RECORD MACHINE DETAILS	DISTRIBUTOR
MODEL	
SERIAL No.	
DATE of PURCHASE	
VOLTAGE	
PHASE	
CYCLES	
QUOTE THIS INFORMATION WHEN REQUESTING SERVICE OR SPARES.	

Flatness specification:- 0.010" per foot.

STARTRITE

Model PT260

PLANER & THICKNESSER

HANDBOOK

29 E

A.L.T. SAWS & SPARES LTD

QUALITY
HSS PLANER KNIVES

TO SUIT THE PT260 MODEL

ORDER LINE- 01634 850833

A.L.T. SAWS & SPARES LTD

Unit 15, Pier Road Industrial Estate

Gillingham

Kent

ME7 1RZ

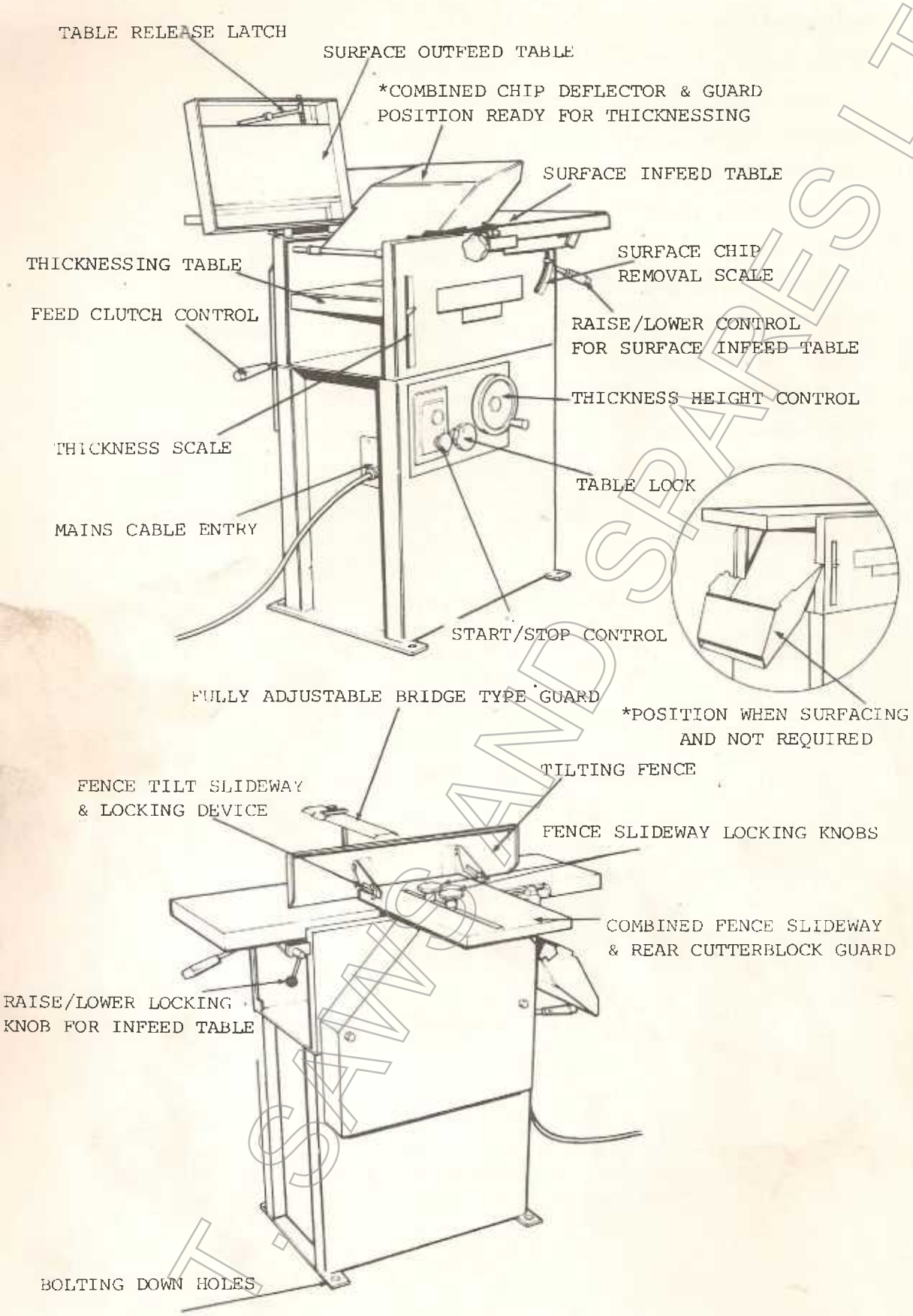
www.altsawsandspares.com

CONTENTS

SPECIFICATION

Model PT260	-Planer/Thicknesser	
Surface Capacity	-260 mm,	10¼"
Combined Table Length	-1000 mm,	39⅜"
Infeed Table Width	-345 mm,	13½"
Outfeed Table Width	-265 mm,	10⅜"
Rebate Depth	-15 mm,	9/16"
Cutterblock Diameter	-70 mm,	2¾"
Cutterblock Speed	-6000 r.p.m.	
Number of cutters	-2	
Thicknessing Depth	-180 mm,	7"
Thicknessing Width	-260 mm,	10¼"
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,	39⅜"
Width.	-600 mm,	23⅝"
Height.	-990 mm,	39"
Weight.	-120kg.	265 lbs.

ALL DIMENSIONS ARE APPROXIMATE.



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.

INSTALATION

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 avialable 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.

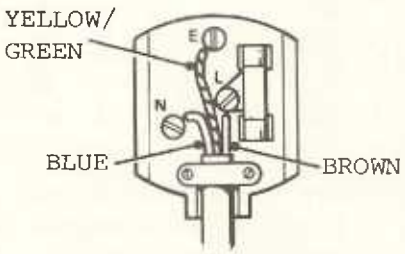


Fig.1

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

Recommended cable size: 1.5 mm^2
Fuse rating: 13 amp.

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

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.

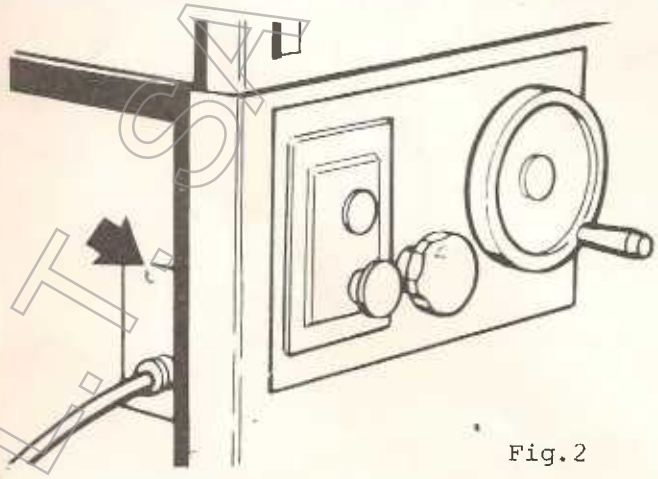


Fig.2

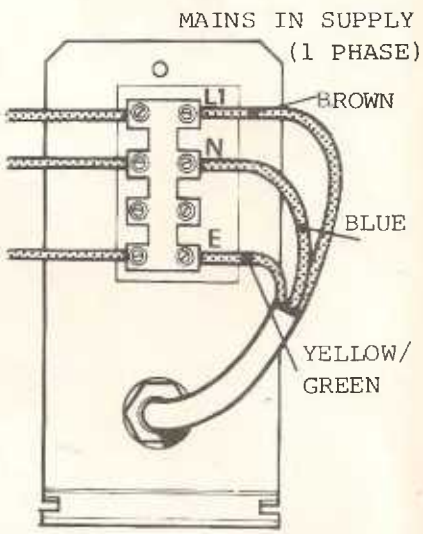


Fig.3

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.

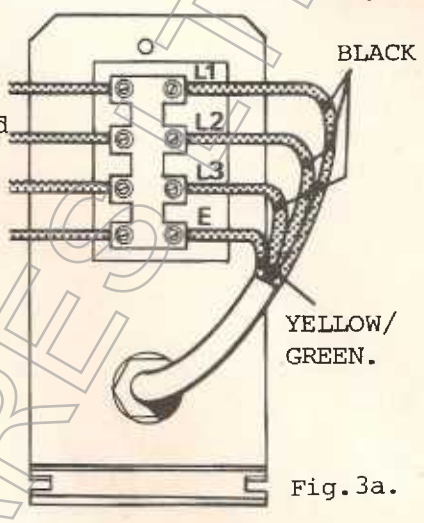


Fig.3a.

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.

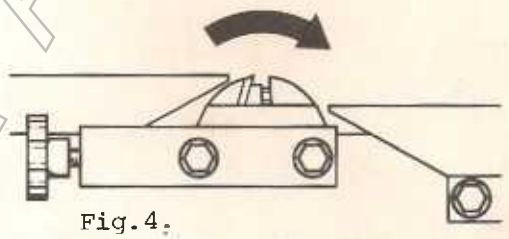


Fig.4.

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

Both single and three phase motors are protected by the contacter which incorporates an overload release. Should overload take place during operation due to work load or feed being too heavy for the motor to accomodate,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.

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)

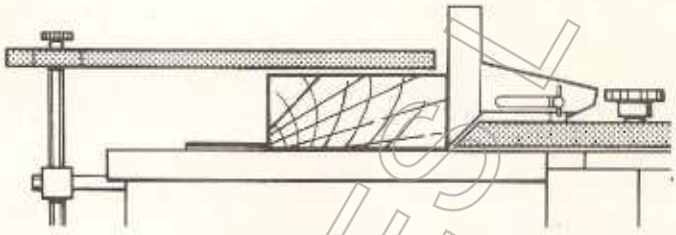


Fig.5.

EDGING:

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

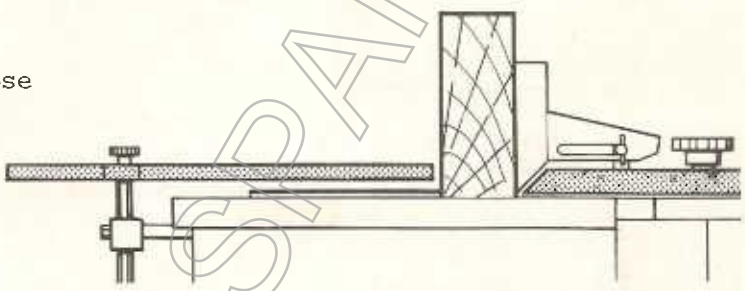


Fig.6.

BEVELLING:

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

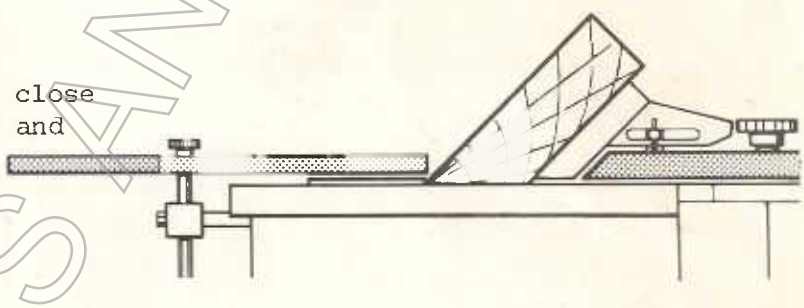


Fig.7.

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.

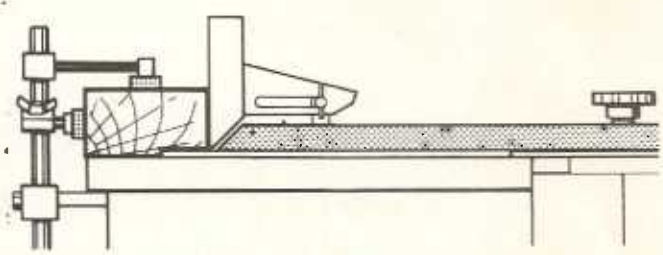


Fig.8.

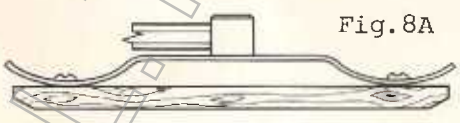


Fig.8A

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.

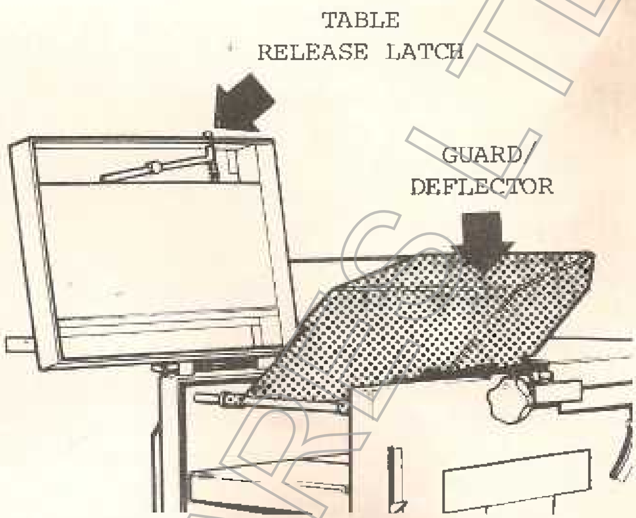


Fig.9:Final operational position.

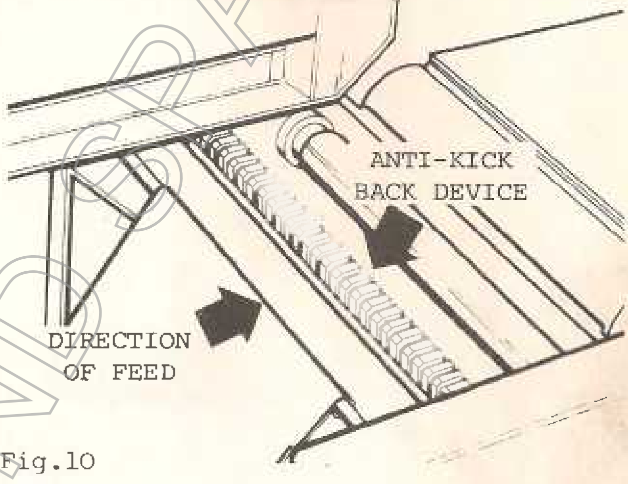


Fig.10

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 automaticaly 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.

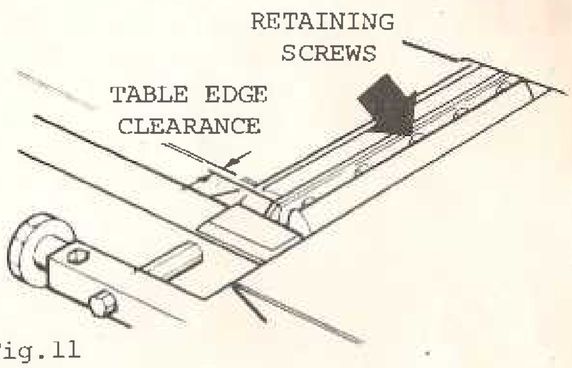


Fig.11

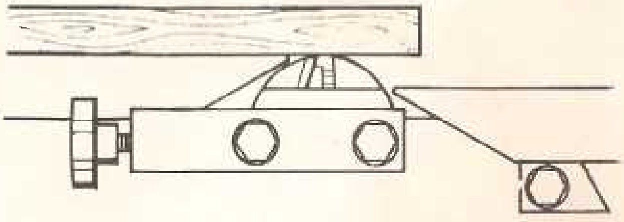


Fig.12

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 abainst 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)

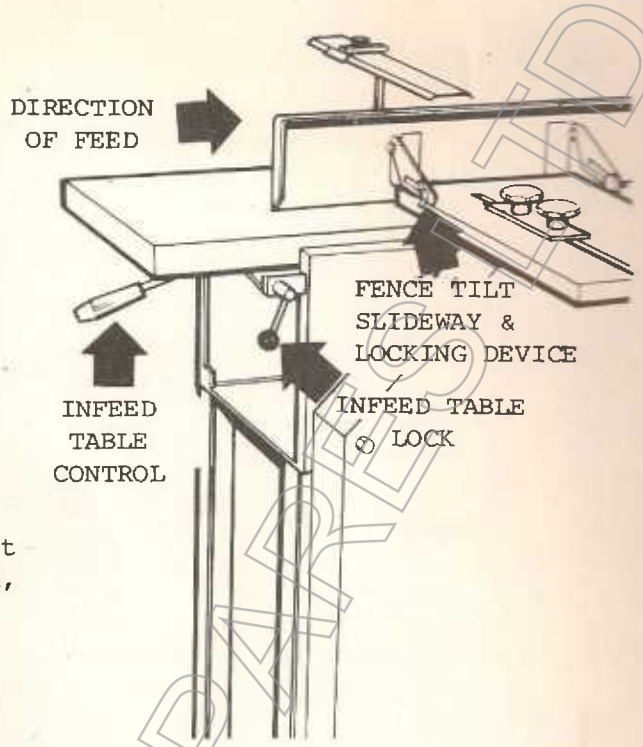


Fig.13.

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 accomodate.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.

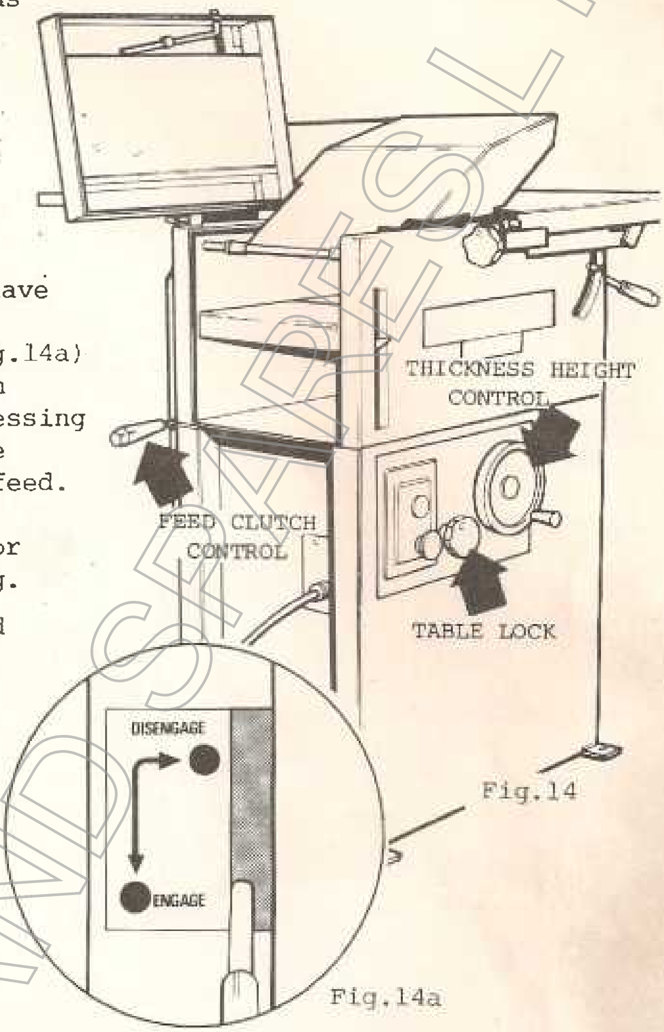


Fig.14

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).

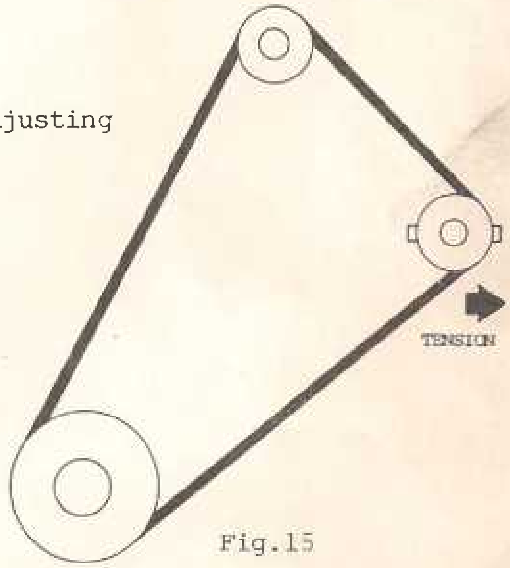
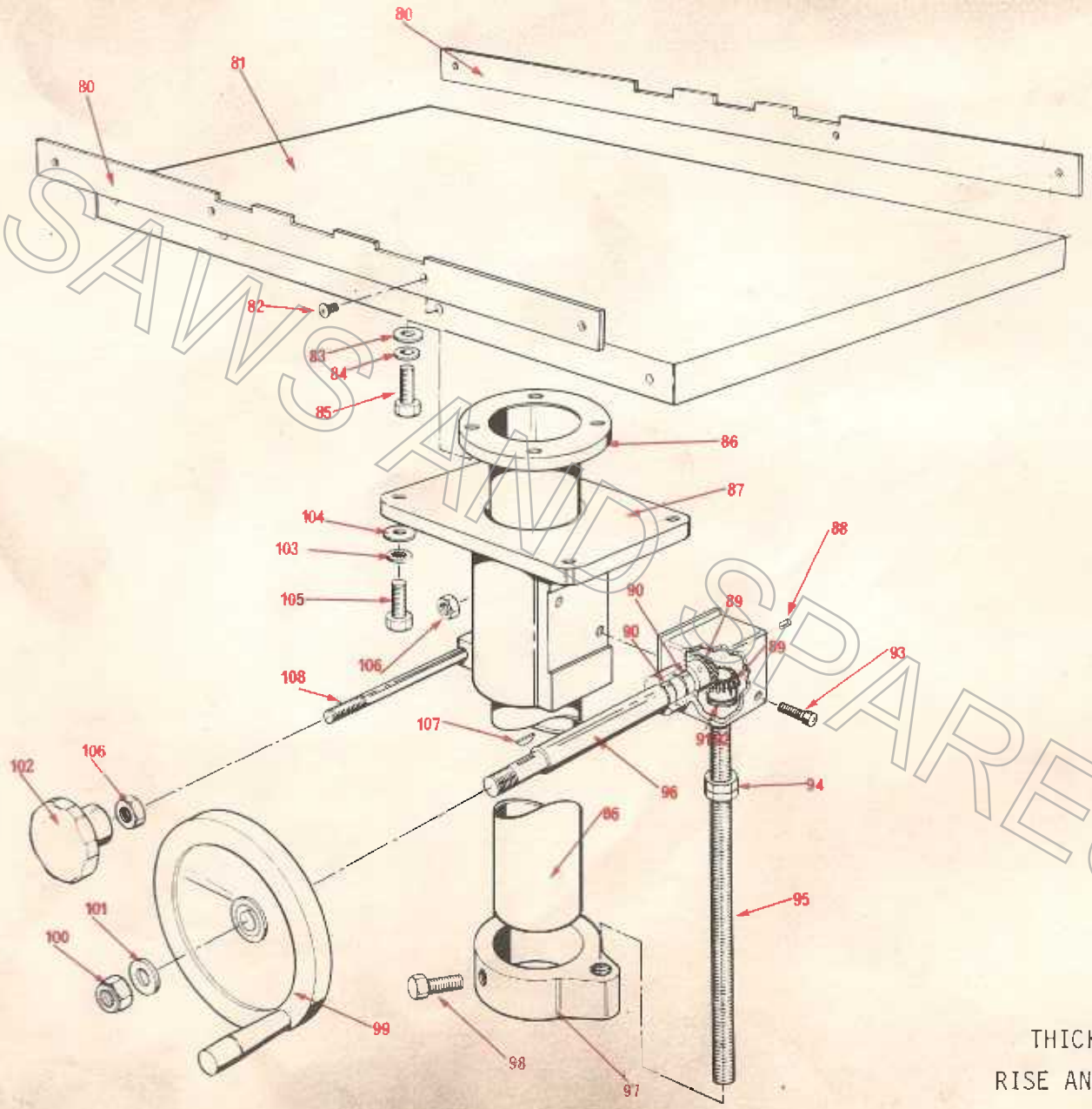


Fig.15

THICKNESSING TABLE/RISE AND FALL ASSEMBLY.

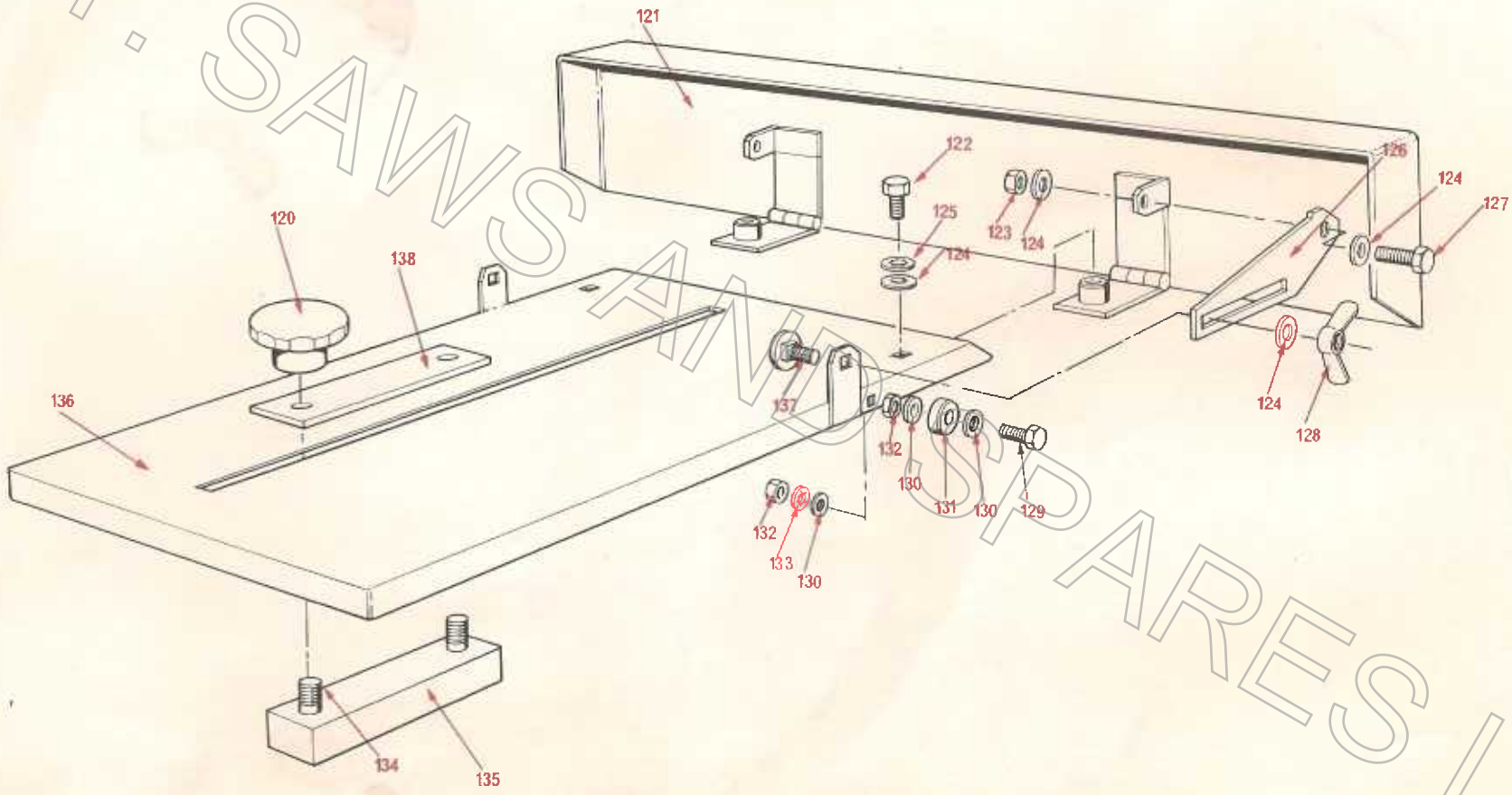
ITEM	PART NUMBER	AND DESCRIPTION	No. OFF
80	M6865	Thicknessing Table Side Plates	2
81	SM1943	Thicknessing Table	1
82		Soc Csn/k. Scw.	8
83		Plain Washer	4
84		Shakeproof Washer	4
85		Hex.Hd.Scw	4
86	SM1454	Table Column	1
87	M6887	Column Casting	1
88		Sel-lok Pin,	2
89	2715	Mitre Gear (plain)	2
90		Compo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



THICKNESSING TABLE/
RISE AND FALL ASSEMBLY

FENCE ASSEMBLY.

ITEM	PART NUMBER	AND DESCRIPTION	No. OFF
120		Black Hand Knob	2
121	SM1497	Fence	1
122		Hex. Hd. Screw	2
123		Self-locking Nut	2
124		Plain Washer	8
125		Shakeproof Washer	2
126	M6843	Fence Pivot Link	2
127		Hex.Hd.Screw	2
128		Wing Nut	2
129		Hex.Hd.Screw	2
130		Plain Washer	6
131	M6818	Roller	2
132		Full Nut	4
133		Shakeproof Washer	2
134	M6873	Stud	2
135	M6872	Clamp Block	1
136	SM1498	Fence Carrier/Guard	1
137		Coach Bolt	2
138	M7309	Clamp Plate	1



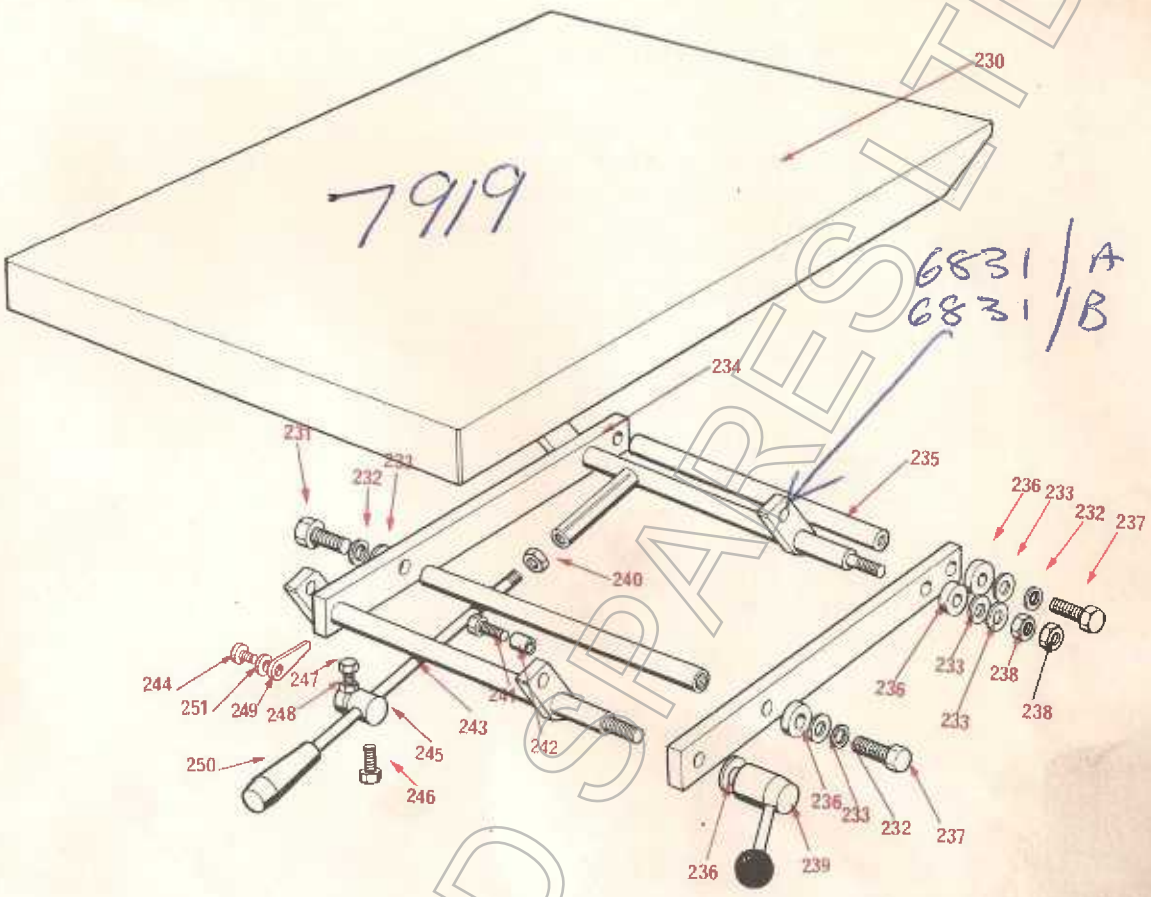
FENCE ASSEMBLY

INFEED TABLE ASSEMBLY.

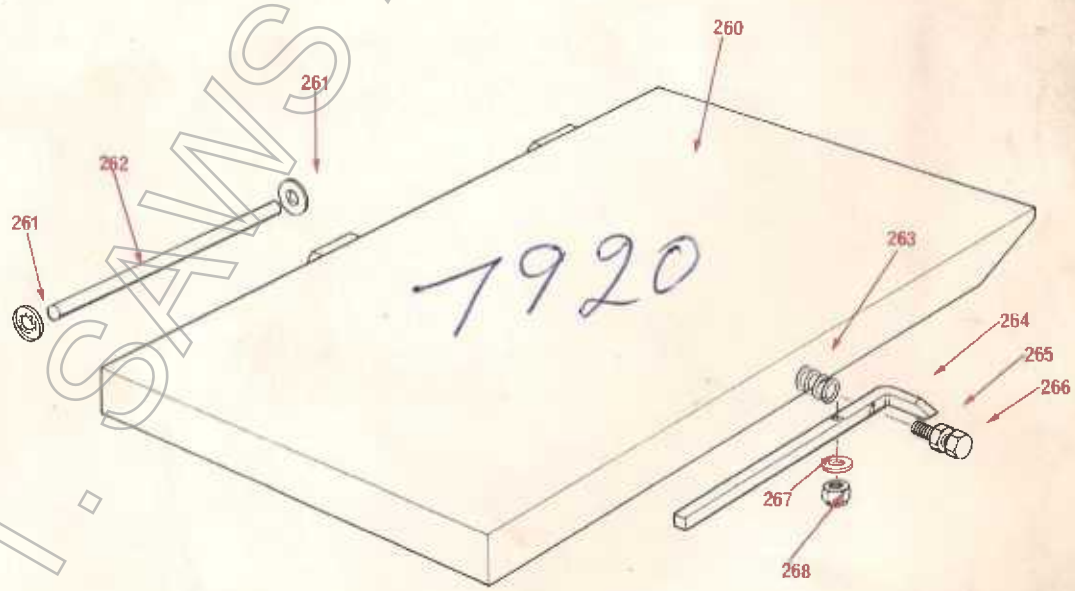
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
230	SM1488	Infeed Table	1
231		Hex.Hd.Screw	2
232		Shakeproof Washer	4
233		Plain Washer Form'A'	6
234	SM1446	Table Pivot	1
235	M6834	Torsion Bar	2
236	M6847	Spacer	3
237		Hex,Hd.Screw	2
238		Hex.Full Nut	2
239	SM1261	Handle	1
240		Locknut	1
241		Hex Hd Screw	4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

FEED OFF TABLE ASSEMBLY.

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



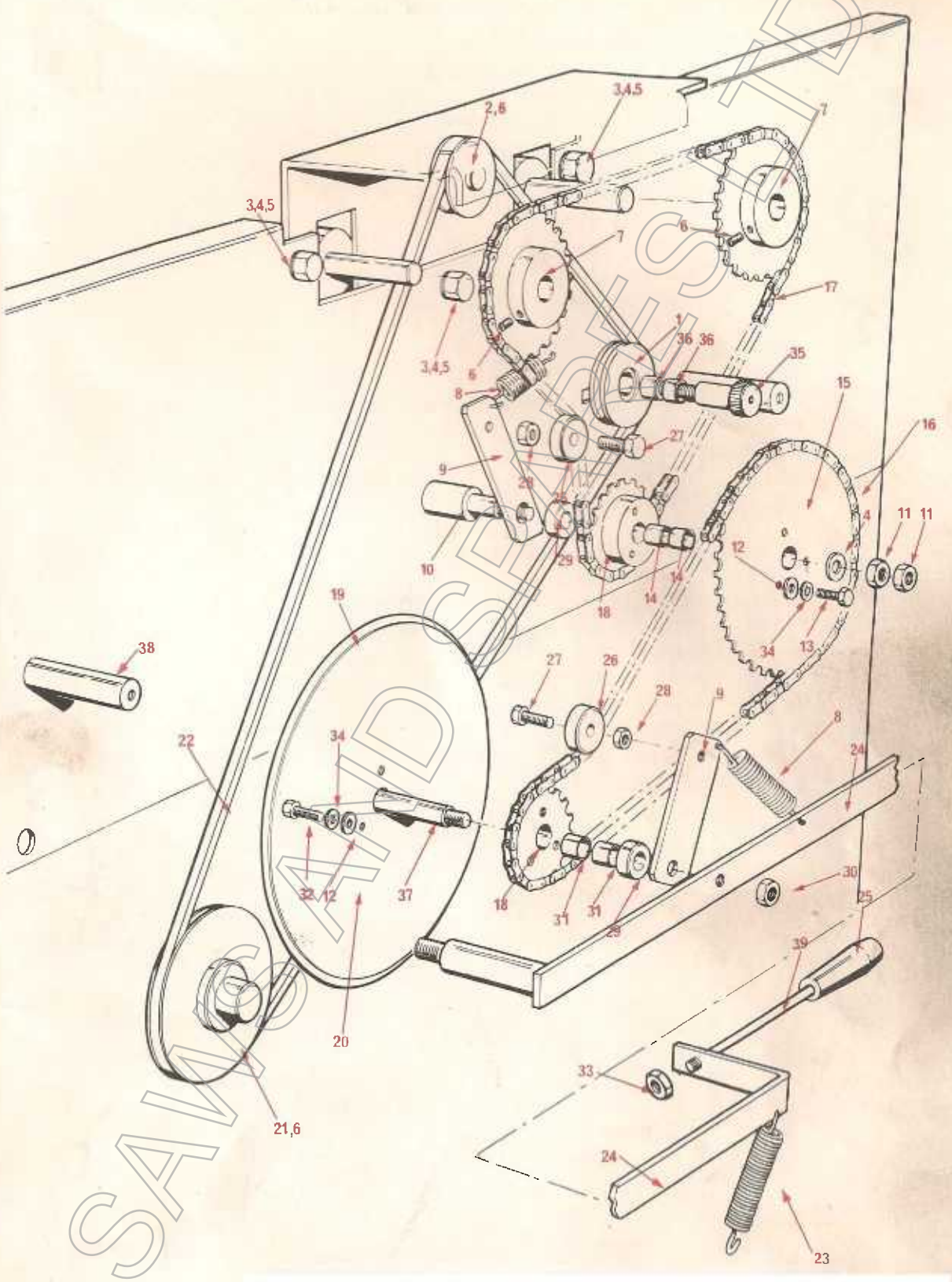
INFEED TABLE ASSEMBLY



FEED OFF TABLE ASSEMBLY

DRIVE ASSEMBLY

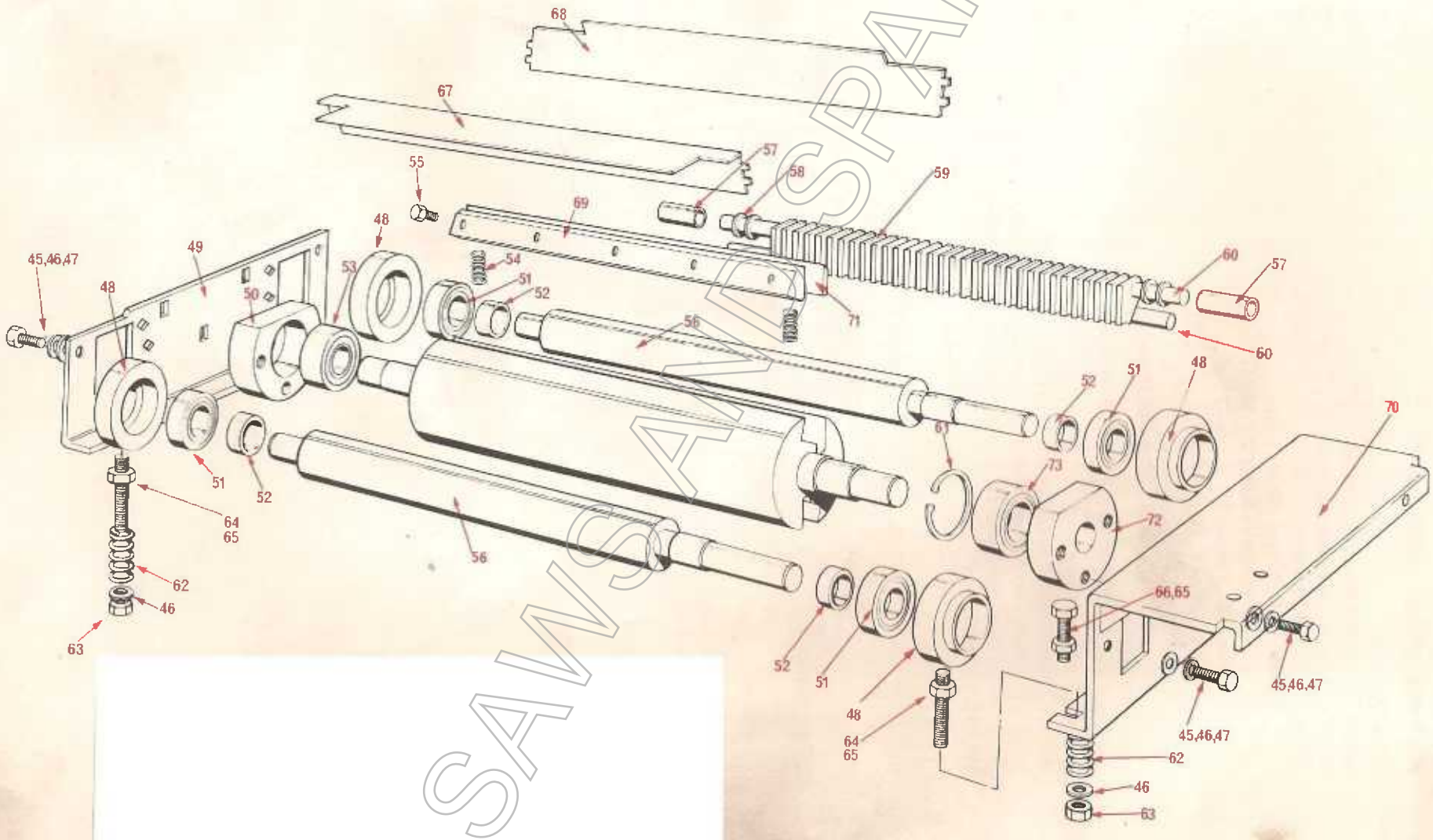
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
1	SM1494	Idler Pulley	1
2	M6814	Cutterblock Pulley	1
3		Hex.Hd.Screw	3
4		Plain Washer	6
5		Shakeproof Washer	3
6		Soc. Set. Screw	8
7	M6830	Sprocket (34T)	2
8		Extension Spring	2
9	M6817	Tension Bar	2
10	M6810	Spindle	1
11		Locknut	2
12		Plain Washer Form'A'	6
13		Hex.Hd.Screw	3
14		Compo Bush	2
15	M6828	Platewheel (57T)	1
16		Chain 1N'Simple	1
17		Chain 1N'Simple	1
18	M6829	Sprocket	2
19		'O' Ring	1
20	M6827	Feed drive Roller	1
21	M6815	Motor Pulley	1
22		Vee Belt	1
23		Extension Spring	1
24	SM1452	Feed Support	1
25		Handle	1
26	M6818	Tension Roller	2
27		Hex.Hd.Screw	2
28		Full Nut	2
29	M6874	Spacer	2
30		Locknut	1
31		Compo Bush	2
32		Hex.Hd.Screw	3
33		M10 Locknut	1
34		Shakeproof Washer	6
35		Shoulder Screw	1
36		Compo Bush	2
37		Shoulder Screw	1
38	M6848	Guard Cover Pillar	2
39	M6811	Feed Engage Bar	1



DRIVE ASSEMBLY

CUTTERBLOCK ASSEMBLY & ANTI KICK BACK DEVICE.-ASSEMBLY No SM1449

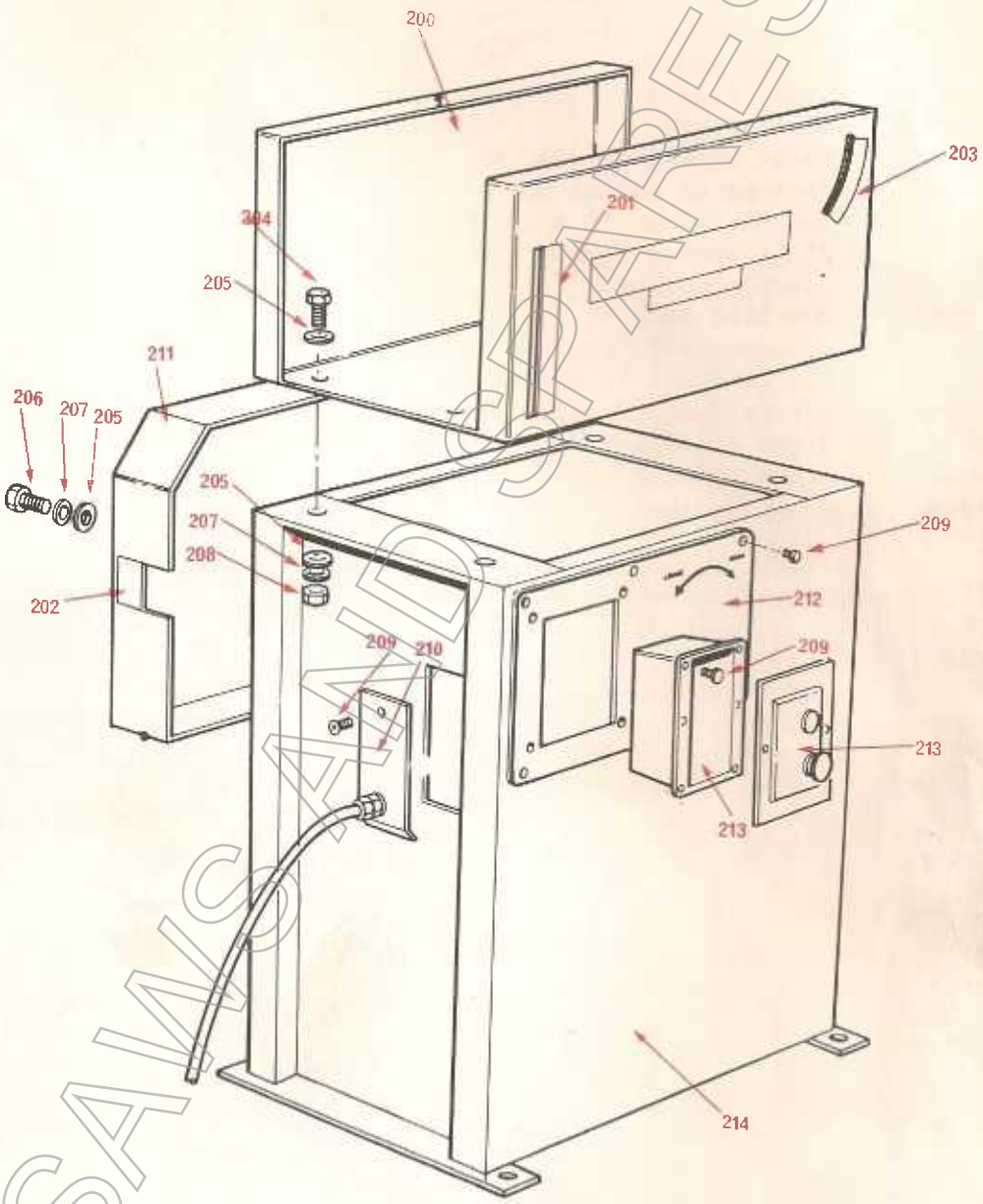
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
45		Hex.Hd.Screw	4
46		Washer	12
47		Shakeproof Washer	4
48	M6805	Bearing Housing(Roller)	4
49	M6977	Roller Guide Bracket	1
50	M6802	Bearing Housing (Front)	1
51		Bearing	4
52	M6806	Spacer (Roller)	4
53		Bearing	1
54		Compression Spring.	4
55	M6813	Jacking Screw	10
56	M6807	Feed Roller	2
57	M6841	Spacer	2
58	M6821	Spacing Washer(Anti kick back)	32
59	M6826	Anti Kickback	29
60	M6804	Anti kickback bar	2
61		Internal Circlip	1
62		Compression Spring	4
63		Self-Locking Nut	4
64	M6969	Feed Roller Studding	4
65		Locknut	6
66		Hex.Hd.Screw	2
67	M6980	Chip Deflector (Planing)	1
68	M6779	Chip Deflector (Thicknessing)	1
69	M6889	Wedge Piece	2
70	M6978	Roller Guide & Fence Bracket	1
71		Blade 3 :	2
72	M6803	Bearing Housing (Rear)	1
73		Bearing	1



CUTTERBLOCK ASSEMBLY & ANTI KICK-BACK DEVICE -ASSEMBLY No SM1449

BODY & STAND ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	No.OFF
200	SM1448	Body	1
201	M6869	Thicknessing Scale	1
202	M6850	Drive Engage Legend	1
203	M6870	Infeed Scale	1
204		Hex.Hd.Screw	4
205		Plain Washer	10
206		Hex.Hd.Screw	2
207		Shakeproof Washer	6
208		Hex Nut	4
209		Self Tapping Screw	11
210	SM1489 SM1490	1PH 3PH } Electrical Panel Assembly	1
211	M6996	Drive Cover	1
212	M6871	Control Panel Legend Plate	1
213		Flush Mounted Starter Switch	1
		Flush Mounted Starter Switch	1
214	SM1492	Stand	1



BODY & STAND ASSEMBLY

SAFETY HOLDING DEVICE - ASSEMBLY No SM1456

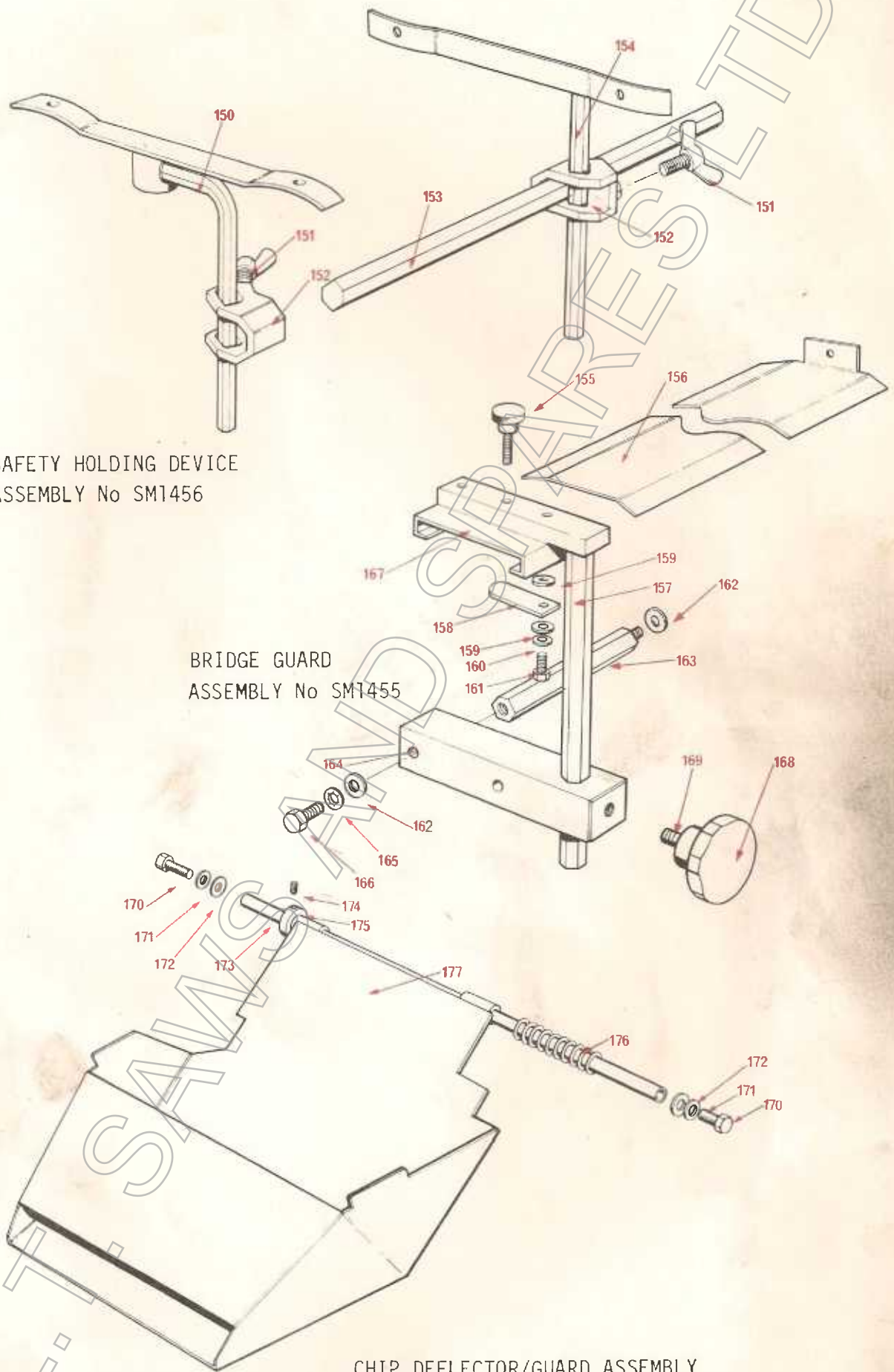
ITEM	PART NUMBER AND DESCRIPTION		No.OFF
150	SM1486	Hold Down Bar (Short)	1
151		Wing Nut	2
152		Knuckle Casting	2
153	M6882	Hold Down Pillar	1
154	SM1487	Hold Down Bar(Long)	1

BRIDGE GUARD-ASSEMBLY SM1455

155	M6967	Thumb Screw	1
156	M6983	Bridge Guard	1
157	SM1500	Guard Pillar	1
158	M6968	Scuff Plate	1
159		Plain Washer	3
160		Shakeproof Washer	2
161		Hex.Hd.Screw.	2
162		Plain Washer	4
163	M6881	Hexagon Spacer	2
164	M6879	Mounting Block	1
165		Shakeproof Washer	2
166		Hex Hd Screw	2
167	M6984	Bridge Guard Mounting Bracket	1
168		Black Hand Knob	1
169	M6545	Studding	1

CHIP DEFLECTOR/GUARD ASSEMBLY.

170		Hex.Hd.Screw	2
171		Shakeproof Washer	2
172		Plain Washer	2
173	M6809	Guard Pivot	1
174		Soc.Set.Screw.	1
175	M6835	Collar	1
176		Compression Spring	1
177	SM1450	Guard/Chip Deflector	1



SAFETY HOLDING DEVICE
ASSEMBLY No SM1456

BRIDGE GUARD
ASSEMBLY No SM1455

CHIP DEFLECTOR/GUARD ASSEMBLY