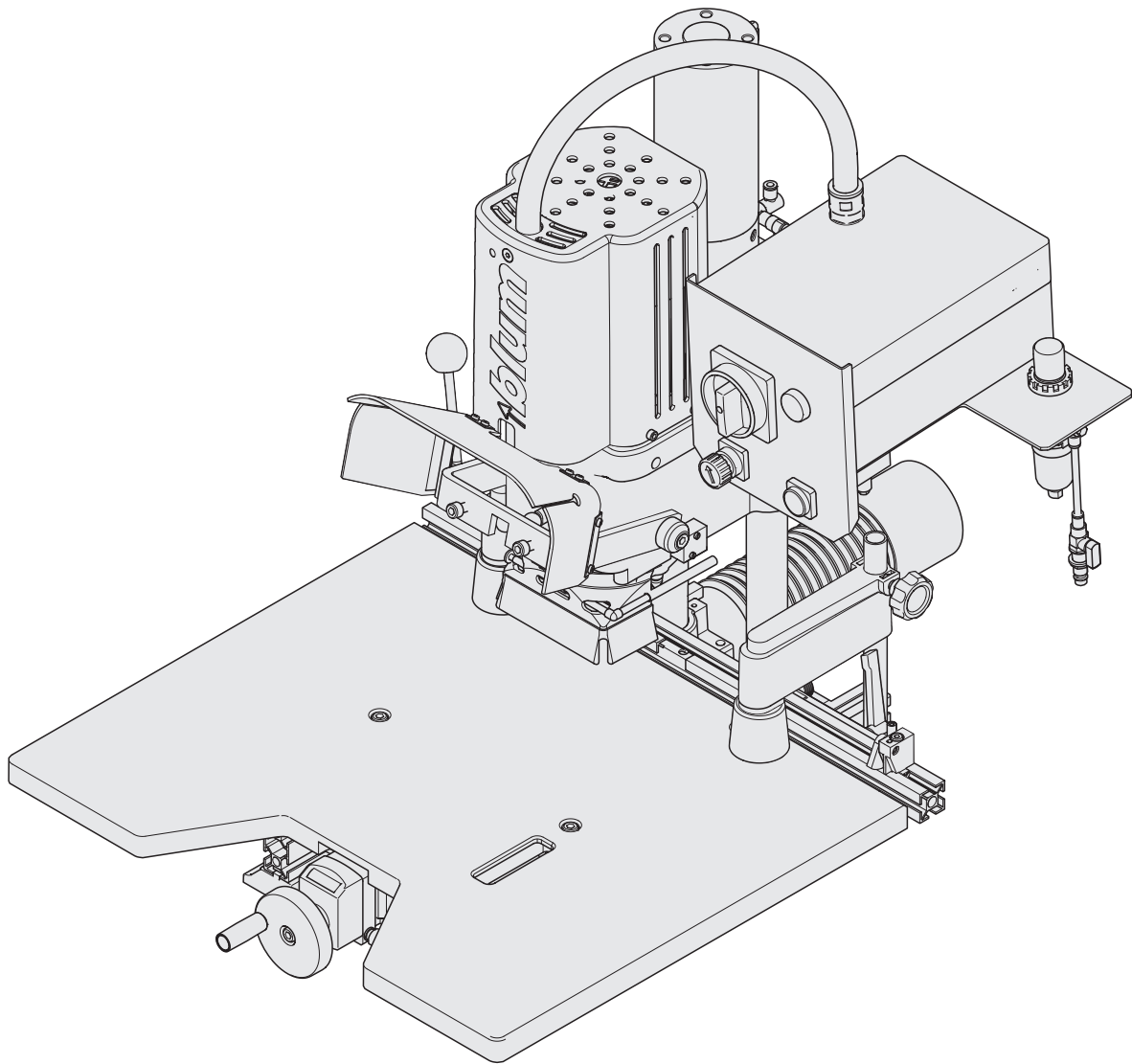




Ensure that the instructions have been fully read and understood before operating the assembly machine. Only properly trained and authorised personnel may operate the assembly machine.

The instruction leaflet must be accessible at all times.

MINIPRESS P

Safety instructions, set-up instructions and
instruction leaflet

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3	Intended use
4	Risk levels
4	Safety information
6	Warning signs
7	Reference diagrams
13	Explanation of operating and control elements
14	Start-up
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34	Drilling and insertion
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49	Diagrams

These instructions are valid for several assembly machines.
Not every assembly machine has the same range of functions displayed.

Handling

- Please read the instruction leaflet and the safety information before start-up of the assembly machine.
- We recommend that you use the reference diagrams to make it easier to identify the parts being described.

Safety principle

The assembly machine complies with current safety standards. Nevertheless, there will still be certain residual risks if the information contained in this instruction leaflet is not observed.

Residual risk according to EN ISO 12100:2010

- The assembly machine is equipped with all the necessary protection features.
- However, there will still be some residual risks for the user, particularly when removing the safety equipment or when control units fail.
- Other residual risks are identified by warning signs and safety information. It is therefore necessary to observe the safety information.

Intended use

The designated purpose of the assembly machine is the drilling and insertion of furniture fittings into workpieces made of wood, particle board or epoxy coated wood.

- The assembly machine may only be operated by fully-trained personnel.
- The assembly machine may only be used in skilled OEM and distribution applications.
- The device should only be installed in dry, enclosed rooms.
- The assembly machine is only intended for stationary operation.
- Only original Blum tools may be used.
- Coated and/or reflective workpieces may not be used.
- No liability can be accepted for any other use.

Foreseeable misuse

- No metal or aluminium frames may be drilled.
- Only drilling heads with a safety shield may be used.

Safety

Areas of responsibility

The operator

- must ensure that only fully-trained personnel, who have read and understood the instruction leaflet, especially the chapter on safety, operate and service the assembly machine.
- is responsible for the safety-related condition of the assembly machine.
- will take the assembly machine out of service immediately when faults are discovered that affect safety.

Risk levels



WARNING

- WARNING indicates a danger that could lead to serious injury if not avoided.



CAUTION

- CAUTION indicates a danger that could lead to injury if not avoided.



NOTE

- This NOTE symbol indicates information that should be observed.

Safety information



WARNING

Serious cut injuries. Caution, danger of being crushed! Failure to heed this warning may result in personal injury.

- Always disconnect the assembly machine from the power supply and the pressurised air system before all cleaning and maintenance work.

Operation

- The assembly machine is designed to only be operated by one person.
- The assembly machine is only intended for stationary operation.

Installation

- Ensure there is sufficient lighting.
- Only attach the assembly machine to a sufficiently stable table.
Load bearing capacity: minimum 250 kg. Height 850 mm (+/- 50 mm).
- The assembly machine may not be operated without the work table.
- The assembly machine is not explosion-proof. It should not be set up near painting facilities.
- The assembly machine is not suitable for operation in an open environment.

Protection equipment

- Do not make any changes or alterations to the assembly machine.
- Protection equipment must not be removed.
- Before starting work, before any shift change or change of personnel, you should check that the protection equipment and machine parts are functioning properly. Any damaged parts should be replaced by original parts from Blum.
- Only drilling heads with a safety shield may be used.

Tools

- Only use sharp, clean drill bits. Attach drill bits securely.
Always check that the drill bit is secure before start-up.
- Observe the direction of rotation of the drill bits. Maximum diameter 35 mm
- When changing the drill bit, always unclamp the drilling head.
Main switch [27] to the "0" position.
- For your own safety, only use those accessories and additional devices which are recommended or indicated in the instruction leaflet or Blum catalogue.
- Only Blum drilling heads may be used.

Workpiece

- Particular care must be taken when working on sections that jut out over the work table. Use additional supports.
- Secure the workpiece during drilling/insertion. Use the assembly machine hold down clamps or, if these are not sufficient for the particular job, use suitable clamping equipment.
- Make sure that no other tools or objects are on the work table aside from your workpiece before turning on the assembly machine.

Operation

- When you release the feed switch [28], the drill bit will continue to run, you must wait until it comes to a stop.
- Keep your hands and other objects away from the assembly machine work area (A) during drilling and knocking-in.
- Only operate the assembly machine with the extraction system switched on.
- The negative pressure in the extraction system must be 250–300 mbar.
- Ensure that the average air velocity for the extraction system is at least 20 m/sec.
- Always turn the main switch to the "0" position after finishing work.

Repair and maintenance

- If there are any questions, please contact the BLUM Customer Service Department.
- Only an electrician may make the connection to the electrical grid.
- Every time before starting work, check the electrical cable and the pneumatic hoses for damage.
- Repairs may only be performed by authorised personnel.

Personal protective equipment

- All national regulations regarding labour law, industrial safety as well as all disposal guidelines must be followed.
- Wear eye protection.
- Wear ear protection.
- Wear appropriate work clothing.

Warning signs



Before connecting the assembly machine to the power supply, you must ensure that you have understood ALL the safety instructions, warning signs and the instruction leaflet.



Keep unauthorised persons away from the assembly machine. Only **1** person at a time should operate the assembly machine.



Always wear eye protection when operating this machine.



Always wear ear protection when operating this machine.



Caution, danger of being crushed!



Do not lift here.



Do not touch the drill bit.



Caution, voltage - danger of shock.

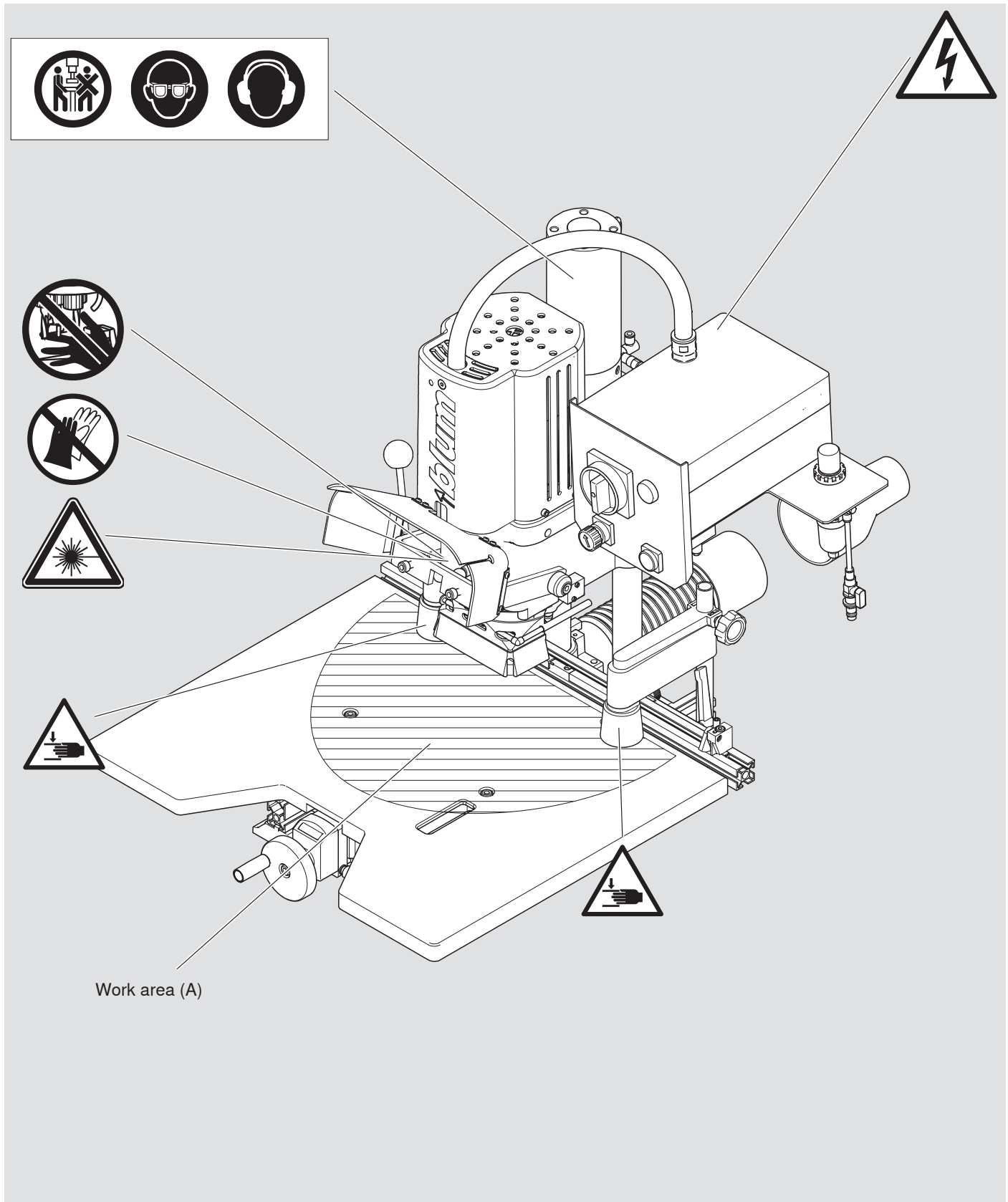


Do not work with gloves.



Do not look into the laser beam.

Position of warning signs and danger zones



MINIPRESS P



Safety

Position of the rating plate

Rating plate: MINIPRESS P [A]

Device type: drilling and insertion machine

MINIPRESS P



Ref. No.: M53.1000.01

SN: xx 12345-8

Julius Blum GmbH

6973 Hoechst

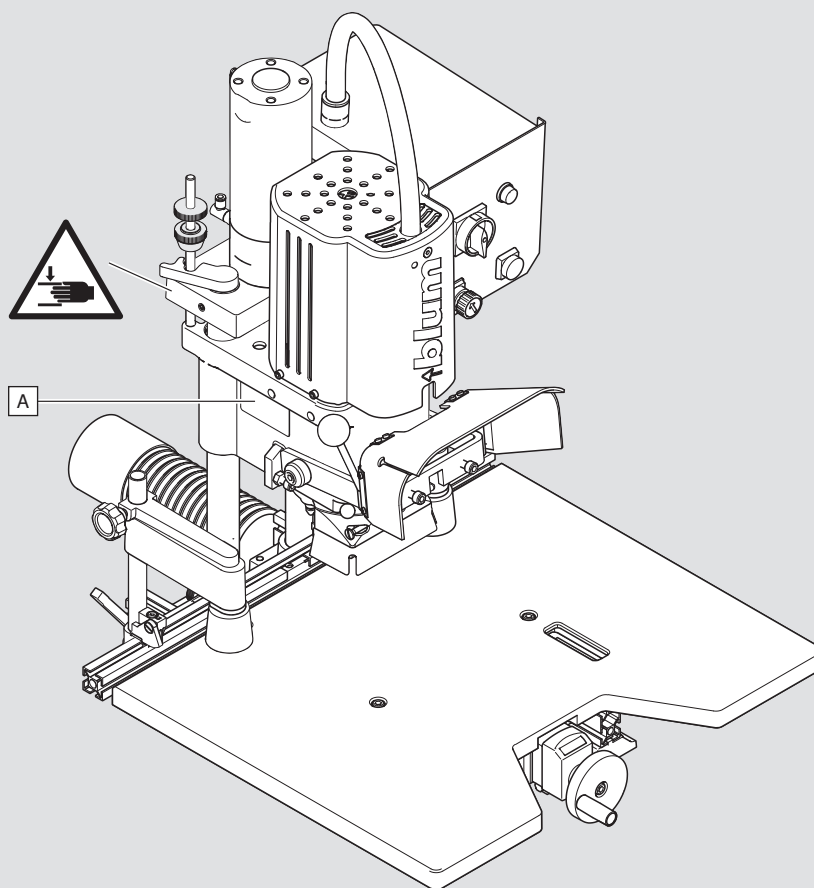
Industriestrasse 1

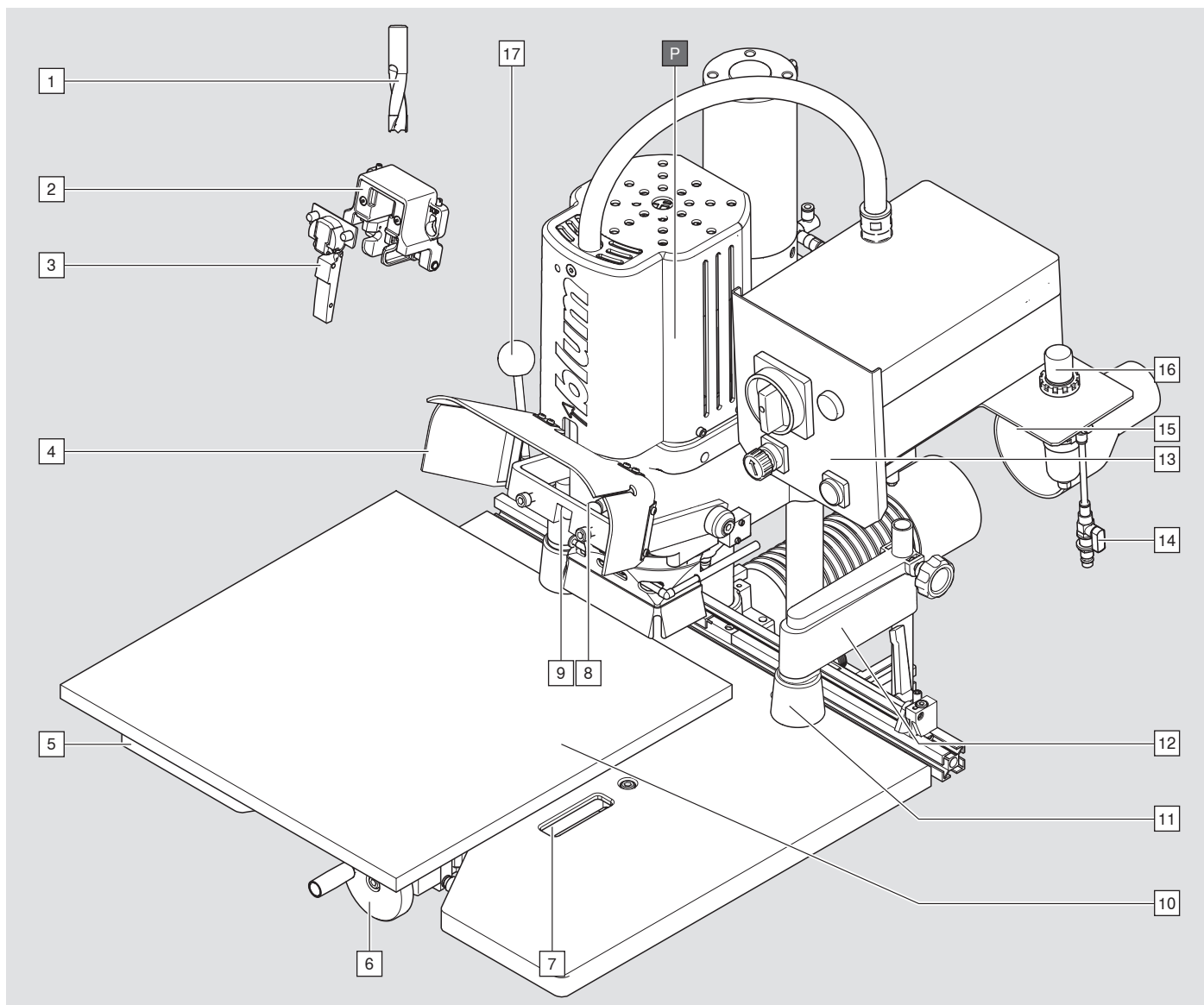
Austria

Made in Austria

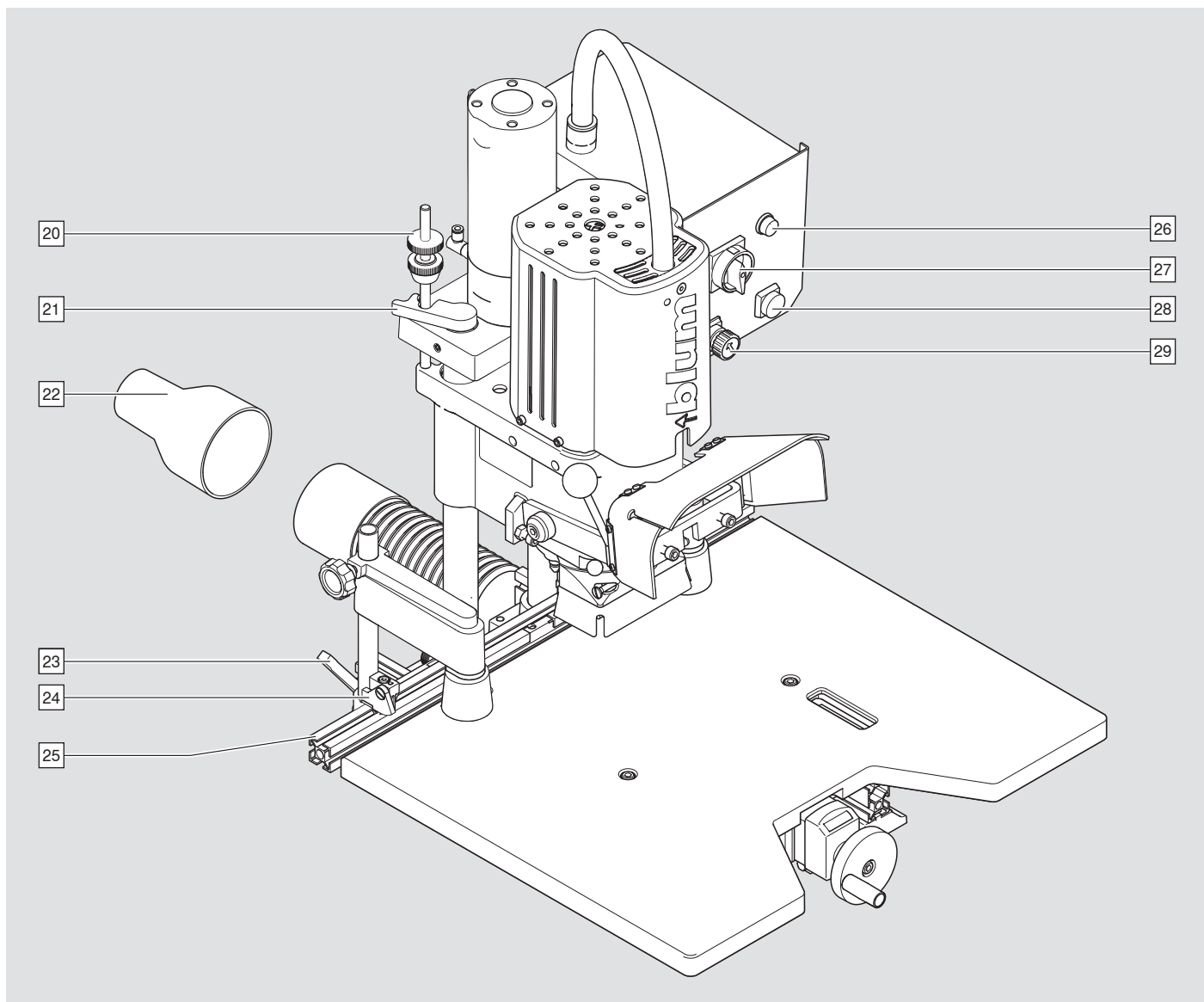


Illustration

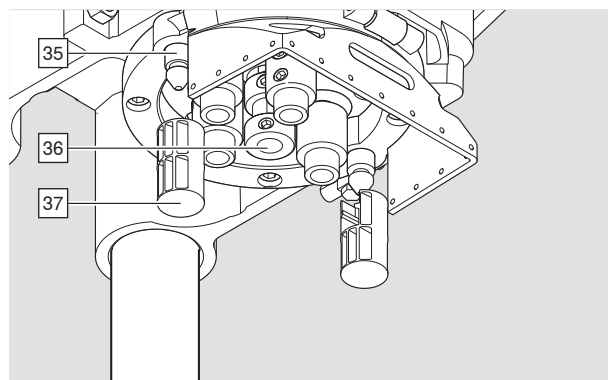




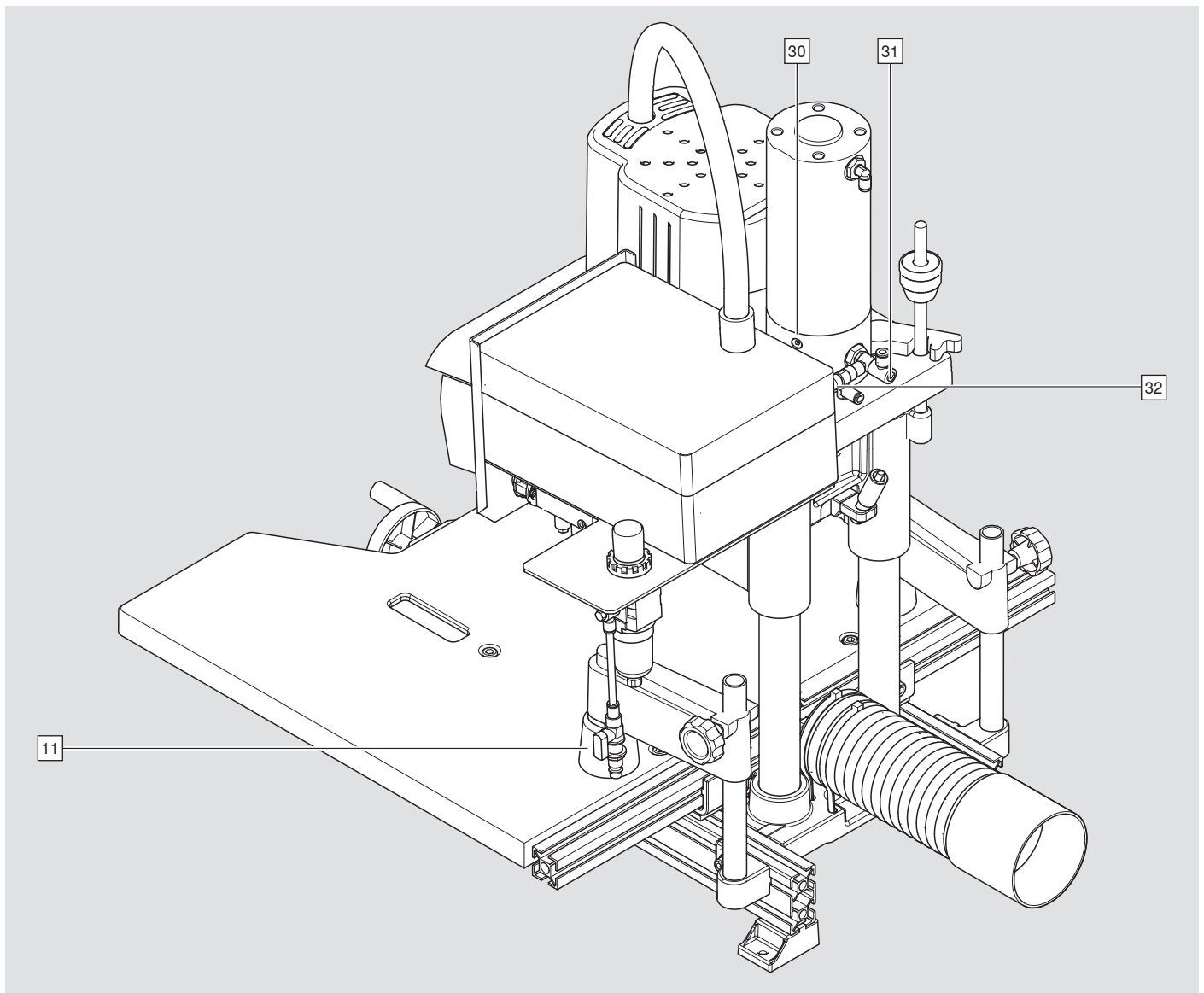
- | | |
|--------------------------------|----------------------------------|
| 1 Drill bit | 13 Operator panel |
| 2 Insertion ram | 14 Compressed air shut-off valve |
| 3 Hinge | 15 Pressure gauge |
| 4 Swing arm | 16 Filter air pressure regulator |
| 5 Work table | 17 Insertion ram swivel lever |
| 6 Ruler system adjustment | |
| 7 Table adjustment scale | P Machine centre of gravity |
| 8 Drilling head fixing pin | |
| 9 Drilling pattern lever | |
| 10 Workpiece | |
| 11 Hold down clamp sight glass | |
| 12 Hold down clamp | |



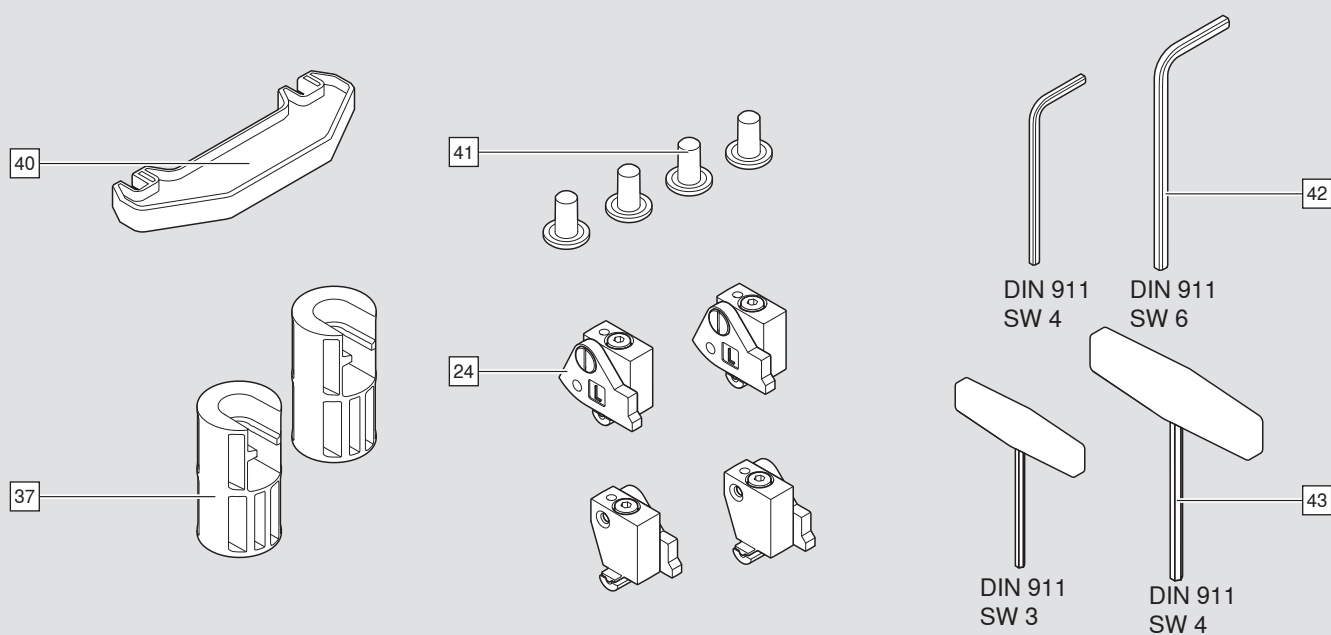
- 20 Knurled nut depth adjustment
- 21 Spacer swivel lever 13 mm
- 22 Funnel extraction system
- 23 Locking device (MZE.1300)
- 24 Swivel stop
- 25 Basic ruler
- 26 Operating mode display
- 27 Main switch
- 28 Feed switch
- 29 Hold down clamp selector switch



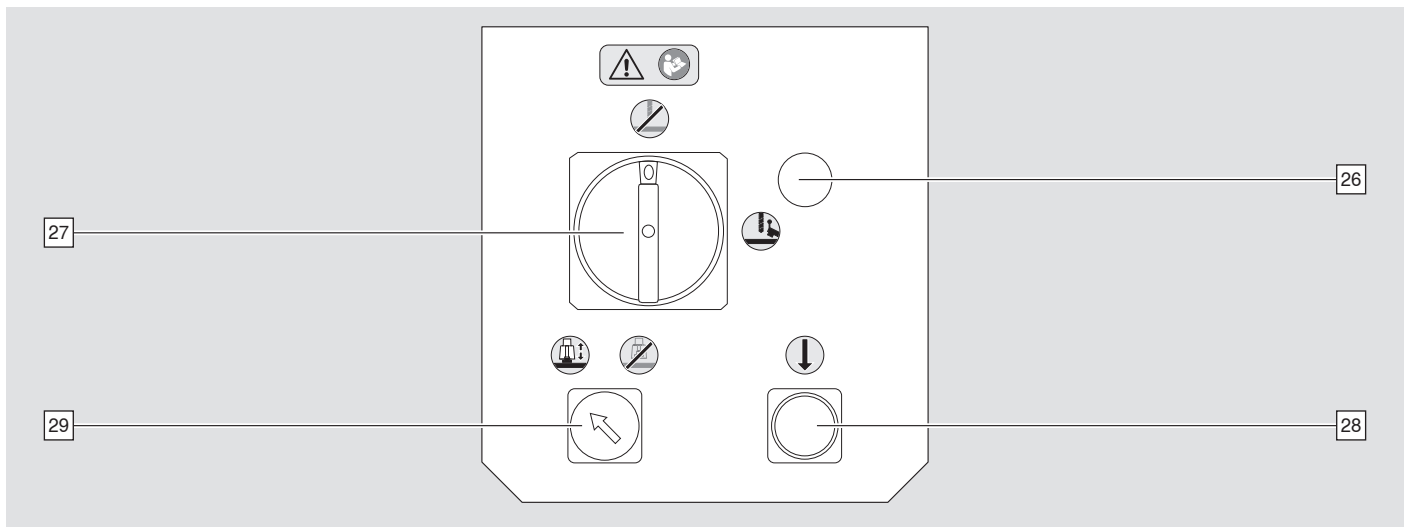
- 35 Pin
- 36 Chuck
- 37 Drilling depth stop M30.1304.02



- 11 Hold down clamp sight glass
- 30 Cam brake
- 31 Cylinder vent valve
- 32 Restrictor



- 24 Swivel stop
- 37 Drilling depth stop M30.1304.02
- 40 Distance template M30.0901
- 41 Cover caps
- 42 Hexagonal offset screwdriver
- 43 Hexagonal recess T-handle screwdriver



WARNING

Serious cut injuries.

Serious injuries are possible from crushing or shearing.

Failure to heed this warning may result in personal injury.

- Always disconnect the assembly machine from the power supply and the pressurised air system before all cleaning and maintenance work.
- The main switch [27] does not disconnect the assembly machine from the pressurised air system.



[27] Operating mode display [26] does not light up.

- Motor cannot be started
- Stroke movement can be carried out



[27] Operating mode display [26] lights up.

- Drilling and the fitting insertion can be carried out
- The marking line lights



[29] "Hold down clamps off" position:

Pressing and turning the clamp switch will turn off the hold down clamps.

When the feed switch [28] is pressed, the hold down clamps remain retracted.



[29] "Hold down clamps on" position:

Pressing the feed switch [28] automatically extends the hold down clamps. Briefly touching the hold down clamp selector switch [29] will disengage the clamps.



Pressing the feed switch [28] will carry out the work process.

If the feed switch [28] is only lightly pressed a few millimetres, the drill unit moves downwards very slowly. Press feed switch [28] until drilling depth is reached.

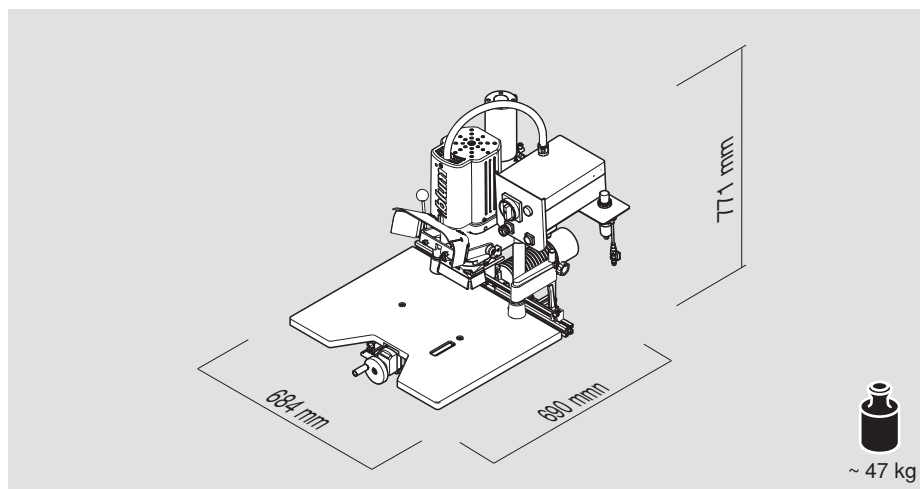
Once the drilling depth is reached, release the feed switch [28].

MINIPRESS P

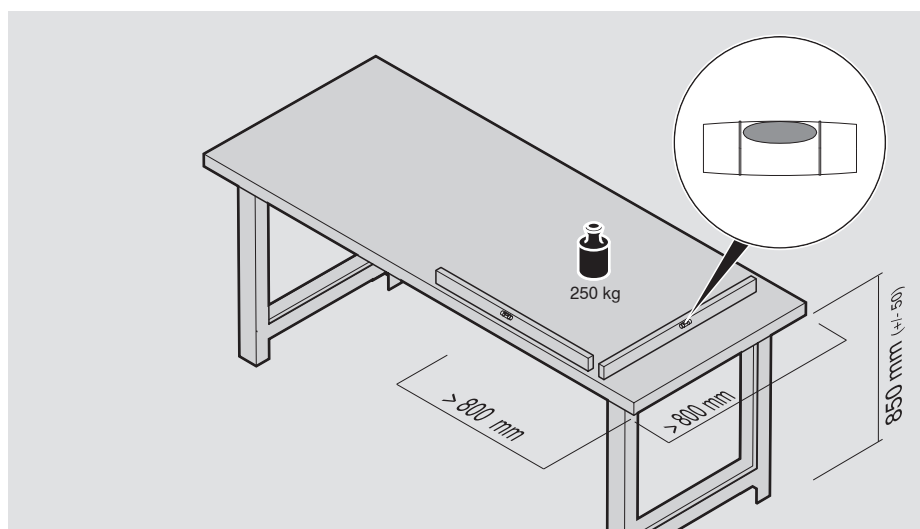


Start-up

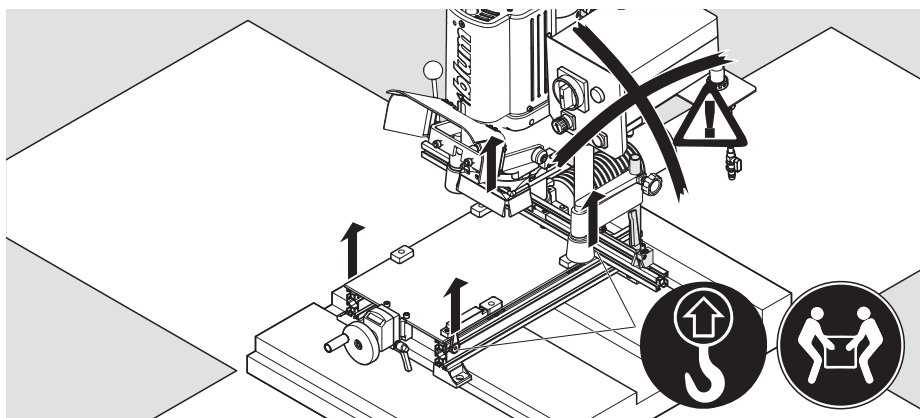
Assembly machine space requirement



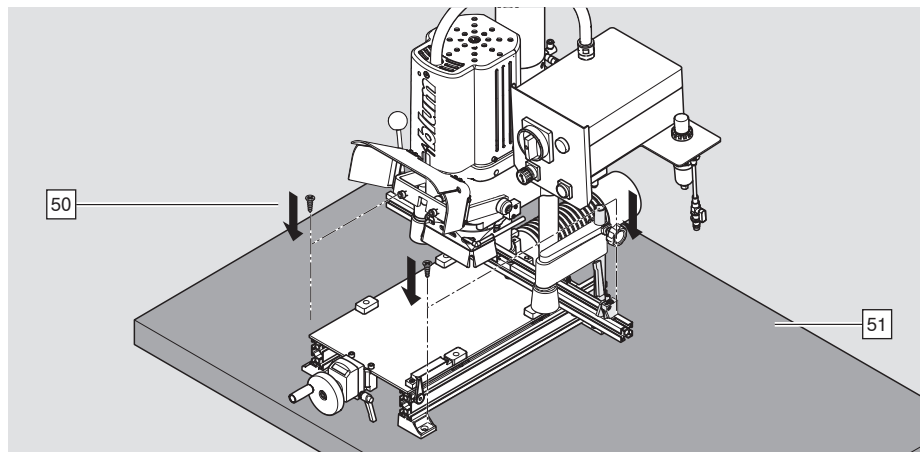
- Space requirement with EASYSTICK, see chapter "Additional information"



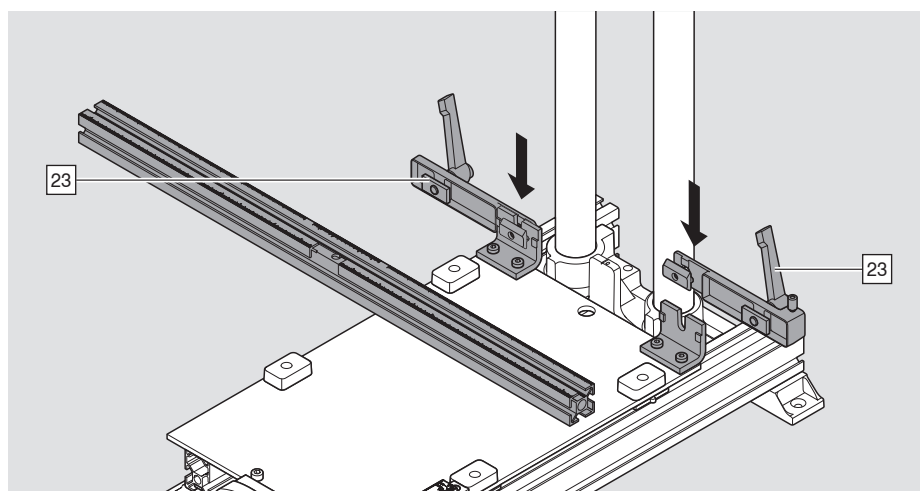
Unpacking and assembly



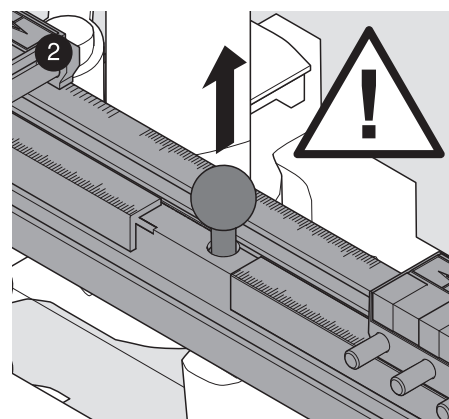
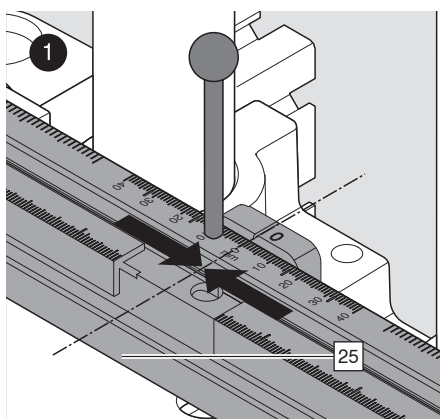
- Open box.
- Use two people to lift the assembly machine onto the table.



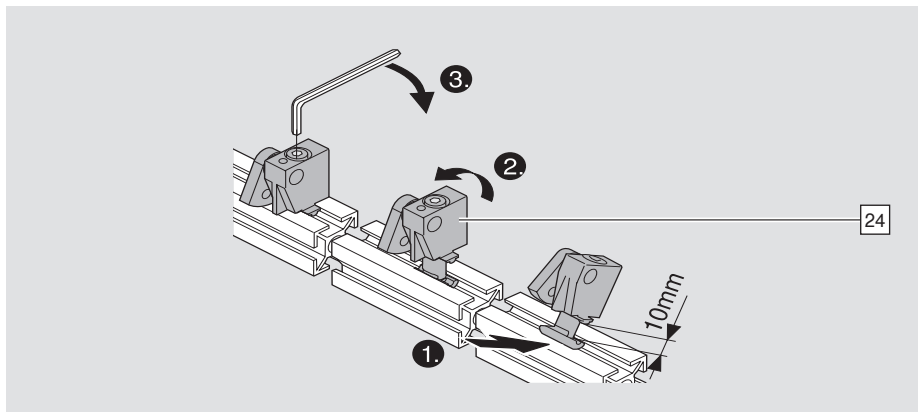
- Secure the assembly machine to the workbench [51] with screws [50].



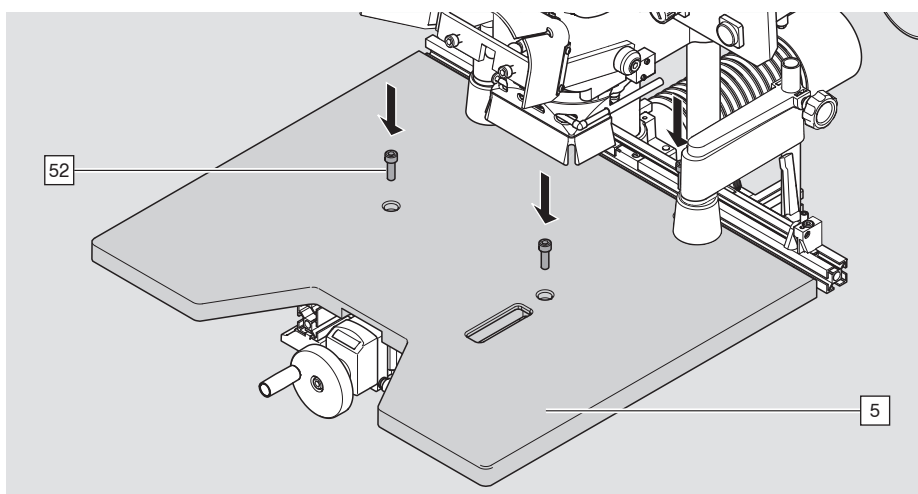
- Assembly of the package [23] MZE.1300 (optional accessory) according to the enclosed installation instructions BA-119.



- Place the basic ruler [25] in the middle.
- The EASYSTICK can also be mounted.



- Loosen the clamping screw until the counter plate protrudes 10 mm.
- Attach the swivel stop [24] to the ruler at an angle and stand upright.
- Tighten the clamping screw.



i NOTE

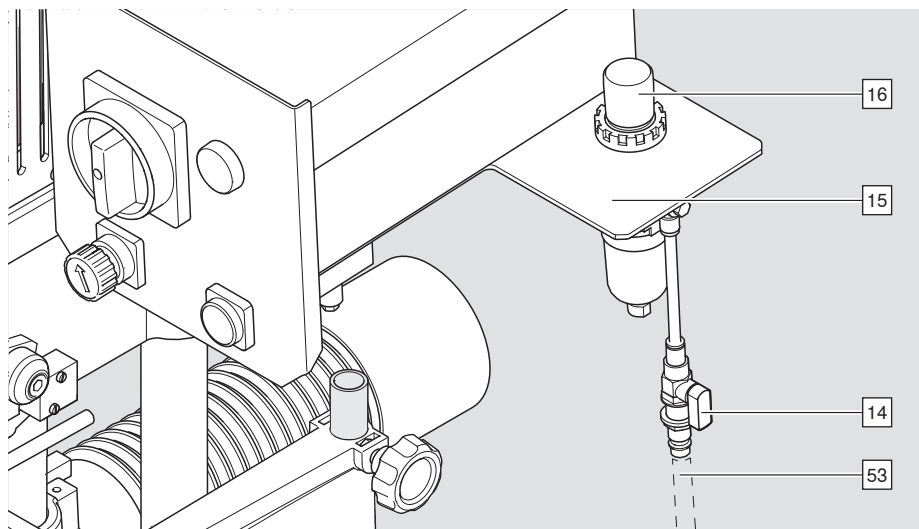
- The assembly machine must not be operated without the work table [5]. The work table [5] must be securely fastened to the assembly machine using the included fixing screws [52].

Accessory work table MZA.5300 table.

- Place work table [5] on runner plate.
- Bolt work table [5] to runner plate.

User-supplied work table [5], see chapter "Additional information".

Connecting the pressurised air system



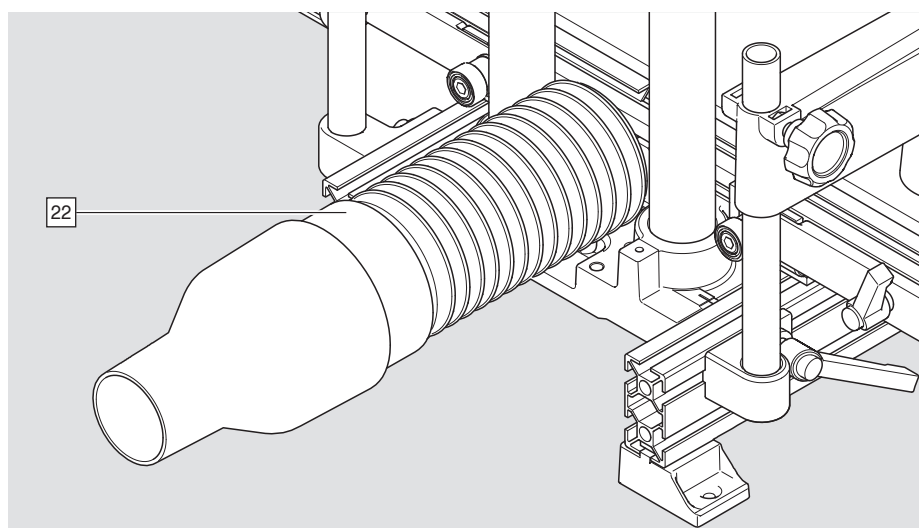
i NOTE

- During the following procedure, the drill unit can move.
- Only oil-free pressurised air may be used.
- A quick-release coupling must be inserted max. 3 m from the machine in the compressed air supply line.

- Connect the air supply [53] to the air filter unit.
- Open the compressed air shut-off valve [14].
- The pressure indicated on the pressure gauge [15] must show 5 - 7 bar / 73 - 101 psi / 0.5 - 0.7 MPa .
- The pressure can be set using the revolving handle [16].

Air consumption per work cycle is 1.5 litres.

Connecting the extraction system



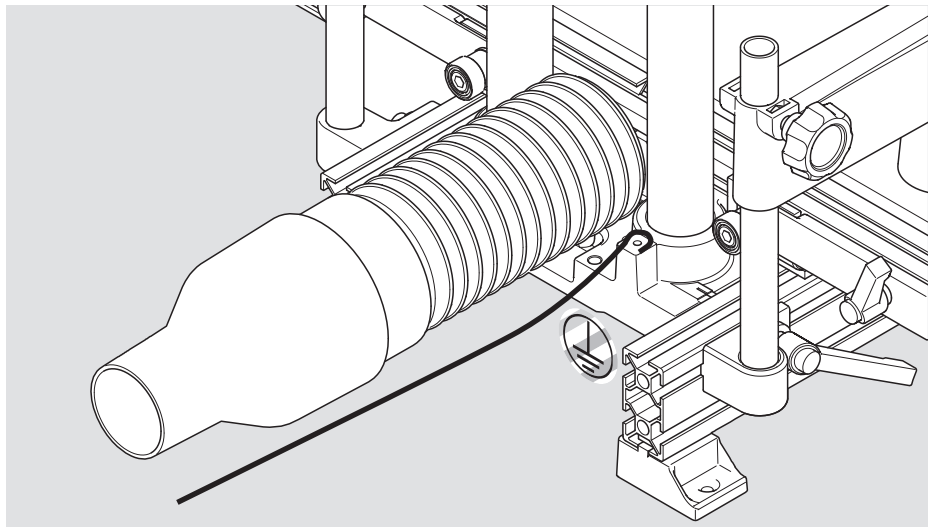
- Insert the extraction hose into the extraction socket [22] and secure it.
- Accessories, see www.blum.com

Start-up

i NOTE

- Ensure that the average air velocity for the extraction system is at least 20 m/sec.
- The negative pressure should be 250 - 300 mbar.
- Volume flow 570 m³/h.

Earthing the extraction system



- Connect the spiral wire of the suction hose to the assembly machine.

Connecting the power supply

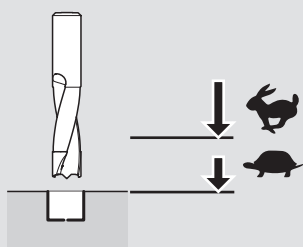
- Set main switch [27] to Pos. "0".

i NOTE

- The assembly machine is designed for the voltage listed on the rating plate and cable label.
- The outlet must be fitted with a PE protective contact.
- The outlet must be fitted with a neutral conductor.
- The outlet must have a 16 A overcurrent protection.
- After finishing work, disconnect the assembly machine from the power supply.
- Avoid overloading the outlet.
- Do not use the assembly machine together with an extension lead or cable drum.
- Use a separate protected outlet for the extraction system and the assembly machine.

- Insert the electrical plug.
- If the direction of rotation of the motor is not correct, see chapter "Troubleshooting".

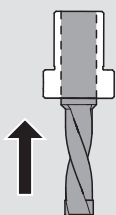
Overview of setup



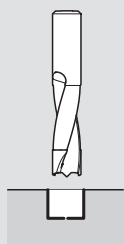
Material-dependent settings
(soft wood/hard wood)



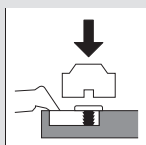
Set drilling pattern



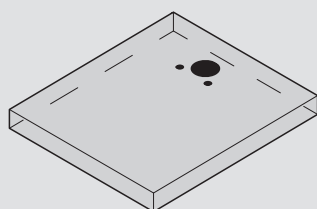
Fit drill bit



Set drilling depth



Fit insertion ram



Set dimensions

MINIPRESS P



Setup

Setup



WARNING

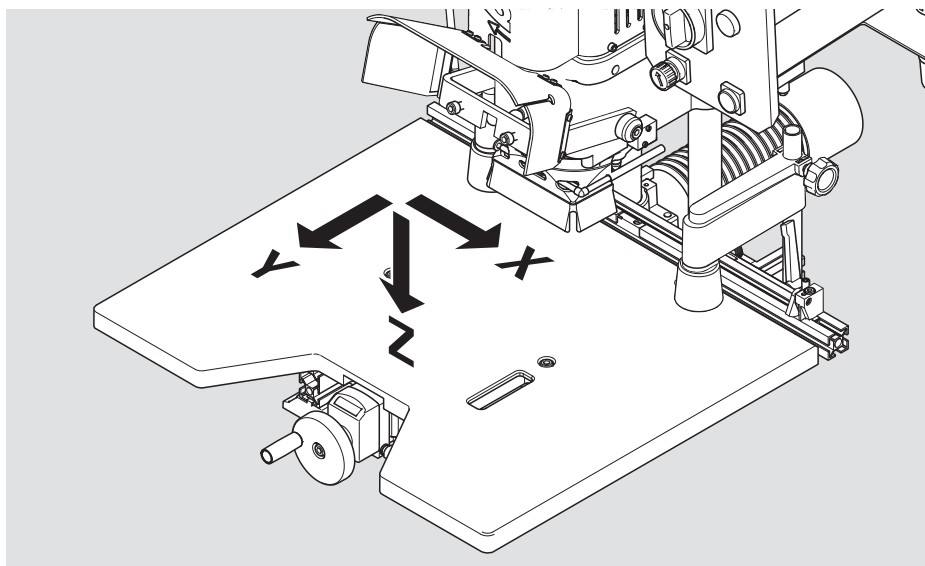
Serious cut injuries.

Serious injuries are possible from crushing or shearing. Failure to heed this warning may result in personal injury.

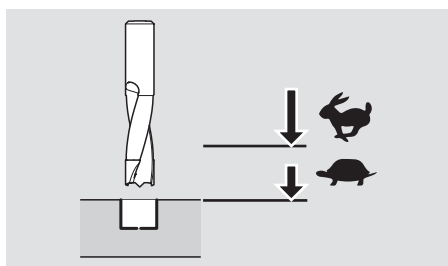
- Only one person at a time is permitted to operate the assembly machine.
- Set the main switch [27] to the "0" position.

Machine coordinates system

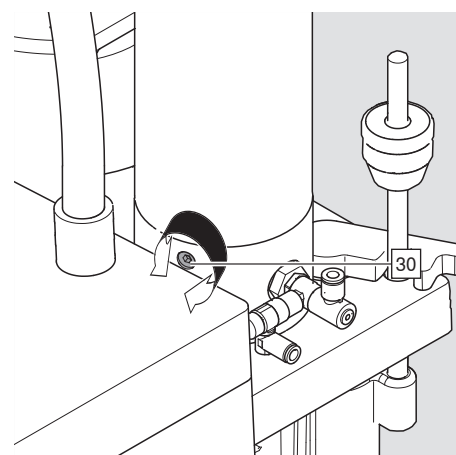
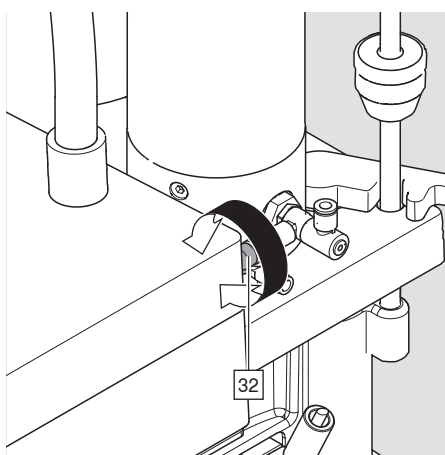
Coordinates system for use with EASYSTICK (optional)



Material-dependent settings (soft wood/hard wood)

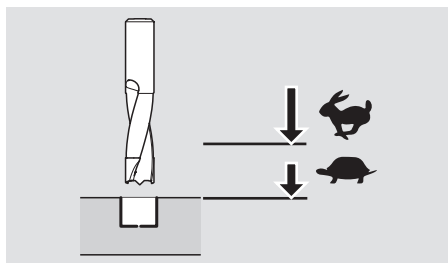


Set cam speed



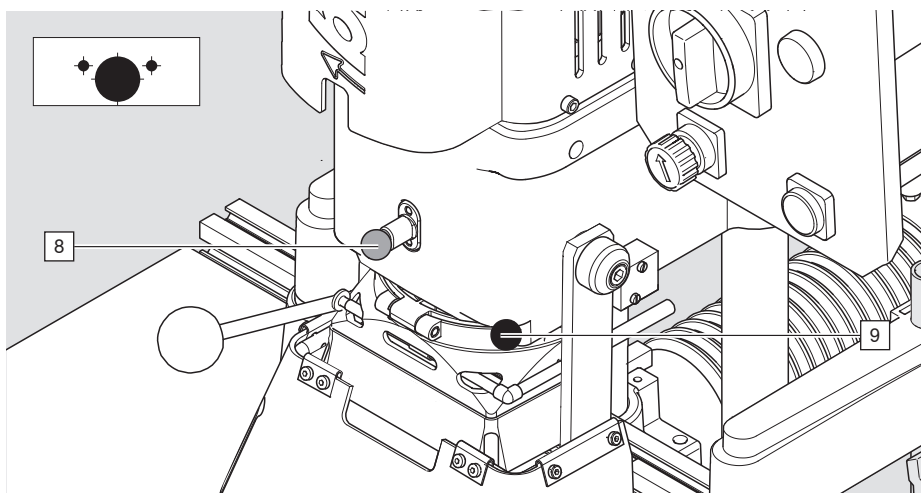
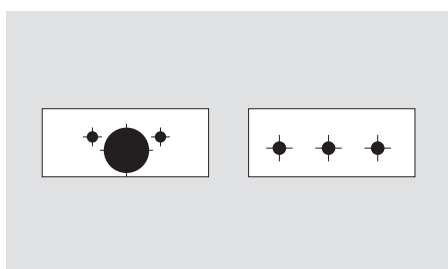
- The stroke speed for drilling heads is adjusted via the restrictor [32]. If there is no drilling head, it is adjusted via the cam brake [30].

Set cam brake



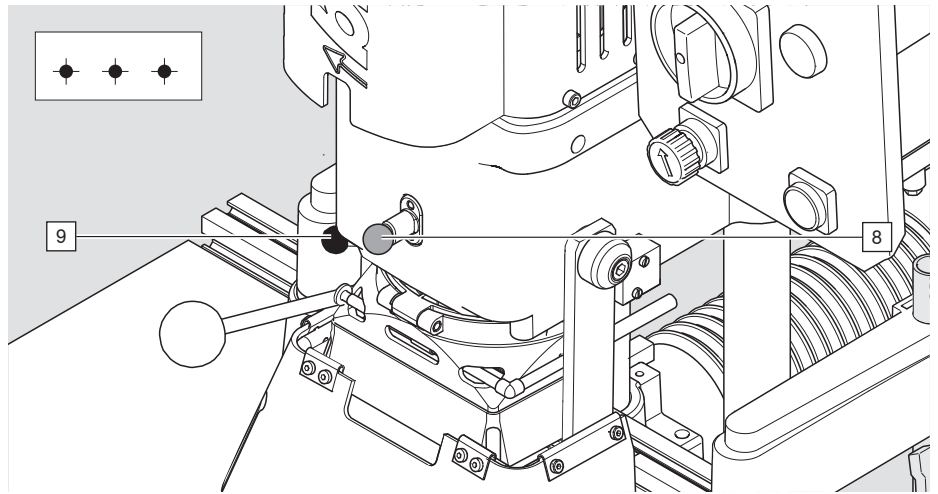
- The cam brake [30] (when machining without a drilling head) slows the stroke speed shortly before the drill bits penetrate the workpiece. The cam brake is adjusted on the cylinder by turning it.
- Quicker: Turn cam brake [30] to the left
- Slower: Turn cam brake [30] to the right

Set drilling pattern



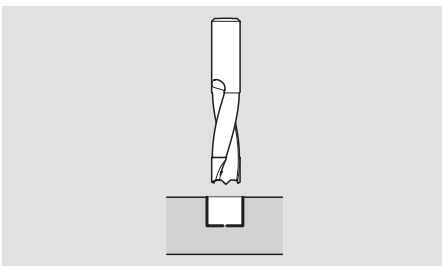
- Remove drilling head fixing pins [8].
- At the same time, move the lever [9] to the "Furniture hinge" symbol.
- Refit drilling head fixing pins [8].

Setup

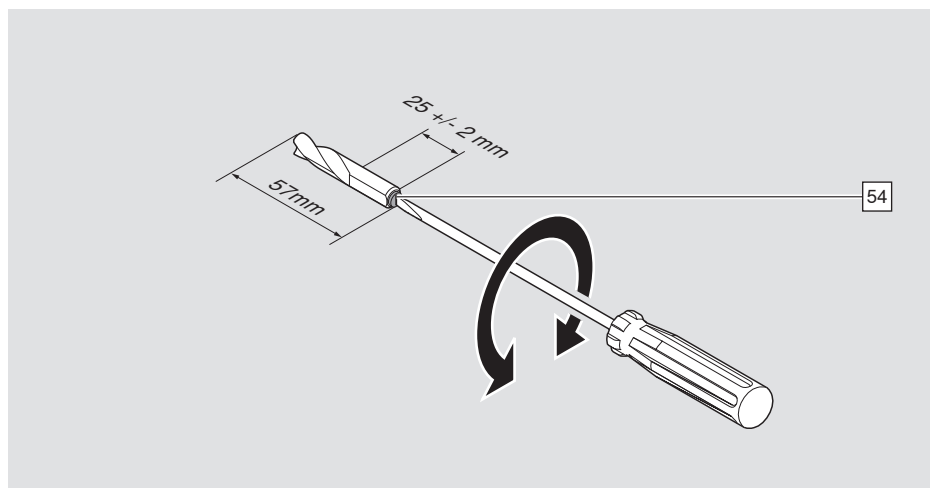


- Remove drilling head fixing pins [8].
- At the same time, move the lever [9] to the "Group drilling" symbol.
- Refit drilling head fixing pins [8].

Set drilling depth



All adjustment work is based on a drill bit length of 57 mm.



- The drill bit length can be set by turning the adjustment screw [54].
Drill bit length should be 57 mm.
- All drill bits must be the same length.
- If the length of the drill bit is no longer reached, the drill bit must be replaced.

Fit drill bit



WARNING

Serious cut injuries.

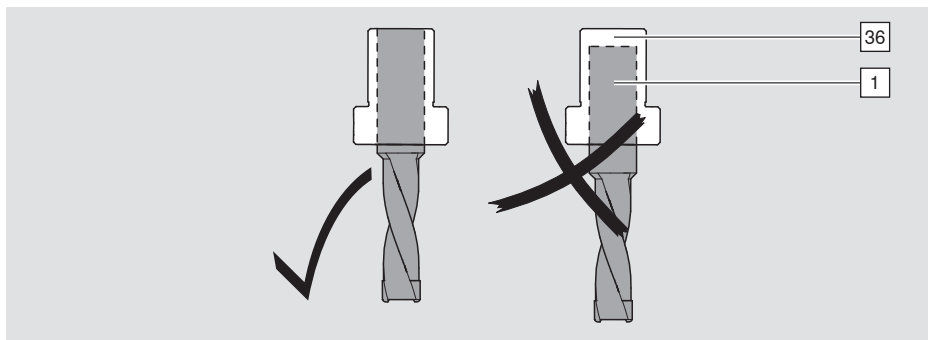
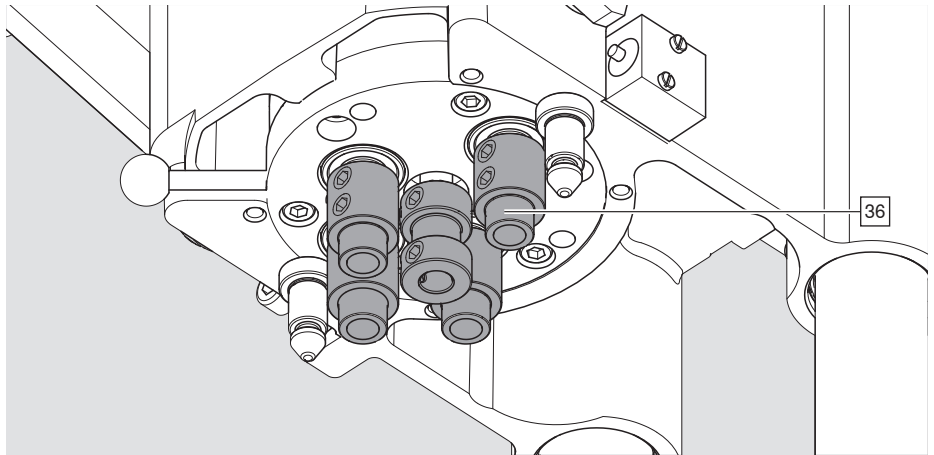
Serious injuries are possible from crushing or shearing. Failure to heed this warning may result in personal injury.

- Only one person at a time is permitted to operate the assembly machine.
- Set the main switch [27] to the "0" position.

i

NOTE

- Do not unscrew the fixing screw completely from the drill chuck. Complete unscrewing could damage the chuck.
- The chuck and drill bit are colour coded.
Red: counterclockwise
Black: clockwise

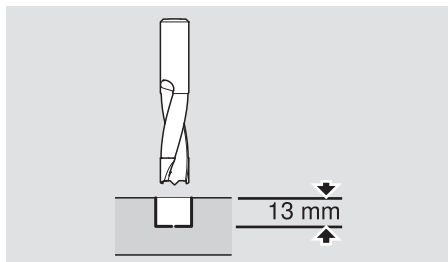


- Push drill bit [1] all the way into the chuck [36].
(The flat surface on the drill shaft must be placed in the direction of the fixing screw)
- Use a hex wrench to tighten the fixing screws.
- Fit cover caps to the unused chucks [41]. This will keep the chucks clean and prevent the fixing screws from coming out on their own.

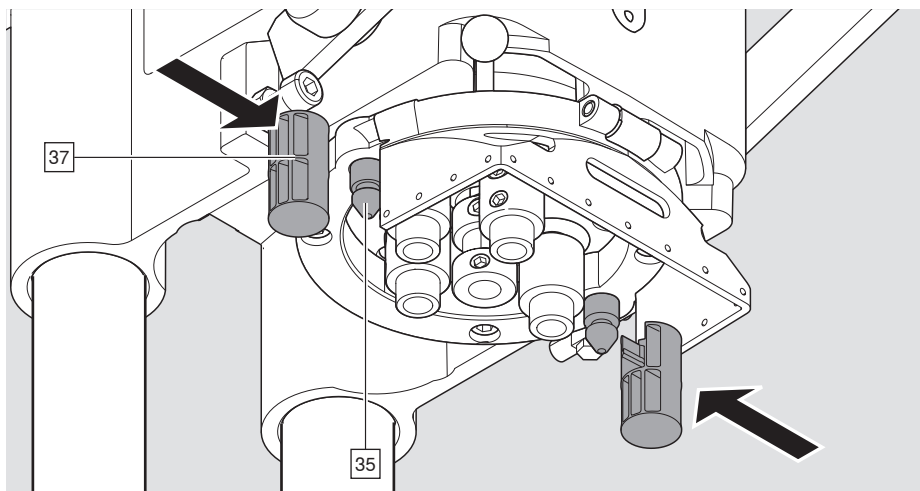
MINIPRESS P



Setup

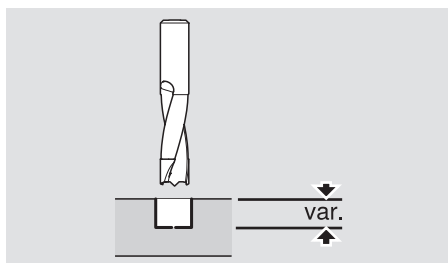


Fixed drilling depth 13 mm



One option to maintain a constant drilling depth is to install the drilling depth stop [37]. When the drilling depth stop [37] is installed, the drilling depth is always 13 mm regardless of the thickness of the workpiece.

- Press the drilling depth stop [37] onto the pins [35] of the retainer ring as far as it will go.



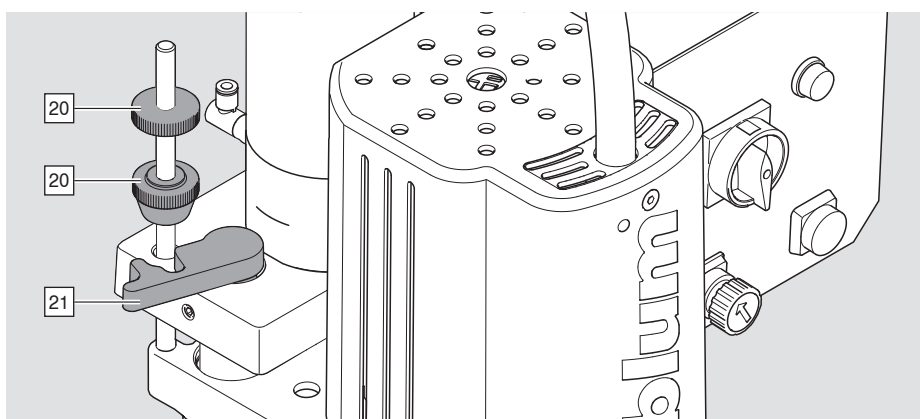
Variable drilling depth



WARNING

Serious cut injuries.
Serious injuries are possible from crushing or shearing.
Failure to heed this warning may result in personal injury.

- Only one person at a time is permitted to operate the assembly machine.
- Set the main switch [27] to the "0" position.

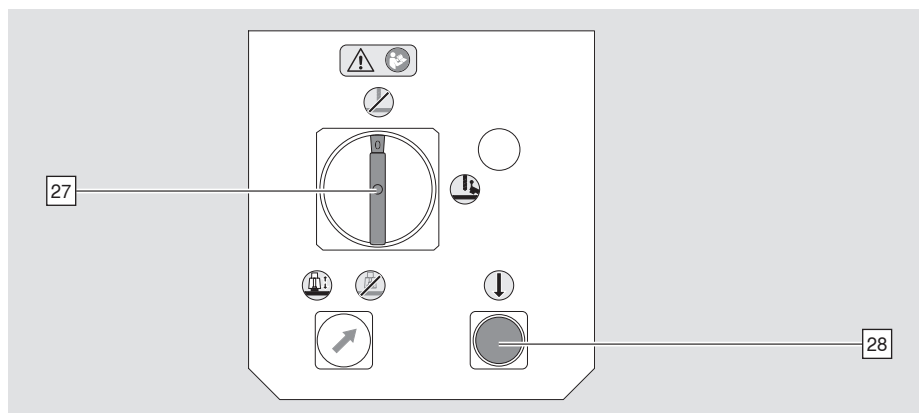


- Turn both knurled nuts [20] upwards.
- Swivel the spacer swivel lever [21] in the direction of the threaded rod.

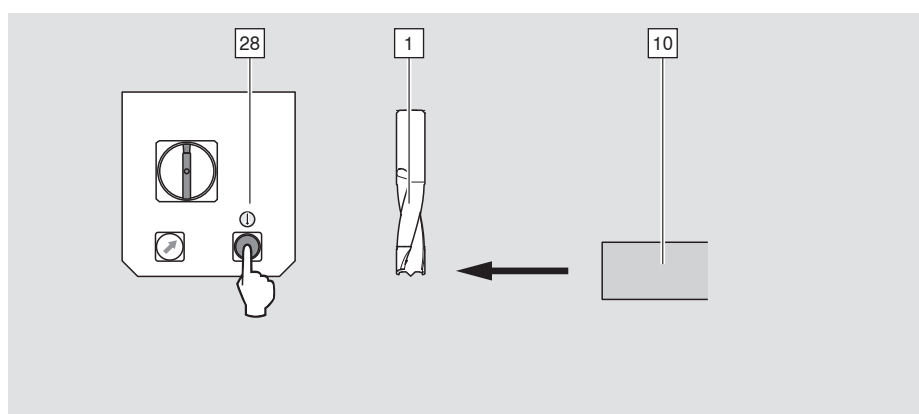


NOTE

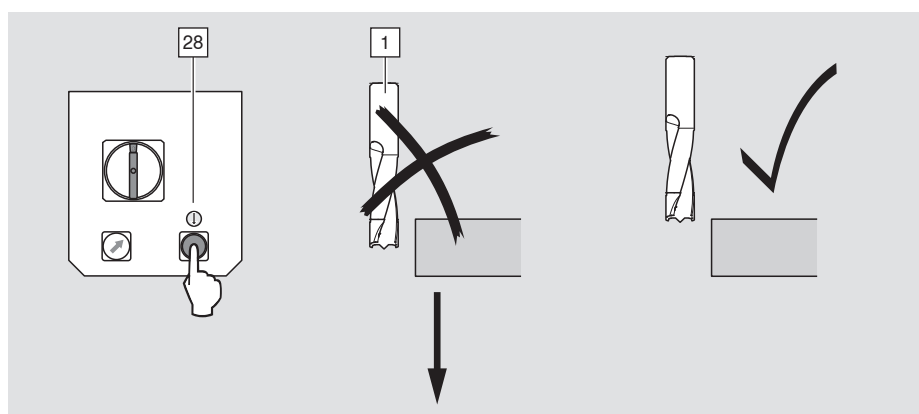
■ A drill bit with a length of 57 mm must be inserted.



- Set the main switch [27] to the "0" position.
- Press the feed switch [28] lightly (1 mm deep).
The drill unit then moves down slowly.



- Press and hold the feed switch [28] until the end position is reached.
- Push the workpiece [10] towards the drill bit [1].



The drill bit cutting edge [1] should be flush with the top edge of the workpiece [8]

- Continue to hold down the feed switch [28]
- Find the deviation

MINIPRESS P

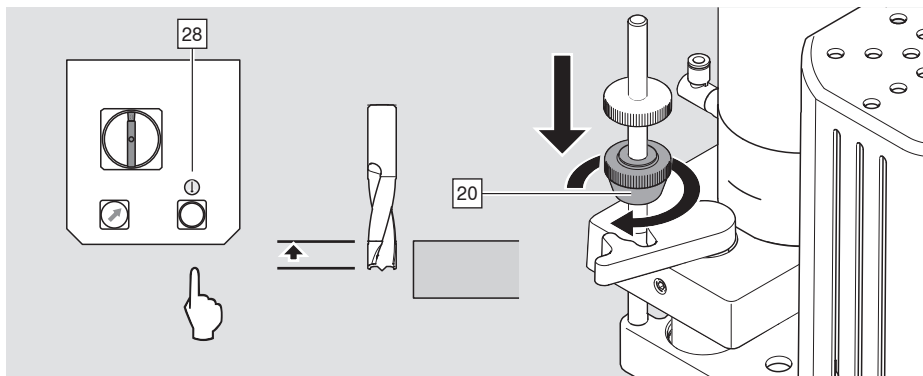
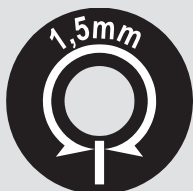


Setup



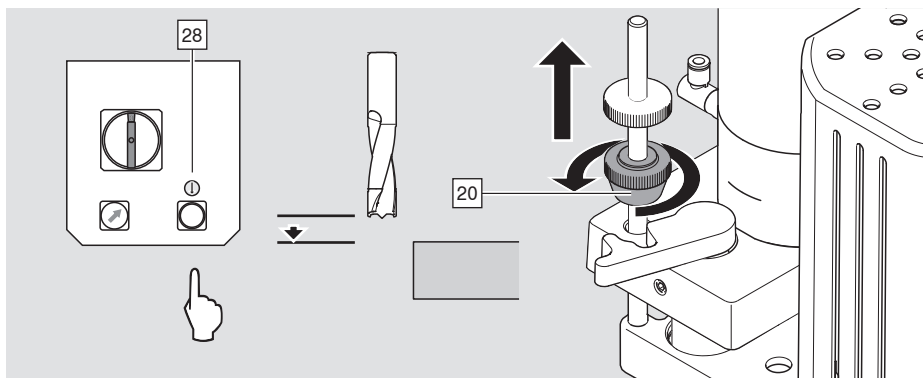
NOTE

■ One turn results in 1.5 mm of adjustment.



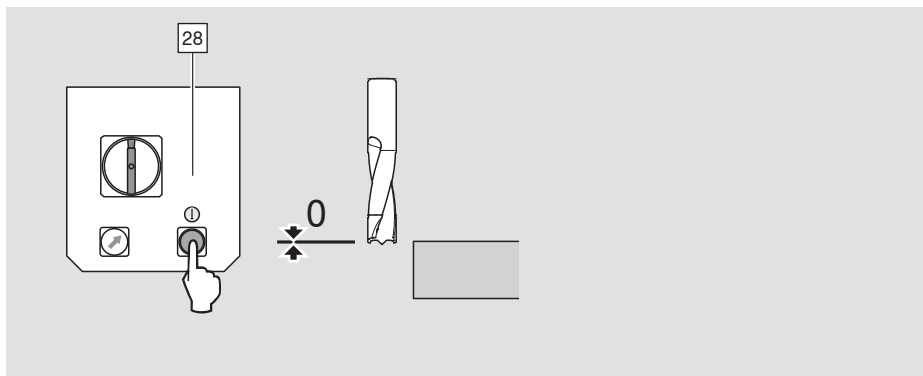
The drill bit cutting edge is located under the top edge of the workpiece.

- Release feed switch [28].
- Turn the knurled nut [20] clockwise.



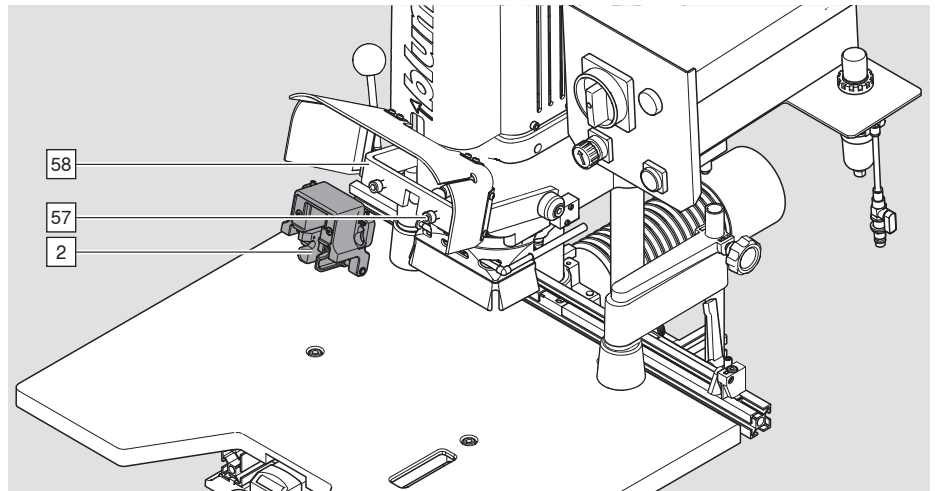
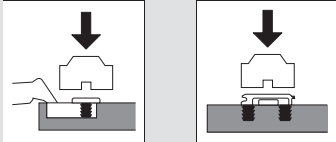
The drill bit cutting edge is located above the top edge of the workpiece.

- Release feed switch [28].
- Turn the knurled nut [20] counter clockwise.

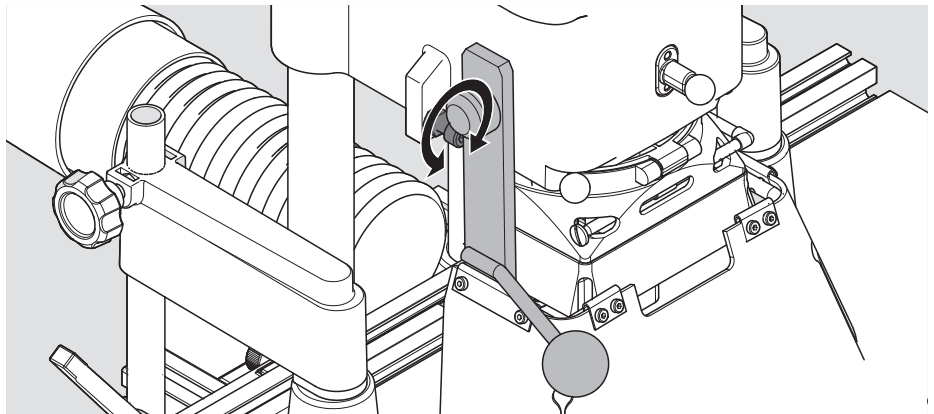


- Press the feed switch [28] and check the drilling depth setting again.
- After successful adjustment, lock with the upper knurled nut [20].
- The work steps must be repeated if the drilling depth is not correct.

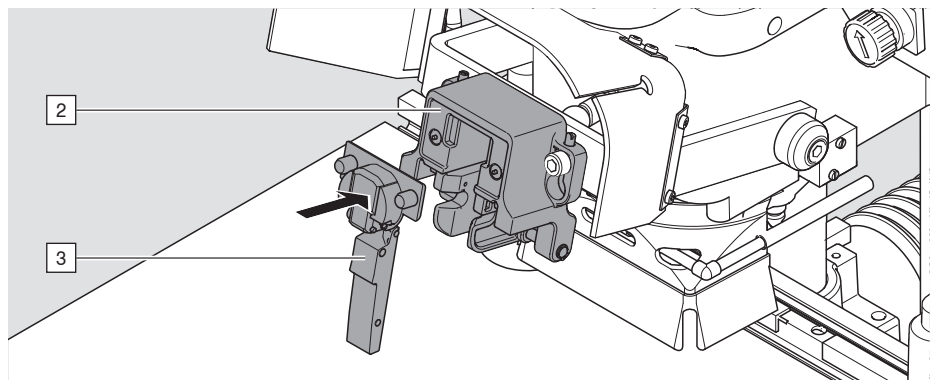
Fit insertion ram



- Fit insertion ram [2] onto the two screws [57] on the swing arm [58].
- Tighten the screws [57] so that the insertion ram is secure.

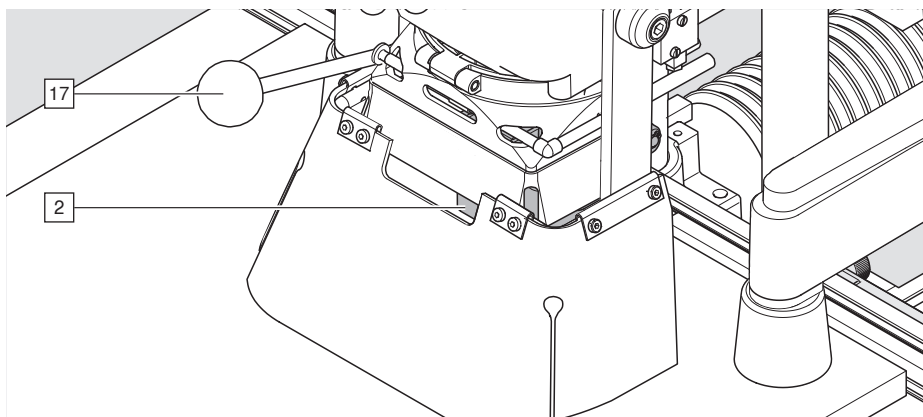


- If necessary, the insertion ram [2] can be aligned perpendicular to the workpiece [10].

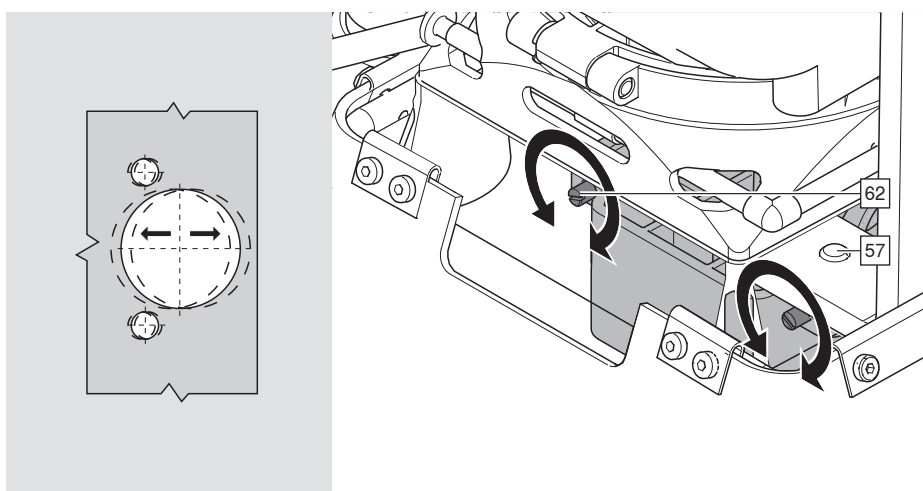


- Clip the hinge [3] on to the insertion ram [2].

Setup

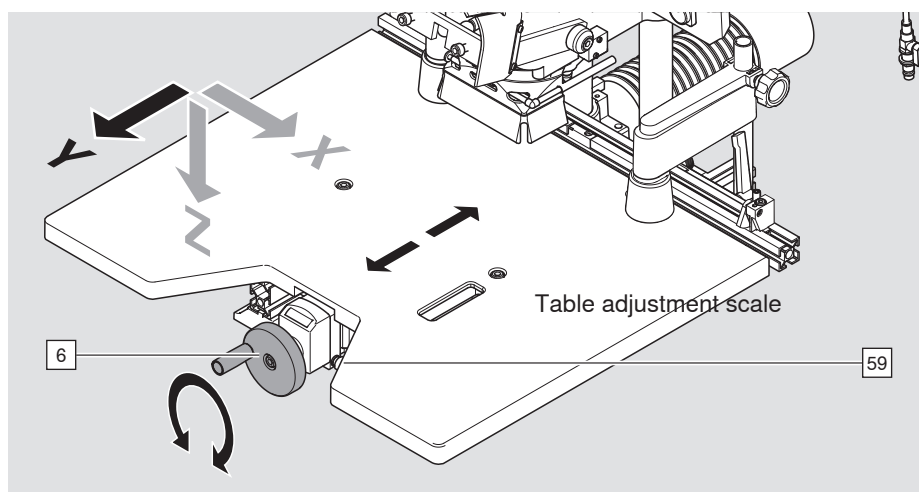
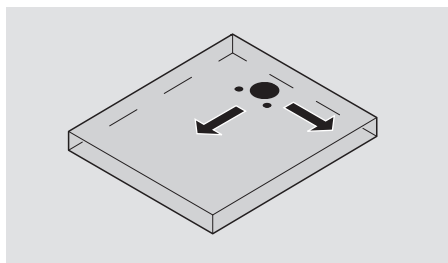


- Swivel the insertion ram [2] downwards with the insertion ram swivel lever [17].



- The insertion ram [2] can be finely adjusted so that the hinge fits exactly over the boss drilling.
- Loosen the screw [57] by one turn.
- Use the set screws [62] to adjust the insertion ram.
- Tighten the screw [57] securely.
- Carry out trial test drilling, see chapter "Drilling and knocking-in"

Setting according to workpiece



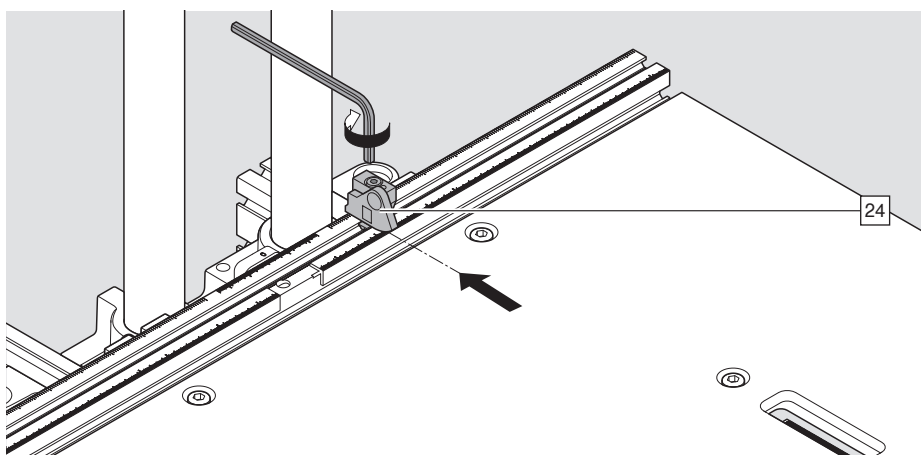
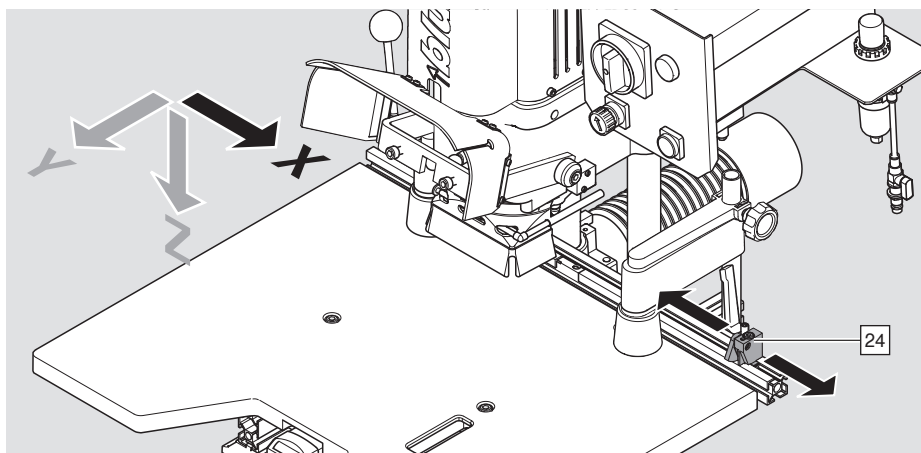
- Loosen clamping screw [59]
- Set the desired dimension using the hand wheel [6] or set the ruler system to the pre-specified values.

Detailed table adjustment scale

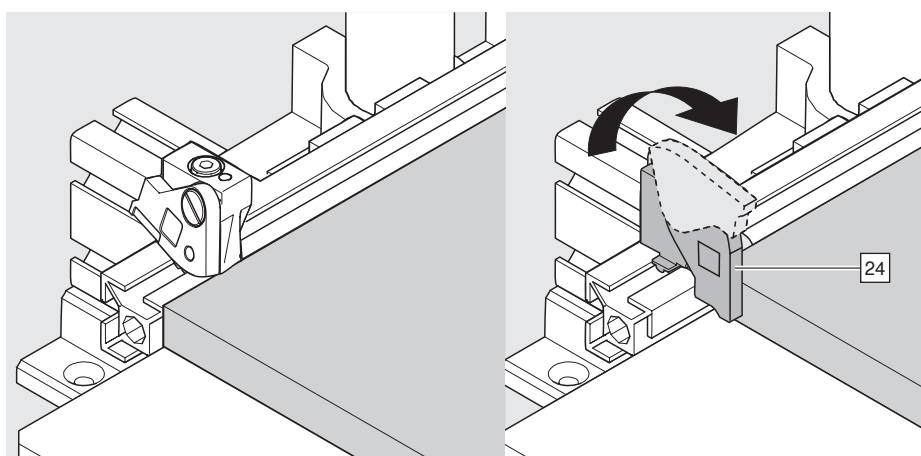


SY9	5 mm	System holes with 9-spindle drilling head
BOX	9 mm	Back panels for LEGRABOX, TANDEMBOX and METABOX
		Drawer base, LEGRABOX, METABOX incl. C15
COM	20.5 mm	COMPACT hinge
CLP	23.5 mm	CLIP hinge
SYS	37 mm	System holes 37 mm without drilling head

Setting the stops [24]

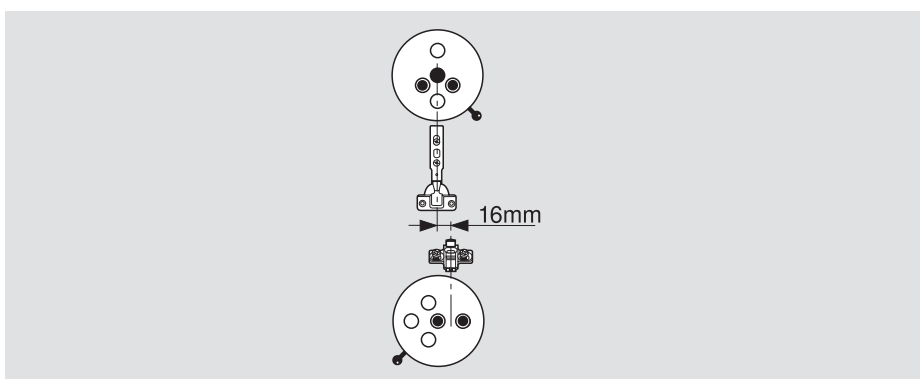
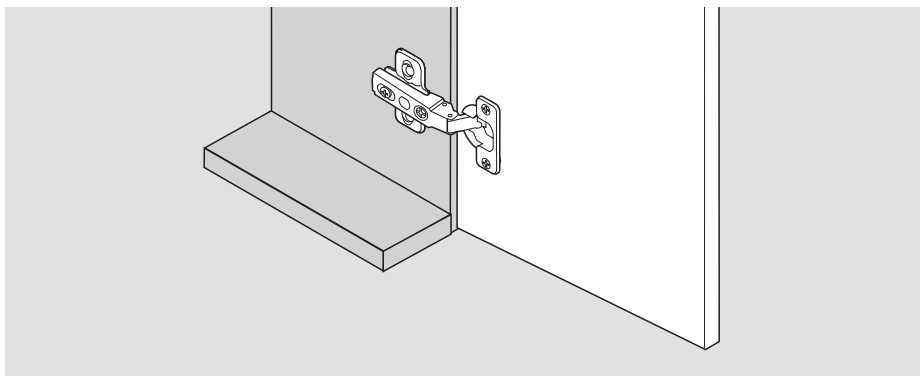
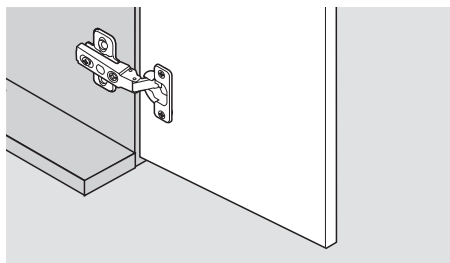


- Set the swivel stops [24] to the desired dimension and clamp.
IMPORTANT: The indicator edge is on the inside of the swivel stop.

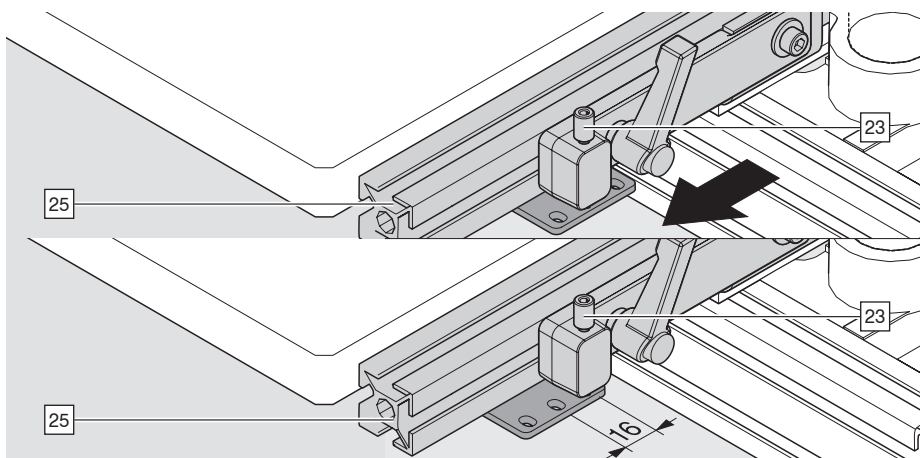


The stop surface can be enlarged by swivelling the stop flap [24] forward for rebated workpieces and workpieces with radiuses (see picture).

16 mm adjustment



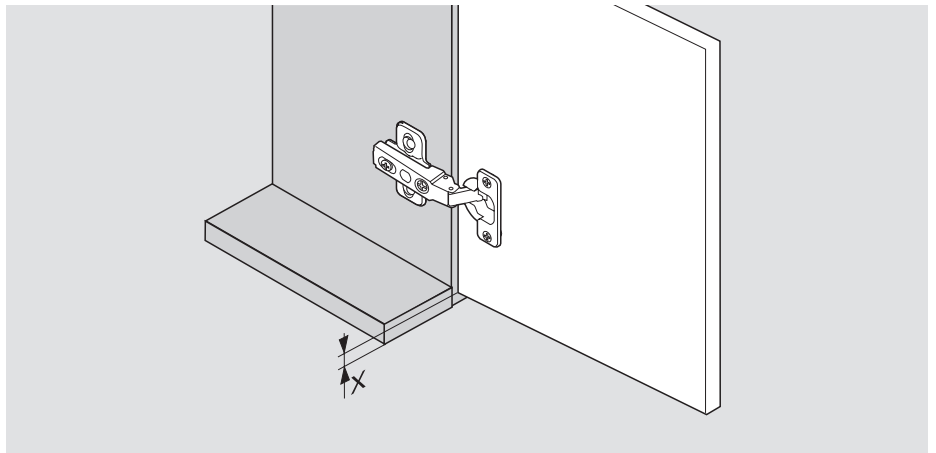
- If the bottom edge of the door should be flush with the bottom edge of the cabinet, only the basic ruler [25] needs to be re-positioned.



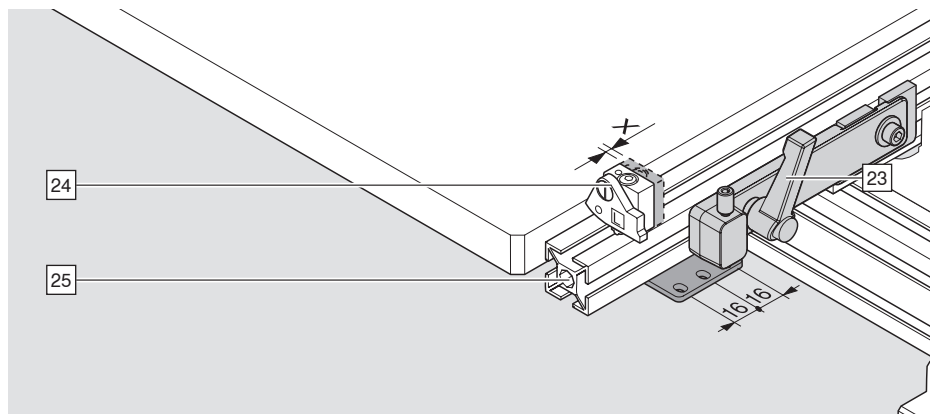
Repositioning the ruler:

- Loosen the locking device (MZE.1300) [23].
- Move basic ruler [25] 16 mm in the direction of the outer drill bit.
- Tighten the locking device (MZE.1300) [23].

Setup



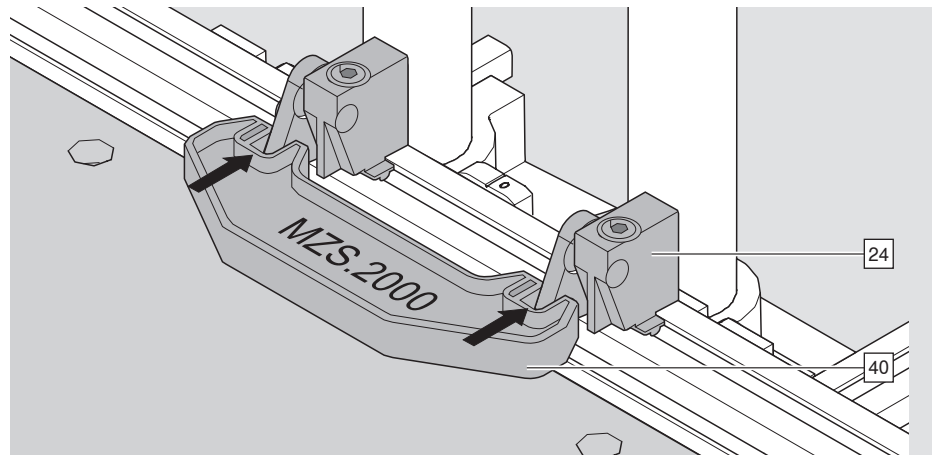
If the bottom edge of the door should be shorter or longer than the bottom edge of the cabinet, the stops [24] must be set according to the measured difference. In addition, the basic ruler [25] must also be re-positioned.



Positioning stops and rulers:

- Move swivel stop [24] by measurement (x).
- Loosen the locking device (MZE.1300) [23].
- Move basic ruler [25] 16 mm in the direction of the outer drill bit.
- Tighten the locking device (MZE.1300) [23].

Distance template



- Place distance template [40] on the swivel stop that has already been set [24] and set an additional swivel stop.
This results in a 6 hole group with a 32 mm hole spacing.

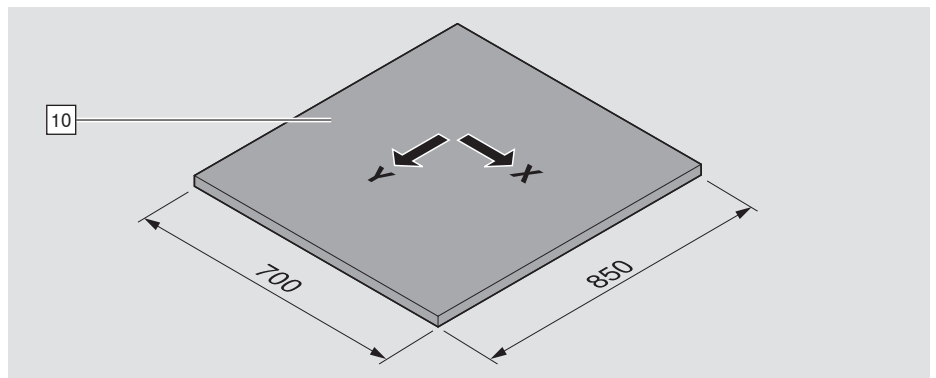


WARNING

Drill bits can cause serious injury.

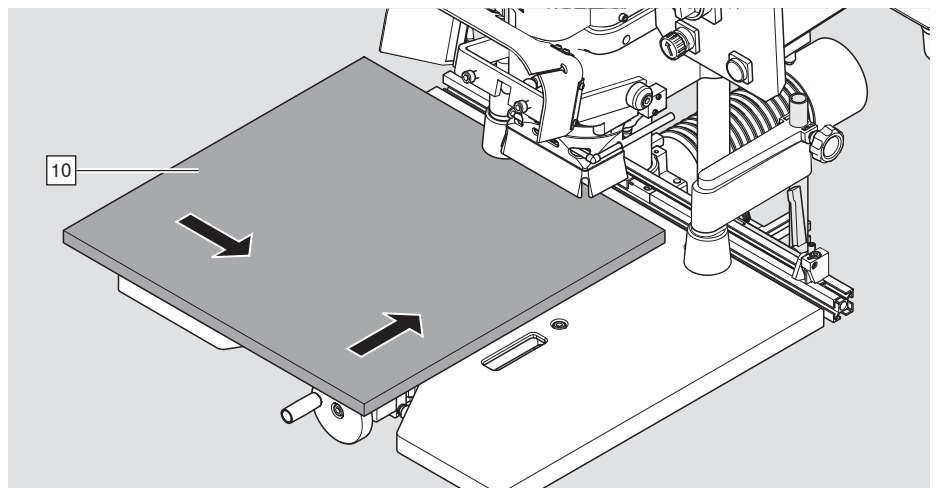
- Only one person at a time is permitted to operate the assembly machine.
- All items except for the workpiece must be removed from the work area [A] of the assembly machine.
- Keep your hands and other objects away from the work area [A] of the assembly machine.
- Caution crush danger in the area of the hold down clamp [12].

Maximum workpiece dimensions



Larger workpieces [10] must be additionally clamped, supported and secured.
Small workpieces [10] that cannot be clamped with the hold down clamps [12] must be clamped using suitable means.

Positioning the workpiece [10]

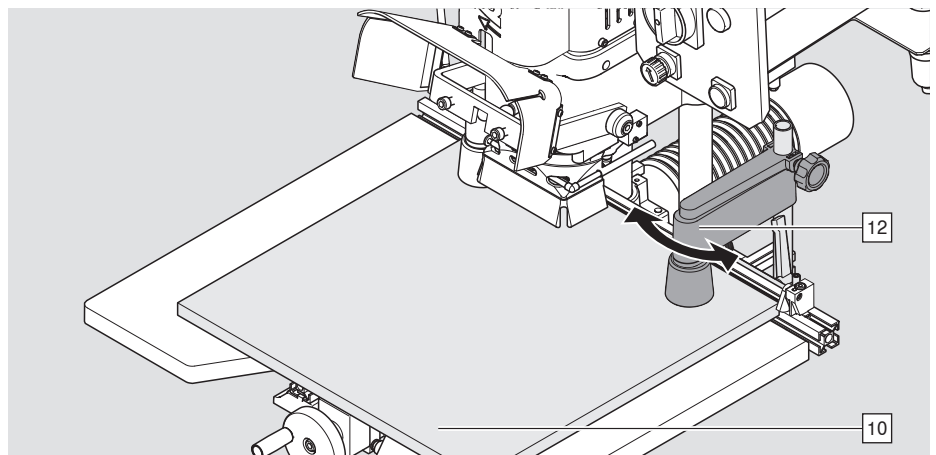


- Check the work table [5] for soiling and remove dirt as necessary.
- Push the workpiece [10] against the swivel stop [24] and basic ruler [25].

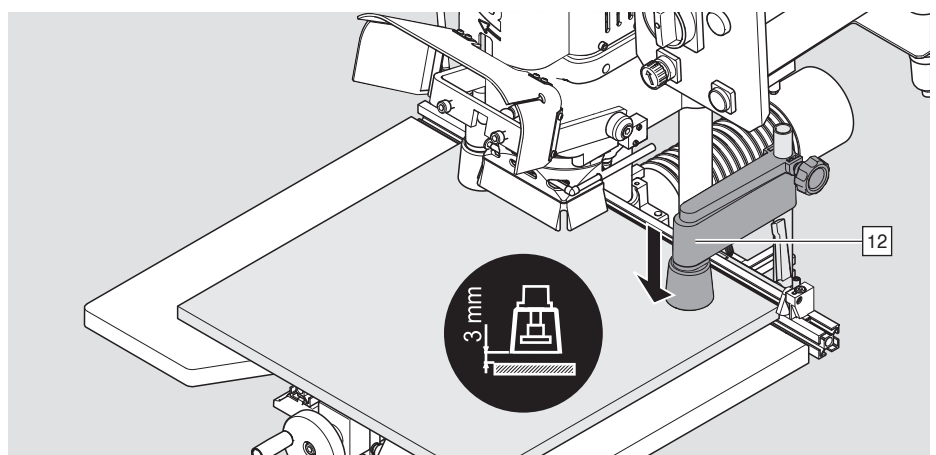
Hold down clamp

i NOTE

- We recommend using the hold down clamps [12] to ensure safe and precise processing of the workpiece.



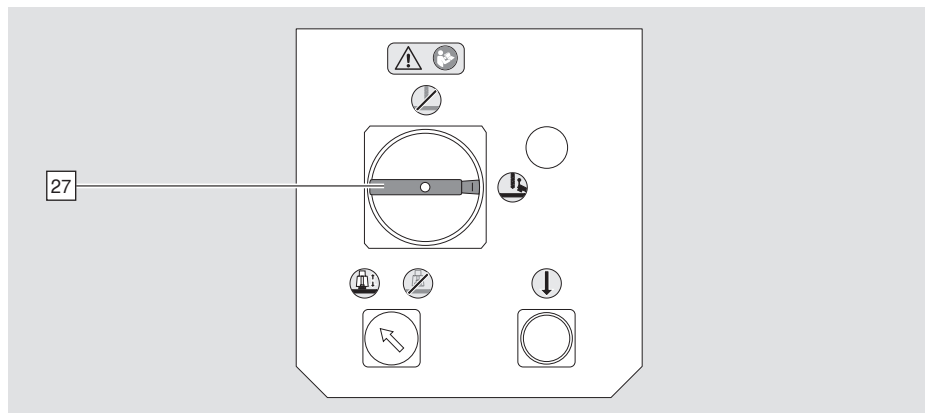
- Pull the hold down clamps [12] over the workpiece [10].
- Check for any collisions.



The hold down clamp [12] must be 3 mm over the workpiece.

- Set the height of the hold down clamp [12].

Drilling and insertion



- Set the main switch [27] to "1".

i NOTE

- The extraction system must always be switched on in order to remove wood chips and dust.

- Switch on the extraction system.

Drilling

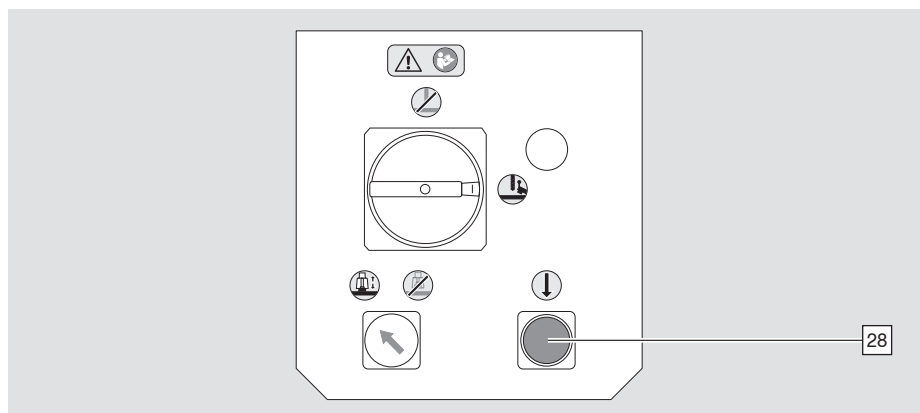


WARNING

Serious cut injuries.

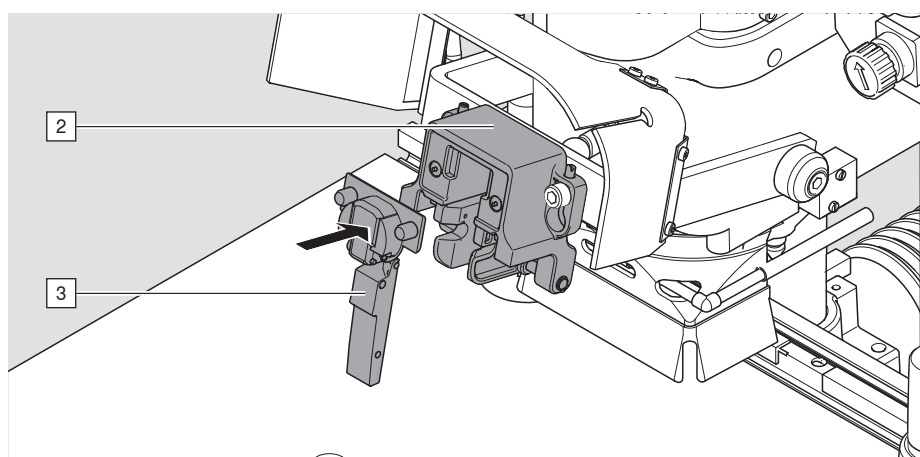
Serious injuries are possible from crushing or shearing. Failure to heed this warning may result in personal injury.

- Only one person at a time is permitted to operate the assembly machine.
- All items except for the workpiece must be removed from the work area [A] of the assembly machine.
- Keep your hands and other objects away from the work area [A] of the assembly machine.
- Caution crush danger in the area of the hold down clamp [12].



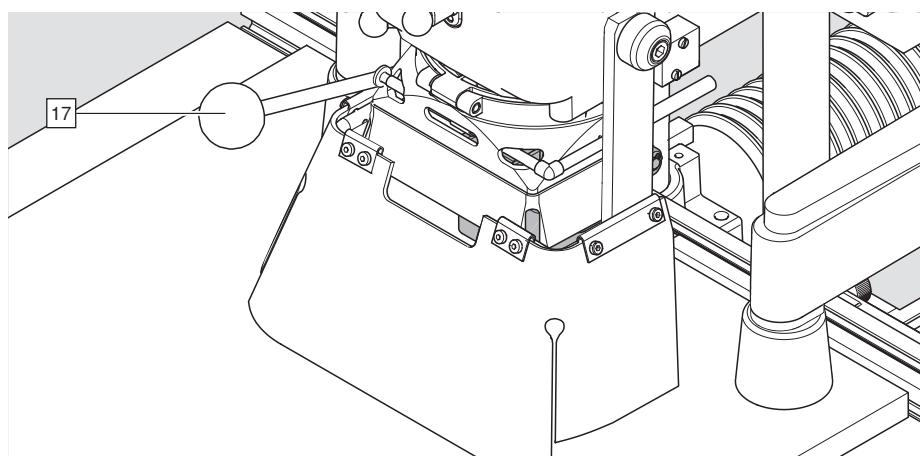
- Press feed switch [28] until drilling depth is reached.
- Release feed switch [28].

Drilling and knocking-in



- Clip the hinge [3] onto the insertion ram [2].

Insert



- Swivel down the insertion ram swivel lever [17].

Drilling and insertion

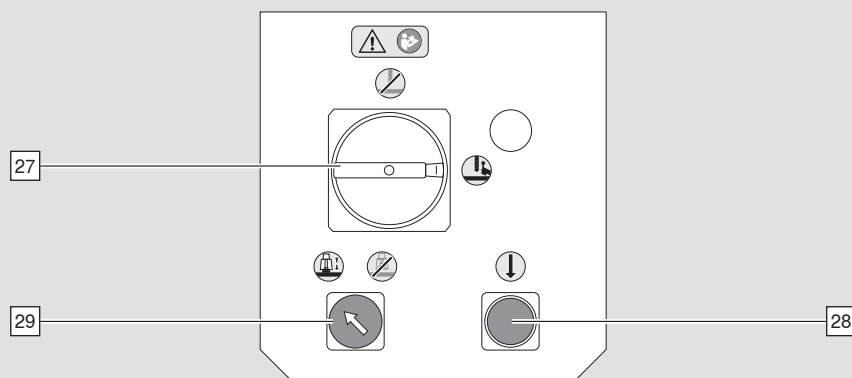


WARNING

Serious cut injuries.

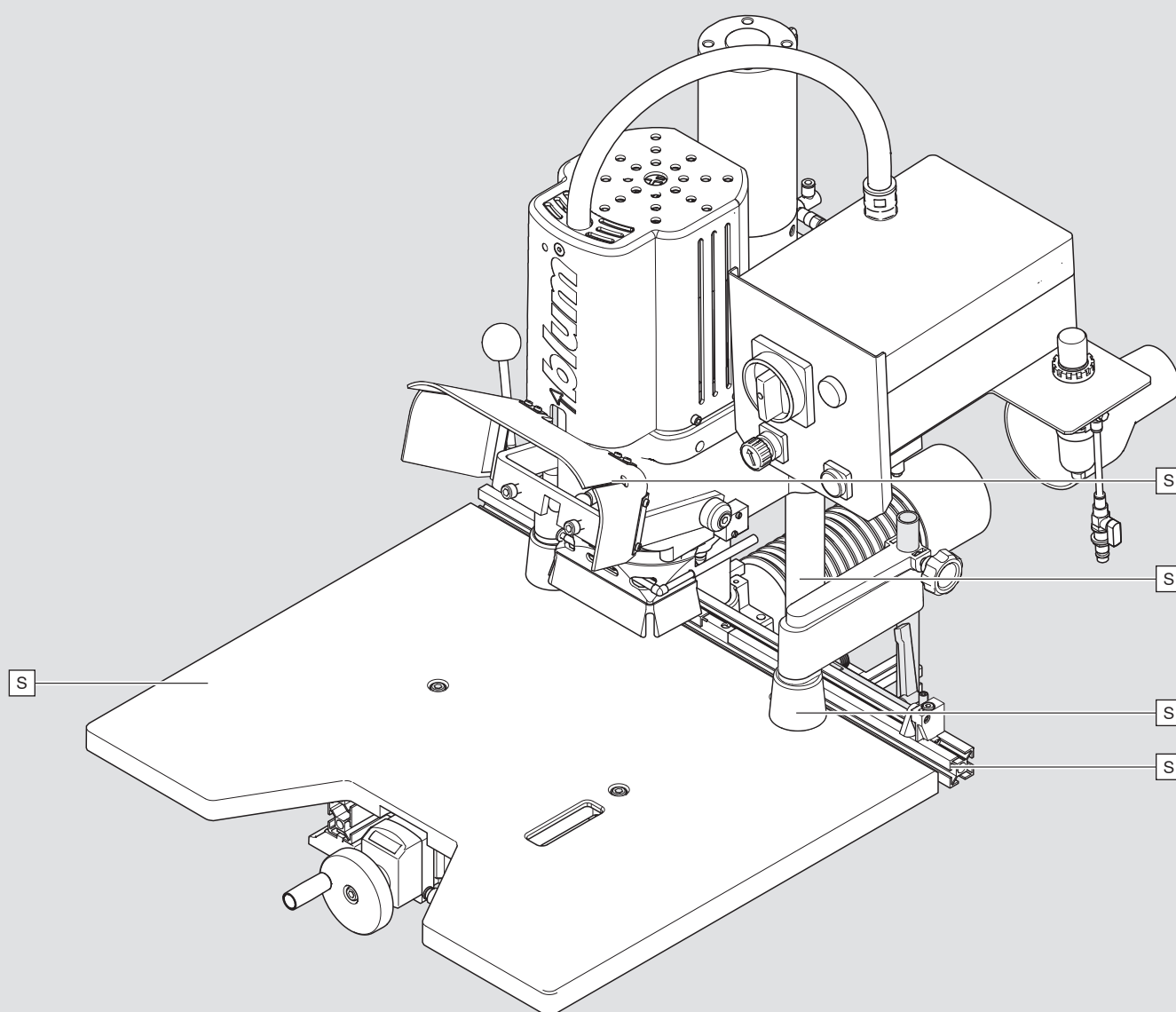
Serious injuries are possible from crushing or shearing. Failure to heed this warning may result in personal injury.

- Only one person at a time is permitted to operate the assembly machine.
- All items except for the workpiece must be removed from the work area [A] of the assembly machine.
- Keep your hands and other objects away from the work area [A] of the assembly machine.
- Caution crush danger in the area of the hold down clamp [12].



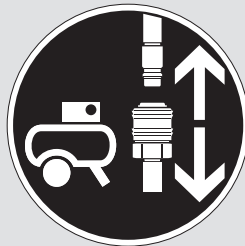
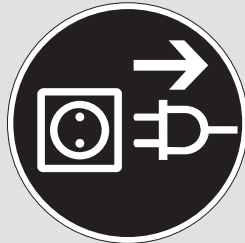
- Press feed switch [28] until the fitting is fully knocked in.
- Release feed switch [28].
- Swivel up the insertion ram swing arm [17].
- Release the hold down clamps by touching the clamp switch [29].
- Remove the workpiece [10].
- Clean the work table [5], basic ruler [25] and stops [24].
- Set the main switch [27] to the "0" position if the machine will not be used for a while or at the end of the working day.

Overview of maintenance points



S: perform a visual inspection, clean with a microfibre cloth if necessary.

Maintenance



WARNING

Serious cut injuries.

Serious injuries are possible from crushing or shearing. Failure to heed this warning may result in personal injury.

- The assembly machine must be disconnected from the power supply before cleaning and maintenance.
- The assembly machine must be disconnected from the pressurised air system before cleaning and maintenance.
- No protection equipment or covers may be removed permanently.
- Set the main switch [27] to the "0" position.



CAUTION

- Wear eye protection during cleaning work.



NOTE

- Replace damaged parts immediately
Only use BLUM original parts.
- Do not use oil or lubricants during cleaning
All runners and bearings are maintenance-free.
- Dust and wood chips must not be removed using sharp-edged or metallic objects.
- We recommend using microfibre cloths for cleaning work.



NOTE

- Daily maintenance work should be performed before starting work, a shift change or operator change.
- You should read the Safety chapter to ensure safe handling of the assembly machine.

Daily maintenance work

- Before starting work, check the pneumatic lines and electrical lines for damage.
Damaged lines should only be replaced by authorised personnel.
- Check the glass surrounding of the hold down clamps for damage [11].
- Check the protection equipment of the assembly machine and drilling head.
- Remove the drilling dust and the drill chips from the assembly machine.
Never remove using pressurised air.

- Perform a visual inspection of the guide elements [S]. If necessary, wipe away the dust using a microfibre cloth.
- Perform a visual inspection of the ruler [25], stops [24], clamps and guides. If necessary, wipe away the dust using a microfibre cloth.
- Defective parts may only be replaced by authorised personnel.

Monthly maintenance work

- Check the filter air pressure regulator [16] for water residue, which can collect in the air filter unit and empty if necessary.

Change drill bit

- Set the main switch [27] to "0".
- Unclamp the drilling head.
- Change the drill bits [1] and note the direction of rotation, see chapter "Setup".

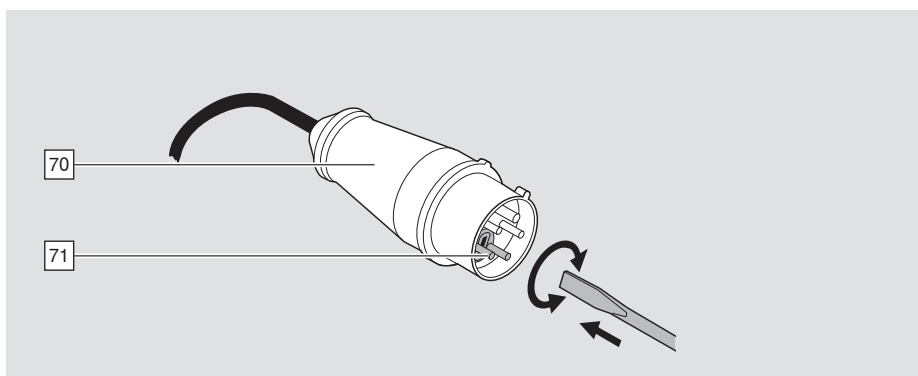
Repairs

- Please contact a Blum partner for repairs.
Blum partners worldwide can be found at:
www.blum.com/addresses

Error during drilling

Fault	Possible cause	Solution
Drill bits [1] are jammed in the wood.	Drill bits [1] are dull.	➤ Repoint drill bits [1] or replace.
	Incorrectly rotating drill bit [1] inserted.	➤ Install anti-clockwise drill bits into chucks [36] marked in red and clockwise drill bits into chucks marked in black.
	Improper material has been drilled.	➤ Only use workpieces made from wood, particle board or epoxy coated wood.
Lots of smoke when drilling.	Drill bits [1] are dull.	➤ Repoint drill bits [1] or replace.
	Incorrectly rotating drill bit [1] inserted.	➤ Install anti-clockwise drill bits [1] into chucks [36] marked in red and clockwise drill bits into chucks marked in black.
	Motor rotating in the wrong direction.	➤ Correct the motor rotation.

Changing the direction of rotation of the motor



- Set the main switch [27] to the "0" position.
- Disconnect the assembly machine from the power supply.
- Rotate the phase change plate [71] in the plug [70] by 180 degrees.
- Check the direction of rotation of the motor again.

If no phase inversion plug is fitted, the direction of rotation must be changed by an electrician.

Error on the workpiece

Fault	Possible cause	Solution
Drillings are too large, oval or stripped.	Drilling diameter is too large.	➤ Check the drill bits [1].
	Drill bits [1] bent.	➤ Replace the drill bits [1].
	Drill bits [1] are dull.	➤ Repoint drill bits [1] or replace.
Drillings are off-centre or in the wrong position.	Ruler [25] not set properly.	➤ Set ruler [25] to the 0 point.
	Chips between the ruler [25] and the workpiece [10].	➤ Remove dirt and chips.
Drilling depth not reached.	Chips in the travel path.	➤ Remove chips from the travel path.
	Length of drill bit [1] is under 57 mm.	➤ Set the drill bit [1] to 57 mm length or change.
	Workpiece thickness less than 16 mm.	
	Machine is running into an object.	➤ Remove object.
	A Blum work table [5] is not being used.	➤ Only use original accessories and spare parts.
Error during insertion.	Chips in the drilling.	➤ Remove chips from the drilling.
	The diameter of the drillings is too small.	➤ Check the drilling diameter.
	Drillings are not deep enough.	➤ Set the drill bit to 57 mm length or change.
	The surface of the workpiece [10] is too hard.	➤ Bevel drilling.
	Insertion ram [2] is running into an object.	➤ Remove object.
	Air pressure is too low.	➤ Adjust air pressure [16].

Error on the workpiece

Fault	Possible cause	Solution
Error during insertion.	Workpiece [10] is offset.	➤ Use hold down clamps [12] or other clamping devices.
	Insertion ram [2] is offset.	➤ Adjust insertion ram [2].
Workpiece [10] is scratched.	Work table [5] is dirty or damaged.	➤ Clean work table [5]. ➤ Check the work table [5] for damage.
	Rulers [25] and stops [24] are dirty.	➤ Clean rulers [25] and stops [24].

Assembly machine malfunctions

Fault	Possible cause	Solution
Motor does not run.	Assembly machine is not connected to the power supply.	➤ Connect the assembly machine to the power supply.
	Power supply overcurrent protection has failed.	➤ Reset overcurrent protection or replace.
	Assembly machine connected to incorrect voltage.	➤ Check mains voltage and compare with connection diagram. ➤ Have this checked by an authorised electrician.
	Motor is defective.	➤ Have motor replaced by an authorised electrician.
Motor overheats.	Assembly machine connected to incorrect voltage level.	➤ Check mains voltage and compare with motor data. ➤ Have this checked by an authorised electrician.
	Thermal cutoff switch has tripped.	➤ Thermal cutoff switches on again after cooling down.

Fault	Possible cause	Solution
Motor overheats.	Drilling in hard wood with too high a speed.	➤ Set correct cam speed.
	Motor is dusty.	➤ Clean the assembly machine.
	Work cycle too fast	➤ Slow down work cycle
Hold down clamps do not function.	Incorrect setting of the hold down clamp selector switch [29].	➤ Change selector switch [29] setting.
	No pressurised air or too little pressure.	➤ Open the compressed air shut-off valve [14]. ➤ Check the pressure.
No stroke movement when pressing the start button.	No pressurised air or too little pressure.	➤ Open the compressed air shut-off valve [14]. ➤ Check the pressure.
Stroke movement goes down but not back up.	Too little pressure.	➤ Check the filter air pressure regulator [16].
	Pneumatic hose kinked or damaged.	➤ Check the air lines.
Air filter connection is leaking.	Air hose is leaking.	➤ Replace air hose.
	Filter air pressure regulator [16] is leaking.	➤ Replace filter air pressure regulator [16].
Chip removal is inadequate.	Chip blow-off is too weak.	➤ Check air pressure.
	Chip exhaust is not set.	➤ Turn on chip exhaust.
Drill bits [1] cannot be gripped in the chuck.	Chuck [36] heavily soiled.	➤ Clean chuck [36].
	Drill shaft diameter too large or deformed.	➤ Change drill bits [1].
	Drill clamping screw not screwed out until the stop.	➤ Unscrew drill clamping screw.
Drill bits [1] not rotating.	Coupling is damaged.	➤ Change coupling.
Operating mode display [26] does not light up	Main switch [27] switched off.	➤ Switch on main switch [27].
	Fuse defective, or no voltage present.	➤ Troubleshooting by an electrician.

Simplified EU Declaration of Conformity for MINIPRESS P

Simplified EU Declaration of Conformity

Julius Blum GmbH hereby declares that all electrical and electronic article types of Julius Blum GmbH conform to the Directives 2009/125/EC and 2011/65/EU as well as 2015/863.

Julius Blum GmbH hereby declares that the electrical and electronic article types M50.XXXX conform to the Directives 2006/42/EC and 2014/30/EU.

The complete text of the EU Declaration of Conformity is available at the following Internet address:

www.blum.com/compliance

Additional information

MINIPRESS P



Technical data MINIPRESS P

Only use in dry, enclosed rooms.

Ambient atmosphere:

Transport/storage: _____ -20 to 85°C

Operation: _____ 0 to 50°C

Relative humidity (operation) _____ 5 - 93 % non-condensing

Dimensions / weight:

Height: _____ 771 mm

Width: _____ 684 mm

Depth: _____ 690 mm

Weight: _____ See rating plate

Installation distance to wall min. 450 mm

Electrical energy:

Voltage: _____ See rating plate

Power: _____ See rating plate

Pneumatic energy:

Pressure: _____ 5 - 7 bar / 73 - 101 psi / 0.5 - 0.7 MPa

Air consumption per cycle (stroke) : _____ 1.5 litre

Sound:

Emission - sound pressure level (LA_{equ}): _____ 76 dB(A)

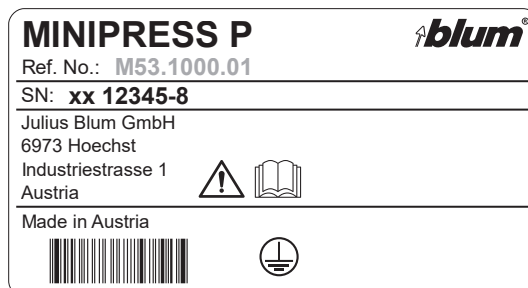
Sound power level tolerance measurement uncertainty: _____ +/- 4 dB(A)

Workpiece:

Materials: _____ wood

Workpiece thickness drilling: _____ 8 - 45 mm

Rating plate:



Illustration

Device type: drilling and insertion machine

Disposal of electrical assembly devices



Electrical assembly devices must not be disposed of with household waste at the end of their service life. Ask your local authority for information on how to proceed. BLUM electrical assembly devices meet the requirements of the WEEE Directive 2012/19/EU.

Electrical and electronic appliances are collected separately, which enables old appliances to be reused or recycled, and their materials to be reused. This is intended to prevent any hazardous materials that may be contained in the appliances from damaging the environment and health during disposal.

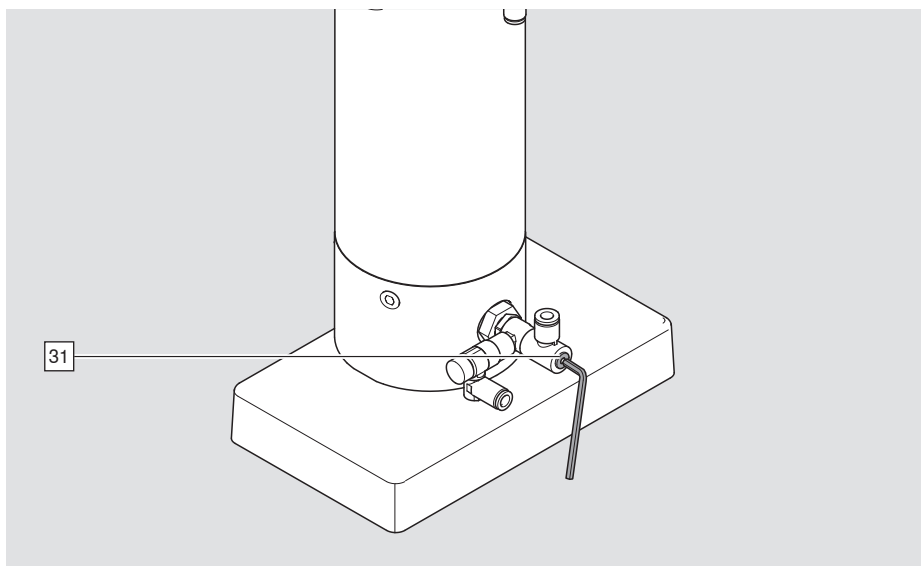
Electric assembly devices can be returned to the manufacturer at the end of their service life or can be recycled or repaired if this makes ecological sense.

Further information on this under the following link:

www.blum.com/recycling

Energy storage:

The assembly machine has stored pneumatic energy. This can be released using the vent valve [31].

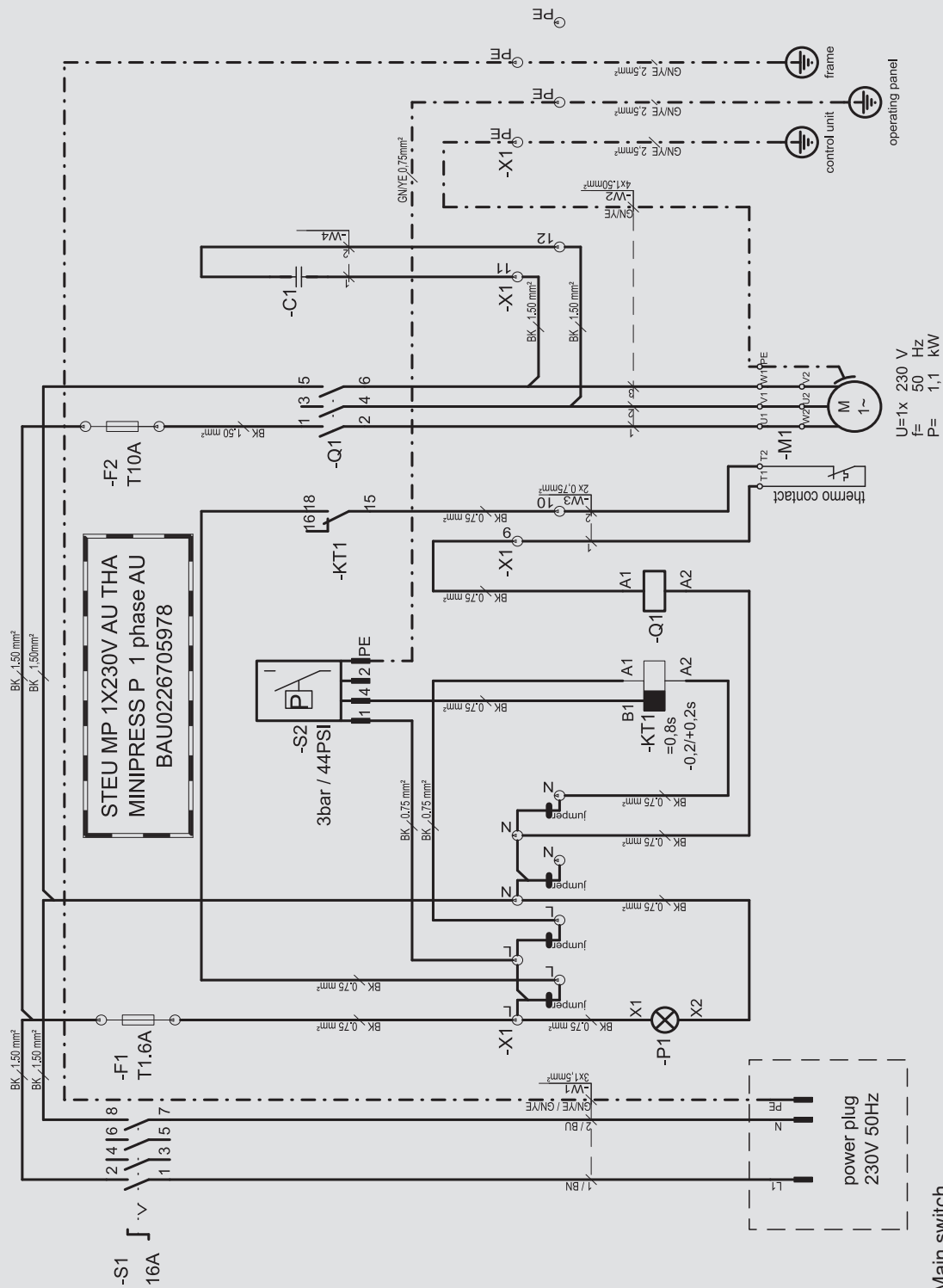


Additional information

MINIPRESS P

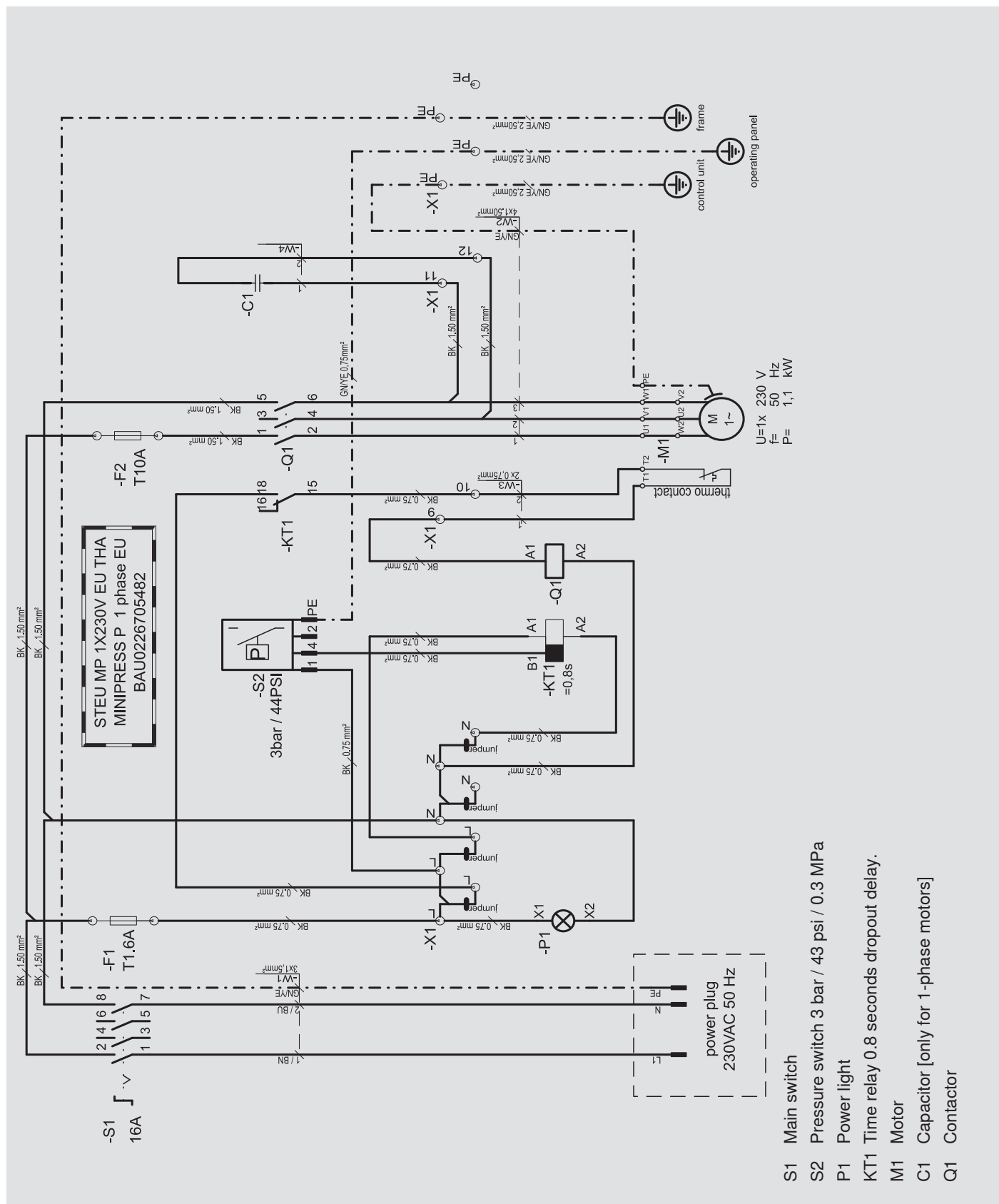


Electrical diagram 1X230V AU



- | | |
|-----|--|
| S1 | Main switch |
| S2 | Pressure switch 3 bar / 43 psi / 0.3 MPa |
| P1 | Power light |
| KT1 | Time relay 0.8 seconds dropout delay. |
| M1 | Motor |
| C1 | Capacitor [only for 1-phase motors] |
| Q1 | Contactors |

Electrical diagram 1X230V EU



Additional information

MINIPRESS P

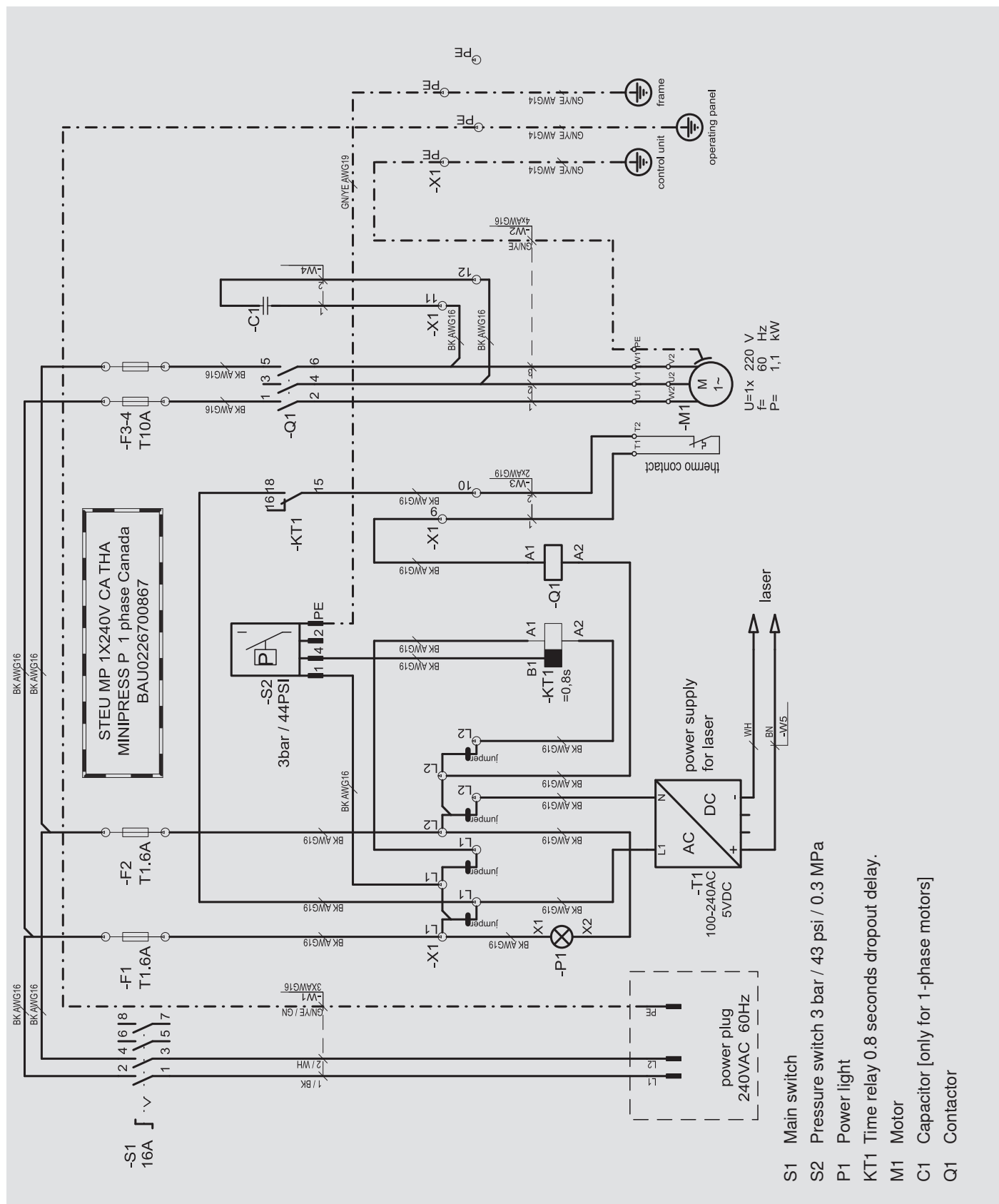


Wiring diagram for a laser system control unit. The diagram shows the electrical connections between a main switch (S1), a pressure switch (S2), a power light (P1), a time relay (KT1), a motor (M1), a capacitor (C1), and a contactor (Q1). The system is powered by a 230V 50Hz AC supply. The motor is a 1-phase EU motor with a power of 1.1 kW. The time relay is set to 0.8s. The pressure switch is set to 3 bar / 44 psi. The diagram includes a detailed legend for the components and their ratings.

Legend:

- S1 Main switch
- S2 Pressure switch 3 bar / 43 psi / 0.3 MPa
- P1 Power light
- KT1 Time relay 0.8 seconds dropout delay.
- M1 Motor
- C1 Capacitor [only for 1-phase motors]
- Q1 Contactor

Electrical diagram 1X240V CA

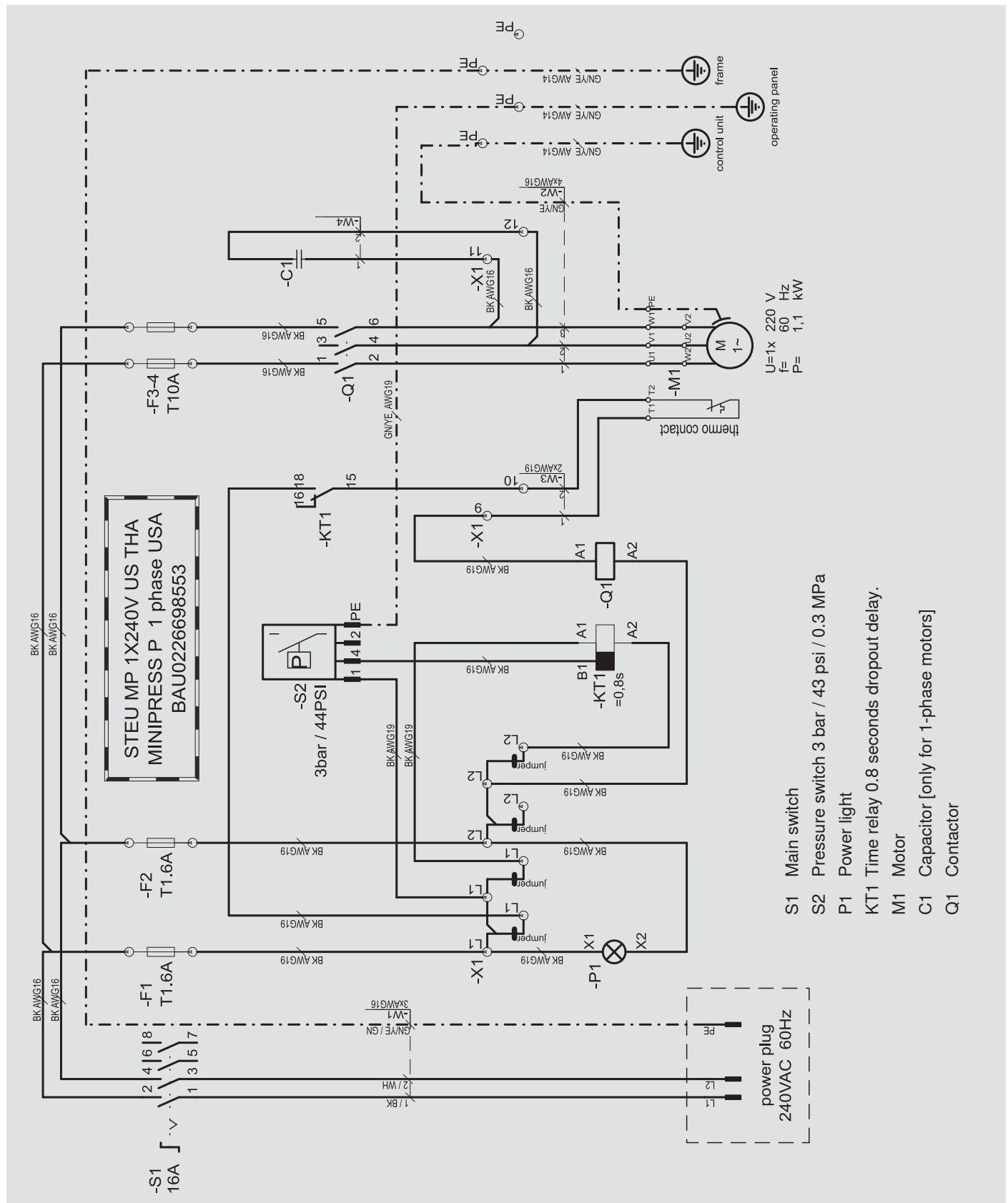


Additional information

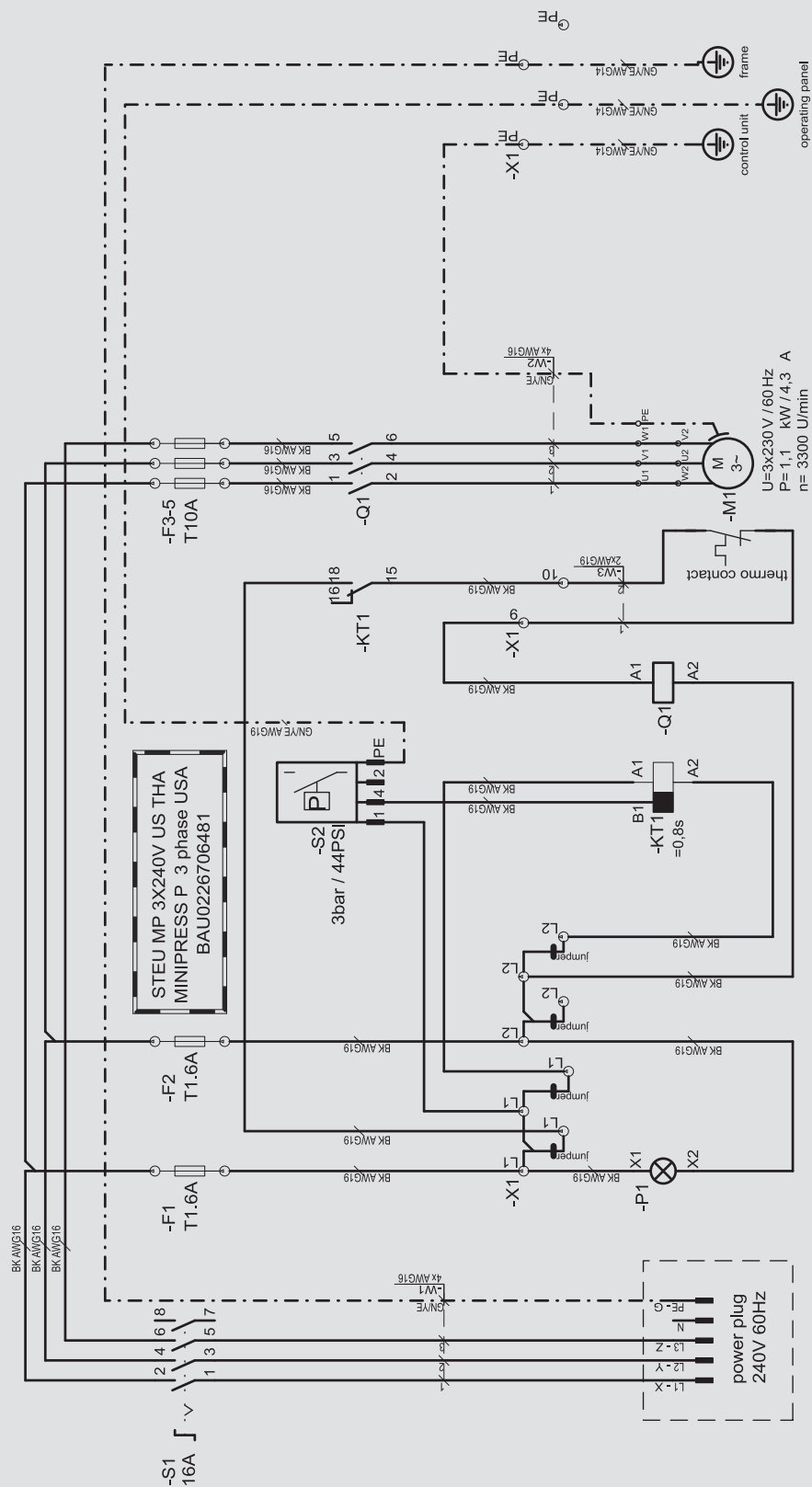
MINIPRESS P



Electrical diagram 1X240V US



Electrical diagram 3X240V US



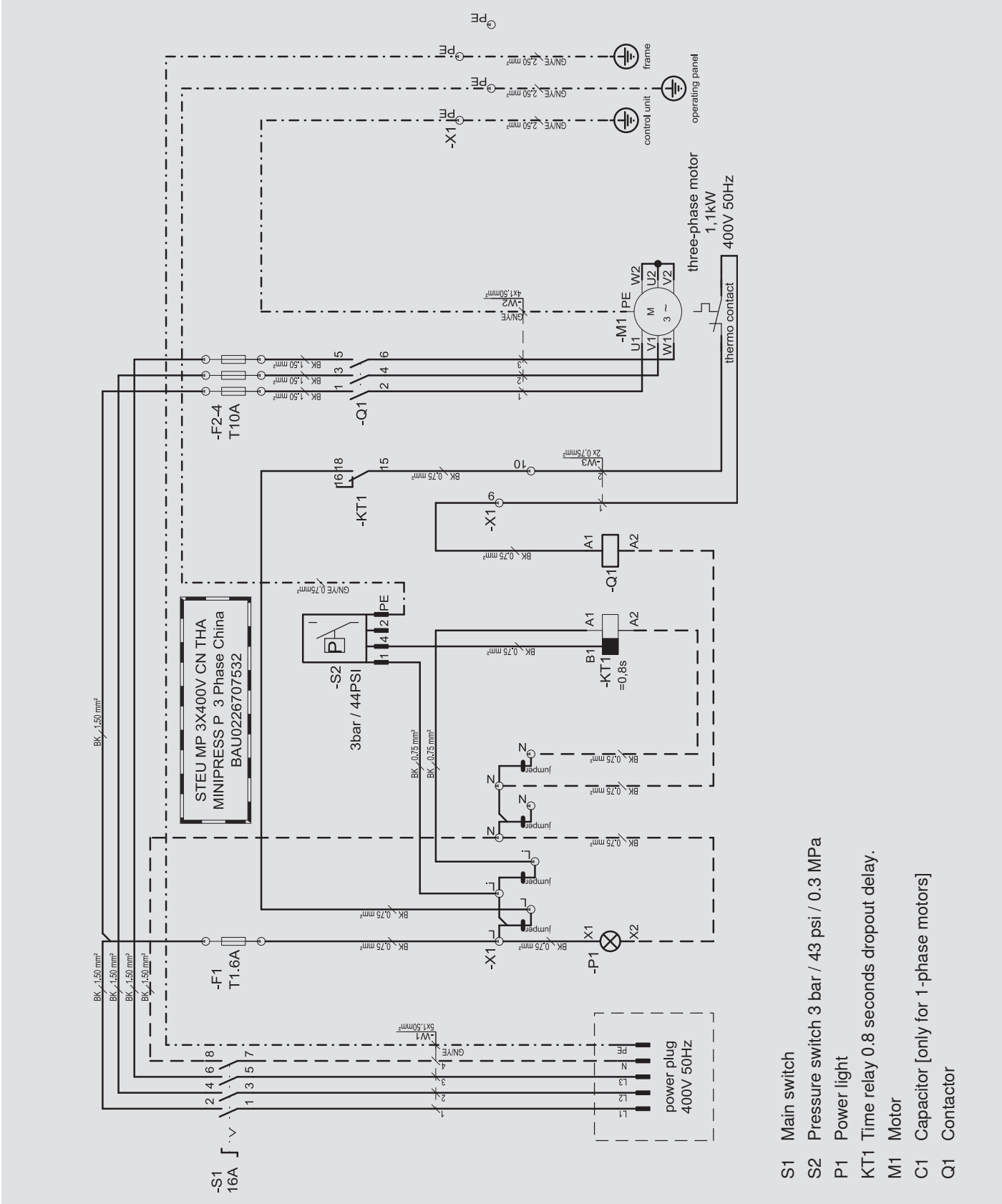
- S1 Main switch
- S2 Pressure switch 3 bar / 43 psi / 0.3 MPa
- P1 Power light
- KT1 Time relay 0.8 seconds dropout delay.
- M1 Motor
- C1 Capacitor [only for 1-phase motors]
- Q1 Contactor

Additional information

MINIPRESS P



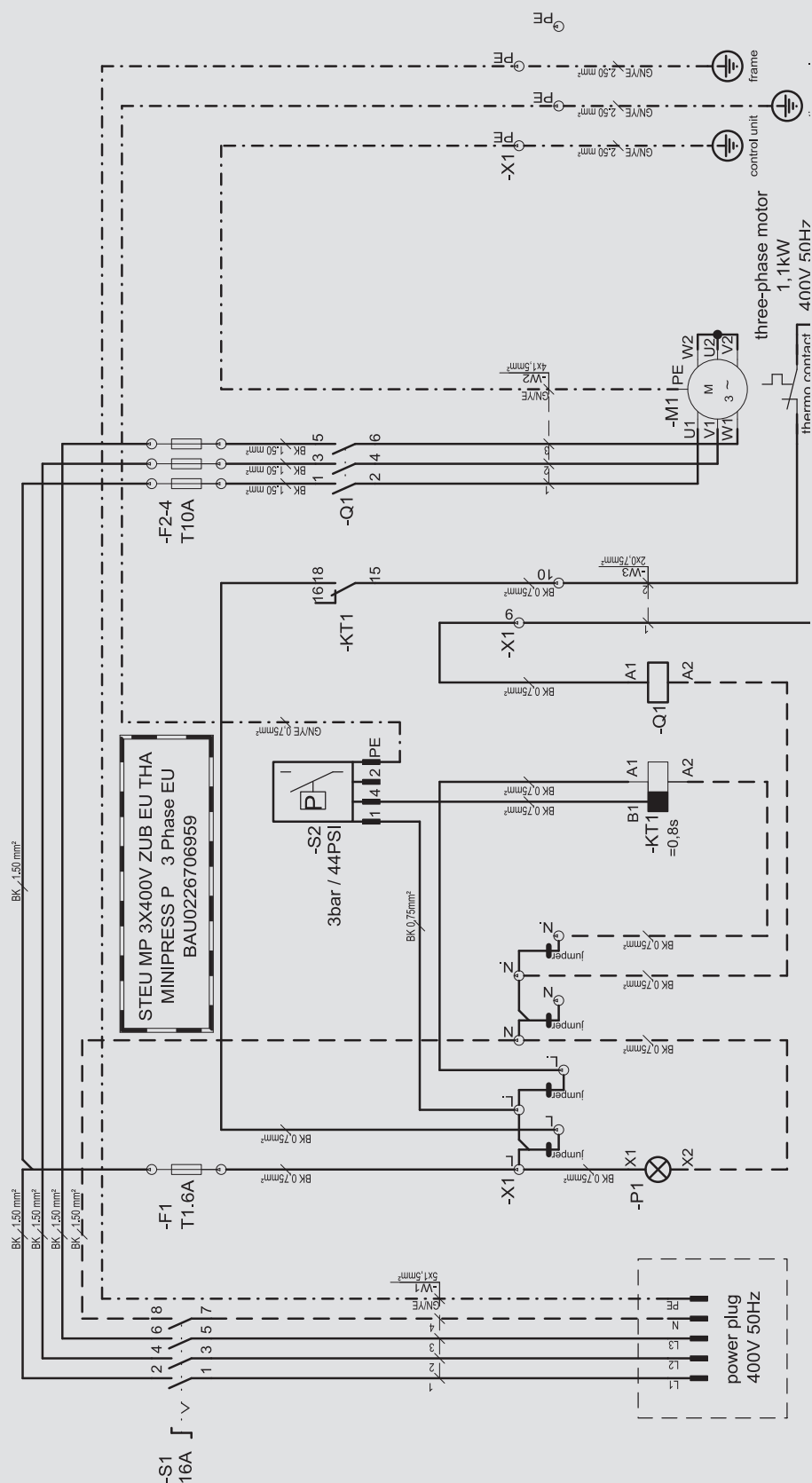
Electrical diagram 3X400V CN



-
- Wiring diagram for a 3-phase motor control system. The diagram shows a power plug (400V 50Hz) connected to a main switch (S1) and a pressure switch (S2). The main switch is connected to a 3-phase motor (M1) through a contactor (C1) and a capacitor (C1). The pressure switch is connected to a power light (P1) and a time relay (KT1). The time relay is connected to a motor (M1) and a capacitor (C1). The diagram also shows a fuse (F1) and a thermal relay (TR1).
- Legend:
- S1 Main switch
 - S2 Pressure switch 3 bar / 43 psi / 0.3 MPa
 - P1 Power light
 - KT1 Time relay 0.8 seconds dropout delay.
 - M1 Motor
 - C1 Capacitor [only for 1-phase motors]
 - Q1 Contactor

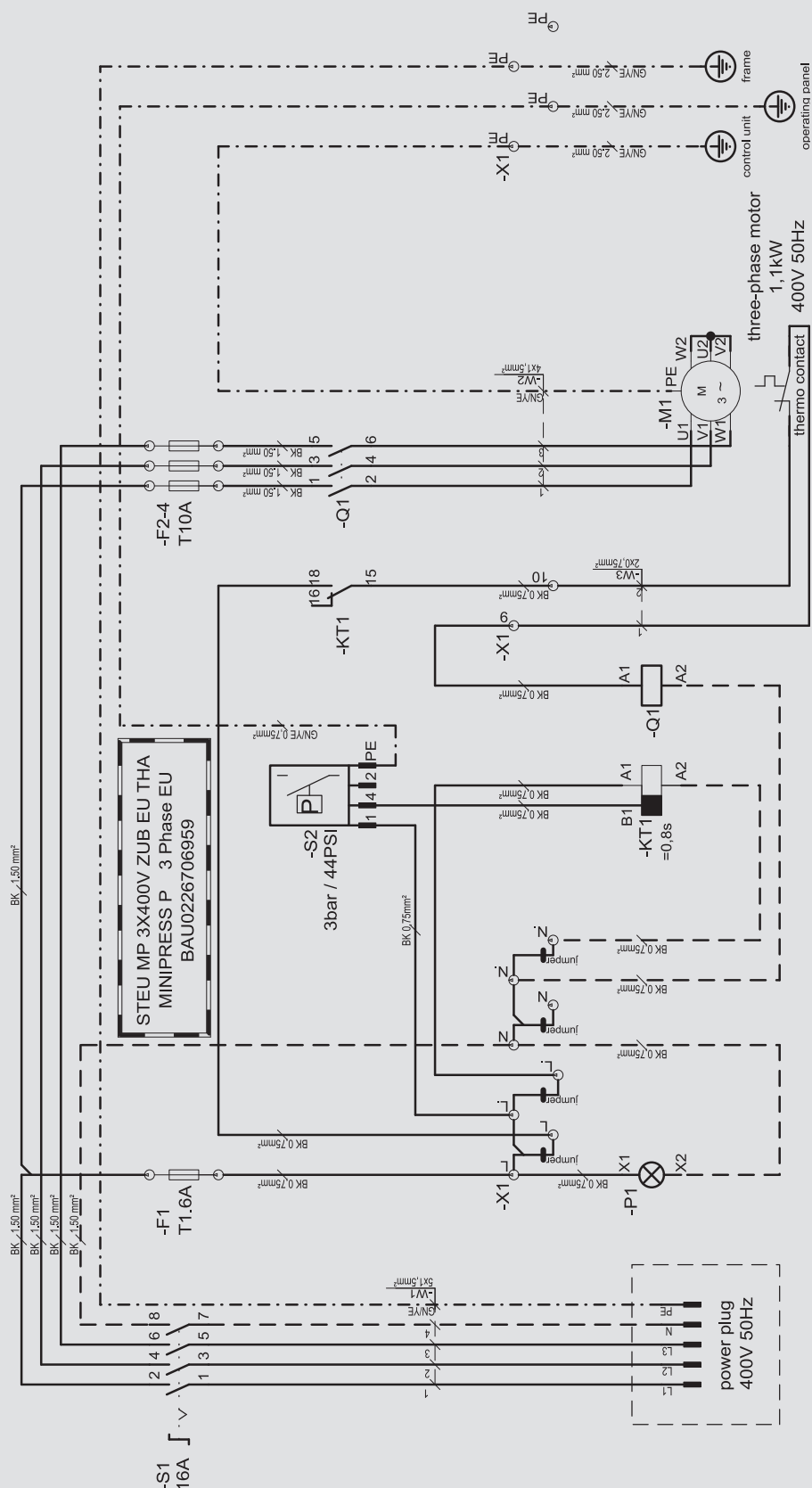
Additional information

Electrical diagram 3X400V ZUB EU



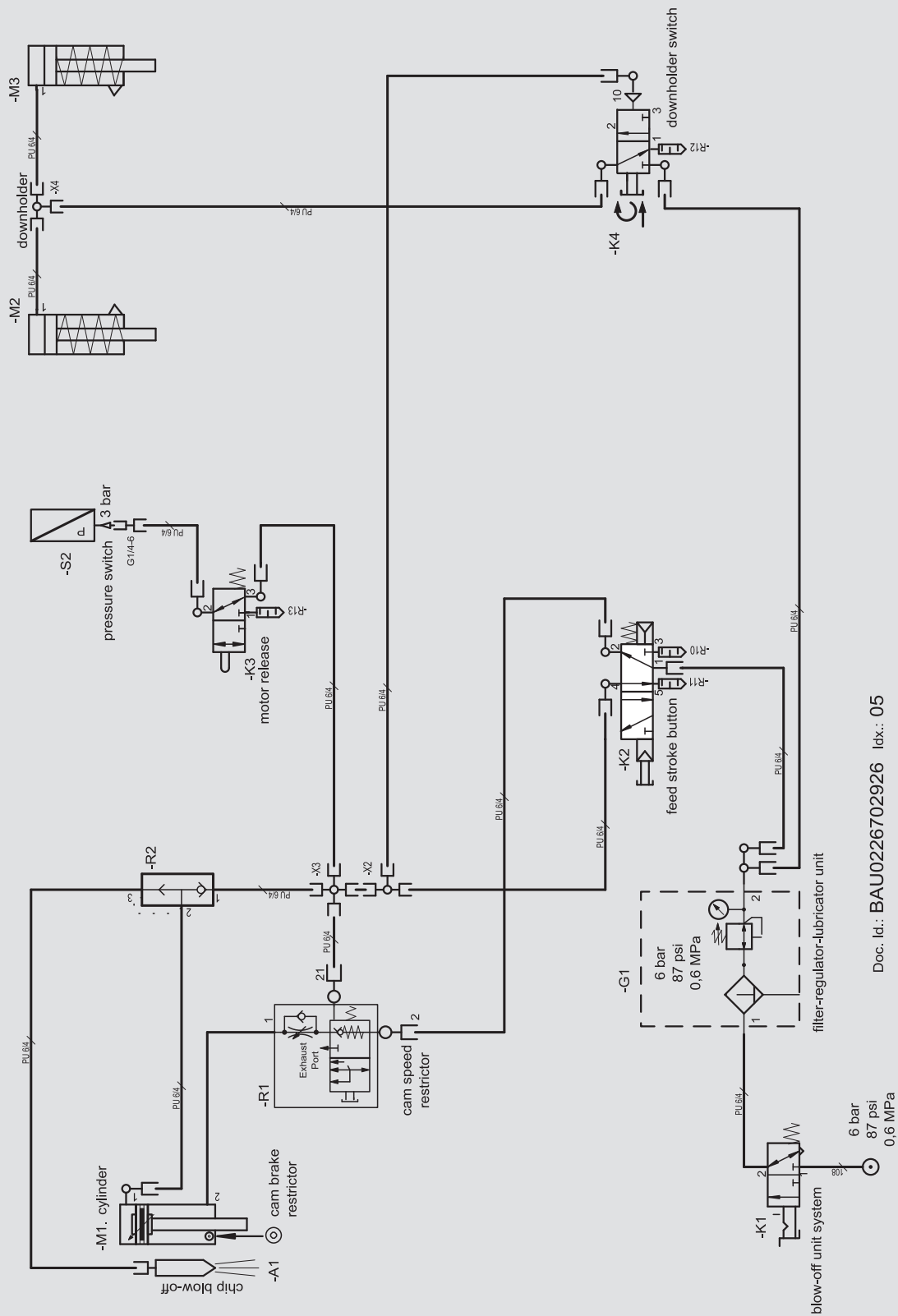
- | | |
|-----|--|
| S1 | Main switch |
| S2 | Pressure switch 3 bar / 43 psi / 0.3 MPa |
| P1 | Power light |
| KT1 | Time relay 0.8 seconds dropout delay. |
| M1 | Motor |
| C1 | Capacitor [only for 1-phase motors] |
| Q1 | Contactors |

Electrical diagram PH 3X400



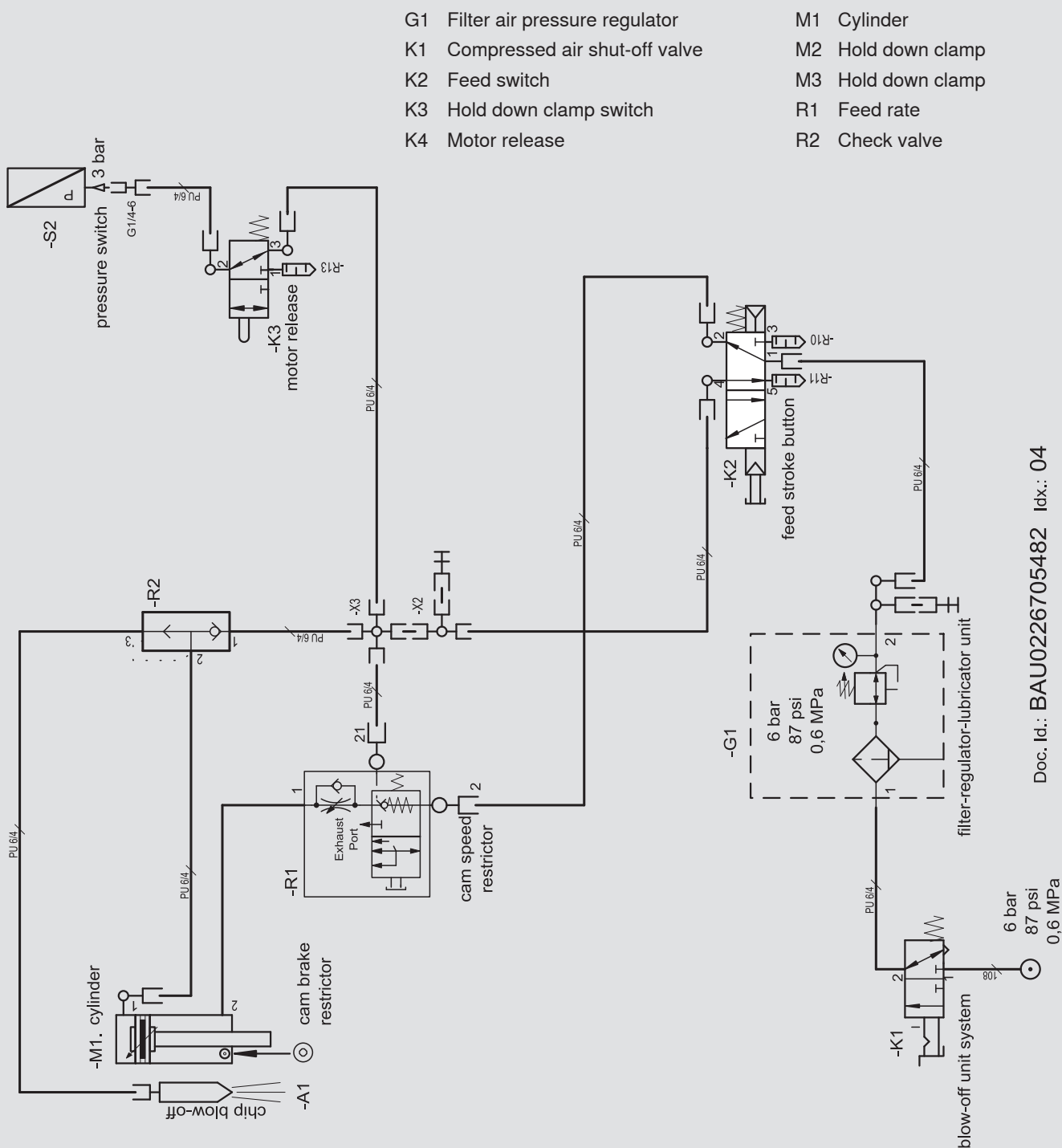
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- C1 Capacitor [only for 1-phase motors]
- Q1 Contactor

Pneumatic diagram

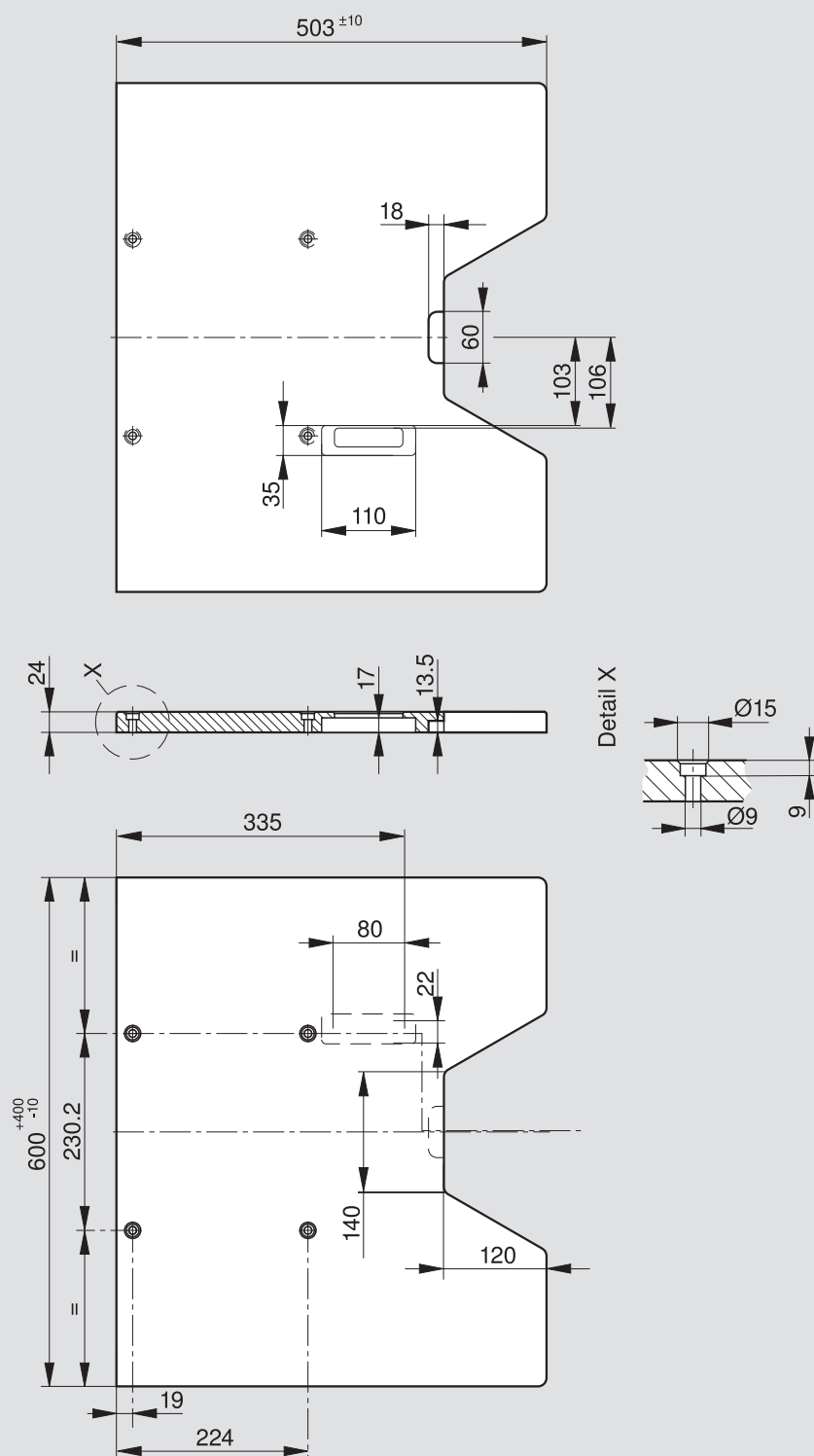


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Pneumatic diagram

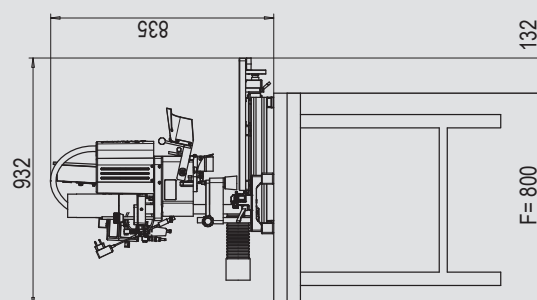
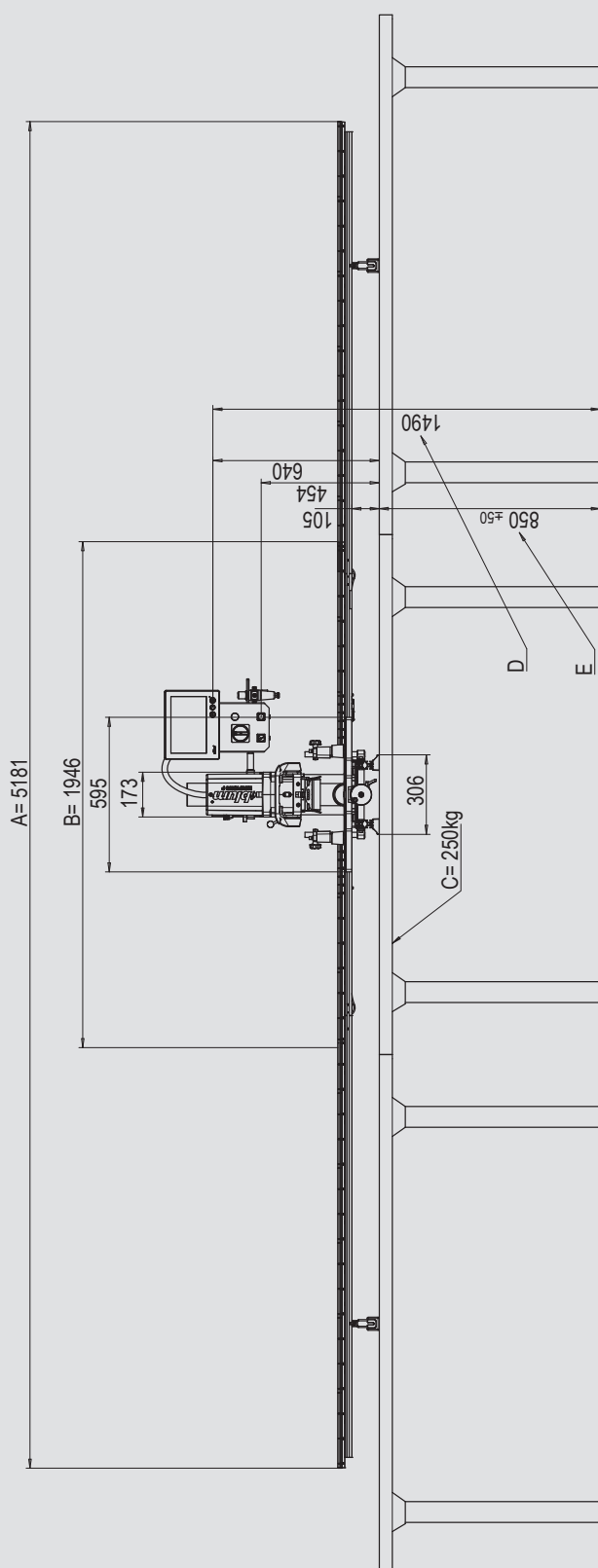


User-supplied work table [5]



- If you are making your own work table [5], use plywood or laminated wood.
- In addition, please use the supplied screws for fixing the work table [5].

MINIPRESS P and EASYSTICK space requirement



- A EASYSTICK in maximum position with ruler extensions
- B EASYSTICK in maximum position without ruler extensions
- C Permissible load work table at least 250kg
- D Maximum height of controls at recommended table height
- E Recommended table height
- F Recommended minimum desk depth

MINIPRESS P



Notes

Notes

MINIPRESS P



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