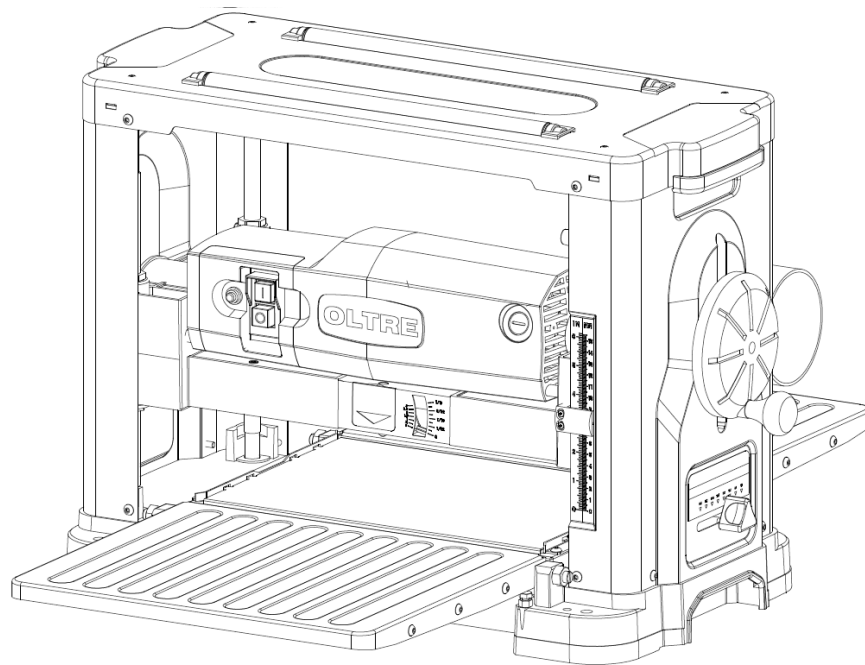


OLTRE

OT-TH-330

330mm (13") Benchtop Thicknesser

with Segmented Style Cutterhead



OPERATION MANUAL

TABLE OF CONTENTS

Specifications.....	2
Safety Instructions	3 - 6
Getting To Know Your Machine	7
Contents of Package	7 - 8
Installation.....	8
Assembly	9
Adjustments.....	10 - 11
Operation	12 - 13
Maintenance	14 - 15
Electricals & Wiring Diagram.....	5 & 16
Troubleshooting.	16
Parts Diagrams & Parts Lists	18 - 21

SPECIFICATIONS

Model No.	OT-TH-330
Motor	
Amps	7.5
Volts	240V, 50 Hz
Motor	22,000 RPM
	1800W
Cutterhead	
Diameter	50mm
Speed	10,000 RPM
Number of HSS Inserts (2 Sided)	26
Number of Insert Rows Maximum	6
Maximum Depth of Cut	3mm
Maximum Cutting Width	330mm
Maximum depth of cut (Height)	152mm
Minimum Length of Material	175mm
Minimum Width of Material	19mm
Minimum Thickness of Material	5mm
Feed Speed M/MIN	8 M/MIN
Table Size (Length x Width)	235mm x 332
Extension Table Sizes (2) (L x W)	305mm x 255mm
Dust Port (O.D.)	100mm or 65mm Diameter
Dust Collection Minimum CFM	650
Noise Level (No Load) Overall	<100 dB
Height	440mm
Weight	33kg
Shipping Weight	35kg
Shipping Carton	660 x 400 x 540mm

NOTE: The specifications, photographs, drawings, and information in this manual represent the current model when the manual was prepared. Changes and improvements may be made at any time, with no obligation on the part of Oltre Machinery to modify previously delivered units. Reasonable care has been taken to ensure that the information in this manual is correct and to provide you with the guidelines for the proper safety, assembly, and operation of this machine.

SAFETY INSTRUCTIONS

IMPORTANT! Safety is the single most important consideration in the operation of this equipment. **The following instructions must be followed at all times.** Failure to follow all instructions listed below may result in electric shock, fire, and/or serious personal injury.

There are certain applications for which this tool was designed. We strongly recommend that this tool not be modified and/or used for any other application other than that for which it was designed. If you have any questions about its application, do not use the tool until you have contacted your local Oltre Dealer and we have advised you.

SAFETY SYMBOLS



SAFETY ALERT SYMBOL: Indicates DANGER, WARNING, or CAUTION. This symbol may be used in conjunction with other symbols or pictographs.



Indicates an imminently hazardous situation, which, if not avoided, could result in death or serious injury.



Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury.



Indicates a potentially hazardous situation, which, if not avoided, could result in minor or moderate injury.

NOTICE: Shown without Safety Alert Symbol indicates a situation that may result in property damage.

GENERAL SAFETY

KNOW YOUR MACHINERY. Read the owner's manual carefully. Learn the tool's applications, work capabilities, and specific potential hazards.

BEFORE USING YOUR MACHINE

To avoid serious injury and damage to the product, read and follow all the Safety and Operating Instructions before operating the machine.

1. Some dust created by using machinery contains chemicals known to cause cancer, birth defects, or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead-based paints.
 - Crystalline silica from bricks, cement, and other masonry products.
 - Arsenic and chromium from chemically treated timber. Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well-ventilated area and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.
2. **READ** the entire Owner's Manual. **LEARN** how to use the product for its intended applications.
3. **GROUND ALL MACHINERY.** If the product is supplied with a 3 prong plug, it must be plugged into a 3-contact electrical receptacle. The 3rd prong is used to ground the product and provide protection against accidental electric shock. **DO NOT** remove the 3rd prong. See Grounding Instructions on the following pages.

4. **AVOID A DANGEROUS WORKING ENVIRONMENT.** **DO NOT** use electrical products in a damp environment or expose them to rain.

5. **DO NOT** use electrical products in the presence of flammable liquids or gasses.

6. **ALWAYS** keep the work area clean, well-lit, and organized. **DO NOT** work in an environment with floor surfaces that are slippery from debris, grease, and wax.

7. **KEEP VISITORS AND CHILDREN AWAY.** **DO NOT** permit people to be in the immediate work area, especially when the electrical product is operating.

8. **DO NOT FORCE THE MACHINERY** to perform an operation for which it was not designed. It will do a safer and higher-quality job by only performing operations for which the tool was intended.

9. **WEAR PROPER CLOTHING.** **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. The user must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.

10. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging machinery from the electrical receptacles, and using padlocks.

11. **ALWAYS UNPLUG THE MACHINE FROM THE ELECTRICAL RECEPTACLE** when making adjustments, changing parts, or performing any maintenance.

SAFETY INSTRUCTIONS

12. KEEP PROTECTIVE GUARDS IN PLACE AND IN WORKING ORDER.

13. AVOID ACCIDENTAL STARTING. Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

14. REMOVE ALL MAINTENANCE TOOLS from the immediate area before turning "ON" the machine.

15. USE ONLY RECOMMENDED ACCESSORIES. The use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the product. If in doubt, check the instruction manual that comes with that particular accessory.

16. NEVER LEAVE A RUNNING MACHINE UNATTENDED. Turn the power switch to the "OFF" position. **DO NOT** leave the machine until it has come to a complete stop.

17. DO NOT STAND ON THE MACHINE. Serious injury could result if the product tips over, or you accidentally contact the cutter.

18. DO NOT store anything above or near the machine where anyone might try to stand on the product to reach it.

19. MAINTAIN YOUR BALANCE. DO NOT extend yourself over the machine. Wear oil-resistant rubber-soled shoes. Keep the floor clear of debris, grease, and wax.

20. MAINTAIN MACHINES WITH CARE. Always keep the machine clean and in good working order. Keep all blades and tool bits sharp, dress grinding wheels and change other abrasive accessories when worn.

21. EACH AND EVERY TIME, CHECK FOR DAMAGED PARTS BEFORE USING THE MACHINE. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding, or breaking of moving parts. A guard or other part that is damaged should be immediately repaired or replaced.

22. DO NOT OPERATE A MACHINE WHILE TIRED, OR UNDER THE INFLUENCE OF DRUGS, MEDICATION, OR ALCOHOL.

23. SECURE ALL WORK. Use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.

24. STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING MACHINERY.

A moment of inattention while operating power tools may result in serious personal injury.

25. ALWAYS WEAR A DUST MASK TO PREVENT INHALING DANGEROUS DUST OR AIRBORNE PARTICLES, including wood dust, crystalline silica dust, and asbestos dust. Direct particles away from face and body. Always operate the machine in a well-ventilated area and provide for proper dust removal. Use a dust collection system wherever possible. Exposure to the dust may cause serious and permanent respiratory or other injuries, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. Allowing dust to get into your mouth or eyes, or lay on your skin may promote the absorption of harmful material. Always use properly fitting Australian Standard approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

26. USE A PROPER EXTENSION CORD IN GOOD CONDITION. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

USE ONLY A 3-WIRE EXTENSION CORD THAT HAS A 3-PRONG GROUNDING PLUG AND A 3-POLE RECEPTACLE THAT ACCEPTS THE MACHINES PLUG.

27. SAVE THESE INSTRUCTIONS. Refer to them frequently and use them to instruct others.

SAFETY INSTRUCTIONS

ELECTRICAL SAFETY

⚠ WARNING: THIS PRODUCT MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides the path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment-grounding conductor and requires a grounding plug. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

DO NOT MODIFY ANY PLUG. If it will not fit the electrical receptacle, have the proper electrical receptacle installed by a qualified electrician.

IMPROPER ELECTRICAL CONNECTION of the the equipment-grounding conductor can result in the risk of electric shock. The conductor with the green insulation(with yellow stripes) is the equipment grounding conductor. **DO NOT** connect the equipment groundingconductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

CHECK with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded when installing or replacing a plug.

USE ONLY A 3-WIRE EXTENSION CORD THAT HAS THE PROPER TYPE OF A 3-PRONG GROUNDING PLUG THAT MATCHES THE MACHINE'S 3-PRONG PLUG AND ALSO THE 3-POLE RECEPTACLE THAT ACCEPTS THE TOOL'S PLUG. *

REPLACE A DAMAGED OR WORN CORD IMMEDIATELY.

This tool is intended for use on a circuit that has an electrical receptacle as shown in **FIGURE A**. It shows a 3-wire electrical plug and electrical receptacle that has a grounding conductor.

FIGURE A



EXTENSION CORDS

⚠ WARNING: THE USE OF AN EXTENSION CORD WITH THIS MACHINE IS NOT RECOMMENDED. For best power and safety, plug the machine directly into a dedicated, grounded electrical outlet that is within the supplied cord length of the machine.

If an extension cord needs to be used, it should only be for a limited operation of the machine. The extension cord should be as short as possible in length.

⚠ WARNING: Check extension cords before each use. If damaged replace it immediately. Never use a product with a damaged cord, since touching the damaged area could cause electrical shock, resulting in serious injury.

⚠ WARNING: Keep the extension cord clear of the working area. Position the cord so that it will not get caught on timber, machines, or other obstructions while you are working with your product.

SAFETY INSTRUCTIONS

SPECIFIC SAFETY INSTRUCTIONS FOR THICKNESSERS

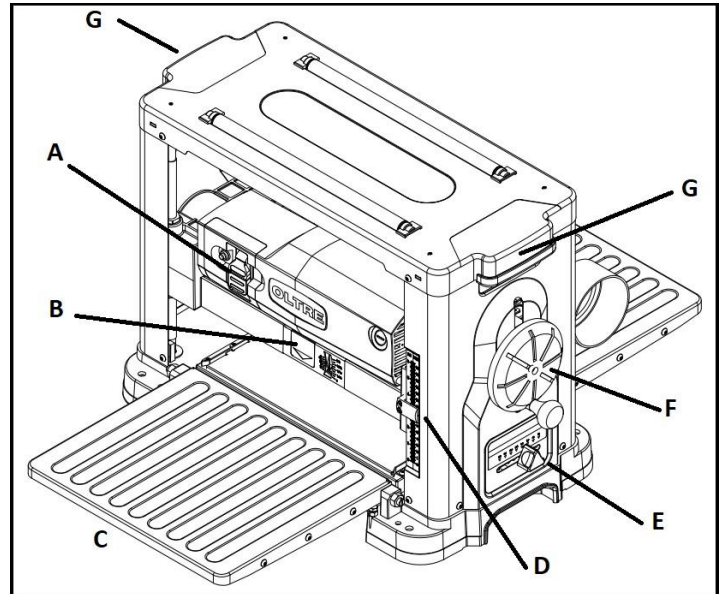
This machine is intended for the thicknessing of natural, solid woods. The permissible workpiece dimensions must be observed (see Technical Specifications). Any other use not as specified, including modification of the machine or use of parts not tested and approved by the equipment manufacturer, can cause unforeseen damage, and invalidate the warranty. **ATTENTION:** The use of this thicknesser still presents risks that cannot be eliminated by the manufacturer. Therefore, the user must be aware that woodworking machines are dangerous if not used with care and all safety precautions are adhered to.

1. Do not operate this machine until you have read all the following instructions.
2. Do not attempt to operate this machine until it is completely assembled.
3. Do not turn ON this machine if any pieces are damaged or missing.
4. This machine must be properly grounded.
5. If you are not familiar with the operation of the machine, obtain assistance from a qualified person.
6. Always wear approved, safety protective eyewear and hearing protection when operating this machine.
7. Always wear a dust mask and use adequate dust collection and proper ventilation.
8. Do not wear loose clothing or jewelry when operating this machine. Keep long hair tied back.
9. Always make sure the power switch is in the OFF position before plugging in the machine.
10. Always make sure the power switch is in the OFF position and the machine is unplugged when doing any cleaning, assembly, setup operation, or when not in use.
11. Make sure all safety guards and hardware are securely tightened before operating the machine.
12. Regularly check that the blades are locked tight in the cutter head.
13. Always keep hands and fingers away from the cutter head, chip exhaust opening, feed rollers, belts, and pulleys to prevent injury.
14. Never thickness wood less than 175mm long, widths under 19mm, or material less than 5mm thick.
15. Never make thicknessing cuts deeper than 3mm. Multiple cuts, 1.5mm or less, produce better finish results.
16. Make sure there are no loose knots, nails, staples, dirt, or foreign objects in the workpiece to be surfaced.
17. Use extra caution with large, warped, very small, or awkward workpieces. Plane warped boards flat before Thicknessing.
18. Use extra supports (roller stands, sawhorses, tables, etc.,) for any workpieces large enough to tip when not held down to the tabletop surfaces.
19. Surface wood in the same direction of the grain, not across the grain. Never plane end cuts or end grain.
20. Thickness only one workpiece at a time. Vary the feeding of the workpieces along with the cutter head, center/left/right, so that all of the knives get used and thus remain sharp, and longer.
21. Never reach inside of a running machine and avoid awkward operations and hand positions where a sudden slip could cause fingers or a hand to move into the cutter head.
22. Do not clear a jammed workpiece while the machine is running. Stop the machine, unplug it from the power source, and then remove the jammed workpiece. Lowering the table may be necessary to dislodge the workpiece.
23. Keep your face and body to one side of the machine during use, out of line with a possible 'kick back' (timber caught in by the rotating cutter head and thrown back towards the operator).
24. The use of any accessories or attachments not recommended may cause injury to you and damage your machine.
25. Sharpen or replace dull or chipped knives immediately, as injury to the user, or the machine may result.
26. Replacement knives/inserts should be from, or through a source recommended by the manufacturer.
27. Remove material or debris from the work area. Keep the work area neat and clean.

This owner's manual is not a teaching aid and is intended to show assembly, adjustments, and general use.

GETTING TO KNOW YOUR MACHINE

- A On / Off Safety Switch with Reset Button
- B Depth Gauge
- C Infeed Extension Table
- D Thickness Scale
- E Repeat Cut Indicator
- F Thickness Adjusting Handwheel
- G Lifting Handle



CONTENTS OF PACKAGE

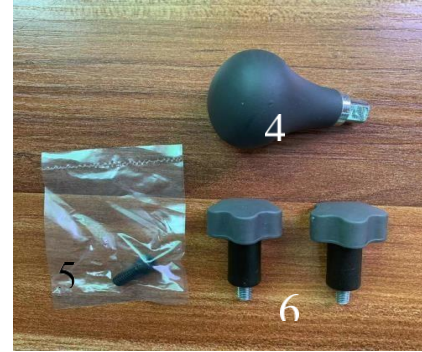
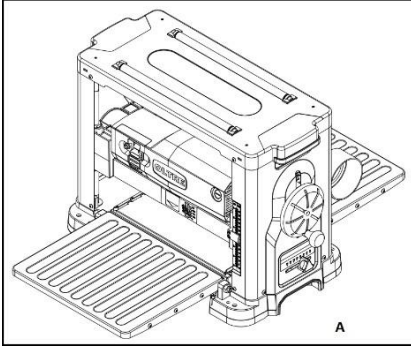
Model OT-TH-330 Planer is shipped complete in one box.

UNPACKING AND CLEAN-UP

1. Carefully remove all contents from the shipping carton. Compare the contents with the list of contents to make sure that all of the items are accounted for, before discarding any packing material. Place parts on a protected surface for easy identification and assembly. If any parts are missing or broken, please call your retailer as soon as possible for replacements. **DO NOT** turn your machine ON if any of these items are missing. You may cause injury to yourself or damage to the machine.
2. Report any shipping damage to your local distributor.
3. Clean all rust-protected surfaces with ordinary household-type grease or spot remover. Do not use, gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
4. Apply a coat of paste wax to the table to prevent rust. Wipe all parts thoroughly with a clean dry cloth. Be careful when reaching inside of the planer as the knives are sharp and may cause injury if touched.
5. Set packing material and shipping carton aside. Do not discard until the machine has been set up and is running properly.

CONTENTS OF PACKAGE

LIST OF LOOSE PARTS



- | | |
|-------------------------|-------|
| 1. DUST PORT | 1 pc |
| 2. HEX WRENCH 4mm x 100 | 1 pc |
| 3. TORX WRENCH | 1 pc |
| 4. HANDWHEEL KNOB | 1 pc |
| 5. HEX SCREW M5*P0.8*20 | 1 pc |
| 6. DUST PORT KNOB | 2 pcs |

INSTALLATION

MOVING & INSTALLING THE THICKNESSER

CAUTION When moving the thicknesser, only use the carry handles that are located on the side of the planer. DO NOT carry or move it using the infeed and outfeed extensions, dust chute, or handwheel.

1. The machine should be firmly bolted to a stand, and workbench to avoid any movement of the machine during use. The thicknesser base has holes in each of the four corners for this purpose (hardware is not included).

For portability and secure clamping of the thicknesser to a workbench, the thicknesser can be first permanently bolted to a piece of plywood. Then the thicknesser can be positioned on your workbench, or another solid surface and the plywood can be clamped in place to secure the thicknesser for use. After use, the plywood can be unclamped and the thicknesser stored away for future use.

2. When positioning the machine on a solid, level bench that is located in an area that ample space in front and in back of the thicknesser for the moving of timber to be milled. Align the machine so that during use, any kickback will not face aisles, doorways, or other work areas that bystanders may be in. Do not locate or use the machine in damp or wet conditions.



WARNING THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE 'OFF' POSITION UNTIL ASSEMBLY IS COMPLETE.

NOTE: The OT-TH-330 thicknesser requires minimal assembly, and therefore the machine can be mounted to a stand, workbench, or on a piece of plywood for portability and storage before assembling of the parts begins.

TOOLS REQUIRED FOR ASSEMBLY

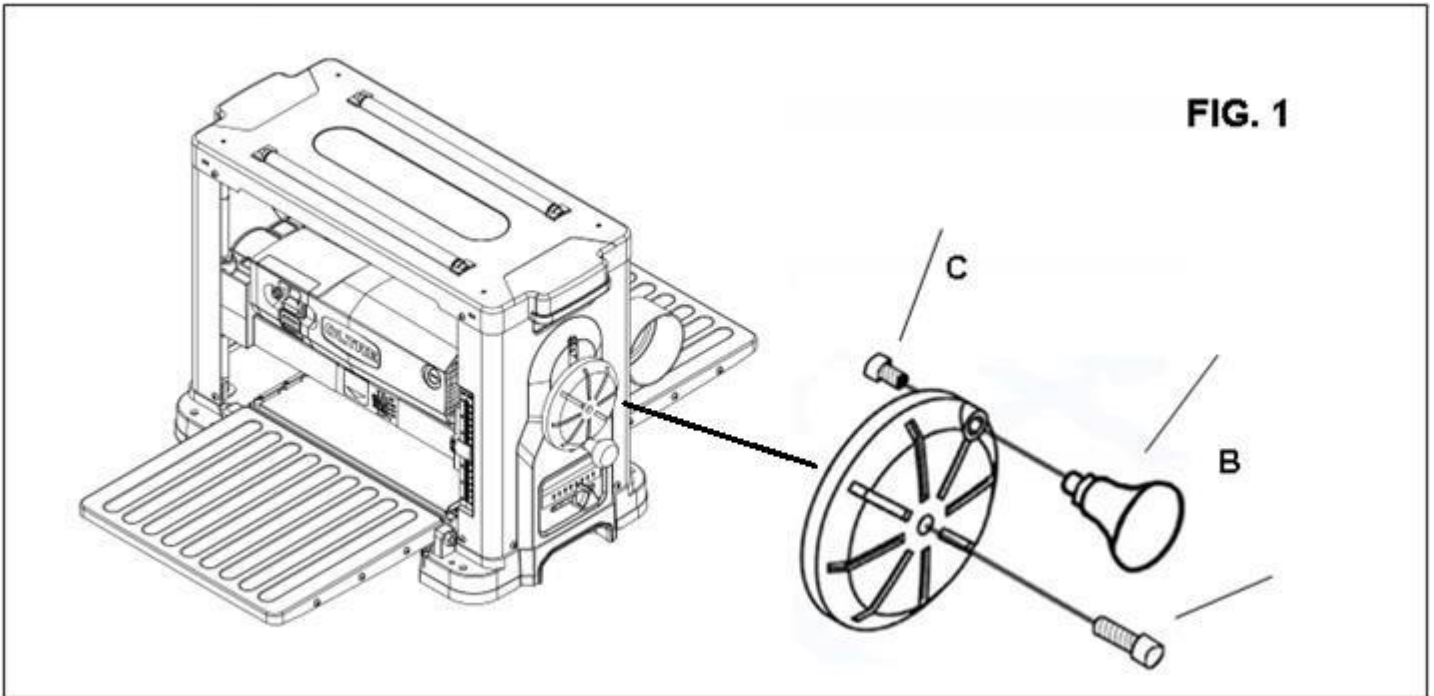
Straightedge or level

To check and adjust the extension tables level to the thicknesser table.

ASSEMBLY

INSTALLING THE HANDWHEEL KNOB for Height Setting of the Thickness Table

1. Remove the depth adjustment handwheel by loosening the screw (A), with the supplied 4mm hex wrench.FIG. 1.
2. Install the knob (B) onto the handwheel with the supplied screw (C).
3. Re-attach the handwheel to the thicknesser side and tighten it back in place with the screw (A).



INSTALLING THE DUST PORT

1. From the back of the machine, locate the dust port on the cutter head assembly. Remove the knobs by turning each counterclockwise. FIG. 2.
2. Align the dust port over the holes on the top of the cutter head assembly and replace the dust port knobs by turning them clockwise.
3. To minimize sawdust accumulation on your workpiece, attach either a 65mm or a 100mm. vacuum hose to the dust port end.



FIG. 2

ADJUSTMENTS

LEVELING THE TABLE EXTENSIONS

The infeed and outfeed table extensions are attached to the thicknesser. Shipped in a folded, upright position, the table extensions must be in the down position before thicknessing can begin. For accurate thicknessing, the table extensions must be level with the thickness table.

NOTE: For optimum performance, always check to make sure that the table extensions are level before beginning thicknessing operations.

To level:

1. Lay a straight edge (A) on the planer table (C) with one end of the straight edge over the infeed table (B). FIG. 3.
2. Check to make sure that the infeed table is level with the planer table.
3. If an adjustment is necessary, raise the table, loosen locknuts (D) and adjust Hex Head Screws (E) on each side of the table until the infeed table is level with the thicknesser table.
4. Recheck for level and repeat adjustment if necessary.
5. Repeat this process for leveling the outfeed table

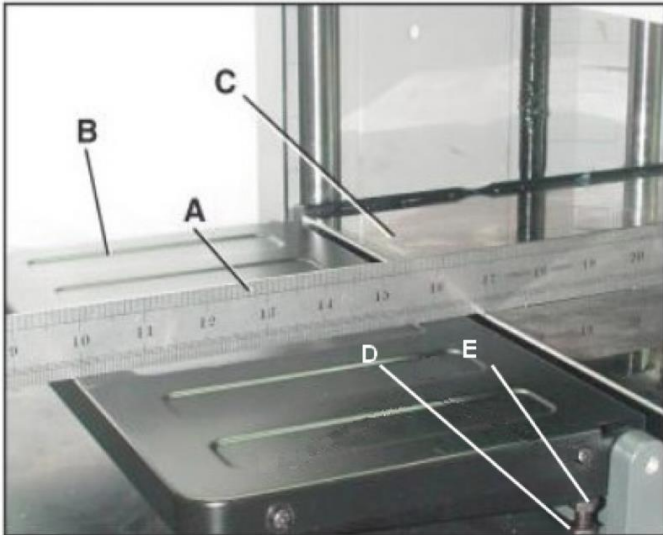


FIG 3

ADJUSTING THE DEPTH OF THICKNESSING

The Depth-Of-Cut Indicator, located on the front of the machine, is a convenient way to quickly determine how much material is being removed in one pass.

The workpiece must be positioned under the depth gauge on the front of the planer. FIG. 4. Each full revolution of the handle will raise or lower the cutter head by 1.6MM.

Never make a thickness cut deeper than:

- 3mm for material up to 150mm wide
- 1.5mm for material 330mm wide

CAUTION: DO NOT continuously use the planer at the maximum depth of cut, 3mm, as it will put excessive stress on the motor which will damage it.



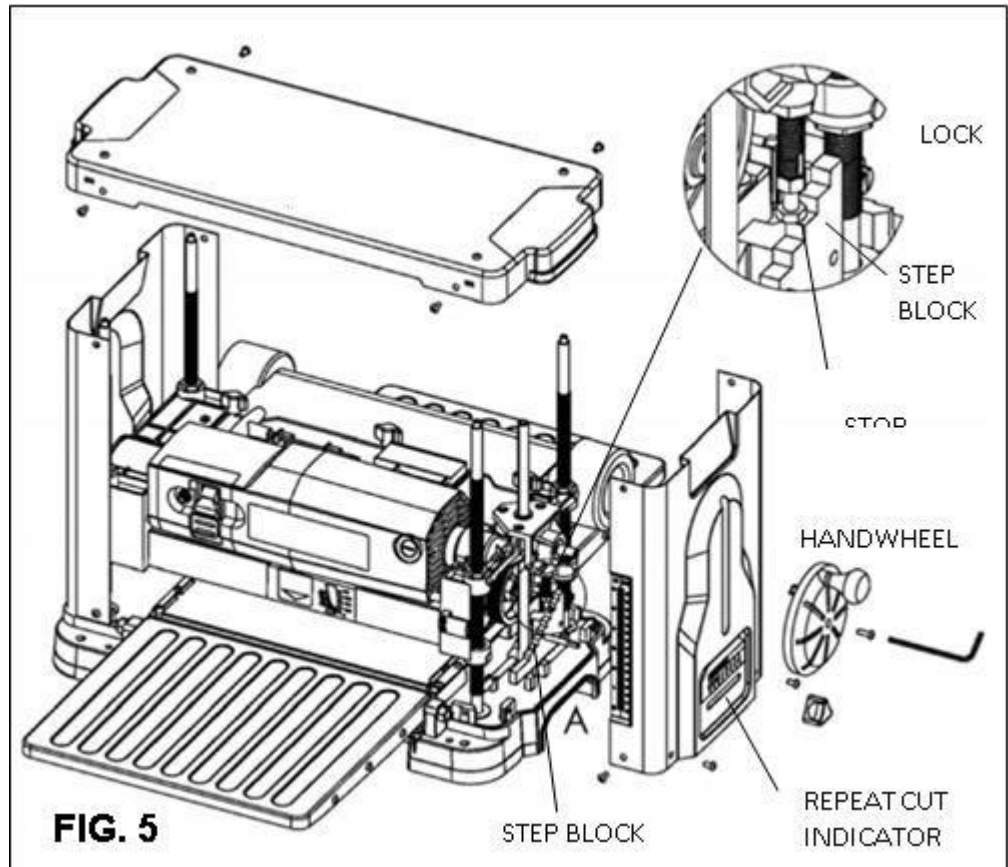
FIG 4

ADJUSTMENTS

RETHICKENING

using the REPEAT CUT

1. Remove the screws to take off the handwheel (1 screw), right side panel (4 screws), and top cover (4 screws). FIG. 5.
2. Lower the cutter head assembly until the stop screw stops on the step block.
3. Thickness a scrap piece of wood, then measure the thickness of the finished piece. It should be the same as the thickness scale and repeat cut indicator.
4. If an adjustment is necessary, use a wrench to loosen the lock nut and adjust the stop screw to correct the height.
5. Once the adjustment is made, retighten the lock nut and the stop screw securely.
6. Install the right-side panel, top cover, and handwheel back onto the Thicknesser.



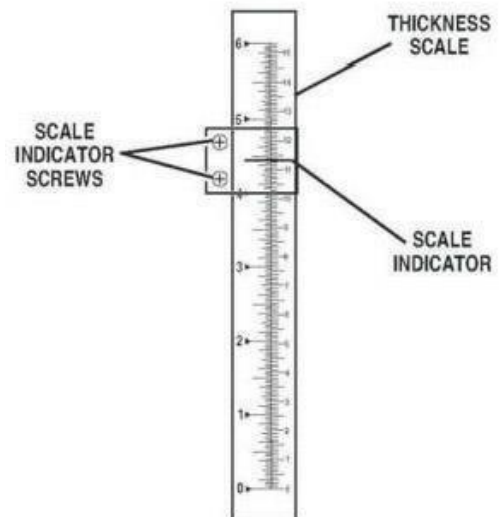
WARNING

THE MACHINE MUST NOT BE PLUGGED IN UNTIL ALL ADJUSTMENTS ARE COMPLETE.

THICKNESS SCALE ADJUSTMENT

Located on the right front of the thicknesser, the thickness scale shows the depth of the finished workpiece. Inaccurate cuts can be prevented by routinely checking the alignment of the thickness scale.

1. Table extensions must be level with a thicknesser table.
2. Thickness a scrap piece of wood, then measure the thickness of the finished piece.
3. If properly adjusted, the thickness of the finished piece should be the same as indicated on the scale.
4. If out of adjustment, loosen the two screws holding the scale indicator and adjust the scale indicator, up or down, to point to the correct setting on the scale.



OPERATION

This machine is intended for the thickening of natural, solid woods to the desired thickness while creating a smooth, level surface. The thickness of each cut will depend on the type of wood (hardwood versus softwood), the width of the workpiece, straightness, dryness, and grain composition. Whenever working with a new type of wood, make thin test cuts on a scrap piece of wood first to determine potential problems with the workpiece. The permissible workpiece dimensions must be observed. Any other use not as specified, including modification of the machine or use of parts not tested and approved by the equipment manufacturer, can cause unforeseen damage.

THICKENING

- Thicknessers work best if at least one side of the workpiece has a flat surface. When both sides of a workpiece are rough, use a surface planer or jointer first to define the initial flat surface. Thickness one side of the workpiece then flip the workpiece and thickness the surface of the reverse side.
- Always thickness both sides of a workpiece to reach the desired thickness. This will leave the workpiece with uniform moisture to prevent warp during the drying process.
- When one end of the workpiece is thicker than the opposite end by more than 3mm, make several cuts with the thicknesser starting with light cuts first. Light cuts create a finer finish than heavier cuts.
- Do not thickness a workpiece less than 5mm thick.
- Do not lower the cutter head assembly lower than 5mm.
- Do not plane a workpiece less than 9mm wide.
- Do not thickness workpiece shorter than 180mm long. Shortboards should be thicknessed end to end with other boards to prevent kickback and snipe.
- Boards longer than 600mm should have additional support as they enter and exit the planer, so that they do not tip-up or down, causing snipe on the ends.
- Do not thickness more than one workpiece at a time.
- Run boards through the planer at different positions along the width of the bed to utilize all the insert cutters along the length of the cutter head. Thicknessing only in the center, or through one side of the machine, will quickly dull the knives in that area.
- ALWAYS keep the cutter inserts sharp for the best cutting results.

THICKNESSER OPERATION

Before turning on the machine, review the safety precautions listed on pages 3 to 6. Make sure that you fully understand the features, adjustments, and capabilities of the machine that are outlined throughout this manual.

1. To feed the workpiece into the machine, assume the proper operating position, FIG. 7. Stand offset to one side of the feed opening to avoid any kick-back, should it occur. Do not push the timber once the infeed roller has been engaged. Let the infeed roller move the workpiece into the thicknesser at its own pace.

2. To remove the workpiece from the machine, position yourself offset to one side of the outfeed opening. FIG. 8. Do not pull the timber as it exits the machine. Let the outfeed roller move the workpiece out of the thicknesser at its own rate, but support the Timber as it extends past the extension rollers.

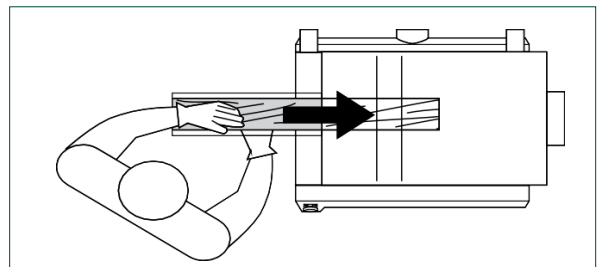


FIG. 7

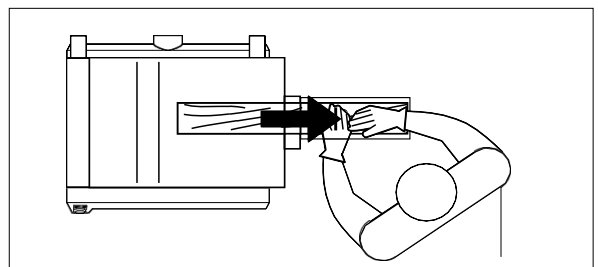


FIG. 8

OPERATION

POWER SWITCH

The thicknesser is turned on by pressing the green ON button and hold down for 2 seconds, this is an NVR (no voltrelay) type switch and is turned off by pressing the red off button. If the power is unplugged from the machine, then the thicknesser will not restart when the power is reconnected.

SNIPE

Snipes, or depressions made at either end of a workpiece by cutter inserts, can occur when the board is not properly supported. Although the snipe may be barely noticeable, it is important to keep the workpiece parallel and flat with the thicknesser table to minimize snipe.

- Butting workpieces end-to-end as they are fed through the machine will minimize the problem for shorter pieces because it provides a more stable feed through the whole cut.
- For stock longer than 1200mm, greater care must be taken to reduce the problem. The longer workpiece length means more weight is unsupported by the thicknesser table and extensions, causing the shifting weight to work against keeping the stock flat, especially at the entry or exiting of the stock from the thicknesser.
- To remove the snipe from a finished workpiece, cut off the end of the stock where the snipe is noticeable.

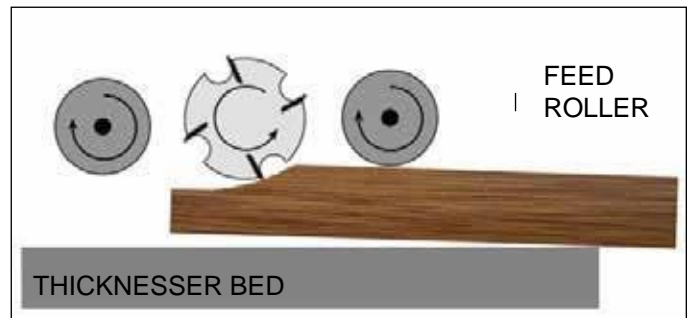


FIG. 9

WARPED WOOD

Little or no warpage is the ideal condition for thicknessing a workpiece. Simply turn the workpiece over and thickness it to the desired thickness. Otherwise, thickness the top flat first, turn the workpiece over, and thickness the bottom.

- For a board that is cupped or bowed across its width, the best method is to rip the board lengthwise down the middle and thickness the pieces separately. This method eliminates much of the waste in thicknessing cupped or bowed workpieces.
- The only way to remove the bow from a workpiece that is cupped or bowed down its length is to use a planer/jointer.
- Avoid using severely warped wood as it can jam the thicknesser. If it must be used, rip it in half before thicknessing to help minimize the possibility of jamming. If jamming does occur, turn the switch off and unplug the unit immediately. Raise the cutter head assembly high enough to remove the workpiece easily. Carefully check to make sure no damage to the tool has occurred before making the next thicknessing pass.
- Always feed the workpiece in the direction of the grain. This allows the cutter blades to sever the wood fibers instead of tearing them. Feeding against the grain can also cause the cutters to chip the workpiece.

DUST COLLECTION

A dust collection system must be used with this thicknesser to eliminate harmful airborne dust, prevent the build-up of chips that may jam the roller system in the cutter head, and keep the working area clean of debris. The thicknesser is supplied with 100mm and 65mm dust ports for attaching your choice of hose to your vacuum system. Make sure all connections are secure and your dust collector is turned on before any milling of timber is done.

MAINTENANCE



WARNING

THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE 'OFF' POSITION UNTIL ADJUSTMENTS ARE COMPLETE.

ROTATING OR REPLACING KNIFE INSERTS

This machine has a cutter head with 6 rows of High-Speed Steel knife inserts. Each of the 26 inserts on the cutter head is indexed and has two sharpened sides. If the knives become dull, or one becomes nicked, simply loosen the retaining screws with the supplied star head screwdriver, lift and rotate the inserts 90° to a new sharp edge. No setting is required, as the cutter head has been machined to automatically index and set the inserts in the proper position for use. When both sides of an insert are dull, the insert can be easily removed, and new knife inserts are placed in the location.

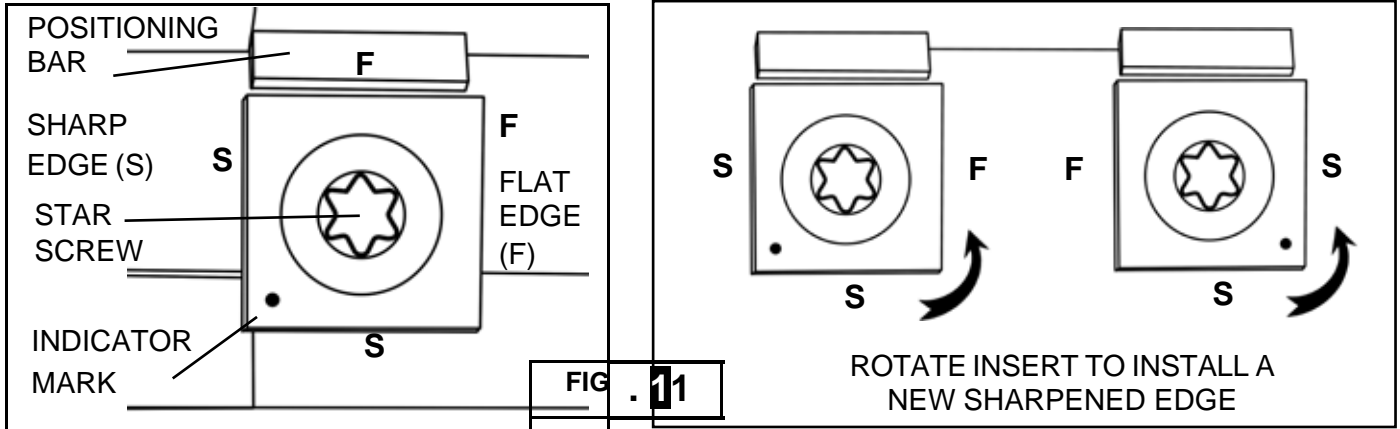
To rotate or remove a knife insert:

1. Unplug the power cable.
 2. Lower the upper frame motor housing to the lowest position near the thicknesser bed by turning the handwheel.
 3. From the back of the thicknesser, remove the two dust chute knobs and take off the dust chute.
 4. Insert the supplied Hex wrench through the hole located on the side of the machine above the Repeat Cut slider. Rotate the cutter head to a position where a cutter tip is visible. SEE FIG.10. next page. (You may have to raise or lower the cutter head to be able to insert the Hexwrench into the cutter head)
 5. Remove any sawdust from the head of the Star screw then remove the screw and cutter insert.
 6. While the insert is removed, clean any resin buildup or trapped dust from the insert and surfaces of the cutter head with a suitable solvent. A toothbrush works well for safe cleaning around the sharp inserts. Using compressed air is also useful. Be sure to wear safety glasses if compressed air is used.
- NOTE:** Any accumulated dust or resin buildup can affect the seating of the insert in the cutter head, raise it, and can make noticeable marks on your workpieces the next time your thickness.
7. Lubricate the Star screw threads with light machine oil, and wipe the excess oil off the threads.
 8. Install a new insert or rotate the old insert so that a newly sharpened edge is in position. The inserts have an indication mark on their top surface corner so that you can reference the positioning of the insert's dulled or sharpened edges. When rotating a cutter insert, it will seat itself back against the positioning bar during tightening-ing. Install the Star screw and torque it down to 48-50 inch/ pounds. Inserts have 2 sharp edges, and 2 flat edges. See FIG. 11.
 9. Once all insert changes have been made, put the thicknesser parts back together by reversing steps 2-4 above.
 10. Plug in the power cord when you are ready to resume thicknessing.



Fig 10

MAINTENANCE



THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE 'OFF' POSITION UNTIL ADJUSTMENTS ARE COMPLETE.

CARBON BRUSH REPLACEMENT

Carbon Brush life will vary depending on the load placed on the motor. The brushes should be inspected every 10-15 hours of use. To inspect the brushes:

1. Unplug the power cable.
2. Remove the two Brush Holders. One is located on the front right of the motor housing, FIG. 12, and the other is located in the same position on the rear of the motor assembly. The brush holders can be removed using a flat-head screwdriver.
3. Once the brush has been removed, inspect the carbon, the spring, and the wire.
4. If the carbon of either brush is worn down to 1/4" or less, both brushes should be replaced. Also, if the spring or wire is burned or damaged in any way, both brushes should be replaced.
5. After inspection or replacement of the brushes, replace the brush holders.
6. Plug in the power cable when you are ready to resume thickening.

FIG 12



MAINTENANCE

⚠ WARNING: Turn the power switch “OFF” and disconnect the plug from the outlet before adjusting or maintaining the machine. DO NOT attempt to repair or maintain the electrical components of the motor. Contact a qualified service technician for this type of maintenance.

1. Before each use:

- Check the power cord and plug for any wear or damage.
- Check for any loose screws or hardware.
- Check the area to make sure it is clear of any misplaced tools, timber, cleaning supplies, etc. that could hamper the safe operation of the thicknesser.

2. To avoid a build-up of wood dust, regularly clean all parts of the machine using a soft cloth, brush, or compressed air. General cleaning should be done after every use to avoid future problems and ensure the machine is in ready condition for the next time it is used.

WARNING: If blowing sawdust, wear proper eye protection to prevent debris from blowing into your eyes.

3. Check the knives to make sure that they are not loose from the cutter head, dull, or nicked. Making sure that they are in proper operating condition will ensure that the quality of your surfaced timber will be the best possible.

4. Clean and lubricate any moving parts regularly with a few drops of penetrating oil and lubricated with a light coating of medium-weight machine oil. Cutter-head ball bearings are lifetime lubricated, sealed, and do not need any further care. Keep the drive belts free of oil and grease.

5. Clean the bed columns regularly to prevent the build-up of wood chips and dust. Treat the posts with a dry lubricant spray. Do not use ordinary oil which will collect dust and hamper the operation of the machine.

6. Keep the thicknesser tables free of resin and rust. Clean them regularly with a non-flammable solvent, then coat with a light film of dry lubricant spray, or quality paste wax, to enhance the passage of workpieces on/over the table and extensions.

WARNING: When cleaning or working on the tables, avoid the risk of personal injury by cuts that may result from touching the knife inserts' sharp edges! Raise the planer table to its maximum 'up/thickness' position, so that there is ample distance between the table and the cutter head's sharp inserts for your safety.

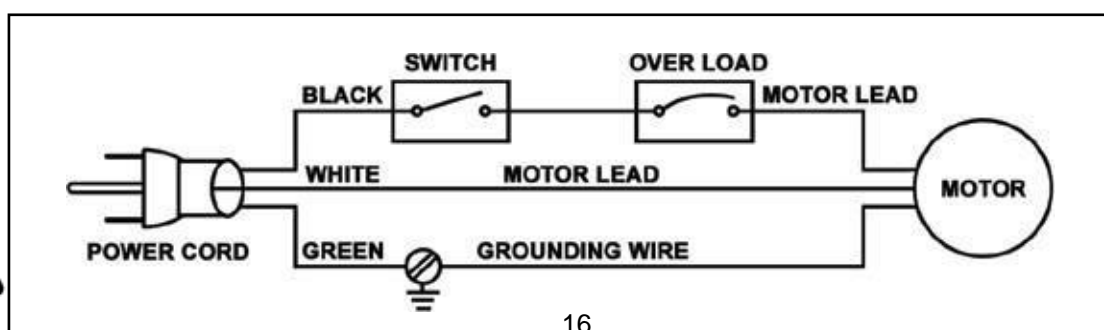
7. Clean the feed rollers with a soft rag, and non-flammable tar and pitch remover if there is resin build-up. Be careful to keep your hands away from the sharp cutter head knife inserts. Do not apply any lubricant to the rollers as they must 'grab' the lumber to move it through the planer and so must not slip.

8. Check the motor brushes every 10 - 15 hours of operation. Install new brushes as necessary. See page 15 for information on the process.

WIRING DIAGRAM

⚠ WARNING: This machine must be grounded. Replacement of the power supply cable should only be done by a qualified electrician. See page 5 for additional electrical information.

This tool is intended for use on a circuit that has a 240-volt electrical receptacle. The illustration on page 5 shows the type of 240v 10A, 3-wire electrical plug, and receptacle that has a grounding conductor that is required.



TROUBLESHOOTING



FOR YOUR SAFETY, ALWAYS TURN OFF AND UNPLUG THE MACHINE BEFORE CARRYING OUT ANY TROUBLESHOOTING.

SYMPTOM	POSSIBLE CAUSES	SOLUTIONS
Planer will not start.	<ol style="list-style-type: none"> 1. No power 2. Tripped overload on machine 3. The main on/off switch is not working 4. Motor failure 	<ol style="list-style-type: none"> 1. Check power source, plug, and wiring. 2. Check overload and press to reset if Tripped. May need to wait for the motor to cool down. 3. Check the position of the switches. Contact local dealer for repair or replacement. 4. Inspect motor for failed components. Contact Dealer for repair or replacement.
Circuit Breakers trip and /or Fuses are blown	<ol style="list-style-type: none"> 1. Wrong circuit size for machine 2. The motor is overloaded under strain from taking too heavy of a cut 3. Use of a long extension cord 	<ol style="list-style-type: none"> 1. Check circuit/fuse rating and amps of the motor. Install CORRECT rated breaker/fuse. 2. Take lighter cuts when thickening timber. 3. No extension cord or use a higher gauge.
Thicknesser feed rate and cutting are not consistent	<ol style="list-style-type: none"> 1. Chips, resin, and dust build-up on the thicknesser tables and parts. 	<ol style="list-style-type: none"> 1. Unplug the thicknesser from the power source and clean the planer parts.
Thickness timber does not match the thickness scale indicator	<ol style="list-style-type: none"> 1. Indicator scale is not set correctly. 	<ol style="list-style-type: none"> 1. Adjust the thickness scale indicator.
Small, raised lines are running along the surface	<ol style="list-style-type: none"> 1. Knives are nicked or broken 	<ol style="list-style-type: none"> 1. Rotate insert knives to new sharp edges.
Snipe on board ends (NOTE: Snipe can be reduced, but not fully eliminated)	<ol style="list-style-type: none"> 1. Lumber is not supported when fed into or exiting the thicknesser 2. Shortboards not butted 	<ol style="list-style-type: none"> 1. Support longboards with roller stands. 2. Run boards butt end to end through the thicknesser.
The thickness surface is torn	<ol style="list-style-type: none"> 1. Cutting against the grain 2. The cut is too deep 3. Knives are dull 	<ol style="list-style-type: none"> 1. Cut with the grain. For figured woods, take shallow cuts to minimize tear-out. 2. Reduce cutting depth to 1.5mm or less. 3. Rotate insert knives to new sharp edges.
Thickened surface grain is rough, raised, or fuzzy	<ol style="list-style-type: none"> 1. Timber has a high moisture content 2. The cut is too deep 3. Knives are dull 	<ol style="list-style-type: none"> 1. Reduce the moisture content by drying it, or the thickness of other properly seasoned timber. 2. Reduce cutting depth to 1.5mm or less. 3. Rotate insert knives to new sharp edges.
The thickened surface is glossy	<ol style="list-style-type: none"> 1. The cutting depth is too shallow 2. Knives are dull 	<ol style="list-style-type: none"> 1. Increase the depth of the cut slightly. 2. Rotate insert knives to new sharp edges.

For parts or technical questions contact your local Oltre Tools Dealer

OT-TH-330 Parts Listing

KEY No	PART NUMBER	Description	Size	Qty
1S	POT-TH-330-1S	Top cover assy.		1
2	POT-TH-330-2	Screw hex socket butt head	M6xP1.0x8L	12
4	#9505291	Elevation nut		8
6A-S	POT-TH-330-6A-S	Upper frame		1
7	POT-TH-330-7	Left side panel		1
8	POT-TH-330-8	Right side panel		1
9	#9505323	Knob		2
10	#9505301	Hand wheel		1
10a	POT-TH-330-10a	Screw	M5xP0.8x20L	1
11	#9505310	Knob		1
11a	POT-TH-330-11a	Screw hex	M5xP0.8x12L	1
13	#95053	Idler		2
14	#9505333	Idler shaft		2
15	#9505294	Threaded screw post		4
16	#9504316	Bevel gear		1
17	POT-TH-330-17	Bushing		1
19	POT-TH-330-19	Base		1
20	POT-TH-330-20	Hex wrench	4MM	1
21	#9505296	Torx wrench		1
22	#9505312	Belt guard		1
25	#9505306	Pointer		1
26	#9505311	Block guard		1
28	#9505328	Plate		5
29	POT-TH-330-29	Special washer		4
32	POT-TH-330-32	Handwheel bracket		1
33	#9505317	Chain wheel		6
34f	POT-TH-330-34f	Velcro		1
34g	POT-TH-330-34g	Blade box		1
35	POT-TH-330-35	Knob		1
38	POT-TH-330-38	Special washer		4
39s	POT-TH-330-39s	Dust hood assy.		1
43	POT-TH-330-43	Hex socket button screw	M6xP1.0x12L	1
44	POT-TH-330-44	Washer		1
45	POT-TH-330-45	Drive rod		1
46	POT-TH-330-46	Phillips screw	M4xP0.7x10L	11
47	POT-TH-330-47	Screw	M5xP0.8x8L	3
48	#9505297	Chip deflector		1
49	POT-TH-330-49	Screw	M5xP0.8x8L	1
50	POT-TH-330-50	Screw	M5xP0.8x10L	1
51	POT-TH-330-51	Clamp cord		1
54	POT-TH-330-54	Washer		1
55	POT-TH-330-55	Hex socket button screw	M8xP1.25x20L	1
61	POT-TH-330-61	Key		1
65	POT-TH-330-65	Motor pulley		1
66	#9505340	V-belt		1
69	#8900075	Cutter inserts	HSS insert	26

OT-TH-330 Parts Listing

No		Description	Size	Qty
70S	#9505293	Spiral cutterhead assy.		1
71	#9505348	Torx screw	M5xP0.8x9.6L	26
72	POT-TH-330-72	Hex nut		1
73	POT-TH-330-73	Thickness adjust rod		1
74	POT-TH-330-74	Hex nut	M5xP0.8	1
75	POT-TH-330-75	Adjust screw		1
76	POT-TH-330-76	Screw		8
77	POT-TH-330-77	Phillips button screw	M3xP0.5x22L	2
78	POT-TH-330-78	Hex socket button screw	M5xP0.8x12L	10
78A	POT-TH-330-78A	Hex socket button screw	M5xP0.8x12L	10
78B	POT-TH-330-78B	Hex socket button screw	M5xP0.8x8L	2
81S	POT-TH-330-81S	Depth of cut indicator Assy.		1
87	POT-TH-330-87	Screw PAN		2
88	POT-TH-330-88	Lockwasher		2
90	POT-TH-330-90	C-ring		3
91	#9505314	Chain wheel		4
92	#9505307	Chain		2
93	#9505335	Spring		2
94	#9505305	Block bearing		4
95	#406868	Outfeed roller		1
96	#9505327	Spring		2
97	#9505325	Plate retainer		4
98	POT-TH-330-98	Screw HEX SOC CAP		8
99	#406869	Infeed roller		1
100	#9505303	Gear box cover		1
101	POT-TH-330-101	Gear		1
102s	POT-TH-330-102s	Gear box assy.		1
113	POT-TH-330-113	Screw		4
115	POT-TH-330-115	Spacer		1
116	POT-TH-330-116	Screw		8
117	#9505300	Rail guide		2
118	#406632	Plate wear		1
119	#9505339	Extension table		2
121	POT-TH-330-121	Washer		2
122	POT-TH-330-122	Washer		1
123	POT-TH-330-123	Ball bearing		1
125	#9505322	Turning shaft		1
128	POT-TH-330-128	Scale		1
129	#9505313	Spacer		3
130	#9505302	Step block		1
131	POT-TH-330-131	Step block pin		1
132	POT-TH-330-132	Hex nut		1
133	#9505336	Spring		1
134	POT-TH-330-134	Steel ball		1
135	#9505315	Pivot rod		1
136	#9505324	Adjust screw		4

OT-TH-330 Parts Listing

KEY		Description	Size	Qty
137	P25-130H-137	Hex nut		4
138	#9505326	Spring plate		4
139	P25-130H-139	Pan head screw	M5xP0.8x10L	8
140	P25-130H-140	Hex screw	M6xP1.0x25L	4
141	POT-TH-330-141	Hex nut	M6xP1.0	4
142	POT-TH-330-142	Ball bearing		5
143	POT-TH-330-143	Washer		5
144	POT-TH-330-144	Screw hex SOC CAP	M4xP0.7x12L	5
145	#9505309	Chain		1
146	#9505308	Chain		1
147	POT-TH-330-147	Hex socket button screw	M5xP0.8x25L	2
148	POT-TH-330-148	Screw hex SOC CAP	M5xP0.8x16L	2
149	POT-TH-330-149	C-ring		3
155	POT-TH-330-155	Washer		5
162	POT-TH-330-162	Hex socket button screw		1
163	POT-TH-330-163	Spring washer		3
164	#9505329	Washer		4
173A	#8000911	Switch	NVR, KJD17	1
188	POT-TH-330-188	Holder brush		2
189	#8000914	Carbon Brush		2
190	#9505346	Cap brush		2
191	POT-TH-330-191	Logo label	OLTRE	1
195	POT-TH-330-195	Spec label		1
202	POT-TH-330-202	Repeat Cut label		1
203	POT-TH-330-203	Safety Warning label		1
204	POT-TH-330-204	Label		1
205	POT-TH-330-205	Label		1
206	POT-TH-330-206	Bushing		1
207	POT-TH-330-207	Washer		1
208	#9505330	Spring		1
209	#9504315	Bevel gear		1
226	POT-TH-330-226	Short bar		1
229	POT-TH-330-229	Spacer		14
230	POT-TH-330-230	Spacer		4
231	POT-TH-330-231	Anti-kick jaw		18
232	POT-TH-330-232	Pad		4
233	POT-TH-330-233	Velcro		2
234	POT-TH-330-234	Special hex soc		4
235	POT-TH-330-235	Long bar		1
236S	POT-TH-330-236S	Roller tube assy.		1
600S	#8900076	Motor assy.		1

