Holzfforma®

for the working man

THE HOLZFFORMA CHAINSAW USER MANUAL

Contents

Safety instructions and work technique

Special precautions must be taken when working with a power saw. The saw chain moves at high speed, and the cutting teeth are extremely sharp. Work efficiency is higher compared to axes or hand saws, increasing accident risks.

Read the instructions carefully before initial operation and save them safely for future reference.

Failure to comply with the operating instructions may result in life-threatening situations.ference.

Comply with the safety regulations in force in the country, including those from trade unions, occupational safety authorities, and other relevant institutions.

Minors under 16 years of age are prohibited from operating the device. Exceptions apply only to individuals aged 16-18 undergoing supervised training.

Children, animals, and spectators must be kept at a safe distance.

When not in use, store the chainsaw securely to prevent unauthorized access or accidental contact.

Protect the motorized chainsaw from unauthorized use.

The operator is fully responsible for accidents or hazards that endanger others or property. Only trained and certified personnel familiar with this model may borrow or rent the machine. Noise regulations: The use of motorized equipment generating high noise levels must comply with local temporary restrictions (e.g., time limits, noise barriers).

Persons operating the device should be rested, healthy, and in good physical condition. Anyone who , for reasons of health, should seek medical advice as to whether he or she can operate the machine.

Only for persons with an implanted pacemaker: The ignition system of this device generates a very small electromagnetic field. The influence of electromagnetic fields on certain types of pacemakers cannot be completely excluded. To avoid health risks, HOLZFFORMA recommends that you consult your physician and the pacemaker manufacturer.

Do not operate the device after using alcohol, medication, or drugs. In case of unfavorable weather (rain, snow, ice, wind) postpone work - increased risk of accidents!

Intended use

Use the chainsaw only for cutting wood and wood objects. The device must not be used for other purposes - **risk of injury!**

Only fit cutting tools, guide bars, saw chains, or accessories approved by HOLZFFORMA for this machine or with similar technological properties. If you have any questions, contact your specialist dealer. Use only the recommended accessories.Otherwise there s a risk of accidents or damage to the machine.

Do not make any modifications to the device as this could have a negative effect on the safety. HOLFFORMA declines all liability for damage to persons and property caused by the use of attachments not approved by HOLFFORMA.
Do not use a high-pressure washer to clean the device. Do not use a high-pressure washer to clean the device.

Clothing and equipment

Wear prescribed clothing and equipment.

Clothing must be appropriate and must not interfere with work. Tight-fitting clothing with cut protection – rather th an a work coat – is rec ommended.

Do not wear clothing that could get caught in wood, brush, or moving parts of the device. Do not wear a scarf, tie, or any jewelry. Long hair must be tied up and secured (scarf, hat, helmet, etc.).

Wear protective boots – with cut protection, ribbed soles, and com posite toes.

Wear a protective helmet – if you can see any overhead objects.

Wear safety goggles or face protection and protective equipment – including hearing prot ection like earplugs.

Wear **sturdy per- chat rooms**.

Transporting the Power Saw

Always lock the chain brake and install the chain guard - also when transporting short distances. When transporting long distances (more than 50 m), also stop the motor.

Carry the chain saw only by the pipe handle - keep the hot muffler away from the body, guide bar pointing backwards. Do not touch hot machine parts, especially the muffler - risk of burns!

On vehicles: Protect the motorcycle unit against tipping over , damage, and fuel spillage.

Refueling

Gasoline is extremely flammable - keep a safe distance from open flames - do not spill fuel - do not smoke.

Before refueling, switch off the engine.
Do not refuel until the engine has cooled down completely - fuel may overflow - **risk of fire!**
Open the fuel filler flap carefully so that the overpressure is released slowly and fuel cannot spurt out.
Refuel only in well-ventilated areas.
If the fuel has been spilled, clean the machine immediately - make sure that the fuel does not get on your clothing, in your clothes, in your hands or on the floor.

but change clothes immediately.
Motorized units can be supplied as standard with various types of tank shut-off devices.

After refueling, tighten the fuel tank screw locking device as far as possible. Correctly install the tank locking device with folding clamp (bayonet lock), turn to the stop and close the lock.

This reduces the risk of the tank lock unscrewing due to engine vibrations and thus the risk of fuel leaking out.

Before launching:

Check that the device is in perfect working order - refer to the corresponding chapter in the operating instructions:

- Saw chain brake in good working order, front guard.
- Correctly mounted guide rail.
- Properly tensioned saw chain.
- The fuel control lever and lever stopper are easily movable - the fuel control lever should automatically spring back to the idle position.
- The combination lever/stop switch must be easily set to position **STOP/0.**
- Check the tightness of the ignition wire contact lug - if the lug is not tightly seated, sparking may occur, sparks may be generated.can ignite the fuel-airfire hazard!
- Do not modify control or safety mechanisms.
- Handles must be oil-free, clean, and dry to ensure safe operation of the power tool.

Operate the chainsaw only in a safe and fully functional condition - **accident risk!**

Starting the engine

Start at least 3 meters away from the refueling area and never in enclosed spaces.
Stand on level ground, maintain a secure stance, and grip the machine firmly. Ensure the cutting attachment does not contact objects or the ground, as it may rotate during startup.
Only one operator is permitted. Unauthorized individuals must stay clear of the work area, even during startup.
Engage the chain brake before starting - rotating saw chain poses injury risk!
Start the engine strictly as described in the manual - never manually.
Do not start the chainsaw if the saw chain is lodged in a cutting kerf.

Handling and operating the device

Always **hold the chainsaw firmly with both hands** during operation: Right hand on the rear handle (applies to both right-handed and left-handed users). For secure grip, ensure the front and rear handles are firmly grasped with thumbs wrapped around them.

While working

Maintain a secure and stable stance at all times.
In emergencies, stop the engine immediately by switching the ignition lever/switch to **0/STOP.**
Only one operator is permitted - no unauthorized persons in the work area.
Never leave the chainsaw unattended while the engine is running.
After releasing the throttle trigger, the saw chain may continue moving briefly due to inertia.
Exercise extreme caution in hazardous conditions:
Slippery surfaces (ice, snow, wet terrain, slopes, uneven ground, or debarked wood).
Obstacles such as stumps, roots, or ditches - **risk of tripping!**

Additional safety rules:
Never work alone - ensure others are within hearing distance to assist in emergencies.
When using hearing protection, remain extra vigilant, as it may limit awareness of warnings (e.g., shouts, alarms).
Take regular breaks to avoid fatigue - exhaustion increases **accident risks**!

Keep flammable materials (e.g., wood chips, bark, dry grass, fuel) away from the hot exhaust gas stream and away from the surface of the hot silencer - fire hazard! Mufflers with catalytic converters can become particularly hot.

When the power tool is running, poisonous exhaust gases are emitted as soon as the engine is started. These gases may be odorless and invisible and may contain carbon and benzene. Never operate the power tool in closed or poorly ventilated areas - also when using the power tool with a catalytic converter.

When working in ditches, hollows, or in confined spaces, a sufficient air exchange must always be ensured. **Danger to life due to poisoning!**
If nausea, headache, visual disturbances (e.g., reduced field of vision), hearing loss, dizziness, or reduced ability to concentrate occur, stop work immediately - these symptoms may be caused by, among other things, increased exhaust gas concentration - **risk of accident!**
Dust (e.g., wood dust), vapors, and fumes generated during work can cause serious health hazards. Wear a dust mask in case of heavy dust generation.
Check the saw chain regularly at short intervals and immediately if noticeable changes occur:
● Stop the motor, wait for the saw chain to stop.

●Check condition and density of plantings

●Monitor the sharpening status of the saw chain

Never touch the saw chain while the engine is running. If the chain is jammed, immediately stop the engine before removing the obstruction - **risk of injury!**

Stop the engine before replacing the saw chain - **injury hazard!**

No smoking during operation or near the device - **fire risk!** Flammable gasoline vapors may escape from the fuel system.

After accidental impacts or drops: Inspect the machine's condition (e. g., fuel leaks, safety device function ality) before reuse. If damaged, cons ult a specialist.

Tree maintenance guidelines: **Secure** the chainsaw with a safety line and loop. Lock the chain brake before detaching it from the line.

Single-handed operation is permitted only if:

●Two-handed use is impossible.

●The chainsaw is firmly gripped, and all body parts are outside its swing range.

Prohibited actions during one-handed use:

●Holding branches being cut.

●Working above shoulder height.

●Attempting to catch falling branches.

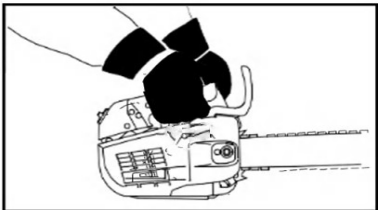
Ensure the saw chain stops completely when the throttle is released. If it continues moving, seek professional repair.

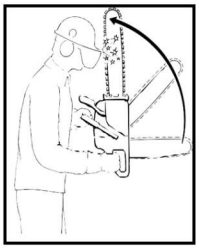
Reaction forces:

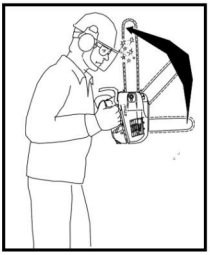
Common forces include kickback, pull-in, and pushback.

Danger from kickback：

Kickback can cause fatal injuries.

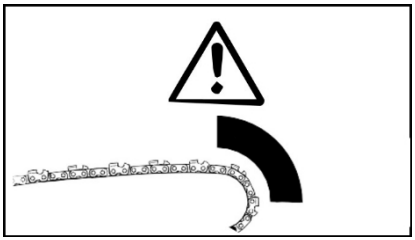






Kickback hazards
Kickback occurs when the saw unexpectedly accelerates toward the operator due to loss of control.

Common triggers:



- The saw chain in the upper quadrant of the guide bar contacts wood or a solid object unintentionally (e.g., cutting limbs and striking another limb).
- The saw chain at the top of the bar is briefly pinched in the cut.

Saw chain brake:

Reduces injury risk in specific scenarios but does not eliminate kickback. When activated, the chain stops within milliseconds (see "Saw Chain Brake" section).

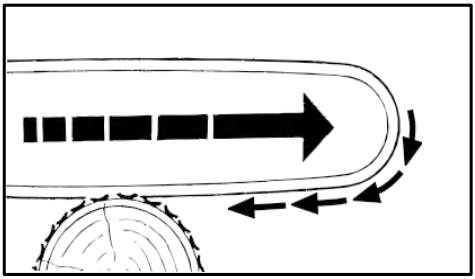
Reducing kickback risks:

- Work deliberately with proper technique.
- Grip the saw firmly with both hands.
- Operate at full throttle during cutting.
- Avoid cutting with the guide bar ’s upper quadrant.
- Stay alert near small branches or unstable wood.

The saw chain may become entangled in limbs, undergrowth, or dense vegetation.

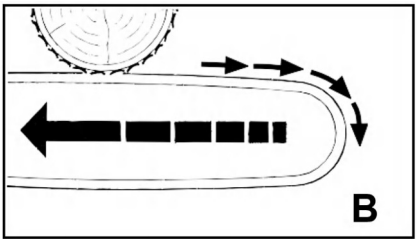
- Never cut more than one branch at a time.
- Avoid leaning too far forward while operating the chainsaw.
- Do not saw above shoulder height. Insert the guide bar carefully into an existing cut.
- Do not perform plunge cuts unless trained in this technique.
- Monitor the trunk ’ s position and forces closing the cutting gap - risk of pinching the saw chain.
- Only use a properly sharpened and tensioned saw chain - ensure depth limiter settings are correct.
- Use anti-kickback chains and guide bars with small nose profiles to reduce hazards.

Tightening in the cut (A)



If the chain is pinched or strikes a hard object during a lower-guide-bar cut (front cut), the saw may jerk sideways. Always secure the chain brake to prevent this.

Reversal (B)



If the saw chain is pinched or strikes a hard object during upper -guide-bar cutting (reverse cut), the saw may swing violently away from the operator. **To avoid this:**

- Never cut with the upper quadrant of the guide bar.
- Avoid rotating the guide bar during operation.

Special precautions required:

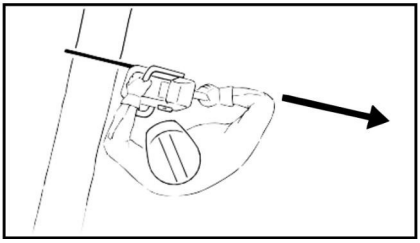
- When working with wood under internal stress (e.g., tension from being lodged between other trees).
- In wind-damaged or unstable forests - do not use the chainsaw directly. Instead, employ mechanical aids like grapples, winches, or tractors.
- Secure loose trunks freed during cutting. If possible, process them in stable areas.

Dry wood hazards:Dry, rotten, or dead wood poses hidden risks (e.g., unpredictable splitting). Use auxiliary equipment (e.g., winches) for safe handling.

When felling near critical areas: Roads, railroad tracks, power lines, etc. - do not operate the chainsaw in the idle position. Engine speed cannot be adjusted via the throttle trigger in this mode.

General safety rules:

Work calmly and carefully - only under good lighting and visibility. Use the shortest guide bar suitable for the task - ensure the saw chain, guide bar, and sprocket are compatible.



Keep body parts clear of the chainsaw ' s swing range.
Retract the saw from wood only with the chain running.
Use the chainsaw solely for cutting - never as a shovel to move debris.
Cutting precautions:Do not trim overhanging branches from below. Exercise extreme caution when cutting split wood - **risk of trapped wood fragments causing injury!**
Avoid contact with foreign objects (e.g., stones, nails) during cutting - they may be ejected violently, damaging the saw.

When working on slopes:Always position yourself above or to the side of the tree trunk or fallen wood to prevent rolling hazards.

When working at heights:

- Use an elevated work platform (e. g., aerial lift).
- Never operate on a stepladder, tree branches, or unstable surfaces.
- Never work above shoulder height .

Cutting technique:

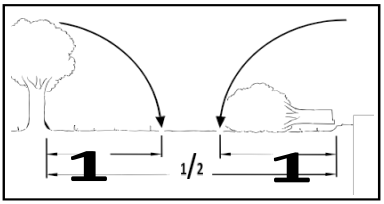
- Engage full throttle before inserting the guide bar into the cut, and ensure the chain brake is securely activated.
- Never operate without the chain brake - sudden movements may cause loss of control.

End of cut precautions:

- At the end of a cut, the chainsaw loses support from the wood. Counteract the weight of the saw immediately - **risk of losing control!**

Felling operations

Only trained and certified personnel may perform tree felling or limbing. Untrained users face significantly **increased accident risks!**
Comply with local felling regulations.
Work area safety:Only authorized personnel involved in felling may enter the work zone. Before felling, ensure no one is within 2.5 times the tree ’s height of the fall path. Use visual/ audible signals (e.g., whistles) to communicate - engine noise may drown out shouts.

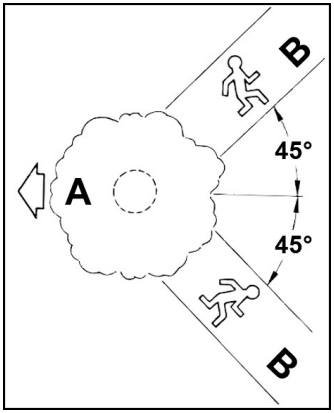


Planning the felling direction:

Identify a clear drop zone within the forest/work area. Consider:

- Natural lean of the tree.
- Structural issues: Heavy branching, asymmetrical growth, trunk damage, or dry/rotten wood.
- Environmental factors: Wind direction/speed (avoid felling in strong winds).
- Slope angle and neighboring tree positions.

Evacuation routes:Establish and mark escape paths perpendicular to the tree ’s fall direction.



A - Felling Direction: Align with the tree's natural lean and environmental factors.
B - Evacuation Routes: Establish escape paths at a 45-degree angle backward from the fall zone.

Preparation Steps:

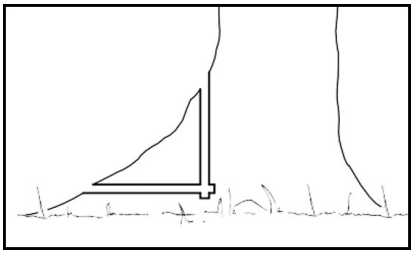
- Clear escape routes of obstacles (e.g., bushes, debris).
- Store tools and equipment at a safe distance - not within escape paths.
- Work from the side of the falling tree and retreat only via designated escape routes.

Steep Slope Operations:

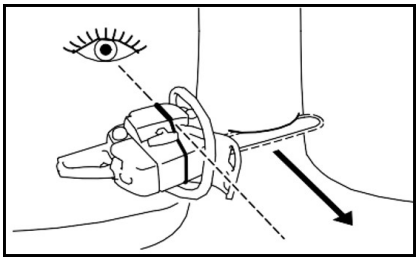
- Design evacuation routes parallel to the slope for safer movement.

Post-Felling Actions:

- Watch for falling limbs and crown movement during retreat.
- Clear the workspace around the trunk of obstacles - ensure all personnel maintain stable footing.
- Remove debris (e.g., sand, stones) from the trunk base using an axe - foreign objects may dull the saw chain.



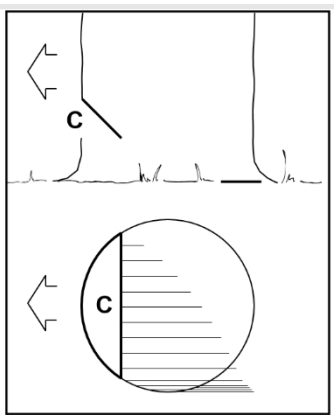
- Trim large overhanging roots only on healthy trees - start with the largest root, cutting vertically first, then horizontally.



Felling direction alignment:

- Monitor the selected direction using the felling bar on the hood and the fan housing of the chainsaw.
- Orient the guide bar to point toward the intended fall path.

Cutting sequence: Horizontal and inclined cuts may vary - follow
local regulations for permissible techniques.



Undercut (C) determines the tree's felling direction. Follow these steps:

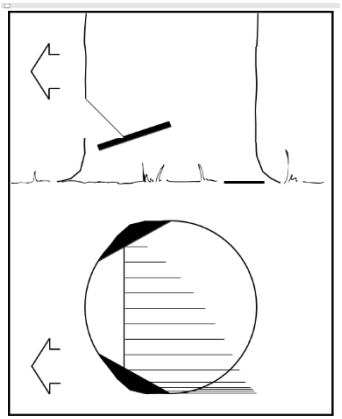
Horizontal cut:

- Perform carefully while using the felling bar to control the direction.
- Cut at a 45-degree angle relative to the fall path.
- Keep the cut as low to the ground as possible.
- Depth: 1/5 to 1/3 of the trunk diameter.

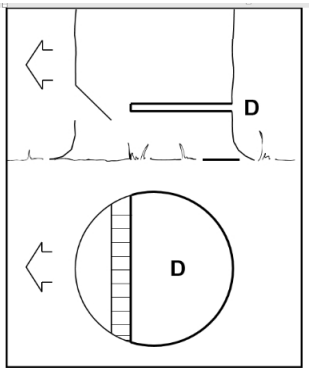
Relief cuts for long-fibered wood:

- Prevent sapwood splitting during fall by making shallow relief cuts (≈1/10 trunk diameter) on both sides of the trunk at the base .
- For thick trunks, limit the depth to the guide bar's maximum width.

Note: Ensure the cut is perpendicular to the intended fall direction.



Felling Kerf Preparation



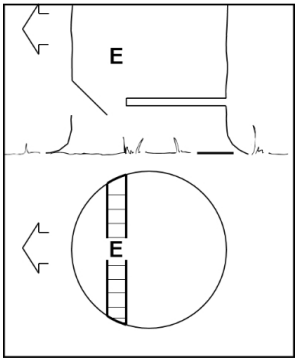
Before making the main kerf (D), shout warnings like " Caution! " to alert nearby personnel.

Main kerf guidelines:

- Cut slightly above the horizontal undercut.
- Keep the kerf strictly horizontal.
- Maintain a gap of ≈1/10 trunk diameter between the main kerf and undercut.

Wedging requirements:

- Insert wedges into the main kerf promptly.
- Permitted materials: Wood, light metal, or plastic.
- Prohibited: Steel wedges (risk of sparks or chain damage).



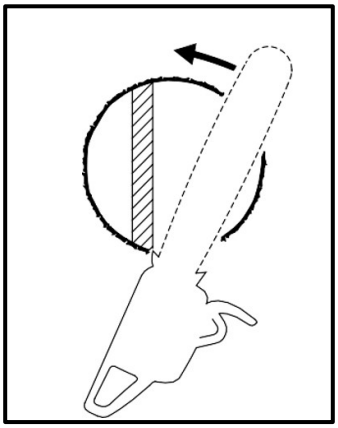
Undersaw (E) Function:

Acts as a hinge to guide the tree ' s fall direction.

●Never interrupt the main kerf - deviation from the planned path may cause accidents!

●Increase kerf width on rotten trunks for stability.

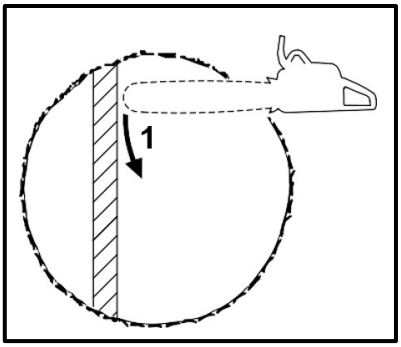
●Shout " Attention! " again just before the tree falls.



Positioning the toothed stop:

●Place it behind the undercut. Rotate the saw around this pivot only before completing the undersaw. Ensure the stop rolls smoothly along the guide bar.

Handling Thick Trunks (Multi-Sector Cut)



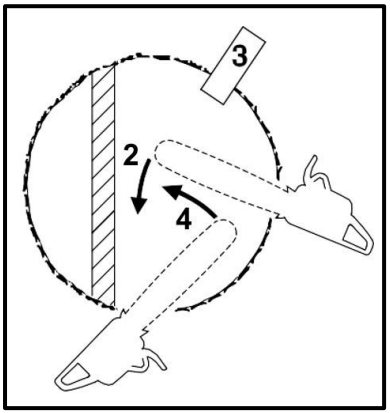
When the trunk diameter exceeds the chainsaw ' s cutting length, use a tightened fan cut (multi-sector cut):

1,Initial Undercut:

●Insert the top of the guide bar into the trunk for undercutting.

●Guide the saw horizontally and withdraw it fully after each cut.

●Use the toothed stop as a pivot point - slightly lift the saw if necessary.



2,Proceeding to Next Cut:

●Adjust the guide bar to the next sector while maintaining horizontal alignment.

●Reset the toothed stop to ensure precise control.Avoid uneven main kerfs by repositioning the toothed stop between cuts.

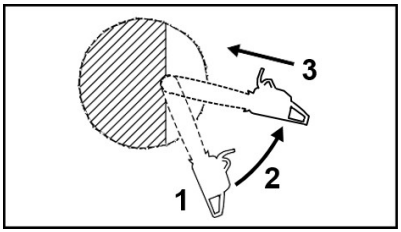
3.Insert wedge (3)

4.The final cut: the saw is set up like a simple fan cut - no undercutting!

Advanced Cutting Techniques

Tapping and tangential cutting require specialized training and practice.

- Felling overhanging trees with a shifted center of gravity.
- Stress relief during crosscutting.
- Amateur operations (use extreme caution).



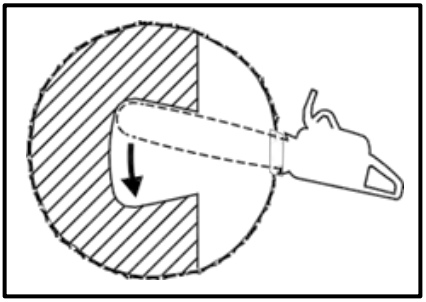
Procedure for Low-Kickback Chains

1,Install the guide bar:Position the bottom (not top) of the bar head. Cut until the guide bar penetrates twice the trunk ' s width - kickback hazard!

2,Swivel the guide bar slowly to the plunge-cut position - risk of kickback or reverse impact!

3,Exercise extreme caution during cutting - reverse impact danger!

Tangential section



- Trunk diameter exceeds twice the guide bar length.
- Hardwood species (e.g., oak, beech) - ensures precise felling direction and prevents splitting of the dense core.
- Soft deciduous trees - relieves internal stress and avoids wood tear-out.

Procedure:

1,Initial cut: Carefully enter the trunk at a controlled angle - high kickback risk!

2,Rotate the saw in the direction of the arrow to complete the tangential cut.

Limbing Operations

Only trained personnel may perform limbing. Untrained users face severe accident risks!

Use low-kickback saw chains and secure the chainsaw if possible.

Prohibited actions:

- Standing on the trunk while cutting.
- Cutting with the guide bar ' s upper quadrant.

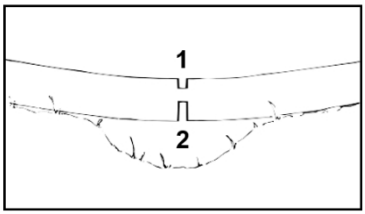
●Pay attention to limbs that are under tension
●Never cut more than one branch at a time.

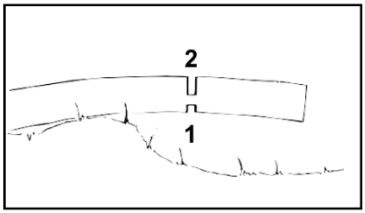
Sawing fine wood

●Use a stable clamping fixture (e.g ., gantry) to secure the wood.
●Do not manually stabilize the tree - no external assistance is allowed.

Handling Trees Under Tension

Cutting sequence:
1,First, cut the compression side (1) .
2,Then, cut the tension side (2).
Reverse this order risks saw jamming or kickback!

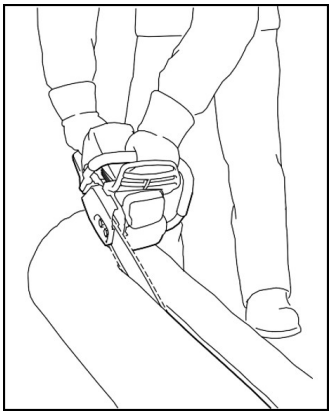




Unloading Cuts
●Compression side (1): Cut from top to bottom.
●Tension side (2): Cut from bottom to top **- risk of reverse impact!**

Do not let fallen trees come into contact with the ground at the cutting point – otherwise, the saw chain could be damaged.

Longitudinal Sawing



Working Without the Toothed Stop
Risk of Pull-In Hazard: Position the guide bar at the flattest possible angle during operation.

Vibration-Induced Health Risks

Prolonged use may cause vibration -induced circulatory disorders (e.g. , Raynaud ' s syndrome/white finger syndrome).
Factors Affecting Usage Duration
Extended Usage:
●Use warm gloves for hand protection.
●Take regular breaks.
Reduced Usage:
●Personal predisposition (e.g., frequent cold/itchy fingers).
●Low ambient temperatures.

●Excessive grip force (restricts blood flow).
Medical Advice

If symptoms (e.g., recurring numbness, itching) persist during regular long-term use, seek periodic medical evaluations.

Maintenance and Repair

All repairs must be conducted by authorized service centers. Modifications or component replacements by users are prohibited. Use exclusively HOLZFFORMA OEM replacement parts.
●Engine must be completely shut off during carburetor maintenance. Keep ignition switch at STOP position when servicing.
●Weekly inspection of fuel shut-off valve leakage is mandatory.
●HOLZFFORMA-certified fuel components are required.
●Check ignition cable insulation integrity and terminal connections monthly.
●Muffler structural damage inspection required every 30 days.
●Chain tension must be checked and adjusted every 8 operational hours.
●Replace drive chain immediately when wear indicators are visible.
Apply oil to guide bar groove daily.

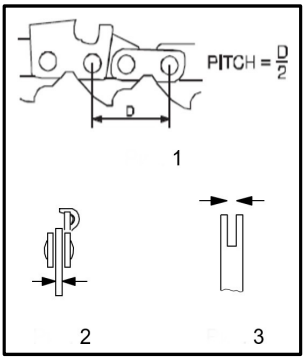
SAFETY INSPECTION CHECKLIST

Verify chain brake functionality prior to each operation. Test emergency stop response time. Confirm 50:1 fuel/oil mixture ratio. Check torque specifications on anti-vibration mounts.

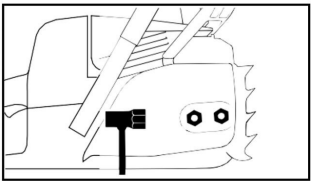
Clutch drum bearing inspection required quarterly. Operate in ventilated areas to prevent carbon monoxide accumulation. Shut down engine immediately if chain rotates during idle.

Cutting headset

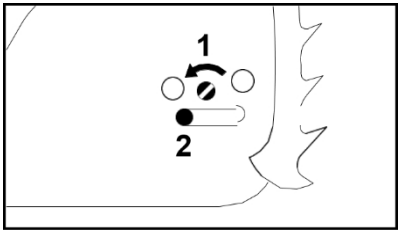
The saw chain, guide bar and chain sprocket form the cutting attachment. The supplied cutting attachment is optimally matched to the power saw.
→ The pitch (D) of the saw chain (Fig. 1), chain sprocket and guide end sprocket must be matched.→ The thickness of the drive link (Fig. 2) of the saw chain (Fig. 1) must be matched to the width of the guide bar groove (Fig. 3). If two unsuitable components are mated, the cutting attachment may be irreparably damaged after short-term use.



Mounting the guide bar and saw chain

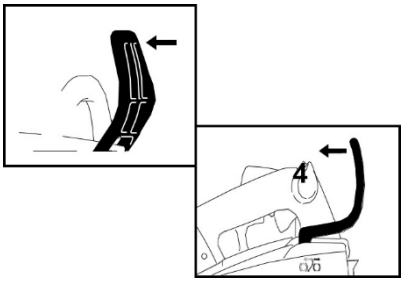


Unscrew nuts and remove chain sprocket cover



●Turn the bolt (1) to the left until the pressure slide (2) fits into the housing recess.

Release the saw chain brake



●Pull the protective shield on the left side toward the pipe handle until an audible click is heard,indicating the brake is released.

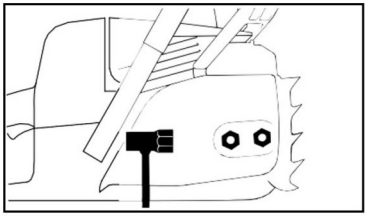
Install the saw chain

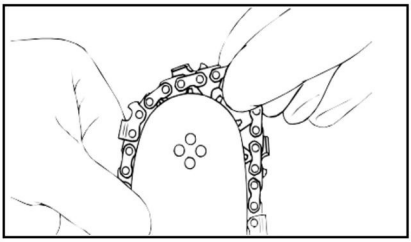
Wear protective gloves to avoid injury from sharp cutting prongs.

Begin chain installation from the top of the guide bar

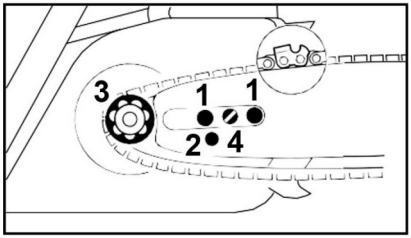
Mounting guide bar and saw chain (front chain tensioning)

●Unscrew nut and remove chain sprocket cover





●Place the guide bar on the bolts (1) - the cutting edges of the saw chain must point to the right.



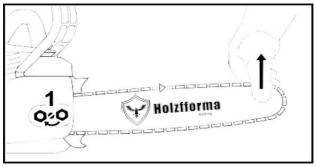
●Place the locking hole (2) on the pin of the clamping slide - at the same time place the saw chain on the chain sprocket (3).

●Turn the bolt (4) to the right until the saw chain slackens only slightly at the bottom - and the projections of the drive links fit into the bar slot.

●Reinstall the chain sprocket (3), cover, and lightly tighten the nuts to the side.

●See further below. "Saw chain tensioning"

Saw chain tension



Adjustment During Work Intervals:

- Stop the engine.
- Loosen the fixing nut.
- Lift the guide bar upward to its top position.

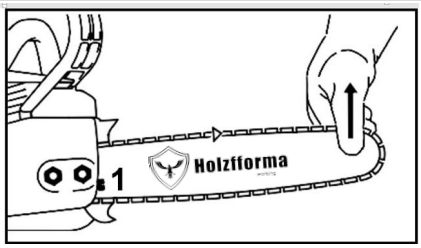
Operation Instructions

- Turn the tensioning screw (1) clockwise with a screwdriver until the chain fits snugly against the bottom of the guide bar.
- Lift the guide bar upward until the nut contacts the top edge of the guide bar.

Notes:

- New chains require more frequent tensioning compared to worn-in chains.
- Regularly check chain tension and adjust as needed. Refer to " Operation Instructions".

Saw chain tension (front chain tension)



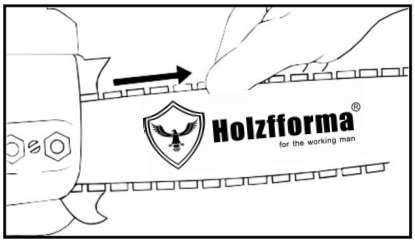
Notes for New Saw Chains:

- New chains require more frequent tensioning compared to worn-in chains.
- Check chain tension regularly and adjust as needed. Refer to " Operation Instructions".

Additional Tension Adjustment During Operation:

- Stop the engine.
- Loosen the fixing nut.
- Lift the guide bar upward to its top position.

Saw chain tension control



- Stop the engine before adjustments.
- Wear protective gloves to avoid contact with sharp edges.
- Ensure the chain rests against the guide bar underside and engages with the bar groove.
- The chain must move freely along the guide bar when pulled manually.
- Re-tension the chain if resistance is detected.
- New chains require more frequent tensioning compared to worn-in chains.
- Check chain tension regularly. Refer to "Operation Instructions".

Fuel

Fuel/Oil Mixture: The engine must run on a premixed gasoline/ 2-stroke oil blend, formulated for air-cooled 2-stroke engines.

Safety Precautions: Avoid skin contact and inhalation of fuel vapors.

Fuel Mixture Preparation

- 2-Stroke Engine Oil: Use manufacturer-recommended 2-stroke oil (specifically for air-cooled engines) to ensure optimal performance.
- Prohibited Oils: Do NOT use 2-stroke oils designed for water-cooled engines or 4-stroke engines.
- Use oils from certified chainsaw manufacturers (e.g., Famous Oil Manufacturer). Unapproved oils may cause severe engine damage.Low-quality gasoline or oil can damage engine seals, fuel lines, and the fuel tank.

Mixing Ratio

When using famous brands of oils: Mix at 1:40 / 5 0 ratio (1 part oil to 40/50 parts gasoline).
Note: Always add oil to gasoline, not vice versa.

When using other motor oil producers for air-cooled two-stroke engines, the ratio is 1:25. 1:25 = 1 part oil + 25 parts gasoline.

Mix Ratio

Famous brands 1:40

Gasoline (L)	Oil (L)	Oil (ml)
1	0.025	25
5	0.125	125
10	0.25	250
15	0.375	375
20	0.5	500
25	0.625	625

Others 1:25

Gasoline (L)	Oil (L)	Oil (ml)
1	0.04	40
5	0.2	200
10	0.4	400
15	0.6	600
20	0.8	800
25	1	1000

Always add oil first into an approved fuel container, then pour gasoline and mix thoroughly.

Fuel Mixture Storage

Store only in fuel-certified containers.
Keep in a cool, dry place, away from light and heat sources.

Fuel mixture degrades over time - store for maximum 14 days. Exposure to light, extreme temperatures, or prolonged storage accelerates deterioration.

Chain oil

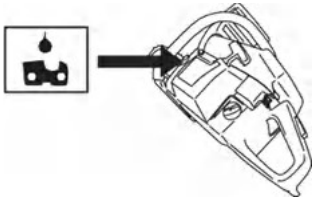
Use specialized chain oil with high adhesion properties.
For automatic chain lubrication systems, use biodegradable, eco-friendly premium-grade oil.
NEVER use oils containing toxic additives - risk of oil pump damage.
Waste oil handling:
- Prolonged skin contact may increase cancer risk.
- Environmentally hazardous; dispose via certified channels.
- Do NOT reuse waste oil for chain lubrication.

Select oil viscosity according to operating temperature range

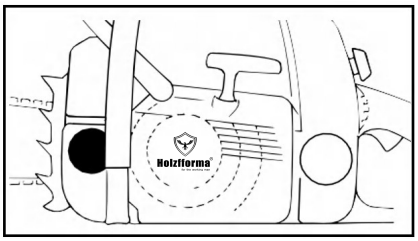
Chain Oil Refilling

Refill chain oil every time you refuel the gasoline tank.
Fill to marked level without spilling or overfilling.
Securely close the oil tank locking mechanism.

Before refueling:Shake the fuel -oil mixture container vigorously to ensure proper blending.
Caution: Internal pressure buildup - open container slowly to release pressure.
Periodically clean fuel tank and container interior.



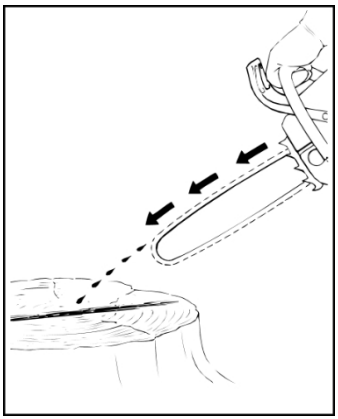
Device Preparation Steps



- Clean the fuel cap assembly and adjacent areas to prevent debris ingress.
- Position the chainsaw with fuel cap facing upward.
- Unlock the fuel cap using designated tool.

After complete fuel consumption, verify minimum oil level remains in chain oil reservoir.
If oil level remains unchanged: Inspect automatic oiling system (pump, feed lines, filter) for malfunctions.

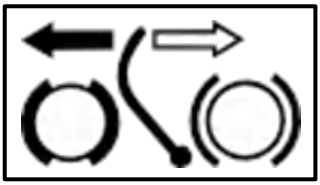
Monitoring the saw chain lubrication system



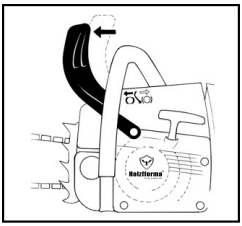
Continuous oil film must be visible on the chain during operation.
NEVER operate with insufficient lubrication! Dry running will damage guide bar and drive sprocket.
Pre-Operation Checks:
Verify chain oiling status and oil tank level before each work session.
Repeat verification prior to every engine start.
New Chain Break-In Procedure:
Run new chains 2-3 minutes at idle speed (no cutting load).
Post-operation: Check chain tension and adjust as needed - see "Chain Tension Verification".

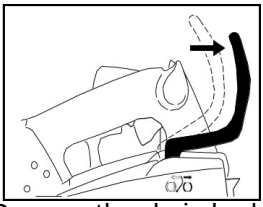
Maintenance and repairs must be performed exclusively by authorized HOLZFFORMA dealers.

Saw chain brake



Lock the saw chain

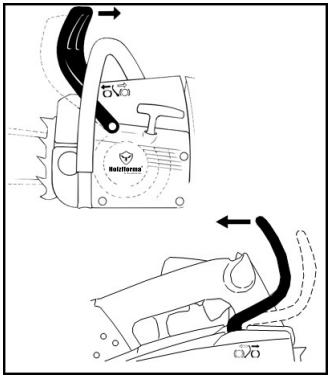




Step 1: Depress the chain brake trigger with left hand (front view diagram).
Step 2: Engage secondary lock on chainsaw body (side view diagram).
Operational Scenarios
- Emergency stop
- Engine startup
- Idle operation

Chain Brake Release

Procedure: Pull the hand guard toward the operator until brake disengages (audible click).



Brake Release Requirement:
Release the chain brake before engaging throttle (except during work control) and before cutting operation.
High-Risk Warning:
Operating at high RPM with engaged chain brake (stationary chain) will rapidly damage clutch assembly and brake mechanism.
Automatic Brake Activation:
Chain brake auto-engages during strong kickback via inertial mechanism: Hand guard accelerates forward to guide bar top.

Do NOT grip the rear handle assembly behind the hand guard during felling operations.

Chain Brake Function Test

Pre-operation check (engine at idle):
Engage chain brake by pressing hand guard to guide bar top → briefly pull throttle → chain must remain stationary.
Hand guard maintenance:
Keep left-side hand guard clean and freely movable.

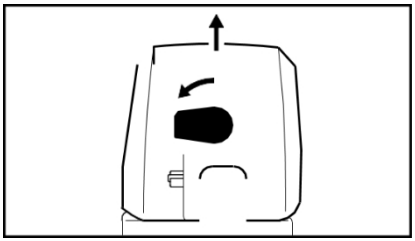
Chain Brake Service

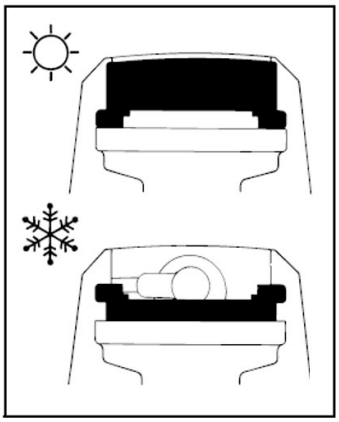
Wear mechanism: Brake lining wears due to operational friction.
Professional service:
Regular maintenance by certified technicians is mandatory for brake functionality.
HOLZFFORMA-approved dealers must perform all repairs.

Winter operation mode

At temperatures below +10°C (G255/E/PRO)

- Press the throttle lock lever and set combination lever to choke position (I).
- Rotate the button above rear handle 90° clockwise to activate winter mode."

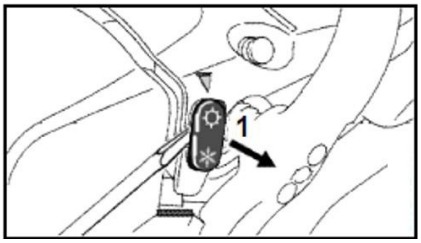




●Remove spark plug cover (slide upward).
●Rotate carburetor heat valve 180° clockwise.
●Reinstall valve with proper torque.
●Reattach air filter cover until click-lock engaged.
Notes:
Warm air intake now prevents carburetor icing.
Above +20°C: Close heat valve immediately to avoid engine power loss and overheating.

At temperatures below +10°C (G366/PRO)

Carburetor heater:

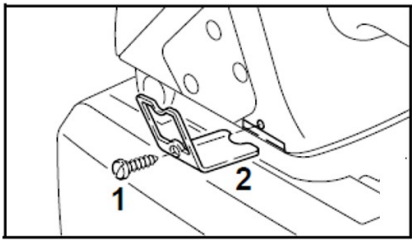


●Use combination wrench or screwdriver to remove valve assembly (1) from mounting bracket.

●Install valve in winter mode position (2) ( ). Hot air from cylinder is redirected to carburetor to prevent icing.

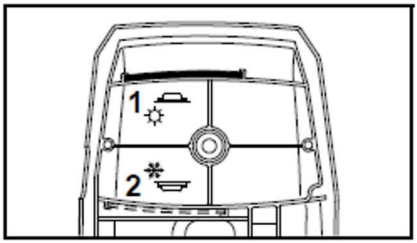
●Operation Above +20°C: Follow technical parameter table ( ) to avoid engine performance degradation and overheating.

At temperatures below+ 10°C (G 111/PRO)



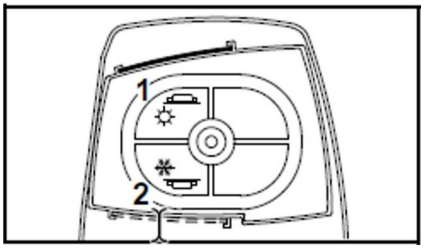
Below +10°C Procedure:
●Loosen retaining screw (1) extract valve reinsert valve (2) with notch facing downward retighten screw (1).
Valve status: Winter mode activated.
Above +10°C Procedure:
●Loosen screw (1) extract valve reinsert valve (2) with notch facing upward retighten screw (1).

At temperatures below +10 ° C (G444, G466/PRO)



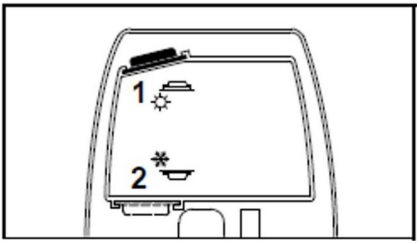
Below 50°F (+10°C): Remove the carburetor cover; move the shutter from Summer Position (1) to Winter Position (2). Heated air mixes with cold air around the cylinder, preventing carburetor icing.
Above 68°F (+20°C): Return the shutter to Summer Position (1) to avoid engine operation issues and overheating.

At temperatures below +10 °C (G660/PRO)



Remove the carburetor cover.
Slide the valve (1) from Summer to Winter mode (2).Draws warm air near the cylinder (no carburetor heating required).
Warning: Above +20°C: Reset valve to Summer mode! Risk of engine damage due to overheating.
Reinstall the cover and secure fasteners.

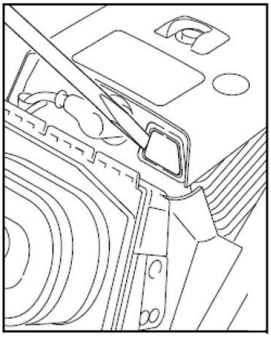
At temperatures below +10 °C (G888)



Remove carburetor cover.
Shift valve from Summer (1) to Winter mode (2).
Draws warm air near the cylinder to prevent freezing.
Warning: Above +20°C, reset valve to Summer mode! Engine damage risk from overheating.

At temperatures below -10 °C (G888/PRO)

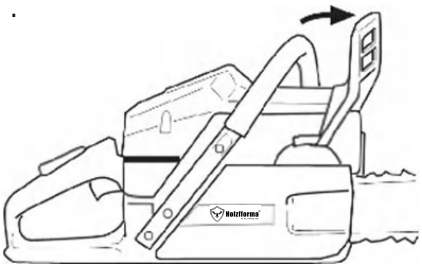
For operation below -10°CIn extreme winter conditions (frost/ snow below -10°C), remove the insert from the cover along the perforated contour to allow warm air near the cylinder to enter, preventing ice in the air filter and carburetor. If the chainsaw is frosted, after starting, run at high idle speed until reaching operating temperature (release the chain brake). Note: Air intake preheating accelerates filter contamination– clean more frequently.



Motor start/stop (G382,G272,G365,G372/XP/XT/PRO,G288,G395XP, G3120)

Cold engine

Activate the chain brake by pushing the brake handle forward .



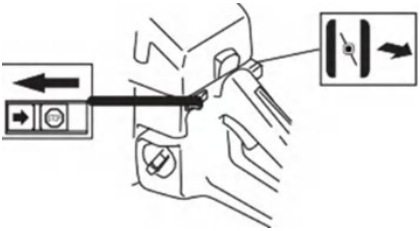
Ignition: Turn the ignition switch to the left

Choke position:

Set the choke to "Closed" by pulling the choke lever out from the saw body.

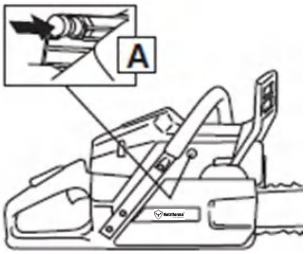
Throttle trigger preset:

Pull the throttle trigger to the start-lock position (preset within the handle).



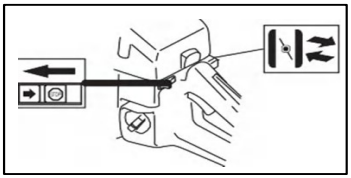
Decompression valve (if equipped)

Press the valve to reduce cylinder pressure for easier starting.Always use the valve during startup; it resets automatically after ignition.

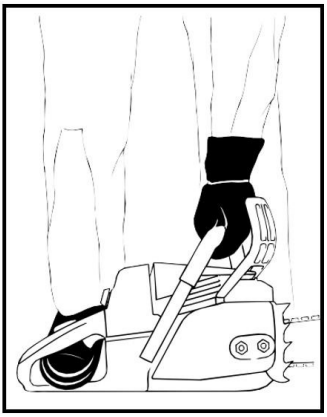


Warm engine startup

Follow the standard startup sequence without closing the choke.
Set the throttle trigger to start position by:
Briefly moving the choke plate to closed position then reopening, OR
Pressing the throttle lock button (if equipped).

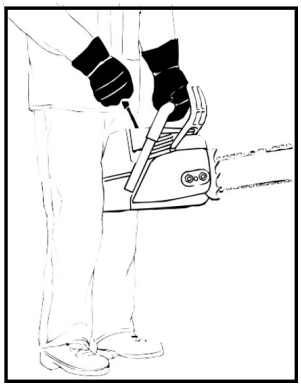


How to start the chainsaw



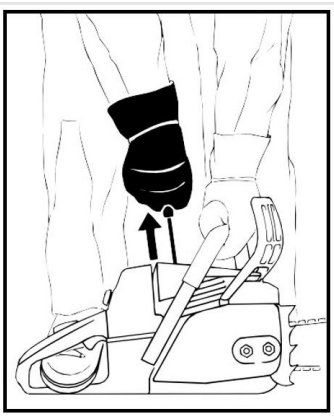
Ground starting

Position the saw: Place it firmly on flat ground, ensuring the chain does NOT contact any surface.
Grip the front handle: Hold the front handle tightly with your left hand.
Secure rear handle: Place your right foot into the rear guard and position your thumb under the handle.



Secure the saw between legs

Position the rear handle between knees/thighs.
Grip the front handle firmly with left hand (thumb wrapped under).



Pull-start operation

Pull the starter grip:
Slowly pull until resistance is felt , then yank sharply.

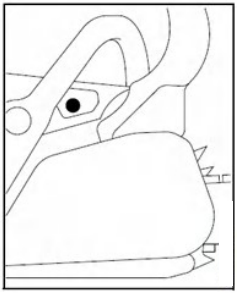
CAUTION:
Do NOT fully extend the starter cord – risk of breakage!
Guide the cord back smoothly; avoid rapid retraction.

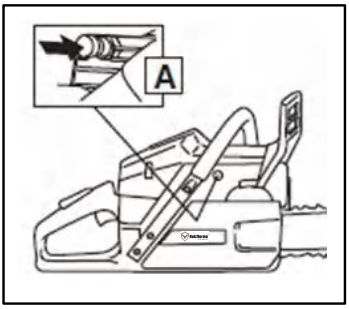
For new/long-stored engines:
If no primer bulb: Pull starter cord repeatedly until fuel system is primed.

Starting the Chainsaw

Clear the work area – Ensure no obstacles within chain rotation range.
Verify chain brake engagement – Confirm the chain brake is activated.

Decompression Valve Operation



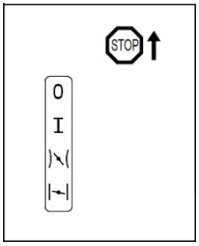


Side view shows decompression valve (marked A).
Press the valve to release cylinder pressure before starting.
Valve auto-resets after ignition – must be manually pressed before each cold start.

Starting / stopping the motor

G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO

Combination lever positions



The four positions of the Master Control lever

0 = Engine off – ignition is switched off.

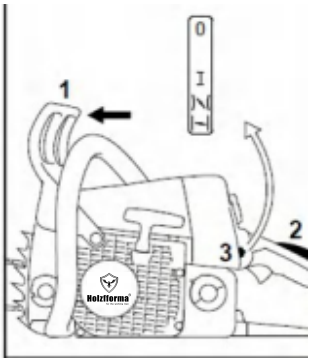
I =Normal run position – engine runs or can fire.

Tomove the Master Control lever from to)\(or |~|, press down the throttle
trigger interlock and squeeze throttle
trigger at the same time.

)\(=Warmstart this position is used to start a warm engine. The Master Control lever moves to the normal run position as soon as the throttle trigger is squeezed.

|~| =Cold start – this position is used to start a cold engine.

Safety Startup Rules



●Push the front handle guard (1) forward
Activates the chain brake (blocks chain rotation).

●Press and hold both the throttle trigger lock (2) and throttle trigger (3) Keep both controls engaged while adjusting the combination lever (3).

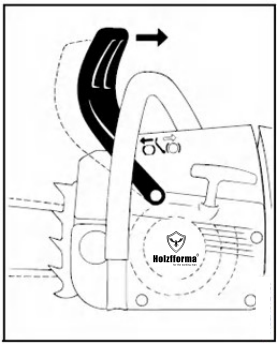
After the first ignition switch

(G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO)

Position the lever to the start preset on the throttle control.
Startup procedure
Engage the chainsaw immediately after engine ignition.

Engine shutdown

Press both the throttle lock (4) and throttle trigger to move the combination lever (3) to OFF.
Engine enters idle mode upon shutdown.
Critical:The engine must return to idle immediately after startup to avoid lockout.Activate chain brake before starting to prevent housing/ brake damage.



Apply throttle only after releasing the chain brake.
Confirm chain brake is fully disengaged.
Engage the front hand guard by pulling it toward the rear handle (left-hand operation).
Chain brake unlocked – chainsaw is ready to operate.
NEVER run the engine with chain brake engaged (chain stationary) – causes clutch/brake damage within minutes.

At very low temperatures

Let the engine warm up by briefly applying throttle for 1-2 minutes.

Engine shutdown

Move the combination lever to Stop 0.

If the engine fails to start

After failed ignition (due to delayed lever adjustment from choke closed):

- Set the combination lever to Stop 0.
- Remove the spark plug (refer to " Spark Plug" section).
- Dry the plug; pull the starter cord 5-6 times to ventilate the combustion chamber.
- Reinstall the spark plug.
- Restart in Start position.

Operating instructions

New Chainsaw Operation & Break-in Period

Avoid high RPM no-load operation (without cutting) until 3rd fuel refill to prevent overstress.

Moving components require seating through controlled friction during break-in.

Engine reaches peak power after 5-15 fuel refills.

Mix fuel strictly per ratio chart using 2-stroke oil from certified manufacturers.

While working

Avoid unauthorized carburetor adjustments for perceived power gains, as improper tuning may cause severe engine damage. Always refer to the "Carburetor Adjustment" section for authorized procedures. Throttle operation must only be performed when the chain brake is fully disengaged. Operating the chainsaw with the chain brake engaged will rapidly damage critical components, including the drive sprocket, chain drive system, crankshaft, and lubrication mechanisms.

Check chain tension regularly:

Regularly inspect chain tension to ensure safe operation. New chains require daily tension checks during the initial break-in period to accommodate stretching and wear.

When cold:

Ensure the chain fits snugly against the lower guide bar edge while allowing manual movement. Retension if needed (refer to " Chain Tensioning").

At operating temperature:

Chain elongates and loosens under heat. Verify drive links remain seated in the guide bar groove to prevent derailment. Retension the chain (see "Chain Tensioning"). Post-cooling, chain contraction may occur. Failure to loosen overtensioned chains risks crankshaft and bearing damage.

After full-load operation:

Idle the engine for 3-5 minutes to dissipate heat via airflow, reducing thermal stress on ignition and carburetion systems.

After Work Maintenance

If the chainsaw chain was tensioned during high-temperature operation, always release chain tension before storage. During cooling, the chain contracts naturally. Failure to loosen tension risks permanent damage to crankshaft bearings.

Short Break Protocol

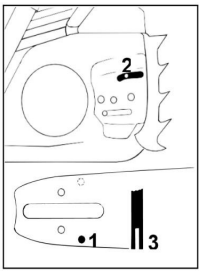
Allow the engine to cool completely . Store the unit with a full fuel tank in a dry, ignition-free area until next use.

Chain Lubrication Oil Adjustment

(G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO, G382, G272, G365, G372XP/PRO, G288, G372XT, G395XP,G3120)

The adjustable oil pump (specialized equipment) regulates lubrication flow via the adjusting screw. Ensure the chainsaw is operated with dedicated chain oil at all times to maintain proper chain lubrication.

Guide Bar Maintenance

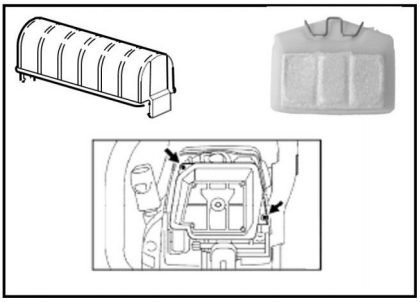


- Rotate the guide bar 180° after each chain sharpening or replacement to prevent uneven wear, especially at the pivot area and lower cutting edge.
- Clean all oil ports (1) and outlets to ensure proper lubrication flow. Blockages risk chain seizure or accelerated wear.
- Measure groove depth on the most worn cutting edge section using a wear gauge. Replace the guide bar if below specifications:

Chain pitch	Min. groove depth
3/8" P	5.0 mm
1/4"	4.0 mm
3/8"; 0.325"	6.0 mm
0.404"	7.0 mm

Regularly inspect and clean the drive link groove (3). Accumulated debris causes drive links to rub against the groove base, misaligning tie straps and reducing cutting precision.

Air filter system



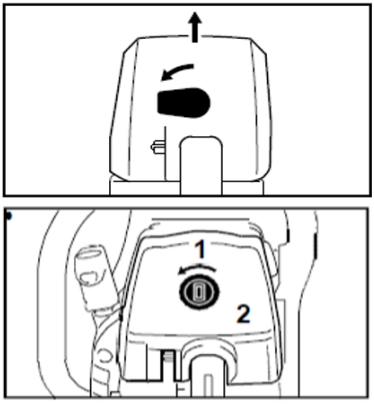
Interchangeable filters adapt to operational conditions. Gasoline chainsaws support wool filters or polymer mesh filters based on model specifications.
The upper right displays two filter types: fibrous strip and gridded unit. Lower left cross-section shows internal assembly with arrow marking filter housing location.

Air Filter Cleaning

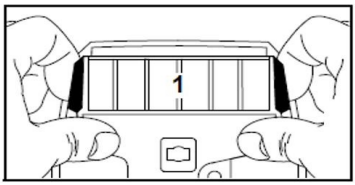
When experiencing gradual engine power loss:

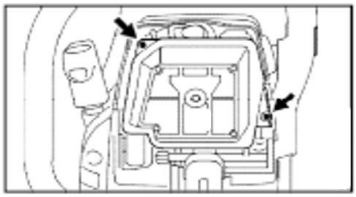
(G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO, G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO)

●Depress throttle lever latch & trigger, set combination lever to OFF position (arrow indicated)



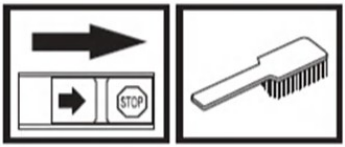
●Rotate knob 90° counterclockwise to remove cover housing
●Permanently replace damaged filters
●Clean peripheral filter components
●Remove coarse debris from filter surface

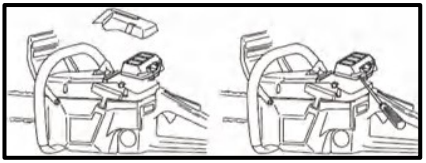




●Filter Replacement
Remove air filter (1) with index finger
Retract handle with thumb on housing
Prohibit tool usage during installation/ removal
●Cleaning Procedure
Blow compressed air through clean-side ports
For adhesive contamination: Rinse in non-flammable detergent (e.g. warm soap solution) and air-dry
●Reinstallation
Align filter with guide rails
Ensure positive engagement in retention brackets

If you want to clean the air filter (G382,G272,G365,G372/XP/XT/PRO,G288,G395XP,G3120)





●Turn off the chainsaw.Remove the air filter cover.

●Clean the air filter with a soft brush or compressed air.Make sure the air filter is completely dry.If the air filter is wet, it can be dried in a warm environment.If the air filter is damaged, it must be replaced.

●Notes:When cleaning the air filter, ensure that it is not damaged. If the air filter cannot be cleaned properly, it should be replaced.

Carburetor tuning

Factory Presets

Factory pre-calibrated carburetor ensures optimal air-fuel mixture across all operational loads. Main adjustment screw regulates fuel delivery volume. Improper calibration may cause drive system damage from inadequate lubrication or thermal overstress.

Professional Service Requirement

All tuning operations must be performed exclusively by HOLZFFORMA-certified technicians.

Spark Plug Maintenance

Perform spark plug inspection when experiencing:Power deficiency | Hard starting | Irregular idle

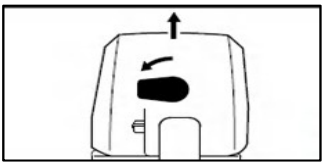
●Scheduled replacement: Every 100 service hours

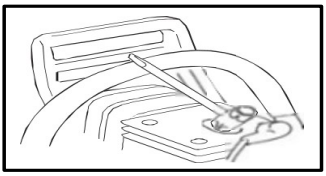
●Immediate replacement required for electrode erosion

●Use manufacturer-specified plug type only

Removing the spark plug

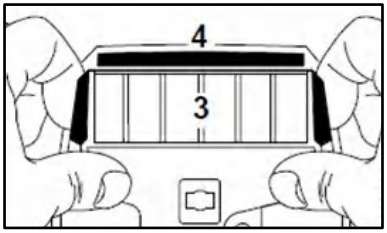
●Engage throttle trigger lockout. Depress throttle trigger while setting combination lever to LOCK





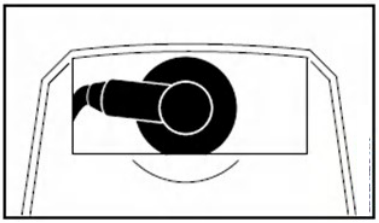
●Rotate safety knob 90° counterclockwise

●Remove carburetor housing cover assembly



●Detach air filter assembly (3). Index finger lifts along handle axis , thumb stabilizes housing

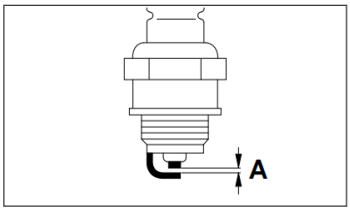
●Remove choke valve (4)



●Tighten the spark plug connector.

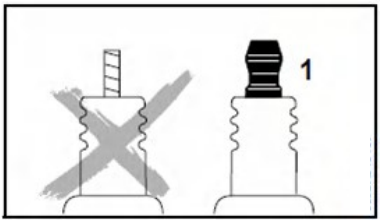
●Unscrew spark plug

Spark plug inspection



- Clean contaminated spark plug
- Verify electrode gap (A), adjust as required
- Eliminate contamination sources:

Excessive 2-stroke oil in fuel mixture
Clogged air filter element
Improper operating environments



Mounting the spark plug

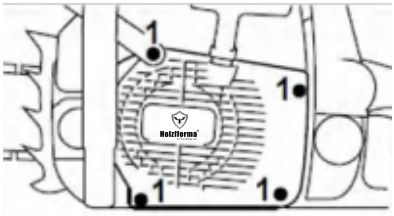
- Securely install spark plug
- Reassemble choke valve & air filter
- Secure carburetor cover

Critical Notice: For spark plugs with separate terminal nuts (1), securely tighten nuts to prevent arcing risks

If the engine does not run satisfactorily despite a cleaned air filter and correct carburetor adjustment, you should contact a specialist service center. HOLZFFORMA recommends that maintenance and repair work should only be carried out by a specialist HOLZFFORMA dealer.

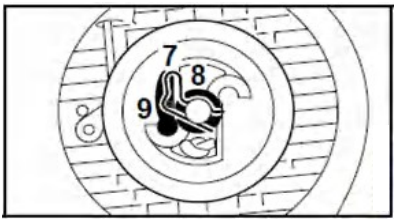
Starter Rope & Return Spring Replacement

G180/E/PRO,G185/E/PRO,G215/E/PRO, G255/E/PRO,G366/PRO,G260/PRO,G028, G388,G444,G466/PRO,G660/PRO,G888/PRO



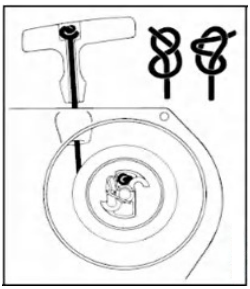
- Loosen mounting bolt:Release marked bolt (1)
- Remove protective guard:Lift front-left guard upward
- Disassemble fan cover:Detach fan cover lower section from crankshaft housing

Standard versions have



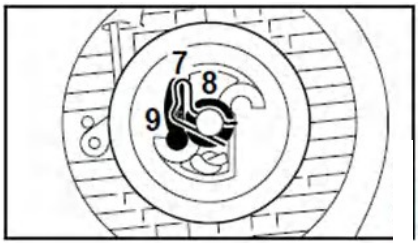
- Compress spring clip.Apply pressure to spring clip (7)
- Remove cable drum with washer (8) and retaining ring (9)

WARNING: Recoil spring may eject abruptly - wear eye protection



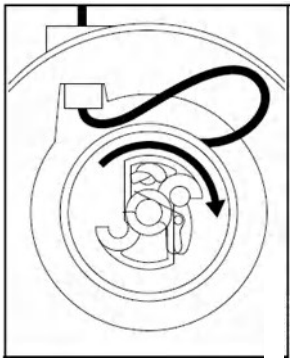
●Remove cable residue.Clear old starter rope fragments from . throttle trigger and guide channel.
●Install new starter rope.Thread new rope through starter pulley, secure with half-hitch knot.
●Terminate rope end.Route opposite end through handle conduit.Secure with figure-eight knot at anchor point.

Mounting starter pulley



●Lubricate starter pulley bearing bore with anhydrous grease
●Slide starter pulley onto shaft, rotate bidirectionally until recoil spring tang engages
●Reinstall spring (9) into starter housing
●Install washer (8) onto shaft
●Press retaining clip (7) through bearing race with pliers - must be oriented clockwise per diagram.

Return spring tension



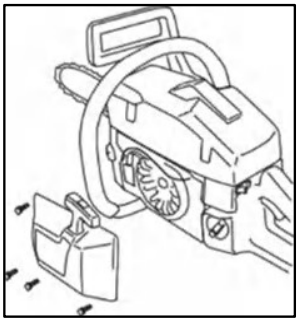
●Create starter loop.Form loop with unwound rope, rotate starter pulley 6 turns per arrow.
●Secure pulley position.Remove twisted rope section and straighten.
●Disengage pulley lock
●Allow rope to wind onto pulley. Maintain controlled retraction speed
●Verify handle alignment.Handle must fully seat in guide bushing. If misaligned, adjust spring via tension screw.
●Test pulley rotation.Pulley must rotate freely at full extension. If not: Over-tensioned spring (fracture risk) Under-tensioned spring (disengagement risk)
●Trim excess rope wraps.Remove unnecessary coils from pulley.
●Reinstall fan housing.Attach cover to crankcase assembly.

Starter Spring Replacement

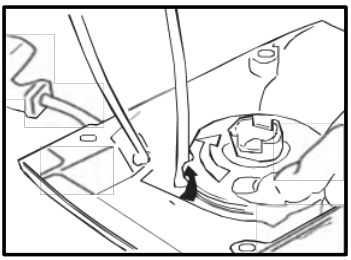
●Starter pulley disassembly
Carefully remove damaged spring parts
Lubricate new spring with non-penetrating oil.
WARNING: Spring fragments remain energized - wear eye and hand protection.
●Position replacement spring
Align spring hook with fan housing tab
Use installation tool provided.
●Tool insertion
Insert flat tool (screwdriver/punch) into guide slot.
Push spring into housing until tool releases.
●Remove installation tool
Extract tool through fan housing opening.
●Reassembly
Reinstall starter assembly components
Tighten all fasteners securely
Reattach fan housing cover.

Replacing the starter rope / spring (G382,G272,G365,G372/XP/XT/PRO,G288,G395XP,G3120)

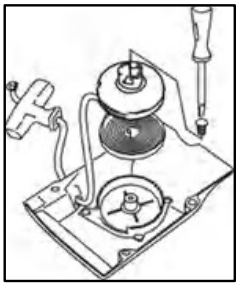
●Loosen starter mechanism fasteners
Remove screws securing starter assembly to crankcase.
Detach starter assembly.



●Prepare starter rope
Pull rope 30cm (12") and hook into pulley notch.
Release recoil spring to allow controlled pulley rotation.



●Rope replacement procedure
Remove center screw and extract pulley.
Insert new rope end into pulley slot
Wind 3 full wraps around pulley
Engage pulley with recoil spring tang
Reinstall center screw
Thread rope through starter housing port.
Attach starter handle and secure with stopper knot.



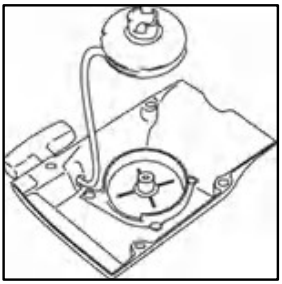
Recoil **spring tension**
Seat the rope in the pulley notch, rotate starter pulley clockwise 2 full turns
Note! Ensure pulley can rotate 1/2 turn when pulling the rope

Recoil Spring Replacement

●Lift the starter pulley
(Refer to "Damaged Starter Rope Replacement" section)
Remember: Recoil spring coils inside housing

●Extract recoil spring housing
Remove spring-loaded housing from starter assembly

●Lubricate and reinstall
Apply light oil to spring
Reinstall housing into starter
Mount pulley and tension spring



Installing the starter

●Prepare starter assembly
Pull starter rope fully out and secure end to crankcase
●Engage pulley with flywheel
Gradually release rope to allow pulley teeth to mesh with flywheel
●Secure starter mechanism
Install and tighten all mounting screws

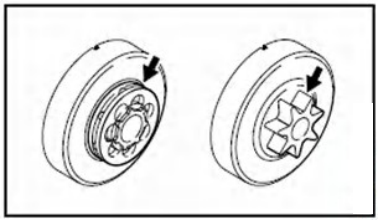
Storage(+30 Days)

●Fuel system drainage
Drain fuel tank in ventilated area
Dispose fuel per environmental regulations
●Engine preparation
Start engine and allow idle until shutdown
●Cutting attachment removal
Remove guide bar & saw chain
Clean and apply protective coating
●Comprehensive cleaning
Clean entire unit, focus on:
Cylinder fins
Air filter assembly
●Bio-oil precautions
●When using biodegradable oil:
Fill tank completely with stabilized bio-fuel
Secure storage
●Store in dry, locked location
Prevent unauthorized access (e.g. childproof locks)

Chain Sprocket Inspection & Replacement

●Remove chain sprocket cover, saw chain and guide bar
●Disengage chain brake - Pull guard toward crankcase

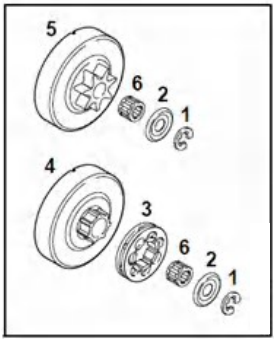
Replace chain sprocket



●After 2 chains wear out (or earlier)
●If wear indicator (arrow) exceeds 0 .5mm depth
●Use wear gauge for verification
●Maintenance Tip:Sprocket wear reduction.Alternate between two chains during operation.

Disassembly Guide

G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO



●Retaining clip (1) removal.Press and extract using flat screwdriver
●Remove spacer washer (2)
●Extract chain sprocket idler (3)
●Inspect guide rim on clutch drum (4).Replace if excessive wear present

Reassembly Protocol

●Reinstall clutch drum.Ensure positive engagement
●Remove coupling drum/sprocket assembly.Detach from crankshaft

Installation of Drive Sprocket & Sprocket Rim

G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO,G028,G388,G444,G466/PRO,G660/PRO,G888/PRO,G382,G272,G365,G372/XP/XT/PRO,G288,G395XP,G3120

●Prepare crankshaft components.
Clean and lubricate crankshaft end & needle roller bearing cage.

●Install bearing cage.Align needle roller bearing cage on crankshaft journal.

●Assemble clutch assembly.Mount clutch drum and drive sprocket
Rotate one full turn to engage oil pump drive chuck.

●Orient sprocket rim.Install sprocket rim with cavities facing outward.

●Secure washers.Reinstall flat washer and lock washer.

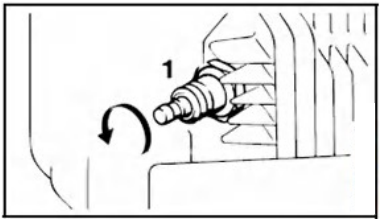
●Temporary rim removal.Remove sprocket rim (3).Inspect clutch drum wear.

●Check sprocket rim profile (4) on clutch drum.Replace drum if excessive wear is observed.

●Disassemble coupling assembly.
Remove coupling drum/drive sprocket (5) with bearing cage.

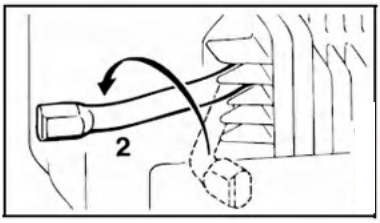
●Chain brake safety operation.
Depress fuel control lock before servicing chain brake system.

Engine Disassembly (G111/PRO)

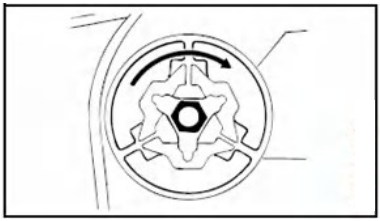


●Remove spark plug boot.
Disconnect ignition lead from spark plug.

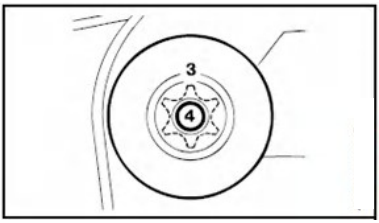
●Extract spark plug.Use socket wrench to remove spark plug.



●Release fixed plate.
Press plate (2) inward toward cylinder.
Rotate plate 180° counterclockwise.
Turn coupling clockwise until locked.



●Remove coupling assembly
Unscrew hexagonal coupling bolt (left-hand thread).
Detach coupling from crankshaft.



●Disengage drive components
Remove chain sprocket (3) and separator (4).
Clean and lubricate crankshaft journal & needle bearing.

Installation of Sprocket & Bearing Assembly

●Mount components to crankshaft
Install needle roller bearing cage and sprocket.

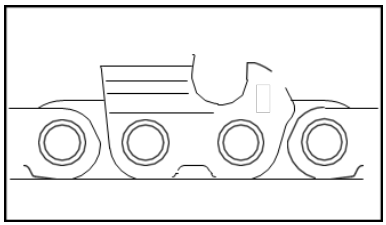
●Position coupling drum.
Rotate coupling drum counterclockwise onto crankshaft.
Secure coupling drum

●Tighten until fully seated
Stop lever and spark plug installation
●Pull stop lever from cylinder
Install and torque spark plug
●Connect ignition system
Press spark plug boot firmly onto plug

Saw Chain Maintenance & Sharpening

A properly sharpened chain penetrates wood with minimal feed force.
Critical Requirements:
●NEVER use dull/damaged chains
Causes: Excessive operator fatigue | Premature drive system wear | Irregular cutting patterns
●Remove resin and wood debris after each use
●Integrity checks
Inspect for:Cracks in drive links; Rivet deformation
●Worn components must match OEM specifications for:
Pitch dimensions
Wear pattern compatibility

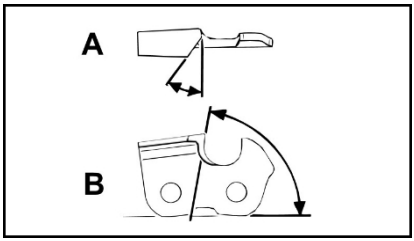
Safety Warning
Maintain original cutter angles and depth gauge clearances
Incorrectly filed depth gauges increase kickback risks during operation



Marking inch	Chain Pitch, mm
1/4 P	6,35
1/4	6,35
3/8 P	9,32
0.325	8,25
3/8	9,32
0.404	10,26

The diameter of the file is selected according to the pitch of the chain. When sharpening the saw, the angles on the cutting tooth must always be maintained.

Grinding angle and front angle

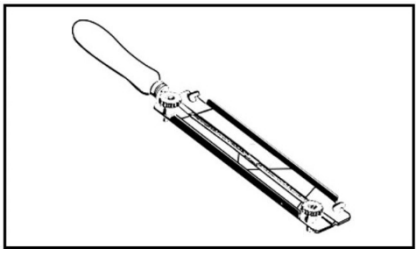


Sharpening Angle
A: HOLZFFORMA chains typically use a 30° sharpening angle. Chains designed for longitudinal sawing require a reduced 10° angle.
Front Angle
B: The correct front angle is automatically achieved when using the specified file holder and matching file diameter.

Shapes	Angle (°)A	B
Semi-chisel	30	75
Full-chisel	30	60

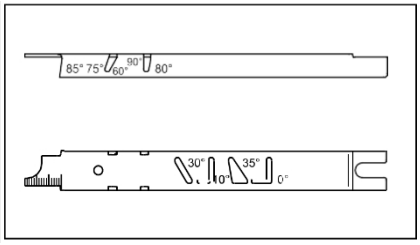
Critical note: All cutting teeth must maintain identical angles. Inconsistent angles will cause erratic chain movement, accelerated wear, and potential chain failure.

File Holder & Filing Gauge



Chainsaw chains must be hand-filed exclusively using the file holder. The file holder features pre-marked guides for maintaining proper filing angles.
Warning: Only use specialized chainsaw files. Standard flat files cannot properly engage with chain teeth due to their geometry and tooth profile.

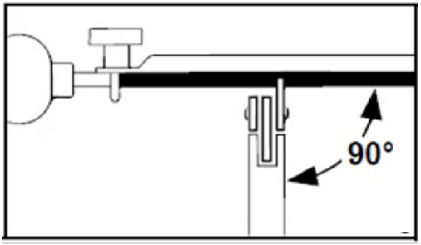
Angle Verification

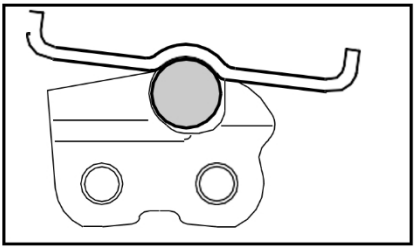


The filing gauge serves as a multi-functional tool for inspecting: filing angle, front angle, depth gauge height, tooth length, groove depth, and cleaning grooves/oil holes.

Proper Chain Sharpening Procedure

- Select filing tools according to chain pitch
- Secure guide bar if required
- Engage chain brake - Push hand guard forward
- To advance chain: Pull hand guard toward tubular handle to release chain tension
- Simultaneously activate chain brake via throttle trigger lockout
- Frequent light sharpening preferred - 2-3 additional file strokes usually suffice





- **File Guidance**

Maintain horizontal file alignment (perpendicular to guide bar) using angle markers on the file holder. Position the holder against cutter teeth and depth gauges.

- **Filing Direction**

Apply filing pressure only during forward strokes. Lift the file on return strokes.

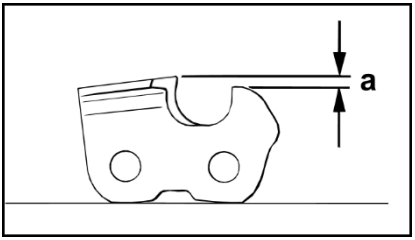
- **Critical Precautions**

Never file tie straps or drive links. Rotate the file slightly during use to prevent uneven wear.

● **Debris Removal**
Clear filing residue with hardwood sticks.
● **Inspection**
Verify tooth geometry using filing gauge templates.
● **Cutter Length Requirements**
All cutting teeth must maintain identical length. Varied lengths cause uneven cutting height, resulting in erratic chain movement and potential breakage.
File all cutters to match the shortest tooth's depth. For precision, use electric chain grinders in workshop conditions.

Caution: Wear cut-resistant gloves during filing operations.

Depth Gauge Clearance Adjustment

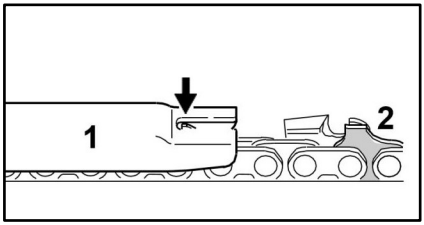


Distance "a" denotes the preset clearance between depth gauge and cutter tip.
The depth gauge regulates cutter penetration depth – determining chip thickness during operation.
When cutting softwood in frost-free conditions: Increase depth gauge clearance to 0.2 mm (0.008").
Note: Maintain consistent depth gauge settings across all cutters.

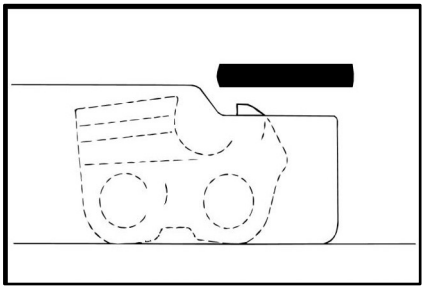
Chain pitch		Limiter depths Distance (a)	
Inch	(mm)	mm	(inch)
1/4	(6,35)	0,65	(0.026)
3/8 P	(9,32)	0,65	(0.026)
0.325	(8,25)	0,65	(0.026)
3/8	(9,32)	0,65	(0.026)
0.404	(10,26)	0,80	(0.031)

Depth Gauge Filing

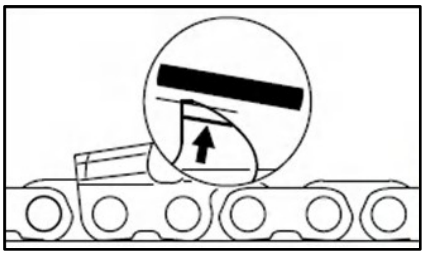
The depth gauge clearance decreases during cutter tooth filing. Always verify the clearance after each filing operation.



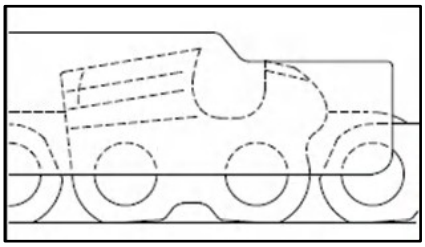
● Position a saw chain gauge (1) matching the chain pitch on the cutter being inspected. If the depth gauge protrudes beyond the gauge, file down the depth gauge.
Process bumper drive links (2) (marked for maintenance) together with depth gauges. Do not file other parts of bumper drive links, as this may increase the chainsaw's kickback tendency.



●Process the depth gauge together with the file guide.



●File the depth gauge on the slope parallel to the usage mark (arrow indicated). Ensure the highest point of the depth gauge does not shift backward.
Excessive lowering of the depth gauge during filing significantly increases chainsaw kickback risk.



●After filing cutter teeth, always verify the depth gauge clearance using a chain pitch-specific gauge tool (1). If the depth gauge protrudes beyond the tool's reference plane, file it down to maintain proper alignment with the cutter's working surface. This prevents excessive chain bite and reduces kickback hazards.

●Process bumper drive links (marked with maintenance indicators) simultaneously with depth gauges. Never file unmarked areas of these links, as improper modification directly increases the chainsaw's kickback tendency during operation.

●Apply specialized chain lubricant (toxic compound) thoroughly during tension adjustments. For long-term storage, clean residual lubricant from guide bar grooves and apply anti-corrosion oil to prevent chain degradation.

Inspection and Maintenance Entrustment

HOLZFFORMA recommends that inspection and maintenance work should only be carried out by a specialized HOLZFFORMA dealer.

Wear Reduction & Damage Prevention

Adherence to operating values specified in the manual prevents premature wear and damage. Operate, maintain, and store the equipment strictly according to the manual.
Users shall bear full responsibility for damages caused by violating safety/ operational guidelines, including but not limited to:

●Unauthorized modifications to the product.

●Use of non-approved/ incompatible/low-quality tools or accessories.

●Equipment misuse or participation in sports competitions.

●Operation with defective components.

Works on technical service

Machine Servicing by HOLZFFORMA-Certified Technicians Only
User liability applies if neglected, covering:

- Drive system damage from inadequate maintenance (e.g., air/ fuel filters), improper carburetor adjustment, or insufficient cooling air intake system cleaning (manifold, cylinder liner).
- Corrosion due to improper storage.
- Damage from substandard replacement parts.

Wear-Prone Components

Replace the following parts periodically based on usage intensity and duration:

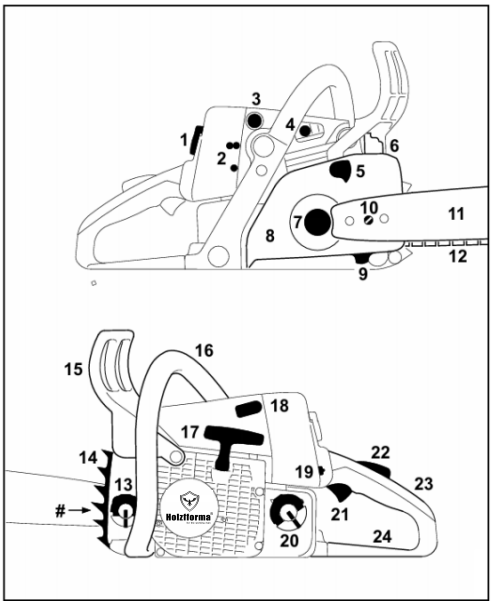
- Saw chain & guide bar
- Drive components (clutch, drum, sprocket)
- Filters (air, oil, fuel)
- Starter assembly
- Spark plug
- Vibration dampeners

Technical Service Requirements

Perform all maintenance tasks listed in the "Maintenance Instructions" section regularly. Contact authorized dealers if unable to execute. HOLZFFORMA recommends technical work be conducted by HOLZFFORMA -certified personnel.

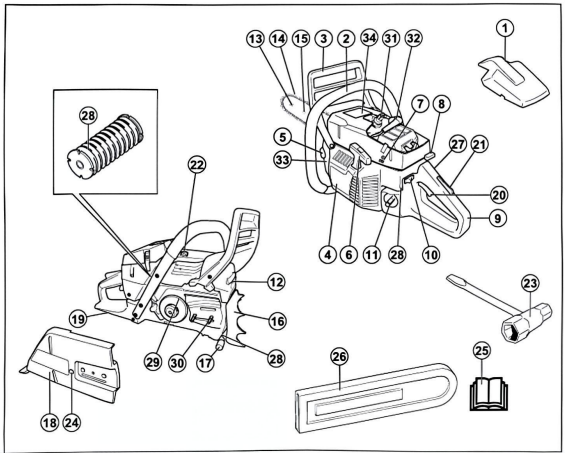
Parts Overview

(G180/E/PRO,G185/E/PRO,G215/E/PRO,G255/E/PRO,G366/PRO,G260/PRO, G028,G388,G444,G466/PRO,G660/PRO,G888/PRO)



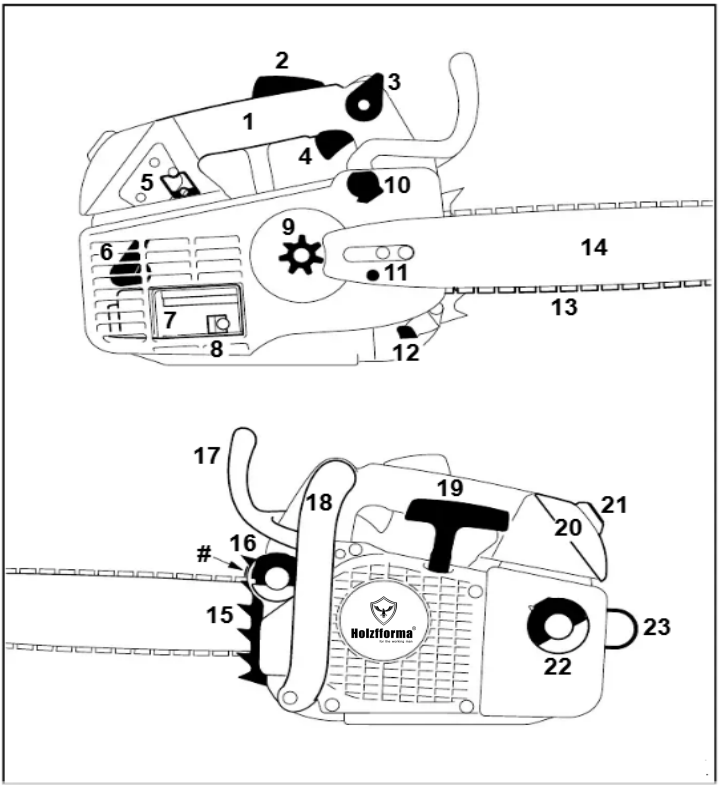
1, Carburetor Box Twist Lock
2, Carburetor Adjusting Screws
3, Fuel Pump
4, Decompression Valve
5, Chain Brake
6, Muffler
7, Chain Sprocket
8, Chain Sprocket Cover
9, Chain Catcher
10, Chain Tensioner
11, Guide Bar
12, Oliomatic Saw
13, Oil Filler Cap
14, Bumper Spike
15, Front Hand Guard
16, Front Handle (Handle bar)
17, Starter Grip
18, Spark Plug Boot
19, Master Control Lever
20, Fuel Filler Cap
21, Throttle Trigger
22, Throttle Lockout
23, Rear Handle
24, Rear Hand Guard

(G382,G272,G365,G372/XP/XT/PRO,G288,G395XP,G3120)



1,Air filter cover
2,Front handle
3,Chain brake and front hand guard
4,Starter housing
5,Chain oil tank
6,Starter rope handle
7,Adjuster screws carburetor
8,Choke control
10,Start/stop switch
11,Fuel tank
12,Muffler
13,BAR sprocket
14,Saw chain
15,Guide bar
16,Spark plug
17,Chain catcher
18,Clutch cover
19,Right hand guard
20,Throttle trigger
21,Throttle trigger lockout
22,Decompression valve
23,Combination wrench
24,Chain tensioning screw
26,Vibration damping system
27,Brake band
28,Bar bolts
29,Spark plug cap
32,Spiked bumper

(G111/PRO)



1. Control Handle
2. Throttle Trigger Lockout
3. Master Control Lever
4. Throttle Trigger
5. Shutter
6. Spark Plug Boot
7. Muffler
8. Spark Arresting Screen
9. Chain Sprocket
10. Chain Brake
11. Chain Tensioner
12. Chain Catcher
13. Oilomatic Saw Chain
14. Guide Bar
15. Bumper Spike
16. Oil Filler Cap
17. Hand Guard
18. Front Handle (Handlebar)
19. Starter Grip
20. Carburetor Box Cover
21. Carburetor Box Cover Twist Lock
22. Fuel Filler Cap
23. Ring for Rope

TECHNICAL DATA

Engine model:	G180/E/ PRO	G185/E/ PRO	G215/E/ PRO	G111/PRO	G255/E/ PRO	G028
Cylinder Displacement(cm3) :	31.8	35.8	35.8	35.2	45.4	51.5
Power Output to ISO 7293(kw):	1.3	1.4	1.4	1.5	2.1	2
Cylinder Bore(mm):	38	39	39	40	42.5	46
Cylinder Stroke (mm):	28	30	30	28	32	31
Idle Speed(rpm):	2800	3000	3000	2800	2800	2700
Maximum Power Speed(rpm):	13500	13500	13500	13500	13500	13000
Fuel tank capacity(l):	0.25	0.396	0.396	0.37	0.47	0.5
Oil Tank Capacity(l):	0.145	0.28	0.28	0.24	0.2	0.3
Total Mass(excl. cutting equipment) (kg):	4	4.8	4.8	3.7	4.8	5.7
Chain pitch(inch):	3/8" P	3/8" P	3/8" P	3/8" P	3/8" P/.325	0.325
Chain gauge(inch):	.050 “	.050 “	.050 “	.050 “	.050 “	.063 ”
Cutting Length(cm) :	30,35,40	30,35,40,45	30,35,40,45	30,35,40	30,35,40,45	40,45,50
Sound power level (dBA):	112	112	112	110	111	113
Engine model:	**G260/ G260PRO**	**G366/PRO**	**G388**	**G444/PRO**	**G466/PRO**	**G660/PRO**
Cylinder Displacement(cm3) :	50.2	59	72.2	70.7	76.5	91.6
Power Output to ISO 7293(kw):	2.4	3.2	3.4	3.7	4.1	4.8
Cylinder Bore(mm):	44.7	47	52	50	52	54
Cylinder Stroke (mm):	32	34	34	36	36	40
Idle Speed(rpm):	2800	2800	2400	2500	3000±200	2500
Maximum Power Speed(rpm):	13000	13000	12500	12500	12500	12500
Fuel tank capacity(l):	0.46	0.685	0.68	0.8	0.8	0.825
Oil Tank Capacity(l):	0.29	0.325	0.36	0.325	0.325	0.36
Total Mass(excl. cutting equipment) (kg):	5	5.7	6.3	6.2	6.5	7.8
Chain pitch(inch):	0.325	3/8"	3/8"	3/8"	3/8"	3/8"
Chain gauge(inch):	.063 ”	.063 ”	.063 ”	.063 ”	.063 ”	.063 ”
Cutting Length(cm) :	40,45,50	40,45,50,60	40,45,50,60	40,45,50,60	50,63,70,80,90	50,63,70,80,90
Sound power level (dBA):	113	114	113	112	113	114

Engine model:	G888/PRO	G382	G372/PRO G365/PRO	G372XP/XT/ PRO	G272	G288
Cylinder Displacement(cm3):	121.6	50.2	65	70.7	72	87
Power Output to ISO 7293(kw):	6	2.2	3.2	3.6	3.4	4.2
Cylinder Bore(mm):	60	44	48	50	52	54
Cylinder Stroke (mm):	43	34	36	36	34	38
Idle Speed(rpm):	2800±200	2700	2800	2800	2500	2800
Maximum Power Speed(rpm):	11000	12500	11500	11500	12000	12500
Fuel tank capacity(l):	1.3	0.45	0,77	0,77	0.75	0.9
Oil Tank Capacity(l):	0.7	0.26	0,42	0,42	0.45	0.5
Total Mass(excl. cutting equipment) (kg):	10.3	5.2	6.6	6.3	6.4	7.8
Chain pitch(inch):	3/8"/.404"	0.325"	3/8"	3/8"	3/8"	3/8"
Chain gauge(inch):	.063"	.050"/.058"	.058"/.063"	.058"/.063"	.058"/.063"	.058"/.063"
Cutting Length(cm):	53,63,75,90, 105	33,38 ,41,46, 51	45,50,63,70	45,50,63,70	45,50,63,70,80	50,63,70,80
Sound power level (dBA):	116	115	119	119	116	117

Engine model:	G395XP/ PRO	G3120/PRO				
Cylinder Displacement(cm3):	93.6	118.8				
Power Output to ISO 7293(kw):	4.3	5.8				
Cylinder Bore(mm):	56	60				
Cylinder Stroke (mm):	38	42				
Idle Speed(rpm):	2800	2500				
Maximum Power Speed(rpm):	12000	12000				
Fuel tank capacity(l):	0.9	1.25				
Oil Tank Capacity(l):	0.5	0.7				
Total Mass(excl. cutting equipment) (kg):	8.2	9.8				
Chain pitch(inch):	3/8"	.404"				
Chain gauge(inch):	.058"/.063"	.063"				
Cutting Length(cm):	45,50,60,70,90 ,106	60,70,90,106				
Sound power level (dBA):	115	116				

WARRANTY CONDITIONS

By presenting this warranty card, the seller confirms the right to free of charge elimination of faults that occur in the product due to the manufacturer's defect within the warranty period.
FARMERTEC Service Centers will only consider warranty claims if the warranty card is correctly and completely filled out in the prescribed form and the documents required for warranty repair are provided.
The warranty period of the FARMERTEC product is 12 months and is calculated from the date of purchase.
All maintenance work must be carried out in accordance with the operating instructions supplied with the product. If the work cannot be carried out by the user himself, it must be entrusted to a specialized service center authorized by FARMERTE. Failure to observe this condition as well as the instructions and safety precautions may result in malfunctions for which the user is responsible. These include:
Damage to the drive train due to untimely or insufficient maintenance (e.g. air or fuel filter), incorrect carburetor setting or insufficient cleaning of the air cooling system;
Damage or defects caused by the use of an incorrectly prepared fuel mixture;
Modifications to the design that are not authorized by FARMERTEC, including the use of the product with combinations of cutting tools and/or guards that are not authorized by the manufacturer;
Use of the product for other than its intended purpose.
Malfunctions due to use of the product with defective parts.
THE WARRANTY DOES NOT APPLY:
Products with mechanical damage (cracks, chips, melting) and damage caused by exposure to high or low temperatures, aggressive media and high humidity (working in the rain, cleaning with water, etc.), as well as damage caused by improper storage (corrosion, etc.);
Parts and assemblies subject to natural wear and tear and classified as wearing parts according to the Operating Instructions (filters, guide bars,saw chainsaw,chain drums, springs, starter elements, lubricants, oil seals, rubber seals, etc.);
Products that have prematurely failed due to natural wear and tear caused by excessive use (commercial of household tools, rental, etc.).
In case any condition mentioned in the guarantee card is recognized as non-compliant with the law, its invalidity does not affect the validity of other conditions.
Please read this warranty card and the operating instructions carefully before using the product.

Warranty Card

Owner Information:

Name: _____Phone: _____

Address: _____ Email: _____

Product Details：

Product:_____ Model: _____Serial No.: _____

Retailer: _____Purchase Date: _____Inv No.:_____

Holzfforma®

for the working man