

RECORD MACHINE DETAILS

MODEL

SERIAL No.

DATE of PURCHASE

VOLTAGE

PHASE

CYCLES

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DISTRIBUTOR

STARTRITE

Model PT260

PLANER & THICKNESSER

HANDBOOK

29 E

FOR SALES, SPARES & SERVICE CONTACT:

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We reserve the right to change design and specification without notice.
Startrite Machine Tool Co. Ltd., Waterside Works, Gads Hill,
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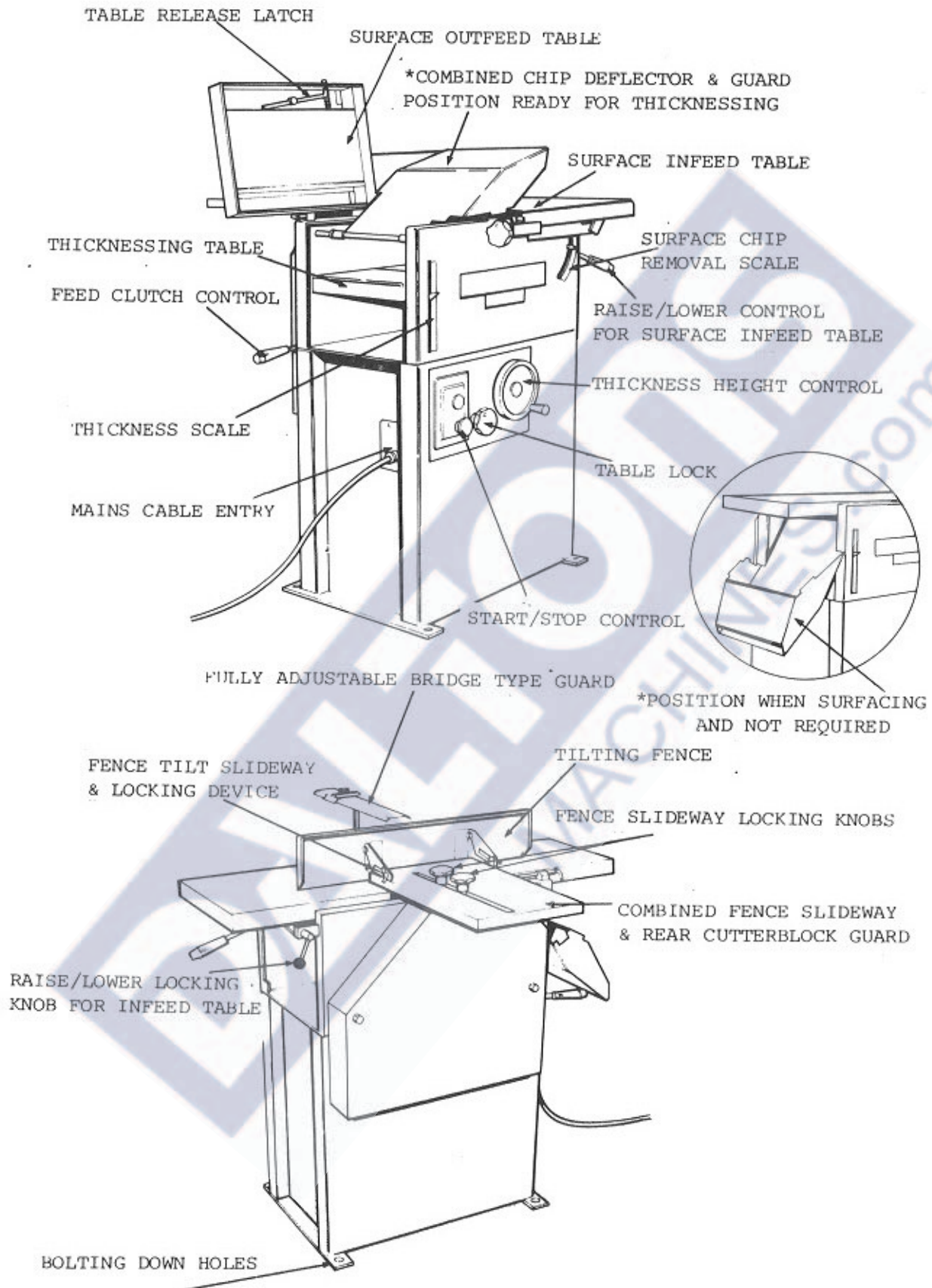
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SPECIFICATION

Model PT260	-Planer/Thicknesser	
Surface Capacity	-260 mm,	10 $\frac{1}{4}$ "
Combined Table Length	-1000 mm,	39 $\frac{3}{8}$ "
Infeed Table Width	-345 mm,	13 $\frac{1}{2}$ "
Outfeed Table Width	-265 mm,	10 $\frac{3}{8}$ "
Rebate Depth	-15 mm,	$\frac{9}{16}$ "
Cutterblock Diameter	-70 mm,	2 $\frac{3}{4}$ "
Cutterblock Speed	-6000 r.p.m.	
Number of cutters	-2	
Thicknessing Depth	-180 mm,	7"
Thicknessing Width	-260 mm,	10 $\frac{1}{4}$ "
Thicknessing Table Length	-560 mm,	22"
Feed Speed	-5.7M/min,	18.7ft/min
Motor Power.	3Phase	-1.1 K.W, 1.5 H.P.
	1Phase	-1.1 K.W, 1.5 H.P.
Machine Dimensions.	Length.	-1000 mm, 39 $\frac{3}{8}$ "
	Width.	-600 mm, 23 $\frac{3}{8}$ "
	Height.	-990 mm, 39"
	Weight.	-120kg, 265 lbs.

ALL DIMENSIONS ARE APPROXIMATE.

FOR BEST RESULTS USE STARTRITE PLANER KNIVES.



OPERATING SAFETY PRECAUTIONS.

BEFORE ATTEMPTING TO OPERATE THE MACHINE BECOME FAMILIAR WITH THE CONTROLS AND OPERATING INSTRUCTIONS.

NO PERSON SHOULD OPERATE THIS MACHINE WITHOUT SUFFICIENT TRAINING AS TO ITS SAFE AND PROPER OPERATION, OR WITHOUT SUPERVISION AS MAY BE NECESSARY (Para.2 No.903 Woodworking Machinery Regulations 1974).

Before starting the machine, check that it is safe to do so, ensuring that the knives are correctly set and securely fastened and all necessary adjustments have been completed and all guards are positioned and securely fixed.

Never make any adjustments while the machine is running. Make sure the machine has been completely switched off and isolated.

Keep hands well away from the rotating cutterblock and all moving parts.

For short lengths and ends of material to be machined, use a push-block or stick to feed with. (Should be made from straight grained hardwood, notched at feed end to grip material and shaped at other end to form a comfortable handgrip.

Never operate machine with loose cuffs, exposed bandages etc. which may become entangled in moving parts. Should a necktie be worn, prevent ends from hanging loose.

Use only knives that are suitable for the machine and are in good condition for the work in hand. Knives that are blunt are unsafe to use and should be re-ground or replaced.

When machining long lengths of material, roller supports or trestles should be used to support overhanging weight of material.

Always keep working area around the machine free from waste chippings and other obstructions.

When leaving machine unattended, make sure that the starter and isolator (if fitted) are in the 'OFF' position.

INSTALLATION

IMPORTANT: DO NOT LIFT OR MOVE MACHINE BY TABLES AS THIS MAY CAUSE MIS-ALIGNMENT OF TABLES.

Site the machine with adequate working space around it so as to ensure proper operation without obstruction.

Where possible, choose a position that offers minimum risk of the operators attention being distracted while using the machine. Take advantage of any natural light available and adequate artificial lighting over the whole working area.

The floor around the machine must have a level, non-slip surface free of any feature which may create a hazard. To comply with the Woodworking Regulations the machine should be anchored with fixing bolts (not supplied) through the bolting down holes in the feet of the machine. Before anchoring the machine to the floor, place packing under feet to ensure that it stands firmly and without wobble.

CONNECTION TO THE ELECTRICITY SUPPLY.

SINGLE PHASE.

IMPORTANT: Check that the machine is suitable for the electricity supply. At all times, ensure that the machine is isolated from mains supply before making any electrical connections or adjustments.

IMPORTANT: IN ALL CASES THE MACHINE MUST BE EFFECTIVELY EARTHED.

Recommended cable size: 1.5 mm²

Fuse rating: 13 amp.

At the side of the machine remove electrical cover plate by means of one screw (see Fig.2). Pass supply lead through cable entry gland in cover plate and link live supply lead to terminal L1, neutral supply lead to terminal N and earth lead to terminal E (see Fig.3). Replace electrical cover plate and tighten gland nut.

Connection can be made to a 13 amp ring main circuit, (by simply wiring the supply leads to a 13 amp fuse as shown in Fig.1.) Local regulations and/or operating conditions may require alternative methods to be adopted.

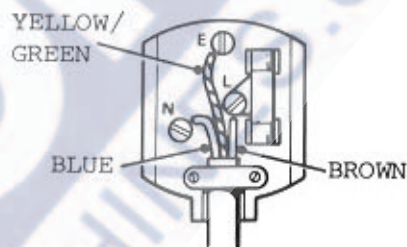


Fig.1

COLOUR CODE

LIVE	(L)	-	BROWN
NEUTRAL	(N)	-	BLUE
EARTH	(E)	-	YELLOW/ GREEN

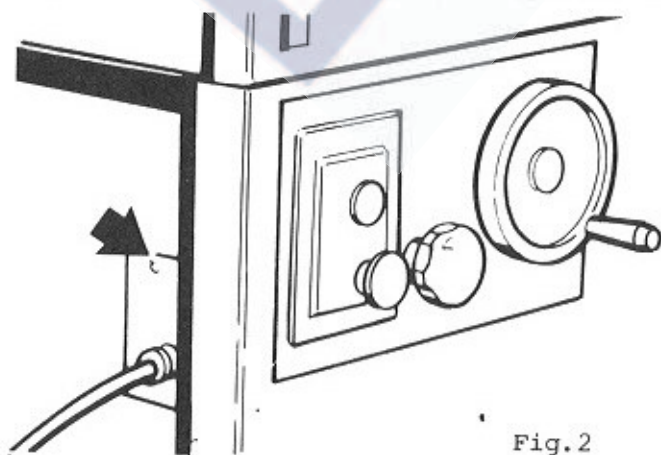


Fig.2

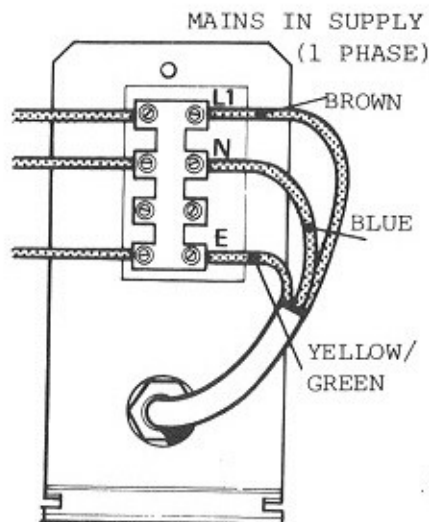


Fig.3

CONNECTION TO ELECTRICITY SUPPLY (CONTINUED).

THREE PHASE.

At side of machine remove electrical cover plate by means of one screw (see Fig.2). Pass supply lead through cable entry gland in cover plate and link live supply leads to terminals L1, L2, L3, and earth to terminal E (see Fig.3a). Replace electrical cover plate and tighten gland nut.

The supply lead should be protected by solid or flexible conduit to a suitable isolater. Check local regulations and operating conditions as required.

A three phase motor may run in either direction, therefore, check that cutterblock rotates clockwise as shown in Fig.4. If necessary, interchange any two of the supply leads to reverse rotation.

IMPORTANT: IN ALL CASES THE MACHINE MUST BE EFFECTIVELY EARTHED.

Both single and three phase motors are protected by the contactor which incorporates an overload release.

Should overload take place during operation due to work load or feed being too heavy for the motor to accommodate, the overload units trip will release and stop motor automatically. Allow 30-60 seconds before re-starting in normal way (this allows heater coils to cool). Care should be taken to ease the load or feed condition so as not to overload the motor again.

IMPORTANT: The service of a competent electrical engineer must be obtained if there is any doubt on any point regarding electrical installation.

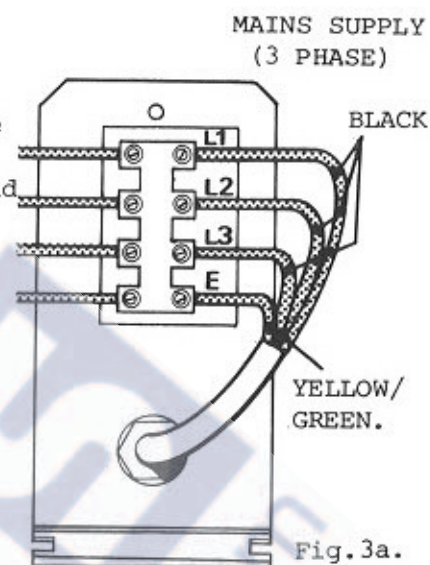


Fig.3a.

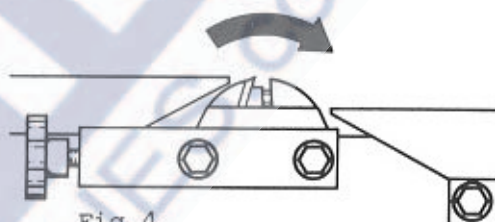


Fig.4.

SUPPLY	MOTOR F/L AMPS	OVERLOAD UNIT AMPS RANGE	OVERLOAD UNIT PART No's.
240/1/50Hz	8.0	8.0 - 12.0	47H0111
415/3/50Hz	2.6	2.7 - 4.2	47H0108

GUARD & SAFETY DEVICE.

BRIDGE TYPE CUTTERBLOCK GUARD FOR USE ON ALL SURFACING OPERATIONS

SURFACING:

Keep cutterblock guard within 10 mm above material and as close as possible to fence (see Fig.5)

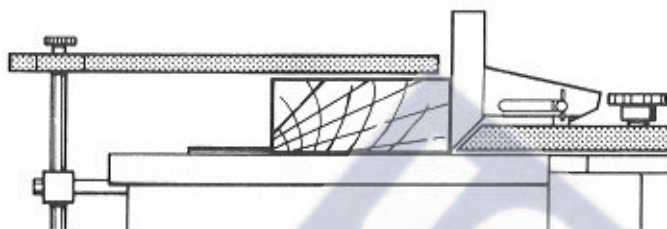


Fig.5.

EDGING:

Keep cutterblock guard as close as possible to the table and within 10 mm from material (see Fig.6)

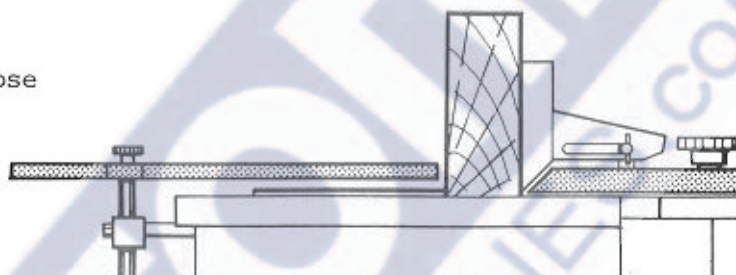


Fig.6.

BEVELLING:

Keep cutterblock guard as close as possible to both table and material (see Fig.7)

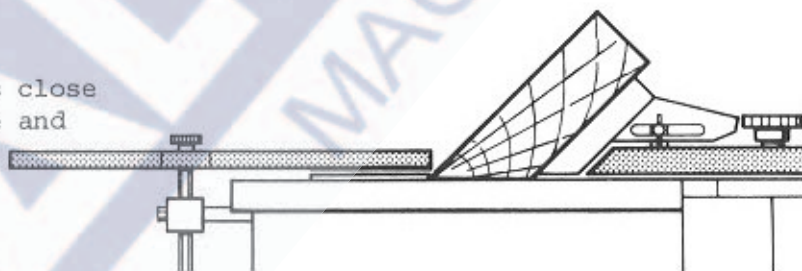


Fig.7.

SAFETY HOLDING DEVICE, USE WHEN REBATING & WHEN BRIDGE GUARD IS NOT SUITABLE.

REBATING:

Secure safety holding device into holder and apply pressure springs as shown in Fig.8.
If required wooden facing pads can be fitted to the pressure springs using the screw holes provided.
As shown in Fig.8A.

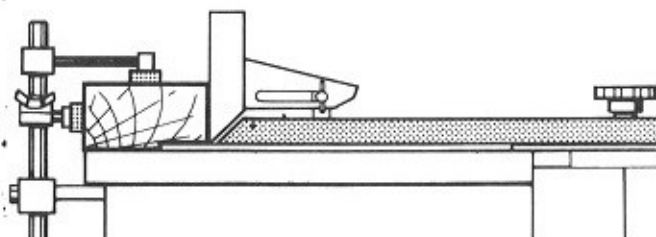


Fig.8.

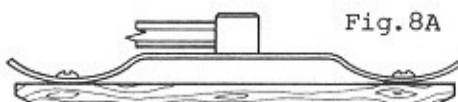


Fig.8A

THICKNESSING GUARD & DEFLECTOR

For operation position move fence back. Release table latch (see Fig.9.). Lift table into vertical position as shown. It will then be possible to swing guard/deflector over until it comes to rest on the infeed table.

IMPORTANT: Care should be taken that guard/deflector is not maladjusted and fouls cutterblock.

A self operating anti-kick back device is fitted prior to the feed roller allowing material to pass in a forward direction only (see Fig.10), eliminating any rejection. This device makes it extra safe when machining one or more pieces of material at one time.

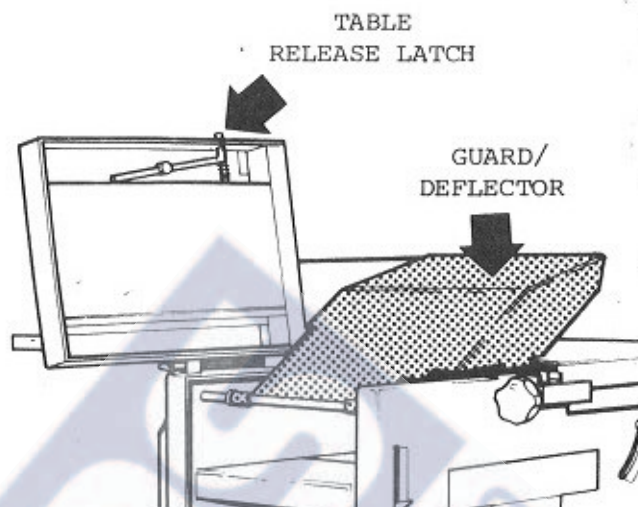


Fig.9:Final operational position.

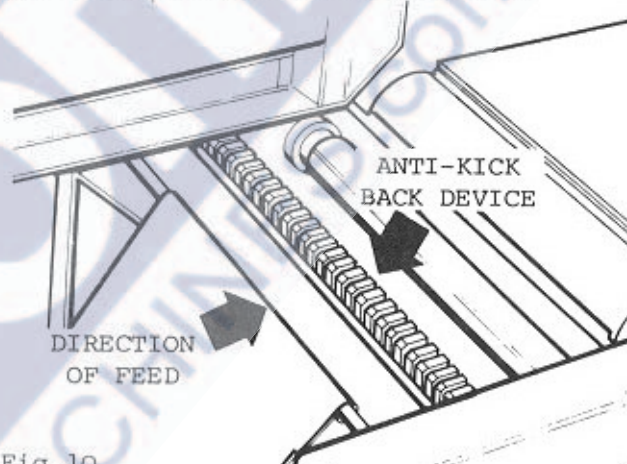


Fig.10

ADJUSTMENT & FIXING OF KNIVES.

For perfect machining, the two knives must be in alignment to each other and the same height as the outfeed table. This can be carried out as follows:-

Release knife wedge retaining screws (see Fig.11) with 10 mm wrench supplied. The knives being spring loaded will automatically lift out of slot and above table. After selecting the uppermost point, the knives can be held down with a piece of flat hardwood to the same height as the outfeed table (see Fig.12). Holding the knife down firmly the retaining screws can be re-tightened, starting with the centre one and working outwards. Care should be taken that the edge of the knife is set with a clearance to the edge of the outfeed table (see Fig.11) for rebating.

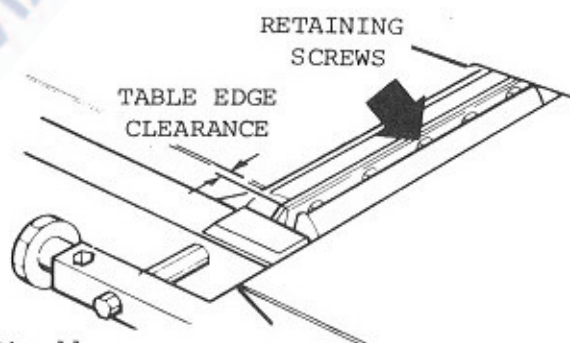


Fig.11

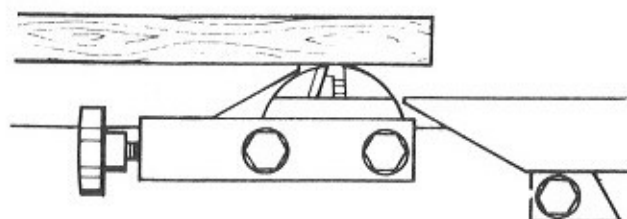


Fig.12

OPERATING SURFACER.

SURFACING:

Examine material to ensure that it is perfectly clean and free from any embedded flint, nails etc. Otherwise this will have a serious effect on the knives. Only the minimum amount of cut to take out all the irregularities in the surface should be made. This amount can be set by releasing locking handle (see Fig.13, page.10.) And setting the amount of material to be removed against scale using infeed control. Finally lock into position with locking handle. Now that the material is ready to be machined, place material on infeed table and hold tightly against fence. Pass over cutterblock and onto outfeed table at the rate of 5.7 metres/18.7 feet per minute for best results. (see Fig.5 page 8 for correct guarding)

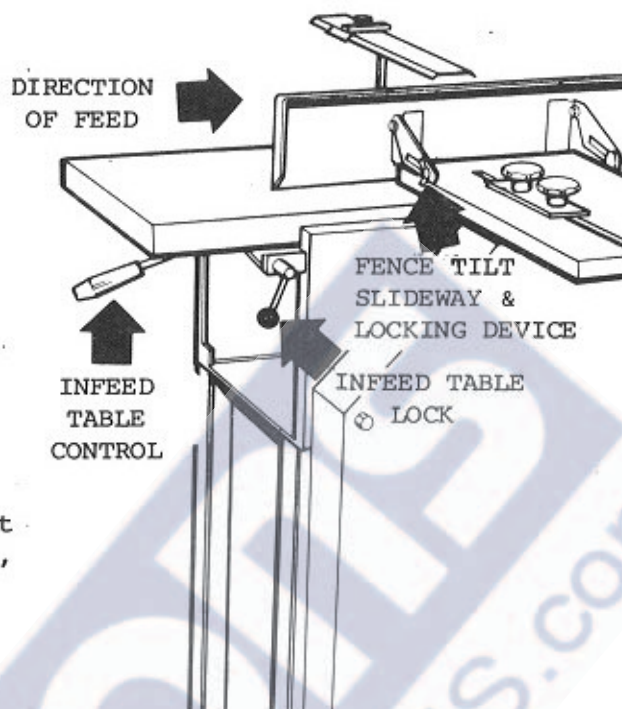


Fig.13.

EDGING/SQUARING

Set fence at 90° to tables and lock securely. Proceed as for surfacing but ensure that material surface is held firmly flat against fence prior to cutterblock. After passing cutterblock the material will seat squarely between fence and tables. (see Fig.6 page 8 for correct guarding).

BEVELLING:

As for edging, adjust fence to required angle by means of tilt slideway and locking securely (see Fig.13), and (Fig.7, page 8 for correct guarding).

REBATING:

Before Rebating, check that knives are correctly set for this operation (see Figs.11 & 12 page 9). The fence should be moved across table and set to required rebate width. Measurement is taken from the corner of the blade. For depth lower infeed table to required amount as for surface planing and edging. (see Fig.8, page 8 for correct setting of safety device).

IMPORTANT:

For all hand feed operations carried out above tables. NEVER feed faster than cutterblock can accommodate. This will be noted by a decreased tone of speed. Performance will vary according to condition of knives, machinability, width and thickness of chip removal of material and feed speeds.

THICKNESSING.

Prepare machine for thicknessing as illustrated in Fig.9 page 9. Check the thickness of material and set thicknessing table by rotating thicknessing height control (see Fig.14) to the required amount, then lock in place, as shown using locking knob. Should the amount of chip removal be greater than 5mm, two or more passes will have to be made. To start the automatic feed engage clutch control (see Fig.14a) which will set the feed rollers in motion. Enter material into thicknessing aperture pushing forward until the feed rollers take over the power feed. Long lengths of material must be supported either by hand, roller or trestle, to eliminate overhang drag.

Should the feed have to be stopped during operation, or when finished with, disengage clutch into locked position.

To ensure smooth power feeding the thicknessing table must be kept polished at all times. Waxing occasionally may also be required. certain operational conditions may require the feed roller tension springs (found directly below rollers) to be adjusted accordingly.

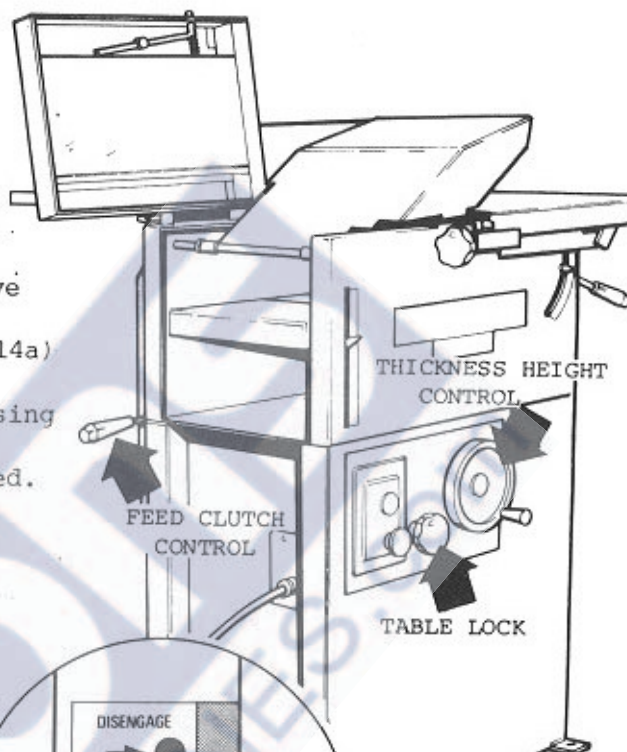


Fig.14

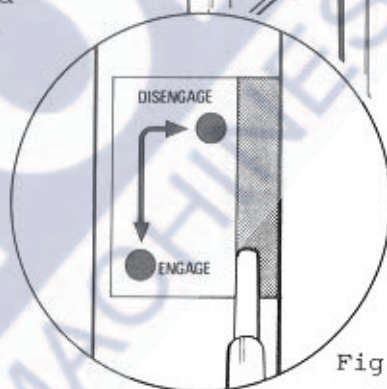


Fig.14a

MAINTENANCE.

All bearings are sealed-for-life and require no further lubrication. Periodically, blow out with air all dust and chippings, wiping clean all moving parts and lightly oil with a cloth. Particular attention should be given to the table movements. And driving chains which can be found on removing the drive gear cover.

IMPORTANT: Isolate machine from mains supply before removing cover. Both driving chains are fitted with self-adjusting tensioning devices and require no further attention. The belt should be replaced when showing signs of wear or slipping during operation.

Belt tension is adjusted by slackening off nut at the rear of jockey pulley assembly and moving out towards end of slot to tension required, then re-tighten nut. A good guide as to the correct belt tension is that it should be possible to give the vee-belt a quarter twist midway between pulleys using thumb and forefinger only (see Fig.15).

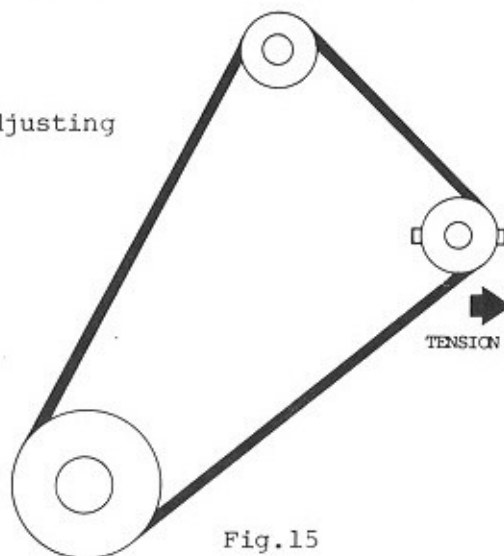
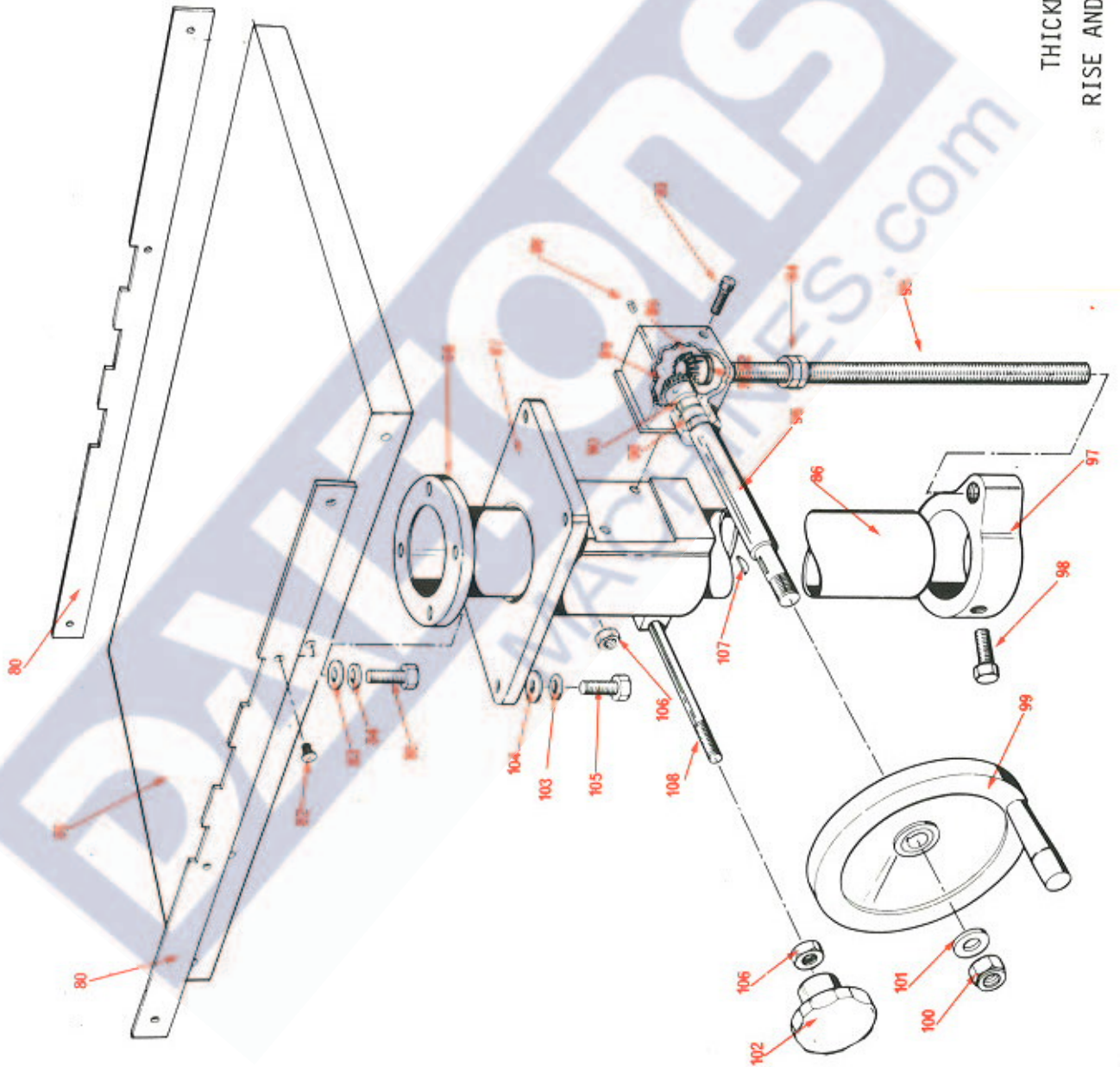


Fig.15

THICKNESSING TABLE/RISE AND FALL ASSEMBLY.

ITEM	PART NUMBER AND DESCRIPTION	No.OFF
80	M6865 Thicknessing Table Side Plates	2
81	SM1943 Thicknessing Table	1
82	Soc Csn/k. Scw.M5 x 8LG	8
83	Plain Washer M8	4
84	Shakeproof Washer M8	4
85	Hex.Hd.Scw M8 x 25LG	4
86	SM1454 Table Column	1
87	M6887 Column Casting	1
88	Sel-lok Pin,Dia $\frac{1}{16}$ " x $\frac{1}{8}$ " LG	2
89	2715 Mitre Gear (plain)	2
90	Compo Bush SNO30 x $\frac{1}{8}$ "	2
91	Needle Thrust Race. NTA 815	1
92	2609 Thrust Washers	2
93	Soc. Cap. Scw. M6 x 55 LG	2
94	Lock Nut. M16	2
95	M6819 Studding	1
96	M6823 Handwheel Shaft	1
97	M6888 Locking Collar	1
98	Hex.Hd.Scw. M10 x 25 LG	2
99	M6867 Handwheel	1
100	Self-Locking Nut,M16	1
101	Plain Washer M16	1
102	Black HandKnob M10. 6687/52	1
103	Shakeproof Washer M10	4
104	Plain Washer M10	4
105	Hex.Hd.Scw. M10 x 25 LG	4
106	Full Nut M8	1
107	Woodruff Key.606	1
108	M6824 Locking Bar	1

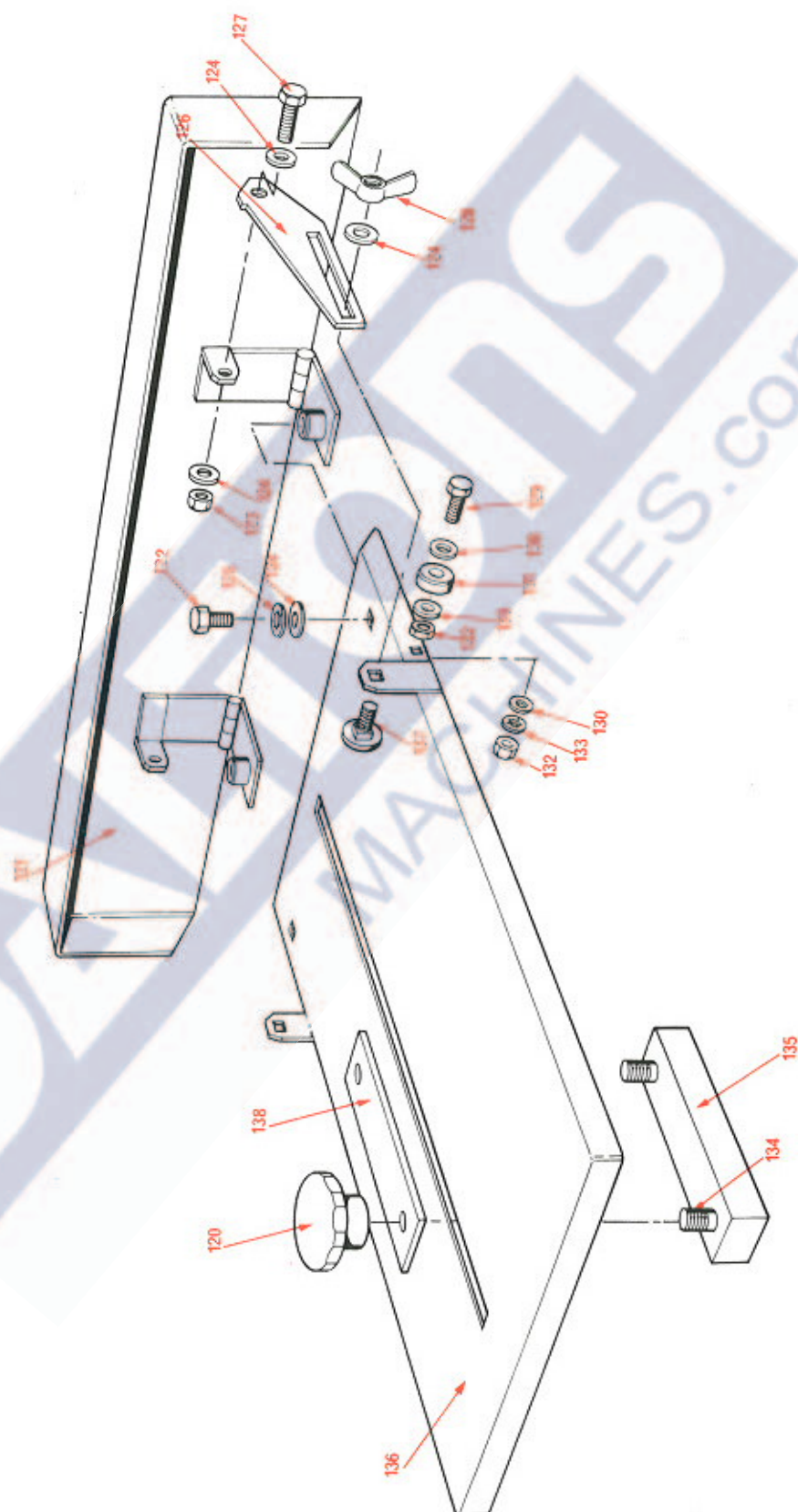
THICKENING TABLE/ RISE AND FALL ASSEMBLY



FENCE ASSEMBLY.

ITEM	PART NUMBER AND DESCRIPTION	No. OFF
120	Black Hand Knob M10.6687/52	2
121	SM1497 Fence	1
122	Hex. Hd. Screw M8 x 12LG	2
123	Self-locking Nut M8	2
124	Plain Washer M8 Form 'A'	8
125	Shakeproof Washer M8	2
126	M6843 Fence Pivot Link	2
127	Hex.Hd.Screw M8 x 16LG	2
128	Wing Nut M8 (Plated)	2
129	Hex.Hd.Screw M6 x 30LG	2
130	Plain Washer M6 Form 'A'	6
131	M6818 Roller	2
132	Full Nut M6	4
133	Shakeproof Washer M6	2
134	M6873 Stud	2
135	M6872 Clamp Block	1
136	SM1498 Fence Carrier/Guard	1
137	Coach Bolt M8 x 25LG	2
138	M7309 Clamp Plate	1

FENCE ASSEMBLY

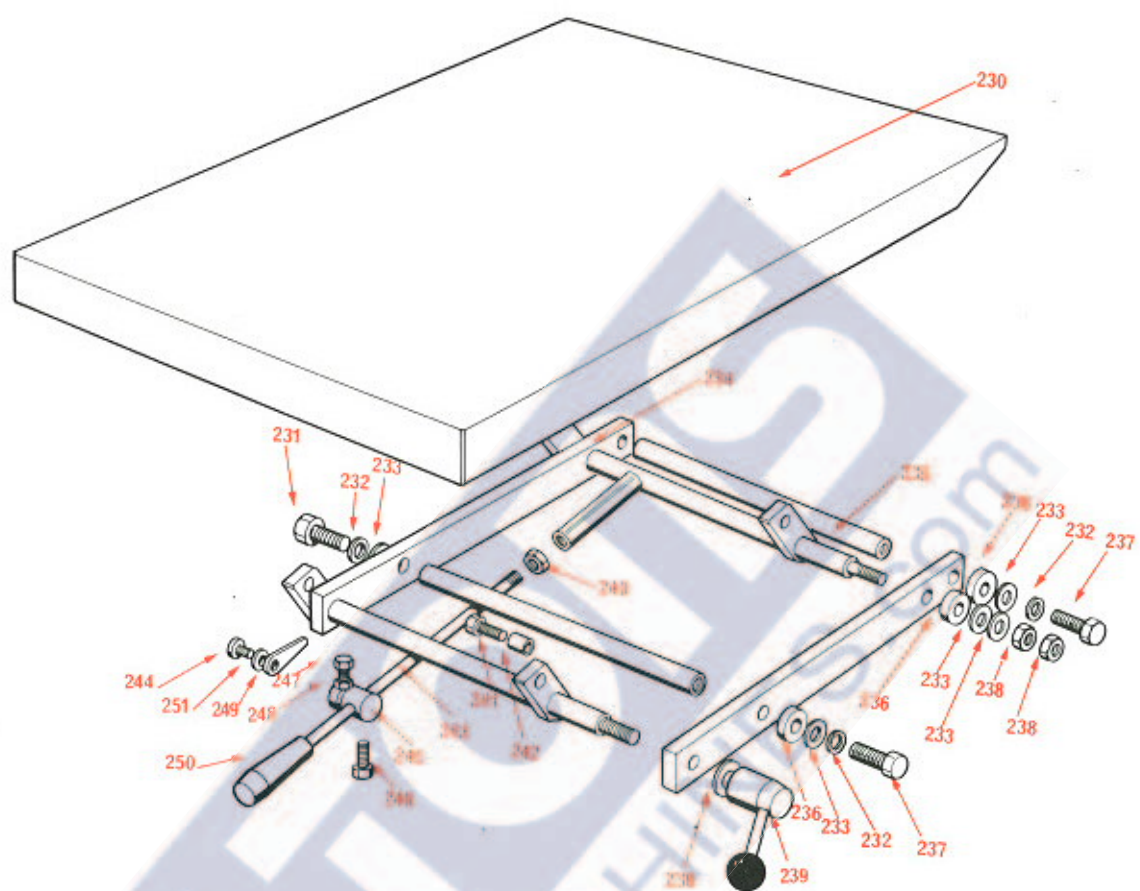


INFEED TABLE ASSEMBLY.

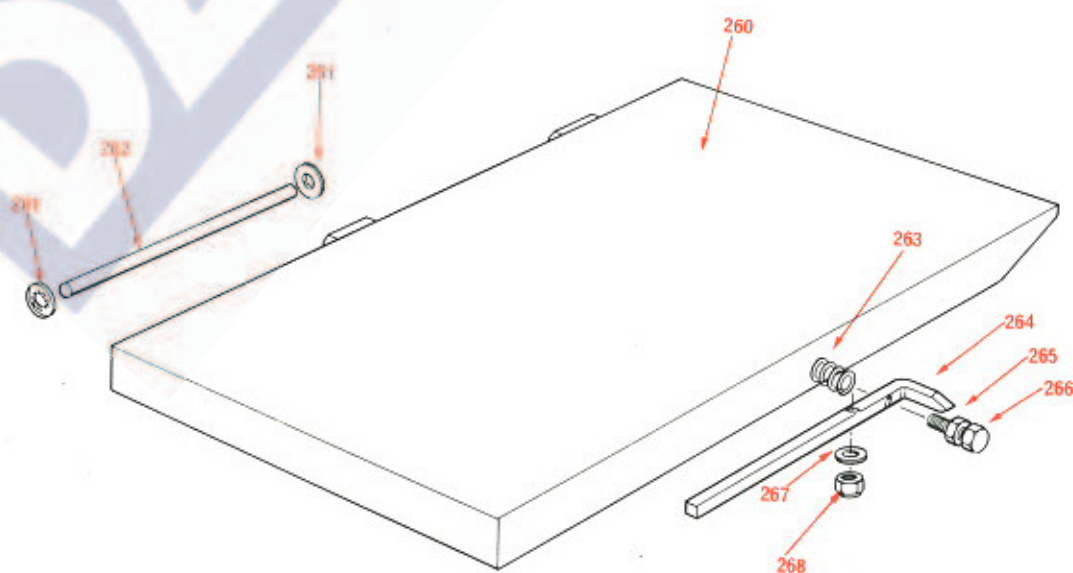
ITEM	PART NUMBER AND DESCRIPTION	No. OFF
230	SM1488 Infeed Table	1
231	Hex.Hd.Screw M10 x 30LG	2
232	Shakeproof Washer M10	4
233	Plain Washer Form 'A' M10	6
234	SM1446 Table Pivot	1
235	M6834 Torsion Bar	2
236	M6847 Spacer	3
237	Hex.Hd.Screw M10 x 40LG	2
238	Hex.Full Nut M10	2
239	SM1261 Handle	1
240	Locknut M10	1
241	Hex Hd Screw M6 x 30LG	4
242	M6836 Bush	4
243	M6838 Infeed Pivot Handle	1
244	Cheese Hd.Screw M6 x 8LG	1
245	M6875 Infeed Indicator Bar	1
246	Hex.Hd.Screw M6 x 10LG	1
247	Hex.Hd.Screw M6 x 45LG	1
248	Hex Nut M6.	1
249	M6877 Pointer	1
250	Handle 1306/F M10	1
251	Shakeproof Washer M6	1

FEED OFF TABLE ASSEMBLY.

260	SM1447 Feed Off Table	1
261	Starlock Washer 8mm Dia	2
262	M6966 Hinge Bar	1
263	Compression Spring. 163408	1
264	M6863 Table Latch	1
265	Locknut M8	1
266	Hex.Hd.Screw M8 x 35LG	1
267	Plain Washer Form 'A' M8	1
268	Self-Locking Nut M8	1



INFEED TABLE ASSEMBLY



FEED OFF TABLE ASSEMBLY

DRIVE ASSEMBLY

ITEM	PART NUMBER AND DESCRIPTION	No. OFF
1	SM1494 Idler Pulley	1
2	M6814 Cutterblock Pulley	1
3	Hex.Hd.Screw M8 x 12LG	3
4	Plain Washer M8 Form'A'	6
5	Shakeproof Washer M8 Form'A'	3
6	Soc. Set. Screw M6 x 8LG	8
7	M6830 Sprocket (34T)	2
8	Extension Spring AQ3316	2
9	M6817 Tension Bar	2
10	M6810 Spindle	1
11	Locknut M8	2
12	Plain Washer Form'A'M5	6
13	Hex.Hd.Screw M5 x 16LG	3
14	Compo Bush SNOO8 x $\frac{5}{16}$ "	2
15	M6828 Platewheel (57T)	1
16	Chain 1N'Simple 8mm Pitch 84 Links	1
17	Chain 1N'Simple 8mm Pitch 88 Links	1
18	M6829 Sprocket (21T)	2
19	'O' Ring 1691-84	1
20	M6827 Feed drive Roller	1
21	M6815 Motor Pulley	1
22	Vee Belt HY-T SPZ1137	1
23	Extension Spring AQ3332	1
24	SM1452 Feed Support	1
25	Handle 1306/FM10	1
26	M6818 Tension Roller	2
27	Hex.Hd.Screw M6 x 20LG	2
28	Full Nut M6	2
29	M6874 Spacer	2
30	Locknut $\frac{5}{16}$ "Whit	1
31	Compo Bush SNOO8 x $\frac{3}{8}$ "	2
32	Hex.Hd.Screw M5 x 25LG	3
33	M10 Locknut	1
34	Shakeproof Washer M5	6
35	Shoulder Screw $\frac{1}{2}$ "Dia x 1"LG - $\frac{3}{8}$ "Whit	1
36	Compo Bush SNO30 x $\frac{3}{8}$ "	2
37	Shoulder Screw $\frac{3}{8}$ "Dia x 1 $\frac{1}{2}$ "LG - $\frac{5}{16}$ "Whit	1
38	M6848 Guard Cover Pillar	2
39	M6811 Feed Engage Bar	1