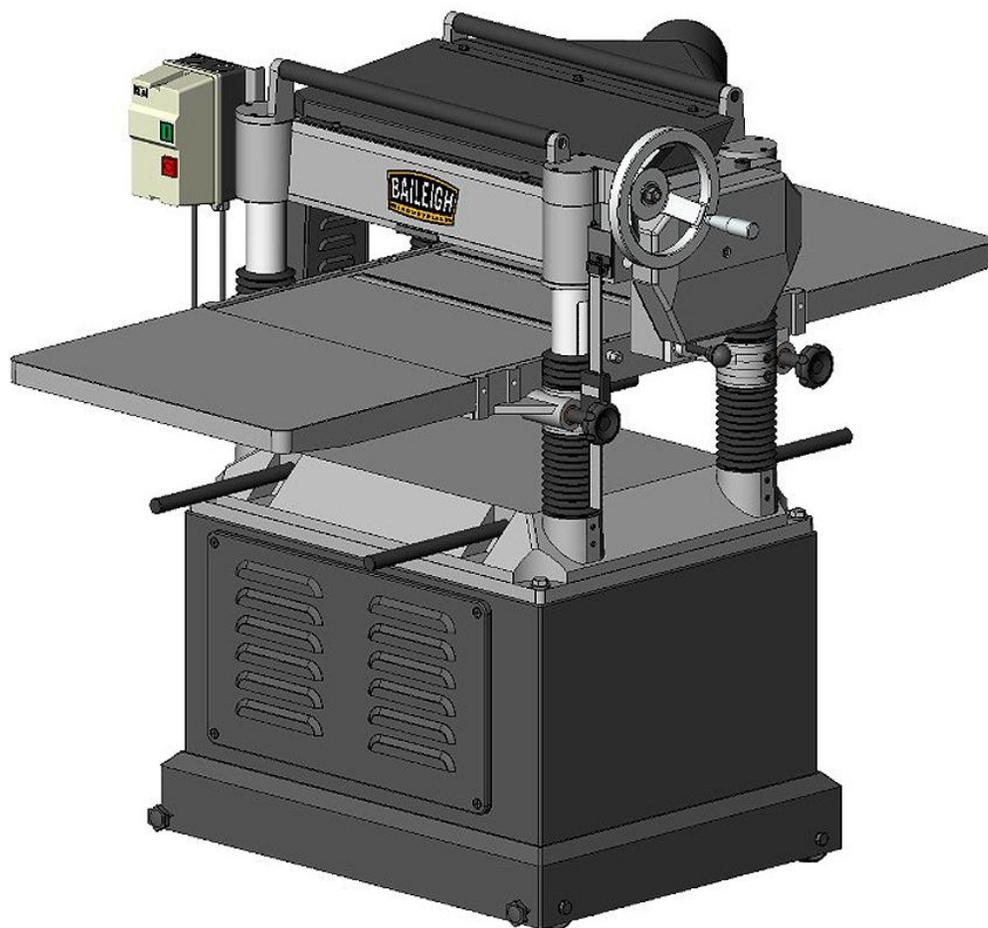




# OPERATOR'S MANUAL



## PLANER MODEL: IP-208

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## THANK YOU & WARRANTY

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

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

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

**Limited Warranty.** Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 30 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (e) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

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

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



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

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

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

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

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

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

**Summary of Return Policy.**

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

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

**For Customer Service & Technical Support:**

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



## **INTRODUCTION**

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

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

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

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

## **GENERAL NOTES**

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

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

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



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



## IMPORTANT

### PLEASE READ THIS OPERATORS MANUAL CAREFULLY

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



## SAFETY INSTRUCTIONS

### LEARN TO RECOGNIZE SAFETY INFORMATION

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

Follow recommended precautions and safe operating practices.

### UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death**.

Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.

General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.



**DANGER**



**WARNING**



**CAUTION**

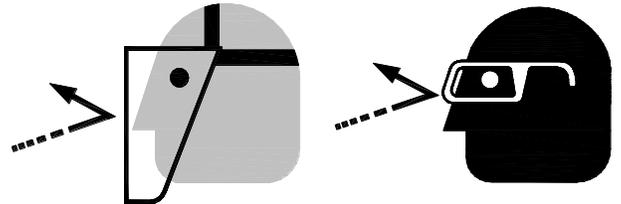


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



**PROTECT EYES**

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



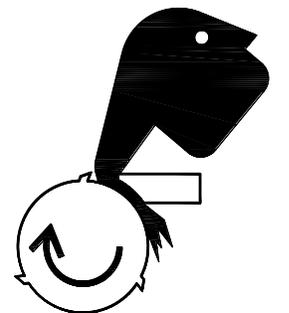
**BLADE HAZARD**

Keep hands and fingers away from the rotating knife blades. These rotating knives can be extremely dangerous if you do not follow proper safety procedures. **NEVER place hands closer than 3" (76mm) to the rotating cutting knives.**



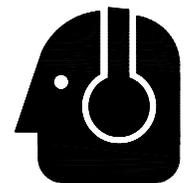
**ENTANGLEMENT HAZARD – ROTATING BLADES**

Contain long hair, **DO NOT** wear jewelry or loose fitting clothing.



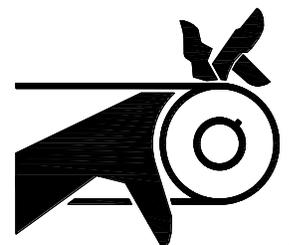
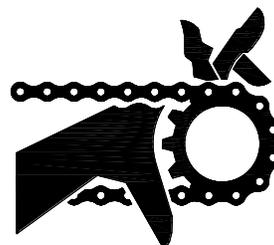
**PROTECT AGAINST NOISE**

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



**BEWARE OF PINCH POINTS**

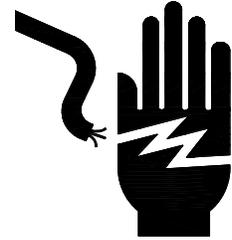
Keep hands and fingers clear of all potential pinch points. These include sprockets and chains along with belts and pulleys.





## HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.  
(FOLLOW PROPER LOCKOUT PROCEDURES)



## SAFETY PRECAUTIONS



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

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

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



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

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel should operate this machine.**
3. **Kickback.** Become familiar with the term "**Kickback**" and how it occurs before operating this planer. Kickback happens when the piece part is thrown towards the operator at a high rate of speed with the potential for serious injury.
4. **Kickback Zone.** The path directly behind the end of the in-feed table is referred to as the "Kickback zone". **NEVER** stand or allow others to stand in this area while the machine is running. Position yourself to one side of the machine while the planer is running.
5. **Reaching Inside Planer.** To avoid serious personal injury from rotating knives, NEVER remove guards or reach inside the planer while it is connected to power. Always Follow proper lockout /tagout procedures.



## SAFETY PRECAUTIONS (cont.)



6. **Clearing Jams.** To avoid serious personal injury from rotating knives, ALWAYS STOP the planer and disconnect power before removing a jammed piece part. Always follow proper lockout/tagout procedures.
7. **Using Quality Stock.** Inspect the stock over carefully that you intend to plane. **NEVER** plane a board that has loose knots, staples, or nails in it. **DO NOT** plane a piece of stock if you have any doubts about its structural integrity.
8. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
9. **Dull / Damaged Knives.** Use only sharp, undamaged knives to avoid unnecessary kickback of the piece part. Dull and damaged knives will also affect cut quality.
10. **Looking Inside Planer.** Wood chips fly around inside the planer at a high rate of speed as it is running. To avoid possible injury from flying debris, **DO NOT** look inside the planer while it is running.
11. **Keep work area clean.** Cluttered areas invite injuries.
12. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
13. **Dress appropriate.** **DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
14. **Use eye and ear protection.** Always wear ISO approved impact safety goggles
15. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
16. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
17. **Grain Direction.** There is an increased chance of kickback when planing end grain or against the grain. This could also produce chatter and excessive chip out of the material.
18. **Observe work area conditions.** **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
19. **DO NOT** bypass or defeat any safety interlock systems.
20. Know the location of the **ON - OFF** switch and the **"E" - STOP** button.
21. Keep visitors a safe distance from the work area.



## SAFETY PRECAUTIONS (cont.)



22. **In-feed Roller Clearance.** The in-feed roller is designed to pull material into the rotating cutterhead. To avoid serious personal injury, keep hands, jewelry, clothing, and long hair away from the in-feed roller while operating the machine.
23. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
24. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
25. **DO NOT** touch live electrical components or parts.
26. **Be Sure** all equipment is properly installed and grounded according to national, state, and local codes. If machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
27. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
28. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.
29. **Reduce the risk of unintentional starting.** Make sure switch is in “**OFF**” position before plugging in power cord.
30. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
31. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
32. **Using Correct Materials.** Planing materials other than natural wood fiber can result in serious personal injury and machine damage. **NEVER** use this machine for anything except planing in wood.
33. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

## **EMERGENCY STOP BUTTON**

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button.



## **SPECIFICATIONS**

Cutting Capacity (W x H)	20" x 8" (508 x 203mm)
Maximum Depth of Cut	1/8" (3.1mm)
Minimum Material Thickness	1/4" (6.3mm)
Cutterhead Speed	5000 RPM
Number Of Knives	4
Cutter Head Size	3.25" (82.5mm)
Motor	5Hp (3.72kw), 1Ph, 60Hz, 220V
Shipping Weight (Approx.)	830 lbs. (376kg)

## **TECHNICAL SUPPORT**

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

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



**Note:** *The manual cover photo illustrates the current production model. All other illustrations are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



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



## **UNPACKING AND CLEANING**

Remove planer and stand from the shipping cartons. Check for damage and ensure all parts are intact. Any damage should be reported immediately to your distributor and shipping agent. Before assembling, read the manual thoroughly, familiarizing yourself with correct assembly and maintenance procedures and proper safety precautions.

### **Cleaning**

Your machine may be shipped with a rustproof waxy oil coating and grease on the exposed unpainted metal surfaces. To remove this protective coating, use a degreaser or solvent cleaner. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces. Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.

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

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



Although some users prefer a wax coating for the table surfaces, white talcum powder rubbed in vigorously once a week with a blackboard eraser will fill any casting pores and form a moisture barrier. Talcum powder will not stain wood or mar finishes.



## INSTALLATION and ASSEMBLY

**⚠ WARNING:** FOR YOUR OWN SAFETY, DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL THE MACHINE IS COMPLETELY ASSEMBLED AND YOU READ AND UNDERSTAND THE ENTIRE INSTRUCTION MANUAL.

### **IMPORTANT:**

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

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they are safely supported and will not extend into any aisles.

**⚠ WARNING:** Before operating; make sure it is positioned firmly on a solid level floor. If it tips over on you, it could cause severe injury or death.

The machine should be sited on a level, concrete floor. The accuracy of any machine depends on the precise placement of it to the mounting surface. Locate the planer in an area that is level and provides a solid foundation. Make sure that any potential kickback is not in line with aisles, doorways, wash stations or other work areas.

Place shims under the four feet mounted in the base as required for leveling.

There are four lifting handles (A) hidden in the bed of the planer table. Pull the handles out for use and push them down otherwise.

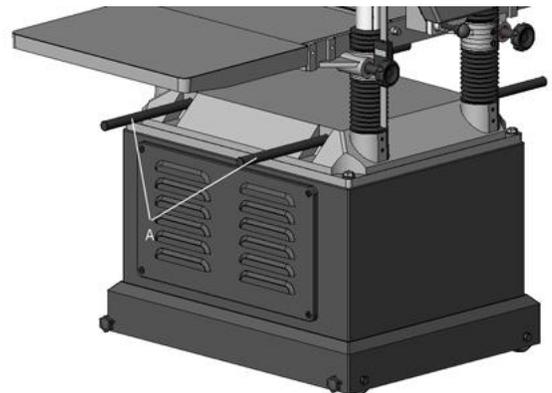


Fig. 1



## ASSEMBLY EXTENSION TABLE

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

1. Use an assistant to help lift and align the holes on the extension table to the main table.
2. Insert the bolts and loosely secure with washers and nuts. (Fig. 2).
3. With the fasteners in position and snug, place straight edge through machine so that it lies across the main table and extension table. (Fig. 3).
4. Align the extension table to the main table. When the tables are aligned, hold in position and securely tighten the fasteners.

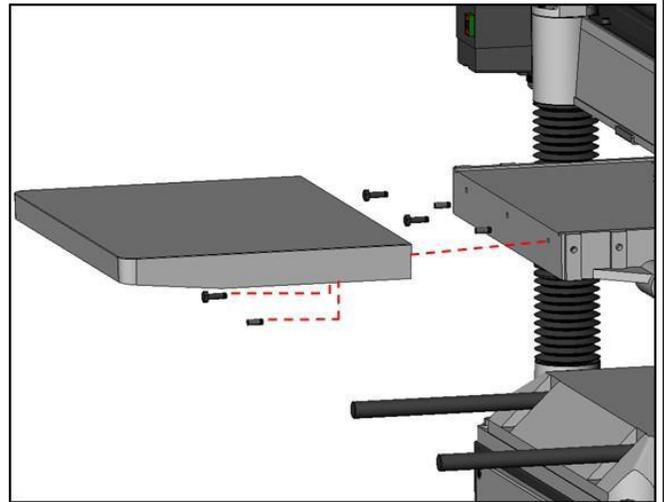


Fig. 2

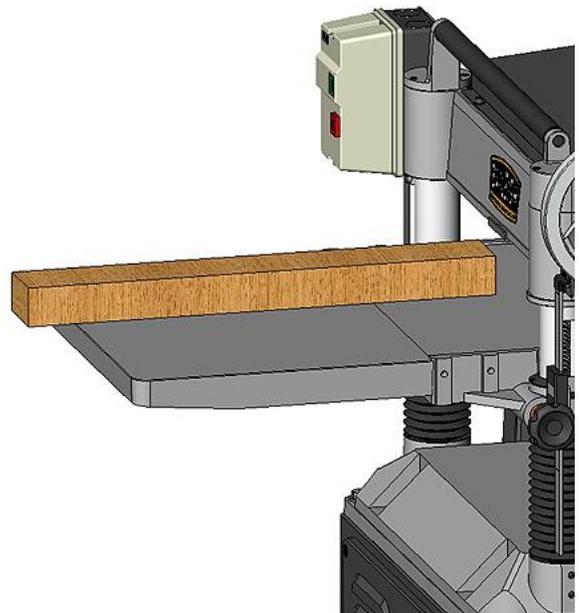


Fig. 3



## DUST CHUTE ASSEMBLY

1. Mount the dust chute to the planer hood with hex head screws & flat washer.
2. Make sure the dust collection system has sufficient capacity and suction for your planer.
3. Always turn on the dust collection system before starting the planer. (Fig. 4).

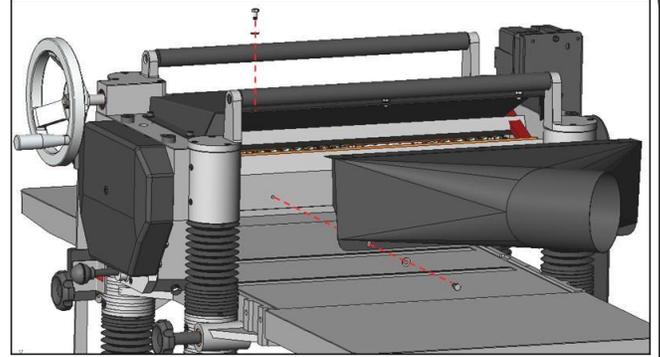


Fig. 4

## ELECTRICAL



**CAUTION:** HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.



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

### Motor Specifications

Your tool is wired for 220 volt, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

### Connections

- A separate electrical circuit should be used for your tools. If an extension cord is used, use only 3-wire extension cords, which have grounding type plugs and receptacles, which accept the tool's plug. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.



- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.
- Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

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

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Use only 3-wire extension cords that have grounding type plugs and receptacles that accept the tool's plug.
- Repair or replace damaged or worn cord immediately.

**Extension Cord Safety**

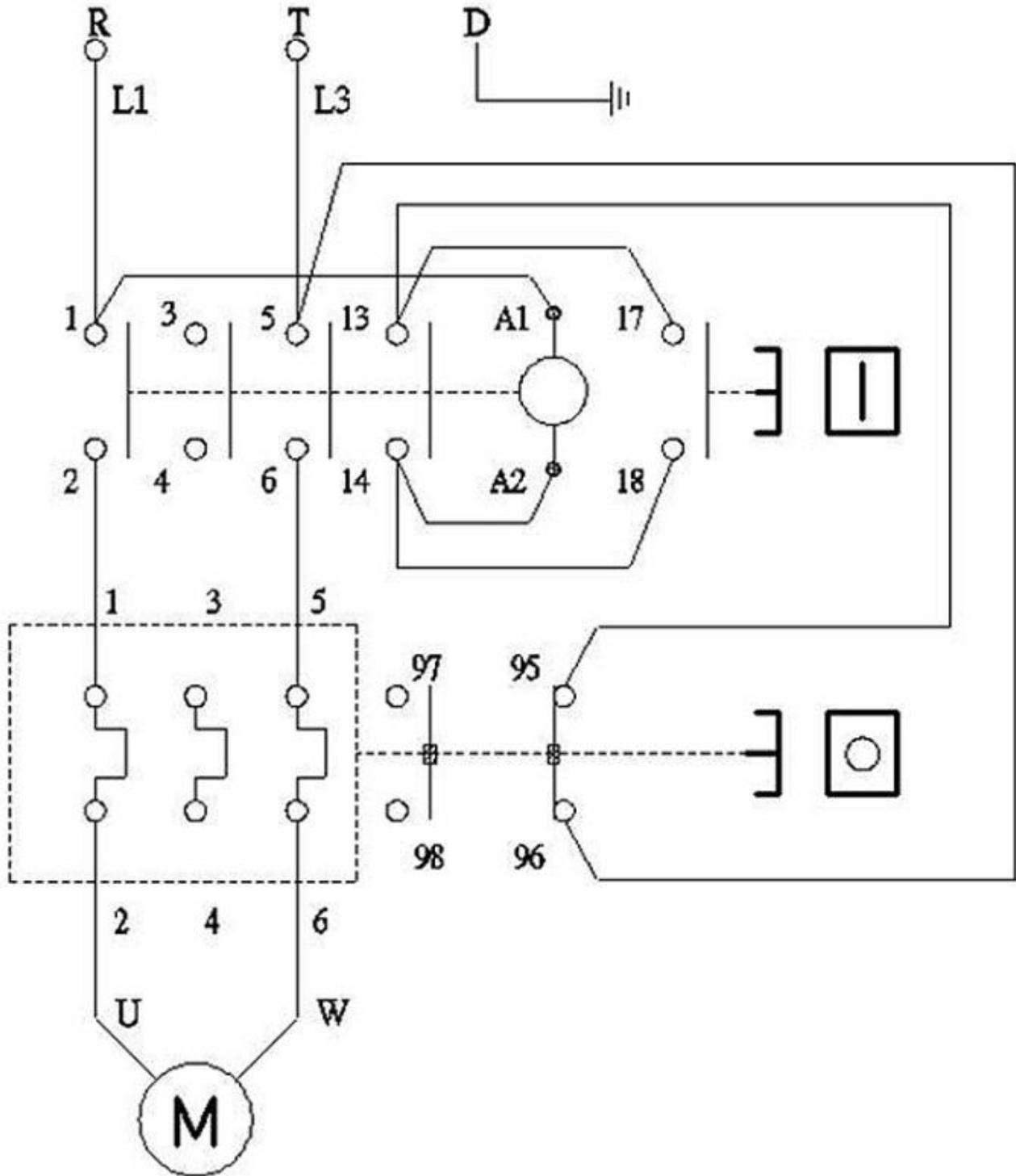
Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
WIRE GAUGE			

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



**ELECTRICAL DIAGRAM**





## CONTROL THE DEPTH OF CUTTING

**⚠ CAUTION:** Always wear proper eye protection with side shields, face shield, safety footwear, and leather gloves to protect from, chips, dust, burrs, and slivers.

The cutting depth scale is a combination of inch / metric scale, the cutting range is from 0 to 8" (204 mm). The distance between upward or downward of driving handle is 0.059" (1.5mm) one complete turn.

Before adjusting the table upward, or downward; loosen nut (A), after positioning to required position, tighten nut (A) again to hold in position. (Fig. 5)

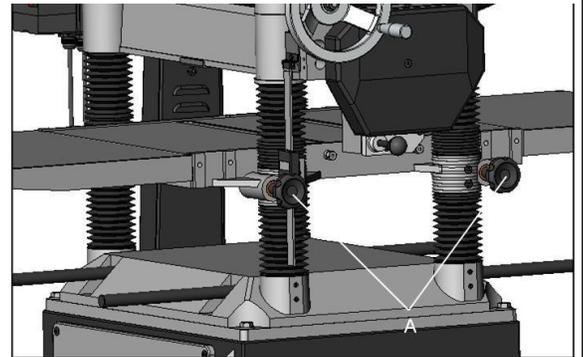


Fig. 5

## CHECKING PULLEY

To verify that motor pulley (B) is in line with the shaft pulley of (A), using the edge of a straight scale check to see if they are on-line with each other.(Fig. 6).

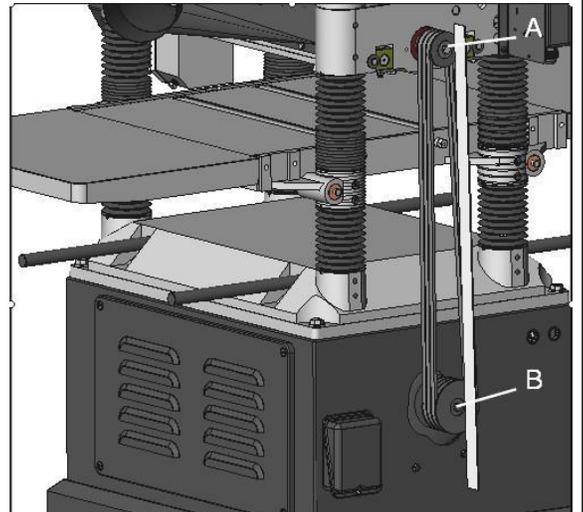


Fig. 6

## Adjusting Motor Mount

If motor pulley B and shaft pulley A, are not on-line loosen screw as shown in (Fig. 7), move shaft to left and right until adjusted to proper position and tighten the screw again.

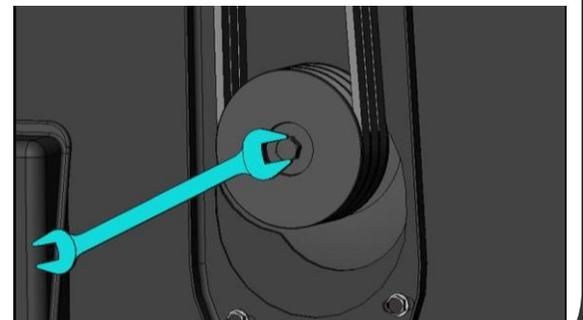


Fig. 7



## **ADJUSTING BELT TENSION**

Use the two bolts to adjust the belt tension (Fig. 8).  
When achieved proper position of adjustment tighten bolts to hold in place.

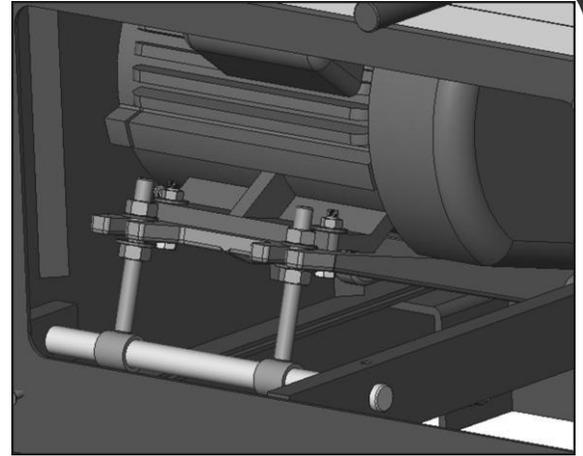


Fig. 8

## **FEED ROLL SPEED RATE**

The rate of speed is transmitted by shift gears located in gear box.  
The shift gear handle (Fig. 9) performs with three different methods of speed by using the shift handle to pull or push.

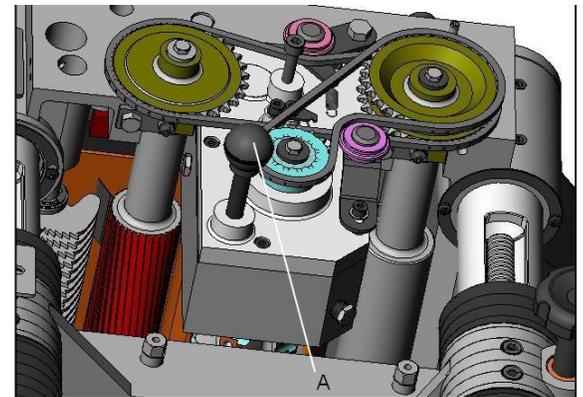


Fig. 9

Position A: feed roll is functioning on 20-FPM speed rate.  
Position B: feed roll is functioning on 0-speed rate.  
Position C: feed roll is functioning on 16-FPM speed rate.

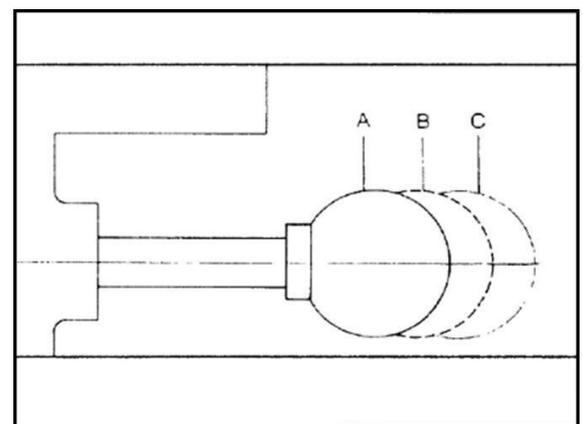


Fig. 10



## **ROLL TRANSMITTING**

The purpose of the roll located on top of machine, is transmitting stock after cutting and shaving workpieces. This roll will save you lots of time, and will speed up you're working rate. (Fig. 11)

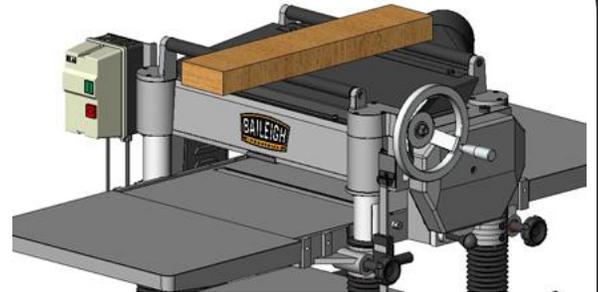


Fig. 11

## **CONNECTING DUST COLLECTOR**

Connect dust collector system to hood of machine, located at the back of machine. The dust collector will collect all dust and particles while molding in process, this system will give a clean and safe working environment. (Fig. 12)

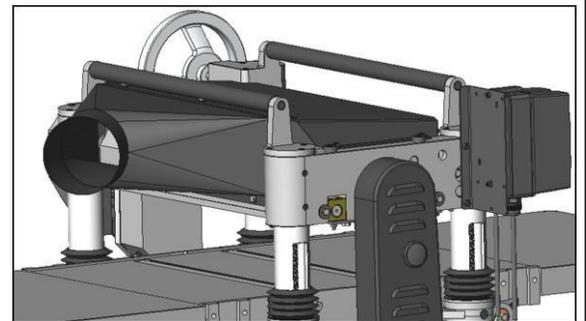


Fig. 12

## **FEEDROLL PRESSURE AJDUSTMENT**

The pressure of the feed roll will depend on the pressure set by the springs, and screws. To adjust the pressure, you must loosen or tighten the lever. There are two sets of springs on both ends of the feed roll, to ensure great results make sure both sides are at the same level pressure. (Fig. 13)

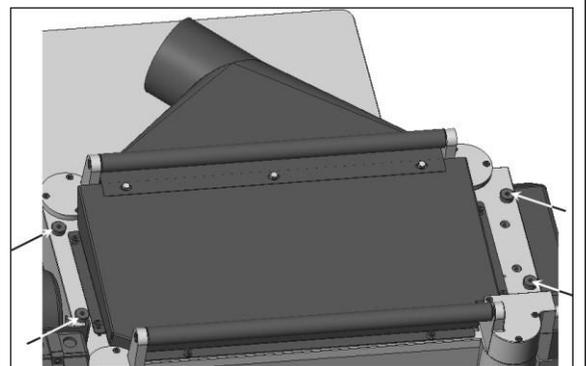


Fig. 13



## **ADJUSTMENT TRANSMITTING ROLLER**

Verify that roller and table are both at the same height.  
(Fig. 14)

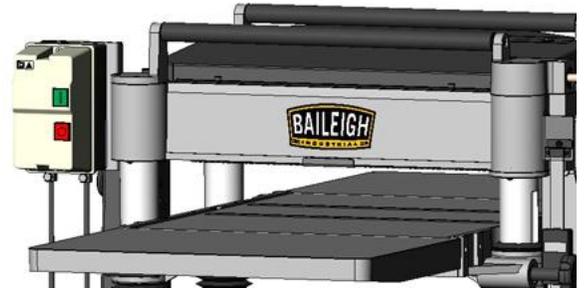


Fig. 14

## **ADJUSTING TABLE ROLLER**

To reduce friction between stock and table, two table roller have been assembled on machine. Adjustments will be needed when planning with the different types of wood.

- Roller must be adjusted high, when planning rough wood.
- Roll must be adjusted low, when planning smooth wood.

## **ADJUST ROLLER**

- UNPLUG OR DISCONNECT PLANER FROM POWER SOURCE AND LOCK OUT POWER.
- Place a straight level on table roll, loosen screw (A) adjust your shaft (B) to the proper height and tighten back the screw to hold in position. (Fig. 15)

Always check to make sure that the front and back height are the same. There must be no slant between roller and table.

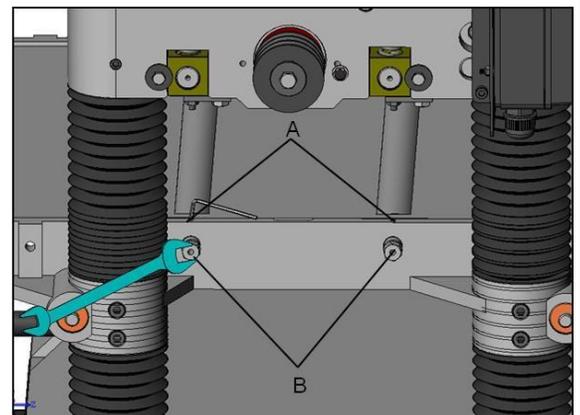


Fig. 15



## CONSTRUCTING GAUGE BLOCK

- UNPLUG OR DISCONNECT PLANER FROM POWER SOURCE AND LOCK OUT POWER.

The manufacturer has adjusted all machines before delivery.

Verify that the screws are properly tightened.

The only time you will have to adjust your machine is when it has been functioning for a long time.

The adjustment will have to be made to adjust the precision of the machine.

Always check the adjustments before starting on a new project, this will save you time and money.

To check you will need the following supplies.

- Straight scale
- Thickness gauge
- Home made gauge block of hard wood, with the dimensions as shown in Fig. 16.

### Hardwood Gauge Block

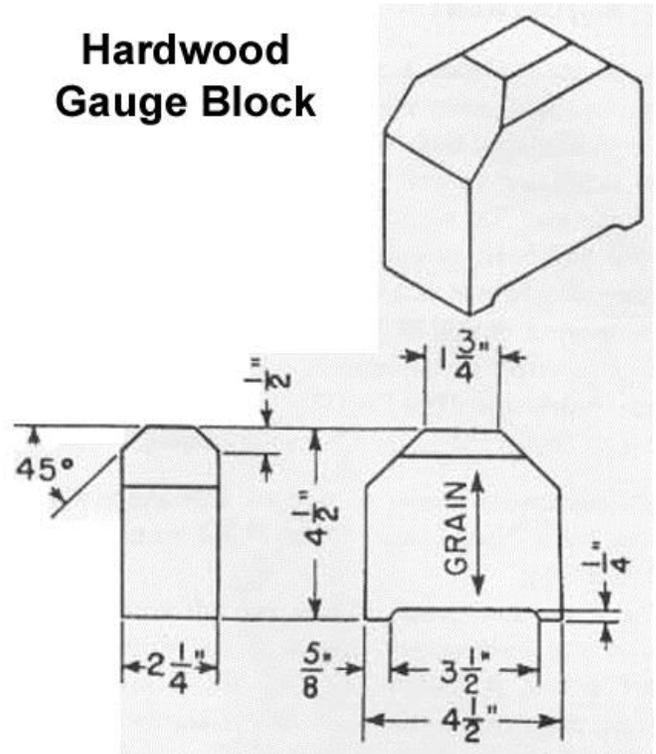


Fig. 16

## ASSEMBLING CHAIN

If head casting is not parallel to table, tilt planer on it's side. Remove bolt C and loosen bolt (D) (Fig. 17). This will enable you to move the idler sprocket assembly (E) this procedure will release the tension of the chain.

Remove chain from sprocket on the end that must be adjusted. When chain has to be released, do not turn the sprocket more than one or two teeth. Turn sprocket clockwise to decrease the distance, and counter clockwise to increase the distance between the caster.

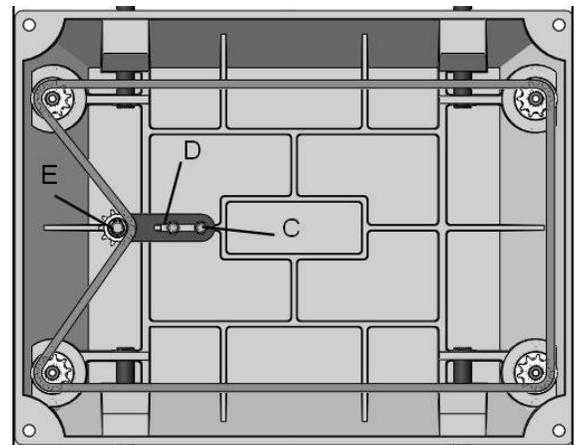


Fig. 17



## ADJUSTING CUTTING HEAD PARALLEL TO TABLE

### Cutting Head and Roller Components

- 1 Infeed Roller
- 2 Chipbreaker
- 3 Cutter Head
- 4 Casting
- 5 Outfeed Roller

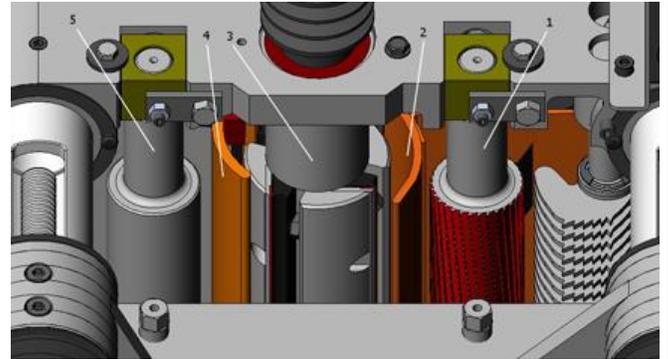


Fig. 18

All parallel adjustments have been made to table before shipment, no further adjustments are required. The only verification you should make is to check indirectly the parallel of the cutter head and table. Proceed with the following:

1. UNPLUG OR DISCONNECT PLANER FROM POWER SOURCE AND LOCK OUT POWER.
2. Place gauge block between upper head casting and table, make them contact slightly. (Fig. 19).
3. Move gauge block to the opposite side, making them to the same height.
4. Follow the same procedures to check the backside.

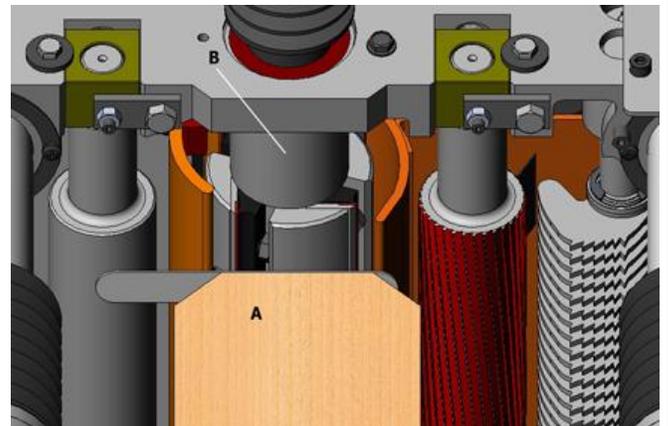


Fig. 19



## ADJUSTING SPRING TENSION OF FEED ROLLER

The infeed roller (A) and the outfeed roller (B) are two of the major parts of automatic transmitting of planer. (Fig. 20).

To control pressure, spring tensions are used.

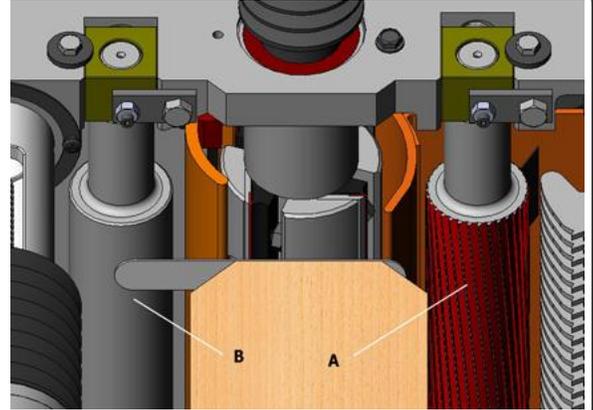


Fig. 20

### Adjusting Infeed and Outfeed Roller

Before starting with the adjustment, you must check the position of the cutting head. You will need;

- Thickness gauge 0.5m/m
- Home made gauge block

Figure 21 shows the relative dimensions of the Cutter Head and Roller assembly. (Fig. 21).

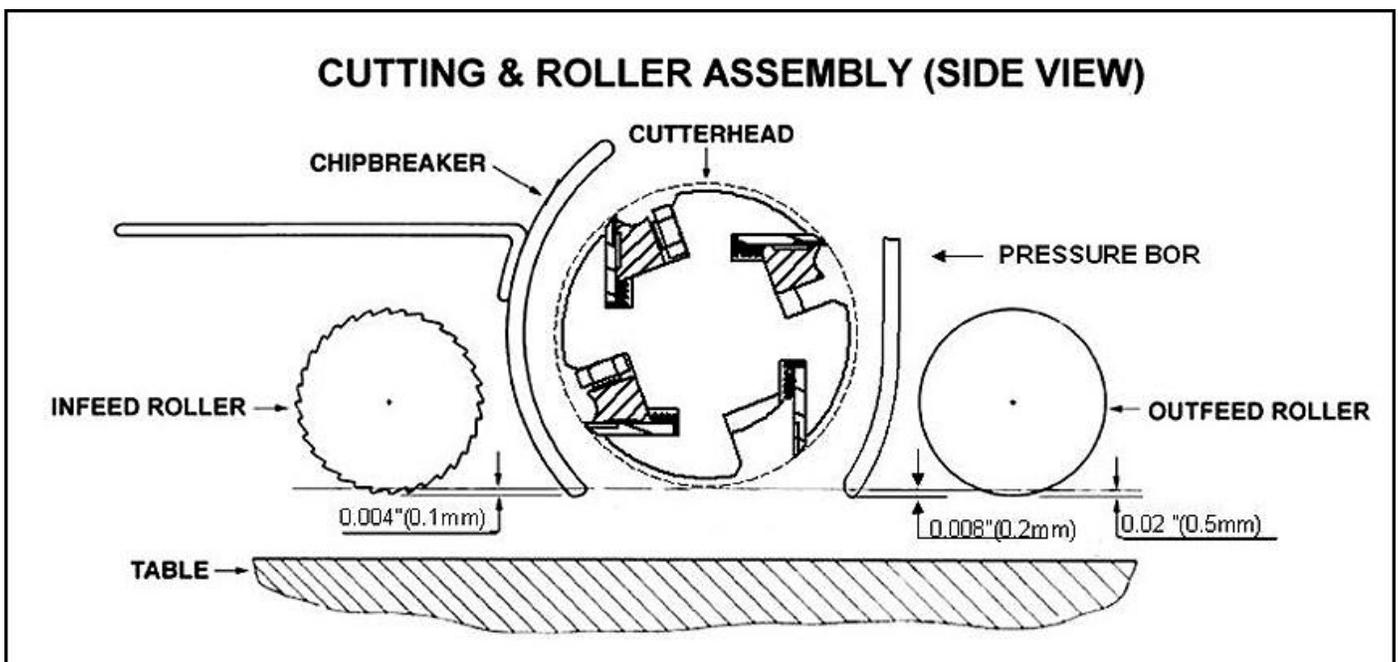


Fig. 21



**⚠ WARNING:** Knife inserts are dangerously sharp. Use extreme caution when working with or around the knife inserts.

1. UNPLUG OR DISCONNECT PLANER FROM POWER SOURCE AND LOCK OUT POWER.
2. Place gauge block under the cutterhead.
3. Raise the table and rotate the cutter head until the blade just contacts the gauge block.

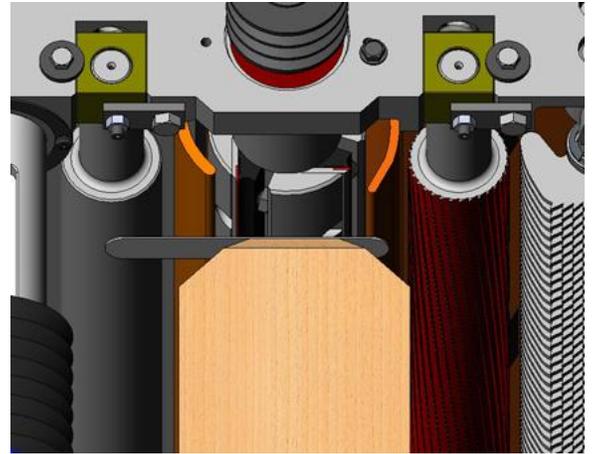


Fig. 22

### Infeed Roller

1. Place gauge block under the infeed roller. (Fig. 23).
2. Loosen nut (2) and turn screw (1). This will make the infeed roller move upwards, or downwards.
3. Make infeed roller touch the top of gauge block.
4. Once adjusted, turn the nut tightly (2), and replace screw (1).
5. The same procedures apply for the other end.

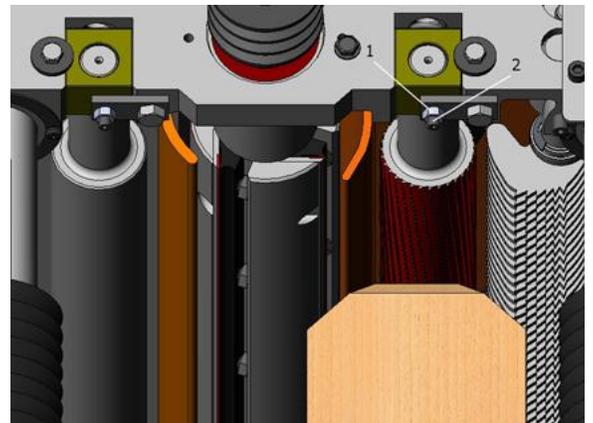


Fig. 23

### Outfeed Roller

1. Place gauge block under outfeed roller. (Fig. 24)
2. Loosen nut (3) and screw (4). This will allow for the outfeed roller to move upwards, or downwards.
3. Make the roller touch the top of gauge block.
4. When adjustments have been finished, tighten nut (3), and replace screw (4).
5. The same procedures apply for the other end.



Fig. 24



## CHECK HEIGHT OF PRESSURE BAR

When adjusting pressure bar, the correct position of wooden gauge and 0.2mm thickness gauge must be as shown in (Fig. 21).

1. UNPLUG OR DISCONNECT PLANER FROM POWER SOURCE AND LOCK OUT POWER.
2. Loosen screw (1) and nut (2). Turn the screw to the right so that the pressure bar moves upward. (Fig. 25).
3. Place gauge block and 0.2mm thickness gauge under the cutterhead as shown in (Fig. 26).
4. Place gauge block under pressure bar.
5. Make pressure bar touch the top of the gauge block.
6. Turn the screw (1) tightly, and replace the nut (2).

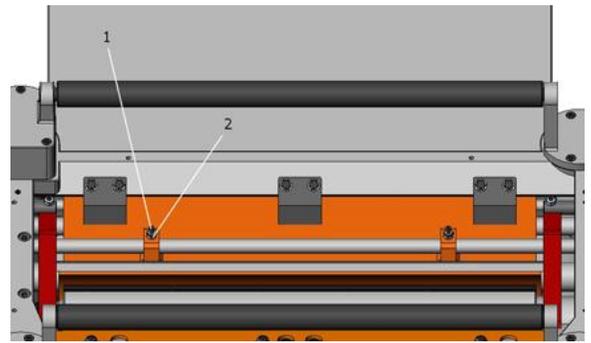


Fig. 25

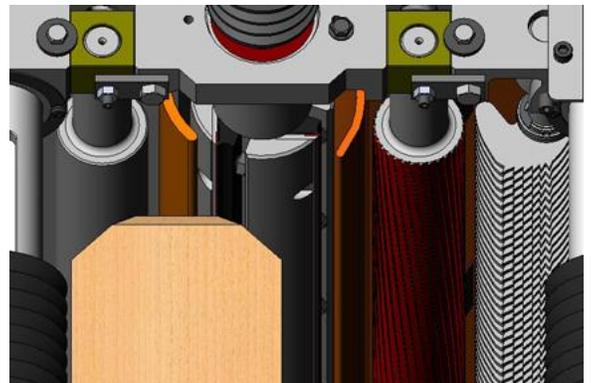


Fig. 26

## CHECK HEIGHT OF CHIPBREAKER

When adjusting the chipbreaker, the correct position of wooden gauge and 0.1mm thickness gauge must be, as shown in (Fig. 26). Adjust process of screw and nut as shown in (Fig. 27).

1. Place wooden gauge and thickness gauge as shown in (Fig. 26)
2. Loosen screw (1) and nut (2). Turn screw to the right to make chipbreaker move upward.
3. Place gauge block under the chipbreaker.
4. Make chipbreaker move downwards slowly until it touches the top of the gauge block.
5. Once adjusted, turn screw (1) tightly, and replace the nut (2).

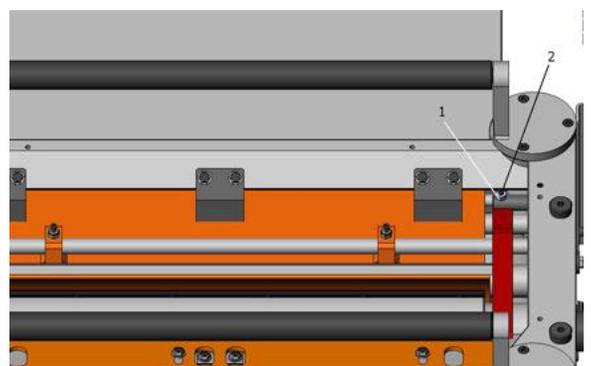


Fig. 27



## DIGITAL READOUT

The digital scale equipped with 20" planer can serve many applications, however for wood planning we need only concern ourselves with the ON/OFF, SET, and mm/in buttons. When set properly the digital readout will display the thickness of the finished product.

### Calibration:

In order to calibrate the unit first run a board through the planer and measure the finished thickness with a set of vernier calipers. This is the number to be entered into the display unit. At this point turn the unit on by pushing the ON/OFF button. Now press the mm/in button to set the unit to American standard or the metric system.

1. Press and hold the SET button until the '+' sign starts to flash and immediately release it.
2. Cycle the set button by pressing it until the '+' sign remains on.
3. Press and hold the SET button until the second zero to the right of the '+' plus sign starts to flash and immediately release it.
4. Cycle the SET button by pressing it until the number reads the correct whole number taken with the vernier calipers and immediately release the button.
5. Press and hold the SET button until the zero to the right of the decimal point starts to flash.
6. Repeat steps 4 and 5 until the last digit in the 0.001 place is entered.
7. Press and hold the SET button until the SET on the display starts to flash and immediately release it.
8. Press and release the SET button one final time to complete the calibration.

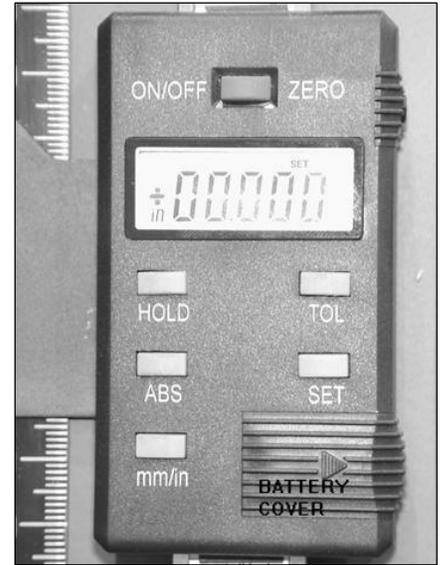


Fig. 28



**Note:** Do not turn the device off. If you do you will have to re-calibrate the unit.

### Battery:

When the display begins to flash the battery should be replaced. The battery is to be replaced with a SR144 (or equivalent) and can be found at most pharmacies or grocery stores. When replacing the battery the positive side of the button cell must face out.



## CONVERSION CHART

Fraction	Decimal	Metric
1/32	0.031	0.794
1/16	0.063	1.588
3/32	0.094	2.381
1/8	0.125	3.175
5/32	0.156	3.969
3/16	0.188	4.763
7/32	0.219	5.556
1/4	0.250	6.350
9/32	0.281	7.144
5/16	0.313	7.938
11/32	0.344	8.731
3/8	0.375	9.525
13/32	0.406	10.319
7/16	0.438	11.113
15/32	0.469	11.906
1/2	0.500	12.700
17/32	0.531	13.494
9/16	0.563	14.288
19/32	0.594	15.081
5/8	0.625	15.875
21/32	0.656	16.669
11/16	0.688	17.463
23/32	0.719	18.256
3/4	0.750	19.050
25/32	0.781	19.844
13/16	0.813	20.638
27/32	0.844	21.431
7/8	0.875	22.225
29/32	0.906	23.019
15/16	0.938	23.813
31/32	0.969	24.606
1	1.00	25.400



## MAINTENANCE



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

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

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

Maintenance on your planer should be done at periodic intervals to ensure that the machine is in good working order. Inspection and maintenance should be performed at least twice a year but more often if the lathe receives constant use.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.



**Note:** *Proper maintenance can increase the life expectancy of your machine.*

- Check all fasteners to make sure they are tight and check all adjustments that they are in order.
- Clean and oil the tables so that the material will slide easily. Clean any rust spots that may develop on the bed with a commercial rust remover.
- Use compressed air to blow out the interior of the machine in order to keep chips and sawdust from accumulating on the belts and pulleys.
- Check the drive belt for tightness. It should be snug but not overly tight.
- Use a mill file to remove any nicks or dings from the infeed or outfeed tables.



## Parts Lubrication Required

No.	Position	Grease	Oil
1	Worm Gear	Yes	No
2	Gear Box	No	Yes
3	Chain	Yes	No
4	Chain	Yes	No
5	Chain	Yes	No
6	Bracket	No	Yes
7	Lead Screw	Yes	No
8	Column Clean & Oil	No	Yes

- Worm Gear is used to adjust the table up or down. (Fig. 29)
- The oil in Gear Box must be changed after 2500 hours of work. (Fig. 30)
- All chains must be lubricated regularly. (Fig. 31)
- After 30 hours or more of work the lubrication of bracket must be changed. (Fig. 32)
- The machine comes equipped with four head screws, it is important to always keep them lubricated. (Fig. 33)
- To ensure maximum performance always keep the sliding rolls of table lubricated (Fig. 34).

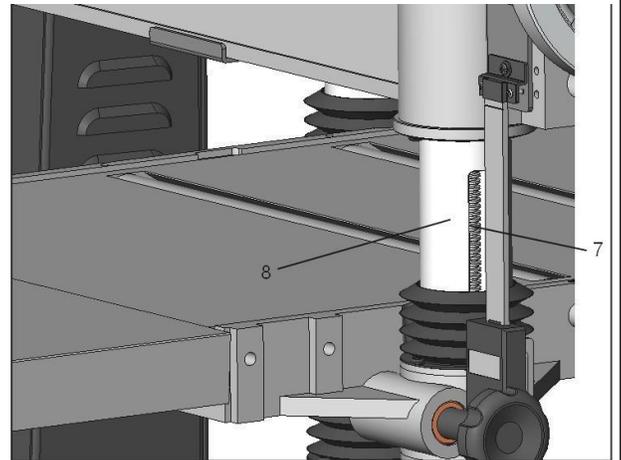


Fig. 29

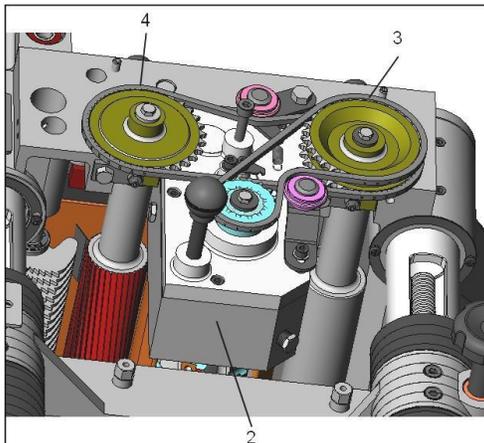


Fig. 30

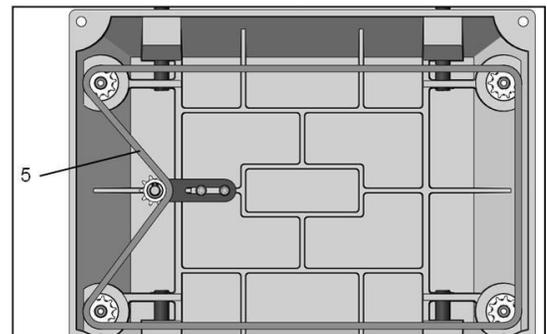


Fig. 31



## Change Lubricant

When lubrication needs to be changed:

1. Loosen the nut A on the outfeed hole.
2. Clean out old lubrication and let it dry.
3. Tighten nut A
4. Replace clean lubricant by hole B

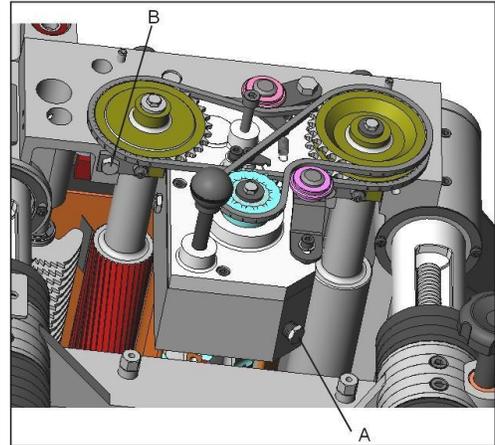


Fig. 32

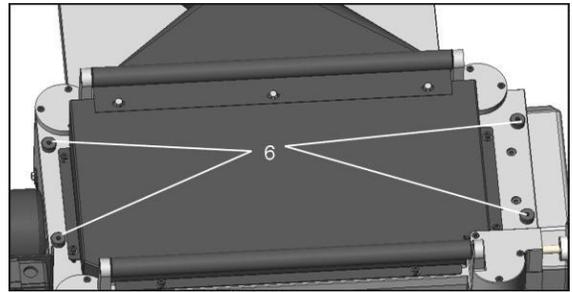


Fig. 33

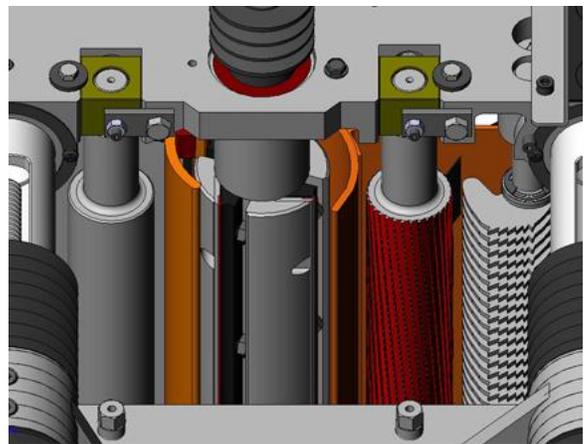
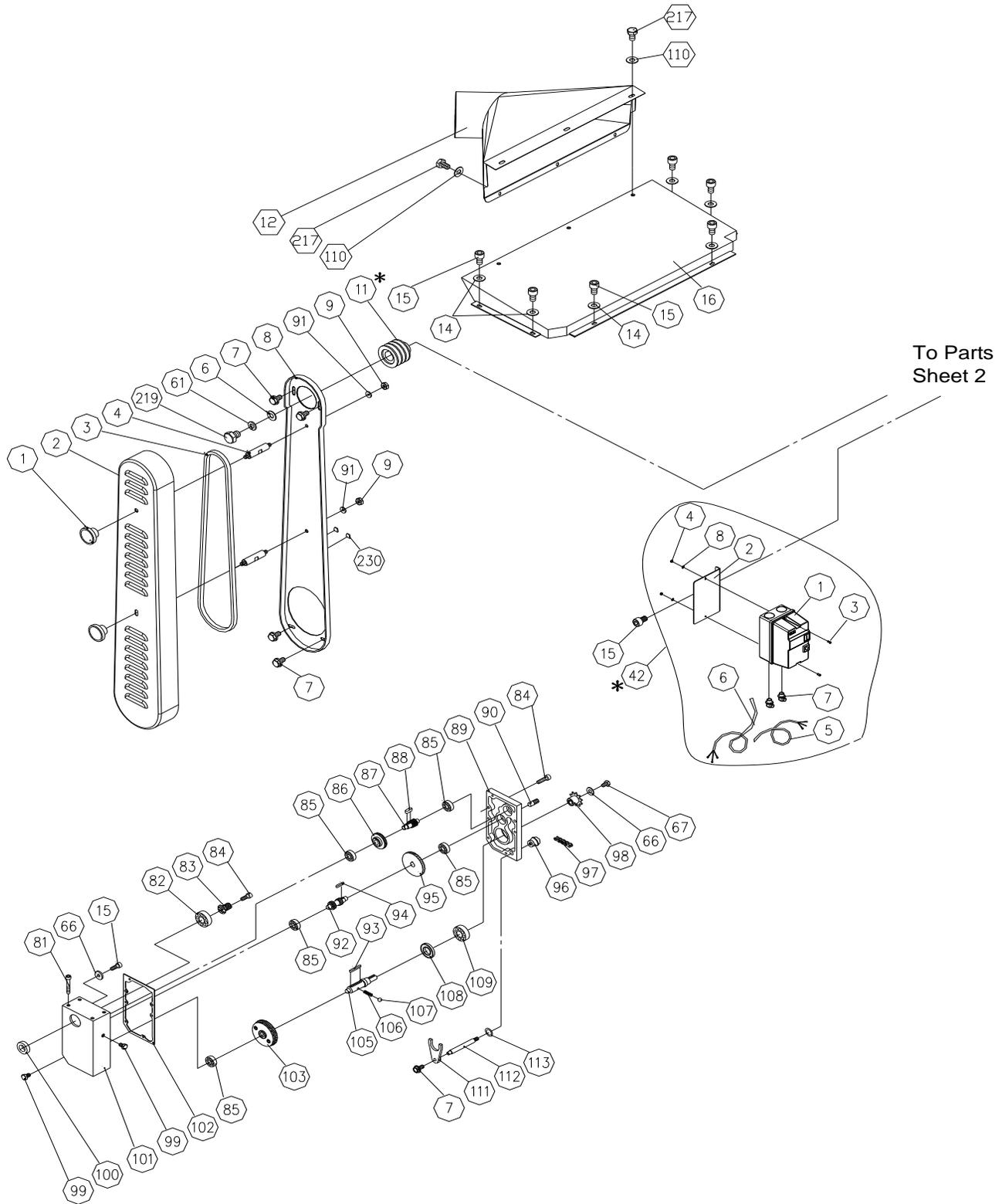


Fig. 34



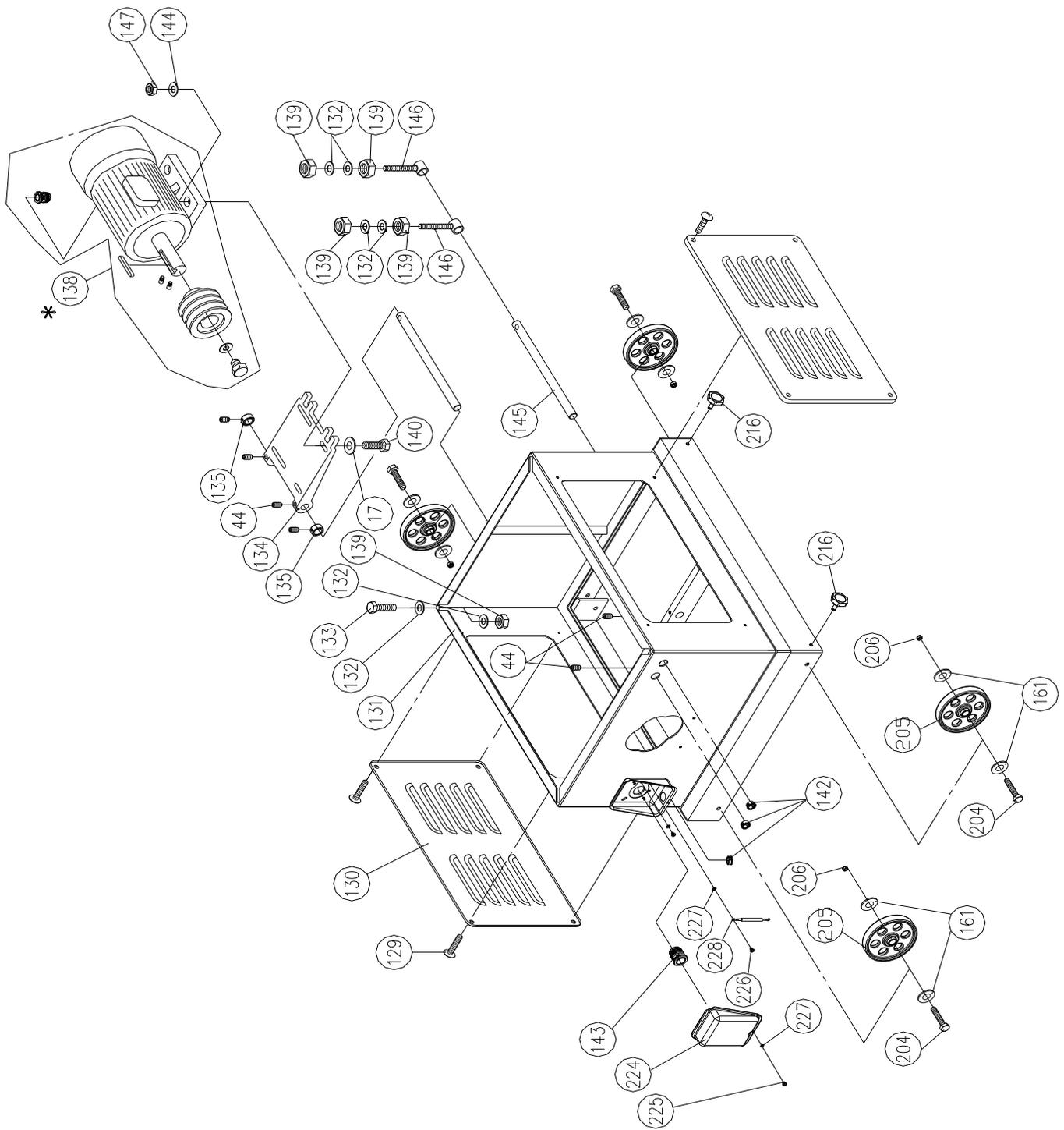
# PARTS DIAGRAM – SHEET 1





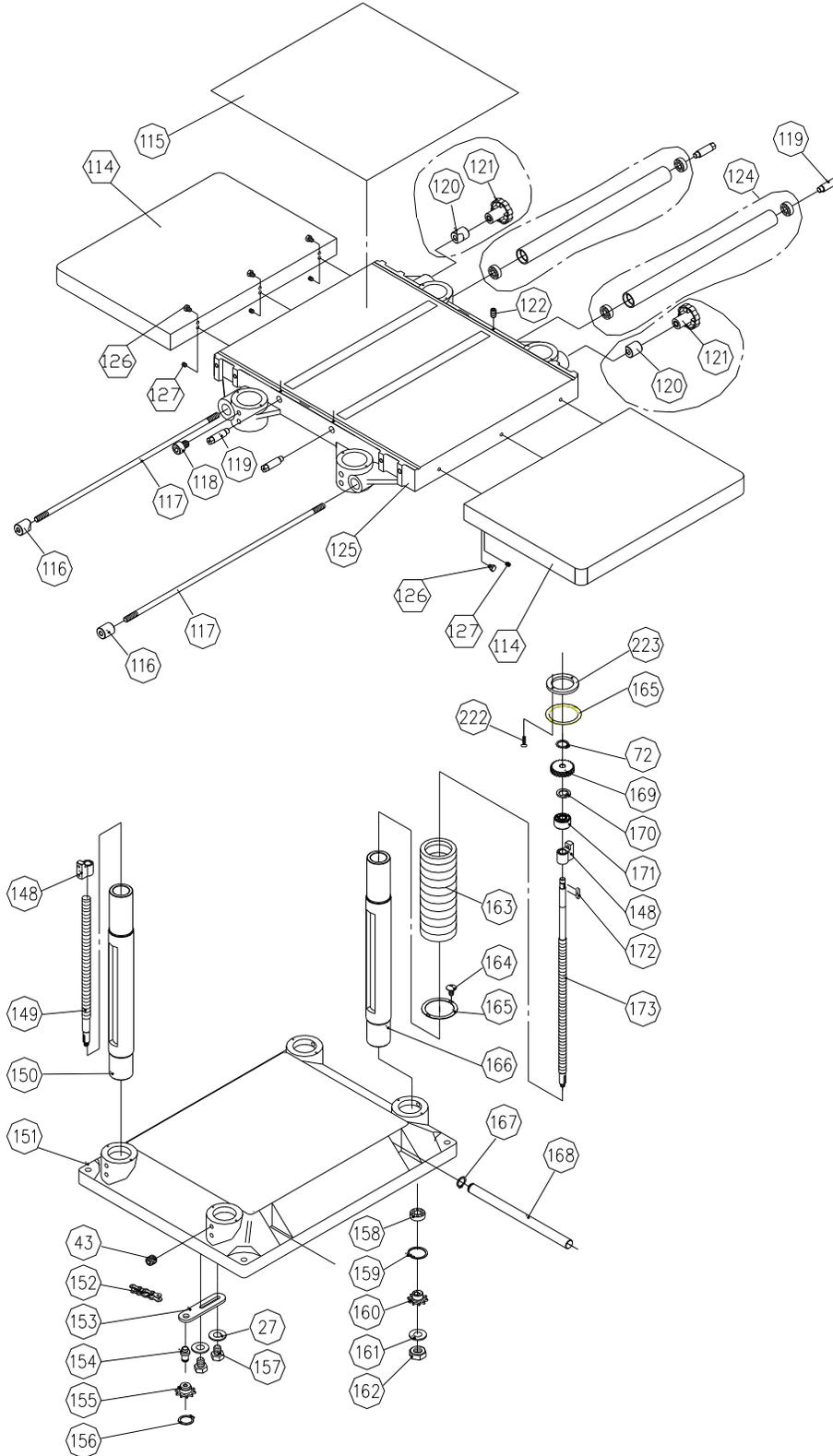


# PARTS DIAGRAM – SHEET 3





# PARTS DIAGRAM – SHEET 4





## Parts List

Item	Descriptions	Specification	Qty.
1	Nut		2
2	Belt Guard Front		1
3	V-Belt	M57	3
4	Bolt		2
5	Hex Screw	M8 x 1.25P x 20	7
6	Flat Washer	8.2 x 30 x 4.0T	2
7	Hex Screw W/Washer	M6 x 1.0P x 12	20
8	Belt Guard Rear		1
9	Hex Nut	5/16"-18NC (12.7B x 6.75H)	2
11	Cutterhead Pulley		1
12	Dust Chute		1
13	Hex Screw	M6 x 1.0P x 12	4
14	Flat Washer	6.6 x 13 x 1.0T	8
15	Cap Screw	M6 x 1.0P x 12	9
16	Dust Hood		1
17	Flat Washer	8.5 x 23 x 2.0T	4
18	Cap Screw	M6 x 1.0P x 16	9
19	Handwheel		1
20	Handle		1
21	Sponge		1
22	Chip Deflector		1
23	Spring Plate		3
24	Set Screw	M6 x 1.0P x 16	7
25	Spring Plate		1
26	Screw		4
27	Flat Washer	8.2 x 22 x 3.0T	3
28	Bracket		1
29	Shaft		1
30	Chain Tensioner		2
31	Chain Tensioner Shaft		2
32	Side Cover Guard		1
33	Spring Pin	6 x 20mm	2
34	Side Cover		1



Item	Descriptions	Specification	Qty.
35	Cap Screw	M8 x 1.25P x 40	1
36	Spring		1
37	Hook		1
39	Shaft		1
40	Cap Screw	M6 x 1.0P x 35	1
41	Side Cover Guard		1
42	Magnetic Switch Assembly	5HP, 220V-240V, 1PH (ON/OFF), CSA	1
42.1	Magnetic Switch	5HP, 220V-240V, 1PH	1
42.2	Switch Mounting Plate		1
42.3	Round Hd Screw	3/16"-24NC x 5/8"	2
42.4	Hex Nut	3/16"-24NC (8B x 4H)	2
42.5	Power Cord	SJT12AWG, 3C x 1450mm	1
42.6	Power Cord	SJT12AWG, 3C x 2000mm	1
42.7	Tooth Washer	5.3 x 10 (BW-5)	2
42.8	Relief Bushing	1/2"	2
43	Set Screw	M10 x 1.5P x 12	16
44	Set Screw	M8 x 1.25P x 12	7
45	Head		1
46	Shaft		2
47	Round Head Rivet	2 x 5mm	4
48	Hex Nut	M6 x 1.0P (10B x 5H)	8
49	Set Screw	M6 x 1.0P x 20	2
50	Flat Head Screw	M5 x 0.8P x 12	2
51	Limit Plate		1
54	Ball Bearing	6206	1
55	Key	8 x 8 x 36mm	1
56	4 Standard Blades Cutterhead Assemblies		1
56.1	Cutter Head		1
56.2	Knife		4
56.3	Flat Head Screw	M5 x 0.8P x 12	8
56.4	Spring		8
56.5	Knife Lock Bar Assembly		4
56.6	Tilt Plate		1
56.7	Knife Gauge		2



Item	Descriptions	Specification	Qty.
56.8	Retainer Plate	ETW-9	4
58	Spring		4
59	Bushing		4
60	Retainer Plate		4
61	Spring Washer	8.2 x 15.4mm	3
62	Pressure Plate		1
63	Outfeed Roller		1
64	Key	5 x 5 x 22mm	2
65	Chain Sprocket		1
66	Flat Washer	6.2 x 20 x 3.0T	4
67	Hex Screw	M6 x 1.0P x 16	3
68	Bracket		2
69	Shaft		1
70	Chip Breaker		1
71	Chain Sprocket		1
72	S-Ring	STW-12	2
73	Retaining Ring	ETW-15	2
74	Spacer		56
75	Anti-Kick Back		55
76	Shaft		1
77	Shaft		1
78	Hex Nut	M12 x 1.75P (19B x 10H)	2
79	Infeed Roller		1
80	Chain	#06B x 67P	1
81	Cap Screw	M8 x 1.25P x 50	4
82	Ball Bearing	6204	1
83	Gear		1
84	Cap Screw	M6 x 1.0P x 25	5
85	Ball Bearing	6201	5
86	Gear		1
87	Shaft		1
88	Key	5 x 5 x 12mm	1
89	Gearbox Cover		1
90	Pin		2
91	Flat Washer	8.5 x 16 x 1.5T	2



Item	Descriptions	Specification	Qty.
92	Shaft		1
93	Key	6 x 6 x 40mm	1
94	Key	5 x 5 x 10mm	1
95	Gear		1
96	Knob		1
97	Chain	#06B x 50P	1
98	Chain Sprocket		1
99	Plug	PT1/4"-19	2
100	Oil Seal	TC28 x 40 x 8	1
101	Gearbox		1
102	Gearbox Gasket		1
103	Gear Assembly		1
104	Retaining Ring	RTW-32	1
105	Shaft		1
106	Spring		1
107	Steel Ball	6	1
108	Oil Seal	SC25 x 47 x 6	1
109	Ball Bearing	6204	1
110	Flat Washer	6.6 x 13 x 1.0T	7
111	Shifting Claw		1
112	Shaft		1
113	O-Ring	P12	1
114	Extension Table		2
115	Plastic Sheet	720 x 570 x 0.05T	1
116	Column Lock Bushing		2
117	Shaft		2
118	Cap Screw	M8 x 1.25P x 16	8
119	Eccentric Shaft		4
120	Column Lock Bushing		2
121	Knob		2
122	Set Screw	M6 x 1.0P x 12	6
123	Ball Bearing	6201	1
124	Roller W/Bearing		2
125	Table		1
126	Hex Screw	M8 x 1.25P x 25	6



Item	Descriptions	Specification	Qty.
127	Set Screw	M8 x 1.25P x 20	6
129	Flat Head Screw	M6 x 1.0P x 20	8
130	Cover		2
131	Motor Assembly		1
132	Flat Washer	13 x 28 x 3.0T	13
133	Hex Screw	M12 x 1.75P x 50	4
134	Motor Plate		1
135	Spacer		2
138	Motor Assembly	5HP, 220V, 60HZ, 1PH, 2P	1
139	Hex Nut	M12 x 1.75P (19B x 10H)	8
140	Hex Screw	M8 x 1.25P x 40	4
142	Relief Bushing	NB-1722	3
143	Relief Bushing	PGA13.5-11B	1
144	Flat Washer	8.5 x 16 x 1.5T	4
145	Motor Mounting Shaft		2
146	Motor Mount Tension Shaft Assembly		2
147	Hex Nut	M8 x 1.25P (13B x 6.5H)	4
148	Nut		4
149	Column Shaft		3
150	Column		3
151	Base		1
152	Chain	#40 x 166P	1
153	Chain Tensioner Bracket		1
154	Sprocket Shaft		1
155	Chain		1
156	S-Ring	STW-15	1
157	Hex Nut	M8 x 1.25P x 25	2
158	Ball Bearing	6202	4
159	Retaining Ring	RTW-35	4
160	Chain		4
161	Flat Washer	10.5 x 19 x 1.5T	12
162	Hex Nut	M10 x 1.25P (17B x 8H)	4
163	Expansion Bend		8
164	Self-Tapping Screw	M5 x 2.12P x 10	30



Item	Descriptions	Specification	Qty.
165	Fixed Bush		16
166	Main Column		1
167	Retaining Ring	ETW-17	4
168	Rod		4
169	Worm Gear		1
170	Retaining Ring	RTW-38	1
171	Bushing		1
172	Key	4 x 4 x 10mm	2
173	Elevating Screw		1
174	Hex Wrench	3mm	1
175	Hex Wrench	4mm	1
176	Hex Wrench	5mm	1
177	Hex Wrench	6mm	1
178	Wrench Box	8 x 10mm	1
179	Wrench Box	12 x 14mm	1
180	Wrench Box	17 x 19mm	1
188	Roller Bracket		3
189	Roller		2
190	Worm Gearbox		1
191	Cap Screw	M6 x 1.0P x 50	3
192	Shaft		1
194	Spacer		1
201	Cap Screw	M6 x 1.0P x 10	2
204	Hex Nut	3/8"-16NC x 2-1/2"	4
205	Wheel		4
206	Hex Nut	3/8"-16NC (14.2B x 11.5H)	4
208	Digital Read Out Assembly	9 inch	1
208.1	Digital Read Out	9 inch	1
208.2	Lower Plate		1
208.3	Upper Plate		1
208.4	Set Screw	M10 x 1.5P x 30	1
208.5	Hex Nut	M10 x 1.5P	1
208.6	Flat Washer	8.5 x 16 x 1.0T	1
208.7	Cap Screw	M8 x 1.25P x 30	1
208.8	Flat Washer	4.3 x 10 x 1.0T	1



Item	Descriptions	Specification	Qty.
208.9	Round Hd Screw	M4 x 0.7P x 6	1
208.10	Round Hd Screw	M3 x 0.5P x 6	2
216	Knob	5/16"-18NC x 3/4"	2
217	Hex Screw	M6 x 1.0P x 12	6
219	Hex Head Screw	M8 x 1.25P x 30	1
220	Wood Screw	M6 x 2.6P x 24	16
221	Sponge	3/8" x 1/2" x 525L	1
222	Round Hd Screw	M5 x 0.8P x 16	2
223	Washer		1
224	Terminal Cover		1
225	Round Hd Screw	3/16"-24NC x 1/4"	1
226	Round Hd Screw	M5 x 0.8P x 10	2
227	Tooth Washer	5.3 x 10 (BW-5)	3
228	Power Cord	SJT12AWG, 1C x 150mm	1
229	Parts Package		1
230	Pad		2
231	Flat Washer	6.2 x 22 x 3T	4



NOTES



## NOTES

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