

# HAND FEED PLANER TYPE 9" BFT

FRONT CUTTERBLOCK GUARD.

FENCE.

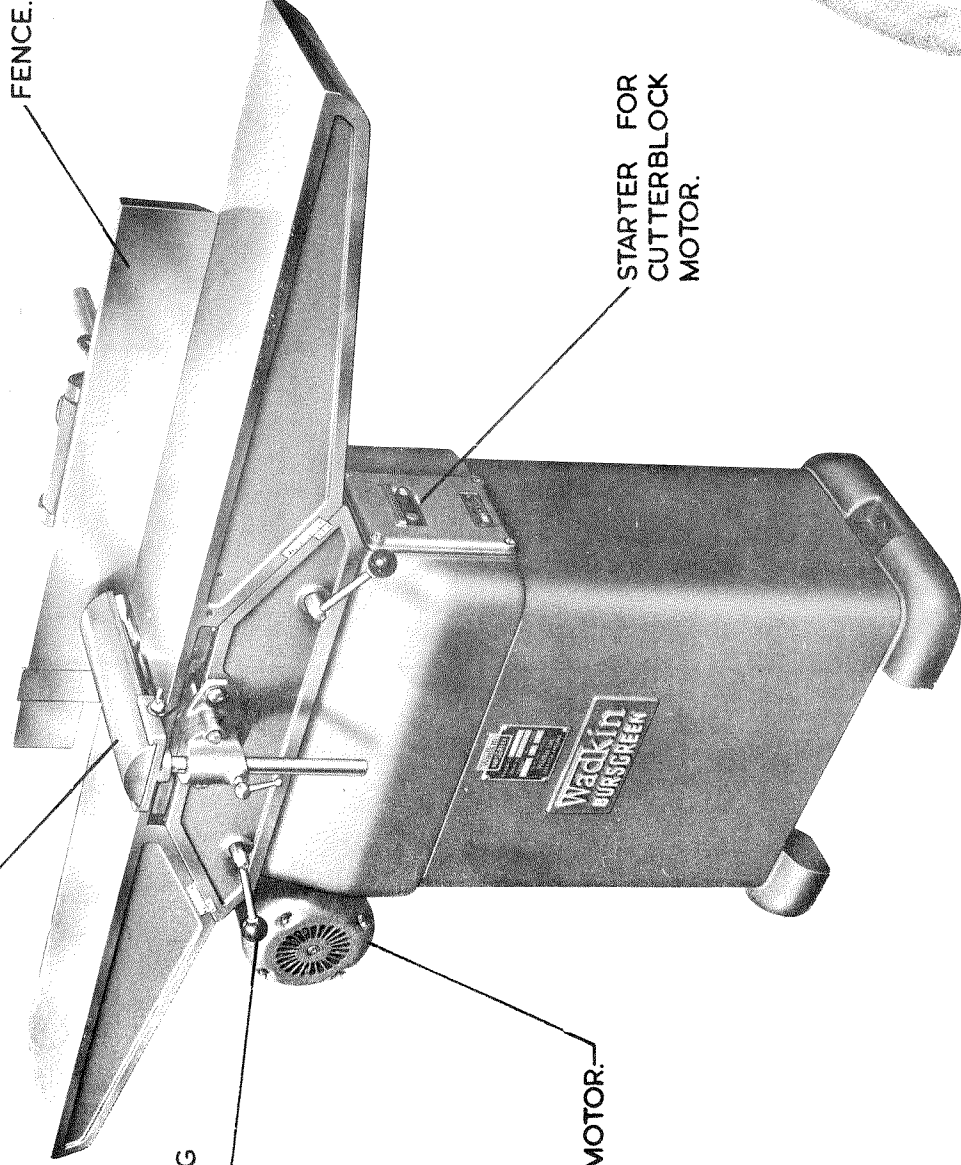


TABLE LOCKING HANDLE.

CUTTERBLOCK MOTOR.

STARTER FOR CUTTERBLOCK MOTOR.

## SPECIFICATION

Planing capacity...	...	9" wide	
Length of tables...	...	5' 0"	
Speed of cutterblock in r.p.m	...	5000	
Cutting circle of cutterblock	...	3½"	
Fence:-			
Length...	...	30"	
Height...	...	4¼"	
Will cant to...	...	45°	
Will rebate to	...	½"	
Rise and fall of tables.	...	¾"	
H.P. of driving motor...	...	2 (3 phase)	
Syn. speed of motor	...	3000 r.p.m, 50 cycles	
		3600 r.p.m, 60 cycles	
Height of table from floor...	...		
Approx. floor space	...	34½"	FLOOR MACHINE
Approx. net weight	...	5'x2'6"	875 mm
Approx. gross weight	...	364lb	1500x 750 mm
Shipping dimensions.	...	540lb	165 kg
Rebate table (EXTRA)	...	27 cu.ft.	245 kg
	...	12lb	.75 cu.m
	...	5 kg	5 kg
	...	14½"	BENCH MACHINE
	...	5'x2'6"	350 mm
	...	325lb	1500 x 750 mm
	...	400lb	150 kg
	...	12½cu.ft.	180 kg
	...	12lb	.35 cu.m.
	...	5 kg	5 kg

FIG. I.

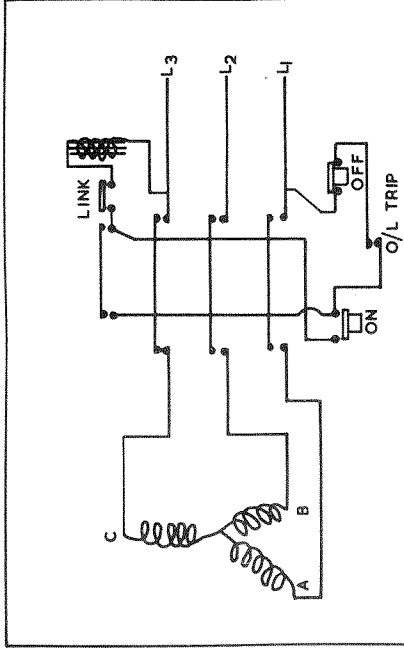
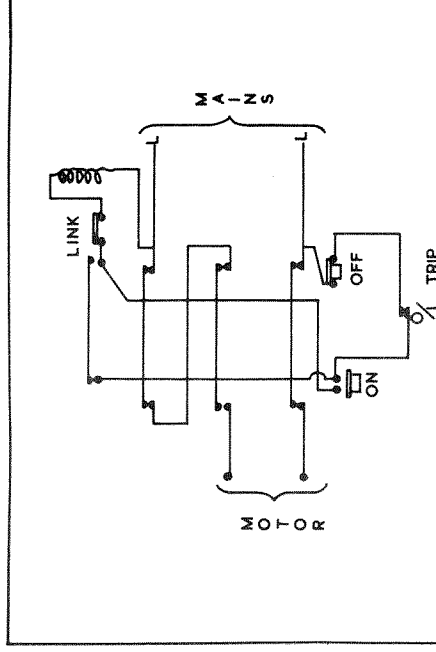
**INSTALLATION**

Remove protective coating from bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

When the machine is cased for export the motor, belt guard, fence and front cutterblock guard are removed and packed individually. Remove and re-assemble as shown in Fig. 1.

**FOUNDATION**

See Fig. 5 for bolt positions and clearance required. When installing the machine, level the table by packing under the feet. Foundation bolts are not supplied with the machine except by special order.

**FIG. 2. WIRING DIAGRAM FOR 3 PHASE SUPPLY.****FIG. 3.****WIRING DIAGRAM FOR 1 PHASE SUPPLY****WIRING DETAILS**

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the starter.

Points to note when connecting to power supply:-

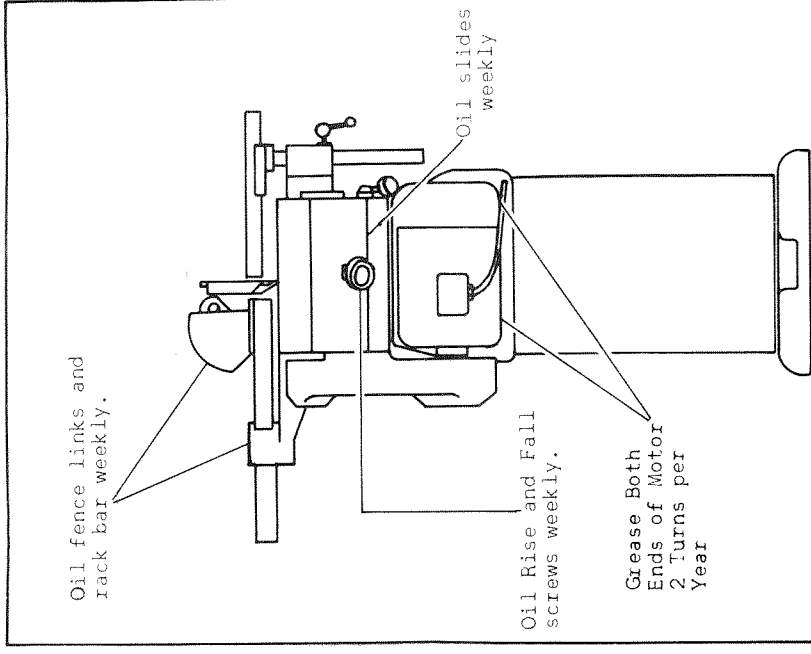
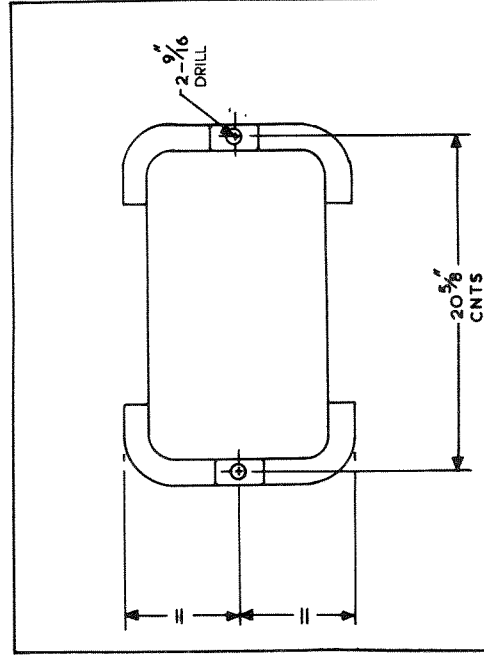
1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3. Check the main line fuses are of the correct capacity. See list below.
4. Connect the line leads to the appropriate terminals. See Fig. 2 for three phase supply. See Fig. 3 for single phase supply.
5. Check all connections are sound.
6. Check the rotation of the motor for the correct direction. If this is incorrect on three phase supply reverse any two of the line lead connections.

VOLTAGE	PHASE	SWG. TINNED COPPER WIRE	AMPS
220	3	22	24
340/420	3	25	15
550	3	29	10
200/250	1	19	38

**LUBRICATION**

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting. The slideways should also be kept clear of chippings for ease of operation.

TYPE OF OIL RECOMMENDED POWER EM 125  
TYPE OF GREASE RECOMMENDED SHELL ALVANIA 3

**FIG. 4.****FIG. 5.****BELT TENSION**

The drive is by means of 2 vee belts from a 2 HP motor mounted on a hinge bracket.

To check the belt tension, remove the belt guard at the rear of the machine.

The tensioning arrangement is shown in Fig. 6.

To re-tension the belts, the undermentioned procedure should be followed:-

1. Adjust the nut A, until the spring is compressed to approximately 9/16" against the pull of the belts. This will ensure the correct belt tension is maintained.
2. Replace the belt guard. This should be in place at all times when the machine is running. To ensure trouble free running of the machine it is advisable to check the belt tension regularly.

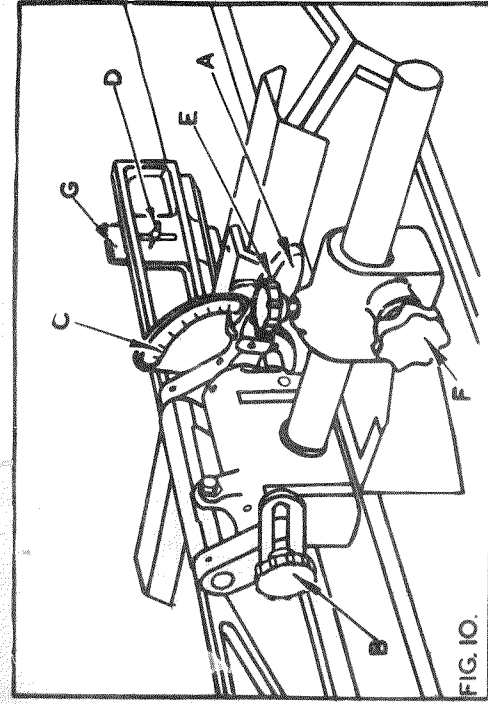


FIG. 10.

#### FENCE ADJUSTMENT

The fence cants by means of a single lever "A" in Fig. 10 to 45°. The angle to which the fence is canted is shown on a graduated scale "C".

To cant the fence to the required angle loosen the handwheel "B" and lift handle "A" until the required angle is shown on the graduated scale "C", then re-lock handwheel "B".

The fence front plate is fitted with an insert "G" which is over the rear planing table and is adjustable depending on the depth of cut which is being taken. To adjust the depth of cut which is being taken, the insert loosen the wing nut "D" and move the insert until it just touches the rear planing table then re-lock wing nut "D". The insert should be loosened at all times before lowering the front planing table.

The fence is also adjustable across the full width of the table by means of a rack and pinion. To adjust the fence across the table loosen the handwheel "E", and turn the handwheel "F" in the direction which the fence is required to move, until the required position is reached, then re-lock handwheel "E".

The fence should be locked in both positions at all times when the machine is in operation.

The fence has positive stops at 90° and 45°. These are both accurately set before despatch from the works.

To check the positive stops on the fence the undermentioned procedure should be followed:-

1. Move the fence towards the rear of the table as shown in Fig. 11.
2. Check the 90° positive stops by means of a steel square as shown in Fig. 11. If adjustment is necessary, adjust the hexagon head bolts "A" until the fence is at right angles to the table when hard up against the stops and the handwheel "B", in Fig. 10, locked.
3. Check the 45° positive stop by means of an adjustable square. If adjustment is necessary, adjust the socket head grub screw "B" until the fence is 45° to the table when hard up against the stop and the handwheel "B" in Fig. 10 locked.
4. If adjustment is necessary to the positive stops check that the graduated scale is still correct. This is secured to the support bar by means of a socket head grub screw. This should be loosened and the scale accurately positioned to the pointer.

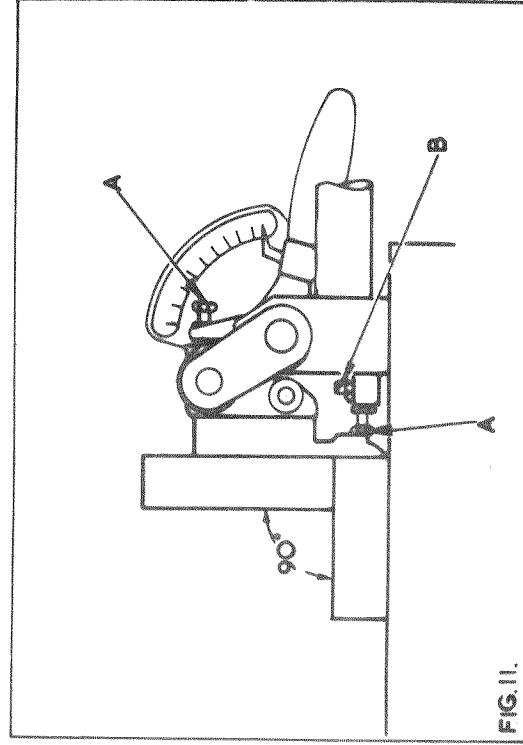


FIG. 11.

#### GENERAL HINTS FOR SURFACE PLANING

1. To obtain the best surface finish always check the direction of the grain, which should run with the cutter as shown in Fig. 12.
2. To obtain a perfectly flat surface especially with warped stock, always put maximum pressure on the back table at "A" in Fig. 13 and as little as possible on the front table at "B".
3. Greater pressure will be required when surfacing bad grained timber, otherwise chattering will take place resulting in coarse finish near each knot.
4. When planing four sides of timber, square turn the timber anti-clockwise after each cut, so that there will always be a machined face next to the fence as in Fig. 14. The fence locates accurately at 90°.

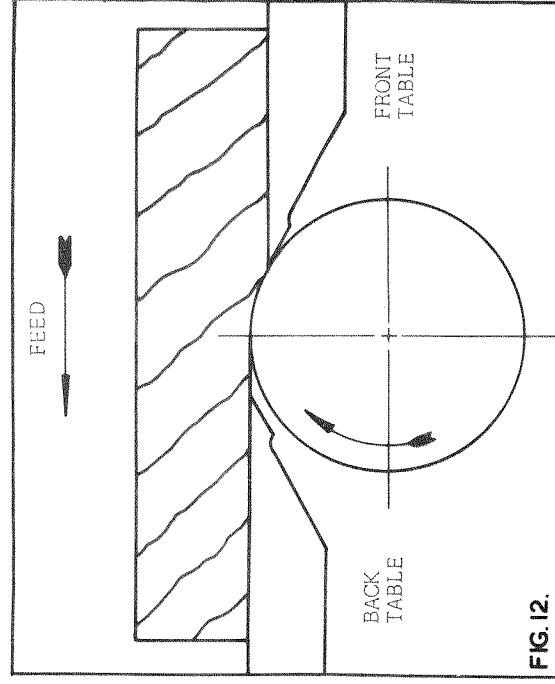


FIG. 12.

#### CORRECT RUN OF GRAIN.

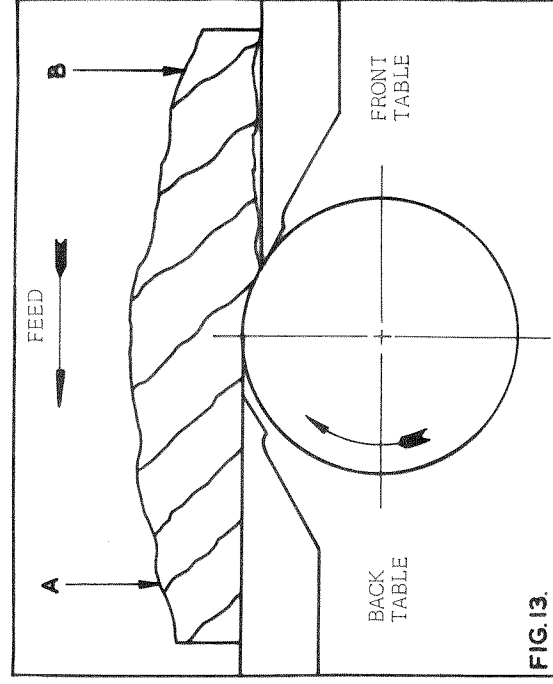


FIG. 13.

#### FEEDING WARPED TIMBER.

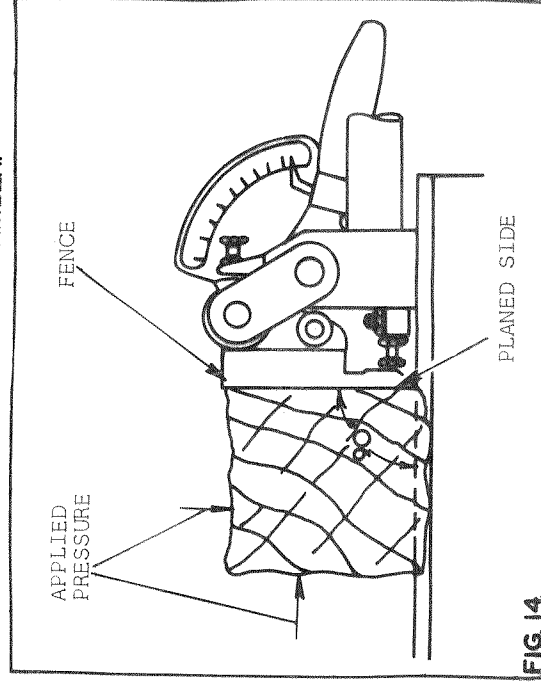


FIG. 14.

WORKING WITH FENCE.

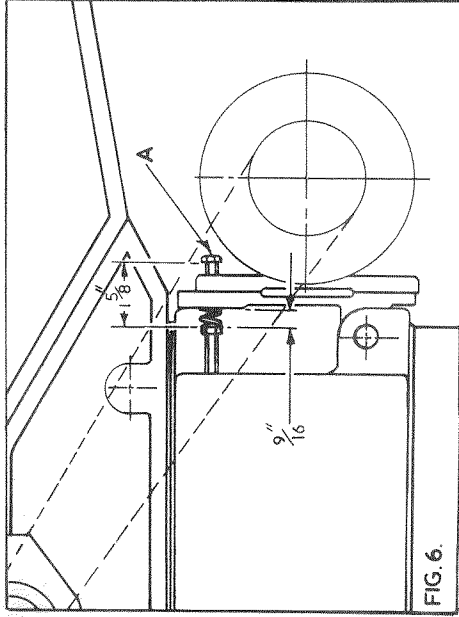


FIG. 6.

**CUTTER SETTING**

The knives are held in the cutterblock by a steel clamping bar secured with 4 - 1/2" whit. heat treated socket head screws. When the locking screws are released the cutters are ejected slightly by a small leaf spring. This is to facilitate easy cutter setting with the special gauge supplied. As the amount of cutter projection is vital to the correct operation of the machine it is most important that the actual gauge supplied with the machine should be used. Should any other method of cutter setting be employed the amount of cutter projection must be exactly the same as with that given by the setting gauge supplied and failure to observe this instruction will result in poor finish. To remove the cutters and re-set with "Bursgreen" cutter setting gauge proceed as follows:-

1. Move the fence to rear of the table and lower both planing tables to their lowest position.
2. Turn the cutterblock to approximately the position shown in Fig. 7 and slacken the securing screws until the knife is just free of the cutterblock. Care should be taken when loosening the last screw as the knives are spring loaded.

The knives can now be removed for grinding or re-placing. When grinding it is most important that knives are ground dead straight and balanced in pairs or sets.

An efficient re-grinding service is available. Charges are moderate and service prompt. To avail yourself with this service, return cutters to:-

**BURSGREEN (DURHAM) LIMITED**

**FENCE HOUSES, HOUGHTON-LE-SPRING, CO. DURHAM.**

3. To re-set the knives, the cutterblock should be in approximately the position shown in Fig. 7. Place the knife in the slot making sure that all faces are clean and the clamping bar free from burrs. Press the knife into the cutterblock with the setting device in Fig. 7 until the four predominant pads rest on the outer surface of the cutterblock and the end stop plate is pressed against the rebate side of the back planing table. Position the knife so that its end butts against the stop plate so as to line up the tip of the knife with the edge of the back table.
4. Holding the setting device securely in this position, tighten the securing screws. Before fully tightening the screws, check that they have not moved in the setting process. The cutting edge should now be dead parallel to the planing tables and the edge in line with the back planing table edge.

Check that all the securing screws have been tightened before setting the next knife.

5. Rotate the cutterblock until the next knife is in position and repeat the procedure until all the knives have been set.
6. To check the setting of the knives raise the back table to its top position i.e. the zero mark on the rule or 1/16" above the outer surface of the cutterblock. Place a straight edge on the table as shown in Fig. 8 and rotate the cutterblock by hand until the knife just touches the straight edge. Repeat this check in various positions over the width of the table to ensure the knife is parallel. Repeat this procedure for all knives.

7. When changing cutters it is advisable to check that all the locking screws are adequately lubricated and quite free. Periodically examine for damage or cracks particularly in the hexagon hole. Any doubtful screws should be replaced and all screws well lubricated with "Moly slip" or similar oil before replacing.

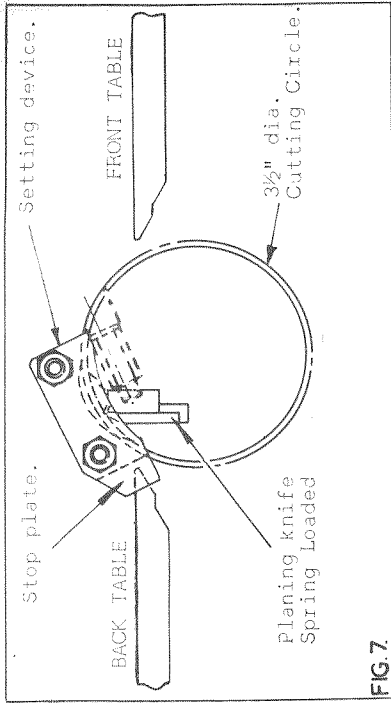


FIG. 7.

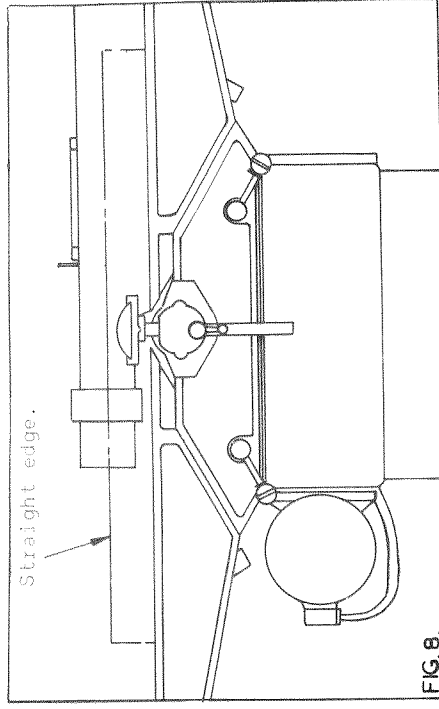


FIG. 8.

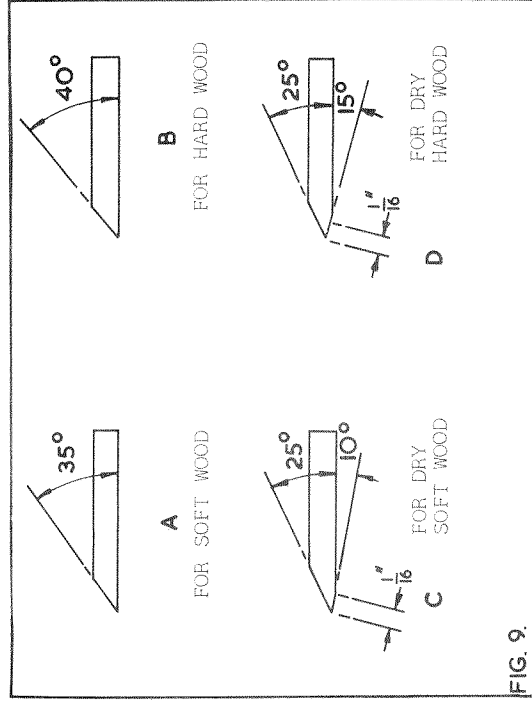


FIG. 9.

**CUTTER CARE**

The cutters supplied are 9/4" (235 mm) long x 1/4" (32 mm) wide x 1/8" (3 mm) thick in balanced sets. They should be kept in balanced sets by ensuring that the cutters have equal dimensions after grinding and that the cutter edge is straight and parallel to the back edge.

For general work, knife angles for soft and hard woods are recommended as in Fig. 9 (a) and (b).

When a very fine finish is required in dry soft and hard woods a slight front bevel is given as in Fig. 9 (c) and (d). For wet or green timber the cutting bevel may be decreased five degrees, but the front bevel should not be given.

Keep the cutters sharp when in position by using a fine grade oil stone dipped in paraffin. Allow the stone to rest lightly and flat on the bevel and pass over the cutter with a rotating action a few times. Give about two strokes on the full length of each knife on the face side to remove all burrs from the cutting edge.

Do not allow a heel greater than 1/32" wide on the bevel before removing and re-grinding. When the heel becomes too wide the knives may heat up or have a hammering effect on the wood and more than normal power will be required to run the cutterblock.

Ref. No.	Part No.	No. Off.	Description	Ref. No.	Part No.	No. Off.	Description
1.	C-1029/11	2	Foot for base.	36.	A-1029/13	4	Table slide rod.
2.		4	Filllet for base.	37.		8	$\frac{1}{4}$ " whit. x $\frac{3}{8}$ " Long socket head cap
3.		16	$\frac{3}{8}$ " whit. x $\frac{3}{4}$ " Long cadmium hexagon head bolt.	38.		8	$\frac{1}{4}$ " whit. x 1" Long socket head cap
4.	D-1029/22	16	$\frac{3}{8}$ " cadmium washer.	39.	Pat. No. 24	2	2" dia. plastic handwheel, $\frac{1}{2}$ " plain bore.
5.	A-1034/14	1	Motor pivot shaft.				
6.		1	Sheet steel base.	40.	A-1029/7	4	$\frac{1}{2}$ " whit. locknut.
7.		2	$\frac{3}{8}$ " whit. x $\frac{3}{8}$ " Long socket head grub screw.	41.	A-1029/12	2	Table rise and fall nut.
8.		4	$\frac{5}{16}$ " whit. x $1\frac{1}{2}$ " Long stud.	42.	A-1029/12	2	Table rise and fall screw.
9.		4	$\frac{5}{16}$ " washer.	43.	B-1029/24	2	Table rise and fall bracket.
10.		4	$\frac{5}{16}$ " whit. aerotight nut.	44.		2	$\frac{1}{2}$ " spring washer.
11.	2410	2	M section vee belt (50 cycle).	45.		2	$\frac{1}{2}$ " whit. x $1\frac{1}{4}$ " Long socket head cap screw.
12.	2440	2	M section vee belt (50 cycle), 3 phase & 60 cycle, 3 phase).	46.	B-1029/16	2	Table locking bar.
		1	Brook motor, T14, T.E.F.C., 2 HP, 2840 r.p.m. (50 cycle, 3 phase).	47.	A-1029/55	4	Table spring.
		1	Brook motor, M66C, T.E.F.C., 2 HP, 3480 r.p.m. (60 cycle, 1 phase).	48.		4	$\frac{3}{8}$ " whit. x $2\frac{1}{2}$ " Long stud.
		1	Brook motor, T14, T.E.F.C., 2 HP, 2840 r.p.m. (50 cycle, 1 phase).	49.	A-1029/72	4	Table spring pressure nut.
		1	Brook motor, M66C, T.E.F.C., 2 HP, 3480 r.p.m. (60 cycle, 1 phase).	50.	A-1029/18	2	Eccentric block.
13.		1	$\frac{3}{16}$ " wide x $1\frac{1}{2}$ " Long Feather key.	51.	44ADS/F0	1	MEM Starter (3 Phase, 50 cycle supply).
14.		2	$\frac{1}{4}$ " whit. x $\frac{3}{4}$ " Long socket head grub screw.			1	Brook Starter (1 Phase, 50 cycle supply).
15.	B-1029/75	1	50 cycle motor pulley.			1	Brook Starter (3 Phase, 60 cycle supply).
16.	B-1029/78	1	60 cycle motor pulley.			1	Brook Starter (1 Phase, 50 cycle supply).
17.	C-1029/9	1	Motor platform (3 Phase motor).	52.		4	$\frac{1}{4}$ " whit. x 1" Long cadmium Cheese head screw.
18.	D-1029/60	1	Motor platform (1 Phase motor).	53.		8	$\frac{1}{4}$ " Long Z6, Mushroom head self tapping screw.
19.	A-1024/21	1	Spring for belt tension.	54.	B-1029/52	1	Chip chute cover.
20.		3	$\frac{3}{8}$ " whit. aerotight nut.	55.		2	$\frac{1}{4}$ " whit. x $\frac{1}{2}$ " Long round head bolt.
21.	D-1029/3	1	Sub base.	56.		2	$\frac{3}{8}$ " whit. x 3" Long hexagon head bolt.
22.		4	$\frac{3}{8}$ " whit. x $1\frac{1}{2}$ " Long stud.	57.		1	$\frac{3}{8}$ " whit. x 1" Long socket head cap screw (Extra).
23.		10	$\frac{3}{8}$ " whit. nut.	58.		1	$\frac{3}{8}$ " whit. x $1\frac{1}{4}$ " Long socket head cap screw (Extra).
24.	D-1029/1	2	Planing table.	59.	C-1029/25	1	Rebate table (Extra).
25.	Pat. No. 28	2	$1\frac{1}{4}$ " dia. plastic ball, $\frac{3}{8}$ " whit.	60.	D-1029/70	1	Boomerang guard (Extra).
26.	A-1002/90A	2	Locking handle for table locking eccentric.	61.		1	$\frac{1}{4}$ " whit. x $\frac{3}{4}$ " Long socket head allen grub screw (Extra).
27.	B-1029/17	2	Table locking eccentric.	62.	A-1029/68	1	Spring holder bolt (Extra).
28.		1	$\frac{3}{8}$ " whit. x 5" Long stud.	63.	A-1029/71	1	Swivel pin for boomerang guard (Extra).
29.	A-1029/59	1	Knurled knob for belt guard.	64.		1	$\frac{5}{16}$ " whit. x $\frac{3}{4}$ " Long square head bolt (Extra).
30.	D-1029/8	1	Belt guard (3 Phase drive).	65.	B-1029/57	1	Bracket for boomerang guard (Extra).
31.	D-1029/2	1	Main frame.	66.		2	$\frac{5}{16}$ " whit. x $1\frac{1}{4}$ " Long hexagon head bolt (Extra).
32.	A-1029/53	2	Table rise and fall indicator.	67.	A-1029/67	1	Spring for boomerang guard (Extra).
33.		4	$\frac{3}{16}$ " whit. x $\frac{3}{8}$ " Long round head screw.	68.	A-1029/69	1	Spring holder for boomerang guard (Extra).
34.	A-1029/21	2	Chip guard.				
35.	A-1029/23	1 each	Table rise and fall rule. (metric).				

Description

No. Off.

Part No.

Ref. No.

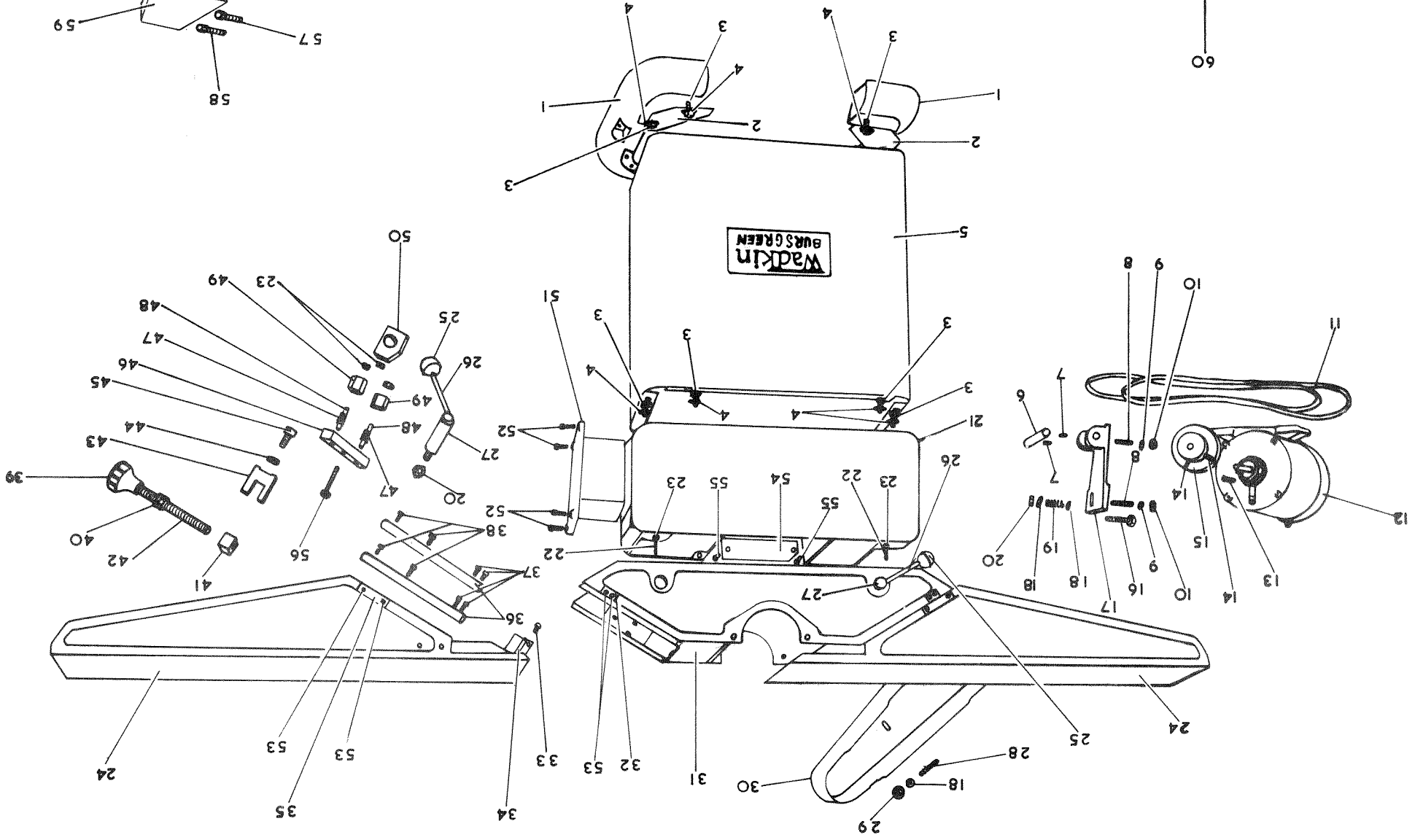
Description

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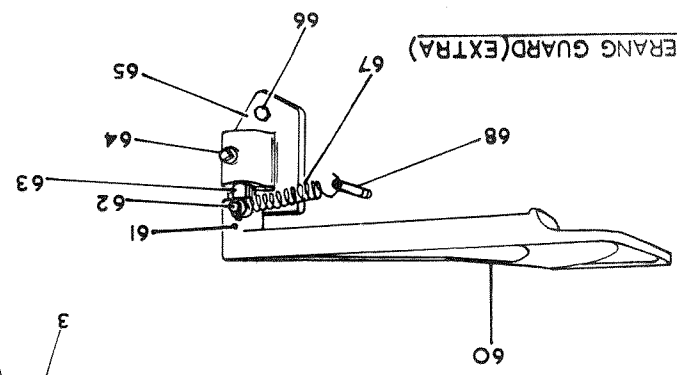
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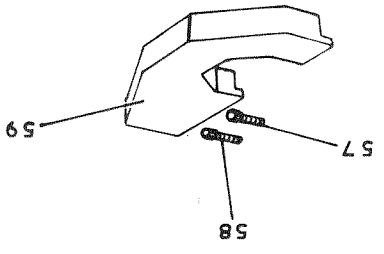
# MAIN FRAME ASSEMBLY



# BOOMRANG GUARD (EXTRA)

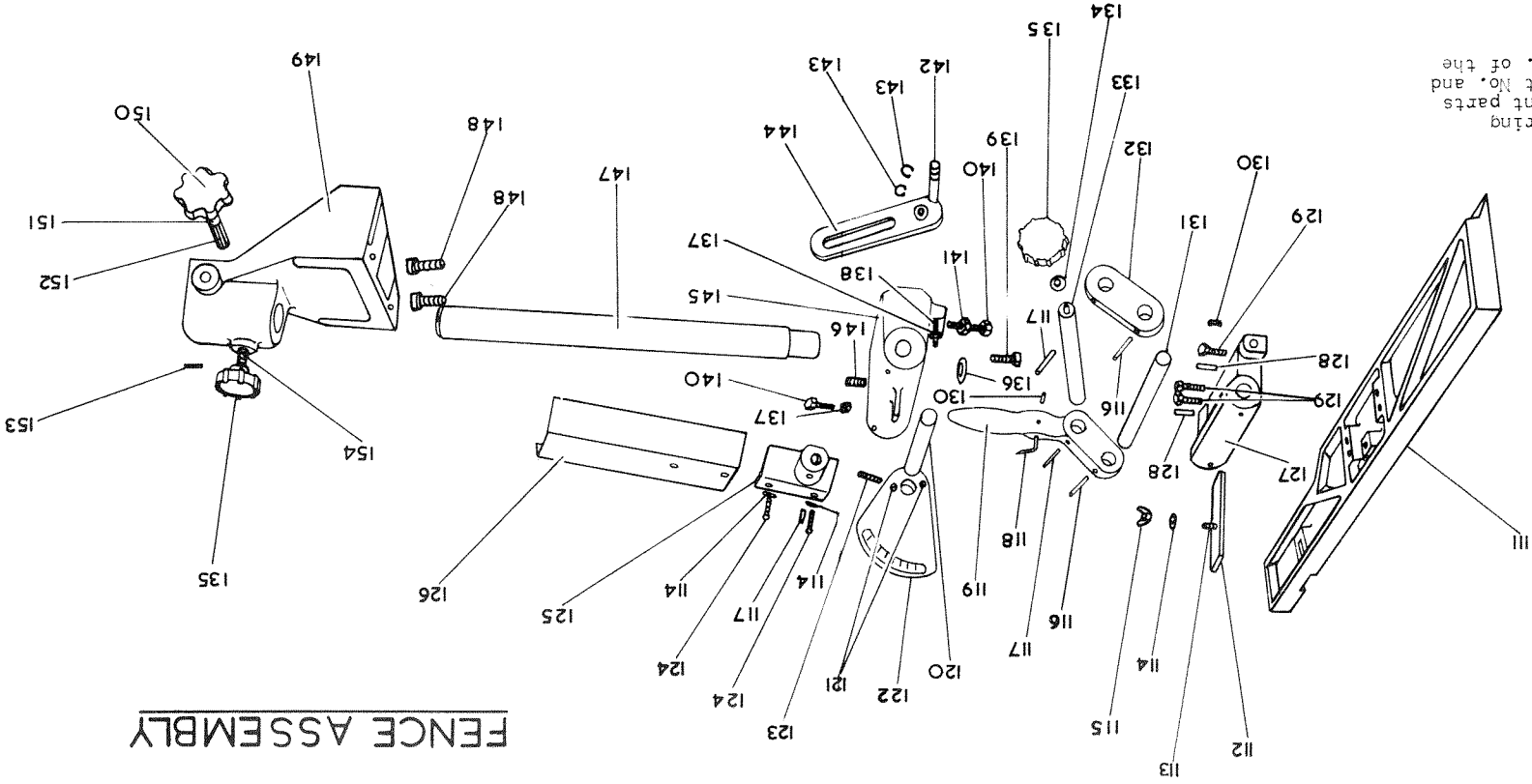


# REBATE TABLE (EXTRA)



NOTE:-  
When ordering  
replacement parts  
quote Part No. and  
Serial No. of the  
Machine.

# FENCE ASSEMBLY



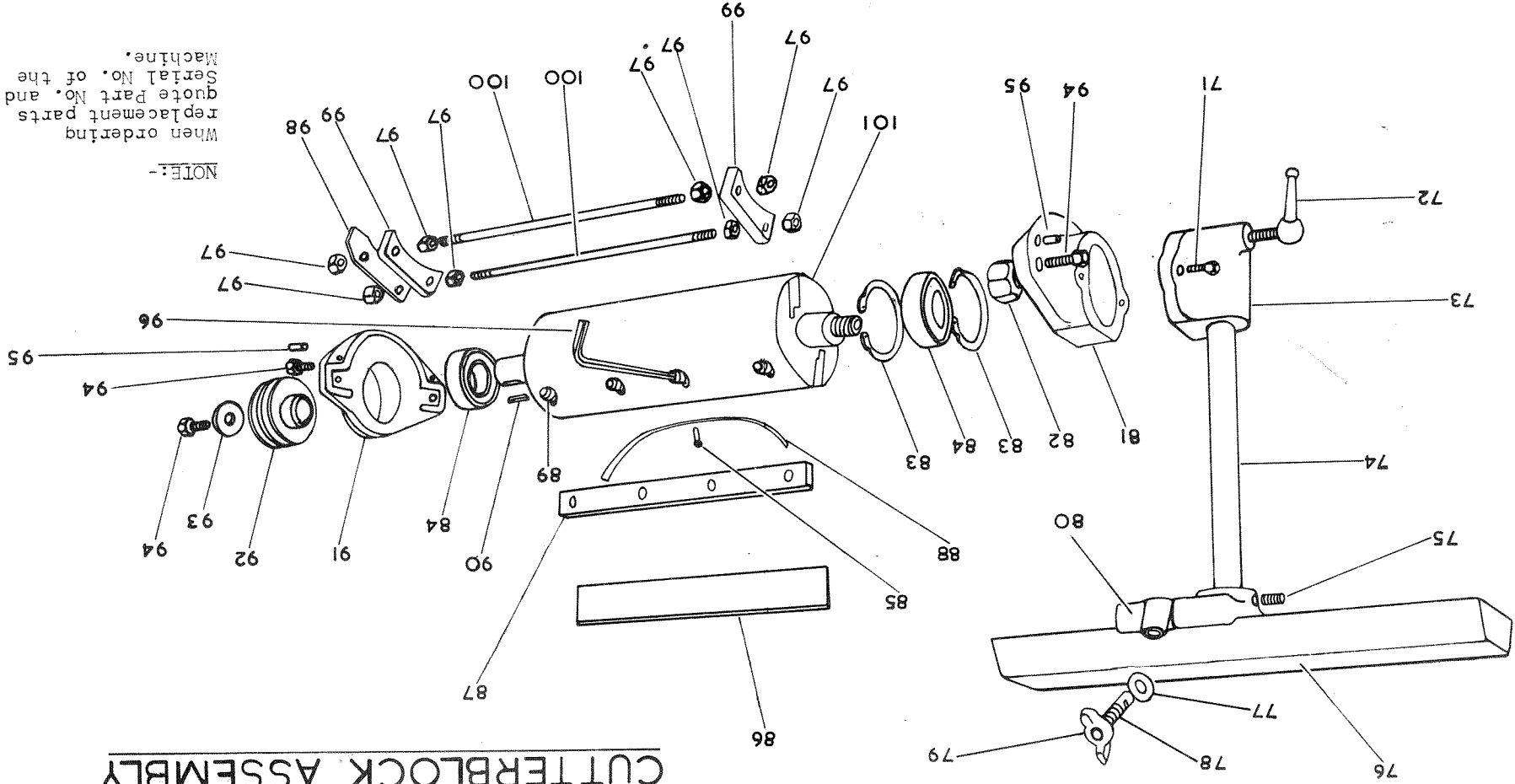
NOTE:-  
When ordering  
replacement parts  
quote Part No. and  
Serial No. of the  
Machine.

Part No.	Description	No. Off.	Part No.	Description	No. Off.
111.	Fence front plate.	1	134.	Washer.	1
112.	D-1029/65	1	135.	Pat. No. 32	2
113.	Adjustable fence plate.	1	136.	A-1792/67	1
114.	Washer.	3	137.	Locknut.	2
115.	Washer.	1	138.	Washer.	1
116.	Washer.	2	139.	Washer.	2
117.	Spring dowel.	3	140.	Washer.	2
118.	A-1029/76	1	141.	Washer.	2
119.	B-1029/34	1	142.	Washer.	2
120.	A-1029/29	1	143.	Washer.	2
121.	A-1029/29	2	144.	Washer.	2
122.	B-1029/44	1	145.	Washer.	2
123.	B-1029/44	1	146.	Washer.	2
124.	B-1029/35	2	147.	Washer.	2
125.	B-1029/28	1	148.	Washer.	2
126.	A-1029/28	1	149.	Washer.	2
127.	C-1029/66	1	150.	Washer.	2
128.	A-1029/33	2	151.	Washer.	2
129.	A-1029/36	3	152.	Washer.	2
130.	A-1029/36	2	153.	Washer.	2
131.	B-1029/33	1	154.	Washer.	2
132.	A-1029/37	1	155.	Washer.	2

Part No.	Description	No. Off.	Part No.	Description	No. Off.
133.	Adjustable fence plate.	1	147.	Washer.	2
134.	Fence front plate.	1	148.	Washer.	2
135.	Washer.	1	149.	Washer.	2
136.	Washer.	3	150.	Washer.	2
137.	Washer.	2	151.	Washer.	2
138.	Washer.	1	152.	Washer.	2
139.	Washer.	2	153.	Washer.	2
140.	Washer.	2	154.	Washer.	2
141.	Washer.	2	155.	Washer.	2
142.	Washer.	2			
143.	Washer.	2			
144.	Washer.	2			
145.	Washer.	2			
146.	Washer.	2			
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154.	Washer.	2			
155.	Washer.	2			

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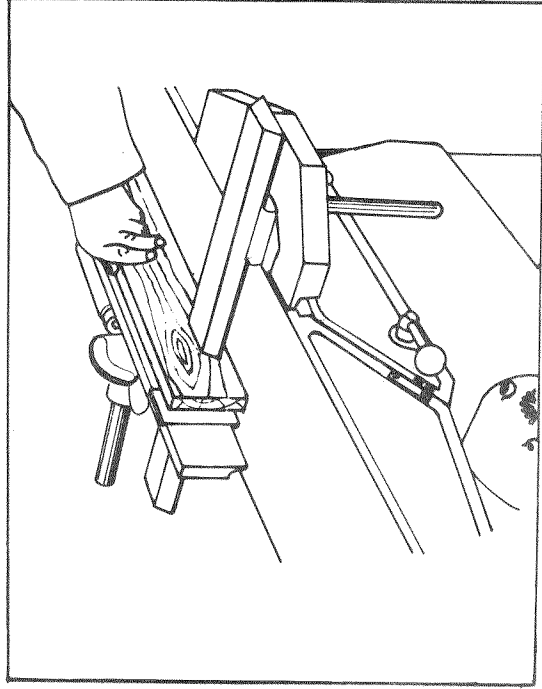
# CUTTERBLOCK ASSEMBLY



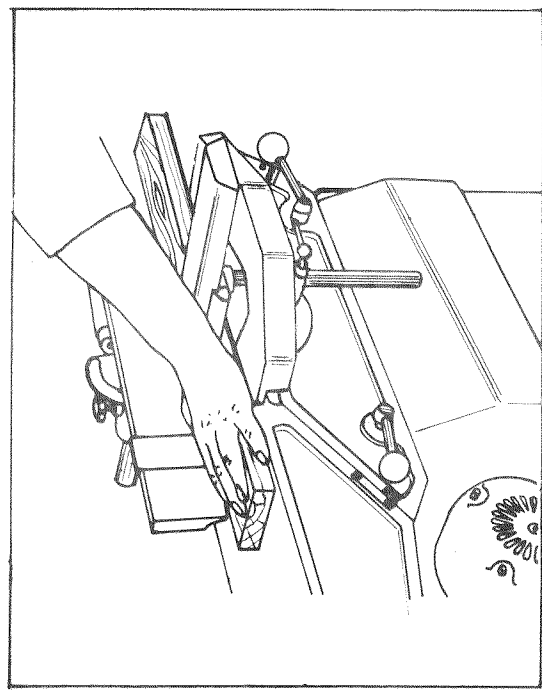
NOTE:-  
When ordering  
replacement parts  
quote Part No. and  
Serial No. of the  
Machine.

Ref. No.	Part No.	Description
71.	B-S-1-B	1 Bolt, ball lever screw.
72.	B-1029/6	1 Rebate side bearing cover.
73.	B-1029/20	1 Cutterblock guard adjusting bar.
74.	A-1029/20	1 5/16" whit. x 1/2" long Socket head grub screw.
75.	A-1029/27	1 Front cutterblock guard.
76.	A-1029/51	1 Front cutterblock guard locking bolt.
77.	A-1029/51	1 3/8" whit. wing nut.
78.	A-1029/51	1 Front cutterblock guard bracket.
79.	B-1029/10	1 Front cutterblock guard bearing housing.
80.	B-1029/4	1 Rebate side bearing housing.
81.	B-1029/4	1 3/8" BSE left hand nut.
82.	5000-206	2 52 m/m internal circlip.
83.	DN205	2 F.B.C. sealed for life bearing.
84.	DN205	2 3/32" dia. fluted rivet.
85.	B-S-55	1 pr. Planing knives (9 1/4" long).
86.	A-1029/56	2 Strip for Cutterblock.
87.	A-1029/49	8 3/8" whit. nut.
88.	A-1029/48	1 Knife setting device stop plate.
89.	A-1029/47	2 Knife setting device end plate.
90.	C-1029/14	1 Knife setting device the bar.
91.		1 Wrench.
92.		1 1/4" across flats long arm hexagon dowel.
93.		4 1/4" dia. x 1 1/4" long groverlok spring.
94.		5 3/8" whit. x 1" long hexagon head bolt.
95.		1 Cutterblock washer.
96.		1 Cutterblock pulley (60 cycle drive).
97.		1 Cutterblock pulley (50 cycle drive).
98.		1 Drive side bearing housing.
99.		1 1/4" wide x 1 1/4" long feather key.
100.		1 socket head grub screw.
101.		2 1/2" whit. x 1 1/4" long dog pointed cutterblock spring.

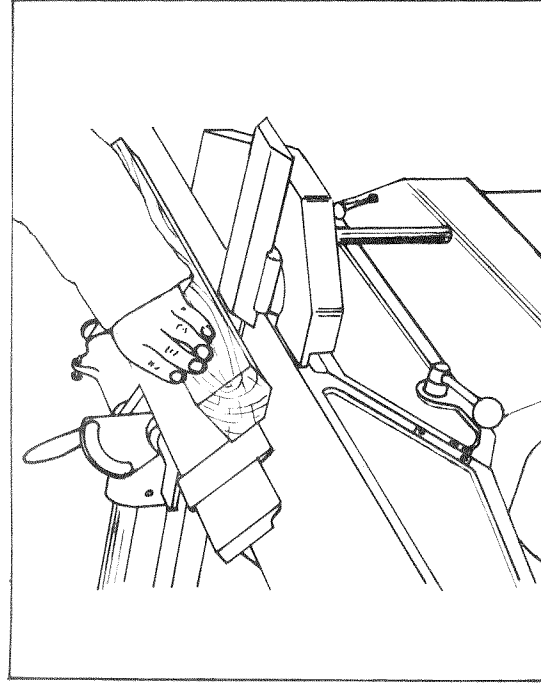
Ref. No.	Part No.	Description
71.	B-S-1-B	1 Bolt, ball lever screw.
72.	B-1029/6	1 Rebate side bearing cover.
73.	B-1029/20	1 Cutterblock guard adjusting bar.
74.	A-1029/20	1 5/16" whit. x 1/2" long Socket head grub screw.
75.	A-1029/27	1 Front cutterblock guard.
76.	A-1029/51	1 Front cutterblock guard locking bolt.
77.	A-1029/51	1 3/8" whit. wing nut.
78.	A-1029/51	1 Front cutterblock guard bracket.
79.	B-1029/10	1 Front cutterblock guard bearing housing.
80.	B-1029/4	1 Rebate side bearing housing.
81.	B-1029/4	1 3/8" BSE left hand nut.
82.	5000-206	2 52 m/m internal circlip.
83.	DN205	2 F.B.C. sealed for life bearing.
84.	DN205	2 3/32" dia. fluted rivet.
85.	B-S-55	1 pr. Planing knives (9 1/4" long).
86.	A-1029/56	2 Strip for Cutterblock.
87.	A-1029/49	8 3/8" whit. nut.
88.	A-1029/48	1 Knife setting device stop plate.
89.	A-1029/47	2 Knife setting device end plate.
90.	C-1029/14	1 Knife setting device the bar.
91.		1 Wrench.
92.		1 1/4" across flats long arm hexagon dowel.
93.		4 1/4" dia. x 1 1/4" long groverlok spring.
94.		5 3/8" whit. x 1" long hexagon head bolt.
95.		1 Cutterblock washer.
96.		1 Cutterblock pulley (60 cycle drive).
97.		1 Cutterblock pulley (50 cycle drive).
98.		1 Drive side bearing housing.
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101.		2 1/2" whit. x 1 1/4" long dog pointed cutterblock spring.



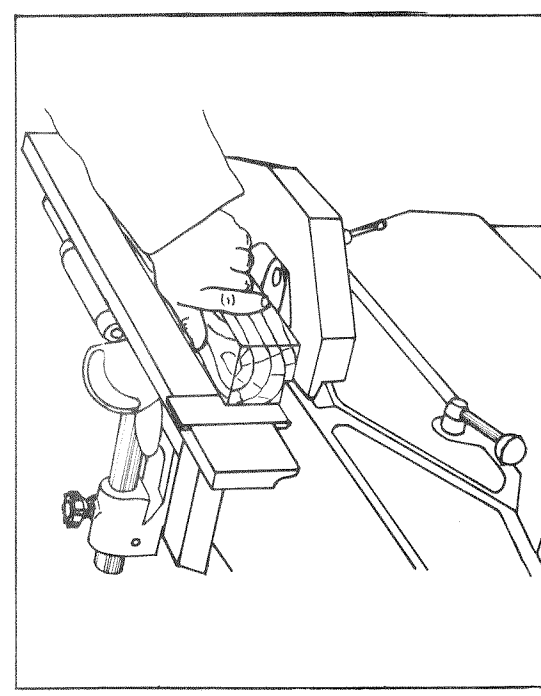
JOINTING (Rebate table is extra)



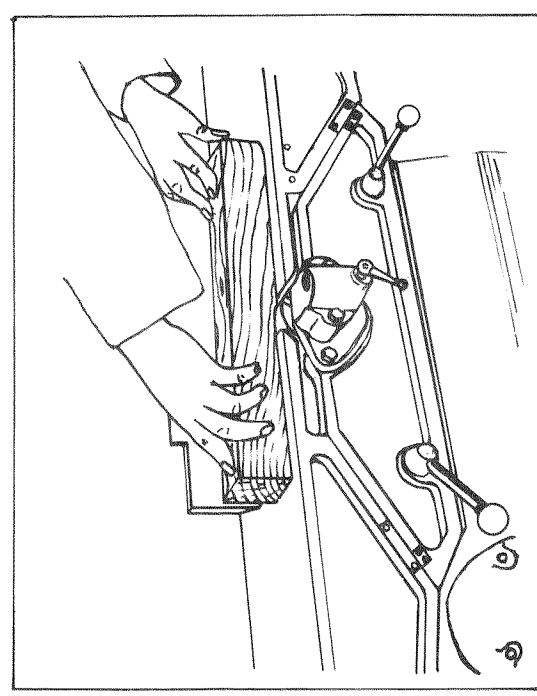
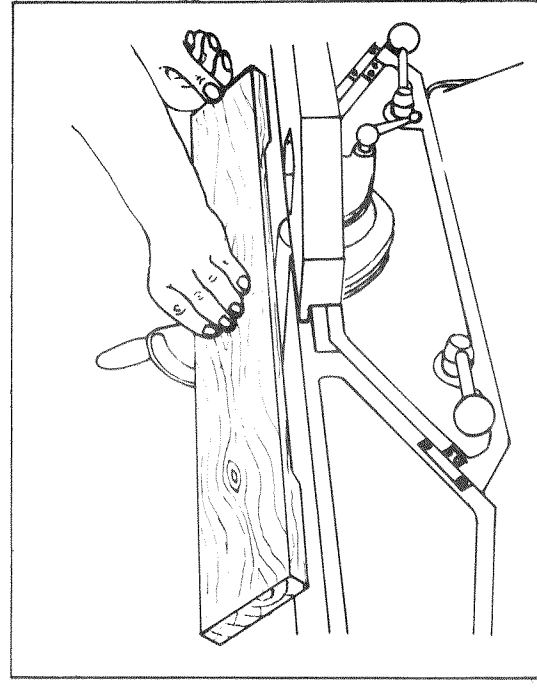
SURFACING (Rebate table is extra)



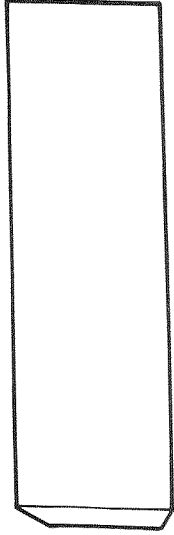
BEVELLING (Rebate table is extra)



REBATING (Rebate table is extra)

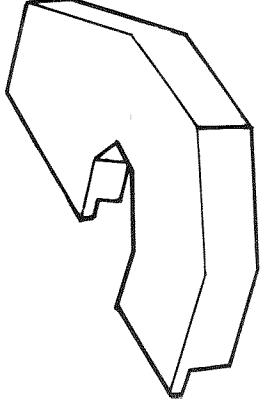


## EXTRA EQUIPMENT



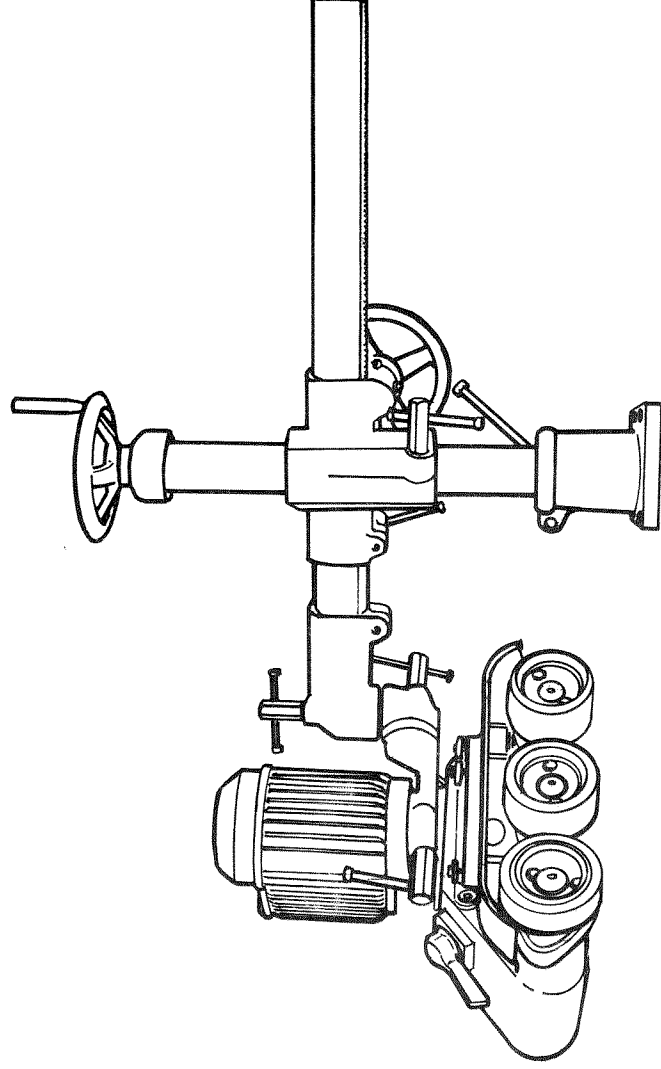
### PLANER KNIVES

9 $\frac{1}{4}$ " (235mm) long H.S.S. planer knives B.V.P.37 in pairs or sets of three



### REBATE TABLE

A rebate table can be supplied for fitting to the front planing table



### POWER FEED UNIT TYPE BLG. 8

The feed unit is supplied with 3 independently sprung rubber tyred feed rollers, two speed electric motor of 0.5/0.7HP and including reversing switch giving 8 feed speed of 6, 13, 16, 19, 33, 39, 49 & 99 feet per minute (2, 4, 5, 6, 10, 12, 15 & 30 m/ min)

Standard equipment includes universal stand for horizontal and vertical working, spanner and grease gun.

Please state voltage required.