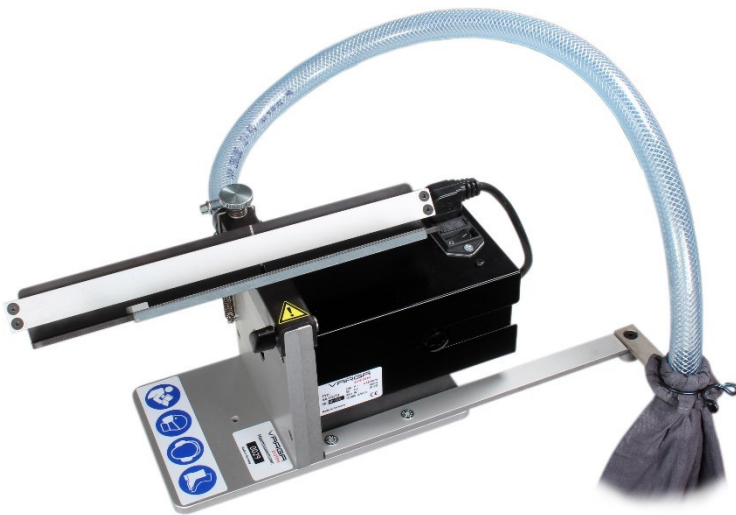


## Original Operating Instructions VARGA Edge Milling Machine

Model VA 2



|                 |            |
|-----------------|------------|
| Current version | 2.0        |
| Date            | 16.07.2025 |
| Scope           | 53 pages   |



**IMPORTANT:**

READ CAREFULLY BEFORE USE

KEEP FOR FUTURE REFERENCE

**Manufacturer**

VARGA SYSTEM GmbH

Hainkämpe 5

28832 Achim

Germany

[www.varga-system.com](http://www.varga-system.com)

**VARGA**  
SYSTEM

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# 1 Introduction

## 1.1 Identification

|                     |                            |
|---------------------|----------------------------|
| Machine name        | VARGA Edge Milling Machine |
| Machine type        | Edge Milling Machine       |
| Model               | VA 2                       |
| Year of manufacture | 2025                       |

## 1.2 Manufacturer

|                     |                       |
|---------------------|-----------------------|
| Manufacturer's name | VARGA SYSTEM GmbH     |
| Street              | Hainkämpe 5           |
| ZIP code, city      | 28832 Achim           |
| Country             | Germany               |
| Telephone           | +49 4232 945870       |
| Email               | info@varga-system.com |
| Web                 | www.varga-system.com  |

## 1.3 Information about the operating instructions

|                 |            |
|-----------------|------------|
| Current version | 2.0        |
| Date            | 16.07.2025 |

## 1.4 Change history

| Date       | Version | Sections affected | Reason for change                     |
|------------|---------|-------------------|---------------------------------------|
| 08.05.2025 | 1.0     | All               | Final version of the document created |
| 16.07.2025 | 2.0     | All               | General adjustments                   |

## 1.5 EC Declaration of Conformity

### EC-Declaration of Conformity

**according to the EC Machinery Directive 2006/42 / EC, Annex II 1.A**

**The manufacturer**

Varga System GmbH  
Hainkämpe 5  
28832 Achim

**declares that the following machine , in the version placed on the market by the manufacturer, complies with all relevant provisions of Directive 2006/42/EC "Machinery Directive" - including the amendments valid at the time of this declaration.**

|              |                                 |                              |      |
|--------------|---------------------------------|------------------------------|------|
| <b>Name:</b> | VARGA Edge Milling Machine VA 2 | <b>Year of construction:</b> | 2025 |
|--------------|---------------------------------|------------------------------|------|

**Functional description:**

The milling blade is stationary and rotates at a fixed speed. The workpiece is manually guided over the milling blade at a guide angle at right angles to the direction of rotation in both directions with the aid of a slide. The chamfering depth is adjustable.

**The machinery also fulfills the relevant provisions of the following other directives - including those modifications applicable at the time of this declaration:**

| Reference  | Name                                                                                                                                                                                            |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 2014/30/EU | Directive 2014/30/EU of the European Parliament and of the Council of 26 February 2014 on the harmonisation of the laws of the Member States relating to electromagnetic compatibility (recast) |

**The following harmonised standards according to article 7 (2) of the machinery directive 2006/42/EC were applied:**

| Reference                | Name                                                                                                                                                                                               |
|--------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| EN 60204-1:2018          | Safety of machinery - Electrical equipment of machines - Part 1: General requirements                                                                                                              |
| EN 62841-1:2015/A11:2022 | Electric motor-operated hand-held tools, transportable tools and lawn and garden machinery - Safety - Part 1: General requirements (IEC 62841-1:2014, modified)                                    |
| EN 62841-2-5:2014        | Electric motor-operated hand-held tools, transportable tools and lawn and garden machinery - Safety - Part 2-5: Particular requirements for hand-held circular saws (IEC 62841-2-5:2014, modified) |
| EN ISO 12100:2010        | Safety of machinery - General principles for design - Risk assessment and risk reduction (ISO 12100:2010)                                                                                          |

**The following standards harmonised under other directives, other technical standards or parts of them, and other specifications were applied:**

| Reference                 | Name                                                                                                              |
|---------------------------|-------------------------------------------------------------------------------------------------------------------|
| EN 61000-6-2:2005         | Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments          |
| EN 61000-6-4:2007/A1:2011 | Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments |

|                   |                         |
|-------------------|-------------------------|
| Achim, 07.05.2025 | <i>A Röhrbein</i>       |
| Location, Date    | Signatory               |
|                   | Alexander Röhrbein, CEO |

Figure 1 EC Declaration of Conformity

## 1.6 CE mark



The CE mark shown here is affixed to the machine.

The mark indicates that the product complies with all EC directives applicable to the machine at the time it was placed on the market.

## 1.7 Type plate

### 1.7.1 Variant 230 V~ mains voltage

|                        |                                                          |
|------------------------|----------------------------------------------------------|
| <b>VARGA</b><br>SYSTEM | Edge Milling Machine<br>Kantenfräsapparat<br>Biseauteuse |
| Model: VA 2            | 230 V~ 50 Hz                                             |
| Serial No.: A2-001     | 350 W                                                    |
| Year: 2025             | 15000 min <sup>-1</sup>                                  |
| Blade: ø 120 mm        | IP 20                                                    |
| <b>CE</b>              | Varga System GmbH<br>Hainkämpe 5<br>28832 Achim, Germany |
| Made in Germany        |                                                          |

Figure 2 Machine type plate 230 V~ mains voltage



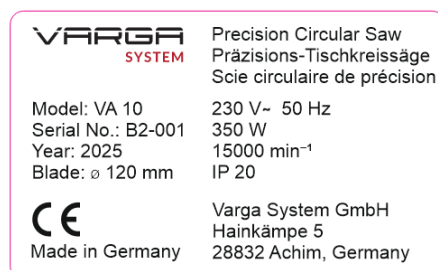


*Figure 3 Motor unit plate 230 V~ mains voltage*

The type plate shown above is attached to the machine.

It includes identification details, which can be found in Sections 1.1 and 1.2 of these instructions.

### 1.7.2 Variant 100-120 V~ mains voltage



*Figure 4 Machine type plate 100-120 V~ mains voltage*



*Figure 5 Motor unit plate 100-120 V~ mains voltage*

The type plate shown above is attached to the machine.

It includes identification details, which can be found in Sections 1.1 and 1.2 of these instructions.

## 2 About these operating instructions

### 2.1 Target groups

These operating instructions are intended for the following target groups:

- Operating personnel
- Maintenance personnel
- Specialist personnel

Where certain target groups are excluded, the target group permitted to carry out the activities described is specified at the start of the section.

#### 2.1.1 Operating personnel

The operating personnel:

- are authorized by the plant operator to operate the machine;
- are physically and mentally capable of operating the machine without creating additional dangers;
- can speak and write the local language to a level that allows the instructions and user interface to be understood;
- are aware of the risks of working with the machine based on the instruction received and experience with the machine.

#### 2.1.2 Maintenance personnel

The maintenance personnel:

- are qualified by training and experience to carry out work on the machine;
- have basic experience of the system (e.g. electrical control system) on which the work is to be carried out;
- have advanced experience of the system on which the work is to be carried out;
- also have the same qualifications as the operating personnel.

#### 2.1.3 Specialist personnel

The specialist personnel:

- are qualified by training and experience to carry out work on the machine;
- have basic experience of the system (e.g. electrical control system) on which the work is to be carried out;
- have advanced experience of the system on which the work is to be carried out;
- have additional qualifications and experience relating to the relevant life phases of the machine.

### 2.2 Presentation of information

Safety instructions are presented in the instructions by a pictogram and a keyword.

The content of the information is structured as follows:

**Type/source of danger!**

Possible consequences!

➤ Measures for prevention

 **DANGER!**

“DANGER” is used when death or serious damage to health **will** occur if the warning is not observed.

 **WARNING!**

“WARNING” is used when death or serious damage to health **may** occur if the warning is not observed.

 **CAUTION!**

“CAUTION” is used when moderate or slight damage to health may occur if the warning is not observed.

**ATTENTION**

“ATTENTION” is used when damage to the machine or surroundings may occur if the warning is not observed.

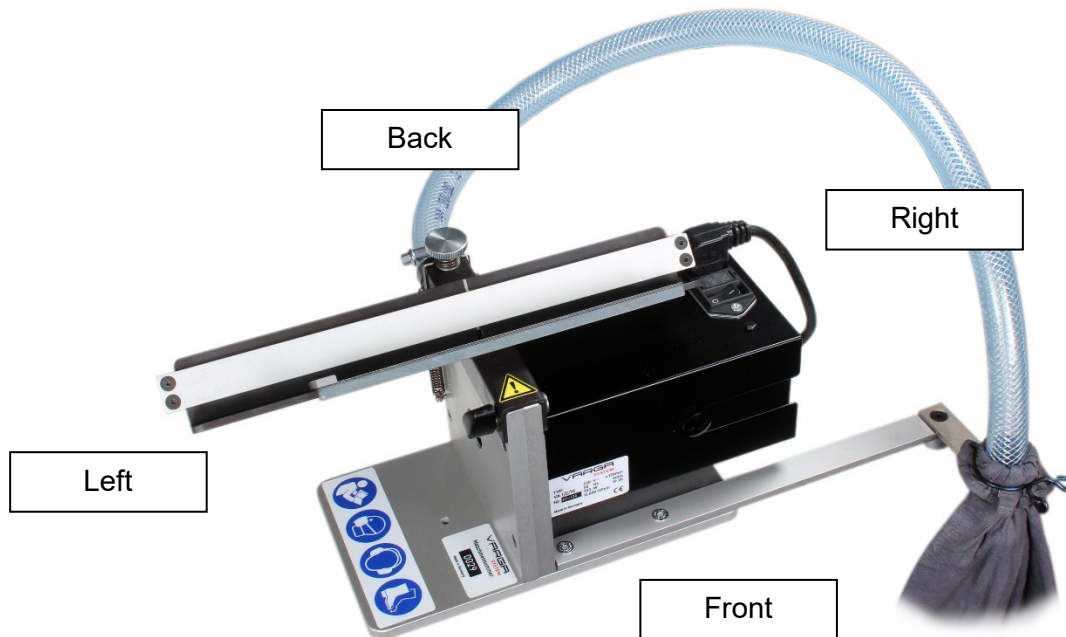
**NOTE**

Helpful application tips and information for using the machine.



Cross-reference to a specific document.

## 2.3 Display of positions and directions



*Figure 6 Positions and directions*

The positions and directions are based on the perspective of the operating personnel and their view of the machine from the main operating station.

## 2.4 Presentation of lists

Lists are presented with bullet points. Example:

- Point 1
- Point 2

## **2.5 Presentation of actions required**

### **2.5.1 Actions with a sequence to be followed**

Actions to be carried out in a defined sequence are numbered and displayed in a list. The system reaction of the machine to the respective action is shown in italics and has a check mark before it. Example:

#### **Action required**

1. Activity, e.g. press the "Horn on" button.

☒ *Reaction 1, e.g. "The signal tone sounds".*

2. Activity, e.g. press the "Horn off" button.

☒ *Reaction 1, e.g. "The signal tone stops".*

### **2.5.2 Actions without a sequence to be followed**

Actions to be carried out without a fixed sequence are shown with an arrow. The system reaction of the machine to the respective action is shown in italics and has a check mark before it. Example:

#### **Action required**

➤ Activity, e.g. press the "Horn off" button.

☒ *Reaction 1, e.g. "The signal tone stops".*

## 3 Safety

### 3.1 General safety instructions

- Damage due to incorrect handling of the machine. The machine is manufactured according to the current state of the art and in compliance with the relevant legal regulations. Nevertheless, dangers to persons and/or the environment may occur. Deploy trained personnel only.
- Failure to observe these operating instructions can have serious consequences for persons or the environment. Always observe the operating instructions.
- Improper use of the machine may result in serious personal injury and damage to the machine. Only use the machine as intended.

### 3.2 General safety instructions for power tools

#### 3.2.1 Safety in the workplace

- The workplace must be kept clean and well lit. Untidy or unlit work areas can cause accidents.
- Working in potentially explosive atmospheres in which flammable liquids, gases, or dust are present is prohibited. Power tools generate sparks that can ignite the dust or vapors.
- Keep children and other persons away when using the power tool. Other people can cause distractions, which can result in loss of control of the power tool.

#### 3.2.2 Electrical safety

- The plug of the power tool must match the socket. The plug must not be modified in any way. Do not use adapter plugs with earthed power tools. Unmodified plugs and matching sockets reduce the risk of electric shock.
- Avoid contact with earthed surfaces such as pipes, heaters, stoves, and refrigerators. There is an increased risk of electric shock when the human body is earthed.
- Keep power tools away from rain and moisture. Ingress of water into a power tool increases the risk of electric shock.
- Do not use the power cable to carry the machine. Do not hang the machine by the power cable or pull the plug out of the socket by the power cable. Lay the power cable away from heat, oil, sharp edges, and moving parts. Damaged or entangled connecting cables increase the risk of electric shock.
- If operating the power tool in a damp environment is unavoidable, use a residual current circuit breaker. The use of a residual current circuit breaker reduces the risk of electric shock.

#### 3.2.3 Safety of personnel

- Work attentively and with care. Do not use the machine if you are tired or under the influence of alcohol, drugs, or medication. Carelessness when using power tools can result in serious injuries.

- Wear prescribed personal protective equipment. Wearing personal protective equipment such as dust masks, goggles, non-slip safety shoes, safety helmet or hearing protection, depending on the type and use of the power tool, reduces the risk of injury.
- Avoid unintentional start-up and ensure that the power tool is switched off before connecting it to the power supply, transporting, or moving it. Switching on the power tool inadvertently when moving it can result in serious accidents.
- Remove tools and other objects from the work area before switching on the power tool. A tool or wrench that is in a rotating part of the power tool can cause injury.
- Avoid abnormal postures and always adopt a safe ergonomic stance so that balance can be maintained at all times. This makes it easier to control the power tool in unexpected situations.
- Do not wear loose clothing, have long hair down, or wear jewelry while operating the power tool. Loose clothing, jewelry, and long hair can be caught by moving parts and cause serious accidents.
- Do not use the machine without chip removal. Dust can cause damage to health. Observe the safety rules for power tools even after repeated use. Careless actions can lead to serious injuries within fractions of a second. Tools that are suitable for use reduce the risk of accidents.

### **3.2.4 Use and handling of the power tool**

- Do not overload the power tool. Observe the intended use.
- Do not use the machine with a defective toggle switch. A power tool that cannot be switched on or off is dangerous and must be repaired.
- Disconnect the plug from the socket before adjusting appliance settings, replacing cutter blades, or carrying out repairs on the electrical device. This precautionary measure prevents the power tool from starting unintentionally.
- Keep power tools out of the reach of children when not in use. Power tools must not be used by persons who are not familiar with them or who have not read the operating instructions. The use of power tools by inexperienced persons carries the risk of serious accidents.
- Check power tools regularly for damage and ensure that all moving parts can be moved freely. Have damaged parts repaired before using power tools. Many accidents are caused by poorly maintained power tools.
- Keep cutting tools sharp and clean. Carefully maintained cutting tools with sharp cutting edges are less likely to jam and are easier to guide.
- Use power tools in accordance with these instructions. The working conditions and the work to be carried out must be taken into account. The use of power tools for applications other than those for which they are intended can lead to dangerous situations.

### **3.2.5 Service**

Have power tools repaired by qualified specialists and with original spare parts only. This ensures that the safety of the power tool is maintained.

### 3.3 Intended use

The Edge Milling Machine is used for chamfering flat workpieces with straight edges made of the following materials:

With carbide cutter blade:

- Formica
- Resopal
- Engraving plastics
- Astralon
- Perspex
- PVC
- Aluminum
- Brass
- Wood
- Hard fabric panels

The machine is intended exclusively for industrial use.

The exact limits of the machine can be found in the technical data in Section 4 of these instructions.

Electrical systems and equipment may only be installed, modified, and maintained by a qualified electrician or under the direction and supervision of a qualified electrician in accordance with electrotechnical regulations.

### 3.4 Reasonably foreseeable misuse

Any applications that do not comply with the intended use are prohibited.

Machining of:

- ferrous metals – especially stainless steel;
- workpieces with irregular thickness;
- workpieces that do not meet the permissible dimensions;
- materials that are not suitable for the cutter blade;
- magnetic materials is prohibited.

Working on workpieces with your hands crossed is prohibited.

Processing of workpieces containing nails or other foreign objects is prohibited.

Operation without protective devices or protective devices that are not in perfect condition or have been modified or rendered ineffective without the manufacturer's approval is prohibited.

Operation is prohibited in the event of damage.

Functional and structural modifications are prohibited.

Changing the performance data of individual components or the machine is prohibited.

Operation is prohibited in the case of changes to or deviations from the specified connected loads.



### 3.5 Residual risks

#### **Danger due to electrical voltage**

Working with live components may result in direct contact with them. This will cause serious injury or death.



- Work on electrical equipment may only be carried out by qualified electricians of the manufacturer or specially authorized and trained electricians.
- Carry out work in compliance with the safety regulations.

#### **Improper cleaning, maintenance, or repair**

Improper cleaning, maintenance, or repair may result in serious injury or death.



- Before cleaning, maintenance, and repair work, ensure that the machine is switched off and disconnected from the power supply. The mains plug must be positioned in such a way that it cannot be accidentally reconnected by other persons.
- Deploy trained personnel only.
- Follow the operating instructions.

#### **Danger due to improper handling of the machine**

The machine presents various dangers such as the risk of crushing, cutting, and hearing damage.



- The machine may only be operated by trained and qualified personnel.
- Before handling the machine, read the operating instructions and always follow them.

**Injuries due to sharp cutter blade**

Contact with the sharp-edged cutter blade may occur during maintenance or cleaning work. This can lead to cuts or puncture wounds to fingers and hands.



- Switch off the machine and disconnect it from the power supply before carrying out maintenance or cleaning work.
- Wear cut-resistant protective gloves.
- Handle the cutter blade with care and caution.
- Work with care.

### **3.6 Obligations of plant operators**

Plant operators are obliged to comply with national and, where applicable, regional occupational health and safety regulations.

Plant operators are obliged in advance to

- arrange for persons working with the machine to read these instructions;
- inform them about the contents of these instructions;
- instruct them in basic occupational health and safety and accident prevention regulations;
- provide personal protective equipment for safe use of the machine.

### **3.7 Obligations of personnel**

All persons working with the machine are obliged to

- read and ensure that they have understood these instructions before using the machine for the first time;
- avoid any working methods that compromise machine safety;
- report any defects in the machine immediately and have them professionally repaired;
- operate the machine only with protective devices in place;
- prevent and report obviously incorrect actions by third parties.

### **3.8 Qualification of personnel**

The personnel deployed must have the appropriate qualifications, training, and professional experience to carry out the intended work. Experience is largely defined by the individual's ability to prevent personal injury and damage to machines.

Different qualifications are required for different activities that have to be carried out with or on the machine, in accordance with the following matrix:

| Activity \ Qualification  | Operating personnel | Maintenance personnel | Specialist personnel |
|---------------------------|---------------------|-----------------------|----------------------|
| Transport                 | ✗                   | ✓                     | ✗                    |
| Assembly and installation | ✗                   | ✓                     | ✗                    |
| Normal operation          | ✓                   | ✓                     | ✗                    |
| Maintenance               | ✗                   | ✓                     | ✗                    |
| Shutdown                  | ✗                   | ✓                     | ✗                    |
| Disposal                  | ✗                   | ✗                     | ✓                    |

### 3.9 Personal protective equipment

The following personal protective equipment must be available:



Wear eye protection.



Wear hearing protection.



Wear a dust mask.



Wear cut-resistant gloves.



Wear foot protection.

### 3.10 Safety markings on the machine

There are safety markings on the machine that indicate residual risks that cannot be avoided by design.



**Meaning:** Indicates that hearing protection must be worn.

**Position:** Base



**Meaning:** Indicates that a dust mask must be worn.

**Position:** Base



**Meaning:** Indicates that the instructions must be read.

**Position:** Base



**Meaning:** Indicates that foot protection must be worn.

**Position:** On the outside of the machine packaging



**Meaning:** Indicates that the mains plug must be disconnected.

**Position:** On the cable below the plug



**Meaning:** Warning of a danger point.

**Position:** Base



**Meaning:** Warning of electrical voltage.

**Position:** On the housing of the motor

## 4 Technical data

### 4.1.1 VARGA VA 2 (Variant 230 V~ mains voltage)

|                                                   |                                                                                                         |
|---------------------------------------------------|---------------------------------------------------------------------------------------------------------|
| Machine<br>(length x width x height)              | 393 x 150 x 174 mm                                                                                      |
| Dead weight                                       | 5.6 kg net<br>6.6 kg gross                                                                              |
| Carbide cutter blade                              | Diameter 120 mm, 1.8 mm, 24 teeth                                                                       |
| Machinable materials                              | Formica, Resopal, Gravoply, Astralon, Perspex,<br>PVC, aluminum, brass, wood, and hard fabric<br>panels |
| Packaging dimensions<br>(length x width x height) | 360 x 255 x 215 cm                                                                                      |
| Max. workpiece thickness                          | 6 mm                                                                                                    |
| Max. chamfer depth                                | 4.5 mm                                                                                                  |
| Angle bracket length                              | 280 mm                                                                                                  |
| Motor power                                       | 350 W                                                                                                   |
| Speed                                             | 15,000 rpm                                                                                              |
| Protection class                                  | IP 20                                                                                                   |
| Supply voltage                                    | 230 V~<br>50 Hz                                                                                         |
| Fuse                                              | 5 x 20 mm<br>T 3.15 A<br>250 V                                                                          |

#### NOTE

The voltage rating of 250 V indicated on the fuse represents the maximum operating voltage at which the fuse can safely and reliably interrupt the circuit in compliance with applicable standards. It is therefore fully suitable for use at lower voltages, such as 120 V~.

#### 4.1.2 VARGA VA 2 (Variant 100-120 V~ mains voltage)

|                                                   |                                                                                                         |
|---------------------------------------------------|---------------------------------------------------------------------------------------------------------|
| Machine<br>(length x width x height)              | 393 x 150 x 174 mm                                                                                      |
| Dead weight                                       | 5.6 kg net<br>6.6 kg gross                                                                              |
| Carbide cutter blade                              | Diameter 120 mm, 1.8 mm, 24 teeth                                                                       |
| Machinable materials                              | Formica, Resopal, Gravoply, Astralon, Perspex,<br>PVC, aluminum, brass, wood, and hard fabric<br>panels |
| Packaging dimensions<br>(length x width x height) | 360 x 255 x 215 cm                                                                                      |
| Max. workpiece thickness                          | 6 mm                                                                                                    |
| Max. chamfer depth                                | 4.5 mm                                                                                                  |
| Angle bracket length                              | 280 mm                                                                                                  |
| Motor power                                       | 350 W                                                                                                   |
| Speed                                             | 15000 rpm                                                                                               |
| Protection class                                  | IP 20                                                                                                   |
| Supply voltage                                    | 100-112 V~<br>50/60 Hz                                                                                  |
| Fuse                                              | 5 x 20 mm<br>T 4 A<br>250 V                                                                             |

#### NOTE

The voltage rating of 250 V indicated on the fuse represents the maximum operating voltage at which the fuse can safely and reliably interrupt the circuit in compliance with applicable standards. It is therefore fully suitable for use at lower voltages, such as 120 V~.

## 4.2 Ambient conditions

### 4.2.1 Installation requirements

The VA 2 Edge Milling Machine should be set up at working height. A workbench or sturdy table, for example, is suitable for this purpose.

The surface/setup area must

- be able to bear the weight of the Edge Milling Machine;
- be stable and sturdy;
- have a horizontal flat surface;
- have a non-slip surface;
- have an ergonomic working height.

#### 4.2.2 Operating conditions

| Area            | Indoors                                                                                                           |
|-----------------|-------------------------------------------------------------------------------------------------------------------|
| Air temperature | +5°C to +40°C<br><i>(short-term +70°C for a maximum of 24 hours)</i>                                              |
| Humidity        | max. 50% at +40°C<br><i>(higher relative humidities are permissible at lower temperatures (e.g. 90% at 20°C))</i> |

#### 4.2.3 Storage conditions

| Area            | Indoors                                                                                                           |
|-----------------|-------------------------------------------------------------------------------------------------------------------|
| Air temperature | -24°C to +55°C<br><i>(short-term +70°C for a maximum of 24 hours)</i>                                             |
| Humidity        | max. 50% at +40°C<br><i>(higher relative humidities are permissible at lower temperatures (e.g. 90% at 20°C))</i> |

#### 4.2.4 Time limits

The service life depends on use and the maintenance intervals observed by specialist personnel. Preventive maintenance has a particular impact on service life; this includes timely replacement of wear parts. Elements of functional safety chains, regardless of the standard(s) applied, must be replaced in good time before the calculated or specified service life is reached, in accordance with their switching frequency or operating time.

#### 4.2.5 Spatial limits

The machine must be set up in such a way that there is sufficient space between the machine and other features (walls, other machine, etc.) to allow handling of larger workpieces and/or completion of maintenance and repair work.

#### 4.2.6 Airborne noise emission

|                              |          |
|------------------------------|----------|
| A-weighted sound power level | 96 dB(A) |
|------------------------------|----------|

The actual noise exposure from the machine depends on the ambient conditions. Further noise measurements must therefore be carried out at the machine's installation site.



## 5 Structure and function

### 5.1 Machine description

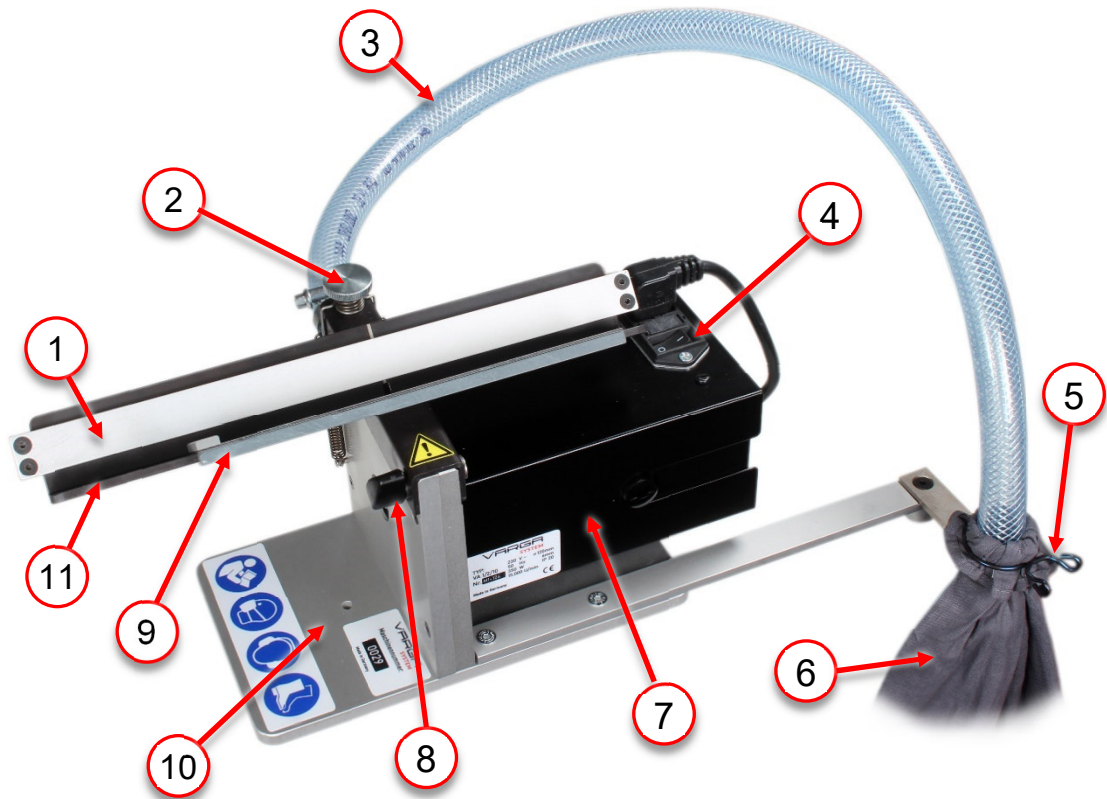


Figure 7 VA 2 Edge Milling Machine

| Item | Designation                            |
|------|----------------------------------------|
| 1    | Hold-down device                       |
| 2    | Height adjustment screw                |
| 3    | Chip hose                              |
| 4    | Toggle switch                          |
| 5    | Spring holder for chip bag             |
| 6    | Chip bag                               |
| 7    | Motor housing with integrated motor    |
| 8    | Locking screw                          |
| 9    | Slide Accessories (Art.-No. 70-2-7007) |
| 10   | Base                                   |
| 11   | Angle bracket                          |

## 5.2 Functional description

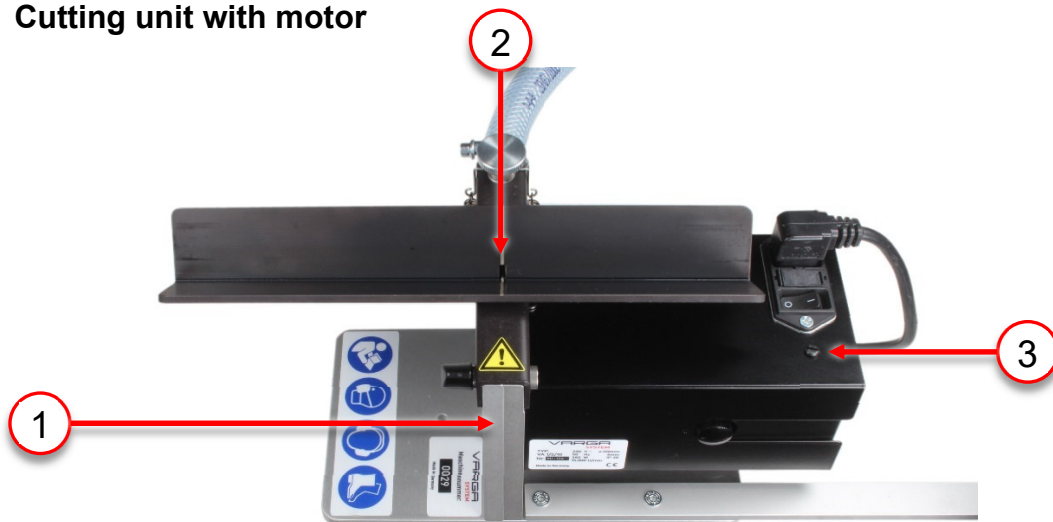
The VARGA VA 2 Edge Milling Machine is used for chamfering plates, strips, or panels. The height of the angle bracket (11, Figure 7) and thus the chamfer depth can be adjusted using the height adjustment screw (2, Figure 7). To adjust the angle bracket, first release the locking screw (8, Figure 7). The height of the angle bracket can then be adjusted using the height adjustment screw and fixed again with the locking screw.

The plate must be aligned at the angle bracket to the body. To attach the chamfer, it is then guided along the angle either from right to left or from left to right

Larger workpieces are guided along the hold-down device (item 1, Figure 7). The hole in the base (item 10, Figure 7) allows the edge milling device to be anchored to the workstation with a screw (M5). This serves to position the machine safely and as a tilt protection.

## 5.3 Component description

### 5.3.1 Cutting unit with motor



*Figure 8 Cutting unit with motor*

| Item | Designation              |
|------|--------------------------|
| 1    | Cutter blade housing     |
| 2    | Cutter blade             |
| 3    | Motor housing with motor |

The VA 2 Edge Milling Machine consists of a cutting unit comprising a motor housing with motor (3, Figure 8), a cutter blade housing (1, Figure 8), and an angle bracket as a support surface. There is a groove in the middle of the angle bracket through which the cutter blade (2, Figure 8) cuts the chamfer into the workpiece.

## 5.4 Working position

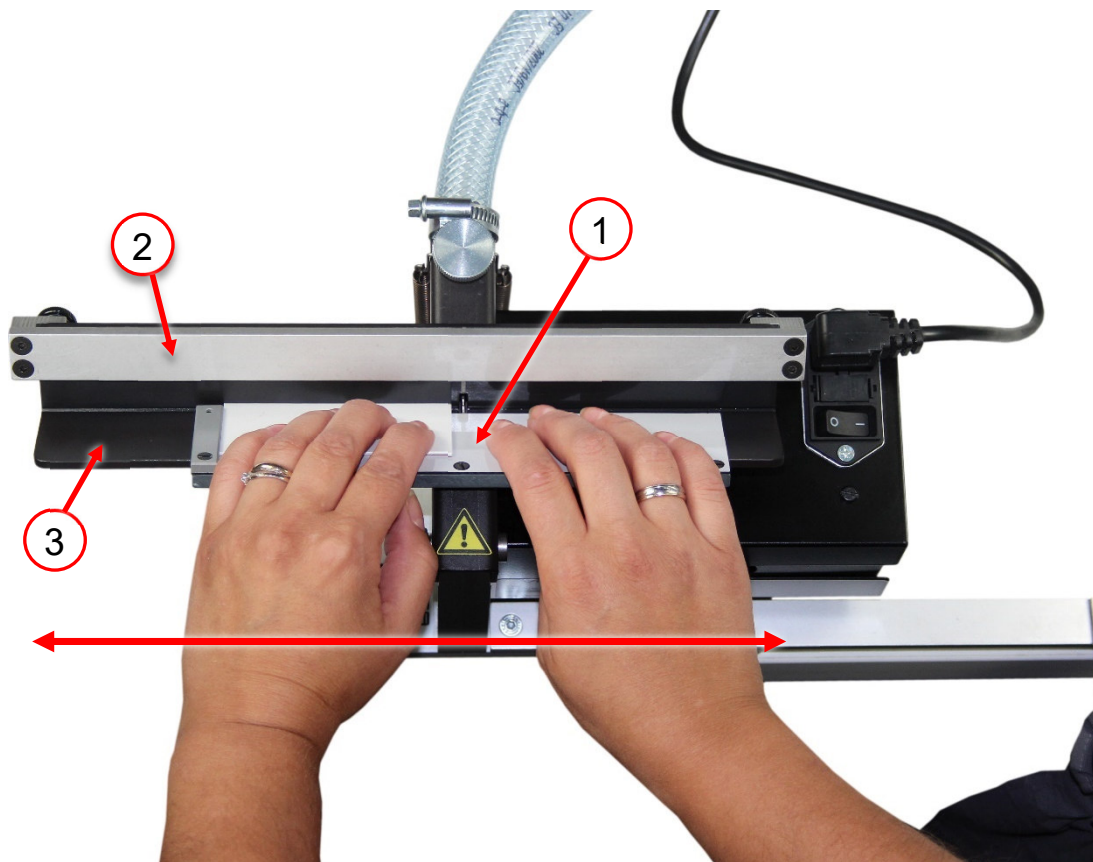


Figure 9 Position at work (viewed from above)

| Item                                                                                | Designation                            |
|-------------------------------------------------------------------------------------|----------------------------------------|
|  | Movement of the workpiece with slide   |
| 1                                                                                   | Slide Accessories (Art.-No. 70-2-7007) |
| 2                                                                                   | Hold-down device                       |
| 3                                                                                   | Angle bracket                          |

The operator stands in front of the Edge Milling Machine.

The plate must be positioned on the angle bracket (3, Figure 9) towards the body. The workpieces are then moved from right to left or left to right to apply the chamfer. Alternatively, processing can be carried out using the slider available as an accessory (1, Figure 9). Larger workpieces can be guided along the hold-down device (2, Figure 9).

## 6 Transport

**Target group:** Maintenance personnel



### 6.1 Special safety instructions

#### **WARNING!**

##### **Danger due to unwieldiness and weight of the machine**

Various dangers can arise due to the machine's unwieldiness and its own weight. Dropping it can cause bruising or fractures to the feet. Carrying loads incorrectly can damage the musculoskeletal system.

- Transport work may only be carried out by trained personnel.
- The machine must be switched off and the mains plug disconnected from the power supply before transport.
- Secure the cable and hose professionally.
- Lift and set down the machine ergonomically and gently. If necessary, use transport equipment (e.g. a pallet truck).
- Keep transport routes without transport equipment as short as possible.
- Wear hand protection.
- Wear foot protection.
- Work with care.

**⚠ WARNING!**

**Danger of parts and materials falling during transport with an industrial truck**

In the event of improper transport with an industrial truck, sudden shifts in weight can lead to uncontrolled behavior of the load. This can result in serious injuries.

- Secure parts and materials properly to prevent falling.
- Adjust the height of the angle bracket so high that the milling blade does not protrude from the groove. Ensure that no one is present under the loads.
- Ensure that no one is on or near the machine during transport.
- Do not use people as counterweights.
- Wear foot protection.

**ATTENTION**

**Falling components**

Improper transport can lead to material damage.

- When selecting the means of transport, observe the technical data of the machine and its individual components.

## 6.2 Transport packaging



*Figure 10 Transport packaging*

The VA 2 Edge Milling Machine is supplied in a cardboard box.

## 7 Assembly and installation

**Target group:** Maintenance personnel



### 7.1 Special safety instructions

#### **DANGER!**

##### **Danger due to electrical voltage**

Working with live components may result in direct contact with them. This will cause serious injury or death.

- Work on electrical equipment may only be carried out by qualified electricians of the manufacturer or specially authorized and trained electricians.
- Carry out work in compliance with the safety regulations.

#### **WARNING!**

##### **Danger due to unsuitable installation location**

An unsuitable installation location can cause the machine to tip over or fall. This can result in various injuries. The following instructions must be observed when setting up the machine.

- Ensure that the surface can bear the weight of the machine and is stable.
- Ensure that the surface is flat, non-slip, and level.
- Anchor the machine only using the method described in the operating instructions.
- The installation height must meet the ergonomic requirements of the personnel.
- Allow work to be carried out by trained specialist personnel only.

 **WARNING!**

**Danger due to improperly laid cables**

An improperly positioned mains plug cannot be reached quickly in the event of danger. There is a danger of serious injury and death from the rotating cutter blade.

- Lay the cable with the mains plug so that it is easily accessible from the workplace.
- Observe the marking on the mains isolating plug.

 **WARNING!**

**Dangers due to improperly fitted chip hose**

An improperly fitted chip hose can lead to increased dust and chip exposure and thus to irritation of the eyes and breathing difficulties.

- Before installing the machine, read the operating instructions and always follow them.

 **CAUTION!**

**Danger due to improperly laid cables and hoses**

Improperly laid cables or hoses can cause dangers such as tripping or falling. This can lead to bruises, sprains, or fractures.

- Lay and cover cables and hoses safely.
- Work with care.

## 7.2 Scope of delivery

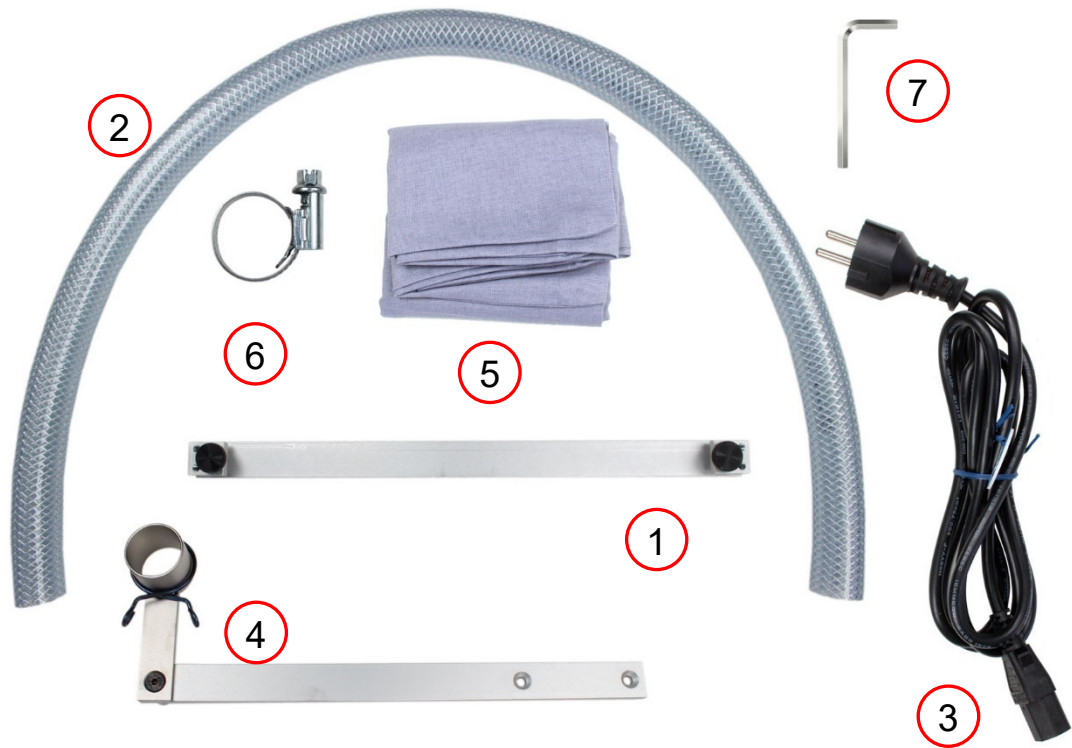


Figure 11 Scope of delivery

| Pos. | Bezeichnung                     |
|------|---------------------------------|
| 1    | Hold-down device                |
| 2    | Chip hose                       |
| 3    | Mains cable                     |
| 4    | Holder for chip bag with spring |
| 5    | Chip bag                        |
| 6    | Hose clamp                      |
| 7    | Hex key, 3 mm                   |



### 7.3 Assembling the machine

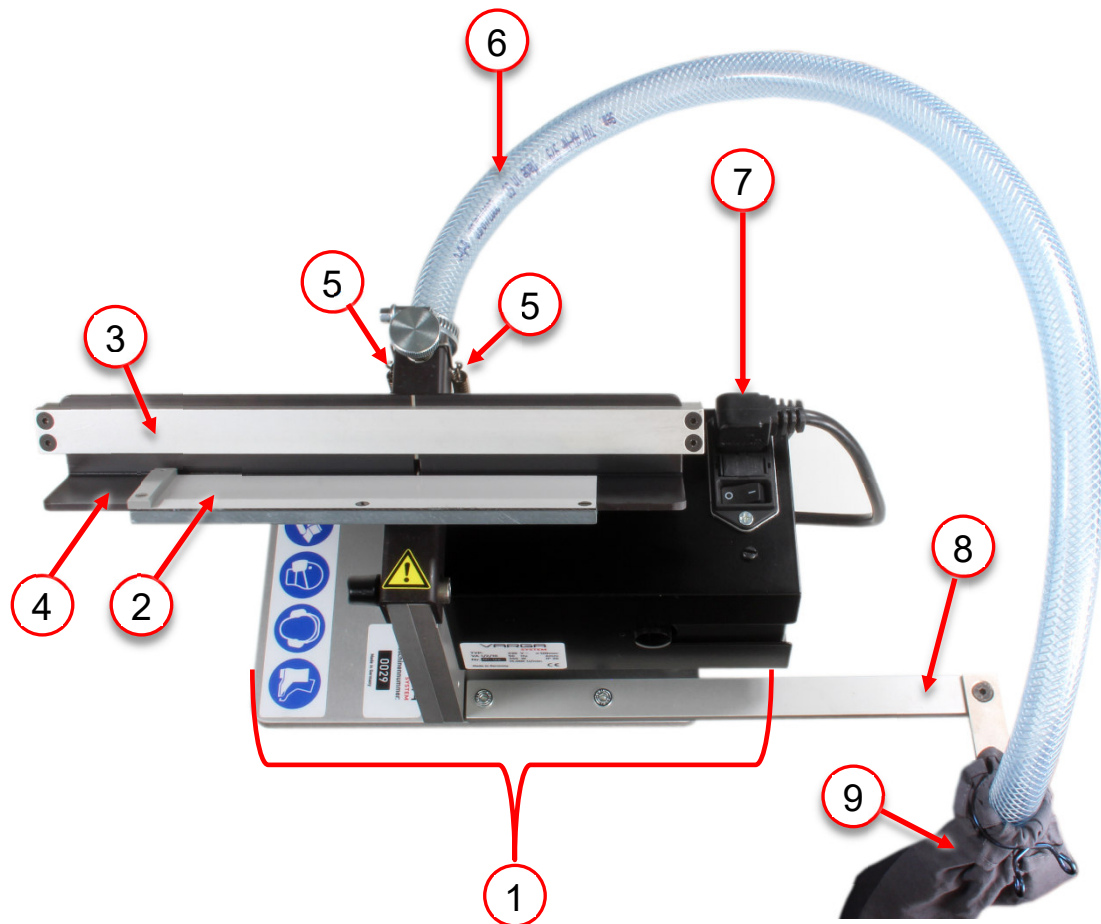


Figure 12 Assembly

| Item               | Designation                            |
|--------------------|----------------------------------------|
| 1                  | Cutting unit                           |
| 2                  | Slide Accessories (Art.-No. 70-2-7007) |
| 3                  | Hold-down device                       |
| 4                  | Angle bracket                          |
| 5                  | Tension springs                        |
| 6                  | Chip hose                              |
| 7                  | Mains cable                            |
| 8                  | Chip bag holder with spring clamp      |
| 9                  | Chip bag                               |
| Not shown in image | Hole for M5 screw                      |

### Action required

1. Remove the VA 2 Edge Milling Machine and the enclosed attachments from the box and place on a suitable work surface.
2. Remove the outer packaging and dispose of properly.
3. Place the Edge Milling Machine on the workbench. Mark the position of the drill holes on the workbench and pre-drill for M5 screws.
4. Insert the appropriate M5 screw into the appropriate hole and screw the edge milling device firmly to the workbench.
5. Attach the chip bag holder (item 8, Figure 12) to the base with the enclosed screws.
6. Guide the chip bag (9, Figure 12) from below through the opening in the bag holder, turn the end over, and secure it with the spring.
7. Attach the chip hose (item 6, Figure 12) to the chip ejection tube at the rear of the machine..
8. Insert the air hose into the chip bag opening.
9. Attach the hold-down bracket (item 3, Figure 12) to the bracket and fix it with the two knurled screws at the correct height or workpiece thickness
10. Connect the power cable (7, Figure 12) to the motor housing.
- ☒ *The Edge Milling Machine is assembled.*
11. Plug the mains cable into a socket.
- ☒ *Power supply is established.*
- ☒ *VA 2 Edge Milling Machine is ready for operation.*

## 8 Normal operation

**Target group:** Operating personnel, maintenance personnel



### 8.1 Special safety instructions

#### **DANGER!**

##### **Danger due to electrical voltage**

Working with live components may result in direct contact with them. This will cause serious injury or death.

- Work on electrical equipment may only be carried out by qualified electricians of the manufacturer or specially authorized and trained electricians.
- Carry out work in compliance with the safety regulations.

#### **WARNING!**

##### **Danger due to improper handling of the machine**

The machine presents various dangers such as the risk of crushing, cutting, and hearing damage.

- The machine may only be operated by trained and qualified personnel.
- Before handling the machine, read the operating instructions and always follow them.

#### **WARNING!**

##### **Danger due to noise**

Continuous noise emitted by the machine can cause hearing damage.

- Wear suitable hearing protection during operation.

 **WARNING!**

**Danger of crushing or cutting**

During the cutting process, personnel may come into contact with the cutter blade. This can cause crushing injuries or cuts to the fingers.

- Work may only be carried out by trained specialist personnel.
- Check the position of your hands.
- Work with care.

 **WARNING!**

**Danger due to ejection of chips and sawdust**

Chips are produced during chamfering, which can enter the respiratory tract and eyes. This can cause breathing difficulties and injury to the eyes.

- The machine may only be operated by trained and qualified personnel.
- Only operate the Edge Milling Machine in accordance with the plant operator's instructions and with the specified personal protective equipment (hearing protection, protective goggles, and respiratory mask) in accordance with the current working conditions.
- Only operate the machine with the chip hose attached.
- Empty the chip bag regularly.

 **WARNING!**

**Danger due to rotating cutter blade when the work is complete**

Danger of fingers being crushed or cut by the rotating cutter blade when the work is complete.

- Complete work on workpiece and remove workpiece.
- Switch off the machine at the on/off switch.
- Allow the cutter blade to stop.

 **WARNING!**

**Danger due to unexpected start-up of the cutter blade**

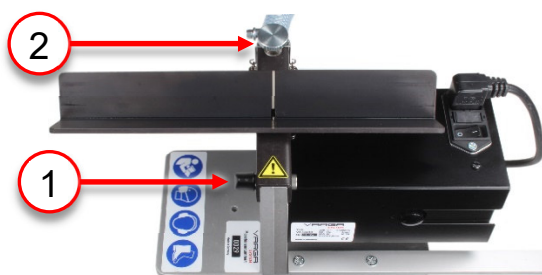
A power tool restarts automatically after a power failure if the toggle switch is set to "On". This can lead to cuts, kickback, or bending of the cutter blade.

- Switch off the machine in the event of a power failure.
- Work with care.

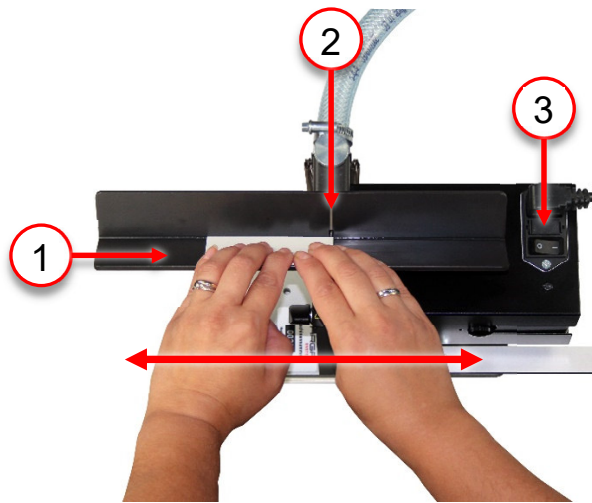
## 8.2 Chamfering the workpiece

**Action required**

1. Ensure that the VA 2 Edge Milling Machine is undamaged and securely bolted to the workbench.
2. Ensure that the correct cutter blade is in the machine and that it is not worn or damaged.
3. Ensure that the prescribed personal protective clothing (goggles, hearing protection, respirator) is worn.
4. Ensure that no parts lying around are obstructing the work area.
5. Ensure that the mains plug is plugged in.



6. Loosen the locking screw (1) to set the chamfer depth.
- ☒ *Angle bracket is released and can be adjusted in height.*
7. Adjust the angle bracket by turning the height adjustment screw (2) until the chamfer depth required is reached.
8. Retighten the locking screw.
- ☒ *Chamfer depth is set.*
9. Place the workpiece on the angle bracket (3) or on the slider.
10. Position the workpiece to the left of the cutting point (5).
11. Set toggle switch (6) to 1.



☒ The cutter blade begins to rotate.

12. **Caution!** Guide the workpiece so that the fingers are far enough away from the cutter blade and always work along the angle bracket or hold-down device.

Guide the workpiece slowly and safely over the rotating milling blade.

☒ Workpiece is chamfered.

13. Once the cutting process is complete, remove the workpiece from the machine.

14. Set the toggle switch to 0 and allow the cutter blade to stop.

☒ VA 2 Edge Milling Machine is safely switched off.

## 9 Maintenance

**Target group:** Maintenance personnel



### 9.1 Special safety instructions

#### **DANGER!**

##### **Danger due to electrical voltage**

Working with live components may result in direct contact with them. This will cause serious injury or death.

- Work on electrical equipment may only be carried out by qualified electricians of the manufacturer or specially authorized and trained electricians.
- Carry out work in compliance with the safety regulations.

#### **WARNING!**

##### **Improper cleaning, maintenance, or repair**

Improper cleaning, maintenance, or repair may result in serious injury or death.

- Before cleaning, maintenance, and repair work, ensure that the machine is switched off and disconnected from the power supply. The mains plug must be positioned in such a way that it cannot be accidentally reconnected by other persons.
- Deploy trained personnel only.
- Follow the operating instructions.

 **WARNING!****Danger due to improper handling of the machine**

The machine presents various dangers such as the risk of crushing, cutting, and hearing damage.

- The machine may only be operated by trained and qualified personnel.
- Before handling the machine, read the operating instructions and always follow them.

 **CAUTION!****Injuries due to sharp cutter blade**

Contact with the sharp-edged cutter blade may occur during maintenance or cleaning work. This can lead to cuts or puncture wounds to fingers and hands.

- Switch off the machine and disconnect it from the power supply before carrying out maintenance or cleaning work.
- Wear cut-resistant protective gloves.
- Handle the cutter blade with care and caution.
- Work with care.

**ATTENTION****Work not described**

- Work that is not described must only be carried out by an authorized service provider, otherwise it may cause damage to the machine.



If in doubt, contact customer service, see Section 9.2.



## 9.2 Customer service

|                        |                       |
|------------------------|-----------------------|
| <b>Manufacturer:</b>   | VARGA SYSTEM GmbH     |
| <b>Street:</b>         | Hainkämpe 5           |
| <b>Zip code, city:</b> | 28832 Achim           |
| <b>Country:</b>        | Germany               |
| <b>Telephone:</b>      | +49 4232 945870       |
| <b>Mail:</b>           | info@varga-system.com |

### 9.3 Maintenance/Cleaning

**Target group:** Maintenance personnel



#### 9.3.1 Maintenance/cleaning schedule

Details of the maintenance intervals listed below can be found in the relevant sections of these instructions.

| Activity                                                                                                                                                                                                                                                                         | Maintenance interval                                                 |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------|
| Clean the Edge Milling Machine:<br><b>Action required</b> <ol style="list-style-type: none"> <li>1. Disconnect the mains plug.</li> <li>2. Sweep off the Edge Milling Machine, clean with a cloth if necessary.</li> </ol>                                                       | As required, at least daily.                                         |
| Cleaning and oiling angles:<br><b>Action required</b> <ol style="list-style-type: none"> <li>1. Disconnect the mains plug.</li> <li>2. Sweep the edge cutter, wipe with a cloth if necessary.</li> <li>3. Rub the angle bracket with a cloth moistened with oil.</li> </ol>      | Regularly                                                            |
| Empty the chip bag:<br><b>Action required</b> <ol style="list-style-type: none"> <li>1. Disconnect the mains plug.</li> <li>2. Pull the exhaust air hose out of the chip bag.</li> <li>3. Release the spring and remove the chip bag.</li> <li>4. Empty the chip bag.</li> </ol> | As required (when the chip bag inflates or the lower third is full). |

- |                                                                                                                                                                                                             |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| <ol style="list-style-type: none"><li>5. Re-attach the empty chip bag and secure it with the spring.</li><li>6. Hook the exhaust air hose into the chip bag.</li><li>7. Reconnect the mains plug.</li></ol> |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|

**NOTE**

Some of the work specified depends on use and environmental conditions. The specified cycles are minimum values. Different maintenance cycles may be required in individual cases. If this is the case:

- adjust the information in these operating instructions.
- instruct the operating personnel accordingly.

## 9.4 Repairs

**Target group:** Maintenance personnel



### 9.4.1 Troubleshooting

#### ATTENTION

##### Unknown fault messages

Unknown faults and attempts to rectify them can lead to damage to the machine.

- If a fault is present but is not displayed on the fault message list, inform customer service.

The following overview provides information about faults, their causes, and remedies:

| Fault                             | Possible cause                              | Remedy                                                                                                                                                                   |
|-----------------------------------|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Cutter blade or workpiece jammed. | ➤ Foreign body is jamming the cutter blade. | <ol style="list-style-type: none"> <li>1. Switch off the Edge Milling Machine.</li> <li>2. Disconnect the mains cable.</li> <li>3. Remove any foreign bodies.</li> </ol> |
| Chips are not being extracted.    | ➤ Chip bag full.                            | <ol style="list-style-type: none"> <li>1. Check whether the chip bag is full</li> <li>2. Empty the chip bag.</li> </ol>                                                  |
|                                   | ➤ Chip ejection pipe blocked.               | ➤ Remove the chip hose and remove the blockage. If necessary, use a cleaning brush. If necessary, remove the angle and open the milling blade housing to clear clogging. |

## 9.4.2 Replacing cutter blade

### **CAUTION!**

#### **Injuries due to sharp cutter blade**

Contact with the sharp-edged cutter blade may occur during maintenance or cleaning work. This can lead to cuts or puncture wounds to fingers and hands.

- Switch off the machine and disconnect it from the power supply before carrying out maintenance or cleaning work.
- Wear cut-resistant protective gloves.
- Handle the cutter blade with care and caution.
- Work with care.

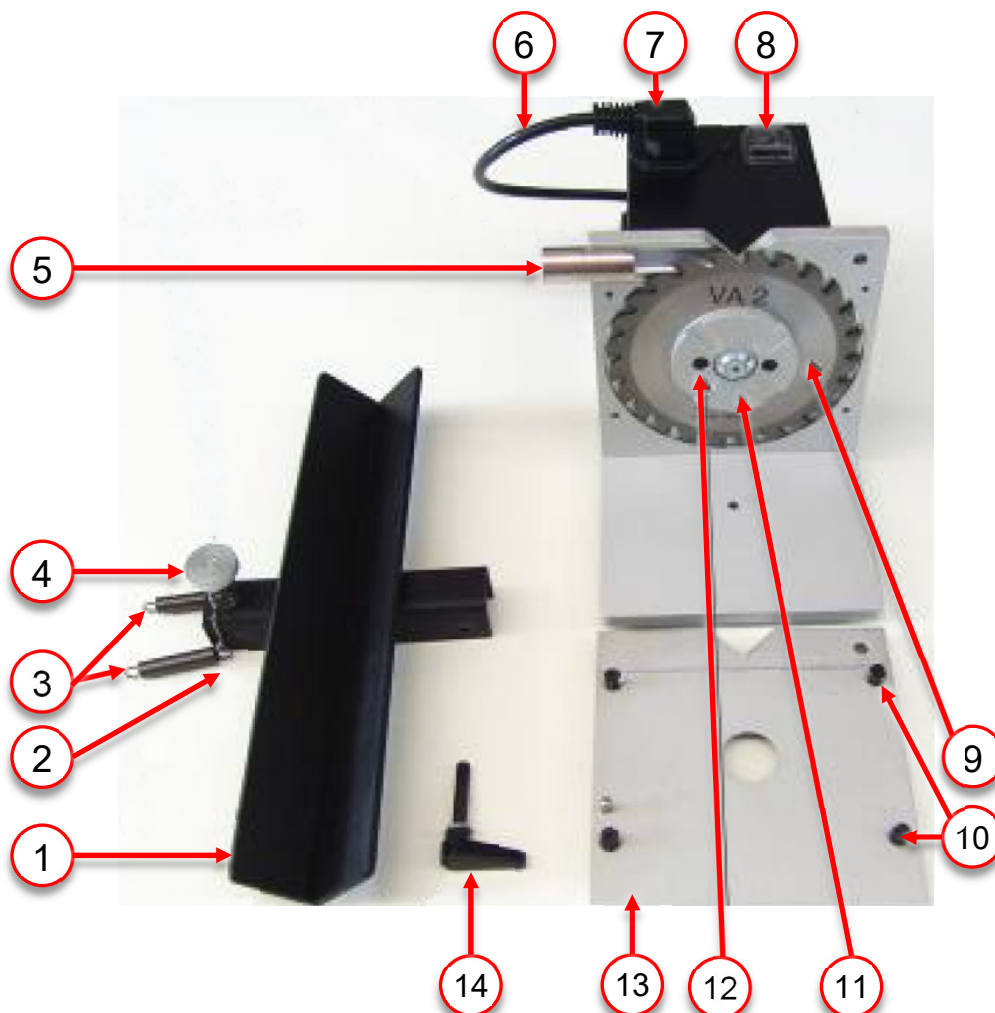


Figure 13 Replacing the cutter blade

| Item | Designation                                         |
|------|-----------------------------------------------------|
| 1    | Angle bracket                                       |
| 2    | Spring holder                                       |
| 3    | Tension springs                                     |
| 4    | Height adjustment screw                             |
| 5    | Chip ejection tube                                  |
| 6    | Mains cable                                         |
| 7    | Mains plug with fuse                                |
| 8    | Toggle switch                                       |
| 9    | Cutter blade                                        |
| 10   | Screws M4x16 (for cutter housing front, 4 pieces)   |
| 11   | Holder cover                                        |
| 12   | M4x16 screws ( <i>for holder cover, 2 pieces</i> )  |
| 13   | Cutter housing front                                |
| 14   | Locking screw ( <i>for angle bracket, 1 piece</i> ) |

### Action required

1. Ensure that the Edge Milling Machine is switched off at the toggle switch (8, Figure 13).
2. Always wear cut-resistant protective gloves.
3. Disconnect the mains plug (7, Figure 13).
4. Unscrew the locking screw (item 14, Figure 13) and remove the angle (item 1, Figure 13) from the cutter housing.
5. Loosen all four M4x16 screws (item 10, Figure 13) of the milling cutter housing at the front (item 13, Figure 13), remove them and store them securely.
6. Remove the cutter housing front cover (13, Figure 13) and set aside.
7. Loosen both M4x16 screws on the holder cover (10, Figure 13), remove, and put safely to one side.
8. Remove the holder cover (11, Figure 13).
9. Carefully remove the used cutter blade (9, Figure 13) and dispose of it.
10. Insert new cutter blade.

**Caution:** *Check the direction of rotation of the cutter blade!*

11. Replace the holder cover.
12. Replace both M4x16 screws of the holder cover and tighten carefully.

13. Reinsert the cutter housing at the front.
  14. Replace all four screws for the milling cutter housing at the front and tighten them.
  15. Place the bracket on the cutter housing and fasten it with a locking screw.
  16. Plug the mains plug back in.
- ☒ *Cutter blade has been replaced.*
  - ☒ *The Edge Milling Machine is ready for operation again.*

#### 9.4.3 Replacing a fuse

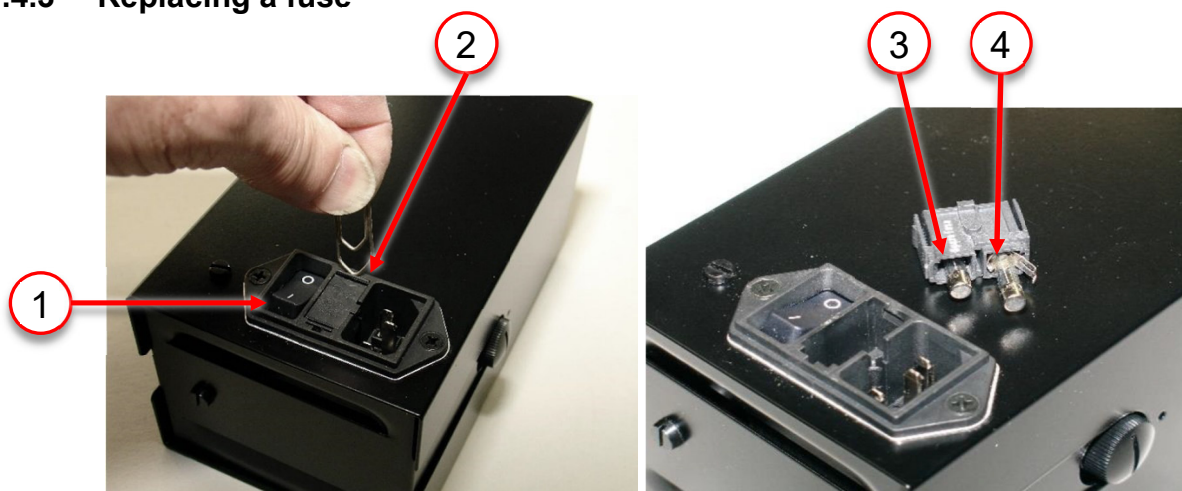


Figure 14 Replacing a fuse

##### Action required

1. Ensure that the Edge Milling Machine is switched off (1, Figure 14).
2. Disconnect the mains plug.
3. Remove the cover of the fuse holder (2, Figure 14) using a paper clip.

**Note:** There are two fuses in the fuse holder. Item 4 (Figure 14) contains the main fuse. There is a back-up fuse in item 3 (Figure 14).

4. Insert new fuse.
5. Reinsert the fuse holder into the receptacle.

☒ *Fuse has been replaced.*

## 10 Shutdown

**Target group:** Maintenance personnel



### 10.1 Special safety instructions

 **WARNING!**

**Danger due to improper handling of the machine**

The machine presents various dangers such as the risk of crushing, cutting, and hearing damage.

- The machine may only be operated by trained and qualified personnel.
- Before handling the machine, read the operating instructions and always follow them.

### 10.2 Temporary shutdown

**Action required**

1. Ensure that the VA 2 Edge Milling Machine is switched off.
2. Disconnect the mains cable.
3. Remove and empty the chip bag.
4. Clean the VA 2 Edge Milling Machine.
5. Loosen the tension springs and remove the angle bracket.
6. Pack away the angle bracket, hold-down devices and, if necessary, sliders
7. Remove the VA 2 edge milling machine from the workbench and store the fastening material carefully.
8. Place the VA 2 edge milling machine and angles bracket as well as accessories in a cardboard box and bring them to the storage location.



### 10.3 Storage during temporary shutdown



Observe the information on temporary shutdown in Section 10.2.

Proper storage guarantees a long service life.

#### **Action required**

- Store the VA 2 Edge Milling Machine only in a closed, well-ventilated room.
- Protect the machine from dust.
- Take suitable corrosion protection measures for long-term storage.
- Keep the operating instructions in a safe place.

### 10.4 Final shutdown

#### **Action required**

1. Ensure that the VA 2 Edge Milling Machine is switched off.
2. Disconnect the mains cable.
3. Remove and empty the chip bag.
4. Clean the VA 2 Edge Milling Machine.
5. Loosen the tension springs and remove the angle bracket.
6. Pack away the angle bracket, hold-down devices and, if necessary, sliders
7. Remove the VA 2 edge milling machine from the workbench and store the fastening material carefully.
8. Place the VA 2 edge milling machine and angles bracket as well as accessories in a cardboard box and bring them to the storage location.

## 11 Disposal

**Target group:** Specialist personnel



### 11.1 Special safety instructions

#### **WARNING!**

##### **Danger due to improper handling of the machine**

The machine presents various dangers such as the risk of crushing, cutting, and hearing damage.

- The machine may only be operated by trained and qualified personnel.
- Before handling the machine, read the operating instructions and always follow them.

#### **CAUTION!**

##### **Danger to personnel from materials and substances**

Improper disposal of materials and substances can lead to personal injury.

- Observe the information in the safety data sheets when disposing of auxiliary and operating materials
- Wear appropriate personal protective equipment.

#### **ATTENTION**

##### **Environmental dangers from materials and substances**

When disposing of the product and its individual components, materials and substances pose a danger to the environment.

- Separate materials by type and recycle in accordance with local regulations.
- Observe the local regulations and information in the safety data sheets when disposing of auxiliary and operating materials.

## 11.2 Disposing of the machine

A defective machine can be disposed of using the method of disposal for electrical appliances after final shutdown. (See Section 10.4 Final shutdown).



Observe the local regulations and information in the safety data sheets when disposing of auxiliary and operating materials.



If in doubt about the disposal method, contact the manufacturer or your local waste disposal company.

---

## 12 Instruction log

COPY SHEET!

➤ Copy first, then fill in.

| Date | Name | Type of instruction | Instruction provided by | Signature |
|------|------|---------------------|-------------------------|-----------|
|      |      |                     |                         |           |
|      |      |                     |                         |           |
|      |      |                     |                         |           |
|      |      |                     |                         |           |
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