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Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN USER MANUAL

ES OPERATING MANUAL

FR MANUEL D'UTILISATION

CZ NÁVOD K POUŽITÍ

TISCHFRÄSMASCHINE

TABLE ROUTER

FRESADORA TUPI DE SOBREMESA

FRAISEUSE DE TABLE (TOUPIE À BOIS)

STOLNÍ FRÉZKA



TFM610V_230V



**YOUR
JOB.
OUR
TOOLS.**



2 SICHERHEITSZEICHEN / SAFETY SIGNS

DE	SICHERHEITSZEICHEN BEDEUTUNG DER SYMBOLE	EN	SAFETY SIGNS DEFINITION OF SYMBOLS	ES	SEÑALES DE SEGURIDAD DEFINICIÓN DE SÍMBOLOS
FR	SIGNALISATION DE SÉCURITÉ DÉFINITION DES SYMBOLES	CZ	BEZPEČNOSTNÍ ZNAČKY VÝZNAM SYMBOLŮ		
	DE CE-KONFORM: Dieses Produkt entspricht den EU-Richtlinien.	EN EC-CONFORM: This product complies with the EC-directives.	ES ¡CONFORMIDAD CE! - Este producto cumple con las directivas CE.	FR CONFORMITÉ CE - Ce produit répond aux directives CE.	CZ CE SHODA: Tento výrobek vyhovuje směrnici EU.
	DE Betriebsanleitung lesen!	EN Read the manual!	ES ¡Observe el manual de instrucciones!	FR Respecter le manuel!	CZ Dodržujte návod k obsluze!
	DE Bedienen mit Handschuhen verboten!	EN Operation with gloves forbidden!	ES ¡Prohibido utilizar guantes!	FR Défense utilisait des gants !	CZ Zákaz používání rukavic!
	DE Keine offene Flamme, Feuer, offene Zündquelle und Rauchen verboten.	EN No open flame, fire, open source of ignition and smoking prohibited.	ES No se permiten llamas o fuegos abiertos, fuentes de ignición abiertas y fumar.	FR Aucune flamme nue, aucun feu, aucune source d'inflammation nue et défense de fumer!	CZ Zákaz otevřeného plamene, ohně, otevřeného zdroje zapalování a kouření
	DE Persönliche Schutzausrüstung tragen!	EN Wear personal protective equipment!	ES ¡Use el equipo de protección individual!	FR Porter un équipement de protection individuelle !	CZ Používejte osobní ochranné pomůcky!
	DE Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen.	EN Switch off the machine before maintenance and breaks and pull out the mains plug.	ES ¡Pare la máquina y desconéctela de la red eléctrica antes de llevar a cabo trabajos de mantenimiento y antes de las pausas!	FR Éteindre la machine avant la maintenance et les pauses et débrancher la fiche secteur!	CZ Stroj před úkony údržby a přestávkami vypněte a odpojte od sítě.
	DE Warnung vor spitzem (scharfem) Werkzeug	EN Warning of pointed (sharp) tool	ES Advertencia de herramienta puntiaguda (aflada)	FR Avertissement en cas d'outil pointu (tréchant)	CZ Výstraha před špičatými (ostrými) nástroji
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.				
ES	¡Deben sustituirse inmediatamente los letreros de advertencia y/o las pegatinas que haya en la máquina, que se hayan vuelto ilegibles o se hayan retirado!				
FR	Les panneaux d'avertissement et/ou autocollants d'avertissement illisibles ou retirés sur la machine doivent être remplacés immédiatement !				
CZ	Výstražné štítky a/nebo samolepky, které jsou na stroji nečitelné nebo odstraněné, je nutné ihned nahradit.				

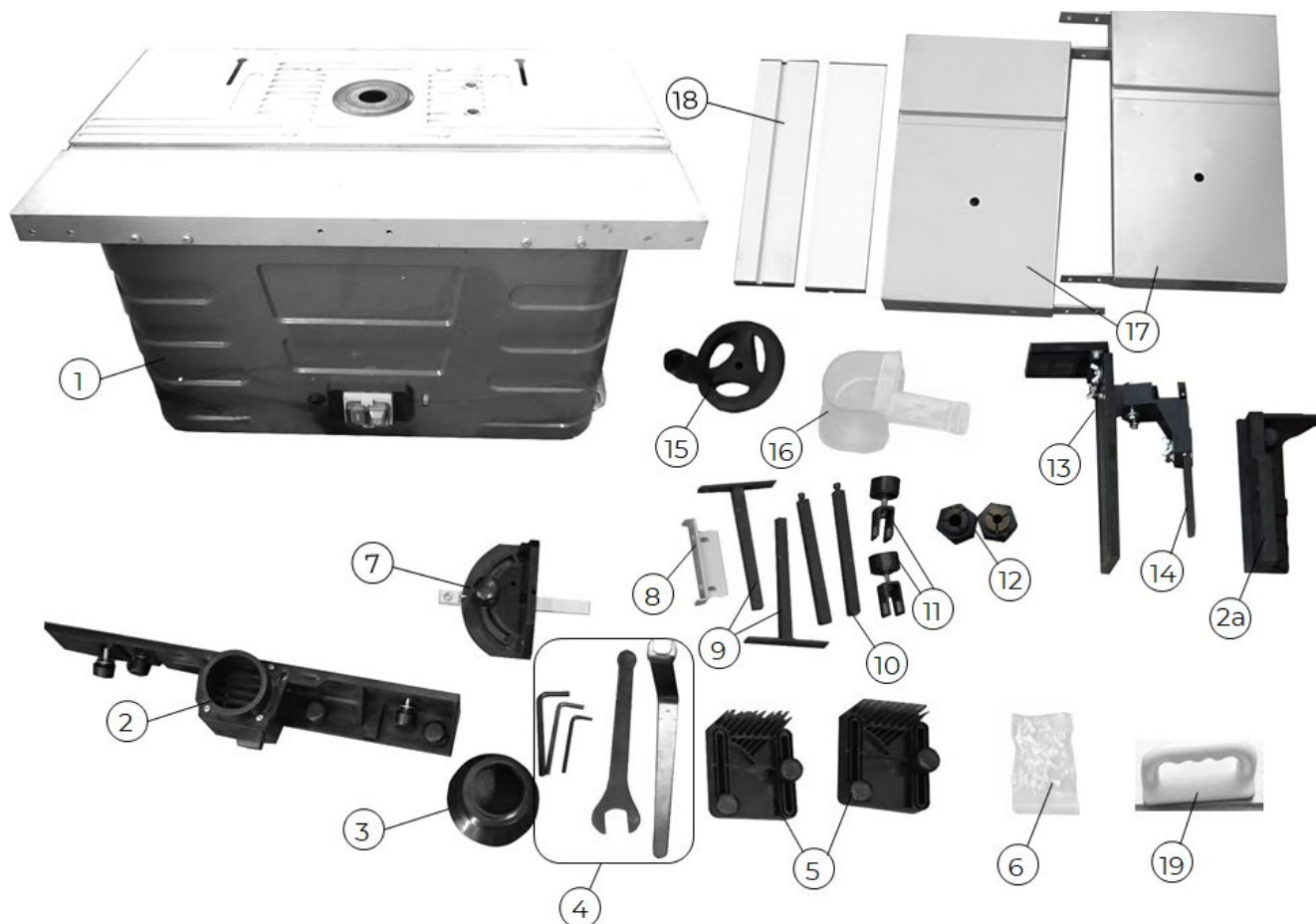


3 TECHNIK / TECHNICS

TÉCNICA / TECHNIQUE / TECHNIKA

3.1 Lieferumfang / Delivery content

Volumen de suministro / Contenu de la livraison / Rozsah dodávky

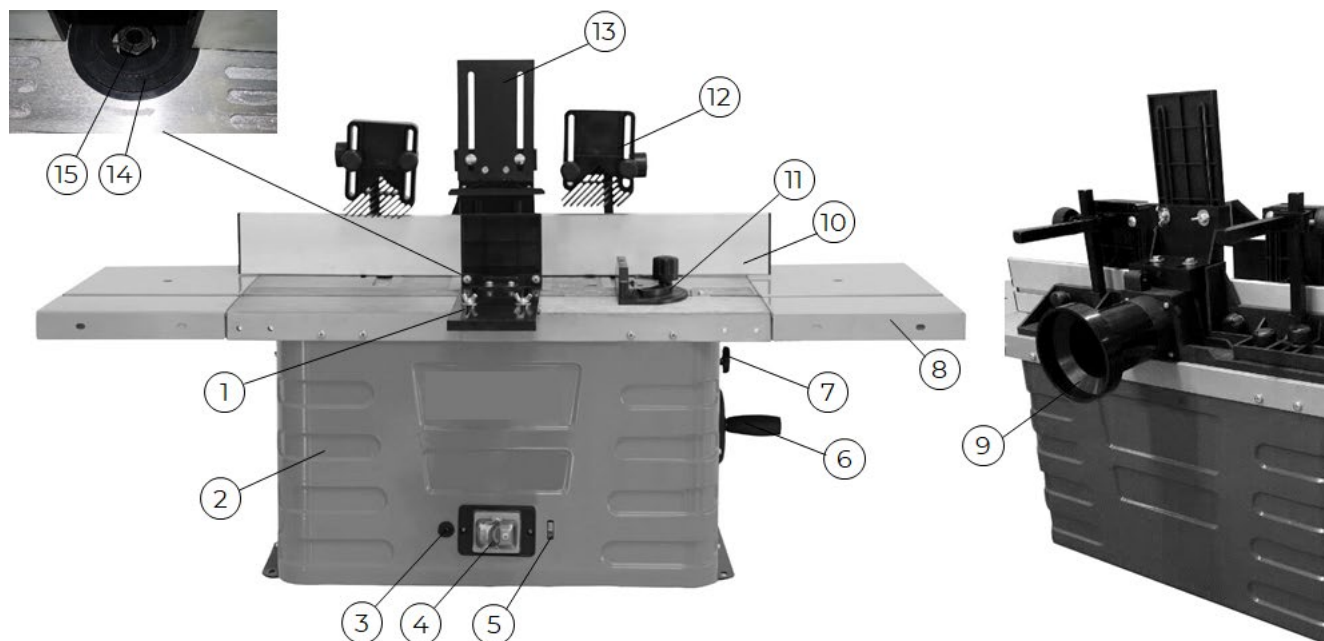


#	Beschreibung / Description	#	Beschreibung / Description
1	Maschine / machine / Máquina / Machine / Stroj	10	Haltstangen für Niederhalter / support rods for downholder / Barras de sujeción para los pisadores / Barres de maintien de serre-flanc / Podpůrné tyče pro přitlačný držák
2	Halterung Fräsanschlag-Niederhalter / holder milling stop-down holder / Soporte de los pisadores del tope de fresado / Bride de support de serre-flanc de butée de toupillage / Držák frézovacího dorazu-přitlačného držáku	11	Befestigungsklemmen für Niederhalter / fixation clips for downholder / Pinzas de fijación para los pisadores / Pince d'ancrage de serre-flanc / Přichytky pro přitlačný držák
2a	Halterung Fräsanschlag-Niederhalter / holder milling stop-down holder / Soporte de los pisadores del tope de fresado / Bride de support de serre-flanc de butée de toupillage / Držák frézovacího dorazu-přitlačného držáku	12	Schaftfräseradapter / shank router cutter adapter / Adaptador de fresa de vástago / Adaptateur de fraise à queue / Adaptér stopkové frézy
3	Absauganschlusstutzen / Dust collector port / Boquilla de conexión del sistema de aspiración / Manchons de raccordement d'aspiration / Konektor odsávání	13	Druckleiste front / pressure pad front / Barra de presión frontal / Barre de pression frontale / Přitlačná lišta přední
4	Werkzeug / tools / Herramienta / Outil / Nářadí	14	Druckleiste oben / pressure pad top / Barra de presión superior / Barre de pression supérieure / Přitlačná lišta horní



5	Niederhalter / down holder / Pisadores / Serre-flanc / Přítlačný držák	15	Handrad Spindelhöhenverstellung / handwheel height adjustment spindle / Volante manual del ajuste en altura del husillo / Volant de réglage de la hauteur de la broche / Ruční kolo výškového nastavení vřetene
6	Montagematerial (Schrauben) / assembly material (screws) / Material de montaje (tornillos) / Matériel de montage (vis) / Montážní sada (šrouby)	16	Schutzhaube / protection guard / Cubierta protectora / Capot de protection / Ochranný kryt
7	Gehrungsanschlag / mitre gauge / Tope de ingletes / Butée à onglet / Úhlové pravítko	17	Tischverlängerung / table extension / Extensión de la mesa / Extension de table / Prodloužení stolu
8	Halterung Druckleiste front / holder pressure pad front / Soporte de barra de presión frontal / Support de barre de pression frontale / Držák přítlačné lišty přední	18	Fräsanschlag / milling stop / Tope de fresado / Butée de toupillage / Frézovací pravítko
9	Haltstangen für Niederhalter / support rods for downholder / Barras de sujeción para los pisadores / Barres de maintien de serre-flanc / Podpůrné tyče pro přítlačný držák	19	Schiebeholz / Sliding wood / Madera de empuje / Cale coulissante / Posuvný přípravek

3.2 Komponenten / Components Componentes / Composants / Komponenty



	Beschreibung / Description		Beschreibung / Description
1	Druckleiste front / pressure pad front / Barra de presión frontal / Barre de pression frontale / Přítlačná lišta přední	9	Absauganschluss / dust collection port / Conexión del sistema de aspiración / Raccord d'aspiration / Připojení odsávání
2	Maschine / machine / Máquina / Machine / Stroj	10	Fräsanschlag / milling stop / Tope de fresado / Butée de toupillage / Frézovací pravítko
3	Thermoschalter / thermoswitch / Interruptor térmico / Interrupteur thermique / Termospínač	11	Gehrungsanschlag / mitre gauge / Tope de ingletes / Butée à onglet / Úhlové pravítko
4	EIN-AUS-SCHALTER / ON-OFF-switch / INTERRUPTOR ON/OFF / INTERRUPTEUR MARCHE-ARRÊT / Hlavní vypínač	12	Niederhalter / down holder / Pisadores / Serre-flanc / Přítlačný držák



5	Drehzahlregler Spindel / spindle speed control / Regulador de velocidad del husillo / Régulateur de vitesse de rotation de la broche / Regulace otáček vřetene	13	Druckleiste Oben / pressure pad top / Barra de presión superior / Barre de pression supérieure / Přítlačná lišta horní
6	Höhenstellrad Spindel / spindle height adjustment wheel / Rueda de ajuste en altura del husillo / Volant de réglage de la hauteur de la broche / Ruční kolo výškového nastavení vřetene	14	Tischeinlageringe / table ring inlays / Anillos para el suplemento de la mesa / Plaques annulaires de platine / Kroužky vložky stolu
7	Klemmschraube Höhenverstellung / fixation knob height adjustment / Tornillo de fijación del ajuste en altura / Vis de serrage de réglage en hauteur / Upínací šroub výškového nastavení	15	Schaftfräseraufnahme / shank router cutter adapter / Alojamiento de la fresa de vástago / Logement de fraise à queue / Upínací pouzdro stopkové frézy
8	Verlängerungstisch / extension table / Mesa de extensión / Prolongement de table / Prodloužení stolu		

3.3 Technische Daten / Technical data

Datos técnicos / Données techniques / Technické údaje

Spezifikation / Specification	
Spannung / Voltage / Tensión / Tension / Napětí	230 V/1 p/50 Hz
Motorleistung / motor power / Potencia del motor / Puissance moteur / Výkon motoru	1500 W
Schutzart / IP code / Grado de protección / Classe / Třída ochrany IP	IP20
Schutzklasse / Appliance classes / Clase de protección / Classe de protection	I
Spindel Drehzahl - 6-Stufen / spindle speed - 6 steps / Velocidad del husillo (6 niveles) / Vitesse de rotation de broche - 6 vitesses / Otáčky vřetene - 6 stupňů	11500-24000 min ⁻¹
Höhenverstellung Spindel / adjustable spindle height / Ajuste en altura del husillo / Réglage en hauteur de la broche / Výškové nastavení vřetene	0-40 mm
Schaftfräser Fräser Ø / shank router cutter Ø / Fresa de vástago Ø / Ø de la fraise à queue / Stopková fréza Ø	6/8/12 mm
Max Fräser Ø / max cutter Ø / Ø máx. de fresa / Ø de fraise max. / Max. Ø frézy	50 mm
Max. Werkstückgröße / max. workpiece dimension / Dimensiones máx. de la pieza de trabajo / Dimension max. de la pièce / Max. rozměr obrobku	650×160×65 mm
Tischöffnung / table opening / Orificio de la mesa / Ouverture de table / Otvor stolu	32/47/55 mm
Arbeitstischdimension / work table dimension / Dimensiones de la mesa de trabajo / Dimension de la table de travail / Rozměr pracovního stolu	610×360 mm
Tischverlängerung / table extension / Extensión de la mesa / Extension de table / Prodloužení stolu	210×360 mm
Tischhöhe / table height / Altura de la mesa / Hauteur de table / Výška stolu	310 mm
Maschinendimension (L×B×H) / machine dimensions (L×W×H) / Dimensiones de la máquina (L×A×H) / Dimension de la machine (L×I×H) / Rozměr stroje (D×Š×V)	1035×690×555 mm
Schallleistungspegel / sound power level / Nivel de potencia acústica / Niveau de puissance sonore / Hladina akustického výkonu L _{WA} (EN ISO 3746)	89 dB(A) k: 3 dB(A)
Schalldruckpegel / sound pressure level / Nivel de presión sonora / Niveau de pression acoustique / Hladina akustického tlaku L _{PA} (EN ISO 11202)	102 dB(A) k: 3 dB(A)
Nettogewicht / net weight / Peso neto / Poids net / Hmotnost netto	21 kg
Bruttogewicht / gross-weight / Peso bruto / Poids brut / Hmotnost brutto	23,5 kg

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

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



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

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

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

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



11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the table router TFM610V, 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 pay special attention to the chapter safety!

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

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

We reserve the right to make technical changes!

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

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

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

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12 SAFETY

This section contains information and important 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 intended exclusively for the following activities:

Machining of wood and plastic materials such as: milling of grooves, machining of recesses, Copying of curves and lettering within the specified machine limits.

NOTE



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

12.1.1 Technical restrictions

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

Relative humidity	max. 65 %
Temperature (operation)	+5 °C to +40 °C
Temperature (storage, transport)	-20 °C to +55 °C

12.1.2 Prohibited applications / Dangerous misuse

- Operating the machine without adequate physical and mental aptitude
- Operating the machine without knowledge of the operating instructions
- Changes in the design of the machine
- Operating the machine in a potentially explosive environment (machine can generate ignition sparks during operation)
- Operation of the machine in closed rooms without chip and dust extraction (a normal household vacuum cleaner is not suitable as an extraction device).
- Operating the machine outside the limits specified in this manual
- Remove the safety markings attached to the machine.
- Modify, circumvent or disable the safety devices of the machine.
- Machining of metal and stone etc.

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 physical and mental suitability as well as knowledge and understanding of the operating instructions are prerequisites for operating the machine. Persons who, because of their physical, sensory or mental abilities or their inexperience or ignorance, are unable to operate the machinery safely must not use it without the supervision or instruction by a responsible person.

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

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

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

12.3 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:



- Before commissioning, check the machine for completeness and function.
- Choose a level, vibration-free, non-slip surface for the installation location.
- Ensure sufficient space around the machine!
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects!
- Only use perfect tools that are free of cracks and other defects (e.g. deformations).
- Remove setting tools from the machine before switching on.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut workpiece parts etc.).
- Check the strength of the machine connections before each use.
- Never leave the running machine unattended. If necessary, stop the machine before leaving.
- The machine may only be operated, serviced or repaired by persons who are familiar with it and who have been informed of the dangers arising in the course of this work.
- Ensure that unauthorised persons maintain an appropriate safety distance from the machine and, in particular, keep children away from the machine.
- Wear suitable protective equipment (eye protection, dust mask, respiratory protection, ear protection, gloves when handling tools) as well as close-fitting work protective clothing - never wear loose clothing, ties, jewellery, etc. - danger of being drawn in!
- Work with gloves on rotating parts is not permitted!
- Hide long hair under hair protection.
- Do not remove any sections or other parts of the workpiece from the cutting area while the machine is running!
- Do not remove splinters and chips by hand! Use a sliding stick for this purpose!
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine!
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!
- Do not use the machine in areas where vapours from paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Do not smoke in the immediate vicinity of the machine (fire hazard)!
- Make sure that the ON/OFF switch is in the "OFF" position before connecting the machine to the power source.
- Do not use the machine if it cannot be switched on and off with the ON/OFF switch.
- Make sure that the device is earthed.
- Only use suitable extension cords.
- Always shut down the machine before carrying out any conversion, adjustment, measuring, cleaning, maintenance or repair work and always disconnect it from the power supply for maintenance or repair work. Before starting any work on the machine, wait until all tools or machine parts have come to a complete standstill and secure the machine against unintentional restarting.

12.4 Electrical safety

- Make sure that the machine is earthed.
- Only use suitable extension cords.
- There is an increased risk of electric shock if your body makes contact with the ground. Avoid body contact with grounded objects, e.g. pipes, radiators, etc.
- 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 sockets reduce the risk of electric shock.
- Water entry into machine increases the risk of electric shock. Do not expose machine to rain or moisture.
- The machine may only be used in humid environments if the power source is protected by a residual current circuit breaker.
- Do not use the machine if it cannot be turned on and off with the ON/OFF switch.



12.5 Special safety instructions for this machine

- During operation of the machine wood dust is generated. Therefore, connect the machine to a suitable dust collection system for dust and chips during installation!
- Always switch on the dust collection system before you start machining the workpiece!
- When using milling tools with a diameter of ≥ 16 mm and circular saw blades, these must comply with EN 847-1:2013 and EN 847-2:2013; tool carriers must comply with EN 847-3:2013;
- Excessive noise can cause hearing damage and temporary or permanent hearing loss. Wear hearing protection certified to health and safety regulations to limit noise exposure.
- Before putting the machine into operation, check that the milling tool is firmly seated and concentric!
- Do not use damaged tools (milling cutters) and ensure that the maximum speed of the milling cutter is above the maximum speed of the machine and that the shank diameter of the milling cutter is within the limits specified for the machine.
- When operating the machine, make sure that metal parts, screws, nails, etc. never gets in contact with the cutter and if greater milling depths are requested use several stages for producing to avoid damaging of the machine and tool.
- Allow the machine to reach full speed and then immerse the cutter in the workpiece.
- If the cutter is clogged with waste, stop the machine. Allow the cutter to run out completely. Remove the waste with a longer rod and not with your fingers.
- Allow the cutter to run out completely before removing the workpiece.
- The milling must always be carried out against the direction of rotation (counter-rotation) of the milling cutter.

12.6 Hazard warnings

Despite intended use, certain residual risk factors remain. Due to the structure and construction of the machine, hazardous situations may occur which are identified in this manual 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 factors in the error-free operation of the machine. **Safe working depends on you!**

13 TRANSPORT

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



Transport the machine in its packaging to the place of installation. When lifting, carrying and depositing the load, ensure the correct posture:

Lifting / Setting down

- When lifting/setting down, ensure that you are standing firmly (legs hip-width apart).
- Lift/set down load with knees bent and back straight.
- Do not lift/set down load with a jerk.

Carrying

- Carry load with both hands as close to body as possible.
- Carry load with straight back.

When transporting the assembled machine, ensure to lift it only by the machine body and not by the attachments. If you transport the machine with a vehicle, ensure that the load is secured appropriately!

14 ASSEMBLY

14.1 Preparatory activities

14.1.1 Check delivery content

Check the machine immediately after delivery for transport damage and missing parts.

14.1.2 The workplace

The floor at the installation site must be able to support the weight of the machine. The minimum space required for the machine is determined by the dimensions of the machine plus a safety area of approx. 80 cm around the machine.

Choose a level, load-bearing surface with adequate space for the machine. The installation site must also meet the ergonomic requirements of a workplace.

14.1.3 Required connection at workplace

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!

The machine is operated with alternating current (230 V, 1~, 50 Hz). The use of 16 A fuses is recommended.

14.1.4 Electrical connection

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

- Check that the supply voltage and the current frequency correspond to the specifications of the machine (refer to technical data or type-plate).
- Use a suitable device to check that the earthing are working properly.
- The power supply circuit must be equipped with overvoltage protection (RCD with maximum residual current of 30 mA).
- For the required cross-section of the supply cables, please refer to the current carrying capacity table. (Make sure that the cables are in good condition and suitable for power transmission. Undersized cables reduce the power transmission and heat up considerably.)
- Connect the appliance plug to the socket provided for this purpose.

14.1.5 Connection to dust collection system

NOTE



The dust collection system must start at the same time as the motor of the machine. In addition, the dust collection system must guarantee an output of at least 800 m³/h.



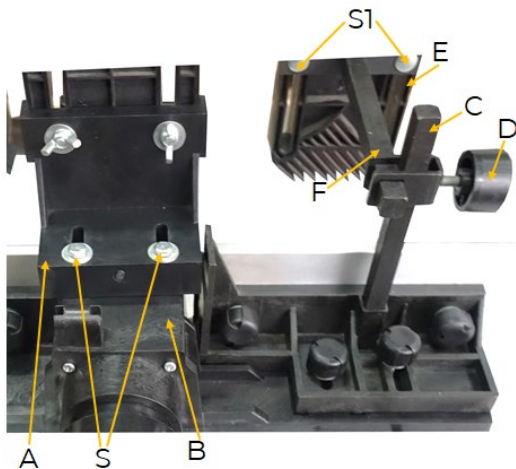
14.2 Assembling the machine

The machine is pre-assembled, the parts removed for transport must be assembled according to the following instructions and the connection to mains have to be made.

Assembly milling stop	
	1. Assembly support rods (x2) for downholder Insert the support rod into the holder of the milling stop (C; D) and fasten with the screw (S) using an Allen key (B).
	2. Assembly milling stop Insert part B into the grooves provided and fix it with screw S1. Insert the two screws S2 and insert the 4 screws S3 to fix the stops.
	3. Mounting milling stop onto machine Die Insert the two screws (S) of the assembled milling stop into the slots (B) on the machine table and fix them. Then insert the slots of the milling stops (C) into the two screws (S1) and fix them with a knob.
Assembly protective hood	
	Place the protective hood (C) on the holder (A) on the milling stop and fasten it to it using the bolt (B). The transparent protective cover protects you from possible contact with the milling cutter. Check whether the protection can be folded down and is securely fastened. Your milling stop is now completely mounted.



Assembly pressure pad and downholder

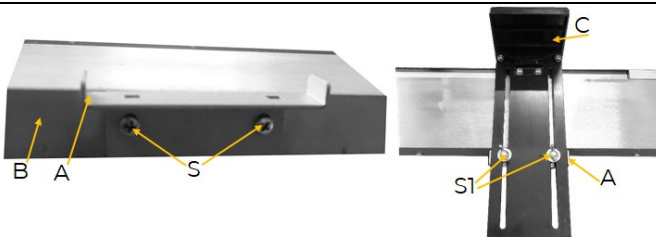


1. Mount the upper pressure pad (A) with 2 screws (S), 2 washers at the stop (B) and the two retaining rods (F) for the hold-down devices (E) to the retaining rods (C) using clamps (D).
2. The hold-down devices (E) can then be fastened to the holder (E) using screws (S1).

NOTE

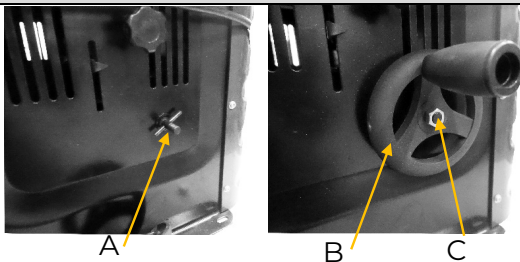


In order to mount the pressure pad, the protective hood must first be dismantled.



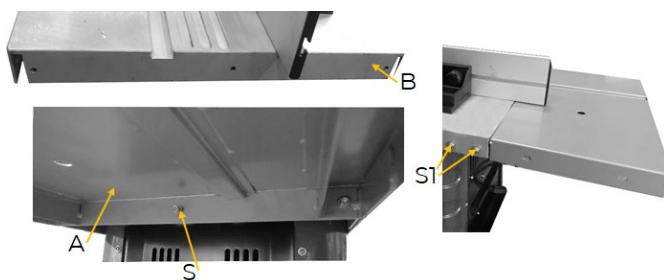
3. Fasten the bracket (A) to the machine table (B) with screws (S).
4. Fasten the pressure pad (C) to the bracket using screws (S1).

Assembly height adjustment wheel



Place the handwheel (B) on the cotter pin+bolt (A) and secure with nut C.

Assembly table extension



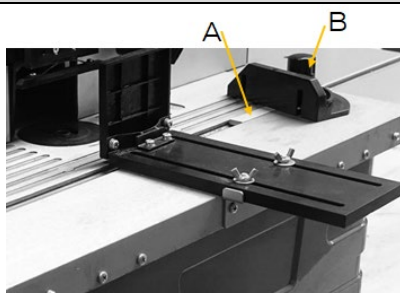
Mount the table extension (A) to the machine table (B) using 3 screws, washers (S) below and 2 screws/nuts/washers (S1) each on the right and left side.

NOTE



The table extension can be adapted to the groove on the main table and finally fixed in the appropriate position with the screw S to be able to work with the mitre gauge.

Assembly mitre gauge



Insert the guideway of the mitre gauge (A) into the groove on the table and fix the mitre gauge in position (angle+position) by tightening the screw (B).



Mounting of the machine at the workplace:

Fix the machine to a workbench using the four holes on the base of the machine.

NOTE



The bolts must be sufficiently long (taking into account the thickness of the work surface, washers/nuts). The working top must be sufficiently large and stable to prevent the machine from tilting during operation.

15 OPERATION

15.1 Operating instructions

Installing and Changing the shank router cutter adapter.

CAUTION



Before any manual handling of the machine, stop the spindles, wait for all tools to come to a standstill and prevent unintentional restarting (pull out the mains plug).

Before changing the shank router cutter adapter, disconnect the mains plug of your machine. Select the adapter that corresponds exactly to the diameter of your milling cutter/tool.

Remove the table inlet rings to gain access to the spindle. Lock the spindle in place with the knob located at the bottom of the spindle. Loosen the lock nut of the clamp using the supplied wrench. Insert or remove the clamp located in the nut. Tighten the clamp nut firmly while holding the spindle in place. Before each use of the machine, make sure that the milling tool is securely clamped at the end of the spindle. Insert the appropriate table insert rings (depending on the selected milling tool). Adjust the stop as required and connect to a dust collection system. Reconnect the machine to the mains.

Adjusting the stop

Each work must be considered separately.

For each new use, make sure that the guards are properly installed and adjusted. With each new use, each pressure piece on the stop must be readjusted.

Make sure that each screw is well tightened before you start milling.

Usage of the table insert rings

The table insert rings must be used to reduce the distance between the table and the spindle to a minimum. Before switching on the machine, you must systematically check that the supplied table rings are correctly installed. Check that you have selected the appropriate table ring for the milling tool and its installation height to reduce the risk of tilting of the workpiece when passing through the hole. The table ring must surround the cutter as far as possible

Adjusting the spindle speed

The machine has 6 steps for adjusting the spindle speed, desired speed and can be selected by wheel (A).

	Spindle speed f (steps)					
	1: 11500min ⁻¹		4: 18000min ⁻¹			
	2: 13000min ⁻¹		5: 21000min ⁻¹			
	3: 15500min ⁻¹		6: 24000min ⁻¹			

Determine the optimum speed by making a test cut on a sample piece. The table on the machine serves as a guideline. The first column in the table shows the cutting speed depending on the selected milling diameter and spindle speed. In the second column there is a recommendation of the speed to be selected as a function of the milling diameter and type of wood.

	20	12	14	16	19	22	25
40	24	27	32	38	44	50	
50	30	34	41	47	55	63	
 n(min ⁻¹)	11500	13000	15500	18000	21000	24000	

material	Cutting tool ø mm	rpm- selection
Hardwood (eg beech, yew)	4-10	5-6
	12-20	3-5
	22-40	1-2
Softwood (eg spruce, pine)	4-10	5-6
	12-20	3-6
	22-40	1-3

**NOTE**

Using the correct speed increases the service life of the milling cutter. It also affects the machined surface on the part.

Adjusting the milling stop

The stop must be adjusted to the size of the workpiece and the milling tool.

Loosen the two plastic screws on the back of the stop.

Push the stop into the desired position.

Retighten the two plastic head screws on the back to hold the stop in this position.

Setting the stop for rabbet cuts

The material coming out to the left of the router is thinner than the material on the right. The left stop bar must be adjusted to fit the thinner material. This supports the material and ensures a more accurate cut. To do this, loosen the plastic head screws, move the stop forward and clamp it in place.

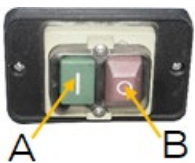
Installing and adjusting the pressure pads

The pressure pads are designed to hold the workpiece in place and prevent recoil.

Adjusting the miter gauge

The miter gauge slides in the groove along the table. It is used to make rabbet and miter cuts. To set the miter fence to the desired angle, loosen the plastic knob on it and turn it to the desired angle. Then tighten it again.

Always make a test cut on a sample piece to make sure that the settings are correct.

15.2 Starting / stopping the machine**Start procedure**

1. Adjusting the machine (spindle speed, cutting tool, spindle height, pressure pads, stops) for upcoming operation.
2. Press green-button (A) for start.

Stopp procedure

1. Press red-button (B) for stopping the machine.

15.3 Operation

Assembly and secure the cutter tool.

- Adjust speed, cutting depth, pressure pads, stop and mitre gauge.
- Make sure that the stop is correctly adjusted to support the material which is actual not cut. Adjust the output stop to support the cut material, compensating for the material removed.
- Start the machine.
- Make sure that the workpiece is pressed firmly against the stop.
- Slide the workpiece softly from right to left against the direction of rotation of the tool.
- Keep the feed speed constant. Do not push too fast, this would slow down the motor too much.
- If you push too fast, you may achieve poor cut quality. It could also damage the cutter or the motor.
- If you push too slowly, fire marks may appear on the workpiece.
- With very hard wood and large cuts, it may be necessary to do more than one operation to achieve the desired depth.
- The correct feed speed depends on the cutter size, the type of material of the workpiece and the cutting depth. Practice first with a piece of waste material to find the correct feed rate and dimensions.
- When the operation is complete, stop the machine.



16 CLEANING, MAINTENANCE, STORAGE, DISPOSAL

16.1 Cleaning

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.

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

- Therefore, clean the machine after each use, but at least once a week and remove any sawdust with a brush, broom or vacuum cleaner.

16.2 Maintenance

WARNING



Handling the machine with the power supply up can lead to serious injuries or even death.

- Always disconnect the machine from the power supply before servicing or maintenance work and secure it against unintentional or unauthorised reconnection!

The machine is low-maintenance and only a few parts have to be serviced. Nevertheless, malfunctions or defects which could impair the safety of the user must be rectified immediately!

- Before each operation, check that the safety devices are in perfect condition.
- Check the connections for tightness at least once a week.
- Regularly check that the warning and safety labels on the machine are in perfect and legible condition.

16.2.1 Tool exchange (collet and milling cutter)

CAUTION



Before any manual tool change, stop the spindles, wait for all tools to come to a standstill and prevent unintentional restart.

Collet (shank router cutter adapter)

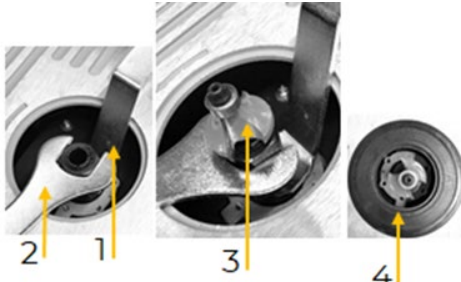


Select the collet ($\varnothing 6$ mm, $\varnothing 8$ mm or $\varnothing 12$ mm) that corresponds exactly to the diameter of your milling cutter (1).
Move the spindle to the highest position using the handwheel.
Remove the table ring inlays (2) to gain access to the spindle.

Position the cranked open-end wrench on the flattened part of the spindle to lock it in place (3).
Loosen the locking nut of the collet chuck with the open-end wrench (4).
Remove the collet and insert the selected collet (1) into the spindle holder.
Tighten the collet nut firmly while holding the spindle in place (4).



Milling cutter

	Position the cranked open-end wrench on the flattened part of the spindle to lock it in place (1). Loosen the locking nut of the collet slightly with the open-end wrench (2). Remove or insert the appropriate milling tool into the collet (3). Tighten the collet nut (2) while fixing the spindle (1). Depending on the milling cutter size, insert the table ring inlays to minimize the distance between the table and spindle (4).
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16.3 Storage

NOTE



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

In case of a longer interruption of operation or shutdown, clean the machine and then store it out of the reach of children in a dry place protected from frost and other weather influences!

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.

→ Disconnect the machine from the power supply before starting work to eliminate defects!

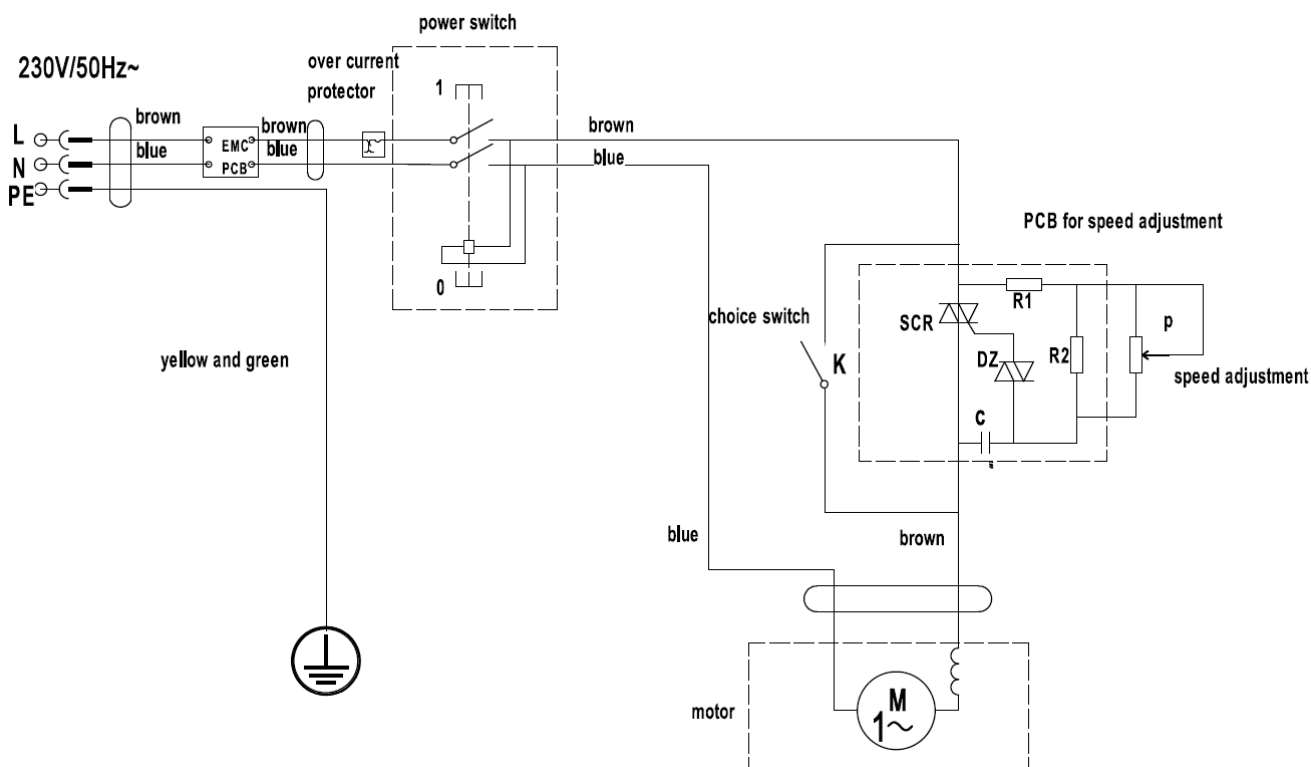
Many possible sources of error can be excluded in advance if the machine is properly connected to the mains. If you are unable to carry out necessary repairs properly and/or do not have the required training, always consult a specialist to correct the problem!



Trouble	Possible cause	Solution
Machine cannot be switched on	• No mains voltage available • Carbon brushes worn out	• repair switch • check power supply, replace fuse or switch contactor if necessary
The machine switches off automatically during idling	• Mains failure	• Check mains-side fuse • Due to undervoltage protection, the machine does not restart automatically and must be switched on again after voltage recovery.
Machine stops during machining	• overload protection activated due to blunt tools or excessive feed or chip thickness	• Before continuing work, replace the tool and wait for the motor to cool down.
Speed drops during machining	• Too much chip removal • Feed rate too high • Blunt tool	• Reduce chip removal • Decrease feed rate • Replace tool
Badly milling surface	• Blunt tool • Uneven feed rate	• Replace tool • Work with reduce feed rate and constant pressure
Dust collector port clogs (without dust collection system)	• Too much chip removal • Blunt tool • Too wet wood	• Reduce chip removal • Replace tool



39 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM CABLEADO / SCHEMA ELECTRIQUE / PLÁN ZAPOJENÍ



40 ERSATZTEILE / SPARE PARTS

PIEZAS DE RECAMBIO / PIÈCES DE RECHANGE / NÁHRADNÍ DÍLY

40.1 Ersatzteilbestellung / spare parts order

Pedido de piezas / Commande de pièces détachées / Objednávka náhradních dílů

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

HINWEIS



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

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

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

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



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

NOTE



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

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

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

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

(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 – SOLICITUD DE PIEZAS DE RECAMBIO,
- por correo electrónico a 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.

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

AVIS



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

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

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

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

(CZ) S náhradními díly HOLZMANN používáte náhradní díly, které jsou ideálním způsobem vzájemně zkoordinovány. Optimální přesnost lícování dílů zkracuje dobu montáže a prodlužuje životnost.

OZNÁMENÍ



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

Náhradní díly objednávejte přímo na naší domovské stránce – kategorie NÁHRADNÍ DÍLY.

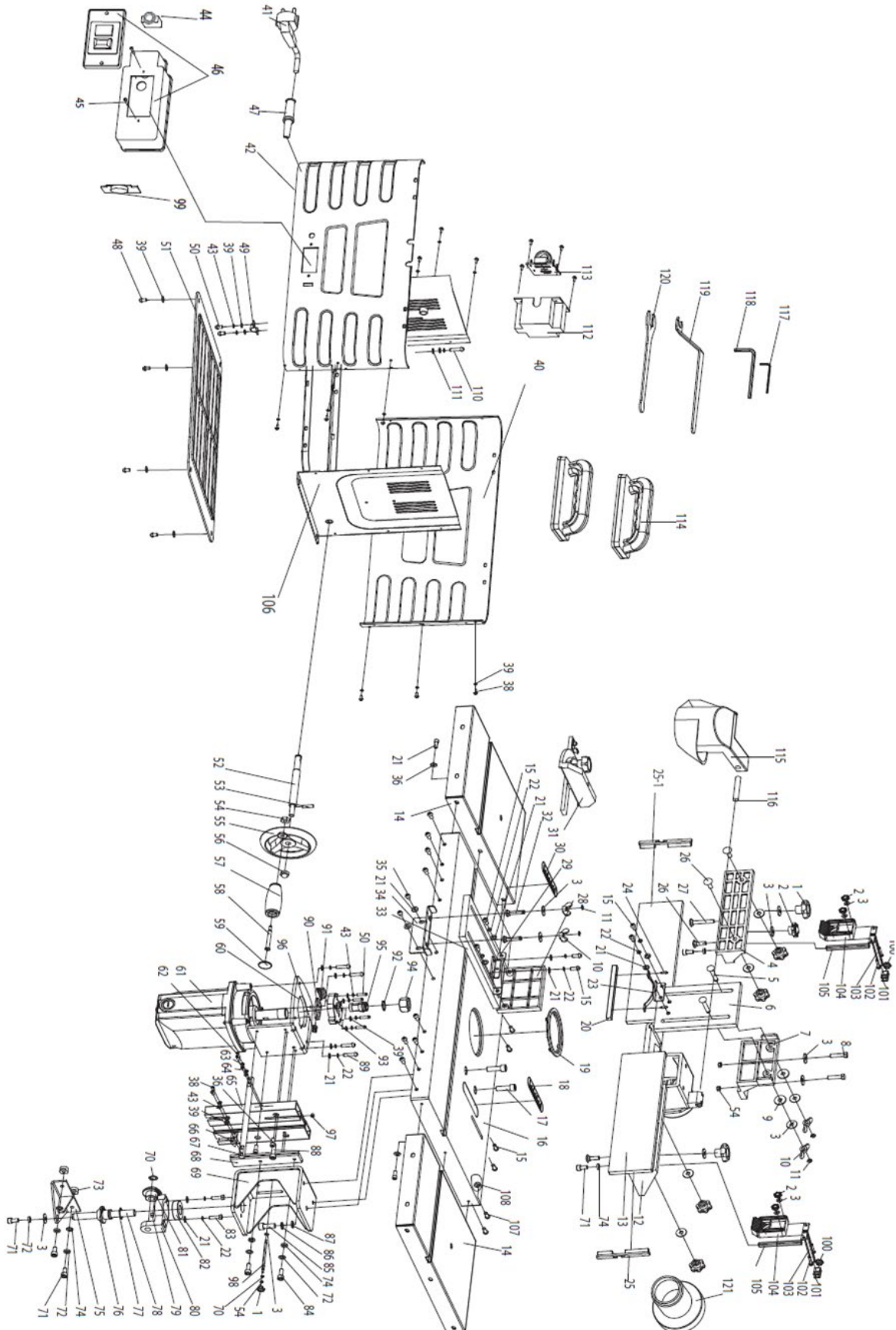
nebo kontaktujte náš zákaznický servis

- přes naši domovskou stránku – kategorie SERVIS – ŽÁDOST O NÁHRADNÍ DÍLY,
- e-mailem na service@holzmann-maschinen.at.

Vždy uveďte typ stroje, číslo náhradního dílu a označení. Abychom předešli nedorozumění v případě, že nepožadujete náhradní díly prostřednictvím online katalogu náhradních dílů - přiložte výkres náhradních dílů, na kterém jsou požadované náhradní díly zřetelně vyznačeny.



41.1 Explosionszeichnung / Exploded view Vista de despiece / Vue éclatée / Rozpadový výkres





41.2 Ersatzteilliste / Spare part list

Listado de piezas de recambio / Liste des pièces de rechange / Seznam náhradních dílů

No.	Description	Qty.	No.	Description	Qty.
1	Transverse Locking Lever Locking Handle	1	61	Motor 230-240V	1
2	Lock Handle	11	62,63,64	Hexagon Socket Cap Screws, Washer M4*10	2
3	Big Washer $\phi 6$	25	65	Guide Profiles	1
4	Clamping Support	1	66,67	The Long Pointer	1
5	Round Head Low Square Neck Carriage Bolts 6*25	3	68	The Motor Rise And Down Conducting Bar	1
6	Pressing Plate	1	69	Motor Fixed Plate Assembly	1
7	The Long Pressing Plate Support	1	70A	Rise And Fall Cushion Cover	1
8	Hexagon Bolt M6*40	2	70	Ring $\phi 10$	2
9	Big Washer6	2	71	Hexagon Socket Cap Screws, Spring Washer, Washer M6*16	2
10	Butterfly Nut M6	4	73	Hex Nut M6	2
12	The Big Support Assembly	1	75	Support Assembly	1
13	Baffle Aluminum	2	76	Bevel Gear	1
14-1	The Side Extension Worktable 1 Assembly	1	77	Ring $\phi 17$	1
14-2	The Side Extension Worktable 2 Assembly	1	78	Rise And Down Turn Screw	1
15	Hexagon Socket Cap Screws 5*20	8	79	Key 4*4*6.5	1
15	Cross Recess Pan Head Screw 5*12	8	80	Bevel Gear Support	1
15	Cross Recess Pan Head Screw, Spring And Washer M5*12	4	81	Rise And Down Shaft Gear	1
16	Worktable	1	82	Bearing 6003RZ	1
17	Hexagon Socket Cap Screws 8*25	2	83	Hexagon Bolt 5*16-8.8 class	2
18	Scaleplate	1	83	Hexagon Bolt 5*16-8.8 class	2
19	Table Round Cover Plate Assembly	1	84	Hexagon Socket Cap Screws, Spring Washer, Washer M6*15	2
20	The Small Pressing Plate Conducting Bar	1	85	Hexagon Socket Cap Screws 8*14	1
21	Hexagon Socket Cap Screws 5*12	6	86	Spring Washer	1
23	The Small Pressing Plate Connecting Assembly	1	87	Washer	1
24	The Cross Recessed Head Is Self-Tapping ST2.9*8	6	88	Hexagon Socket Cap Screws 5*25	1
25	The Right End Cap	2	89	Cross Recess Pan Head Screw, Spring Washer, Washer Couple M5*15	4
25-1	The Left End Cap	2	90	Locking Piece	1
26	Semicircular Head Low Square Neck Bolt 6*20	7	91	The Handle Of Locking Piece	1
27	Semicircular Head Low Square Neck Bolt 6*35	1	93	The Lock Cover	1
28	The Long Pressing Plate Assembly	1	92,94,95	Chuck	1
29	The Long Pressing Plate Connecting Assembly	1	92,94,95	Chuck	1
30	Scaleplate	1	96	Spring	1
31	Index Plate Assembly	1	97	Sliding Block	1
31	Spring Washer $\phi 6$	1	98	Lock Rod	1
31	Washer $\phi 4$	1	99	Circuit Board V	1
31	Cross Recess Pan Head Screw, Spring And Washer M5*8	1	100	The Lock Handle	2
33	The Long Pressing Plate Assembly	1	101	U Weld Assembly	2
34	The Short Pressing Plate Support	1	102	Semicircular Head Low Square Neck Bolt M6x35	5
36	Washer $\phi 5$	6	103	T Weld Assembly	2
38	Cross Recess Pan Head Screw, Spring And Washer M4*10	14	104	Pressing Block	2
40	The Support In Behind	1	105	Shore	2
41	Plug 3*1*2.5m	1	106	Base Assembly	1
42	The Support In Front	1	107	Hexagon Socket Cap Screws, Spring Washer, Washer M5*12	8
44	Overcurrent Protective Device 250V7A	1	108	Lock Nut M5	10



45	The Cross Recessed Head Is Self-Tapping ST3.5*12	6	109	Cross Recess Pan Head Screw 4*8	3
46	Switch Box Assembly	1	110	Cross Recess Pan Head Screw, Spring Washer, Flatwasher M4*8	1
47	Power Line Sheath	1	111	Ring4	3
48	Cross Recess Pan Head Screw, Big Washer Couple M4*10	4	112	Transformer Box	1
49	Tension Disc	1	113	Circuit Board W	1
50	Cross Recess Pan Head Screw M4*18	2	114	Hand Slap	2
51	Baseplate	1	115	Plastic Cover	1
52	Rise And Fall Shaft	1	116	Pin 6*35	1
53	Pin 4*25	1	117	Allen Wrench S4*63	1
54	Lock Nut M6	3	118	Allen Wrench S5*80	1
55	Pilot Wheel	1	119	Wrench	1
56	Acorn Nut M8	1	120	Wrench	1
57	Handle	1	121	Control Of Dust	1
58	Handle Bush Assembly	1	122	The Cross Recessed Head Is Self-Tapping ST2.9*8	1
59	Handle Cover	1	123	Cross Recess Pan Head Screw M5x16	2
60	Motor Connect Plate	1	124	Hex Nut M5	2
12			31		
12	The Big Support Base	1	31-1	Point	1
12-1	Dowel	1	31-2	Lock Handle	1
12-2	Wire Entanglement	1	31-3	Index Plate	1
12-3	Small Plate Head Screw With Cross Groove	1	31-4	Conducting Bar	1
12-4	The Big Support Base M4*12	4			
			46	Switch	1
19			46-1	Box VSM-50	1
19-1	Table Top Plate a	1	46-2	Switch Box Cover VSM-50	1
19-2	Table Top Plate b	1			
19-3	Table Top Plate c	1	58		
19-4	Table Top Plate d	1	58	Handle Bush	1
			58	Cross Recess Pan Head Screw 6*651	1