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Originalfassung

**DE BETRIEBSANLEITUNG**

Übersetzung / Translation

**EN USER MANUAL**

**FR MODE D'EMPLOI**

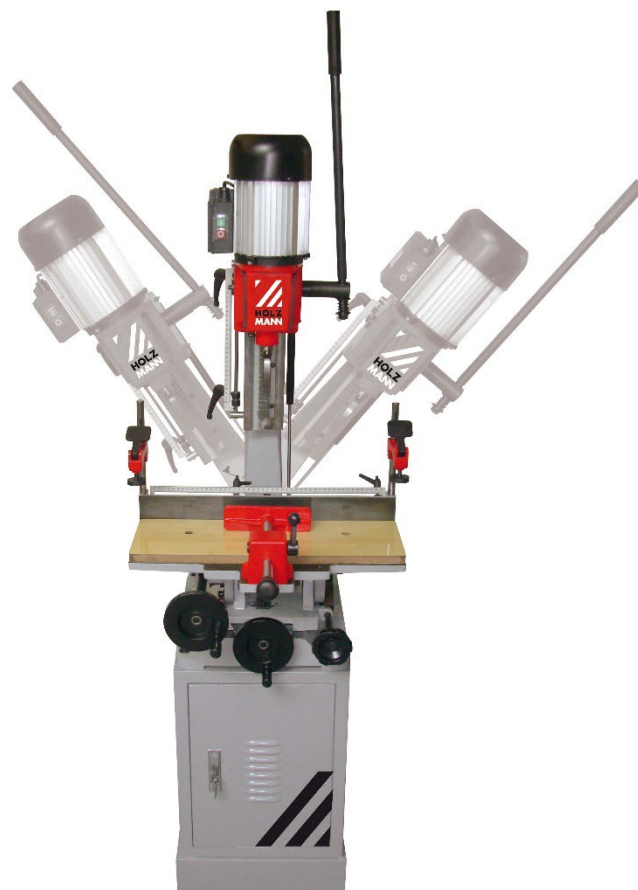
**ES INSTRUCCIONES DE SERVICIO**

**BOHR - STEMM - MASCHINE**

**BORING - MORTISE - MACHINE**

**PERCEUSE À COLONNE - MORTAISEUSE**

**TALADRADORA-ESCOPLEADORA**



**STM26**

**STM26S**



**YOUR  
JOB.  
OUR  
TOOLS.**



## 2 SICHERHEITSZEICHEN / SAFETY SIGNS / SYMBOLES DE SÉCURITÉ / SEÑALES DE SEGURIDAD

|           |                                                     |           |                                       |           |                                                    |
|-----------|-----------------------------------------------------|-----------|---------------------------------------|-----------|----------------------------------------------------|
| <b>DE</b> | SICHERHEITSZEICHEN<br>BEDEUTUNG DER SYMBOLE         | <b>EN</b> | SAFETY SIGNS<br>DEFINITION OF SYMBOLS | <b>FR</b> | SYMBOLES DE SÉCURITÉ<br>SIGNIFICATION DES SYMBOLES |
| <b>ES</b> | SEÑALES DE SEGURIDAD<br>SIGNIFICADO DE LOS SÍMBOLOS |           |                                       |           |                                                    |



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

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

**FR CONFORMITÉ CE :** Ce produit répond aux directives CE.

**ES CONFORMIDAD CE:** Este producto cumple con las directivas de la UE.



**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.

**ES Lea atentamente las instrucciones de servicio y de mantenimiento de su máquina y familiarícese con los elementos de mando de la misma para manejarla correctamente y, de este modo, evitar que se produzcan daños personales y en la máquina.**



**DE** Schutzausrüstung tragen!

**EN** Wear protective equipment!

**FR** Porter un équipement de protection !

**ES** ¡Use el equipo de protección!



**DE** Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

**EN** Stop and pull out the power plug before any break and engine maintenance!

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

**ES** ¡Pare la máquina y desconéctela de la red eléctrica antes de llevar a cabo trabajos de mantenimiento y antes de las pausas!



**DE** Warnung vor Quetschverletzungen!

**EN** Warning of crush injuries!

**FR** Avertissement contre les blessures par écrasement !

**ES** ¡Advertencia de sufrir lesiones producidas por aplastamiento!



**DE** Warnung vor gefährlicher elektrischer Spannung!

**EN** Beware of dangerous electrical voltage!

**FR** Avertissement de tension électrique dangereuse !

**ES** ¡Advertencia de tensiones eléctricas peligrosas!



**DE** Bedienen mit Handschuhen verboten!

**EN** Operation with gloves forbidden!

**FR** Utilisation avec des gants défendue !

**ES** ¡Prohibido el manejo con guantes!

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

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

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

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



### 3 TECHNIK / TECHNICS / TECHNIQUE / TÉCNICA

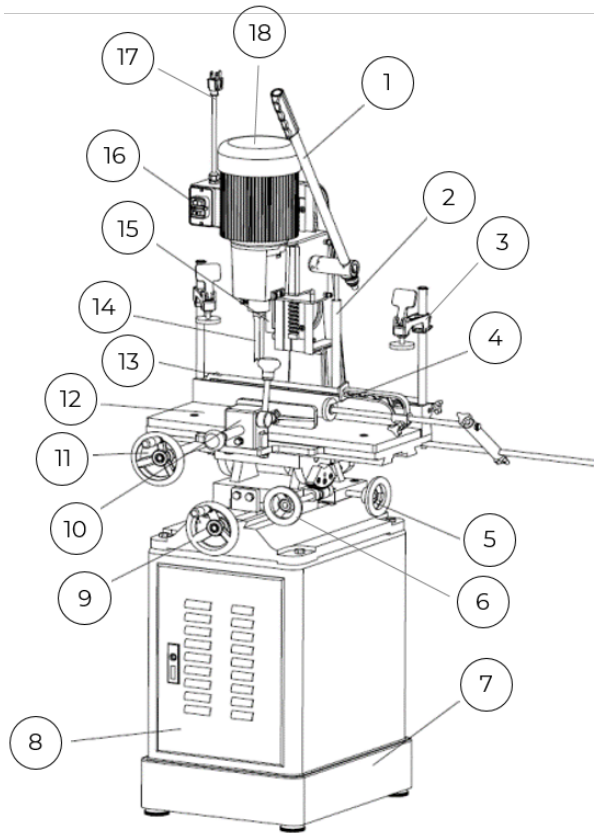
#### 3.1 Lieferumfang / Delivery content / Contenu de la livraison / Volumen de suministro



| #  | Beschreibung / Description / Description / Descripción                                                                                                                                                                                          | Qty. |
|----|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|
| 1  | Maschine / machine / Machine / Máquina                                                                                                                                                                                                          | 1    |
| 2  | Untergestell / machine stand / Support / Bastidor                                                                                                                                                                                               | 1    |
| 3  | Maschinenfüße / machine feet / Pieds de la machine / Pies de la máquina                                                                                                                                                                         | 4    |
| 4  | Schlüssel / key / Clé / Llave                                                                                                                                                                                                                   | 2    |
| 5  | Werkstückanschlag / workpiece stop / Butée de pièce / Tope de pieza de trabajo                                                                                                                                                                  | 1    |
| 6  | Stemmbohrer 16mm / mortise drill 16mm / Foret à mortaiser 16 mm / Broca escoplo 16 mm                                                                                                                                                           | 1    |
| 7  | Bedienhebel / operating lever / Manette de commande / Palanca de mando                                                                                                                                                                          | 1    |
| 8  | Handradgriffe / handwheel handles / Poignées de volant / Palanca de volante                                                                                                                                                                     | 2    |
| 9  | Montageschrauben, -scheiben, -ringe Werkstückanschlag / mounting screws, washer, circlips workpiece stop / Boulons de fixation, rondelles plates, bagues, butée de pièce / Tornillos, arandelas, anillas de montaje tope de la pieza de trabajo | 2    |
| 10 | Montageschrauben, -scheiben, -ringe, muttern Untergestell / mounting screws, washer, circlips, nuts machine stand / Boulons de fixation, rondelles plates, bagues, châssis-support / Tornillos, arandelas, anillas de montaje, tuercas bastidor | 4    |
| 11 | Inbusschlüssel / hex wrench / Clé Allen / Llave allen                                                                                                                                                                                           | 4    |
| 12 | Bohrfutterschlüssel / drill chuck key / Clé de mandrin / Llave para mandriles                                                                                                                                                                   | 1    |
| 13 | Betriebsanleitung / user manual / Mode d'emploi / Instrucciones de servicio                                                                                                                                                                     | 1    |



### 3.2 Komponenten / Components / Composants / Componente



|           | Beschreibung / Description / Description / Descripción                                                                                                                                                        |
|-----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>1</b>  | Bedienhebel / operating handle / Manette de commande / Palanca de mando                                                                                                                                       |
| <b>2</b>  | Gasdruckfeder / gas spring / Vérin à gaz / Muelle neumático                                                                                                                                                   |
| <b>3</b>  | Werkstückniederhalter / workpiece downholder / Presseur / Pisador de la pieza de trabajo                                                                                                                      |
| <b>4</b>  | Werkstückanschlag / workpiece stop / Butée de pièce / Tope de pieza de trabajo                                                                                                                                |
| <b>5</b>  | Handrad Säulenschwenkung (nur STM26S) / hand wheel column swivel (only STM26S) / Volant de réglage de l'inclinaison de la colonne (STM26S uniquement) / Volante manual oscilación de la columna (solo STM26S) |
| <b>6</b>  | Handrad Tischneigung (nur STM26S) / hand wheel table tilt (only STM26S) / Volant d'inclinaison de la table (STM26S seulement) / Volante manual inclinación de la mesa (solo STM26S)                           |
| <b>7</b>  | Untergestell / machine stand / Support / Bastidor                                                                                                                                                             |
| <b>8</b>  | Tür Untergestell / door machine stand / Porte du châssis-support de la machine / Bastidor de la puerta                                                                                                        |
| <b>9</b>  | Handrad Querverfahrweg / handwheel cross travel / Volant de course transversale / Volante desplazamiento transversal                                                                                          |
| <b>10</b> | Werkstückklemmung / workpiece clamping / Dispositif de serrage de la pièce à usiner / Fijación de la pieza                                                                                                    |
| <b>11</b> | Handrad Längsverfahrweg / handwheel longitudinal travel / Volant de course longitudinale / Volante desplazamiento longitudinal                                                                                |
| <b>12</b> | Arbeitstisch / worktable / Table de travail / Mesa de trabajo                                                                                                                                                 |
| <b>13</b> | Anschlag Arbeitstisch / worktable stop / Butée de la table de travail / Tope mesa de trabajo                                                                                                                  |
| <b>14</b> | Stemmbohrer / mortise drill / Foret à mortaiser / Broca escoplo                                                                                                                                               |
| <b>15</b> | Bohrtiefenanschlag / drill depth stop / Butée de profondeur de perçage / Tope de profundidad para broca                                                                                                       |



|           |                                                                                   |
|-----------|-----------------------------------------------------------------------------------|
| <b>16</b> | EIN-AUS-Schalter / ON-OFF switch / Interrupteur MARCHÉ-ARRÊT / Interruptor ON/OFF |
| <b>17</b> | Anschlusskabel / cord / Câble de raccordement / Cable de conexión                 |
| <b>18</b> | Motor / motor / Moteur / Motor                                                    |

### 3.3 Technische Daten / Technical data / Données techniques / Datos técnicos

| Spezifikation / Specification / Spécifications / Especificación                                                                                 | STM26                  | STM26S                 |
|-------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|------------------------|
| Spannung / voltage / Tension / Tensión                                                                                                          | 230 V / 50 Hz          | 230 V / 50 Hz          |
| Motorleistung S1 (100 %) / motor power S1 (100 %) /<br>Puissance moteur S1 (100 %) / Potencia del motor S1 (100 %)                              | 750 W                  | 750 W                  |
| Spindeldrehzahl / spindle speed / Vitesse de broche /<br>Velocidad del husillo                                                                  | 1400 min <sup>-1</sup> | 1400 min <sup>-1</sup> |
| Arbeitstischgröße / worktable dimension / Taille de la table<br>de travail / Tamaño de la mesa de trabajo                                       | 540 x 190 mm           | 540 x 190 mm           |
| Tischhöhe / table height / Hauteur de table / Altura de la<br>mesa                                                                              | 820 mm                 | 880 mm                 |
| Stemmborhrergröße / mortise drill dimension / Diamètre<br>du foret à mortaiser / Tamaño de la broca escoplo                                     | 6 – 26 mm              | 6 – 26 mm              |
| Stemmborhrerschaft (Buchse) /<br>mortise drill shank (bushing) / Tige du foret de mortaire<br>(guide) / Vástago de la broca escoplo (casquillo) | Ø 19 mm                | Ø 19 mm                |
| max. Bohrtiefe / max. drilling depth / Profondeur max. de<br>perçage / Profundidad máx. de perforación                                          | 76 mm                  | 76 mm                  |
| Bohrhub / drill travel / Course de perçage / Carrera de<br>perforación                                                                          | 220 mm                 | 220 mm                 |
| max. Werkstückklemmung / max. workpiece clamping /<br>Dispositif de serrage de la pièce à usiner max. / Fijación<br>máx. de la pieza            | 190 mm                 | 190 mm                 |
| Bohrfutter / drill chuck / Mandrin de perçage / Mandril                                                                                         | 3 – 16 mm              | 3 – 16 mm              |
| Längsverfahrweg Tisch / table longitudinal travel / Table<br>de course longitudinale / Mesa de desplazamiento<br>longitudinal                   | ± 145 mm               | ± 145 mm               |
| Querverfahrweg Tisch / table cross travel / Table de course<br>transversale / Mesa de desplazamiento transversal                                | 140 mm                 | 140 mm                 |
| max Abstand Tisch-Buchse / max distance table-bushing /<br>Distance max. table-guide / Distancia máx. mesa-casquillo                            | 320 mm                 | 340 mm                 |
| Arbeitstischneigung / worktable tilt / Inclinaison de la<br>table de travail / Inclínación de la mesa de trabajo                                | ----                   | ± 20 °                 |
| Säulenschwenkung / column swivel / Pivotement de la<br>colonne / Oscilación de la columna                                                       | ----                   | ± 22,5 °               |
| Anschlusskabellänge / cord length / Longueur de câble de<br>raccordement / Longitud del cable de conexión                                       | 1,8 m                  | 1,8 m                  |
| Maße Untergestell (LxBxH) /<br>machine stand dimension (LxWxH) / Dimensions du<br>châssis-support(LxIxH) / Dimensiones bastidor (LxAxH)         | 475 x 380 x 570 mm     | 475 x 380 x 570 mm     |
| Maschinenmaße (LxBxH) / machine dimensions (LxWxH) /<br>Dimensions de la machine (LxIxH) / Dimensiones de la<br>máquina (LxAxH)                 | 945 x 620 x 1410 mm    | 945 x 620 x 1450 mm    |



|                                                                                                                                                                      |                                                 |                                                 |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|-------------------------------------------------|
| Verpackungsmaße (LxBxH) /<br>packaging dimensions (LxWxH) / Dimensions d'emballage<br>(LxIxH) / Dimensiones del embalaje (LxAxH)                                     | I: 570 x 490 x 850 mm<br>II: 490 x 400 x 615 mm | I: 620 x 565 x 960 mm<br>II: 490 x 400 x 615 mm |
| Gewicht Brutto (Maschine / Untergestell) /<br>weight gross (machine / machine stand) / Poids brute<br>(machine / châssis-support) / Peso bruto<br>(máquina/bastidor) | I: 92 kg<br>II: 13 kg                           | I: 117 kg<br>II: 13 kg                          |
| Gewicht Netto / weight net / Poids net / Peso (neto)                                                                                                                 | 86 kg                                           | 111 kg                                          |
| Schallleistungspegel $L_{WA}$ / sound power level $L_{WA}$ / Niveau<br>de puissance sonore $L_{WA}$ / Nivel de potencia sonora $L_{WA}$                              | 84 dB(A).....k: 3 dB(A)                         | 84 dB(A).....k: 3 dB(A)                         |
| Schalldruckpegel $L_{PA}$ / sound pressure level $L_{PA}$ / Niveau de<br>pression acoustique $L_{PA}$ / Nivel de presión sonora $L_{PA}$                             | 75 dB(A).....k: 3 dB(A)                         | 75 dB(A).....k: 3 dB(A)                         |

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

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

**(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.

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



## 11 PREFACE (EN)

### Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the BORING - MORTISE - MACHINE STM26 and STM26S, 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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The place of jurisdiction is the regional court Linz or the court responsible for 4170 Haslach is valid.

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## 12 SAFETY

This section contains information and important notes on the safe commissioning and handling of the machine.



For your safety, read this manual carefully before commissioning. This will enable you to handle the machine safely and thus prevent misunderstandings as well as personal injury and damage to property. Pay special attention to the symbols and pictograms used on the machine as well as the safety information and danger warnings!

### 12.1 Intended use of the machine

The machine is designed exclusively for the following activities:

Machining (drilling, mortising) from wood, wood composites or materials with similar physical properties to wood, within the prescribed technical limits.

#### NOTE



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

#### 12.1.1 Technical restrictions

The machine is designed for the work under the following conditions:

|                                  |                  |
|----------------------------------|------------------|
| Relative humidity                | max. 70 %        |
| Temperature (operation)          | +10 °C to +40 °C |
| Temperature (storage, transport) | -25 °C to +55 °C |

#### 12.1.2 Prohibited applications / Dangerous misuse

- Operating the machine outdoors.
- Operating the machine without adequate physical and mental fitness.
- Operating the machine without knowledge of the manual.
- Modifying the machine design.
- Operating the machine outside the technical limits specified in this manual.
- Removing of the safety markings attached to the machine.
- Modifying, circumventing or disabling the safety devices of the machine.

The non-intended use or the disregard of the explanations and instructions described in this manual will result in the expiration of all warranty claims and compensation claims for damages against HOLZMANN MASCHINEN GmbH.

### 12.2 User requirements

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

Basic knowledge of woodworking especially the correlation of wood type, mortise drill 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!**

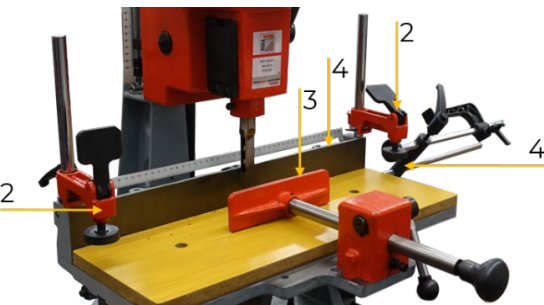


**Work on electrical components or equipment may only be carried out by a qualified electrician or under the guidance and supervision of a qualified electrician.**

Put on your personal protective equipment before working on the machine.

### 12.3 Safety devices

The machine is equipped with the following safety devices:

|                                                                                    |                                                                 |
|------------------------------------------------------------------------------------|-----------------------------------------------------------------|
|   | Drill chuck cover (1)                                           |
|  | Workpiece downholders (2), workpiece clamping (3) and stops (4) |

### 12.4 General safety instructions

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

- Check the machine for completeness and function before starting. Only use the machine if the separating and other non-separating protective devices required for machining have are fitted.
- Make sure that the guards are in good working order and properly maintained.
- Select a level, vibration-free surface as the installation area.
- Ensure sufficient space around the machine.
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects.
- Ensure a clean working environment.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut-off workpiece parts, etc.).
- Only use tools that are in perfect condition and free of cracks and other defects (e.g. deformations).
- Remove tool keys and other setting tools before switching on the machine.
- Check the machine's connections for strength before each use.
- Never leave the running machine unattended. Switch off the machine before leaving the working area and secure it against unintentional or unauthorized restarting.
- The machine may only be operated, maintained or repaired by persons who are familiar and who have been informed about the dangers arising from this work.
- Ensure that unauthorized persons keep a safety distance from the machine and keep children away from the machine.
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine.
- Hide long hair under hair protection.
- Wear close fitting protective work clothing and suitable protective equipment (eye protection, dust mask, ear protection, safety-shoes, work gloves only when handling tools).
- Never wear loose jewellery, loose clothing or accessories (e.g. tie, scarf).
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!



- Do not use the machine in areas where vapours of paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Shut down the machine and disconnect it from the power supply, before adjustment, changeover, cleaning, maintenance or repair work, etc. Before starting work on the machine, wait until all tools or machine parts have come to a complete standstill and secure the machine against unintentional restart.
- Warning signs and/or stickers on the machine that are illegible or have been removed must be replaced immediately!

## 12.5 Electrical safety

- Make sure that the machine is grounded.
- Only use suitable extension cables.
- A damaged or tangled cable increases the risk of electric shock. Handle the cable with care. Never use the cable to carry, pull or disconnect the power tool. Keep the cable away from heat, oil, sharp edges or moving parts.
- Proper plugs and outlets reduce the risk of electric shock.
- Water entry into the machine increases the risk of electric shock. Do not expose the machine to rain or moisture.
- The machine may only be used if the power source is protected by a residual current circuit breaker.
- Use the machine only when the ON-OFF switch is in good working order.
- Before connecting the machine always make sure that it is switches off.

## 12.6 Special safety instructions for this machine

- During operation of the machine wood dust is generated. Work only in well-ventilated rooms and wear a dust mask!
- Keep the machine away from potential ignition sources such as open flames – risk of fire and explosion!
- If an original machine stand is not used, the machine must be fixed firmly on a stable worktable or workbench. The working height should be 850 mm.
- The workpiece to be machined must be free of foreign objects such as nails or screws.
- Never remove sections or other parts of the workpiece from the working area while the machine is running.
- Replace cracked and deformed mortise drills immediately, they cannot be repaired.
- Use clean and sharpened mortise drills, which are less sensitive to malfunctions and easier to guide.
- Always fix workpieces with workpiece clamping and workpiece downholder.
- For a workpiece that is wider or longer than the supporting table, sufficient support such as table extensions, saw blocks, etc. must be provided.

## 12.7 Hazard warnings

### 12.7.1 Residual risks

Despite intended use, certain residual risk factors remain.

- Danger of cutting hands/fingers or other parts due to sharp mortise drills.
- Risk of injury to hands/fingers due to crushing between moving and fixed parts (hold-down devices, stops, workpiece supports,...).
- Risk of injury due to tipping of the machine.
- Risk of injury due to improper maintenance activities.

### 12.7.2 Hazardous situations

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

**DANGER**



A safety instruction designed in this way indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

## WARNING



A safety instruction designed in this way indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

## CAUTION



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

## NOTE



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

Regardless of all safety regulations, your common sense and your appropriate technical aptitude/training are and remain the most important safety factor in the error-free operation of the machine. **Safe working depends on you!**

## 13 TRANSPORT

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 place of installation. To manoeuvre the machine in the packaging, a pallet truck or forklift truck with the appropriate lifting force can be used, for example. The specifications can be found in the chapter Technical data. For proper transport, also observe the instructions and information on the transport packaging regarding centre of gravity, lifting points, weight, means of transport to be used as well as the prescribed transport position etc. Ensure that the selected lifting equipment (crane, forklift, pallet truck, load sling, etc.) is in perfect condition. The fork must have a length of at least 1200 mm. Ensure adequate load securing!

## WARNING



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

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

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



## 14 ASSEMBLY

### 14.1 Preparation

#### 14.1.1 Check delivery content

Check the delivery immediately for transport damage and missing parts. Report any damage or missing parts to your dealer or the shipping company immediately. Visible transport damage must also be noted immediately on the delivery note in accordance with the provisions of the warranty, otherwise the goods are deemed to have been properly accepted.

#### 14.1.2 Requirements for the installation site

The selected installation site must ensure a suitable connection to the electrical mains, as well as (e.g. :) connection to an extraction system. Observe the safety requirements and the dimensions of the machine.

Place the machine on a level, solid surface. The chosen installation site of the machine must comply with the local safety regulations as well as the ergonomic requirements for a workplace with sufficient lighting conditions.

#### NOTE



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

When dimensioning the required space, take into account that the operation, maintenance and repair of the machine must be possible without restrictions at all times. In the case of long workpieces, no crushing or shearing points may occur in the extension area (=danger area).

#### 14.1.3 Preparation of the surfaces

Before putting the machine into operation, carefully remove the anti-corrosion protection or grease residues from the bare metal parts. This can be done with the usual solvents. Under no circumstances should you use nitro thinners or other cleaning agents, as these can attack the machine's finish.

#### NOTE



The use of paint thinners, petro, aggressive chemicals or scouring agents will damage the surfaces!

**Therefore: Use only mild cleaning agents!**

### 14.2 Assemble

#### NOTE



**The machine and machine components are heavy!**

2 persons are required to assemble the machine.

The machine has been disassembled for transport and must be reassembled before use. Follow the instructions below:



|  |                                                                                                                                                                                                    |
|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>1. Assemble the machine feet:<br/>Fix the 4 machine feet with washers (2), circlip (3) and nut (4) in the mounting holes</p>                                                                    |
|  | <p>2. Assemble the machine on the machine stand:<br/>Lift the machine onto the machine stand. Align the mounting holes and fix the machine with screws (1) washers (2), circlips (3) and nuts.</p> |
|  | <p>3. Assemble the handwheel handles:<br/>Screw the handwheel handles (1) into the threads of the handwheels.</p>                                                                                  |
|  | <p>4. Assemble the operating lever:<br/>Insert the operating lever (1) into the bracket (2) and fix it with washers (3), spring (4) and nut (5).</p>                                               |
|  | <p>5. Assemble the workpiece stop:<br/>Fix the workpiece stop (1) to the left or right end of the worktable with washers (2), circlips (3) and screws (4).</p>                                     |



### 14.3 Electrical connection

#### WARNING

**Dangerous electrical voltage!**

- The machine may only be connected to the mains supply and the associated checks carried out by a qualified electrician or under the instruction and supervision of a qualified electrician!

- Check, whether the neutral connection and the protective grounding function properly.
- Check, whether the supply voltage and the frequency correspond to the specifications of the machine.

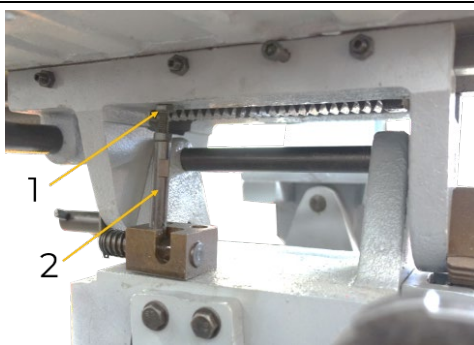
#### NOTE

**Deviation of the supply voltage and frequency!**

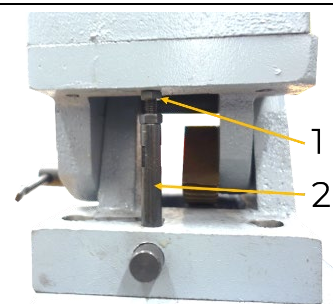
A deviation from the value of the supply voltage of  $\pm 5\%$  is permissible.  
A short-circuit fuse must be provided in the power supply system of the machine!

- Use a supply cable of type H07RN (WDE282) or 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 source 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.

### 14.4 Settings STM26S

**Worktable tilt:**

Set the worktable to exactly  $90^\circ$  and secure the position with the nut (1) of the position stop (2).

**Column swivel:**

Set the column to exactly  $90^\circ$  and secure the position with the nut (1) of the position stop (2).



## 15 OPERATION

Only operate the machine when it is in a perfect condition. Before each operation, a visual inspection of the machine must be carried out. Safety devices and operating elements must be checked carefully. Check screw connections for damage and tight fit.

### 15.1 Operating instructions

| Before starting to work                                    | After work have finished                                                                     |
|------------------------------------------------------------|----------------------------------------------------------------------------------------------|
| Lubricate all lubrication points                           | Disconnect the machine from the power supply.                                                |
| Remove unused tools / parts                                | Remove tools from the machine                                                                |
| Make sure that the workpiece is properly clamped.          | Clean and lubricate the machine.                                                             |
| Make sure that there are no chips on the sliding surfaces. | Cover the bare surfaces on the machien with a corrosion protection agent to avoid corrosion. |

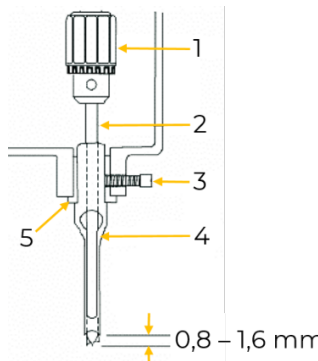
### 15.2 Switch the machine on and off

|  |                                                                                                             |
|--|-------------------------------------------------------------------------------------------------------------|
|  | <b>ON-OFF switch</b><br>Press the green button (I) to switch on.<br>Press the red button (O) to switch off. |
|--|-------------------------------------------------------------------------------------------------------------|

### 15.3 Clamping a mortise drill

|  |                                                                                                                                                                                                                                                                        |
|--|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | Loosen the screw of the drill chuck cover<br>Open the drill chuck cover                                                                                                                                                                                                |
|  | Release the lock screw (3)<br>Insert the mortise chisel (4) into the bushing (5)<br>Tighten the lock screw<br><br><b>NOTE:</b> Turn the slot to the left or right side, never to the front or to the back. This will allow the ejection of chips when making mortises. |
|  | Insert the drill (2) upwards through the mortise chisel into the drill chuck (1)<br>Lock the drill in the drill chuck with the drill chuck key (6)                                                                                                                     |



|                                                                                   |                                                                                                                                                                                                                    |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>The drill tip should be adjusted to a distance of 0.8 to 1.6 mm between the chisel points depending on the type of wood</p> <p>Close the drill chuck cover</p> <p>Fasten the screw of the drill chuck cover</p> |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

## 15.4 Operating

### WARNING

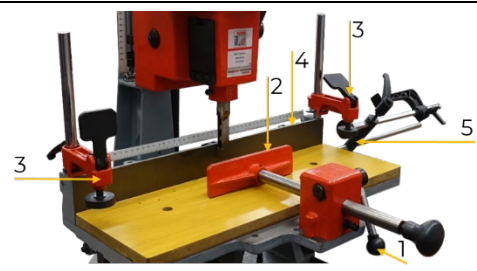


#### **Danger due to electrical voltage!**

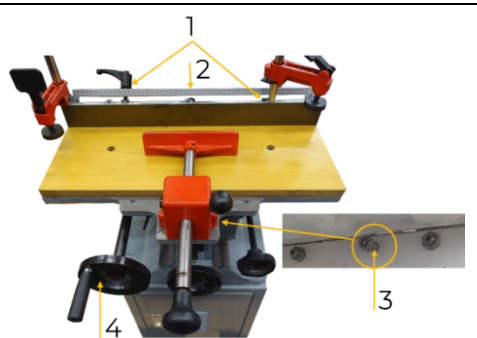
Handling the machine with connected power supply may result in serious injury or death.

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

### 15.4.1 Clamping the workpiece

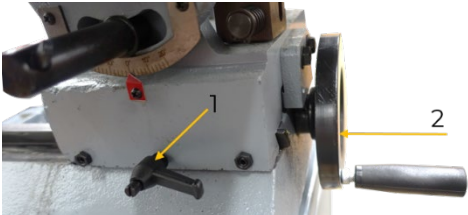
|                                                                                     |                                                                                                                                                                                                                                                                                                 |
|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Place the workpiece on the work table</p> <p>Set the workposition with the workpiece stop (5) on the work table stop (4)</p> <p>Clamp the work piece with the workpiece clamping (2) and lock with the locking lever (1)</p> <p>Close the workpiece downholder (3) and fix the workpiece</p> |
|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

### 15.4.2 Longitudinal travel

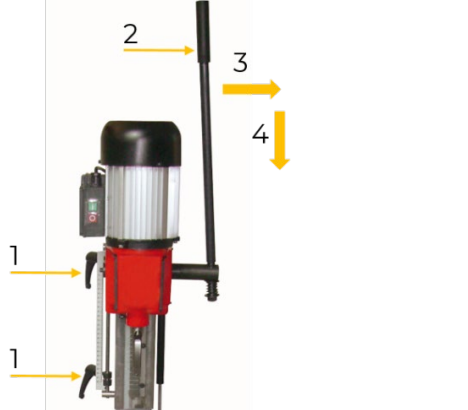
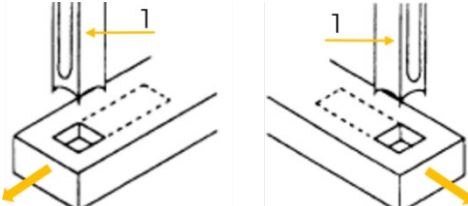
|                                                                                     |                                                                                                                                                                                                                        |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Set the desired longitudinal travel with stops (1) (read off the scale (2)).</p> <p>Loosen the locking screw (3)</p> <p>Move the work table in the desired direction with the handwheel longitudinal travel (4)</p> |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|



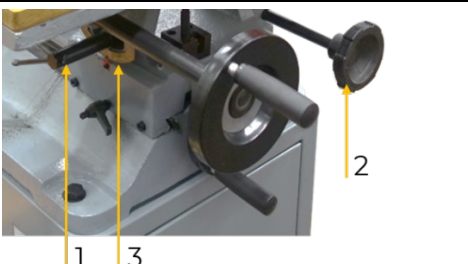
### 15.4.3 Cross travel

|                                                                                   |                                                                                                                                                              |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Loosen the locking lever (1)<br/>Move the work table in the desired direction with the handwheel cross travel (2)<br/>Retighten the locking lever (1)</p> |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|

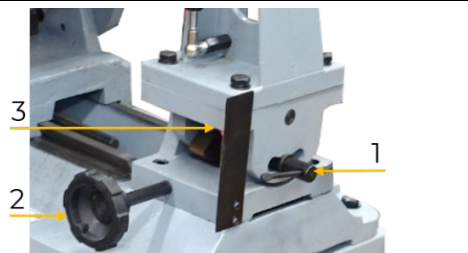
### 15.4.4 Mortising-Drilling

|                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                |
|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|   | <p>Set the drilling depth with the stops (1)<br/>Feed the mortise drill steadily into the workpiece by pulling down (4) the operating lever (2)<br/><b>NOTE:</b> If there is not enough travel, press the operating lever to the right (3), guide it upwards, let it engage again and then pull it down again.<br/><b>NOTE:</b> When making deep mortises, carry out the process in several steps (one step approx. 2 cm).</p> |
|  | <p><b>NOTE:</b> Make sure that the ejection slot (1) is always in the direction of movement of the workpiece, this enables the ejection of the chips when making mortises.</p>                                                                                                                                                                                                                                                 |

### 15.4.5 Worktable tilt (STM26S)

|                                                                                     |                                                                                                                                                      |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Loosen the locking (1)<br/>Set the desired worktable tilt with handwheel (2) (read off the angle on the scale (3)).<br/>Retighten the locking</p> |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------|

### 15.4.6 Column swivel (STM26S)

|                                                                                     |                                                                                                                                              |
|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Loosen the locking (1)<br/>Set the desired column with handwheel (2) (read off the angle on the scale (3)).<br/>Retighten the locking</p> |
|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------|



## 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 need to be serviced. Malfunctions or defects that could affect your safety must be repaired immediately!

- Before each operation, check the perfect condition of the safety devices.
- Regularly check the perfect and legible condition of the warning and safety labels of the machine.
- Use only proper and suitable tools.
- Use only original spare parts recommended by the manufacturer.

#### 16.2.1 Maintenance plan

The type and degree of machine wear depends to a large extent on the operating conditions. The following intervals apply when the machine is used within the technical limits:

| Interval     | Components        | Action                                    |
|--------------|-------------------|-------------------------------------------|
| Before usage | Cable and plug    | Check for damage and replace if necessary |
| Once a week  | Screw connections | Check for tightness                       |
|              | Moving parts      | Lubricate                                 |
|              | Guideways         | Lubricate                                 |

#### 16.2.2 Worktable guideways adjustment



1. Remove all dirt from the area.
2. Loosen the nuts.
3. Adjust the guideways with the worm screws.
4. Tighten the nuts again.
5. Check the smooth movement and adjust the settings if necessary.



## 16.3 Storage

Store the machine in a dry, frost-proof and lockable place when not in use. Make sure that unauthorised persons and especially children do not have access to the machine.

### NOTE



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

## 16.4 Disposal



Observe the national waste disposal regulations. Never dispose of the machine, machine components or operating equipment in the residual waste. If necessary, contact your local authorities for information regarding available disposal options.

If you purchase a new machine or equivalent equipment from your specialist dealer, he is obliged in certain countries to dispose of your old machine properly.

# 17 TROUBLESHOOTING

### WARNING



#### **Danger due to electrical voltage!**

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

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

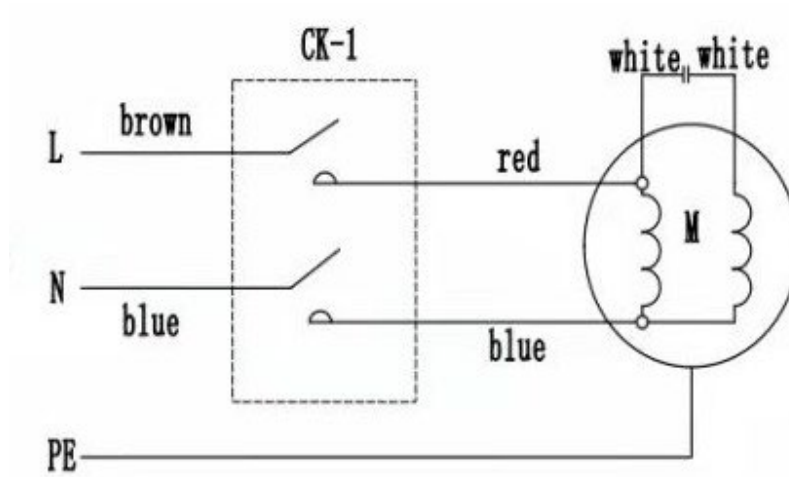
Many possible sources of error can be eliminated in advance if the machine is properly connected to the mains.

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

| Trouble                   | Possible cause                        | Solution                             |
|---------------------------|---------------------------------------|--------------------------------------|
| <b>Motor does not run</b> | Power supply incorrect                | Check all electrical connections     |
|                           | Switch defective                      | Repair/exchange switch               |
|                           | Motor defective                       | Repair/exchange switch               |
| <b>Tool smokes</b>        | Wrong ratio speed / material hardness | Reduce pressure                      |
|                           | Blunt mortise drill                   | Sharpen the mortise drill            |
| <b>Inaccurate result</b>  | Poor workpiece clamping               | Readjust and clamp the workpiece new |
|                           | Vibratin of the machine               | Relevel the machine                  |



32 **SCHALTPLAN / WIRING DIAGRAM / SCHEMA ELECTRIQUE /  
DIAGRAMA DE CABLEADO**





## 33 ERSATZTEILE / SPARE PARTS / PIECES DE RECHANGE / PIEZAS DE RECAMBIO

### 33.1 Ersatzteilbestellung / Spare parts order / Commande de pièces détachées / Pedido de piezas

**(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/NEWS/FAQ – ERSATZTEILANFORDERUNG,  
per Mail an [service@holzmann-maschinen.at](mailto: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/NEWS/FAQ - SPARE PARTS REQUEST,  
by e-mail to [service@holzmann-maschinen.at](mailto: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/ACTUALITÉS/FAQ – DEMANDE DE PIECES DE RECHANGE,  
par e-mail à l'adresse [service@holzmann-maschinen.at](mailto: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.



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

## AVISO



¡La instalación de piezas de recambio no originales lleva a la pérdida de garantía! Por lo tanto: Al llevar a cabo la sustitución de componentes/piezas, utilice únicamente piezas de recambio recomendadas por el fabricante.

Pida las piezas de recambio directamente en nuestra página web: Categoría PIEZAS DE RECAMBIO.  
o póngase en contacto con nuestro servicio de atención al cliente

en nuestra página web: Categoría SERVICIO/NOTICIAS/PREGUNTAS FRECUENTES – SOLICITUD DE  
PIEZAS DE RECAMBIO

por correo electrónico a [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at).

Indique siempre el tipo de máquina, la referencia de la pieza de recambio y la denominación. Para evitar malentendidos, se recomienda adjuntar al pedido una copia del esquema de piezas de recambio en el que se marque claramente las piezas de recambio necesarias, cuando no se solicitan con el catálogo en línea de piezas de recambio.



## **33.2 Explosionszeichnung / Exploded view / Vue éclatée / Vista de despiece**

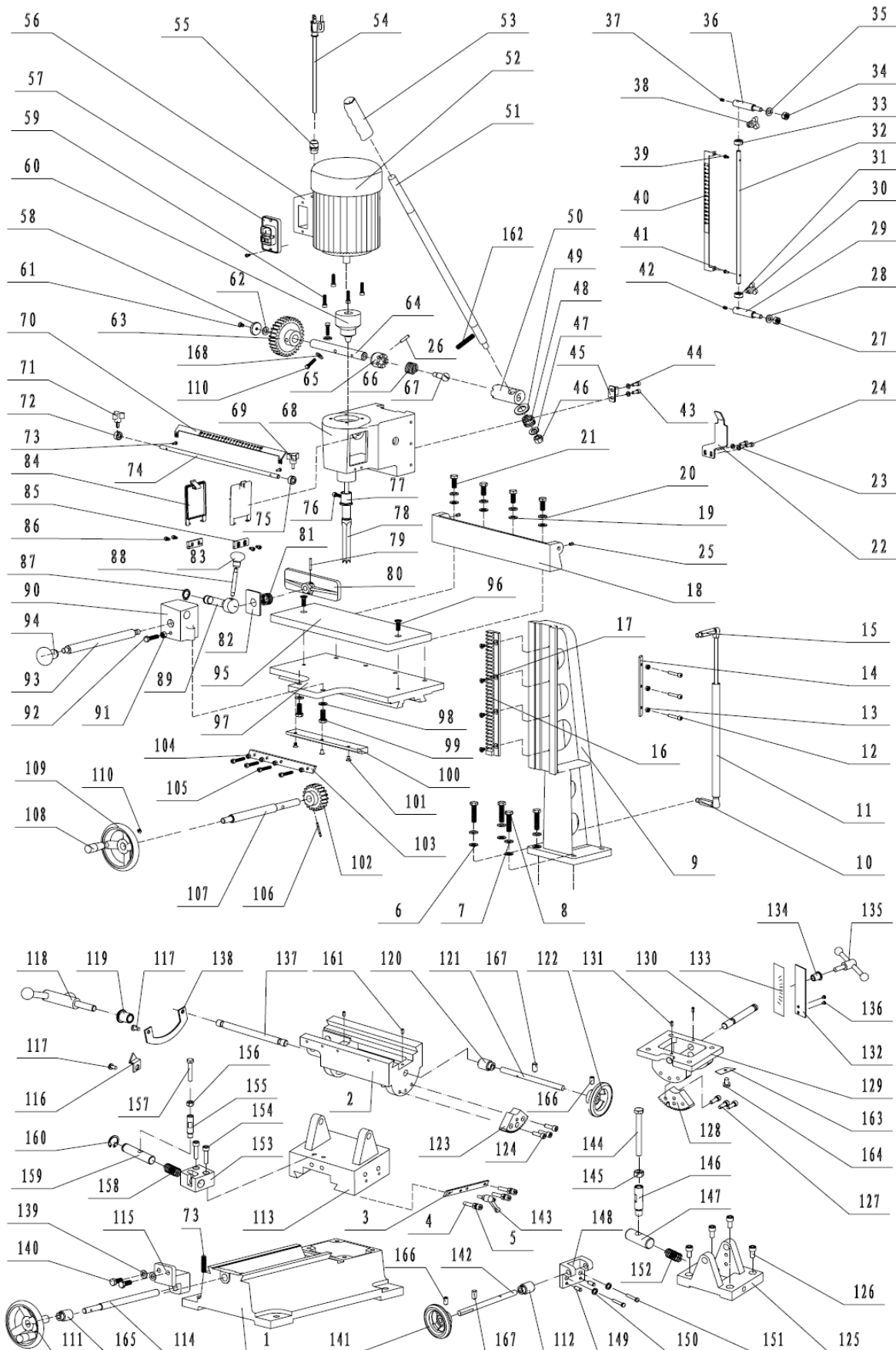
### **33.2.1 STM26**



| yyy | Description           | Qty | NO. | Description              | Qty  |
|-----|-----------------------|-----|-----|--------------------------|------|
| 1   | Base                  | 1   | 60  | Chuck, 16mm              | 1    |
| 2   | Middle Base           | 1   | 61  | Screw, M6x10             | 1    |
| 3   | Drift                 | 1   | 62  | Cover                    | 1    |
| 4   | Set Screw, M6x35      | 4   | 63  | Gear                     | 1    |
| 5   | Hex Nut, M6           | 4   | 64  | Shaft                    | 1    |
| 6   | Washer, 10            | 4   | 65  | Connecting Bend          | 1    |
| 7   | Wave Washer, 10       | 4   | 66  | Spring                   | 1    |
| 8   | Cap Screw, M10x40     | 4   | 67  | Screw                    | 1    |
| 9   | Column                | 1   | 68  | Headstock                | 1    |
| 10  | Screw                 | 1   | 69  | Screw                    | 1    |
| 11  | Gas Spring            | 1   | 70  | Ruler mark               | 1    |
| 12  | Set Screw, M6x35      | 3   | 71  | Screw                    | 1    |
| 13  | Hex Nut, M6           | 3   | 72  | Setting Collar           | 1    |
| 14  | Drift                 | 1   | 73  | Screw, M4x12...          | 2    |
| 15  | Screw                 | 1   | 74  | Setting Rod              | 1    |
| 16  | Rack                  | 1   | 75  | Setting Collar           | 1    |
| 17  | Screw, M6x10          | 4   | 76  | Screw, M6x25             | 1    |
| 18  | Fence                 | 1   | 77  | Bushing                  | 1    |
| 19  | Washer, 10            | 4   | 78  | Mistising Chisel And Bit | 1    |
| 20  | Wave Washer, 10       | 4   | 79  | Pin                      | 1    |
| 21  | Cap Screw, M10x25     | 4   | 80  | Clamp Plate              | 1    |
| 22  | Localizer             | 1   | 81  | Spring                   | 1    |
| 23  | Washer, 6             | 2   | 82  | Spring Cover             | 1    |
| 24  | Screw, M6x15          | 2   | 83  | Handle                   | 1    |
| 25  | Screw, M6x10          | 2   | 84  | Cover                    | 1    |
| 26  | Pin                   | 2   | 85  | Screw, M5x10             | 4yyy |
| 27  | Hex Nut, M10          | 1   | 86  | Cover Base               | 2    |
| 28  | Washer, 10            | 1   | 87  | C—Spring C-20            | 2    |
| 29  | Screw                 | 1   | 88  | Handle                   | 1    |
| 30  | Screw                 | 1   | 89  | Shaft                    | 1    |
| 31  | Setting Collar        | 1   | 90  | Clamping Block           | 1    |
| 32  | Setting Rod           | 1   | 91  | Nut ,M10                 | 1    |
| 33  | Setting Collar        | 1   | 92  | Screw, M8x25             | 2    |
| 34  | Hex Nut, M10          | 1   | 93  | Locking Shaft            | 1    |
| 35  | Washer, 10            | 1   | 94  | Handle                   | 1    |
| 36  | Screw                 | 1   | 95  | Wood Table               | 1    |
| 37  | Screw, M6x15          | 1   | 96  | Screw, M8x25             | 2    |
| 38  | Screw                 | 1   | 97  | Table                    | 1    |
| 39  | Screw, M4x12          | 1   | 98  | Washer , 10              | 2    |
| 40  | Depth Ruler           | 1   | 99  | Screw, M10x25            | 2    |
| 41  | Screw, M4x12          | 1   | 100 | Rack                     | 1    |
| 42  | Screw, M6x15          | 1   | 101 | Screw, M6x10             |      |
| 43  | Screw, M6x15          | 2   | 102 | Gear                     |      |
| 44  | Washer, 6             | 2   | 103 | Drift                    |      |
| 45  | Localizer             | 1   | 104 | Nut , M6                 |      |
| 46  | Hex Nut, M12          | 1   | 105 | Screw, M6x15             |      |
| 47  | Washer, 12            | 1   | 106 | Pin                      |      |
| 48  | Spring                | 1   | 107 | Gear Shaft               |      |
| 49  | Washer, 14            | 1   | 108 | Collar                   |      |
| 50  | Connecting Bend       | 1   | 109 | Handwheel                |      |
| 51  | Handle                | 1   | 110 | Screw, M8x10             |      |
| 52  | Motor                 | 1   | 111 | Handwheel                |      |
| 53  | Handle Grip           | 1   | 112 | Screw, M8x10             | 1    |
| 54  | Power Cord            | 1   | 113 | Collar                   | 1    |
| 55  | Strain Relief Bushing | 1   | 114 | Lead Screw               | 1    |
| 56  | Switch Box            | 1   | 115 | Lead Nut                 | 1    |
| 57  | Switch                | 1   | 116 | Washer 10                | 2    |
| 58  | Screw, M4x15          | 2   | 117 | Screw, M10x25            | 2    |
| 59  | Screw, M6x25          | 4   |     |                          |      |



33.2.2 STM26S





| NO. | Description           | Qty | NO. | Description      | Qty |
|-----|-----------------------|-----|-----|------------------|-----|
| 1   | Base                  | 1   | 85  | Screw, M5x10     | 4   |
| 2   | Middle base           | 1   | 86  | Cover base       | 2   |
| 3   | Drift                 | 1   | 87  | "C" ring, 20     | 2   |
| 4   | Set screw, M6x35      | 4   | 88  | Handle           | 1   |
| 5   | Hex nut, M6           | 4   | 89  | Shaft            | 1   |
| 6   | Washer, 10            | 4   | 90  | Clamping block   | 1   |
| 7   | Wave washer, 10       | 4   | 91  | Nut, M10         | 1   |
| 8   | Cap screw, M10x40     | 4   | 92  | Screw, M8x25     | 1   |
| 9   | Column                | 1   | 93  | Locking shaft    | 1   |
| 10  | Screw                 | 1   | 94  | Handle           | 1   |
| 11  | Gas spring            | 1   | 95  | Wood table       | 1   |
| 12  | Set screw, M6x35      | 3   | 96  | Screw, M8x25     | 2   |
| 13  | Hex nut, M6           | 3   | 97  | Table            | 1   |
| 14  | Drift                 | 1   | 98  | Washer, 10       | 2   |
| 15  | Screw                 | 1   | 99  | Screw, M10x25    | 2   |
| 16  | Rack                  | 1   | 100 | Rack             | 1   |
| 17  | Screw, M6x10          | 4   | 101 | Screw, M6x10     | 3   |
| 18  | Fence                 | 1   | 102 | Gear             | 1   |
| 19  | Washer, 10            | 4   | 103 | Drift            | 1   |
| 20  | Wave washer, 10       | 4   | 104 | Nut, M6          | 4   |
| 21  | Cap screw, M10x25     | 4   | 105 | Screw, M6x15     | 4   |
| 22  | Localizer             | 1   | 106 | Pin              | 1   |
| 23  | Washer, 6             | 2   | 107 | Gear shaft       | 1   |
| 24  | Screw, M6x15          | 2   | 108 | Collar           | 1   |
| 25  | Screw, M6x10          | 2   | 109 | Handwheel        | 1   |
| 26  | Pin                   | 1   | 110 | Screw, M8x10     | 1   |
| 27  | Hex nut, M10          | 1   | 111 | Handwheel        | 1   |
| 28  | Washer, 10            | 1   | 112 | Gear             | 1   |
| 29  | Screw                 | 1   | 113 | Collar           | 1   |
| 30  | Screw                 | 1   | 114 | Lead Screw       | 1   |
| 31  | Setting collar        | 1   | 115 | Lead Nut         | 1   |
| 32  | Setting rod           | 1   | 116 | Sharp            | 2   |
| 33  | Setting collar        | 1   | 117 | Screw, M5x10     | 3   |
| 34  | Hex nut, M10          | 1   | 118 | Set Screw Handle | 1   |
| 35  | Washer, 10            | 1   | 119 | Bush             | 1   |
| 36  | Screw                 | 1   | 120 | Gear             | 1   |
| 37  | Screw, M6x15          | 1   | 121 | Gear shaft       | 1   |
| 38  | Screw                 | 1   | 122 | Hand wheel       | 1   |
| 39  | Screw, M4x12          | 1   | 123 | Gear             | 1   |
| 40  | Depth ruler           | 1   | 124 | Screw, M10x25    | 3   |
| 41  | Screw, M4x12          | 1   | 125 | Plate-A          | 1   |
| 42  | Screw, M6x15          | 1   | 126 | Screw, M10x25    | 2   |
| 43  | Screw, M6x15          | 2   | 127 | Screw, M10x25    | 3   |
| 44  | Washer, 6             | 2   | 128 | Gear             | 1   |
| 45  | Localizer             | 1   | 129 | Plate-B          | 1   |
| 46  | Hex nut, M12          | 1   | 130 | shaft            | 1   |
| 47  | Washer, 12            | 1   | 131 | Screw, M6x15     | 2   |
| 48  | Spring                | 1   | 132 | Calibration      | 1   |
| 49  | Washer, 14            | 1   | 133 | Angle Ruler      | 1   |
| 50  | Connecting bend       | 1   | 134 | BuSh             | 1   |
| 51  | Handle                | 1   | 135 | Set Screw Handle | 1   |
| 52  | Motor                 | 1   | 136 | Screw, M4x10     | 2   |
| 53  | Handle grip           | 1   | 137 | Gear shaft       | 1   |
| 54  | Power cord            | 1   | 138 | Calibration      | 1   |
| 55  | Strain relief bushing | 1   | 139 | Washer           | 2   |
| 56  | Switch box            | 1   | 140 | Cap screw, M8x25 | 2   |
| 57  | Switch                | 1   | 141 | Handwheel        | 1   |
| 58  | Washer                | 1   | 142 | Gear shaft       | 1   |
| 59  | Screw, M6x25          | 4   | 143 | Set screw        | 1   |



|           |                          |   |            |                  |   |
|-----------|--------------------------|---|------------|------------------|---|
| <b>60</b> | Chuck, 16mm              | 1 | <b>144</b> | Screw, M6x30     | 1 |
| <b>61</b> | Screw, M6x10             | 1 | <b>145</b> | Nut, M6          | 1 |
| <b>62</b> | Cover                    | 1 | <b>146</b> | Lead Screw       | 1 |
| <b>63</b> | Gear                     | 1 | <b>147</b> | shaft            | 1 |
| <b>64</b> | Shaft                    | 1 | <b>148</b> | Gear Base        | 1 |
| <b>65</b> | Connecting bend          | 1 | <b>149</b> | Pin 8            | 2 |
| <b>66</b> | Spring                   | 1 | <b>150</b> | Spring Washer 8  | 2 |
| <b>67</b> | Screw                    | 1 | <b>151</b> | Screw, M8x30     | 2 |
| <b>68</b> | Headstock                | 1 | <b>152</b> | Spring           | 1 |
| <b>69</b> | Screw                    | 1 | <b>153</b> | Lead Screw Base  | 1 |
| <b>70</b> | Ruler mark               | 1 | <b>154</b> | Cap screw, M6x25 | 2 |
| <b>71</b> | Screw                    | 1 | <b>155</b> | Lead Screw       | 1 |
| <b>72</b> | Setting collar           | 1 | <b>156</b> | Nut, M6          | 1 |
| <b>73</b> | Screw, M4x12             | 2 | <b>157</b> | Screw, M6x30     | 1 |
| <b>74</b> | Setting rod              | 1 | <b>158</b> | Spring           | 1 |
| <b>75</b> | Setting collar           | 1 | <b>159</b> | shaft            | 1 |
| <b>76</b> | Screw, M6x25             | 1 | <b>160</b> | "C" ring, 14     | 1 |
| <b>77</b> | Bushing                  | 1 | <b>161</b> | Set screw        | 2 |
| <b>78</b> | Mortising chisel and bit | 1 | <b>162</b> | Pin 8            | 1 |
| <b>79</b> | Pin                      | 1 | <b>163</b> | Sharp            | 1 |
| <b>80</b> | Clamp plate              | 1 | <b>164</b> | Screw, M4x10     | 1 |
| <b>81</b> | Spring                   | 1 | <b>165</b> | Bush             | 1 |
| <b>82</b> | Spring cover             | 1 | <b>166</b> | Screw            | 2 |
| <b>83</b> | Handle                   | 1 | <b>167</b> | Pin              | 2 |
| <b>84</b> | Cover                    | 1 | <b>168</b> | Wave washer, 8   | 2 |

### 33.2.3 Untergestell / machine stand / Support / Bastidor

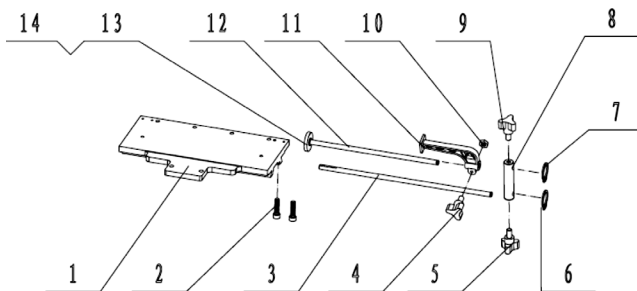
| NO.       | Description       | Qty |
|-----------|-------------------|-----|
| <b>1</b>  | Base              | 1   |
| <b>2</b>  | Stand             | 1   |
| <b>3</b>  | Door              | 1   |
| <b>4</b>  | Door latch        | 1   |
| <b>5</b>  | Hex nut, M10      | 4   |
| <b>6</b>  | Stand base        | 4   |
| <b>7</b>  | Hex nut, M10      | 4   |
| <b>8</b>  | Washer, 10        | 4   |
| <b>9</b>  | Wave washer 10    | 4   |
| <b>10</b> | Cap screw, M12x40 | 4   |



### 33.2.4 Werkstückniederhalter / workpiece downholder / Presseur / Pisador de la pieza de trabajo

| NO. | Description    | Qty |
|-----|----------------|-----|
| 1   | Shaft          | 2   |
| 2   | Setting piece  | 2   |
| 3   | Spring         | 2   |
| 4   | Clamping body  | 2   |
| 5   | C-Clip         | 2   |
| 6   | Locking handle | 2   |
| 7   | Locking screw  | 2   |
| 8   | Spring         | 2   |
| 9   | Pin            | 2   |
| 10  | Stop disc      | 2   |

### 33.2.5 Werkstückanschlag / workpiece stop / Butée de pièce / Tope de pieza de trabajo



| NO. | Description              | Qty |
|-----|--------------------------|-----|
| 1   | Table                    | 1   |
| 2   | Cap Screw M6x25          | 2   |
| 3   | Rear Length Setting Rod  | 1   |
| 4   | Handle Screw             | 1   |
| 5   | Handle Screw (big)       | 1   |
| 6   | C-Clip                   | 1   |
| 7   | C-Clip                   | 1   |
| 8   | Length Setting Block     | 1   |
| 9   | Handle Screw (big)       | 1   |
| 10  | Nut M6                   | 1   |
| 11  | Stop Disc                | 1   |
| 12  | Front Length Setting Rod | 1   |
| 13  | Washer                   | 1   |
| 14  | Stop Disc                | 1   |

## 34 ZUBEHÖR / ACCESSORIES / ACCESSOIRES / ACCESORIOS

**(DE)** Optionales Zubehör finden Sie online auf der Produktseite, Kategorie EMPFOHLENE PRODUKTE.

**(EN)** Optional accessories can be found online on the product page, category RECOMMENDED PRODUCTS.

**(FR)** Des accessoires en option sont disponibles en ligne sur la page produit, catégorie PRODUITS RECOMMANDÉS.

**(ES)** Los accesorios opcionales se encuentran en la página del producto en internet, en la categoría PRODUCTOS RECOMENDADOS.