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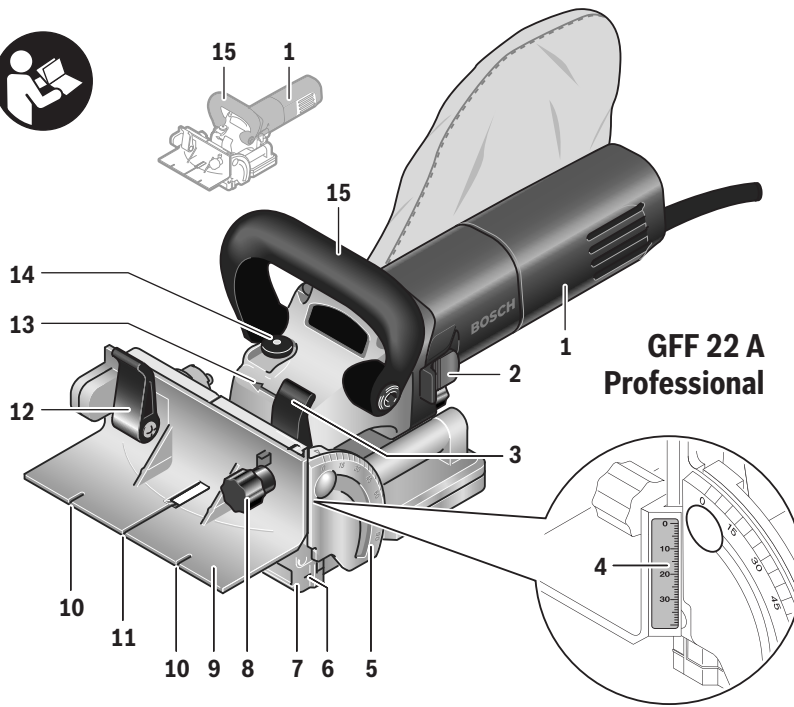
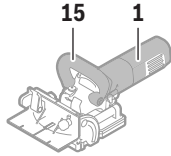
GFF 22 A Professional



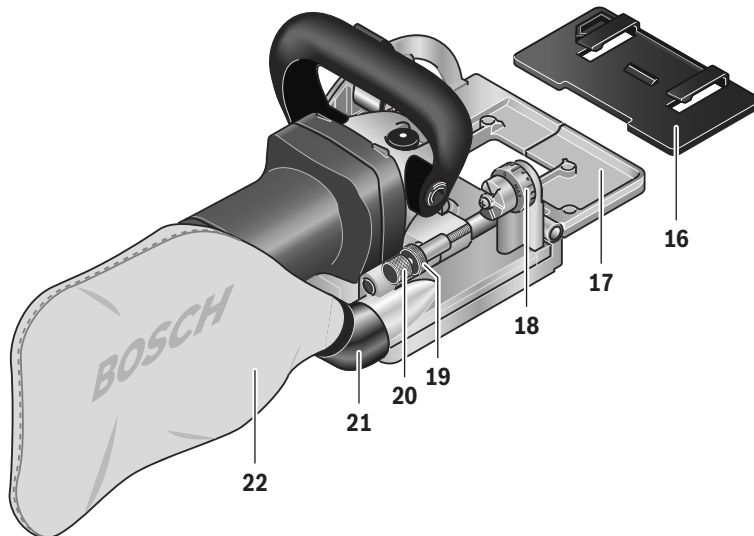
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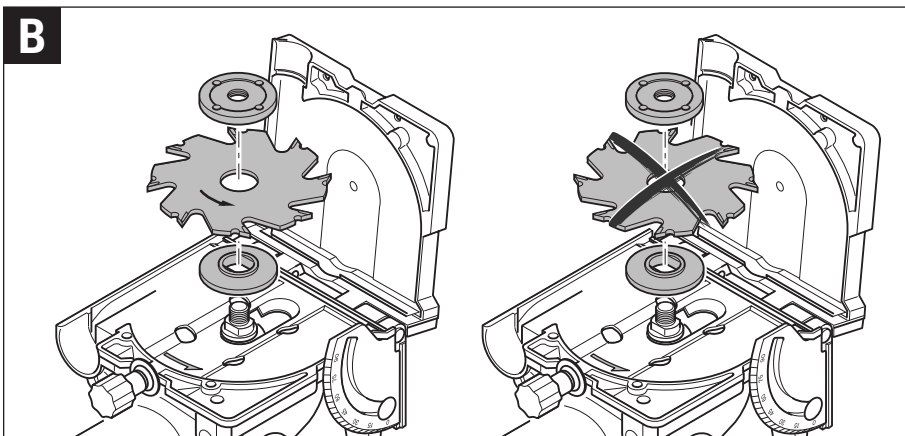
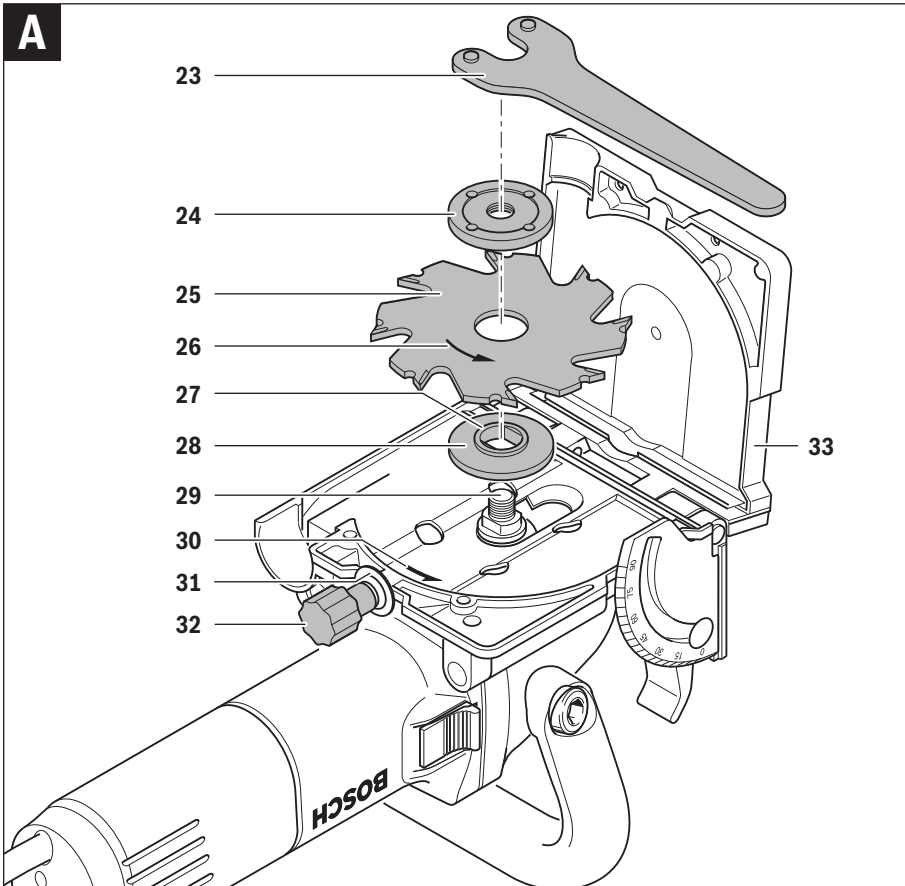


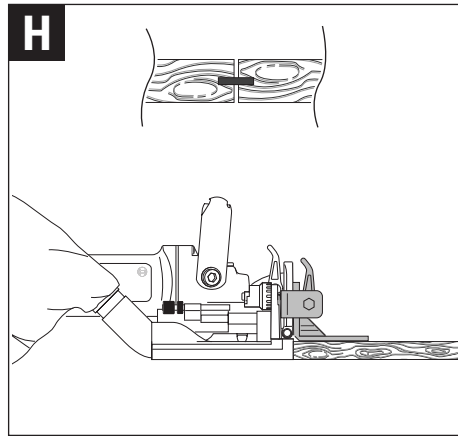
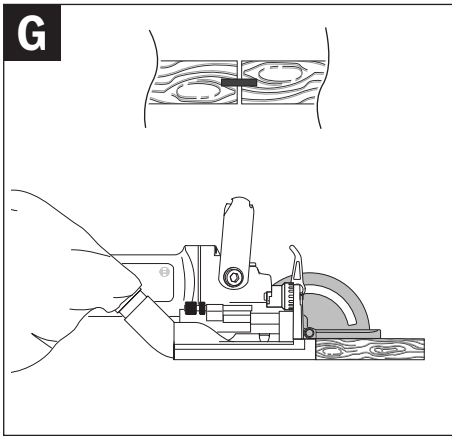
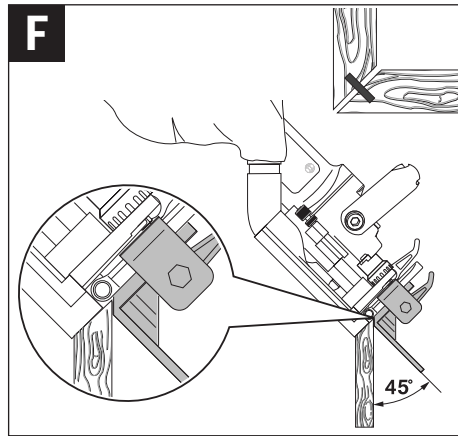
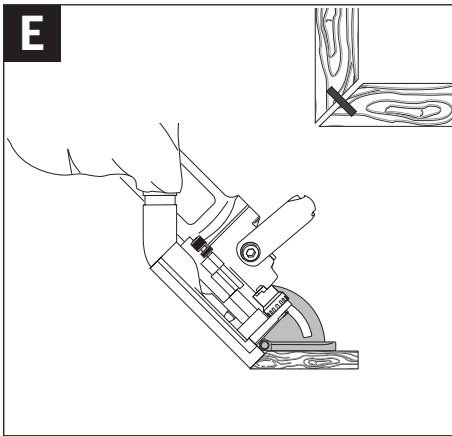
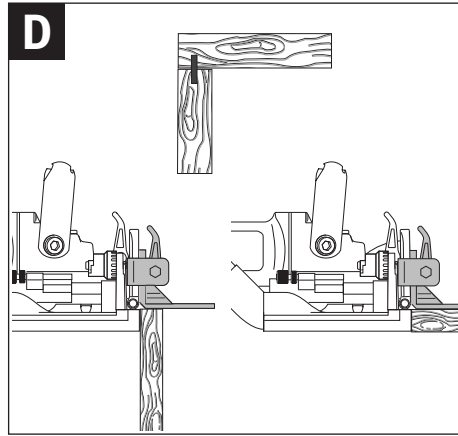
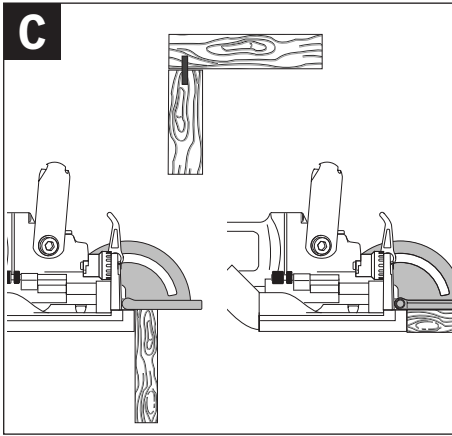
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Professional**



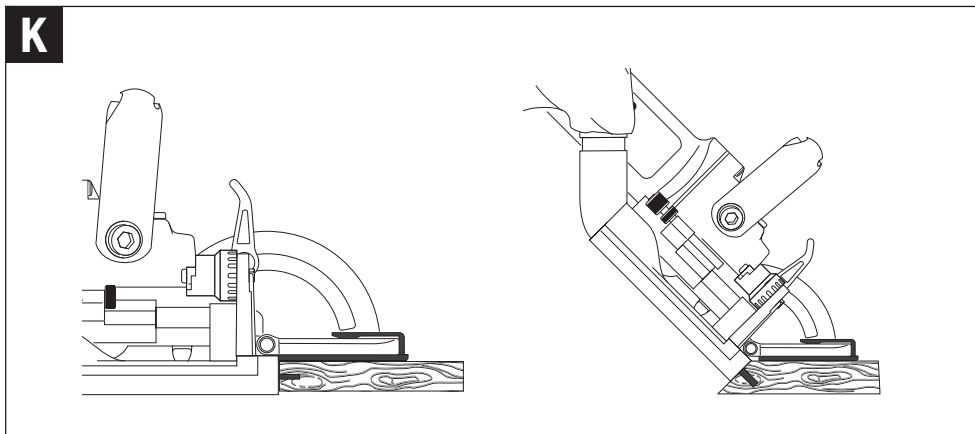
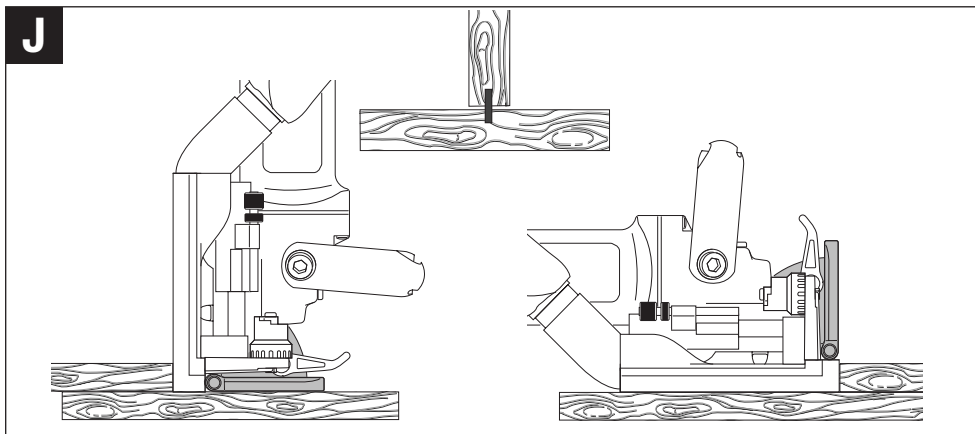
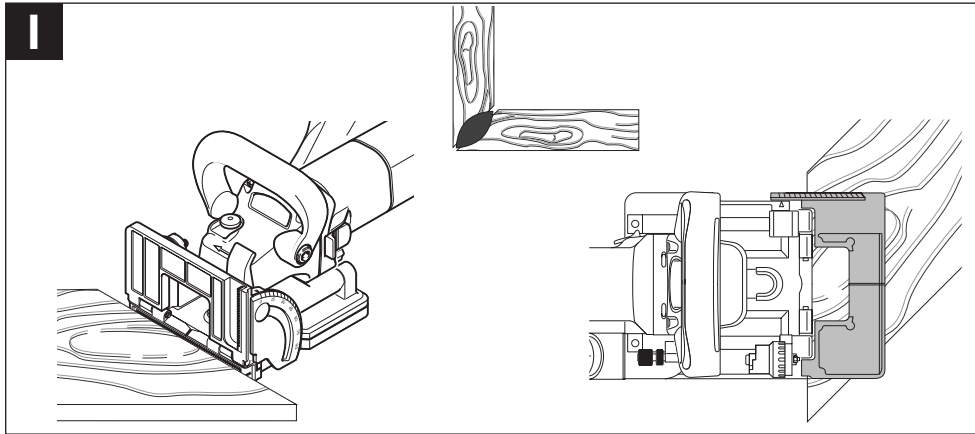


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Entsorgung

Elektrowerkzeuge, Zubehör und Verpackungen sollen einer umweltgerechten Wiederverwertung zugeführt werden.

Werfen Sie Elektrowerkzeuge nicht in den Hausmüll!

Nur für EU-Länder:

Gemäß der Europäischen Richtlinie 2002/96/EG über Elektro- und Elektronik-Altgeräte und ihrer Umsetzung in nationales Recht müssen nicht mehr gebrauchsfähige Elektrowerkzeuge getrennt gesammelt und einer umweltgerechten Wiederverwertung zugeführt werden.

Änderungen vorbehalten.

English**Safety Notes****General Power Tool Safety Warnings**

⚠ WARNING Read all safety warnings and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

Work area safety

- ▶ **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- ▶ **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- ▶ **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

Electrical safety

- ▶ **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- ▶ **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.

- ▶ **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- ▶ **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges and moving parts.** Damaged or entangled cords increase the risk of electric shock.
- ▶ **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- ▶ **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

Personal safety

- ▶ **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- ▶ **Use personal protective equipment. Always wear eye protection.** Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- ▶ **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- ▶ **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- ▶ **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- ▶ **Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- ▶ **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.

Power tool use and care

- ▶ **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- ▶ **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- ▶ **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.

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- ▶ **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- ▶ **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- ▶ **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- ▶ **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.

Service

- ▶ **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.

Jointers Safety Warnings

- ▶ **Disc cutters must be rated for at least the speed marked on the tool.** Disc cutters running over rated speed can fly apart and cause injury.
- ▶ **Hold power tool by insulated gripping surfaces, because the cutter may contact its own cord.** Cutting a "live" wire may make exposed metal parts of the power tool "live" and could give the operator an electric shock.
- ▶ **Always use correctly sized cuttings discs with the fitting mounting bore.** Cutting discs that do not fit to the mounting components of the biscuit jointer rotate irregularly and lead to loss of control.
- ▶ **Apply the machine to the workpiece only when switched on.** Otherwise there is danger of kickback when the cutting tool jams in the workpiece.
- ▶ **Keep your hands away from the cutting area and the cutting disc. Hold the auxiliary handle with your second hand.** When both hands hold the machine, they cannot be injured by the cutting disc.
- ▶ **Never cut over metal objects, nails or screws.** The router bit can become damaged and lead to increased vibrations.
- ▶ **Use suitable detectors to determine if utility lines are hidden in the work area or call the local utility company for assistance.** Contact with electric lines can lead to fire and electric shock. Damaging a gas line can lead to explosion. Penetrating a water line causes property damage or may cause an electric shock.
- ▶ **Do not use blunt or damaged router bits.** Blunt or damaged router bits cause increased friction, can become jammed and lead to imbalance.
- ▶ **When working with the machine, always hold it firmly with both hands and provide for a secure stance.** The power tool is guided more secure with both hands.
- ▶ **Secure the workpiece.** A workpiece clamped with clamping devices or in a vice is held more secure than by hand.

- ▶ **Always wait until the machine has come to a complete stop before placing it down.** The tool insert can jam and lead to loss of control over the power tool.
- ▶ **Use auxiliary handle(s), if supplied with the tool.** Loss of control can cause personal injury.
- ▶ **The slip safety 7 must always be mounted.**
- ▶ **Use only the application tools listed in these operating instructions.** Do not use cutting discs or circular saw blades.
- ▶ **Press the spindle lock button 14 only when the machine is at a standstill.**
- ▶ **Before putting into operation, check the cutting disc for tight seating.**
- ▶ **Products sold in GB only:** Your product is fitted with a BS 1363/A approved electric plug with internal fuse (ASTA approved to BS 1362).
If the plug is not suitable for your socket outlets, it should be cut off and an appropriate plug fitted in its place by an authorised customer service agent. The replacement plug should have the same fuse rating as the original plug. The severed plug must be disposed of to avoid a possible shock hazard and should never be inserted into a mains socket elsewhere.
- ▶ **Products sold in AUS and NZ only:** Use a residual current device (RCD) with a rated residual current of 30 mA or less.

Product Description and Specifications

Read all safety warnings and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

While reading the operating instructions, unfold the graphics page for the machine and leave it open.

Intended Use

The machine is intended for cutting grooves for biscuit dowel joints in chipboard, hard- and softwood, plywood, fibreboard or artificial marble (e.g. Corian®).

Product Features

The numbering of the product features refers to the illustration of the machine on the graphics page.

- 1 Handle (insulated gripping surface)
- 2 On/Off switch
- 3 Clamping lever of the angle stop
- 4 Height scale
- 5 Angle scale
- 6 Centre mark of cut, horizontal
- 7 Slip safety
- 8 Knob of the adjustable height stop
- 9 Adjustable height stop
- 10 Marks of cutting disc width
- 11 Centre mark of cut, vertical

- 12 Clamping lever of adjustable height stop
- 13 Direction-of-rotation arrow on housing
- 14 Spindle lock button
- 15 Auxiliary handle (insulated gripping surface)
- 16 Attachment plate
- 17 Angle stop
- 18 Cutting depth adjustment knob
- 19 Lock nut for cutting depth adjustment
- 20 Knurled screw for cutting depth adjustment
- 21 Vacuum connection
- 22 Dust bag
- 23 Two-pin spanner
- 24 Clamping nut
- 25 Cutting disc
- 26 Direction-of-rotation arrow on the cutting disc
- 27 Centring collar on mounting flange
- 28 Mounting flange
- 29 Cutter spindle
- 30 Spindle direction-of-rotation arrow
- 31 Base plate lock washer
- 32 Base plate clamping screw
- 33 Base plate

Accessories shown or described are not part of the standard delivery scope of the product. A complete overview of accessories can be found in our accessories program.

Technical Data

Biscuit Jointer		GFF 22 A Professional
Article number		0 601 620 0..
Rated power input	W	670
Output power	W	400
No-load speed	min ⁻¹	9000
Cutting depth, max.	mm	22
Spindle thread diameter		M10 x 1.25
Diameter of cutting disc mounting bore	mm	22
Cutting disc diameter, max.	mm	105
Cutting disc thickness, max.	mm	4
Weight according to EPTA-Procedure 01/2003	kg	2.9
Protection class		□/II

The values given are valid for a nominal voltage [U] of 230 V. For different voltages and models for specific countries, these values can vary. Please observe the article number on the type plate of your machine. The trade names of the individual machines may vary.

Noise/Vibration Information

Measured sound values determined according to EN 60745. Typically the A-weighted noise levels of the product are: Sound pressure level 87 dB(A); Sound power level 98 dB(A). Uncertainty K = 3 dB.

Wear hearing protection!

Vibration total values a_{h_i} (triax vector sum) and uncertainty K determined according to EN 60745:
 $a_{h_i} < 2.5 \text{ m/s}^2$, $K = 1.5 \text{ m/s}^2$.

The vibration emission level given in this information sheet has been measured in accordance with a standardised test given in EN 60745 and may be used to compare one tool with another. It may be used for a preliminary assessment of exposure. The declared vibration emission level represents the main applications of the tool. However if the tool is used for different applications, with different accessories or poorly maintained, the vibration emission may differ. This may significantly increase the exposure level over the total working period. An estimation of the level of exposure to vibration should also take into account the times when the tool is switched off or when it is running but not actually doing the job. This may significantly reduce the exposure level over the total working period. Identify additional safety measures to protect the operator from the effects of vibration such as: maintain the tool and the accessories, keep the hands warm, organisation of work patterns.

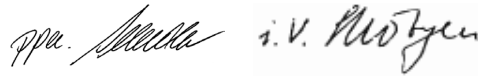
Declaration of Conformity

We declare under our sole responsibility that the product described under "Technical Data" is in conformity with the following standards or standardization documents: EN 60745 according to the provisions of the directives 2004/108/EC, 2006/42/EC.

Technical file at:
 Robert Bosch GmbH, PT/ESC,
 D-70745 Leinfelden-Echterdingen

Dr. Egbert Schneider
 Senior Vice President
 Engineering

Dr. Eckerhard Strötgen
 Head of Product
 Certification



Robert Bosch GmbH, Power Tools Division
 D-70745 Leinfelden-Echterdingen
 Leinfelden, 14.04.2011

Assembly

Installing/Replacing the Cutting Disc (see figures A – B)

- Before any work on the machine itself, pull the mains plug.
- For installing and replacing cutting discs, it is recommended to wear protective gloves
- Protect cutting discs against shock and impact.

The machine may be operated exclusively with the Bosch cutting disc 3 608 641 013.

Use only clean cutting discs that are in perfect condition.

- As necessary, set the angle stop 17 to 0° (see "Setting the Cutting Angle", page 17) and the adjustable height stop 9 to the maximum height (see "Setting the Adjustable Height Stop", page 16).
- Turn the machine around so that the base plate 33 faces upward.

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- Loosen the clamping screw **32** by approx. 3 turns.
Note: Do not completely unscrew the clamping screw **32** so that the lock washer **31** is not lost. Without the lock washer, the base plate **33** cannot be secured.
- Pivot the base plate **33** upward. Hold the machine in such a manner that the base plate will not pivot back.
- Press the spindle lock button **14** and keep it pressed.
- Loosen and remove the clamping nut **24** with the two-pin spanner **23** provided.
- Remove the cutting disc **25** if mounted, and clean it.
- Remove the mounting flange **28** if mounted, and clean it.
- Place the mounting flange **28** onto the cutter spindle **29** in such a manner that the centring collar **27** (22 mm diameter) faces upward. The flats of the mounting flange must engage onto the flats of the cutter spindle (anti-twist protection).
- Place the clean cutting disc **25** as shown in the figure onto the mounting flange **28** in such a manner that the direction-of-rotation arrow on the cutting disc **26** is visible and corresponds with the direction-of-rotation arrow of the cutter spindle **30**. The mounting bore of the cutting disc must engage in the centring collar **27** of the mounting flange.
- Screw the clamping nut **24** onto the cutter spindle **29**. With the spindle lock button **14** pressed, firmly tighten the clamping nut with the two-pin spanner **23**.
- ▶ **Check if the cutting disc is properly mounted and rotates freely.**
- Pivot the base plate **33** down. Pay attention that the lock washer **31** rests on the base plate (with the clamping screw **32** alone the base plate cannot be fastened securely).
- Tighten the clamping screw **32**.
- ▶ **Check if the base plate 33 is locked securely.**

Dust/Chip Extraction

- ▶ Dusts from materials such as lead-containing coatings, some wood types, minerals and metal can be harmful to one's health. Touching or breathing-in the dusts can cause allergic reactions and/or lead to respiratory infections of the user or bystanders.
Certain dusts, such as oak or beech dust, are considered as carcinogenic, especially in connection with wood-treatment additives (chromate, wood preservative). Materials containing asbestos may only be worked by specialists.
 - As far as possible, use a dust extraction system suitable for the material.
 - Provide for good ventilation of the working place.
 - It is recommended to wear a P2 filter-class respirator.
 Observe the relevant regulations in your country for the materials to be worked.

Clean the vacuum connection **21**, if required. For this, pivot up the base plate **33** (see "Installing/Replacing the Cutting Disc", page 15) and pull off the vacuum connection.

External Dust Extraction (see Accessory Page)

Insert the extraction adapter (accessory) with a light turning motion into the vacuum connection **21**. Insert the sleeve of a vacuum hose (accessory) with a turning motion into the extraction adapter. Connect the vacuum hose to a vacuum cleaner.

The vacuum cleaner must be suitable for the material being worked.

When vacuuming dry dust that is especially detrimental to health or carcinogenic, use a special vacuum cleaner.

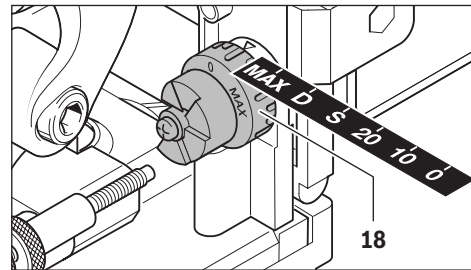
Internal Dust Extraction with Dust Bag (see Accessory Page)

For small cutting jobs, the dust bag **22** can be used.

Insert the sleeve of the dust bag **22** with a light turning motion into the vacuum connection **21**.

To maintain optimum dust collection, empty the dust bag **22** in good time.

For this, pull off the dust bag **22**, open the zipper and empty the dust bag.

Operation**Adjusting the Depth-of-cut**

With the cutting depth adjustment knob **18**, the depth-of-cut can be set. The cutting depth adjustment knob has set stops for six biscuit dowel sizes.

Correlation of the set stops to biscuit dowel sizes and depths-of-cut:

Set stop	Biscuit dowel	Depth-of-cut in mm
0	No. 0	8
10	No. 10	10
20	No. 20	12.3
S	Simplex	13
D	Duplex	14.7
MAX	–	22

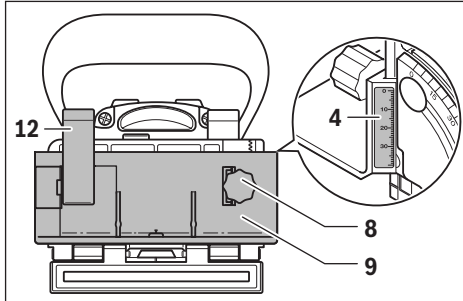
When using resharpened cutting discs, the depth-of-cut may possibly need to be readjusted. For this, loosen the lock nut **19**. The depth-of-cut can be reduced by turning the knurled screw **20** in clockwise direction or increased by turning in anticlockwise direction. Check the adjusted cutting depth by carrying out trial cuts. Afterwards, firmly tighten the lock nut **19** again.

Setting the Adjustable Height Stop

With the adjustable height stop **9**, the distance between the upper surface of the workpiece and the intended groove can be set.

To mount the adjustable height stop **9**, place it on the angle stop **17** and screw it into the guide on the angle stop with knob **8**.

Note: Do not exert any force when mounting! The stop **9** slides in easily when in the correct position.



With the knob **8**, set the desired distance on the height scale **4**. Then retighten the clamping lever **12**.

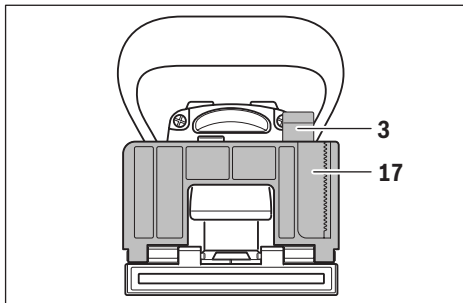
In order to position the groove centred in the workpiece, the adjustable height stop must be set to half of the workpiece thickness.

Example: For an 18 mm thick workpiece, set the height scale to 9 mm.

To remove the adjustable height stop **9**, loosen clamping lever **12**. With knob **8**, unscrew the height stop upward out of the angle stop **17**.

Setting the Cutting Angle

The angle stop **17** enables easy cutting of grooves on mitre joints.



To adjust the angle stop **17**, loosen clamping lever **3**. Pivot the angle stop until the desired angle is set on the angle scale **5** (latching points are located at 0°, 45° and 90°). Then tighten clamping lever **3** again.

► **After adjusting the cutting angle, pay attention that neither the adjustable height stop **9** nor the die attachment plate **16** are in the path of the cutting disc.** Check as follows: With the machine switched off, simulate a cut and push the cutter outlet e. g., against a table edge until the cutting disc becomes visible. The cutting disc, when driven out to the maximum position, may not touch the adjustable height stop **9** or the attachment plate **16**.

Starting Operation

- **Observe correct mains voltage! The voltage of the power source must agree with the voltage specified on the nameplate of the machine. Power tools marked with 230 V can also be operated with 220 V.**
- **The machine may be switched on only when the base plate **33** is locked securely with the clamping screw **32** and the lock washer **31**.**
- **Before switching on, check if the automatic returning action of the motor unit functions properly.** Push the cutter outlet e. g., against a table edge until the cutting disc becomes visible. When the pressure is released, the cutting disc must be completely pulled back into the base plate.

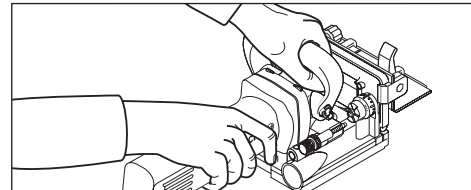
Switching On and Off

To **switch on** the machine, push the On/Off switch **2** forward and press it down at the front to **lock on**.

To **switch off** the machine, press down the On/Off switch **2** at the rear so that the switch springs back to the off position.

Working Advice

- **When working with the machine, always hold it firmly with both hands and provide for a secure stance.** The power tool is guided more secure with both hands.
- **Keep your hands away from the cutting area and the cutting disc.**



While working, hold handle **1** with one hand and auxiliary handle **15** with the other hand.

- **Apply the machine to the workpiece only when switched on.** Otherwise there is danger of kickback when the cutting tool jams in the workpiece.

Carry out the routing process applying uniform feed.

Establishing the Cutting Position

The vertical centre mark of cut **11** on the angle and height stop indicates the centre of the cut (vertical to the cutting disc). The maximum width of the cut is indicated by the two marks **10** on the adjustable height stop **9**.

For positioning of the height, the horizontal centre mark of cut **6** on the base plate, which indicates the horizontal centre of the cutting disc, is helpful.

The direction-of-rotation arrow **13** on the housing of the power tool indicates the rotation direction of the cutting disc.

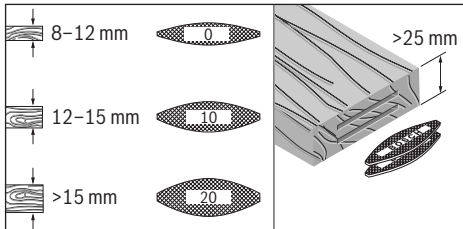
Cutting Groove Joints

Examples for the following groove joints are shown on the graphic pages:

- **Corner joints:** With the angle stop, see figure C; with the adjustable height stop, see figure D
- **Mitre joints:** With the angle stop, see figure E; with the adjustable height stop, see figure F

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- **Longitudinal and lateral joints:** With the angle stop, see figure G; with the adjustable height stop, see figure H
- **Frame joints:** See figure I
- **Centre wall joints:** See figure J

Selection of the Biscuit Dowel

Use the largest possible biscuit for a solid wood joint. Bosch offers appropriate biscuits in the accessories program (see accessories page at the end of the operating instructions).

Cutting Thin Workpieces (see figure K)

For cutting workpieces with a thickness below 16 mm, place the attachment plate **16** on the angle stop **17**. This ensures that the groove is not cut too close to the upper surface of the workpiece. When calculating the horizontal cutting position, consider the 4 mm thickness of the attachment plate.

Also use the attachment plate **16** for mitre joints in thin workpieces so that the groove is not cut too deep.

Cutting Narrow Workpieces

If possible, use the adjustable height stop **9** when cutting narrow workpieces. Pay attention that the marks for the maximum cutting disc width **10** on the height stop are within the workpiece.

Maintenance and Service**Maintenance and Cleaning**

- ▶ **Before any work on the machine itself, pull the mains plug.**
- ▶ **For safe and proper working, always keep the machine and ventilation slots clean.**

Clean and grease the guides as necessary. Use exclusively non-gumming oil for this (e.g., sewing machine oil).

Re-tensioning Clamping Levers

The tensioning force of the clamping levers **3** and **12** can be readjusted, if required. For this, loosen and then screw off the clamping lever. Screw on the clamping lever again displaced by at least 30° in anticlockwise direction.

If the machine should fail despite the care taken in manufacturing and testing procedures, repair should be carried out by an after-sales service centre for Bosch power tools.

In all correspondence and spare parts order, please always include the 10-digit article number given on the type plate of the machine.

After-sales Service and Customer Assistance

Our after-sales service responds to your questions concerning maintenance and repair of your product as well as spare parts. Exploded views and information on spare parts can also be found under:

www.bosch-pt.com

Our customer service representatives can answer your questions concerning possible applications and adjustment of products and accessories.

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