OPERATION MANUAL

WINTER Thickness planner PLANERMAX 810

ATTENTION: ***Before commissioning it is necessary to get acquainted with all the instructions of this manual. The manufacturer is not responsible for damages caused due to improper operation of the machine or amendments in the design.***

Henrik Winter Holztechnik GmbH
Druckereistr. 8
04159 Leipzig

Tel: +49 (0)341/ 4619021 Fax: +49 (0)341/4618358 Funk: +49 (0)171/2820443
Em@il: info@winter-holztechnik.de Internet: www.winter-holztechnik.de

Table of contents

Warnings

1. Know your machine. For your own safety, read the operation manual carefully. Learn the machine applications and limitations, as well as specific potential hazards pertinent to this machine.
2. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning, make sure it is properly reattached before using the machine again.
3. Keep children away. All visitors should be kept a safe distance from the work area.
4. Make workshop childproof. Use padlocks or master switches, or remove starter keys.
5. Do not force the tool. It will do the job better and be safer working at the rate for which it was designed.
6. Use the right tool. Do not force the machine or attachment to do a job for which it was not designed.
7. Maintain tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
8. Disconnect tools before servicing or when changing accessories such as blades and cutters.
9. Reduce the risk of unintentional starting. Make sure switch is in OFF position before connecting to power source. If power is interrupted during operation, turn off switches before restoring power.
10. Never stand on machine. Serious injury could occur if it tips over or if the blade is unintentionally contacted.
11. Wear proper eye protection. Also use a face or dust mask if operation is exceptionally dusty.
12. Wear proper apparel. Avoid loose clothing, gloves, neckties, rings, bracelets or jewelry, which could get caught in moving parts. Wear protective hair covering to contain long hair.
13. Always use push sticks to feed work piece whenever possible.
14. Do not over reach. Keep proper footing and balance at all times. Never reach around or over cutting blade.
15. Operate the machine in a dry, indoor place. Do not expose it to rain. Keep work area clean and well lit.
16. Check damaged parts. Before using the machine check to see that all parts are in working order, including the range and traverse of moving parts. Damaged parts should be repaired or replaced before using the machine.
17. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
18. Never leave the machine running unattended. Do not leave the machine until it has come to a complete stop.
19. Make sure cutterhead rotates in a counterclockwise direction when viewed from the main drive motor side. If the cutterhead rotates clockwise, then check the wiring of the machine.
20. Then operating the planer, stand to the left side out of line with the table, and make sure no other persons are standing in line with the table
21. Do not plane boards with loose knots, nails or any foreign material on the workpiece surface. Knife impact on these objects can cause the knives to be pulled out of the cutterhead and shatter against the chipbreaker or pressure bar. Twisted, warped, or winding stock should first be jointed on one surface before attempting to plane.
22. Stacked boards: Do not feed stacked boards through the planer; Kickback can occur causing severe or fatal injury.
23. Short stock: do not attempt to plane boards shorter than 10”(250mm) in length without butting a board

of equal thickness behind it when feeding through the planer. Be sure the last board of a butted sequence is 250mm long or longer.

24. Wear ear protectors (plug or muffs) during extended periods of operation. If the board being planned stops feeding, disengage or turn the feed off and turn the power off. Wait until the cutter head comes to

    a complete stop before lowering the table to remove the board. Never lower the table with the power on and the stock still in the machine. A kickback can occur which could cause severe or fatal injury.
25. If the operator leaves the machine area for any reason, the planer should be turned “OFF” and the cutter head should come to a complete stop before leaving the machine. In addition, If the operation is complete, the operator should clean the planer and the work area.
26. Turn off the machine before cleaning, Use a brush or compressed air to remove chips or debris—do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Maintain a balanced stance at all times so that you do not fall or lean against the knives or other moving parts. Do not overreach or use excessive force to perform any machine operation.
29. Use recommended accessories, Improper accessories may be hazardous.
30. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
31. Only cutter compliance with EN847-1 can be used in this machine.
32. Do not use this planer for other than its intended use. If use for other purposes, disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use. .
33. This planer is designed and intended for use by properly trained and experienced only. If you are not familiar with the proper and safe operation of a planer, do not use until proper training and knowledge have been obtained.
34. Replace the warming labels if they become obscured or removed.
35. Provide for adequate space surrounding work area and non-glare, overhead lighting.
36. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.

Using restriction

The machine is designed for woodworking purpose (e.g. wood, plywood, composite wood, etc.).
It is prohibited to process any other materials of work piece, (e.g. metal material, rubber/plastic material, alloy. Etc.).

Introduction

This manual is covering the safe operation and maintenance procedures for a Model An-926/932/940/952 Planer. This manual contains instructions on installation, Maintenance instructions, safety precautions, General operating procedures and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier

Description

This planer is built for the rugged, industrial environment. It features a Yunnan helical cutter head with reversible TCT knives, rubber in feed roller with sectional chip breaker, and two rubber out feed rollers. The in feed and out feed rollers have lever type pressure. The cast iron table are supported by four massive columns, and the planer frame is built with heavy plate steel, this machine will not vibrate under load. Knife changes are quick with the self-seating knives. The planer will accommodate rough to finish work, and multiple piece planning.

Familiarize yourself with the following safety notices used in this manual:

⚠WARNING

This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING

This means that if precautions are not heeded, it may result in serious injury or possibly even death

----------Save these instructions----------

Specifications

Model	An-926	An-932	An-940	An-952
Main motor	7.5kw/11kw(opt)	15kw	18.7kw	22.5Kw
Table elevation motor	0.187Kw	0.375Kw	0.375Kw	0.375Kw
Feed motor	0.75Kw	1.5Kw	1.5Kw	1.5Kw
Variable feed speed (m/min.)	6-18	6-18	6-18	6-18
Cutterhead speed (RPM)	4500	4500	4500	4500
Cutterhead diameter (mm)	125	125	125	125
Knife size (straight Knife)	610*30*3mm	813*35*6mm	1016*35*6mm	1320*5*6mm
Knife size (Helical cutterhead)	14*14*2.0	14*14*2.0	14*14*2.0	14*14*2.0
Stock thickness (Min-Max)	6-300mm	8-300mm	8-300mm	8-300mm
Table dimensions (mm)	660*840	813*100	1016*1100	1320*1100
Dust port (in)	5”	6”	6”	6”
Thickness capacity (mm)	9mm	9mm	9mm	9mm
Belts	four V-belts	four V-belts	four V-belts	four V-belts
Machine Size (mm)	1080*840*1250	1280*100*1250	1480*1100*1250	1780*1100*1250
Net weight (kgs)	800	950	1100	1500
Shipping weight (kgs)	880	1100	1300	1700
Noise level (dB)	70	74	80	83

From the above measured results, this auto planer machine present no severs hearing or noise hazard to operator, however, the operator is recommended to wear ear caps whenever possible during operation and conform to the local safety regulations of labours.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, reserves the right to change specifications at ant time and without prior notice, without incurring obligations.

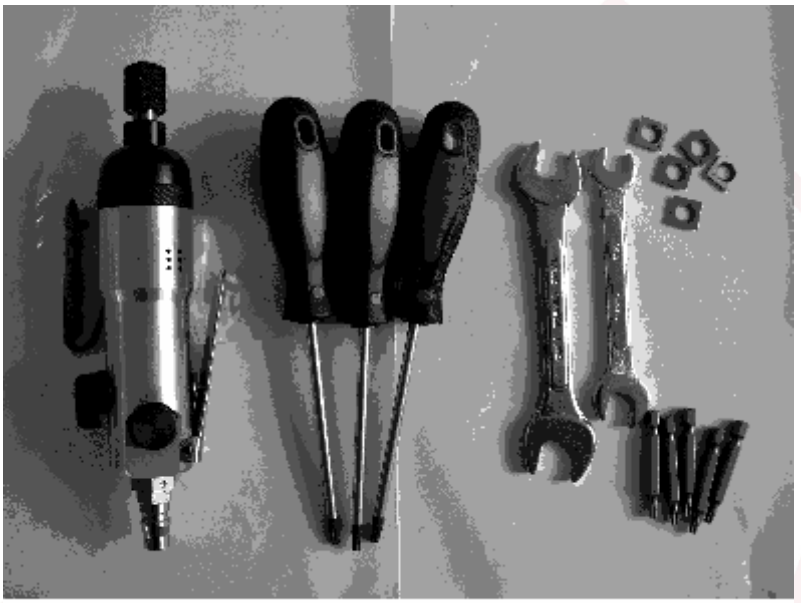
Unpacking

Open shipping crate and check for shipping damage. Report any damage immediately to you distributor and shipping agent. Read this instruction manual thoroughly for assembly, maintenance and safety instructions

Contents of the Shipping Container

1. Planer
2. Open-end wrenches (11-13,17-19,mm)
3. Owner's manual
4. Air drive……1set
5. Bits (T20) for TCT….5pce
6. TCT (‘14*14*2.)…….5pce
7. T20 Screw Drive…….3pce

(4-7 items for helical cutter head)



⚠WARNING

Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.

…save these instructions……

Installation

Tools required for installation
wrench set (provided) level
forklift or crane with straps.

Remove the crate from around the planer and any fasteners securing the planer to the skid. Remove the side covers and place the lifting hooks. Place straps under them and lift the machine off the skid. The planer should be located on a sturdy floor, preferably concrete, in a dry area with sufficient lighting. Leave enough space around the machine for loading and offloading stock and routine maintenance work.

When the planer is situated, use the leveling screws to level the machine.

This should be removed with a soft cloth and kerosene. Do not use an abrasive pad. Do not let solvent contact the plastic parts of the machine, as it may damage them.

Electrical Connections

WARNING

Electrical connections must be made by a qualified electrician in compliance with all relevant codes. The machine must be properly grounded to help prevent electrical shock and possible fatal injury.

1. The planer may be fitted with a correct volt, be ”hard-wired” directly to your electrical panel. If hard-wired to a panel, make sure disconnect is available for the operator.
2. Make sure the machine’s wire is disconnected from the power source. If it is hard-wired. Make sure the fuses have been removed or the breakers have been tripped in the circuit to which the saw will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired. Always follow proper Lock Out/Tag Out procedures when performing any wiring on this machine

3. 

Figure 1

Figure 2

4. Make sure the voltage of the power source corresponds to the power source corresponds to the voltage of the planer as recorded on the motor plate.
5. Open the electrical enclosure (Main switch) on the rear side of the machine (figure 1) by loosening the screws.
6. Connect the three phases to terminals marked L1, L2, L3
7. Connect the green neutral wire to terminal ”PE”.
8. Connect the machine to power (or install

the fuses or reset the breakers at the power source).

9. Test the rotation of the cutter head. Turn on the main power switch (see Figure 2) and then the main motor switch (figure 4). The pulley on the main motor (on the side near the motor) should rotate clockwise. If it rotates counter clockwise, stop the machine with the red stop button (Figure 4).
10. Disconnect machine from power source, and exchange leaks L1 and L3
11. Reconnect power, and close the electrical cover

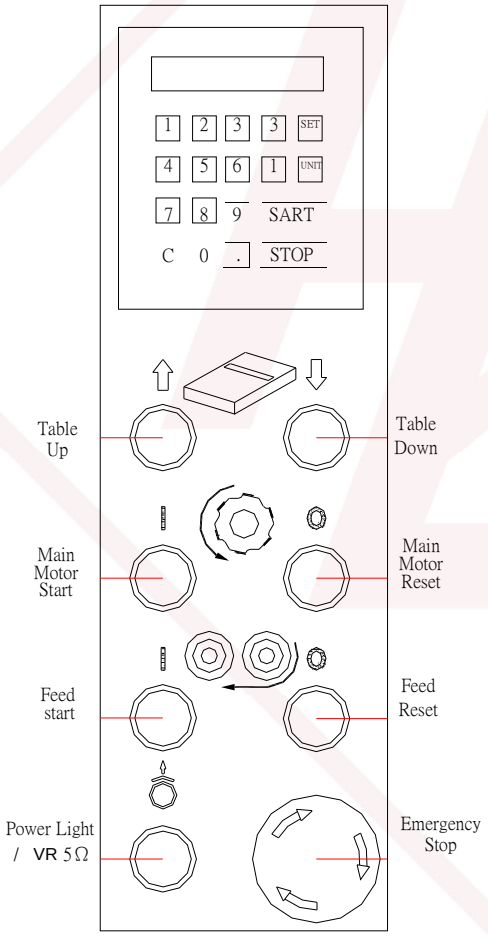


Figure 3

Adjustments and Controls

Figure 3 shows the control panel for the planer.

Starting procedure

Turn Main Switch to position “ | ”.〔NOTE: The main switch has a lock-out hole, through which a padlock or similar device can be inserted, when the switch is in :”O” position〕

Push the Main Motor Star button; the motor will start in Star-Delta. After a few seconds you will hear the motor switch over to full speed operation.

NOTE: The planer will not start if the hood is raised, or if the brake release is turn-on (see below). Fore’s or back’s E-stop is pressed or main switch is turn on.

The emergency button is on the planner. An automatic brake stops the motor within 8 seconds. A similar stop button can be found at the back of the machine. To restart the machine, simply twist the stop button and allow it to pop back up. To begin the feed motor. And rotate the handle to set the feed speed. Speed ranges from 6 to 18 m/min.

The Brake Release switch (Hood inside) frees the cutter head so that it can be moved by hand (e.g. when changing knives) while the hood is raised,. When the brake release is on, the switch stays turn on. As a safety feature, the planer’s motor will not start if the brake release switch is turn on. And if the switch turn on during operations, The motor will automatically stop. To restart the planer,

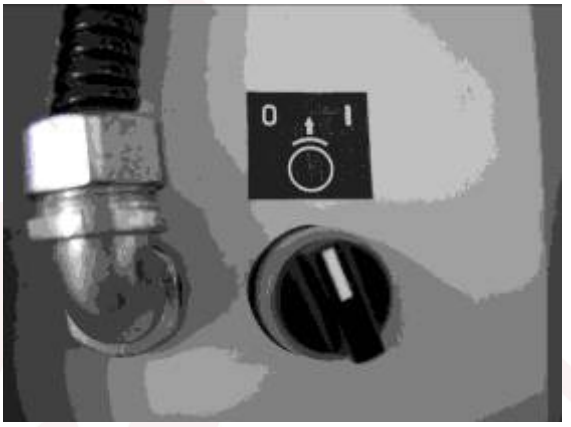


Figure 4

Raise the table

To raise the table press the up-arrow buttons or "-" on control.

To lower the table press the down-arrow buttons or "+" on control.

Figure 6

Automatic start of control unit

Before operating the planer, the digital display should be checked for accuracy and calibrated if necessary. Use a scrap board.

If the figure shown on this control unit is 100.0 and we need to increase it to 200.5

1. Press "SET" then the display will show 0. The "input" instruction light will come on after pressing "SET".
2. Press button "2", "0", "0", ".", "5", the display will show 200.5
3. Then press "START", the "RUN" instruction light will come on and the "INPUT" instruction light go out. And the table will start to move.
4. Press Button "START" again. This control unit starts to run and the figure on display changes back to 200.5 and start to increase.

WARNING

The thickness of this planner is 6-300mm, So don't to run out the range of 6-300mm. Do not move the table while there is any stock on table.

Correcting of control unit

Before operating the planer, the control unit should be check for accuracy and calibrated if necessary.

1. Flip the board over and feed it through the planer, then carefully measure its thickness with callipers. Compare this with the digital display.
2. If the display needs correcting, press "SET" The display will return to zero,
3. Key in "number of measure"
4. Then press "SET", for 2-3 second, The figure "number of measure" is shown on display. Now, the correcting existing date is completed.

Table parallelism:

For accurate planning, the table must be parallel with the cutterhead. Lack of parallelism results in a taper over the width of the workpiece. Use the knife gauge to ensure knives have the same protrusion along the length of the cutterhead. Maximum deviation allowed for good planning is 0.02mm. If deviation exceeds 0.02mm, see section on installing cutterhead knives or section on jointing and riding knives before levelling the table.

If knives are set correctly and the machine is still cutting at a taper, perform the following steps to check the parallelism of the table to the cutterhead

Disconnect the machine from the power source. Place a gauge block directly under the upper cutterhead. Raise the table with the hand wheel until the knife on the upper cutterhead just touches the gauge block.

Move the gauge block to the opposite end of the table and repeat the process. The distance from the table to the edge of the cutterhead should be the same.

Adjusting the table:

To raise or lower one side of the table, loosen the lockscrew that locks the threaded flange nut from rotation in the table on the side to be raised or lowered. Rotate the nut using a rod in the flange holes and adjust height of the side. Relock the flange nut lockscrew in the table. Another method that can be used if the table is free, is to loosen two sets 4 lockscrew on the high side of the table ***Figure 7*** and then rotate two column clockwise, the opposite side until it is level. Relock the flange nut lockscrew in the table.

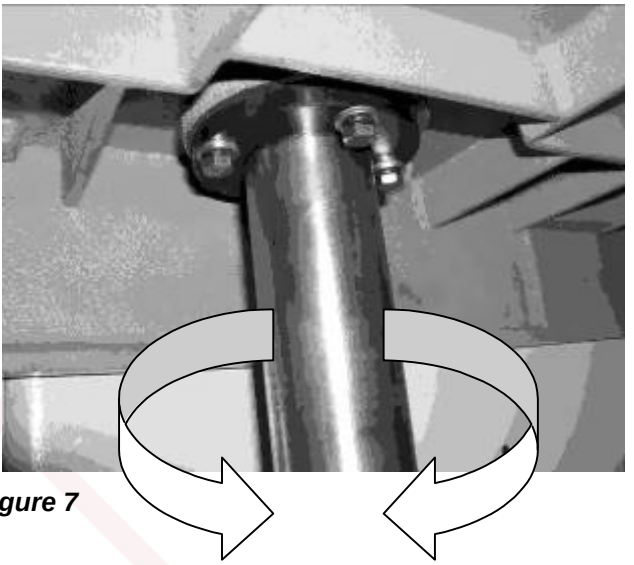
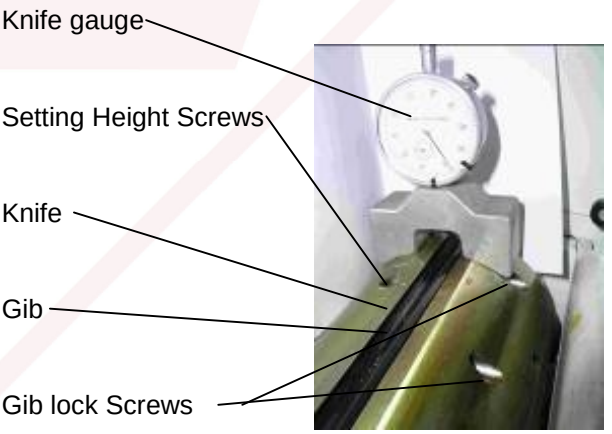


Figure 7

Changing Knives

Straight knife installation:

Knife installation on a planer can be a difficult and exacting process. If the knives are not to be jointed and ground, end-to-end and knife-to-knife relationship must be held within 0.03mm for accurate and smooth planning. To help avoid cutterhead distortion in changing out a set of knives, remove and replace the knife in one slot before change the next knife. The measure is 3.00mm between point of knife and cutterhead edge



Clean all dust, ~~chip, pitch and accum~~ulated foreign matter from a cutterhead slot and off of its gib. Working with one slot, With the knife and gib against each other and the beveled surface of the knife on the knife spring and the concave shaped surface of the gib up, insert into the slot. The back edge of the

knife bevel should be slightly below the outside diameter of the cutterhead

Press the knife with knife gage Lightly tighten two outside and center gib screws.

Repeat the preceding method on successive knives making sure that the height from knife to knife is the same within 0.03mm. Loosen gib screw to establish the high point of the knife. To touch the knife gage.

After all knife have been installed, recheck all gib screw to be sure they are tight, loose gib screws can result in knife being thrown out of the cutterhead causing severe damage to the machine and possible serious or fatal injury to the operator or bystanders.

Note: If all knives have been removed, a new set must be installed without locking the gibs until all knives and gibs are in and the gib screws lightly snuggled down. The locking process should precede working from the center out on each knife and locking all gib screw once, repeat the same sequence until all screws are equally tight. Locking one knife in without the others in position can cause cutterhead distortion.

Removal of knives:

1. Loosen all gib screws in one slot.
2. Remove both knife, gib.
3. Repeat step 1 & 2 for the remaining knives

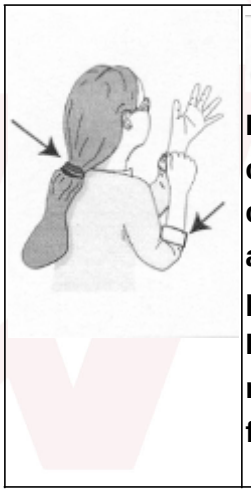
Helical cutterhead insert installation:

The planer has a helical cutterhead

Knife changing is simple, and the four-sided knives are self-seating once the cutterhead begins rotating.

TCT knives are available from your dealer or most woodworking supply stores.

1. Turn on the brake release button, and press the E-stop.
2. Pull out on the lever at the fore side of the machine, and raise the hood
3. Check cutterhead insert size 14 x 14 x 2.0mm and angle 30°
4. Clean cutterhead & insert, set the insert in position, lubricate the M6 x 1.0 screw
5. Use an air driver to adjust air pressure to 2kg/cm2 to pre–set the insert.
6. After the pre-setting of insert, adjust air driver pressure to 6kg/cm2 to tighten screws. The torque is 0.55-0.58 kgf-m.
7. Lower the hood and reconnect power to the machine. Turnoff the brake release button. And release the E-stop.
8. After adjusting or changing knifes. The control unit should be check and recalibrated if necessary.



⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury.

Keep loose clothing rolled up and away from machinery.

Dust Collection

It is strongly recommended this planer be connected to a dust extraction system, via the 5”(125mm) dust port at the rear of the planer. Your dust collector should have at least 1500 CFM capacity. And The required air flow speed at the end of flexible hose is 30-34m/sec.

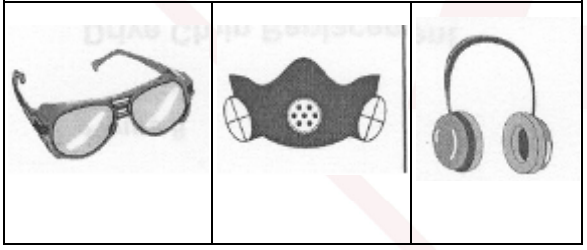
The dust extraction system shall be earthed.

⚠WARNING

After prolonged use of the planer, the cast iron frame and areas around the cutterhead may be hot.

⚠WARNING

Damage to your eyes, lungs and ears could result from failure to wears safety glasses, a respirator, and hearing protection while using this machine



Belt Tension & Replacement

1. Note Belts should be replaced as a matched set of four
2. Pull out on the lever at the fore side of the machine, and raise the hood
3. Loosen the three bolts (, Figure 8) which hold the motor support bracket to the frame.
4. Turn the hex nuts on the tension rod as needed.
5. When finished, tighten the three bolts closed the hood and turn off the brake release button

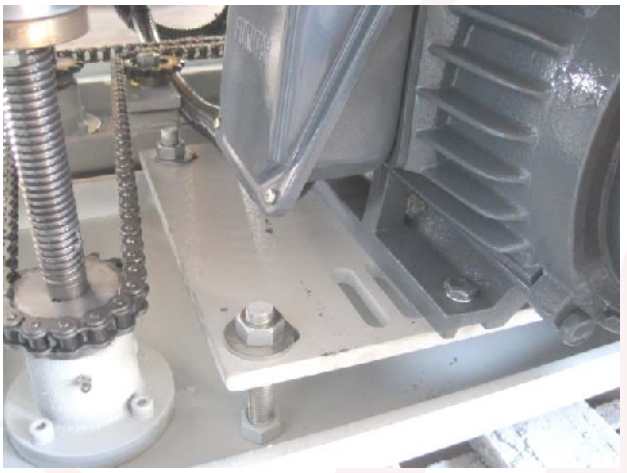


Figure 8

Drive Chain Replacement

The drive chains do not require tension adjustment, since tension is always assured by an idle chain tension.

To replace the main drive chain, pull the tensioner backward and remove the chain from around the sprockets. When the new chain has been mounted, always make sure the tensioner is well placed on the chain

To replace the chain for the table raising mechanism, pull the lever to the back and remove the chain. When the new chain has been mounted, push the lever) back into position.

WARNING

Do not turn the sprockets on the table raising screws with the chain removed. Doing so will misalign the table

Feed Rollers

The infeed and outfeed rollers and chipbreaker have been factory set. However, if spring tension adjustment should ever be necessary, use the appropriate adjustment assembly located beneath the lip of the frame – one is shown if figure 9.

1. Loosen the nut and turn the screw in or out
2. When finished, tighten nut.
3. Perform the same adjustment at the opposite end of the roller.

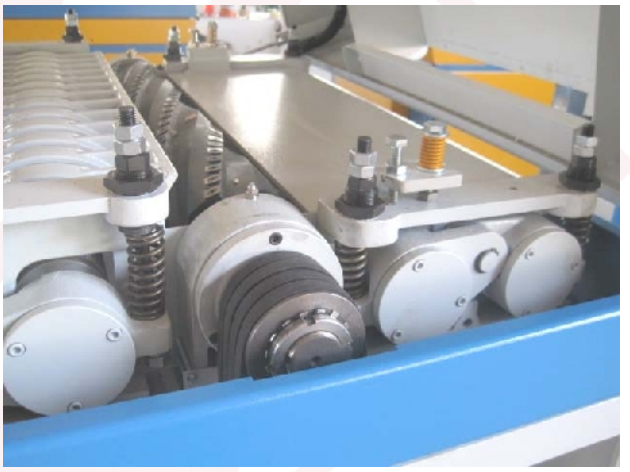


Figure 9

Changing Fuses

Disconnect planer from power source, and open the electrical enclosure. Pull open the cover on a fuse holder. As shown in figure10 and slide out the old fuse. Replace it with a new one of the proper amperage. Close the cover.

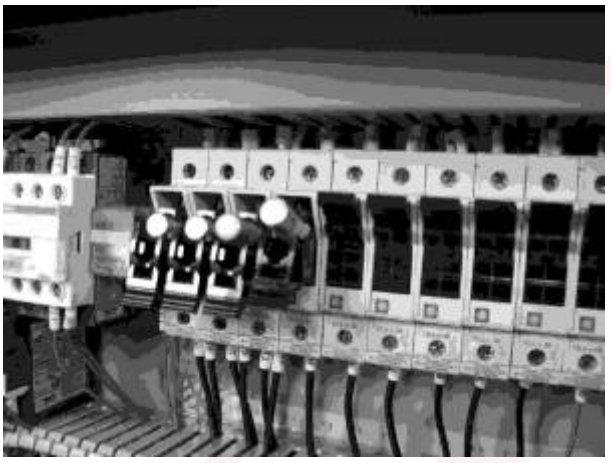


Figure 10

⚠WARNING

Do not use a fuse with amperage ration different than what is listed on the cover of the fuse holder

⚠WARNING

Before and intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Follow lockout procedures. Failure to comply may cause serious injury.

Maintenance

⚠WARNING

Before and intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Follow lock out / tag out procedures. Failure to comply may cause serious injury.

1. The anti-kickback fingers must hang down freely and operate independently by gravity. They should be inspected frequently and cleaned and concerning state of the tip and any destruction whenever necessary. If they have any destruction, shall be order our agent for new anti-kickback fingers.
2. The table should be kept clean and free of rust or deposits.
3. The lead screws and posts beneath the table and the drive chains, the columns should be kept clean and oiled
4. Periodically blow out sawdust from the motor's cooling fan.
5. Periodically check the brake of motor, Change new brake block then thickness of brake block is less 3mm.
6. The infeed roller and outfeed roller are mounted on sealed ball bearing and require no lubrication. The following lubrication chart indicates the lubrication points, frequency, and recommended lubrication.

Lubrication Point	Frequency	type
Cutterhead Housing	Weekly	High Speed grease
Table	Daily	SAE10
The lead screws	Weekly	SAE10
The lead screws housing	Monthly	High Speed grease
The columns housing	Monthly	High Speed grease

Troubleshooting: Operating Problems

Trouble	Probable cause	Remedy
Snipe(NOTE: Snipe can be minimized but not eliminated)	Table rollers not set properly.	Adjust rollers to proper height.
	Inadequate support of long boards.	Support long boards with extension rollers.
	Uneven feed roller pressure front to back.	Adjust feed roller tension.
	Dull knives.	Reverse or replace knives.
	Lumber not butted properly.	Butt end to end each piece of stock as they pass through
Fuzzy Grain	Planing wood with high moisture content	Remove moisture content from wood by drying, or choose other stock
	Dull knives.	Reverse or replace knives
Torn Grain	Too heavy a cut	Adjust proper depth of cut.
	Knives cutting against grain	Cut along the grain.
	Dull knives	Reverse or replace knives.
Rounded, Raised surface	Dull knives.	Reverse or replace knives.
	Too heavy a cut	Adjust proper depth of cut.
	Moisture content too high.	Remove moisture content from wood by drying, or choose other stock.
Rounded, glossy surface	Dull knives.	Reverse or replace knives.
	Feed speed too slow	Increase speed.
	Cutting depth too shallow	Increase depth.
Poor feeding of lumber	Inadequate feed roller pressure	Adjust feed roller tension. If proper tension cannot be achieved replace
	Planer bed rough or dirty.	Clean pitch and residue, and wax planer table.
	Transmission v-belt slipping.	Tighten transmission v-belt.
	Surface of feed rollers too smooth.	Lightly roughen the feed roller surface with sandpaper
	Bed rollers too low.	Raise bed rollers to proper depth for stock.

Troubleshooting: Mechanical & Electrical Problems

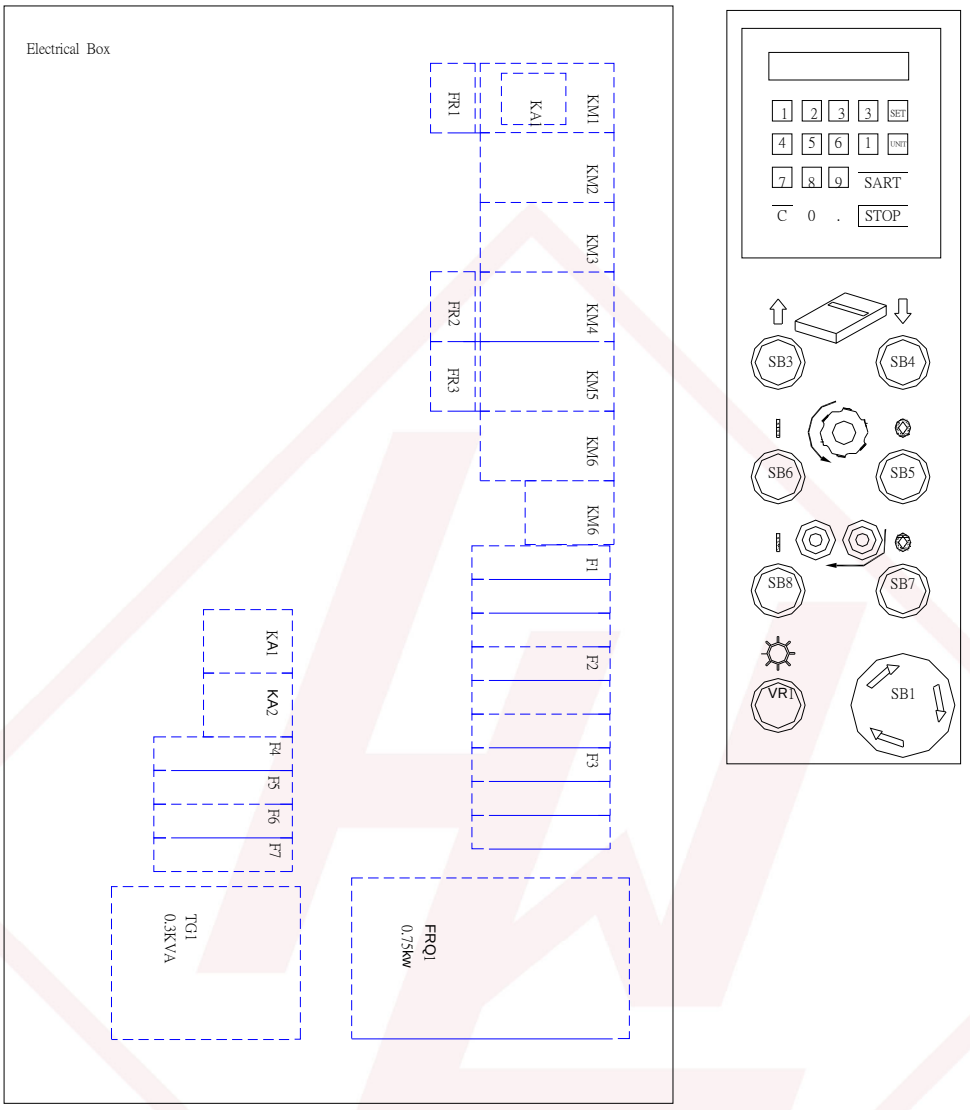
Trouble	Probable Cause	Remedy
Board thickness does not match digital display	Digital display not calibrated properly.	Follow calibration procedures
Chain jumping	Inadequate chain tension.	Adjust chain tension.
	Sprockets misaligned.	Align sprockets.
	Sprockets worn.	Replace sprockets.
	No incoming power.	Verify unit is connected to power, and main switch is set to " | ".
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses	Overload automatic reset has not reset.	When planer overloads on the circuit breaker built into the motor starter, it takes time for the machine to cool down before restart. Allow unit to adequately cool before attempting restart. If problem persists. Check amp setting on the motor starter inside the electrical enclosure.
		One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to take a lighter cut. If too deep a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is electrical lead. Check amp setting on motor starter.
	Building circuit breaker trips or fuse blows.	Verify that planer is on circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter
	Loose electrical connections.	Go through all the electrical connections on the planer including motor connections, verifying the tightmess of each. Look for any signs of electrical arcing which is a sure indicator of loose connections or circuit overload.
	Motor starter failure	Examine motor starter for burned or failed components. If damage is found, replace motor starter. If motor starter looks okay but is still suspect, you have two options: Have a qualified electrician test the motor starter for function, or purchase a new starter and establish if that was the problem on change out (continued)

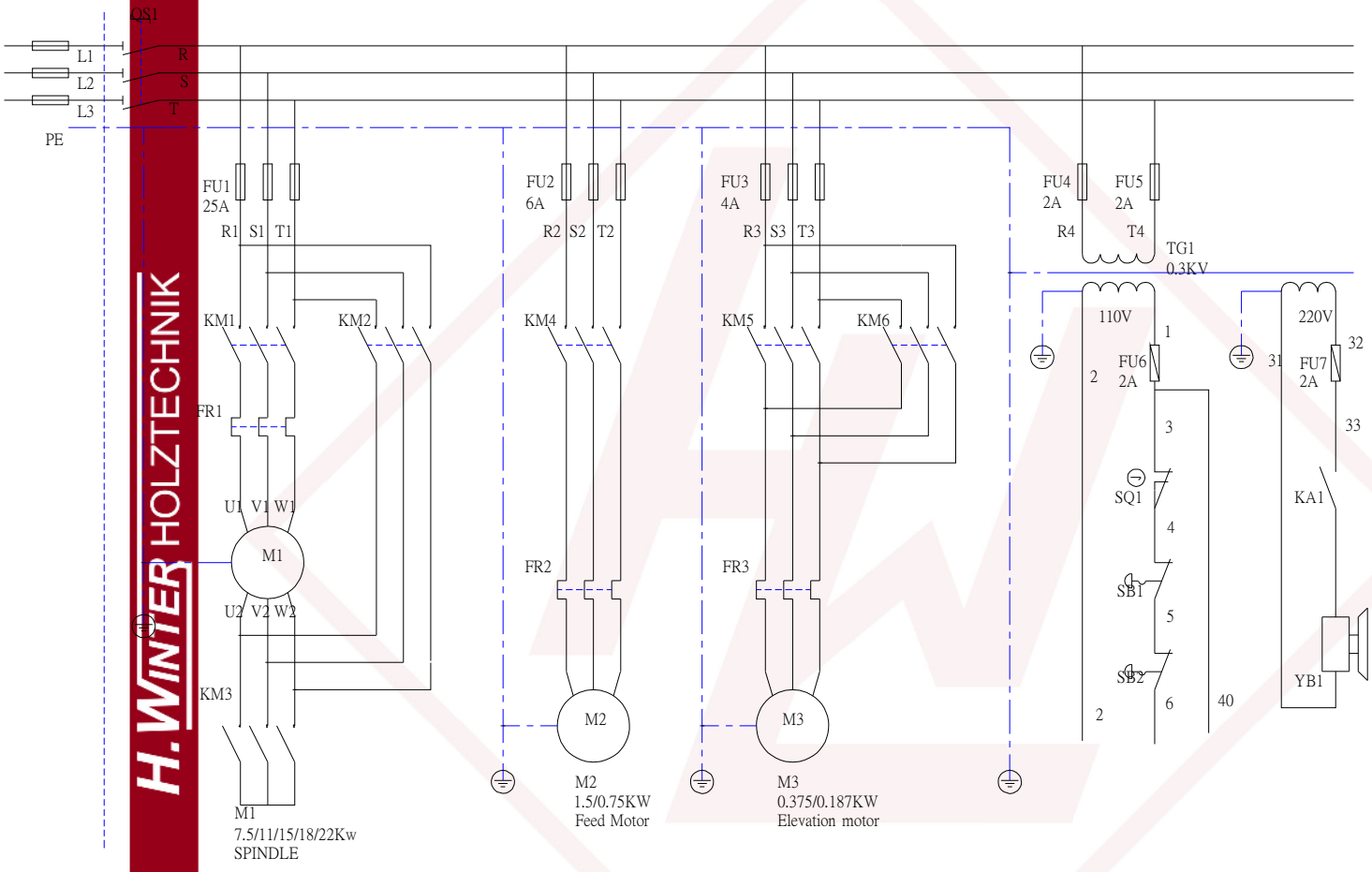
Electric Specification

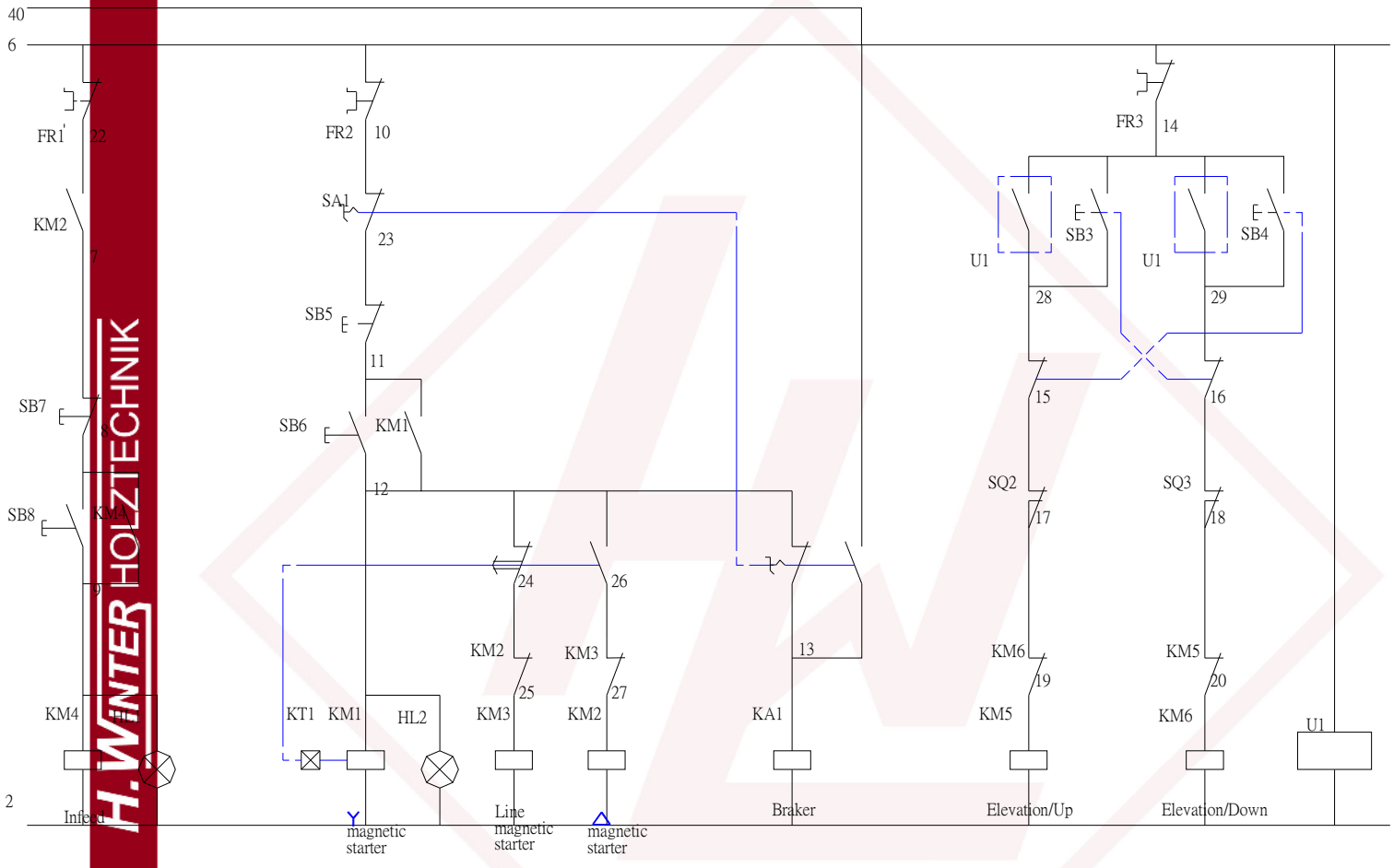
Mold			AN-926		AN-932	AN-940	AN-952
Spindle Motor	Power		7.5kw	11kw	15kw	18kw	22kw
	TR1	Range	16-24A	24-32A	25-40A	40-63A	40-63A
		Setting	16A	25A	32A	38A	50A
	Electric cable cross-section		2.0mm	3.5mm	5.5mm	5.5mm	8mm
Main electric cable cross-section			3.5mm	5.5mm	8mm	8mm	14mm
Feed Motor	Power		0.75Kw		1.5Kw	1.5Kw	1.5Kw
	TR2	Range	4-6.3A		6-10A	6-10A	6-10A
		Setting	4A		8A	8A	8A
	Electric cable cross-section		2.0mm		2.0mm	2.0mm	2.0mm
Elevation motor	Power		0.18Kw		0.375Kw	0.375Kw	0.375Kw
	TR3	Range	1.6-2.5A		2.5-4A	2.5-4A	2.5-4A
		Setting	1.6A		2.5A	2.5A	2.5A
	Electric cable cross-section		2.0mm		2.0mm	2.0mm	2.0mm
Inverter of Feed Motor	Model Nnverter		VFD-007M		VFD-015M	VFD-15M	VFD-015M
	VRQ-1		0.75kw		1.5Kw	1.5Kw	1.5Kw
	Electric cable cross-section		2.0mm		2.0mm	2.0mm	2.0mm

Electric part list

Yuan An Iron Works Co., Ltd.	SCHEDULE OF ELECTRICAL EQUIPMENT			Sheet No. 1	
TYPE: An-926					
Item Designation	Designation and Function	Technical data	Supplier	Suppliers Reference	Remarks
QS1	Disconnection switch	Ith= 16A Ue=Ui=690V	Moeller	T0-/E	EN60947-3
FU1	Fuse	25A/600V	TE	DF6-AB10	EN60269-1
FU2	Fuse	6A/600V	TE	DF6-AB10	EN60269-1
FU3	Fuse	4A/600V	TE	DF6-AB10	EN60269-1
FU4	Fuse	2A/600V	TE	DF6-AB10	EN60269-1
FU5	Fuse	2A/600V	TE	DF6-AB10	EN60269-1
FU6	Fuse	2A/600V	TE	DF6-AB10	EN60269-1
FU7	Fuse	2A/600V	TE	DF6-AB10	EN60269-1
SQ1	Safety interlock switch	2A/400V	TEN	AD-S11	EN60947-5-1
SQ2 /Q3	Limit Switch	5A /240V	Tend	TZ-8112	EN60947-5-1
TC1	Transformer	0.3KVA	Tai Chung	SP-TBSW	EN60742
M1	Motor	7.5KW/400Vac	FUKUTA		EN60034-1
M2	Motor	0.75kW/400Vac	FUKUTA		EN60034-1
M3	Motor	0.18kW/400Vac	FUKUTA		EN60034-1
SB1-SB7	Push button switch	3A 600V	AUSPIOIOUS	LXBGS22-1/0	EN60947-1
SA1	Selection switch	3A 600V	AUSPIOIOUS	CS22-1/C	EN60947-1
KM1-2	Contactor	7.5kW/440V	TE	LC1-D126	EN60947-3
KM3-6	Contactor	4kW/440V	TE	LC1-D096	EN60947-3
KA1 KA2	Relay	250V 10A 2a2b	idec	RM2S-U220V	IEC60255-1 IEC60255-23
KT1	Timer	0~30 sec.	TE	LADS2	IEC947-4-1
FR1	Overload Relay	16-24A/18A	TE	LR3D-226	IEC947-4-1
FR2	Overload Relay	4-6A/4A	TE	LR3D-106	IEC947-4-1
FR3	Overload Relay	1.6-2.5A/1.6A	TE	LR3D-076	IEC947-4-1
YB1	Brake	13W/220V	SANLI ELE LTD.	Join-230V	
U1	CONTROL UNIT		RICH	DP-626	
VR1	Variable Resistor	5Ω			
FRQ1	Inverter	0.75kw	Delta	VFD-007M	EN50178


Electrical Box
FR1
KA1
KM1
KM2
KM3
FR2
KM4
FR3
KM5
KM6
KM6
F1
F2
F3
KA1
KA2
F4
F5
F6
F7
TG1
0.3KVA
FRQ1
0.75kw
1 2 3 3 SET
4 5 6 1 UNIT
7 8 9 SART
C 0 . STOP
SB3
SB4
SB6
SB5
SB8
SB7
VR1
SB1


QS1
L1
L2
L3
PE
R
S
T
FU1
25A
R1 S1 T1
KM1
KM2
FR1
U1 V1 W1
M1
U2 V2 W2
KM3
M1
7.5/11/15/18/22Kw
SPINDLE
FU2
6A
R2 S2 T2
KM4
FR2
M2
M2
1.5/0.75KW
Feed Motor
FU3
4A
R3 S3 T3
KM5
KM6
FR3
M3
M3
0.375/0.187KW
Elevation motor
FU4
2A
FU5
2A
R4
T4
TG1
0.3KV
110V
1
2
FU6
2A
3
SQ1
4
SB1
5
SB2
6
2
40
220V
31
32
FU7
2A
33
KA1
YB1



H.WINTER HOLZTECHNIK

Part List

No.	Description	Qty
1.	Base	1
2.	Side cove	2
3.	Middle cover	1
4.	Hood Raising Lift	1
5.	Dust Hood Assembly	1
6.		
7.	Anti-Kickback Finger	
8.	Anti-Kickback Finger Spacer	
9.	Anti-Kickback Finger Axle	1
10.	Hex Cap Screw M8*20	2
11.	Pointer	1
12.	Handle	1
13.	Hex Cap Screw M6*12	20
14.	Fore cover	1
15.	Panel Scale	1
16.	Hex Cap Screw M6*12	8
17.	Side strip	2
18.	Table	1
19.	Table column	4
20.	Table column ring	4
21.	Hex Cap Screw M8*30	16
22.		
23.	Hex Cap Screw M10*30	16
24	Table column Supper	4
25.	Table Raising Screw	4
26.	Table Raising Nut	4

No.	Description	Qty
27.	Hex Cap Screw M8*25	16
28.	Table Raising Sprocket	4
29.	Bearing 6204	4
30.	Hex Cap Screw M8*25	16
31.	Bearing house	4
32.	Nut M16	8
33	Key 6*6*20	4
34.	Raising chain	
35.	Raising Reducer	1
36.	Raising Motor	1
37.	Raising Reducer Sprocket	1
38.	Hex Cap Screw M6*12 & Nut	8
41.	Thirst Bearing 2904	8
51.	Feed Handle	1
52.	Feed Handle Axle	1
53.	Reducer Belt 1224V300	1
54.	Reducer wheel	1
55.	Reducer Plank	1
56.	Feed Motor	1
57.	Feed Reducer	1
58.	Feed Reducer Wheel	1
59.	Feed Reducer Sprocket	1
61.	Hex Cap Screw M8*30	3
62.	Flat Washer	2
63.	Outfeed sprocket	1
64.	Sprocket ring	2

No.	Description	Qty
65.	Retaining ring R52	4
66.	Bearing 6205	4
67.	Outfeed house LH	2
68.	Outfeed Frame LH	1
69.	Outfeed Spring	4
70.	Spring Screw	6
71.	Spring Nut	6
72.	Press Bar	1
73.	Outfeed houst RH	2
74.	Retaining ring S20	4
75.	Outfeed Axle	1
76.	Nut M10	2
77.	Press bar spring	2
78.	Washer	2
79.	Hex Cap Screw M10*80	2
80.	Outfeed Roller	2
81.	Outfeed Frame RH	1
82.	Retaining ring	2
83.	Cutterhead Pulley	1
84.	House Cover RH	1
85.	Bearing 6205	2
86.	Bearing house RH	1
87.	Knife	4
88.	Knife Jib	4
89.	Knife Set Screw	24
90.	cutterhead	1

No.	Description	Qty
91.	Bearing house LH	1
92.	Bearing Cover	1
93.	Bearing Nut	1
94.	Retaining ring S30	2
95.	Retaining ring R62	2
96.	Bearing 6206	2
97.	Bearing House	1
98.	Infeed Frame RH	1
99.	Hex Cap Screw M10*35	12
100.	Hex Cap Screw M8*35 and nut	13
101.	Chipbreaker Frame	1
102.	Ring	2
103	Chipbreaker	13
104.	Plank	1
105.	Chipbreaker Axle	1
106.	Outfeed sprocket	1
107.	Infeed Frame LH	1
108.	Bearing House	1
109.	Ring	1
110.	Infeed sprocket	1
111.	Washer	1
112.	Hex Cap Screw M10*70 & Nut	6
113.	Plank	1
114.	Ring	1
115.	Hex Cap Screw M10*35	1
116.	Infeed Spring	1

117.	**Sprocket Axle**	1
118.	**Sprocket**	1
119.	**Bearing 6203**	1
120.	**Nut M8**	1
121.	**Spring**	1
122.	**Hex Cap Screw M8*25 and Nut**	1
123.	**Hex Cap Screw M8*45and Nut**	1
124.	**Hex Cap Screw M10*30**	1
125.	**Washer**	1
126.	**Ring**	1
127.	**Motor Pulley**	1
128.	**Motor**	1
129.	**Motor shelf**	1

APPENDIX - INVERTER (with inverter machines only)

A frequency inverter is built in inverter machines to provide variablespeed control for feed roller. The preferable range of frequency andFeed speed are showed as the following table.

Planning material	Frequency(Hz)	Feed speed(m/min)
Hard wood	20-60	6-10
Soft wood	60-80	10-18

DATA SETTING

Change the data of “DATA PROTECTION P76” to “0” before startingany other change.

1 Press the MODE key, Then ▼ or ▲ to seek the P76 Parameter.

2.Press the ENTER key, the monitor will show the data of 01.

3 Press “▼” or ”▲” the digital monitor will show “00”

4. then Press ENTER Key.

5.Set the data of P76 to “01” after all other setting hasaccomplished.

FUNCTION TABLE

Parameter		Date preset	Remark
No.	Name		
P76	Parameter lock and configuration	01	Change inhibited
P00	Source Frequency command	01	
P01	Source of operation command	01	
P02	Stop method	00	Ramp stop
P03	Max. frequency	80Hz	
P04	Base frequency	50Hz	According to the local frequency
P05	Max. output voltage	380V	
P10	Acceleration time	2 sec	
P11	Deceleration time	2 sec	
P36	Frequency limit (high)	80HZ	
P37	Frequency limit (low)	20HZ	