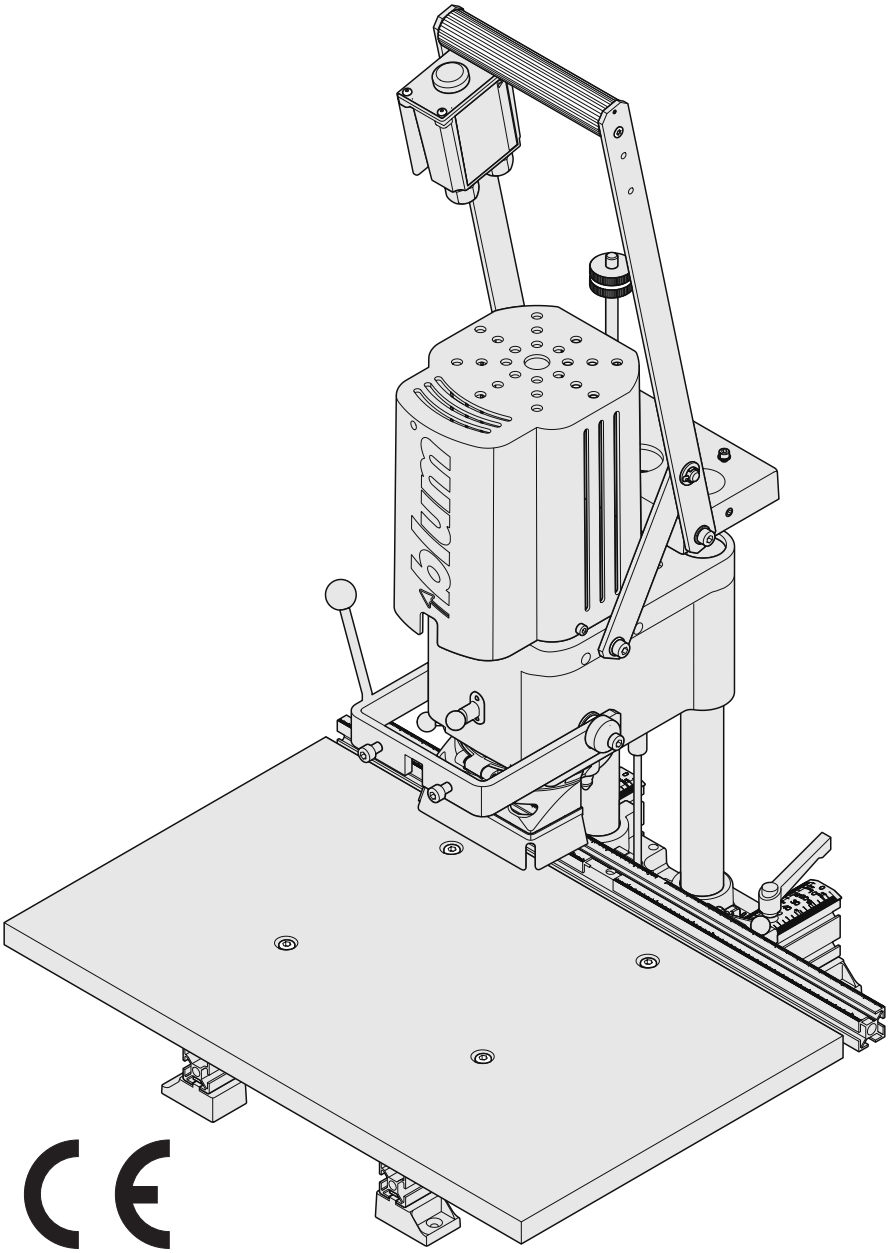
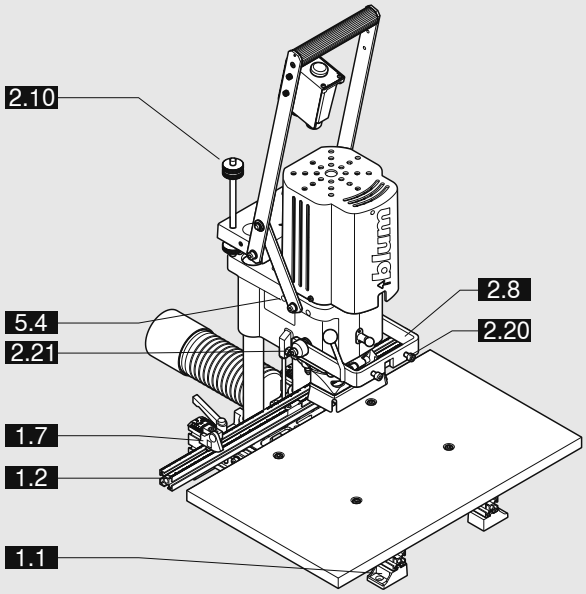


MINIPRESS M

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.

EN

BA-100/1EN M52.XXXX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2.8
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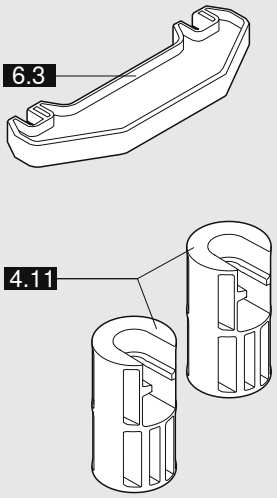
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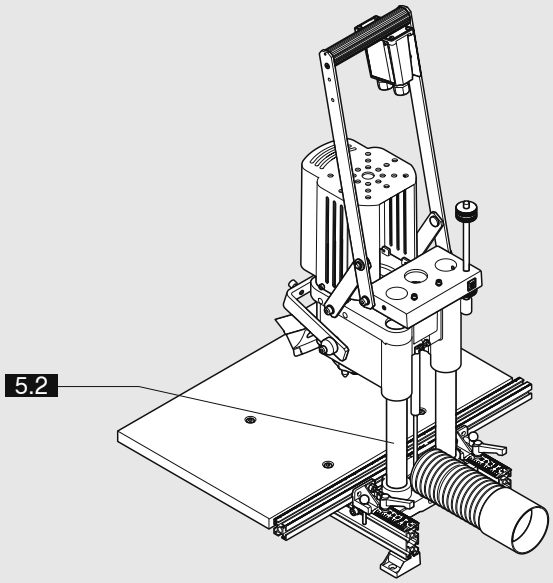
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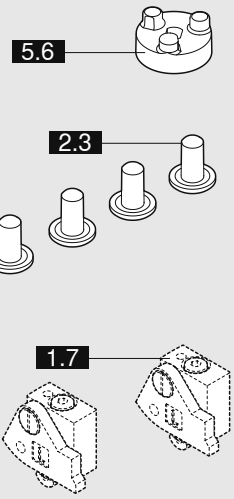
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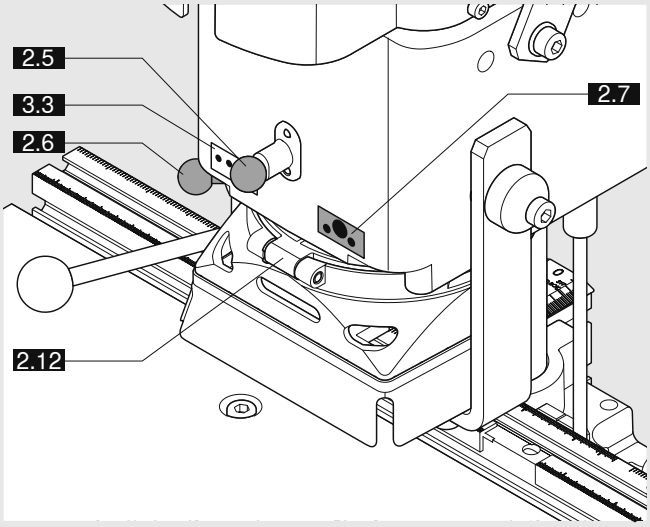
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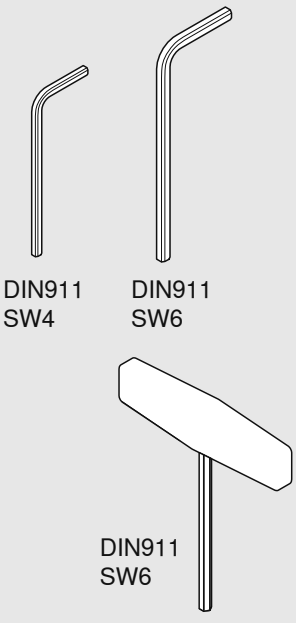
2.12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SW6

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.

(3.1) 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

	Completely read the operating instructions and the safety information before operating the assembly machine
	Wear proper eye and face protection when operating this machine
	Only one person at a time should operate the machine
	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)
	Keep hands away from the drill or swing arm during the drilling or insertion process. Do not remove safety devices - danger of injury.
	Keep hands away from the danger zone. - danger of being crushed

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

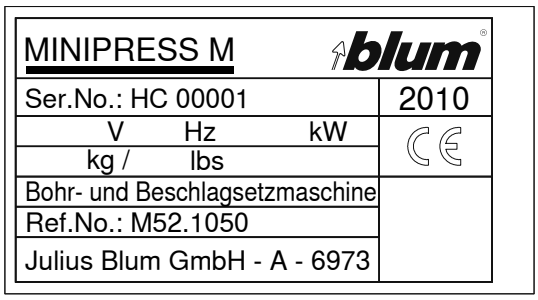
Noise emission levels as per EN ISO 11202 (11204) are:
Work place noise level is (work cycle): 79 dB(A) (measured at a height of 1.5 m and at 1 m forward of the worktable edge. The ambient correction factor K3A is 4 dB and is calculated according to EN ISO 11204 Appendix A. The difference between the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



BG	Пробивни машини
DA	Bore- og beslagssætmaskiner
DE	Bohr- und Beschlagsetzmaschine
EN	Drilling and insertion machine
ET	Puurimis- ja sisestusmasinad
FI	Asennusporakoneet
FR	Machine pour percer et poser des ferrures
EL	Μηχάνημα διάτρησης και τοποθέτησης
IT	Macchina forainseritrice
LV	Urbšanas un furnitūras iestrādāšanas iekārta
LT	Gręžimo-montavimo staklės
NL	Boor- en beslagmachines
PL	Maszyna do nawiercania i osadzania okuć
PT	Furadeira e máquina para a montagem de ferragens
RO	Maşină de găurit şi montat feronerie
SV	Borr- och beslagsmonteringsmaskiner
SK	Vŕtací a lisovací stroj
SL	Vrtalni stroj in stroj za okovje
ES	Máquinas para taladrar y de instalación de herrajes
CS	Vrtací a lisovací stroje
HU	Fúró- és vasalatbepréselő gépek

F.1 - EC Declaration of Conformity

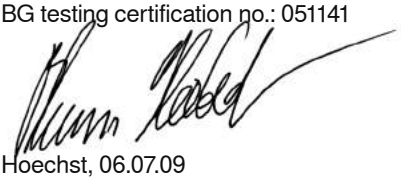
Julius Blum GmbH, Industriestr. 1, A-6973 Höchst herewith declare on our own responsibility that the product MINIPRESS (M52.xxxx) with drilling heads (MZK.1000, MZK.1900, MZK.8000, MZK.8800) to which this Declaration refers, complies with the following EC Directives:

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



Hoechst, 06.07.09
Dipl.-Ing. Herbert Blum
Managing Director
www.blum.com

Documentation authorised agent:
Dipl.-Ing. (FH) Thomas Maier,
www.blum.com

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

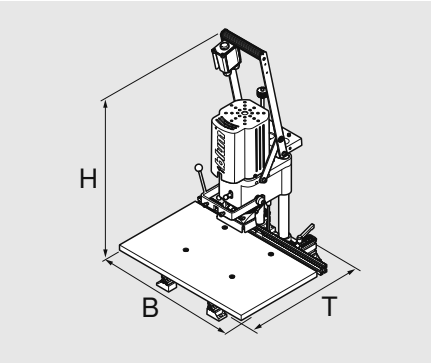
- Drilling distance centre spindle: 0 - 70 mm

5) Max. drilling diameter

- Max. drilling diameter 45 mm

6) Accessories

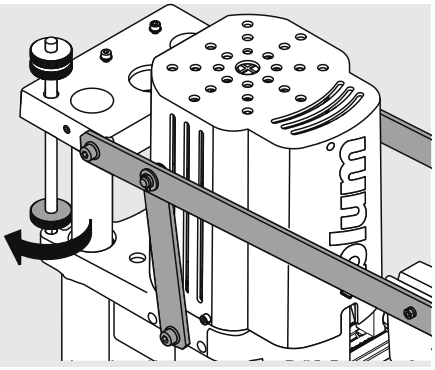
- For accessories see BLUM complete catalogue



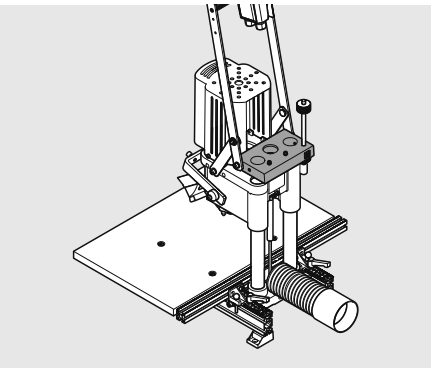
1.1 - Unpacking and assembly

1.1.1) Assembly machine space requirement

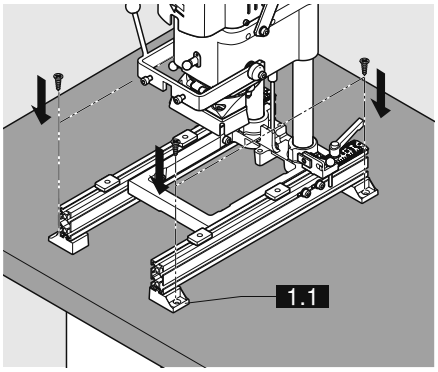
H= 966 mm
B= 600 mm
T= 531 mm



- Completely loosen bottom knurled screw



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

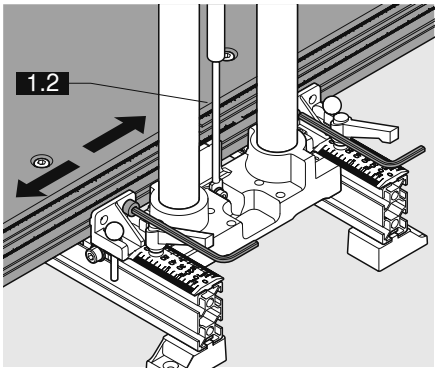


1.1.2) Unpacking assembly machine and attaching to a suitable table

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

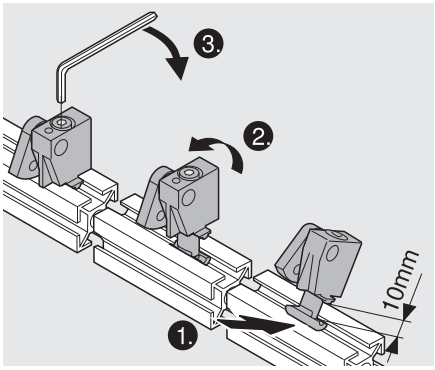
ATTENTION:
The assembly machine weighs approx. 37 kg.
The table must be of sufficient stability to accommodate this

- Pre-drill holes and then attach assembly machine (1.1) 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 (1.2) base ruler

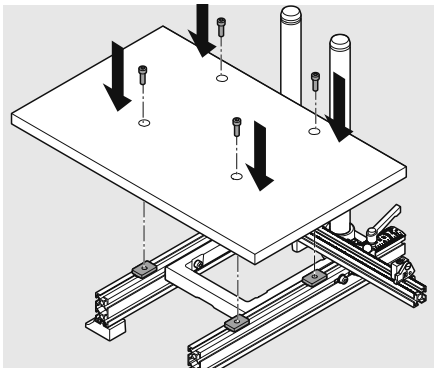
- Place ruler on fixing
- Centre ruler drilling with the drilling of the runner plate
- Clamp ruler



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

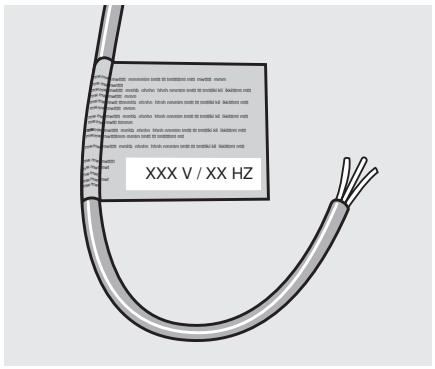
Note:
This procedure can also be used to set a stop between two available stops.



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

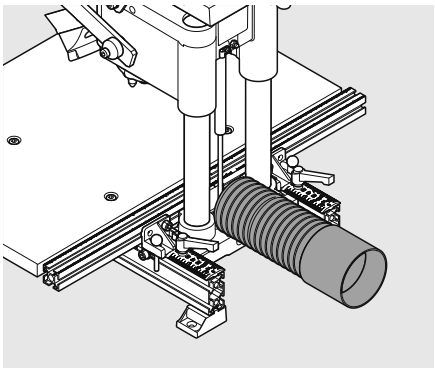
b) Above table is not supplied with machine unless ordered seperately. For details of how to construct a work table, see Chapter 7 - Appendix



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

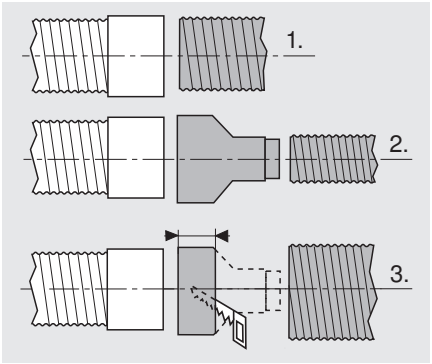


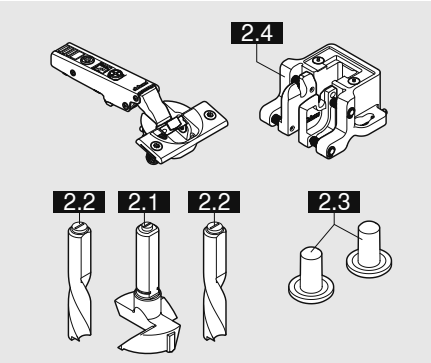
1.4 - Dust extraction

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 (image 1.4.2) 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.

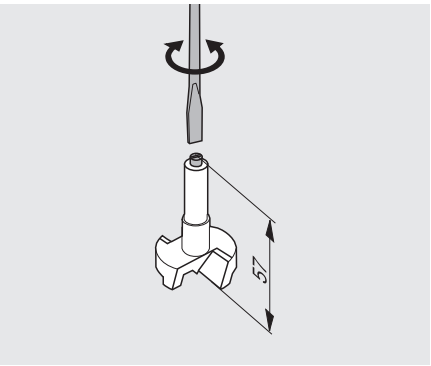




2.1 - Furniture hinge assembly

2.1.1) Required parts

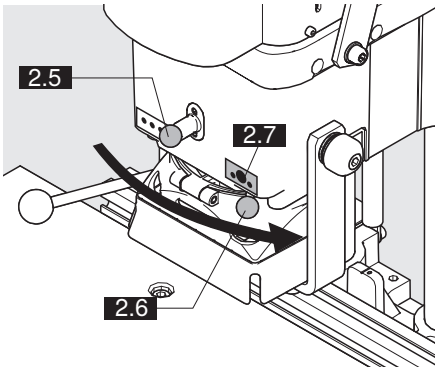
- Drill bits:
  1x ø 35 mm clockwise (2.1) (marked in black)
  2x ø 8 mm counterclockwise (2.2) (marked in red)
- Cover caps (2.3)
- Insertion ram MZM.00XX (2.4) (see catalogue to determine the proper insertion ram for the respective furniture hinge)
- Furniture hinge



2.1.2) Setting drill bit length

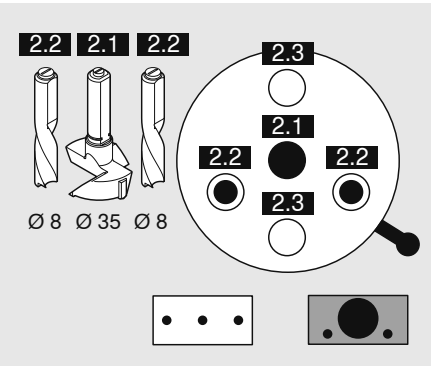
- The total length of the drill bits (from bit-tip to adjustment screw) should be 57 mm
- To correct drill bit length, adjust screw accordingly using a screwdriver

! Important:
All drill bits must be the same length



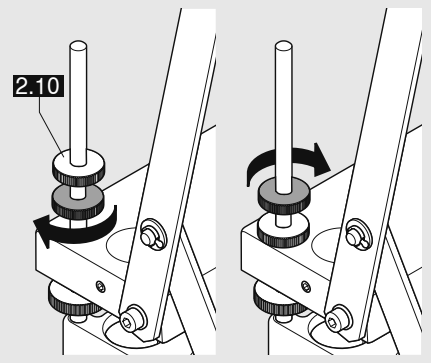
2.1.3) Setting drilling pattern

- 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)



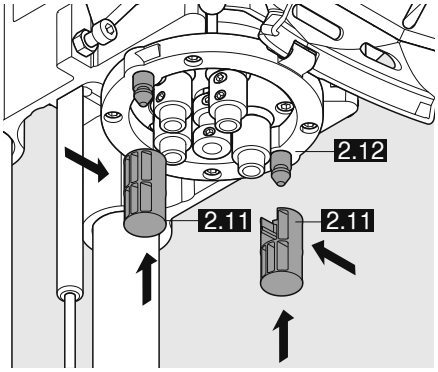
2.1.4) Inserting drill bits

- 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 (2.11)

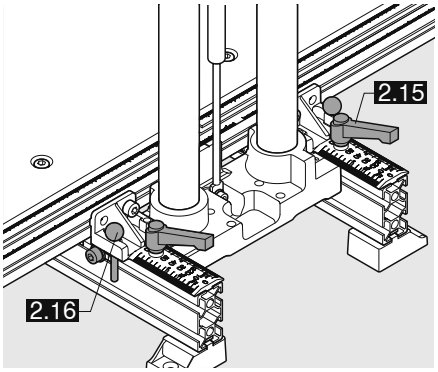
Another option to maintain a constant drilling depth is to install the drilling depth stop. When the drilling depth stop is installed, the drilling depth is always 13 mm regardless of the thickness of the work piece.

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 (2.12) until it engages and turn 90 degrees with force.
- Attach drill bit

IMPORTANT:

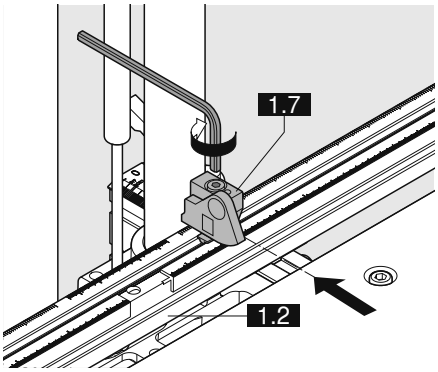
The drill bit length must be set to 57 mm. (See point 2.1.2). The knurled screw should not jut out before the drilling depth is reached. (See point 2.1.5)



2.1.7) Setting the stop system

- Loosen the clamping lever (2.15)
- Remove locking pin (2.16) and set gauge (1.4) to the MB.
- Secure the clamping lever (2.15)

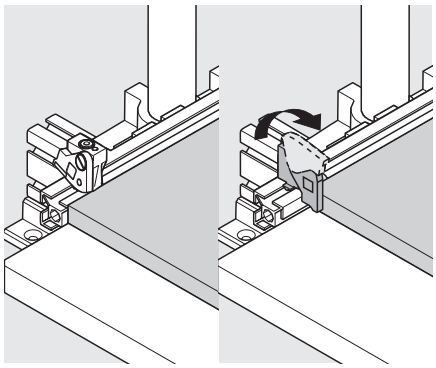
This fixed setting provides a drilling distance of 22.5 mm.



2.1.8) Setting swivel stops (optional) (1.7)

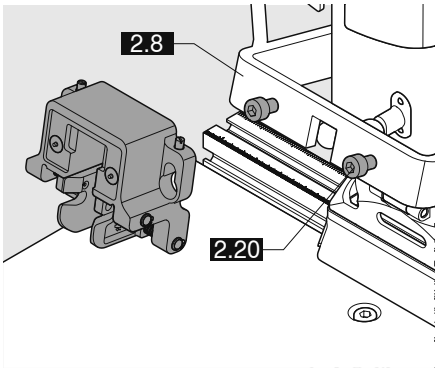
Set the swivel stops (1.7) to the desired dimension and clamp.

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



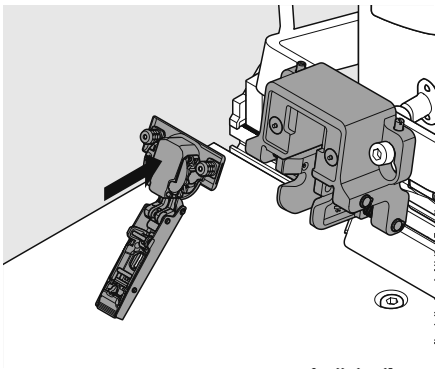
2.1.9) Placing door on the work table and pushing up against the stop

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

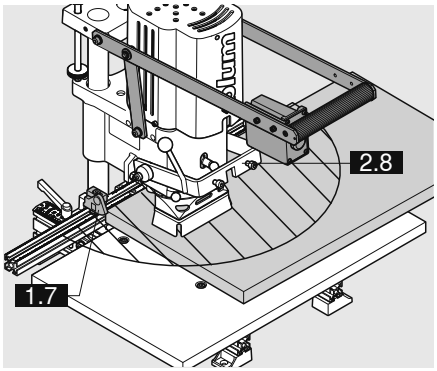


2.1.10) Attaching insertion ram to swing arm (2.8)

- 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.



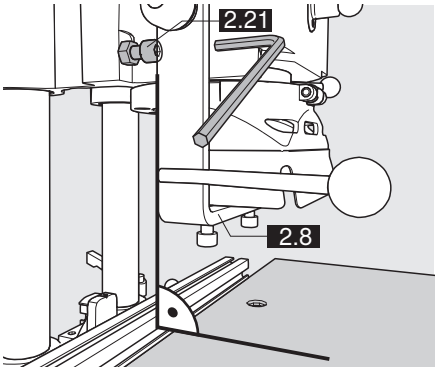
2.1.11) Clipping furniture hinge on to the insertion ram



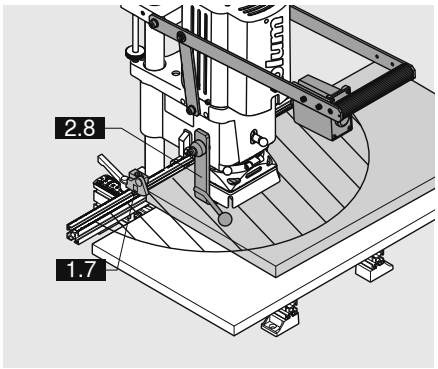
2.1.12) Drilling

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 (1.7) .
- Push handle down
- Press motor button
- Drill until the correct depth is reached
- Release motor button



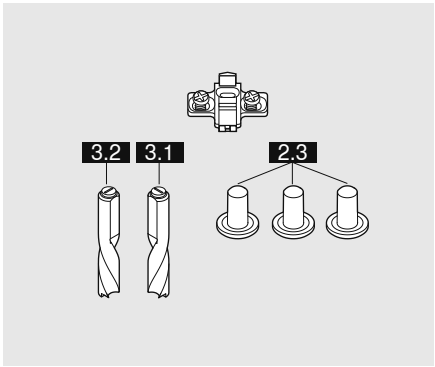
2.1.13) Checking the tilt adjustment of the swing arm (2.8)
- Swivel down swing arm (2.8) to the stop.
- Check whether or not the furniture hinge is aligned with the drilling.
- If it is misaligned, this can be caused by two things:
  a) Swivel arm (2.8) is not set vertical.
  - Use the screw to correct 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 (1.7)

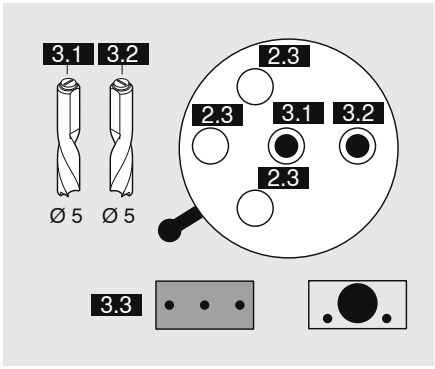


3.1 - Cruciform mounting plate assembly

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)

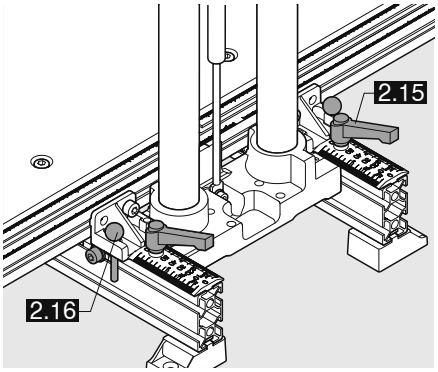


3.1.3) Setting drilling pattern

- 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)

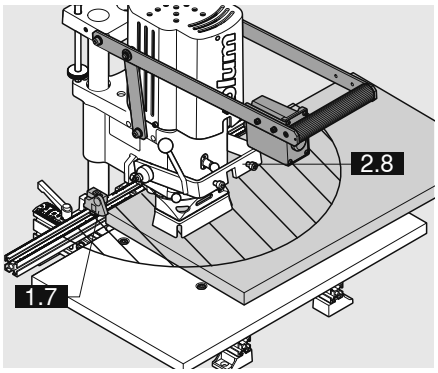
3.1.5) Checking drilling depth setting
(see points 2.1.5 / 2.1.6)



3.1.6) Setting the stop system (1.4)

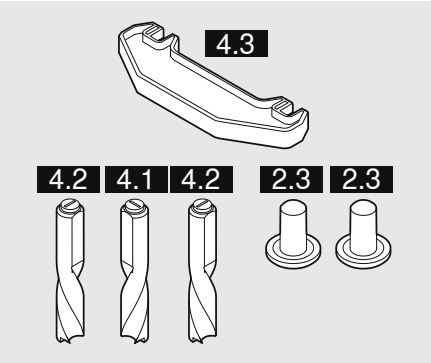
- Loosen the clamping lever (2.15) .
- Remove locking pin (2.16) and set gauge (1.4) to SY.
- Secure the clamping lever (2.15) .

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)



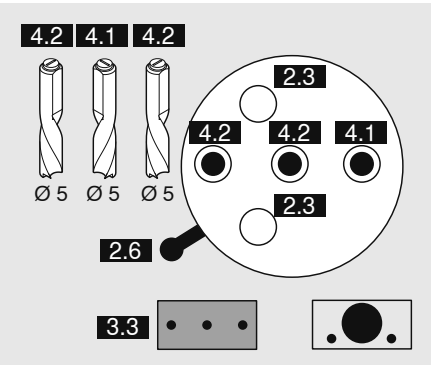
4.1 - Drilling hole groups

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

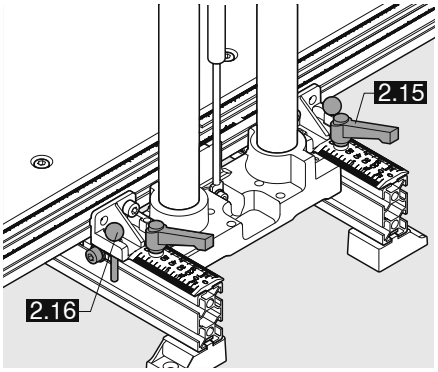
- Pull sprung loaded knob out (2.5) .
- At the same time, move the lever (2.6) to symbol (3.3)
- Release knob back to original position (2.5) .

4.1.4) Inserting drill bits into the chuck

(See point 2.1.4)

4.1.5) Checking drilling depth setting

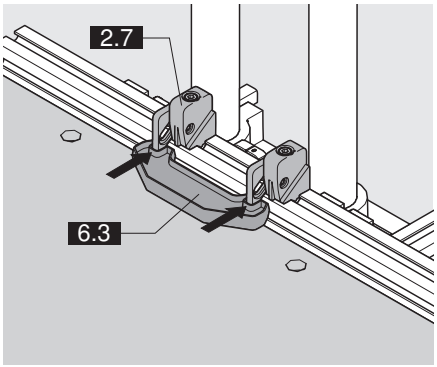
(see points 2.1.5 / 2.1.6)



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.



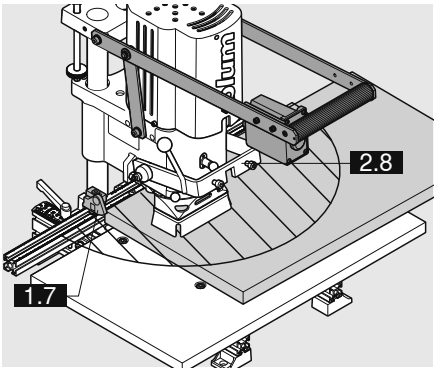
4.1.7) Setting the swivel stops (1.7)

(See point 2.1.8)

4.1.8) Drilling hole groups

- Place setup gauge (4.3) 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.

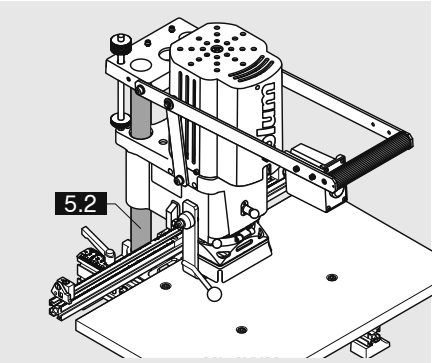


4.1.9) Placing carcase side on the work table and pushing up against the stop

(See point 2.1.9)

4.1.10) Drilling

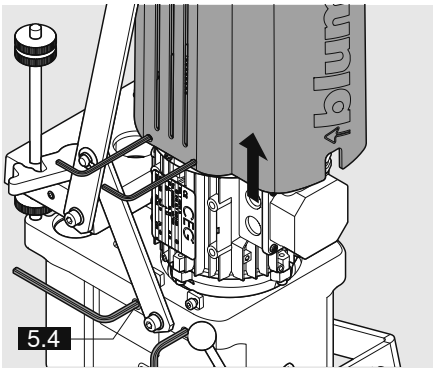
(See point 2.1.12)



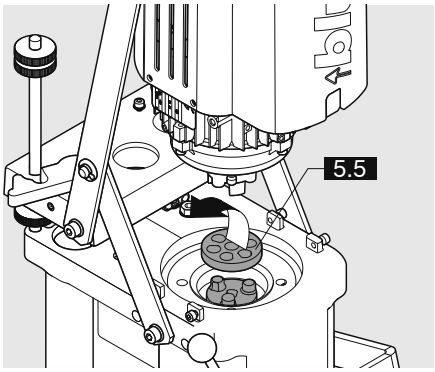
5.1 - Maintenance

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



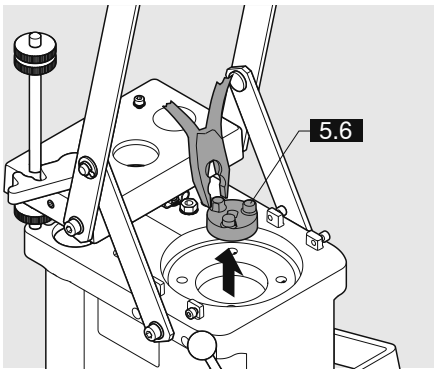
- The supports are maintenance free and should not be oiled
- The guide elements (5.2) must be cleaned regularly with a dry cloth to remove dust. (Do not use cleaners or solvents)



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.

ATTENTION:
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



ATTENTION:
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

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

6.1 - Error during drilling

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

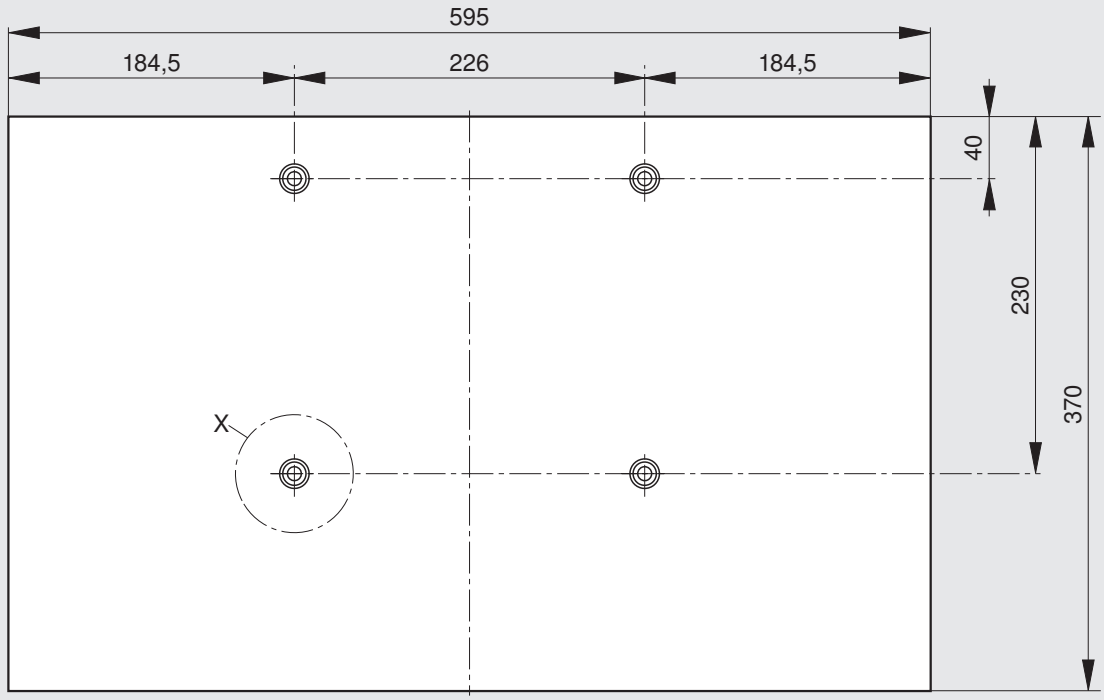
6.2 - Fitting insertion error

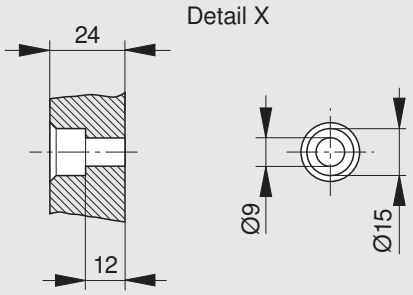
Error	Cause	Solution	Comment
Fittings cannot be inserted or only with great difficulty	Insertion ram or swing arm is driving against an object (e.g. swivel stop)	Remove object	none
	The surface of the work piece is too hard	Bevel drillings	Use slip-on counter-sink
	Drillings are not deep enough	See point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

6.3 - Function errors

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

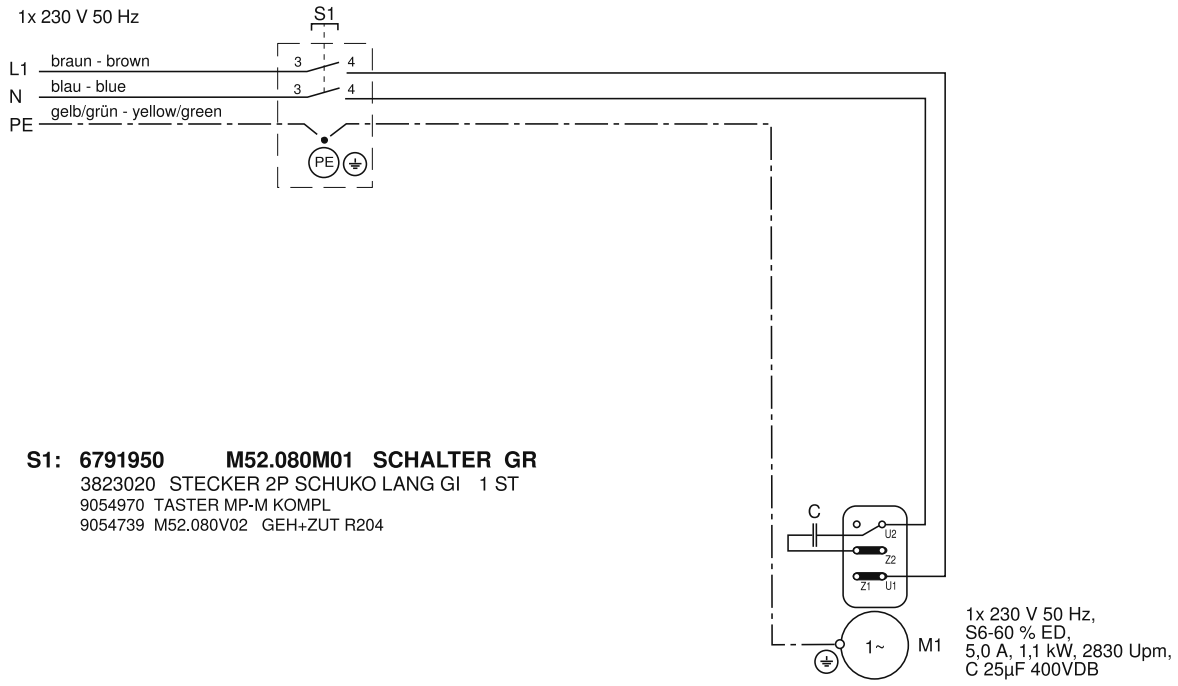
7.1 – User-supplied work table





- 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



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3823020 STECKER 2P SCHUKO LANG GI 1 ST
9054970 TASTER MP-M KOMPL
9054739 M52.080V02 GEH+ZUT R204

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