

# OPERATION MANUAL



## THICKNESSER Model T-13S

Order Code W815

*Edition No* : TH-815-2

*Date of Issue* : 04/2020

**MACHINE DETAILS**

<b>MACHINE</b>	<input type="text" value="THICKNESSER"/>
<b>MODEL NO.</b>	<input type="text" value="T-13S"/>
<b>SERIAL NO.</b>	<input type="text"/>
<b>DATE OF MANF.</b>	<input type="text"/>

DISTRIBUTED BY

[www.machineryhouse.com.au](http://www.machineryhouse.com.au)[www.machineryhouse.co.nz](http://www.machineryhouse.co.nz)**NOTE:**

This manual is only for your reference. Owing to the continuous improvement of the HAFCO machines, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating this electric machine.

**NOTE:**

In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)

A rectangular product specification plate with the HAFCO logo at the top. Below the logo, it says "PRODUCT SPECIFICATION". There are seven rows, each with a label and a corresponding empty rectangular box for data entry: MODEL:, CAPACITY:, SER. NO:, MFG DATE:, WEIGHT:, VOLTS:, and MOTOR Kw:. At the bottom, it includes the website [www.machineryhouse.com.au](http://www.machineryhouse.com.au) and "Made in China".

<b>HAFCO</b>	
PRODUCT SPECIFICATION	
MODEL:	<input type="text"/>
CAPACITY:	<input type="text"/>
SER. NO:	<input type="text"/>
MFG DATE:	<input type="text"/>
WEIGHT:	<input type="text"/>
VOLTS:	<input type="text"/>
MOTOR Kw:	<input type="text"/>
<a href="http://www.machineryhouse.com.au">www.machineryhouse.com.au</a> Made in China	

FIG.1

**OPERATION MANUAL**

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**1.1 SPECIFICATIONS**

ORDER CODE	W815
<b>MODEL</b>	<b>T-13S</b>
MATERIAL WIDTH CAPACITY (MM)	330
MAX. STOCK THICKNESS (MM)	152
MINIMUM MATERIAL LENGTH (MM)	178
MAXIMUM DEPTH OF CUT AT FULL WIDTH (MM)	1.5MM @ 330MM WIDE 3.3MM @ 152MM WIDE
CUTTER TYPE	HSS INSERTS - SPIRAL
QUANTITY OF CUTTERS (NO. X TYPE)	26 X INSERTS
CUTTER BLOCK DIAMETER (MM)	50.8
CUTTER BLOCK SPEED (R.P.M)	10000
FEED RATE (M/MM)	7
LENGTH OF TABLE (MM)	250
LENGTH OF TABLE WITH EXTENSIONS (MM)	720
FEED SPEED (M/MIN)	7
DUST OUTLET DIAMETER (MM)	100/63
MOTOR POWER (KW / HP)	1.8 / 2.4
POWER REQUIREMENT	240V, 50HZ, 1PH
FULL-LOAD CURRENT RATING (AMPS)	10
MINIMUM CIRCUIT SIZE (AMPS)	10
FLOOR SPACE (W X D X H)	550 X 720 X 485
SHIPPING DIMENSIONS (L X W X H)	590 X 400 X 470
NETT WEIGHT (KGS.)	30

**1.2 IDENTIFICATION T-13S**

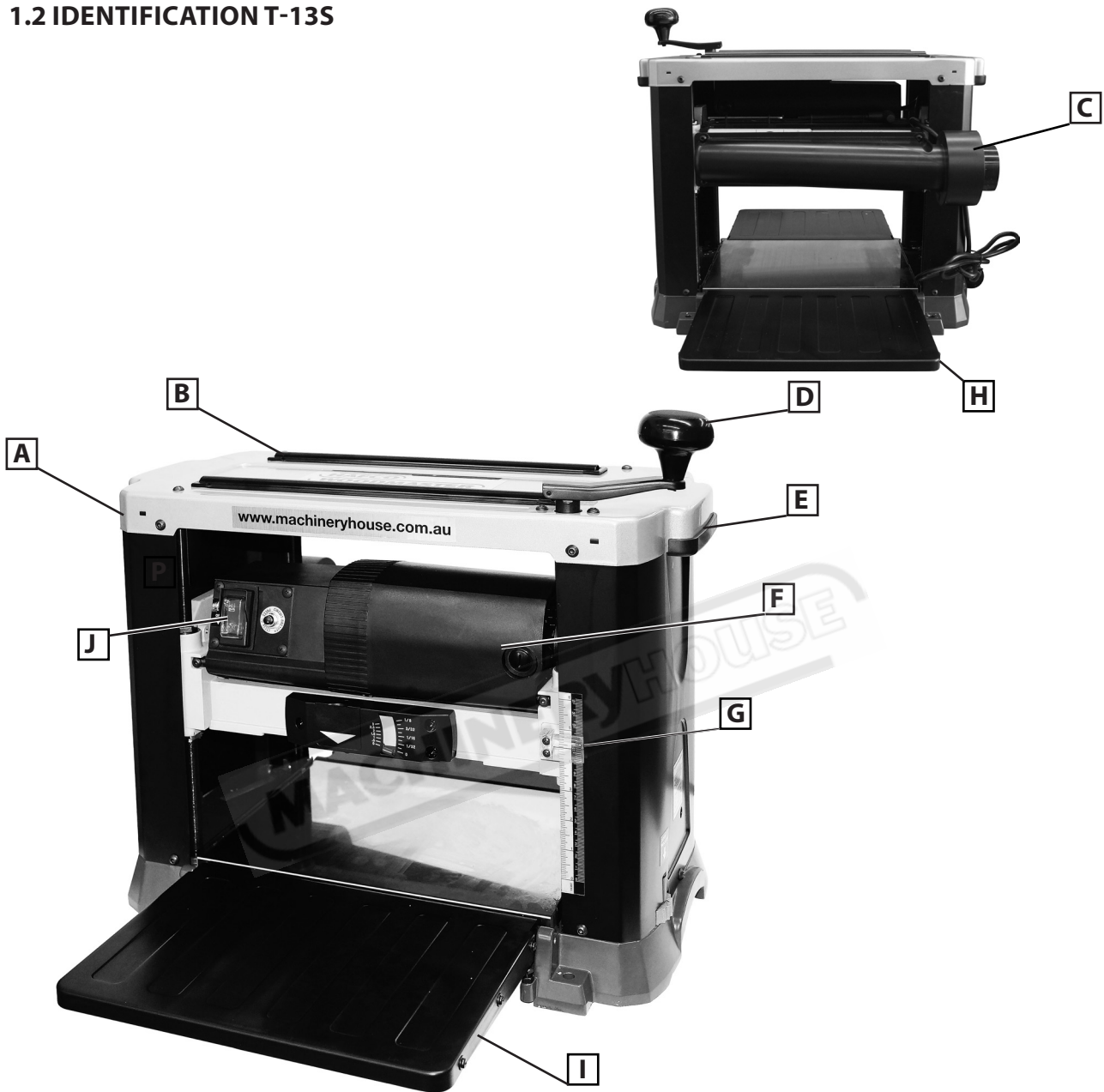


FIG. 1

<b>A</b>	HEAD	<b>F</b>	CUTTERHEAD & MOTOR ASSEMBLY
<b>B</b>	RETURN ROLLERS	<b>G</b>	HEIGHT GAUGE
<b>C</b>	DUST CHUTE	<b>H</b>	OUT-FEED EXTENSION WING
<b>D</b>	HAND WHEEL	<b>I</b>	IN-FEED EXTENSION WING
<b>E</b>	LIFTING HANDLES	<b>J</b>	ON/OFF SWITCH

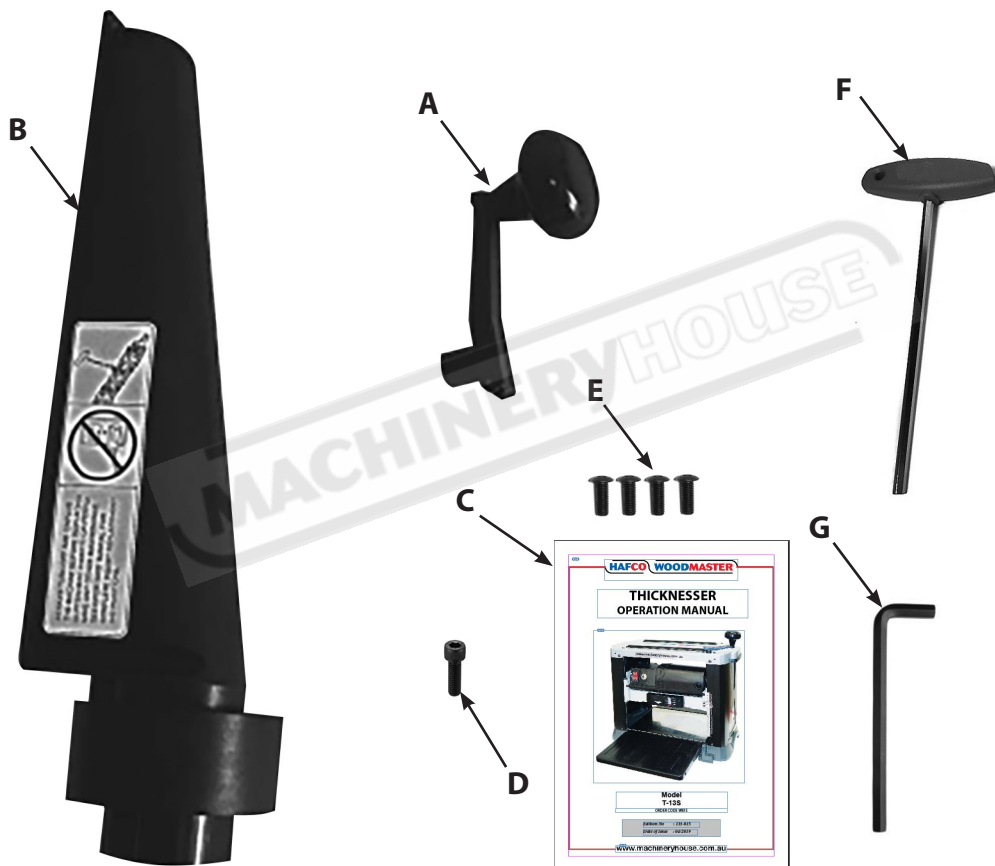
**1.3 UNPACKING & ACCESSORIES**

The machine was carefully packaged at the factory for safe transportation. Remove the packaging materials from around the machine and inspect it. If you find that the machine is damaged, contact your distributor and report it immediately.

If the machine has been damaged while in transit, save all the packing materials for possible inspection by the carrier.

Do not dispose of the packing materials until the machine has been assembled and any shipment disputes have been settled.

**PACKING LIST**



<b>A</b>	Crank Handle	<b>E</b>	Soc. Head Cap Screw
<b>B</b>	Dust Port	<b>F</b>	Torx Wrench
<b>C</b>	Manual	<b>G</b>	Hex Key
<b>D</b>	Socket Head Screw	<b>H</b>	Machine (Not displayed)

## 2. IMPORTANT INFORMATION

### 2.1 GENERAL WOODWORKING MACHINE SAFE PRACTICES

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation



## WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension, of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. Some examples of these chemicals are:



- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated timber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

- ✓ Always wear safety glasses or goggles and protective footwear.
- ✓ Wear dust masks when required.
- ✓ Wear hearing protection that is suitable for the level and frequency of the noise you are exposed to in the woodworking area. If you have trouble hearing someone speak from three feet away, the noise level from the machine may be hazardous.
- ✓ Use gloves to protect hands from splinters when handling wood but do not wear them near rotating blades and other machinery parts where the gloves can catch.

**2.1 GENERAL WOODWORKING MACHINE SAFE PRACTICES Cont.**

- ✓ Make sure the guard that is in position is in good working condition, and guards the machine adequately before operating any equipment or machine. Check and adjust all other safety devices.
- ✓ Make sure the equipment is properly grounded before use.
- ✓ Check that keys and adjusting wrenches are removed from the machine before turning on the power.
- ✓ Inspect stock for nails or other materials before cutting, planing, routing or carrying out similar activities.
- ✓ Make sure that all machines have start and stop buttons within easy and convenient reach of an operator. Start buttons should be protected so that accidental contact will not start machine.
- ✓ Ensure that all cutting tools and blades are clean, sharp, and in good working order so that they will cut freely, not forced.
- ✓ Turn the power off and unplug the power cord (or lock out the power source) before inspecting, changing, cleaning, adjusting or repairing a blade or a machine. Also turn the power off when discussing the work.
- ✓ Use a "push stick" to push material into the cutting area. Jigs are also useful in keeping hands safe during cutting procedures. Keep hands out of the line of the cutting blade.
- ✓ Always use a push stick for pieces less than 30 cm (1 ft) in length, or for the last 30 cm of a longer cut, and to remove the cut piece.
- ✓ Clamp down and secure all work pieces when drilling or milling.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position or shade lighting sources so that they do not shine in the operator's eyes or cause any glare and reflections.
- ✓ Ensure that the floor space around the equipment is sufficient to enable you to machine the size of work piece being processed safely without bumping into other workers or equipment.
- ✓ Woodworking machines should be fitted with efficient and well-maintained local exhaust ventilation systems to remove sawdust or chips that are produced.
- ✓ Electric power cords should be above head level or in the floor in such a way that they are not tripping hazards.
- ✓ Keep work area free of clutter, clean, well swept, and well lit. Spills should be cleaned up immediately. Floor areas should be level and non-slip. Good housekeeping practices and workplace design will reduce the number of injuries and accidents from slips, trips, and falls.
- ✓ Do not wear loose clothing, work gloves, neckties, rings, bracelets or other jewelry that can become entangled with moving parts. Confine long hair.
- ✓ Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the cutting tool or blade.
- ✓ Do not remove sawdust or cuttings from the cutting head by hand while a machine is running. Use a stick or brush when the machine has stopped moving.
- ✓ Do not use compressed air to remove sawdust, turnings, etc. from machines or clothing.
- ✓ Do not leave machines running unattended. Do not leave a machine until the power is turned off and the machine comes to a complete stop.

**2.1 GENERAL WOODWORKING MACHINE SAFE PRACTICES Cont.**

- ✓ Do not try to free a stalled blade before turning the power off.
- ✓ Do not distract or startle an operator while he or she is using woodworking equipment.
- ✓ Horseplay should be prohibited. It can lead to injuries.

**HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:**

- Being struck by ejected parts of the machinery
- Being struck by material ejected from the machinery
- Contact or entanglement with the machinery
- Contact or entanglement with any material in motion

**Health Hazards (other than physical injury caused by moving parts)**

- Chemicals hazards that can irritate, burn, or pass through the skin
- Airborne substances that can be inhaled, such as oil mist, metal fumes, solvents, and dust
- Heat, noise, and vibration
- Ionizing or non-ionizing radiation (X-ray, lasers, etc.)
- Biological contamination and waste
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip)

**Other Hazards**

- Slips and falls from and around machinery during maintenance
- Unstable equipment that is not secured against falling over
- Safe access to/from machines (access, egress)
- Fire or explosion
- Pressure injection injuries from the release of fluids and gases under high pressure
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components
- Environment in which the machine is used (in a machine shop, or in a work site)

**WARNING**

**MACHINES ARE SAFEGUARDED TO PROTECT THE OPERATOR FROM INJURY OR DEATH WITH THE PLACEMENT OF GUARDS. MACHINES MUST NOT BE OPERATED WITH THE GUARDS REMOVED OR DAMAGED.**

## 2.2 ADDITIONAL SAFETY FOR THICKNESSERS.

**DO NOT** use this machine unless the operator has been instructed in its safe use and operation and have read and understood this manual



Safety glasses must be worn at all times in work areas.



Long and loose hair must be contained or restrained.



Appropriate protective footwear with substantial uppers must be worn.



Close fitting, protective clothing or a workshop apron is encouraged.



Rings and jewellery must not be worn.



Hearing protection will be required when operating this machinery.

### PRE-OPERATIONAL SAFETY CHECKS

1. Check workspaces and walkways to ensure that no slip/trip hazards are present.
2. Check material to be planed for defects, splits, dead knots, or nails.
3. Ensure in-feed table is clear of debris and free from gum or resin residue.
4. Locate and ensure you are familiar with the operation of the ON/OFF starter and E-Stop.
5. Do not exceed maximum 2mm depth of cut.
6. Ensure all locks are securely tightened before operating the machine.
7. Start the dust extraction unit before using the machine.
8. Faulty equipment must not be used. Immediately report suspect machinery.

### OPERATIONAL SAFETY CHECKS

1. Never leave the machine running unattended.
2. Timber less than 300 mm in length must not be planed on this machine.
3. Feed timber to machine with the grain.
4. Feed only one piece of timber at a time.
5. Never look through machine feed opening when cutter block is revolving.
6. Never plane any timber with embedded nails, etc.
7. Stand to one side of material being fed through machine in case of kickback.
8. Before making adjustments or before clearing the in-feed or out-feed tables switch off and bring the machine to a complete standstill.

### HOUSEKEEPING

1. Switch off the machine.
2. Leave the machine in a safe, clean and tidy state.

### POTENTIAL HAZARDS

- Rotating and moving parts – timber may be flung back violently
- Pinch and squash injuries
- Flying chips and debris
- Eye injuries
- Excessive noise

## 2.2 ADDITIONAL SAFETY FOR THICKNESSERS

### IN-FEED AND OUT-FEED EXTENSION WINGS

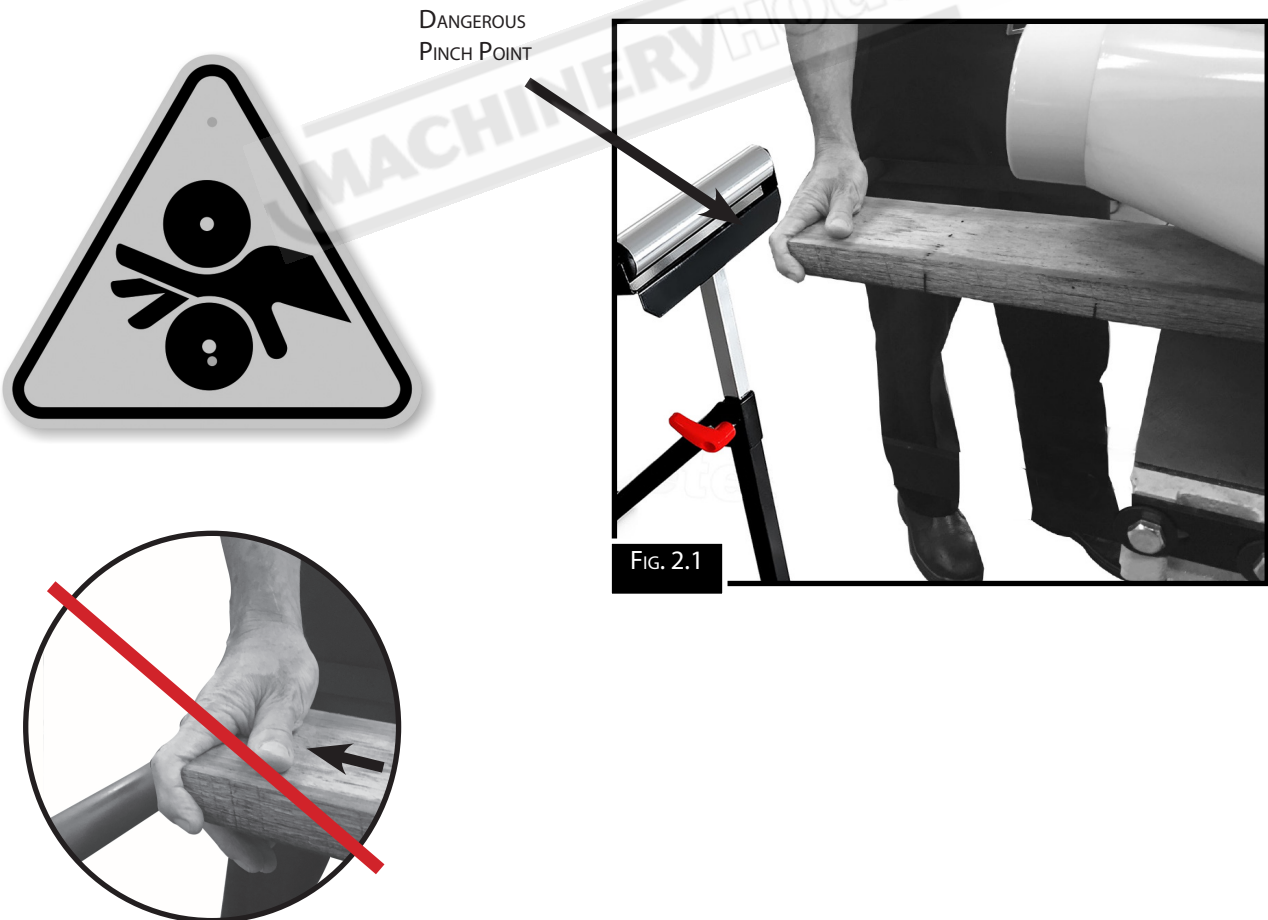
This machine is designed to feed material into and away from the spinning cutterhead, and doing so clamps the material firmly to the table. To avoid serious personal injury, always keep hands, clothing, jewellery, and long hair away from the in-feed and out-feed tables during operation.

### DISCONNECT BEFORE ADJUSTMENTS.

To avoid unexpected start-up and serious personal injury, always disconnect the thicknesser from the power before performing adjustments, maintenance, or service.

### PINCH POINTS

Beware of pinch points that can cause serious damage to fingers and hands especially if using a support roller stand on the out feed. (Fig.2.1) It is best practice to wait for the workpiece to stop feeding before removing.



**2.3 LIFTING INSTRUCTIONS**

The thicknesser in this manual is heavy. Serious personal injury could occur if safe moving methods are not used. Get assistance and use the correct lifting posture to move the shipping crate and when removing the machine from the crate. NOTE: Check the weight of the machine on the specification plate before lifting the machine and seek help if needed.



Fig. 2.2

**Stand (optional)**

The thicknesser is not supplied with a stand, but can be used on a bench or on an optional stand (Order Code W810). The machine has inbuilt lifting handles (Fig. 2.2) to assist in the lifting process.. Make sure that machine is kept in a level position while lifting.



W810

**3. INSTALLATION**

**3.1 SELECTING A LOCATION**

Check the weight and footprint specifications of your machine to ensure that the bench or stand is able to support both the machine and the work-piece.

**Placement Location**

Consider the existing and all anticipated needs, the size of the material to be processed through the machine, and extra space for auxiliary stands, work tables or other machinery when picking a location for the machine. See Fig. 3.1 for the minimum working clearances.

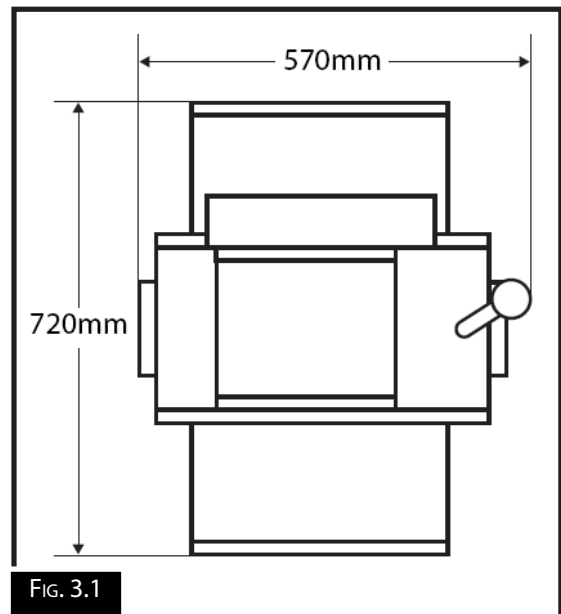


Fig. 3.1

### 3.2 SETTING UP THE THICKNESSER

#### MOUNTING OPTION

The thicknesser is supplied with an option for mounting to a workbench or stand.

There are 4 x holes in the base to place bolts through the base and into a bench or stand. (Fig. 3.2)

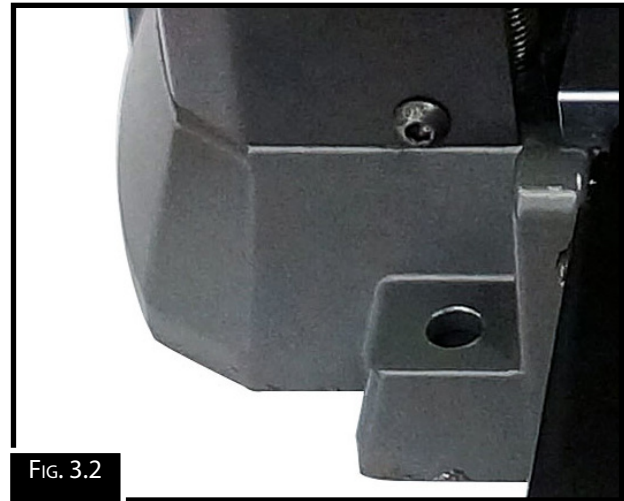


FIG. 3.2

#### ATTACHING THE HAND WHEEL

Attach the depth adjustment handle (A) to the shaft (B) and fasten in place with a Hex Socket Head screw. Tighten screw using supplied hex wrench. (Fig. 3.3)

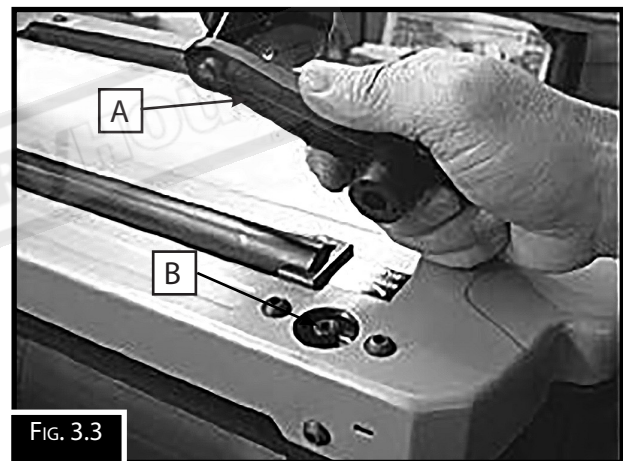


FIG. 3.3

#### ATTACHING THE DUST HOOD

The Dust Port is used to direct the waste away from the machine, and is most commonly used when the thicknesser is connected to a dust collector. It has a 4" port to accommodate most dust collection systems.

To install:

1. Install the dust port on the rear of the thicknesser by placing the dust hood on the back of the machine and attach using the 4 socket head cap screws supplied with the machine.



FIG. 3.4

**3.3 ELECTRICAL INSTALLATION**

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 240V. To minimize the risk of electrocution, fire, or equipment damage, these machines should be plugged directly into the power socket.

NOTE : The use of an extension cord is not recommended as it may decrease the life of electrical components on your machine.

**ELECTRICAL REQUIREMENTS**

Nominal Voltage.....	240V
Cycle.....	50 Hz
Phase.....	Single Phase
Power Supply Circuit.....	10 Amps
Full Load Current.....	10 Amps

(Full load current rating is also on the specification plate on the motor.)

**3.4 FULL-LOAD CURRENT RATING**

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine at 240V is 10 Amps

It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.



SAA APPROVED PLUG



### 3.5 TEST RUN

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying that the motor powers up and the machine runs correctly. When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises. If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately then review the Troubleshooting section on Page 23

If you still cannot remedy a problem, contact your distributor

## 4. OPERATION

### 4.1 BASIC CONTROLS.

The following descriptions will help you to become familiar with the basic controls of your machine.

**ON/OFF Switch:** Starts/stops the spindle and the drive rollers of the Thicknesser. (Fig. 3.6)

**Overload Reset Button:** This machine has a motor thermal overload protection switch, which will trip if the motor becomes too hot. To reset the switch, move the ON/OFF switch to OFF, wait a few minutes to allow the motor to cool, then press the reset button.

**Height Adjustment Handle:** The thicknesser depth of cut is controlled by using the elevation crank on top of the machine. Rotating the crank clockwise raises the cutterhead. (Fig. 3.7)

**Depth of Cut Scale:** The Depth Of Cut Scale, located on the front of the machine, is a convenient way to quickly determine how much material is being planed off in one pass. (Fig. 3.8)

1. With the machine OFF, insert your workpiece just under the depth of cut scale
2. Crank the raising / lowering handle until the button (B) comes in contact with the workpiece.
3. As you rotate the raising / lowering handle, the needle on the depth of cut scale will move showing you how much material will be removed in that pass under the depth of cut scale.

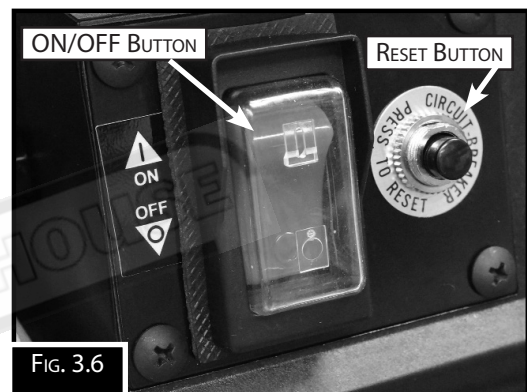


FIG. 3.6

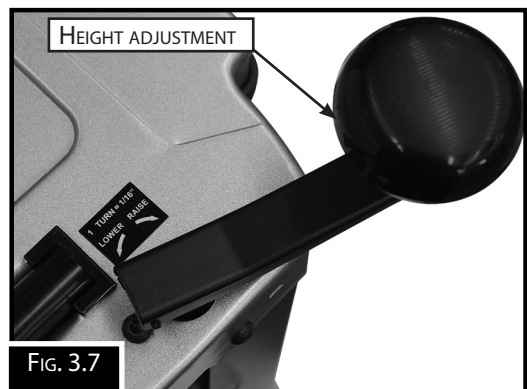


FIG. 3.7

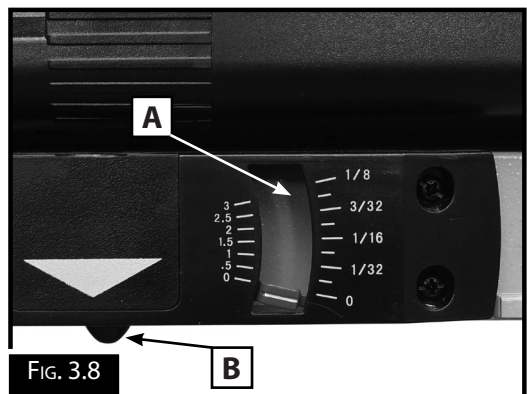


FIG. 3.8

**Thickness Scale:** The Depth of cut can also be read directly from the inch/millimeter scale on the front of the thicknesser, as shown. (Fig. 3.9)

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend a maximum depth of cut at full width, of no more than 1.5mm. A series of light cuts will give a better end result and put less stress on the motor than trying to take off too much material in a single pass.

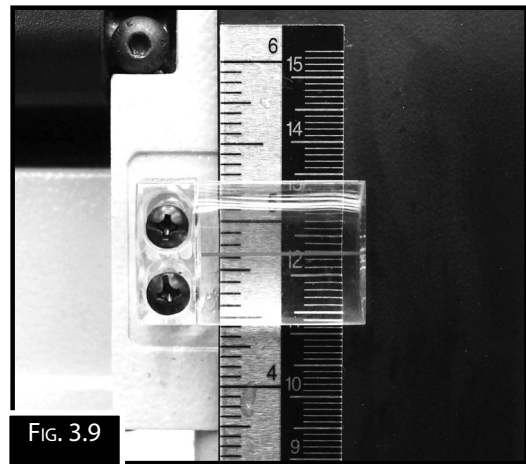


FIG. 3.9

**Depth Stop Indicator:** This depth stop dial is mounted on the lower side of machine and controls the depth of cut for finished board thickness. with pre-set heights of 1/8", 1/4", 3/8", 1/2'. (Fig. 3.10)

**NOTE:** When lowering the head assembly, ensure the Quick Set thickness indicator is in the lowest position. Failure to do so may result in excess downward pressure and cause damage to the adjustment rod and upper frame

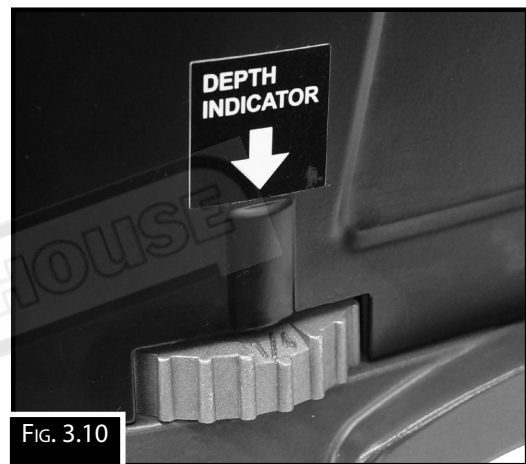


FIG. 3.10

#### 4.2 WORKPIECE INSPECTION

Some workpieces are not safe to plane or may require modification before they are safe to pass through the thicknesser. Before cutting, inspect all workpieces for the following:

- **Material Type:** This machine is only intended for planing workpieces of natural wood fiber. Attempting to plane workpieces of any other material could lead to serious personal injury and machine damage.
- **Foreign Objects:** Inspect lumber for defects and foreign objects (nails, staples, imbedded gravel, etc.). If you have any question about the quality of your lumber, do not use it. Remember, wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.
- **Large/Loose Knots:** Loose knots can become dislodged during the planing operation. Large knots can cause kickback and machine damage. Always choose workpieces that do not have large/loose knots when planing.
- **Wet or "Green" Stock:** Avoid planing wood with a high water content. Wood with more than 20% moisture content or wood exposed to excessive moisture (such as rain or snow), will plane poorly and cause excessive wear to the knives and motor. Excess moisture can also hasten rust and corrosion of the planer and/or individual components.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being planed. **DO NOT** use workpieces with these characteristics!

### 4.3 BASIC OPERATION

This section gives you the basic process that happens during an operation with this machine. Familiarize yourself with this process to better understand of the operation of this machine.

**To complete a typical operation, the operator should do the following:**

1. First check that the workpiece is clean and free of any defects or foreign materials that might cause kickback or damage the cutters.
2. Adjusts the height of the head for the correct depth of cut.
3. Start the dust collection system.
4. Connect the thicknesser to the power supply and turn the machine ON.
5. Move the workpiece in slowly until the "Height Adjustment Scale" registers
5. The operator should place their body to the side of the machine, then lay the workpiece on the in-feed table and feed it into the machine until the in-feed roller engages it and moves it past the cutterhead.
6. When the workpiece exits the thicknesser, return it to the in-feed table, using the return rollers and make as many passes as necessary.
7. When finished turn the machine OFF.

**Note:** Anytime you switch directions with the cutterhead elevation crank, there will be a small amount of backlash—the amount the crank moves before the cutterhead begins to move. However, as long as you move the handle in the same direction during operation, backlash will not be a factor

#### Operating Tips

- Where ever possible use the full width of the thicknesser cutters. If the width is smaller than the width of the cutters, alternate the cutting path between the left, the right and the middle of the table to evenly distribute the wear across the cutters.
- Scrape all glue off joined boards before putting the timber through the thicknesser
- ONLY machine natural wood. Do not machine wood composites or any other man-made material.
- Machine the workpiece with the grain. NEVER feed end-cut or end-grained lumber into your machine.
- Keep the work area clear.
- Always true up any cupped or warped stock on a jointer or bandsaw before placing it through the thicknesser.
- When making multiple passes through the thicknesser with long stock, use the stock return rollers on top of the machine to move the material back to the infeed side.
- When possible, machine both faces of the workpiece so that they will be parallel with one another

### AVOIDING SNIPE

Snipe, gouging or depression of the board at the ends, can occur when the board is not properly supported. (Fig. 3.11)

For workpieces longer than 1200mm, greater care must be taken to reduce the problem because the additional length of the workpiece translates into more unsupported weight pulling down on the end of the board. This unsupported weight will work against keeping the stock flat. Make sure to use supports or stands whenever long pieces are being planed to avoid this problem. Since snipe occurs at the end of the boards, it is good practice to start with a workpiece that is slightly longer than what you need so that you can simply cut off the end with the problem.

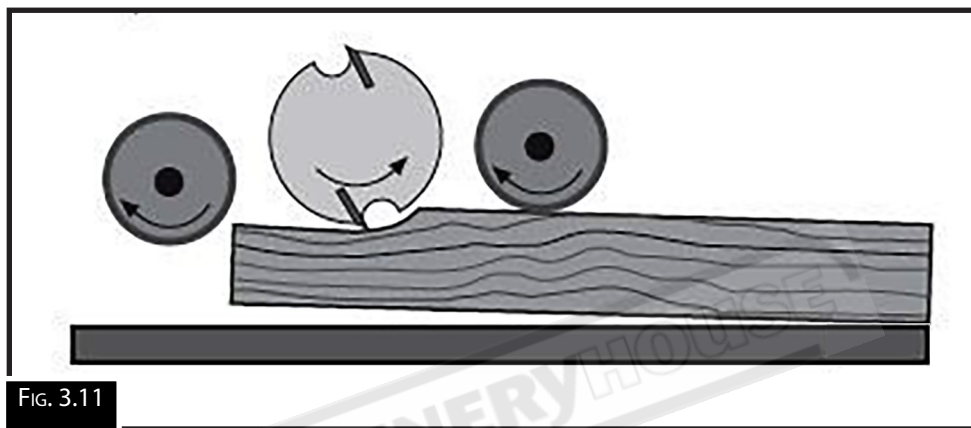


Fig. 3.11

### CHIP MARKS OR INDENTATIONS

**Reason:** Chip indentation or chip bruising is the result of wood chips not being removed from around the cutterhead. Instead, they are deposited on the planed surface and crushed into the workpiece by the outfeed roller. This condition can be caused by a number of reasons, some of which are:

- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (20% or higher) and/or surface moisture. Typically found in air-dried lumber where the surface is dry but the interior of the stock needs more time to season.
- Dull knives or inserts
- Depth of cut too much.

#### **Solution:**

- Lumber must be completely dry, preferably kiln-dried (KD). Air-dried (AD) lumber must be seasoned properly and have no surface moisture. DO NOT plane partially air-dried (PAD) lumber.
- Make sure the planer knives or inserts are sharp.
- Reduce the depth of cut and make more passes.

## 5. MAINTENANCE

### 5.1 LUBRICATION

The Thicknesser should provide you with a long time of service provided the following maintenance operations are performed.

1. A quality paste wax should be applied to the table surface to ease the movement of the workpiece across it. Be sure to buff off all excess wax so that it does not get absorbed into the wood when planing.
2. Having clean feed rollers is essential for optimal results. After disconnecting the machine from the power supply, check the feed rollers after each use for buildup of pitch, gum, or resin and be sure to clean off with a non flammable tar and pitch remover.
3. Any moving parts should be cleaned regularly with a penetrating oil and lubricated with a light coating of medium weight machine oil.

### GEAR LUBRICATION

The gears in the gear box should be lubricated periodically.

To lubricate the gears,

1. DISCONNECT THE MACHINE FROM THE POWER SUPPLY
2. Remove the socket head screw (A) located on the front of the machine. You will also need to remove the other socket head screw, located in the same position on the rear of the planer. (Fig. 5.1)
3. Remove the side panel to expose the gear box cover (B).
4. Remove the two screws (C) in order to remove the gear box cover and access the gear box. (Fig. 5.2)
5. Place a light coat of multi purpose grease on the teeth of the gears (D) and a light coat of spray lubricant on the chain (E). Do not over-lubricate. (Fig.5.3)
6. Replace all covers and guards that were removed once the lubrication is complete.



FIG. 5.1

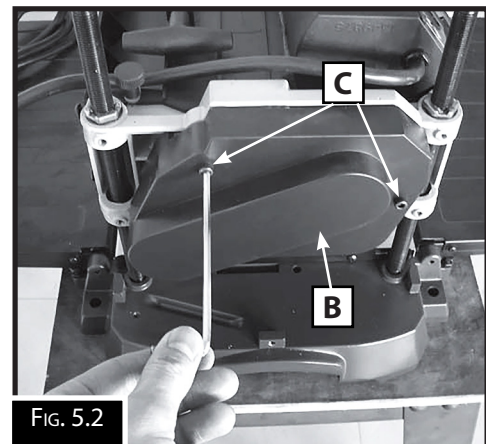


FIG. 5.2

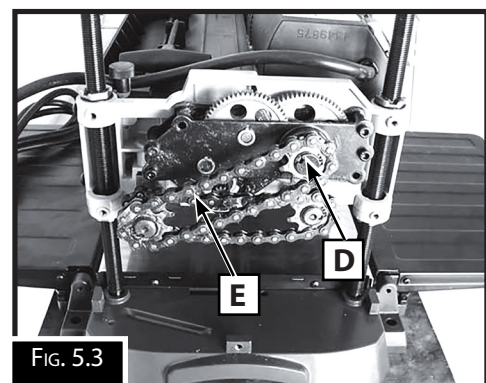


FIG. 5.3

## MAIN BEARINGS

The thicknesser is supplied with bearings that are lubricated and sealed at the factory. These bearing do not require any further attention unless they need to be replaced. If a bearing fails, the thicknesser will probably develop a noticeable rumble or vibration, which will increase when the machine is under load. The bearings are standard sizes and can be replaced.

## 5.2 ADJUSTMENT

### MOTOR BRUSH REPLACEMENT

Brush life will vary depending on the load placed on the motor. The brushes should be inspected every 10-15 hours of use.

To inspect:

1. DISCONNECT MACHINE FROM THE POWER SUPPLY
2. Remove the Brush Holders, one of which is shown at (A). The other is located in the same position on the rear of the motor assembly. The Brush Holder can be removed using a flat blade screwdriver. (Fig. 5.4)
3. Once the brush has been removed, inspect the carbon (B), the spring (C), and the wire (D).
4. If the carbon of either brush is worn down to 4.5mm or less, both brushes should be replaced. Also if the spring or wire are burned or damaged in any way, both brushes should be replaced. (Fig.5.6)

**NOTE:** Contact your distributor for replacement brushes (Part No 173 in spare parts list)

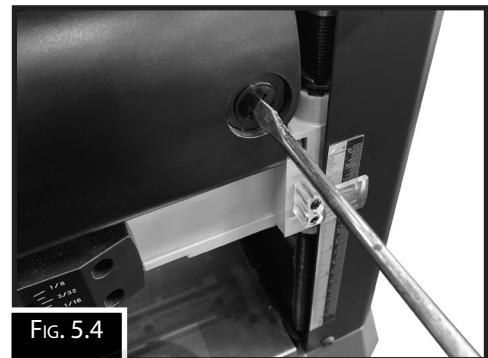


FIG. 5.4



FIG. 5.5

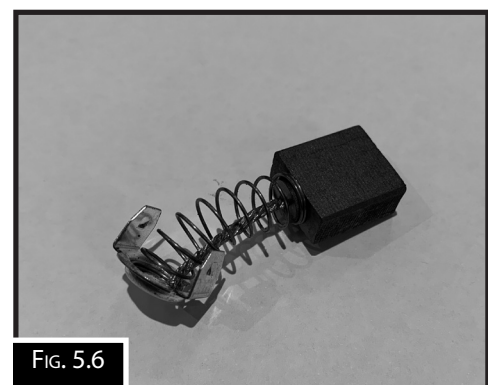


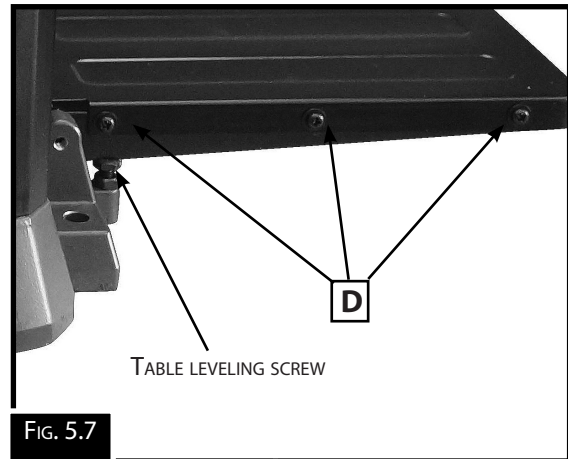
FIG. 5.6

### TABLE LEVEL ADJUSTMENT

The out-feed and in-feed tables of the thicknesser were set level before the machine left the factory. However after shipping or prolong use the tables may need to be adjusted.(Fig. 5.7)

#### To adjust the table:

1. Disconnect the machine from the power
2. Place a straight edge across the tables.
3. If the table needs to be adjusted, loosen the three screws "D" on the side of the table and adjust as required. If more adjustment is required then the table leveling screw can be adjusted by loosening the lock nut and adjust the bolt accordingly
4. Tighten the lock nut and recheck the level

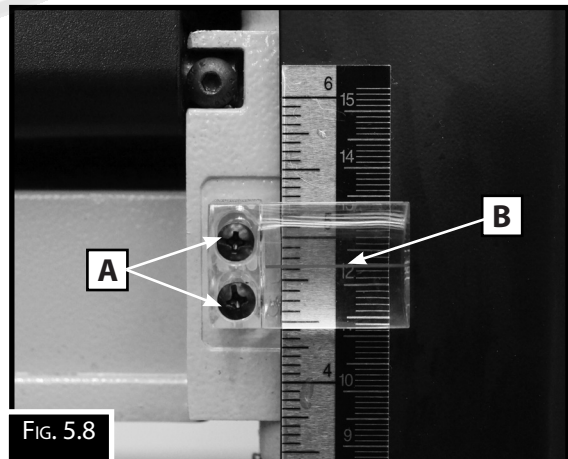


### THICKNESS SCALE ADJUSTMENT

The scale, located on the right hand side of the thicknesser, shows the thickness of the finished work-piece. (Fig. 5.8)

To make sure the scale is set correctly, run a piece of timber through the thicknesser and measure the finished size of the timber. If the measurement on the scale is not the same as the timbers thickness, loosen the two round head screws (A) holding the scale indicator (B) and adjust the thickness indicator to the correct setting.

Make sure to re-tighten the two screws once the adjustment is complete.



**CHANGING INSERTS ON THE SPIRAL CUTTER**

The 330mm cutter-head is equipped with 26 indexable high speed steel cutting tips. (Fig. 5.9) Each cutting tip can be rotated to reveal any one of its 2 cutting edges. If one cutting edge becomes dull or damaged, users may simply rotate the cutting tip to index to a fresh cutting edge.

Each tip has a reference dot at the corner. (Fig. 5.10) If the tip is rotated, the reference dot location will be used as an indicator to tell if it is used or new.

**To Change The Inserts**

1. DISCONNECT MACHINE FROM THE POWER!
2. Loosen 4 hex head screws from dust chute with a hex wrench and remove the Dust Chute.
3. Leather heavy gloves should be worn to protect your hands and fingers.
4. Insert a hex wrench into the right side panel & cutter-head and turn the cutter-head to a position for changing tips. (Fig. 5.11)
5. Remove any sawdust or debris from around the insert, Torx screw, and the surrounding area.
6. Remove the Torx screw and the insert, then clean both parts and the pocket where the insert sits.

**Note:** Ensure the insert, Torx, screw, and the cutter head pocket have been thoroughly cleaned. This is critical to achieving a smooth and precision finish. Trapped dirt between the insert and cutter-head will slightly raise the insert, and make noticeable marks.

7. Replace the insert so that a fresh cutting edge faces outward. If all two insert cutting edges have been used, replace the insert with a new one. Always position the reference mark (Fig.5.10) on the insert in the same position when installing a new insert to aid in the rotational sequencing.
8. Lubricate the Torx screw threads with a very small amount of light machine oil, wipe the excess off, and tighten the screws making sure not to over tighten them.

**Note:** Do Not use too much oil. The excess may squeeze out of the threaded hole as you install the insert and force the insert to raise slightly, forcing the insert out of alignment.



FIG. 5.9

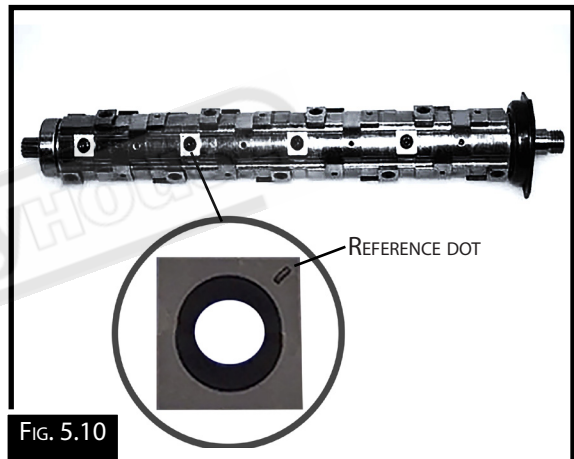


FIG. 5.10



FIG. 5.11

**5.3 TROUBLESHOOTING**

Should any problems arise review the troubleshooting procedures in this section to find the possible problem or fix and adjust your machine.

The spare parts view and the procedure for ordering is layed out in the spare parts section.

<b>SYMPTOM</b>	<b>POSSIBLE CAUSE</b>	<b>POSSIBLE SOLUTION</b>
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>1. Stop push-button engaged/faulty.</li> <li>2. Power switched OFF or at fault.</li> <li>3. Thermal overload relay has tripped.</li> <li>4. Wall circuit breaker tripped.</li> <li>5. Plug/receptacle at fault/wired incorrectly.</li> <li>6. Motor connection wired incorrectly.</li> <li>7. Contactor not energized.</li> <li>8. Wiring open/has high resistance.</li> <li>9. ON/OFF switch at fault.</li> <li>10. Start capacitor at fault.</li> <li>11. Centrifugal switch at fault</li> <li>12. Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check magnetic switch/replace it.</li> <li>2. Ensure power supply is switched ON</li> <li>3. Reset trip load dial if necessary; replace.</li> <li>4. Ensure circuit size is correct/replace.</li> <li>5. Test for good contacts; correct the wiring.</li> <li>6. Correct motor wiring connections</li> <li>7. Test all legs for power/replace if faulty.</li> <li>8. Check and fix broken, disconnected wires</li> <li>9. Replace switch.</li> <li>10. Test/replace if faulty.</li> <li>11. Adjust/replace centrifugal switch.</li> <li>12. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered	<ol style="list-style-type: none"> <li>1. Feed rate too fast.</li> <li>2. Workpiece material not suitable.</li> <li>3. Dust collection ducting problem.</li> <li>4. Motor overheated.</li> <li>5. V-belt(s) slipping.</li> <li>6. Run capacitor at fault.</li> <li>7. Pulley/sprocket slipping on shaft.</li> <li>8. Motor bearings at fault.</li> <li>9. Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease feed rate.</li> <li>2. Ensure timber moisture is below 20%.</li> <li>3. Clear blockages, use smooth wall duct,</li> <li>4. Clean motor, let cool, and reduce load.</li> <li>5. Tension/replace belt(s) ensure pulleys are aligned</li> <li>6. Test/repair/replace.</li> <li>7. Replace loose pulley/shaft.</li> <li>8. Test/repair/replace.</li> <li>9. Test/repair/replace.</li> </ol>
Excessive step (snipe) (gouge at the end of the workpiece that is uneven with the rest of the cut).	<ol style="list-style-type: none"> <li>1. One or both of the bed rollers are set too high.</li> <li>2. Rear table extension slopes down or is not level with the table</li> <li>3. Chip breaker or pressure bar set too low</li> <li>4. Workpiece is not fully supported as it leaves the thicknesser.</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower the bed rollers</li> <li>2. Adjust the rear extension wing set screws to make the extension level with the table</li> <li>3. Raise the height of the chip breaker or pressure bar</li> <li>4. Use a roller stands to properly support the workpiece as it leaves the thicknesser.</li> </ol>
Workpiece stops/slow in the middle of the cut.	<ol style="list-style-type: none"> <li>1. Depth of cut too deep.</li> <li>2. Pitch/glue build-up on thicknesser components.</li> <li>3. One or both of the bed rollers are set too low or too high.</li> <li>4. Chip breaker or pressure bar set too low</li> <li>5. Feed rollers set too low or too high.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce the depth of cut.</li> <li>2. Clean planer components with a pitch/resin dissolving solvent.</li> <li>3. Lower/raise the bed rollers</li> <li>4. Raise the height of the chip breaker or pressure bar</li> <li>5. Adjust the feed rollers to the correct height</li> </ol>

**5.3 TROUBLESHOOTING**

<b>SYMPTOM</b>	<b>POSSIBLE CAUSE</b>	<b>POSSIBLE SOLUTION</b>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Belts slapping cover.</li> <li>2. V-belt(s) worn or loose.</li> <li>3. Pulley loose.</li> <li>4. Motor mount loose/broken.</li> <li>5. Motor fan rubbing on fan cover.</li> <li>6. Table rollers protruding unevenly.</li> <li>7. Motor bearings at fault.</li> <li>8. Cutterhead bearings at fault.</li> <li>9. Chip deflector hitting cutterhead.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace/realign belts with a matched set.</li> <li>2. Inspect/replace belts with a new matched set.</li> <li>3. Realign/replace shaft, pulley, setscrew, &amp; key.</li> <li>4. Tighten/replace.</li> <li>5. Fix/replace fan cover; replace damaged fan.</li> <li>6. Adjust table rollers.</li> <li>7. Test by rotating shaft; &amp; replace worn bearings</li> <li>8. Replace bearing(s)/realign cutterhead.</li> <li>9. Check/replace chip deflector and realign</li> </ol>
Consistent chipping pattern.	<ol style="list-style-type: none"> <li>1. Knots or conflicting grain direction in workpiece.</li> <li>2. Nicked or chipped cutter or insert.</li> <li>3. Feed rate too fast.</li> <li>4. Depth of cut too deep.</li> <li>5. Bed rollers set too high or low; not even with each other.</li> <li>6. Misaligned chip breaker.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect workpiece for knots and grain direction; use only clean stock.</li> <li>2. Rotate/replace cutters or insert .</li> <li>3. Reduce feed rate.</li> <li>4. Reduce the depth of cut.</li> <li>5. Properly adjust the bed roller height.</li> <li>6. Adjust sides of chip breaker until correct</li> </ol>
Furry grain.	<ol style="list-style-type: none"> <li>1. Workpiece has high moisture content or surface wetness.</li> <li>2. Dull cutter blades or inserts</li> </ol>	<ol style="list-style-type: none"> <li>1. Allow workpiece to dry if moisture content is over 20% or has surface wetness.</li> <li>2. Rotate/replace cutter blades or inserts</li> </ol>
Lines or ridges running the length of the workpiece	<ol style="list-style-type: none"> <li>1. Nicked blades or chipped inserts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Rotate or replace the inserts or replace the damaged blades.</li> </ol>
Uneven cutting marks, wavy surface, or chatter marks on the workpiece.	<ol style="list-style-type: none"> <li>1. Feed rate too fast.</li> <li>2. Chip breaker or pressure bar set unevenly.</li> <li>3. Bed rollers not set correctly.</li> <li>4. Insert(s) or blades not properly installed.</li> <li>5. Worn cutterhead bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate.</li> <li>2. Adjust the height of the chip breaker or pressure bar</li> <li>3. Properly adjust the bed roller height</li> <li>4. Remove insert(s) or blades, then properly clean and install</li> <li>5. Replace cutterhead bearings</li> </ol>
Glassy surface	<ol style="list-style-type: none"> <li>1. Inserts are dull.</li> <li>2. Feed rate too slow.</li> <li>3. Depth of cut too shallow</li> </ol>	<ol style="list-style-type: none"> <li>1. Rotate/replace inserts or replace blades</li> <li>2. Increase feed rate</li> <li>3. Increase depth of cut</li> </ol>
Inconsistent chip marks.	<ol style="list-style-type: none"> <li>1. Chips are not being removed from around the cutterhead</li> </ol>	<ol style="list-style-type: none"> <li>1. Use an adequate dust collection system; adjust the chip deflector in or out.</li> </ol>

# SPARE PARTS SECTION

## THICKNESSER

### Model T-13S

ORDER CODE W815

*Edition No* : TH-815-2

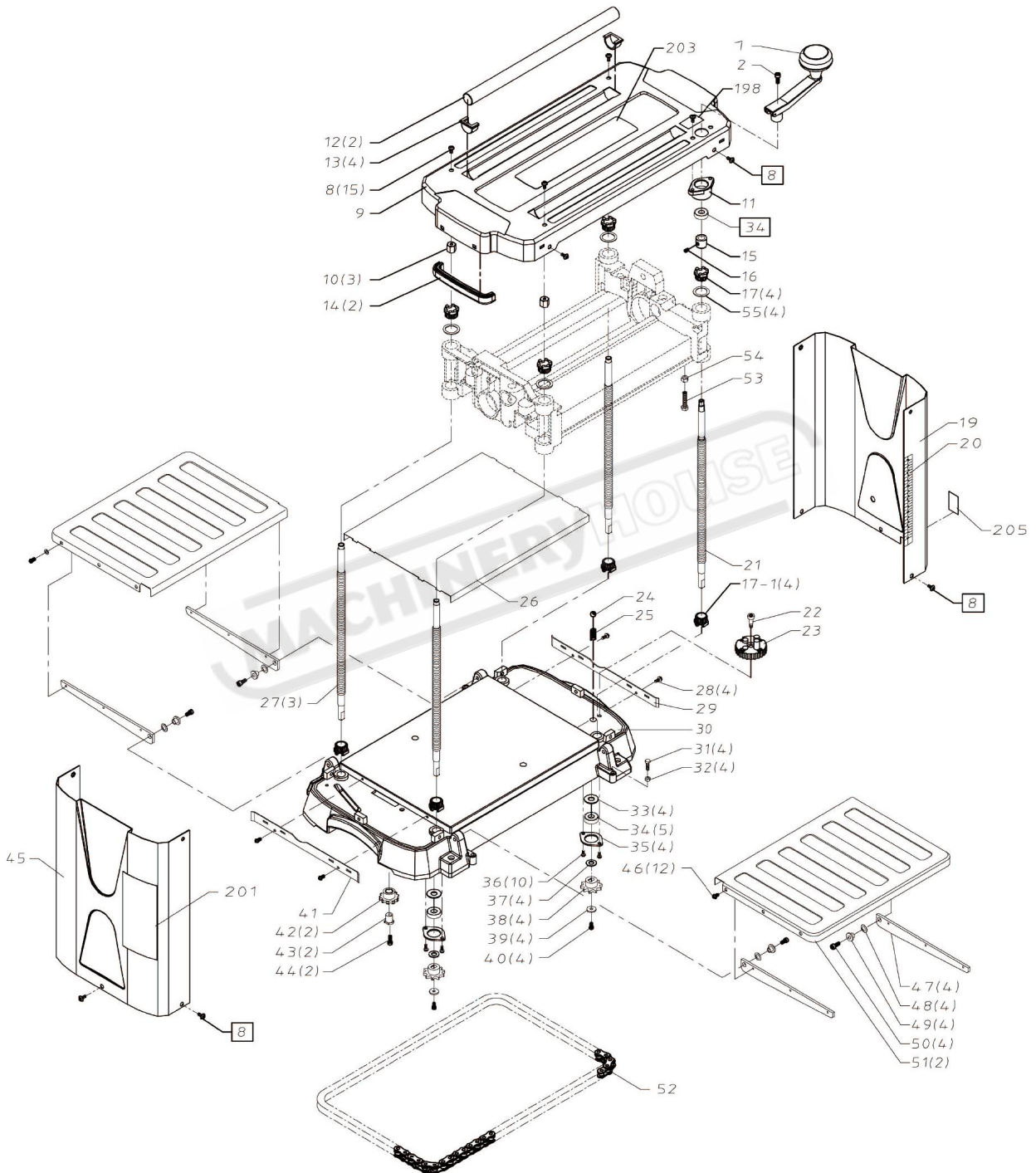
*Date of Issue* : 04/2020

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

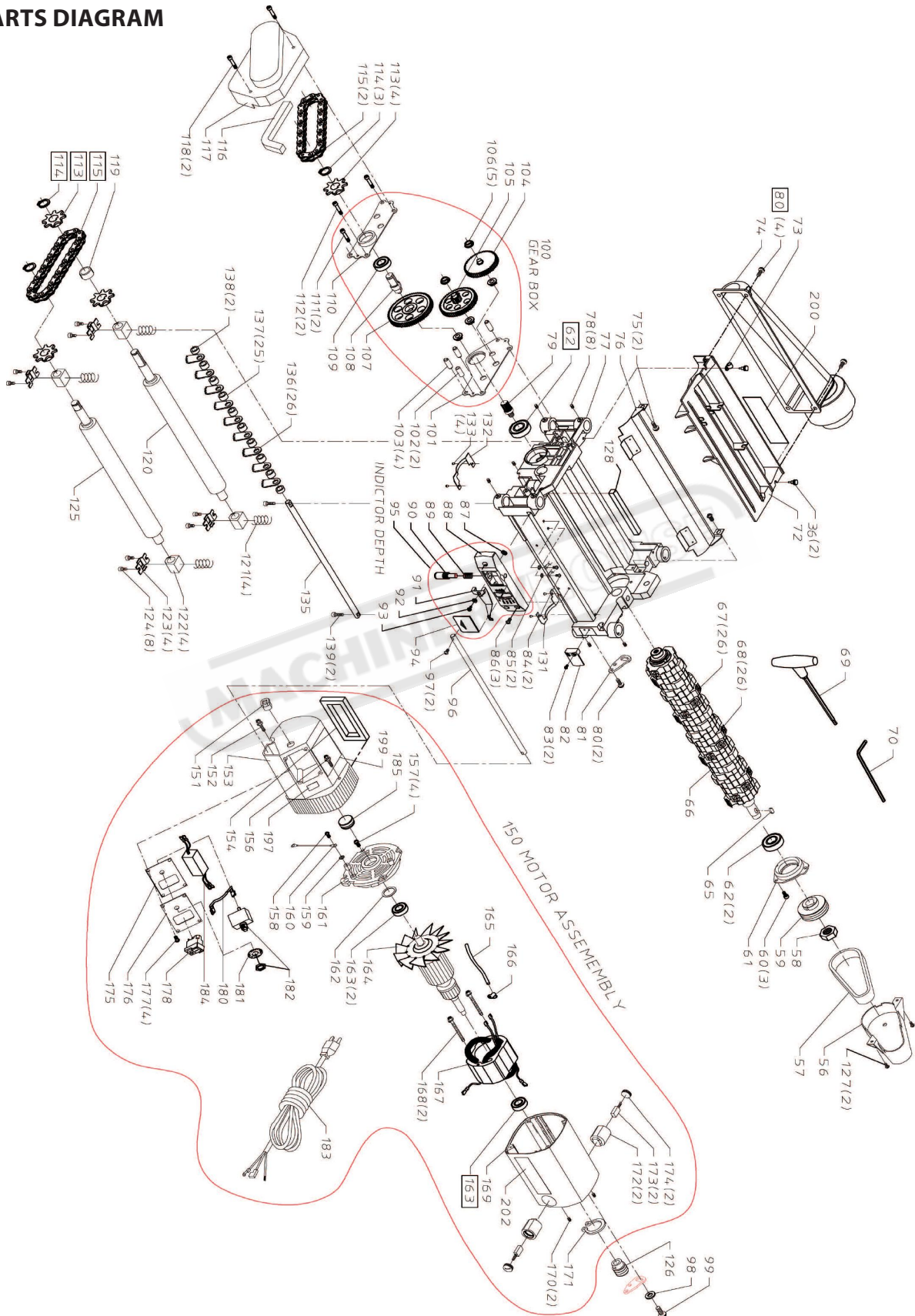
#### HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to [www.machineryhouse.com.au/contactus](http://www.machineryhouse.com.au/contactus) and fill out the enquiry form attaching a copy of scanned parts list.

**PARTS DIAGRAM**



**PARTS DIAGRAM**



**OPERATION MANUAL**

**PARTS LIST**

ITEM	DESCRIPTION	QTY.	ITEM	DESCRIPTION	QTY.
1	HANDLE ASSEMBLY	1	49	TABLE BUSHING	4
2	M5XP0.8X20L HEX SOC HD SCR	1	50	M6XP1.0X16L PAN HD SCR	4
3	SPINDLE LEVER KNUCKLE	1	51	IN-FEED / OUT-FEED TABLE	2
4-1	HAND KNOB UPPER	1	52	ROLLER CHAIN	1
4-2	HAND KNOB LOWER	1	53	M8XP1.25X45L HEX HD SCREW	1
5	SCREW	1	54	M8XP1.25 HEX NUT	1
6	PLATE	1	55	FLAT WASHER	4
7	SPRING PIN	1	56	BELT GUARD	1
8	M6XP1.0X8L HEX SOC HD CAP SCR	15	57	BELT	1
9	TOP COVER	1	58	M16XP2.0 L.H. HEX NUT	1
10	SHAFT BUSHING	3	59	CUTTERHEAD DRIVE PULLEY	1
11	UPPER BEARING SEAT	1	60	M5XP0.8X12L HEX SOC HD SCR	3
12	ROLLER TUBE	2	61	CUTTERHEAD BEARING CUP	1
13	ROLLER TUBE SEAT	4	62	CUTTERHEAD BEARING (6203ZZ)	2
14	HANDLE BAR	2	63	BEARING RETAINER	1
15	SPACER	1	64	M3XP0.5X8L PAN HD SELF TAP SCR	2
16	M5XP0.8X5L NYLOCK SCR SOC CUP PT	1	65	5X5X12MM KEY	1
17	ELEVATION NUT UPPER	4	66	SPIRAL CUTTERHEAD	1
17-1	ELEVATION NUT LOWER	4	67	SPIRAL CUTTERHEAD TIPS	26
19	RIGHT SIDE COVER	1	68	M5XP0.8 TIPS TORX SCREW	26
20	SCALE	1	69	TORX WRENCH	1
21	HEIGHT ADJ SPINDLE	1	70	HEX WRENCH	1
22	M6XP1.0 SPECIAL BOLT	1	72	DUST CHUTE	1
23	TURNING TRAY	1	73	POWER CORD CLAMP	1
24	STEEL BALL	1	74	ADAPTER	1
25	COIL SPRING	1	75	M6XP1.0X10L HEX SOC HD CAP SCR	2
26	WEAR PLATE	1	76	DEFLECTOR	1
27	SPINDLE	3	77	UPPER FRAME	1
28	M4XP0.7X10L PAN HD SCR	4	78	M5XP0.8X6L CONE SET SCR	8
29	BASE GUIDE RAIL RIGHT	1	79	CUTTERHEAD PINION GEAR	1
30	BASE	1	80	M6XP1.0X12L HEX SOC HD CAP SCR	6
31	M6XP1.0X20L HEX HD SCREW	4	81	MOTOR MTG PLATE	1
32	M6XP1.0 HEX NUT	4	82	CURSOR	1
33	FLAT WASHER	4	83	M3XP0.5X16L ROUND HD SCR	2
34	SPINDLE BEARINGS (6000ZZ)	5	84	M5XP0.8X8L PAN HD SCR L/WASH	2
35	BASE BEARING RETAINER	4	85	EXT TOOTH WASHER	2
36	M5XP0.8X12L HEX SOC HD CAP SCR	10	86	M4XP0.7X12L PAN HD SCR	3
37	FLAT WASHER	4	87	SPECIAL NUT	1
38	SPINDLE SPROCKET	4	88	POINTER HOUSING	1
39	FLAT WASHER	4	89	COIL SPRING	1
40	M4XP0.7X12L NYLOCK HEX SOC HD SCR	4	90	ROD POINTER ELEVATING	1
41	BASE GUIDE RAIL LEFT	1	91	POINTER	1
42	IDLE WHEEL	2	92	BUSHING	1
43	IDLE WHEEL SHAFT	2	93	M4XP0.7X10L NYLOCK SCR W/WASH	1
44	M5XP0.8X25L HEX SOC HD SCR	2	94	POINTER HOUSING	1
45	LEFT SIDE COVER	1	95	INDICATOR DEPTH ASSY	1
46	M4XP0.7X6L PAN HD SCR W/WASH	12	96	MOTOR PIVOT ROD	1
47	TABLE SUPPORT	4	97	M5XP0.8X16L HEX SOC HD CAP SCR	2
48	SPRING WASHER	4	98	FLAT WASHER	1

**OPERATION MANUAL**

**PARTS LIST**

ITEM	DESCRIPTION	QTY.	ITEM	DESCRIPTION	QTY.
99	M8XP1.25X20L HEX SOC HD CAP SCR	1	161	MOTOR END CAP	1
100	GEARBOX ASSY	1	162	WAVE WASHER	1
101	REAR GEARBOX PLATE	1	163	BALL BEARING	2
102	SPACER A	2	164	ARMATURE	1
103	SPACER B	4	165	SLEEVE	1
104	GEAR-SMALL	1	166	POWER CORD CLAMP	1
104A	GEAR SHAFT	2	167	FIELD	1
105	GEAR-INTERMEDIATE	1	168	M4.8X75L TAP SCR PAN HD L/WASH	2
106	BUSHING	5	169	MOTOR HOUSING	1
107	GEAR-LARGER	1	170	M5XP0.8X8MM HEX SOC SET SCR	2
108	GEAR SHAFT	1	171	RING RETAINING	1
109	BEARING (6002ZZ)	1	172	BRUSH HOLDER	2
110	FRONT GEARBOX PLATE	1	173	BRUSH	2
111	M5XP0.8X27L HEX SOC HD SCR	2	174	BRUSH CAP	2
112	M5XP0.8X35L HEX SOC HD SCR	2	175	INSULATOR	1
113	SPROCKET	4	175-1	SWITCH FIXED PLATE	1
114	RING-EXT RET	3	176	SWITCH COVER	1
115	GEARBOX DRIVE CHAIN	2	177	PAN HD TAP SCREW	4
116	CUSHION	1	178	MAGNETIC SWITCH	1
117	GEARBOX GUARD	1	180	CONNECT WIRE	1
118	M5XP0.8X45L HEX SOC HD SCR	2	181	NAME PLATE	1
119	SPROCKET SPACER	1	182	SWITCH RESET	1
120	OUTFEED ROLLER	1	183	POWER CORD	1
121	SPRING	4	183-1	POWER CORD BAG	1
122	BEARING BLOCK	4	184	WAVE FILTER	1
123	BEARING BLOCK RETAINER	4	185	PLUG	1
124	M5XP0.8X10L HEX SOC HD SCR	8	197	ON/OFF LEAEL	1
125	INFEED ROLLER	1	198	ELEVATION INDICATE LEAEL	1
126	MOTOR PULLEY	1	199	NAMEPLATE LEAEL	1
127	M4XP0.7X10L PAN HD SCR W/WASH	2	200	BLADE CHANGE LEAEL	1
128	CUSHION	1	201	WARNING LEAEL	1
131	RIGHT BOTTOM COVER	1	202	LOGO LEAEL	1
132	LEFT BOTTOM COVER	1	203	TOP COVER LOGO LEAEL	1
133	LABEL RIVET	4	204	REP CUT INDICATE LEAEL	1
135	BAR	1			
136	ANTI-KICK JAW	26			
137	SPACER	25			
138	SPACER	2			
139	M5XP0.8X20L HEX SOC HD SCR	2			
150	MOTOR ASSY	1			
151	STRAIN RELIEF BUSHING	1			
152	M5XP0.8X16L PAN HD SCREW L/WASH	1			
153	AIR CHAMBER(MOTOR)	1			
154	CUSHION	1			
156	M5XP0.8X35L PAN HD SCREW W/LOCK	1			
157	M4.2XP1.7X20L TAPING SCR L/WASH	4			
158	M5XP0.8X8L SCR PAN HD CR TYTT	1			
159	LOCKWASHER EXT	1			
160	GROUND WIRE	1			

# WARNING

## General Machinery Safety Instructions

---

Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

# WARNING

## Planer Thicknesser Safety Instructions

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### Machinery House

requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure the Planer Thicknesser is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Planer Thicknesser Condition.** Planer Thicknesser must be maintained for a proper working condition. Never operate a Planer Thicknesser that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Blade/Cutter Condition.** Never operate a Planer Thicknesser with dropped, cracked or badly worn blades or cutters. Before using a Planer Thicknesser inspect all blades and cutters. A damaged blade or cutter can cause serious injury.
- 4. Hand Hazard.** Keep hands and fingers clear from the cutter-head, infeed & outfeed table supports. Serious injury can occur.
- 5. Leaving a Planer Thicknesser Unattended.** Always turn the Planer Thicknesser off and make sure all moving parts have come to a complete stop before leaving the Planer Thicknesser. Do not leave Planer Thicknesser running unattended for any reason.
- 6. Avoiding Entanglement.** Blade guard must be used at all times. Remove loose clothing, belts, or jewelry items. Never wear gloves while machine is in operation. Tie up long hair and use the correct hair nets to avoid any entanglement with the Planer Thicknesser moving parts.
- 7. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 8. Power outage.** In the event of a power failure during use of the Planer Thicknesser, turn off all switches to avoid possible sudden start up once power is restored.
- 9. Work area hazards.** Keep the area around the Planer Thicknesser clean from oil, tools, chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 10. Workpiece Handling.** Supporting the work-piece adequately with additional supports at all times while cutting. This is crucial for making safe cuts and avoiding injury. Never attempt to make a cut with an unstable work-piece. Ensure work piece has stopped feeding before handling.
- 11. Hearing protection and hazards.** Always wear hearing protection as noise generated from cutter-head and work-piece vibration can cause permanent hearing loss over time.
- 12. Thicknesser Infeed clearance safety.** The infeed roller is designed to pull the work-piece into the cutter-head. Always keep hands, clothing, hair away from the infeed roller during operation to prevent serious injury.
- 13. Never look inside thicknesser.** Wood chips fly around inside the thicknesser at a high rate of speed. Do not look inside the thicknesser remove guards or covers during operation.
- 14. Operating position.** The work-piece may kick out during operation. To avoid getting hit, stand to the side of the machine during the entire operation.
- 15. Use correct material.** Only use natural timber. Do not use MDF, plywood, laminates, or other synthetic or man-made products. Thicknessing material not designed for this machine may cause serious injury.
- 16. Planer Cutter-head Alignment.** The top edge of the outfeed table should be aligned with the edge of the knife at top dead centre to avoid kickback. An unaligned table can cause serious injury.
- 17. Joining with the grain.** Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.
- 18. Thicknessing Grain direction.** Thicknessing across the grain may cause the work-piece to kick out. Always thickness with the wood grain or at a small angle.
- 19. Use a Push Stick.** Always use a push stick when whenever surface planing. Never pass your hands directly over the cutter-head without a push stick.
- 20. Blade guards.** Always use blade guards except when rebating. Make sure you replace the guard after rebating.
- 21. Planer Cutting operation.** Always keep the work-piece moving toward the outfeed table until the work-piece has passed completely over the cutter-head. Never feed the work-piece toward the infeed table.
- 22. Stalled blade.** In the case that the cutter-head stalls while in operation, turn the Planer Thicknesser off before freeing the stalled cutter-head.
- 23. Changing between Planer / Thicknesser mode.** Once changed to the required mode either Planer or Thicknesser, always ensure all safety guards and dust chutes are re-fitted before starting machine.
- 24. Work-piece safety.** Inspect your work-piece carefully before feeding it over the cutter-head. Never thickness material that has knots, nails, or staples.
- 25. Dust hazards.** Always use a dust collector when using machine.
- 26. Kickback.** Kickback is defined as high speed expulsion of work-piece from the Planer Thicknesser table cutter-head. Never stand in the kickback zone.
- 27. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

# PLANT SAFETY PROGRAM

## **NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL**

### Planer Thicknesser

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures  
This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace ( WHSA 2011 No10 )

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
A	ENTANGLEMENT CRUSHING	HIGH	Eliminate, avoid loose clothing / Long hair etc. Heavier timber must be supported Be sure that when rising and falling planner tables hands are well away from locating, clamping and pivoting area.
B		MEDIUM	Keep hands clear from infeed & outfeed support rollers during operation.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Isolate power to machine prior to any checks or maintenance. Do not open or clean inside until the machine has completely stopped. Keep hands clear of all blades and moving parts. Use a push stick where necessary. Care must be taken when handling knives.
D	SHEARING	MEDIUM	Make sure all guards are secured shut when machine is on.
F	STRIKING	MEDIUM	Do not stand behind timber when feeding into machine. A face mask must be worn at all times. Ensure to use correct feed rates for material.
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine. Machine should be installed & checked by a Licensed Electrician.
O	OTHER HAZARDS, NOISE, DUST.	LOW	Wear hearing protection as required. Must be connected to dust extraction
Plant Safety Program to be read in conjunction with manufactures instructions			



[www.machineryhouse.com.au](http://www.machineryhouse.com.au)



[www.machineryhouse.co.nz](http://www.machineryhouse.co.nz)

Authorised and signed by:

Safety officer: .....

Manager: .....

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