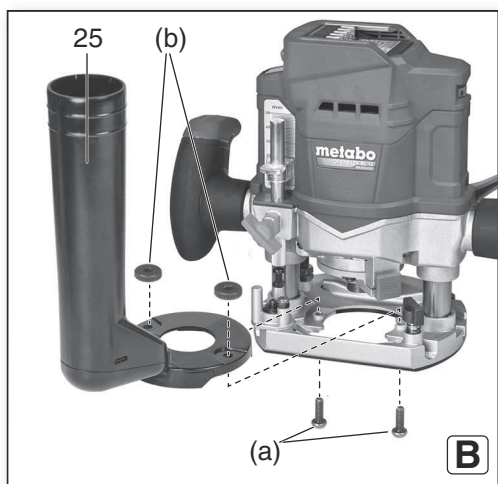
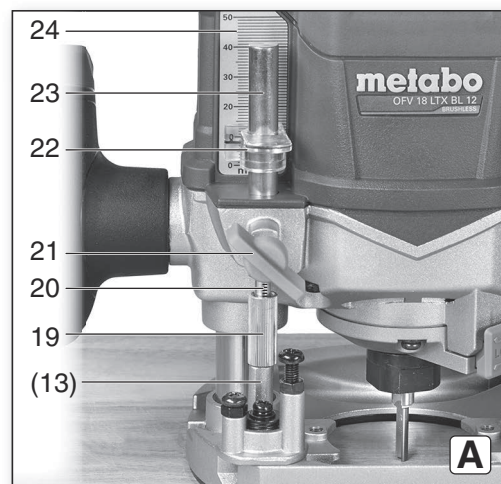
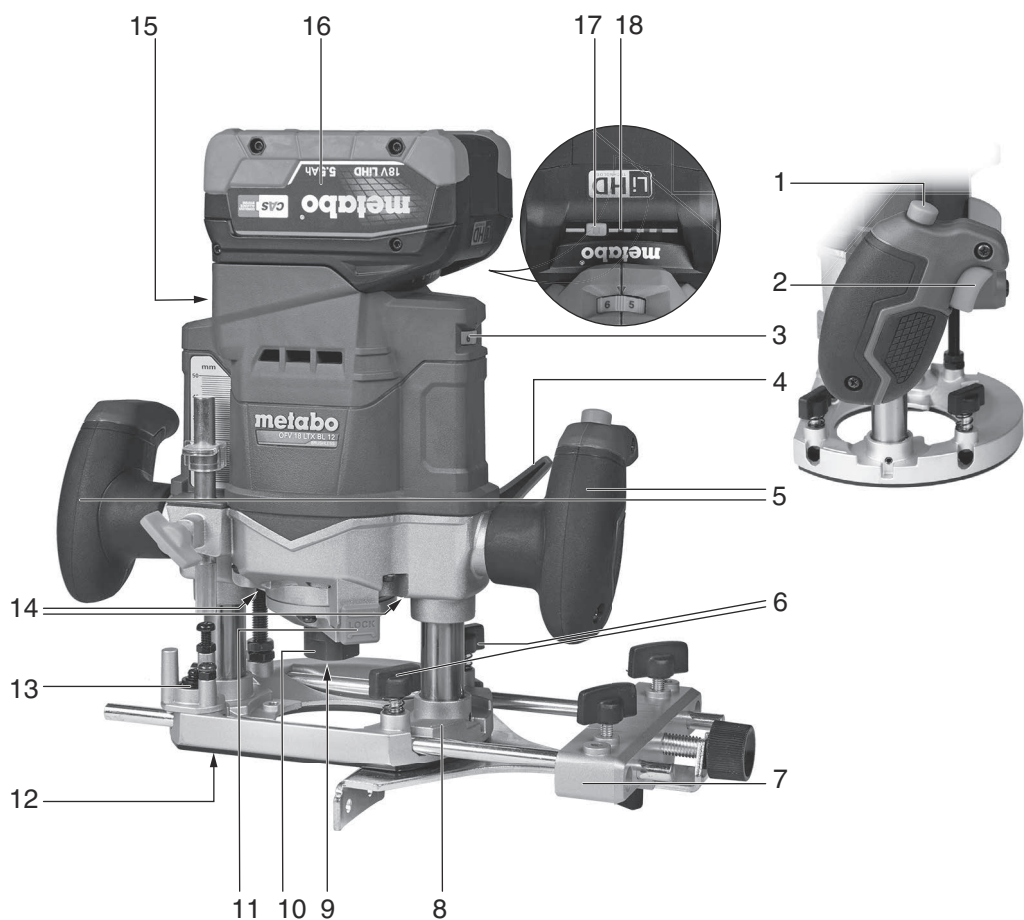


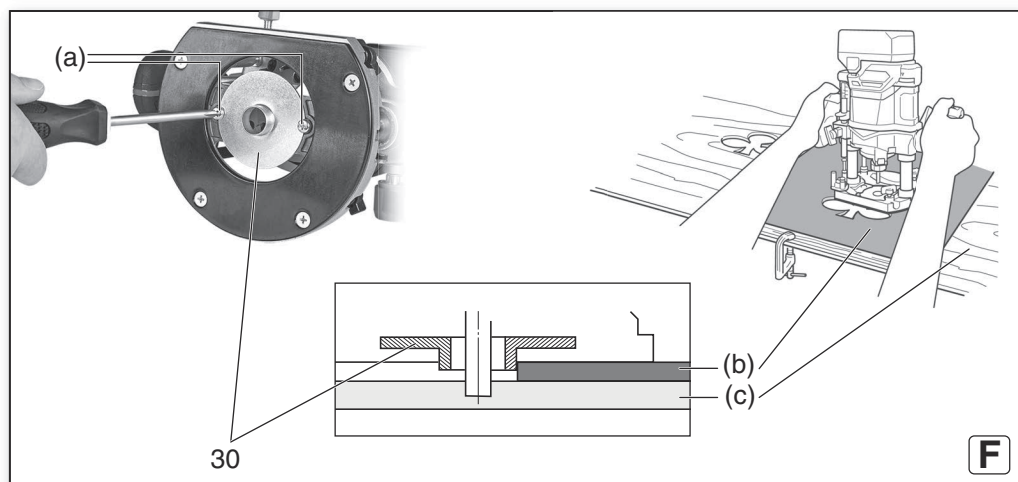
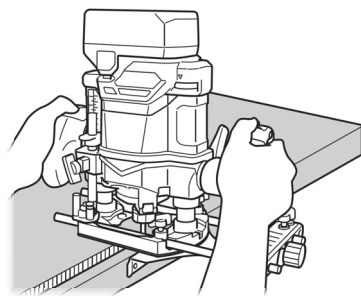
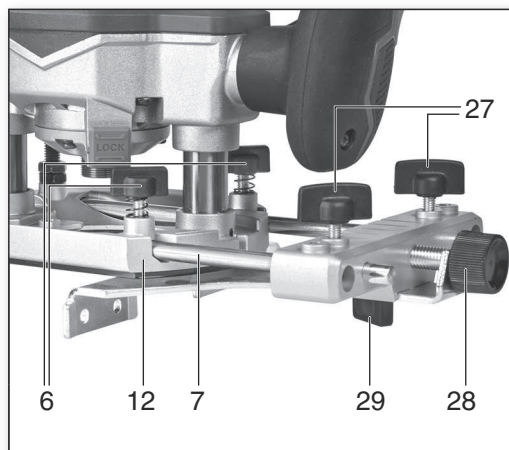
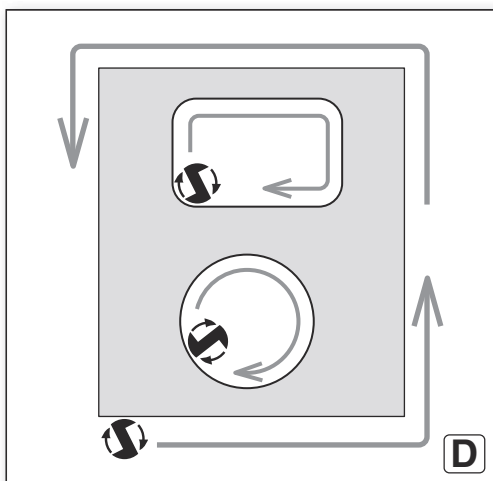
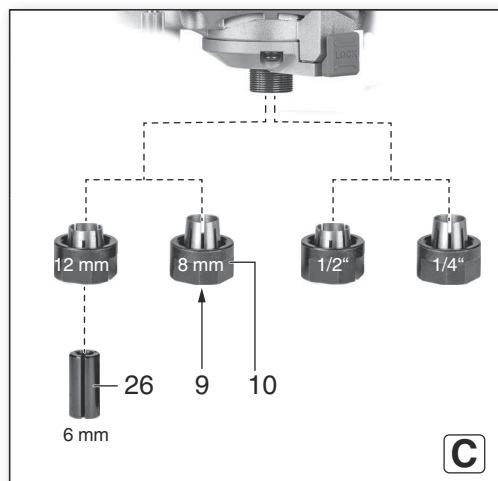
OFV 18 LTX BL 12





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		OFV 18 LTX BL 12
*1) Serial Number		01743..
U	V	18
n₀	1/min (rpm)	11000 - 25000
H_{max}	mm (in)	50 (1 ³⁰ / ₃₂)
d	mm / in	6, 8, 12 / 1/2", 1/4"
m	kg (lbs)	3,9 (8.6)
a_h/K_h	m/s²	4,8 / 1,5
L_{pA}/K_{pA}	dB(A)	94 / 3
L_{WA}/K_{WA}	dB(A)	102 / 3

	n₀ (/min)
1	11000
2	13800
3	16600
4	19400
5	22200
6	25000



*2) 2014/30/EU, 2006/42/EC, 2011/65/EU
 *3) EN 62841:2015, EN 62841-2-17:2017, EN IEC 63000:2018

ppa. B.F.

2024-09-03, Bernd Fleischmann
 Chief Technology Officer Koki Holdings Co., Ltd.

*6) Metabowerke GmbH - Metabo-Allee 1 - 72622 Nuertingen, Germany

Original instructions

1. Declaration of Conformity

We, being solely responsible, hereby declare: these routers, identified by type and serial number *1), meet all relevant requirements of directives *2) and standards *3). Technical documents for *4) - see page 4.

2. Specified Conditions of Use

The router is suited for cutting wood, wood-like materials and plastic.

The user bears sole responsibility for any damage caused by inappropriate use.

Generally accepted accident prevention regulations and the enclosed safety information must be observed.

3. General Safety Information



For your own protection and for the protection of your power tool, pay attention to all parts of the text that are marked with this symbol!



WARNING – Read the operating instructions to reduce the risk of injury.



WARNING – Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

Always include these documents when passing on your power tool.

4. Special Safety Instructions

4.1 Safety instructions for routers

a) **Use clamps or another practical way to secure and support the workpiece to a stable platform.** Holding the workpiece by hand or against your body leaves it unstable and may lead to loss of control.

4.2 Additional safety instructions



Wear a suitable dust protection mask.



Wear ear protectors.



Wear protective goggles.

Remove the battery pack from the tool before any adjustments, conversions, servicing or cleaning are performed.

The clamping lever (4) must always be tightened well when working with the machine.

Do not try to machine extremely small workpieces. Smaller workpieces must be secured in such a way that they do not get loose when working with the machine (e.g. using screw clamps).

Check the workpiece for foreign bodies. When working, always make sure that no nails or other similar materials are being cut into.

Keep your hands away from the rotating tool! Remove debris and similar material only when the machine is at a standstill.

Do not touch the cutter straight after use. It can be very hot and cause burns to your skin.

Danger of injury from the sharp edges of the cutter.

Press the spindle locking button only when the motor is at a standstill and the battery pack has been removed.

Materials that generate dusts or vapours that may be harmful to health (e.g. asbestos) must not be processed.

Connect a suitable extraction device.

LED light (14): do not observe the LED radiation directly with optical instruments.



CAUTION Do not stare at operating lamp.

Reducing dust exposure:



WARNING - Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints,
- crystalline silica from bricks and cement and other masonry products, and
- arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

This also applies to dust from other materials, such as some timber types (like oak or beech dust), metals, asbestos. Other known diseases are e.g. allergic reactions, respiratory diseases. Do not let dust enter the body.

Observe the relevant guidelines and national regulations for your material, staff, application and place of application (e.g. occupational health and safety regulations, disposal).

Collect the particles generated at the source, avoid deposits in the surrounding area.

Use suitable accessories for special work. In this way, fewer particles enter the environment in an uncontrolled manner.

Use a suitable extraction unit.

Reduce dust exposure with the following measures:

- do not direct the escaping particles and the exhaust air stream towards yourself or nearby persons or towards dust deposits,
- use an extraction unit and/or an air purifier,
- ensure good ventilation of the workplace and keep it clean using a vacuum cleaner. Sweeping or blowing stirs up dust.
- Vacuum or wash protective clothing. Do not blow, beat or brush protective gear.

4.3 Special safety instructions for cordless tools:



Protect battery packs from water and moisture!



Do not expose battery packs to fire!

Do not use faulty or deformed battery packs!

Do not open battery packs!

Do not touch or short circuit battery pack contacts!



A slightly acidic, flammable fluid may leak from defective Li-Ion battery packs!



If battery fluid leaks out and comes into contact with your skin, rinse immediately with plenty of water. If battery fluid leaks out and comes into contact with your eyes, wash them with clean water and seek medical attention immediately!

If the machine is defective, remove the battery pack from the machine.

Transport of Li-Ion battery packs:

The shipping of Li-Ion battery packs is subject to laws related to the carriage of hazardous goods (UN 3480 and UN 3481). Inform yourself of the currently valid specifications when shipping Li-Ion battery packs. If necessary, consult your freight forwarder. Certified packaging is available from Metabo.

Only send the battery pack if the housing is intact and no fluid is leaking. Remove the battery pack from the machine for sending. Prevent the contacts from short-circuiting (e.g. by protecting them with adhesive tape).

5. Overview

See pages 2 and 3.

- 1 Switch lock / lock button
- 2 Trigger switch
- 3 Speed adjustment wheel
- 4 Clamping lever (cutting depth)
- 5 Knob handle (to hold)
- 6 Wing screws (for parallel guide)
- 7 Parallel stop
- 8 Arrow (shows the direction of rotation of the cutter)
- 9 Collet chuck*

- 10 Collet chuck nut*
- 11 Spindle locking button (to lock the milling spindle)
- 12 Footplate
- 13 Three-state depth guide (cutting depth)
- 14 LED light (worklight) / electronic signal display
- 15 Battery pack release button
- 16 Battery pack*
- 17 Capacity indicator button *
- 18 Capacity and signal indicator *
- 19 Knurled screw (fine adjustment of the cutting depth)
- 20 Scale (fine adjustment of the cutting depth)
- 21 Wing screw (cutting depth)
- 22 Cutting depth indicator (cutting depth)
- 23 Pin (cutting depth)
- 24 Scale (cutting depth)
- 25 Extractor connection piece
- 26 Reducing sleeve*
- 27 Wing screws (parallel guide)
- 28 Setting screw (fine adjustment)
- 29 Wing screw (fine adjustment)
- 30 Template followers

* depending on the country / features

6. Initial Operation and Setting

6.1 Inserting the cutter



The high speed of the machine requires high-quality cutters (HSS or carbide).



Only use cutters that are suited to the speed of your machine. See chapter "Technical data".



Only use cutters the shaft diameter of which matches the collet bore of the collet chuck. If necessary, change the collet chuck, see chapter 6.5.



The collet chuck nut may only be tightened by hand if no cutters are used.



Do not use blunt or damaged cutters.

1. Remove battery pack.
2. Push the cutter into the collet chuck (9) until the entire cylindrical part of its shaft is enclosed by the collet chuck (9).
3. Locking the milling spindle: Push spindle locking button (11) and keep pressed. Slowly turn the collet chuck nut (10) until the lock engages.
4. Firmly tighten the collet chuck nut (10) using the open-end wrench provided for this purpose.
5. Release the spindle locking button (11).

6.2 Adjusting the cutting depth



Clean and safe cutting is achieved with a maximum cutting depth of 6 mm. This also protects the motor from overloading. Greater cutting depths can be achieved with several rounds.

1. Remove battery pack.
2. Loosen the clamping lever (4) and guide the motor part downwards until the milling cutter sits on the workpiece. Retighten the clamping lever (4).

See fig. A:

3. Release the wing (21) screw. Guide the pin (23) downwards until it rests on a stop of the three-stage depth guide (13). Retighten the wing screw (21).
4. Move the cutting depth indicator (22) in such a way that the read-off marking points to the 0-point of the scale (24).
5. Release the wing (21) screw. Push the pin (23) upwards to that the read-off marking shows the desired cutting depth on the scale (24). Retighten the wing screw (21).
6. Fine adjustment: If needed turn the knurled screw (19) and read the clearance on the scale (20).
7. When working, the desired cutting depth is achieved if the motor part is guided downwards until the stop after the clamping lever (4) is loosened.

Using the three-stage depth guide (13), 3 different cutting depths can be preset.

6.3 Setting speed

The speed can be set via the thumb-wheel (3) and is infinitely variable.

Speeds when idle, see table, page 4.

6.4 Attach the chip extraction

If an extraction unit is used, attach the extraction nozzle (25). **See fig. B.**

1. Remove battery pack.
2. Removing the cutter.
3. Fit the extraction nozzle (25) as shown to the machine: Screw 2 long screws (a) from below into the foot plate. Place the extraction nozzle (25) from the top on the 2 screw threads and fix with the 2 knurled screws (b).
4. To extract the saw chips, connect a suitable extraction unit with suction hose to the connection piece. Use a hose adapter if necessary.

6.5 Replace the collet chuck (depending on the features)

See fig. C.

1. Remove battery pack.
2. Unscrew the collet chuck nut (10)
3. Replace the collet chuck (9) with the other collect chuck supplied.
4. Screw on the collet chuck (10) only by hand, do not tighten.

To use cutter with 6-mm shaft:

Fit the supplied 12 mm collet chuck (depending on the features). To this end, insert the supplied, original Metabo reducing sleeve (26) (depending on features) deep into the 12 mm collet chuck (it must be flush with the collet chuck (9)). The insert the cutter with 6-mm shaft into the reducing sleeve.

6.6 Battery pack

Charge the battery pack (16) before use.

Recharge the battery pack if performance diminishes.

Instructions on charging the battery pack can be found in the operating instructions of the Metabo charger.

Battery packs have a capacity and signal indicator (18) (depends on design variant):

- Press the button (17), the LEDs indicate the charge level.
- The battery pack is almost empty and must be recharged if one LED is flashing.

Removing and inserting the battery pack

Removing:

Press the battery pack release (15) button and remove the battery pack (16).

Inserting:

Slide in the battery pack (16) until it engages.

7. Use


7.1 Switching on and off

Instantaneous operation: Press the locking button (1) and keep pressed, then press the trigger (2). Release the locking button (1).

To switch off release the trigger switch (2).


Continuous operation:

With the trigger (2) pressed, push in the locking button (1) and then released the trigger (2). Press and release the trigger (2) again to switch off.

 In continuous operation, the machine continues running if it is forced out of your hands. Therefore, always hold the machine with both hands using the handles provided, stand securely and concentrate.

7.2 Working Directions

Machine use

 Hold the machine firmly on both knob handles (5).

Place the machine onto the workpiece without the cutter touching the workpiece. Switch on machine and wait until the full speed has been reached. Only then allow the cutter to penetrate the workpiece. To fix the milling depth, tighten the clamping lever (4). The foot plate (12) glides onto the workpiece.

Feed direction

Always work in the opposite direction. Always push the machine forwards as shown. See fig. D.

The direction of rotation of the cutter is indicated by an arrow (8) on the machine.

Guide the machine evenly at a speed suitable for the material being processed.

7.3 Putting down after use

After finishing the milling process, switch off the router and release the clamping lever (4). Then the motor is pressed upwards by the springs in the columns and the machine can be put down.

7.4 Special working methods:

Cutting with parallel guide (fig. E)

1. If required, fit the wing screws (6):
Put the spring onto the thread, then screw in.
2. Push the parallel guide (7) into the grooves on the base plate (12) and fix with the two wing screws (6).
3. Loosen the wing screws (27) and roughly set the desired distance between the stop bar of the parallel guide and the cutter. Tighten the wing screws (27).
4. Release the wing (29) screw. Finely adjust the desired distance with the adjusting screw (28). Tighten the wing screw (29).

If required, carry out a trial cut.

Template follower (Fig. F)

For cutting according to a template fixed on the workpiece.

5. Insert the template follower (30) as shown and fix with 2 short screws (a).
6. Attach a template (b) on the workpiece (c). Place the machine on the template and guide it so that the template follower (30) glides along the edge of the template (b).

Milling from the workpiece edge.

1. Use routers with a thrust ring.
2. Release the clamping lever (4) and lower the motor part of the switched-on router to the desired milling depth.
3. To fix the milling depth, tighten the clamping lever (4) and push the machine forward.

Milling along a strip attached to the workpiece / milling along a straight marking

1. Attach a strip on the workpiece and guide the router with a straight edge of the foot plate along the strip. (Always use the same edge.)

Mill grooves and fillets from the centre of the workpiece

1. Release the clamping lever (4) and lower the motor part of the switched-on router to the desired milling depth.
2. To fix the milling depth, tighten the clamping lever (4) and push the machine forward.

Profile milling

1. When working with profile cutters, first remove a larger chip and then a smaller chip.
2. The feed rate must not be too low, otherwise the wood will scorch and the cutter will become prematurely blunt.

8. Cleaning, Maintenance



Remove battery pack.

Dust deposits must be regularly removed from the machine. This includes vacuum cleaning the ventilation louvers on the motor.

9. Troubleshooting

Electronic signal display (14) off, continuous beeping, the machine is not running:

Restart protection:

Restart protection is active. The machine will not start if the battery pack is inserted while the machine is on. Switch the machine off and back on again.

Fast flashing, fast beeping, the machine was switched off automatically:

Overload protection:

The overload protection protects the motor from overheating. Switch the machine off and then on again and continue to work with smaller feed or reduced cutting depth.

Slow flashing, no beeping:

Battery pack almost empty: Charge the battery pack soon.

Slow flashing, slow beeping:

Battery pack empty: Charge battery pack.

10. Accessories

Use only original Metabo or CAS (Cordless Alliance System) battery packs and accessories.

Use only accessories that fulfil the requirements and specifications listed in these operating instructions.

Chargers: ASC 145, etc.

Battery packs with different capacities. Buy battery packs only with voltage suitable for your power tool.

4.0 Ah (LiHD), order no.: 625367000

5.5 Ah (LiHD), order no.: 625368000
etc.

5.2 Ah (Li-Ion), order no.: 625028000
etc.

For the complete range of accessories, see www.metabo.com or the main catalogue.

11. Repairs



Repairs to electrical tools must only be carried out by qualified electricians!

Contact your local Metabo representative if you have Metabo power tools requiring repairs. For addresses see www.metabo.com.

You can download a list of spare parts from www.metabo.com.


12. Environmental Protection

Observe national regulations on environmentally compatible disposal and on the recycling of disused machines, packaging and accessories.

Packaging materials must be disposed of according to their labelling in accordance with municipal guidelines. Further information can be found at www.metabo.com in the "Service" section.

Battery packs may not be disposed of with regular waste. Return faulty or used battery packs to your Metabo dealer!

Do not allow battery packs to come into contact with water!

 Only for EU countries: never dispose of power tools in your household waste! According to European Directive 2012/19/EU on Waste from Electric and Electronic Equipment and implementation in national law, used power tools must be collected separately and recycled in an environmentally-friendly manner. Discharge the battery pack in the power tool before disposal. Prevent the contacts from short-circuiting (e.g. by protecting them with adhesive tape).

The noise level can exceed 80 dB(A) during operation.



Wear ear protectors!

13. Technical Specifications

Explanatory notes regarding the specifications on page 3.

Subject to change in accordance with technical progress.

U = Voltage of battery pack
 n_0 = rated no load speed
 H_{\max} = max. stroke height
 d = collet bore of the supplied collet chuck (specific to country / depending on features)
 m = weight (with the smallest battery pack)

Measured values determined in conformity with EN 62841.

Permitted ambient temperature during operation: 0 °C (-4°F) to 40 °C (120°F) (limited performance with temperatures below 0 °C (32°F)). Permitted ambient temperature for storage: 0 °C (32°F) to 30 °C (86°F).

Recommended ambient temperature when charging: 0 °C to 40 °C.

== direct current

The technical specifications quoted are subject to tolerances (in compliance with relevant valid standards).



Emission values

These values make it possible to assess the emissions from the power tool and to compare different power tools. The actual load may be higher or lower depending on operating conditions, the condition of the power tool or the accessories used. Please allow for breaks and periods when the load is lower for assessment purposes. Arrange protective measures for the user, such as organisational measures based on the adjusted estimates.

Vibration total value (vector sum of three directions) determined in accordance with EN 62841:

a_h = vibration emission value
 (Slot milling in MDF)

K_h = uncertainty (vibration)

Typical A-effective perceived sound levels:

L_{pA} = Sound pressure level

L_{WA} = Acoustic power level

K_{pA} , K_{WA} = Uncertainty