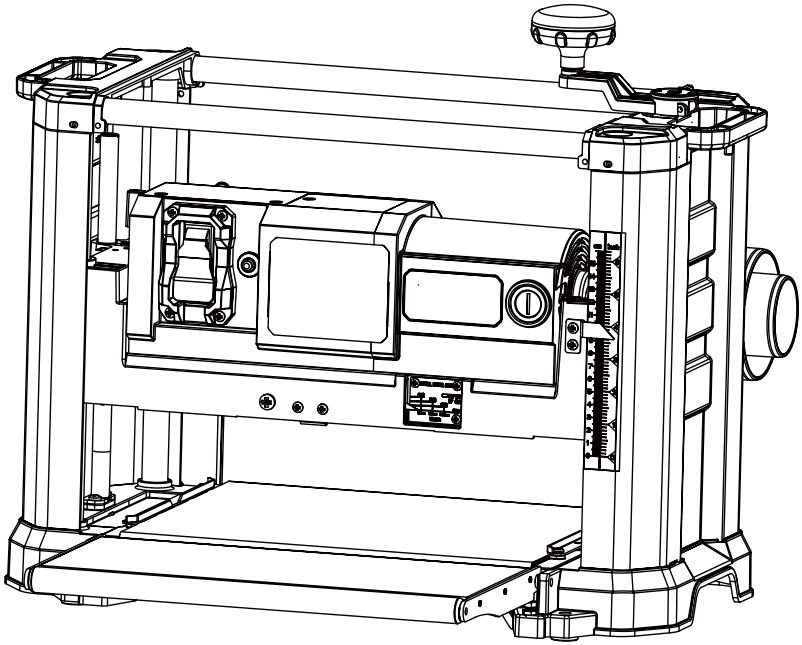
WOODSTARTER



Thickness Planer

TP10K

USER MANUAL V 1.0

*Please read carefully before use. Please keep it for future reference.

CONTENT

SAFETY PRECAUTIONS

IMPORTANT SAFETY INSTRUCTIONS FOR ALL TOOLS

AWARNING: For your safety, read the instruction manual thoroughly before operating the planer. Failure to follow these warnings may result in personal injury or serious damage to the planer. When servicing the tool, use only identical replacement parts. Damaged cords must be replaced by an authorized service center.

1. Keep children away from the planner. Maintain a clean work area, as a cluttered workbench can lead to accidents. Avoid working near flammable or explosive materials, liquids, or gases to prevent accidents. Do not use the planer in wet environments, and stop working during thunderstorms or lightning.
2. Do not operate the planer if you are fatigued, under the influence of alcohol, or taking medication that may impair your abilities. Avoid wearing loose clothing, jewelry, or accessories, and tie back long hair to prevent them from getting caught in the machine.
3. For your safety, always wear protective goggles, a dust mask, and earplugs. Unplug the planer when not in use, before performing maintenance, or when replacing the blades. Ensure the power switch is in the "OFF" position before plugging in the planer to avoid unexpected starts.
4. Do not stand on the planer.
5. Always unplug the planer when it is not in use or when leaving the work area. Ensure that it is completely powered off. Use a power supply that matches the voltage and frequency specified on the machine's nameplate.
6. Do not force the tool. It will perform better and more safely when used within its designed capacity.
7. Inspect damaged parts carefully before using the planer. Check for alignment of moving parts, binding of components, breakage, or other conditions that may affect operation. Damaged guards or other parts should be repaired or replaced by a qualified technician.

Additional Specific Safety Rules for Planers

WARNING: To reduce the risk of injury, users must read and fully understand the instruction manual before operating the planer.

1. Keep your hands away from the underside of the cutter head carriage. Never rotate the cutter block directly with your hands to avoid injury.
2. Feed the workpiece into the planer according to the direction of the feed arrows on the machine.
3. Never clear clogs, replace cutter knives, or perform any maintenance/ adjustment while the machine is plugged in.
4. Ensure all cutter knives are installed as described in the instruction manual and that all bolts are securely tightened.
5. Remove shavings from the exhaust chute using a brush or vacuum after the planer has been powered off and the cutter head has stopped spinning.
6. Ensure all screws are properly tightened before operating the planer.
7. Only plane smooth, lump-free wood. Ensure the workpiece is free of nails, screws, stones, or other foreign objects that could damage the blade.
8. Do not stand directly in front of or behind the planer. The workpiece may kick back and cause injury.
9. Blades are extremely sharp. Handle them with extreme caution and vigilance during use and maintenance.
10. Only start working when the blade shaft has reached its maximum speed.
11. Do not use dull blades, which can cause clogging and uneven surfaces. Replace both blades simultaneously with the original blades of the same specifications.
12. Before turning on the planer, ensure the switch is in the "OFF" position. Allow the machine to reach full operating speed before feeding any material.
13. Avoid forcing cuts. Slowing or stalling may cause motor overheating. Let the automatic feed operate as intended.
14. Always feed the material from the in-feed side to the out-feed side. Do not attempt to reverse the direction of the workpiece while it is being planned maintain the planner regularly and follow the maintenance instructions in this manual

WARNING: For your safety, it is recommended that two people carry the planer to avoid injury.

WARNING: Dust created by sanding, sawing, grinding, drilling, and other woodworking activities may contain chemicals known to cause cancer, birth defects, or other reproductive harm. Always use proper dust collection systems and wear protective gear.

SPECIFICATIONS

• Machine specifications

Power: ····· 120V~ 60Hz ; 15A
No-load Speed: ····· 10000 RPM
Number of cutting blade: ····· 2
Dust chute adapter sizes ····· 1-2/5 , 2-1/2 , 4 inches
Single planing depth: ····· 0-1/8 inches
Max. planing width: ····· 13 inches
Max. planing height of workpiece (material): ····· 6 inches
Min. planing height of workpiece (material): ····· 1/4 inches
Feed Rate ····· 21 FPM

• Planing instruction

Single planing width 0-3” ····· Max. planing thinkness 1/8 inches
Single planing width 3”-6” ····· Max. planing thinkness 1/12 inches
Single planing width 6”-13” ····· Max. planing thinkness 1/24 inches

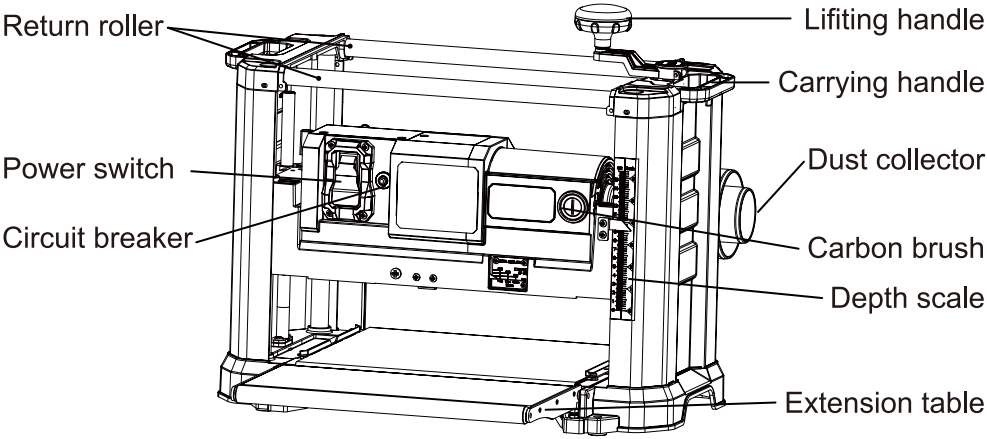

In order to prolong the service life of the product, the lifting handle is adjusted by half a circleof planing once, that is, a single planing is 0.75mm thickness.


Recommend wearing noise protection earplugs and goggles.


The thicknesser can only be used for planing flat wooden boards, and it is forbidden to plane other mater materials such as metal, plastic, branches and trunks, etc.


The thicknesser is not suitable for industrial use.

PART LIST



PARTS DESCRIPTION

Main Machine

Accessories

Lifting handle

Dust collector

Disassembly wrench
(Pre-install back of the machine)

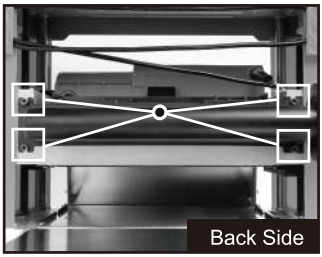
INSTALLATION INSTRUCTIONS

Lifting handle installation



Align the flat side of the handle with the lifting shaft and press it, fix it with screws, and finally turn it correctly to use.

Dust collection cover installation and disassembly

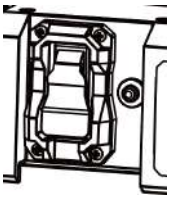



Take out the wrench and loosen the four fixing screws on the back, align the dust collection cover with the holes and tighten the fixing screws to complete the installation. [Pay attention to the direction of the dust port, to the left or right is all fine]

OPERATION

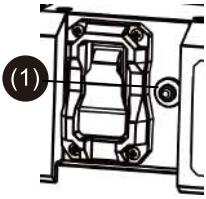
It is strongly recommended to fix your thicknesser on the support stand before use. It is highly deprecated that you did not place the machine on a stable level surface before use. Fixing the thicknesser on the support stand for work will prevent your machine from tipping over. You can fix the thicknesser on a work table and mark the four places to be punch holes. Move the thicknesser base to the corresponding hole position to punch four holes. And fix it with suitable screws, nuts and gaskets.(operation)

On/Off Switch



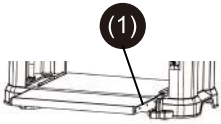
The ON/OFF switch is located on the front of the planer motor. To turn the planer ON, ensure the safety key is inserted, then flip the switch to the up position. To turn the planer OFF, flip the switch to the down position.

CIRCUIT BREAKER



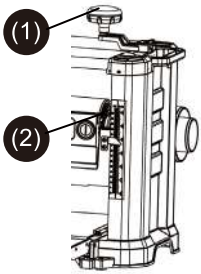
This planer is equipped with a circuit breaker(1) to protect the motor from excessive current. If the breaker trips, turn off the planer and wait a few minutes for the breaker to cool. Press the reset button to restart. If the breaker trips again, reduce the depth of the cut and try again.

Table Extensions



Before using the planer, unfold the table extensions located at the front and back of the machine. These extensions provide additional support for longer workpieces.

HEIGHT OF CUT



Rotate the depth adjustment handle(1) to adjust the height of the roller case. The depth scale (2) shows the height of the cutter head above the main table. The quality of the finished surface depends on the operator's experience and judgment about the depth of cut. Each full rotation of the depth-adjustment handle adjusts the planer's height by 1/16"(1.5mm). For example, 1/2 of a rotation is 1/32"(0.75mm), and 1 full rotation is 1/16''(1.5mm)

DEPTH OF CUT

1. The depth of cut depends on the width, species, hardness, moisture content, and grain direction of the wood.
2. Maximum cutting depths:
   - Up to 1/8'' (3mm) for workpieces less than 3'' wide.
   - Up to 1/12'' (2mm) for workpieces 3'' to 6'' wide.
   - Up to 1/24'' (1mm) for workpieces 6'' to 13'' wide.
3. For optimal results, take multiple shallow passes rather than one deep cut. This will extend the life of the motor and blades while producing a smoother surface.
4. For cupped or bowed boards, flatten them first using a jointer or take multiple shallow passes until one side is flat. Then flip the board to plane the opposite side.
5. As a rule of thumb, it is best to alternate sides of the board being planned until the desired thickness is reached. This will result in the board having a more uniform moisture content since half of the total depth of cut has been taken from each side. Any additional drying should not cause warping or cupping.
6. Scrap wood is your best friend. Cut a test piece to verify the finish produced, as well as the accuracy of the depth of cut and the thickness of the finished product

PREPARING WORK

1. Flat Surface: Thickness planers operate best when at least one side of the board is already flat. Use a jointer or surface planer to create a flat surface before planing. Severely warped or twisted boards may jam the machine and should be avoided.
2. Workpiece Size: For excessively warped boards, consider ripping them into smaller sections to minimize warpage before planning.
3. Grain Direction: Always feed the workpiece with the wood grain. If the grain changes direction in the middle of the board, cut the board into sections, so the grain direction is consistent during planning. Planing against the grain can result in tear-out or a rough surface.

CHECK FOR WORN CUTTING INSERTS

The condition of the cutting blades significantly impacts the quality of the finished surface. Watch for the following signs of dull blades:

1. Fuzzy Surfaces: Dull blades tear wood fibers instead of cutting cleanly.
2. Raised Grain: Uneven cutting occurs due to varying wood density.
3. Nicks: Raised edges on the workpiece indicate nicks in the blade.

To maintain optimal performance, replace worn or damaged blades promptly. Keeping a spare set of blades is recommended.

AVOIDING SNIPE

A snipe is a small dip or indentation at the ends of a board caused by uneven pressure as the board enters or exits the planer. This issue typically occurs when the workpiece is not properly supported or when only one feed roller is engaged with the board.

Methods to Reduce or Eliminate Snipe:

1. Leave Extra Length: Add 1–2 inches to the board's length, which can later be trimmed off to remove the snipe.
2. Support the Workpiece: Use additional supports or gently lift the board at both the in-feed and out-feed ends to ensure consistent pressure.
3. Dummy Board: Place a scrap board in front of and behind the workpiece. These scraps will absorb the snipe, leaving the main workpiece unaffected.
4. Adjust Extension Tables: Slightly incline the in-feed and out-feed tables (upwards by about 1 mm) to form a shallow "V" shape with the planer base. (see p. 11 for adjustments)

Grain Direction Tips

1. Always plane with the grain, not against it.
2. Avoid planing end grains or feeding boards perpendicular to the grain, as this can cause splintering or even damage to the planer.
3. When planing boards with inconsistent grain directions, consider cutting the board into smaller sections to align the grain.

FEEDING WORK

The planer is supplied with cutting inserts mounted in the cutter head, and the in feed and out feed rollers pre-adjusted to the correct heights. The feed rate (the rate at which the work piece travels through the planer) is automatic, but will vary slightly depending on the depth of cut and type of wood.

To feed the work piece:

1. Align the work perpendicular to the roller case so that the work feeds through the planer straight, making sure that the board is traveling in the same direction as the grain and that you are only planing either side or face grain. Boards longer than 33-1/2'' should have additional support from free-standing material stands. Position the work piece with the face to be planed on top.
2. Raise / lower roller case to produce the depth of cut desired.
3. Stand on the side of the planer. Do not stand directly in front or behind the planer.
4. Turn the planer ON and direct the board into the planer. Gently slide work pieces into the in feed side of the planer until the in feed roller advances the work piece. Let go of the work piece and allow the automatic feed to advance the board through the planer.
5. Do not push or pull on the work piece. Catch the planed lumber by grasping it in the same manner, as it was fed as it comes out the back side. Make sure not to stand directly behind the planer while catching fed lumber. Do not grasp any portion of board which has not gone past the out feed roller.
6. Repeat as needed. The planer has two return rollers on top, so an assistant can easily pass the work back to the operator. Keep in mind that multiple shallow cuts result in smoother surfaces than a single deeper cut.

MAINTENANCE

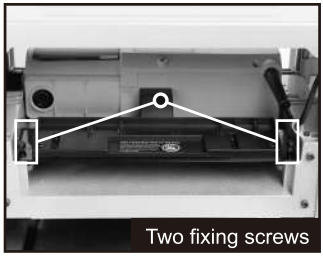
AWARNING: Disconnect the planer from the power source before performing any maintenance or adjustments.

1. ADJUSTING/REPLACING CUTTING BLADE

Note: the thicknesser adopts adjustment-free double-edged planing blade, which can be installed directlyIf one side of the planing blade is damaged, the other side can be replaced to continue usingIf the dust collection cover has been added, it should be removed first.

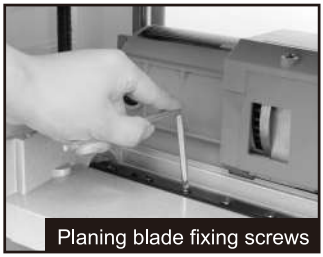

Disassembly wrench

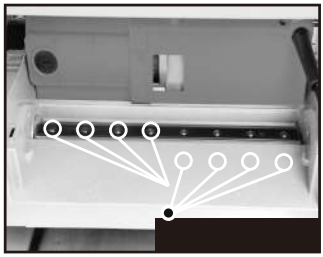

Dust port screw


Two fixing screws

1. Find the disassembly wrench placed on the back of the machine and disassemble the two set screws as shown above.


Dust cover

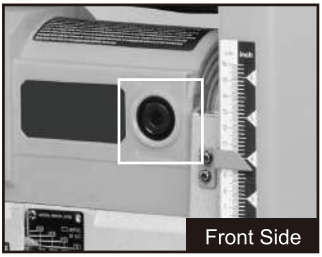

Planing blade fixing screws

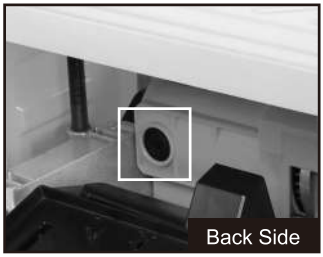


2. Take out the cover, you can see the fixing screws of planing blade (there are 16 screws in total for two planing blade), loosing screws to take out the planing blade pressure plate, so the planing blade can be replaced.

   [Note: after the installation of the planing blade, be sure to tighten fixing screws]

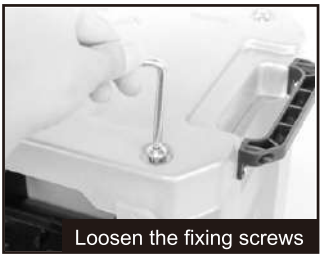
2. ADJUSTING/REPLACING CARBON BRUSH

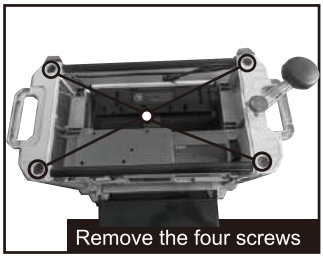




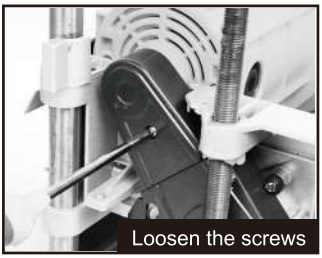
1. Loosen the carbon brush cover with a flat-head screwdriver to take out the carbon brush for replacement. [One carbon brush on each side of the motor, need to replace at the same time]

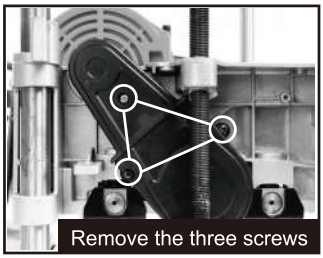
3. ADJUSTING/REPLACING BELT

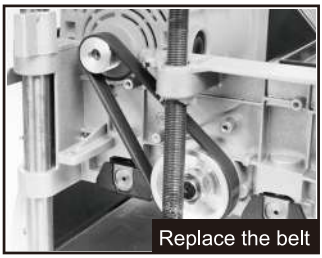




1. After raising the motor to the top, remove the lifting handle and loosen the four screws fixing the casing as shown in the picture above, and take out the casing.

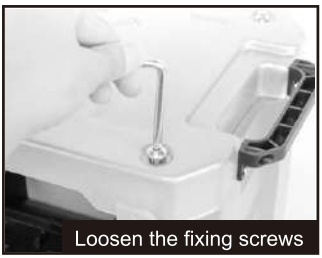


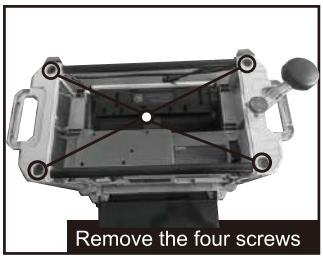




1. As shown in the picture above, remove the three fixing screws in turn and remove the belt cover to replace the belt. After the replacement is completed, tighten the screws in turn to install the belt cover and the casing.

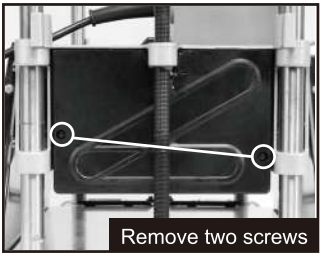
4. ADJUSTING/REPLACING CHAIN/CHAIN WHEEL

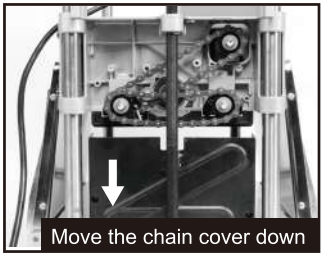

Loosen the fixing screws


Remove the four screws


Take out the casing

1. After raising the motor to the top, remove the lifting handle and loosen the four screws fixing the casing as shown in the picture above, and take out the casing.


Remove two screws


Move the chain cover down


Three chain screws in tota

2. Remove the two fixing screws as shown in the picture above, pull the chain cover to the bottom to expose the chain, and loosen the chain screws to replace the chain/chain wheel.

5. CLEANING THE PLANER

Keep the planer clean of any wood chips, dust, dirt, or debris. We strongly recommend always using a dust collection system. Make sure to clean out the planer after every use. After 10 hours of operation, the drive chains and sprockets should have wood chips, dust, and old grease removed. While wearing safety glasses, use a couple of puffs of compressed air (do not exceed 50 PSI) to blow dust and chips out of the gearbox and drive chains. Use common automotive bearing grease to lubricate all drive chains and sprockets. Spray the gearbox with a light coat of dry lubricant. Clean the table and infeed /outfeed rollers using a soft, damp cloth. Do not use any waxes, oils, or solvents on the table.

6. ADJUSTING THE INFEED/OUTFEED EXTENSION TABLES

1. Locate the table elevation adjustment bolt on each side of the table. Raise the table to expose the bolt.
2. Using a wrench and screwdriver, loosen the bolt. Keep track of the number of turns applied to each screw. Make sure that the bolt on the left and right sides of the table are turned the same number of times.
3. Test the table height. If adjustments need to be made, repeat step 2 as needed, ensuring that both bolts have been turned the same number of times.
5. Repeat steps 1 – 3 for the other table until you are satisfied with the height.
6. Test the adjustments on a scrap piece of wood, making further adjustments as necessary, until you are satisfied.

TROUBLE SHOOTING

1. IF THE MATERIAL DOES NOT FEED PROPERLY, CHECK FOR:

- Dull knives, rotate or replace as necessary. Refer to Changing the Planer blade in the maintenance section
- Excess clogging in the dust hood. Refer Dust collection cover installation paragraph.
- Excess oil/debris/pitch on feed rollers.
- Excessively twisted, cupped, or bowed material.
- A broken drive belt. Refer to replacing a New Belt paragraph in the maintenance section.

2. IF THE UNIT IS NOT RUNNING, CHECK TO SEE:

- If the unit is plugged in. Ensure the unit is plugged into the appropriate outlet.
- If the motor brushes are depleted, replace them as necessary. Refer to the Brushes paragraph under the maintenance section.

3. The circuit breaker keeps tripping.

- Dull cutting blade. Check the cutting blade. Rotate or replace as necessary.
- Excessive depth of cut. Reduce the depth of the cut.
- Internal motor problem. Contact customer service for assistance.

4. Drive rollers do not work, or excessively loud grinding noise.

- Broken gearbox, drive chain, or sprocket. Contact customer service for assistance.

5. Marks on the workpiece.

- Dull cutting inserts. Check cutting inserts. Rotate or replace as necessary.
- Excessive depth of cut. Reduce the depth of the cut.
- Workpiece being fed against grain. Reverse workpiece.
- Table or feed rollers are dirty. Clean table and/or feed rollers.
- Dust or debris between cutting inserts and cutter head. Clean cutting inserts and cutter head.

6. Snipe.

- Dull cutting inserts. Check cutting inserts. Rotate or replace as necessary.
- Improper support being used. Support workpieces properly (especially long workpieces).
- Table or feed rollers are dirty. Clean table and/or feed rollers.

WARRANTY INFORMATION

WOODSTARTER offers a one-year warranty along with lifetime technical support to ensure your satisfaction. For any inquiries or feedback, please contact our team at support@woodstarter.com or visit our support page at www.woodstarter.com for assistance.

WOODSTARTER

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