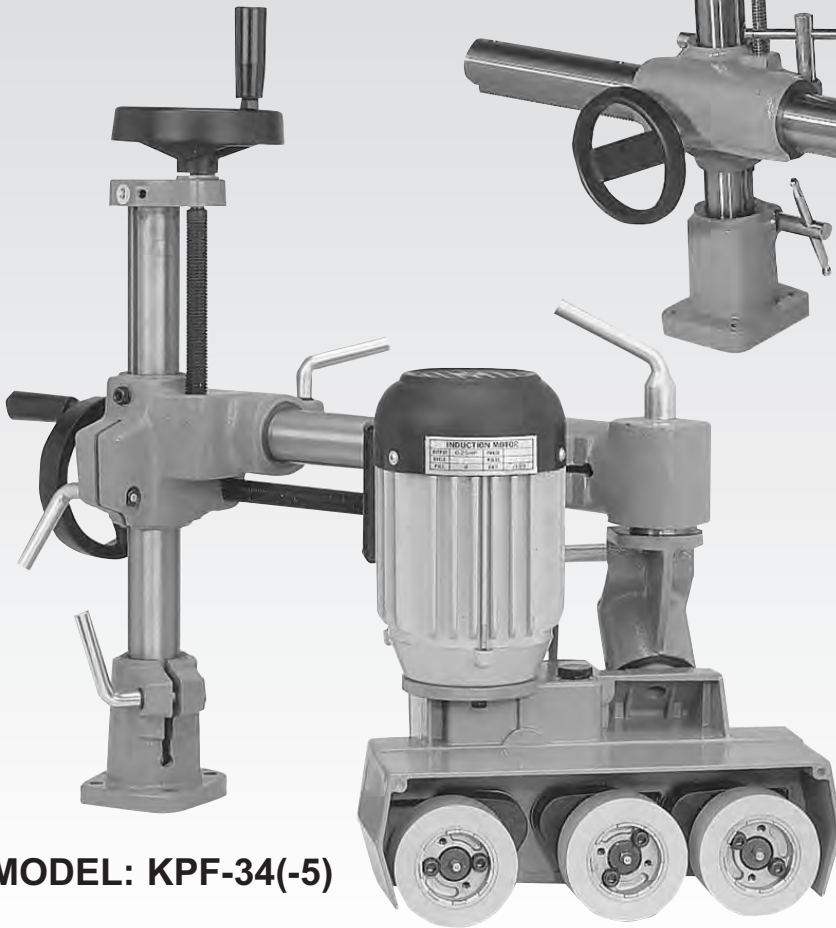
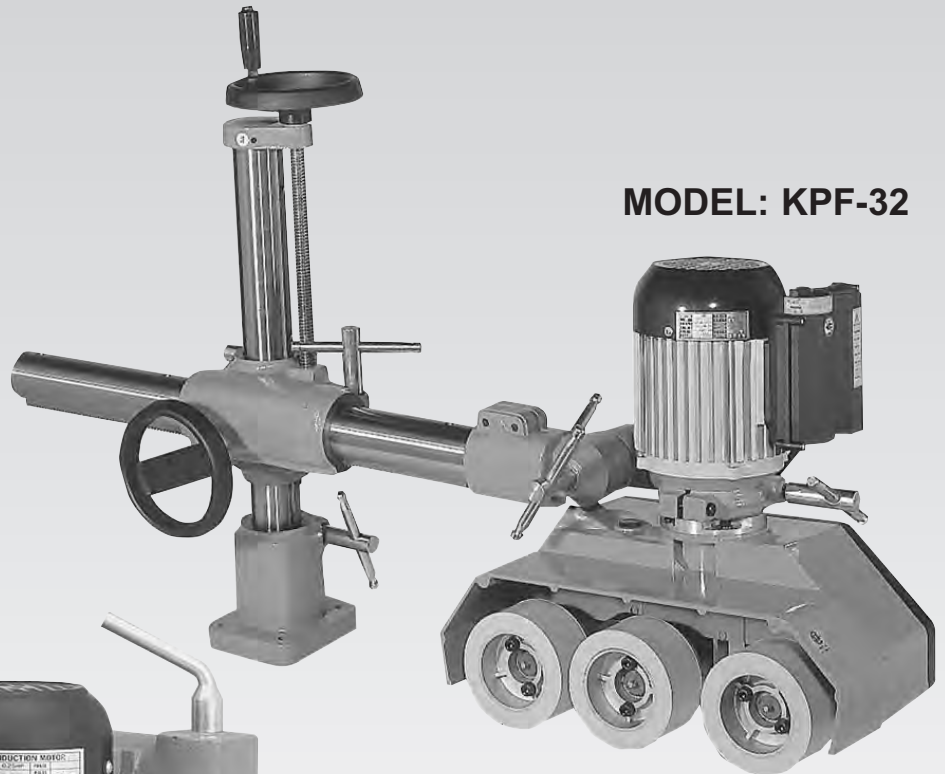




KING CANADA

POWER FEEDERS

MODEL: KPF-32



MODEL: KPF-34(-5)

INSTRUCTION MANUAL

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General Safety Rules

Warning:

Do not attempt to operate until you have read Thoroughly and understand completely all instructions, rules...etc, contained in this manual. Failure to comply can result in accidents involving fire, electric shock, or serious personal injury. Keep this owner's manual and review frequently for continuous safe operation.

1. Know your machine.

For your own safety, read the owner's manual carefully. Learn its application and limitation, as well as specific potential hazards pertinent to this machine.

2. Make sure all tools are properly grounded.

If the tool electrical plug has three prongs; it should be used with a three-hole electrical socket. If a three-prong to two-prong adapter is used, the adapter lug must be properly grounded. Do not remove or otherwise disable the third plug.

3. Keep guards in place and in working order.

If a guard must be removed for maintenance or cleaning, make sure it is properly reattached before using the tool again.

4. Remove adjusting keys and wrenches.

From habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.

5. Keep work-area clean.

Cluttered areas and workbenches increase the likelihood of an accident.

6. Do not use in dangerous environments.

Do not use power tools in damp or wet location or expose them to rain. Keep working area well illuminated.

7. Keep children away.

All visitors should be kept at safe distance from work area.

8. Make workshop childproof.

Use padlocks, master switches, or remove starter keys.

9. Do not force the machine.

It will do the job better and be safer at the rate for which it was designed.

10. Use the right tools.

Do not force the machine or attachments to do a job for which they were not designed. Contact the manufacturer or distributor if there is any question about tool's suitability for a particular job.

11. Wear proper apparel.

Avoid loosen clothing, gloves, neckties, rings, bracelets, or jewelry, which could be caught in moving parts. None slip footwear is recommended. Wear protective hair covering to contain long hair.

12. Always use safety glasses.

Also use face or dust mask if operation is dusty. Everyday eyeglasses only have impact resistant lenses. They are Not safety glasses.

13. Secure work.

Use clamps or a vise to hold work when practical. It is safer than using your hands and frees both hands to operate the tool.

14. Do not overreach.

Keep proper footing and balance at all times.

15. Maintain machine in top condition.

Keep machine clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. Disconnect machine from power source.

Before servicing and when changing accessories, or when mounting and remounting motor.

17. Avoid accidental starting.

Make sure switch is in the "off" position before plugging in power cord.

18. Use recommended accessories.

Consult the owner's manual for recommended accessories.

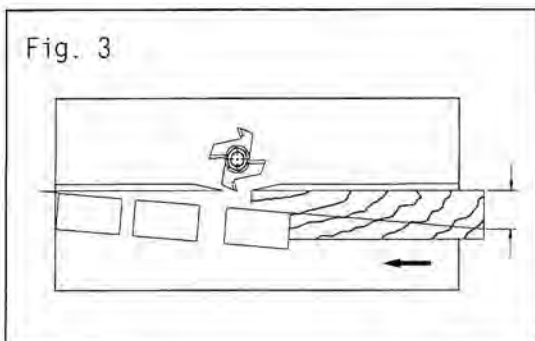
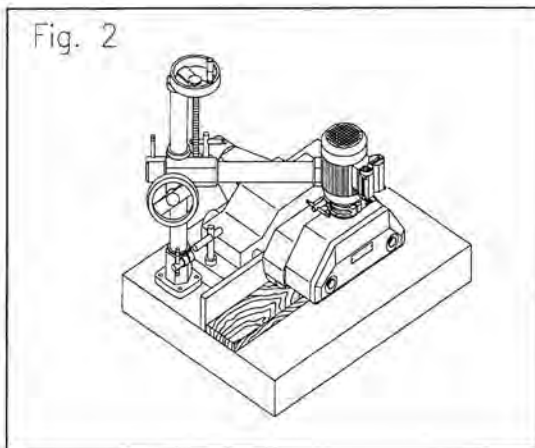
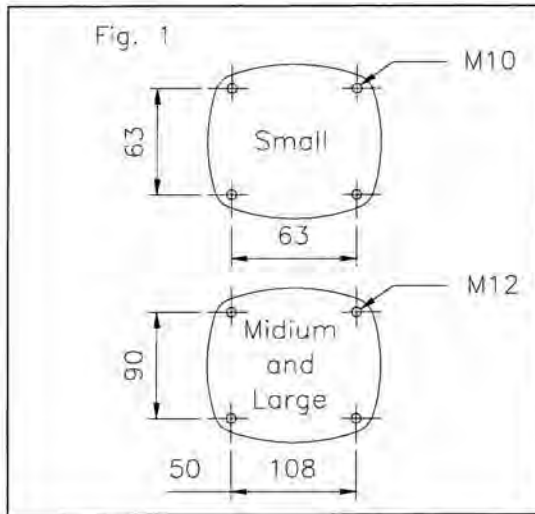
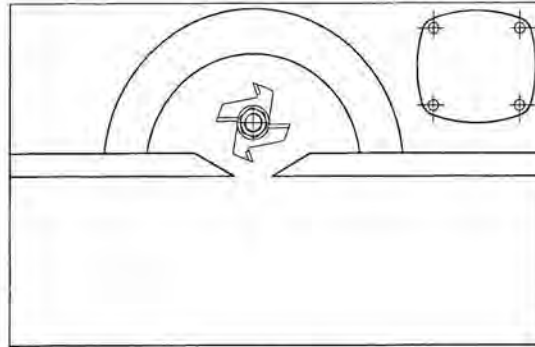
19. Check damaged parts.

Before further use of the machine, a guard or other part that is damaged should be carefully checked to make sure that it would operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other condition that may affect its operation. Guards or other conditions may affect its operation. Guards or other parts that are damaged should be properly.

PARTS DIAGRAM & PARTS LISTS

Refer to the Parts section of the King Canada web site for the most updated parts diagram and parts list.

20. **Never leave machine running unattended.**
Turn power off. Do not leave the machine until it comes to a complete stop.
21. **Do not use any power tools while under the effects of drugs, alcohol, or any medication.**
22. **Always wear a face or dust mask.**
If operation creates a lot of sawdust and/or wood chips, always operate the tool in a well ventilation area and provide for proper dust removal. Use a wood dust collection system whenever possible.



Safety Rules for JUNIOR Feeders

1. Always use the appropriate machine.
2. Make sure all cutting tools are moving at operation speed before feeding.
3. Do not feed the material too quick. The cutting tool will perform better and a safer working at the rate for which it was designed.
4. Keep hands away from the moving parts of the feeder and the cutting tool at all times.
5. Do not work on long stock without adequate support on the out-feed end of the table.
6. Stop the feeder before stopping the cutting tool.
7. Disconnect the feeder from its power source before cleaning, repairing, or adjusting.

INSTALLATION

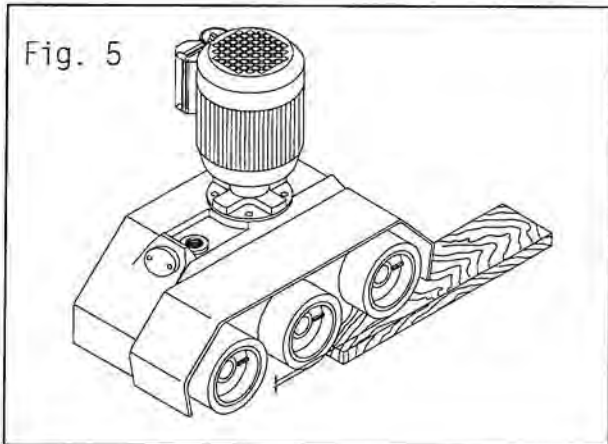
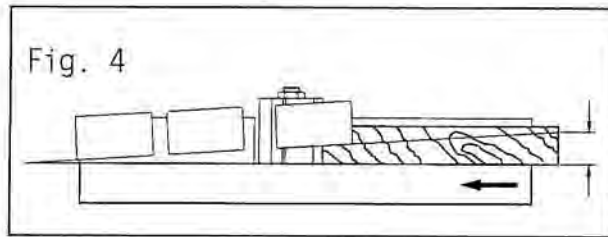
The feeders are shipped in special boxes. The universal stand was disassembled to facilitate packing. The column base is fastened to the machine by means of 1/2" (12 mm)[3/8" (10 mm) for small feeder bolts], as required by local conditions **(Figure 1)**.

The over arm may be inserted into the elevating bracket to pass at the right of the vertical column. The stand with fine adjustment is horizontally adjusted by a wheel, pinion and rack. Column is fitted directly into the provided hole of the column base. **(Figure 2)**

Do not lock the handle before insert the column in the base.

To set up, stacked the hexagon head screw on the side of the swivel and make sure to retighten firmly when adjustment is completed.

To ensure that the stock is positively held against the fence, set the feeder slightly at an angle to the direction of feed, that is the out-feed roller should be approx. 3-5 mm (3/16") closer to the fence than the in-feed roller is. **(Figure 3)**



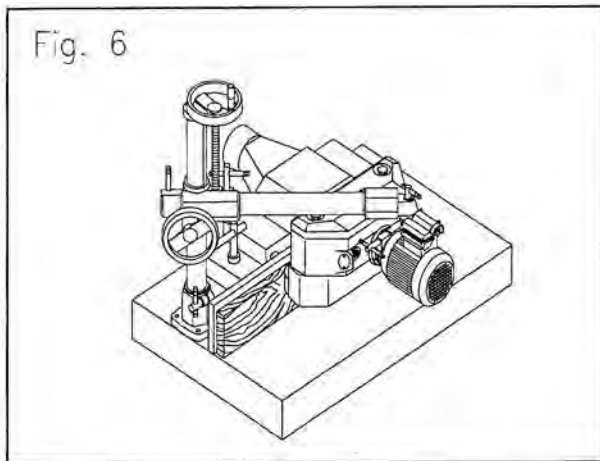
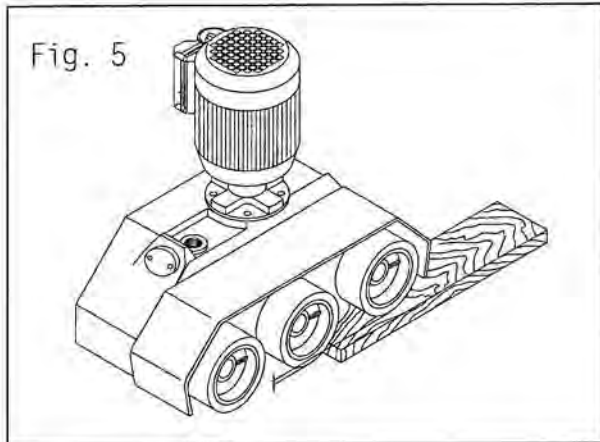
In a similar manner, if the feeder is used horizontally, the out-feed roller must be approx. 3-5 mm (3/16") closer to the machine table than the in-feed roller is. **(Figure 4).**

The feeder should be adjusted for height so that the distance between the table and the feeding rollers is approx. 5-6 mm (3/16"-1/4") smaller than the minimum wood thickness to be processed.

Friction between the feeding rollers and the work piece enables the transmission of the forward feed to the working machine. The spring suspension is designed so that the rollers can exert the necessary pressure on the stock. Moreover, this pressure varies automatically in accordance with feed resistance owing to the special mounting.

The total roller spring lift is 20 mm so that the difference in thickness of the wood up to 20mm (3/4") is easily compensated. In other words, work piece differing in thickness within this limit can be fed through the machine without any adjustment. If very resinous wood is being handled, it is suggested to treat the machine table from time to time with a commercial type of lubricant such as sliver litharge or paraffin wax.

The saw blade of the saw bench should be positioned between the central roller and out-feed roller. First, adjust the height of the wood to be cut, then set the feeder to the thickness of wood to be handled, make sure that the rollers are raised approx. 5 mm over the work piece when wood passed the machine. **(Figure 5)**



In order to guide the work piece firmly along the fence, set the feeder so that the direction of feed is slightly at an angle to [leading approx. 3 mm (1/8") away from] the fence.

CAUTION:

1. Fence must not be "given" at its end.
2. Rollers must also grip the off-cut. (The rollers stand above the saw blade).

(Figure 5)

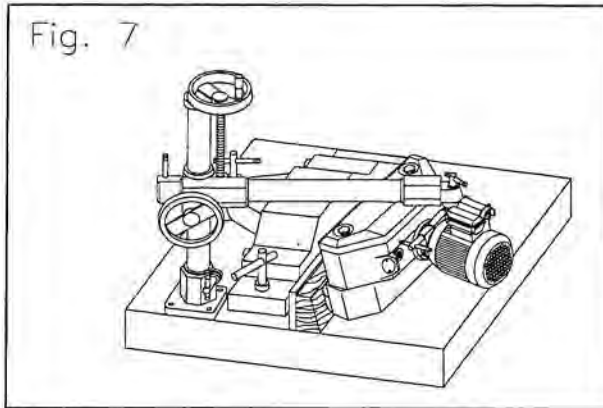
The rubber covered feeding roller is standard equipment. The duromen number of rubber for feeding roller is 70° - 75°. On a shaper, the roller pressure on the work piece can be from above, from side or any other intermediate direction.

The following instructions must be observed to obtain a smooth surface free of rough spots.

1. For rebating or molding work, both fences must be precisely aligned.
2. For shaping or profiling work covering the entire width of the work piece face, the two fences must be out of alignment by the depth of cut (similar to the table of a surface planer).
3. The cutter must be positioned between the in-feed roller and the central roller.

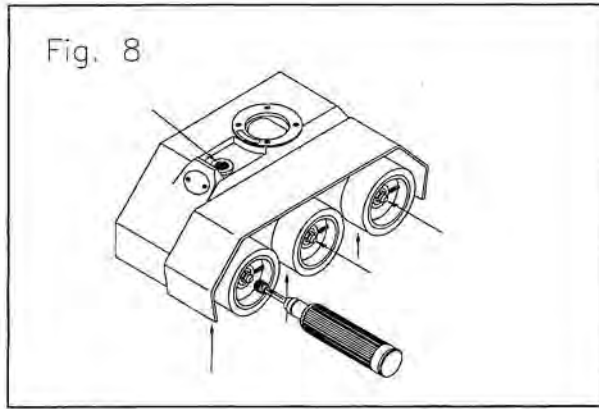
The pressure of the central feeding roller must not be directly towards the opening between the fences but should act directly on the fences. Attention should be paid to the elasticity of rollers.

(Figure 6)

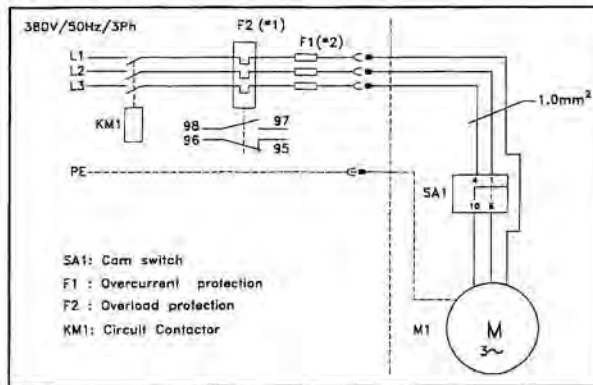


4. The gap between the fences for the cutter should be kept as small as possible. For lateral pressure, the feeder must be inclined slightly towards the worktable in the direction of feed to force work piece against the table.
5. When shaping, all rollers act on the stationary table, with the in-feed roller approx. 5-6 mm (3/16"-1/4") away from the table gap. Roller pressure should be as light as possible along the connecting line between the corners of the work piece resting on the table edges.
6. With a smooth out-feed table and will adjusted, sharp planer knives, planing of hardwood may be accompanied by a considerable increase of friction between the work piece and the table.
7. Apply some paraffin wax or Chaulic to the out-feed table across the direction of feed. **(Figure 7)**
8. For jointing work, the cutter head should be positioned between the in-feed and central roller. Again, the feeder should be slightly inclined forward towards the worktable. Perfect jointing and surfacing depends on the correct adjustment of the table.

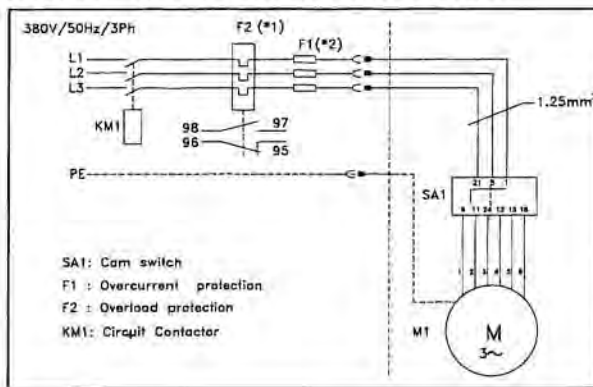
Fig. 8



Model: 32



Model: 34/38/44/48/04/54/C3/MX



LUBRICATION

1. Please lubricate feeding rollers with grease gun after 200 hours of operation (or each month).
(Figure 8)

2. Check chains and change gears every 3 months (depends on operation status) and treat them with grease.
3. The gearbox has a special filling to ensure long of the gearing. The first oil change should be made after approx. 1000 hours of operation. Please make sure to use one of the special purpose oil in your own interests: MOBIL Mobil-gear 630, SHELL/Omala 150, BP/Energol GR-XP 150.

Fill oil to a following from the top of the gear housing.

Oil Level:
Model: 32 - 1&3/8"

Model: 34 - 1&1/2"

ELECTRICAL COMPONENTS

The unit should be wired by a qualified electrician to I.E.E. standards. It is preferable to fit a socket to the machine and a plug on the unit. This will enable the unit to be moved from one machine to another (supposed that sockets are fitted). Wire connection, please refer to the diagrams (Figure 9)

