

## Original Instructions

# PT107 10" x 7" Heavy Duty Planer Thicknesser

Version 3.2  
April 2022



To register this product please visit  
**[www.recordpower.info](http://www.recordpower.info)**

It is important to register your product as soon as possible in order to receive efficient after sales support and be entitled to the full **5 year guarantee**. Your statutory rights are not affected.  
Please see back cover for contact details.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

### Important

For your safety read instructions carefully before assembling or using this product.

Save this manual for future reference.

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# 1. Explanation of Symbols

**THE SYMBOLS AND THEIR MEANINGS SHOWN BELOW MAY BE USED THROUGHOUT THIS MANUAL. PLEASE ENSURE THAT YOU TAKE THE APPROPRIATE ACTION WHEREVER THE WARNINGS ARE USED.**

## **Mandatory Instructions**



Read and fully understand the instruction manual before attempting to use the machine.



Indicates an instruction that requires particular attention



Wear protective eyewear



Use respiratory protective equipment



Use hearing protection



Use suitable protective footwear



Use protective work gloves

## **Warning**



Indicates a risk of severe personal injury or damage to the machine



Indicates a risk of severe personal injury from electrical shock



Risk of personal injury from lifting of heavy items



Indicates a risk of severe personal injury from airborne objects



Risk of fire

# 2. General Health & Safety Guidance

**Ensure that you carefully read and fully understand the instructions in this manual before assembly, installation and use of this product. Keep these instructions in a safe place for future reference.**

**WARNING:** for your own safety, do not attempt to operate this machine until it is completely assembled and installed according to these instructions.

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

## Safe Operation

### 1. Use Personal Protective Equipment (PPE)

- The operation of any machine can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Protective eyewear or other suitable eye protection or face shield should be used at all times. Everyday spectacles only have impact resistant lenses. They are not protective eyewear and do not give additional lateral protection.
- Use respiratory protective equipment (dust mask etc.) if the machining operation creates dust. Exposure to high levels of dust created by machining hardwoods, softwoods and man made composite boards can result in serious health problems. Some imported hardwoods give off highly irritating dust, which can cause a burning sensation. The use of respiratory protective equipment should not be seen as an alternative to controlling the risk of exposure at source by using adequate dust extraction equipment.
- The use of ear plugs or ear defenders is recommended when the machine is in use, particularly if the noise level exceeds 85 dB.
- Wear suitable protective gloves when handling cutting tools or blades. Gloves should NOT be worn when using the machine as they can be caught in moving parts of the machine.
- Non-slip safety footwear is recommended when using the machine and handling large work pieces.

### 2. Dress appropriately

- Do not wear loose clothing, neckties or jewellery; they can be caught in moving parts of the machine.
- Roll up long sleeves above the elbow.
- Wear protective hair covering to contain long hair.

### 3. Safety warnings

- Find and read any warning labels on the machine
- It is important that any labels bearing health and safety warnings are not removed, defaced or covered. Replacement labels can be obtained by contacting our Customer Service Department.

### 4. Familiarise yourself with the machine

- If you are not thoroughly familiar with the operation of this machine, obtain advice from your supervisor, instructor, or other qualified person or contact your retailer for information on training courses. Do not use this machine until adequate training has been undertaken.

### 5. Take care when moving or positioning the machine

- Some machines can be very heavy. Ensure the floor of the area in which the machine is to be used is capable of supporting the machine.
- The machine and its various components can be heavy. Always adopt a safe lifting technique and seek assistance when lifting heavy components. In some cases it may be necessary to use mechanical handling equipment to position the machine within the work area.
- Some machines have optional wheel kits available to allow them to be manoeuvred around the workshop as required. Care should be taken to install these according to the instructions provided.
- Due to the nature of the design of some machines the centre of gravity will be high making them unstable when moved. Extreme care should be taken when moving any machine.
- If transportation of the machine is required then all precautions relating to the installation and handling of the machine apply. In addition, ensure that any vehicles or manual handling equipment used for transportation

are of adequate specification.

### 6. The machine should be level and stable at all times

- When using a leg stand or cabinet base that is designed to be fitted to the machine, always ensure that it is securely fastened to the machine using the fixings provided.
- If the machine is suitable to be used on a workbench, ensure that the workbench is well constructed and capable of withstanding the weight of the machine. The machine should always be securely fastened to the workbench with appropriate fixings.
- Where possible, floor standing machines should always be secured to the floor with fixings appropriate to the structure of the floor.
- The floor surface should be sound and level. All of the feet of the machine should make contact with the floor surface. If they do not, either re-locate the machine to a more suitable position or use packing shims between the feet and the floor surface to ensure the machine is stable.

### 7. Remove adjusting keys and wrenches

- Ensure that all adjusting wrenches and keys are removed before switching the machine 'ON'. There is a risk of severe personal injury or damage to the machine from airborne objects.

### 8. Before switching the machine 'ON'

- Clear the machine table of all objects (tools, scrap pieces etc.)
- Make sure there is no debris between the work piece and the table / work support.
- Ensure that the work piece is not pressed against, or touching the saw blade or cutting tool.
- Check all clamps, work holding devices and fences to ensure that they are secure and cannot move during machining operations.
- Plan the way that you will hold and feed the work piece for the entire machining operation.

### 9. Whilst machining

- Before starting work, watch the machine while it runs. If it makes an unfamiliar noise or vibrates excessively, switch the machine 'OFF' immediately and disconnect it from the power supply. Do not restart until finding and correcting the source of the problem.

### 10. Keep the work area clear

- Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely operate your machines in any foreseeable operation.

- Cluttered work areas and benches create the risk of accidents. Keep benches clear and tidy away tools that are not in use.

- Ensure that the floor area is kept clean and clear of any dust and debris that may create trip or slip hazards.

### 11. Consider the work area environment

- Do not expose the machine to rain or damp conditions.
- Keep the work area well lit and ensure that there is artificial lighting available when there is insufficient natural light to effectively light the work area. Lighting should be bright enough to eliminate shadow and prevent eye strain.
- Do not use the machine in explosive environments eg. in the presence of flammable liquids, gases or dust.
- The presence of high levels of dust created by machining wood can present a risk of fire or explosion. Always use dust extraction equipment to minimise the risk.

### 12. Keep other persons away (and pets)

- The machine is designed to be used by one person only.
- Do not let persons, especially children, touch the machine or extension cable (if used) and keep visitors away from the work area.
- Never leave the machine running unattended. Turn the power supply off and do not leave the machine unattended until it comes to a

## 2. General Health & Safety Guidance cont.

complete stop.

- If the work area is to be left unattended, all machinery should be switched 'OFF' and isolated from the mains power supply.

### 13. Store machines safely when not in use

- When not in use, machines should be stored in a dry place, out of reach of children. Do not allow persons unfamiliar with these instructions or with the machine to operate it.

### 14. Do not overreach

- Choose a working position that allows your body to remain balanced and feed the work piece in to the machine without overreaching.
- Keep proper footing and balance at all times.

### 15. Electrical supply

- Electrical circuits should be dedicated to each machine or large enough to handle combined motor amp loads. Power outlets should be located near each machine so that power or extension cables are not obstructing high-traffic areas. Observe local electrical guidelines for proper installation of new lighting, power outlets, or circuits.
- The machine must be connected to an earthed power supply.
- The power supply must be equipped with a circuit breaker that provides short circuit, overload and earth leakage protection.
- The voltage of the machine must correspond to the voltage of the mains power supply.
- The mains plug fitted to the machine should always match the power outlet. Do not modify the plug in any way. If a replacement plug is required it should be fitted by a competent person and of the correct type and rating for the machine.
- If you are unsure about any electrical connections always consult a qualified electrician.

### 16. Avoid unintentional starting of the machine

- Most machines are fitted with a no-volt release (NVR) switch to prevent unintentional starting. If in doubt always ensure the machine switch is in the 'OFF' position before connecting it to the power supply. This means the machine will not automatically start up after a power cut or switching on of the power supply, unless you first reset the start switch.

### 17. Outdoor use

- Your machine should not be used outdoors.

### 18. Extension cables

- Whenever possible, the use of extension cables is not recommended. If the use of an extension cable is unavoidable, then it should have a minimum core cross section of 2.5 mm<sup>2</sup> and limited to a maximum length of 3 metres.
- Extension cables should be routed away from the direct working area to prevent a trip hazard.

### 19. Guard against electric shock

- Avoid body contact with earthed or grounded surfaces such as pipes and radiators. There is an increased risk of electric shock if your body is earthed or grounded.

### 20. Always work within the machine's intended capacities

- Operator safety and machine performance are seriously adversely affected if attempts to make the machine perform beyond its limits are made.

### 21. Do not abuse the power cable

- Never pull the power cable to disconnect it from the power socket. Always use the plug.
- Keep the power cable away from heat, oil and sharp edges.
- Do not use the power cable for carrying or moving the machine.

### 22. Secure the work piece

- Ensure that the work piece is securely held before starting to machine it.
- When working within 300 mm of the machining area, always use a push stick to feed the work piece in to the blade or cutting tool. The push stick should have a minimum length of 400 mm. If the push stick becomes damaged, replace it immediately.
- Use extra supports (roller support stands etc.) for any work pieces large enough to tip when not held down to the table top.

- Do not use another person as a substitute for a table extension, or as additional support for a work piece that is longer or wider than the basic table, or to help feed, support, or pull the work piece.
- Do not attempt to machine more than one work piece at a time.
- When feeding the work piece towards the blade or cutting tool never position your hands in direct line of the cutting path. Avoid awkward operations and hand positions where a sudden slip could cause your hand or fingers to move into the machining area.

### 23. Stay alert

- Safety is a combination of operator common sense and alertness at all times when the machine is being used.
- Use all machines with extreme care and do not use the machine when you are tired or under the influence of drugs, alcohol or medication.

### 24. Use the correct tool for the job

- Do not use the machine for any purpose other than which it was designed.
- When selecting replacement cutting tools and blades, always ensure that they are designed to cut the material that you intend to use them for. If in any doubt seek further advice from the manufacturer.

### 25. Connect dust extraction equipment

- Always use dust extraction equipment. The dust extractor should be of suitable size and capacity for the machine that it is connected to and have a filtration level appropriate to the type of waste being collected. Refer to the relevant section of the manual for details of the specific dust extraction requirements for this machine.
- The dust extractor should be switched 'ON' before starting the machine that it is connected to. The dust extractor should be left running for 30 seconds after the last machining operation is complete in order to clear any residual waste from the machine.

### 26. Ensure that the machine is correctly guarded

- Never use the machine if any of the standard safety guards and equipment are removed or damaged.
- Some machines incorporate safety interlocks to prevent the machine from being used without the guards in place. Never attempt to bypass or modify the interlocks to allow the machine to be used without the guards in place.

### 27. Maintain your machine with care

- This manual gives clear instructions on installation, set up and operation of the machine and also details any routine and preventative maintenance that should be performed periodically by the user.
- Remember always to switch off and unplug the machine from the power supply before carrying out any setting up or maintenance operations.
- Follow any instructions for the maintenance of accessories and consumables.
- Do not use compressed air to clean the machine. Always use a brush to dislodge dust in places that are awkward to reach and a dust extractor to collect the waste.
- Inspect electric cables periodically and, if damaged, have them replaced by an authorised service facility or qualified electrician.
- Inspect extension cables (if used) periodically and replace if damaged.

### 28. Keep cutting tools sharp and clean

- Correctly maintained cutting tools are easier to control and less likely to bind.
- Cutting tools and blades can become hot during use. Take extreme care when handling them and always allow them to cool before changing, adjusting or sharpening them.

### 29. Disconnect the machine from the power supply

- When not in use, before servicing, changing blades etc. always disconnect the machine from the power supply.

### 30. Check for damaged parts

- Before each use of the machine, it should be carefully checked to determine that it will operate properly and perform its intended function.
- Check for alignment of moving parts, binding of moving parts, breakage

## 2. General Health & Safety Guidance cont.

of parts and any other conditions that may affect the operation of the machine.

- A guard or other part that is damaged should be properly repaired or replaced by a qualified person unless otherwise indicated in this instruction manual.
- Do not use the machine if the switch does not turn the machine 'ON' and 'OFF'.
- Have defective switches replaced by a qualified person.

### **31. Warning!**

- The use of any accessory or attachment, other than those recommended in this instruction manual, or recommended by our Company may present a risk of personal injury or damage to the machine and invalidation of

the warranty.

### **32. Have your machine repaired by a qualified person**

- This machine complies with the relevant safety rules and standards appropriate to its type when used in accordance with these instructions and with all of the standard safety guards and equipment in place. Only qualified persons using original spare parts should carry out repairs. Failure to do this may result in considerable danger to the user and invalidation of warranty.

### **33. Caution! Motor may become hot during use**

- It is normal for motors on some machines to become hot to the touch during use. Avoid touching the motor directly when in use.

# 3. Additional Health & Safety Guidance for Planer Thicknessers

**WARNING: FOR YOUR OWN SAFETY, DO NOT ATTEMPT TO OPERATE YOUR PLANER THICKNESSER UNTIL IT IS COMPLETELY ASSEMBLED AND INSTALLED ACCORDING TO THESE INSTRUCTIONS**

## Safe Operation

### 1. The planer thicknesser should be level and stable at all times

- If using an optional wheel kit to position the machine within your workshop, never attempt to move the machine with the surface tables in the raised position as this will raise the centre of gravity and make the machine unstable.

### 2. Familiarise yourself with the machine

- Machining operations using planer thicknessers have a history of serious accidents. Most accidents resulted from contact with the cutter block when surface planing due to the guard being incorrectly adjusted or missing from the machine.
- The machine is designed for planing hard and soft woods. It is not designed for planing any other material.
- Do not attempt to perform rebating, moulding, cutting tenons and recessing. The machine is designed to prevent these operations from being performed. Do not modify the machine in order to attempt any of these operations.

### 3. Before switching the machine 'ON':

- Set and secure safety guards in position before operating the machine. Adjust the guards to suit the size of work piece. Full details of the correct setting of the guards is included within the manual.
- Before starting work, watch the planer while it runs. If it makes an unfamiliar noise or vibrates excessively, switch the machine 'OFF' immediately and disconnect it from the power supply. Do not restart until finding and correcting the problem.
- Regularly check that the blades and lock bars are locked tight in the cutter block.
- Regularly check the anti-kickback fingers of the thicknesser for proper operation.
- Make sure there are no nails, screws or foreign objects in the part of the work piece to be planed.
- Make sure there is no debris between the work piece and the table or fence.
- Check that the fence, guards and work holding devices are secure and that the fixings for them are fully tightened.
- Clear the planing tables of all objects (tools, scrap pieces etc.).
- Plan the way you will hold and feed the work piece from start to finish.

### 4. Whilst planing:

- Never remove any of the safety guards. Keep guards operational at all times.
- Use extra caution with large, very small or irregularly shaped work pieces.
- Use extra supports (roller support stands etc) for any work pieces large enough to tip when not held down to the table top.
- Do not use another person as a substitute for a table extension, or as additional support for a work piece that is longer than the basic planer table, or to help feed, support, or pull the work piece.
- When planing irregularly shaped work pieces, or chamfering with the fence at 45°, plan your work support so it will not slip and be pulled from your hands.
- When planing short work pieces an additional push block should be used. Never attempt to plane a work piece that is too small to hold by hand.
- Avoid awkward operations and hand positions where a sudden slip could cause fingers or hands to move into the cutter block.
- Never make planing cuts deeper than 3mm / 1/8".
- Plane only one work piece at a time.

- Keep your face and body to one side, out of line with a possible kick back.
- If the work piece binds when thicknessing the machine may stall. If this happens, switch the machine 'OFF' immediately and follow the instructions detailed in the manual for safely removing the work piece. Do not attempt to free the work piece whilst the machine is running.

### 5. Maintenance:

- Regularly check that all safety guards are present and in full working order.
- Regularly check that the bridge guard moves freely, both horizontally and vertically.
- Keep the guards clean and free from waste material and deposits of resin.
- Regularly clean the planer table and thicknesser bed and apply a suitable lubricant (silicone wax or spray to help the work piece slide easily).
- The planer knives should be sharpened regularly to reduce the risk of snatching and kick back.
- Do not exceed maximum allowable blade projection over cutter block of 1.0mm/ 0.040 inch +10%.

6. This machine falls under the scope of the 'Health & Safety at Work etc. Act 1974', and the 'Provision & Use of Work Equipment Regulations 1998'. In addition the elimination or control of risks from wood dust is included in the above regulations and the 'Control of Substances Hazardous to Health (COSHH) Regulations 2002'. We recommend that you study and follow these regulations.

Further guidance is available from The Health & Safety Executive and their website [www.hse.gov.uk](http://www.hse.gov.uk).



# 4. Record Power Guarantee

“**Products**” means the Products sold by Record Power subject to these terms and conditions;

“**Record Power**” is Record Power Limited, whose company registration number is 4804158 and registered office address is Centenary House, 11 Midland Way, Barlborough Links, Chesterfield, Derbyshire, S43 4XA and sells through a network of Authorised Dealers;

“**Authorised Distributor**” is the nominated importer for your region who will generally sell through a network of Authorised Dealers. Details of Authorised Distributors for specific countries can be found in the Product manual or at [www.recordpower.info](http://www.recordpower.info);

“**Authorised Dealer**” is a retailer or business authorised to sell Record Power Products to end users.

## 1 Guarantee

- 1.1 Record Power guarantees that for a period of 5 years from the date of purchase the components of qualifying Products (see clauses 1.2.1 to 1.2.9) will be free from defects caused by faulty construction or manufacture.
- 1.2 During this period Record Power, its Authorised Distributor or Authorised Dealer will repair or replace free of charge any parts which are proved to be faulty in accordance with paragraphs 1.1 above provided that:
  - 1.2.1 you follow the claims procedure set out in clause 2 below;
  - 1.2.2 Record Power, our Authorised Distributor or Authorised Dealer are given a reasonable opportunity after receiving notice of the claim to examine the Product;
  - 1.2.3 if asked to do so by Record Power, its Authorised Distributor or Authorised Dealer, you return the Product, at your own cost, to Record Power's premises or other approved premises such as those of the Authorised Distributor or supplying Authorised Dealer, for the examination to take place;
  - 1.2.4 the fault in question is not caused by industrial use, accidental damage, fair wear and tear, wilful damage, neglect, incorrect electrical connection, abnormal working conditions, failure to follow our instructions, misuse, or alteration or repair of the Product without our approval;
  - 1.2.5 the Product has been used in a domestic environment only;
  - 1.2.6 the fault does not relate to consumable Products such as blades, bearings, drive belts or other wearing parts which can reasonably be expected to wear at different rates depending on usage (for full details contact Record Power or your local Authorised Distributor);
  - 1.2.7 the Product has not been used for hire purposes, by you or by a previous owner;
  - 1.2.8 the Product has been purchased by you as the guarantee is not transferable from a private sale.
  - 1.2.9 where the Product has been purchased from a retailer, the 5 year guarantee is transferable and begins on the date of the first purchase of the Product and in the event of a claim under this guarantee proof of the original purchase date will be required to validate the warranty period.

## 2 Claims Procedure

- 2.1 In the first instance please contact the Authorised Dealer who supplied the Product to you. In our experience many initial problems with machines that are thought to be due to faulty parts are actually solved by correct setting up or adjustment of the machines. A good Authorised Dealer should be able to resolve the majority of these issues much more quickly than processing a claim under the guarantee.
- 2.2 Any damage to the Product resulting in a potential claim under the guarantee must be reported to the Authorised Dealer from which it was purchased within 48 hours of receipt.
- 2.3 If the Authorised Dealer who supplied the Product to you has been unable to satisfy your query, any claim made under this Guarantee should be made directly to Record Power or its Authorised Distributor (for details of the Authorised Distributor in your country please see your Product manual or check [www.recordpower.info](http://www.recordpower.info) for details). The claim itself should be made in a letter setting out the date and place of purchase, and giving a brief explanation of the problem which has led to the claim. This letter should then be sent with proof of the purchase date (preferably a receipt) to Record Power or its Authorised Distributor. If you include a phone number or email address this will help to speed up your claim.
- 2.4 Please note that it is essential that the letter of claim reaches Record Power or its Authorised Distributor on the last day of this Guarantee at the latest. Late claims will not be considered.

## 3 Limitation of Liability

- 3.1 We only supply Products for domestic and private use. You agree not to use the Product for any commercial, business or re-sale purposes and we have no liability to you for any loss of profit, loss of business, business interruption or loss of business opportunity.
- 3.2 This Guarantee does not confer any rights other than those expressly set out above and does not cover any claims for consequential loss or damage. This Guarantee is offered as an extra benefit and does not affect your statutory rights as a consumer.

## 4 Notice

This Guarantee applies to all Products purchased from an Authorised Dealer of Record Power within the United Kingdom of Great Britain and Northern Ireland. Terms of Guarantee may vary in other countries – please check with the Authorised Distributor in your country (details of the Authorised Distributor for your country can be found in the manual or at [www.recordpower.info](http://www.recordpower.info)).

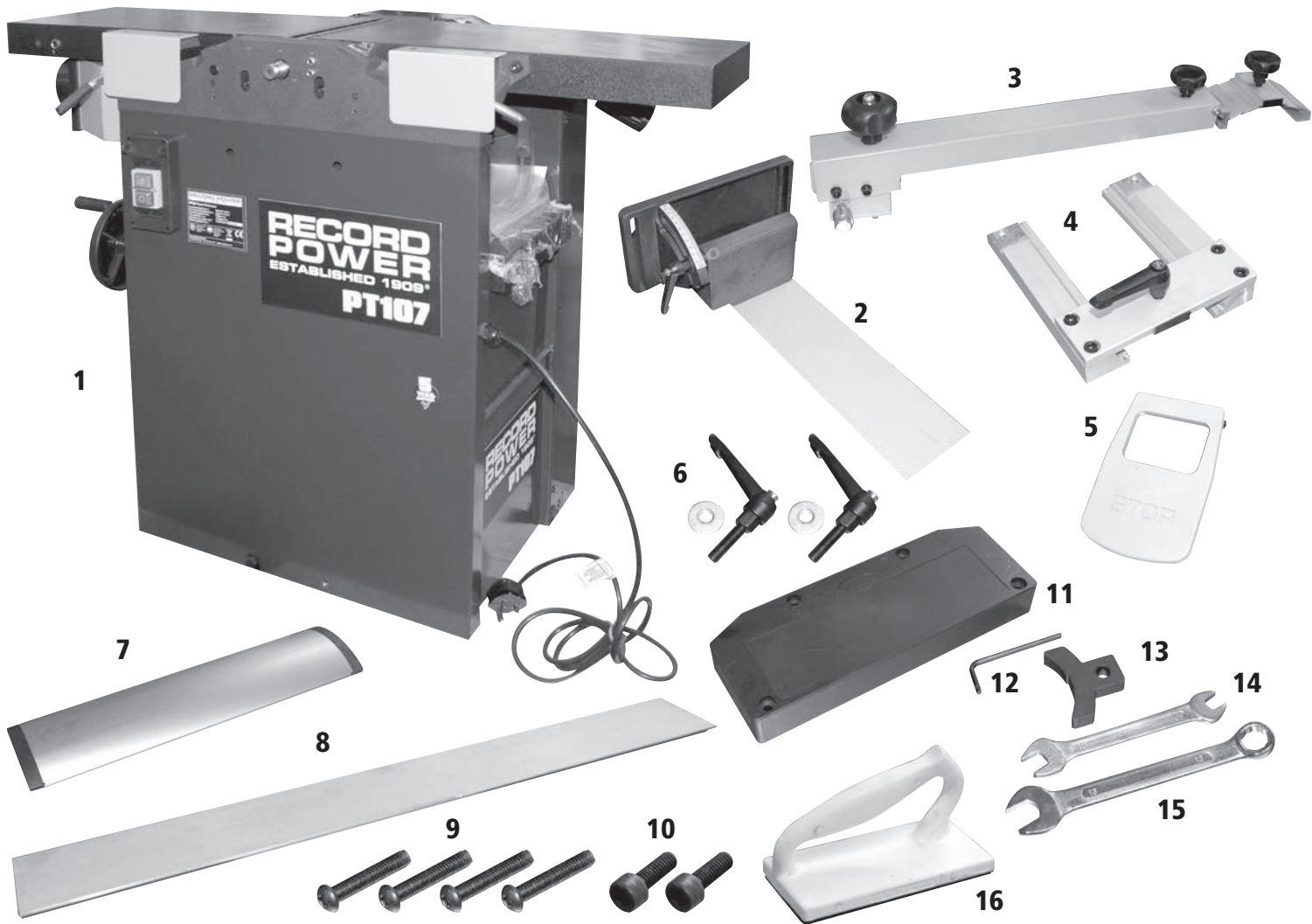


# 5. Specifications

<b>Cutter block diameter:</b>	75 mm
<b>Number of cutters:</b>	3
<b>Blade size:</b>	260 x 18.5 x 3 mm
<b>Cutter block speed:</b>	4000 rpm
<b>Planing table size:</b>	1100 x 265 mm
<b>Maximum planing width:</b>	265 mm
<b>Thicknessing table size:</b>	600 x 265 mm
<b>Maximum thicknessing width:</b>	265 mm
<b>Maximum planing depth of cut:</b>	3 mm
<b>Maximum thicknesser depth of cut:</b>	2 mm
<b>Maximum thicknessing height:</b>	190 mm

<b>Thicknesser feed rate:</b>	5 metres / minute
<b>Fence size:</b>	1080 x 130 mm
<b>Fence tilt:</b>	90° - 45°
<b>Dust port diameter:</b>	100 mm
<b>Weight:</b>	162 kg
<b>Sound power level:</b>	85 db(a) / 106 db(a) unloaded / loaded
<b>Sound pressure level:</b>	83 db(a) / 100 db(a) unloaded / loaded
<b>Motor:</b>	230 v / 50 hz / 3 hp / 2200 w
<b>Full load current:</b>	9.7 A

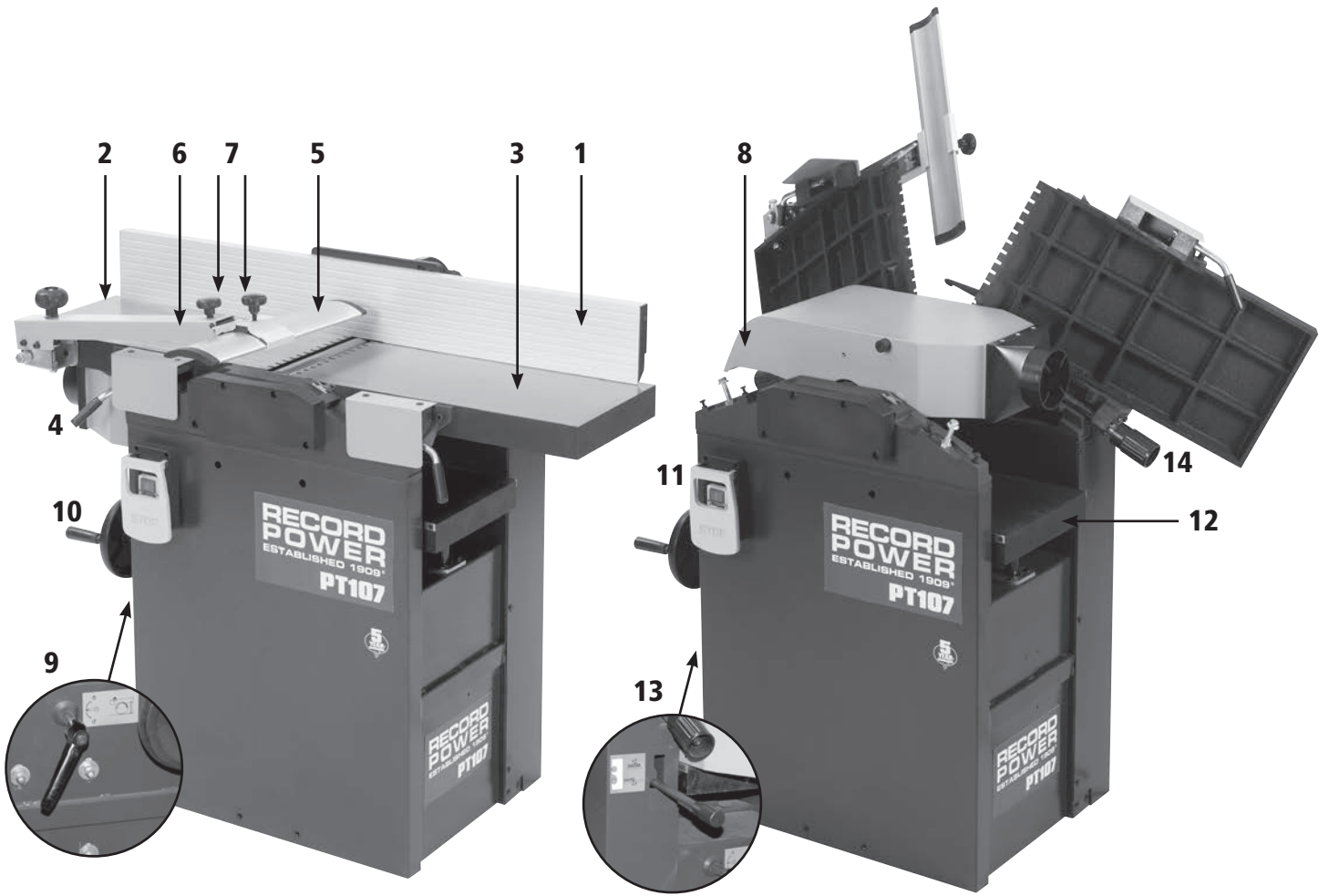
# 6. Contents of the Package



- 1 PT107 Planer Thicknesser
- 2 Fence bracket
- 3 Bridge guard bracket
- 4 Fence carrier
- 5 Emergency stop cover
- 6 Ratchet handles and M8 washers x 2
- 7 Bridge guard
- 8 Fence

- 9 Spindle cover screws x 4
- 10 M5 hex head socket bolts x 2
- 11 Spindle cover
- 12 3 mm hex wrench
- 13 Blade setting jig
- 14 10 / 8 mm wrench
- 15 13 mm wrench
- 16 Push block

# 7. Getting to Know Your Planer Thicknesser



- 1 Fence
- 2 Outfeed table
- 3 Infeed table
- 4 Table lock
- 5 Bridge guard
- 6 Bridge guard bracket
- 7 Bridge guard adjustment knobs

- 8 Dust extraction hood
- 9 Thickener table lock lever
- 10 Thickening table hand wheel
- 11 Power switch
- 12 Thickener table
- 13 Thickener feed clutch
- 14 Infeed table adjustment handle

# 8. Assembly

## Unpacking



The planer thicknesser is a heavy machine. DO NOT over-exert yourself, while unpacking or moving the machine. You will need assistance and possibly powered equipment to move it. Serious personal injury may occur if safe moving methods are not adhered to.



**Warning: Never lift the machine by the planer tables when unloading as shown in Fig. 8.1. Belt and chains may only be attached to the stand.**

Ensure that lifting gear used has an adequate capacity and the load is secured against lateral slipping.

Unloading can be performed using a forklift, pallet jack or crane.

Use of the **PT107/W** Jockey Style Wheel Kit is recommended for transport of the machine, **Fig. 8.2**.



**Warning: Some metal parts may have sharp edges on them. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.**

## Cleaning

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during transport. Remove this protective coating with a solvent cleaner, de-greaser or white spirit. For optimum performance of the machine, make sure to clean all moving parts or sliding contact surfaces that are coated. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact with them.

After cleaning it is recommended that Record Power **CWA195** Silicone Spray or wax be applied to the tables to give smooth movement of timber.



**Warning: Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.**



**Warning: Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.**

Fig 8.1

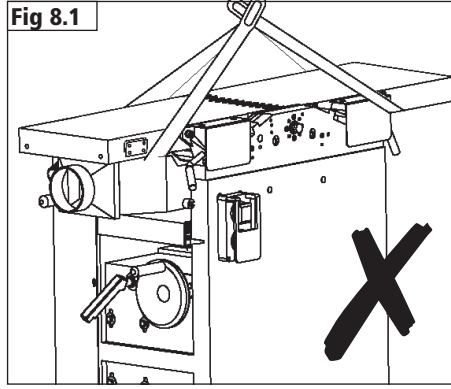


Fig. 8.2

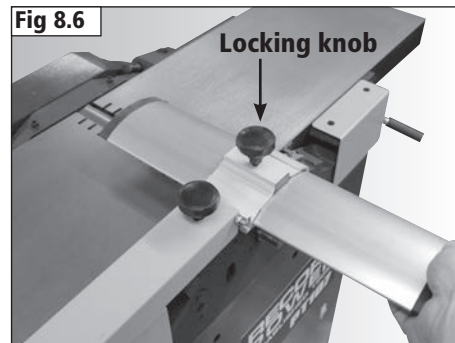
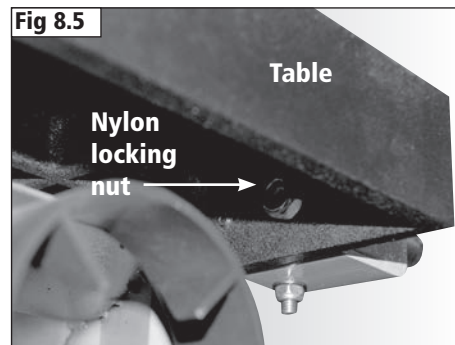
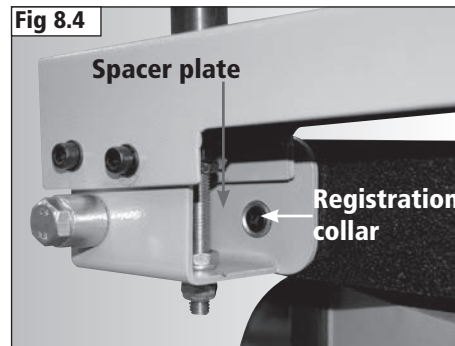
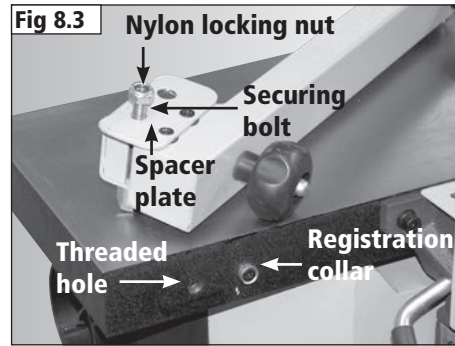


# 8. Assembly

## Fitting the Bridge Guard & Bracket

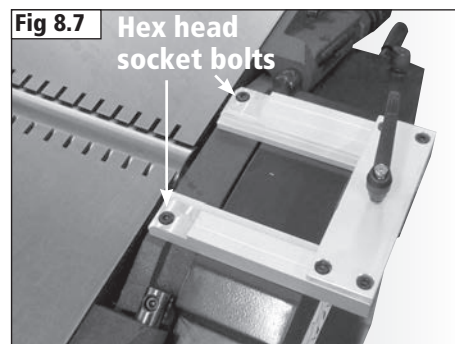
The bridge guard bracket is supplied with an M10 x 100 mm securing bolt, spacer plate and nylon locking nut already fitted, **Fig. 8.3**. Remove the nut and attach the bracket to the outfeed table by screwing the bolt into the threaded hole in the outfeed table, locating the hole in the spacer plate over the registration collar and securing with the nylon locking nut, **Fig. 8.4**. To fit the nut, access to the bolt is gained from the underside of the outfeed table, **Fig. 8.5**.

Slide the bridge guard into the holder on the bracket as shown in **Fig. 8.6** and tighten the locking knob on top of the holder.



## Fitting the Fence

Attach the fence carrier to the machine body using the 2 hex head socket bolts as shown in **Fig. 8.7**.



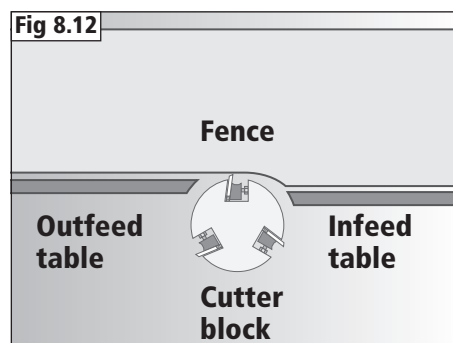
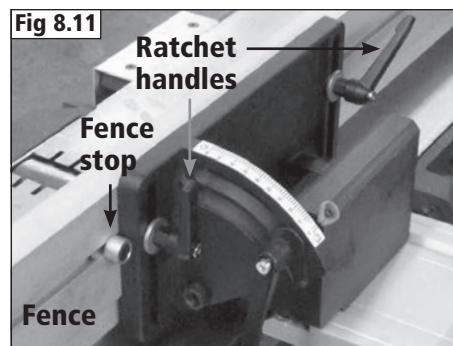
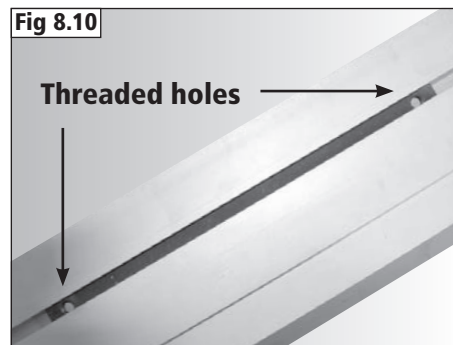
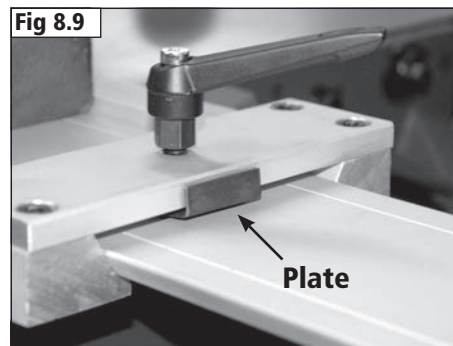
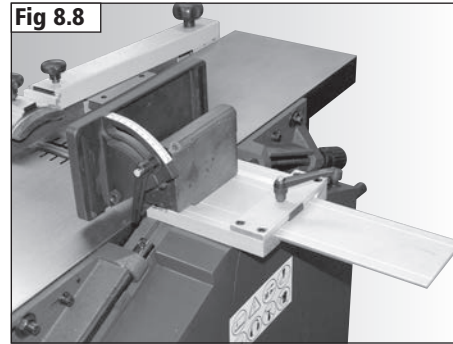
# 8. Assembly

Slide the fence bracket into the carrier as shown in **Fig. 8.8**. The bracket can be locked in position using the locking handle of the carrier. Ensure that the plate attached to the underside of the locking handle mount is positioned beneath the locking handle as shown in **Fig. 8.9**.

The fence features a moving plate with threaded holes inside the groove on the rear of the fence, **Fig. 8.10**. Attach the fence to the bracket by screwing the two bolts with ratchet handles attached into the holes as shown in **Fig. 8.11**. Ensure the washers supplied are placed between the ratchet handles and the fence bracket as shown.



The fence features a stop which must always be positioned as shown in **Fig. 8.11**. The fence is shaped to allow maximum support to the workpiece by having a deeper surface on its right hand side, see **Fig. 8.12**. The left hand side of the fence is raised to give clearance to the outfeed table. The purpose of the stop is to eliminate the risk of the fence being positioned so the lower part of it comes into contact with the cutter block.

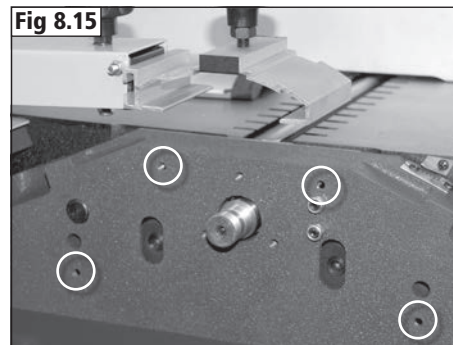
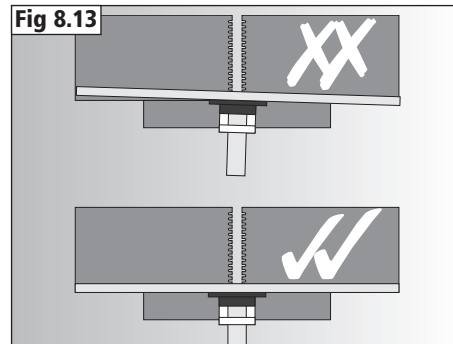


# 8. Assembly

Once the whole fence assembly is installed, check that the fence is square to the table. If not, adjust the position of the fence carrier until alignment is achieved. See **Fig. 8.13**.

Attach the switch cover to the switch box on the front of the machine as shown in **Fig. 8.14** using the nuts and bolts supplied pre-assembled to the switch cover.

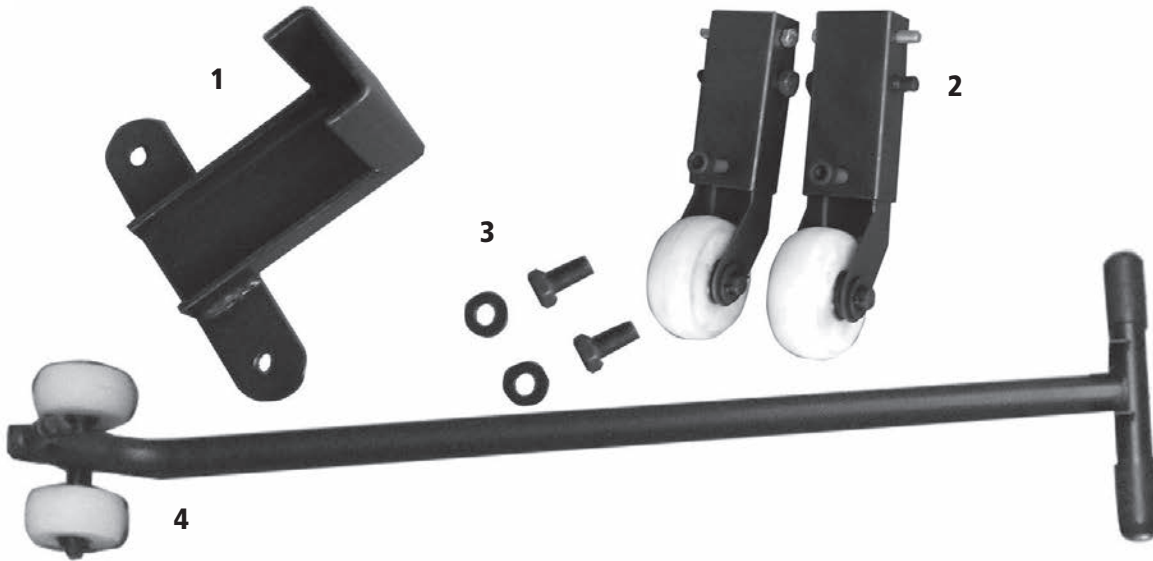
To fit the spindle cover, pass the spindle cover screws through the holes in the cover and screw into the threaded holes on the side of the machine as shown in **Fig. 8.15**.





# 9. Assembly of the Optional Wheel Kit

Fig. 9.1



## Contents of the Package

See Fig. 9.1.

- 1 Lifting bracket
- 2 Wheel assemblies, hex head nuts and bolts x 2
- 3 Hex head nuts and bolts x 2
- 4 Jockey bar and wheels



Access to the underneath of the machine is required to fit the nuts to the bolts which hold the wheel kit components to the machine. To do this safely, mount the machine securely on blocks of wood which are tall enough to allow access, Fig. 9.2.

**DO NOT attempt to gain access to the underneath of the machine by tipping it as this introduces the risk of it becoming unstable and falling over.**

The wheel assemblies are supplied with hex head nuts and bolts pre-assembled. To attach them to the machine, remove the nuts and pass the bolts through the assemblies and the pre-drilled holes in the machine body and secure with the nuts, as shown in Fig. 9.3. Ensure the assemblies are installed with the wheels pointing upwards as in Fig. 9.3.

Using the remaining two nuts and bolts, attach the lifting bracket to the front of the machine as shown in Fig. 9.3.

Fig. 9.2

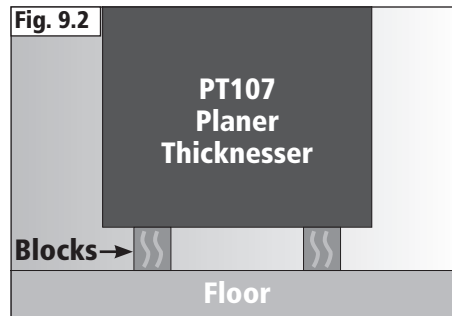
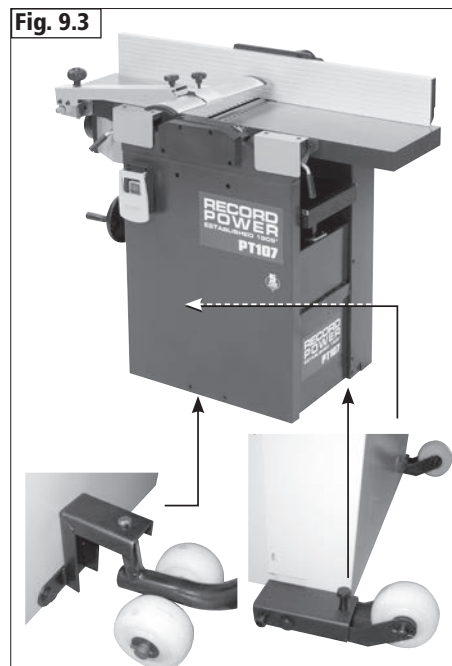


Fig. 9.3



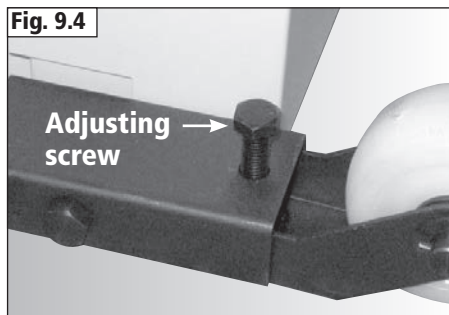
# 9. Assembly of the Optional Wheel Kit

When the wheel kit is not in use, the wheels fitted to the main body of the machine can be raised by unscrewing the adjusting screw, **Fig. 9.4**, so that they are clear of the floor. The wheels must be lowered again before using the wheel kit.

When fully assembled, the wheel kit should be as shown in **Fig. 9.5**.



Never attempt to move the machine with the wheel kit whilst the planer tables are in the raised position. The centre of gravity will be high, making the machine unstable. Always ensure that the tables are in the closed position before attempting to move the machine.

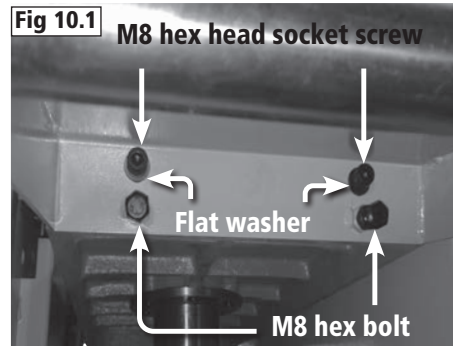


# 10. Assembly of the Optional 49000 Thicknessing Table Extension

**Note:** Follow instructions below for machines with pre-drilled holes for table extension fitment. For machines without pre-drilling, please see instructions for **Drilling the Thicknessing Table to fit the Table Extension to Machines Without Pre-drilled Holes.**

## Fitting the Thicknessing Table Extension to Pre-drilled Machines

Firstly, fix the thicknessing extension table onto the edge of main thicknessing table of the PT107, using the 2 M8 hex bolts, 2 M8 hex head socket screws and 2 flat washers supplied, as shown in **Fig 10.1**, do not fully tighten. Then, adjust the two M8 hex bolts mounted on the underside of the thicknessing extension table, to ensure that the two surfaces are flush, **Fig 10.2**. Then, fully tighten the 2 M8 hex bolts.

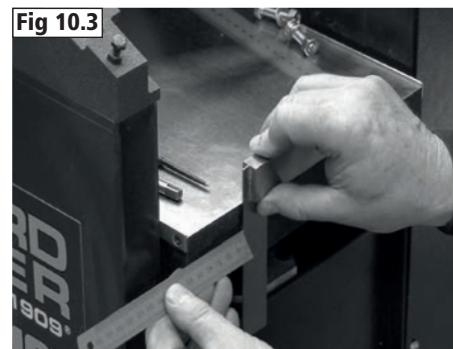


## Drilling the Thicknessing Table to fit the Table Extension to Machines Without Pre-drilled Holes

**Note:** Step-by-step video illustrating how to drill the machine thicknessing table available at [YouTube.com/RecordPowerTV](https://www.youtube.com/RecordPowerTV).

Measure 54 mm inwards from the left-hand side of the machine thicknessing table and mark a line, **Fig 10.3**.

Measure 16 mm down from the top of the table and mark a second line across the marking previously made, **Fig 10.4**.



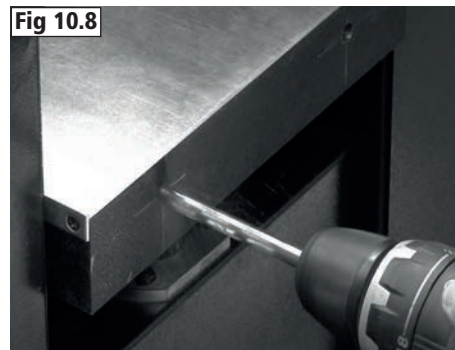
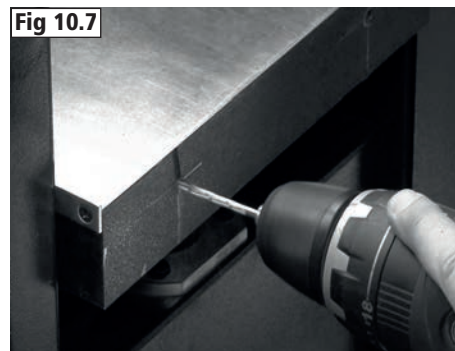
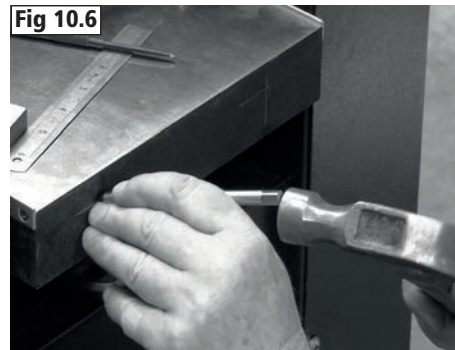
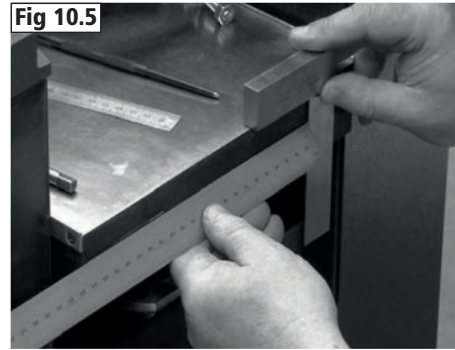
# 10. Assembly of the Optional **49000** Thickening Table Extension

From the centre point of the two markings previously made, measure 150 mm into the table and mark a third line, **Fig 10.5**.

As done previously, measure 16 mm down from the top of the table along the line previously made and mark a fourth line, **Fig 10.4**.

Create an indentation in both centre points of the four markings using a centre punch and hammer, **Fig 10.6**.

Drill through both centre points using either a 3.5 mm or 4.5 mm drill bit, then, drill through both holes using an 8.5 mm drill bit, **Fig 10.7** and **Fig 10.8**.

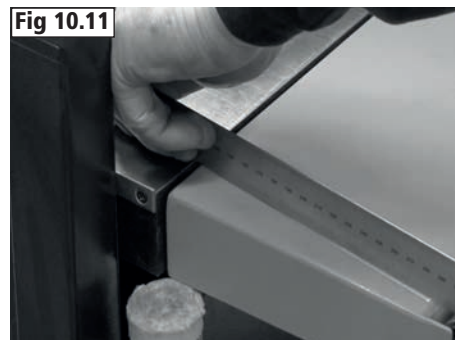
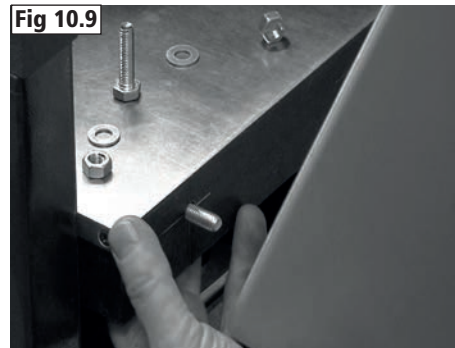


# 10. Assembly of the Optional 49000 Thicknessing Table Extension

Thread the M8 hex head socket screw along with the first M8 washer through the drilled hole as shown. On the opposing side of the table, add the second M8 washer, followed by the M8 nut and repeat this process, **Fig 10.9**.

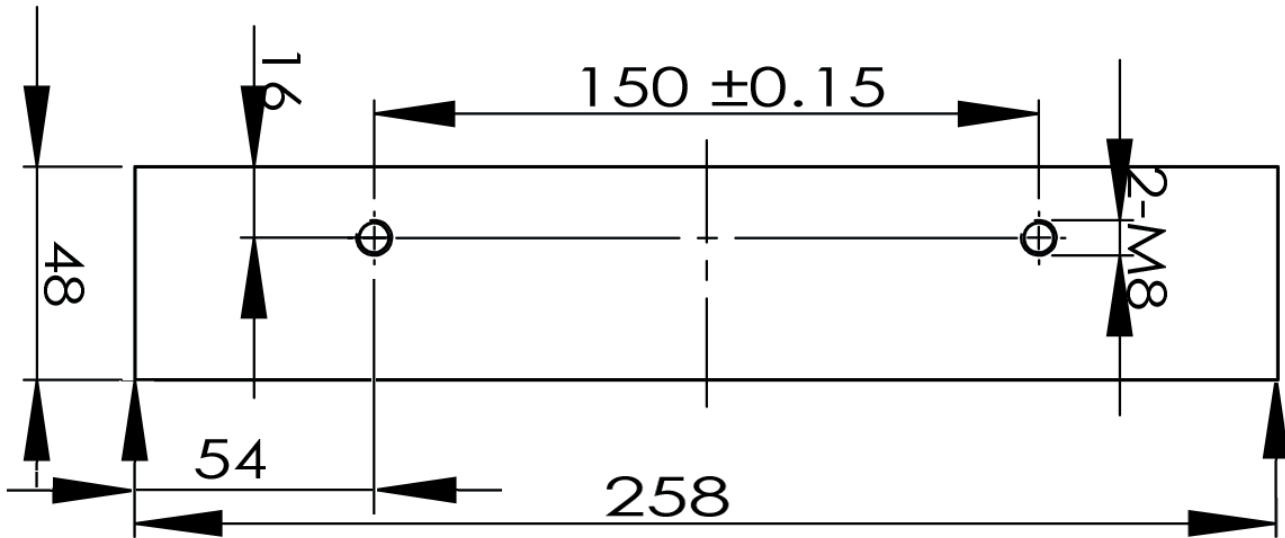
Place a straight edge over the joint from the machine table to the extension table on both sides, to check they are flush together, **Fig 10.10**.

Should adjustment be required, gently knock the extension table into position using a soft mallet. Fine adjustment can also be made by loosening the M8 hex bolts pre-fitted into the extension table, **Fig 10.11**.



# 10. Assembly of the Optional **49000** Thickening Table Extension

49000 Thickening Table Extension Drilling Template

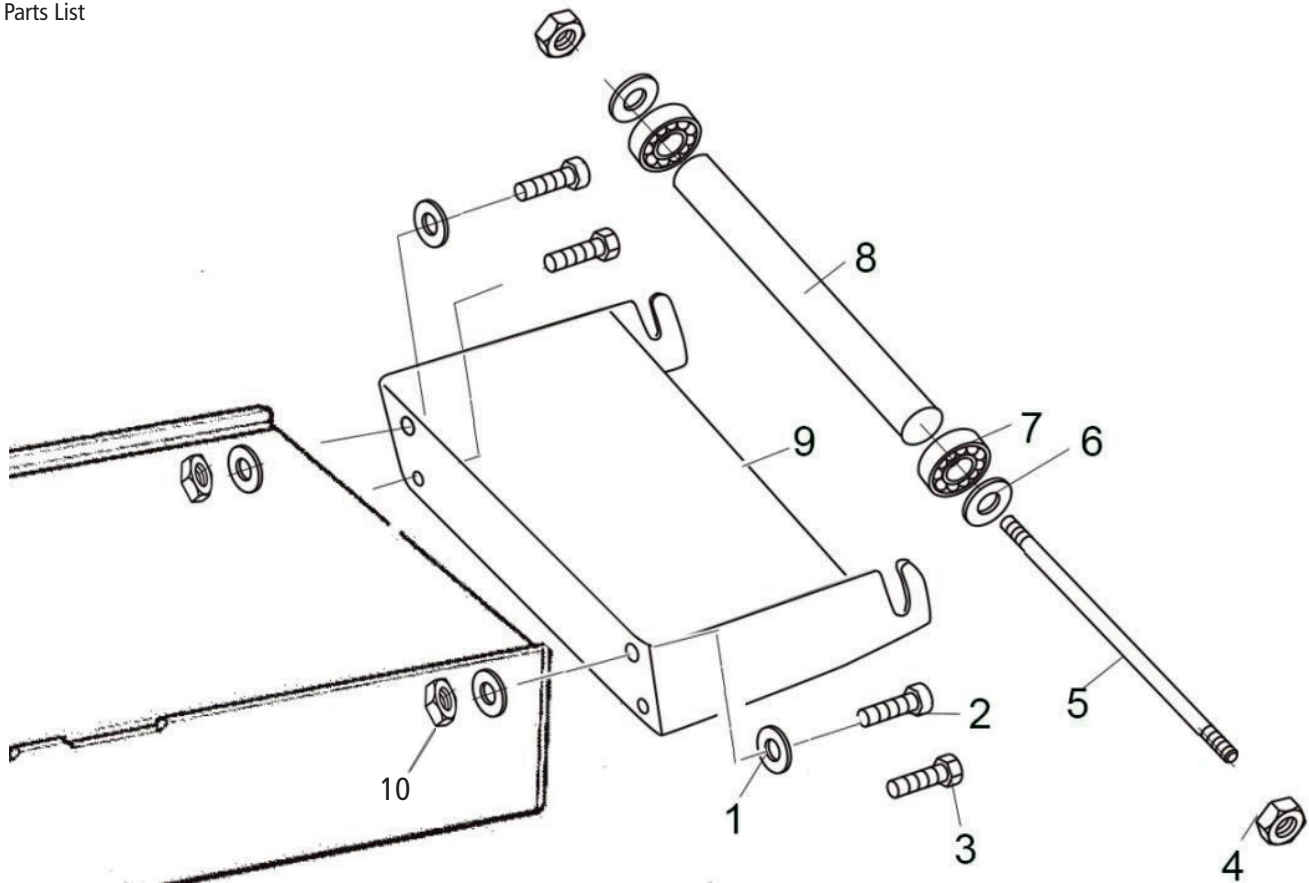


Template not to scale



# 10. Assembly of the Optional **49000** Thickening Table Extension

Parts List



No.	Description	Quantity
1	Flat washer	4
2	M8 hex head socket screws	2
3	M8 hex bolt	2
4	M10 hex nut	2
5	Shaft	1
6	Flat washer (large)	2
7	Bearing 6001	2
8	Table extension roller	1
9	Table extension	1
10	M8 hex nut	2

# 11. Operation

## Working techniques

Permitted working techniques.

All uses deviating from those described below are considered improper uses and are therefore not permitted.

- Planing the wide side of a workpiece.
- Planing the narrow side of a workpiece.
- Bevelling the edges of a workpiece.

## Prohibited Working Techniques

The following work techniques are prohibited on the machine. This list is not exhaustive.

- Down-cut jointing (direction of cutter block rotation same as feed direction).
- Insertion cuts (workpiece is not worked along its entire length).
- Planing of excessively warped timber.
- Thickness planing of multiple workpieces of different thicknesses.



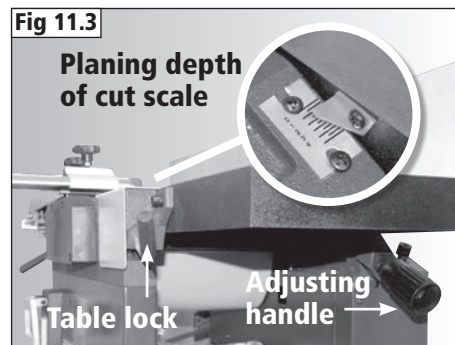
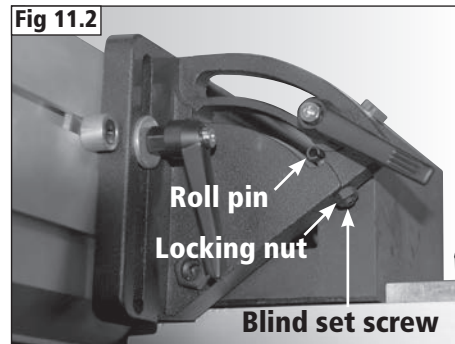
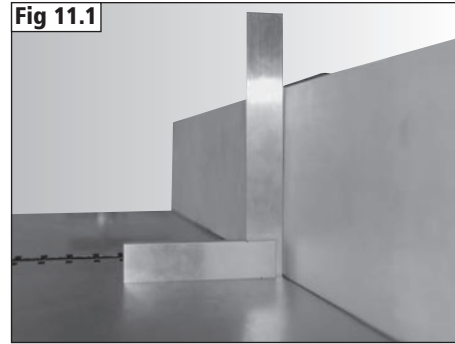
**Before first use of the machine check that the fence is at 90° to the table to ensure accurate results. Use a set square as shown in Fig. 11.1.**

If adjustment is required, loosen the locking nut at the rear of the fence bracket and adjust the blind set screw, **Fig. 11.2**. If the fence is less than 90° to the table, turn the screw anti-clockwise until it rests against the roll pin when the table is at 90°. If the fence is more than 90° to the table, turn the screw clockwise until it rests against the roll pin when the table is at 90°.

Before planing, connect a suitable dust or chip extractor to the dust extraction outlet situated beneath the outfeed table.

## Setting the Infeed Table

Open the table lock, **Fig 11.3**. and turn the adjusting handle until the desired depth of cut is shown (maximum 3 mm). Re-tighten the table lock securely.



# 11. Operation

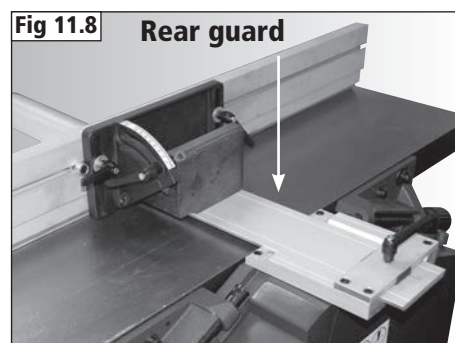
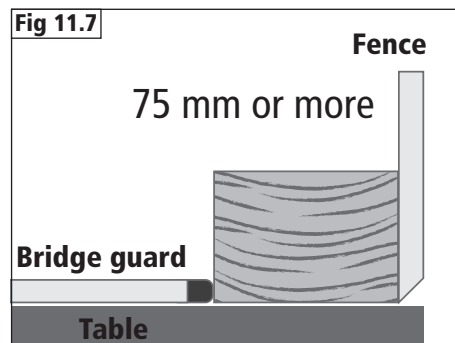
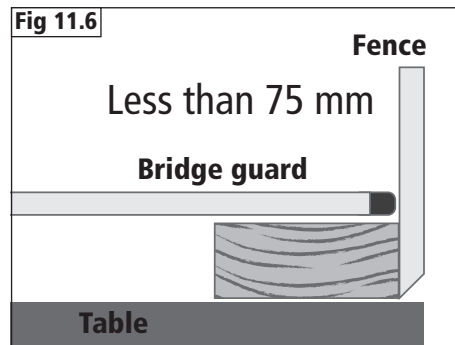
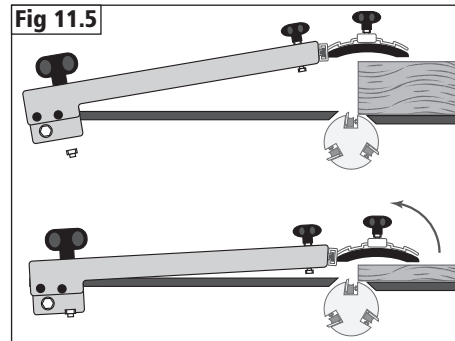
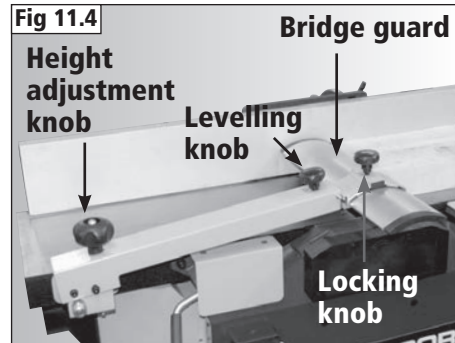
## Positioning the Bridge Guard

Place the timber on the tables and position the bridge guard to be as close as possible to the timber without touching it, **Fig 11.4**. To set the height of the bridge guard use the height adjustment knob on the bracket, **Fig 11.4**. Ensure the bridge guard is covering as much of the cutter block as possible by loosening the guard locking knob, sliding the guard as far towards the fence as possible and re-tightening the knob.

The bridge guard levelling knob can be used to position the guard parallel to the workpiece, depending on its depth, as shown in **Fig. 11.5**.

The guard should always be used above the workpiece when planing timber below 75 mm in height, **Fig. 11.6**. For timber greater in height than 75 mm, move the bridge guard up to the side of work-piece and let it rest on the planing table, covering as much of the cutter block as possible, **Fig 11.7**.

The fence assembly features a rear guard as shown in **Fig. 11.8**. When planing narrow workpieces, this guard covers the area of the cutter block which may otherwise be accessible from behind the fence.



# 11. Operation

## Surface Planing



**Caution:** Minimise positioning hands above the cutter block. It is not necessary to exert feeding pressure directly over the cutter block.



**When surface planing, always feed the workpiece at a slow and consistent rate. Feeding the workpiece too quickly will reduce the quality of finish of the planed surface. Fine ridges or marks across the width of the workpiece are an indication that the feed rate is too fast.**

Before switching the machine on, ensure the feed clutch is in the lower position as shown in **Fig. 11.9**.

### Power Switch

To switch the planer on use the green button, **Fig. 11.10**.

To switch the planer off use the large red button beneath the emergency stop flap.

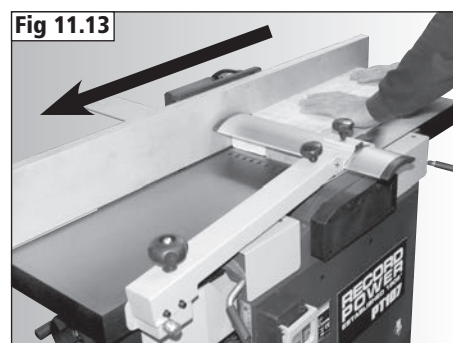
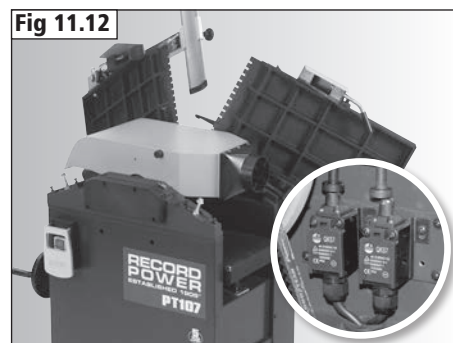
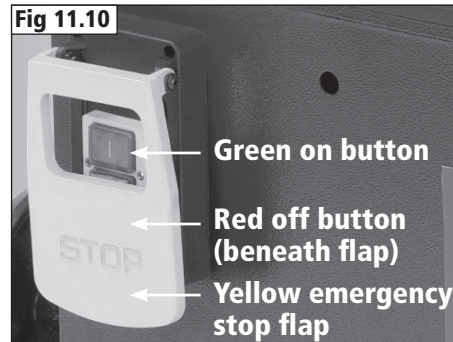
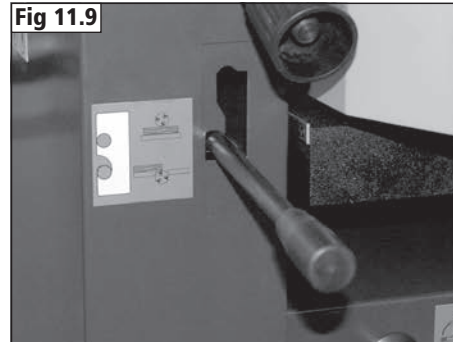
In an emergency the machine can be stopped quickly using the yellow emergency stop flap.

### Safety Limit Switches

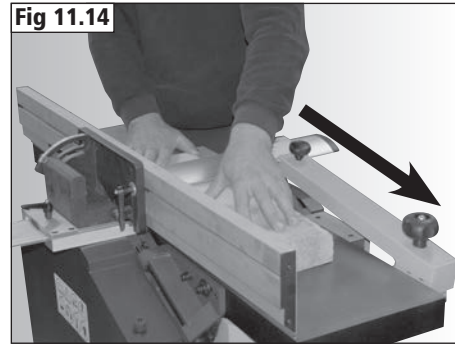
The machine is equipped with 2 safety limit switches.

The cutter block can only run when either the planer tables are closed, **Fig 11.11**, or the extractor hood is positioned over the cutterblock when the tables are raised for thicknessing operations, **Fig 11.12**.

Correct hand placement when surface planing is important for good results and safe operation. Stand at the front of the machine, at approximately 45° to the table. Hold the timber down on the infeed table with the left hand and apply feed pressure with the right hand, **Fig. 11.13**. As soon as there is enough timber on the outfeed table to accommodate the left hand, it should be moved over the bridge guard and onto the timber. Feed pressure should then be applied with the left hand onto the timber on the outfeed table, with the right hand following to complete the feeding operation, **Fig. 11.14**.



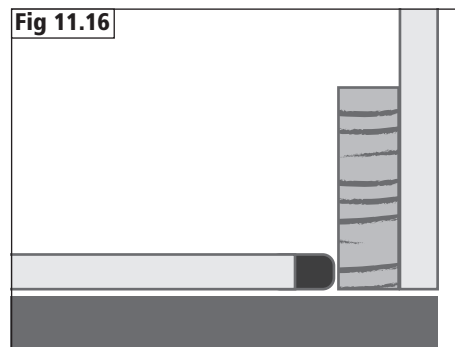
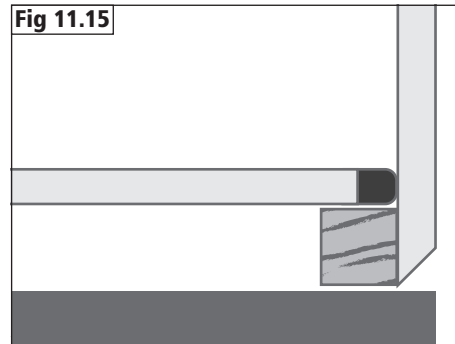
# 11. Operation



## Edge planing

When edge planing small stock as shown in **Fig. 11.15** the bridge guard should be positioned above the work piece to guard as much of the cutter block as possible. When edge planing larger or tall pieces the bridge guard should be positioned against the table as shown in **Fig. 11.16**. In this instance, if the guard was above the timber the gap left between the cutter block and guard would be too large and therefore not offer enough protection. There is no specific rule as to the position of the bridge guard when edge planing and user discretion must be exercised to ensure the safest possible position based on these guidelines.

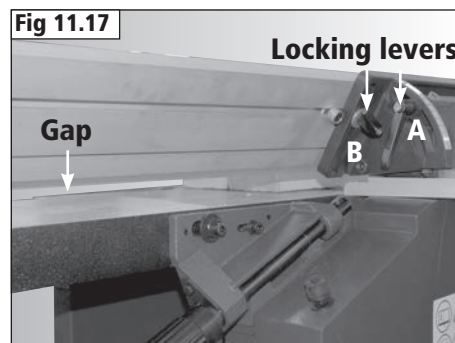
Feed the workpiece across the cutter block as described for surface planing, taking extra care to not let the hands pass over the cutter block. Pressure should be applied sideways to keep the timber against the fence, ensuring an accurate cut.



## Tapering & Edge Beveling

During this procedure the longitudinal edges of a work-piece are bevelled or tapered to the required angle.

To adjust the angle of the fence, loosen locking lever **A** on the fence bracket, **Fig. 11.17**, and position the fence to the required angle. This adjustment will bring the fence away from the table as shown in **Fig. 11.17**. To bring the fence back to meet the table, loosen the locking levers **B** on both sides of the bracket and lower into position.



# 11. Operation

When bevelling, set the bridge guard as shown in **Fig 11.18** and when tapering as shown in **Fig. 11.19**. Due to the nature of the cuts to be made, the guard cannot be placed as close to the timber and cutter block as when surface planing. However, ensure that the guard is a maximum of 10 mm from the timber and cutter block.

Adjust the fence to required angle and press the work piece against the fence and guide evenly over the cutterblock, **Fig. 11.20**.

To ensure an accurate cut and help prevent the timber slipping, press the workpiece mainly against the fence and only lightly against the planing table.

## Using Additional Support

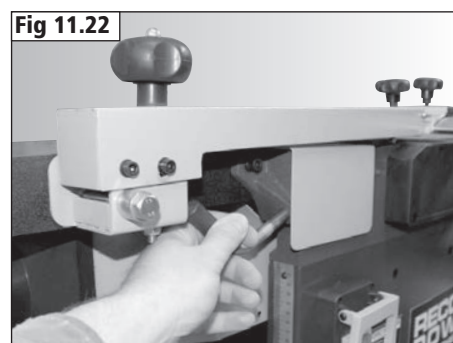
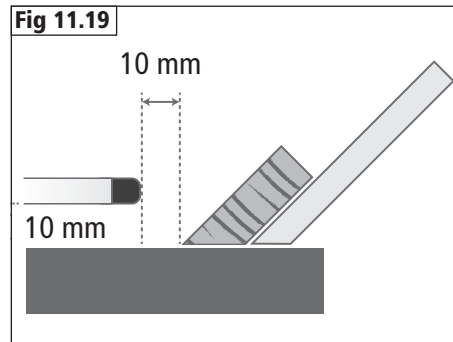
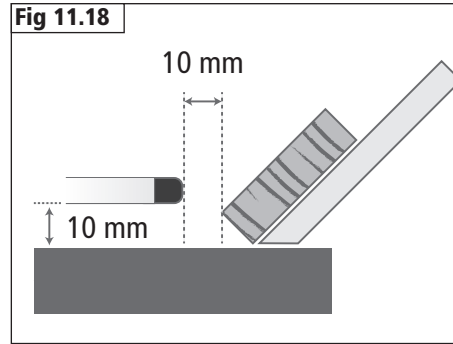
When surfacing planing small workpieces, extra care must be taken to keep the hands a safe distance from the cutter block. If a workpiece is too small to be held with both hands, the supplied push block can be used to hold the timber as shown in **Fig. 11.21**, providing the timber is large enough to allow the push block to sit fully upon it.

## Changeover from Planing to Thicknessing



**Remove the planer fence before changeover. Ensure that the thicknessing table is at least 160 mm below the cutterblock to allow the extraction hood to move freely between the surface planing and thicknessing positions.**

Open the table lock, **Fig. 11.22**, of the outfeed table, pull out the lever fully and lift up the outfeed table.





# 11. Operation

Be sure the outfeed table is fully raised and tilted, **Fig. 11.23**.

Now raise the infeed table in the same manner.

Finally, raise the extraction hood to cover the cutter block, **Fig. 11.23**.

To return the machine to planing mode follow the above instructions in reverse order.

## Adjusting the Height for Thickening

Unscrew the lock lever that clamps the thickening table, **Fig. 11.24**.

Now adjust the thickening table to the required height using the hand wheel, **Fig. 11.24**. The depth scale and pointer to the right of the hand wheel indicate the table height.

Retighten the lock lever to clamp the table in place.



**Attention:** The depth of cut should be minimised under the following circumstances:

- The timber is very wide.
- The timber is hard wood.
- The timber is damp.
- The planer blades are in need of sharpening.

## Thickening

Adjust the thickening table height to that of the workpiece height, minus the depth of cut required.

Ensure the feed clutch is in the upper position as shown in **Fig. 11.25**.

Turn the machine on and carefully slide the work-piece onto the thickener table until it is drawn in by the feed rollers, **Fig. 11.26**. Keep hands as far from the cutter block as possible.



**Warning: If the workpiece becomes trapped when feeding into the thickener, immediately switch the machine off and disconnect from the power before attempting to free the workpiece. To release the workpiece, lower the thickening table.**

## Restarting

### In the Event of a Blockage or if the Machine Stalls

If the machine stalls due to the work piece becoming trapped in the cutter block, switch it off immediately by pressing the emergency stop button (Red button marked 'O') and wait for the machine to come to a complete stop before proceeding further.

If the work piece is trapped between the cutter block and thickening table, it may be necessary to lower the thickening table in order to free the blockage.

To re-start the machine, press the green button marked 'I' on the switch.

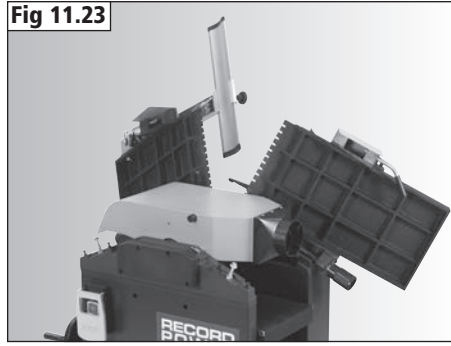
### In the Event of a Power Failure

The machine is fitted with a no volt release (NVR) switch to protect the user against automatic starting of the machine when power is restored after a power failure.

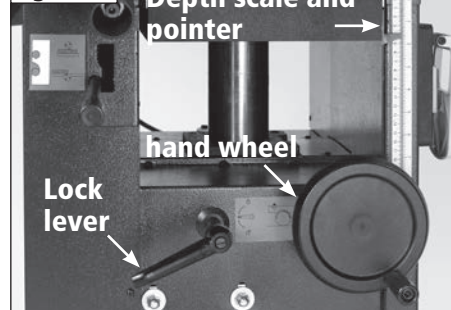
In the event of a power failure, first locate and rectify the source of the failure. If the fault is within the power circuit of the workshop, there may be an underlying cause (circuit overload etc.) that should be investigated by a qualified electrician, before attempting to restore the power source. If a cutting operation was taking place when the power supply was interrupted, then it may be necessary to free the work piece from the cutter before attempting to re-start the machine.

Once the power is restored, the machine can be re-started by pressing the 'on' switch.

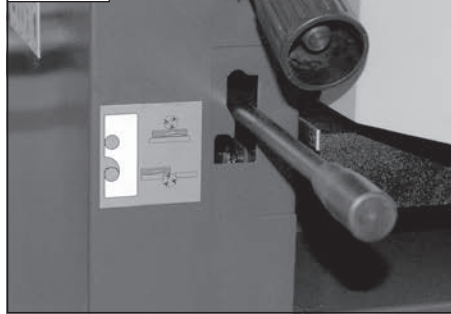
**Fig 11.23**



**Fig 11.24**



**Fig 11.25**



**Fig 11.26**



# 11. Operation

## Using a Planer Thicknesser to Achieve 90° to All Adjacent Sides of the Timber

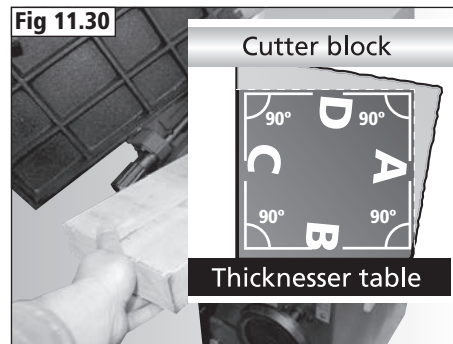
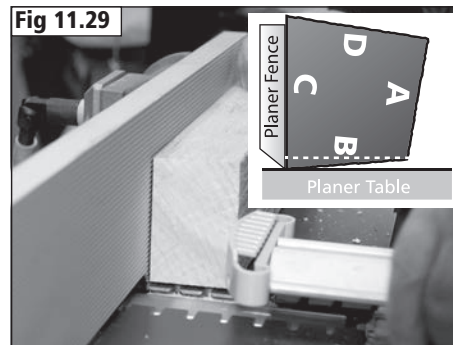
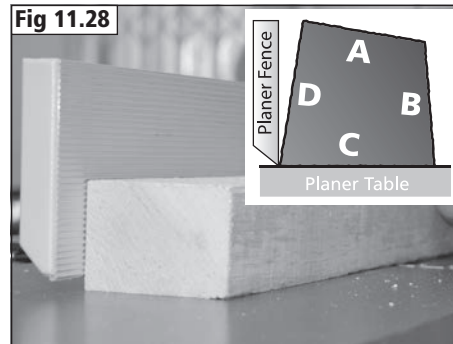
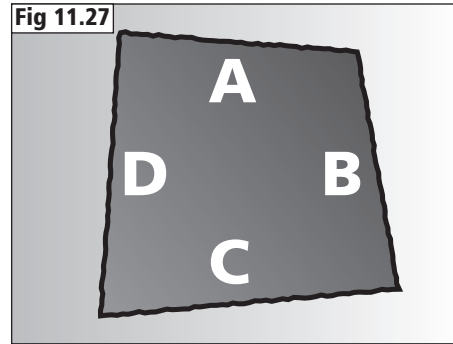
The most common use of a planer thicknesser is to plane timbers to accurate sizes and with all adjacent sides at 90° to one another. Using the methods already described in this manual and following the process below, any number of pieces can be planed and dimensioned to exact sizes. This preparation gives the best base possible for carrying out projects successfully.

**Fig. 11.27** shows an exaggerated cross section of a typical rough-sawn piece of timber before being machined.

Plane surface **C** to be flat using the machine in the planing mode, **Fig. 11.28**.

Place surface **C** against the fence, which is set to 90°, and plane surface **B** until it is at 90° to surface **C**, **Fig. 11.29**.

Once these two adjacent faces are at 90° to each other, the remaining opposite faces can be thickened parallel by using them as a reference, **Fig. 11.30**.



# 12. Adjustments & Maintenance

## Outfeed Table Adjustment



**Please note:** The height of outfeed table is factory set. It should only require adjustment in cases where other normal adjustments to the planer knives have not rectified any alignment issues.



**Please note:** Before carrying out any of the adjustments below, ensure that the machine is switched off and that the power cord is disconnected from the mains supply.



**CAUTION!** This procedure involves close contact with the planer blades. Ensure that protective gloves are worn at all times to prevent injury to hands.

### Aligning the Outfeed Table

Loosen the two hex nuts inside the adjusting handle, **Fig. 12.1**.

Open the table lock, **Fig. 12.2**, and leave the table in the down position.

Remove the bridge guard to give access to the cutter block.

Rotate the cutter block so that one of the knives is at top dead centre.

A knife is at top dead centre when it is at its highest point during the rotation as shown in **Fig. 12.3**.

Place a straight edge on the outfeed table, and using the adjusting handle, position the table so that it is 0.1 mm (or as close as possible to 0.1 mm) lower than the blade at its highest point, **Fig. 12.4**.

Re-tighten the table lock and 2 hex nuts in the adjusting handle.

### Adjusting the Infeed Table

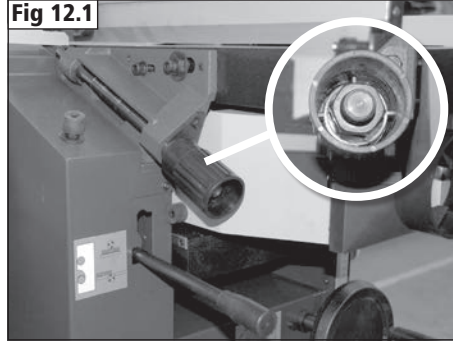
Before making any adjustments to the infeed table, ensure the outfeed table is in the correct position as described above.

Place a straight edge across the outfeed table and the infeed table, **Fig. 12.5**.

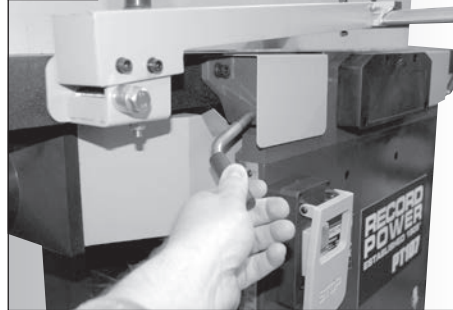


**Note:** The straight edge used must be long enough to span the full length of both tables.

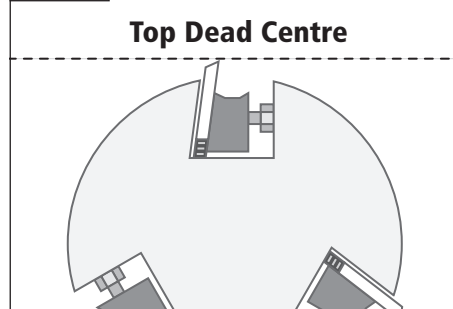
**Fig 12.1**



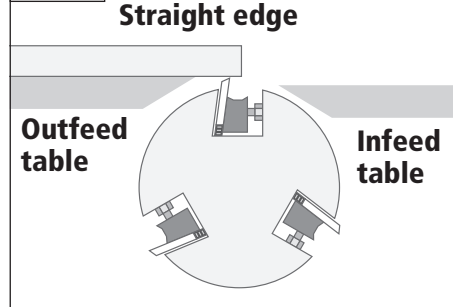
**Fig 12.2**



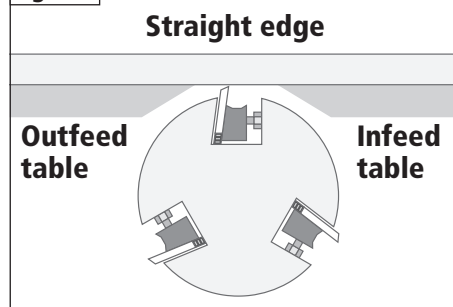
**Fig. 12.3**



**Fig. 12.4**



**Fig 12.5**

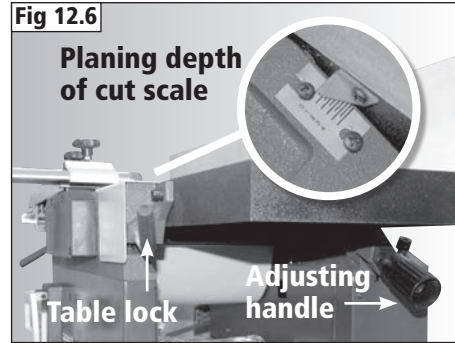


# 12. Adjustments & Maintenance

Release the infeed table lock, **Fig. 12.6**, and adjust the table until it is at the same height as the outfeed table, **Fig. 12.5**.

Lock the infeed table in place.

Set the pointer as shown in **Fig. 12.6** to 0 on the planing depth of cut scale.



## Aligning the Out Feed Table with the Cutter Block

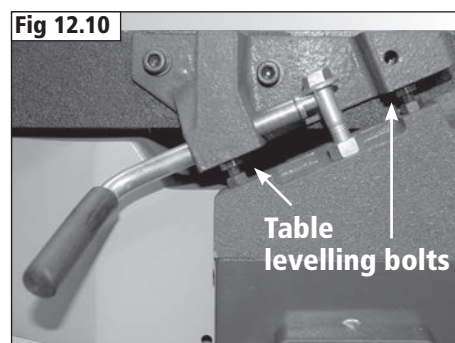
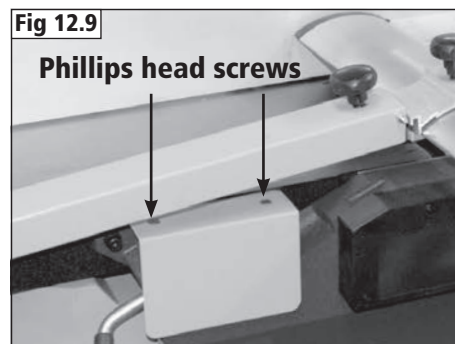
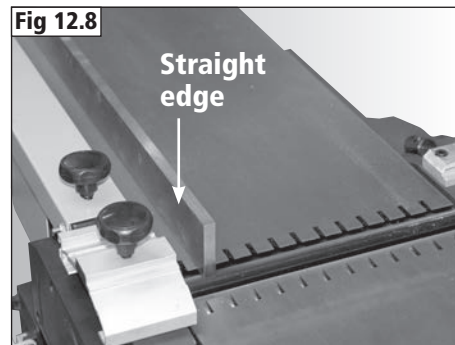
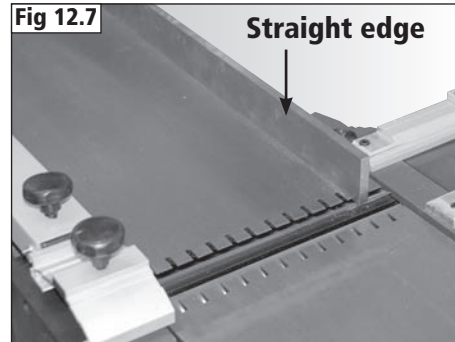
To ensure accurate results when planing and thicknessing, the in feed and out feed tables must both be aligned square to the cutter block. This alignment is carried out during assembly and manufacture and no adjustment should be needed. If the tables become misaligned due to damage in transit or misuse (e.g. moving the machine around the workshop by the tables) then follow the instructions below to realign them.

Place a straight edge on the out feed table at the end of the cutter block nearest the fence mount, **Fig. 12.7**, and position the table to be 0.1 mm (or as close as possible to 0.1 mm) below the blade, as previously described.

Place the straight edge on the out feed table at the opposite end of the cutter block as shown in **Fig. 12.8** and check that the table is at the same height in relation to the cutter block as at the other end.

If adjustment is needed, remove the protective cover as shown in **Fig. 12.9** by removing the 2 Phillips head screws from the top to gain access to the table levelling bolts, **Fig. 12.10**.

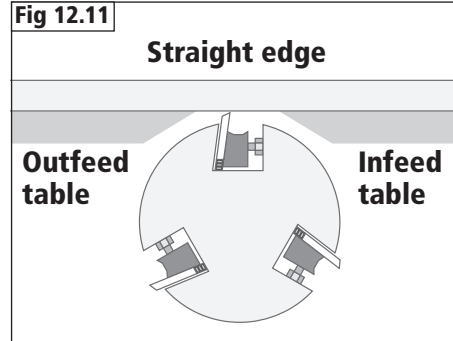
Adjust the table levelling bolts until the table is aligned square with the cutter block.



# 12. Adjustments & Maintenance

## Aligning the In Feed Table with the Cutter Block

Once the out feed table is aligned correctly, use a straight edge as shown in **Fig. 12.11** to align the in feed table along its full width to be flush with the out feed table. The in feed table also features levelling bolts which can be used to adjust the alignment in the same way as the out feed table.



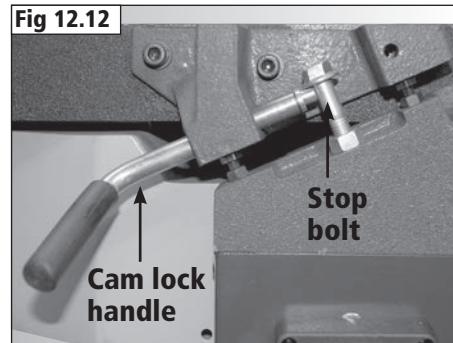
## Adjusting the Table Cam Locking Mechanism

Both the in feed and out feed tables have an adjustable cam lock mechanism to ensure correct pressure can always be applied to keep the tables in position.

To lock the table in position, push the handle in and turn clockwise.

If the cam lock handle is too difficult to apply, raise the stop bolt as shown in **Fig. 12.12**.

If the cam lock handle can be turned with ease but does not lock the table in position, lower the stop bolt until the table can be secured with the handle.





# 12. Adjustments & Maintenance



The cutter block in this machine is designed to hold three blades. Never attempt to use the machine if any of the blades are missing or damaged. Replacement blades must conform to BS EN 847-1.

## Changing the Planer Blades



**CAUTION!** This procedure involves close contact with the planer blades. Ensure that protective gloves are worn at all times to prevent injury to hands.

To make setting the blades an easier and faster operation, Record Power offer the RPPSJ Planer Blade Setting Jig. Please see online for full details.

## Check the height of the Blade

The blades should be periodically checked for sharpness and position. Adjustments should be as precise as possible to a tolerance within 1- 1.1 mm to prolong the sharpness of the blades.

Improperly adjusted blades can unbalance the cutterblock and shorten bearing life as well as producing substandard results.

The planer blades fitted to this machines are made from high speed steel and can be sharpened to maintain their cutting edge and optimise performance of the machine. The process of sharpening blades will remove a small amount of material from the blade's edge and will therefore reduce the overall width of the blade. Never attempt to use blades that have been reduced by more than 25% of their original width. Always ensure that the blade can be held securely by the blade holder. Replace defective blades immediately.



**Caution:** Before carrying out any adjustments or maintenance ensure that the machine is isolated and disconnected from the electricity supply.

## Checking the Height of the Blades

Remove the bridge guard to give access to the top of the cutter block. Raise both tables into the upright position to give access to the sides of the cutter block, **Fig. 12.13**.

Position the blade setting jig over the blade as shown in **Fig. 12.14**. The outer pads of the jig should sit fully on the cutter block. If the blade is set correctly it should be just touching the recessed area of the jig. If the blade does not touch the middle slot, or if it causes the outer pads of the gauge to not sit flush then it must be adjusted. The blades should protrude from the cutter block by a maximum of 1.1 mm.

## Adjusting the Height of the Blades

Each blade is held in the cutter block by a blade holder which runs the full length of the cutter block. The blade holder is secured in place by 4 blade holder screws which are spread across the length of the holder as shown in **Fig. 12.15**. Beneath the blade is a spring which pushes it upwards when the screws are loosened.

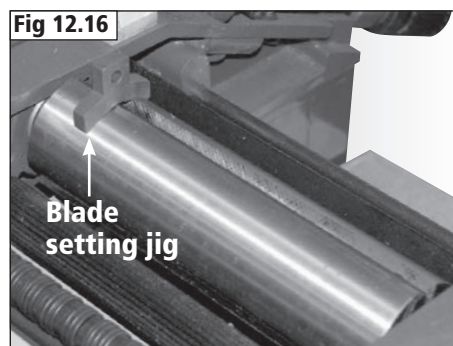
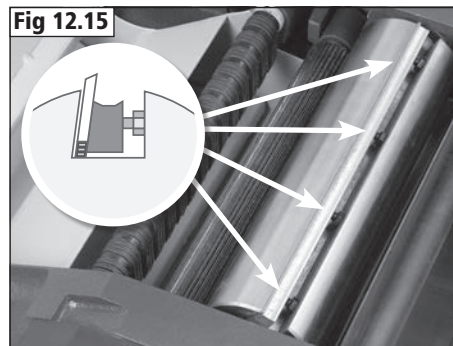
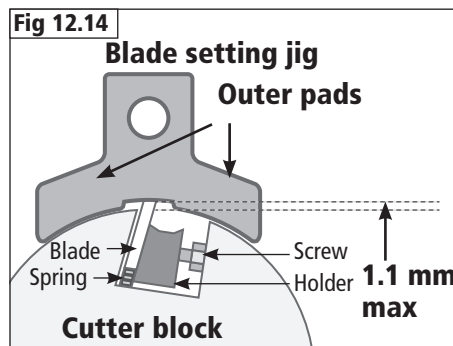
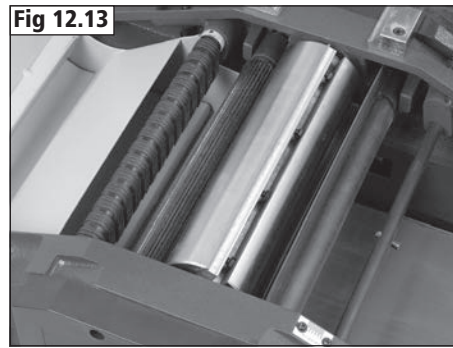
Carefully turn the cutter block until the first blade is at top dead centre.

Loosen each blade holder screw enough to allow the blade to move.

Place the blade setting jig as shown in **Fig. 12.16** over the blade at one end of the cutter block. The spring will push the blade up to meet the recess in the blade setting jig. Tighten the blade holder with the screw just enough to keep it in place but allow movement at the other end.

Repeat this process at the opposite end of the cutter block then fully tighten all blade holder screws.

Repeat the above process on the remaining 2 blades.





# 12. Adjustments & Maintenance

## Drive belts

Over time the drive belt may loosen slightly. In this case, the belt must either be tightened or replaced. Check the belt regularly for cracks or lateral tears and replace it if necessary.

To access the interior of the machine, remove the 6 screws (3 on either side of the machine) as shown in **Fig 12.17**.

In addition, the fence carrier must be removed, **Fig. 12.18**.

The side panel can now be removed by lifting upwards slightly and then away from the machine, **Fig 12.19**.

Loosen the motor mounting bolts on the side of the machine, beneath the outfeed table, **Fig 12.20**.

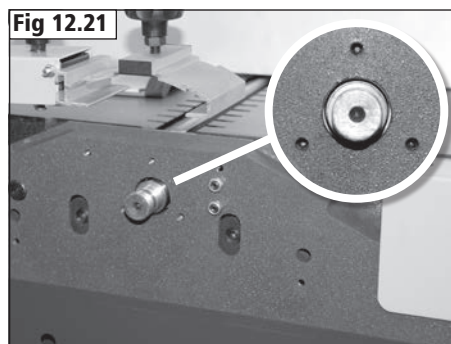
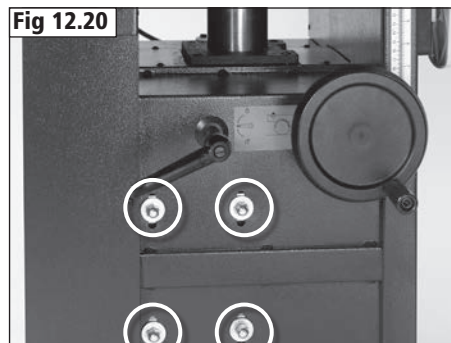
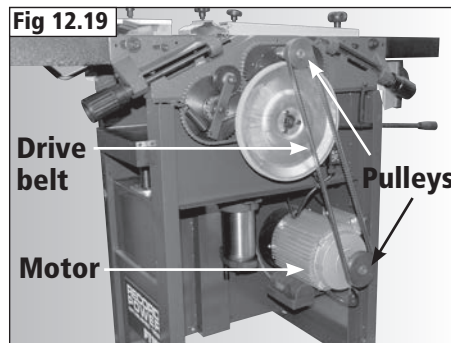
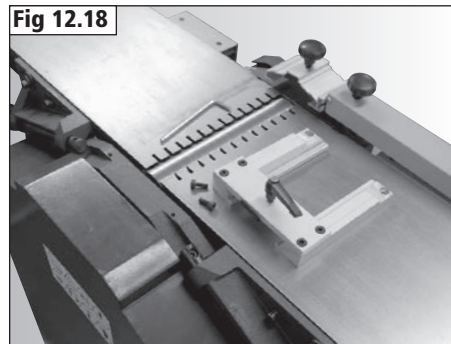
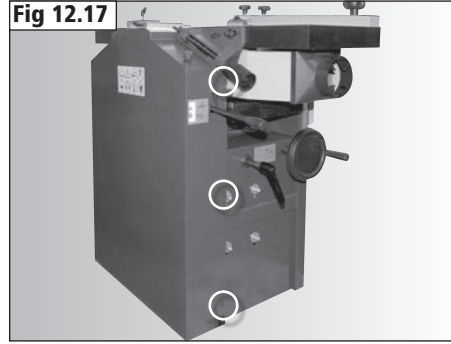
Use the weight of the motor to tension the drive belt. When the correct tension is applied, tighten the motor mounting bolts.



**When re-positioning the motor to apply tension, ensure it is kept level in the horizontal plane. Also ensure both pulleys are aligned.**

## Cutter Block Bearings

After prolonged use the bearings of the cutter block may become slightly loose and need tightening. To do so, remove the spindle cover from the side of the machine and adjust the 3 blind set screws shown in **Fig. 12.21** with a 3 mm hex wrench. This will adjust only the bearing on that side of the cutter block. However, the amount of movement that is likely to occur is so small that under normal circumstances adjustment of this bearing only will be sufficient. When tightening the blind set screws, only minimal adjustment is needed. Turn them each 1/8 of a turn at a time and stop when resistance is felt. In the highly unlikely event that the other bearing needs adjustment, please contact Record Power customer services in your area.



# 12. Adjustments & Maintenance

## Cleaning



**Caution:** Before carrying out any adjustments or maintenance ensure that the machine is isolated and disconnected from the electricity supply.

To avoid a build-up of wood dust, regularly clean the thickener drive gear using a brush, **Fig. 12.22**.

Ensure that all moving parts and the chain are sufficiently lubricated with standard machine grease. The friction wheel is a consumable part and may need replacement. See **Fig. 12.22**.

Clean the thickening bed rise and fall lead screw periodically and lubricate with standard machine grease, **Fig. 12.23**. The rod is situated behind the thickener table support column.

Clean the thickening bed support column, **Fig. 12.24**, on a regular basis to prevent the build-up of wood chips and dust and lubricate with silicone spray. Do not use ordinary oil as this will attract dust.

Keep the infeed and outfeed tables and thickening bed free of resin. Clean regularly with white spirit, then coat lightly with silicone spray to enhance passage of workpiece, **Fig 12.25**.

### Kickback Guards

Remove traces of resin as required. When lifted, the guards must drop back into position by their own weight. Test their function before each use. See **Fig. 12.26**.

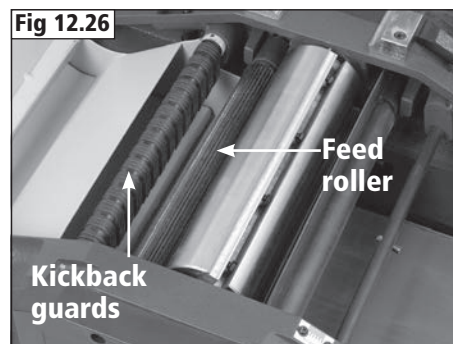
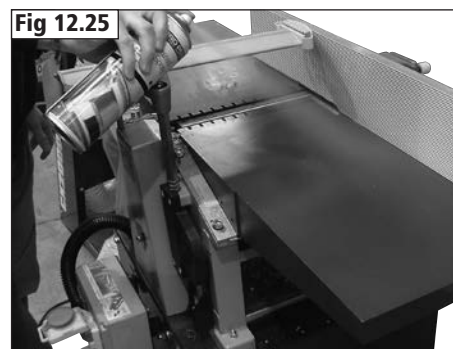
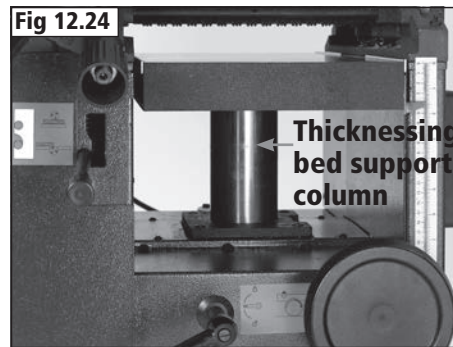
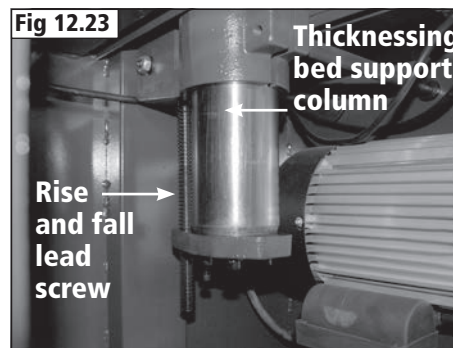
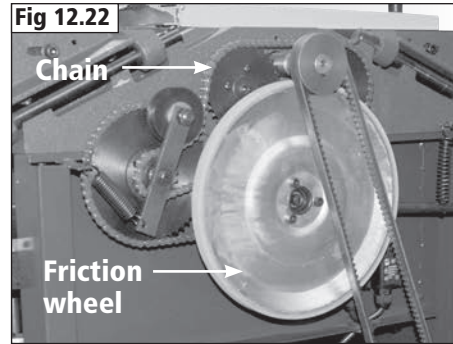
### Feed Roller

Remove traces of resin regularly, when marks appear in the timber or in the event of poor feed. See **Fig. 12.26**.

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 from standard specifications. The user of this machine shall have the sole responsibility for any malfunction which results from improper use or unauthorised modification from standard specification, faulty maintenance, damage or improper repair.



# 12. Adjustments & Maintenance

## Cutter Block & Blades



**CAUTION!** This procedure involves close contact with the planer blades. Ensure that protective gloves are worn at all times to prevent injury to hands.

Clean the blades, blade holders and cutter block to remove any traces of resin, waste and debris as often as necessary.

Each blade is held in the cutter block by a blade holder which runs the full length of the cutter block. The blade holder is secured in place by 4 blade holder screws which are spread across the length of the holder as shown in **Fig. 12.27**. Beneath the blade is a spring which pushes it upwards when the screws are loosened.

Carefully turn the cutter block until the first blade is at top dead centre.

Loosen each blade holder screw enough to free the blade.

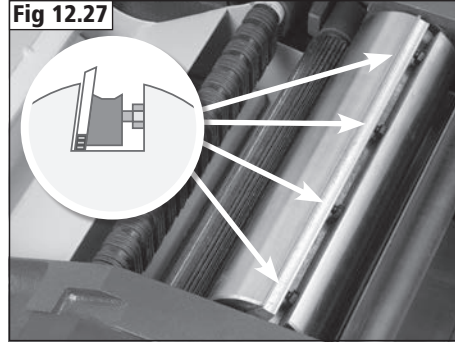
Ensuring protective gloves are worn, carefully lift the blade from the cutter block holding at each end as shown in **Fig. 12.28**.

Carefully clean the blade, blade holder and also the recess that houses them.

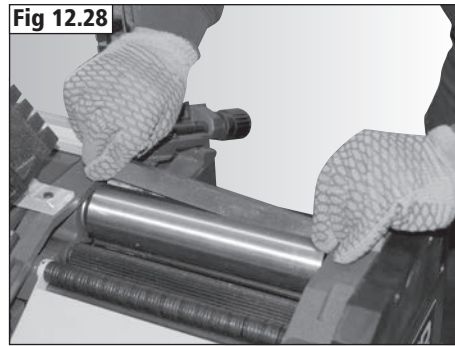
Refit the blade to the correct height as described in the **Adjusting the Height of the Blades** section of the manual.

Repeat the above process on the remaining 2 blades.

**Fig 12.27**



**Fig 12.28**



# 13. Dust Extraction

## The Importance of Dust Extraction

Suitable dust extraction is essential to avoid the possibility of serious health problems related to wood dust. It is also necessary in order to ensure the waste producing machine performs safely and effectively. Some woods are extremely toxic and in addition to suitable dust extraction machines it is recommended that PPE such as respirators are also used.

## Record Power Dust Extraction Machines

Below is a summary of the Record Power range. Please visit your local stockist or go online for full details.

### CGV286 CamVac Series Compact Extractor

36 litre capacity, 1 kW single or twin motor, 0.5 micron filtration. Includes hose.

### CGV286-3-WALL CamVac Series Wall Mounted Extractor

150 litre capacity, twin motor, 0.5 micron filtration. Includes hose.

### CGV336 CamVac Series Medium Extractor

55 litre capacity, 1 kW single or twin motor, 0.5 micron filtration. Includes hose.

### CGV386 CamVac Series Large Extractor

90 litre capacity, 1 kW twin or triple motor, 0.5 micron filtration. Includes hose.

### CGV486 CamVac Series Heavy Duty Extractor

200 litre capacity, 1 kW triple motor, 0.5 micron filtration. Includes hose.

### AC400 2 Stage Air filter with Remote, 3 speeds and Time Delay

Collects airborne dust, 1 micron filtration.

	Bandsaws	Table Saws	Planer Thicknessers	Lathes	Sanding Machines	Dust Extraction Systems	Airborne Dust Collection
CGV286	✓	✓	✓	✓	✓		
CGV286-3-WALL	✓	✓	✓	✓	✓	✓	
CGV336	✓	✓	✓	✓	✓		
CGV386	✓	✓	✓	✓	✓	✓	
CGV486	✓	✓	✓	✓	✓	✓	
AC400							✓

# 14. Electrical Connection & Wiring Diagram

Machines supplied for use in the UK are fitted with a 3 pin plug conforming to BS1363, fitted with a fuse conforming to BS1362 and appropriate to the current rating of the machine.

Machines supplied for use in other countries within the European Union are fitted with a 2 pin Schuko plug conforming to CEE 7/7.

Machines supplied for use in Australia & New Zealand are fitted with a 3 pin plug conforming to AS/NZS3112.

In all cases, if the original plug or connector has to be replaced for any reason, the wires within the mains power cable are colour coded as follows:

## 230 V (Single Phase)

Brown: Live (L)  
 Blue: Neutral (N)  
 Green and Yellow: Earth (E)

The wire coloured brown must always be connected to the terminal marked 'L' or coloured red.

The wire coloured blue must always be connected to the terminal marked 'N' or coloured black.

The wire coloured green and yellow must always be connected to the terminal marked 'E' or with the earth symbol:



or coloured green / green and yellow.

It is important that the machine is effectively earthed. Some machines will be clearly marked with the double insulated logo:



In this case there will not be an earth wire within the circuit.

In the case of the BS1363 plug for use in the UK, always ensure that it is fitted with a fuse conforming to BS1362 appropriate to the rating of the

machine. If replacing the original fuse, always fit a fuse of equivalent rating to the original. Never fit a fuse of a higher rating than the original. Never modify the fuse or fuse holder to accept fuses of a different type or size.

Where the current rating of the machine exceeds 13 A at 230 V, or if the machine is designated for use on a 400 V 3 phase supply a connector conforming to BS4343 (CEE17 / IEC60309) will be used.

230 V machines will be fitted with a blue 3 pin connector. The wiring for this type of this connector will be the same as shown above.

400 V, 3 phase machines will be fitted with a red 4 or 5 pin connector. The wiring for this type of connector is as shown below:

## 400 V (3 phase)

Brown: Live (L1)  
 Black: Live (L2)  
 Grey: Live (L3)  
 Blue: Neutral (N)  
 Green and Yellow: Earth (E)

The wire coloured brown must always be connected to the terminal marked 'L1'.

The wire coloured black must always be fitted to the terminal marked 'L2'.

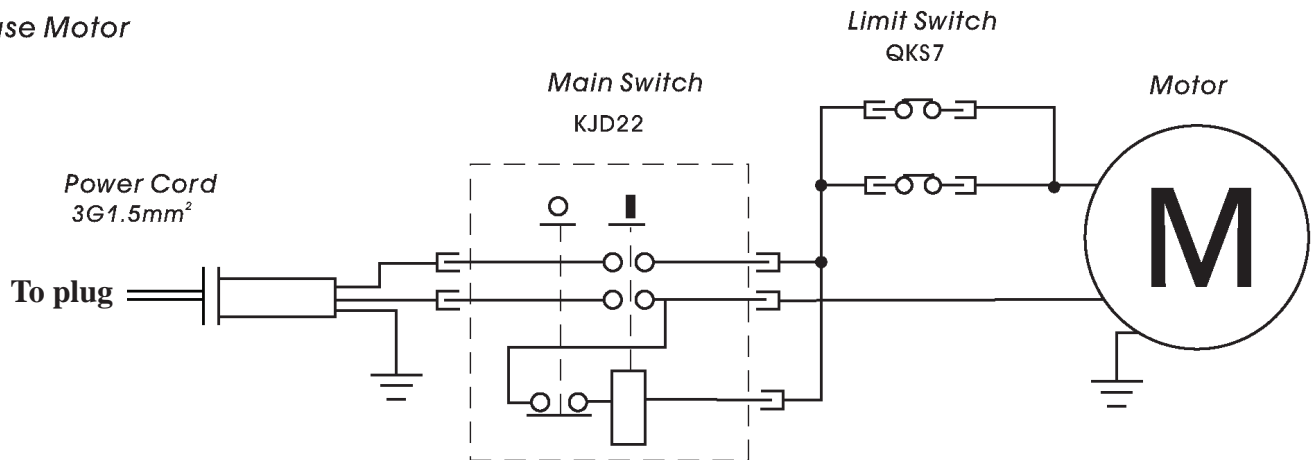
The wire coloured grey must always be connected to the terminal marked 'L3'.

The wire coloured blue must always be connected to the terminal marked 'N' or coloured black.

The wire coloured green and yellow must always be connected to the terminal marked 'E' or with the earth symbol

If in doubt about the connection of the electrical supply, always consult a qualified electrician.

## 1phase Motor

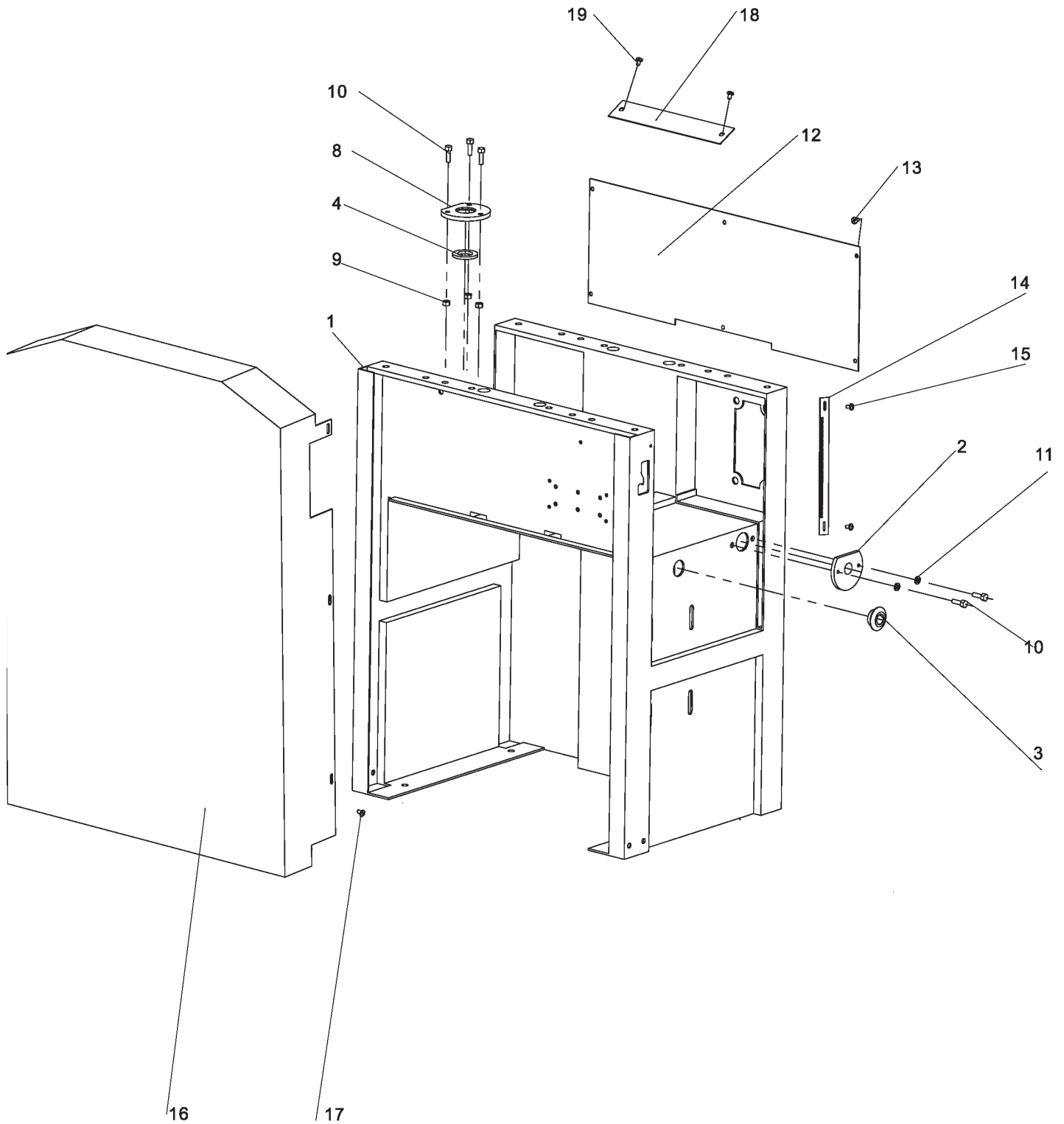


# 15. Troubleshooting

Problem	Cause	Solution
Motor is slow or weak.	<ol style="list-style-type: none"> <li>1. Low voltage supply.</li> <li>2. Circuit is overloaded with appliances, lights, or other electrically powered equipment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Request a voltage check from local power company.</li> <li>2. Do not use other appliances or electrically powered equipment on the same circuit when using this machine.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Machine is operating beyond capacity.</li> <li>2. Dull planer blades.</li> <li>3. Low voltage supply.</li> </ol>	<ol style="list-style-type: none"> <li>1. Take smaller cuts and / or reduce planing feed speed.</li> <li>2. Sharpen or replace the planer blades.</li> <li>3. Request a voltage check from the local power company.</li> </ol>
The cut burns the timber.	<ol style="list-style-type: none"> <li>1. Planer blades are dull.</li> </ol>	<ol style="list-style-type: none"> <li>1. Sharpen or replace the planer blades.</li> </ol>
Height handles are hard to turn.	<ol style="list-style-type: none"> <li>1. Dust has collected on the mechanisms inside the base.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean and lubricate the mechanisms inside the base.</li> </ol>
Planer thicknesser vibrates excessively.	<ol style="list-style-type: none"> <li>1. Floor surface is uneven.</li> <li>2. V-belt is damaged.</li> <li>3. Planer blades are damaged.</li> <li>4. Loose bolt, screws or nuts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Readjust the machine.</li> <li>2. Replace the V-belt.</li> <li>3. Replace the planer knives.</li> <li>4. Tighten all hardware.</li> </ol>
The machine does not start.	<ol style="list-style-type: none"> <li>1. Power cord is not plugged in.</li> <li>2. Circuit fuse is blown.</li> <li>3. Circuit breaker is tripped.</li> <li>4. Motor cord or switch is damaged.</li> <li>5. Microswitches not made.</li> <li>6. Motor windings are worn out.</li> <li>7. Power switch is faulty.</li> <li>8. Power switch connections are loose or damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Plug in power cord to volt electrical outlet.</li> <li>2. Replace circuit fuse.</li> <li>3. Reset circuit breaker.</li> <li>4. Have the motor cord or switch replaced.</li> <li>5. Switch microswitch.</li> <li>6. Replace the motor.</li> <li>7. Replace the power switch.</li> <li>8. Check and repair if necessary.</li> </ol>
Fuses blow or circuit breakers trip frequently.	<ol style="list-style-type: none"> <li>1. Motor is overloaded.</li> <li>2. Fuses or circuit breakers are wrong size or defective.</li> <li>3. Dull planer blades.</li> <li>4. Power Switch is defective.</li> <li>5. Dull planer blades.</li> <li>6. Fuses or circuit breakers are wrong size or defective.</li> <li>7. Feeding work-piece too rapidly.</li> <li>8. Cold ambient temperature produces current surge on operation.</li> </ol>	<ol style="list-style-type: none"> <li>1. Feed work-piece more slowly.</li> <li>2. Replace fuses or circuit breakers.</li> <li>3. Replace the planer blades.</li> <li>4. Have the power switch replaced.</li> <li>5. Sharpen or replace the planer blades.</li> <li>6. Replace fuses or circuit breakers.</li> <li>7. Feed work-piece more slowly.</li> <li>8. Increase ambient temperature of work area.</li> </ol>
Machine is noisy when running.	<ol style="list-style-type: none"> <li>1. Motor is loose or defective.</li> <li>2. Feed roller drive chain is loose.</li> <li>3. Cutter block bearings are loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Have the motor checked/repared.</li> <li>2. Adjust tension.</li> <li>3. Adjust as described in the <b>Adjustment &amp; Maintenance</b> section of this manual.</li> </ol>



# 16. Parts Lists & Diagrams

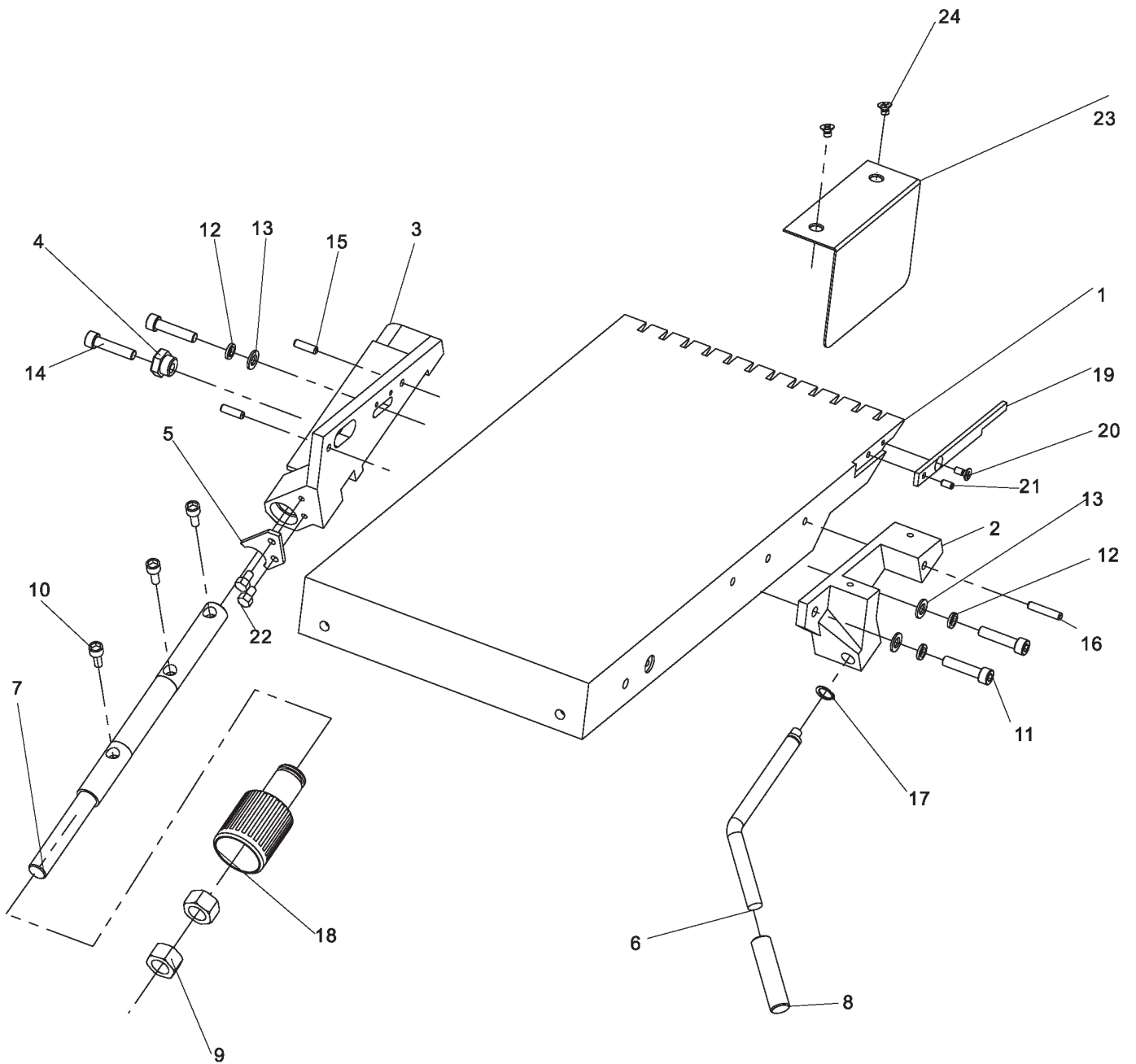


NO.	DESCRIPTION	QUANTITY
1	Main frame	1
2	Shaft seat, thickening table	1
3	Seat, lock lever	1
4	Oil seal	1
8	Seat, bearing	1
9	Hex lock nut	3
10	Hex screw M6 x 16 mm	5
11	Washer 6 mm	2

NO.	DESCRIPTION	QUANTITY
12	Inner shield	1
13	Cross sunk head screw M5 x 6 mm	5
14	Scale, thickening height	1
15	Pan head screw M5 x 6 mm	5
16	Gear cover	1
17	Pan head screw M5 x 6 mm	6
18	Cover plate	2
19	Pan head screw M5 x 8 mm	4

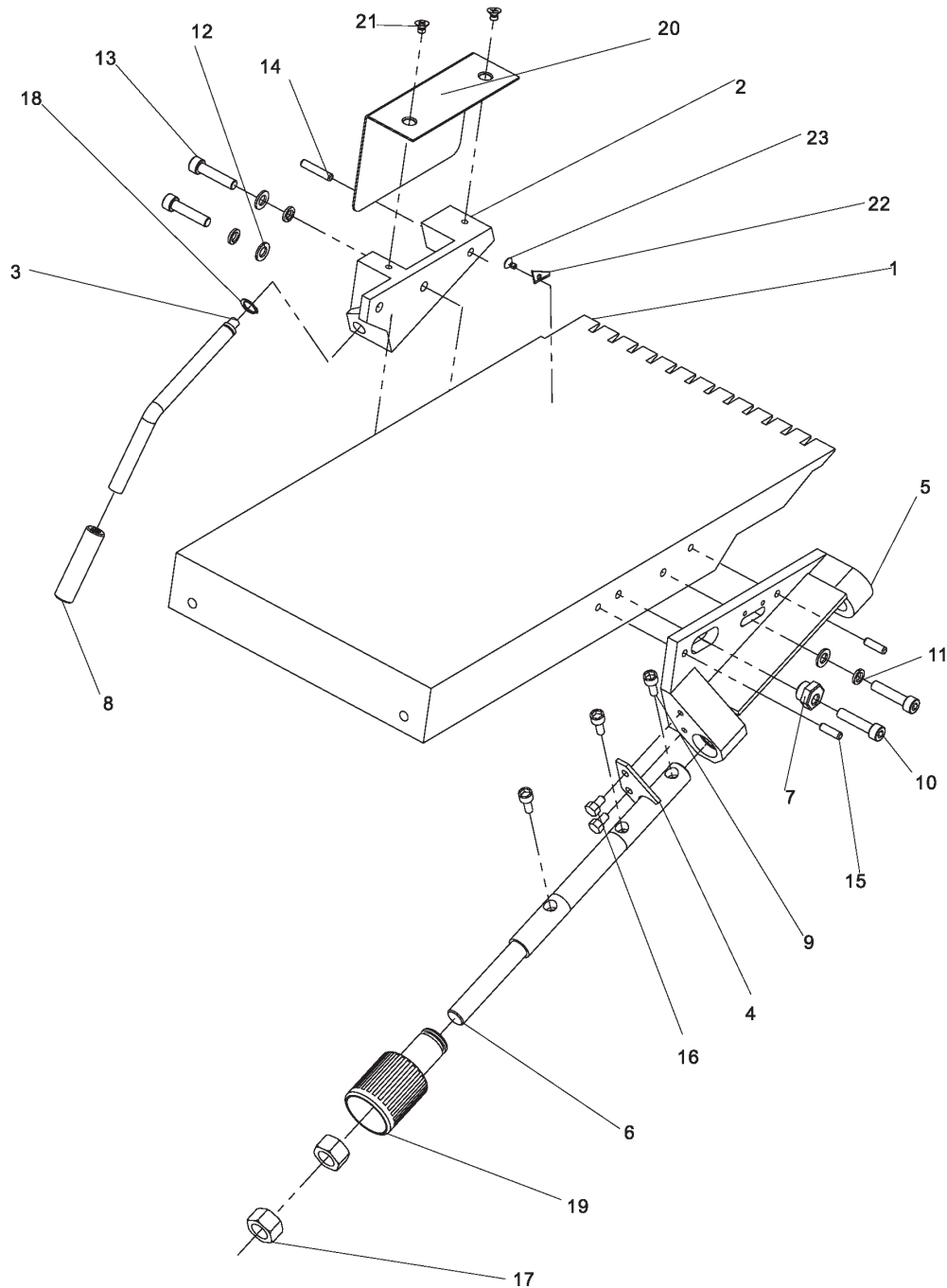
NO.	DESCRIPTION	QUANTITY
12	Inner shield	1
13	Cross sunk head screw M5 x 6 mm	5
14	Scale, thickening height	1
15	Pan head screw M5 x 6 mm	5
16	Gear cover	1
17	Pan head screw M5 x 6 mm	6
18	Cover plate	2
19	Pan head screw M5 x 8 mm	4

# 16. Parts Lists & Diagrams - cont.



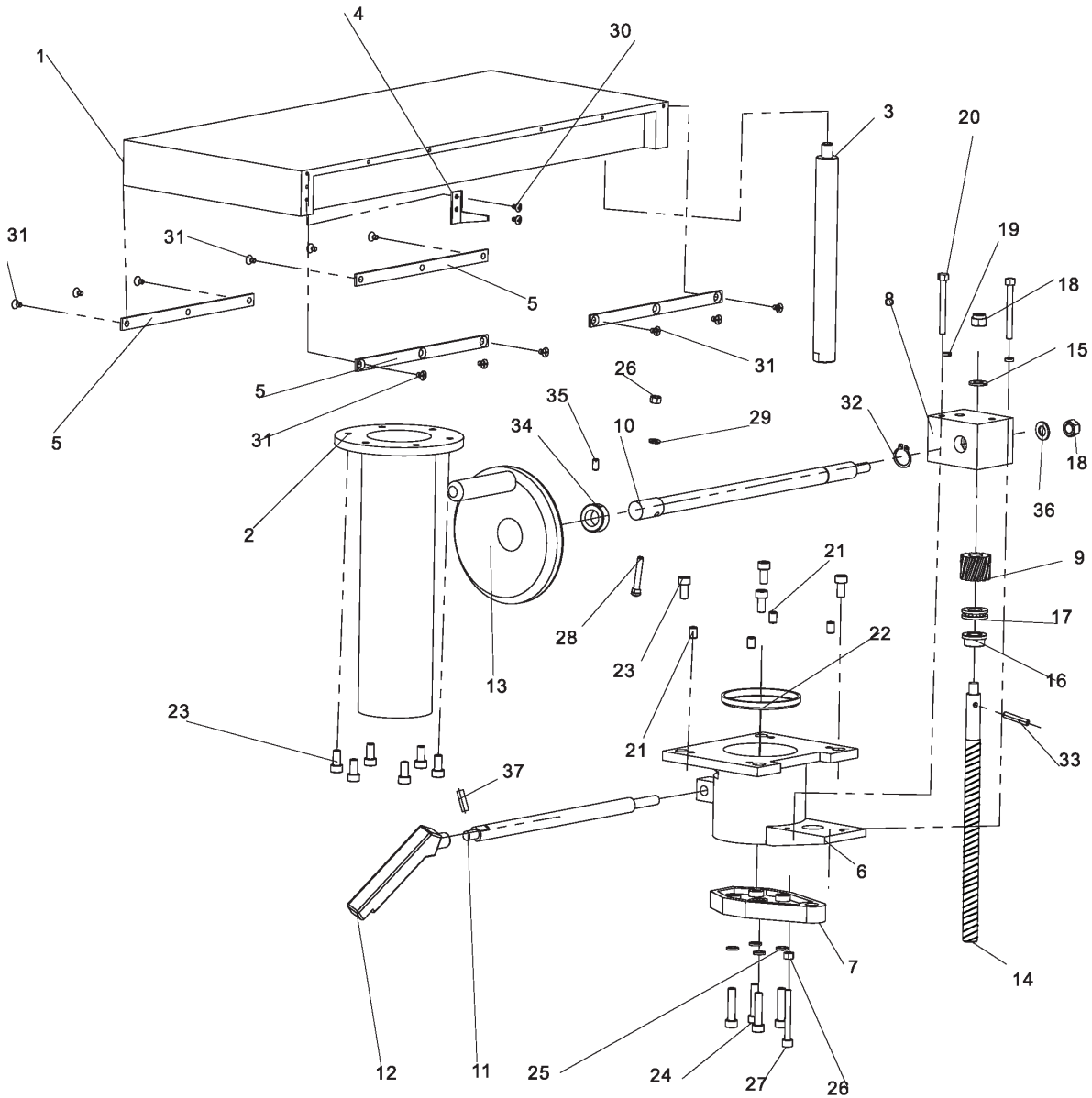
NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Outfeed table, planer	1	13	Washer 8 mm	3
2	Table lock seat	1	14	Hex screw M8 x 30 mm	2
3	Table swing seat	1	15	Roll pin D6 x 20 mm	2
4	Eccentric seat	1	16	Roll pin D6 x 30 mm	1
5	Fork	1	17	Circle ring 12 mm	1
6	Table lock	1	18	Handle, table swing	1
7	Table swing shaft	1	19	Safe link rod	1
8	Sleeve, table lock	1	20	Cross sunk head screw M5 x 12 mm	1
9	Hex nut M16	2	21	Roll pin 5 x 10 mm	1
10	Hex screw M6 x 20 mm	3	22	Hex head screw M6 x 12 mm	2
11	Hex screw M8 x 25 mm	2	23	Shield plate	1
12	Spring washer 8 mm	3	24	Cross sunk head screw M6 x 8 mm	2

# 16. Parts Lists & Diagrams - cont.



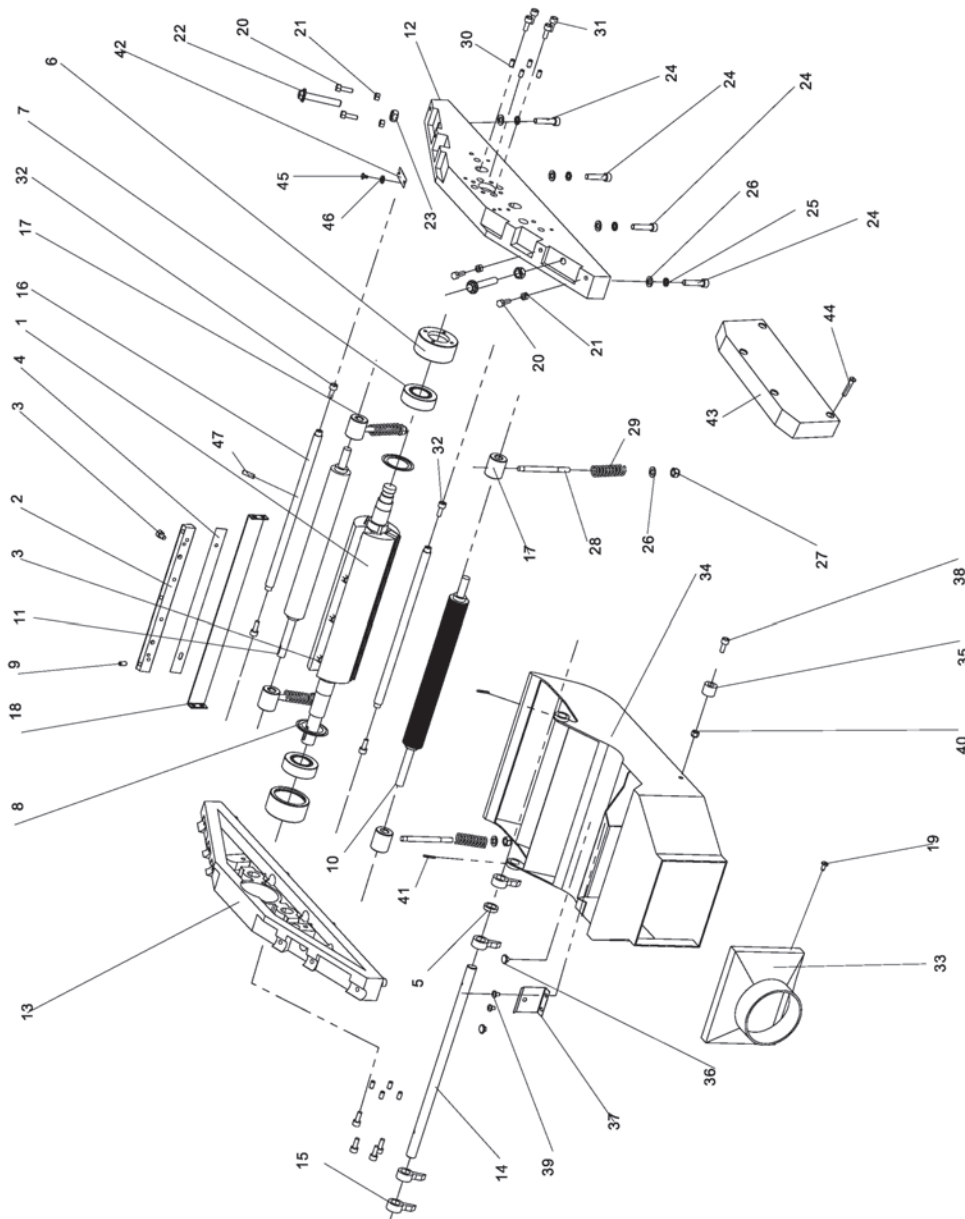
NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Feed table, planer	1	13	Hex screw M8 x 25 mm	2
2	Table lock seat	1	14	Roll pin D6 x 30 mm	1
3	Table lock	1	15	Roll pin D6 x 20 mm	2
4	Fork	1	16	Hex head screw M6 x 12 mm	2
5	Table swing seat	1	17	Hex nut M16	2
6	Table swing shaft	1	18	Circle ring 12 mm	1
7	Eccentric seat	1	19	Handle, table swing	1
8	Sleeve, table lock	1	20	Shield plate	1
9	Hex screw M6 x 20 mm	3	21	Cross sunk head screw M6 x 8 mm	2
10	Hex screw M8 x 30 mm	2	22	Pointer	1
11	Spring washer 8 mm	3	23	Pan head screw M4 x 8 mm	1
12	Washer 8 mm	3			

# 16. Parts Lists & Diagrams - cont.



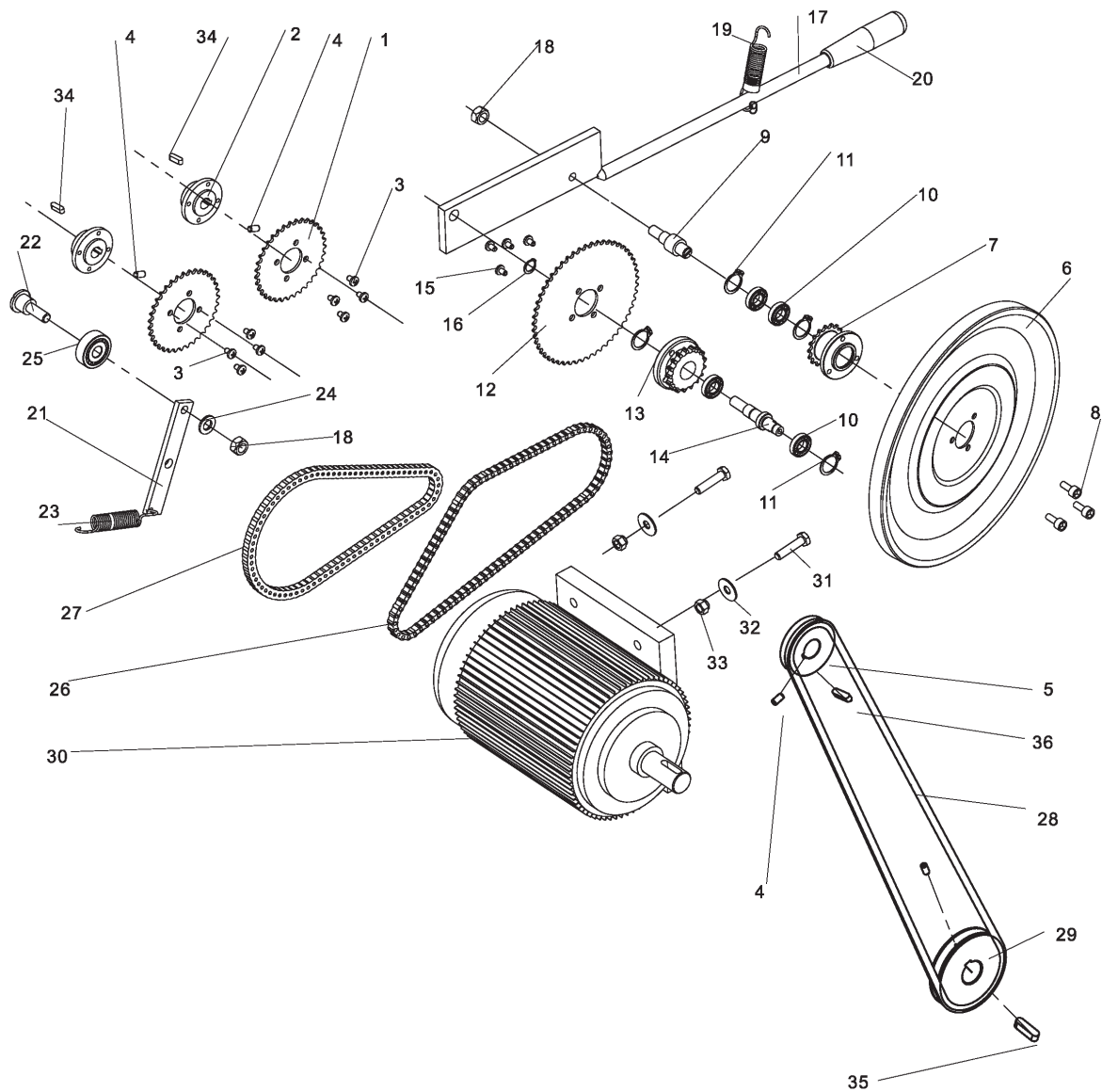
NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Thickening table	1	20	Hex head screw M6 x 60 mm	2
2	Raise guide rail	1	21	Set screw M8 x 12 mm	4
3	Special guide	1	22	Oil seal	1
4	Height indicator	1	23	Hex screw M8 x 16 mm	10
5	Edge plate	4	24	Hex screw M8 x 35 mm	4
6	Fixed guide rail	1	25	Spring washer 8 mm	4
7	Screw guide	1	26	Hex nut M6	2
8	Raise gear seat	1	27	Hex screw M6 x 55 mm	1
9	Raise gear	1	28	Carriage bolt M6 x 40 mm	1
10	Raise shaft	1	29	Washer 6 mm	1
11	Clamp rod	1	30	Pan head screw M4 x 10 mm	2
12	Clamp lever	1	31	Cross sunk head screw M4 x 8 mm	12
13	Handle wheel, raising	1	32	Circle ring 18 mm	1
14	Rise and fall lead screw	1	33	Roll pin 5 x 10 mm	1
15	Spacer	1	34	Collar	1
16	Spacer	1	35	Set screw M8 x 8 mm	1
17	Thrust bearing 51102	1	36	Washer 10 mm	1
18	Hex lock nut M10	2	37	Roll pin 2.5 x 12 mm	1
19	Spring washer 6 mm	2			

# 16. Parts Lists & Diagrams - cont.



NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Cutter block	1	20	Hex head screw M6 x 60 mm	2
2	Blade holder	3	21	Set screw M8 x 12 mm	4
3	Hex head screw M6 x 12 mm	12	22	Oil seal	1
4	Blade	3	23	Hex screw M8 x 16 mm	10
5	Spacer	16	24	Hex screw M8 x 35 mm	4
6	Bearing cover	2	25	Spring washer 8 mm	4
7	Bearing 6205	2	26	Hex nut M6	2
8	Circle ring 52 mm	2	27	Hex screw M6 x 55 mm	1
9	Set screw M6 x 12 mm	6	28	Carriage bolt M6 x 40 mm	1
10	In-feed roller	1	29	Washer 6 mm	1
11	Outfeed roller	1	30	Pan head screw M4 x 10 mm	2
12	Bearing house, front	1	31	Cross sunk head screw M4 x 8 mm	12
13	Handle wheel, raising	1	32	Circle ring 18 mm	1
14	Raise guide rod	1	33	Roll pin 5 x 10 mm	1
15	Spacer	1	34	Collar	1
16	Spacer	1	35	Set screw M8 x 8 mm	1
17	Thrust bearing 51102	1	36	Washer 10 mm	1
18	Hex lock nut M10	2	37	Roll pin 2.5 x 12 mm	1
19	Spring washer 6 mm	2			

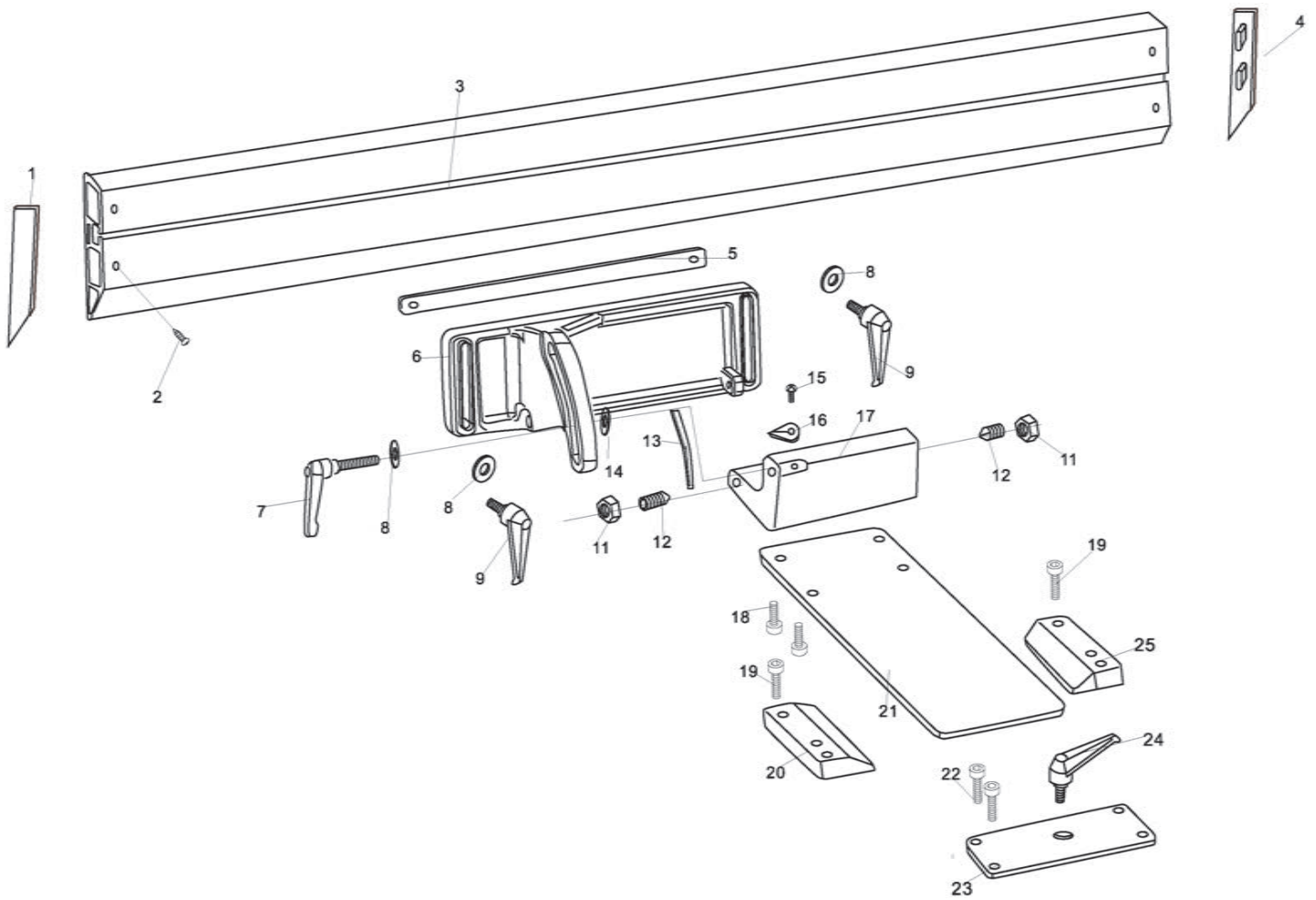
# 16. Parts Lists & Diagrams - cont.



NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Sprocket A	2	19	Spring	1
2	Flange	2	20	Handle, friction lever	1
3	Pan head screw M5 x 8 mm	8	21	Tension plate	1
4	Set screw M6 x 6 mm	4	22	Tension rod	1
5	Shaft pulley	1	23	Spring	1
6	Friction wheel	1	24	Washer 10mm	1
7	Sprocket B	1	25	Bearing 6303	1
8	Hex screw M6 x 12 mm	3	26	Feeding chain	1
9	Shaft, friction wheel	1	27	Chain	1
10	Bearing 61901	4	28	Belt XPZ1250	1
11	Circle ring 24 mm	4	29	Motor pulley	1
12	Sprocket C	1	30	Motor	1
13	Sprocket D	1	31	Hex head screw w.flange M8 x 25 mm	4
14	Shaft, sprocket	1	32	Special flat washer 8 mm	4
15	Pan head screw M6 x 8 mm	4	33	Cap nut M8	4
16	Circle ring 12 mm	1	34	Flat key 5 x 5 x 16 mm	2
17	Lever, friction wheel	1	35	Flat key 8 x 7 x 28 mm	1
18	Hex nut M10	2	36	Flat key 6 x 6 x 16 mm	1

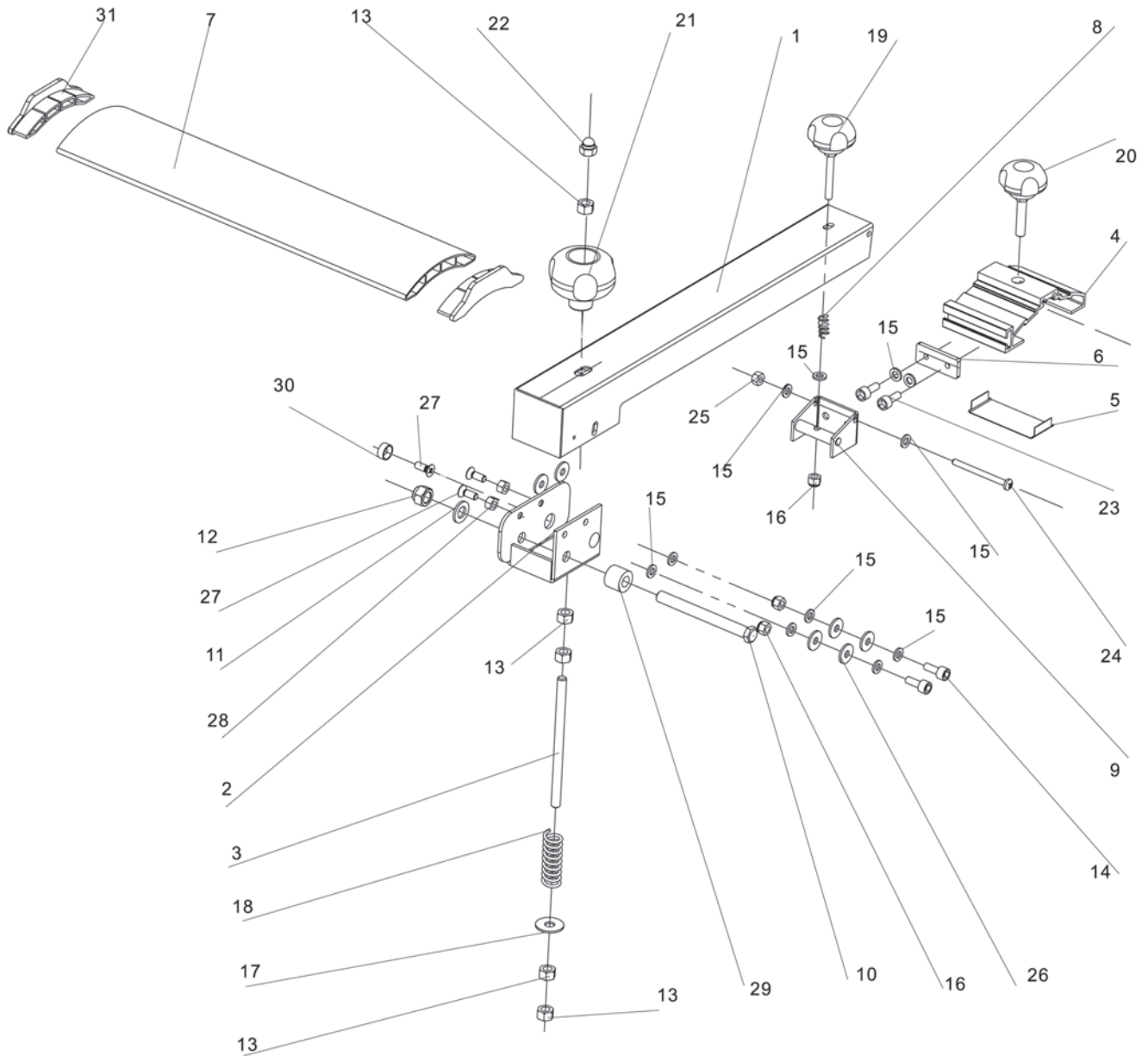


# 16. Parts Lists & Diagrams - cont.



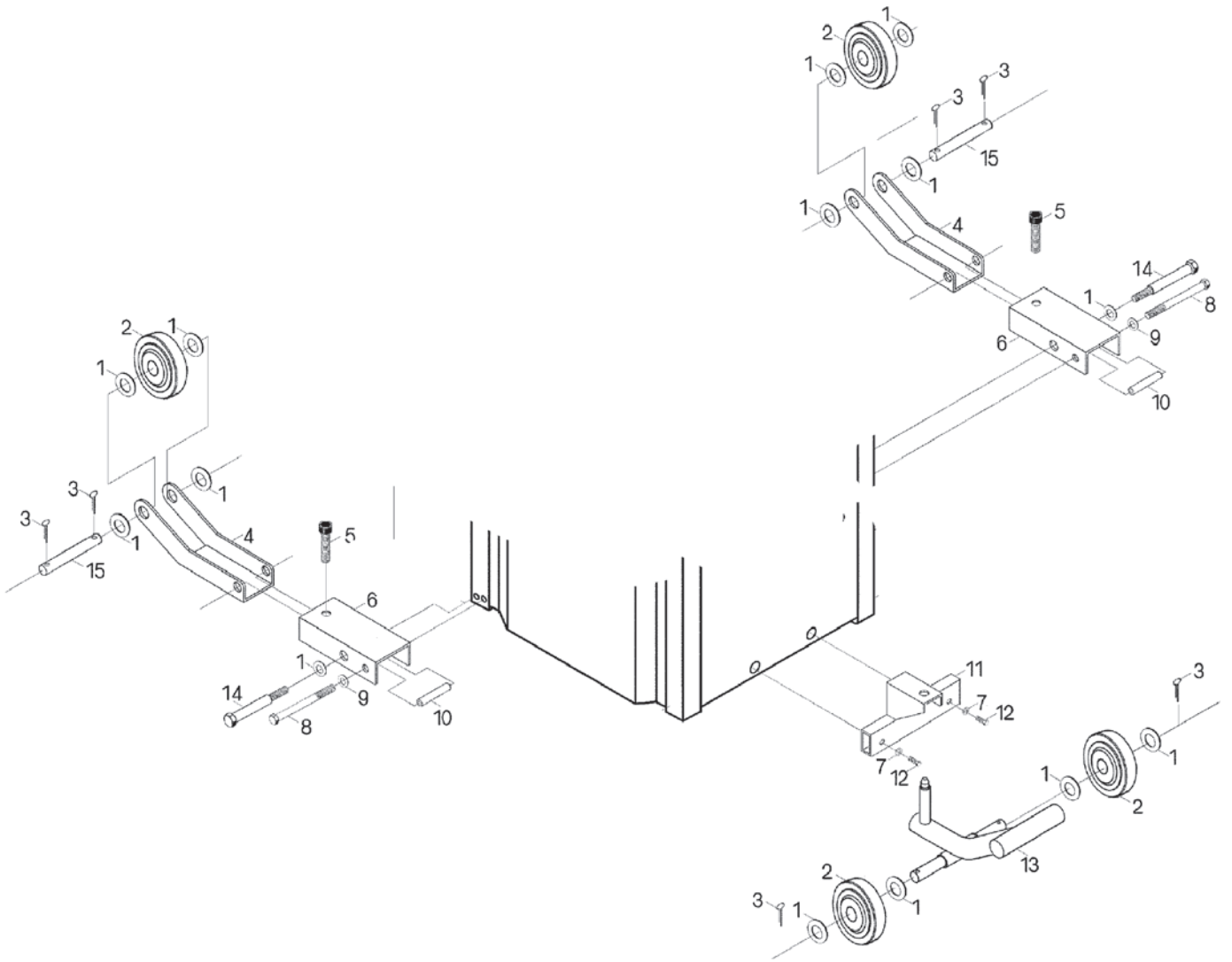
NO.	DESCRIPTION	QUANTITY
1	End cap (right)	1
2	Screw	1
3	Fence extrusion	1
4	End cap (Left)	1
5	Fence locating strip	1
6	Fence bracket	1
7	Ratchet handle M8	1
8	Washer M8	3
9	Ratchet handle M8	1
11	Locking nut 10 mm	1
12	Blind set screws 10 mm	2
13	Scale	1
14	Spacer	1
15	Screw	1
16	Pointer	1
17	Fence block	1
18	Hex bolt M6	2
19	Hex bolt M6	1
20	Aluminium fence seat	1
21	Fence plate	1
22	Hex bolts	2
23	Fence lock plate (left)	1
24	Ratchet Handle M8	1
25	Fence lock plate (right)	1

# 16. Parts Lists & Diagrams - cont.



NO.	DESCRIPTION	QUANTITY	NO.	DESCRIPTION	QUANTITY
1	Bridge guard arm	1	17	Flat washer 8 mm	1
2	Swivel base, guard	1	18	Spring	1
3	Rod, spring	1	19	Star-type screw M6 x 35 mm	1
4	Joint, bridge guard	1	20	Star-type screw M8 x 35 mm	1
5	Insert, guard	1	21	Star-type nut	1
6	Bolt guide	1	22	Cap nut M8	1
7	Protective guard plate	1	23	Hex screw M6 x 10 mm	2
8	Spring	1	24	pan head screw M5 x 65 mm	1
9	Knot	1	25	Hex lock nut M5	1
10	Hex head screw M10 x 100 mm	1	26	Spacer	6
11	Washer 10 mm	1	27	Cross sunk head screw M6 x 16 mm	3
12	Hex lock nut M10	1	28	Hex lock nut M6	2
13	Hex nut M8	5	29	Spacer	1
14	Hex screw M6 x 20 mm	2	30	Spacer	1
15	Washer 6 mm	11	31	End cap, bridge guard	2
16	Hex lock nut M6	5			

# 16. Parts Lists & Diagrams - cont.



NO.	DESCRIPTION
1	Washer 16 mm
2	Castor
3	Roll pin 4 x 30 mm
4	Bracket castor
5	Hex screw M12 x 50 mm
6	Bracket castor
7	Washer 10 mm
8	Hex screw M12 x 80 mm
9	Washer 12 mm
10	Bushing bracket
11	Support, pull rod
12	Hex screw M10 x 55 mm
12	Pull rod
14	Bolt, bracket
15	Shaft, castor

# EC Declaration of Conformity

**Cert No: EC / PT107 / 4**

**Record Power Ltd**

Centenary House, 11 Midland Way, Barlborough Links, Chesterfield, Derbyshire  
S43 4XA, United Kingdom

declares that the machinery described:

- 1. Type: **Planer Thicknesser**
- 2. Model No: **PT107**
- 3. Serial No: **FT20220005, FT20220007, FT20220001, FT20220003**

Will conform with the following standards:

- MACHINERY DIRECTIVE: 2006/42/EC
- ADDITIONAL USED EC DIRECTIVES: EMC Directive 2014/30/EU
- USED HARMONIZED STANDARDS: EN ISO 12100:2010  
2014/35/EU  
EN 60204-1:2018  
EN ISO 19085-1:2021  
EN ISO 19085-7:2019  
EN IEC 55014-1:2021  
EN IEC 61000-3-2:2019+A1  
EN 61000-3-3:2013+A1+A2  
EN IEC 55014-2:2021



and complies with the relevant essential health and safety requirements and conforms to the machinery example for which the EC Type-Examination certificate numbers

**BM 50502344 (230v) BM 50502346 (400v) and AE 50502661 0001**

have been issued at:

TÜV Rheinland LGA Products GmbH, Tillystrasse 2, 90431, Nürnberg, Germany

Signed.....*Andrew Greensted*.....Dated: 24/03/2022 – Chesterfield / U.K.

**Andrew Greensted**  
Managing Director

Technical file held by Andrew Greensted, Record Power Ltd, Centenary House, 11 Midland Way, Barlborough Links, Chesterfield, Derbyshire, S43 4XA, United Kingdom

<table border="1"><tr><td>EC</td><td>REP</td></tr></table>	EC	REP	Record Power B.V., Verlengde Poolseweg 16, 4818 CL BREDA, Netherlands, Tel: +31 76 52 44 766
EC	REP		











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