

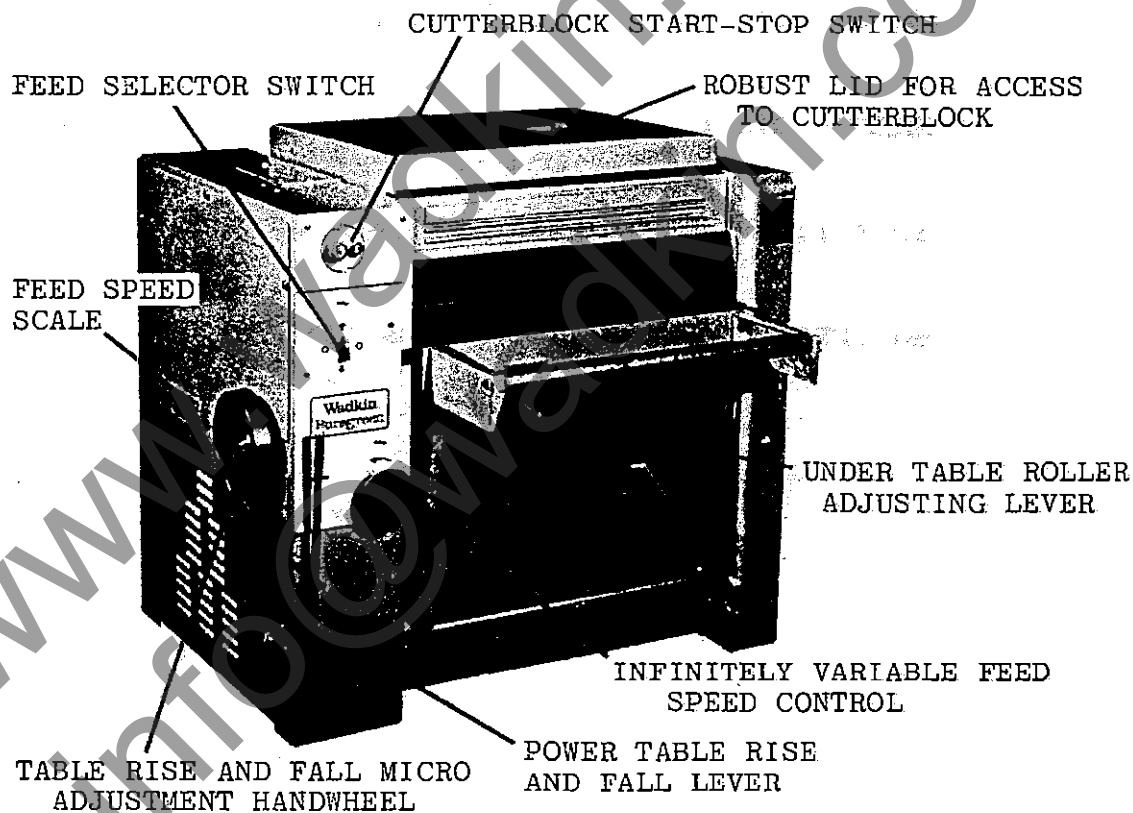
Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

PLEASE INSERT SERIAL NUMBER OF MACHINE

INSTRUCTION MANUAL FOR

BT 630

Planer and Thicknesser



For Replacement Parts, Tools & Accessories,
Contact:—

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SECTION A

PRINCIPAL DIMENSIONS & CAPACITIES

Capacity of machine-----	630 x 230	25" x 9"
Feed of machine -----	6-18 metres/min	20-60ft/min
H. P. of feed motor -----	.75kw	1HP
H. P. of cutterblock motor -----	5.5kw	7.5HP
Speed of cutterblock -----	4,200rpm	4,200rpm
Speed of motor : 50 cycle -----	3,000rpm(syn)	3,000rpm(syn)
: 60 cycle -----	3,600rpm(syn)	3,600rpm(syn)
Dia. of cutting circle -----	115	4½"
Dia. of feed rollers -----	75	3"
Yield of complete infeed rollers -----	10	3/8"
Minimum stock length -----	292	11½"
Maximum stock removal -----	10	3/8"
Length of table -----	765	30"
Floor space -----	1200 x 1070	47½" x 37"
Nett weight approx -----	710 kg	1560 lb
Gross weight approx -----	910 kg ₃	2010 lb ₃
Shipping dimensions -----	160 m ³	56.5 ft ³

1-SKF 6202-2RS -----	Feed Motor traverse screw
2-SKF 51105 -----	Rise and fall cross shaft
2-SKF 51104 -----	Rise and fall screw
4-SKF 6203-2RS -----	Under table rollers
2-SKF 6207-2RS -----	Cutterblock
2-RHP XLT 18 -----	Rise and fall screw
1-INA AXK 2542 -----	Clutch thrust bearing
2-INA AS 2542 -----	Clutch bearing pressure plates

For BTS Slings, See
Supplementary Instruction Booklet

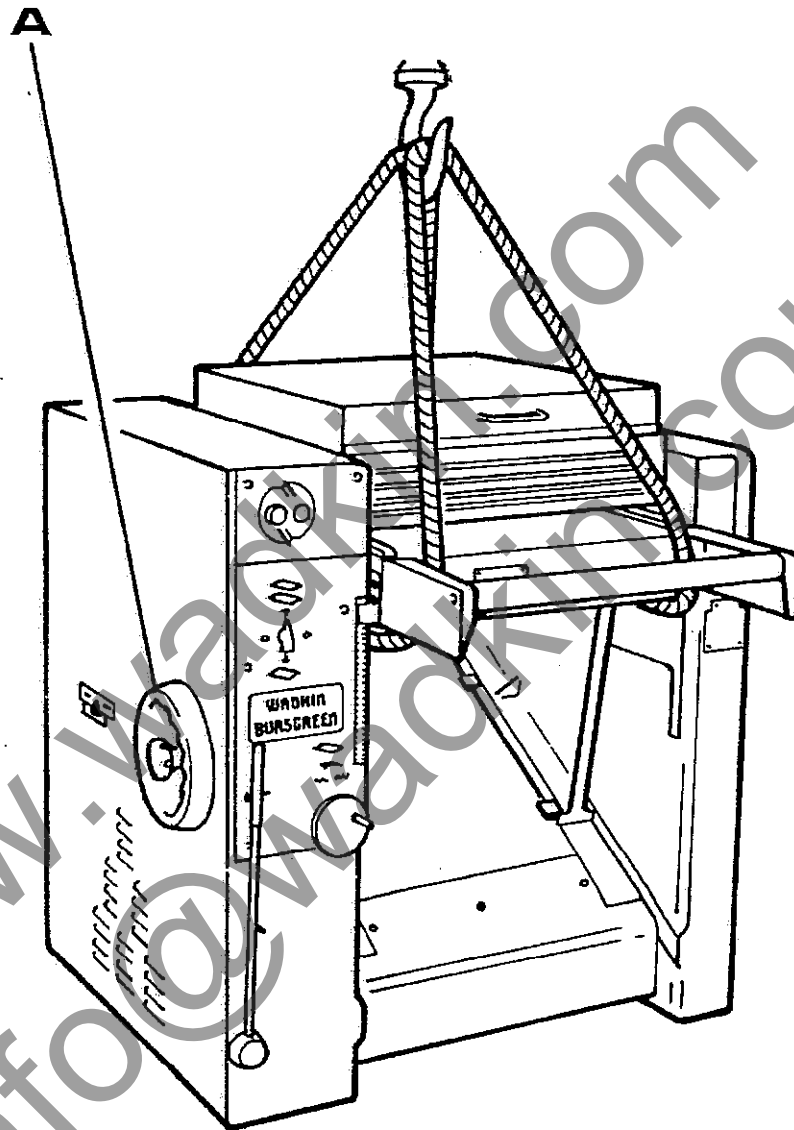


Fig B1

IMPORTANT

**ENSURE DAMAGE WILL NOT BE CAUSED
TO MACHINE DURING SLINGING OPERATION**

SECTION "B" INSTALLATION

SLINGING

FIG. B1.

1. Manually rise the table by handwheel "A" until the table reaches the stops in its uppermost position. Place sling under table as shown in FIG. B1 ensuring damage will not be caused to the machine during slinging.
2. Move machine to required position.

CLEANING

Clean protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

MARKING OUT

FIG. B2.

1. Mark out floor and drill to suit 4 foundation bolts. These bolts can be supplied at an additional extra charge.
2. Level table by adjusting the 4 - Simplex adjusting screws situated in bottom corners of machine side frames.

WIRING DETAILS

FIG. B3.

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the isolating switch. Points to note when connecting to power supply:

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3. Check the main line fuses are of the correct capacity. See list below.
4. Connect the line leads to the appropriate terminals.
5. Check all connections are sound.
6. Check the rotation of both motors for the correct direction. If these are incorrect reverse any two of the line lead connections.

For Automatic Star Delta Starter wiring diagram see page 8 or for Star Delta Switch wiring diagram see page 9.

Voltage	H.P.		Phase	Cycles	SWG Tinned Copper Wire	
	Block -	Feed			Amps	- SWG
380/420	7½	1	3	50	55	17
380	7½	1	3	50	38	19
208/220	7½	1	3	60	65	17
550	7½	1	3	60	24	22
220	7½	1	3	50	65	17
440	7½	1	3	60	29	21

Fuse capacity should not exceed three times full load current of the machine.
NOTE: DUST EXHAUST Information is available on request.

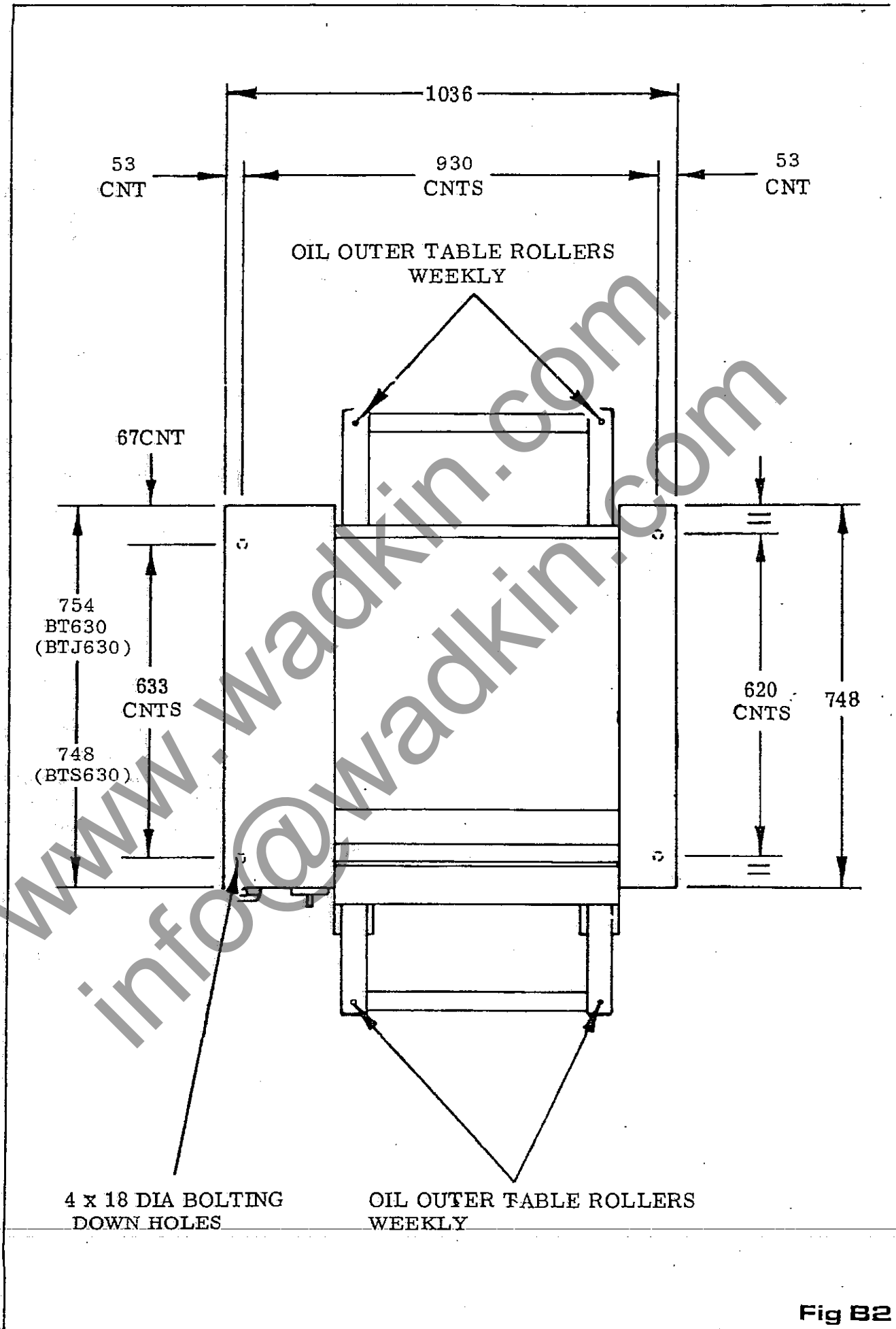


Fig B2

MEM AUTO LINE - DIRECT ON LINE STARTER STANDARD WIRING DIAGRAM

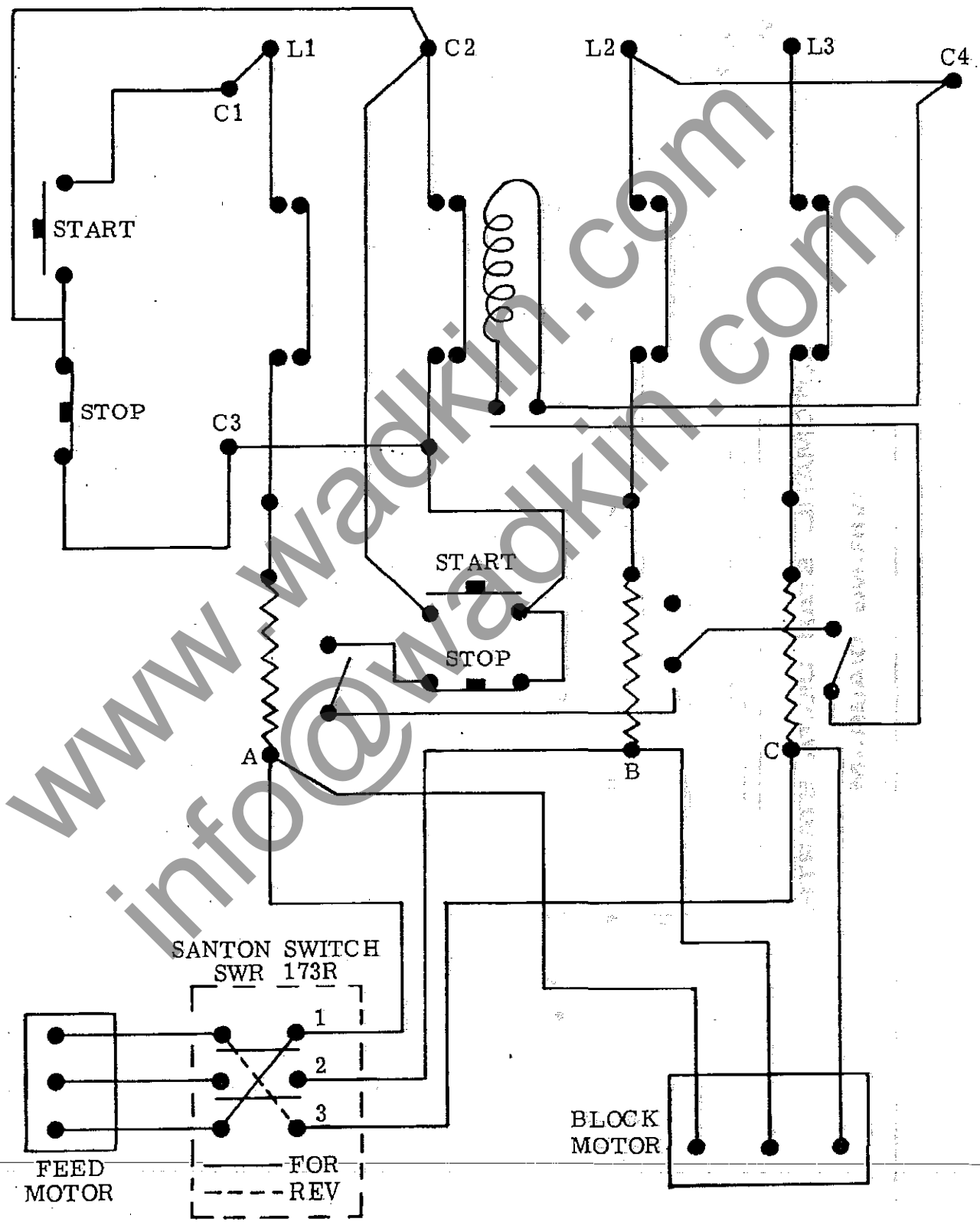
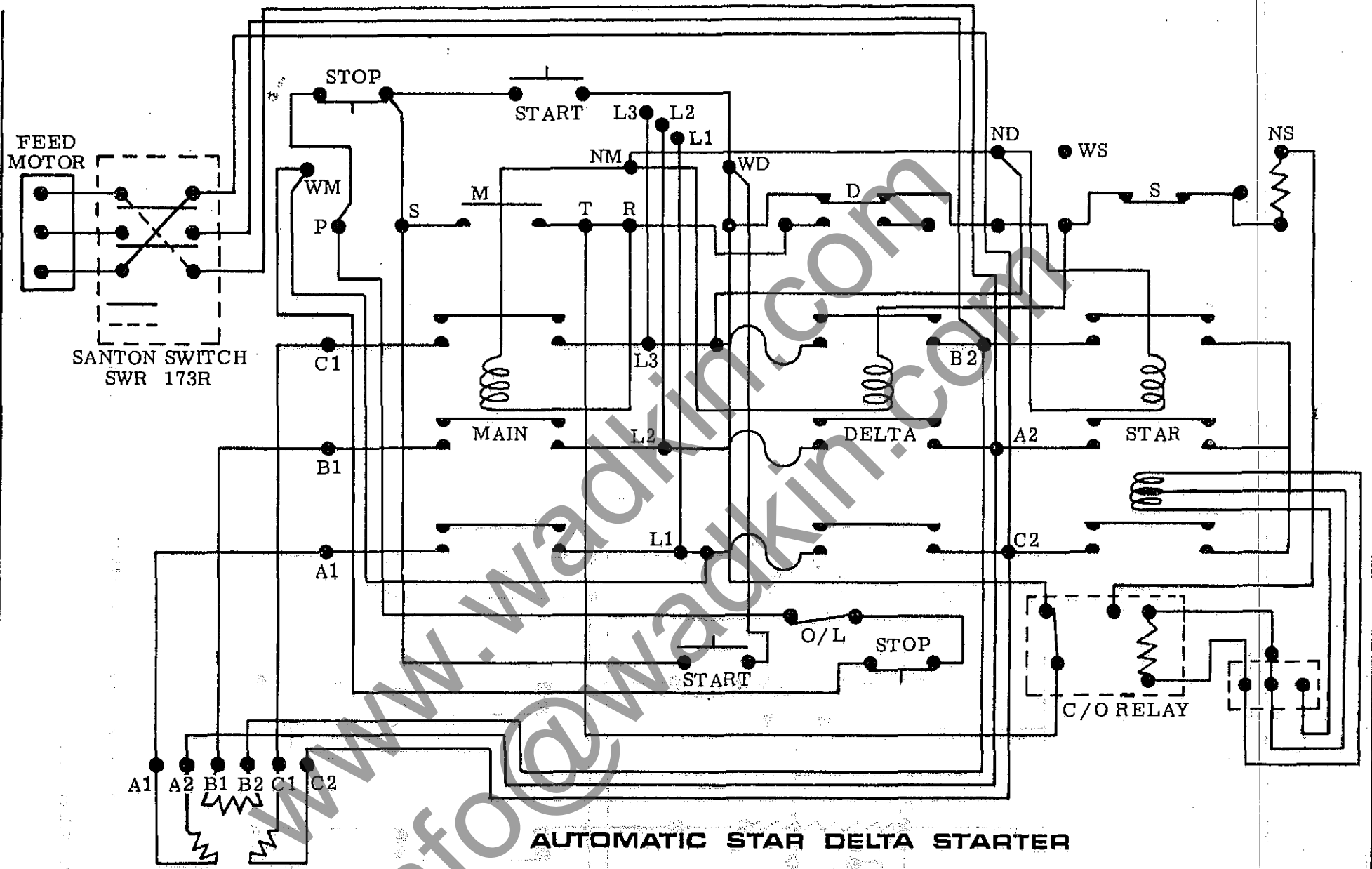
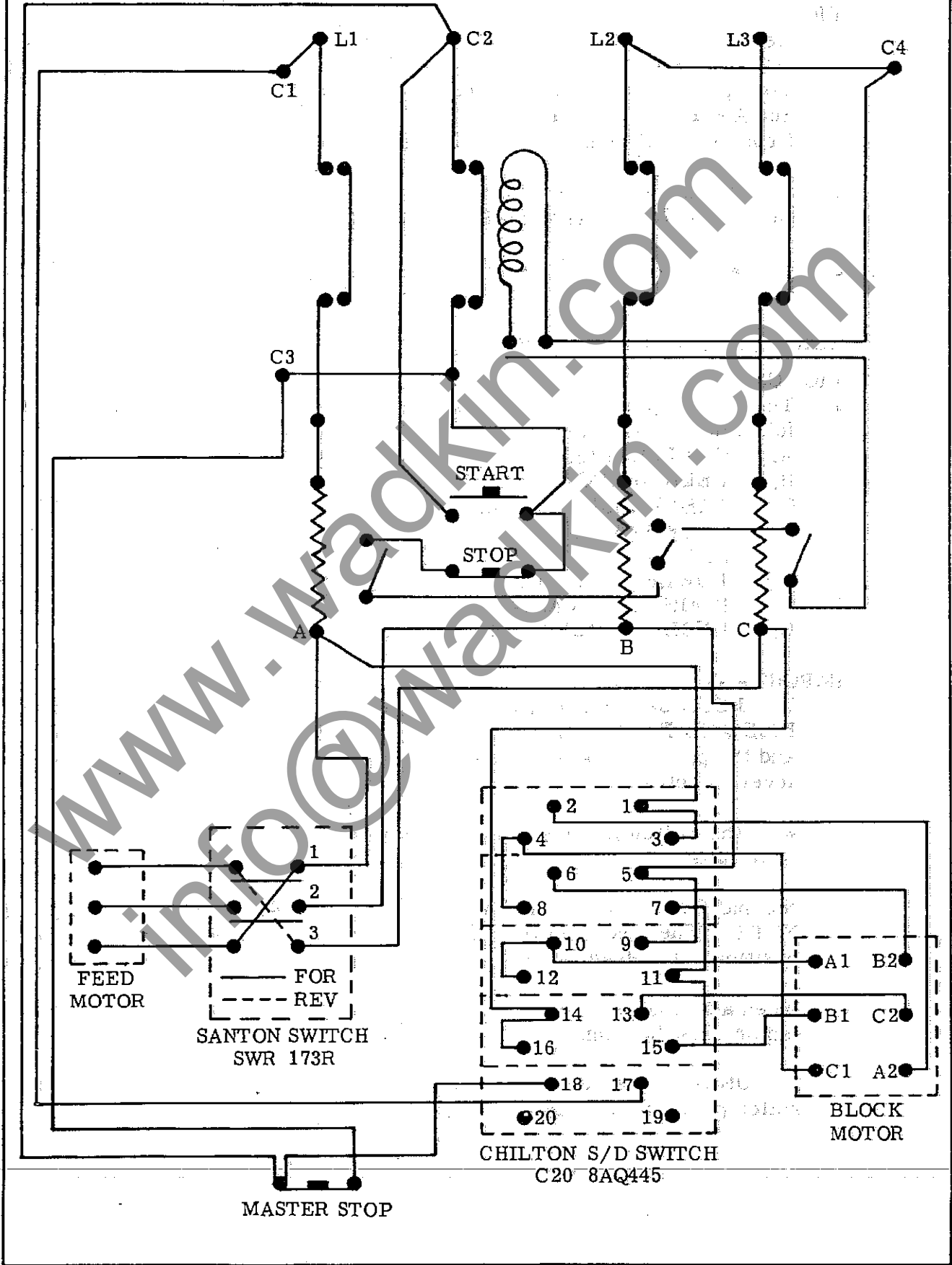


Fig B3



**AUTOMATIC STAR DELTA STARTER
WIRING DIAGRAM**

STAR DELTA SWITCH (SPECIAL)



SECTION "C" DESCRIPTION AND OPERATION

PREPARATION FOR OPERATION

FIG. C1.

1. Remove filler plug "A" from top of reduction gearbox "B" and oil level plug "C" from side of gearbox. Check that the oil is up to the oil level hole "C". Top up if necessary using correct grade of oil. See APPROVED LUBRICANTS, page 12. Replace oil filler plug "A" and oil level plug "C".
2. FIG. C2 and C3. Lubricate machine according to lubrication operations No's. 1 to 7. See APPROVED LUBRICANTS, page 12.
3. It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

CONTROLS AND OPERATION

FIG. C3.

1. The control panel is situated on the front left side of the machine with the following controls incorporated in a grouped layout:-
 - A. CUTTERBLOCK START-STOP SWITCH.
 - B. FEED SELECTOR SWITCH.
 - C. TABLE RISE AND FALL MICRO ADJUSTMENT HANDWHEEL.
 - D. LOCK FOR TABLE RISE AND FALL MICRO ADJUSTMENT HANDWHEEL.
 - E. POWER TABLE RISE AND FALL LEVER.
 - F. INFINITELY VARIABLE FEED SPEED CONTROL.
 - G. UNDER TABLE ROLLER ADJUSTING LEVER.

IMPORTANT NOTES:-

The FEED SELECTOR SWITCH works in conjunction with the POWER TABLE RISE AND FALL LEVER. When the switch is pointing in the upward position and the power table lever operated, the table will rise until the power table lever is released.

With the switch in the downward position the procedure is the same only the table falls.

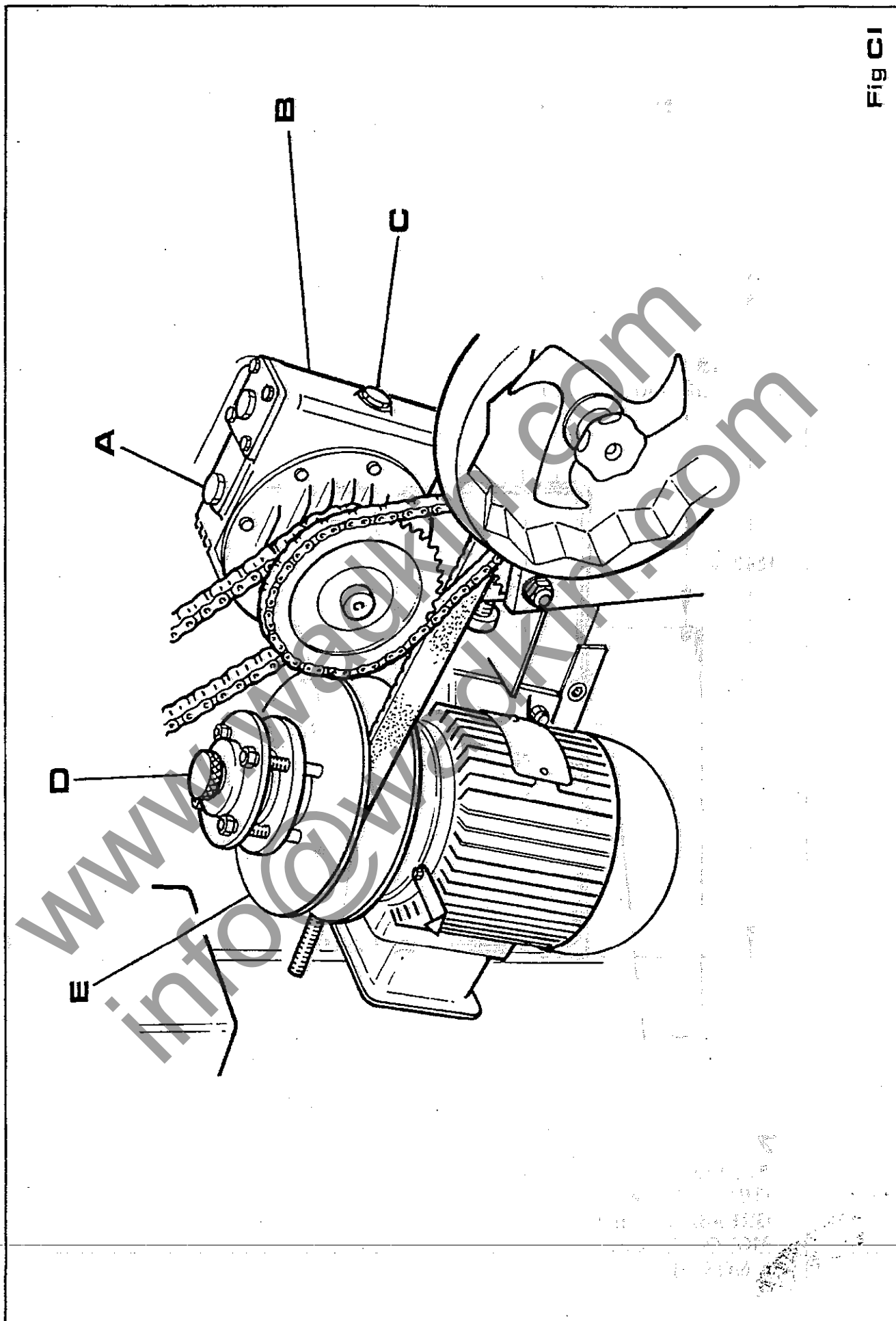
Normal feeding is attained with the feed selector switch in the up position.

NOTE : The feed is reversed when the feed selector switch is in the down position. The feed is OFF when the switch is in the horizontal position.

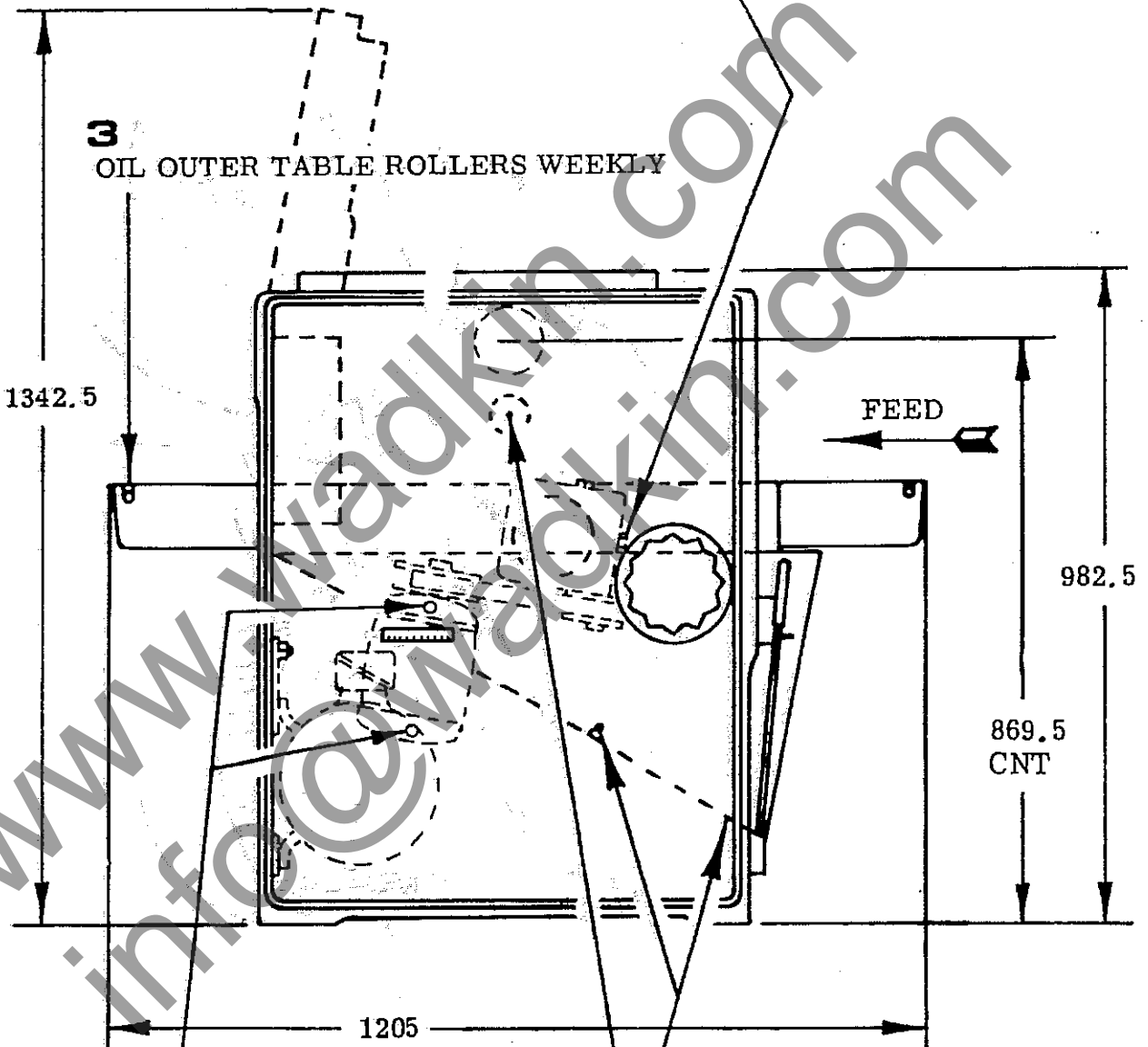
When altering the INFINITELY VARIABLE FEED SPEED CONTROL, the feed motor must be running.

The UNDER TABLE ROLLER ADJUSTING LEVER readily selects the correct roller position for maximum traction.

Fig 01



TYPE FV HOLROYD REDUCTION BOX
 (20.5 :1 REDUCTION). USE CASTROL ALPHA 617 (OR EQUIVALENT)
5 CHECK OIL IN REDUCTION BOX MONTHLY



3 OIL OUTER TABLE ROLLERS WEEKLY

1 GREASE RISE/FALL
GEARS AND NUTS
WEEKLY

2 GREASE JOCKEY SPROCKET
WEEKLY

7
 FEED MOTOR - BROOKS D80a
 (1HP - .75KW) 1,500 RPM
 GREASE BOTH ENDS OF
 MOTOR 2 TURNS EVERY
 6 MONTHS

Fig C2

NOTE: WITH MACHINE RUNNING, TURN VARIABLE FEED SPEED HANDWHEEL "F" THROUGH COMPLETE SPEED RANGE ONCE DAILY TO ENSURE PULLEY IS FULLY LUBRICATED.

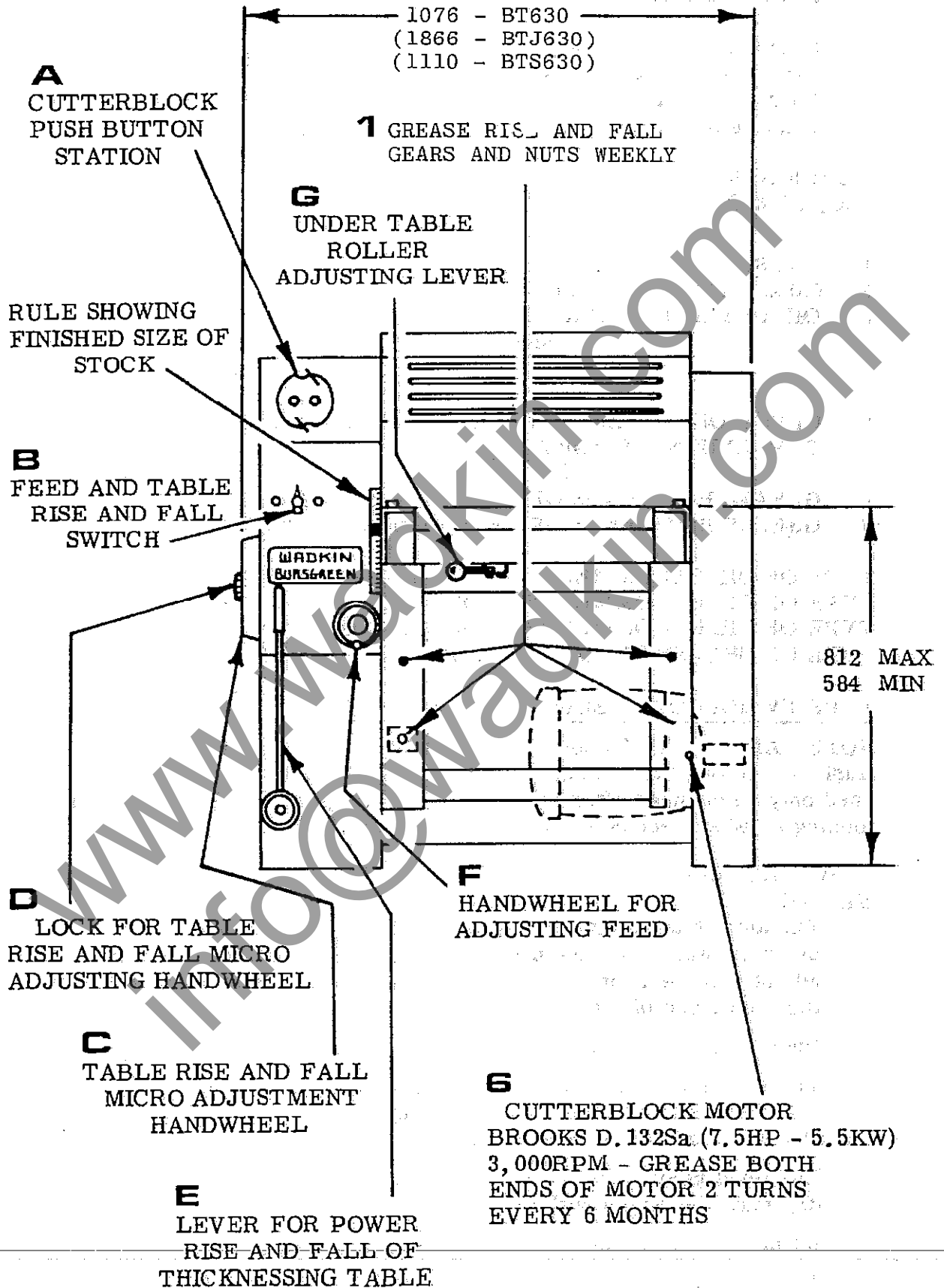


Fig C3

SECTION "D" MAINTENANCE

All adjustments and alignments following have been carefully set and checked and the complete machine thoroughly tested before despatch from the works.

During the first few weeks of operation and at regular intervals afterwards certain items such as belt tension and chain tension should be checked carefully. When adjustments are necessary, proceed in accordance with the relative instructions given.

LUBRICATION FIG. C2 & C3.

WEEKLY

1. GREASE RISE/FALL GEARS AND NUTS
2. GREASE JOCKEY SPROCKET
3. OIL OUTER TABLE ROLLERS.

MONTHLY

5. CHECK OIL IN REDUCTION GEARBOX IS UP TO OIL LEVEL HOLE. TOP UP IF NECESSARY.

6 MONTHLY

6. GREASE BOTH ENDS OF CUTTERBLOCK MOTOR:- 2 TURNS.
7. GREASE BOTH ENDS OF FEED MOTOR:- 2 TURNS.

TYPE OF OIL RECOMMENDED FOR GENERAL USE:- CASTROL MAGNA ED
 TYPE OF OIL RECOMMENDED FOR REDUCTION GEARBOX } CASTROL ALPHA
 TYPE OF OIL RECOMMENDED FOR VARIABLE PULLEY } 617 (OR EQUIV').
 TYPE OF GREASE RECOMMENDED:- CASTROL SPHEEROL AP3.

TYPE FV HOLROYD REDUCTION BOX

NOTE: After about 200 hours running with a new gear it is desirable to drain and flush out the original charge of oil and refill with clean oil, after which the oil need only be changed after long intervals. Regular inspection of oil level and topping up when necessary is however important.

TABLE ROLLERS FIG. D1.

The anti-friction table rollers or bed rollers revolve on sealed for life bearings which require no lubrication. These rollers are automatically adjusted in relation to the table surface by a single operating lever "A" at the infeed end of the table.

Under table roller height depends on the stock being machined.

The extremes of height being for narrow wet and soft material which allow the rollers to sink into the material considerably and still allow the bottom of the stock to ride on the table surface.

The level position of the rollers caters for the opposite extremes of wide hard dry material which will not permit the rollers to sink into it.

Infinite variation therefore permits correct setting for all classes of timber.

The general rule for setting being that the bottom rollers should be high enough to relieve the friction between table and stock WITHOUT the material losing contact with the table surface.

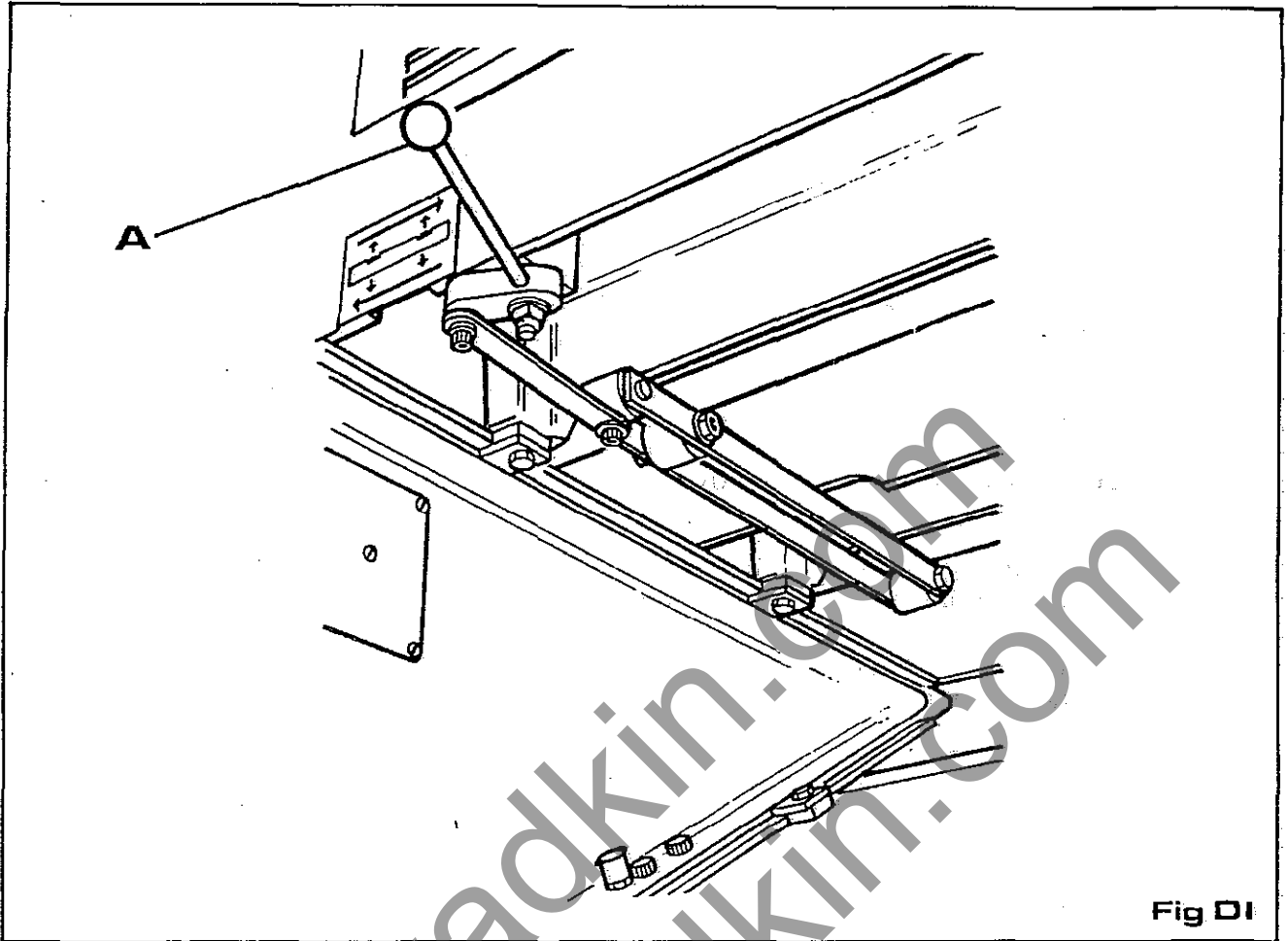
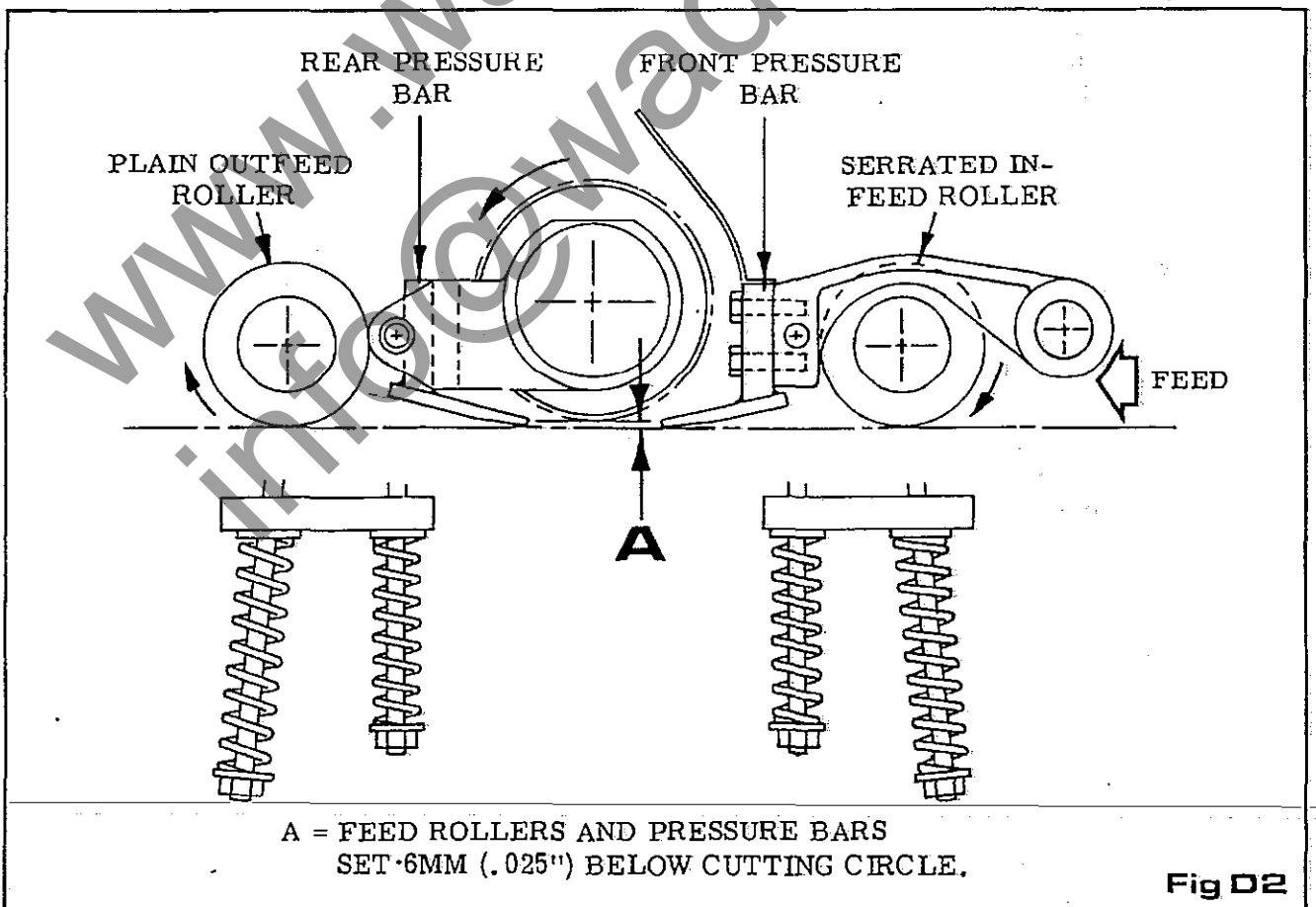


Fig D1



A = FEED ROLLERS AND PRESSURE BARS
SET .6MM (.025") BELOW CUTTING CIRCLE.

Fig D2

In all cases the lowest position consistent with good and regular feeding should be used as this will give the best possible results. Should the table rollers be removed for any reason, care must be taken to replace them exactly as before otherwise the setting will be disturbed.

It must be emphasised that a really good surface finish from a thickening machine is only possible when the face of the timber resting on the machine table is flat and has a reasonable finish. Wherever practicable this face should be pre-machined on a overhand jointer, or surfacer to remove twist and other irregularities.

FEED ROLLER AND PRESSURE BAR SETTINGS

FIG. D2.

These are pre-set at the works and vertical adjustment relative to the cutter-block is neither possible nor necessary provided the cutters are correctly set with the special setting guage supplied with each machine. Should replacement feed rollers or pressure bars be fitted at any time, the settings should be very carefully checked with FIG. D2.

Some slight advantage in finish or feeding may on occasions be obtained by increasing or decreasing the tension of the pressure bar or feed roller springs.

NOTE: The springs should never be compressed to a point where the feed rollers and pressure bars cannot lift sufficient to allow the maximum cut to be taken.

BELT TENSION

FIG. D3.

The cutterblock drive is by three Vee belts from a $7\frac{1}{2}$ HP motor. Tension is effected to these belts by adjusting motor. To adjust, loosen four aerotight nuts "A" then proceed to turn hexagon head nut "B" until required tension is reached then relock nuts "A".

FEED CHAIN TENSION

FIG. D4.

The drive to feed rollers is by roller chain from a worm reduction gearbox which is in turn driven by a variable pulley from a 1HP motor, giving variable feed speeds of 6 - 18 METRES/MIN (20 - 60 FT/MIN).

To adjust chain tension on top feed roller chain, proceed as follows:-
Loosen two aerotight nuts "A" and hexagon head locknut "B". Adjust square head screw "C" until required tension is reached, i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned relock aerotight nuts "A" and locknut "B".

TABLE RISE AND FALL CHAIN TENSION

FIG. D5 & FIG. D6.

Tension adjustment to the manual table rise and fall chain is as follows:-
Power rise table to uppermost position. Turn handwheel "A" in FIG. D5 until the hole in the handwheel boss lines with the hole in the handwheel shaft, then locate 6mm DIA toggle bar into handwheel shaft. Loosen aerotight nut "A" in FIG. D6 then move toggle bar until required chain tension is reached i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned hold toggle bar in position and re-tighten aerotight nut "A", then remove toggle bar.

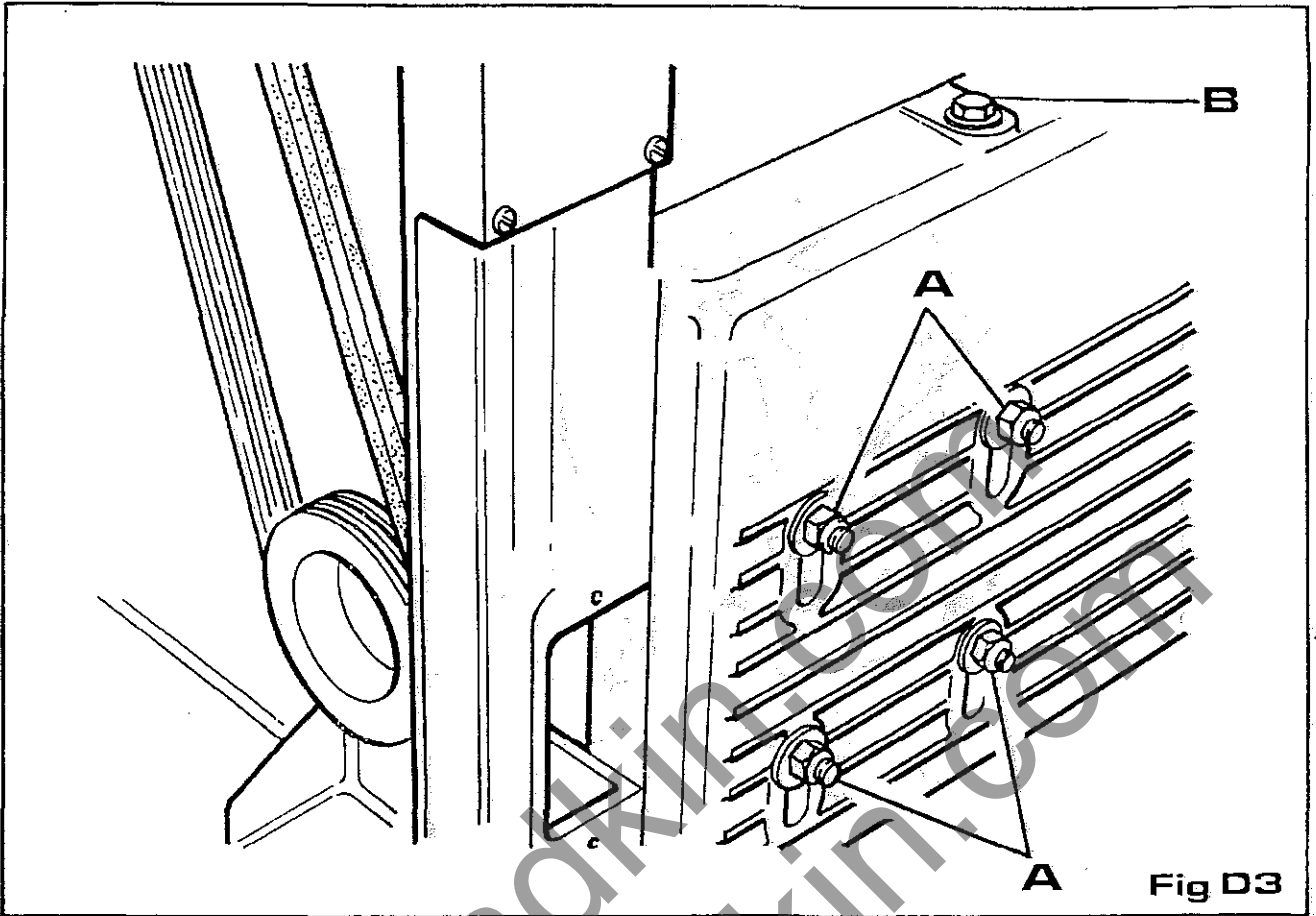


Fig D3

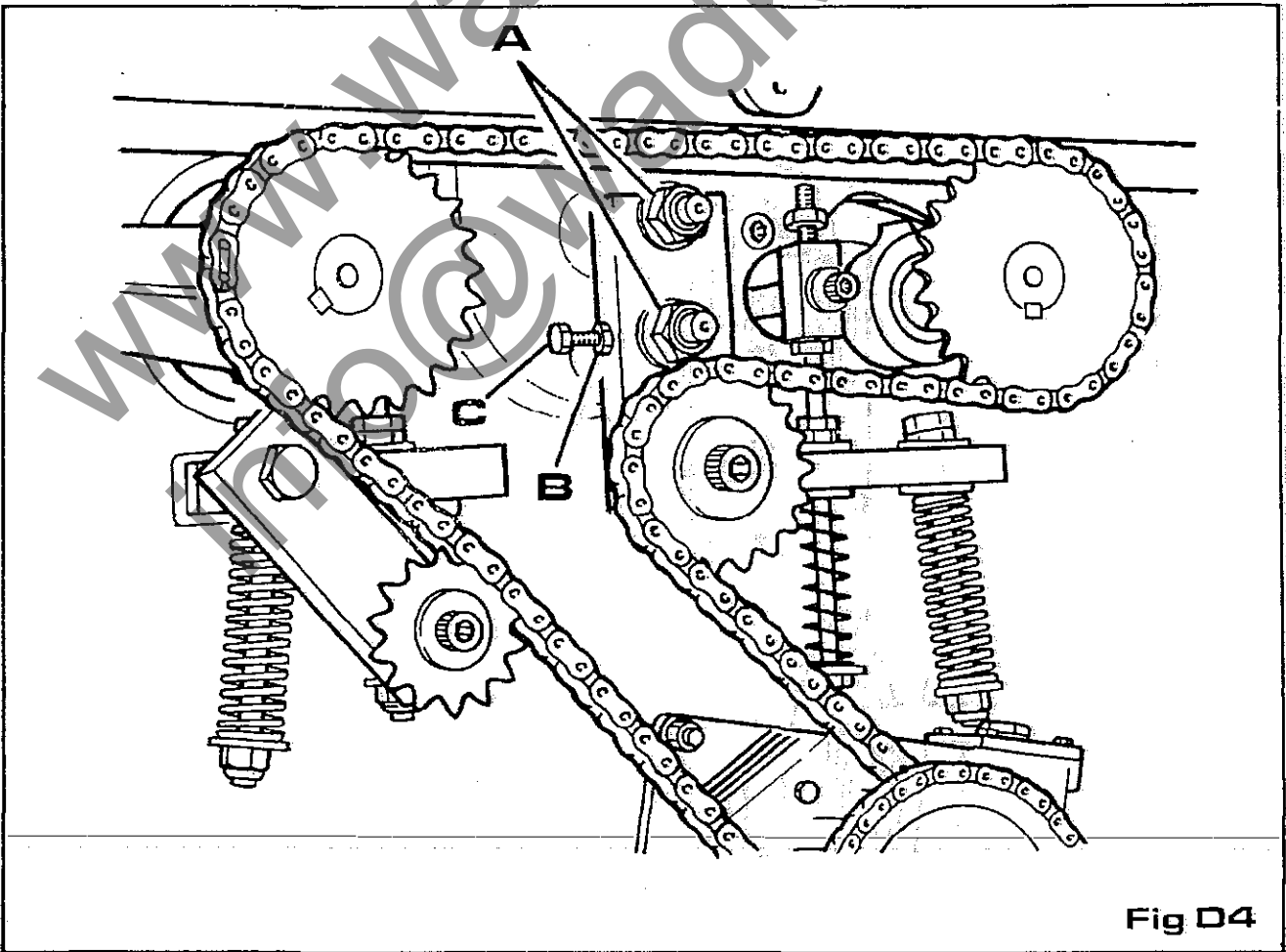
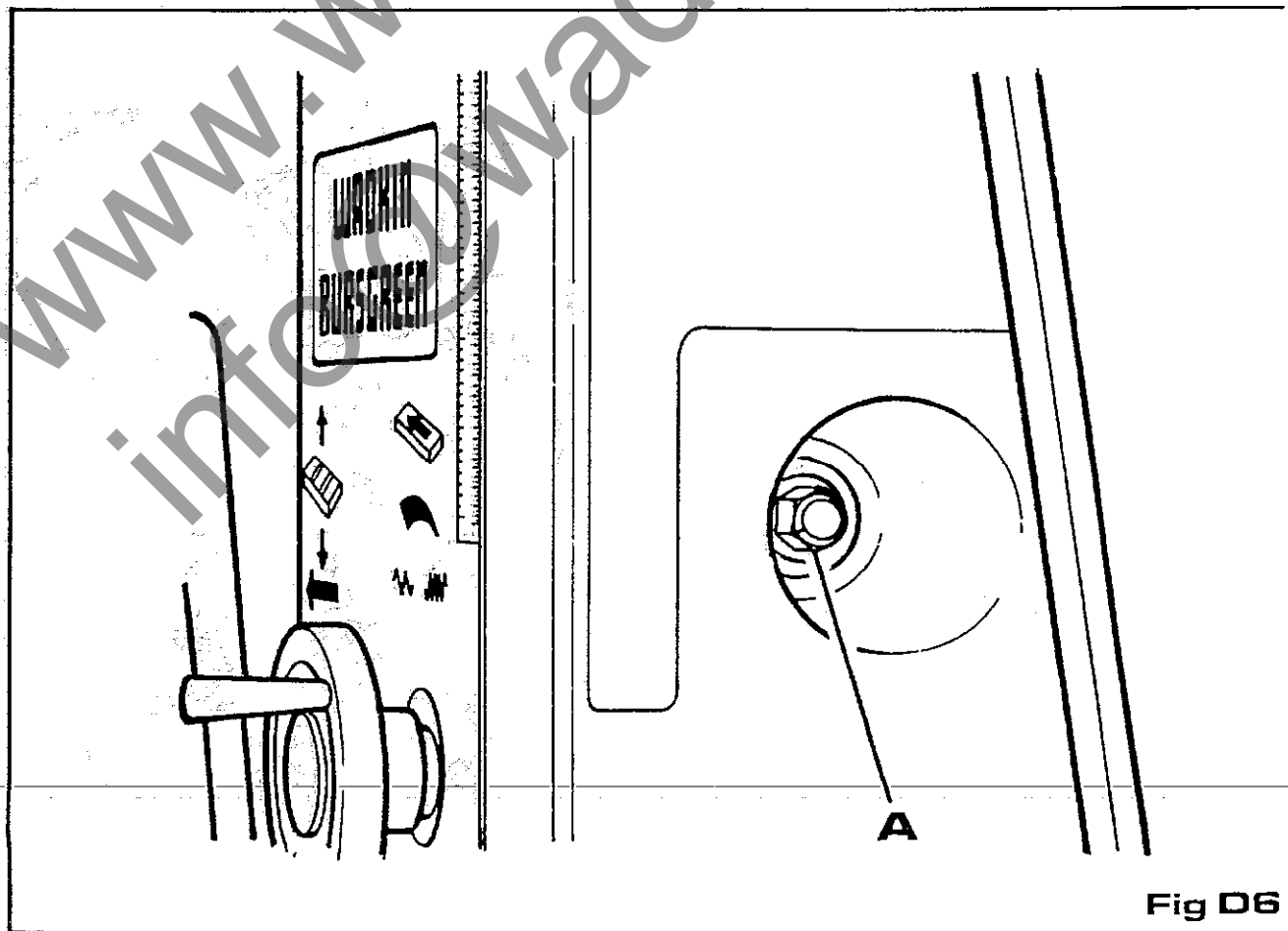
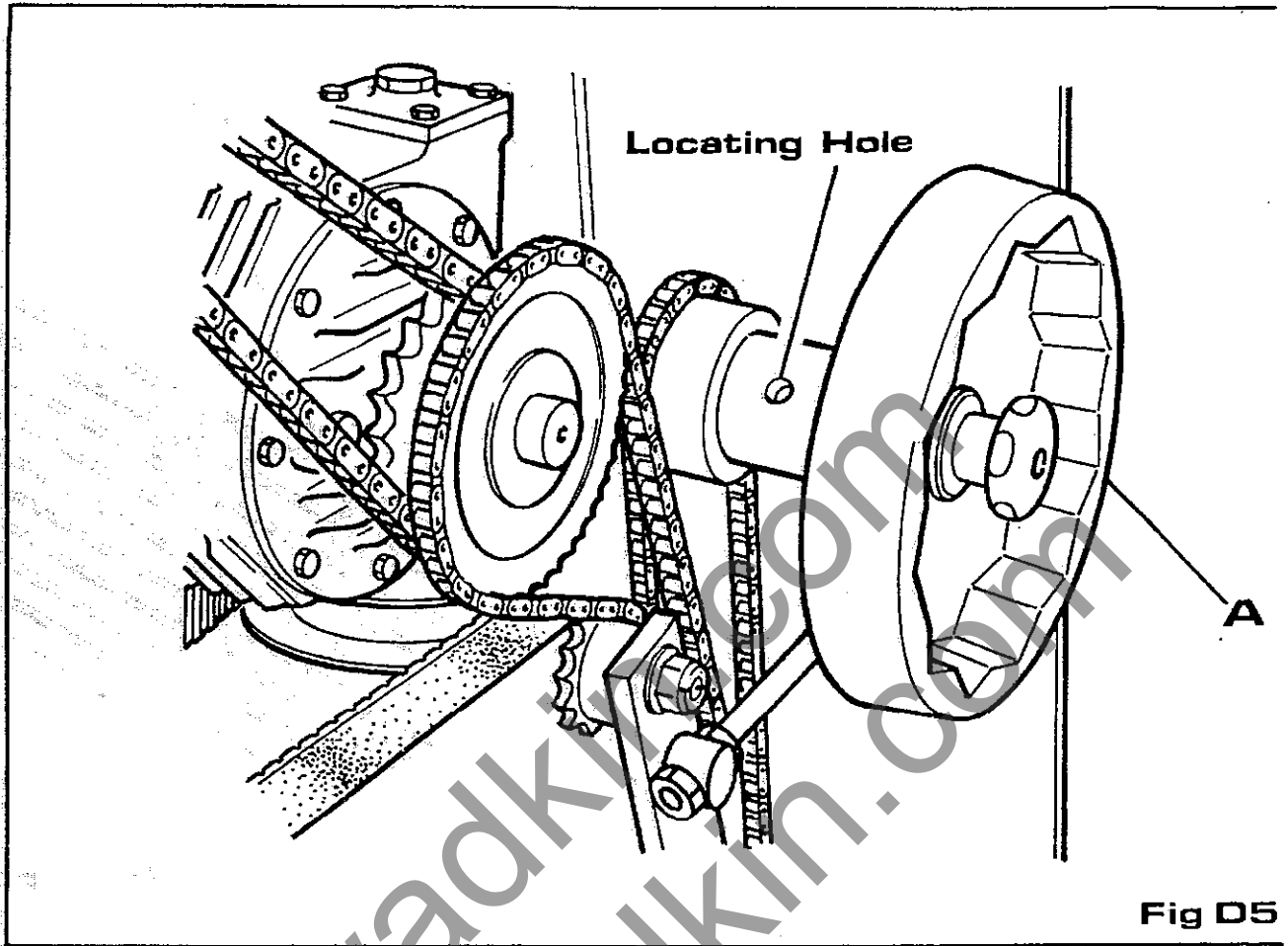


Fig D4



WORM GEARBOX TO CLUTCH CHAIN TENSION
FIG. D7.

Slacken hexagon locknut "A" and adjust hexagon locknut "B" until chain tension is correct, i.e. chain should not be run either too slack or too tight.

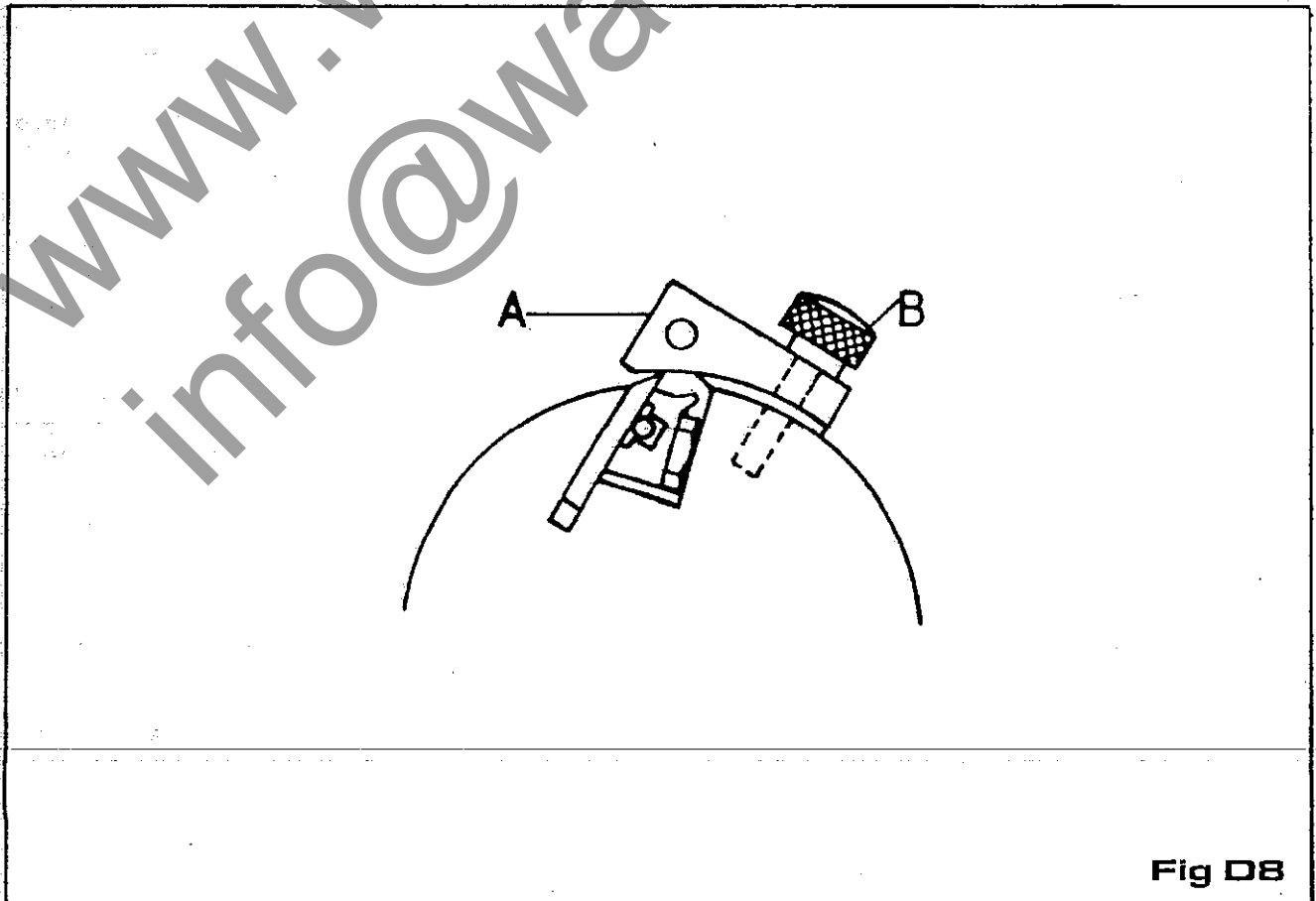
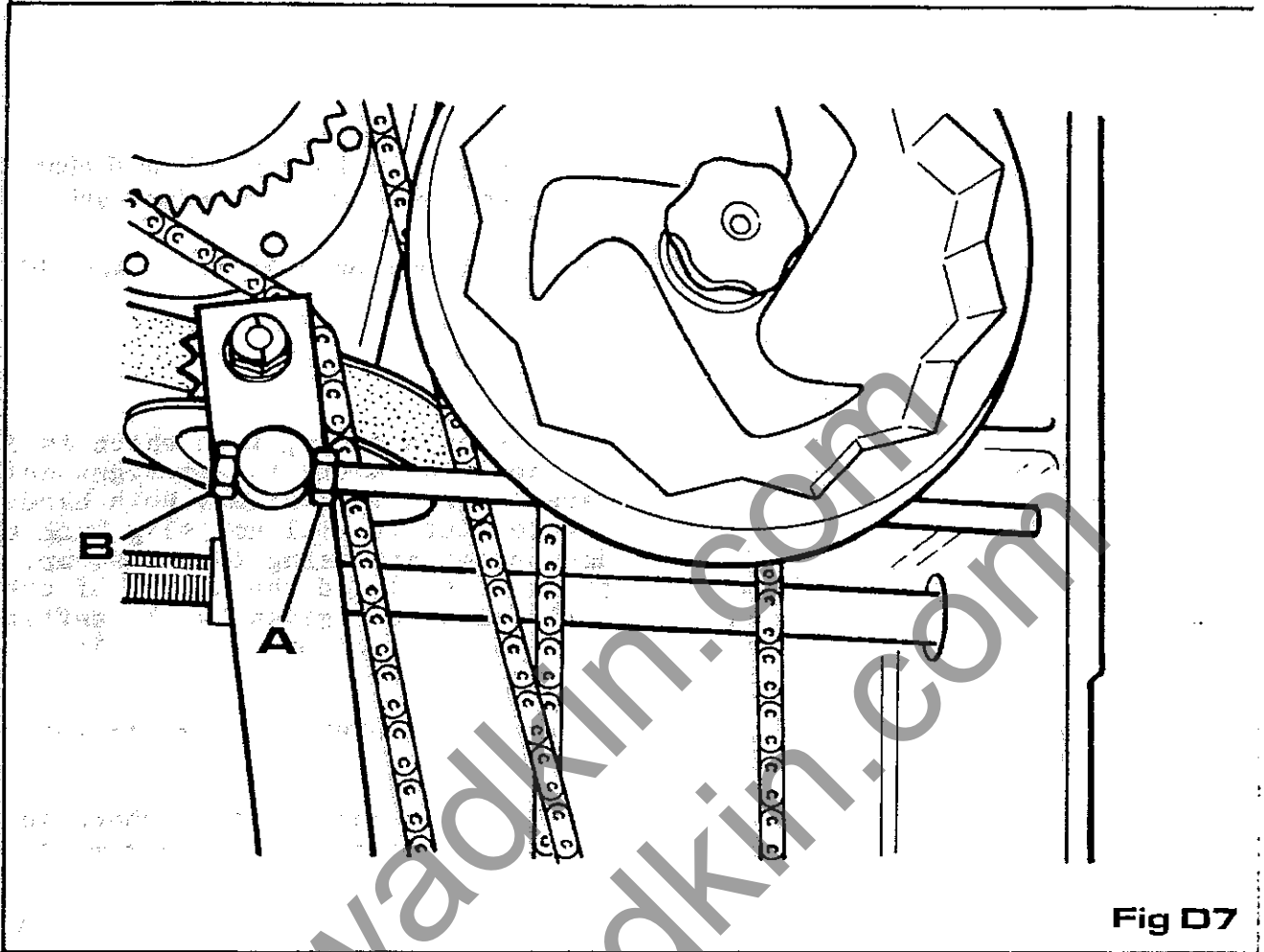
When chain is correctly tensioned relock hexagon locknuts "A" and "B".

CUTTER SETTING - FIG.D8

The knife is held in the cutterblock by a wedge, into which is fitted spring loaded balls, these balls hold the knife finger tight whilst the 9-M12 hexagon head screws are loose. This allows both hands to be free to adjust the blade and ensure that it will not slip back during setting or move whilst the wedge screws are being tightened up. Should any other method of cutter setting be employed the amount of cutter projection must correspond exactly with that given by the setting gauge supplied and failure to observe this instruction will result in bad feeding and poor finish.

To remove the knives and re-set with the "BURSGREEN" knife setting gauge, proceed as follows:-

- 1 Turn the cutterblock to approximately the position shown in FIG.D8 and loosen the 9-M12 hexagon head screws, carefully remove knife from cutterblock.
NOTE: When grinding it is most important that knives are ground dead straight and balanced in pairs or sets.
An efficient re-grinding service is available, charges are moderate and service prompt. To avail yourself with this service, return knives to BURSGREEN (DURHAM), FENCE HOUSES, TYNE & WEAR.
- 2 To re-set the knives the cutterblock should be in the approximate position shown in FIG.D8. Place knife in between wedge and cutterblock with the blade drawn forward slightly.
- 3 Carefully secure the knife setting device 'A' (which when not in use is normally secured to the rear of the machine table), to the cutterblock with the three knurled locking screws 'B' as shown in FIG.D8.
- 4 Whilst turning these locking screws 'B' FIG.D8, knife will be lowered to correct setting which is reached when knurled screws are locked in position and knife just touches knife setting device.
- 5 When the knife is correctly set, tighten the 9-M12 hexagon head screws, remove knife setting device then securely lock the 9-M12 hexagon head screws.
- 6 Rotate cutterblock until the next knife is in position and repeat the procedure until all the knives have been set.
- 7 When changing knives it is advisable to check that all the locking screws are adequately lubricated and quite free. Periodically examine for damage or cracks. Any doubtful screws should be replaced and all screws well lubricated with "Molyslip" or similar oil, before replacing.



CUTTER CARE FIG. D9.

The cutters supplied are 637mm long x 30mm wide x 3mm thick in balanced sets. They should be kept in balanced sets by ensuring that the cutters have equal dimensions after grinding and that the cutting edge is straight and parallel to the back edge.

For general work, knife angles for soft and hard woods are recommended as in FIG. D9. (a) and (b).

When a very fine finish is required in dry soft and hard woods a slight front bevel is given as in FIG. D9.(c) and (d). For wet or green timber the cutting bevel may be decreased five degrees, but the front bevel should not be given.

Keep the cutters sharp when in position by using a fine grade oil stone dipped in paraffin.

Allow the stone to rest lightly and flat on the bevel and pass over the cutter with a rotating action a few times. Give about two strokes on the full length of each knife on the face side to remove all burrs from the cutting edge.

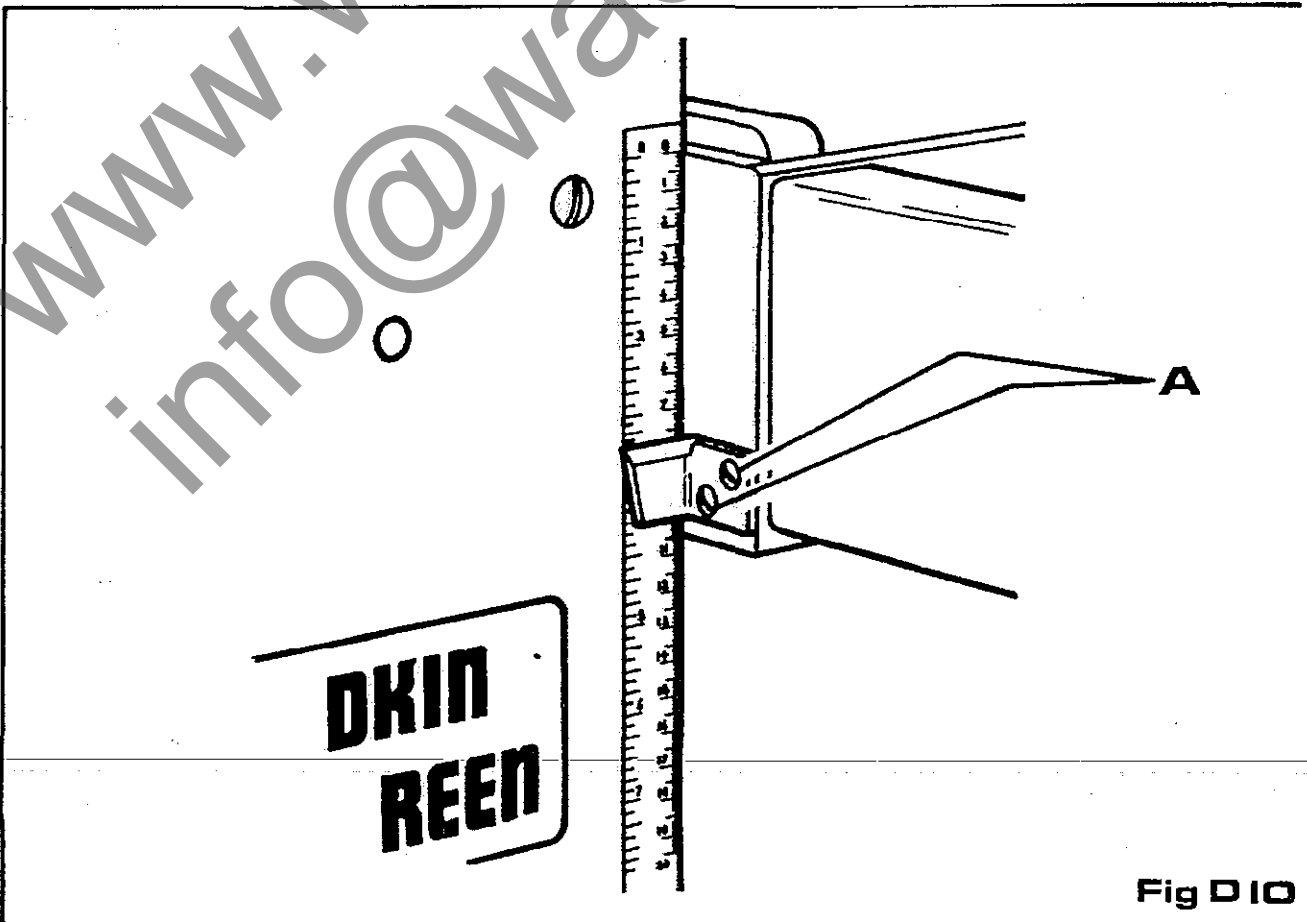
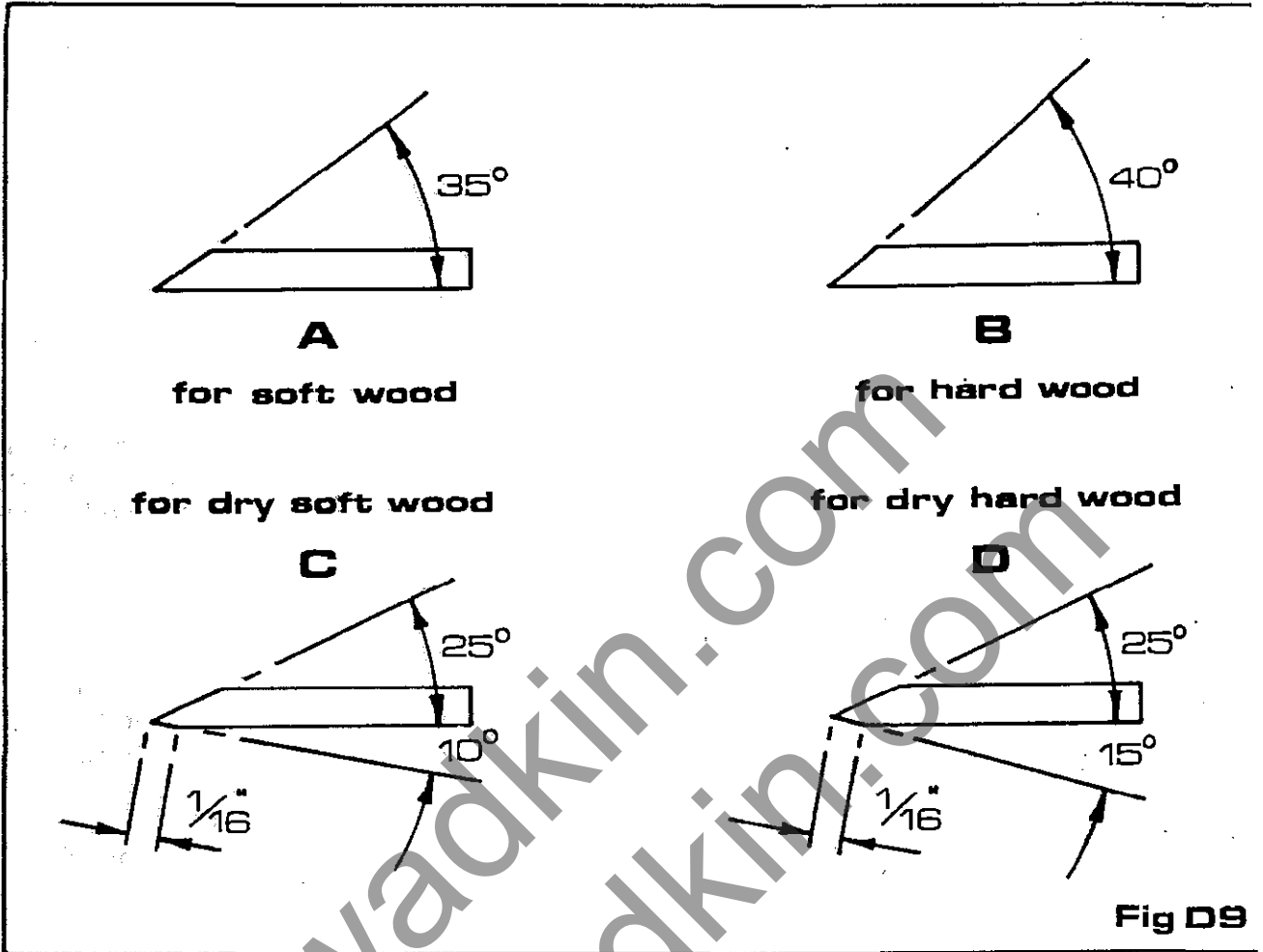
Do not allow a heel greater than .79mm (1/32") wide on the bevel before removing and regrinding. When the heel becomes too wide the knives may heat up or have a hammering effect on the wood and more than normal power will be required to run the cutterblock.

SETTING THICKNESSING TABLE PARALLEL TO CUTTERBLOCK

The machine table is accurately set parallel to cutterblock before despatch but should it be disturbed for any reason it must be carefully checked and made parallel to the cutterblock, if necessary, by the following procedure.

1. Feed a short length of timber approximately 50mm (2" square) x 460mm (18" long) through the machine to one side of the thicknessing table.
2. Without adjustment to the height of the table feed the timber through the machine again on the opposite side of the table to that in item 1.
3. If a cut is taken or it does not touch the wood adjust the fine thread adjusters on the underside of the table to suit and when set tighten all screws.

As the knife setting device sets the knives parallel to the cutterblock it is vitally important that the table is set parallel to the knives for accurate thicknessing.



THICKNESSING RULE

FIG. D10.

The pointer on the machine table is pre-set before despatch. Should it be disturbed, feed a piece of timber through the machine and measure the thickness accurately. Check that the reading given by the pointer corresponds to the thickness of timber machined. Should adjustment be necessary slacken the screws "A" in FIG. D10. and set pointer to the correct thickness.

GENERAL HINTS

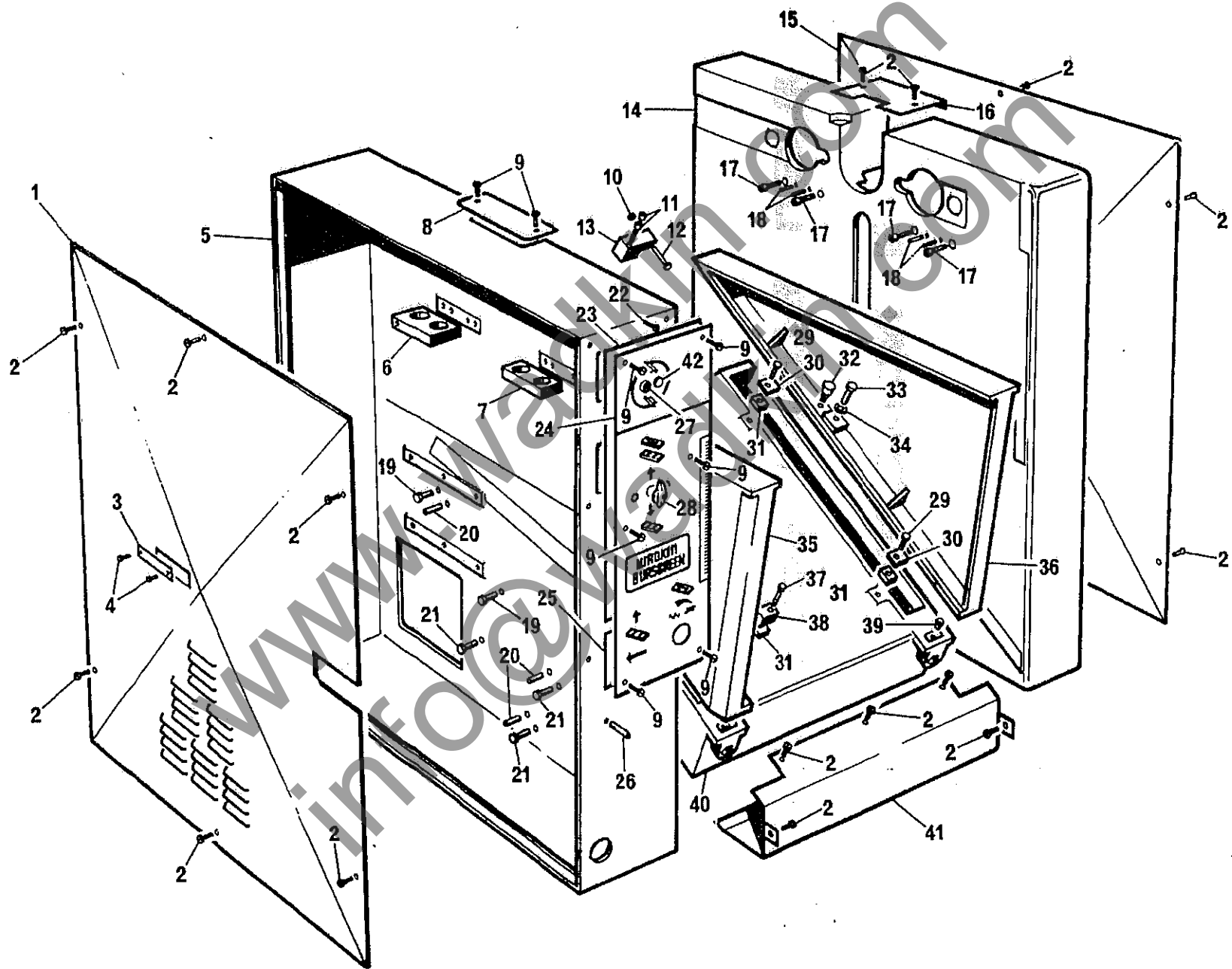
1. When thicknessing long lengths of timber always support after the machine table, otherwise a step will appear on either or both ends.
2. When a smooth finish is required use the slow feed speed. For roughing when the finish is not important use the fast feed speed.
3. For the best results always feed the timber to cut with the grain.
4. Should the timber stick when thicknessing two probable causes are given below:
 - (a) The table rollers are set too low in the table.
 - (b) The spring pressure is too great on the pressure bars and too little on the feed rollers.

Application	APPROVED LUBRICANTS					
	Castrol	B.P.	Shell	Esso	Texaco/Caltex	Wadkin
Worm Boxes	ZN220	Energol CS320	Vitrea 320	Spartan EP220	Regal Oil 320	L2
General Lubrication	Magna 68	Energol HP68	Vitrea 68	Nuray	Ursa Oil P68	L4
Pneumatic Lubricators	Hyspin AWS32	Energol HL32	Tellus 37	Nuto H32	Rando Oil HD32	
Grease	Spheerol AP3	Energol L53	Alvania R3	Beacon 3	Regal Starfak Premium 3	L6
Brake Cables	Brake Cable grease	Energol L21M	Alvania R3	Esso Multi-purpose grease		

SECTION E
SPARE PARTS LISTS

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When ordering replacement parts quote
Part No. and Serial No. of the machine



MAIN FRAME ASSEMBLY

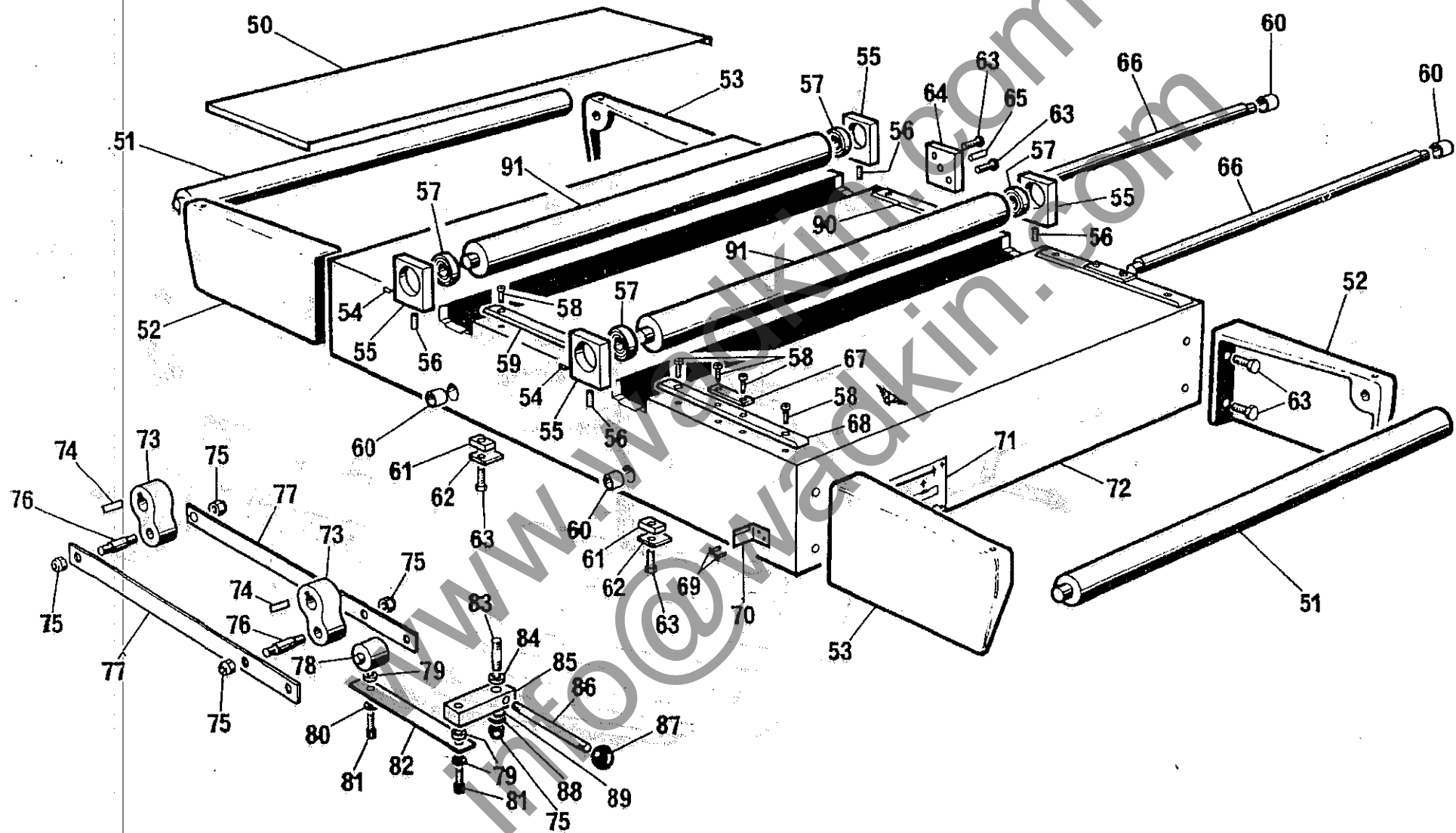
Ref. No.	Part No.	No. Off	Description
1	1069/208	1	Drive side cover
2		19	8mm x 10mm pan head screw
3	1069/136	1	Feed scale
4		2	1/8" dia x 1/4" long self tapping screw
5	1069/235	1	Drive side frame
6	1069/162	1	Spring and jockey pressure plate
7	1069/48	3	Spring pressure plate
8	1069/84	1	Cover for belt aperture
9		8	6mm x 10mm pan head screw
10		1	8mm nut
11		2	8mm x 25mm socket head capscrew
12		1	8mm x 50mm hexagon head bolt
13	1069/186	1	Thicknessing table stop
14	1069/236	1	Rebate side frame
15	1069/243	1	Rebate side cover
16	1069/276	1	Spindle pulley cover
17		8	10mm x 25mm socket head capscrew
18		8	1/4" dia. x 1 1/4" long fluted dowel
19		2	12mm x 30mm hexagon head bolt
20		6	12mm x 28mm hardened ground dowel
21		8	12mm x 35mm hexagon head bolt
22		4	6mm x 10mm countersunk socket head screw
23	1069/89	1	Front panel back plate
24	1069/204	1	Control plate
25	1069/241	1	Front panel back plate
26	1069/295	1	Stop peg
27		1	Brooks "STOP" push button unit
28		1	Chilton switch No. C6 - A292 with tear drop handle
29		3	10mm x 25mm hexagon head bolt
30	1069/93	9	Wedge keeps
31	1069/92	4	Wedge keep locking piece
32	WF 1920	2	Spring lid oil cup wick feed (1/8" gas)
33		2	10mm x 35mm socket head capscrew
34	1032/22	2	Washer for rise and fall nut
35	1069/171	1	Wedge (left hand)
36	1069/171	1	Wedge (right hand)
37		1	10mm x 45mm hexagon head bolt
38	1069/187	1	Thicknessing table stop block
39	PC2	2	Grease nipple (1/8" gas)
40	1078/4	1	Base
41	1078/5	1	Cover for rise and fall gears
42		1	Brooks "START" push button unit

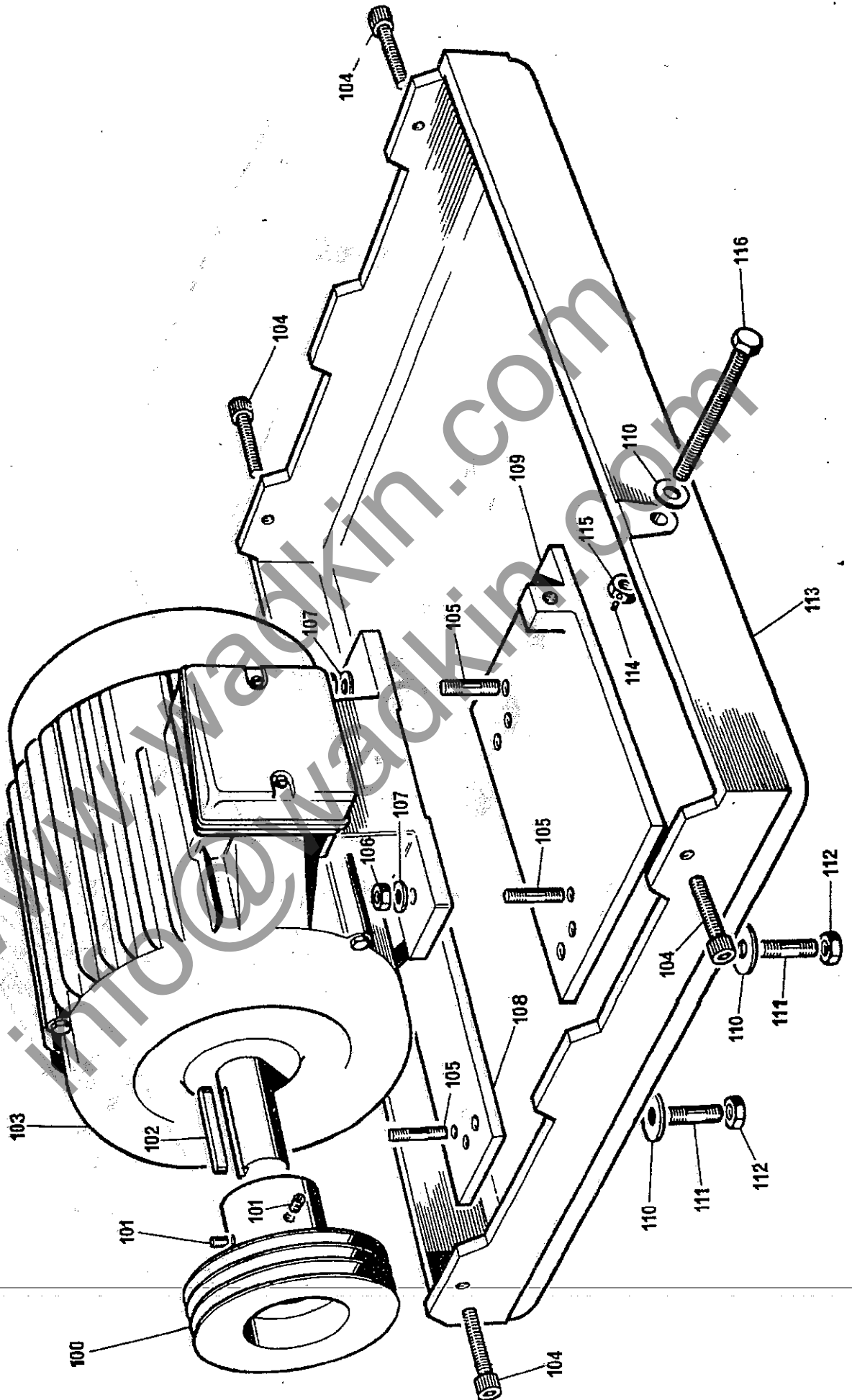
NOTE :- When ordering replacement parts quote
Part No. and Serial No. of the machine

TABLE ASSEMBLY

Ref. No.	Part No.	No. Off	Description
50	1078/6	1	Cover for outfeed roller
51	1078/14	2	Outer table roller
52	1069/18	2	Outer table roller bracket (right hand)
53	1069/18	2	Outer table roller bracket (left hand)
54		4	6mm x 16mm long socket head grubscrew
55	1069/77	4	Under table roller bearing block
56	1069/239	4	Under table roller adjusting screw
57	SKF 62032RS	4	Bearing
58		12	6mm x 12mm long cheese head screw
59	1069/210	1	Left hand inner table strip
60	1069/78	4	Under table roller bushes
61	1069/92	4	Wedge keep locking piece
62	1069/93	4	Wedge keep
63		14	10mm x 25mm hexagon head bolts
64	1069/51	1	Table key
65		1	3/8" dia. x 1" long fluted dowel
66	1078/13	2	Under table roller eccentric
67	1069/228	2	Depth stop control plate
68	1069/97	2	Front table strip
69		2	1/8" dia. x 3/8" long self tapping screw
70	1069/292	1	Thickening pointer
71	1069/137	1	Table roller instruction plate
72	1078/3	1	Table
73	1069/72	2	Under table roller links
74		2	8mm x 7mm x 32mm feather key
75		5	10mm nut
76	1067/76	2	Under table roller link pin
77	1069/74	2	Under table roller adjusting link
78	1069/75	1	Under table roller swivel nut
79	1069/147	3	Roller link swivel
80		1	8mm washer
81		2	8mm x 25mm socket head capscrew
82	1069/145	1	Roller control link
83	1069/231	1	Stud for under-table mechanism
84		1	10mm fibre washer (thick)
85	1069/148	1	Under table swivel block
86	1069/32	1	Under table control lever
87		1	10mm x 32mm dia. plastic ball
88		1	10mm washer
89		1	10mm fibre washer (thin)
90	1069/209	1	Right hand inner table strip
91	1078/24	2	Under table roller

NOTE :- When ordering replacement parts quote
Part No. and Serial No. of the machine





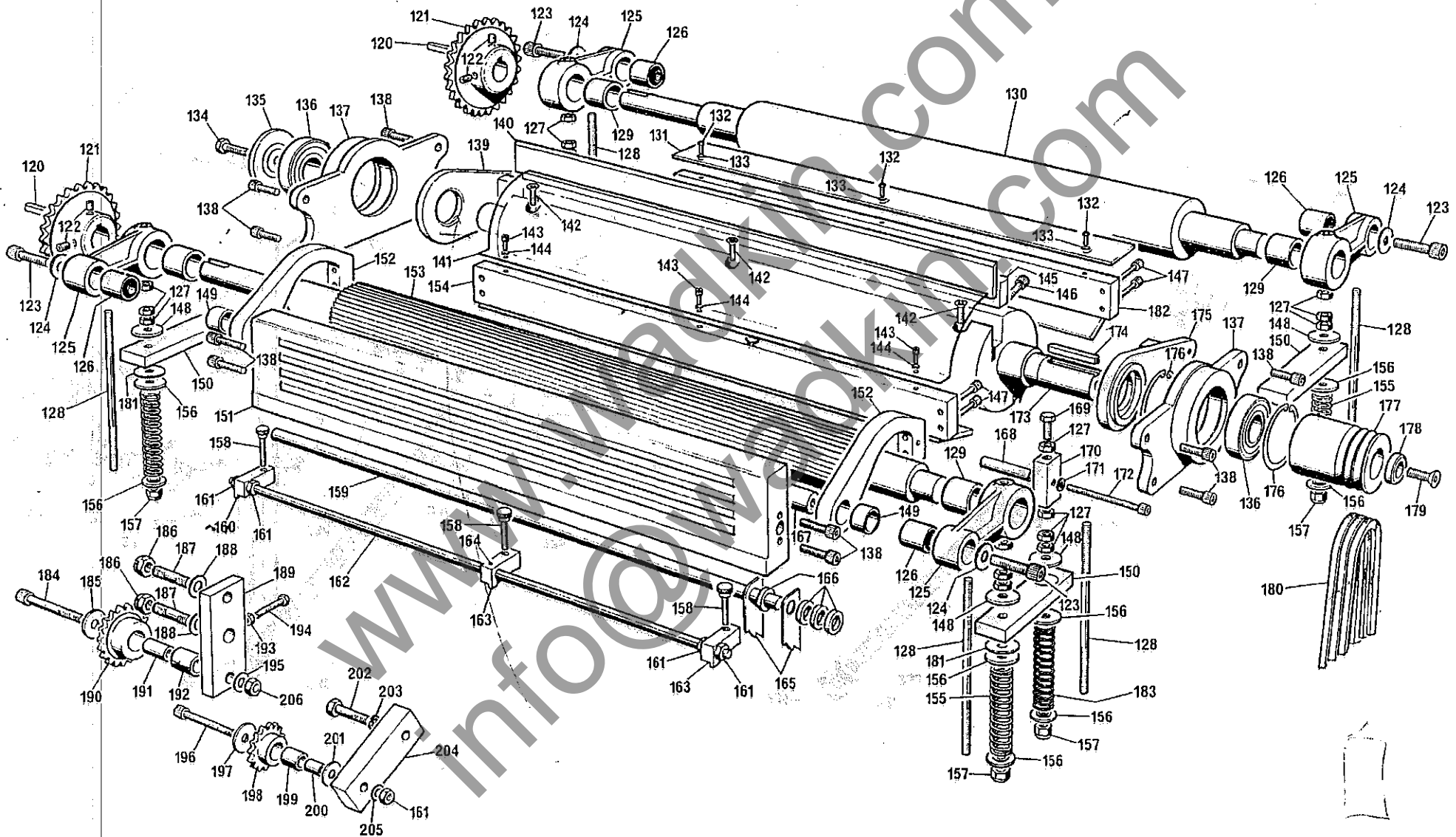
MOTOR MOUNTING ASSEMBLY

Ref. No.	Part No.	No. Off	Description
100	1069/23	1	Block motor pulley
101		2	10mm x 12mm socket head grubscrew
102		1	8mm x 10mm x 60mm feather key (ground to size)
103		1	Brook Motor, 7.5HP, 3000 r.p.m. TEFC Frame D132SA, Foot mounted Star Delta Wound 3 phase 50 cycles Terminal box in standard position.
		1	Brook Motor 7.5 HP 3, 600 r.p.m. TEFC Frame D132SA, Foot mounted Star Delta wound 3 phase 60 cycles, Terminal box in standard position.
		1	Brook Motor 10HP, 3000 r.p.m. TEFC Frame D132SB, Foot mounted Star Delta Wound, 3 phase 50 cycles Terminal box in Standard position.
		1	Brook motor 10HP, 3600 r.p.m. TEFC Frame 132SB, Foot mounted, Star Delta Wound, 3 phase 60 cycles, Terminal Box in Standard position.
104		4	12mm x 35mm socket head capscrew
105	1069/233	4	Stud for motor platform
106		4	10mm nut
107		4	10mm washer
108	1069/58	1	Plate for motor feet
109	1069/79	1	Motor adjusting plate
110		5	12mm washer
111	1069/234	4	Stud for motor platform
112		4	12mm nut
113	1078/1	1	Motor platform
114		1	6mm x 6mm socket head grubscrew
115		1	12mm nut (with 6mm tapped hole)
116		1	12mm x 100mm hexagon head bolt

NOTE :- When ordering replacement parts quote
Part No. and Serial No. of the machine

CUTTERBLOCK ASSEMBLY

Ref. No.	Part No.	No. Off.	Description	Ref No.	Part No.	No. Off.	Description
120		2	8mm x 6mm x 30mm feather key	164		1	6mm x 6mm socket head grubscrew
121	1069/131	2	Feed Roller Sprocket	165	1069/40	77	Anti kick back finger
122		4	10mm x 10mm socket head grubscrew	166	1069/41	84	Spacer for kick back finger
123		4	12mm x 80mm socket head capscrew	167	1078/9	1	Tie bar
124	1069/141	4	Washer for "Metalastic" bush	168	1069/50	4	Pressure bar tie rods
125	1069/11	4	Feed Roller pivot arm	169		1	10mm x 45mm hexagon head bolt
126		4	"Metalastic" bush	170	1069/49	4	Pressure bar block
127		25	10mm locknut	171		4	8mm washer
128	1069/68	8	Stud for pressure bar spring	172		4	8mm x 90mm socket head capscrew
129	1069/78	4	Under table roller bush	173	1078/19	1	Cutterblock (state No of knife slots)
130	1078/17	1	Outfeed roller	174		1	10mm x 7.2mm x 60mm feather key
131	1078/23	1	Scraper plate	175	1078/42	1	Back pressure bar bracket (right hand)
132		3	6mm x 10mm hexagon head bolt	176	Type 80	2	Internal circlip
133		3	6mm washer	177	1069/22	1	Cutterblock pulley
134		1	12mm x 30mm hexagon head bolt	178	1069/39	1	Washer for cutterblock pulley
135	1078/40	1	Washer for cutterblock	179		1	12mm x 35mm countersunk "nylok" socket head screw
136	6207-2RS	2	Cutterblock bearing				
137	1078/18	2	Bearing housing	180	ALPHA 670	3	Vee belts, K S104-203
138		12	10mm x 30mm socket head capscrew	181	1069/254	2	Washer for spring guide
139	1078/42	1	Back pressure bar bracket (left hand)	182	1078/11	1	Rear Pressure bar
140		as required	Cutterblock knives (state quantity required)	183	ETS 162	2	Pressure bar spring
141	1078/7	1	Chip deflector	184		1	12mm x 75mm long socket head capscrew
142		6	8mm x 30mm countersunk socket headscrew	185	1026/22	1	Washer
143		3	6mm x 10mm socket head capscrew	186		2	14mm aerolight nut
144		3	6mm spring washer	187		2	14mm x 60mm long stud
145	1078/22A/22B	as required	Cutterblock wedge (state length and quantity required)	188		2	14mm washer
146	1069/183	as required	Cutterblock screw	189	1069/26	1	Jockey sprocket arm
147		8	8mm x 30mm socket head capscrew	190	1069/132	1	Idle sprocket
148	1069/70	8	Washer for feed roller spring	191	1069/52	1	Idle sprocket spacer
149	BS 99	2	Oilite bush	192		1	20mm I/D x 28mm O/D x 30mm long oilite bush
150	1069/48	3	Spring pressure plate	193		1	8mm locknut
151	1078/2	1	Front tie piece	194		1	8mm x 45mm hexagon head bolt
152	1069/8	2	Front pressure bar bracket	195		1	12mm washer
153	1078/17	1	Infeed roller	196		1	10mm x 65mm long socket head capscrew
154	1078/16	1	Front pressure bar	197	1032/22	1	Washer
155	ETS194	4	Feed roller spring	198	1069/100	1	Jockey sprocket for main drive
156	1069/69	16	Spring guide	199		1	16mm I/D x 22 O/D x 20mm long oilite bush
157		8	10mm aerotight nut	200	1069/64	1	Jockey sprocket bush
158	1069/184	3	Knife setting device fixing screw	201	1069/203	1	Washer
159	1078/10	1	Anti kick back fingers bar	202		1	12mm x 40mm hexagon head bolt
160	1069/175	1	Knife setting device block (left hand)	203		1	12mm spring washer
161		5	10mm nut	204	1069/71	1	Main drive tension arm
162	1078/15	1	Knife setting tie bar	205		1	10mm washer
163	1069/175	2	Knife setting device block (right hand)	206		1	12mm nut



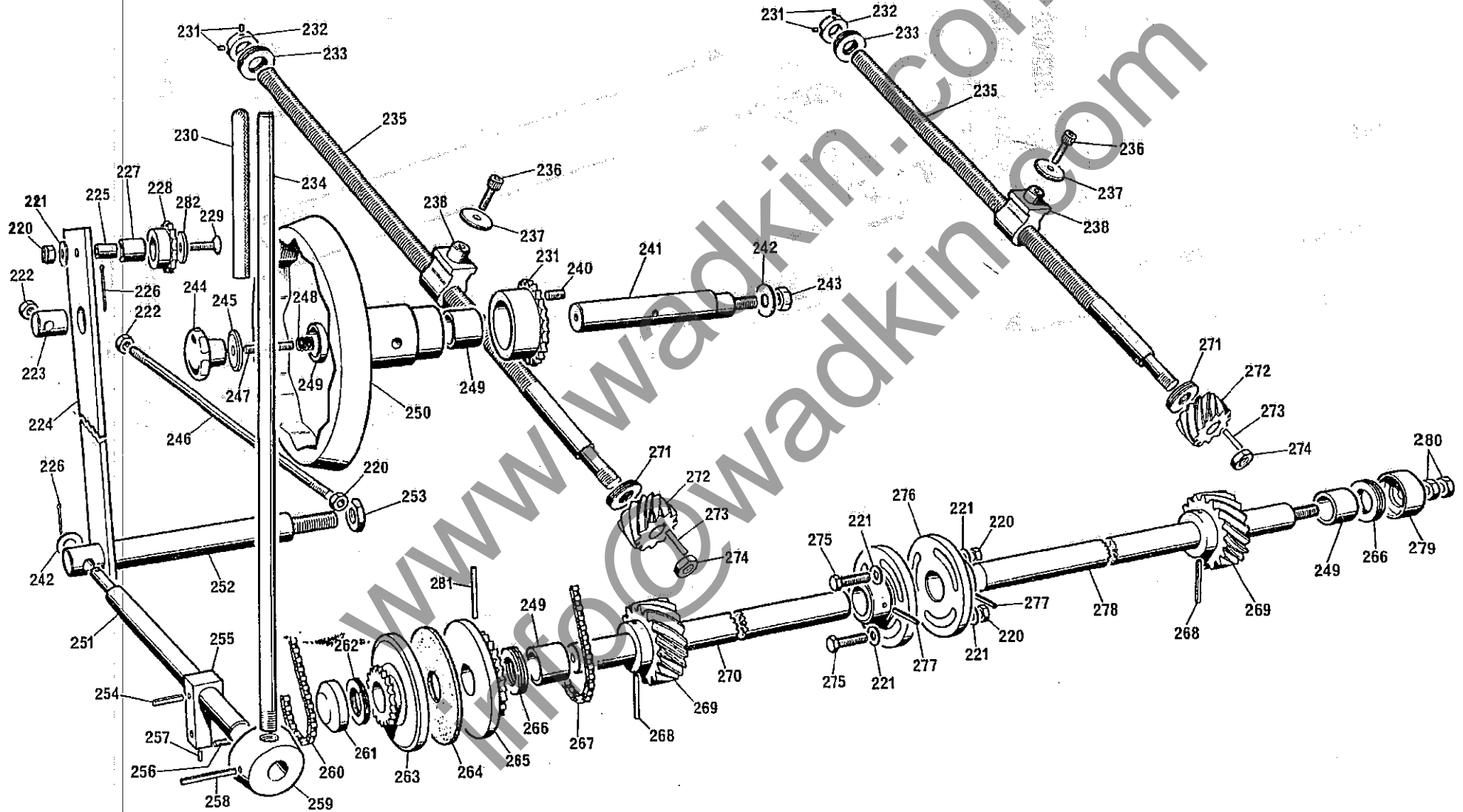


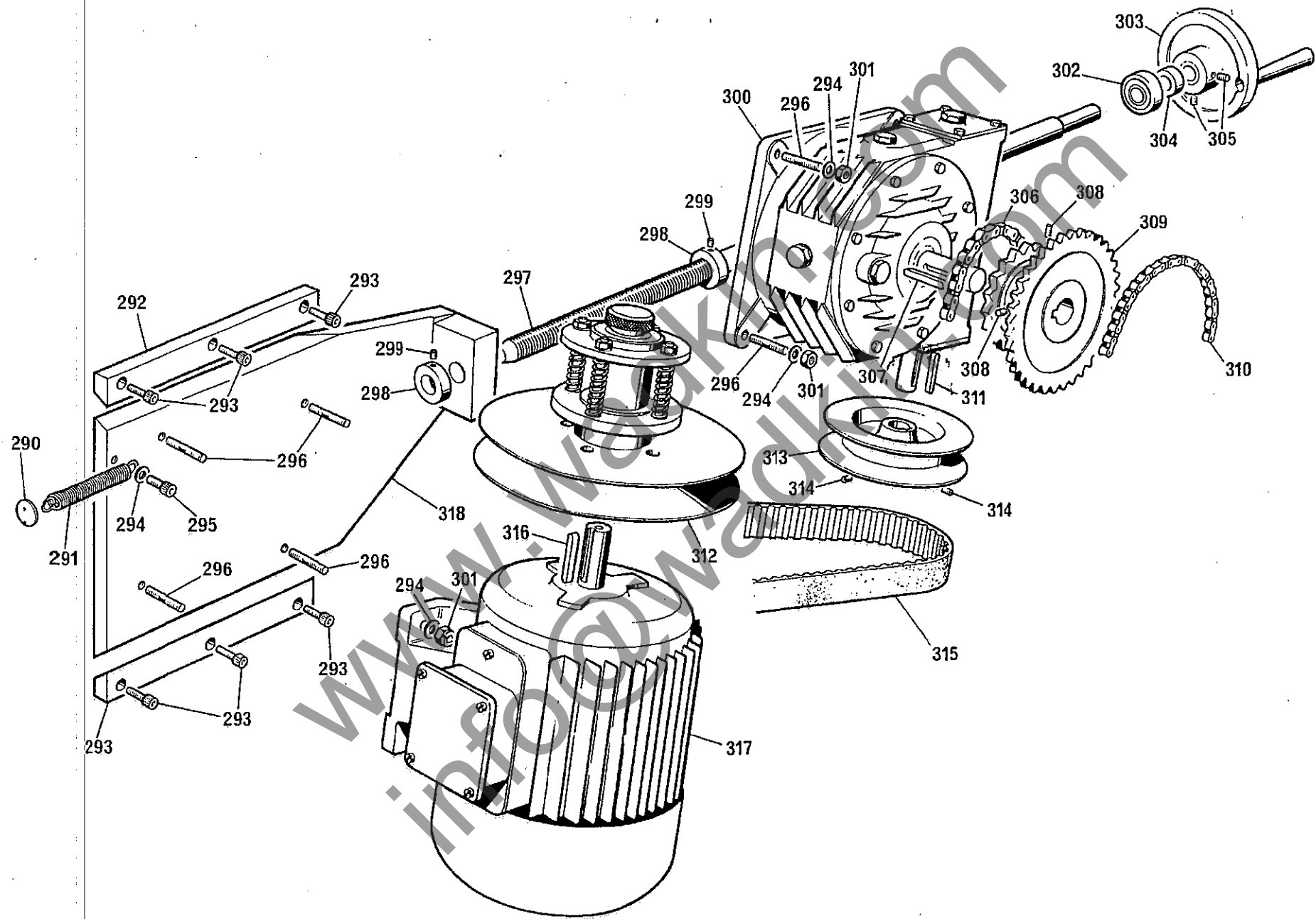
TABLE RISE & FALL ASSEMBLY

Ref. No.	Part No.	No. Off	Description
220		5	10mm nut
221		7	10mm washer
222		2	10mm locknut
223	1069/251	1	Pivot for rise and fall chain tension bar
224	1069/207	1	Table rise and fall chain tension bar
225	1069/64	1	Jockey sprocket bush
226		2	2.5mm x 30mm split pin
227	CT264A	2	16mm ID x 22mm OD x 20mm long oilite bush
228	1069/134	1	Jockey sprocket
229		1	10mm x 50mm countersunk slotted screw
230		1	14mm dia rubber handle
231		4	6mm x 6mm socket head grubscrew
232	1069/56	2	Stop for rise and fall screw
233	SKF 51104	2	Rise and fall screw bearing
234	1069/102	1	Clutch control lever
235	1069/173	2	Rise and fall screw
236		2	10mm x 35mm socket head capscrew
237	1032/22	2	Washer for rise and fall nut
238	1069/172	2	Rise and fall nut
239	1069/25	1	Handwheel sprocket
240		1	10mm x 20mm socket head grubscrew
241	1069/46	1	Rise and fall handwheel shaft
242		2	12mm washer
243		1	12mm nut
244		1	8mm x 44mm plastic handwheel
245	1062/47	1	Handwheel washer
246	1069/212	1	Adjusting screw for jockey sprocket
247	1069/230	1	Stud for rise and fall handwheel
248	1026/63	1	Handwheel return spring
249	BS 99	4	Oilite bush
250	1069/24	1	Rise and fall handwheel
251	1069/61	1	Clutch pressure shaft
252	1069/59	1	Rise and fall chain tension post
253		1	16mm locknut
254		1	6mm x 32mm groverlok spring dowel
255	1069/205	1	Clutch pressure link
256	1069/221	1	Adjusting screw for clutch pressure
257		1	6mm x 12mm socket head grubscrew
258		1	8mm x 50mm groverlok spring dowel
259	1069/63	1	Boss for clutch pressure shaft
260	110038	1	Roller chain (state no. of links including split link)
261	1069/66	1	Thrust bearing cover
262	INA-AXK 2542	1	Clutch thrust bearing
263	1069/20	1	Inner clutch sprocket
264	1069/73	1	Clutch for table rise and fall
265	1069/138	1	Outer clutch sprocket
266	SKF 51105	2	Rise and fall cross shaft bearing
267	110038	1	Roller chain (state no. of links including split link)
268		2	6mm x 45mm groverlok spring dowel
269	1069/14	1	Driving gear for table rise and fall
270	1078/12	1	Rise and fall cross-shaft (with female end)
271	SKF 51104	2	Rise and fall screw bearing
272	1069/13	2	Driven gear for table rise and fall
273		2	5mm x 5mm x 20mm key
274		2	16mm nut
275		3	10mm x 35mm hexagon head bolt
276	1069/15	2	Cross-shaft coupling
277		2	6mm x 40mm groverlok spring dowel
278	1078/12	1	Rise and fall cross-shaft (with male end)
279	1069/213	1	Cover for cross-shaft thrust bearing
280		2	12mm locknut
281		1	6mm x 60mm groverlok spring dowel
282	1069/83	1	Washer for jockey sprocket

VARIABLE DRIVE ASSEMBLY

Ref. No.	Part No.	No. Off	Description
290	1069/203	1	Anchor plate for feed roller spring
291	1034/44	1	Spring
292	1069/288	2	Gib strip
293		6	8mm x 16mm button head capscrew
294		9	8mm washer
295		1	8mm x 16mm socket head capscrew
296		8	8mm x 35mm stud
297	1069/60	1	Motor platform traverse screw
298	1069/56	2	Stop for rise and fall screw
299		2	6mm x 6mm socket head grubscrew
300		1	Holroyd type F.V. worm reduction box 20.5 to 1 reduction (50 cycle)
	<i>1578</i>	1	Holroyd type F.V. worm reduction box 25 to 1 reduction (60 cycle) special
301		8	8mm nut
302	6202/2RS	1	Bearing for motor control shaft
303	Rencol No. 601	1	Handwheel
304	1069/99	1	Handwheel spacer
305		2	6mm x 12mm socket head grubscrew
306	110046	1	Roller chain (FEED ROLLERS)
307		1	6mm x 6mm x 40mm feather key
308		2	6mm x 10mm socket head grubscrew
309	1069/206	1	Gearbox output sprocket
310	110038	1	Roller chain (GEARBOX TO CROSS SHAFT)
311		1	5mm x 5mm x 32mm feather key
312		1	Variable pulley
313	1069/21	1	Gearbox input sprocket
314		2	8mm x 8mm socket head grubscrew
315		1	CRVSV24HO81O3D Variable pulley belt
316		1	6mm x 6mm x 35mm feather key
317		1	Brook motor, 1HP, 1,500RPM, Frame 80A, T.E.F.C. Foot mounted terminal box in standard position 3PH, 50cycles.
		1	Brook motor, 1HP, 1,800RPM, Frame 80A, T.E.F.C. Foot mounted terminal box in standard position 3PH, 60cycles. (SPECIAL)
318	1069/286	1	Feed motor platform.

NOTE :- When ordering replacement parts quote
Part No. and Serial No. of the machine



SECTION "D" MAINTENANCE

All adjustments and alignments following have been carefully set and checked and the complete machine thoroughly tested before despatch from the works.

During the first few weeks of operation and at regular intervals afterwards certain items such as belt tension and chain tension should be checked carefully. When adjustments are necessary, proceed in accordance with the relative instructions given.

**LUBRICATION
FIG. C2 & C3.****WEEKLY**

1. GREASE RISE/FALL GEARS AND NUTS
2. GREASE JOCKEY SPROCKET
3. OIL OUTER TABLE ROLLERS.

MONTHLY

5. CHECK OIL IN REDUCTION GEARBOX IS UP TO OIL LEVEL HOLE. TOP UP IF NECESSARY.

6 MONTHLY

6. GREASE BOTH ENDS OF CUTTERBLOCK MOTOR:- 2 TURNS.
7. GREASE BOTH ENDS OF FEED MOTOR:- 2 TURNS.

TYPE OF OIL RECOMMENDED FOR GENERAL USE:- CASTROL MAGNA ED
 TYPE OF OIL RECOMMENDED FOR REDUCTION GEARBOX } CASTROL ALPHA
 TYPE OF OIL RECOMMENDED FOR VARIABLE PULLEY } 617 (OR EQUIV').
 TYPE OF GREASE RECOMMENDED:- CASTROL SPHEEROL AP3.

TYPE FV HOLROYD REDUCTION BOX

NOTE: After about 200 hours running with a new gear it is desirable to drain and flush out the original charge of oil and refill with clean oil, after which the oil need only be changed after long intervals. Regular inspection of oil level and topping up when necessary is however important.

**TABLE ROLLERS
FIG. D1.**

The anti-friction table rollers or bed rollers revolve on sealed for life bearings which require no lubrication. These rollers are automatically adjusted in relation to the table surface by a single operating lever "A" at the infeed end of the table.

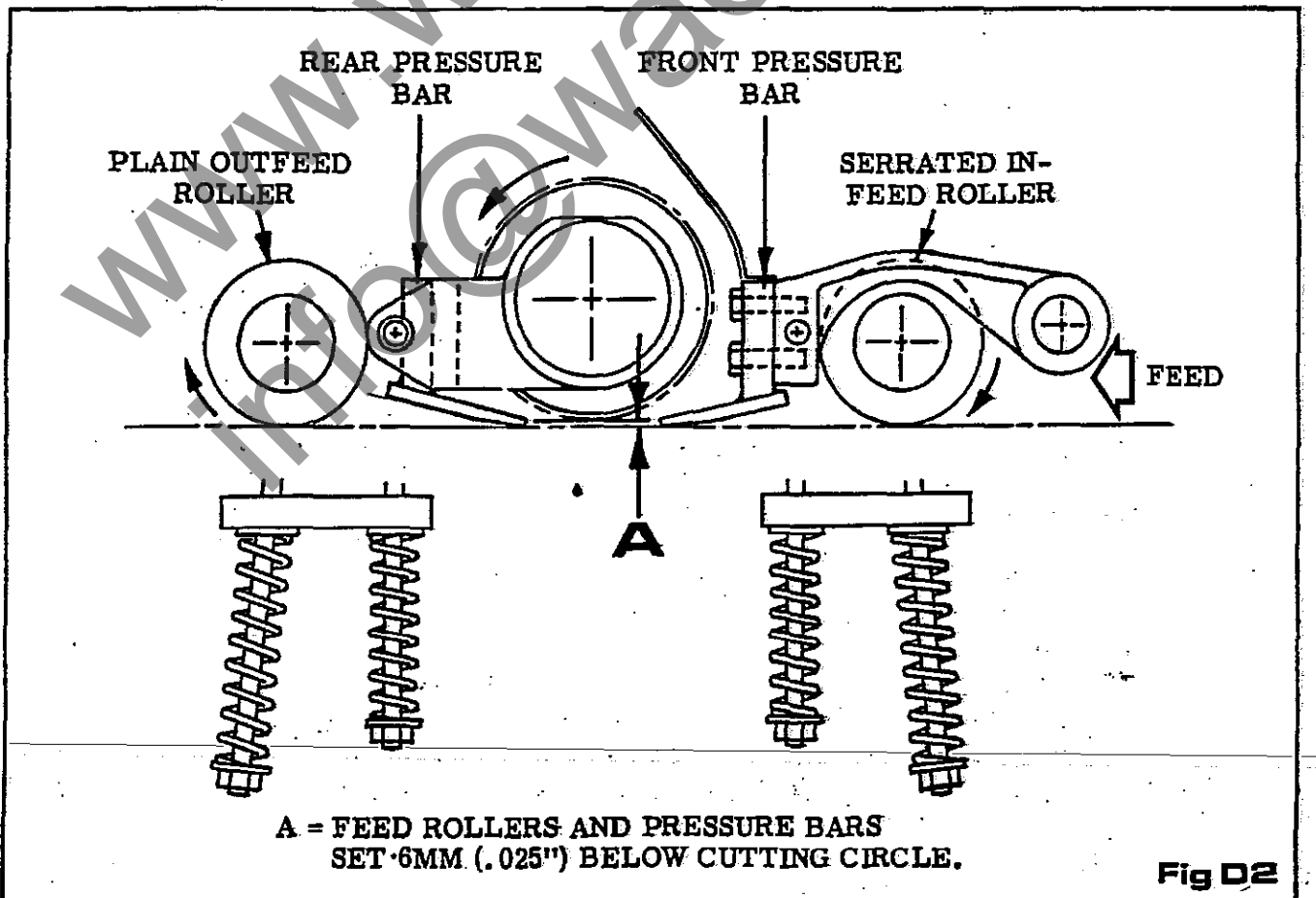
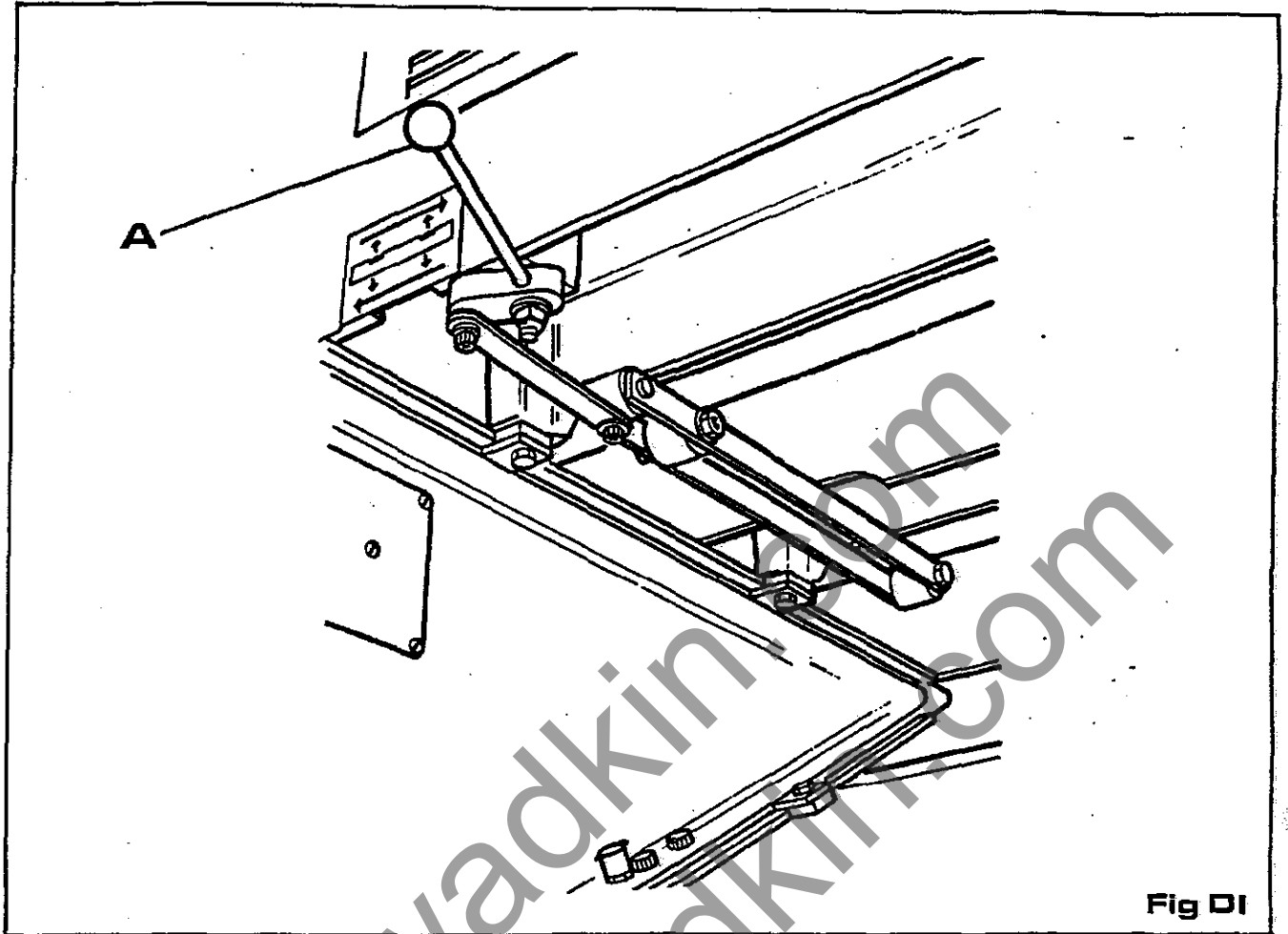
Under table roller height depends on the stock being machined.

The extremes of height being for narrow wet and soft material which allow the rollers to sink into the material considerably and still allow the bottom of the stock to ride on the table surface.

The level position of the rollers caters for the opposite extremes of wide hard dry material which will not permit the rollers to sink into it.

Infinite variation therefore permits correct setting for all classes of timber.

The general rule for setting being that the bottom rollers should be high enough to relieve the friction between table and stock WITHOUT the material losing contact with the table surface.



In all cases the lowest position consistent with good and regular feeding should be used as this will give the best possible results. Should the table rollers be removed for any reason, care must be taken to replace them exactly as before otherwise the setting will be disturbed.

It must be emphasised that a really good surface finish from a thickening machine is only possible when the face of the timber resting on the machine table is flat and has a reasonable finish. Wherever practicable this face should be pre-machined on a overhand jointer, or surfacer to remove twist and other irregularities.

FEED ROLLER AND PRESSURE BAR SETTINGS

FIG. D2.

These are pre-set at the works and vertical adjustment relative to the cutter-block is neither possible nor necessary provided the cutters are correctly set with the special setting gauge supplied with each machine. Should replacement feed rollers or pressure bars be fitted at any time, the settings should be very carefully checked with FIG. D2.

Some slight advantage in finish or feeding may on occasions be obtained by increasing or decreasing the tension of the pressure bar or feed roller springs.

NOTE: The springs should never be compressed to a point where the feed rollers and pressure bars cannot lift sufficient to allow the maximum cut to be taken.

BELT TENSION

FIG. D3.

The cutterblock drive is by three Vee belts from a $7\frac{1}{2}$ HP motor. Tension is effected to these belts by adjusting motor. To adjust, loosen four aerotight nuts "A" then proceed to turn hexagon head nut "B" until required tension is reached then relock nuts "A".

FEED CHAIN TENSION

FIG. D4.

The drive to feed rollers is by roller chain from a worm reduction gearbox which is in turn driven by a variable pulley from a 1HP motor, giving variable feed speeds of 6 - 18 METRES/MIN (20 - 60 FT/MIN).

To adjust chain tension on top feed roller chain, proceed as follows:- Loosen two aerotight nuts "A" and hexagon head locknut "B". Adjust square head screw "C" until required tension is reached, i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned relock aerotight nuts "A" and locknut "B".

TABLE RISE AND FALL CHAIN TENSION

FIG. D5 & FIG. D6.

Tension adjustment to the manual table rise and fall chain is as follows:- Power rise table to uppermost position. Turn handwheel "A" in FIG. D5 until the hole in the handwheel boss lines with the hole in the handwheel shaft, then locate 6mm DIA toggle bar into handwheel shaft. Loosen aerotight nut "A" in FIG. D6 then move toggle bar until required chain tension is reached i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned hold toggle bar in position and re-tighten aerotight nut "A", then remove toggle bar.

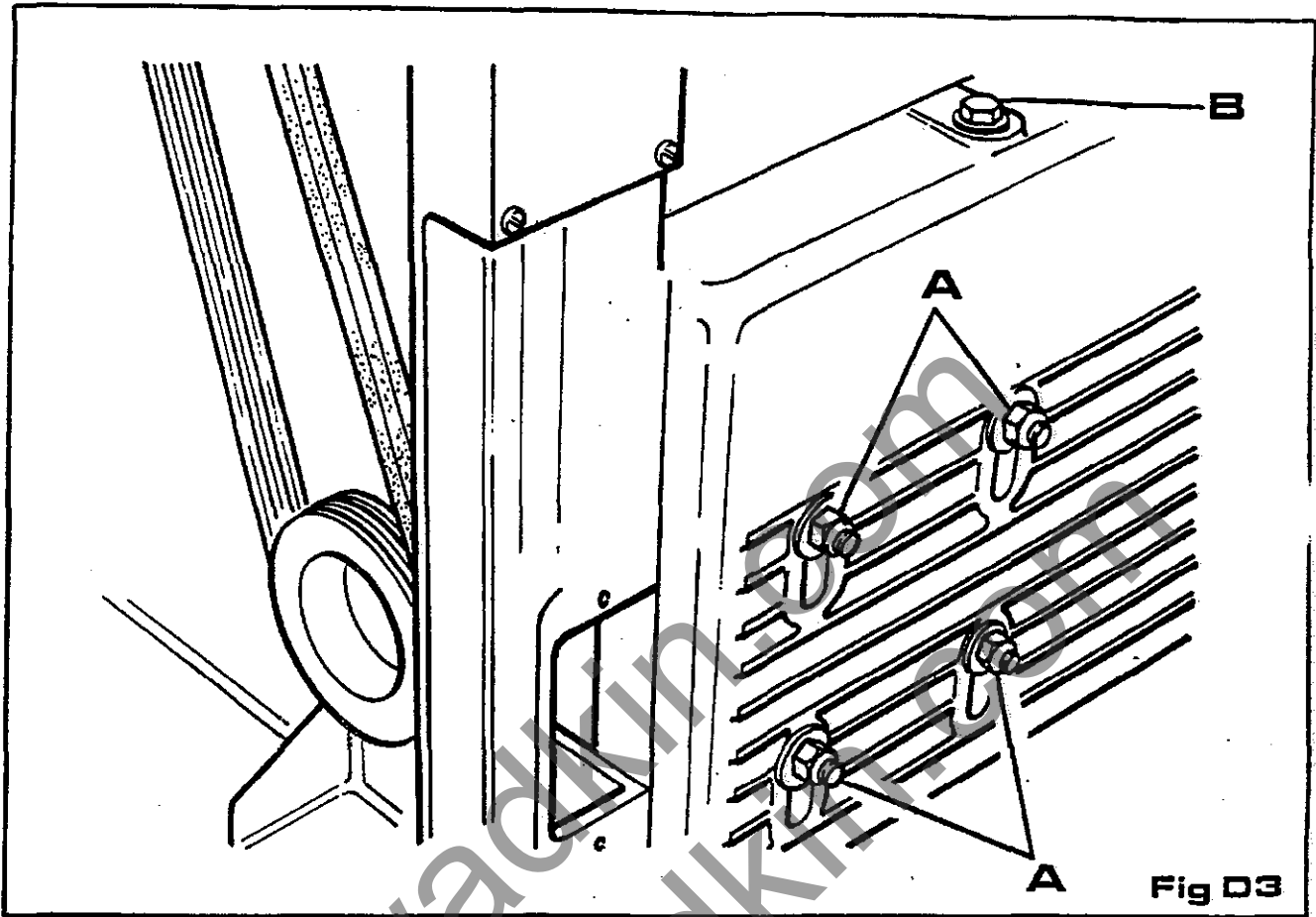


Fig D3

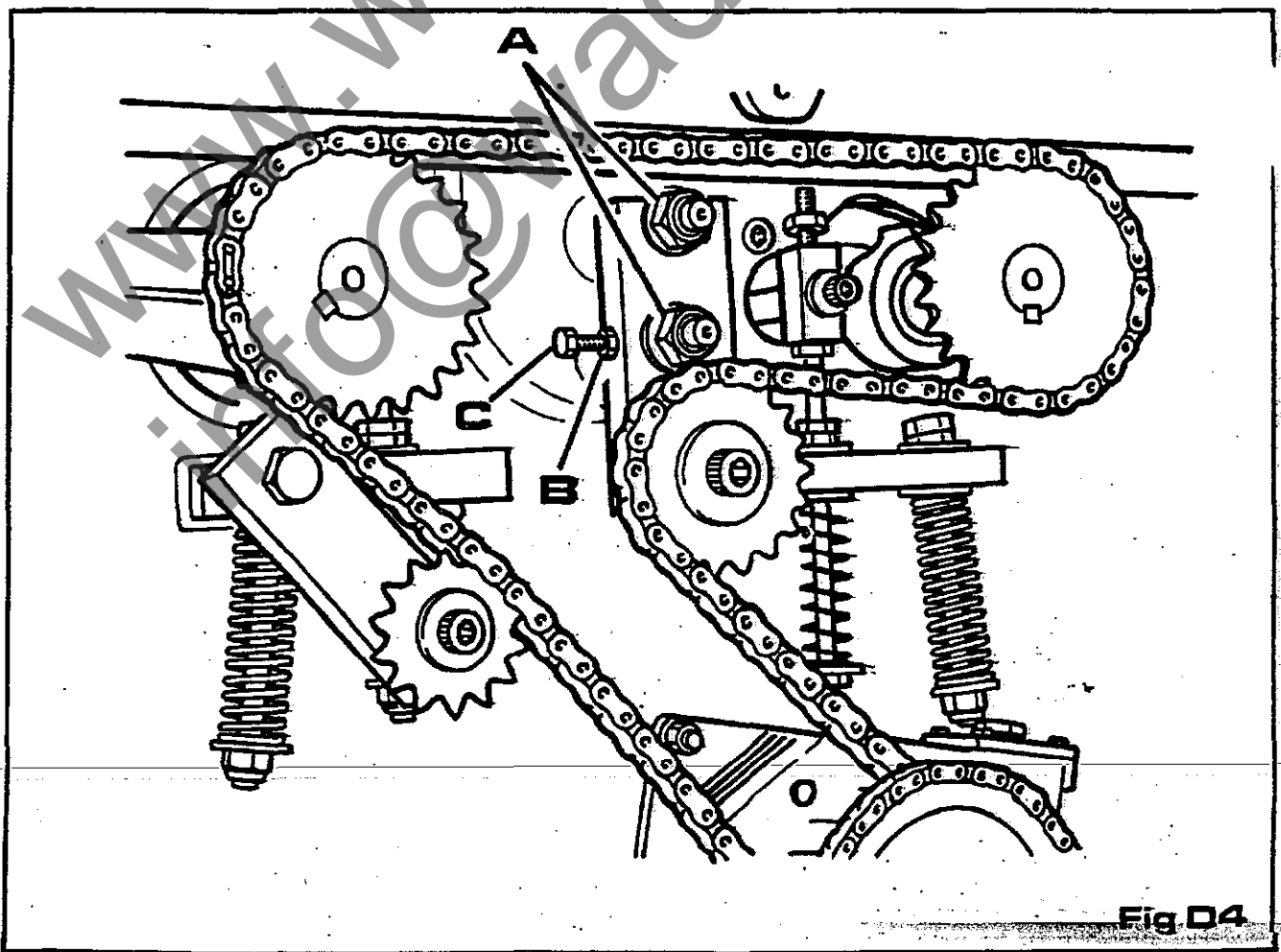


Fig D4

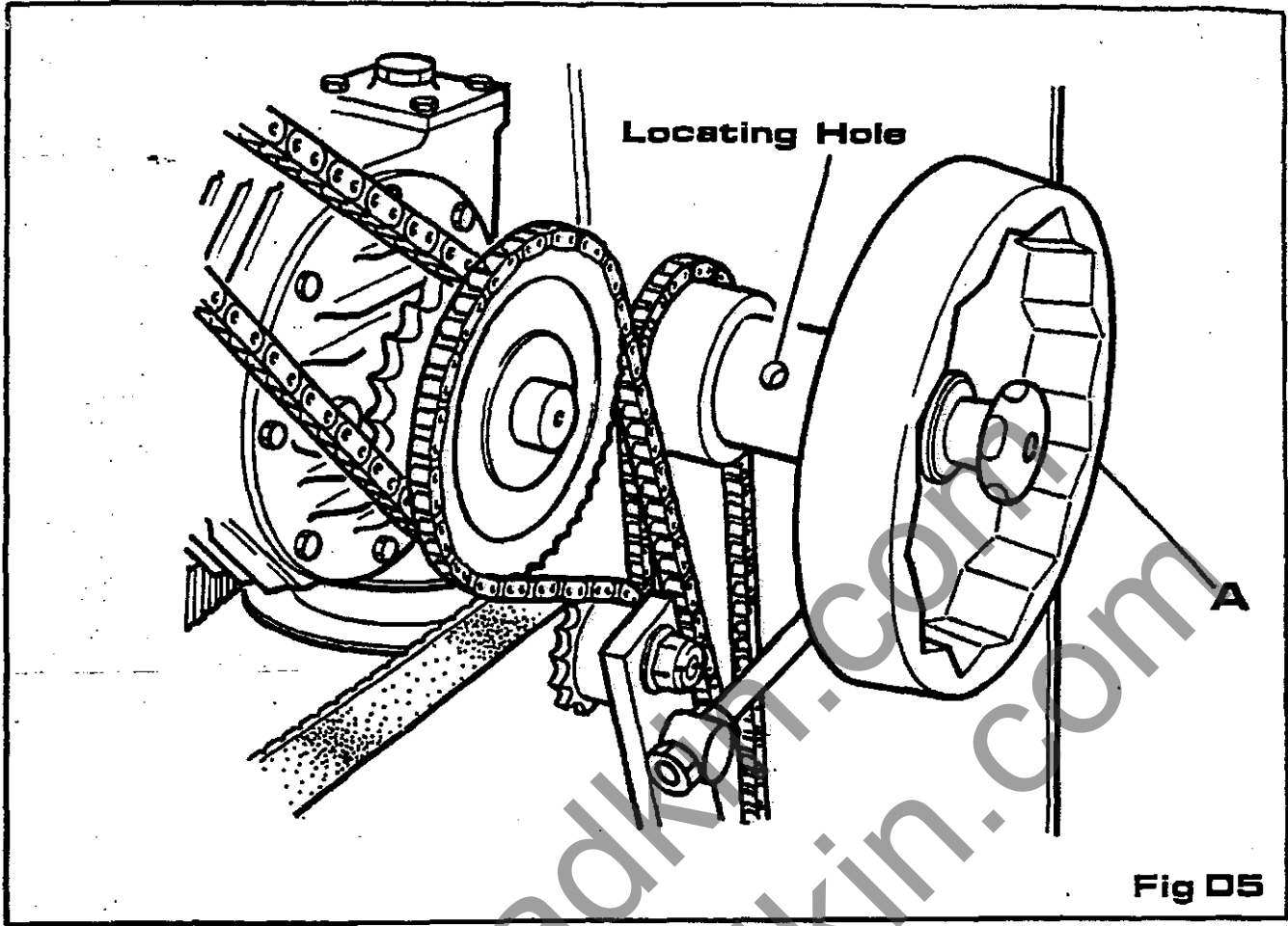


Fig D5

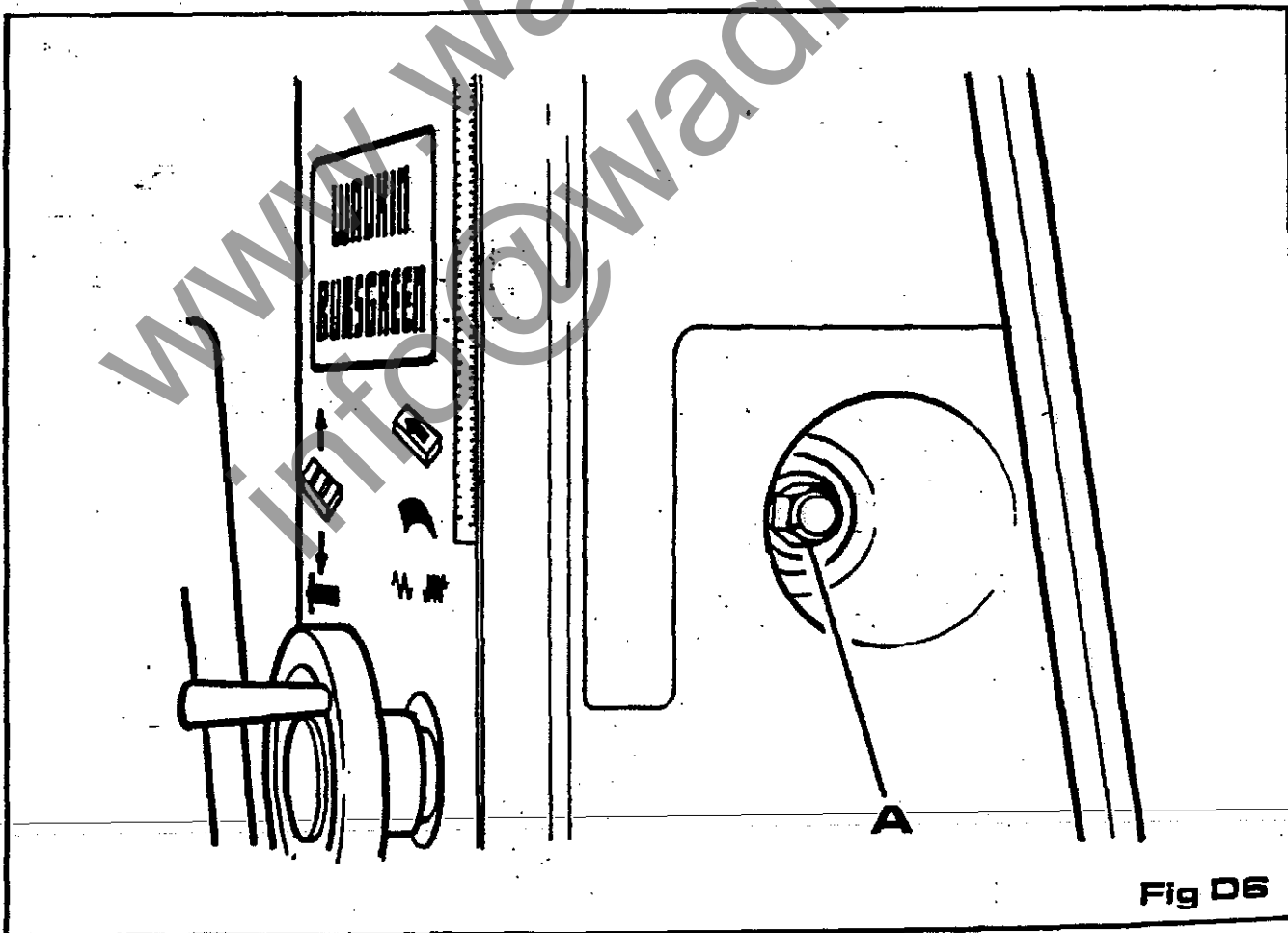


Fig D6

WORM GEARBOX TO CLUTCH CHAIN TENSION FIG. D7.

Slacken hexagon locknut "A" and adjust hexagon locknut "B" until chain tension is correct, i.e. chain should not be run either too slack or too tight.

When chain is correctly tensioned relock hexagon locknuts "A" and "B".

CUTTER SETTING - FIG.D8

The knife is held in the cutterblock by a wedge, into which is fitted spring loaded balls, these balls hold the knife finger tight whilst the 9-M12 hexagon head screws are loose. This allows both hands to be free to adjust the blade and ensure that it will not slip back during setting or move whilst the wedge screws are being tightened up. Should any other method of cutter setting be employed the amount of cutter projection must correspond exactly with that given by the setting gauge supplied and failure to observe this instruction will result in bad feeding and poor finish.

To remove the knives and re-set with the "BURSGREEN" knife setting gauge, proceed as follows:-

- 1 Turn the cutterblock to approximately the position shown in FIG.D8 and loosen the 9-M12 hexagon head screws, carefully remove knife from cutterblock.
NOTE: When grinding it is most important that knives are ground dead straight and balanced in pairs or sets.
An efficient re-grinding service is available, charges are moderate and service prompt. To avail yourself with this service, return knives to BURSGREEN (DURHAM), FENCE HOUSES, TYNE & WEAR.
- 2 To re-set the knives the cutterblock should be in the approximate position shown in FIG.D8. Place knife in between wedge and cutterblock with the blade drawn forward slightly.
- 3 Carefully secure the knife setting device 'A' (which when not in use is normally secured to the rear of the machine table), to the cutterblock with the three knurled locking screws 'B' as shown in FIG.D8.
- 4 Whilst turning these locking screws 'B' FIG.D8, knife will be lowered to correct setting which is reached when knurled screws are locked in position and knife just touches knife setting device.
- 5 When the knife is correctly set, tighten the 9-M12 hexagon head screws, remove knife setting device then securely lock the 9-M12 hexagon head screws.
- 6 Rotate cutterblock until the next knife is in position and repeat the procedure until all the knives have been set.
- 7 When changing knives it is advisable to check that all the locking screws are adequately lubricated and quite free. Periodically examine for damage or cracks. Any doubtful screws should be replaced and all screws well lubricated with "Molyslip" or similar oil, before replacing.

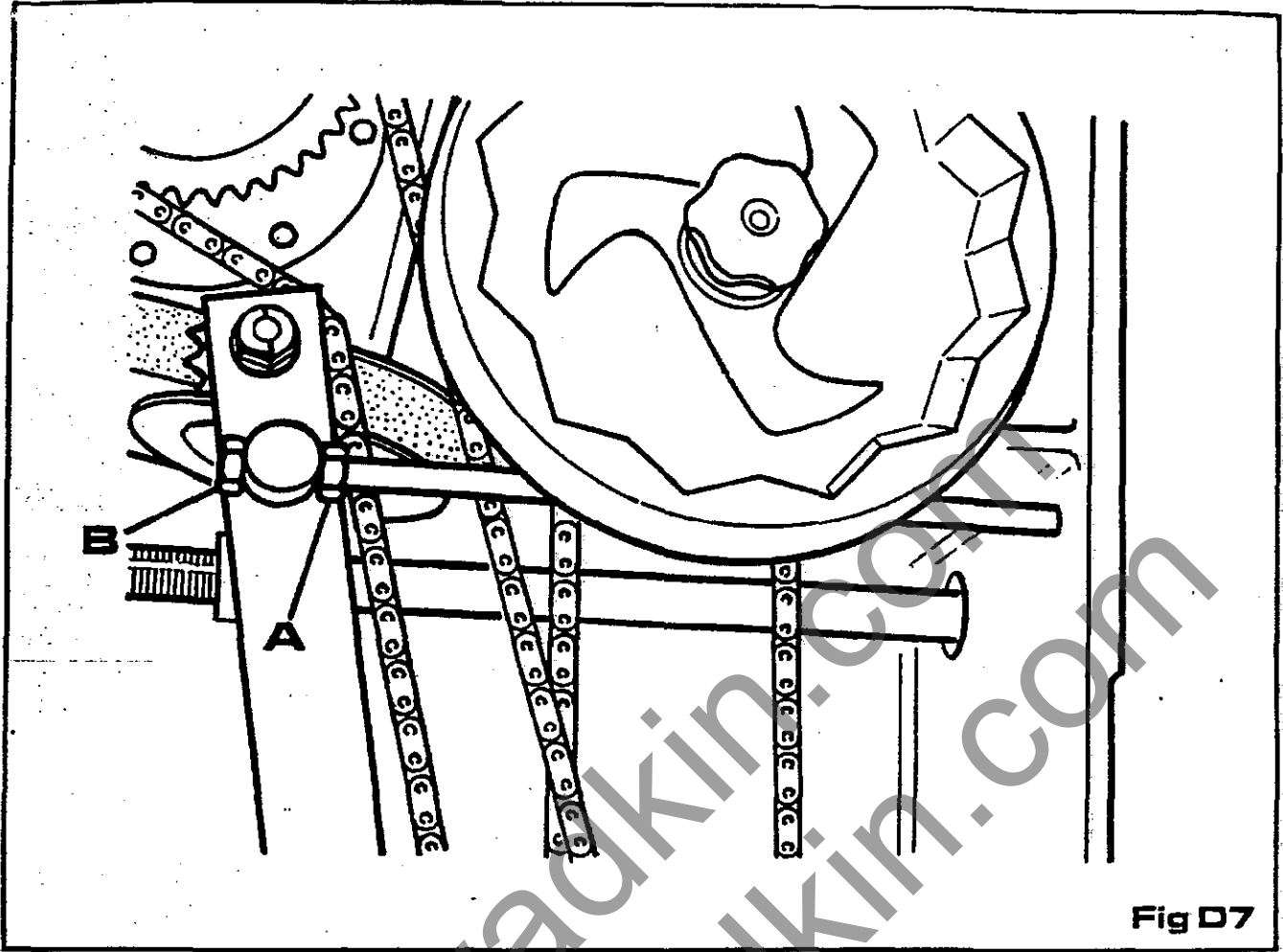


Fig D7

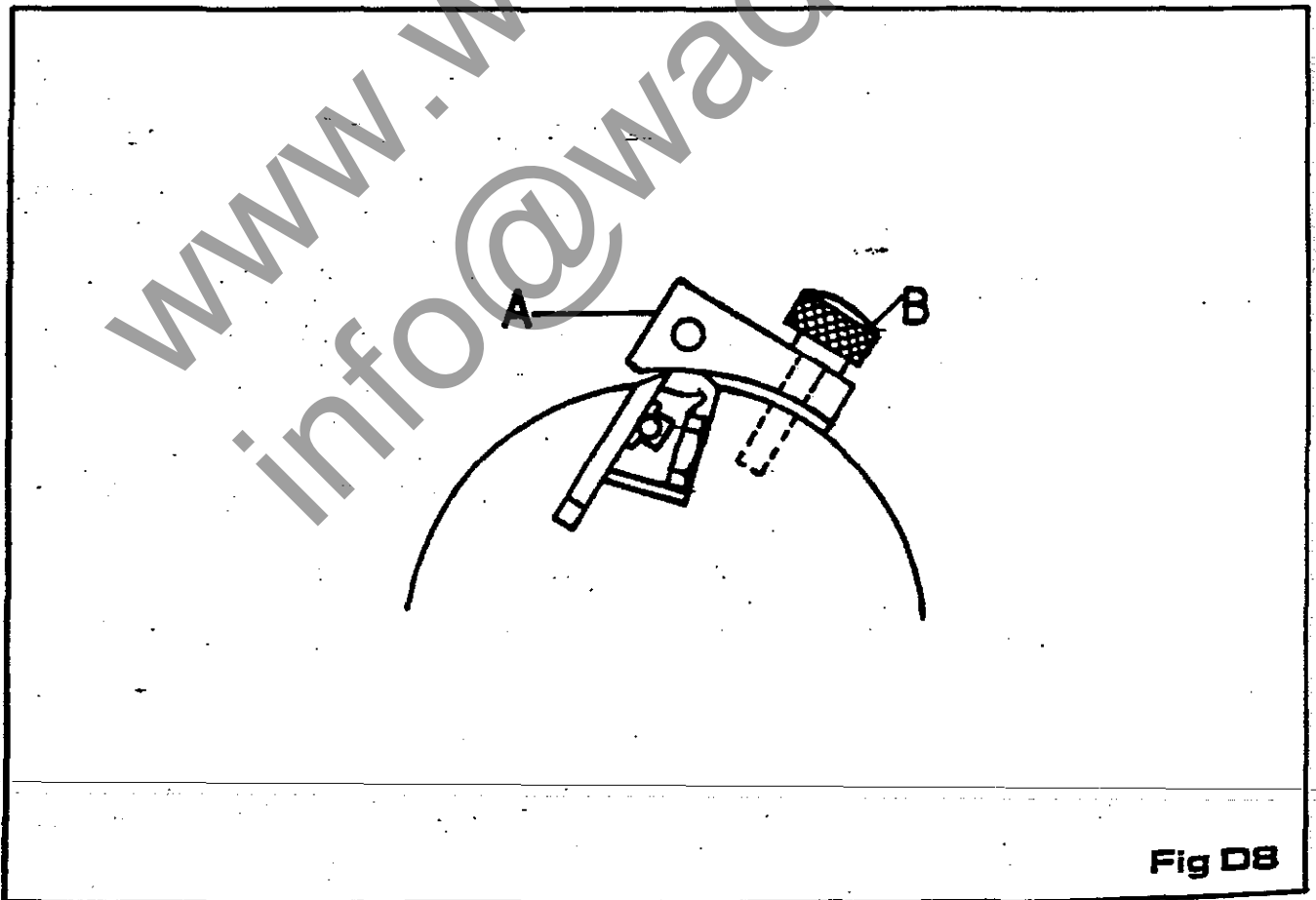


Fig D8

CUTTER CARE

FIG. D9.

The cutters supplied are 637mm long x 30mm wide x 3mm thick in balanced sets. They should be kept in balanced sets by ensuring that the cutters have equal dimensions after grinding and that the cutting edge is straight and parallel to the back edge.

For general work, knife angles for soft and hard woods are recommended as in FIG. D9. (a) and (b).

When a very fine finish is required in dry soft and hard woods a slight front bevel is given as in FIG. D9.(c) and (d). For wet or green timber the cutting bevel may be decreased five degrees, but the front bevel should not be given.

Keep the cutters sharp when in position by using a fine grade oil stone dipped in paraffin.

Allow the stone to rest lightly and flat on the bevel and pass over the cutter with a rotating action a few times. Give about two strokes on the full length of each knife on the face side to remove all burrs from the cutting edge.

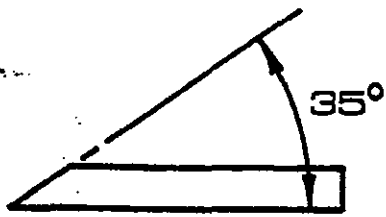
Do not allow a heel greater than .79mm (1/32") wide on the bevel before removing and regrinding. When the heel becomes too wide the knives may heat up or have a hammering effect on the wood and more than normal power will be required to run the cutterblock.

SETTING THICKNESSING TABLE PARALLEL TO CUTTERBLOCK

The machine table is accurately set parallel to cutterblock before despatch but should it be disturbed for any reason it must be carefully checked and made parallel to the cutterblock, if necessary, by the following procedure.

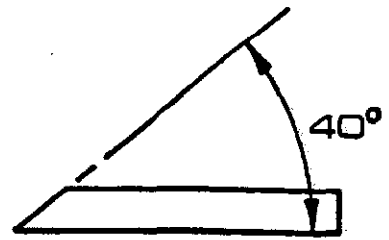
1. Feed a short length of timber approximately 50mm (2" square) x 460mm (18" long) through the machine to one side of the thicknessing table.
2. Without adjustment to the height of the table feed the timber through the machine again on the opposite side of the table to that in item 1.
3. If a cut is taken or it does not touch the wood adjust the fine thread adjusters on the underside of the table to suit and when set tighten all screws.

As the knife setting device sets the knives parallel to the cutterblock it is vitally important that the table is set parallel to the knives for accurate thicknessing.



A

for soft wood

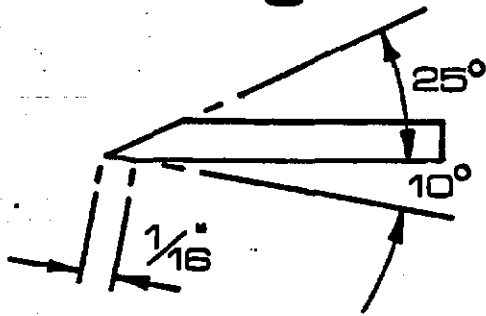


B

for hard wood

for dry soft wood

C

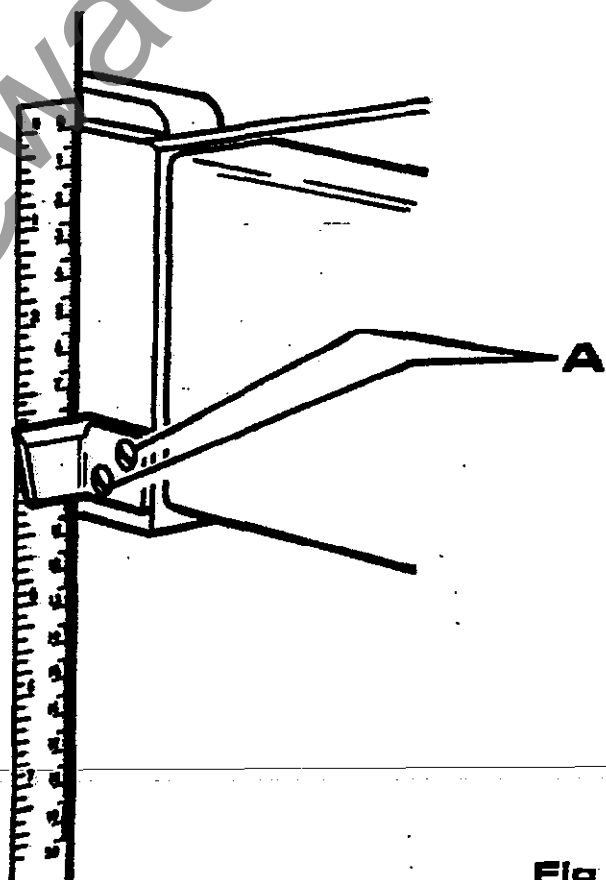


for dry hard wood

D



Fig D9



**DKIN
REEN**

Fig D10

THICKNESSING RULE FIG. D10.

The pointer on the machine table is pre-set before despatch. Should it be disturbed, feed a piece of timber through the machine and measure the thickness accurately. Check that the reading given by the pointer corresponds to the thickness of timber machined. Should adjustment be necessary slacken the screws "A" in FIG. D10. and set pointer to the correct thickness.

GENERAL HINTS

1. When thicknessing long lengths of timber always support after the machine table, otherwise a step will appear on either or both ends.
2. When a smooth finish is required use the slow feed speed. For roughing when the finish is not important use the fast feed speed.
3. For the best results always feed the timber to cut with the grain.
4. Should the timber stick when thicknessing two probable causes are given below:
 - (a) The table rollers are set too low in the table.
 - (b) The spring pressure is too great on the pressure bars and too little on the feed rollers.

BTJ KNIFE JOINTING & GRINDING INSTRUCTIONS

www.wadkin.com
info@wadkin.com

BTJ KNIFE JOINTING & GRINDING INSTRUCTIONS

In order to ensure that all the knives in the cutterblock are actually cutting and each doing its share of work per revolution of the spindle, it is essential they all run in one common circle at the cutting edge. To give the operator the desired means of obtaining the accuracy required, a combined knife grinding and jointing device is fitted on a slide attached to the top of machine.

NOTE: It is possible to joint and grind the knives 3 or 4 times before resetting with the setting gauge supplied with the machine. See Page 19 of the BT Instruction Manual.

To Joint the knives proceed as follows:-

1. Stop cutterblock by cutterblock stop button on control panel then swing combined chip deflector/safety guard "A" clear, as shown in FIG 1.
2. Unscrew knurled knob and move cutterblock pulley guard "B" to position shown in FIG 1 and secure with same knurled knob "C".
3. Remove two socket head capscrews and lift chip deflector baffle (which covers top of cutterblock) from the machine.
4. Ensure the jointing stone "D" and grinding wheel "E" are raised clear of the cutterblock by releasing the locking levers "F" and "G" and adjusting handwheels "H" and "I". Relock locking levers "F" and "G".
5. Start cutterblock running and allow to attain full speed.
6. Very slowly and evenly traverse the device across the cutterblock by handle "J". Release locking lever "F" and adjust handwheel "H" until the stone touches the knives and gives off a very light spark.
7. This operation is carried on very lightly until the knives appear to be in a true circle. Stop cutterblock at intervals for examination. A slight flat or heel as shown in FIG 2 will be produced thus ensuring that all the knives are cutting equally.
The jointing operation may be performed two or three times before regrinding, but never allow a heel greater than $1/32"$ (.8mm) wide on the bevel.
8. When jointing operation is complete, push jointing/grinding unit clear of cutterblock by handle "J" in FIG 1. Relock locking lever "F".

After jointing operation inspect all knives edges to check the width of heel on the bevel. If the heel is greater than $1/32"$ (.8mm) wide then the back bevel of the knife must be ground to ensure the minimum possible heel on each knife.

To grind each knife proceed as follows:-

1. Rotate the cutterblock carefully by hand until it can be locked securely with the lever "A" in FIG 3 in the Cutterblock Locked position.

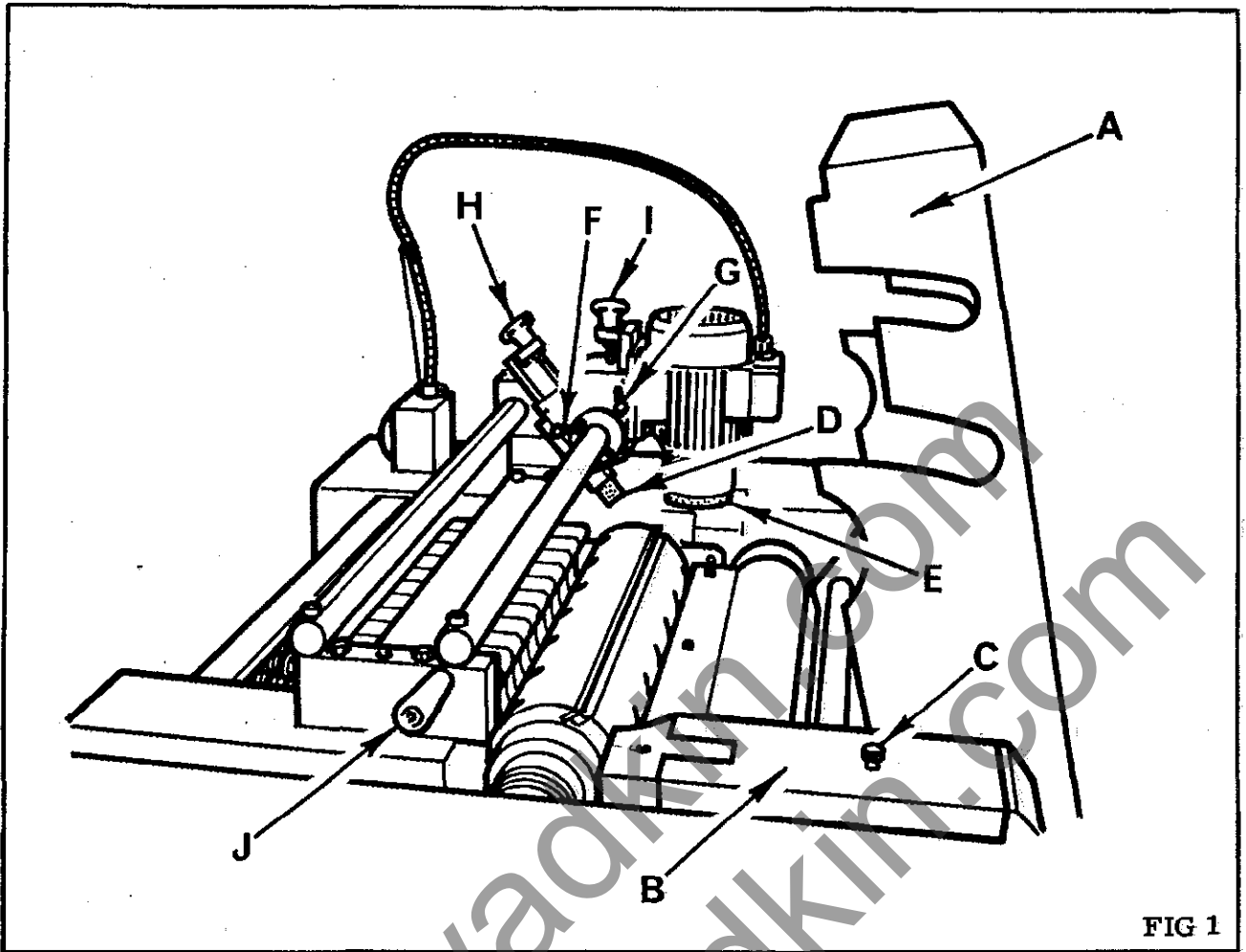


FIG 1

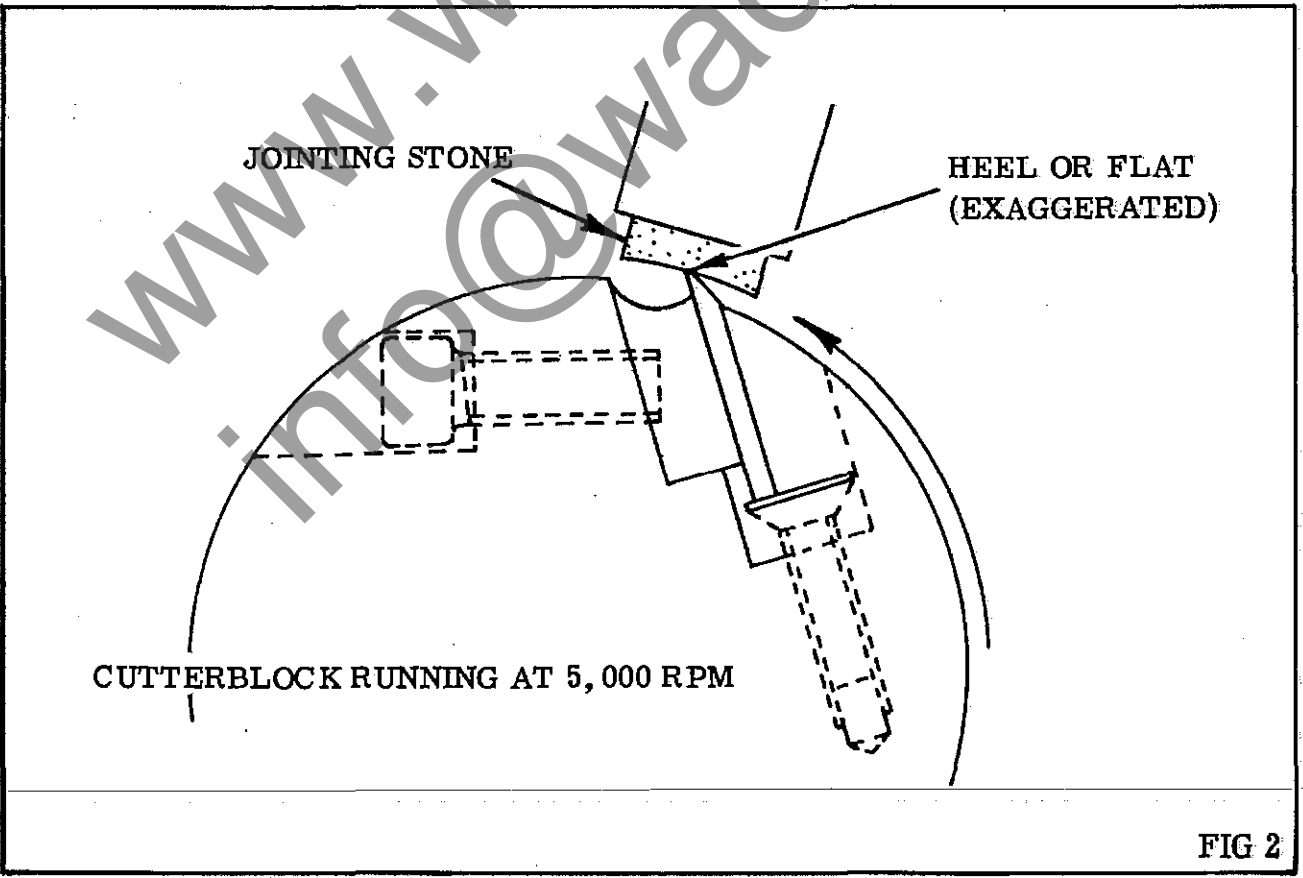


FIG 2

2. Start the grinder spindle by the switch "B" and release locking lever "C" then carefully adjust handwheel "D" until the grinding wheel just touches the back bevel of the knife.

IMPORTANT When grinding take light cuts and traverse rapidly.

3. Traverse the grinder across the cutterblock two or three times until the land is just visible on the knife edge and finish with the grinding wheel clear of the cutterblock.
4. Repeat on all knives.
5. When grinding is completed, move lever "A" in FIG 3 to "NORMAL RUNNING" position.
Replace chip deflector baffle and guards "A" and "B" in FIG 1.

IMPORTANT

DRESSING OF CIRCULAR GRINDING STONE

Keep the grinding face on the circular grinding stone to within 1/8" (3mm) wide as shown in FIG 4. This will ensure accurate and clean grinding of knives.

To dress the grinding stone proceed as follows:-

1. Release lock "C" in FIG 3 then by turning vertical adjustment handwheel "D" remove motor complete with vertical slide from grinder support bracket "E".
2. Rest motor on top of the machine sideframe.
3. Holding motor securely, start motor and proceed to dress the internal lip of the grinding wheel with a dressing stone or dressing wheel.
4. Dressing operation is complete when the lip on the circular grinding stone is 1/8" (3mm) wide as shown in FIG 4.
5. Reverse procedure No. 1 to refit motor and slide to bracket.

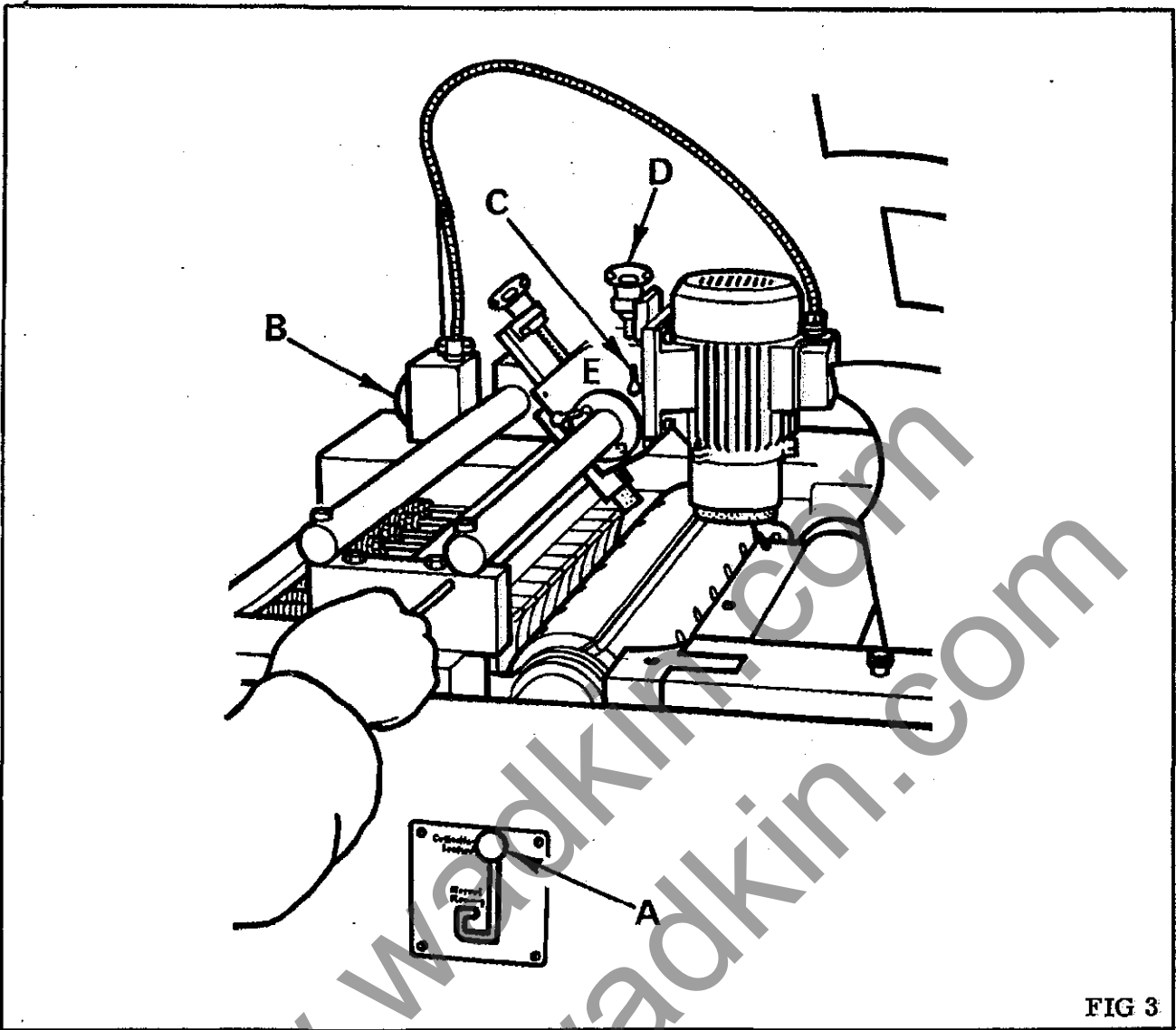


FIG 3

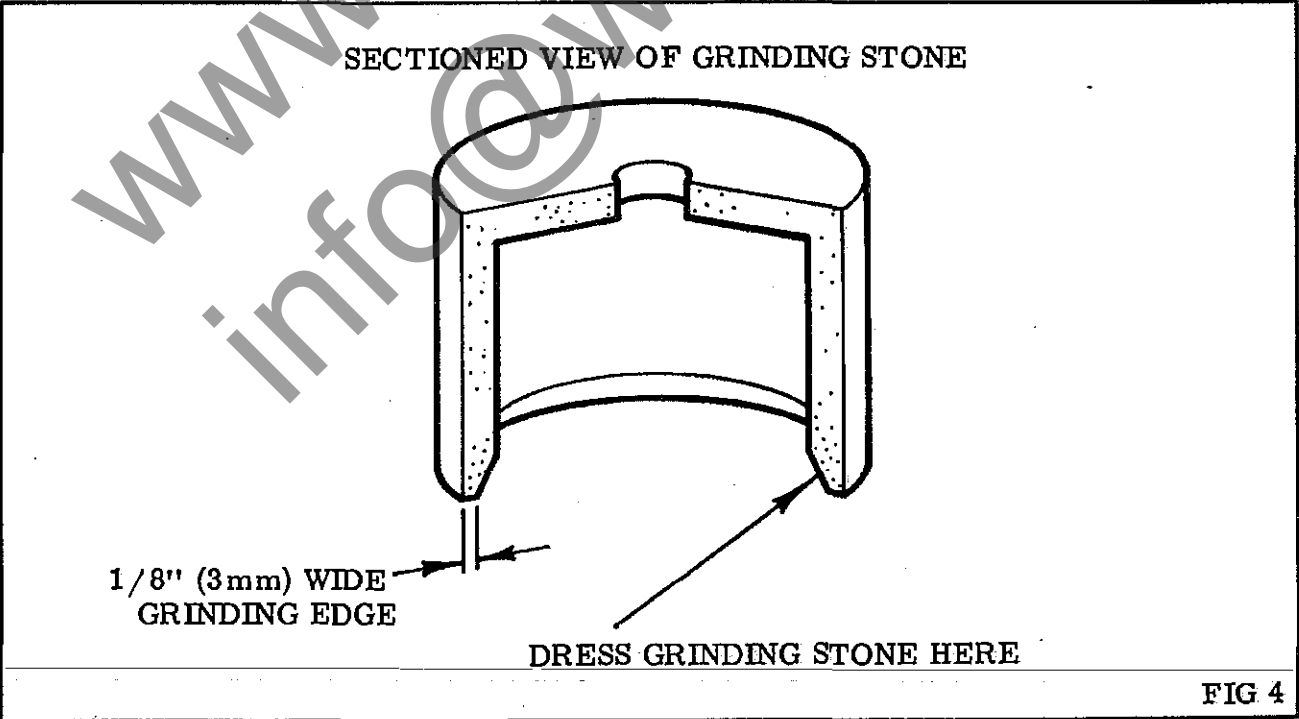
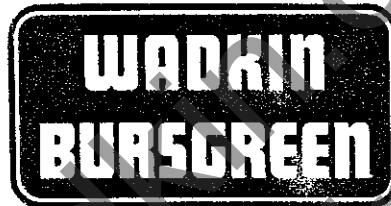


FIG 4

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.

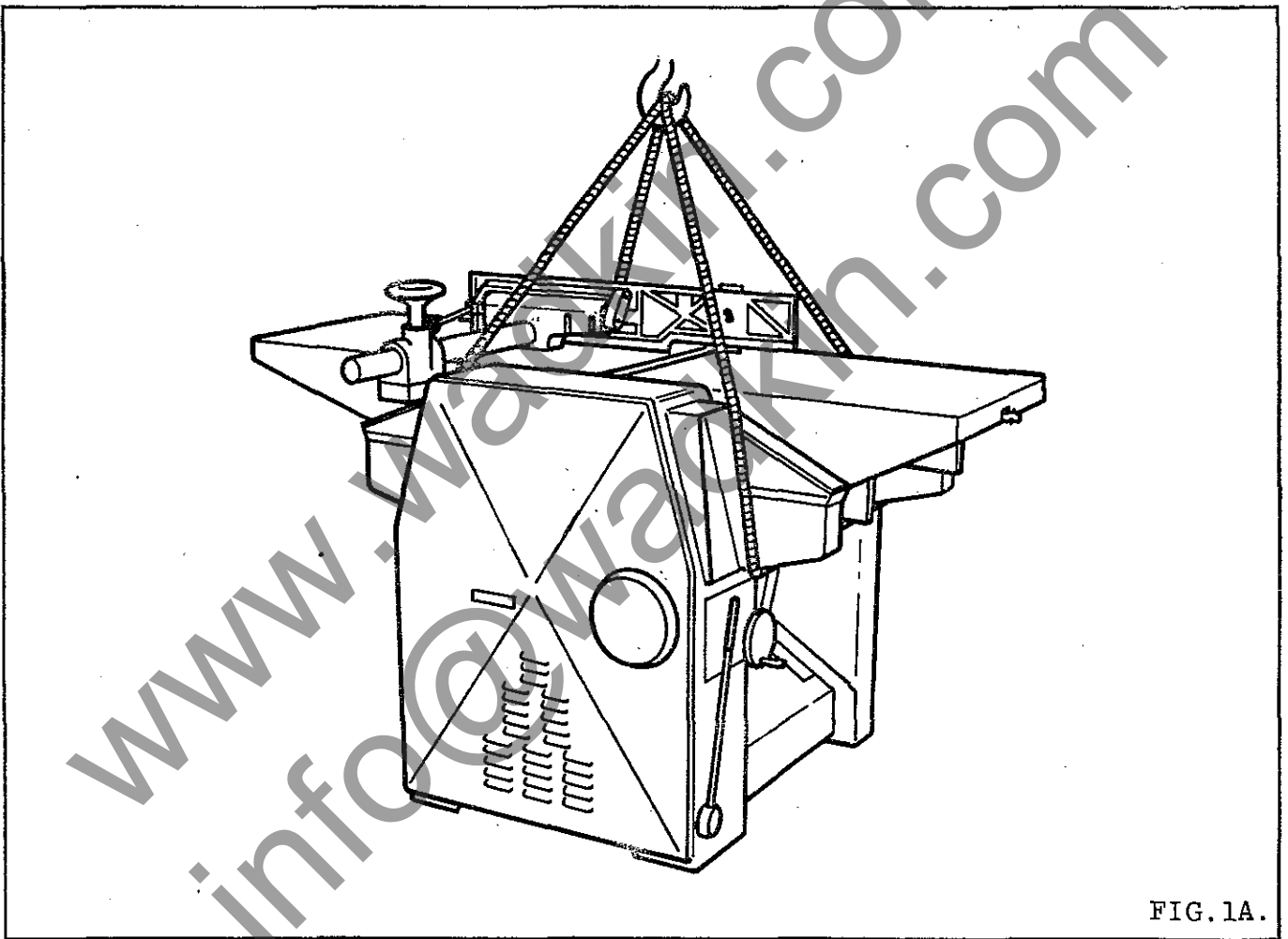


FIG.1A.

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 thicknessing 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.

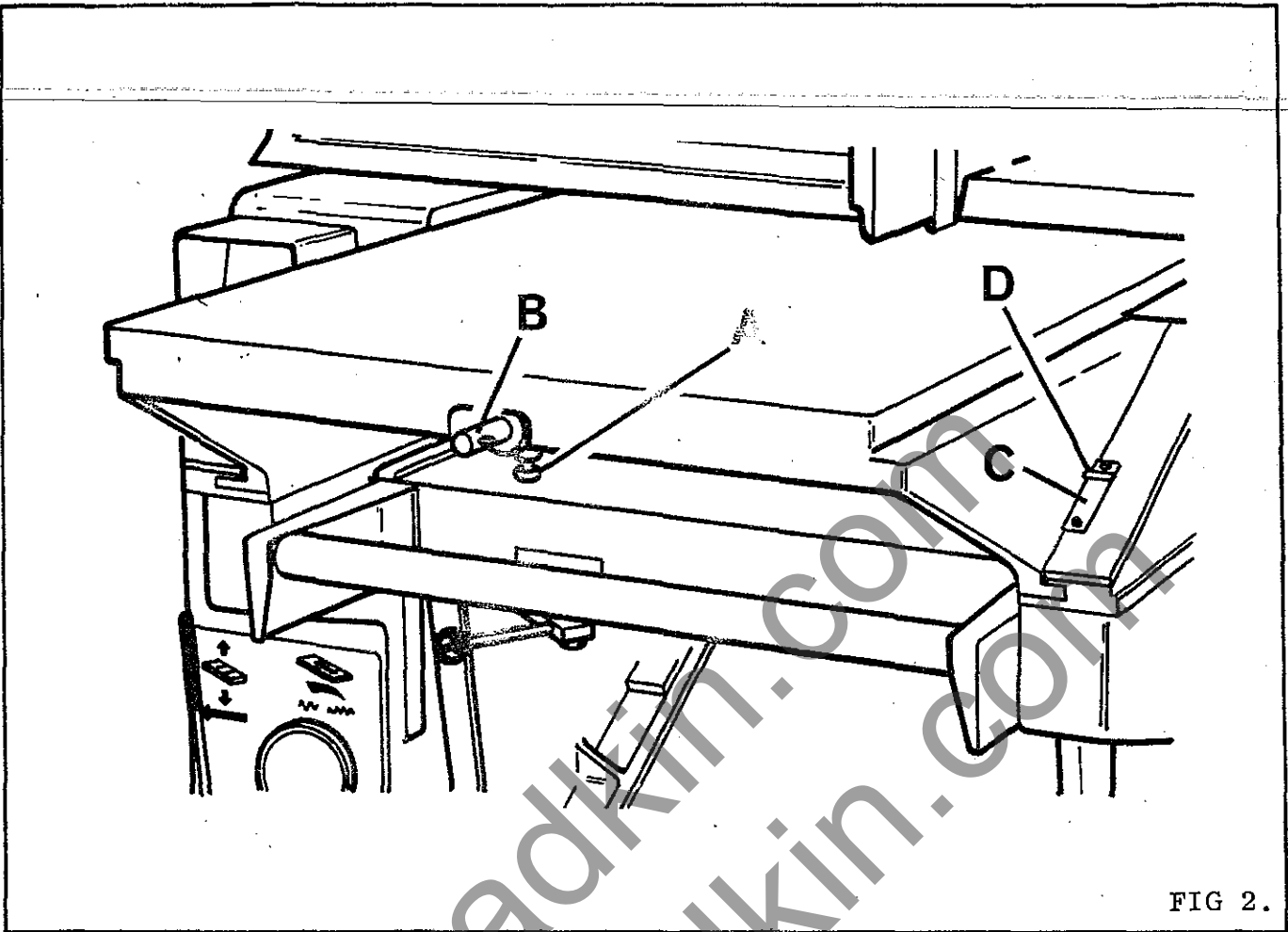


FIG 2.

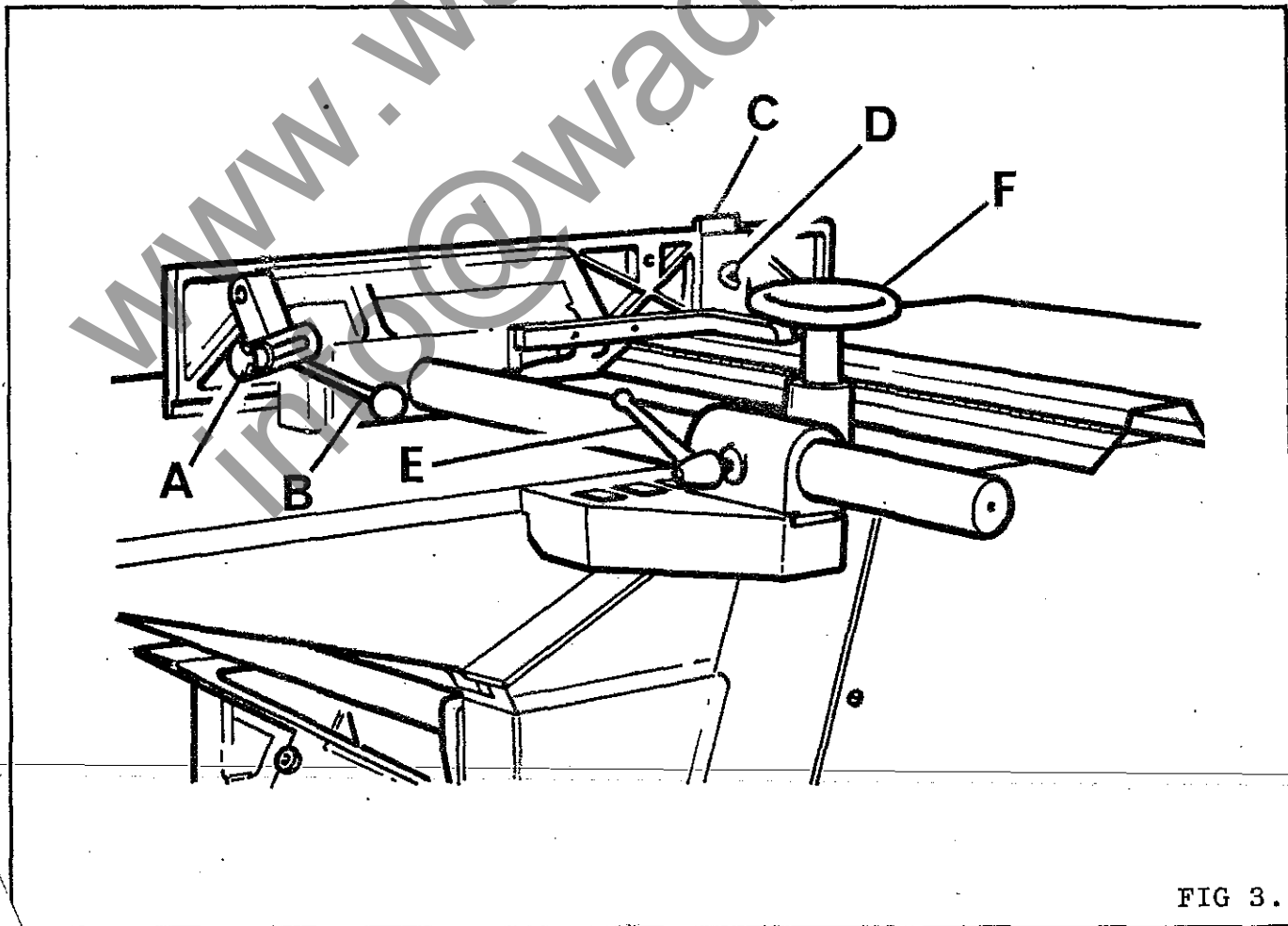


FIG 3.

TO CHECK THE FENCE, FOLLOW THE UNDERMENTIONED 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.

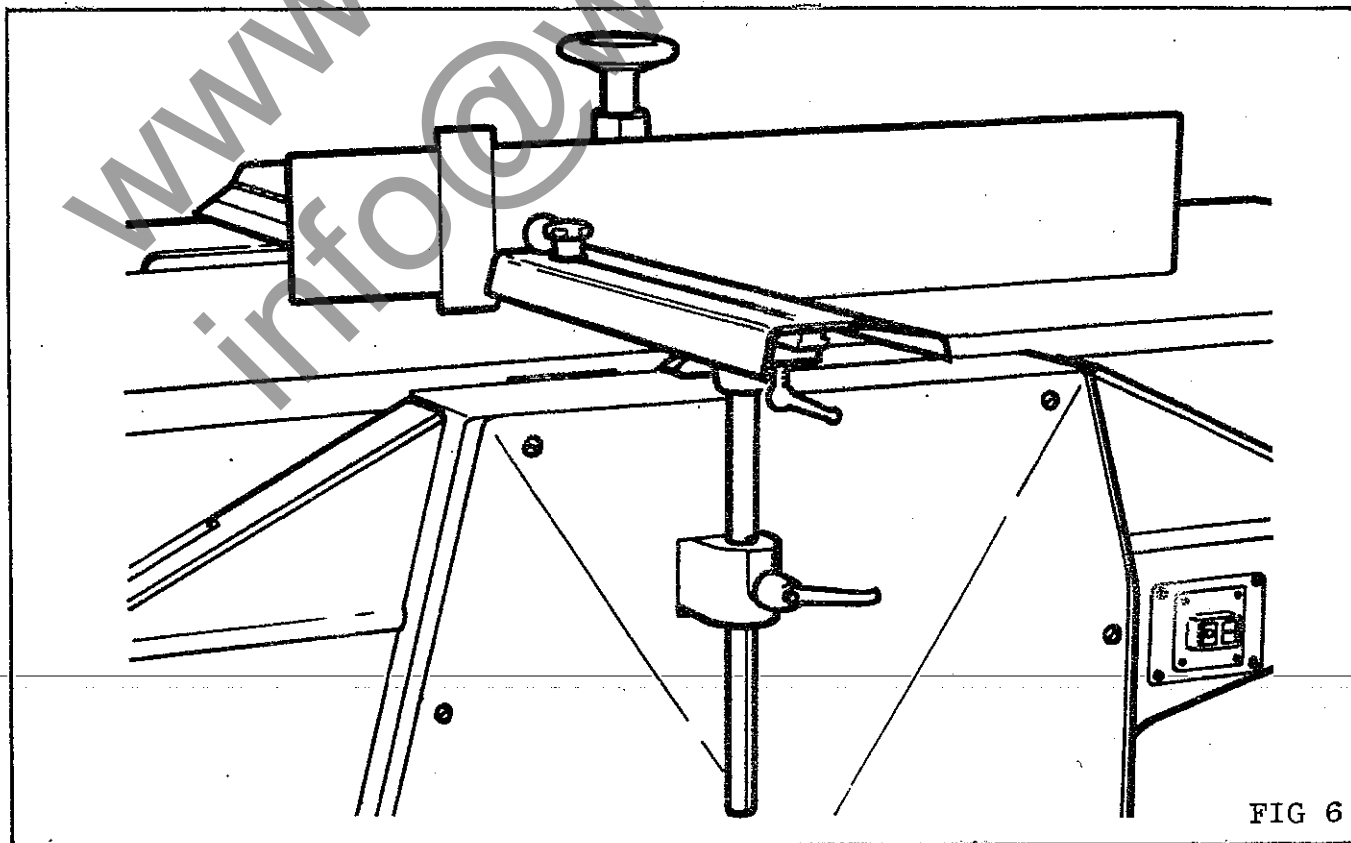
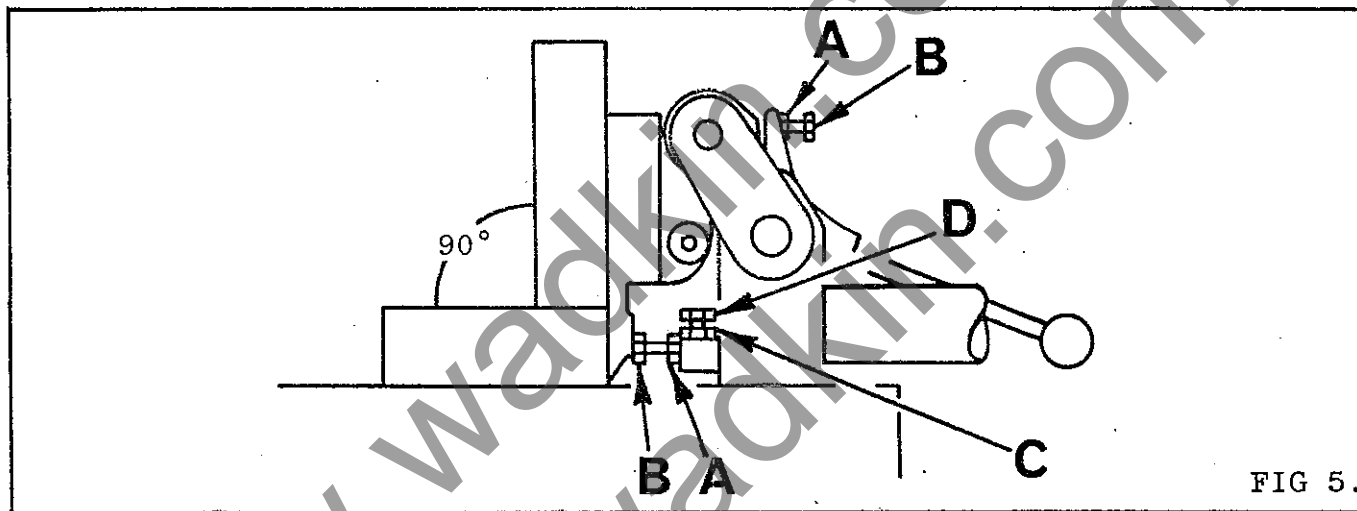
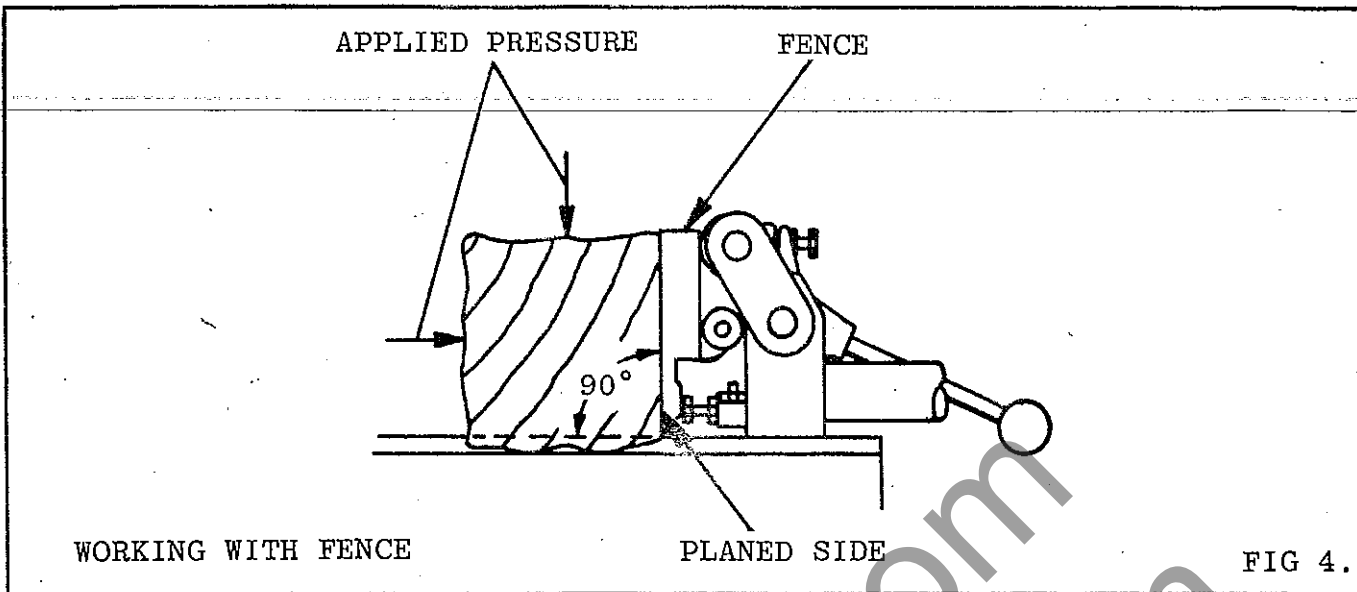
IMPORTANT: Stop machine before adjusting guards.

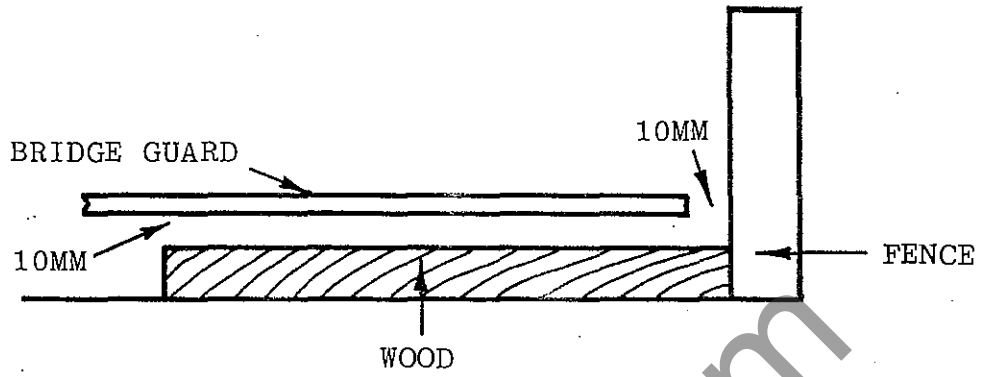
For correct cutterblock guard positions see FIG. 7, FIG. 8 and FIG. 9.

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

GENERAL HINTS FOR SURFACE PLANING

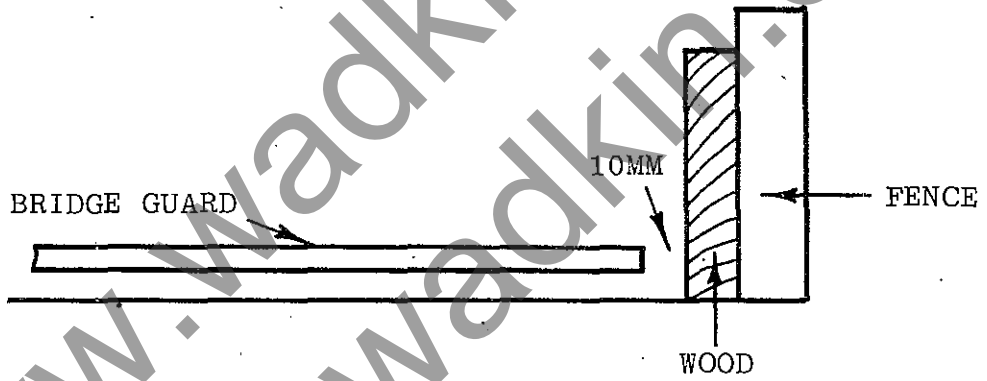
1. To obtain the best surface finish always ensure that the direction of grain runs with the cutterblock as in FIG. 11.
2. To obtain a perfectly flat surface, especially with warped stock always put maximum pressure on the back table at "A" in FIG. 12 and as little as possible on the front table at "B".
3. Greater pressure will be required when surfacing bad grained timber otherwise chattering will take place resulting in a course 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.





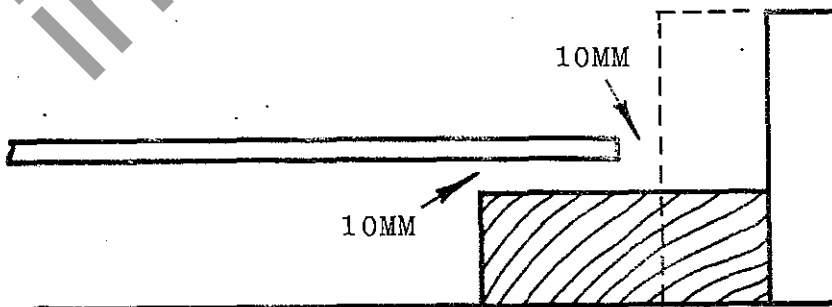
GUARD ADJUSTMENT FOR FLATTING

FIG 7.



GUARD ADJUSTMENT FOR EDGING

FIG 8.



GUARD ADJUSTMENT FOR FLATTING AND EDGING
CARRIED OUT ONE AFTER THE OTHER

FIG 9.

