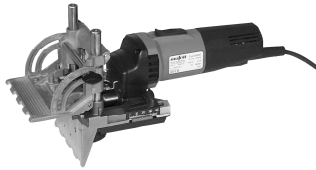


de	DuoDübler	Originalbetriebsanleitung	5
en	Duo Dowel Joiner	Original operating instructions	13
fr	Tourillonneuse portative double	Traduction de la notice d'emploi originale	21
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MAF013500a

WARNUNG

Lesen Sie alle Sicherheitshinweise und Anweisungen. Versäumnisse bei der Einhaltung der Sicherheitshinweise und Anweisungen können elektrischen Schlag, Brand und/oder schwere Verletzungen verursachen. **Bewahren Sie alle Sicherheitshinweise und Anweisungen für die Zukunft auf.**

WARNING

Please read all safety instructions and directions. Failure to comply with the safety instructions and directions can cause electric shock, fire and/or serious injuries. **Please retain all safety instructions and directions for future reference.**

AVERTISSEMENT

Veuillez lire toutes les consignes de sécurité et instructions. Tout non-respect des consignes de sécurité et instructions risque d'être à l'origine de décharges électriques, d'incendies et/ou de blessures graves. **Conservez toutes les consignes et instructions pour pouvoir les relire à tout moment.**

AVVERTENZA

Leggere tutte le avvertenze di sicurezza e le istruzioni. La mancanza del rispetto delle avvertenze di sicurezza e delle istruzioni possono causare scossa elettrica, incendio e/o gravi lesioni. **Conservare tutte le avvertenze di sicurezza e le istruzioni per il futuro.**

WAARSCHUWING

Lees alle veiligheidsaanwijzingen en instructies. Nalatigheid bij het naleven van de veiligheidsinstructies en aanwijzingen kan elektrische schok, brand en/of ernstige letsels veroorzaken. **Bewaar alle veiligheidsaanwijzingen en instructies voor later gebruik.**

ADVERTENCIA

Lea todas las indicaciones de seguridad e instrucciones. Si no se cumplen las indicaciones de seguridad e instrucciones, se pueden producir descargas eléctricas, incendios y/o lesiones graves. **Guarde todas las indicaciones de seguridad e instrucciones para el futuro.**

VAROITUS

Lue kaikki turvaohjeet ja käyttöohjeet. Laiminlyönti turvaohjeiden ja käyttöohjeiden noudattamisessa voi aiheuttaa sähköiskun, tulipalon ja/tai vakavia vammoja. **Säilytä kaikki turvaohjeet ja käyttöohjeet tulevaisuuden varalle.**

WARNING

Läs alla säkerhetsanvisningar och anvisningar. Underlåtenhet att följa säkerhetsanvisningar och anvisningar kan orsaka elstöt, brand och/eller allvariga personskador. **Behåll alla säkerhetsanvisningar och anvisning för framtida användning.**

ADVARSEL

Læs alle sikkerhedshenvisninger og instruktioner. En manglende overholdelse af sikkerhedshenvisningerne og instruktionerne kan føre til elektrisk stød, brand og/eller alvorlige kvæstelser. **Opbevar alle sikkerhedshenvisninger og instruktioner til fremtidig brug.**

D - EG Konformitätserklärung

Wir bescheinigen hiermit, dass die Maschine DD40 G/P den angeführten EU-Richtlinien entspricht. Bei Konstruktion und Bau wurden die gelisteten Normen angewendet.

Bevollmächtigter für die Zusammenstellung der technischen Unterlagen: Mafell AG

GB - EC Declaration of Conformity

We herewith confirm that the machine DD40 G/P complies with the EU directives quoted. The standards listed were used for design and construction.

Empowered person for the configuration of the technical documents: Mafell AG

F - Déclaration CE de conformité

Nous déclarons par la présente que la machine DD40 G/P est conforme aux directives CE applicables comme suit. Lors de la construction, les règlements suivants ont été utilisés.

Plénipotentiaires pour l'assemblage des documentations techniques: Mafell AG

I - Dichiarazione di conformità CE

Con la presente certifichiamo che la macchina DD40 G/P è conforme alle seguenti direttive CE applicabili. Nella progettazione e la costruzione sono state applicate le seguenti norme.

Responsabile per la composizione della documentazione tecnica: Mafell AG

NL - EG conformiteitsverklaring

Wij bevestigen hiermede dat de machine DD40 G/P aan de vermelde EU-richtlijnen beantwoord. Bij constructie en bouw werden de vermelde normen toegepast.

Gemachtigde voor de samenstelling van de technische documenten: Mafell AG

E - Declaración de conformidad CE

Con la presente se certifica que la máquina DD40 G/P cumple las directivas europeas mencionadas, las cuales forman la base tanto del diseño constructivo como de los procesos de fabricación.

Apoderado legal para la compilación de la documentación técnica: Mafell AG

FIN - EY-vaatimustenmukaisuusvakuutus

Vakuutamme täten, että kone DD40 G/P vastaa mainittujen EU-direktiivien vaatimuksia. Sen suunnittelussa ja valmistuksessa on sovellettu luettelossa ilmoitettuja standardeja.

Teknisten asiakirjojen laatimiseen valtuutettu henkilö: Mafell AG

S - EG Konformitetsförklaring

Vi intygar härmed att maskinen DD40 G/P uppfyller angivna EU direktiv. De angivna normerna användes vid konstruktion och tillverkning.

Befullmäktigad för sammanställningen av den tekniska dokumentationen: Mafell AG

DK - EU overensstemmelseserklæring

Vi attesterer hermed, at maskinen DD40 G/P opfylder de angivede EU-direktiver. Konstruktion og bygning er udført iht. de angivede standarder.

Person, der er befuldmægtiget til at sammenstille det tekniske materiale: Mafell AG



2006/42/EG

2014/30/EU

2011/65/EG

EN 60745, EN 55014-1, EN 55014-2, EN 61000-3, EN 12100 T1, EN 12100 T2, EN 1037

DD40 G/P

Art.-Nr. 916001, 916002, 916010, 916020, 916021, 916025, 916030, 916031, 916032, 916035, 916040, 916041, 916042, 916045

Mafell AG

D - 78727 Oberndorf, den 27.04.2016


Krauss

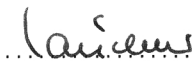

i. V. Dr. Lauckner

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1 Signs and symbols



This symbol appears at places where you will find instructions for your own safety.

Non-compliance with these instructions may result in very serious injuries.



This symbol indicates a potentially hazardous situation.

If this situation is not avoided, the product or objects in its vicinity may get damaged.



This symbol indicates tips for the user and other useful information.

2 Product information

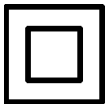
for machines with product no. 916001, 916002, 916010, 916020, 916021, 916025, 916030, 916031, 916032, 916033, 916034, 916035, 916040, 916041, 916042, 916043, 916045

2.1 Manufacturer's data

MAFELL AG, Beffendorfer Straße 4, D-78727 Oberndorf / Neckar, Phone +49 (0)7423/812-0, Fax +49 (0)7423/812-218

2.2 Machine identification

All details required for machine identification are available on the attached rating plate.



Protection class II



CE symbol to document compliance with the basic safety and health requirements according to Appendix I of the Machinery Directive.



For EU countries only

Do not dispose of electric tools together with household waste material!

In accordance with the European directive 2002/96/EC on waste electrical and electronic equipment and transposition into national law, obsolete electrical tools must be collected separately and recycled in an environmentally-compatible manner.



To reduce the risk of injury, please read the operating instructions.

2.3 Technical data

	DD40P	DD40G
Universal motor, radio and TV interference suppressed	230 V~, 50 Hz or 110 V~, 50 Hz	230 V~, 50 Hz or 110 V~, 50 Hz
Power input (nominal load)	1000 W	700 W
Current at nominal load	4,3 A (230 V) or 9,1 A (110 V)	3,0 A (230 V) or 6,4 A (110 V)
Drill clearance	32 mm (1 1/4 in.)	32 mm (1 1/4 in.)
Drilling depth	0 - 40 mm (0 - 1 9/16 in.)	0 - 37 mm (0- 17/16 in.)
Swivel range	0 - 90°	0 - 90°
Tool diameter maximum	16 mm (5/8 in.)	12 mm (15/32 in.)
Tool diameter minimum	6 mm (15/64 in.)	3 mm (1/8 in.)
Tool receiving bore	8 mm (5/16 in.)	8 mm (5/16 in.)
Tool idling speed	13500 rpm	18500 rpm
Hose connector diameter	35 mm (1 3/8 in.)	35 mm (1 3/8 in.)
Weight without mains cable	2,8 kg	2.8 kg (6.2 lbs)
Dimensions (W x L x H)	130 x 300 x 185 mm (5 1/8 x 11 13/16 x 7 1/4 in.)	130 x 300 x 185 mm (5 1/8 x 11 13/16 x 7 1/4 in.)

2.4 Noise emission specifications

Noise emission values determined according to EN 60745-1:

	Sound power level	Workplace-related emission value
Idling	100 dB (A)	89 dB (A)

The noise measurement was recorded using the tool included in the standard equipment.

The values stated do not take into consideration any possible series variances and are not suitable for determining the rating levels, as these fluctuate in dependence on the time in service, the respective type of machining and the environmental influences. The noise rating level can therefore only be determined on an individual basis at the machine user's position.

2.5 Vibration specifications

The typical hand-arm vibration is less than 2.5 m/s².

2.6 Scope of supply

DD40G MidiMAX

Item No. 916001, 916020, 916021, 916025

2 carbide-tipped dowel drill bits ø 8 mm (5/16 in.)

1 pack of MAFELL special dowels ø 8x30 mm (5/16 x 1 3/16 in.)

(approx. 200 pcs.)

1 bottle of glue

2 anti-slip mats

1 Allen key with handle

1 service tool in bracket on the machine

1 carrying case

1 operating manual

1 folder "Safety Instructions"

DD40G MaxiMAX

Item No. 916002, 916030, 916031, 916032, 916033, 916034, 916035

2 carbide-tipped dowel drill bits ø 6 mm (1/4 in.)

2 carbide-tipped dowel drill bits ø 8 mm (5/16 in.)

2 carbide-tipped dowel drill bits ø 10 mm (3/8 in.)

1 pack of MAFELL special dowels ø 6x30 mm (1/4 x 1 3/16 in.)

(approx. 350 pcs.)

- 1 pack of MAFELL special dowels \varnothing 8x30 mm (5/16 x 1 3/16 in.)
(approx. 200 pcs.)
- 1 pack of MAFELL special dowels \varnothing 10x40 (3/8 mm x 1 9/16 in.)
(approx. 100 pcs.)

Further scope of delivery:

- 1 bottle of glue
- 1 dowel nozzle \varnothing 8 mm (5/16 in.)
- 2 anti-slip mats
- 1 Allen key with handle
- 1 service tool in bracket on the machine
- 1 carrying case
- 1 operating manual
- 1 folder "Safety Instructions"

DD40P PowerMAX

Item No. 916010, 916040, 916041, 916042, 916043, 916045

- 2 carbide-tipped dowel drill bits \varnothing 8 mm (5/16 in.)
- 2 carbide-tipped dowel drill bits \varnothing 10 mm (25/64 in.)
- 2 carbide-tipped dowel drill bits \varnothing 12 mm (15/32 in.)
- 1 pack of MAFELL special dowels \varnothing 8x30 mm (5/16 x 1 3/16 in.)
- 1 pack of MAFELL special dowels \varnothing 10x40 mm (3/8 x 1 9/16 in.)
- 1 pack of MAFELL special dowels \varnothing 12x60 mm (1/2 x 2 3/8 in.)

Further scope of delivery as MaxiMAX

2.7 Safety devices



Danger

These devices are required for the machine's safe operation and may not be removed or rendered inoperative.

The machine is equipped with the following safety devices:

- Protection against contact with the bits
- Large bearing faces of limit stops
- Handles and handle supports
- Hose connector

2.8 Use according to intended purpose

The DuoDübler is exclusively intended for drilling of solid wood and panel materials such as chip board, coreboard and Mdf-boards, using the drill bits permitted, with diameters between 3 mm and 12 mm (1/8 and 15/32 in.) (DD40G) and from 6 mm to 16 mm (15/64 and 5/8 in.) (DD40P).

Any other use than described above is not permissible. The manufacturer cannot be held liable for any damage arising from such other use.

In order to use the machine as intended, comply with the operating, maintenance, and repair instructions specified by Mafell.

2.9 Residual risks



Danger

Even if used in accordance with its intended purpose and despite conforming with the safety instructions, residual risks caused by the intended use will always remain.

- Touching the drill bits when fitted in or when outside the base plate.
- Touching the drill bits on the workpiece rear when drilling.
- Breakage of the drills and risk of the drill bits or parts of them being hurled away.
- Touching live parts with the housing open and the mains plug not removed.
- Hearing can be impaired when working for long periods without ear protectors.
- Emission of harmful wood dusts during longer operation without extraction.

3 Safety instructions



Danger

Always observe the following safety instructions and the safety regulations applicable in the respective country of use!

General instructions:

- Children and adolescents must not operate this machine. This rule does not apply to young persons receiving training and being supervised by an expert.
- Never work without the protection devices prescribed for the respective operating sequence and do not make any changes to the machine that could impair safety.
- When operating the machine outdoors, use of an earth-leakage circuit-breaker is recommended.
- Damaged cables or plugs must be immediately replaced.
- Avoid sharp bends in the cable. Especially when transporting and storing the machine, do not wind the cable around the machine.

Do not use:

- Damaged drill bits and drill bits that have changed their form.
- Blunt drill bits as they impose an excessive load on the motor.
- Drill bits that are not suitable for the drill's idling speed.

Instructions on the use of personal protective equipment:

- Always wear ear protectors during work.
- Always wear a dust mask during work.

Instructions on operation:

- Do not reach with your hands into the drilling area and do not touch the drill bits. With your other hand, support the supplementary handle or the motor casing.
- Do not reach under the workpiece.
- Never support the workpiece in your hand or over your leg. Secure the workpiece against a sturdy support.
- Only hold the device by its isolated handle surfaces when carrying out work during which the

cutting tool could hit hidden power cables or its own connection cable.

- Before starting to drill, tighten the drilling depth and cutting angle adjustments.
- Examine the workpiece for foreign objects. Never attempt to drill into nails or other metal objects.

Instructions on service and maintenance:

- Regularly cleaning the machine, especially the adjusting devices and guides, constitutes an important safety factor.
- Only original MAFELL spare parts and accessories may be used. Otherwise, the manufacturer will not accept any warranty claims and cannot be held liable.

4 Setting / Adjustment

4.1 Mains connection

Prior to commissioning make sure that the mains voltage complies with the operating voltage stated on the machine's rating plate.

4.2 Chip extraction

Connect the machine to a suitable external dust extractor during all work generating a considerable amount of dust. The air velocity must be at least 20 m/s (65.6 ft / sec.).

The inside diameter of hose connector 1 (Fig. 1) is 35 mm (1 3/8 in.).

4.3 Selection of tools

Use the dowel drill bits listed in chapter 8 "Special Accessories".

These carbide-tipped drills were developed specially for the DD40G/P and are suitable for all types of wood.

4.4 Tool change



Danger

Pull the power plug during all service work.

The basic requirement for correct drilling are well ground drill bits.

Proceed as follows for the tool change:

- Turn the tool holding fixture 2 (Fig. 2) such that the screws 3 are on top.
- Unfasten the screws with the Allen key.
- Pull off the drill bits 4 to the front.
- Push the new drill bits into the tool holding fixture up to the limit stop. Align the plain surface of the drill bits with the screw holes.
- Tighten the screws against the plain surfaces.
- Check the drill bits' seat.



After the tool change, you have to readjust the zero setting for the drill depth.

- Unfasten the wing nut 11 (Fig. 3)
- Completely swing open the tilting stop 9.
- Tighten the wing nut 11.
- Place the machine with the swung open limit stop onto a flat surface.
- Push the motor casing 5 forward until the tip of the drill bears on this surface.
- Unfasten the wing screw 6.
- Push the depth stop 7 up to the limit stop to the top and tighten the wing screw.
- Push the indicator 8 to zero.

4.5 Pivot adjustment



The tilting stop 9 (Fig. 3) can be continuously adjusted in the range from 0° to 90°. Three latching positions facilitate a fast setting of the angles 22.5°, 45° and 67.5°.

- Unfasten the wing screw 11.
- Tilt the tilting stop to the desired angle.
- Retighten the wing nut.

4.6 Drill depth adjustment



The drill depth can be continuously adjusted in a range between 0 - 37 mm (0 - 1 7/16 in.) on the DD40G or 0 - 40 mm (0 - 1 9/16 in.) on the DD40P.

- Unfasten the wing nut 6 (Fig. 3)
- Push the depth stop 7 to the desired value.
- Retighten the wing nut.

4.7 Adjusting the drilling clearance



The edge clearance is continuously variable between 7 and 40 mm (9/32 and 1 9/16 in.).

- Unfasten the wing nut 16 (Fig. 4)
- Push the tilting stop 9 (Fig. 3) to the desired scale value.
- Retighten the wing nut.

With the rotating revolver limit stop 17 you can select five firmly preset edge clearances:

6.5 mm, 8 mm, 9.5 mm, 11 mm, 12.5 mm (1/4 in., 5/16 in., 3/8 in., 7/16 in., 1/2 in.)

5 Operation

5.1 Initial operation

Personnel entrusted to work with the machine must be made aware of the operating instructions, calling particular attention to the chapter "Safety instructions".

5.2 Switching on and off

- **Switching on:** Push the switch 23 (Fig. 5) forward until it engages.
- **Switching off:** Push onto the rear end of the switch. The switch jumps into off position.

5.3 Drilling according to tracing

The tilting stop 9 (Fig. 3) has three reference markings. The reference markings on the left and right each correspond to the centre of the drill.

- Clamp the workpiece or prevent it from moving by using the anti-slip mats supplied.
- Position the machine on the workpiece and align the machine by means of the reference markings.
- With your free hand, press the tilting stop against the workpiece.

- Switch on the machine (see chapter 5.2) and push the motor casing forward up to the limit stop.
- Pull back the motor casing and switch off the machine.

5.4 Drilling with stop pin

The base plate 22 (Fig. 5) is equipped with two resilient stop pins. They are used to place the drill holes at a fixed distance to the outer edge of the workpiece. The machine stop can be positioned at the left or right.

- Clamp the workpiece or prevent it from moving by using the anti-slip mats supplied.
- Position the machine on the workpiece. At the same time you push in a stop pin 20 and allow the other stop pin to butt at the outer edge of the workpiece.
- With your free hand, press the tilting stop against the workpiece.
- Switch on the machine (see chapter 5.2) and push the motor casing forward up to the limit stop.
- Pull back the motor casing and switch off the machine.

7 Troubleshooting



Danger

Determining the causes for existing defects and eliminating these always requires increased attention and caution. Pull the mains plug beforehand!

Some of the most frequent defects and their causes are listed in the following chart. In case of other defects, contact your dealer or the MAFELL customer service.

Defect	Cause	Elimination
Machine cannot be switched on	No mains voltage	Check power supply
	Mains fuse defective	Replace fuse
	Carbon brushes worn	Take the machine to a MAFELL customer service shop
Machine stops while drilling is in process	Mains failure	Check mains back-up fuses
Burn marks on the drill holes	Blunt drill bit	Regrind drill bit or replace
Chip ejection blocked	Wood is too damp	
	Extended drilling without extraction	Connect to an external exhaustion, e.g. portable dust extractor

5.5 Drilling with additional stop

see page 77

6 Service and maintenance



Danger

Pull the power plug during all service work.

MAFELL machines are designed to be low in maintenance.

The ball bearings used are greased for life. When the machine has been in operation for a longer period of time, we recommend to hand the machine in at an authorised MAFELL customer service shop for inspection.

Only use our special grease, order No. 049040 (1 kg tin) for all greasing points.

6.1 Storage

If the machine is not used for a longer period of time, it has to be carefully cleaned. Spray bright metal parts with a rust inhibitor.

8 Optional accessories

- Dowel drill bit - HS-TiN Ø 3 mm (1/8 in.)	Order No. 090 083
- Dowel drill bit - HM Ø 5 mm (13/64 in.)	Order No. 090 089
- Dowel drill bit - HM Ø 6 mm (15/64 in.)	Order No. 090 096
- Dowel drill bit - HM Ø 6.1 mm (1/4 in.)	Order No. 090 120
- Dowel drill bit - HM Ø 7 mm (9/32 in.)	Order No. 090 121
- Dowel drill bit - HM Ø 8 mm (5/16 in.)	Order No. 090 097
- Dowel drill bit - HM Ø 8.1 mm (5/16 in.)	Order No. 090 122
- Dowel drill bit - HM Ø 8.2 mm (21/64 in.)	Order No. 090 123
- Dowel drill bit - HM Ø 10 mm (25/64 in.)	Order No. 090 098
- Dowel drill bit - HM Ø 10.1 mm (25/64 in.)	Order No. 090 124
- Dowel drill bit - HM Ø 10.2 mm (13/32 in.)	Order No. 090 125
- Dowel drill bit - HM Ø 12 mm (15/32 in.)	Order No. 090 099
- Dowel drill bit - HM Ø 12.1 mm (15/32 in.)	Order No. 090 126
- Dowel drill bit - HM Ø 12.2 mm (31/64 in.)	Order No. 090 127
- Dowel drill bit - HM Ø 14 mm (35/64 in.) (only for DD40P)	Order No. 090 128
- Dowel drill bit - HM Ø 15 mm (19/32 in.) (only for DD40P)	Order No. 090 129
- Dowel drill bit - HM Ø 16 mm (5/8 in.) (only for DD40P)	Order No. 090 085
- Dowel drill bit - HM Ø 16.2 mm (41/64 in.) (only for DD40P)	Order No. 090 130
- dowel gauge with clamping device	Order No. 203 980
- Dowel drilling template extension 1600 cpl., length 1600 mm (63 in.)	Order No. 203 434
- Adaptor for dowel template extension	Order No. 203 437
- MAFELL special dowels Ø 6x30 mm (1/4 x 1 3/16 in.), 6 x 350 pcs.	Order No. 802 000
- MAFELL special dowels Ø 8x30 mm (5/16 x 1 3/16 in.), 6 x 200 pcs.	Order No. 802 010
- MAFELL special dowels Ø 8x40 mm (5/16 x 1 9/16 in.), 6 x 120 pcs.	Order No. 802 011
- MAFELL special dowels Ø 10x40 mm (3/8 x 1 9/16 in.), 6 x 100 pcs.	Order No. 802 020
- MAFELL special dowels Ø 10x60 mm (3/8 x 2 3/8 in.), 6 x 50 pcs.	Order No. 802 021
- MAFELL special dowels Ø 12x60 mm (1/2 x 2 3/8 in.), 6 x 40 pcs.	Order No. 802 030
- MAFELL special dowels Ø 16x75 mm (63/100 x 2 19/20 in.), 6 x 30 pcs.	Order No. 802 040
- Dowel nozzle ø 8 mm (5/16 in.)	Order No. 095 060
- Bottle of glue	Order No. 095 059
- Anti-slip mat wrapped, 2 pcs.	Order No. 095 063
- Allen key with handle	Order No. 093 282

9 Exploded drawing and spare parts list

The corresponding information in respect of spare parts can be found on our homepage: www.mafell.com