Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

BT 500 50079458 PLEASE INSERT SERIAL NUMBER OF MACHINE

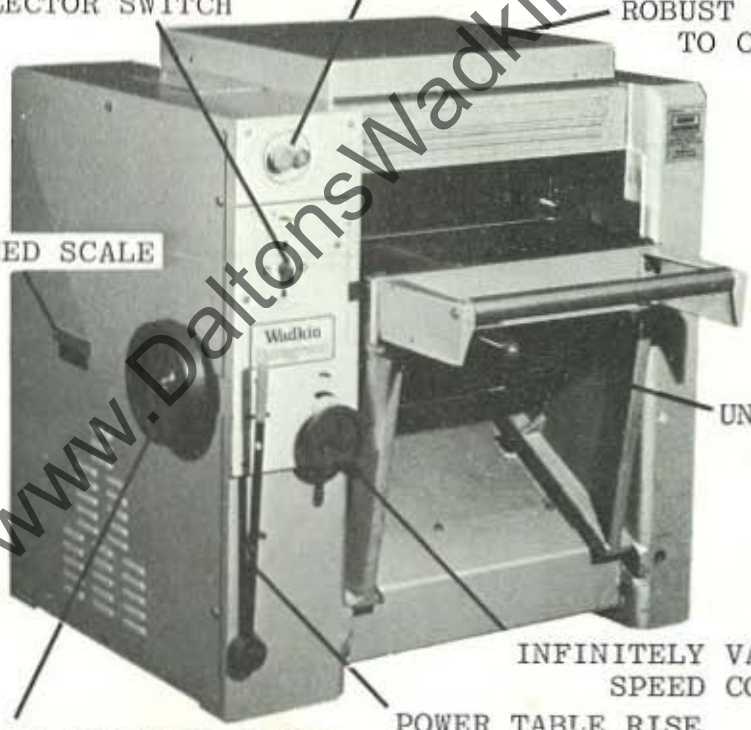
FOR WADKIN SPARE PARTS.
WADKIN P.L.C.
GREEN LANE RD.
LEICESTER.
TEL 0533769111
FAX 0533461021
14-10-93.

INSTRUCTION MANUAL FOR

BT 500

Planer and Thicknesser

MACHINE No. BT 550079455



For Replacement Parts, Tools & Accessories,
Contact ~~Brian Stacey~~,
~~Bursgreen~~ (Durham) Ltd.,
Fence Houses, Houghton~le~Spring,
Tyne~Wear DH4 5RQ. England.
Telephone: Fence Houses (5 Lines)
Telex: 53441 (Bursgreen Duram)

WADKIN Wadkin

091 3854395

SECTIONS

HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.

2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.

3. Only personnel trained in the safe use of a machine should operate it.

4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.

5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

oOo

WADKIN LTD · GREEN LANE WORKS · LEICESTER LE5 4PF · ENGLAND · TELEPHONE 0533 769111
and York House, Empire Way, Wembley, Middlesex HA9 0PA
Telephone: 01-902 7714 Telex: 262210
Telex: 34646 (Wadkin Leicester)
Telegrams: Woodworker Leicester Telex

SAFETY

1. Read Instruction Book.
2. Securely Lock Cutters.
3. Set Guards Correctly.
4. Select Correct Speed.
5. Use Feeding Devices Where Possible.
6. Refer To HSW Booklet No.41. (in UK) For Safety In The Use Of Woodworking Machinery.

SECTION A

PRINCIPAL DIMENSIONS & CAPACITIES

Capacity of machine	508 x 230	20" x 9"
Feed of machine	6 - 18 metres/min	20-60ft/min
H.P. of feed motor	.75kw	1HP
H.P. of cutterblock motor	5.5kw	7.5HP
Speed of cutterblock	5,000rpm	5,000rpm
Speed of motor : 50 cycle	3,000rpm(syn)	3,000rpm(syn)
: 60 cycle	3,600rpm(syn)	3,600rpm(syn)
Dia. of cutting circle	115	$4\frac{1}{2}$"
Dia. of feed rollers	75	3"
Yield of complete infeed roller	10	3/8"
Minimum stock length	292	$11\frac{1}{2}$
Maximum stock removal	10	3/8"
Length of table	765	30"
Floor space	1205 x 944	3'-$11\frac{1}{2}$" x 3'-1"
Nett weight approx.	635 kg	1400lb
Gross weight approx.	749 kg	1652lb
Shipping dimensions	1.47m^3	52ft^3

Bearings Used

1-SKF 6202-2RS	Feed Motor traverse screw
2-SKF 51205	Rise and fall cross shaft
2-SKF 51104	Rise and fall screw
4-SKF 6203-2RS	Under table rollers
2-SKF 6207-2RS	Cutterblock
2-Hoffman XLM 18	Rise and fall screw
1-INA AXK 2542	Clutch thrust bearing
2-INA AS 2542	Clutch bearing pressure plates

SECTION "B" INSTALLATION

SLINGING
FIG. B1.

1. Manually rise the table by handwheel "A" until the table reaches the stops in its uppermost position. Place sling under table as shown in FIG. B1 ensuring damage will not be caused to the machine during slinging.

2. Move machine to required position.

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

MARKING OUT
FIG. B2.

1. Mark out floor and drill to suit 4 foundation bolts. These bolts can be supplied at an additional extra charge.

2. Level table by adjusting the 4 - Simplex adjusting screws situated in bottom corners of machine side frames.

WIRING DETAILS
FIG. B3.

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the isolating switch. 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.
5. Check all connections are sound.
6. Check the rotation of both motors for the correct direction. If these are incorrect reverse any two of the line lead connections.

Voltage	H.P. Block - Feed		Phase	Cycles	SWG Tinned Copper Wire Amps - SWG	
380/420	$7\frac{1}{2}$	1	3	50	38	19
380	$7\frac{1}{2}$	1	3	50	38	19
208/220	$7\frac{1}{2}$	1	3	60	65	17
550	$7\frac{1}{2}$	1	3	60	24	22
220	$7\frac{1}{2}$	1	3	50	65	17
440	$7\frac{1}{2}$	1	3	60	29	21

Fuse capacity should not exceed three times full load current of the machine.
NOTE: DUST EXHAUST Information is available on request.

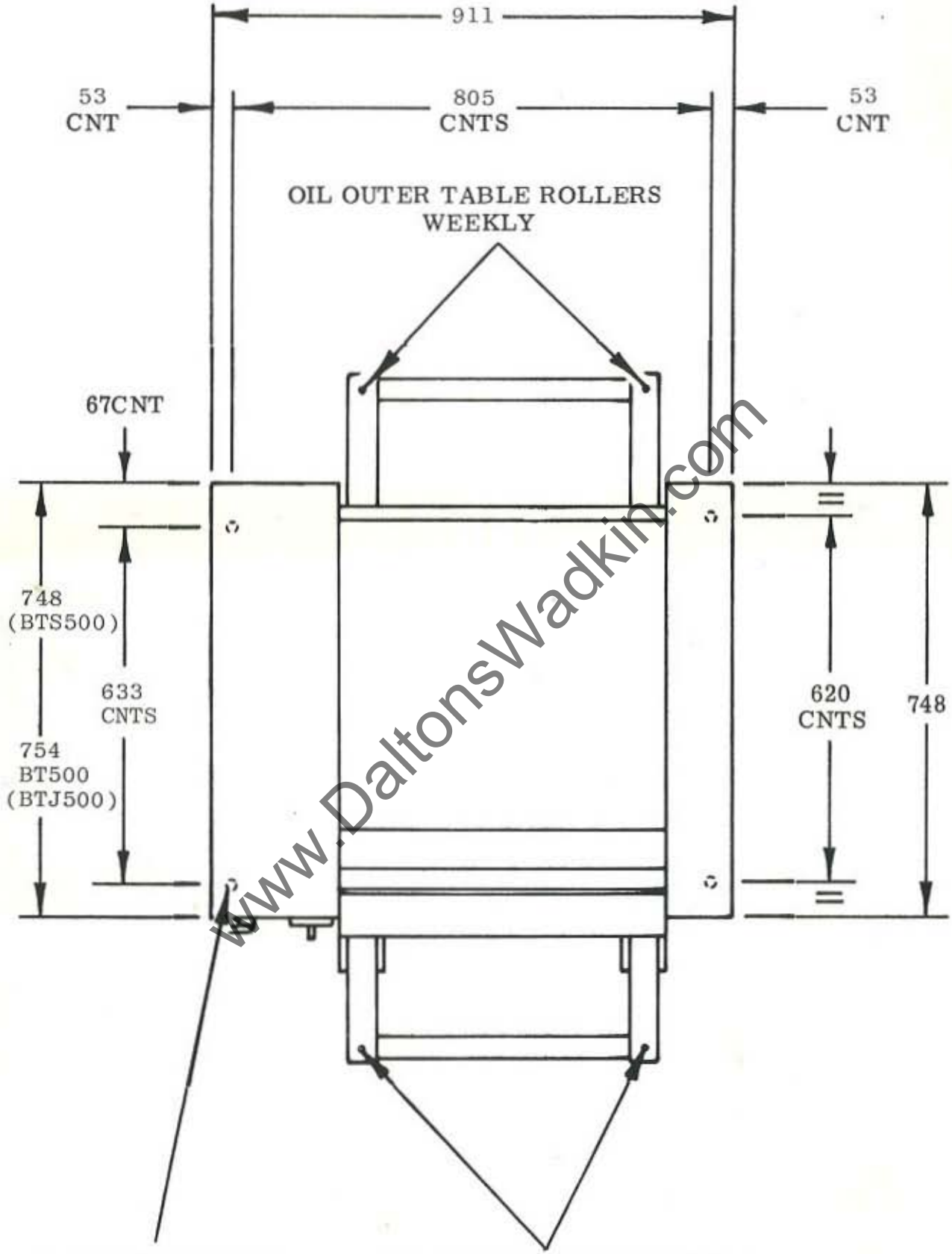
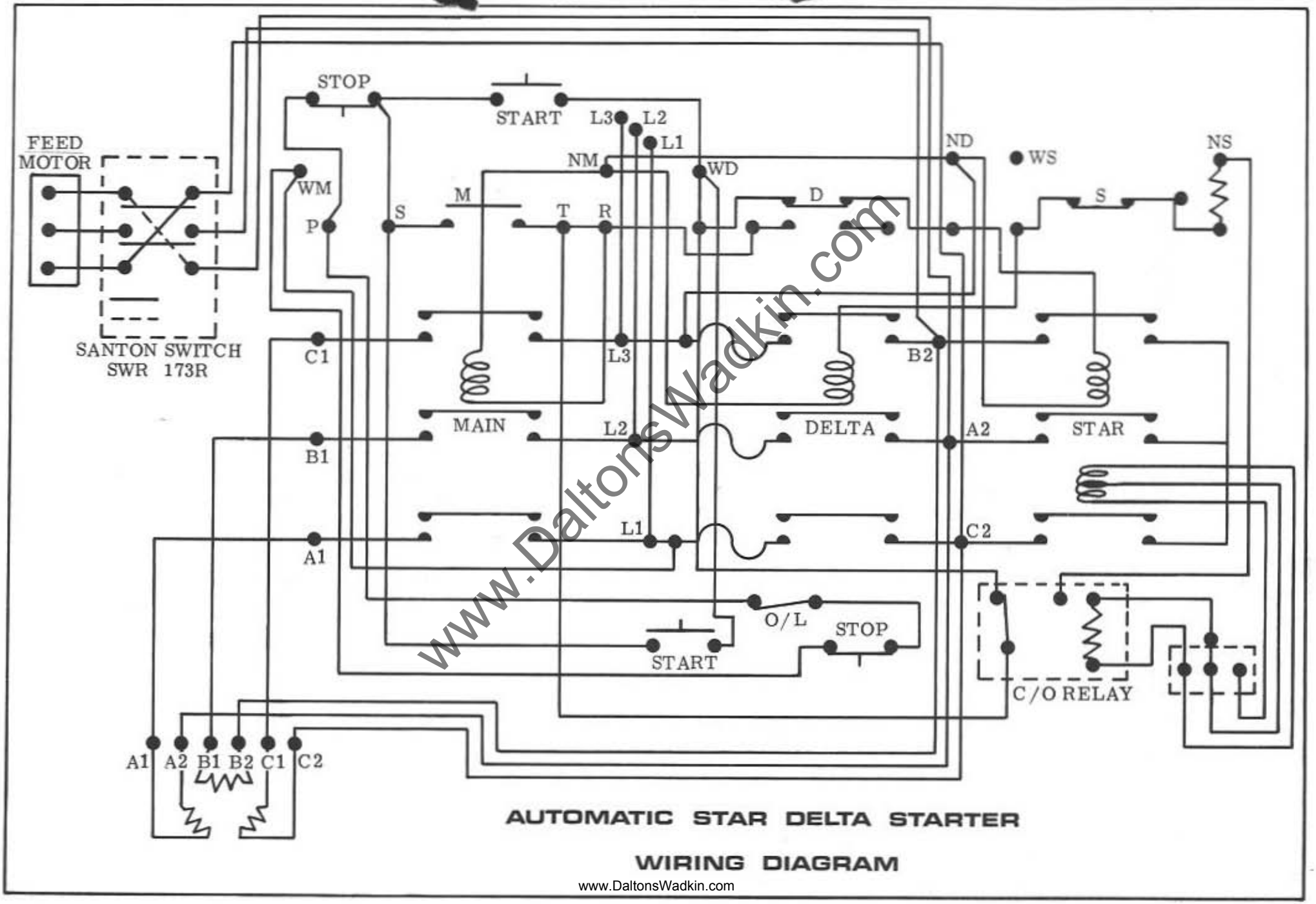


Fig B2



AUTOMATIC STAR DELTA STARTER

WIRING DIAGRAM

MEM AUTO LINE ~ DIRECT ON LINE STARTER

STANDARD WIRING DIAGRAM

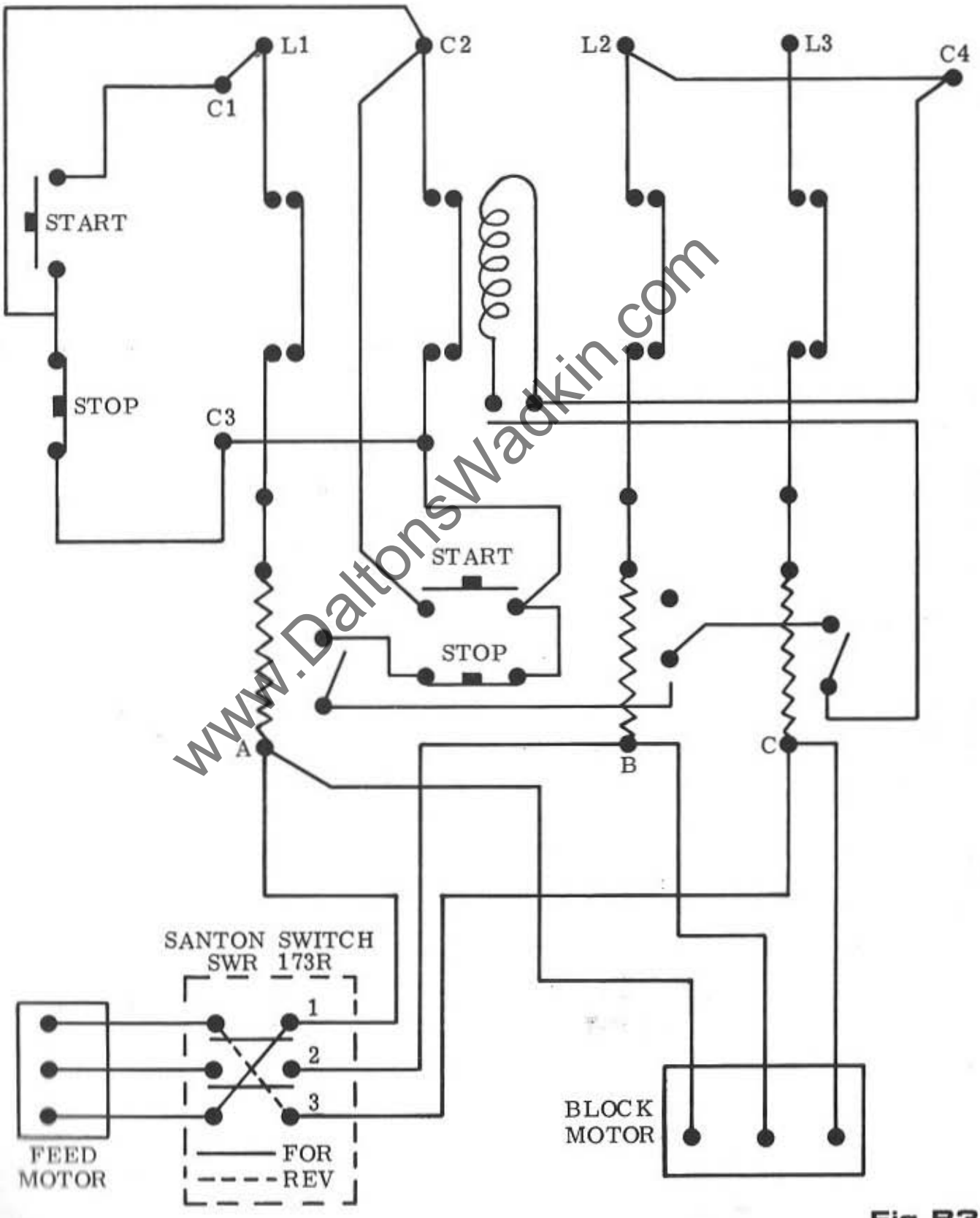
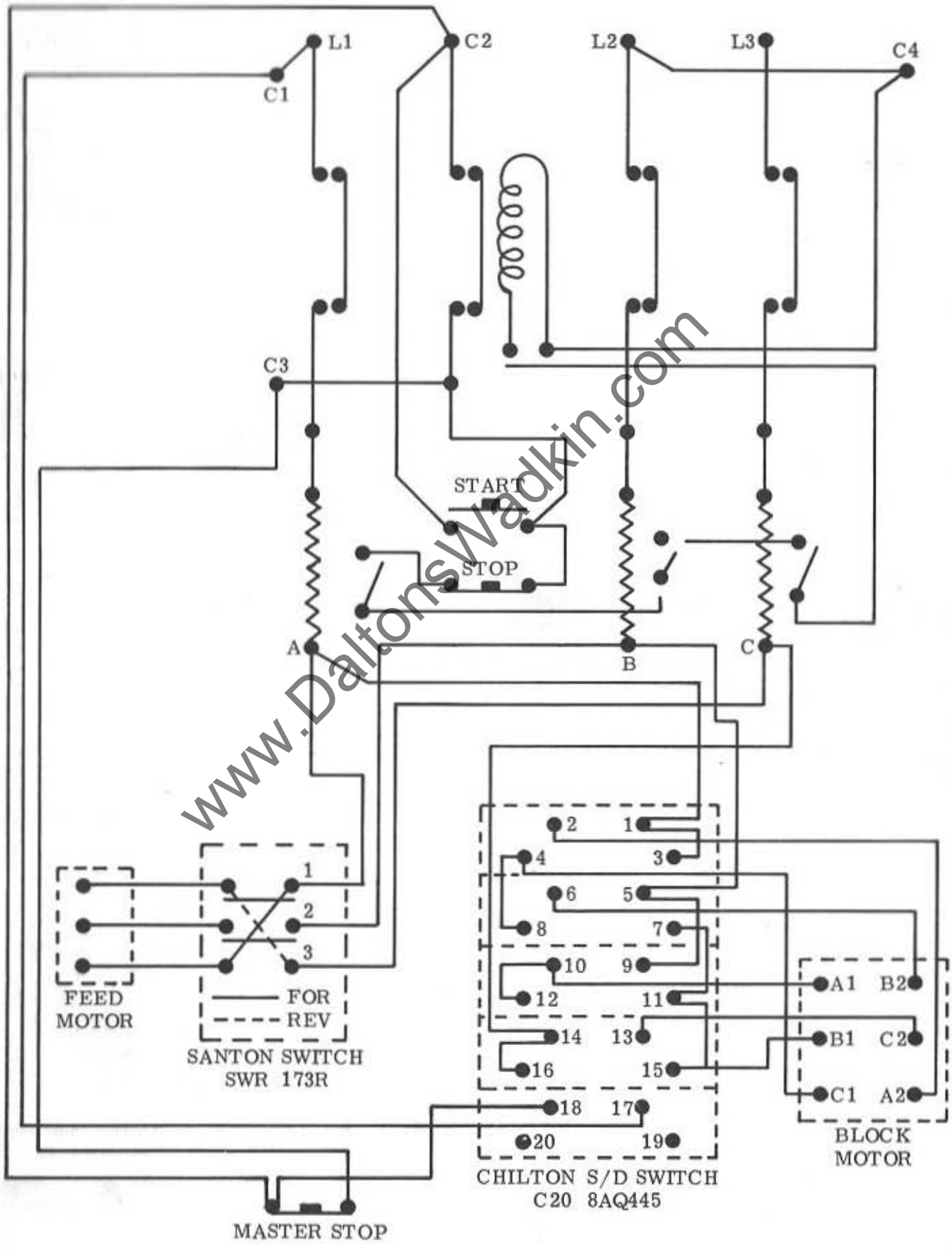


Fig B3

STAR DELTA SWITCH (SPECIAL)



SECTION "C" DESCRIPTION AND OPERATION

PREPARATION FOR OPERATION

FIG. C1.

1. Remove filler plug "A" from top of reduction gearbox "B" and oil level plug "C" from side of gearbox. Check that the oil is up to the oil level hole "C". Top up if necessary using correct grade of oil.
   See APPROVED LUBRICANTS, page 12.
   Replace oil filler plug "A" and oil level plug "C".

2. Remove filler "D" from top of variable pulley "E" and check that oil level is to within $\frac{1}{2}$" from top of hole. Top up, if necessary, using correct grade of oil. See APPROVED LUBRICANTS, page 12.

3. FIG. C2 and C3. Lubricate machine according to lubrication operations No's. 1 to 7. See APPROVED LUBRICANTS, page 12.

4. It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

CONTROLS AND OPERATION

FIG. C3.

1. The control panel is situated on the front left side of the machine with the following controls incorporated in a grouped layout:-
   A. CUTTERBLOCK START-STOP SWITCH.
   B. FEED SELECTOR SWITCH.
   C. TABLE RISE AND FALL MICRO ADJUSTMENT HANDWHEEL.
   D. LOCK FOR TABLE RISE AND FALL MICRO ADJUSTMENT HANDWHEEL.
   E. POWER TABLE RISE AND FALL LEVER.
   F. INFINITELY VARIABLE FEED SPEED CONTROL.
   G. UNDER TABLE ROLLER ADJUSTING LEVER.

IMPORTANT NOTES.

The FEED SELECTOR SWITCH works in conjunction with the POWER TABLE RISE AND FALL LEVER. When the switch is pointing in the upward position and the power table lever operated, the table will rise until the power table lever is released.

With the switch in the downward position the proceedure is the same only the table falls.

Normal feeding is attained with the feed selector switch in the up position.
NOTE : The feed is reversed when the feed selector switch is in the down position. The feed is OFF when the switch is in the horizontal position.

When altering the INFINITELY VARIABLE FEED SPEED CONTROL, the feed motor must be running.

The UNDER TABLE ROLLER ADJUSTING LEVER readily selects the correct roller position for maximum traction.

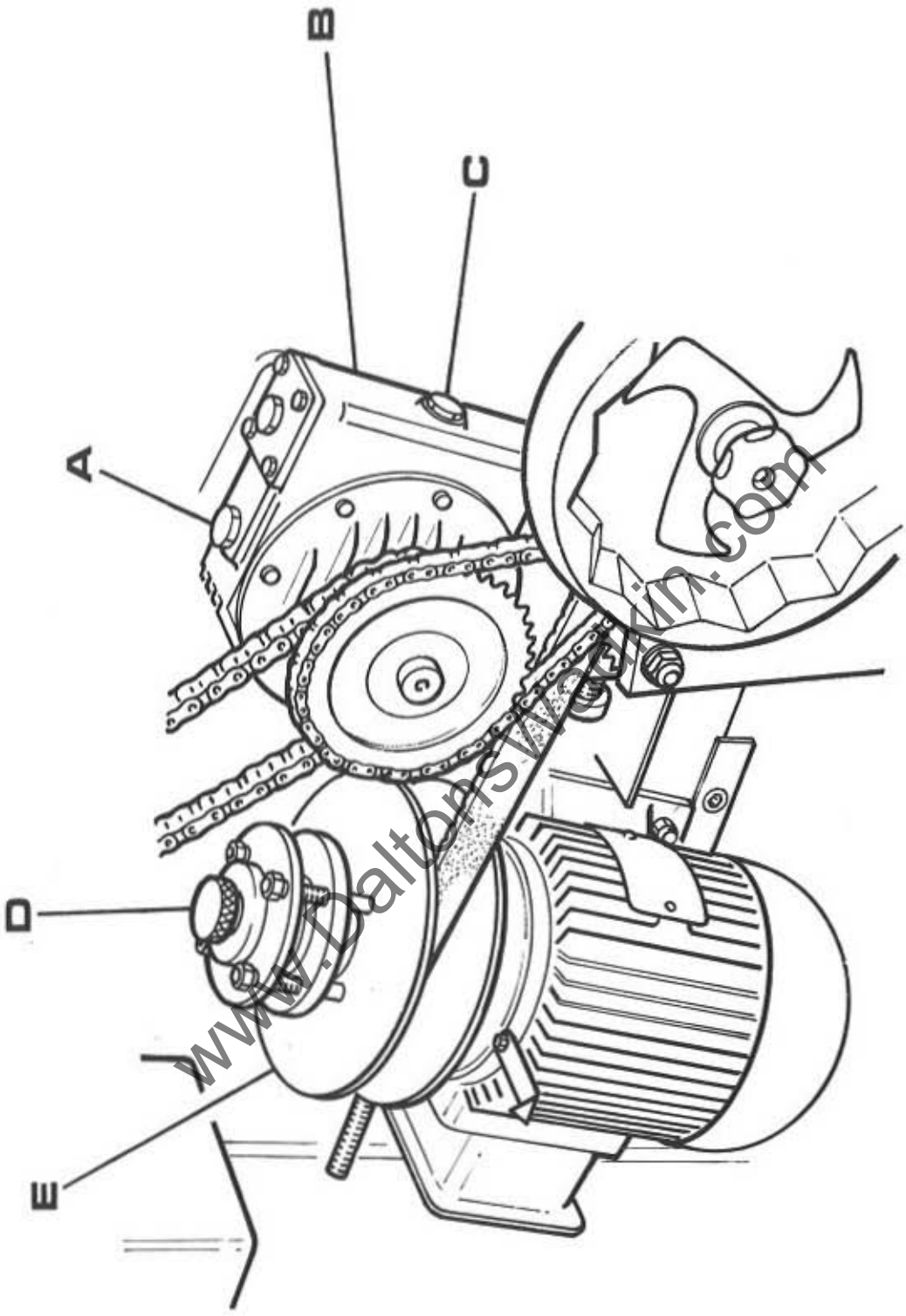


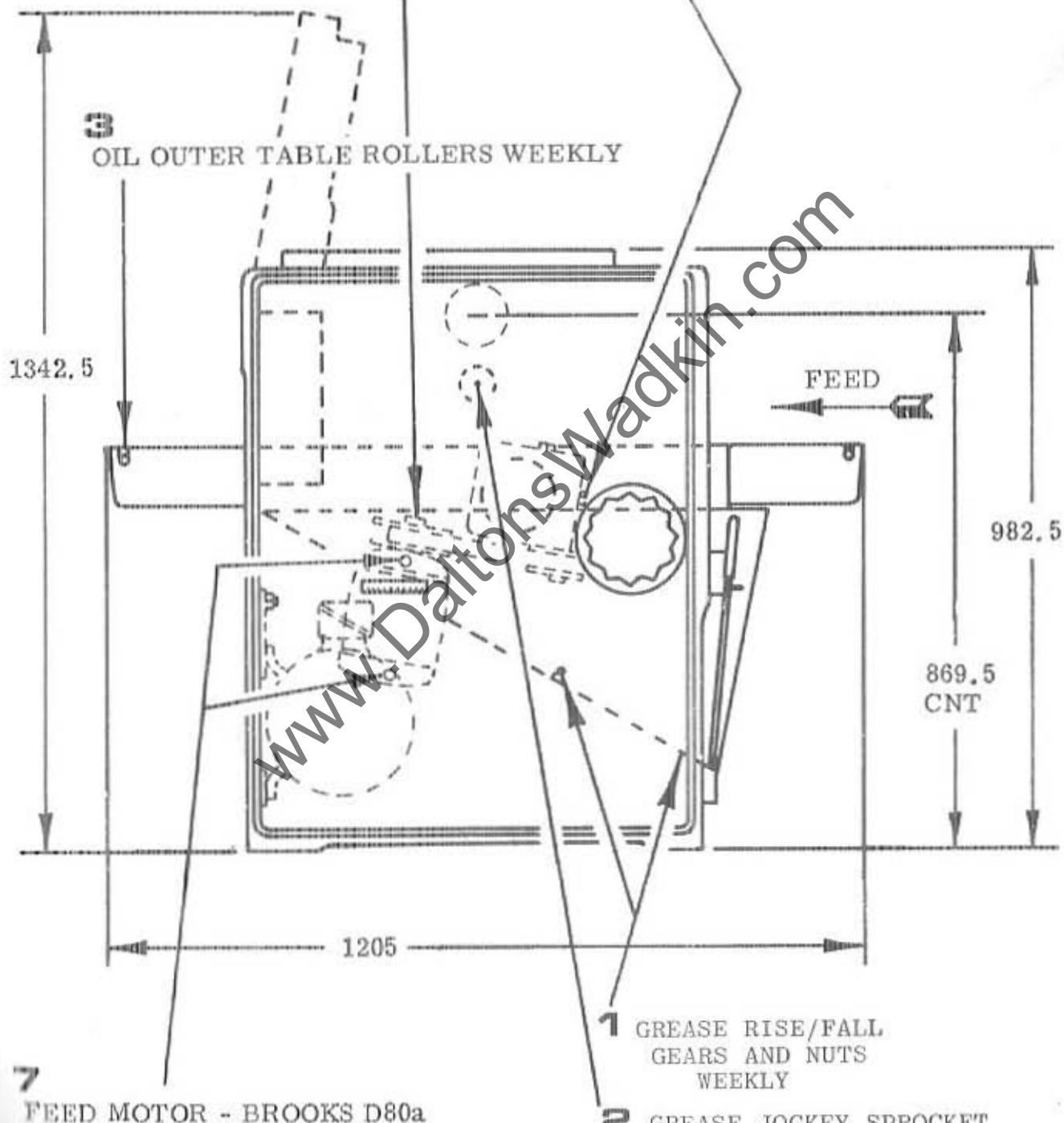
Fig CI

TYPE FV HOLROYD REDUCTION BOX
(20.5 : 1 REDUCTION). USE CASTROL ALPHA 617 (OR EQUIVALENT)

5 CHECK OIL IN REDUCTION BOX MONTHLY

4 CHECK OIL IN VARIABLE PULLEY MONTHLY

3 OIL OUTER TABLE ROLLERS WEEKLY



1 GREASE RISE/FALL GEARS AND NUTS WEEKLY

2 GREASE JOCKEY SPROCKET WEEKLY

7 FEED MOTOR - BROOKS D80a
(1HP - .75KW) 1,500 RPM
GREASE BOTH ENDS OF
MOTOR 2 TURNS EVERY
6 MONTHS

Fig C2

NOTE: WITH MACHINE RUNNING, TURN VARIABLE FEED SPEED HANDWHEEL "F" THROUGH COMPLETE SPEED RANGE ONCE DAILY TO ENSURE PULLEY IS FULLY LUBRICATED.

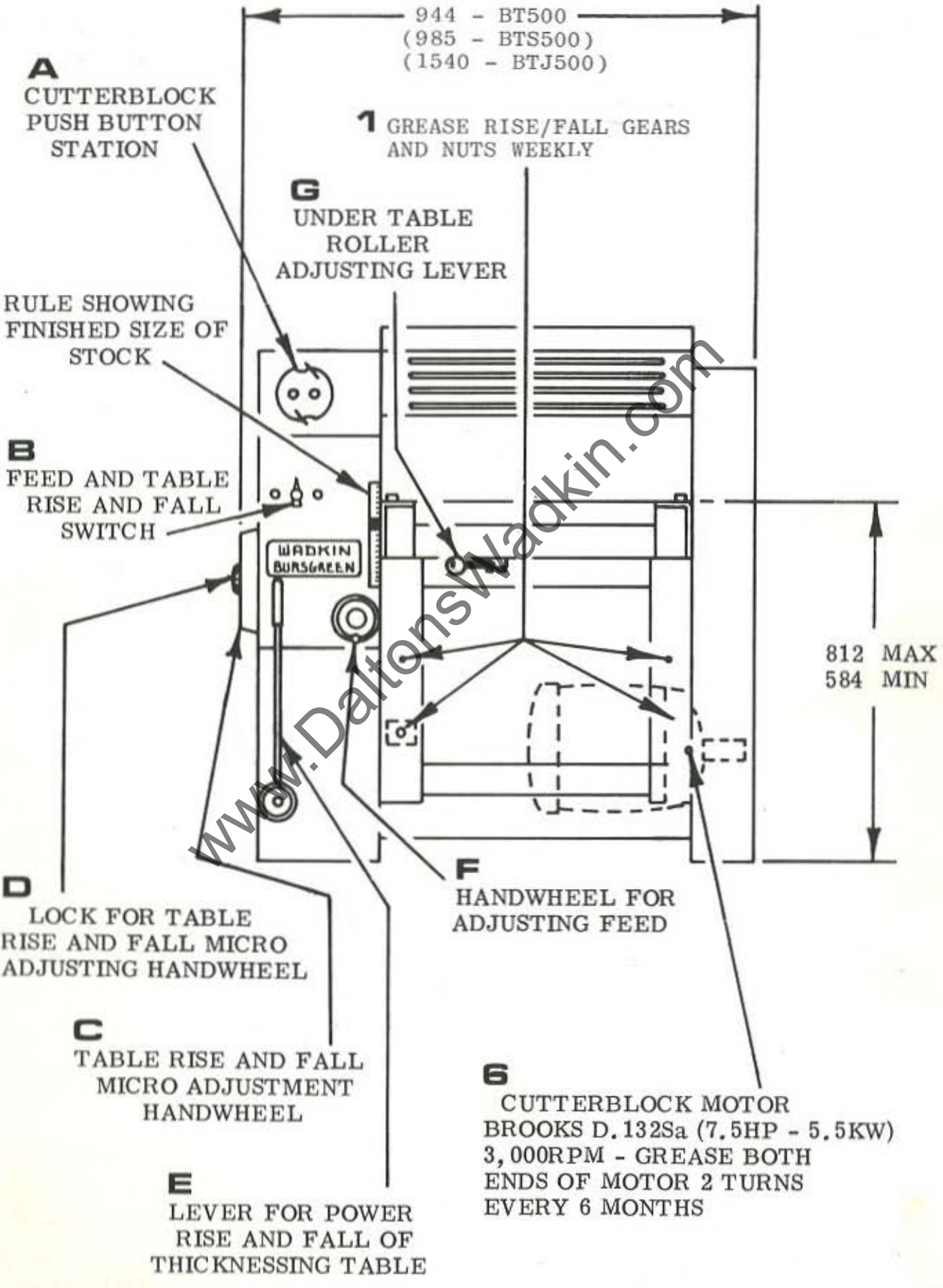


Fig C3

SECTION "D" MAINTENANCE

All adjustments and alignments following have been carefully set and checked and the complete machine thoroughly tested before despatch from the works.

During the first few weeks of operation and at regular intervals afterwards certain items such as belt tension and chain tension should be checked carefully. When adjustments are necessary, proceed in accordance with the relative instructions given.

LUBRICATION
FIG. C2 & C3.

WEEKLY

1. GREASE RISE/FALL GEARS AND NUTS
2. GREASE JOCKEY SPROCKET
3. OIL OUTER TABLE ROLLERS.

MONTHLY

4. CHECK OIL IN VARIABLE PULLEY IS TO WITHIN $\frac{1}{2}$" FROM TOP OF FILLER. TOP UP IF NECESSARY.
5. CHECK OIL IN REDUCTION GEARBOX IS UP TO OIL LEVEL HOLE. TOP UP IF NECESSARY.

6 MONTHLY

6. GREASE BOTH ENDS OF CUTTERBLOCK MOTOR:- 2 TURNS.
7. GREASE BOTH ENDS OF FEED MOTOR:- 2 TURNS.

TYPE OF OIL RECOMMENDED FOR GENERAL USE:- CASTROL MAGNA ED
TYPE OF OIL RECOMMENDED FOR REDUCTION GEARBOX } CASTROL ALPHA
TYPE OF OIL RECOMMENDED FOR VARIABLE PULLEY } 617 (OR EQUIV').
TYPE OF GREASE RECOMMENDED:- CASTROL SPHEEROL AP3.

TYPE FV HOLROYD REDUCTION BOX

NOTE: After about 200 hours running with a new gear it is desirable to drain and flush out the original charge of oil and refill with clean oil, after which the oil need only be changed after long intervals. Regular inspection of oil level and topping up when necessary is however important.

TABLE ROLLERS
FIG. D1.

The anti-friction table rollers or bed rollers revolve on sealed for life bearings which require no lubrication. These rollers are automatically adjusted in relation to the table surface by a single operating lever "A" at the infeed end of the table.

Under table roller height depends on the stock being machined.

The extremes of height being for narrow wet and soft material which allow the rollers to sink into the material considerably and still allow the bottom of the stock to ride on the table surface.

The level position of the rollers caters for the opposite extremes of wide hard dry material which will not permit the rollers to sink into it.

Infinite variation therefore permits correct setting for all classes of timber.

The general rule for setting being that the bottom rollers should be high enough to relieve the friction between table and stock WITHOUT the material losing contact with the table surface.

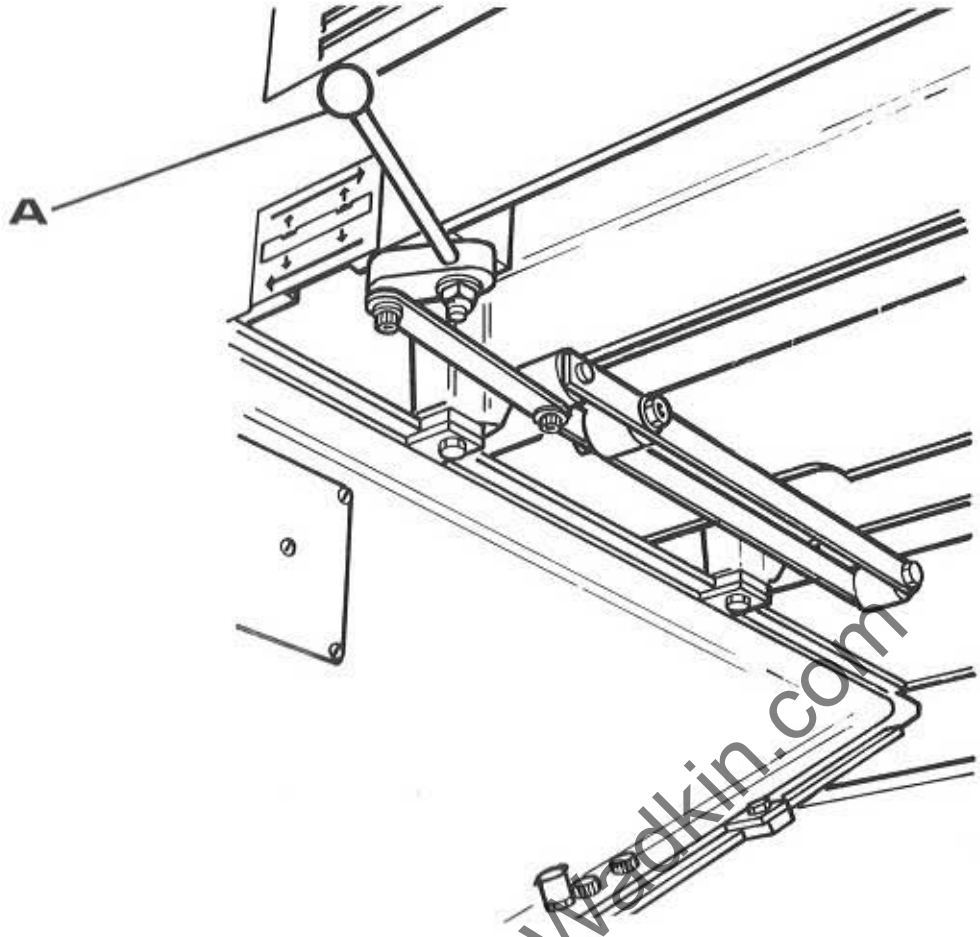
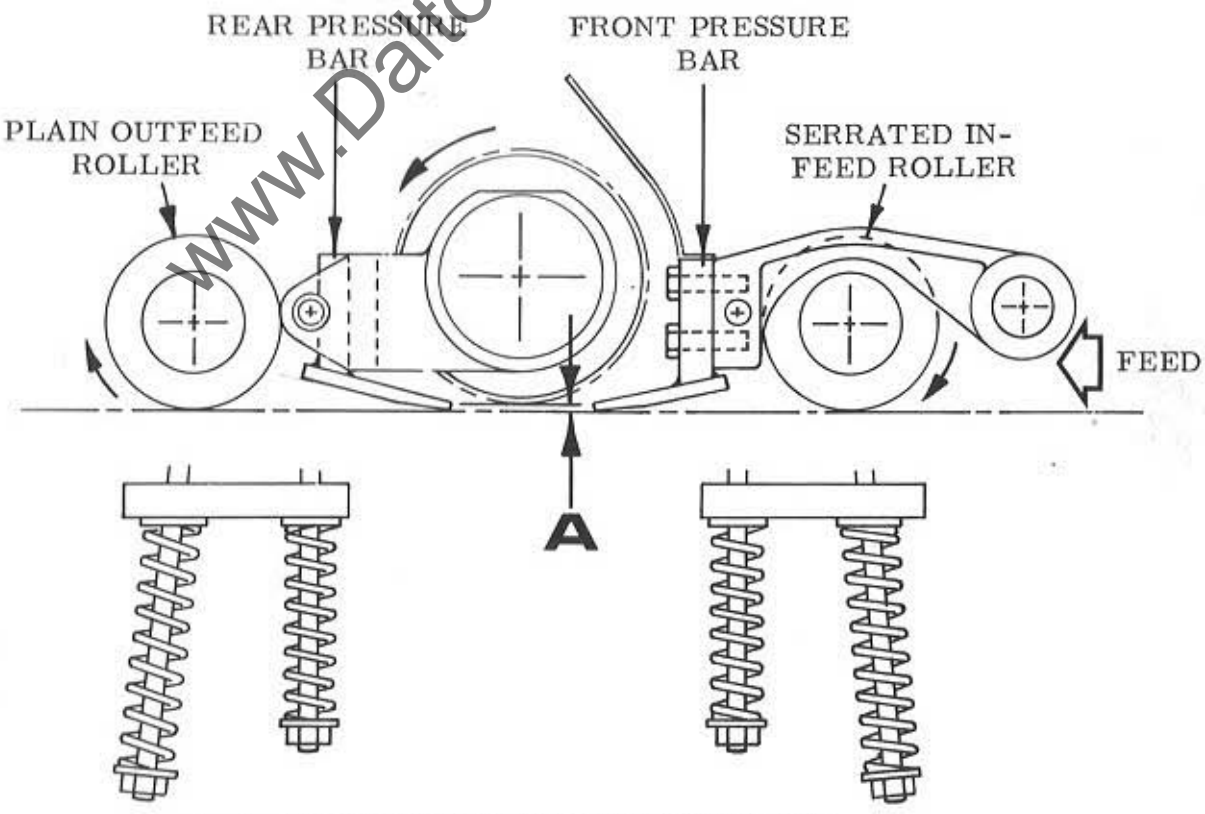


Fig D1



A = FEED ROLLERS AND PRESSURE BARS SET·6MM (.025") BELOW CUTTING CIRCLE.

Fig D2

In all cases the lowest position consistent with good and regular feeding should be used as this will give the best possible results. Should the table rollers be removed for any reason, care must be taken to replace them exactly as before otherwise the setting will be disturbed.

It must be emphasised that a really good surface finish from a thicknessing machine is only possible when the face of the timber resting on the machine table is flat and has a reasonable finish. Wherever practicable this face should be pre-machined on a overhand jointer, or surfacer to remove twist and other irregularities.

FEED ROLLER AND PRESSURE BAR SETTINGS

FIG. D2.

These are pre-set at the works and vertical adjustment relative to the cutterblock is neither possible nor necessary provided the cutters are correctly set with the special setting guage supplied with each machine. Should replacement feed rollers or pressure bars be fitted at any time, the settings should be very carefully checked with FIG. D2.

Some slight advantage in finish or feeding may on occasions be obtained by increasing or decreasing the tension of the pressure bar or feed roller springs.

NOTE: The springs should never be compressed to a point where the feed rollers and pressure bars cannot lift sufficient to allow the maximum cut to be taken.

BELT TENSION

FIG. D3.

The cutterblock drive is by three Vee belts from a $7\frac{1}{2}$HP motor. Tension is effected to these belts by adjusting motor. To adjust, loosen four aerotight nuts "A" then proceed to turn hexagon head nut "B" until required tension is reached then relock nuts "A".

FEED CHAIN TENSION

FIG. D4.

The drive to feed rollers is by roller chain from a worm reduction gearbox which is in turn driven by a variable pulley from a 1HP motor, giving variable feed speeds of 6 - 18 METRES/MIN (20 - 60 FT/MIN).

To adjust chain tension on top feed roller chain, proceed as follows:- Loosen two aerotight nuts "A" and hexagon head locknut "B". Adjust square head screw "C" until required tension is reached, i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned relock aerotight nuts "A" and locknut "B".

TABLE RISE AND FALL CHAIN TENSION

FIG. D5 & FIG. D6.

Tension adjustment to the manual table rise and fall chain is as follows:- Power rise table to uppermost position. Turn handwheel "A" in FIG. D5 until the hole in the handwheel boss lines with the hole in the handwheel shaft, then locate 6mm DIA toggle bar into handwheel shaft. Loosen aerotight nut "A" in FIG. D6 then move toggle bar until required chain tension is reached i.e. chain should not be run either too slack or too tight. When chain is correctly tensioned hold toggle bar in position and re-tighten aerotight nut "A", then remove toggle bar.

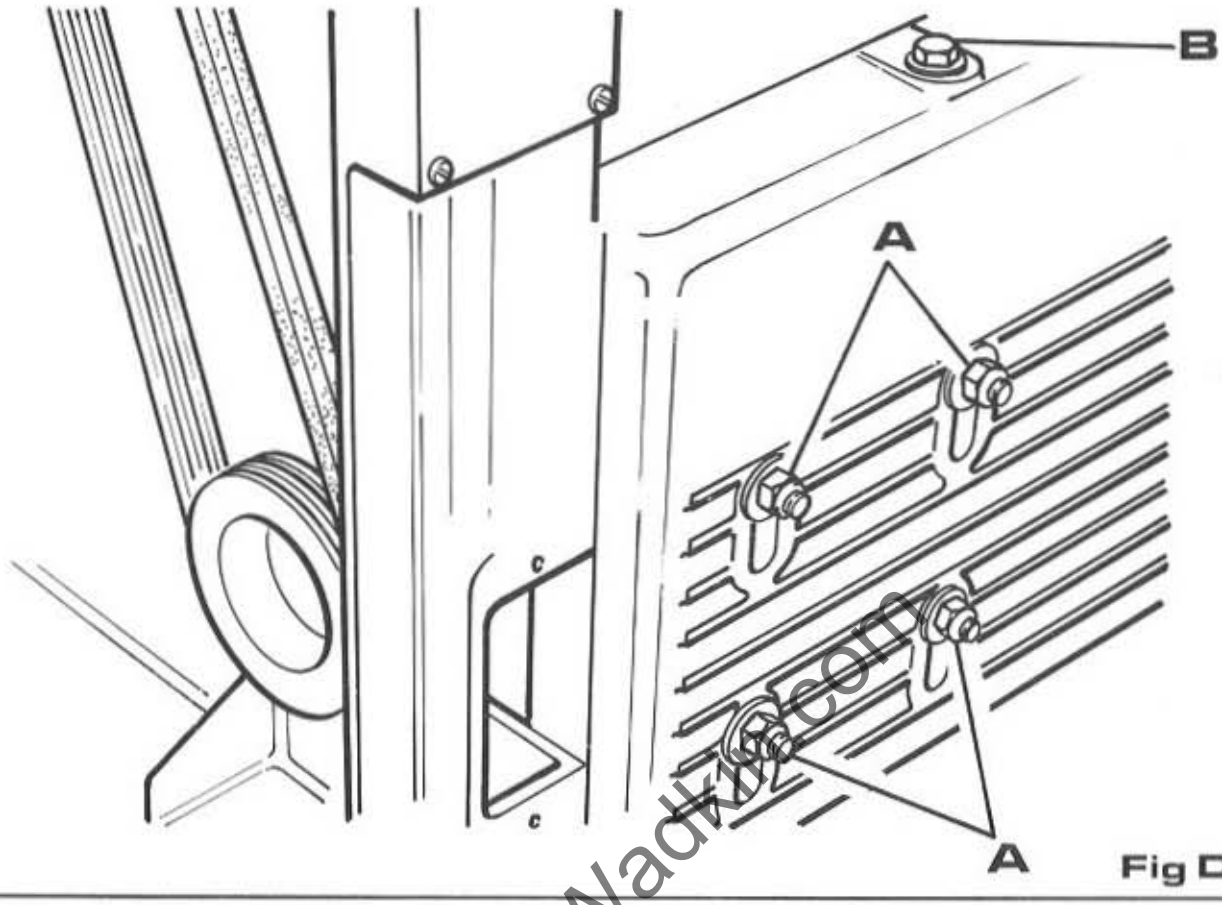


Fig D3

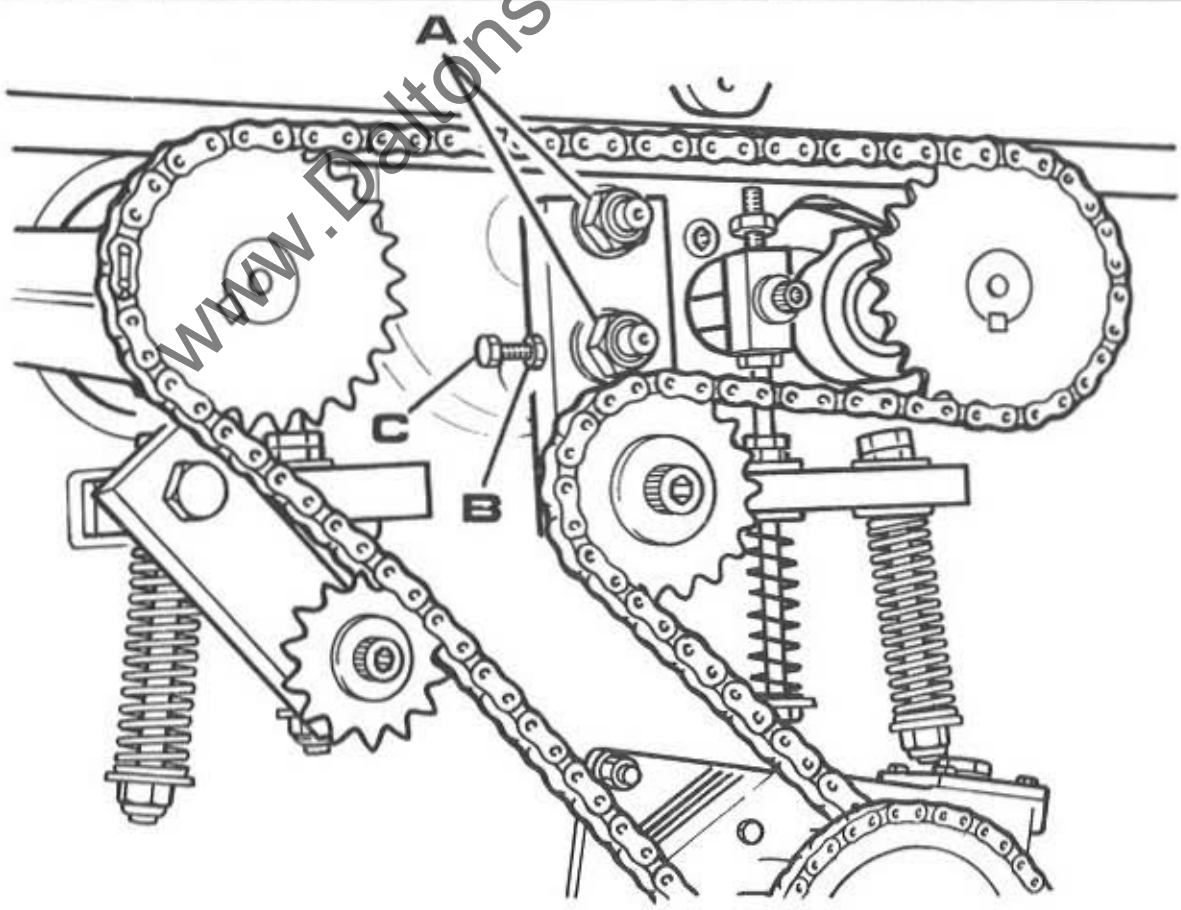


Fig D4

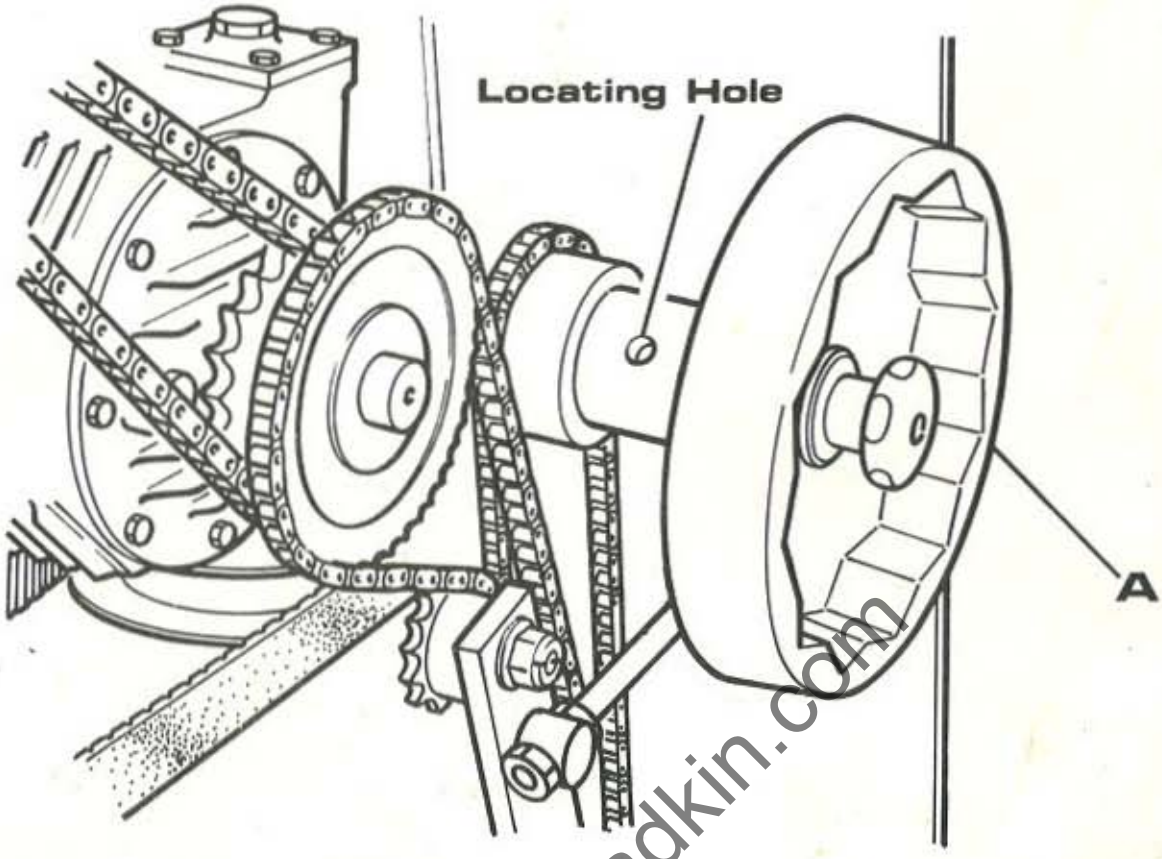


Fig D5

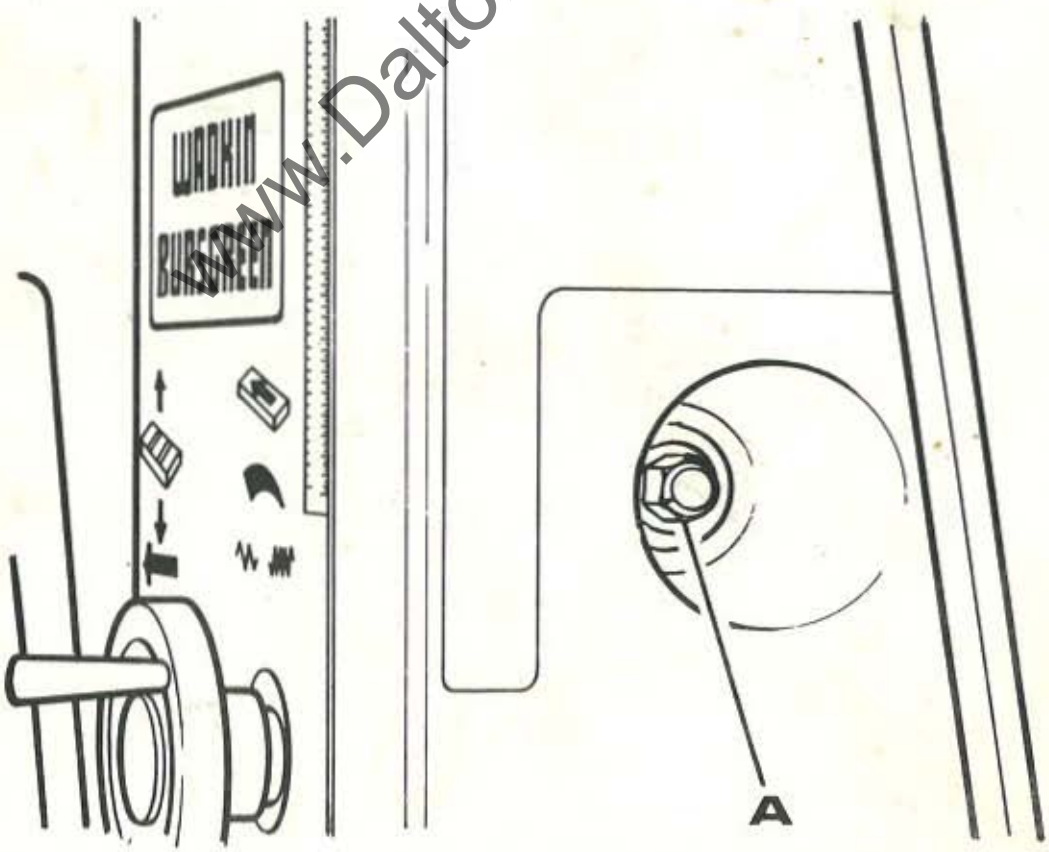


Fig D6

WORM GEARBOX TO CLUTCH CHAIN TENSION
FIG. D7.

Slacken hexagon locknut "A" and adjust hexagon locknut "B" until chain tension is correct, i.e. chain should not be run either too slack or too tight.

When chain is correctly tensioned relock hexagon locknuts "A" and "B".

CUTTER SETTING
FIG. D8.

The cutters are held in the cutterblock by a steel clamping bar secured with 7 - 10mm heat treated socket head screws. As the amount of cutter projection is vital to the correct operation of the machine it is most important that the actual setting gauge supplied with the machine should be used. Should any other method of cutter setting be employed the amount of cutter projection must correspond exactly with that given by the setting gauge supplied and failure to observe this instruction will result in bad feeding and poor finish.

To remove the cutters and re-set with the "BURSGREEN" cutter setting guage, proceed as follows:-

1. Turn the cutterblock to approximately the position shown in FIG. D8. and slacken the 7 - 10mm knife locking screws until the knife is just free of the cutterblock.

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

   An efficient regrinding service is available, charges are moderate and service prompt. To avail yourself with this service, return cutters to: BURSGREEN (DURHAM) LTD., FENCE HOUSES, HOUGHTON-LE-SPRING, CO. DURHAM

2. To re-set the knives the cutterblock should be in approximately the position as shown in FIG. D8. Place the knife in the slot ensuring that all faces are clean and the clamping bar free from burrs.
3. Ensure that the three socket head jacking screws upon which the knife rests, are at their lowest positions by means of a 6mm allenkey.
4. Secure the knife setting device "A" (which when not in use is normally secured to the rear of the machine table) to the cutterblock by the three knurled locking screws "B" as shown in FIG. D8.
5. Adjust the three socket head jacking screws until the knife just touches the knife setting device at three points "C".
   IMPORTANT Care should be taken to ensure that the knife only just touches the knife setting device, as over-adjusting will damage the knife.
6. When the knife is correctly set, securely lock the 7 - 10mm knife locking screws.
7. Rotate cutterblock until the next knife is in position and repeat the procedure until all the knives have been set.

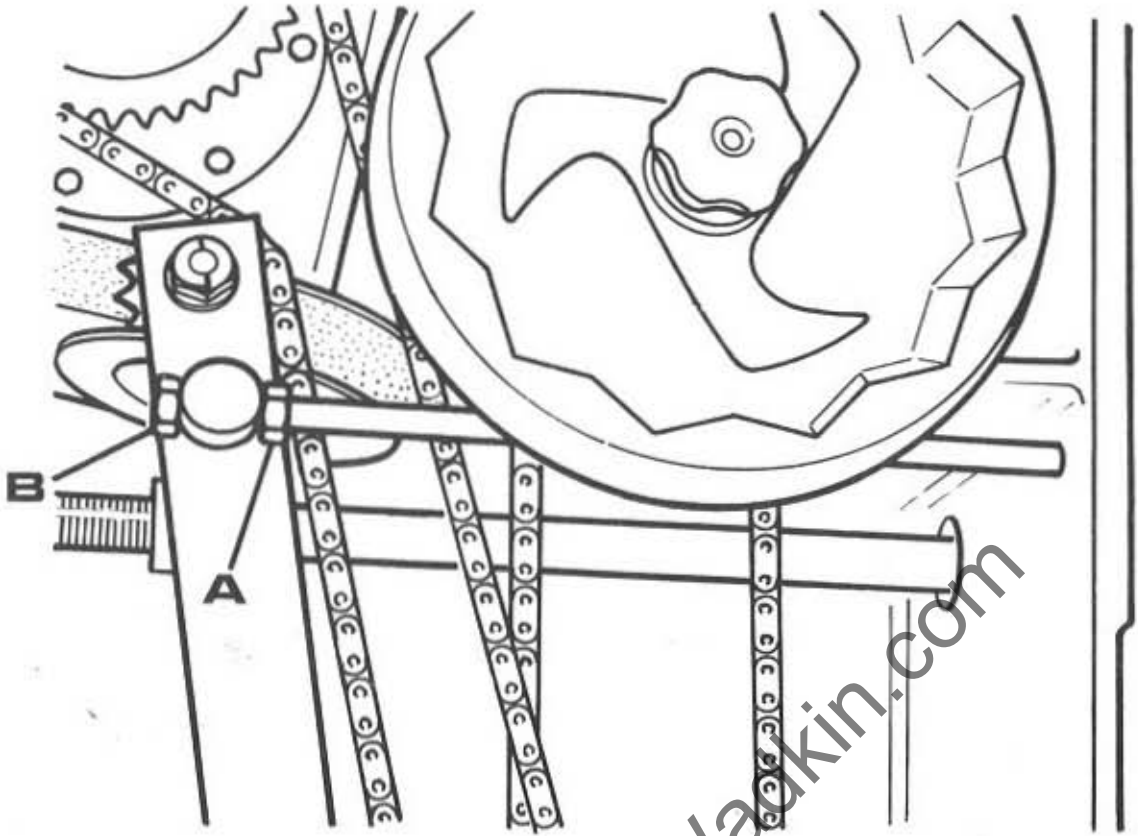


Fig D7

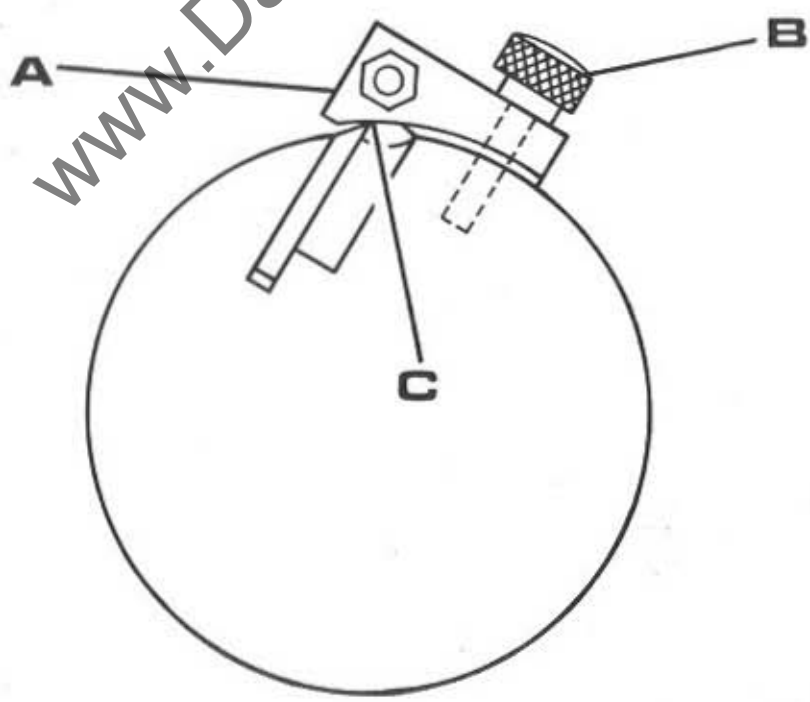


Fig D8

8. 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 "Molyslip" or similar oil, before replacing.

CUTTER CARE

FIG. D9.

The cutters supplied are 511mm long x 30mm wide x 3mm thick in balanced sets. They should be kept in balanced sets by ensuring that the cutters have equal dimensions after grinding and that the cutting edge is straight and parallel to the back edge.

For general work, knife angles for soft and hard woods are recommended as in FIG. D9. (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. D9.(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.

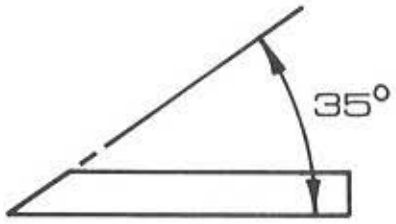
Do not allow a heel greater than .79mm (1/32") wide on the bevel before removing and regrinding. When the heel becomes too wide the knives may heat up or have a hammering effect on the wood and more than normal power will be required to run the cutterblock.

SETTING THICKNESSING TABLE PARALLEL TO CUTTERBLOCK

The machine table is accurately set parallel to cutterblock before despatch but should it be disturbed for any reason it must be carefully checked and made parallel to the cutterblock, if necessary, by the following procedure.

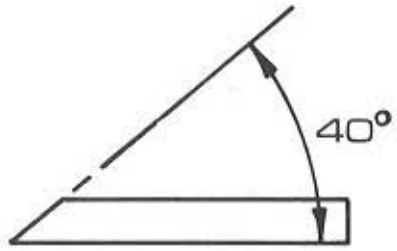
1. Feed a short length of timber approximately 50mm (2" square) x 460mm (18" long) through the machine to one side of the thicknessing table.
2. Without adjustment to the height of the table feed the timber through the machine again on the opposite side of the table to that in item 1.
3. If a cut is taken or it does not touch the wood adjust the fine thread adjusters on the underside of the table to suit and when set tighten all screws.

As the knife setting device sets the knives parallel to the cutterblock it is vitally important that the table is set parallel to the knives for accurate thicknessing.



A

for soft wood

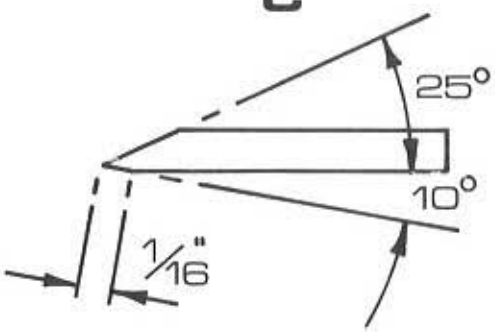


B

for hard wood

for dry soft wood

C



for dry hard wood

D

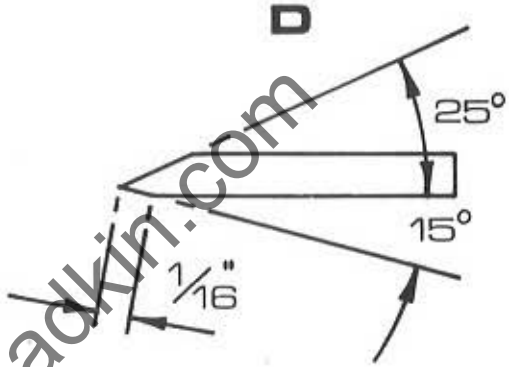
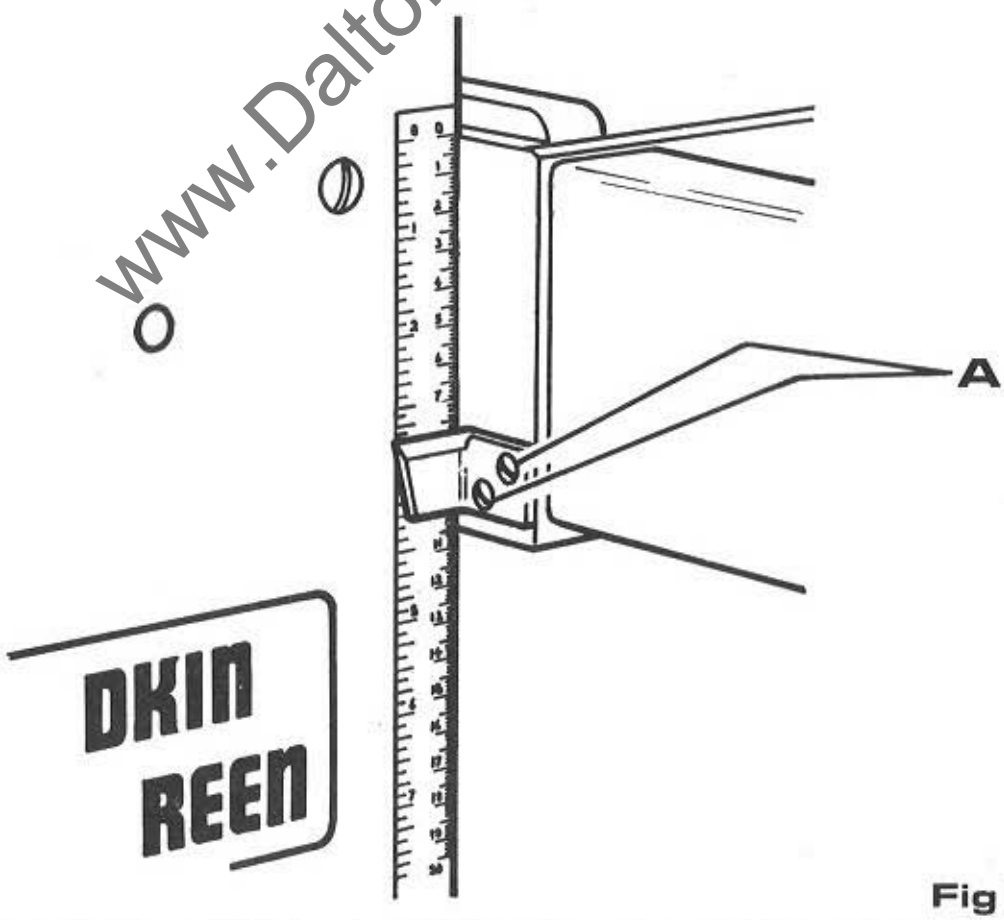


Fig D9



DKIN
REEN

Fig D10

THICKNESSING RULE
FIG. D10.

The pointer on the machine table is pre-set before despatch. Should it be disturbed, feed a piece of timber through the machine and measure the thickness accurately. Check that the reading given by the pointer corresponds to the thickness of timber machined. Should adjustment be necessary slacken the screws "A" in FIG. D10. and set pointer to the correct thickness.

GENERAL HINTS

1. When thicknessing long lengths of timber always support after the machine table, otherwise a step will appear on either or both ends.

2. When a smooth finish is required use the slow feed speed. For roughing when the finish is not important use the fast feed speed.
3. For the best results always feed the timber to cut with the grain.
4. Should the timber stick when thicknessing two probable causes are given below:
   (a) The table rollers are set too low in the table.
   (b) The spring pressure is too great on the pressure bars and too little on the feed rollers.

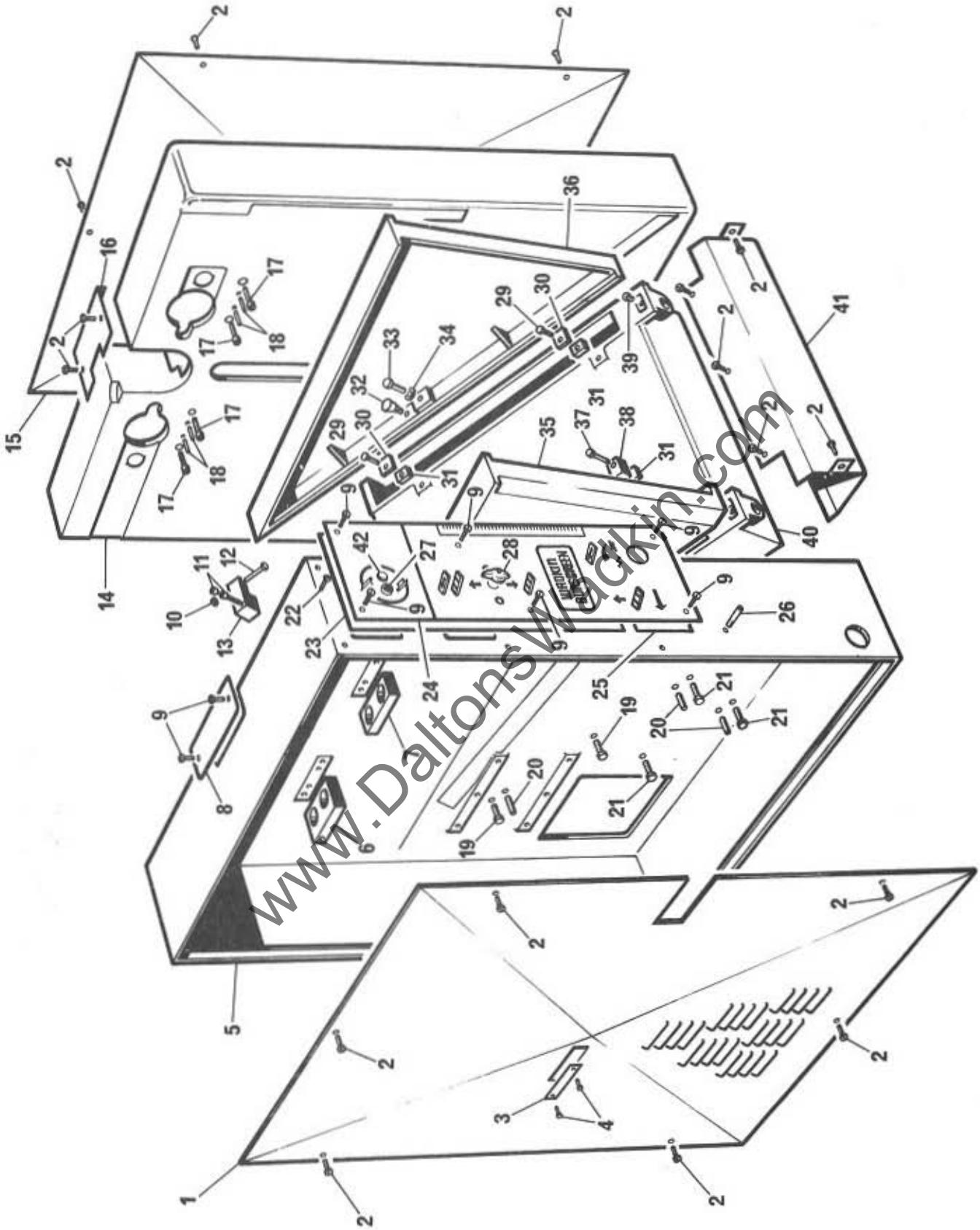
BURSGREEN (DURHAM) LIMITED
APPROVED LUBRICANTS

Application	Approved Lubricant					
	Castrol	B. P.	Shell	Esso	Texaco/ Caltex	Wadkin
Worm Boxes	Alpha 617	Energol CS425	Vitrea 75	Pen-O-Led E. P.3	Regal Oil J	L. 2.
General Lubrication	Magna ED	Energol HP. 20	Vitrea 33	Esstic 50	Ursa Oil P. 20	L. 4.
Pneumatic Lubricators	Hyspin AWS 32	Energol HL 65	Tellus 27	Nuto H 44	Rando Oil HDA	
Grease	Spheerol AP. 3	Energrease LS. 3	Alvania 3	Beacon 3 Starfak Premium 3	Regal	L. 6.
Brake Cables	Brake cable grease	Energrease L21M	Alvania 3	Multi-purpose grease H		

SECTION E

SPARE PARTS LISTS

When ordering replacement parts quote Part No. and Serial No. of the machine



MAIN FRAME ASSEMBLY

Ref. No.	Part No.	No. Off	Description
1	1069/208	1	Drive side cover
2		19	8mm x 10mm pan head screw
3	1069/136	1	Feed scale
4		2	1/8" dia x $\frac{1}{4}$" long self tapping screw
5	1069/235	1	Drive side frame
6	1069/162	1	Spring and jockey pressure plate
7	1069/48	3	Spring pressure plate
8	1069/84	1	Cover for belt aperture
9		8	6mm x 10mm pan head screw
10		1	8mm nut
11		2	8mm x 25mm socket head capscrew
12		1	8mm x 50mm hexagon head bolt
13	1069/186	1	Thicknessing table stop
14	1069/236	1	Rebate side frame
15	1069/243	1	Rebate side cover
16	1069/276	1	Spindle pulley cover
17		8	10mm x 25mm socket head capscrew
18		8	$\frac{1}{4}$" dia. x $1\frac{1}{4}$" long fluted dowel
19		2	12mm x 30mm hexagon head bolt
20		6	12mm x 28mm hardened ground dowel
21		8	12mm x 35mm hexagon head bolt
22		4	6mm x 10mm countersunk socket head screw
23	1069/89	1	Front panel back plate
24	1069/204	1	Control plate
25	1069/241	1	Front panel back plate
26	1069/295	1	Stop peg
27		1	Brooks "STOP" push button unit
28		1	Chilton switch No. C6 - A292 with tear drop handle
29		3	10mm x 25mm hexagon head bolt
30	1069/93	9	Wedge keeps
31	1069/92	4	Wedge keep locking piece
32	WF 1920	2	Spring lid oil cup wick feed (1/8" gas)
33		2	10mm x 35mm socket head capscrew
34	1032/22	2	Washer for rise and fall nut
35	1069/171	1	Wedge (left hand)
36	1069/171	1	Wedge (right hand)
37		1	10mm x 45mm hexagon head bolt
38	1069/187	1	Thicknessing table stop block
39	PC2	2	Grease nipple (1/8" gas)
40	1069/168	1	Base
41	1069/37	1	Cover for rise and fall gears
42		1	Brooks "START" push button unit

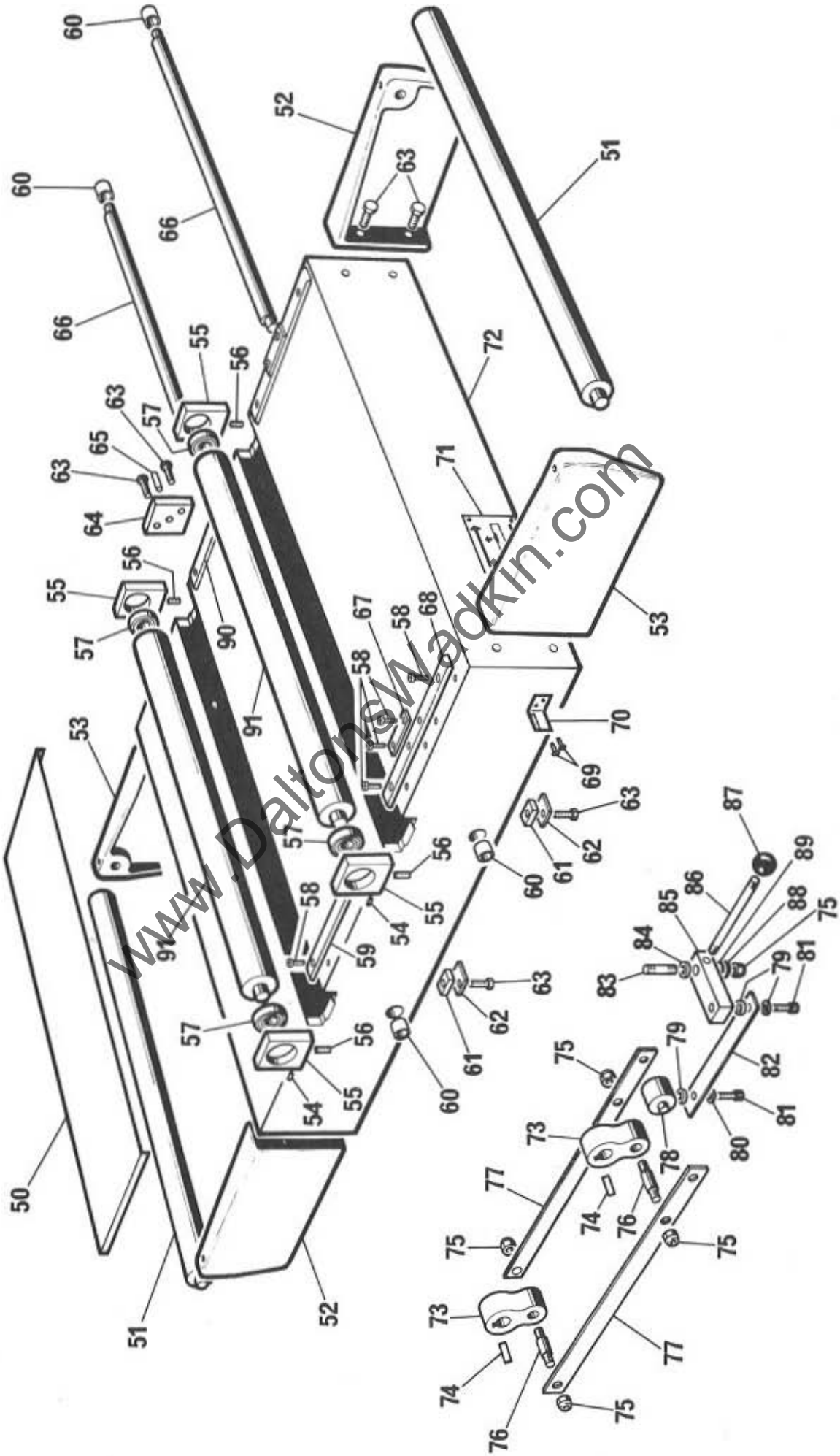
STOP START BUTTON PT Nº 5$17300
CONTACT BLOCK PT NO 5117314

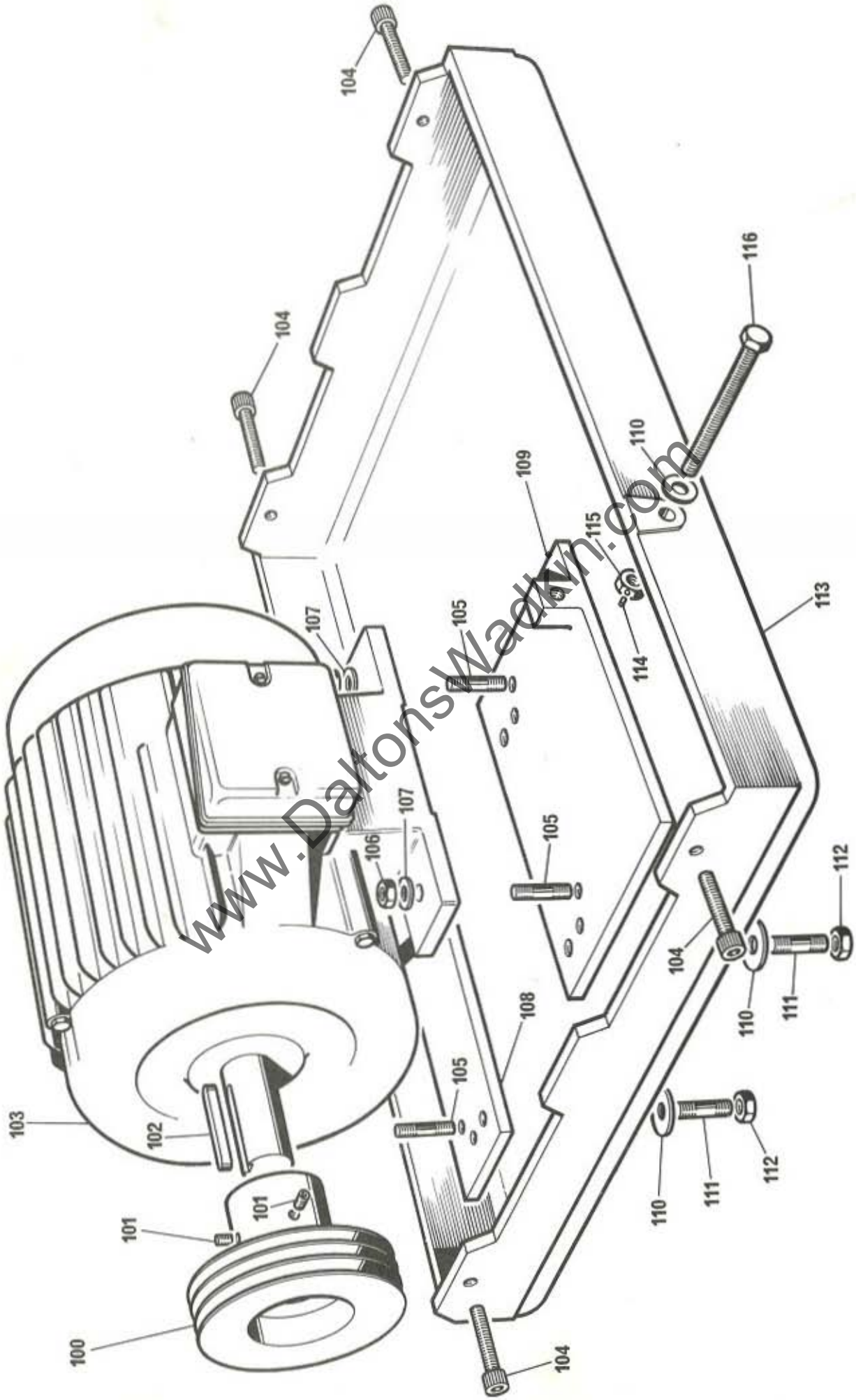
NOTE :- When ordering replacement parts quote Part No. and Serial No. of the machine

TABLE ASSEMBLY

Ref. No.	Part No.	No. Off	Description
50	1069/193	1	Cover for outfeed roller
51	1069/35	2	Outer table roller
52	1069/18	2	Outer table roller bracket (right hand)
53	1069/18	2	Outer table roller bracket (left hand)
54		4	6mm x 16mm long socket head grubscrew
55	1069/77	4	Under table roller bearing block
56	1069/239	4	Under table roller adjusting screw
57	SKF 62032RS	4	Bearing
58		12	6mm x 12mm long cheese head screw
59	1069/210	1	Left hand inner table strip
60	1069/78	4	Under table roller bushes
61	1069/92	4	Wedge keep locking piece
62	1069/93	4	Wedge keep
63		14	10mm x 25mm hexagon head bolts
64	1069/51	1	Table key
65		1	3/8" dia. x 1" long fluted dowel
66	1069/34	2	Under table roller eccentric
67	1069/228	2	Depth stop control plate
68	1069/97	2	Front table strip
69		2	1/8" dia. x 3/8" long self tapping screw
70	1069/292	1	Thicknessing pointer
71	1069/137	1	Table roller instruction plate
72	1069/5	1	Table
73	1069/72	2	Under table roller links
74		2	8mm x 7mm x 32mm feather key
75		5	10mm nut
76	1067/76	2	Under table roller link pin
77	1069/74	2	Under table roller adjusting link
78	1069/75	1	Under table roller swivel nut
79	1069/147	1	Roller link swivel
80		1	8mm washer
81		2	8mm x 25mm socket head capscrew
82	1069/145	1	Roller control link
83	1069/231	1	Stud for under-table mechanism
84		1	10mm fibre washer (thick)
85	1069/148	1	Under table swivel block
86	1069/32	1	Under table control lever
87		1	10mm x 32mm dia. plastic ball
88		1	10mm washer
89		1	10mm fibre washer (thin)
90	1069/209	1	Right hand inner table strip
91	1069/33	2	Under table roller

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





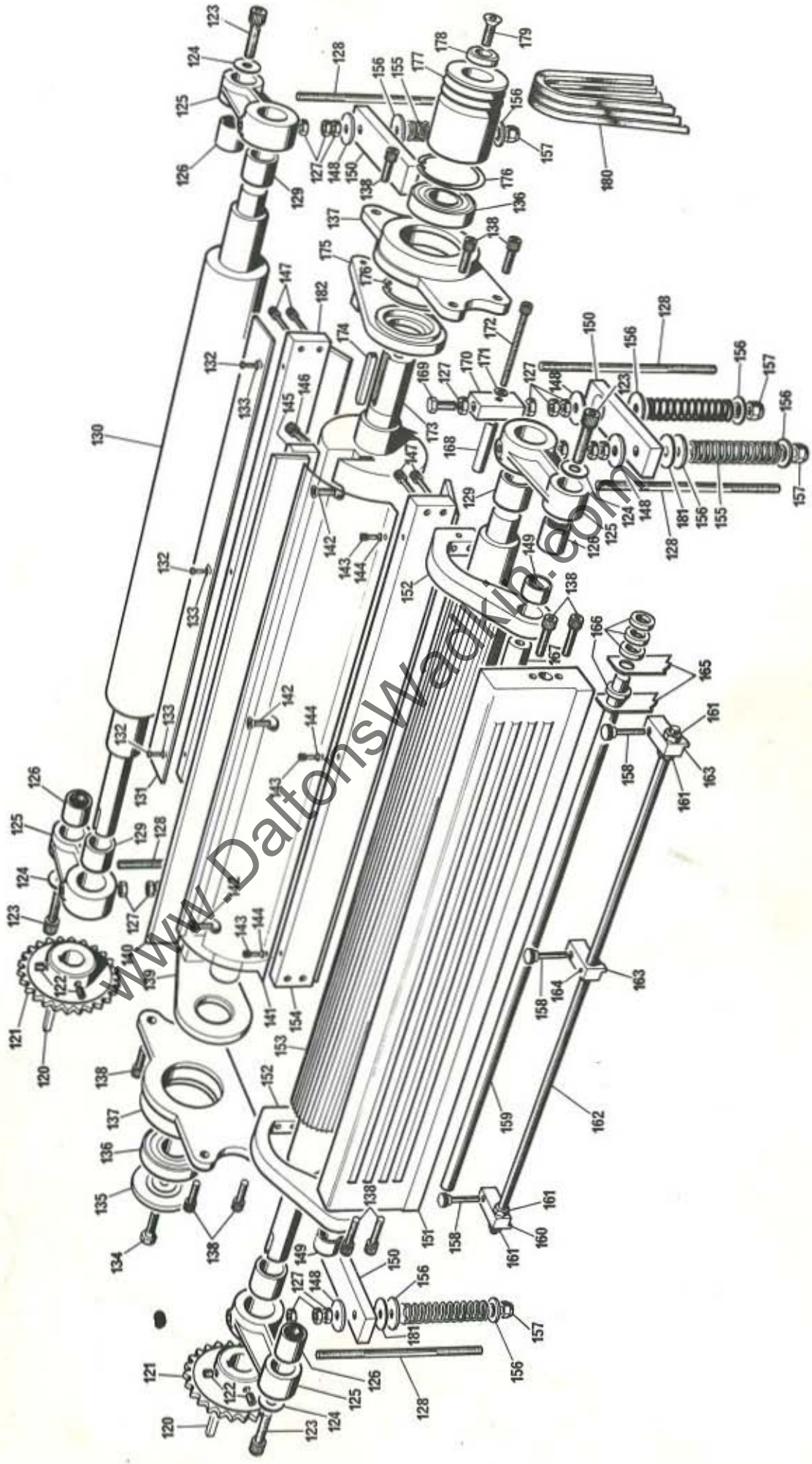
MOTOR MOUNTING ASSEMBLY

Ref. No.	Part No.	No. Off	Description
100	1069/23	1	Block motor pulley
101		2	10mm x 12mm socket head grubscrew
102		1	8mm x 10mm x 60mm feather key (ground to size)
103		1	Brook motor, 7.5HP, 3,000RPM, T.E.F.C. Frame D.132SA, Foot mounted star delta wound, 3PH, 50 cycles, Terminal box in std. position.
		1	Brook motor, 7.5HP, 3,600RPM, T.E.F.C. Frame D.132SA, Foot mounted star delta wound, 3PH 60 cycles. Terminal box in std. position. (SPECIAL)
104		4	12mm x 35mm socket head capscrew
105	1069/233	4	Stud for motor platform
106		4	10mm nut
107		4	10mm washer
108	1069/58	1	Plate for motor feet
109	1069/79	1	Motor adjustment plate
110		5	12mm washer
111	1069/234	4	Stud for motor platform
112		4	12mm nut
113	1069/6	1	Motor platform
114		1	6mm x 6mm socket head grubscrew
115		1	12mm nut (with 6mm tapped hole)
116		1	12mm x 100mm hexagon head bolt

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

CUTTERBLOCK ASSEMBLY

Ref. No.	Part No.	No. Off	Description
120		2	8mm x 6mm x 30mm feather key
121	1069/131	2	Feed roller sprocket
122		4	10mm x 10mm socket head grubscrew
123		4	12mm x 80mm socket head capscrews
124	1069/141	4	Washer for "Metalastic" bush
125	1069/11	4	Feed roller pivot arm
126		4	"Metalastic" bush
127		25	10mm locknut
128	1069/68	8	Stud for pressure bar spring
129	1069/78	4	Under table roller bush
130	1069/28	1	Outfeed roller
131	1069/240	1	Scraper plate
132		3	6mm x 10mm hexagon head bolt
133		3	6mm washer
134		1	12mm x 30mm hexagon head bolt
135	1069/38	1	Washer for cutterblock
136	6207-2RS	2	Cutterblock bearing
137	1069/7	2	Bearing housing
138		12	10mm x 30mm socket head capscrew
139	1069/9	1	Back pressure bar bracket (left hand)
140		as required	Cutterblock knives (state quantity required)
141	1069/86	1	Chip deflector
142	9NO Arm Screws.	6	8mm x 30mm countersunk socket head screw
143		3	6mm x 10mm socket head capscrew
144		3	6mm spring washer
145	1069/178	as required	Cutterblock wedge (state quantity required)
146	1069/183	as required	Cutterblock screw
147		8	8mm x 30mm socket head capscrew
148	1069/70	8	Washer for feed roller spring
149	BS 99	2	Oilite bush
150	1069/48	3	Spring pressure plate
151	1069/10	1	Front tie piece
152	1069/8	2	Front pressure bar bracket
153	1069/28	1	Infeed roller
154	1069/29	1	Front pressure bar
155	ETS 194	4	Feed roller spring
156	1069/69	16	Spring guide
157		8	10mm aerotight nut
158	1069/184	1	Knife setting device fixing screw
159	1069/82	1	Anti kick back fingers bar
160	1069/175	1	Knife setting device block (left hand)
161		4	10mm nut
162	1069/185	1	Knife setting tie bar
163	1069/175	2	Knife setting device block (right hand)
164		1	6mm x 6mm socket head grubscrew
165	1069/40	62	Knife back finger
166	1069/41	68	Spacer for kick back finger
167	1069/81	1	Tie bar
168	1069/50	4	Pressure bar tie rods
169		1	10mm x 45mm hexagon head bolt
170	1069/49	4	Pressure bar block
171		4	8mm washer
172		4	8mm x 90mm socket head capscrew
173	1069/198	1	Cutterblock
174		1	10mm x 7.2mm x 60mm feather key.
175	1069/9	1	Back pressure bar bracket (right hand)
176	5000/283	2	72mm internal circlip
177	1069/22	1	Cutterblock pulley
178	1069/39	1	Washer for cutterblock pulley
179		1	12mm x 35mm countersunk "nylok" socket head screw
180	ALPHA 630	3	Vee belts
181	1069/254	2	Washer for spring guide
182	1069/30	1	Rear pressure bar



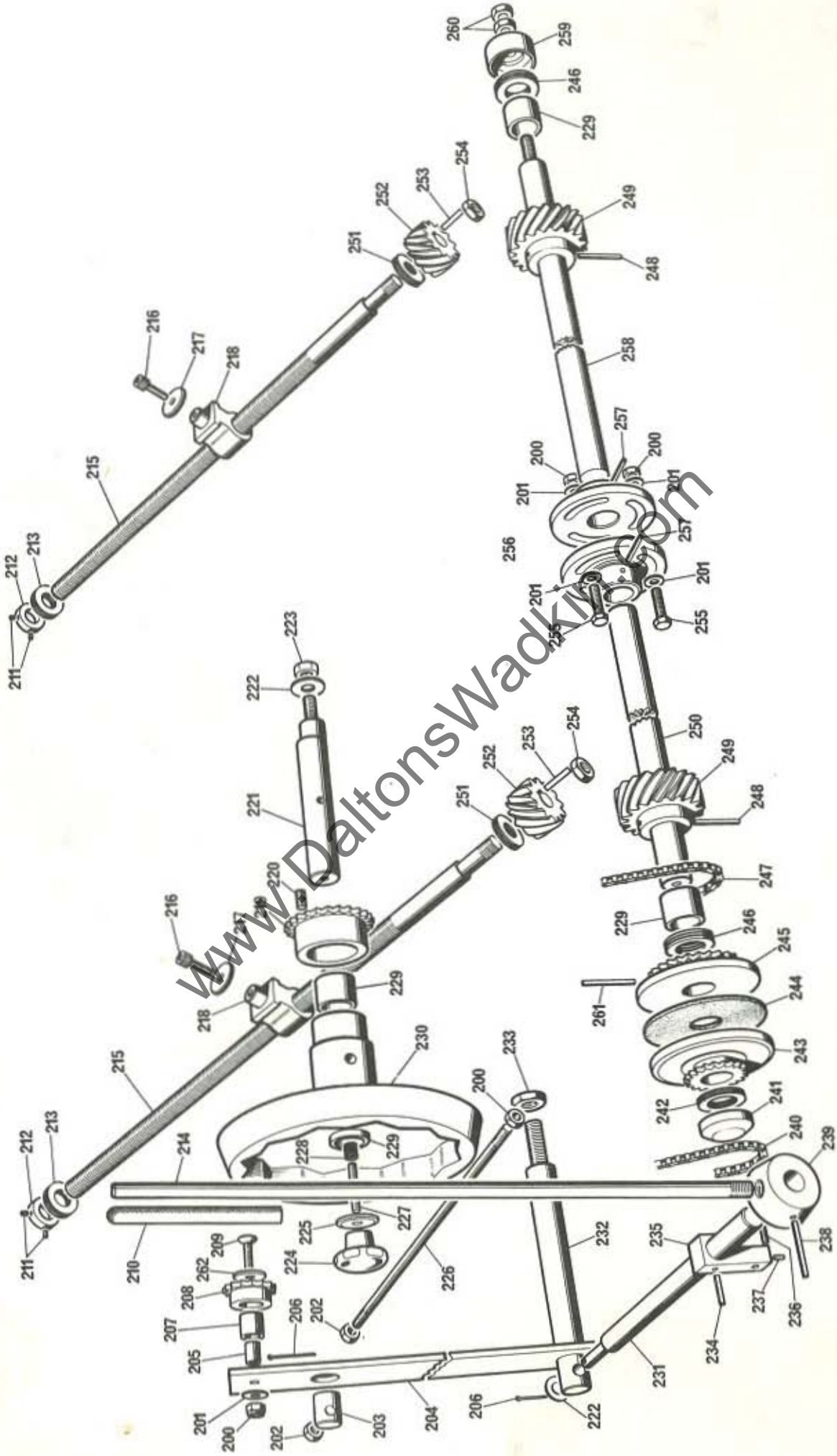


TABLE RISE & FALL ASSEMBLY

Ref. No.	Part No.	No. Off	Description
200		5	10mm nut
201		7	10mm washer
202		2	10mm locknut
203	1069/251	1	Pivot for rise and fall chain tension bar
204	1069/207	1	Table rise and fall chain tension bar
205	1069/64	1	Jockey sprocket bush
206		2	2.5mm x 30mm split pin
207	CT264A	2	16mm ID x 22mm OD x 20mm long oilite bush
208	1069/134	1	Jockey sprocket
209		1	10mm x 50mm countersunk slotted screw
210		1	14mm dia rubber handle
211		4	6mm x 6mm socket head grubscrew
212	1069/56	2	Stop for rise and fall screw
213	SKF 51104	2	Rise and fall screw bearing
214	1069/102	1	Clutch control lever
215	1069/173	2	Rise and fall screw
216		2	10mm x 35mm socket head capscrew
217	1032/22	2	Washer for rise and fall nut
218	1069/172	2	Rise and fall nut
219	1069/25	1	Handwheel sprocket
220		1	10mm x 20mm socket head grubscrew
221	1069/46	1	Rise and fall handwheel shaft
222		2	12mm washer
223		1	12mm nut
224		1	8mm x 44mm plastic handwheel
225	1062/47	1	Handwheel washer
226	1069/212	1	Adjusting screw for jockey sprocket
227	1069/230	1	Stud for rise and fall handwheel
228	1026/63	1	Handwheel return spring
229	BS 99	4	Oilite bush
230	1069/24	1	Rise and fall handwheel
231	1069/61	1	Clutch pressure shaft
232	1069/59	1	Rise and fall chain tension post
233		1	16mm locknut
234		1	6mm x 32mm groverlok spring dowel
235	1069/205	1	Clutch pressure link
236	1069/221	1	Adjusting screw for clutch pressure
237		1	6mm x 12mm socket head grubscrew
238		1	8mm x 50mm groverlok spring dowel
239	1069/63	1	Boss for clutch pressure shaft
240	110038	1	Roller chain (state no. of links including split link)
241	1069/66	1	Thrust bearing cover
242	INA-AXK 2542	1	Clutch thrust bearing
243	1069/20	1	Inner clutch sprocket
244	1069/73	1	Clutch for table rise and fall
245	1069/138	1	Outer clutch sprocket
246	SKF 51105	2	Rise and fall cross shaft bearing
247	110038	1	Roller chain (state no. of links including split link)
248		2	6mm x 45mm groverlok spring dowel
249	1069/14	1	Driving gear for table rise and fall
250	1069/31	1	Rise and fall cross-shaft (with female end)
251	SKF 51104	2	Rise and fall screw bearing
252	1069/13	2	Driven gear for table rise and fall
253		2	5mm x 5mm x 20mm key
254		2	16mm nut
255		3	10mm x 35mm hexagon head bolt
256	1069/15	2	Cross-shaft coupling
257		2	6mm x 40mm groverlok spring dowel
258	1069/31	1	Rise and fall cross-shaft (with male end)
259	1069/213	1	Cover for cross-shaft thrust bearing
260		2	12mm locknut
261		1	6mm x 60mm groverlok spring dowel
262	1069/83	1	Washer for jockey sprocket

VARIABLE DRIVE ASSEMBLY

Ref. No.	Part No.	No. Off	Description
270	1069/203	1	Anchor plate for feed roller spring
271	1034/44	1	Spring
272	1069/288	2	Gib strip
273		6	8mm x 16mm button head capscrew
274		9	8mm washer
275		1	8mm x 16mm socket head capscrew
276		8	8mm x 35mm stud
277	1069/60	1	Motor platform traverse screw
278	1069/56	2	Stop for rise and fall screw
279		2	6mm x 6mm socket head grubscrew
280		1	Holroyd type F.V. worm reduction box 20.5 to 1 reduction (50 cycle)
		1	Holroyd type F.V. worm reduction box 25 to 1 reduction (60 cycle) special
281		8	8mm nut
282	6202/2RS	1	Bearing for motor control shaft
283	Rencol No. 601	1	Handwheel
284	1069/99	1	Handwheel spacer
285		2	6mm x 12mm socket head grubscrew
286	110046	1	Roller chain (FEED ROLLERS)
287		1	6mm x 6mm x 40mm feather key
288		2	6mm x 10mm socket head grubscrew
289	1069/206	1	Gearbox output sprocket
290	110038	1	Roller chain (GEARBOX TO CROSS SHAFT)
291		1	5mm x 5mm x 32mm feather key
292		1	Variable pulley
293	1069/21	1	Gearbox input sprocket
294		2	8mm x 8mm socket head grubscrew
295		1	CRVSV24HO81O3D Variable pulley belt
296		1	6mm x 6mm x 35mm feather key
297		1	Brook motor, 1HP, 1,500RPM, Frame 80A, T.E.F.C. Foot mounted terminal box in standard position 3PH, 50cycles.
		1	Brook motor, 1HP, 1,800RPM, Frame 80A, T.E.F.C. Foot mounted terminal box in standard position 3PH, 60cycles. (SPECIAL)
298	1069/286	1	Feed motor platform.

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