



HOLZMANN MASCHINEN GmbH
Marktplatz 4 · A-4170 Haslach
Tel. +43 7289 71 562-0
info@holzmann-maschinen.at

www.holzmann-maschinen.at

Originalfassung
DE BETRIEBSANLEITUNG

Übersetzung / Translation
EN USER MANUAL

KANTENANLEIMMASCHINE

EDGE BANDING MACHINE



KAM535NEO_400V



**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 Maschine vor Reparatur, Wartung oder Pausen ausschalten und Netzstecker ziehen

EN Switch off the machine before repairing, servicing or stopping work and pull out the mains plug



DE Persönliche Schutzausrüstung tragen!

EN Wear personal protective equipment!



DE Warnung vor Quetschverletzungen!

EN Warning of crush injuries!



DE Warnung heiße Oberfläche

EN Warning hot surface



DE Warnung vor automatischem Anlauf

EN Warning automatic start-up



DE Warnung gefährliche elektrische Spannung

EN Warning high voltage

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

EN **Missing or non-readable safety stickers have to be replaced immediately!**

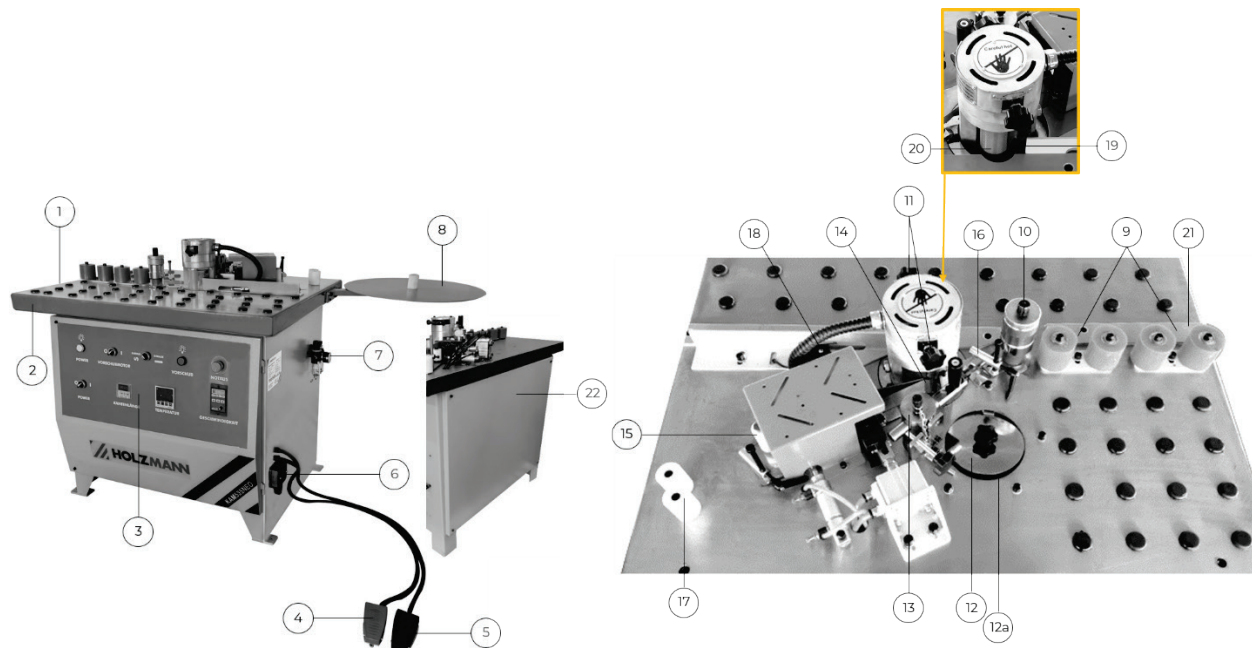
3 TECHNIK / TECHNICS

3.1 Lieferumfang / Delivery Content

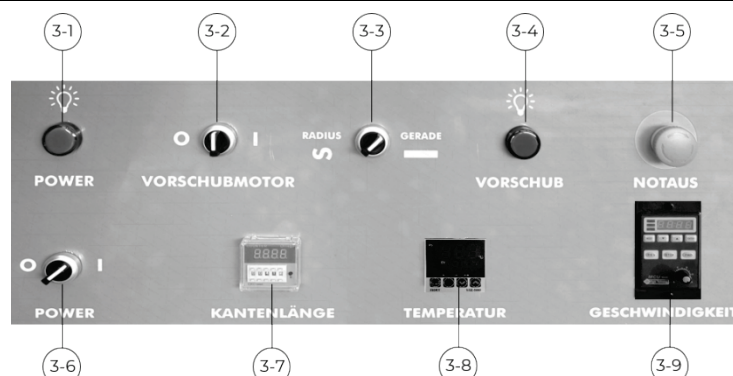
	#	Beschreibung / Description
	1	Maschine mit Fußpedal / machine with foot pedal
	2	Kantenbandauflagetisch / edge banding support table
	3	Werkzeug / tools
	4	Werkzeugbox / tool box
	5	Betriebsanleitung / user manual



3.2 Komponenten / Components



Beschreibung / Description	
1	Werkstückauflage-pads / workpiece support pads
2	Werkstücktisch / worktable
3	Bedienpanel / control panel
4	Fußpedal stopp / foot pedal stop
5	Fußpedal start / foot pedal start
6	Klemmbox (Spannungsversorgung) / clamp box (power supply)
7	Drucklufteinheit / air-pressure unit
8	Kantenbandauflagetisch / edge banding support table
9	2x2 Anpresswalzen / 2x2 contact rolls
10	Höheneinstellung Kantenband / height adjustment band
11	Leimmengen Einstellung Werkstück + Kantenband / glue quantity setting workpiece and edge banding
12	Deckel Klebgranulateinfüllöffnung / cover adhesive granulate filling opening
12a	Klebgranulatbehälter mit Heizung / adhesive granulate container with heating-unit
13	Anpresseinheit Kantenband an Leimrolle / pressing unit edge banding on glue roll
14	Schlagmesser Kantenband / cutting knife edge banding
15	Antriebsrolle Kantenbandvorschub / drive wheel edge banding feed
16	Niederhalter Kantenband / hold down edge banding
17	Führungswalzen Kantenband / guide rollers edge banding
18	Mikroschalter Start/Ende Kantenbandzufuhr / micro switch start/end edge banding feed
19	Anleimrolle für Kantenband / glueing roller für egde banding
20	Anleimrolle für Werkstück / glueing roller für workpiece
21	Werkstückauflage 2-teiliger Streifen / workpiece support 2 parted strip
22	Trennende Schutteinrichtung (Wartungszugang) / Separating protective guard (maintenance access)





Bedienpanel / control panel			
3-1	Kontrolllicht Maschine eingeschaltet / controll-light machine switch on	3-6	Hauptschalter / main-switch
3-2	De-Aktivierungsschalter Vorschubeinheit / de-activation switch feeding unit	3-7	Timer für Ende Kantenanleimzufuhr / timer for ende edge banding feed
3-3	Moduswahlschalter Gerade/Kurven anleimen / mode-switch straight / curve banding	3-8	Temperaturkontrolleinheit Kleber / temperature control unit glue
3-4	Kontrolllicht Vorschubeinrichtung aktiviert/ controll-light feeding unit activated	3-9	Kantenband Vorschubkontrolleinheit / edge banding feed rate control unit
3-5	Not-Halt-Schalter / emergency switch		

Temperaturkontrolleinheit Kleber / tempertur control-unit glue	
	3-8-1 Anzeige Ist-Temperatur Kleber / display current glue temperature
	3-8-2 Anzeige Soll-Temperatur Kleber / display setpoint glue temperature
	3-8-3 Taste für Soll-temperatur verringern / key for reducing setpoint temperature
	3-8-4 Taste für Soll-temperatur erhöhen / key for increasing setpoint temperature
	3-8-5 Programmierstaste / function key

Anleimkanten Vorschubkontrolleinheit / edge banding feed rate control unit	
	3-9-1 Potentiometer für Einstellung der Vorschubgeschwindigkeit / potentiometer for adjusting feed rate
	3-9-2 Taste zur Aktivierung Vorschubmotor (Vorwärtslauf) / key for activation of feeding motor (forward-direction)
	3-9-3 Taste zur Aktivierung Vorschubmotor (Rückwärtslauf) / key for activation of feeding motor (reverse-direction)
	3-9-4 Anzeige aktuell Vorschubdrehzahl / display of actual feed rate

3.3 Technische Daten / technical data

Spezifikation / Specification	
Spannung / voltage	400 V / 50Hz
Motorleistung Antriebsmotor Vorschub / motor power drive motor feed	250 W
Leistung Heizaggregat / power heating unit	1,75 kW
Dimension Auflagetisch Leimkante / dimension support table edge banding	Ø 500 mm
Tischgröße L x B (max. Werkstückauflagebreite) / dimension table L x W (max. work-piece support width)	950 x 750 (300) mm
Arbeitstischhöhe / working table height	830 mm
Vorschubgeschwindigkeit / feeding speed	0 - 15 m/min
Kantenband Breite / edge band width	13 - 54 mm
Kantenband Dicke / edge band thickness	0,3 - 3 mm
Werkstückdicke / thickness of panel	10 - 50 mm
min. Radius Rundleimen / min radius of curved edge banding	20 mm
Luftarbeitsdruck / compressed air working pressure	4 - 5 bar
Max. Klebertemperatur / max. glue-temperatur	170 °C
Nettogewicht / net weight	133 kg
Bruttogewicht / gross weight	161 kg
Verpackungsmaße (L x B x H) / packing dimensions (L x W x H)	1050 x 830 x 1100 mm
Maschinenmaße (L x B x H) / machine dimension (L x W x H)	1460 x 1000 x 990 mm
Schalldruckpegel L _{PA} / sound pressure level L _{PA}	< 70 dB(A)



11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the edge banding machine KAM535NEO_400V, 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

© 2023

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

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

Customer service contact

HOLZMANN MASCHINEN GmbH

4170 Haslach, Marktplatz 4
AUSTRIA

Tel +43 7289 71562 - 0
info@holzmann-maschinen.at



12 SAFETY

This section contains information and important notes on safe start-up and handling of the machine.



For your personal safety, please read these operating instructions carefully before commissioning. This will enable you to handle the machine safely and prevent misunderstandings as well as personal injury and damage to property. Also observe the symbols and pictograms used on the machine as well as the safety and danger information!

12.1 Intended Use of the Machine

The machine is intended 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 glue 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 intended for use under the following ambient conditions:

Rel. Humidity:	max. 65 %
Temperature (operational)	+5° C to +40° C
Temperature (Storage, Transport)	-20° C to +55° C

12.1.2 Prohibited Use / Forseeable Misuse

- Operating the machine without adequate physical and mental aptitude
- Operating the machine without knowledge of the operating instructions
- Changes in the design of the machine
- Operating the machine in a potentially explosive environment (machine can generate ignition sparks during operation)
- Operating the machine outside the limits specified in this manual
- Remove the safety labels attached to the machine.
- Modify, circumvent or disable the safety devices of the machine.

The improper use or disregard of the versions and instructions described in this manual will result in the voiding of all warranty and compensation claims against Holzmann Maschinen GmbH.

12.2 User Requirements

The machine is designed for operation by one person. The physical and mental aptitude as well as knowledge and understanding of the operating instructions are prerequisites for operating the machine. Persons who, because of their physical, sensory or mental abilities or their inexperience or ignorance, are unable to operate the machinery safely must not use it without supervision or instruction from a responsible person.

Please note that local laws and regulations may stipulate the minimum age of the operator and restrict the use of this machine!

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

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

12.3 Safety Devices

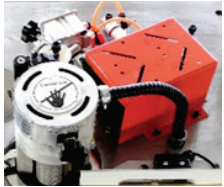
The machine is equipped with the following safety devices:



symbolic image

- One self-locking EMERGENCY STOP button to stop dangerous movements at any time.



	• Separating protective device (fixed)
	• Separating protective device (fixed) (Access to motor)

12.4 General Safety Instructions

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

- Before commissioning, check the machine for completeness and function. Only use the machine if the guards and other non-separating guards required for machining are fitted, are in good operating condition and have been properly maintained.
- Choose a level, vibration-free, non-slip surface for the installation location.
- Ensure sufficient space around the machine!
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects!
- Ensure a clean working environment!
- Only use perfect tools that are free of cracks and other defects (e.g. deformations).
- Remove adjustment tools from the machine before switching it on.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut workpiece parts etc.).
- Check the strength of the machine connections before each use.
- Never leave the running machine unattended. The machine must be stopped if it is unattended.
- The machine may only be operated, maintained or repaired by persons who are familiar with it and who have been informed of the dangers arising in the course of this work.
- Ensure that unauthorised persons maintain a safe distance from the machine and keep children away from the machine.
- Wear suitable protective equipment (eye protection, dust mask, respiratory protection, ear protection, gloves when handling tools) as well as close-fitting work protective clothing - never loose clothing, ties, jewellery, etc. - danger of being drawn in!
- Hide long hair under hair protection.
- Do not remove any sections or other parts of the workpiece from the cutting area while the machine is running!
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine!
- Do not work on the machine if it is tired, not concentrated or under the influence of medication, alcohol or drugs!
- Do not use the machine in areas where vapours from paints, solvents or flammable liquids represent a potential danger (danger of fire or explosion!).
- Do not smoke in the immediate vicinity of the machine (fire hazard)!
- Always shut down the machine before carrying out any conversion, adjustment, measuring, cleaning, maintenance or repair work and always disconnect it from the power supply for maintenance or repair work. 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 restarting.

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.
- Before connecting the machine always make sure that the main switch is switched off.
- Use the machine only when all switches are in good working order.

12.6 Special Safety Instructions for Panel Saws

- Work with gloves on rotating parts is not permitted!
- Never remove sections or other parts of the workpiece from the cutting area while the machine is running.
- Adhesive and gluing unit are strongly heated during operation, avoid any contact with hot components/adhesive and wait for cool-down phases before maintenance work..

12.7 Hazard Warnings

Despite their intended use, certain residual risks remain. Due to the structure and construction of the machine, hazardous situations may occur when handling the machines:

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



Such a safety instruction indicates a potentially hazardous situation which, if not avoided, may result in serious injury or even death.

CAUTION



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

NOTICE



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

Irrespective of all safety regulations, their sound common sense and corresponding technical suitability/training are and remain the most important safety factor in the error-free operation of the machine. Safe working depends first and foremost on you!

13 TRANSPORT

WARNING



Damaged or not sufficiently viable hoists and lifting devices can cause serious injury or even death. Always check hoists and load lifting devices for adequate load-bearing capacity and perfect condition, carefully fasten the loads and never keep them under suspended loads!

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.

Lifting and transporting the machine may only be carried out by qualified personnel with appropriate training for the lifting equipment used.



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 Requirements for the installation site

Choose a suitable place for the machine. Pay attention to the safety requirements and the dimensions of the machine. Make sure that the floor can support the load of the machine. The machine must be levelled simultaneously at all support points. It is also necessary to guarantee a distance of at least 0.8 m around the machine. The selected installation site must ensure a suitable connection to the power supply and to a compressed air supply.

14.1.3 Preparation of the surfaces

Before putting the machine into operation, carefully remove the 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

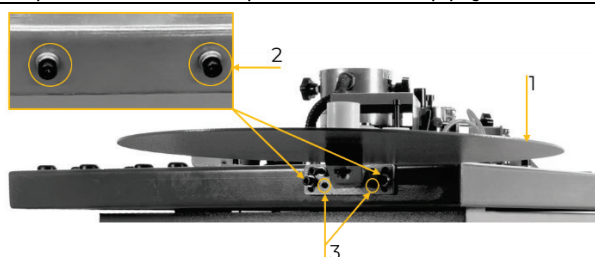


The use of paint thinners, petro, aggressive chemicals or scouring agents will damage the surfaces!

Therefore: Use only mild cleaning agents!

14.2 Assemble

The machine is pre-assembled; only the parts disassembled for transport and the connection to the power and compressed air supply must be made. Follow the following instructions:



Assembly edge band support table:

Attach the edge band support table (1) to the machine with the two cap screws, spring washers and washers (2).

With the two screws (3), the angular position to the table can be adjusted to ensure exact alignment of the supporting table to the machine.

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.

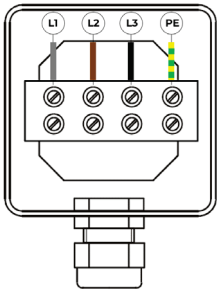
A short-circuit fuse must be provided in the power supply system of the machine!



- 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.

14.3.1 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 power supply is made through an appropriately powered CEE coupling (L1, L2, L3, N and PE).

Plug connection 400V:	Remove cover: 	5--wire: with N-conductor 
------------------------------	---	--

- 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.

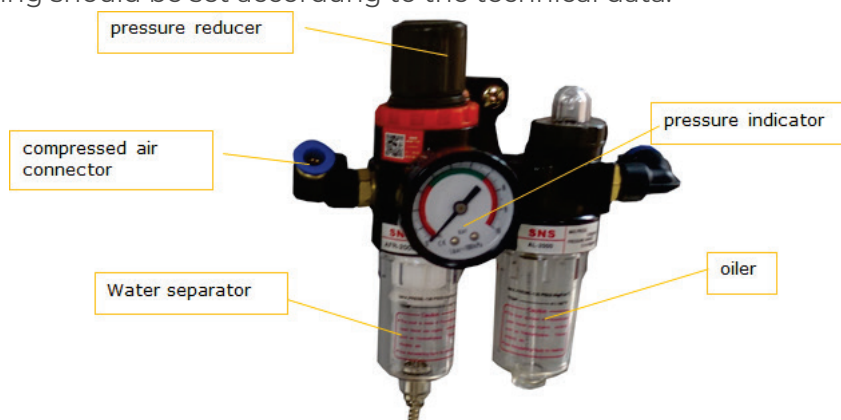
NOTE



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

14.4 Connecting to a compressed air supply

Connect the compressed air unit to the compressed air supply at the compressed air connector. The pressure setting should be set according to the technical data.



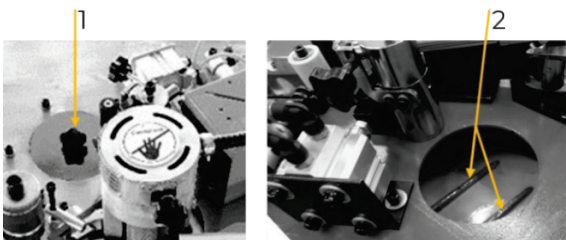
15 OPERATION

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, electrical lines, compressed air lines and operating elements must be checked carefully. Check screw connections for damage and tight fit.

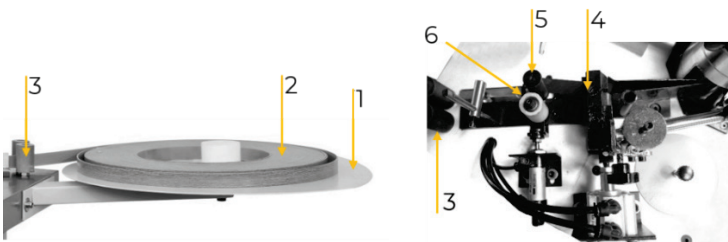


15.1 Initial check before start

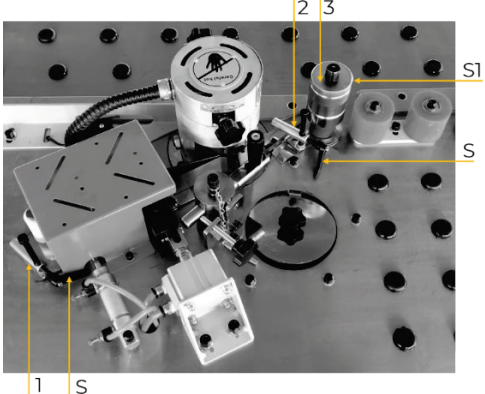
15.1.1 Glue granulate filling

	Open the cover of the granulate container (1) and fill in the granulate. Then close the granulate container again. (Note: heating elements (2) should be covered)
---	--

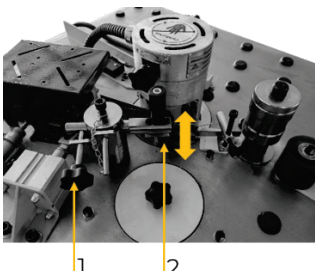
15.1.2 Inserting edgeband in edgeband feed

	Place the edgeband (2) on the edgeband support (1) and pass it through the rollers (3), as well as the pressure roller feed (5) and feed roller (6) up to the crosscut blade (4).
---	--

15.1.3 Adjusting the height of the edge band

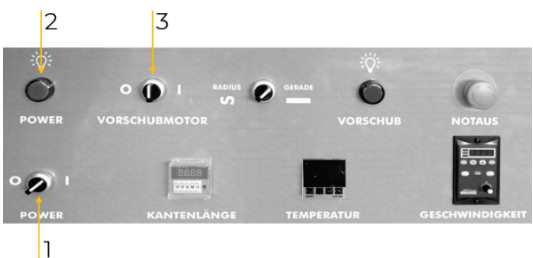
	The height adjustment must be made in 3 positions. For position 1 and 2: Loosen clamping lever (S) and move the bolt to the desired height and then retighten clamping lever (S). For position 3: Adjust the height by means of knurled screw S1. NOTE: Optimum height adjustment = edge band + slight height play (1-2mm) must not jam under any circumstances.
--	---

15.1.4 Applying contact pressure to edge band

	The position of the pressure roller (2) in relation to the edge band and thus the contact pressure for the edge band can be changed by turning the adjustment knob (1) and thus adapted to the edge band thickness used.
---	---

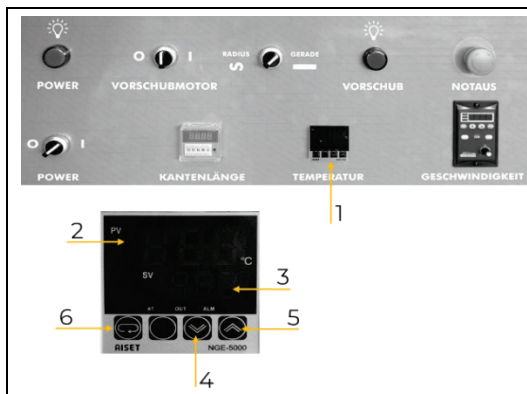
15.2 Operation

15.2.1 Switch on machine

	Turn the main switch (1) to position ON (I). The control lamp (2) lights up. Switch on feeding unit: Turn de-activation switch to position ON (I)
---	---



15.2.2 Setting the glue temperature



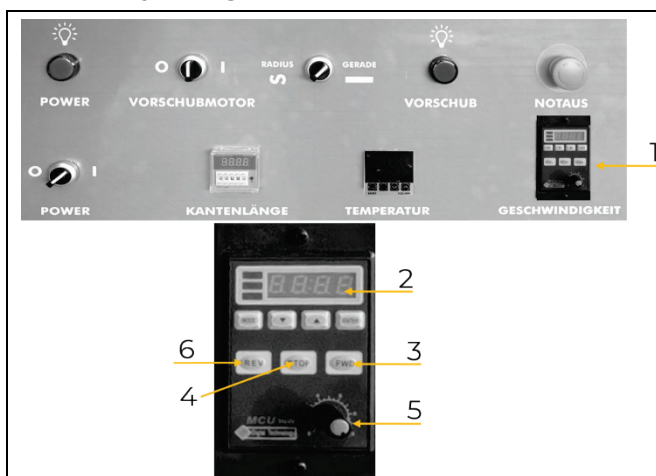
The glue temperature can be preset (3) by means of the control unit (1) and the current glue temperature is indicated on the display on position (2).

Setting the preset temperature:

- Push key 6
- Reduce preset temperature pushing key 4
- Increase preset temperature pushing key 5
- Enter by pushing key 6

NOTE: If the target glue temperature has not yet been reached, the feed unit is not released.

15.2.3 Adjusting the feed rate



The feed control unit (1) is used to set/display the feed speed (motor speed drive roller) and activate the motor start.

Display of the current selected speed in the display (2).

Use the potentiometer (5) to set the speed (clockwise for higher speed, counter-clockwise for slower speed).

The feed motor is activated with key 3 (in forward direction).

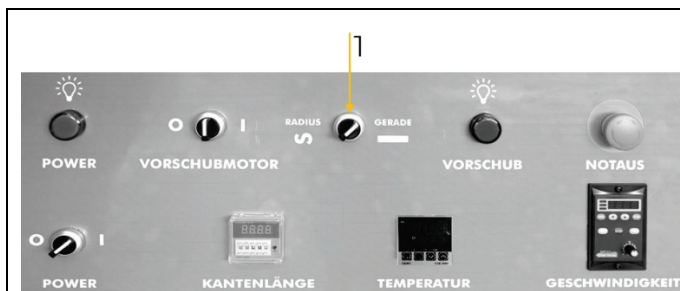
The feed motor is stopped with key 4.

The feed motor is activated with key 6 (in reverse direction is normally not required).

Glue delivery in wrong direction!.

NOTE: That control unit only activated when feed motor is activated.

15.2.4 Setting the mode selector switch to the desired operating mode



The mode selector switch (1) selects the mode of operation:

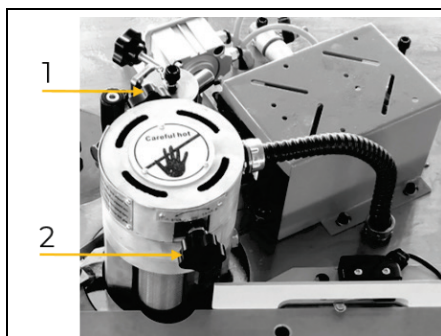
Mode I: Switch in "Straight" position

Mode II: Switch in position "S Radius"

In operating mode I the edge feed and the edge band cut-off are activated/deactivated with the micro switch on the worktable.

In operating mode II this is done by means of the foot pedal and edge length adjustment.

15.2.5 Adjusting the glue quantity



With the setting wheels 1 and 2 the amount of glue can be changed while turning.

Setting wheel 1 adjusts the amount of glue for the edgeband.

Setting wheel 2 adjusts the amount of glue for the workpiece.



15.2.6 Edge banding (Straight edge mode)

Checklist before start:

- Edge band inserted and height adjusted
- Glue granules filled.
- Machine is switched on (main switch on "I").
- Glue target temperature reached.
- Feed motor activated (control lamp feed lights up)
- Speed Feed motor selected and motor activated.
- Mode selector switch to "Straight".

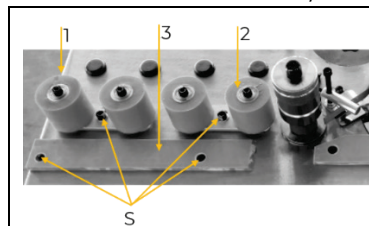
Glueing process:

- Place the workpiece to the right of the limit switch at the stop.
- Push the workpiece to the left and when the limit switch is actuated, the edge feed is started automatically and the edgeband is fed at the selected speed.
- Push the workpiece evenly, with a short overhang of the edge band at the beginning of the workpiece, together with the edge band to the left.
- Press the workpiece evenly against the rubber rollers.
- As soon as the workpiece is no longer in contact with the limit switch (end of workpiece reached) the edgeband is cut with the cutting knife and the feed is stopped (pressure roller and thus edgeband is removed from the drive wheel - no power transmission to the edgeband).
- After this process, another edge of the workpiece can be glued or machine stopped.

15.2.7 Edge banding (Radius „S“ mode)

Checklist before start:

- Edge band inserted and height adjusted
- Glue granules filled.
- Machine is switched on (main switch on "I").
- Glue target temperature reached.
- Feed motor activated (control lamp feed lights up)
- Speed Feed motor selected and motor activated.
- Mode selector switch to Radius"S".
- Pressure rollers/workpiece support disassembled



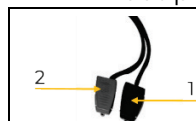
If necessary, depending on the type of workpiece to be machined, the pressure rollers (1 and/or 2) and part of the workpiece support (3) must be removed. To do this, remove the screws (S) and then the components from the machine.

- Adjusting the timer for edge band length



The timer can be set using the buttons, after activating the feed the timer counts down (indicated on the display). At 0 the edge is cut off and feed is stopped.

- Foot pedal



In radius „S“ mode push foot pedal start (1 = red colour) to start the process. By pushing foot pedal stop (2 = black colour) the process will be stopped

Glueing process:

- Place the workpiece against the stop.
- Press the foot pedal (1) to start the edge feed automatically and feed the edge band at the selected speed.



- Push the workpiece evenly, with a short overhang of the edge band at the beginning of the workpiece, together with the edge band to the left in the given workpiece shape.
- After the countdown on the timer has elapsed, the edge band is cut with the cutting knife and the feed is stopped (the pressure roller and thus the edge band is removed from the feed roller → no force is transmitted to the edge band) or the process is stopped by pressing the second foot pedal (2).
- After this process, another edge of the workpiece can be glued or the machine stopped.

15.2.8 Stop / switch off the machine

	Normal Stop: Turn feed motor switch (1) to position "0". Heating is still active, activation of feed is not possible. Switch off the machine: Main switch (2) in position "0" Only in emergency situation Stopping the machine using the EMERGENCY STOP button (3) CAUTION: The emergency stop button can only be unlocked after the emergency situation has been eliminated.
--	---

16 CLEANING, MAINTENANCE, STORGE, DISPOSAL

16.1 Cleaning

NOTE



Wrong cleaning agents can attack the varnish of the machine. Do not use solvents, nitro thinners, or other cleaning agents that could damage the machine's paint. Observe the information and instructions of the cleaning agent manufacturer!

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.

16.2 Maintenance

WARNING



Handling the machine with the power supply and compressed air supply up can lead to serious injuries or even death. Always disconnect the machine from the power supply before servicing or maintenance work and secure it against unintentional or unauthorised reconnection!

The machine is low-maintenance and only a few parts have to be serviced. Nevertheless, any faults or defects which may affect the safety of the user must be rectified immediately!

- Before each start-up, make sure that the safety devices are in perfect condition and function properly.
- Check all connections for tightness at least once a week.
- Regularly check that the warning and safety labels on the machine are in perfect and legible condition.
- Only use original spare parts recommended by the manufacturer.

16.2.1 Inspection and 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 specified limits:

interval	components	activity
Before usage	machine	Cleaning the machine
Before usage	machine	Removal of all loose parts / tools
1 x month	Moving parts	Greasing / lubrication of guides / gear racks / wheels
1x month	Emertgency switch	Checking the emergency stop function by means of a function test



16.3 Storage

NOTE



Improper storage can damage and destroy important machine parts. Store packed or unpacked parts only under the intended ambient conditions!

When not in use, store the machine in a dry, frost-proof and lockable place to prevent the formation of rust on the one hand and to ensure that unauthorised persons and in particular children have no access to the machine on the other hand!

16.4 Disposal



Observe the national waste disposal regulations. Never dispose of the machine, machine components or equipment in residual waste. If necessary, contact your local authorities for information on the disposal options available. If you buy a new machine or an equivalent device from your specialist retailer, he is obliged in certain countries to dispose of your old machine properly.

17 TROUBLESHOOTING

WARNING



Handling the machine with the power supply and compressed air supply up can lead to serious injuries or even death. Always disconnect the machine from the power supply before servicing or maintenance work and secure it against unintentional or unauthorised reconnection!

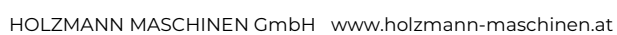
Many possible sources of error can be excluded in advance if the machine is properly connected to the mains.

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

Trouble	Possible cause	Solution
Machine does not start	• EMERGENCY STOP button activated • Switch or a phase is broken • Overheating protection activated	• Turn the EMERGENCY STOP button to the right to unlock • Repair the defective switch or phase • Let the heater cool down
Glue is applied to rollers	• too much glue added	• Decrease glue supply
Edge band is not glued optimally	• too little glue is added	• Increase glue supply

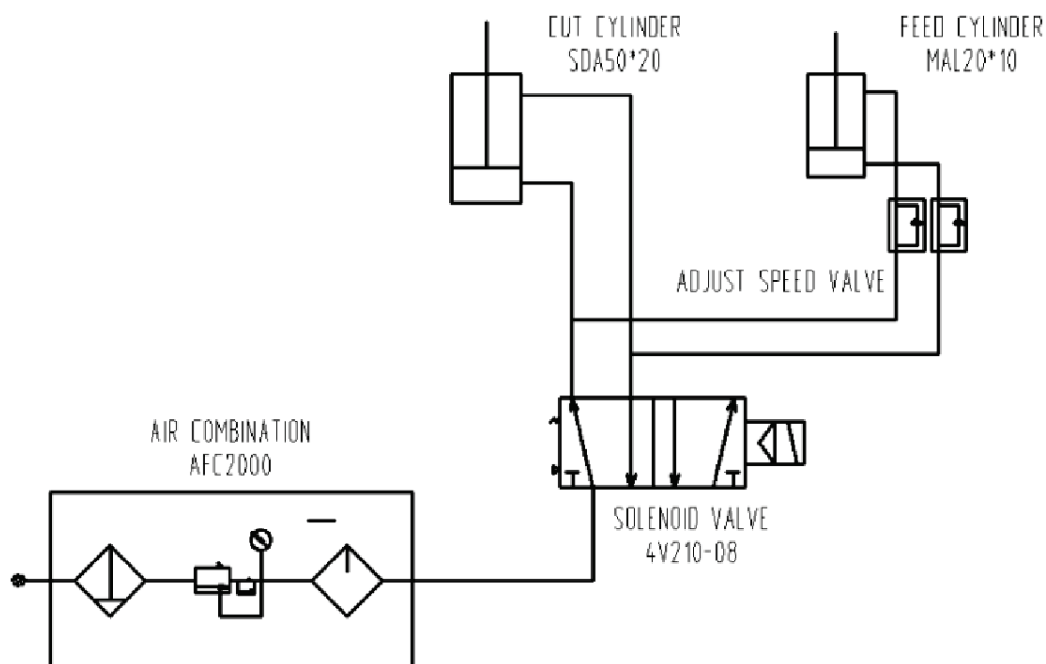


The diagram illustrates a three-phase power supply system. On the left, the main supply lines are labeled PE (Protective Earth), L1, L2, L3, and N (Neutral). These lines pass through a three-phase circuit breaker with three visible poles. The lines are then distributed to two different loads. The first load, labeled 'heater', is connected to three phases (U, V, W) and a neutral line (N). The second load, labeled 'M2', is a three-phase motor connected to the same three phases (U, V, W) through a contactor (KM2) and a speed controller. A ground symbol is shown at the bottom right, indicating the connection to the earth.





19 PNEUMATISCHER SCHALTPLAN / PNEUMATIC DIAGRAM



20 ERSATZTEILE / SPARE PARTS

20.1 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.

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.

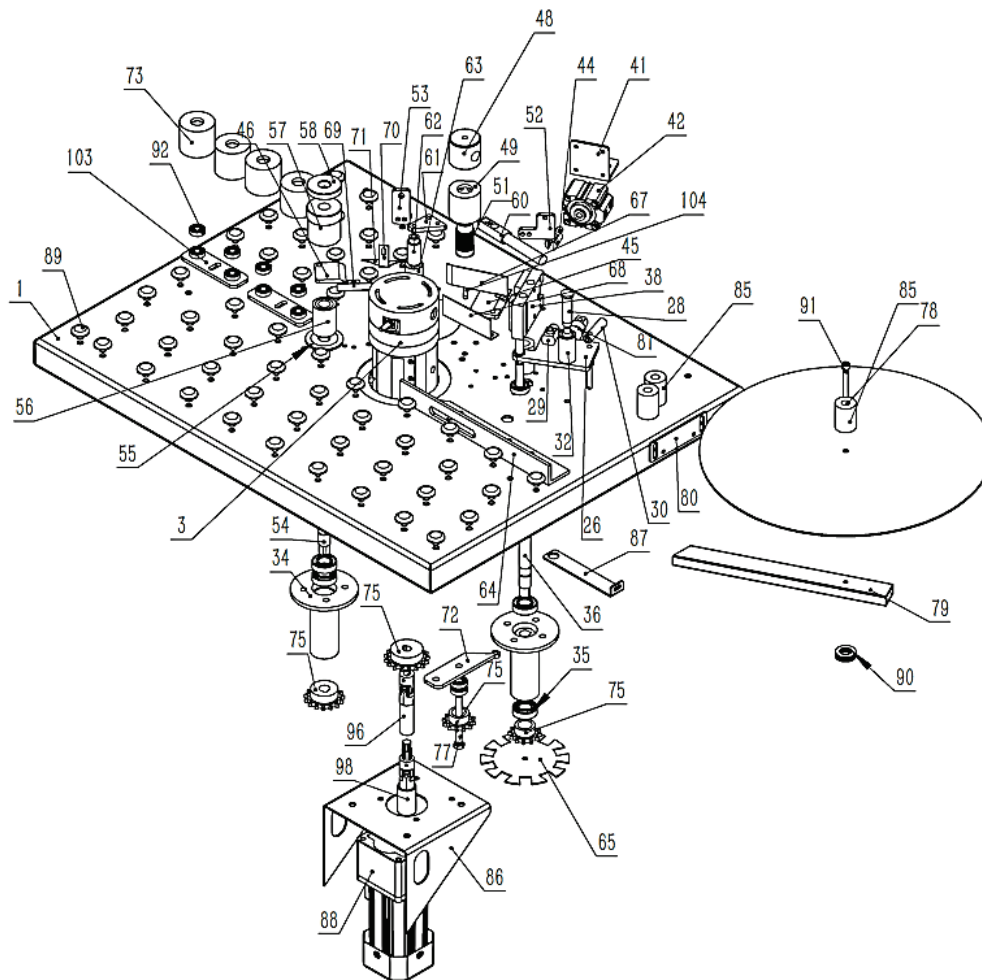
Order the spare parts directly on our homepage-category SPARE PARTS or contact our customer service

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

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.



20.2 Explosionszeichnungen / Exploded View

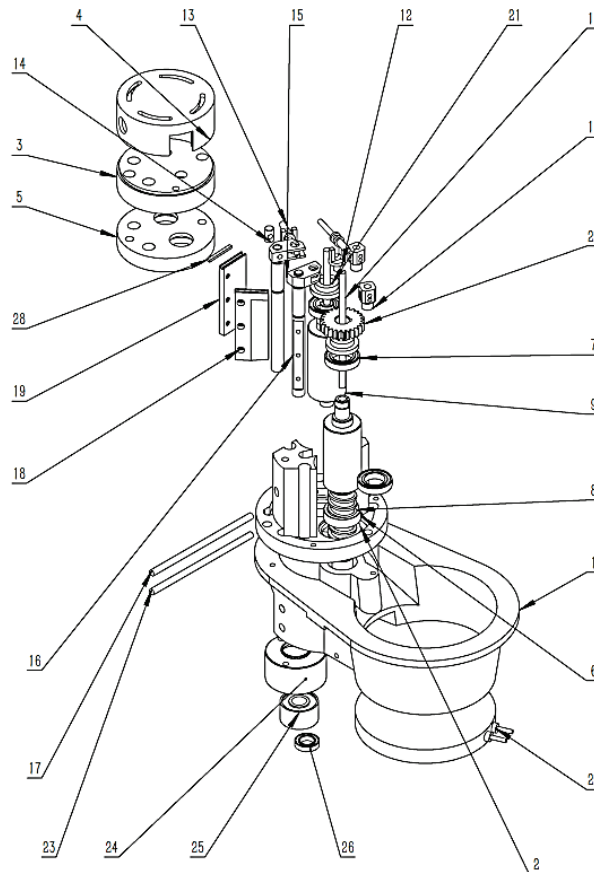


No.	Description	Qty.	No.	Description	Qty.
1	Working table	1	63	Manual - Big Eye External Axis	1
3	Manual glue pot	1	64	Manual-aluminum fence	1
26	Small cylinder union	1	65	Manual-Counter Plate	1
28	Small cylinder union fixed shaft	1	66	Manual-glue pot cover	1
29	Cylinder joint	1	67	Manual stainless steel parts-1	1
30	Press Belt Shaft	1	68	Manual stainless steel parts-2	1
31	Manual glue pot	1	69	Manual stainless steel parts-3	1
32	Stop belt nylon wheel	1	70	Manual - small blade holder	1
33	Cylinder connection inner shaft	2	71	Manual - Small Blade	1
34	Bearing cartridge	2	72	Manual - Tensioner pl	1
35	Bearings 6004RS	4	73	Manual silicone wheel (large)	4
36	Manual - short axis	1	75	Gears (12 gears / 15 gears / 17 gears / 12 gears with bearings)	4
37	Manual belt feeding pulley (knurled straight flower)	1	76	Bearing 6001RS	2
38	Manual cutter	1	77	Tension wheel set screw hexagonal M12x100	1
41	Manual - Large cylinder seat	1	78	Disc	1
44	Manual - cutter connection shaft	1	79	Manual - disc support pipe	1
45	Manual-Feed with pad	1	80	Manual- disc fixing plates	1
46	Manual - out with pad	1	81	MBL20X10CA	1
47	Manual-combination body spring	1	85	Center wheel of platen	3
48	Manual-assembly 1	1	86	Motor base 3mm	1
49	Manual-assembly 2	1	87	Proximity switch holder	1
50	Manual-assembly 3	1	88	Speed control motor	1
51	Manual-assembly 4	1	89	Black round beans	53
52	Gun-shaped iron plate	1	90	Thrust bearings	2
53	Long iron plate	1	91	Disc center hexagon socket set screws M8x80 1	1
54	Manual - long axis	1	92	Bearing-6900Z	8



55	Manual - large spacer	1	93	GB/T 276-2013[Deep groove ball bearings with dust caps on both sides[60000-2Z][6201-2Z]	1
56	Manual - Silicone Wheel (Medium)	1	98	Motor shaft sleeve	1
57	Manual - large nuts	1	99	Heating Rod 250W 10*160	1
58	Manual - Large Nut Cap	1	100	Heating Rod 100W 10*160	1
59	Manual - Rubber pot ring	1	101	Rubber Door Seal	2
60	Manual - Dumb handle	1	102	Hexagon socket M8*50J	1
61	Manual - Trapezoidal connection plate	1	103	515B-Ballast Wheel Base Plate	2
62	Manual - Big Eye Inner Axis	1	104	Manual plugs	1

Glueing unit



No.	Description	Qty.	No.	Description	Qty.
1	Heated Rubber Seat	1	15	Rubber door adjusting block	2
2	Gluing Seat	1	16	Rubber door axle	2
3	Retainer cover	1	17	Heating Rod 250W-10X160	1
4	Superstructure	1	18	Glue gate right	1
5	Rubber Medium Board	1	19	Glue gate left	1
6	Manual Rubber Pot Copper Sleeve	1	20	Manual flat gear 25×2	1
7	Bearing-6905	3	21	Rubber pot cover PTFE sleeve	2
8	Propeller shaft	1	22	Heating plate 220V 1200W	1
9	Gluing shafts	1	23	Heating Rod 100W-10X160	1
10	Fastening sleeve	2	24	Manual rubber pot bottom seat PTFE sleeve	1
11	Heating Rod 120W- 8X170	2	25	Manual Rubber Pot Holder	1
12	Hand-operated Pocket Handle	2	26	Bearing-6903	1
13	Adjustment screw	2	27	Glued shaft bottom sleeve	1
14	Manual Rubber Door Adjustment Column	2	28	Rubber Door Seal	1

21 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.