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Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN USER MANUAL

VORSCHUBAPPARAT 4 Geschwindigkeiten

POWER FEEDER 4 speed



SF324N



**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 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!

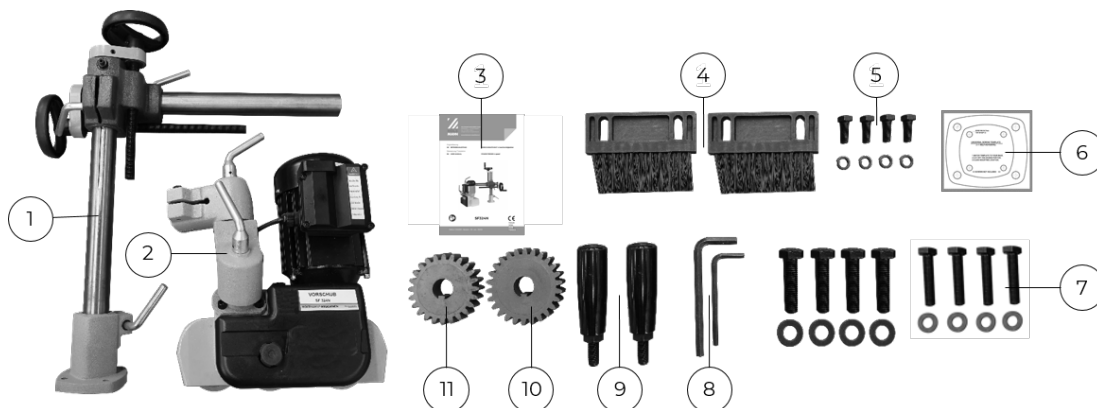
DE **Warnschilder und/oder Aufkleber an der Maschine, die unleserlich sind oder entfernt wurden, sind umgehend zu erneuern.**

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



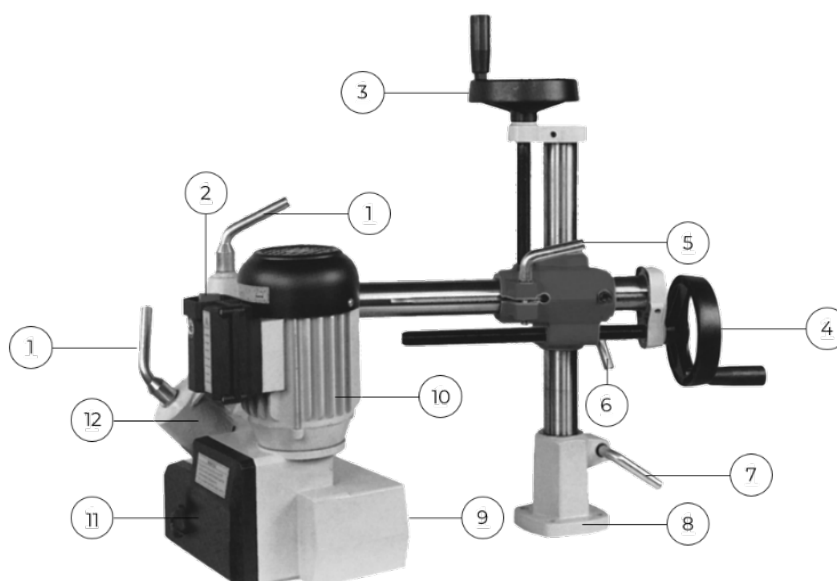
3 TECHNIK / TECHNICS

3.1 Lieferumfang / Delivery content



#	Beschreibung / Description	Qty.
1	Zweistangenstativ / dual rod device	1
2	Vorschubapparat / power feeder	1
3	Betriebsanleitung / user manual	1
4	Schmutzbürsten / dust brushes	2
5	Befestigungsschrauben und Distanzscheiben / mounting screws and washers	4
6	Bohrschablone / hole pattern	1
7	Montagematerial Gewindebohrung / mounting hardware direct mounting	8
8	Inbusschlüssel / allen keys	2
9	Griffe / handles	2
10	Zahnrad Z26 / gear T26	1
11	Zahnrad Z24 / gear T24	1

3.2 Komponenten / Components





#	Beschreibung / Description
1	Klemmhebel Multifunktionsgelenk / lock lever multifunctional joint
2	Schalter Vorschub / feed switch
3	Handrad Vertikalverstellung / handwheel vertical travel
4	Handrad Horizontalverstellung / handwheel horizontal travel
5	Klemmhebel Horizontalverstellung / lock lever horizontal travel
6	Klemmhebel Vertikalverstellung / lock lever vertical travel
7	Klemmhebel Drehverstellung / lock lever rotary movement
8	Halterung / base
9	Antriebsrollen / drive rollers
10	Motor / motor
11	Getriebe / gearbox
12	Multifunktionsgelenk / multifunctional joint

3.3 Technische Daten / Technical data

Spezifikation / Specification	
Spannung / voltage	230 V / 50 Hz 400 V / 50 Hz
Motorleistung S1 (100 %) / motor power S1 (100 %)	250 W
Vorschubgeschwindigkeiten (4 Stufen) / feeding speeds (4 steps)	5 6,5 8 11 m/min
Antriebsrollen / drive rollers	3
Antriebsrollenmaße (ØxB) / drive rollers dimensions (ØxW)	Ø 80 x 30 mm
Federweg Antriebsrollen / spring deflection drive rollers	12 mm
max. Werkstückhöhe / max. workpiece height	125 mm
Vertikalverstellung / travel vertical	250 mm
Horizontalverstellung / travel horizontal	160 mm
Ölmenge / oil volume	100 ml
Anschlusskabelänge / cord length	1,6 m
Maschinenmaße (LxBxH) / machine dimensions (LxWxH)	890x305x590 mm
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH)	560x560x270 mm
Gewicht Brutto / weight gross	31,5 kg
Gewicht Netto / weight net	29 kg
Schalldruckpegel L _{PA} / sound pressure level L _{PA}	< 70 dB(A)

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

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



11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the POWER FEEDER 4 speed SF324N, hereinafter referred to as “machine” in this document.



This manual is part of the machine and must not be removed. Save it for later reference and if you let other people use the machine, add this manual to the machine.

Please read and note the safety instructions!

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

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

We reserve the right to make technical changes!

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

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

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

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:

Feeding workpieces of wood, wood composites or materials with similar physical properties to wood in combination with woodworking machines, within the prescribed technical limits.

The positioning and guiding of the workpiece must be done by the operator.

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)	-25 °C to +55 °C

12.1.2 Prohibited applications / Dangerous misuse

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

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

12.2 User requirements

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

Basic knowledge of woodworking especially the correlation of material, tool, feed and speeds.



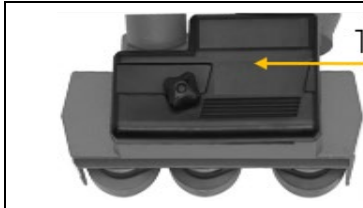
Please note that locally applicable laws and regulations determine the minimum age of the operator and may restrict the use of this machine!

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

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

12.3 Safety devices

The machine is equipped with the following safety devices:



Protective device gear cover (1)

12.4 General safety instructions

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

- Check the machine for completeness and function before starting. Only use the machine if the separating and other non-separating protective devices required for machining have are fitted.
- Make sure that the guards are in good working order and properly maintained.
- Mount the machine securely to the woodworking machine being used to prevent it from lifting off or falling over when feeding.
- 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.).
- Remove tool keys and other setting tools before switching on the machine.
- Check the machine's connections for strength before each use.
- Never leave the running machine unattended. Switch off the machine before leaving the working area and secure it against unintentional or unauthorized restarting.
- The machine may only be operated, maintained or repaired by persons who are familiar and who have been informed about the dangers arising from this work.
- Ensure that unauthorized persons keep a safety distance from the machine and keep children away from the machine.
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine.
- Hide long hair under hair protection.
- Wear close fitting protective work clothing and suitable protective equipment (eye protection, dust mask, ear protection, safety-shoes, work gloves only when handling tools).
- Never wear loose jewellery, loose clothing or accessories (e.g. tie, scarf).
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!
- Do not use the machine in areas where vapours of paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Shut down the machine and disconnect it from the power supply, before adjustment, changeover, cleaning, maintenance or repair work, etc. Before starting work on the machine, wait until all tools or machine parts have come to a complete standstill and secure the machine against unintentional restart.
- Warning signs and/or stickers on the machine that are illegible or have been removed must be replaced immediately!



12.5 Electrical safety

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

12.6 Special safety instructions for this machine

- Refer to the operating instructions of the woodworking machine used
- Never feed several workpieces at the same time
- Do not feed long workpieces without providing sufficient support such as table extensions, saw blocks, etc. at the outfeed end of the wood working machine
- Always stop the feeder before stopping the cutting tool
- Make sure all cutting tools are rotating at the operating speed before feeding the workpiece and adapt the feeding speed to the machining speed.
- Keep all body parts away from rotating parts of the machine and the machining tool. Do not allow hands or clothing to be pinched between the rollers and workpiece.
- Work only in well-ventilated rooms!
- Keep the machine away from potential ignition sources such as open flames – risk of fire and explosion!

12.7 Hazard warnings

12.7.1 Residual risks

Despite intended use, certain residual risk factors remain.

- Risk of injury to hands/fingers due to crushing between moving and fixed parts (stops, workpiece supports,...)
- Risk of injury from the workpiece falling down from the rear of the machine.
- Risk of injury due to improper maintenance activities.

12.7.2 Hazardous situations

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

DANGER



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

WARNING



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

**CAUTION**

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

NOTE

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

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

13 TRANSPORT

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.

14.1.2 Preparation of the surfaces

Before putting the machine into operation, carefully remove the anti-corrosion protection or grease residues from the bare metal parts. This can be done with the usual solvents. Under no



circumstances should you use nitro thinners or other cleaning agents, as these can attack the machine's finish.

NOTE



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

Therefore: Use only mild cleaning agents!

14.2 Assemble

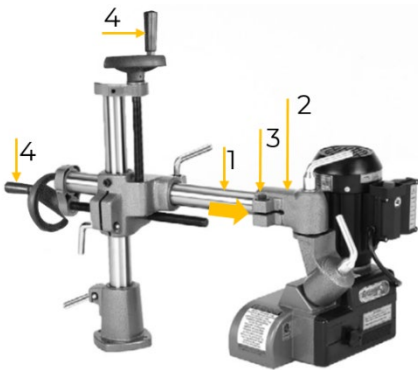
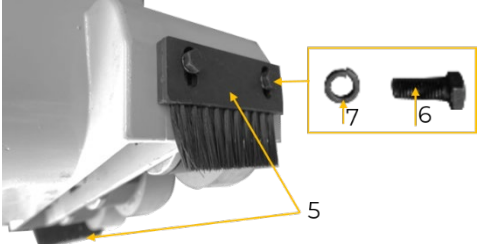
NOTE



The machine and machine components are heavy!

2 persons are required to assemble the machine.

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

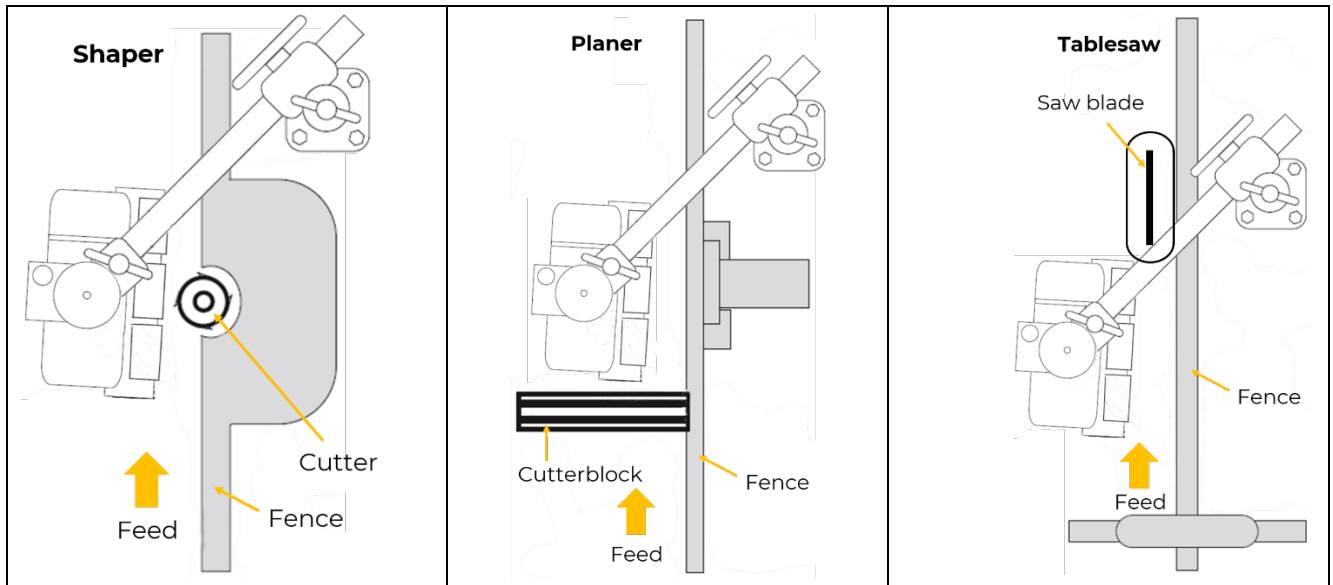
	<ol style="list-style-type: none">1. Insert the end of the rod of the horizontal travel (1) into the multi-function joint (2) and fix with the clamping screw (3).2. Turn in the handles (4)
	<ol style="list-style-type: none">3. Fix the dust brushes (5) with screws (6) and spring washers (7) on the drive rollers cover

14.3 Mounting on woodworking machine

Find the suitable fastening position for the respective woodworking machine. From this position it must be possible to adjust the drive rollers so that they press on the workpiece parallel to the worktable and ensure safe feeding of the workpiece.



Examples:



Monting options:

- Through-Bolt mounting
- Direct mounting

In order to achieve an exact drilling pattern, use the hole pattern provided. Pay attention to grooves and struts under the worktable and choose the appropriate mounting variant.

NOTE: Only mounting hardware for direct mounting is included in the delivery content

	<p>Through-Bolt mounting:</p> <ul style="list-style-type: none"> • Drill holes by using the hole pattern • Fix the base (1) with bolt (2), washers (3), spring washer (4) and nut (5) onto the worktable
	<p>Direct mounting:</p> <ul style="list-style-type: none"> • Drill holes by using the hole pattern • Cut a suitable thread (7) into the worktable • Fix the base (1) with bolt (2), spring washer (4) and washer (3) onto the worktable

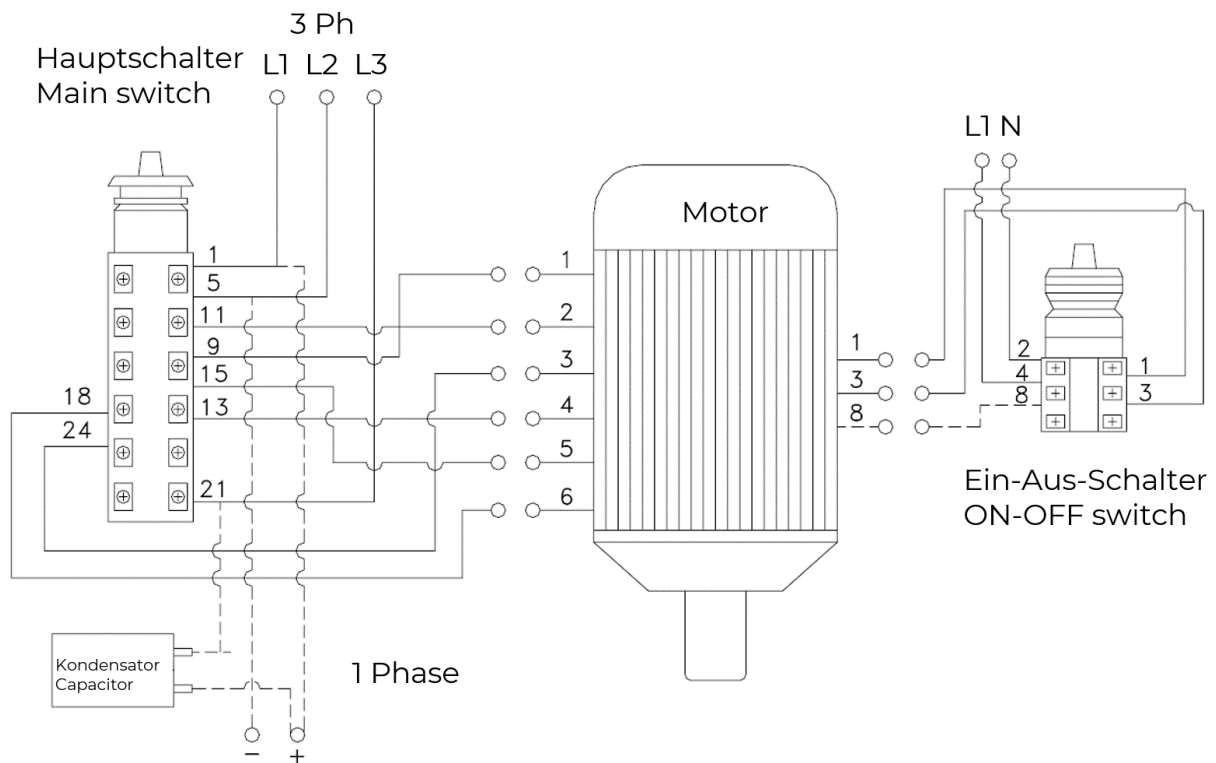


14.4 Electrical connection

The power feeder will be operated in conjunction with woodworking machines and may only be used with machines whose electrical connection complies with local regulations.

The electrical connection of the power feeder to the machine must ensure that the main switch and the emergency stop switch of the machine also control the power supply to the power feeder. In addition, the current tap must provide an overload and under voltage protection systems.

Example:



WARNING



Dangerous electrical voltage!

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

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

NOTE



Deviation of the supply voltage and frequency!

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

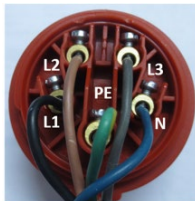
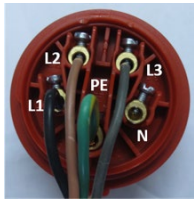
- Use a supply cable of type H07RN (WDE282) and take the required cross-section of the supply cable from a current carrying capacity table. Pay attention to the measures for protection against mechanical damage.
- Make sure that the power supply is protected by a residual current circuit breaker.
- Connect the device only to a properly grounded outlet.



- When using an extension cable, make sure that the dimension matches the connected load of the machine. The connection power can be found in the technical data, the correlation of cable cross-section and cable lengths can be found in the technical literature or obtain information from a specialist electrician.
- A damaged cable must be replaced immediately.

14.4.1 Setting up a 400 V machine

- The grounding conductor is yellow-green.
- Connect the supply cable to the corresponding terminals in the input box (L1, L2, L3, N and PE), see the figure below. If a CEE plug is available, the connection to the mains is made through an appropriately powered CEE coupling (L1, L2, L3, N and PE).

Plug connection 400V:	5-wire: with N-conductor		4-wire: without N-conductor	
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- After the electrical connection, check the correct running direction. If the machine runs in the wrong direction, swap two conductive phases, e.g. L1 and L2, at the connection plug.

NOTE



- Operation is only permitted with residual current device (RCD) with maximum residual current of 30 mA.

15 OPERATION

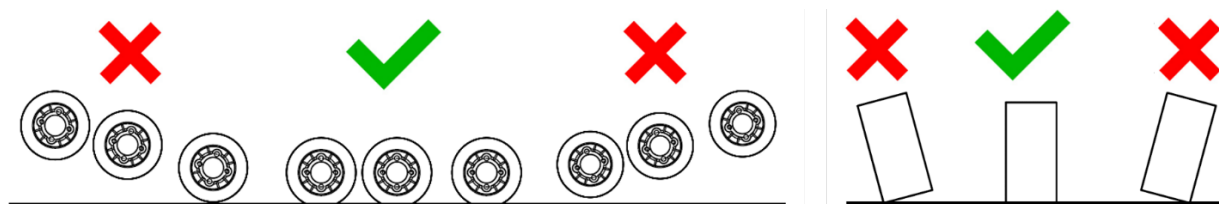
Only operate the machine when it is in a perfect condition. Before each operation, a visual inspection of the machine must be carried out. Safety devices, operating elements and electrical lines must be checked carefully. Check screw connections for damage and tight fit.

15.1 Operating instructions

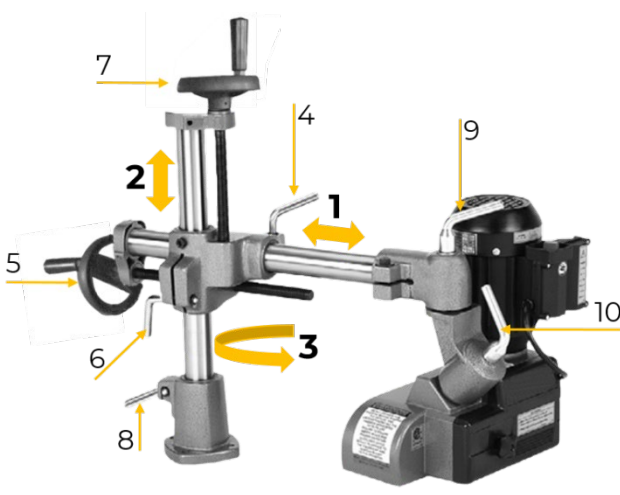
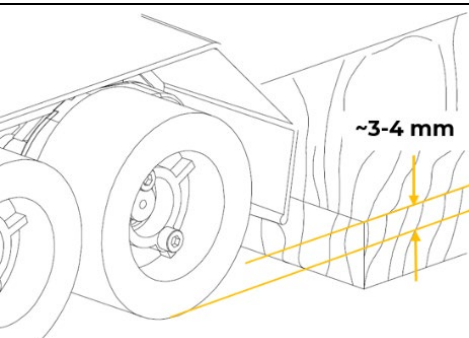
- To ensure a safe contact of the workpiece to the fence, set the distance between the fence and the first roller approx. 3 - 5 mm larger than the distance of the last roller. (Set approx. 1° to 1.5° towards the workpiece stop).
- When adjusting the machine, pay attention to the machine's centre of gravity, especially with smaller woodworking machines. The woodworking machine may tip over.

15.2 Handling

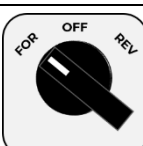




15.2.1 Set position





	<p>1: Horizontal travel</p> <ul style="list-style-type: none"> Loosen lock lever (4) Set the position with handwheel (5) Fix lock lever (4) <p>2: Vertikal travel</p> <ul style="list-style-type: none"> Loosen lock lever (6) Set the position with handwheel (7) Fix lock lever (6) <p>3: Turning the machine</p> <ul style="list-style-type: none"> Loosen lock lever (8) Turn the machine Fix lock lever (8) <p>Multifunctional joint:</p> <ul style="list-style-type: none"> Loosen lock lever (9, 10) Set machine in position Fix lock lever (9, 10)
	<ul style="list-style-type: none"> The correct contact pressure of the drive rollers to the workpiece is achieved when the drive rollers spring deflection is approx. 3-4 mm.

15.2.2 Switch the machine on and off

		<p>Switch on feeding backward</p> <ul style="list-style-type: none">Set switch to position FOR
		<p>Switch on feeding forward</p> <ul style="list-style-type: none">Set switch to position REV
		<p>Switch off</p> <ul style="list-style-type: none">Set switch to position OFF

15.2.3 Setting the feed speed

The correct feed speed (B in m/min) is very important for good quality and efficiency. It depends on the speed (min^{-1}) of the woodworking machine, the sharpness and type of the cutting tool (C), the hardness and thickness of the material to be machined (A).



Reference value table:

min ⁻¹		6000			8000			10000		
A	B	C								
	6 mm		9	15	23	9	15	23	15	23
	10 mm		8	12	15	8	15	15	12	15
	20 mm		5	9	12	6	12	12	8	12
	25 mm		3	5	6	5	6	8	6	9

WARNING



Danger due to electrical voltage!

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

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

	GEAR	SPEED	<p>Refer to the change gear table to find the gear combination (A and B) required for your chosen feed speed</p>
	A20 – B30	5 m/min	
	A24 – B26	6.5 m/min	
	A26 – B24	8 m/min	
	A30 – B20	11 m/min	
			<ol style="list-style-type: none"> 1. Loosen the starscrew (1) 2. Remove the gear cover (2) 3. Loosen nuts (3) 4. Put the gears in the required position (A and B) 5. Fix the gears with the nuts 6. Remount the gear cover

16 CLEANING, MAINTENANCE, STORAGE, DISPOSAL

WARNING



Danger due to electrical voltage!

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

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



16.1 Cleaning

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

NOTE



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

- Remove chips and dirt particles from the machine after each use with a proper tool.
- Prepare the surfaces and lubricate the bare machine parts with an acid-free lubricating oil (e.g. WD40 rust inhibitor).

16.2 Maintenance

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

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

16.2.1 Maintenance plan

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

Intervall	Komponenten	Maßnahme
Before usage	• Cabel connection	• Check and replace, if damaged
	• Screw connections	• Check for tightness and tighten if necessary
	• Drive roller	• Check for tightness and wear, change if necessary
Every 200 operating hours	• Drive roller bearing	• Lubricate
	• Chain, sprocket, gears	• Lubricate
First after 200 operating hours, thereafter every 1000 operating hours	• Feeding gear	• Oil change

16.2.2 Oil change feeding gear

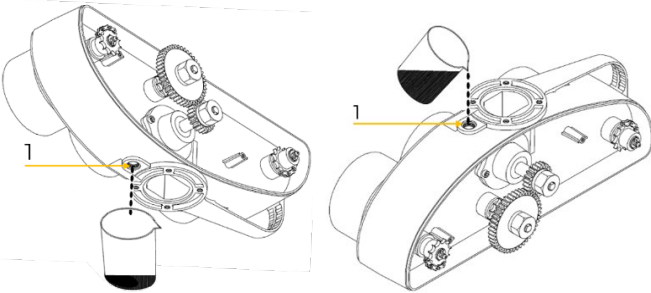
NOTICE




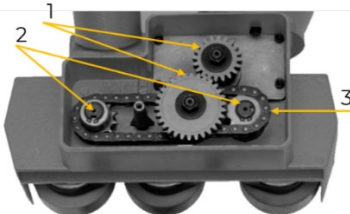
Lubricants are toxic and must not be released into the environment. When changing, use suitable collecting containers with sufficient volume! Follow the manufacturer's instructions and, if necessary, contact your local authority for further information on proper disposal.



Supply gear oil (recommended for ISO 12925-1 CKD, DIN51517 Part 3 CLP, US Steel 224, AGMA 9005-E02) with a viscosity of 220.

	<ul style="list-style-type: none"> • Turn the machine upside down • Remove the oil cap (1) • Drain the oil • Turn the machine back • Fill in new oil (appr. 100ml) • Put on the oil cap (1)
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16.2.3 Lubrication

	<ul style="list-style-type: none"> • Lubricate the drive roller bearings on the grease fittings with a grease gun filled with grease (NLGI-grade 2)
	<ul style="list-style-type: none"> • Lubricate gears (1), sprockets (2) and the chain (3) lightly with grease (NLGI-grade 2)

16.2.4 Drive rollers change

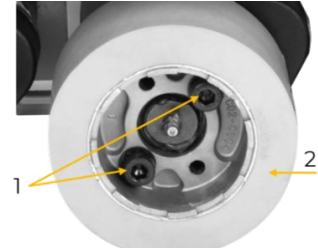
NOTE



Change all drive rollers of the machine at the same time.

Different outside diameter will cause faster wear-out.

To compensate for wear, changing the position of the drive rollers can increase the service life.

	<ul style="list-style-type: none"> • Loosen the screws (1) • Change the drive rollers (2) • Refix them with screws (1)
---	---

16.3 Storage

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

**NOTE**

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

16.4 Disposal

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

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

17 TROUBLESHOOTING**WARNING****Danger due to electrical voltage!**

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

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

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

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

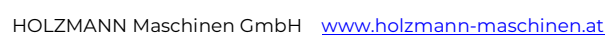
Trouble	Possible cause	Solution
Motor does not run	• Switch defective	• Repair switch
	• Cable damaged	• Replace cable
	• Fuse damaged	• Replace fuse
	• No power supply	• Check power supply
Motor overheats	• Motor overloaded	• Reduce feeding speed
	• Not enough cooling	• Clean ventilation slots
Workpiece jams when feeding under drive rollers	• Drive rollers set to low	• Raise the machine
	• Maschine is set to a wrong angle	• Set the angle of the machine parallel to the workpiece
Drive rollers slip on the workpiece	• Drive rollers set to high	• Lower the machine
	• Feeding speed too fast	• Reduce feeding speed
	• Drive rollers are dirty or oily	• Clean the drive rollers
	• Worn drive rollers	• Replace drive rollers



Workpiece cut is burnt	<ul style="list-style-type: none">• Wrong feeding speed	<ul style="list-style-type: none">• Adjust feeding speed
	<ul style="list-style-type: none">• Blunt cutting tool	<ul style="list-style-type: none">• Sharpen or replace cutting tool
Rough finish or broken edges on workpiece	<ul style="list-style-type: none">• Feeding speed too fast	<ul style="list-style-type: none">• Reduce feeding speed
	<ul style="list-style-type: none">• Blunt cutting tool	<ul style="list-style-type: none">• Sharpen or replace cutting tool
	<ul style="list-style-type: none">• Machine angle is not toed in to keep workpiece against the fence	<ul style="list-style-type: none">• Set the machine approx. 1° to 1.5° towards the workpiece stop



18.1 230 V / 50 Hz





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/NEWS/FAQ – 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

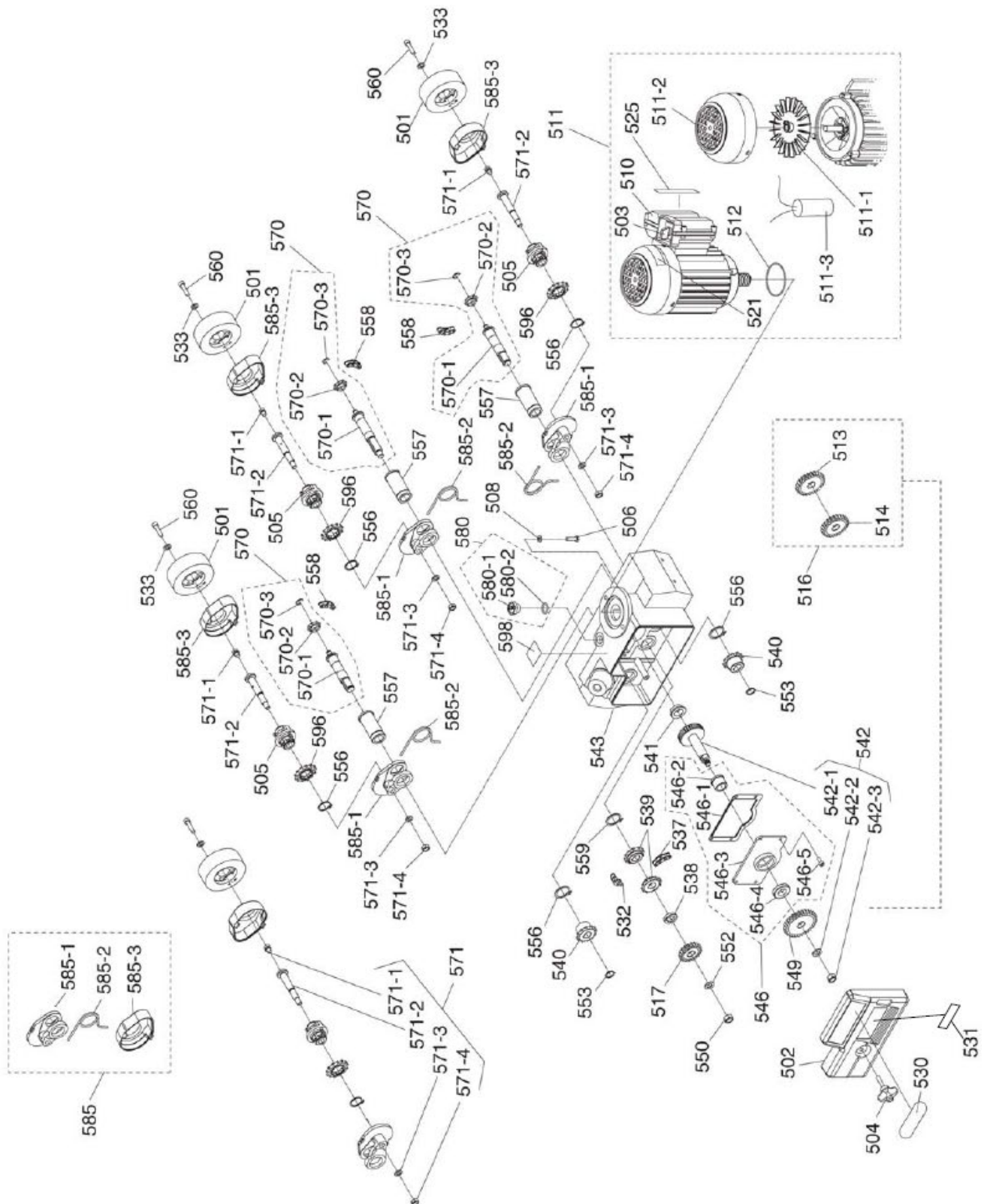
- via our Homepage – category SERVICE/NEWS/FAQ - SPARE PARTS REQUEST,
- by e-mail to service@holzmann-maschinen.at.

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.



19.2 Explosionszeichnung / Exploded view

Power feeder

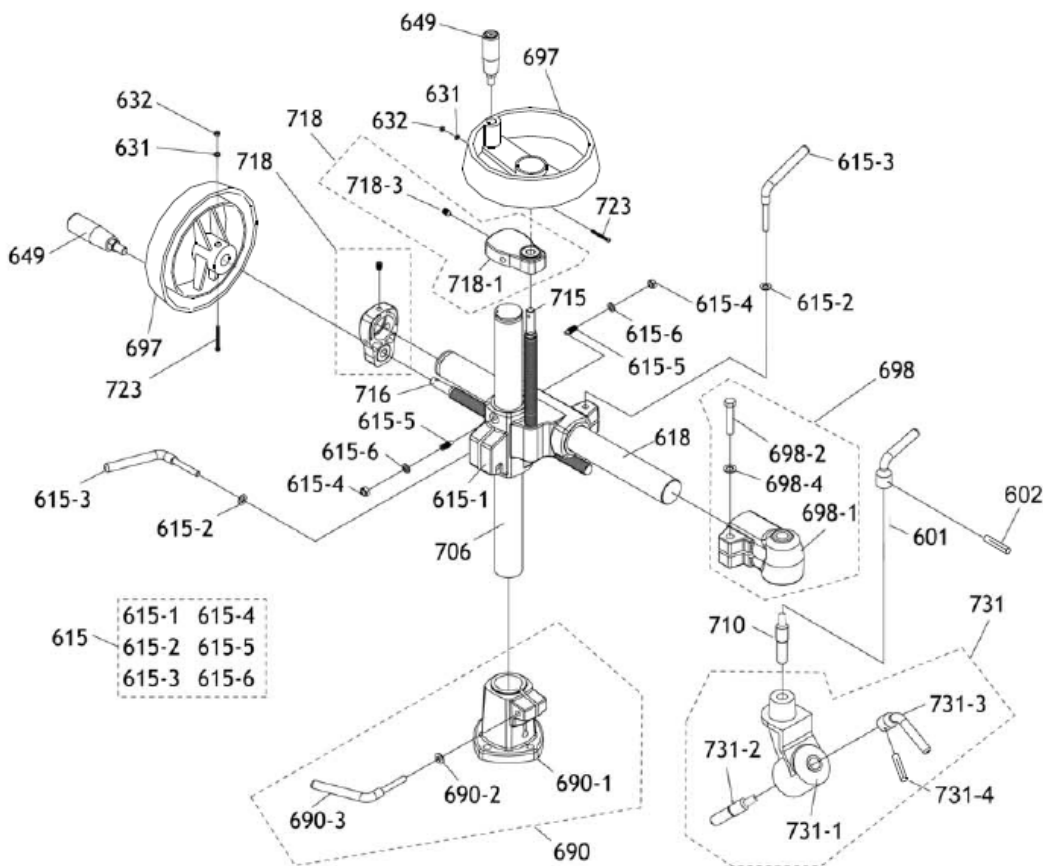




No.	Description	No.	Description
501	Rubber wheel	546	Worm gear box cover assembly
502	Gear cover	546-1	Gasket
503	Switch assembly	546-2	Bushing
504	Knob bolt	546-3	Cover
505	Sprocket bushing	546-4	Seal
506	Hex bolt M6-1x20	546-5	Cap screw M5-8x12
508	Flat washer 6mm	549	Gear 30T
510	Switch box assembly	550	Hex nut M10-1.5
511	Motor	552	Flat washer 10mm
511-1	Motor fan	553	Ext retaining ring 13mm
511-2	Fan cover	556	Ext retaining ring 24mm
511-3	Capacitor 20mF 250V	557	Tube
512	Seal	558	Chain assembly (18S)
513	Gear 24T	559	Ext retaining ring 24mm
514	Gear 26T	560	Cap screw M6-1x25
516	Gear set 24T, 26T	570	Sprocket shaft assembly
517	Gear 20T	570-1	Sprocket shaft
521	Switch direction level	570-2	Sprocket
525	Electricity warning label	570-3	E-clip 13mm
530	Domed Holzmann label	571	Sprocket shaft assembly
531	Cover warning label	571-1	Grease nipple
532	Chain	571-2	Shaft
533	Lock washer 6mm	571-3	Lock washer 8mm
537	Chain	571-4	Hex nut M8-1.25
538	Bushing	580	Oil cap assembly
539	Sprocket	580-1	Oil cap
540	Sprocket	580-2	O-ring 18.8x2.4 P16
541	Bushing	585	Sprocket case assembly
542	Worm gear shaft assembly	585-1	Sprocket case
542-1	Worm gear shaft	585-2	Spring 36x6
542-2	Flat washer 3/8	585-3	Case cover
542-3	Hex nut M10-1.5	596	Sprocket
543	Frame	598	Lubrication label




Base



No.	Description	No.	Description
601	Lever	698	Over arm cone assembly
602	Hollow pin	698-1	Overarm cone
615	Elevating bracket assembly	698-2	Hex bolt M10-1.5x50
615-1	Elevating bracket	698-4	Lock washer 10mm
615-2	Flat washer 8mm	706	Elevating shaft
615-3	Lever M8-1.25	710	Screw shaft
615-4	Nut M8	715	Elevating screw
615-5	Dog point set screw	716	Leadscrew
615-6	Lock washer 8mm	718	Column cap assembly
618	Over arm shaft	718-1	Column cap
631	Lock washer 4mm	718-3	Set screw M8-1.25x10
632	Hex nut M4-7	723	Phlp HD screw M4-7m35
649	Handle	731	Swivel cone assembly
690	Base assembly	731-1	Swivel cone
690-1	Base	731-2	Screw shaft
690-2	Flat washer	731-3	Lever M16-2
690-3	Lever M8-1.25	731-4	Hollow pin
697	Hand wheel		

**20 EU-KONFORMITÄTSERKLÄRUNG / CE-CERTIFICATE OF CONFORMITY**

	Inverkehrbringer / Distributor HOLZMANN MASCHINEN® GmbH 4170 Haslach, Marktplatz 4, AUSTRIA Tel.: +43 7289 71562-0 www.holzmann-maschinen.at
Bezeichnung / name	
VORSCHUBAPPARAT 4 Geschwindigkeiten / POWER FEEDER 4 speed	
Typ / model	
SF324N	
EU-Richtlinien / EC-directives	
<ul style="list-style-type: none">• 2006/42/EC• 2014/30/EC• 2011/65/EC	
Angewandte Normen / applicable Standards	
EN 60204-1:2006+A1; EN 60034-1:2010; 60034-5:2001+A1:2007;	

(DE) Hiermit erklären wir, dass die oben genannten Maschinen aufgrund ihrer Bauart in der von uns in Verkehr gebrachten Version den grundlegenden Sicherheits- und Gesundheitsanforderungen der angeführten EU-Richtlinien entsprechen. Diese Erklärung verliert ihre Gültigkeit, wenn Veränderungen an der Maschine vorgenommen werden, die nicht mit uns abgestimmt wurden.

(EN) Hereby we declare that the above mentioned machines meet the essential safety and health requirements of the above stated EC directives. Any manipulation or change of the machine not being explicitly authorized by us in advance renders this document null and void.

Technische Dokumentation
HOLZMANN MASCHINEN GmbH
4170 Haslach, Marktplatz 4

Haslach, 11.03.2022
Ort / Datum place/date

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GmbH
Marktplatz 4, 4170 Haslach
weiterer Standort:
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www.holzmann-maschinen.at

DI (FH) Daniel Schörgenhuber
Geschäftsführer / Director