

MB200 SlabMizer

Safety, Operation, Maintenance & Parts Manual

MB200

rev. A1.02



Safety is our #1 concern! Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

Form #2396_PL

Original Instructions

Please keep for future reference

SECTION 1	INTRODUCTION	1-1
1.1	Chip Extractor	1-3
1.2	SlabMizer Major Components	1-4
	<i>General Contact Information</i>	
	<i>Branches & Authorized Sales Centers Wood-Mizer Locations (North and South America)</i>	
1.3	Specifications	1-9
1.4	Dust/Chip Extractor Specifications	1-12
SECTION 2	SAFETY	2-1
2.1	Safety Symbols.....	2-1
2.2	Safety Instructions.....	2-1
	<i>Residual risk</i>	
SECTION 3	PLANER ASSEMBLY	3-1
3.1	Uncrating the Planer	3-1
3.2	Assemble the Bed Sections	3-3
3.3	Install the Side Rails.....	3-4
3.4	Install the Leg Assembly	3-5
3.5	Install The Head Stops.....	3-6
3.6	Install The Clamps.....	3-6
3.7	Leg Adjustment	3-7
3.8	Install the Gantry	3-8
3.9	Install the Head Retainers.....	3-8
3.10	Install the Feed Chain.....	3-9
SECTION 4	PLANER SETUP	4-1
4.1	Bed Frame Setup	4-1
4.2	Electrical Hookup.....	4-3
4.3	Electric Wiring	4-3
4.4	Vacuum Hose Hookup	4-5
4.5	Sanding Head.....	4-5
SECTION 5	PLANER OPERATION	5-1
5.1	Turning on Planer	5-1
5.2	Power Feed	5-2
5.3	Cross Feed	5-2
5.4	Head Up & Down.....	5-3
5.5	Cutter Start and Stop	5-4
5.6	Manual Operation.....	5-5
SECTION 6	MB200 AUTO FEED OPERATION	6-1
6.1	MB200 Auto Feed Control Panel.....	6-1
6.2	Light Column.....	6-1
6.3	Auto Feed Mode Operation	6-2
	<i>Working area after setting the limiters</i>	
	<i>Possible cases</i>	

SECTION 7	MAINTENANCE	7-1
7.2	Cross Feed Rope.....	7-1
7.3	Head Up & Down Threads.....	7-1
SECTION 8	TROUBLESHOOTING GUIDE	8-1
SECTION 9	PLANER ALIGNMENT	9-1
9.1	Routine Alignment Procedure.....	9-1
	<i>Alignment Front & Rear</i>	
	<i>Alignment Side to Side</i>	
	<i>Adjusting the Scale</i>	
	<i>Dust Head</i>	

SECTION 1 INTRODUCTION

Congratulations on your purchase of a Wood-Mizer SlabMizer!

Wood-Mizer is committed to providing you with the latest technology, best quality, and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we are meeting current wood-processing demands. Your comments and suggestions are welcome.

This documentation includes information on preparing the SlabMizer for operation and operating, servicing and repairing the machine.

GENERAL

Check your SlabMizer as soon as you receive it. Report any transport damage to the transport company immediately.

Lift the SlabMizer using a forklift or pallet jack with lifting capacity of minimum 800kg.

When replacing spare parts, use only original parts and note that anything electrical must be assembled by a qualified electrician.

APPLICATIONS

The SlabMizer can be used for flattening wood, chipboard, board, etc. of dimensions listed in "Specification" section. Hard materials such as chipboard, teak, MDF, etc. require hard carbide tools.

It is not allowed to use this machine for flattening any other material such as metal, ice etc.

The SlabMizer is designed for indoor use, with temporary outdoor use during good weather. It not allowed to use or store this machine outdoor when it is raining or snowing.

The SlabMizer should be operated only by an adult who has read and understood the entire operator's manual.

REQUIREMENTS

SlabMizer can be used in rooms with temperature range from -15°C to +40 C. Ventilation must be mechanical and in accordance with standards.

The SlabMizer must be connected to a dust/chip extractor. Extractor must be turned on when the machine is working. [See Section 1.4](#) for the dust extractor specification.

SAFETY DISTANCE



WARNING! Other than the operator, no one should be within 3 meters of the SlabMizer's sides or 8 meters from the in and out-feed sides during operation. Mark risk area on the floor.

MACHINE AND SITE PREPARATION

The machine is delivered on pallet. Due to the weight, it has to be transported with auxiliary lifting equipment and in accordance with general safety rules.

Check your SlabMizer as soon as you receive it. Any transport damage must be reported to the transport company immediately.

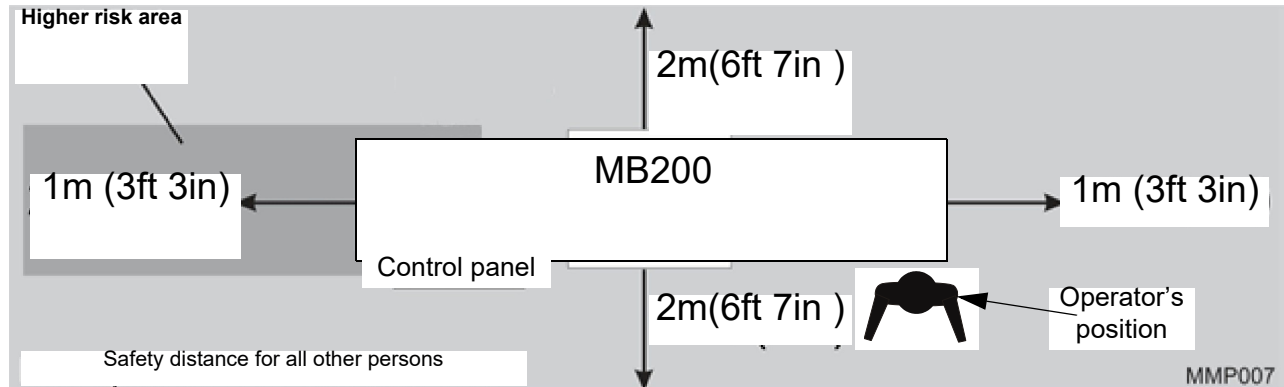
Most of the SlabMizer is protected against rust, but it will require extra maintenance in the form of lubrication for all the parts not protected against rust. See the Maintenance section.

- Place the SlabMizer on a stable and flat base.
- It is recommended to screw the SlabMizer down to the floor, if it does not have to be moved.
- Ensure that there is enough space for the longest boards you want to plane at the in and outfeed sides, and that there is enough space for maintenance and timber stocks.
- Connect the dust hoses and fix using the hose clips on the planer and fan.
- Hang the SlabMizer's electrical cable on the ceiling or protect it in another way. Never step on the cable. The SlabMizer should be connected via an earth-fault protection switch.
- CAUTION! The illumination at the operator's position should be at least 300lx. The light source can not cause stroboscopic effect. Ensure that there is no risk of glare.

SPACE REQUIREMENTS

The SlabMizer needs a space of at least 3m wide.

The minimum length is 8 m.



ANCHORING

It is recommended that the MB200 SlabMizer be anchored to the floor using 12 mm screws.

1.1 Chip Extractor

MB200 SlabMizer must be connected to chip extractor with a capacity of at least 5 000m³/h. Remember that chip container has to be equipped with an air vent (e.g. a fine net or filter if dust are collected indoors). During work in heated rooms, it is necessary to remember that the fan will quickly cool the space if the filtered air will not be supplied back into the building.

Contact the local authorities for advice in designing a chip collection system to conform with national rules.

It is necessary to set the fan so that it will be easy to reach the switch.



IMPORTANT! Remove the chips from the SlabMizer when the work is finished.

CHIP EXTRACTOR TECHNICAL REQUIREMENTS¹

- The chip extractor must be approved according to the CE-standard.
- The airflow "without external connection" must be approx. 5000 m³/hour. (The manufacturer's standard indication of airflow.)
- The chip extractor hose diameters for the SlabMizer = 100 mm (4") x 3 and 125 mm (5") x 1.
- Pressure drop should not exceed 1,5 kPa.



IMPORTANT! The dust extractor hoses must be grounded or made of materials not accumulating electrostatic charge.

1. EN 12779:2016-04 standard contains requirements for chip and dust extraction systems equipment with fixed installations.



CAUTION! Always turn on the chip extractor before starting the machine

1.2 SlabMizer Major Components

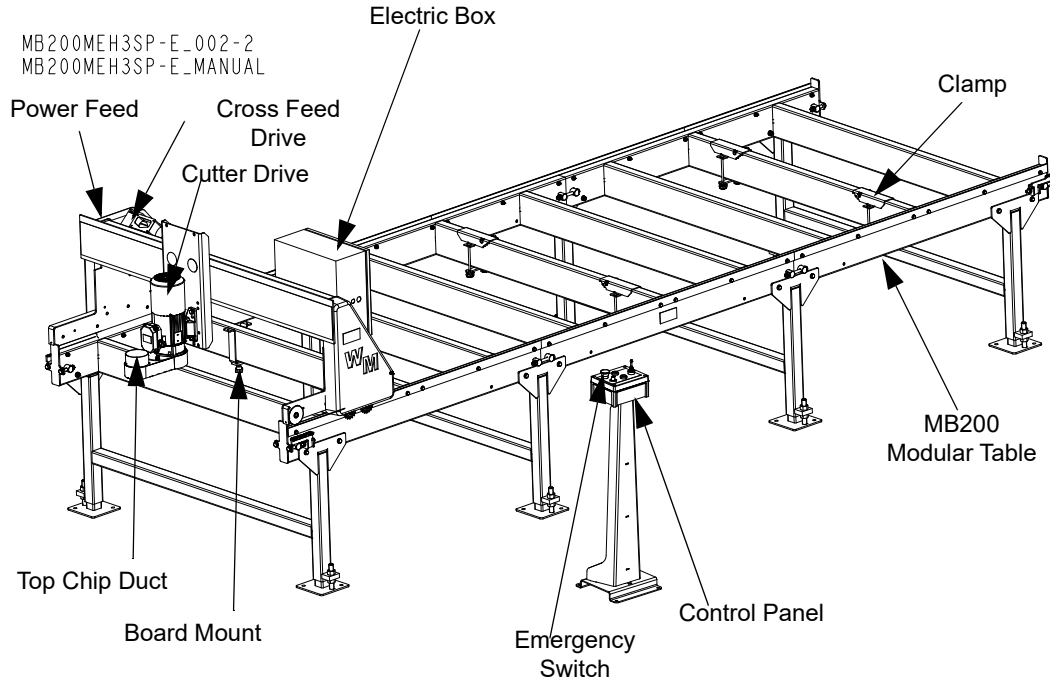


FIG. 1-1 MB200

Getting Service

Wood-Mizer is committed to providing you with the latest technology, best quality and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we're meeting current wood-processing demands. Your comments and suggestions are welcome.

General Contact Information

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Koło, Nagórna 114 St, Poland at **+48-63-2626000**. From the continental U.S., call our U.S. Headquarter 8180 West 10th St. Indianapolis, IN 46214, toll-free at **1-800-525-8100**. Ask to speak with a Customer Service Representative. Please have your machine identification number and your customer number ready when you call. The Service Representative can help you with questions about the operation and maintenance of your machine. He also can schedule you for a service call.

Office Hours:

Country	Monday - Friday	Saturday	Sunday
Poland	7 a.m.- 3 p.m.	Closed	Closed
US	8 a.m.- 5 p.m.	8 a.m.- 12 p.m	Closed

Please have your vehicle identification number and your customer number ready when you call.

Wood-Mizer will accept these methods of payment:

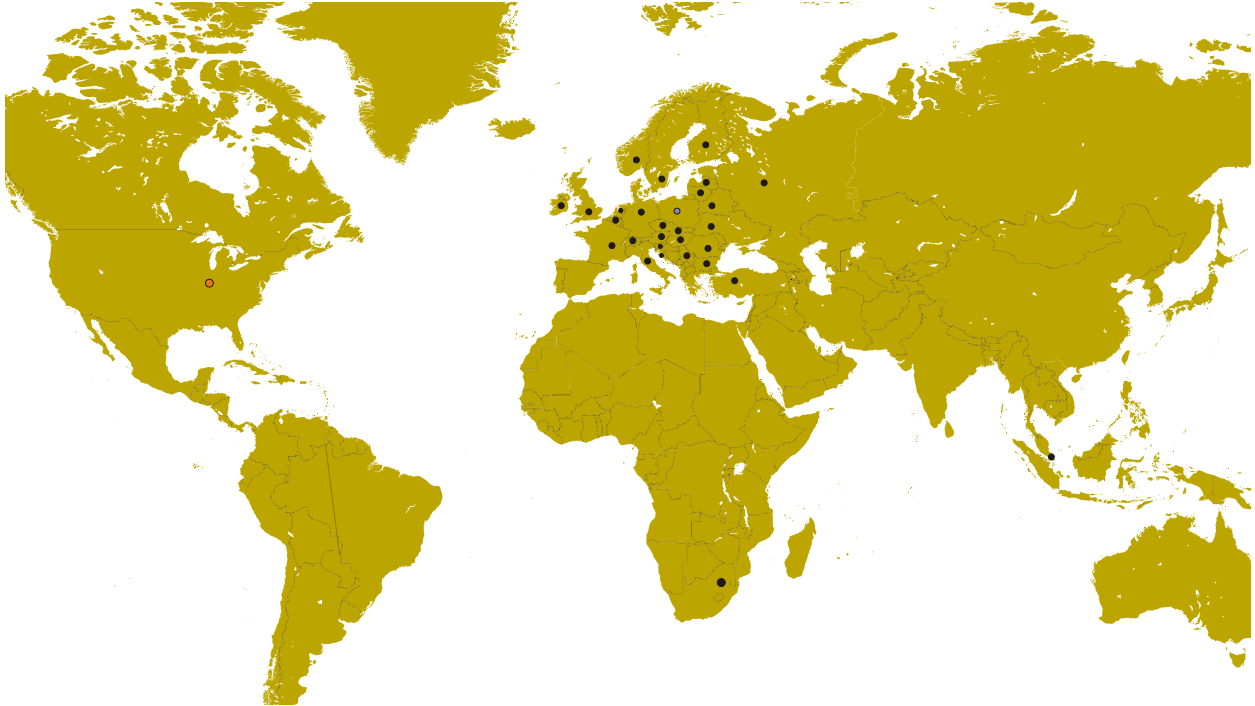
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)



Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

Technical data are subject to change without prior notice.

Actual product may differ from product images. Some illustrations show machines with optional equipment.

Branches & Authorized Sales Centers Wood-Mizer Locations (North and South America)



EUROPE		UNITED STATES
<p> European Headquarters Wood-Mizer Industries Sp. z o.o. Nagórna 114, 62-600 Kolo, Poland Tel.: +48-63-26-26-000 Fax: +48-63-27-22-327 www.woodmizer.eu</p>		<p> World Headquarters Wood-Mizer LLC 8180 West 10th Street Indianapolis, Indiana 46214-2400, USA Tel.: +1-317-271-1542 Fax: +1-317-273-1011 www.woodmizer.com</p>
<p>BELARUS MOST-GRUPP Siemashko 15, k.3 Minsk 2200116 Tel.: +375-17-270-90-08 Fax: +375-17-270-90-08 GSM: +375-29-649-90-80 e-mail: most-by@mail.ru</p>	<p>SWITZERLAND Stefan Wespi Maschinen u. Geräte Spezialarbeiten GmbH Eichstraße 4 6353 Weggis Tel.: +41-413-900-312 GSM: +41-799-643-594 info@woodmizer.ch www.woodmizer.ch</p>	<p>RUSSIA Dariusz Mikołajewski OOO WOOD-MIZER INDUSTRIES 141031, Moscow Reg., Mytishenski raj., pos. Veshki, Zavodskaja str., 3B Tel.Fax: +7(495) 788-72-35 Tel.Fax: +7(495) 641-51-60 e-mail: dariuszm@woodmizer-moscow.ru</p>
<p>BULGARIA Kalin Simeonov Ecotechproduct 38 Star Lozenski pat str. Sofia 1186 Tel.: +359-2-462-7035 Tel.: +359-2-963-1656 Tel./Fax : +359-2-979-1710 Kalin Simeonov GSM: +3592-963-2559 e-mail: office@ecotechproduct.com</p>	<p>HUNGARY Wiktor Turoczy Wood-Mizer Hungary K.F.T. Szonyi Ut 67., 2921 Komárom Tel./Fax: +36-34-346-255 e-mail: woodmizer@woodmizer.hu</p>	<p>RUSSIA Far East Wladimir Glazaczew “WM Service” Krasnoretchenskaya Str.111 680006 Khabarovsk Tel./Fax: +7-914-541-1183 e-mail: wms-khv@mail.ru</p>

<p>CROATIA Krešimir Pregernik Pregimex d.o.o. S. Batušića 31, 10090 Zagreb Tel./Fax: +3851-38-94-668 Krešimir Pregernik GSM: +3851-98-207-106 e-mail: Kresimir.Pregernik@gmail.com</p>	<p>ITALY Pasquale Felice Wood-Mizer Italia Srl Cda. Capoiaccio SN 86012 Cercemaggiore Campobasso Tel./Fax: +39-0874-798-357 GSM: +39-333-281-03-79 e-mail: wmitaliasrl@gmail.com</p>	<p>SERBIA Dragan Markov Wood-Mizer Balkan d.o.o. Svetosavska GA 3/3; P. Fah 25 23 300 Kikinda Tel./Fax: +381-230-25-754 Tel./Fax: +381-230-23-567 GSM: +381-63-568-658 e-mail: office@woodmizer.co.yu</p>
<p>CZECH REPUBLIC Miroslav Greill Wood-Mizer CZ s.r.o. Za Kasárny 946 339 01 Klatovy tel: +420-376-312-220 Greill Miroslav GSM: +420 602-439-799 e-mail: woodmizer@woodmizer.cz</p>		<p>SLOVAKIA Wiktor Turoczy Wood-Mizer Danubia s.r.o. Hadovce 5, 94501 Komárno Tel.: +421-35-77-40-316 Fax: +421-35-7740-326 GSM: +421-905-930-972 e-mail: woodmizer@woodmizer.sk</p>
<p>CZECH REPUBLIC Lubomir Kudlik Wood-Mizer Moravia Sovadinova 6 69002 Breclav Tel./Fax: +420-519-322-443 Lubomir Kudlik GSM: +420-602-734-792 e-mail: info@wood-mizer.net</p>	<p>LATVIA Vilmars Jansons OBERTS Ltd Gaujas str. 32/2 LV-2167 Marupe, Rigas Raj. Tel.: +371-7-810-666 Fax: +371-7-810-655 Vilmars Jansons GSM: +371-92-06-966 Andris Orols GSM: +371-28-33-07-90 e-mail: andris@oberts.lv</p>	<p>TURKEY Er-Ka Ahsap Profil Kerestecilik San. ve Tic. Ltd. Sti. Adana Keresteciler Sitesi 191 sk No.41 ADANA Tel.: +90-322-346-15-86 Fax: +90-322-345-17-07 GSM: +90-533-363-18-44 e-mail: info@erkaahsap.com.tr</p>
<p>FINLAND Howard Blackburn Oy Falkberg Jordbruk Ab Falkintie 220 25610 Ylonkyla Tel.: +358-2732-2253 Fax: +358-2732-2263 Howard Blackburn GSM: +358-440-424-339 e-mail: falkberg@woodmizer.fi</p>	<p>LITHUANIA Andrius Zuzevicius UAB Singlis Savanoriu pr. 187, 2053 Vilnius Tel.: +370-5-2-32-22-44 Fax: +370-5-2-64-84-15 GSM: +370-620-28-645 e-mail: andrius.z@singlis.lt</p> <p>Dmitrij Gaiduk GSM: +370-69-84-51-91 e-mail: dmitrijus.g@singlis.lt</p>	<p>UKRAINE Ivan Vinnicki MOST UKRAINA bul. Myru 3, Bajkivtsi Ternopolskyj r-j Ternopolska oblast 47711 Ukraine Tel/Fax: +38 (0352) 52 37 74 GSM: +38 (067) 352 54 34 GSM: +38 (067) 674 50 68 E-mail: most-ukraina@ukr.net</p>
<p>FRANCE Tizoc Chavez Wood-Mizer France 556 chemin des Embouffus, ZAC des Basses Echarrieres 38440 SAINT JEAN DE BOURNAY Tel: +33-4 74 84 84 44 GSM: +33-607 52 02 82 Mail: tchavez@woodmizer.fr</p>	<p>NORWAY Tor Bakken Flaathe Bakken Flaathe A/S Løkenvegen 5, 2034 Holter Tel: + 47-638 74 989 Sales: + 47- 412 80 076 Service: +47- 975 87 588 post@woodmizer.no www.woodmizer.no</p>	<p>UNITED KINGDOM & IRELAND Wood-Mizer UK Hopfield Barn Kenward Road, Yalding Kent ME18 6JP, UK Tel.: +44-1622-813-201 Fax: +44-1622-815-534 e-mail: info@woodmizer.co.uk</p>
<p>SLOVENIA Jan Fale FAMTEH d.o.o. Gacnikova pot 2, 2390 Ravne na Koroskem Tel.: +386-2-62-04-232 Fax: +386-2-62-04-231 Jan Fale GSM: +386-2-62-04-230 e-mail: jan.fale@famteh.si</p> <p>Matjaz Kolar Tel.: +386-2-62-04-232 GSM: +386-31-775-999 e-mail: matjaz.kolar@famteh.si</p>		

<p>GERMANY/AUSTRIA Klaus Longmuss Wood-Mizer GmbH Dorfstraße 5, 29485 Schletau Büro Tel: +49-5883 988 010 Werkstatt Tel: +49-5883 988 220 Ersatzteilservice Tel: +49 58 83 - 98 80 250 Schärfservice Tel: +49-58 83 - 98 80 270 E-mail: info@woodmizer.de www.woodmizer.de Klaus Longmuss Tel.: +49-5883-9880-12 GSM: +49-17-298-55-892 e-mail: KLongmuss@woodmizer.de</p>	<p>Subagent: SWEDEN Kjell Larsson Mekwood AB Slingan 14, 812 41 Gästrike-Hammarby Tel.: +46-290-515-65 Kjell Larsson GSM: +46-706-797-965 e-mail: kjell.larsson@mekwood.se</p>	<p>IRELAND Wood-Mizer Ireland Stephen Brennan Cum Lahardane Ballina County Mayo Tel: +353 96 51345 E-mail: brennanmill@ericom.net</p>
<p>Subagents: DENMARK Kevin Christiansen Kevin Christiansen's savværker PMV Arnborgvej 40, 7330 Brande- Fasterholt Mobile: +45 61468763 Mobile: +45-23495828 Info@woodmizer.dk www.woodmizer.dk</p>	<p>ROMANIA Adrian Echert SC WOOD-MIZER RO SRL TRANSILVANIEI Nr. 5 Sibiu, Cisnadia 555300 Tel./Fax: : +40-369-405-433 GSM: +40-745-707-323 e-mail: aechert@woodmizer.ro</p>	<p>Regional Manager - Asia Robert Moxham Regional Direction - Asia Wood-Mizer Asia Manufacturing Co., Ltd. No.2, Gongyequ 40th Rd. Xitun District, Taichung City, 40768, Taiwan, R.O.C. TEL: +886-4-2359 3022 FAX: +886-4-2359 3205 CELL: +886-9-0568 7708 EMAIL: RMoxham@woodmizer.com www.woodmizerasia.com Skype: r.g.moxham</p>
<p>NETHERLANDS Gerlo Breukers Breukers Houtzagerij en Bosbouw machines Hazenweg 5, 7481 PC Haaksbergen Tel: +31-535741326 Mobile: +31-620419412 info@woodmizer.nl www.woodmizer.nl</p>	<p>Subagent: ROMANIA M. Echert S.C. Echert Comprod s.r.l Str. Schitului Nr. 6, Apt.7 etajul-1 725 70 Vatra Dornei, Romania Tel./Fax: +40-230-374-235 Tel. : +40-740-35-35-74</p>	<p>Regional Manager - Africa Gavin Prowse Regional Sales Director - Africa Wood-Mizer Africa (Pty) Ltd. Unit 1, Leader Park 20 Chariot Street Stormill Ext.5 Maraisburg, Johannesburg South Africa TEL: +27 11 473 1313 FAX: +27 11 473 2005 CELL: +27 71 398 8010 EMAIL: gprorowse@woodmizer.com www.woodmizerafrika.com Skype: gavin.prowse</p>

USA World Headquarters

Serving North & South America, Oceania, East Asia

Wood-Mizer LLC
8180 West 10th Street
Indianapolis, IN 46214

Phone: 317.271.1542 or 800.553.0182
Customer Service: 800.525.8100
Fax: 317.273.1011
Email: infocenter@woodmizer.com

Brazil Headquarters

Serving Brazil

Wood-Mizer do Brasil
Rua Dom Pedro 1, No: 205 Bairro: Sao Jose
Ivoti/RS CEP:93.900-000

Tel: +55 51 9894-6461/ +55 21 8030-3338/ +55 51 3563-4784
Email: info@woodmizer.com.br

Canadian Headquarters

Serving Canada

Wood-Mizer Canada
396 County Road 36, Unit B
Lindsay, ON K9V 4R3

Phone: 705.878.5255 or 877.357.3373
Fax: 705.878.5355
Email: ContactCanada@woodmizer.com

Europe Headquarters

Serving Europe, Africa, West Asia

Wood-Mizer Industries Sp z o.o.
Nagorna 114
62-600 Kolo, Poland

Phone: +48.63.26.26.000
Fax: +48.63.27.22.327

Branches & Authorized Sales Centers

For a complete list of dealers, visit www.woodmizer.com

1 Specifications

1.3 Specifications

Power

3HP Electric

Material Capacities

Min width 0" or 3" if not clamped between larger material

Max width – 56" or 72" (MB200 Wide)

Min thickness 1/2"

Max thickness 8"

Min length 22"

Max length – 13' or longer with 5' bed extensions

Min depth of cut 1/64"

Max depth of cut – 1/8"

Cutter Head

Knives – Five 4-sided carbide (15 x 15 x 2.5mm – R150)

Sanding Head – 7" orbital with hook and loop paper

(Velcro) Speed – Variable up to 5,500 RPM

Feed Motor Motor, 1/6hp 90RPM 3phase 19:1 gear Continuous

Duty Feed Speed:

Power feed - 21 m/min.

Left/Right – 6.2 m/min.

Machine Dimensions & Weight

Length – 182"

Width – 65"

Table Height – 30" – 33"

Machine Height 71"

Max Weight: 750kg/850kg (MB200 Wide)

Shipment Weight- 680kg (machine) + 70kg (palette)/750kg (machine) +100kg (palette)

Machine Standards & Requirements

Electrical requirements – 1-Phase, 220V, 30 A

Dust collection port diameter 3 1/2" OD of dust head.

See Table. 1-1. See the table below for technical data on the motors.

Motor Type	Manufacturer	Model No.	Other Data
Electric Motor E3, 2.2 kW	Besel	SLh90-2LH2SP	3 x 400V, 50 Hz, 33.8A 2930 r.p.m.
Cross Feed Motor 0.7kW			24V DC 90 rpm

TABLE. 1-1

See Table. 1-2. The overall dimensions of the MB200 are given in the table below.

SlabMizer type	MB200
Height	1803 mm
Width	1651 mm
Length	4622 mm

TABLE. 1-2

See Table. 1-3. Material capacities of the MB200 are given in the table below.

SlabMizer type	MB200
Min width	0 or 75 mm
Max width	1422 or 1828
Min thickness	12 mm
Max thickness	203
Min length	558
Max length	3962
Min depth cut	0,4 mm
Max depth cut	3,2 mm

TABLE. 1-3

See Table. 1-4. The noise level generated by Wood-Mizer SlabMizer is given in the table below^{1 2 3}

	Noise Level
SlabMizer MB200 Equipped with electric motor	$L_{pA} = \text{--dB (A)}$

TABLE. 1-4

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard . Value for associated uncertainty $K=4\text{dB}$.
2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission levels and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. Factors that influence the actual level of exposure of the workforce include the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. Also, the permissible exposure level value may vary depending on country. This information enables the machine's user to better identify hazards and a risk.
3. The total value of hand-arm vibration the operator may be exposed to does not exceed 2.5 m/s^2 . The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0.5 m/s^2 .

1 Specifications

Specifications



IMPORTANT! The total value of hand-arm vibration the operator may be exposed to does not exceed 2.5 m/s^2 . The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0.5 m/s^2 .

1.4 Dust/Chip Extractor Specifications

See Table. 1-5. Specifications of the dust/chip extractors used on the MB200 are listed below.

Airflow	5000 m ³ /h
Inlet diameter	3x100mm 1x125 mm
Motor power	4 kW
Number of sacks	1-2 pcs
Sack capacity	--
Recommended conveying air velocity in the duct	25 m/s

TABLE. 1-5

The pressure drop between the inlet of the capture device and the connection to the CADES should be maximum 1,5 kPa (for the nominal air flow rate). If the pressure drop exceeds 1,5 kPa the machine might not be compatible with conventional CADES.



IMPORTANT! The dust extractor hoses must be grounded or made with materials not accumulating electrostatic charge.

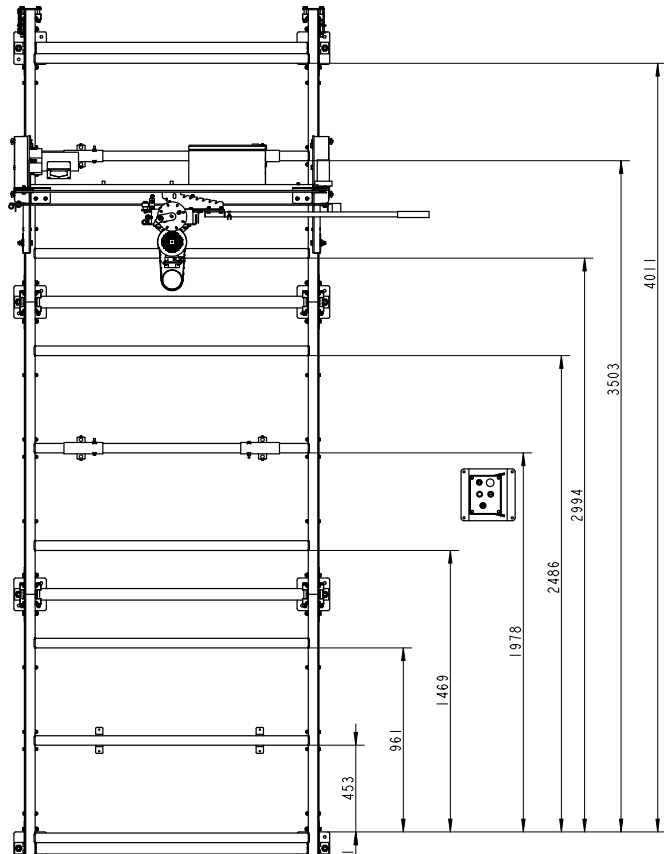
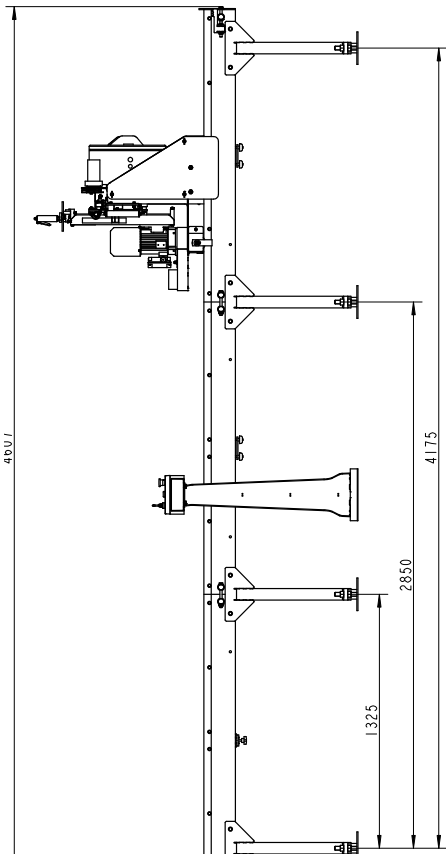
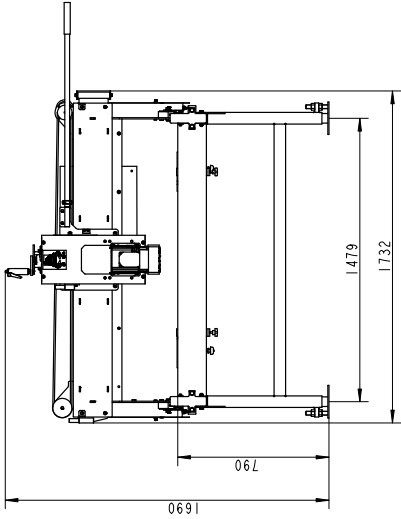
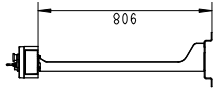


CAUTION! Always turn on the dust extractor before starting the machine

1 Specifications

Dust/Chip Extractor Specifications


MB200 Dimensions





SECTION 2 SAFETY


2.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions.


 **DANGER!** indicates an imminently hazardous situation which, if not avoided, will result in serious injury or death.

 **WARNING!** suggests a potentially hazardous situation which, if not avoided, could result in serious injury or death.

 **CAUTION!** refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury or damage to equipment.

 **IMPORTANT!** indicates vital information.


NOTE: gives helpful information.

 Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

2.2 Safety Instructions

NOTE: ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding planer/moulder damage appear where applicable throughout the manual.

- Observe Safety Instructions

 **IMPORTANT!** Read the entire Operator's Manual before operating the planer/moulder. Take notice of all safety warnings throughout this manual and those posted on the equipment. Keep this manual with this equipment at all times, regardless of ownership.

Read all additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions!

IMPORTANT! Only adult persons who have read and understood the entire operator's manual should operate the planer/moulder. The sawmill is not intended for use by or around children. Never operate the planer/moulder under the influence alcohol or any other drugs.

IMPORTANT! The operator of the planer/moulder should get adequate training in the operation and adjustment of the machine.

IMPORTANT! It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer planer/moulder. All Wood-Mizer planer/moulder owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the planer/moulder.

Residual risk



DANGER! Risk of injury!

Despite compliance with all safety regulations, there are the following types of residual risk:

- Risk of injury while changing planing knives.
- Risk of injury from the rotating knife shaft.
- Risk of injury from thrown out elements.
- Risk of injury due to recoil (while leveling).
- Risk of hearing damage.
- Risk of health loss due to dustiness, especially while processing beech and oak wood.

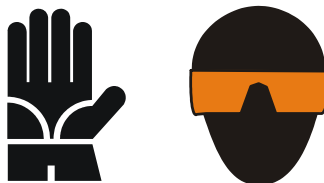
- Wear Safety Clothing



WARNING! Secure all loose clothing and jewelry before

operating this machine. Failure to do so may result in serious injury or death.

WARNING! Wear safety goggles and gloves when operating machinery. Failure to do so may result in serious injury.



WARNING! Always wear ear, respiration and foot protection when operating planer/moulder.



- Keep the Machine And Area Around Clean



DANGER! Maintain a clean and clear path for all necessary movement around the planer/moulder and lumber stacking areas. Failure to do so will result in serious injury.

- Dispose of Sawing By-Products Properly



IMPORTANT! Always properly dispose of all sawing by-products, including sawdust and other debris.

- Check planer/moulder before operation.



DANGER! Make sure all guards and covers are in place and secured before operating planer/moulder. Check that knobs, screws, nuts, fences, sleeves, planing cutters, planing knives, etc. are properly tightened. Also check that the cutter can rotate freely and that there are no tools in or on the planer/moulder before it is started. Failure to do so may result in serious injury.



WARNING! Always shut off the motor to stop the cutter whenever the planer/moulder is not in use. Failure to do so may result in serious injury.

WARNING! Do not for any reason adjust the engine drive belts with the engine running. Failure to do so will result in serious injury.

- Keep all people away

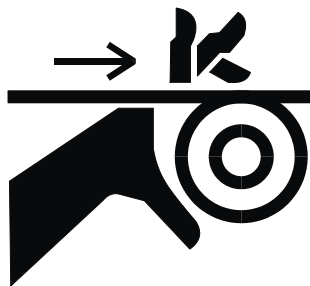


DANGER! Other than the operator, no one should be within 3 meters of the planer/moulder's sides during operation. Failure to do so will result in serious injury.

- Keep Hands Away

DANGER! Moving parts can cut or crush fingers or hand. Keep hands clear. Make sure all guards and covers are in place and secured before operating the planer/moulder. Failure to do so may result in serious injury.

DANGER! Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.





WARNING! Beware of rotating parts. Shut down the


sawmill and allow all moving parts to come to a complete stop before removing any guards and covers. Do NOT operate planer/moulder with any guards or covers removed.


DANGER! Before changing the knives or performing any service to planer/moulder, disconnect the power cord from the electric box.


IMPORTANT! Knife and feed assembly covers are equipped with limit switches. After opening the cover, engine will turn off and all moving parts will stop. Limit switches should be always in proper working condition.


 **WARNING!** Do not set up the planer on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the planer or dig out areas for the legs to keep planer level. Setting up the planer on an incline could cause it to tip over.


 **WARNING!** Keep all persons out of the path of moving equipment and slabs when operating planer or loading and turning slabs.


 **DANGER!** Perform the power lockout procedure before changing the cutter or performing any service to the machine.

 **DANGER!** Always disengage the cutter and shut off the planer motor before changing the cutter.


 **DANGER!** Keep hands, feet, and other objects away from cutter guards when operating planer.

 **DANGER!** Stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.

 **WARNING!** Turn off the motor whenever the planer is not cutting.

 **WARNING!** Always make sure slab is clamped securely before planing.

Never use the planer/moulder under the influence of strong medication, alcohol or any other strong drugs.

 **WARNING!** Make sure the knives are properly fastened before starting the motor.





WARNING! Never place tools or hands into the in or outfeed areas when the planer/moulder is running.



IMPORTANT! When starting the machine for the first time, check that cutter rotation direction is as indicated by the arrow located on the side cover. If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of cutter.

- Use proper maintenance procedures



DANGER! Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.

DANGER! Hazardous voltage inside the electric boxes and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during mill operation.



WARNING! Consider all electrical circuits energized and dangerous.

WARNING! Never assume or take the word of another person that the power is off; check it out and lock it out.

WARNING! Do not wear rings, watches, or other jewelry while working around an open electrical circuit.



IMPORTANT! Planer/moulder is equipped with emergency switch. It is used to immediately stop the machine in case of emergency. Emergency switch should be always in good condition.

IMPORTANT! Planer/moulder should not be modified by owner. Use only original spare parts.

- Keep safety labels in good condition.



IMPORTANT! Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor or Wood-Mizer Customer Service to order more decals.

IMPORTANT! If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed in the same place.

- Fire protection

CAUTION! The work-stand of the planer/moulder should be equipped with a 4 kg or bigger dry powder extinguisher.

2 Safety

Residual risk

See Table 2-1. See the table below for descriptions of the pictographic warning and informational decals placed on the MB200 sawmill.

TABLE 2-1

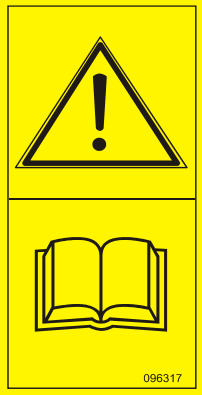


Decal View	Decal No.	Description
	096317	CAUTION! Read thoroughly the operator's manual before operating the sawmill. Observe all safety instructions and rules when operating the machine.
	545701	CAUTION! Remove The Plug Before Removing The Cover.
	099221H	CAUTION! Keep all persons away from work area when operating the machine.

TABLE 2-1

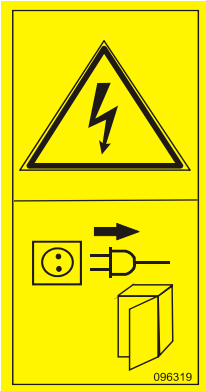


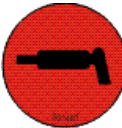



	<p>096319</p>	<p>CAUTION! Disconnect power supply before opening the box.</p>
	<p>S12004G</p>	<p>CAUTION! Always wear safety goggles when operating the sawmill.</p>
	<p>S12005G</p>	<p>CAUTION! Always wear protective ear muffs when operating the sawmill!</p>
	<p>501467</p>	<p>Lubrication point</p>
	<p>P85070</p>	<p>CE certification marking</p>

TABLE 2-1

 <p>The logo features a stylized 'PC' inside a circle, with the Cyrillic characters 'АЯ04' below it. A small '099401' is printed in the bottom right corner of the logo's border.</p>	099401	Russian certification marking
 <p>The logo consists of a solid black arrow pointing upwards, enclosed in a rounded rectangular border. The code 'S20097' is printed at the bottom of the border.</p>	S20097	Direction of motor revolutions

2.3 Electrical Lockout Procedures

RULES FOR USING LOCKOUT PROCEDURE

The Planer shall be locked out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch or valve bearing a lock.

LOCKOUT PROCEDURES MUST BE USED DURING:

Changing or adjusting cutters	Electrical maintenance
Unjamming operations	Retrieval of tools/parts from work area
Cleaning	Activities where guards or electrical panel guard is open or removed
Mechanical repair	

MAINTENANCE HAZARDS INCLUDE:

cutter contact	Missiles (thrown cutters/wood chips)
Pinch points	Electrical
Kickbacks	

FAILURE TO LOCKOUT MAY RESULT IN:

Cut	Serious injury and death
Crush	Amputation
Blindness	Burn
Puncture	Shock
Electrocution	

TO CONTROL MAINTENANCE DANGERS:

- Lockout procedures must be followed (see OSHA regulation 1910.147).
- Never rely on machine stop control for maintenance safety (emergency stops, on/off buttons, interlocks).
- Do not reach into moving cutters or feed systems. Allow all coasting parts to come to a complete stop.
- Electrical power supply and air supply must both be locked out.

- Where established lockout procedures cannot be used (electrical troubleshooting or mechanical dynamic troubleshooting), alternative effective protective techniques shall be employed which may require special skills and planning.
- Always follow safe operations practices in the workplace.

PLANER LOCKOUT PROCEDURE

Lockout procedures per OSHA regulation 1910.147, appendix A:

GENERAL

The following simple lockout procedure is provided to assist owner/operators in developing their procedures so they meet the requirements of OSHA regulation 1910.147. When the energy isolating devices are not lockable, tagout may be used, provided the owner/operator complies with the provisions of the standard which require additional training and more rigorous periodic inspections. When tagout is used and the energy isolating devices are lockable, the owner/operator must provide full operator protection (see OSHA regulation 1910.147, paragraph (c)(3)) and additional training and more rigorous periodic inspections are required. For more complex systems, more comprehensive procedures may need to be developed, documented, and utilized.

PURPOSE

This procedure establishes the minimum requirements for the lockout of energy isolating devices whenever maintenance or servicing is done on machines or equipment. It shall be used to ensure that the machine or equipment is stopped, isolated from all potentially hazardous energy sources and locked out before personnel perform any servicing or maintenance where the unexpected energization or start-up of the machine or equipment or release of stored energy could cause injury.

COMPLIANCE WITH THIS PROGRAM

All personnel are required to comply with the restrictions and limitations imposed upon them during the use of lockout. The authorized personnel are required to perform the lockout in accordance with this procedure. All operators, upon observing a machine or piece of equipment which is locked out to perform servicing or maintenance shall not attempt to start, energize, or use that machine or equipment.

SEQUENCE OF LOCKOUT

1. Notify all affected personnel that servicing or maintenance is required on a machine or equipment and that the machine or equipment must be shut down and locked out to perform the servicing or maintenance.
2. The authorized employee shall refer to the company procedure to identify the type and magnitude of the energy that the machine or equipment utilizes, shall understand the hazards of the energy, and shall know the methods to control the energy.
3. If the machine or equipment is operating, shut it down by the normal stopping procedure (depress the stop button, open switch, close valve, etc.).
4. De-activate the energy isolating device(s) so that the machine or equipment is isolated from the energy source(s).
5. Lock out the energy isolating device(s) with assigned individual lock(s).
6. Stored or residual energy (such as that in capacitors, springs, elevated machine members, rotating flywheels, hydraulic systems, and air, gas, steam, or water pressure, etc.) must be dissipated or restrained by methods such as grounding, repositioning, blocking, bleeding down, etc.
7. Ensure that the equipment is disconnected from the energy source(s) by first checking that no personnel are exposed, then verify the isolation of the equipment by operating the push button or other normal operating control(s) or by testing to make certain the equipment will not operate.



CAUTION! Return operating control(s) to neutral or "off" position after verifying the isolation of the equipment.

8. The machine or equipment is now locked out.

RESTORING EQUIPMENT TO SERVICE

When the servicing or maintenance is completed and the machine or equipment is ready to return to normal operating condition, the following steps shall be taken.

1. Check the machine or equipment and the immediate area around the machine to ensure that nonessential items have been removed and that the machine or equipment components are operationally intact.
2. Check the work area to ensure that all personnel have been safely positioned or removed from the area.
3. Verify that the controls are in neutral.

4. Remove the lockout devices and re-energize the machine or equipment.

NOTE: The removal of some forms of blocking may require re-energization of the machine before safe removal.

5. Notify affected personnel that the servicing or maintenance is completed and the machine or equipment is ready for use.

PROCEDURE INVOLVING MORE THAN ONE PERSON

In the preceding steps, if more than one individual is required to lock out the Planer, **each shall place his own personal lock on the energy isolating devices.**

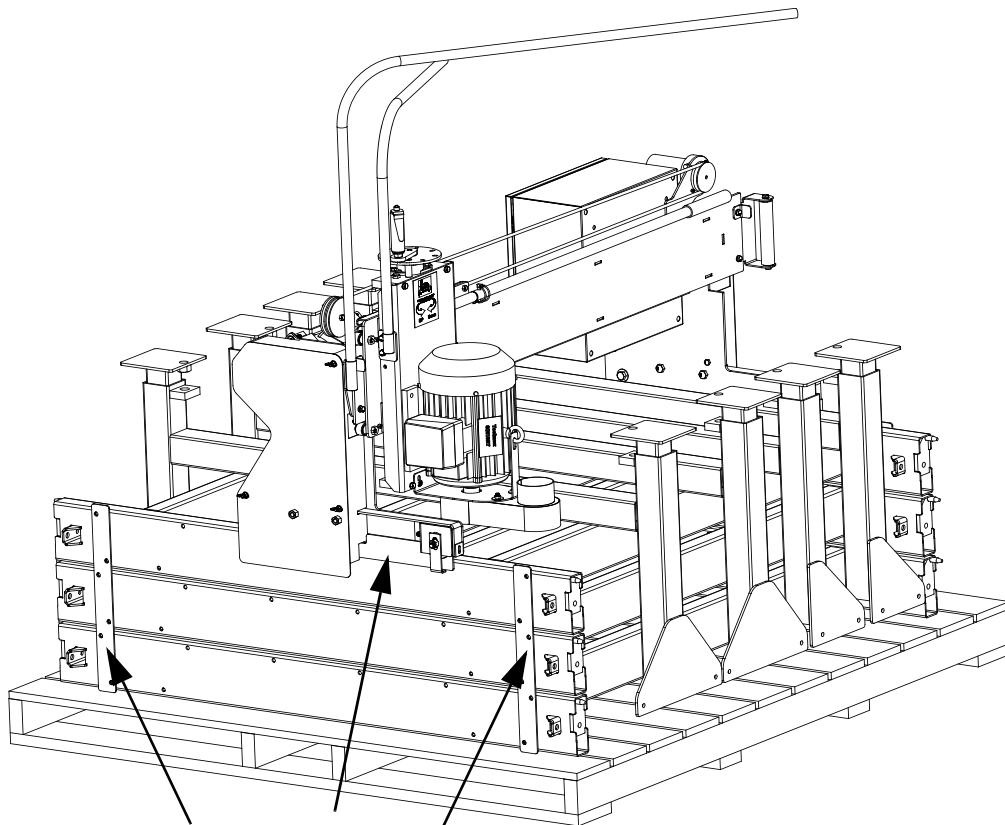
SECTION 3 PLANER ASSEMBLY



IMPORTANT! The Planer is shipped secured to the pallet. Before starting Planer assembly, remove the shipping brackets and straps securing the Planer to the pallet.

3.1 Uncrating the Planer

1. Disassemble any shipping straps from the bed sections before beginning.
2. Remove bed sections from shipping skid.



Remove retaining straps. Keep hardware securing the straps; it will be reused in the assembly.

FIG. 3-1

3. Open the parts box and spread the parts out in an orderly fashion.
4. Ensure all the parts are present.

3

Planer Assembly

Uncrating the Planer

REF	PART #	DESCRIPTION	QTY.
		PACKING LIST, MB200 SURFACE PLANER	
1		Control Box Key	1
2		Control Box Switch Key	1
3		13mm Wrench	1
4		19mm Wrench	1
5		4mm Allen Key	1
6		6mm Allen Key	1
7		Cutter Head Box with T20 T Handle Wrench	1
8	127139	SANDING HEAD	1
9	127140	Head, Sanding Pad 7"	1
10	127141	Balance, Sanding	1
11	127142	Stud, Sanding	1
12	127199	Bolt, M5x10 Flat Head	1
13	127200	Bolt, M5x18 Socket Head	2
14	P10688	Bearing, R6-2NSL	2
15		Sandpaper, 40, 80, 180, 3 of each	1
16		Chain Assembly	2
17	127012	CLAMP ASSEMBLY, MB200	4
18	F05010-132	Nut, M8-1.25 Nylock	4
19	127173	Plate, Clamp	4
20	F05021-19	Bolt, M8-1.25x75 HH	4
21	127175	Bolt, 5/16-18x5 Carriage	8
22	127176	Nut, 5/16-18 Knob	8
23	127174	Clamp, Strap	4
24	127093	Stand	1
25	127163	Tube, Vacuum Hose Arm	1
26	127167	Rail, Long	10
27	127169	Rail, Short	4
28	127168	Plate, End Stop	4
29	127155	Clip Chain Retainer	4
30	F05011-134	Washer, M10	4
31	F05004-97	Bolt, M10-1.5x35mm HH Zinc	4
32	F05022-15	Bolt, M10-1.5x70 HH (52 Bolts Total - 28 Bolts on Shipping Brackets = 24)	24
33	F05023-10	Bolt, M12-1.75x110 HH	8
34	F05004-270	Nut, M10-1.5 Hex Nylock (52 Nuts Total - 28 Nuts on Shipping Brackets = 24)	24
35	F05010-209	Nut, M12x1.75 Hex Nylock Zinc	8
36	127165	Plate, Cover Roller	2
37	127180	Plate, Head Keeper	4

3.2 Assemble the Bed Sections

NOTE: Disassemble any shipping straps from the bed sections before beginning.

1. Lay the bed sections end-to-end so the side rail bolt holes are at the top off each section.
2. Slide the sections together and secure with four M12-120mm hex head bolts and M12 nylon lock nuts.

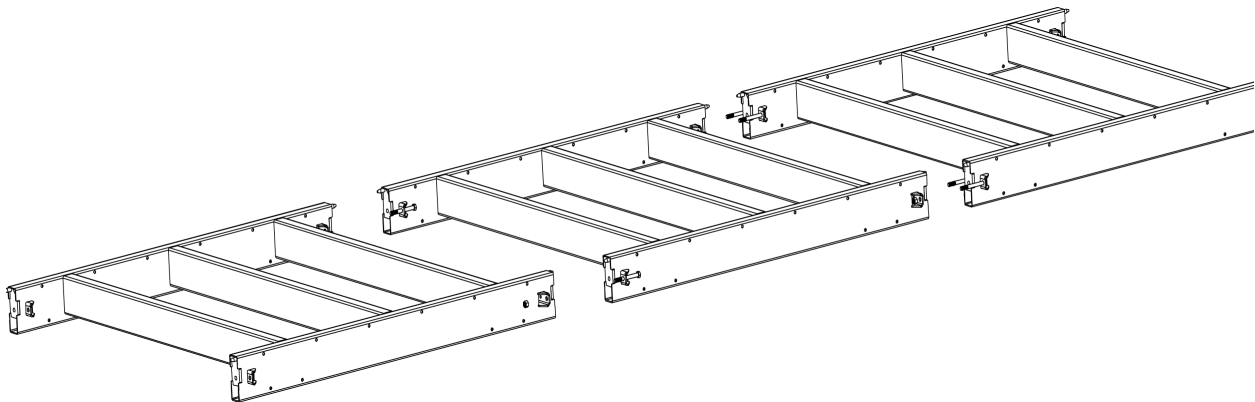
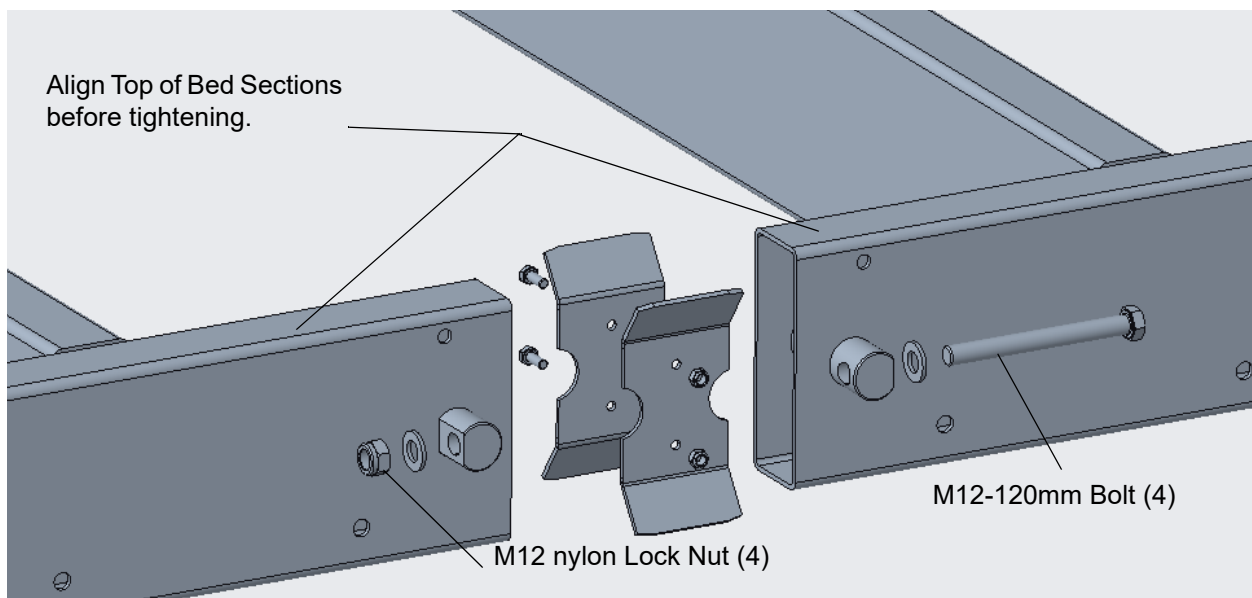


FIG. 3-2



NOTE: Make sure the top surfaces of the outer side of the bed sections are aligned. It may be necessary to pry one bed section up or down until the surfaces are aligned, then tighten the bolts.

Make sure the top surface of each section are flush, then tighten the fasteners completely.

3 Planer Assembly

Install the Side Rails

3.3 Install the Side Rails

1. Next install the side rails to the assembled bed sections.
2. Using the M8-70mm Hex Head Bolts and M8 Nylon Lock Washers to fasten the side rails to the bed section. There are two layers per side.
3. from one end of the bed section install the first layer of side rail strips in this order
Short Strip - Long Strip - Long Strip - Short Strip
The second Layer of side rails should be
Long Strip - Long Strip - Long Strip
4. Repeat this for both sides of the bed sections.

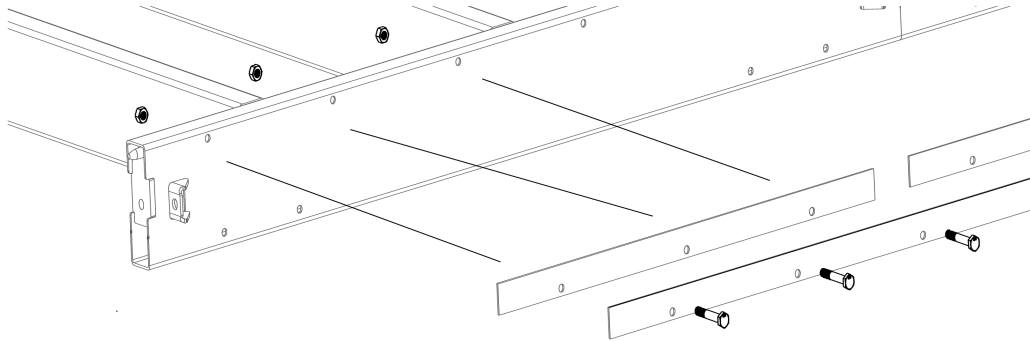


FIG. 3-4

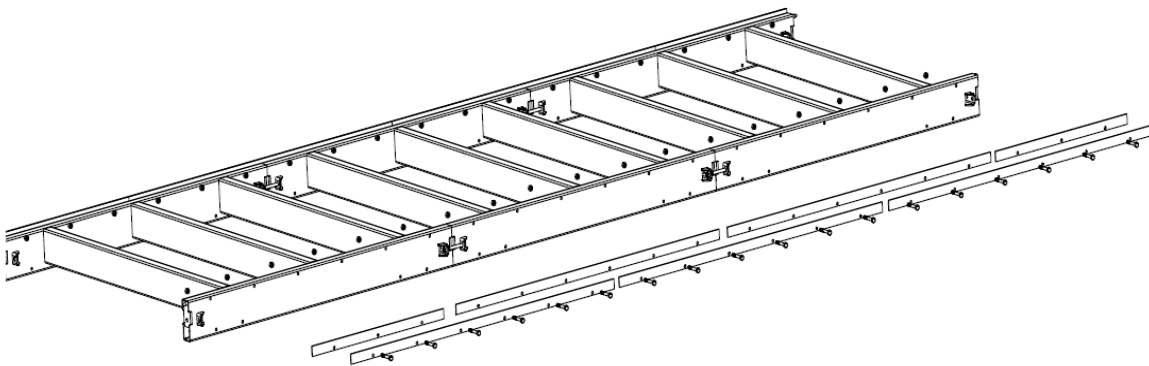


FIG. 3-5

3.4 Install the Leg Assembly

1. Attach the Leg Assemblies to the Bed Sections as shown in Figure 3-6 using the provided M10-70mm Hex Head Bolts and M10 Nylon Lock Washers.

Note: The Leg assemblies have a left and right assembly as well as the center leg assemblies. (Notice the Brackets). As shown Below.

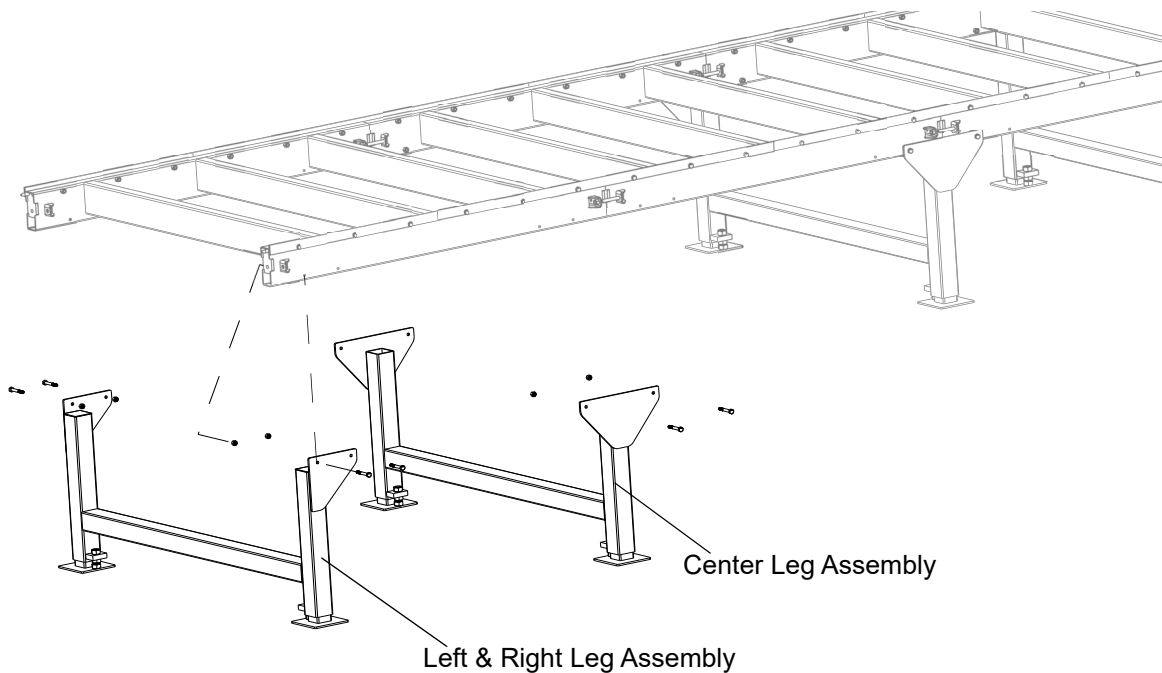


FIG. 3-6

3.5 Install The Head Stops

1. Once the Leg Assemblies are attached to the bed section, next install the Head Stops at each end of the bed section (4 Stops total) See Figure 3-7 for reference.
2. Make sure the Head Stop's alignment hole is positioned correctly then secure each stop with (1) M10-35mm Hex Head Bolt and M10 Washer as shown. Repeat this for all four End Stops.

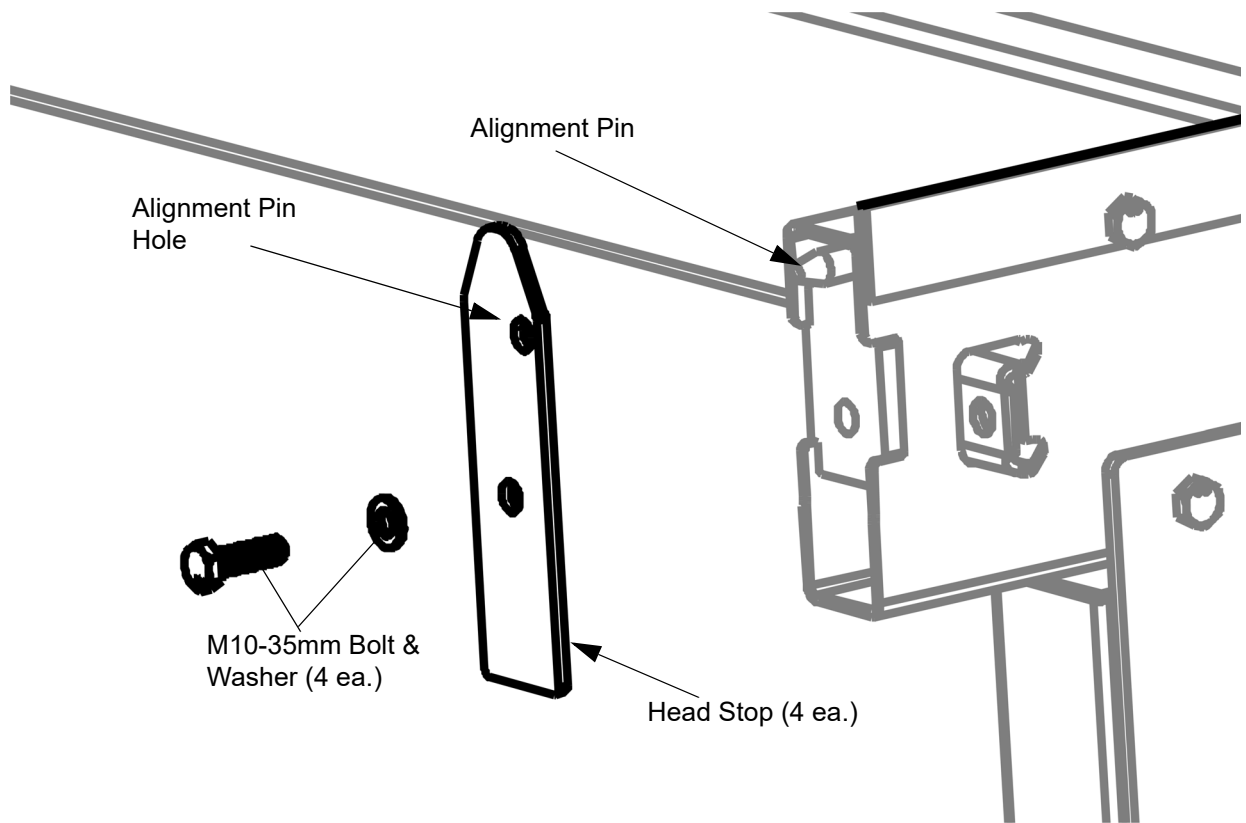


FIG. 3-7

3.6 Install The Clamps

1. The Planer includes (4) Clamp assemblies for securing material to the bed. These clamps ride along the cross rails of the bed section and are secured from underneath using the clamp bracket plate and (2) star knobs for each clamp. See FIGURE 3-8
2. Position the clamps to best secure the slab being finished.

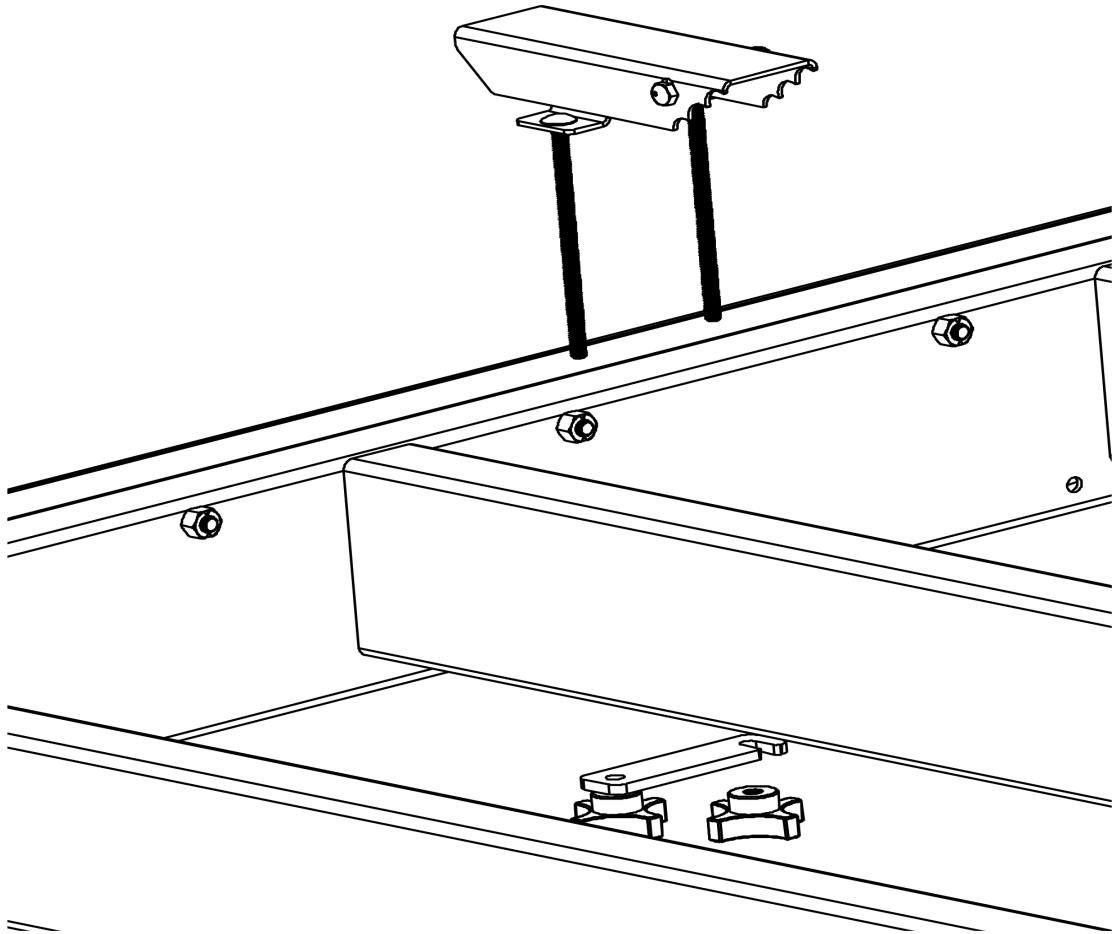


FIG. 3-8

3.7 Leg Adjustment

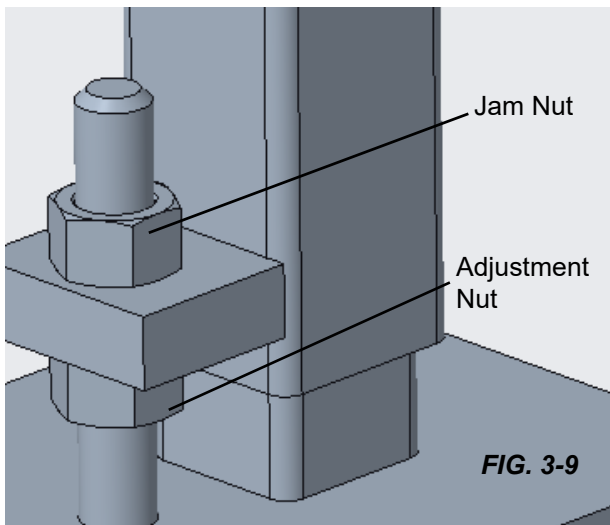


FIG. 3-9

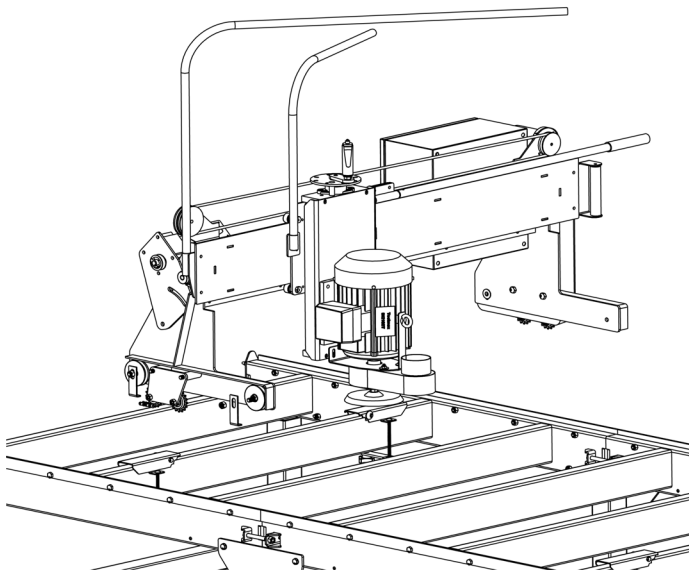
1. The bed section leveling will be discussed thoroughly in the Setup section of the manual. The legs are adjusted by loosening the upper jam nut and adjust leg height by tightening or loosening the lower adjustment nut. See FIGURE 3-9

3.8 Install the Gantry

WARNING! Use a fork lift, crane, or other lifting device to remove the gantry from the packing crate. Failure to follow this may result in serious injury or death.

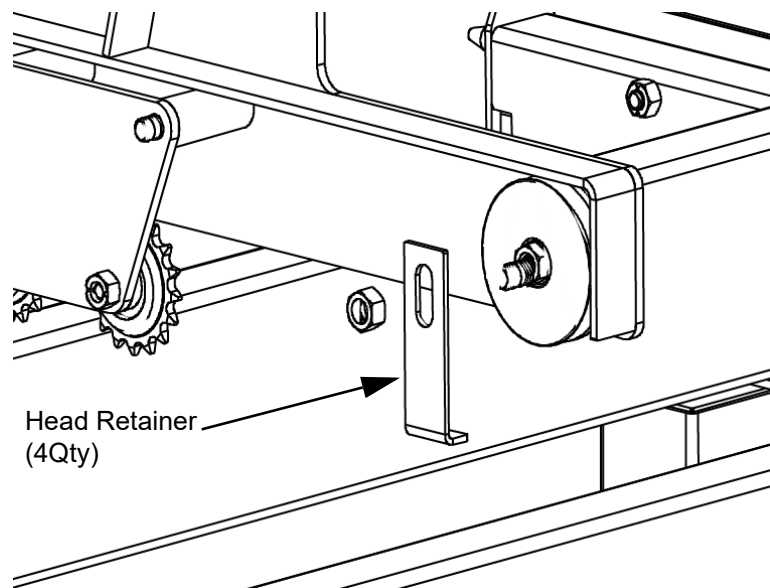
IMPORTANT! Do not attempt to set the gantry down on any surface other than the bed rails. Equipment damage may occur.

1. Place the Gantry onto the assembled bed section. Use care when mounting the gantry to avoid damage.



3.9 Install the Head Retainers

2. With the Gantry in place, secure it to the bed assembly by installing the Head Retainers (4) on each side of the table.
3. Secure the Head Retainers using (1) 1/2" nut. Repeat these steps for all (4) Head Retainers



3.10 Install the Feed Chain

1. Connect the Feed Chain to the Feed Chain Tensioner located at the end of the bed assembly.
2. Run the Feed Chain under and around the drive sprockets as shown in Figure 3-10.
3. Connect the other end of the feed chain to the Feed Chain Tensioner at the opposite end of the table assembly.
4. Repeat Steps 1-3 on the opposite side of Table and Gantry.

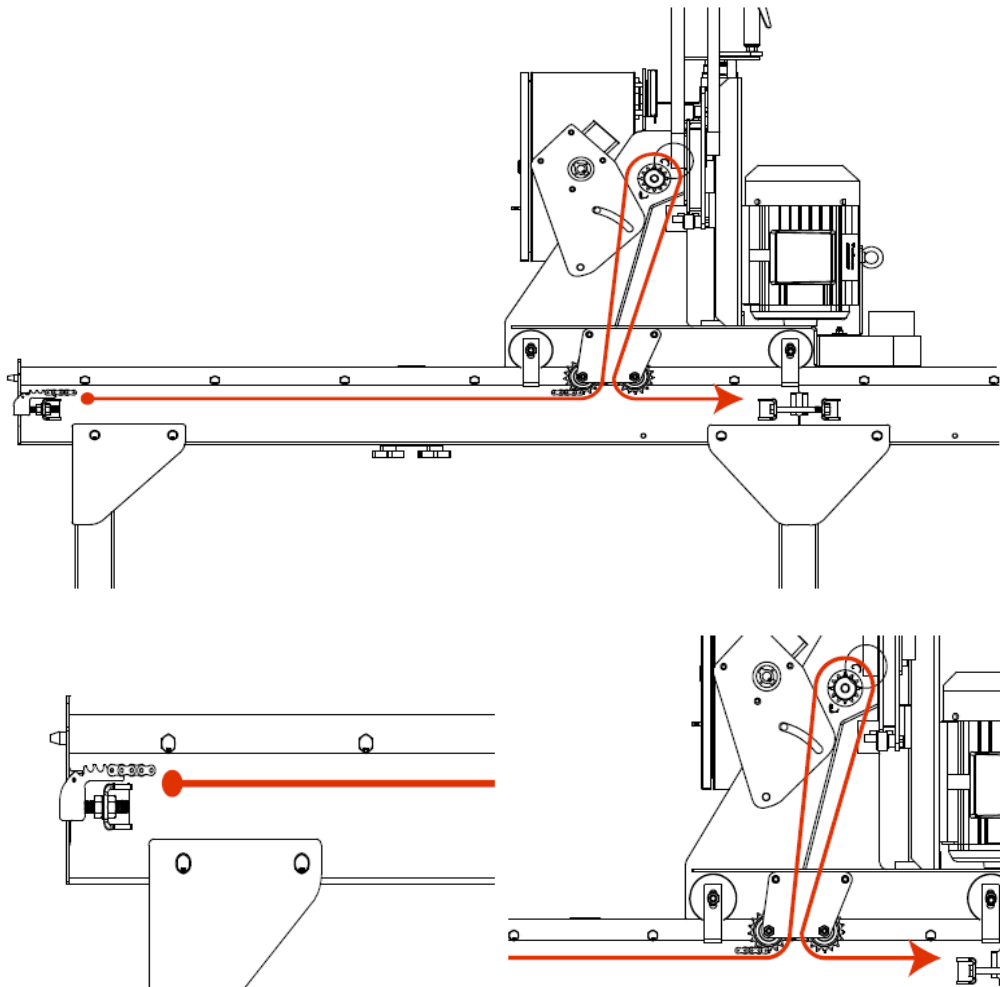


FIG3-10

SECTION 4 PLANER SETUP

4.1 Bed Frame Setup

The following setup procedure should be performed whenever the planer is moved or reassembled. If surfacing problems occur and misalignment is suspected, [See SECTION 8](#) for complete alignment instructions. [See SECTION 3](#) for planer assembly instructions.



DANGER! Do not use a gas engine indoors. Failure to follow this will result in serious injury or death.



IMPORTANT! Set up conditions include:

- Set up the planer on firm, level ground and level the planer.
- Use a sawdust collection system when operating under roof or indoors (electric only).

ADJUSTING THE BED

1. Adjust the frame legs so the planer appears level; use shims under the legs, if necessary.
2. Run a string from the front bed rail to the rear bed rail near the operator's side of the frame. See Figure 4-1.
3. Place **IDENTICAL** matching spacers between the string and the front and rear bed rails.
4. Measure the distance between the string and the other bed rails.
5. Adjust the frame legs until all bed rails measure the same distance from the string.

See Figure 4-1

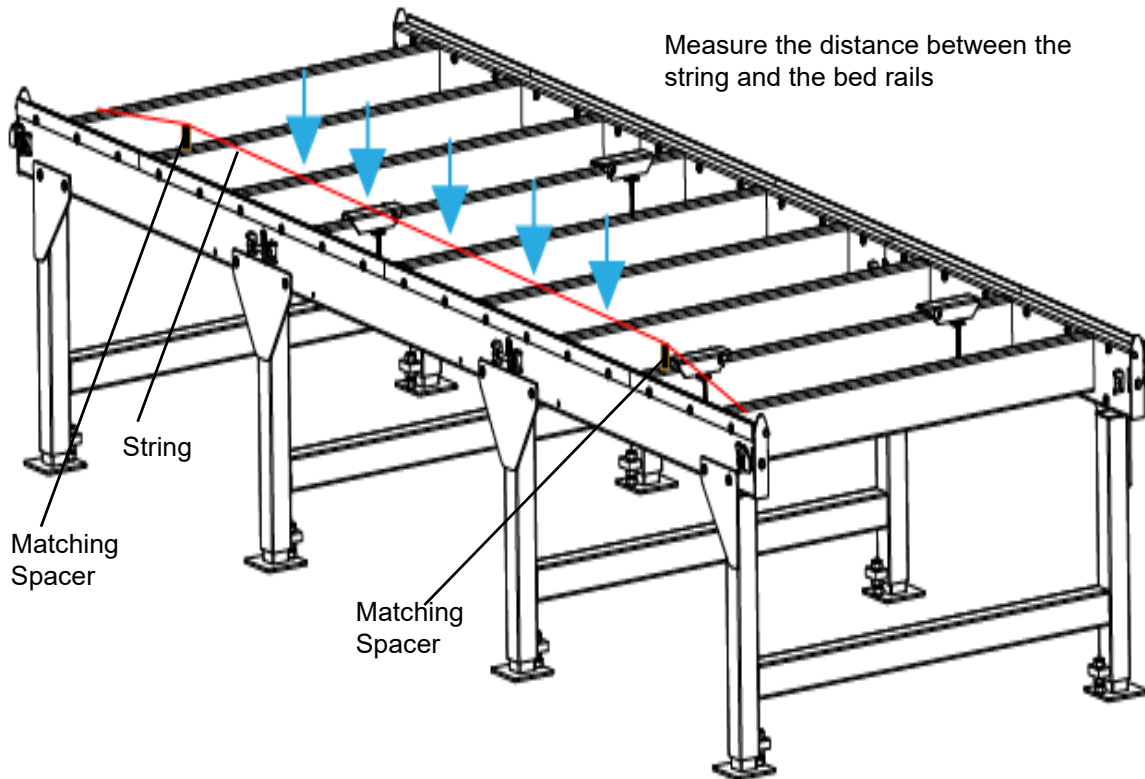
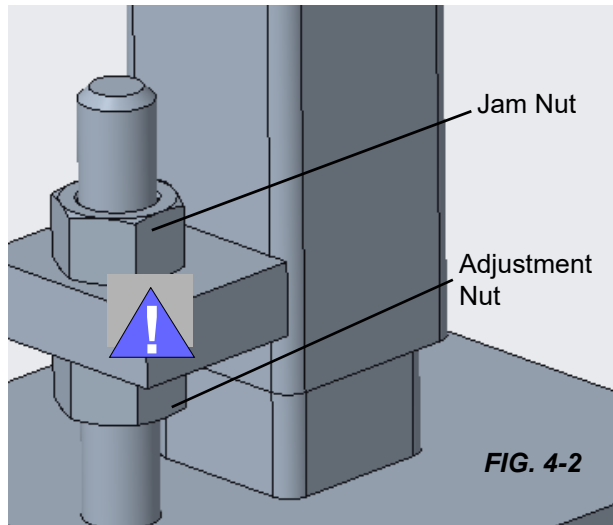


FIG. 4-1

6. Repeat the bed rail adjustment with the string at the other side of the planer frame.

LEG ADJUSTMENT

See Figure 4-2



7. The legs are adjusted by loosening the upper jam nut and adjust leg height by tightening or loosening the lower adjustment nut. See Figure 4-2.

4.2 Electrical Hookup

IMPORTANT! This information is provided so that you may have your site prepared for installation of your electric planer. In order to properly install your planer, you need to:

1. **Prepare a firm, level area where the planer can be operated.** There should be enough room around the planer for operators, sawdust removal, material loading and board removal.
2. **Have a qualified electrician install the power supply before receipt of your planer.** The power supply must meet the enclosed specifications concerning wire size, fused disconnect, and voltage. The electrical installation must also meet local codes.
3. **Be sure the power supply cables are properly secured.** Secure the power supply cables in the provided power cord boom system.
4. **Have a qualified electrician present when the planer is to be installed.** All relevant motor specifications and wiring information is provided. When scheduling an electrician for the day of installation, please confirm that they have enough of the proper size cable (wiring). Many electricians may not stock the cable, which could seriously delay installation and training.

4.3 Electric Wiring



DANGER! Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.



WARNING! Make sure that the machine you have purchased can be powered with the provided power source before making any connections. Do not connect the machine to the improper power source. Serious injury,

death or damage to the equipment will result.

See Table. 4-1 All electrical installation must meet local electrical codes. Install a fused disconnect switch within sight of the machine. The disconnect must be equipped with Class J fuses. Fuse size will be determined by the conductor wire size, but must be at least as large as the full-load amperage of the machine (See Below). Fuses supplied in the planer electrical control are sized for short-circuit protection only.

Model	Full Load Amperage
MB200EA3U	30A

TABLE. 4-1

Route the incoming power supply to the main electrical control cabinet. Punch a knockout in the box and route the cable through the box and secure the cable properly. Connect to cable wires to the power disconnect in the Lower-right corner of the cabinet. Connect the ground wire to a panel mount stud.

See Figure 4-3

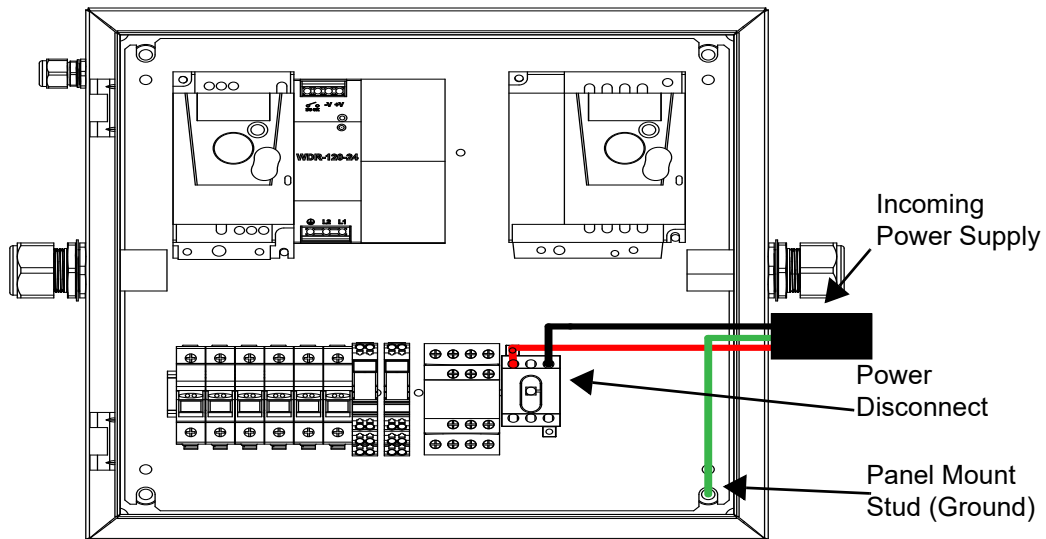


FIG. 4-3

See Table. 4-2 This table lists the specifications for the planer blade motor.

Electric Blade Motor Specifications	MB200EA3U
Horsepower	3
RPM	4300
Volts	240
Full-Load Amps	30

TABLE. 4-2

4

Planer Setup

Vacuum Hose Hookup

SF	1.25
NOM EFF	86.5
Frame	182E
Design	B
AMB	40° C
INS	F3
PH	3
ENCL	TEFC
Code	K

TABLE. 4-2

4.4 Vacuum Hose Hookup

1. Secure the Vacuum Hose to the Vacuum Hose Arm using appropriately sized hose clamps or zip ties. (Minimum 5 locations as shown in Figure 4-4).

See Figure 4-4

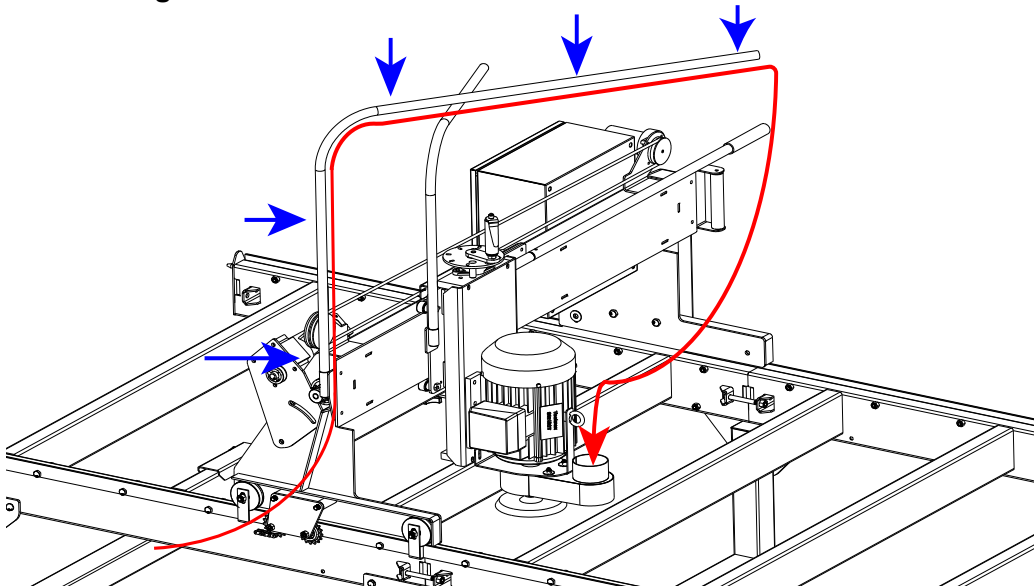


FIG. 4-4

4.5 Sanding Head

1. To install the Sanding Head, fit the Orbital Balance onto the retaining washer before threading the (2) M5x18 SH Bolts. Tighten the two bolts with the provided 4mm hex wrench. as shown in Figure 4-5.
2. Thread the Sanding Pad onto the Sanding Stud using the included 19mm wrench.



CAUTION: Ensure the Orbital Head is fully seated to prevent cross threading of the bolts.

See Figure 4-5

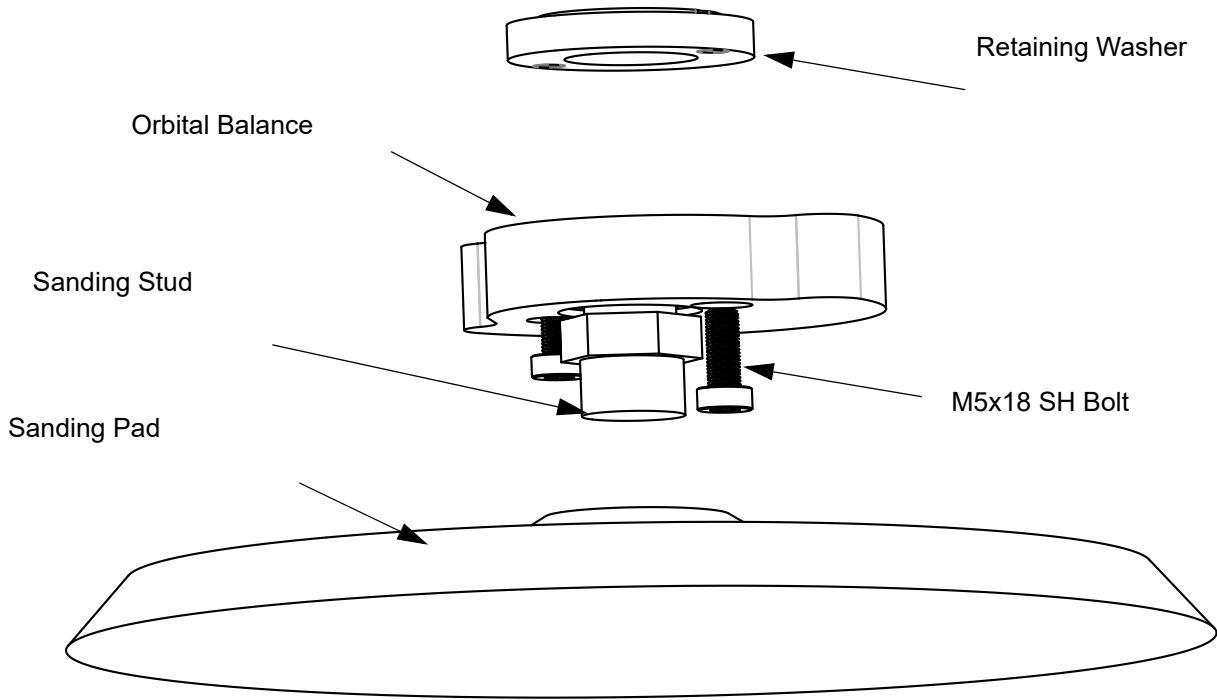
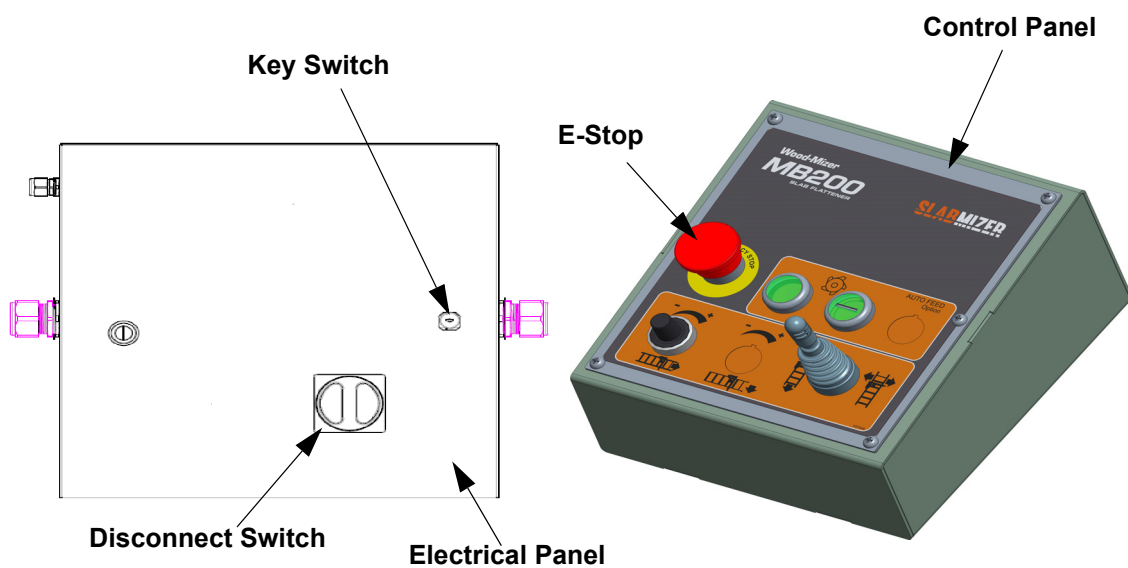


FIG. 4-5

SECTION 5 PLANER OPERATION

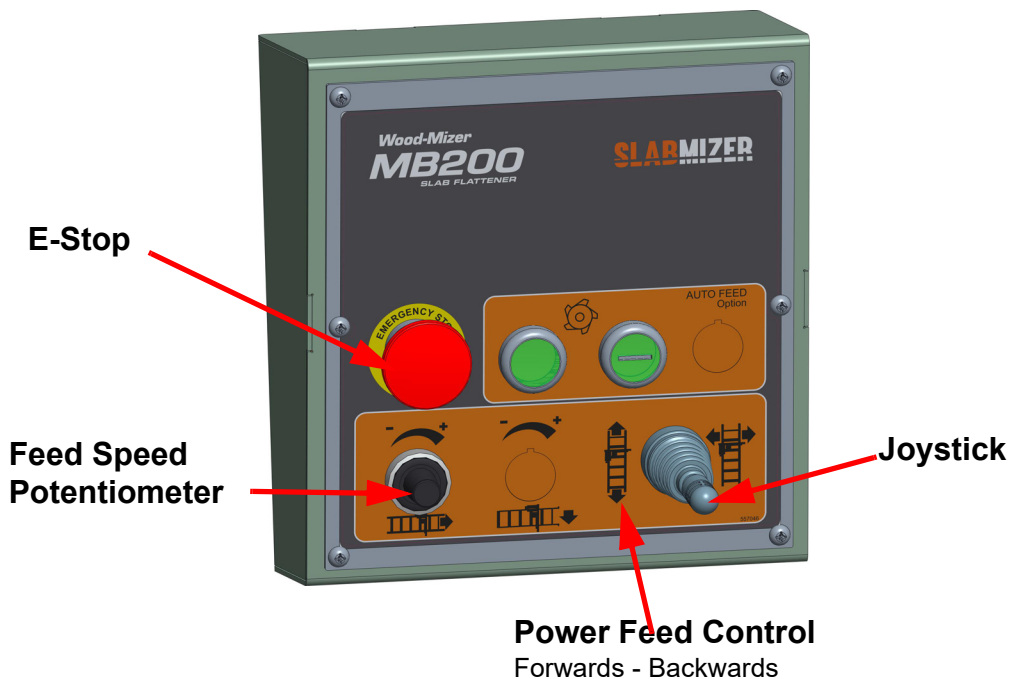
5.1 Turning on Planer

1. Make sure the disconnect switch, located on the unit's electrical panel is in the ON position.
2. Turn the key switch located on the unit's electrical panel to the ON position.
3. Disengage the E-Stop located on the unit's control panel with a clockwise twist. When disengaged the E-Stop will unlock and the knob will pop outwards.
4. The unit is now ready to begin operation.



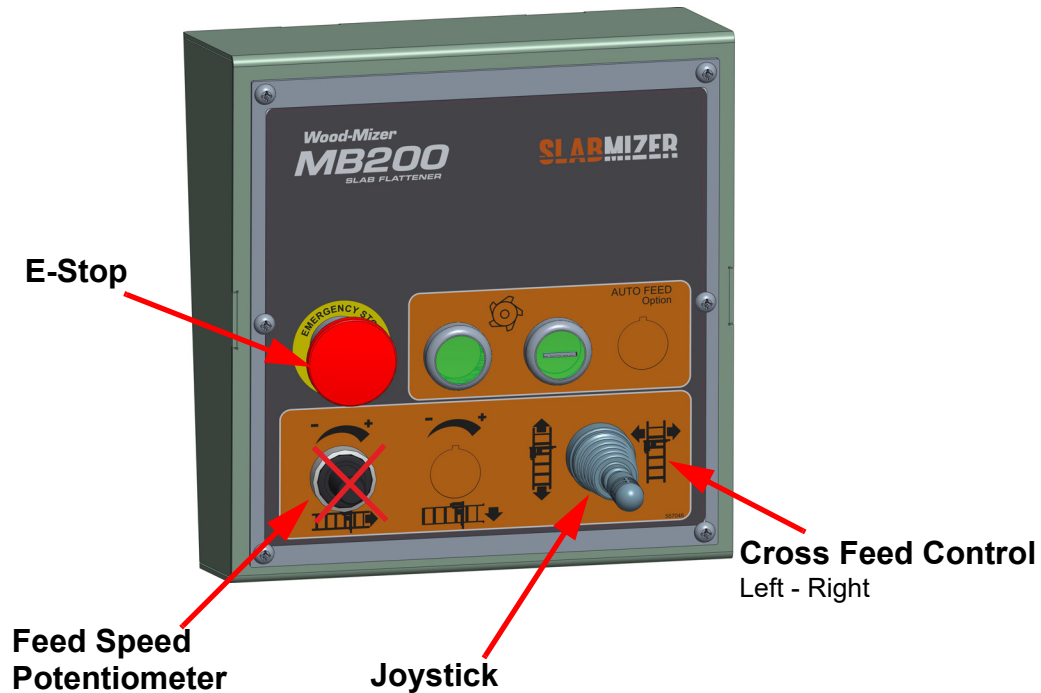
5.2 Power Feed

1. The power feed of the planer is controlled by the control panel.
2. Use the joystick (forwards - backwards) motion to control power feed movement. The power feed speed can be controlled by the feed speed potentiometer on the control panel



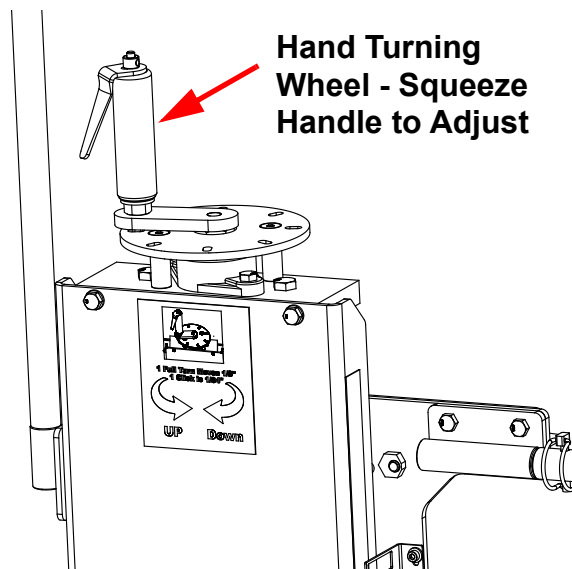
5.3 Cross Feed

1. The cross feed of the planer is controlled by the control panel.
2. Use the joystick (left - right) motion to control the cross feed movement. The cross feed speed **cannot** be controlled by the feed speed potentiometer on the control panel. It has a set feed rate.



5.4 Head Up & Down

1. The cutter head up & down motion is controlled manually by the hand turning wheel located on the top of the gantry. Turning the hand-wheel clockwise will lower the head, while counter-clockwise turn will raise the head.
2. The cutter head height can be adjusted by increments of 1/64 with the positive stops located on the turning wheel.
3. Squeeze the handle to unlock the turning wheel to make height adjustments.



5.5 Cutter Start and Stop

1. The cutter is activated with the cutter drive on & off buttons located on the control panel.



WARNING! Before activating the cutter, clear the working area of any tools, debris or other obstacles that could cause interference with the cutter.

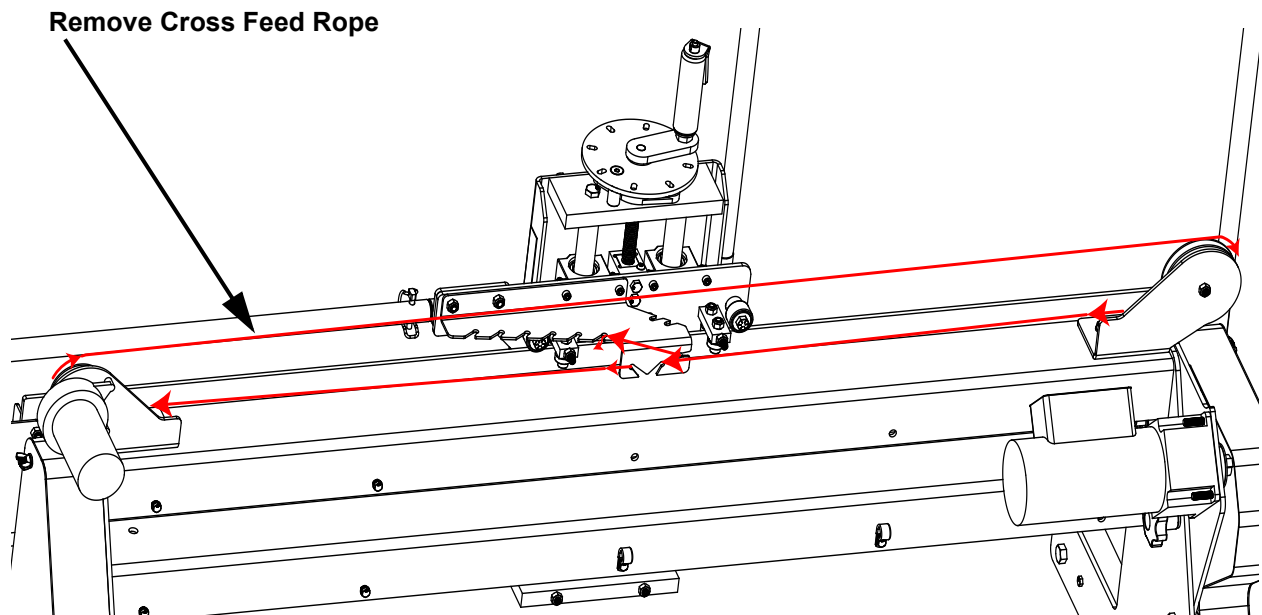
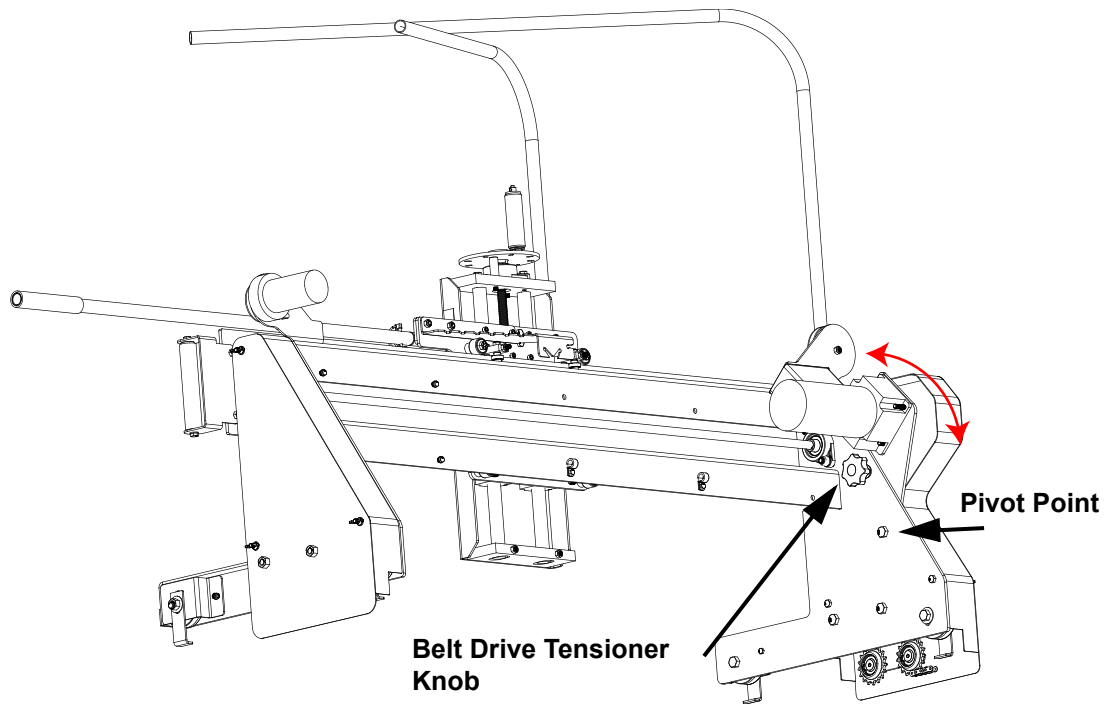


WARNING! Make sure the user and all personnel are clear of the cutter head before activating. Failure to do so can result in serious injury or death.



5.6 Manual Operation

1. The planer can be operated manually by the user in order to target specific planing needs. To convert the planer to manual operation follow the steps below.
2. Loosen the drive Belt by loosening the Drive Belt Tensioner Knob and pivoting the Drive Motor up to loosen the belt, once loose, tighten the tensioner knob to secure the drive motor. See Figure 7.
3. Remove the Cross Feed Drive Rope from the rope mount and remove rope from around the drive pulleys in order operate the cross feed manually.



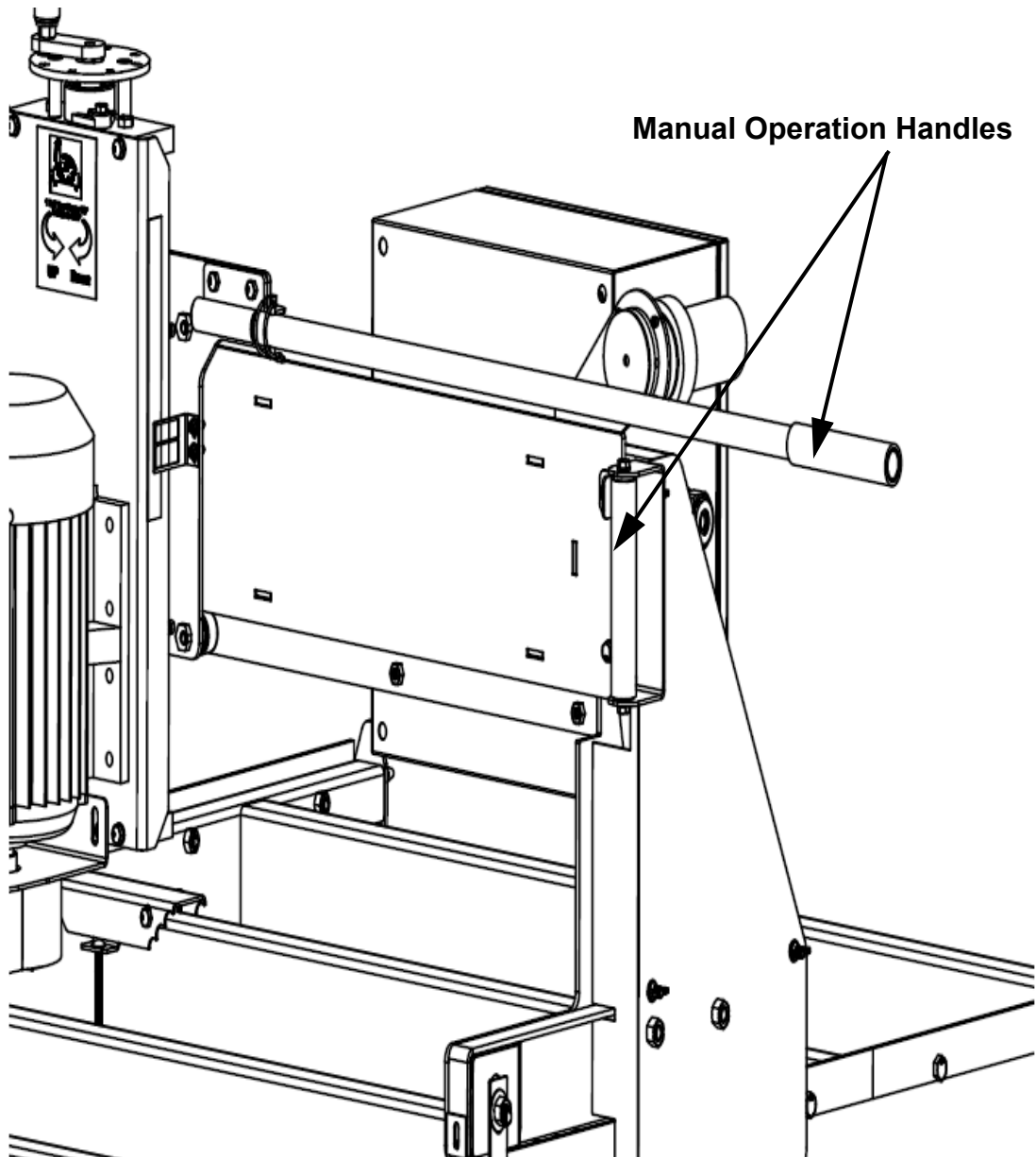
4. Use the handles located on the operator's side of the gantry to manually control the cross feed and the power feed of the planer.

5 Planer Operation

Manual Operation

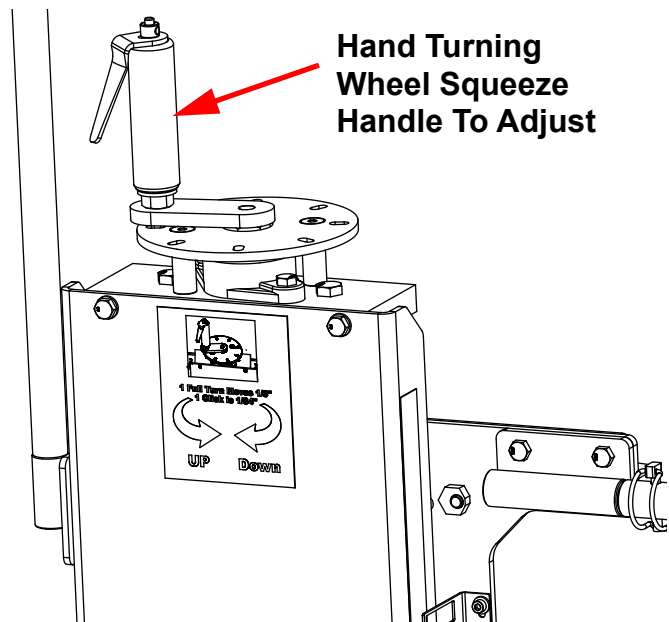


CAUTION When operating the planer manually, use consistent controlled feed rates to prevent damaging the material surface and/or the cutter head.



5.7 Sanding

1. Refer to section 4.4 for installing the sanding head.
2. Sanding operations can be performed manually or using the automatic drive of the control panel.
3. Sanding pressure can be adjusted by raising or lowering the head no more than 1/64" per pass (positive stops located on the hand wheel are set to 1/64 inch per pass). Refer to the figure below.



CAUTION! Do not let the sanding head leave the slab surface, otherwise it may cause damage to the sanding head or the sandpaper may detach.

SECTION 6 MB200 AUTO FEED OPERATION

6.1 MB200 Auto Feed Control Panel

See Figure 6-1.

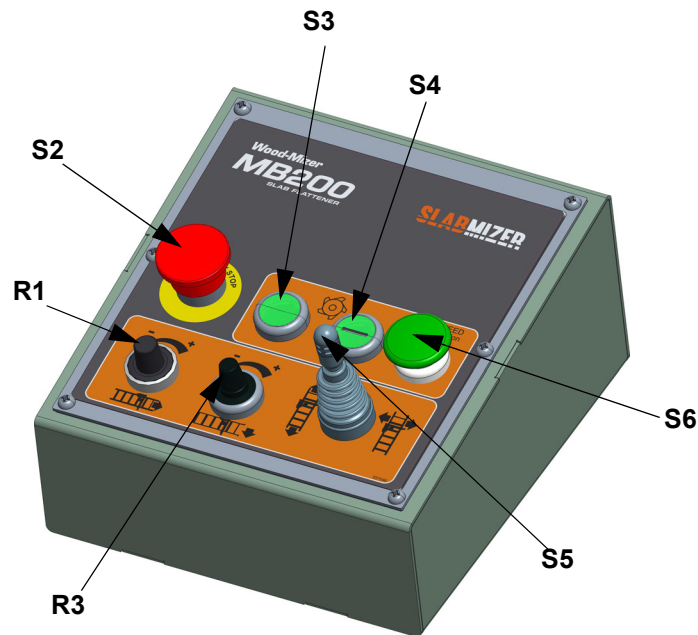


FIG. 6-1

- R1 - feed speed potentiometer,
- S2 - emergency stop (E-Stop) button,
- S3 - cutter drive off button,
- S4 - cutter drive on button,
- S5 - cutter movement joystick (forwards - backwards, left - right),
- S6 - Hold-To-Run Button,
- R3 - cutter head left movement potentiometer.

6.2 Light Column

The electric box for the MB200 Auto Feed is additionally equipped with the light column.

See Figure 6-2.

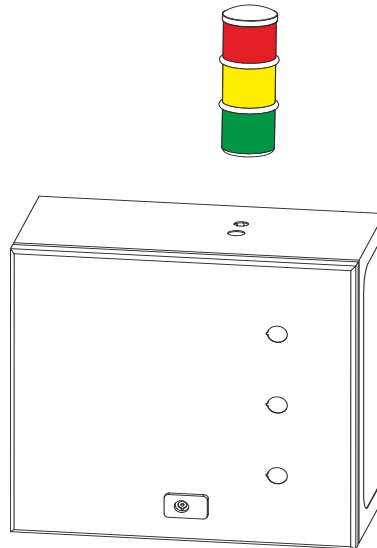


FIG. 6-2

The meaning of the light signals shown by the light column is as follows:

- Green light - safety circuits are active, power supply is on,
- Yellow light - if it is flashing every 1 second, then it means that the auto feed mode is on,
- Red light - if it is flashing every 1 second, then it means that the cutter head is on the left movement limiter. After that, the cutter head will go back to its initial position and the cutter will be stopped.

6.3 Auto Feed Mode Operation



IMPORTANT! The machine must be constantly supervised by the operator. Auto Feed Mode will only work, if the Hold-To-Run button is pressed and held by the operator. Releasing the button stops the machine.

1. The cutter starts working after pressing the S4 button. Then the S4 button is backlit, it indicates that the cutter is working. The light column is flashing the yellow light every 1 second. The S5 joystick is used for moving the cutter head forwards, backwards, left and right.
2. The auto feed mode is activated by pressing the S6 button. The cutter head starts moving 3 seconds after pressing the S6 button. If the Hold-To-Run button is released, the Auto Feed is switched off. To restart the auto feed mode press the S4 button again, then press and hold the S6 button.

6**MB200 auto feed operation***Auto Feed Mode Operation*

3. The cutter head speed is set with the R1 potentiometer. The R3 potentiometer sets the limit of the cutter head left movement. The maximum movement value is 175 mm in relation to the cutter axis.
4. The S3 button deactivates the auto feed mode. The S4 button backlight will go out when the cutter stops working. The yellow light on the light column and the S6 button will go out immediately after that.
5. The auto feed mode can be turned on while operating the machine manually. In order to do it, the working area of the cutter head needs to be defined with magnetic limiters.

See Figure 6-3.

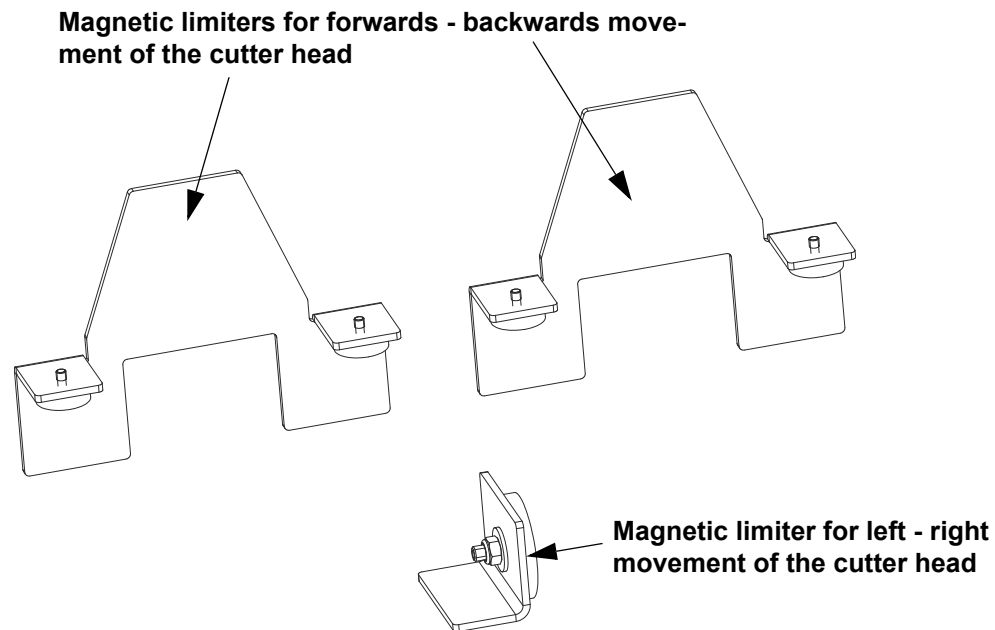
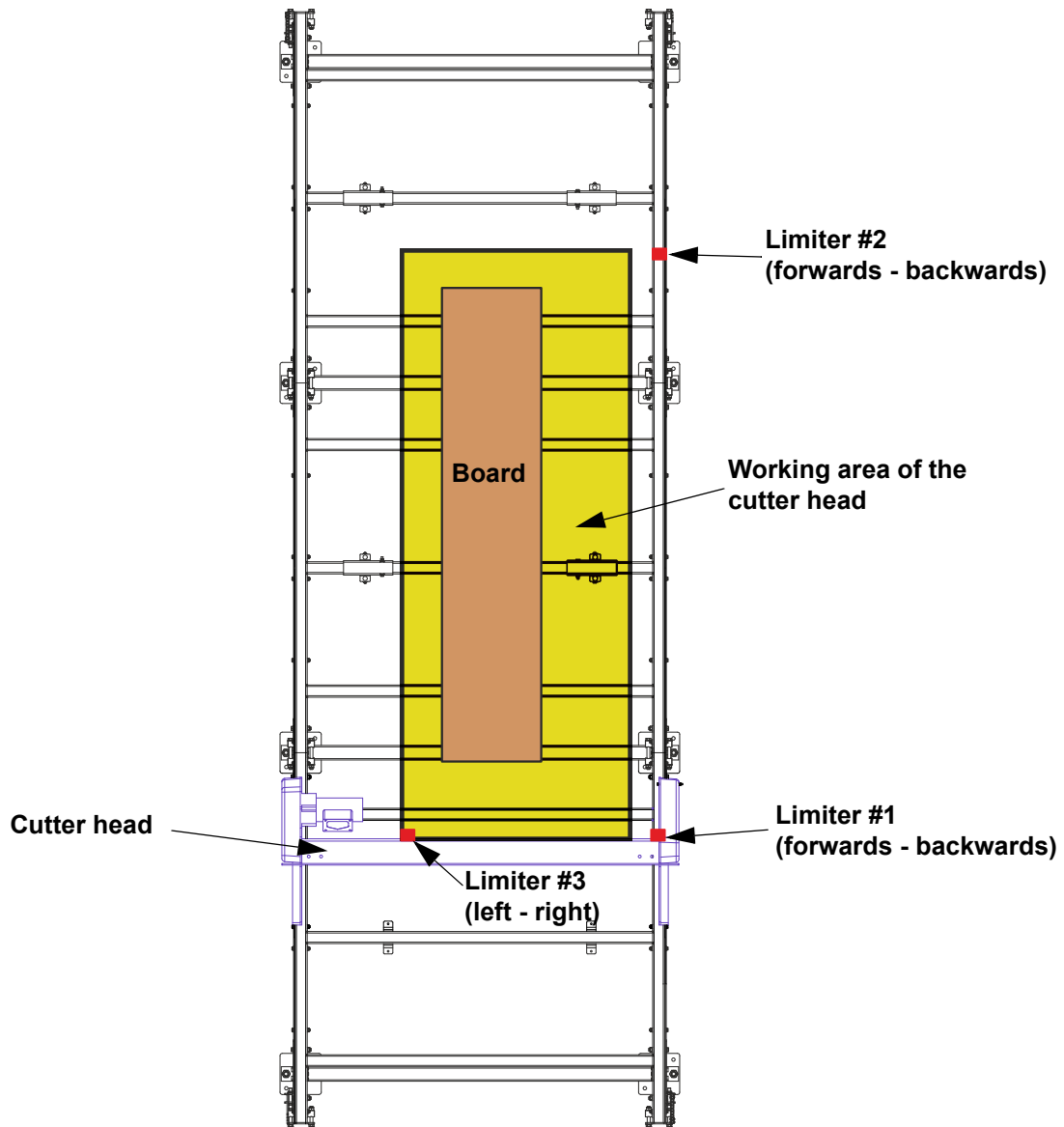


FIG. 6-3

Working area after setting the limiters

See Figure 6-4.



IMPORTANT! The working area defined by the limiters #1, #2, and #3 needs to be bigger than the area occupied by the board being processed (as shown in the picture above).

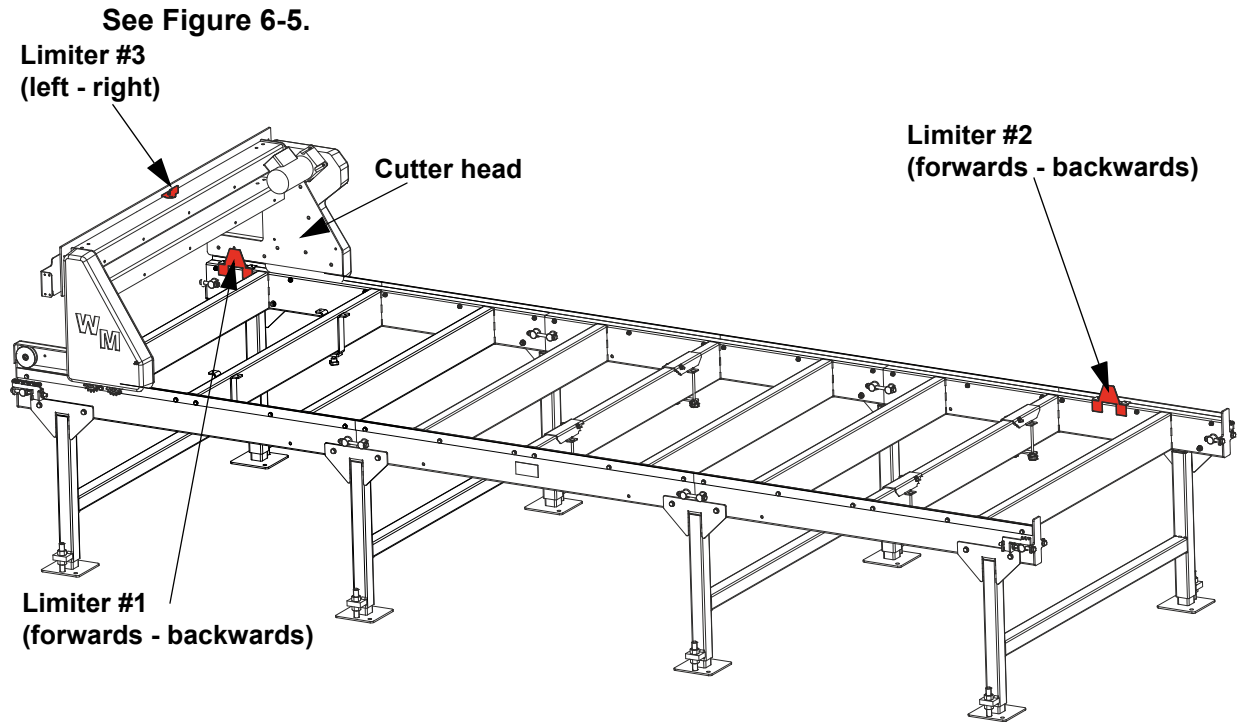


FIG. 6-5



IMPORTANT! The cutter head needs to be between the limiters #1 and #2 and on the right side of the limiter #3 to work properly in the auto feed mode.



IMPORTANT! If the cutter drive is off, it is not possible to move the cutter head forwards / backwards. It is possible to move the cutter head left / right only.



IMPORTANT! The first passage of the cutter head needs to be made in the manual feed mode. After that, when the working area of the cutter head is defined, it is possible to operate the planer automatically.

Two inductive sensors are mounted on the cutter head.

The lower sensor detects the working area longitudinal to the frame with the use of the magnetic limiters (#1 and #2).

The upper sensor detects the working area crosswise to the frame with the use of the magnetic limiter (#3).

Possible cases

1. If the cutter head reaches the limiter #3, it will be signaled by the flashing red light on the light column and by flashing of the S6 button. If such an error appears, it will not be possible to turn on the auto feed mode because the limiter #3 is the limit of the cutter left movement. The cutter head needs to be moved right using the joystick.
2. If the cutter head reaches the limiter #2 and, by moving to the left, it reaches the limiter #3, the red light on the light column will flash and the cutter head will return to the limiter #1, then the machine will be turned off.
3. If the cutter head reaches the limiter #1 and, by moving to the left, it reaches the limiter #3, the red light on the light column will flash. Then the cutter head will go forward to the limiter #2 and it will return straight to the limiter #1. After that, the machine will be turned off. In this mode, the cutter head returns to the limiter #1 because the limit of the cutter head left movement is determined by the limiter #3.



WARNING! Before activating the cutter head clear the working area of any tools, debris or other obstacles that could cause interference with cutter.



WARNING! Make sure the user and all personnel are clear of the cutter head before activating. Failure to do so can result in serious injury or death.



CAUTION When operating the planer manually, use consistent controlled feed rates to prevent damaging the material surface and/or the cutter head.

SECTION 7 MAINTENANCE



WARNING! Turn the key switch to the OFF (0) position and remove the key before performing service near moving parts such as cutters, pulleys, motors, belts, and chains. If the key is turned on and moving parts activated, serious injury or death may result.

Keep a log of machine maintenance by recording in the machine hours and the date you perform each procedure.

7.1 Rails, Chains and Rollers

1. Keep the Rails & Rollers free of Debris.
2. Light weight oil (ex. 3 in 1 oil) will assist with reducing pitch build up.
3. The unit should be lubricated as often as needed to maintain a good operating condition.

7.2 Cross Feed Rope



WARNING! Turn the key switch to the OFF (0) position and remove the key before performing service near moving parts such as cutters, pulleys, motors, belts, ropes, and chains. If the key is turned on and moving parts activated, serious injury or death may result.

1. Check the rollers for performance and wear often.
2. Adjust the Cross Feed Rope as needed to remove slack in order to avoid slipping on the pulleys which can result in inaccurate cross feed performance.
3. Lubricate the Cam Bearings with a light weight oil (Ex. 3-in-1 lubricating oil)

7.3 Head Up & Down Threads



WARNING! Turn the key switch to the OFF (0) position and remove the key before performing service near moving parts such as cutters, pulleys, motors, belts, ropes, and chains. If the key is turned on and moving parts activated, serious injury or death may result.

1. Up & Down Lead Screw located under the Hand Turning Wheel need to be lubricated regularly to ensure smooth operation and performance.
2. Lubricate the Lead Screw with a light weight oil (Ex. 3-in-1 lubricating oil) as needed.

See Figure 7-1.

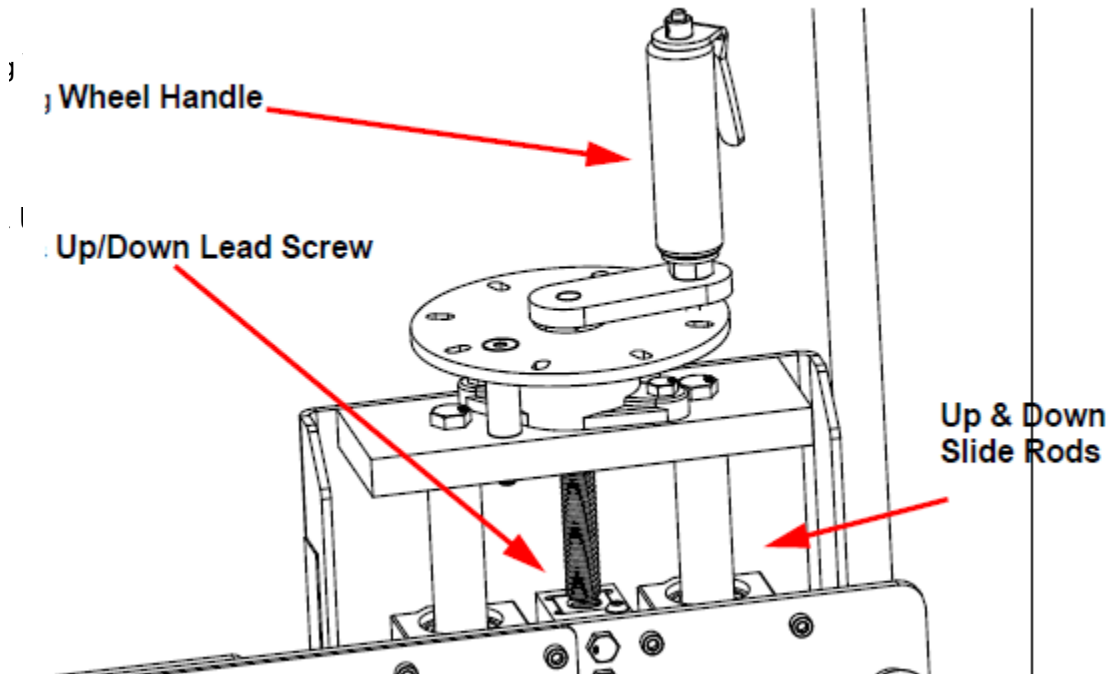


FIG. 7-1

3. Keep Up & Down Slide Rods free of debris, lubricate with a light weight oil.

7.4 Changing Cutter Knives

See Figure 7-2.

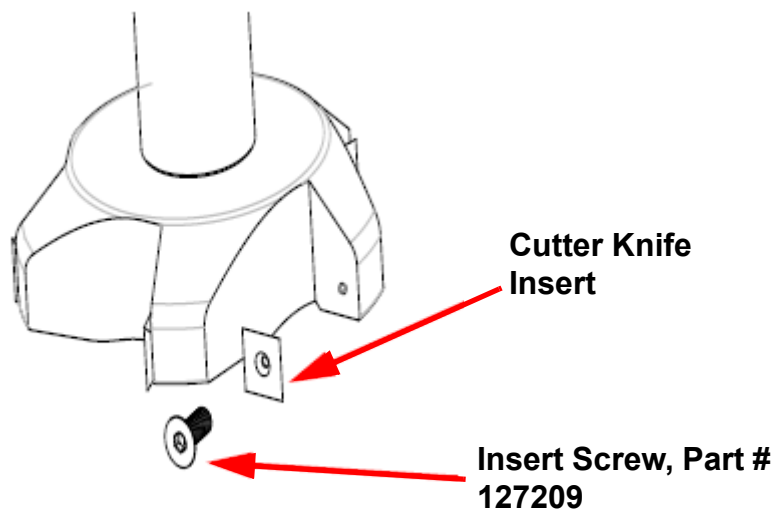


FIG. 7-2

7

Maintenance

Changing Cutter Knives

1. Replace Cutter inserts as needed by removing the Insert Screw (Part 127209) using the provided T20 T-Handle wrench as shown in Figure 6-2. Place in the new insert.
2. Cutter Knives can be rotated up to 4 times to a fresh sharp cutting edge before replacing.



CAUTION: Do not over torque the insert screws to prevent damage to the screws and cutter head.

SECTION 8 TROUBLESHOOTING GUIDE

8.1 Planing Problems

WARNING! Turn the key switch to the OFF (0) position and remove the key before performing service near moving parts such as cutters, pulleys, motors, belts, and chains. If the key is turned on and moving parts activated, serious injury or death may result.

PROBLEM	CAUSE	SOLUTION
Burning Wood	Dull or dirty knives	Turn cutter inserts to sharp edge or replace inserts
	Inappropriate feed rate	Adjust feed rate faster or slower.
Leaving Lines	Misaligned cutter head	Align the Cutter Head, Refer to Alignment in Section 8
	Step-over of cutter is to large	Decrease the step-over to reduce the presence of lines
Nothing Working	No Power, Blown Fuses	Check incoming Power, Check Fuses located in the Control Panel
Cutting Head Not Turning	Bad Motor Fuse	Check Motor Fuse located in the Control Panel.
		Have a licensed Electrician inspect the fuses and power supply
Cross Feed Not Working	Slack or loose Cross feed rope	Check Rope Tension, remove any slack.
	Dirt, Debris, Resin, Pitch Build up on rails and rollers	Make sure head moves smoothly by removing Debris, Pitch, Resin and Dirt Buildup on Rails, pulleys and rollers.
	unsuccessful resolve of issue	Contact Customer Support
Power Feed Not Working	blown or bad fuse	Check fuses in Control Panel
	loose or detached drive chain	Tighten the Drive Chain to ensure it stays on sprockets
	debris build up	Clear all debris or buildup on Rails and rollers.



Planer Alignment

Routine Alignment Procedure

SECTION 9 PLANER ALIGNMENT

Two alignment procedures are available to realign the Planer if necessary. The Routine Alignment instructions should be performed as necessary to solve planing problems not related to cutter performance. The Complete Alignment procedure should be performed approximately every 1500 hours of operation or as needed.

9.1 Routine Alignment Procedure

Misalignment of the cutter head can cause a variety of issues. It is important that the cutter head is parallel to the cutting surface in order to achieve optimal planing and sanding results.

Level the frame and adjust the saw head as described in Section 3.

Alignment Front & Rear

1. The Cutter Head is aligned front and rear by adjusting the set screws on the Up & Down Mounting Plate.

See Figure 9-1.

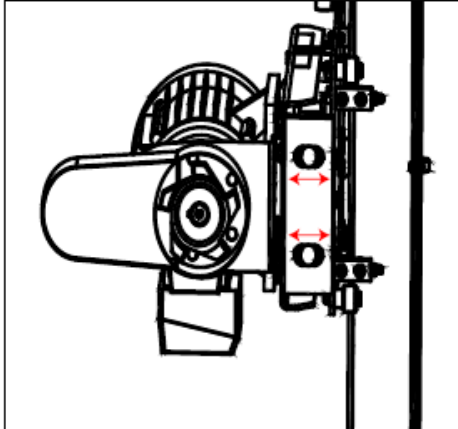


FIGURE 8-1

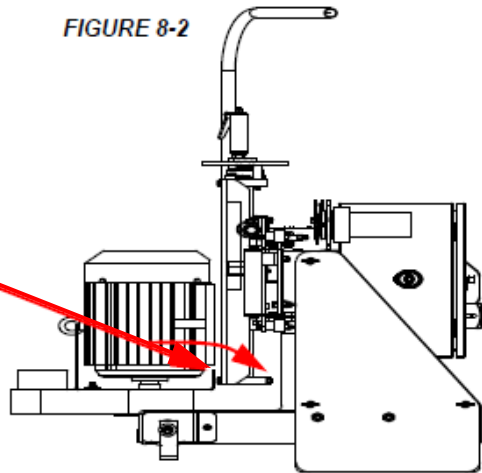
1a. Figure 8-1 Bottom Side View. The Motor Mounting plate can pivot forward and backwards to align the cutter head.

1b. Figure 8-2 Side View. The cutter head needs to be parallel to the material surface. To align the cutter head loosen the alignment bolt nut on bottom of the back-side of the motor mounting plate and tighten the alignment bolt to bring the front of the cutter downward. Loosen the rear bolt to bring the front of the cutter head upward.

Be sure to secure the opposite alignment bolt after head is aligned.

Cutter front to rear alignment bolt (1) on each side of the bottom of the motor mounting plate

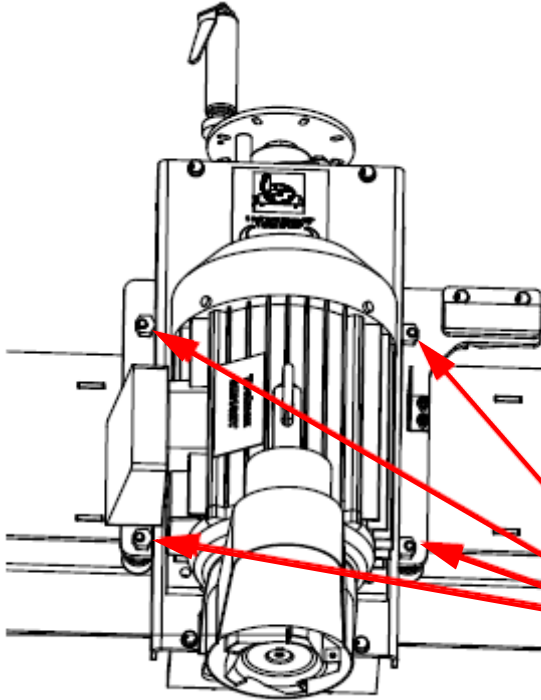
FIGURE 8-2



Alignment Side to Side

2. Adjusting the cutter head side to side by turning the lower cam nuts located on the up and down mounting plate. Do not over tighten the cams as this will cause restriction to the Cross Feed movement.

FIGURE 8-3

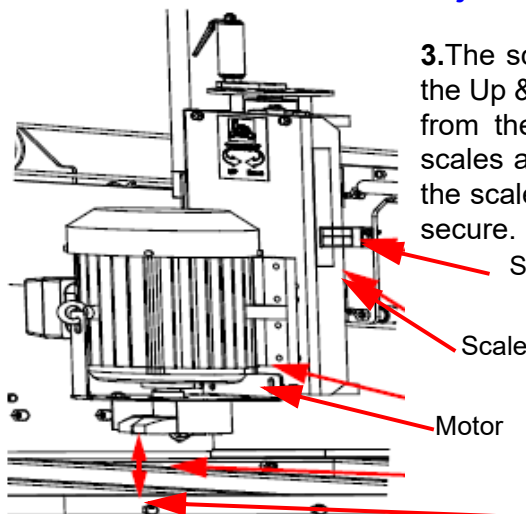


2a. Figure 8-3 ISO View - Side to side alignment cam bolts (4) are located on the Black Plate located behind the Motor Mounting Plate (2) at the top, (2) at the bottom. The Bolts have a cam action to adjust the left to right (Side to side) movement of the cutter head. Both cams on one side of the motor needs to be turned equal amounts in order to raise or lower that side of the cutter head.

Note: only (2) of the cam bolts need to be adjusted to move the cutter head. Be sure to not overly cam the bolt or this may restrict the smooth movement of the cutter along the gantry.

Cam Bolts (4) for adjusting side to side alignment of the cutter.

Adjusting the Scale



3. The scale measuring strip is located at the side of the Up & Down mounting plate. measure the distance from the surface to the cutter head to ensure the scales accuracy. If the scale requires adjusting reset the scale's sight line to the correct measurement and secure.

Scale Sight Line

Scale

Motor

Adjust the scale's sight line based on the distance from the bed's rail to the bottom of the cutter knife.

Dust Head

4. Raise or lower the up down so that cutting head is sitting on the surface of material. Adjust the dust head leaving a 1/8" gap between the surface of material and bottom of the Dust Head. Use the Dust head adjustment screws for moving dust head up and down as needed.

MB200MEH3SP-E_OPER_004
MB200MEH3SP-E_OPER

