Please keep a copy of the operating instructions.
The operating instructions contain the EC Declaration of Conformity, which must be produced for authorities upon request.
# Table of contents

## Orientation diagram
- Orientation diagram: 2

## Table of contents
- Table of contents: 3

## Guidelines on using this manual
- How to use these operating instructions: 5

## Safety information
- Remaining risks according to ISO EN 12100-2: 6
- Safety decals: 6
- Intended use: 6
- Safety information: 6
- Noise emission: 7
- Dust emission: 7

## EC Declaration of Conformity / Techn. Data
- EC Declaration of Conformity: 9

## Assembly machine setup
- Assembly machine space requirement: 10
- Unpacking and assembly:
  - Required parts: 10
  - Setting drill bit length: 10
  - Setting drilling pattern: 10
  - Inserting drill bits: 10
  - Setting drilling depth: 10
  - Drilling depth stop: 11
  - Setting the stop system: 11
  - Setting swivel stops (optional): 11
- Electrical connection: 11
- Dust extraction: 11

## Assembly
- Furniture hinge assembly:
  - Required parts: 12
  - Setting drill bit length: 12
  - Setting drilling pattern: 12
  - Inserting drill bits: 12
  - Setting drilling depth: 12
  - Drilling depth stop: 12
  - Setting the stop system: 12
  - Setting swivel stops (optional): 12
  - Placing door on the work table and pushing up against the stop: 12
  - Drilling: 12

## Cruciform mounting plate assembly
- Required parts: 16
- Setting drill bit length: 16
- Setting drilling pattern: 16
- Installing drill bits into the chuck: 16
- Checking drilling depth setting: 16
- Setting the stop system: 16
- Placing carcass side on the work table and pushing up against the stop: 16

## Drilling hole groups
- Required parts: 17
- Setting drill bit length: 17
- Setting drilling pattern: 17
- Inserting drill bits into the chuck: 17
- Checking drilling depth setting: 17
- Setting stop system: 17
- Setting the swivel stops: 17
- Drilling hole groups: 17
- Placing carcass side on the work table and pushing up against the stop: 17

## Drilling
- Drilling: 17
<table>
<thead>
<tr>
<th>Chapter</th>
<th>Title</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 - Maintenance and service</td>
<td></td>
<td>18</td>
</tr>
<tr>
<td>5.1 - Maintenance</td>
<td></td>
<td>18</td>
</tr>
<tr>
<td>5.1.1) Maintenance</td>
<td></td>
<td>18</td>
</tr>
<tr>
<td>5.1.2) Damaged coupling (clutch)</td>
<td></td>
<td>18</td>
</tr>
<tr>
<td>6 - Troubleshooting</td>
<td></td>
<td>19</td>
</tr>
<tr>
<td>6.1 - Error during drilling</td>
<td></td>
<td>19</td>
</tr>
<tr>
<td>6.2 - Fitting insertion error</td>
<td></td>
<td>21</td>
</tr>
<tr>
<td>6.3 - Function errors</td>
<td></td>
<td>22</td>
</tr>
<tr>
<td>7 - Appendix</td>
<td></td>
<td>23</td>
</tr>
<tr>
<td>7.1 – User-supplied work table</td>
<td></td>
<td>24</td>
</tr>
<tr>
<td>8 - Diagrams</td>
<td></td>
<td>24</td>
</tr>
<tr>
<td>8.1 - Electrical diagram 1x 230 V 50 Hz</td>
<td></td>
<td>25</td>
</tr>
<tr>
<td>Notes</td>
<td></td>
<td>25</td>
</tr>
</tbody>
</table>
C.1 - How to use these operating instructions

- Please keep a copy of the operating instructions.
- Completely read the operating instructions and the safety information before operating the assembly machine.
- We recommend that you use the orientation diagram for easier identification of the parts being described.
- Individual sections are indicated by capital letters which makes it easier to navigate the instructions.

Safety information:
This exclamation point indicates important safety information that must be followed.

Comment:
This exclamation point indicates an important comment. If this comment is not followed, then assembly machine components as well as the work piece itself may be damaged or the assembly machine may be rendered inoperable and/or the work piece unusable.

Component description codes correspond to the section where the component and its function is described. For example, [3.1] is described in section 3.

Dear valued Blum customer,
We would like to congratulate you on your decision to purchase the Blum assembly machine. You are now the owner of a modern, high-quality assembly machine that will give you years of productive use with the proper care and maintenance.

We realise that your time is valuable. However, you should carefully read these operating instructions before you set up and use the machine for the first time. In this way, you will best determine how to adjust the assembly machine to your needs as well as protect yourself against injury. In addition, the operating instructions also contain important information about machine maintenance.

At the time of printing, these operating instructions contained up-to-date information for this model. Small deviations due to continual development of the assembly machine design cannot be ruled out entirely. These operating instructions are an important component to the assembly machine and must be transferred to the new owner if the machine is sold.

For your own safety, you should only use Blum-approved replacement parts and accessories. Blum is not liable for any damages resulting from the use of unapproved products.

Blum GmbH retains the right to make changes to and/or cancel without replacement the technical design, equipment, technical information, colour, materials, services provided and similar without prior notice and without explanation as well as the right to discontinue production of a specific model also without prior notice.
D.1- Remaining risks according to ISO EN 12100-2

The machine complies with the current safety standards. However, risks remain for:

- The operator and second persons due to the stroke movement of the drilling unit and especially in cases where safety devices are removed or control elements should fail.

- Other remaining risks are indicated by the safety decals and in the following safety rules. It is therefore absolutely essential to follow all safety instructions carefully.

D.2 - Safety decals

<table>
<thead>
<tr>
<th>Safety Decal</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Completely read the operating instructions and the safety information before operating the assembly machine</td>
</tr>
<tr>
<td></td>
<td>Wear proper eye and face protection when operating this machine</td>
</tr>
<tr>
<td></td>
<td>Only one person at a time should operate the machine</td>
</tr>
<tr>
<td></td>
<td>Electrical connections and maintenance should only be performed by a qualified electrician. Disconnect the assembly machine from the power supply before making any repairs. (eg un plug)</td>
</tr>
<tr>
<td></td>
<td>Keep hands away from the drill or swing arm during the drilling or insertion process. Do not remove safety devices - danger of injury.</td>
</tr>
<tr>
<td></td>
<td>Keep hands away from the danger zone. - danger of being crushed</td>
</tr>
</tbody>
</table>

D.3 - Intended use

- The designated purpose of the assembly machine is the drilling and insertion of furniture fittings into work pieces made of wood, particle board or plastic coated wood. The assembly machine should only be used in manufacturing. The manufacturer does not assume liability for uses not described in the instruction manual.

- The machine is not explosion-proof. It should not be set up near a paint finishing system

D.4 - Safety information

- Disconnect the assembly machine from the power supply before retooling or performing any work on drill bits.

- Only use sharp, clean drill bits.

- Particular care must be taken when working on sections that jut out over the worktable. Attach a larger work table or use extensions.

- Secure the work piece during drilling/insertion. Use suitable clamping equipment.
You should always check that all safety devices and machine parts are functioning properly before use. Replace damaged parts with original Blum parts.

Make sure that no other tools or objects are on the work table aside from your work piece before turning on the assembly machine.

After finishing work, disconnect the machine from the power supply.

CAUTION: For your own safety, use only those accessories which are recommended or indicated in the manual or Blum sales literature.

Do not make any alterations or modifications to the assembly machine.

If there are any questions and/or problems, please contact the BLUM Customer Service Department.

D.5 - Noise emission

Noise emission levels as per EN ISO 11202 (11204) are:
Work place noise level is (work cycle): 79 dB(A) (measured at a height of 1.5 m and at 1 m forward of the worktable edge. The ambient correction factor K3A is 4 dB and is calculated according to EN ISO 11204 Appendix A. The difference between the extraneous noise level and the sound intensity level at each measuring point is > 6dB)

The specified values are emission values, which means that they are not necessarily safe workplace values at the same time. Although there is a correlation between emission and immission values, the necessity of additional precautions cannot be deduced with certainty. Factors liable to influence current immission levels in the workplace include the length of exposure, the characteristics of the workroom, and other noise sources. Also, admissible workplace levels may vary from country to country. The information provided here is designed to enable users to assess the hazards and risks involved more accurately.

D.6 - Dust emission

If connected properly to a dust extraction system, dust emissions fall clearly below the technical standard value. The assembly machine is equipped with a connecting piece for hoses with an inside diameter of 80 mm. This provides negative pressure of 2000 Pa for the maximum required average air velocity of 20 m/sec. If there is no extraction system connector with a diameter of 80 mm, the supplied adapter can be used. For connection, make sure that a minimum air velocity of 20 m/sec is provided at the cross-section of the 80 mm hose.

The assembly machine must be connected to a dust extraction system. (The extraction system connection must be flexible and non-flammable).

Regularly remove remaining dust and chips using a vacuum cleaner.
<table>
<thead>
<tr>
<th>Language</th>
<th>Translation</th>
</tr>
</thead>
<tbody>
<tr>
<td>BG</td>
<td>Пробивни машини</td>
</tr>
<tr>
<td>DA</td>
<td>Bore- og beslagssætmaskiner</td>
</tr>
<tr>
<td>DE</td>
<td>Bohr- und Beschlagsetzmaschine</td>
</tr>
<tr>
<td>EN</td>
<td>Drilling and insertion machine</td>
</tr>
<tr>
<td>ET</td>
<td>Puurimis- ja sisestusmasinad</td>
</tr>
<tr>
<td>FI</td>
<td>Asennusporakoneet</td>
</tr>
<tr>
<td>FR</td>
<td>Machine pour percer et poser des ferrures</td>
</tr>
<tr>
<td>EL</td>
<td>Μηχανή μαζικής διάτρησης και τοποθέτησης</td>
</tr>
<tr>
<td>IT</td>
<td>Macchina forainseritrice</td>
</tr>
<tr>
<td>LV</td>
<td>Urbsanas un furnīturas iestrādāšanas iekārta</td>
</tr>
<tr>
<td>LT</td>
<td>Grēžimo-montavimo staklēs</td>
</tr>
<tr>
<td>NL</td>
<td>Boor- en beslagmachines</td>
</tr>
<tr>
<td>PL</td>
<td>Maszyna do nawiercania i osadzania okuć</td>
</tr>
<tr>
<td>PT</td>
<td>Furadeira e máquina para a montagem de ferragens</td>
</tr>
<tr>
<td>RO</td>
<td>Mașină de găurit și montat feronerie</td>
</tr>
<tr>
<td>SV</td>
<td>Borr- och beslagsmonteringsmaskiner</td>
</tr>
<tr>
<td>SK</td>
<td>Vrtiací a lisovací stroj</td>
</tr>
<tr>
<td>SL</td>
<td>Vrtašni stroj in stroj za okovje</td>
</tr>
<tr>
<td>ES</td>
<td>Máquinas para taladrar y de instalación de herrajes</td>
</tr>
<tr>
<td>CS</td>
<td>Vrtaci a lisovací stroje</td>
</tr>
<tr>
<td>HU</td>
<td>Fúró- és vasalatbepréselő gépek</td>
</tr>
</tbody>
</table>
F.1 - EC Declaration of Conformity

Julius Blum GmbH, Industriestr. 1, A-6973 Höchst herewith declare on our own responsibility that the product MINIPRESS (M52.xxxx) with drilling heads (MZK.1000, MZK.1900, MZK.8000, MZK.8800) to which this Declaration refers, complies with the following EC Directives:

EC Machine Directive  2006/42/EC
EC EMV Directive  2004/108/EC

The following harmonised European standards have been used to ensure proper implementation of the requirements specified in the EU Directives:
EN ISO 12100-1, EN ISO 12100-2, EN 60204-1, EN 349

In addition, the following standards have also been applied:
EN ISO 11202, EN ISO 11204, DIN 33893-2

Registered location:
Fachausschuss Holz
Testing and certification centre in BG - PRÜFZERT
Postfach 800480
GS testing certification no.: 051140
BG testing certification no.: 051141

F.2 - Technical data

1) General data

- Voltage: see serial tag
- Current: see serial tag
- Connected load
  Motor: 1.1 kW
- RPM: see serial tag

Important: Provide a 16 A mains backup fuse.

2) Weight and measurements

- Weight: m= 37 kg
- Dimensions: H= 966 mm, W= 600 mm, D= 531 mm

3) Max. work piece thickness

- drilling only 45 mm
- Insertion depending on the fitting max. 20 mm max. 32 mm

4) Max. drilling distance

- Drilling distance centre spindle: 0 - 70 mm

5) Max. drilling diameter

- Max. drilling diameter 45 mm

6) Accessories

- For accessories see BLUM complete catalogue
1.1 - Unpacking and assembly

1.1.1) Assembly machine space requirement

\[ H = 966 \text{ mm} \]
\[ B = 600 \text{ mm} \]
\[ T = 531 \text{ mm} \]

- Completely loosen bottom knurled screw

ATTENTION:
To lift assembly machine only use hitch and load pick up device!

1.1.2) Unpacking assembly machine and attaching to a suitable table

- Open box
- Use two people to lift the assembly machine onto the work table

ATTENTION:
The assembly machine weighs approx. 37 kg.
The table must be of sufficient stability to accommodate this
- Pre-drill holes and then attach assembly machine [\[ \text{[1]} \] using the proper screws.
- The assembly machine should not be set up in a moist environment. The area must be dry.

1.1.3) Positioning [\[ \text{[2]} \] base ruler

- Place ruler on fixing
- Centre ruler drilling with the drilling of the runner plate
- Clamp ruler
1 - Assembly machine setup

1.1.4) Attaching swivel stops (optional)

- Loosen clamping screw until the location plate protrudes 10 mm
- Attach swivel stop to ruler at an angle and stand upright
- Tighten clamping screw

**Note:**
This procedure can also be used to set a stop between two available stops.

1.1.5) Attaching work table

a) Accessory work table reference MZA.5200
- Set work table on runner plate
- Attach work table to runner plate

b) Above table is not supplied with machine unless ordered separately. For details of how to construct a work table, see Chapter 7 - Appendix

1.3 - Electrical connection

1.3.1) Electrical connection

- The assembly machine comes with a connector. If this is not suitable, an adapter must be used.

**Important:**
The assembly machine is designed for the voltage printed on the label of the connection cable.
For use with other assembly machine operating voltages, see Chapter 8 - Diagrams

1.4 - Dust extraction

1.4.1) Connecting extraction system to the assembly machine

**ATTENTION:**
The machine must be connected to a dust extraction system!

- Insert the spiral hose with an inside diameter of 80 mm into the receiving tube and fix it.
- Make sure that the average air velocity for the extraction system is at least 20 m/sec.
- If there is no extraction system connector with a diameter of 80 mm, the supplied adapter can be used. For connection, make sure that a minimum air velocity of 20 m/sec is provided at the cross-section of the 80 mm hose.
2 - Assembly

2.1 - Furniture hinge assembly

2.1.1) Required parts

- Drill bits:
  1x ø 35 mm clockwise [2.1] (marked in black)
  2x ø 8 mm counterclockwise [2.2] (marked in red)
- Cover caps [2.3]
- Insertion ram MZM.00XX [2.4] (see catalogue to determine the proper insertion ram for the respective furniture hinge)
- Furniture hinge

Important:
All drill bits must be the same length

2.1.2) Setting drill bit length

- The total length of the drill bits (from bit-tip to adjustment screw) should be 57 mm
- To correct drill bit length, adjust screw accordingly using a screwdriver

2.1.3) Setting drilling pattern

- Pull sprung loaded knob out [2.5]
- At the same time, move the lever [2.6] to the “Furniture hinge” symbol [2.7]
- Release knob back to original position [2.5]

2.1.4) Inserting drill bits

- Disconnect assembly machine from the power supply
- Push drill bits all the way into the chuck (The flat on the drill shank must be aligned with the fixing screw)
- Use a hex wrench to tighten the fixing screws
- Insert cover caps into the unused chucks [2.3]. This will keep the chucks clean and prevent the fixing screws from shaking loose.

2.1.5) Setting drilling depth

- Set drilling depth using the bottom knurled screw [2.10]
  (One turn equals 1.5 mm)
- Secure the bottom knurled screw [2.10] (lock)
2.1.6) Drilling depth stop

Another option to maintain a constant drilling depth is to install the drilling depth stop. When the drilling depth stop is installed, the drilling depth is always 13 mm regardless of the thickness of the workpiece.

Installing the drilling depth stop:
- Disconnect assembly machine from the power supply
- Remove drill
- Push drilling depth stop into the locking holes of the retainer ring until it engages and turn 90 degrees with force.
- Attach drill bit

IMPORTANT:
The drill bit length must be set to 57 mm. (See point 2.1.2). The knurled screw should not jut out before the drilling depth is reached. (See point 2.1.5)

2.1.7) Setting the stop system

- Loosen the clamping lever
- Remove locking pin and set gauge to the MB.
- Secure the clamping lever

This fixed setting provides a drilling distance of 22.5 mm.
2.1.8) Setting swivel stops (optional) (1.7)

Set the swivel stops (1.7) to the desired dimension and clamp.

**IMPORTANT:**
Indicator edge is on the inside of the swivel part.

2.1.9) Placing door on the work table and pushing up against the stop

**IMPORTANT:**
The stop surface can be enlarged by swivelling the stop flap forward for grooved work pieces and work pieces with radii (see picture).

2.1.10) Attaching insertion ram to swing arm (2.8)

- Place insertion ram on to the two fixing screws (2.20) on the swing arm (2.8).
- Tighten the screws so that the insertion ram is secure.

2.1.11) Clipping furniture hinge on to the insertion ram
2.1.12) Drilling

ATTENTION:
All items except for the work piece should be removed from the work area of the assembly machine. Keep your hands out of work area (A).

• Swing arm (2.8) must be swivelled up.
• Hold down door outside of danger area (A) and press against the swivel stop (17/).
• Push handle down
• Press motor button
• Drill until the correct depth is reached
• Release motor button

2.1.13) Checking the tilt adjustment of the swing arm (2.8)

• Swivel down swing arm (2.8) to the stop.
• Check whether or not the furniture hinge is aligned with the drilling.
• If it is misaligned, this can be caused by two things:
  a) Swivel arm (2.8) is not set vertical.
     - Use the screw to correct this setting (2.21)
  b) Insertion ram is off-centre:
     - Correct this setting using the adjustment screws (2.22) on the insertion ram.

2.1.14) Inserting the furniture hinge

ATTENTION:
Keep your hands and other objects away from assembly machine work area (A)

• Swivel down swing arm (2.8)
• Push handle down to insert hinge into door.
• Swivel up swing arm (2.8)
• Remove door from the work table or push to the next stop (17/).
3 - Assembly

3.1 - Cruciform mounting plate assembly

3.1.1) Required parts
• Drill bits:
  1 x ø5 mm clockwise 3.1 (marked in black)
  1 x ø5 mm counterclockwise 3.2 (marked in red)
• Cover caps 2.3
• Carcase side
• Cruciform mounting plate with system screws

3.1.2) Setting drill bit length (see point 2.1.2)

3.1.3) Setting drilling pattern
• Pull sprung loaded knob out 2.5.
• At the same time, move the lever 2.6 to the “Hole group” symbol 3.3.
• Release knob back to original position 2.5.

3.1.4) Installing drill bits into the chuck
(see point 2.1.4)

3.1.5) Checking drilling depth setting
(see points 2.1.5 / 2.1.6)

3.1.6) Setting the stop system 1.4
• Loosen the clamping lever 2.15.
• Remove locking pin 2.16 and set gauge 1.4 to SY.
• Secure the clamping lever 2.15.

This fixed setting provides a drilling distance of 37 mm.

3.1.7) Placing carcase side on the work table and pushing up against the stop
(See point 2.1.9)

3.1.8) Drilling
(See point 2.1.12)
4 - Assembly

4.1 - Drilling hole groups

4.1.1) Required parts
• Drill bits:
  1x ø 5 mm clockwise [4.1] (marked in black)
  2x ø 5 mm counterclockwise [4.2] (marked in red)
• Cover caps [2.3]
• Setup gauge [4.3]
• Carcase side

4.1.2) Setting drill bit length
(See point 2.1.2)

4.1.3) Setting drilling pattern
• Pull sprung loaded knob out [2.5].
• At the same time, move the lever [2.6] to symbol [3.3].
• Release knob back to original position [2.5].

4.1.4) Inserting drill bits into the chuck
(See point 2.1.4)

4.1.5) Checking drilling depth setting
(see points 2.1.5 / 2.1.6)

4.1.6) Setting stop system [1.4]
• Loosen the clamping lever [2.15].
• Remove locking pin [2.16] and set gauge [1.4] to SY.
• Secure the clamping lever [2.15].

This fixed setting provides a drilling distance of 37 mm.

4.1.7) Setting the swivel stops [1.7]
(See point 2.1.8)

4.1.8) Drilling hole groups
• Place setup gauge [1.5] on the stop that has already been set [1.7] and set an additional stop.

This results in a 6 hole group with a 32 mm hole spacing.

4.1.9) Placing carcase side on the work table and pushing up against the stop
(See point 2.1.9)

4.1.10) Drilling
(See point 2.1.12)
5.1 - Maintenance

5.1.1) Maintenance

- Drilling dust should be removed from the assembly machine on a regular basis
- Electrical lines should always be checked for damage before the machine is used
- The supports are maintenance free and should not be oiled
- The guide elements [5.2] must be cleaned regularly with a dry cloth to remove dust. (Do not use cleaners or solvents)

5.1.2) Damaged coupling (clutch)

The coupling is damaged if:
- The drill is jammed in the work piece but the motor fan wheel continues [1.9] to turn.

⚠️ Keep your hands and other objects away from machine work area (A)

- Disconnect assembly machine from the power supply
- Remove drill
- Remove motor hood
- Loosen the motor's four side fixing screws [5.4], (approx. 4 full turns)
- Lift up motor and place on to the drive

⚠️ Secure the motor against falling

- Remove dampening ring [5.5]
- Remove old coupling [5.6]
- Attach replacement coupling [5.6] on to the spindle. (ensure correct positioning of coupling and spindle)
- Insert dampening ring [5.5]
- Preposition coupling base for motor attachment
- Attach motor (motor must sit securely on the flange)
- Re-secure the motor's four side fixing screws [5.4]
- Re-attach motor hood
### 6.1 - Error during drilling

<table>
<thead>
<tr>
<th>Error</th>
<th>Cause</th>
<th>Solution</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drilled holes too large, oval or ragged</td>
<td>Drill diameter is too large</td>
<td>Check drill</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Drills are twisted</td>
<td>Replace drill</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Drilling speed is too high</td>
<td>Pull handle down slower</td>
<td>See point 2.1.12</td>
</tr>
<tr>
<td></td>
<td>Drilling through work pieces</td>
<td>Use roof tip drill bit to drill through</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Drive shafts are bent, e.g. supports are defective</td>
<td>Replace gearbox</td>
<td>none</td>
</tr>
<tr>
<td>Drill blockage in wood</td>
<td>Improper material has been drilled</td>
<td>Only use work pieces made from wood, particle board or plastic coated wood</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Drilling speed is too high</td>
<td>Pull handle down slower</td>
<td>See point 2.1.12</td>
</tr>
<tr>
<td></td>
<td>Coupling (clutch) broken (motor runs, drill blockage in wood)</td>
<td>Replace defective Coupling (clutch)</td>
<td>See point 5.1.2</td>
</tr>
<tr>
<td></td>
<td>Drills are dull</td>
<td>Repoint drills or replace</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Drill rotation not set properly</td>
<td>Install left hand drill bits into chucks marked in red and right hand drill bits into chucks marked in black</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Assembly machine connected to the wrong voltage</td>
<td>Check mains voltage and compare with motor data. Have checked by authorised electrician</td>
<td>See chapter 8 - Diagrams</td>
</tr>
<tr>
<td>Drill bits cannot be gripped in the chucks</td>
<td>Drill bits full of chips</td>
<td>Clean drill chuck</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Use cover caps</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Drill shaft diameter too large or damaged</td>
<td>Repoint drill shaft or replace</td>
<td>none</td>
</tr>
</tbody>
</table>
### 6.1 - Error during drilling

<table>
<thead>
<tr>
<th>Error</th>
<th>Cause</th>
<th>Solution</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drilling depth does not match</td>
<td>Drilling depth set incorrectly</td>
<td>Correct drilling depth setting</td>
<td>See point 2.1.5</td>
</tr>
<tr>
<td></td>
<td>Drilling length does not match</td>
<td>Drilling length set to 57 mm</td>
<td>See point 2.1.2</td>
</tr>
<tr>
<td></td>
<td>Drill bits not completely pushed into the chuck</td>
<td>Clean dirt from chuck and completely insert drill bit</td>
<td>See chapter 2</td>
</tr>
<tr>
<td></td>
<td>Work piece thickness does not correspond to the given value (e.g. 15 mm instead of 16 mm)</td>
<td>Check work piece thickness, correct drilling depth setting, use drill depth stop</td>
<td>See chapter 2</td>
</tr>
<tr>
<td></td>
<td>Assembly machine is driving against an object (e.g. swivel stop)</td>
<td>Remove object</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Feed switch was released before the drilling depth was reached</td>
<td>Keep feed switch engaged until the drilling depth has been reached</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Work table height (thickness)</td>
<td>Put work table underneath until a height of 24 mm has been reached</td>
<td>See chapter 7 - Appendix</td>
</tr>
<tr>
<td></td>
<td>The swivel stops were not set properly on the ruler.</td>
<td>Check positions and stops and correct if necessary</td>
<td>none</td>
</tr>
<tr>
<td>Drillings are off centre or in the wrong position</td>
<td>Ruler not set properly</td>
<td>Set ruler to the 0 point</td>
<td>See point 1.1.3</td>
</tr>
<tr>
<td></td>
<td>Chips between the ruler and the work piece</td>
<td>Remove dirt and chips</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Extension ruler is not attached properly</td>
<td>Check ruler attachments and extension - check spacing of both rulers</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Swivel gear not engaged</td>
<td>Allow index bolts to engage</td>
<td>See point 2.1.3</td>
</tr>
</tbody>
</table>
# 6 - Troubleshooting

## 6.2 - Fitting insertion error

<table>
<thead>
<tr>
<th>Error</th>
<th>Cause</th>
<th>Solution</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fittings cannot be inserted or only with great difficulty</td>
<td>Insertion ram or swing arm is driving against an object (e.g. swivel stop)</td>
<td>Remove object</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>The surface of the work piece is too hard</td>
<td>Bevel drillings</td>
<td>Use slip-on countersink</td>
</tr>
<tr>
<td></td>
<td>Drillings are not deep enough</td>
<td>See point “Drilling depth not reached”</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>The drilling diameters are too small</td>
<td>Check drill bits and replace if necessary</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>The insertion ram has shifted or turned</td>
<td>Set insertion ram</td>
<td>See point 2.1.10</td>
</tr>
<tr>
<td></td>
<td>Drill chips are in the drill holes</td>
<td>Remove chips from drillings</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Swing arm is not set properly</td>
<td>Check swing arm setting</td>
<td>See point 2.1.13</td>
</tr>
</tbody>
</table>
## 6.3 - Function errors

<table>
<thead>
<tr>
<th>Error</th>
<th>Cause</th>
<th>Solution</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor does not run</td>
<td>Assembly machine is not connected to the power supply</td>
<td>Connect assembly machine to the power supply</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Building fuse has failed</td>
<td>Reset fuse or replace</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Swing arm is swivelled down</td>
<td>Swivel up swing arm</td>
<td>See point 2.1.12</td>
</tr>
<tr>
<td></td>
<td>Assembly machine connected to the wrong voltage</td>
<td>Check mains voltage and compare with motor data. Have checked by authorised electrician</td>
<td>See electrical diagram</td>
</tr>
<tr>
<td></td>
<td>Motor defective</td>
<td>Have motor replaced by an authorised electrician</td>
<td>none</td>
</tr>
<tr>
<td>Motor overheats</td>
<td>Assembly machine connected to the wrong voltage</td>
<td>Check mains voltage and compare with motor data. Have checked by authorised electrician</td>
<td>See electrical diagram</td>
</tr>
<tr>
<td></td>
<td>Drilling in hard wood with too high a speed</td>
<td>Pull handle down slower</td>
<td>none</td>
</tr>
<tr>
<td></td>
<td>Motor hood is dirty or covered by something</td>
<td>Remove objects and chips in the area of the motor hood</td>
<td>none</td>
</tr>
<tr>
<td>Gearbox defective</td>
<td>Support, spindles or gears are damaged</td>
<td>Replace gearbox</td>
<td>none</td>
</tr>
</tbody>
</table>
7.1 – User-supplied work table

- If you are making your own work table, use plywood or laminated wood for the support plate.
- In addition, please use the screws supplied for fixing the work table.
8.1 - Electrical diagram 1x 230 V 50 Hz

S1: 6791950  M52.080M01 SCHALTER GR
3823020  STECKER 2P SCHUKO LANG GI  1 ST
9054970  TASTE/R MP+M KOMPL
9054730  M52.080V02 GEH+ZUT R204

1x 230 V 50 Hz

L1  braun - brown
N  blau - blue
PE  gelb/grün - yellow/green

1x 230 V 50 Hz

C  60 % ED,
5.0 A, 1.1 kW, 2830 Upm,
25μF 400V08

M1