

BTS SURFACING TABLE INSTRUCTIONS



NOTE:

THE BASIC CONSTRUCTION OF OUR BTS MACHINE IS THE SAME AS THE BT THICKNESSER WITH THE ADDITION OF TOP SURFACING TABLES.

THE BASIC BT INSTRUCTION BOOK IS THEREFORE VALID APART FROM THE TOP TABLES WHICH ARE SHOWN IN THESE SUPPLEMENTARY INSTRUCTIONS.

B.T.S. WIRING DETAILS.

See enclosed B.T.S. Foundation Drawing for wiring diagram.
For fuse rating, refer to Page 3 of B.T. instruction manual.

B.T.S. LUBRICATION.

Refer to enclosed B.T.S. Foundation Drawing for lubrication details.

B.T.S. SLINGING OPERATION.

Ensure thickening table is in uppermost position. Attach slings to machine as shown in FIG.1A. and ensure damage will not be caused to machine during slinging operation.

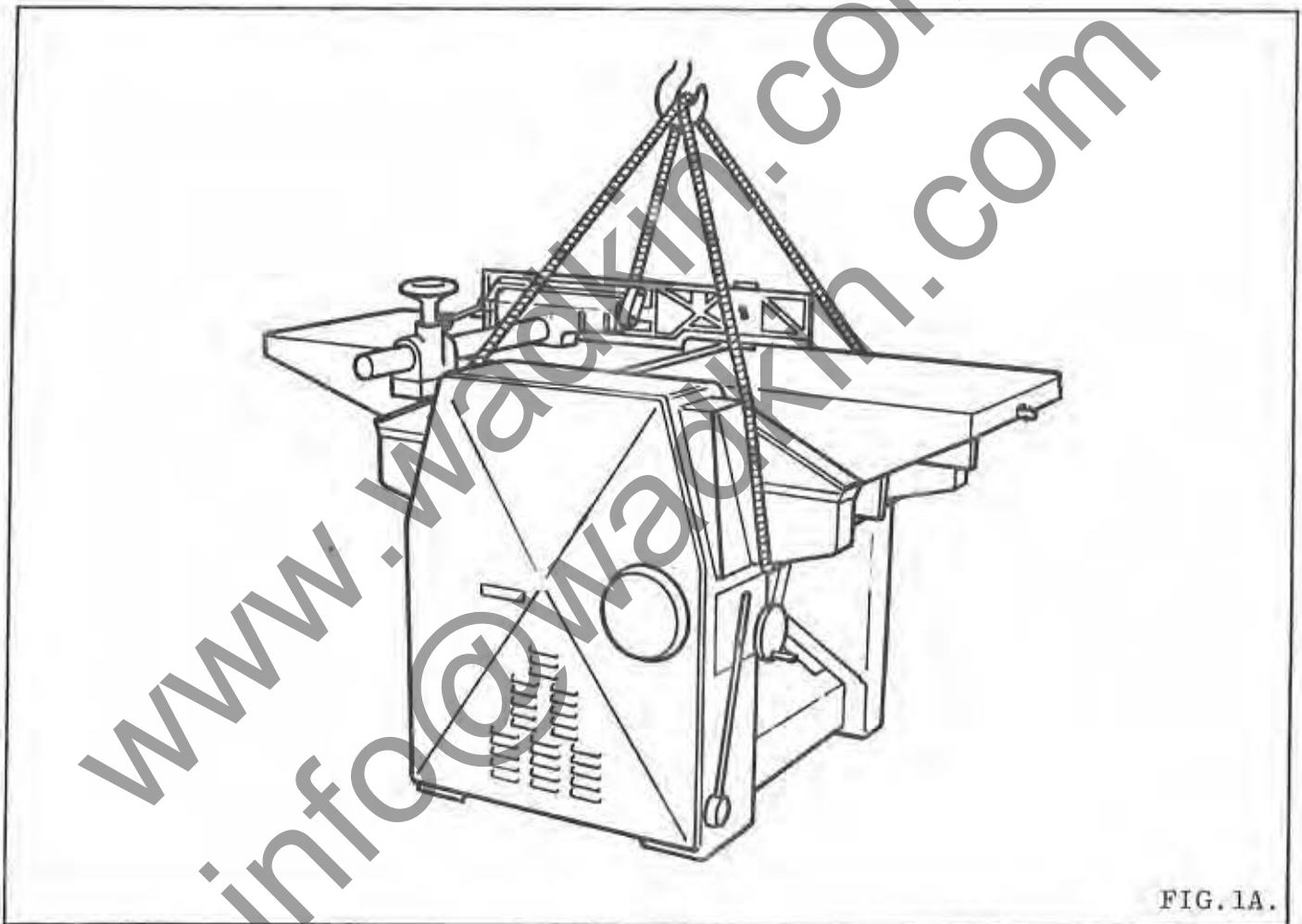


FIG. 1A.

IMPORTANT.

BEFORE ADJUSTING TABLES OR OPERATING MACHINE ETC.,
READ SAFETY NOTES INSIDE FRONT COVER OF B.T. INSTRUCTION MANUAL.

CONTROLS

The control panels are situated at the thickening infeed end of the machine with the following controls incorporated in a grouped layout:- FIG. 1

1. A digital timber thickness indicator
2. Cutterblock start - stop switch.
3. Feed selector switch.
4. Table rise and fall micro adjustment handwheel
5. Lock for table rise and fall micro adjustment handwheel
6. Power table rise and fall lever.
7. Infinitely variable feed speed controls.
8. Under table roller adjusting lever.

An additional Cutterblock start - stop switch is fitted to the side of the infeed planing table for operator convenience.

NOTE: See controls and Operation of enclosed instruction manual.

SURFACE TABLE ADJUSTMENT

To raise or lower the infeed table, loosen knurled knob "A" in FIG.2 then turn adjusting nut "B" using crank handle supplied with machine, working in conjunction with the depth of cut scale "C" indicated by pointer "D". When set tighten knurled knob "A".

Ensure the outfeed table top is always kept in line with the cutting circle, See FIG. 11.

BTS FENCE ADJUSTMENT

The fence has positive stops at 90° and 45° which are accurately set before despatch.

To cant fence, loosen handwheel "A" in FIG. 3 and move fence to required position by lever "B". When set relock handwheel "A".

The fence front plate is fitted with an insert "C" which is adjustable depending on the depth of cut being taken. To adjust, loosen wingnut "D" then move insert until it touches the rear table. Relock wingnut "D".

NOTE: The insert should be loosed at all times before raising or lowering table.

To move fence across the table, loosen adjustable handle "E" then turn handwheel "F" until fence is in required position. Relock adjustable handle "E".

The fence should be locked in both positions at all times when machine is in operation.

WORKING WITH FENCE: SEE FIG. 4.

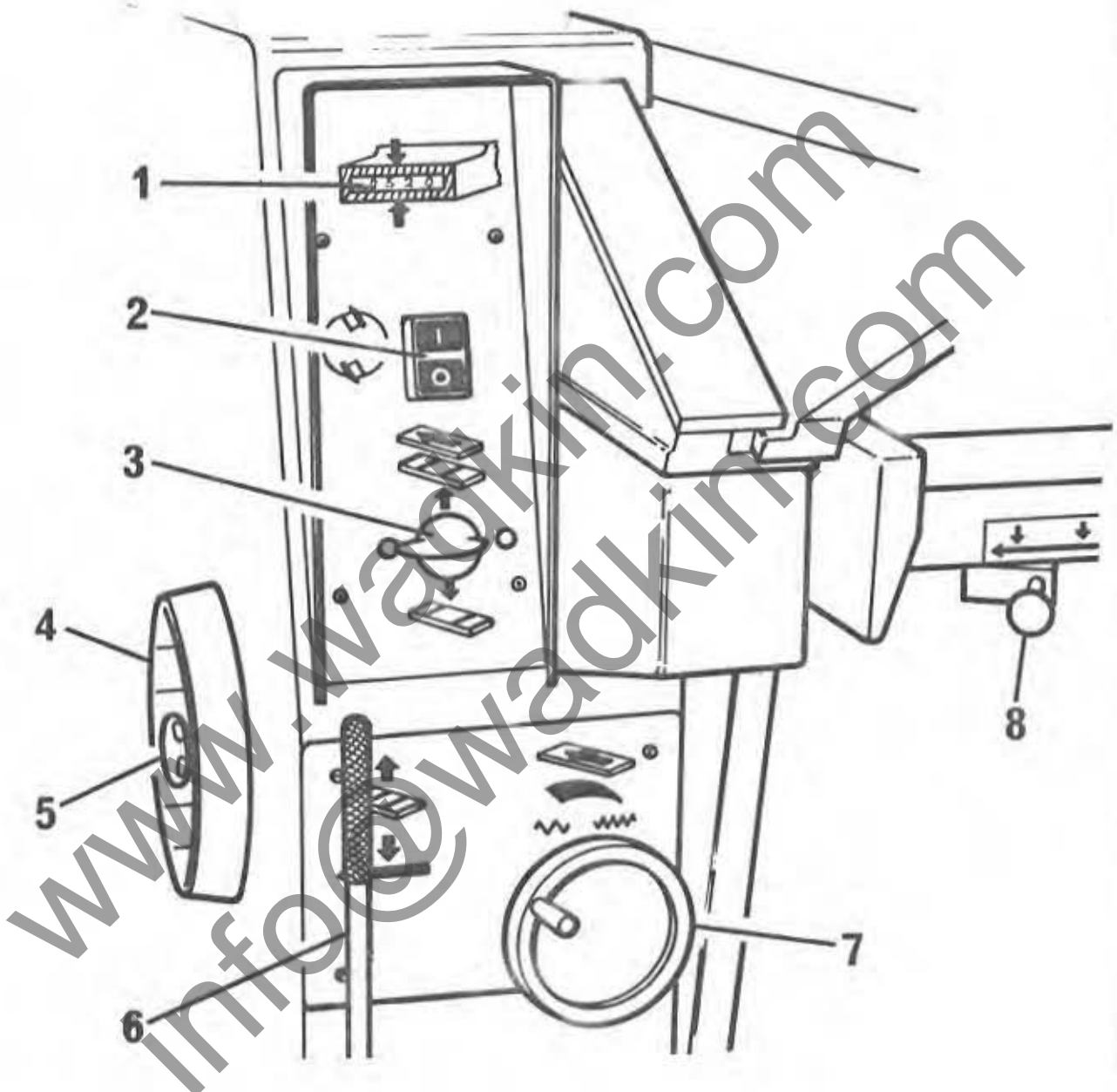


FIG 1.

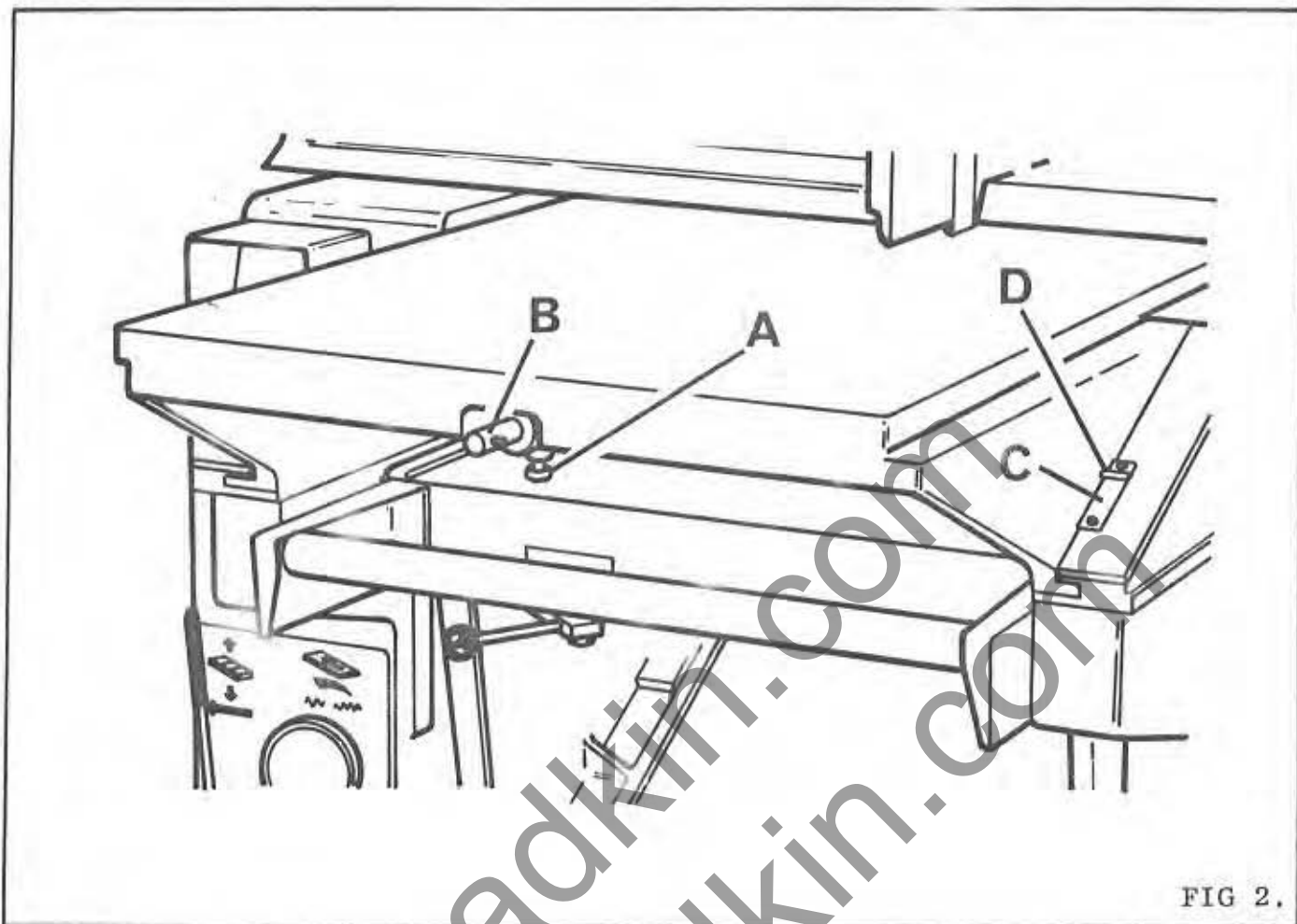


FIG 2.

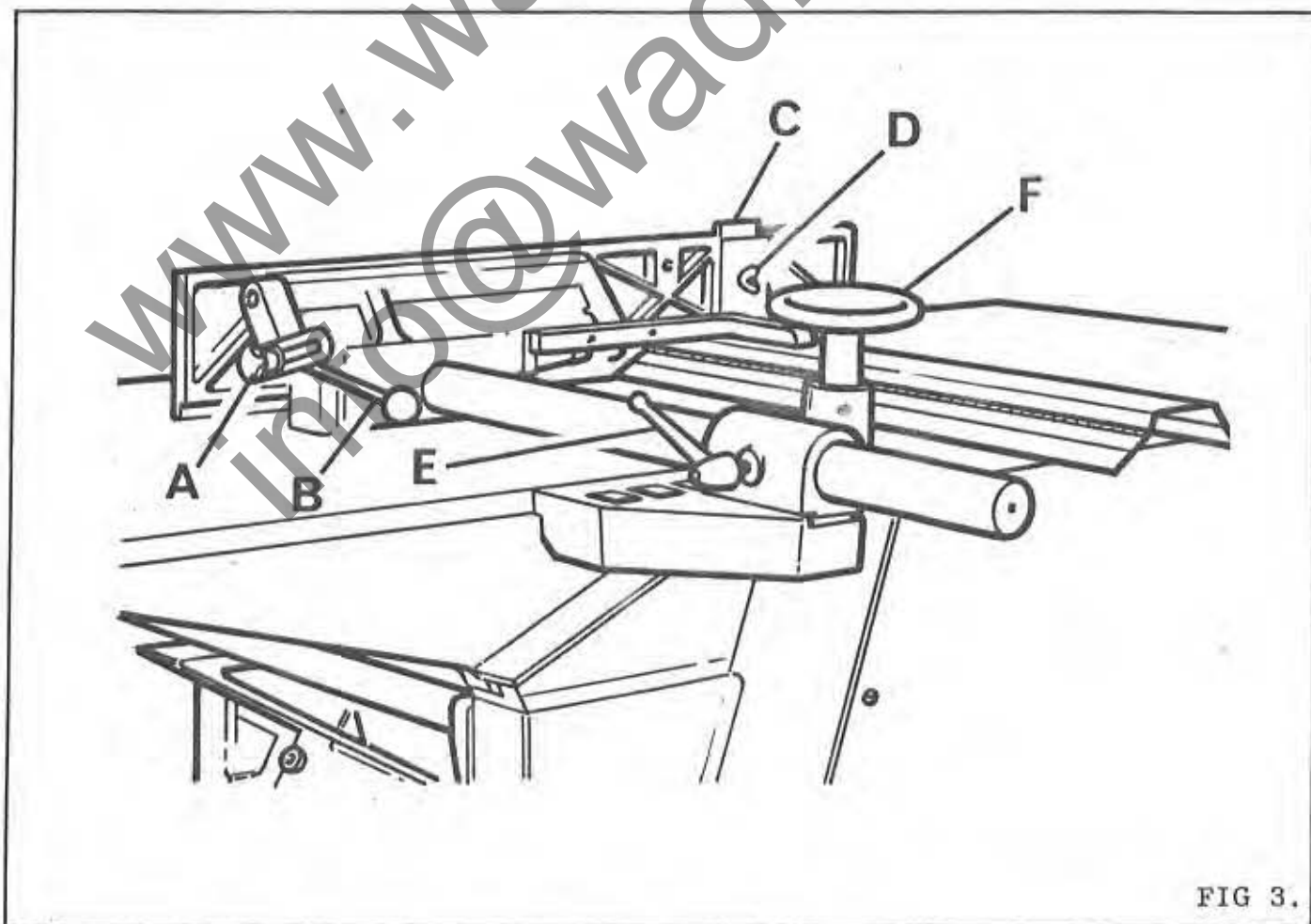


FIG 3.

TO CHECK THE FENCE, FOLLOW THE UNDERMENTIIONED PROCEDURE:-

1. Move fence towards rear of table as shown in FIG. 5.
2. Check the 90° positive stop by means of a steel square as in FIG. 5. If adjustment is necessary, loosen locknuts "A" then adjust hexagon head bolts "B" until fence is at right angles to table when hard up against the stops with the handwheel "A" in FIG. 3. locked. When set, tighten locknuts "A" in FIG. 5.
3. Check the 45° positive stop by means of an adjustable square. If adjustment is necessary, loosen locknut "C" in FIG. 5. then adjust hexagon head bolt "D" until the fence is 45° to the table when hard up against the stop and the handwheel "A" in FIG. 3. locked. When set, tighten locknut "C" in FIG. 5.

GUARDS

The front Cutterblock Guard "A" in FIG. 6 must be adjusted at all times to protect the operator from cutterblock when machine is in operation.

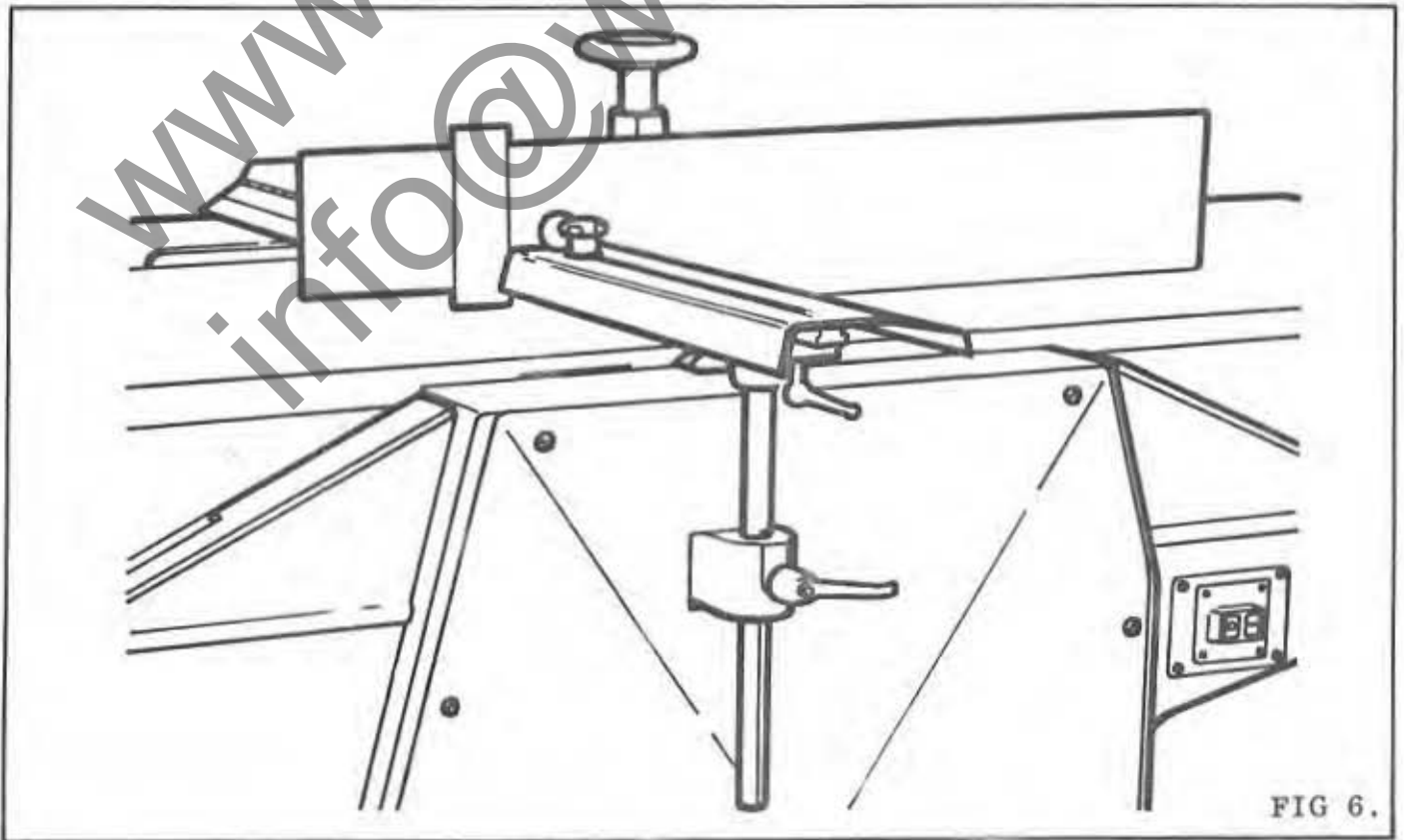
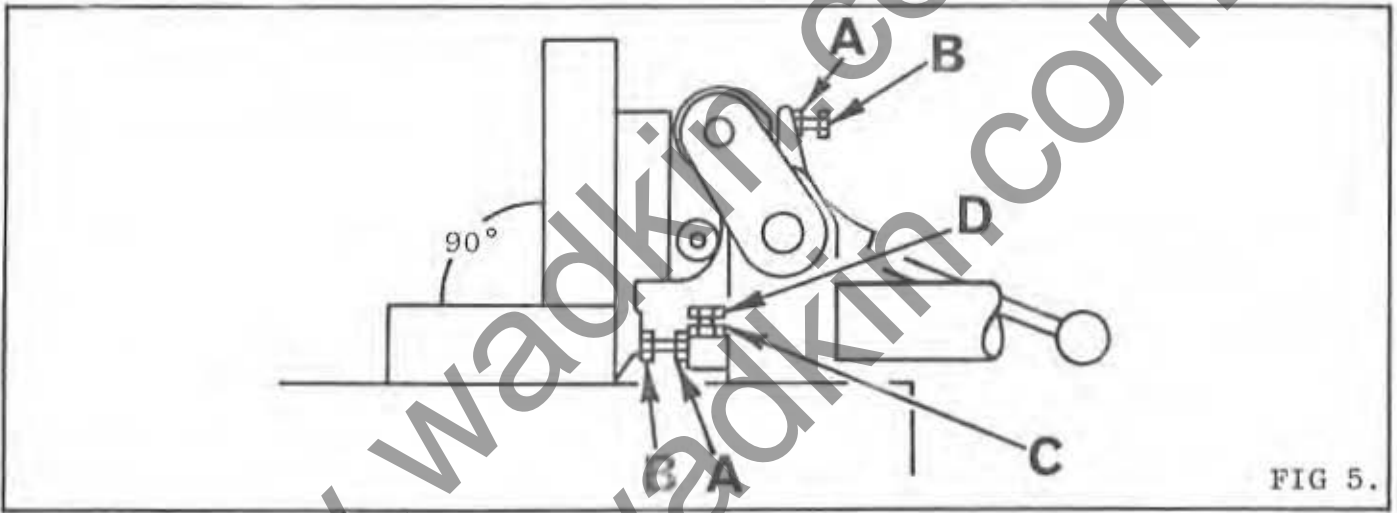
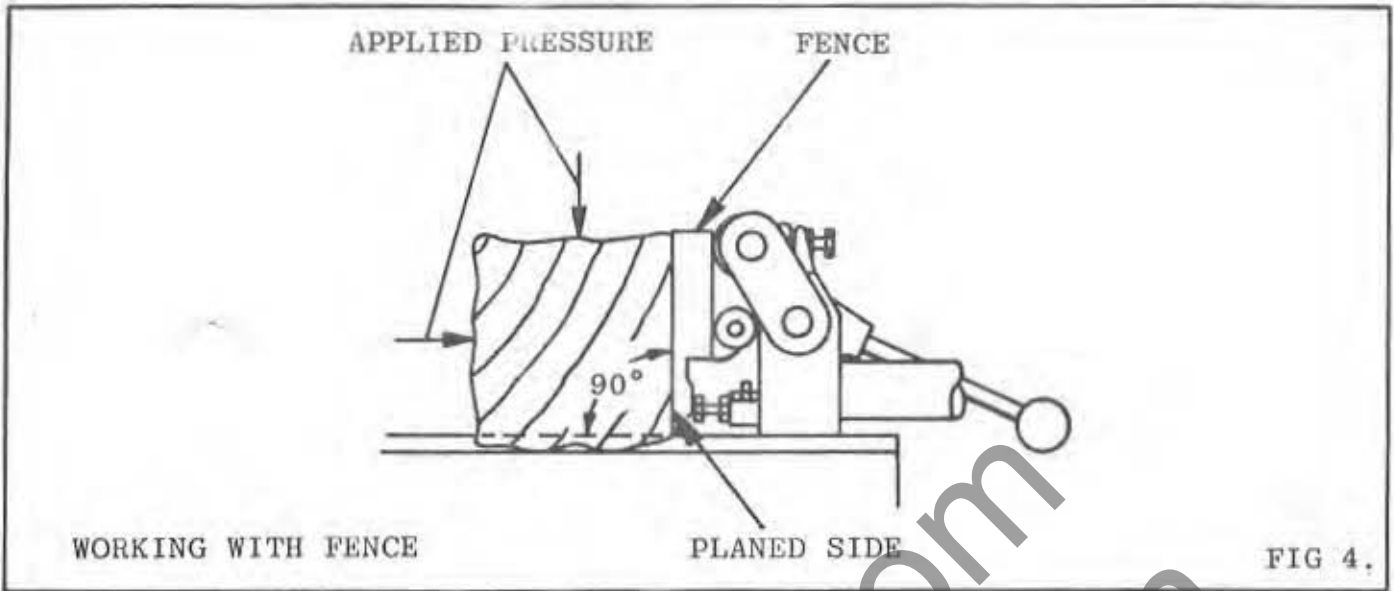
IMPORTANT: Stop machine before adjusting guards.

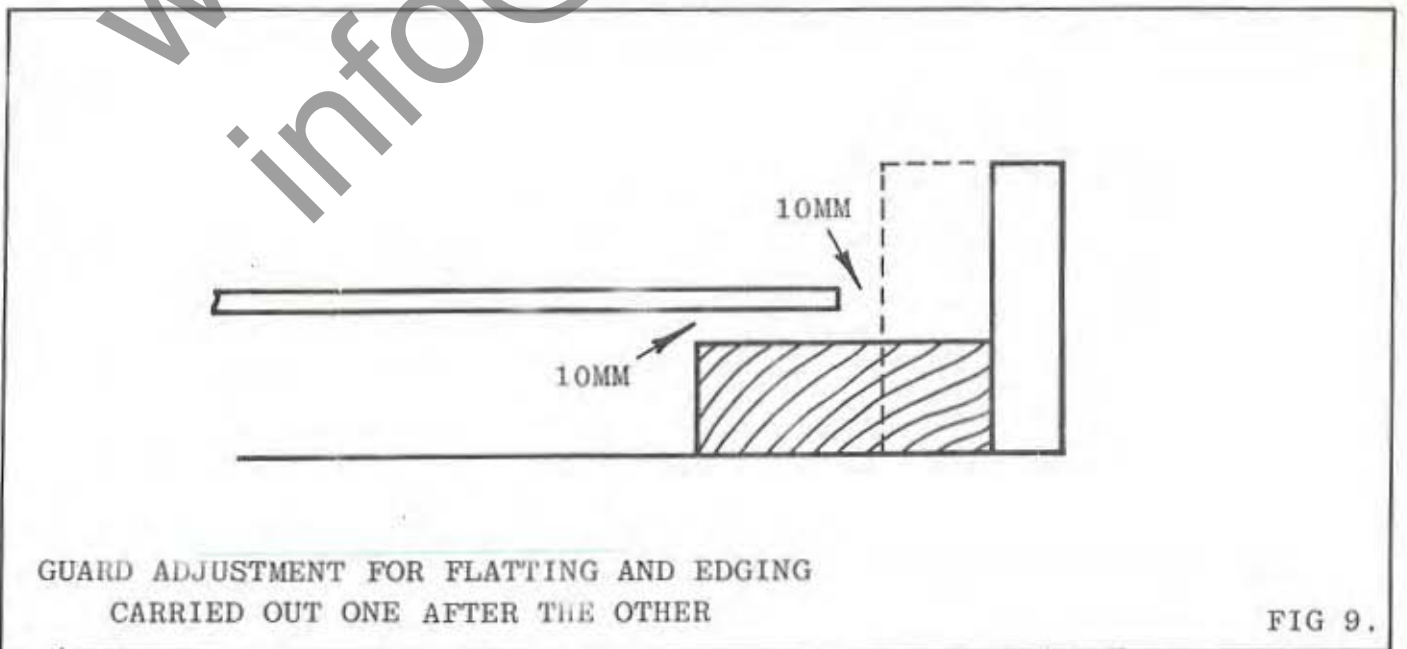
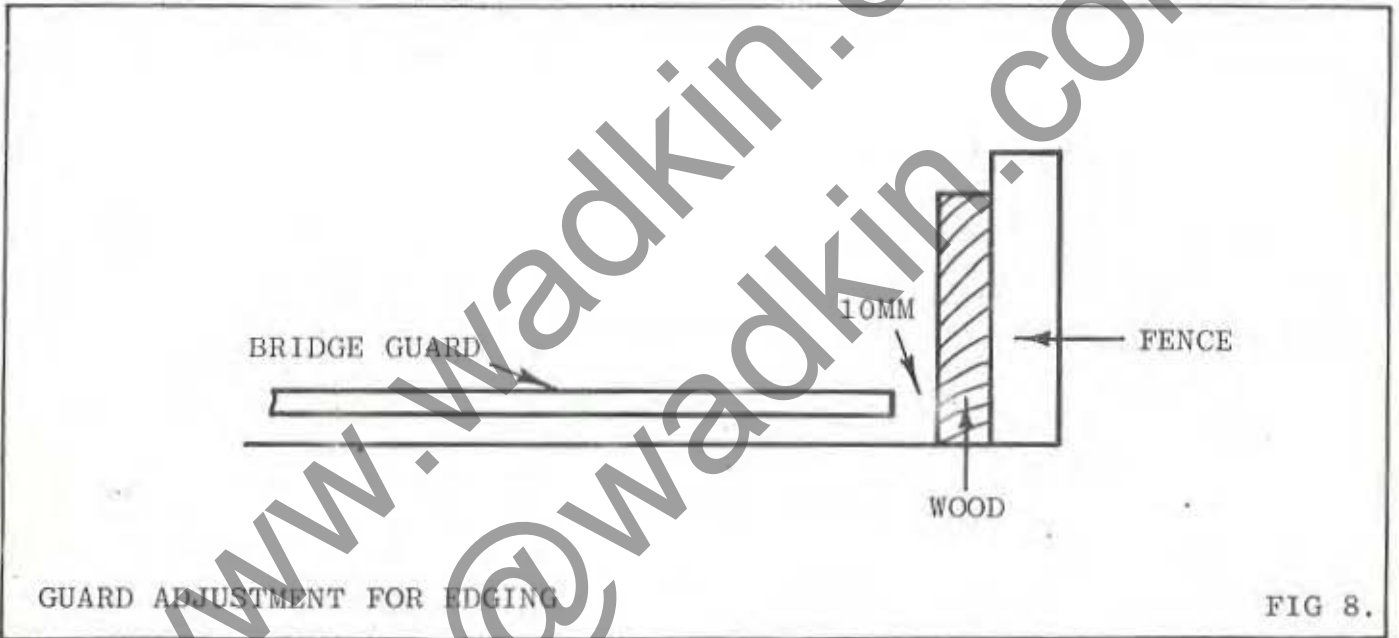
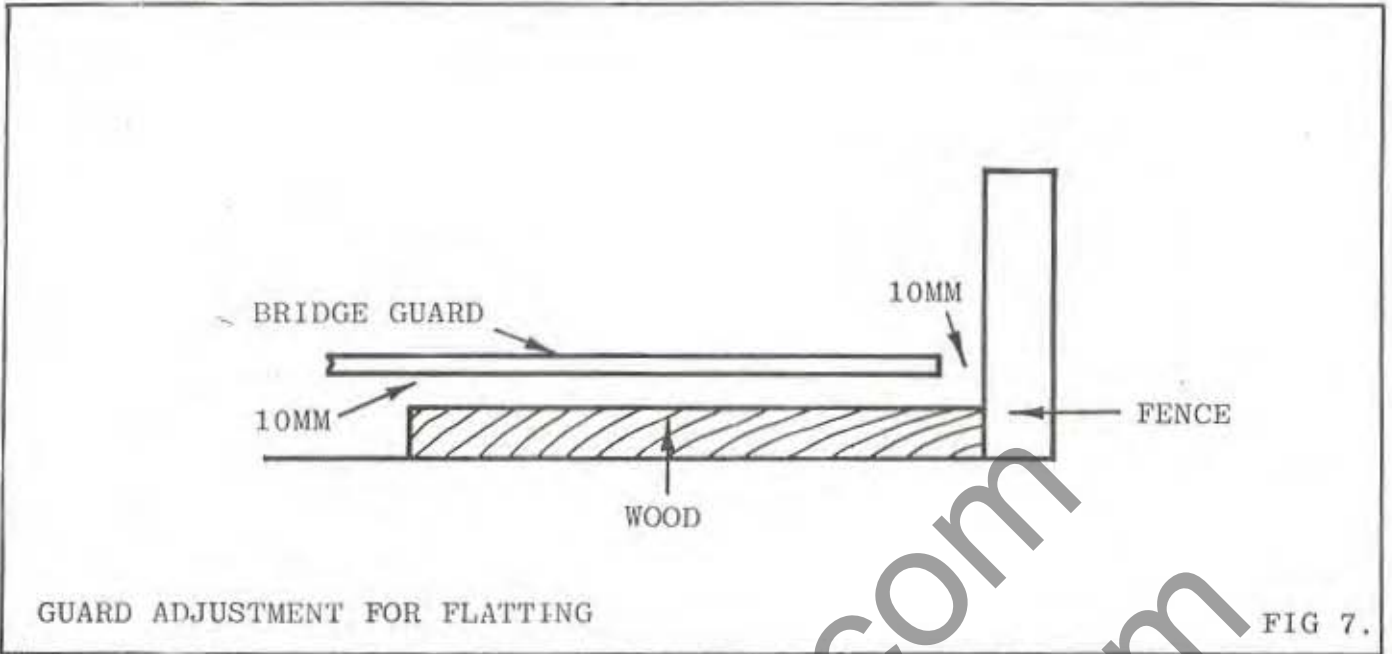
For correct cutterblock guard positions see FIG. 7, FIG. 8 and FIG. 9.

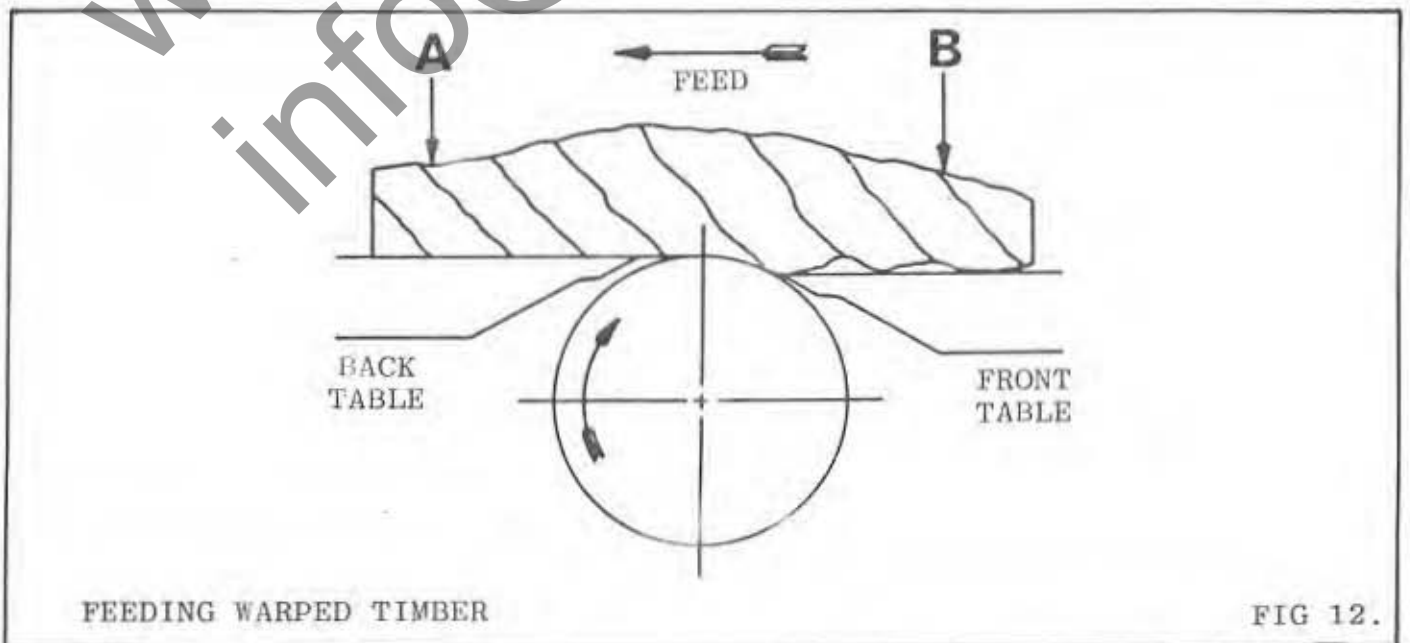
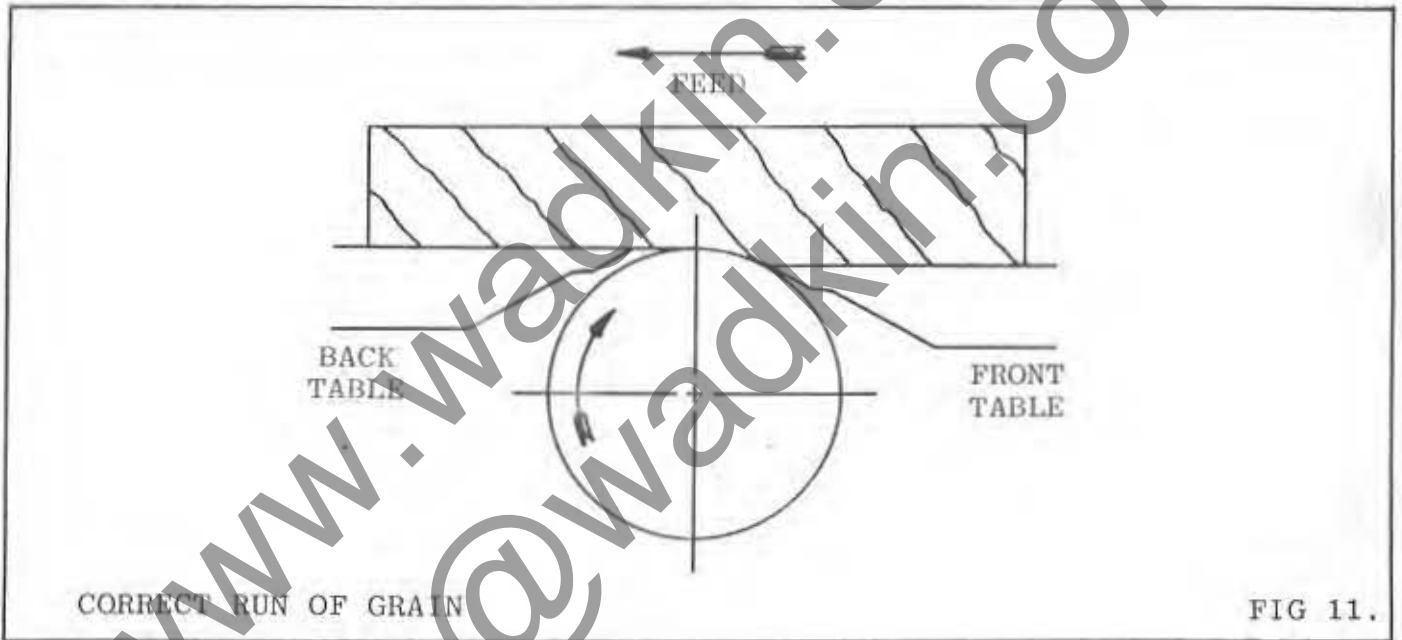
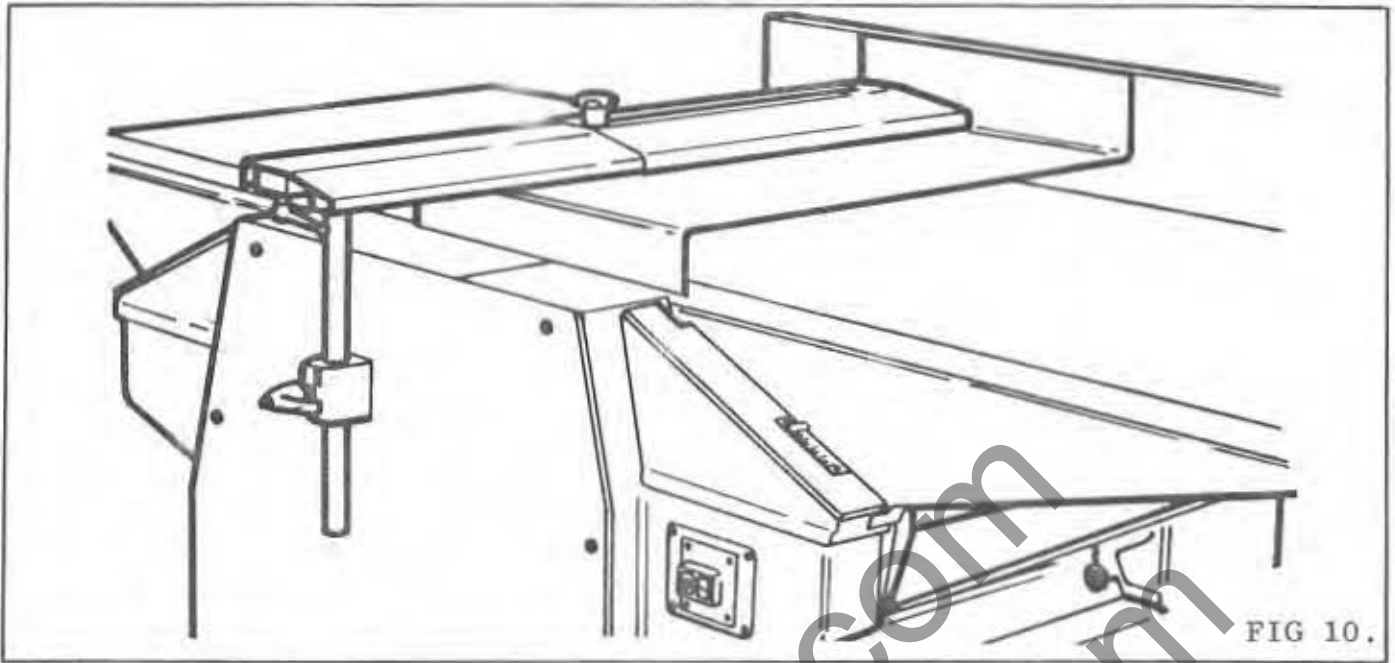
When the machine is to be used for thickening, the Tunnel Guard supplied with machine should be fitted to front cutterblock guard as shown in FIG. 10.

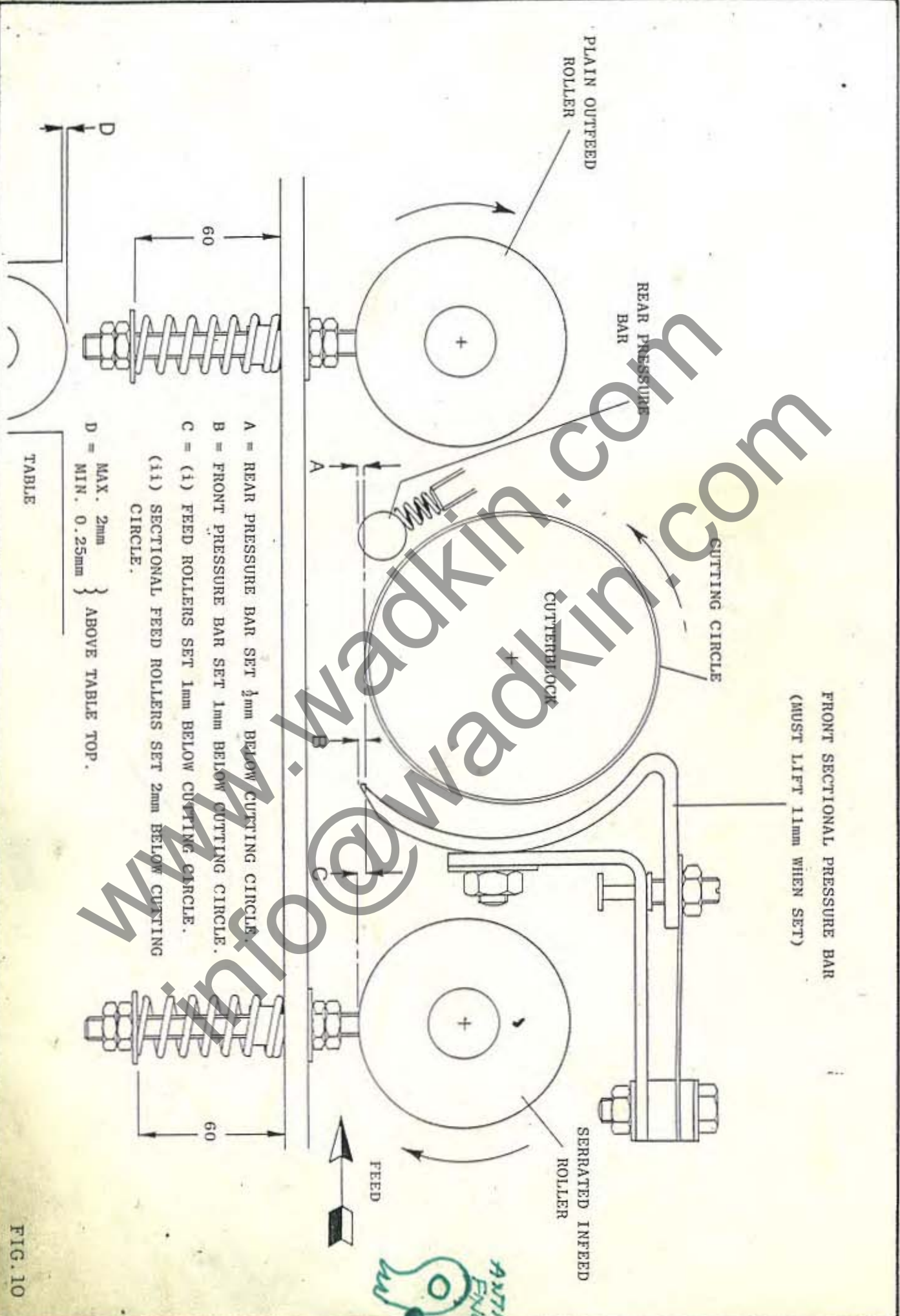
GENERAL HINTS FOR SURFACE PLANING

1. To obtain the best surface finish always ensure that the direction of grain runs with the cutterblock as in FIG. 11.
2. To obtain a perfectly flat surface, especially with warped stock always put maximum pressure on the back table at "A" in FIG. 12 and as little as possible on the front table at "B".
3. Greater pressure will be required when surfacing bad grained timber otherwise chattering will take place resulting in a coarse finish near each knot.
4. When square planing four sides of timber, turn timber anti-clockwise after each cut to ensure a machined face is always against the fence as in FIG. 4.









FRONT SECTIONAL PRESSURE BAR
(MUST LIFT 11mm WHEN SET)

- A = REAR PRESSURE BAR SET 2mm BELOW CUTTING CIRCLE.
- B = FRONT PRESSURE BAR SET 1mm BELOW CUTTING CIRCLE.
- C = (1) FEED ROLLERS SET 1mm BELOW CUTTING CIRCLE.
(11) SECTIONAL FEED ROLLERS SET 2mm BELOW CUTTING CIRCLE.

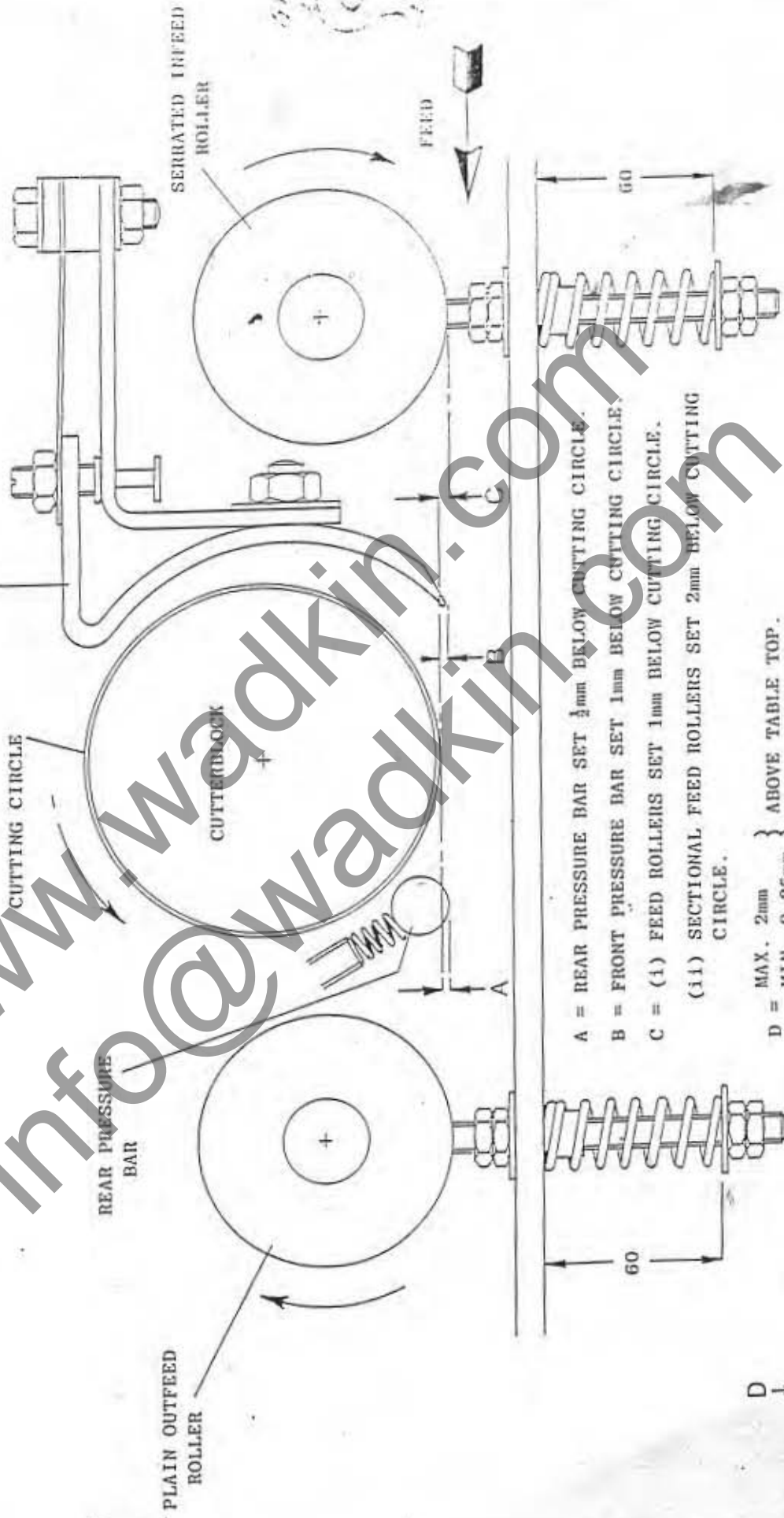
D = MAX. 2mm
MIN. 0.25mm } ABOVE TABLE TOP.

TABLE

FIG. 10

ANTI KEK
ENGINERS

FRONT SECTIONAL PRESSURE BAR
(MUST LIFT 11mm WHEN SET)



- A = REAR PRESSURE BAR SET 1mm BELOW CUTTING CIRCLE.
- B = FRONT PRESSURE BAR SET 1mm BELOW CUTTING CIRCLE.
- C = (1) FEED ROLLERS SET 1mm BELOW CUTTING CIRCLE.
(11) SECTIONAL FEED ROLLERS SET 2mm BELOW CUTTING CIRCLE.

D = MAX. 2mm } ABOVE TABLE TOP.
MIN. 0.25mm }

TABLE

FIG. 10

15 x 40 x 14
Thick

