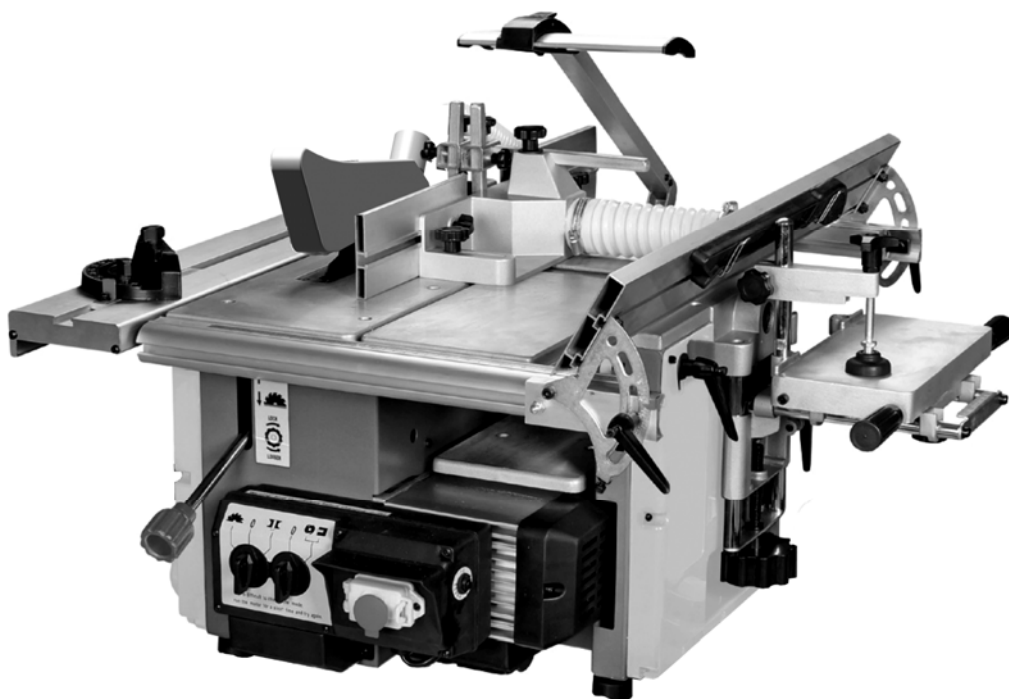


# Operator's Manual

## Combined woodworking machines



**CAUTION:** Read and follow all Safety Rules and operating Instructions before First Use of this Product.  
Keep this manual with tool.

1410-ZH06

## **Introduction**

To enjoy your new machine as long as possible, please read carefully the Operating Instructions before using it. Further, we recommend keeping the Operating Instructions to recall the product features in the future.

Within the continuous product development, we reserve the right to make technical changes to improve it.

Any reprints, even partial, are subject to approval.

This document represents translation of the original Operating Instructions.

## **Warranty**

The express approval of manufacturer is required before technical modifications of any kind are carried out or the unit is used out of accordance with the instruction.

Please contact your supplier in case of any guarantee claims.

Any actions with regard to the guarantee may only be dealt with by the authorised supplier

Any repairs after the expiry of the guarantee period may be carried out by any qualified personnel

## **Use as designated**

This machine has been designed for cutting wood and plastic materials. You must not cut metal with the machine.

The machine cannot be used for works other than for which the machine has been designed and that are specified in the Operating Instructions.

Any other use is a use in conflict with the designation. The manufacturer will not be liable for any consequential damage and injuries. Please be sure to know that the machine has not been designed for industrial purposes.

## **Operator requirements**

The operator must carefully read the Operating Instructions before using the machine.

### **Qualification**

No special qualification is necessary for using the machine apart from detailed instruction by an expert.

### **Minimum age**

The machine can only be operated by persons over 18 years of age. An exception includes youngsters operating the machine within their professional education to achieve necessary skills under trainer's supervision.

### **Training**

Using the machine only requires appropriate instructions by a professional or reading the Operating Instructions. No special training necessary.

# Technical Specification

<b>Drive:</b>	
Voltage/frequency:	230V / 50Hz
Motor Power	1000W P1
Motor protection	yes
Motor speed	2800 1/min
<b>Surface planer</b>	
Plane width	154 mm
Length of table	620 mm
Max. width acceptance	1.5 mm
Number of cutting blades	2
Cutting block speed	6000 1/min
<b>Thicknesser</b>	
Pass-through width	154 mm
Pass-through height	92 mm
Table length	315 mm
Max. width acceptance	1 mm
Feed rate speed	7m/min
<b>Table saw</b>	
Table size	620X310 mm
Blade size	200X30X2.6/1.6mm
Cutting height	42mm(with guard in place)
Blade speed	4200 1/min
<b>Shaper</b>	
Tool acceptance	12 mm
Tools	6/8 mm
Shaft height adjustment	0--42 mm
Rotational speed	9000 1/min
<b>Mortiser</b>	
Tool acceptance	13 mm
Tools	6 / 8 /10 mm
Drill depth	45 mm
Vertical movement	60 mm
Horizontal movement	95 mm

## SAFETY INSTRUCTIONS

**WARNING:** When using electric tools, basic safety precautions, including the following, should always be followed to reduce the risk of fire, electric shock and personal injury. Read all these instructions before operating this product and save the instructions.

**CAUTION:** Read and follow all Safety Rules and operating Instructions before First Use of this Product.

Keep this manual with tool.

### The symbols used in this manual and the label of the machine.



Read the handbook before start up.

#### Danger Symbols



Attention  
General safety notice.



Risk of electric shock!  
Risk of personal injury by electric shock

#### Symbol of Prohibition



Be careful when starting the machine  
Remove tools



Keep your work place neat!  
A messy work place can lead to accidents!



Keep your work place neat!  
A messy work place can lead to accidents!

#### Symbols of Obligation



Wear a dust mask



Use hearing or ear protection



**Wear safety goggles**



**Wear non-slip safety shoes**

## **Other symbols**



**Saw**



**Router**



**Surface planer and thicknesser**



**Mortiser**



**Lower the saw blade**



**Upper the saw blade**



**Lock the saw blade height or loosen to change the saw bale height**

## GENERAL

Please pass this safety information on to all persons who work with the machine. People who operate this machine must have read the instructions for use and, in particular, the chapter concerning safety information. Once they have begun work, it is too late. This is especially the case for personnel who only occasionally use the machine, for example when the machine is to be equipped or maintenance work carried out.

- Pay attention to all safety and danger information on the machine.
- Keep all safety and danger information on the machine completely and in a legible condition.
- Check the line cables. Do not use defective electrical connections.
- See that the machine is firmly situated on a firm ground
- Make sure that there is adequate light in the work place and near the machine
- Take care when working, rotating cutting tools present danger of bodily harm to fingers and hands.
- When the machine is in use, all protective equipment and covers must be mounted.
- Keep all other people, especially children, away from the work area and the machine when it is plugged in as well as its cables.
- Make sure that children do not have access to the machine when it is not in use.
- Do not overtax the equipment and use it only within the performance parameters described in the technical data section of the information for use.
- Do not use the cable for uses other than that for which it is intended. Protect the cables from heat, oil and sharp corners.
- Keep the hand holds dry, clean and free of oil and grease.
- Before the machine is switched on, check that keys and other preparatory tools are removed from it.
- Be alert and pay attention to what you are doing. Be sensible about your work. Do not use this machine when you are not able to concentrate. Do not use this machine when you are tired or under the influence of alcohol, drugs or medications.
- The operator must be at least 18 years old. People in training must be at least 16 years old, and may only operate the machine if they are supervised.
- People operating the machine should not be distracted.
- Keep the service area in good order; remove saw dust and wood shavings. A disorderly work area can lead to accidents.
- Protect the machine from rain and dampness.
- Do not operate the machine in a damp or wet environment.
- Store the machine in a safe place, so that nobody can be injured by the machine or inadvertently switch it on. Do not let the machine stand without protection outdoors or in a damp environment.
- Only operate the machine according to the appropriate uses.
- Do not operate the machine where there is danger of fire or explosion.
- When using this piece of equipment, avoid physical contact with grounded items (for example pipes, radiators, electrical stoves, refrigerators).
- Wear close fitting cloths. Remove jewelry, rings and watches.
- When operating the machine wear hearing protection, protective glasses as well as a dust protection mask.
- Wear a cap or hair net to protect long hair.

- The safety equipment on this machine may not be removed or made useless. Carry out changes, adjustments, measurement or cleaning work only when the motor is turned off. Unplug the machine and wait until all rotating tools have come to a standstill.
- Installation, repairs, and maintenance work on the electrical equipment may only be carried out by a specialist.
- All protective and safety devices must be immediately reinstalled after repair or maintenance work has been carried out. In order to deal with problems, turn the machine off. Pull out the plug!
- Use an exhaust extraction system to remove wood chips or sawdust. The current speed at the vacuum heads must be 20 m/s.
- When the machine is moved, even a small distance, it must be disconnected from the electrical current. Before starting the machine up again it must be connected to the electrical supply in an orderly way.
- The operator must turn off the motor when he leaves the workplace. Pull out the plug! Unplug the machine when it is not needed.
- Check the machine each time it is started up to make sure that the protective equipment and the switches are in order. Do not use the machine if the protective equipment, the switch, the electrical connections, the plug or other parts of the machine are damaged.
- The machine should be anchored into the ground by means of screws when it is in operation.
- The machine must be grounded. The yellow/green (green) wire is the ground wire.
- The machine could be used only if it is connected to the effective chip and dust extraction system
- That tools according to EN 847-1:2005 could be used only
- That the dust extraction equipment is to be on before commencing machining
- If push stick and push block would be damaged please contact to service store be replace it immediately
- Below function should be inspected before operation:
  - 1). Emergency stop(s)-by function
  - 2). Interlocked guard: by opening each guard in turn to stop the machine and by proving the inability to start the machine with each guard in the open position
  - 3). Anti-kickback fingers: by inspection at least once every working shift that they are in good working condition e.g. the contact face for impact damage and that the fingers fall freely under their own weight

### **Special safety instructions for the planer and thicknesser**

- Do not use dull cutting blades since this increases the danger of kickbacks.
- The part of the cutting block that is not in use must be covered.
- When short pieces of wood are to be planed, use a pusher to position the work pieces.
- Use extra aides when planing narrow work pieces, such as, for example, horizontal pushers, spring mounted protective units.
- Do not use the machine to notch or harrow wood.
- Regularly check that the planing wave and the kickback safety are working properly.
- Regularly check that the kickback safety is functioning properly.
- Never plane deeper than 1.5 mm.
- Use only well sharpened planing cutting blades in order to work better and more safely.
- Do not use cracked planing cutting blades, or those which are no longer in their original form.
- Use suitable aides to support heavy or bulky pieces when they are to be planed. Such aides include the extra units: jack up and universal trucks.

- Check regularly that the planing cutting blade and the cutting blade openings on the cutting blade waves are securely fastened.
- The cutting blade may only stick out a maximum of 1 mm or 10% above the cutting blade wave.
- When changing the planing cutting blade, wear appropriate work gloves.
- When working on the planer and thicknesser, do not wear work gloves; safe in those cases when the work piece is rough.

### **Additional safety instructions for the table saw**

- The circular table saw should not be used to cut firewood. Keep the service area of the machine free from chips and wood debris.
- Only use well-sharpened saw blades that are free from cracks and deformations.
- Circular saws from high-performance steel may not be mounted on the machine.
- The riving knife is an important protective unit, which leads the work piece into the machine and closes the cut behind the saw blade, thus preventing kick back of the work piece. Make sure that the riving knife has the right thickness: It may not be thinner than the saw blade and not thicker than the breadth of the saw kerf.
- The protective cover must be lower each time the work piece is fed.
- The protective cover must be parallel to the saw blade each time the work piece is handled.
- For long cuts on small work pieces -- less than 120 mm -- a pusher must be used. This pushing cane must be used to prevent the operator's hands from coming near the saw blade
- Turn off the machine before beginning repairs or attempting to remove pieces of wood caught in the machine. Pull out the plug!

### **Additional safety instructions for shaping work**

- Use the correct end stops and covers.
- Pay attention to the torque direction of the tools and the correct entry direction.
- Lead the work piece into the machine against the direction of rotation.
- Use the pressure edges to guide the work piece and as protection against kick back.
- Use the appropriate table cover for your tools.
- Do not touch the tool after the work is done. It can get quite hot and burn your skin.
- Only use shapers that are in perfect condition.
- Always use the correct taper sleeves.

### **Additional safety instructions for mortising**

- Only use well-sharpened drill heads that are in perfect condition.
- Work with limited dust, take up and drill in stages.
- Be sure that the work piece is led in securely, use a work piece vise.
- Do not touch the tool after the work is done. It can get extremely hot and burn your skin.

## **Appropriate Use**

The machine corresponds to the valid EC Machine Norms.

- Before beginning work, all protective and safety equipment must be mounted on the machine.
- The machine is conceived to be operated by one person.
- Pay attention to all safety and danger warnings on the machine.
- All safety and danger warnings on the machine must be kept legible.
- The maximum measurement of work pieces may not exceed the standard size of the table.



- Should larger work pieces be handled, such that the table top must be tipped, a table extension or a jack up truck (extra accessory) must be used.
- If the machine is used in an enclosed space, then an exhaust extraction system must be hooked up to it.
- Use the machine only when it is in technically perfect condition and only for appropriate jobs, with an awareness of safety and possible dangers, based on observation of the operating instructions! In particular, problems which could influence the safety of use must be immediately dealt with!
- All of the manufacturer's safety, work, and maintenance regulations as well as the given norms in the Technical Data must be observed.
- The appropriate accident prevention rules and all those generally recognized safety rules must be observed.
- The machine may only be used, maintained or repaired by those persons who understand and have been instructed in the potential dangers. Independent changes in the machine cancel any manufacturer's liability for any damages that result from these changes.
- The machine may only be used with the manufacturer's original parts and tools.
- Note: the use of tools or equipment other than those specified in the operating instructions can mean danger for the user.
- Any use beyond what is specified here is not appropriate. The manufacturer is not liable for any damages which result from inappropriate use; the entire risk is carried by the user.
- Do not lean too far forward.
- Always stand firmly on the ground and maintain your balance.
- Always concentrate on your work. Do not work with the machine when you are tired or under the influence of drugs or alcohol.
- Check the machine for damaged parts. If protective equipment or any other part is damaged, check carefully before you continue your work whether it functions properly. Test the release of moveable parts and make sure they can move freely. Be certain that there are no breaks, cracks or other conditions that could negatively influence the functioning of the machine. Damaged protective equipment or other parts that are defective must be repaired or replaced by a recognized customer service center unless otherwise specified in the operating instructions.
- Have defective switches replaced by a recognized customer service center. Do not work with the machine if the ON/OFF switch or the speed of rotations cannot be moved properly.
- Make sure that the electrical current corresponds to the requirements of the type label on the machine.
- Treat your tools with care: they can be extremely sharp.
- Before starting work with the machine, make sure that objects such as nails and screws have been removed from the work piece.
- Keep your hands away from rotating tools.
- When turning on the machine, the tools may not touch the work piece.
- Once you have turned on the machine, let it run for a while before you make the first cut. Pay attention to any vibrations or drumming which might indicate an improperly mounted tool.
- Pay attention to the rotational direction of the tool and the correct entry direction of the work piece.
- Do not leave the running machine unattended.
- Do not touch the tool after the work has been completed. It can be extremely hot and can burn the skin.
- Rags, cables and similar items should not be left on the work surface when the machine is in operation.

- After the machine has been in operation for a long period of time, external metal parts and equipment can get hot.
- Turn the machine off and wait until the tool has come to a complete stop before removing the work piece from the table
- Support the work piece properly.
- Use extra aides, such as horizontal holders, for working on smaller work pieces.
- Do not let the machine stand in the rain.

**.Warning: The use of any equipment or external parts that is not recommended in this operating instruction can lead to bodily harm.**

**This product may only be used for the purposes for which it was made. Any other use which is not described in these operating instructions is understood to be inappropriate. The operator, and not the manufacturer, is responsible for all damages or injuries which result from improper use.**

## **Remaining hazards**

**The machine has been manufactured according to technical standards and recognized safety rules. Still, when working with the machine, certain residual risks can come about.**

- There can be danger or injury to fingers and hands due to rotating tools when the work piece is led into the machine in an inappropriate manner.
- Wood dust or saw dust can present danger to health. It is imperative that the operator wear personal protection devices such as goggles. Use an exhaust extraction system!
- Danger of injury due to defective tools. Check regularly that the tools are in good working order.
- Danger of injury to fingers and hands when changing the tools. Use appropriate work gloves.
- Danger of injury when the machine is being turned on due to rotating tools.
- Danger due to the electrical current when the electrical connections are not properly installed.
- Danger to the operator's health due to the rotating tools if the operator has long hair and loose clothing. Personal protection devices such as hair nets and close-fitting clothing should be worn.
- In spite of all safety measures being followed there can still be obvious residual risks.
- Residual risks can be reduced when all the instructions in general are followed.

## **ELECTRICAL REQUIREMENTS**

**WARNING:** To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tools. To avoid shock or fire, if power cord is worn or cut, or damaged in any way, have it replaced immediately.

### **GROUNDING INSTRUCTIONS**

**WARNING:** This tool must be grounded while in use to protect the operator from electrical shock.

**IN THE EVENT OF A MALFUNCTION OR BREAKDOWN,** grounding provides a path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching receptacle that is properly installed and grounded in accordance with ALL local codes and ordinances.

**DO NOT MODIFY THE PLUG PROVIDED.** If it will not fit the receptacle, have the proper receptacle installed by a qualified electrician.

**IMPROPER CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with green insulation (with or without yellow stripes) is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment-grounding conductor to a live terminal.

**CHECK** with a qualified electrician or service person if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

**WARNING:** Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

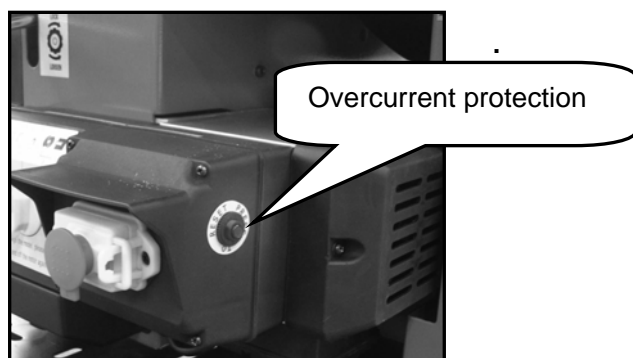
**WARNING:** This machine is for indoor use only. Do not expose to rain or use in damp locations.

## **GUIDELINES FOR EXTENSION CORDS**

**USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and cause overheating.

**Be sure your extension cord is properly wired** and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

**Attention: There is an overcurrent protection device in the circuit.**



## **ACCESSORIES AND ATTACHMENTS**

### **RECOMMENDED ACCESSORIES**

To avoid injury:

- Use only accessories recommended for this machine.
- Follow instructions that accompany accessories. Use of improper accessories may cause hazards.
- Use only accessories designed for this machine to avoid injury from thrown broken parts or workpieces.
- Do not use any accessory unless you have completely read the instruction or operator's manual for that accessory.

## **CARTON CONTENTS**

### **UNPACKING AND CHECKING CONTENTS**

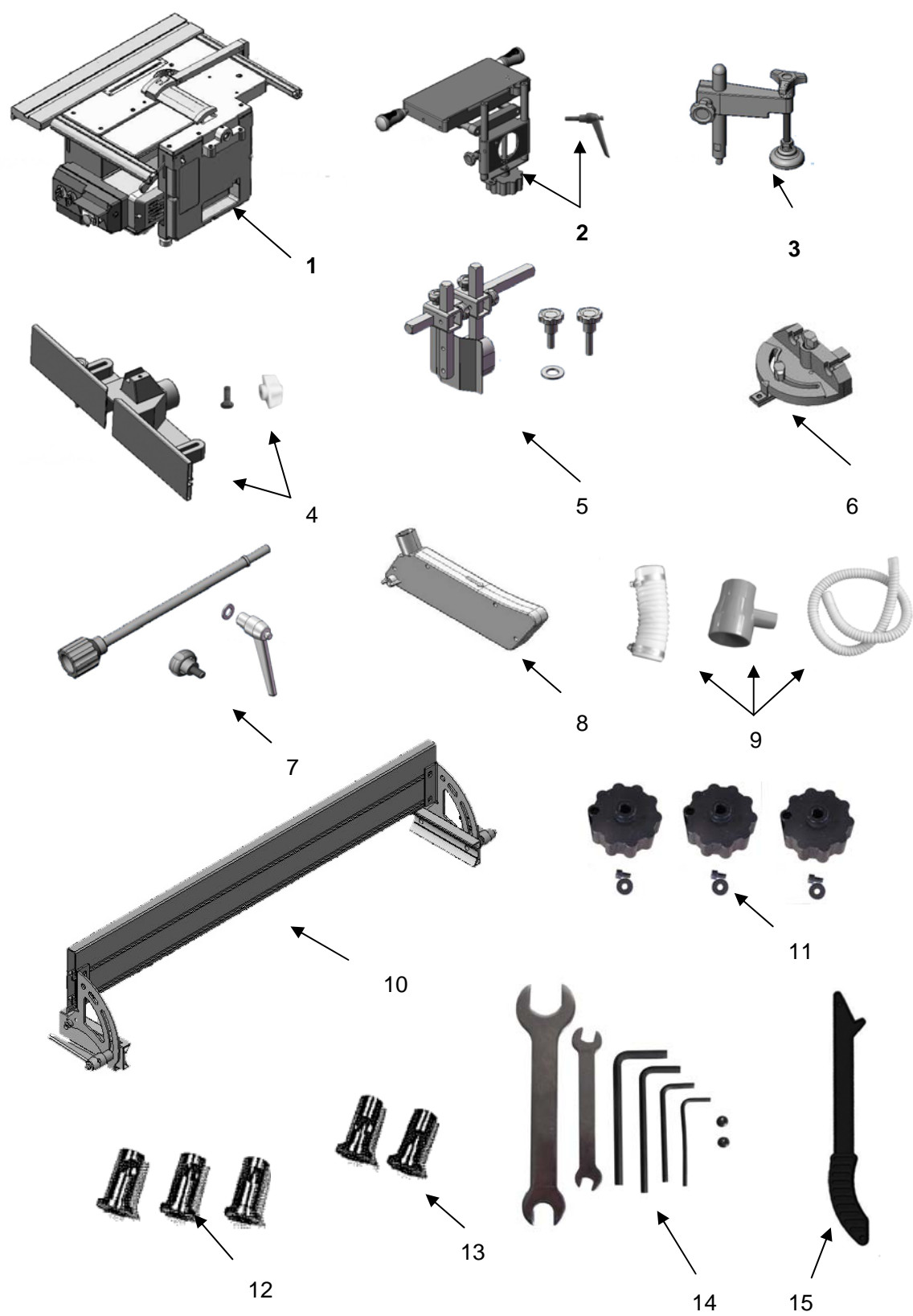
Carefully unpack the machine and all its parts, and compare against the illustration following.

#### **WARNING:**

- To avoid injury from unexpected starting, do not plug the power cord into a power source receptacle during unpacking and assembly. This cord must remain unplugged whenever you are assembling or adjusting the machine.
- If any part is missing or damaged, do not plug the machine until the missing or damaged part is replaced, and assembly is complete.

**TABLE OF LOOSE PARTS**

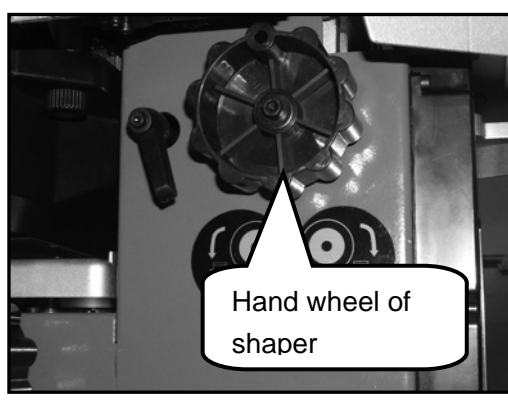
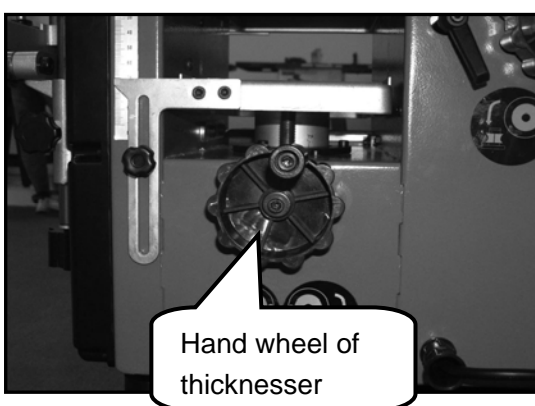
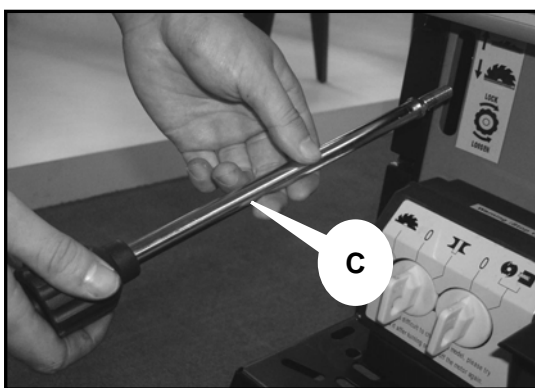
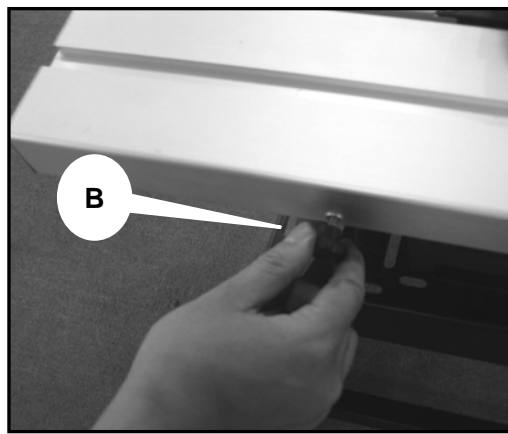
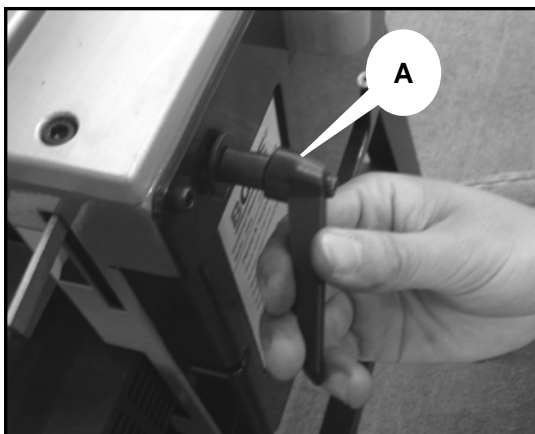
Unpack carton; check you machine to see parts listed below:



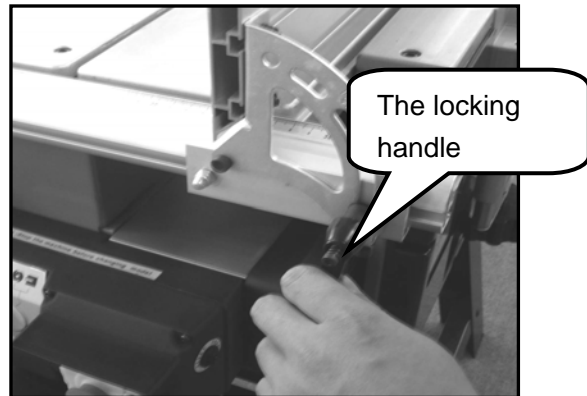
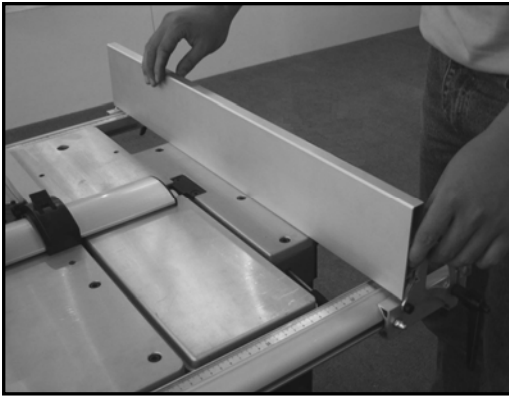
1. Combined woodworking machine
2. Mortising table assembly and lock knob
3. Mortising clamp arm assembly
4. Shaper fence assembly
5. Shaper protection guide and knob
6. Mitre gauge
7. Handle and knob
8. Saw guard assembly
9. accessory for dust collection
10. Planner and Saw fence
11. Hand wheel and bolt
12. Mortising cutter bushing
13. Shaping cutter bushing
14. Wrench and set screw
15. Push stick

## ASSEMBLY

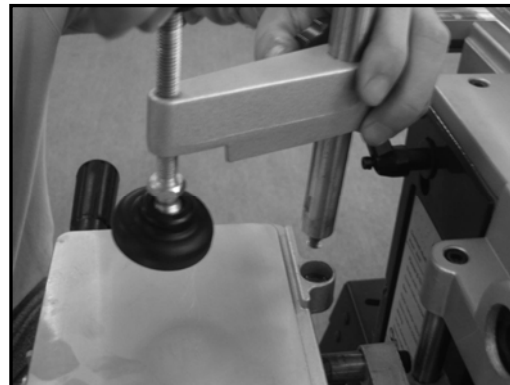
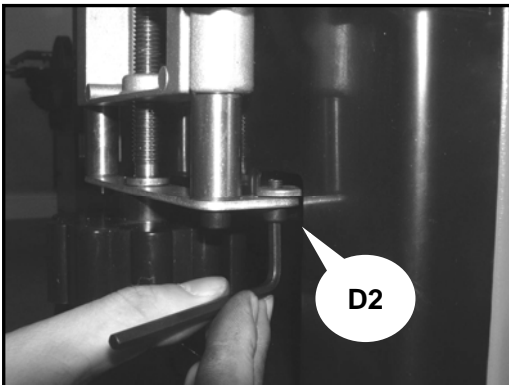
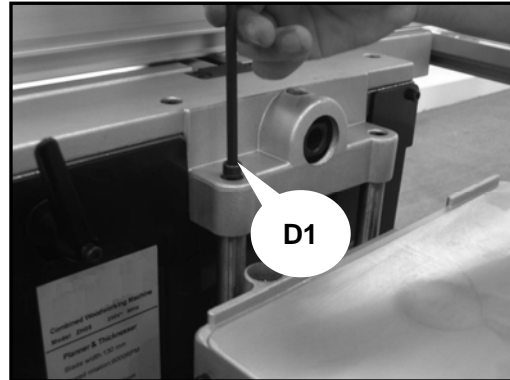
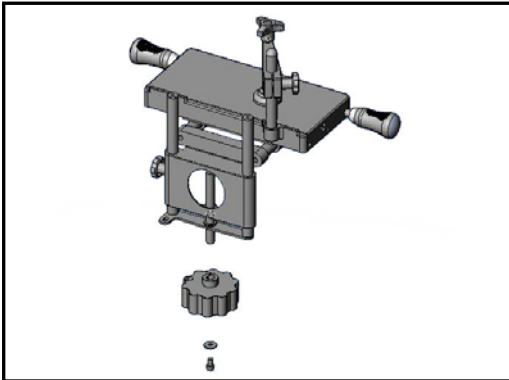
1. Mount the clamp handle (A) with a washer on the machine.  
Mount the lock knob (B) to square carriage.  
Push the height adjustment handle(C) through the front side saw and tighten it.  
Attach mitre gauge on the square carriage.  
Assemble the hand wheels of thicknesser and shaper.



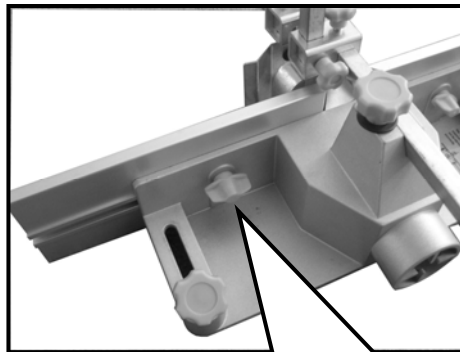
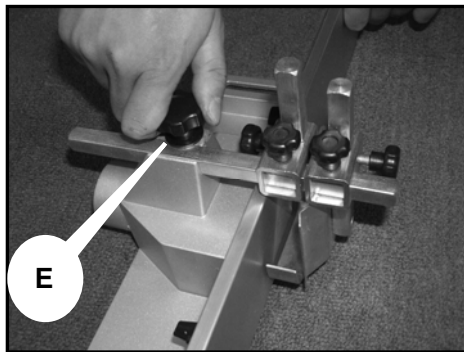
2. Attach the planer and saw fence assembly to the rail beside the table. Adjust it to the desired position and tighten with two locking handles.



3. Assemble the knob on mortising table assembly and attach them to the block beside table, fix them top and bottom with the socket head bolt (D1 & D2). Assemble the mortising clamp arm to the mortising table and tighten it with a wrench.



4. Assemble shaper protection guide to the shaper fence assembly with 8mm flat washer and the shorter knob (E),



Lock the plate with knob

## OPERATION

**Observe the safety instructions and symbols on machine before operation.**

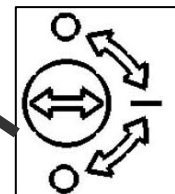
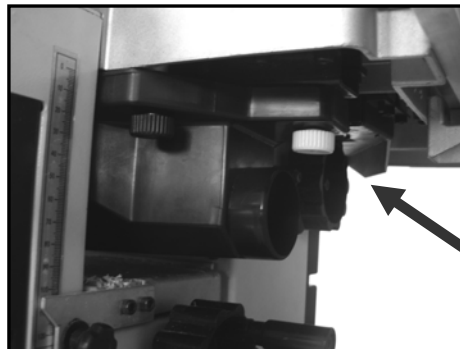
Do not turn the mode selection when the machine is in running position.

The mode selection is designed to prevent two or more functions to be start at the same time. Turn the function selecting knob to 0 before you would turn the selecting knob to any function

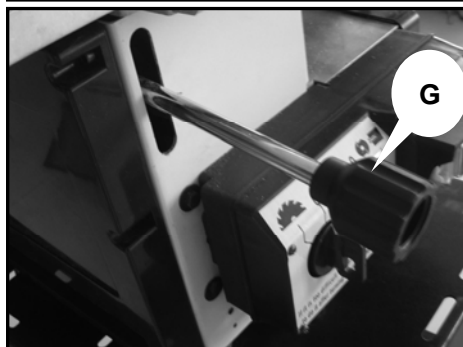
### 1. Saw function

Turn the mode selection to the Sawing Symbol (F).

Set the micro switch to "on" position.



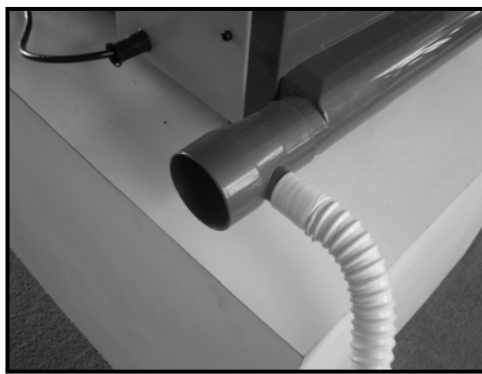
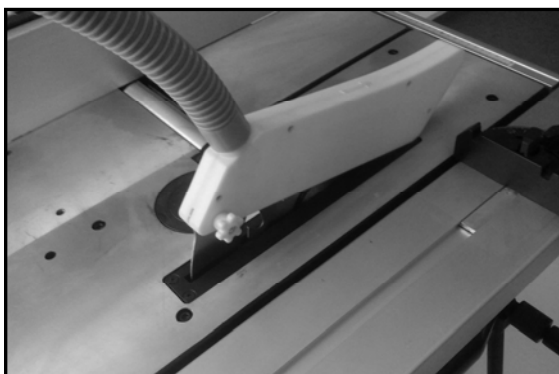
Upper or lower the handle (G) to adjust circular saw's blade to proper height, tighten the knob to lock the position.



Assemble the saw blade guard to the knife.

Assemble accessory for dust collection and connect it to the dust extraction system.

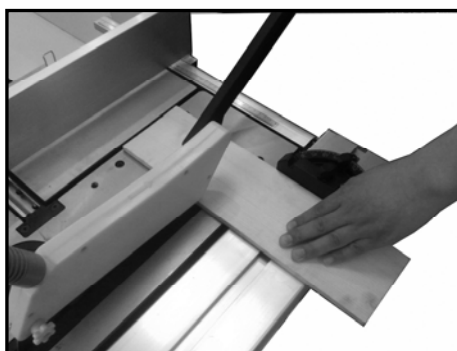
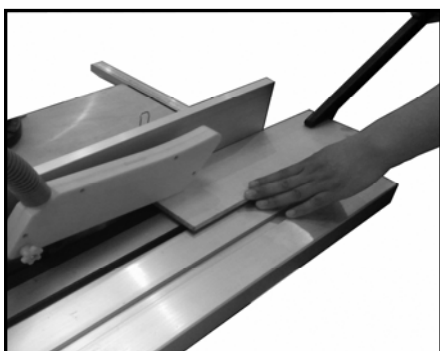
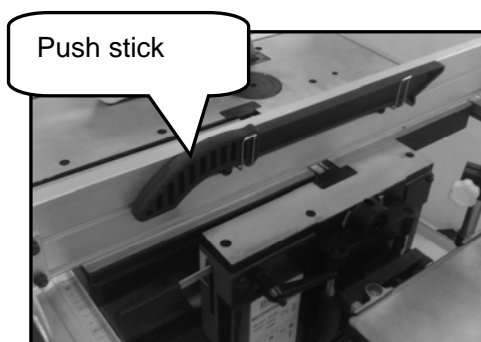
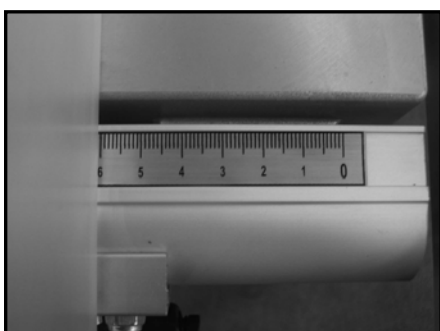




Slide the fence on the rail to the desired measurement on the scale. Tighten both locking handles beside the fence.

Turn on the machine and lead the workpiece carefully to the saw blade.

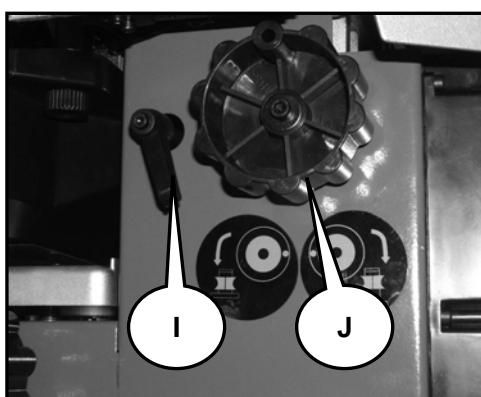
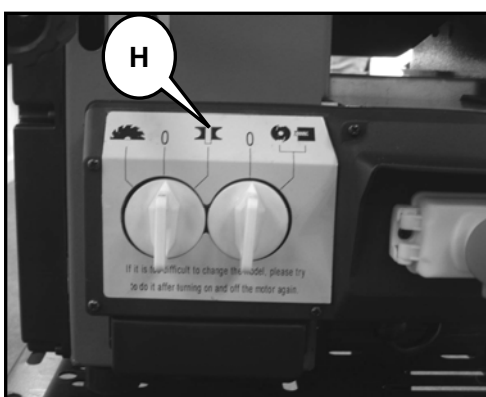
Use the mitre guide.



## 2. Shaper function

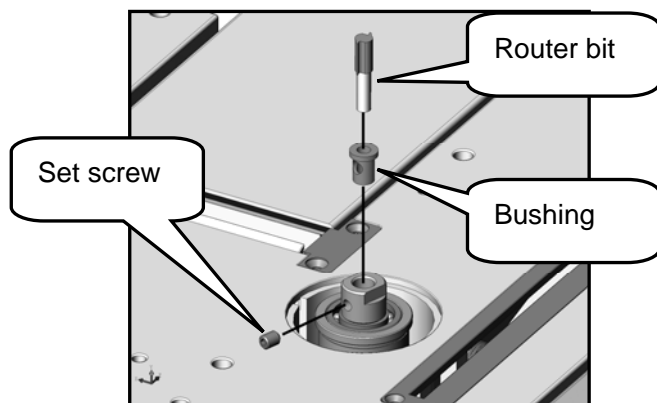
Turn the mode selection to the shaper Symbol (H).

Loosen the lock knob (I), adjust the spindle height by the handwheel (J).

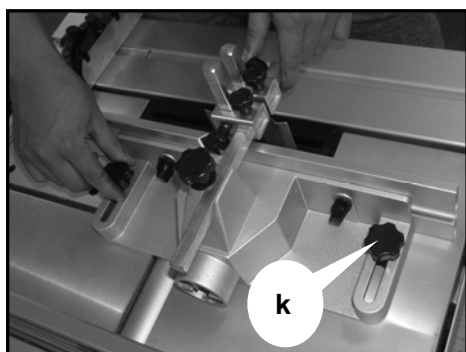


Fix the router bit with the appropriate bushing by equipment set screw and replace the shaper ring.



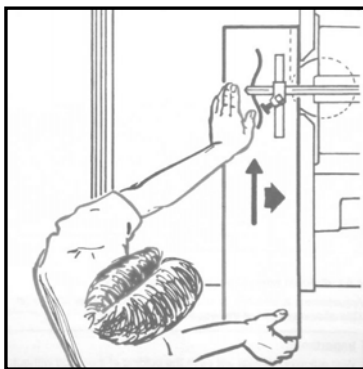
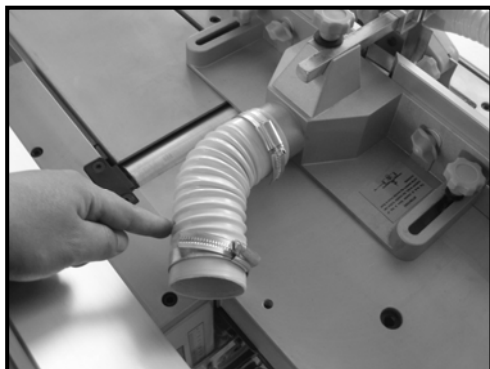


Mount the shaping fence assembly on the table and set the distance from the shaper.  
Tighten the knob (k) to set the micro switch “on”.



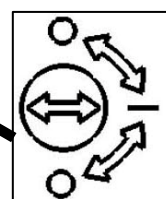
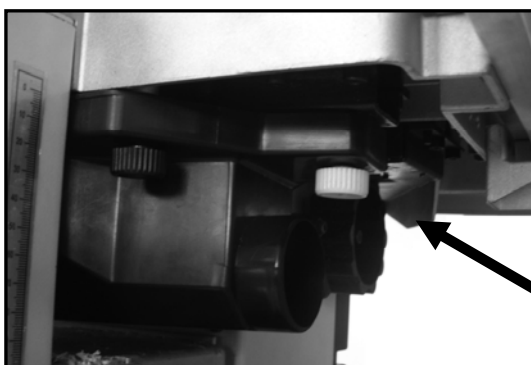
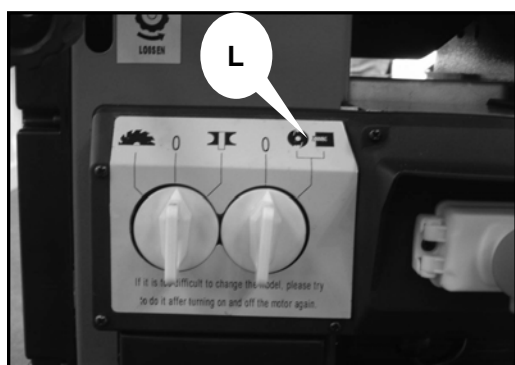
Connect to dust extraction system and turn on the machine.

Lead the workpiece to the fence and against the rotational direction of the shaper. Use the push stick if needed.

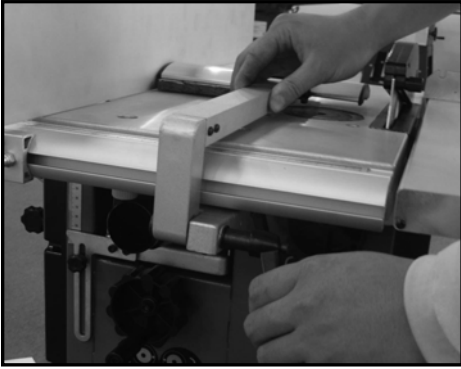


### 3. Surface planer and thicknesser

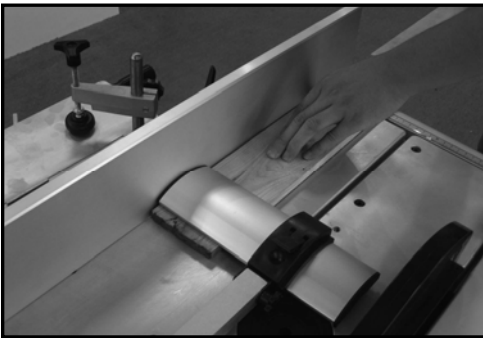
Turn the mode selection to the planing Symbol (L). Assemble the suction connector under the table and connect it to dust extraction system. Set the micro switch “on”



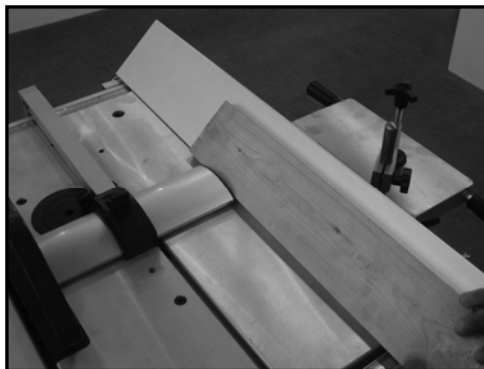
Adjust the bridge type guard to the proper height and lock the knob



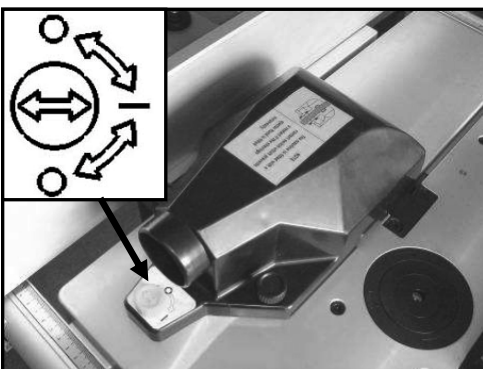
Turn on the machine and lead the work piece to the fence.



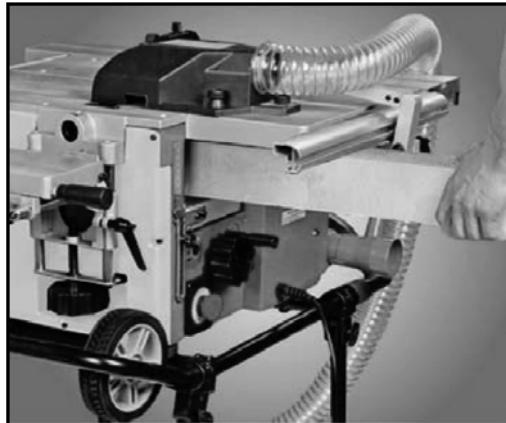
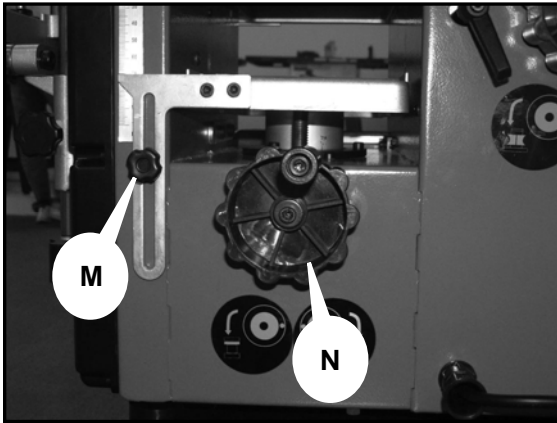
Adjust the fence to desired angle and tighten it on both sides. Lead the workpiece against the fence to cutting blade carefully.



For thicknessing, assemble the suction connector on the table and connect it to the dust extraction system. Set the micro switch "on"



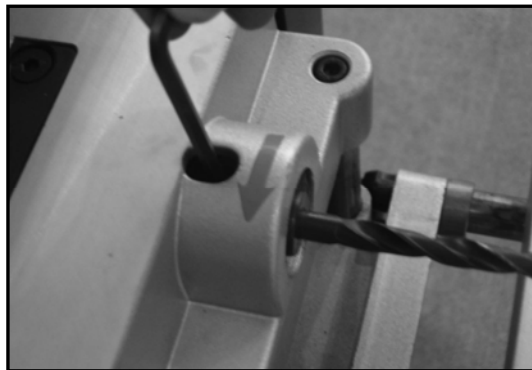
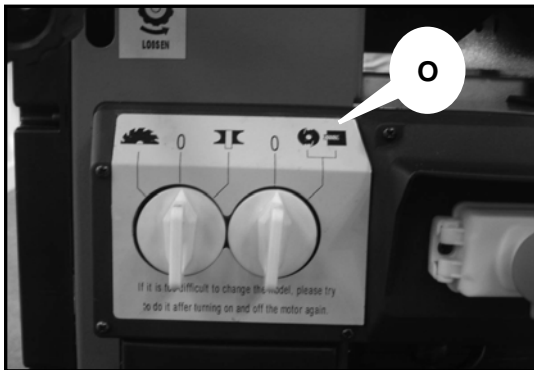
Adjust the table height by the handwheel (N) , lock the position by tighten the knob(M)



## 4. Mortising function

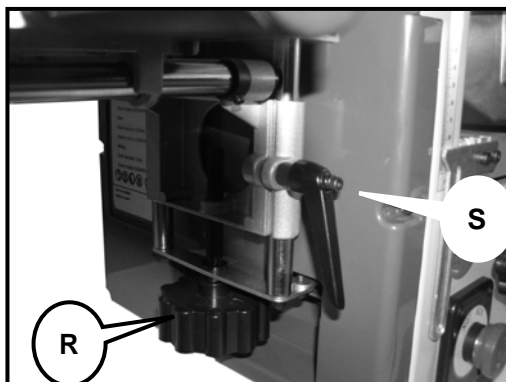
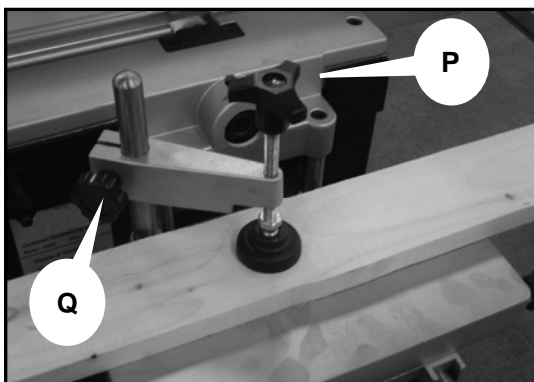
Turn the mode selection to the planing and mortising Symbol (o).

Mount the bit with bushing into the master shaft and lock it by using the equipment set screw.



Fix the wood workpiece to the mortising table by tighter the knob (P) and (q).

Adjust the table height by the adjusting the handwheel (R)) and fix it at a proper position by locking handle (S).



Start the motor in the mode of planing working and begin mortising

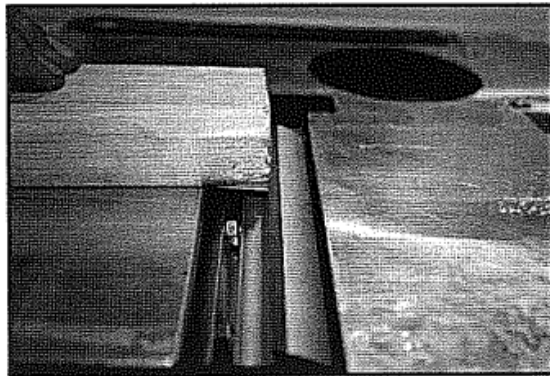
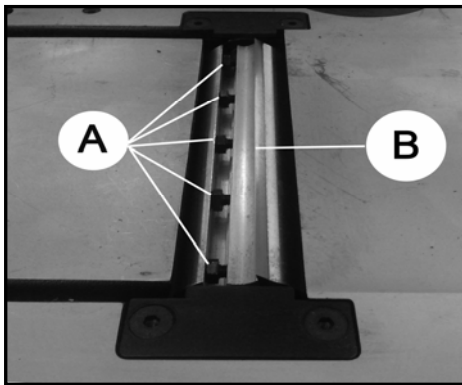
## MAINTENANCE

**Warning:** Turn off the machine and disconnect from the power supply before conducting maintenance work or settings.

### Replacement of planer cutting blades

- Unscrew Bolt A on the fixing cutting blade B.
- Remove the cutting blades.
- Replace new cutting blades.
- Get bolt approach to the cutting blade.
- Use a planed plank to adjust the cutting blade and make the cutting blade touch the plane workbench on Position 0.

**Caution:** The maximum allowable exposed part of the blade on the shaft is 1.1mm. Check if the bolts are locked before starting the machine.



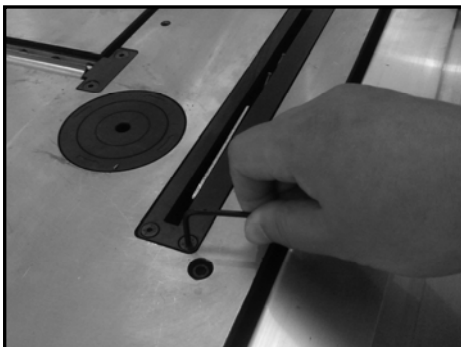
### Replacement of saw blade

**Warning:** Use blades that conform to En 847-1

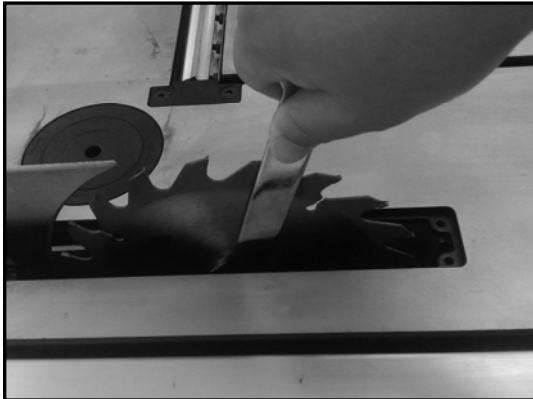
Unscrew the screws.

Remove the saw blade's protection plate.

Lower the lock lever and rotate the knob clockwise to lock the blade.

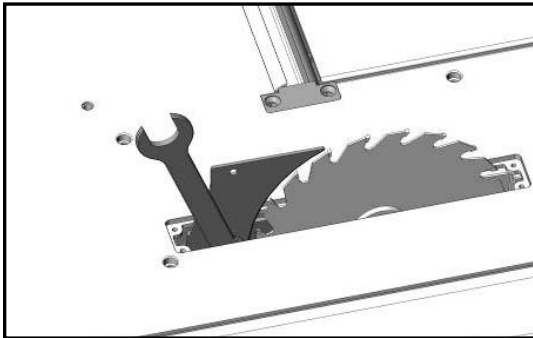


Use a maintenance wrench to rotate clockwise (left screw) and unscrew the circular saw's fixing nuts; remove the nuts, shim plate and circular saw; replace the circular saw and install them in the reverse order.

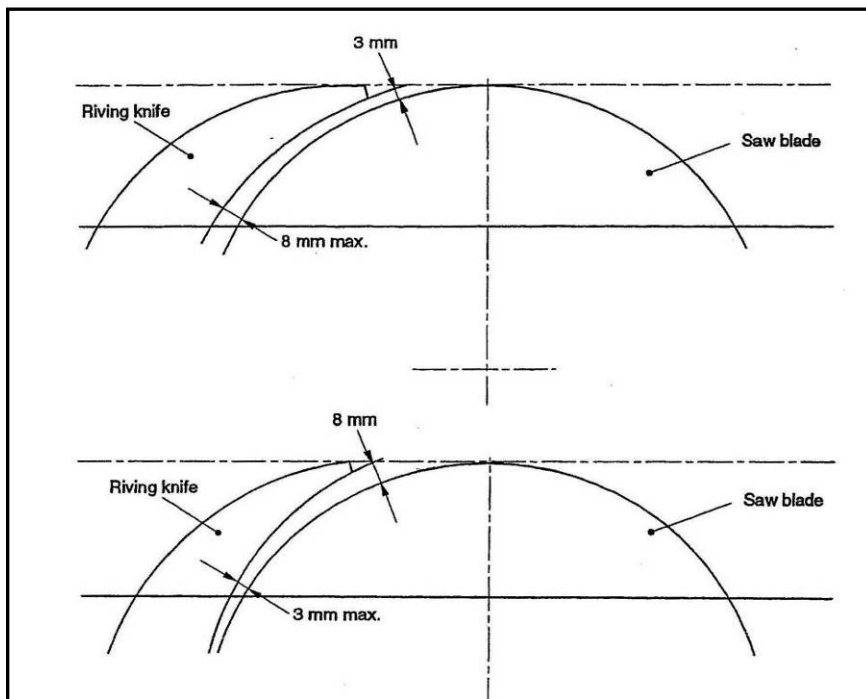


### Adjustment of riving knife

Use a maintenance wrench to unscrew the fixing nuts of the fixed dividing cutter.



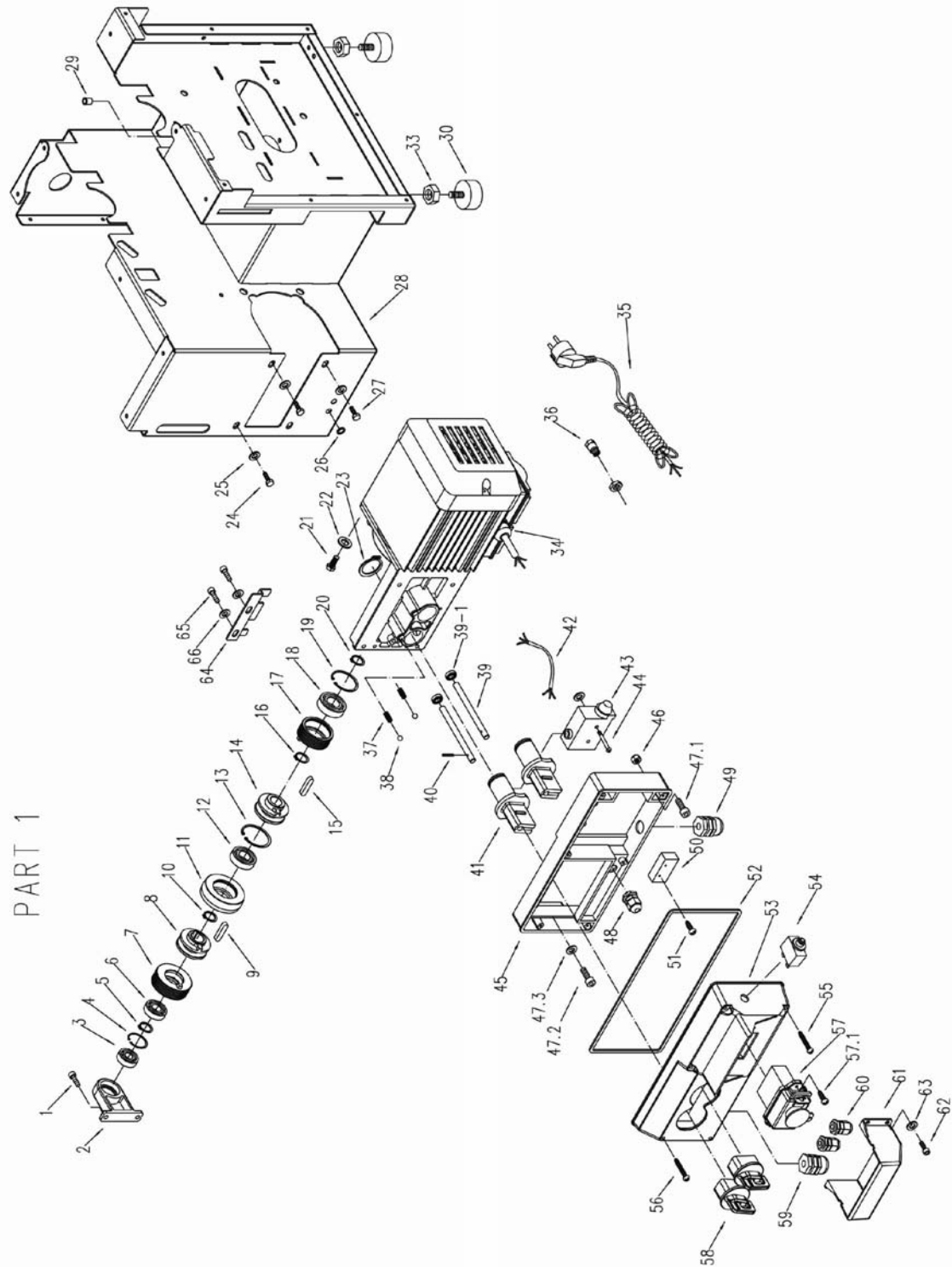
Adjust the space between the dividing cutter and the circular saw's sawtooth to 3 ~ 8mm.



## Troubleshooting Chart

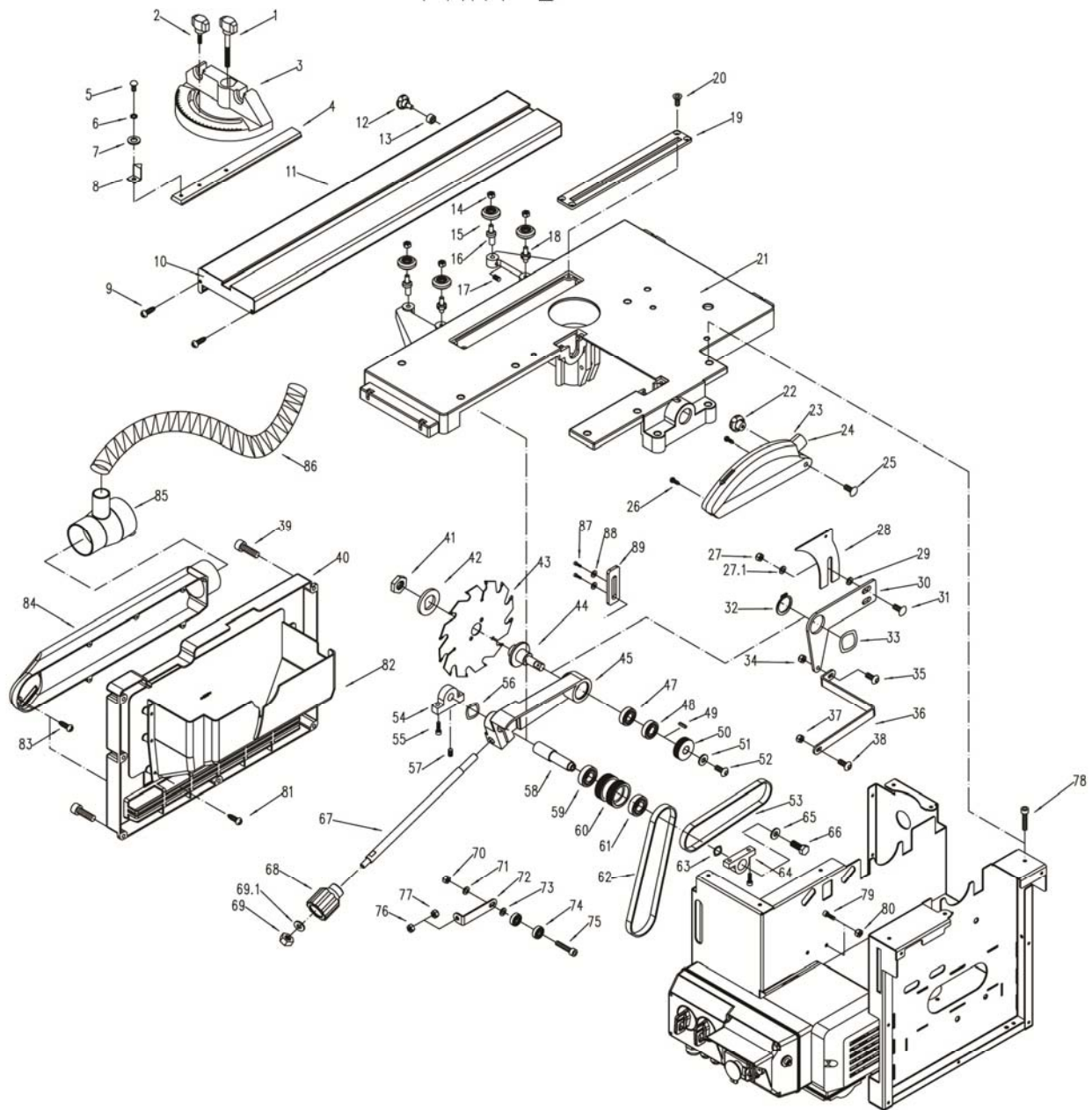
Failure	Cause	Remedies
Machine does not operate	Power shortage	Check the plug Check the cable Call for an electrician
	Circuit breaker cut power	Push to reset
	Emergency stop switch has been locked	Release it
	Interlock switch is off	Take it on
Surface and thickness planer does not run	Interlock switch is off	Assemble wood chip correctly, Take the interlock switch on
	circuit breaker	Push to reset. Check the electrical system if it still breaks.
		Release the emergency stop switch Correct the position of mode selector
Automatic feeding is intermittently when use the the thickness planer	The workbench is polluted by resin	Clean up with gas or solvent after the machine stops.
	The spring of feed roller needs to be adjusted	Check the spring
	There are wood chips between the roller seat and roller cover	Lift the roller with a lever and blow the spacing between roller cover and roller seat with air jet.
Jump at entrance when planing	The thickness planer workbench is not fixed	Lock the workbench with the lock knob(on the side of mortiser)
There are longitudinal cutting marks when planing	The plane cutter is worn	Replace or milling the cutter
Problem in the processing quality	The belt is loose	Tighten the belt
	Cutter	Mill the cutter
	Too much removal	Diminish the cut
The saw cutter does not work	The belt is loose	Tighten the belt
	Circular cutter	The disc cutter needs to be replaced or is not suitable for the processing, therefore, replace it.
Notches at Moulding entrance and exit	Unparallel guide	Rotate the knob leftwards or rightwards to make the two parallel guide rails aligned.
Retention time of saw and planer> 10 seconds	Loose belt	Tighten the belt; replace it if worn .
Retention time of moulder >10 seconds	Loose belt	Tighten the belt; replace it if worn .

# ASSEMBLY DIAGRAM



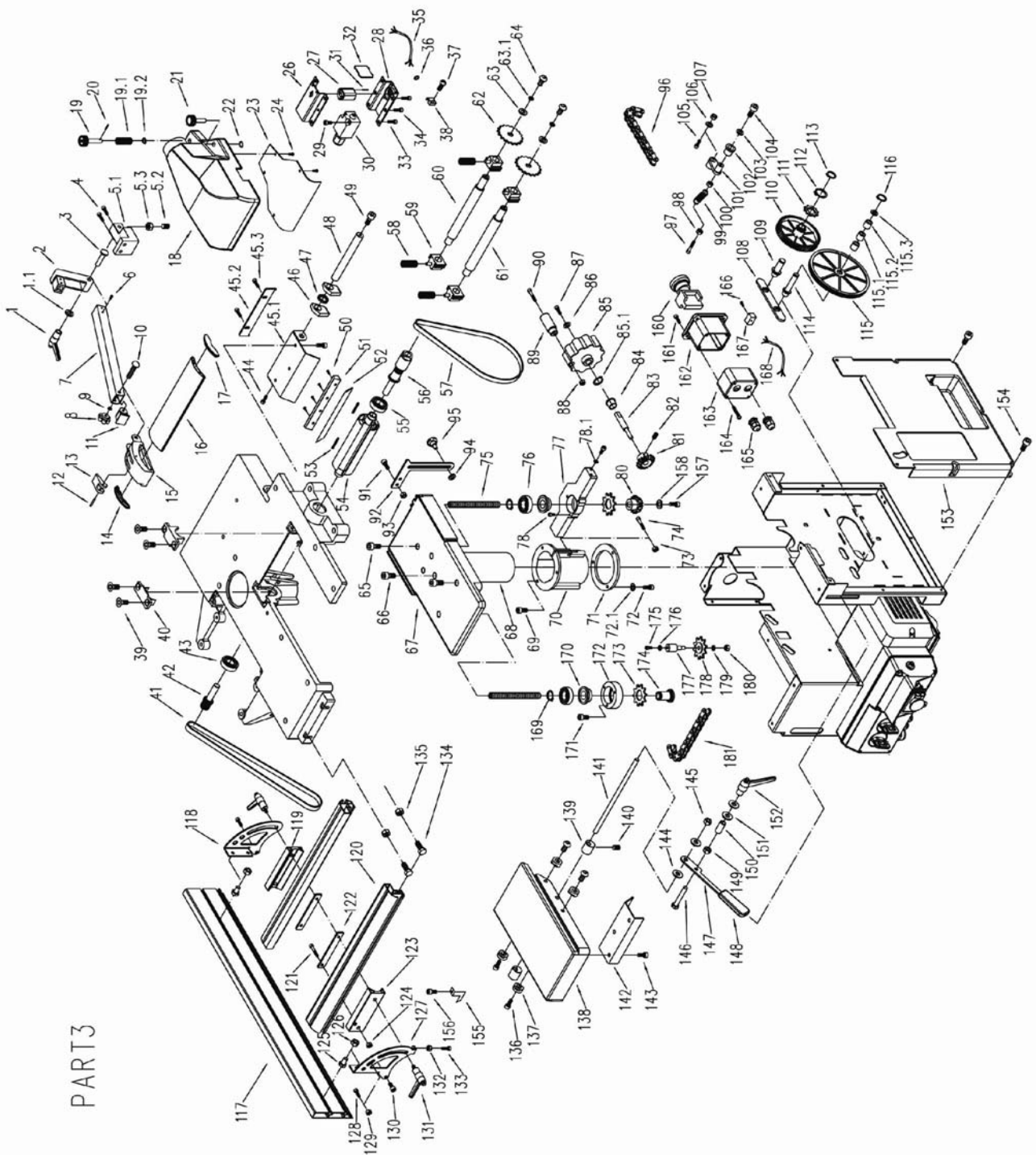


## PART 2

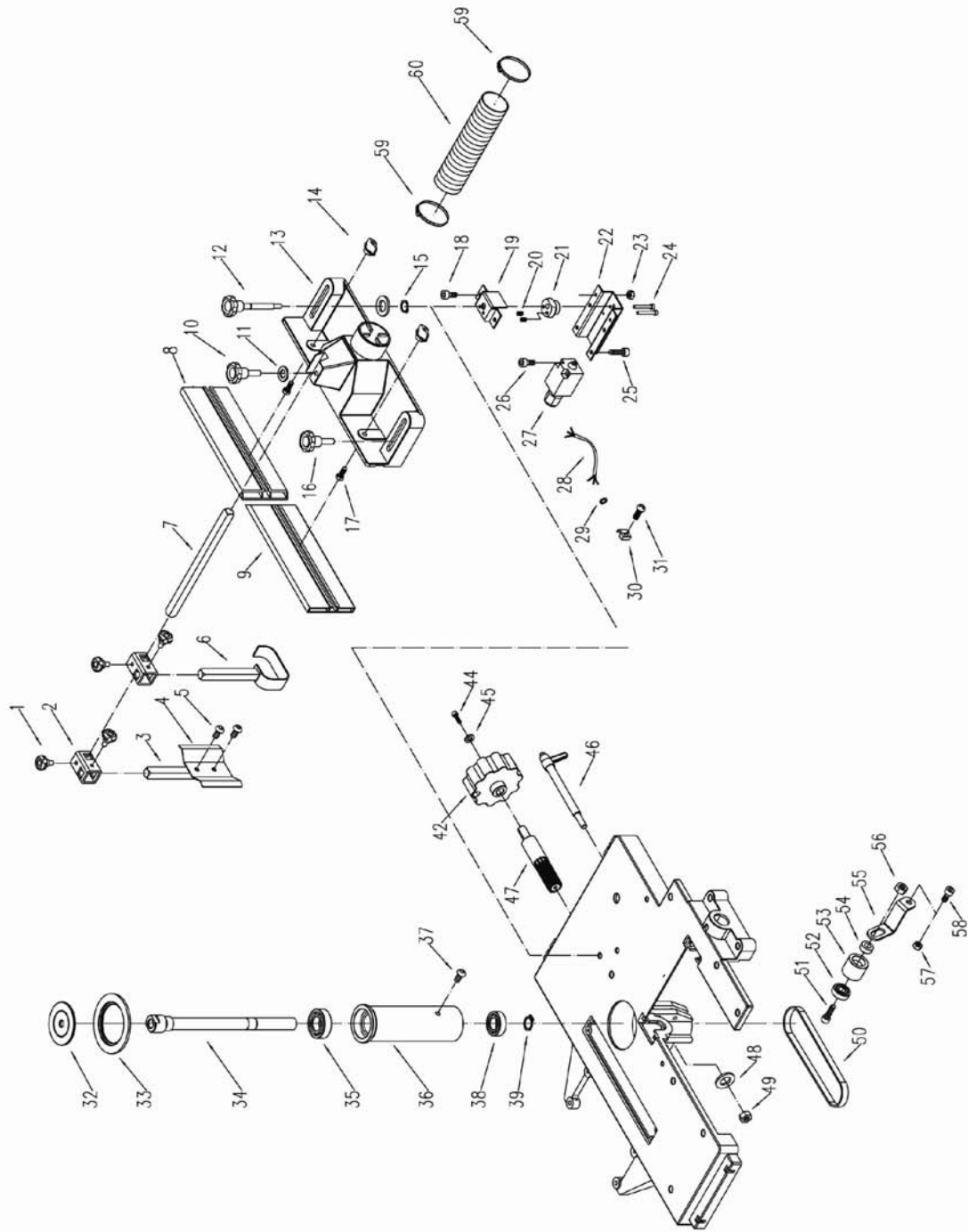




# PART3



# PART4



# PART5

