LUMBER JACK

SAFETY AND OPERATING MANUAL
10" PLANER THICKNESSER
PT254/H

ORIGINAL INSTRUCTIONS

TABLE OF CONTENTS

SPECIFICATIONS

Model No		PT254/H
Motor		1500W (Please choose proper power source, voltage and frequency that are shown in the label for your machine.)
No. of Blade	Straight	2
	Helical	24
Cutterhead rpm		8500 min^{-1}
Weight		27 kg
Technical data-Planer		
Cutting Width(max)		254 mm (10″)
Cutting Depth (max)		2mm
Angle fence		610x127mm
Fence Angle		90° -135°
Working Table		920x254 mm
Technical data-Thicknesser		
Cutting Width(max)		254 mm (10″)
Cutting thickness(max)		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 try 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 its 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 authorised service centre.
- Do not use the tool if the switch does not turn it on and off.

(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 workpieces 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 the tool only for wood or similar materials.
When the blade be abraded 95%, you must change it to the new one, which must meeting EN847-1.

(33) Need two persons for moving round the workshop due to its heavy weight.

(34) The machine should be fixed on the floor by screws when operating.

SUPPLEMENTARY SAFETY INSTRUCTIONS

(1) Regularly check that blades and lock bars are locked tight in cutter block.

(2) Max. allowable blade projection over cutter block 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, molding and recessing may not be undertaken without the use of special guards.

⑽ Never make jointing or planning 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 1and 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

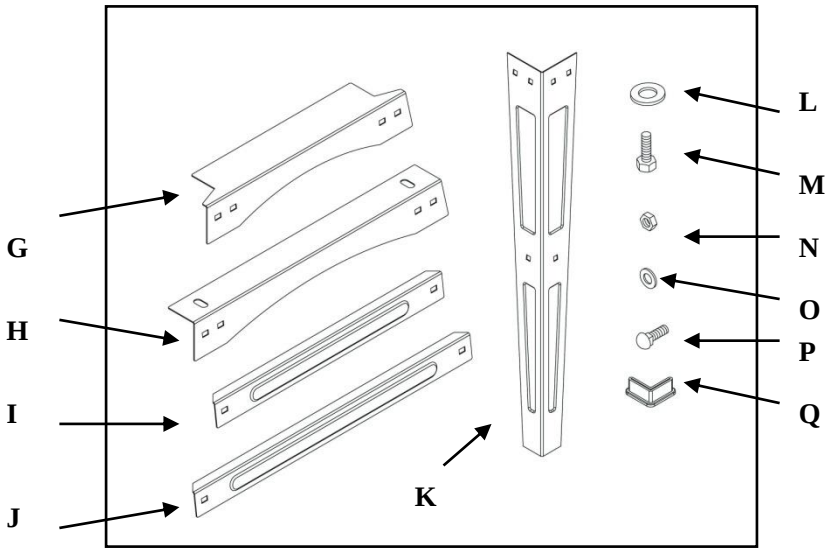


Figure2

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.

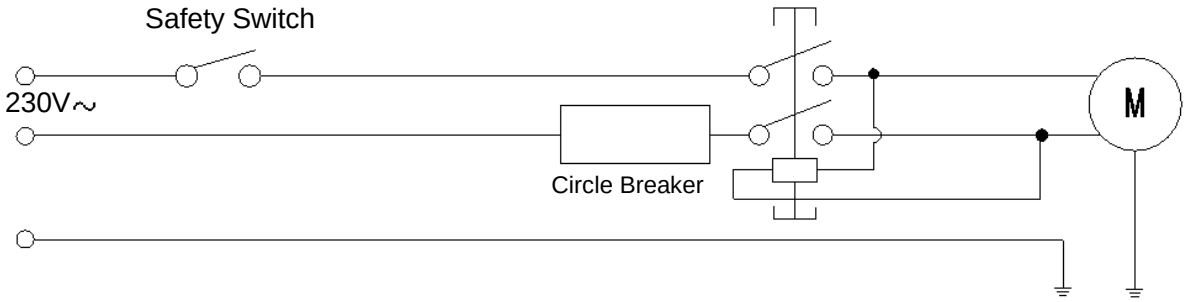


Figure 3

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.

GRONNDING 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.

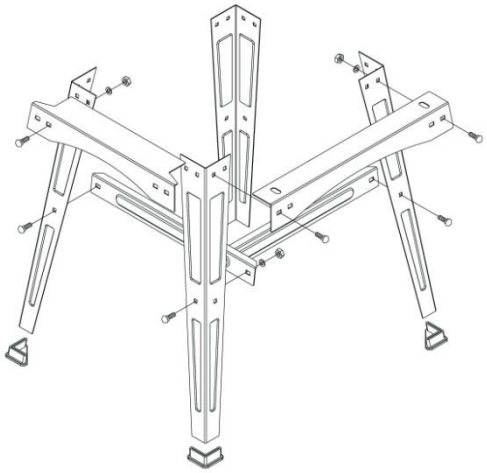
-Grounding plug should be plugged directly into a properly installed and grounded 3 prong grounding-type receptacle, as shown.

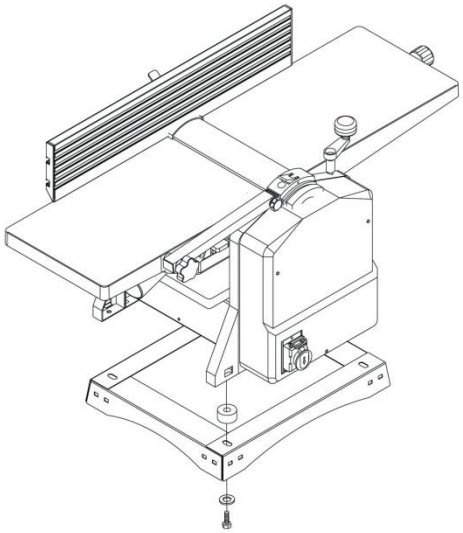
-Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

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 cannot 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

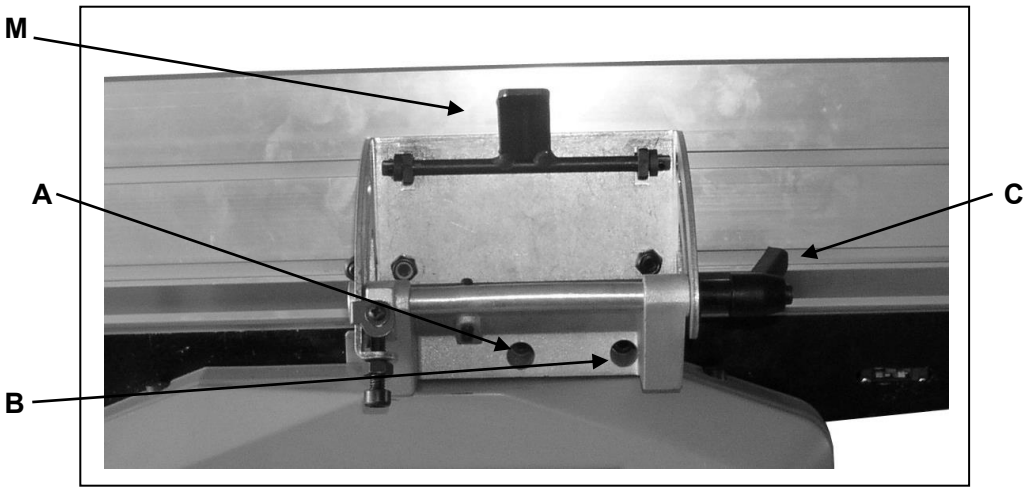


Figure 5

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;

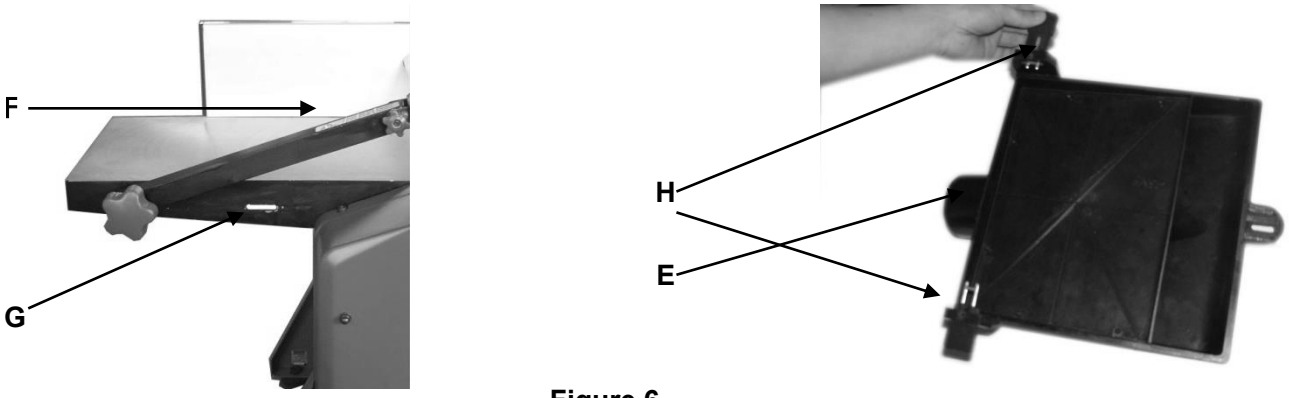


Figure 6

- 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 THICKNESSING:

-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.

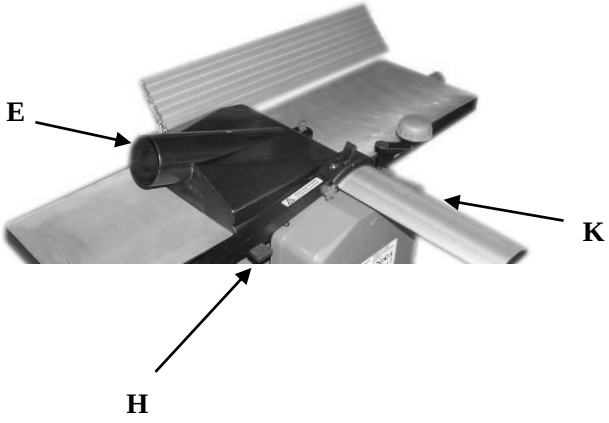


Figure 8

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 be slide ways to set the required stock width for jointing. Push lock lever down to lock guard extrusion in position.

Refer to Figure 9.

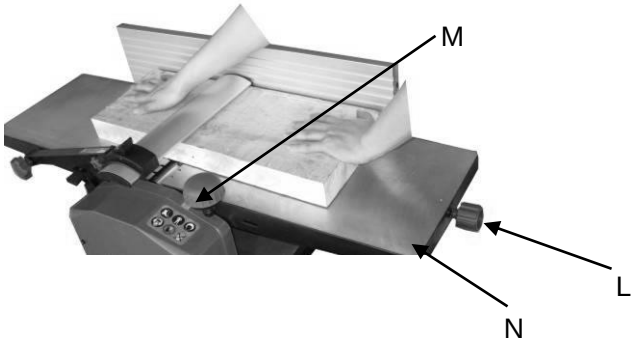


Figure 9

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 knife 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

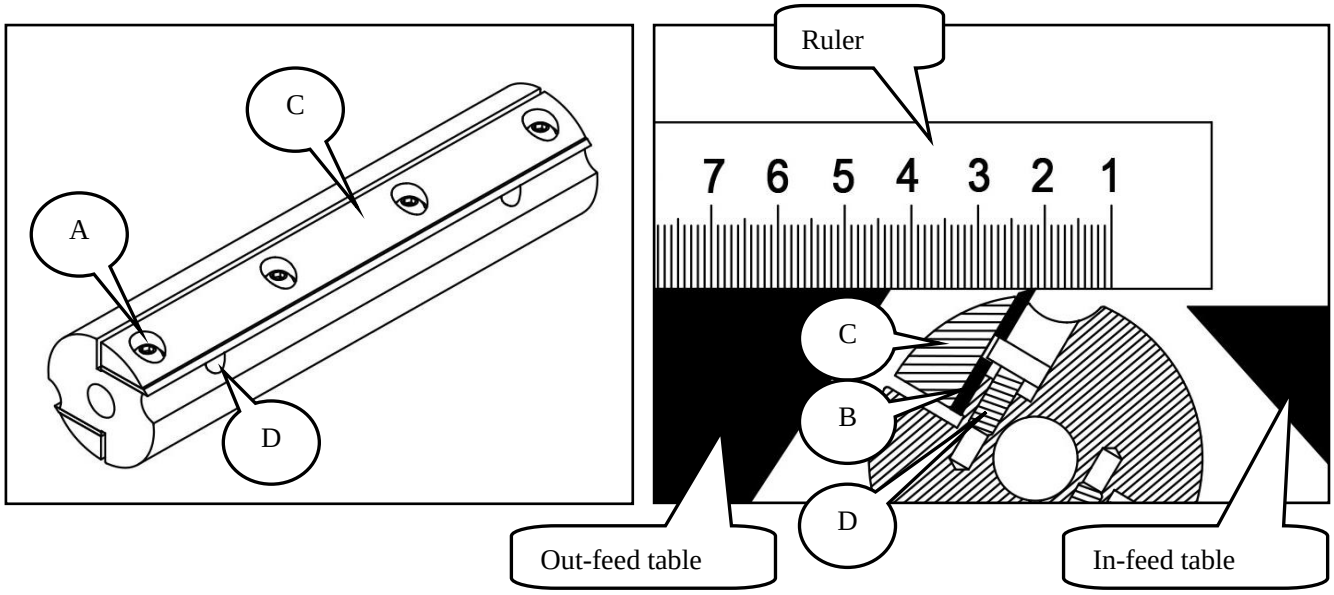
-Slide in narrow wood in the middle.

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 （FOR STRAIGHT CUTTING BLADE OF MODEL PT254）



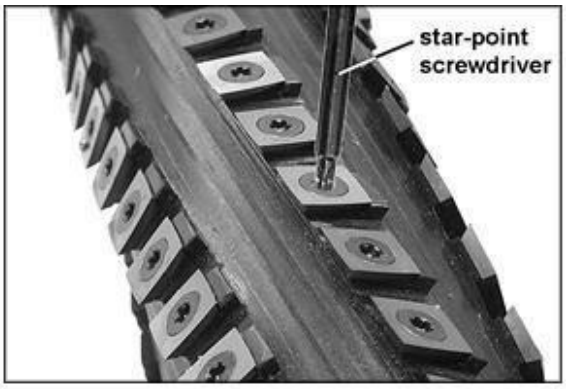
- Put the main switch of the machine to OFF position.
- Pull the power supply plug from the socket.
- Pull the cutter block guard aside.
- Turn the adjusting handle down the in-feed table.
- Release and remove the blade clamping screws (**A**).
- Lift the blades (**B**) and blade clamper (**C**) from the cutter block.
- Remove the chips and any resin from the cutter block and blade clamper.
- Place new blades (**B**) into the cutter block and fix them with the rectangle slots in both screw heads **(D)**. (With these two screws, height-adjustment of the blade is done.)
- Place the blade clamper (**C**) onto the blade.
- Slightly tighten the clamping screws (**A**).
- Repeat these actions for the second blade.
- Then adjust the planer blade exactly with the out-feed table. Use a ruler that you put onto the out-feed table.
- By the two set screws **(D)**, the blade can be adjusted for height.
- By turning the cutter block and using the ruler, you can see the height adjustment.
- The blade is exactly set, when the ruler is moved by the blade but not higher than 3 mm.
- After a successful blade setting, all clamping screws **(A)** must be tightened.
- Repeat upper actions for the second blade.

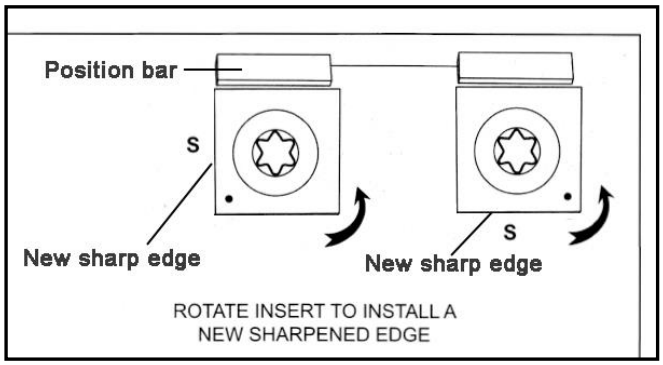
ATTENTION:

- The planer blades used on this machine are not suitable for rebating and dovetailing.
- Finally replace the cutter block guard to cover the cutter block again.

REPLACING/ROTATING KNIFE INSERTS (FOR HELICAL KNIFE INSERTS OF MODEL PT254H)

CAUTION: Make sure the switch is in the OFF position and cord is unplugged before proceeding with checking blades. Knife inserts are extremely sharp. Use caution when cleaning or changing. Failure to comply may cause serious injury. Position the blade guard and showing the cutter head. The knife inserts are four-sided. When dull, simply remove each insert, rotate it 90° for a fresh edge, and re-install it. Use the provided star point screwdriver to remove the knife insert screw. It is advisable to rotate all inserts at the same time to maintain consistent cutting. However, if one or more knife inserts develops a nick, rotate only those inserts affected. Each knife insert has etched numerals to keep track of the rotations.





IMPORTANT: When removing or rotating inserts, clean saw dust from the screw, the insert, and the cutterhead platform. Dust accumulation between these elements can prevent the insert from seating properly, and may affect the quality of the cut.

Before installing each screw, lightly coat the screw threads with machine oil and wipe off any excess.

Securely tighten each screw which holds the knife inserts before operating the planer. Knife inserts should be torqued to approximately 5 to 5.5 NM.

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.

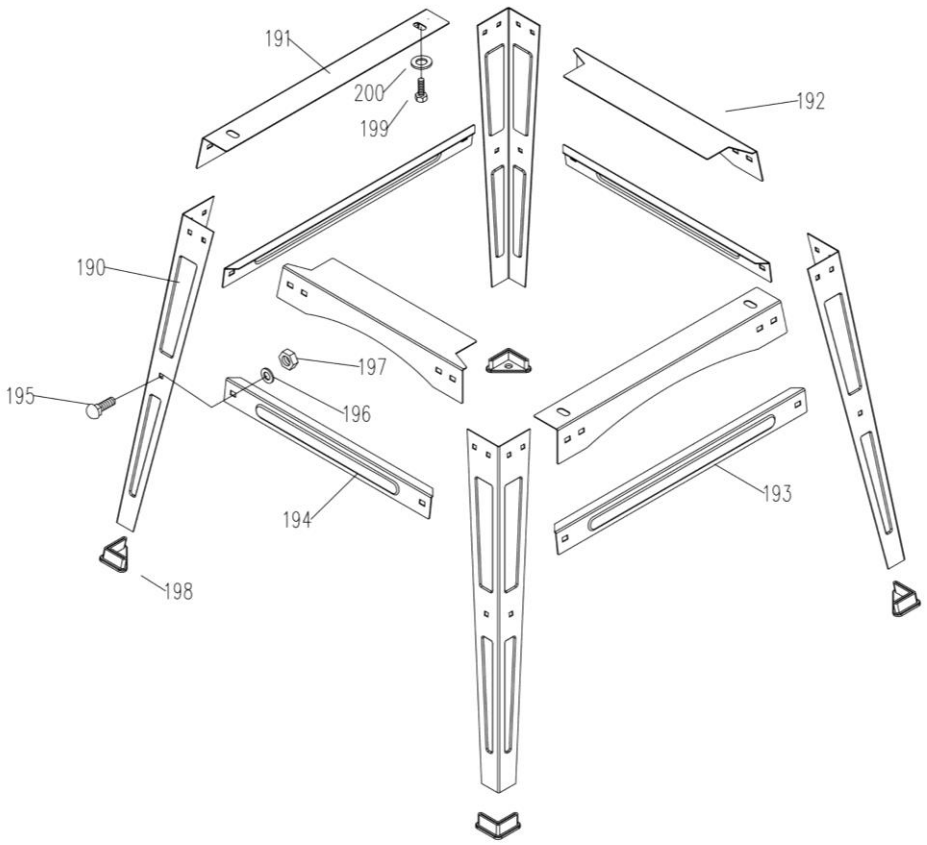
Tool care

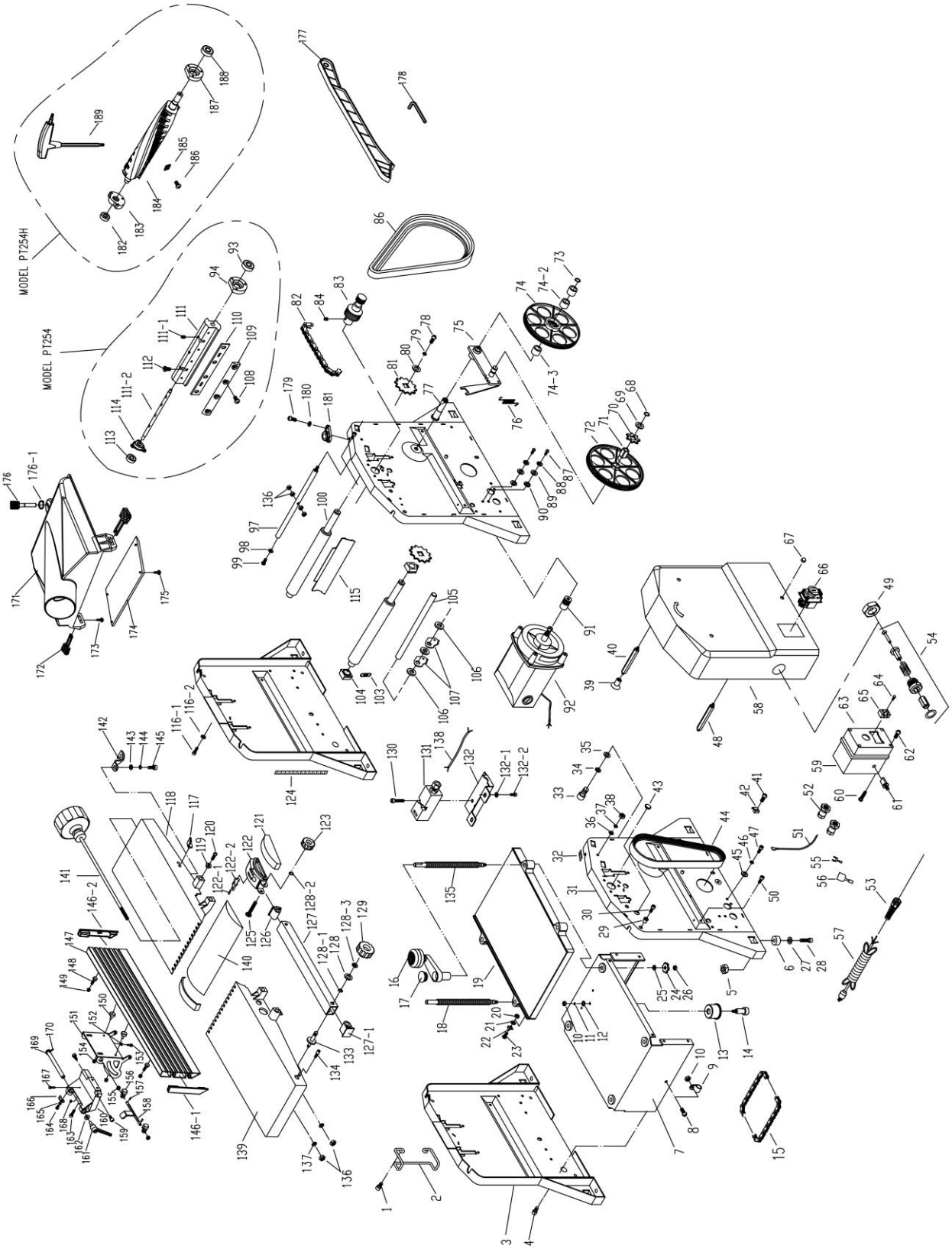
The cutter head, clamping devices, knife supports and knives used on the machine must be freed from resin regularly as a clean tool improves the cutting quality. This can be done by soaking the clamping devices, knife supports and reversible knives for 24 hours in paraffin, white spirit or commercially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

ATTENTION!

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

STAND ASSEMBLY DIAGRAM




MODEL PT254H
MODEL PT254

1	Socket head screw	4
2	Cord hook	2
3	Rear wall plate	1
4	Socket head screw	8
5	Hex nut	4
6	Foot	4
7	Base	1
8	Pan head screw	1
9	Cord clamp	1
10	Hex nut	2
11	Lock washer	1
12	Flat washer	1
13	Chain tension wheel	1
14	Shaft	1
15	Chain	1
16	Crank handle assembly	1
17	Handle cap	1
18	Screw	3
19	Thicknesser table	1
20	Hex nut	1
21	Flat washer	1
22	Pointer	1
23	Pan head screw	1
24	Sprocket	4
25	Flat washer 8mm	4
26	Lock nut	4
27	Flat washer 8mm	4
28	Socket head screw	4
29	Positioning sleeve	4
30	Socket head screw	4
31	Front wall plate	1
32	Scale	1
33	Socket head screw	1
34	Lock washer	1
35	Flat washer	1
36	Flat washer 8mm	1
37	Lock washer 8mm	1
38	Hex nut M8	1
39	Rivet nut	3
40	Hex bar	2
41	Pan head screw	5
42	Cord clarmp	5
43	Rubber bushing	2
44	Belt	1

45	Flat washer	4
46	Lock washer	4
47	Socket head screw	4
48	Hex bar	1
49	Hex nut M14	1
50	Socket head screw	4
51	Cable tie	1
52	Bushing	2
53	Bushing	1
54	Reset button assembly	1
55	Quick connecting terminal	4
56	Insulation sleeve	4
57	Power cord	1
58	Cover	1
59	Rear switch box	1
60	Thread forming screw	2
61	Circuit breaker	1
62	Thread forming screw	4
63	Front switch box	1
64	Thread forming screw	2
65	Terminal	1
66	Main switch	1
67	Lock nut	3
68	Retaining ring	1
69	Flat washer	1
70	Sprocket	1
71	Square bushing	1
72	Gear	1
73	Retaining ring	1
74	Pulley with pinion	1
74-2	Bushing	1
74-3	Needle roller bearing	2
75	Mounting plate assembly	1
76	Spring	1
77	Shaft	1
78	Socket head screw	2
79	Lock washer	2
80	Flat washer	2
81	Sprocket	2
82	Chain	1
83	Spindle pulley	1
84	Set screw	2
85	Socket head screw	3
86	Belt	1

87	Pan head screw M5X10	2
88	Lock washer 5mm	2
89	Flat washer 5mm	2
90	Serriated washer 5mm	2
91	Motor pulley	1
92	Motor	1
93	Ball bearing	1
94	Bearing house	1
97	Rod	1
98	Flat washer	1
99	Socket head screw	1
100	Feed roller	2
103	Spring	3
104	Bearing block	5
105	Shaft	1
106	Spacer	27
107	Kick-back pawl	26
108	Socket pan head screw	8
109	Blade clamper	2
110	Blade	2
111	Cutter block	1
111-1	Set screw	4
111-2	Spindle shaft	1
112	Adjusting screw	4
113	Ball bearing	1
114	Bearing house	1
115	Apron	1
116-1	Socket head screw	3
116-2	Lock washer	3
117	Pointer	1
118	Infeed table	1
119	Guide bushing	4
120	Socket head screw	4
121	Guard cover	2
122	Guard support	1
122-1	Pin	1
122-2	Knob	1
123	Knob	1
124	Scale	1
125	Carriage bolt	1
126	Arm cap	1
127	Support arm	1
127-1	Cap	1
128	Flat washer	1

128-1	Retaining ring	1
128-2	Retaining ring	1
128-3	Lock washer 8mm	1
129	Knob	1
130	Socket head screw	2
131	Interlock switch	1
132	Switch fixing plate	1
132-1	Flat washer	4
132-2	Socket head screw	4
133	Shaft	1
134	Pin	1
135	Lifting screw	1
136	Hex nut M6	2
137	Lock washer 6mm	2
138	Inner wire	1
139	Outfeed table	1
140	Cutterblock guard	1
141	Table adjusting screw	1
142	Fixing plate	1
143	Flat washer	2
144	Lock washer	2
145	Socket head screw	2
146-1	Fence cover A	1
146-2	Fence cover B	1
147	Fence	1
148	Hex head bolt	2
149	Lock nut	2
150	Guide screw	2
151	Angle support	2
152	Hex nut	1
153	Socket head screw	1
154	Lock nut	2
155	Locking block	2
156	Guide screw	2
157	Pin	2
158	Locking handle	2
159	Positioning screw	2
160	Fence support base	1
161	Locking handle	1
162	Flat washer	1
163	Socket head screw	2
164	Pan head screw	1
165	Flat washer	1
166	Pointer	1

167	Socket head screw	1
168	Hex nut	1
169	Rod	1
170	Pin	1
171	Dust chute	1
172	Key	2
173	Thread forming screw	2
174	Dust chute cover	1
175	Thread forming screw	4
176	Knob	1
176-1	Retaining ring	1
177	Push stick	1
178	Hex wrench	1
179	Pan head screw	2
180	Flat washer	2
181	Guide block	1
182	Ball bearing	1
183	Bearing house	1
184	Helical cutting head	1
185	Knife insert	24
186	Screw	24
187	Bearing house	1
188	Ball bearing	1
189	Torx wrench	2
190	Leg	4
191	Long frame	2
192	Short frame	2
193	Long brace	2
194	Short brace	2
195	Carriage bolt	24
196	Flat washer	24
197	Hex nut	24
198	Foot	4
199	Hex head bolt	4
200	Flat washer	4

DECLARATION OF CONFORMITY

We Importer:

TOOLSAVE LTD
Unit C, Manders Ind. Est.,
Old Heath Road, Wolverhampton,
WV1 2RP.

Declare that the product:

Designation: 1500W Planer Thicknesser
Model: PT254/PT254H

Complies with the following Directives:

Electromagnetic Compatibility Directive - **2004/108/EC**
Machine Directive - **2006/42/EC**
Restrictions of the use of Hazardous Substances in Electrical Equipment - **2011-65/EU**
Waste Electrical and Electronic Equipment - **2012/19/EU**

Standards & technical specifications referred to:
EN 61029-1:2009+All
EN 61029-2-3:2011
AfPS GS 2019:01 PAK

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The Director