Setup and adjustment

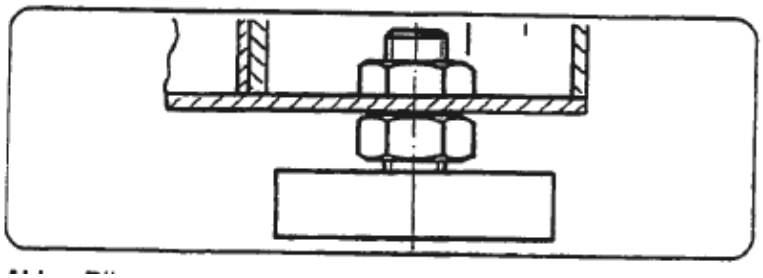


Fig 'A'

The machine stands on 4 adjustable rubber block supports. To level unevenness of the floor loosen the lower nut with a wrench and screw in or out the rubber feet. To lock retighten the nuts. A spirit level should be used to check for level. If required the machine can be bolted to the floor.

Wheel Mechanism

Fig 'B'

Lift the machine according to the sign board to allow the wheel assembly to be inserted.

Surface Planing Fence

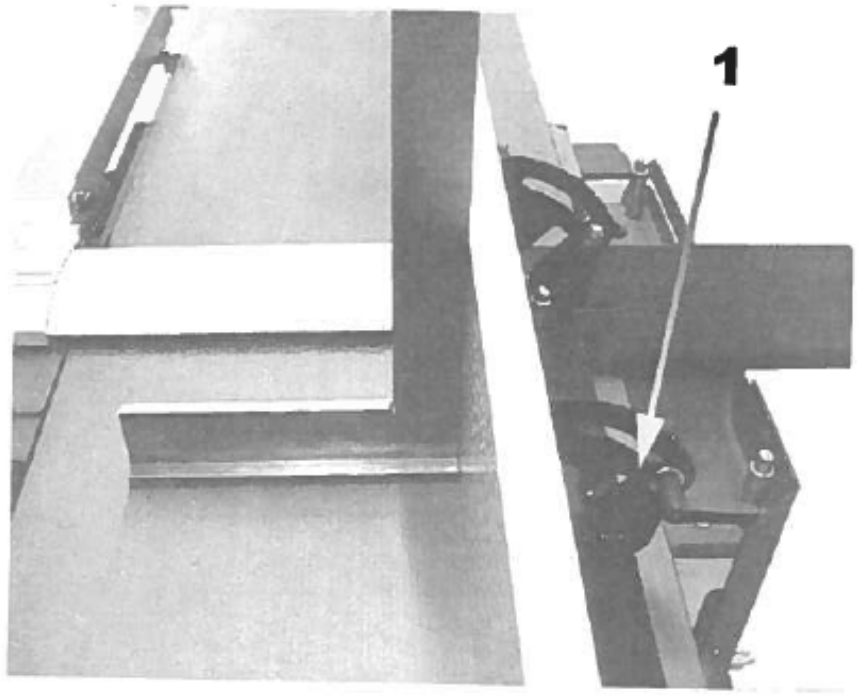


Fig 'C'

Set the surface planing fence on to the machine. Using a set square find 90° position. When at 90° lock in position using lever 1. Set the fence screws (2) to the 90° and 45° position using a No. 10 wrench. The surface planign fence can then be swung into any position between 90° - 45° when the handles on the swinging arms are loosened.

Reset the 90° with a set square and check with a trial piece of wood and a protractor.

Adjustment of the fence

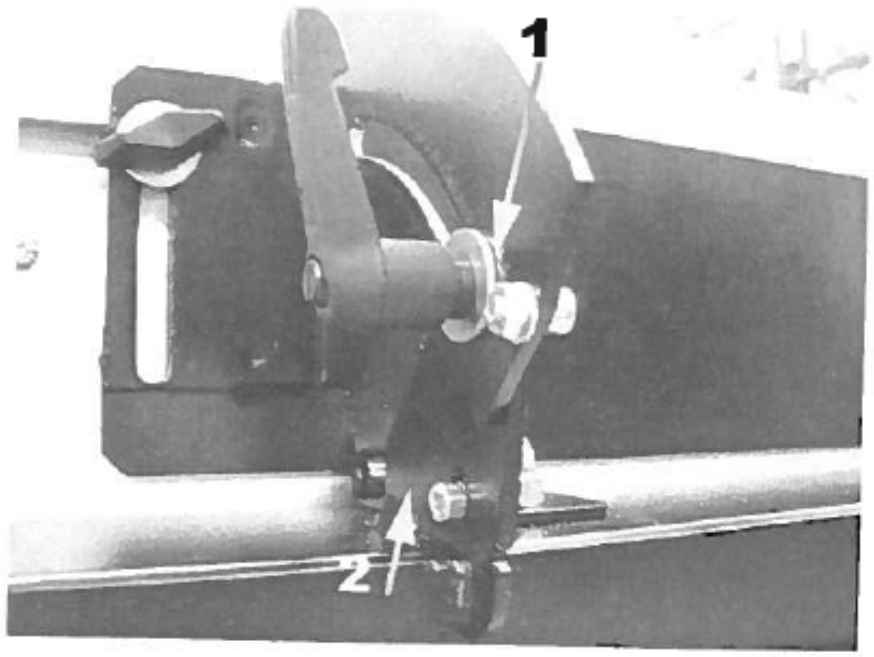


Fig 'C1'

If required recheck the 90°/45° angle and adjust by means of the cylindrical screw M4x8.

1=adjusting screw for 90° angle
2=adjusting screw for 45° angle.

Pay Attention to topics Fig 'H', 'I' and 'J'. The fence must always be secured safely.

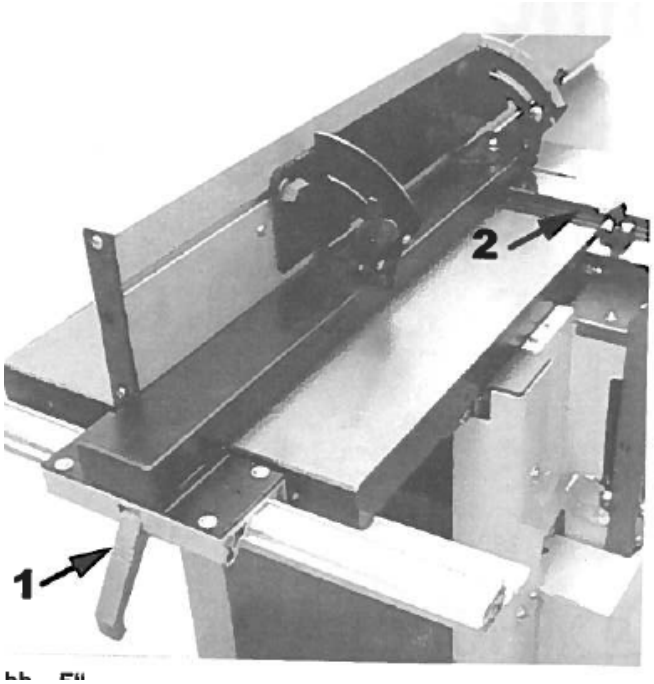


Fig 'D'

The clamping of the fence is locked by means of the eccentric lever (1), Additionally the fence can also be clamped with lever (2).

The fence is adjustable 320mm across the planing width.

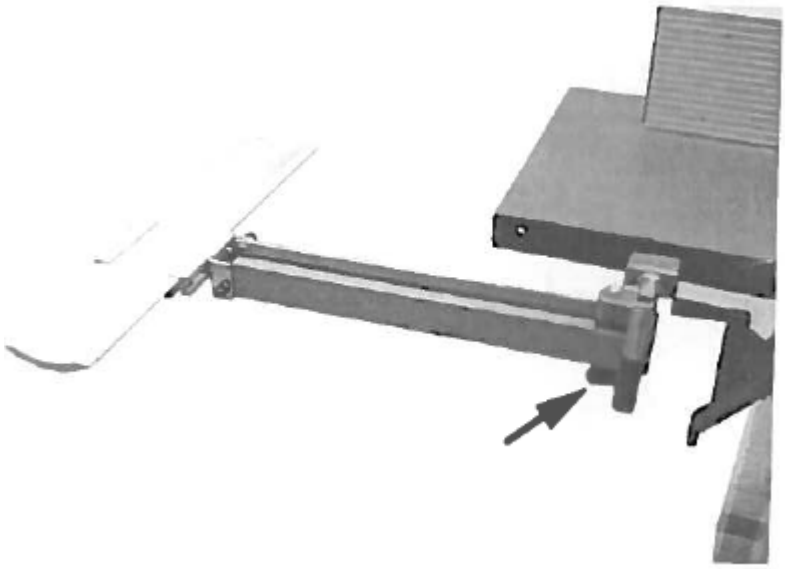


Fig 'E'

Screw on the planing shaft guard at the outfeed table. The planing shaft guard can be swivelled out of the way if required by releasing the eccentric lever.

Attention – never plane without the planing shaft guard in place.

Putting into operation

Planing – chip off particles

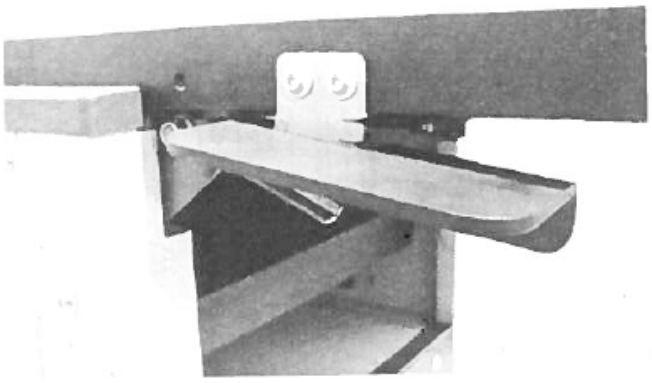
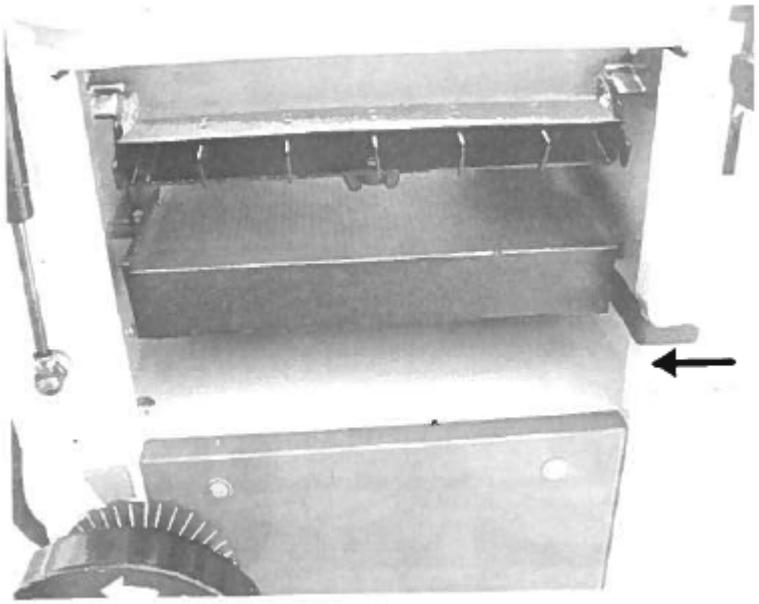


Fig 'H'

The chip off particles when planing are infinitely adjustable by using articulated lever (1) from 0-5mm.

While planing, the thickness desk has to be adjusted to be between 70-180mm to avoid the exhaust hood being clamped. Fig 'H1'



In the case that longer workpieces (longer than the in-feed table or out-feed table) a roller stand or similar should be used.

Planing – planing shaft protection

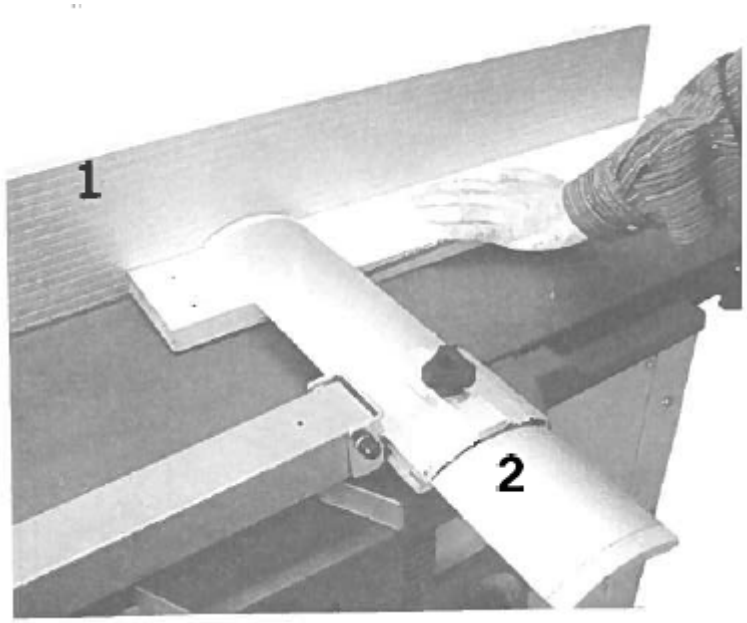


Fig 'I'

1. Fence
2. Planing Shaft Protection

While planing pieces of wood up to 75mm thickness, the planing shaft guard should be used to cover both the piece of wood being planed and the planing shaft. For pieces of wood thicker than 75mm, adjust the check rail of the shaft guard so that the guard is as close to the workpiece as possible without touching.

Jointing

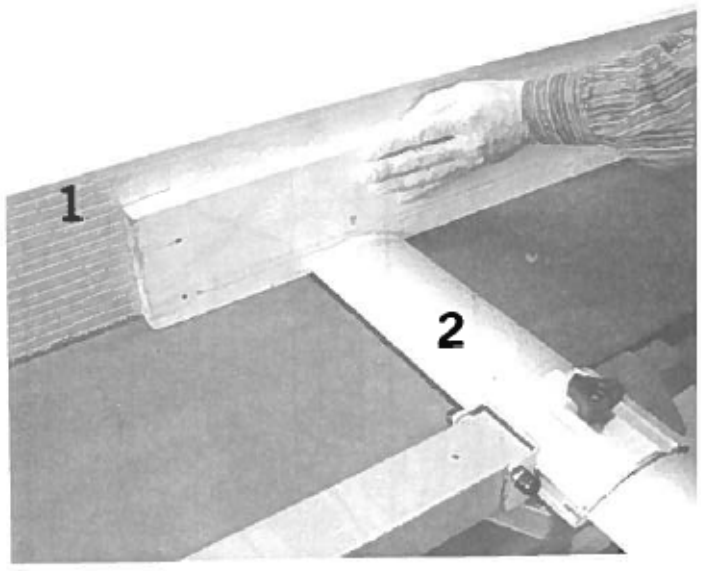


Fig 'J'

The Fence should be used for this operation. Let the planing shaft guard rest on the feed tables and adjust the check rail up to the width of the workpiece. Holding the workpiece with both hands against the fence lead it with both hands over the planing shaft. As soon as enough of the workpiece has passed over the planing shaft transfer your hands to the outfeed side of the fence and continue to pass the workpiece over the planing shaft in one continuous motion.

Planing – chip ejection

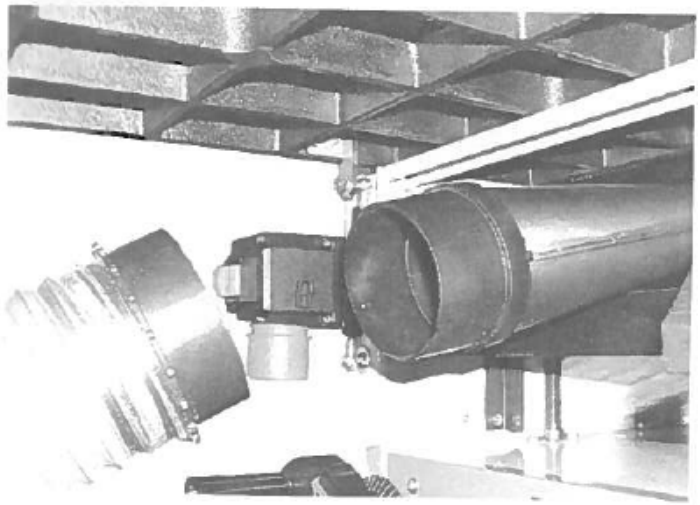
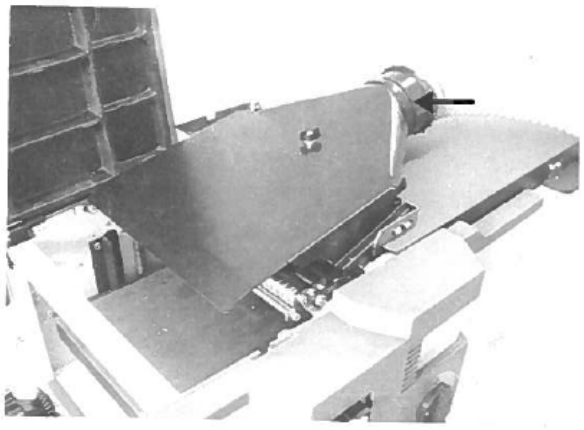


Fig 'K'

While planing the table needs to be locked using lever (x). Plug the extraction hose on to the extraction hood. Then in conjunction with an extraction device the chip particles can be collected. The diameter of the exhaust standpipe is 100 mm.

Thicknessing – machine adjustment

Fence should be removed prior to thicknessing.



Pull up the desk locking device lever and swing open the outfeed table. Position the height adjustment of the infeed table to full height. Swing up and lock the ejection hood (arrow). Depress the small metal locking catch to fully engage hood (machine will not start unless locking device fully

engaged). Connect the exhaust standpipe and tighten the wing nut. When used in conjuction with an extraction device chip particles will be collected.

Thicknessing – desk adjustment

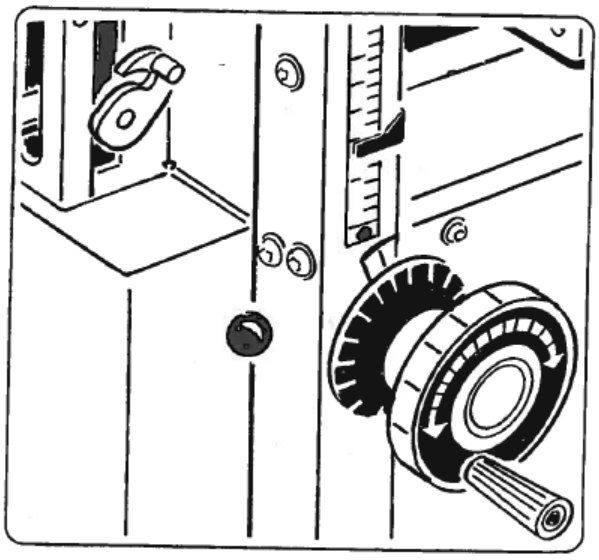


Fig 'L1'

The height of the thickness desk is adjustable by means of the hand wheel. The integrated display of the position shows the passage height of 5-180mm. One hand wheel turn corresponds to 2mm. Keep the thickness desk and trimming desks free of resin.

The graduation marks on the scale ring make possible a fine adjustment, at which 1 graduation mark corresponds to 0.05 mm

Scale Correction

The thickness scale can be corrected if required. If the passage height is adjusted to 100mm and the processed work measures at 101mm. Loosen the mounting screws of the thickness scale. Adjust the thichness scale to 101mm and retighten the thickness scale.

Thickness planing – feed

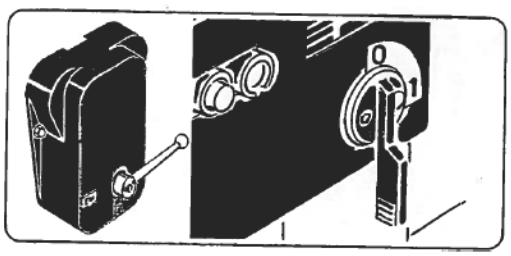


Fig 'M'

The feed can be switched on and off with the lever (1)

0=off
1=on

First switch on the feed, then set-in the workpiece.

V-Belt Tension

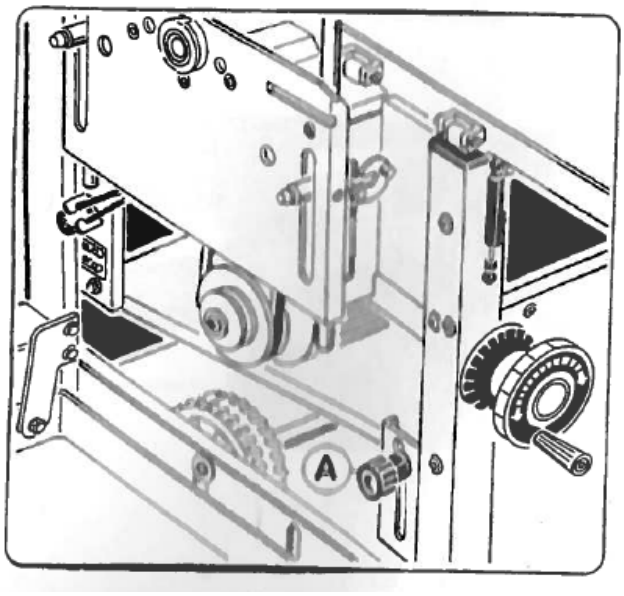


Fig 'O'

Open the side panel with an allen key
Loosen handhold 'A'
Push down the motor rocker
Tighten handhold 'A'
Close the side panel.

Feed Roll Adjustment

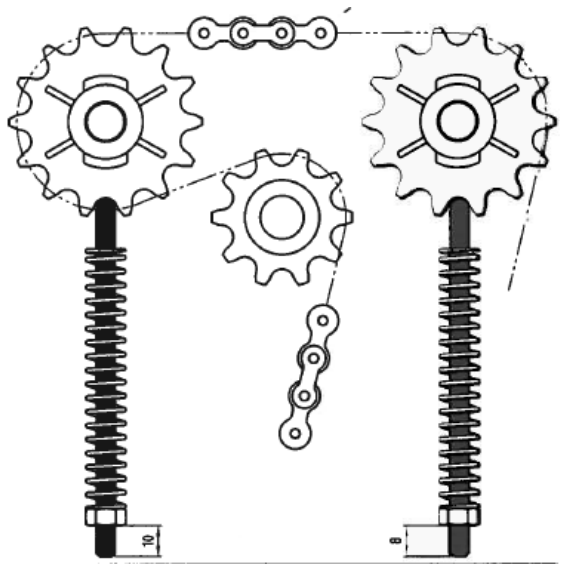


Fig 'P'

To guarantee the a proper feed, the pressure springs have to be adjusted to the measurements shown above.

Exchange of feed section roller

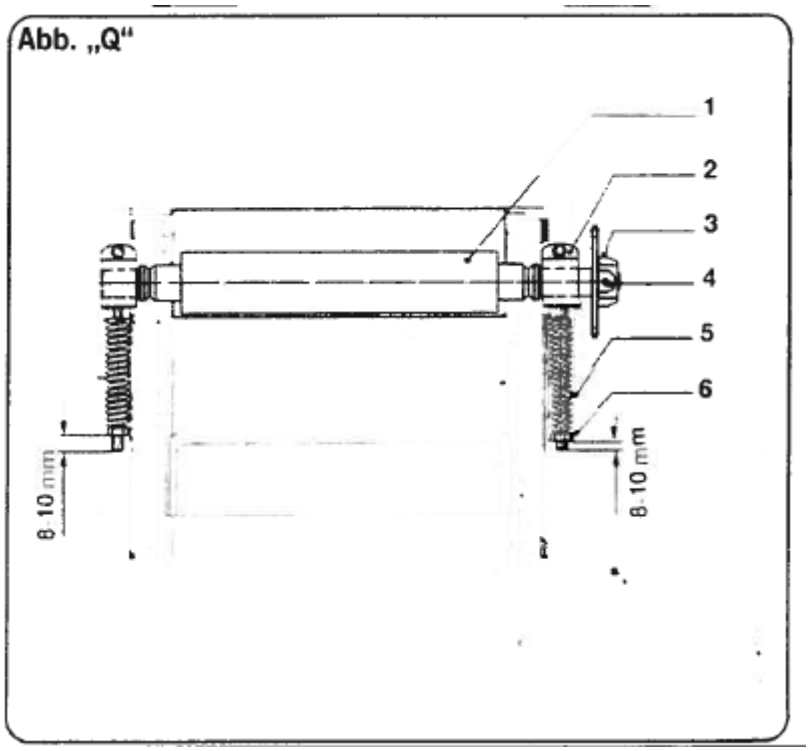


Fig 'Q'

The coating of the feed rollers in made of an abrasion resistant rubber. In the case of many years of use the roller may require to be replaced.

1. Feed roll
2. Bearing Clip
3. Chain Wheel
4. Spiral Pin
5. Pressure Spring
6. Hexagonal nut

Carry out the exchange as follows:-

Unscrew the gear feed lever.
Unscrew the right cover. Loosed the 5 tallow drop screws.
Remove the left cover. Loosen the 4 tallow drop screws.
Remove the front left panel. Loosen the 3 countersunk screws and 2 hexagonal nuts
Remove the feed chain.
Remove feed roll (1) after detachment of the hexagonal nut (6)
Rearrange the chain wheel on to the new feed roller.
Install the new feed roll.

Installation complete.

Trimming Desk Locking.

Fig 'R'

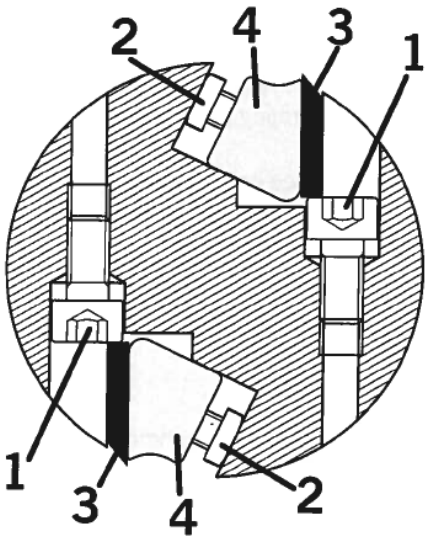
To avoid unintentional closing of the outfeed table, the table is fitted with a pneumatic spring. When closing the outfeed table no further locking has to be removed.

Trimming Desk (Feed Tables)

Fig 'S'

The chipping at the planer is infinitely adjustable from 0-5mm. If the in-feed table shifts itself during work, dimensionally accurate planing is no longer possible. IN this case the four hexagonal screws (arrows) have to be tightened in order to ensure that the tables hold position accurately.

Installation of planer knives



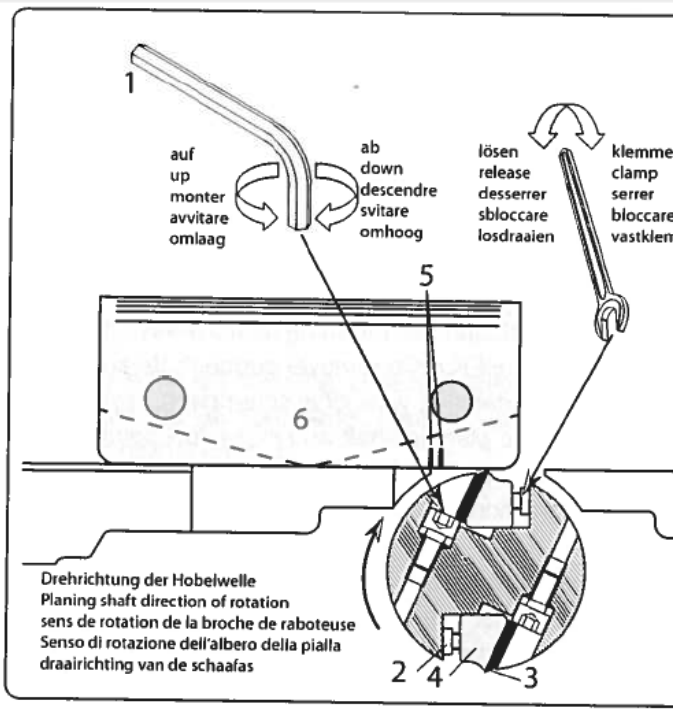


Fig 'T'

1. Adjustment screw
2. Thrust Screw
3. Planer Knives
4. Taper Gib
5. Marking
6. Adjusting Ring

- Use the supplied adjusting gauge for adjustment
- First adjust one planer knife, then the second planer knife
- Loosen the thrust screws on the planer knife to be adjusted
- Adjust the planer knife up or down using the adjustment screw until the knife touches the adjustment gauge placed on the outfeed table
- The right hand mark on the gauge should be in line with the edge of the outfeed table as shown.
- Turn the planing shaft in the direction of travel. The blade should move the adjustment gauge by no more than the distance to the second mark on the gauge.
- Carry out this adjustment on the left and right outer edge of the planer knife.
- Firmly re-tighten the thrust screws of the taper gib with the supplied wrench
- After each change of knives make a test run and then re-tighten the thrust screws (8-9 N/m)