

# PLANER

VERSION 3.1



AUTODESK  
PIER 9

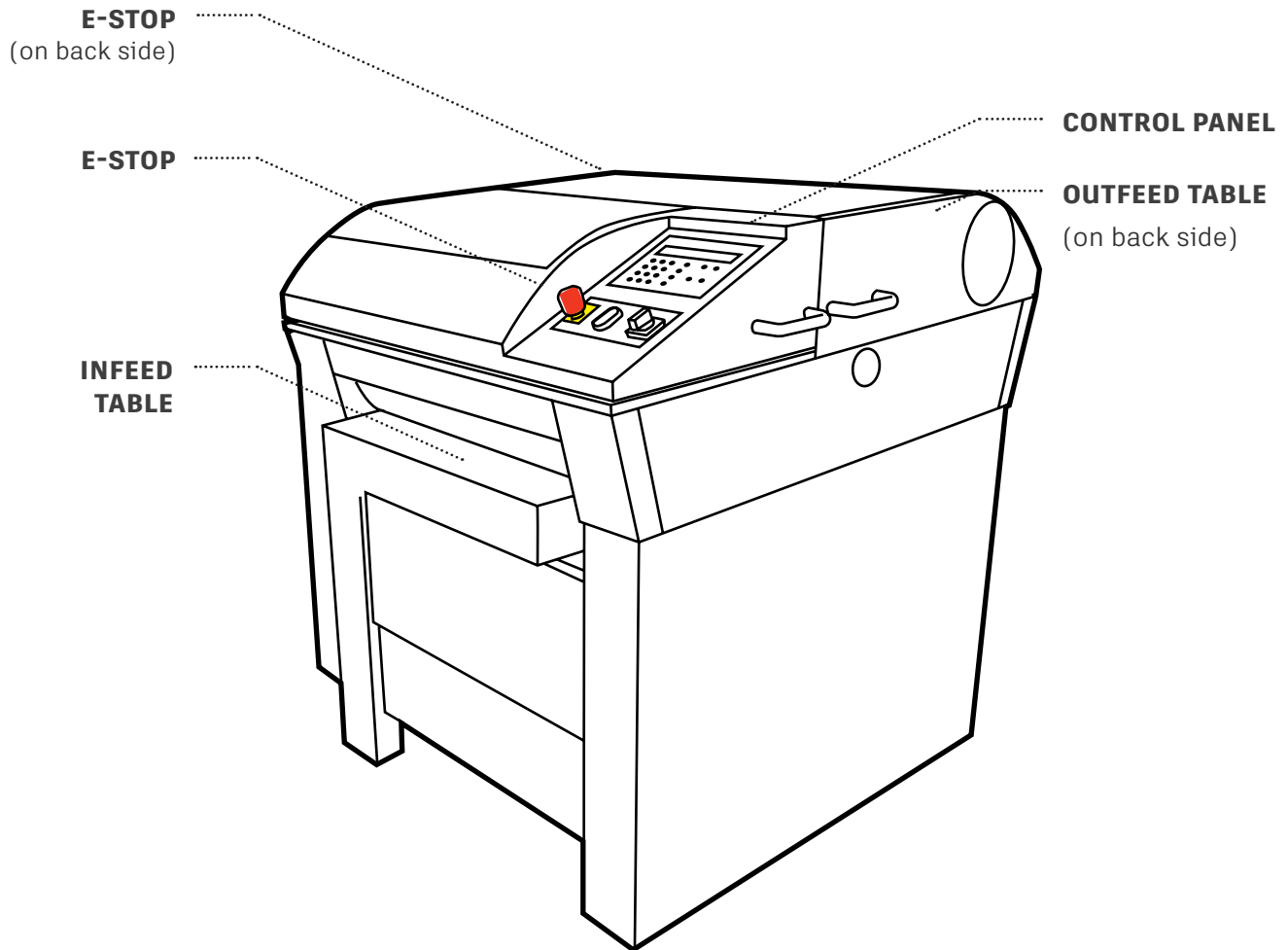
# PLANER

## MACHINE CONTROLS

VERSION 3.1

THE PLANER CONVERTS ROUGH-SAWN LUMBER TO USABLE BOARDS.

P. 2



## MATERIALS

### **i** ALLOWED MATERIALS

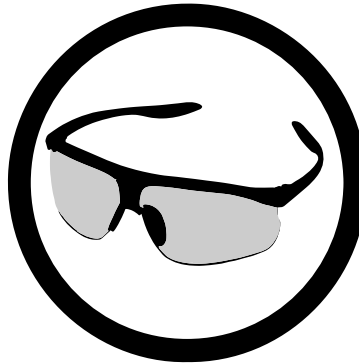
- + Solid hardwood - clean and free of nails, staples or paint

### **x** BANNED MATERIALS

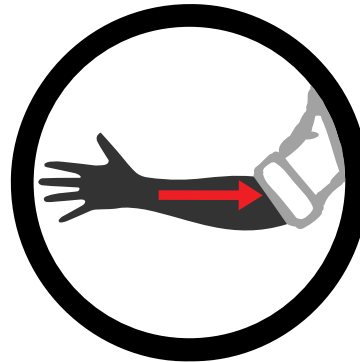
- + Any material that isn't solid wood.
  - ▶ plywood, plyboo, MDF, etc.
- + Painted wood
- + Soft wood
- + Reclaimed wood

USE PERSONAL PROTECTIVE EQUIPMENT WHEN OPERATING THE PLANER.

P. 3

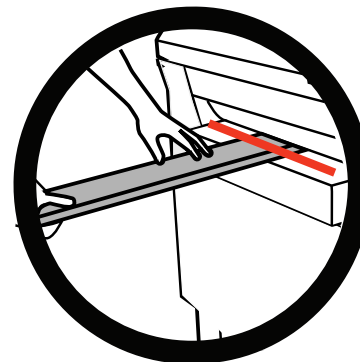
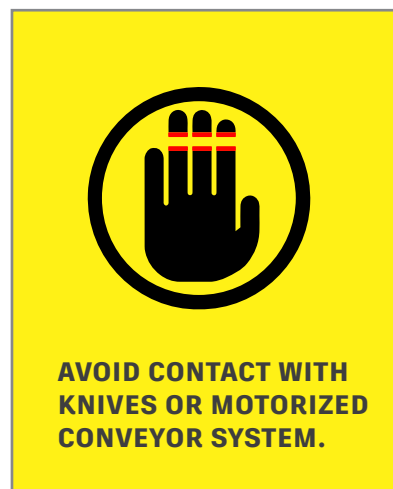


Always wear safety glasses.



Always wear short sleeves, or rolled sleeves, pull back and tuck in long hair, remove jewelry and lanyards, etc.

Do not wear gloves.



Never reach into the opening of the planer.

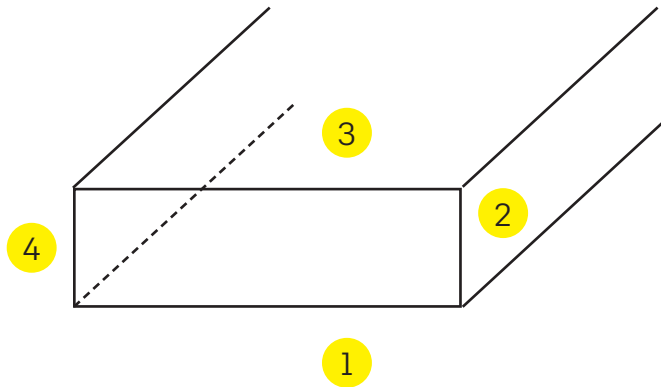
# PLANER

TIPS & TRICKS

VERSION 3.1

USE THE PLANER TOGETHER WITH THE JOINTER TO MAKE A SMOOTH, SQUARE PIECE.

P. 4



1. Use the jointer to flatten one face (the bottom).
2. Use the jointer on an adjacent edge to make two perpendicular surfaces.
  - ▶ Place the jointed face against the fence when jointing the edge.
3. Use the planer to make the top parallel to the bottom.
  - ▶ Use repeated passes on the planer to reach the desired thickness.
4. The second edge should be cut square on the table saw.
  - ▶ Cutting 1/16" wider than required will allow making a final pass on the jointer for a perfectly smooth edge.

## OPERATING MECHANISM

The planer works by rotating knives slicing the top of the board, as motorized wheels pull the wood through the machine.

The control panel allows you to set the finished dimension of the board - opposite of the jointer where the adjustment is for amount of material to be removed. The table height is changed by entering a dimension into the control panel.

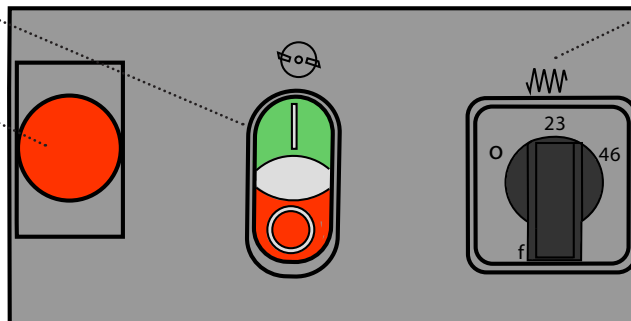
## FEED RATE

The feed rate knob controls how fast the board moves past the cutting knives. It has two settings: 23 or 46 feet per minute.

Always use the 23 feet per minute setting.

KNIFE START SWITCH

E-STOP



FEED RATE SELECTOR

THE READOUT SHOWS HOW THICK THE BOARD WILL BECOME.

P. 5

## CHANGING THE DEPTH OF CUT

The main power and the dust collector must be on before adjusting the planer.

- + If the machine will not turn on, check the e-stop by the outfeed table.

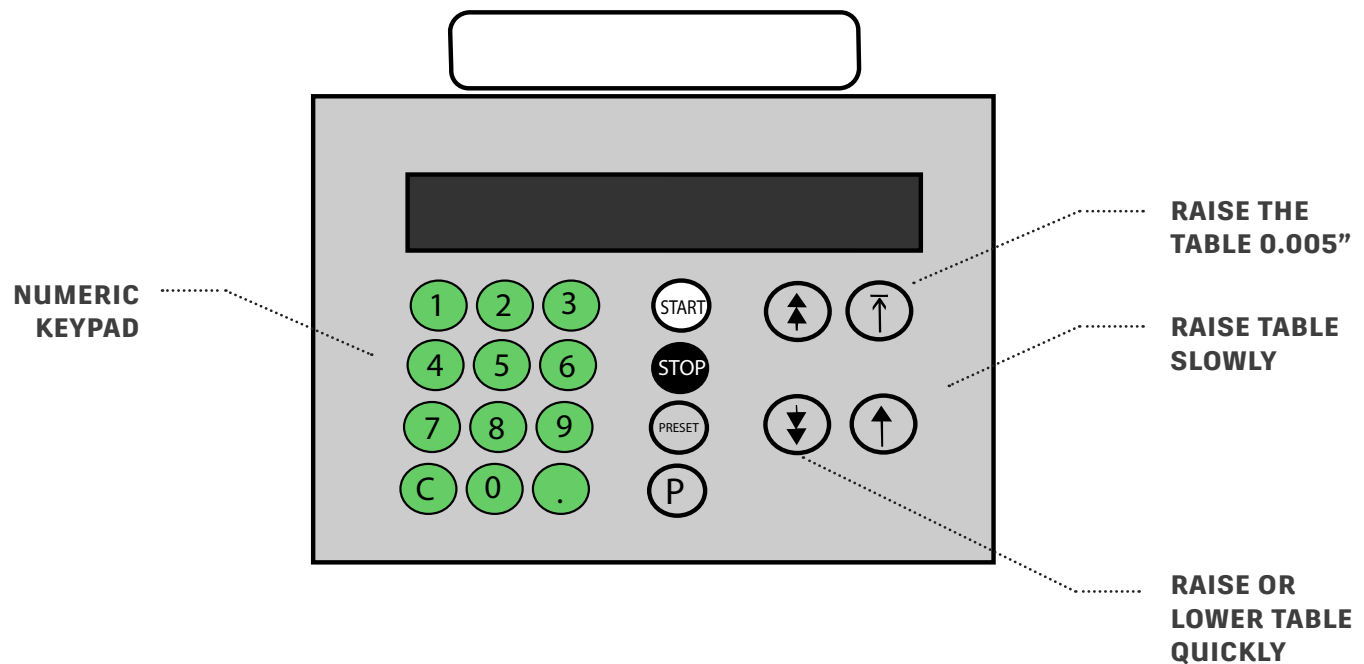
There are two ways to adjust the table height.

### ENTER A HEIGHT WITH THE KEYPAD

- + Enter a number with the keypad and press START.
  - ▶ The number must be entered as a decimal inch (3.125) rather than a fraction (3 1/8).
  - ▶ Use the chart under the control panel for easy conversions.
- + The maximum depth of cut is 1/16" (0.063").

### MOVE THE TABLE USING THE ARROW BUTTONS

- + Use the rapid table movement buttons to get the table close to the desired height.
- + Use the slow table movement button to reach the desired height.
  - ▶ The final adjustment must always move the table up, never down.
- + The maximum depth of cut is 1/16" (0.063").



## USING AUTO STEP

Auto Step lifts the bed a pre-determined amount each time the START button is pushed. It can only be used after the first pass has been made.

The step value is the amount the table will raise each time.

- + Press STOP, P, 0, then START.
  - ▶ The display should read 00P and a number - the step value.
- + Enter the new step value.
- + Use 0.03 (about 1/32").
- + Press START.

Each time you make a pass, press START and insert the workpiece again. The table will raise .03 each time.

## AREA AND MACHINE PREPARATION

1. Clean and clear the table.
2. Make sure there is sufficient room behind the outfeed table for your workpiece.
3. Measure the thickness of the workpiece in multiple places.
  - ▶ Using a digital caliper is easy and gives the answer in decimal inches.
4. Turn on the main power, and check the front and rear e-stop.
5. Turn on the dust collection.
6. Set the table height.
  - ▶ Press stop.
  - ▶ Enter the thickest dimension you measured.

**MAKE SURE ALL WOOD IS NAIL, STAPLE, GLUE & SAP FREE.**

## MAKING THE CUT

1. Press the blade start button and wait for the planer to come up to speed and table to move.
2. Slide the board into the machine and support the end if needed.
  - ▶ Do not push or pull the board once the power feed has taken over.
3. Go to the outfeed side (or have a partner help) and support the board as it exits.
4. Readjust the table height and take another pass if needed.
  - ▶ Maximum depth of cut is 0.06" (about 1/16").

**KEEP HANDS OUT OF THE OPENING IN THE MACHINE.**



## CLEANUP

1. Brush off the table.
2. Clean up the area.
3. Turn off the dust collector if it's not in use.
4. Put scraps in the trash and reusable pieces in the storage rack.

**MAKE SURE THE MACHINE IS TURNED OFF BEFORE YOU WALK AWAY.**