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Originalfassung

DE BETRIEBSANLEITUNG **VERBINDUNGSFRÄSE**

Übersetzung / Translation

EN USER MANUAL **BISCUIT JOINTER**

IT ISTRUZIONI PER L'USO **FRESA ORIZZONTALE LAMELLARE**

CZ NÁVOD K OBSLUZE **LAMELOVACÍ FRÉZKA**

PJ 100PRO

Edition: 03.07.2017 – Revision - 00 – CEC - DE/EN/IT/CZ

8 PREFACE (EN)

Dear Customer!

This manual contains information and important instructions for the installation and correct use of the biscuit jointer PJ 100PRO.
Following the usual commercial name of the machine (see cover) is substituted in this manual with the name "machine".
This manual is part of the product and shall not be stored separately from the product. Save it for later reference and if you let other people use the product, add this instruction manual to the product.

Please read and obey the security instructions!
Before first use read this manual carefully. It eases the correct use of the product and prevents misunderstanding and damages of product and the user's health.

Due to constant advancements in product design, construction pictures and content may diverse slightly. However, if you discover any errors, inform us please.
Technical specifications are subject to changes!

Please check the product contents immediately after receipt for any eventual transport damage or missing parts.

Claims from transport damage or missing parts must be placed immediately after initial product receipt and unpacking before putting the product into operation.

Please understand that later claims cannot be accepted anymore.

Copyright

Customer service contact

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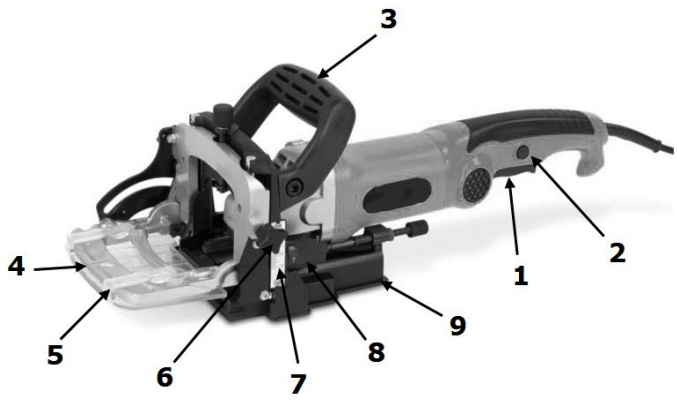
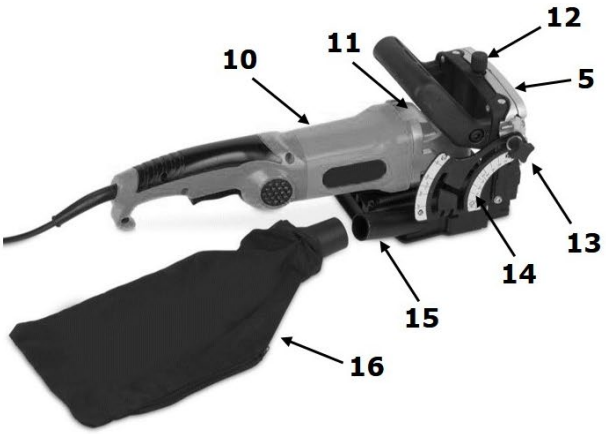
9 TECHNIC

9.1 Components





PJ100PRO			
1	ON-OFF-switch	**9**	Base plate
2	Lock-off button	**10**	Housing
3	Handle	**11**	Spindle lock
4	Angle stop	**12**	Knob height adjustment
5	Plate protection	**13**	Lock knob angle adjustment
6	Lock knob height adjustment	**14**	Angle scale
7	Scale height adjustment	**15**	Dust collector plug
8	Cutting depth adjustment	**16**	Dust bag

9.2 Technical details

PJ100PRO	
Voltage	230 V / 50 Hz
Power	900 W
No-load speed	10800 min^{-1}
Blade diameter	Ø 100mm
Blade bore diameter	Ø 22mm
Max. cutting depth	19 mm
Angle range	-45° - +90°
Spindle dimension	M10
Weight	3,3 kg
Protection class	II
Protection mode	IP 20
Sound pressure level L_{PA}	89 dB(A) k: 3 dB(A)
Sound power level L_{WA}	100 dB(A) k: 3 dB(A)

10 SAFETY

10.1 Intended Use

The machine must only be used for its intended purpose! Any other use is deemed to be a case of misuse.

To use the machine properly you must also observe and follow all safety regulations, the assembly instructions, operating and maintenance instructions lay down in this manual.

All people who use and service the machine have to be acquainted with this manual and must be informed about the machine's potential hazards.

It is also imperative to observe the accident prevention regulations in force in your area.

The same applies for the general rules of occupational health and safety.

The machine is used for:

Culling grooves for biscuit dowel joints in solid wood, plywood, chipboard, plastic boards.

Work on the different materials with suitable blades only

This machine is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the machine by a person responsible for their safety. Never allow children or people unfamiliar with these instructions to use the machine. Supervise children. This will ensure that children do not play with the unit.

Any manipulation of the machine or its parts is a misuse, in this case HOLZMANN-MASCHINEN and its sales partners cannot be made liable for ANY direct or indirect damage.

WARNING

- **Use only blades allowable for this machine!**
- **Never use a damaged blade!**

HIGHEST RISK OF INJURY!

Ambient conditions

The machine may be operated:

humidity	max. 70%
temperature	+5°C to +40°C (+41°F to +104°F)

The machine shall not be operated outdoors or in wet or damp areas.

The machine shall not be operated in areas exposed to increased fire or explosion hazard.

Prohibited use

- The operation of the machine outside the stated technical limits described in this manual is forbidden.
- The operation of the machine without provided protective devices is prohibited.
- The use of the machine not according with the required dimensions is forbidden.
- The use of the machine not being suitable for the use of the machine and not being certified is forbidden.
- Any manipulation of the machine and parts is forbidden.
- The use of the machine for any purposes other than described in this user-manual is forbidden.
- The unattended operation on the machine during the working process is forbidden!
- It is not allowed to leave the immediate work area during the work is being performed.

10.2 Safety instructions

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

The locally applicable laws and regulations may specify the minimum age of the operator and limit the use of this machine!

To avoid malfunction, machine defects and injuries, read the following security instructions!

Work area safety:

- Keep work area clean and well lit. Cluttered and dark areas invite accidents.
- Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
- Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.

Electrical safety:

- Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
- Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
- Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges and moving parts. Damaged or entangled cords increase the risk of electric shock.
- When operating a power tool outdoors, use an extension cord suitable for outdoor use. Use of a cord suitable for outdoor use reduces the risk of electric shock.

Personal safety:

- Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
- Use personal protective equipment. Always wear eye protection. Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool. Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- Remove any adjusting key or wrench before turning the power tool on. A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- If devices are provided for the connection of dust collectors and collection facilities, ensure these are connected and properly used. Use of dust collection can reduce dust-related hazards.

Power tool use and care:

- Do not overload the machine. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.
- Do not use the power tool if the switch does not turn it on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools. Such preventive safety measures reduce the risk of starting the power tool accidentally.

- Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Power tools are dangerous in the hands of untrained users.
- Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.
- Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.

Additional safety instructions:

- Sawdust and splinters must not be removed while the machine is running.
- Do not use cutting discs or circular saw blades in the machine.
- Protect blades against shocks and impacts
- Only use properly sharpened blades, otherwise increased culling forces will shatter the work piece.
- Before use, inspect the blade for any damage. Do not use blades that are cracked, ripped or otherwise damaged
- Make sure that the work piece is sufficiently supported or clamped. Keep your hands away from the surface to be cut
- Use the machine only with the auxiliary handle.
- When blades have to be mounted on the thread of the spindle, make sure that the spindle has sufficient thread
- Make sure that the blade has been mounted and fastened properly. Do not use reducing rings or adapters to make the blade fit properly.
- Apply the machine to the work piece only when the machine is switched on.
- When working with the machine always hold the machine firmly with both hands and provide for secure distance.
- Always wear safety goggles and hearing protection. If desired or required also use another protection for example an apron or helmet
- Always disconnect the plug from the socket before carrying out any work on the machine, only plug in when the machine is switched off
- Keep mains lead clear from working range of the machine. Always lead the cable away behind you.
- The base plate must not be clamped down while the blade is extended. Lowering and raising the blade must be a smooth operation.

11 OPERATION

Please check the product contents immediately after receipt for any eventual transport damage or missing parts. Claims from transport damage or missing parts must be placed immediately after initial machine receipt and unpacking before putting the machine into operation. Please understand that later claims cannot be accepted anymore.

11.1 Assembly

WARNING

Perform all machine settings with the machine being disconnected from the power supply!

NOTICE

Wear safety gloves when working on the blades!

11.1.1 Blade

- Loosen your screws and open the top of the base plate
- Press the spindle lock (11) and turn the spindle until it engages in the lock. Keep the spindle lock pressed during this procedure.
- Remove the flange nut from the spindle using the wrench.
- Position the saw blade and the flange.
- Place the flange nut from the spindle and tighten it with the wrench.
- Take care that the flange nut will be placed with the correct side on the spindle.
- Release the spindle lock and check that the spindle is unlocked by rotating it.
- Close the top of the base plate and fasten four screws.
- Make sure that the top of the base plate is securely closed before operating the machine.

11.1.2 Dust bag

- If you do not use a dust collector, insert the dust bag into the dust collector plug.
- Empty the dust bag regularly so that the vacuuming performance remains intact.

11.1.3 Plate protection

- The plate protection needs to be attached to the angle stop prior to use.
- For easier assembly, set the angle stop into the 90° position. Slide the plate protection onto the angle stop with the plastic locating arms positioned over the top, and the plastic face being located underneath.

11.2 Operation

Machine to be operated in a perfect state only. Inspect the device visually every time it is to be used. Check in particular the safety equipment, electrical controls, electric cables and screwed connection for damage and if tightened properly. Replace any damaged parts before operating the device.

11.3 Adjustments

11.3.1 Cutting depth

- Move the motor base plate (9) as far as possible backwards.
- Set the cutting depth by luring the cutting depth adjustment (8). The knob is marked “0”, “2”, “4”, “5”, “7”, “12” and “19” according to the sizes of dowels.
- Move the motor base forwards and check if the pin will fall in the notch of the cutting depth adjustment (8).

Checking the cutting depth:

- Always check the cutting depth after mounting a blade.
- Move the motor base (9) as far as possible backwards
- Set the cutting depth in the maximum position by turning the depth adjustment (8).
- Move the motor base forwards till the pin will fall in the notch of the depth adjustment (8)
- Turn the blade till one tooth of the blade is in the front position.
- Measure the distance from the side of the base plate to the tooth of the saw blade
- Check if the distance is 19mm

Setting the cutting depth:

- Move the motor base (9) as far as possible backwards.
- Loosen the pin
- Set the cutting depth by turning the screw, the screw is positioned at the back of the pin.
- Repeat the procedure till the cutting depth is correct.
- Fasten the Pin.

11.3.2 Cutting angle

- The cutting angle can be set by unlocking the lock knob angle adjustment (13) and put the angle stop (4) in the required angle.

11.3.3 Height

- The correct height can be set by unlocking the lock knob height adjustment (8) and turning the knob for the height adjustment (12) to the desired height with aid of the scale height adjustment (7)
- The height must corresponds to half of the material thickness of the work piece, the groove lot the biscuit dowel must always be in the middle of the working piece.

11.4 Operating

11.4.1 Switching on / off

- Never use the spindle lock during starting or when the machine is working.
- To switch the machine on push the lock-off button and the ON-OFF switch at the same time.
- To switch the machine off, release the ON-OFF switch.

11.4.2 Marking the workpieces

Before starting with the biscuit jointer the work pieces must be marked as following:
- Place the two work pieces which must be connected, on top of each other.
- Fasten the work pieces and mark the center of the groove.

The space between two grooves should be 10-15cm. This is not applicable for smaller workpieces. Smaller work pieces don't have to be marked

11.4.3 Positioning of the machine

Based on the size of the work pieces the machine can be positioned in several ways.

11.4.4 Large workpieces:

- Place the machine near the work piece
- The middle of the base plate (this point is marked on the base plate) must face the center of the groove in the work piece, {see marking the work piece).

11.4.5 Small workpieces.

- Place the machine near the work piece
- The side of the machine must be lacing the side of the work piece.

11.4.6 Sawing grooves

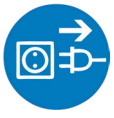
- Move the motor base backward.
- Place the machine near the work piece.
- Position the machine (see positioning of the machine)
- Hold the machine with both hands and switch the machine on.
- Push the motor base carefully forward as far as possible.
- Move the motor base backward and switch the machine off.

11.4.7 Joining the workpieces

When the grooves in both work pieces have been made the workplaces can be joined together
- Put glue in both grooves.
- Race the biscuit dowel in the groove of one work piece.
- Place the other work piece on the biscuit dowel.
- Fasten the work pieces and wait till the glue is dry.

12 MAINTENANCE

ATTENTION



Perform all maintenance machine settings with the machine being disconnected from the power supply!

Serious injury due to unintentional or automatic activation of the machine!

The machine does not require extensive maintenance. If malfunctions and defects occur, let it be serviced by trained persons only.

NOTICE

Clean your machine regularly after every usage – it prolongs the machines lifespan and is a pre-requisite for a safe working environment.

Repair jobs shall be performed by respectively trained professionals only!

Check regularly the condition of the security stickers. Replace them if required.

Check regularly the condition of the machine!

12.1 Cleaning

Once a month the machine and all its parts must be thoroughly cleaned.

NOTICE

The usage of certain solutions containing ingredients damaging metal surfaces as well as the use of scrubbing agents will damage the machine surface!

Never use running water or a high pressure cleaner to clean the machine.

- After each use, clean the machine using a dry cloth or a brush if the machine is very dirty.
- Keep the ventilation slits clean and dustfree.

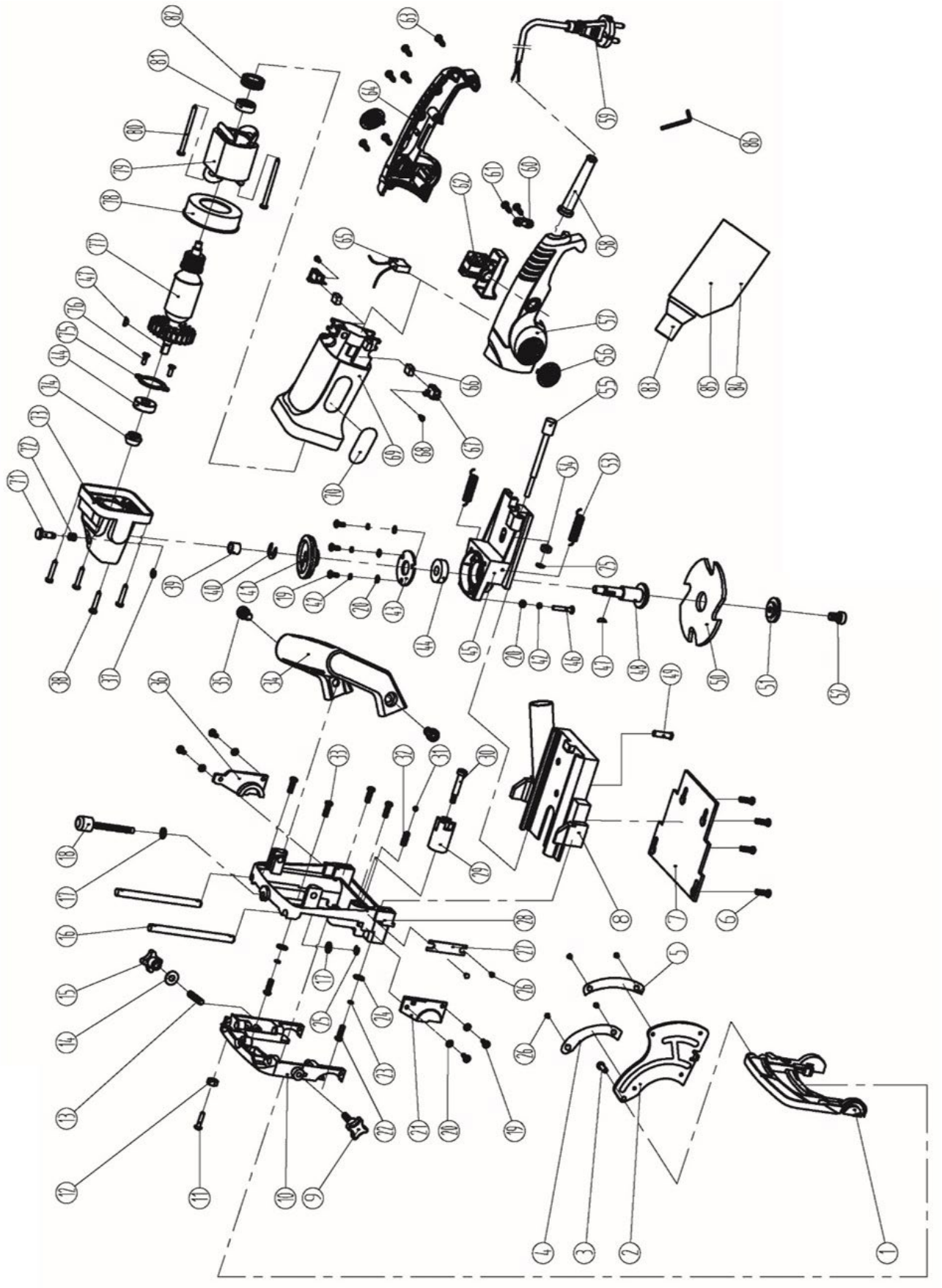
12.2 Storage

- Thoroughly clean the whole machine and its accessories.
- Store it out of the reach of children, in a stable and secure position, in a cool and dry place, avoid too high and too low temperatures.
- Protect it from exposure to direct sunlight. Keep it in the dark, if possible.
- Don’t keep it in plastic bags to avoid humidity build-up.

12.3 Disposal

Do not dispose the machine in residual waste. Contact your local authorities for information regarding the available disposal options. When you buy at your local dealer for a replacement unit, the latter is obliged to exchange your old.

24.2 Explosionszeichnung / explosion drawing / Disegno esploso / Rozpadový výkres



No.	Part name	Qty	No.	Part name	Qty
1	Rotational plate	1	**44**	Bearing 6000-2Z	2
2	Scale board	1	**45**	Fore cover	1
3	pin	1	**46**	Screw M4X18	4
4	Ruler(1)	1	**47**	Woodruff key 2.9X10	2
5	Ruler(2)	1	**48**	Spindle	1
6	Base plate screw	4	**49**	Pin screw(limit)	1
7	Base plate	1	**50**	Saw（Φ100X4XΦ22）	1
8	Base	1	**51**	Saw cover	1
9	Knob screw	1	**52**	Hex screw M6X16	1
10	Moving board	1	**53**	Spring	2
11	Screw M4X22	1	**54**	Hex nuts M6	1
12	Hex nut M4	1	**55**	Limit screw	1
13	Locking screw	1	**56**	Vent cover	2
14	Plain washer 6（Φ16XΦ7.5X1.2）	1	**57**	Left handle	1
15	Nut of handle	1	**58**	Cable sheath	1
16	Guide pole	2	**59**	Cable	1
17	Plain washer 6（Φ12XΦ6X1.0）	2	**60**	Cable fixer	1
18	Regulate screw	1	**61**	Screw ST4.2X14	2
19	Screw M4X10	7	**62**	Switch	1
20	Plain washer 4	11	**63**	Screw ST4.2X16	6
21	Orientation board(right)	1	**64**	Right handle	1
22	Screw M5X22	2	**65**	Two feet capacitanc 0.33μF	1
23	Spring washer 5	2	**66**	Carbon brush	2
24	Plain washer 5	2	**67**	Brush holder	2
25	Circlip for shaft 4	2	**68**	Screw ST2.9X8	2
26	Screw M3X3.5	6	**69**	House	1
27	Scale	1	**70**	Trade mark	1
28	Anxious rack	1	**71**	Self-locking pin	1
29	Limit column	1	**72**	Self-locking spring	1
30	Screw	1	**73**	Gear box	1
31	Steel ball SΦ5	1	**74**	Pinion	1
32	Spring(limit)	1	**75**	Bearing cover of gear box	1
33	Tapping screw M4X18	4	**76**	Screw M4X10	2
34	Assistant handle	1	**77**	Rotor	1
35	Hex screw M8X12	2	**78**	Wind baffce	1
36	Orientation board(left)	1	**79**	Stator	1
37	Circlip for shaft 5	1	**80**	Screw ST4.2X70	2
38	Screw ST4.2X22	4	**81**	Bearing 627-2Z	2
39	Oil bearing（Φ12XΦ8X10）	1	**82**	608 Bearing bushing	1
40	Circlip for shaft 9	1	**83**	Dust tube	1
41	Big gear	1	**84**	Wire bracket	1
42	Spring washer 4	7	**85**	Dust bag	1
43	Bearing cover of fore cover	1	**86**	Allen key	1