



# OPERATOR'S MANUAL

Wood Working



## PORTABLE BENCH TOP PLANER MODEL: IP-1306

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# Table of Contents

THANK YOU & WARRANTY .....	1
INTRODUCTION.....	3
GENERAL NOTES.....	3
SAFETY INSTRUCTIONS .....	4
SAFETY PRECAUTIONS .....	7
Dear Valued Customer:.....	7
TECHNICAL SPECIFICATIONS .....	10
TECHNICAL SUPPORT .....	11
UNPACKING AND CHECKING CONTENTS.....	12
Cleaning .....	12
INSTALLATION.....	13
GETTING TO KNOW YOUR MACHINE .....	14
ASSEMBLY AND SET UP .....	15
Attaching Depth Adjustment Handle.....	15
Attaching Dust Port.....	16
Dust Collection .....	16
Securing Planer to a Table or Workbench.....	16
ELECTRICAL.....	17
Power cord connection:.....	18
ADJUSTMENTS.....	19
Levelling Extension Tables.....	19
Raising and Lowering Head Assembly .....	20
Adjusting / Replacing Knives .....	20
Thickness Scale Adjustment.....	22
Cutting Depth Gauge.....	22
Repeat Cut Preset.....	23
OPERATION.....	24
Power Switch.....	24
Circuit Breaker Reset .....	24
Getting Prepared .....	25
Basic Operation.....	25
Thickness Planing .....	26
General Tips and Guidelines .....	26
GENERAL RECOMMENDATIONS.....	26
Ridges .....	27
Planing Glued-Up Boards.....	27
Snipe .....	28
Planing Warped Wood.....	28
Grain Direction.....	29
Knots and Trouble Spots .....	29
Planing Rough Lumber.....	30
LUBRICATION AND MAINTENANCE .....	31
Cleaning .....	31
Hardware Tightness .....	31
Gear Lubrication .....	32
Brush Replacement.....	32
Belt Replacement .....	33

Feed Roller Inspection.....	34
PLANER PARTS DIAGRAM-A.....	35
Planer Parts List-A.....	36
MOTOR PARTS DIAGRAM-B.....	40
Motor Parts List- .....	41
TROUBLESHOOTING .....	42



## THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial Holdings LLC. We hope that you find it productive and useful to you for a long time to come.

**Inspection & Acceptance.** Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without an RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

**Specifications.** Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

**Limited Warranty.** Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (e) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

**EXCLUSION OF OTHER WARRANTIES.** THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

**Limitation of Liability.** IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



**Force Majeure.** Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

**Installation.** If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

**Work By Others; Safety Devices.** Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

**Remedies.** Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

**Attorney's Fees.** In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

**Governing Law/Venue.** This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

#### **SUMMARY OF RETURN POLICY.**

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial Holdings LLC makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial Holdings LLC reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

#### **For Customer Service & Technical Support:**

Please contact one of our knowledgeable Sales and Service team members at:  
(920) 684-4990 or e-mail us at [sales@baileighindustrial.com](mailto:sales@baileighindustrial.com)



## **INTRODUCTION**

*The quality and reliability of the components assembled on a Baileigh Industrial Holdings LLC machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.*

*Our technical staff will do their best to help you get your machine back in working order.*

### **In this manual you will find: (when applicable)**

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

## **GENERAL NOTES**

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial Holdings LLC and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



**Note:** *This symbol refers to useful information throughout the manual.*



## IMPORTANT

### PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



## SAFETY INSTRUCTIONS

### LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

### UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

**DANGER:** Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

**WARNING:** Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

**CAUTION:** Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

**NOTICE:** Indicates a situation which, if not avoided, could result in property damage.

**DANGER**

**WARNING**

**CAUTION**

**NOTICE**

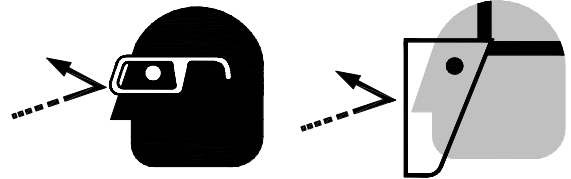


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



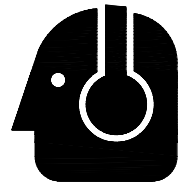
**PROTECT EYES**

Wear safety glasses or suitable eye protection when working on or around machinery.



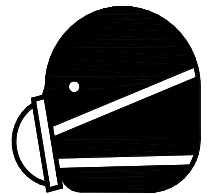
**PROTECT AGAINST NOISE**

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



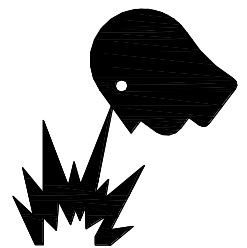
**DUST HAZARD**

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



**DUST PARTICLES AND IGNITION SOURCES**

**DO NOT** operate the table saw in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



**CUTTER HAZARD**

Keep hands and fingers away from the rotating cutter blades. These rotating cutters can be extremely dangerous if you do not follow proper safety procedures. **NEVER place hands directly over or in front of the cutter. Keep hand at least 6" (150mm) from the cutter while operating.**

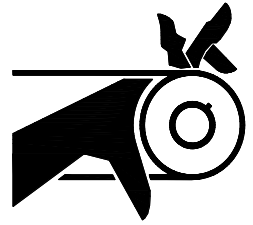






### **BEWARE OF PINCH POINTS**

**DO NOT** allow fingers to get pinched between belt and belt rollers. This may pull the operator's hand into the machine causing serious personal injury. **DO NOT** operate without guards in place.



### **Power Switch with Lock Out**

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the Power Switch paddle downward. Remove the yellow lock key to prevent the machine from starting.



**Note:** Resetting the Power Switch WILL start the machine.



### **CALIFORNIA PROPOSITION 65**

WARNING: Cancer and Reproductive Harm.  
[www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)





## **SAFETY PRECAUTIONS**



Wood working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

**REMEMBER: Your personal safety is your responsibility.**



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY**

### **Dear Valued Customer:**

- All Baileigh woodworking machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

**Please enjoy your Baileigh machine! ....Please enjoy it SAFELY!**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Overloading machine.** By overloading the machine, you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
6. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machines rated capacity.



7. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
8. This machine is designed to process wood **ONLY**.
9. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
10. **Use eye protection.** Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
11. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
12. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
13. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
14. **Keep work area clean.** Cluttered areas invite injuries.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. **Blade adjustments and maintenance.** Always keep blades sharp and properly adjusted for optimum performance.
17. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
18. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
19. **DO NOT** touch live electrical components or parts.
20. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
21. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
22. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
23. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
24. **DO NOT** bypass or defeat any safety interlock systems.



25. Keep visitors a safe distance from the work area.
26. **Machines can eject** piece parts towards the operator. Know and avoid the conditions which cause the piece part to kickback.
27. **Check** for damaged parts before using machinery. Check for binding or misaligned parts, broken parts, loose bolts, or any other conditions which may impair the machines operation. Repair or replace any damaged parts before operation.
28. **Do not stop** the spindle using your hand. Allow the spindle to stop on its own or in the case of an emergency, use the spindle brake.
29. **Disconnect power** and make sure all moving parts have come to a complete stop before changing cutting tools, starting any inspection, adjustment, or maintenance procedure.
30. **Properly secure** the cutting tool in the spindle before operating the machine.
31. **Do not remove** any warning signs.
32. **Check** safety equipment, such as safety covers, emergency stop buttons, safety mats, railings, light booms, ramps, and warning signs.
33. Dressing material edges. Always chamfer and deburr all sharp edges.
34. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well-ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.
35. **Respiratory Protection.** Wear an approved dust mask or respirator while using this machine. Continued exposure to wood dust can cause allergies or respiratory problems.
36. **Material Removal Rate.** Attempting to remove too much material at once can cause the piece part to fly out of the lathe causing **severe bodily injury**.
37. **NEVER** position fingers or thumbs near the infeed / outfeed rollers or cutterhead.
38. Long pieces of stock should **ALWAYS** be supported with some type of fixture.
39. **DO NOT** operate planer with dull or damaged blades.
40. **MAKE CERTAIN** that the planer is properly adjusted prior to use.
41. **DO NOT** try and remove excessive amounts of wood in one single pass.
42. **INSPECT** all stock before planing, ensuring that there are no foreign objects embedded in the wood, loose knots, or knots that may become loose during operation.
43. **DO NOT** attempt to remove jams until power is disconnected and all moving parts have come to a complete stop.
44. **MAKE SURE** that there is adequate operating space on both the infeed and outfeed sides of the planer before operating.
45. **DO NOT** plane wood that is less than 7" (178mm) long or less than 1/8" (3.1mm) thick.



## **TECHNICAL SPECIFICATIONS**

Motor Type	2hp, AC, Universal
Motor Power Supply	120 V, 60 Hz, AC Only, 15 Amp
Motor Speed	22000+/-10% (No Load)
Current Draw, Starting, Running (No Load)	13A, 7.1A
On/Off Switch	Toggle Switch with Removable Safety Key
Power Cord	14AWG X 3C, 6-1/2 Ft.
Power Plug Installed	5-15P (CSA/UL)
Recommended Circuit Size	20A
Sound Rating	97db at 33" (1000mm) From Motor
Maximum Cutting Width	13" (330mm)
Maximum Workpiece Thickness	6" (152mm)
Minimum Workpiece Thickness	1/8", .125" (3.1mm)
Maximum depth of cut @ 6" (152mm)	1/8", .125" (3.1mm)
Maximum depth of cut @ 13" (330mm)	1/16", .0625" (1.5mm)
Minimum Length of Stock (Unbutted)	7" (178mm)
Head Movement Per Handle Revolution	1/16", .0625" (1.5mm)
Feed Speed F/min	26FPM (7.9MPM)
Thickness Gauge Stops	1/8, 1/4, 1/2, 3/4, 1, 1-1/4, 1-1/2, 1-3/4In.
Number of Cutterhead Rows	6
Cutter Inserts / Qty	26 (2 sided), HSS Inserts
Knife Inserts, Size (L x W x T)	.55" x .55" x .078" (14 x 14 x 2mm)
Cutterhead Speed, No Load	10,000 RPM
Cutterhead Diameter	2" (50.8mm)
Overall Dimensions, Assembled (L x W x H)	42" x 22" x 19" (1066 x 558 x 482mm)
Main Table Size (L x W)	9.75" x 13" (248 x 330mm)
Feed Table Size (L x W)	12" x 14" (305 x 356mm)
Dust Port Outside Diameter	2.5" or 4" (63.5 or 101mm)
Recommended Minimum Dust Extraction	500 CFM
Main Table and Infeed/Outfeed Tables	Stainless Steel, Formed
Frame	Aluminum
Feed Rollers	Rubber
Net Weight	62lbs. (28.1kgs)
Shipping Weight	71.2lbs. (32.3kgs)
Shipping Dimensions (W x D x H)	26.77" x 16.14" x 21.26" (680 x 410 x 540mm)



## **TECHNICAL SUPPORT**

Our technical support department can be reached at 920.684.4990 and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: [sales@baileigh.com](mailto:sales@baileigh.com), Phone: 920.684.4990, or Fax: 920.684.3944.



**Note:** *The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



**Note:** *The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*



## UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

**⚠ WARNING: SUFFOCATION HAZARD!** Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.  
If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

### Cleaning

**⚠ WARNING: DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

**⚠ CAUTION:** When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

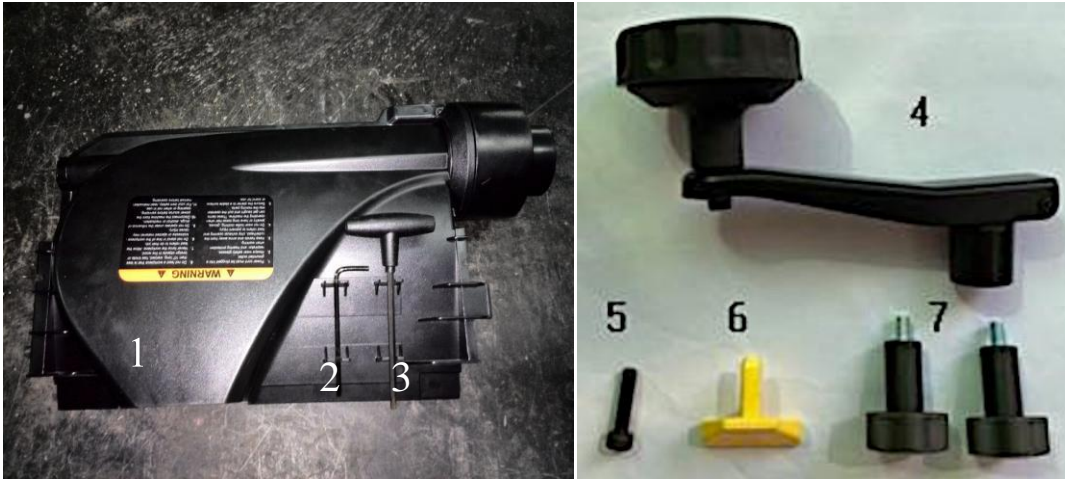
Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



**Important:** This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





1	Dust Port	1 pc
2	Hex Wrench 4mm x 100	1 pc
3	Torx Wrench	1 pc
4	Raise / Lower Handle	1 pc
5	Hex Screw M5*P0.8*20	1 pc
6	Switch Safety Key	1 pc
7	Dust Port Knob	2 pcs

## **INSTALLATION**

### **IMPORTANT:**

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- It is important to maintain free area around the machine. If any long material is machined, it is necessary to have a sufficient room for material input and output.





- **ENSURE** that the machine sits firmly before using. If the machine wobbles or is unstable, correct the problem by attaching to a bench top prior to operation.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

## GETTING TO KNOW YOUR MACHINE





Item	Description	Item	Description
A	Infeed Table	B	Depth of Cut Indicator
C	Power Switch w/Lockout	D	Raise Lower Crank Handle
E	Dust Port	F	Outfeed Table
G	Repeat Cut Quick Set	H	Thickness Scale

## ASSEMBLY AND SET UP

**⚠ WARNING:** For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

### Attaching Depth Adjustment Handle

- Attach the raise/lower adjustment handle to the shaft located on top of the planer and fasten in place with 1 Hex Socket Head screw.
- Tighten screw using supplied hex wrench.





### Attaching Dust Port

- Facing the rear of the machine, locate the dust port on the cutterhead assembly by turning 2 dust port knobs.
- To minimize sawdust accumulation on your workpiece, attach either a 2-1/2" or a 4" vacuum hose to the dust port.



### Dust Collection

It is recommended that a dust collection system be used with this planer. It should have a minimum capacity of 500 CFM. Connect a 4-inch diameter dust hose (not provided) to the port and secure with a hose clamp. If using a 2-1/2-inch dust hose, use the 4-inch to 2-1/2-inch adaptor.



**Important:** Dryer vent hose is not acceptable for the collection of wood dust and chips.



**Important:** If a dust collection system is not used, do not install the dust hood. Use of the dust hood without dust collection will hasten the gathering of chips and dust around the cutterhead area.

### Securing Planer to a Table or Workbench

During operation, if there is any tendency for the planer to tip over, slide or walk, the planer MUST be secured to a supporting surface such as a workbench or table.

- Four holes are provided (2 are shown at A below) to securely mount the planer.
- The surface you are mounting the planer on should be perfectly flat.





## ELECTRICAL

**⚠ CAUTION:** HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!  
Check if the available power supply is the same as listed on the machine nameplate.

**⚠ WARNING:** Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

### Power Specifications

Your machine is wired for 120 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is  $\pm 5\%$ , and for the frequency is  $\pm 1\%$ .

### Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machine. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

**⚠ WARNING:** In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

### **Extension Cord Safety**

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

	LENGTH		
AMP RATING	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
WIRE GAUGE			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

### **Power cord connection:**

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
  - a. Route the power cord so that it will NOT become entangled in the machine in any way.
  - b. Route the cord to the power supply is a way that does NOT create a trip hazard.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation.
5. Turn the switch OFF when the machine is not in operation.
6. Remove the yellow lock key to prevent the machine from starting.



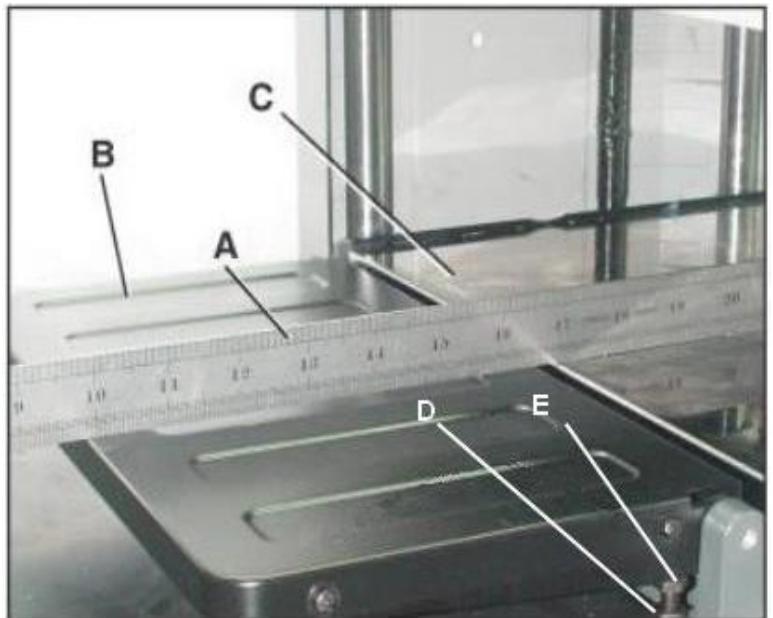
## ADJUSTMENTS

**⚠ WARNING:** Make sure the electrical disconnect is OFF before working on the machine.

### Levelling Extension Tables

The extension tables must be level with the planer table.  
To check the extension tables and adjust if necessary:

- Lay a straight edge (A) on the planer table (C) with one end of the straight edge over the infeed table (B).
- Check to make sure that the infeed table is level with the planer table.
- If an adjustment is necessary, raise table, loosen lock nuts (D) and adjust Hex Head Screws (E) on each side of the table until the infeed table is level with the planer table. This will adjust the outer edge of the table.
- Recheck for level and repeat adjustment if necessary.
- Repeat this process for leveling the outfeed table.





## Raising and Lowering Head Assembly

The head assembly consists of the cutterhead, knives, feed rollers, cutterhead guard, and the motor. Raising and lowering of the head assembly controls the depth of cut on the planer.

To adjust:

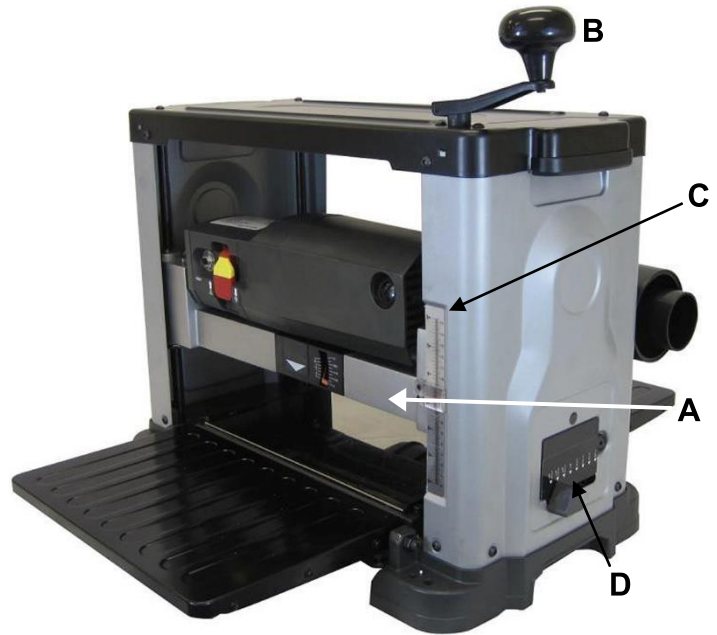
- To raise the head assembly (A), turn the adjusting handle (B) clockwise.
- To lower the head assembly, turn the adjusting handle counterclockwise.



**Note:** One revolution of the handle will move the cutterhead up or down approximately 1/16", .0625" (1.5mm). You can confirm this by referencing the scale (C) on the front right side of the planer.



**Note:** The Repeat Cut Thickness Indicator (D), located on the bottom right side of the planer, provides a simple way to preset the finished thickness of a workpiece. Slide the indicator to the desired finished thickness. Use this feature when thickness planing multiple workpieces to ensure a uniform thickness of all workpieces. Do not attempt to lower the cutterhead assembly below the preset level as damage will occur.



## Adjusting / Replacing Knives



**WARNING:** To prevent serious personal injury NEVER rotate the cutterhead by hand without protection. Cutter insert are razor sharp! Always wear heavy leather gloves when handling the cutterhead.

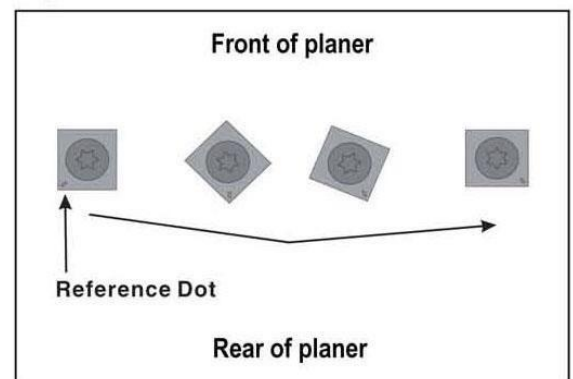
This 13" cutterhead is equipped with 26 indexable cutter inserts. Each cutter insert can be rotated to reveal one of its two cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge.

In addition, each cutter insert has a reference dot on one corner. As the cutter insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves back around to its starting position, the cutter should be replaced.



To rotate or change cutter tip inserts:

1. Face the rear of the machine. Remove the Dust Port.
2. Use the handle to lower the cutterhead assembly down to about 2" (50.8mm) on the scale.
3. Insert the supplied Hex wrench through the hole located on the side of the machine above the Repeat Cut slider.
4. Rotate the cutterhead to a position where a cutter tip is visible. (You may have to raise or lower cutterhead to be able to insert the Hex wrench into the cutterhead)
5. While holding the hex wrench to prevent cutterhead rotation, remove the cutter tip screw using the provided Torx T-wrench allowing the tip to be removed.
6. Carefully clean all dust and dirt off the cutter tip and the cutterhead seat.
7. Replace or rotate the cutter insert so a fresh sharp edge is facing outward. If available, use pitch remover to be sure all wood residue is off the cutterhead, cutter insert, and screws, before attempting to rotate or replace them. Using a shot of compressed air is also helpful. Be sure to wear safety glasses when using compressed air.
8. Lubricate the Torx screw threads with light machine oil and wipe the excess oil off the threads. Install cutter tip insert and torque the Torx screw to 48-50 inch/ pounds.



**Note:** Proper cleaning of tips and cutterhead is critical to achieving a smooth finish. Dirt or dust trapped between the cutter insert and cutterhead will slightly raise the cutter insert and make noticeable marks on your workpiece the next time you plane.

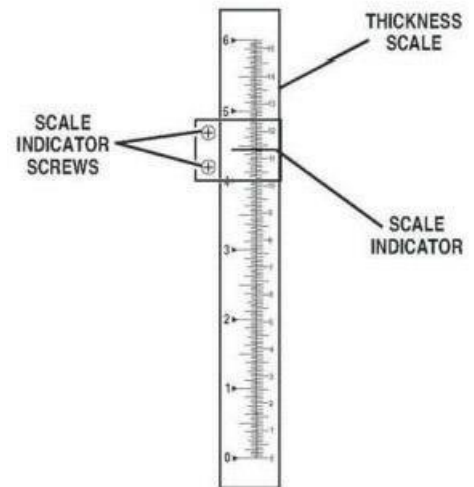




## Thickness Scale Adjustment

The thickness scale, located on the right of the planer, shows the thickness of the finished workpiece.

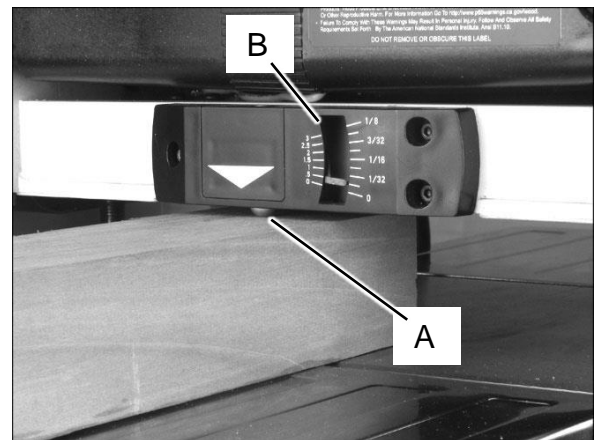
- To make sure the scale is set properly, run a piece of wood through the planer and measure the thickness of the wood.
- If the scale is out of alignment, loosen the two round head screws (A) holding the scale indicator (B) and adjust the thickness indicator to the correct setting.
- Make sure to tighten the two screws once the adjustment is complete.



## Cutting Depth Gauge

The cutting depth gauge provides a quick method for setting depth of cut. The bottom of the gauge ball has been set even with the cutterhead knives.

1. With the machine OFF, insert workpiece far enough (about 2-inches) that it lies beneath the gauge ball (A). Verify that the workpiece lies flat on table.
2. Lower the cutter head until ball contacts workpiece and engages the depth scale, as shown.
  - a. As you lower the cutter head, the needle on the depth of cut scale will move showing how much material will be removed in that pass.
3. Continue lowering until desired cut depth is shown on the scale (B). Remove the workpiece.
4. Start planer and insert workpiece, allowing it to push past gauge ball and continue feeding through machine.
5. Refer to thickness scale to lower head to desired depth of cut for the next pass.





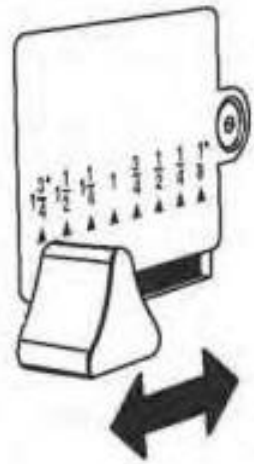
## Repeat Cut Preset

The REPEAT CUT preset, located on the right side of the planer, provides a simple way to preset the finished thickness of a workpiece.

- The indicator can be set to various thicknesses.
- Move the lever to the desired finished thickness.
- Use this feature when thickness planning multiple workpieces to ensure a uniform thickness of all workpieces.



**Note:** When lowering the head assembly, ensure the REPEAT CUT preset is in the lowest desired thickness position. Failure to do so may result in excess downward pressure by the cutterhead assembly onto the mechanism and cause damage to the adjustment rod and upper frame.





## OPERATION

**⚠ CAUTION:** Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. Never pass hands directly over the cutterhead. Always use cutterhead guard, push blocks, and keep hands away from cutterhead.



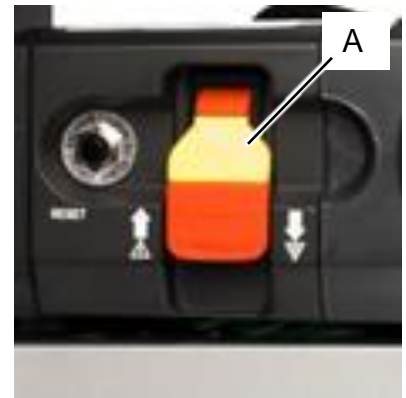
**Note:** This operations section was designed to give instructions on the basic operations of this planer. However, it is in no way comprehensive of every planing operation. It is strongly recommended that you read books, trade magazines, or get formal training to maximize the potential of your planer while minimizing the risks.



**Note:** This planer is designed to process wood ONLY.

### Power Switch

- The planer is turned on by flipping the switch into the up position and it is turned off by flipping the switch in the down position.
- This planer is also equipped with a special lockout toggle switch that prevents unauthorized use.
- To prevent unauthorized use of the planer, simply pull out the yellow key (A) located on the face of the switch.



### Circuit Breaker Reset

- The planer is equipped with a motor protective circuit breaker. The breaker will shut the planer off automatically when excessive current is consumed.

If this occurs:

- Press the OFF switch.
- Raise head and remove the workpiece.
- Allow planer to cool for a few minutes, then push reset button.
- Verify that the cutter bed is clear and restart the planer.
- Reduce the depth of cut by half of the original (example, change 1/8" to 1/16") and return to operation.
- Be sure to turn planer OFF before resetting the circuit breaker to avoid unintentional starting.



## Getting Prepared

- It is always a good idea to use a piece of scrap wood for your first planing attempt.
- Before each use of the planer, make it a habit of checking for loose fasteners, fittings or hardware.
- Turn the planer ON and allow it to reach full speed. Pay close attention to any excessively loud noises that may be coming from the planer or any excessive vibration. If either occurs, shut down the planer immediately checking again for loose hardware.

## Basic Operation



**WARNING: DO NOT stand or allow anyone else to stand directly behind infeed table while feeding material. DO NOT bend down to see how stock is feeding. Should a kickback occur, serious or fatal injury could result.**

1. Put on safety glasses and a respirator, and secure loose clothing and long hair.
2. Set the depth of cut to the desired setting.
3. Stand to either the left or right side of the planer.
4. Flip the switch to the ON position.
5. Lift the workpiece onto the infeed table by grabbing the edges of the board at the middle of the length.



**Note:** For longer pieces, be sure to use additional supports or stands.

6. Push slightly on the board to start feed and allow the feed rollers to pull the board through the planer. Once the feed rollers start to pull the workpiece through, let go of the board and allow the rollers to do their job. **DO NOT** push or pull on the workpiece once the rollers have engaged.
7. Move to one side of the rear of the planer and receive the planed workpiece by grabbing the edges of the wood like you did when feeding the workpiece in.
8. It normally takes several passes of varying depths to achieve a smooth finish, so repeat this process as many times as necessary. Remember the less you take off in a pass, the smoother the finish will be, but you may still need to finish the surface by sanding.



## **Thickness Planing**

- Thickness planing sizes the workpiece to a desired thickness, while at the same time creating a smooth and level surface. The thickness of each cut will depend on the type of wood, width of the workpiece, and condition of the lumber (i.e. dryness, grain composition, straightness, etc).
- Always make thin test cuts on a scrap piece of wood prior to performing final cuts.

## **General Tips and Guidelines**

- Thickness planing always works best when at least one side of the workpiece has a flat surface. If both sides of the workpiece are rough, feed one face of the board through the planer until the entire surface is flat.
- ALWAYS plane both sides of the workpiece to reach the desired thickness.
- DO NOT plane workpieces less than 1/8" thick, less than 3/4-in wide, or shorter than 7-in.
- It is not recommended to continuously use the planer at its maximum depth of cut (1/16") and at its full width (13") as this will shorten the life of the motor.
- Light cuts create a smoother finish than heavier cuts.


## **GENERAL RECOMMENDATIONS**

- Many variables determine suitable depth of cut, such as wood width, density, grain structure, dampness, etc. For best results, use shallow cuts and multiple passes. Excessive depth of cut will place undue strain upon the motor.
- Use shallower cuts on wider workpieces.
- A thickness planer works best when the lumber has at least one flat surface. Use a jointer to create a flat surface. If this is not possible, make several passes of the same surface through the planer until it is flat. Then flip the material over to plane the opposite surface.
- Plane alternate sides until desired thickness is obtained. When half of the total cut has been taken from each side, the board will have a uniform moisture content and additional drying will not cause it to warp.
- Make a test cut on scrap wood to verify thickness; check its accuracy before working on the finished product.
- Avoid knots. Heavily cross-grained wood makes knots hard. Knots can come loose and jam the knives.
- Do not plane dirty boards; dirt and small stones are abrasive and will wear out the knife inserts and may become projectiles.
- Do not plane boards less than 7 inches long. It is recommended that when planing short boards you butt them end-to-end to avoid kickback and reduce snipe.



- For optimum planing performance, the depth of cut should be less than 1/16”.
- Recommended maximum depth of cut:
  - Hard/Softwood up to 5-1/2” wide.....1/8”
  - Hard/Softwood 5-1/2 to 13” wide.....1/16”

### Ridges

 **WARNING:** Do not attempt to plane second-hand lumber, painted or varnished wood, plywood or particle board. These materials can damage planer knives. Failure to comply may cause serious injury.

- Damaged or nicked knives can leave ridges along the length of a board.
- Always inspect each board carefully before attempting to plane it.
- Do not attempt to plane second-hand lumber with nails below the surface, painted wood, plywood, hardboard, wood with a glue bead, or any material other than solid wood.

### Planing Glued-Up Boards

**NOTICE:** Glued-up stock must dry at least 24 hours before being planed. Failure to comply may cause the stock to separate in the planer, leading to kickback and serious injury.

This planer is designed for planing solid wood. Other material, including glue, will dull or damage the knives. However, when you need to “true-up” glued-together stock, follow these suggestions.

- As you glue the stock, scrub off all the glue on the surface with a wet rag. This prevents glue beads from forming on the wood surface. Allow the glue to dry at least 24 hours. Check the surface for any glue that you missed and remove with a scraper, chisel, or sander.
- Set the cutterhead for a shallow depth of cut. When you are finished planing the glued-up board, unplug the planer and check planer knives for built-up pitch or other signs of wear.



## Snipe

Snipe refers to a depression at either end of the board caused by an uneven force on the cutterhead when the work is entering or leaving the planer. Snipe may occur when the board is not supported properly or when only one feed roller is in contact with the board at the beginning or end of the cut.

- If the snipe is deep, be more careful how the board is supported. Keep it parallel to and flat on the table at all times. Use an extra support, such as a roller stand, at both the infeed and outfeed ends of the planer.
- Other methods to prevent snipe are reducing the depth of cut, and feeding additional boards butted closely to leading and trailing ends of the workpiece.
- If snipe cannot be avoided, cut the material longer than needed and trim the ends after planing.

## Planing Warped Wood

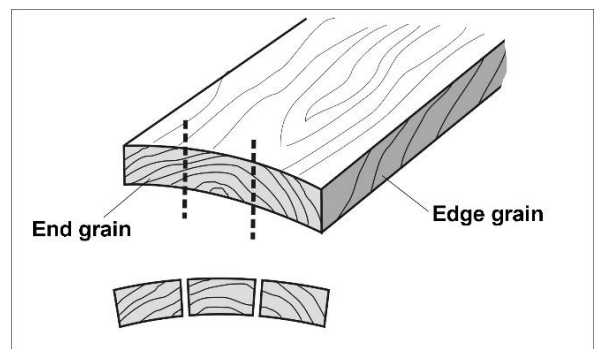


**CAUTION:** Do not attempt to plane a board which is warped along its length. A warped board can jam itself against the cutterhead knives resulting in kickback and/or damage to the planer.



**Note:** If a significantly cupped board is fed into the planer, the feed rollers will press it flat for the pass, but the wood will spring back into cupped form when it has cleared the rollers. For best results, one side of the material should be run through a jointer to achieve a flat surface prior to planing. However, if a board is only moderately cupped you may attempt to plane it.

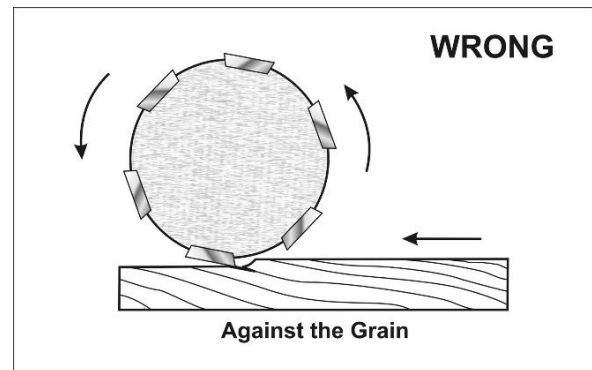
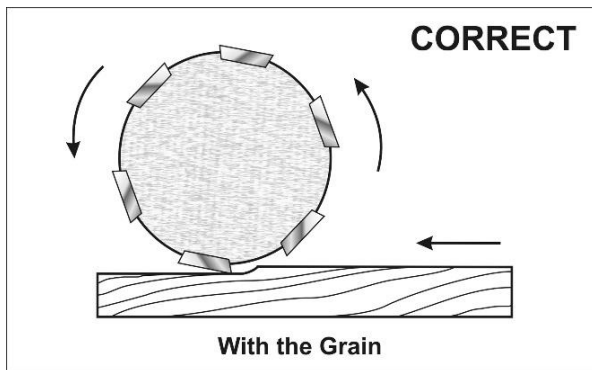
- If the board is narrow enough, consider using a table saw or band saw to rip the top of the warp before planing the board. If this is not practical, feed the board into the planer concave side down and plane the top of the board until it presents a flat surface.
- Turn the board over and plane the bottom edges until they are flush with the middle. After planing the board, use a table saw or band saw to square the board's edges with the top and bottom surfaces.
- Cupping can often be diminished by ripping the board into narrower pieces on a table saw or band saw.





## Grain Direction

- Always feed the board so the knives are cutting in the same direction as the wood grain. If you cut against the grain, the wood can “chip out” leaving an undesirable finish.
- TIP: On rough lumber, you may need to rip one edge on a table saw or band saw to more easily observe a board’s grain direction. Also, the grain on some wood species may change direction in the middle of the board. If possible, cut the board in the middle so the grain direction will be consistent on both pieces. Otherwise, use personal judgment as to which direction is more favorable, and safer, for feeding.
- Edge grain may be planed if the stock is wide enough to rest firmly upon the table.
- Do not attempt to plane end-grain as this can result in splintering of the stock and potential kickback.



## Knots and Trouble Spots

Wood with knots, “wild” grain, or extensive figuring is always difficult to surface and requires extra care.

- Check that any knots are solid.
- Do not plane stock with loose knots.
- Take light cuts.
- Be especially cautious of kickbacks and stop cutting immediately if the board will not feed smoothly.





## Planing Rough Lumber

**NOTICE:** Make sure wood is properly dried before planing. Wet or “green” lumber may clog the machine and lead to damage.

Air dried wood should stand for at least a year per inch of thickness of the rough-cut stock. The moisture content of air-dried wood should be about 12% to 15%. Kiln dried woods should have a moisture content of approximately 10%. Wood to be used in fine furniture should have a moisture content of 7% to 8%.

- Joint one edge of the rough-cut lumber before planing. This will help you determine the direction of grain travel. Feed the board into the planer so the knives cut with the grain.
- Measure the rough lumber at several locations to find the thickest part. As wood dries, its dimensions vary, including its thickness. Set the planer to take a very shallow cut on the highest, thickest part of the board. Continue to take very shallow cuts until you can determine whether there are any knots or unusual grain patterns.
- After completing one side, inspect the opposite side for irregularities, then process it using the same procedure as for the first side.



## LUBRICATION AND MAINTENANCE



**WARNING:** Make sure the electrical disconnect is OFF before working on the machine.

Maintenance should be performed on a regular basis by qualified personnel.

Always follow proper safety precautions when working on or around any machinery.

### Daily Maintenance

- Do a general cleaning by removing dust and chips from the machine.
- Check and tighten any loose mounting bolts.
- Sharpen or replace any worn or damaged tooling.
- Inspect the power plug and cord.
- Keep area around machine clear of debris.
- Check for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.

### Cleaning

Sawdust buildup and other debris can cause the machine to plane incorrectly. Periodic cleaning and waxing is needed for accurate precision planning. Any moving parts should be cleaned regularly with penetrating oil and lubricated with a light coating of medium weight machine oil.

With the machine unplugged, blow off motor with low pressure air to remove dust or dirt. Air pressure above 50 P.S.I. should not be used as high-pressured air may damage insulation. The operator should always wear a respirator and eye protection when using compressed air. Do not allow chips and dust to accumulate under the machine. Keep area clean and in safe order.



**Note:** When cleaning chips and debris from the machine, use a brush and a shop vacuum. **DO NOT** blow off the machine with compressed air. The force of the compressed air may force chips into critical mechanisms or may inflict injury to yourself or others.

Periodically clean, wax, and buff the tables. This will aid in the prevention of improper feeding of the work piece.

### Hardware Tightness

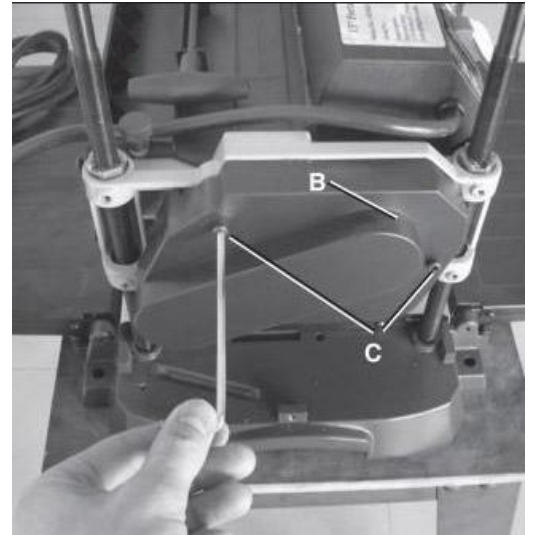
Periodically check all clamps, nuts, bolts, and screws, for tightness and condition. Stop the machine and recheck the cutterhead screw and knives, or tips, for tightness after about 50 hours of operation.



## Gear Lubrication

The gears in the gear box should be lubricated periodically.

1. Facing the front of the machine, remove the raise/ lower handle.
2. Remove the 9 screws holding the top cover on the machine. 5 screws are located on top and 4 on the upper sides. Remove the top cover.
3. On the left side panel, remove the 4 socket head screws located around the bottom edge and remove the side panel to expose the gearbox cover.
4. Remove the two screws (C) to remove the gear box cover (B) and access the gear box.
5. Replace all covers, panels, and guards that you removed once lubrication is complete.

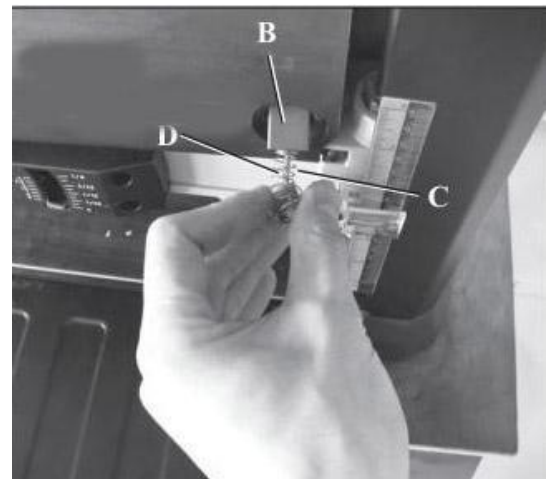


## Brush Replacement

Brush life will vary depending on the load placed on the motor. The brushes should be inspected every 20-30 hours of motor run time.

To inspect or replace:

1. Remove the brush holders, one of which is shown at (A). The other is located in the same position on the rear of the motor assembly. The Brush Holder can be removed using a flat blade screwdriver.
  2. Once the brush has been removed, inspect the carbon (B), the spring (C), and the wire (D).
- If the carbon of either brush is worn down to 3/16" or less, both brushes should be replaced.
  - Also, if the spring or wire are burned or damaged in any way, both brushes should be replaced.



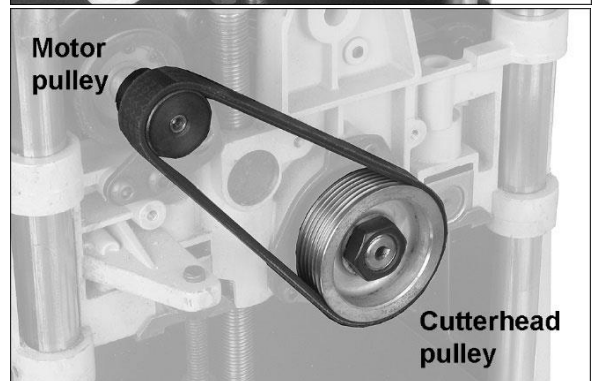
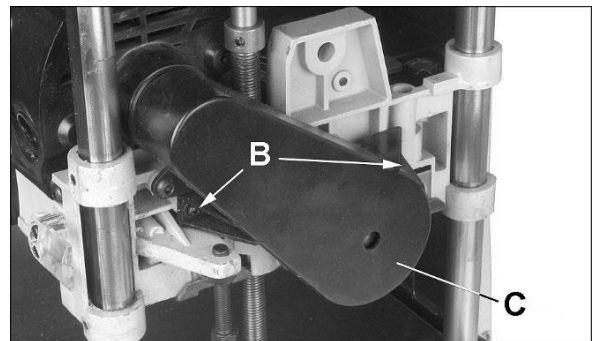
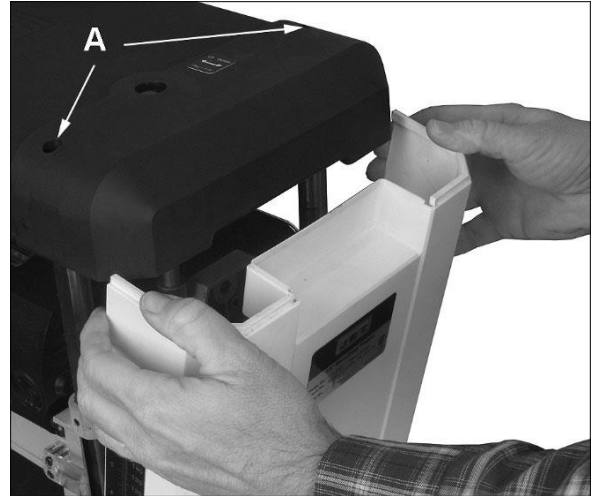


## **Belt Replacement**

- Inadequate tension on the V-belt will cause the belt to slip from the motor pulley or the cutterhead pulley.

A loose belt must be replaced, as follows.

1. Disconnect planer from power source; unplug.
2. Remove crank handle.
3. Unscrew the two screws on the right side of the top plate (A) with a 5mm hex wrench; a T-handle wrench is preferred for this. The screws do not need to be removed, only released from the tops of the columns.
4. Carefully maneuver the right-side cover from beneath the top plate. Then lift the side cover out of the groove in the planer base.
5. Remove two screws (B) with Phillips screwdriver, and remove belt guard (C).
6. Remove belt by walking the belt from the motor and cutterhead pulleys alternately. Gently pull the belt while turning the pulleys at the same time.
7. Walk the new belt on to the pulleys in the reverse procedure from that above. The belt should fit snugly in the grooves of both pulleys.
8. Install belt guard, side cover, and tighten screws in top plate.
9. Install crank handle.





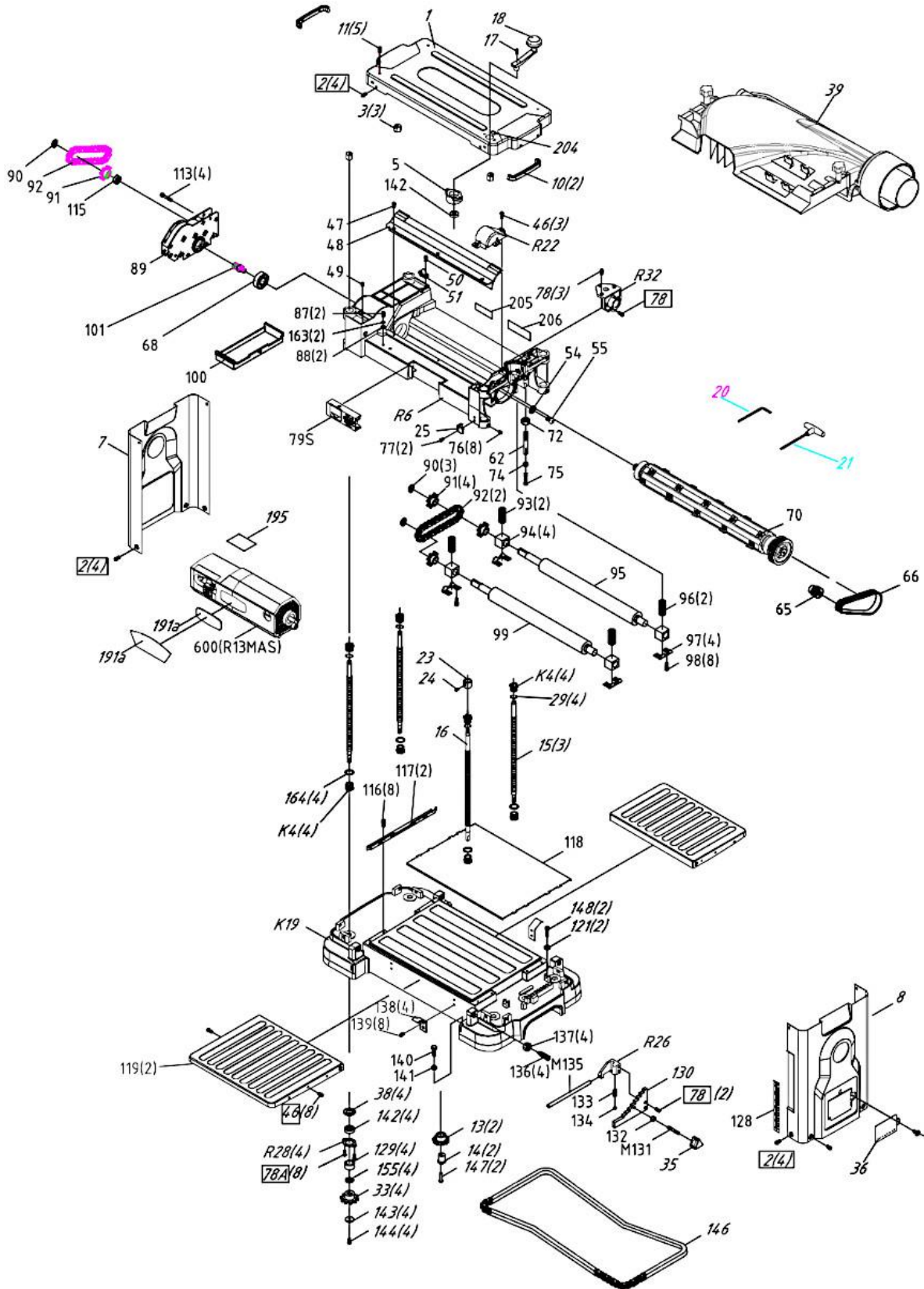
### **Feed Roller Inspection**

The feed rollers are made of a rubber material and should be inspected after every hour of operation:

1. Disconnect planer from power source; unplug.
2. Lower head until you see the hexagonal recess in center of cutterhead shaft through the access hole.
3. Insert 4mm hex wrench through hole and into recess. Use this wrench to rotate cutterhead and rollers during the inspection process.
4. Inspect both rollers for sawdust and wood chips.
5. To remove sawdust or wood chips, first use a soft brush. If chips or dust remain, use a soft cloth with a mild cleaner. Do not touch feed rollers with sharp or abrasive objects or use harsh solvents. Keep hands away from knife inserts.



# PLANER PARTS DIAGRAM-A





## Planer Parts List-A

Item	Part No.	Description	Qty
1	IP1306-A1	Top Cover	1
2	IP1306-A2	Screw Hex Socket Button Head M6xP1.0x8L	12
3	IP1306-A3	Retainer Bearing for Top Cover	3
K4	IP1306-AK4	Elevation Nut	8
5	IP1306-A5	Retainer Bearing for Top Cover	1
6	IP1306-A6	Upper Frame	1
7	IP1306-A7	Left Side Panel RAL5009	1
8	IP1306-A8	Right Side Panel RAL5009	1
9	IP1306-A9	Knob	2
10	IP1306-A10	Handle Bar	2
11	IP1306-A11	Screw Hex Socket Button Head M6xP1.0x10L	5
12	IP1306-A12	Screw Pan Cr Tap M3xP1.0x16L	2
13	IP1306-A13	Idler	2
14	IP1306-A14	Idler Shaft	2
15	IP1306-A15	Spindle	3
16	IP1306-A16	Height Adjust Spindle	1
17	IP1306-A17	Hex Socket Head Screw M5xP0.8x20L	1
18	IP1306-A18	Hand Knob Assembly 18a~18f	1
K19	IP1306-AK19	Base	1
20	IP1306-A20	Hex Wrench 4mmX100L	1
21	IP1306-A21	Torx Wrench T25	1
R22	IP1306-AR22	Belt Guard	1
23	IP1306-A23	Spacer	1
24	IP1306-A24	Screw M5xP0.8x5L, SCM3	1
25	IP1306-A25	Pointer H=17.5	1
R26	IP1306-AR26	Block Guard	1
R27	IP1306-AR27	Cutterhead Pulley	1
R28	IP1306-AR28	Plate	4
29	IP1306-A29	Washer Ø19.95xØ28x0.5T	4
R32	IP1306-AR32	Handwheel Bracket	1
33	IP1306-A33	Chain Wheel	4
35	IP1306-A35	Knob	1
36	IP1306-A36	Right Side Cover	1
37	IP1306-A37	Screw M6XP1.0X12L	1



Item	Part No.	Description	Qty
38	IP1306-A38	Special Washer Ø12.5xØ25.8, S45C	4
39	IP1306-A39	Dust Hood Assembly	1
46	IP1306-A46	Phillips Screw M4XP0.7X10L	3
47	IP1306-A47	Screw M5XP0.8X8L	3
48	IP1306-A48	Chip Deflector	1
49	IP1306-A49	Screw M5XP0.8X8L	1
50	IP1306-A50	Screw M5XP0.8X10L	1
51	IP1306-A51	Cord Clamp GCL-5/16 S	1
54	IP1306-A54	Washer Ø8.5xØ18x2T	1
55	IP1306-A55	Hex Socket Button Screw M8xP1.25x20L	1
61	IP1306-A61	Key 5X12L	1
62	IP1306-A62	Thickness Adjusting Rod Ø12x59L, Ø7 Hole	1
63	IP1306-A63	Retainer Bearing	1
65	IP1306-A65	Motor Pulley	1
66	IP1306-A66	V-Belt 135J6	1
70	IP1306-A70	Helical Cutterhead	1
	IP1306-TCI	Tungsten Carbide Insert Set (10pcs/set) req. 3 sets	26
	IP1306-TS	Torx Screw M5xP0.8x9.6L	26
72	IP1306-A72	Hex Nut M10 X14XP1.5	1
74	IP1306-A74	Hex Nut M5XP0.8	1
75	IP1306-A75	Adjust Screw M5XP0.8X25L	1
76	IP1306-A76	Screw M5XP0.8X6L	8
77	IP1306-A77	Phillips Button Screw M3XP0.5X22L	2
78	IP1306-A78	Hex Socket Button Screw M5xP0.8x12L	10
78A	IP1306-A78	Hex Socket Button Screw M5xP0.8x12L	8
79S	IP1306-A79S	Pointer 79~82,84~86.	1
83	IP1306-A83	Phillips Screw M4xP0.7x10L	9
87	IP1306-A87	Screw Pan Cr Tytt M5X8L	2
88	IP1306-A88	Lock Washer External M5	2
89	IP1306-A89	Gear Box 102~114,150~153,113	1
90	IP1306-A90	C-Ring STW15	3
91	IP1306-A91	Chain Wheel 8Ø15	4
92	IP1306-A92	Chain #410-26	2
93	IP1306-A93	Spring	2
94	IP1306-A94	Block Bearing	4
95	IP1306-A95	Outfeed Roller	1



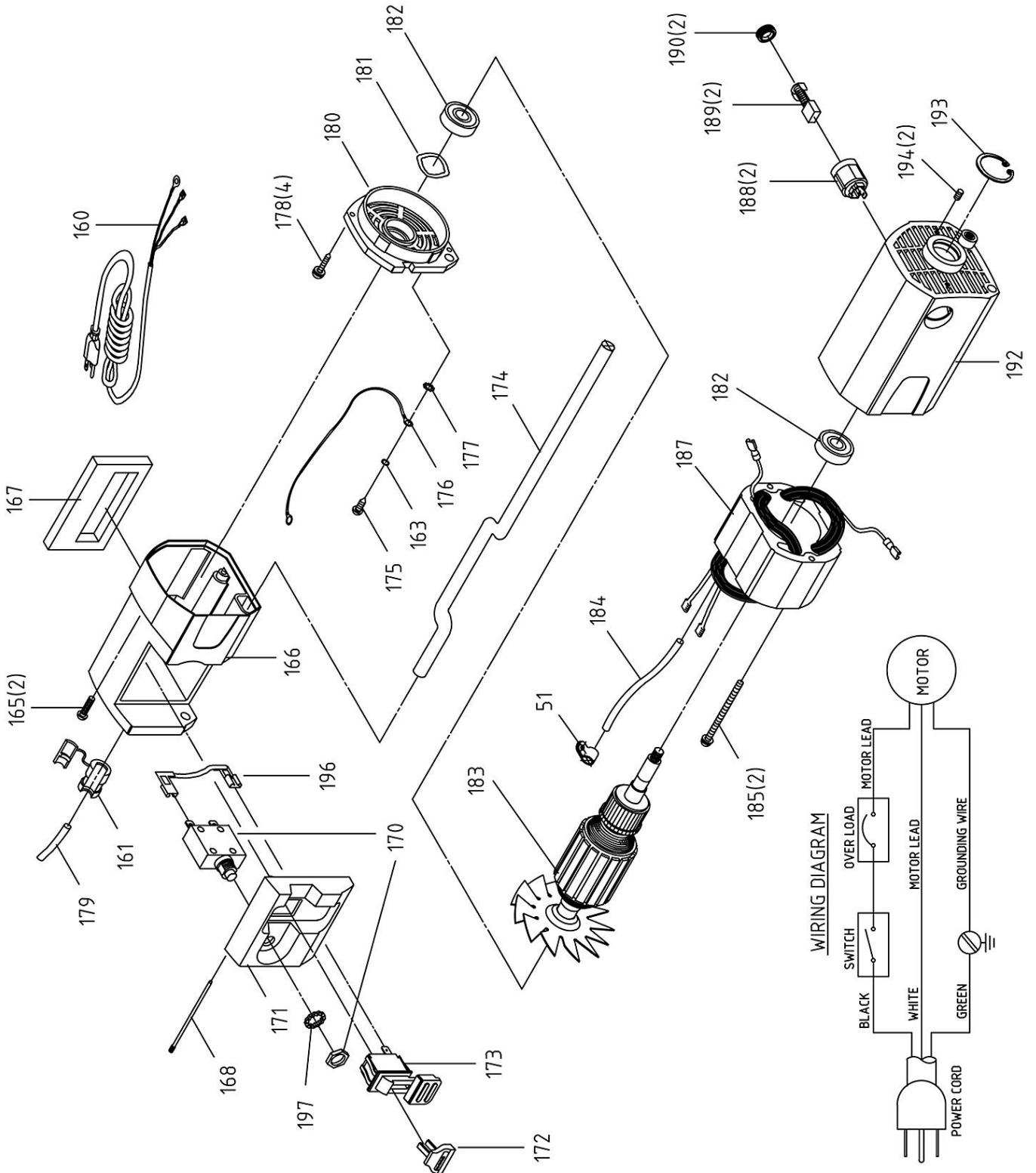


Item	Part No.	Description	Qty
96	IP1306-A96	Spring	2
97	IP1306-A97	Plate Retainer	4
98	IP1306-A98	Screw Hex Socket Cap M5XP0.8X10L	8
99	IP1306-A99	Infeed Roller	1
100	IP1306-100	Gear Box Cover	1
101	IP1306-A101	Gear (12t) 12T	1
113	IP1306-A113	Screw Sems L/Wash M5XP0.8X35L	4
115	IP1306-A115	Spacer Ø15xØ20x7	1
116	IP1306-A116	Screw Sems W/Wash M5XP0.8X10L	8
117	IP1306-A117	Rail Guide	2
118	IP1306-A118	Plate Wear	1
119	IP1306-A119	Extension Table 12" x 14"	2
121	IP1306-A121	Washer Ø5.3xØ12x1.5T	2
128	IP1306-A128	Scale	1
129	IP1306-A129	Spacer Ø10.5xØ18x12T	4
130	IP1306-A130	Step Block	1
131	IP1306-A131	Step Block Pin	1
132	IP1306-A132	Hex Nut M6XP1.0	1
133	IP1306-A133	Spring Ø7.62XØ15.75XØ0.7	1
134	IP1306-A134	Steel Ball 10MM	1
135	IP1306-A135	Pivot Rod	1
136	IP1306-A136	Adjust Screw M10xP1.5	4
137	IP1306-A137	Hex Nut M10xP1.5	4
138	IP1306-A138	Spring Flat	4
139	IP1306-A139	Screw SEMS L/Washer M5xP0.8x10L	8
140	IP1306-A140	Hex Screw M6XP1.0X25L	4
141	IP1306-A141	Hex Nut M6XP1.0	4
142	IP1306-A142	Ball Bearing 6000ZZ	5
143	IP1306-A143	Washer Ø4.2xØ15x2T	4
144	IP1306-A144	Screw Hex Socket Cap M4XP0.7X12L	4
146	IP1306-A146	Chain #410-116	1
147	IP1306-A147	Hex Socket Button Screw M5XP0.8X25L	2
148	IP1306-A148	Screw Hex Socket Cap M5XP0.8X16L	2
155	IP1306-A155	Washer Ø10.3xØ18x1T	4
163	IP1306-A163	Spring Washer Ø5.3xØ8x1T	2
164	IP1306-A164	Flat Washer Ø19.8xØ23.5x0.8T	

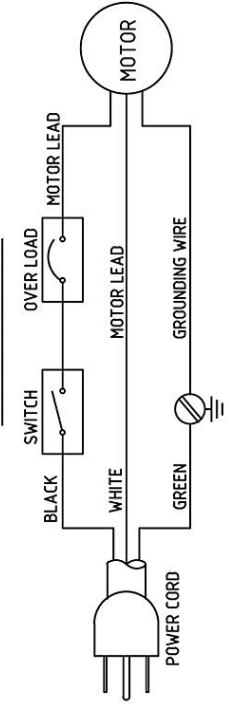


Item	Part No.	Description	Qty
191	IP1306-A191	Logo Label Baileigh	1
195	IP1306-A195	Specification Label	1
198	IP1306-A198	Side Label	1
203	IP1306-A203	Safety Warning Label	1
600	IP1306-A600	Motor/Switch Assembly 120V/60Hz	1

# MOTOR PARTS DIAGRAM-B



WIRING DIAGRAM





**Motor Parts List-**

Item	Item	Description	Qty.
51	IP1306-B51	Clamp Cord GCL-5/16 S	1
160	IP1306-B160	Cord W/Plug 2150mm	1
161	IP1306-B161	Strain Relief HALO (6P3-4)	1
163	IP1306-B163	Spring Washer $\phi$ 5.3x $\phi$ 8x1t	1
165	IP1306-B165	Screw Pan Hd Cr M5X20L	2
166	IP1306-B166	Motor Housing (Rear)	1
167	IP1306-B167	Gasket Foam	1
168	IP1306-B168	Screw Special	1
170	IP1306-B170	Overload Switch 20A	1
171	IP1306-B171	Bezel Switch	1
172	IP1306-B172	Key Switch	1
173	IP1306-B173	Switch	1
174	IP1306-B174	Rod Motor Pivot	1
175	IP1306-B175	Pan Hd Screw W/Washer M5x8L	1
176	IP1306-B176	Lead Wire 300mm	1
177	IP1306-B177	Lockwasher External M5	1
178	IP1306-B178	Screw Sems L/Washer M4.2x20L	4
179	IP1306-B179	Heat Shrinkable Tubing $\phi$ 6*5cm	1
180	IP1306-B180	Motor End Cap	1
181	IP1306-B181	Washer Spring Wavy	1
182	IP1306-B182	Bearing Ball 6201LLB	2
183	IP1306-B183	Armature Assembly	1
185	IP1306-B185	Screw Sems L/Wash M4.8x75L	2
187	IP1306-B187	Field Assembly	1
188	IP1306-B188	Holder Brush	2
189	IP1306-189	Brush	2
190	IP1306-B190	Cap Brush	2
192	IP1306-B192	Motor Housing (Front)	1
193	IP1306-B193	Ring Retaining RTW32	1
194	IP1306-B194	Screw Hex Socket Set M5x12L	2
196	IP1306-B196	Lead Wire 80mm	1
197	IP1306-B197	Lockwasher External	1



## TROUBLESHOOTING

**⚠ WARNING:** Make sure the electrical disconnect is **OFF** before working on the machine.

PROBLEM	LIKELY CAUSE	SOLUTION
Planer will not start.	No incoming power.	Check plug connection.
	Low voltage.	Have power line inspected for proper voltage.
	Circuit breaker on planer motor tripped.	Allow motor to cool and press reset switch.
	Fuse blown or breaker tripped at panel.	Check power source. Replace fuse or reset breaker.
	Motor brushes worn or damaged.	Inspect and replace brushes if needed.
	Short circuit in line cord or plug.	Inspect cord or plug for damaged insulation and shorted wires.
	Defective or loose switch or wiring.	Have a qualified electrician inspect switch and wiring.
	Motor failure.	Have motor inspected by qualified personnel.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
Motor stalls or overheats, resulting in tripped breaker.	Motor overloaded.	Reduce load on motor; try less depth of cut or slower feed rate. Make sure knife inserts are sharp.
	Low voltage.	Correct the low voltage conditions.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
	Motor failure.	Have motor inspected by qualified personnel.
Machine slows when operating.	Feed rate too fast or cutting too deeply.	Select lower feed rate, or shallower depth of cut.
	Drive belt is loose (stretched).	Replace belt.
	Motor brush failure.	Inspect and replace brushes if needed.
Snipe.	Dull knife inserts.	Rotate or replace knife inserts.
	Inadequate support of long boards	Use an assistant or roller stand to support long workpieces.
	Lumber is not butted properly.	Butt each piece of stock end-to-end as they pass through the planer.
	Cutterhead not parallel to table.	Contact Baileigh technical service.



PROBLEM	LIKELY CAUSE	SOLUTION
Fuzzy grain.	Wood has high moisture content.	Remove moisture by drying or use different stock.
	Dull knife inserts.	Rotate or replace knife inserts.
Torn grain.	Too heavy a cut.	Remove less material.
	Knives cutting against grain.	Cut with the grain.
	Dull knife inserts.	Rotate or replace knife inserts.
Rough/raised grain.	Dull knife inserts.	Rotate or replace knife inserts.
	Too heavy a cut.	Reduce depth of cut and make more passes.
	Wood has high moisture content.	Remove moisture by drying or use different stock.
Poor feeding of lumber.	Excessive warpage of stock.	Use different stock.
	Planer bed rough or dirty.	Clean pitch and residue; wax planer bed.
	Feed roller surfaces are dirty.	Clean feed rollers with cloth and mild cleaner.
	Dull knives, or debris building up on cutterhead.	Clean cutterhead; rotate or replace knife inserts; clean out dust hood if being used.
	Drive belt slipping or damaged.	Replace belt.
Uneven depth of cut side to side.	Knife projection not uniform.	Inspect all knife inserts for positioning and tightness.
	Table not parallel to cutterhead.	Contact Baileigh technical service.
Head difficult to adjust.	Lack of lubrication on corner posts and lead screws.	Lubricate posts and lead screws.
Head cannot be lowered.	Thickness gauge is preventing further movement.	Reset thickness gauge dial setting.
	Buildup of debris on leadscrews and/or columns.	Clean affected areas, and re-grease.
Board thickness doesn't match thickness scale.	Thickness scale out of adjustment.	Recalibrate thickness scale/cursor and make test cuts.
Chain keeps coming off sprocket(s).	Chain or sprocket(s) are worn.	Inspect and replace as needed.

\*Warning: Some corrections may require a qualified electrician.



NOTES



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