

Planer & Thicknesser PT310A

Instruction Manual

IMPORTANT

For your safety read instructions carefully before assembling or using this product. Save this manual for future reference.



HEALTH AND SAFETY GUIDELINES

Always follow the instructions provided with the manual. Always wear safety glasses when using woodworking equipment. Always disconnect the power before adjusting any equipment. Failure to observe proper safety procedures and guidelines can result in serious injury.

WARNING: Do not allow familiarity (gained from frequent use of your machine and accessories) to become commonplace. Always remember that a careless fraction of a second is sufficient to inflict severe injury.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

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1. General Information

1.1 FOREWORD

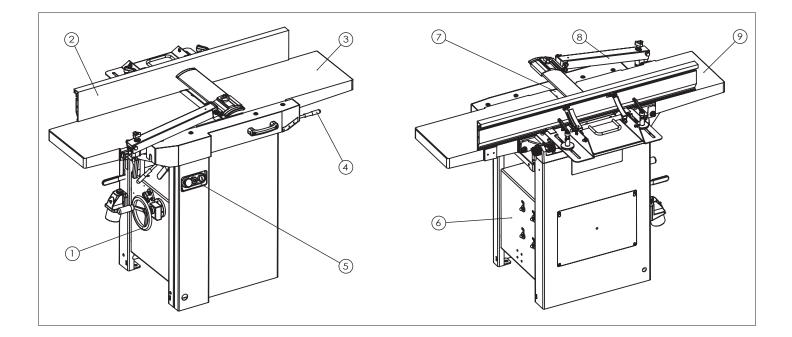
This manual must be read and understood before operating the machine. This will provide a better working knowledge of the machine, for increased safety and to obtain the best results.

2. Machine Description

2.1 MACHINE IDENTIFICATION

There is a metallic identification plate fixed to the machine, containing the manufacturer's data, year of construction, serial number.

2.2 GETTING TO KNOW YOUR MACHINE



- 1 Height setting of thicknesser bed
- 2 Jointer fence
- 3 Infeed table
- 4 Height setting of infeed table

- 5 On/off switch
- 6 Frame
- 7 Cutterblock
- 8 Cutterblock guard
- 9 Outfeed table

2.3 TECHNICAL SPECIFICATION

SPECIFICATION	PT310A
Feed speed m/min	7
Cutterblock speed rpm	5500
Cutterblock diameter mm	70
Max thicknesser capacity mm	305x225
Max planing width mm	310
Max depth of cut thicknesser mm	3
Max depth of cut planer mm	3
Knives pcs	3
Fence tilting degree	0-45
Motor power output	2.5kW
Net Weight kg	230

2.4 RECOMMENDED PROTECTIVE CLOTHING

• Non-slip footwear is recommended.

• Do not wear loose clothing, neckties or jewellery; they can be caught in moving parts.

Roll up long sleeves above the elbow.

• Wear protective hair covering to contain long hair.

2.5 NOISE EMISSION

The measurements of noise, in the working position and during operation, were carried out under the standard ISO 7960 Annex B and C:

Instantaneous acoustic pressure:

<98dB(A)
<107dB(A)
<89dB(A)
<98dB(A)

Constant K=4 dB measured in accordance with EN ISO 3746:1995

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. Also the permissible exposure level can vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.

2.6 PRESCRIBED USE OF THE MACHINE

This machine is intended for surface planing and thickness planing of solid woods. The permissible workpiece dimensions must be observed (see Technical Specification).

Any other use is not as specified. Unspecified use, modification of the machine or use of parts not tested and approved by the equipment manufacturer can cause unforeseen damage.

2.7 HAZARDS

ATTENTION Planer & thicknesser still present risks that cannot be eliminated by the manufacturer. Therefore the user must be aware that wood working machines are dangerous if not used with care and all safety precautions adhered to.

2.8 SAFETY INSTRUCTIONS FOR PLANER.THICKNESSER

A planer/thicknesser is a tool which can, due to operator carelessness, cause serious personal injury. It is therefore strongly recommended you read and observe:

· these instructions, particularly the special safety information in the respective chapters;

• the relevant guidelines or regulations for the prevention of accidents pertaining to the use of planer/thicknessers, where applicable.

Keep all documents, supplied with the machine, for future reference.

The planer/thicknesser shall only be started and operated by persons familiar with planer/thicknessers and who are at any time aware of the dangers associated with the operation of such tool. Persons under 18 years of age shall use this planer/thicknesser only under the supervision of an instructor in the course of their vocational training.

The following residual risks do principally exist with planer/thicknessers and can not, even by employing safety devices, completely eliminated:

- Hazard generated by environmental conditions:

do not operate the planer/thicknesser in rain or damp environment. Ensure sufficient lighting. Do not

operate the planer/thicknesser near inflammable liquids or gases.

- Hazard to other persons in the work area:

Keep bystanders, particularly children, out of the danger zone.

- Risk of injury by machine faults:

check the planer/thicknesser for damage before any use. Do not operate the machine with a damaged part. Replace blunt cutter knives at once. Risk of injury by kickback if a blunt knife gets caught in the workpiece's surface.

- Risk of injury by an unstable stand of the planer/thicknesser:

when working long stock use suitable supports on both sides of the machine. Avoid adverse body positions. Ensure firm footing, and keep your balance at all times.

- Risk of injury by foreign objects in the machine:

prior to any starting of the machine ensure that there are no objects (e.g. tools) in the machine.

- Risk of injury by workpiece kickback (workpiece is caught by the rotating cutterblock and thrown back against the operator):

operate machine only with a fully functional anti-kickback lock. Always use sharp cutter knives. If in doubt check workpiece for inclusion of foreign objects (e.g. nails, screws, lose knots).

- Risk of injury by touching the rotating cutterblock:

always keep your hands well clear of the cutterblock. Switch machine off and plug out if it is not used.

- Danger! Drawing-in/trapping hazard!

Take care that no parts of the body or clothing can get caught and drawn in by the rotating cutterblock (do not wear neck ties and garments with wide sleeves; contain long hair with a hairnet).

- Risk of injury by cuts with cutterblock at standstill: Wear gloves when changing cutter knives.

- Risk of injury by inhaling wood dust: dust of certain timber species (e.g. oak, beech, ash) can cause cancer when inhaled. Use a suitable dust collector:

- fitting the outer diameter of the suction port (100 mm)
- air volume >= 815 m3/h;
- vacuum at suction port of machine >= 740 Pa;
- air speed at suction port of machine >= 20 m/s;
- Risk of injury by inadequate personal protection: when planing, wear:
- dust respirator;
- hearing protection;
- safety goggles.

- The electrical equipment shall be operated under the load with the conditions of the nominal supply: 0.9 to 1.1 times of nominal voltage.

- The electrical equipment shall be opearted in an ambient air temperature between +5°C and +40°C, and the average ambient air temperature over a period of 24 h shall not exceed +35°C.

- The electrical equipment shall be operated within a relative humidity not exceed 90%(20°C).

- The electrical equipment shall be operated at altitudes up to 1000m above mean sea level.

- The mains connection must have maximum 16A fuse.

- Connect the main leads to a standard electrical supply which has protection devices of under-voltage, over-voltage, over-current as well as a residual current device (RCD) which maximum residual current rated at 0.03A, the main connection must have maximum 16A time-lag fuse.

- The anti-kick back device shall be checked once every working shift that they are in good working condition, e.g. the contact face for impact damage and that the fingers return to their rest position by gravity.

- Regularly check the brake performance, the braked run-down time shall be less than 10s.

3. Installation

3.1. LIFTING AND UNLOADING

The machine can be transported by two means:

- with a forklift truck. To do so, the machine is secured on a pallet with four hex bolts.

- by several persons. Here, the machine is carried by means of carrying straps or two battens (A, Fig.1) placed underneath the thicknesser bed.

CAUTION

Do not carry the machine holding it at the infeed and outfeed tables, these are not designed to withstand the tensile load by the machine weight.

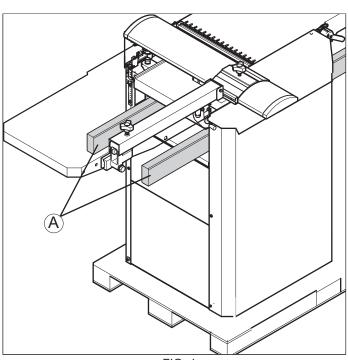


FIG. 1

3.2 POSITION OF THE MACHINE

CAUTION

It is prohibited to install the machine in explosive environments. Ensure that the floor area around the machine is level, well maintained and free from loose material e.g. chips;

- 1. Remove four mounting bolts from the machine base.
- 2. Lift machine off the pallet and set down on the floor.

3. Fix the machine to the floor. Fix the machine feet and fix on ground by means of expansion bolts (not supplied).

3.3 IDENTIFYING SHIPPING BOXES

BEFORE ASSEMBLY

It is advisable that before unpacking to have plenty of paper towels or cloths available to clean off the rust preservative.

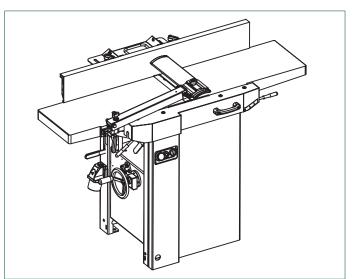


FIG. 2

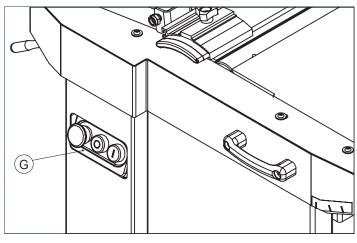


FIG. 3

3.4. INSTALLATIONS OF LOOSE PARTS

3.4.1 SWITCH - INSTALLATION

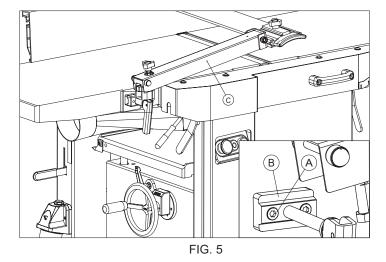
- Fit the switch (G, Fig.4) onto the bracket with two hex nuts.





3.4.2 Cutterblock guard - INSTALLATION

- Take off both of the hex socket screws (A, Fig.5). Install the cutterblock guard assembly (B, Fig.5) using two of hex socket screws. Make sure the square washer (C, Fig. 5) stay between the table and cutterblock guard.



3.5 ELECTRICAL CONNECTION

Electrical installation should be carried out by competent, qualified personnel.

The mains connection should be made using the terminal box.

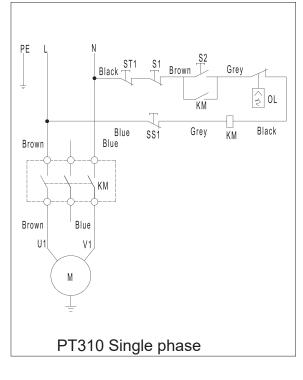
Ensure that the mains supply corresponds with that of the machine, use cables of a section suitable for the power of the motor. For a supply tension of 400 V the minimum section recommended is 2.5 mm, including the earth wire.

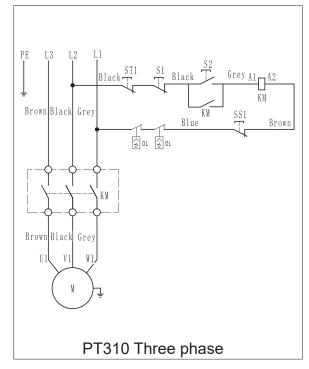
For a mains supply of 230 V or a power rating greater than 15 A it will be necessary to increase the section of the connecting cables .

Connect the phase wires to the terminals R-S-T (L1 - L2 - L3) and the earth wire to the earth terminal.

On initial start-up check the direction of rotation, if it is incorrect then invert the two phase wires (for machines with 3 phase supply). Direction of rotation of machines with single-phase supply is pre-determined during production .

On completion of the installation check that the terminal box is closed correctly and that the plug points are locked.





3.6. DUST CHUTE - INSTALLATION

The dust chute complete with suction connector must be installed for thickness planing.

CAUTION: The contact pins on the shaft of the dust chute (A, Fig. 6) must engage properly in the limit switch. Incorrectly installed dust chute the machine will not start.

Connect a suitable dust collector to the suction connector of the planer/thickesser.

4. Adjustment

4.1. THICKNESSER TABLE HEIGHT ADJUSTMENT

With the height setting for the thicknesser bed the planing thickness (= thickness of the workpiece after planing) is set when the machine is used for thickness planing.

 \cdot Per pass a maximum of 3 mm material can be removed.

 \cdot Workpieces of max. 200 mm thickness can be planed. Height adjustment is made with a handwheel (B, Fig.7). One full turn of the crank changes the height of the thicknesser bed (C, Fig.7) by 4 mm.

· Clockwise turning = raises the thicknesser bed

 \cdot Counter-clockwise turning = lowers the thicknesser bed. The set planing thickness is indicated on the scale (D, Fig.7).

4.2. INFEED TABLE HEIGHT ADJUSTMENT

With the height setting for the infeed table (E, Fig,8) the depth of cut is set when the machine is used for surface planing.

 \cdot The scale (F, Fig.8) next to the adjusting lever (G, Fig.8) corresponds to 1 mm chip removal.

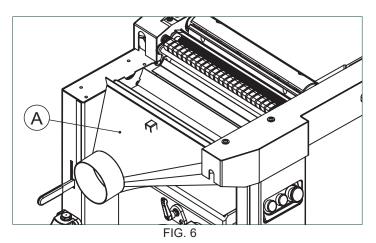
- Per pass a maximum of 3 mm material can be removed.

4.3. JOINTER FENCE ADJUSTMENT

The jointer fence (I, Fig.9) provides lateral support for the workpiece when surface planing.

 \cdot After loosening the lock lever (J, Fig.9) the jointer fence can be adapted to the workpiece width.

 \cdot After loosening the lock lever (K, Fig.9) the jointer fence extrusion can be tilted to the angle between 0°- 45°.



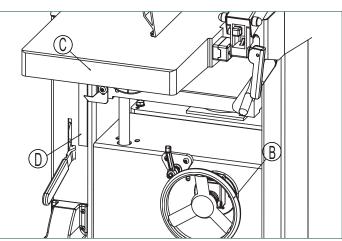
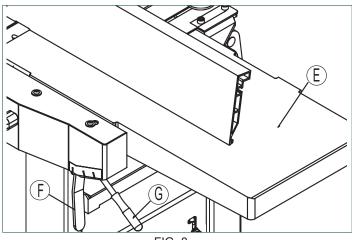
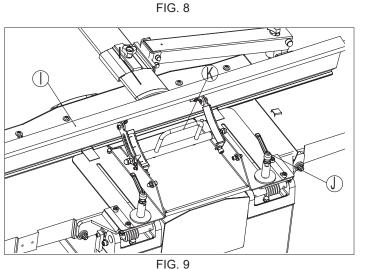


FIG. 7

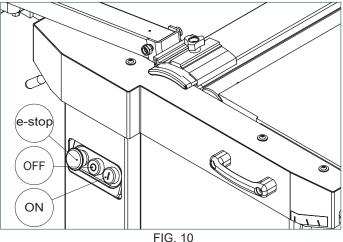




5. Operating Procedures

5.1. ON/OFF SWITCH (Fig.10)

- · To switch ON = press green switch button.
- · To switch OFF = close cover or press red switch button.
- · To unlock the switch cover push the pin on the stop cover.



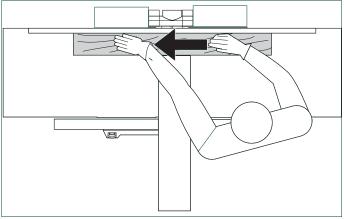
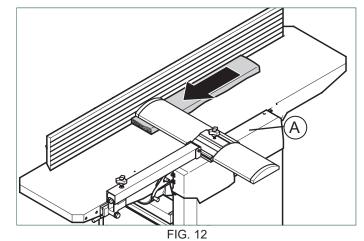
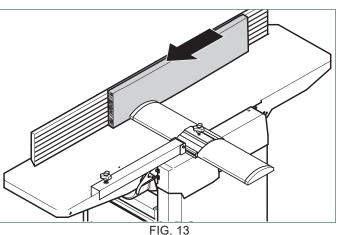


FIG. 11





5.2 SURFACE PLANER MODE:

Note: With surface planing, an irregular surface is planed flat (= jointed).

- The workpiece rests on top of the infeed table.
- The workpiece is cut on the underside.

- The feed direction of the workpiece is exactly opposite than when thickness planing.

Workpiece dimensions

- Length: use a push stick to feed workpieces shorter than 250 mm; for workpieces over 1500 mm use a second person for support.

- Width: max. 310 mm.
- Thickness: min. 5 mm.

Note: The max. depth of cut for a single pass is 3 mm.

- 1. Assume proper operating position:
- position yourself to one side of the infeed table.
- 2. Set jointer fence as required.
- 3. Set planing thickness.
- 4. Place workpiece against jointer fence .
- 5. Adjust cutterblock cover:
- when planing narrow edges (jointing) or workpieces more than 75 mm thick:

Set cutterblock cover from the side against the workpiece (A, Fig.12)..



- Planing the face of a plank or workpieces up to 75 mm thick: lower cutterblock cover from top onto workpiece. Adjust cutterblock cover so that the undermentioned distances are not

exceeded in any position:

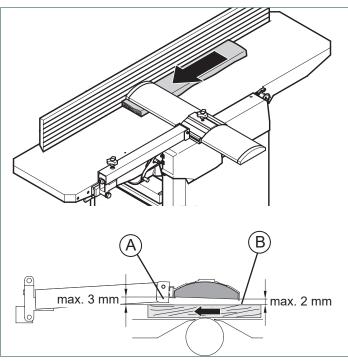
rear edge (A, Fig.14) - workpiece max. 3 mm;

front edge (B, Fig.14) - workpiece max. 2 mm.

6. Start motor.

7. Feed workpiece straight across the infeed table holding your fingers close together, guiding the workpiece with the palm of your hands. Exert downward pressure on the workpiece only in the infeed table area.

8. Switch machine off if no further cutting is to be done immediately afterwards.





5.3. THICKNESS PLANER MODE

Note: Thickness planing is used to reduce a workpiece with one already surface planed surface to a desired thickness.

- The workpiece is run through the thicknesser.

- The surface already planed flat rests on the thicknesser bed.

- The workpiece is cut on the upper side.

- The feed direction of the workpiece is exactly opposite than with surface planing.

Workpiece dimensions

- Length: min. 200 mm; for workpieces over 1500 mm use a second person for support.

- Width: max. 305 mm.

- Thickness: min 6 mm; max. 200 mm.

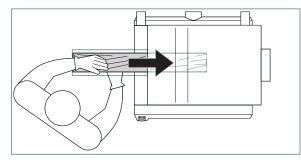
Note: The max. depth of cut for a single pass is 3 mm.

1. Turn clamping lever (B, Fig.15) outward and swing the outfeed table (C, Fig.15) together with the fence to the left. Make sure the outfeed table stopper (D, Fig.15) is engaged (When close the outfeed table, please don't forget the release the stopper first). 2. Turn the dust chute (E, Fig.15) with installed suction connector to the machine .

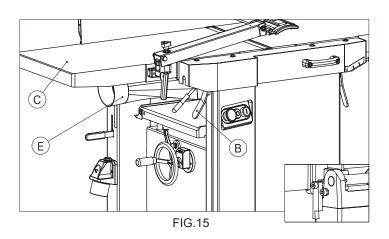
3. Assume proper operating position:

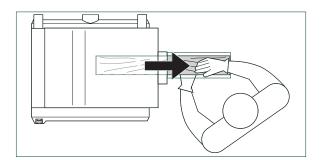
- to feed the workpiece into the machine, position yourself offset

to one side of the feed opening.



- to remove the workpiece from the machine, position yourself offset to one side of the outfeed opening.





5. To thickness plane stock which surfaces are not parallel, use suitable feeding aids (make fitting templates).

- 6. Set planing thickness.
- 7. Start motor.

8. Feed workpiece slowly and straight into the thicknesser. It will then be automatically fed through the thicknesser.

9. Guide workpiece straight through the thicknesser.

10. Switch machine off if no further cutting is to be done immediately afterwards.

6. Maintenance

6.1 REPLACING CUTTER KNIVES

CAUTION! Risk of personal injury by cuts from the cutter knives! Wear gloves when changing cutter knives.

To remove the cutter knives:

1. Unplug power cable.

2. Push fence back.

3. Raise cutterblock cover fully and pull extrusion fully outwards.

4. Turn the five hexagon head screws of the cutter knife lockbar fully in wear gloves! (Fig.16).

5. At first remove cutter knife, then cutter knife lockbar from the cutterblock.

6. Clean all surfaces of cutterblock and cutter knife lockbar with a suitable solvent.

7. Place fresh cutter knife on cutter knife lockbar.

8. Place cutter knife lockbar with the fitted cutter knife into the cutterblock.

9. Check the projection of the knives:

- With the provided straight edge gauge .

- Place straight edge gauge across outfeed table and cutterblock as shown.

- Turn cutterblock by hand one turn against the direction of feed. - The cutter knives are set correctly if the straight edge is moved forward 4 to 6 mm by the turning cutterblock. This check must be performed at both ends of the cutterblock. (Fig.17)

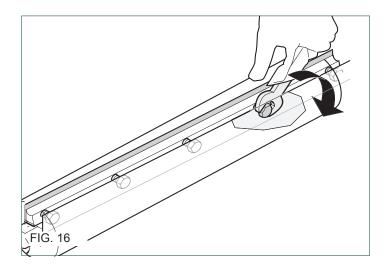
10. To tighten the cutter knives, turn the five hexagon head screws of the cutter knife lockbar fully out. To prevent distortion of the cutter knife lockbar start with the screws in the centre , then tighten the screws closer to the edges step by step.(Fig.18)

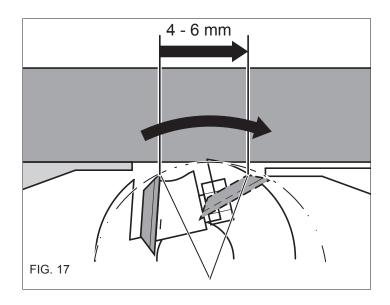
Danger!

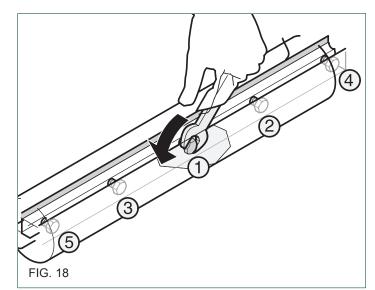
- Do not extend tool when tightening the screws.

- Do not tighten bolts by striking the wrench.

11. Return cutterblock cover to its starting position.







6.2 Drive Belt Check

The cutterblock drive belt and the feedgear drive belt need to be checked periodically and retightened if necessary. Both drive belts are located behind the machine's side panel.

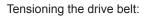
Checking the drive belt:

1. Unplug power cable.

2. Pull the fence (A, Fig.19) forward.

3. Take off the the side panel (B, Fig.19) and belt cover (C, Fig.19).

4. Check belt tension with thumb pressure. The drive belt should not give more than 10 mm in the centre.



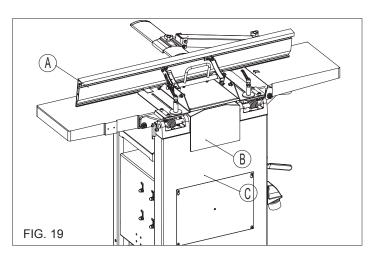
5. From outside the machine, loosen the four nuts (D, Fig.20) – using stick (E, Fig.20) to increase the motor, the cutterblock drive belt will be slackened.

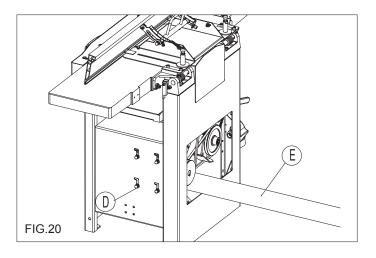
CAUSTION: When increase the motor by stick, don't damaged the motor wiring box.

6. To tension the cutterblock drive belt, push the motor downward. When belt tension is correct tighten motor mounting nuts (D, Fig.20).

7. If necessary, remove chips and dust with dust collector or brush.

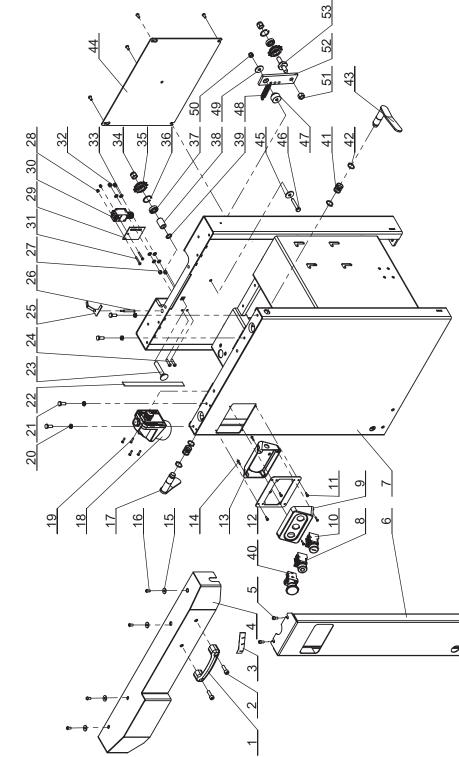
8. Replace the side panel and belt cover secure with the screws.





Frame Assembly-SHEET A

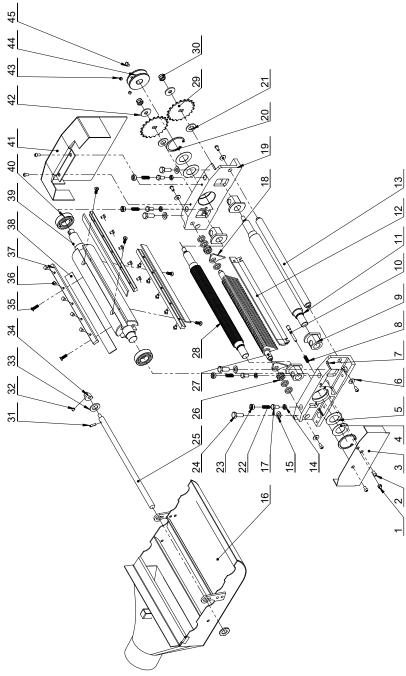
1	rrame /	Frame Assembly-SHEET A	₹ [
ġ.	Description	Part No.	ğ
- c	Handle	JL45030030A	- c
N W	Label	M6A2UGD/UD JL45030031B	v ←
4	Left cover	JL45032000C	-
5	Screw	M6X12GB70D1Z	2
9	Front cover assy	JL45013000	~
~ ′	Frame	JL45010000F	~ ~
οσ	Switch hoy	LA39-BZ-10-W	
, 5	Stop knob	LA39-B2-01-K	
1	Screw	M4X12GB70D1Z	4
12	Switch plate	JL45090009	-
13	Switch box	JL45090011	-
1 4 7	Tapping screw	ST3D5X16GB845Z	4 -
10	Borew	M6X12GB70D2B	+ 00
17	Handle	JL45030026	-
18	Plug	P224E-13A(1PH)/	-
10	Don scrow	P226E-03A(3PH) M4Y16CB8237	~
20	Nut	M8GB6172Z	14
21	Ball head bolt	JL45030016	4
22	Scale	JL45040019	-
23	Square neck bolt	M12X65GB801Z	-
24	Hex. Screw	M6X25GB70D2B	2
25	Plate	JL45090003	~ ~
07 0	Kod Nut	JL45U9UUU5 MACD417	- c
28	l ocknut	M4GB8897	N 0
29	Switch plate	JI 45090004	1 ←
30	Switch	QKS7	· -
31	Pan screw	M4X30GB818Z	2
32	Locknut	M6GB889Z	2
33	Plat washer	WSH6GB97D1Z	9
34 1	Hex.locknut	M12GB889B	2 1
20 90	l ensioner Rind		л с
37	Bearing	BRG6001-2RSGB276	10
38	Tube	JL45052002B	-
39	Adjust cushio	JL40020004	. .
40 41	Emergency button Handle snring	AZZ-E-S-KUT .II 45030032	- c
42	Circlip		14
43	Handle	JL45030014	-
44	Window plate	JL45010004	-
45	Large washer	WSH8GB5287Z	. .
40	Hexagon nead polt Shaft	M8X45GB5/832	- ~
48	Tension spring	FDPT1202020021	-
49	Large washer	WSH8GB5287Z	-
20	Fasten screw nut	M8GB889D1Z	~ 7
51 52	Hex nut Tension nlate	M12GB617UZ	
53	Tensioner axle	JL45053004	



7. Diagrams & Components 7.1 Frame Assembly-SHEET A

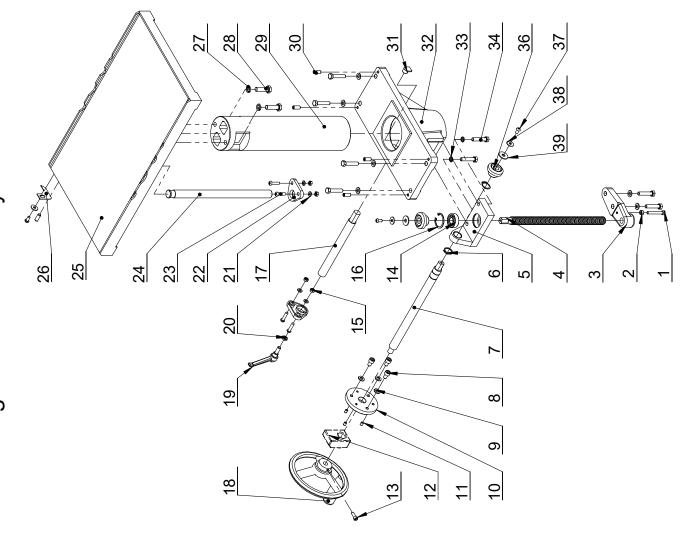
Tool Carrier Assembly-SHEET B

M6GB9232 M6X12GB70D2B JL45020016 JL45020017 WSH6GB96B JL45020002 JL45020006 JL45020006 JL450200012 JL450200013 JL450200013 JL45020001 JL45020001 JL45020001 JL45020001 JL45020001 JL45020003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45021003 JL45020001 M8X6GB77B WSH10GB96Z M8X6GB77B Shaft JL4502001 JL45020001 JL45020003 JL4502003 JL45020003 JL4502003 JL45020003 JL4502003 JL4502003 JL4502003 JL4502003 JL4502003 JL4502003 JL4202003 JL4202003 JL4202003 JL4202003 JL4202003 JL4202003 JL4202003 JL4202003 JL4200003 JL42020003 JL42020003 JL42000003 JL4200003 JL4200	ç	Description	Part No	Ş
Screw Micr 12:GE7002B Inner guide JL45020015 Washer JL45020015 Washer JL4502002 Big washer JL4502002 Spring JL45020005 Spring JL45020007 Spring JL45020001 Location pin JL45020001 JL45020001 Just board JL45020001 Just board JL45020001 Just board JL45020001 Nut Micr JL45020001 Hexagon bolt JL45020001 Right cutterhead bracket JL45020001 Right cutterhead bracket JL45020001 Right cutterhead bracket JL45020003 Shaft MICRB97B118 JL45020003 Bush Micr JL45020003 Bush Micr JL45020003 Hexagon bolt JL45020003 Bush Micr Micr JL45020003 Bush Micr JL45020003 Hexagonal self-locking nut Micr Micr Shing Set screw Micr Micr Screw JL45020003 Bush Micr JL45020003 Bush Micr Micr Micr Micr Micr Micr Micr Micr			M6GB923Z	
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Retainer ringCLP52GB893D1BWasherU45051005SpringJL45020003SorewJL45020009SorewJL45020009BushJL45020009BushJL45020005BushJL45020005Big chain wheelJL45020005Infeed rollerJL45020005Big chain wheelJL45020005PinJL45020005RodJL45020005Big chain wheelJL45020005Big chain wheelJL45020005Hexagonal self-locking nutM10GB8892PinM10GB8892Set screwM6X20GB77BSmall eccentric wheelJL45020003Hexagonal surk screwJL45020003KnifeJL45021003BarJL45021003BarJL45021003BarJL45021003BarJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003BaringJL45021003Belt pulley for cutter shaftJL45050001Flat keyPLN6X16GB1096	റ	Right cutterhead bracket	JL45020001	-
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Rod Infeed roller Big chain wheel Hexagonal self-locking nut Pin Set screw Tat washer Flat washer Square head screw M6X20GB70D3B Hexagonal sunk screw M6X20GB70D3B JL45021007 JL45021007 JL45021002 M6X20GB70D3B JL45021007 JL45021000 Bar JL45021000 Bearing Storew M6X20GB7001 Beating Beating Belt pulley for cutter shaft Flat key PLN6X16GB1096	9	Bush	JL45020011	27
Infeed roller JL45020005 Big chain wheel JL45050003 Hexagonal self-locking nut M10GB8892 Pin M6X8GB77B P1N5X18GB879B Set screw M6K8GB77B M6X8GB77B P1A twasher W5H16GB97D1Z Small eccentric wheel M6X20GB70D3B JL45090002 Hexagonal sunk screw JL41010007 JL45090002 Bar JL45021001 JL45021001 BRG6205-DDUC3 Right guard JL45021001 BRG6205-DDUC3 Right guard W5H10GB96Z Set screw W5H10GB96Z Belt pulley for cutter shaft JL45050001 Flat key PLN6X16GB1096		Kod	JL45020008	, - 1
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Bearing BRG6205-DDUC3 Right guard JL45031000 Big washer WSH10CB96Z Set screw M8X6GB77B Belt pulley for cutter shaft JL45050001 Flat key PLN6X16GB1096	6	Cutter shaft	JL45021001	-
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Big washer WSH10GB96Z Set screw M8X6GB77B Belt pulley for cutter shaft JL45050001 Flat key PLN6X16GB1096	-	Right guard	JL45031000	-
Set screw M8X6GB77B Belt pulley for cutter shaft JL45050001 Flat key PLN6X16GB1096	2	Big washer	WSH10GB96Z	2
Belt pulley for cutter shaft JL45050001 Flat key PLN6X16GB1096	ო	Set screw	M8X6GB77B	2
Flat key PLN6X16GB1096	4	Belt pulley for cutter shaft	JL45050001	-
· · · · · · · · · · · · · · · · · · ·	5	Flat key	PLN6X16GB1096	-



Press Planing Machine Assembly-SHEET C

No.	Description	Description Part No.	Qtv.
Ļ	Hexagon socket can screw	M6X45GB707	•
5	Nut	M6GB41Z	-
ო	Thread Tube	JL45040006	-
4	Thread rod	JL45040007	-
5	Bracket	JL45040004B	-
9	Circlip	CLP20GB894D1B	7
7	Lifting shaft	JL45040009A	-
8	Hexagon socket cap screw	M8X12GB70Z	ო
6	Flat washer	WSH8GB97D1Z	б
10	Flange plate	JL45040028	-
11	Set screw	M6X8GB77B	ი
12		JL09124D0E20	-
13	n socket cap screw	M6X16GB70Z	-
14	Bearing	BRG6202-2Z-P5GB276	-
15	Nut	M6GB6170Z	4
16	Circlip ring	CLP35GB893D1B	-
17	Locking lever	JL45040008	-
18	Handwheel	SGSL-D160-d12A1	-
19	Adjustable handle	KTSB-1-B-M8X63X20	-
20	Thin nut	M8GB6172Z	-
21	Flat washer	WSH6GB97D1Z	4
22	Rings	JL45040014	2
23	Screw	M6X25GB70D2B	4
24	Rod	JL45040012	-
25	Thicknesser table	JL45040001A	-
26	Indicator	JL45040020	-
27	Spring washer	WSH10GB93Z	2
28	Hexagonal head screw	M10X35GB5783B	7
29	Tube	JL45040002A	-
30	Set screw	M8X20GB77B	Ŋ
31	Locking plate	JL45040005	-
32	Locating sleeve	JI 45040003A	.
33	Spring washer	WSH8GB93Z	. 0
34	Hexagon bolt	M8X40GB57837	
35	Shaft sleeve	P23X20X15GB12613) ~
36	Gear	11 45040010	
37	Screw	MEX12GR70D2R	1 0
38	Big washer	WSH6GB96Z	
39	Big washer	WSH8GB96Z	0 0
8			1



7.3 Press Planing Machine Assembly-SHEET C

Discharging Platform Assembly-SHEET D

<u>31 32 33</u>

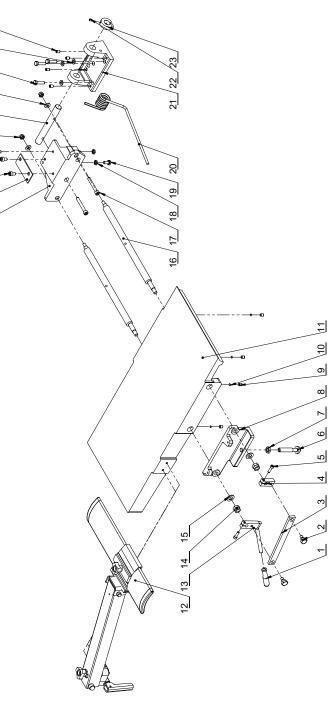
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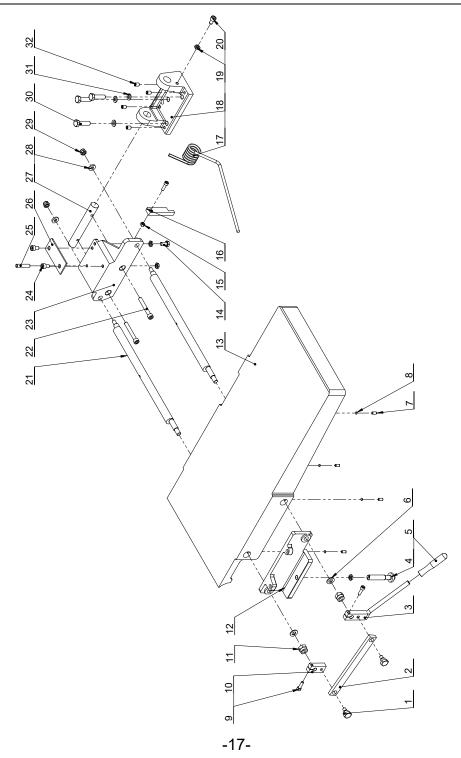
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지 - 2		Part No.	25
		11 1 1 100000	
-	Handle sleeve Shoulder holt	JL45U3UUZ8 11 / 5030017	
ă	Circuider Boil	JL 45030013	
ζ.Ϋ́	Small lever	JI 45030011	
Ť	Hexagon socket cap screw	M6X20GB70Z	2
Ë	Tighten rod	.II 45030008	I ~
N 1		M12GB61727	
Ë	Back rack	.II 45030007	
ΪĬ	Hex screw	MRX10GR77B	4
3	Washer	JL45030029	4
	Planer table	.II 45030001B	- -
. c	Cutterhead guard	EDPT12020215	
μ	Dattornoad gaar a Hand shank	II 45030012	
		M12GB889B	- ~
<u>; </u>	Elat washer	WSH12GR97D17	10
<u> </u>	Eccontric chaft		4 C
10			4 C
ŏ ī	OCIEW		N
_	l nin nut	M8GB61/22	N
Ť	Hexagon bolt	M8X16GB5781Z	-
Ĕ	Torsional spring	JL45030009	-
ທີ	Support	JL45030005	-
Š	Set screw	M6X8GB77B	-
	Big deflection wheel	JL45090001	-
B	Back rack	JL45030004	-
Ū	Guide plate	.II 45060028	~
ŭ N	Screw	M8X10GB70B	. ~
) i			1 -
Ĕ	Hex.screw		- c
Ĕ	Hexagon sell-locking nut		ч
ñ	Back support bar	JL45030027	~
Ŝ	Washer	JL45030020	2
ĕ	Bolt	M8X30GB5783Z	ო
Ĩ	Flat washer	WSH8GB97D1Z	e
Ť	Hex.screw	M8X12GB80B	4
Ĕ	ax.sciew		4



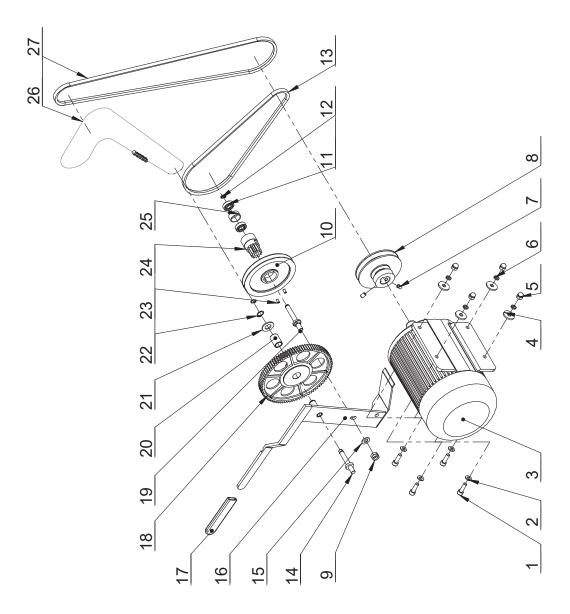
7.4 Discharging Platform Assembly-SHEET D

Feed Table	Assen	
Description	Part No.	uty.
Shoulder bolt	JL45030017	~ 5
Rod	JL45030013	~
Hand shank	JL45030012	~
Tighten rod	JL45030008	-
Handle tube	JL45030028	-
Plat washer	WSH12GB97D1Z	7
Hex.screw	M8X10GB77B	4
Washer	.II 45030029	4
Haverraw	MEXONCEZOZ	ۍ .
		°.
Kod	JL45030011	
Locknut	M12GB889B	2
Rising rack	JL45030006	-
Planer table	JL45030001B	~
Screw	M8X16GB57817	~
Nut	MRGB61707	· 、
Block		
Shrind		
		- •
Support base	JL45030005	-
Nut	M8GB6172Z	4
Hex.screw	M8X12GB70Z	-
Eccentric shaft	JL45030015	2
Screw	M8X60GB70B	2
Front Rack	JL 45030003	~
Screw	M8X10CB70B	¢
		N 1
Hex.sciew		_
Guide plate	JL45060028	-
Support bar	JL45030010	-
Washer	JI 45030020	2
Locknit	MRGB8897	~
Blot	M8X30GB57837	1 0
		о с
Plat washer		n
Hex.screw	M8X12GB80B	4



7.5 Feed Table Assembly-SHEET E

	aty.	4	4	~		4	4	4	2	~	-	-	2	2	~	-	. .	- ,				_ 、	, ,	.	2	-	-	-	-	
			WSH8GB97D1Z	2-YLKA9003021A-01(1PH)/	2-YSKA905222A(3PH)	WSH8GB5287Z	M8GB923Z	WSH8GB93Z	M8X12GB77Z	JL45050002	M10GB889Z	JL45051101	BRG6000-2ZGB276	CLP10GB894D1B	JL45050007	JL45051004	WSH10GB97D1Z	JL45051300				JL45051003	JL45051005	CLP15GB894D1B	M5X10GB77B	JL45051102	JL45051103	JL45050008	JL45050009	
a live	Description	Hexagon socket cap screw	Washer	Motor		Big washer	Cap nut	Spring washer	Socket head cap screw	Motor pulley	Self-locking nut	Belt wheel	Bearing	Circlip ring	V-belt	Chain wheel spindle	Washer	Panel assembly		Big gearwheel		Minor sprocket push	Washer	Circlip ring	Set screw	Small gearwheel	Bush	Chain	V-belt	
:	No.	- 1	2	ო		4	2	9	7	8	б	10	11	12	13	14	15	10	2 7	0 0	n 0	02	21	22	23	24	25	26	27	i de la construcción de la constru



Drive System Assembiy-SHEET F

7.6 Drive System Assembly-SHEET F

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No.DescriptionPart No.Qty.1NutMeGB889222Support baseJ.4506000223Hex. ScrewM6GB889225Support baseJ.4506000225WasherMK16GB70227WasherWSH16GB70228NutM8X60GB80B210Cap nutM6GB8023211Hex. ScrewMSK16GB702112Right support armJ.45060020113NutM6X12GB7022114Lock tubeJ.45060024115Lock tubeJ.45060021116Lock handleJ.45060021117Hex. ScrewM8X16GB702118Angle labelJ.45060021119Hex. ScrewJ.45060026119Hex. ScrewM8X16GB702221Support armJ.45060021122Big washerJ.45060021123IndicatorJ.45060026324WasherWSH4GB9322225Fex. ScrewWSH4GB9322226Spring washerJ.45060026327Cap nutJ.45060026328Thick washerM8GB92322229Square nutJ.45060016230Long pinJ.45060016231Rip fenceJ.45060016232Rip fence <t< th=""><th></th><th>Material Baff</th><th>Material Baffle Assembly-SHEET</th><th>EETG</th></t<>		Material Baff	Material Baffle Assembly-SHEET	EETG
Nut M6GB8892 Support base JL45060002 Hex. Screw M6X16GB70D32 Hex. Screw M6X16GB70D32 Hex. Screw M8X16GB7012 Uvasher W8H12GB97D12 Nut M8GB61702 Nut M8C6GB80B Cap nut M8X60GB80B Cap nut M8X60GB80B Cap nut M8X60GB80B Cap nut M8X60GB80B Cap nut M8X60GB80B Cap nut M8X60GB80B Lock tube JL45060024 Lock tube JL45060021 Lock tube JL45060021 Left support arm JL45060021 Left support arm JL45060021 Support plate JL45060021 Support plate JL45060021 Support plate JL45060021 Big washer M4X5GB702 Indicator JL45060026 Washer M4X5GB702 Spring washer M8X5GB702 Long pin JL45060016 Square nut JL45060016 Square nut JL45060016 Square nut JL45060016 Square nut JL45060016 Square nut JL45060011 Rip fence JL45060011	No.	Description	Part No.	Qty.
Support base JL45060002 Hex. Screw M6X16GB70D32 Hex. Screw M6X16GB70D32 Hex. Screw M8X16GB7012 Uvasher WSH8GB97D12 Nut WSH8GB61702 Nut M8GB61702 Locknut M8C60GB80B Cap nut M8X60GB80B Cap nut M8C60020 Nut M8C6B9232 Hex. Screw JL45060021 Lock tube JL45060021 Lock tube JL45060021 Left support arm JL45060021 Left support arm JL45060021 Left support arm JL45060021 Left support arm JL45060021 Big washer M8X5GB702 Left support arm JL45060021 Left support arm JL45060021 Big washer M8X5GB702 Left support arm JL45060021 Left support arm JL45060021 Left support arm JL45060021 Left support arm JL45060021 Kip fence WSH4GB9702 Left washer M8GB9232 Left washer M8CB9232 Left support plate WSH4GB9702 Left support plate WSH4GB9702 Spring washer WSH4GB9702 Left plate UL45060016 Square nut JL45060016 Square nut JL45060011 Rip fence JL45060011	-		M6GB889Z	2
Hex. Screw M6X16GB70D3Z Hex. Screw M6X16GB70Z Washer WSH12GB97D1Z Disc spring washer WSH8GB97D1Z Washer WSH8GB97D1Z Nut WSH8GB6170Z Locknut M8X60GB80B Cap nut M8X60GB80B Cap nut M6X12GB70D3Z Right support arm M6X12GB70D3Z Right support arm JL45060024 Lock tube JL45060023 Lock tube JL45060021 Nut JL45060026 Washer M8X20GB70Z Angle label JL45060021 Left support arm JL45060021 Big washer M6X16GB96Z Indicator JL45060026 Washer WSH6GB96Z Indicator WSH6GB96Z Indicator WSH6GB96Z Indicator WSH6GB96Z Indicator WSH4GB970Z Spring washer WSH4GB970Z Cap nut M8GB923Z Cap nut JL45060016 Square nut JL45060016 Square nut JL45060011 Rip fence JL45060011	2	Support base	JL45060002	2
Hex. Screw M8X16GB702 Washer WSH12GB97D12 Disc spring washer WSH36B97D12 Nut WSH8GB97D12 Nut M8GB61702 Locknut M8GB61702 Locknut M8X60GB80B Cap nut M6X12GB70D32 Hex. Screw M6X12GB70D32 Right support arm JL45060024 Lock tube JL45060024 Lock tube JL45060023 Lock tube JL45060021 Hex. Screw M6X16GB702 Angle label M8X20GB702 Left support arm JL45060021 Left support arm JL45060021 Big washer JL45060021 Support plate JL45060021 Flex. Screw M6X16GB702 Cap nut M8X20GB702 Indicator JL45060026 Washer WSH4GB97D12 Hex. Screw M4X5GB702 Spring washer WSH4GB97D12 FDPT1202060016 Square nut M8GB9232 Long pin JL45060016 Square nut M8GB9232 Long pin JL45060011 Rip fence JL45060011	ო	Hex. Screw	M6X16GB70D3Z	2
Washer WSH12GB97D1Z Disc spring washer WSH8GB97D1Z Nut Disc spring washer UL46062006 Washer WSH8GB6170Z Locknut M8X60GB80B Cap nut M8X60GB80B Cap nut M6X12GB70D3Z Hex. Screw UL45060020 Nut UL45060024 Lock tube UL45060024 Lock tube UL45060024 Lock handle M6X16GB70Z Hex. Screw UL45060021 JL45060026 Washer UL45060026 Washer UL45060026 Washer UL45060016 Spring washer UL45060016 Spring washer WSH4GB97D1Z Hex. Screw WSH4GB97D1Z Hex. Screw UL45060026 Washer UL45060016 Spring washer M8GB923Z Cap nut M8GB923Z Cap nut M8GB923Z Long pin UL45060011 Rip fence UL45060011	4	Hex. Screw	M8X16GB70Z	2
Disc spring washer JL46062006 Washer WSH8GB97D12 Nut M8GB61702 Locknut M8X60GB80B Cap nut M6GB923Z Hex. Screw JL45060020 Nut JL45060024 Lock tube JL45060024 Lock tube JL45060024 Lock tube JL45060027 Hex. Screw JL45060027 Hex. Screw JL45060021 JL45060026 Washer JL45060026 NgB1 washer JL45060026 NgSH6GB962 Indicator JL45060026 Washer JL45060026 Washer JL45060016 Spring washer WSH4GB97D12 Hex. Screw JL45060026 Nut JL45060016 Spring washer M8GB9232 Cap nut M8GB9232 Cap nut M8GB9232 Long pin JL45060011 Rip fence JL45060011	5	Washer	WSH12GB97D1Z	2
Washer WSH8GB97D1Z Nut WSH8GB97D1Z Nut M8GB6170Z Locknut M8K60GB80B Cap nut M6K12GB70D3Z Hex Screw M6X12GB70D3Z Right support arm M6X12GB70D3Z Lock tube JL45060024 Lock tube JL45060023 Lock tube JL45060023 Lock handle M8X20GB70Z Hex Screw JL45060021 JL45060026 Vasher M4X5GB70Z Spring washer WSH4GB97D1Z Hex Screw W4X5GB70Z Spring washer WSH4GB97D1Z Hex Screw W4X5GB70Z Spring washer M4X5GB70Z Spring washer M4X5GB70Z Spring washer M4X5GB70Z Left support arm JL45060026 Vasher W5H4GB93Z Cap nut M8GB923Z Thick washer M8GB923Z Left pfence JL45060016 Square nut JL45060016 Square nut JL45060011 Rip fence JL45060011	9	Disc spring washer	JL46062006	2
Nut M8GB61702 Locknut M8K60GB80B Cap nut M8X60GB80B Cap nut M6K12GB70D32 Right support arm JL45060020 Nut JL45060024 Lock tube JL45060024 Lock tube JL45060023 Lock handle JL45060027 Hex. Screw JL45060027 Angle label JL45060021 JL45060026 Nasher JL45060026 Nasher JL45060026 Nasher M4X5GB702 Spring washer WSH4GB962 Indicator JL45060026 Washer M8GB9232 Cap nut M8GB9232 Cap nut JL45060016 Spring washer M8GB9232 Long pin JL45060011 Rip fence JL45060011	7	Washer	WSH8GB97D1Z	2
Locknut M8X60GB80B Cap nut M6X12GB70D3Z Right support arm M6X12GB70D3Z Nut JL45060020 Nut JL45060024 Lock tube JL45060023 Lock tod JL45060023 Lock handle JL45060027 Hex. Screw JL45060027 Hex. Screw M8X20GB702 Left support arm JL45060026 Masher JL45060026 Washer JL45060026 Washer WSH6GB96Z Indicator WSH4GB97D12 Hex. Screw WSH4GB932 Cap nut M8X5GB702 Spring washer JL45060016 Square nut JL45060016 Kusher M8GB9322 Long pin JL45060011 Rip fence JL45060011	ω	Nut	M8GB6170Z	2
Cap nut M6GB923Z Hex. Screw M6X12GB70D3Z Right support arm JL45060020 Nut JL45060024 Lock tube JL45060023 Lock tod JL45060027 Hex. Screw JL45060027 Hex. Screw JL45060027 Hex. Screw JL45060027 Hex. Screw JL45060026 M8X20GB702 Left support arm JL45060026 Washer JL45060026 Washer WSH6GB96Z Indicator WSH4GB97D12 Hex. Screw WSH4GB932 Cap nut M8CB9232Z Cap nut JL45060016 Square nut JL45060016 KWSH4GB932Z Long pin JL45060011 Rip fence JL45060011	6	Locknut	M8X60GB80B	2
Hex. Screw M6X12GB70D3Z Right support arm JL45060020 Nut JL45060024 Lock tube JL45060023 Lock handle JL45060027 Hex. Screw M6X16GB702 Angle label JL45060027 Hex. Screw JL45060021 JL45060026 M8X20GB702 Indicator JL45060021 Spring washer JL45060021 M4X5GB96Z Indicator JL45060021 M4X5GB96Z Indicator JL45060021 Kvasher M4X5GB96Z Indicator JL45060021 Spring washer W5H4GB97D12 Hex. Screw JL450600016 Kvasher M8GB923Z Cap nut JL450600016 Kvasher M8GB923Z Long pin JL450600016 Rip fence JL450600016	10	Cap nut	M6GB923Z	4
Right support arm JL45060020 Nut M8GB61722 Lock tube JL45060024 Lock tod JL45060023 Lock handle JL45060027 Hex. Screw JL45060007B Hex. Screw M6X16GB702 Hex. Screw JL45060021 Support plate JL45060021 JL45060021 Support plate WSH6GB962 Indicator WSH6GB962 Indicator WSH6GB962 Indicator WSH6GB962 Trick washer M8C5GB702 Spring washer M4X5GB702 Spring washer M8C89232 Cap nut M8GB9232 Thick washer M8GB9232 Thick washer M8GB9232 Cap nut JL45060016 Kip fence JL45060011 Rip fence JL45060001	5	Hex. Screw	M6X12GB70D3Z	2
Nut M8GB6172Z Lock tube JL45060024 Lock rod JL45060023 Lock handle JL45060027 Hex. Screw JL45060028 Angle label M6X16GB702 Hex. Screw JL45060021 Support arm JL45060021 Support plate WSH6GB962 Indicator JL45060026 Washer JL45060026 Washer M8CB9232 Spring washer M8CB9232 Thick basher M8CB9232 Thick washer M8CB9232 Thick basher M8C	12	Right support arm	JL45060020	-
Lock tube JL45060024 Lock handle JL45060023 Lock handle JL45060027 Hex. Screw JL4506007B Hex. Screw JL45060007B Hex. Screw JL45060021 JL45060026 Nasher JL45060026 Nasher JL45060026 Nasher M4X5GB702 Spring washer M4X5GB702 Spring washer M4X5GB702 Spring washer M4X5GB702 Thick washer M4X5GB701 Thick washer M4X5GB701 Spring washer JL45060016 Square nut JL45060011 Rip fence JL45060011	13	Nut	M8GB6172Z	2
Lock rod JL45060023 Lock handle JL45060027 Hex. Screw M6X16GB702 Angle label M6X16GB702 Hex. Screw JL45060021 Left support arm JL45060021 Support plate JL45060026 Nasher JL45060026 Washer M4X5GB702 Spring washer M8GB9232 Cap nut M8GB9232 Thick washer M8GB9232 Cap nut JL45060011 Rip fence JL45060011 Rip fence JL45060011	4	Lock tube	JL45060024	2
Lock handle JL45060027 Hex. Screw M6X16GB702 Angle label M6X16GB702 Hex. Screw JL45060002B Hex. Screw JL45060021 Support plate JL4506002A Big washer JL45060026 Indicator JL45060000 Washer W5H4GB97012 Hex. Screw W5H4GB97012 Hex. Screw W5H4GB9322 Cap nut M8GB9232 Thick washer M8GB9232 Long pin JL450600011 Rip fence JL450600011	15	Lock rod	JL45060023	~
Hex. Screw M6X16GB70Z Angle label JL45060007B Hex. Screw M8X20GB70Z Left support arm JL45060021 Support plate M8X206B96Z Indicator JL45060026 Washer WSH4GB97D12 Hex. Screw W3H4GB97D12 Hex. Screw W3H4GB93Z Cap nut M8GB93Z Cap nut M8GB93Z Thick washer M8GB39Z Long pin JL45060011 Rip fence JL45060011	16	Lock handle	JL45060027	.
Angle label JL4506007B Hex. Screw M8X20GB702 Left support arm JL45060021 Support plate M8X206B962 Indicator JL45060026 Washer JL45060026 Washer M4X5GB702 Kasher M4X5GB702 Spring washer M8GB9232 Cap nut M8GB9232 Thick washer M8GB392 Long pin JL45060011 Rip fence JL45060001	17	Hex. Screw	M6X16GB70Z	7
Hex. Screw M8X20GB70Z Left support arm JL45063000A Support plate JL45063000A Big washer JL45060026 Indicator WSH6GB96Z Indicator WSH6GB96Z Washer M4X5GB70Z Spring washer M4X5GB70Z Cap nut M8GB923Z Cap nut M8GB923Z Thick washer M8GB32Z Long pin JL45060011 Rip fence JL45060001	18	Angle label	JL45060007B	.
Left support arm JL45060021 Support plate JL45060026 Big washer JL45060026 Indicator JL45060026 Washer M4X5GB702 Spring washer M4X5GB702 Cap nut M8GB9232 Thick washer M8GB9232 Thick washer M8GB392 Long pin JL45060011 Rip fence JL45060001	19	Hex. Screw	M8X20GB70Z	2
Support plate JL45063000A Big washer WSH6GB96Z Indicator WSH4GB97D12 Washer WSH4GB97D12 Hex. Screw W4X5GB702 Spring washer M4X5GB702 Cap nut M4X5GB702 Cap nut M4X5GB702 Cap nut M4X5GB702 Cap nut M4X5GB702 Square nut JL45060011 Rip fence JL45060001 Rip fence JL45060001	20	Left support arm	JL45060021	~
Big washer WSH6GB96Z Indicator WSH6GB96Z Washer WSH4GB97D1Z Hex. Screw WSH4GB97D1Z Spring washer M4GB923Z Cap nut M8GB923Z Thick washer M8GB923Z FDPT1202060016 Square nut JL450600011 Rip fence JL450600011	21	Support plate	JL45063000A	~
Indicator JL45060026 Washer WSH4GB97D1Z Hex. Screw WSH4GB93Z Spring washer M4X5GB70Z Cap nut WSH4GB93Z Cap nut M8GB923Z Thick washer M8GB392 Long pin JL45060011 Rip fence JL45060001	22	Big washer	WSH6GB96Z	9
Washer WSH4GB97D1Z Hex. Screw M4X5GB70Z Spring washer WSH4GB93Z Cap nut M8GB923Z Thick washer M8GB39Z Long pin JL45060001 Rip fence JL45060001	23	Indicator	JL45060026	,
Hex. Screw M4X5GB70Z Spring washer WSH4GB93Z Cap nut M8GB923Z Thick washer M8GB39Z Long pin JL45060011 Rip fence JL45060001	24	Washer	WSH4GB97D1Z	2
Spring washer WSH4GB93Z Cap nut M8GB923Z Thick washer FDPT1202060016 Square nut JL45060011 Rip fence JL45060001 Rip fence JL45060001	25	Hex. Screw	M4X5GB70Z	2
Cap nut M8GB923Z Thick washer FDPT1202060016 Square nut M8GB39Z Long pin JL45060011 Rip fence JL45060001	26	Spring washer	WSH4GB93Z	2
Thick washer FDPT1202060016 Square nut M8GB39Z Long pin JL45060001 Rip fence JL45060001	27	Cap nut	M8GB923Z	7
Square nut M8GB39Z Long pin JL45060001 Rip fence JL45060001	28	Thick washer	FDPT1202060016	2
Long pin JL45060001 Rip fence JL45060001	29	Square nut	M8GB39Z	2
Rip fence JL45060001	30	Long pin	JL45060011	7
	31	Rip fence	JL45060001	~

