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Originalfassung

DE BETRIEBSANLEITUNG

Übersetzung / Translation

EN USER MANUAL

ES INSTRUCCIONES DE SERVICIO

PT MANUAL DE INSTRUÇÕES

FORMATKREISSÄGE

PANEL SAW

ESCUADRADORA

SERRA DE DIMENSIONAMENTO



TS315VF2000_230V
TS315VF2000_400V



**YOUR
JOB.
OUR
TOOLS.**



2 SICHERHEITSZEICHEN / SAFETY SIGNS / SEÑALES DE SEGURIDAD

DE SICHERHEITSZEICHEN
BEDEUTUNG DER SYMBOLE

EN SAFETY SIGNS
DEFINITION OF SYMBOLS

ES SEÑALES DE SEGURIDAD
SIGNIFICADO DE LOS SÍMBOLOS

PT SINAIS DE SEGURANÇA
SIGNIFICADO DOS SÍMBOLOS



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

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

ES **CONFORMIDAD CE:** Este producto cumple con las directivas de la UE.

PT **CONFORMIDADE CE:** Este produto corresponde às diretivas UE.

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.

DE

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.

EN



ES

¡LEER LAS INSTRUCCIONES DE SERVICIO! Lea atentamente las instrucciones de servicio y de mantenimiento de su máquina y familiarícese con los elementos de mando de la misma para manejarla correctamente y, de este modo, evitar que se produzcan daños personales y en la máquina.

LER O MANUAL DE INSTRUÇÕES! Leia atentamente as instruções de funcionamento e manutenção da sua máquina e familiarize-se com os elementos de funcionamento da máquina, a fim de operar a máquina corretamente e evitar assim danos ao homem e à máquina.

PT



DE

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

EN

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

ES

¡ADVERTENCIA! ¡Observe los símbolos de seguridad! El incumplimiento de las normas e indicaciones para utilizar la máquina puede dar lugar a daños personales de carácter grave y a peligros mortales.

PT

ATENÇÃO! Respeitar os símbolos de segurança! A não observância das instruções e notas sobre a utilização da máquina pode resultar em graves danos pessoais e perigo fatal.



DE Schutzausrüstung tragen!

EN Wear protective equipment!

ES ¡Use el equipo de protección!

PT Use equipamento de proteção!

DE

Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

EN

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

ES

¡Pare la máquina y desconéctela de la red eléctrica antes de llevar a cabo trabajos de mantenimiento y antes de las pausas!

PT

Desligue a máquina e retire a ficha da tomada antes de iniciar os trabalhos de reparação, manutenção e de paragens!

DE

Warnung vor Schnittverletzungen!

EN

Warning of crush injuries!

ES

¡Advertencia de sufrir lesiones producidas por cortes!

PT

Atenção aos ferimentos por corte!

DE

Benutzen von Handschuhen verboten!

EN

Do not use gloves!

ES

¡Prohibido utilizar guantes!

PT

É proibida a utilização de luvas!



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.

ES

¡Deben sustituirse inmediatamente los letreros de advertencia y/o las etiquetas que haya en la máquina, que se hayan vuelto ilegibles o se hayan retirado!

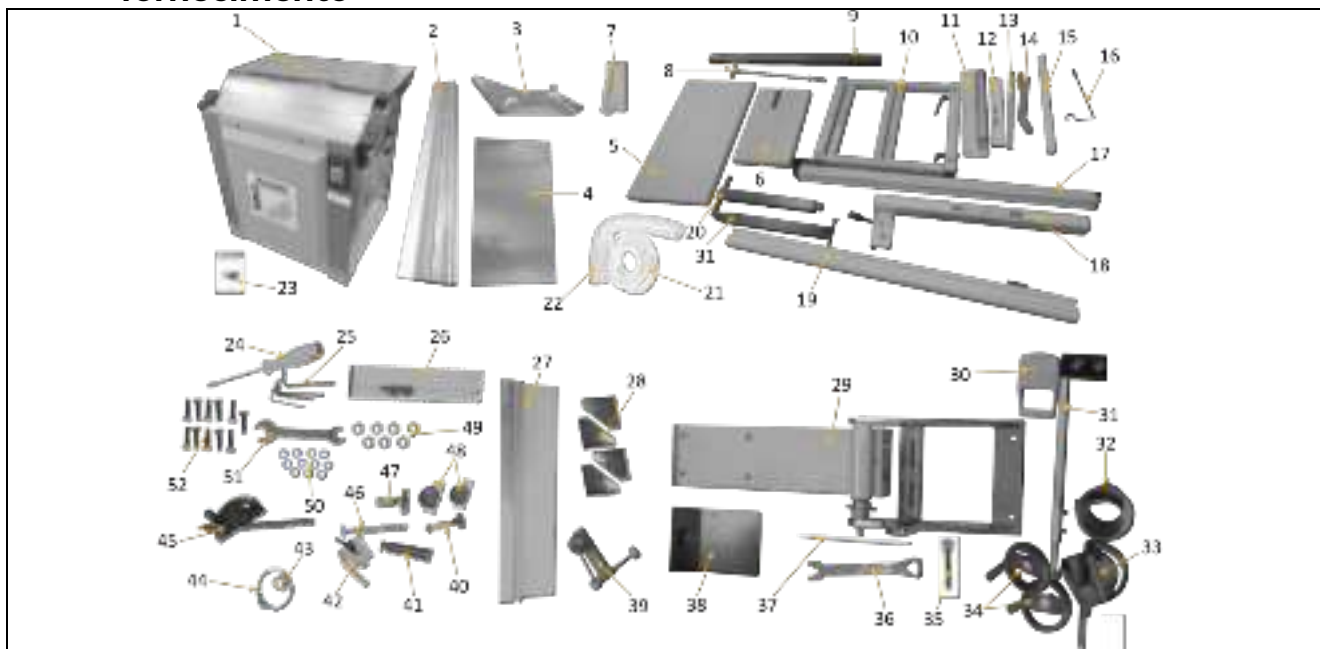
PT

Os sinais de aviso e/ou autocolantes na máquina que sejam ilegíveis ou tenham sido removidos devem ser substituídos imediatamente!



3 TECHNIK / TECHNICS / TÉCNICA / TECNOLOGIA

3.1 Lieferumfang / Delivery content / Volumen de suministro / Volume de fornecimento



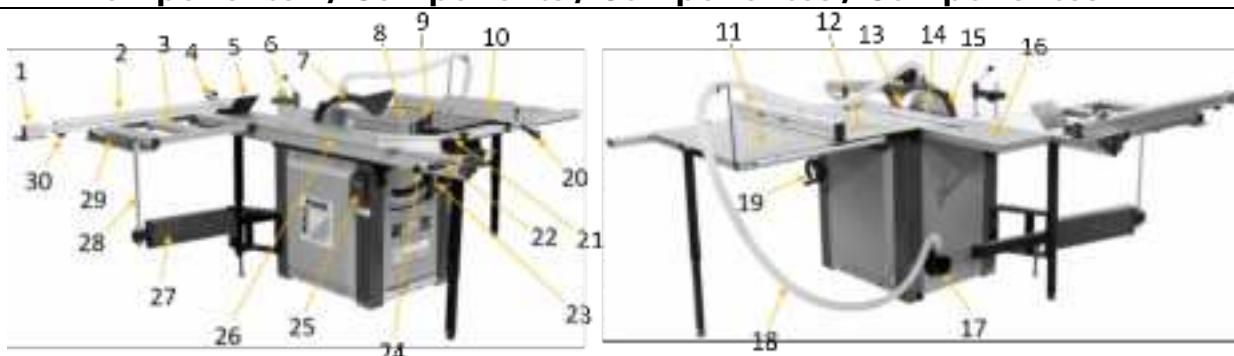
Beschreibung / Description			
1	Maschine mit Sägeblatt und Vorritzsägeblatt / Machine with blade and scoring blade / Máquina con hoja de sierra y hoja de sierra del incisor / Máquina com lâmina de serra e lâmina de serra marcador	27	L-Anschlag / L-fence / Tope en L / Batente em L
2	Formatschiebetisch / Sliding table / Carro desplazable de formatos / Mesa deslizante de dimensionamento	28	Maschinenfüße / Machine feet / Patas de la máquina / Pés da máquina
3	Sägeblattschutz (Ø 30mm) / Saw blade guard (Ø 30 mm) / Protección de la hoja de la sierra (Ø 30 mm) / Proteção da lâmina de serra (Ø 30mm)	29	Schwenkarm mit Halterung / Swivel arm with bracket / Brazo pivotante con soporte / Braço giratório com suporte
4	Tischverbreiterung (Grauguss) / Table widening (grey cast) / Ampliación de la mesa (fundición gris) / Extensão da mesa (ferro fundido cinzento)	30	Stoppplappe / Stop flap / Tapa de cierre / Tampa de paragem
5	Tischverbreiterung / Table widening / Ampliación de la mesa / Extensão da mesa	31	Unterstützungsfüße Formatschiebetisch / Support feet sliding table / Patas de apoyo del carro desplazable de formatos / Pés de apoio para mesa deslizante de dimensionamento
6	Tischverlängerung / Table extension / Ampliación de la mesa / Extensão da mesa	32	Absaugstutzen Ø 100 - 30mm / Suction socket Ø 100 - 30mm / Ø Boquillas de aspiración 100 - 30 mm / Bocal de aspiração Ø 100 - 30mm
7	Schiebehholz / Sliding wood / Madera de empuje / Madeira deslizante	33	Gehrungsanschlag Formatschiebetisch / Mitre fence sliding table / Tope de ingletes del carro desplazable de formatos / Esquadro da mesa deslizante de dimensionamento
8	Schwenkarmstütze mit Montageteile / Swivel arm support with assembly parts / Soporte de brazo pivotante con piezas de montaje / Suporte de braço giratório com peças de montagem	34	Handräder / Hand wheels / Volantes / Volantes
9	Schwenkarm Innenteil / Swivel arm inner part / Pieza interior del brazo pivotante / Parte interna do braço giratório	35	Stützfuß Schwenkarm / Support foot swivel arm / Pata de apoyo del brazo pivotante / Pé de apoio Braço giratório



10	Auslegertisch / Outrigger table / Carro de bandera / Mesa de apoio	36	Sägeblattschlüssel / Blade wrench / Llave para hoja de sierra / Chave da lâmina de serra
11	Auslegertischrolle / Outrigger table roll / Rodillo del carro de bandera / Rolo da mesa de apoio	37	Fixierstift für Sägeblattwechsel / Fixing pin for saw blade exchange / Pasador de fijación para sustituir la hoja de la sierra / Cavilha de fixação para substituição da lâmina de serra
12	Anschlag Gehrungsanschlag Formatschiebetisch / Stop for mitre fence sliding table / Tope del tope de ingletes del carro desplazable de formatos / Batente Esquadro da mesa deslizante de dimensionamento	38	Besäumschuh / Edging shoe / Zapata de canteado / Sapata de corte
13	Montagestütze Tischverlängerung / Mounting support table extension / Soporte de montaje de la ampliación de la mesa / Suporte de montagem da extensão da mesa	39	Werkstückniederhalter / Workpiece downholder / Pisador de la pieza de trabajo / Fixador da peça de trabalho
14	Schiebestock / Push stick / Bastón de corredera / Varra de empurrar	40	Verriegelung Formatschiebetisch / Locking sliding table / Dispositivo de bloqueo del carro desplazable de formatos / Bloqueio da mesa deslizante de dimensionamento
15	Verbindungsprofil Tischverbreiterung / Connecting profile table extension / Perfil de conexión de la ampliación de la mesa / Perfil de ligação da extensão da mesa	41	Handgriff Formatschiebetisch / Handle sliding table / Empuñadura carro desplazable de formatos / Pega da mesa deslizante de dimensionamento
16	Absaugschlauchhalterung / Suction hose holder / Soporte para manguera de aspiración / Suporte da mangueira de aspiração	42	Kippanschlag / Flip stop / Tope abatible / Esquadro basculante
17	Ablänganschlag / Cross-cut fence / Tope de acorte / Esquadro de corte transversal	43	Schlauchschellen für Absaugschlauch ø 30mm / Hose clamps for suction hose ø 30mm / Abrazaderas para manguera de aspiración ø 30mm / Braçadeiras para mangueira de aspiração ø 30mm
18	Parallelanschlag / Rip fence / Tope paralelo / Esquadro de corte	44	Schlauchschellen für Absaugschlauch ø 100mm / Hose clamps for suction hose ø 100mm / Abrazaderas para manguera de aspiración ø 100mm / Braçadeiras para mangueira de aspiração ø 100mm
19	Führungsschiene Parallelanschlag / Guide rail rip fence / Carril guía tope paralelo / Carril de guía Esquadro de corte	45	Gehrungsanschlag Arbeitstisch / Mitre fence work table / Tope de ingletes de la mesa de trabajo / Esquadro da mesa de trabalho
20	Unterstützungsfuß Tischverbreiterung / Support foot table widening / Pata de apoyo de la ampliación de la mesa / Pé de apoio Extensão da mesa	46	Halterung Werkstückniederhalter / Bracket workpiece downholder / Soporte pisador de la pieza de trabajo / Suporte do fixador da peça de trabalho
21	Absaugschlauch ø 30mm / Suction hose ø 30mm / Manguera de aspiración ø 30 mm / Mangueira de aspiração ø 30mm	47	Feineinstellung Parallelanschlag / Fine adjustment rip fence / Ajuste fino del tope paralelo / Regulação fina Esquadro de corte
22	Absaugschlauch ø 100mm / Suction hose ø 100mm / Manguera de aspiración ø 100 mm / Mangueira de aspiração ø 100mm	48	Schiebetischklemmschrauben / Sliding table clamping screws / Tornillos de sujeción del carro desplazable / Parafusos de fixação da mesa deslizante
23	Betriebsanleitung / User manual / Instrucciones de servicio / Manual de instruções	49	Muttern (7x) / Nuts (7x) / Tuercas (7x) / Porcas (7x)
24	Schraubendreher / Screwdriver / Destornillador / Chave de fendas	50	Distanzscheiben (11x) / Washers (11x) / Arandelas distanciadoras (11x) / Discos espaçadores (11x)
25	Inbusschlüsselset / Allen wrench set / Juego de llaves Allen / Jogo de chaves de Allen	51	Gabelschlüssel / Wrench / Llave fija / Chave de boca
26	Anschlag Gehrungsanschlag Arbeitstisch / Stop for mitre fence work table / Tope del tope de ingletes de la mesa de trabajo / Batente do esquadro Mesa de trabalho	52	Schrauben (11x) / Screws (11x) / Tornillos (11x) / Parafusos (11x)



3.2 Komponenten / Components / Componentes / Componentes



Beschreibung / Description			
1	Ablänganschlag (ausziehbar) / Length cross-cut fence (extendable) / Tope de acorte (extraíble) / Esquadro de corte transversal (extensível)	16	Tischverlängerung / Table extension / Ampliación de la mesa / Extensão da mesa
2	Ablänganschlag / Length cross-cut fence / Tope de acorte / Esquadro de corte transversal	17	Absaugstutzen / Suction socket / Boquillas de aspiración / Bocal de aspiração
3	Auslegertisch / Outrigger table / Carro de bandera / Mesa de apoio	18	Absaugschlauch / Suction hose / Manguera de aspiración / Mangueira de aspiração
4	Kippanschlag / Flip stop / Tope abatible / Esquadro basculante	19	Handrad Winkelverstellung Sägeblatt / Handwheel saw blade tilting / Volante de ajuste angular de la hoja de la sierra / Volante Ajuste do ângulo da lâmina de serra
5	Besäumschuh / Edging shoe / Zapata de canteado / Sapata de corte	20	Klemmhebel Parallelanschlag / Clamping lever rip fence bracket / Palanca de sujeción del tope paralelo / Alavanca de aperto Esquadro de corte
6	Werkstückniederhalter / Work piece downholder / Pisador de la pieza de trabajo / Fixador da peça de trabalho	21	Gehrungsanschlag Formatschiebetisch / Mitre fence sliding table / Tope de ingletes del carro desplazable de formatos / Esquadro da mesa deslizante de dimensionamento
7	Sägeblattschutz / Saw blade guard / Protección de la hoja de la sierra / Proteção da lâmina de serra	22	Handgriff Formatschiebetisch / Handle sliding table / Empuñadura carro desplazable de formatos / Pega da mesa deslizante de dimensionamento
8	Arbeitstisch / Work table / Mesa de trabajo / Mesa de trabalho	23	Handrad Höhenverstellung Sägeblatt / Hand wheel height adjustment saw blade / Volante de ajuste de altura de hoja de la sierra / Volante Ajuste em altura da lâmina de serra
9	Gehrungsanschlag Arbeitstisch / Mitre fence work table / Tope de ingletes de la mesa de trabajo / Esquadro da mesa de trabalho	24	Verriegelung Formatschiebetisch / Locking sliding table / Dispositivo de bloqueo del carro desplazable de formatos / Bloqueio da mesa deslizante de dimensionamento
10	Parallelanschlag / Rip fence / Tope paralelo / Esquadro de corte	25	Ein-Aus Schalter / ON-OFF switch / Interruptor de encendido / Interruptor On-Off
11	Tischverbreiterung / Table widening / Ampliación de la mesa / Extensão da mesa	26	Formatschiebetisch / Sliding table / Carro desplazable de formatos / Mesa deslizante de dimensionamento
12	Tischverbreiterung (Grauguss) / Table widening (grey cast) / Ampliación de la mesa (fundición gris) / Extensão da mesa (ferro fundido cinzento)	27	Schwenkarm / Swivel arm / Brazo pivotante / Braço giratório
13	Vorritzsägeblatt Ø90 x 3 x Ø20mm – 12Z / Scoring blade Ø90 x 3 x Ø20mm – 12T / Hoja de sierra del incisor Ø90 x 3 x Ø20mm – 12Z / Lâmina de serra para ranhuras Ø90 x 3 x Ø20mm – 12T	28	Schwenkarmstütze / Swivel arm support / Soporte de brazo pivotante / Apoio do braço giratório



14	Sägeblatt Ø315 x 3 x Ø30mm – 40Z / Saw blade Ø315 x 3 x Ø30mm – 40T / Hoja de la sierra Ø315 x 3 x Ø30mm – 40Z / Lâmina de serra Ø315 x 3 x Ø30mm – 40Z	29	Auslegertischrolle / Outrigger table roll / Rodillo del carro de bandera / Rolo da mesa de apoio
15	Spaltkeil / Riving knife / Cuña de separación / Faca de corte	30	Fixierknopf Ablänganschlag / Fixing knob length cross-cut fence / Tirador de fijación del tope de acorte / Botão de fixação do esquadro de corte transversal

3.3 Technische Daten / Technical data / Datos técnicos / Dados técnicos

Spezifikation / Specification	TS315VF2000_230V	TS315VF2000_400V
Spannung / voltage / Tensión / Tensão	230 V / 1 / 50Hz	400 V / 3 / 50 Hz
Motorleistung S1 (100%) / Motor power S1 (100%) / Potencia del motor S1 (100 %) / Potência do motor S1 (100%)	3000 W	
Arbeitstischgröße / worktable size / Tamaño de la mesa de trabajo / Tamanho da mesa de trabalho	800 x 820 mm	
Formatschiebetisch / sliding table / Carro desplazable de formatos / Mesa deslizante de dimensionamento	2000 x 270 mm	
Tischverbreiterung / table widening / Ampliación de la mesa / Extensão da mesa	800 x 440 mm	
Tischverlängerung / table extension / Ampliación de la mesa / Extensão da mesa	500 x 310 mm	
Arbeitstisch Höhe / work table height / Mesa de trabajo altura / Altura da mesa de trabalho	870 mm	
Auslegertisch / outrigger table / Carro de bandera / Mesa de apoio	540 x 760 mm	
Ablänganschlag / cross-cut fence / Tope de acorte / Esquadro de corte transversal	1230-2260 mm	
Max. Besäumlänge / Max. cutting length / Longitud máx. de canteado / Comprimento máx. de corte	1900 mm	
Sägeblattdimension / saw blade dimension / Dimensiones de la hoja de la sierra / Dimensão da lâmina de serra	Ø 315 x 30 x 3.0/ 2,3 mm	
Drehzahl Sägeblatt / saw blade speed / Velocidad de la hoja de la sierra / Velocidade da lâmina de serra	4000 min ⁻¹	
Sägeblatt Neigung / saw blade tilt / Inclinação hoja de la sierra / Inclinação da lâmina de serra	0 – 45°	
Schnitthöhe bei 90 ° / cutting height at 90 ° / Altura de corte a 90° / Altura de corte a 90°	100 mm	
Schnitthöhe bei 45 ° / cutting height at 45 ° / Altura de corte a 45° / Altura de corte a 45°	80 mm	
Vorritzersägeblattdimension / scoring saw blade dimension / Dimensión de la hoja de sierra del incisor / Dimensão da lâmina de serra marcada	Ø 90 x 20 x 3.0/ 2.3 mm	
Drehzahl Vorritzersägeblatt. / scoring saw blade speed / Velocidad de la hoja de sierra de incisor / Velocidade da lâmina da serra de ranhurar	5800 min ⁻¹	
Max. Schnittbreite am Parallelanschlag / max. cutting width at rip fence / Ancho máx. de corte en el tope paralelo / Largura de corte máxima no esquadro de corte	1250 mm	
Absauganschluss Durchmesser / dust collector port / Diámetro de la conexión de aspiración / Diâmetro da ligação de aspiração	1x Ø 100 mm / 1x Ø 30 mm	
notwendiger Luftvolumenstrom Absauganlage / necessary air volume / Volumen de aire necesario para el sistema de aspiración / Fluxo de ar necessário Sistema de extração	2480 m ³ /h	
notwendiger Unterdruck Absauganlage / vacuum dust collector / presión negativa necesaria del sistema de aspiración / Vácuo necessário Sistema de extração	1800 Pa	



Maschinenmaße (L×B×H) / machine dimensions (L×W×H) / Dimensiones de la máquina (LxAxH) / Dimensões da máquina (CxLxA)	2820 x 2000 x 1160 mm
Verpackungsmaße (L×B×H) / packaging dimensions (L×W×H) / Dimensiones del embalaje (L×A×H) / Dimensões da embalagem (CxLxA)	Colli I: 910 x 740 x 1050 mm Colli II: 2070 x 300 x 235 mm
Gewicht Brutto / weight gross / Peso bruto / Peso bruto	295,5 kg (I: 225 kg II: 70,5 kg)
Gewicht Netto / weight net / Peso neto / Peso líquido	263 kg
Schallleistungspegel L_{WA} / sound power level L_{WA} / Nivel de potencia sonora L_{WA} / Nível de potência sonora L_{WA}	98,7 dB(A).....k: 4 dB(A)
Schalldruckpegel L_{PA} / sound pressure level L_{PA} / Nivel de presión sonora L_{PA} / Nível de pressão sonora L_{PA}	82,1 dB(A).....k: 4 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.

(ES) Aviso sobre los valores de ruido: Los valores indicados son valores de emisión y, por lo tanto, no representan necesariamente al mismo tiempo valores seguros en el lugar de trabajo. Aunque hay una correlación entre los niveles de emisión y los de inmisión, no se puede deducir con certeza si es necesario adoptar medidas de precaución adicionales o no. Entre los factores que influyen en el nivel de inmisión real en el lugar de trabajo, se encuentran la naturaleza del espacio de trabajo y otras fuentes de ruido, es decir, el número de máquinas y otros procesos de trabajo adyacentes. Asimismo, los valores admisibles en el lugar de trabajo pueden variar de un país a otro. No obstante, esta información debe capacitar al usuario a evaluar mejor los peligros y los riesgos.

(PT) Nota Dados relativos ao ruído: Os valores indicados são valores de emissão e não representam necessariamente valores de segurança no local de trabalho ao mesmo tempo. Embora exista uma correlação entre os níveis de emissão e de imissão, não se pode deduzir com fiabilidade se são ou não necessárias medidas de precaução adicionais. Os fatores que afetam o nível real de emissões no local de trabalho incluem a natureza do espaço de trabalho e outras fontes de ruído, ou seja, o número de máquinas e outros processos de trabalho vizinhos. Os valores permitidos no local de trabalho também podem variar de país para país. Esta informação deve permitir ao utilizador fazer uma melhor avaliação do perigo e do risco.



11 PREFACE (EN)

Dear Customer!

This operating manual contains information and important notes for safe commissioning and handling of the panel saw TS315VF2000_230V and TS315VF2000_400V, hereinafter referred to as "machine".



The manual is an integral part of the machine and must not be removed. Keep it for later use in a suitable place, easily accessible to users (operators), protected from dust and moisture, and enclose it with the machine if it is passed on to third parties!

Please read and obey the security instructions!

Due to the constant further development of our products, illustrations and contents may differ slightly. If you notice any errors, please inform us.

Technical changes reserved!

Check the goods immediately after receipt and make a note of any complaints on the consignment note when the delivery person takes them over!

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

Holzmann Maschinen GmbH cannot accept any liability for transport damage not noted.

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Court of jurisdiction is the Landesgericht Linz or the competent court for 4170 Haslach, Austria!

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12 SAFETY

This section contains information and important notes on safe commissioning 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:

Lengthwise and crosswise cutting of wood and materials with similar physical properties to wood using an effective suction device according to technical specifications and within the technical limits.

NOTE



HOLZMANN MASCHINEN GmbH assumes no responsibility or warranty for other activities and any resulting property damage or injuries!

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

- Operation of 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)-
- Operation of the machine in closed rooms without chip and dust extraction (a normal household vacuum cleaner is not suitable as an extraction device).
- Operating the machine outside the limits specified in this manual.
- Remove the safety markings attached to the product.
- Modify, circumvent or disable the safety devices of the machine.
- Cutting of materials with dimensions outside the limits specified in this manual.
- Use of tools which do not meet the safety requirements of the standard for machine tools for woodworking (EN847-1).

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 the supervision or instruction by a responsible person.

Basic knowledge of woodworking especially the correlation of wood type, blade, cutting feed and speeds.

Please note that local laws and regulations may determine 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:



	Safety guard (adjustable): saw blade guard is attached to the riving knife to prevent contact with the saw blade.
 Riving knife	This measure is intended to prevent the workpiece from kick back. The setting is in horizontal and vertical direction opposite to the saw blade.
 Edging shoe	Safety device for longitudinal cuts. Press the workpiece against the edging shoe (1). This prevents the workpiece from jumping up.
	Interlocking movable guard: Safety cover of the saw blade (secured with screws and equipped with a safety switch) This safety switch interrupts the power supply immediately when the cover is removed.
Push stick / sliding wood	For cutting operations where less than 120mm is cut, i.e. less than 120mm distance to the right of the saw blade to the rip fence. Do not feed the wood by hand, but with the push stick.

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 must be observed:

- Before start-up, check the machine for completeness and function. Only use the machine if the guards and other non-parting guards required for machining have been 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 tool keys and other adjustment tools before switching on the machine.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut parts, etc.).
- Check the strength of the machine connections before each use.
- Never leave the running machine unattended. Switch off the machine before leaving the working area and secure it against unintentional or unauthorised recommissioning.
- The machine may only be operated, serviced 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 close-fitting protective clothing and suitable protective equipment (eye protection, dust mask, ear protection; gloves only when handling tools).
- 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!
- Do not remove splinters and chips by hand!
- 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 you are 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)!
- Shut down the machine and disconnect it from the power supply before carrying out any adjustment, conversion, cleaning, maintenance or repair work. Before starting any 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.
- Use the machine only when the ON-OFF switch is in good working order.

12.6 Special safety instructions for woodworking machines

- Working with gloves on rotating parts is not permitted.
- Wood dust is generated when operating the machine. Therefore, connect the machine to a suitable dust and chip collection system when installing it.
- Always switch on the dust collection system before you start machining the workpiece.
- Never remove sections or other parts of the workpiece from the cutting area while the motor is running.
- When using milling tools with a diameter ≥ 16 mm and circular saw blades, they must comply with EN 847-1:2013 and EN 847-2:2013; tool carriers must comply with EN 847-3:2013.
- Wear hearing protection certified to health and safety regulations to limit noise exposure.
- Replace cracked and deformed saw blades immediately; they cannot be repaired.
- Use a push stick for cutting operations where less than 120 mm is cut.
- Select the number of teeth of the saw blade so that at least 2-3 teeth cut through the workpiece at the same time. A lower number of teeth leads on the one hand to an unclean cut and on the other hand increases the risk of vibrations and noise pollution due to increased kickback.
- Never try to cut freehand. If the workpiece is not guided exactly parallel to the saw blade, kickback is to be expected.
- Always use the rip fence or crosscut fence to support the workpiece.

12.7 Hazard warnings

12.7.1 Residual risks

Despite intended use, certain residual risk factors remain.

- Risk of injury to fingers and hands from rotating saw blade if the workpiece is not guided properly.
- Risk of injury from the workpiece being flung away if not properly held or guided, such as working without a fence. Risk of kickback!
- Danger to health from wood dust or wood chips. It is essential to wear personal protective equipment such as eye protection and a dust mask and to use a dust collection system.
- Risk of injury from breakage or ejection of the saw blade or parts of it, especially in the event of overloading or incorrect direction of rotation.
- Risk of injury to the eye from flying parts, even with protective goggles.
- Hearing damage if hearing protection is not used.
- Injuries caused by a defective saw blade.
- Risk of electric shock, if improper electrical connections are used.

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



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.

NOTE



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, your common sense and appropriate technical suitability/training are and remain the most important safety factor for the fault-free operation of the machine. **Safe working depends first and foremost on you!**

13 TRANSPORT

WARNING



Damaged or insufficiently strong hoists and load slings can cause serious injuries or even death. Always check hoists and load slings for sufficient load-bearing capacity and that they are free of obstacles, fasten the loads carefully and never stand under suspended loads.

To ensure proper transport, also observe the instructions and information on the transport packaging regarding centre of gravity, attachment points, weight, means of transport to be used and the prescribed transport position, etc..



Transport the machine in its packaging to the installation site. To manoeuvre the machine in the packaging, a pallet truck or a forklift with appropriate lifting power can be used.

If you transport the machine with a vehicle, make sure that the load is adequately secured!



NOTE: To transport the machine, you need a forklift truck with the appropriate load capacity and a fork of at least 1200 mm length. The fork of the truck should be positioned under the machine.

The machine can be transported for short distances with the transport device or transported by crane or forklift truck using belts of appropriate load capacity and length.

NOTE: Do not carry the machine at the work tables, these are not designed to withstand the tensile load of the machine weight.

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

The chosen installation site must have a suitable connection to the power supply and a connection to a dust collection system. Observe the safety requirements and the dimensions of the machine.

Place the machine on a level, solid surface that can support the weight of the machine. The chosen installation site of the machine must comply with the local safety regulations as well as the ergonomic requirements for a workplace with sufficient lighting conditions.

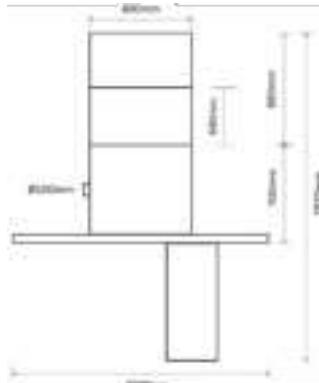
NOTE



The floor at the installation site must be able to bear the load of the machine!

When dimensioning the required space, take into account that the operation, maintenance and repair of the machine must be possible without restrictions at all times. Also take into account the working areas of neighbouring machines.

The base of the machine has fixing holes by means of which the machine is firmly connected to the floor. This improves the stability of the machine.





Preparation of the surface

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

NOTE

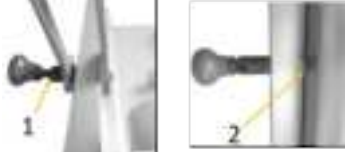
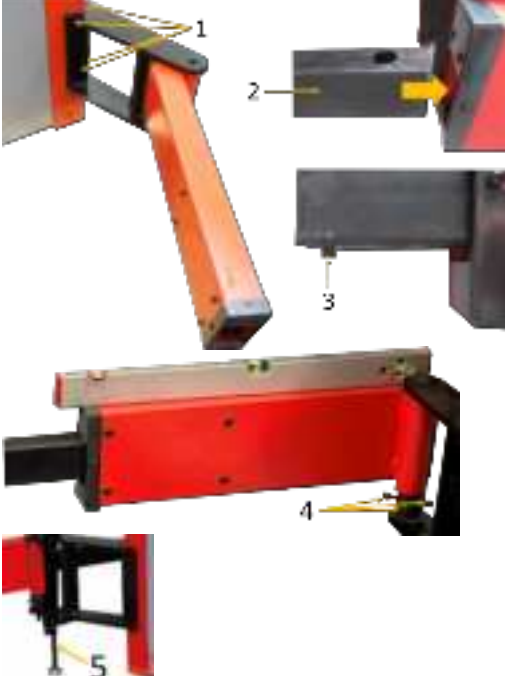


- The machine and machine parts are heavy!
- At least 2 people are required to set up the machine.

The machine has been disassembled for transport and must be reassembled before use.

	1. Assembly machine feet Place the 4 machine feet on each of the 4 corners of the machine
	2. Assembly hand wheels - Place the hand wheel for height adjustment (1) on the shaft and tighten the Allen screw. - Mount the hand wheel for saw blade tilting (2) in the same way as described above.
	3. Assembly stop flap Mount the stop flap (1) with nuts, washers and screws (2) on the switch housing
	4. Assembly suction socket - Fix the suction socket (1) with screws, washers and nuts in the opening of the machine base frame (1). - Fix one end of the Ø 100mm suction hose with the hose clamp to the saw blade unit and the other end to the suction socket (2)
	5. Assembly the sliding table - Slide the two sliding table clamping screws into the slots (1) at both ends of the sliding table. - Fix the sliding table on the sliding table brackets with the sliding table clamping screws (2). NOTE: Ensure that the insert plate lies between the bracket and the sliding table on the adjustment screws.



	6. Align sliding table with work table • Level the edge of the sliding table with that of the work table (straight piece of wood / spirit level) by turning the adjust screw (4) until it is horizontally aligned without gaps (5). • Thereby slightly loosen the clamping screws and only tighten them again after the correct setting has been made. • Further adjustments for parallelism can be made with the screws of the bracket (6). Loosen the screws and move the bracket in the area of the slotted holes. • Secure the position by adjusting the security plate (7) with the set screw (8).
	7. Assembly the locking sliding table • Place the locking onto the sliding table and fix it (1). • The locking (2) can be unlocked by pulling out and turning.
	8. Assembly the handle sliding table • Slide the handle into the slot (1). • Place the handle to the desired position (2) and fix it by turning (2).
	9. Assembly edging shoe • Slide the edging shoe into the slot in the back end of the sliding table (1) and fix it with the clamping screw (2).
	10. Assembly swivel arm • Use 4 screws and spacers to fix the bracket with the swivel arm (1) to the provided threads. • Insert the inner part end with the hole (2) into the swivel arm. • Make sure that the stopper screw (3) at the rear end points downwards. • Level swivel arm (using a spirit level) by turning the adjust screw (4) until it is horizontally aligned. • Turn in the support foot (5)



	11. Assembly outrigger table NOTE: Before mounting check the smooth running of the swivel arm. • By turning the 4 screws (1) you can close or move away the eccentric guide rollers. • Insert the swivel arm support with the assembly parts (sequence as in Fig. 1) into the swivel arm. • Slide the outrigger table into the slot of the sliding table (2) • Fix the swivel arm support on the outrigger table with the 2 screws (3). • Slightly tighten the nut (4).
	12. Assembly outrigger table roll • Fix the outrigger table roll on the outrigger table with the 3 screws (1). • The exact height of the roller is adjusted via the slotted hole (2) of the bracket.
	13. Align outrigger table with work table • Level the edge of the outrigger table with that of the work table (straight piece of wood / spirit level) by turning the adjust screws (5) until it is horizontally aligned without gaps (4). • Thereby slightly loosen the clamping screws (6) and only tighten them again after the correct setting has been made.
	14. Assembly length cross-cut fence • Place the length cross-cut fence (1) on the outrigger table so that the pivot pin (2) and the fastening thread (3) fit into the provided openings. • Fix the pivot pin with the clamping screw (4). • Fix the length cross-cut fence with the clamping screw (5). • Slide the flip stop (6) into the slot of the length cross-cut fence and fix it with the clamping lever (7) on the desired position.
	15. Assembly table widening (grey cast) • Fix the table widening (grey cast) with the 4 screws (3) on the work table.



	16. Align table widening (grey cast) with work table - Level the edge of the table widening with that of the work table (straight piece of wood / spirit level) by turning the adjust screws (3) until it is horizontally aligned without gaps (2). - Thereby slightly loosen the clamping screws (4) and only tighten them again after the correct setting has been made.
	17. Assembly guide rail rip fence Fix the rip guide rail (1) with 3 screws, washers and nuts (2) on the work table and table widening (grey cast). NOTE: The remaining 2 screws are needed for mounting the table widening.
	18. Assembly table widening - Fix the table widening with the 4 screws, washers and nuts (1) on the work table and with 2 screws, washers and nuts on the guide rail rip fence. - Fix the connecting profile table widening (3) with 3 screws, washers and nuts (4).
	19. Assembly table extension - Fix the table extension (1) with the 2 screws, washers and nuts (2) on the work table - Fix the mounting support (3) with the 2 screws, washers and nuts (4) on the table extension and on the machine base frame NOTE: Tighten the screws slightly!
	20. Align table extension with work table - Level the edge of the table widening with that of the work table (straight piece of wood / spirit level) until it is horizontally aligned without gaps (5). - Tighten the screws after the correct setting has been made.
	21. Assembly rip fence - Insert the rip fence (1) into the guide rail with the clamping lever (2) open. - Clamping lever up: open - Clamping lever down: clamped NOTE: If the rip fence is not well levelled, adjust the guide rail up or downwards.
	22. Assembly L-fence - After unscrewing the T-nuts, insert the fastening screws (1) through the provided holes in the rip fence. - Screw T-nuts back and slide on the L-fence (2). - Then fix the L-stop in the desired position with the fastening screws.



	23. Assembly saw blade guard - Fix the saw blade guard (1) to the riving knife (3) with the locking screw (2). - Use the slot (4) according to main saw blade diameter NOTE: The saw blade guard should be positioned as close as possible to the workpiece.
	24. Assembly suction hose - Fix the suction hose holder (1) on the table widening. - Fix the suction hose Ø30mm on the saw blade guard (2) and on the suction socket (3) with the hose clamp. NOTE: Ensure that the suction hose is not kinked and that there is sufficient distance between the suction hose and the work area.
	25. Assembly support feet a. Sliding table - Slide a support foot (1) into the slot at each end of the sliding table and fix it with the screws (2). NOTE: To ensure that the swivel arm is not blocked by the support foot a distance (a) of 620mm must be maintained. b. Table widening - Fix the support foot (1) to the table widening with 2 screws, washers and nuts (2). After assembly, adjust the required height with the set screws (3).
	26. Assembly of various components a. Work piece downholder - Insert the slot stone of the work piece downholder (1) into the T-slot on the sliding table. - Fix it by turning the holder bar (2) in desired position b. Mitre fence sliding table - Insert the mitre fence (1) into the T-slot on the sliding table. - Fix it by turning the knop (2) in desired position - Fix the stop (4) with the fixing screws (3) in desired position - Fix the angle position with clamping lever (5) c. Mitre fence work table - Insert the mitre fence (1) into the T-slot on the work table. - Fix the stop (4) with the fixing screws (3) in desired position - Fix the angle position with clamping screws (2)



14.3 Electrical connection

WARNING

**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 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.

14.3.1 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 400 V:	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.

14.4 Connecting to a dust collection system

The machine must be connected to a dust collection system for dust and chips. The dust collection system must start up at the same time as the machine's engine. The air speed at the suction connection and in the exhaust air lines must be at least 20 m/s for materials with a moisture $< 12\%$ (at least 28 m/s for moist chips with a moisture $> 12\%$). The hoses used must be flame-retardant (DIN4102 B1) and permanently antistatic (or earthed on both sides) and comply with the relevant safety regulations. For information on air volume flow, negative pressure and suction connection, please refer to the technical specifications.

14.5 Settings

WARNING

**Danger due to electrical voltage!**

Handling the machine while it is connected to the voltage source can lead to serious injuries or death.

→ Always disconnect the machine from the voltage source before carrying out adjustment or maintenance work and secure it against reconnection.

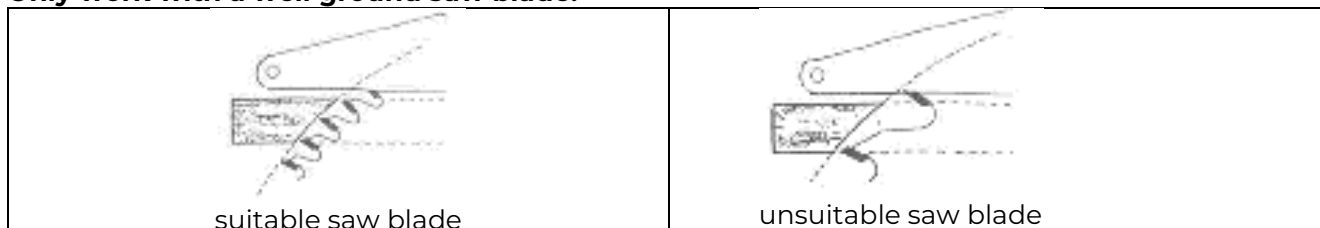


14.5.1 Saw blade

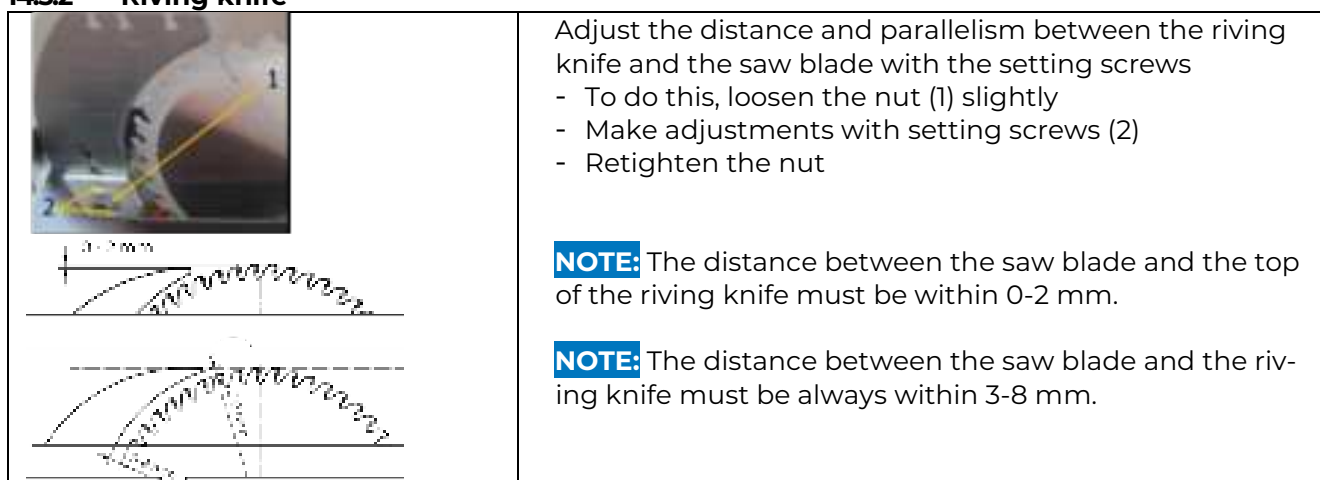
The material of the workpiece and the saw blade teeth are important criteria for a precise cutting result. Both the number of teeth and their shape, arrangement and position are associated with a specific function.

To improve the quality of the cut, always make sure that several teeth (at least 2-3) cut through the workpiece at the same time. If only one tooth is working, the result is a poor machining surface and the risk of kickback, vibrations and sound pollution increase.

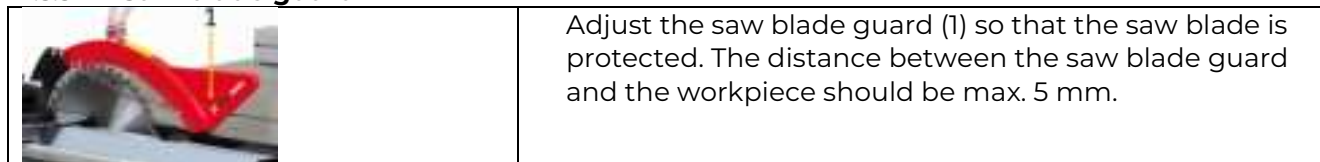
Only work with a well ground saw blade!



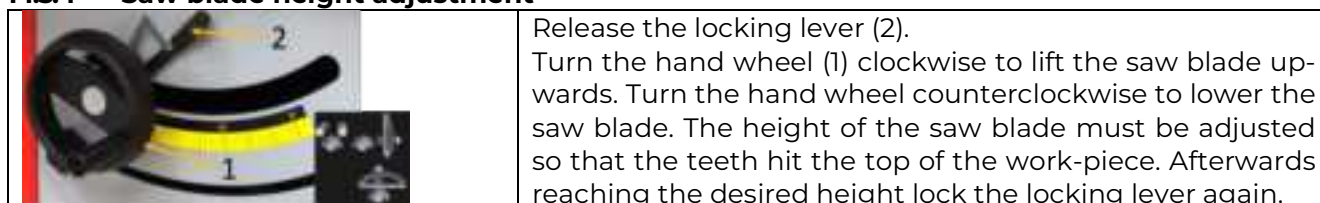
14.5.2 Riving knife



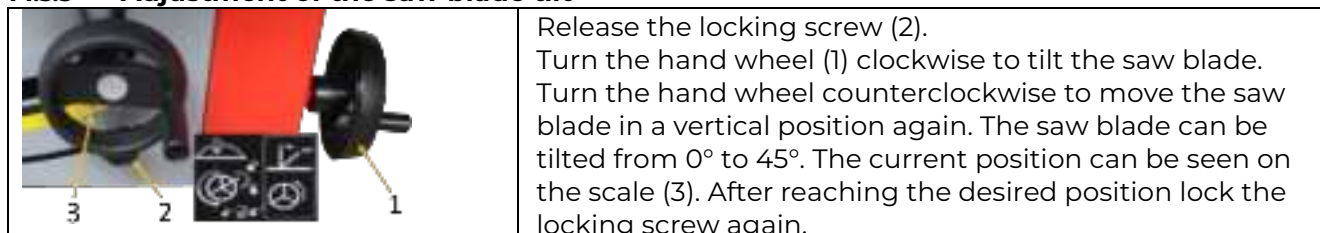
14.5.3 Saw blade guard



14.5.4 Saw blade height adjustment



14.5.5 Adjustment of the saw blade tilt



NOTE



After adjusting the saw blade tilt, adapt the rip fence and/or the cross-cut fence so that they do not become contact with the tilted saw blade.



14.5.6 Scoring saw blade height adjustment



Adjust the height of the scoring blade (1) by turning the adjustment screw (2) with a screwdriver

More adjustments: see chapter MAINTENANCE

NOTE



When using the scoring blade, the height must be adjusted so that it cuts a slot with a depth of 1.5 - 2mm

14.5.7 Adjustment of the cutting width at rip fence



The cutting width can be adjusted on the rip fence and can be read off the ruler (1).

Clamping lever (2) up: rip fence unlocked

Clamping lever (2) down: rip fence locked

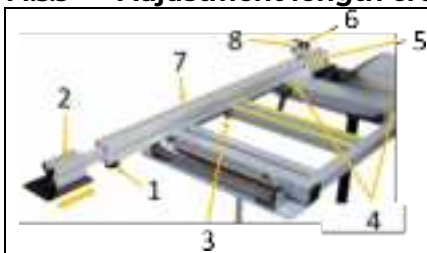
The fine adjustment is made by turning the knurled wheel (3)

14.5.8 Adjustment outrigger table



After losing the clamping screws (1), the outrigger table (2) can be moved along the slot in the sliding table. After reaching the desired position, tighten the clamping screws again.

14.5.9 Adjustment length cross-cut fence



The cutting width at the cross-cut fence can be adjusted by moving the flip stop (5) (the fine adjustment (8) is made by turning the knurled wheel) and read off the scale (7).

To do this, loosen the clamping lever (6), move the flip stop and fix it again with the clamping lever.

After losing the fixing knob (1), the length cross-cut fence (2) can be moved in and out. After reaching the desired position, tighten the fixing knob again.

The angle can be adjusted by losing the clamping screw (3) and/or changing the position of the pivot pin (4)

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 cables and operating elements must be checked carefully. Check screw connections for damage and tight fit.

15.1 Operating instructions

- Make sure that the saw blade used matches the set speed of the machine and that the diameter of the saw blade is compatible with the machine.
- Cracked and deformed saw blades cannot be repaired. They must be replaced immediately with new saw blades.
- Make sure that the machine works without vibrations.
- Always use the riving knife and the saw blade guard. Make sure that the riving knife, the saw blade guard and the height of the saw blade are positioned correctly. The riving knife must always be aligned with the workpiece. Otherwise there is a risk that the workpiece will stick and cause kickback.
- Make sure that the workpiece is in a stable position on the table and is supported by either the rip fence or the outrigger table during cutting.
- Make sure that the work table and the sliding table are parallel to the saw blade.
- Never stand in the direct cutting line of the saw blade, do not hold any parts of your body in the cutting line. Keep the side of the saw blade whenever cutting.
- Never reach over or behind the saw blade with your hand while cutting.

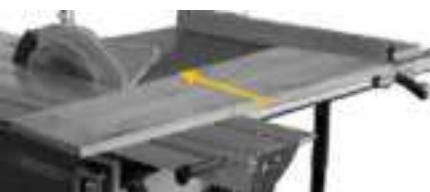


- Avoid awkward operations and hand positions where a sudden slip could cause your hand to get caught in the rotating saw blade.
- When using the cross-cut fence, the workpiece should not touch the rip fence at the same time as cutting.
- Use the push stick if the distance between the saw blade and the ruler of the rip fence is less than 120 mm.
- Use the downholder to secure the workpiece.
- Guide the workpiece smoothly until the end of cutting.
- Avoid jerky movements and changing direction.

15.2 Types of cut

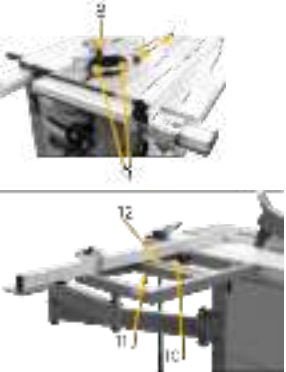
15.2.1 Workpiece size

Larger workpieces are moved by pushing the sliding table with little effort. Smaller workpieces can be pushed over the stationary table top, as with a table saw.

 bolpicture	Large workpieces - Adjust the rip fence or the cross-cut fence. If necessary, pull out the cross-cut fence. - Use the downholder to fix the workpiece. - Use the sliding table to move the workpiece. - For removal widths less than 120 mm, use the push stick. - Angle: Adjust the angle with the cross-cut fence.
 Symbolpicture	Smaller workpieces - For smaller workpieces, use the mitre gauge. Set the mitre gauge to 90° to the saw blade and place the workpiece against it. The rip fence can be used to support this. - Use the pushing stick. - Push the workpiece evenly with the pushing stick. - Angle: Set the angle with the mitre gauge. You can fix the angle stop in the groove of the worktable or the sliding table.

15.2.2 Mitre cuts

Depending on the workpiece size, set the desired angle on the mitre fence.

 Symbolpictures	Mitre fence - Loosen the locking screw (8) and position the mitre gauge. - If necessary, loosen the clamping screws (9) and move the mitre fence. - Fix the workpiece with the downholder. Cross-cut fence - Depending on the workpiece size and angle, select a rotation point in the outrigger table and fix the cross-cut fence. - Loosen the knurled nut on the below side of the cross-cut fence (10) and the clamping screw (11). - Adjust the angle of the cross-cut fence and read off the set angle on the scale (12). - Fix the workpiece with the downholder. - Use the sliding table to move the workpiece evenly.
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15.2.3 Angled cuts with inclined saw blade

 Symbolpicture	- Adjust the desired inclination of the saw blade (13). - Adjust the saw blade guard (14). - Adjust the rip fence (15) or the cross-cut fence (16). - Fix the workpiece with the downholder (17).
--	--

15.2.4 Longitudinal cut of boards

Use the down holder for cutting and fixing boards and avoiding a kickback.



	- Mount the down holder (1) in the groove of the sliding table. - Set the desired dimension with the rip fence or the cross-cut fence.
---	--

15.3 Operation

15.3.1 Switch the machine on and off

	Green ON-button (I): switch on the machine Stop flap activates the red OFF-button (O): switch off the machine
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15.3.2 Cutting

- Operating instructions read and followed
- Type of cut and appropriate machine setting selected.
- Switch on the machine
- Wait until saw blade has reached full speed (approx. 10 sec.)
- Carry out cut(s)
- Switch off the machine
- Wait until the machine has come to a complete standstill before moving any bodypart into the danger area (saw blade) or moving away from the machine.

15.3.3 End operation

NOTE

	When the work is finished, the machine must be switched off. → Lower the complete saw blade and the scoring saw blade → Switch-off the main switch to disconnect the machine from the power supply.
--	--

16 CLEANING, MAINTENANCE, STORGE, 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 cleaning, maintenance or repair work and secure it against unintentional reconnection.
---	---

CAUTION

	→ Wear protective cutting gloves when handling the saw blade and scoring blade to reduce the risk of injury!!
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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.
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- After each work shift, clean the machine and all its parts thoroughly.
- Vacuum the wood chips and sawdust. Wipe off any remaining dust with a dry cloth.
- Use a resin-dissolving cleaner for resin build-up.
- 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.



- Check the condition and tight fit of the saw blade and the saw blade guard before every operation.
- 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.
- Repair work may only be carried out by qualified personnel.

16.2.1 Maintenance schedule

The type and degree of machine wear depend on the operating conditions. The following intervals apply when the machine is used within the specified limits:

Interval	Components	Action
Before usage	Machine	Clean
	Loose fixing bolts, screws	Check for tight fit, tighten if necessary
	Switch, control elements	Check for function, replace if necessary
Once a week	Guide track and roller guide of sliding table and rip fence	Clean, blow out
	Moving parts	Lubricate
Once a month	Maintenance room	Vacuum chips Clean the motor housing
	Saw blade, scoring saw blade	Change
If necessary	V-belt	Change

16.2.2 Assembly / exchange saw blade

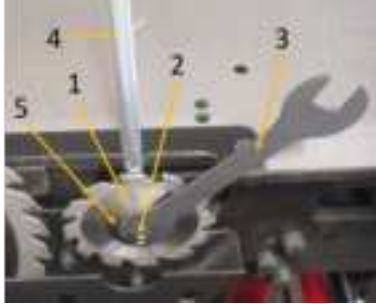
- Adjust the cutting height to the maximum possible level.
- Remove the saw blade guard (1) by slackening off the locking knob (2) and unhooking from the riving knife.
- Place the sliding table on the right side as far as possible.
- Loosen the screws (3) and remove safety cover of the saw blade.
- Fix the drive shaft with the supplied fixing pin (4).
- Turn the flangenut (8) with the blade wrench (5) clockwise (left thread) to loosen it.
- Remove the screw (8), flange (7) and saw blade (6) from the drive shaft.
- Clean the drive shaft and the flange thoroughly from impurities.
- Replace the old saw blade with a new one.
- Make sure that the new saw blade is undamaged and not dirty.
- Place the saw blade and the flange on the drive shaft.
- Screw the flangenut (8) back onto the drive shaft, fix it with the fixing pin (4) and tighten it counterclockwise with the blade wrench (5).

NOTE Retighten the flangenut tightly to prevent the nut from loosening during operation.
(tightening torque: 50Nm)

- Replace the safety cover of the saw blade and retighten the screws to hold it in place.
- Fit the saw blade guard on the riving knife.



16.2.3 Assembly / exchange / adjustments scoring saw blade



- Proceed the access of the scoring saw blade (1) as like as for the assembly of the main saw blade.
- Fix the drive shaft with the supplied fixing pin (4).
- Loosen the flange nut (2) with a wrench (3) by turning it anti-clockwise (right-hand thread).
- Remove the flange nut, flange (5) and scoring saw blade from the drive shaft.
- Clean the drive shaft and the flange thoroughly from impurities.
- Replace the old scoring saw blade with a new one.
- Make sure that the new scoring saw blade is undamaged and not dirty.
- Place the scoring saw blade (pay attention to the direction of rotation!) and the flange on the drive shaft.
- Screw the flange nut back onto the drive shaft, fix the drive shaft with the fixing pin and tighten it clockwise with a wrench.

NOTE Retighten the flange nut tightly (tightening torque: 25 Nm) to prevent the flange nut from loosening during operation.

- Replace the safety cover of the saw blade and retighten the screws to hold it in place.
- Fit the saw blade guard on the riving knife.

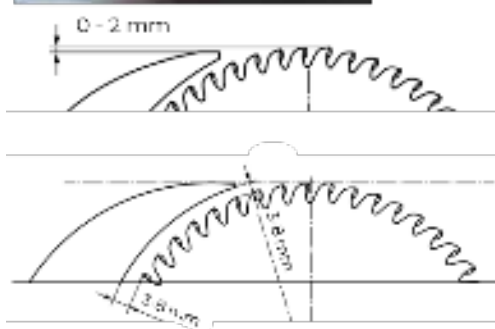


NOTE: The height of the scoring blade must be adjusted so that it cuts a slot of a depth of 1.5 - 2mm. The scoring saw blade has to be oriented exactly to the main saw blade

Adjustments:

- Adjust main saw blade to 90°
- Adjust the height of the scoring blade by turning the adjustment screw (3) with a screwdriver
- Lock the locking screw (1) with a screwdriver
- Adjust the scoring saw blade horizontally by turning the adjustment screw (2) with a screwdriver.
- Tighten the locking screw

16.2.4 Assembly / adjustment riving knife



The riving prevents the teeth on the rear circumference of the saw blade from touching the workpiece and causing unintentional damage or ejection.

- Proceed the access of the riving knife as like as for the assembly of the main saw blade.
- Loosen screw (1)
- Adjust the distance between saw blade and riving knife with screws (2).

NOTE: The distance between the saw blade and the top of the riving knife must be within 0-2 mm.

NOTE: The distance between the saw blade and the riving knife must be always within 3-8 mm.

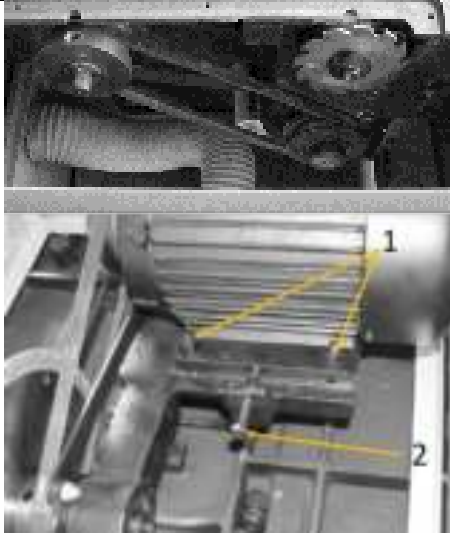
NOTE: Check with the rip fence whether the riving knife is parallel to the saw blade.

- Finally tighten (tightening torque: 25Nm) the screw (1).
- Replace the safety cover of the saw blade and retighten the screws to hold it in place.
- Fit the saw blade guard on the riving knife.



16.2.5 Checking / adjusting / replacing V-belt saw blade

The V-belt tension is set correctly for new machines ex-factory. By stretching the belts over the running time, retensioning of the V-belt is necessary.



- Adjust the cutting height to the maximum possible level.
- Remove the saw blade guard by slackening off the locking knob and unhooking from the riving knife.
- Place the sliding table on the left side as far as possible.
- Remove safety cover of the saw blade.
- Demount the saw blade
- Remove the chip housing by removing the 3 Allen screws

NOTE: To remove the 2 lower screws set the saw blade to 30°, to remove the upper screw set the saw blade to 90°

- The motor is fixed by 4 screws.
- Loosen the 4 nuts (1) of the motor bracket.
- Move the motor with the tension bolt (2) to release the tension.

For changing the V-belt, completely detension the V-belt and pull it over the tension pulleys and insert a new belt. Then establish correct V-belt tension again.

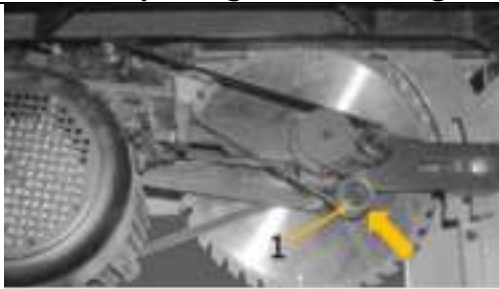
Increase V-belt tension:

Loosen the 4 nuts (1) now the motor can be shifted to more V-belt tension by turning in the tension bolt (2).
When correct tension is reached. Tighten the 4 nuts (1) firmly again

Decrease V-belt-tension:

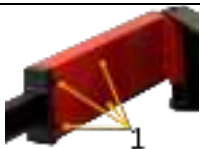
Loosen the 4 nuts (1) now the motor can be shifted to more V-belt tension by turning out the tension bolt (2).
When correct tension is reached. Tighten the 4 nuts (1) firmly again

16.2.6 Replacing V-belt scoring blade



- Adjust the cutting height to the maximum possible level
- Set the saw blade to 90°.
- Remove the 4 screw of the right panel from the machine frame and remove the panel
- Push the tension pulley (1) as far as possible in arrow direction
- Replace the V-belt
- Remount the right panel

16.2.7 Swivel arm guide rollers



Cleand swivel arm
By turning the 4 screws (1) you can close or move away the eccentric guide rollers and adjust a smooth running

16.3 Storage

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

NOTE



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



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



Danger due to electrical voltage! Handling the machine with the power 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!

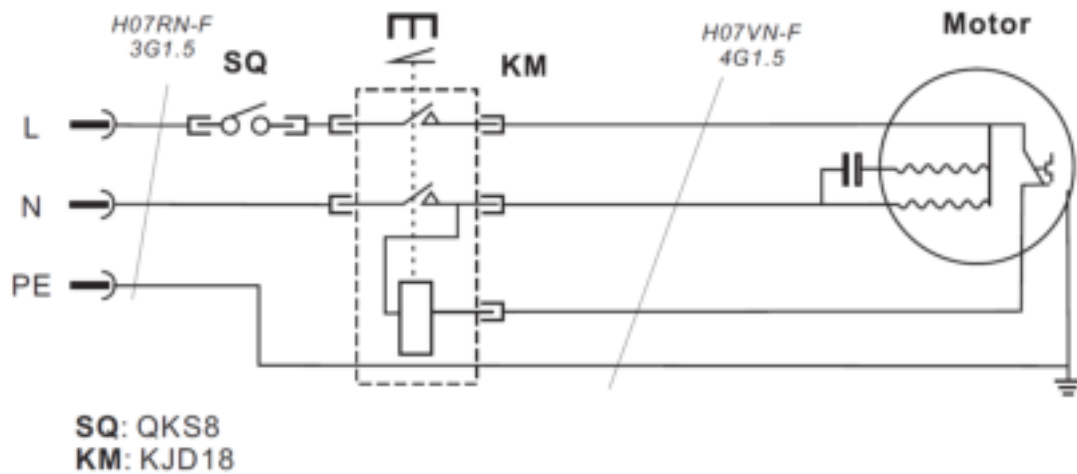
Many possible sources of error can be excluded in advance if the machine is properly connected to the power supply. If you are unable to carry out necessary repairs properly and/or do not have the required training, always consult a specialist to correct the problem!

Trouble	Possible cause	Solution
Machine does not start	1. Switch or a phase is broken	1. Repair the defective circuit or the faulty phase
Motor switches itself off	1. Machine overheated 2. Machine overloaded	1. Contact an electrician 2. Feeding too rapid Saw blade is dull
Machine vibrates during operation	1. Clamping lever for fixation of saw blade tilt is insufficiently fixed 2. The hand wheel for saw blade tilting is insufficiently fixed	1. Fix the clamping lever 2. Fix the hand wheel for saw blade tilting
Machine makes unusual noises	1. Bearings 2. V-belt loose	1. Inspect bearings, if necessary replace them 2. Check the tension of the V-belt, retighten if necessary
The saw blade height is difficult to adjust	1. The high of the spindle is difficult to adjust	1. Clean and lubricate the threaded rod, gears and slideways thoroughly. 2. Check the function of the clamping lever
Saw blade becomes blunt quickly	1. Contaminated wood processed (cement, nails, sand)	1. Only process perfect material
Burn marks on the workpiece	1. The saw blade is blunt 2. Saw blade is not mounted correctly	1. Replace the saw blade 2. Check and, if necessary, correctly mount the saw blade
Broken edges on the workpiece	1. The saw blade or work tables are incorrectly adjusted 2. Saw blade is incorrectly mounted	1. Adjust the saw blade or work tables 2. Check and, if necessary, correctly mount the saw blade
The finished dimension of the processed workpiece does not correspond to the cutting width set on the rip fence	1. The ruler for the cutting width display at the rip fence is set incorrectly	1. Setting dimension scale: Cut the workpiece at the rip fence, measure the workpiece and move the measuring scale so that the correct cutting width can be read off at the edge of the ruler
Workpiece jams while feeding	1. The saw blade is blunt 2. The work table is not clean 3. The riving knife thickness does not match with the saw blade used	1. Replace the saw blade 2. Clean the worktable 3. Riving knife thickness must be greater than or equal to the saw blade thickness
Wood is raised by the rear side of the saw blade	1. Rip fence not correctly adjusted 2. The riving knife is not correctly aligned 3. Saw blade does not match with riving knife	1. Adjust rip fence 2. Adjust riving knife 3. The saw blade must be narrower in relation to the riving knife

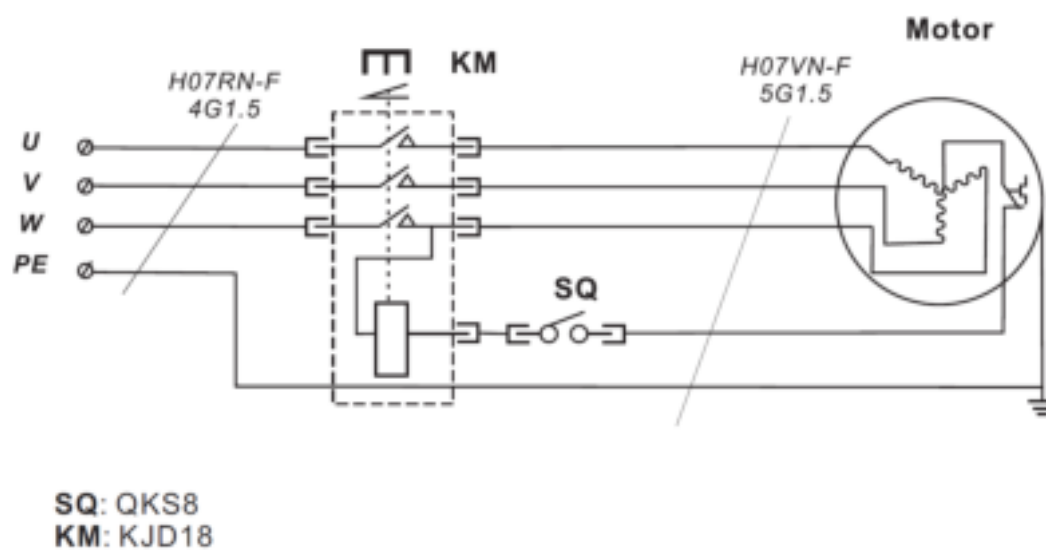


32 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM / DIAGRAMA ELÉCTRICO / DIAGRAMA DE CIRCUITES ELÉTRICOS

230V:



400V:





33 ERSATZTEILE / SPARE PARTS / PIEZAS DE RECAMBIO / PEÇAS SOBRESSALENTES

33.1 Ersatzteilbestellung / Spare parts order / Pedido de piezas / Encomenda de peças sobressalentes

(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.

(ES) Con las piezas de recambio de HOLZMANN, utiliza piezas de recambio que se ajustan perfectamente entre sí. El ajuste óptimo de los componentes acorta el tiempo de instalación y aumenta la vida útil.

AVISO



¡La instalación de piezas de recambio no originales lleva a la pérdida de garantía! Por lo tanto: Al llevar a cabo la sustitución de componentes/piezas, utilice únicamente piezas de recambio recomendadas por el fabricante.

Pida las piezas de recambio directamente en nuestra página web: Categoría PIEZAS DE RECAMBIO.
o póngase en contacto con nuestro servicio de atención al cliente

- en nuestra página web: Categoría SERVICIO – SOLICITUD DE PIEZAS DE RECAMBIO,
- por correo electrónico a service@holzmann-maschinen.at.

Indique siempre el tipo de máquina, la referencia de la pieza de recambio y la denominación. Para evitar malentendidos, se recomienda adjuntar al pedido una copia del esquema de piezas de recambio en el que se marque claramente las piezas de recambio necesarias, cuando no se solicitan con el catálogo en línea de piezas de recambio.

(PT) Com as peças sobressalentes da HOLZMANN utilizam-se peças que se combinam de forma ideal umas com as outras. A ótima precisão de montagem das peças encurta o tempo de instalação e aumenta a vida útil.

AVISO



A instalação de peças sobressalentes não originais conduz à perda da garantia! Assim, aplica-se o seguinte: Para a substituição de componentes/peças, utilizar apenas peças sobressalentes recomendadas pelo fabricante.

Encomende as peças sobressalentes diretamente na nossa página inicial - categoria PEÇAS SOBRESSALENTES.

ou contacte o nosso serviço de apoio ao cliente

- através da nossa página inicial - categoria SERVIÇO - PEDIDO DE PEÇAS SOBRESSALENTES,
- por correio eletrónico para service@holzmann-maschinen.at.

Indique sempre o tipo de máquina, número de peça sobressalente e designação. Para evitar mal-entendidos, recomendamos que anexe à encomenda de peças sobressalentes uma cópia do desenho das peças sobressalentes, no qual estão claramente assinaladas as peças sobressalentes necessárias, caso não efetue a consulta através do catálogo de peças sobressalentes online.



33.2 Explosionszeichnungen / Exploded view / Vistas de despiece / Vistas explodidas

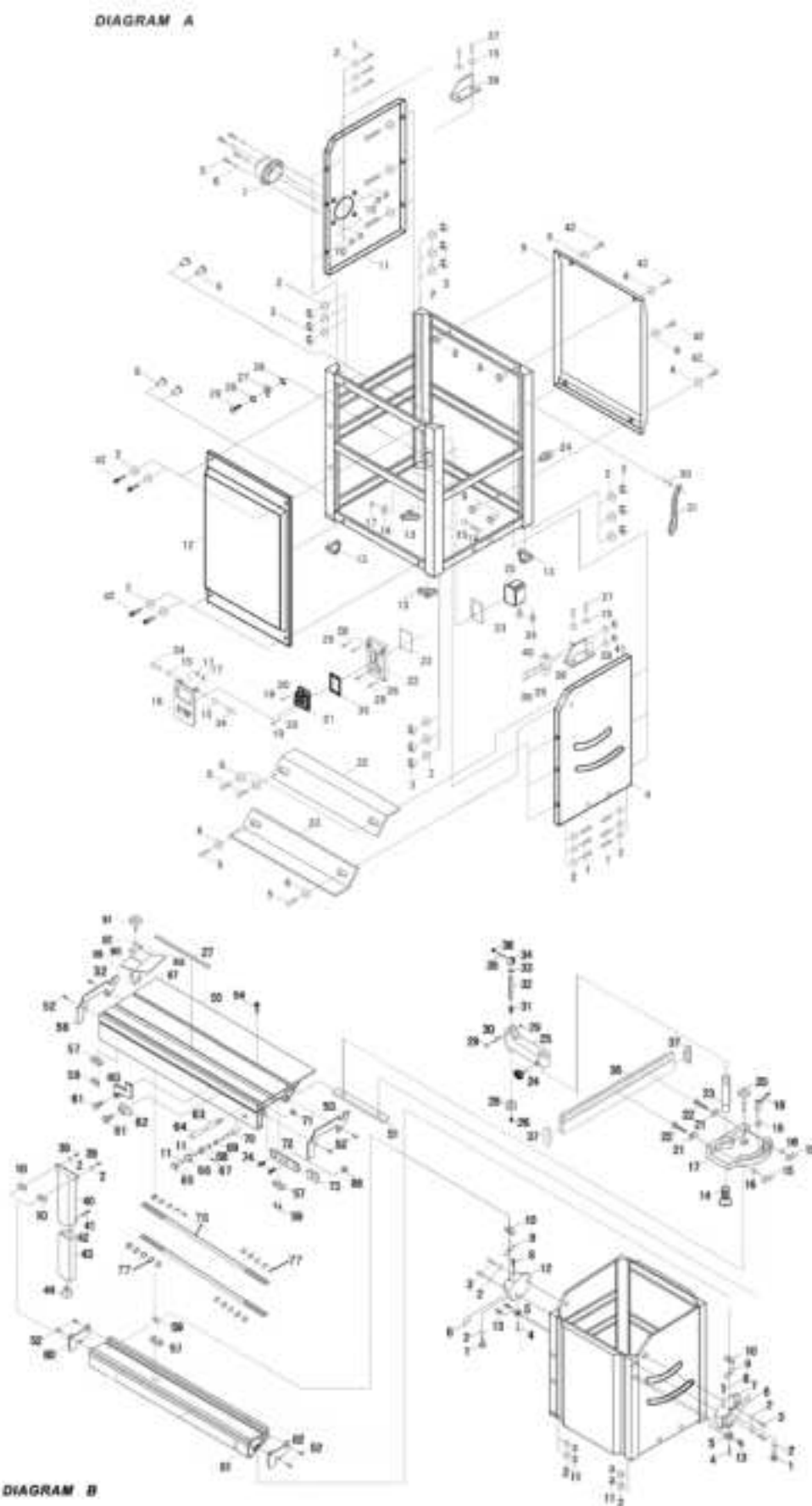




DIAGRAM C

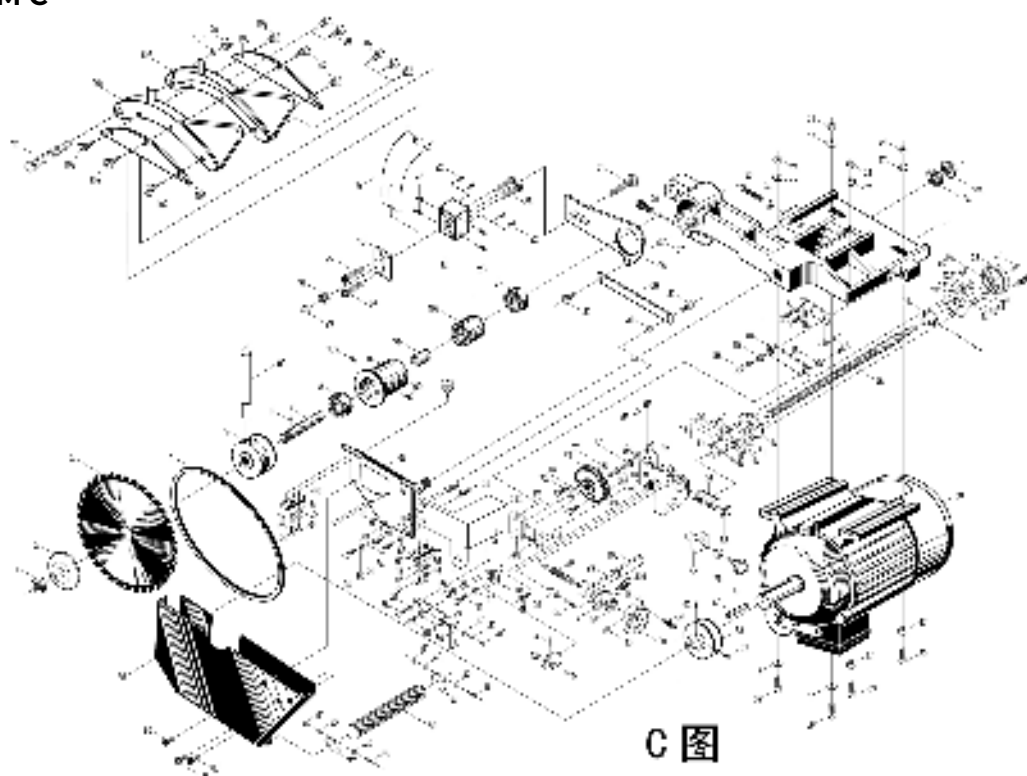


DIAGRAM D

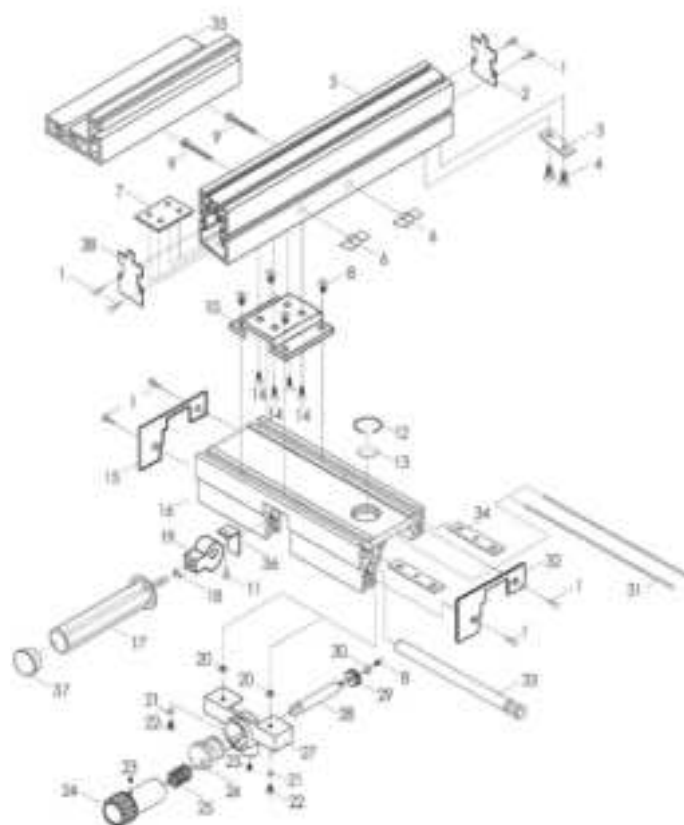




DIAGRAM E

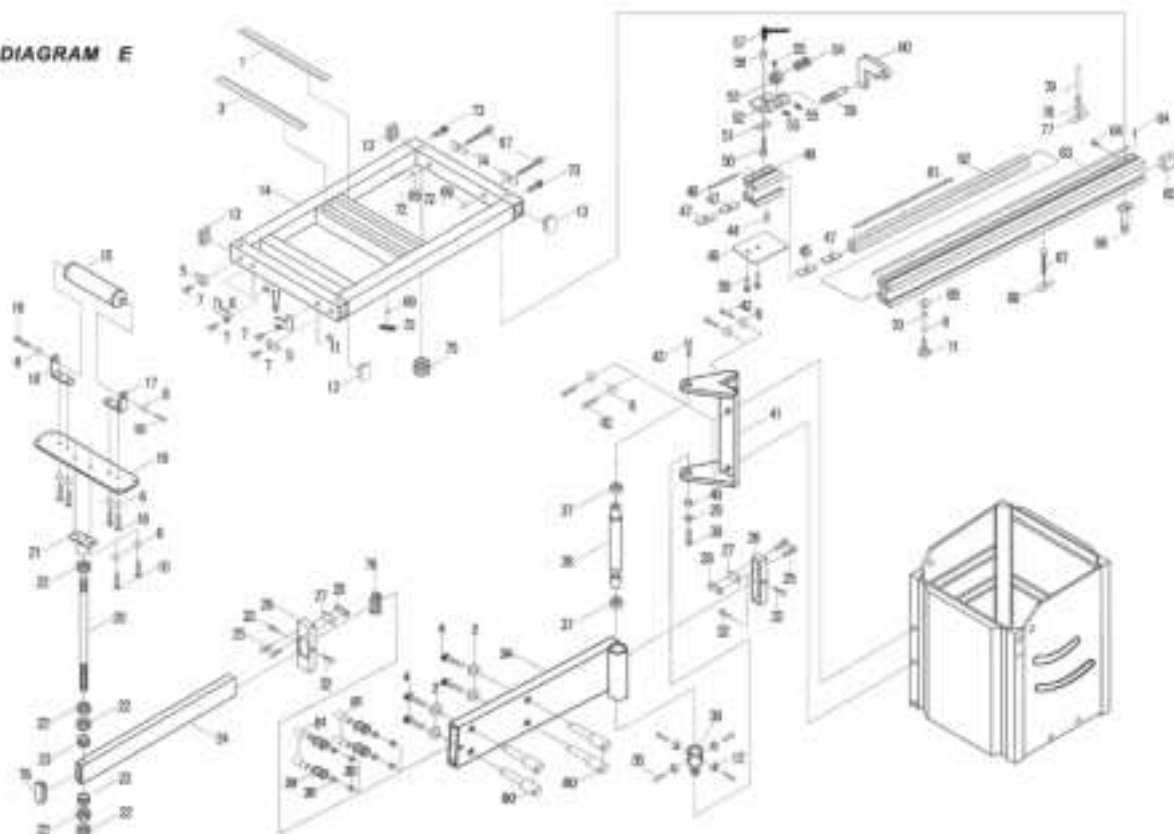
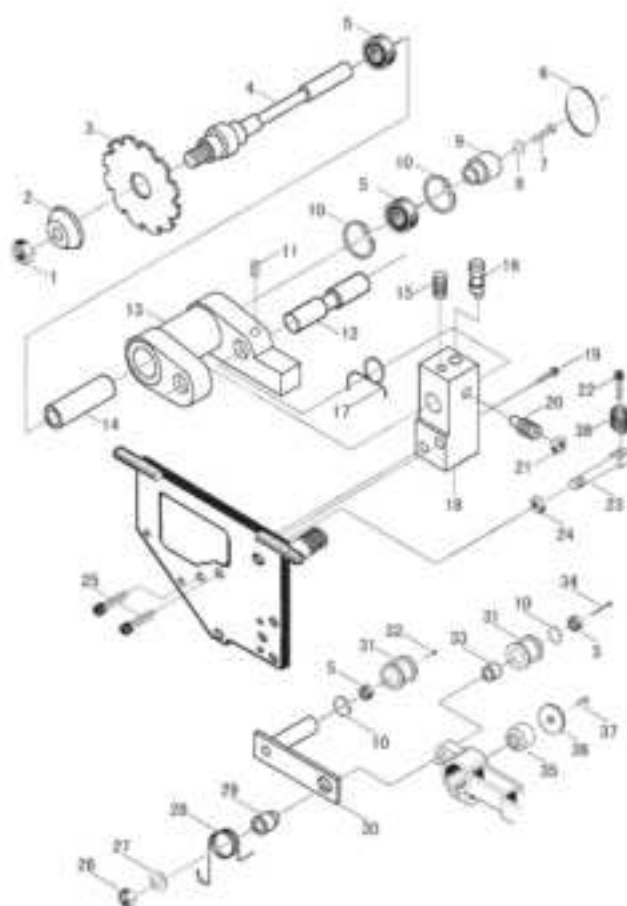


DIAGRAM F



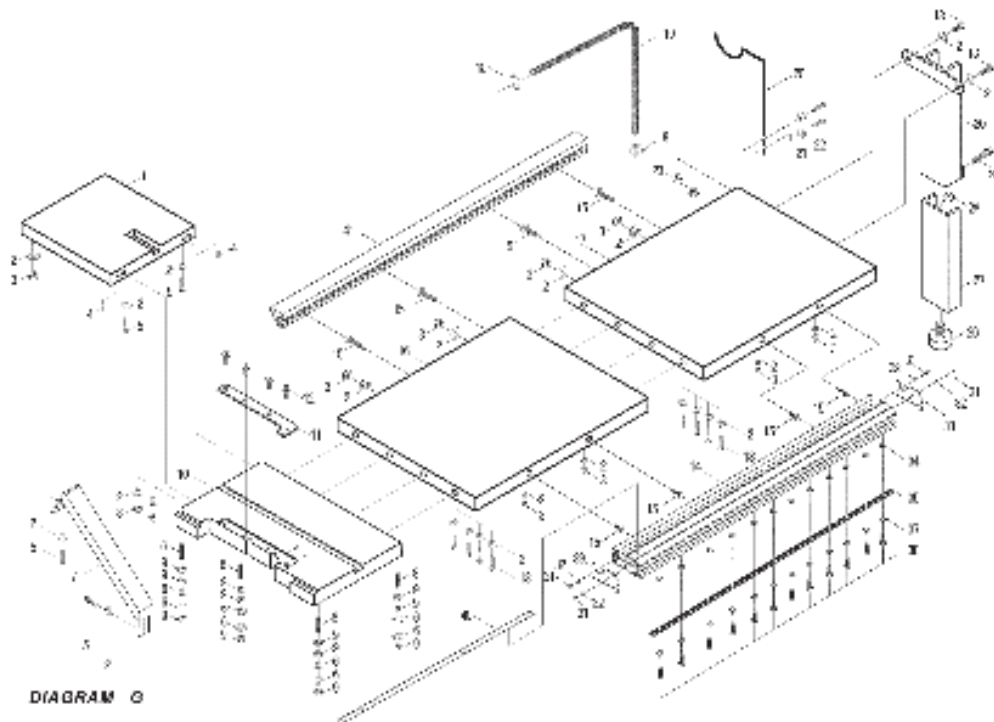


DIAGRAM G

DIAGRAM H



Parts List Diagram A

No.	Description	No.	Description
A-1	Hex screw M5x10	A-22	Drive roller pin
A-2	Roller pin	A-23	End cap plate
A-3	Roller pin	A-24	End cap pin
A-4	End cap pin	A-25	Roller pin
A-5	Roller pin	A-26	End cap plate
A-6	Roller pin	A-27	End cap pin
A-7	Roller pin	A-28	End cap pin
A-8	Roller pin	A-29	End cap pin
A-9	Roller pin	A-30	End cap pin
A-10	Roller pin	A-31	End cap pin
A-11	Roller pin	A-32	End cap pin
A-12	Roller pin	A-33	End cap pin
A-13	Roller pin	A-34	End cap pin
A-14	Roller pin	A-35	End cap pin
A-15	Roller pin	A-36	End cap pin
A-16	Roller pin	A-37	End cap pin
A-17	Roller pin	A-38	End cap pin
A-18	Roller pin	A-39	End cap pin
A-19	Roller pin	A-40	End cap pin
A-20	Roller pin	A-41	End cap pin
A-21	Roller pin	A-42	End cap pin

Parts List Diagram B

No.	Description	No.	Description
B-1	Carriage roller pin	B-12	Carriage roller pin
B-2	Carriage roller pin	B-13	Carriage roller pin
B-3	Carriage roller pin	B-14	Carriage roller pin
B-4	Carriage roller pin	B-15	Carriage roller pin
B-5	Carriage roller pin	B-16	Carriage roller pin
B-6	Carriage roller pin	B-17	Carriage roller pin
B-7	Carriage roller pin	B-18	Carriage roller pin
B-8	Carriage roller pin	B-19	Carriage roller pin
B-9	Carriage roller pin	B-20	Carriage roller pin
B-10	Carriage roller pin	B-21	Carriage roller pin
B-11	Carriage roller pin	B-22	Carriage roller pin
B-12	Carriage roller pin	B-23	Carriage roller pin
B-13	Carriage roller pin	B-24	Carriage roller pin
B-14	Carriage roller pin	B-25	Carriage roller pin
B-15	Carriage roller pin	B-26	Carriage roller pin
B-16	Carriage roller pin	B-27	Carriage roller pin
B-17	Carriage roller pin	B-28	Carriage roller pin
B-18	Carriage roller pin	B-29	Carriage roller pin
B-19	Carriage roller pin	B-30	Carriage roller pin
B-20	Carriage roller pin	B-31	Carriage roller pin
B-21	Carriage roller pin	B-32	Carriage roller pin



Parts List Diagram B cont.				Parts List Diagram C			
No.	Description	No.	Description	No.	Description	No.	Description
B-42	Lower support	B-66	Spring lock pin	C-1	Arbor nut (left)	C-25	Stop screw
B-44	Adjustable stop	B-70	Lock pin	C-2	Outer flange	C-26	Allen screw M10x30
B-51	Screw guide	B-71	Hex nut M10	C-3	Base blade	C-27	Lock nut M8
B-52	Tapping screw STA 2x12	B-72	Lock pin	C-4	V-belt 550mm	C-28	Riveting hole bracket
B-53	End cap, sliding panel	B-73	End cap, sliding panel	C-5	Pushing blade	C-29	Connector nut
B-54	Allen screw M10x1	B-74	Set screw M8x12	C-6	Pushing blade	C-30	End head screw M10x20
B-55	End cap, sliding panel	B-77	Set 1/2"	C-8	Flat key 5x5x25	C-31	End, connection nut
B-56	End cap, sliding panel	B-78	Set 1/2"	C-9	Arbor shaft	C-32	End head screw M10x20
B-57	Stop plate	B-80	End cap, sliding panel	C-10	Beaking 525x 290	C-33	Hex screw M10x1
B-58	End head screw M10x10	B-81	End cap, sliding panel	C-11	Arbor shaft sleeve	C-34	End nut for motor base
B-59	1/2" lock plate	B-83	End cap, sliding panel	C-12	Circle ring 40mm	C-35	Tapping screw STA 2x12
B-61	End head screw M10x1	B-84	Lock nut M8	C-13	Mount frame, riveting knife	C-37	Set screw M10x1
B-62	End cap, sliding panel	B-87	Threaded shaft	C-14	End stop	C-38	Handwheel, main blade
B-63	Push handle	B-88	Hex nut M8	C-15	Set screw M8x12	C-39	Handle
B-64	End, main handle	B-89	End stop	C-16	Spacer, elevation gear	C-40	End head screw M10x1
B-65	End cap, main	B-90	End stop	C-17	Hex screw M10x1	C-41	Washer 8 mm
B-66	Star-type lock, lock pin	B-91	Star-type screw M10x1	C-18	Washer 8 mm	C-42	Washer, knob
B-67	Set pin 1x10	B-92	Washer frame	C-19	Block plate	C-43	Angle connection knob
B-68	End, lock pin			C-20	Riveting knife	C-44	Roll pin 4x25
				C-21	Knurled nut	C-45	Angle adjust thread
				C-22	Carriage bolt M10x80	C-47	Elevation pad A
				C-23	Set screw M10x1	C-48	Elevation connection nut
				C-24	Set screw M10x1	C-49	Elevation pad B
				C-25	Hex nut M8	C-51	Hex nut M8

Parts List Diagram C cont.				Parts List Diagram D			
No.	Description	No.	Description	No.	Description	No.	Description
C-52	Adjusting frame	D-17	Hex screw M10x1	D-1	Tapping screw STA 2x12	D-20	End nut
C-53	Circle ring 40mm	D-18	Hex screw M10x1	D-2	Hex plate, frame	D-21	Washer frame
C-54	End stop	D-19	End head screw M10x1	D-3	End plate, frame	D-22	End head screw M10x1
C-55	End head screw M10x1	D-20	End nut	D-4	End head screw M10x1	D-23	Set screw M10x1
C-56	Elevation gear	D-21	End nut	D-5	Frame	D-24	Frame, fine adjust gear
C-57	Lock block	D-22	End nut	D-6	Wing nut	D-25	Collaring, fine adjust
C-58	Arbor	D-23	End nut	D-7	Screw guide	D-26	End cap, fine adjust
C-59	Hex screw M10x1	D-24	End nut	D-8	End head screw M10x1	D-27	Frame, fine adjust gear
C-60	Flat key 5x5x25	D-25	End nut	D-9	Carriage screw M10x1	D-28	Gear rod, fine adjust
C-61	Set screw M10x1	D-26	End nut	D-10	Frame plate	D-29	Core gear
C-62	Set screw M10x1	D-27	End nut	D-11	End head screw M10x1	D-30	Washer frame
C-63	Pushing blade	D-28	End nut	D-12	Circle ring	D-31	End cap, frame
C-64	Hex screw M10x1	D-29	End nut	D-13	Lock	D-32	End cap, frame
C-65	Lock washer frame	D-30	End nut	D-14	Allen screw M10x1	D-33	Lock shaft, fine adjust
C-66	Angle lock block	D-31	End nut	D-15	End cap, frame	D-34	Screw guide
C-67	Angle screw	D-32	End nut	D-16	Frame center	D-35	Frame "L" shape
C-68	Hex nut M10	D-33	End nut	D-17	Lock handle, frame	D-36	Lock plate
C-69	Lock washer frame	D-34	End nut	D-18	Hex nut M8	D-37	End cap, lock handle
C-70	End head screw M10x1	D-35	End nut	D-19	End nut M8	D-38	Frame plate, frame
C-71	Flat key 5x5x25						
C-72	End head screw M10x1						
C-73	End head screw M10x1						
C-74	End head screw M10x1						
C-75	End head screw M10x1						
C-76	End head screw M10x1						
C-77	End head screw M10x1						
C-78	End head screw M10x1						
C-79	End head screw M10x1						
C-80	End head screw M10x1						
C-81	End head screw M10x1						
C-82	End head screw M10x1						
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C-84	End head screw M10x1						
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C-129	End head screw M10x1						
C-130	End head screw M10x1						
C-131	End head screw M10x1						
C-132	End head screw M10x1						
C-133	End head screw M10x1						
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C-183	End head screw M10x1						
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C-190	End head screw M10x1						
C-191	End head screw M10x1						
C-192	End head screw M10x1						
C-193	End head screw M10x1						
C-194	End head screw M10x1						
C-195	End head screw M10x1						
C-196	End head screw M10x1						
C-197	End head screw M10x1						
C-198	End head screw M10x1						
C-199	End head screw M10x1						
C-200	End head screw M10x1						



Parts List Diagram E

No.	Description
E-1	Scale, cross cut table
E-2	Washer 8mm
E-3	Scale, cross cut table
E-4	Allen screw M6x12
E-5	Excentric cam
E-6	Washer 8mm
E-7	Sunk head screw M6x10
E-8	1/2" lock plate
E-9	1/2" lock plate
E-10	Hex screw M6x20
E-11	Lock nut M6
E-12	Hex nut M8
E-13	End cap, cross cut table
E-14	Circle cut table
E-15	Roller
E-16	Hex screw M6x32
E-17	Bracket, roller
E-18	Bracket, roller
E-19	Roller, roller
E-20	Support rod, cross cut table
E-21	Joint, support
E-22	Thin hex nut M10
E-23	Bearing 8104
E-24	Swing arm, extension
E-25	Pin head screw M5x12
E-26	Insert, swing arm
E-27	Washer sheet
E-28	Block
E-29	Roll
E-30	Bearing 8101
E-31	Pin head screw M5x10
E-32	Swing arm
E-33	Hex screw M6x35
E-34	Stop roller
E-35	Bearing 8202
E-36	Shaft, swing arm
E-37	Hex screw M6x30
E-38	Thin nut M10
E-39	Support, swing arm
E-40	Hex screw M6x30

No.	Description
E-41	Hex screw M10x25
E-42	Sunk head screw M6x12
E-43	T-nut, extension fence
E-44	Lock plate
E-45	T-block
E-46	Scale
E-47	End, extension fence
E-48	Carriage bolt M6x38
E-49	Screw guide
E-50	Flip stop fence
E-51	Knurled knob
E-52	Spring, flip stop
E-53	Ball screw
E-54	Spacer, knurled lever
E-55	Ballhead lever, flip stop
E-56	Allen screw M6x20
E-57	Shut, flip stop
E-58	Flip stop
E-59	Scale, extension fence
E-60	Extension fence
E-61	Scale, cross cut fence
E-62	Tapping screw ST4.2 x12
E-63	End cap, cross cut fence
E-64	Lock stud, cross cut fence
E-65	Carriage bolt M6x75
E-66	T-block
E-67	Flat washer M6
E-68	Spatul, lock handle
E-69	Star-type lock handle
E-70	Wing nut M8
E-71	Shut, cross cut table
E-72	T-block
E-73	Knurled knob, fence
E-74	End cap, swing arm
E-75	T-block, hold down
E-76	Washer 12mm
E-77	Shut, hold down
E-78	Excentric shaft
E-79	Sleeve

Parts List Diagram F

No.	Description
F-1	Hex nut M6
F-2	Outer flange, scoring blade
F-3	Scoring blade
F-4	Arbor, scoring blade
F-5	Bearing 6100-RS
F-6	Flat belt

No.	Description
F-7	Hex screw M6x12
F-8	Washer 8mm
F-9	Pulley, scoring blade
F-10	Circle ring 40mm
F-11	Set screw M6x6
F-12	Adjusting shaft

Parts List Diagram F (cont.)

No.	Description
F-13	Bearing 6101
F-14	Outer flange, scoring blade
F-15	Scoring blade
F-16	Arbor, scoring blade
F-17	Bearing 6102
F-18	Hex screw M6x12
F-19	Washer 8mm
F-20	Hex nut M6
F-21	Excentric shaft
F-22	End cap, swing arm
F-23	Hex screw M6x30
F-24	Thin nut M10
F-25	Hex screw M6x30

Parts List Diagram G

No.	Description
G-1	Hex extension screw
G-2	Washer 8mm
G-3	Hex nut M6
G-4	Set Lock M6x12
G-5	Hex screw M6x16
G-6	Flat washer 11mm
G-7	Hex plate support
G-8	Spig screw M6x12
G-9	Hex nut M6
G-10	Major roller
G-11	Roller mount
G-12	Sunk head screw M6x8
G-13	Hex screw M6x20
G-14	Knurled cap
G-15	Roller head nut M6x20
G-16	Extension roller
G-17	Shut extension fence
G-18	Hex nut M10
G-19	Shut fence 30mm dia. 10x10mm

No.	Description
G-20	Lock nut M10
G-21	Washer 8mm
G-22	Hex screw M6x20
G-23	Hex nut M6
G-24	Adjustable stop
G-25	Lock support
G-26	Allen screw M6x20
G-27	Spacer, support
G-28	Tapping screw ST4.2x12
G-29	Knurled knob
G-30	Right end cap, drawbar
G-31	Flange M6
G-32	Roller fence
G-33	Lock system 30mm
G-34	Flat head screw M6x6
G-35	Left end cap, flat belt
G-36	Scale, left
G-37	Roller belt

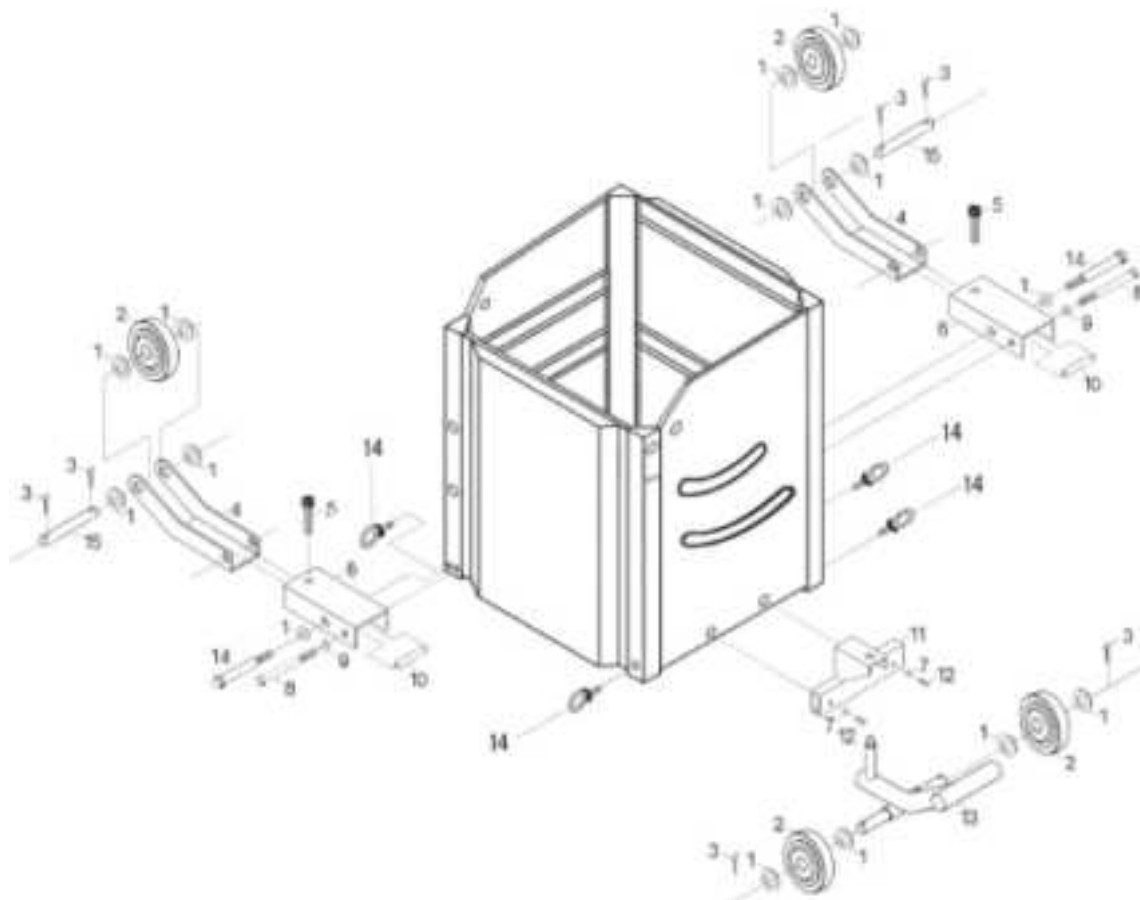
Parts List Diagram H

No.	Description
H-1	Micro gauge head
H-2	Washer 8mm
H-3	Micro gauge head
H-4	Pin head screw M6x10
H-5	Indicator gauge
H-6	Block indicator
H-7	Stop pin
H-8	Sunk head screw M6x8
H-9	Roller, gauge
H-10	Guide pin

No.	Description
H-11	Micro gauge nut
H-12	Pin head screw M6x10
H-13	Hex nut M6
H-14	Scale, gauge
H-15	End cap, Gauge fence
H-16	Gauge fence
H-17	Carriage bolt M6x32
H-18	Washer 8mm
H-19	Knurled nut



DIAGRAM J (optional)



Parts List Diagram J (optional)

No	Description	No	Description
J-1	Washer 16mm	J-9	Washer 12mm
J-2	Castor	J-10	Bushing bracket
J-3	Roll pin 4x30	J-11	Support, pull rod
J-4	Bracket castor	J-12	Hex screw M10x55
J-5	Allen screw M12x50	J-13	Pull rod
J-6	Bracket castor	J-14	Bolt, bracket
J-7	Washer 10mm	J-15	Shaft, castor
J-8	Hex screw M12x80	J-16	Lift ring

34 ZUBEHÖR / ACCESSORIES / ACCESORIO / ACESSÓRIOS

(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.

(ES) Los accesorios opcionales se encuentran en la página del producto en internet, en la categoría ACCESORIOS RECOMENDADOS PARA EL PRODUCTO.

(PT) Os acessórios opcionais podem ser encontrados online na página do produto, categoria ACESSÓRIOS RECOMENDADOS PARA O PRODUTO.



35 EG-KONFORMITÄTSERKLÄRUNG/CE-CERTIFICATE OF CONFORMITY / DECLARACIÓN DE CONFORMIDAD CE / DECLARAÇÃO DE CONFORMIDADE UE

	HOLZMANN MASCHINEN® GmbH 4170 Haslach, Marktplatz 4, AUSTRIA Tel.: +43/7289/71562-0 www.holzmann-maschinen.at
Bezeichnung / Name / Denominación / Designação	
FORMATKREISSÄGE / PANEL SAW / ESCUADRADORA / SERRA DE DIMENSIONAMENTO	
Typ / Model / Modelo / Tipo	
TS315VF2000_230V TS315VF2000_400V	
EU-Richtlinien / EC-directives / Directivas de la EU / Diretivas CE	
• 2006/42/EC • 2014/30/EC • 2011/65/EC	
Angewandte Normen / Applicable standards / Normas aplicables / Normas aplicadas	
EN ISO 19085-1; EN ISO 19085-5	

(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.

(ES) Por medio de la presente, declaramos que las máquinas arriba mencionadas debido a su concepción y construcción en la versión comercializada por nosotros cumplen todos los requisitos esenciales en materia de seguridad y de salud de las directivas UE mencionadas. Esta declaración perderá su validez en caso de que se lleven a cabo modificaciones en la máquina que no hayan sido acordadas con nosotros.

(PT) Declaramos aqui que as máquinas acima mencionadas, devido à sua conceção, na versão comercializada por nós, cumprem os requisitos essenciais de saúde e segurança das diretivas UE mencionadas. Esta declaração perde a sua validade se forem feitas alterações à máquina que não tenham sido acordadas connosco.

Technische Dokumentation
HOLZMANN-MASCHINEN GmbH
4170 Haslach, Marktplatz 4

Haslach, 10.08.2023
Ort / Datum place/date


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Geschäftsführer / Director