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

This machine is engineered to a high standard of construction and performance. Attention to maintenance and service will be repaid by many years' trouble-free operating.
Consult your Distributor in the event of difficulty or servicing requirements. Your Distributor is qualified to advise you on the proper maintenance of your Machine, to assess any claims under the Guarantee and to supply and fit genuine STARTRITE parts.

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

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CONTENTS

IMPORTANT

DO NOT LIFT MACHINE BY TABLES

PLACE SUITABLE LIFTING BARS
UNDER INTEGRAL BRACKETS
AT BOTH ENDS OF MACHINE

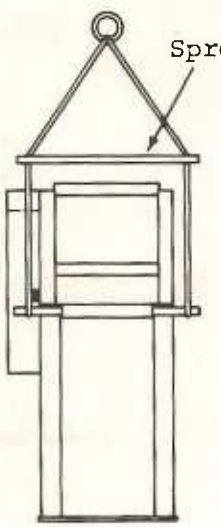
SPECIFICATION

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	-4.9M/min,	16ft/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.

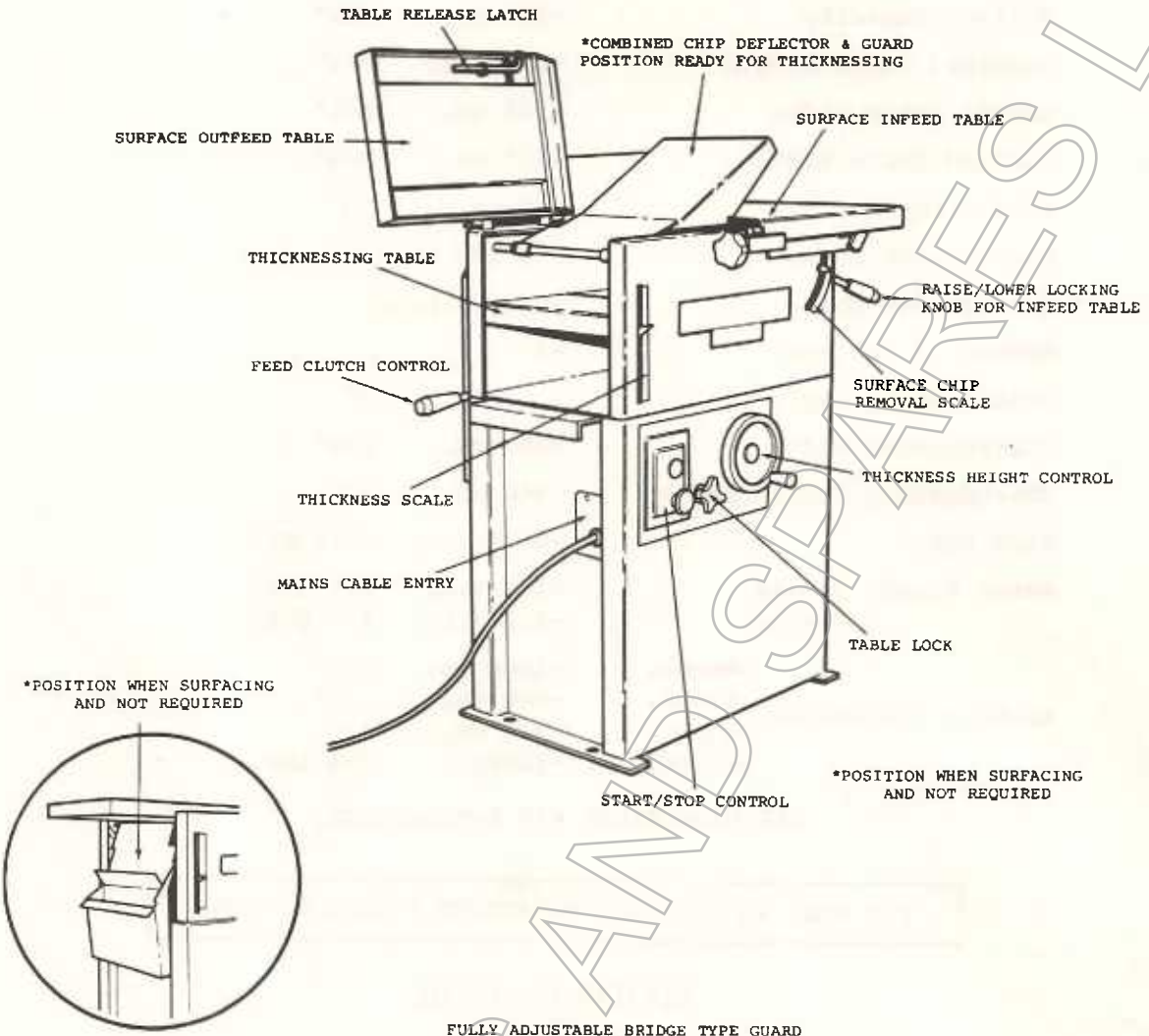
ALL DIMENSIONS ARE APPROXIMATE.

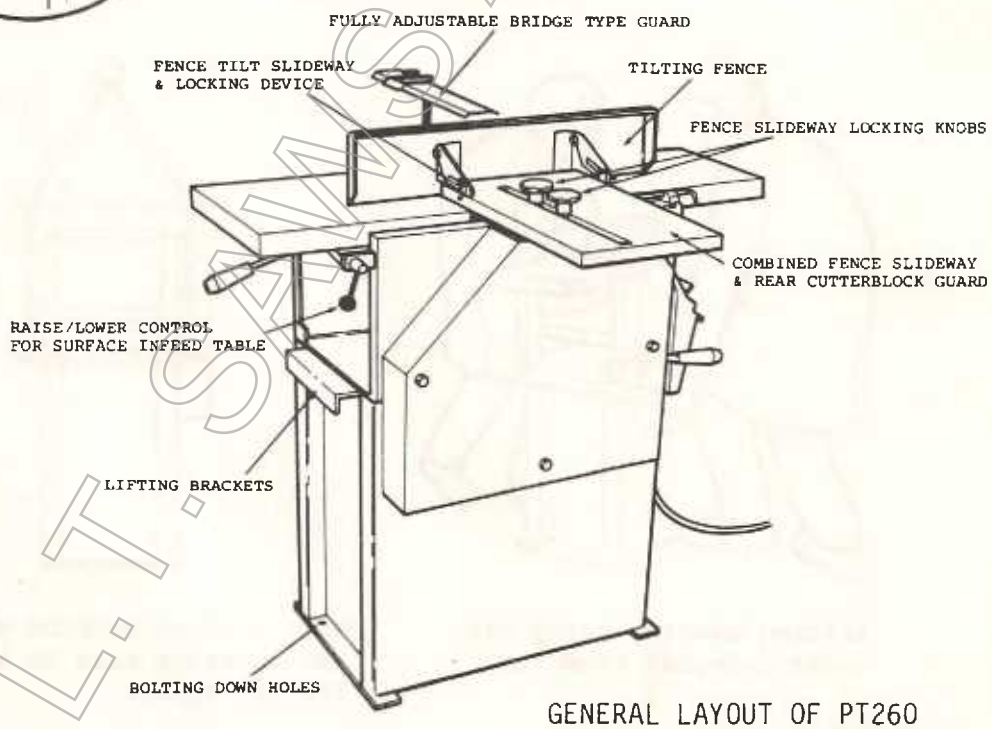
LIFTING THE PT260.

Lifting machine using bars under integral brackets.



When lifting machine with hoist use spreader bars to keep ropes free of table.





GENERAL LAYOUT OF PT260
(DETAILS VARY ACCORDING TO MODEL).

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.

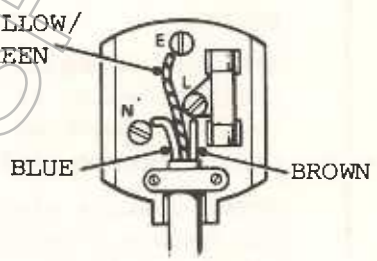


Fig.1

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.

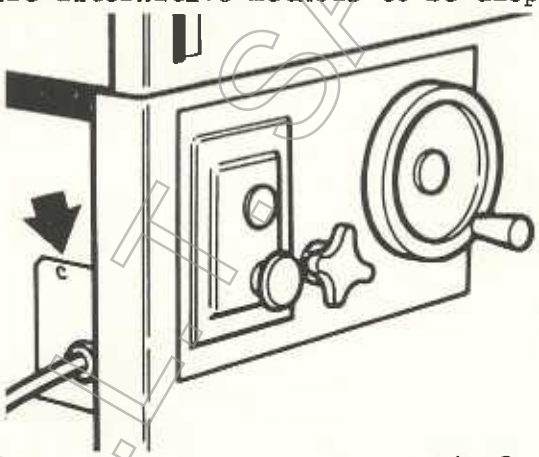


Fig.2

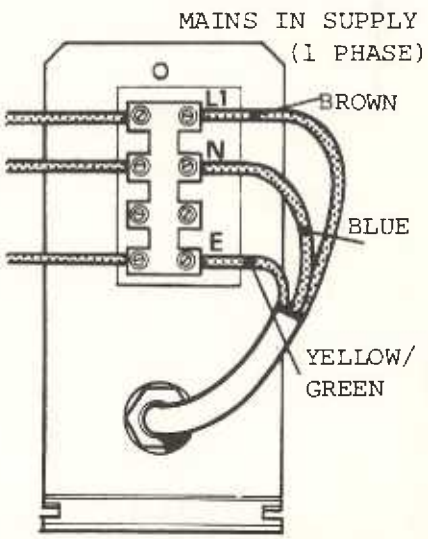


Fig.3

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.

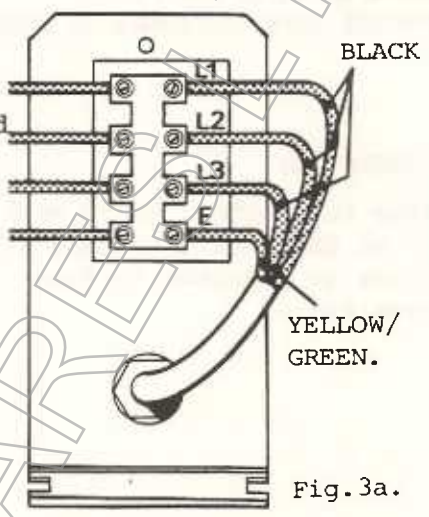


Fig.3a.

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.

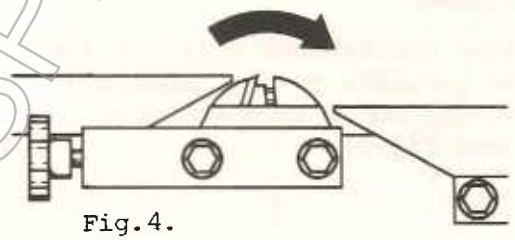


Fig.4.

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	7.0	7.0 - 10.5	MT0150939
415/3/50Hz	2.6	2.2 - 4.8	MT0150936

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)

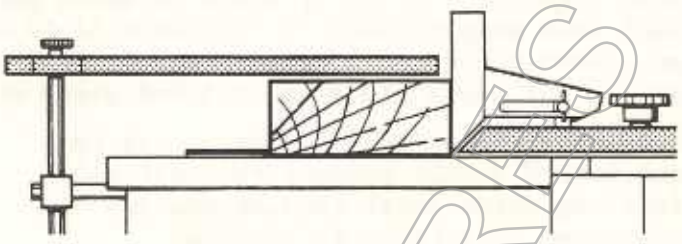


Fig.5.

EDGING:

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

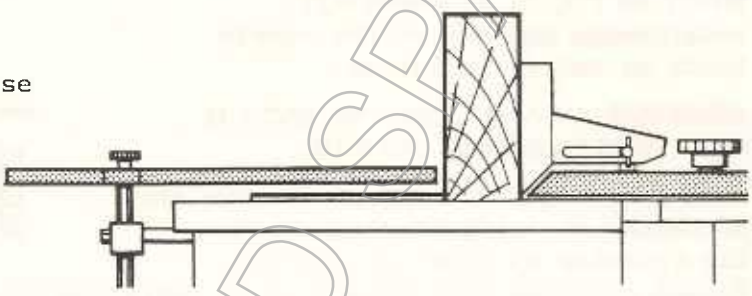


Fig.6.

BEVELLING:

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

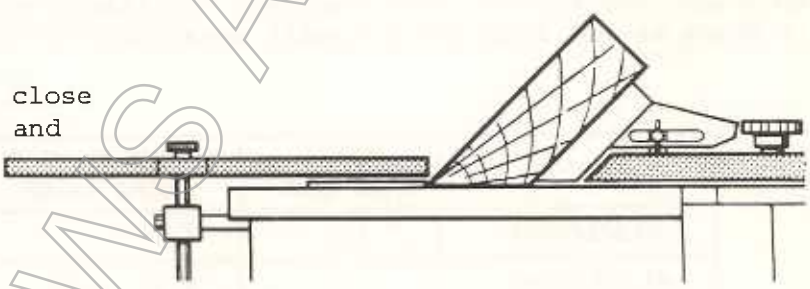


Fig.7.

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.

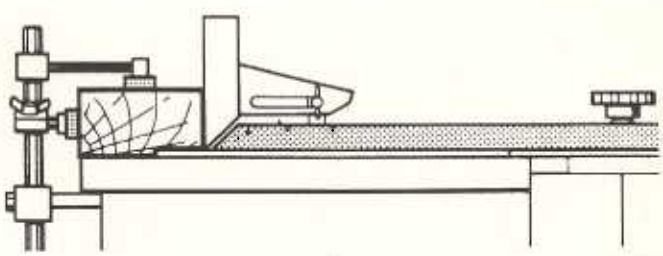


Fig.8.

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 which must be in the raised position.

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.
Note: Waxing table face will ensure a smoother feed i.e. to reduce friction.

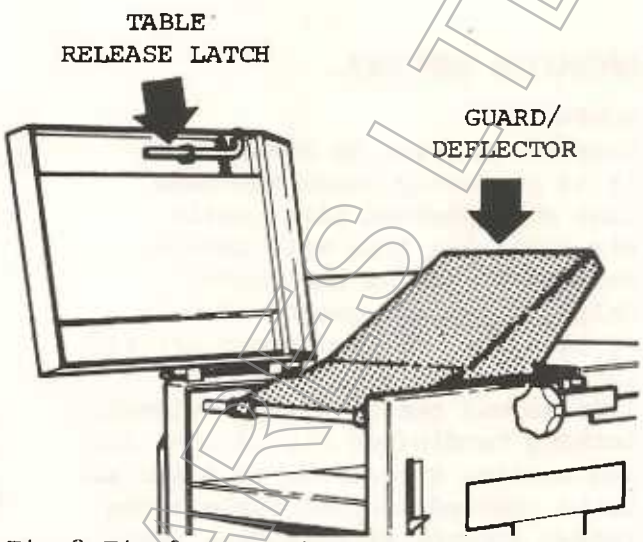


Fig.9:Final operational position.

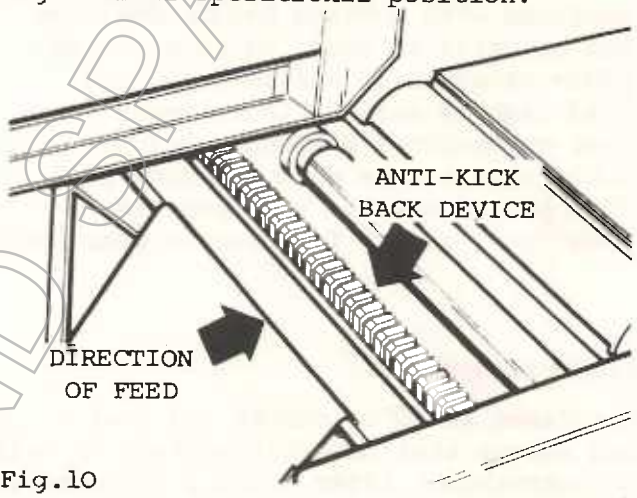


Fig.10

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.

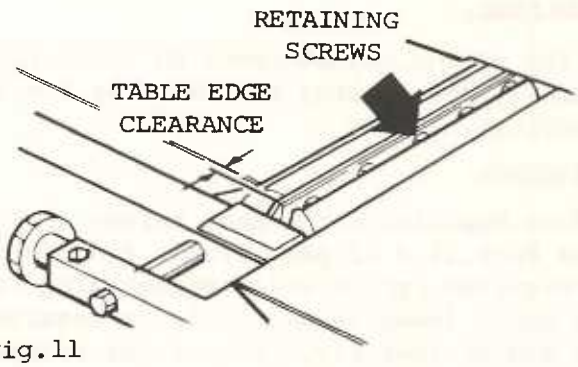


Fig.11

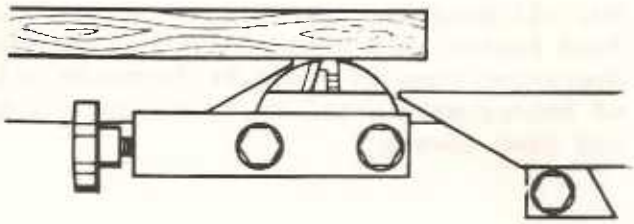


Fig.12

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)

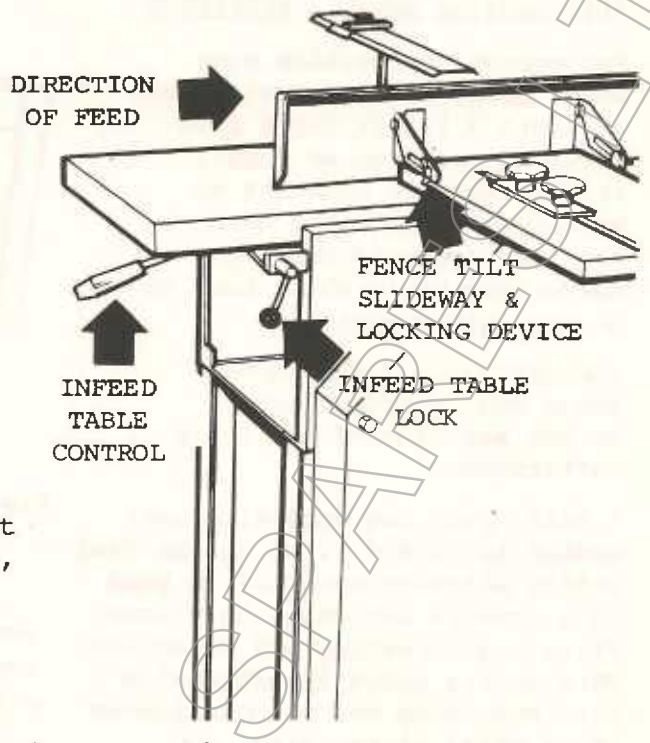


Fig.13.

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.

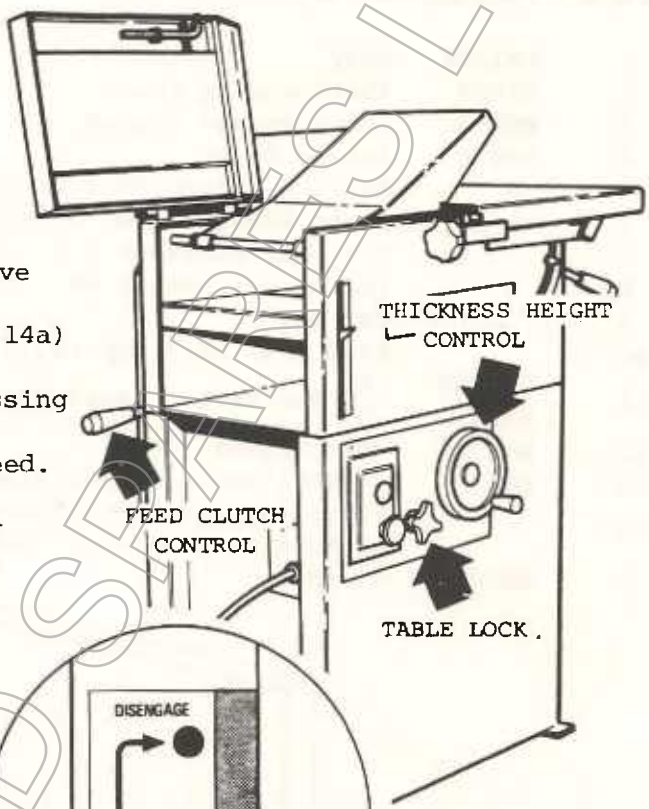


Fig.14

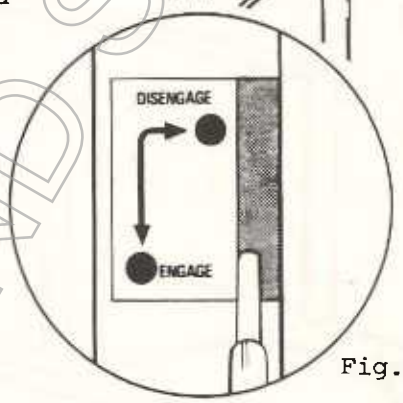


Fig.14a

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.

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).

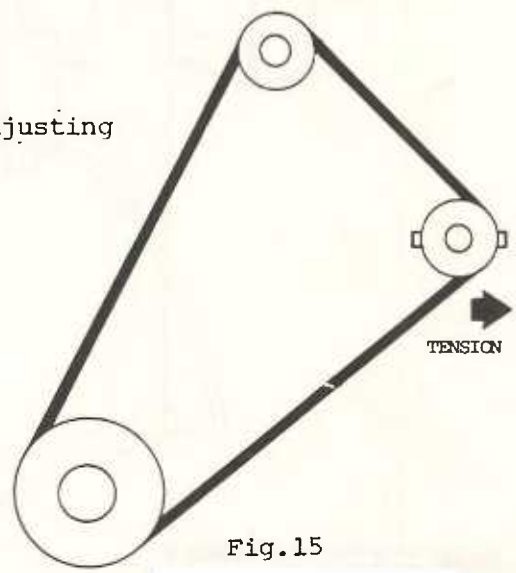
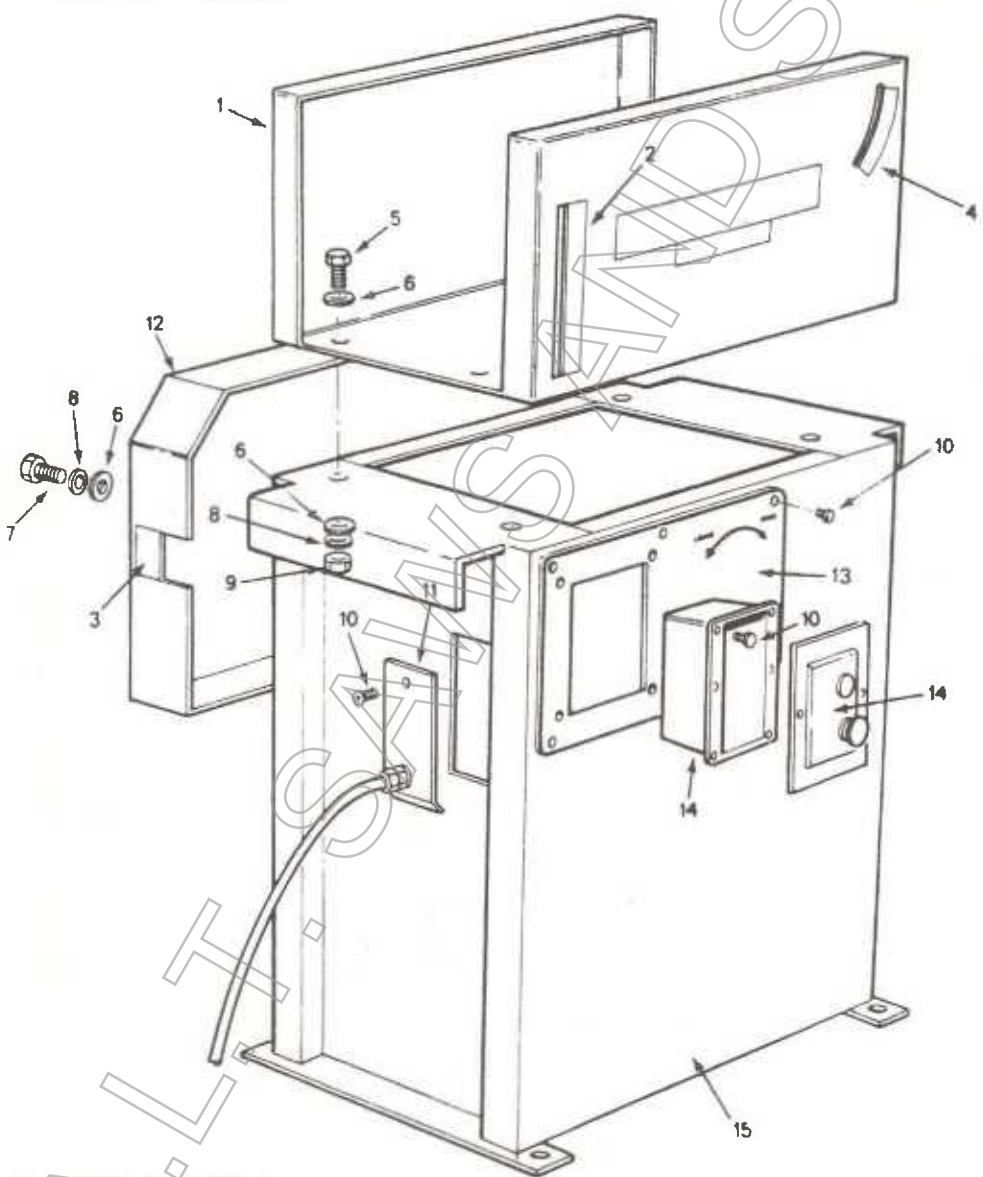


Fig.15

BODY & STAND ASSEMBLY

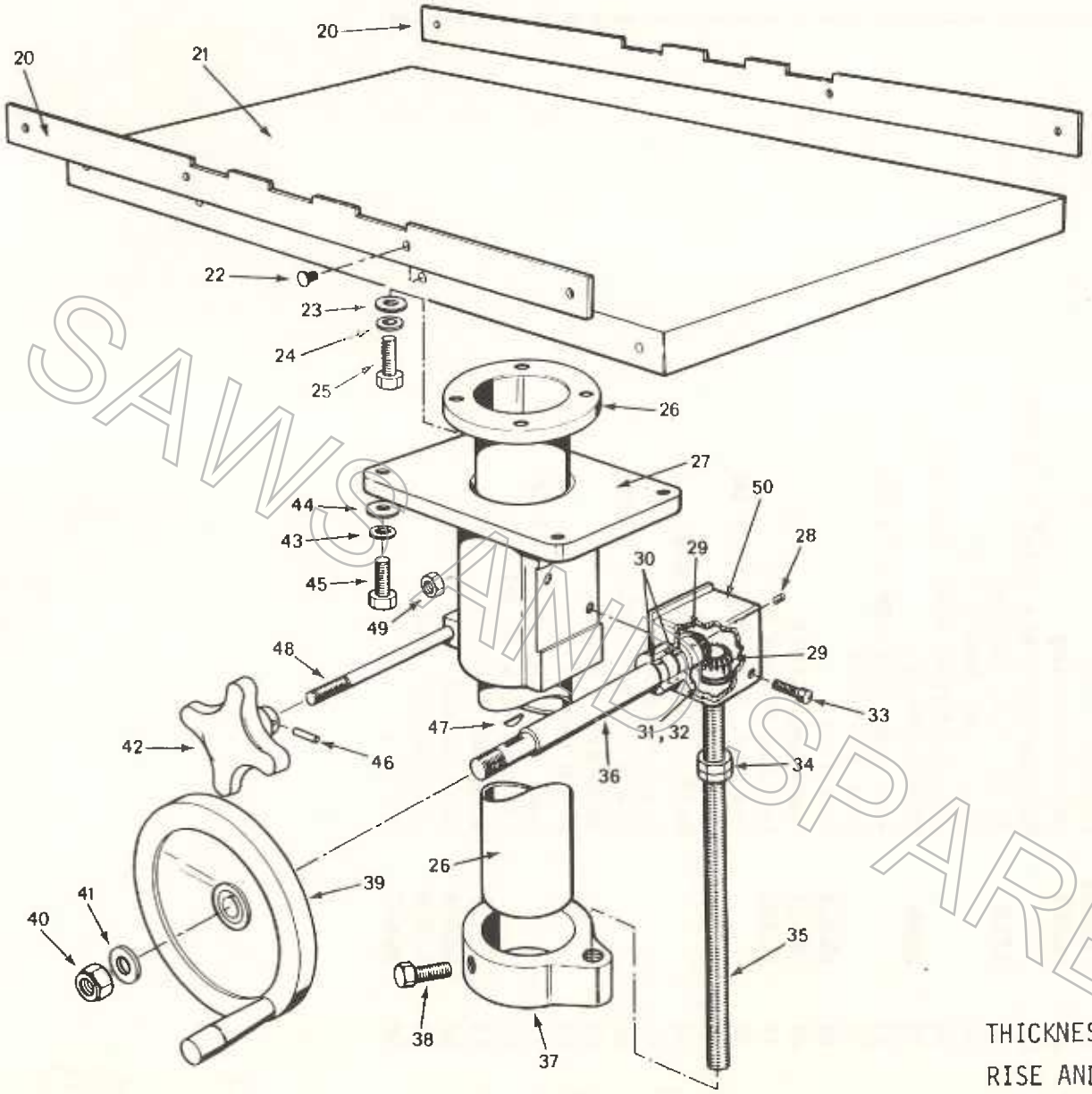
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
1	SM1448	Body	1
2	M6869	Thicknessing Scale	1
3	M6850	Drive Engage Legend	1
4	M6870	Infeed Scale	1
5		Hex. Hd. Screw	4
6		Plain Washer	11
7		Hex. Hd. Screw	3
8		Shakeproof Washer	7
9		Hex Nut	4
10		Self Tapping Screw	11
11	SM1489 SM1490	1PH 3PH Electrical Panel Assembly	1
12	M6996	Drive Cover	1
13	M6871	Control Panel Legend Plate	1
14		Flush Mounted Starter Switch	1
		Flush Mounted Starter Switch	1
15	SM1492	Stand	1



BODY & STAND ASSEMBLY

THICKNESSING TABLE/RISE AND FALL ASSEMBLY.

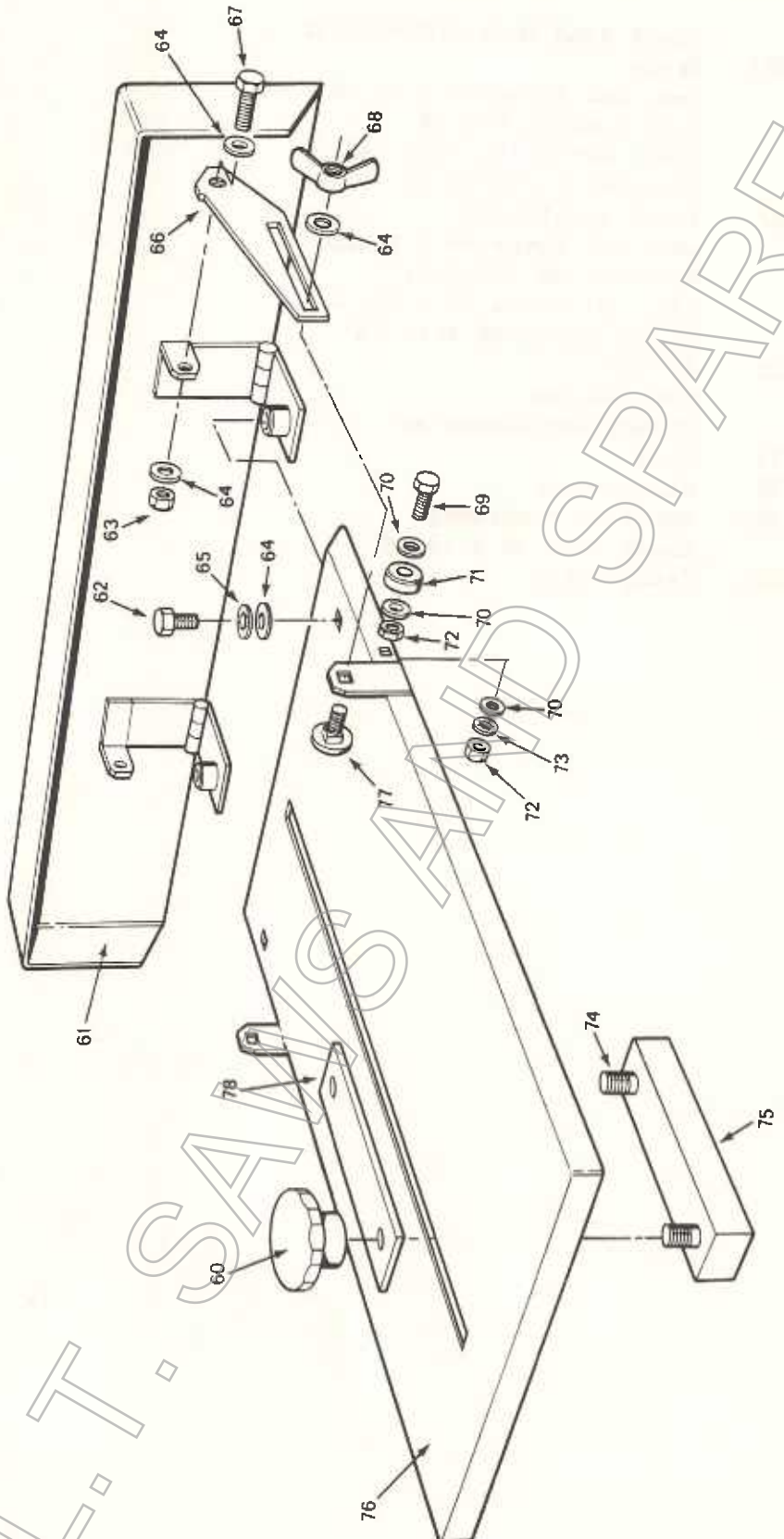
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
20	M6865	Thicknessing Table Side Plates	2
21	SM1493	Thicknessing Table	1
22		Soc. csk/n. Scw.I	8
23		Plain Washer	4
24		Shakeproof Washer	4
25		Hex. Hd. Scw	4
26	SM1454	Table Column	1
27	M6887	Column Casting	1
28		Sel-Lok Pin,	2
29	2715	Mitre Gear (plain)	2
30		Compo Bush	2
31		Needle Thrust Race.	1
32	2609	Thrust Washers	2
33		Soc. Cap. Scw.	2
34		Lock Nut.	2
35	M6819	Studding	1
36	M6823	Handwheel Shaft	1
37	M6888	Locking Collar	1
38		Hex. Hd. Scw.	2
39	M6867	Handwheel	1
40		Self Locking Nut,	1
41		Plain Washer	1
42		Black Handknob	1
43		Shakeproof Washer	4
44		Plain Washer	4
45		Hex. Hd. Scw.	4
46		Sel Lok	1
47		Woodruff Key	1
48	M6824	Locking Bar	1
49	M5798	Special Nut	1
50	M2637	Housing	1



THICKNESSING TABLE/
RISE AND FALL ASSEMBLY

FENCE ASSEMBLY.

ITEM	PART NUMBER AND DESCRIPTION		No.OFF
60		Black Hand Knob	2
61	SM1497	Fence	1
62		Hex. Hd. Screw	2
63		Self-locking Nut	2
64		Plain Washer	8
65		Shakeproof Washer	2
66	M6843	Fence Pivot Link	2
67		Hex. Hd. Screw	2
68		Wing Nut	2
69		Hex. Hd. Screw	2
70		Plain Washer	6
71	M6818	Roller	2
72		Full Nut	4
73		Shakeproof Washer	2
74	M6873	Stud	2
75	M6872	Clamp Block	1
76	SM1498	Fence Carrier/Guard	1
77		Coach Bolt	2
78	M7309	Clamp Plate	1



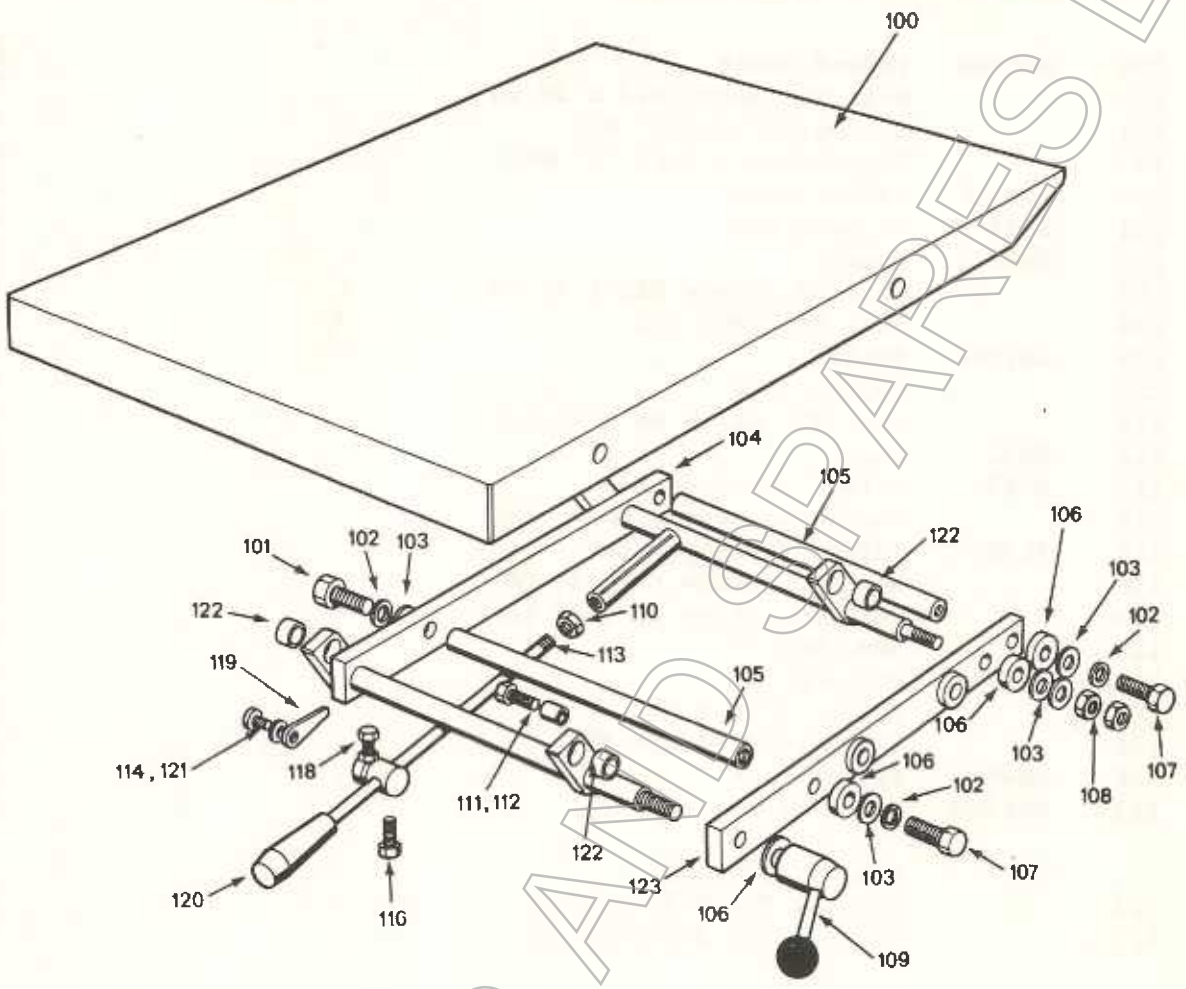
FENCE ASSEMBLY

INFEED TABLE ASSEMBLY.

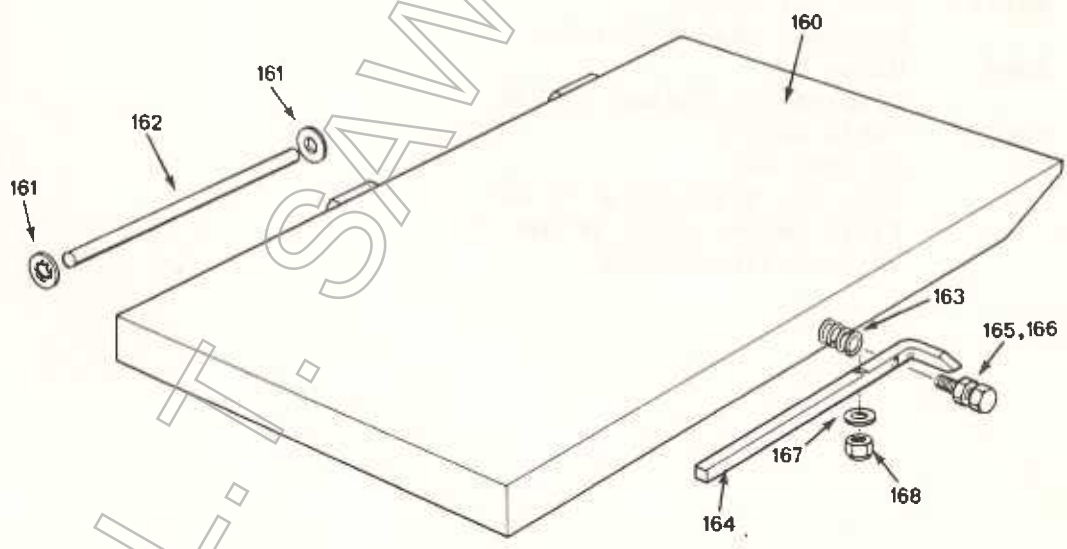
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
100	SM1488	Infeed Table	1
101		Hex. Hd. Screw	2
102		Shakeproof Washer	4
103		Plain Washer	6
104	SM1446	Table Pivot	1
105	6834	Torsion Bar	2
106	6847	Spacer	3
107		Hex. Hd. Screw	2
108		Hex. Full	2
109	SM1261	Handle	1
110		Locknut	1
111		Hex. Hd. Screw	4
112	6836	Bush	4
113	6838	Infeed Pivot Handle	1
114		Cheese Hd. Screw	1
115	6875	Infeed Indicator Bar	1
116		Hex. Hd. Screw	1
117		Hex. Hd. Screw	1
118		Hex. Nut	1
119	6877	Pointer	1
120		Handle	1
121		Shakeproof Washer	1
122	6849	Spacer	4
123	SM1588	Pivot Plate	1
		Not illustrated:	
124		Sel Lok Pin	2
125		Sel Lok Pin	2

FEED OFF TABLE ASSEMBLY.

160	SM1447	Feed Off Table	1
161		Starlock Washer	2
162	6966	Hinge Bar	1
163		Compression Spring	1
164	6863	Table Latch	1
165		Locknut	1
166		Hex. Hd. Screw	1
167		Plain Washer	1
168		Self-Locking Nut	1



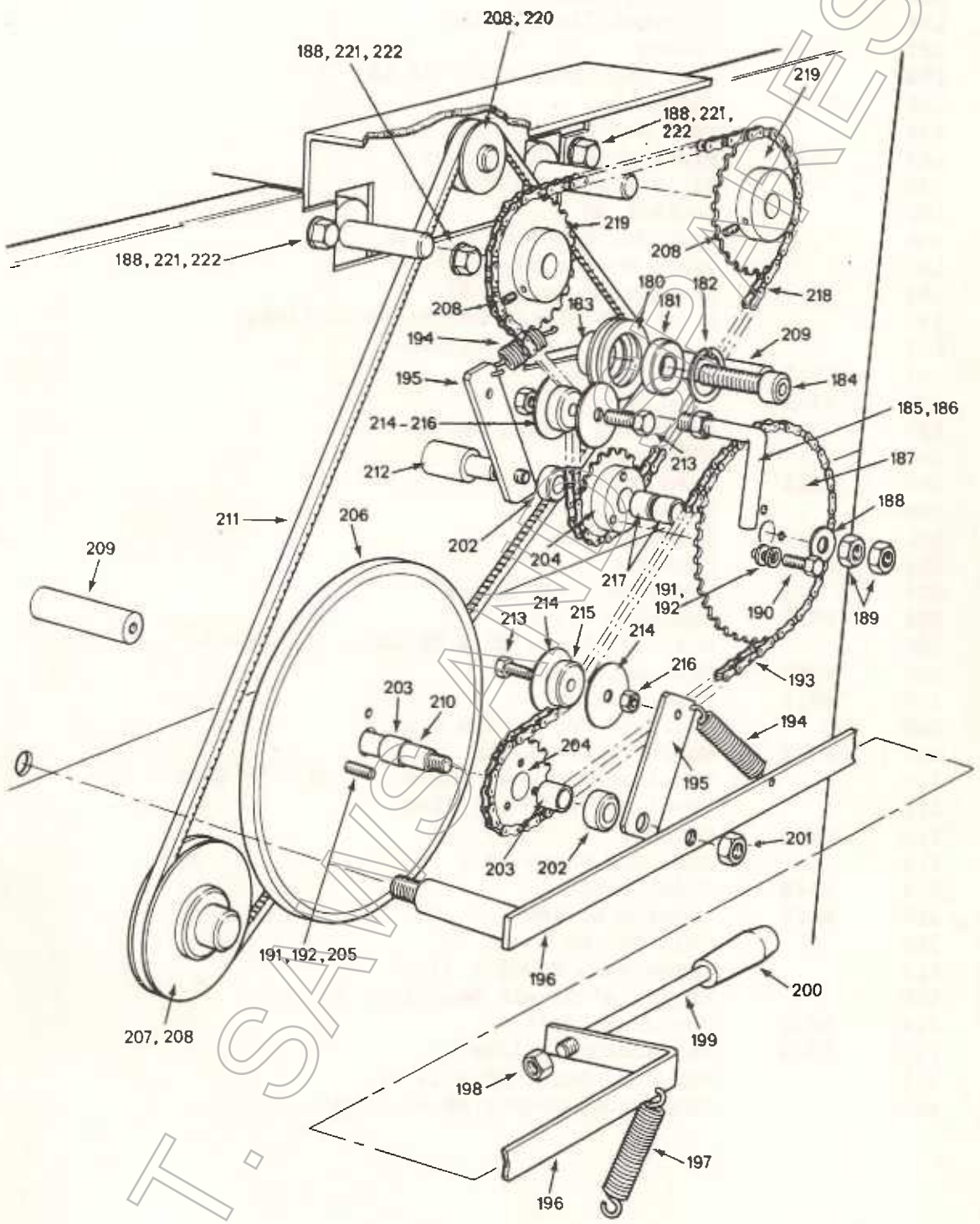
INFEED TABLE ASSEMBLY



FEED OFF TABLE ASSEMBLY

DRIVE ASSEMBLY

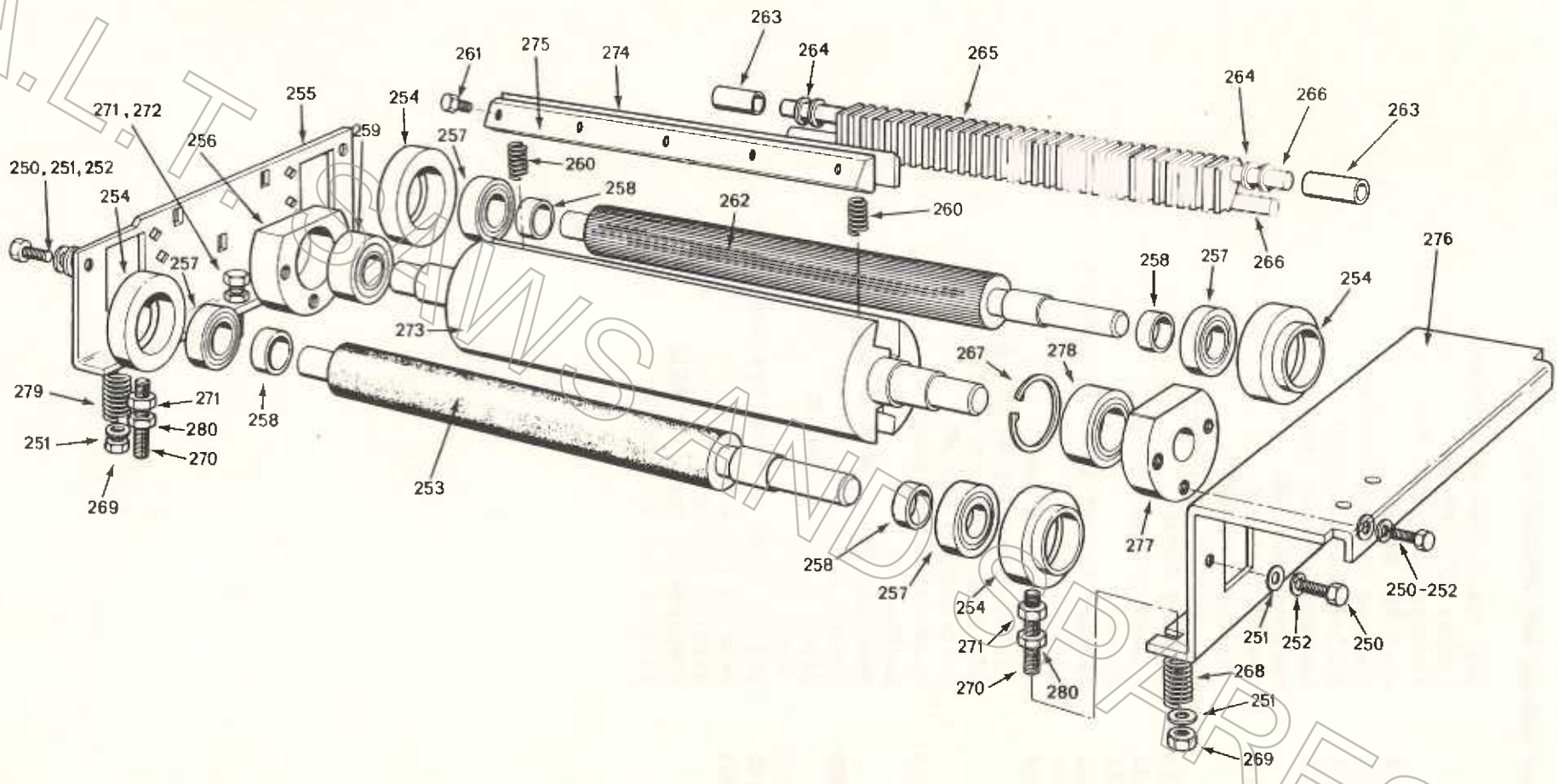
ITEM	PART NUMBER	AND DESCRIPTION	No.OFF
180	6839	Idler Pulley	1
181		Bearing	1
182		Internal Circlip	2
183	7496	Spacer	4
184		Soc. Cap Screw	1
185	7644	Stop Bar	1
186		Full Nut	2
187	6828	Plate Wheel	1
188		Plain Washer	6
189		Locknut	2
190		Hex. Hd. Screw	3
191		Plain Washer	6
192		Shakeproof Washer	6
193		Chain in' Simple	1
194		Extension Spring	2
195	6817	Tension Bar	2
196	1452	Feed Support	1
197		Extension Spring	1
198		Locknut	1
199	6811	Feed Engage Bar	1
200		Handle 1306/FM10	1
201		Locknut	1
202	6874	Spacer	2
203		Compo Bush	2
204	6829	Sprocket	2
205		Hex. Hd. Screw	3
206	8066	Feed Drive Roller	1
207	6815	Motor Pulley	1
208		Soc. Set Screw	8
209	6848	Guard Cover Pillar	2
210		Shoulder Screw	1
211		'Cog' Vee Belt	1
212	6810	Spindle	1
213		Hex. Hd. Screw	2
214	7645	Side Plate	4
215	6818	Tension Roller	2
216		Full Nut	2
217		Compo Bush	2
218		Chain in' Simple	1
219	6830	Sprocket	2
220	6814	Cutterblock Pulley	1
221		Hex. Hd. Screw	3
222		Shakeproof Washer	3



DRIVE ASSEMBLY

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

ITEM	PART NUMBER	DESCRIPTION	No.OFF
250		Hex. Hd. Screw	4
251		Washer	12
252		Shakeproof Washer	4
253	8024	Feed Off Roller	1
254	6805	Bearing Housing (Roller)	4
255	6977	Roller Guide Bracket	1
256	6802	Bearing Housing (Front)	1
257		Bearing	4
258	6806	Spacer (Roller)	4
259		Bearing	1
260		Compression Spring	4
261	6813	Jacking Screw	10
262	8023	Infeed Roller	1
263	6841	Spacer	2
264	6821	Spacing Washer (Anti Kick Back)	32
265	6826	Anti Kickback	29
266	6804	Anti Kickback Bar	2
267		Internal Circlip	1
268		Compression Spring	2
269		Self-Locking Nut	4
270	6969	Feed Roller Studding	4
271		Locknut	6
272		Hex. Hd. Screw	2
273	6820	Cutter Block	1
274		Blade	2
275	6889	Wedge Piece	2
276	6978	Roller Guide & Fence Bracket	1
277	6803	Bearing Housing (Rear)	1
278		Bearing	1
279		Compression Spring	2
280		Filidas Nut	2



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

SAFETY HOLDING DEVICE - ASSEMBLY No SM1456

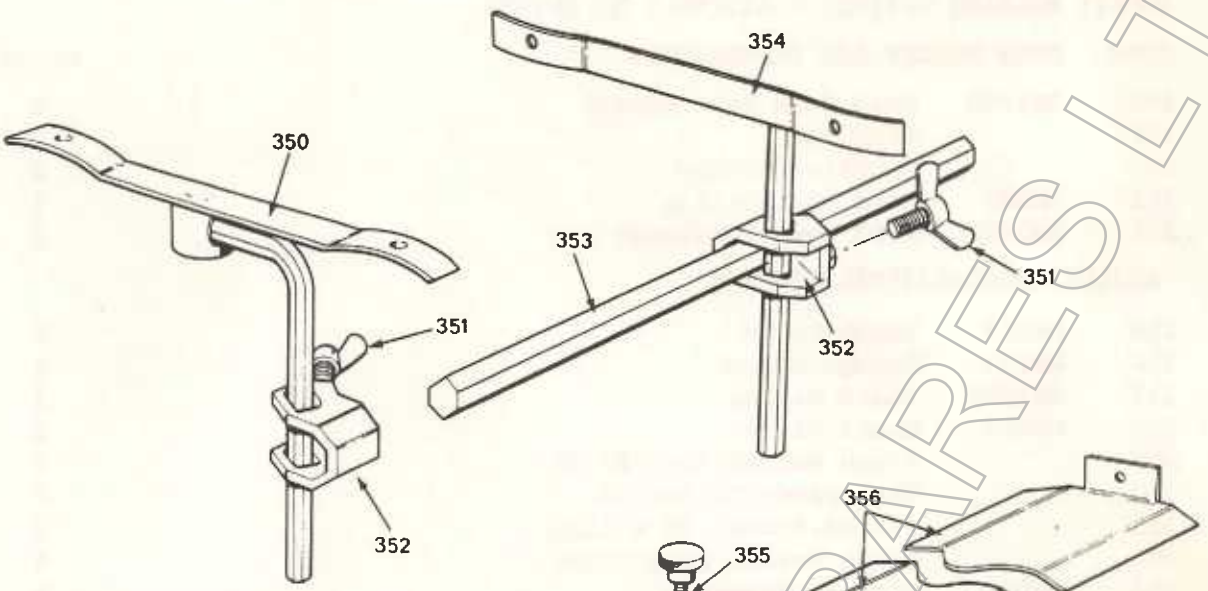
ITEM	PART NUMBER AND DESCRIPTION		No.OFF
350	SM1486	Hold Down Bar (Short)	1
351		Wing Nut	2
352		Knuckle Casting	2
353	M6882	Hold Down Pillar	1
354	SM1487	Hold Down Bar(Long)	1

BRIDGE GUARD-ASSEMBLY SM1455

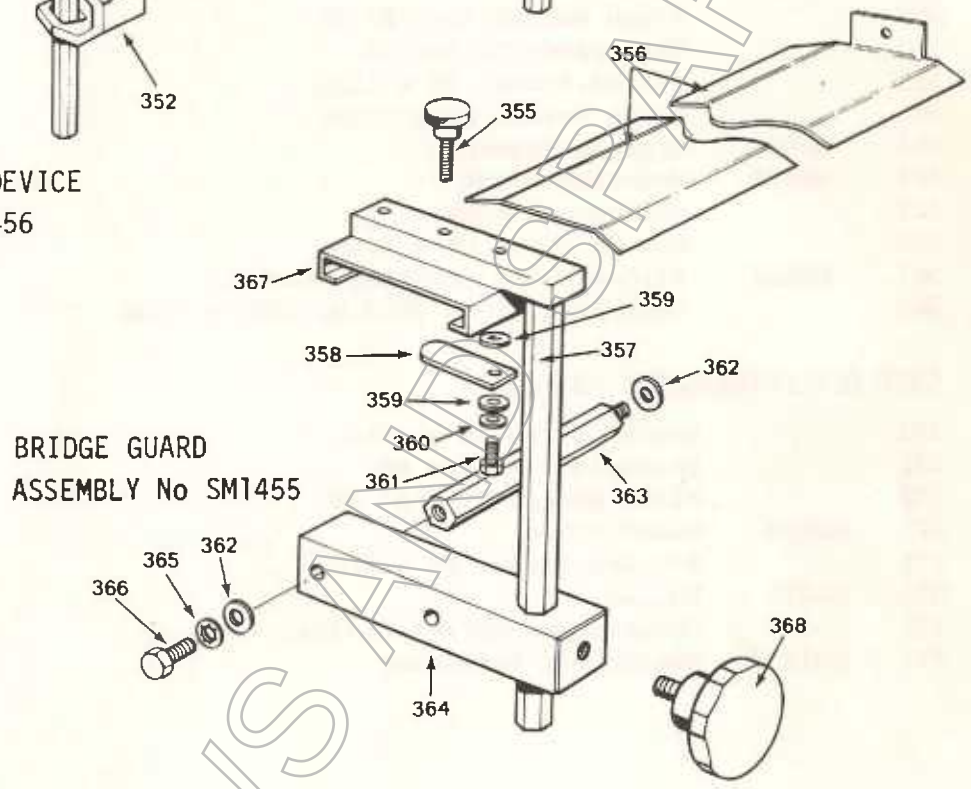
355	M6967	Thumb Screw	1
356	M6983	Bridge Guard	1
357	SM1500	Guard Pillar	1
358	M6968	Scuff Plate	1
359		Plain Washer	3
360		Shakeproof Washer	2
361		Hex.Hd.Screw.	2
362		Plain Washer	4
363	M6881	Hexagon Spacer	2
364	M6879	Mounting Block	1
365		Shakeproof Washer	2
366		Hex Hd Screw	2
367	M6984	Bridge Guard Mounting Bracket	1
368		Hand Knob	1

CHIP DEFLECTOR/GUARD ASSEMBLY.

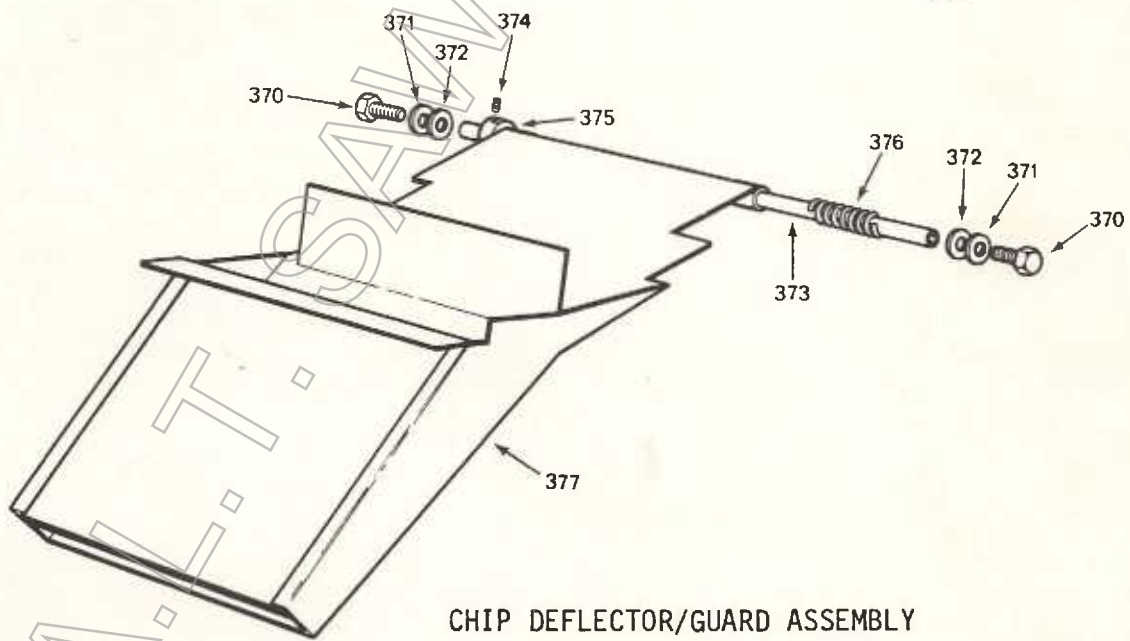
370		Hex.Hd.Screw	2
371		Shakeproof Washer	2
372		Plain Washer	2
373	M6809	Guard Pivot	1
374		Soc.Set.Screw.	1
375	M6835	Collar	1
376		Compression Spring	1
377	SM1450	Guard/Chip Deflector	1



SAFETY HOLDING DEVICE
ASSEMBLY No SM1456



BRIDGE GUARD
ASSEMBLY No SM1455



CHIP DEFLECTOR/GUARD ASSEMBLY