

# AT260PT / AT260SPT AT310SPT Planer Thicknesser



Code: 508498 with HSS Blades  
Code: 101156 with Spiral Blades




Code: 101157 with Spiral Blades



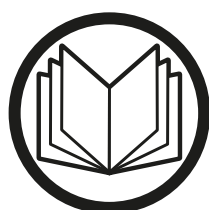
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## EU Declaration of Conformity

<p><b>Cert No: PT107/230 &amp; PT129/230</b></p> <p>Axminster Tool Centre Ltd Axminster Devon EX13 5PH UK <b>axminstertools.com</b></p> <p>declares that the machinery described:-</p> <table border="1"> <tr> <td>Type</td> <td><b>Planer Thicknesser</b></td> </tr> <tr> <td>Model</td> <td><b>AT260PT, AT260SPT, AT310SPT</b></td> </tr> </table> <p>Signed </p> <p><b>Andrew Parkhouse</b> Operations Director</p> <p>Date: <b>27/7/2015</b></p>	Type	<b>Planer Thicknesser</b>	Model	<b>AT260PT, AT260SPT, AT310SPT</b>	<p><b>EU Declaration of Conformity</b></p> <p><b>This machine complies with the following directives:</b></p> <p>2006/42/EC 06/42/EC - Annex I/05.2006 EN 60204-1:2006+A1+AC EN 861:2007+A2</p> <p>and conforms to the machinery example for which the EC Type-Examination Certificate No BM 50314376 has been issued by <b>Laizhou Futian Machinery Co., Ltd.</b> at: Fenghuang Science and Technology Park, Development Zone Laizhou, Shandong 261400 China</p> <p>and complies with the relevant essential health and safety requirements.</p>
Type	<b>Planer Thicknesser</b>				
Model	<b>AT260PT, AT260SPT, AT310SPT</b>				

The symbols below advise the correct safety procedures when using this machine.



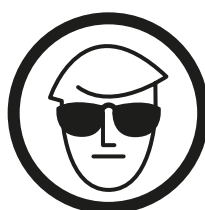
Fully read manual  
and safety instructions  
before use



Ear protection  
should be worn



Two Man  
Assembly



Eye protection  
should be worn



Dust mask  
should be worn



HAZARD

## What's Included

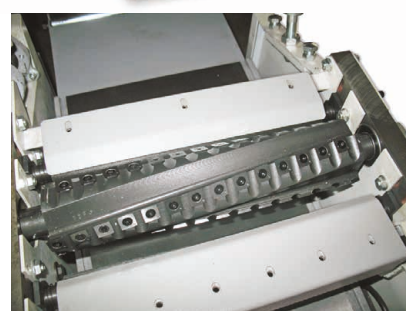
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Quantity	Item	Code: 508498
		Part
1	Planer Thicknesser (with HSS Blades)	<b>A</b>

Model Number:		AT310SPT
Quantity	Item	Code: 101157
		Part
1	Planer Thicknesser (with Four Sided Spiral Blades)	<b>B</b>

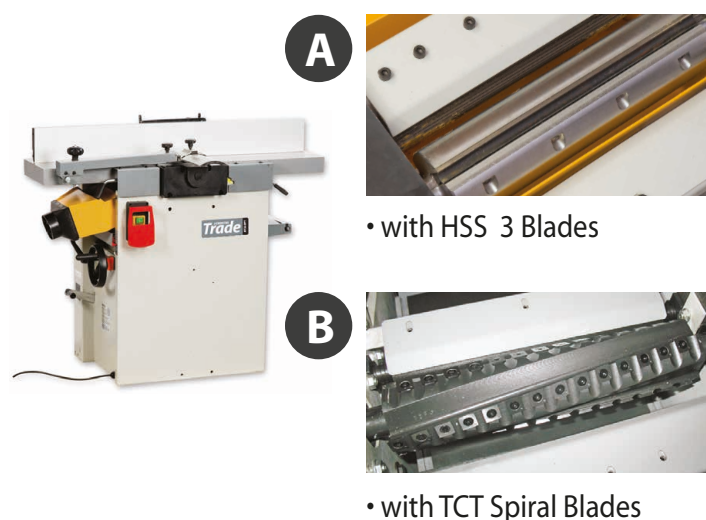
Model Number:		AT260SPT
Quantity	Item	Code: 101156
		Part
1	Planer Thicknesser (with Four Sided Spiral Blades)	<b>B</b>



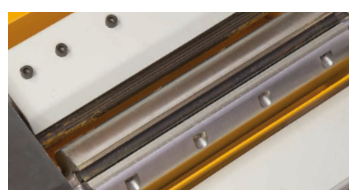
**B**



• with TCT Spiral Blades



**A**



• with HSS 3 Blades

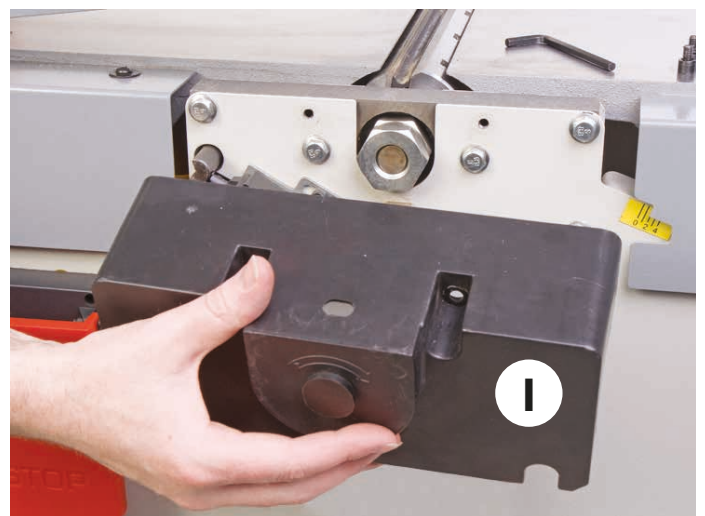
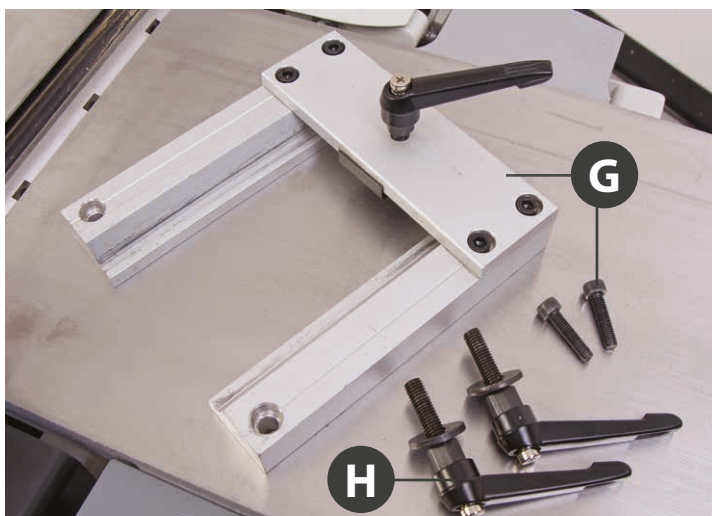
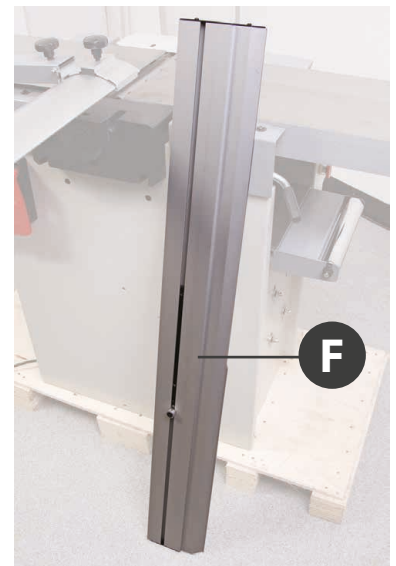
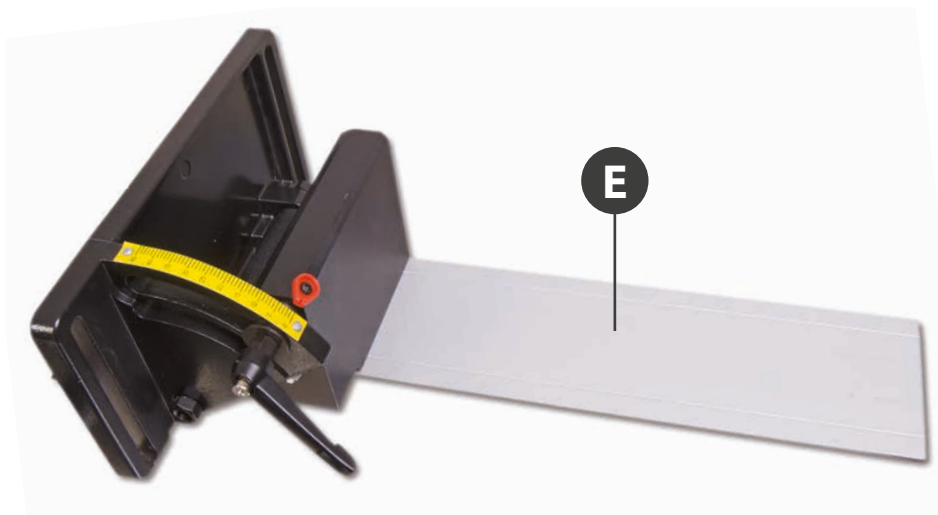
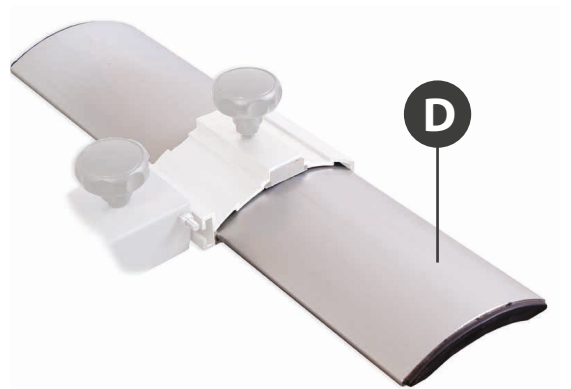
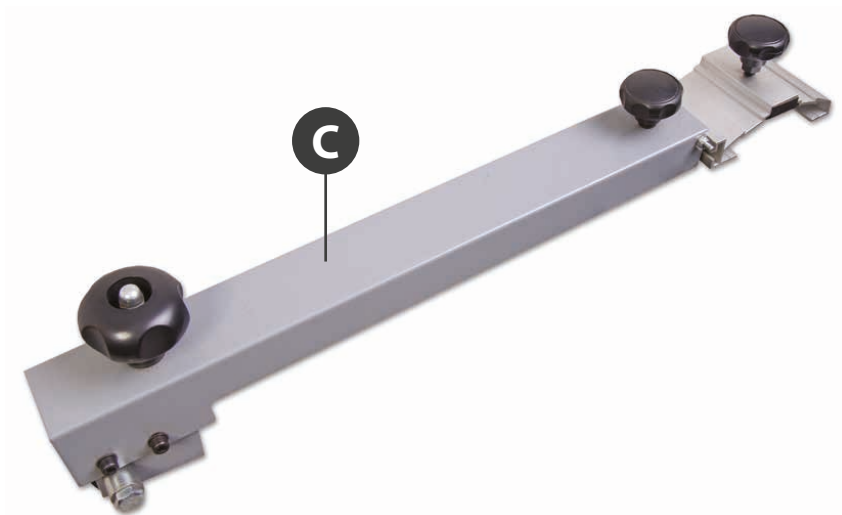
**B**

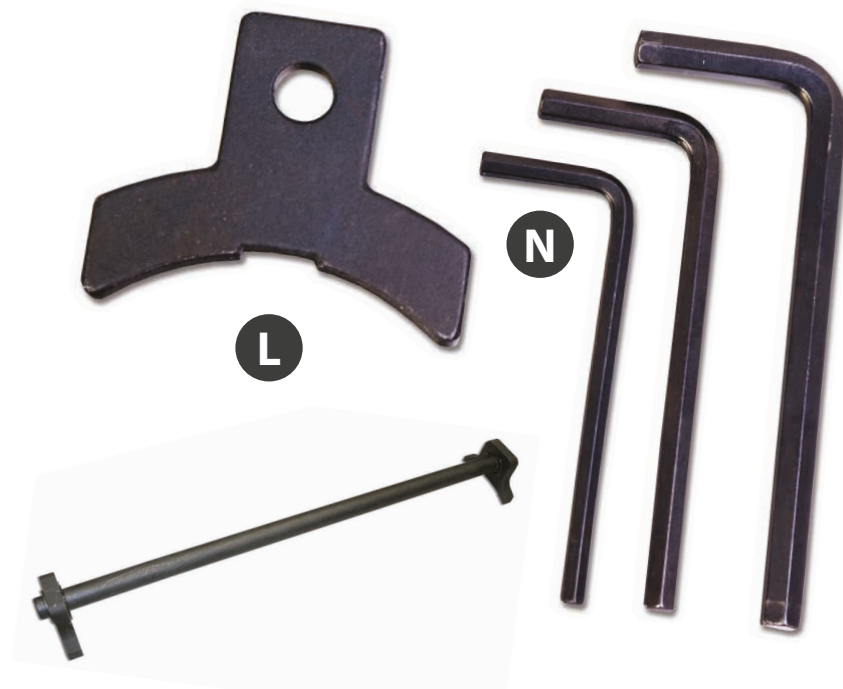


• with TCT Spiral Blades

1	Planer Thicknesser Assembly (95% Assembled)	
1	Overhead Cutter Guard Mounting Arm Assembly	<b>C</b>
1	Cutter Block Guard	<b>D</b>
1	Fence Tilt Assembly	<b>E</b>
1	Fence	<b>F</b>
1	Fence Assembly Mounting bracket with clamping handle and two Cap head Screws	<b>G</b>
2	Lift & Shift Handles with M8 threads	<b>H</b>
1	Cutter Block Side Guard	<b>I</b>
1	NVR Emergency Stop Lever with two Phillips Screws and Nuts	<b>J</b>
2	Fence Storage Angle Brackets	<b>K</b>
1	Blade Setting Tool	<b>L</b>
1	Push Guide Block	<b>M</b>
2	Hex Keys 3,4,5mm	<b>N</b>
1	Instruction Manual	

## What's Included





# General Instructions for 230V Machines

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



**WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN**



**KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.**

## Mains Powered Tools

- Tools are supplied with an attached 16 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

## Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.

- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

# Specific Precautions Using Planer Thicknessers

Most machines currently, are well interlocked to ensure that the machine must be in the correct configuration to perform one task or the other. Make yourself familiar with these configurations and do not try to use the machine in a half and half state; or rig the interlocks to enable you to do so.

These machines are designed for cutting timber only. They will, but are not designed to, cut timber derivatives or composites. Glue lines in plywood, block board etc, will 'notch' blades as sure as eggs is eggs. The bonding agent in chipboard is likewise detrimental to the health of your planer irons.

It is best to leave them alone. If you have to machine composites, work out the costs of tungsten, against HSS (plus the sharpening costs), and proceed accordingly. On larger machines it is common practice to leave a portion of the blade (usually the offside 30mm) to be used on 'aggressive' materials.

## Overhand planing

Make sure during overhand planing operations, that the fence is set to the required angle, is securely fastened and locked in position. Ensure the planer block guarding is in position and secured.

- Disengage the autofeed for the thicknesser.
- Ensure both tables are correctly seated and locked down.
- Ensure the dust extraction hood is in place and is not blocked.
- Fit dust extraction.

Check the sharpness of planer irons, check for 'nicks' and 'notches', if there are damaged sections on the blades, try to plane in the 'clear' areas. Especially when planing material down to 'thin' dimensions, maintain pressure on the 'front' of the material i.e., that portion of the stuff that has passed over the block, but use a push stick or a pusher shoe to clear the end of the stuff over the block.

## Thicknessing

When thicknessing, remove the fence and place the assembly onto the fence storage brackets to the rear of planer thicknesser. Lower the thicknessing table slightly. Unlock and swing both tables 'up and out of the way', taking care not to foul the overhand guard/arm assembly, which will probably swing free. Turn the dust extraction hood up and over the block.

- Connect the dust extraction. Ensure the hose will not foul any stuff being passed through the machine.
- Check the height of the thicknessing table.
- Engage the autofeed mechanism.
- Periodically, clean any excess build up of resin from the thicknessing table, and apply any proprietary brand of lubricating agent.

**NOTE,** Consideration should be given to the type of finish you will be applying to the surface when you select your cleaning/lubrication agent.

## Specification

Code	508498	Code	101156
Model	AT260PT	Model	AT260SPT
Rating	Trade	Rating	Trade
Power	2.2kW 230V 1ph	Power	2.2kW 230V 1ph
Feed Speed	5m/min	Feed Speed	5m/min
Cutterblock Speed	4,800rpm	Cutterblock Speed	4,800rpm
Cutterblock Diameter	70mm	Cutterblock Diameter	70mm
Max Thicknesser Capacity	190mm	Max Thicknesser Capacity	190mm
Max Planing Width	255mm	Max Planing Width	255mm
Max Depth of Cut Thicknesser	2mm	Max Depth of Cut Thicknesser	2mm
Max Depth of Cut Planer	4mm	Max Depth of Cut Planer	4mm
Knives	3 x HSS	TCT Four Sided Spiral Knives (Replaceable)	44 TCT
Length of Table	1,100mm	Length of Table	1,100mm
Min Extraction Airflow Required	1,000m <sup>3</sup> /hr	Min Extraction Airflow Required	1,000m <sup>3</sup> /hr
Noise Level	89dB	Noise Level	89dB
Dust Extraction Outlet	100mm	Dust Extraction Outlet	100mm
Overall L x W x H	1,100 x 660 x 940mm	Overall L x W x H	1,100 x 660 x 940mm
Weight	182kg	Weight	182kg

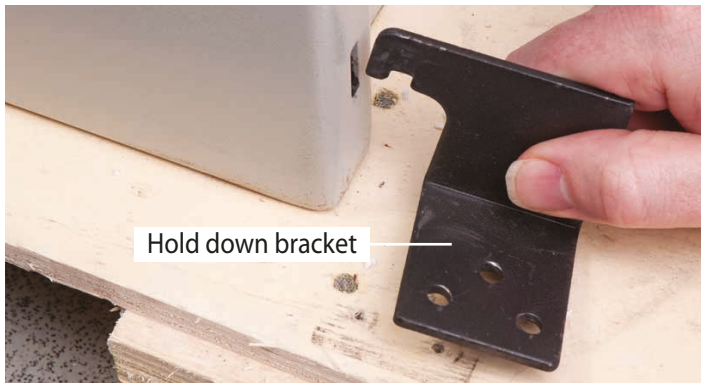
Code	101157
Model	AT310SPT
Rating	Trade
Power	3.0kW 230V 1ph
Feed Speed	5m/min
Cutterblock Speed	4,800rpm
Cutterblock Diameter	70mm
Max Thicknesser Capacity	225mm
Max Planing Width	310mm
Max Depth of Cut Thicknesser	2mm
Max Depth of Cut Planer	4mm
TCT Four Sided Spiral Knives (Replaceable)	56 TCT
Length of Table	1,380mm
Min Extraction Airflow Required	1,500m <sup>3</sup> /hr
Noise Level	89dB
Dust Extraction Outlet	100mm
Overall L x W x H	1,385 x 705 x 1,000mm
Weight	272kg

# Assembly



The planer Thicknesser comes 95% assembled. It is enclosed in a packing case with all the accessories, see fig 01. Having removed the top and the sides of the packing case, remove all the components from the machine, place safely aside.

**Fig 01-02**



Hold down bracket

**1.** Ascertain the orientation of the machine and move it to its desired position in the workshop. Make sure its positioned on a flat level surface and ensure that the machine is positioned to allow sufficient clearance both in front and behind the machine to cater for the maximum length of timber you will wish to machine.

**Remember sufficient space must be left 'around' the machine to facilitate your stance when overhand planing and moving from end to end of the machine if you are thicknessing single handed. Remember that when the surface tables are up and out of the way' for thicknessing, the machine is appreciably wider than when it is in overhand mode.**

**2.** The machine is secured down on to the pallet that forms the bottom of the packing case. Remove these 'hold down' brackets, see fig 02. Place lifting straps around the machine, DO NOT under normal circumstances lift, push or pull the machine using the tables. Any movement is best carried out against the main frame cabinet. Hoist the machine clear of the pallet, slide the pallet out of the way and lower the machine in position.

**NOTE:** There is four 10mm threaded holes to the underside of main frame, to attach adjustable machine feet if required. Check our catalogue or visit our website for details.

**Fig 03-04**



**3.** If you do not have the availability of such a hoist, and are going to have to 'manhandle' the machine off the pallet; make sure the tables are locked down before applying any lifting force to them, see fig 03-04.

**4.** Before adding the fence and the guarding remove the protective grease film from the unpainted parts of the machine. Use a proprietary de-greasing agent. Unfortunately, this cleaning process is always a bit 'mucky'; you are advised to wear overalls or coveralls etc., during the process. Keep in mind the timber you will be machining and its possible finishing process, when you choose your anti-corrosion agent.

## NVR Emergency Stop Lever

Locate the RED emergency stop lever (J) and remove the two Phillips screws and nuts. Line up the holes in the hinges with the ones on the NVR switch housing, insert the Phillips screws through the hinges and replace the nuts. Lightly tighten sufficiently to allow the lever to move freely, see fig 05-06-07.

**Fig 05-06-07**



Phillips screw/nut

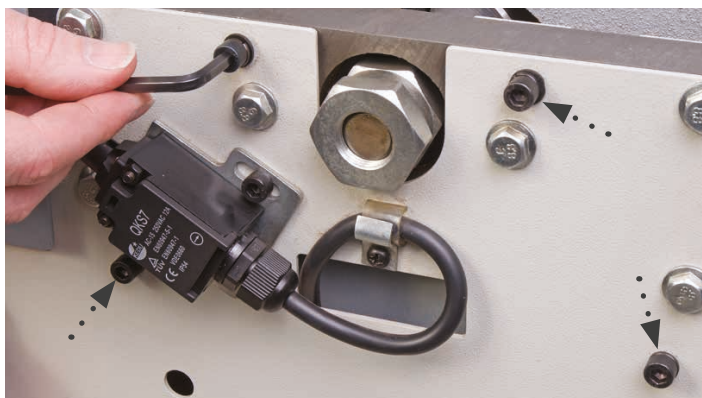
J



## Cutter Block Side Guard

1. Put to hand the side guard (I), remove the four Hex screws and washers to the front of the planer thicknesser and place safely to one side, see fig 08.
2. Place the side guard up against the frame covering the micro switch and cutter block drive shaft. Line up the holes in the guard with the threaded holes in the frame and secure using the Hex screws and washers you removed earlier, see fig 09-10-11.

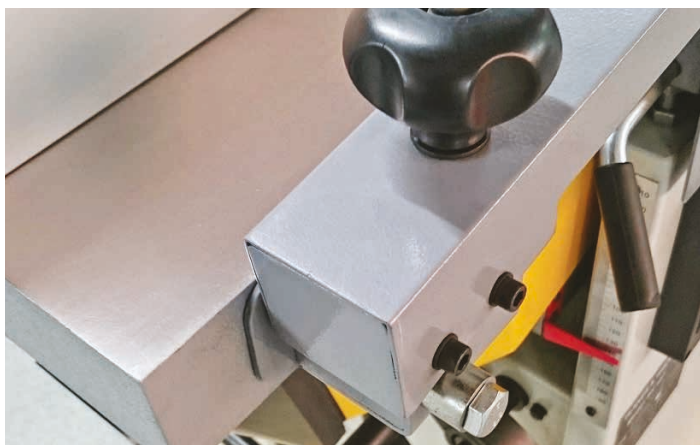
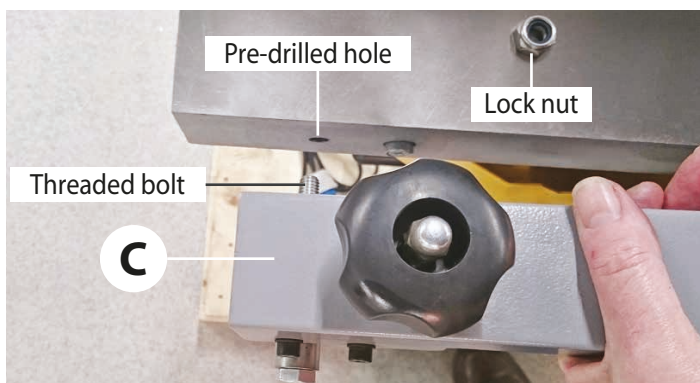
**Fig 08-09-10-11**

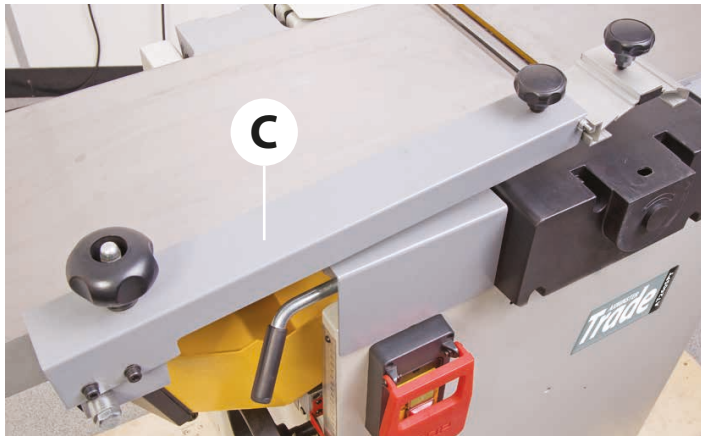


## Overhead Cutter Mounting Arm Guard

1. Locate the overhead cutter mounting arm (C) remove the lock nut from the threaded bolt, insert the bolt through the pre-drilled hole to the side of the outfeed table and secure in place with the lock nut you removed earlier, see fig 12-13-14.

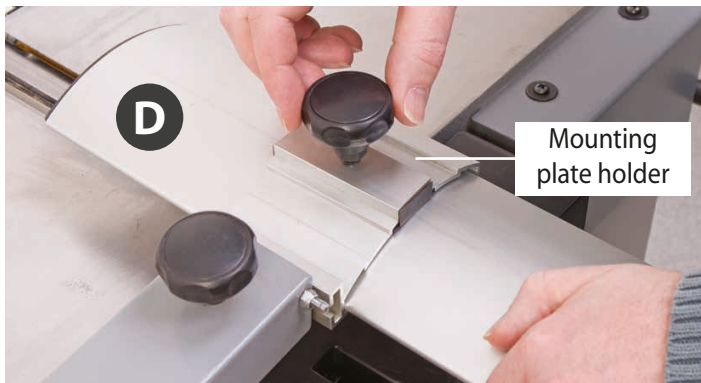
**Fig 12-13-14**





2. Locate the cutter block guard (D). Loosen the locking knob on top of the mounting plate holder on the mounting arm (C). Slot the cutter block guard through the mounting plate and tighten the locking knob, see fig 15.

**Fig 15**

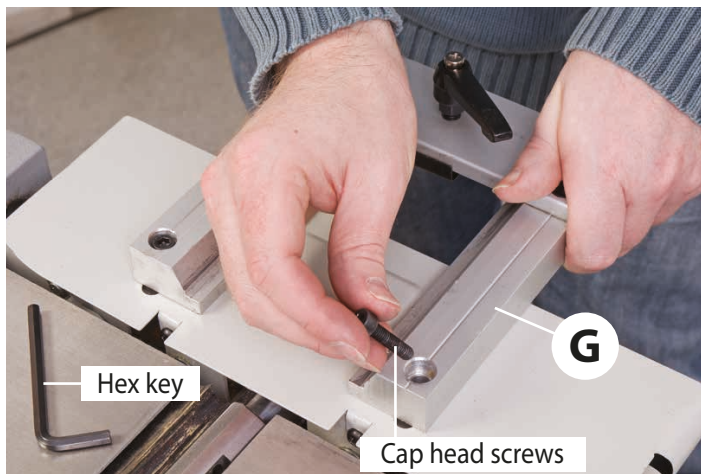


## Mounting the Fence

To mount the fence assembly put to hand the following: The fence tilt assembly (E), fence (F), fence mounting bracket with cap head screws (G) and the two lift and shift handles (H).

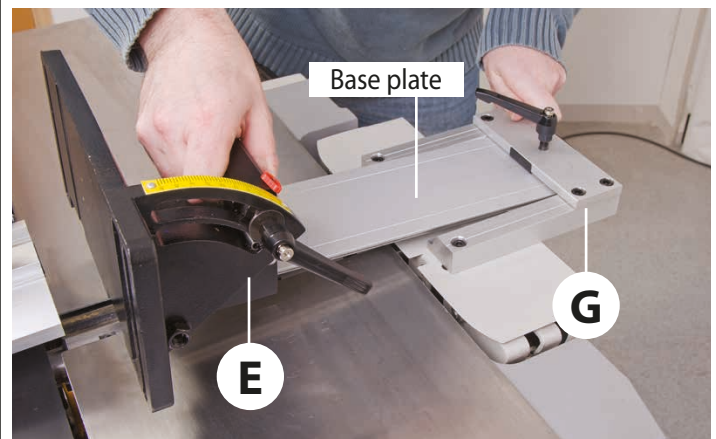
1. Line up the mounting bracket (G) pre-drilled holes with the threaded holes mid table to the rear of planer thicknesser and secure using the two cap head screws, see fig 16-17.

**Fig 16-17**



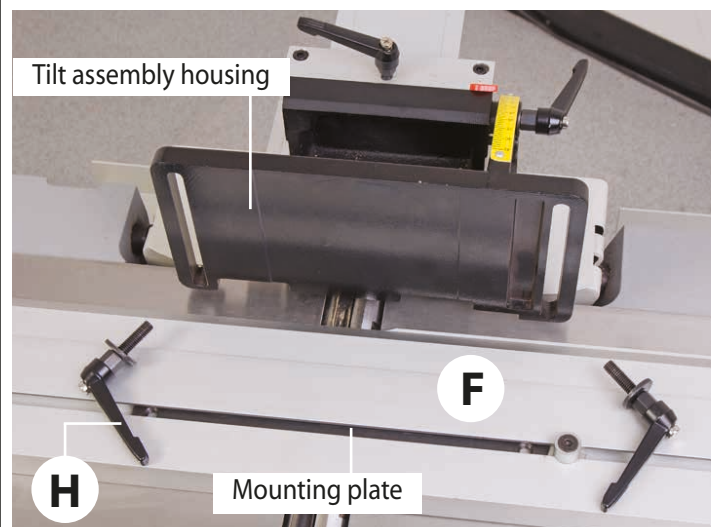
2. Loosen the clamping handle on the mounting bracket, insert the tilt assembly base plate (E) through the mounting bracket (G) sufficiently for the next step. Lightly tighten clamping handle, see fig 18.

**Fig 18**



3. Locate the two lift and shift handles (H) and the fence (F), see fig 19. Position the fence up against the tilt assembly housing (E). Line up the pre-drilled holes in the mounting plate to the rear fence assembly (F) with the elongated slots in the tilt assembly housing (E).

**Fig 19**



**Note:** make sure the fence is the right way up with the machined cutout for the cutter block flush against the tables.

4. Insert the thread of one of the lift and shift handles (H) through the elongated slot and screw it into the fence mounting plate, see fig 20.

**Note: As space is limited to the rear of the tilt assembly housing it may be easier to remove the handle from the threaded bolt, to make it easier to screw on, see fig 21.**

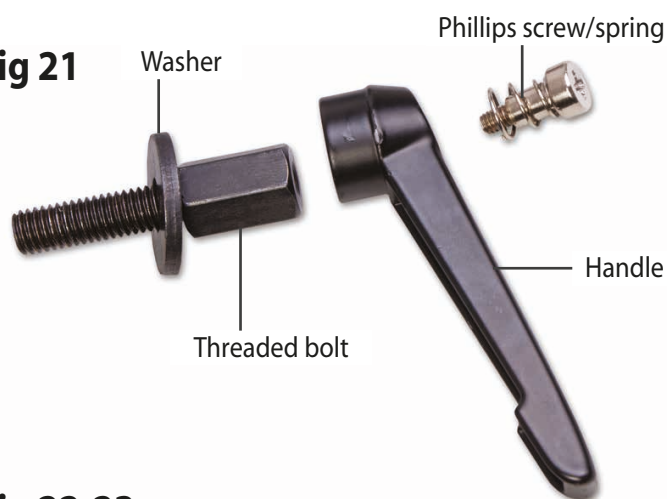
5. Replace the handle and secure in place with the Phillips screw/spring, see fig 22. Repeat for the opposite.

**Fig 20**

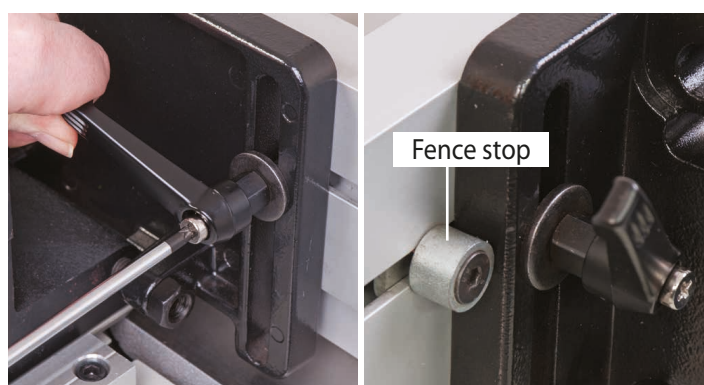


Please note the lift and shift handle has been removed to make it easier to screw on the threaded bolt.

**Fig 21**



**Fig 22-23**

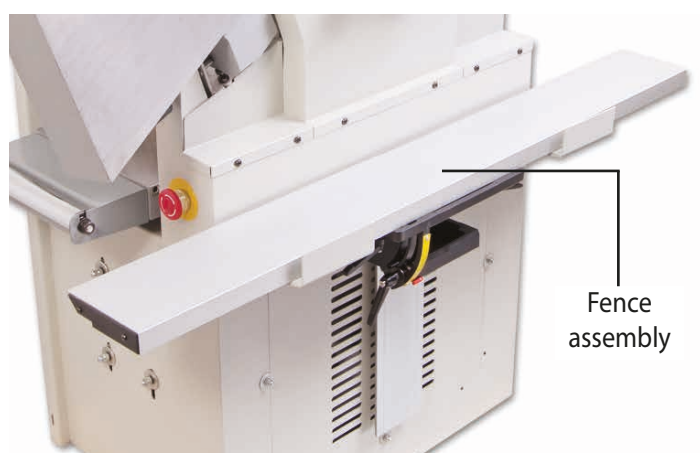
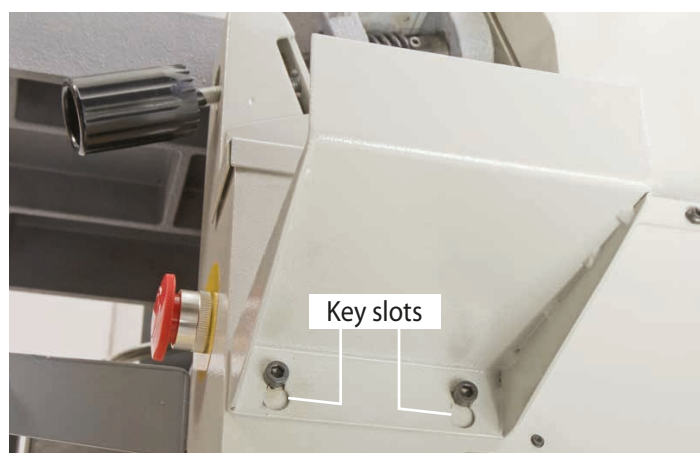


6. Slide the fence (F) until its stop is up against the tilt assembly housing (E) then tighten the lift and shift handles, see fig 23.

## Fence Storage Brackets

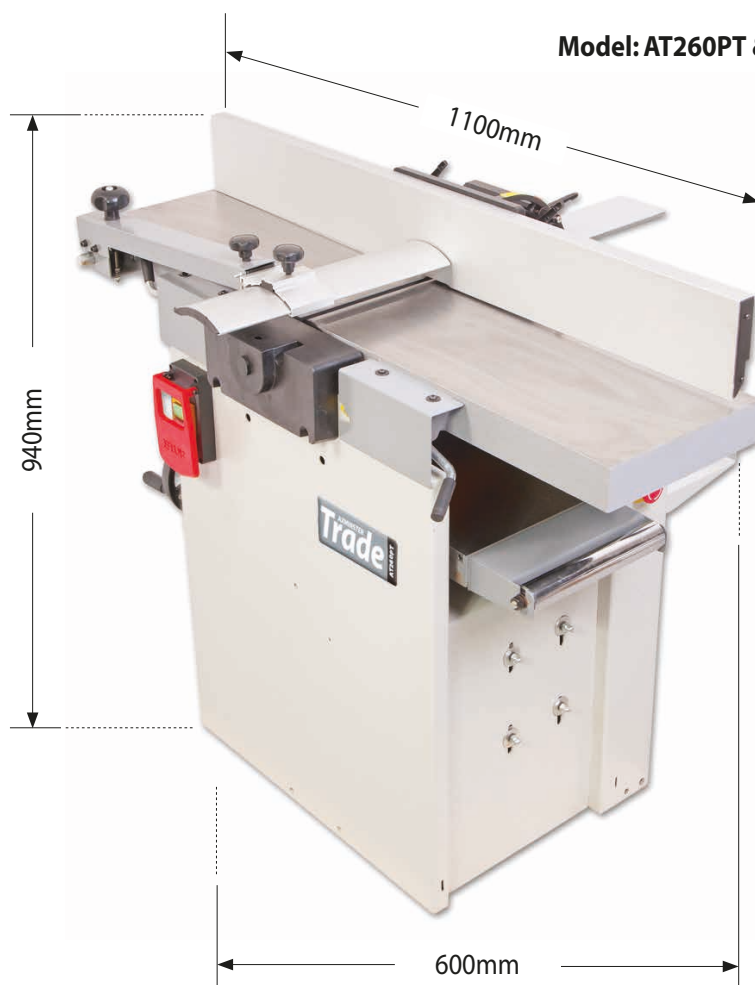
1. Locate the two fence storage brackets (K). Loosen the four cap head screws to the rear of the planer thicknesser. Slot the cutout key slots to the rear of one of the storage brackets down over to one of the cap head screws until it locks in place. Tighten the two cap head screws, see fig 24-25.

**Fig 24-25-26**



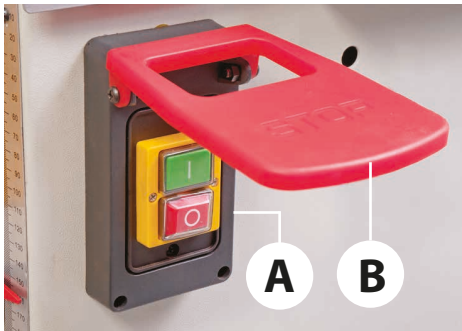
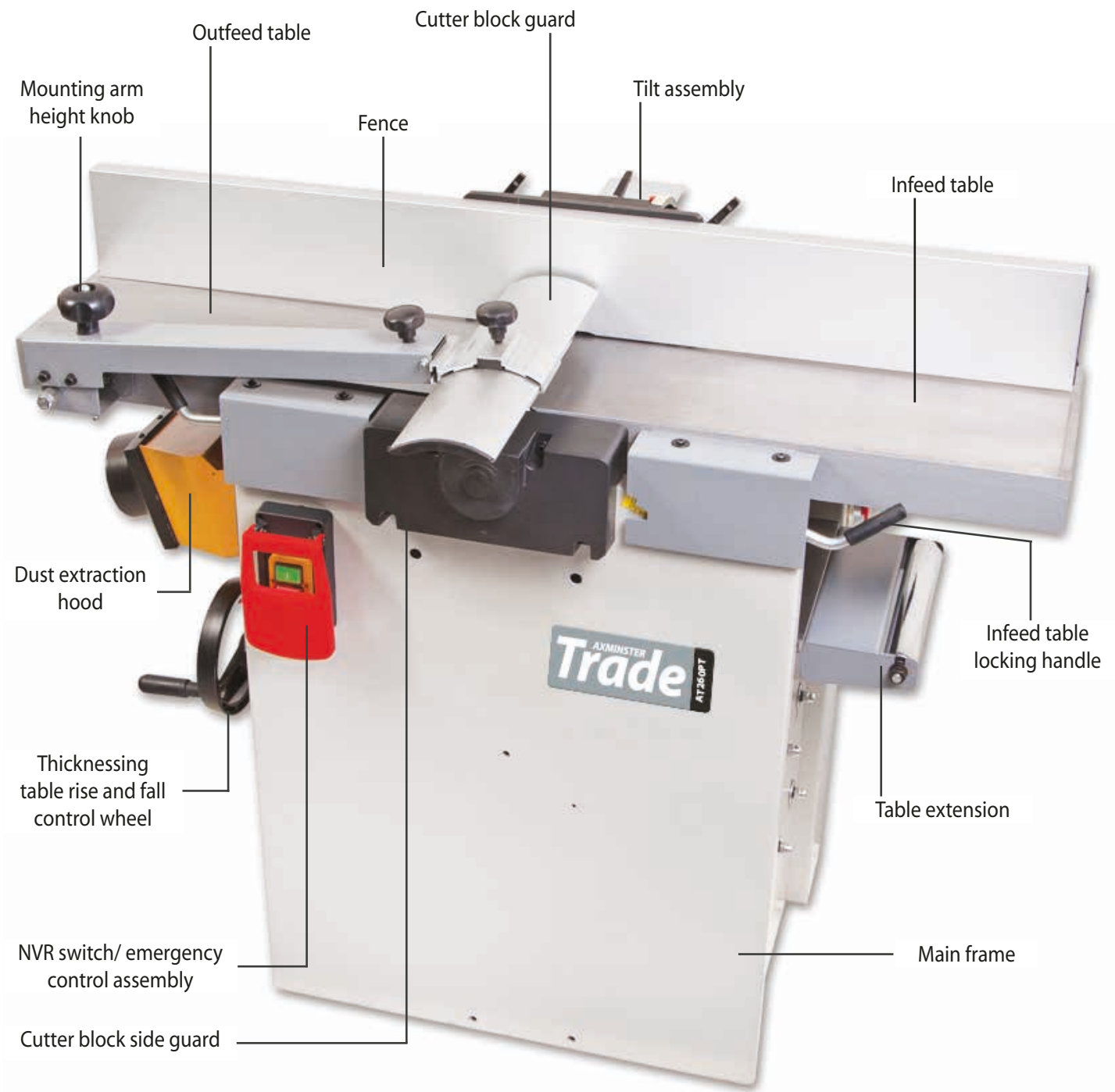
## Machine Footprint

Model: AT260PT & AT260SPT Planer Thicknesser

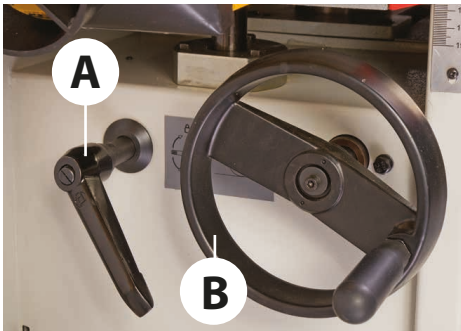


Model: AT310SPT Planer Thicknesser

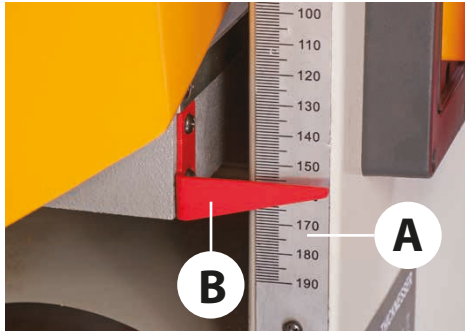
# Illustration and Parts Description



NVR switch assembly (A)  
 Emergency stop shroud lever (B)

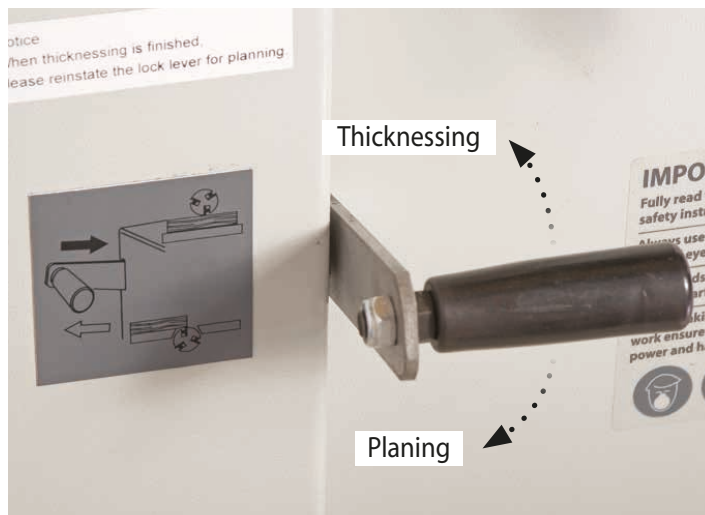


Thickening table rise and fall clamping handle (A)  
 Thickening table rise and fall control wheel (B)

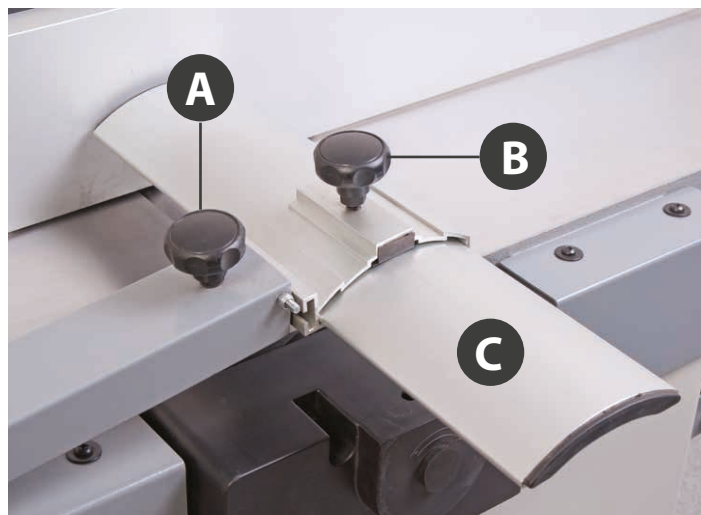


Thickening table rise and fall scale (A)  
 Table Pointer (B)

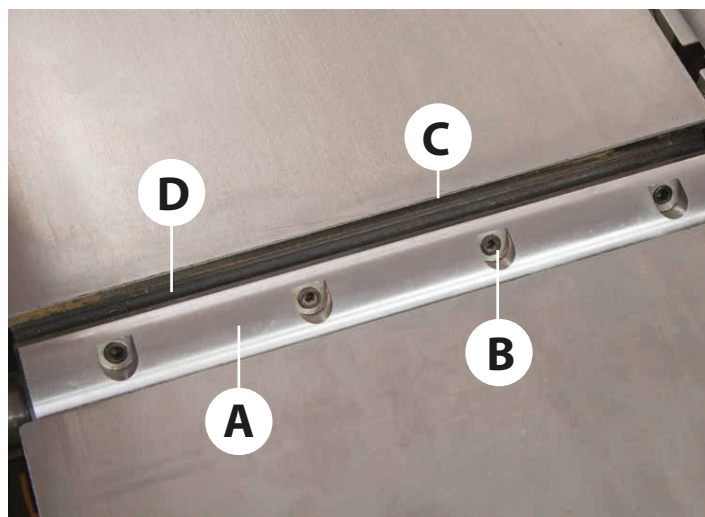
# Illustration and Parts Description



Locking lever to engage either planing or thicknessing function



Cutter block guard angle adjuster (A)  
Cutter block guard clamping knob (B)  
Cutter block guard (C)



Cutter block (A), Clamping Hex screws (B),  
Planer knife (C), Blade holder (D)

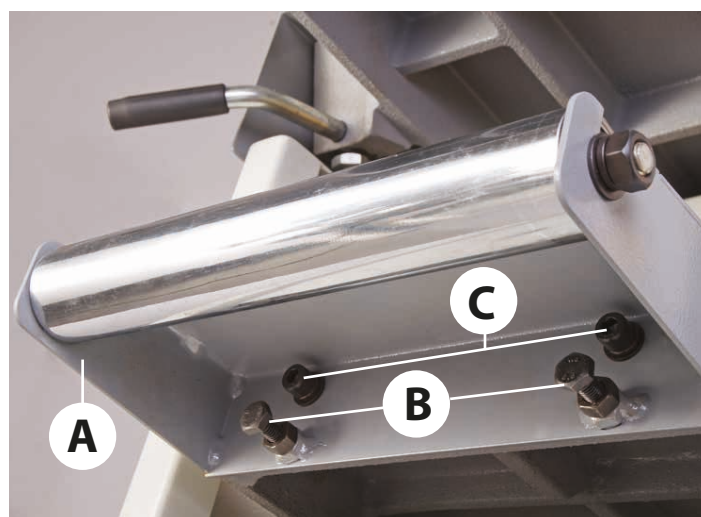
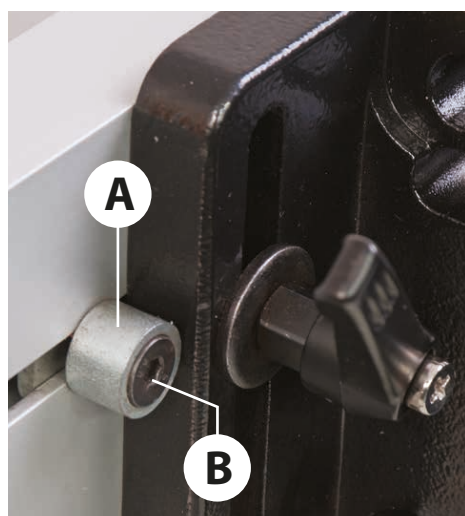
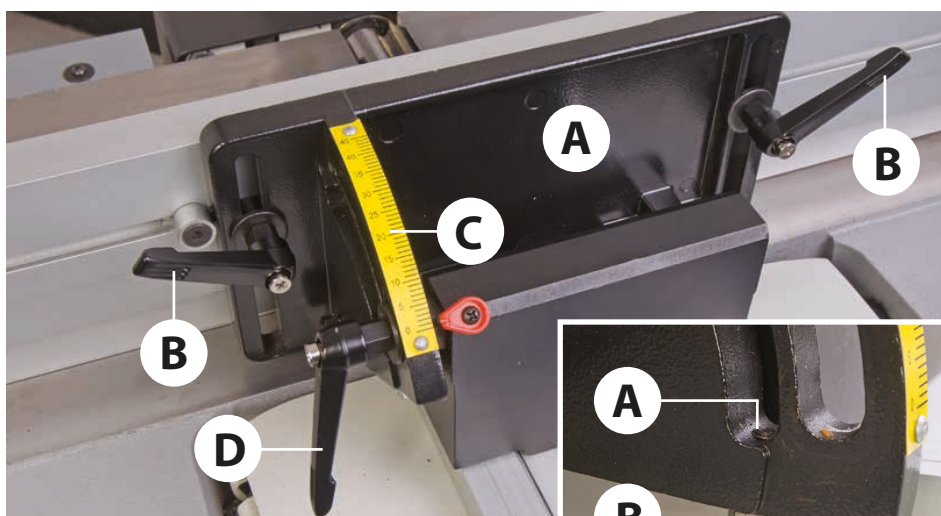


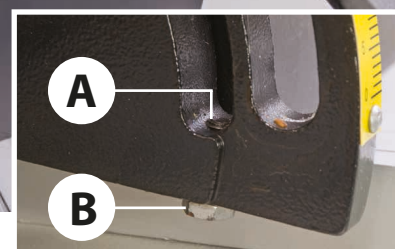
Table extension assembly (A), Table levelling  
adjusting bolts (B) Table clamping Hex bolts (C)



Fence Stop (A),  
Fence stop clamping Hex screw (B)

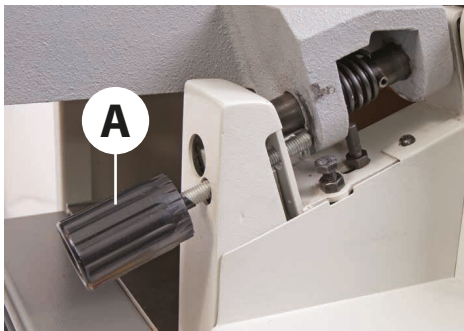
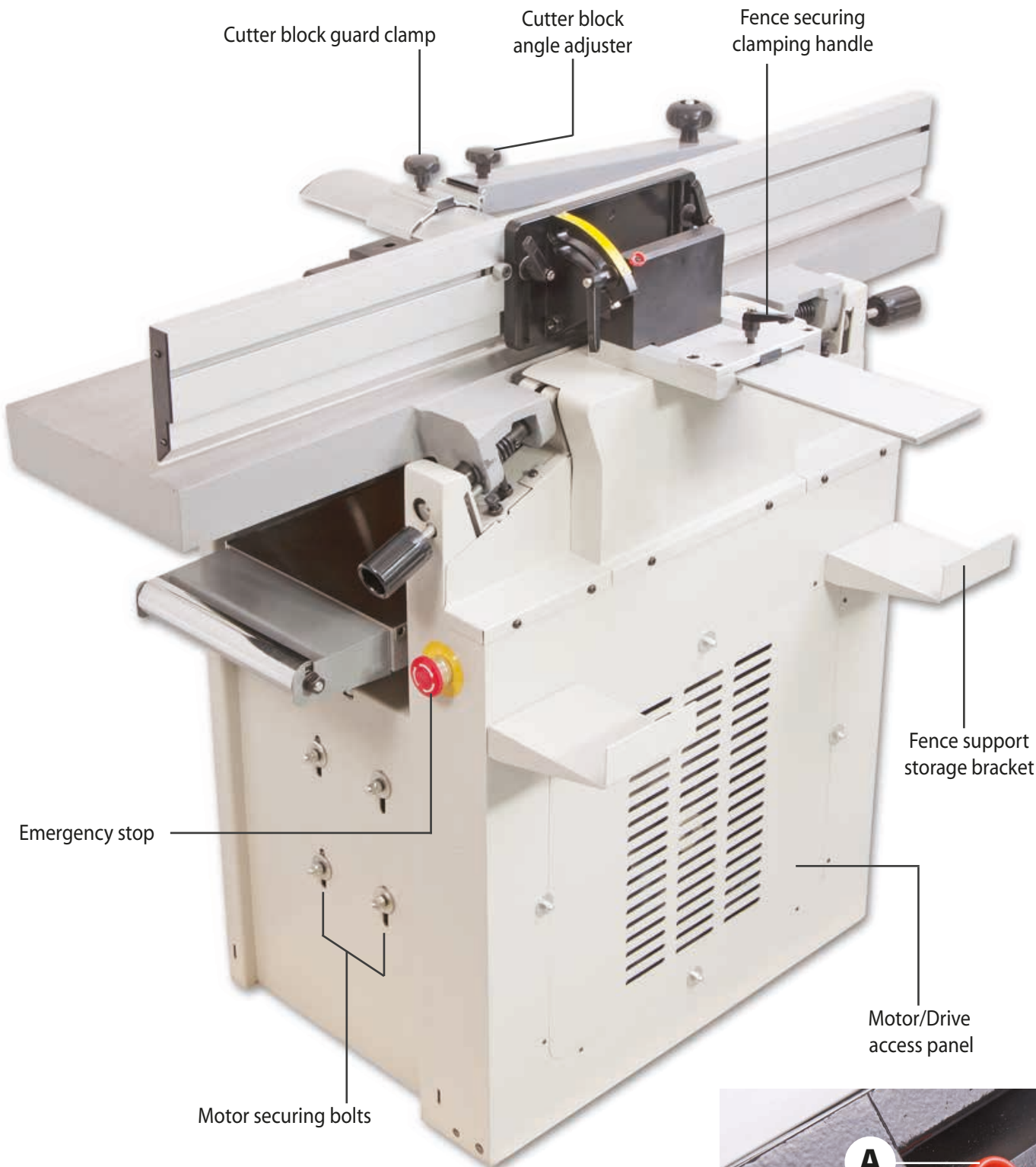


Tilt fence assembly (A), Fence lift and shift  
clamping handles (B), Scale (C),  
Tilt clamping handle (D)



Tilt stop (A)  
Adjusting nut (B)

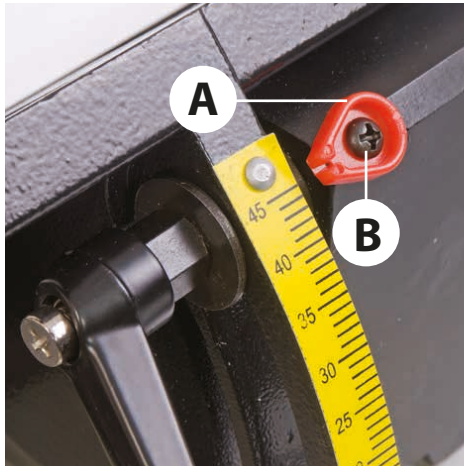
# Illustration and Parts Description



Outfeed table adjuster (A)

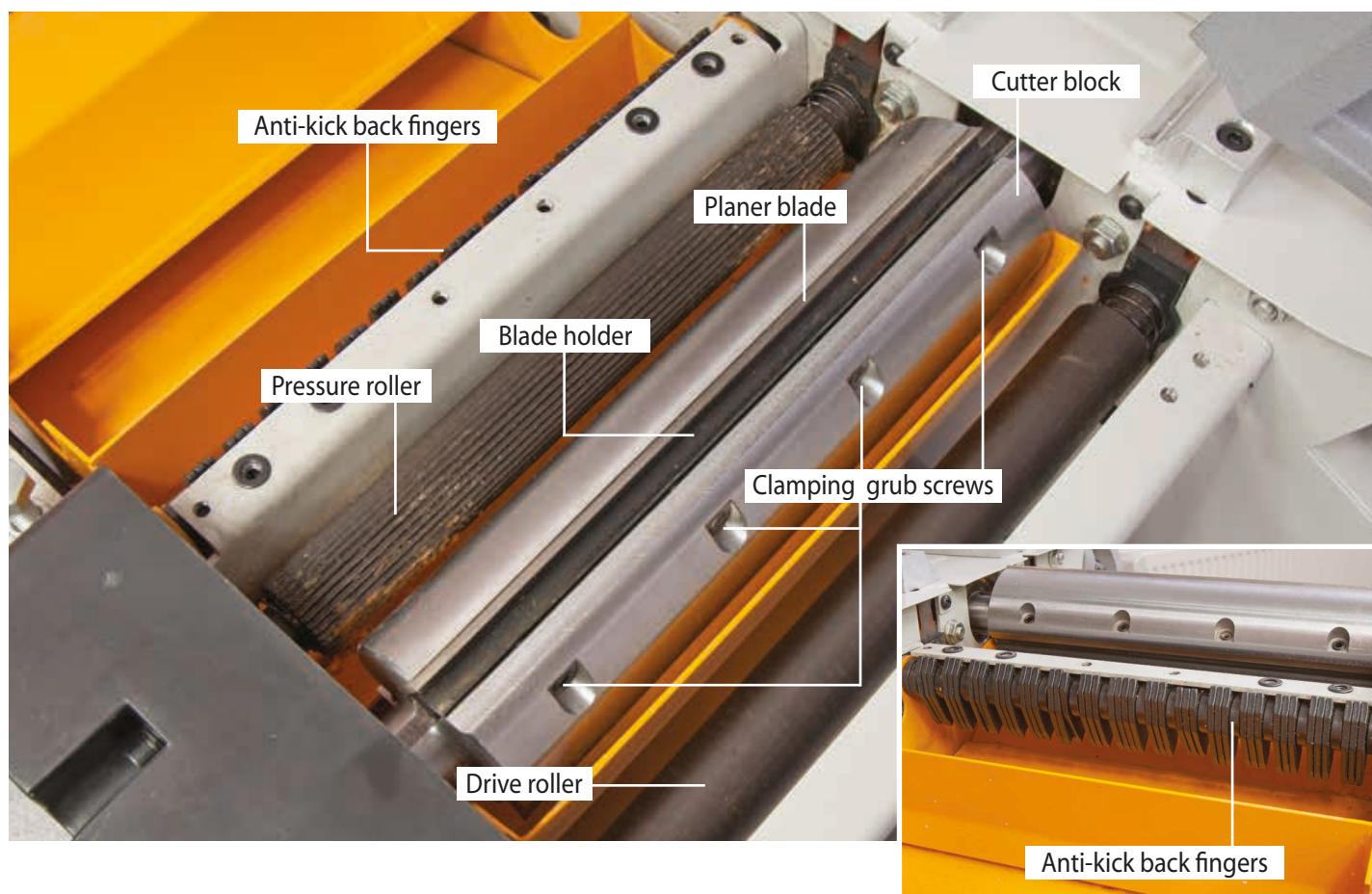
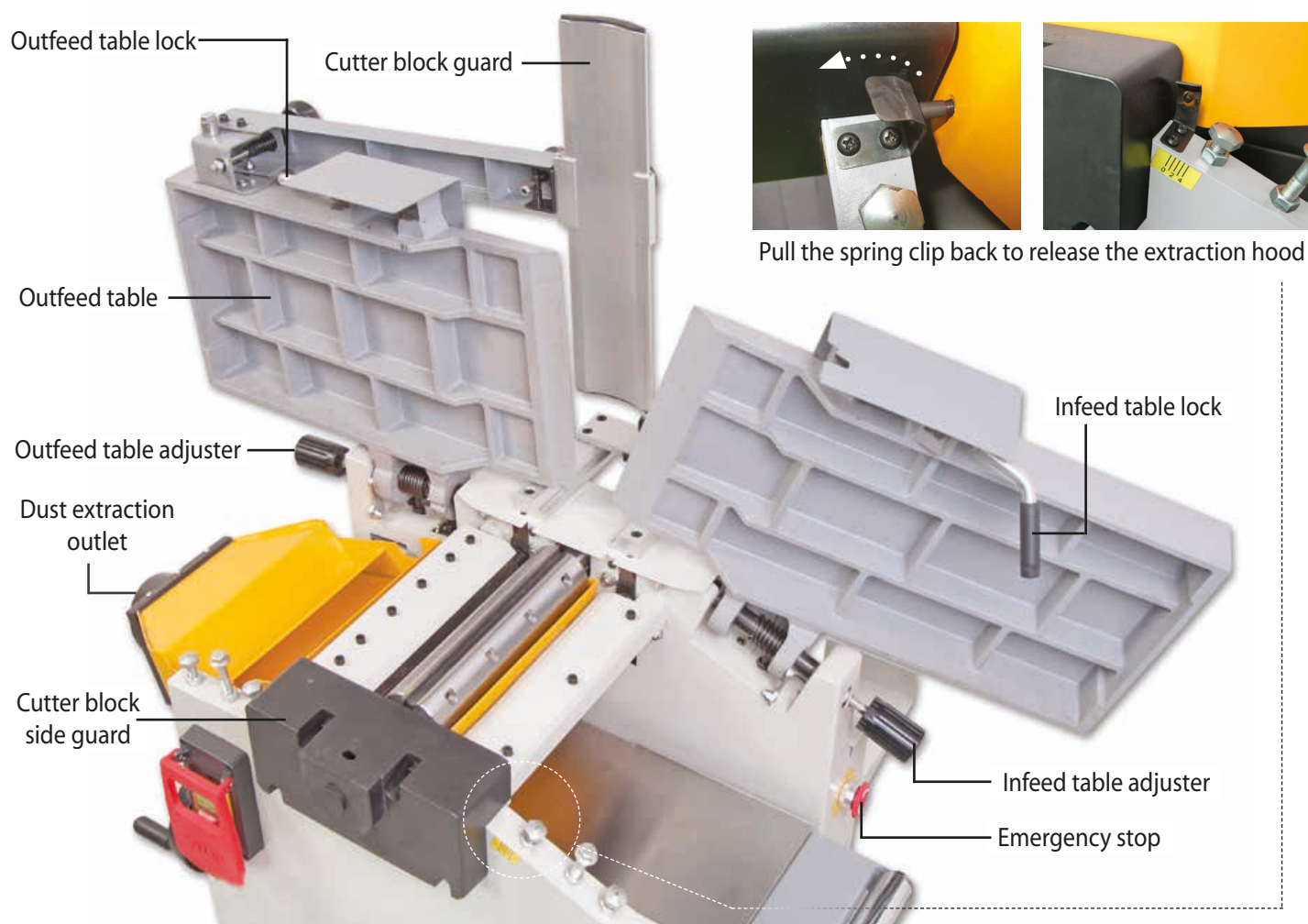


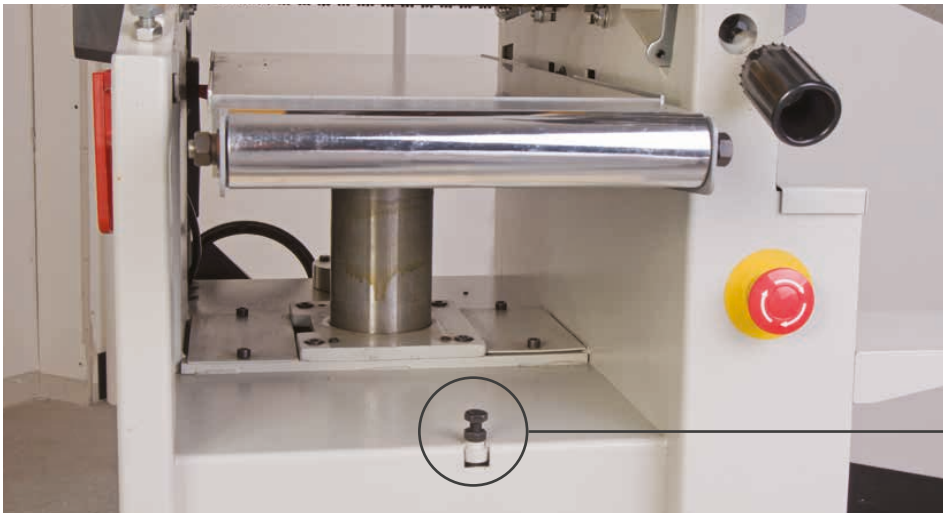
Emergency stop



Fence angle pointer set to 45° (A)  
Pointer adjusting screw (B)

# Illustration and Parts Description





Thickening table assembly



Thickening table adjustable stop

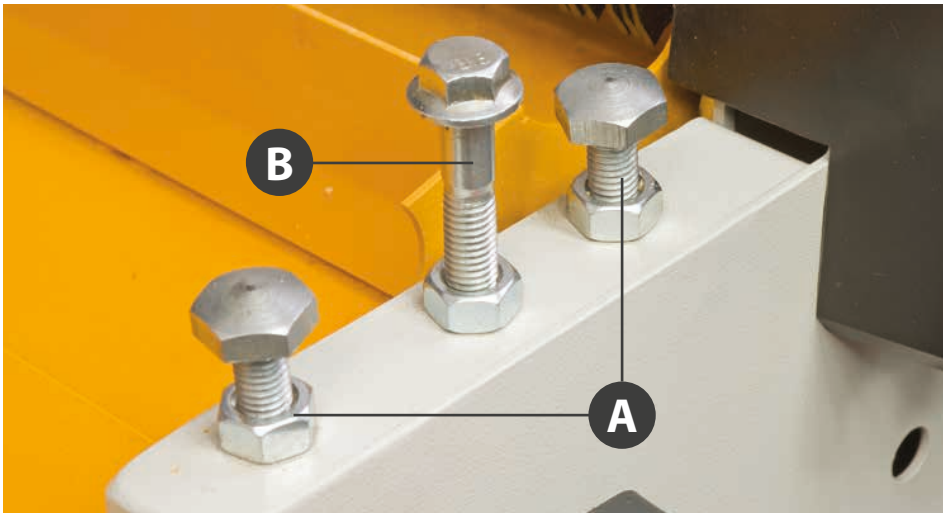


Table positioning studs (A), Table lock stud (B)

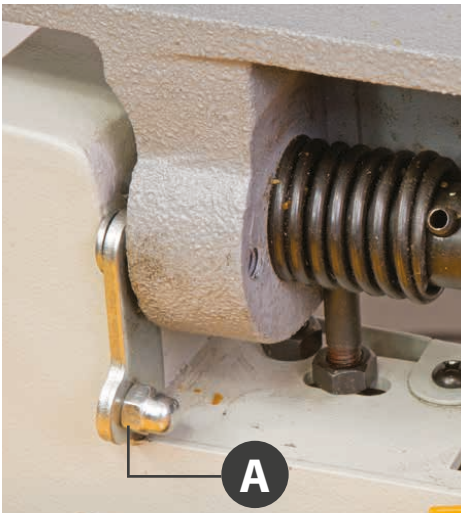
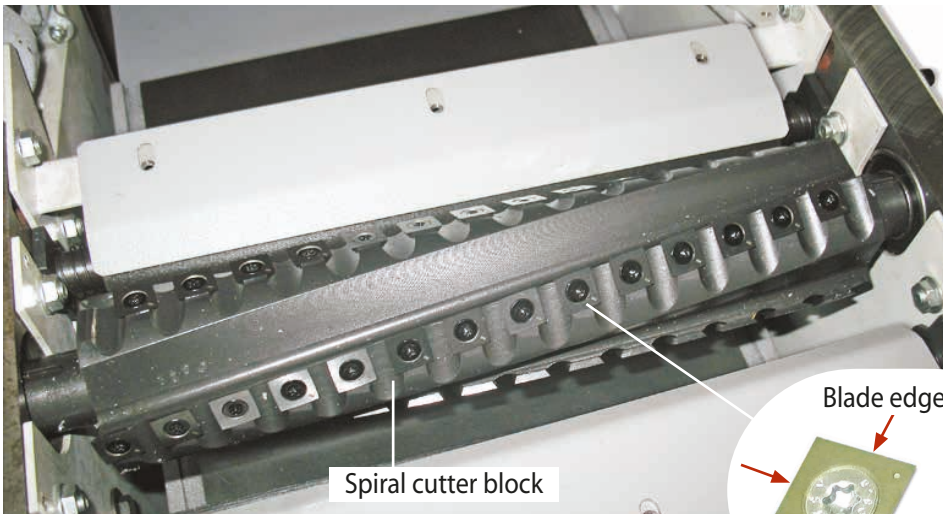


Table locking bar (A)

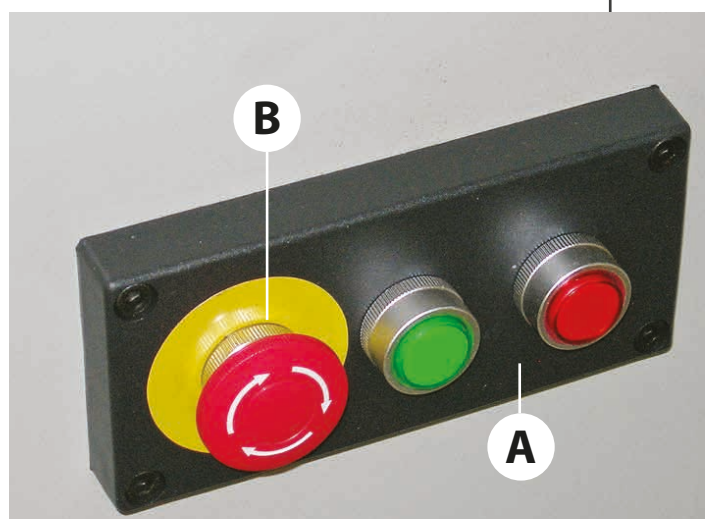


Four sided Spiral Cutter Block with TCT Spiral Blades



Infeed table planning scale

# Illustration and Parts Description

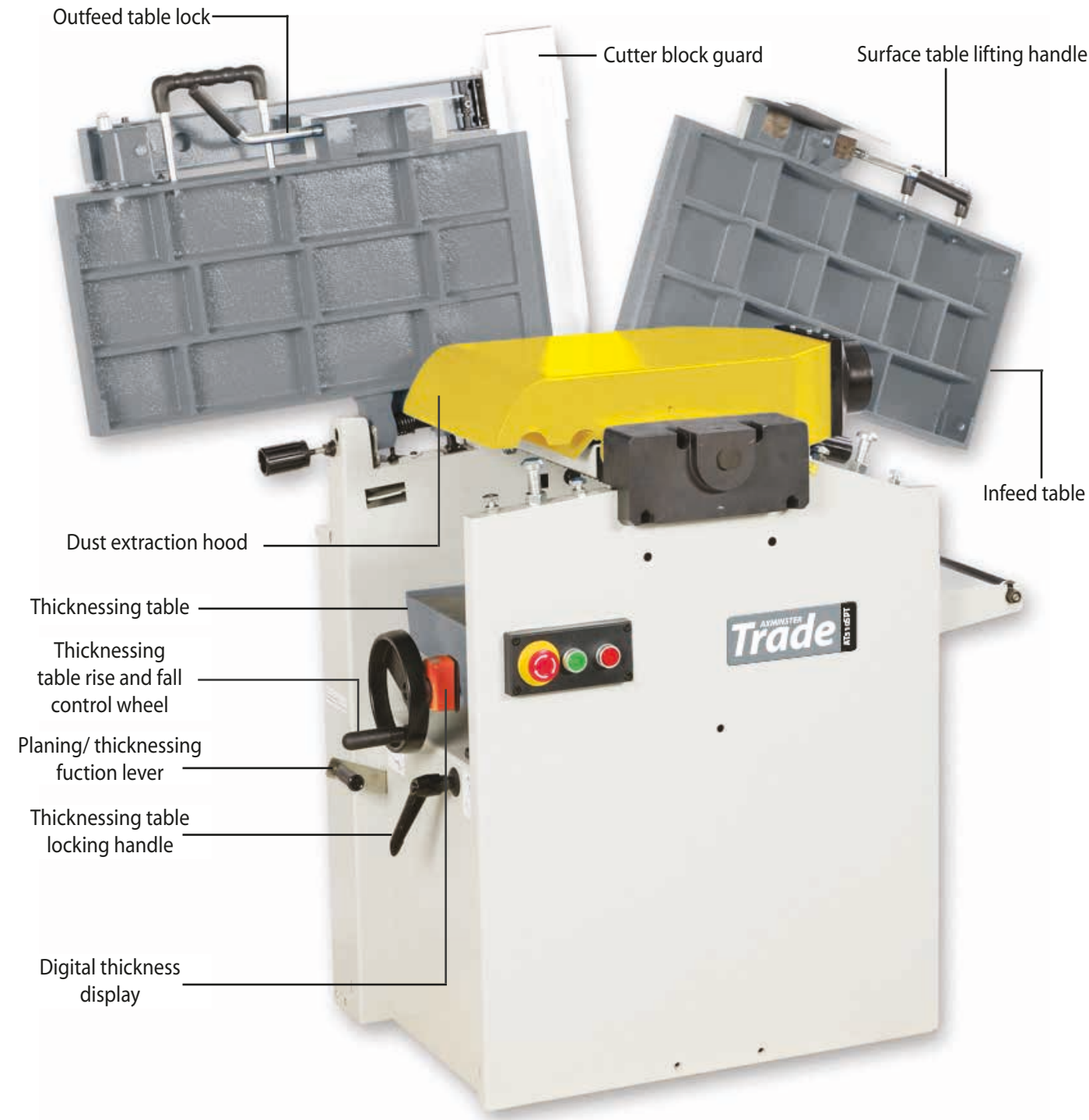


NVR switch assembly (A) and Emergency stop (B)



Emergency stop control box with overload trip (RESET) switch

# Illustration and Parts Description



Motor/Drive access panel (A)

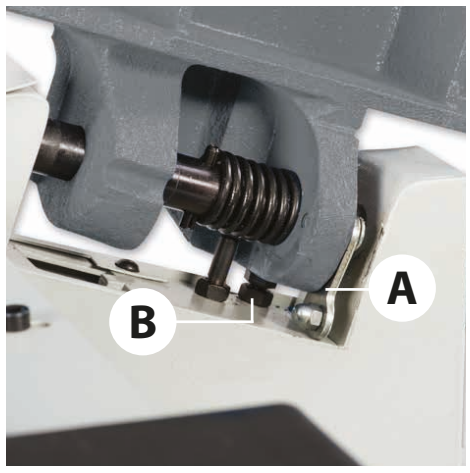


Table locking bar (A)  
Table micro switch (B)

# Setting up the Machine

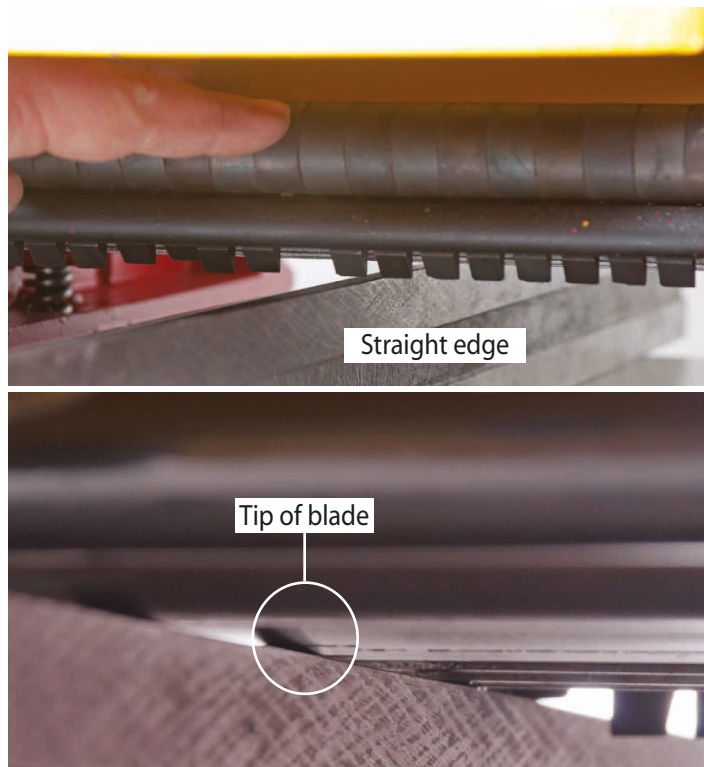
## Digital Thickness Display

The 'Digital Display' will give an accurate visual indication of the amount you are adjusting the thickening table in 0.10mm increments.

The digital display should be pre-set at the factory but if required can be set as follows.

1. Place a straight edge across the thickening table, raise the table until the tip of the cutter-block blade at it's lowest point is touching the top of the straight edge, see fig A-B.

Fig A-B



2. Using a vernier, measure the height of the straight edge and write down the reading, see fig C. Loosen the grub screw holding the collar mechanism, turn the collar on the digital display unit and dial in the measurement you wrote down, see fig D-E. Tighten the grub screw, clamping the collar to the drive shaft.

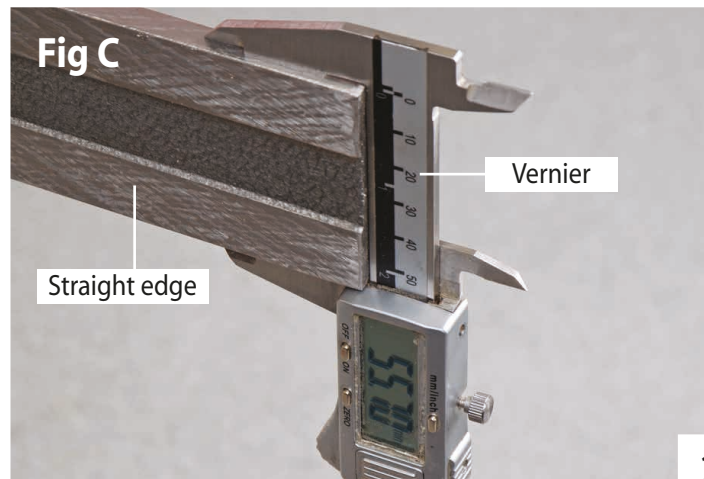


Fig D-E



3. Remove the stright edge from the thickening table.



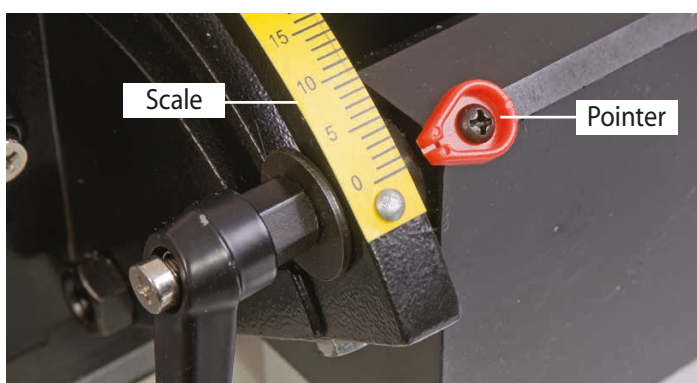
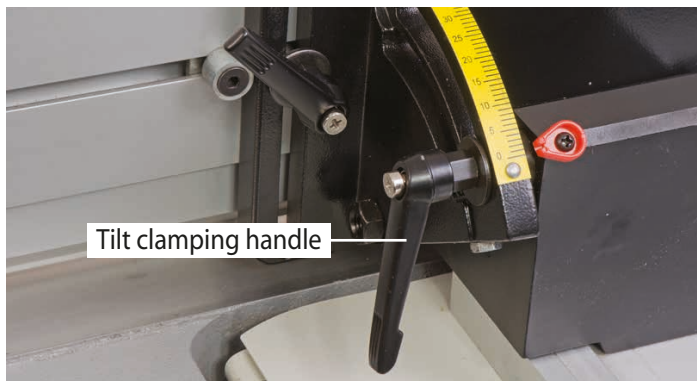
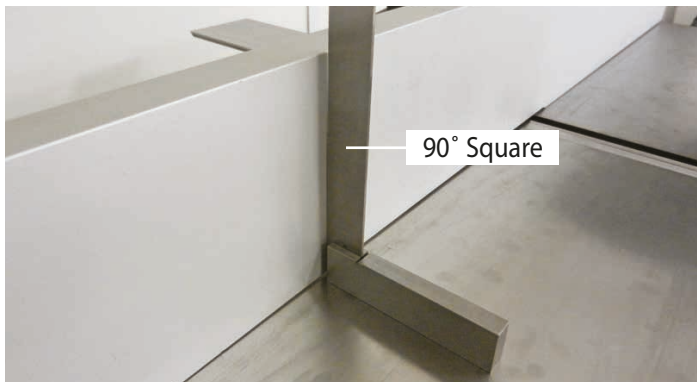
## Surface Tables and Cutter Block

Correctly setting the tables and the cutter block is important, not only to improve the quality of the work, but also to the safety when operating the machine.

### Setting the Fence at 90°

1. Using a 90° square, place it on the outfeed table and against the fence, checking the fence is square with the outfeed table, see fig 27. If adjustment is required loosen the tilt clamping handle to the rear of the fence assembly and adjust the fence until correct, re-tight the clamping handle, see fig 28.

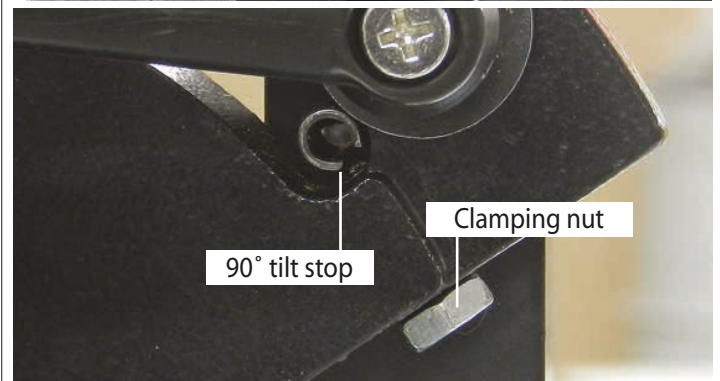
**Fig 27-28-29**



**NOTE:** Check that the pointer on the tilt assembly lines up with 'zero' on the scale. If, not loosen the pointer's clamping screw and adjust until correct, see fig 29.

**NOTE:** Reset the 90° degree tilt stop by loosening the clamping nut and adjusting the Hex screw, see fig 30-31.

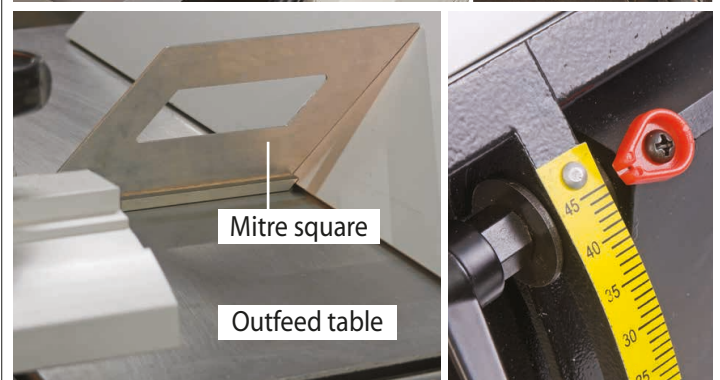
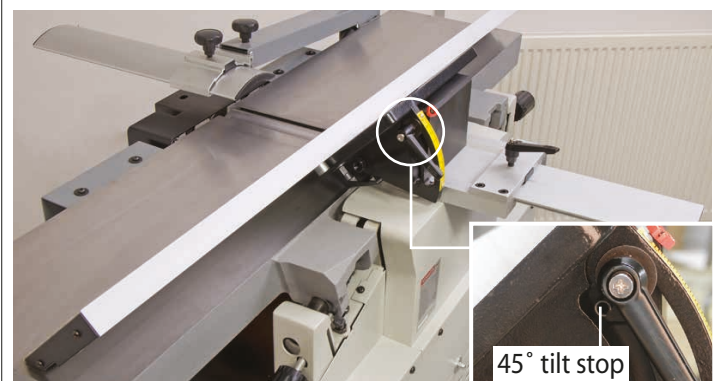
**Fig 30-31**



### Setting the Fence at 45°

2. Set the fence to 45° degrees by loosening the tilt clamping handle as before, place a mitre square up against the fence and check it's perpendicular with the outfeed table. Adjust the fence until correct and nip up the tilt clamping handle. Reset the pointer and 45° degree stop, see fig 32-33.

**Fig 32-33**



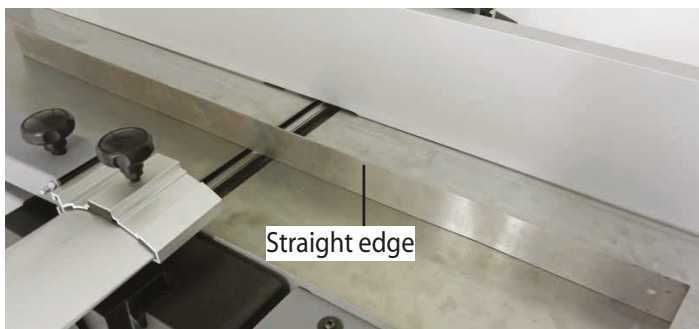
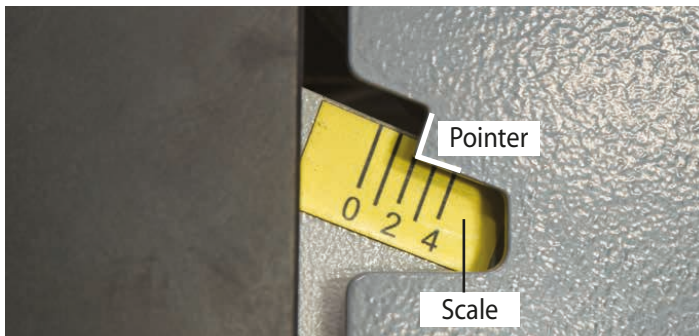
# Setting up the Machine

## Infeed Surface Table

1. Raise the infeed table by turning the rise and fall adjusting knob, see fig 34, until the infeed table pointer reads 'zero' on the scale, see fig 35.

2. Place a straight edge across both tables and check they are both level, see fig 36. If not, adjust the two positioning studs below the table, see next step.

Fig 34-35-36



3. Remove the fence assembly and lower the unit onto the storage brackets to the rear of the machine. Unlock the infeed table locking handle and raise the table up, see fig 37-38-39. With the table out of the way adjust the two positioning studs, see fig 40.

**NOTE: Remember to make small adjustments to the studs so you don't over correct.**

4. While holding the table, pull out the table locking bar and lower the infeed table, secure in place with the locking handle, see fig 41-42. Place the straight edge across the tables and check again. Repeat the procedure until both surface tables are level.

Fig 37-38-39



Fig 40

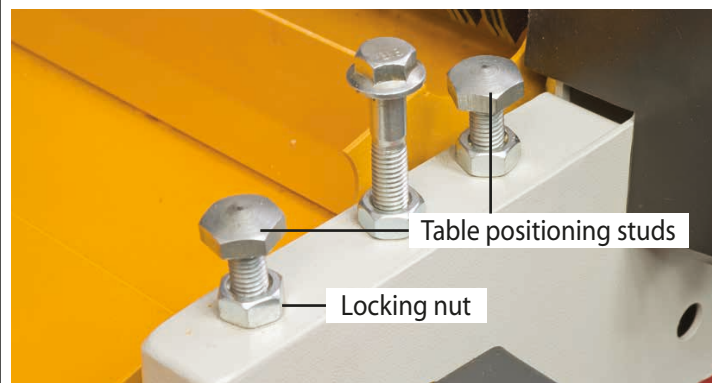


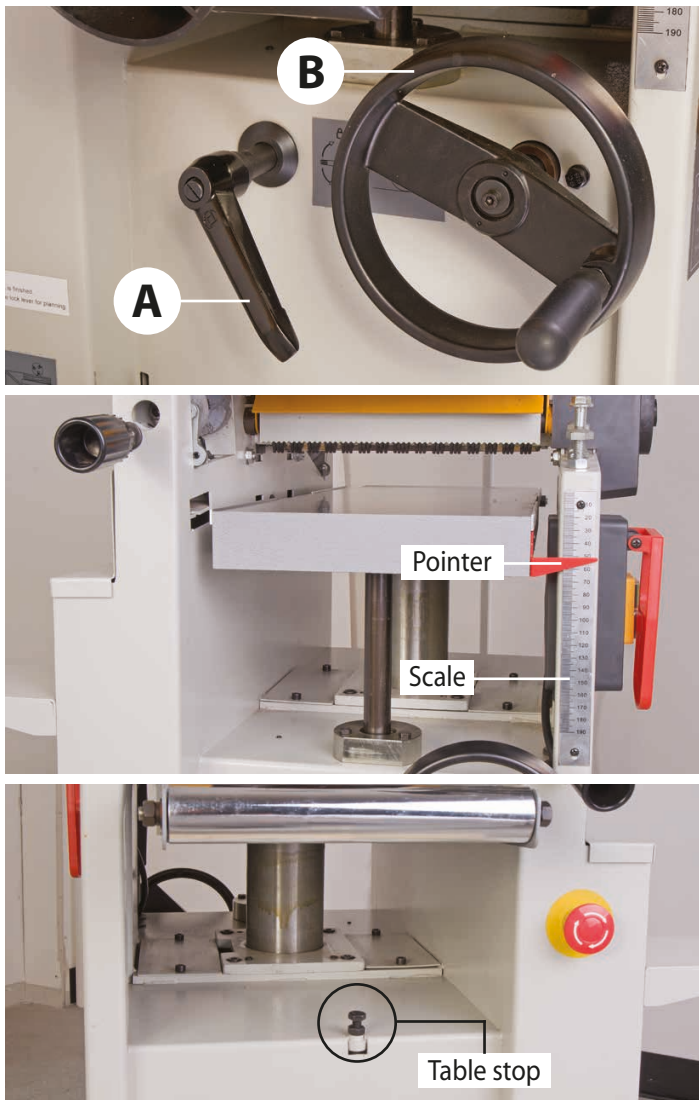
Fig 41-42



## Thickening Table

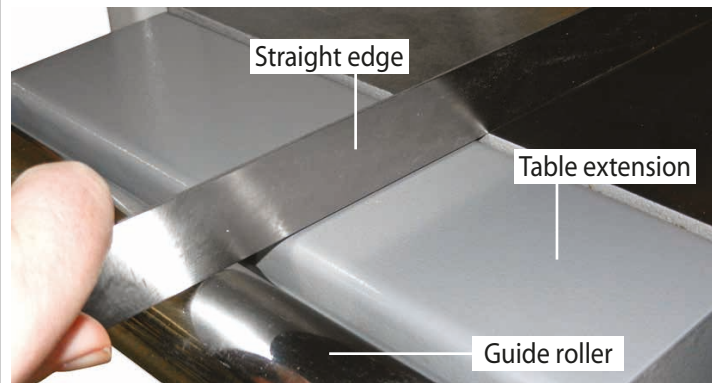
1. Raise the surface tables as explained on the opposite page.
2. Release the rise and fall clamping handle (A) and turn the operating wheel (B) counterclockwise to lower the thickening table until the pointer reads 190 on the scale and check the stop is up against the underside of the thickening table. If not, loosen the locking nut and adjust the stop then re-tighten the nut to lock the setting, see fig 43-44-45-46.

**Fig 43-44-45-46**



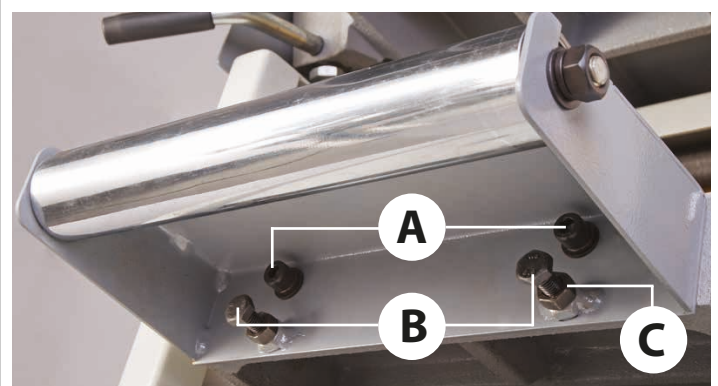
**Table Extension**

**Fig 47**



1. Place a straight edge across the thickening table and guide roller and check they are both in line with each other, see fig 47.
2. If adjustment is required, loosen the two cap head bolts (A) and adjust the Hex bolts (B) until alignment is reached, tighten the nuts (C) to lock the setting. Re-tighten the cap head bolts (A), see fig 48.

**Fig 48**



## Positioning the Machine

Ascertain the orientation of the machine and move it to its desired position in the workshop. Ensure that the machine is positioned to allow sufficient clearance all round to cater for the maximum length of timber you wish to machine. The machine should be positioned on a flat level surface.



# Operating Instructions

## Planning/Thicknesser



### HSE Health and Safety Executive

To operate the machine correctly, it is recommended to read the HSE (Health and Safety Executive) website at [www.hse.gov.uk](http://www.hse.gov.uk) on the safe operation procedures.

### Setting the Machine for Planing

1. Lower the surface tables and re-mount the fence assembly. Check the machine is set up correctly, see the section for setting up the machine. Press down the locking lever to engage the planing function, see fig 49.

2. Connect a 100mm extraction hose to the extraction hood outlet.



**CONNECT THE MACHINE TO THE MAINS SUPPLY!**

3. Visit the HSE (Health and Safety Executive) website for the correct safe operating procedures.

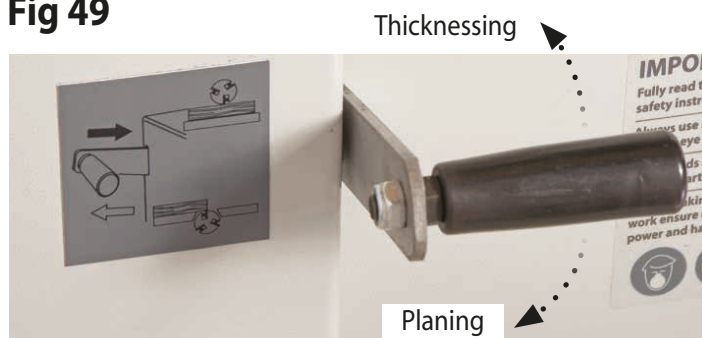
4. Lift up the emergency stop shroud lever and press the 'GREEN' button to start the machine.

5. When planing is finished switch off the machine by pressing the 'RED' button and wait until it comes to a complete stop.



**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!**

**Fig 49**



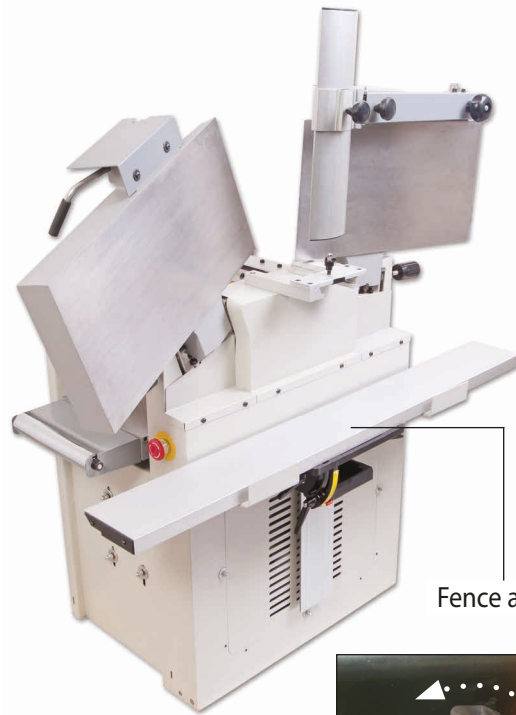
### Setting the Machine for Thickening

1. Remove the fence assembly and place it in its holder to the rear of the machine. Unlock the surface table and raise them to the upright position, see fig 50.

2. Rotate the dust extraction hood until it's in the upright position, see fig 51.

3. Raise the locking lever to engage the thickening function, see fig 49.

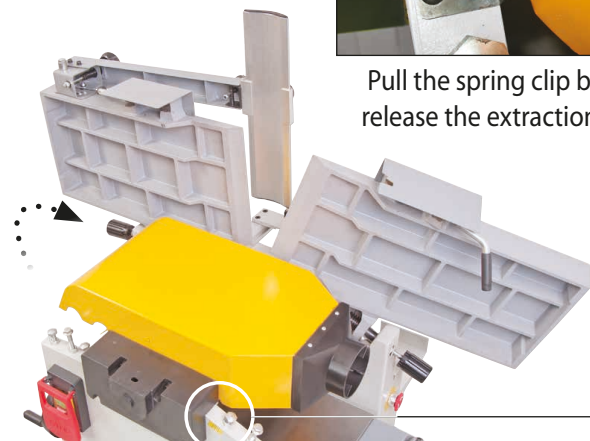
**Fig 50-51**



Fence assembly



Pull the spring clip back to release the extraction hood



5. Visit the HSE (Health and Safety Executive) website for the correct safe operating procedures.



**CONNECT THE MACHINE TO THE MAINS SUPPLY!**

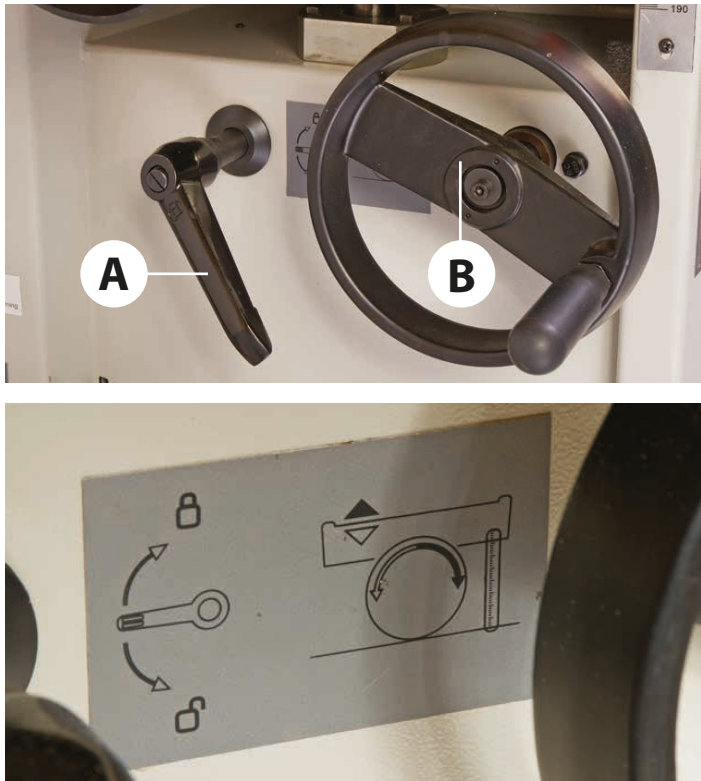
6. Release the rise and fall clamping handle (A) and turn the operating wheel (B) clockwise to raise the thickening table to the required thickness then re-tighten the clamping handle, see fig 52-53.

7. Lift up the emergency stop shroud lever and press the 'GREEN' button to start the machine.

8. When thickening is finished switch off the machine by pressing the 'RED' button and wait until it comes to a complete stop.

**NOTE: Disconnect the machine from the mains before making any adjustments.**

**Fig 52-53**



## Emergency Stop

There are two emergency stops on this machine, the first is part of the NVR switch assembly, a large red shroud lever covering the ON/OFF buttons. The second is mushroom shaped, mounted to the side of the machine, see fig 54-55.

In an emergency, slap down on either stop to bring the machine to a halt. Note: You will need to twist the mushroom shaped stop to unlock it allowing the machine to restart when the 'GREEN' button is pressed.

**Fig 54-55**



Slap down the shroud lever to stop the machine in an emergency.



Rotate the mushroom emergency stop to unlock

## Changing the Cutter Block Blades

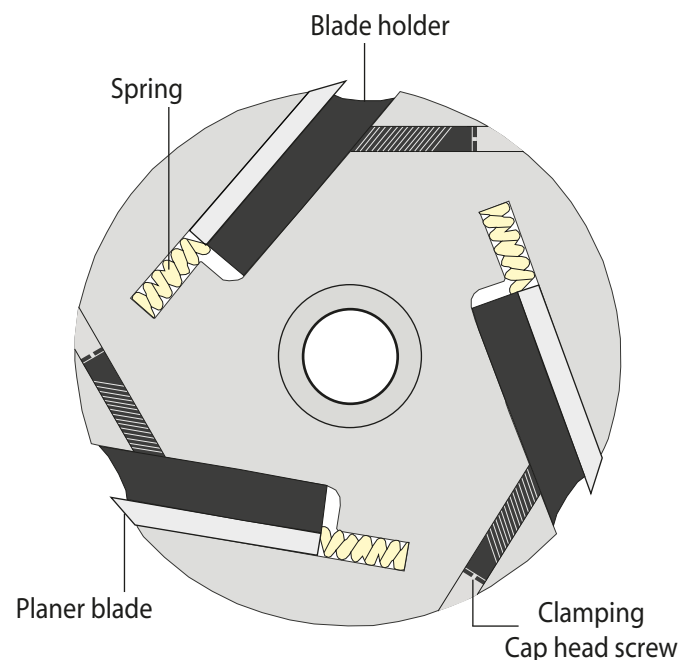


**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY BEFORE CONTINUING!**

### Overview

The planer blades are mounted into three slot housings machined in the cutter block. The slot housing comprises of a slot cut on a radial axis with a reverse tapered slot around it. The depth of the first slot governs the seating of the blade holder, the second slot allows the blade to be set to its correct depth in the block.

The blade holder is machined with a tapered face set at the same angle as the slot. This allows the blade to be clamped between parallel faces, see illustration opposite.



Continues Over....

# Changing the Cutter Block Blades

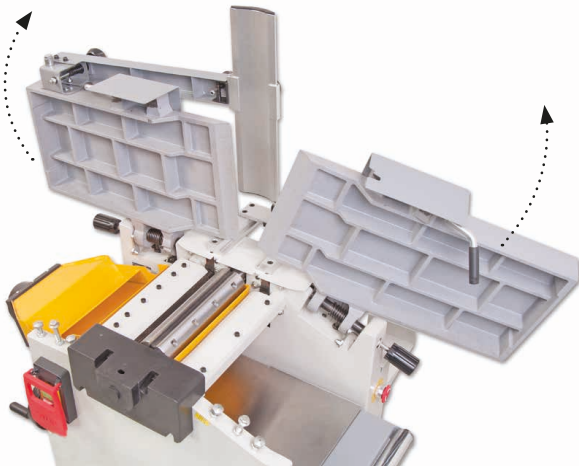


**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY BEFORE CONTINUING!**

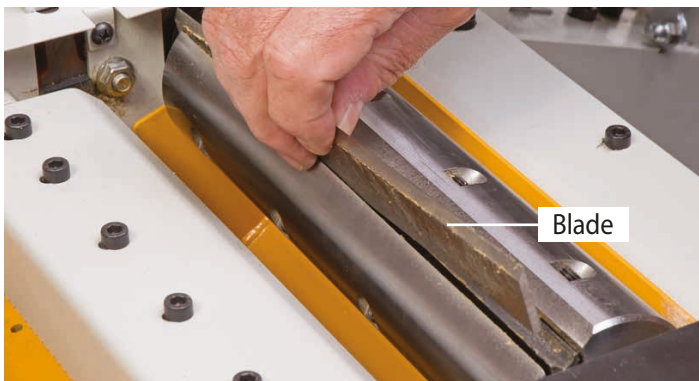
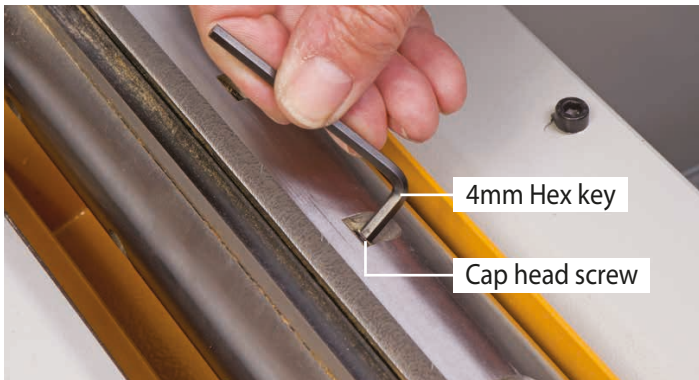
## Changing the Standard Blades

1. Remove the fence assembly, raise the two surface tables into the upright positions to gain access to the cutter block, see fig 56.
2. Turn the cutter block until one of the slots is in the upright position. Using a 4mm Hex key loosen the four cap head screws on the cutter block, thus removing the clamping effect. This should allow the blade to 'spring' up, protruding clear of the edge of the cutter block, see fig 57.

**Fig 56**



**Fig 57-58**



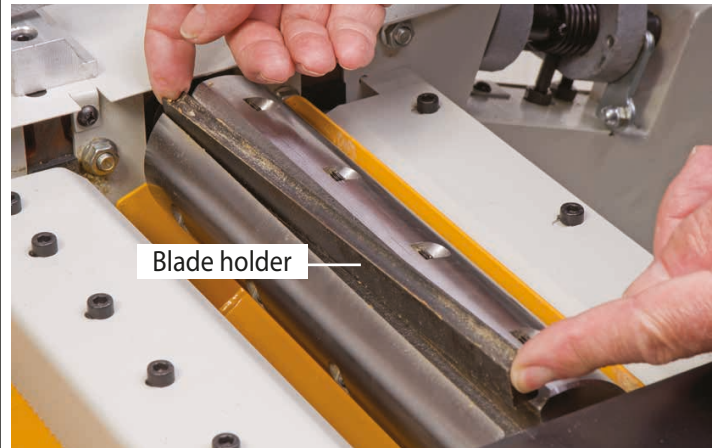
3. Carefully remove the blade and place safely aside, see fig 58.



**WARNING! BE VERY CAREFUL WHEN REMOVING THE BLADE AS IT IS EXTREMELY SHARP.**

4. Remove the blade holder and lay aside. Clean the slot housing thoroughly, remove any resin build-up, sawdust, chips etc. Clean the blade holder and ensure the circumference of the cutter block is cleaned thoroughly, see fig 59.

**Fig 59**



5. Remove the new blade from its keeper and place the old blade in its place. Locate the blade setting tool (L), see fig 60.

**Fig 60**

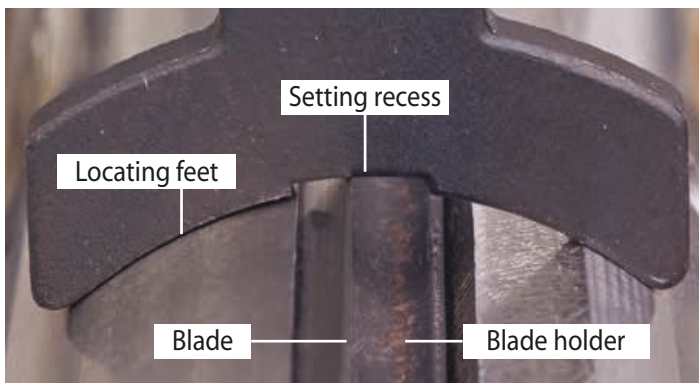
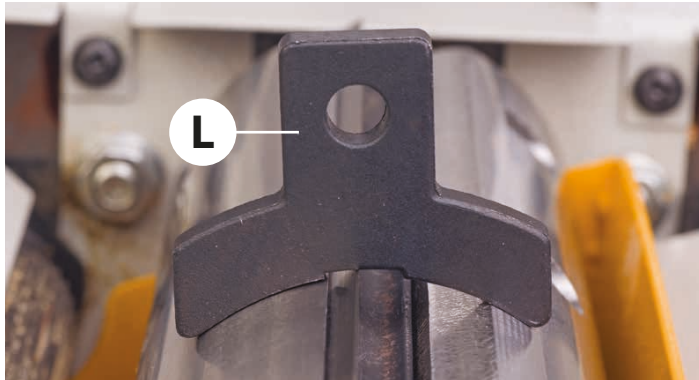


6. Introduce the blade holder, position it against the back of the slot, introduce the blade in the front of the blade holder. Carefully position the blade and the holder to line up with the edge of the cutter block. Press the blade setting tool gently down onto the blade, ensuring the locating feet are firmly seated against the circumference of the cutter block and the blade is against the setting recess, see fig 61-62.
7. Holding the blade and setting tool (L) in position, tighten two cap head screws to provide a firm clamp on the blade. Keeping the setting tool held firmly in place tighten the remaining cap head screws, see fig 63-64.



**DO NOT OVERTIGHTEN TO AVOID THE CAP HEAD SCREWS ENDS FROM GETTING DAMAGED!**

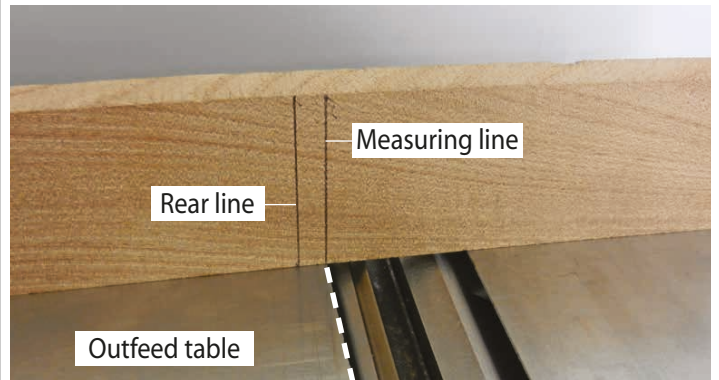
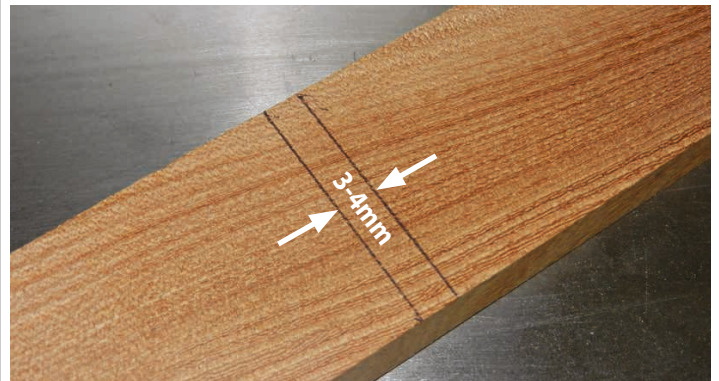
**Fig 61-62-63-64**



**8.** Repeat the procedure for the other two blades. When all the blades are set at the correct height, carry out a quick check by rotating the cutter block in reverse and visually inspecting the edge of the blade against a fixed point.

**9.** If this appears satisfactory, go round and check everything is tight and lower the surface tables and re-lock them in place. Replace the fence assembly and continue with the operation.

**Fig 65-66**

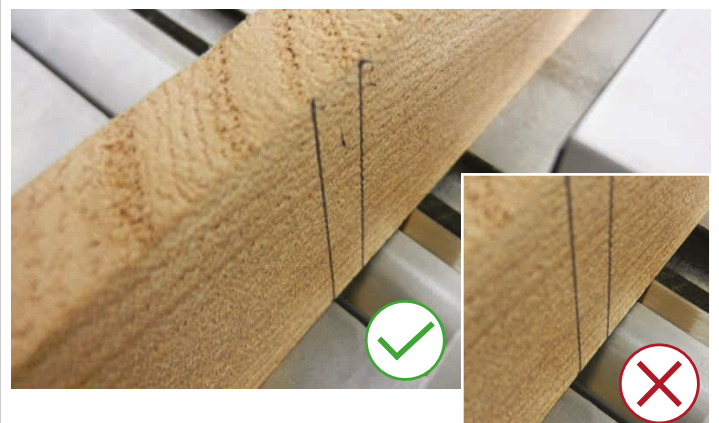


**NOTE:** You can also check that the blades are set at the correct height along the length of the cutter block by the following method below.

- Find a scrap piece of timber and draw two measuring lines approximately 3-4mm apart, see fig 65.
- Place the timber to one side of the cutter block across the tables and line up right measuring line to the edge of the outfeed surface table, see fig 66.
- Rotate the cutter block so the blade tip pulls the timber forward, stop when the blade detaches itself from the timber.
- The rear line should now line up with the outfeed table's edge, see fig 67.
- Repeat for the opposite side.

**NOTE:** If there is any deviation along the length of the cutter block, adjust the blade until correct.

**Fig 67**

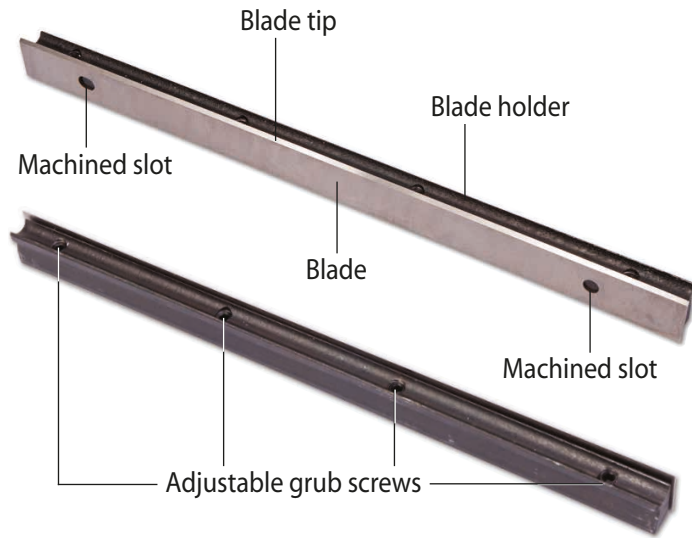


# Changing the Cutter Block Blades

## Self Adjustable Blade Holder Kit

The planer thicknesser comes with three adjustable blade holders with disposable blades. The blade is doubled edged to allow it to be reversed to extend its life span. The blade holder has four independent adjustable grub screws which raises and lowers the blade at a preset height. This makes it easier when fitting a new blade as the blade holder is already preset to previous blade. Follow the instructions below to install the self adjustable blade holders.

**Fig 68**

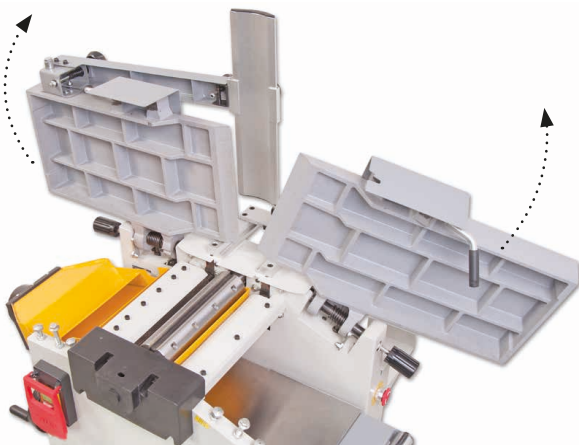


**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY BEFORE CONTINUING!**

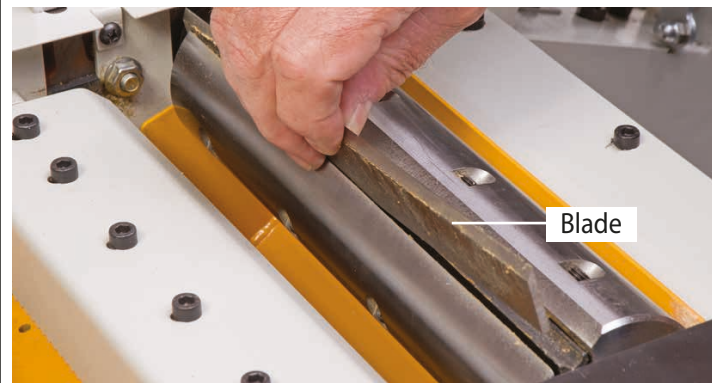
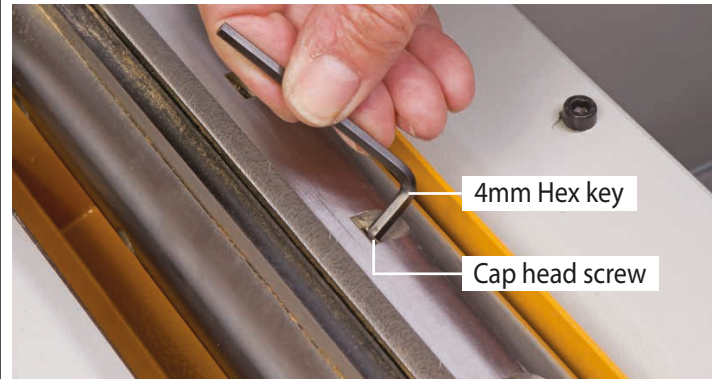
**1.** Raise the two tables into the upright positions to gain access to the cutter block assembly, see fig 69.

**2.** Turn the cutter block until one of the slots is in the upright position. Using a 4mm Hex key loosen the four cap head screws on the cutter block, thus removing the clamping effect. This should allow the blade to 'spring' up, protruding clear of the edge of the cutter block, see fig 70.

**Fig 69**



**Fig 70-71**



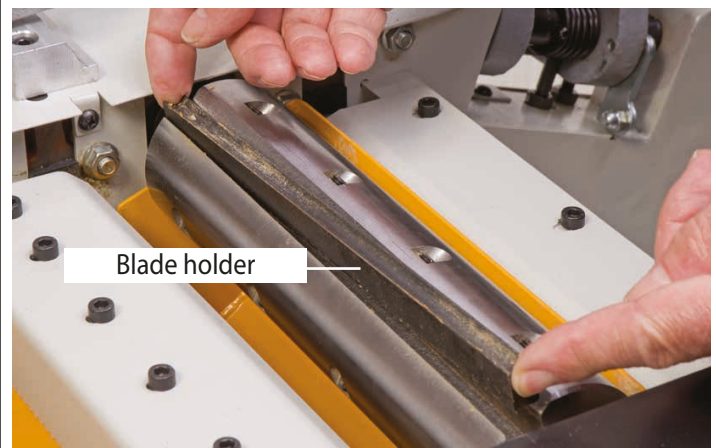
**3.** Carefully remove the blade and place safely aside, see fig 71.



**WARNING! BE VERY CAREFUL WHEN REMOVING THE STANDARD BLADES AS THEY ARE EXTREMELY SHARP.**

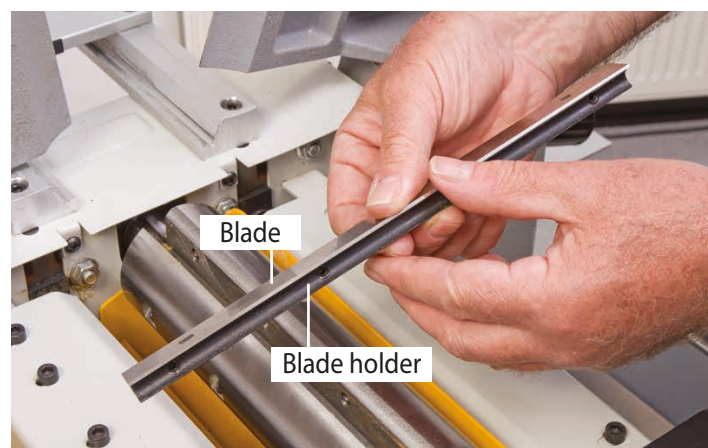
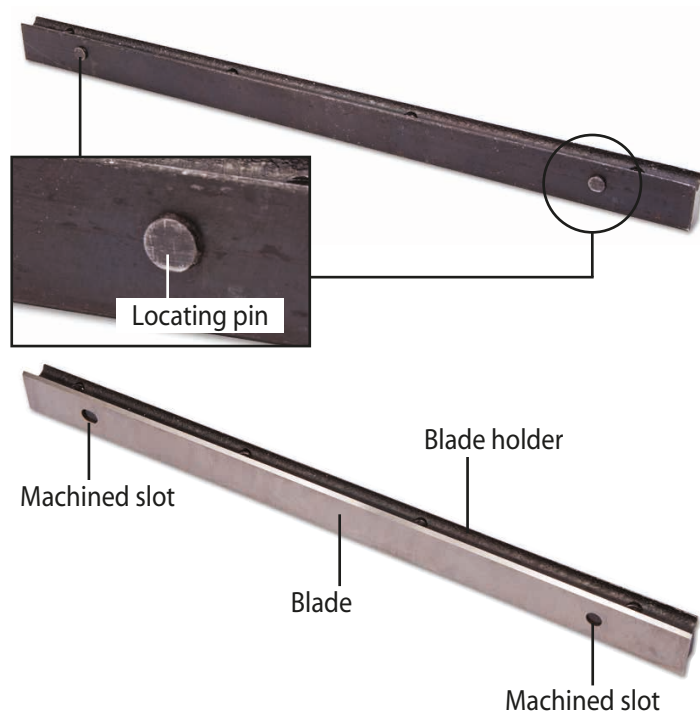
**4.** Remove the standard blade holder and lay aside, see fig 72. Clean the slot housing thoroughly, remove any resin build-up, sawdust, chips etc. Clean the holder and ensure the circumference of the cutter block is cleaned thoroughly.

**Fig 72**



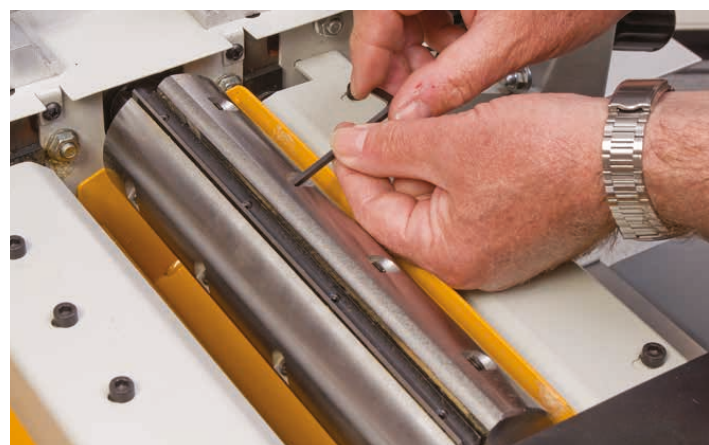
**5.** Locate one of the self adjustable blade holders and disposable blade. Insert the machined slots in the blade down over the locating pins on the blade holder until they lock in place, see fig 73-74-75.

**Fig 73-74-75**



**6.** Introduce the blade holder, position it against the back of the slot. Carefully position the holder to line up with the edge of the cutter block and finger tighten the four cap head screws to lightly secure the holder in position, see fig 76.

**Fig 76**



**7.** Press the blade setting tool (L) gently down onto the blade, ensuring the locating feet are firmly seated against the circumference of the cutter block and the blade is against the setting recess.

**8.** Holding the blade and setting tool (L) in position, adjust the four grub screws until the blade is set at the correct height, see fig 77-78.

**9.** Securely tighten the four cap head screws in the cutter block to provide a firm clamp on the blade holder assembly, see fig 79.

**Fig 77-78-79**



**NOTE:** When it's time to replace the blade there is no need to adjust the blade once fitted as the blade holder is already preset.

**10.** Repeat the procedure for the other two blade holders. When all the blades are set at the correct height, carry out a quick check by rotating the cutter block in reverse and visually inspecting the edge of the blade against a fixed point.

# Changing the Cutter Block Blades

11. If this appears satisfactory, go round and check everything is tight. Lower the tables and re-lock them in place, refit the fence assembly, 80-81-82-83.

12. Connect the machine to the main supply and continue with the operation.

Fig 80-81-82-83



1) Push locking handle in



2) Turn the handle to lock the table

## Spiral Cutter Blocks



**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY BEFORE CONTINUING!**

The spiral cutter block has four rows of square cutters running around its circumference. There is 44 square cutters in total on the 10inch model and 56 cutters on the 12inch model. There is a blade machined to each side of the square cutter allowing the cutter to be rotated to a clean sharp edge if one side has been damaged or has become blunt, see fig 84-85.

The square cutter has an embossed position marker to one of its four corners, once this mark has gone round one full rotation it is time to replace the square cutter.

To rotate the cutter, loosen the Torx head screw and rotate until the new edge is in alignment with the other cutters. Re-tighten the Torx head screw to lock the cutter in place.

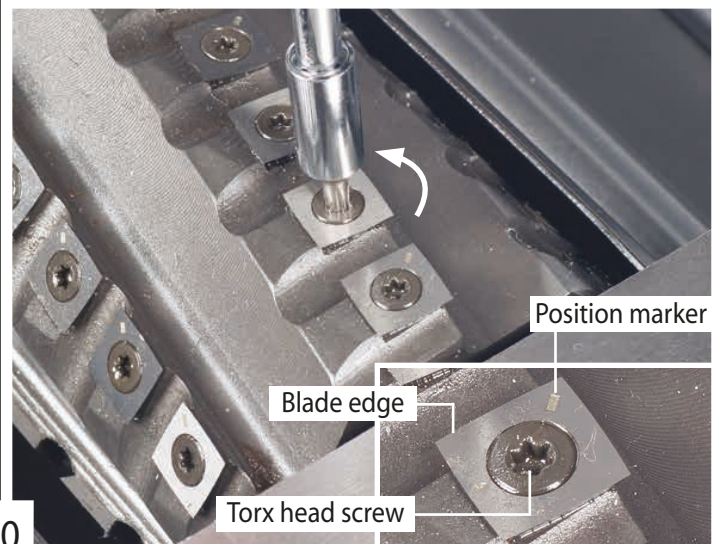
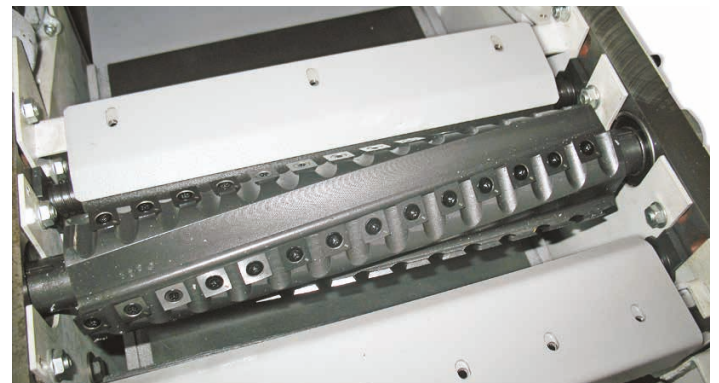


**WARNING! BE VERY CAREFUL WHEN TURNING THE CUTTERS AS THE BLADES ARE EXTREMELY SHARP.**



**DO NOT OVERTIGHTEN TO AVOID THE TORX HEAD SCREW HEAD FROM GETTING DAMAGED!**

Fig 84-85





**DISCONNECT THE MACHINE FROM THE MAINS SUPPLY BEFORE CONTINUING!**

## Daily

Check the overhand tables and the thickening table are clean, not coated with resin etc. Apply a proprietary cleaner/lubricating agent such as 'Liberon Wax & Polish Remover' (1) and 'Liberon Lubricating Wax' (2).

Check the cable and the plug for damage or defects. Mount the planer fence and check it is set upright.

Check the dust extraction hood and ensure there are no excessive build ups of sawdust/resin, especially in the mouth of the chip deflector and around the mouth of the extractor.

Check the blades for sharpness and damage.

Check the rollers of the thickening table rotate freely, and there is no build up between the roller and the extension table.



## Weekly

Carry out the 'Daily' checks.

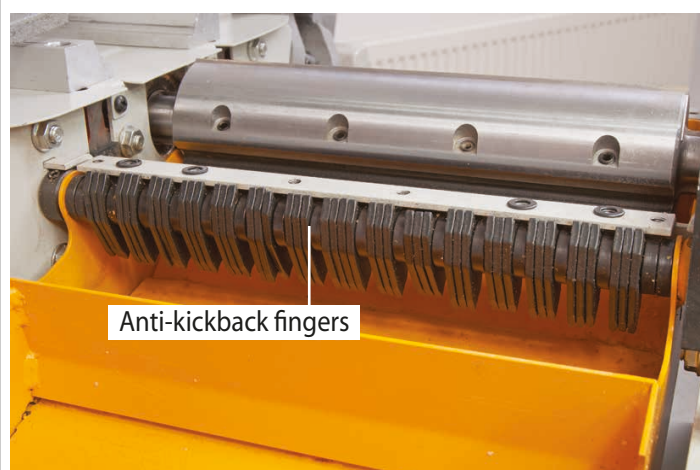
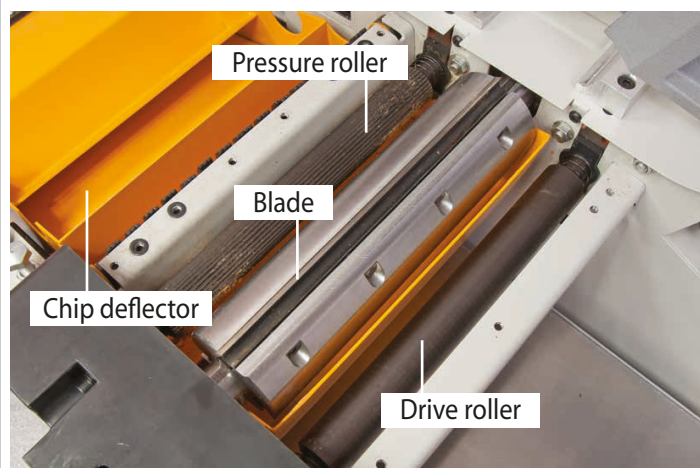
Clean the machine thoroughly, remove any shavings, sawdust, chips etc, from in, under and around the machine.

Check the cutter block for resin build up, especially behind the blade and in the scallop of the blade holder.

Raise the tables and brush out and clean any debris or build up around the area of the noise attenuating slots in the edges of the overhand tables.

Check the infeed and take off pressure rollers are not clogged, clean as necessary.

Check the action of the anti-kickback fingers, again clean and lubricate as required.



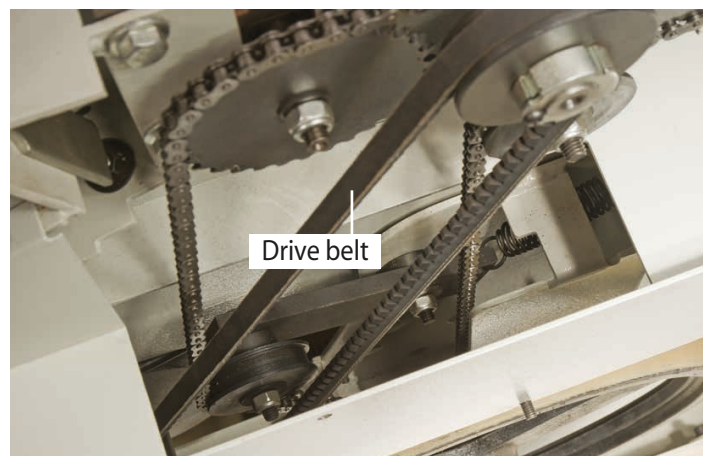
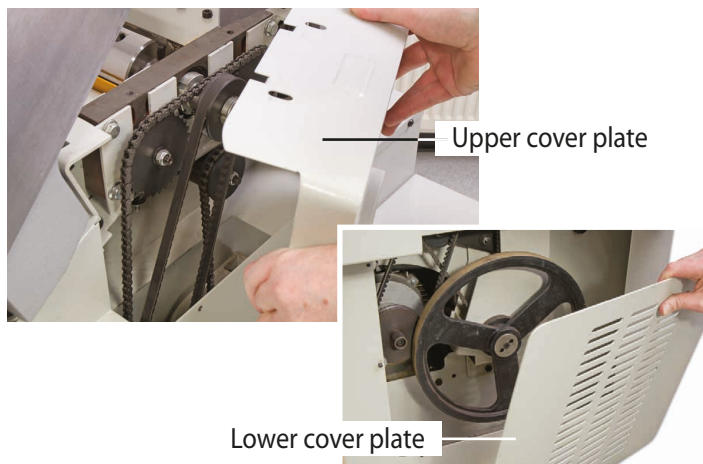
## Monthly

Carry out the 'Weekly' checks.

Remove the upper and lower machine cover plates, check the condition and tension of the drive belt.

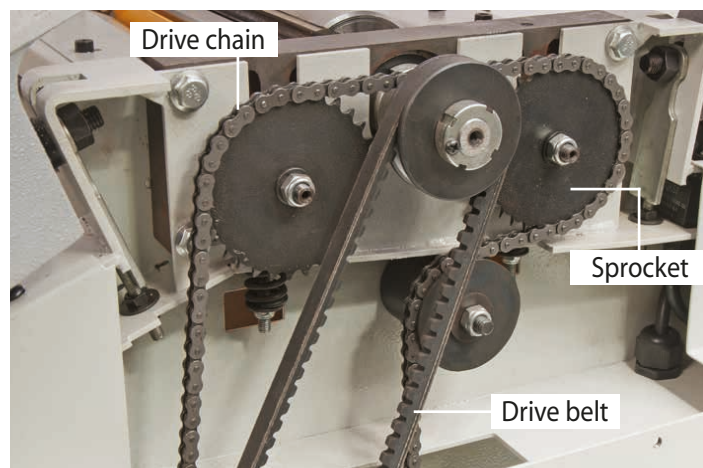
Check the autofeed engage and disengage function.

## Maintenance



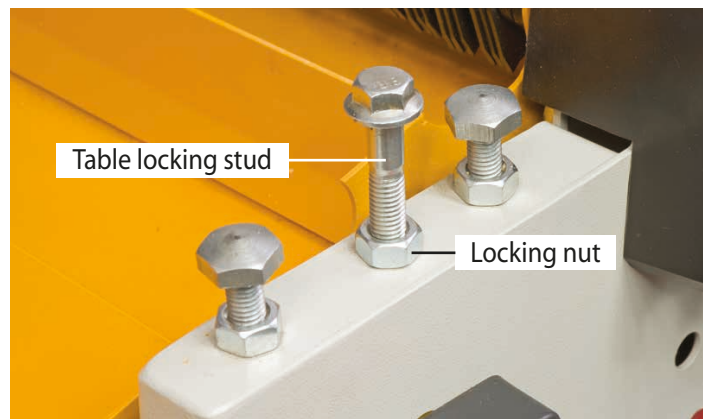
Check the condition of the drive chains, clean and apply a light coating of oil to the chains and sprockets.

Using 'Ambersil Dry PTFE Film Antistick' spray, (3) lubricate all the bearing areas, taking care not to get oil on the drive belt and tyre surfaces. Replace both machine covers plate.



Re-tightening table lock down handles.

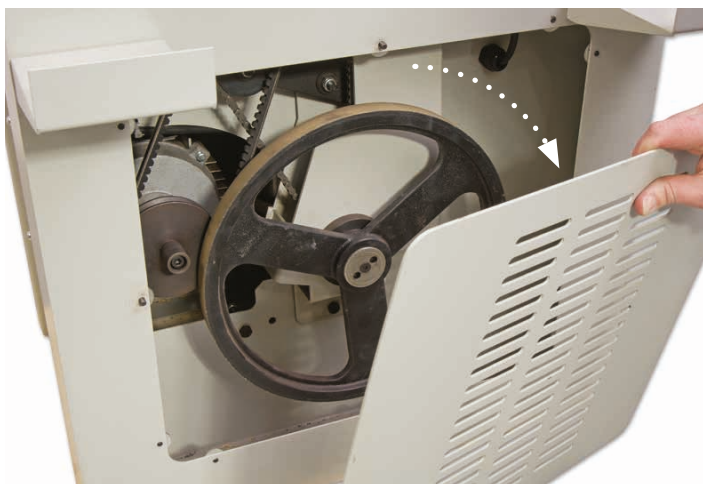
If the table lock downs becomes 'slack' they can be adjusted by altering the height of the table lock stud. Hold the stud firmly and loosen the lock nut, adjust the stud, lightly 'pinch' with the lock nut, try.



### Drive Belt Tension

Remove the upper and lower machine cover plates and check the tension of the drive belt. If there considerable movement in the drive belt, loosen the four domed nuts securing the motor and let the motor slide down to find its own level then re-tighten the domed nuts to secure the motor in position.

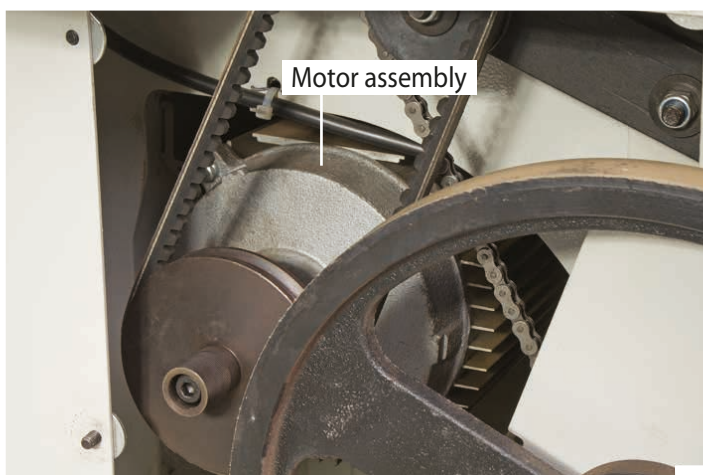
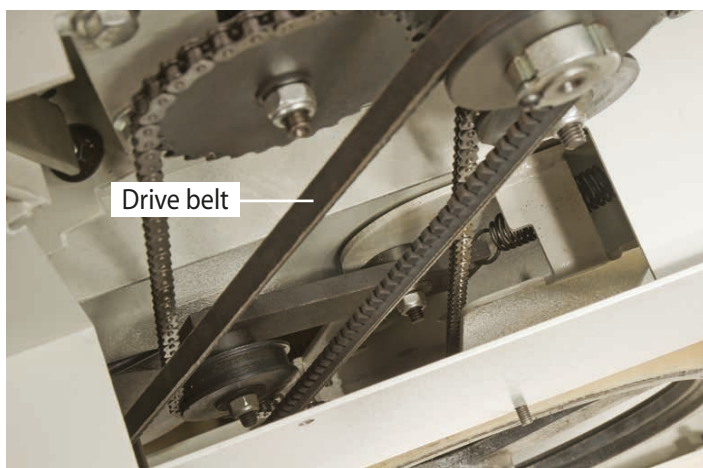
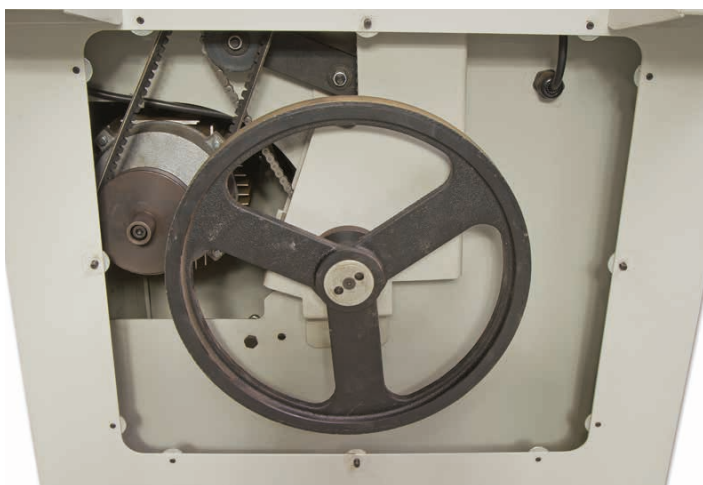




Motor securing domed nuts/washers

Once adjustments have been completed, replace the upper and lower cover plates, lower the infeed and outfeed surface tables and lock them in place with the table locking handles.

Replace the fence assembly.



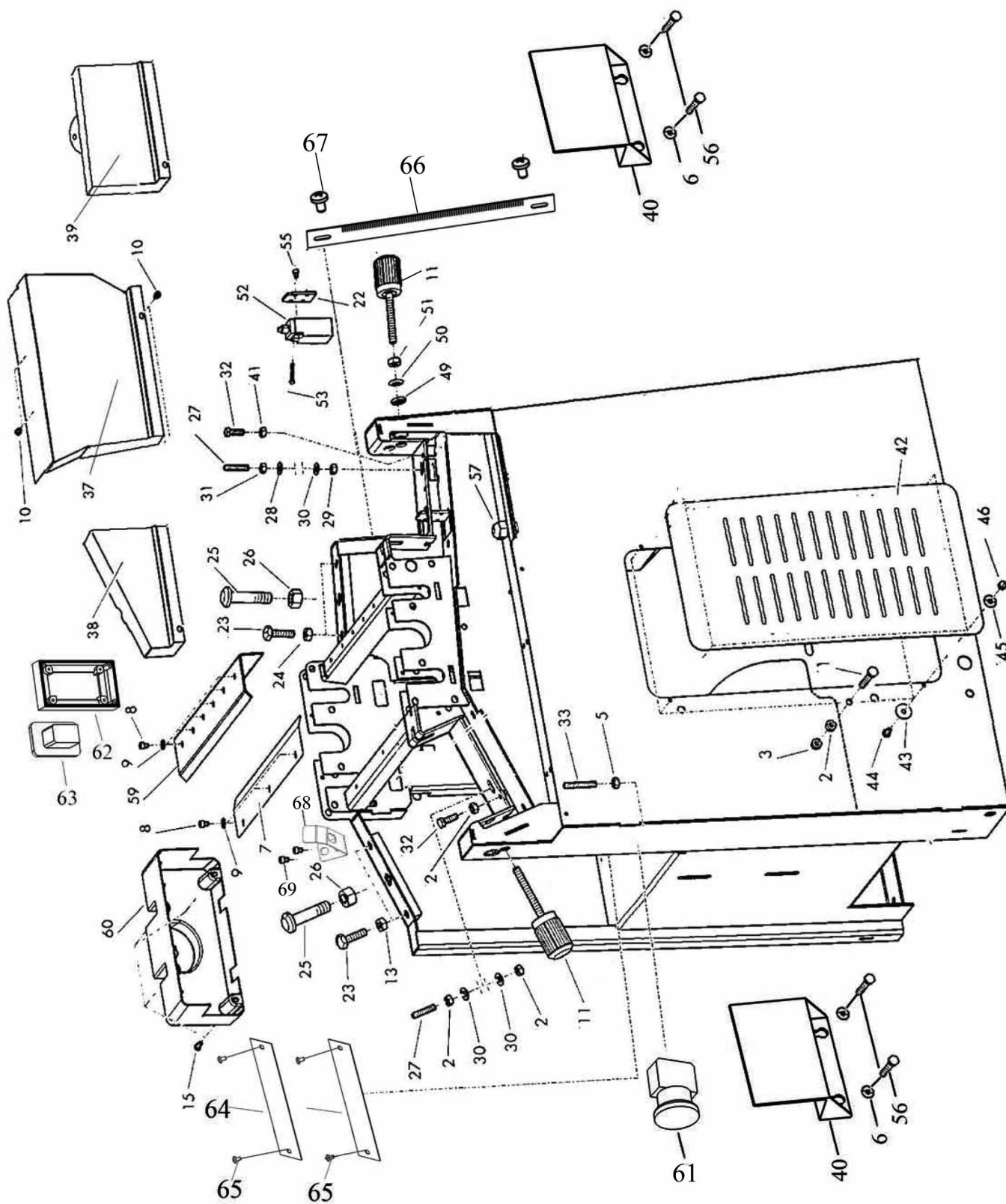
**CONNECT THE MACHINE TO THE MAINS SUPPLY!**

Continue with operation.

# Exploded Diagrams/Lists

AT260PT / AT260SPT Planer Thicknesser

DIAGRAM A

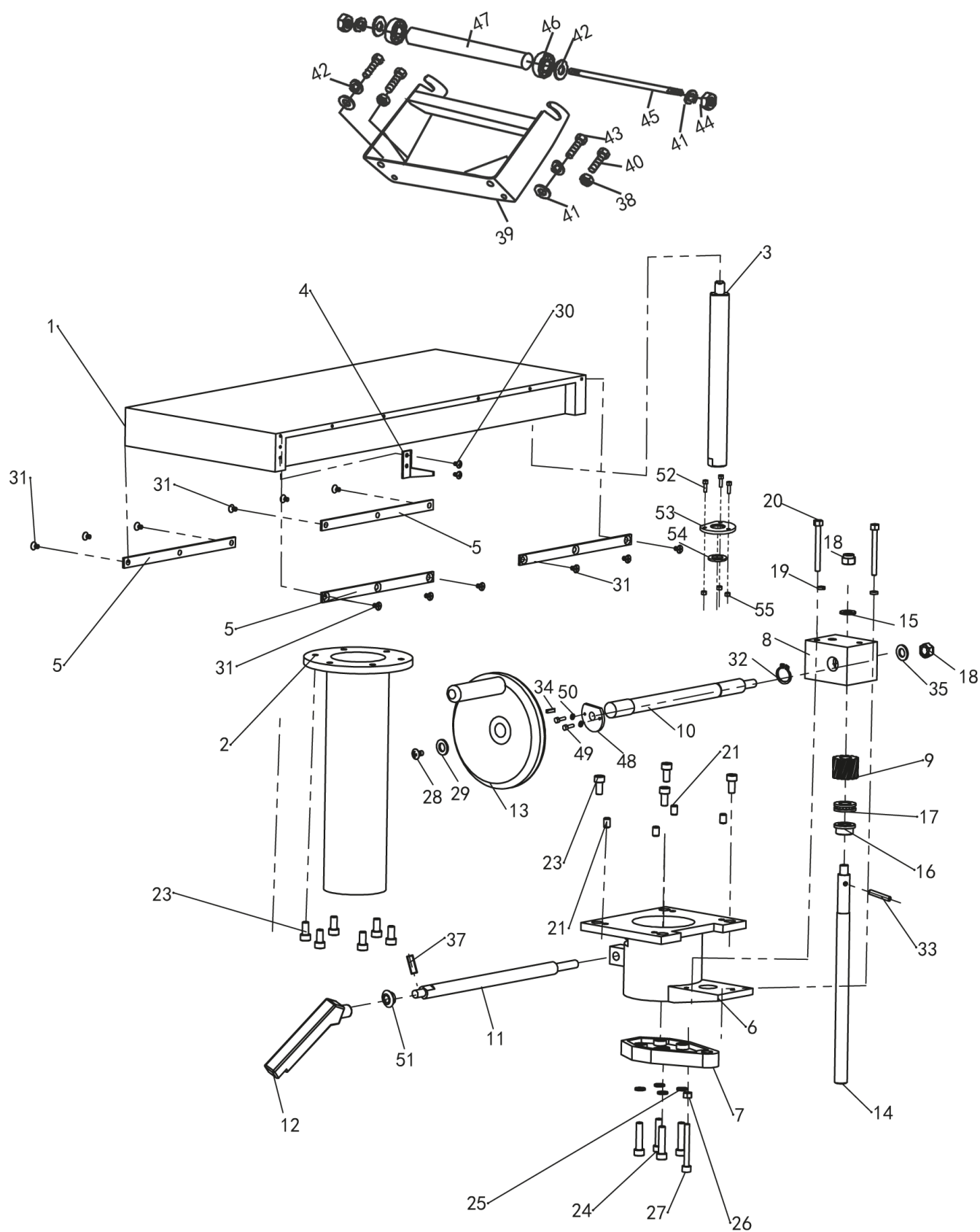


## Parts List of Diagram A

NO.	DESCRIPTION
A-1	Screw hex head M8x45
A-2	Nut hex M8
A-3	Nut hex,lock M8
A-5	Nut hex M8
A-6	Flat washer 8mm
A-7	Cover plate,feed rolled
A-8	Allen screw M6x10
A-9	Spring washer 6mm
A-10	Pan head screw M6x10
A-11	Adjust handle planer table
A-23	Stop screw,table
A-24	Nut hex M10
A-25	Lock bolt M10x40 table
A-26	Hex nut M10
A-27	Set screw M8x40
A-28	Washer 8mm
A-29	Nut hex M8
A-30	Washer 8mm
A-31	Nut hex M8
A-32	Screw hex head M8x25
A-33	Set screw M8x50
A-37	Guard,belt
A-38	Guard belt,left
A-39	Guard belt,right
A-40	Fence bracket
A-41	Nut hex M8
A-42	Cover plate,friction wheel
A-43	Flat washer 6mm
A-44	Screw hex head M6x12
A-45	Flat washer 6mm
A-46	Cap nut M7
A-49	Wave washer
A-50	Wave washer
A-51	Nut hex M10
A-52	Limit switch
A-54	Pan head screw M4x30
A-55	Allen screw M5x10
A-56	Pan head screw M8x12
A-58	Transport retainer
A-59	Guard cover,feed roller
A-60	Gear cover feed roller
A-61	Emergency stop
A-62	Bottom,switch box
A-63	NVR switch
A-64	Cover plate
A-65	Pan head screw M5x8
A-66	Scale,thicknessing height
A-67	Pan head screw M4x8
A-68	Stop spring plate
A-69	Pan head screw M5x8

## AT260PT / AT260SPT Planer Thicknesser

DIAGRAM B



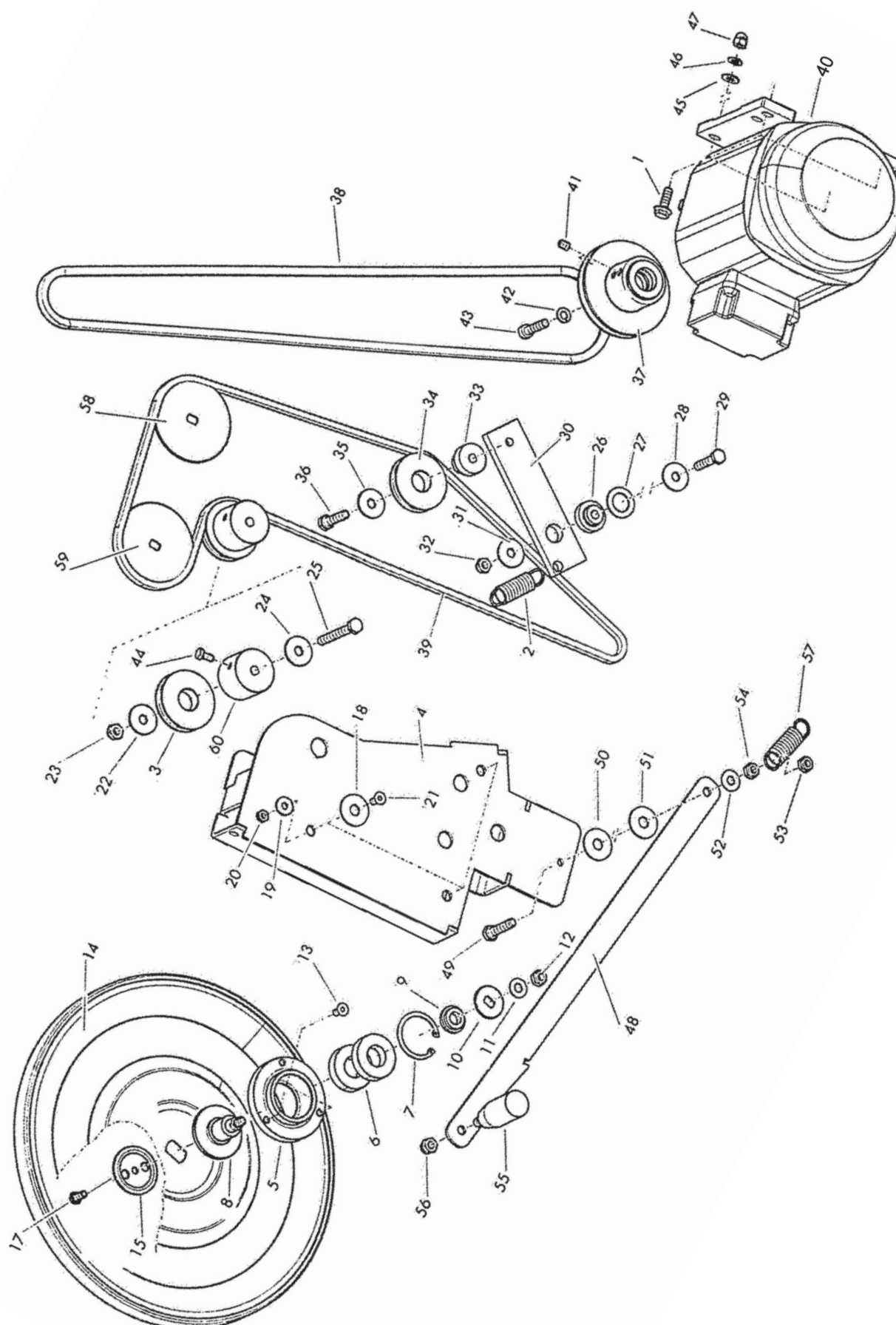
## Parts List of Diagram B

NO.	DESCRIPTION		
B-1	Thicknessing table	B-29	Washer 6mm
B-2	Raise guide rail	B-30	Pan head screw M4x10
B-3	Special guide	B-31	Cross sunk head screw M4x8
B-4	Height indicator	B-32	Circle ring 18mm
B-5	Edge-plate	B-33	Roll pin 5x10
B-6	Fixed guide rail	B-34	Collar
B-7	Screw guide	B-35	Set screw M8x8
B-8	Raise gear seat	B-37	Roll pin 2.5x12
B-9	Raise and fall gear	B-38	Hex nut M8
B-10	Raise and fall shaft	B-39	Support roller
B-11	Clamp rod	B-40	Hex head bolt M8x25
B-12	Clamp lever	B-41	Flat washer 8mm
B-13	Rise and fall handle	B-42	Spring washer 8mm
B-14	Raise guide rod	B-43	Pan head screw M8x25
B-15	Spacer	B-44	Hex nut M10
B-16	Spacer	B-45	Threaded rod
B-17	Thrust bearing 51102	B-46	Bearing 6202
B-18	Hex lock nut M10	B-47	Roller
B-19	Spring washer 6mm	B-48	Shaft seat,thicknessing table
B-20	Hex head screw M6x60	B-49	Hex bolt M6x16
B-21	Set screw M8x12	B-50	Flat washer 6mm
B-23	Allen screw M8x16	B-51	Seat,lock lever
B-24	Allen screw M8x35	B-52	Hex bolt M6x40
B-25	Spring washer 8mm	B-53	Locking seat,bearing
B-27	Allen screw M6x55	B-54	Oil seal
B-28	Carriage bolt M6x40	B-55	Self-lock nut M6

# Exploded Diagrams/Lists

AT260PT / AT260SPT Planer Thicknesser

DIAGRAM C

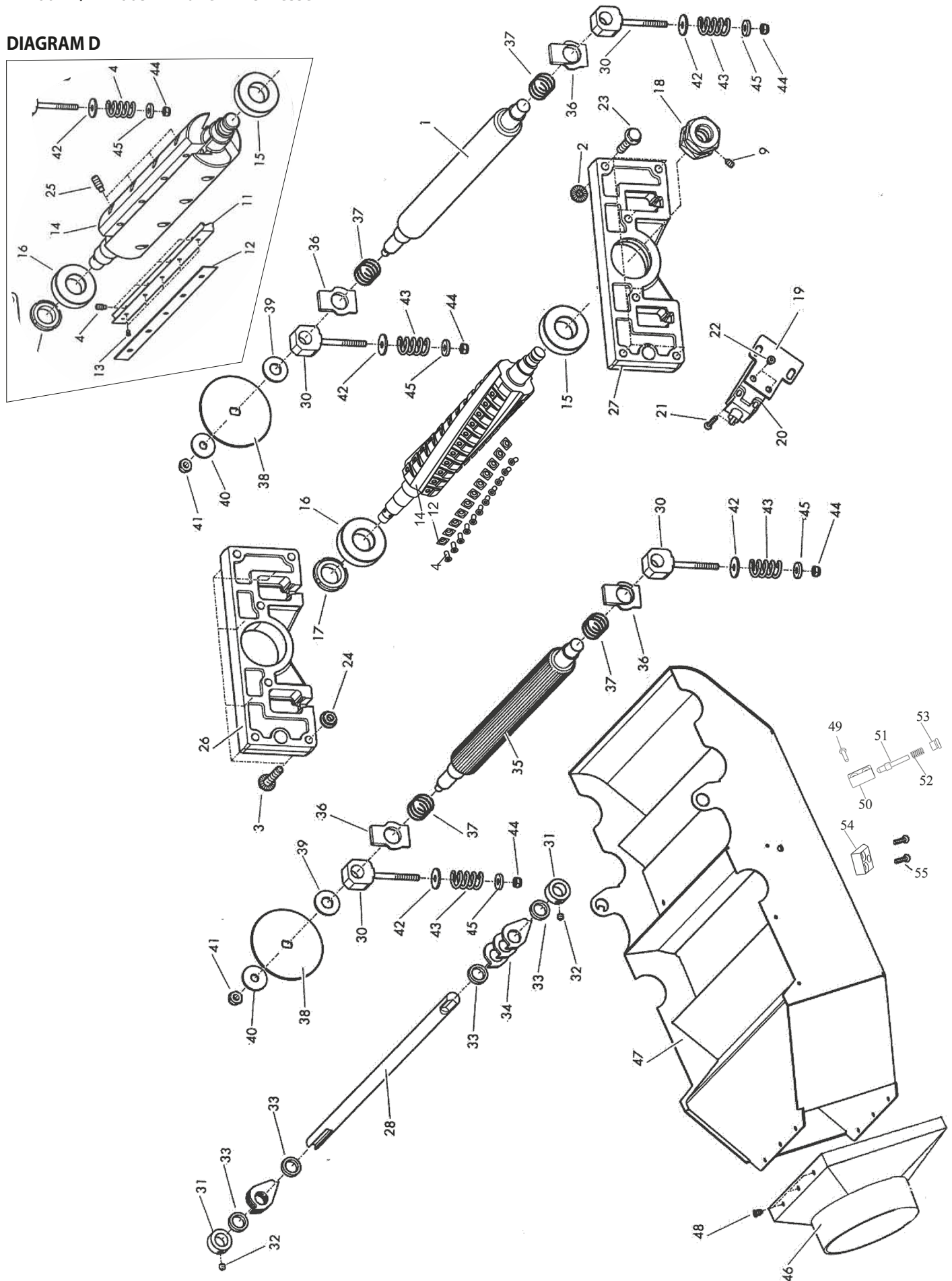


## Parts List of Diagram C

NO.	DESCRIPTION	C-31	Flat washer 8mm
C-1	Screw hex w/flange M8x25	C-32	Lock nut M8
C-2	Pull spring	C-33	Spacer
C-3	Tension pulley	C-34	Tension pulley
C-4	Guide friction pulley	C-35	Flat washer 8mm
C-5	Spacer lock	C-36	Hex head screw M8x45
C-6	Ball bearing 6004-2Z	C-37	Motor pulley
C-7	Circle ring 42mm	C-38	Drive belt XPZ 1250
C-8	Shaft friction pulley	C-39	Drive chain 05B-1-172
C-9	Spacer,friction pulley	C-40	Motor
C-10	Sprocket B	C-41	Set screw M8x10
C-11	Flat washer 8mm	C-42	Spring washer 6mm
C-12	Lock nut M8	C-43	Allen screw M8x40
C-13	Sunk head screw M6x16	C-44	Hex head screw M6x16
C-14	Friction Pulley	C-45	Special washer 8mm
C-15	Ring	C-46	Spring washer 6mm
C-17	Screw hex head M6x12	C-47	Cap nut M8
C-18	Nylon ring	C-48	Lever,friction pulley
C-19	Washer 6mm	C-49	Hex head screw M8x45
C-20	Lock nut M6	C-50	Plastic washer
C-21	Sunk head screw M6x16	C-51	Plastic washer
C-22	Flat washer 8mm	C-52	Flat washer 8mm
C-23	Lock nut M8	C-53	Lock nut M8
C-24	Flat washer 8mm	C-54	Lock nut M8
C-25	Screw hex head M8x70	C-55	Lever handle
C-26	Collar	C-56	Cap nut M8
C-27	Plastic washer	C-57	Pull spring
C-28	Flat washer 8mm	C-58	Sprocket A
C-29	Hex head screw M8x45	C-59	Sprocket A
C-30	Tension plate	C-60	Shaft tension pulley

## AT260PT / AT260SPT Planer Thicknesser

DIAGRAM D



## Parts List of Diagram D

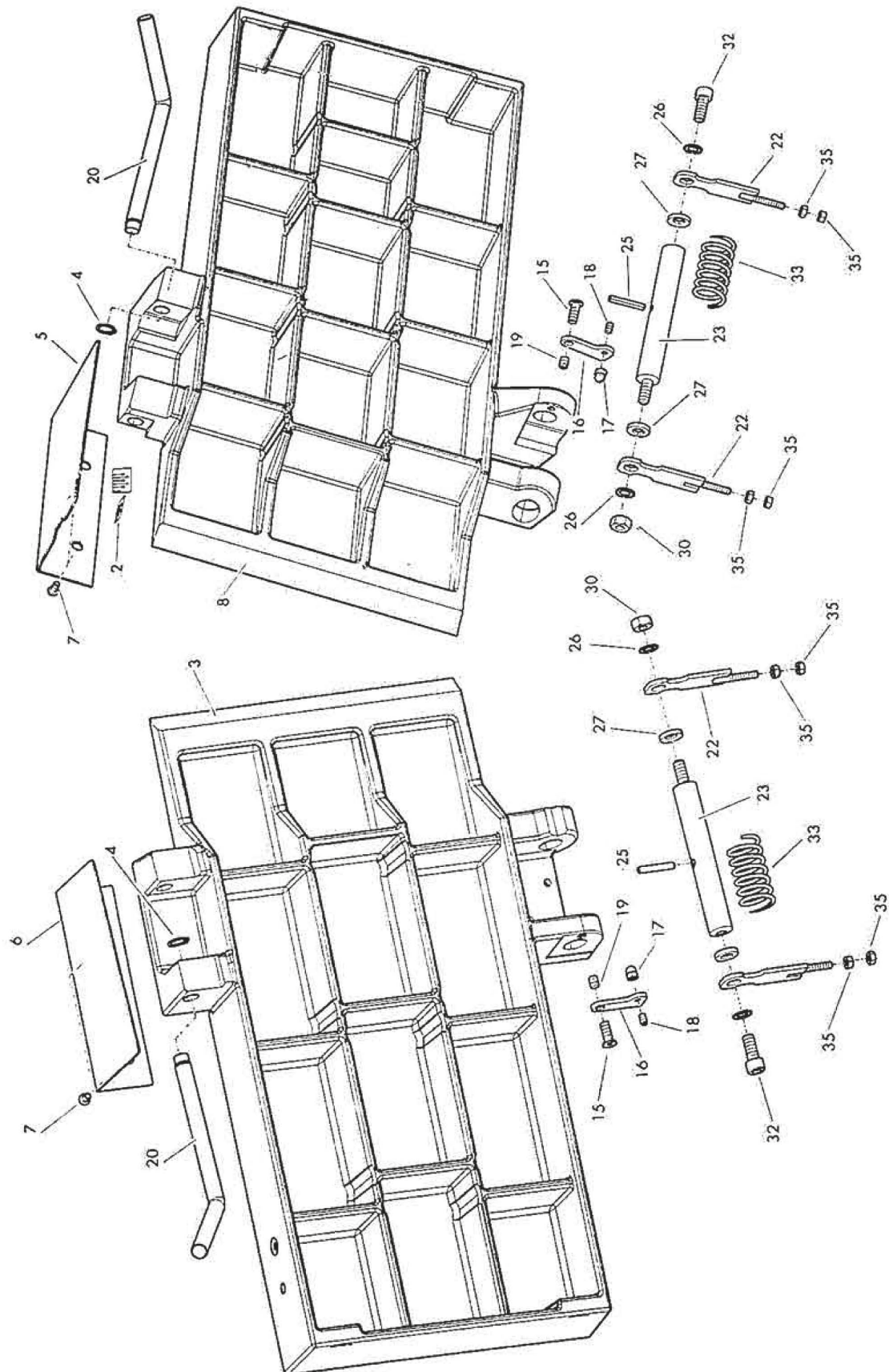
NO.	DESCRIPTION		
D-1	Outfeed roller	D-32	Set screw M6x6
D-2	Nut hex w/flange M8	D-33	Spacer
D-3	Screw hex w/flange M8x40	D-34	Recoil lock
D-4	Set screw M6x12 (Set Screw M5x12 Spiral Block)	D-35	Infeed roller
D-9	Set screw M6x10	D-36	Square spacer
D-11	Blade holder	D-37	Pressure spring
D-12	Cutter Blade	D-38	Sprocket A
D-14	Cutter block	D-39	Spacer sprocket
D-15	Deep groove bearing 6205-P5-2Z	D-40	Flat washer 8mm
D-16	Deep groove bearing 6205-P5-2Z	D-41	Lock nut M8
D-17	Lock nut for block	D-42	Flat washer 6mm
D-18	Spindle special Hex nut	D-43	Pressure spring for rollers
D-19	Mount,limit switch	D-44	Lock nut M6
D-20	Limit switch	D-45	Flat washer 6mm
D-21	Sunk head screw M4x35	D-46	Dust port
D-22	Nut hex M4	D-47	Combined vacuum hood
D-23	Screw hex w/flange M8x40	D-48	Rivet
D-24	Nut hex w/flange M8	D-49	Pan head screw M4x16
D-25	Set screw for block M8x20	D-50	Seat,locking shaft
D-26	Bearing house,rear	D-51	locking shaft
D-27	Bearing house,front	D-52	Spring
D-28	Shaft,dust hood	D-53	Nut M6
D-30	Glide piece	D-54	Locking plate
D-31	Collar	D-55	Cross sunk head screw M4x12

## Replacement Blades for AT260PT

CODE	SUPPLIER	DESCRIPTION
101566	Axminster Tool Centre	Disposable Blades
101568	Axminster Tool Centre	HSS Resharpenable Blades
101570	Axminster Tool Centre	TCT Resharpenable Blades

## AT260PT / AT260SPT Planer Thicknesser

DIAGRAM E



## Parts List of Diagram E

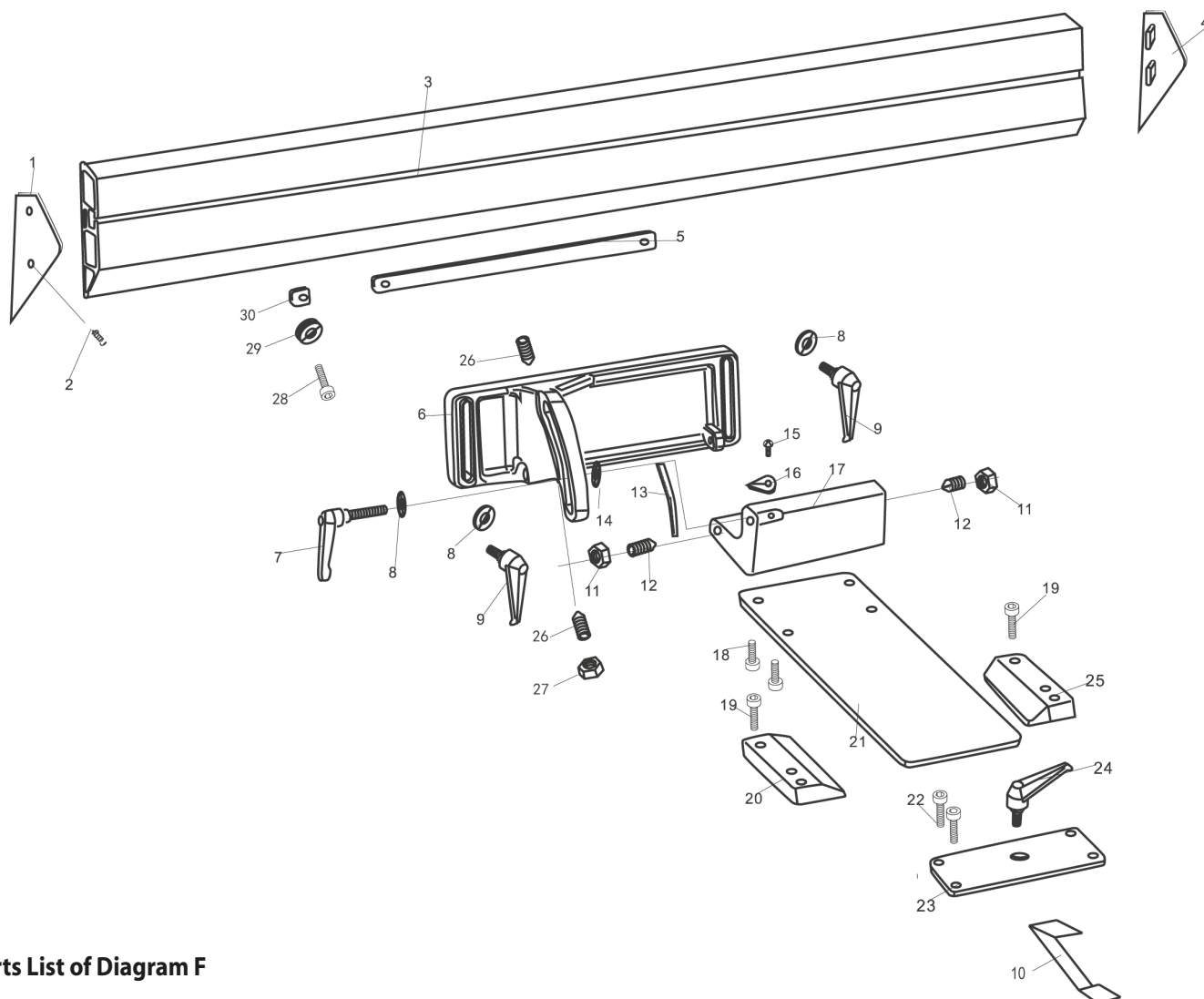
NO.	DESCRIPTION
<b>E-2</b>	Indicator scale
<b>E-3</b>	Out-feed table
<b>E-4</b>	Circle ring 15mm
<b>E-5</b>	Guard,in-feed table
<b>E-6</b>	Guard,out-feed table
<b>E-7</b>	Pan head screw M6x12
<b>E-8</b>	In-feed table planer
<b>E-15</b>	Screw
<b>E-16</b>	Bracket
<b>E-17</b>	Cap nut M6
<b>E-18</b>	Set screw M6x10

<b>E-19</b>	Set screw M6x6
<b>E-20</b>	Clamping lever
<b>E-22</b>	Slide piece from table
<b>E-23</b>	In-Out feed table shaft
<b>E-25</b>	Roll pin 6x35
<b>E-26</b>	External lock washer 10mm
<b>E-27</b>	Wave washer
<b>E-30</b>	Nut hex M10
<b>E-32</b>	Allen screw M10x35
<b>E-33</b>	Spring
<b>E-35</b>	Nut hex M6

# Exploded Diagrams/Lists

## AT260PT / AT260SPT Planer Thicknesser

### DIAGRAM F



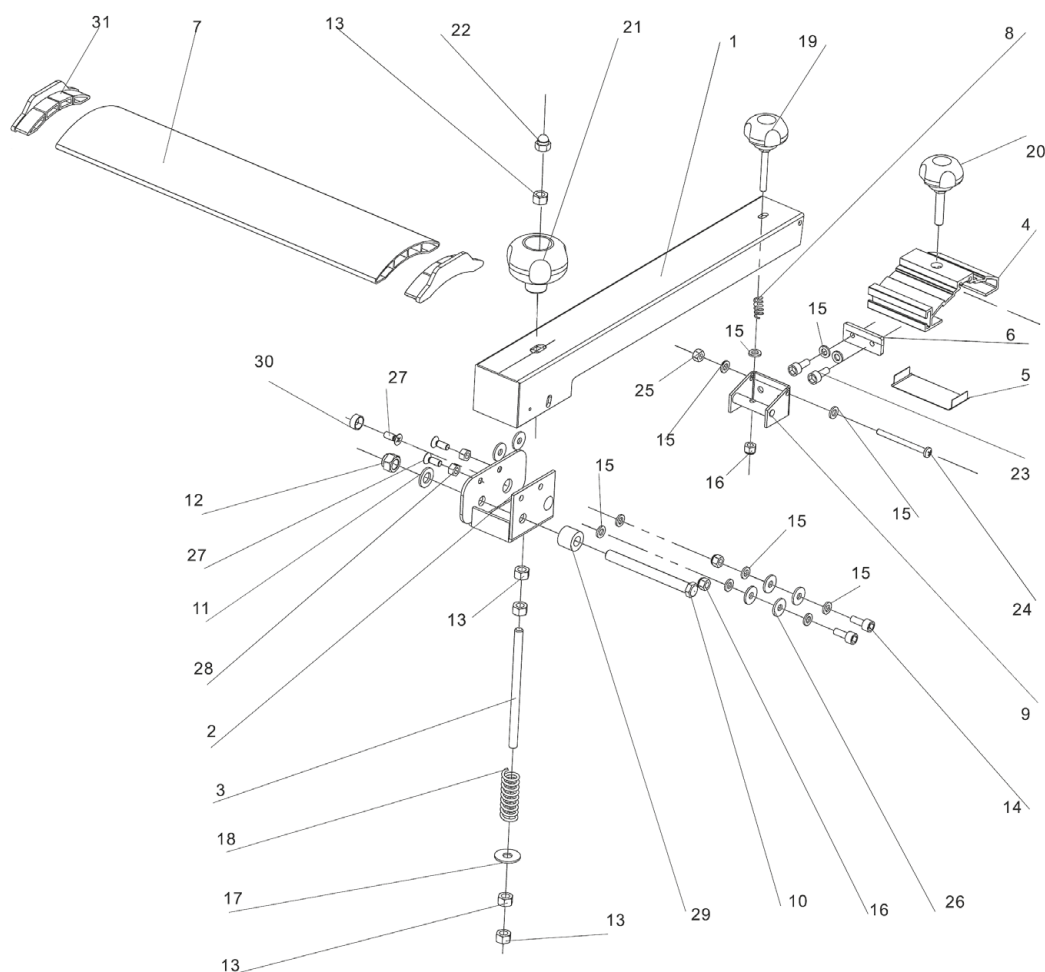
### Parts List of Diagram F

NO.	DESCRIPTION
F-1	Left hand cover for fence
F-2	Pan head screw
F-3	Rip fence
F-4	Right hand cover for fence
F-5	Connection plate
F-6	Fence plate
F-7	Adjusting handle
F-8	Washer
F-9	Adjusting handle
F-10	Insert board for fence
F-11	Nut
F-12	Set screw
F-13	Scale
F-14	Set screw
F-15	Pan head screw

F-16	Pointer
F-17	Fence block
F-18	Allen bolt
F-19	Allen bolt
F-20	Left fixing plate
F-21	Sliding plate
F-22	Allen screw
F-23	Clamping plate
F-24	Adjusting handle
F-25	Right fixing plate
F-26	Locking screw M6x12
F-27	Nut M6
F-28	Cross sunk head screw M6x12
F-29	Stop spacer
F-30	Locking plate

## AT260PT / AT260SPT Planer Thicknesser

DIAGRAM G

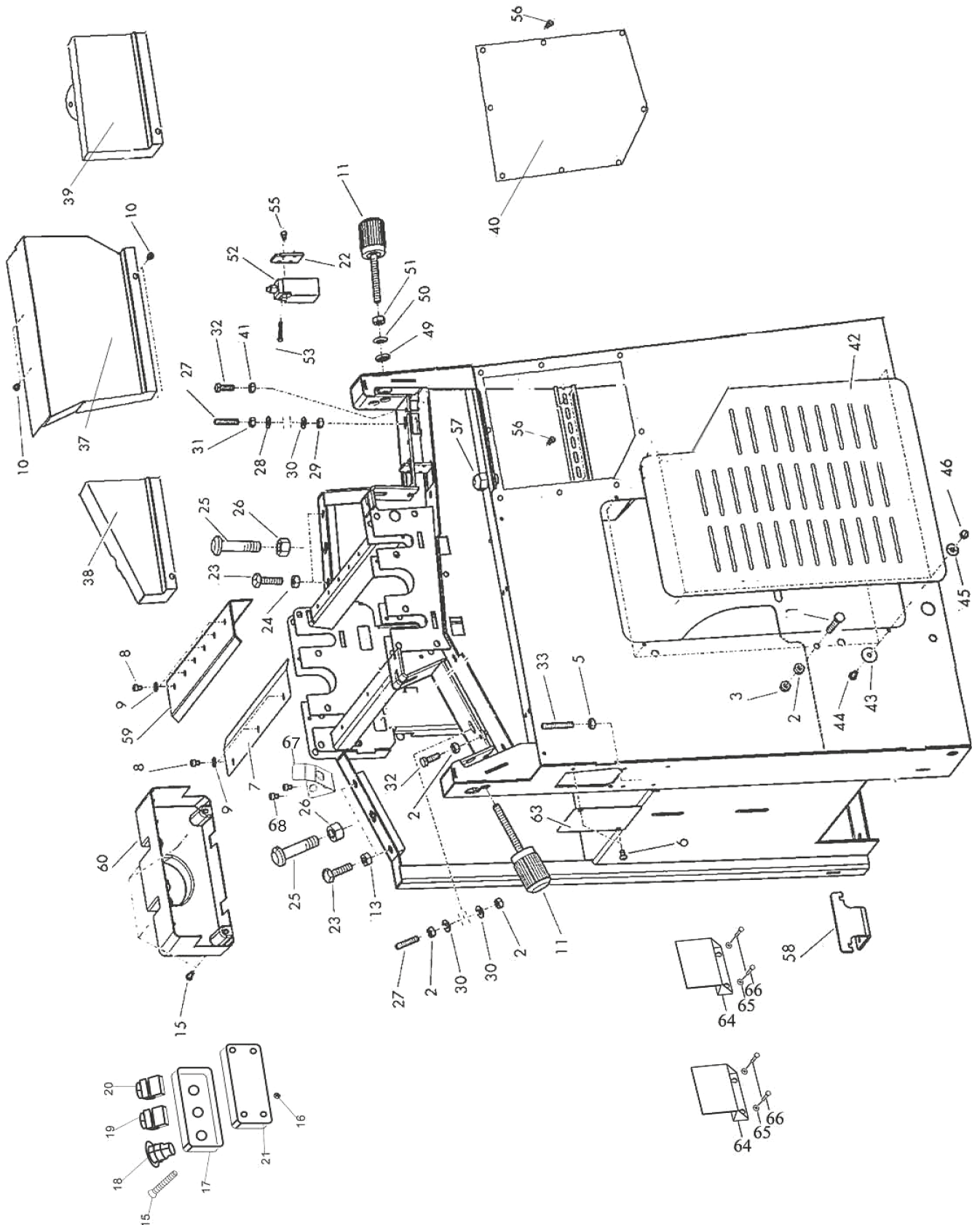


Parts List of Diagram G

NO.	DESCRIPTION		
G-1	Bridge guard arm	G-16	Hex lock nut M6
G-2	Swivel base,guard	G-17	Flat washer 8mm
G-3	Rod,spring	G-18	Spring for guard
G-4	Joint,bridge guard	G-19	Star knob screw M6x35
G-5	Insert for guard	G-20	Star knob screw M8x35
G-6	Bolt guide	G-21	Star knob for guard
G-7	Protective guard plate	G-22	Cap nut M8
G-8	Spring	G-23	Allen screw M6x10
G-9	Knot	G-24	Pan head screw M5x65
G-10	Hex head screw M10x100	G-25	Hex lock nut M6
G-11	Washer 10mm	G-26	Spacer
G-12	Hex lock nut M10	G-27	Cross sunk head screw M6x16
G-13	Hex nut M8	G-28	Hex lock nut M6
G-14	Allen screw M6x20	G-29	Spacer
G-15	Washer 6mm	G-30	Spacer
		G-31	End cap guard

## AT310SPT Planer Thicknesser

### DIAGRAM A



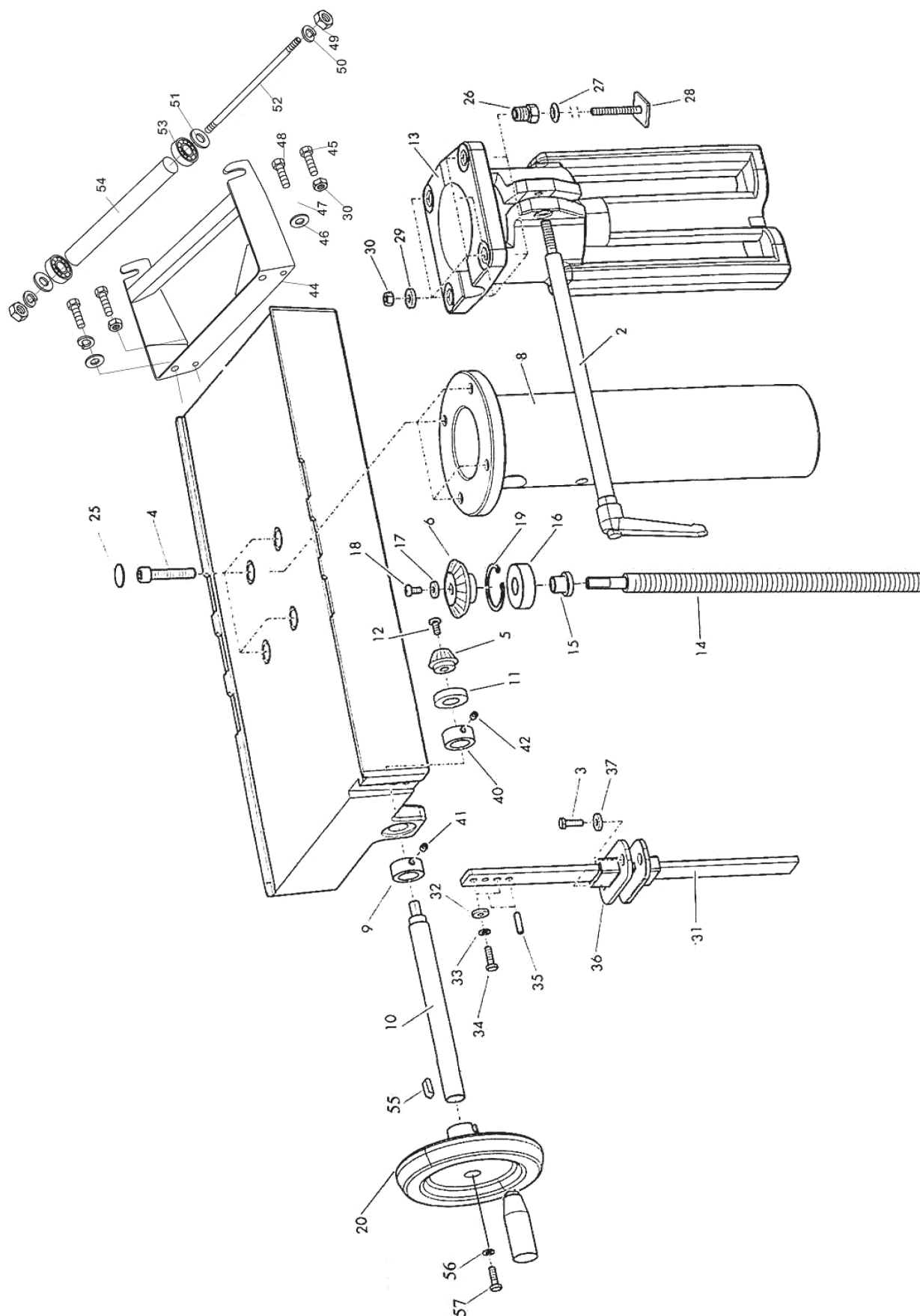
## Parts List of Diagram A

NO.	DESCRIPTION		
A-1	Screw hex head M8x45	A-33	Set screw M8x50
A-2	Nut hex M8	A-37	Guard,belt
A-3	Nut hex,lock M8	A-38	Guard belt,left
A-5	Nut hex M8	A-39	Guard belt,right
A-6	Pan head screw M6x10	A-40	Cover,terminal box
A-7	Cover plate,feed roller	A-41	Nut hex M8
A-8	Allen screw M6x10	A-42	Cover plate,friction wheel
A-9	Spring washer 6mm	A-43	Flat washer 6mm
A-10	Pan head screw M6x10	A-44	Screw hex head M6x12
A-11	Adjust handle, planer table	A-45	Flat washer 6mm
A-15	Pan head screw M6x30	A-46	Cap nut M7
A-16	Nut hex M6	A-49	Wave washer
A-17	Cover plate,control panel	A-50	Wave washer
A-18	Emergency-off button	A-51	Nut hex M10
A-19	Planer-off button	A-52	Limit switch
A-20	Planer-on button	A-54	Pan head screw M4x30
A-21	Control panel	A-55	Allen screw M5x10
A-22	Connection Plate, Micro Switch	A-56	Pan head screw M6x8
A-23	Stip screw,table	A-57	Strain relief
A-24	Nut hex M10	A-58	Transport retainer
A-25	Lock screw,table	A-59	Guard cover,feed roller
A-26	Nut hex M16	A-60	Plastic Gear cover
A-27	Set screw M8x40	A-63	Power Switch
A-28	Washer 8mm	A-64	Fence bracket
A-29	Nut hex M8	A-65	Flat washer
A-30	Washer 8mm	A-66	Pan head screw M8x12
A-31	Nut hex M8	A-67	Stop spring plate
A-32	Screw hex head M8x25	A-68	Pan head screw M5x8

# Exploded Diagrams/Lists

## AT310SPT Planer Thicknesser

### DIAGRAM B

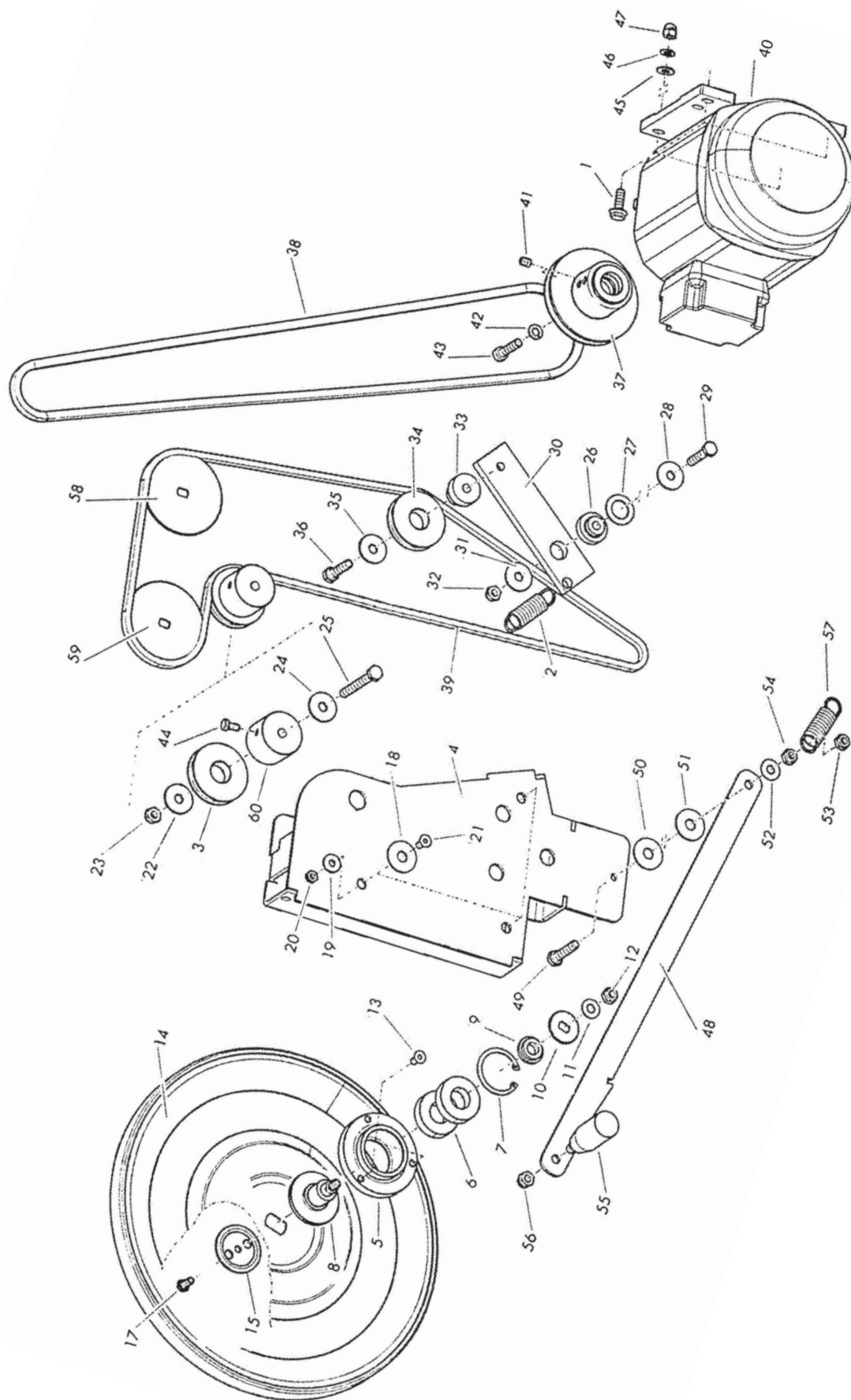


## Parts List of Diagram B

NO.	DESCRIPTION		
B-2	Rise and fall clamp lever	B-30	Nut hex M8
B-3	Screw hex head M6x16	B-31	Scale rule
B-4	Allen screw M10x50	B-32	Washer 6mm
B-5	Cone gear A	B-33	Spring washer 6mm
B-6	Cone gear B	B-34	Screw hex head M6x16
B-8	Raise guide rail	B-35	Roll pin 6x22
B-9	Collar stop	B-36	Scale,body
B-10	Rise and fall shaft	B-37	Flat washer 6mm
B-11	Bearing 6003	B-40	Collar,stop
B-12	Pan head screw M6x12	B-41	Set screw M6x6
B-13	Fixed guide rail	B-42	Set screw M6x6
B-14	Raise and fall guide rod	B-44	Support roller
B-15	Bush for rise and fall guide rod	B-45	Hex head screw M8x25
B-16	Bearing 6303	B-46	Washer 10mm
B-17	Washer 8mm	B-47	Spring washer 10mm
B-18	Pan head screw M6x12	B-48	Hex head screw M10x30
B-19	Ring circle	B-49	Hex nut M10
B-20	Handle-wheel	B-50	Spring washer 10mm
B-25	Insert,table bolt	B-51	Washer 10mm
B-26	Nut adjuste	B-52	Threaded rod
B-27	Wave washer	B-53	Bearing 6202
B-28	Special thread	B-54	Roller
B-29	Thin washer	B-55	Key
		B-56	Flat washer 8mm
		B-57	Hex.bolt M6

## AT310SPT Planer Thicknesser

### DIAGRAM C

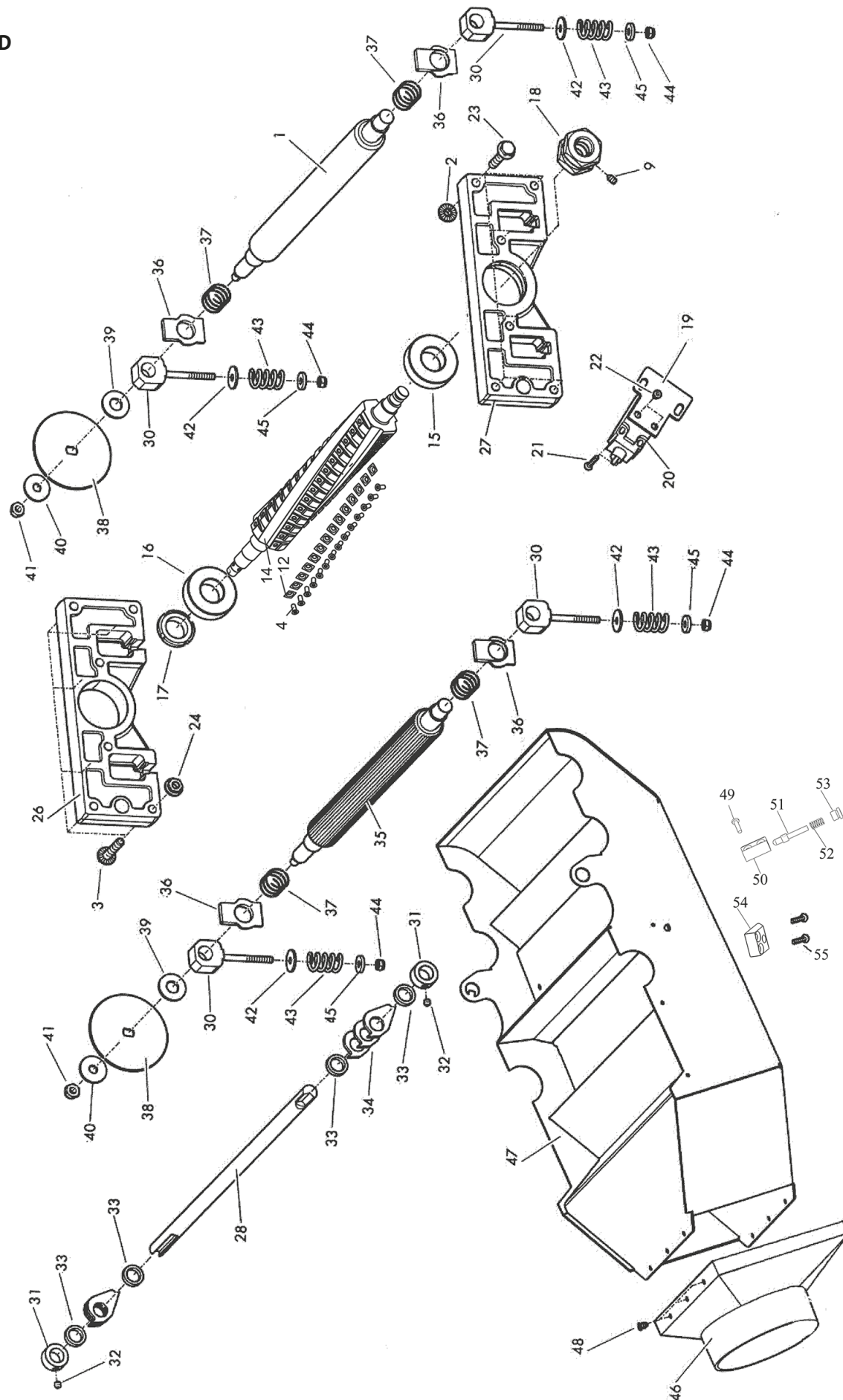


## Parts List of Diagram

NO.	DESCRIPTION		
C-1	Screw hex w/flange M8x25	C-31	Flat washer 8mm
C-2	Pull spring	C-32	Lock nut M8
C-3	Tension pulley	C-33	Spacer
C-4	Guide,friction pulley	C-34	Tension pulley
C-5	Spacer lock	C-35	Flat washer 8mm
C-6	Ball bearing 6004-2Z	C-36	Hex head screw M8x45
C-7	Circle ring 42mm	C-37	Motor pulley
C-8	Shaft friction pulley	C-38	Drive belt XPZ 1340/3Vx530
C-9	Spacer friction pulley	C-39	Drive chain 05B-1-172
C-10	Sprocket B	C-40	Motor
C-11	Flat washer 8mm	C-41	Set screw M8x10
C-12	Lock nut M8	C-42	Spring washer 6mm
C-13	Sunk head screw M6x16	C-43	Allen screw M8x40
C-14	Friction pulley	C-44	Hex head screw M6x16
C-15	Ring	C-45	Special washer 8mm
C-17	Screw hex head M6x12	C-46	Spring washer 6mm
C-18	Nylon ring	C-47	Cap nut M8
C-19	Washer 6mm	C-48	Lever,friction pulley
C-20	Lock nut M6	C-49	Hex head screw M8x45
C-21	Sunk head screw M6x16	C-50	Plastic washer
C-22	Flat washer 8mm	C-51	Plastic washer
C-23	Lock nut M8	C-52	Flat washer 8mm
C-24	Flat washer 8mm	C-53	Lock nut M8
C-25	Screw hex head M8x70	C-54	Lock nut M8
C-26	Collar	C-55	Handle for lever
C-27	Plastic washer	C-56	Cap nut M8
C-28	Flat washer 8mm	C-57	Pull spring
C-29	Hex head screw M8x45	C-58	Sprocket A
C-30	Tension plate	C-59	Sprocket A
		C-60	Shaft,tension pulley

## AT310SPT Planer Thicknesser

DIAGRAM D



## Parts List of Diagram D

NO.	DESCRIPTION		
D-1	Outfeed roller	D-32	Set screw M6x6
D-2	Nut hex w/flange M8	D-34	Recoil lock
D-3	Screw hex w/flange M8x40	D-35	Infeed roller
D-4	Set screw M5x12	D-36	Square spacer
D-9	Set screw M6x10	D-37	Pressure spring
D-11	Blade holder	D-38	Sprocket A
D-12	Cutter blade	D-39	Spacer sprocket
D-14	Cutter block	D-40	Flat washer 8mm
D-15	Deep groove bearing 6205-P5-2Z	D-41	Lock nut M8
D-16	Deep groove bearing 6205-P5-2Z	D-42	Flat washer 6mm
D-17	Lock nut for block	D-43	Pressure spring
D-18	Spindle special Hex nut	D-44	Lock nut M6
D-19	Mount,limit switch	D-45	Flat washer 6mm
D-20	Limit switch	D-46	Dust port
D-21	Sunk head screw M4x35	D-47	Combined vacuum hood
D-22	Nut hex M4	D-48	Rivet
D-23	Screw hex w/flange M8x40	D-49	Pan head screw M4x16
D-24	Nut hex w/flange M8	D-50	Locking shaft
		D-50	Seat,locking shaft
D-26	Bearing house,rear	D-51	locking shaft
D-27	Bearing house,front	D-52	Spring
D-28	Shaft,dust hood	D-53	Nut M6
D-30	Glide piece	D-54	Locking plate
D-31	Collar	D-55	Cross sunk head screw M4x12



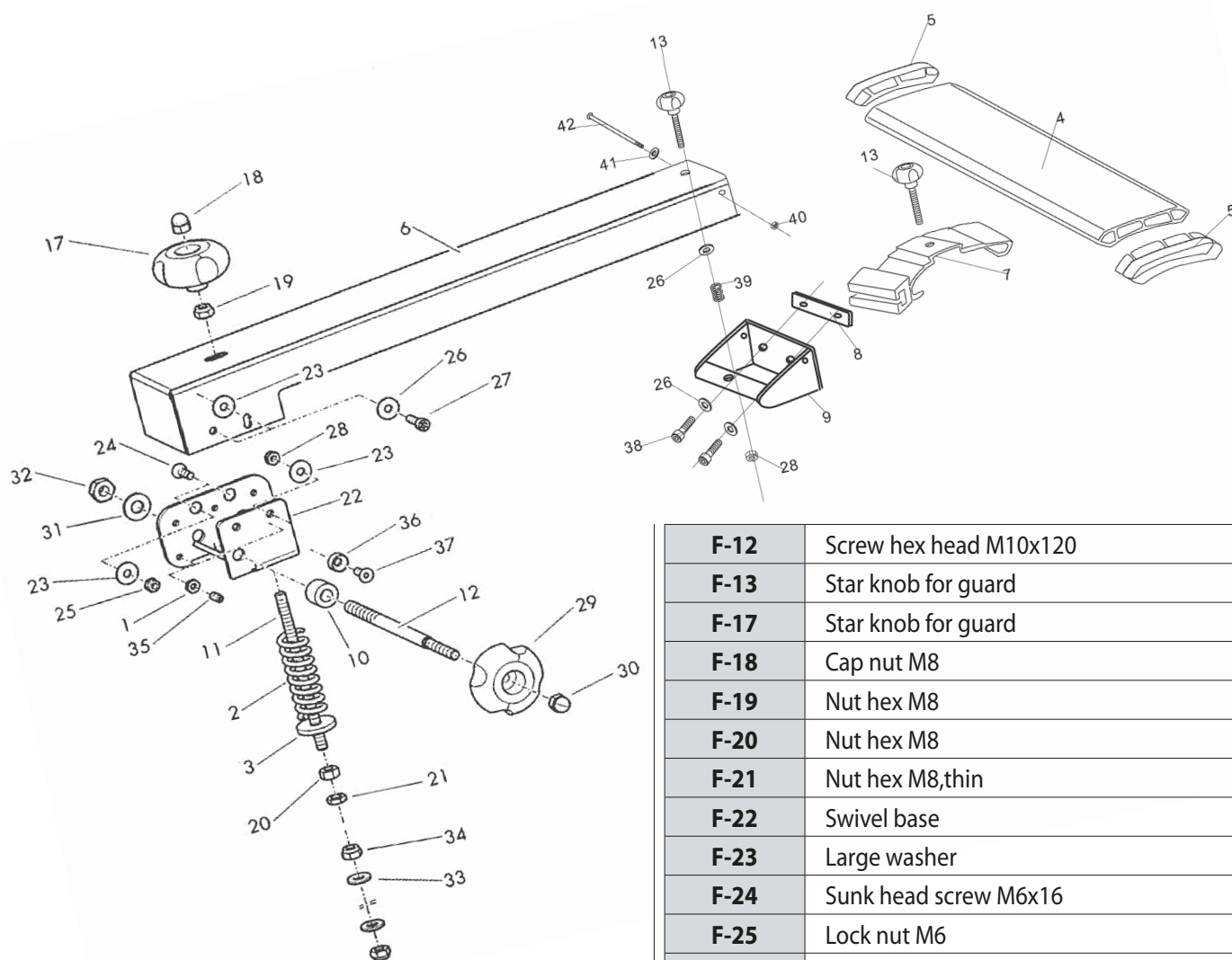
## Parts List of Diagram E

NO.	DESCRIPTION		
<b>E-2</b>	Indicator scale	<b>E-20</b>	Clamping lever
<b>E-3</b>	Out-feed table	<b>E-21</b>	Table turning handle
<b>E-4</b>	Circle ring 15mm	<b>E-22</b>	Slide piece from table
<b>E-5</b>	Guard,in-feed table	<b>E-23</b>	In-Out feed table shaft
<b>E-6</b>	Guard,out-feed table	<b>E-25</b>	Roll pin 6x35
<b>E-7</b>	Pan head screw M6x12	<b>E-26</b>	External lock washer 10mm
<b>E-8</b>	In-feed table,planer	<b>E-27</b>	Wave washer
<b>E-15</b>	Screw	<b>E-28</b>	Washer 8mm
<b>E-16</b>	Bracket	<b>E-29</b>	Nut hex M8
<b>E-17</b>	Cap nut M6	<b>E-30</b>	Nut hex M10
<b>E-18</b>	Set screw M6x10	<b>E-32</b>	Allen screw M10x35
<b>E-19</b>	Set screw M6x6	<b>E-33</b>	Spring
		<b>E-35</b>	Nut hex M6

# Exploded Diagrams/Lists

## AT310SPT Planer Thicknesser

### DIAGRAM F



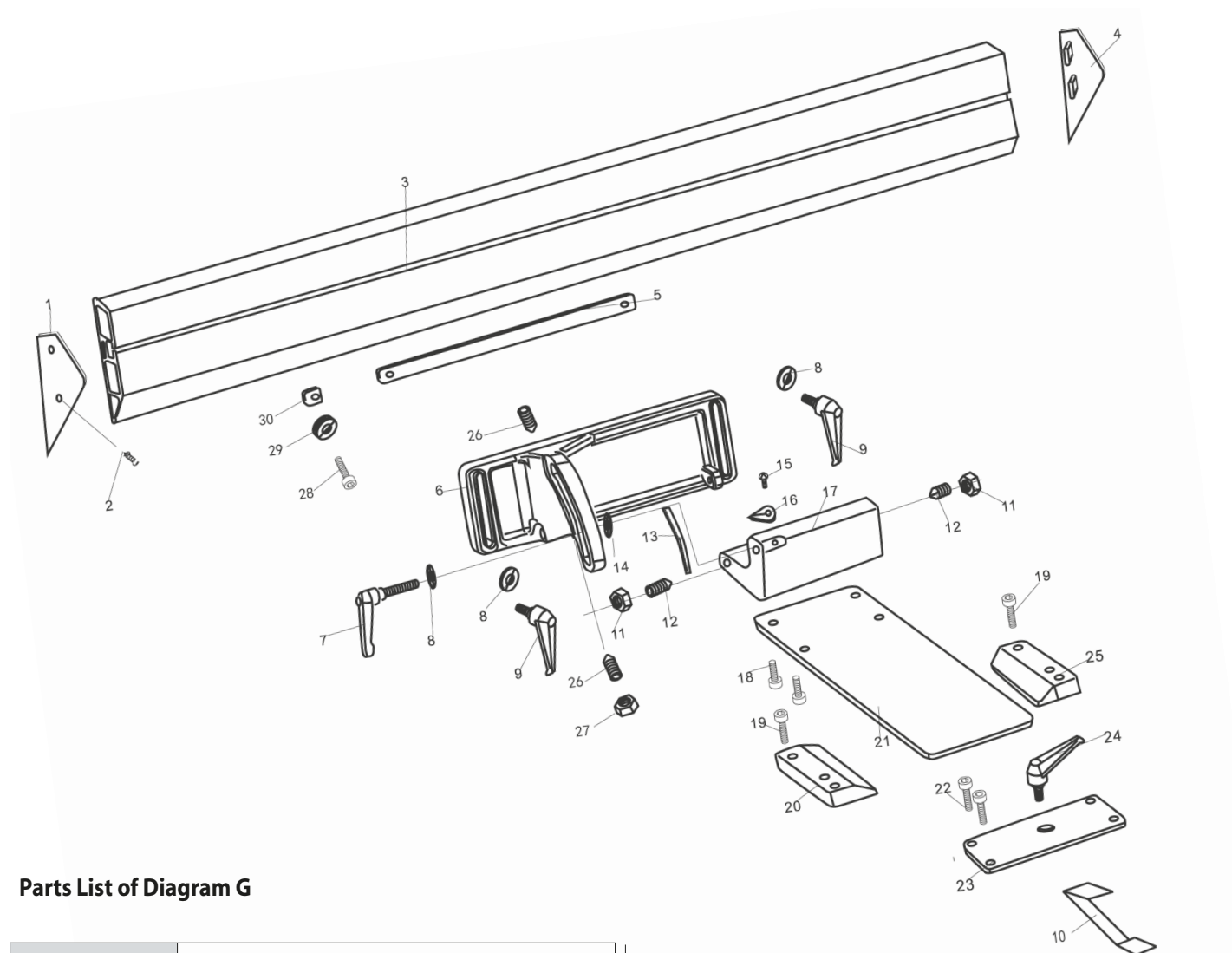
### Parts List of Diagram F

NO.	DESCRIPTION
F-1	Nut hex M6
F-2	Spring
F-3	Flat washer
F-4	Protective guard plate
F-5	End cap protective guard
F-6	Bridge guard arm
F-7	Joint,bridge guard
F-8	Blot guide
F-9	Knot
F-10	Spacer
F-11	Screw rod M8x145

F-12	Screw hex head M10x120
F-13	Star knob for guard
F-17	Star knob for guard
F-18	Cap nut M8
F-19	Nut hex M8
F-20	Nut hex M8
F-21	Nut hex M8,thin
F-22	Swivel base
F-23	Large washer
F-24	Sunk head screw M6x16
F-25	Lock nut M6
F-26	Washer 6mm
F-27	Allen screw M6x20
F-28	Lock nut M6
F-31	Washer 10mm
F-32	Lock nut M6
F-33	Washer 8mm
F-34	Lock nut M8
F-35	Set screw M6x12
F-36	Spacer,lock
F-37	Sunk head screw M6x16
F-38	Allen screw M6x10
F-39	Spring
F-40	Hex nut M5
F-41	Washer 5mm
F-42	Pan head screw M5x60

## AT310SPT Planer Thicknesser

DIAGRAM G

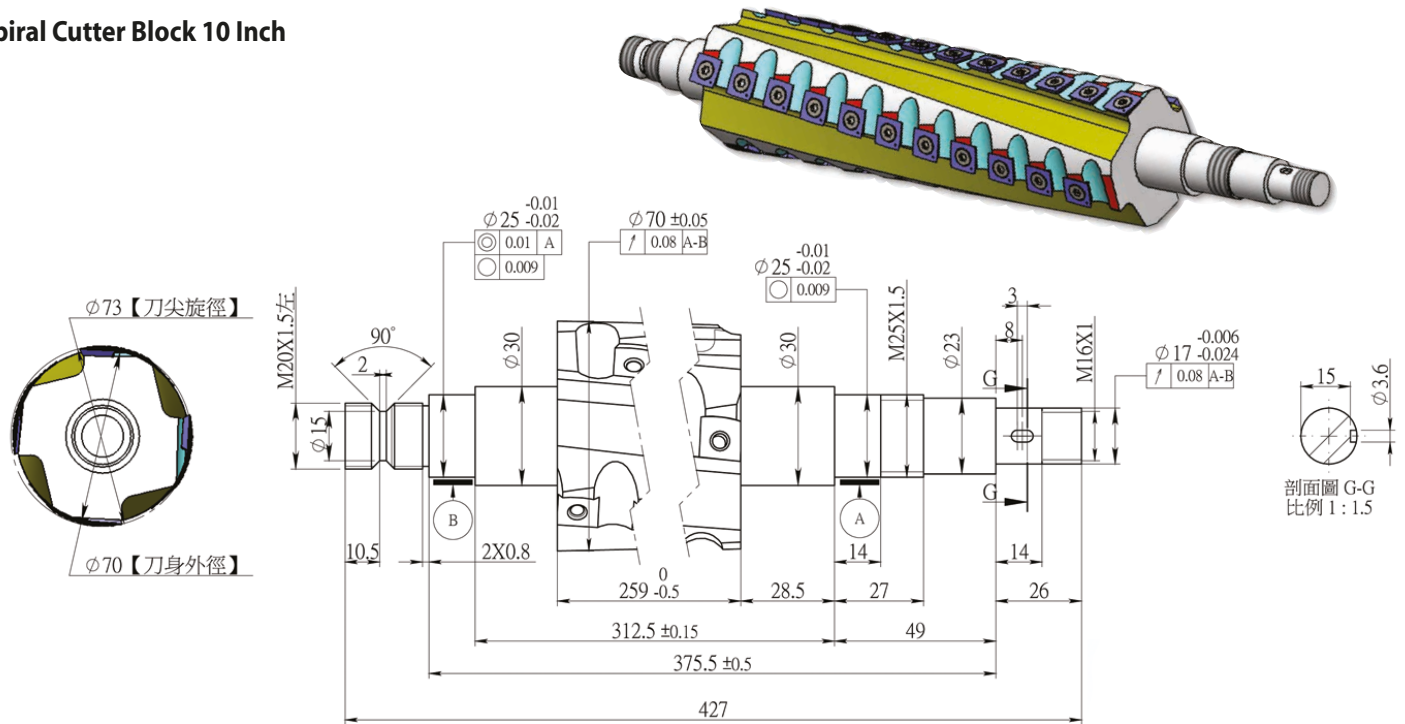


Parts List of Diagram G

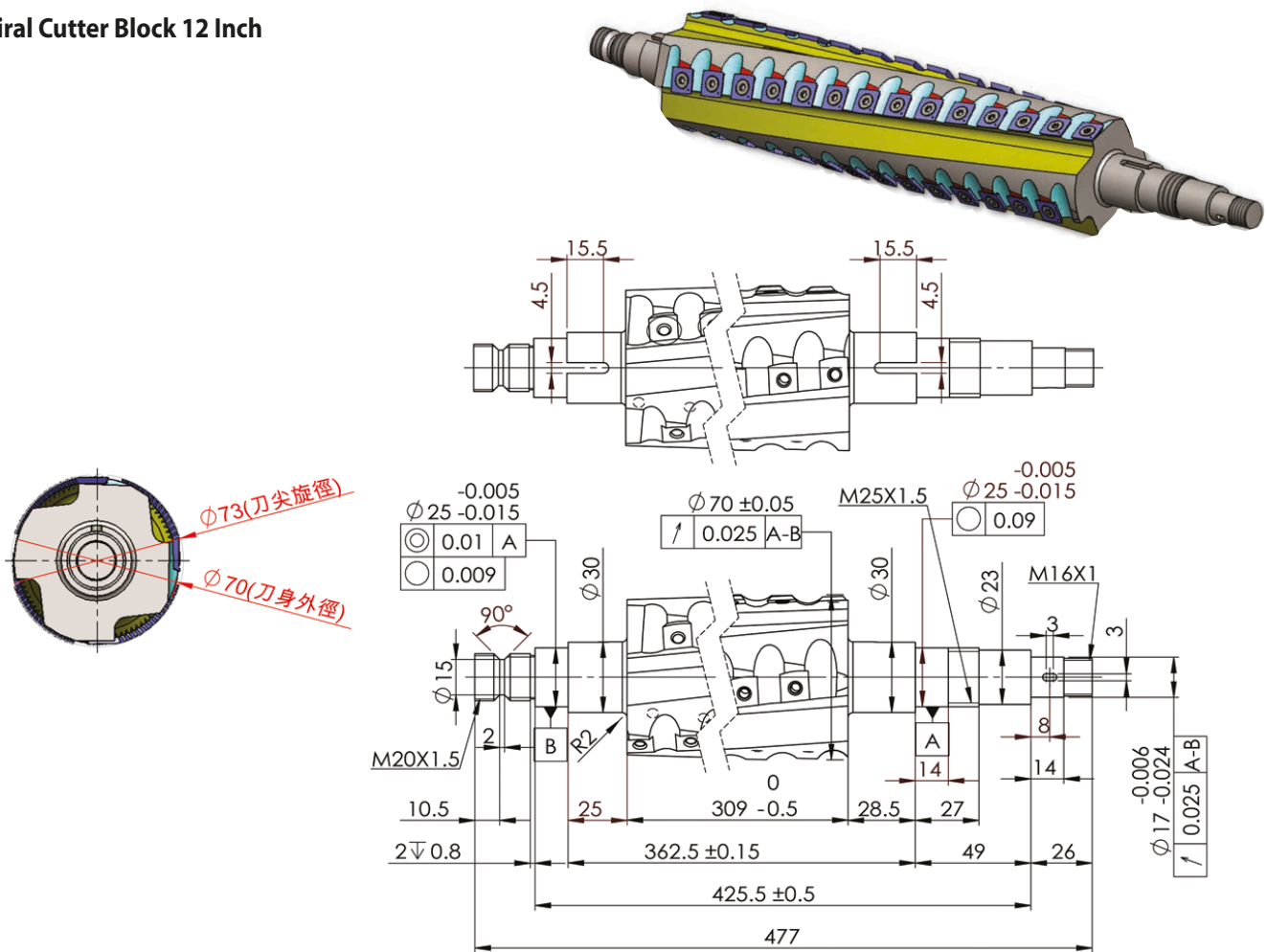
NO.	DESCRIPTION		
<b>G-1</b>	Left hand cover for fence	<b>G-16</b>	Pointer
<b>G-2</b>	Pan head screw	<b>G-17</b>	Fence block
<b>G-3</b>	Rip fence	<b>G-18</b>	Allen bolt
<b>G-4</b>	Right hand cover for fence	<b>G-19</b>	Allen bolt
<b>G-5</b>	Connection plate	<b>G-20</b>	Left fixing plate
<b>G-6</b>	Fence plate	<b>G-21</b>	Sliding plate
<b>G-7</b>	Adjusting handle	<b>G-22</b>	Allen screw
<b>G-8</b>	Washer	<b>G-23</b>	Clamping plate
<b>G-9</b>	Adjusting handle	<b>G-24</b>	Adjusting handle
<b>G-10</b>	Insert board for fence	<b>G-25</b>	Right fixing plate
<b>G-11</b>	Nut	<b>G-26</b>	Locking screw M6x12
<b>G-12</b>	Set screw	<b>G-27</b>	Nut M6
<b>G-13</b>	Scale	<b>G-28</b>	Cross sunk head screw M6x12
<b>G-14</b>	Set screw	<b>G-29</b>	Stop spacer
<b>G-15</b>	Pan head screw	<b>G-30</b>	Locking plate

# Spiral Cutter Block Diagram

## Spiral Cutter Block 10 Inch



## Spiral Cutter Block 12 Inch





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