

## 10" PLANER-THICKNESSER



**ORIGINAL INSTRUCTIONS**

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### SPECIFICATIONS

Model No	PT254
Motor	1500W (Please choose proper power source, voltage and frequency that are shown in the label for your machine.)
No. of Blade	2
Cutterhead rpm	8500 min <sup>-1</sup>
Weight	35/30 kg (39/34 kg with stand)
<b>Technical data-Planer</b>	
Cutting Width(max)	254 mm (10")
Cutting Depth (max)	2mm
Angle fence	635x127mm
Fence Angle	90° -135°
Working Table	920x264 mm
<b>Technical data-Thicknesser</b>	
Cutting Width(max)	254 mm (10")
Cutting thickness(max)	6-120mm
Cutting Depth (max)	2mm
Working Table	380x254mm

## SAFETY RULES:

**WARNING:** When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following.

Read all these instructions before attempting to operate this product and save these instructions.

- (1) Keep work area clear
  - Cluttered area and benches invite injuries.
- (2) Consider work area environment
  - Don't expose electric tools to rain.
  - Do not use electric tools in damp or wet locations.
  - Keep work area well lit.
  - In particular, no inflammable liquids or gases must be present.
- (3) Guard against electric shock
  - Avoid body contact with earthed or grounded surface.
- (4) Keep children and other persons away
  - Don't let especially children, persons not involved in the work touch the tool or extension cord and keep them away from the work area.
- (5) Store idle tools
  - When not in use, tools should be stored in a dry locked up place, out of reach of children.
- (6) Don't force the tool
  - It will do the job better and safer at the rate for when it was intended.
- (7) Use the right tool
  - Don't force small tools to do the job of a heavy duty tool.
  - Don't use tools for purposes not intended: for example, don't use circular saws to cut tree limbs or logs.
- (8) Dress properly
  - Don't wear loose clothing or jewelry. They can be caught in moving parts.
  - Rubber gloves and non-skid footwear are recommended when working outdoors.
  - Wear protective hair covering to contain long hair.
- (9) Use protective equipment
  - Use safety glasses.
  - Use face or dust mask if cutting operations create dust.
- (10) Don't abuse cables
  - Never carry tool by cable or rank it to disconnect it from socket. Keep cable from heat, oil and sharp edges.
- (11) Do not abuse the cord
  - Never yank the cord to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.
- (12) Secure work
  - Where possible use clamps or a vice to hold the work. It is safer than using your hand.
- (13) Don't overreach
  - Keep proper footing and balance at all times.
- (14) Maintain tools with care
  - Keep cutting tools sharp and clean for better and safer performance.

- Follow instruction for lubricating and changing accessories.
  - Inspect tool cords periodically and if damaged have them repaired by an authorized service facility.
  - Inspect extension cords periodically and replace if damaged.
  - Keep handles dry, clean and free from oil and grease.
- (15) Disconnect tools
- When not in use, before servicing and when changing accessories such as blades, bits and cutters, disconnect tools from the power supply.
- (16) Remove adjusting keys and wrenches
- Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- (17) Avoid unintentional starting
- Ensure switch is in "off" position when plugging in.
- (18) Use outdoor extension leads
- When the tool is used outdoors, use only extension cords intended for outdoor use and so marked.
- (19) Stay alert
- Watch what you are doing, use common sense and do not operate the tool when you are tired.
- (20) Check damaged parts
- Before further use of tool, it should be carefully checked to determine that it will operate properly and perform it's intended function.
  - Check for alignment of moving parts, binding of moving parts, mounting and any other conditions that may affect it's operation.
  - A guard or other part that is damaged should be properly repaired or replaced by an authorized service centre unless otherwise indicated in this instruction manual.
  - Have defective switches replaced by an authoeized service centre.
- (21) Warning
- The use of any accessory or attachment other than one recommended in this instruction manual may present a risk of personal injury.
- (22) Have your tool repaired by a qualified person
- This electric tool complies with the relevant safety rules. Repairs should only be carried out by qualified persons using original spare parts. Otherwise this may result in considerable danger to the user.
- (23) Never use the machine without the appropriate guard in place and correctly adjusted.
- (24) Do not use knives, which are blunt as this increases the danger of kickback.
- (25) Any portion of the cutter block not being used for planning shall be guarded.
- (26) When planning short workpieces, a push-stick should be used.
- (27) When planning narrow workpices additional measures. Such as of horizontal pressure devices and spring-loaded guards, may be necessary to ensure safe working.
- (28) Do not use the tool cut rebate.
- (29) The effectiveness of the device for the prevention of kickback and the feed spindle should be regularly inspected to ensure safe operation.
- (30)Tools equipped with chip collection and extractor hoods shall be connected to the dust and chip-collecting device.
- (32) Use this tool only for wood or similar materials.
- 3) Need two persons for moving round the workshop due to its heavy weight.

# SUPPLEMENTARY SAFETY INSTRUCTIONS

- (1) Regularly check the blades and lock bars are locked tight in cutterblock.
- (2) Max. allowable blade projection over cutterblock 1.0mm/0.004 inch +10%.
- (3) Never remove any of the machine's safety guards other than for servicing and repair work. Keep guards operational at all times.
- (4) Set and secure safety guards in position before operating machine.
- (5) When operating machine in enclosed spaces connect to a dust collector.
- (6) This machine must be safety earthed. The yellow/green (green) lead is the earth conductor.
- (7) Regularly check anti-kickback fingers for proper operation.
- (8) Always wear eye protection.
- (9) Rebating, tenoning, moulding and recessing may not be undertaken without the use of special guards.
- (10) Never make jointing or planing cut deeper than 2 mm.

## USER RESPONSIBILITY

This machine will perform in conformity with the description contained in this manual when installed, operated, maintained and repaired in accordance with the instructions provided.

This machine must be checked periodically. Defective equipment (including power cable) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repair or replacement become necessary, it is recommended that such repairs be carried out by qualified persons.

This machine or any of its parts should not be altered or changed or changed from standard specifications. The user of this machine shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specification, Faulty maintenance, damage or improper repair.

## UNPACKING

Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer.

The machine is shipped complete in one carton. Additional parts which need to be fastened to machine should be located and accounted for before assembling. Refer to figure 1 and figure 2.

### Parts of machine

- A. Planer and Thicknesser
- B. Angle fence
- C. 4mm Hex wrench
- D. Handle assembly
- E. Socket head bolt
- F. Dust chute

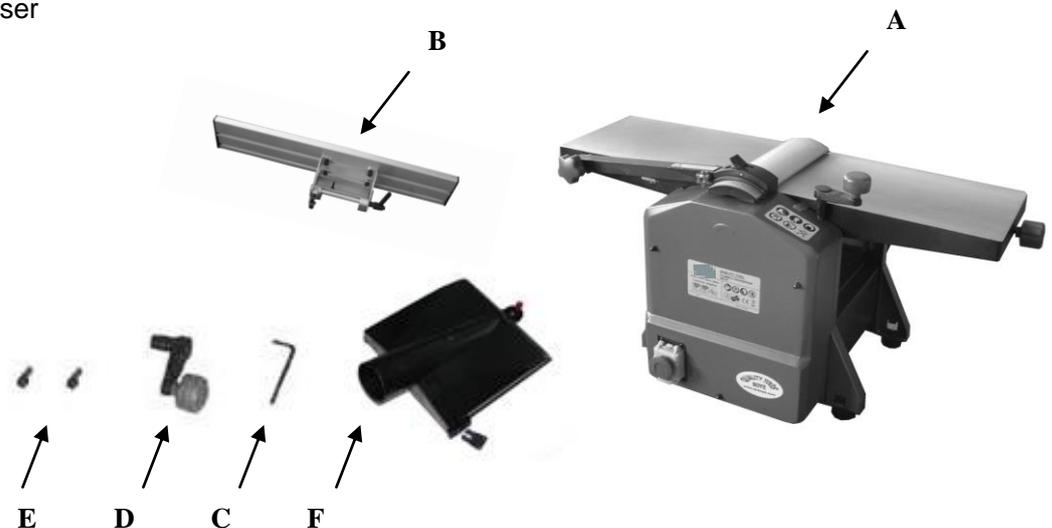


Figure 1 Parts of stand

Description

QTY

- G. Short top frame 2
- H. Long top frame 2
- I. Short brace 2
- J. Long brace 2
- K. Leg 4
- L. 8mm flat washer 4
- M. M8X30 hex bolt 4
- N. M6 hex nut 24
- O. 6mm flat washer 24
- P. M6X12 carriage bolt 24

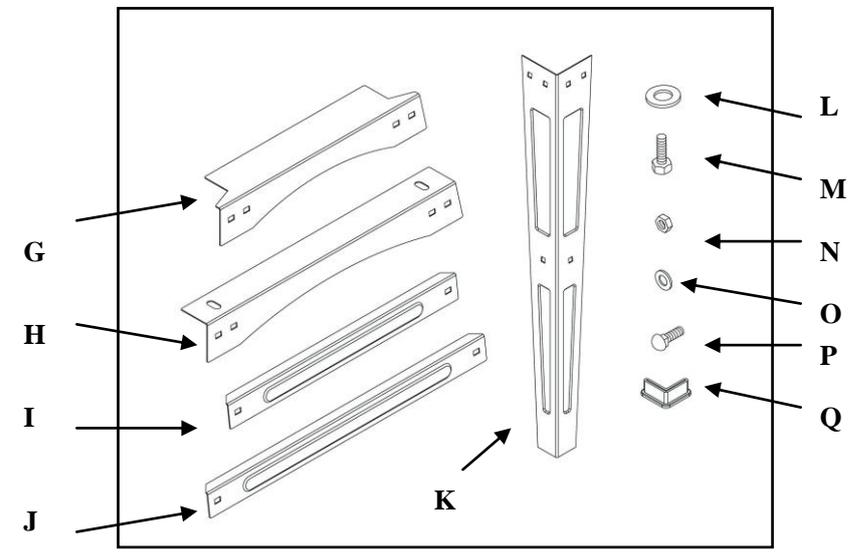


Figure2

## STRUCTURE AND FUNCTIONS

The surface planer-thicknesser is a transportable electric tool. The machine is driven by a single-phase series motor, and it is double insulated. It is used to planer-thicknesser wood. It has the characteristics of rational structure, easy operation and high efficiency. Refer to figure 3.

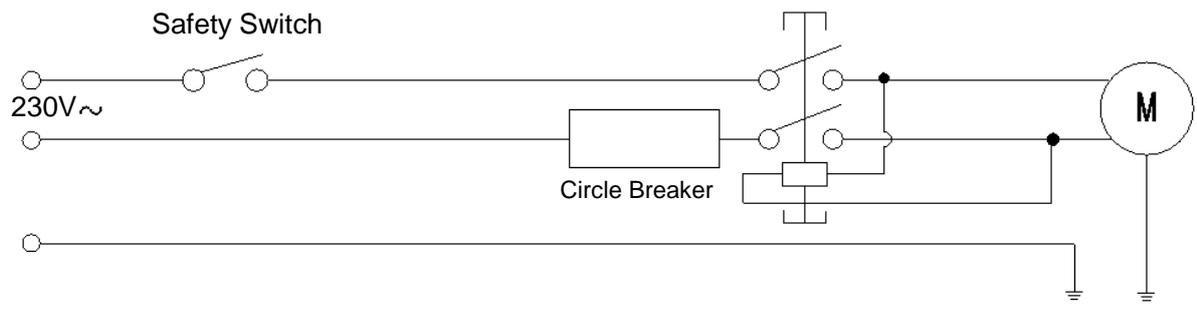


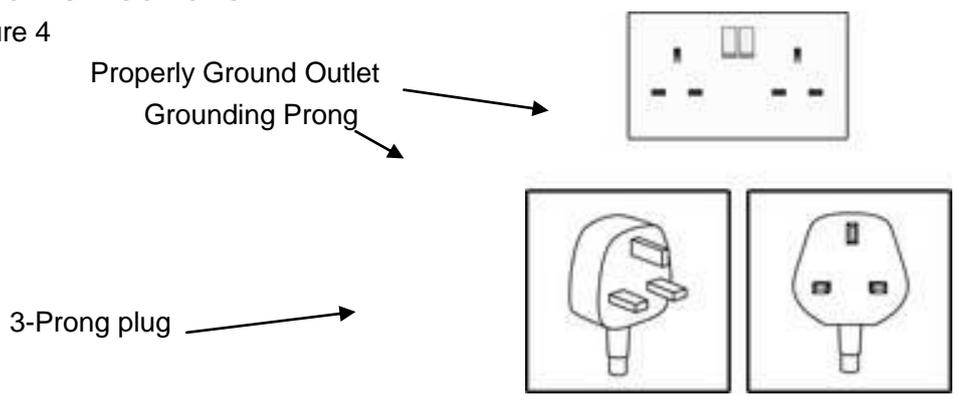
Figure 3

### POWER SOURCE

**WARNING:** Do not connect planer-thicknesser to the power source until all assembly steps have been completed. The motor is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below specified voltage. Running the until on voltages which are not within range may cause overheating and motor burnout. Heavy loads require that voltage at motor terminals be no less than the voltage specified on nameplate.

### GROUNDING INSTRUCTIONS

Refer to figure 4



**Figure 4**

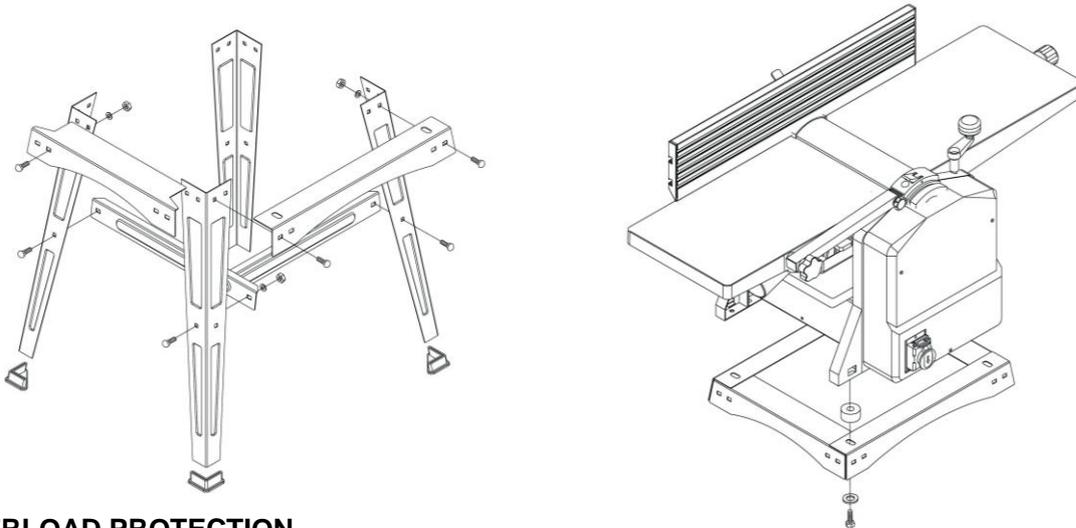
**WARNING:** Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

- Check with a qualified electrician if you do not understand grounding instructions or if you are in doubt as to whether the tool is properly grounded.
- This tool is equipped with an approved cord rated at 230v and a 3-prong grounding type plug for you protection against shock hazards.
- Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown.
- Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

## **OPERATION REGULATIONS**

**ATTENTION:** Make sure that the switch is in off position before adjusting the cutting depth, replacing or adjusting the blades. Make sure the blade screws are securely tightened.

**Assemble** stand with M6 hex nut, 6mm flat washer and carriage bolt. Then install the machine to the stand and secure it with M8X30 hex bolt and 8mm flat washer



### **OVERLOAD PROTECTION**

If the motor protection responds, this always indicates that the motor is overloaded. The cause must be located and the fault eliminated.

If the motor is overloaded or in the event of power failure, the motor switches off automatically. The machine can not be switched on again until the motor is cooled down or the power supply has been restored.

### **SETTING ANGLE FENCE**

Insert the socket head bolt into the slot A and B. Then loosen C to adjust angle fence.

Turn M down, guide fence can be moved to left or right.

Refer to figure 5

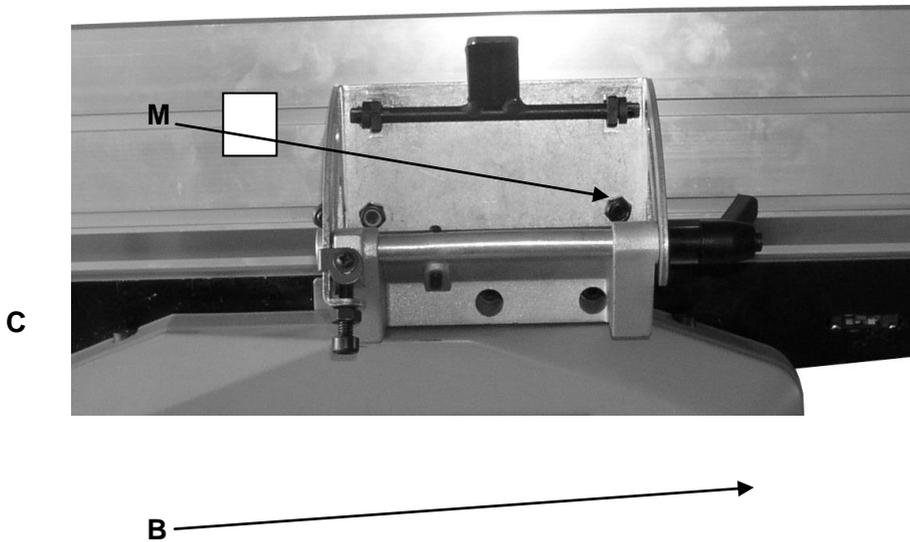


Figure 5

### CHIP EXTRACTION

To ensure trouble free and reliable operation on enclosed premises, the machine must be connected to an extractor unit at the dust chute E (accessory)

DUST CHUTE CONNECTION WHEN PLANING :

- Lift up the blade guard arm F so that the longitude holes G being exposed;
- Pull out the key H on both sides of the dust chute E;
- Move down the thickness table to the lowest position, and insert the dust chute E;

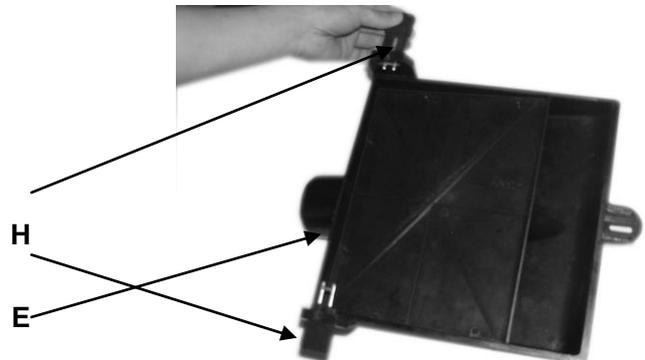
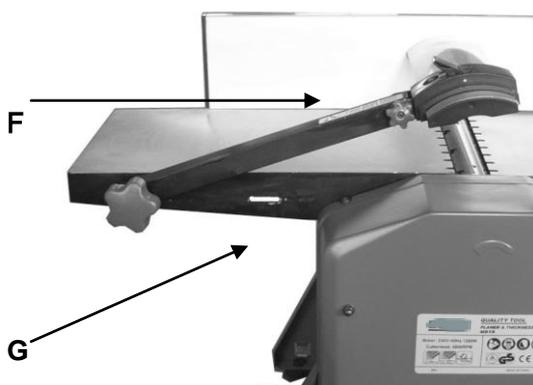
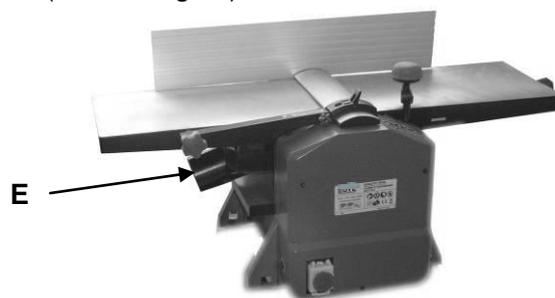


Figure 6

- The dust chute E is so positioned that both keys H are in line with the longitude holes G. Then push both keys H into the longitude holes G. (refer to Fig. 6 )

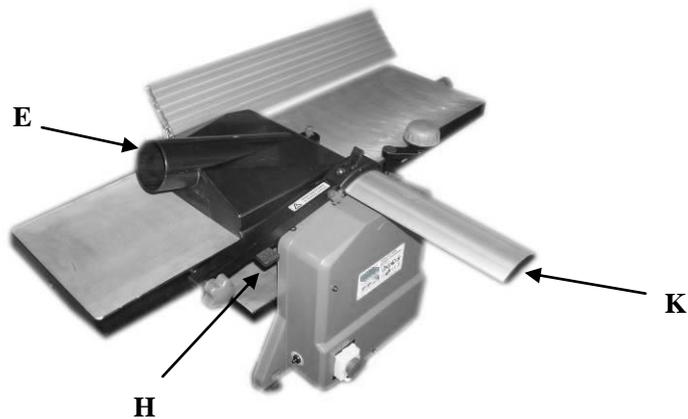


**Figure 7**

**DUST CHUTE CONNECTION WHEN THICKENING:**

- Slide the fence to right side, and turn to 135°
- Remove the blade guard K and place the dust chute E(See Figure 8).
- The dust chute E is so positioned that both keys H are in line with the longitude holes G. Then push both keys H into the longitude holes G (See Figure 6).

The minimum air velocity at the extractor connection must be 20m/s(65ft/sec) to ensure an optimum extraction.

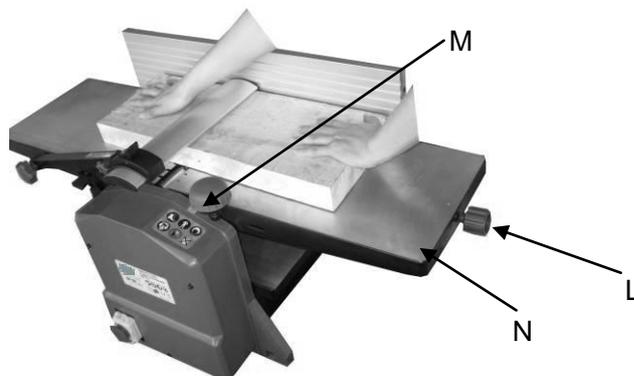


**Figure 8**

**SETTING OF GUARD**

Height adjustment is made with the lever mounted on the left side of the machine. After lifting the lock lever the blade cover can slide to set the required stock width for jointing. Push lock lever down to lock guard extrusion in position.

Refer to Figure 9.



**Figure 9**

**PLANING**

The cutting depth is set by handle L at the front table plate N by means of the scale for cutting depth M. Cutting depth between 0.5 and 1.5 mm (1/64~1/16 in.) will produce the best surface.

**WARNING:** The part of the cutter head not used has to be covered by the blade guard.

Take up a working position so that you are always on one side of the machine away from the area directly in front of or behind the cutterhead. Place both hands on the workpiece with the fingers. Do not hold on to the workpiece edges.

Only workpieces should be planed which rest firmly on the machine and can be safety guided.

Refer to figure 10.



**Figure 10**

### **THICKNESSING**

-Set the desired height with handle assembly at spindle with reference to scale.

1 turn =3mm

-Slide in narrow wood in the middle.

When thicknessing the table must be lubricated regularly with lubricant. After having worked for a long period or when planing wet wood it may occur that the workpiece stops while pulling in.

**WARNING:** Switch off the machine immediately in case of failure. Do not remove chips and splinters from the tables while the machine is running.

Short workpieces should not be planed.

### **REPLACING BLADES**

Disconnect machine from power before servicing!

Replacing blades

-Unplug the planer-thicknesser from power source and turn the switch to “off” position.

-Block the blade guard from closing down.

-Loosen and remove three blade lock screws securing blade and blade clamp.

-Lift blade and blade clamp from cutterhead.

-Clean any sawdust and resin buildup from cutterhead and blade clamp.

-Place blade clamp against the replacement blade and replace in cutterhead.

-Secure blade and blade clamp using three blade lock screws. Do not over-tighten blade lock screws first.

**Note:** Check blade height at both sides of the blade

-Tighten blade lock screws.

-Recheck blade adjustment and make sure blade is still level with outfeed table.

-Repeat the procedure to replace the other blade.

-Remove the scrap wood and release blade guard.

-Make sure all the blade lock screws are tight and snug.

**NOTE:**

-The blades which used with the tool may be replaced.

-the blades used in this tool can not be used to rebate.

## **MAINTENANCE**

Prior to doing any maintenance work, always pull out the mains plug. The protecting hood which has been removed to the side has to be mounted again after the maintenance work.

### **Machine care**

The planer-thicknesser is designed with a low maintenance requirement. The bearing are greased for life.

After approximately 10 hours of operation we recommend to lubricate the following parts:

-bearings of the feed-in and feed-out rollers.

-bearings of pulley and gear wheel of the belt.

Treat threaded spindles for the height adjustment of the thicknessing table with dry lubricant only!

The table surface and feed-in / feed-out rollers should always be kept clean of resin.

Dirty feed-in rollers and feed-out rollers have to be cleaned.

In order to prevent the motor from overheating, regularly check that no dust has accumulated on the ventilation apertures of the motor.

After a prolonged period of operation, users are recommended to have the machine checked by an authorized customer service shop.

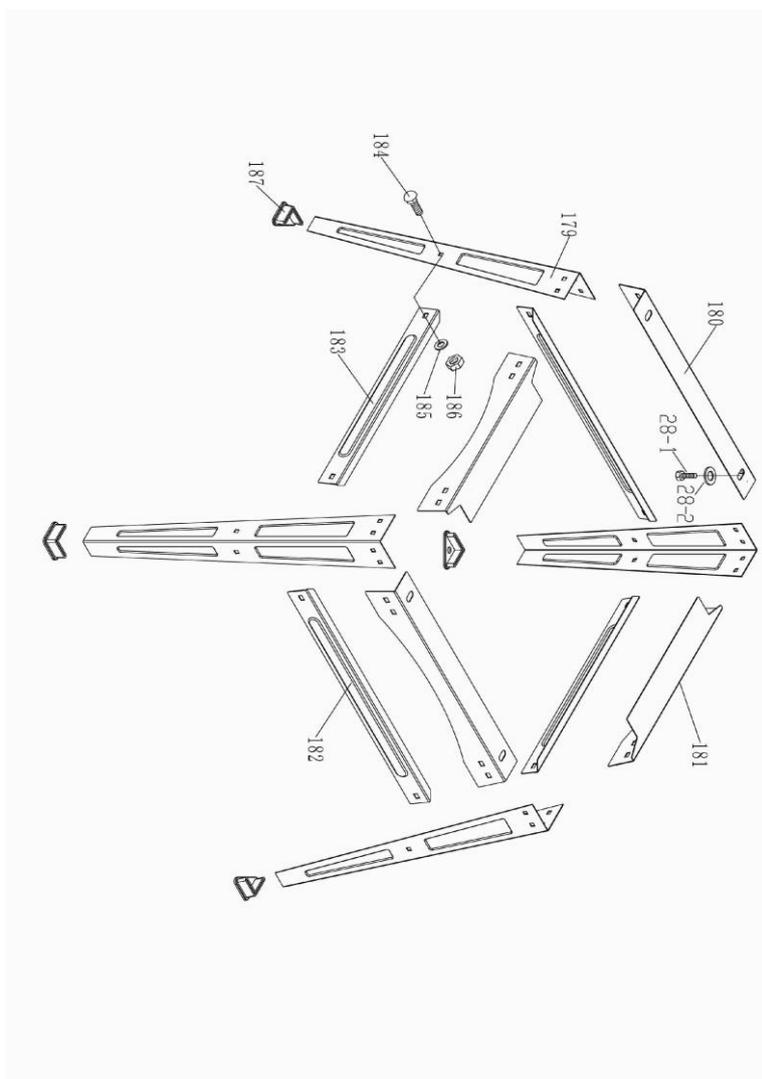
### Tool care

The cutter head, clamping devices, knife supports and knives used on the machine must be freed from resin regularly as a clean tool improves the cutting quality. This can be done by soaking the clamping devices, knife supports and reversible knives for 24 hours in paraffin, white spirit or commercially available resin remover.

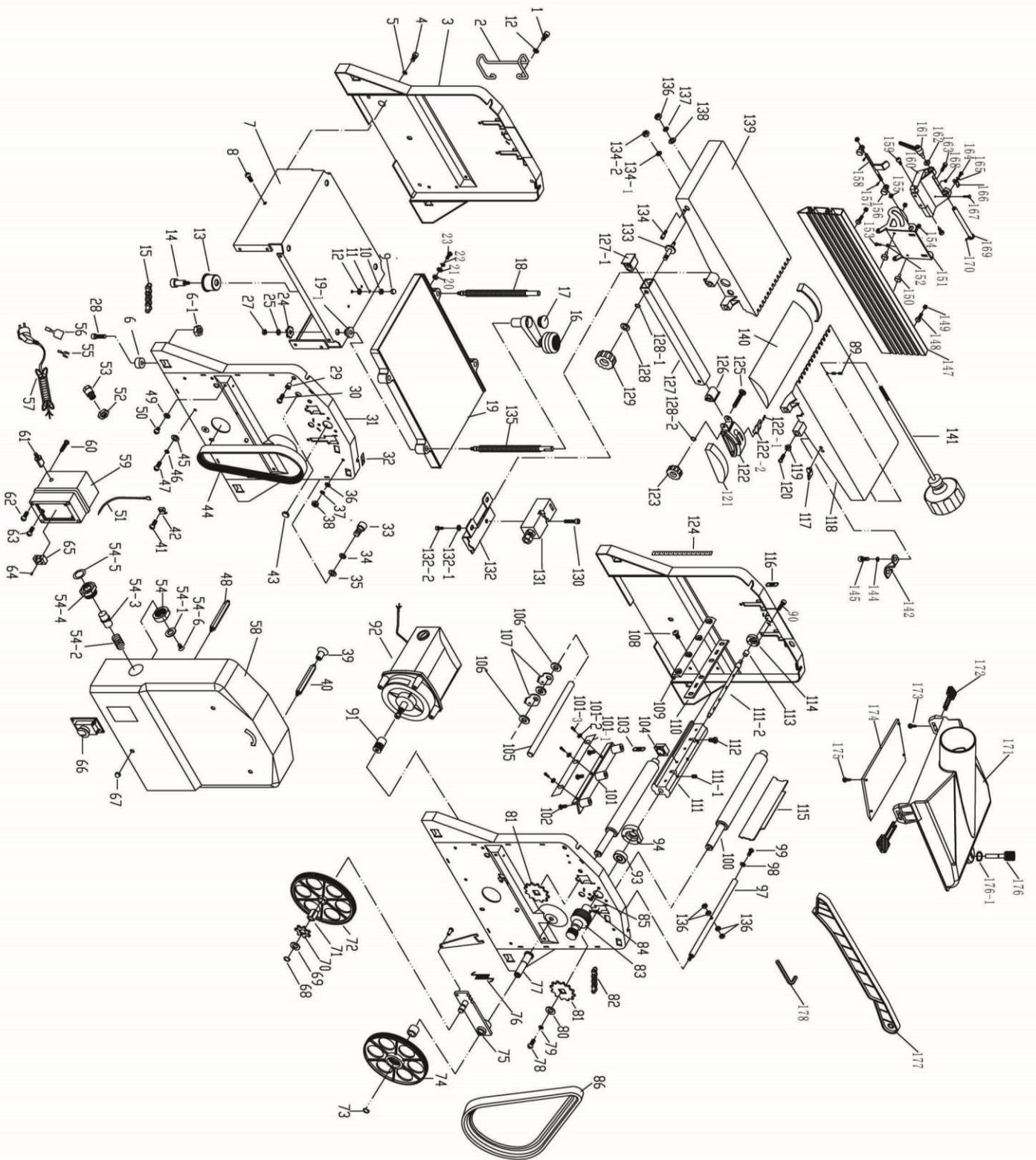
Tools made of aluminum may only be deresinified with cleaning agents which do not corrode this kind of material.

## ATTENTION!

Through poor conditions of the electrical MAINS, shortly voltage drops can appear when starting the EQUIPMENT. This can influence other equipment (eg. Blinking of a lamp). If the MAINS-IMPEDANCE  $Z_{max} < 0.464 \text{ OHM}$ , such disturbances are not expected. (In case of need, you may contact your local supply authority for further information).



# ASSEMBLY DIAGRAM



# **CE DECLARATION OF CONFORMITY**

## **TOOLSAVE**

Unit C Manders Ind Est  
Old Heath Rd  
Wolverhampton,  
West Midlands,  
WV1 2RP,  
ENGLAND.  
Tel: 01902450470

## **Declares that the 10" Planer Thicknesser PT254**

Is in compliance with the regulations included in the Directives: 2006/42/EC

## **EC DECLARATION OF CONFORMITY**

Certificate for EC-type examination delivered by Interk Testing Services Hangzhou 16  
No. 1 Ave., Xiasha Economic Development District, Hangzhou 310018, China  
(Verification No.:151000179HZH-V1)

**Person who declares: Bill Evans**

**CE**

**12.02.2019  
The Director**



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