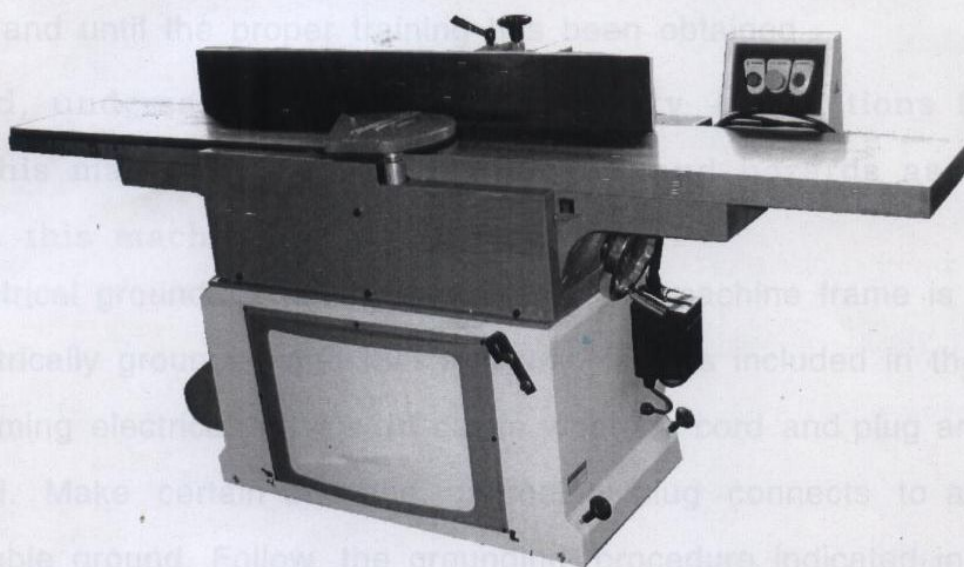


⚠ WARNING

INSTRUCTION MANUAL

12" PLANER JOINTER



WARNANG

Read this manual completely and observe all warning labels on the machine. The Machinery has made every attempt to provide a safe, reliable, easy-to-use piece of machinery. Safety, however, is ultimately the responsibility of individual machine operator. As with any piece of machinery, the operator must exercise caution, patience, and common sense to safely run the machine. Before operating this product, become familiar with the safety rules in the following with the safety rules in the following sections,

- **Always keep guards in place and in proper operating condition.**

- ☐ Never reach around or under the jointer.
- 1. If you are not properly trained in the use of a jointer do not use and until the proper training has been obtained.
- 2. Read, understand and follow the safety instructions found in this manual. Know the limitations and hazards associated with this machine.
- 3. Electrical grounding: Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used. Make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.
- 4. Eye safety: Wear an approved safety shield, goggles, or glasses

To protect eyes. Common eyeglasses are only impact-resistant, they are not safety glasses.

5. Personal protection: Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows, Remove all loose outer clothing and confine long hair. Protective type footwear should be used.

6. Guards: Keep the machine guards in place for every operation for which they can be used. If and guards are removed for maintenance, DO NOT OPERATE the machine until the guards are reinstalled.

7. Work area: keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to use the machine. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Use antiskid floor strips on the floor area where the operator normally stands and mark off machine work area. Provide adequate work space around the machine.

8. Jointer position: Position the jointer so that in case of material kick back the flying piece will not injure workers.

9. Material condition: Do not attempt to joint boards with loose knots or with nails or other foreign material.

Operator: Always use push blocks. Maintain a balanced stance and

Keep your body under control at all times.

10. Before starting: Before turning on machine, remove all extra equipment such as keys, wrenches, scraps, and cleaning rags away from the machine and off the table.
11. Careless acts: Give the work you are doing your undivided attention. Looking around, around, carrying on a conversation, and horseplay are careless acts that can result in serious injury.
12. Disconnect all power sources: Before performing any service, maintenance, adjustments or when changing blades. A machine under repair should be RED TAGGED to show to it should not be used until the maintenance is complete.
13. Job completion: If the operator leaves the machine area for any reason, the jointer should be tuned off and the cutter head should come to a complete stop before leaving.
14. Replacement parts: Use only genuine the Machinery factory authorized replacement parts and accessories; otherwise the warranty and guarantee are null and void.
15. Drugs, alcohol and medication: Do not operate this machine while under the influence of drugs, alcohol, or any medication.
16. This machine is designed for planing wood products only, do not use to cut any kind of metal or substance other than wood.
17. Never start the jointer while a work piece is in contact with the blade.

18. Raise or lower the tables only when the machine has been turned "off" and the cutterhead has come to a complete stop.
29. Make sure the cutter head is running in the proper direction. The knives should be turning toward the in feed table.
20. Health hazards: some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
- .lead from lead-based paint.
 - .Crystalline silica from bricks and cement and other masonry products.
 - .Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your risk from these exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

Familiarize yourself with the following safety notices used in this manual:

CAUTION (This means that if precautions are not needed, it may result in minor or moderate injury and/or possible machine damage)

WARNING: (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

Specifications

Model No	12"
Cutterhead speed(RPM)	5200
Number of Knives	4
Rebbering Capacity(in)	1/8
Dust PORT Diameter(in)	5
Table Dimensions	2250 × 320
Table heimensions mm	320
Fence Dim ensions mm	1200 × 150
Fence Tilts(deg.)	90and45
Overall Dimensions	2300 × 720 × 1250
Gross Weight	500kg

Contents:

1.12" jointer

2.Knife setting jig uncrating the machine uncrate the machine and inspect the unit for signs of shipping damage. If damage is found, contact your dealer immediately, unbolt the machine from the pallet. Retain all packaging materials in case it becomes neccssary to ship the machine to another site.

This jointer must be. Positioned on a smooth,level surface, The area mast be well lit and have plenty of room to mance aver with large pieus of wood.

Level the jointer front to back and side to side using a level placed on the table. Use shims under the corners, if necessaty, but maked sure the jointer is stable before being placed into service.

Clean all rust protected protected surfaces with a commercial solvent. Do not use any type of flammable solvent.

Belt Adjustment

Adjust the tension of the belt until it won't slip during operation. The belt should not be too tense, otherwise the bearing of the cutterhead may be overloaded and infect its service life. Operation method and points for attention read the manual carefully before operation before connecting the power, install the blades first, properly adjust the cutting capacity (cutting depth) and the angle between the fence and table surface. Tighten securely after confirming they are all correctly adjusted. Disconnect the power if readjustment is required. Ensure that the tool is connected to the power, the voltage is correct, and the tool is reliable.

Safe Guard Device

While the planer jointer is processing the stock, you have to push the stock with hand, and it is extremely vulnerable if you are not very careful, so it is of vital importance to equip the machine with safe guard device. Never remove the safe guard device when being engaged in planning work. The tool is installed with full-covering plate sway type hand protective device, shown as Figure, the cutterhead guard cover the cutterhead to prevent hand into the cutting lot and getting injured.



The other end of the cutterhead guard

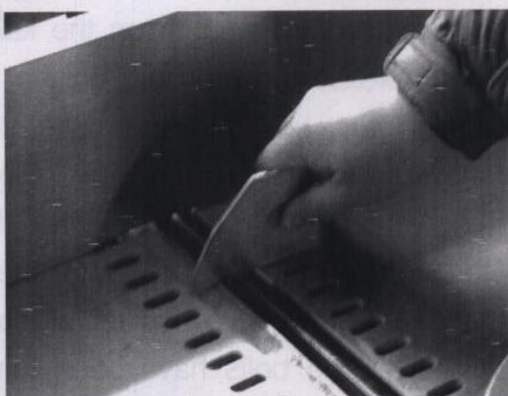
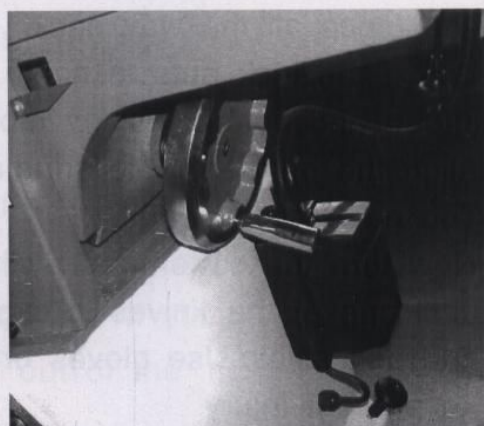
is fixed to the control shaft on which torsion spring is mounted. When planning, hold the stock against the rear edge of the cutterhead guard and push it front behind across the cutting slot. Throughout the operation, the cutterhead guard covers the part which is not participating cutting.

When the stock is pushed away from the cutting slot, the cutterhead guard return to its original position by the torsion spring to cover the cutterhead.

Table Adjustment

Shown as figure

Slide Way and guide screw nut adjusting mechanism are used to raise and lower the front and rear tables. Turning the front and rear wheels, through the guide screw nut, can drive the front and rear slide bodies and tables rising and Falling with certain range. The height balance between the front and rear tables is just the cutting depth, the front table is adjusted according to the desired cutting thickness, 1-2mm lower than the general trix for the cutting edges. When the front table is higher than the rear table (the cutting edges), planning operation cannot be performed. However, do not adjust the front table too low; otherwise, it will increase the cutting capacity and infect the processing quality. The rear table should be adjusted accurately, make its surface slightly lower than the cutting circle of the cutterhead.



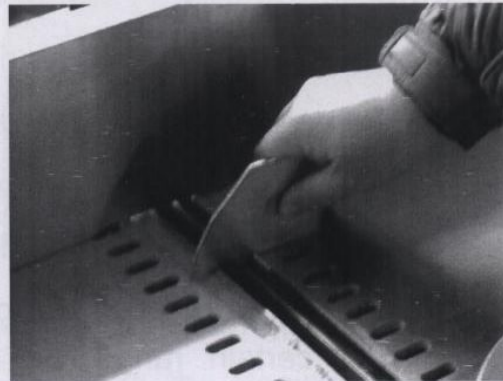
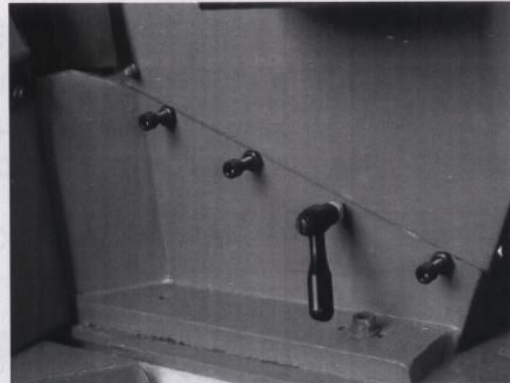
Knives adjustment

Installation of the Knives

1. To expose the cutterhead, move the fence all the way back.
2. Loose the lock nuts to enable the infeed and outfeed tables moving. Align the outfeed table surface and Top edge of knives.
3. Now turn the cutterhead by hand until one of the knives is exposed and accessible. Use gloves or a rag to prevent injury
4. Using a 10mm wrench on the knife lock bolt, release the pressure on the knife by turning the bolt into the cutterhead as shown in Figure. To prevent injury, hold the wrench with one hand while tapping the top of the wrench with the other hand as shown. Do this for all six bolts.
5. Once all the bolts have been turned in, the knife should pop up from the spring pressure. Remove the knife and immediately place the new knife in the slot to prevent loss of the springs.

Note: it is not only important to set the height of the knife with respect to the cutterhead it is also important that the outside edge of the knives be aligned with the rabbeting ledge.

6. With the knife in the slot use a straight edge on the rabbeting ledge as shown in Figure to push the knife into alignment with the edge.
7. Next use the supplied knife gauge as shown to carefully push down on the knife until it is position as shown in Figure.



8.Repeat the above for all knives.

Note:the supplied guage sets the knives to the cutterhead however it is always the best to set the knives to work from the center bolts outward, Do this in two steps, First loosely, then firmly the second time.

9.Repeat the above for all knives.

Note:the supplied guage sedts the knives to the cutter head how ever its always the best to set the knives to the out feed table,Many after market devices are available to do this. If suing this method the knife should be no more than $1/8$ " out of the cutterhead (not including the bevel).

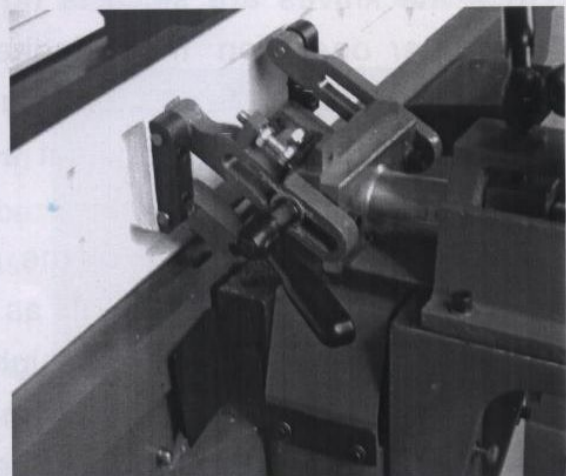
Fence Adjustment

Use a square to check the vertical degree between the fence surface and cutterhead. Finally, tighten the crosswise and angle adjusting handle.

90 STOP ADJUSTMENT

Following procedures for the 90 and 45 top assume the out feed table has been adjusted correctly. If it has not refer to Section X.C. Before proceeding.

- 1.Place a square on the outfeed table fair close on the cutterhead.See Figure.
- 2.Rough adjustment can be made by loosening the check nut on the degree tilting rod and turning the rod itself, It may by



necessary to insert a small rod through the tilting rod for better leverage. To adjust or loosen the check nut on the positive stop bolt, then turn the bolt against the tab until the fence contacts the edge of the square evenly. See Figure.

3. Tighten the check nut on the stop bolt and tilt the fence forward. Then back against the stop.

4. Re-check with the square. Tightening the check nut will move the stop bolt slightly, so some trial-and-error may be necessary to perfect your settings.

45 STOP ADJUSTMENT

When the fence is properly aligned, it will be perpendicular to the outfeed table. The fence can also be



tilted away from the table. By loosening the lock handle, lifting up the 90 positive stop tab, and moving the fence in the desired direction. See Figure for adjustment locations. To set the 45 degree stop:

Adjusting the Outfeed Table

1. Once the knives are set it is now time to set the outfeed table. For proper operation the height of the outfeed table must be set to height of the out feed table must be set to the highest point of the cutting circle. To do this, set a straight edge on the out feed table as shown in Figure.
2. Carefully watch the height of the straight edge as you gently rock the cutterhead back and forth as shown by the arrows in figure. Stop when the knife is at its highest position.
3. At this point it is time to 'dial in' the outfeed table to the knife. To this, slowly turn up or down the table with table height adjusting wheel until there is no light between the table and the bottom of the straight edge.

4. Once set, lock into place with the height lock knob.

Note: Failure to adjust the outfeed table will result in either a curved or sniped work piece.

Operation

WARNING

Keep all guards in place. Keep hands away from the cutterhead! Always use push stick when possible. Failure to comply may cause serious injury.

Hand Safety and Placement

Never pass the hands directly over the cutter knife. As one hand approaches the knife, remove it from the stock in an arc motion and place it back on the stock at a position beyond the cutter knife. See figure. When feeding the work piece, pressure is applied not only toward the cutterhead as stated above.



Grounded.

but against the fence and down to the table as well. At the start of the cut, the left hand holds the material down and toward the cutterhead. As the material crosses the cutterhead, the left hand comes up and over as in Figure to continue the pressure but now on the outfeed table. As the right hand approaches the cutterhead, it is time to move it up and over the cutterhead in the same fashion as the left in Figure, all the while continuing pressure. Clean the table surface, keep the work area clean, and get rid of the wood scraps, oil, and lubricating oil to avoid being slippery. Check the safety guard device, ensure safety before starting the machine. Remove or fix well the accessories on the body, such as necktie, long necklace, etc.

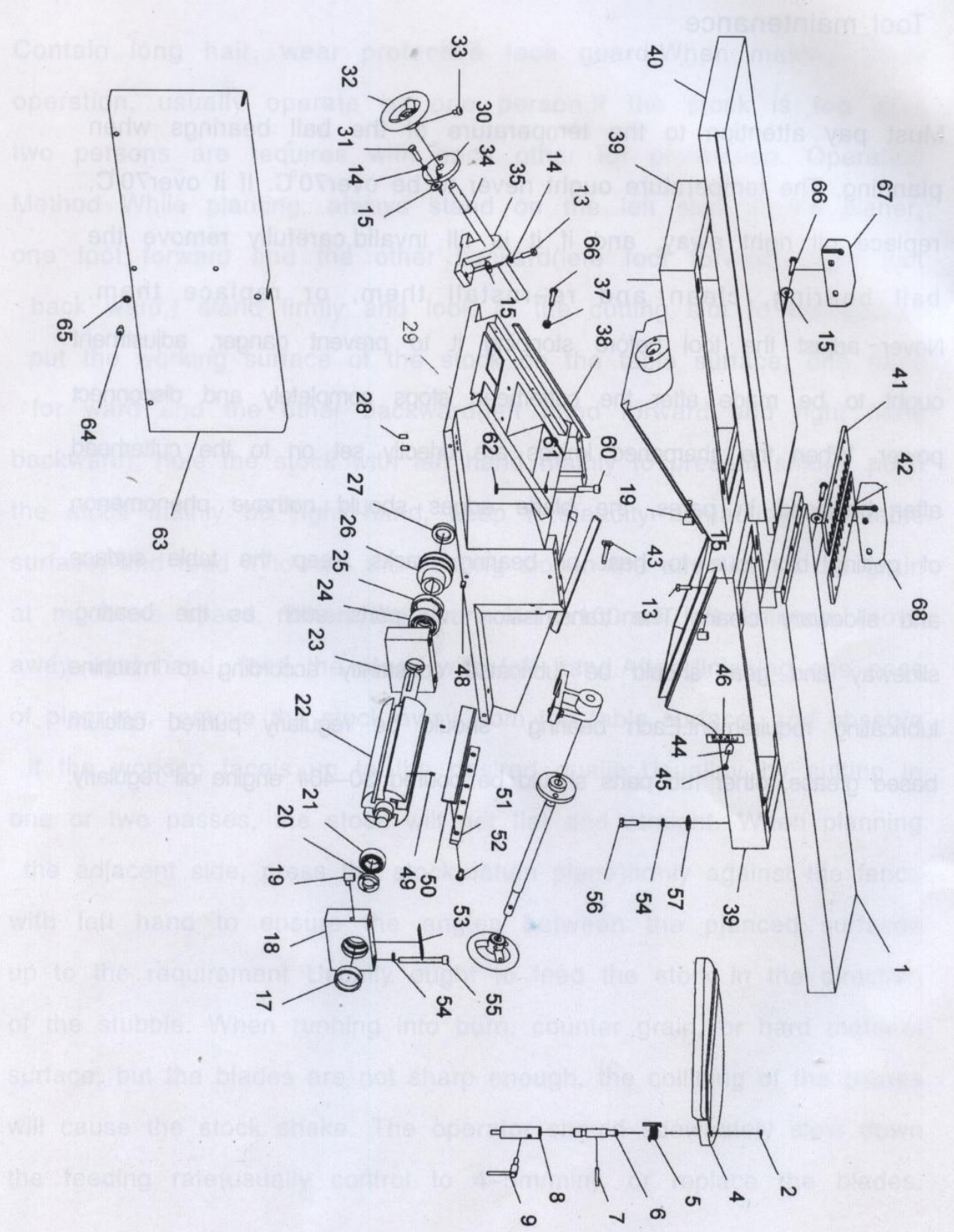
Contain long hair, wear protective face guard. When making stock operation, usually operate by one person, if the stock is too long two persons are required with each other for cooperation. Operation Method While planing, always stand on the left side of the planer, one foot forward and the other backward (left foot forward, right foot backward,) stand firmly and look at the cutting slot of the planer, put the working surface of the stock on the table surface, one hand forward and the other backward (left hand forward and right hand backward), hold the stock with left hand mainly to prevent shake, push the stock mainly by right hand, keep it steadily contacting the table surface, and feed it toward the cutting slot in the direction of the grain at moderate speed. When there are only 100mm left unplaned, move away right hand, feed the stock with left hand. After finishing one pass of planing, remove the stock away from the table surface, and observe if the working face is up to the desired quality. Usually by cutting in one or two passes, the stock will get flat and straight. When planing the adjacent side, press the stock (datum plane) firmly against the fence with left hand to ensure the angles between the planed surfaces up to the requirement. Usually ought to feed the stock in the direction of the stubble. When running into burn, counter grain, or hard material surface, but the blades are not sharp enough, the colliding of the blades will cause the stock shake. The operator should gradually slow down the feeding rate (usually control to 4–5m/min), or replace the blades.

Tool maintenance

Must pay attention to the temperature of the ball bearings when planning. The temperature ought never to be over 70°C. If it over 70°C, replace oil right away, and if it is still invalid, carefully remove the ball bearing, clean and re-install them, or replace them. Never adjust the tool before stopping it to prevent danger, adjustment ought to be made after the cutterhead stops completely and disconnect power. When the sharpened knives are directly set on to the cutterhead after balanced in pairs, the blade edges should not have phenomenon of getting blur due to heat or bearing cracks. Keep the table surface and slideway clean. The transmission rub parts such as the bearing, slideway and gear should be lubricated constantly according to machine lubricating requirement. Each bearing should be regularly poured calcium based grease, other rub parts should be poured 30-40# engine oil regularly.

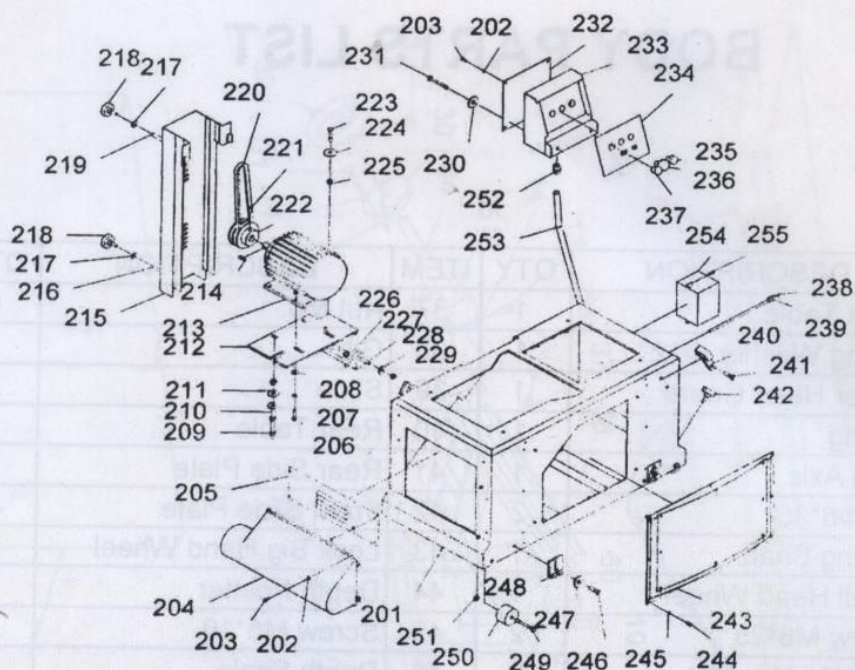


24	Left V-belt	1	21	Flat Washer $\phi 10$	4
25	Right V-belt	1	22	Lock Washer $\phi 10$	4
26	Cutter Head Key	1	23	Front Plate	1
27	Right Nut	1	24	Screw M8*12	4
28	Set Screw $\phi 6$	4	25	Flat Washer $\phi 8$	4
29	Base	1	26	Screw M8*16	4
30	Left Plate	2	27	Support Block	1
31	Screw M8*10	4	28	Support Block	1
32	Hand V-belt	2			
33	Screw M8*12	4			
34	Screw	16			
35	Nut	2			
36	Screw M8*10	6			



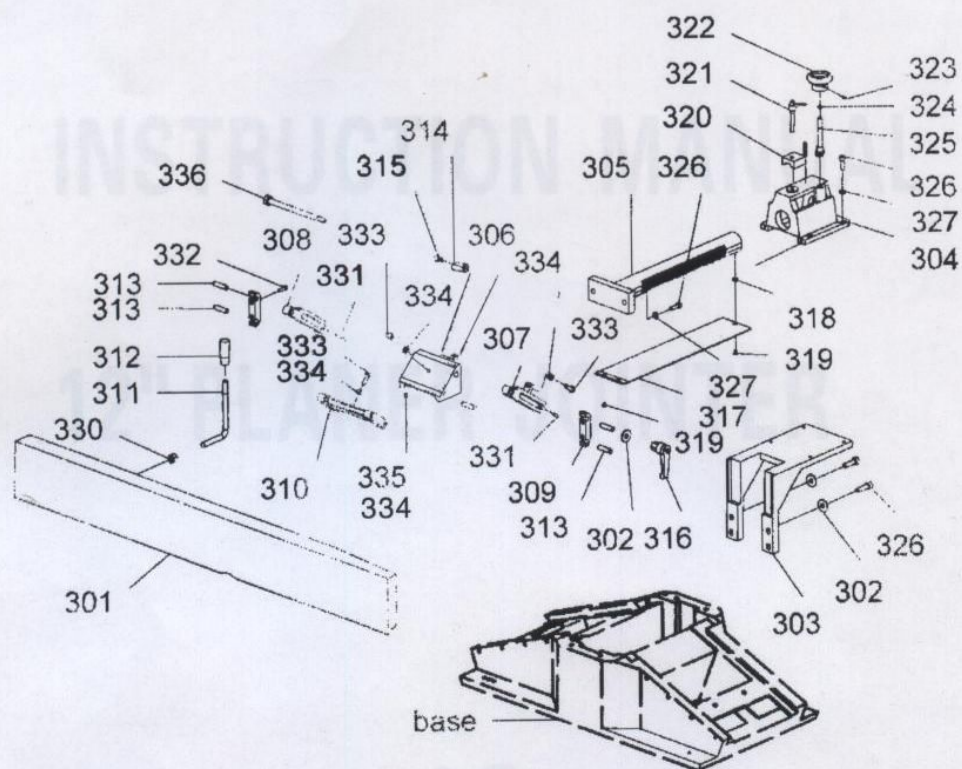
BODY PARTS LIST

ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY
1	Front Table	1	37	Nut M8	6
2	Spring Washer $\Phi 12$	1	38	Gib	2
4	Cutter Head Guard	1	39	Slide	2
5	Spring	1	40	Rear Table	1
6	Hold Axle	1	41	Rear Side Plate	1
7	Pin $\Phi 6 \times 35$	2	42	Front Slide Plate	1
8	Driving Shaft	1	43	Lock Big Hand Wheel	2
9	Small Head Wheel	1	44	Depth Pointer	1
13	Screw M8 \times 25	2	45	Screw M5 \times 10	1
14	Lock Washer $\Phi 8$	2	46	Depth Scale	1
15	Flat Washer $\Phi 8$	2	47	Lable	1
16	Stop Block	1	48	Key 8 \times 7 \times 35	1
17	Left Hold Axle	1	49	Spring	8
18	Left Bearing Housing	1	50	Blade	4
19	Oil Glass	6	51	Knife Lock Bar	4
20	Left Nut	1	52	Screw M8 \times 10	24
21	Ball Bearing 60205	1	53	Lable	1
22	Cutter Head	1	54	Lock Washer $\Phi 10$	12
23	Right Bearing Housing	1	55	Set Screw M10 \times 95	4
24	Ball Bearing 60206	1	56	Bolt M10 \times 30	8
25	Right Hold Axle	1	57	Flat Washer 10	8
26	Cutter Head Pulley	1	58	Screw M5 \times 10	1
27	Right Nut	1	59	Pin $\Phi 4 \times 6$	4
28	Set Screw M8 \times 16	4	60	Screw M10 \times 30	4
29	Base	1	61	Flat Washer $\Phi 10$	4
30	Lift Plate	2	62	Lock Washer $\Phi 10$	4
31	Screw M8 \times 30	4	63	Front Plate	1
32	Hand Wheel	2	64	Screw M8 \times 12	4
33	Screw M8 \times 12	4	65	Flat Washer $\Phi 8$	4
34	Screw	2	66	Screw M8 \times 16	4
35	Nut	2	67	Support Block	1
36	Screw M8 \times 40	6	68	Support Block	1



201	STAND	1	228	FLAT WASHER $\Phi 10$	2
202	FLAT WASHER $\Phi 6$	14	229	NUT M10	2
203	SCREW M6*16	14	230	FLAT WASHER $\Phi 8$	2
204	DUST COLLER	1	231	SCREW M8*60	2
205	PLATE	1	232	SWITCH PLATE	1
206	BOLT M8*30	4	233	SWITCH BOX	1
207	LOCK WASHER $\Phi 8$	4	234	LABLE	1
208	FLAT WASHER $\Phi 8$	4	235	ON SWITCH	1
209	NUT M12	3	236	STOP SWITCH	1
210	ADJUST SCREW M12	1	237	LAMP	1
211	FLAT WASHER $\Phi 12$	2	238	POWER CORD	1
212	MOTPR PLATE	1	239	PLASTIC NUT M20	1
213	MOTOR	1	240	HANGER	2
214	KEY 8*35	1	241	SCREW M10*25	4
215	BACK PLATE	1	242	KNOB M8*40	2
216	POLE	1	243	FRONT PLATE	1
217	FLAT WASHER	2	244	SCREW M5*10	8
218	KNOB M8	2	245	FLAT WASHER $\Phi 5$	8
219	POLE	1	246	BOLT M10*25	4
220	BELT	2	247	FLAT WASHER $\Phi 10$	4
221	SET SCREW M8*12	1	248	FOOT	4
222	MOTOR PULLEY	1	249	BOLT M10*80	4
223	BOLT M10*50	2	250	WHEEL	4
224	FLAT WASHER $\Phi 10$	2	251	SPECIAL NUT M10	4
225	NUT M10	2	252	PLASTIC NUT M20	2
226	STAND PLATE	1	253	TUBE	1
227	SCREW M10*45	2	254	MAGNETIC SWITCH	1
			255	CAP SCREW M5*16	2

FENCE DIAGRAM AND PART LIST



ITE	DESCRIPTION	QTY	ITE	DESCRIPTION	QTY
301	FENCE	1	318	WASHER	1
302	WASHER	4	319	FLAT HD SCREW M6*10	3
303	SET BASE	1	320	TUBE LOCKING SHOE	1
304	FENCE BASE	1	321	ADJUST HANDLE M10*50	1
305	ADJUSTMENT TUBE	1	322	HANDLE	1
306	FENCE BRACKET	1	323	SET SCREW M6*6	1
307	BRACKET (RIGHT)	1	324	RETAINING RING 10	1
308	BRACKET (LEFT)	1	325	PINION SHAFT	1
309	REAR CLAMP	2	326	CAP SCREW M8*25	6
310	SUPPORT	1	327	WASHER 8	6
311	STUD	1	330	NUT M12	1
312	KNOB	1	331	SET SCREW M6*16	2
313	PIN Φ 10*40	6	332	CAP SCREW M6*20	4
314	STOP	1	333	HEX HD BOLT M8*25	3
315	SPECIAL BOLT	1	334	NUT M8	3
316	ADJUST HANDLE M10	1	335	SET SCREW M6*8	2
317	GUARD	1	336	SPECIAL SCREW	1