



## Professional GLF 55-6

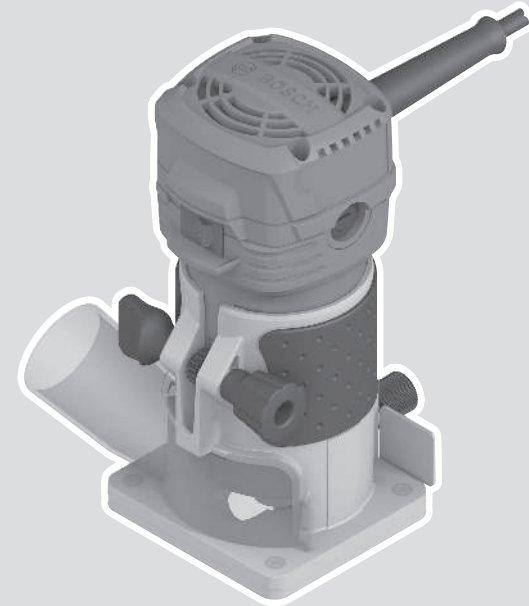
Robert Bosch Power Tools GmbH  
70538 Stuttgart  
GERMANY

[www.bosch-pt.com](http://www.bosch-pt.com)

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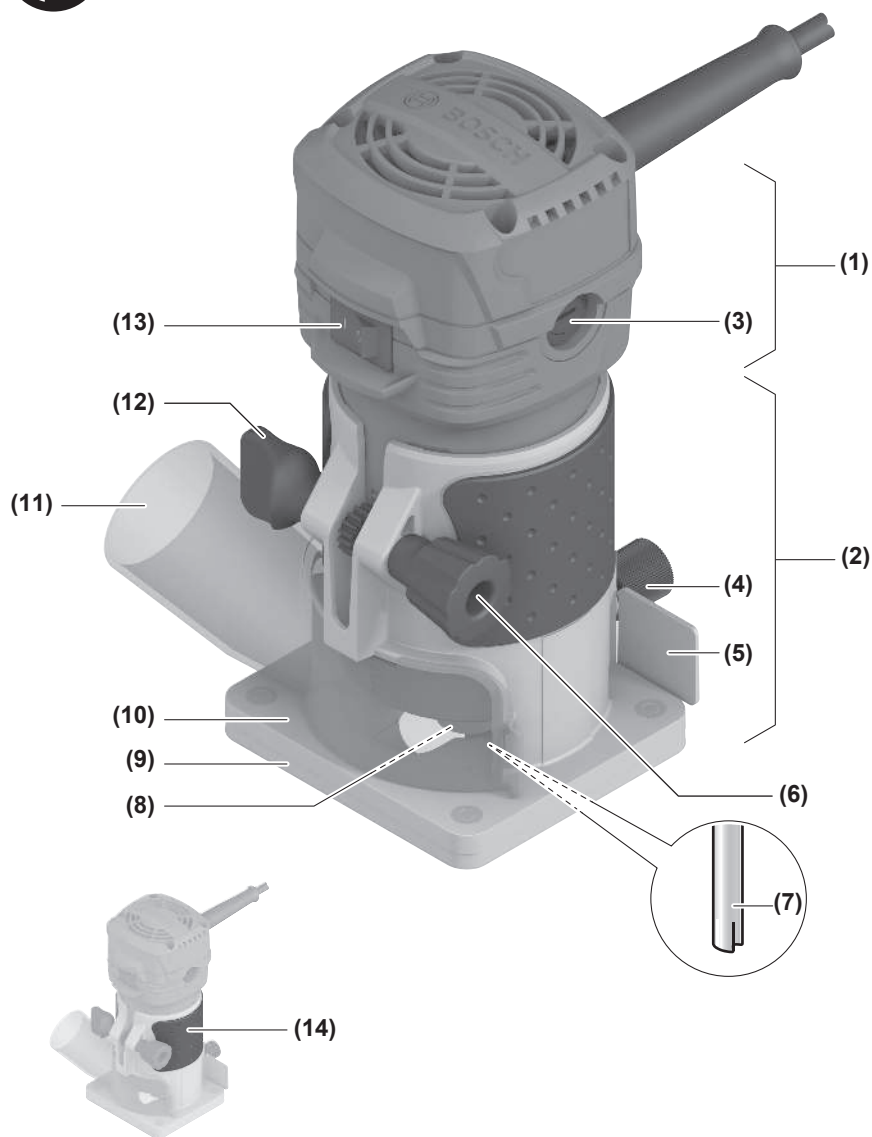
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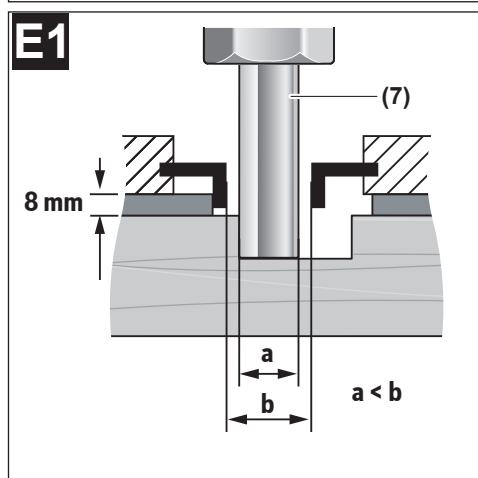
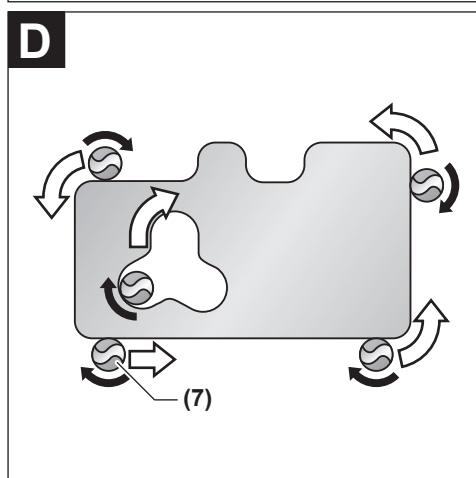
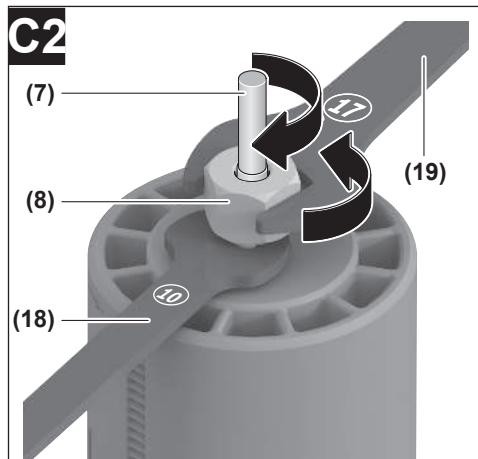
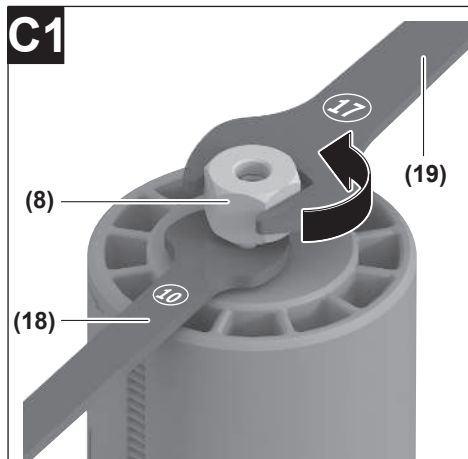
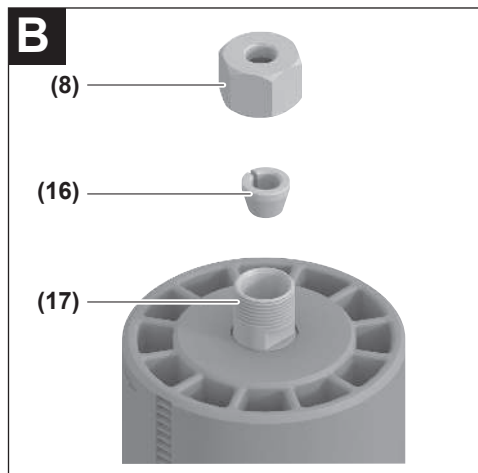
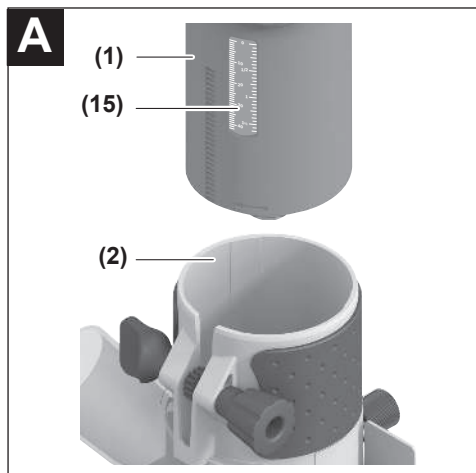


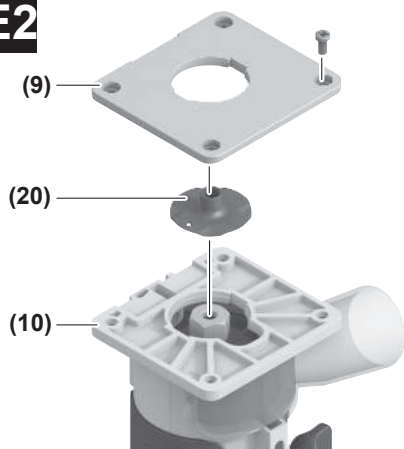
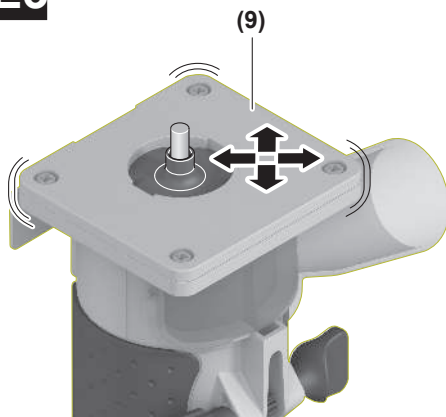
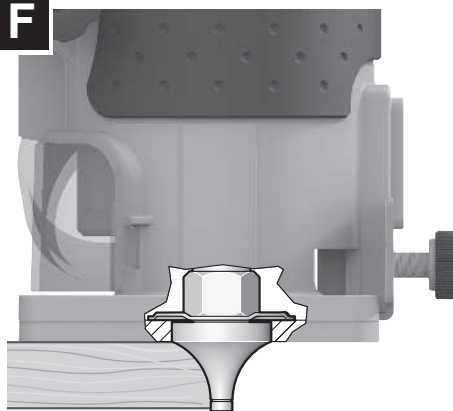
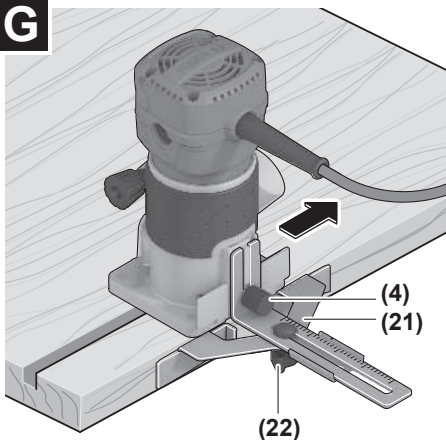
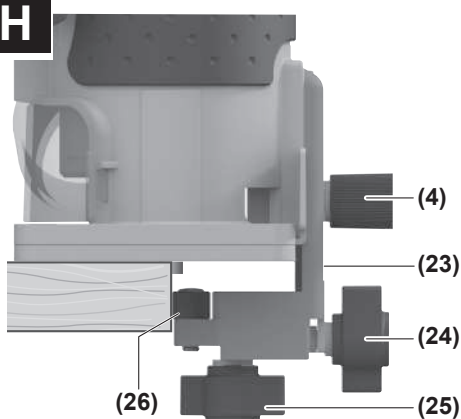
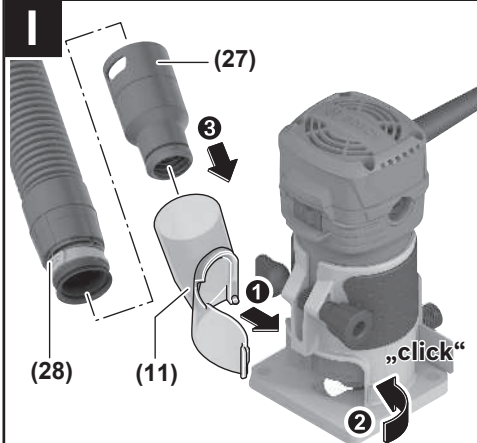
en Original instructions









**E2****E3****F****G****H****I**

# English

## Safety Instructions

### General Power Tool Safety Warnings

**⚠ WARNING** Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below 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 or 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 inatten-

tion while operating power tools may result in serious personal injury.

- ▶ **Use personal protective equipment. Always wear eye protection.** Protective equipment such as a 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 engaging 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 jewellery. Keep your hair and clothing 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.
- ▶ **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

#### 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 remove the battery pack, if detachable, 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.
- ▶ **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 and accessories. 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.
- ▶ **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

#### 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.

#### Safety instructions for edge routers

- ▶ **Hold the power tool by insulated gripping surfaces only, 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.
- ▶ **Use clamps or another practical way to secure and support the workpiece to a stable platform.** Holding the work by your hand or against the body leaves it unstable and may lead to loss of control.
- ▶ **The permitted speed of the cutting bit must be at least equal to the maximum speed marked on the power tool.** If cutting bits run faster than their rated speed, they may break and fly off.
- ▶ **Routers and other accessories must be able to fit exactly in the tool holder (collet) of your power tool.** Application tools that do not fit exactly in the tool holder of the power tool will turn unevenly, vibrate heavily and may cause a loss of control.
- ▶ **Only bring the power tool into contact with the workpiece when switched on.** Otherwise there is danger of kickback if the cutting tool jams in the workpiece.
- ▶ **Never rout over metal objects, nails or screws.** The router could become damaged and cause increased vibration.
- ▶ **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 routers.** Blunt or damaged routers cause increased friction, create imbalances and may become jammed.
- ▶ **Always wait until the power tool has come to a complete stop before placing it down.** The application tool can jam and cause you to lose control of the power tool.
- ▶ **Products sold in GB only:**  
Your product is fitted with an BS 1363/A approved elec-

tric 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.

## Product Description and Specifications



#### Read all the safety and general instructions.

Failure to observe the safety and general instructions may result in electric shock, fire and/or serious injury.

Please observe the illustrations at the beginning of this operating manual.

#### Intended use

The power tool is intended for copy routing as well as routing grooves, edges, profiles and elongated holes in wood, plastic and light building materials while resting firmly on the workpiece.

#### Product features

The numbering of the product features refers to the diagram of the power tool on the graphics page.

- (1) Drive unit
- (2) Routing base
- (3) Carbon brush bracket
- (4) Nut for routing guide
- (5) Chip deflector
- (6) Knurled screw for routing base
- (7) Router bit<sup>a)</sup>
- (8) Cap nut with collet
- (9) Guide plate
- (10) Base plate
- (11) Dust extraction adapter
- (12) Wing bolt for routing base
- (13) On/off switch
- (14) Handle (insulated gripping surface)
- (15) Scale for setting routing depth
- (16) Collet
- (17) Tool holder
- (18) Open-ended spanner (10 mm)<sup>a)</sup>
- (19) Open-ended spanner (17 mm)<sup>a)</sup>
- (20) Guide bushing<sup>a)</sup>
- (21) Parallel guide<sup>a)</sup>
- (22) Wing bolt for parallel guide<sup>a)</sup>
- (23) Guide<sup>a)</sup>

- (24) Wing bolt for fixing horizontal alignment<sup>a)</sup>
- (25) Wing bolt for horizontal alignment of the guide<sup>a)</sup>
- (26) Guide roller<sup>a)</sup>
- (27) Dust extraction adapter<sup>a)</sup>
- (28) Extraction hose<sup>a)</sup>

a) This accessory is not part of the standard scope of delivery.

## Technical data

Edge router		GLF 55-6
Article number		<b>3 601 FA0 0..</b>
Rated power input	W	550
No-load speed	min <sup>-1</sup>	33 000
Tool holder	mm	6
	inches	¼
Weight <sup>A)</sup>	kg	1.4
Protection class		□ / II

A) With dust extraction adapter, without mains connection cable  
The specifications apply to a rated voltage [U] of 230 V. These specifications may vary at different voltages and in country-specific models.

Values can vary depending on the product, scope of application and environmental conditions. To find out more, visit [www.bosch-professional.com/wac](http://www.bosch-professional.com/wac).

## Noise/Vibration Information

Noise emission values determined according to **EN 62841-2-17**.

Typically, the A-weighted noise level of the power tool is:  
Sound pressure level **86 dB(A)**; sound power level **94 dB(A)**. Uncertainty K = **3 dB**.

### Wear hearing protection!

Vibration values  $a_h$  (continuous vibrations),  $p_f$  (repeated shock vibrations) and uncertainty K determined according to **EN 62841-2-17**:

$a_h = 1.0 \text{ m/s}^2$  (K = **1.5 m/s}^2**),  $p_f = 40 \text{ m/s}^2$  (K = **4 m/s}^2**)

The vibration level and noise emission value given in these instructions have been measured in accordance with a standardised measuring procedure and may be used to compare power tools. They may also be used for a preliminary estimation of vibration and noise emissions.

The stated vibration level and noise emission value represent the main applications of the power tool. However, if the power tool is used for other applications, with different accessories or is poorly maintained, the vibration level and noise emission value may differ. This may significantly increase the vibration and noise emissions over the total working period.

To estimate vibration and noise emissions accurately, the times when the tool is switched off or when it is running but not actually being used should also be taken into account. This may significantly reduce vibration and noise emissions over the total working period.

Implement additional safety measures to protect the operator from the effects of vibration, such as servicing the

power tool and accessories, keeping their hands warm, and organising workflows correctly.

## Fitting

- **Pull the plug out of the socket before carrying out any work on the power tool.**

## Changing the tool

- **Wearing protective gloves while fitting and changing router bits is recommended.**

Original router bits from the extensive range of **Bosch** accessories are available from your specialist dealer.

### Removing the routing base (see figure A)

Before fitting a router bit, you must first separate the routing base **(2)** from the drive unit **(1)**.

Open the wing bolt **(12)** on the routing base **(2)**.

Pull the drive unit out in an upward direction.

### Changing the Collet (see figure B)

Depending on the router bit used, you may have to change the cap nut with the collet **(8)** before fitting the router bit.

If the right collet for your router bit is already fitted, please follow the work steps in the following section.

The collet **(16)** must sit in the cap nut with a small amount of play. The cap nut **(8)** must be easy to fit. If the cap nut or collet is damaged, replace it immediately.

Place the open-ended spanner **(18)** on the tool holder **(17)** (see figure **C1**).

Unscrew the cap nut **(8)** anticlockwise using the open-ended spanner **(19)**.

If required, clean all the parts you want to fit with a soft brush or by blowing them clean with compressed air before assembling them.

Place the new cap nut on the tool holder **(17)**.

Loosely tighten the cap nut.

- **Do not, under any circumstances, tighten the collet with the tightening nut until a router bit has been fitted.** The collet may otherwise become damaged.

### Fitting the router bit (see figure C1 – C2)

Router bits are available in a wide variety of designs and qualities depending on the intended application.

**Router bits made of high-performance high-speed steel (HSS)** are suited to machining soft materials such as softwood and plastic.

**Router bits with carbide tips (HM)** are especially suitable for hard and abrasive materials such as hardwood and aluminium.

Original router bits from the extensive range of Bosch accessories are available from your specialist dealer.

Only use undamaged and clean router bits.

### Installing the Routing Base (see figure A)

To start routing, the routing base **(2)** must be fitted back onto the drive unit **(1)**.



Open the wing bolt **(12)** on the routing base **(2)**.

Slide the drive unit **(1)** into the routing base **(2)**.

Close the wing bolt **(12)** on the routing base **(2)**.

**Note:** The wing bolt **(12)** and the knurled screw **(6)** can be exchanged with each other.

► **After assembly, always check that the drive unit is firmly seated in the routing base.**

## Dust/Chip Extraction

Do not perform work without taking dust-reducing measures. Using a suitable dust extraction attachment will reduce exposure to harmful dust. Provide good ventilation at the workplace. Always use suitable breathing protection. Use a dust extraction system that is suitable for the material wherever possible. The regulations on the materials being machined that apply in the country of use must be observed.

### Requirements for the Dust Extractor

Recommended hose nominal diameter	mm	<b>35</b>
Required vacuum pressure <sup>A)</sup>	mbar hPa	≥ <b>230</b> ≥ <b>230</b>
Required flow rate <sup>A)</sup>	l/s m³/h	≥ <b>36</b> ≥ <b>129.6</b>
Recommended filter efficiency	Dust class M <sup>B)</sup>	

A) Power value at the power tool's dust extractor connection

B) According to IEC/EN 60335-2-69

Refer to the dust extractor's instructions. If there is reduced suction power, stop working and eliminate the cause.

### Connecting the dust extraction system (see figure I)

Attach an extraction hose (dia. 35 mm) **(28)** (accessory) to the fitted dust extraction adapter. Connect the dust extraction hose **(28)** to a dust extractor (accessory).

The power tool can be directly connected to the plug socket of a **Bosch** all-purpose dust extractor with remote starter. This dust extractor is started up automatically when the power tool is switched on.

The dust extractor must be suitable for the material being worked.

When extracting dry dust or dust that is especially detrimental to health or carcinogenic, use a special dust extractor.

## Operation

- **Products that are only sold in AUS and NZ:** Use a residual current device (RCD) with a nominal residual current of 30 mA or less.
- **Pay attention to the mains voltage.** The voltage of the power source must match the voltage specified on the rating plate of the power tool.

### Setting the routing depth

- **The routing depth must only be set while the power tool is switched off.**

- Place the power tool with a fitted router bit onto the workpiece you want to machine.
- Reopen the wing bolt **(12)** on the routing base **(2)** in order to set the required routing depth based on the scale for setting routing depth **(15)** either by hand or with the knurled screw **(6)**.
- Close the wing bolt **(12)** on the routing base **(2)**.
- Check the routing depth you have set by carrying out a practical test and correct it if required.

## Starting Operation

### Switching on/off

To **switch on** the power tool, set the on/off switch **(13)** to I.

To **switch off** the power tool, set the on/off switch **(13)** to 0.

### Working Advice

- **Protect router bits against shock and impact.**
- **Pull the plug out of the socket before carrying out any work on the power tool.**

### Routing direction and routing process (see figure D)

- **Routing must always be carried out with the workpiece being moved against the direction in which the router bit **(7)** is turning (up cut).** If the workpiece is moved in the same direction as the router bit is turning (down cut), the power tool may be pulled out of your hands.

- **Only use the power tool when the routing base **(2)** is fitted.** Losing control of the power tool can cause injuries.

**Note:** Be aware that the router bit **(7)** always protrudes slightly from the base plate **(10)**. Do not damage the template or the workpiece.

Set the routing depth you want.

Switch on the power tool and guide it to the point you want to machine.

Switch off the power tool after routing.

- **Do not put the power tool down before the router bit has come to a complete stop.** Application tools that are still running can cause injuries.

### Routing with guide bushing (see figure E1 – E3)

Using the guide bushing **(20)**, you can transfer contours from templates or patterns to the workpiece.

Select the guide bushing that is suitable for the thickness of the template or pattern. Due to the protruding height of the guide bushing, the template must have a minimum thickness of 8 mm (see figure E1).

- **Select a router bit with a diameter that is smaller than the interior diameter of the guide bushing.**

Unscrew the four cylinder screws on the underside of the guide plate **(9)** and remove the guide plate.

Insert the guide bushing **(20)** into the guide plate (see figure E2).

Loosely screw the guide plate back onto the base plate **(10)**. It must still be possible to move the guide plate freely.

To ensure that the distance between the centre of the router bit and the edge of the guide bushing is uniform, the guide bushing and guide plate must (if necessary) be centrally aligned with each other.

- Align the guide plate such that the router bit and guide bushing are centred on the opening in the guide plate (see figure E3).
- Hold the guide plate in this position and firmly tighten the fastening screw.

To rout with the guide bushing (20), proceed as follows:

- Place the power tool with the guide bushing (20) onto the template.
- Guide the power tool with the protruding guide bushing along the template using lateral pressure.

### Edge or profile routing (see figure F)

For edge and profile routing without a parallel guide, the router bit must be fitted with a pilot pin or a ball bearing.

While it is switched on, guide the power tool towards the workpiece from the side until the pilot pin or the ball bearing of the router bit is touching the side of the workpiece edge that you want to machine.

Guide the power tool along the workpiece edge. Pay attention that the router is positioned perpendicularly. Too much pressure can damage the edge of the workpiece.

### Routing with a parallel guide (see figure G)

You can fit a parallel guide (21) for when cutting parallel to an edge.

Fit the parallel guide (21) to the routing base (2) using the nut (4).

Set the required stop depth using the wing bolt on the parallel guide (22).

While it is switched on, guide the power tool along the workpiece edge with a uniform feed and while applying lateral pressure to the parallel guide.

### Routing with a pilot (see figure H)

The pilot (23) helps when routing edges with router bits without a pilot pin or ball bearing.

Fit the pilot to the routing base (2) using the nut (4).

Guide the power tool along the workpiece edge with a uniform feed.

**Lateral clearance:** To change the amount of material being removed, you can adjust the lateral clearance between the workpiece and the guide roller (26) on the pilot (23).

Loosen the wing bolt (24), set the lateral clearance you want by turning the wing bolt (25), then retighten the wing bolt (24).

**Height:** Set the vertical alignment of the pilot according to the router bit you are using and the thickness of the workpiece you want to machine.

Loosen the nut (4) on the pilot, slide the pilot into the desired position and retighten the bolt.

## Maintenance and Service

### Maintenance and Cleaning

- ▶ **Pull the plug out of the socket before carrying out any work on the power tool.**
- ▶ **To ensure safe and efficient operation, always keep the power tool and the ventilation slots clean.**

In order to avoid safety hazards, if the power supply cord needs to be replaced, this must be done by **Bosch** or by an after-sales service centre that is authorised to repair **Bosch** power tools.

### After-Sales Service and Application Service

#### Great Britain

Tel. Service: (0344) 7360109

#### GB Importer:

Robert Bosch Ltd.  
Broadwater Park  
North Orbital Road  
Uxbridge  
UB9 5HJ

You can find the link to our service addresses and warranty conditions on the last page.

In all correspondence and spare parts orders, please always include the 10-digit article number given on the nameplate of the product.

### Disposal

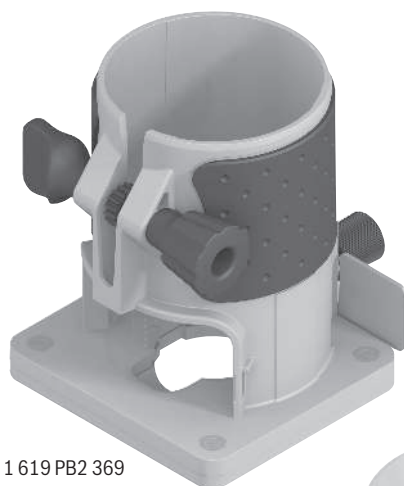
The power tool, accessories and packaging should be recycled in an environmentally friendly manner.



Do not dispose of power tools along with household waste.

### Only for EU countries and United Kingdom:

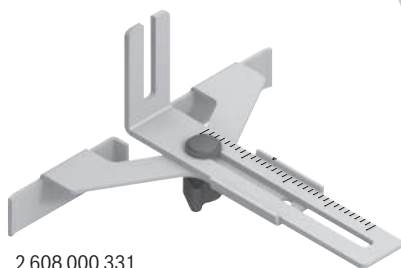
Electrical and electronic equipment that is no longer suitable for use must be collected separately and disposed of in an environmentally friendly manner. Use the designated collection systems. Incorrect disposal may cause harmful effects on the environment and human health, due to the potential presence of hazardous substances.



1619 PB2 369


 1619 PB3 058 (6 mm)  
 1619 PB3 057 (1/4")

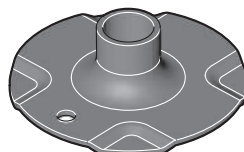

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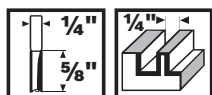
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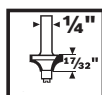
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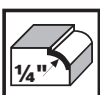
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 1619 PB2 377 (17 mm)  
 2 609 110 254 (10 mm)


2 608 628 411



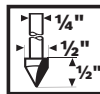
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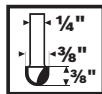
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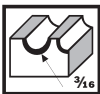
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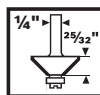
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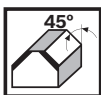
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2 609 256 669



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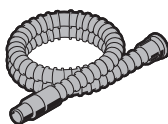




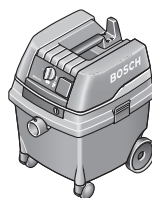
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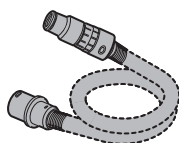
GAS 20 L SFC



Ø 35 mm:  
2 607 002 163 (3 m)  
2 607 002 164 (5 m)

GAS 50 L SFC  
GAS 25 L SFC

Ø 22 mm:  
2 608 000 568 (5 m)  
Ø 35 mm:  
2 608 000 566 (5 m)

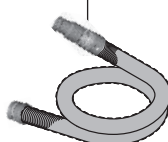


Ø 22 mm:  
2 608 000 567 (5 m)  
Ø 35 mm:  
2 608 000 565 (5 m)

GAS 35 L SFC+  
GAS 35 L AFC  
GAS 35 M AFC

GAS 55 M AFC

2 608 000 585



Ø 35 mm:  
2 608 000 658 (1,6 m)



GAS 18V-10 L

Servicekontakte  
Service Contacts  
Contacts de Service  
Contactos de Servicio



<https://www.bosch-pt.com/serviceaddresses>

Garantiebedingungen  
Guarantee Conditions  
Conditions de Garantie  
Condiciones de Garantía



<https://www.bosch-pt.com/guarantee/202507>