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Originalfassung

DE BETRIEBSANLEITUNG **HOLZBANDSÄGE Tisch XL**

Übersetzung / Translation

EN USER MANUAL **WOOD BANDSAW table XL**

HBS610_230V
HBS610_400V

YOUR JOB. OUR TOOLS.

Edition: 26.08.2022 – Revision – 00 – EcC – DE/EN

7 SICHERHEITSZEICHEN / SAFETY SIGNS

DE SICHERHEITSZEICHEN
BEDEUTUNG DER SYMBOLE

EN SAFETY SIGNS
DEFINTION 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 Bedienen mit Handschuhen verboten!

EN Operation with gloves forbidden!

DE Schutzausrüstung tragen!

EN Wear protective equipment!

DE Maschine vor Wartung und Pausen ausschalten und Netzstecker ziehen!

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

DE Warnung vor Schnittverletzungen!

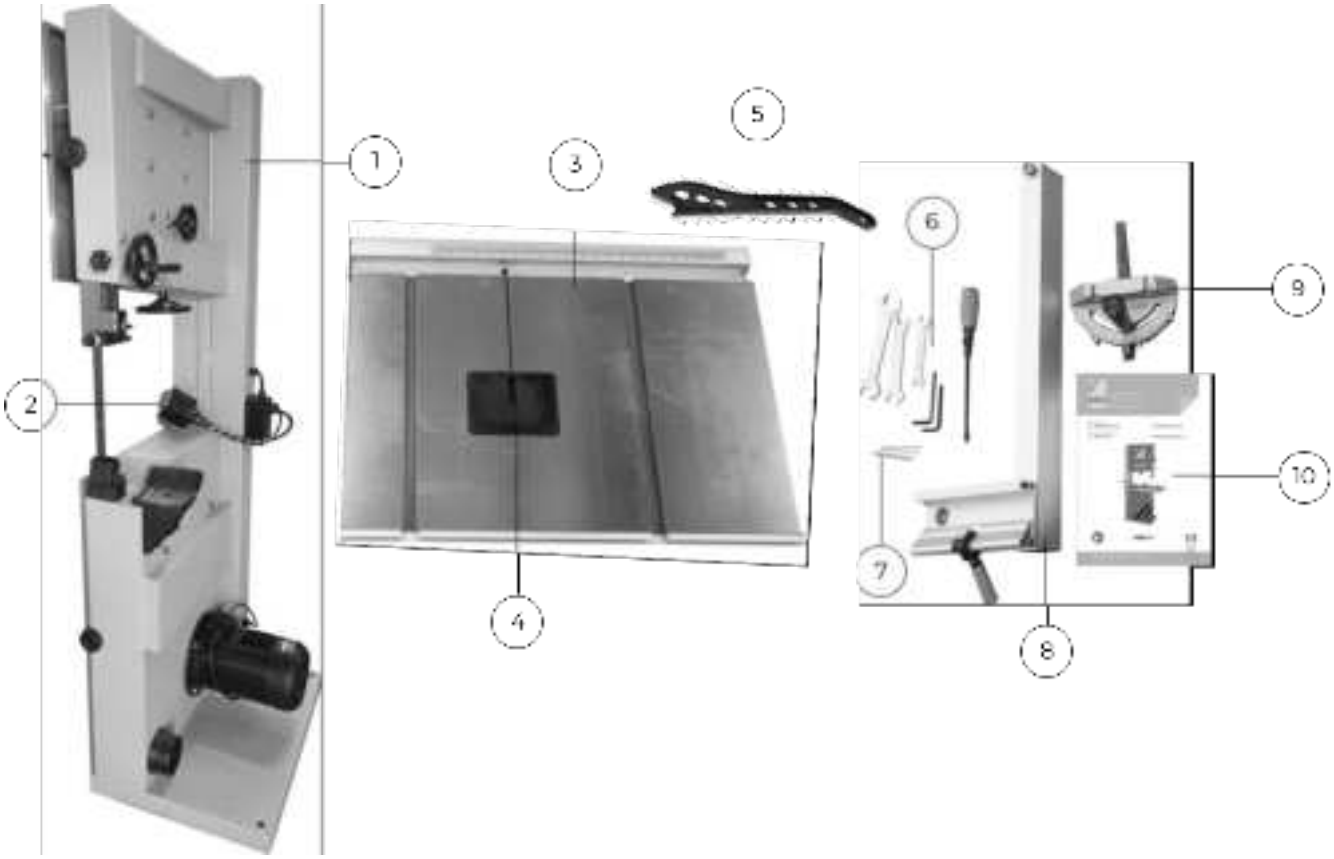
EN Warning of crush injuries!

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

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

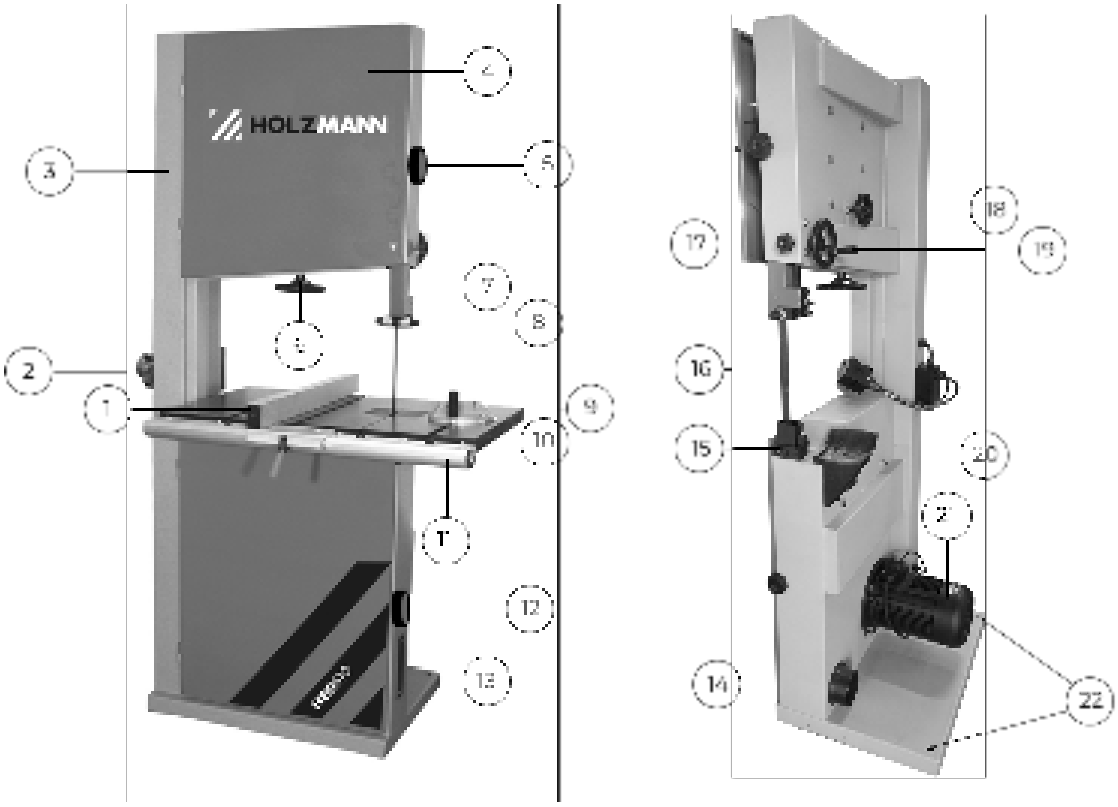
3 TECHNIK / TECHNICS

3.1 Lieferumfang / Delivery content



#	Beschreibung / Description
1	Maschine / machine
2	Schaltereinheit / switch unit
3	Graugusstisch mit Führungsanschlag und Lineal / cast iron table with guide stop and ruler
4	Tischeinlage / table inlay
5	Schiebstock / push stick
6	Werkzeug-Set / tool kit
7	Schrauben (für Befestigung der Schaltereinheit) / screws (for fixing the switching unit)
8	Parallelanschlag mit Exzenterhebel / rip fence with eccentric lever
9	Gehrungsanschlag / mitre gauge
10	Betriebsanleitung / user manual

3.2 Komponenten / Components



#	Beschreibung / Description
1	Parallelanschlag / rip fence
2	EIN-AUS-Schalter / ON-OFF switch
3	Maschinenrahmen / machine frame
4	Obere Laufradabdeckung / upper flywheel cover
5	Klemmrad - obere Laufradabdeckung / clamping wheel - upper flywheel cover
6	Handrad – Sägebandspannung / handwheel – saw band tensioning
7	Sägebandabdeckung verstellbar / saw band guard adjustable
8	Obere Sägebandführung / upper saw band guide
9	Gehrungsanschlag / mitre gauge
10	Arbeitstisch / worktable
11	Führung Parallelanschlag mit Skala / guide rip fence with scale
12	Klemmrad - untere Laufradabdeckung / clamping wheel - lower flywheel cover
13	Untere Laufradabdeckung / lower flywheel cover
14	Absauganschluss / dust collector port
15	Untere Sägebandführung / lower saw band guide
16	Sägeband / saw band
17	Klemmrad - Sägebandführungshöhenverstellung / clamping wheel - saw band guide height adjustment
18	Einstellrad und Klemmung – Sägebandlauf / setting wheel and clamping - saw band tracking
19	Handrad-Sägebandführungshöhenverstellung / handwheel - saw band guide height adjustment
20	Schwenkvorrichtung Arbeitstisch / swivel device worktable
21	Motor / motor
22	Befestigungspunkte / fastening points

3.3 Technische Daten / Technical data

Spezifikation / Specification	HBS610_230V	HBS610_400V
Spannung / voltage	230 V / 50 Hz	400 V / 50 Hz
Motorleistung S1 (100 %) / motor power S1 (100 %)	2,2 kW	3,0 kW
Ausladung - max. Schnittbreite / outreach - max. cutting width	585 mm	
Schnittbreite am Parallelanschlag / max. cutting width at rip fence	545 mm	
Schnitthöhe bei 90° / cutting height at 90°	300 mm	
Gesamthöhe / total height	1980 mm	
Dimension Standfläche / dimension base	550 x 770 mm	
Dimensionen des Arbeitstisches / worktable dimensions	550 x 860 mm	
Schwenkbereich Arbeitstisch / worktable tilt angle range	0°-+ 20°	
Tischhöhe / table height	970 mm	
Sägebandbreite / sawband width	8 – 32 mm	
Sägebandlänge / sawband length	4080 mm	
Sägebandgeschwindigkeit / saw band speed	600 m min^{-1}	
Laufraddurchmesser Ø / flywheel diameter Ø	600 mm	
Absauganschluss Ø / dust collector port Ø	100 mm	
notwendiger Absaug Luft-Volumenstrom / necessary air-flow-rate (dust collector)	1080 m^3 h^{-1}	
Notwendiger Unterdruck (Absauganlage) / necessary vaccum pressure (dust collector)	1000 Pa	
Maschinenmaße (LxBxH) / machine dimensions (LxWxH)	1150 x 930 x 2000 mm	
Verpackungsmaße (LxBxH) / packaging dimensions (LxWxH)	920 x 2060 x 590 mm	
Gewicht Brutto / weight gross	335 kg	
Gewicht Netto / weight net	300 kg	
Schallleistungspegel L_{WA} / sound power level L_{WA}	101,5 dB(A).....k: 4 dB(A)	
Schalldruckpegel L_{PA} / sound pressure level L_{PA}	84,9 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.

11 PREFACE (EN)

Dear Customer!

This manual contains information and important notes for safe commissioning and handling of the wood band saw HBS610_230V and HBS610_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

Customer service contact

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12 SAFETY

This section contains information and important notes on the safe commissioning and handling of the machine.

For your safety, read this manual carefully before commissioning. This will enable you to handle the machine safely and thus prevent misunderstandings as well as personal injury and damage to property. Pay special attention to the symbols and pictograms used on the machine as well as the safety information and danger warnings!

12.1 Intended use of the machine

The machine is designed exclusively for the following activities:

Sawing wood, wood composites or materials with similar physical properties to wood, within the prescribed technical 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 designed for the work under the following conditions:

Relative humidity	max. 70 %
Temperature (operation)	+5 °C to +50 °C
Temperature (storage, transport)	-25 °C to +55 °C

12.1.2 Prohibited applications /Dangerous misuse

- Operating the machine outdoors.
- Operating the machine without adequate physical and mental 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
- Operating the machine outside the specified ambient conditions
- Operating the machine in closed rooms without chip and dust extraction device (a normal household vacuum cleaner is not suitable as an extraction device).
- Remove the safety markings attached to the machine.
- Modify, circumvent or disable the safety devices of the machine.
- Machining of materials with dimensions outside the limits specified in this manual.
- Cleaning the machine with water, neither with the power switched on nor with the power switched off.

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

12.2 User requirements

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

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

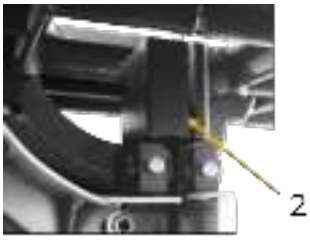
Please note that locally applicable laws and regulations determine the minimum age of the operator and may restrict the use of this machine!

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

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

12.3 Safety devices

The machine is equipped with the following safety devices:

	• Adjustable saw band guard (1)
	• Saw band cover on the lower side of the worktable (2)
	• Door safety switch: one safety switch each on the inside of the the upper and lower flywheel cover.
	• Push stick: For cutting operations where less than 120mm is cut, i.e. less than 120mm distance to the right of the saw band 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 impairments when working with the machine, the following points must be observed in addition to the general rules for safe working:

- Check the machine for completeness and function before starting. Only use the machine if the separating and other non-separating protective devices required for machining have are fitted.
- Make sure that the guards are in good working order and properly maintained.
- Select a level, vibration-free surface as the installation area.
- Anchor the machine to the ground to prevent it from lifting off or falling over when cutting.
- Ensure sufficient space around the machine.
- Ensure sufficient lighting conditions at the workplace to avoid stroboscopic effects.
- Ensure a clean working environment.
- Keep the area around the machine free of obstacles (e.g. dust, chips, cut-off workpiece parts, etc.).
- Only use tools that are in perfect condition and free of cracks and other defects (e.g. deformations).
- Remove tool keys and other setting tools before switching on the machine.

- Check the machine's connections for strength before each use.
- Never leave the running machine unattended. Switch off the machine before leaving the working area and secure it against unintentional or unauthorized restarting.
- The machine may only be operated, maintained or repaired by persons who are familiar and who have been informed about the dangers arising from this work.
- Ensure that unauthorized persons keep a safety distance from the machine and keep children away from the machine.
- Always work with care and the necessary caution and never use excessive force.
- Do not overload the machine.
- Hide long hair under hair protection.
- Wear close fitting protective work clothing and suitable protective equipment (eye protection, dust mask, ear protection, work gloves only when handling tools).
- Never wear loose jewellery, loose clothing or accessories (e.g. tie, scarf).
- Do not work on the machine if you are tired, not concentrated or under the influence of medication, alcohol or drugs!
- Connect the machine to a suitable dust collection system.
- Do not use the machine in areas where vapours of 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 adjustment, changeover, cleaning, maintenance or repair work, etc. Before starting work on the machine, wait until all tools or machine parts have come to a complete standstill and secure the machine against unintentional restart.

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 this machine

- Work with gloves on rotating parts is not permitted!
- During operation of the machine wood dust is generated. Therefore, connect the machine to a suitable dust collection system during installation!
- Always switch on the dust collection system before you start machining the workpiece!
- Never remove parts of the workpiece from the cutting area while the machine is running.
- Excessive noise can cause hearing damage and temporary or permanent hearing loss. Wear hearing protection certified to health and safety regulations to limit noise exposure.
- Only use sharpened tools.
- Make sure that the maximum speed indicated on the tools is not exceeded.
- Replace torn and deformed saw bands immediately, they cannot be repaired.
- Use a push stick for cutting operations!
- Never clean the saw band or the flywheels of the machine while running with a brush or scraper held in the hand.

12.7 Hazard warnings

12.7.1 Residual risks

Despite intended use, certain residual risk factors remain.

- Danger of cutting hands/fingers or other other parts due to sharp saw band.
- Risk of injury due to breakage or ejection of the saw band or parts thereof, especially in the event of overloading or incorrect running direction of the saw band.

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

12.7.2 Hazardous situations

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

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

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

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

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

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

13 TRANSPORT

Transport the machine in its packaging to the place of installation. To manoeuvre the machine in the packaging, a pallet truck or forklift truck with the appropriate lifting force (the fork must have a length of at least 1200 mm) 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.

WARNING
Risk of injury from suspended or unsecured load! Damaged or insufficiently strong hoists and load slings can result in serious injury or even death. → Before use, therefore, check hoists and load slings for adequate load-bearing capacity and perfect condition. Secure the loads carefully. Never stand under suspended loads!

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 selected installation site must ensure a suitable connection to the power supply, as well as (e.g.:) connection to an extraction system. Observe the safety requirements and the dimensions of the machine.

Place the machine on a level, solid surface. 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. In the case of long workpieces, no crushing or shearing points may occur in the extension area (=danger area).

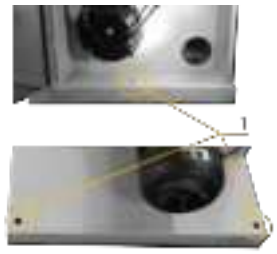
WARNING

Danger of tipping over!
Unanchored machine can tip over and cause injuries.
→ Anchor the machine in the ground before commissioning!

The base of the machine has fixing holes by means of which the machine is firmly connected to the floor. This prevents movement of the machine during operation and possible damage or injury.

NOTE

Required mounting material is not included in the scope of delivery.



Anchoring to the ground

- Anchor both sides of the machine (1) to the floor of the installation site using appropriate fixing bolts.

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

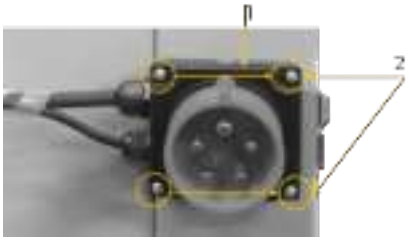
The use of paint thinners, petro, aggressive chemicals or scouring agents will damage the surfaces!
Therefore: Use only mild cleaning agents!

14.2 Assemble

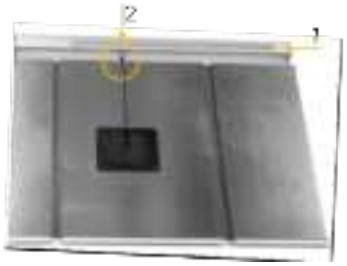
NOTE

The machine and machine components are heavy!
2 persons are required to assemble the machine.

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



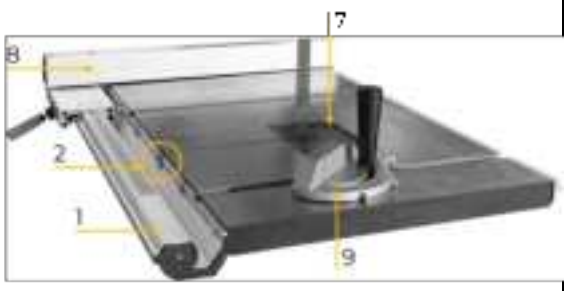
1. **Switch unit:**
   Fix the switch unit (1) to the machine frame using the 4 screw (2) supplied.



2. **Work table:**
   Remove the rip fence guide with scale (1) and the slot pin (2).

- Lift the cast iron table (3) into the mounting position with the aid of a second person or a technical lifting device, thread the work table (3) through the saw band (4) and position the fixing screw in the swivel device.

- Fasten the worktable (3) to the swivel device (6) using the fastening screw and nut (5).



- Insert the table inlay (7).

NOTE

Check that the table inlay is at the same height as the machine table.

- Mount the rip fence guide (1) on the worktable using the 6 screws and reattach the slot pin (2).
- Assemble the rip-fence (8) and, if necessary, the mitre gauge (9).

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 ±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). If a CEE plug is available, the connection to the mains is made through an appropriately powered CEE coupling (L1, L2, L3, N and PE).

Plug connection 400V:	5-wire: **with** N-conductor	
	4-wire: **without** N-conductor	

- After the electrical connection, check the correct running direction. If the machine runs in the wrong direction, swap two conductive phases, egg. 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.

15 OPERATION

15.1 Operating instructions

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 carrying out any modification or adjustment work and secure it against unintentional reconnection.

CAUTION

- Never start the machine with a workpiece pressed down!
- Long workpieces must be supported
- Property damage and injury by bouncing up the workpiece or tilting of the machine possible!

15.1.1 Before you start working

- Check the workpiece for foreign objects, cracks and loose knots.
- Use only sharp, crack-free and sufficiently set saw bands.
- Check that the saw band on the flywheel is correctly tensioned and aligned.
- Check the saw band guide for correct adjustment.
- Adjust the height-adjustable guard to the height of the workpiece.
- Have any necessary aids (e.g.: rip fence, push stick, etc.) ready.
- If gloves are required for workpiece handling, they must be finger-free.

15.1.2 During work

- Move the adjustable guard for the saw band as close as possible to the workpiece.
- When feeding the workpiece, do not place your hands on the workpiece in the area of the cutting plane.
- Feed the workpiece at a constant speed and constant pressure.
- Use aids for safe workpiece guidance:
  - When cutting workpieces standing on edge, secure them against tilting (e.g. by means of contact angle, rip fence, sliding shutter).
  - Secure round workpieces against twisting with a wedge support.
  - When cutting round discs, use a circular cutting device.
  - For long or wide workpieces, ensure good workpiece support (e.g. by widening or lengthening the table).
- Never remove splinters or chips by hand while the saw band is running.

WARNING

In the case of a broken saw band or V-belt, the flywheels may continue to run. It is necessary to wait for the machine to come to a complete stop before opening the separating protective device.

15.1.3 After work

- Switch machine off, wait for standstill.
- Remove wood chips and splinters from cutting area and table insert.
- Lower the saw band guard onto the machine table.
- To protect the running surfaces of the wheels, remove the band saw band tension and attach a warning sign to the machine reminding you that the saw band tension must be reset before the next use.

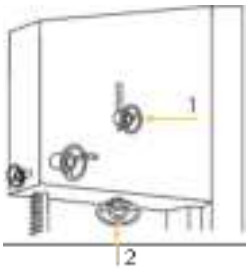
15.2 Settings

In order to ensure the desired precision of the machine, certain basic settings must be made before commissioning, which are described below.

15.2.1 Adjusting saw band tensioning

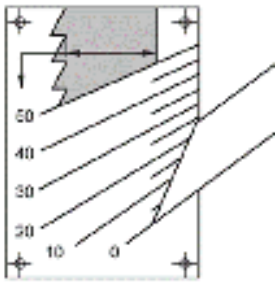
CAUTION

If the tension is too high, the saw band may tear - risk of injury! If the tension is too low, the driven flywheel may spin and the band saw band may stop. Therefore check the saw band tension before each start-up!



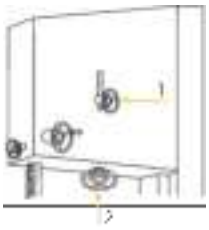
Procedure:

- Loosen the clamping of setting wheel - saw band run (1).
- Adjust the tensioning of the saw band using the handwheel – saw band tensioning (2).



- The correct tension value is indicated on the tension scale inside the upper door, the indicated value corresponds to the width of the blade (the saw band tension is correct if you press against it with your finger laterally in the centre of the saw band and the saw band yields by a max. of 1 to 2 mm).
- Check with a few manual turns that tracking of the sawband is correct (the saw band should be in the middle of each flywheel). If necessary readjust by means of the setting wheel - saw band run (1).
- Fix the clamping of setting wheel - saw band run (1).

15.2.2 Adjusting saw band tracking

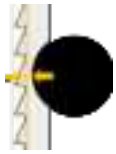


If the saw band tracking does not run properly (centred), the saw band tracking must be readjusted. Clamping - saw band tracking (1) must be loosened and with the setting wheel - saw band tracking (1) the upper wheel must be tilted either forwards or backwards, then the tracking must be checked again. This procedure may have to be repeated several times to ensure correct running. After the tracking is adjusted correct fix the clamping of setting wheel - saw band tracking (1).

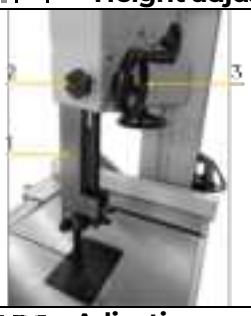
15.2.3 Adjusting the saw band guide

NOTE

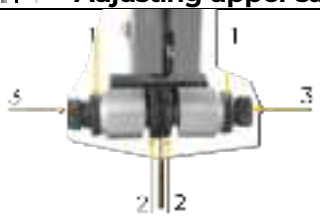
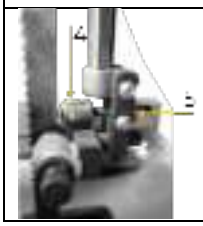
Adjust the saw band guide only after the saw band tension and the tracking of the saw band have been adjusted and checked. Correct adjustment of the saw band guide is important. The saw band becomes unusable if the teeth touch the guides while the saw band is running.

	Adjust the rear guide roller so that it sits just behind the saw band. The saw band should not touch the guide roller when not under load (when not sawing). The rear guide roller should support the saw band and prevent the saw band from being pushed backwards by the workpiece being fed too far.
	Place the two lateral guide bolts as close as possible to the saw band. They should only support the saw band when it is loaded laterally.
	When adjusting the saw blade guide, the side guides must be brought just up to the tooth base of the saw band.

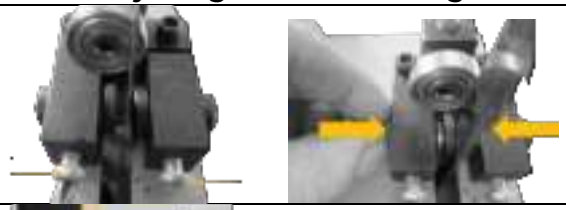
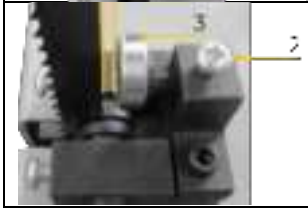
15.7.4 Height adjusting saw band guard

	1. Always lower the saw band guard (1) with the upper saw band guide as close as possible (5 - 10 mm) to the workpiece. 2. To adjust the height, open the clamping screw (2) and turn the handwheel (3) until the desired height is reached. 3. Tighten the clamping screw (2) again afterwards.

15.7.5 Adjusting upper saw band guide

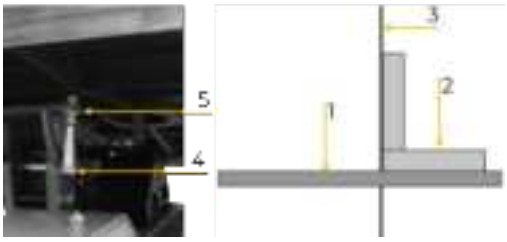
	• To adjust, loosen the clamping nuts (1) and bring the guide rollers (2) to the saw band by turning the screws (3). • Then retighten the clamping nuts.
	• To adjust, loosen the clamping screw (5) and position the rear guide roller (4) to the saw band back. • Then tighten the clamping screw again.

15.7.6 Adjusting lower saw band guide

	• Slightly loosen the screws (1) on the left and right saw band guidance bar • Push the guide rollers on both sides against the saw band and screw them tight
	• Unscrew the screw (2) for the rear saw band guide. • Push the guide (3) to the saw band and fasten it.

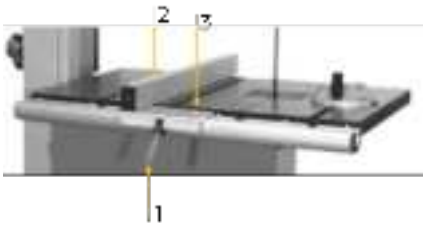
15.2.7 Tilting the table

1. Open the clamping screw (1)
2. Swivel the worktable (2) to the desired position using the angle scale (3).
3. Tighten the clamping screw (1) again.



Setting 0° exactly:
Check the setting with a square (2) to the saw blade (3) placed on the work table (1). If necessary, correct the setting of the table and also realign the pointer of the scale. If the table has an exact angle of 90° with the saw blade, unscrew the adjusting screw (4) until it contacts the table. Lock it with the nut (5).

15.2.8 Adjusting rip fence



1. Loosen the eccentric lever (1).
2. Set the rip fence (2) to the desired position using the scale (3).
3. Tighten the eccentric lever to fix the rip fence in position.

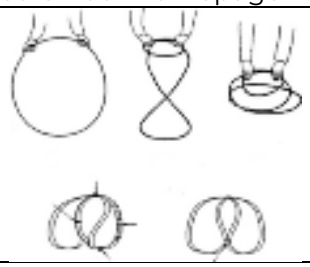
15.3 Handling

15.3.1 Selection of saw bands

NOTE

Always wear gloves when handling saw bands. Handle the saw bands carefully to prevent damage. Unused, untensioned saw bands should be folded and stored securely in a (child-)safe, dry place. Always check saw bands for damaged teeth and cracks before use!

Select the saw band according to the material to be cut. Narrow saw bands are suitable for curved and circular cuts, wide saw bands for straight cuts. For hard wood you need finer toothed saw bands, for soft wood you should use coarser toothed saw bands. Or use the basic information saw bands provided on our homepage – category service/news/downloads.



Correct winding of saw bands

Saw band transport device

15.3.7 Switch the machine on and off

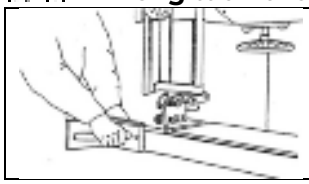
Switch on
Push green ON-button (I)
Switch off
Push red OFF-button (0)

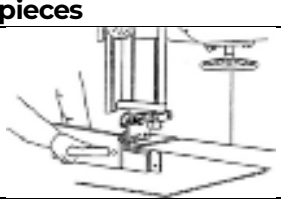
15.4 Working techniques

CAUTION

When cross-cutting a round or irregularly shaped workpiece, it is necessary to secure the workpiece with a suitable template or holding device and to use a suitable saw band (for cross section)!

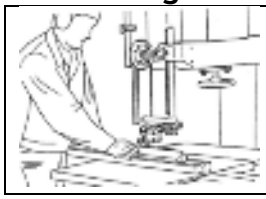
15.4.1 Longitudinal cutting of narrow (thin) workpieces

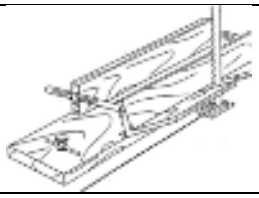




Longitudinal cutting is sawing parallel to the wood fibre. For rectangular cuts (table at right angles to the saw band), place the rip fence to the left of the saw band to guide the workpiece safely along the fence with your right hand. For longitudinal mitre cuts with an inclined table, attach the parallel stop to the right of the saw band on the downward side (if the width of the workpiece permits this) in order to secure the workpiece against slipping.
Use a sliding stick to prevent the hands from being too close to the saw band!

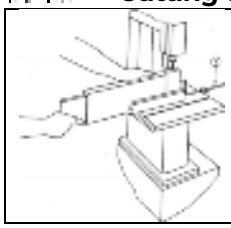
15.4.2 Diagonal cut





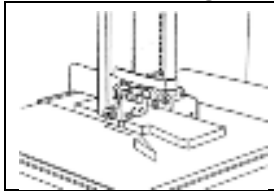
For diagonal cuts, use auxiliary devices as shown in the illustrations above.

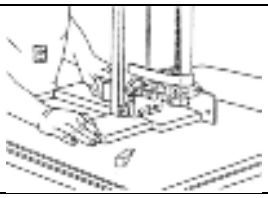
15.4.3 Cutting tenons



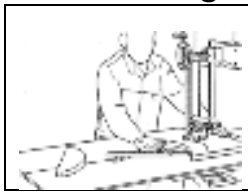
1. Stop, fixed to the table

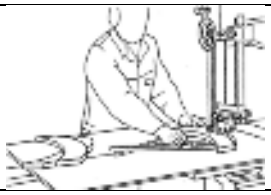
15.4.4 Cutting wedges





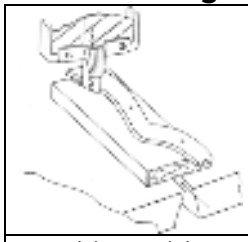
15.4.5 Cutting curves

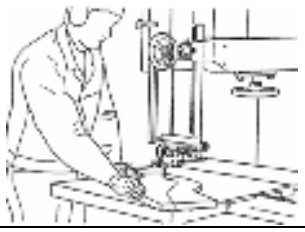




When cutting curves, pay particular attention to the width of the saw band. Choose a narrow saw band with which you can cut even the smallest radii in your workpiece. Work at a low feed rate so that you do not push the workpiece sideways out of the cutting line.

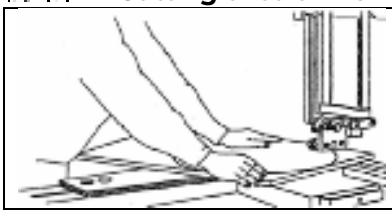
15.4.6 Cutting with a template, handling shaped work



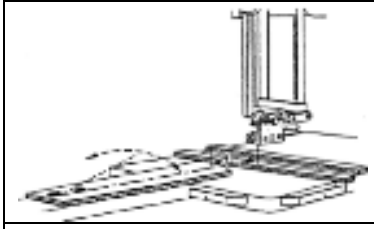
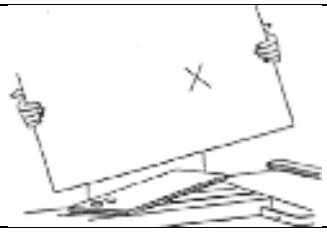


Working with a template	Correct handling of moulded parts

15.4.7 Cutting circular work

	• To cut round slices, use a circular cutting device as shown in the illustrations on the left and below!

15.4.8 Fixtures

	
Fixture without workpiece	Operator placing workpiece fixture

16 CLEANING, MAINTENANCE, STORAGE, DISPOSAL

WARNING

Danger due to electrical voltage!
Handling the machine with connected power supply may result in serious injury or death.
→ Always disconnect the machine from the power supply before maintenance or repair work and secure it against unintentional reconnection.

16.1 Cleaning

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

NOTE

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

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

16.2 Maintenance

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

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

16.2.1 Maintenance plan

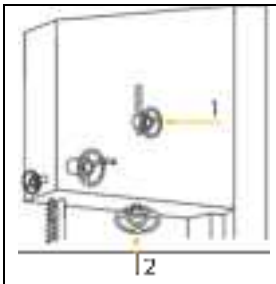
The type and degree of machine wear depends to a large extent on the operating conditions. The following intervals apply when the machine is used within the technical limits:

Intervall	Components	Action
before usage	• machine	• cleaning (from dust and chips)
	• flywheel housing	• cleaning (from dust and chips)
once a week	• moving parts	• control, lubrication
monthly	• V-belt	• check retighten or replace if necessary
on demand	• rubber bandage, chip brushes	• replace

16.3 Changing/tensioning the saw band

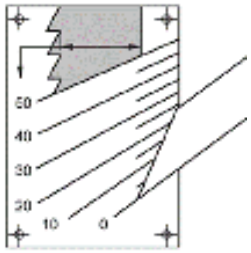
CAUTION

If the tension is too high, the saw band may tear - risk of injury! If the tension is too low, the driven fly wheel may spin and the saw band may stop. Therefore check the saw band tension before each start-up!



Procedure:

- Disconnect machine from the power supply
- Remove table inlay and slot pin
- Remove rip fence guide
- Open the flywheel covers
- Loosen the clamping of setting wheel - saw band run (1)
- Reduce the tensioning of the saw band using the handwheel – saw band tensioning (2)
- Unthread the old saw band through the work table
- Thread in a new saw band and place it over the two wheels. (Observe cutting direction: The teeth must point downwards in the cutting direction.)



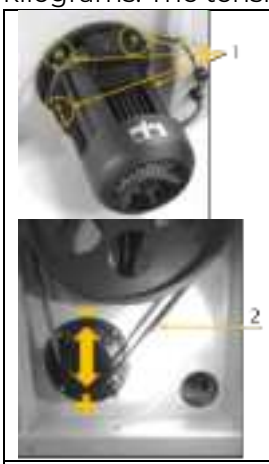
- Adjust the tensioning of the saw band using the handwheel – saw band tensioning (2)
- The correct tension value is indicated on the tension scale inside the upper door, the indicated value corresponds to the width of the blade (the saw band tension is correct if you press against it with your finger laterally in the centre of the saw band and the saw band yields by a max. of 1 to 2 mm)
- Check with a few manual turns that tracking of the sawband is correct (the saw band should be in the middle of each flywheel). If necessary readjust by means of the setting wheel - saw band run (1)
- Fix the clamping of setting wheel - saw band run (1)
- Close flywheel covers, mount stop guide and reattach table insert and slot pin
- Adjust saw band guide

16.4 Checking/adjusting/replacing the V-belt

NOTE

Always keep the V-belt correctly tensioned. A V-belt that is too loose weakens the power transmission (drive and braking effect), too much tension leads to excessive stress on the V-belt (heating).

To check/adjust or replace the belt, open the lower flywheel cover.
To control the belt tension, press inwards at the centre of the belt with a force of three to four kilograms. The tension is OK if the belt does not yield by more than five to six millimetres.



Increase belt tension:
Loosen nuts (1) and unscrew slightly. The motor (motor mounting plate) can now be shifted in the direction (+) of more belt tension.
When correct tension is reached. Tighten the nuts (1) firmly again.

Decrease belt-tension:
Loosen nuts (1) and unscrew slightly. The motor (motor mounting plate) can now be shifted in the direction (-) of less belt tension.
When correct tension is reached. Tighten the nuts (1) firmly again.

For changing the V-belt, remove saw band, completely de-tension the belt (2) and pull it over the pulley and insert new belt. Then establish correct belt tension again. Re-insert and tension the saw band. After completion close the lower flywheel cover.

16.5 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 components. Only store packed or already unpacked parts under the intended ambient conditions!

16.6 Disposal

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

17 TROUBLESHOOTING

WARNING

Danger due to electrical voltage!
Handling the machine with connected power supply may result in serious injury or death.
→ Always disconnect the machine from the power supply before maintenance or repair work and secure it against unintentional reconnection.

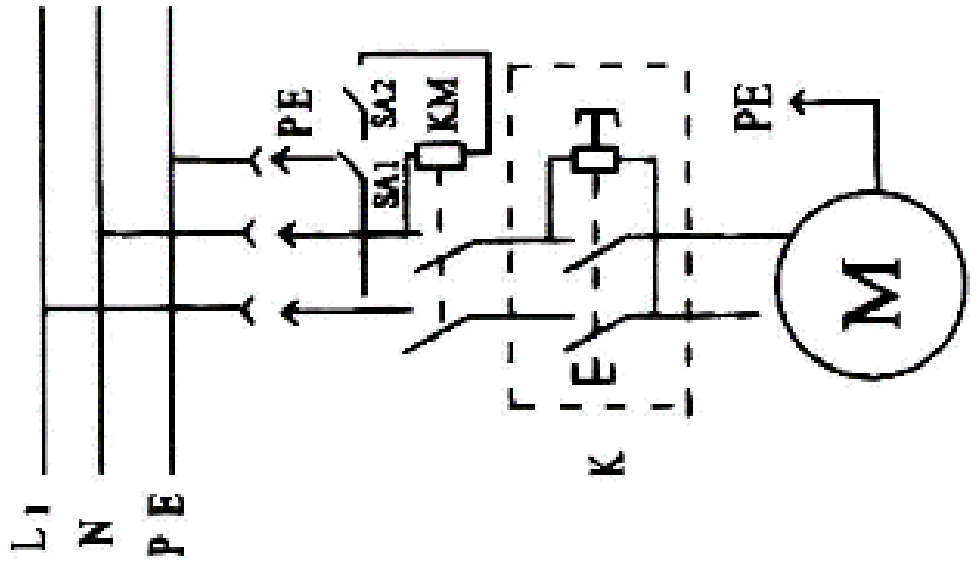
Many possible sources of error can be eliminated in advance if the machine is properly connected to the power supply. If you are unable to carry out the necessary repairs properly and/or do not have the required training, always consult a specialist to solve the problem.

Trouble	Possible cause	Solution
Machine does not run	• ON-OFF switch defective	• Repair/replace switch
	• Fuse defective	• Replace fuse
	• Motor defective	• Repair/replace motor
	• Power cord damaged	• Replace power cord
	• Thermo protection activated	• Let cool down the motor
Machine does not make exact 45° or 90° cuts	• Stop not exactly adjusted	• Remeasure and set the stop correctly
	• Angle inaccurately adjusted	• Readjust the angle
	• Mitre fence inaccurately applied	• Readjust mitre fence
Saw band moves while cutting	• Stop is not aligned	• Check the stop and readjust it
	• Unevenly thick wood	• If possible, select a different blank size
	• Feed rate too high	• Reduce feed rate
	• Wrong saw band	• Replace saw band
	• Saw band tension irregular	• Adjust the saw band tension according to the saw band size, see above
	• Saw band guide incorrectly adjusted	• Readjust saw band guide
	• Work table incorrectly mounted	• Set up or assemble the work table
Unsatisfactory cuts	• Blunt saw band	• Sharpen or change the saw band
	• Saw band incorrectly mounted	• Teeth must look in cutting direction
	• Wrong saw band	• Check whether the width or tooth pitch of the saw band corresponds to your work
	• Work table is resinous	• Clean the work table with a suitable detergent
Machine doesn't "get up to speed"	• Extension cable with too small cable cross-section or too long	• Use an adequate extension cable
	• Mechanical running problem of the saw band	• Check the running of the saw band for ease of movement
Machine vibrates unnaturally strong	• Uneven ground	• Realign on level surface
	• Worn V-belts, bad pulley	• Replace V-belt, pulley
	• Motor not fixed properly	• Tighten the screws securing the motor

18 ELEKTRISCHER SCHALTPLAN / WIRING DIAGRAM

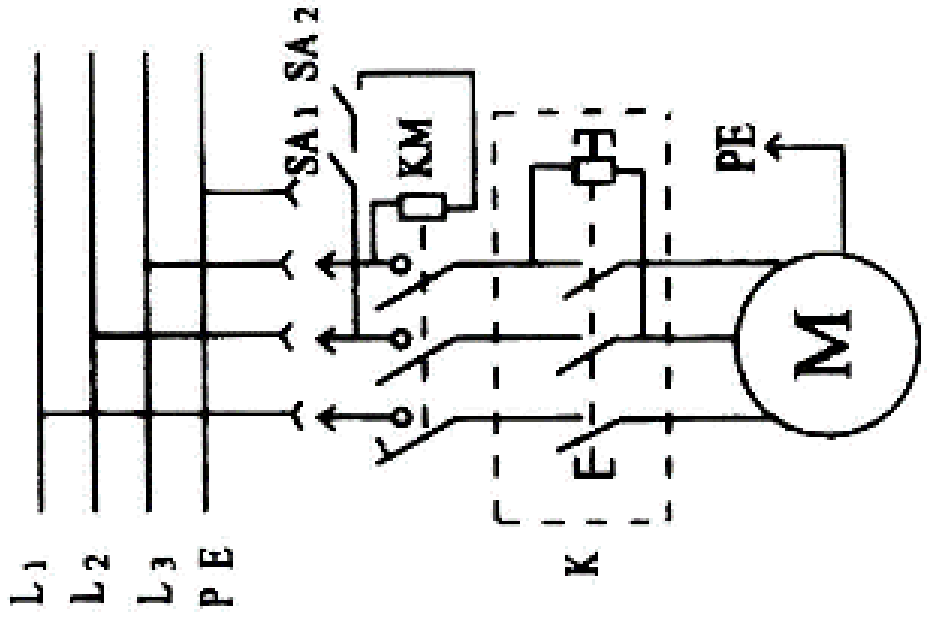
18.1 HBS610_230V

Schaltplan, einphasig, mit Kontaktschalter / Wiring Diagram, single phase, with contactor



18.2 HBS610_400V

Schaltplan, dreiphasig, mit Kontaktschalter / Wiring Diagram, three phase, with contactor



19 ERSATZTEILE / SPARE PARTS

19.1 Ersatzteilbestellung / Spare parts order

(DE) Mit HOLZMANN-Ersatzteilen verwenden Sie Ersatzteile, die ideal aufeinander abgestimmt sind. Die optimale Passgenauigkeit der Teile verkürzen die Einbauzeiten und erhöhen die Lebensdauer.

HINWEIS	
	Der Einbau von anderen als Originalersatzteilen führt zum Verlust der Garantie! Daher gilt: Beim Tausch von Komponenten/Teile nur vom Hersteller empfohlene Ersatzteile verwenden.

Bestellen Sie die Ersatzteile direkt auf unserer Homepage – Kategorie ERSATZTEILE.

oder kontaktieren Sie unseren Kundendienst

- über unsere Homepage – Kategorie SERVICE – 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.

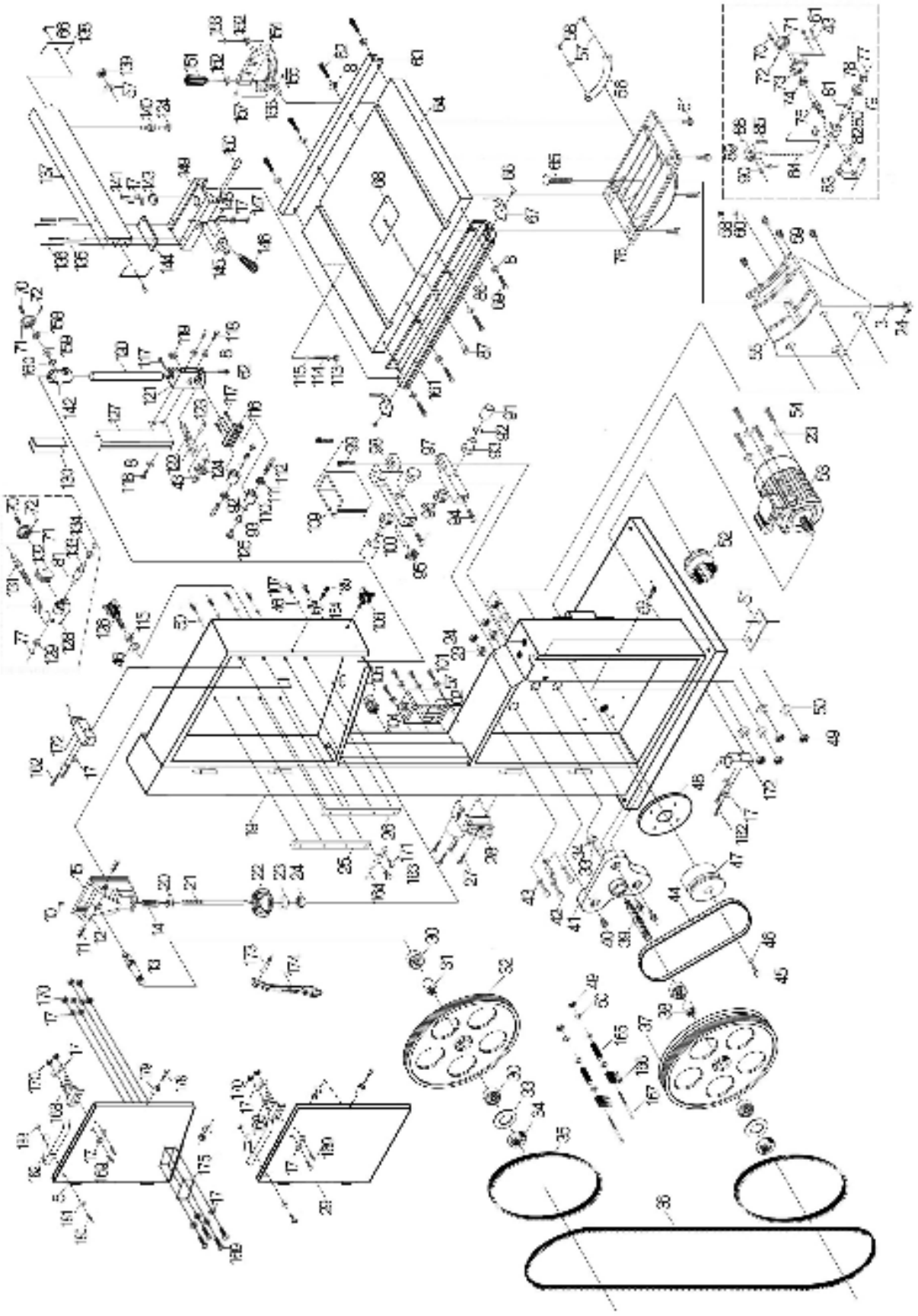
NOTE	
	The installation of parts other than original spare parts leads to the loss of the guarantee! Therefore: When replacing components/parts, only use spare parts recommended by the manufacturer.

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.

19.2 Explosionszeichnung / Exploded view



19.3 Ersatzteilliste / Spare part list

No.	Description	Qty.	No.	Description	Qty.
5	Upper door	1	**99**	Cap screw M6x40	2
10	Pin 5x25	1	**100**	Eccentric bearing shaft	1
11	Adjusting shaft	2	**101**	Phillips head screw M5x10	4
12	Upper wheel shaft base	1	**102**	Contactor	1
13	Upper wheel shaft	1	**103**	Phillips head screw M4x30	4
14	Spring	1	**104**	Contactor box	1
15	Upper wheel adjusting base	1	**105**	Retainer M20x15	5
19	Saw body	1	**106**	Locking knob	1
20	Nut	1	**107**	Hex bolt M8x12	2
21	Adjusting thread bar	1	**108**	Hex bolt M10x25	10
22	Handwheel	1	**109**	Lower protection guard	1
23	Washer 12	5	**110**	Blade guide base	2
24	Hex nut M12	5	**111**	Nut	2
25	Left adjusting base	1	**112**	Adjusting shaft	2
26	Right adjusting base	1	**113**	Rubber plate	1
27	Phillips head screw M4x60	4	**114**	Hex bolt M8x25	1
28	Switch	1	**115**	Hex nut M8	2
29	Lower door	1	**116**	Blade guide support	1
30	Bearing 80206	4	**117**	Cap screw M8x12	2
31	Upper wheel shaft bush	1	**118**	Phillips head screw M6x10	2
32	Upper wheel	1	**119**	Locking nut	1
33	Washer 24	3	**120**	Guide bar	1
34	Hex nut M24	3	**121**	Guide bar bracket	1
35	Rubber belt	2	**122**	U-shaped bracket	1
36	Saw band	1	**123**	Shaft	1
37	Lower wheel	1	**124**	Bearing 80027	2
38	Lower wheel shaft bush	1	**125**	Upper Guide wheel	2
39	Lower wheel shaft	1	**126**	Adjusting handle	1
40	Adjusting screw	3	**127**	Protection guard	1
41	Lower wheel support	1	**128**	Guide base	1
42	Hex bolt M8x20	4	**129**	Gear bush	1
43	Washer 8	8	**130**	Sliding plate	1
44	V-belt	2	**131**	Worm	1
45	Hex bolt M8x30	1	**132**	Gear	1
46	Washer 8	1	**133**	Gear shaft	1
47	Motor pulley	1	**134**	bush	1
48	Motor mounting plate	1	**135**	Bush	4
49	Hex nut M10	4	**136**	Cap screw M6x65	4
50	Washer 10	4	**137**	Upper guide plate	1
51	Plate	1	**138**	Upper guide plate insert	2
52	Dust chute	1	**139**	Hex nut M5	1
53	Motor	1	**140**	Bearing bar	1
54	Hex bolt M12x35	4	**141**	Phillips head screw M4x5	1
55	Inclination support	1	**142**	Guide bar base	1
56	Scale plate	1	**143**	Pointer with magnifier	1
57	Washer 5	8	**144**	Plate	1
58	Phillips head screw M5x6	3	**145**	Locking block	1
59	Adjusting screw	4	**146**	Locking handle	1
60	Pointer	1	**147**	Phillips screw M4x8	1

61	Cap screw M8x25	4	**148**	U clamp	1
62	Cap screw M6x12	5	**149**	Sliding base	1
63	Back rail	1	**150**	Shaft	1
64	Working table	1	**151**	Handle	1
65	Flange bolt	1	**152**	Washer 6	2
66	Phillips head tap screw 3x10	4	**153**	Phillips head screw M6x6	1
67	Side clamp plate	2	**154**	Scale for mitre gauge	1
68	Table insert	1	**155**	Cap screw M4x6	1
69	Hex bolt M8x16	4	**156**	Slide plate	1
70	Handle	2	**157**	Round pointer	1
71	Handwheel	2	**158**	Bearing	1
72	Cap screw M6x10	2	**159**	Gear	1
73	Plate	1	**160**	Washer	1
74	Bearing 101	3	**161**	Scale for front guiding rail	1
75	Worm	1	**162**	Phillips head screw M4x30	4
76	Table support	1	**163**	Bolt	1
77	C' ring 10	4	**164**	Pointer	1
78	Plate	1	**165**	Brush sleeve	2
79	Gear	1	**166**	Brush	2
80	Gear shaft	1	**167**	Carriage bolt M8	2
81	Pin 4x12	2	**168**	Jiggle plug	2
82	Gear box	1	**169**	Screw M4x12	4
83	Gear	1	**170**	Nut M4	4
84	Rack	1	**171**	Screw M6x12	2
85	Cap screw M6x16	2	**172**	Safety switch	2
86	Front guiding rail	1	**173**	Screw	1
87	Pin	1	**174**	Push stick	1
88	Pin 2x12	1	**175**	Perspective version	1
89	Sipport	4	**176**	Window for indication	1
90	Shaft	1	**178**	Knob sleeve	2
91	Lower guide shaft	2	**179**	Knob screw	2
92	C' ring 10	4	**180**	Screw	2
93	Lower guide copper bush	4	**181**	Washer	2
94	Phillips head screw M6x12	3	**182**	Door lock	2
95	Bearing 80101	1	**183**	Nut	2
96	Lower guide wheel	2	**184**	Knob	2
97	Lower guide base	1	**185**	Knob axis	2
98	Lower guide base	1			

20 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.