

WOODFAST

Planer & Thicknesser
PT310A

Instruction Manual

IMPORTANT

For your safety read instructions carefully before assembling or using this product. Save this manual for future reference.



Original Instruction
V.4-202005

HEALTH AND SAFETY GUIDELINES

Always follow the instructions provided with the manual. Always wear safety glasses when using woodworking equipment. Always disconnect the power before adjusting any equipment. Failure to observe proper safety procedures and guidelines can result in serious injury.

WARNING: Do not allow familiarity (gained from frequent use of your machine and accessories) to become commonplace. Always remember that a careless fraction of a second is sufficient to inflict severe injury.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

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1. General Information

1.1 FOREWORD

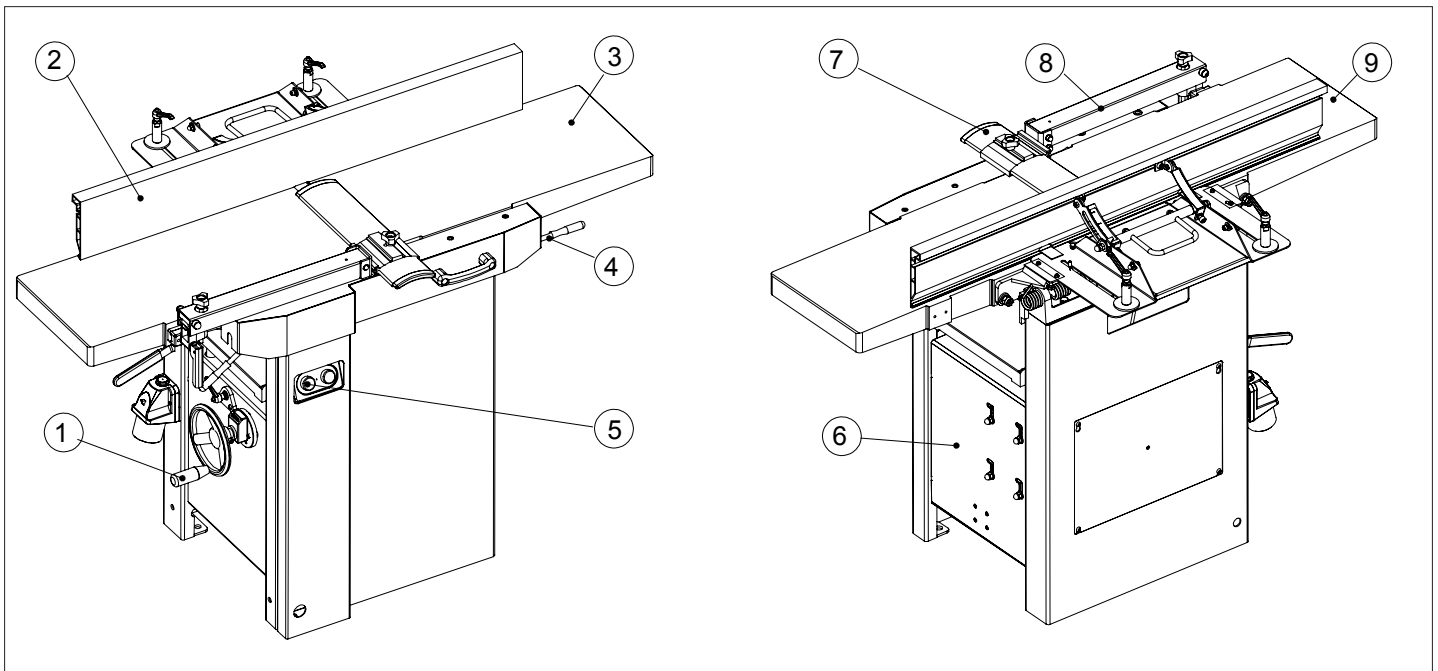
This manual must be read and understood before operating the machine. This will provide a better working knowledge of the machine, for increased safety and to obtain the best results.

2. Machine Description

2.1 MACHINE IDENTIFICATION

There is a metallic identification plate fixed to the machine, containing the manufacturer's data, year of construction, serial number.

2.2 GETTING TO KNOW YOUR MACHINE



- 1 Height setting of thicknesser bed
- 2 Jointer fence
- 3 Infeed table
- 4 Height setting of infeed table

- 5 On/off switch
- 6 Frame
- 7 Cutterblock
- 8 Cutterblock guard
- 9 Outfeed table

2.3 TECHNICAL SPECIFICATION

SPECIFICATION	PT310A
Feed speed m/min	7
Cutterblock speed rpm	5500
Cutterblock diameter mm	70
Max thicknesser capacity mm	310x225
Max planing width mm	310
Max depth of cut thicknesser mm	3
Max depth of cut planer mm	3
Knives pcs	3
Fence tilting degree	0-45
Motor power output	220-240V/2.5kW 380-415V/2.2kW
Net Weight kg	230

2.4 RECOMMENDED PROTECTIVE CLOTHING

- Non-slip footwear is recommended.
- Do not wear loose clothing, neckties or jewellery; they can be caught in moving parts.
- Roll up long sleeves above the elbow.
- Wear protective hair covering to contain long hair.

2.5 NOISE EMISSION

The measurements of noise, in the working position and during operation, were carried out under the standard ISO 7960 Annex B and C:

Instantaneous acoustic pressure:

Sound power level(no load)	<98dB(A)
Sound power level(load)	<107dB(A)
Sound Pressure level(no load)	<89dB(A)
Sound Pressure level(load)	<98dB(A)

Constant K=4 dB measured in accordance with EN ISO 3746:1995

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. Also the permissible exposure level can vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.

2.6 PRESCRIBED USE OF THE MACHINE

This machine is intended for surface planing and thickness planing of solid woods. The permissible workpiece dimensions must be observed (see Technical Specification).

Any other use is not as specified. Unspecified use, modification of the machine or use of parts not tested and approved by the equipment manufacturer can cause unforeseen damage.

2.7 HAZARDS

ATTENTION Planer & thicknesser still present risks that cannot be eliminated by the manufacturer. Therefore the user must be aware that wood working machines are dangerous if not used with care and all safety precautions adhered to.

2.8 SAFETY INSTRUCTIONS FOR PLANER.THICKNESSER

A planer/thicknesser is a tool which can, due to operator carelessness, cause serious personal injury. It is therefore strongly recommended you read and observe:

- these instructions, particularly the special safety information in the respective chapters;
- the relevant guidelines or regulations for the prevention of accidents pertaining to the use of planer/thicknessers, where applicable.

Keep all documents, supplied with the machine, for future reference.

The planer/thicknesser shall only be started and operated by persons familiar with planer/thicknessers and who are at any time aware of the dangers associated with the operation of such tool. Persons under 18 years of age shall use this planer/thicknesser only under the supervision of an instructor in the course of their vocational training.

The following residual risks do principally exist with planer/thicknessers and can not, even by employing safety devices, completely eliminated:

- Hazard generated by environmental conditions:

do not operate the planer/thicknesser in rain or damp environment. Ensure sufficient lighting. Do not operate the planer/thicknesser near inflammable liquids or gases.

- Hazard to other persons in the work area:

Keep bystanders, particularly children, out of the danger zone.

- Risk of injury by machine faults:

check the planer/thicknesser for damage before any use. Do not operate the machine with a damaged part. Replace blunt cutter knives at once. Risk of injury by kickback if a blunt knife gets caught in the workpiece's surface.

- Risk of injury by an unstable stand of the planer/thicknesser:

when working long stock use suitable supports on both sides of the machine. Avoid adverse body positions. Ensure firm footing, and keep your balance at all times.

- Risk of injury by foreign objects in the machine:

prior to any starting of the machine ensure that there are no objects (e.g. tools) in the machine.

- Risk of injury by workpiece kickback (workpiece is caught by the rotating cutterblock and thrown back against the operator):

operate machine only with a fully functional anti-kickback lock. Always use sharp cutter knives. If in doubt check workpiece for inclusion of foreign objects (e.g. nails, screws, loose knots).

- Risk of injury by touching the rotating cutterblock:

always keep your hands well clear of the cutterblock. Switch machine off and plug out if it is not used.

- Danger! Drawing-in/trapping hazard!

Take care that no parts of the body or clothing can get caught and drawn in by the rotating cutterblock (do not wear neck ties and garments with wide sleeves; contain long hair with a hairnet).

- Risk of injury by cuts with cutterblock at standstill: Wear gloves when changing cutter knives.

- Risk of injury by inhaling wood dust: dust of certain timber species (e.g. oak, beech, ash) can cause cancer when inhaled. Use a suitable dust collector:

- fitting the outer diameter of the suction port (100 mm)
- air volume $\geq 815 \text{ m}^3/\text{h}$;
- vacuum at suction port of machine $\geq 740 \text{ Pa}$;
- air speed at suction port of machine $\geq 20 \text{ m/s}$;

- Risk of injury by inadequate personal protection: when planing, wear:

- dust respirator;
- hearing protection;
- safety goggles.

3. Installation

3.1. LIFTING AND UNLOADING

The machine can be transported by two means:

- with a forklift truck. To do so, the machine is secured on a pallet with four hex bolts.
- by several persons. Here, the machine is carried by means of carrying straps or two battens (A, Fig.1) placed underneath the thicknesser bed.

CAUTION

Do not carry the machine holding it at the infeed and outfeed tables, these are not designed to withstand the tensile load by the machine weight.

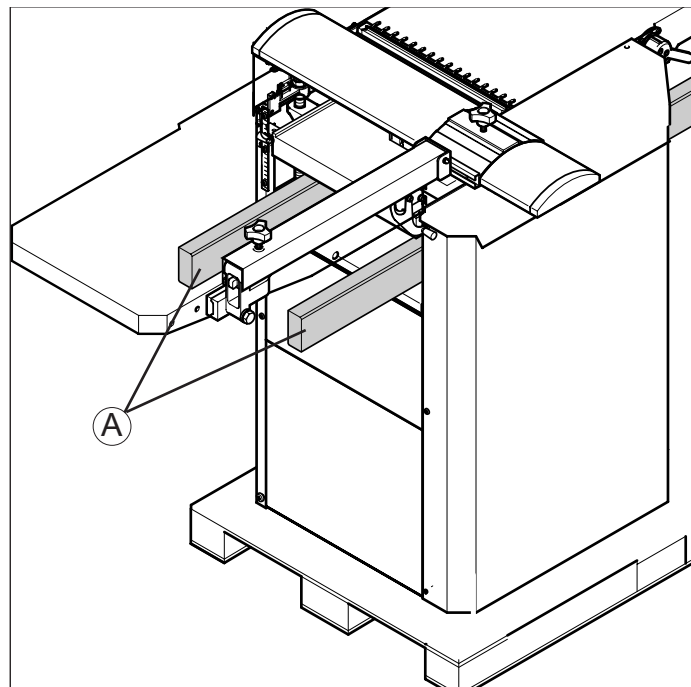


FIG. 1

3.2 POSITION OF THE MACHINE

CAUTION

It is prohibited to install the machine in explosive environments. Ensure that the floor area around the machine is level, well maintained and free from loose material e.g. chips;

1. Remove four mounting bolts from the machine base.
2. Lift machine off the pallet and set down on the floor.
3. Fix the machine to the floor. Fix the machine feet and fix on ground by means of expansion bolts (not supplied).

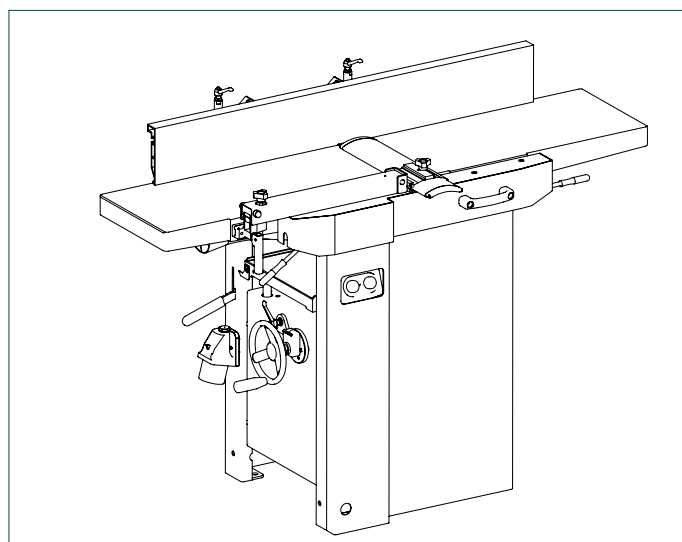


FIG. 2

3.3 IDENTIFYING SHIPPING BOXES

BEFORE ASSEMBLY

It is advisable that before unpacking to have plenty of paper towels or cloths available to clean off the rust preservative.



FIG. 3

3.4. INSTALLATIONS OF LOOSE PARTS

3.4.1 SWITCH - INSTALLATION

- Fit the switch (G, Fig.4) onto the bracket with two hex nuts (H, Fig.7)

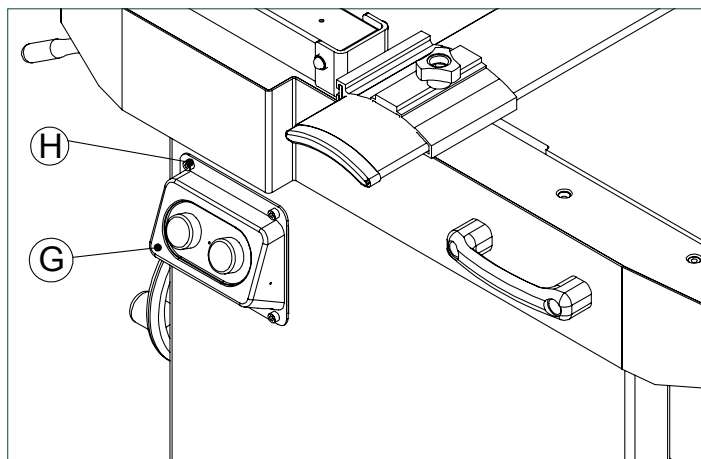


FIG. 4

3.4.2 Cutterblock guard - INSTALLATION

- Take off both of the hex socket screws (A, Fig.5). Install the cutterblock guard assembly (B, Fig.5) using two of hex socket screws. Make sure the square washer (C, Fig. 5) stay between the table and cutterblock guard.

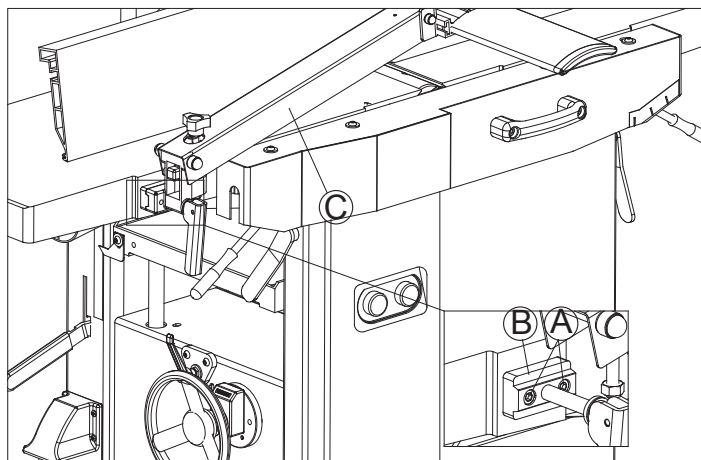


FIG. 5

3.5 ELECTRICAL CONNECTION

Electrical installation should be carried out by competent, qualified personnel.

The mains connection should be made using the terminal box.

Ensure that the mains supply corresponds with that of the machine, use cables of a section suitable for the power of the motor. For a supply tension of 400 V the minimum section recommended is 2.5 mm, including the earth wire.

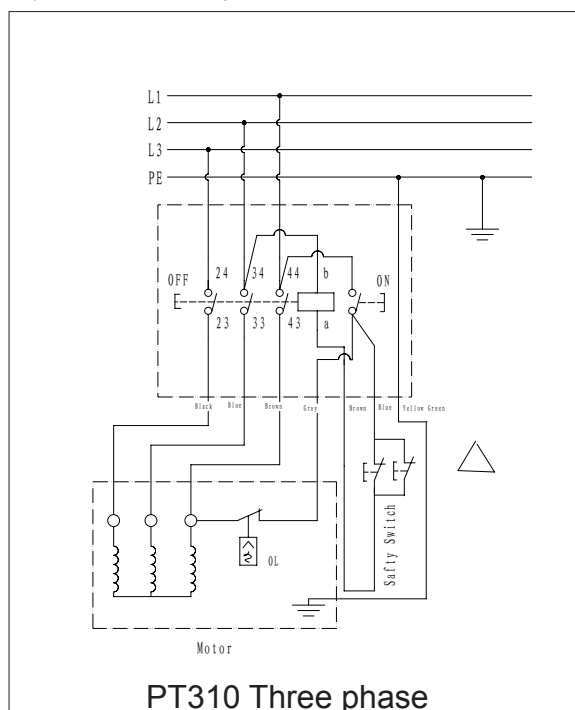
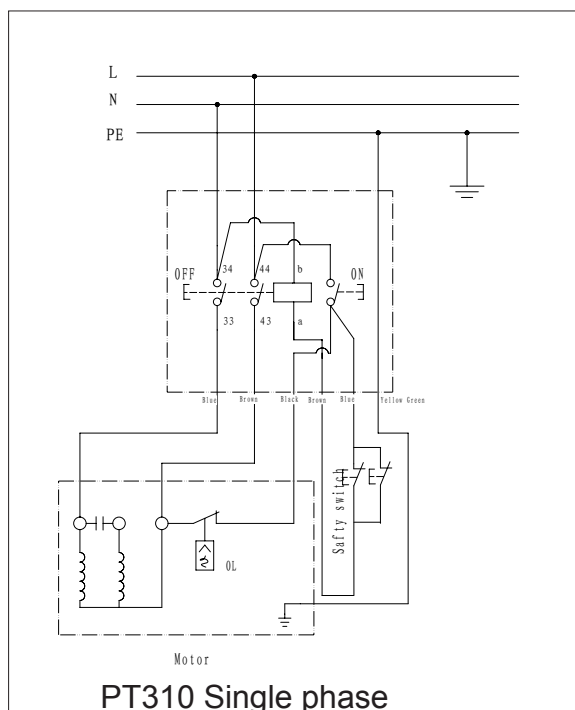
For a mains supply of 230 V or a power rating greater than 15 A it will be necessary to increase the section of the connecting cables .

Connect the phase wires to the terminals R- S - T (L1 - L2 - L3) and the earth wire to the earth terminal.

On initial start-up check the direction of rotation, if it is incorrect then invert the two phase wires (for machines with 3 phase supply).

Direction of rotation of machines with single-phase supply is pre-determined during production .

On completion of the installation check that the terminal box is closed correctly and that the plug points are locked.



3.6. DUST CHUTE - INSTALLATION

The dust chute complete with suction connector must be installed for thickness planing.

CAUTION: The contact pins on the shaft of the dust chute (A, Fig. 6) must engage properly in the limit switch. Incorrectly installed dust chute the machine will not start.

Connect a suitable dust collector to the suction connector of the planer/thicknesser.

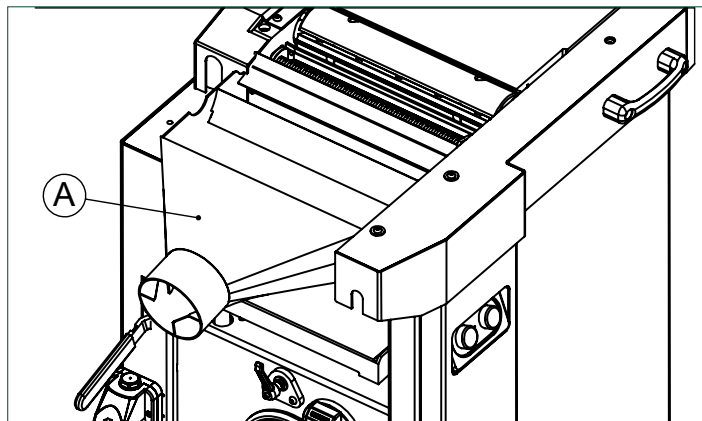


FIG. 6

4. Adjustment

4.1. THICKNESSER TABLE HEIGHT ADJUSTMENT

With the height setting for the thicknesser bed the planing thickness (= thickness of the workpiece after planing) is set when the machine is used for thickness planing.

- Per pass a maximum of 3 mm material can be removed.
- Workpieces of max. 200 mm thickness can be planed. Height adjustment is made with a handwheel (B, Fig.7). One full turn of the crank changes the height of the thicknesser bed (C, Fig.7) by 4 mm.
- Clockwise turning = raises the thicknesser bed
- Counter-clockwise turning = lowers the thicknesser bed. The set planing thickness is indicated on the scale (D, Fig.7).

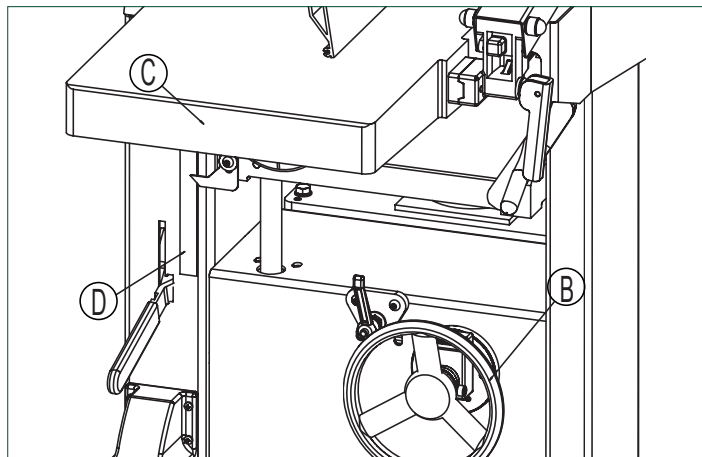


FIG. 7

4.2. INFEEED TABLE HEIGHT ADJUSTMENT

With the height setting for the infeed table (E, Fig.8) the depth of cut is set when the machine is used for surface planing.

- The scale (F, Fig.8) next to the adjusting lever (G, Fig.8) corresponds to 1 mm chip removal.
- Per pass a maximum of 3 mm material can be removed.

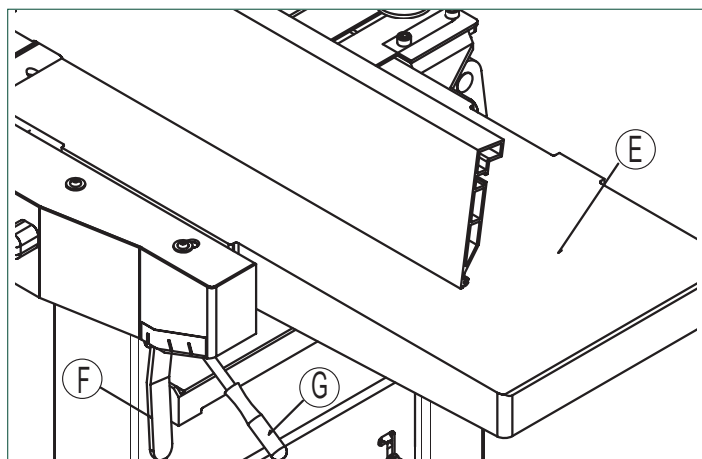


FIG. 8

4.3. JOINTER FENCE ADJUSTMENT

The jointer fence (I, Fig.9) provides lateral support for the workpiece when surface planing.

- After loosening the lock lever (J, Fig.9) the jointer fence can be adapted to the workpiece width.
- After loosening the lock lever (K, Fig.9) the jointer fence extrusion can be tilted to the angle between 0° - 45°.

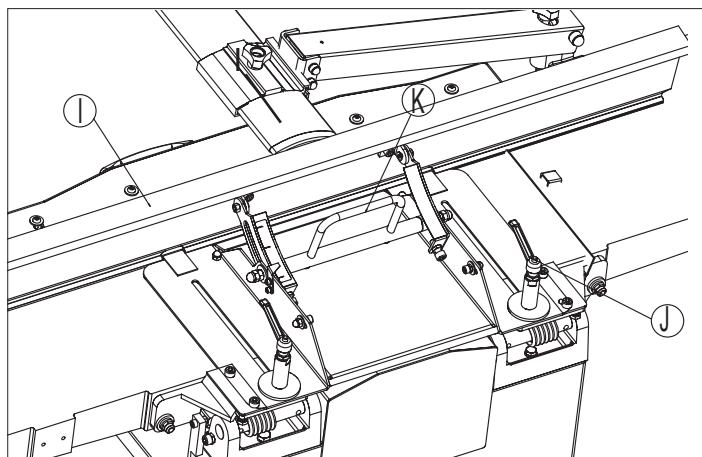


FIG. 9

5. Operating Procedures

5.1. ON/OFF SWITCH (Fig.10)

- To switch ON = press green switch button.
- To switch OFF = close cover or press red switch button.
- To unlock the switch cover push the pin on the stop cover.

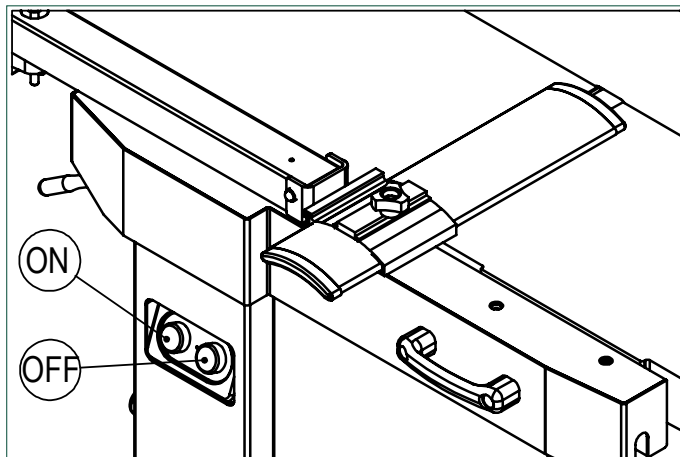


FIG. 10

5.2 SURFACE PLANER MODE:

Note: With surface planing, an irregular surface is planed flat (= jointed).

- The workpiece rests on top of the infeed table.
- The workpiece is cut on the underside.
- The feed direction of the workpiece is exactly opposite than when thickness planing.

Workpiece dimensions

- Length: use a push stick to feed workpieces shorter than 250 mm; for workpieces over 1500 mm use a second person for support.
- Width: max. 310 mm.
- Thickness: min. 5 mm.

Note: The max. depth of cut for a single pass is 3 mm.

1. Assume proper operating position:

position yourself to one side of the infeed table.

2. Set jointer fence as required.

3. Set planing thickness.

4. Release the Belt Lever for Planer Drive Rollers, at the jointer outfeed end of the cabinet. FIG. 13. This will transfer more power directly to the cutterhead.

5. Place workpiece against jointer fence .

6. Adjust cutterblock cover:

- when planing narrow edges (jointing) or workpieces more than 75 mm thick:

Set cutterblock cover from the side against the workpiece (A, Fig.12)..

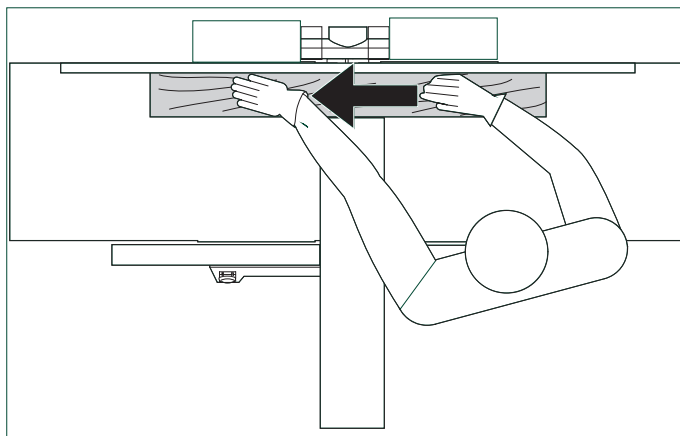


FIG. 11

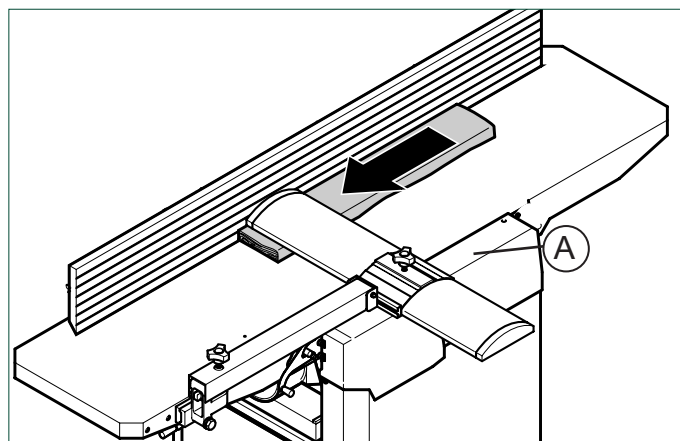


FIG. 12

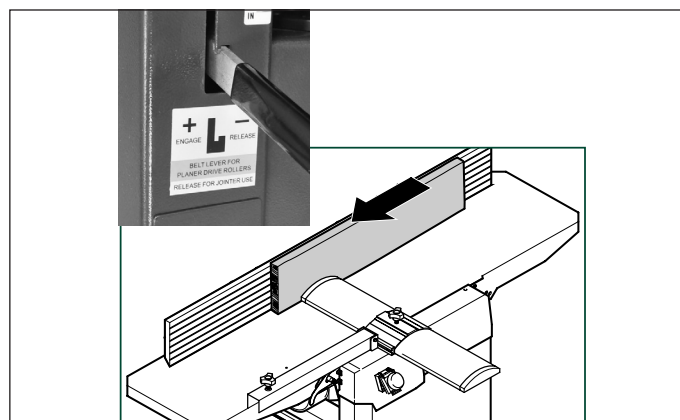


FIG. 13

- Planing the face of a plank or workpieces up to 75 mm thick: lower cutterblock cover from top onto workpiece. Adjust cutterblock cover so that the undermentioned distances are not exceeded in any position:

rear edge (A, Fig.14) – workpiece max. 3 mm;

front edge (B, Fig.14) – workpiece max. 2 mm.

6. Start motor.

7. Feed workpiece straight across the infeed table holding your fingers close together, guiding the workpiece with the palm of your hands. Exert downward pressure on the workpiece only in the infeed table area.

8. Switch machine off if no further cutting is to be done immediately afterwards.

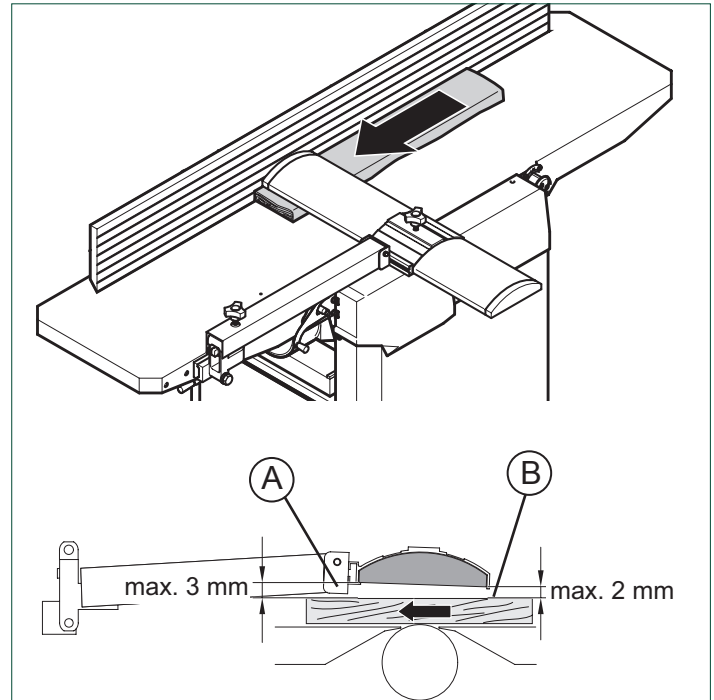


FIG. 14

5.3. THICKNESS PLANER MODE

Note: Thickness planing is used to reduce a workpiece with one already surface planed surface to a desired thickness.

- The workpiece is run through the thicknesser.
- The surface already planed flat rests on the thicknesser bed.
- The workpiece is cut on the upper side.
- The feed direction of the workpiece is exactly opposite than with surface planing.

Workpiece dimensions

- Length: min. 200 mm; for workpieces over 1500 mm use a second person for support.
- Width: max. 305 mm.
- Thickness: min 6 mm; max. 200 mm.

Note: The max. depth of cut for a single pass is 3 mm.

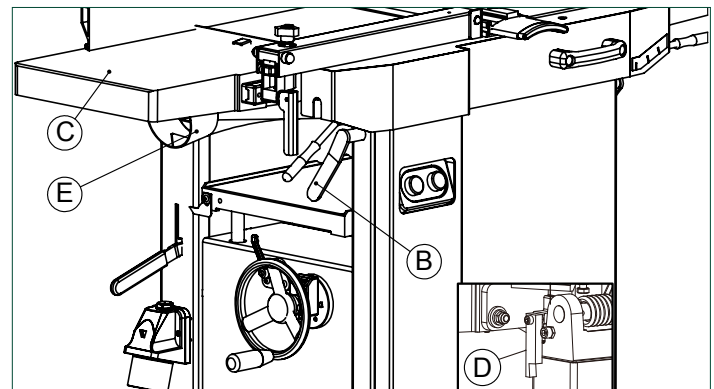
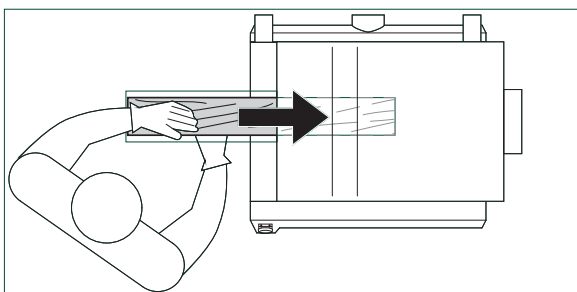
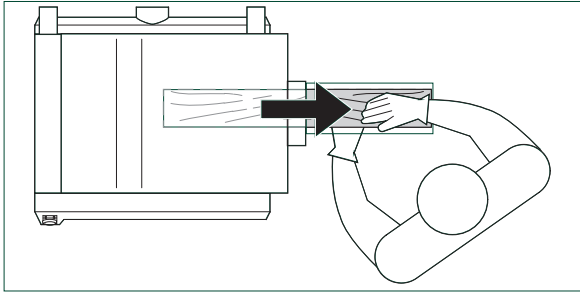


FIG.15

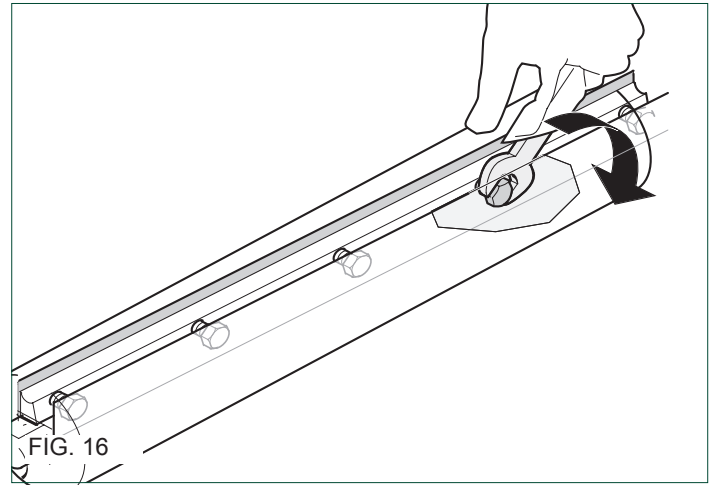
1. Turn clamping lever (B, Fig.15) outward and swing the outfeed table (C, Fig.15) together with the fence to the left. Make sure the outfeed table stopper (D, Fig.15) is engaged (When close the outfeed table, please don't forget the release the stopper first).
2. Turn the dust chute (E, Fig.15) with installed suction connector to the machine .
3. Assume proper operating position:
 - to feed the workpiece into the machine, position yourself offset to one side of the feed opening.



- to remove the workpiece from the machine, position yourself offset to one side of the outfeed opening.



5. To thickness plane stock which surfaces are not parallel, use suitable feeding aids (make fitting templates).
6. Set planing thickness.
7. Start motor.
8. Feed workpiece slowly and straight into the thicknesser. It will then be automatically fed through the thicknesser.
9. Guide workpiece straight through the thicknesser.
10. Switch machine off if no further cutting is to be done immediately afterwards.



6. Maintenance

6.1 REPLACING CUTTER KNIVES

CAUTION! Risk of personal injury by cuts from the cutter knives! Wear gloves when changing cutter knives.

To remove the cutter knives:

1. Unplug power cable.
2. Push fence back.
3. Raise cutterblock cover fully and pull extrusion fully outwards.
4. Turn the five hexagon head screws of the cutter knife lockbar fully in wear gloves! (Fig.16).
5. At first remove cutter knife, then cutter knife lockbar from the cutterblock.
6. Clean all surfaces of cutterblock and cutter knife lockbar with a suitable solvent.
7. Place fresh cutter knife on cutter knife lockbar.
8. Place cutter knife lockbar with the fitted cutter knife into the cutterblock.

9. Check the projection of the knives:

- With the provided straight edge gauge .
- Place straight edge gauge across outfeed table and cutterblock as shown.
- Turn cutterblock by hand one turn against the direction of feed.
- The cutter knives are set correctly if the straight edge is moved forward 4 to 6 mm by the turning cutterblock. This check must be performed at both ends of the cutterblock. (Fig.17)

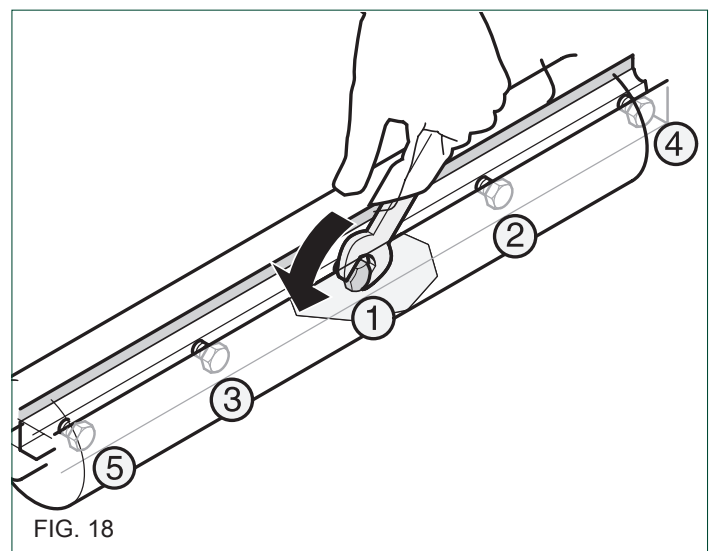
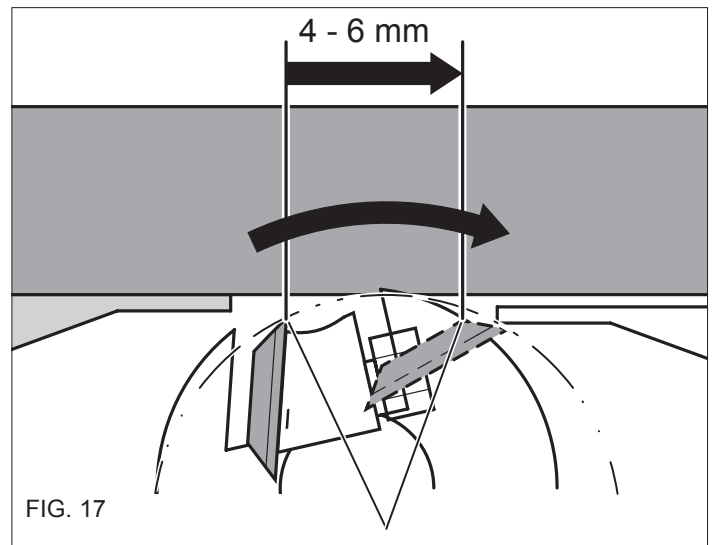
10. To tighten the cutter knives, turn the five hexagon head screws of the cutter knife lockbar fully out. To prevent distortion of the cutter knife lockbar start with the screws in the centre , then tighten the screws closer to the edges step by step.(Fig.18)

Danger!

- Do not extend tool when tightening the screws.
- Do not tighten bolts by striking the wrench.

11. Return cutterblock cover to its starting position.

12. Pull fence forward.

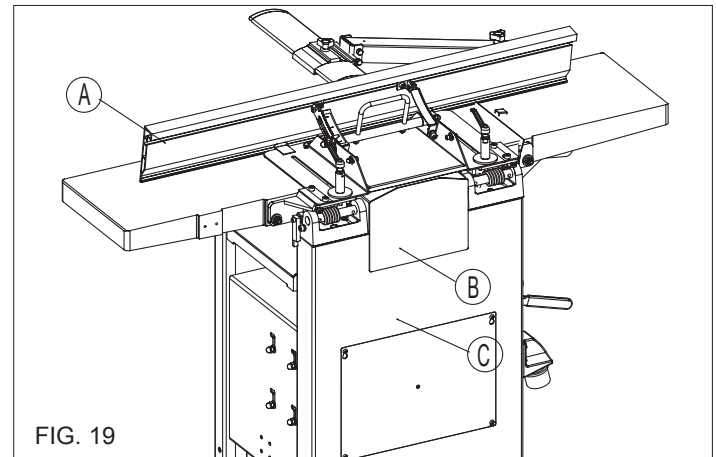


6.2 Drive Belt Check

The cutterblock drive belt and the feedgear drive belt need to be checked periodically and retightened if necessary. Both drive belts are located behind the machine's side panel.

Checking the drive belt:

1. Unplug power cable.
2. Pull the fence (A, Fig.19) forward.
3. Take off the the side panel (B, Fig.19) and belt cover (C, Fig.19).
4. Check belt tension with thumb pressure. The drive belt should not give more than 10 mm in the centre.

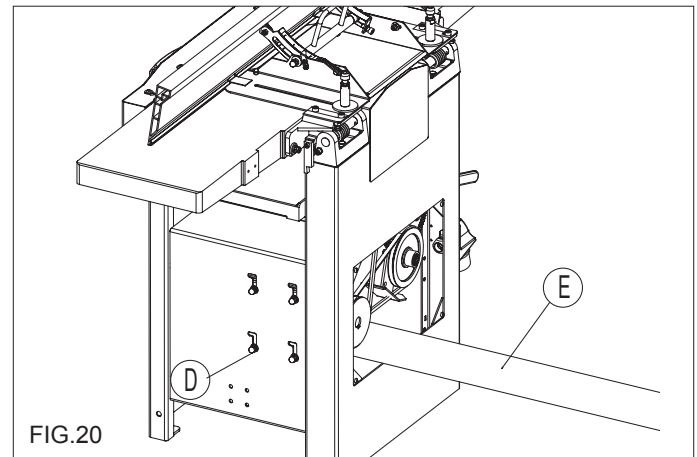


Tensioning the drive belt:

5. From outside the machine, loosen the four nuts (D, Fig.20) – using stick (E, Fig.20) to increase the motor, the cutterblock drive belt will be slackened.

CAUTION: When increase the motor by stick, don't damaged the motor wiring box.

6. To tension the cutterblock drive belt, push the motor downward. When belt tension is correct tighten motor mounting nuts (D, Fig.20).
7. If necessary, remove chips and dust with dust collector or brush.
8. Replace the side panel and belt cover secure with the screws.

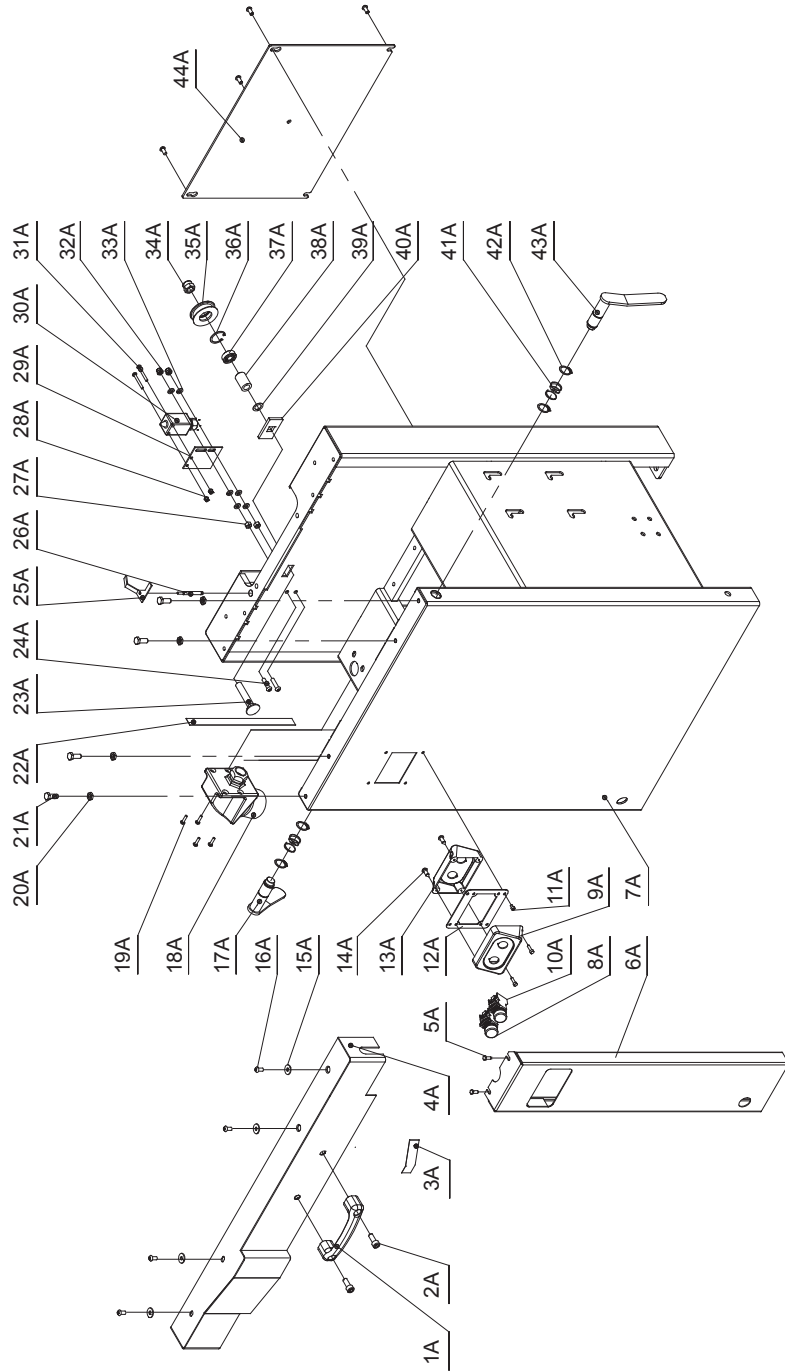


7. Diagrams & Components

7.1 Frame Assembly-SHEET A

Frame Assembly-SHEET A

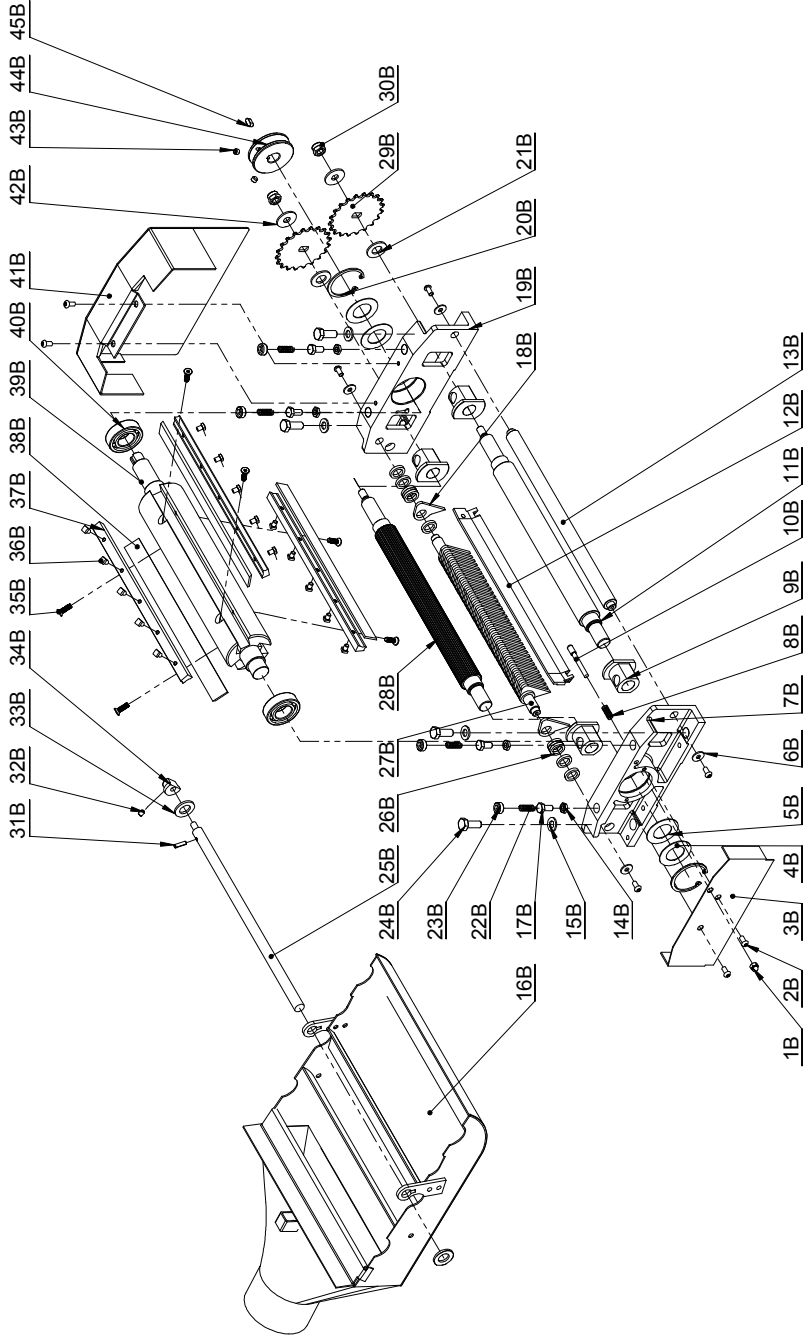
NO.	Description	Part No.	Qty.
1A	Handle	JL45030030A	1
2A	Hex. Screw	M8X20GB70B	2
3A	Label	JL45030031B	1
4A	Left cover	JL45032000C	1
5A	Screw	M6X12GB70D1Z	2
6A	front cover assy	JL45013000	1
7A	Frame	JL45010000F	1
8A	Start knob	LA39-B2-10-g	1
9A	Switch box	JL45090010	1
10A	Stop knob	LA39-B2-01-r	1
11A	Screw	M4X12GB70D1Z	4
12A	switch plate	JL45090009	1
13A	Switch box	JL45090011	1
14A	Tapping screw	ST3D5X16GB845Z	4
15A	Big washer	WSH6GB96B	4
16A	Screw	M6X12GB70D2B	8
17A	Handle	JL45030026	1
18A	Plug	P224E-13A	1
19A	Pan screw	M4X16GB823Z	4
20A	Nut	M8GB6172Z	4
21A	Ball head bolt	JL45030016	4
22A	Scale	JL45040019	1
23A	Square neck bolt	M12X65GB801Z	1
24A	Hex. Screw	M6X25GB70D2B	2
25A	Plate	JL45090003	1
26A	Rod	JL45090005	1
27A	Nut	M6GB41Z	2
28A	Locknut	M4GB889Z	2
29A	Switch plate	JL45090004	1
30A	Switch	QKS7	1
31A	Pan screw	M4X30GB818Z	2
32A	Locknut	M6GB889Z	2
33A	Plat washer	WSH6GB97D1Z	6
34A	Hex.locknut	M12GB889B	1
35A	Idle pulley	JL45052001	1
36A	Ring	CLP28GB893D1B	1
37A	Bearing	BRG6001-2ZGB276	1
38A	Tube	JL45052002	1
39A	Adjust cushion	JL40020004	1
40A	Plate	JL45052003	1
41A	Handle spring	JL45030032	2
42A	Circlip	CLP20GB894D1B	4
43A	Handle	JL45030014	1
44A	Window plate	JL45010004	1



7.2 Tool Carrier Assembly-SHEET B

Tool Carrier Assembly-SHEET B

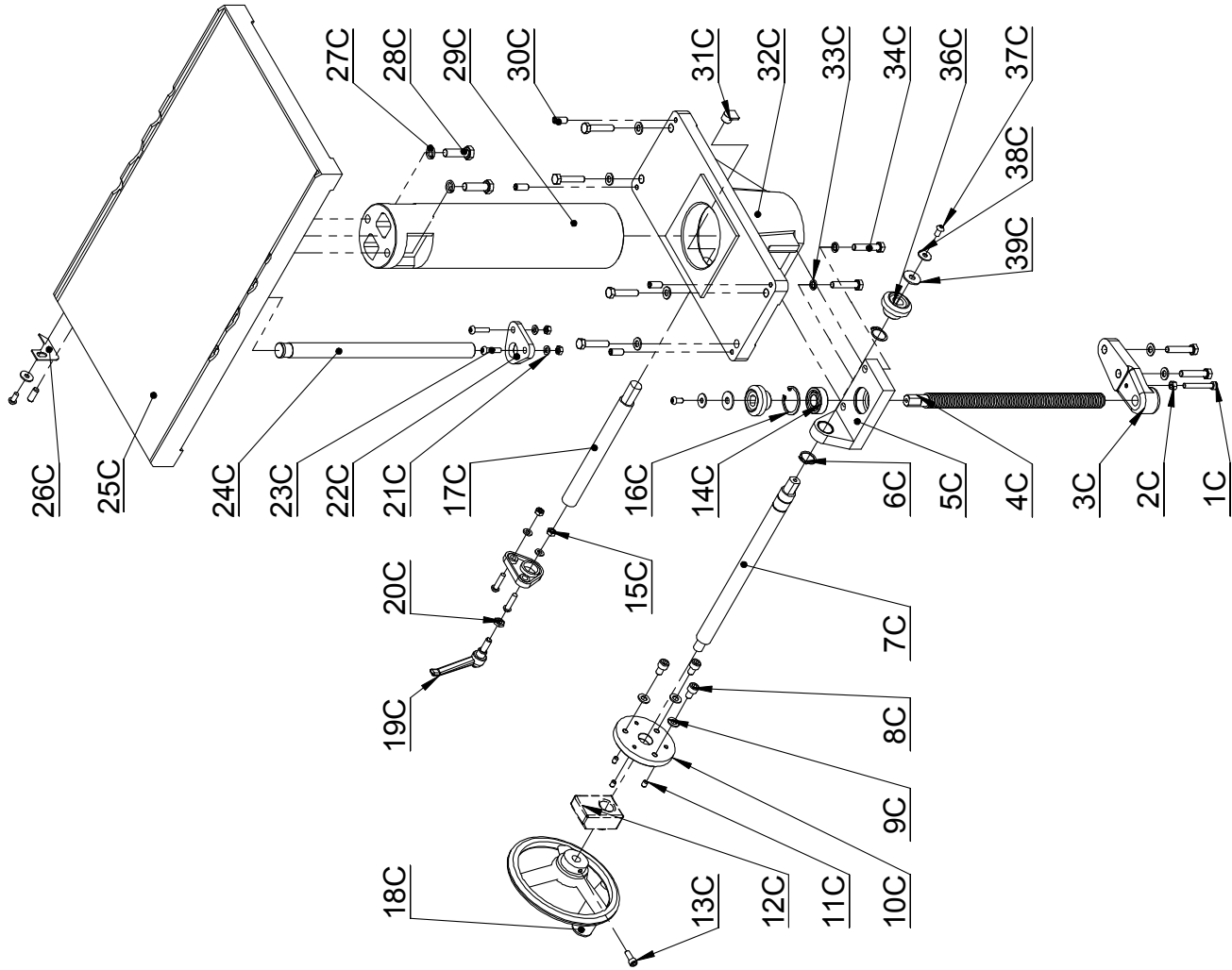
No.	Description	Part No.	Qty.
1B	Cap nut	M6GB923Z	1
2B	Screw	M6X12GB70D2B	8
3B	Inner guide	JL45030023	1
4B	Wave washer	JL45020016	2
5B	Washer	JL45020017	2
6B	Big washer	WSH6GB96B	4
7B	Left cutterhead bracket	JL45020002	1
8B	Spring	JL41025102	1
9B	Shaft sleeve	JL45020006	4
10B	Location pin	JL45023001	1
11B	Outfeed roller	JL45020007	1
12B	Dust board	JL45020013	1
13B	Shaft	JL45020012	1
14B	Nut	M8GB617ZZ	4
15B	Washer	WSH10GB97D1B	4
16B	Dust collector	JL45022000	1
17B	Hexagon bolt	M8X16GB5781Z	4
18B	Non-return block	JL45020010A	18
19B	Right cutterhead bracket	JL45020001	1
20B	Retainer ring	CLP52GB893D1B	2
21B	Washer	JL45051005	2
22B	Spring	JL45020004	4
23B	Screw	JL45020003	4
24B	Hexagon bolt	M10X25GB5783B	4
25B	Rod	JL45020009	1
26B	Bush	JL45020011	27
27B	Rod	JL45020008	1
28B	Infeed roller	JL45020005	1
29B	Big chain wheel	JL45050003	2
30B	Hexagonal self-locking nut	M10GB889Z	2
31B	Pin	PIN5X18GB879B	1
32B	Set screw	M6X8GB77B	1
33B	Flat washer	WSH16GB97D1Z	2
34B	Small eccentric wheel	JL45090002	1
35B	Hexagonal sunk screw	M6X20GB70D3B	6
36B	Square head screw	JL41010007	15
37B	Bar	JL45021003	3
38B	Knife	JL45021002	3
39B	Cutter shaft	JL45021001	1
40B	Bearing	BRG6205-DDUC3	2
41B	Right guard	JL45031000	1
42B	Big washer	WSH10GB96Z	2
43B	Set screw	M8X6GB77B	2
44B	Belt pulley for cutter shaft	JL45050001	1
45B	Flat key	PLN6X16GB1096	1



7.3 Press Planing Machine Assembly-SHEET C

Press Planing Machine Assembly-SHEET C

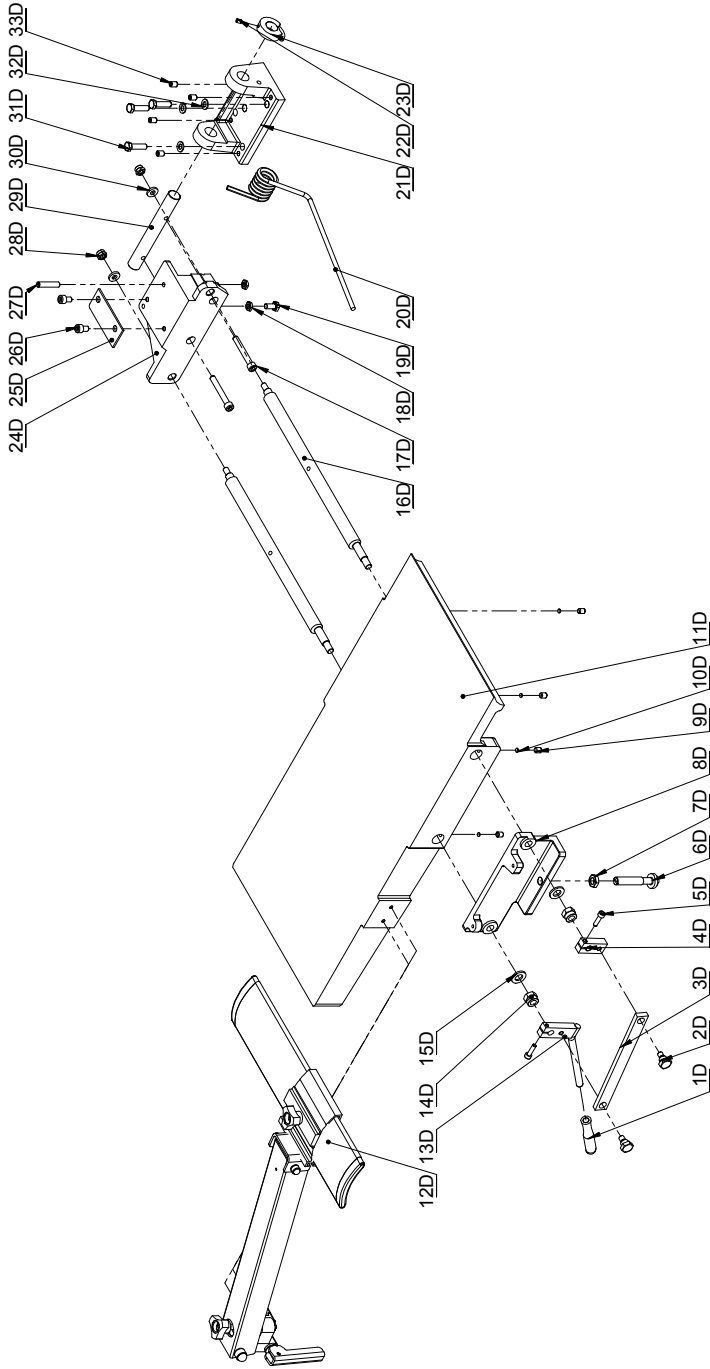
No.	Description	Part No.	Qty.
1C	Hexagon socket cap screw	M6X45GB70Z	1
2C	Nut	M6GB41Z	1
3C	Thread Tube	JL45040006	1
4C	Thread rod	JL45040007	1
5C	Bracket	JL45040004B	1
6C	Circlip	CLP20GBB894D1B	2
7C	Lifting shaft	JL45040009A	1
8C	Hexagon socket cap screw	M8X12GB70Z	3
9C	Flat washer	WSH8GB97D1Z	9
10C	Flange plate	JL45040028	1
11C	Set screw	M6X8GB77B	3
12C	Position indicator	JL09124D0E20	1
13C	Hexagon socket cap screw	M6X16GB70Z	1
14C	Bearing	BRG6202-2Z-P5GB276	1
15C	Nut	M6GB6170Z	4
16C	Circlip ring	CLP35GBB893D1B	1
17C	Locking lever	JL45040008	1
18C	Handwheel	SGSL-D160-d12A1	1
19C	Adjustable handle	KTSB-1-B-M8X63X20	1
20C	Thin nut	M8GB6172Z	1
21C	Flat washer	WSH6GB97D1Z	4
22C	Rings	JL45040014	2
23C	Screw	M6X25GB70D2B	4
24C	Rod	JL45040012	1
25C	Thickneser table	JL45040001A	1
26C	Indicator	JL45040020	1
27C	Spring washer	WSH10GB93Z	2
28C	Hexagonal head screw	M10X35GB5783B	2
29C	Tube	JL45040002A	1
30C	Set screw	M8X20GB77B	5
31C	Locking plate	JL45040005	1
32C	Locating sleeve	JL45040003A	1
33C	Spring washer	WSH8GB93Z	2
34C	Hexagon bolt	M8X40GB5783Z	8
35C	Shaft sleeve	P23X20X15GB12613	1
36C	Gear	JL45040010	2
37C	Screw	M6X12GB70D2B	3
38C	Big washer	WSH6GB96Z	3
39C	Big washer	WSH8GB96Z	2



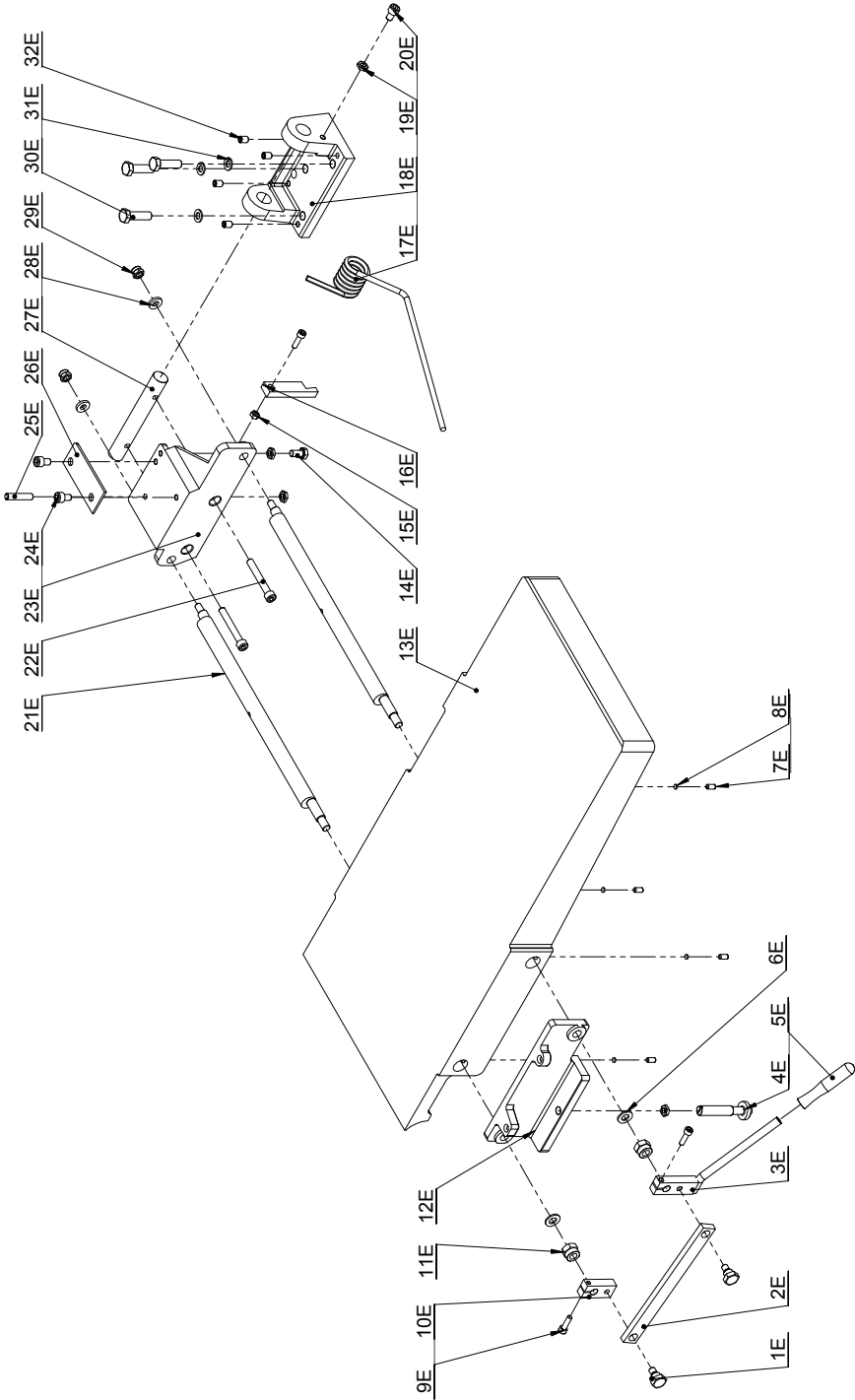
7.4 Discharging Platform Assembly-SHEET D

Discharging Platform Assembly-SHEET D

No.	Description	Part No.	Qty.
1D	Handle sleeve	JL45030028	1
2D	Shoulder bolt	JL45030017	1
3D	Rod	JL45030013	1
4D	Small lever	JL45030011	1
5D	Hexagon socket cap screw	M6X20GB70Z	2
6D	Tighten rod	JL45030008	1
7D	Nut	M12GB6172Z	1
8D	Back rack	JL45030007	1
9D	Hex.screw	M8X10GB77B	4
10D	Washer	JL45030029	4
11D	Planer table	JL45030001B	1
12D	Cutterhead guard	FDPT1202070000	1
13D	Hand shank	JL45030012	1
14D	Locknut	M12GB889B	2
15D	Flat washer	WSH12GB97D1Z	2
16D	Eccentric shaft	JL45030015	2
17D	Screw	M8X60GB70B	2
18D	Thin nut	M8GB6172Z	2
19D	Hexagon bolt	M8X16GB5781Z	1
20D	Torsional spring	JL45030009	1
21D	Support	JL45030005	1
22D	Set screw	M6X8GB77B	1
23D	Big deflection wheel	JL45090001	1
24D	Back rack	JL45030004	1
25D	Guide plate	JL45060028	1
26D	Screw	M8X10GB70B	2
27D	Hex.screw	M8X40GB77B	1
28D	Hexagon self-locking nut	M8GB889B	2
29D	Back support bar	JL45030027	1
30D	Washer	JL45030020	2
31D	Bolt	M8X30GB5783Z	3
32D	Flat washer	WSH8GB97D1Z	3
33D	Hex.screw	M8X12GB80B	4



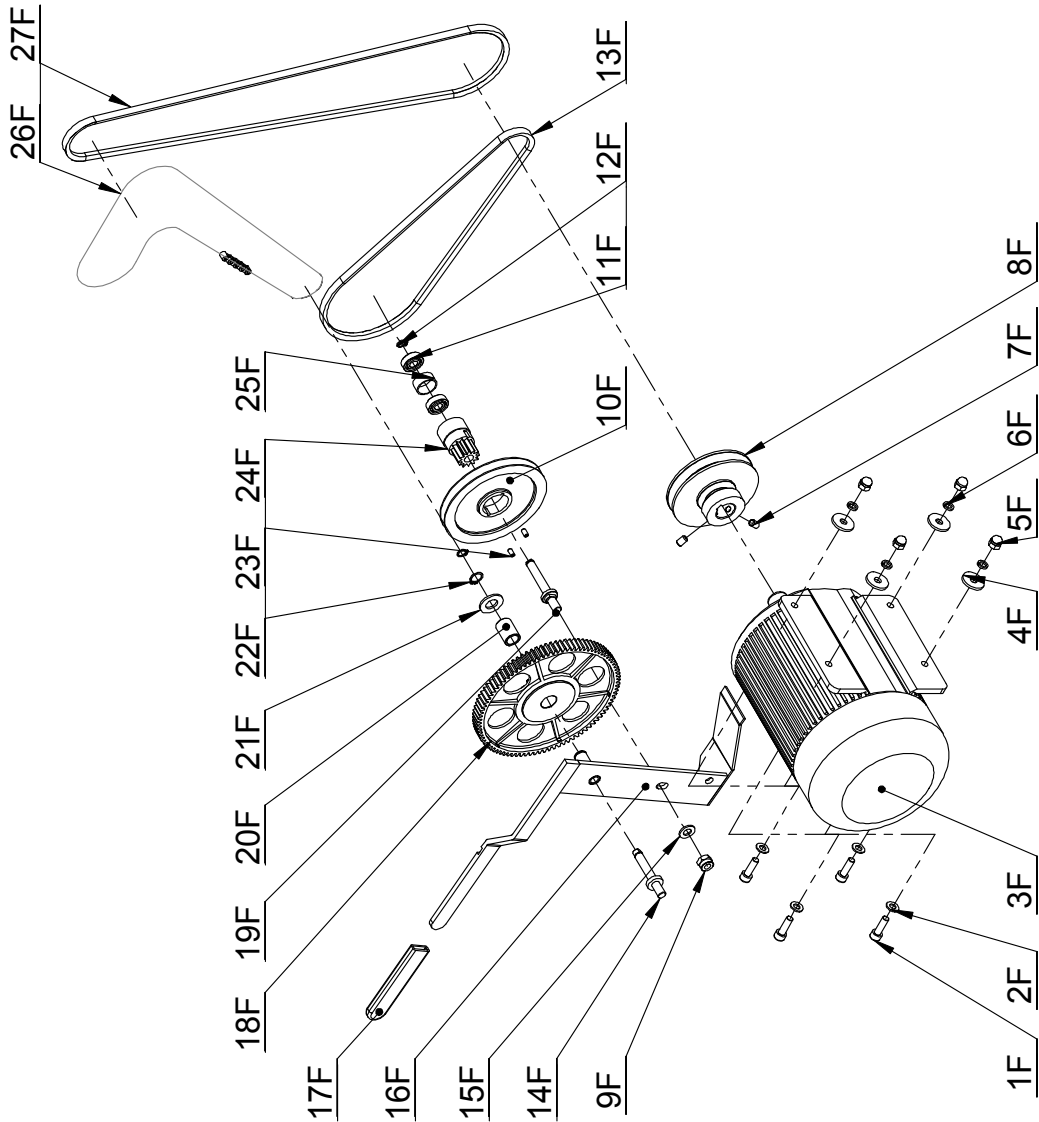
No.	Description	Part No.	Qty.
1E	Shoulder bolt	JL45030017	2
2E	Rod	JL45030013	1
3E	Hand shank	JL45030012	1
4E	Tighten rod	JL45030008	1
5E	Handle tube	JL45030028	1
6E	Plat washer	WSH12GB97D1Z	2
7E	Hex.screw	M8X10GB77B	4
8E	Washer	JL45030029	4
9E	Hex.screw	M6X20GB70Z	3
10E	Rod	JL45030011	1
11E	Locknut	M12GB889B	2
12E	Rising rack	JL45030006	1
13E	Planer table	JL45030001B	1
14E	Screw	M8X16GB5781Z	1
15E	Nut	M8GB6170Z	1
16E	Block	JL45030018	1
17E	Spring	JL45030009	1
18E	Support base	JL45030005	1
19E	Nut	M8GB6172Z	4
20E	Hex.screw	M8X12GB70Z	1
21E	Eccentric shaft	JL45030015	2
22E	Screw	M8X60GB70B	2
23E	Front Rack	JL45030003	1
24E	Screw	M8X10GB70B	2
25E	Hex.screw	M8X40GB77B	1
26E	Guide plate	JL45060028	1
27E	Support bar	JL45030010	1
28E	Washer	JL45030020	1
29E	Locknut	M8GB889Z	2
30E	Blot	M8X30GB5783Z	3
31E	Plat washer	WSH8GB97D1Z	3
32E	Hex.screw	M8X12GB80B	4



7.6 Drive System Assembly-SHEET F

Drive System Assembly-SHEET F

No.	Description	Part No.	Qty.
1F	Hexagon socket cap screw	M8X25GB70B	4
2F	Washer	WSH8GB97D1Z	4
3F	Motor	YKA905222A	1
4F	Big washer	WSH8GB5287Z	4
5F	Cap nut	M8GB923Z	4
6F	Spring washer	WSH8GB93Z	4
7F	Socket head cap screw	M8X12GB77Z	2
8F	Motor pulley	JL45050002	1
9F	Self-locking nut	M10GB889Z	1
10F	Belt wheel	JL45051101	1
11F	Bearing	BRG6000-2ZGB276	2
12F	Circlip ring	CLP10GB894D1B	2
13F	V-belt	JL45050007	1
14F	Chain wheel spindle	JL45051004	1
15F	Washer	WSH10GB97D1Z	1
16F	Panel assembly	JL45051300	1
17F	Handle sleeve	JL45050013	1
18F	Big gearwheel	JL45051001	1
19F	Belt wheel spindle	JL45051301	1
20F	Minor sprocket bush	JL45051003	1
21F	Washer	JL45051005	1
22F	Circlip ring	CLP15GB894D1B	1
23F	Set screw	M5X10GB77B	2
24F	Small gearwheel	JL45051102	1
25F	Bush	JL45051103	1
26F	Chain	JL45050008	1
27F	V-belt	JL45050009	1



7.7 Material Baffle Assembly-SHEET G

Material Baffle Assembly-SHEET G

No.	Description	Part No.	Qty.
1G	Nut	M6GB889Z	2
2G	Support base	JL45060002	2
3G	Hex. Screw	M6X16GB70D3Z	2
4G	Hex. Screw	M8X16GB70Z	2
5G	Washer	WSH12GB97D1Z	2
6G	Disc spring washer	JL46062006	2
7G	Washer	WSH8GB97D1Z	2
8G	Nut	M8GB6170Z	2
9G	Locknut	M8X60GB80B	2
10G	Cap nut	M6GB923Z	4
11G	Hex. Screw	M6X12GB70D3Z	2
12G	Right support arm	JL45060020	1
13G	Nut	M8GB6172Z	2
14G	Lock tube	JL45060024	2
15G	Lock rod	JL45060023	1
16G	Lock handle	JL45060027	1
17G	Hex. Screw	M6X16GB70Z	2
18G	Angle label	JL45060007B	1
19G	Hex. Screw	M8X20GB70Z	2
20G	Left support arm	JL45060021	1
21G	Support plate	JL45063000A	1
22G	Big washer	WSH6GB96Z	6
23G	Indicator	JL45060026	1
24G	Washer	WSH4GB97D1Z	2
25G	Hex. Screw	M4X5GB70Z	2
26G	Spring washer	WSH4GB93Z	2
27G	Cap nut	M8GB923Z	2
28G	Thick washer	FDPT1202060016	2
29G	Square nut	M8GB39Z	2
30G	Long pin	JL45060011	2
31G	Rip fence	JL45060001	1

