Operating Manual

8″ PLANER-THICKNESSER WITH DUST COLLECTION

ADH 200

CAUTION: Read and follow all Safety Rules and Operating Instructions before First Use of this Product.

TABLE OF CONTENTS

SPECIFICATIONS

Motor	AC230V ~ 50Hz 1500W 5.8A
Number of Blade	2
Cutter block rpm	8500 min^{-1}
Weight	28 kg
Technical data-Planer	
Cutting Width (max)	204 mm
Cutting Depth (max)	2 mm
Angle fence	520x102 mm
Fence Angle	90° -135°
Working Table	737x210 mm
Technical data-Thicknesser	
Cutting Width (max)	204 mm
Cutting thickness (max)	5-120 mm
Cutting Depth (max)	2 mm
Working Table	255x204 mm

SAFETY RULES:

WARNING: When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following.

Read all these instructions before attempting to operate this product and save these instructions.

(1) Keep work area clear

- Cluttered area and benches invite injuries.

(2) Consider work area environment

- Don't expose electric tools to rain.
- Do not use electric tools in damp or wet locations.
- Keep work area well lit.
- In particular, no inflammable liquids or gases must be present.

(3) Guard against electric shock

- Avoid body contact with earthed or grounded surface.

(4) Keep children and other persons away

- Don't let especially children, persons not involved in the work touch the tool or extension cord and keep them away from the work area.

(5) Store idle tools

- When not in use, tools should be stored in a try locked up place, out of reach of children.

(6) Don't force the tool

- It will do the job better and safer at the rate for when it was intended.

(7) Use the right tool

- Don't force small tools to do the job of a heavy-duty tool.
- Don't use tools for purposes not intended: for example, don't use circular saws to cut tree limbs or logs.

(8) Dress properly

- Don't wear loose clothing or jewelry. They can be caught in moving parts.
- Rubber gloves and non-skid footwear are recommended when working outdoors.
- Wear protective hair covering to contain long hair.

(9) Use protective equipment

- Use safety glasses.
- Use face or dust mask if cutting operations create dust.

(10) Don't abuse cables

- Never carry tool by cable or rank it to disconnect it from socket. Keep cable from heat, oil and sharp edges.

(11) Do not abuse the cord

- Never yank the cord to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

(12) Secure work

- Where possible use clamps or a vice to hold the work. It is safer than using your hand.

(13) Don't overreach

- Keep proper footing and balance at all times.

(14) Maintain tools with care

- Keep cutting tools sharp and clean for better and safer performance.
- Follow instruction for lubricating and changing accessories.
- Inspect tool cords periodically and if damaged have them repaired by

an authorized service facility.

- Inspect extension cords periodically and replace if damaged.
- Keep handles dry, clean and free from oil and grease.

(15) Disconnect tools

- When not in use, before servicing and when changing accessories such as blades, bits and cutters, disconnect tools from the power supply.

(16) Remove adjusting keys and wrenches

- Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.

(17) Avoid unintentional starting

- Ensure switch is in “off” position when plugging in

(18) Use outdoor extension leads

- When the tool is used outdoors, use only extension cords intended for outdoor use and so marked.

(19) Stay alert

- Watch what you are doing, use common sense and do not operate the tool when you are tired.

(20) Check damaged parts

- Before further use of tool, it should be carefully checked to determine that it will operate properly and perform it’s intended function.
- Check for alignment of moving parts, binding of moving parts, mounting and any other conditions that may affect it’s operation.
- A guard or other part that is damaged should be properly repaired or replaced by an authorized service centre unless otherwise indicated in this instruction manual.
- Have defective switches replaced by an authorized service centre.
- Do not use the tool if the switch does not turn it on and off.

(21) Warning

- The use of any accessory or attachment other than one recommended in this instruction manual may present a risk of personal injury.

(22) Have your tool repaired by a qualified person

-This electric tool complies with the relevant safety rules. Qualified persons using original spare parts should only carry out repairs. Otherwise this may result in considerable danger to the user.

(23) Never use the machine without the appropriate guard in place and correctly adjusted.

(24) Do not use knives, which are blunt as this increases the danger of kickback.

(25) Any portion of the cutter block not being used for planning shall be guarded.

(26) When planning short workpieces, a push-stick should be used.

(27) When planning narrow workpieces additional measures. Such as of horizontal pressure devices and spring-loaded guards, may be necessary to ensure safe working.

(28) Do not use the tool cut rebate.

(29) The effectiveness of the device for the prevention of kickback and the feed spindle should be regularly inspected to ensure safe operation.

(30) Tools equipped with chip collection and extractor hoods shall be connected to the dust and chip-collecting device.

(31) Use the tool only for wood or similar materials.
When the blade be abraded 95%, you must change it to the new one, which must meeting EN847-1.

(32) Need two persons for moving round the workshop due to its heavy weight.

(33) The machine should be fixed on the floor by screws when operating.

UNPACKING

Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer.

The machine is shipped complete in one carton. Additional parts which need to be fastened to machine should be located and accounted for before assembling. Refer to figure 1.

A. Planer and Thicknesser
B. Dust collector
C. Guide fence
D. Cannulation and Hoop
E. Bag
F. Spring

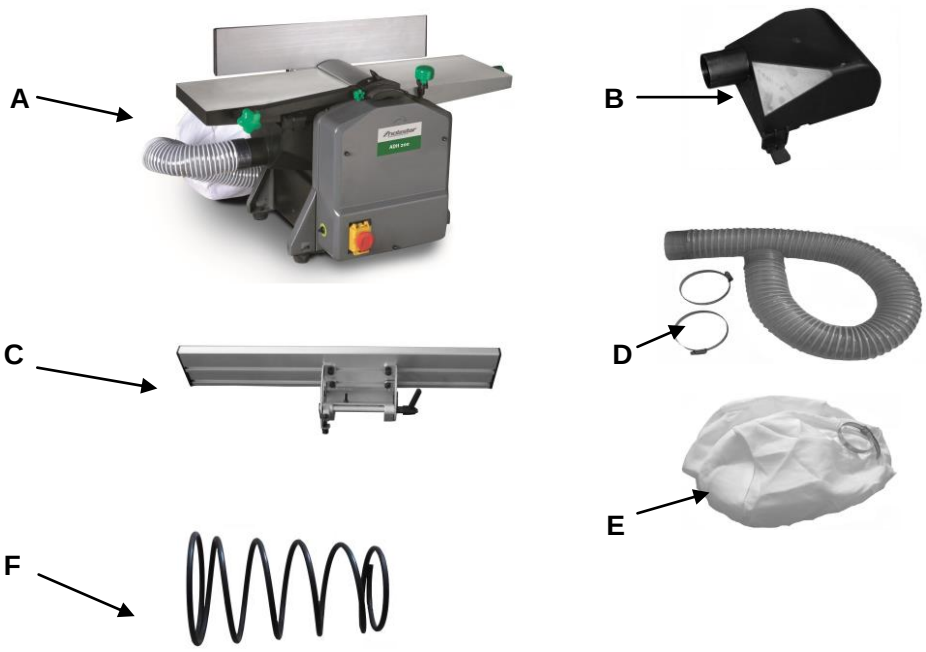


Figure 1

INSTALLATION

The planer weighs approximately 28 kg when completely assembled. The planer must be installed in a place with ample lighting and correct power supply. To install planer:

-Make sure there is plenty of room for moving the workpiece through the entire cut. There must be enough room that neither the operators nor the bystanders will have to stand in line with the wood while using the tool.

-Planer should be installed on a workbench using bolts, Locking Nuts and hex nuts. (Have supplied)

-The planer must be bolted to a firm, level surface.

-Make sure the planer does not rock and the tables are level.

Refer to Figure 2

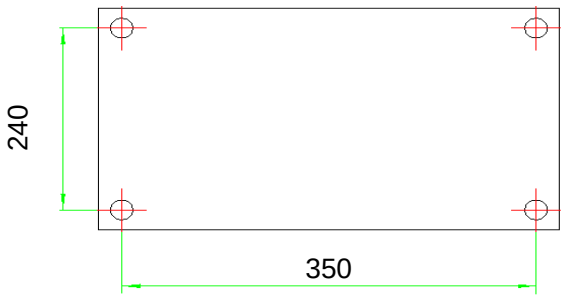


Figure 2

STRUCTURE AND FUNCTIONS

MBY8 planer and thicknesser is a transportable electric tool. The machine is driven by a single-phase induction-motor. It is only used to plane wood. It has the characteristics of rational structure, easy operation and high efficiency. Refer to figure 3.

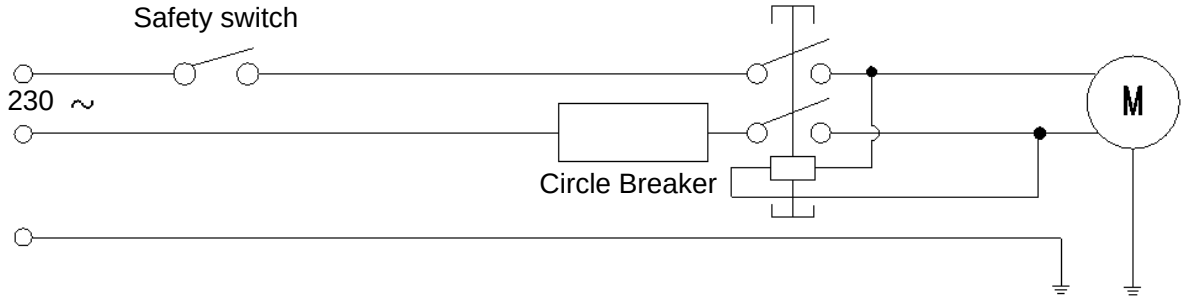


Figure 3

POWER SOURCE

WARNING: Do not connect jointer/planer to the power source until all assembly steps have been completed. The motor is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below specified voltage. Running the until on voltages which are not within range may cause overheating and motor burnout. Heavy loads require that voltage at motor terminals be no less than the voltage specified on nameplate.

GROUNDING INSTRUCTIONS

Refer to figure 4

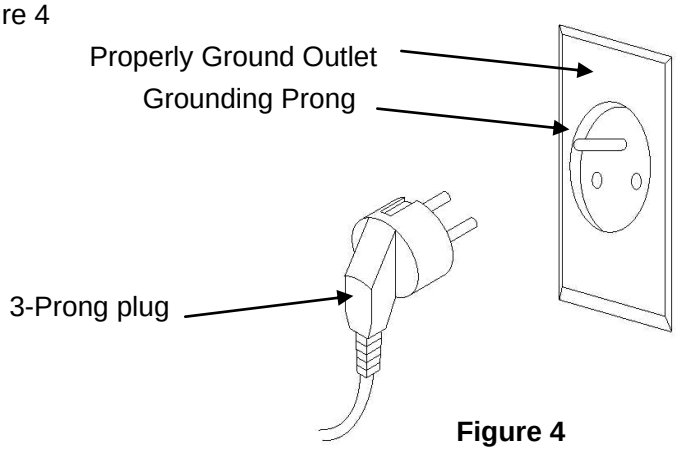


Figure 4

WARNING: Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

- Check with a qualified electrician if you do not understand grounding instructions or if you are in doubt as to whether the tool is properly grounded.

-This tool is equipped with an approved cord rated at 230v and a 3-prong grounding type plug for you protection against shock hazards.

-Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown.

-Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

SUPPLEMENTARY SAFETY INSTRUCTIONS

1 Regularly check that blades and lock bars are locked tight in cutter block.

2 Max. allow able blade projection over cutter block 1.0mm/0.004 inch +10%.

⑶ Never remove any of the machine's safety guards other than for servicing and repair work. Keep guards operational at all times.

⑷ Set and secure safety guards in position before operating machine.

⑸ When operating machine in enclosed spaces connect to a dust collector.

⑹ This machine must be safety earthed. The yellow/green (green) lead is the earth conductor.

⑺ Regularly check anti-kickback fingers for proper operation.

⑻ Always wear eye protection.

⑼ Rebating, tenoning , moulding and recessing may not be undertaken without the use of special guards.

⑽ Never make jointing or planning cut deeper than 2 mm.

USER RESPONSIBILITY

This machine will perform in conformity with the description contained in this manual when installed, operated, maintained and repaired in accordance with the instructions provided.

This machine must be checked periodically. Defective equipment (including power cable) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repair or replacement become necessary, it is recommended that such repairs be carried out by qualified persons.

This machine or any of its parts should not be altered or changed or changed from standard specifications. The user of this machine shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specification, Faulty maintenance, damage or improper repair.

OPERATION REGULATIONS

ATTENTION: Make sure that the switch is in off position before adjusting the cutting depth, replacing or adjusting the blades. Make sure the blade screws are securely tightened.

SETTING ANGLE FENCE

Insert screw into the slot A and B. Then loosen C to adjust angle fence.

Turn M up, guide fence may move to left or right.

Refer to figure 5

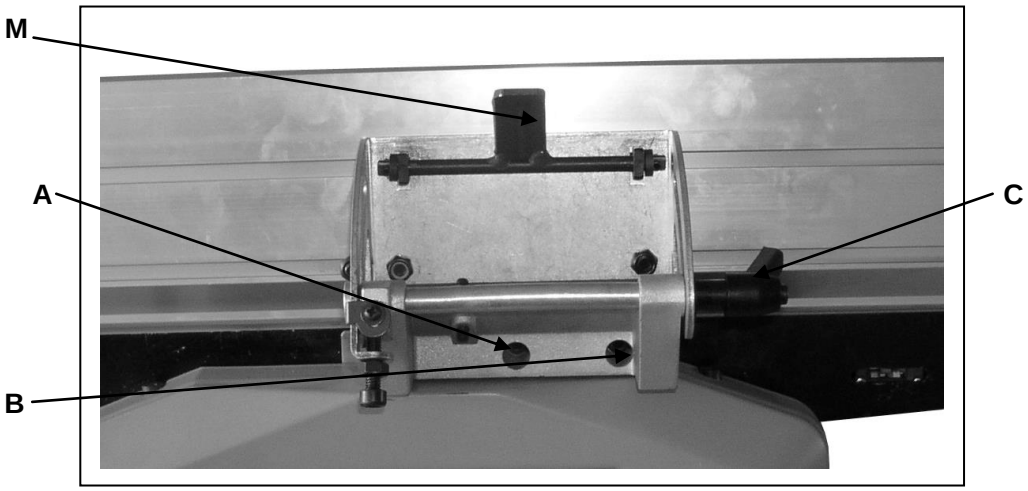


Figure 5

OVERLOAD PROTECTION

If the motor protection responds, this always indicates that the motor is overloaded. The cause must be located and the fault eliminated.

If the motor is overloaded or in the event of power failure, the motor switches off automatically. The machine can not be switched on again until the motor is cooled down or the power supply has been restored.

CHIP EXTRACTION

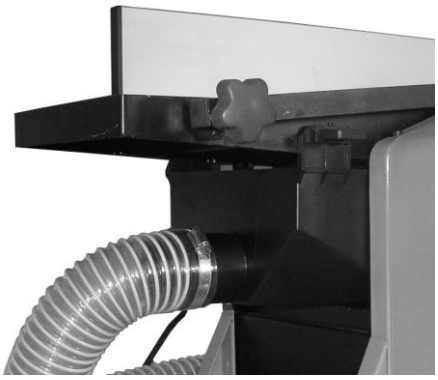
To ensure trouble free and reliable operation on enclosed premises, the machine must be connected to an extractor unit at the dust collector D (accessory)

DUST COLLECTOR CONNECTION WHEN PLANING :

- Lift up the blade guard arm E so that the longitude holes F being exposed;
- Pull out the key G on both sides of the dust collector D;
- Move down the working table H to the lowest position, and insert the dust collector D; referring to Fig. 6

Figure 6

- The dust collector D is so positioned that both keys G are in line with the longitude holes E. Then push both keys G into the longitude holes F. Referring to Fig. 7



DUST COLLECTOR CONNECTION WHEN THICKNESSING:

-Adjust guide fence to 135°.Loosen M, then slips guide fence into right side.

-Remove the blade guard I and place the dust collector D. See Figure 8.

-The dust collector D is so positioned that both keys G are in line with the longitude holes F. Then push both keys G into the longitude holes F. Referring to Fig. 8

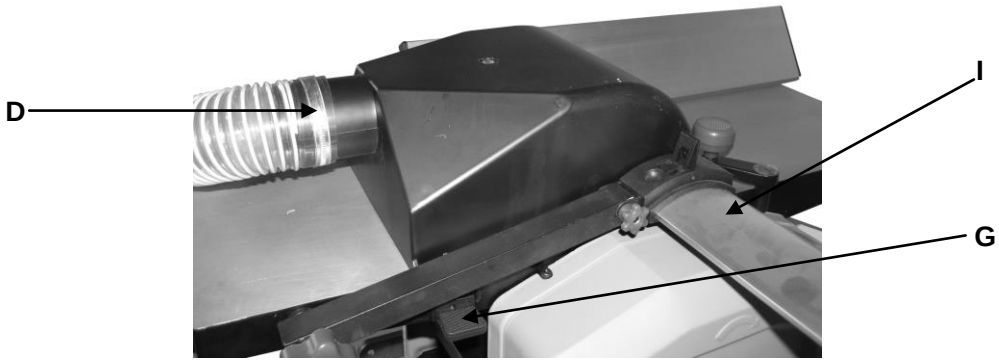


Figure 8

SETTING OF GUARD

Height adjustment is made with the lever mounted on the left side of the machine. After lifting the lock lever the blade cover can be slide ways to set the required stock width for jointing. Push lock lever down to lock guard extrusion in position. Refer to Figure 9.

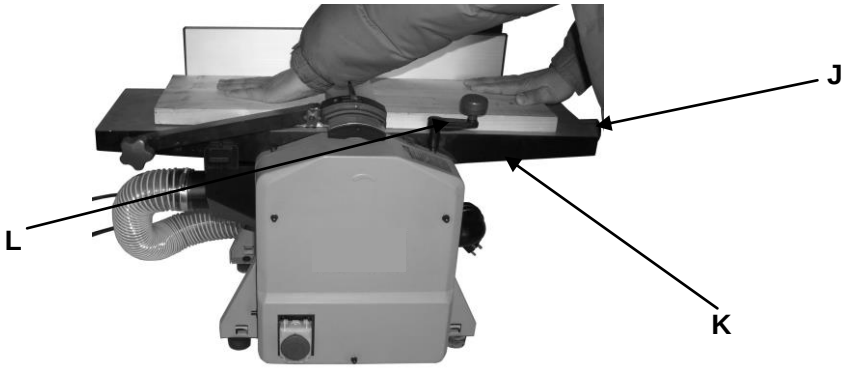


Figure 9

PLANING

The cutting depth is set by handle J at the front table plate K by means of the scale for cutting depth L. Cutting depth between 0.5 and 1.5 mm (1/64~1/16 in.) will produce the best surface.

WARNING: The part of the cutter head not used has to be covered by the knife guard.

Take up a working position so that you are always on one side of the machine away from the area directly in front of or behind the cutter head. Place both hands on the workpiece with the fingers. Do not hold on to the workpiece edges.

Only workpieces should be planed which rest firmly on the machine and can be safety guided.

Refer to figure 10

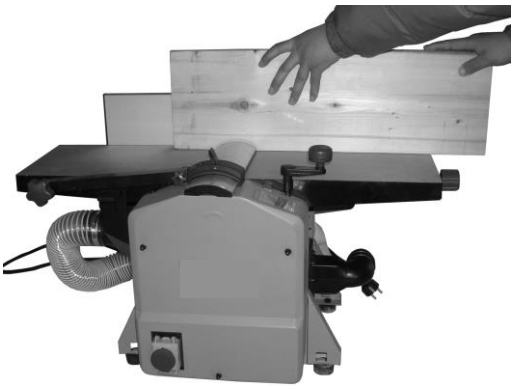


Figure 10

THICKNESSING

-Set the desired height with handle assembly at spindle A with reference to scale.

Depth of cut : 3mm = 1turn of the wheel

-Slide in narrow wood in the middle.

Timber feed device : the timber is feed automatically by two rollers (mounted on spring), one of which is fluted and one of which is smooth. Engage the wood face against the thickness working table, until it is caught by the feed roller. Allow the work piece to pass without pushing. Plane the wood so that the thickness is constant on its whole length.

Long work piece should be supported both at entry into and exit from the machine, in order to avoid hells at the end of the timber. A heel of 1/10 mm is acceptable.

Before beginning machining, check that the timber to be used is free from knots, in order to avoid dangerous breakages. If several pieces are to be machined consecutively, all pieces of the same thickness should be passed through one after another without changing the setting. Perform the machining cycle from the beginning until the required thickness is obtained.

Pass each piece one after another (when the feed roller is free) and allow them to pass through without pushing (as soon as they are caught by the feed roller).

REPLACING BLADES

Disconnect machine from power before servicing!

Replacing blades

-Unplug the jointer/planer from power source and turn the switch to “off” position.

-Block the blade guard from closing down.

-Loosen and remove three blade lock screws securing blade and blade clamp.

-Lift blade and blade clamp from cutterhead.

-Clean any sawdust and resin buildup from cutterhead and blade clamp.
-Place blade clamp against the replacement blade and replace in cutterhead.
-Secure blade and blade clamp using three blade lock screws.Do not over-tighten blade lock screws first.
Note: Check blade height at both of blade
-Tighten blade lock screws.
-Recheck blade adjustment and make sure blade is still level with outfeed table.
-Repeat the procedure to replace the other blade.
-Remove the scrap wood and release blade guard.
-Make sure all the blade lock screws are tight and snug.
NOTE:
-The blades which used with the tool may be replaced or re-sharpened.
-If the blades are re-sharpened, the re-sharpenings should be not more than 3 times with 0.05mm max. each time.
-the blades used in this tool can not be used to rebate**.**

MAINTENANCE

Prior to doing any maintenance work, always pull out the mains plug. The protecting hood which has been removed to the side has to be mounted again after the maintenance work.

Machine care

The planer-thicknesser is designed with a low maintenance requirement. The bearing are greased for life.
After approximately 10 hours of operation we recommend to lubricate the following parts:
-bearings of the feed-in and feed-out rollers.
-bearings of pulley and gear wheel of the belt.
Treat threaded spindles for the height adjustment of the thicknessing table with dry lubricant only!
The table surface and feed-in / feed-out rollers should always be kept clean of resin.
Dirty feed-in rollers and feed-out rollers have to be cleaned.
In order to prevent the motor from overheating, regularly check that no dust has accumulated on the ventilation apertures of the motor.
After a prolonged period of operation, users are recommended to have the machine checked by an authorized customer service shop.

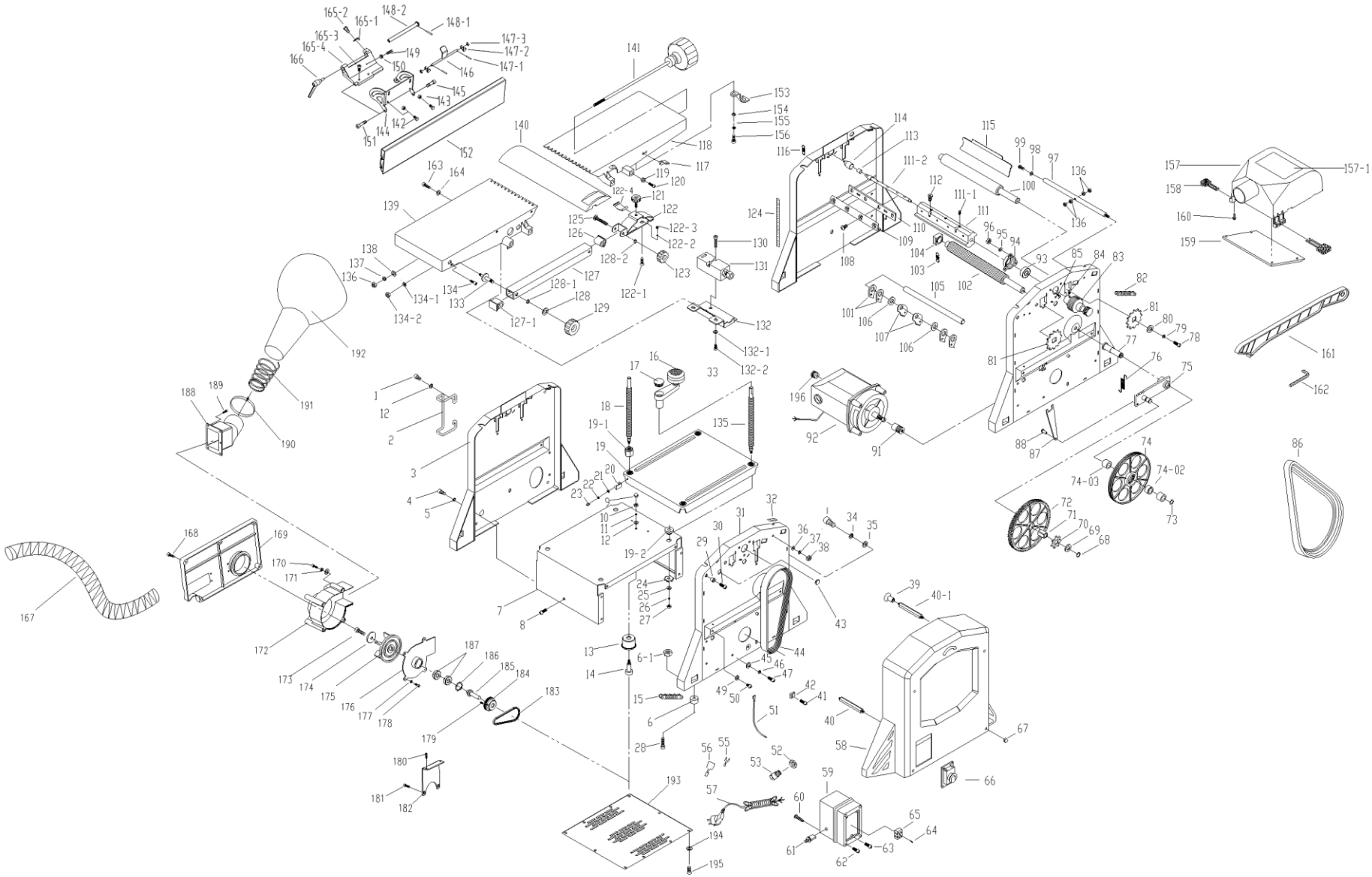
Tool care

The cutter head, clamping devices, knife supports and knives used on the machine must be freed from resin regularly as a clean tool improves the cutting quality. This can be done by soaking the clamping devices, knife supports and reversible knives for 24 hours in paraffin, white spirit or commercially available resin remover.
Tools made of aluminium may only be depurated with cleaning agents which do not corrode this kind of material.

ATTENTION!

Through poor conditions of the electrical MAINS, shortly voltage drops can appear when starting the EQUIPMENT. This can influence other equipment (eg. Blinking of a lamp). If the MAINS-IMPEDANCE Zmax<0.464 OHM, such disturbances are not expected. (In case of need, you may contact your local supply authority for further information).

ASSEMBLY DIAGRAM



PART LIST

NO	DESCRIPTION	QTY.		NO	DESCRIPTION	QTY.
1	Socket head bolt	4		35	Flat washer	1
2	Cord wrap	2		36	Flat washer	1
3	Side plate	1		37	Locking washer	1
3-1	Protecting hood	1		38	Hex nut	1
4	Socket head bolt	11		39	Hex nut	4
5	Locking washer	11		40	Rod,long	4
6	Underprop	4		41	Pan head screw	7
6-1	Hex nut	4		42	Cable Clamp	7
7	Motor covering	1		43	Rubber buffer	2
8	Pan head screw	1		44	Flat belt	1
9	Hex nut	1		45	Flat washer	4
10	Hex nut	1		46	Locking washer	4
11	Locking washer	1		47	Socket head bolt	4
12	Flat washer	6		48	Rod,long	2
13	Angle	1		48-1	Rod,long	2
14	Screw	1		49	Flat washer	12
15	Chain	1		50	Socket head bolt	4
16	Crank	1		51	Line	1
16.1	Joining	1		52	plastic locknut	3
16.2	Upper cover	1		53	strain relief	3
16.3	Nether cover	1		54	Nut	1
16.4	Screw	1		54-1	Adjusting washer	1
17	Plug	1		54-2	Spring	1
18	Threaded spindle,short	3		54-3	Rod	1
19	Table	1		54-4	Sleeve	1
19-1	Threaded spindle nut	4		54-5	Sign	1
19-2	Sleeve	4		54-6	Pan head screw	1
20	Pointer	1		55	Locking line	6
21	Flat washer	1		56	Rubber set	1
22	Locking washer	1		57	Power cable	1
23	Pan head screw	1		58	Protecting hood	1
24	Chain wheel	4		58-1	Tool box	1
25	Flat washer	4		58-2	Box cover	1
26	Locking washer	4		59	Switch box	1
27	Hex nut	4		59.1	Upper cover	1
28	Socket head bolt	4		59.2	Nether cover	1
29	Sleeve	4		60	Pan Head Self Tapping Screw	2
30	Socket head bolt	4		61	Thermo-protector	1
31	Side plate	1		62	Pan Head Self Tapping Screw	4
32	Scale for cutting depth	1		63	Pan Head Self Tapping Screw	3
33	Socket head bolt	1		64	Pan Head Self Tapping Screw	2
34	Locking washer	1		65	Terminal	4

PART LIST

NO	DESCRIPTION	QTY.		NO	DESCRIPTION	QTY.
66	Switch	1		102	Feed-in roller	1
67	Nut	8		103/116	Retracting spring	3
68	Locking ring	1		104	Bearing bush	5
69	Flat washer	1		105	Rod	1
70	Chain wheel	1		106	Flat washer	24
71	Square sleeve	1		107	Ratchet	44
72	Gear wheel	1		108	Bolt	8
73	Retaining ring	1		109	clamping device	2
74	Belt wheel	1		110	Knives	2
74-01	Pinion	1		111	Knife stalk	1
74-02	Lantern ring	1		111-1	Set screw	3
74-03	Needle bearing	2		111-2	Arbor	1
75	Wing,cpl.	1		112	Adjusting bolt	4
75.1	Joint	1		113	Needle bearing	1
75.2	Lantern ring	1		114	Bearing Cap	1
75.3	Short shaft	1		115	Sheet metal deflector	1
76	Retracting spring	1		117	Plastic pointer	1
76-1	Socket head bolt	1		118	Front table top	1
76-2	Hex nut	1		119	Sliding block	4
77	Arbor	1		120	Socket head bolt	4
78	Socket head bolt	2		121	Hand knob	1
79	Locking washer	2		122	Arc cover	1
80	Flat washer	2		122-1	Pan head screw	1
81	Chain wheel	2		122-2	Locking ring	1
82	Chain	1		122-3	Hex nut	1
83	Belt disk	1		122-4	Spring cushion	1
84	Set screw	2		123	Hand knob	1
85	Socket head bolt	3		124	Scale	1
86	Flat belt	3		125	Stud bolt	1
87	Supporting plate	1		126	Cover	1
88	Pole	1		127	Square tube	1
91	Motor belt wheel	1		127-1	Cover	1
92	Motor	1		128	Spacer	1
93	Grooved ball bearing	1		128-1	Locking ring	1
94	Bearing cover	1		128-2	Locking ring	1
95	Locking washer	3		129	Hand knob	1
96	Hex nut	3		130	Socket head bolt	2
97	Strut	1		131	Limit Switch	1
98	Flat washer	2		132	Switch cover	1
99	Socket head bolt	1		132-1	Flat washer	4
100	Feed-out roller	1		132-2	Socket head bolt	4
101	Ratchet	3		133	Stud bolt	1

PART LIST

NO	DESCRIPTION	QTY.		NO	DESCRIPTION	QTY.
134	Impede stalk	1		165-1	Pointer	1
134-1	Locking washer	1		165-2	Flat head screw	1
134-2	Hex nut	1		165-3	Socket head bolt	2
135	Threaded spindle,long	1		165-4	Angle piece	1
136	Hex nut	5		166	Knob	1
137	Locking washer	1		167	Pipe	1
138	Flat washer	1		168	Socket head bolt	5
139	Rear table top	1		169-1	Board	1
140	Knife guard	1		169-2	Rubber ring	1
141	Spindle	1		170	Socket head bolt	4
141.1	Tessera	1		171-1	Flat washer	4
142	Flat head bolt	4		171-2	Locking washer	4
143	Locking nut	4		172	Chip Exhaust	1
144	Joint plate	1		173	Socket head bolt	1
145	Set screw	2		174	Flat washer	1
146	Staff	1		175	Fan	1
147-1	Spring pin	2		176	Bearing seat	1
147-2	Locking bolt	2		177	Locking washer	4
147-3	Locking block	2		178	Socket head bolt	4
148	Locking staff	1		179	Set bolt	1
149	Set screw	2		180	Socket head bolt	2
150	Hex nut	2		181	Socket head bolt	2
151	Spring pin	1		182	Assisting support	1
152	Guide fence	1		183	Belt	1
153	Clamping	1		184	Fan pulley	1
154	Flat washer	2		185	Fan shaft	1
155	Locking washer	2		186	Retracting spring	1
156	Socket head bolt	2		187	Grooved ball bearing	2
157	Dust collector	1		188	Pipe	3
157-1	Nameplate	1		189	Socket Head Bolt	5
158	Key assembly	2		190	Clamp	1
159	Cover	1		191	Spring	1
160	Pan Head Self Tapping Screw	2		192	Bag	1
161	Handspike	1		193	Cover	1
162	Hex Wrench	1		194	Flat washer	1
163	Socket head bolt	1		195	Pan head screw	1
164	Washer	1		196	Pulley	1

EU-Declaration of Conformity

According to Machinery Directive 2006/42/EC, Annex II 1.A

Manufacturer / distributor: Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt

hereby declares that the following product

Product Category:	Holzstar® Woodworking Machines
Machine denomination:	ADH 200
Item number:	5905200
Machine type:	Planer-Thicknesser
Serial number:	_____
Year of manufacture:	20____

corresponds, on the basis of its design and construction, as well as the version that we have put into circulation, with the relevant fundamental health and safety requirements of (subsequent) EU Directives.

Relevant EU Directives:	2014/35/EU	Low Voltage Directive
	2014/30/EU	EMC-Directive

Following standards are used:

DIN EN 60204-1:2007-06	Safety of machines - Basic concepts, general principles for design - Part 1: General requirements
DIN EN ISO 12100:2010	Safety of machinery - General principles for design - Risk assessment and risk reduction (ISO 12100:2010)
DIN EN 861	Safety of woodworking machines - Surface planing and thicknessing machines

Responsible for documentation: Engineering Department, Dr.-Robert-Pfleger-Str. 26, D-96103 Hallstadt

Hallstadt, 13.04.2016

CE

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Kilian Stürmer

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Maschinen