



AUTOPLANUS PLANER BLOCK



INST/IT/AUTO v1.0

Please read carefully before use

Thank you for purchasing this brand new cutter from Trend. This tool was designed and manufactured according to the European standard EN 847-1/2.

SAFETY

Observe the safety regulations in the instruction manual of the machinery and accessory/attachment to be used. Please read the following instructions carefully. Failure to do so could lead to serious injury.

PLEASE KEEP THESE INSTRUCTIONS IN A SAFE PLACE.

The attention of UK users is drawn to The Provision and Use of Work Equipment Regulations 1998, and any subsequent amendments. Users should also read the HSE/HSC Safe Use of Woodworking Machinery Approved Code of Practice and Guidance Document and any amendments. Users must be competent in using woodworking equipment before using our products.

INTENDED USE

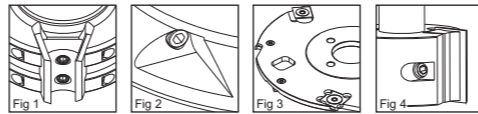
This cutter is intended to be used for machining wood and wood derived materials.

Maximum Speed (n.Max)

The maximum speed marked on the tool, or shown in the chart or on the packaging should not be exceeded. Where stated, the speed range should be adhered to.

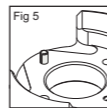
General Instructions

1. Before first use, please check that the screws (see fig. 1 – 4) are tightened correctly and the cutting edges are not damaged. If any of the screws are missing, or the cutting edges are damaged, do not use the cutter and return it to the distributor from where it was purchased.
2. Before putting the cutter on the machine spindle, please ensure that the recommended RPM etched on the cutter matches the RPM of your machine and the cutter is rotating in the correct direction.



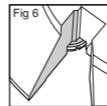
Example for tightening screws

3. If the cutter is a set, please check every part of the set individually and only assemble according to the supplied instructions. Only assemble the parts in a way that is allowed by the positioning pins (see fig. 5)



Positioning pin

4. Don't remove, reassemble, or replace parts that will change the characteristics of the original cutter. Removing, reassembling or replacing parts of the cutter could invalidate the guarantee.



Knife seat area

5. Handle the tool carefully. Cutting edges can be damaged if the tool is not handled properly.
6. Try to avoid touching the cutting edges. The edges are sharp and may cause injury.
7. Tools with visible cracks must not be used.
8. Tools and tool bodies shall be clamped in such a way, that they shall not loosen during operation.
9. For tools with friction lock a setting gauge shall be used to maintain radial and axial cutter projections.
10. Care shall be taken of mounting tools to ensure that the clamping is by the hub respectively by the clamping surface of the tool and that the cutting edges are not in contact with each other or with the clamping elements.
11. Fastening screws and nuts shall be tightened using the appropriate

spanners etc. and to the torque value provided by the manufacturer.

12. Extension of the spanner or tightening using hammer blows shall not be permitted.
13. Clamping surfaces shall be cleaned to remove dirt, grease, oil and water.
14. Clamping screws shall be tightened according to instructions provided by the manufacturer. Where instructions are not provided clamping screws shall be tightened in sequence from the centre outwards.
15. Use of loose rings or sleeves to "make up" bore sizes on circular sawblades shall not be permitted. Use of fixed rings, e.g. pressed or held by adhesive fixing, in circular sawblades or flanged sleeves for other tools shall be permitted if made to the manufacturers specifications.
16. Resin shall only be removed from light alloy with solvents that do not affect the mechanical characteristics of these materials.

Installing the Cutter on the Machine

1. Make sure that the bore of the cutter matches the diameter of your machine spindle. Don't force the cutter onto the machine spindle and don't make any changes to the bore of the cutter.
2. Ensure that the rotation of the machine spindle corresponds to the rotation direction etched onto the cutter.
3. Tighten the spindle nut well before you start to work with the cutter.
4. Before starting the machine, make sure the cutter is able to rotate freely and does not come into contact with any part of the machine.

Working with the Cutter

1. Please make sure you read and fully understand the machine instructions before working with this cutter.
2. Do not exceed the maximum RPM etched onto the cutter.
3. The wood can only be manually fed onto the cutter if the word "MAN" is etched onto the cutter.

4. We recommend that suitable eye, mouth and ear protection are worn whenever working with woodworking machinery.

5. Ensure machine is connected to suitable dust extraction equipment, as specified by the machine manufacturer. Failure to use adequate dust extraction equipment can result in harmful dust being released into the work place and poor cutter performance.
6. When using a new cutter, or after replacing the cutter knives, we recommend that the screws are checked and re-tightened if necessary, after a few minutes use.
7. Check the knives regularly for sharpness. Dull knives can damage the tool, machine and work piece. Replace the knives before they get dull.
8. Try to keep the cutter as clean as possible. A clean cutter will improve chip flow and cut quality.
9. If the cutter comes into contact with a foreign object during use, immediately switch off the machine and check the cutter for damage. It is important to check the knife seating area (see fig. 6) for damage before replacing the new cutter knife. Damaged seating area will decrease the holding force on the knife and could cause the cutter to be dangerous.
10. Trial cuts should be made in waste material before starting any project.

Repair of Tools/Maintenance

1. Repair of tools is only allowed in accordance with the manufacturers instructions.
2. The design of composite (tipped) tools shall not be changed in the process of repair. Composite tools shall be repaired by competent person, i.e. a person of training and experience, who has knowledge of the design requirements and understands the levels of safety to be achieved.
3. Repair shall therefore include e.g. the use of spare parts which are in accordance with the specification of the original parts provided by the manufacturer.
4. Tolerances which ensure correct clamping shall be maintained. (cont.)

ENVIRONMENTAL PROTECTION



Recycle raw materials instead of disposing as waste.

Packaging should be sorted for environmental-friendly recycling. The product and its accessories at the end of its life should be sorted for environmental-friendly recycling.

GUARANTEE

All Trend products are guaranteed against any defects in either workmanship or material, except products that have been damaged due to improper use or maintenance.

Please see Trend website www.trend-uk.com/safety for more safety advice.

Our policy of continuous improvements mean that specifications may change without notice. Trend Machinery & Cutting Tools Ltd. cannot be held liable for any material rendered unusable, or for any form of consequential loss.

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RS 28982
Stockholding
& Supply



RECYCLABLE



Repair of Tools/Maintenance - (cont.)

- Care shall be taken that the regrinding of the cutting edge will not cause weakening of the body and the connection of the cutting edge to the body.
- When replacing the knife, try to work in a clean environment. Remove any resin with Trend Resin Cleaner.
- Use only the original keys and gauges supplied with the cutter. The replacing of knives does not require any undue force. Exaggerated force will damage the screws and clamping parts.
- After removing the dull knife, ensure that the knife seat is clean.
- Make sure that the knife is positioned in the correct direction. When tightening the screws, push the knife against the seating area.
- Use only original Trend spare parts.
- The coating used on the cutters is sensitive to acid. Do not clean the tools with any products containing acid.

Handling

- To avoid injuries, tools shall be handled in accordance with the guidance provided by the manufacturer. Typically, safe handling involves the use of devices such as carrying hooks, proprietary handles, frames (e.g. for circular saw blades), boxes, trolleys etc. The wearing of protective gloves improves the grip on the tool and further reduces the risk of injury.
- Tools which weigh more than 15kg may require the use of special handling devices or attachments, these will depend on the features that the manufacturer has designed into the tool to allow easy handling. The manufacturer can advise on the availability of necessary devices.

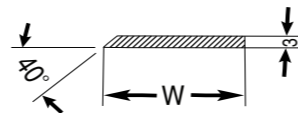
Storage

- We recommend that the cutter is kept inside its box when not in use. This will protect it, keep it clean and oiled against corrosion.
- Always return spare knives and blades to their protective storage packaging when not in use.

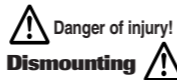
Autoplanus - Planer Block

Knives Geometry

- To work properly the Autoplanus knives must have a 40° cutting angle as shown below.



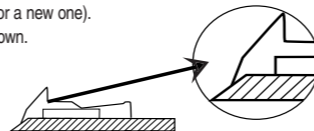
- To work in safety knife width "W" after resharpening must not be under 20mm and thickness must remain 3mm.
- Starting the machine during a tool change is not allowed (see handling instruction for the machine).



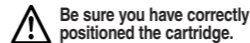
- Unscrew using the supplied key.
- Extract the cartridge (wedge + knife) sliding from side or from top.
- Insert the supplied screw driver into the pocket to detach the wedge from the knife.
- Clean the cutter head slot, wedge and the knife.

Mounting

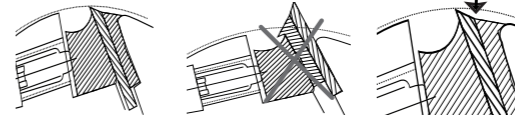
- Take the resharpened knife (or a new one).
- Put against the wedge as shown.
- The magnet keeps the knife and wedge together.



- Fit the cartridge into the cutter head slot as shown.



- Tighten the locking screws (whilst applying pressure to the cartridge) ensuring the cartridge is in the right position.

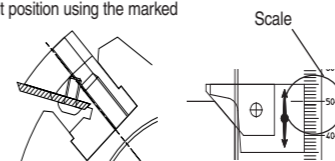


Using Adjustable Knives

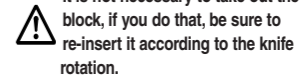
- The machine must be stopped and the power supply disconnected before changing knives.
- Knives are sharp and can injure, always wear gloves during this operation.

Setting the Height

- Loosen the locking screws.
- Set the right position using the marked scale.

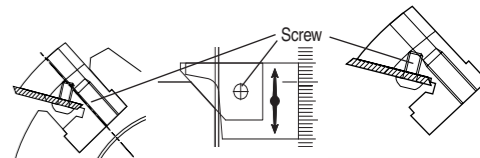


- Lock the screw again at the desired height.

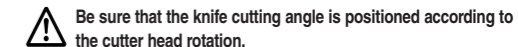
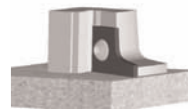


Changing the Profiled Knives

- Remove the block from the head before starting.
- Unscrew and remove the knife from the block.



- Clean the block as well as the knife.
- Take a new (or resharpened) knife. Put it in the block, support them on a table so the knife is aligned to the block.



- Re-insert the screw and tighten.

