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Originalfassung

**DE BETRIEBSANLEITUNG**

Übersetzung / Translation

**EN USER MANUAL**

**ELEKTRISCHES  
BOHRERSCHÄRFGERÄT**

**ELECTRIC DRILL BIT SHARPENER**



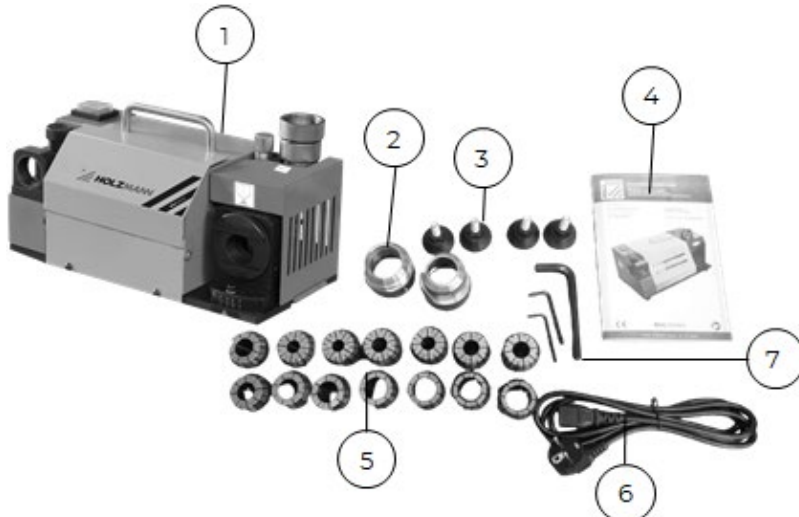
**BSG13PRO\_230V**  
**BSG26PRO\_230V**





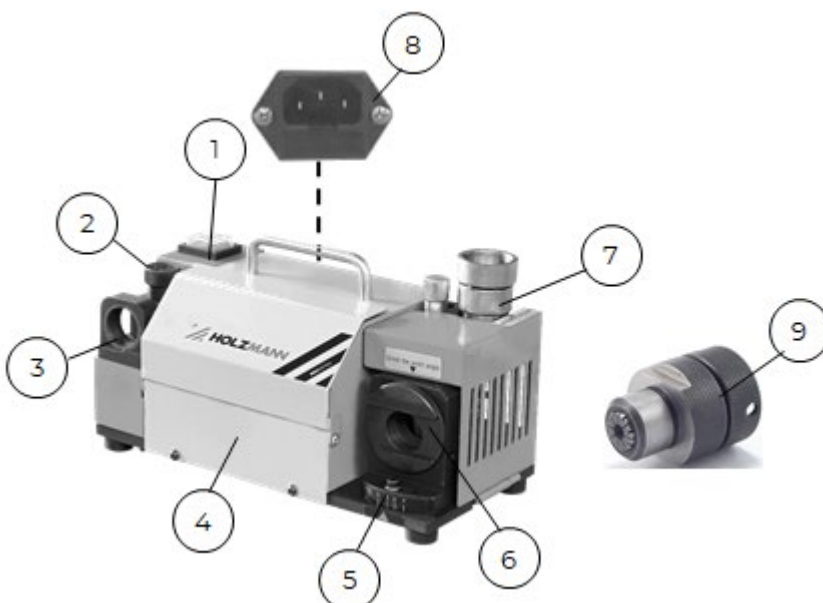
### 3 TECHNIK / TECHNICS

#### 3.1 Lieferumfang / Delivery content



#	Beschreibung / Description	#	Beschreibung / Description
<b>1</b>	Elektrisches Bohrerschärfgerät mit Schleifscheibe mit CBN (für HSS) / electric drill bit sharpener with grinding wheel CBN (for HSS)	<b>5</b>	<b>BSG13PRO</b> 11 Spannhülsen: Ø3-2 ... Ø13-12 mm / 11 collets Ø3-2 ... Ø13-12 mm <b>BSG26PRO</b> 14 Spannhülsen: Ø13-12 ... Ø26-25 mm / 14 collets Ø13-12 ... Ø26-25 mm
<b>2</b>	Spannfutter / collet chuck	<b>6</b>	Anschlusskabel / connecting cable
<b>3</b>	Gummifuß / rubber foot	<b>7</b>	Sechskantschlüssel-Set / hexagon wrench-set
<b>4</b>	Bedienungsanleitung / user manual		

#### 3.2 Komponenten / Components



	Beschreibung / Description		Beschreibung / Description
<b>1</b>	EIN-AUS-Schalter / ON-OFF-switch	<b>6</b>	Schleifführung Hauptschneide / honing guide main cutting edge

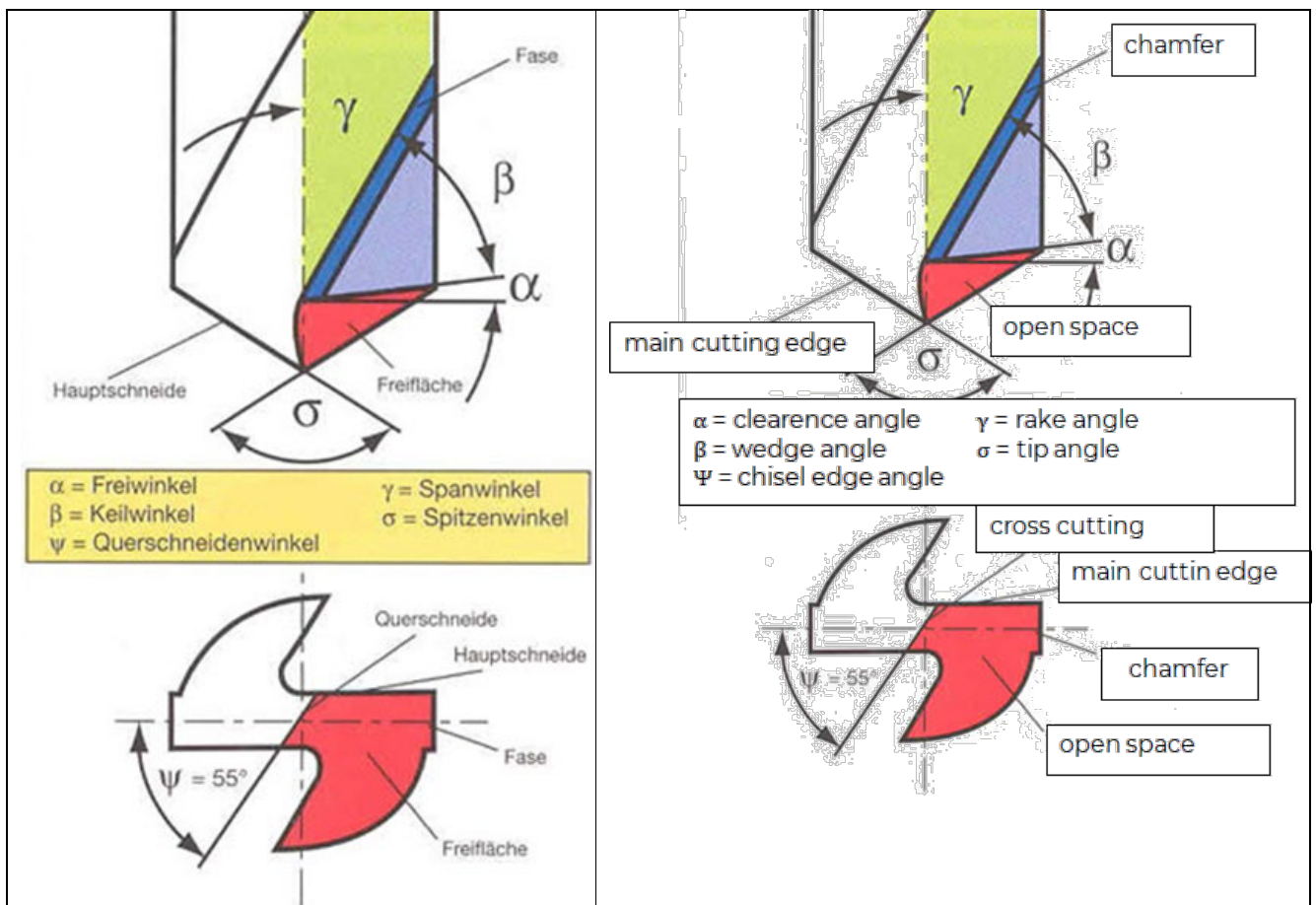


2	Bohrergrösse Einstellknopf / drill size adjustment	7	Schleifführung Freifläche –Hinterschliff– / honing guide open space –relief–
3	Einstell-Führung / setting guide	8	Geräterückseite) / cable connection (at the rear of the device)
4	Spannhülsen Lagerung / collet storage	9	Spannfutter / collet chuck
5	Bohrer Schnittwinkel Einstellskala / drill cutting angle adjustment scale		Kabelanschluss (auf der

### 3.3 Technische Daten / Technical data

Spezifikation / Specification	BSG13PRO_230V	BSG26PRO_230V
Spannung / voltage	230 V / 50 Hz	230 V / 50 Hz
Motorleistung / motor power	180 W	250 W
Drehzahl / speed	5300 min <sup>-1</sup>	4800 min <sup>-1</sup>
Bohrerdurchmesser / drill diameter	3 – 13 mm	13 – 26 mm
Spitzenwinkel / point angle	90 – 135°	90 – 135°
Schleifscheibe / grinding wheel	CBN 200 (für HSS / for HSS)	CBN 200 (für HSS / for HSS)
Verpackungsmaße (L×B×H) / packaging dimensions (L×W×H)	310×170×180 mm	460×240×220 mm
Gewicht Brutto / weight gross	10 kg	27 kg
Gewicht Netto / weight net	9,5 kg	25 kg

### 3.4 Winkel & Schneiden am Bohrer / Angles & cuttings at the drill





## 10 PREFACE (EN)

### Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the drill bit sharpener BSG13PRO\_230V and BSG26PRO\_230V, 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.**

### Copyright

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This documentation is protected by copyright. All rights reserved! In particular, the reprint, translation and extraction of photos and illustrations will be prosecuted.

The place of jurisdiction is the regional court Linz or the court responsible for 4170 Haslach is valid.

### Customer service contact

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AUSTRIA

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## 11 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!

### 11.1 Intended use of the machine

The machine is designed exclusively for the following activities:

For sharpening HSS twist drills within the specified technical limits.

For grinding carbide spiral drills, the grinding wheel must be replaced!

#### 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.

#### 11.1.1 Technical restrictions

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

Relative humidity	max. 70 %
Temperature (operation)	+5 °C to +40 °C
Temperature (storage, transport)	-25 °C to +55 °C

#### 11.1.2 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 in the vicinity of flammable liquids, vapours or gases.
- 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.

### 11.2 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.

**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.

### 11.3 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:



- 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, work gloves).
- 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.

#### **11.4 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 supply is protected by a residual current circuit breaker.
- Before connecting the machine always make sure that the main switch is switched off.
- Use the machine only when the ON-OFF switch is in good working order.

#### **11.5 Special safety instructions for this machine**

- Only grind dry.
- Do not reach into the running machine.
- Do not brake the grinding wheel with your hand or other objects.
- Do not use the machine if the grinding wheel is damaged.
- Do not use the machine without honing guide, otherwise the drill may be expelled.
- Keep the ventilation slots on the housing clear to prevent the motor from overheating.





## 11.6 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!**

## 12 TRANSPORT

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

Transport the machine in its packaging to the place of installation. When lifting, carrying and depositing the load, make sure that you are in 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!

## 13 OPERATION

### 13.1 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.



## 13.2 Assembly

- Screw the 4 rubber feet into the holes provided on the underside of the machine.
- Connect the connection cable to the machine and the socket.

## 13.3 Handling

### NOTE



The drill sharpener is not suitable for continuous use. If the motor becomes too hot, the machine will switch off for thermal reasons. Allow the machine to cool down before it is switched off again.  
If the workpiece turns blue during grinding, it is overheated and can be damaged. Reduce the grinding removal by turning the drill slower or cool the workpiece in water.

### CAUTION



Avoid touching the grinding disc and the workpiece immediately after use, as they become very hot.

#### 13.3.1 Setting up the Drill Bit

	<ol style="list-style-type: none"><li>1. Determine the diameter of the drill, then select the appropriate collet.</li><li>2. Insert the collet into the chuck at an angle of 45° and tighten the clamping nut slightly.</li></ol>
	<ol style="list-style-type: none"><li>3. Insert the twist drill with approx. 35 mm projection into the chuck and tighten slightly at the front so that the drill can still be moved.</li></ol>

#### 13.3.2 Aligning the Drill Bit

<ol style="list-style-type: none"><li>1. Reset the scale ring: Turn the drill size adjustment knob (2) clockwise as far as it will go and then counterclockwise to the size of the drill (e.g. 8 mm).</li></ol>





2. Insert the chuck with drill bit completely into the setting guide by turning it slightly.
  3. Push the drill bit forward in the chuck and turn it clockwise with the main cutting edge until it stops.
  4. In this position, tighten the drill in the collet by turning it clockwise.
- NOTE:** Make sure that the cutting lip of the drill (main cutting edge) is parallel to the guide edge of the chuck before you start grinding. If this is not the case, the drill must be realigned.

### 13.3.3 Grinding the Point Angle

1. Switch on the machine with the ON-OFF-switch.
2. Insert the chuck carefully into honing guide main cutting edge (6).

**NOTE:** Insert the chuck guide edge completely into the guide groove.

3. Turn the chuck in the honing guide slightly to the left and to the right to and fro until no grinding noise is heard any more.
4. Pull the chuck out of the honing guide and turn it 180°.
5. Insert the chuck again and repeat the procedure until no more grinding noise is audible.
6. Switch off the machine with the ON-OFF-switch.

7. Pull the chuck out of the honing guide and open the fixing handle on the chuck.

### 13.3.4 Grinding the Lip Relief Angle

1. Switch on the machine with the ON-OFF-switch.
2. Insert the chuck into the honing guide open space (7).

**NOTE:** Put leading edge correctly into the lead.

3. Turn the chuck in the point guide to the left and right until the grinding noise disappears.
4. Pull the chuck out of the grinding guide and turn it by 180°.
5. Reinsert the chuck and repeat the procedure.
6. Switch off the machine with the ON-OFF-switch.

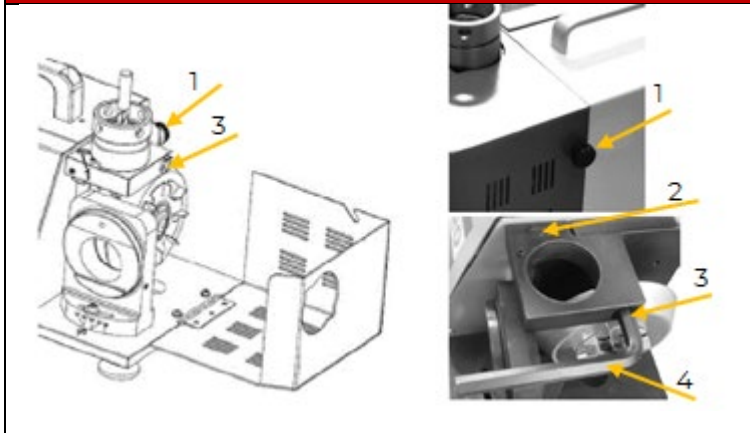
7. Pull the chuck out of the honing guide and open the fixing handle on the chuck.

8. Remove finished ground drill bit.

### 13.3.5 Setting the cross cutting edge

**BSG13PRO\_230V**

- With the knob (1) the size of the chisel edge can be adjusted...

**BSG26PRO\_230V**

- Loosen the screw (1) and open the cover.
- Use an Allen key (4) to loosen the screw (3).
- Use a screwdriver to turn the stud screw (2) to adjust the size of the cross cutting edge.

**14 CLEANING, MAINTENANCE, STORAGE, DISPOSAL****WARNING**

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

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

**14.1 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.
- Keep the surfaces and ventilation slots of the machine free of dust and dirt.
- Use a soft cloth and a mild soap solution for cleaning and, if necessary, a moisture-free jet of compressed air.

**14.2 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.

**14.2.1 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	• grinding wheel	• check for damage
	• power cord	
Each time after completion of work	• surfaces	• remove dust and dirt
	• air vents	
• if required	• grinding wheel	• replace

#### 14.2.2 Replacing the Grinding Wheel

### WARNING

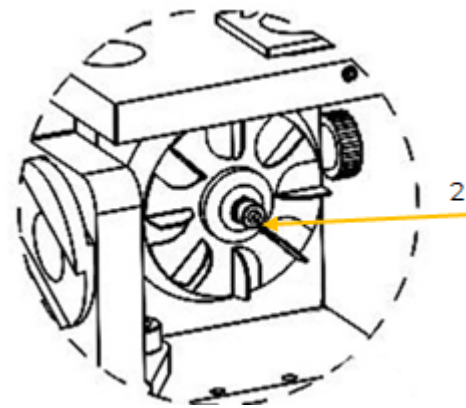


#### Risk of injury from hot machine parts!

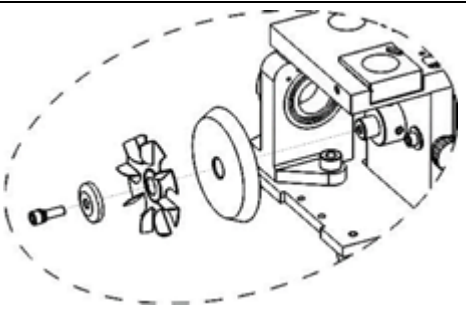
→ Allow the machine to cool down after use before starting maintenance work!



1. Remove the chuck if necessary.
2. Loosen the knurled screw (1) on the back of the unit.
3. Remove the cover.



4. Loosen the screw in the middle of the fan wheel.
5. Remove the fan wheel and the grinding wheel.



6. Mount the new grinding wheel in reverse order.

#### 14.3 Storage

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

**NOTE**

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

**14.4 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.

**15 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!

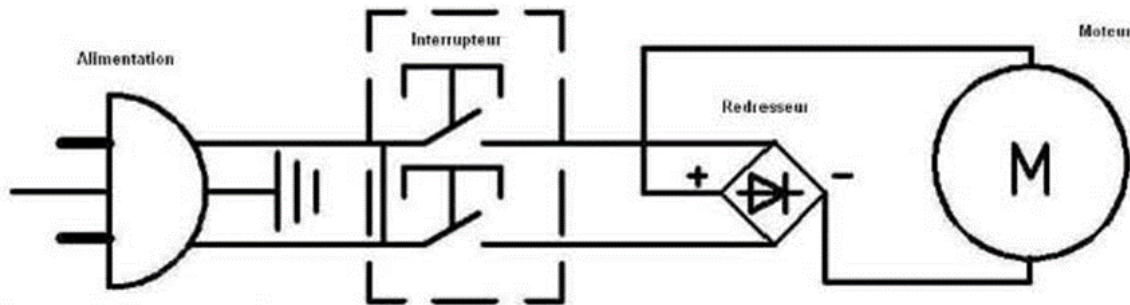
Many possible sources of error can be eliminated in advance if the machine is properly connected to the power supply.

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 cannot be switched on</b>	• switch defective	• Contact customer service
	• Mains plug not plugged in	• Plug in the mains plug -
<b>Grinding performance is poor</b>	• Grinding disc is worn	• Replacing the grinding disc



## 16 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM



## 17 ERSATZTEILE / SPARE PARTS

### 17.1 Ersatzteilbestellung / Spare parts order

**(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](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

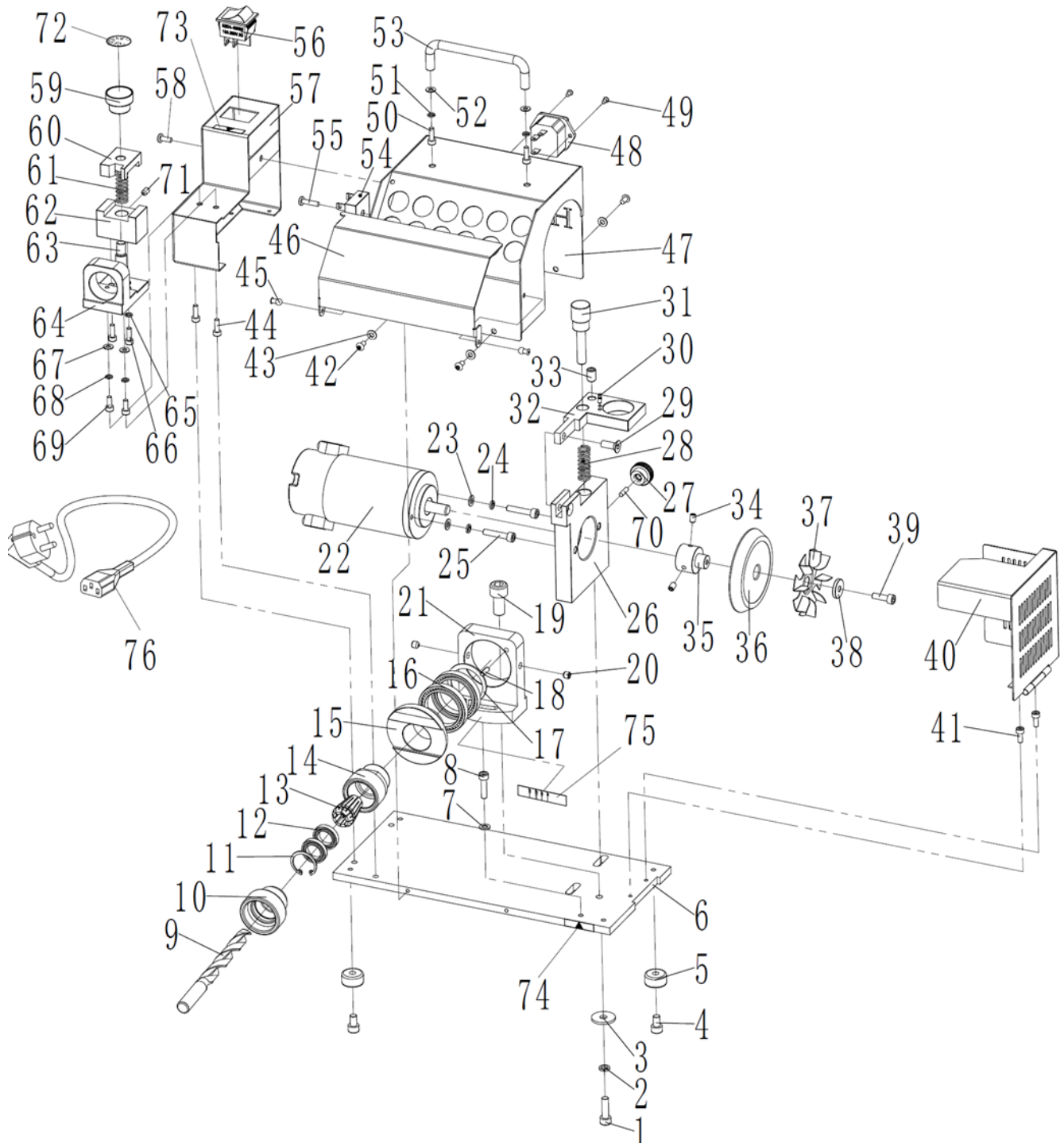
- via our Homepage-category SERVICE-SPARE PARTS REQUEST,
- by e-mail to [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at).

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.



## 17.2 Explosionszeichnung / Exploded view

### 17.2.1 BSG13PRO\_230V



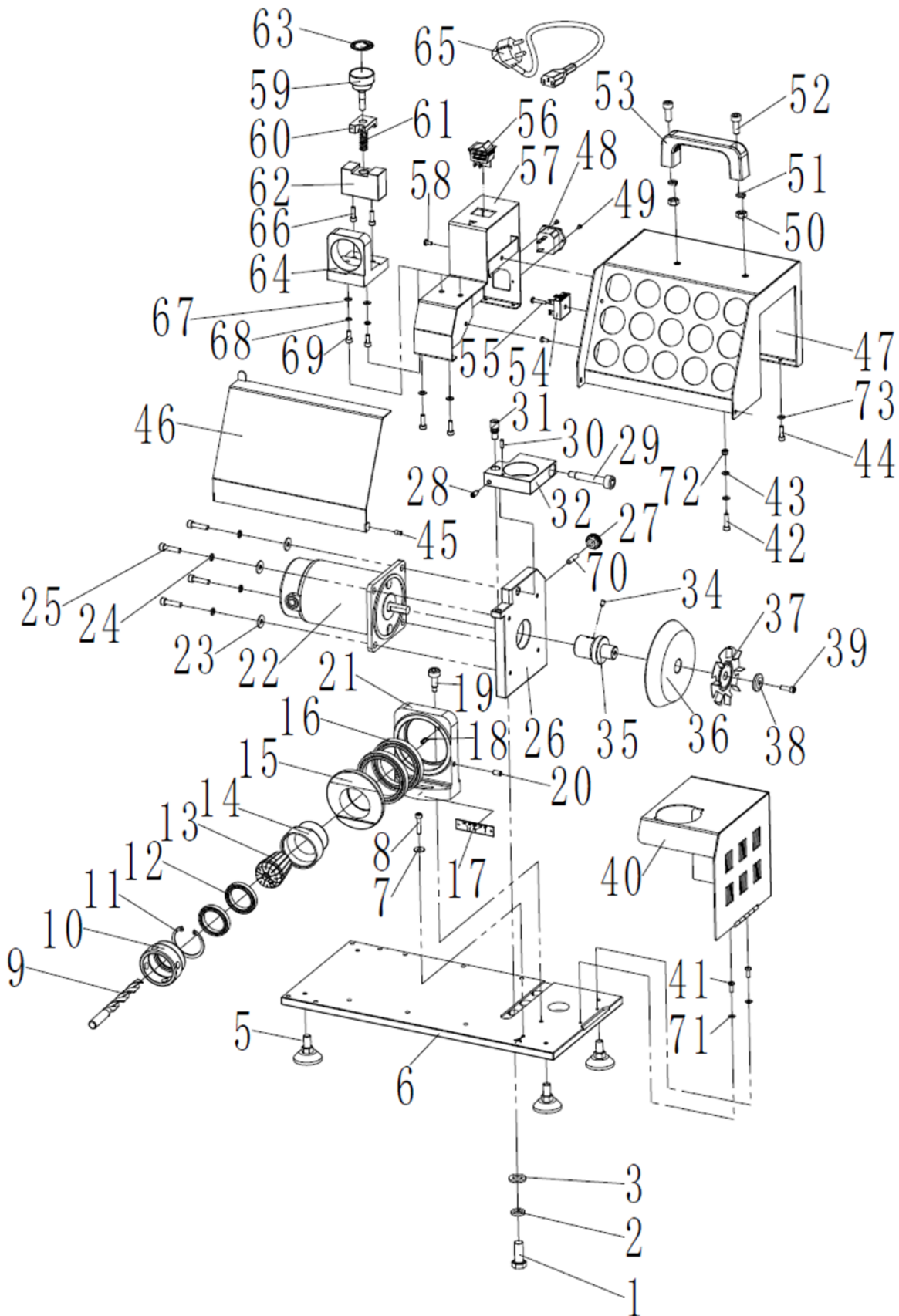




No.	Description	Qty.	No.	Description	Qty.
1	Screw M6×20	2	39	Screw M5×16	1
2	Spring washer ø 6	2	40	Cooling shield	1
3	Very large washer	2	41	Screw M4×10	2
4	Screw M6×10	4	42	Screw M4×8	4
5	Rubber tray	4	43	Washer ø 4	4
6	Base plate	1	44	Screw M4×12	3
7	Washer ø 5	1	45	Rivet 4×5	2
8	Screw M6×20	1	46	Box shield	1
9	Drilling bit	1	47	Motor shield	1
10	Retrac bush	1	48	Plug base	1
11	C ring ø 24	1	49	Screw M3×6	2
12	Bearing 61802	2	50	Screw M4×12	2
13	Barrel clamp	11	51	Spring washer ø 4	2
14	Anterior bush	1	52	Washer ø 4	2
15	Rotating bush	1	53	Gripe	1
16	Bearing 61807	2	54	Rectifier	1
17	C ring ø 35	1	55	Screw M4×16	1
18	Spring pin 4×12	1	56	Switch	1
19	Pin screw1	1	57	Switch box	1
20	Set screw M6×6	2	58	Screw M4×10	1
21	Bracket	1	59	Handgrip	1
22	Motor	1	60	Set ruler	1
23	Washer ø 5	2	61	Spring	1
24	Spring washer ø 5	2	62	Set block	1
25	Screw M5×25	2	63	Bolt	1
26	Motor Support	1	64	Set base	1
27	Locking button	1	65	Spring washer ø 4	2
28	Spring	1	66	Set screw M4×12	2
29	Screw M6×16	1	67	Washer ø 4	2
30	Spring pin 3×5	2	68	Spring washer ø 4	2
31	Handgrip	1	69	Screw M4×10	2
32	Rolling support	1	70	Screw M6×25	1
33	Set screw M8×12	1	71	Set screw M5×8	1
34	Set screw M5×8	3	72	Set ruler	1
35	Link flange	1	73	Arrow pointer	1
36	Grinding wheel	1	74	Arrow pointer	1
37	Paddle	1	75	Angle ruler	1
38	Platen	1	76	Plug	1



## 17.2.2 BSG26PRO\_230V





No.	Description	Qty.	No.	Description	Qty.
1	Bolt M12×30	3	38	Platen	1
2	Spring washer Ø12	3	39	Screw M5×16	1
3	Washer Ø12	3	40	Cooling shield	1
5	Rubber tray	4	41	Screw M4×12	2
6	Base plate	1	42	Screw M5×20	3
7	Washer Ø5	1	43	Washer Ø5	6
8	Screw M5×25	1	44	Screw M5×16	7
9	Drilling bit	1	45	Rivet 4×6	2
10	Retral bush	1	46	Box shield	1
11	C ring Ø47	1	47	Motor shield	1
12	Bearing 61807	2	48	Plug base(10A)	1
13	Barrel clamp	14	49	Screw M3×6	2
14	Anterior bush	1	50	Screw M4×12	2
15	Rotating bush	1	51	Spring washer Ø4	2
16	Bearing 61812	2	52	Washer Ø4	2
18	Sping pin 4×12	1	53	Gripe	1
19	Pin screw	1	54	Rectifier	1
20	Set screw M6×12	2	55	Screw M4×20	1
21	Bracket	1	56	Switch	1
22	Motor	1	57	Switch box	1
23	Washer Ø6	4	58	Screw M4×8	2
24	Spring washer Ø6	4	59	Handgrip	1
25	Screw M6×25	4	60	Set ruler	1
26	Motor support	1	61	Spring	1
27	Locking button	1	62	Set block	1
28	Set screw	1	63	Set ruler	1
29	Pin screw	1	64	Set base	1
30	Sping pin 4×12	1	65	Plug	1
31	Handgrip	1	66	Screw M5×16	2
32	Rolling support	1	67	Washer Ø5	2
34	Set screw M5×8	2	68	Spring washer Ø5	2
35	Link flange	1	69	Screw M5×12	2
36	Grinding wheel	1	70	Screw M6×25	1
37	Paddle	1	71	Washer Ø4	2
			72	Hex nut M5	3
			73	Washer Ø5	7