

M35.7200

EN

 **blum**[®]

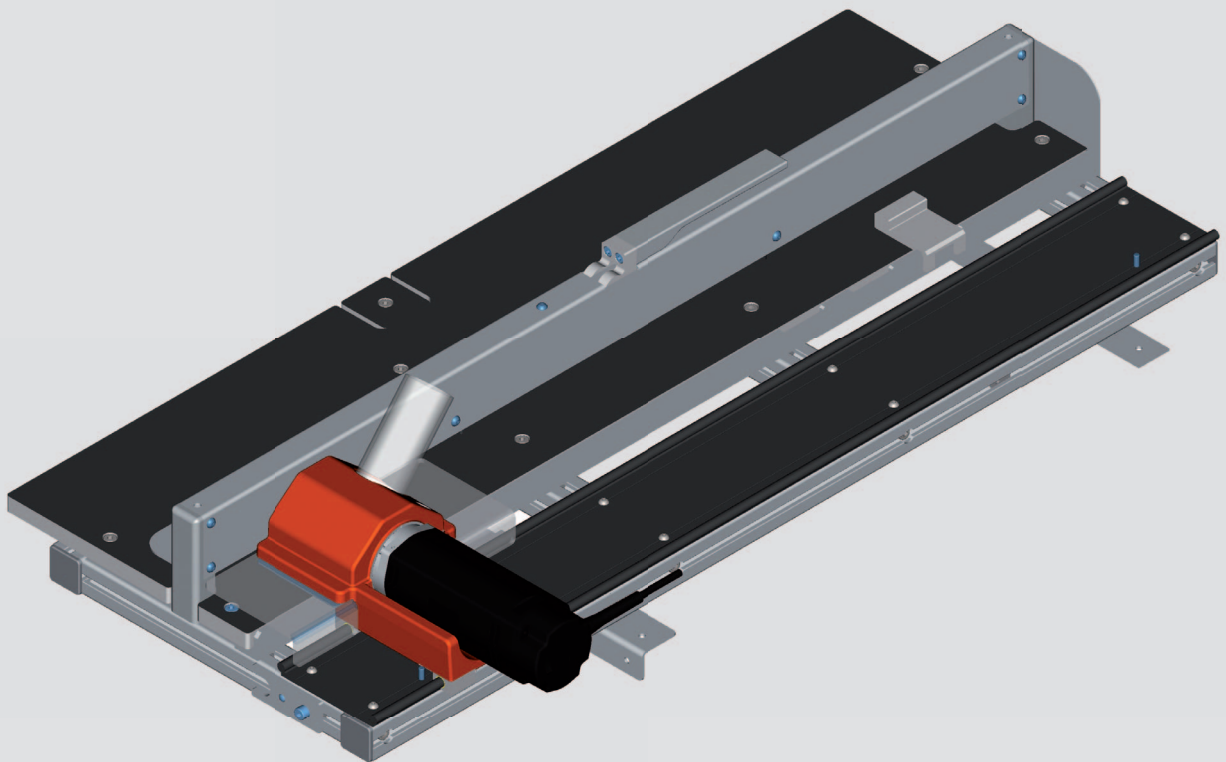


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Safety Handling

- Please read the instruction leaflet and the safety information before starting up the base notching device.
- We recommend that you use the reference diagram for easier identification of the parts being described.

Safety principle

The base notching device conforms to current safety standards. Nevertheless, certain risk factors will remain if the information contained in this instruction leaflet is not observed.

Residual risk according to DIN ISO EN 12100

- The base notching device is equipped with all the necessary protection features.
- However, some risk factors will remain for the user, particularly when removing the protective equipment or when control units fail.
- Other risks are identified by warning signs and safety information. It is therefore necessary to observe the safety information.

Intended use

The base notching device is only intended to process drawer bases for the Blum LEGRABOX. The base notching device may only be used under the following conditions:

- The base notching device may only be operated by fully trained personnel.
- The base notching device is designed for professional traders.
- Only particle board and medium-density fibreboard (MDF) may be used as the workpiece.
- The device should only be installed in dry, enclosed rooms.
- Only for drawer bases with a thickness of 16 mm.

Foreseeable misuse

No solid wood or hard wood may be processed.

Responsibilities

The operator

- must ensure that the base notching device is only operated and maintained by sufficiently trained staff, who have read and understood the instruction leaflet and, most importantly, the safety section.
- is responsible for ensuring that the base notching device is kept in a safe operating state.
- will stop using the base notching device immediately when faults occur which jeopardise safety.

Risk levels



WARNING

- WARNING indicates a danger that could cause death or serious injury if not heeded.



CAUTION

- CAUTION indicates a danger that could cause injury if not heeded.



NOTE

- The NOTE sign indicates information that should be observed.

Safety information



WARNING



Serious cuts.

Failure to heed this warning may result in personal injury.

- The base notching device must be disconnected from the power supply before cleaning and maintenance.

- The base notching device is only intended for use by **one** person.
- Before starting work, you should check that the protection devices and mechanical parts are functioning properly. Any damaged parts should be replaced by original parts from Blum.
- Do not make any changes or alterations to the base notching device.
- Always apply a protective cover when operating the base notching device.
- For your own safety, use only those accessories which are recommended or specified in the instruction leaflet or Blum sales catalogue.
- Check the electrical cable for damage.
- Failure to observe the instructions and warnings given for this base notching device may result in serious injury.
- The instruction leaflet should be accessible at all times.

Warning signs



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



Keep non-authorized persons
away from the base notching device .

No more than one person may use the base notching device at a
time.



Always wear eye protection when operating this machine.

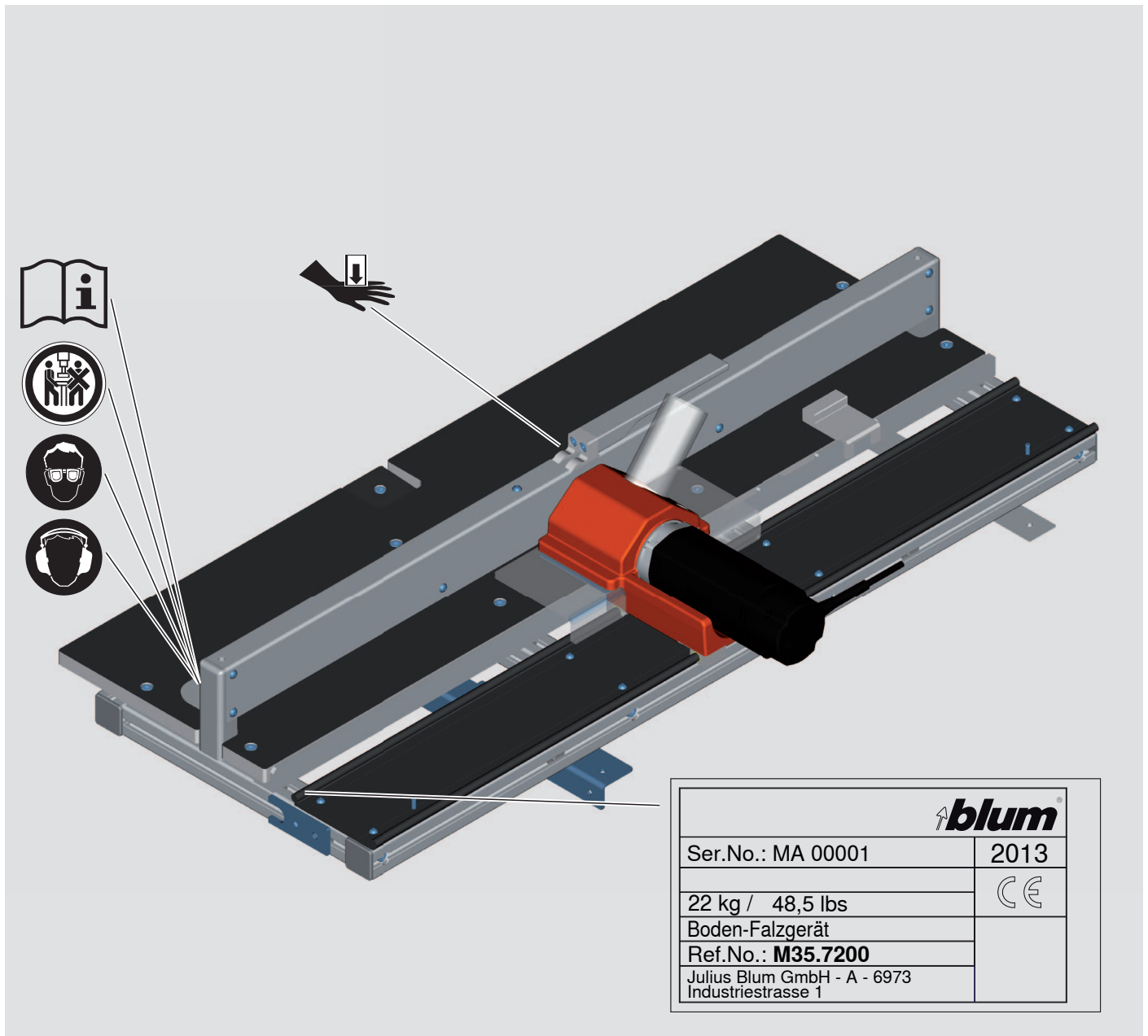


Wear proper ear protection when operating this machine.

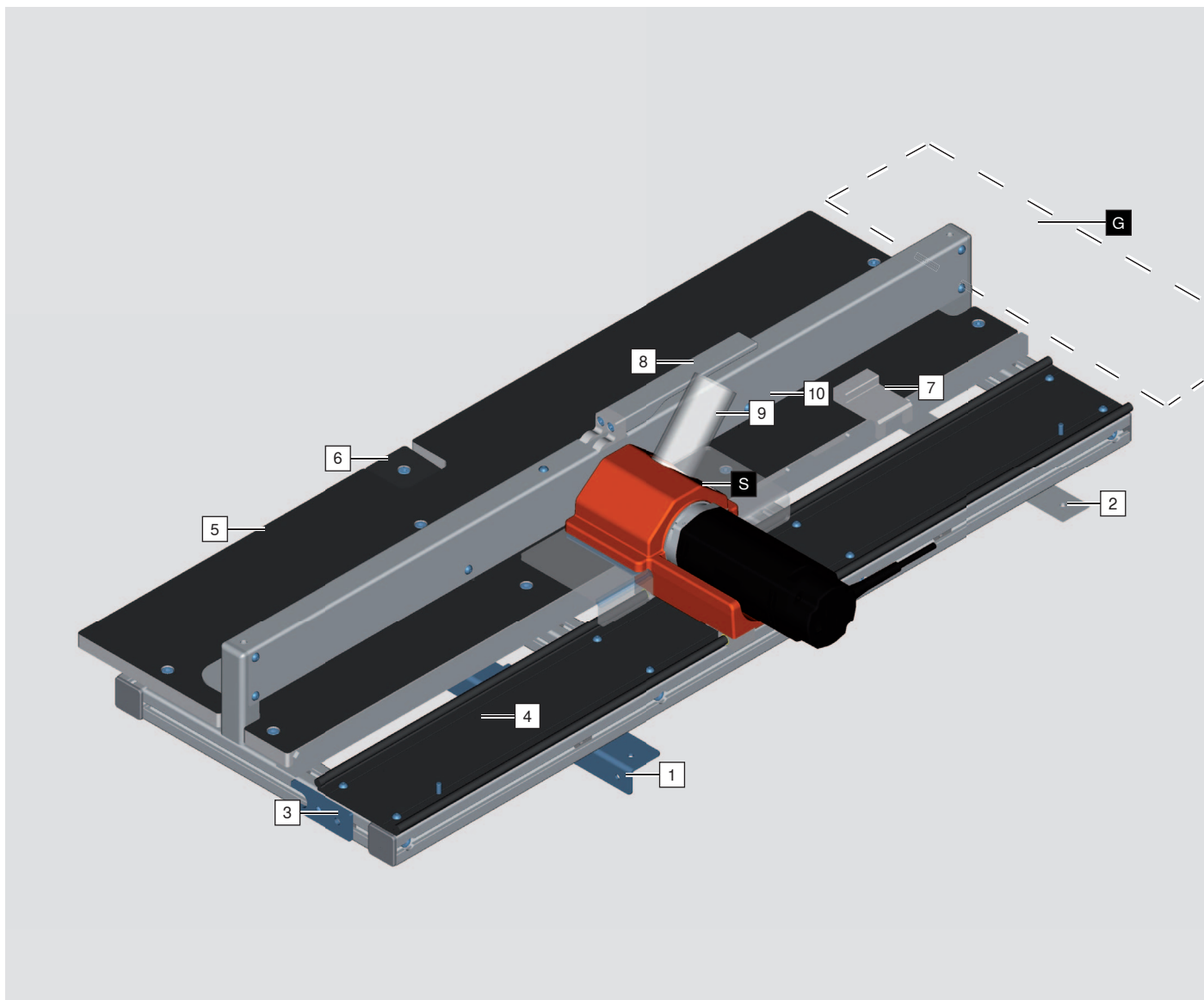


Caution: danger of crushing!

Position of warning signs

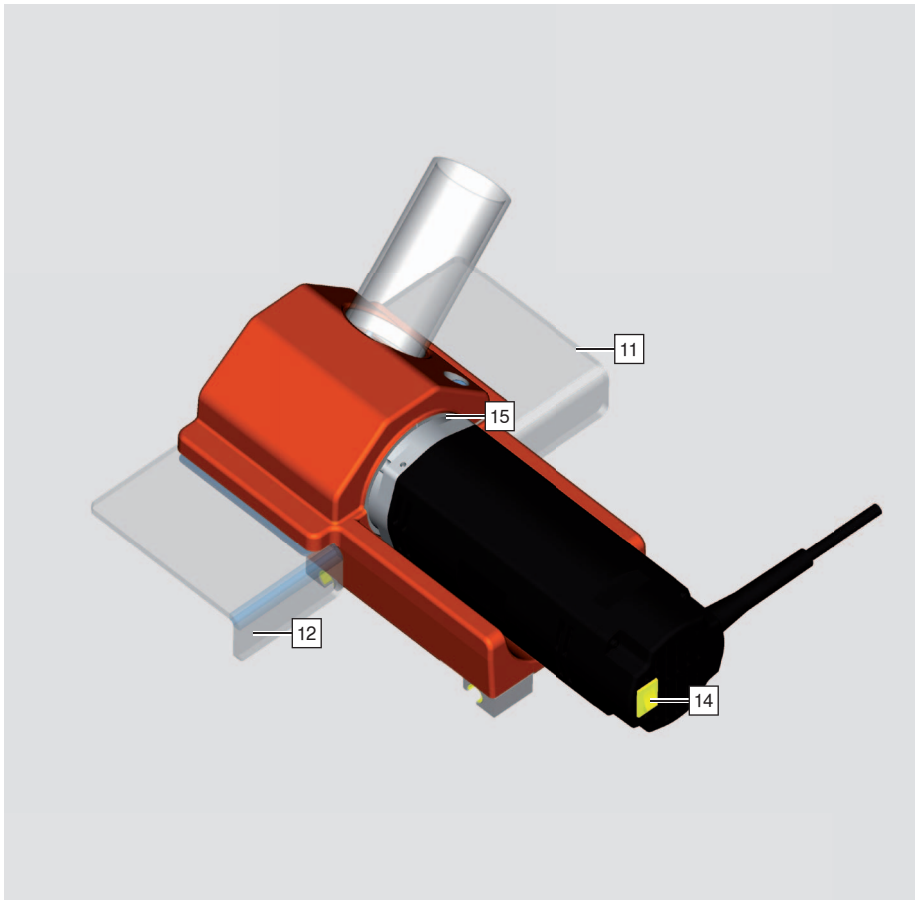


Reference diagram

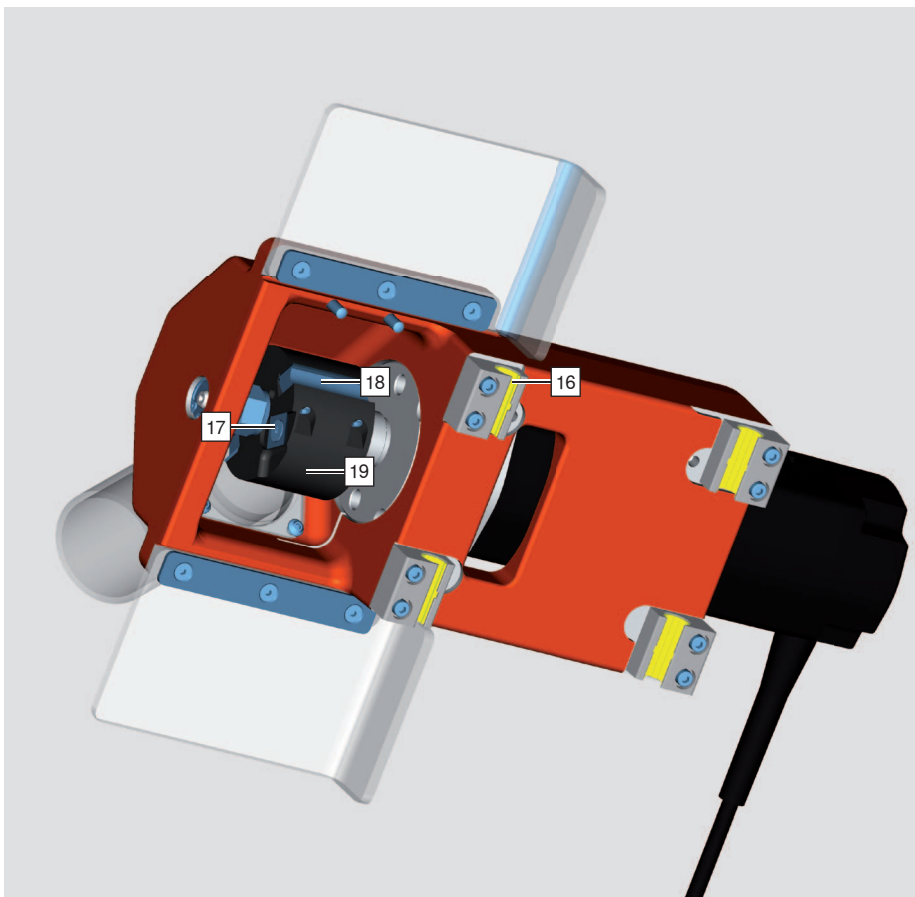


- 1 Fixing bracket (used to secure the device during delivery)
- 2 Fixing board
- 3 Shaft holder
- 4 Runner
- 5 Work top
- 6 Support
- 7 Depth stop
- 8 Clamping lever
- 9 Extraction socket
- 10 Clamping plate
- G Danger zone
- S Carriage

Reference diagram for carriage

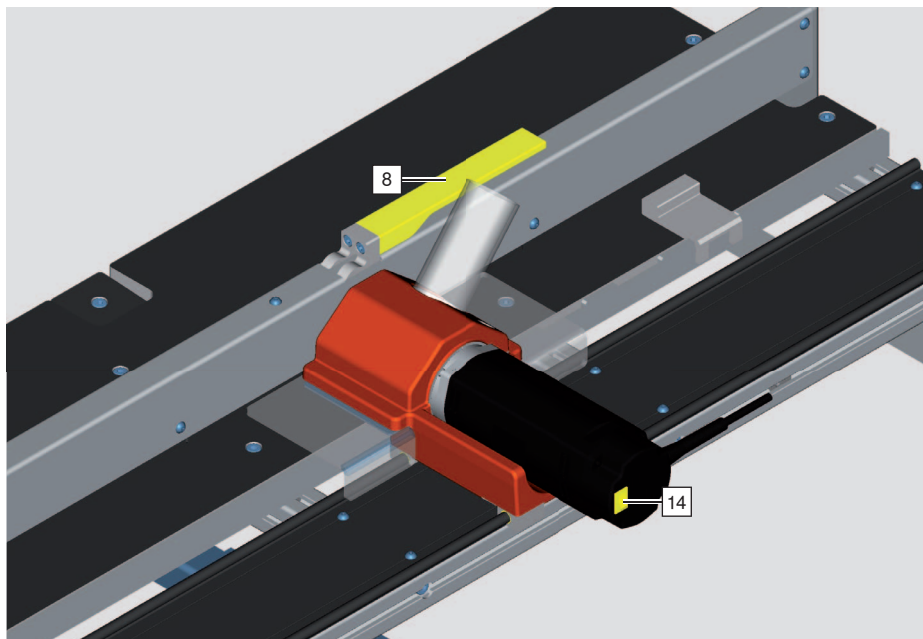


- 11 Rear protective cover
- 12 Front protective cover
- 14 Rocker switch
- 15 Flange surface



- 16 Sliding film
- 17 Pre-cutter
- 18 Cutting insert
- 19 Notch cutter

Operating elements



8 Clamping lever

Press down the clamping lever [8] to secure the workpiece.

14 Rocker switch

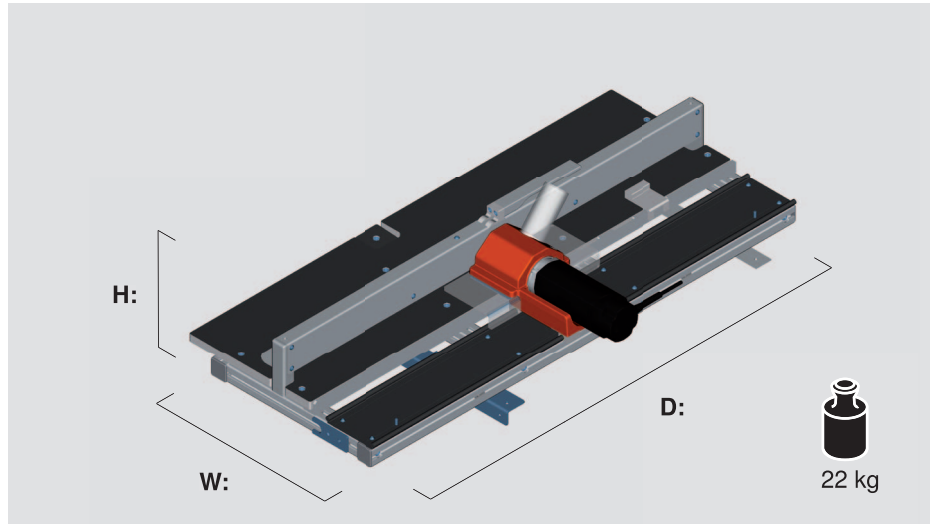
The rocker switch [14] is used to switch the base notching device off and on.

i NOTE

- The rocker switch [14] does not have an inching mode.
- Caution: non-stop operation.

Set-up and start-up

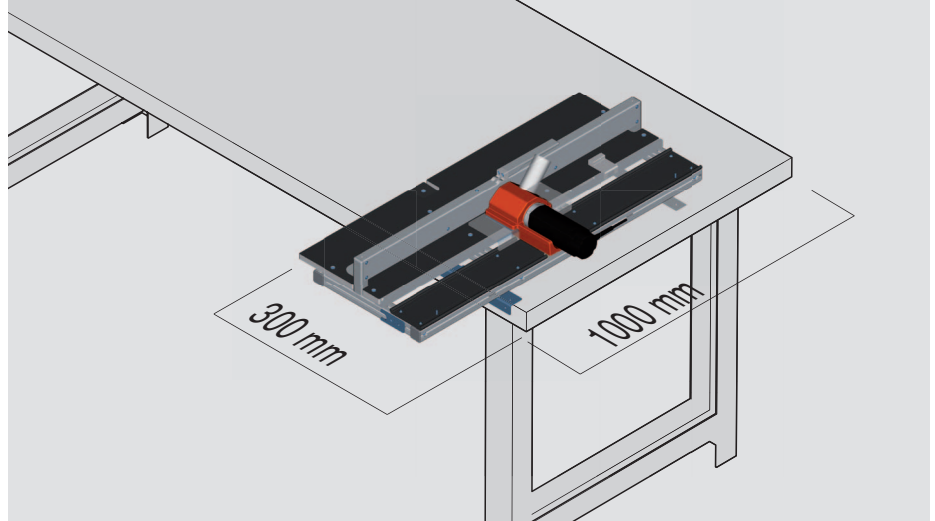
Dimensions



Height (H):	_____	264 mm
Width (W):	_____	584 mm
Depth (D):	_____	1108 mm
Weight:	_____	22 kg

- Should only be used in dry, enclosed rooms.

Required table space



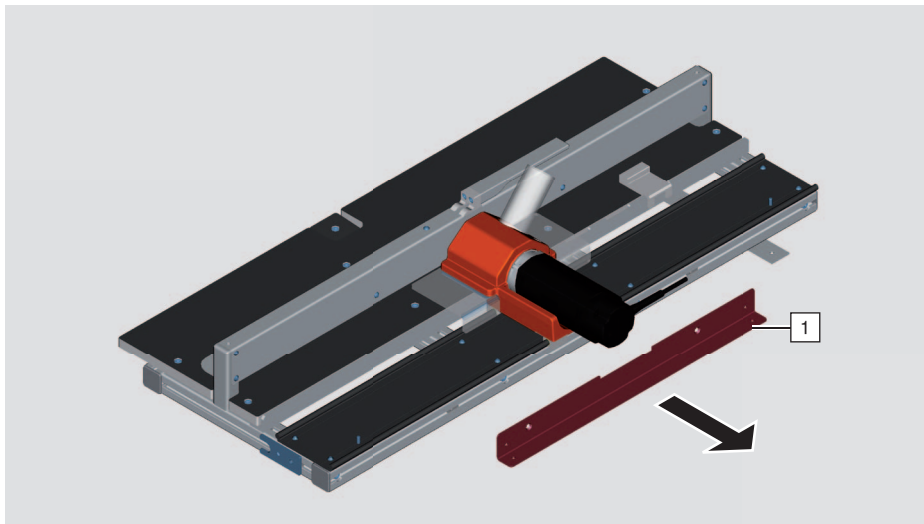
WARNING

The base notching device weighs 22 kg.

Failure to observe this information may result in personal injury.

- The base notching device must be lifted by two persons.

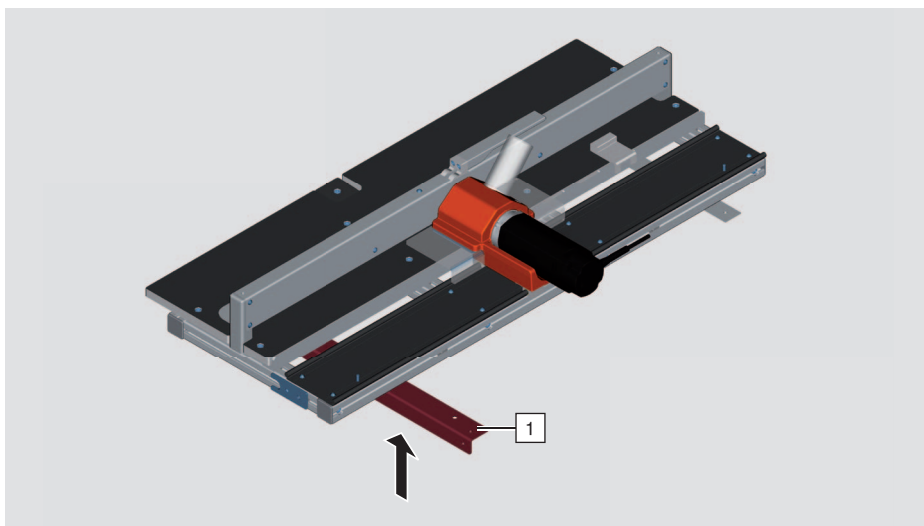
Remove the transport locking device



The carriage on the base notching device is secured by the fixing bracket [1].

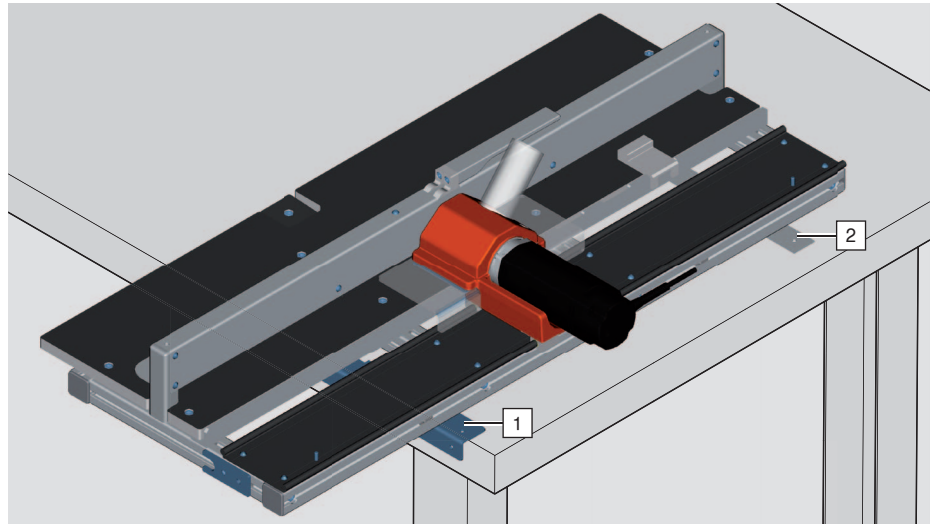
- Loosen the screws.
- Remove the fixing bracket [1].

Applying the fixing bracket



- Pull the base notching device forwards on the table.
- Secure the base notching device to prevent it from falling.
- Apply the fixing bracket [1] as shown.

Fixing to the work top



WARNING

The base notching device must be securely connected to the workbench.

- Screw the base notching device at the fixing bracket [1] and fixing board [2] to the work table.
- Alternatively, the base notching device can be clamped using screw clamps on the fixing bracket [1] and the fixing board [2].

Connecting the power supply

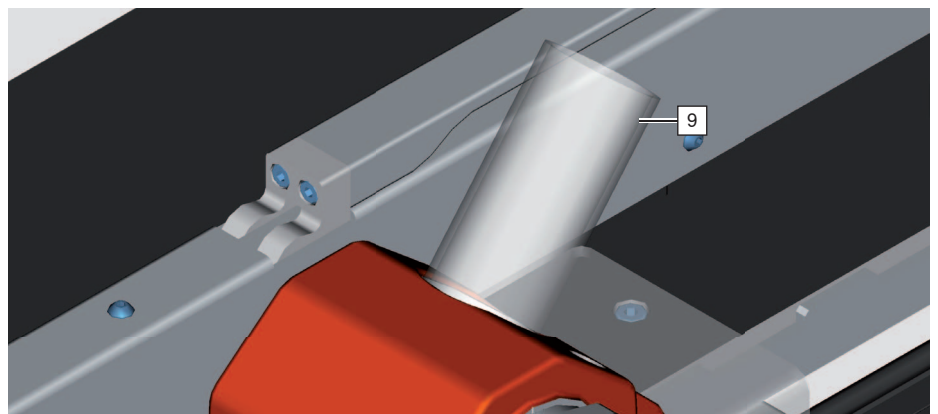
- Insert the plug.
The base notching device is designed for an operating voltage of 230 V, 50 Hz.



NOTE

- After finishing work, disconnect the base notching device from the power supply.

Connecting the extraction system



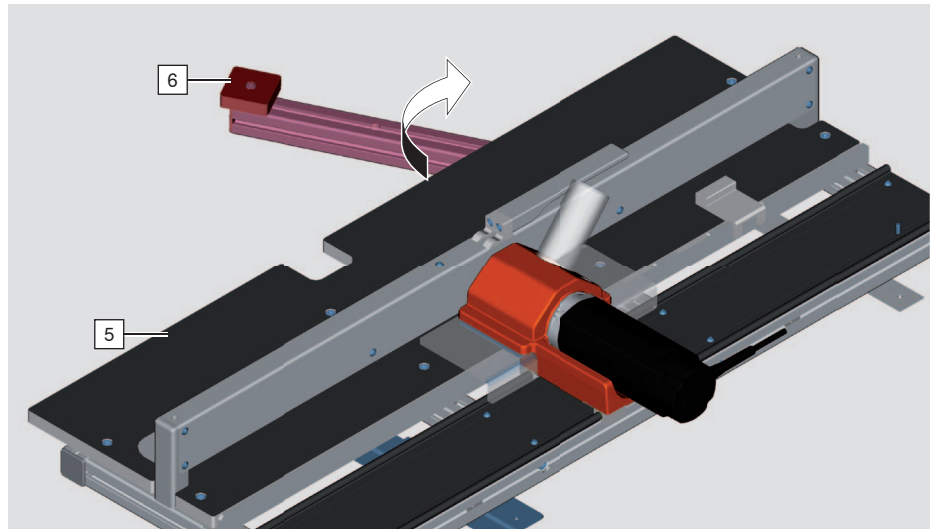
- Insert a spiral hose with an inner diameter of 50 mm into the extraction socket [9] and secure it. Extraction socket [9] outer diameter 50 mm.
- Move the carriage [S] across the full length. Check that the cable and hose can move freely and do not get strained or chafed at any point.
- Make sure that the average air velocity for the extraction system is at least 20 m/sec.

Set-up

Processable drawer bases

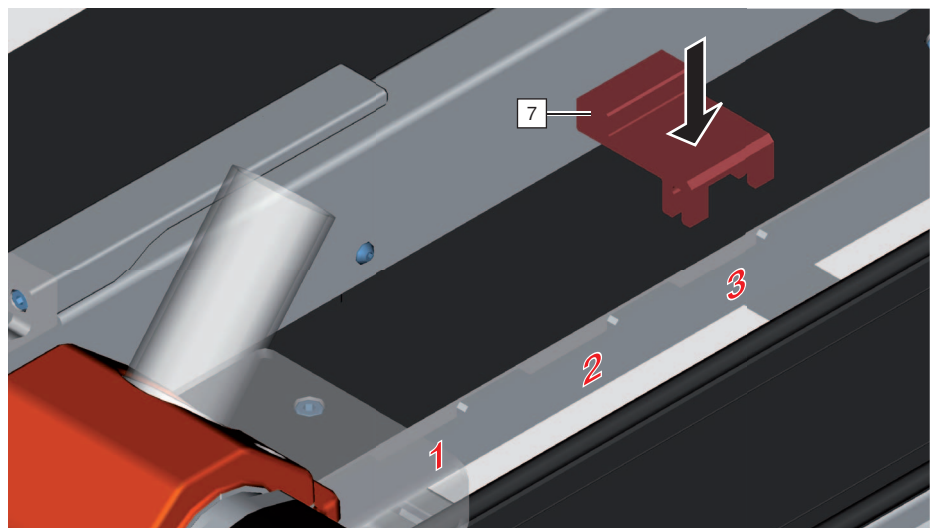
Nominal length of drawer base	for cabinet width	Drawer base
min. 270 mm max. 650 mm	min. 275 mm max. 1200 mm	Thickness 16 mm

Support



- Swing out the support [6] from the drawer base – width 500 mm.
- The workpiece must lie flat on the work top [5].

Using the depth stop



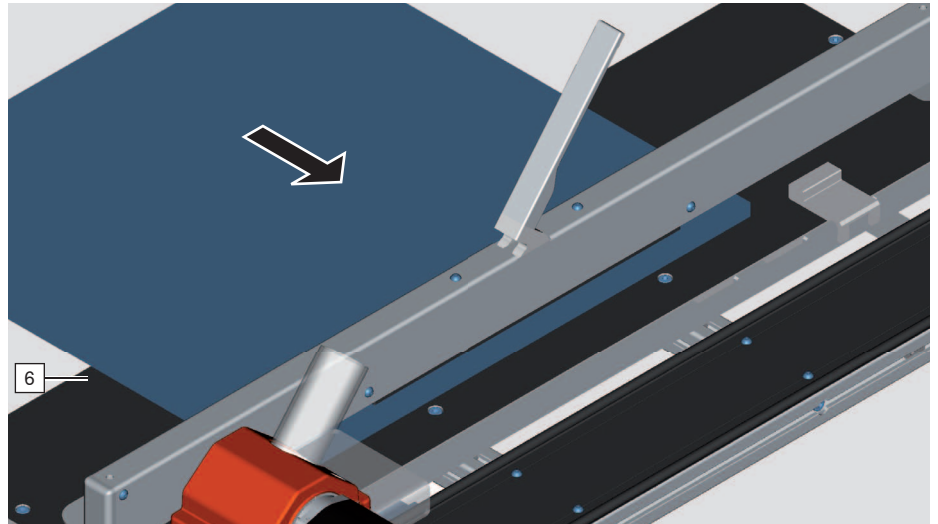
The depth stop [7] prevents tattered edges.

- Clip-on the depth stop [7] in the following positions:

Nominal length of drawer base	
270–350 mm	Position 1
400–550 mm	Position 2
600–650 mm	Position 3

Clamping and milling

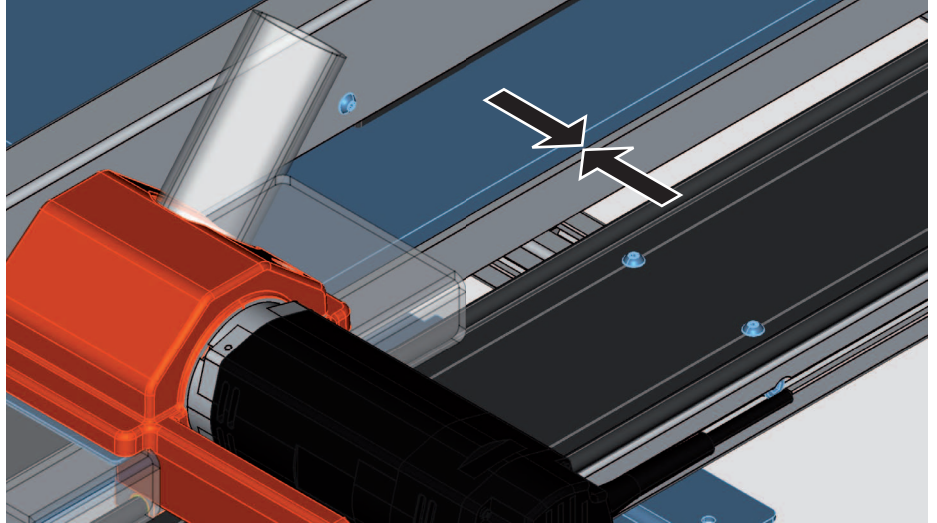
Clamping



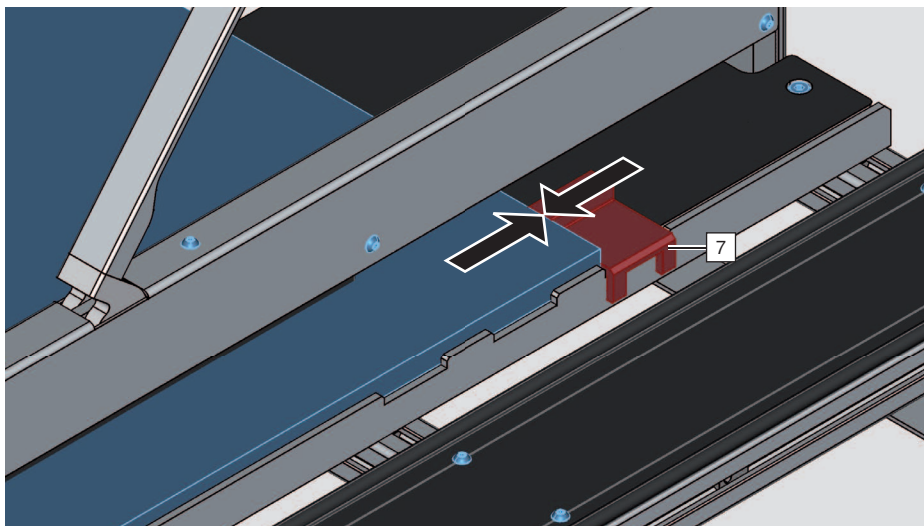
i NOTE

- There should be no wood chips on the work top [6] since they can affect the accuracy of the notch or damage the surface of the workpiece.

- Lay the workpiece on the base notching device, as shown.



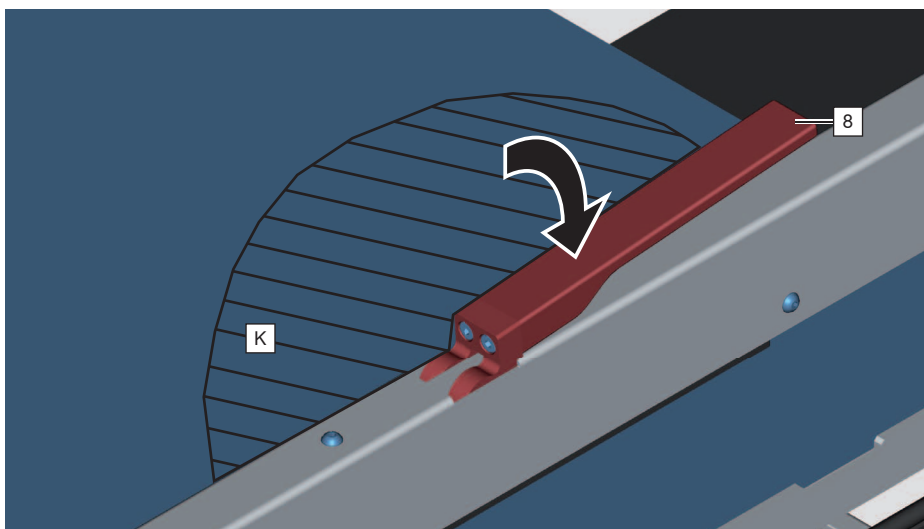
- Push the workpiece against the lateral stop, as shown.



i NOTE

- By working with a depth stop [7] you can increase the accuracy and quality of the notch.

- Push the workpiece against the depth stop [7], as shown.



⚠ CAUTION

- Keep your hands away from the clamp (K).

- Keep the workpiece pressed against the stops.
- Push down the clamping lever [8].
- Check again that the workpiece is lying flat against the stops.

Milling

**WARNING**

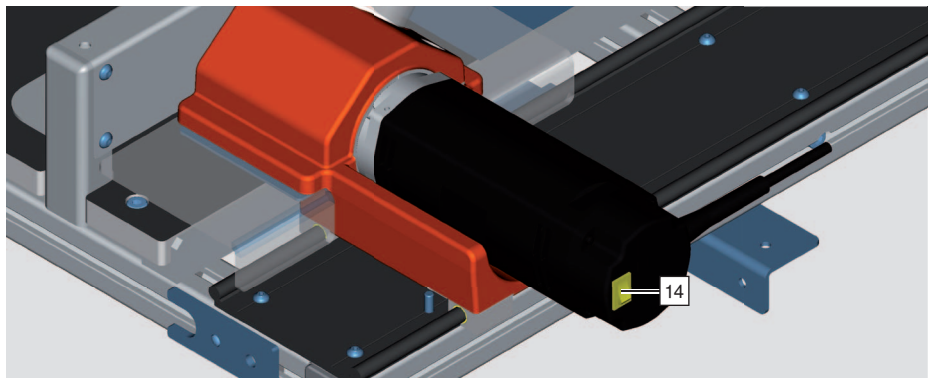
Cutting tools can cause serious injury.

- No more than one person may use the base notching device at a time.
- Nobody should be in the machine's danger zone [G].
- Wear eye protection.
- Wear ear protection.

- Switch on the extraction system.

**NOTE**

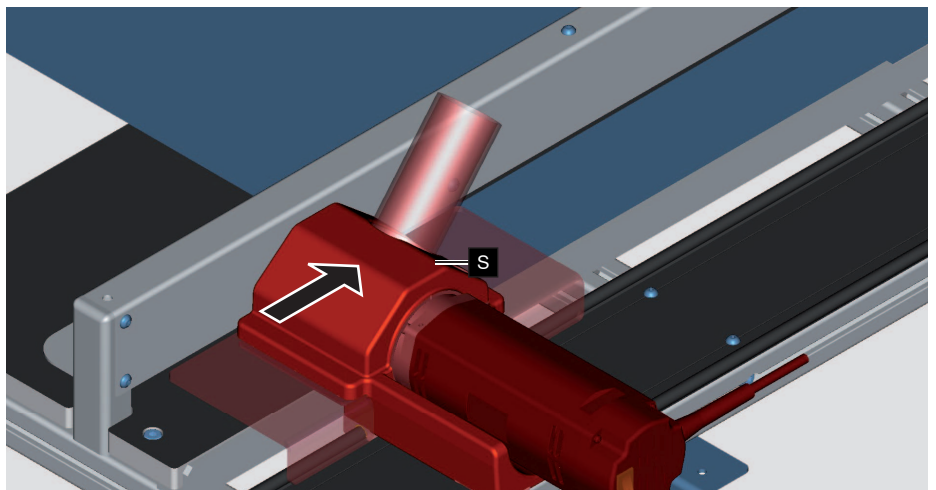
- The extraction system must always be switched on in order to remove wood chips and dust.



- Press the rocker switch [14]. Switch on the motor.

**NOTE**

- Always allow the motor to reach full speed.
- A cutter with sharp blades considerably relieves the load on the motor and therefore extends its service life.
- The feed rate affects the quality of the notch.



- Push the carriage [S] gently into the workpiece
- At the end of the workpiece, gently draw the carriage out from the material

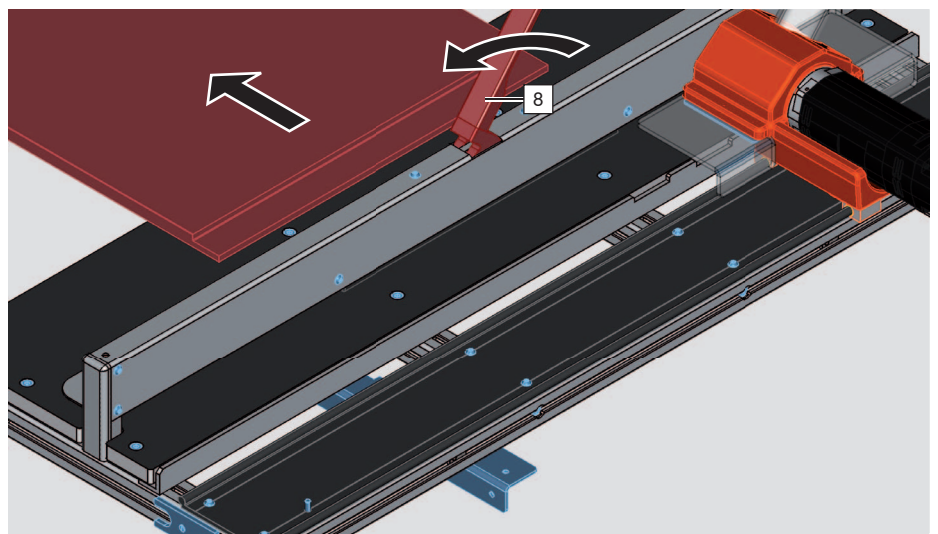
i NOTE

- Never turn off the motor during the milling process. That could damage the motor or the notch cutter [19].

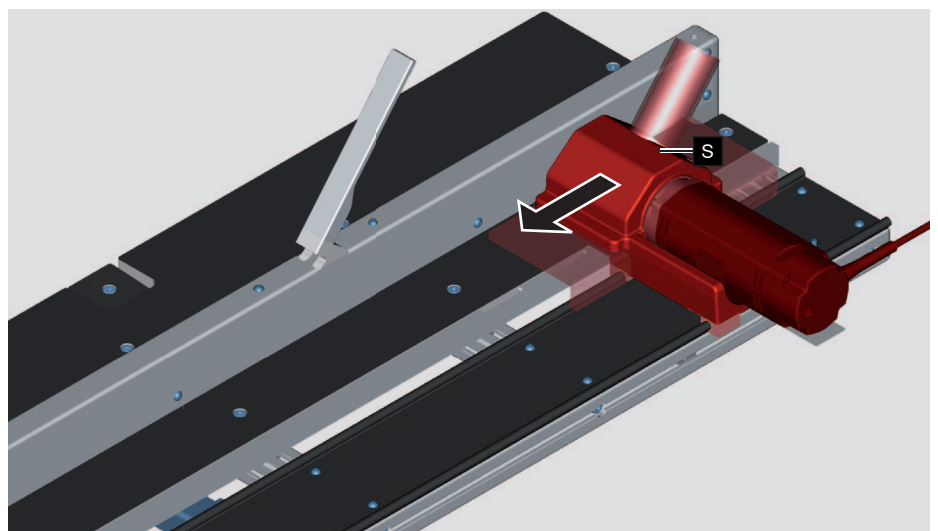
- Press the rocker switch [14]. Switch off the motor.

i NOTE

- After finishing the work, do not push the carriage back over the workpiece, no matter whether or not the motor is running.



- Loosen the clamping lever [8].
- Carefully remove the workpiece.



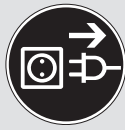
- Place the carriage [S] in the front position.
- Clean the work top [5]
- After completing all the work, pull out the mains plug.

Maintenance

Everyday cleaning



WARNING



Serious cuts.

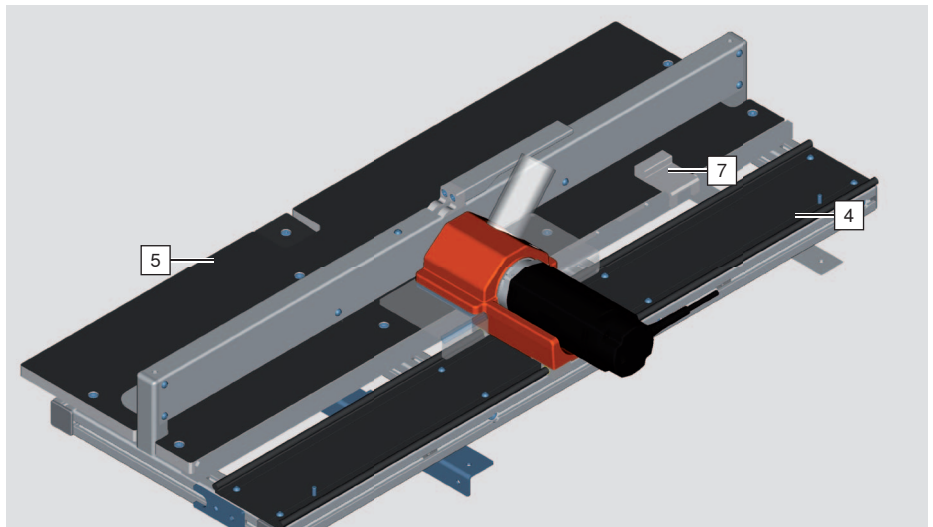
Failure to heed this warning may result in personal injury.

- The base notching device must be disconnected from the power supply before cleaning and maintenance.



CAUTION

- Wear eye protection during cleaning work.



NOTE

- 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.
- Never use compressed air near the motor.

Wood chips may infiltrate the motor through the ventilation slots and therefore impair the motor's cooling system and service life.

- Keep the motor ventilation slots free of dust and wood chips.
- Clean the depth stop [7] and lateral stop.
- Clean the runner [4] using a dry cloth.
- Clean the work top [5] using compressed air

Removing the motor

If the motor needs to be removed for maintenance, cleaning or replacement purposes, proceed as follows:



WARNING



Serious cuts.

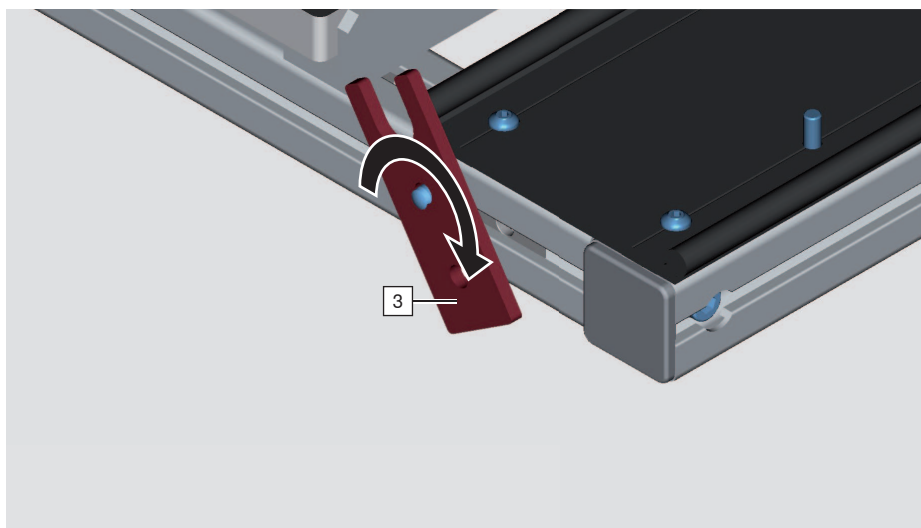
Failure to heed this warning may result in personal injury.

- The base notching device must be disconnected from the power supply before cleaning and maintenance.

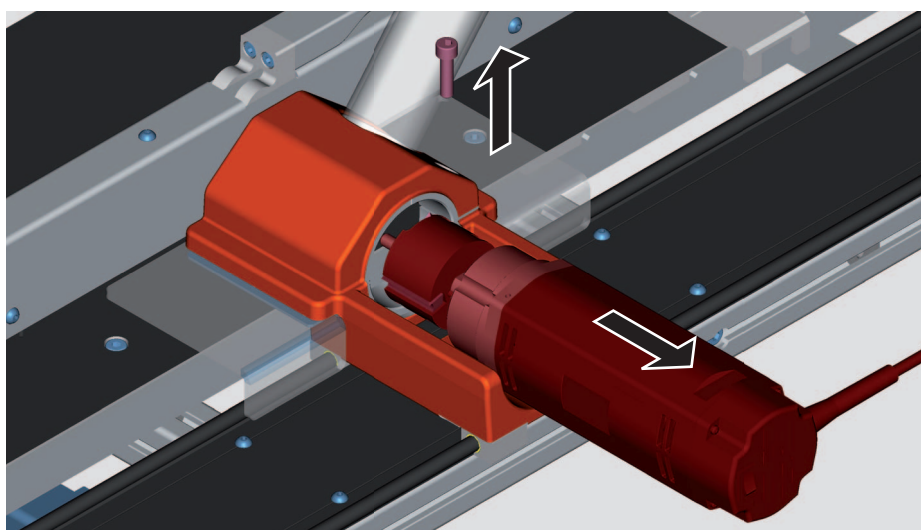


NOTE

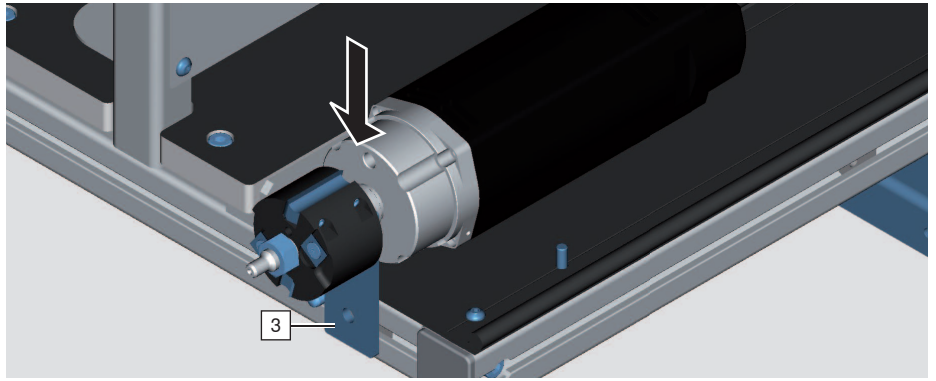
- Gloves must always be worn when cleaning the cutter.



- Swivel the shaft holder [3]

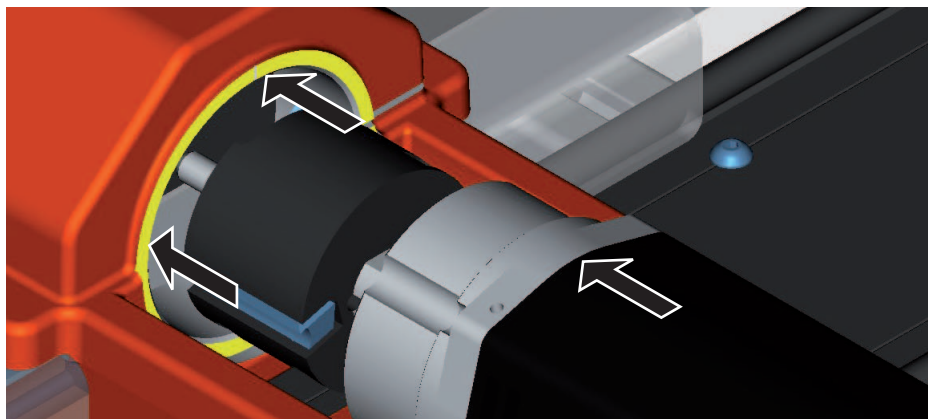


- Loosen the screw with a SW 6 Allen key.
- Pull out the motor.



- Secure the motor in the shaft holder [3].

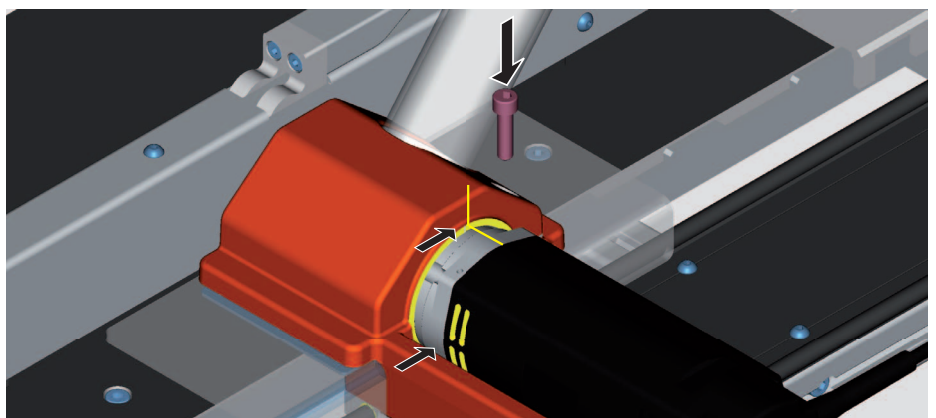
Install the motor



- All the fixing and clamping surfaces on the carriage and motor must be free of dust and wood chips.

i NOTE

- Cutters and cutting inserts may not touch the housing under any circumstances since they could damage the cutting inserts.
- Push the motor against the flange stop.



i NOTE

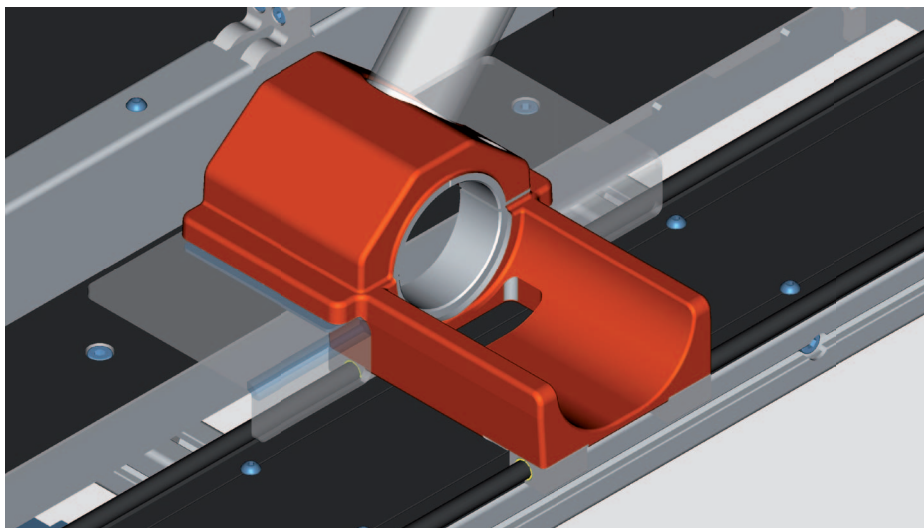
- Make sure that the motor is correctly positioned. The motor's ventilation slot must not be covered. Risk of overheating.

- Turn the motor to the correct position.
- Re-tighten the Allen screw.

Cleaning the housing

Proceed as follows if the carriage housing [S] is filled with wood chips or if the cutter is blocked:

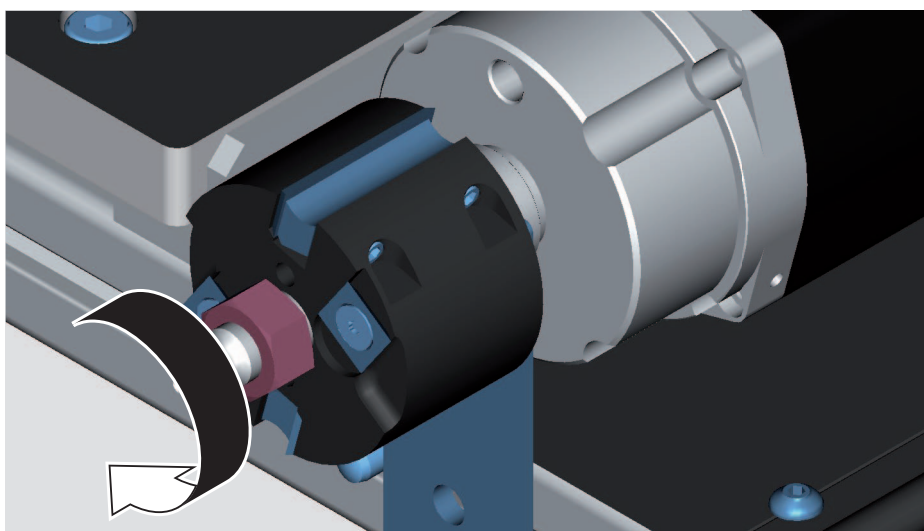
Removing and installing the motor



- Remove the wood chips from the housing.

Remove the cutter

Removing and installing the motor



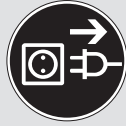
- Turn the nut clockwise using the IM spanner.

i NOTE

- The motor shaft is a left hand thread.

Change the cutting inserts

Removing and installing the motor

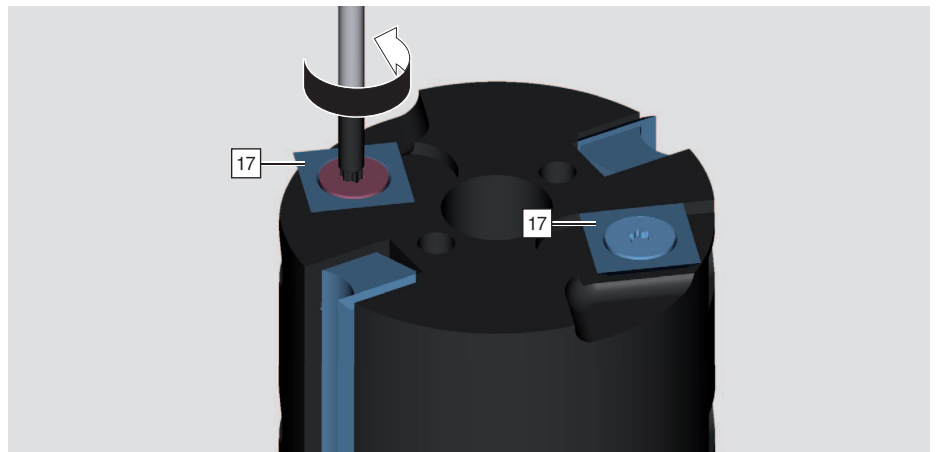
**WARNING****Serious cuts.****Failure to heed this warning may result in personal injury.**

- The base notching device must be disconnected from the power supply before cleaning and maintenance.
- Wear gloves.

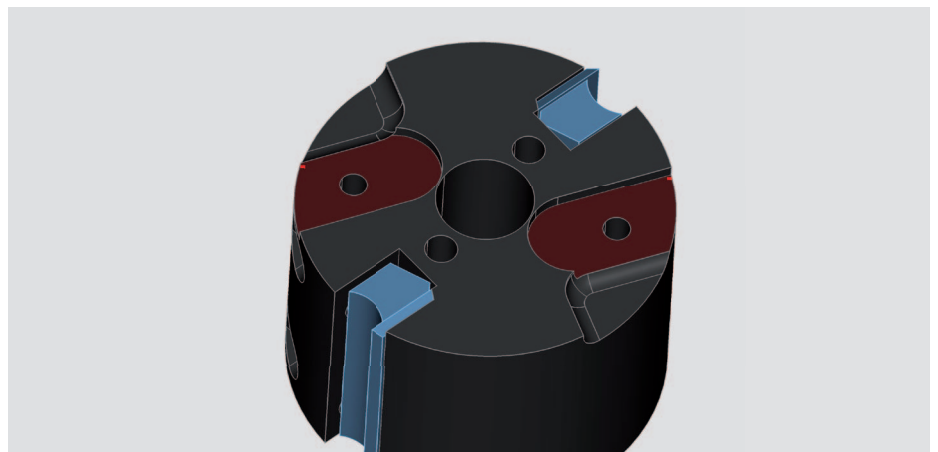
**NOTE**

- The blades should be changed in the following sequence:
Whenever the pre-cutters [17] are turned for the second time, the cutting inserts [18] should also be turned.
- Sharp blades significantly extend the service life.

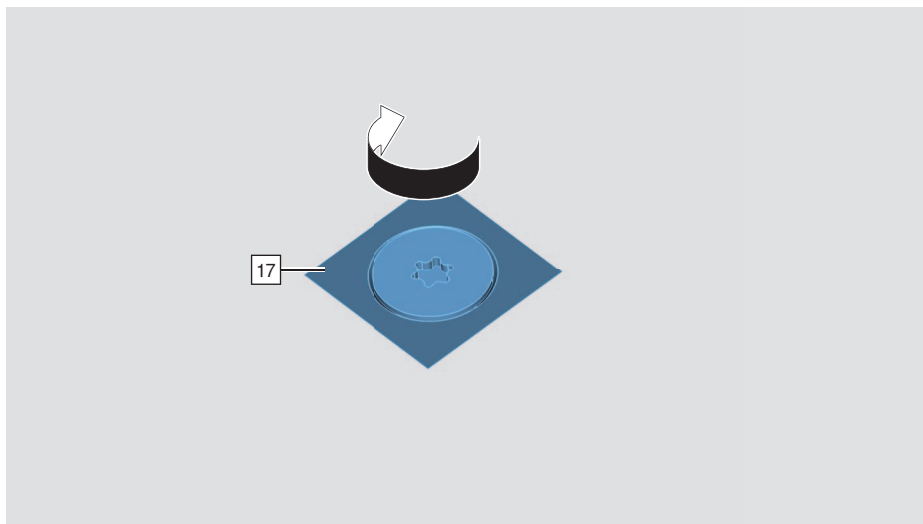
Changing the pre-cutter [17].



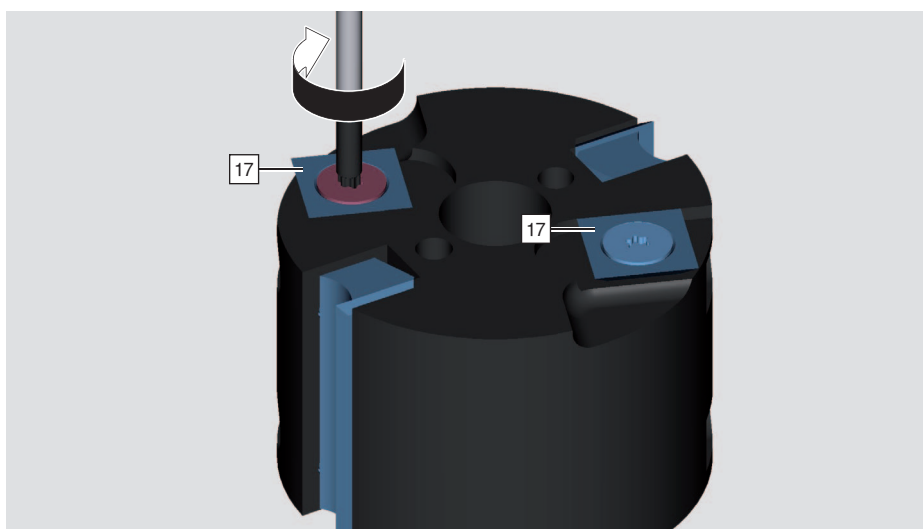
- Loosen the pre-cutter screw [17] by turning it anticlockwise.



- Clean the base of the pre-cutter [17] using a dry cloth.



- Clean the pre-cutter [17] using a dry cloth.
- Turn the pre-cutter [17] 90 degrees.

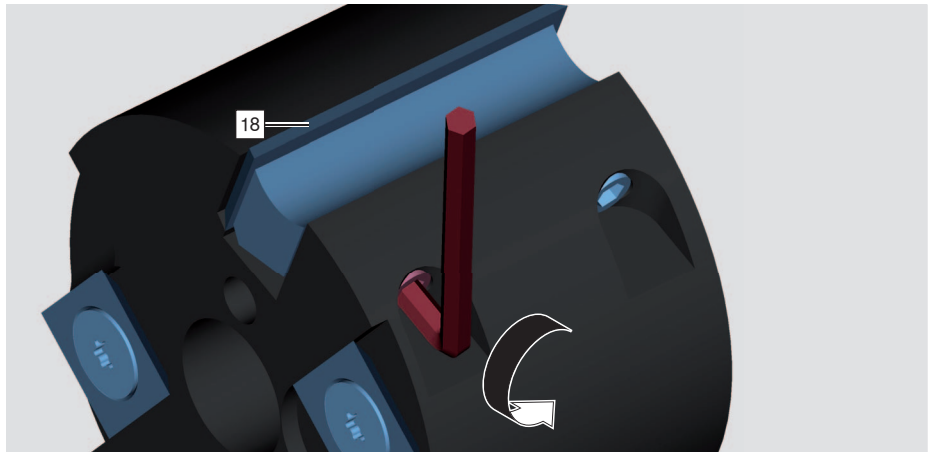


- Tighten the screw in the pre-cutter [17] by turning it clockwise.

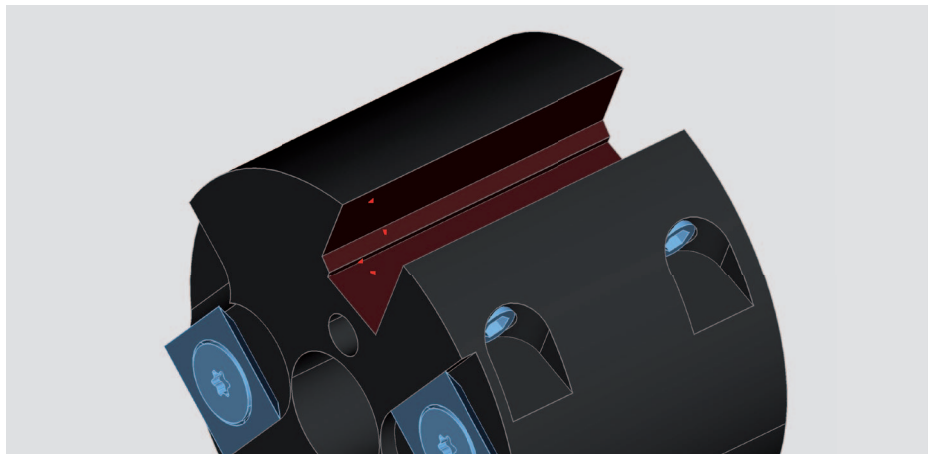
i NOTE

- Only the TORX® key provided may be used.

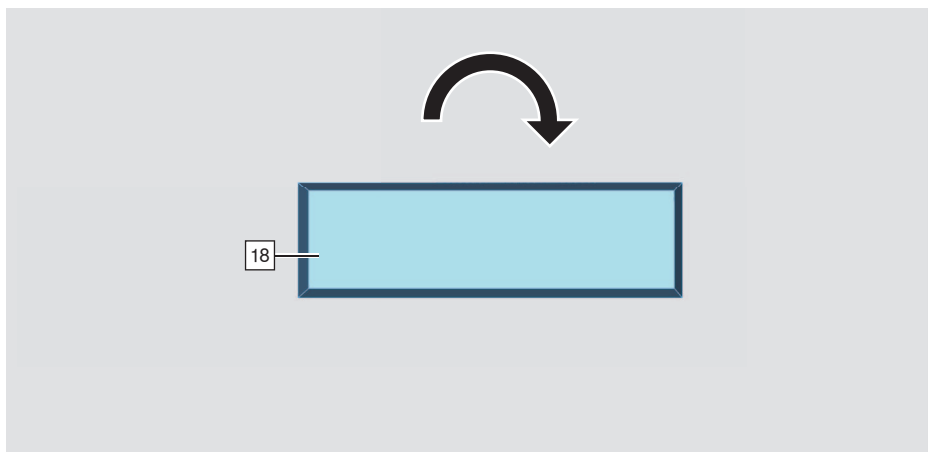
Changing the cutting insert [18].



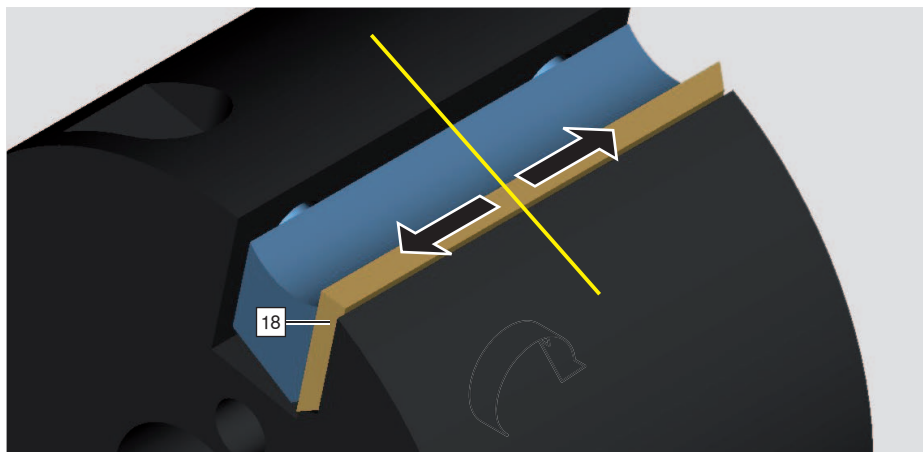
- Loosen the screw for the cutting insert [18] by turning it anticlockwise.



- Clean the base of the cutting inserts [18] using a dry cloth.



- Turn the insert cutter [18] 180 degrees.



- Place the cutting insert [18] in the middle.



- Tighten the screw for the cutting insert [18] by turning it clockwise.

i NOTE

- Only the TORX® key provided may be used

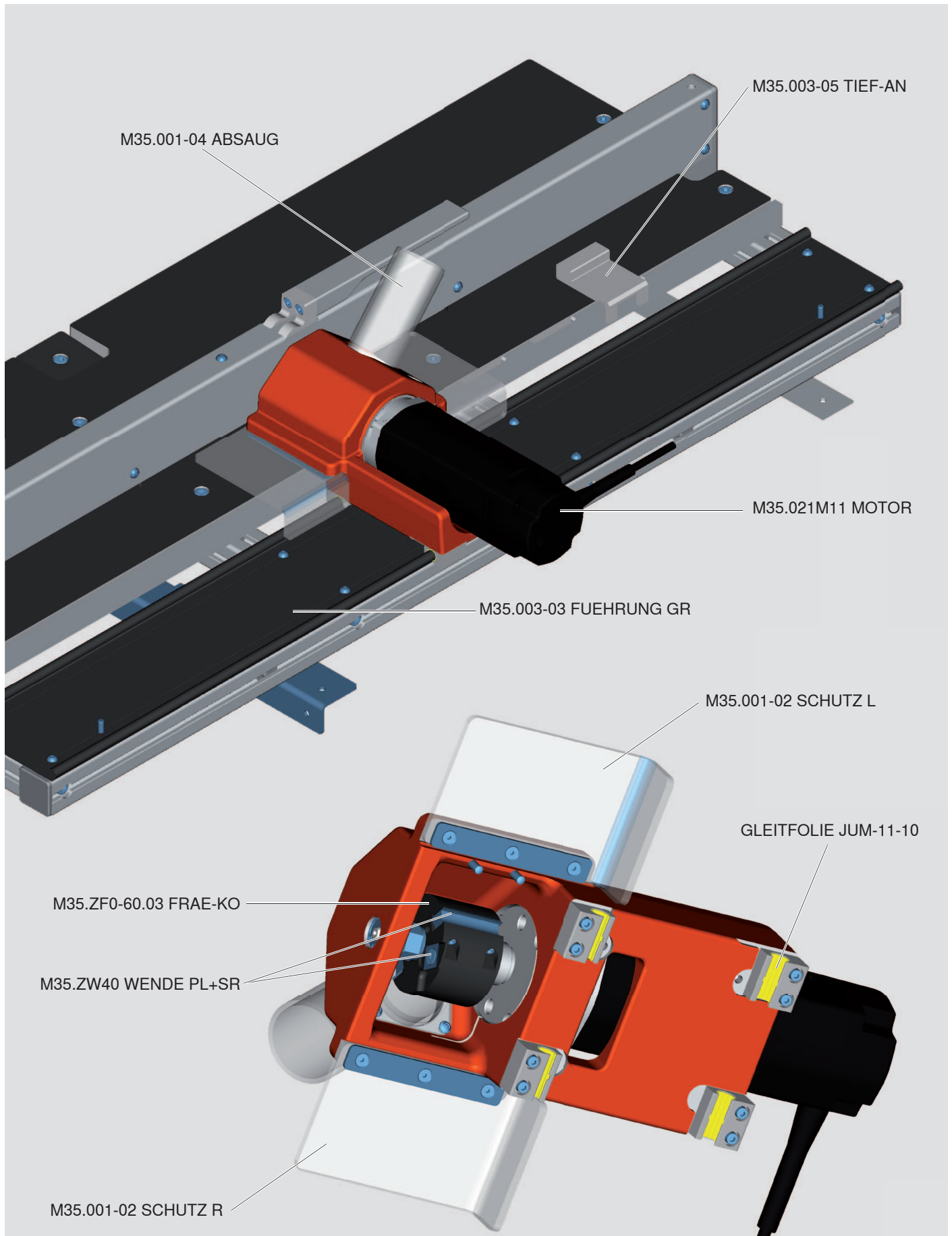
i NOTE

- In order to ensure equal wear on the pre-cutters and the cutting inserts, always change the complete set when replacing the pre-cutters [17] or insert cutters [18].

Troubleshooting

Fault	Possible cause	Remedy
Incorrect notch dimensions	Workpiece not clamped correctly	➤ see page 14
	Dirty stops	➤ see page 18
	Dirty work top	➤ see page 18
	Workpiece is not flat against the stop	➤ see page 13
	Cutter worn out	➤ see page 22
Tattered notch	Cutter worn out	➤ see page 22
	No rear stop	➤ see page 13
	Incorrect feed	➤ see page 16
Strong vibrations on base notching device	Base notching device not clamped	➤ see page 12
	Workpiece not clamped	➤ see page 14
Strong vibrations on the motor	Incorrect material	➤ see page 3
	Cutter not screwed tightly	➤ see page 21
	Motor in the carriage not correctly clamped	➤ see page 20
	Cutting inserts not screwed tightly	➤ see page 22
	Not all the cutting inserts have been installed	➤ see page 22
	Damaged cutting inserts	➤ see page 22
Motor overheated	Reduce feed	➤ see page 16
	Cutter worn out	➤ see page 22
	Motor ventilation slots are blocked	➤ see page 18

Spare parts



Scope of delivery

Base notching device	M35.7200
Cutter	M35.ZF0-60.03 FRAE-KO
Hopper	M51N0603 TRI+ZUT
Open-ended wrench 19	
hex-wrench 6	

EC Declaration of Conformity

We, Julius Blum GmbH, Industriestrasse 1, A-6973 Höchst, Austria take full responsibility in declaring that product M35.7200, to which this declaration refers, complies with the following EU directives:

EC Machine Directive	2006/42/EC
EC EMC Directive	2004/108/EG
EC RoHS Directive	2011/65/EG

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



Höchst, 24/09/2013
Dipl. Ing. Herbert Blum,
Managing Director
www.blum.com

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

Technical data

Should only be used in dry, enclosed rooms.


Dimensions/Weight:

Height: _____ 264 mm
Width: _____ 584 mm
Depth: _____ 1108 mm
Weight: _____ 22 kg

Sound:

Emission – Sound pressure level (LAeq): _____ 92 dB(A)

Serial tag

	
Ser.No.: MA 00001	2013
22 kg / 48,5 lbs	CE
Boden-Falzgerät	
Ref.No.: M35.7200	
Julius Blum GmbH - A - 6973 Industriestrasse 1	

Device type: Base notching device

Notes

Notes

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