BOOK No. B408M

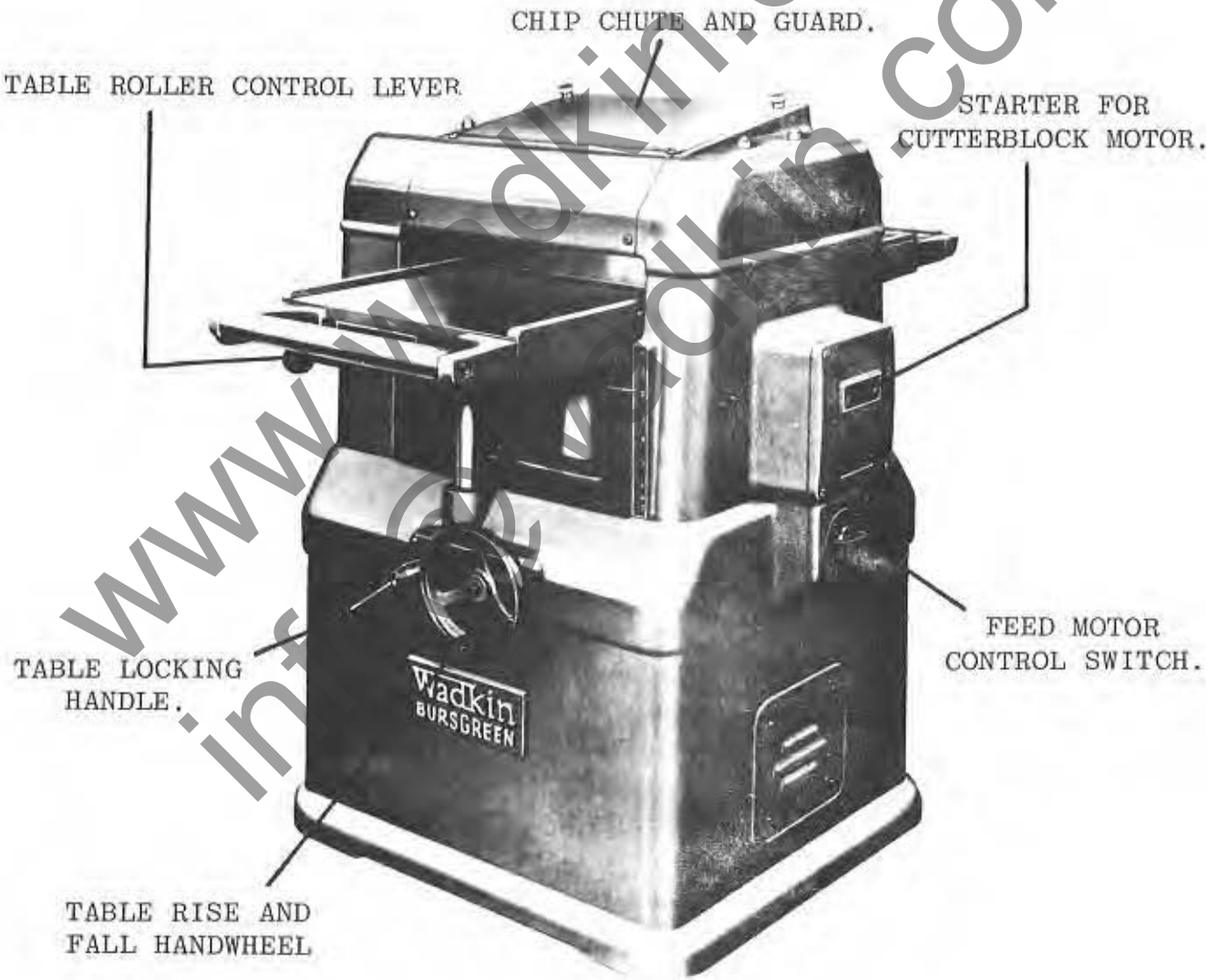
Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

PLEASE INSERT SERIAL NUMBER OF MACHINE

INSTRUCTION MANUAL FOR

12" BAO

Roller Feed Planer & Thicknesser



FOR REPLACEMENT PARTS, TOOLS & ACCESSORIES
CONTACT BRIAN STACEY
Telephone: Fence Houses 2385 (5 lines) Telex: 53441 (Bursgreen Duram)

HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.

2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.

3. Only personnel trained in the safe use of a machine should operate it.

4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.

5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

oOo

WADKIN LTD · GREEN LANE WORKS · LEICESTER LE5 4PF · ENGLAND · TELEPHONE 0533 769111
and York House, Empire Way, Wembley, Middlesex HA9 0PA
Telephone: 01-902 7714 Telex: 262210
Telex: 34646 (Wadkin Leicester)
Telegrams: Woodworker Leicester Telex

SAFETY

1. Read Instruction Book.
2. Securely Lock Cutters.
3. Set Guards Correctly.
4. Select Correct Speed.
5. Use Feeding Devices Where Possible.
6. Refer To HSW Booklet No.41. (in UK) For Safety In The Use Of Woodworking Machinery.

BURSGREEN (DURHAM) LIMITED
APPROVED LUBRICANTS

Application	Approved Lubricant					
	Castrol	B. P.	Shell	Esso	Texaco / Caltex	Wadkin
Worm Boxes	Alpha 617	Energol CS425	Vitrea 75	Pen-O-Led E. P.3	Regal Oil J	L. 2.
General Lubrication	Magna ED	Energol HP. 20	Vitrea 33	Esstic 50	Ursa Oil P. 20	L. 4.
Pneumatic Lubricators	Hyspin AWS 32	Energol HL 65	Tellus 27	Nuto H 44	Rando Oil HDA	
Grease	Spheerol AP. 3	Energrease LS. 3	Alvania 3	Beacon 3 Starfak Premium 3	Regal	L. 6.
Brake Cables	Brake cable grease	Energrease L21M	Alvania 3	Multi-purpose grease H		

SPECIFICATION

Length of thicknessing table.	28"	710mm
Overall length including outer rollers..	35½"	900mm
Capacit of machine....	12⅜"wide x 7" deep	310mm x 180mm
Cutting circle diameter of cutter lock..	4"	100mm
Speed of cutterblock...	5,000 rpm	5,000 rpm
Number of cutters:		
Standard..	2	2
Optional extra	3	3
H.P. of cutterblock motor....	3	3
S.n speed of cutterblock motor:		
50 cycles.	3,000 rpm	3,000 rpm
60 cycles.	3,600 rpm	3,600 rpm
Diameter of feed rollers	2"	50mm
Feed speeds per minute:		
3 phase...	15 & 30ft.	4,5 & 9m
1 phase...	22ft.	6.7m
Floor space.	35½" x 25½"	900mm x 650mm
Net weight.	620 lb.	275 kg.

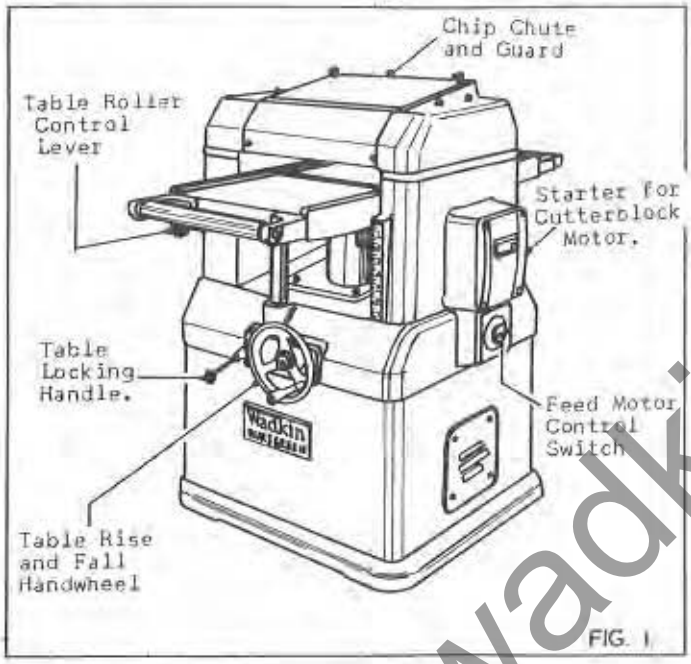
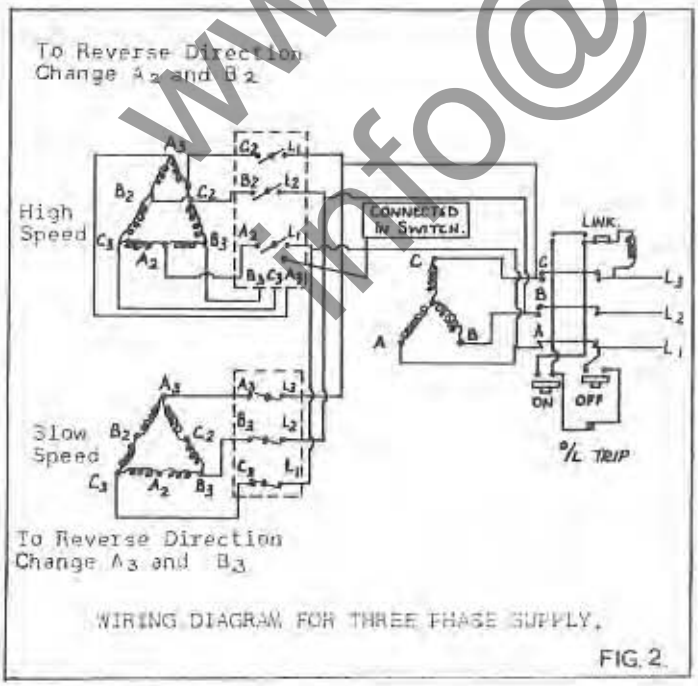


FIG. 1

INSTALLATION

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

When machine is cased for export, the outer table rollers and rise and fall handwheel are removed and packed in the parcel. Remove and re-assemble as shown in Fig. 1.



WIRING DIAGRAM FOR THREE PHASE SUPPLY.

FIG. 2.

WIRING DETAILS

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the starter.

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. See Fig. 2 for three phase supply.
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 single phase supply refer to booklet supplied with starter for wiring details.

Voltage	Phase.	S.W.G. Tinned Copper Wire	Amps
550/400/440	3	23	20
380/420/340/380	3	22	24
220	3	21	29
200 - 250	1	17	65

Fuse capacity should not exceed three times full load current of machine.

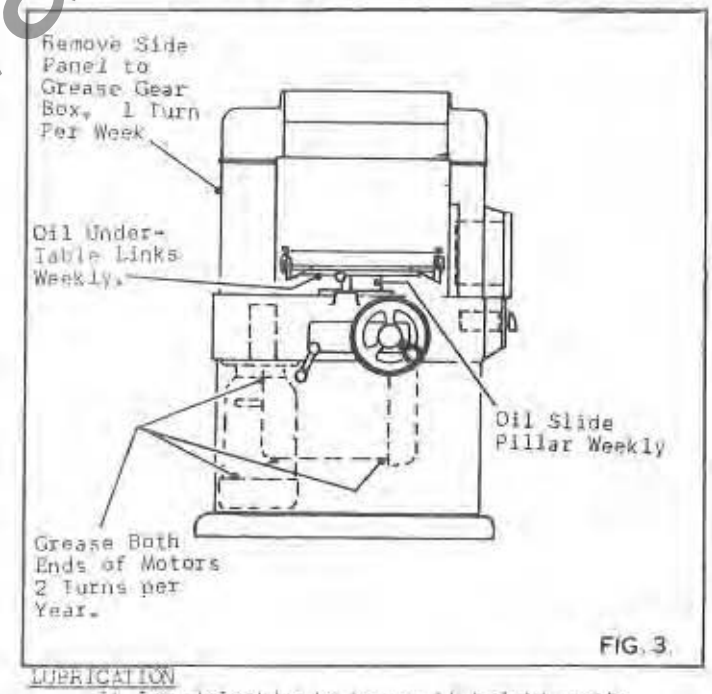


FIG. 3.

LUBRICATION

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

TYPE OF OIL RECOMMENDED POWER EN. 125
TYPE OF GREASE RECOMMENDED SHELL ALV.N1A3.

All adjustments and alignments listed below have been carefully set and checked and the whole 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.

TABLE ROLLERS

The anti-friction table rollers or bed rollers revolve on sealed for life ball bearings which require no lubrication. On machines prior to serial no. 63457 rollers were individually adjusted by set screws under the bearing blocks and should be adjusted to suit the relevant working conditions. On all machines after this number, the rollers are automatically adjusted in relation to the table surface by a single operating lever at the infeed end of the table.

A calibrated scale (O - 3) above the lever indicates the relevant positions, a guide to which is as follows:

At Min. O

Rollers are level with table surface and only very fine cuts on selected pre-machined timber are generally possible on this position. Feed permitting, however, very accurate skip free planing can be carried out in this position.

Positions 1 and 2.

These positions are the normal ones for general use, combining good feeding with first class results.

Position 3 maximum

This is for use with wet, twisted or roughly sawn material where feeding is most important feature.

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 thicknessing 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 an overhand jointer or surfacer to remove twist and other irregularities.

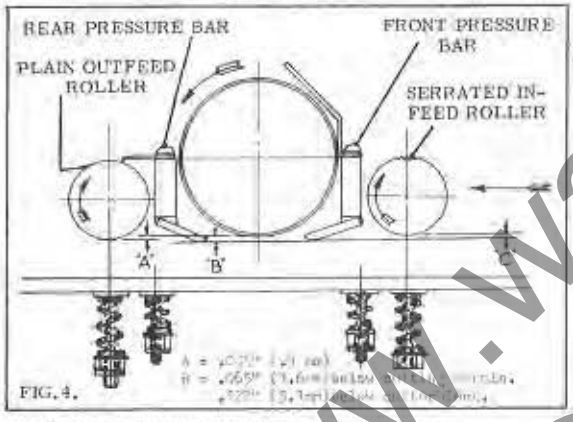


FIG. 4.

FEED ROLLER AND PRESSURE BAR SETTINGS

These are pre-set at works in accordance with Fig. 4 and vertical adjustment relative to the cutterblock 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. 4.

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. 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.

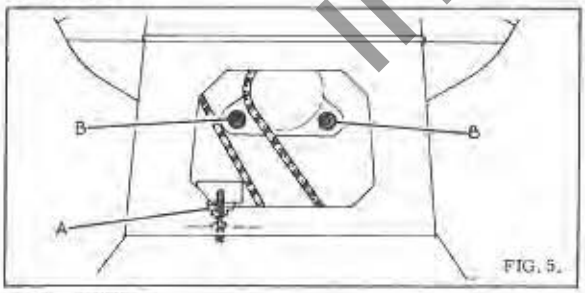


FIG. 5.

BELT TENSION

The cutterblock drive is by 2 Vee belts from a 3 HP motor. Tension is effected in these belts by an adjustable jockey pulley. To adjust, remove sheet steel panel from drive side of the machine and turn the knurled nut "A" in Fig. 5 in the direction indicated until the required tension is reached.

Replace panel before operating machine.

FEED CHAIN TENSION

Drive to feed rollers is by roller chain from a worm gearbox directly coupled to the feed motor. Feed motor on 3 phase machines is 2 speed giving feed speeds of 15 and 30 ft/min (4.5 and 9 m/min) and on single phase, single speed giving a feed speed of 22 ft/min (6.7 m/min) only.

The feed chain must be run with sufficient slack to allow the front or serrated feed roller to freely lift $\frac{1}{4}$" (6 m/m) from rest position. To adjust, remove drive side panel, loosen the two nuts "B" in Fig. 5 and move idler sprocket as required. Check feed roller lift as above, tighten nuts and replace panel

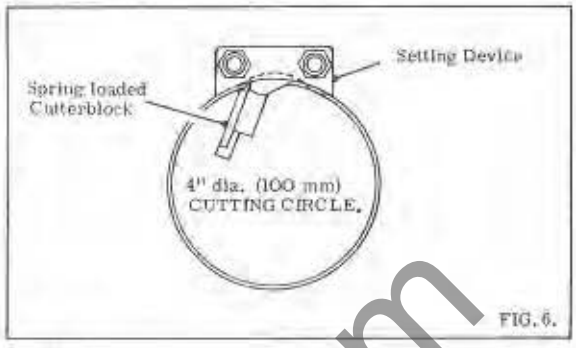


FIG. 6.

CUTTER SETTING

The cutters are held in the cutterblock by a steel clamping bar secured with [illegible] hexagon socket head screws. When the locking screws are released the cutter is ejected slightly by a small leaf spring. This is to facilitate easy setting with the special gauge supplied. As the amount of cutter projection is vital to the correct operation of the machine it is most important that the actual setting gauge supplied with the machine should be used. 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 cutters and reset with the "Burgwyn" cutter setting gauge proceed as follows:

1. Remove the four domed nuts and washers securing the guard and chip chute and lift the complete guard clear of the machine.
2. Turn the cutterblock to approximately the position shown in Fig. 6 and slacken the securing screws until the knife is just free in the cutterblock. Care should be taken when loosening the last screw as the knives are not pre-loaded.

The knives can now be removed for grinding or replacing. When grinding it is most important that knives are ground dead straight and balanced in pairs or sets.

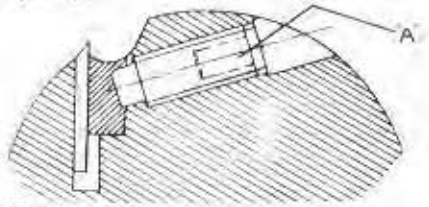
An efficient regrinding service is available, charges are moderate and service prompt. To avail yourself with this service, return cutters to:

BURGSCREEN (DURHAM) LTD., FENCE HOUSES, HOUGHTON-LE-SPRING, CO. DURHAM.

3. To re-set the knives, the cutterblock should be in approximately the position as shown in Fig. 6. Place the knife in the slot making sure that all faces are clean and the clamping bar free from burrs. Press the knife into the cutterblock with the setting device as in Fig. 6 until the four predominant pads rest on the outer surface of the cutterblock. Position the knife central in the cutterblock.
4. Holding the setting device securely in this position, tighten the securing screws. Before fully tightening the knives, check that they have not moved in the setting process. The cutting edge should now be dead parallel to the thicknessing table.

Check that all the securing screws have been tightened before setting the next knife.

5. Rotate cutterblock until the next knife is in position and repeat the procedure until all the knives have been set.
6. When changing cutters it is advisable to check that all the locking screws are adequately lubricated and quite free. Periodically examine for damage or cracks particularly in the hexagon hole. Any doubtful screws should be replaced and all screws well lubricated with "Molyslip" or similar oil, before replacing.



NOTE:-

It is most important that hexagon socket "A" in the knife locking screws is kept clear of all gum and dirt, to ensure easy removal of screws when changing knives. Always ensure that the hexagon key is fully inserted in the screw when locking or unlocking the cutters. This avoids damage to the hexagon socket.

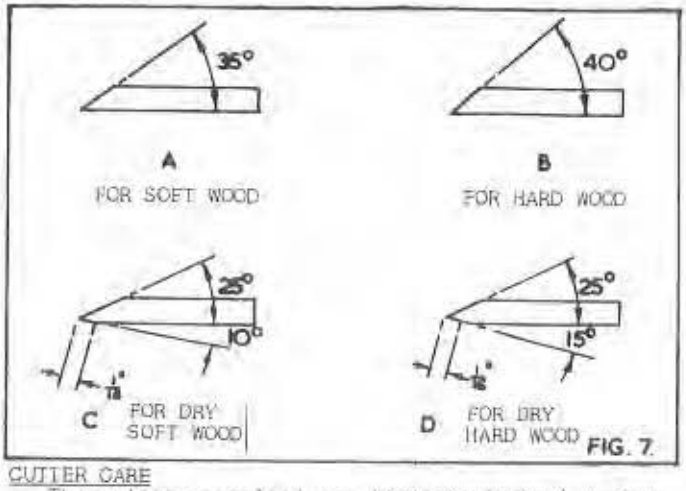


FIG. 7.

CUTTER CARE

The cutters supplied are 12¾"long (310mm) x 1¼" wide (32 mm) x ⅛" thick (3mm) 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. 7 (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. 7 (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 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 2" square (50 mm) x 18" long (460 mm) 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 under-side 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.

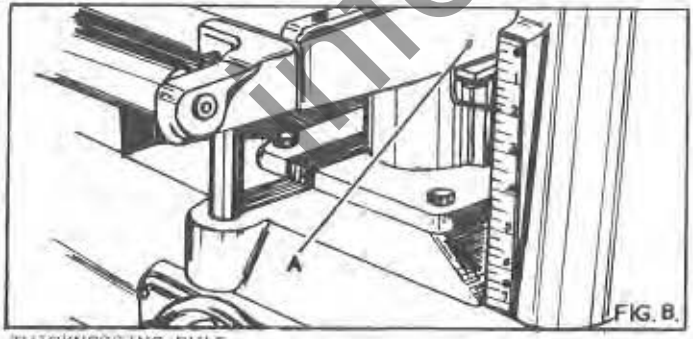


FIG. 8.

THICKNESSING RULE

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 screw "A" in Fig. 8 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.
   See fig. 9 for suggested support which can be easily made.
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.

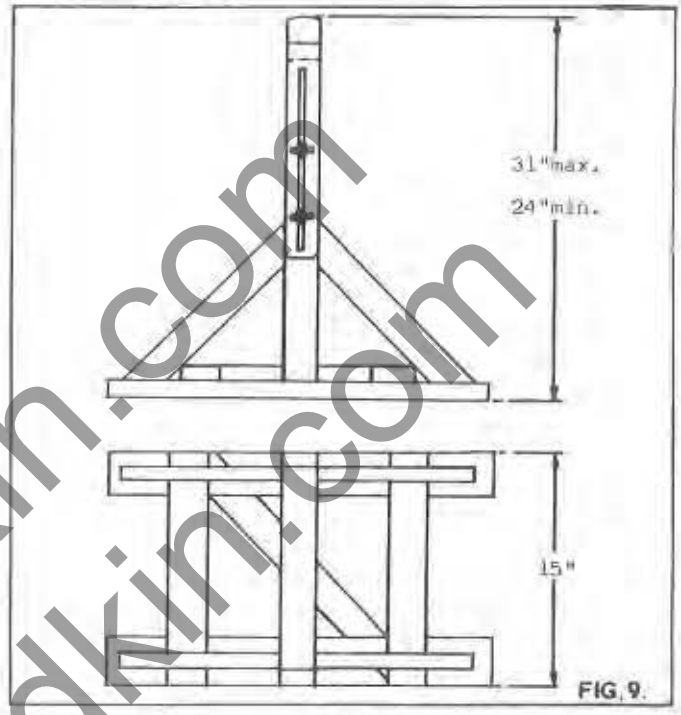
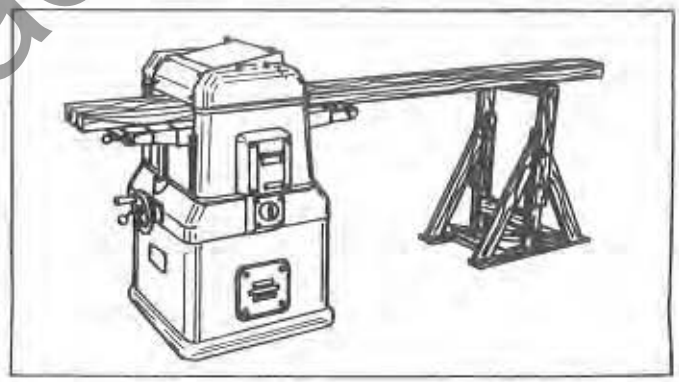
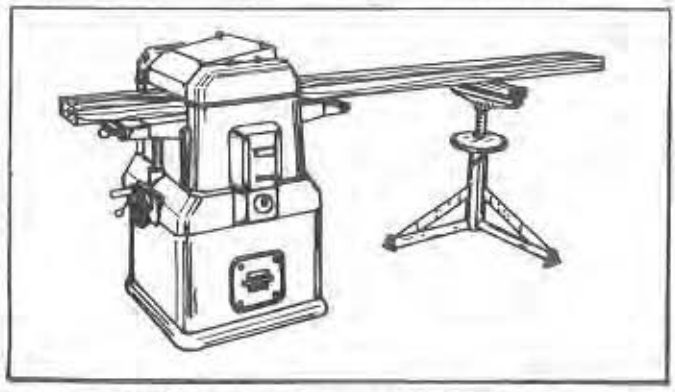


FIG. 9.

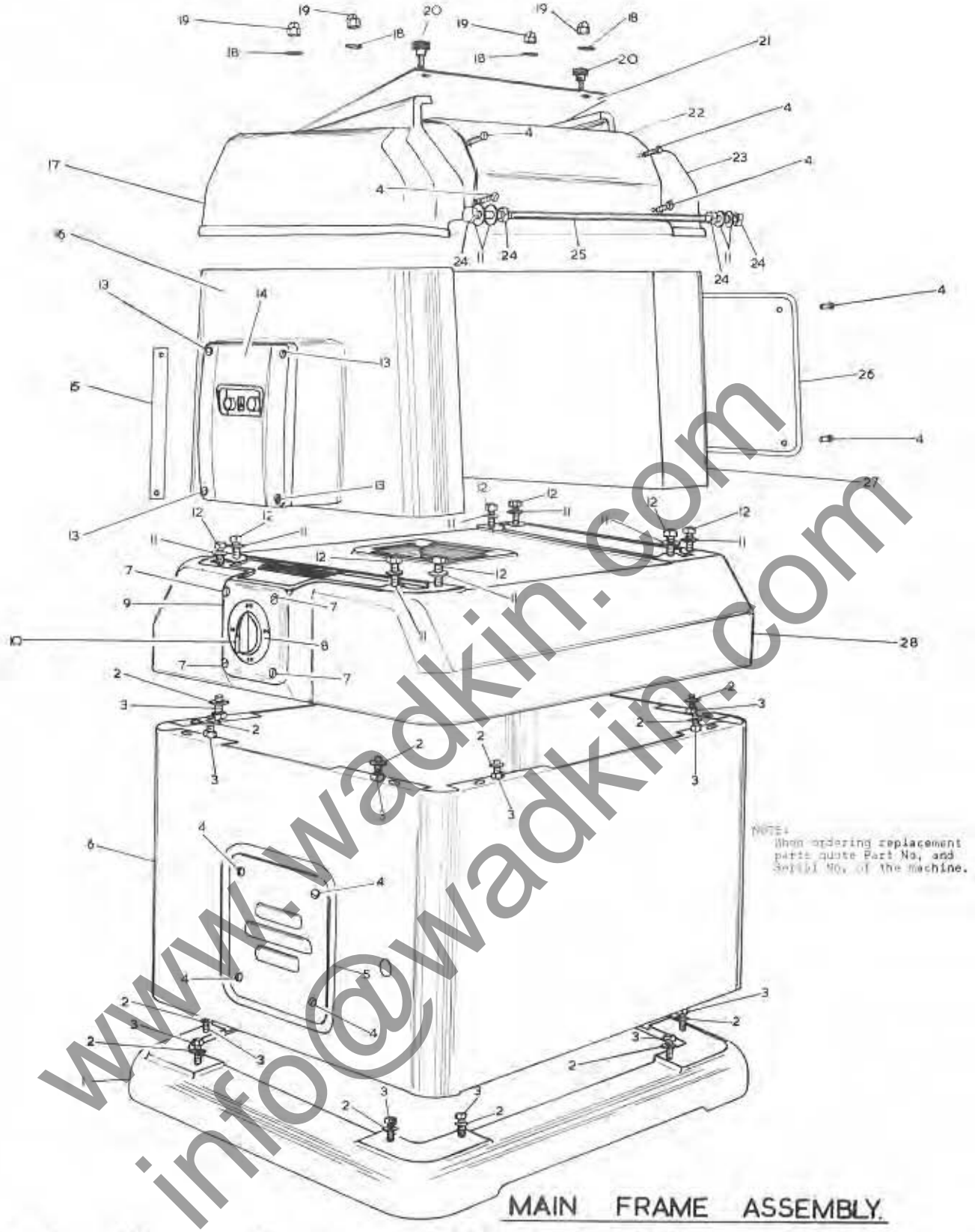
OVERALL DIMENSIONS OF SUGGESTED SUPPORT



SKETCH SHOWING WOOD SUPPORT IN POSITION



SKETCH SHOWING WADKIN/BURSGREEN ROLLER STAND TYPE VW IN POSITION.

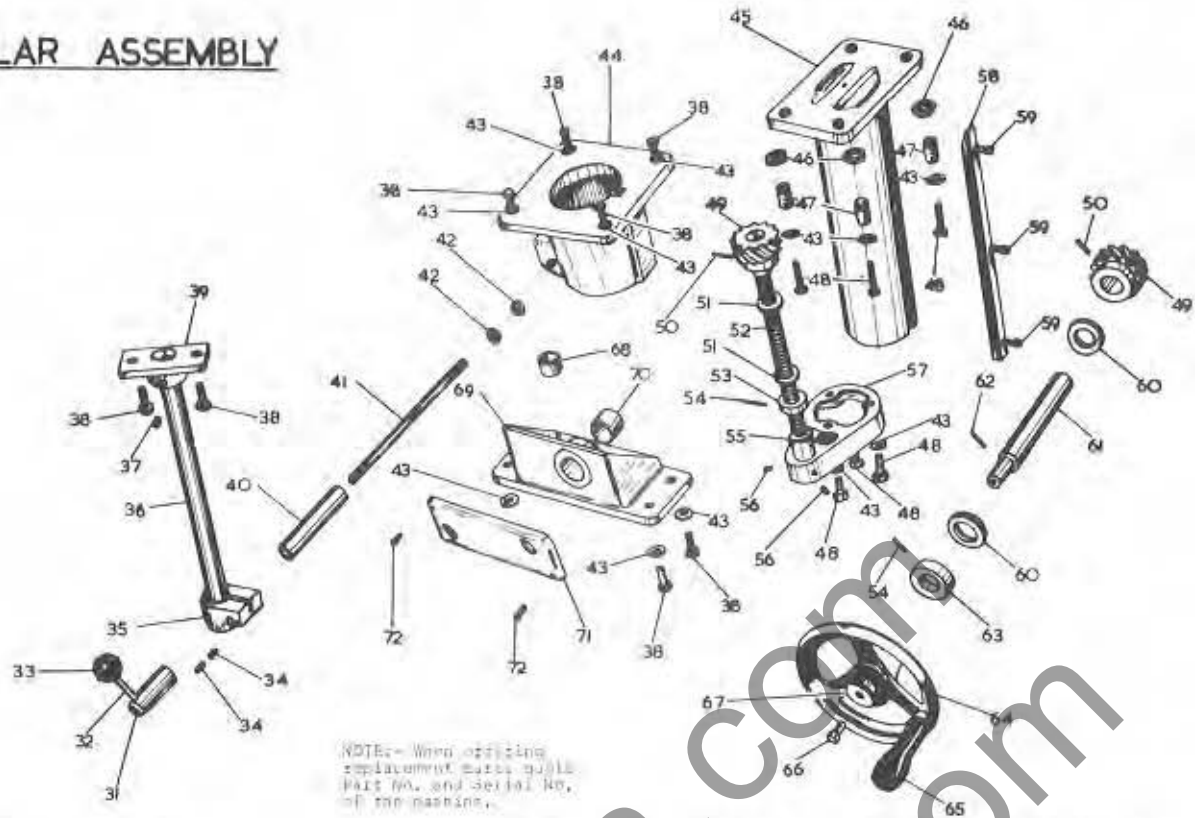


NOTE:
When ordering replacement parts quote Part No, and Serial No. of the machine.

MAIN FRAME ASSEMBLY.

Ref.No.	Part No.	No.off	Description
1	D-1031/5	1	Foot for Base.
2		16	⅜" cadmium washer.
3.		16	⅜" whit. x ⅜" long cadmium hexagon head bolt.
4.		22	¼" whit. x ⅜" long round head screw.
5.	B-1031/53	2	Panel for base.
6.	E-1031/7	1	Base (Standard).
	C-1031/97	1	Base (Single phase).
7.		4	¼" whit. x ⅜" long countersunk screw.
8.	B-1031/67	1	Escutcheon plate for rotary switch (Standard).
	A-1031/93	1	Escutcheon plate for rotary switch (Single phase).
9.	B-1031/16	1	Faceplate for rotary switch.
10.	SR.1310BG74	1	Santon 2 speed rotary switch (3phase, 50 cycles).
	SR.123	1	Santon rotary switch (1phase, 50 cycles).
	SR.1316AR65	1	Santon 2 speed rotary switch (3phase, 60 cycles).
11.		16	⅜" washer.
12.		8	⅜" whit. x 1" long hexagon head bolt.
13.		4	¼" whit. x 1" long cheese head screw.
14.	B4ADS/FO	1	MEM starter. NOTE: 1 phase and 60 cycle supplies have separate push button controls for full details refer to manufacturer.
15.	B-1031/25	1	Thicknessing table rule (English).
	B-1031/65	1	Thicknessing table rule (Metric).
16.	B-1031/3	1	Rebate side frame.
17.	D-1031/22	1	Rebate side guard.
18.		4	5/16" washer.
19.		4	5/16" whit. domed nut.
20.	D-1797/62	2	Knurled knob for chip chute.
21.	D-1031/31	1	Front chip chute.
22.	D-1031/31	1	Back chip chute.
23.	D-1031/21	1	Drive side guard.
24.		8	⅜" whit. nut.
25.	A-1031/34	2	Guard tie bar.
26.	B-1031/52	1	Drive side frame panel.
27.	D-1031/2	1	Drive side frame.
28.	E-1031/1	1	Main frame.

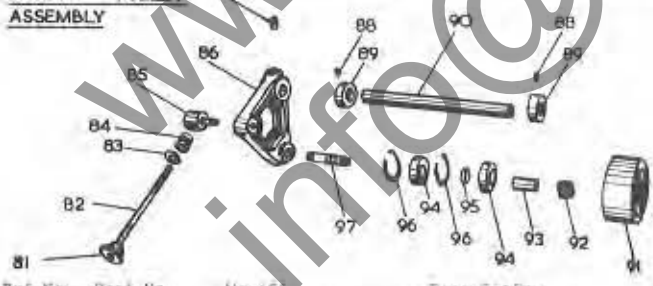
PILLAR ASSEMBLY



NOTE:- When ordering replacement parts quote part No. and serial No. of the machine.

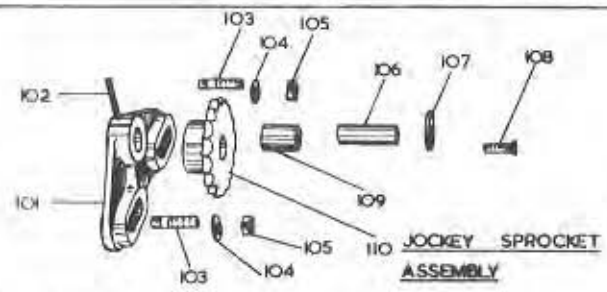
Ref.No.	Part No.	No.off	Description
31.	A-1031/84	1	Undertable support locking handle.
32.	A-1002/90A	1	Table rise and fall locking handle.
33.	Patt. No.30	1	1¼" dia. plastic ball, ⅜" hole.
34.		2	⅜" whit. x 3" long ground rod grubscrew.
35.	A-1031/83	1	Undertable support arm clamp.
36.	A-1031/87	1	Undertable support bar.
37.		1	⅜" whit. x ⅜" long socket head grubscrew.
38.		10	⅜" whit. x 1" long hexagon head bolt.
39.	A-1031/89	1	Undertable support bracket.
40.	A-1031/86	1	Undertable support locking bush.
41.	A-1031/85	1	Undertable support locking stud.
42.		2	⅜" whit. locknut.
43.		10	⅜" washer.
44.	D-1031/10	1	Pillar sleeve bracket.
45.	D-1031/8	1	Pillar.
46.	A-1031/51	4	⅜" Simplex locknut.
47.	A-1031/93	4	Thicknessing table adjusting screw.
48.		7	⅜" whit. x 1¼" long hexagon head bolt.
49.	OK,187	2	Split gear for rise and fall.
50.		2	5/16" dia. x 2" long groverlok spring dowel.
51.	bw.&	2	Hoffmann thrust race.
52.	B-1031/48	1	Thicknessing table rise and fall screw.
53.	A-1031/94	1	Collar for thicknessing table rise and fall screw.
54.		2	3/16" dia. x 1½" long groverlok spring dowel.
55.	A-1031/58	1	Cutter for thicknessing table rise and fall.
56.		2	5/16" whit. x ½" long socket head grubscrew.
57.	A-1031/45	1	Pillar end cap.
58.	A-1031/44	1	Thicknessing table pillar key.
59.		3	5/16" whit. x ¾" long socket head cap screw.
60.	BW.&	2	Hoffmann thrust race.
61.	A-1031/46	1	Thicknessing table rise and fall shaft.
62.		1	3/16" dia. x 1⅛" long groverlok spring dowel.
63.	A-1031/114	1	Collar for rise and fall shaft.
64.	A-1036/8	1	Rise and fall handwheel.
65.	Patt. No.4	1	3" plastic handle.
66.		1	⅜" whit. x ¾" long hexagon head bolt.
67.	A-1031/90	1	Washer for handwheel.
68.		2	½" bore x 1" O/D x ⅝" long oilite bush.
69.	C-1031/1	1	Bracket for rise and fall mechanism.
70.		1	½" bore x 1⅛" O/D x 1" long oilite bush.
71.	B-1031/47	1	Faceplate for rise and fall handle.
72.		2	⅜" whit. x ⅝" long round head screw.

JOCKEY PULLEY ASSEMBLY



Ref.No.	Part No.	No.off	Description
81.	A-1002/87	1	Jockey pulley adjusting nut.
82.	A-1031/48	1	Belt tension screw.
83.		1	⅜" washer.
84.	A-1024/21	1	Spring for belt tensioner.
85.	A-1031/40	1	Belt tensioner pivot nut.
86.	C-1031/9	1	Lever for belt tensioner.
87.		1	⅜" gas x ½" long socket head grubscrew.
88.		2	¼" whit. x ⅝" long socket head grubscrew.
89.	A-1031/69	2	Jockey pulley pivot shaft collar.
90.	A-1031/47	1	Pivot pin for belt tension lever.
91.	A-1031/20	1	Belt tension pulley.
92.		1	⅜" whit. aerotight nut.
93.	A-1031/48	1	Bearing bush for belt tension pulley.
94.	6203.F.	2	Fischer single seal bearings.
95.	A-1031/78	1	Jockey pulley distance piece.
96.	5008-156	2	"Truarc" 40 m/m internal circlip.
97.		1	½" whit. x 2⅝" long stud.

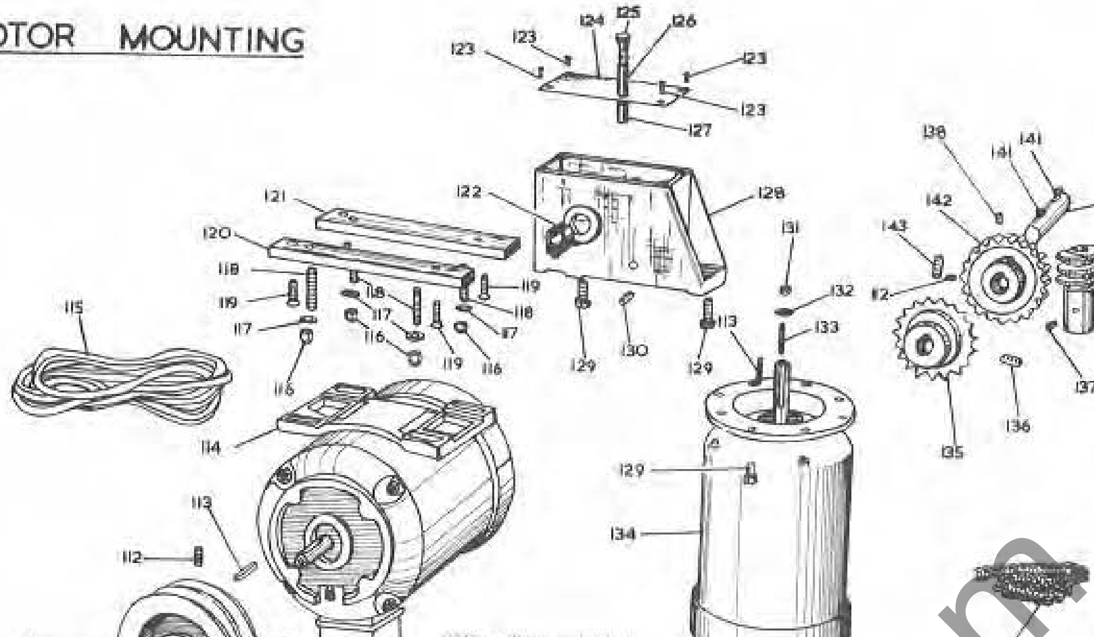
JOCKEY SPROCKET ASSEMBLY



Ref.No.	Part No.	No.off	Description
101.	C-1031/6	1	Bracket for jockey sprocket.
102.		1	3/16" dia. x 1½" long groverlok spring dowel.
103.		2	⅜" whit. x 1½" long stud.
104.		2	⅜" washer.
105.		2	⅜" whit. nut.
106.	A-1031/35	1	Jockey sprocket bearing pin.
107.	A-1027/86	1	Countersunk washer for jockey sprocket.
108.		1	5/16" whit. x ⅝" long countersunk head screw.
109.		1	⅜" bore x ⅝" O/D x 1⅛" long oilite bush.
110.	A-1031/69	1	Jockey sprocket (19 teeth).

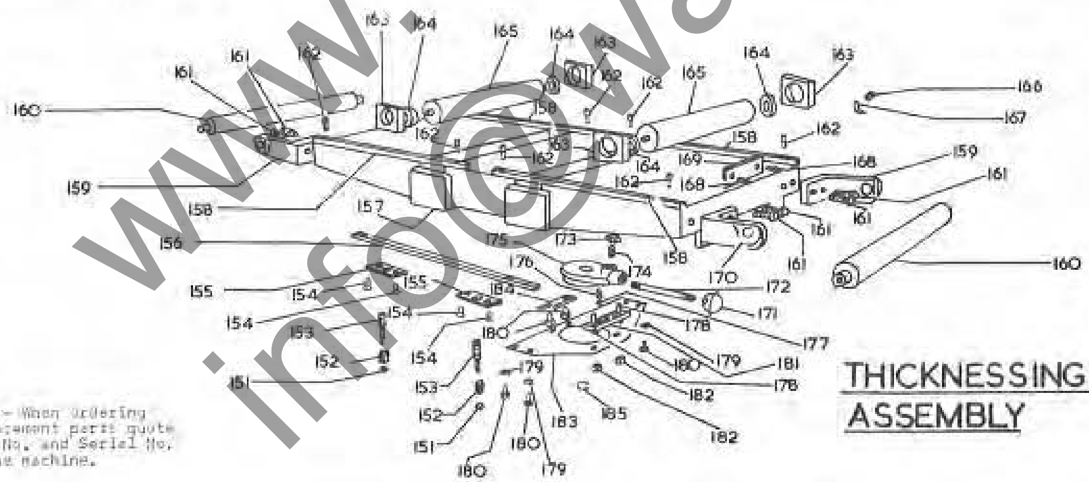
NOTE:- WHEN ORDERING REPLACEMENT PARTS QUOTE PART NO. AND SERIAL NO. OF THE MACHINE.

MOTOR MOUNTING



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

Ref. No.	Part No.	No. off	Description
111	B-1031/90	1	Motor pulley (50 cycles).
	B-1031/91	1	Motor pulley (60 cycles).
112		3	¼" whit. x ⅜" long socket head grubscrew.
113		2	3/16" wide x 1⅛" long feather key.
114		1	Brook M66B, 3HP, TEFC motor, 2840 r.p.m. foot mounted 3PH, 50 cycles.
		1	Brook [illegible], 3HP, TEFC motor, 2840 r.p.m. foot mounted 1PH, 50 cycles.
		1	Brook M66B, 3HP, TEFC motor, 3400 r.p.m. foot mounted 3PH, 60 cycles.
115	A.57	1	Goodyear belt (vee type).
116		4	⅜" whit. aerotight nut.
117		4	⅜" washer.
118		4	⅜" whit. x [illegible] long stud.
119		4	⅜" whit. x 1" countersunk socket head screw (50 cycles).
		4	⅜" whit. x 1¼" countersunk socket head screw (60 cycles).
120	B-1031/22	1	Spindle end packing piece for Brook motor ⅛" thick (50 cycles).
	B-1031/82	1	Spindle end packing piece for Brook motor 1⅛" thick (60 cycles).
121	B-1031/22	1	Fan end packing piece for Brook motor ⅛" thick (50 cycles).
	B-1031/83	1	Fan end packing piece for Brook motor 1⅛" thick (60 cycles).
122		2	¼" bore x 1" O/D x ¼" [illegible] bush.
123		4	3/16" whit. x ⅜" long round head screw.
124	A-1031/56	1	Feed gear box cover.
125	No. 0	1	⅛" [illegible] grease [illegible].
126	A-1031/6[illegible]	1	Grease tube for gearbox.
127	A-1031/65	1	Nut for grease tube.
128	C-1031/13	1	Feed gearbox.
129		[illegible]	⅜" whit. x ¾" long hexagon head bolt.
130		1	¼" gas x ⅜" long socket head grubscrew.
131		1	⅜" whit. aerotight nut.
132	A-1031/7[illegible]	1	Retaining washer for worm.
133		1	⅜" whit. x [illegible] long stud.
134		1	Brook T.14, 2 speed TEFC motor, 710 and 1420 r.p.m. flange mounted 3PH 50 cycles
		1	Brook C.12 TEFC motor, 1420 r.p.m. flange mounted 1PH 50 cycles.
		1	Brook T.14, 2 speed TEFC motor, 850 and 1700 r.p.m. flange mounted 3PH 60 cycles.
135	A-1031/60	1	Gearbox sprocket, 19 teeth, 3 phase supply.
	A-1031/92	1	Gearbox sprocket, 15 teeth, 1 phase supply.
136		1	⅜" whit. x ⅜" long socket head grubscrew.
137		1	¼" whit. x ¼" long socket head grubscrew.
138		2	¼" whit. x ⅜" long socket head grubscrew.
139	B-1031/57	1	Worm for feed gearbox, 3 phase supply.
	B-1031/57A	1	Worm for feed gearbox, 1 phase supply.
140	A-1031/45	1	Feed wormwheel bearing shaft.
141	No. 9	2	3/16" wide x ⅝" long woodruff key.
142	B-1031/67	1	Wormwheel for feed gearbox, 3 phase supply.
	B-1031/67A	1	Wormwheel for feed gearbox, 1 phase supply.
143		1	⅜" whit. x ⅜" long socket head grubscrew.
144	110046 [illegible]		Renold chain.

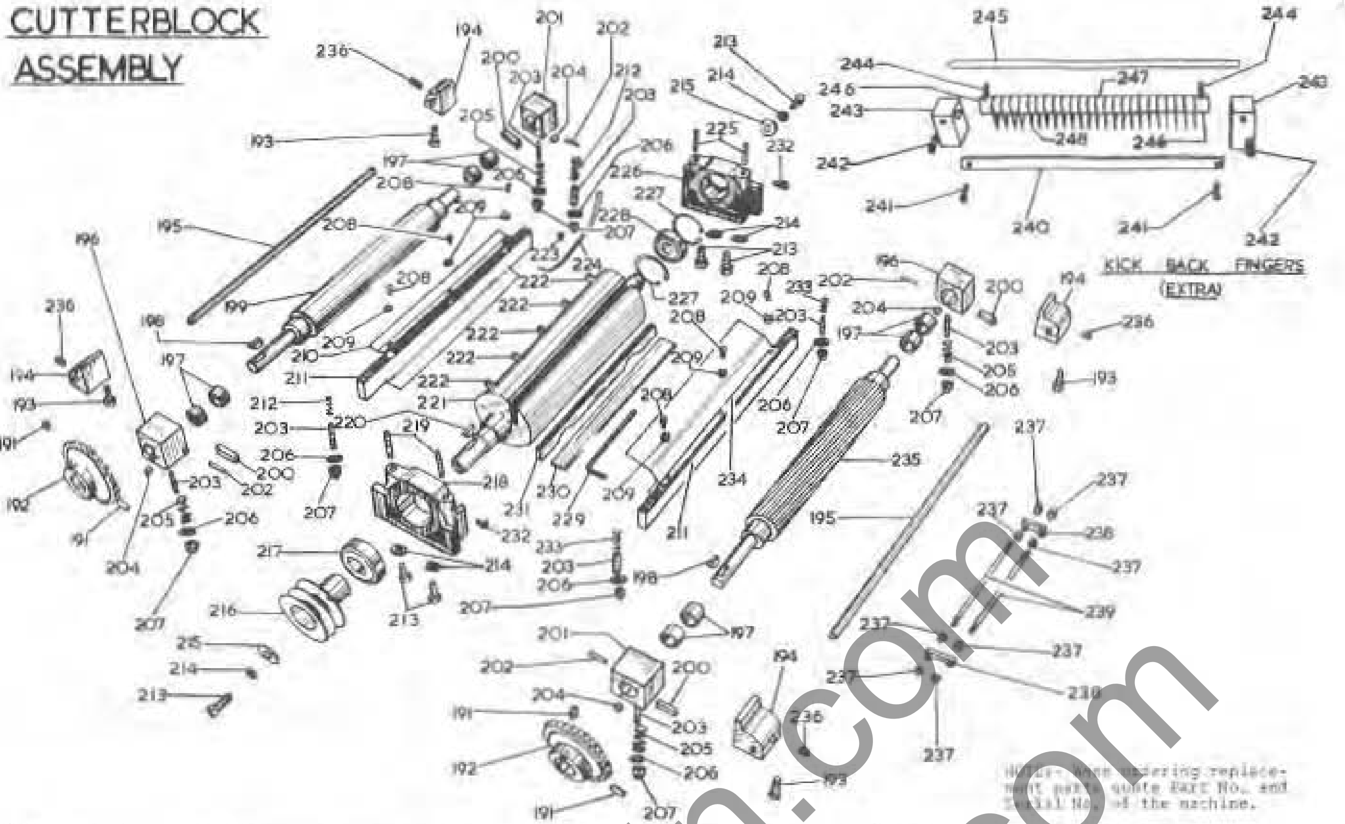


THICKNESSING TABLE ASSEMBLY

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

Ref. No.	Part No.	No. off	Description
151		4	5/16" whit. locknut.
152	A-1031/115	4	Pinion.
153	A-1031/116	4	Adjusting screw for pinion.
154		6	⅜" whit. x ⅝" long countersunk head screw.
155	A-1031/101	4	Rack trapping plate.
156	B-1031/100	2	Adjustment rack.
157	D-1031/4	1	Thicknessing table.
158	A-1031/36	4	Thicknessing table strip.
159	B-1031/24	2	Thicknessing table roller bracket (Rt.Hd)
160	B-1031/68	2	Outer table roller.
161	A-1031/110	8	Outer table roller bracket securing screws.
162		8	¼" whit. x ½" long cheese head screw.
163	A-1031/38	4	Undertable roller bearing block.
164	DN.200	4	Fischer sealed for life bearing.
165	B-1031/37	2	Undertable roller.
166		1	¼" whit. x ⅜" long socket head grubscrew.
167	A-1031/43	1	Thicknessing table rise and fall pointer.
168	———	2	⅛" dia. x ¼" long fluind rivets.
169	A-1031/117	1	Undertable roller adjustment plate.
170	B-1031/24	2	Thicknessing table roller bracket (Lt.Hd)
171		1	1" dia. plastic ball, ⅜" whit.
172	A-1031/103	1	Undertable roller adjustment handle.
173		1	⅜" whit. locknut.
174		1	⅜" whit. x ½" long socket head grubscrew.
175	B-1031/99	1	Undertable roller adjustment cam.
176	A-1031/118	1	Undertable roller adjustment spring.
177		1	5/16" dia. steel ball.
178	A-1031/106	2	Step screw for cam.
179		4	¼" washer.
180		6	¼" whit. x ½" long hexagon head bolts.
181	A-1031/104	1	Cam outer bearing plate.
182		2	¼" whit. nut.
183	C-1031/98	1	Undertable adjusting bracket.
184	A-1031/105	1	Cam inner bearing plate.
185		1	1" external circlip.

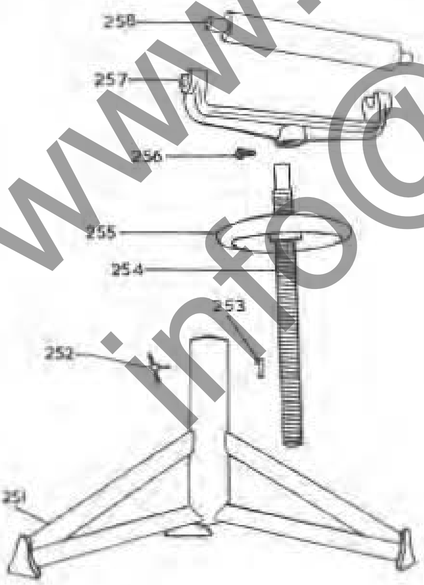
CUTTERBLOCK ASSEMBLY



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

Ref.No.	Part No.	No.off	Description
191		4	¼" whit. x ¼" long socket head grubscrew.
192	A-1031/61	2	Feed roller sprocket 25 teeth.
193		4	⅜" whit. x ⅜" long hexagon head bolt.
194	A-1031/23	4	Tie bar block.
195	A-1031/30	2	Side frame tie bar.
196	B-1031/28B	2	Feed roller bearing block.
197		8	⅝" bore x 1⅛" O/D x ⅝" long roller bush.
198	No. 150	2	⅛" wide x 1" woodruff key.
199	C-1031/29	1	Feed roller (plain).
200	3" long	4	⅜" sq. black "Tecnoil", type 770
201	B-1031/28A [illegible]	2	Feed roller bearing block.
202		4	⅛" dia. x 1" long fluted dowel.
203		8	5/16" whit. x 2" long stud.
204	A-1031/39	4	Feed roller stop.
205	A-1031/49	4	Feed roller spring.
206		8	5/16" washer.
207		8	5/16" self-locking nut.
208		6	¼" whit. x ½" long cheese head screw.
209		6	¼" spring washer.
210	A-1031/51	1	Scraper plate.

Ref.No.	Part No.	No.off	Description
211	C-1031/29	2	Pressure bar.
212	A-1031/50	2	Pressure bar spring.
213		6	⅜" whit. x 1" long hexagon head bolt.
214		6	⅜" spring washer.
215	A-1032/22	1	Cutterblock washer.
216	B-1031/81	1	Cutterblock pulley.
217	5088NORP	1	SKF sealed for life bearing.
218	B-1031/13	1	Drive side bearing housing.
219		1	5/16" whit. x 1⅝" long stud.
220	No. 155	1	5/16" wide x 1" woodruff key.
221	C-1031/22A	1	Cutterblock.
222		18	⅜" whit. x 1⅛" long dog pointed socket head grubscrew.
223		2	3/32" dia. x ¼" long fluted rivet.
224	[illegible]	2	Cutterblock spring.
225		2	5/16" whit. x 1⅝" long stud.
226	B-1031/[illegible]	1	Remote side bearing housing.
227	[illegible]	2	Truarc internal circlip.
228	[illegible]	1	Fischer sealed for life bearing.
229		1	⅛" across flats, long arm hexagon wrench.
230	B-S-56	3	Cutterblock knife (12¼" long).
231	D-1010/110	3	Strip for cutterblock.
232		3	⅜" whit. x ⅜" long cheese head screw.
233	A-1031/50	2	Pressure bar spring.
234	A-1031/32	1	Baffle plate.
235	C-1031/27	1	Feed roller (fluted).
236		6	⅛" whit. x ⅜" long socket head grubscrew.
237		8	⅜" whit. nut.
238	A-1031/54	2	Knife setting device and plate.
239	D-1010/2	2	Knife setting device tie bar.
240	A-1031/76	1	Stop bar.
241		2	⅜" whit. x ⅝" long countersunk head screw.
242		2	⅜" whit. x ⅝" long socket head grubscrew.
243	B-1031/74	2	Kick back finger tie bar block.
244		3	⅜" whit. x ⅜" long socket head grubscrew.
245	B-1031/75	1	Kick back finger tie bar.
246	B-1031/75	2	Thick tie bar collar.
247	B-1031/75	23	Thin tie bar collar.
248	A-1031/73	24	Kick back finger.



ROLLER STAND TYPE VW

Ref.No.	Part No.	No.off	Description
251	BVW.3	1	Roller stand.
252	S.122	1	T. locking handle.
253	BVW.8	1	Roller stand key.
254	BVW.4	1	Roller stand rise and fall screw.
255	BVW.2	1	Rise and fall handwheel.
256		1	⅜" whit. x 1" long sq. head bolt.
257	BVW.1	1	Yoke of roller stand.
258	BVW.6	1	Roller.

NOTE:- WHEN ORDERING REPLACEMENT PARTS QUOTE PART NO. AND SERIAL NO. OF THE MACHINE.