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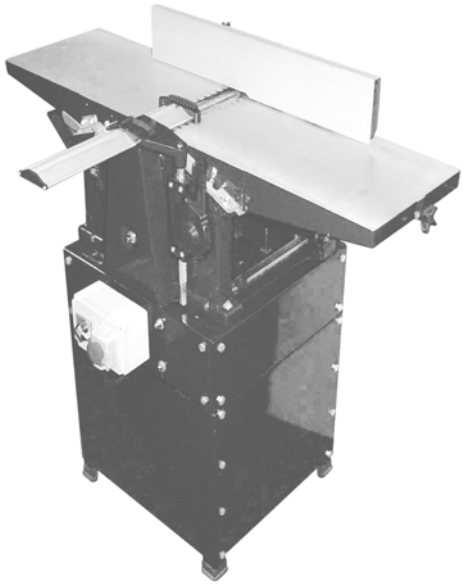
10” x 6” PLANER THICKNESSER OPERATING INSTRUCTIONS

MODEL: W582



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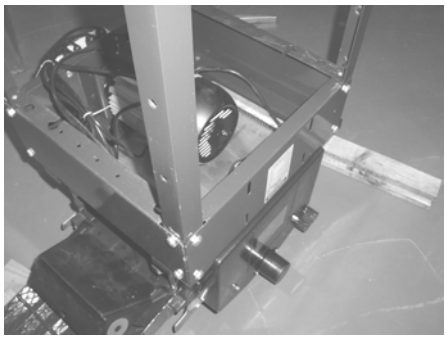
Contents

1.0 Technical Details

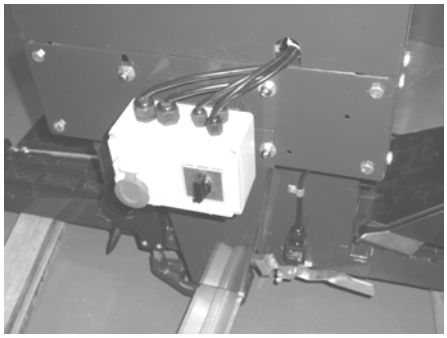
Planing Table Length	1000 mm	40”
Length, thicknessing bed	400 mm	15¾”
Max working width	260 mm	$10^{3}/_{16}$”
Max thicknessing capacity	180 mm	$6^{1}/_{8}$”
Max depth of cut	3 mm	$^{1}/_{8}$”
Fence Tilt	Max. 45^{0}	
Height of planing bed from Floor	840 mm	33”
Cutter block diameter	63 mm	
Cutter block speed	6500 rpm	
Thicknesser feed rate	5m/min	16 ft/min
Weight	76kg	167 lbs
Noise	<90 dB(A)	
Motor speed	2800 rpm	
Motor	1.8kW	240V 50Hz Single phase

2.0 Assembly

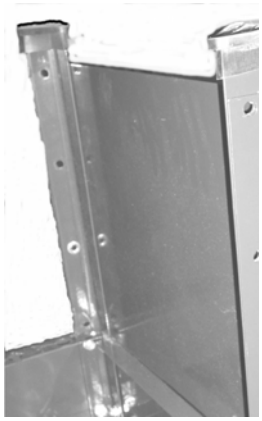
2.1 Unpack all components and invert the machine, supporting it on the large polystyrene sheet from top of packaging or timber blocks.



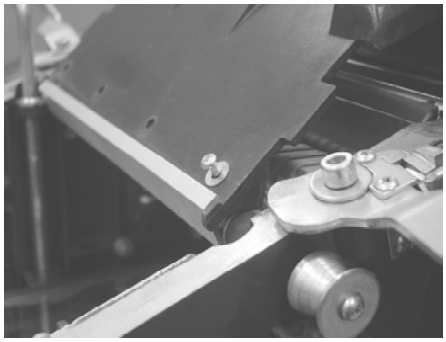
2.2 Fit legs into motor housing and loosely secure with M8 x 16 hex bolts, spring washers and hex nuts.



2.3 Fit switch box as shown, making sure that it is on the opposite side of the machine to the labels. This must be done before the side panels are fitted.



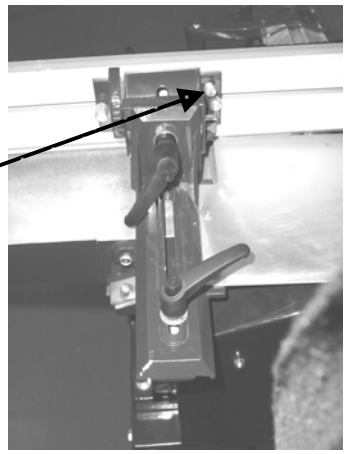
2.4 Fit the four sides of the base. The two plates with returns should be fitted first and these go outside the legs. The two flat plates go outside these and are fitted last of all. M8 x 16 hex bolts, spring washers and hex nuts are used for the whole base assembly. Tighten up all nuts and bolts ensuring that the base is square.
Push rubber feet on to the legs.
Set the machine on its feet.



2.5 Attach the chip ejection hood to the extrusion, using the 4 sheet metal screws supplied.

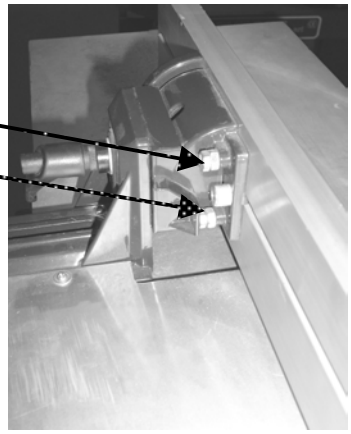
2.6 Bolt the fence carrier to the infeed table with two M8 hex bolts, if not already fitted.

2.7 Fix fence bracket to the carrier with an 8 mm coach bolt and then fix the fence to the carrier with the two knurled nuts supplied. Note that the shorter nut is placed adjacent to the 90/45^0 stop adjusters.



3.0 Setting the Fence

The fence has pre-set positions for 45^0 and 90^0. By adjusting the fence setting screws, these can be set accurately.



4.0 Mains Connection

Machines sold in the United Kingdom are fitted with a 13 amp plug. Please ensure that the socket to which the machine is connected is properly earthed

5.0 Switch

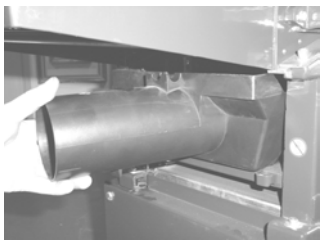
Your planer/thicknesser is fitted with an NVR (No Volt Release) switch. This ensures that it cannot automatically re-start after a power failure.

6.0 Chip Extraction

The extractor hood is designed to connect to 100 mm hose.

7.0 Chip Extraction While Planing

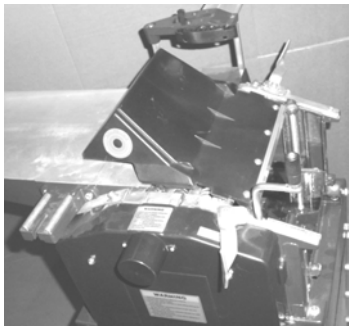
Lower the thicknesser bed to approximately ⅔ capacity and insert the extractor hood so that the two notches above the outlet fit over the junction of the two rods beneath the infeed table. Raise the thicknesser bed sufficiently to lock the hood in place.



Note: unless the hood is correctly located, the planer will not work. This is not a fault – it is part of the machine's safety system.

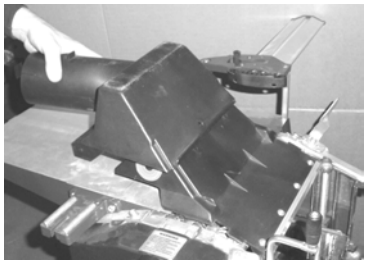
8.0 Chip Extraction While Thicknessing

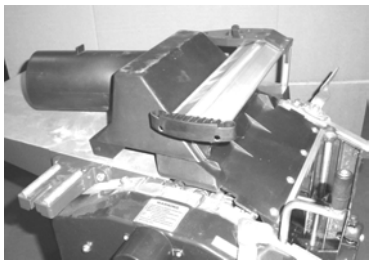
Remove the outfeed table, slide the guard clear of the table and raise it to its highest position. Swing the chip collection hood over the cutter block.



If you are **not** using an extractor, lock the hood in place with the lock lever adjacent to the crank handle and by lowering the guard on to it.

If you are using a dust extractor (this is strongly recommended), prior to securing the collection hood, place the extraction hood over it and then secure as detailed above.





Important Safety Notice – the chip collection hood also functions as the cutter block guard when the machine is set up for thicknessing.

Never operate the machine without the chip collection hood in place and correctly secured.

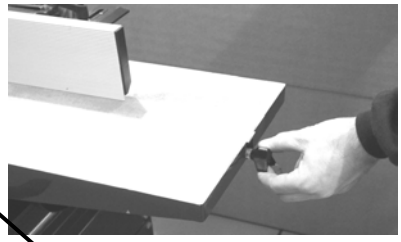
9.0 Setting the Guard

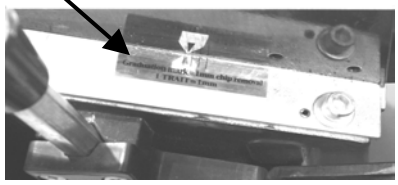
The guard may be moved across the table after loosening the locking lever. Press this down to lock the guard in position after adjustment. Height adjustments are made with the lever mounted to the right of the guard assembly.

10.0 Planing

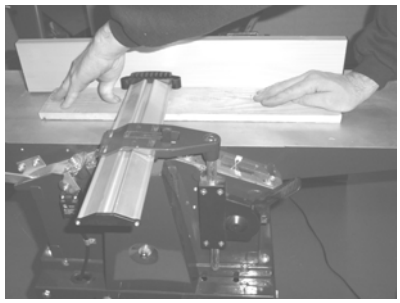
Before starting the machine, place the work flat on the infeed table and set the guard to a height such that the work will just slide beneath it.

Set the depth of cut, using the knurled knob at the end of the infeed table to approximately 1.5mm. There is a scale in front of the infeed table that shows the depth, which has been set.

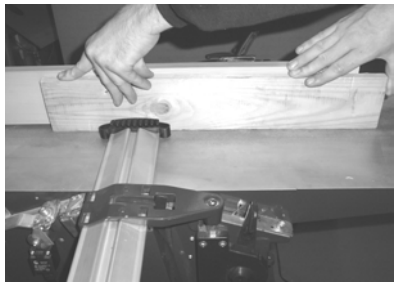




'The switches on this machine will only allow the desired function to be performed once the guards have been correctly fitted. Turn the black function selector switch to the left (anti-clockwise) for planing operations. Turn the black function selector switch to the right (clockwise) for thicknessing operations.'



Move the work clear of the cutters and start the machine. Slide the work slowly over the cutters, keeping a firm downward pressure on it. Your hand should always pass over the guard, **never** beneath it. With thin pieces of timber the downward pressure should never be so strong that the work is distorted. You may wish to reduce the depth of cut for the finishing passes.

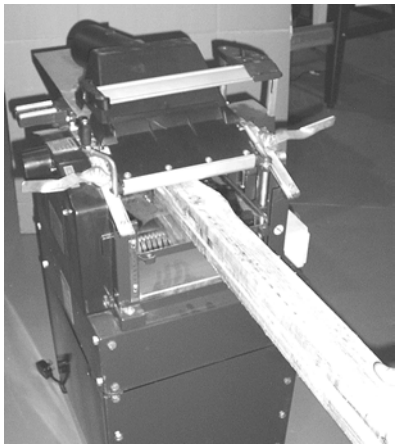


Once the face side has been satisfactorily planed, the face edge can be machined. Check that the fence is set at the required angle. Slide the guard across the table so that the work can pass between the fence and the guard and lower the latter to its minimum height. Lock the guard in place. The plastic end cap of the guard should exert slight pressure on the work.

Start the machine and keeping the work firmly pressed against the fence, pass it slowly over the cutter block.

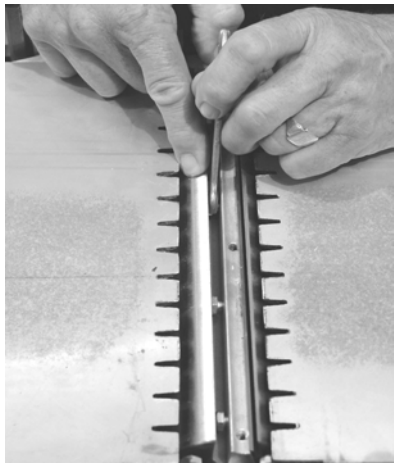
11.0 Thicknessing

Following the instructions given in section 8.0 set the machine for thicknessing. Set the machine to take a light cut from the work, which should be placed face side down on the thicknessing bed. Start the machine and slowly insert the work until the feed rollers engage it. Should the stock be wedge shaped, feed the thicker end first.

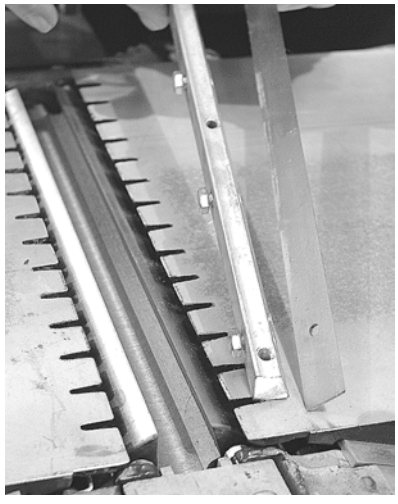


12.0 Blade replacement

Disconnect the machine from the mains before servicing



Remove the fence. Using the 10 mm spanner supplied with the machine, loosen the hex bolts of the lock bar, turning them clockwise (into the bar). Remove the bar, complete with blade from the block. Thoroughly clean the blade (if reusing it), the lockbar and the lock bar seat. Reverse the blade or fit a new one onto the lock bar. Place the assembly into the cutter block and secure in place by turning the hex bolts anticlockwise.



At this stage the bolts should be tightened lightly. Repeat the process for the other blade.

Using the gauge provided, set the edge of each blade to the correct projection from the cutter block.

It is essential that the projection is the same for each blade

Use the 3mm Allen key supplied, adjust the projection of the knives by turning the three setting screws of the lock bar in or out as required. When the settings are correct (keep checking with the gauge) fully tighten the lock bar's hex bolts. Start with the centre bolt and work outwards.

Caution! Do not use a longer spanner than that provided with the machine. The excessive torque developed by a longer spanner might strip the threads. Should the lock bars or bolts have damaged threads, for safety reasons they must be replaced immediately.

13.0 Belt Tension

After the first 5 hours of operation, check the belt tension. Remove the domed nuts retaining the drive belt cover and remove the cover. Check the tension of the belt by pushing against it. The play should be approximately 15 to 20 mm.

14.0 Care and Maintenance

Clean the thicknesser drive gear regularly with a brush or compressed air. Lubricate all bearing points and chains with a few drops of engine oil. Keep the flat belt clear of oil and grease.

Regularly clean the thicknessing bed spindles, ensuring that the threads are free of chips. Spray with WD40 or a similar product. Do **not** use normal oil.

Keep tables and thicknesser bed free of resin. Wipe with paraffin or a proprietary cleaner. These parts will benefit from a light coating of wax or silicone.

Should work pieces fail to autofeed through the thicknesser, check that the feed rollers are not clogged with resin. If they are, clean as advised above.

15.0 Safety Instructions

Frequently check that the knives and lock bars are locked tightly in the cutter block.

The knives must not project more than 1.0 mm (+10%) over the cutter block.

Use the machine's guards at all times. Guards may only be removed for servicing and repair work and only when the machine is disconnected from the mains.

Set and secure guards before starting the machine.

When operating the machine in an enclosed space a dust extractor must be used.

The machine must always be earthed. The yellow and green wire is the earth conductor.

Regularly check the anti-kickback fingers for correct operation.

Always were eye and hearing protection.

Never try to exceed the maximum depth of cut, which is 3 mm.

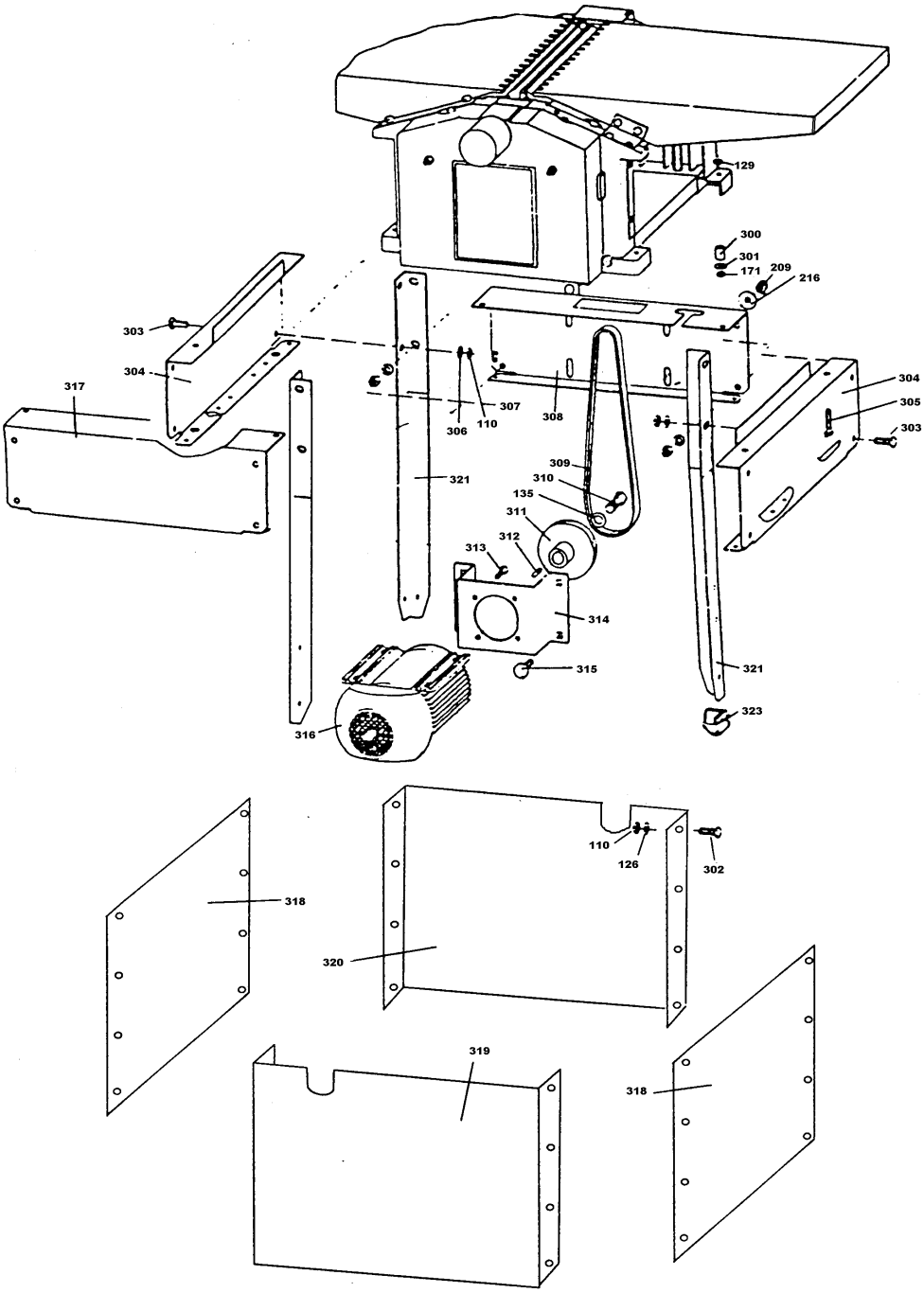
16.0 User Responsibility

The performance of this machine will conform to the description given in the manual, provided that it is installed, operated, maintained and repaired in accordance with the instructions provided.

This machine must be regularly checked. Defective equipment should not be used. Damaged mains cables must be replaced immediately. Any parts that are visibly worn, broken, missing, distorted or contaminated must be replaced immediately. It is recommended that suitably qualified people carry out any repairs. Neither the machine nor any of its parts may be altered or changed from the standard specification. The user of this machine will be wholly responsible for any malfunction that is the result of improper use or unauthorised modification from the standard specification, faulty maintenance or improper repair.

100	Planing bed	2B6 x 500
101	Lock bar screw	M6 x 11
102	Lock bar	
103	Clamp for lock bar	5X6
104	Set screw	M6 x 8
105	Planer blade	20 x 3 x 20/18.6 x 1 x 260
106	Cutter block	63 x 440
107	Side panel	
108	Pan head screw	M5 x 12
109	Square washer	
110	Hexagon nut	M8
111	Hex socket head cap screw	M6 x 28
112	Wave lock washer	10
113	Pin roll	4x10
114	Clamping sleeve	4 x 16
115	Screw hex head	M6 x 12
116	Star knob	
117	Washer	23.0 x 10.2 x 0.9
118	Set collar	Ø11
119	Threaded rod	450
120	Hex socket head cap screw	M6 x 16
121	Spacer strip	4 x 22 x 190
122	Hex. socket head cap screw	M6 x 12
123	Hex. socket head cap screw	M8 x 16
124	Countersunk head screw	M6 x 12
125	Cover rail	4 x 25 x 180
126	Disk spring	16.0 x 8.2 x 0.6
128	Crank handle	
129	Torque nut	M6
130	Thicknesser bed adjusting spindle	T 14 x 3 x 365
131	Thicknesser bed spindle	T 14 x 3 x 228
132	Grooved dowel pin	3 x 16
133	Hexagon head screw	M6 x 80
134	Glide piece	
135	Washer	Ø 12
136	Feed roller, smooth	
137	Spacer shaft w/tapped hole	Ø 20 x 295
138	Feed roller, coarse	
140	Set screw	M5
141	Check nut	T14 x 3
142	Thicknesser bed w/pointer	
144	Shim with hole 8.1	22 x 22
145	Pressure spring	
146	Washer	Ø8
147	Hexagon head screw	W x 80
148	Pin roll	M8 x 16
149	Pan head screw	MX48
150	Thicknesser bed scale	
151	Shim ring	8x14xl.0
152	Spindle bush	16 x10
153	Shim with hole 12.1	22 x 22
154	Chain sprocket Z=15 T=6	
155	Roller chain pitch 6 - 210 links	
156	Drive chain protection plate	1.5 x 259 x 415
157	Washer	Ø 6
158	Setting bracket	2 x 62 x 48
159	Guide rail, left	4 x 22 x 190
160	Guide screw	M6 x 8
161	Guide rail, right	
162	Chip extraction hood extrusion	258
163	Pan head tapping screw	St4.8 x 13
164	Recoil lock segment	
165	Recoil lock bar	Ø6x288
166	Recoil lock bar	Ø10.70 x 286
167	Hexagon head screw	M8 x 80
168	Chip guide plate	
169	Spacer shaft	20 x 295
170	Chain tension sprocket Z=15 T=6	
171	Hexagon nut	M6
172	Threaded bolt	13 x 22
173	Chain tension plate	2.5 x 25 x 84
174	Chip extraction hood	
175	Hex. socket head cap screw	M8 x 25
177	Hex. socket head cap screw	M8 x 25
178	Chip extraction hood	ABS
200	Fence extrusion end cap, right	
201	Fence segment	
202	Glide segment	
203	Hexagon head screw	M8 x 50
204	Fence extrusion	600
205	Carriage bolt	M6 x 20
206	Fence extrusion end cap, Left	
207	Guard extrusion	80 x 360
208	Guard extrusion clamping lever	
209	Cap nut	M8
210	Guard support	
211	Guard extrusion end cap	
212	Pan heed tapping screw	St 3.5 x 13
213	Side panel lid	1.8 x 30 x 153
214	Pan head screw	M4 x 8
215	Drive belt cover	
216	Washer	Ø 8

217	Ratchet lever	M8
218	Plastic washer	Ø20 x Ø8 x 6
219	Fence carrier	
220	Guide segment	
221	Nylon hexagon head screw	M6 x 16
222	Washer	Ø4
223	Pan head screw.	M4 x 8
224	Fence cover plate	1.5 x 190 x 190
225	PVC pressure spring	
226	Guard setting lever	
227	Hex. screw	M10 x 16
228	Pressure plate	
229	Setting rod, cogged, hexagonal	SW 14 x 285
230	Gear cover	
231	Countersunk head screw	M6 x 20
232	Shim ring	
233	Lock lever, right	
235	J-belt pulley 5J x 42	
236	Bearing cup	
237	O-ring	Ø40 x 2.65
238	Grooved ball bearing 6203	
239	Guide bar	Ø10 x 75
240	Fence carrier support bracket	
241	Hexagon head screw	M6 x 20
242	Carriage bolt	M8 x 40
243	Drive chain sprocket Z=25 T=8	
244	Pin roll	4 x 20
245	Bolt, chain tensioner N	
246	Torsion spring	
247	Chain tensioner	4 x 20 x 90
248	Roller chain pitch 8 74 links	
249	Chain sprocket Z=10 T=8	
250	Threaded bolt	Ø14 x 20
251	Bolt, short	Ø20 x 64.5
252	Bolt, long	Ø20 x 87
253	Ring retaining	Ø8
254	Ring retaining	16 x 1.0
255	Shim ring	16 x 22 x 1.0
256	Flat belt	
257	Flat bed pulley	
258	Cam wheel Z=25 T=38	
259	Disk spring	34.0 x 12.3 x 1.0
260	Hexagon nut	M12 x 1.25
261	Drill chuck cover	
262	Thicknesser driver gear cover	
263	Cap nut	M14 x 1.5
264	Hexagon nut	MI0 x 16
265	Hex. socket head cap screw	Ø6 Ø15 x 18
300	Spacer bush	86.4
301	Washer	
302	Switch	M8 x 16
303	Hexagon head bolt	
304	Side panel, neutral	M6 x 40
305	Hexagon head bolt	Ø8
306	Washer	5 x 8
307	Blind rivet	
308	Front panel	5 PJ 864
309	Poly-V-belt	M8 x 20
310	Hexagon head screw	W X 90
311	J-belt pulley 50 Hz	5J x 90
312	Feather key	M6 x 16
313	Hex. socket head cap screw	
314	Motor carrier	M8 X 16
315	Carriage bolt	
316	Motor	
318	Front panel	
319	Rear panel	
320	Front panel	
321	Leg	
323	Rubber foot	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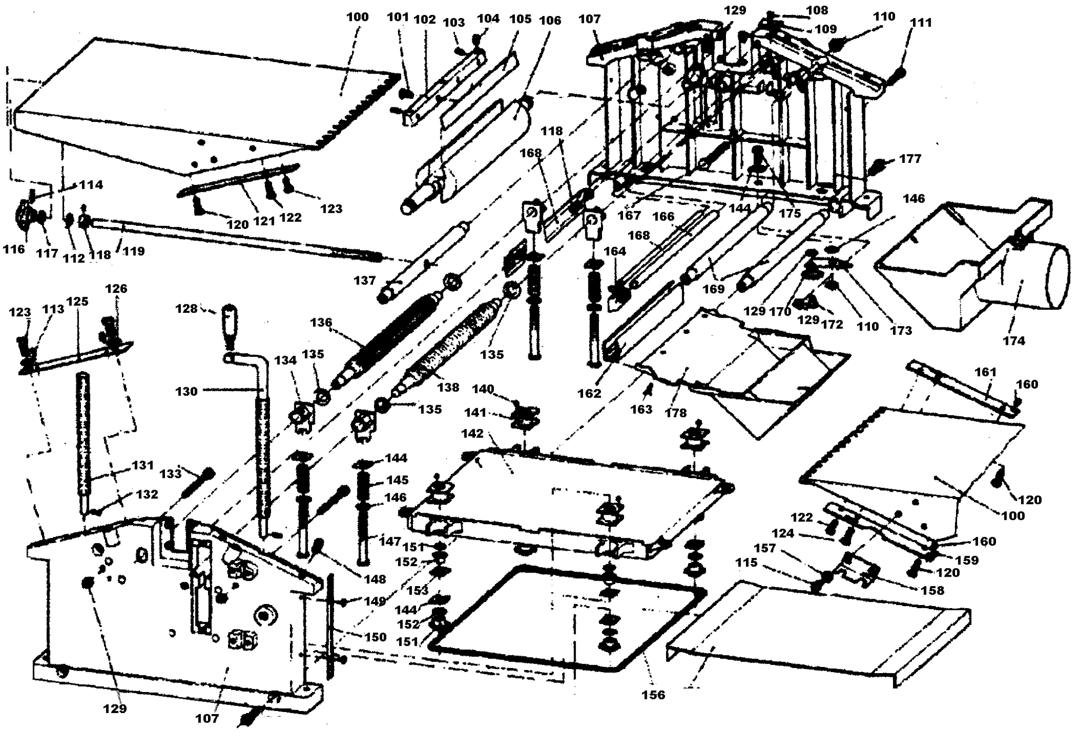
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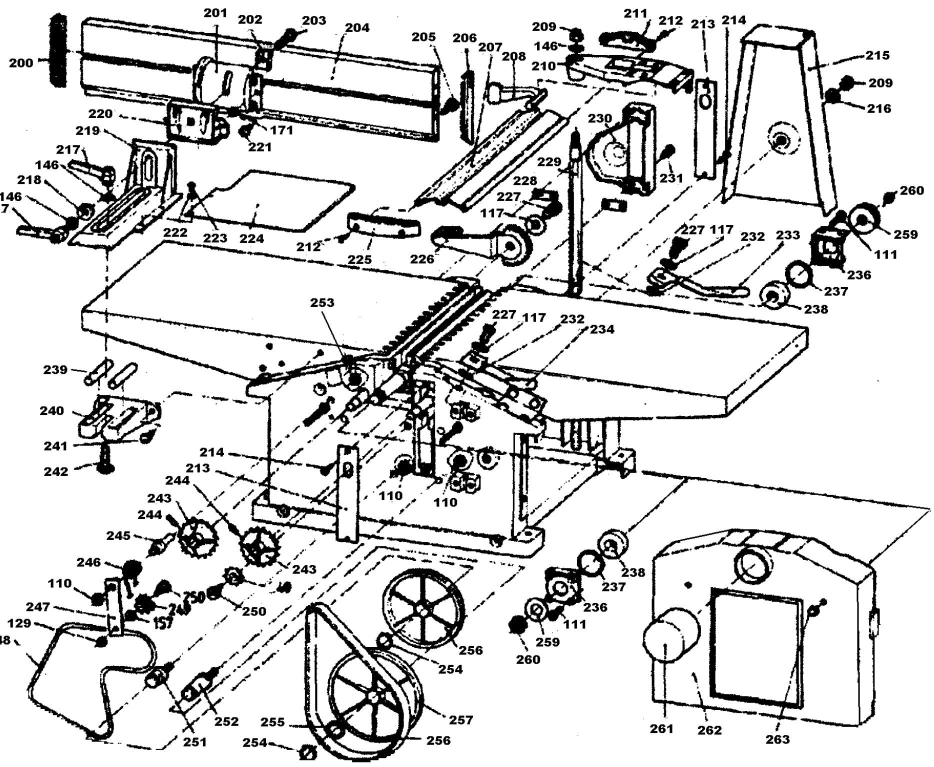
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