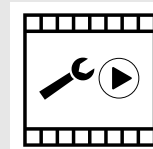
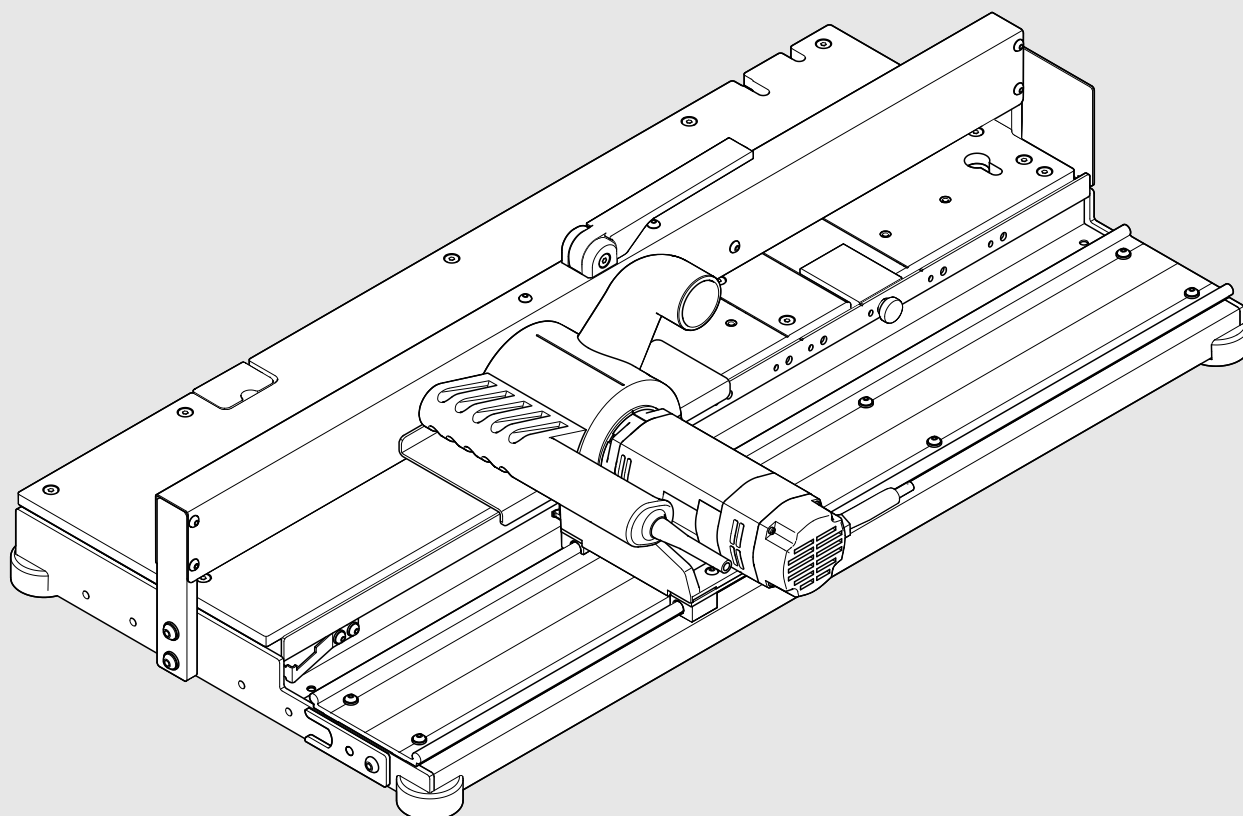


# M35.7200.NA – Bottom router



## Safety, set-up, operating and maintenance instructions

NA - EN



Ensure that the instructions have been fully read and understood before operating the bottom router. Only appropriately trained and authorized personnel may operate the bottom router.

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## A – Safety



### WARNING

#### Handling:

- Please read the instruction manual and the safety information before starting up the bottom router.
- We recommend that you use the reference diagram for easier identification of the parts being described.

#### Safety principle

The bottom router conforms to current safety standards. Nevertheless, certain risk factors will remain if the information contained in this instruction manual is not observed.

#### Residual risk according to EN ISO 12100:1210

- The bottom router 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.



### WARNING

#### Intended use:

The bottom router is only intended to process drawer bottoms for the Blum LEGRABOX and TANDEMBOX. The bottom router may only be used under the following conditions:

- The bottom router may only be operated by fully trained personnel.
- The bottom router is designed for professional traders.
- Only particle board and medium-density fibreboard (MDF) may be used as materials.
- The device should only be installed in dry, enclosed rooms.
- Only for drawer bottoms with a thickness of 15–19 mm / (9/16" - 3/4").  
(depending on device type)
- Only original Blum tools may be used.
- No liability can be accepted for any other use.

#### Foreseeable misuse

No solid wood, hard wood or plastic may be processed.



### WARNING

#### Responsibilities:

The operator

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

## Risk levels

**WARNING**

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

**CAUTION**

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

**NOTE**

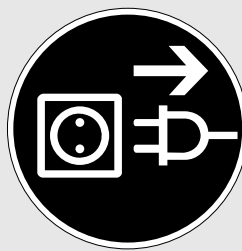
- The NOTE sign indicates information that should be observed.

**WARNING**

**Serious cuts.**

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

- Only push the carriage by the handle.

**WARNING**

**Serious cuts.**

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

- The bottom router must be disconnected from the power supply before set-up, cleaning and maintenance.

**WARNING**

- The bottom router is only intended for use by one person.
- **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from work area.
- **MAKE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
- **WEAR PROPER APPAREL.** Do not wear clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- Only attach the bottom router to a sufficiently stable table.
- Operate with the bottom router only when the router carriage [S1] is mounted
- Ensure there is sufficient lighting.
- Only operate the bottom router with the dust extraction system on.
- 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 bottom router.
- For your own safety, use only those accessories which are recommended or specified in the instruction manual or Blum sales catalog.
- Check the electrical cable for damage.

- The bottom router is only intended for use by one person.
- Ensure that the average air velocity for dust extraction system is at least 20 m/sec.
- The negative pressure in the dust extraction system must be 250–300 mbar.
- Failure to observe the instructions and warnings given for this bottom router may result in serious injury.
- The instruction manual should be accessible to operating and maintenance personnel at all times.
- When the rocker switch is released, the milling cutter continues to run for a time. Wait for the milling cutter to come to a standstill under all circumstances.

## Warning signs



Before connecting the bottom router to the power supply, you must ensure that you have understood ALL the safety instructions, warning signs and the instruction manual.



Keep non-authorized persons away from the bottom router.

No more than one operator may use the bottom router at a time.



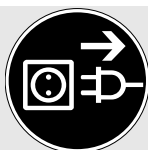
Always wear eye protection when operating this machine.



Wear proper ear protection when operating this machine.



Danger of crushing!

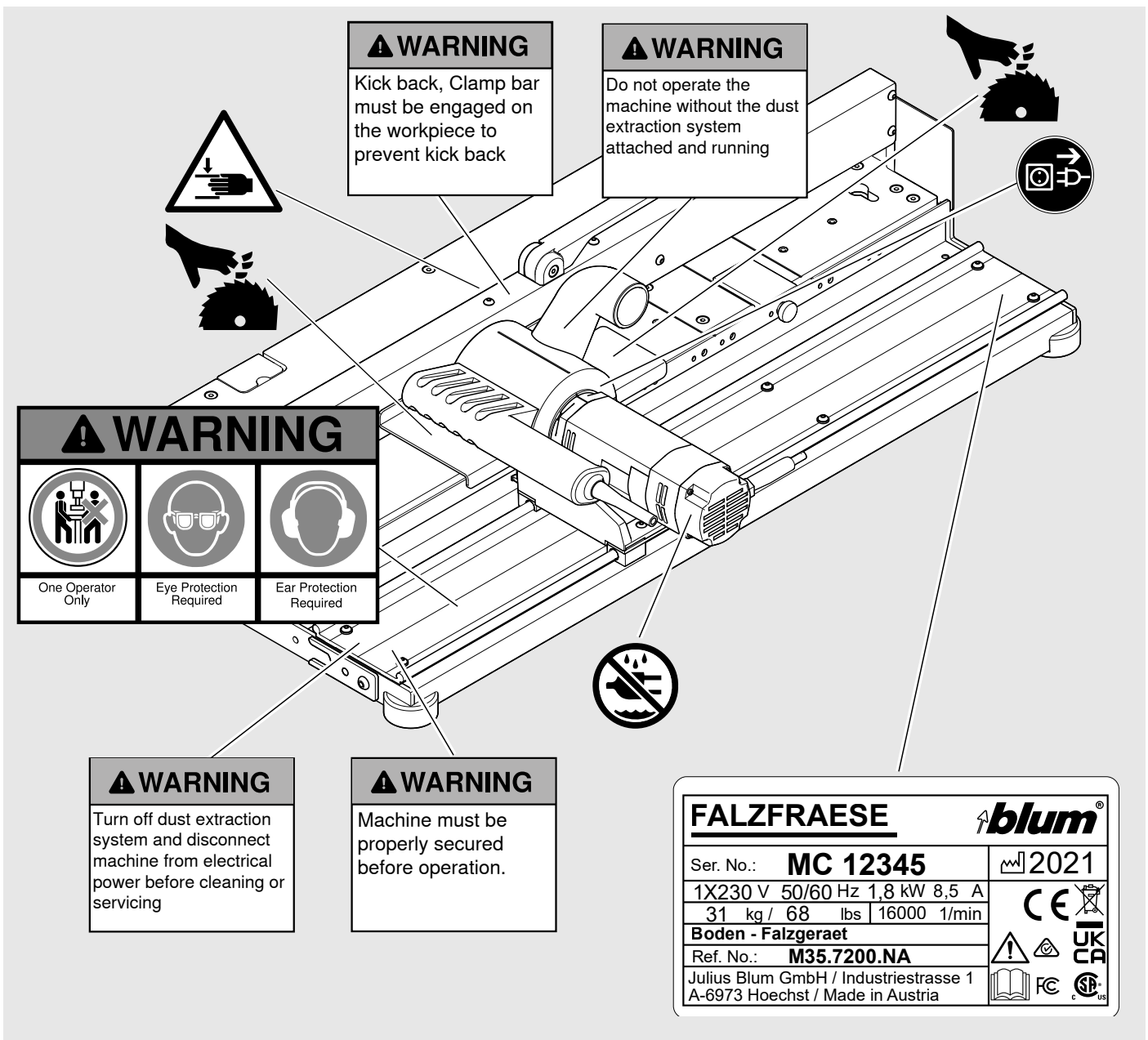


The bottom router must be disconnected from the power supply before cleaning and maintenance.

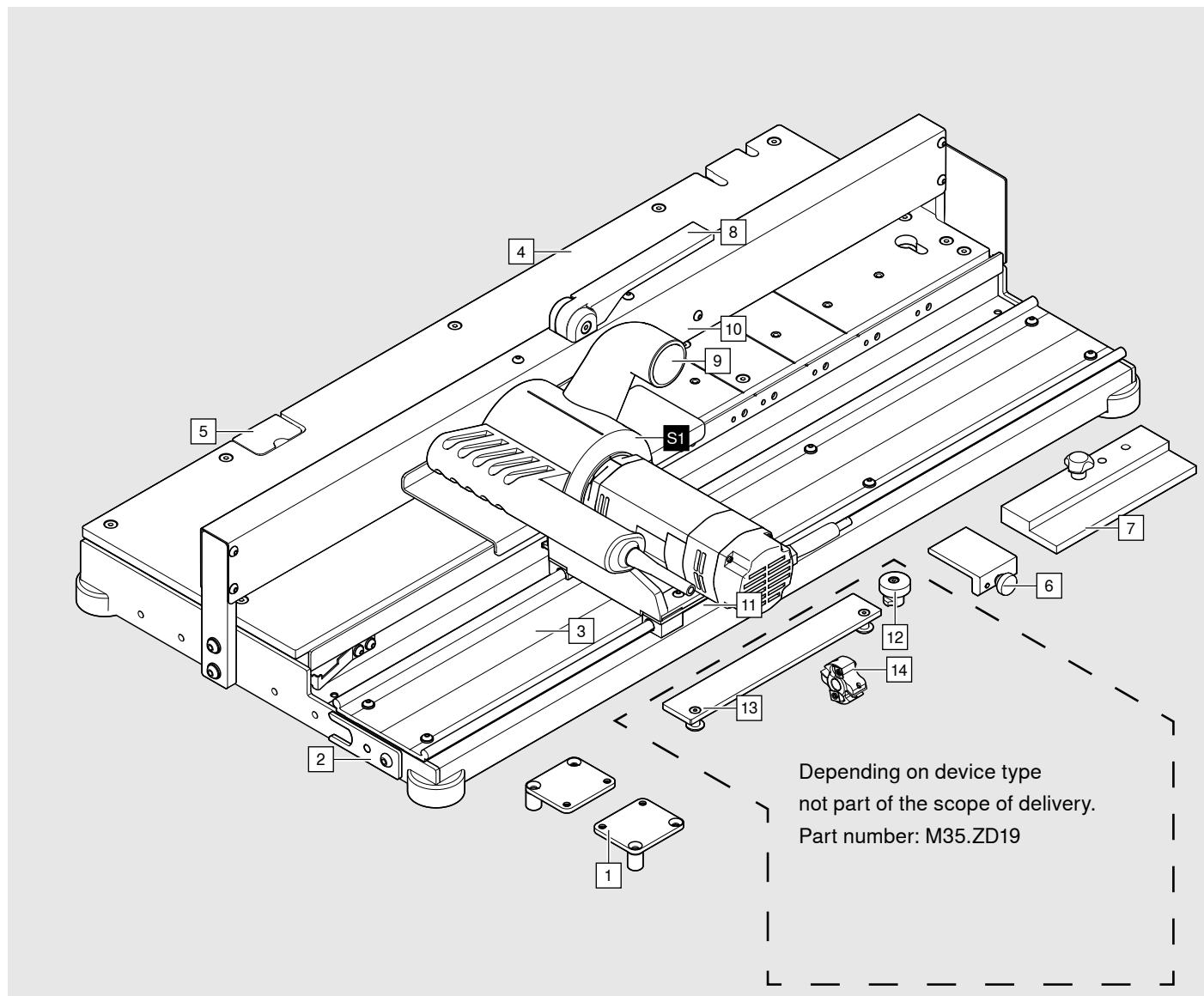


Serious cuts.

### Position of warning signs

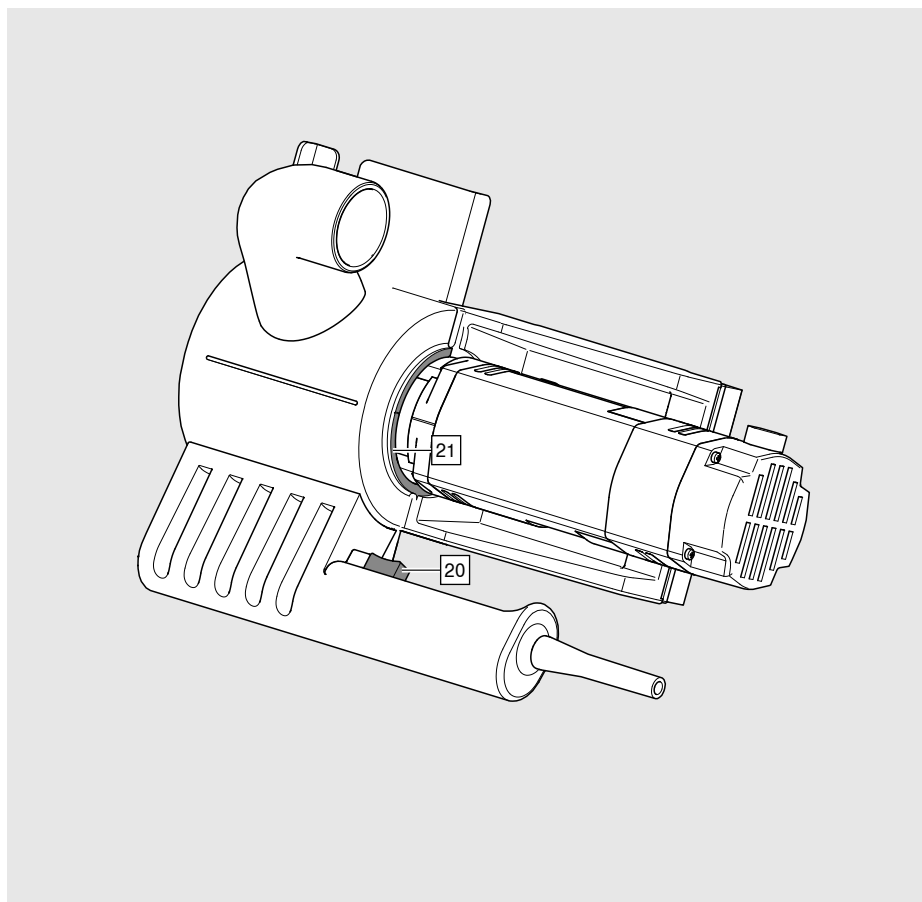


## B – Reference diagrams

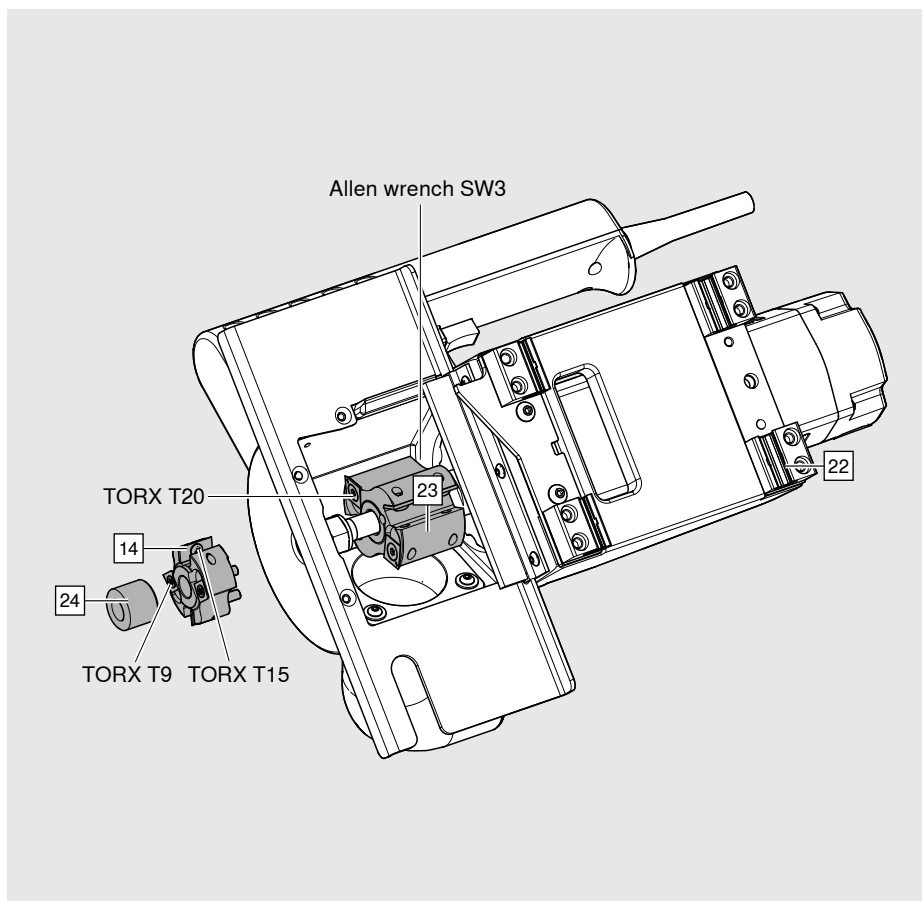


- |                                  |                 |
|----------------------------------|-----------------|
| 1 Fixing board (delivered loose) | 12 Support stop |
| 2 Shaft holder                   | 13 Stop bar     |
| 3 Runner                         | 14 Cutter DM 44 |
| 4 Work top                       |                 |
| 5 Support                        |                 |
| 6 Depth stop                     |                 |
| 7 Wood stop                      |                 |
| 8 Clamping lever                 |                 |
| 9 Dust extraction socket         |                 |
| 10 Clamping plate                |                 |
| 11 Transportation lock           |                 |
| S1 Router carriage               |                 |

## Reference diagram for Router carriage



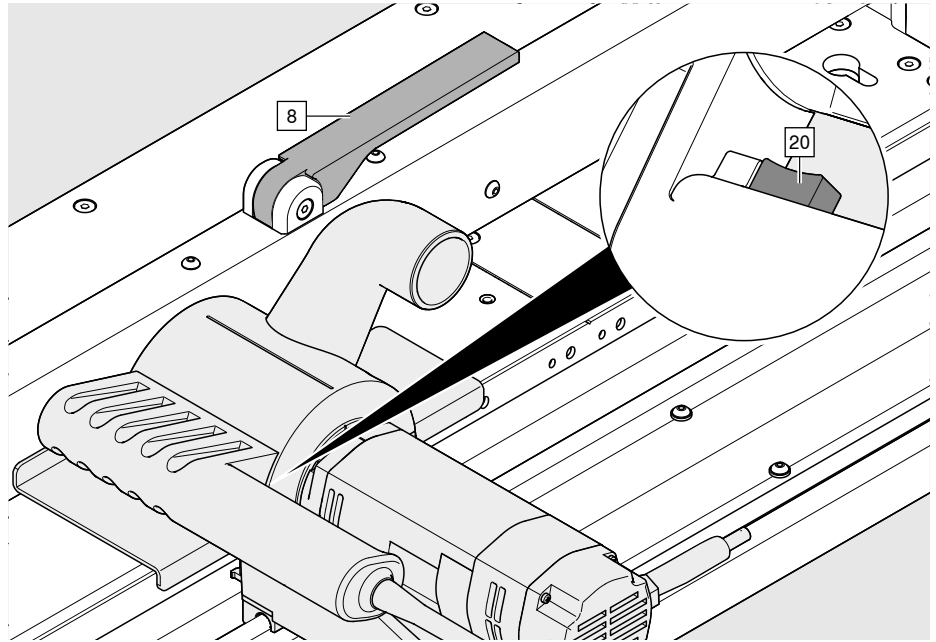
- 20 Rocker switch
- 21 Flange surface



- 22 Sliding film
- 23 Notch cutter
- 24 Spacer sleeve
- 14 Cutter DM 44



## Operating elements



### **8** Clamping lever

Press down the clamping lever [8] to secure the work piece.

### **20** Rocker switch

The rocker switch [20] is used to switch the bottom router off and on.

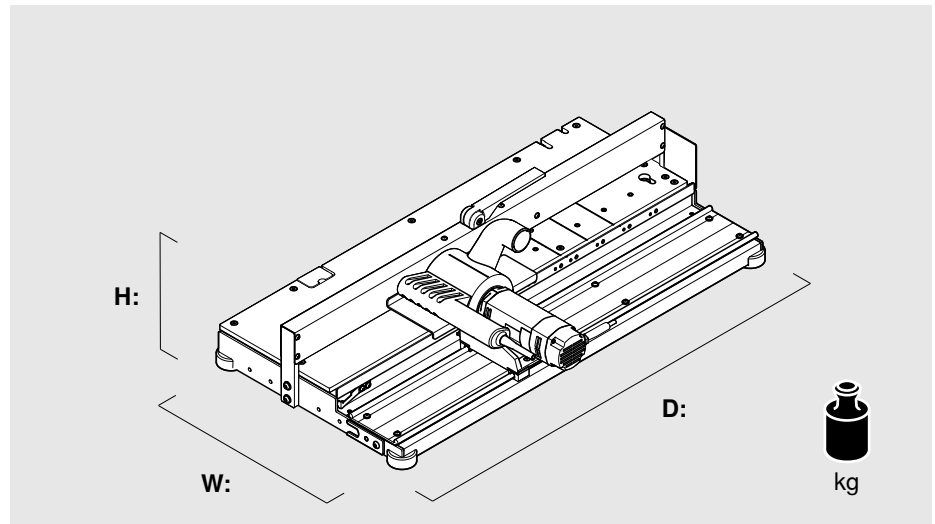
Non-stop operation is not possible.

When the rocker switch is released, the milling cutter continues to run for a time.  
Wait for the milling cutter to come to a standstill under all circumstances.

In the event of overheating due to overload, the motor will be switched off by the temperature monitoring. After a cooling phase the motor can be operated again.

## C – Installation and start-up

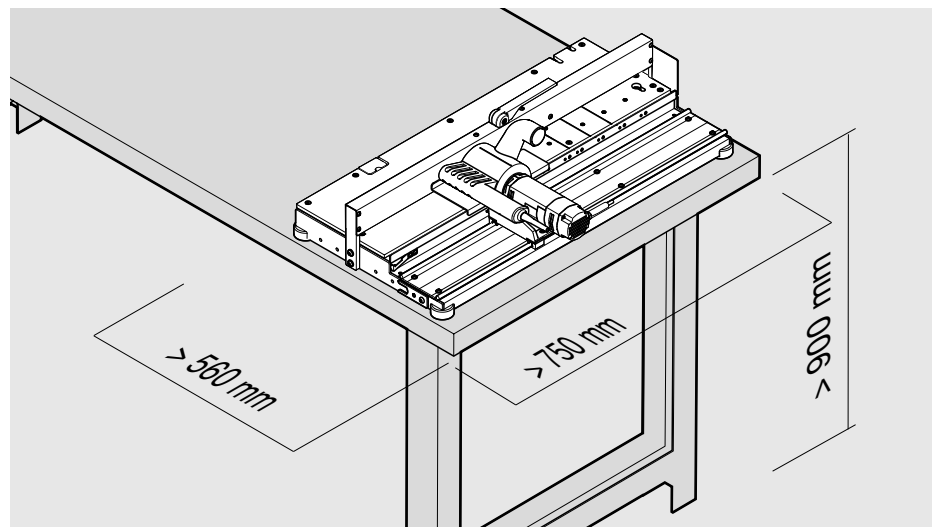
### Dimensions and weight



Height (H): \_\_\_\_\_ 250 mm (9 7/8")  
 Width (W): \_\_\_\_\_ 580 mm (22 7/8")  
 Depth (D): \_\_\_\_\_ 990 mm (39")  
 Weight: \_\_\_\_\_ 29 kg (64lb)

- Only use in dry, enclosed rooms.
- Ensure there is sufficient lighting.

### Requirements for the work area



#### WARNING

**The bottom router weighs 29 kg (64lb).**

**Failure to observe this information may result in personal injury.**

- The bottom router must be lifted by two persons.

- A table height of more than 900 mm (35 7/16") is recommended.
- The specified width, depth and height are minimum dimensions.
- The bottom router must only be used on a stable work top.



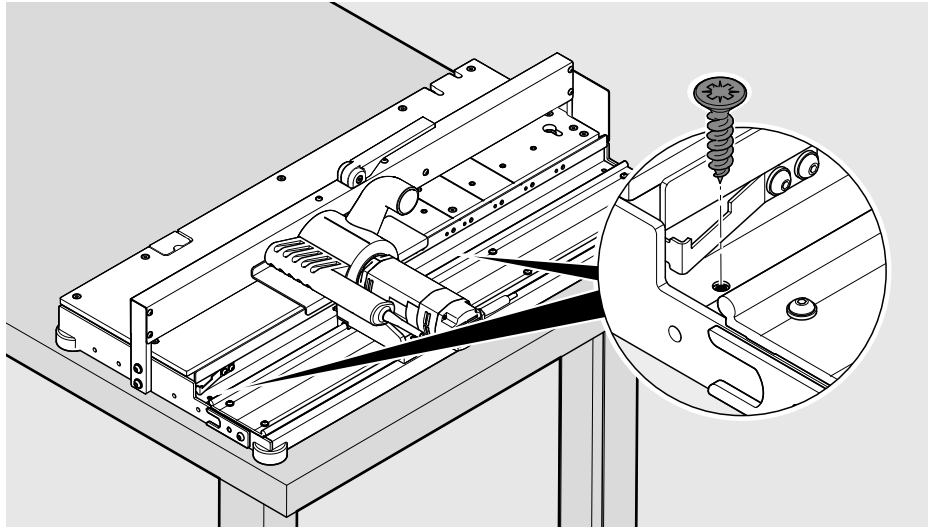
## WARNING

**The bottom router must be securely connected to the workbench.  
Failure to heed this warning may result in personal injury and material damage.**

The following fixing methods are intended for the bottom router:

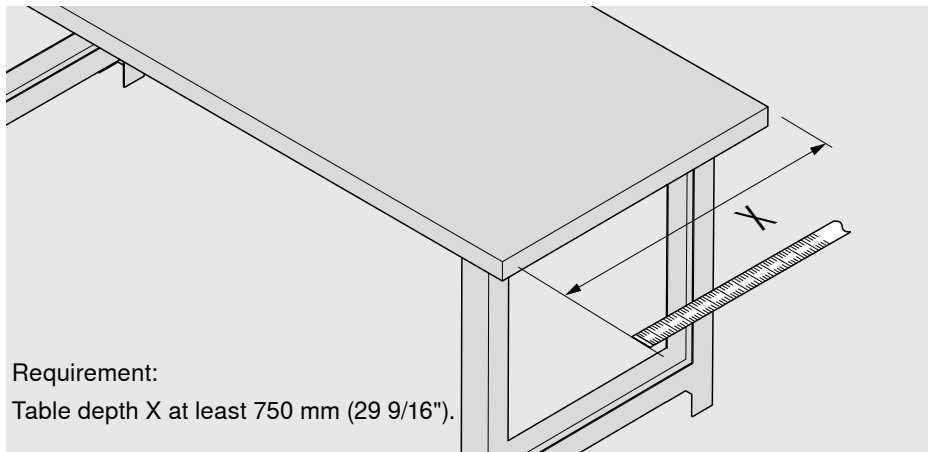
- fixed attachment to the work top
- removable attachment to the worktop

### Fixed attachment to worktop

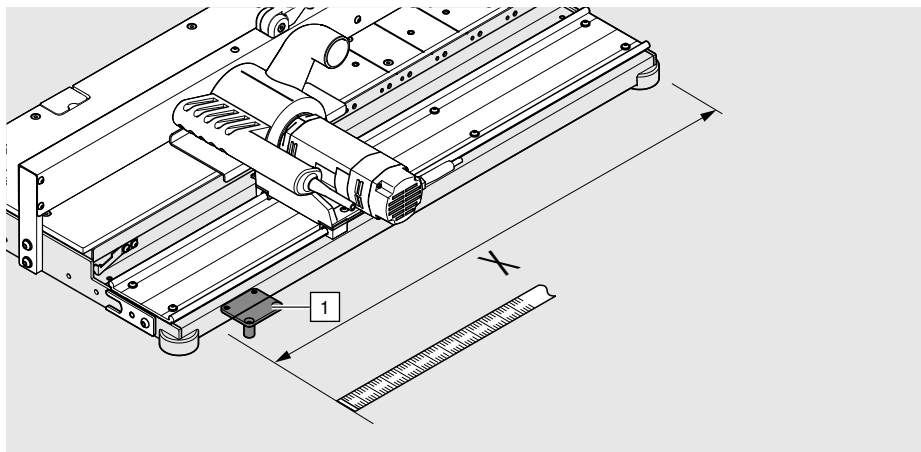


- Screw the bottom router to the work top.

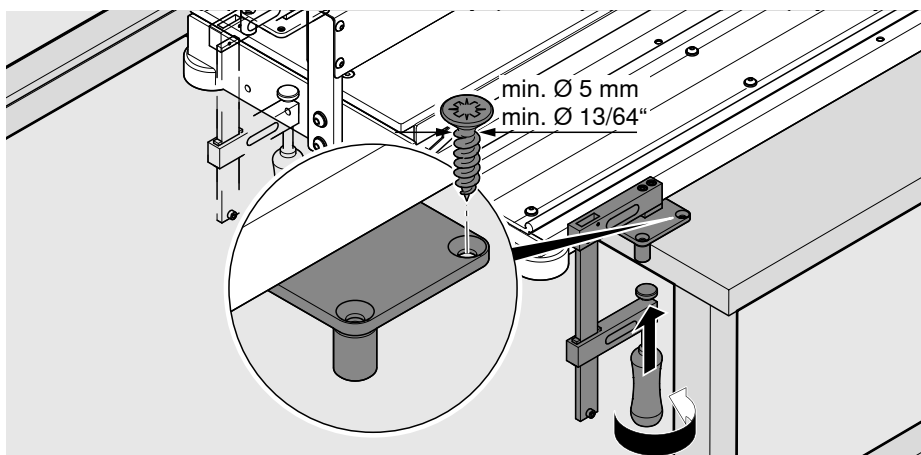
### Removable attachment to worktop



- Measure the depth X of the workbench.

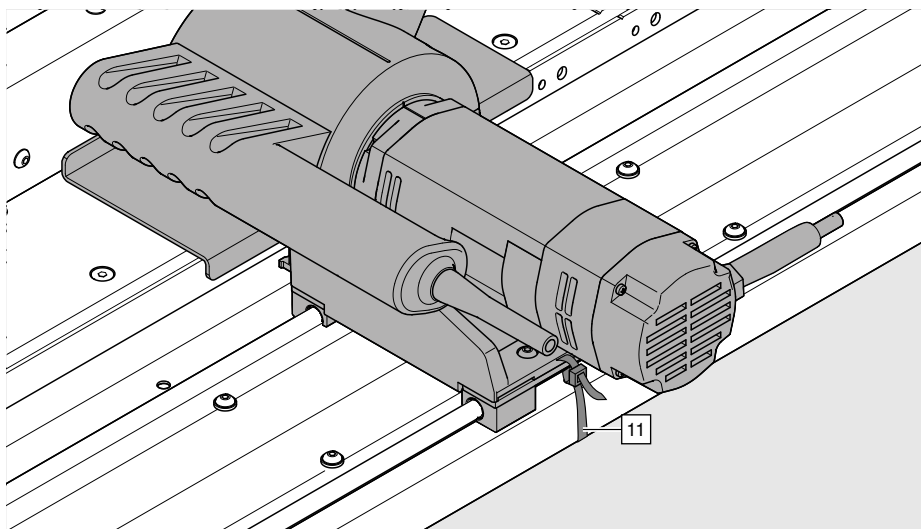


- Position the fixing board [1] within the table length and screw to the frame.



- Secure the bottom router to the work top with fixing boards [1] and screw clamps.

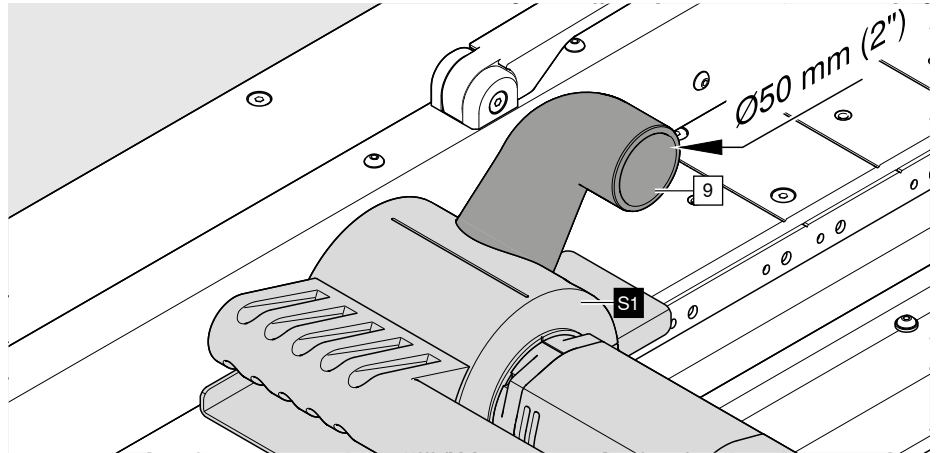
## Removing the transportation lock



The carriage of the bottom router is secured for transport.

- Remove the transportation lock [11].

## Connecting the dust extraction system

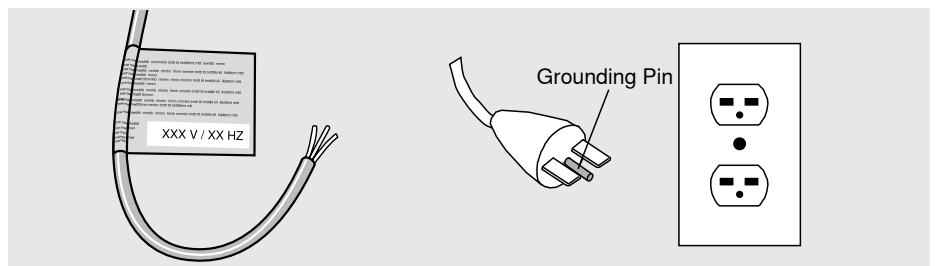


- Insert an extraction hose with an inner diameter of 50 mm (2") into the dust extraction socket [9] and secure it.  
Dust extraction socket [9] outer diameter 50 mm (2").
- Ensure that the average air velocity for the dust extraction system is at least 20 m/sec.
- The negative pressure must be 250–300 mbar.
- Move the carriage [S1] across the full length.  
Check that the cable and hose can move freely.  
Avoid tensioning or scraping the cable and hose.

## Electrical connection

### **i** NOTE

- The electrical connection must be performed by a qualified electrician!
- The bottom router is designed for the voltage printed on the label of the connection cable.



- Mount a plug conforming to CSA or UL requirements.
- Don't hardwire the bottom router directly to the supply circuit

## Connecting the power supply

- Insert the plug.  
The bottom router is designed for 230–240 V 50/60 Hz.

### **i** NOTE

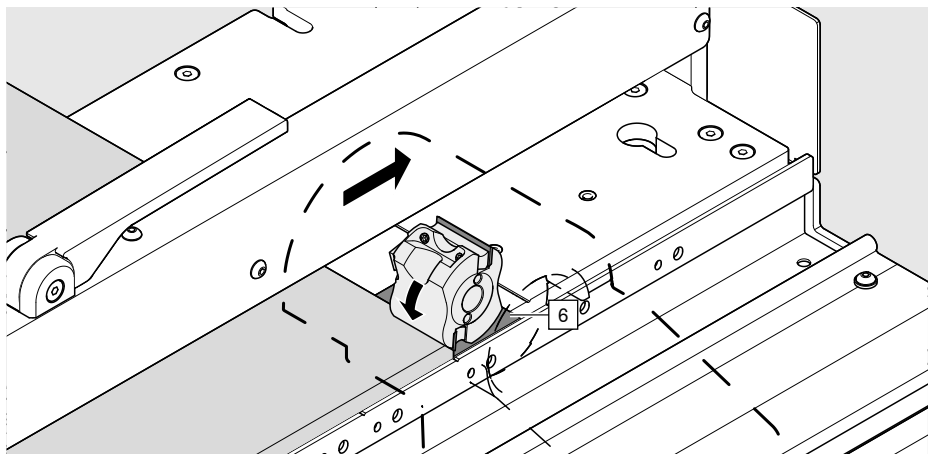
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician. Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the

equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug. Repair or replace damaged or worn cord immediately.

- This bottom router is intended for use on a circuit that has an outlet that looks like the one illustrated. The bottom router has a grounding plug that looks like the plug illustrated. Make sure the bottom is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this bottom router. If the bottom router must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel: and after reconnection, the bottom router should comply with all local codes and ordinances.
- The outlet must be fitted with a PE protective contact.
- The outlet must have a minimum 16 A fuse.
- After finishing work, disconnect the bottom router from the power supply.
- Avoid overloading the outlet.
- Do not use the bottom router together with an extension lead or cable drum.
- Use a separately protected outlet for the dust extraction system and bottom router.

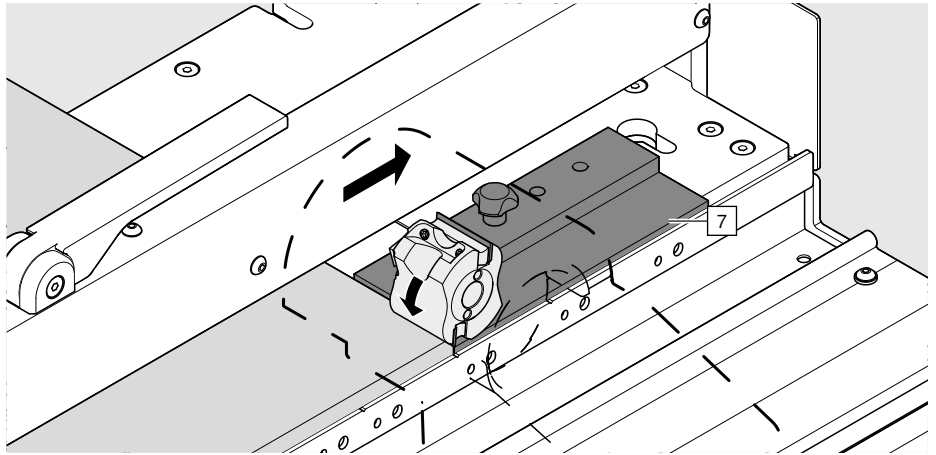
## D – Information about routing

### Routing with depth stop [6] for uncoated work pieces



The depth stop [6] is used to position the work piece.  
For work pieces with edge bands and for backs, we recommend using the wood stop [7].

### Routing with wood stop [7] for coated work pieces



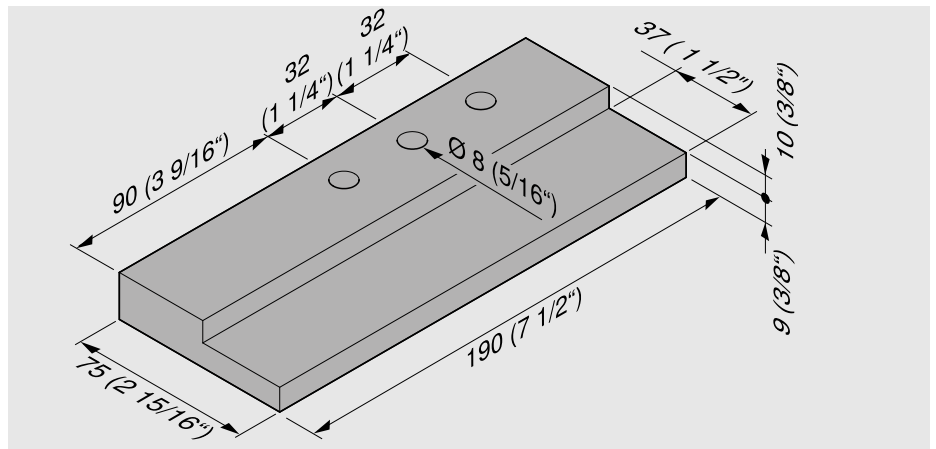
The wood stop [7] prevents torn edges and edge bands. When processing backs, the use of the wood stop [7] is strongly recommended.

The wood stop [7] is designed for small processing quantities and must therefore frequently be replaced.

#### **i** NOTE

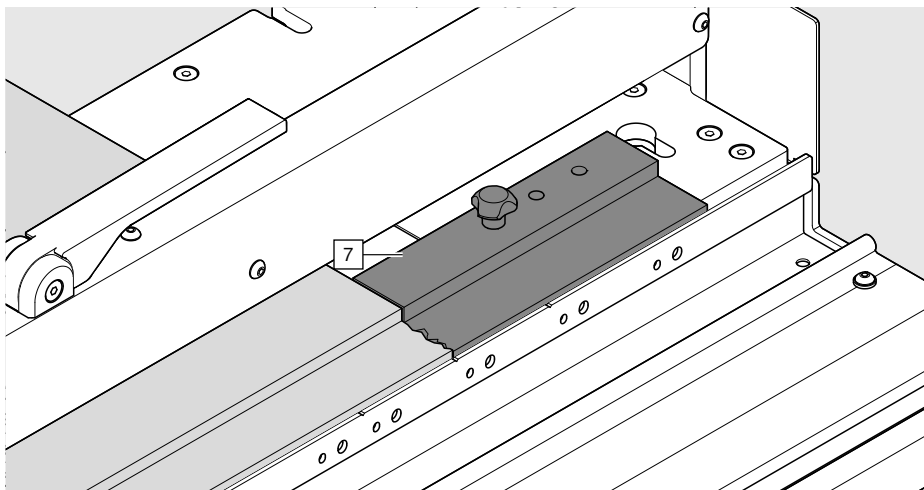
- The wood stop [7] is included loose.
- Spare part – part number: M35.ZT01 (10 pieces)

### Wood stop drawing [7]

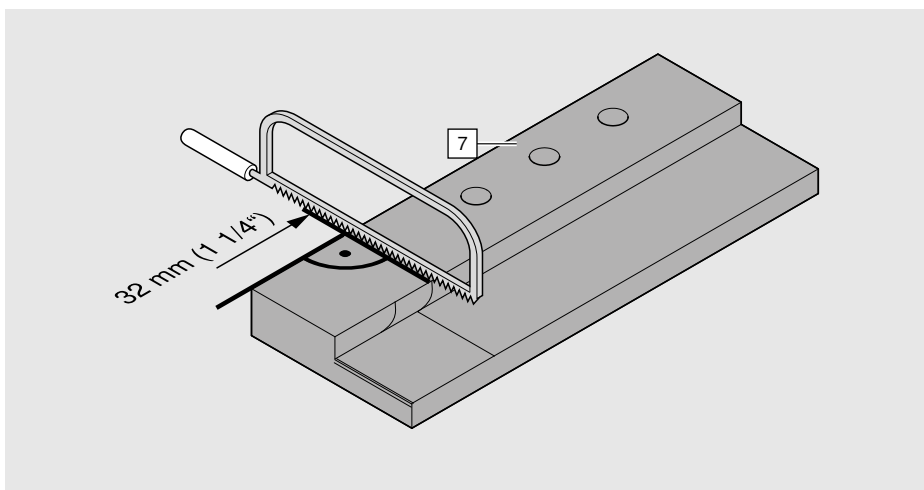


#### **i** NOTE

- For in-house production, the wood stop [7] must be pre-notched. This will significantly improve the result of the processed work piece.

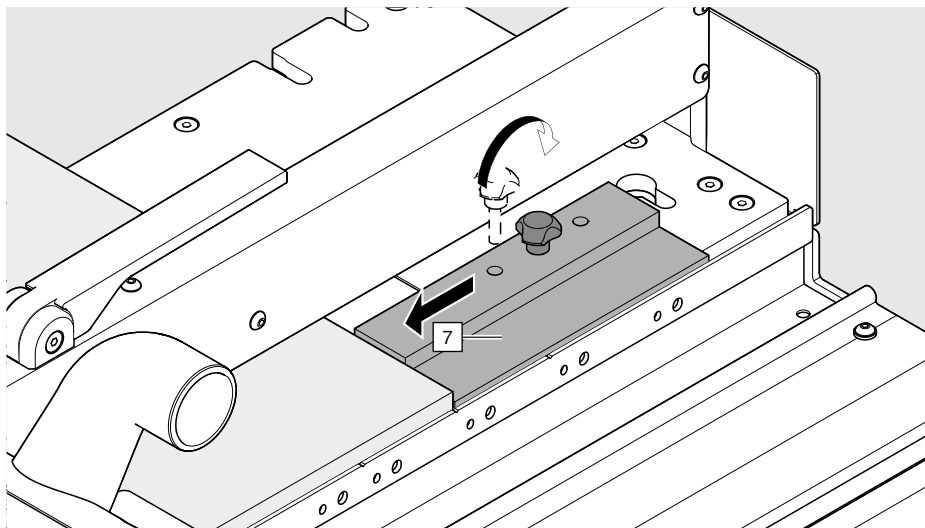
**Replacing the wood stop [7]**

The wood stop [7] becomes worn through frequent routing. This can lead to torn edges on the work piece. To avoid this, the wood stop [7] must be reworked, if necessary.



- Shorten the wood stop [7] by 32 mm.



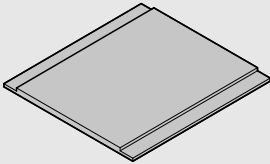
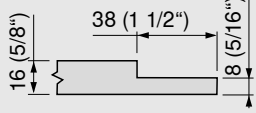
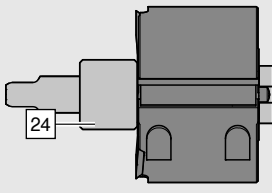



- Reposition the wood stop [7] using the next through-hole.
- The wood stop [7] can be reworked twice.

**E – Processable products, required accessories, work steps**

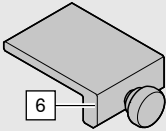

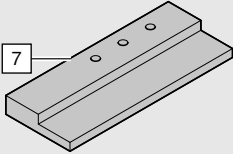




Panel thickness


**15 - 16 mm (9/16" - 5/8")**

LEGRABOX	Selecting		Set-up	
	Drawer bottom [30]	Notch	Cutter fittings	
			 	

**In scope of delivery****i NOTE**

- The cutter M35.ZF44.03 should not be used in the processing of panel thicknesses up to 16 mm (5/8"). The spacer sleeve [24] must be mounted in place of the cutter.
- For the product TANDEMBOX, no further processing is necessary for panel thicknesses up to 16 mm (5/8").

Set-up				Processing
	Depth stop [6]  	Wood stop [7]  	Support [5] 	Clamp work piece  Route work piece 
	M35.0035.01	M35.ZT01		

## Panel thickness

 **>16 - 19 mm (5/8" - 3/4")**

For restrictions for Blum products with panel thickness greater than 16 (5/8") and up to 19 mm (3/4") – see page 46:

LEGRABOX

Selecting

Back [31]

Notch

Set-up

Cutter fittings

Stop bar [13]

**M35.ZD19**

Drawer bottom [30]

**M35.ZD19**

TANDEMBOX

Selecting

Back [31]

Notch

Drawer bottom [30]

Set-up

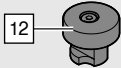

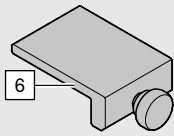

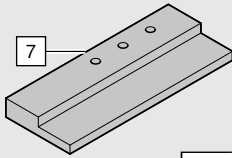


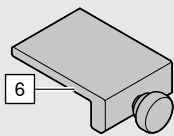

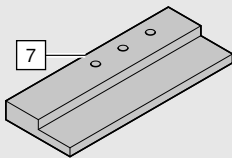



Cutter fittings

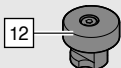

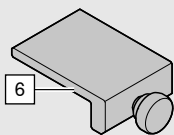

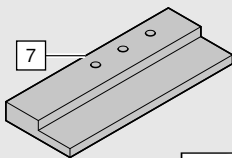


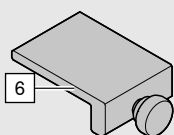

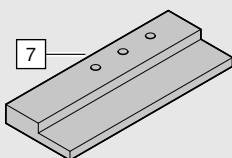



M35.ZD19

Stop bar [13]

M35.ZD19

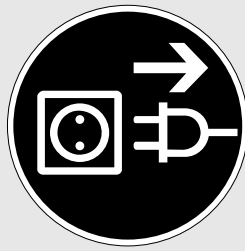
Depending on device type not part of the scope of delivery

Set-up				Processing
Support stop [12]	Depth stop [6]	Wood stop [7]	Support [5]	
 	 	 		Clamp work piece
<b>M35.ZD19</b>	<b>M35.0035.01</b>	<b>M35.ZT01</b>		
	 	 		Route work piece
	<b>M35.0035.01</b>	<b>M35.ZT01</b>		

Set-up				Processing
Support stop [12]	Depth stop [6]	Wood stop [7]	Support [5]	
 	 	 		Clamp work piece
<b>M35.ZD19</b>	<b>M35.0035.01</b>	<b>M35.ZT01</b>		
	 	 		Route work piece
	<b>M35.0035.01</b>	<b>M35.ZT01</b>		

In scope of delivery

## F – Set-up



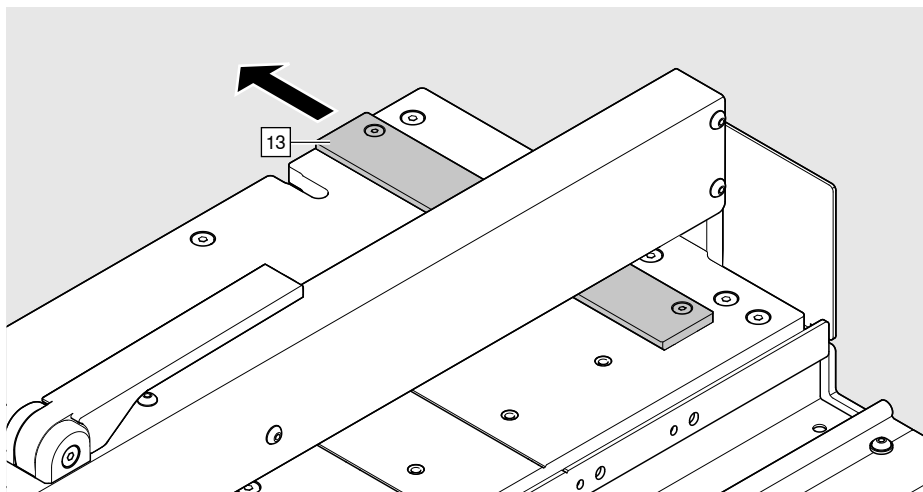
### WARNING

**Serious cuts.**

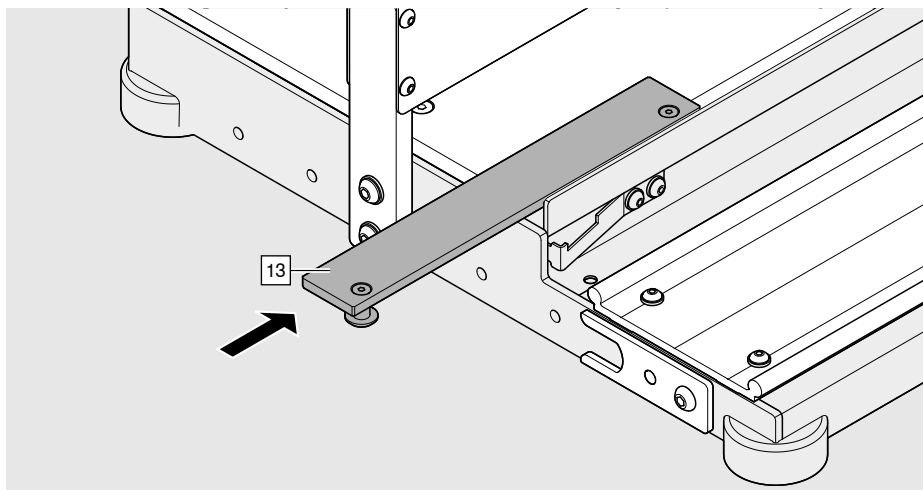
**Failure to heed this warning may result in personal injury.**

- The bottom router must be disconnected from the power supply.

**Stop bar [13]**  
(optional accessory  
Part number: M35.ZD19)

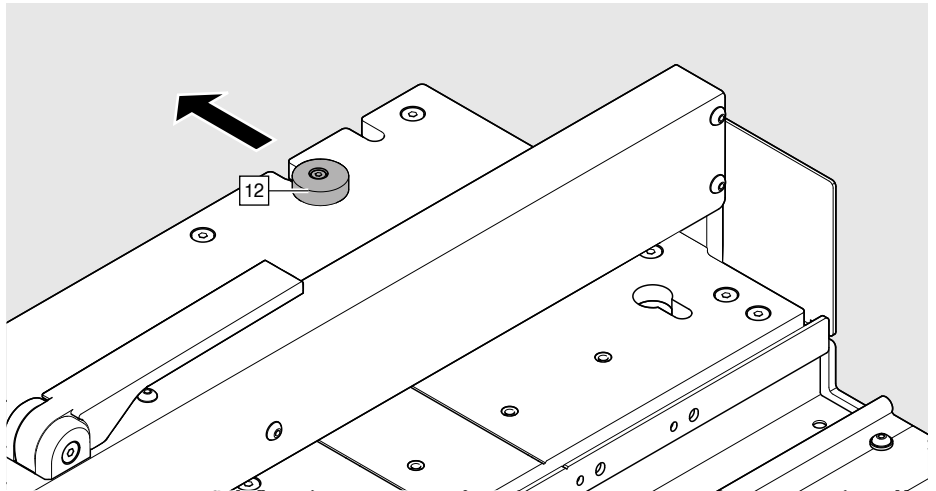


- Remove the stop bar [13] from the parked position.

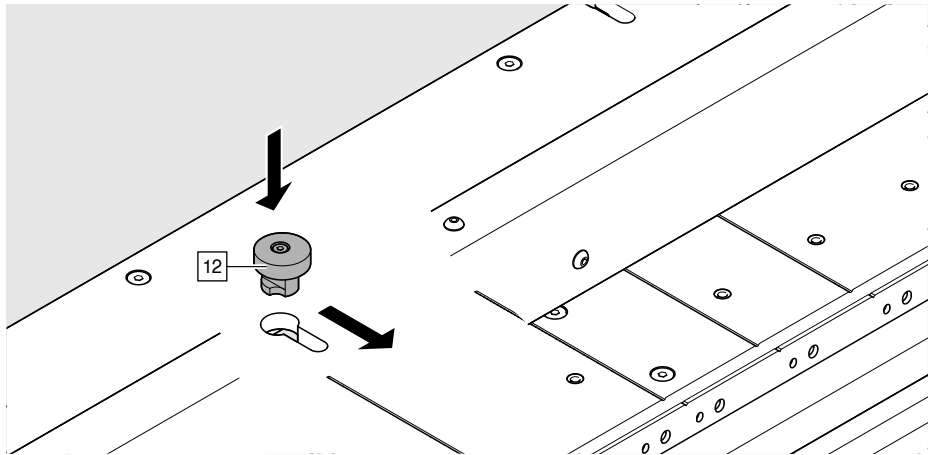


- Push the stop bar [13] into the runner of the bottom router.

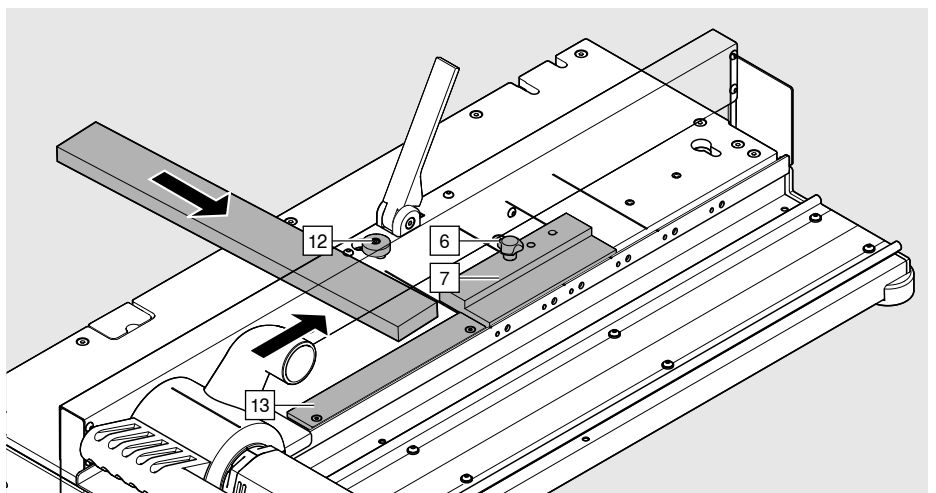
**Support stop [12]**  
 (optional accessory  
 part number: M35.ZD19)



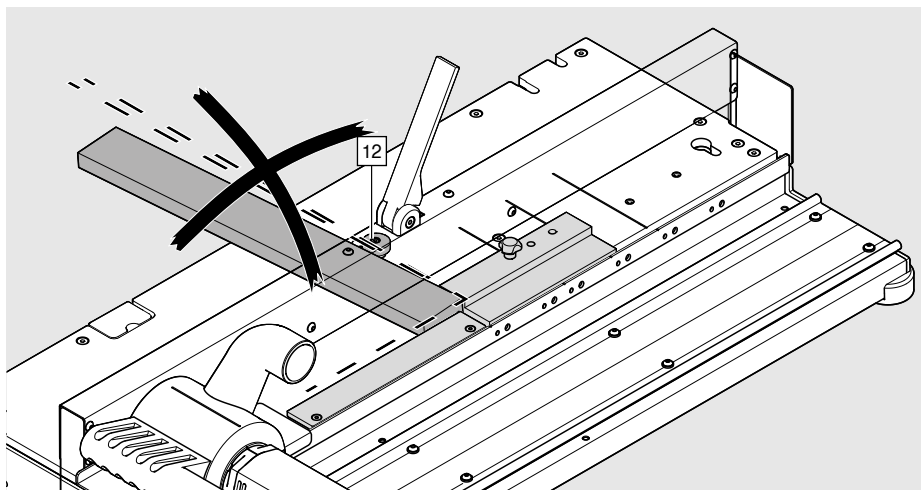
- Remove the support stop [12] from the parked position.



- Mount the support stop [12] in the working position.



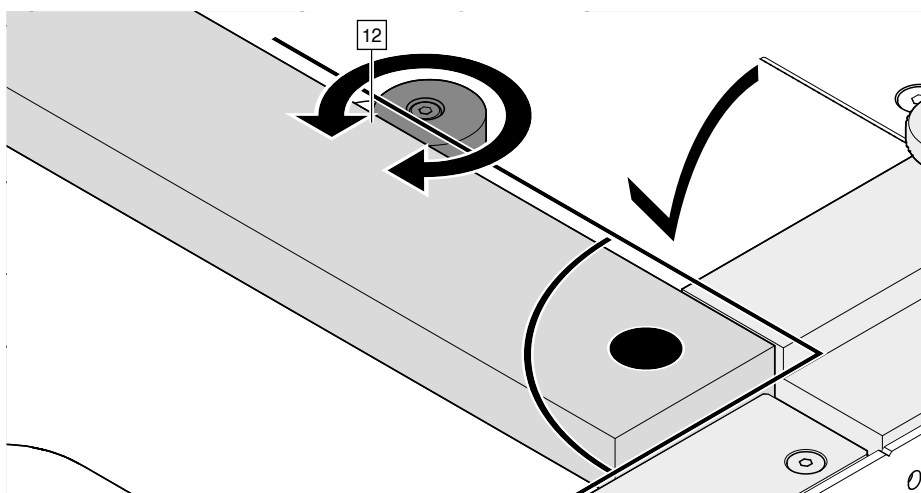
- Mount the depth stop [6] or wood stop [7] in the furthest forward position. See page 25.
- Push the work piece to the support stop [12], stop bar [13] and depth stop [6] or wood stop [7].



The support stop [12] must be aligned.

- Check whether a right angle is present.

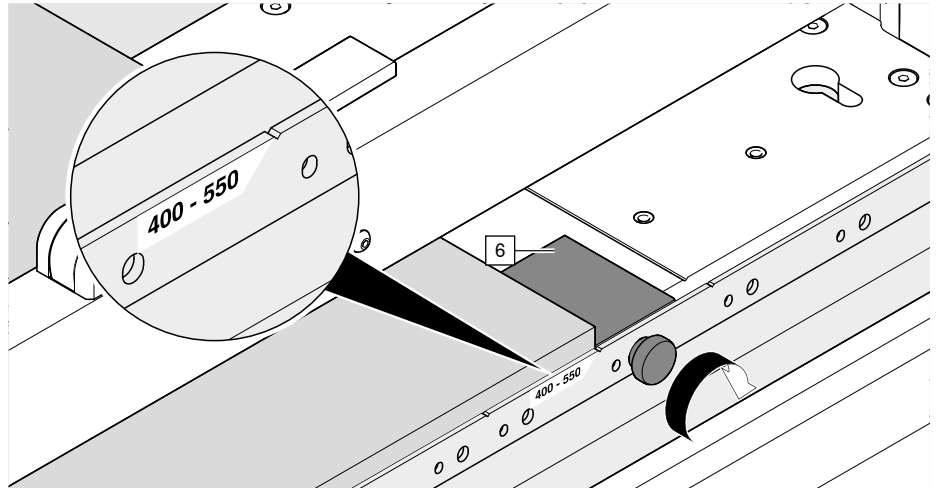
If there is no right angle, proceed as follows:



- Loosen the screw of the support stop [12].
- Rotate the support stop [12] until a right angle is formed.
- Screw the support stop [12] into place.

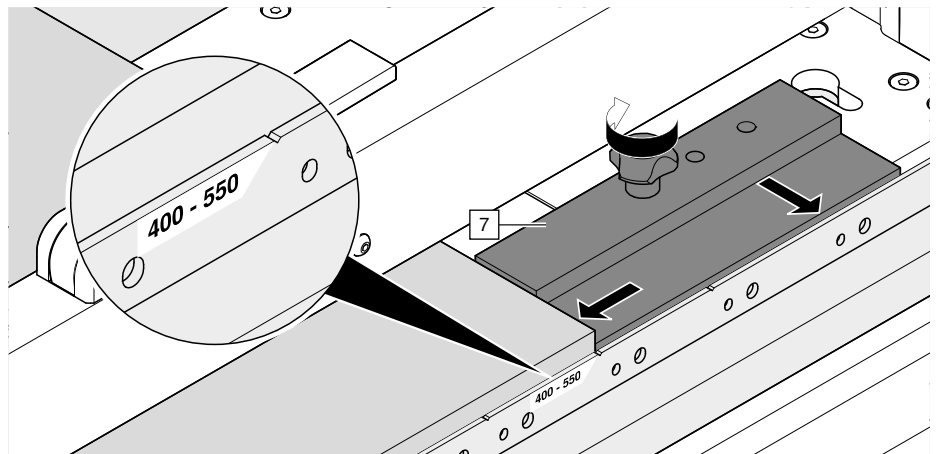


### Positioning the depth stop [6]



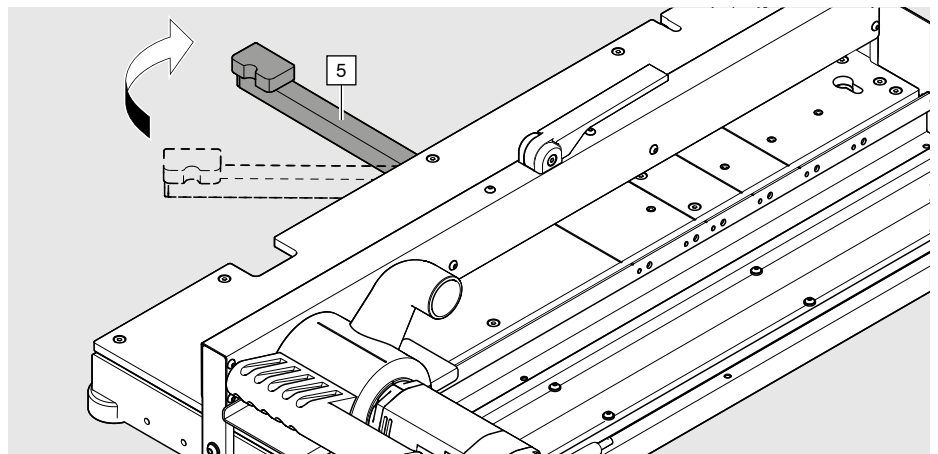
- Mount the depth stop [6] in accordance with the drawer nominal length.
- When processing the back [31], the depth stop [6] must always be mounted in the furthest forward position.

### Positioning the wood stop [7]



- Mount the wood stop [7] in accordance with the drawer nominal length.
- When processing the back [31], the wood stop [7] must always be mounted in the furthest forward position.

### Support [5]



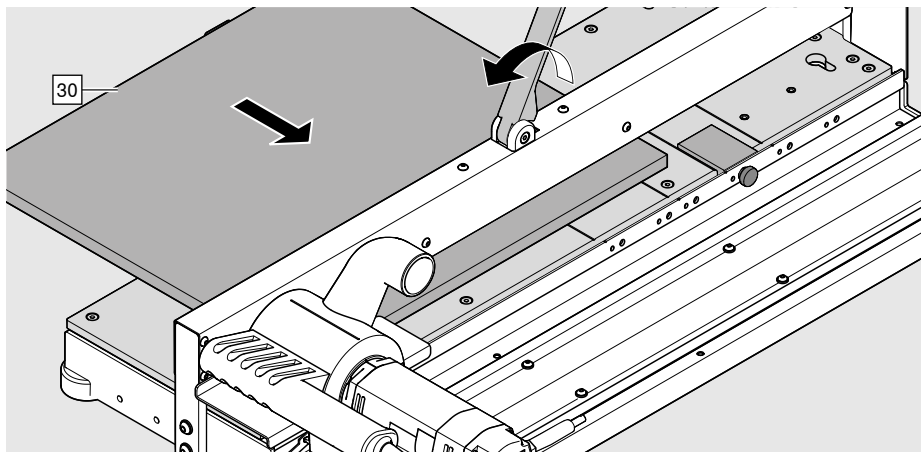
- Drawer bottom width 500 mm (19 11/16"): swivel out the support [5].
- Swivel out the support [5] until the stop (right angle).

## G – Clamping the work piece

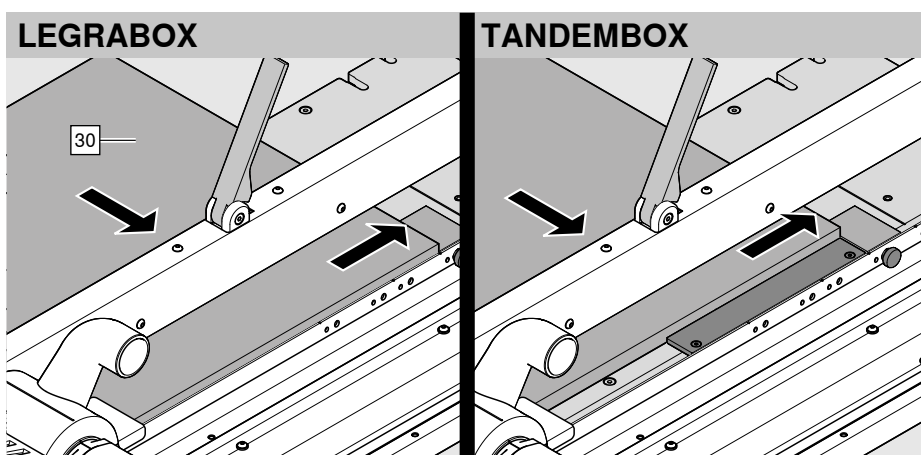
### i NOTE

- There should be no wood chips on the work top [4] and stop surface as they can affect the accuracy of the notch or damage the surface of the work piece.

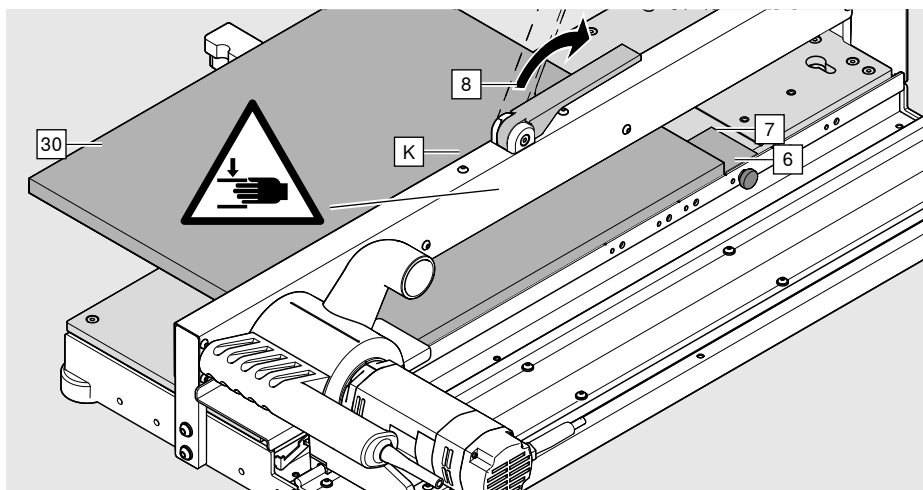
### Clamping the drawer bottom [30]



- Lay the drawer bottom [30] on the bottom router, as shown.



- Push the drawer bottom [30] onto the stops, as shown.



#### CAUTION

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

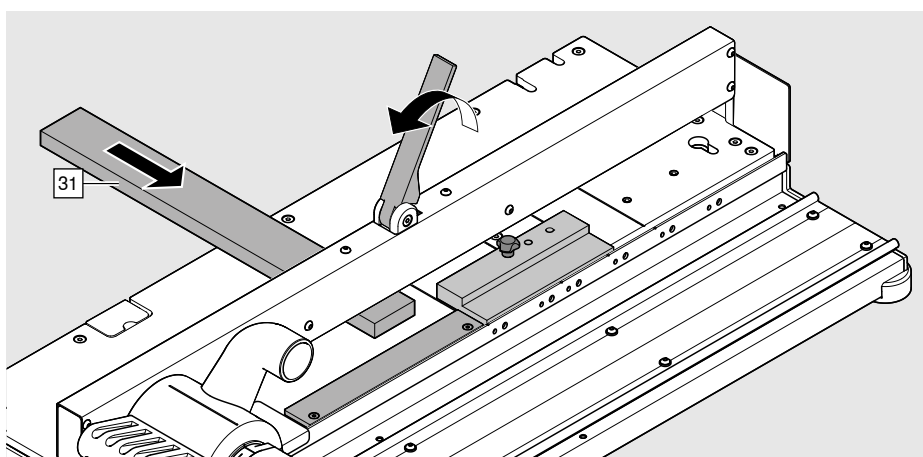
- Keep the drawer bottom [30] pressed down on stops [6] [7].
- Push down the clamping lever [8].
- Check again that the work piece is lying flat against the stops.

#### Clamping the back [31]

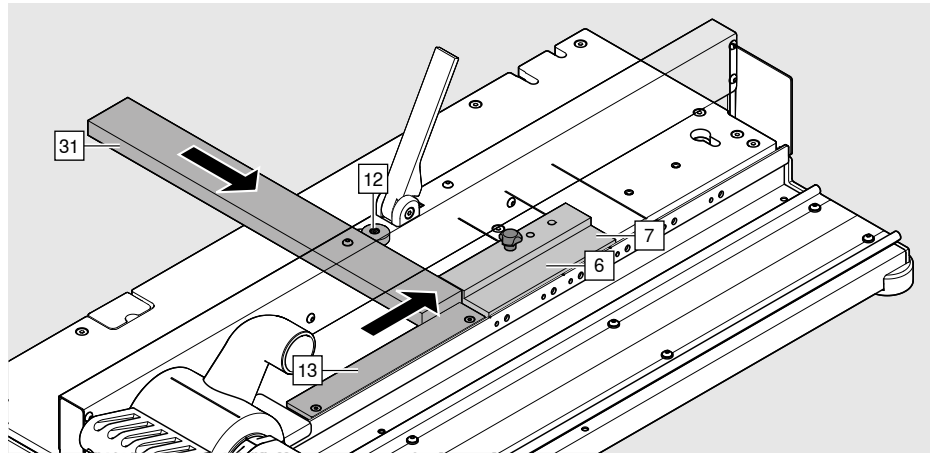


#### NOTE

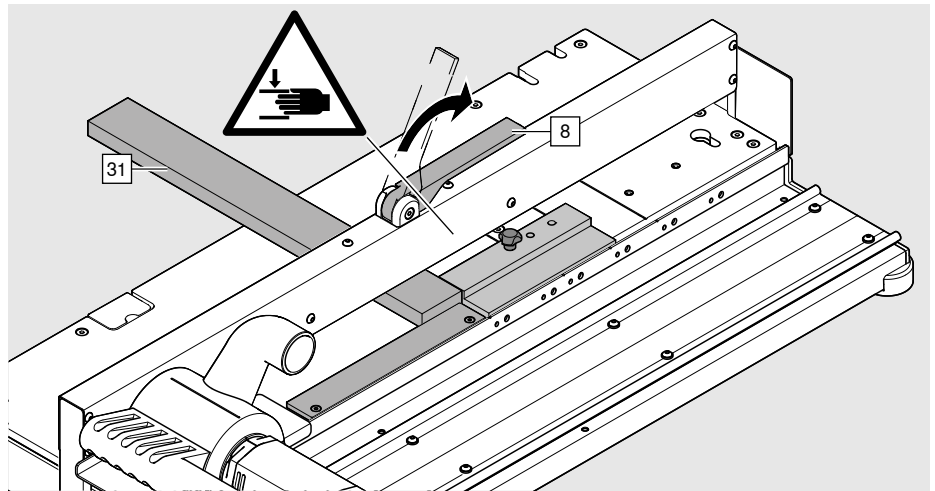
- There should be no wood chips on the work top [4] and stop surface as they can affect the accuracy of the notch or damage the surface of the work piece.



- Lay the back [31] on the bottom router, as shown.



- Push the back [31] onto the stop bar [13], support stop [12] and stops [6] [7], as shown.



#### CAUTION

- Keep your hands away from the clamp.

- Keep the work piece [31] pressed against the stops.
- Push down the clamping lever [8].
- Check again that the work piece is lying flat against the stops.

## H – Routing the work piece

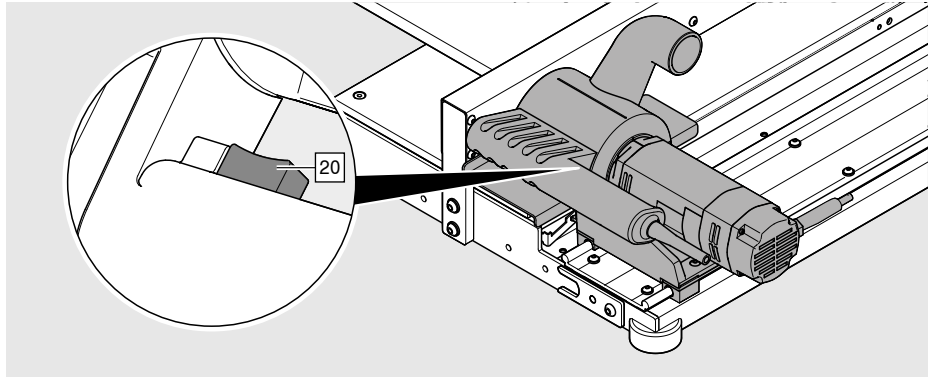
### Routing the drawer bottom

- Switch on the dust extraction system.



#### NOTE

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



#### WARNING

**Cutting tools can cause serious injury.**

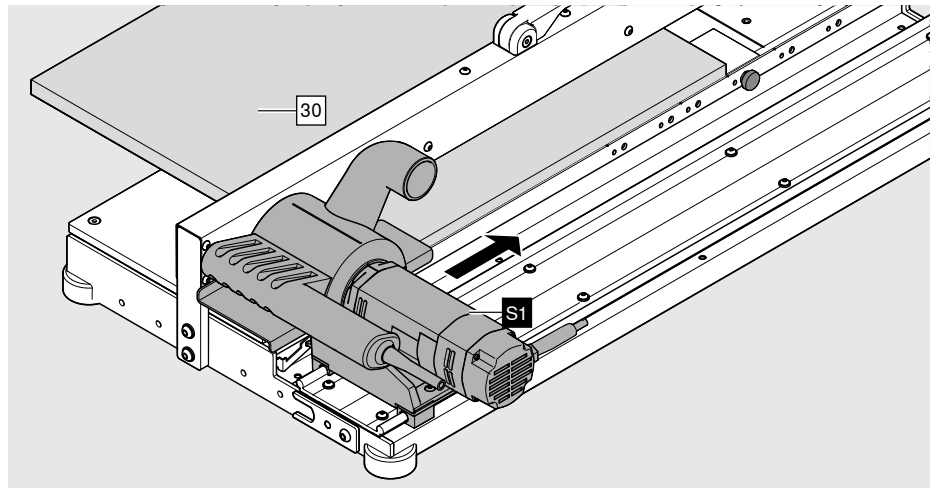
- No more than one operator may use the bottom router at a time.
- Wear eye protection.
- Wear ear protection.

- Press the rocker switch [20].

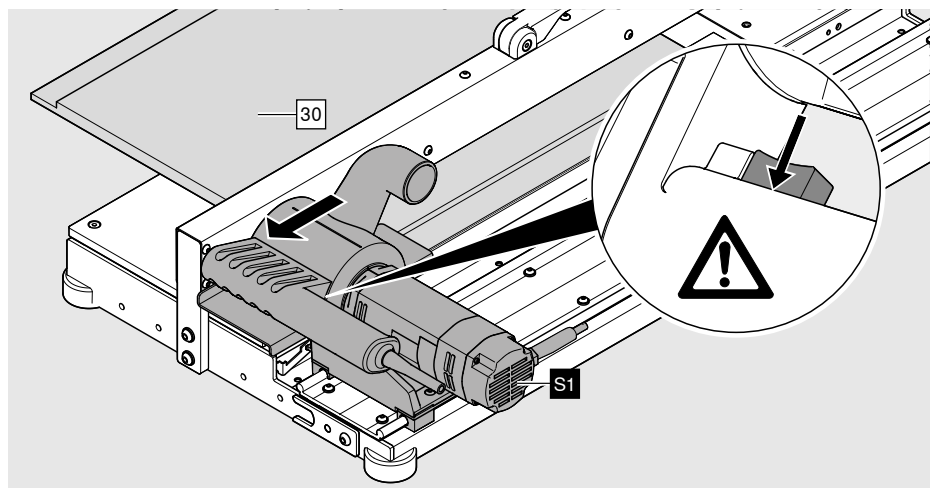


#### NOTE

- 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.
- In the event of overheating due to overload, the motor will be switched off by the temperature monitoring. After a cooling phase the motor can be operated again.



- Push the carriage [S] gently into the drawer bottom [30].
- At the end of the drawer bottom [30], gently draw the carriage out from the material.



#### **i** NOTE

- Never turn off the motor during the routing and return process. This could damage the motor or the notch cutter [23].

- Return the slide [S1] to its starting position when the motor is switched on.
- Leave the rocker switch [20] in the starting position.

#### **i** NOTE

- When the rocker switch is released, the milling cutter continues to run for a time. Wait for the milling cutter to come to a standstill under all circumstances.

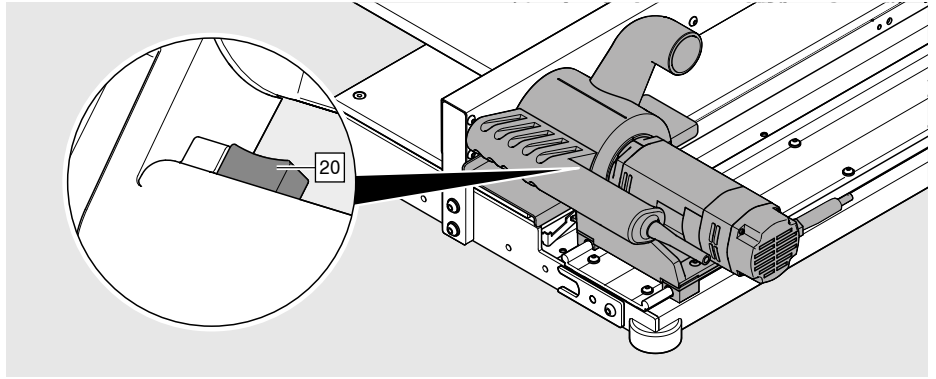
- For the second notch, repeat the work processes from 'Clamp workpiece'.
- Switch off extraction system.

## Routing the back [31]

- Switch on the dust extraction system.

### **i** NOTE

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



### WARNING

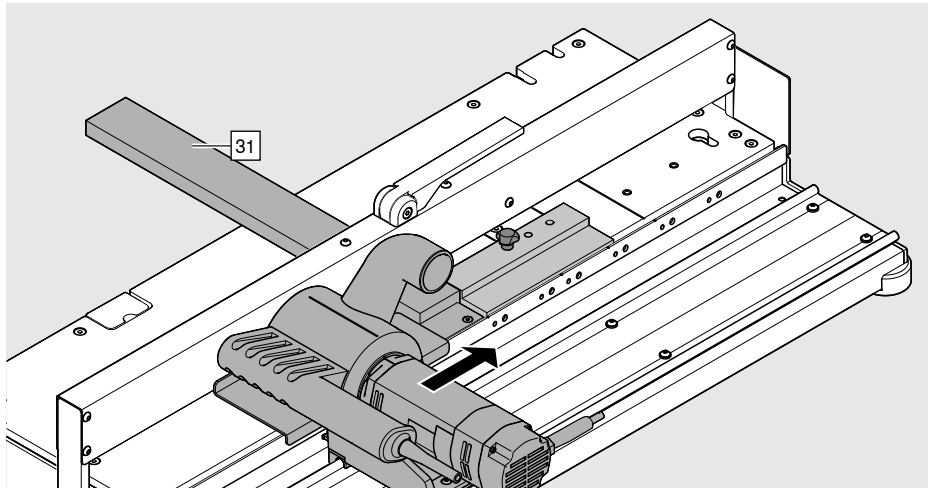
**Cutting tools can cause serious injury.**

- No more than one operator may use the bottom router at a time.
- Wear eye protection.
- Wear ear protection.

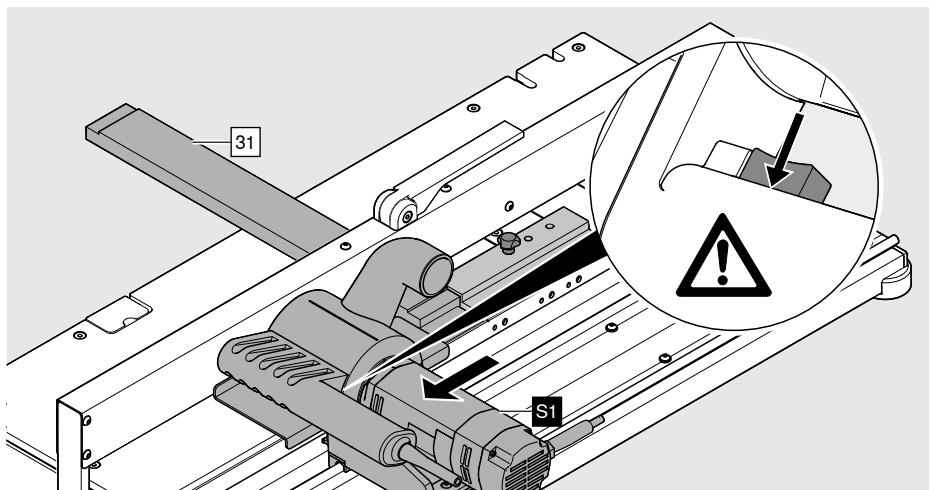
- Press the rocker switch [20].

### **i** 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.
- In the event of overheating due to overload, the motor will be switched off by the temperature monitoring. After a cooling phase the motor can be operated again.



- Push the carriage [S1] gently into the back [31].
- At the end of the back [31], gently draw the carriage out from the material.



#### **i** NOTE

- Never turn off the motor during the routing and return process. This could damage the motor or the notch cutter [23].

- Return the slide [S1] to its starting position when the motor is switched on.
- Leave the rocker switch [20] in the starting position.

#### **i** NOTE

- When the rocker switch is released, the milling cutter continues to run for a time. Wait for the milling cutter to come to a standstill under all circumstances.

- For the second notch, repeat the work processes from 'Clamp workpiece'.
- Switch off extraction system.

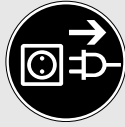


## I – Maintenance

### Everyday cleaning



#### WARNING



##### Serious cuts.

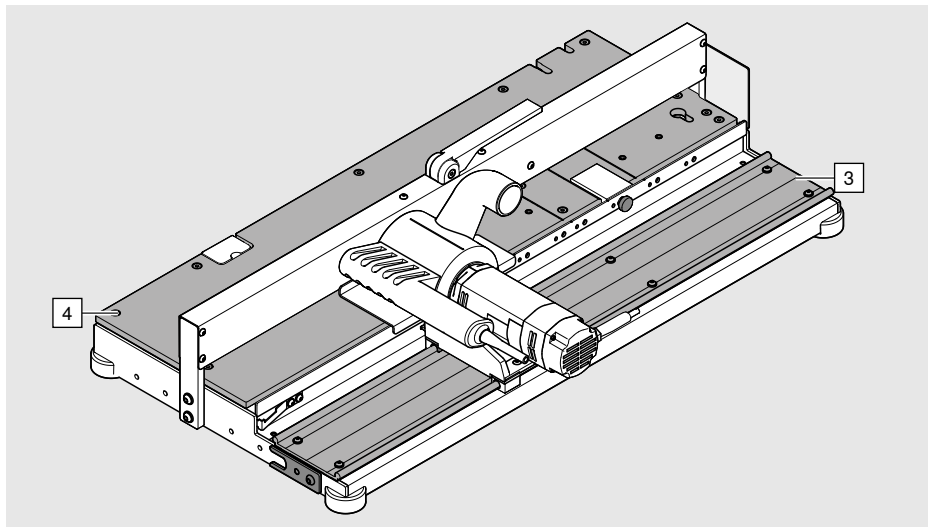
Failure to heed this warning may result in personal injury.

- The bottom router 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.

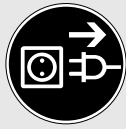
- Keep the motor ventilation slots free of dust and wood chips.
- Clean the depth stop and lateral stop.
- Clean the runner [3] using a dry cloth.
- Clean the work top [4] using compressed air.

## Removing the motor

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



### WARNING



#### Serious cuts.

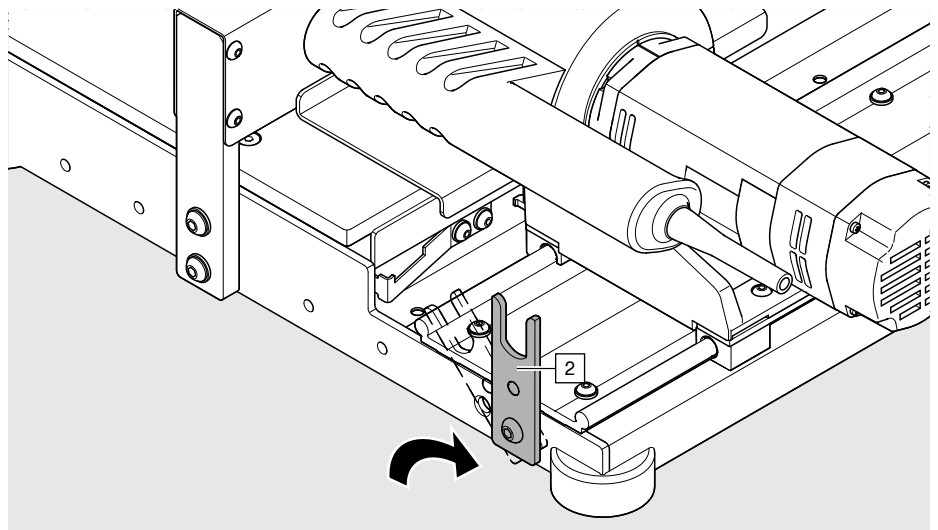
**Failure to heed this warning may result in personal injury.**

- The bottom router must be disconnected from the power supply before cleaning and maintenance.

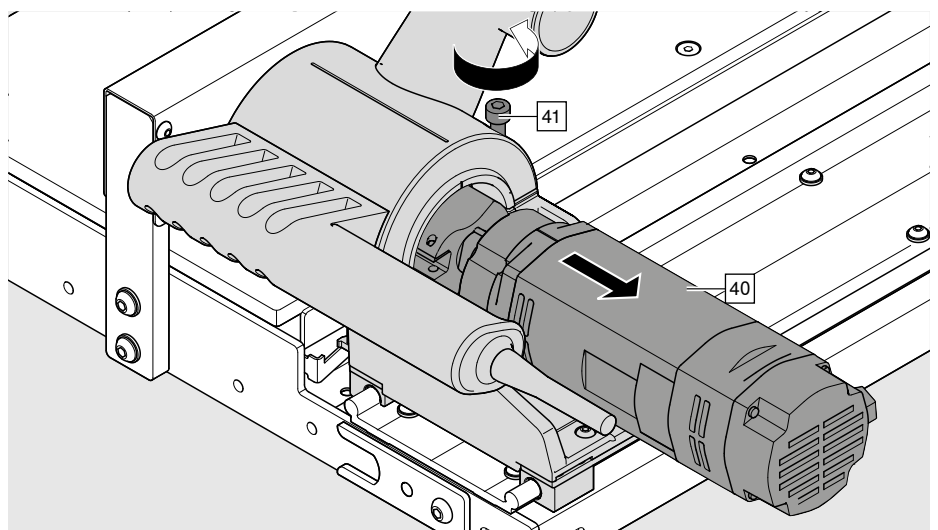


### NOTE

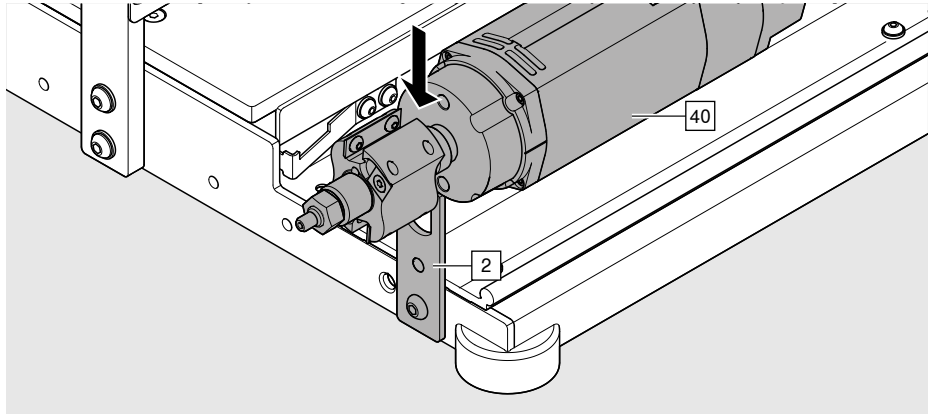
- Gloves must always be worn when cleaning the cutter [23].



- Swivel the shaft holder [2] by 90 degrees.

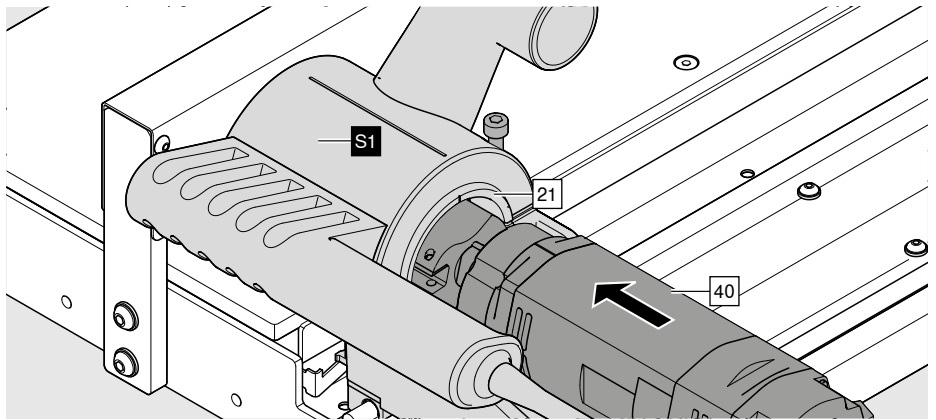


- Loosen the screw [41] with an SW 6 hex key.  
1/4 rotation – 90°
- Carefully remove the motor [40]. Damage to the cutting inserts is possible.

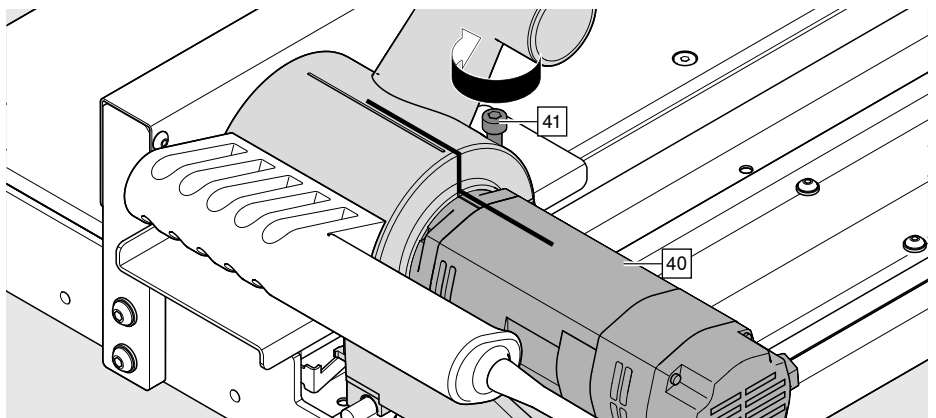


- Place the motor [40] in the shaft holder [2].

### Installing the motor



- All the fixing and clamping surfaces [21] on the carriage [S1] and motor [40] must be free of dust and wood chips.
- Push the motor carefully on to the flange surface [21]. Damage to the cutting inserts is possible.



### **i** NOTE

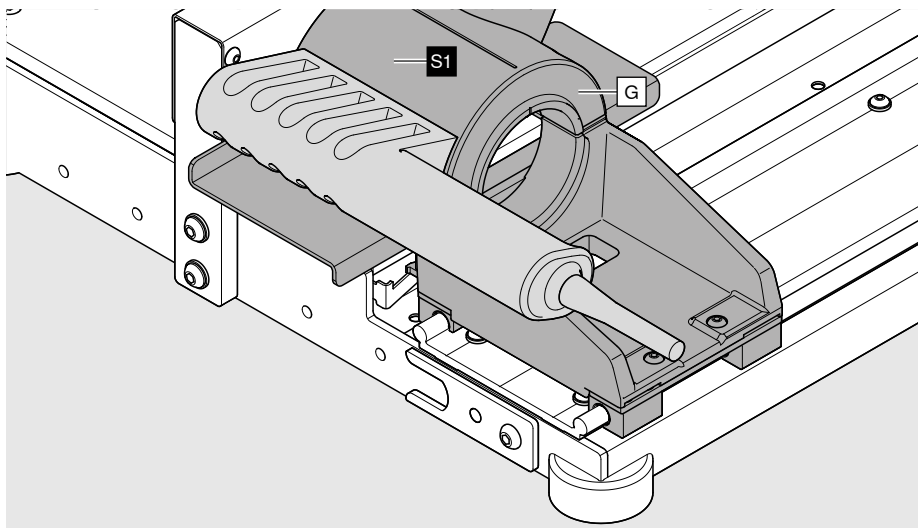
- Pay attention to the motor position. The motor's ventilation slot [40] must not be covered. Risk of overheating.

- Turn the motor [40] to the correct position.
- Tighten screw [41].

## Cleaning the housing

If the housing [G] of the carriage [S1] is filled with wood chips or if the cutter is blocked, proceed as follows:

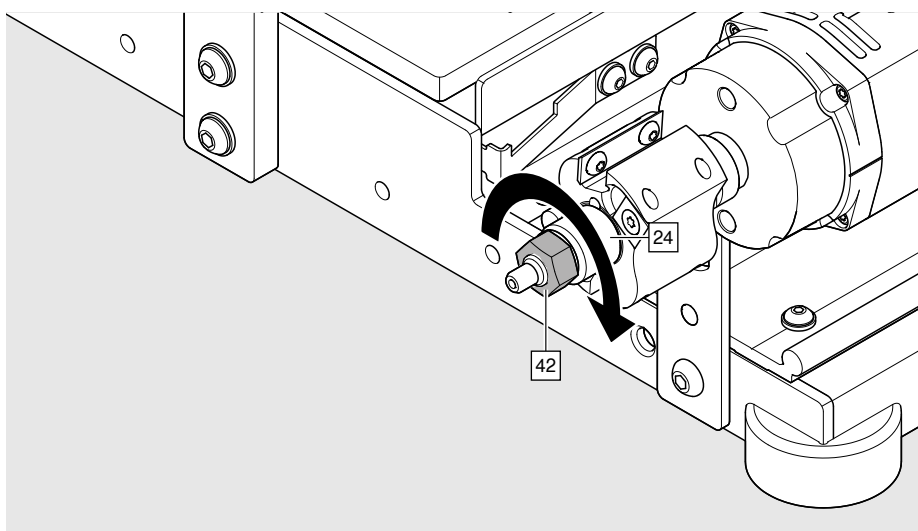
### Removing and installing the motor



- Remove the wood chips from the housing [G].

## Installing/removing the cutter

### Removing and installing the motor



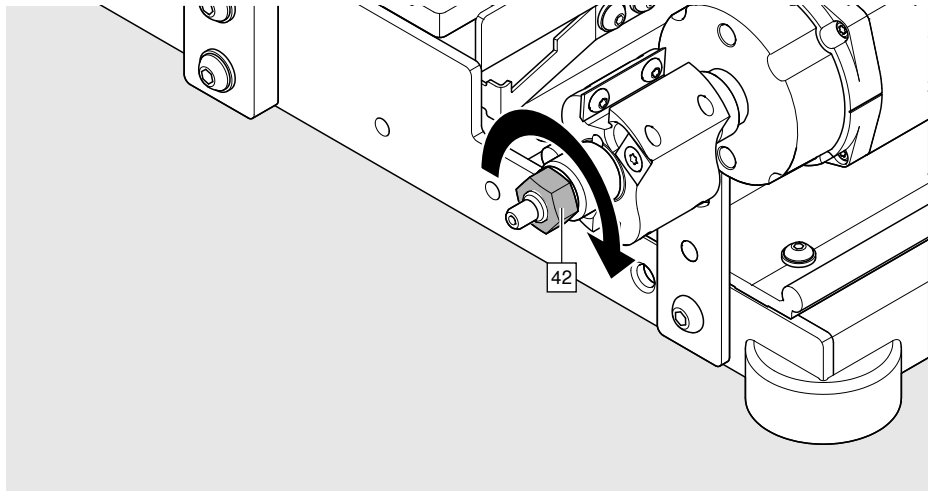
- Turn the nut [42] clockwise using the IM spanner.

### **i** NOTE

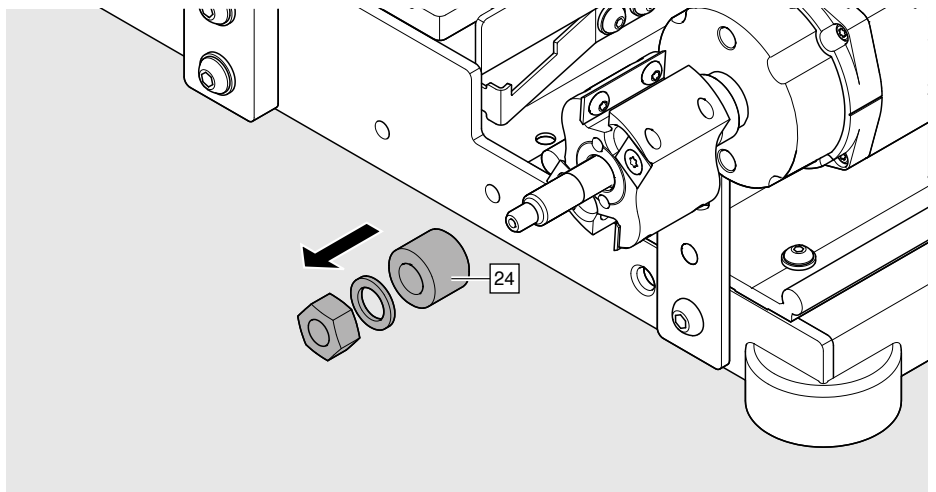
- The thread on the motor shaft is a left hand thread.

**Retrofitting cutter DM 44 [14]  
(optional accessory  
Part number: M35.ZD19)**

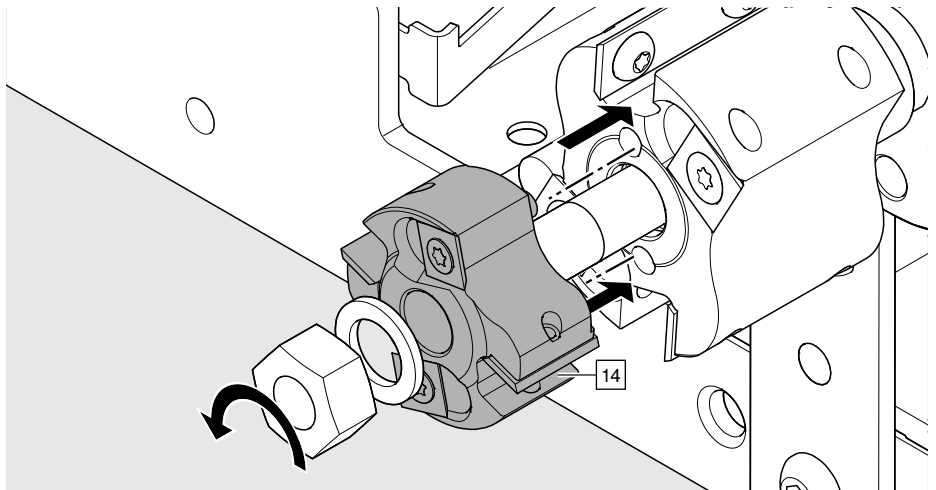
Removing and installing the motor



- Turn the nut [42] clockwise using the IM spanner.



- Remove the spacer sleeve [24].



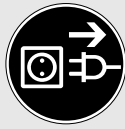
- Mount the cutter DM 44 [14].

## Changing the cutting inserts

Removing and installing the motor



### WARNING



#### Serious cuts.

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

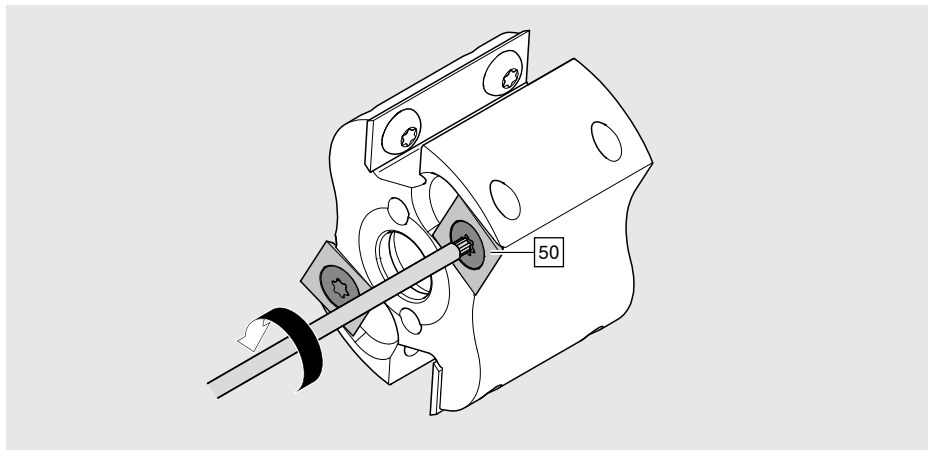
- The bottom router must be disconnected from the power supply before cleaning and maintenance.
- Wear gloves.



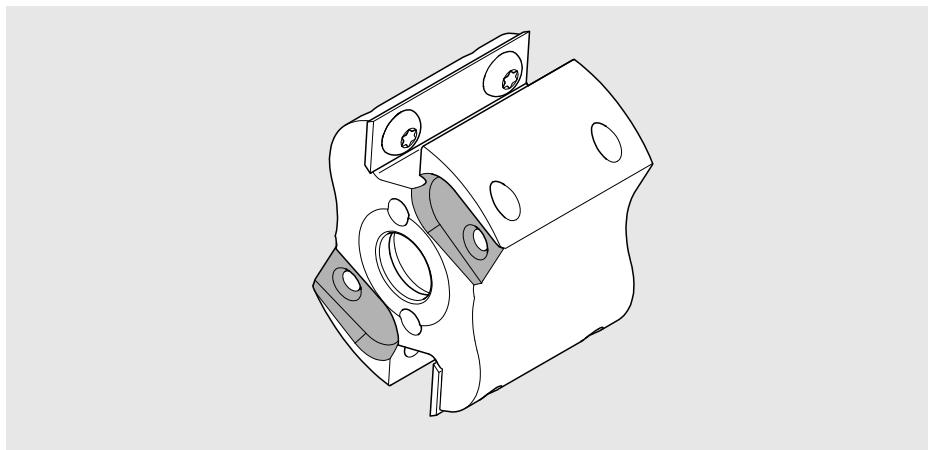
### NOTE

- The blades should be changed in the following sequence:  
Whenever the pre-cutters [50] are turned for the second time, the cutting inserts [51] should also be turned. The pre-cutter [50] has the highest load.
- Sharp blades significantly extend the service life of the motor.
- For spare parts, see page 43.

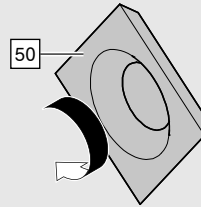
Changing the pre-cutter [50].



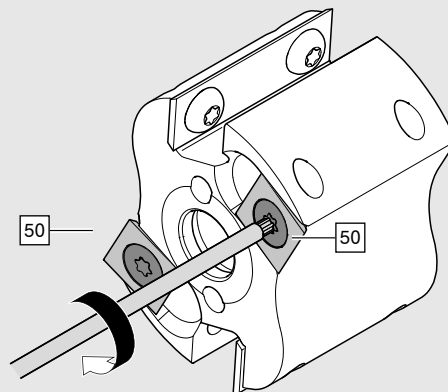
- Loosen the pre-cutter screw [50] by turning it counter clockwise.



- Clean the base of the pre-cutter [50] using a dry cloth.



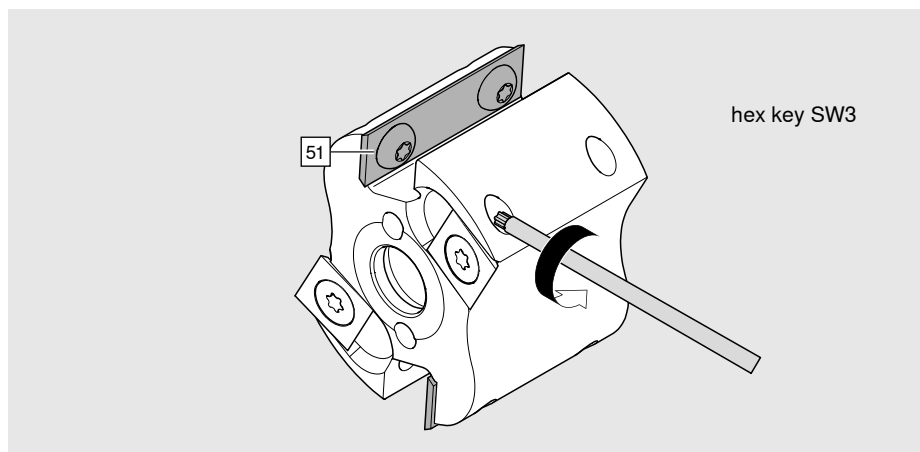
- Clean the pre-cutter [50] using a dry cloth.
- Turn the pre-cutter [50] 90 degrees.



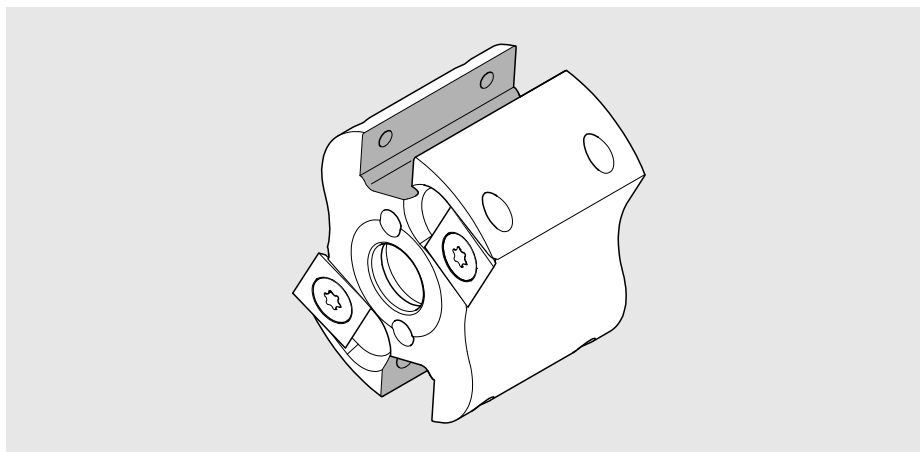
- Tighten the screw in the pre-cutter [50] by turning it clockwise.

**i** NOTE

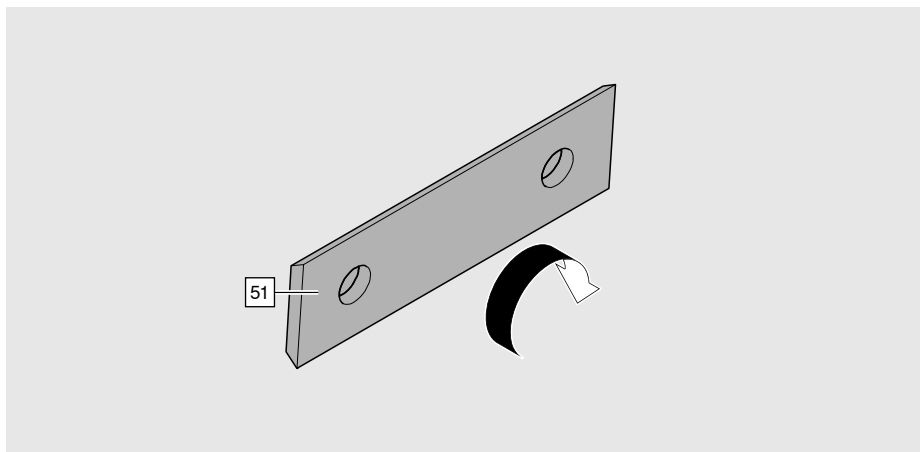
- Only the TORX® key provided may be used.



- Loosen the screw for the cutting insert [51] by turning it counter clockwise.

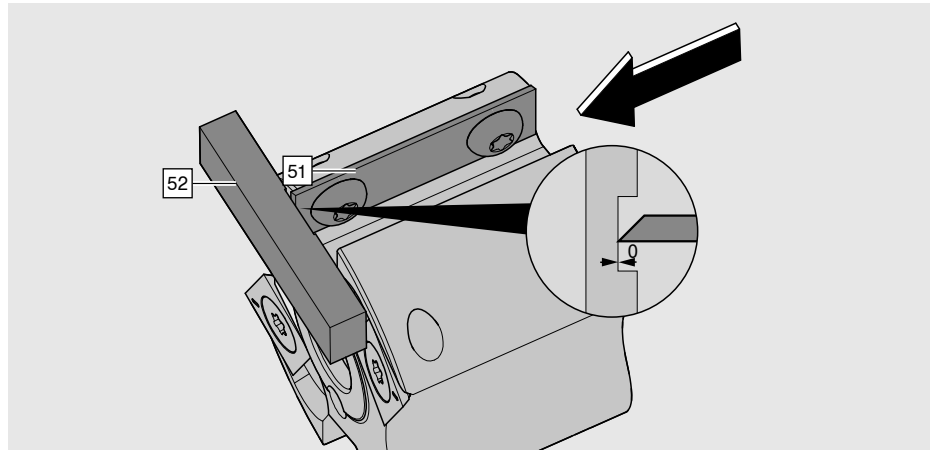


- Clean the base of the cutting inserts [51] using a dry cloth.

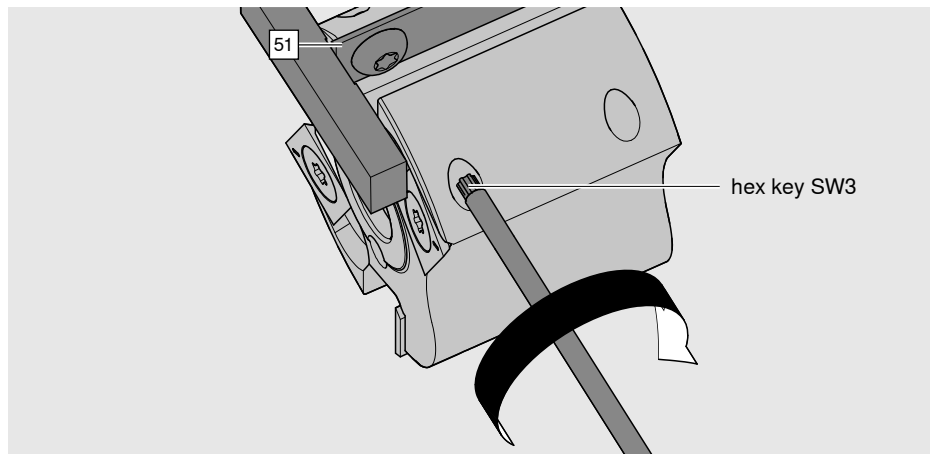


- Turn the cutting insert [51] 180 degrees.





- Position the cutting insert [51] using the setting gauge [52].



- Tighten the screw for the cutting insert [51] by turning it clockwise.

#### **i** NOTE

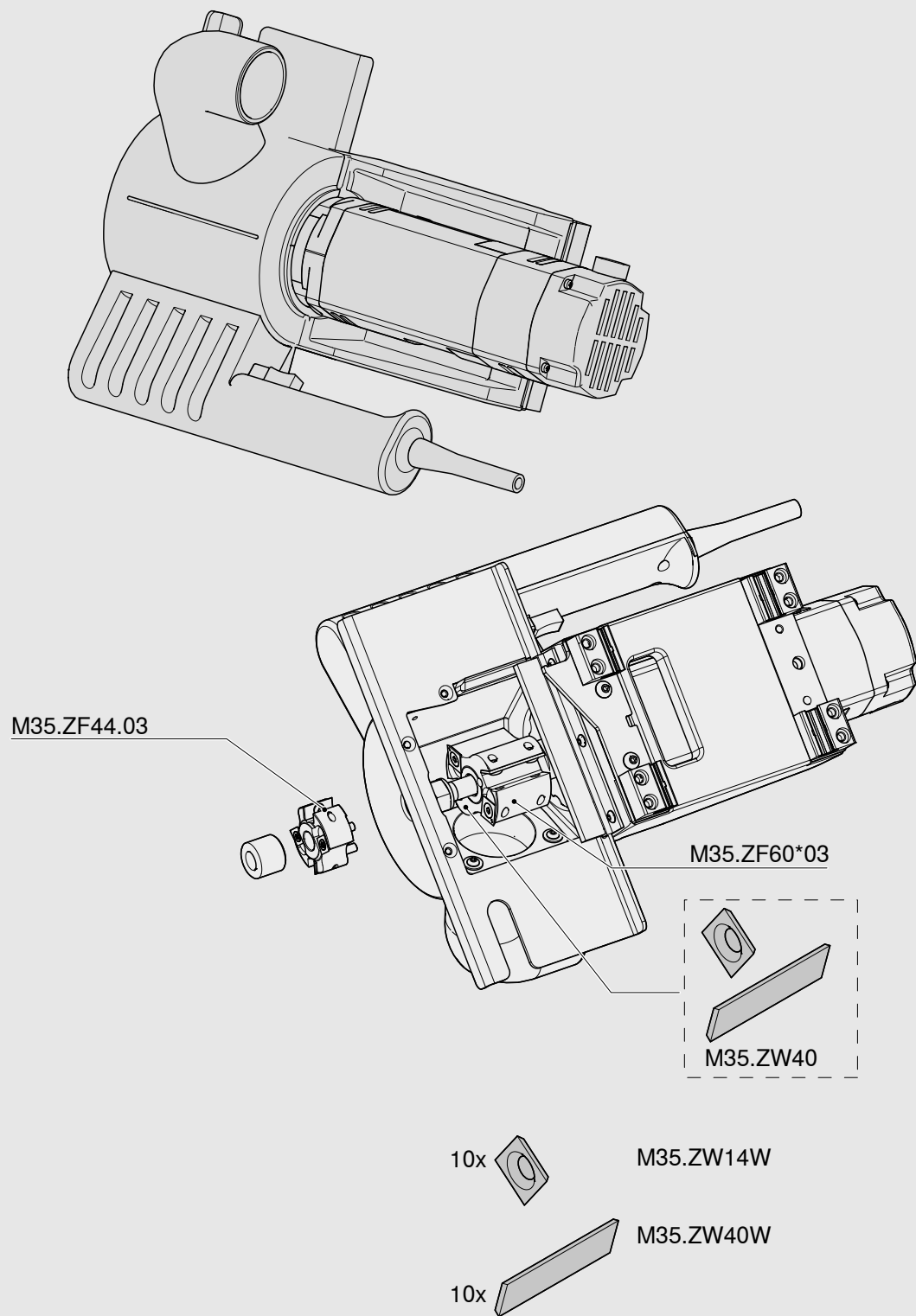
- After all four pre-cutter positions have become worn, the entire set consisting of pre-cutters [50] and cutting inserts [51] must be replaced.

## J – Troubleshooting

<b>Fault</b>	<b>Possible cause</b>	<b>Remedy</b>
Incorrect notch dimensions	Work piece not clamped correctly	➤ See page 26
	Dirty stops	➤ See page 33
	Dirty work top	➤ See page 33
	Work piece is not flat against the support	➤ See page 25
	Cutter worn out	➤ See page 38
	Cutting inserts not correctly mounted	➤ See page 38
Notch edges are torn	Cutter worn out	➤ See page 38
	Rear stop missing, wood stop worn	➤ See page 25
	Feed too fast	➤ See page 29
Strong vibrations on bottom router	Bottom router not clamped	➤ See page 11
	Work piece not clamped	➤ See page 26
Strong vibrations on the motor	Incorrect material	➤ See page 3
	Cutter not screwed tightly	➤ See page 36
	Motor in the carriage not correctly clamped	➤ See page 35
	Cutting inserts not screwed tightly	➤ See page 38
	Not all the cutting inserts have been installed	➤ See page 38
	Damaged cutting inserts	➤ See page 38
Motor overheated	Feed too fast	➤ See page 29
	Cutter worn out	➤ See page 38
	Motor ventilation slots are blocked	➤ See page 33
	Carbon brush worn	➤ See MA-709
Motor temporarily cuts out	Overheating due to overloading	➤ See page 29
	Carbon brush worn	➤ Spare part M35.ZM01

## K - Spare parts

When ordering spare parts, state the year of construction and serial number.



## L – Bottom router set

Bottom router	M35.7200.NA
Cutter	M35.ZF0-60.03 FRAE-KO
Dust extraction socket	M51N0603 TRI+ZUT
Spanner 19	
Allen key 6	

## Disposal

- Dispose of all mechanical components of the bottom router in accordance with local regulations.
- Dispose of all electrical components of the bottom router in a separate collection for electrical and electronic appliances as per local regulations.

**Technical data**

Only use in dry, enclosed rooms.

**Dimensions/weight:**

Height: \_\_\_\_\_ 250 mm (9 7/8")

Width: \_\_\_\_\_ 580 mm (22 7/8")

Depth: \_\_\_\_\_ 990 mm (39")

Weight: \_\_\_\_\_ 29 kg (64lb)

**Energy:**

Voltage: \_\_\_\_\_ 1x 230–240 V 50–60 Hz

Power: \_\_\_\_\_ 1050 W

**Sound:**Emission – Sound pressure level (LA<sub>eq</sub>): \_\_\_\_\_ 92 dB(A)

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

**Temperature:**

Operation: \_\_\_\_\_ 5–40°C / 41 °F - 104 °F

Storage: \_\_\_\_\_ -20–70°C / -4 °F - 158 °F








**Work piece:**

Nominal length of drawer bottom: \_\_\_\_\_ 270–650 mm (10 5/8" - 25 19/32")

Cabinet width: \_\_\_\_\_ 275–1200 mm (10 53/64" - 47 1/4")

Panel thickness: \_\_\_\_\_ 15–19 mm (9/16" - 3/4")

**Serial tag**

<b>FALZFRAESE</b>			
Ser. No.: <b>MC 12345</b>		2021	
1X230 V 50/60 Hz 1,8 kW 8,5 A		 	
31 kg / 68 lbs   16000 1/min			
<b>Boden - Falzgeraet</b>		   	
Ref. No.: <b>M35.7200.NA</b>			
Julius Blum GmbH / Industriestrasse 1 A-6973 Hoechst / Made in Austria			

Device type: Bottom router

## Panel thickness limitations >16 mm (5/8") –19 mm (3/4")

For TANDEMBOX and LEGRABOX, Blum recommends using a panel thickness of 16 mm for back and bottom. The following limitations are to be taken into account when using thicker panel material (up to 19 mm).

### LEGRABOX limitations:

Back with >16 (5/8") to 19 mm (3/4")

- With SERVO-DRIVE, the drilling positions and space requirement have to be adjusted.

Bottom with >16 (5/8") to 19 mm (3/4")

- Use of steel back only possible with additional notch at rear of drawer bottom.
- Use of front piece only possible with additional notch at front of drawer bottom.
- Use of side stabiliser only possible in combination with steel back.
- TIP-ON synchronisation can only be used with a panel width of up to 18 mm.
- With the front stabilizer, the drilling position and space requirement beneath need to be considered.
- Bottom/back drilling template (ZML.7000) cannot be used.

### TANDEMBOX limitations:

Back with >16 (5/8") to 19 mm (3/4")

- With SERVO-DRIVE, the drilling positions and space requirement have to be adjusted.
- The side stabiliser installed at the rear cannot be used. (Side stabiliser installed at the top possible.)

Bottom with >16 (5/8") to 19 mm (3/4")

- Use of steel back only possible with additional notch at rear of drawer bottom.
- Use of front piece only possible with additional notch at front of drawer bottom.
- TIP-ON is not possible.
- Sink pull-out: notch for sink drawer side also necessary.
- With the front stabilizer, the drilling position and space requirement beneath need to be considered.

Notes

Blum partners worldwide can be found at:  
[www.blum.com/addresses](http://www.blum.com/addresses)

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System



**ISO 50001**  
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