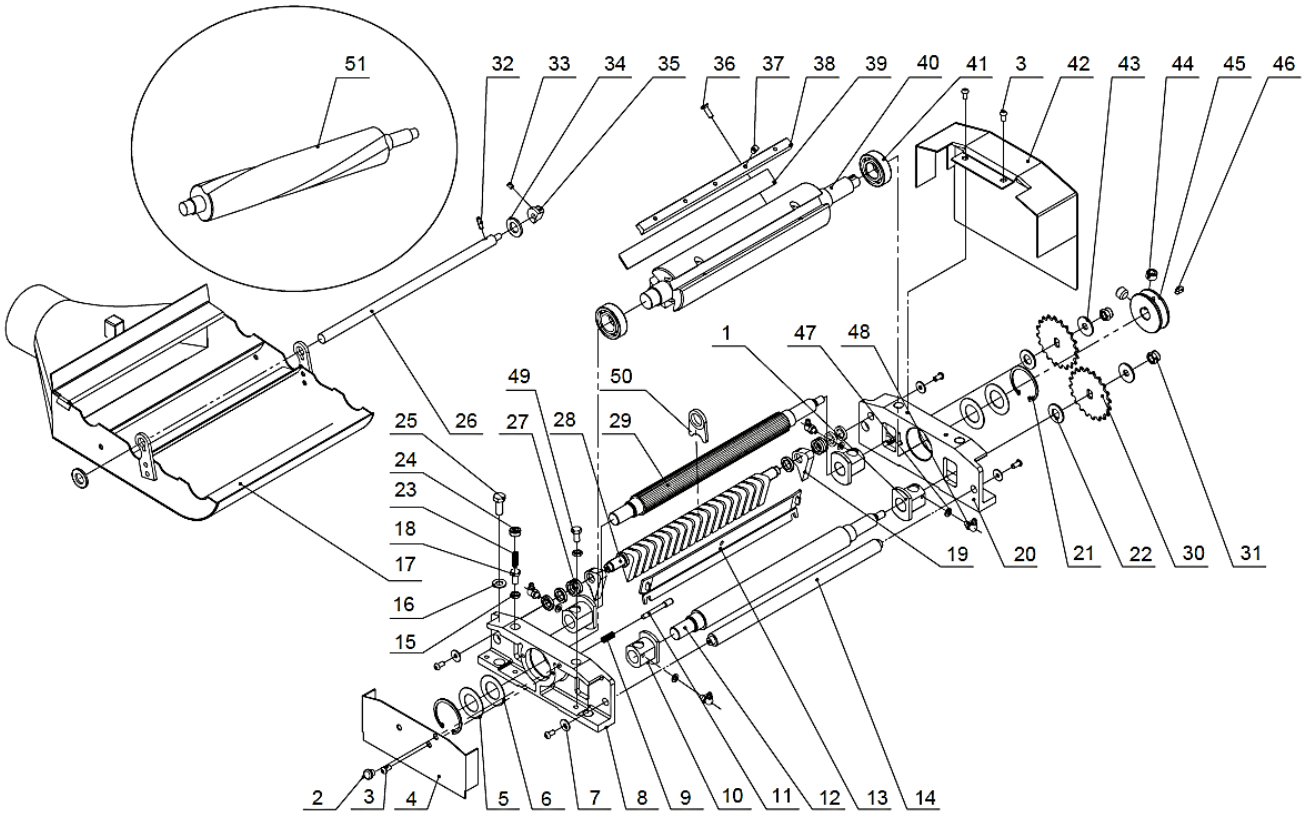
33.2 Explosionszeichnung / Exploded view / Vue éclatée / Výkres v rozloženém stavu

Frame assembly-SHEET A



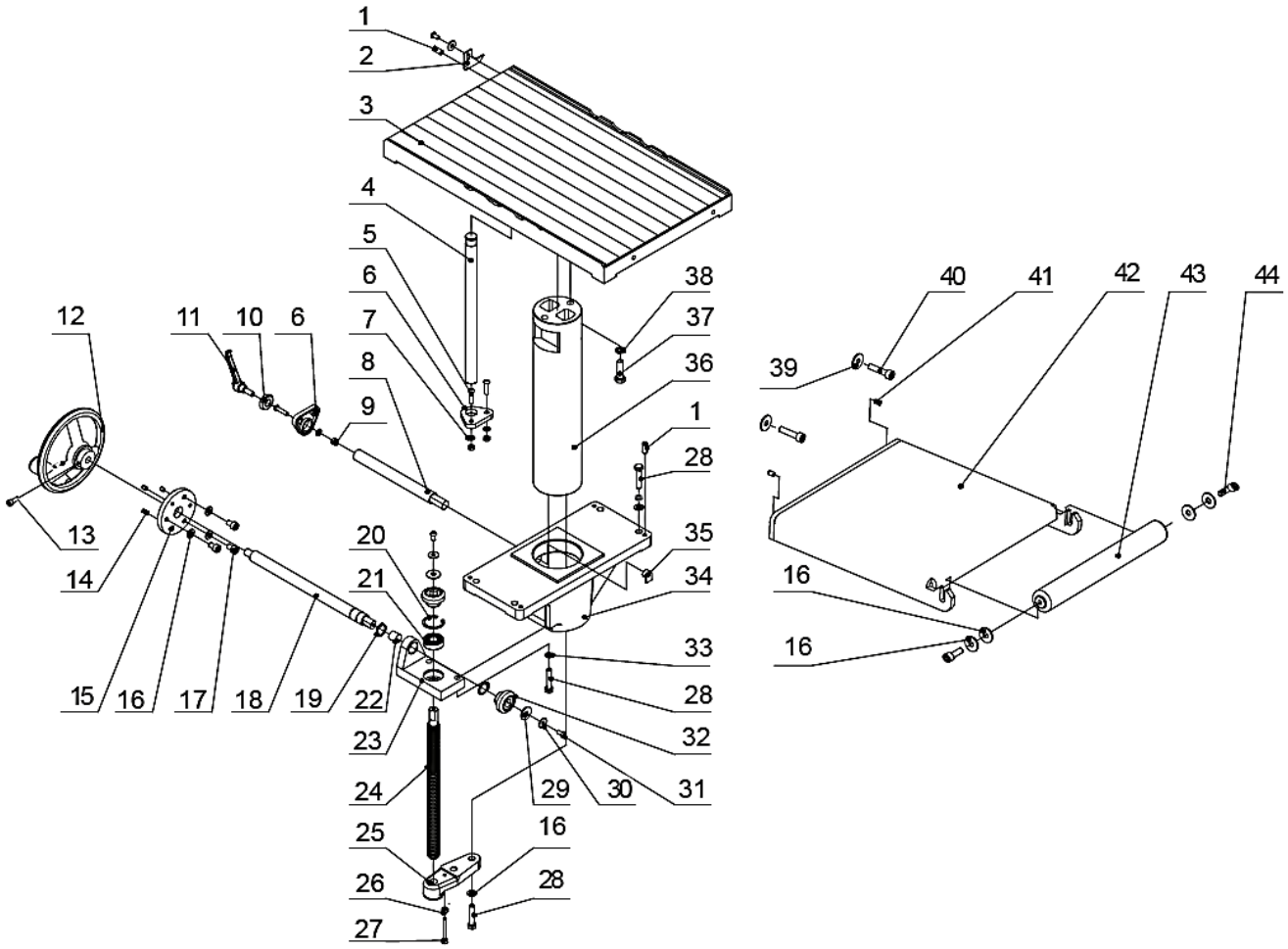
No.	Description	No.	Description
1	Handle	**26**	Scale
2	Hexagon screw	**27**	Press plate
3	Scale	**28**	Press rod
4	Left guard	**29**	Hexagon screw
5	Frame	**30**	Screw
6	No-pull off	**31**	Seat plate
7	Switch box	**32**	Safety switch
8	Emergency knob	**33**	Locking nut
9	Screw	**34**	Locking nut
10	Locking washer	**35**	Flat washer
11	Hexagon screw	**36**	Locking nut
12	Big washer	**37**	Retaining ring
13	Hexagon screw	**38**	Locking nut
14	Stop knob	**39**	Tension wheel
15	Start knob	**40**	Bearing
16	Switch box cover	**41**	Sleeve
17	Screw	**42**	Round washer
18	Retaining ring	**43**	Bolt
19	Handle sleeve	**44**	Window plate
20	Handle	**45**	Handle
21	Spring	**46**	Relay plate
22	Screw	**47**	Flat washer
23	Ball bolt	**48**	Hexagon screw
24	Hexagon nut	**49**	Screw
25	3 phase plug	**50**	Relay box

Tool carrier assembly-SHEET B



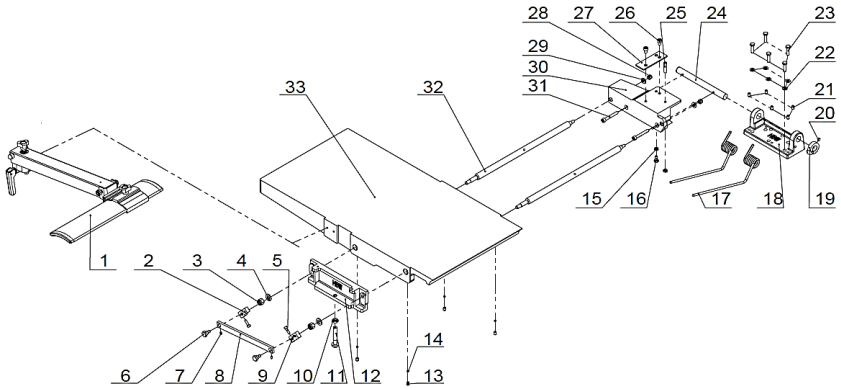
No.	Description	No.	Description
1	Left shaft sleeve	**27**	Spacer
2	Pin cover	**28**	Anti-back rod
3	Hexagon screw	**29**	Infeed roller
4	Protection guard	**30**	Big chain wheel
5	Spring washer	**31**	Hexagon locking nut
6	Round washer	**32**	Round pin
7	Big washer	**33**	Fixing screw
8	Left cutter bracket	**34**	Flat washer
9	Spring	**35**	Small wheel
10	Right shaft sleeve	**36**	Screw
11	Position pin	**37**	Square screw
12	Outfeed roller	**38**	Press block
13	Dust plate	**39**	Knife
14	Support rod	**40**	Cutterblock
15	Hexagon nut	**41**	Bearing
16	Big washer	**42**	Right guard
17	Dust collector	**43**	Big washer
18	Hexagon screw	**44**	Fixing screw
19	Anti-back block	**45**	Cutterblock wheel
20	Right cutter bracket	**46**	Flat key
21	Retaining ring	**47**	Thin nut
22	Washer	**48**	Oil mouth
23	Press spring	**49**	Hexagon screw
24	Screw	**50**	Spacer block
25	Hexagon screw	**51**	Spiral cutterhead
26	Rod		

Press planing machine assembly-SHEET C



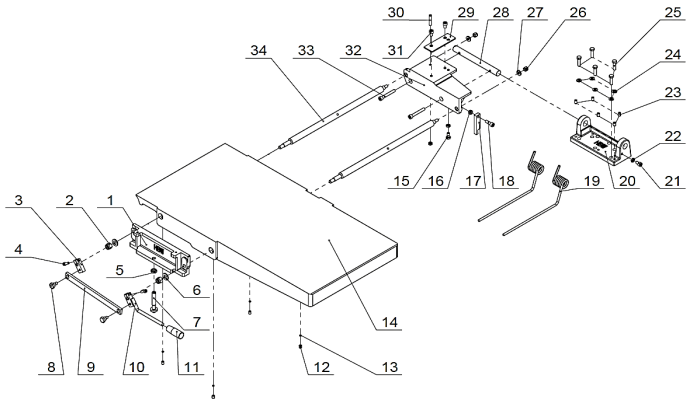
No.	Description	No.	Description
1	Fixing screw	**23**	Holder seat
2	Needle	**24**	Thread rod
3	Thicknesser table	**25**	Thread sleeve
4	Scale bar	**26**	Hexagon nut
5	Hexagon screw	**27**	Hexagon screw
6	Ring	**28**	Hexagon screw
7	Flat washer	**29**	Big washer
8	Locking rod	**30**	Big washer
9	Hexagon nut	**31**	Hexagon screw
10	Hexagon nut	**32**	Gear
11	Adjustable handle	**33**	Spring washer
12	Handwheel	**34**	Position sleeve
13	Fixing screw	**35**	Locking plate
14	Fixing screw	**36**	Lifting sleeve
15	Flange	**37**	Hexagon screw
16	Flat washer	**38**	Spring washer
17	Hexagon screw	**39**	Flat washer
18	Lifting shaft	**40**	Hexagon screw
19	Retaining ring	**41**	Fixing screw
20	Retaining ring	**42**	Extension table support
21	Bearing	**43**	Roller
22	Rolling shaft sleeve	**44**	Hexagon screw

Discharging platform assembly-SHEET D



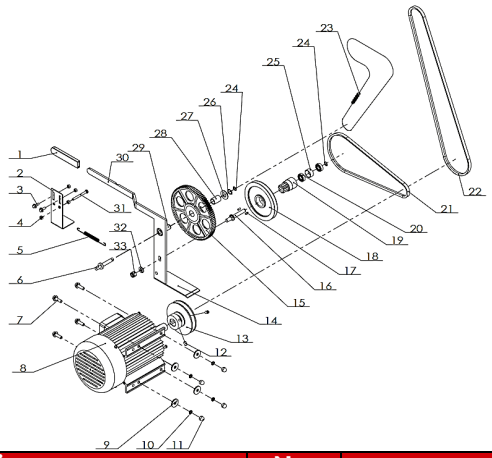
No.	Description	No.	Description
1	Cutterblock protection plate assy.	**18**	Support seat
2	Connection rod	**19**	Eccentric wheel
3	Locking nut	**20**	Fixing screw
4	Flat washer	**21**	Fixing screw
5	Hexagon screw	**22**	Flat washer
6	Shoulder screw	**23**	Hexagon screw
7	Fixing screw	**24**	Support rod
8	Connection rod	**25**	Fixing screw
9	Connection rod	**26**	Hexagon screw
10	Hexagon nut	**27**	Guide plate
11	Locking rod	**28**	Locking nut
12	Lifiting bracket	**29**	Washer
13	Fixing screw	**30**	Support bracket
14	Washer	**31**	Hexagon screw
15	Hexagon nut	**32**	Eccentric shaft
16	Hexagon screw	**33**	Planner table
17	Torsion spring		

Feed table assembly-SHEET E



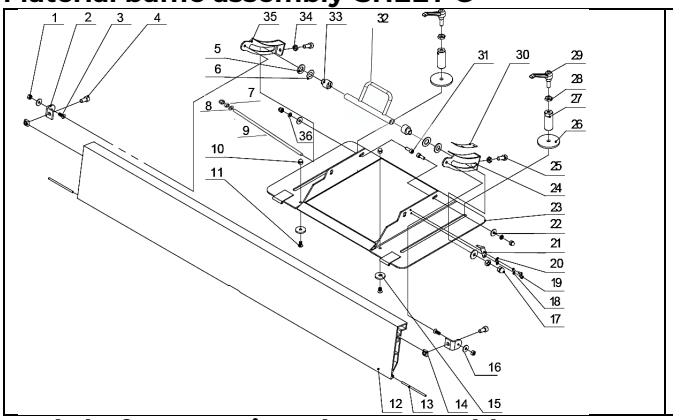
No.	Description	No.	Description
1	Front lifting	**18**	Hexagon screw
2	Locking nut	**19**	Torsion spring
3	Connection rod	**20**	Support seat
4	Hexagon screw	**21**	Hexagon screw
5	Hexagon nut	**22**	Thin nut
6	Flat washer	**23**	Fixing screw
7	Locking rod	**24**	Flat washer
8	Shoulder bolt	**25**	Hexagon screw
9	Connection rod	**26**	Locking nut
10	Handle	**27**	Washer
11	Handle	**28**	Support rod
12	Fixing screw	**29**	Guide plate
13	Washer	**30**	Fixing screw
14	Planner table	**31**	Hexagon screw
15	Hexagon screw	**32**	Holder bracket
16	Hexagon nut	**33**	Hexagon screw
17	Support block	**34**	Eccentric shaft

Drive system assembly-SHEET F



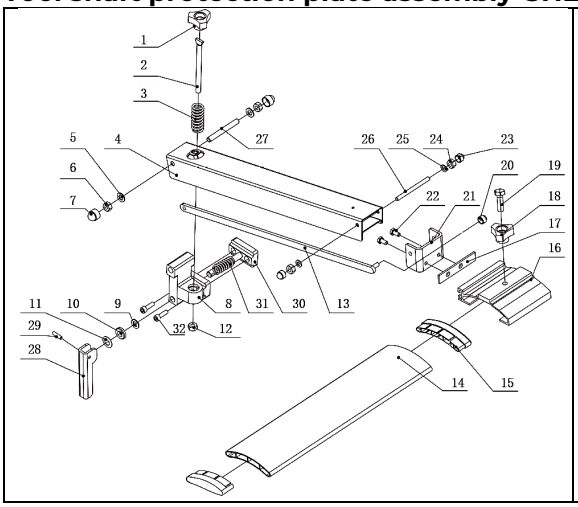
No.	Description	No.	Description
1	Handle sleeve	18	Gear wheel
2	Press plate	19	Small gear
3	Hexagon screw	20	Bearing
4	Hexagon nut	21	V-belt
5	Spring	22	V-belt
6	Turning shaft	23	Chain
7	Hexagon screw	24	Retaining ring
8	Motor	25	Spacer
9	Extra washer	26	Retaining ring
10	Spring washer	27	Washer
11	Nut	28	Chain wheel sleeve
12	Fixing screw	29	Chain shaft
13	Motor pulley	30	Handle
14	Holder plate	31	Hexagon bolt
15	Gear	32	Flat washer
16	Pulley shaft	33	Locking nut
17	Fixing screw		

Material baffle assembly-SHEET G



No.	Description	No.	Description
1	Locking nut	19	Hexagon nut
2	Support seat	20	Flat washer
3	Screw	21	Needle
4	Screw	22	Flat washer
5	Flat washer	23	Fence bracket
6	Spring washer	24	Left support arm
7	Hexagon nut	25	Hexagon nut
8	Flat washer	26	Round washer
9	Thread rod	27	Locking column
10	Cap nut	28	Hexagon nut
11	Screw	29	Adjustable handle
12	Rip fence	30	Angle ruler
13	Long pin	31	Hexagon nut
14	Square nut	32	Locking tube
15	Thick washer	33	Locking sleeve
16	Big washer	34	Hexagon nut
17	Cap nut	35	Right support arm
18	Spring washer	36	Hexagon nut

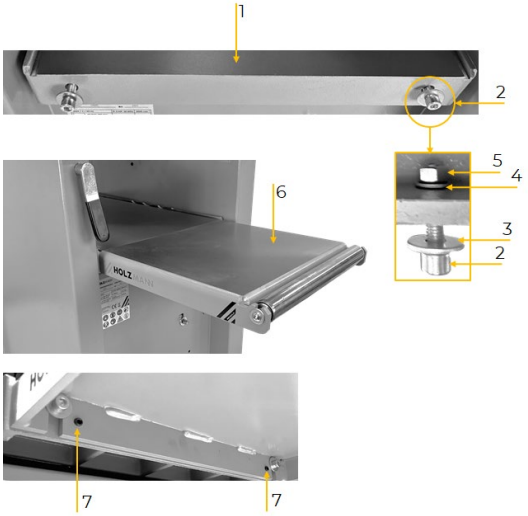
Tool shaft protection plate assembly-SHEET H



No.	Description	No.	Description
1	Knob handle	17	Fixation plate
2	Thread rod	18	Knob handle
3	Spring	19	Nylon bolt
4	Support arm	20	Locking nut
5	Flat washer	21	Sliding sleeve support
6	Locking nut	22	Hex head bolt
7	Nut cover	23	Nut cover
8	Locking support body	24	Hex lock nut
9	Flat washer	25	Nylon washer
10	Thick washer	26	Screw head shaft
11	Spring washer	27	Screw head shaft
12	Hexagon nut	28	Locking handle
13	Long rod	29	Pin
14	Cutterhead guard	30	Locking support
15	End cover	31	Locking spring
16	Sliding sleeve	32	Hexagon screw

34 ZUBEHÖR / ACCESSORIES / ACCESSOIRES / PŘÍSLUŠENSTVÍ

34.1 HOB410ECO-ET



Montage:
- Schrauben (2) wie abgebildet am Dickenhobeltisch montieren
  (große Scheibe (3) außen, kleine Scheibe (4) und Mutter (5) innen)
- Erweiterungstisch (6) einhängen und mit Schrauben und Mutter fixieren (noch nicht ganz anziehen!)
- Mit Wurmschrauben (7) die Höhe nivellieren
- Schrauben und Muttern fest anziehen

Assembly:
- Mount the screws (2) on the thicknessing table as shown
  (large washer (3) on the outside, small washer (4) and nut (5) on the inside)
- Attach the extension table (6) and secure with screws and nut (do not tighten completely!)
- Level the height with worm screws (7)
- Tighten the screws and nuts

Montage :
- Monter les vis (2) comme illustré sur le rabot d'usinage en épaisseur
  (grande rondelle (3) extérieure, petite rondelle (4) intérieure et écrou (5) intérieur)
- Accrocher la table d'extension (6) et la fixer avec des vis et des écrous (ne pas serrer à fond !)
- Régler la hauteur avec des goujons filetés (7)
- Serrer les vis et les écrous à fond

Montáž:
- Namontujte šrouby (2) na tloušťkovací stůl podle obrázku
  (velká podložka (3) vně, malá podložka (4) a matice (5) uvnitř)
- Rozšiřovací stůl (6) zavěste a upevněte šrouby a maticemi (ještě zcela nedotahujte!)
- Proveďte nivelaci výšky pomocí stavěcích šroubů se zářezem (7)
- Šrouby a matice pevně dotáhněte

(DE) Optionales Zubehör finden Sie online auf der Produktseite, Kategorie EMPFOHLENES ZUBEHÖR ZUM PRODUKT.
(EN) Optional accessories can be found online on the product page, category RECOMMENDED PRODUCT ACCESSORIES.
(FR) Des accessoires en option sont disponibles en ligne sur la page produit, catégorie ACCESSOIRES RECOMMANDÉS POUR LE PRODUIT.
(CZ) Volitelné příslušenství najdete na internetu na stránce výrobku, kategorie DOPORUČENÉ PŘÍSLUŠENSTVÍ K VÝROBKU.