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Originalfassung

**DE BETRIEBSANLEITUNG**

Übersetzung / Translation

**EN USER MANUAL**

**KANTENANLEIMMASCHINE inkl. Zubehör**

**EDGE BANDING MACHINE with accessories**



**KAM55V\_230V**



**YOUR  
JOB.  
OUR  
TOOLS.**



## 2 SICHERHEITSZEICHEN / SAFETY SIGNS

DE SICHERHEITSZEICHEN  
BEDEUTUNG DER SYMBOLE

EN SAFETY SIGNS  
DEFINITION OF SYMBOLS



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

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



DE **BETRIEBSANLEITUNG LESEN!** Lesen Sie die Betriebs- und Wartungsanleitung Ihrer Maschine aufmerksam durch und machen Sie sich mit den Bedienelementen der Maschine gut vertraut, um die Maschine ordnungsgemäß zu bedienen und so Schäden an Mensch und Maschine vorzubeugen.

EN **READ THE MANUAL!** Read the user and maintenance carefully and get familiar with the controls in order to use the machine correctly and to avoid injuries and machine defects.



DE **WARNUNG!** Beachten Sie die Sicherheitssymbole! Die Nichtbeachtung der Vorschriften und Hinweise zum Einsatz der Maschine kann zu schweren Personenschäden und tödliche Gefahren mit sich bringen.

EN **ATTENTION!** Ignoring the safety signs and warnings applied on the machine as well as ignoring the security and operating instructions can cause serious injuries and even lead to death.



DE Schutzausrüstung tragen!

EN Wear protective equipment!



DE Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

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



DE Warnung vor gefährlicher elektrischer Spannung!

EN Beware of dangerous electrical voltage!



DE Verbrennungsgefahr! Heiße Oberfläche

EN Burn hazard! Hot surface



DE Handverletzung durch rotierende Walzen!

EN Hand injuries because of rotating rollers!



DE Verbrennungsgefahr! Hohe Temperatur

EN Burn hazard! High temperature

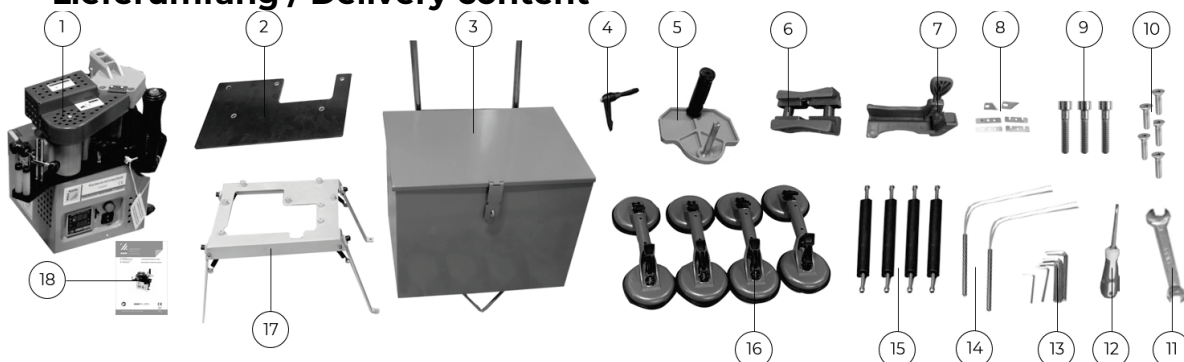
DE **Warnschilder und/oder Aufkleber an der Maschine, die unleserlich sind oder entfernt wurden, sind umgehend zu erneuern.**

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



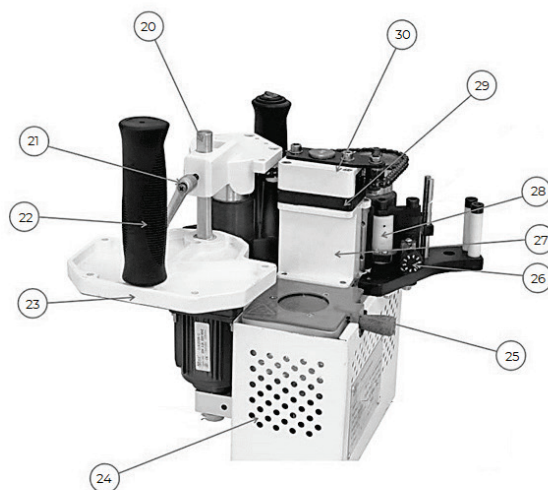
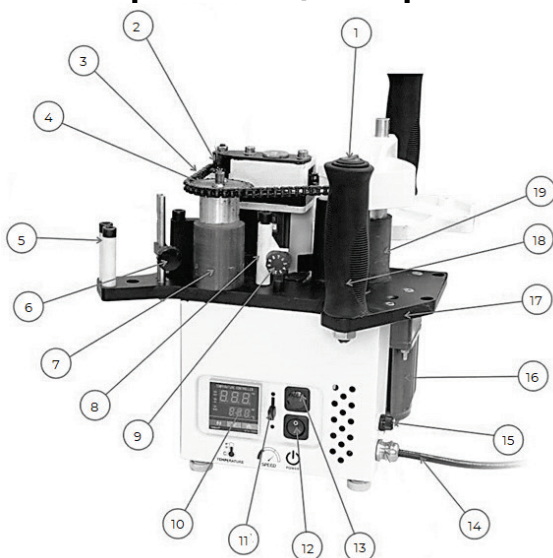
### 3 TECHNIK / TECHNICS

#### 3.1 Lieferumfang / Delivery content



#	Beschreibung / Description	Qty.	#	Beschreibung / Description	Qty.
1	Maschine / machine	1	10	Montageschrauben Montageplatte / mounting screws mounting plate	5
2	Montageplatte / mounting plate	1	11	Gabelschlüssel / wrench	1
3	Metallkoffer / metal case	1	12	Schraubendreher / screw driver	1
4	Klemmhebel / clamping lever	1	13	Inbusschlüsselset / Allen key set	1
5	Auflageplatte mit Handgriff / locating plate with handle	1	14	Ersatzheizstab / spare heating pipe	2
6	2-Seitenschneider / double edge trimmer	1	15	Distanzhalter / space holder	4
7	Endschneider / end trimmer	1	16	Vacuumsauger / vacuum workpiece holder	4
8	Ersatzklingenset / spare blades set	1	17	Stationärstisch / fixing table	1
9	Montageschrauben Maschine / mounting screws machine	3	18	Betriebsanleitung / user manual	1

#### 3.2 Komponenten / Components



#	Beschreibung / Description	#	Beschreibung / Description
1	Ein-Aus-Schalter Vorschub / on-off switch feeding	16	Motor / motor
2	Kettenspannrad / tension sprocket	17	Grundplatte / base plate
3	Kette / chain	18	Bediengriff / operation handle
4	Kettenzahnrad / chain sprocket	19	Antriebswelle Motor /
5	Zuführrollen / infeed rolls	20	Einstellung Werkstückdicke / adjustment workpiece thickness
6	Einstellung Kantenbreite / adjustment edge width	21	Klemmhebel / clamping lever
7	Kantenvorschubwalze / edge feeding roller	22	Handgriff / handle
8	Druckstift / pressure pin	23	Auflageplatte / locating plate
9	Einstellung Kantendicke / adjustment edge thickness	24	Gehäuse / housing
10	Temperaturregelung / temperature controller	25	Abdeckung Klebgranulatbehälter / glue pot cover
11	Regler Vorschubgeschwindigkeit / feeding speed controller	26	Einstellung Klebgranulatmenge / glue adjustment



<b>12</b>	Ein-Aus-Schalter / on-off-switch	<b>27</b>	Halterung / base
<b>13</b>	Betriebskontrollleuchte / power indicator light	<b>28</b>	Kantenzuführwalze / edge band feeding roller
<b>14</b>	Anschlusskabel / cable	<b>29</b>	Untere Abdeckung / lower cover
<b>15</b>	Sicherungshalter / fuse socket	<b>30</b>	Obere Abdeckung / upper cover

### 3.2.1 Bedienelemente / control elements

Beschreibung / Description	
<b>1</b>	IST-Temperatur / current temperatur
<b>2</b>	SOLL-Temperatur / target temperature
<b>3</b>	keine Funktion / no function
<b>4</b>	Taste Wert senken / key value lower
<b>5</b>	Taste Wert erhöhen / key value increase
<b>6</b>	Regler Vorschubgeschwindigkeit / feed speed controller
<b>7</b>	Ein-Aus-Schalter / on-off-switch
<b>8</b>	Betriebskontrollleuchte / power indicator light

### 3.3 Technische Daten / Technical data

Spezifikation / Specification	
Spannung / voltage	230 V / 1 / 50 Hz
Motorleistung S1 (100 %) / motor power S1 (100 %)	765 W
Vorschubgeschwindigkeit / feed speed	0,3 – 3 m/min
Kantendicke / edge thickness	0,3 – 3 mm
Kantenbreite / edge width	10 – 55 mm
min. Kurvenradius / min. curve radius	20 mm
Betriebstemperatur / working temperature	120 – 180 °C
Aufwärmzeit / warm-up time	~ 6 min
Fassungsvermögen Leimtopf / glue pot capacity	200 ml
Kabellänge / cable length	1,75 m
Sicherung / Fuse	F6A (230V)
Maschinenmaße (LxBxH) (mit Tisch) / machine dimensions (LxWxH) (with table)	330 x 320 x 390 mm (525 x 360 x 400 mm)
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH)	500 x 445 x 475 mm
Gewicht Brutto / weight gross	30 kg
Gewicht Netto (mit Tisch) / weight net (with table)	8,5 (12,5) kg

## 4 VORWORT (DE)

### Sehr geehrter Kunde!

Diese Betriebsanleitung enthält Informationen und wichtige Hinweise zur Inbetriebnahme und Handhabung der KANTENANLEIMMASCHINE inkl. Zubehör KAM55V\_230V, nachfolgend als „Maschine“ in diesem Dokument bezeichnet.



## 11 PREFACE (EN)

### Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the EDGE BANDING MASCHINE with accessories KAM55V\_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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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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## 12 SAFETY

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



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

### 12.1 Intended use of the machine

The machine is designed exclusively for the following activities:

Edge banding (PVC, ABS, PP, wood) on wood-based materials such as chipboard, MDF, HDF and lightweight boards using a hot melt adhesive within the technically specified limits.

#### NOTE



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

#### 12.1.1 Technical restrictions

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

Relative humidity	max. 70 %
Temperature (operation)	+5 °C to +40 °C
Temperature (storage, transport)	-20 °C to +55 °C

#### 12.1.2 Prohibited applications / Dangerous misuse

- Operating the machine outdoors.
- Operating the machine without adequate physical and mental fitness.
- Operating the machine without knowledge of the manual.
- Modifying the machine design.
- Operating the machine in a potentially explosive environment.
- 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.
- Machining of materials with dimensions outside the limits specified in this manual.
- Cleaning the machine with water, neither with the power switched on nor with the power switched off.

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

### 12.2 User requirements

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

**Please note that locally applicable laws and regulations determine the minimum age of the operator and may restrict the use of this machine!**

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

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

### 12.3 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.
- When using the fixing table, 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, 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.

#### **12.4 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.
- Use the machine only when the ON-OFF switch is in good working order.

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

- Work only in well-ventilated rooms!
- Glue and gluing unit are heated during operation, avoid any contact with hot components/glue and wait for cooling phases before maintenance work!
- Always ensure that you are standing securely when working. Do not use the machine for overhead work. Risk of hot liquid glue dripping onto the operating person.
- Keep the machine away from potential ignition sources such as open flames – risk of fire and explosion!

#### **12.6 Hazard warnings**

##### **12.6.1 Residual risks**

Despite intended use, certain residual risk factors remain.

- Risk of injury for hands / fingers by rotating rollers during operation.
- Risk of injury due to sharp edges of the workpiece
- Risk of injury due to improper maintenance activities.

##### **12.6.2 Hazardous situations**

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

Transport the machine in its packaging to the place of installation. To manoeuvre the machine in the packaging, a pallet truck or forklift truck with the appropriate lifting force can be used, for example. The specifications can be found in the chapter Technical data. For proper transport, also observe the instructions and information on the transport packaging regarding centre of gravity, lifting points, weight, means of transport to be used as well as the prescribed transport position etc. Ensure that the selected lifting equipment (crane, forklift, pallet truck, load sling, etc.) is in perfect condition. Ensure the correct body posture when lifting, carrying and setting down the load.

### 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

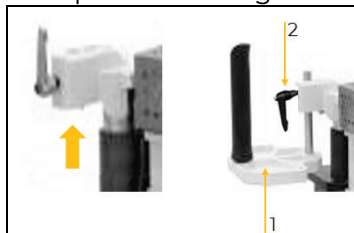
### 14.1 Preparation

#### 14.1.1 Check delivery content

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

### 14.2 Assemble

The machine comes pre-assembled, it is necessary to assemble the components dismantled for transport according to the following instructions and to make the electrical connection.

**Locating plate with handle:**

- Insert the locating plate (1) into the bracket
- Fix the locating plate in required position with the clamping lever (2)





	<p><b>Fixing table:</b></p> <ul style="list-style-type: none"> <li>• Unfold the fixing table (1)</li> <li>• Place the mounting plate (2) as shown and fix it with the mounting screws (3)</li> <li>• Place the machine on the fixing table as shown and fix it with the mounting screws (4)</li> </ul> <p><b>NOTE:</b> When using with the fixing, do not mount the locating plate with handles!</p>
	<p><b>Vacuum workpiece holder:</b></p> <ul style="list-style-type: none"> <li>• Connect the vacuum workpiece holder (1) with the space holders (2)</li> <li>• The double vacuum workpiece holder assembled in this way is matched to the height of the fixing table and can be used as a workpiece support</li> </ul>

### 14.3 Electrical connection

#### WARNING



##### **Dangerous electrical voltage!**

Risk of injury due to dangerous electrical voltage!

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

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

#### NOTE



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

A deviation from the value of the supply voltage of  $\pm 5\%$  is permissible.

A short-circuit fuse must be provided in the power supply system of the machine!

- Use a supply cable that fulfils the electrical requirements (e.g. H07RN, H05RN) and take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage.
- Make sure that the power supply is protected by a residual current circuit breaker.
- Connect the machine only to a properly grounded outlet.
- When using an extension cable, make sure that the dimension matches the connected load of the machine. The connection power can be found in the technical data, the correlation of cable cross-section and cable lengths can be found in the technical literature or obtain information from a specialist electrician.
- A damaged cable must be replaced immediately.

## 15 OPERATION

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

### 15.1 Settings

#### WARNING

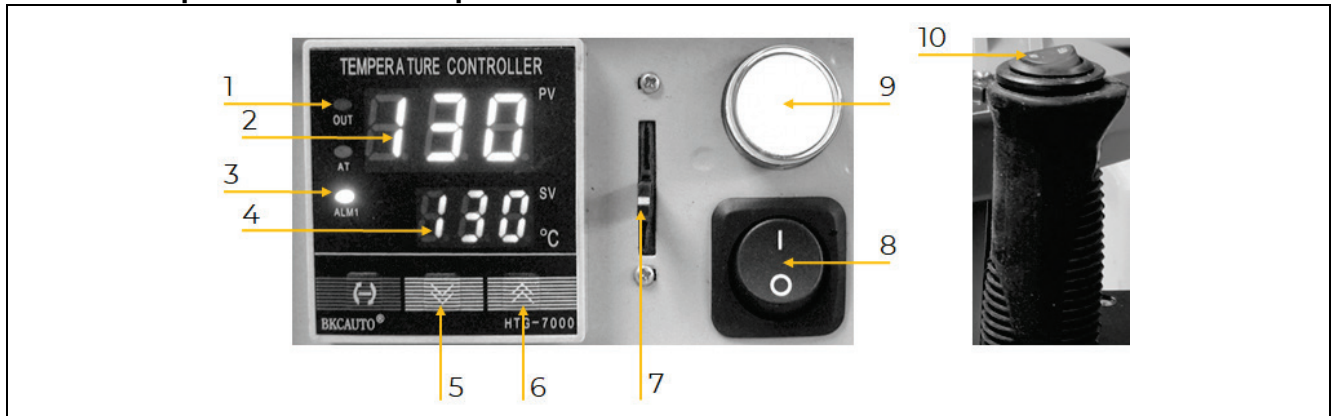


Handling the machine with connected power supply may result in serious injury or death.

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



### 15.1.1 Temperature and feed speed



1	Heating indicator light	The control light is on for the duration of the heating process.
2	Target temperature	Display of the intended operating temperature.
3	Indicator light temperature reached	As soon as the target temperature is reached, the indicator light will light up. Feed can be started.
4	Current temperature	Display of the current heating temperature of the machine.
5	Temperature lower	By pressing the button once, the temperature is reduced by one degree. A quicker temperature adjustment is achieved by pressing continuously the button.
6	Temperature higher	By pressing the button once, the temperature is increased by one degree. A quicker temperature adjustment is achieved by pressing continuously the button.
7	Feed speed controller	Controller down: accelerate the feeding speed. Controller up: reduce the feeding speed.
8	Heating ON-OFF	Press the ON-OFF-switch to turn the heating on (I) or off (O).
9	Power indicator light	Lights up when the heating is switched on.
10	Feed speed	Press ON-OFF switch feed to switch the feeding on (I) or off (O).

### 15.1.2 Height adjustment of the guiding plate

	<ul style="list-style-type: none"> <li>Measure the height of the workpiece.</li> </ul>
	<ul style="list-style-type: none"> <li>Loosen the clamping lever (1) and adjust the distance between supporting plate (2) and edge bander by using the scale (3)</li> </ul>
	<ul style="list-style-type: none"> <li>Tighten the clamping lever (1)</li> </ul>



### 15.1.3 Adjustment for the width of edge banding material

	<ul style="list-style-type: none"> <li>• Loose screw (1) and insert a sample edge (2) into the side of the hold-down clamp</li> <li>• Move down the clamp (3) to touch the edge band and set the width of the band</li> <li>• Tighten the screw (1)</li> </ul>
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### 15.1.4 Adjustment for the thickness of edge banding material

	<ul style="list-style-type: none"> <li>• Set the required thickness by turning the adjusting screw (1)</li> </ul>
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### 15.1.5 Adjustment for the amount of glue

	<ul style="list-style-type: none"> <li>• Adjusting glue amount: the adjusting knob (1) can control the amount of glue applied onto the edge banding material (<b>only when the machine is heated up and the glue granulate is liquid!</b>).</li> <li>• When machine has heated up and the glue granulate has become liquid, feed a sample edge to check the amount of glue applied on it. Adjust until the edge is coated evenly.</li> </ul>
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**NOTE:** Do not set adjustment knob after machine has cooled down. Part of the adjusting components will get stuck by the glue, hence no turning on the knob is allowed.

## 15.2 Operating instructions

- Feeding rollers must always be clean.
- Adjust temperature setting to the used glue granule!
- Always hold the machine by the insulated handles because some components of the machine become hot (rollers, glue pot, glue pot cover)!
- Do not open the glue pot cover or turn the glue adjustment knob while the machine is cool.
- Store the machine back to the original box only when the machine is cooled down!

### 15.2.1 Glue pot

**To prevent particles of dirt falling into the glue pot, close the pot again after filling it with glue granule.** However, if particles of dirt are detected in the glue pot, please remove the existing glue from the pot by heating up the machine for approx. 3 minutes and remove the glue with a tool when it has completely melted. Then heat the machine up further (without switching on the motor) and refill the remaining glue into a suitable vessel.

## 15.3 Handling

### 15.3.1 Edge banding mobile use

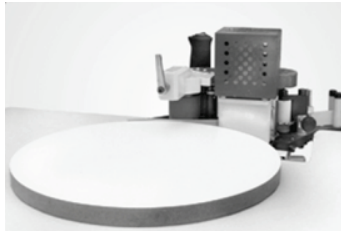
	<ul style="list-style-type: none"> <li>• Fill in glue granule into the glue pot</li> <li>• Switch on heating</li> <li>• Adjust temperature setting to the used glue granule</li> </ul> <p><b>NOTE:</b> Heating time takes about 6-10 min</p>
<ul style="list-style-type: none"> <li>• Cut the edge banding material to the required length + 5% or 10cm.</li> <li>• Before the edge banding operation, make sure the glue is completely melted into liquid (Using the tool and glove while opening the glue pot to check).</li> <li>• Place the locating plate onto the work piece and place the pressure roller close to the work piece without touching it.</li> </ul>	



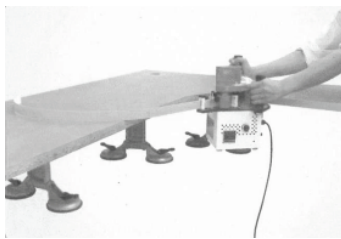
- Hold the machine tightly on both handles.
- Switch on the feeding and guide the machine along the workpiece edge as showing in the picture.
- Place the edge banding material into the feeding entrance until the edge band touches roller. The edge band will be transported automatically.
- As soon as the edge banding material has reached the pressure roller, press the pressure roller against the workpiece. The movement of the pressure roller automatically moves the machine ahead.

**NOTE:** Once the edge banding material is applied to the workpiece, apply constant pressure to achieve even edge banding..

- The machine is automatically moved forward by the feed of the pressure roller.
- The feeding speed can be adjusted variably.



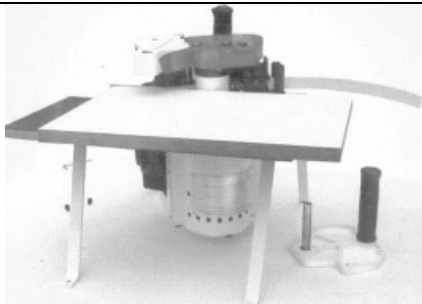
- At the end of the edge band make sure that the machine is led further uniformly in height and direction until the protruding edge band is led out of the pressure roller.
- Remove protruding edge banding material (with Überstehendes Kantenmaterial (for material thickness up to max. 0.8 mm double edge trimmer and end trimmer can be used)



### **For large workpieces, straight and bent**

- Use vacuum workpiece holder for supporting the workpiece

### **15.3.2 Edge banding stationary use**



- Mount the machine on the fixing table.
- Now small workpieces can be easily banded

## **16 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.

### **16.1 Cleaning**

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

### **NOTE**



Incorrect cleaning products can attack the finish of the machine. Do not use any solvents, nitro thinners or other cleaning products that could damage the machine's finish.

Observe the specifications and instructions of the cleaning agent manufacturer.

- Remove chips and dirt particles from the machine after each use with a proper tool.



### 16.2 Maintenance

The machine is low-maintenance and only a few parts need to be serviced. Malfunctions or defects that could affect your safety must be repaired immediately!

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

#### 16.2.1 Maintenance plan

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

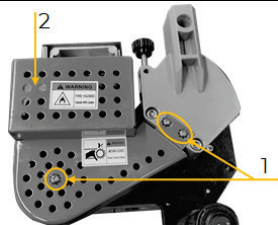
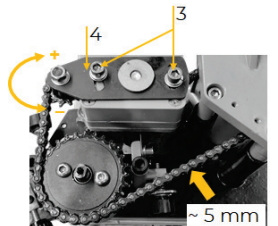
##### After each operation:

- The machine has to be cleaned after each operation. Beware for hot machine components. No cleaning immediately after turning off the machine
- Residues on the feeding rollers can be easily removed as follows: heat glue up to 120°C, start feeding motor and let make the roller few turns so the new hot glue heats the residual material on the roller. Press a wooden scoop carefully to the roller so you can remove the residual material. For finalized cleaning use a damp cloth with cleaning benzene.

##### After 50 work hours

- In order to keep the glue pot clean, it should be cleaned every 50 hours. Method: when the remaining hot glue granulate is intermediate / luke warm, clean up the leaving adhesive in the bottom of glue pot with a wooden scoop.

#### 16.2.2 Chain tension

	<ul style="list-style-type: none"><li>• Loosen the screws (1)</li><li>• Remove the cover (2)</li></ul>
	<ul style="list-style-type: none"><li>• Loosen the screws (3)</li><li>• Move the tension plate (4) in required direction</li></ul> <p><b>NOTE:</b> Do not overtension the chain!</p> <ul style="list-style-type: none"><li>• Tighten the screws again (3) wieder</li><li>• Remount the cover</li></ul>

### 16.3 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!

### 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 eliminated in advance if the machine is properly connected to the power supply.

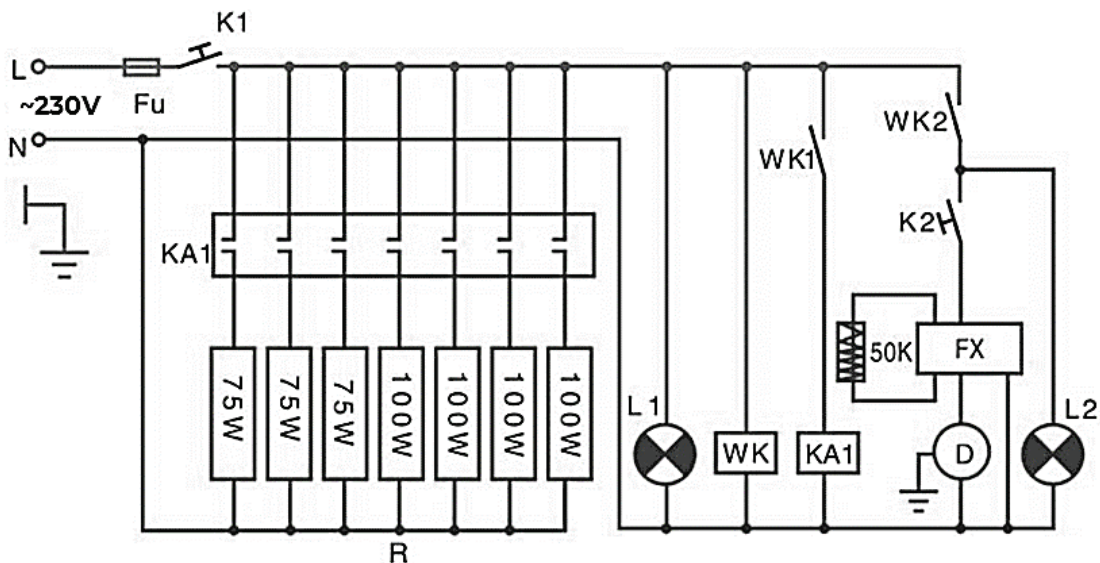
If you are unable to carry out the necessary repairs properly and/or do not have the required training, always consult a specialist to solve the problem.

Trouble	Possible cause	Solution
<b>Machine does not start</b>	• Switch defective	• Repair switch
	• Power supply is off	• Repair power supply
	• Fuse is defective	• Change fuse
	• Electric contactor is defective	• Repair or change electric contactor
<b>Edge is not fully covered with glue</b>	• The granulate in the glue pot is not fully melted into liquid	• Increase the heating period
	• Glue amount is not adjusted to the appropriate volume	• Increase the glue amount by glue adjustment knob
	• Residues into the glue pot	• Clean the glue pot
	• Incorrect temperature or glue granule	• Set temperature correctly or check glue granule
<b>Edges do not stick together</b>	• Wrong granulate	• Select right granulate
<b>While gluing the edges go up or down</b>	• Wrong edge height adjustment	• Set edge height adjustment new
<b>No movement on edge transport</b>	• Feeding roller dirty	• Clean feeding roller
<b>Feeding roller motor does not start</b>	• Glue not fully dissolved	• Increase heating temperature, switch on when reached re-set temp.
<b>Operation has been cancelled, machine does not start</b>	• Temperature rise is too high	• Let the machine cool down, then press the main switch ON-OFF again.





## 18 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM



## 19 ERSATZTEILE / SPARE PARTS

### 19.1 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.

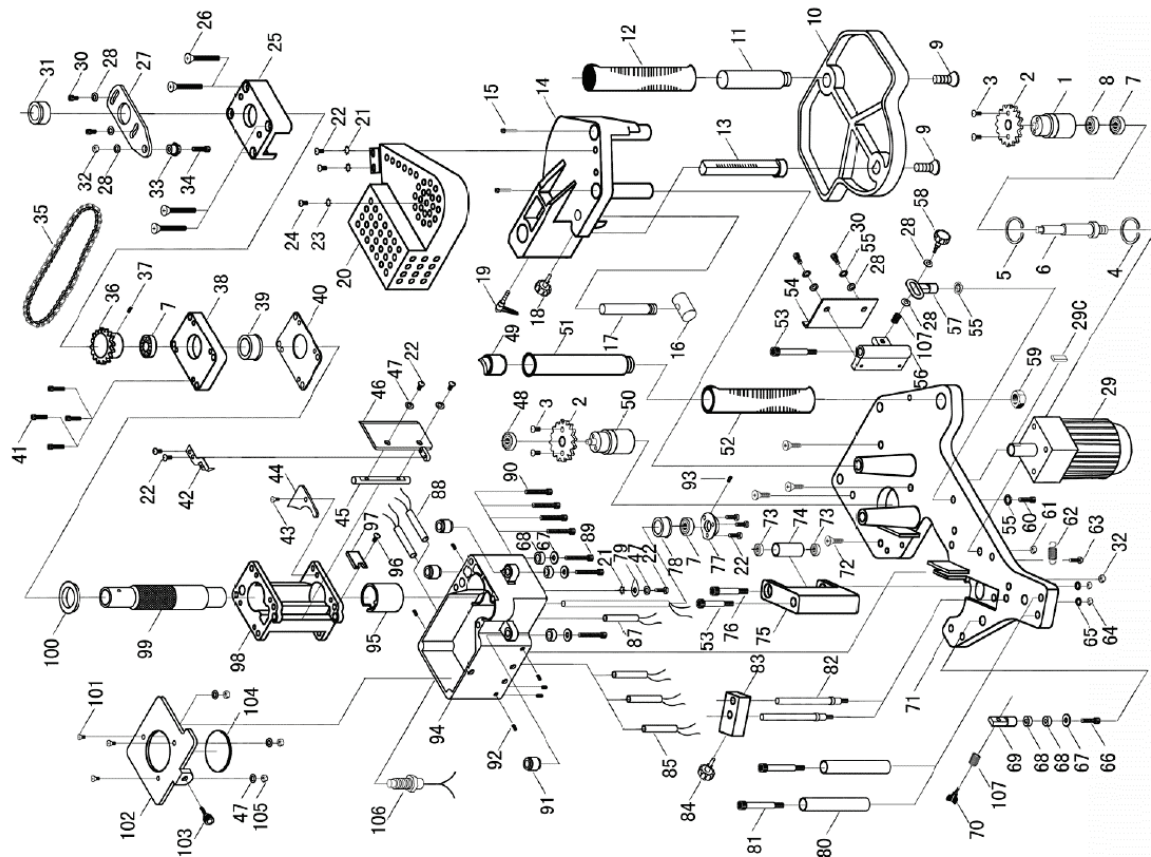
Order the spare parts directly on our homepage-category SPARE PARTS or contact our customer service

- 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.

### 19.2 Explosionszeichnung / Exploded view

KAM55V\_230V\_A

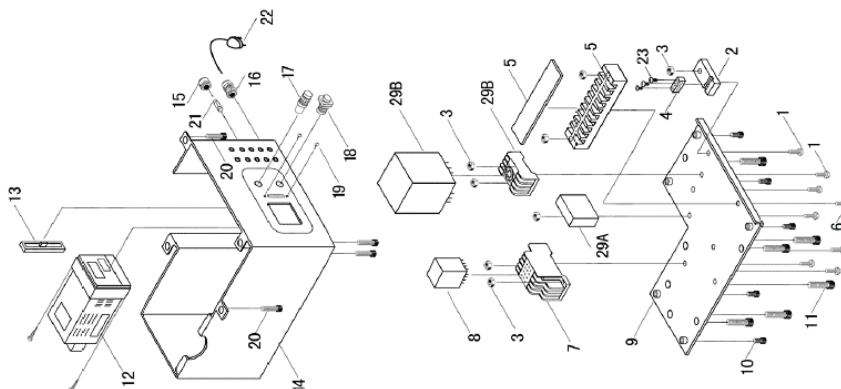


No.	Description	Qty.	No.	Description	Qty.
A1	rubbl wheel	1	A54	lead belt board	1
A2	driving sprocket	2	A55	elastic washer	4
A3	screws	4	A56	Lead belt base	1
A4	ring-circlips	1	A57	adjust base	1
A5	ring-circlips	1	A58	knob	1
A6	rubbl wheel shaft	1	A59	nut	1
A7	bearing	3	A60	screws	1
A8	bearing	1	A61	nut	1
A9	screws	2	A62	tension spring	1
A10	locating plate	1	A63	screws	1
A11	handle l	1	A64	nut	2
A12	handle l sheath	1	A65	Flat Washer	2
A13	locating rod	1	A66	screws	1
A14	bearing block	1	A67	Flat Washer	4
A15	screw	2	A68	cushion	5
A16	height limit blocks	1	A69	glue pointer base	1
A17	height adjustment lever	1	A70	glue pointer knob	1
A18	knob	1	A71	sole plate	1
A19	adjusting handle	1	A72	screws	4
A20	shield	1	A73	bearing	2
A21	washer lock	3	A74	guide pulley	1
A22	screws	10	A75	guide pulley base	1
A23	washer lock	1	A76	screws	1
A24	screws	1	A77	glue tank Bottom cover	1
A25	chain pulley seat	1	A78	glue tank bearing base	1
A26	screws	4	A79	grounding	1
A27	sprocket wheel plate	1	A80	guide sheath	2
A28	flat washer	7	A81	guide sheath shaft	2
A29	motor	1	A82	guide shaft	2
A29c	flat key	1	A83	locating lump	1
A30	screws	4	A84	knob	1
A31	sheath heating pipe	1	A85	heating pipe	3
A32	nut	2	A86	heating pipe	1
A33	tension sprocket	1	A87	heating pipe	1
A34	tension sprocket shaft	1	A88	heating pipe	2
A35	sprocket chain	1	A89	screw	3
A36	sprocket wheel	1	A90	screw	4
A37	screw	1	A91	cushion	3
A38	bearing block	1	A92	screws	6
A39	Bearing bush	1	A93	screws	1
A40	gasket	1	A94	glue tank	1
A41	screws	4	A95	scroll cover	1
A42	gule pointer	1	A96	screws	1
A43	screws	1	A97	blocking board	1
A44	blocking_plate	1	A98	glue shaft base	1
A45	control board shaft	1	A99	glue shaft	1
A46	glue quantity control board	1	A100	blocking sheath	1
A47	flat washer	6	A101	screws	3



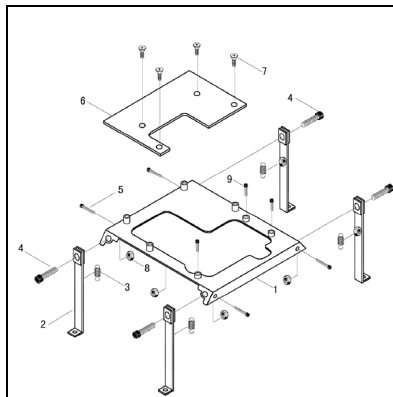
<b>A48</b>	bearing	1	<b>A102</b>	glue tank cover	1
<b>A49</b>	motor switch	1	<b>A103</b>	knob	1
<b>A50</b>	motor rubber wheel	1	<b>A104</b>	Round Glass	1
<b>A51</b>	handle II	1	<b>A105</b>	nut	3
<b>A52</b>	handle II sheath	1	<b>A106</b>	thermoelectric couple	1
<b>A53</b>	pressure roller shaft	2	<b>A107</b>	pressure spring	2

#### KAM55V\_230V\_B



No.	Description	Qty.	No.	Description	Qty.
<b>B1</b>	screws	2	<b>B14</b>	frame	1
<b>B2</b>	terminal block	1	<b>B15</b>	flush block	1
<b>B3</b>	nut	8	<b>B16</b>	clamp	1
<b>B4</b>	terminal	1	<b>B17</b>	power light	1
<b>B5</b>	terminal board	1	<b>B18</b>	power switch	1
<b>B6</b>	screws	6	<b>B19</b>	screws	2
<b>B7</b>	relay base	1	<b>B20</b>	screws	3
<b>B8</b>	relay	1	<b>B21</b>	fuse-link	1
<b>B9</b>	frame base	1	<b>B22</b>	plug	1
<b>B10</b>	handle II	5	<b>B23</b>	screws	4
<b>B11</b>	screws	6	<b>B29a</b>	capacitor	1
<b>B12</b>	temperature control meter	1	<b>B29b</b>	speed controller	1
<b>B13</b>	potentiometer	1			

#### KAM55V\_230V\_C



No.	Description	Qty.
<b>C1</b>	bucket assembly	1
<b>C2</b>	support leg	4
<b>C3</b>	tension spring	4
<b>C4</b>	axis pin	4
<b>C5</b>	screws	7
<b>C6</b>	work table	1
<b>C7</b>	screws	4
<b>C8</b>	nut	4

## 20 ZUBEHÖR / ACCESSORIES

**(DE)** Optionales Zubehör finden Sie online auf der Produktseite, Kategorie EMPFOHLENES ZUBEHÖR ZUM PRODUKT.

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