

# MANN®

# HOLZ

# MASCHINEN

DE Bedienungsanleitung Universalfräsmaschine  
EN User Manual Heavy duty milling machine



## BF 1000D DRO

### Universalfräsmaschine Heavy duty milling machine

*Bedienungsanleitung und  
Sicherheitshinweise lesen  
und beachten!*

*Read the operation manual  
carefully before first use!*



*Technische Änderungen  
sowie Druck- und Satz-  
fehler vorbehalten!*

*Technical data subject to  
changes, errors excepted!*

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## 1 Attention

### 1.1 Inspection And Acceptance

Please check carefully when open the package and make sure no parts are missing.

### 1.2 Safety

Please read the operation manual carefully before the installation and adjustment of the machine, when finish the installation, check all the details and trial run the machine carefully before put it into operation.

### 1.3 Caution

Keep in mind the safety measures for electrical and operating protection.

## 2. Work Environment

2.1 The elevation of workshop has to be 2000m or less.

2.2 No conductive dust allowed.

2.3 No explosive factor allowed.

2.4 No corrosive gas or steam which may corrode metal or damage the insulation.

2.5 Keep away from the source of impact or vibration.

## 3. Operation Instruction

3.1 Before starting the machine, read carefully the operation manual and be fully acquainted with all the details.

3.2 The operator should be familiar with all the rules and points of attention of running and maintaining the machine.

3.3 Remove all the anti-rust coating or grease from the machine. Fill the machine with lubricant. Run the machine from low to high speed and check if it is normal.

3.4 There's a reliable ground protection, the ground wire must be connected properly before it in operation.

#### 4. Lubrication

Lubricate the sliding and rotating part before trial run.

Pour NO.40 machine oil into the Gear Box and the Power Feed. Till indicating through the oil level indicators then do a overall check.

Keep oil level above the mark.

## WARNING

1. Read and understand the entire instruction manual before operating machine.
2. Always Wear approved safety glasses/face shields while using this machine.
3. Make certain the machine is properly grounded.
4. Before operating the machine, remove tie, rings, watches, other jewelry, and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. DO NOT wear gloves.
5. Keep the floor around the machine clean and free of scrap material, oil and grease.
6. Keep machine guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
7. Do NOT over reach. Maintain a balanced stance at all times so that you do not fall or lean against blades or other moving parts.
8. Make all machine adjustments or maintenance with the machine unplugged from the power source.
9. Use the right tool, Don't force a tool or attachment to do a job which it was not designed for.
10. Make certain the motor switch is in the OFF position before connecting the machine to the power supply.
11. Keep visitors a safe distance from the work area.
12. Never attempt any operation or adjustment if the procedure is not understood.
13. Keep fingers away from revolving parts and cutting tools while in operation.
14. Do not attempt to adjust or remove tools during operation.
15. Always keep cutters sharp.
16. Failure to comply with all of these warnings may cause serious injury.

## I USAGE

The machine is used for cutting metals. It's suitable to mill, drill and widely use in the field of instrument, machining for cutting a single part or a batch of parts.

## II USE AND MAINTENANCE

(Refer Fig. 1)

1. The user must read the operation manual carefully, know structure and ability of every handle, the system of transmission and lubrication well.
2. Before operating, inspect the normal conditions of the column lock handle, the spindle sleeve and electric equipments. The ground line must be connect in the ground.
3. Switch on power of machine, check out flexibility and reliability of each electrical switch. Button 1、2、3 for vertical spindle turning clockwise or anticlockwise and stop. Button 4 is rising button of rising and falling platform; 5 is falling button; the rising and falling of rising and falling platform is also controlled by switch 14. Button 6 are Longitudinal, cross feed and feed stop selection switches. The selection of Longitudinal or cross feed is also controlled by handle 11. Cooling pump switch 7 for switching on or off motor of cooling pump. Button 8 for horizontal spindle turning clockwise or anticlockwise and stop. Emergency cut-off button 9 stops machine completely; when accident occurs and emergency cut-off is needed, please use this button.
4. When the position of spindle box to the working table need to be adjusted, first loosen handle 24. if hand-operated, turn handle 13 only. Will shake to bring to dismantle immediately after moving, in order to prevent mistake the operation is mobile but dangerous, dismantle to shake empers, put switch 14 on "close" condition. then press button 4 or 5 to adjust service platform to the position needed. if accaracy is needed, please also use handle 13, then lock handle 24. the machine can operate.

5. Table cross movement. First, loosen lock hand lever 12, If hand-operated feed, put handle 11 on "HAND" position, turn handle 22 to do it. If power feed, first, put handle 11 on "TRANSVERSE" condition. second, put handle 23 on  $\wedge\wedge$  condition, choose feed speed by using speed-change handle 21, then turn switch 6; if you want to stop feeding, just turn switch 6.

6. Table longitudinal movement. First, loosen lock hand lever 20. If hand-operated feed, put handle 11 on "HAND" position, turn handle 10 or 17 to do it. If power feed, first, put handle 11 on "LONGITUDINAL" condition. second, put handle 23 on  $\wedge\wedge$  condition, choose feed speed by using speed-change handle 21, turn switch 6; if you want to stop feeding, just turn switch 6.

**Notice: In order to improve rigidity of the machine, you must loosen "the lock apparatus" of ways which need to be moved and lock ways which do not need to be moved at the time!**

7. The Auto-Feeding and Manual-Feeding for spindle sleeve can be realized. For Auto-Feeding, please engage the safety clutch by handle 26, then engage the Tri-union sliding gear with three gears by Handle 25. Three different Feeding (0.08, 0.15, 0.25mm/r) can be gained by the spindle sleeve. Spindle sleeve is also with step block 27 and scale 28, etc, for automatic stopping and size-controlling properly.

The adjusting shaft 29 on Mill Head, Nut 30 stop-Block 27 are for pro-setting the size. For this, please posit the upper scale of the nut 30 the scale and tight the nut 31.

When auto-feeding, stop-Block 27 touch nut 30, they will press the clutch off, Feeding will be stopped. Safety clutch is with over-load protection, to avoid damaging the parts.

Manual-Feeding can be realized by Handle 32 when Handle 26 is off. (Fig.2)

Bar 34 is for Fixing Gauge.

Notice:

(1) Please tight the spindle sleeve by Handle(33) when spindle sleeve is free, pay attention that the force can't be too much.

(2) Auto-Feed is not allowed when the spindle speed is 1500 RPM or spindle reverse.

8. The cross-slide of spindle box can be realized through the ram moving, for cross sliding, please firstly loosen the two clamping bolts 15 locating on the right side of the ram, turn the gear shaft 18, to move the ram and spindle box and tight the two clamping bolts.

9. The spindle box can turn  $180^{\circ}$  around the column in the horizontal plane, to realize this, please firstly loosen the 4 pcs of clamping nuts 16 under the ram, turn the ram to the suitable position, finally tight the 4 pcs of clamping nuts.

10. The spindle's turn and revolve can be realized by turn the switch located in right side of hoist-descend sliding.

11. The Horizontal milling can be realized by turn the vertical spindle box  $90^{\circ}$ . The spindle box must be turn  $180^{\circ}$  when the Tool shaft and jack applied for assistance

12. The spindle box that transmitted by the belt can be swivled  $\pm 45^{\circ}$  in vertical plane, when operating, please loose the three retaining nut and pay attention these nutes need only 1 pitch, then swivle srew lever by socket headscrew wrench(S21-24) to make the spindle box swivle to the place required (clockwise turn the nut, the spindle box will counter clockwise turn, or otherwise).

13. If the machine doesn't work well or have irregular noise, please immediately shut off machine.

### III. MAJOR TECHNICAL PARAMETERS OF THE MACHINE

| ITEM |  |                           | PARAMETERS                                |      |      |
|------|--|---------------------------|---|------|------|
| 1    | Max. drilling diameter                         | Hand wheel control (iron) | 30mm                                      | 50mm | 50mm |
|      |  | Auto feeding (steel)      | 6mm                                       |      |      |
|      |  | Auto feeding (iron)       | 8mm                                       |      |      |
| 2    | Max. milling diameter                          |                           | 25mm                                      |      |      |
| 3    | Spindle taper                                  |                           | ISO 40                                    |      |      |
| 4    | Spindle speed numbers                          |                           | 8steps (vertical)<br>12steps (horizontal) |      |      |
| 5    | Spindle speed range (50HZ)                     |                           | 90-2000 RPM (V)<br>40-1300 RPM (H)        |      |      |
| 6    | Distance between spindle and surface of column |                           | 200-550mm                                 |      |      |
| 7    | Distance between spindle and table surface     |                           | 90-490mm                                  |      |      |
| 8    | Distance between the axis of spindle and table |                           | 0-400mm                                   |      |      |
| 9    | Spindle travel                                 |                           | 120mm                                     |      |      |
| 10   | Table size                                     |                           | 1370x320mm                                |      |      |
| 11   | Table travel                                   |                           | 990x300mm                                 |      |      |
| 12   | Motor power                                    |                           | 2.2kw(V), 2.2kw(H)                        |      |      |
| 13   | Net weight (approximate)                       |                           | 1700kgs                                   |      |      |

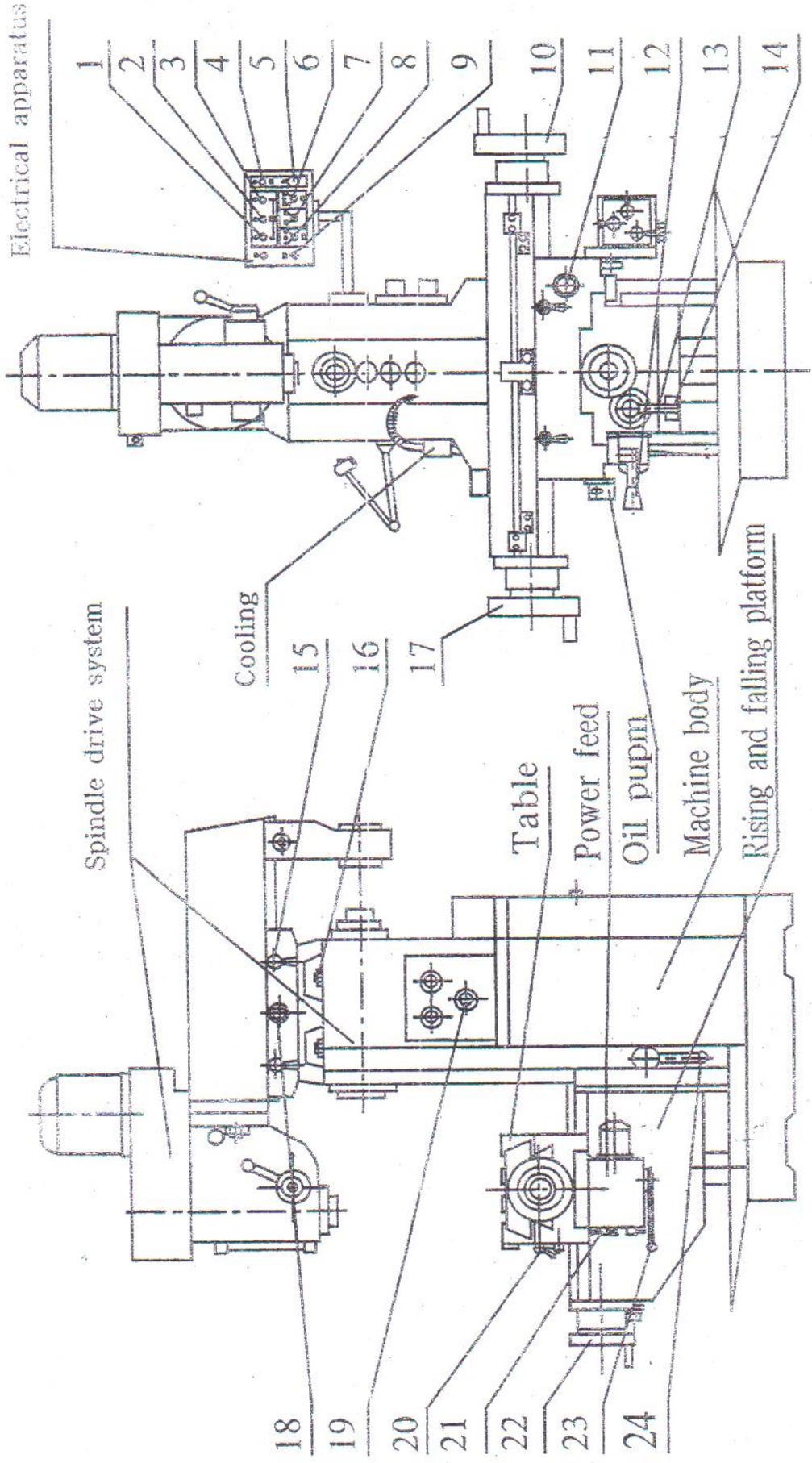


Fig.1

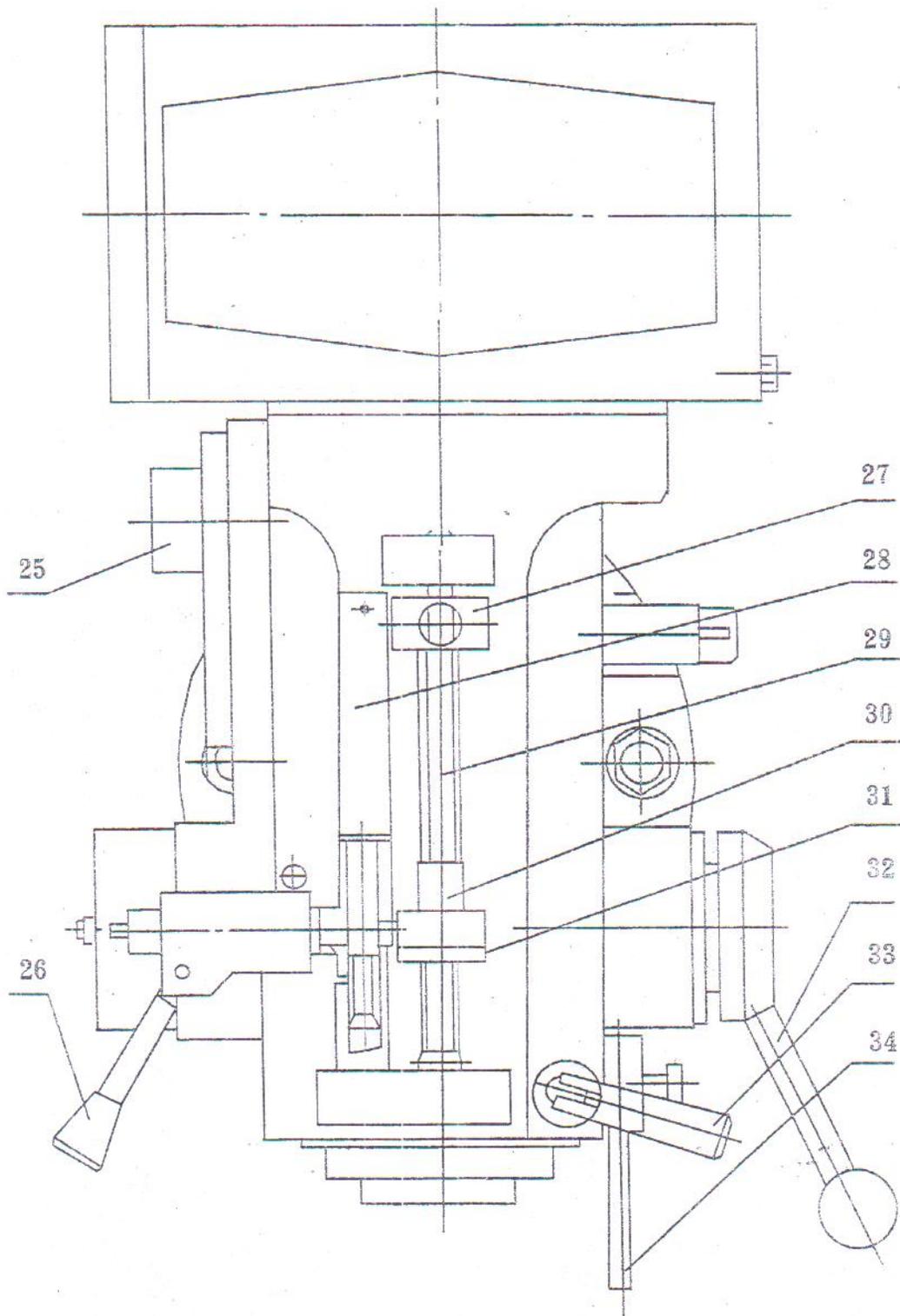


Fig.2

## IV THE SYSTEM OF TRANSMISSION AND CHANGED SPEED(Fig.1)

### 1.Transmission of power

The machine power is transmitted through gear on the shaft of motor and moving-gears to the gear of spindle.

2.vertical shaft: please cut the power firstly, then the three speed changing Handle. as per the indicating charging and speed board. 8 different speeds can be gained.

3.Horizontal shaft: when change speed, must cut off power, then change the handle 19 to the position ( I or II or III ;A or B;C or D).

## V LIST OF BEARINGS (Fig.3)

| NO | BEARING | MODEL    | QUTY | NO | BEARING | MODEL     | QUTY |
|----|---------|----------|------|----|---------|-----------|------|
| 1  | BEARING | 6205     | 1    | 18 | BEARING | 6307      | 1    |
| 2  | BEARING | 61908    | 1    | 19 | BEARING | 51109     | 1    |
| 3  | BEARING | 6204     | 1    | 20 | BEARING | 6005-2RZ  | 1    |
| 4  | BEARING | 16009    | 1    | 21 | BEARING | 7006AC    | 1    |
| 5  | BEARING | 6003     | 2    | 22 | BEARING | 6005      | 1    |
| 6  | BEARING | 7008AC   | 1    | 23 | BEARING | 51109     | 1    |
| 7  | BEARING | 6202     | 2    | 24 | BEARING | 7006AC    | 1    |
| 8  | BEARING | 51105    | 1    | 25 | BEARING | 7004AC    | 1    |
| 9  | BEARING | 32009/P6 | 1    | 26 | BEARING | 61906-2RS | 2    |
| 10 | BEARING | 61805    | 1    | 27 | BEARING | 60906     | 1    |
| 11 | BEARING | 6005-2RZ | 2    | 28 | BEARING | 6203      | 4    |
| 12 | BEARING | 7005AC   | 2    | 29 | BEARING | 6004      | 1    |
| 13 | BEARING | 7007AC   | 2    | 30 | BEARING | 7005AC    | 2    |
| 14 | BEARING | 6004     | 4    | 31 | BEARING | 60904-2RZ | 2    |
| 15 | BEARING | 32011/P6 | 1    | 32 | BEARING | 6004      | 1    |
| 16 | BEARING | 30308/P6 | 1    | 33 | BEARING | 6202      | 1    |
| 17 | BEARING | 6205     | 5    |    |         |           |      |

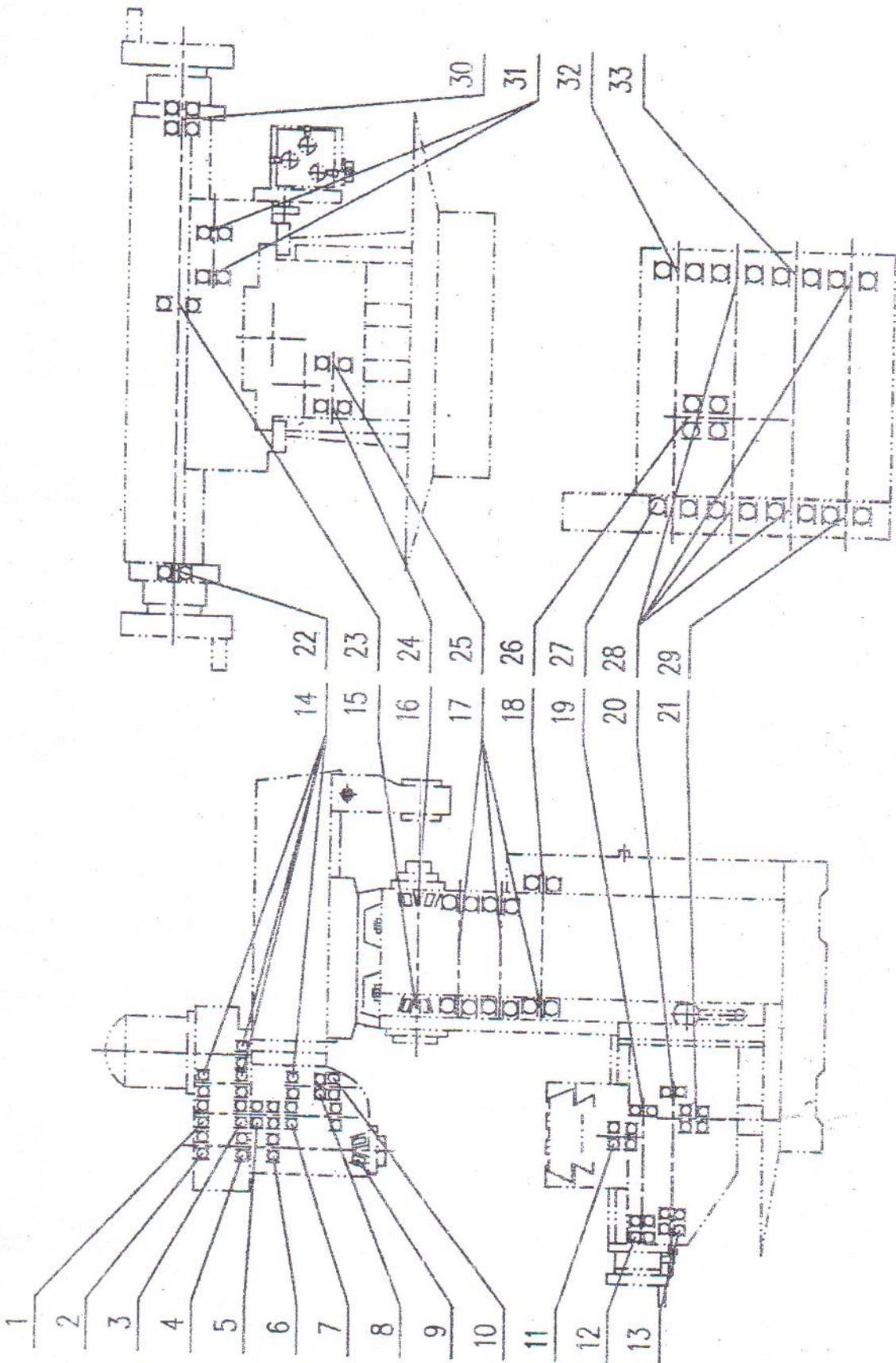


Fig. 3

## VI MACHINE LUBRICATING AND COOLING

### 1. Lubricating

To a great extent, life of machine depends on reasonable lubricating.

a. When the machine is used, user must comply with requirement of machine lubricating strictly to lubricate the machine. N46# lubricating-oil should be clean, No acidness and not contain water and hard particles.

b. Hand-operated oil pump installed on the left side of slide carriage supplies oil to deep, cross, vertical lead screw and ways. Every shift should supply oil no less than four times. User should often check oil supply line; when you find it is blocked, please repair it as soon as possible.

### 2. Cooling

Coolant is supplied to cooler of the machine by a cooling pump of which flow is 12L. Coolant is sent to nozzle through pipe. User should adjust the nozzle to spray coolant to cutting area exactly to cool cutting mill. Coolant is installed in the base of the machine.

## VII TRANSPORTATION, BOX-OPENING AND INSTALLATION

### 1. Transportation

When using crane to load and unload machine packing box, user must comply with outer sign of box to lift or put down it. Any impact or vibration is prohibited. After opening box, it is better to move the machine by using forklift. There is relieving position on the base. If lifting, set crane rope according to lifting Fig.5; before lifting, remove water-plate; during lifting, ask for someone to help transportation. Don't make crane rope touch machine surface and each hand lever, handle; at the same time, put wood block or soft mat on the contact surface between crane rope and machine to avoid damaging paint coat.

### 2. Box-opening

Open box carefully to avoid damaging machine. After box is opened, according to list, check out if all auxiliaries are complet and correct; check

out if there is any damage to each hand lever, handle or other protruding parts. If there is anything wrong or damaged, please inform us in time in orde to settle it.

### 3、 Installation

In orde to make machine keep stability and working accuracy, machine should be installed on cement foundation which should be built according to the size on foundation Fig. 4. The foundation should be built on solid soil. Its depth depends on soil condition.

After the machine has been put on the foundation, first, basically make level, then use cement to pour foundation bolt; after cement solidifies, lock screw nut evenly; at the same time, check horizontal condition of the machine, errors in deep, cross directions of service platform surface should not surpass 0.04/1000.

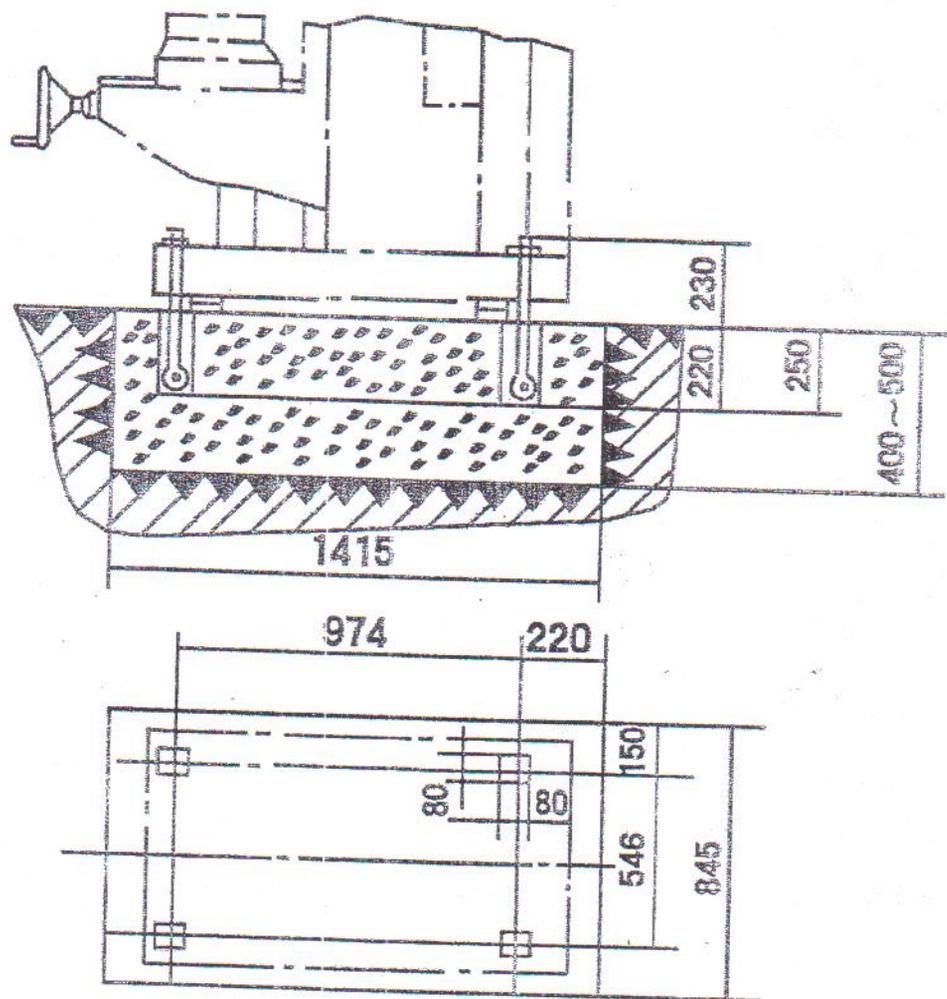


Fig.4

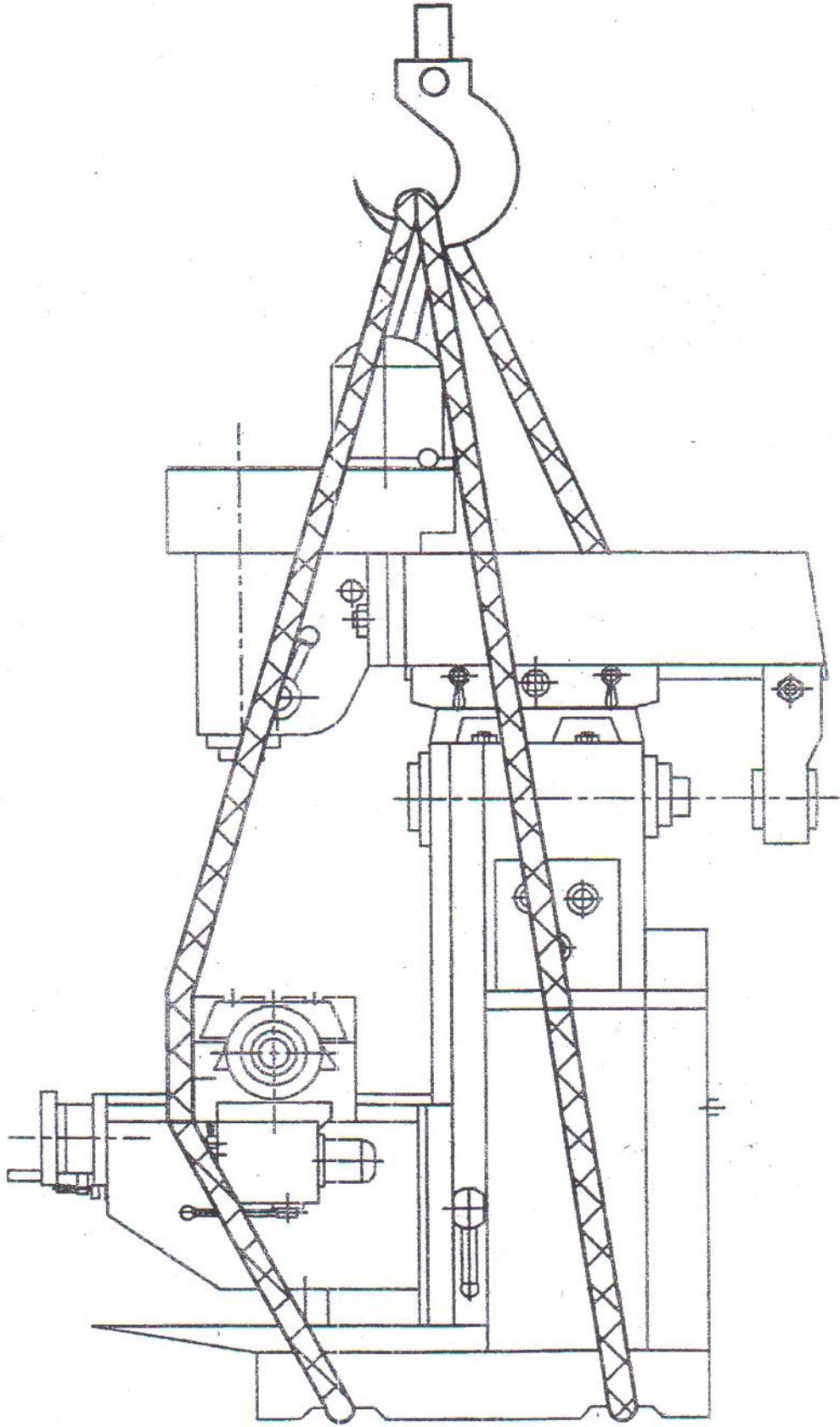


Fig5

## VIII SIMPLE MALFUNCTION OBVIATION

1.If the motor does not turn. please inspect it is right to connect wire or check electrical source.

2.If the radial run out of spindle is big with noise and heat please inspect wether spindle is too loose.

please spindle the nut on the spindle assembly to be fittest.

3.When the machine wobble please check the motor mount and lever lock nut screw machine head surport on the spindle if loosing pls adjust and lock.

4.It is difficult for the spindle to rise, fall or not replacing, please inspect wether there is scrap iron and other something in the connection between spindle sleeve and gear shaft and fatigue of spindle, If finding them, please clean them and apply oil and adjust spring to fittest.

5.If the knee table slide carrige does not rise steadily with noise, the table is steady, please confirm wether wedge ship loose or not, and clean scrap iron, add oil adjust wedge ship to fittest.

6.If there is noise in gear box, please stop machine immediately to conform the position you require, then check that the oil meet standard.

### **Trial Run**

Before trial tun. Please carefully clean the anti-rust oil on the every part of the machine. But the metal tools and other tools which can hurt the parts surface are forbidden. Then coat a thin lager oil on the outer surface.

Lubricate the sliding and rotating part before trial run. Pour engine oil into the Gear Box and the Power Feed. Till indicating through the point then do a overall check.

Bofore putting the power,examine if the power parameters is consisent with the indicated parameters on the machine's data plate and at the same time the round direction of the spindle is all right. During the trial run, first run the machine unloaded at the lowest speed for around 30 min's,

then increase the speed step by step and mean while inspect if the handwheel or handle operates easily or reliably etc.

**Notice:** Must loosen the tighten handle before move the moving part.

## IX ELECTRIC SYSTEM

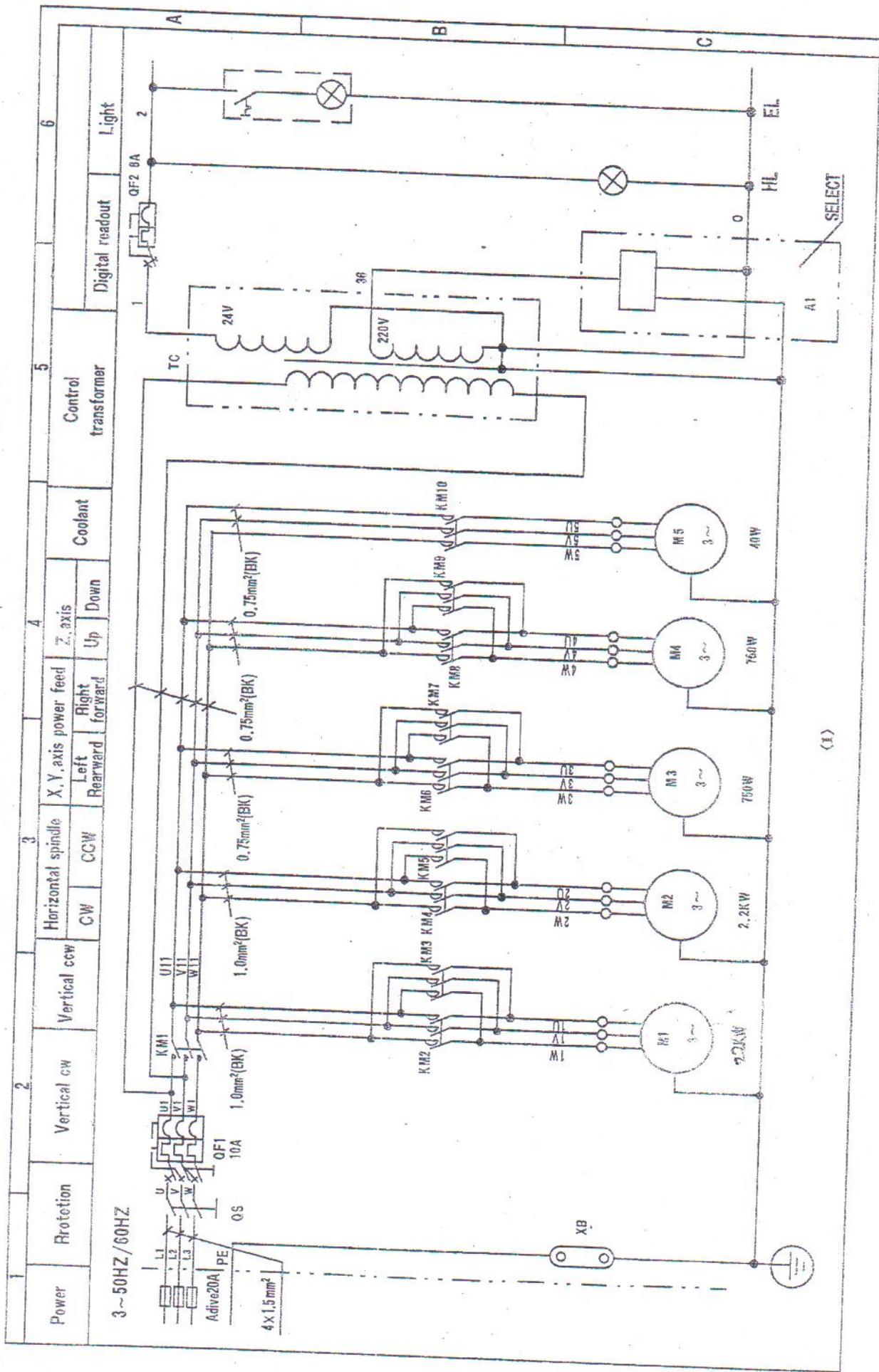
Electrical circuit adopt the advanced international component to make up, which make the machine easy to operate and safe.

**Caution:** The machine must have reliable grounding.

Only professionals have the rights to repair electrical apparatus of the machine.

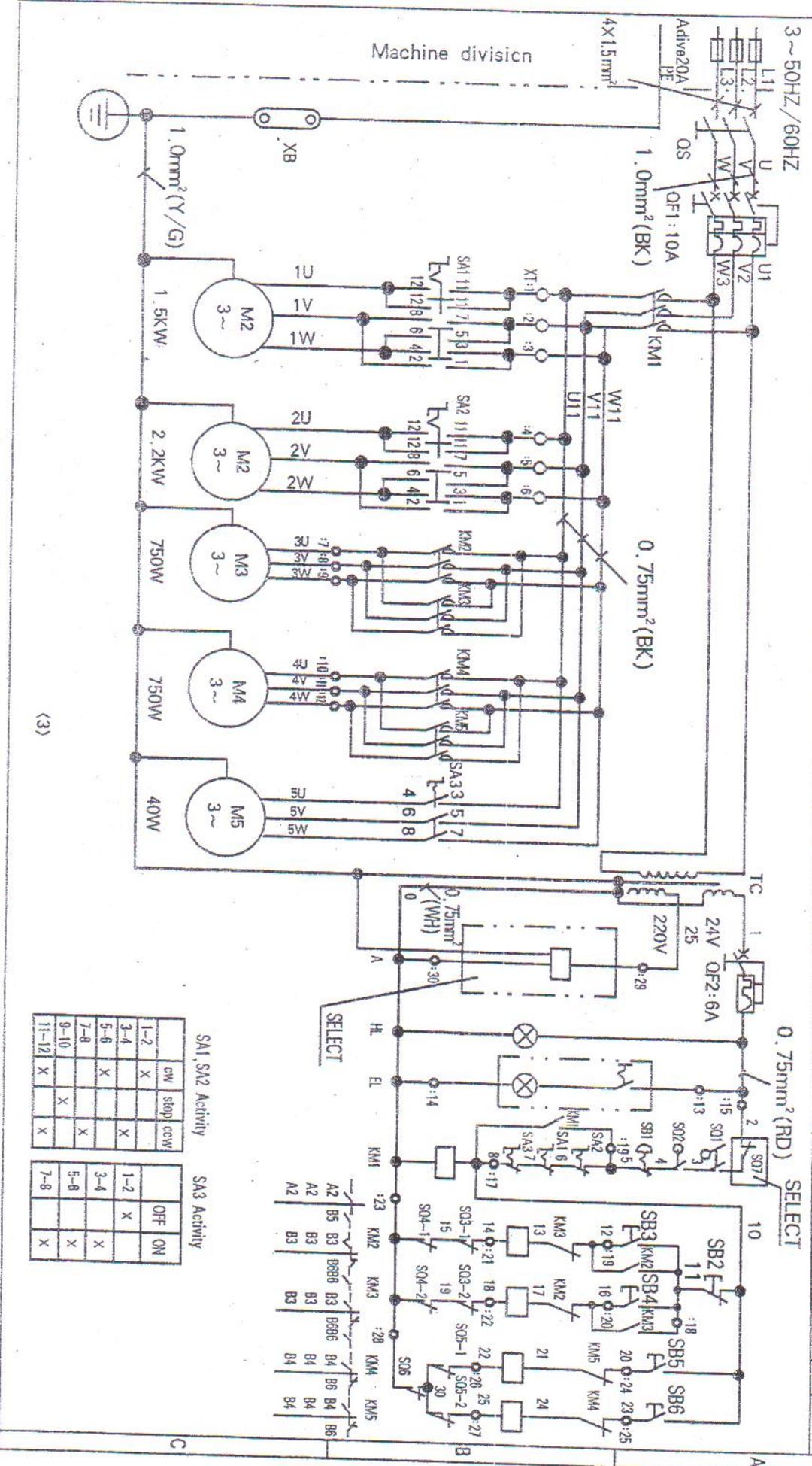
**Caution:** cut off connection between the machine and outer power.

Appendix: electrical parts list and electrical principle diagram.



(1)

|   |              |            |          |            |                      |        |                    |        |         |                     |             |             |    |      |   |  |
|---|--------------|------------|----------|------------|----------------------|--------|--------------------|--------|---------|---------------------|-------------|-------------|----|------|---|--|
| 1 | Power switch | Protection | 2        |            | 3                    |        | 4                  |        | Coolant | Control transformer | light       | E. stop     | 5  |      | 6 |  |
|   |              |            | Vertical | Horizontal | X, Y axis power feed | Z axis | Power feed control | Z axis |         |                     |             |             |    |      |   |  |
|   |              |            | ccw      | ccw        | ccw                  | ccw    | Left               | Right  | UP      | DOWN                | left behind | front right | UP | DOWN |   |  |



|      |     |     |     |     |      |       |
|------|-----|-----|-----|-----|------|-------|
|      | 1-2 | 3-4 | 5-6 | 7-8 | 9-10 | 11-12 |
| ccw  | X   |     | X   |     | X    |       |
| stop |     |     |     |     |      |       |
| ccw  |     | X   |     | X   |      | X     |

|     |     |     |     |     |
|-----|-----|-----|-----|-----|
|     | 1-2 | 3-4 | 5-6 | 7-8 |
| OFF |     | X   |     |     |
| ON  |     |     | X   |     |

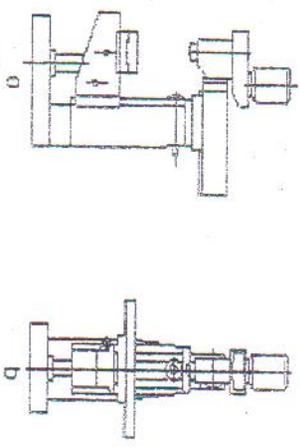
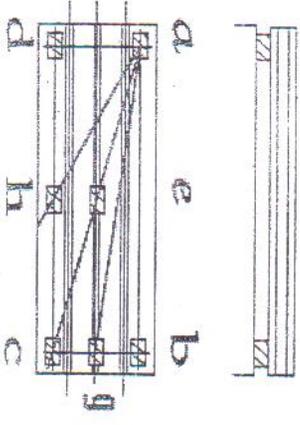
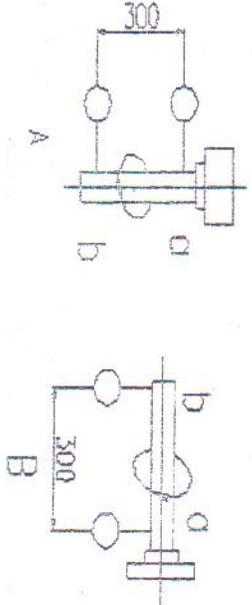


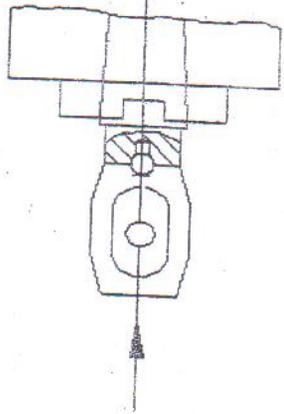
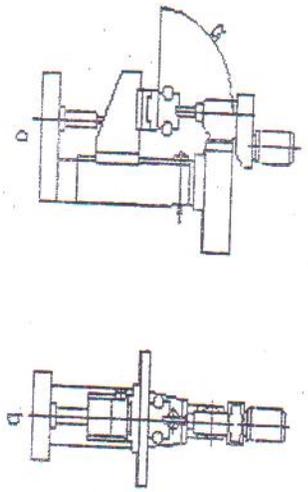
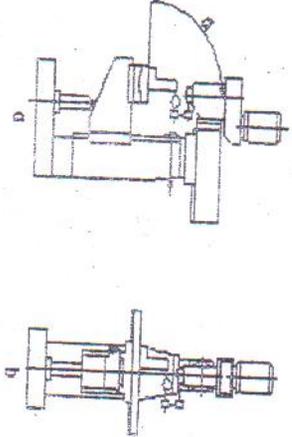
## List of electrical equipment

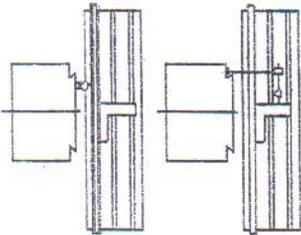
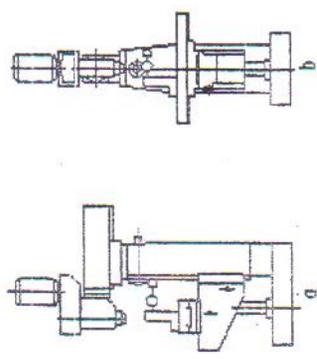
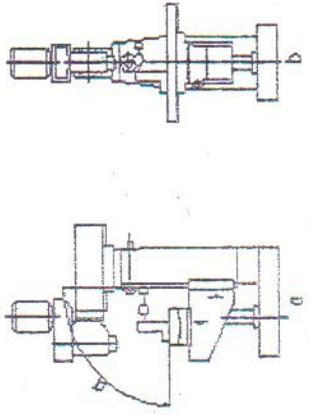
| Legend             | Name & usage              | Technical data                                 | Qty |
|--------------------|---------------------------|--|-----|
| M1                 | Spindle motor (vertical)  | Y90L-4 3PH 1.5KW V1                            | 1   |
| M2                 | Spindle motor(horizontal) | Y100L-4 3PH 2.2KW B3                           | 1   |
| M3                 | X.Yaxis power feed motor  | YS7144 3PH 750W B5                             | 1   |
| M4                 | Z.axis power feed motor   | YS7134 3PH 750W B5                             | 1   |
| M5                 | Coolant pump              | DB-12B 3PH 40W                                 | 1   |
| QS                 | Main switch               | JCH-13 20/31                                   | 1   |
| QF1                | Circuit breaker           | DZ47-63 (3P 10A)                               | 1   |
| QF2                |                           | DZ47-63 (1P 6A)                                | 1   |
| KM1..5             | AC contactor              | CJX1-9/22 (AC:24V)                             | 5   |
| TC                 | Control transformer       | JBK4-100VA I:0-380V O:0-24V                    | 1   |
| SA1                | Switch unit               | HZ5B-10/3 D022 (IE:10A)                        | 1   |
| SA2                | Switch unit               | HZ5B-10/3 D022 (IE:10A)                        | 1   |
| SA3                | Switch unit               | HZ5B-10/3 C005 (IE:10A)                        | 1   |
| SB1                | E.Stop button             | LA42J-11/R(J-1)                                | 1   |
| SB2                | Button                    | LA42P-10/R                                     | 1   |
| SB3.5              | Button                    | LA42P-10/G                                     | 2   |
| SB4.6              | Button                    | LA42P-10/W                                     | 2   |
| SQ1                | Door-switch               | JWM6-11A                                       | 1   |
| SQ3.4.5            | Limit switch              | JW2-11Z/3                                      | 3   |
| SQ6                | Limit switch              | JW2A-11H/W1                                    | 1   |
| SQ2                | Micro-switch              | LXW6-11DL                                      | 1   |
| EL                 | Working lamp              | JC-38 (AC:24V 50W)                             | 1   |
| HL                 | Power lamp                | LAY7-XD3/242 (AC:24V)                          | 1   |
| for user to elect: |                           |  |     |
| TC                 | Control readout           | JBK4-160 I:0-380V<br>O:0-24V(100VA)0-220(60VA) | 1   |
| A1                 | Digital readout           | AC:220V  | 1   |
| SQ7                | Micro-switch              | LXW16-10/21C                                   | 1   |

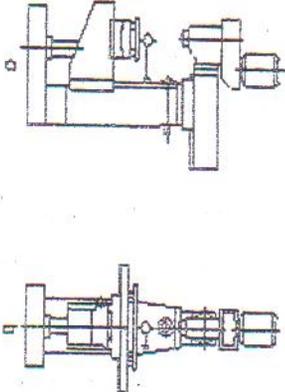
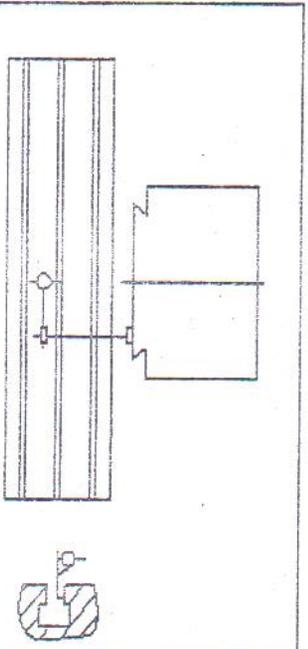
## List of electrical equipment

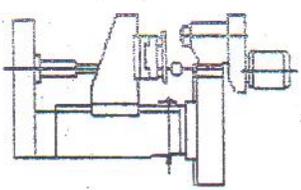
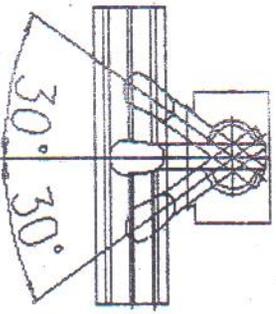
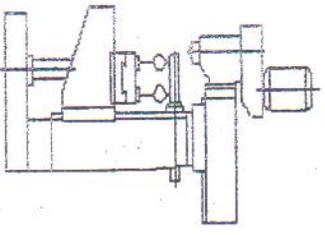
| Legend             | Name & usage              | Technical data                          | Qty |
|--------------------|---------------------------|---|-----|
| M1                 | Spindle motor (vertical)  | Y90L-4 3PH 2.2KW V1                     | 1   |
| M2                 | Spindle motor(horizontal) | Y100L-4 3PH 2.2KW B3                    | 1   |
| M3                 | X.Yaxis power feed motor  | YS7144 3PH 750W B5                      | 1   |
| M4                 | Z.axis power feed motor   | YS7134 3PH 750W B5                      | 1   |
| M5                 | Coolant pump              | AB-12 3PH 40W                           | 1   |
| QS                 | Main switch               | JCH-13 20/31                            | 1   |
| QF1                | Circuit breaker           | DZ47-63 (3P 10A)                        | 1   |
| QF2                |                           | DZ47-63 (1P 6A)                         | 1   |
| KM1..10            | AC contactor              | CJX1-9/22 (AC:24V)                      | 10  |
| TC                 | Control transformer       | JBK4-160VA O:0-24V                      | 1   |
| SA1SA2             | Rotary switch             | LAY7-22X/3106                           | 2   |
| SA3                | Rotary switch             | LAY7-11X/2101                           | 1   |
| SB1                | E.Stop button             | LA42J-11/R(J-1)                         | 1   |
| SB2                | Button                    | LA42P-10/R                              | 1   |
| SB3.5              | Button                    | LA42P-10/G                              | 2   |
| SB4.6              | Button                    | LA42P-10/W                              | 2   |
| SQ1                | Door-switch               | JWM6-11A                                | 1   |
| SQ3.5              | Limit switch              | JW2-11Z/3                               | 3   |
| SQ6                | Limit switch              | JW2A-11H/W1                             | 1   |
| SQ2                | Micro-switch              | LXW6-11DL                               | 1   |
| EL                 | Working lamp              | JC-38 (AC:24V 50W)                      | 1   |
| For user to elect: |                           |   |     |
| TC                 | Control readout           | JBK4-200<br>O:0-24V(160VA) 0-220V(40VA) | 1   |
| A1                 | Digital readout           | AC:220V                                 | 1   |
| SQ7                | Limit switch              | LXW16-10/21C                            | 1   |

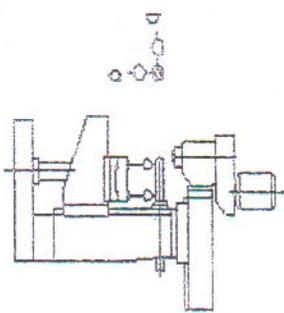
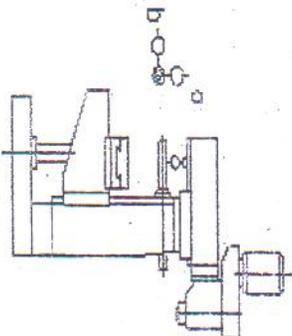
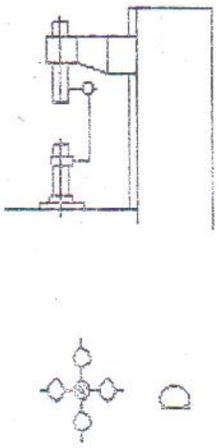
| NO. | ITEM                     | BRIEF DRAWING   | ALLOWANCE                    | ACTUAL TEST |
|-----|--------------------------|---|------------------------------|-------------|
| G1  | Flatness                 |  | a: 0.04/1000<br>b: 0.04/1000 |             |
| G2  | Table flatness           |   | 0.04/200                     |             |
| G3  | Spindle bore axis runout |   | a: 0.02<br>b: 0.04           |             |

| NO. | ITEM  | BRIEF DRAWING  | ALLOWANCE  | ACTUAL TEST |
|-----|---|--|--|-------------|
| G4  | Kick of spindle   |  | 0.02   |             |
| G5  | Perpendicularity of the spindle and table                           |    | a: 0.10/200<br>$\alpha \leq 90^\circ$<br>b: 0.10/200 |             |
| G6  | Perpendicularity between vertical movement of the spindle and table |    | a: 0.10/200<br>$\alpha \leq 90^\circ$<br>b: 0.10/200 |             |

| NO. | ITEM  | BRIEF DRAWING  | ALLOWANCE  | ACTUAL TEST |
|-----|---|--|--|-------------|
| G10 | Perpendicular<br>between longitudinal<br>move of table and<br>cross move of table |   | 0.10/200   |             |
| G11 | Straightness of<br>vertical movement of<br>knee                                   |    | a: 0.05/200<br>b: 0.05/200                           |             |
| G12 | Perpendicular<br>between bedway and<br>vertical guideway                          |  | a: 0.10/200<br>$\alpha \leq 90^\circ$<br>b: 0.10/200 |             |

| NO. | ITEM  | BRIEF DRAWING   | ALLOWANCE                  | ACTUAL TEST |
|-----|---|---|----------------------------|-------------|
| G7  | Parallelism between the work flatness and table |  | a: 0.05/200<br>b: 0.05/200 |             |
| G8  | The straightness of basis "T"                   |   | 0.03/200                   |             |
| G9  | The parallelism between basis "T" and table     |   | 0.15/200                   |             |

| NO. | ITEM  | BRIEF DRAWING   | ALLOWANCE | ACTUAL TEST |
|-----|---|---|-----------|-------------|
| G13 | Parallelism between table and ram moving            |  | 0.10/200  |             |
| G14 | Parallelism between table and rotating plate rotate |   | 0.10/200  |             |
| G15 | Parallelism between spindle and table               |   | 0.10/200  |             |

| NO. | ITEM   | BRIEF DRAWING   | ALLOWANCE                  | ACTUAL TEST |
|-----|--|---|----------------------------|-------------|
| G16 | Parallelism between cross move of table and spindle            |  | a: 0.10/200<br>b: 0.10/200 |             |
| G17 | Parallelism between the guideway and spindle                   |   | a: 0.10/200<br>b: 0.10/200 |             |
| G18 | Coaxialism between the hole of surporthilt and axis of spindle |   | a: 0.10<br>b: 0.10         |             |

## PACKING LIST

| ITEM | NAME                       | MODEL                  | Q'TY |
|------|----------------------------|------------------------|------|
| 1    | Drilling & Milling machine |                        | 1    |
| 2    | Keyless Drill Chuck        | B18/1-16MM             | 1    |
| 3    | Milling chuck set          |                        | 1    |
| 4    | Reduction Sleeve           | ISO40/MT3<br>ISO40/MT2 | 2    |
| 5    | Machine Vice 160MM         | 160mm                  | 1    |
| 6    | Wrench                     | S21-24                 | 1    |
| 7    | Inner-Hexagonal Spanner    | S21-24                 | 1    |
| 8    | Camlock                    |                        | 2    |
| 9    | Wedge Shifter              |                        | 1    |
| 10   | Spindle Arbor (only MT.4)  |                        | 1    |
| 11   | Horizontal Milling Arbor   | 22,27mm                | 2    |
| 12   | Operation Manual           |                        | 1    |
| 13   | Packing List               |                        | 1    |

## HOLZMANN-MASCHINEN GmbH

Marktplatz 4 · 4170 Haslach · Austria  
**Telefon** +43.(0)7289.71562-0  
**Telefax** +43.(0)7289.71562-4  
**Email** info@holzmann-maschinen.at

weiterer Standort:  
Gewerbepark 8 · 4707 Schlüsslberg · Austria  
**Telefon** +43.(0)7248.61116-0  
**Telefax** +43.(0)7248.61116-6



# EC Declaration of Conformity

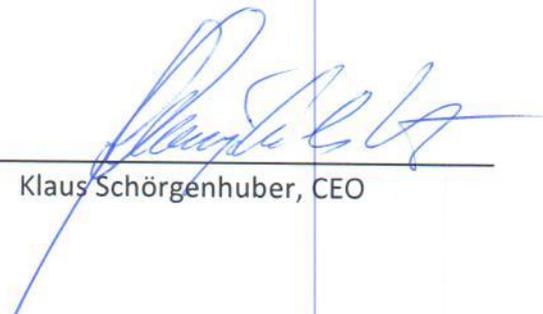
Hereby we declare that the machine BF 1000 DDRO meets all requirements of the EC Directive 98/37/EC in reference to its safety and health requirements.

Any changes to the machine without our written permission renders this document invalid.

Manufactured for:     HOLZMANN MASCHINEN GmbH  
                              Marktplatz 4  
                              4170 Haslach

Product description: Holzmann BF 1000 DDRO

Haslach, 20.12.2012  
Place, date

  
\_\_\_\_\_  
Klaus Schörgenhuber, CEO

Sparkasse Rohrbach · BLZ **20334** · Kto-Nr. **1188531**  
SWIFT-BIC: **SMWRAT21** · IBAN: **AT072033400001188531**

Gerichtsstand: A-4020 Linz · Firmenbuchnummer: FN 340945s · UID-Nummer: ATU 65513349 · Steuernummer: 203/5484  
EORI-Nummer: ATEOS1000021386 · Die Ware bleibt bis zur vollständigen Bezahlung unser uneingeschränktes Eigentum.

Raiffeisenbank Peuerbach · BLZ **34442** · Kto-Nr. **433680**  
SWIFT-BIC: **RZ00AT2L442** · IBAN: **AT383444200000433680**

## 17 GARANTIEERKLÄRUNG

(Stand 01.07.2013)

Mängelhaftungsansprüche des Käufers aus dem Kaufvertrag gegenüber dem Verkäufer (Holzmann Vertriebspartner) sowie gesetzliche Gewährleistungsrechte des jeweiligen Landes werden durch diese Garantieerklärung nicht berührt.

Für diese Maschine leisten wir Garantie gemäß folgenden Bedingungen:

- A) Die Garantie umfasst die unentgeltliche Beseitigung aller Mängel an der Maschine, nach Maßgabe der nachfolgenden Regelungen (B-G), welche die ordnungsgemäße Funktion der Maschine beeinträchtigen und nachweislich auf Material- oder Herstellungsfehler beruhen.
- B) Die Garantiezeit beträgt 12 Monate, bei gewerblicher Nutzung 6 Monate, gültig ab Lieferung der Maschine an den Erstendabnehmer. Als Nachweis ist der Original-Ablieferbeleg maßgeblich, bei Selbstabholung der Maschine der Original Kaufbeleg.
- C) Zur Anmeldung von Garantieansprüchen kontaktieren Sie bitte den HOLZMANN Vertriebspartner, von dem Sie die Maschine erworben haben, mit folgenden Unterlagen:
  - >> Kaufbeleg und/oder Ablieferbeleg
  - >> ausgefülltes Serviceformular mit Fehlerbericht
  - >> Bei Anforderung von Ersatzteilen eine Kopie der Ersatzteilzeichnung, mit den benötigten Ersatzteilen markiert.
- D) Die Garantieabwicklung und der Ort der Garantierfüllung erfolgt nach Maßgabe der HOLZMANN GmbH. Leicht zu behebbende Mängel werden durch unsere Vertriebspartner beseitigt, bei komplexeren Defekten behalten wir uns eine Begutachtung in 4707 Haslach, Österreich vor. Sofern nicht explizit ein zusätzlicher Vor-Ort Servicevertrag abgeschlossen ist, gilt als Erfüllungsort der Garantieleistung stets der HOLZMANN-MASCHINEN Firmensitz in 4707 Haslach, Österreich. Die im Rahmen einer Garantiebearbeitung anfallenden allfälligen Transportkosten von und zum Firmensitz sind in dieser Hersteller-Garantie nicht abgedeckt.
- E) Garantieausschluss bei Mängeln:
  - an Maschinenteilen, welche gebrauchsbedingten oder sonstigen natürlichen Verschleiß unterliegen, sowie Mängeln an der Maschine, die auf einen gebrauchsbedingten oder sonstigen natürlichen Verschleiß zurückzuführen sind.
  - die auf unsachgemäße oder fahrlässige Montage, Inbetriebnahme, bzw. Anschluss an das elektrische Netz zurückzuführen sind.
  - die auf Nichtbeachtung von Bedienungshinweisen, nicht bestimmungsgemäßen Gebrauch, atypischen Umweltbedingungen, sachfremden Betriebsbedingungen und Einsatzgebiet, mangelnde bzw. unsachgemäße Wartung oder Pflege zurückzuführen sind.
  - die durch die Verwendung sowie Einbau von Zubehör-, Ergänzungs- oder Ersatzteilen verursacht wurden, die keine Original HOLZMANN Ersatzteile sind.
  - die geringfügige Abweichungen vom Soll-Zustand darstellen, welche für den Wert oder die Gebrauchstauglichkeit der Maschine unerheblich sind.
  - die auf fahrlässige konstruktionsbedingte Überbeanspruchung zurückzuführen sind. Insbesondere bei Mängeln durch Nutzung, welche durch Belastungsniveau und Umfang als gewerblich einzustufen sind, bei Maschinen, die nach Bauart und Leistungsvermögen nicht für den gewerblichen Gebrauch konstruiert und bestimmt sind.
- F) Im Rahmen dieser Garantie sind weitere Ansprüche des Käufers über die hier ausdrücklich genannten Garantieleistungen hinaus ausgeschlossen.
- G) Diese Hersteller-Garantie wird freiwillig übernommen. Garantieleistungen bewirken daher keine Verlängerung der Garantiefrist und setzen auch keine neue Frist, auch nicht für Ersatzteile, in Gang.

### SERVICE

Nach Ablauf der Garantiezeit können Instandsetzungs- und Reparaturarbeiten von entsprechend geeigneten Fachfirmen durchgeführt werden. Es steht Ihnen auch die HOLZMANN-Maschinen GmbH weiterhin gerne mit Service und Reparatur zur Seite. Stellen Sie in diesem Fall eine unverbindliche Kostenanfrage, unter Angabe der Informationen siehe C) an unseren Kundendienst oder senden Sie uns Ihre Anfrage einfach per umseitig beiliegendem Formular ein.

Mail: [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at)

FAX: +43 (0) 7248 61116 6

## 18 GUARANTEE TERMS

(applicable from 01.07.2013)

Please consult our troubleshooting section for initial problem solving. Feel free to contact your HOLZMANN reseller or us for Customer Support!

Warranty claims based on your sales contract with your HOLZMANN retailer, including your statutory rights, shall not be affected by this guarantee declaration. HOLZMANN-MASCHINEN grants guarantee according to following conditions:

- A) The guarantee covers the correction of deficiencies to the tool/machine, at no charge, if it can be verified adequately that the deficiencies were caused by a material or manufacturing fault.
- B) The guarantee period lasts 12 months, and is reduced to 6 months for tools in commercial use. The guarantee period begins from the time the new tool is purchased from the first end user. The starting date is the date on the original delivery receipt, or the sales receipt in the case of pickup by the customer.
- C) Please lodge your guarantee claims to your HOLZMANN reseller you acquired the claimed tool from with following information:
  - >> Original Sales receipt and/or delivery receipt
  - >> Service form (see next page) filed, with a sufficient deficiency report
  - >> for spare part claims: a copy of the respective exploded drawing with the required spare parts being marked clear and unmistakable.
- D) The Guarantee handling procedure and place of fulfillment is determined according to HOLZMANN's sole discretion in accordance with the HOLZMANN retail partner. If there is no additional Service contract made including on-site service, the place of fulfillment is principally the HOLZMANN Service Center in Haslach, Austria.
- E) Transport charges for sendings to and from our Service Center are not covered in this guarantee.  
The Guarantee does not cover:
  - Wear and tear parts like belts, provided tools etc., except to initial damage which has to be claimed immediately after receipt and initial check of the machine.
  - Defects in the tool caused by non-compliance with the operating instructions, improper assembly, insufficient power supply, improper use, abnormal environmental conditions, inappropriate operating conditions, overload or insufficient servicing or maintenance.
  - Damages being the causal effect of performed manipulations, changes, additions made to the machine.
  - Defects caused by using accessories, components or spare parts other than original HOLZMANN spare parts.
  - Slight deviations from the specified quality or slight appearance changes that do not affect functionality or value of the tool.
  - Defects resulting from a commercial use of tools that - based on their construction and power output - are not designed and built to be used within the frame of industrial/commercial continuous load.
- F) Claims other than the right to correction of faults in the tool named in these guarantee conditions are not covered by our guarantee.
- G) This guarantee is voluntary. Therefore Services provided under guarantee do not lengthen or renew the guarantee period for the tool or the replaced part.

### SERVICE

After Guarantee and warranty expiration specialist repair shops can perform maintenance and repair jobs. But we are still at your service as well with spare parts and/or machine service. Place your spare part / repair service cost inquiry by filing the SERVICE form on the following page and send it:

via Mail to [service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at)

or via Fax to: +437248611166

# SERVICE FORM / SERVICEFORMULAR

Please tick one box from below / Bitte kreuzen Sie eine der untenstehenden an:

- service inquiry / Serviceanfrage  
 spare part inquiry / Ersatzteilanfrage  
 guarantee claim / Garantierantrag

## 1. Senders information (\* required) / Daten Antragsteller (\* sind Pflichtfelder)

\*First name, Family name / Vorname, Nachname \_\_\_\_\_

\*Street, house number / Straße, Hausnummer \_\_\_\_\_

\*ZIP Code, place / PLZ, Ort \_\_\_\_\_

\*Country / Staat \_\_\_\_\_

\*(mobile)Phone / Telefon bzw. Mobiltel. \_\_\_\_\_

*International numbers with country code*

\* E-Mail \_\_\_\_\_

Fax \_\_\_\_\_

## 2. Tool information / Geräteinformationen

serial number/Seriennummer: \_\_\_\_\_ \*Machine type/Maschinentype: \_\_\_\_\_

### 2.1 Required spare parts / benötigte Ersatzteile

| Part No° / Ersatzteilnummer | Description / Beschreibung | Number/Anzahl |
|-----------------------------|----------------------------|---------------|
|                             |                            |               |
|                             |                            |               |
|                             |                            |               |
|                             |                            |               |
|                             |                            |               |

### 2.2 Problem description / Problembeschreibung

Please describe amongst others in the problem:

What has caused the problem/defect, what was the last activity before you noticed the problem/defect?

For electric problems: Have you had checked your electric supply and the machine already by a certified electrician?

Bitte führen Sie in der Fehlerbeschreibung unter anderem an:

Was hat den Defekt verursacht bzw. was war die letzte durchgeführte Tätigkeit, bevor Ihnen das Problem/der Defekt aufgefallen ist?

Bei Elektrodefekten: Wurde die Stromzuleitung sowie die Maschine bereits von einem Elektrofachmann geprüft?

## 3. Additional information

INCOMPLETELY FILED SERVICE FORMS CANNOT BE PROCESSED!  
FOR GUARANTEE CLAIMS PLEASE ADD A COPY OF YOUR ORIGINAL SALES /  
DELIVERY RECEIPT OTHERWISE IT CANNOT BE ACCEPTED.  
FOR SPARE PART ORDERS PLEASE ADD TO THIS SERVICE FORM A COPY OF  
THE RESPECTIVE EXPLODED DRAWING WITH THE REQUIRED SPARE PARTS  
BEING MARKED CLEARLY AND UNMISTAKABLE.  
THIS HELPS US TO IDENTIFY THE REQUIRED SPARE PARTS FASTLY AND ACCE-  
LERATES THE HANDLING OF YOUR INQUIRY.  
THANK YOU FOR YOUR COOPERATION!

## / Bitte Beachten

UNVOLLSTÄNDIG AUSGEFÜLLTE FORMULARE KÖNNEN NICHT BEARBEITET  
WERDEN!  
GARANTIEANTRÄGE KÖNNEN AUSSCHLISSLICH UNTER BEILAGE DES  
KAUFBELEGES/ABLIEFERBELEGES AKZEPTIERT WERDEN.  
BEI ERSATZTEILBESTELLUNGEN LEGEN SIE DIESEM FORMULAR EINE KOPIE  
DER BETREFFENDEN ERSATZTEILZEICHNUNG BEI! MARKIEREN SIE DARAUF  
DIE BENÖTIGTEN ERSATZTEILE. DIES ERLEICHTERT UNS DIE IDENTIFIZIE-  
RUNG UND ERMÖGLICHT SO EINE RASCHERE BEARBEITUNG.  
VIELEN DANK!

## Produktbeobachtung

Wir beobachten unsere Produkte auch nach der Auslieferung.

Um einen ständigen Verbesserungsprozess gewährleisten zu können, sind wir von Ihnen und Ihren Eindrücken beim Umgang mit unseren Produkten abhängig:

- Probleme, die beim Gebrauch des Produktes auftreten
- Fehlfunktionen, die in bestimmten Betriebssituationen auftreten
- Erfahrungen, die für andere Benutzer wichtig sein können

Wir bitten Sie, derartige Beobachtungen zu notieren und an diese per E-Mail, Fax oder Post an uns zu senden:

## Product experience form

We observe the quality of our delivered products in the frame of a Quality Management policy.

Your opinion is essential for further product development and product choice. Please let us know about your:

- Impressions and suggestions for improvement.
- experiences that may be useful for other users and for product design
- Experiences with malfunctions that occur in specific operation modes

We would like to ask you to note down your experiences and observations and send them to us via FAX, E-Mail or by post:

Meine Beobachtungen/ My experiences:

|  |
|--|
|  |
|  |
|  |
|  |
|  |
|  |
|  |
|  |
| <b>Name:</b><br><b>Product:</b><br><b>Purchase date:</b><br><b>Purchased from:</b><br><b>My Email:</b> |
| Thank you for your kind cooperation!   |

### KONTAKTADRESSE / CONTACTS:

**HOLZMANN MASCHINEN GmbH**

4170 Haslach, Marktplatz 4 AUSTRIA

Fax 0043 7248 61116-6

[service@holzmann-maschinen.at](mailto:service@holzmann-maschinen.at)