

## Holzmann TBS650PRO

# Holzmann TBS 650PRO Manual Sheet Metal Guillotine Shear

Instruction Manual

## 1. SAFETY INSTRUCTIONS

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Read and understand all safety instructions before operating the Holzmann TBS 650PRO manual sheet metal guillotine shear. Failure to follow these instructions may result in serious injury or damage to the equipment.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and sturdy footwear.
- Ensure the machine is securely mounted on a stable and level workbench before use.
- Keep hands and fingers clear of the cutting blade and hold-down device during operation.
- Do not exceed the maximum cutting capacity of 650 mm width and 1.5 mm thickness.
- Keep the work area clean and well-lit. Remove all tools and debris from the machine before operation.
- Only authorized and trained personnel should operate this equipment.
- Inspect the blade and all moving parts for damage or wear before each use. Do not operate if damaged.

## 2. PRODUCT OVERVIEW

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The Holzmann TBS 650PRO is a manual sheet metal guillotine shear designed for precise cutting of sheet materials up to 650 mm wide and 1.5 mm thick. It features robust construction and user-friendly adjustments for efficient operation.

### Key Features:

- **Manual Back Gauge:** Equipped with a measuring scale for accurate material positioning from 0 to 500 mm.

- **Cutting Area Illumination:** Provides clear visibility of the cutting line for enhanced precision.
- **High-Quality Blade:** Features a cutting blade made from carbon and chrome content steel for durability and clean cuts.
- **Fixed Angular Stop:** Located on the front for consistent angled cuts.
- **Automatic Sheet Hold-Down Device:** Secures the sheet metal firmly in place just before the cut, preventing movement and ensuring accuracy.



*Figure 1: Holzmann TBS 650PRO Manual Sheet Metal Guillotine Shear. This image shows the complete shear with its red frame, grey blade guard, and long operating handle.*

## 3. SETUP

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### 3.1 Unpacking

- Carefully remove the shear from its packaging.
- Inspect the machine for any signs of shipping damage. Report any damage to your supplier immediately.
- Verify that all components listed in the packing list are present.

### 3.2 Assembly and Placement

- Position the shear on a sturdy, level workbench or stand capable of supporting its weight (Net Weight: 105 Kg).
- Securely fasten the shear to the workbench using appropriate bolts and nuts to prevent movement during operation.
- Attach the operating handle to its designated pivot point, ensuring it is firmly secured.
- Ensure there is adequate clear space around the machine for safe operation and material handling.

## 4. OPERATING INSTRUCTIONS

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## 4.1 Preparing the Material

- Ensure the sheet metal to be cut is clean and free of burrs or obstructions.
- Verify that the material thickness does not exceed 1.5 mm and the width does not exceed 650 mm.

## 4.2 Adjusting the Back Gauge

The manual back gauge allows for precise control over the cutting length. To adjust:

1. Loosen the locking mechanism for the back gauge.
2. Slide the back gauge to the desired measurement using the integrated scale (range 0 to 500 mm).
3. Tighten the locking mechanism to secure the back gauge in position.

## 4.3 Cutting Procedure

1. Position the sheet metal against the back gauge and the fixed angular stop (if required) on the front.
2. Ensure the material is flat and fully supported on the cutting bed.
3. Lower the operating handle slowly. The automatic sheet hold-down device will engage, securing the material.
4. Continue to lower the handle with steady pressure to execute the cut.
5. Once the cut is complete, raise the operating handle to its original position. The hold-down device will release.
6. Carefully remove the cut material and any off-cuts.

# 5. MAINTENANCE

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Regular maintenance ensures the longevity and optimal performance of your Holzmann TBS 650PRO shear.

## 5.1 Cleaning

- After each use, clean the cutting bed and blade area to remove metal shavings and dust.
- Use a brush or compressed air for cleaning. Avoid using harsh chemicals that may damage painted surfaces.

## 5.2 Blade Care

- Regularly inspect the carbon-chrome steel cutting blade for sharpness and any signs of damage (nicks, dullness).
- A dull blade can lead to poor cut quality and increased effort. If the blade is dull, it should be professionally sharpened or replaced.
- When replacing the blade, ensure it is a genuine Holzmann replacement part for optimal performance and safety.

## 5.3 Lubrication

- Apply a light machine oil to all pivot points and sliding surfaces periodically to ensure smooth operation.
- Wipe off any excess oil to prevent dust accumulation.

## 5.4 Storage

- Store the shear in a dry, clean environment to prevent rust and corrosion.
- If storing for an extended period, apply a thin layer of protective oil to exposed metal surfaces, especially the blade.

## 6. TROUBLESHOOTING

This section addresses common issues you might encounter during operation.

Problem	Possible Cause	Solution
Uneven or rough cuts	Dull blade, improper material positioning, loose back gauge.	Inspect and sharpen/replace blade. Ensure material is flush against stops. Tighten back gauge.
Difficulty operating handle	Material too thick, lack of lubrication, binding mechanism.	Verify material thickness is within limits. Lubricate pivot points. Check for obstructions.
Material slips during cut	Hold-down device not engaging properly, material not flat.	Ensure hold-down device is functioning. Position material flat on the bed.

## 7. SPECIFICATIONS

Technical specifications for the Holzmann TBS 650PRO Manual Sheet Metal Guillotine Shear.

Specification	Value
Model Number	TBS650PRO
Max. Cutting Width	650 mm
Max. Material Thickness	1.5 mm
Back Gauge Range	0 - 500 mm
Net Weight	105 Kg
Gross Weight	150 Kg
Package Dimensions	940 x 500 x 500 mm
Blade Material	Carbon and Chrome Content Steel
Manufacturer	Holzmann

## 8. WARRANTY AND SUPPORT

### 8.1 Warranty Information

The Holzmänn TBS 650PRO comes with a **2-year warranty**. This warranty covers manufacturing defects but excludes wear parts. Please retain your proof of purchase for warranty claims.

## **8.2 Customer Support**

For technical assistance, spare parts, or warranty inquiries, please contact your authorized Holzmänn dealer or the retailer from whom you purchased the product. Provide your model number (TBS650PRO) and purchase date when contacting support.