

# Thickness Planer Manual



**Please keep this manual for future reference**



## SAFETY INSTRUCTIONS

**IMPORTANT:** carefully read the instructions in this manual as well as the general safety instructions before using this tool.

Keep the packaging material out of the reach of children -- risk of suffocation.

**WARNING !** Always take basic safety precautions when using power tools to safeguard against the risk of fire, electric shock and /or personal injury.

- 1. For safe operation.** We recommend that you take appropriate measures for the protection of hearing if the sound pressure of 85dB (A) is exceeded
- 2. Keep the work area clean.** Cluttered work areas increase the risk of accidents and injuries.
- 3. Keep the workplace environment safe.** Do not use power tools in damp or wet areas. Do not expose power tools to rain. Make sure the work area is well lit. Do not use power tools in explosive environments, such as in the vicinity of flammable liquids, gases or dust.
- 4. Protect against the risk of electric shock.** Avoid body contact with earthed surfaces, Such as pipes, radiators, cookers and refrigerators.
- 5. Keep children at a safe distance.** Do not allow onlookers to touch the tool or the extension cord. Onlookers should be kept away from the work area.
- 6. Put away tools that are not being used .** When not in use, store the tool in a dry place out of the reach of children.
- 7. Do not force the tool .** The tool does the job better and safer when used at the rate for which it was designed.
- 8. Use the correct machine.** Do not force small machines or accessories to perform jobs that require a powerful machine. Use tools only for their intended purpose. (do not use a circular saw to cut tree branches).
- 9. Wear suitable clothing.** Do not wear loose clothing or jewellery. they can be caught in moving parts. Non-slip shoes are recommended when working outdoors. Wear a hair net if you have long hair.
- 10. Wear safety glasses.** Wear a dust mask if the work generates dust.
- 11. Be careful with the cord.** Never carry the tool by the cord. Do not pull the power cord to disconnect the plug from the mains socket. Keep the power cord away from heat, oil and sharp edges.
- 12. Secure the workpiece.** Secure the workpiece with a clamp, vice or clips. This is safer than using your hands and means you have both hands free to operate the tool.
- 13. Do not overreach.** Always maintain a firm footing and good balance.
- 14. Maintain the tool in good care.** Keep cutting tools sharp and clean for better, safer work. Follow the instructions for lubricating and for the replacement accessories. Check power cords regularly. If damaged, they must be replaced at an authorised service centre. Check extension cords at regular intervals and replace them if they are damaged. Keep the handles clean, dry and free from oil and grease.
- 15. Always unplug the power cord.** when the tool is not being used, and before carrying out service work or changing accessories, such as blades, bits or discs.
- 16 Remove adjuster keys/spanners and other assembling tools.** Remove adjuster keys/spanners and other assembling tools before starting the power tool.
- 17. Avoid accidental starting.** Never carry a power tool with your finger on the switch when it is connected to the mains. Make sure the power switch is in the OFF position before

plugging in the power cord.

**18. If using the tool outdoors.** only use an extension cord approved for outdoor use.

**19. Stay alert .** Always be careful when using the equipment. Use your common sense ,Do not use the tool if you are tired.

**20. Connect dust extraction equipment .** If dust extraction and dust collection equipment is provided. This should be connected and used correctly.

**21. Check for damaged parts.** If a guard or some other part has been damaged, check carefully before using the tool to ensure that it will operate correctly and as intended. Make sure that moving parts are properly adjusted and do not jam and that no parts are incorrectly fitted or damaged. Check for any other factors that could influence functionality. Guards or other parts that are damaged must be repaired or replaced by an authorised service centre. Unless otherwise specified in these instructions. If the power switch does not work, it must be replaced by an suthorised service centre. Do not use the tool if it cannot be switched on and off using the power switch.

**WARNING!** The use of accessories or attachments other than those recommended in these operating instructions can result in personal injury.

Repairs must only be carried out by qualified personnel. This power tool has been manufactured in compliance with current safety standards and requirments. Repair may only be carried out by qualified personnel using identical spare parts. Failure to carry out repairs correctly can result in the risk of personal injury/death or material damage.

**NOTE:** A temporary voltage drop can occur when starting the machine. Which could affect other equipment. If the maina supply's impedance  $Z_{max}$ . is lower than 0.206ohms, this kind of interference is common. Contact your electricity supplier for more information.

## IMPORTANT SAFETY INSTRUCTIONS

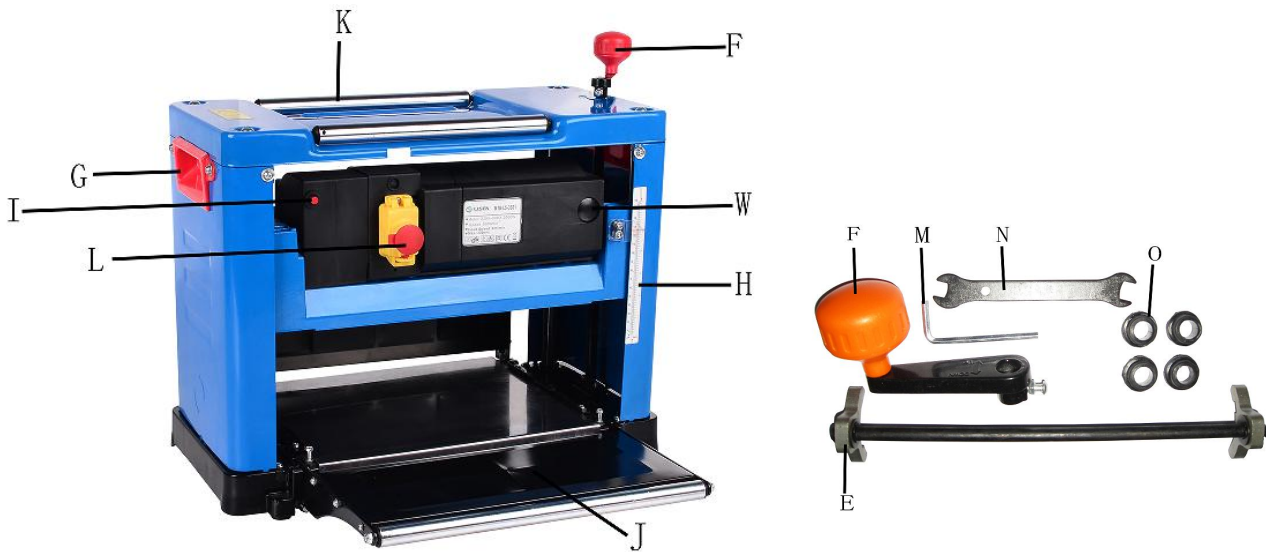
1. Wear safety glasses, Don't cram wood into outfeed side.
2. Before use. check that all screws connections are properly tightened.
3. Do not force the tool. Let the feed mechanism do the work. Never insert objects or body parts in the outfeed.
4. Check regularly that the rubber roller and iron roller are clean. If the rollers are contaminated the workpiece will not infeed correctly- risk of persona injury.
5. Do not machine workpieces with many knots or sprigs.
6. The operating position is in front of the machine. Stand by the side of the infeed table.
7. Remove any nails,screws and other metal objects from the workpiece before machining.
8. Check that the blades are correctly installed.
9. Handle the knife blades with care--risk of personal injury and/or damage to property.
10. Never start to planer until the blade holder has reached full speed.
11. Never use blunt blades-risk of kickback.
12. Always replace or sharpen both blades at the same time. Both blades must be of the same size and weight.
13. Never insert your fingers or other body parts in the chip outlet--risk of personal injury--DANGER.
14. Pls check the recoil claw is in the correct position.
15. If infeed wood not smooth,pls don't force the wood,check if machine have some problems.

## TECHNICAL DATA

Model:	M1B-LS-3301		
Specs:			
Motor:	230V/50Hz 2000W	Planing depth:	0-3mm
Knife shaft speed :	8000 r/min	Planing height:	6-160mm
Feed Speed:	6m/min	Working table size:	330x290mm
Max.planing width:	330mm	Exterior size:	525x696x480mm
No. of blade:	2pcs	Packing size:	57x36x45.5cm
G.W/N.W:	30.5/27.5kg		

## DESCRIPTION

1. The tool is designed for planing wooden planks and dry wood. It is forbidden to plane other materials, such as metals、plastics、branches、tree trunks and wet wood.
2. The tool is intended for household and professional use .
3. Pls use this machine under correct operation, if don't know how to use it, pls contact with factory.



E-Knife blade bit gauge

H-depth label

K-Roller bar

N-Open spanner

F-Depth adjustment handle

I-Overcurrent protective device

L-Switch

O-Rubber feet

G-Carrying handle

J-Extension table

M-Allen wrench

W-Carbon brush cover

Advised wear ear protection.

Advised wear safety glasses.



## OPERATION STEPS

### Unpacking

Carefully unpack the machine. The packaging must be recycled in accordance with local regulations.

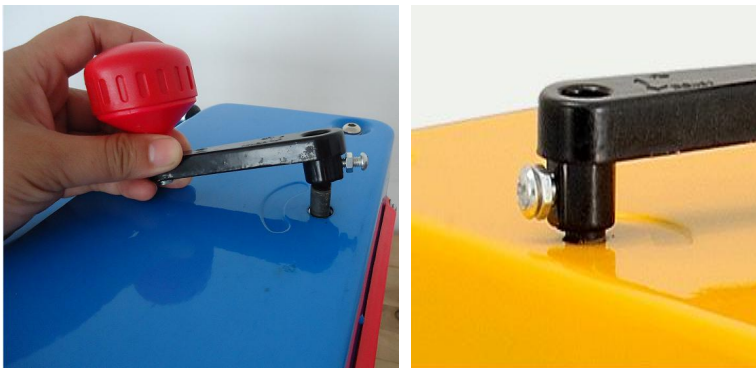
**WARNING!** Turn off the machine and unplug the power cord before cleaning, performing maintenance and adjustment.

### Assembly

Before using the machine must be in accordance with the requirements of the assembly complete.

### Install depth Adjustment handle

Place the depth adjustment handle (F) on the protruding shaft to the right of the machine's top surface. Push on the handle firmly and lock it with the supplied screw.



### Adjust depth of the planer

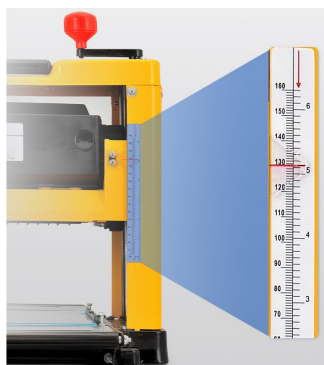
**In order to be able to completely correct and safe operate this machine, User must be know how to correct adjust.**

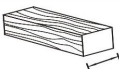
**Very Important!!!**

Rotate the depth adjustment handle(F) a circle, the machine depth can be rised or lowered by 1.5 mm.

Before using, pls planer the wood a few times, that's can be ensure the surgace of the wood is completely horizontal in later use.

Please refer to the correct wood width range to adjust the depth of the one-time planer:



 width of wood (mm)	cutting depth (mm)
0 ~ 100	0 ~ 3
160 ~ 210	0 ~ 2
210 ~ 330	0 ~ 1



At first, user needs a ruler to measure the thickness of the wood to be planed, Then observation depth label (H) to adjust the depth label to the thickness of the planer required by the user.

Such as: the thickness of wood it's 200mm, user wants to planer 2mm, so depth label pointer is at 198mm, In this way, the thickness required by the user can be reached during the one-time working process.

Pls note: The distance between the bottom of the machine and the knife shaft is the thickness of the wood when it is planed; The difference between the thickness of the wood when it comes out of the machine and the thickness when it comes in is the thickness of the wood that was shaved off.

### **Warning!**

It is forbidden to planer the thickness above 2.5mm at one-time.

The length of the wood must not be less than 153mm. The thickness of the wood must not be less than 125mm.

### **Operate switch (power ON/OFF)**

Plug the power cord into the mains supply. If you are using an extension cord, the cross section of the conductors must be sufficient for the tool's power supply. Avoid inappropriate use of cable. as this can lead to voltage drop and cause power loss and over heating.



This planer is equipped with an electromagnetic switch.

Press the green button marked "I" to start the machine.

Press the red button marked "O" to stop the machine.

### **Overcurrent protective device correct use and replacement (I)**

When the load power is too large, the current exceeds the load, so the overcurrent protective device will jump!

1. When the overcurrent protective device jump, first disconnect the power supply of the machine, then press the protective button to reset it
2. When press the protective button to reset it, don't reboot immediately. Need wait for the machine temperature to cool then start for use.
3. If overcurrent protective device jump frequently. Pls replacement a new.

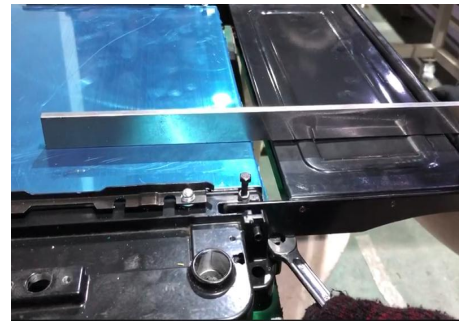
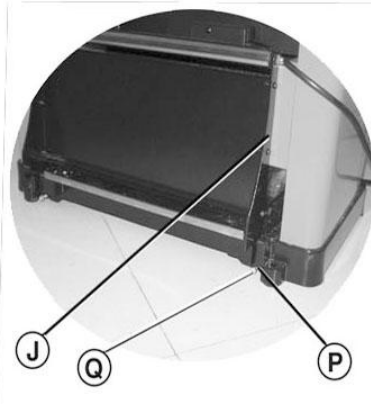
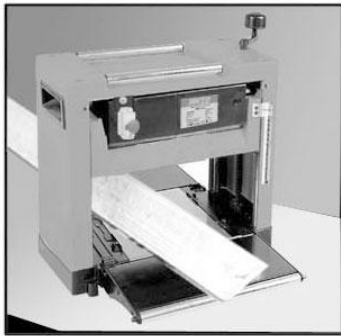


### **ADJUST TABLE EXTENSION (J)**

**Attention:** this adjustment is already factory set ok, in order to avoid to effecting the function

of the machine . need to check again.

1. Put the blade holder rise to a suitable height , so that it is easily assembly.
2. Place a horizontal rule on the main worktable, use rule to measure the table extension (J) and main worktable's level.
3. If the table extension (J) are not flush with the main worktable, loosen the nut (P) and turn the screw (Q) until table extension's rollers and the main worktable touch the ruler, Adjust both the left and right -hand table extensions (J).

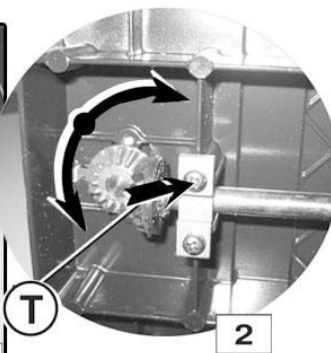
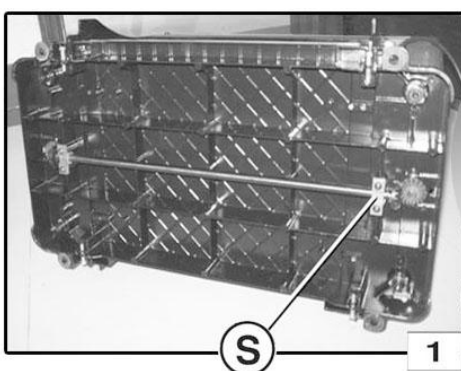


### PARALLELISM ADJUSTING

ATTENTION: This adjustment is already factory set ok. in order to avoid to effecting the function of the machine. need to check again.

Poor parallelism is usually caused by misaligned blades. Always check that the blade holder and the work table parallel before attempting to adjust the parallelism setting.

1. Place the machine on its side and rotate the cross rod bearings (S) fig.1 .
2. Move the conical gear wheel (T) towards the clamp until it runs freely from the second gear wheel (fig.2).
3. Turn the second gear wheel to adjust the height of the blade holder on the side where the gear wheels are located. One tooth shifting anti-clockwise raises the blade holder 0.1mm (H).



### Replacing and Adjusting the blades

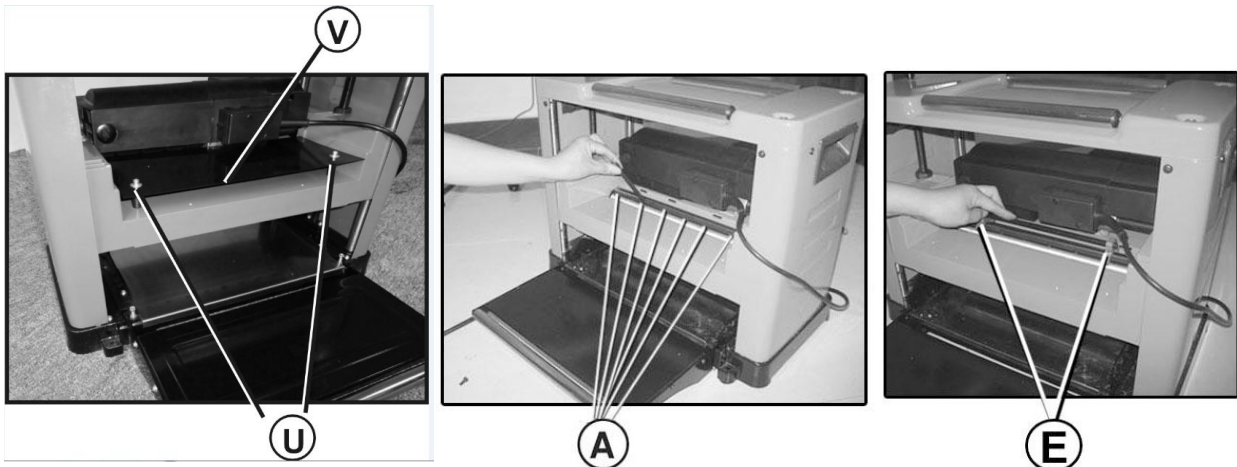
**WARNING !** Turn off the machine, unplug the power cord and wait until all moving parts have stopped completely before replacing or adjusting the blades.

### Dismantling the knife blade

1. Use allen wrench (N) to remove the dust hood (V) by loosening the screws (U), see below picture.
2. Use the double open wrench (N) to loosen the blade locking plate (B) and knife blade (C)

by turning the outer hexagon bolt (A) clockwise. The knife blades are spring-loaded (D) and can be removed when the blade locking plate is removed.

3. Remove the knife blade and blade locking plate.

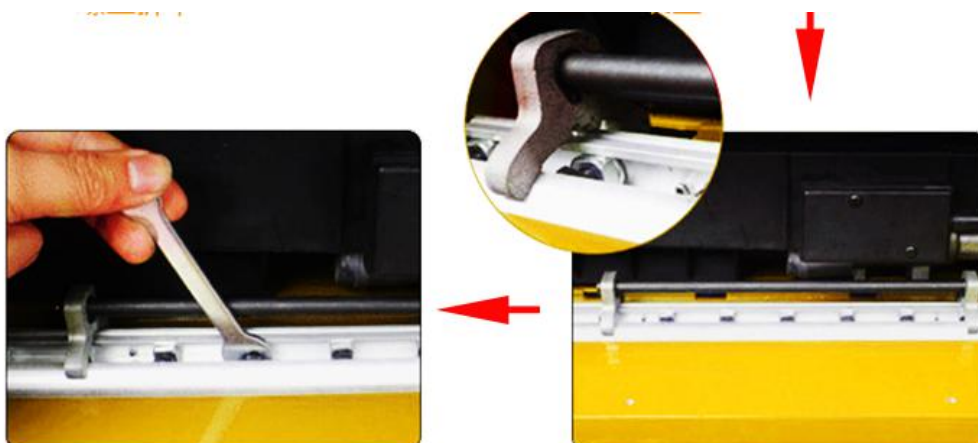
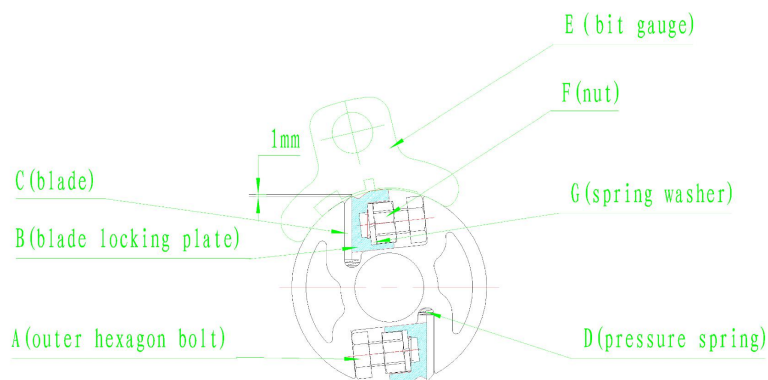


### Install the knife blade

1. Place the knife blade against the blade locking plate, in the correct position relative to the pins.

2. Insert the knife blade and knife locking plate together in the slot and lock in position by turning the outer hexagon bolt (A) anticlockwise. Ensure that the blades face in the right direction (see picture).

3. Set the height of the knife shaft of the knife blades as 1mm with the bit gauge, That two support blocks on left and right side of bit gauge are pressed against the knife blade. (Loosen, if necessary, the clamping screws to move the blade to the correct position. ) When the knife blade is positioned correctly. Hold it firmly in place and tighten all outer hexagon bolt (A).





**Warning!** Check that total 18 screws are tightened. Turn the blade holder by hand to check that it rotates easily and smoothly.

Handle the blades with caution to avoid personal injury and/or damage to property.

## **OPERATION**

### **Coarse PLANING**

Coarse planing is used to provide a reference surface for machining.

1. Set a small removal setting for the best surface finish.
2. Process where possible along the grain.

Note :the surface finish is affected by various factors.

1. the wood's hardness、 moisture content、 fibre structure. etc.
2. Blade sharpness、 machining direction、 material removal per pass. etc.
3. Perform test machining to find the best setting.

## **PLANING**

Planing involves material removal of the workpiece to the desired thickness, the machining of the surface opposite a coarse planed reference surface.

The maximum material removal per pass is 2.5mm, Multiple machining passes may be needed.

## **MAINTENANCE**

**WARNING :** Turn off the machine and unplug the power cord before cleaning and maintenance, Do not use water or other liquids to clean electrical parts,

### **CHECK AND REPLACING THE CARBON BRUSH**

1. Turn off the machine, unplug the power cord and wait until all moving parts have stopped completely.
2. Dismantle the carbon brush cover (W) as illustrated using a screw driver.
3. Replace the carbon brush, the minimum length of each brush should be 6mm.
4. Fit the new carbon brushes. Always replace both carbon brush at the same time.
5. Replace the carbon brush cover (W).

### **LUBRICATION :**

1. Regularly remove shavings from the depth setting chains、 reduction drive and lifting screws for the blade holder.
2. Remove chips with a cloth and brush and lightly grease with a clean brush dipped in oil.
3. Never pour oil directly on the components-- too much oil means dust will stick and impair lubrication, which in turn shortens component life.
4. The blade holder's bearings are sealed and must not be lubricated.

## **MAINTENANCE**

1. Keep the machine clean and free of dust and chips.
2. Clean reapped materials from the blade holder and tongues and carefully lubricate with a clean brush dipped in oil.
3. Remove resin and the like from the rollers and work table with a non-flammable solvent.
4. Clean plastic parts with a damp cloth and mild detergent. Never immerse the tool in water or any other liquid. Never use detergents or alcohol.
5. Always check that all guards and other components are correctly fitted before use. Guards or other parts that are damaged must be repaired or replaced by an authorised service centre, unless otherwise specified in these instructions.

## **THE ENVIRONMENT**



Preserve the health of people by safeguarding natural resources and the environment .