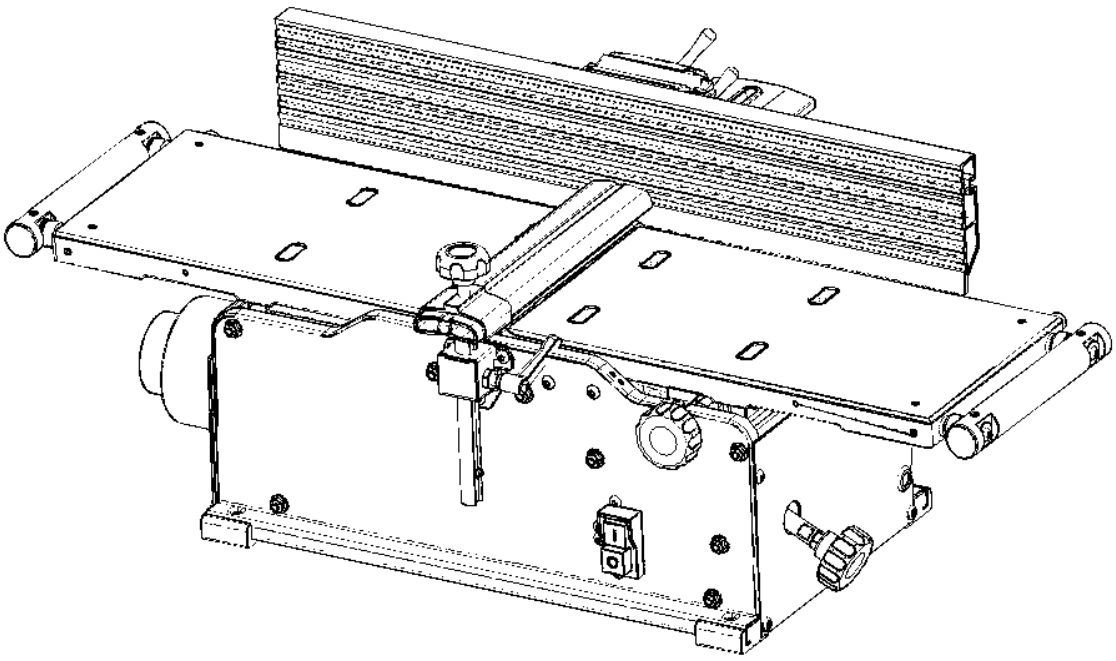
Jointer
Bench model
A200

Original Operating Instructions



Original Operating Instructions Version 2024_V01_EN

EX-A200

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1 General information

1.1 Information about this manual

This manual enables safe and efficient use of the machine. It contains instructions on safety, assembly, operation and maintenance, and spare parts lists. The manual must be kept in the immediate vicinity of the machine and passed on if the machine is sold.

NOTICE

Failure to read and observe these operating instructions may result in serious injury. Careful use and handling can significantly reduce the risk of injury. Observing the safety information and instructions in these operating instructions is a basic requirement for safe working.

1.2 Explanation of symbols

1.2.1 Safety notices

Safety notices in this manual are marked with colours and symbols. They are introduced with signal words that indicate the level of hazard.

DANGER

Indicates a high risk and an immediate danger to people!

Failure to observe this notice may result in serious, irreversible injuries or even death.

WARNING

Indicates a medium risk and a recognizable danger to people!

Failure to observe this notice may result in serious, irreversible injuries or even death.

CAUTION

Indicates a low risk and a recognizable danger to people!

Failure to observe this notice may result in minor, reversible injuries.

NOTICE

Indicates a possible material damage or an important information.

1.2.2 Mandatory signs

The following mandatory signs in the operating instructions and on the machine indicate safety aspects that must be observed:

Sign	Meaning	Sign	Meaning	Sign	Meaning
	Wear eye protection		Wear ear protection		Wear respiratory protection
	Wear a face shield		Wear foot protection		Refer to instruction manual
	Disconnect mains plug from electrical outlet		Wear protective clothing		

1.2.3 Prohibition signs

The following prohibition signs on the machine indicate activities that are prohibited:

Sign	Meaning	Sign	Meaning
	No reaching in		Do not wear gloves

1.2.4 Warning signs

The following warning signs in the operating instructions indicate specific hazards:

Sign	Meaning	Sign	Meaning
	Electricity hazards		Sharp elements
	Risk of fire		General warning

1.2.5 Other signs

Sign	Meaning	Sign	Meaning
	Environmentally hazardous substances		Do not dispose of in household waste

1.2.6 Warning labels on the machine

WARNING

Risk of injury if warning labels are ignored!

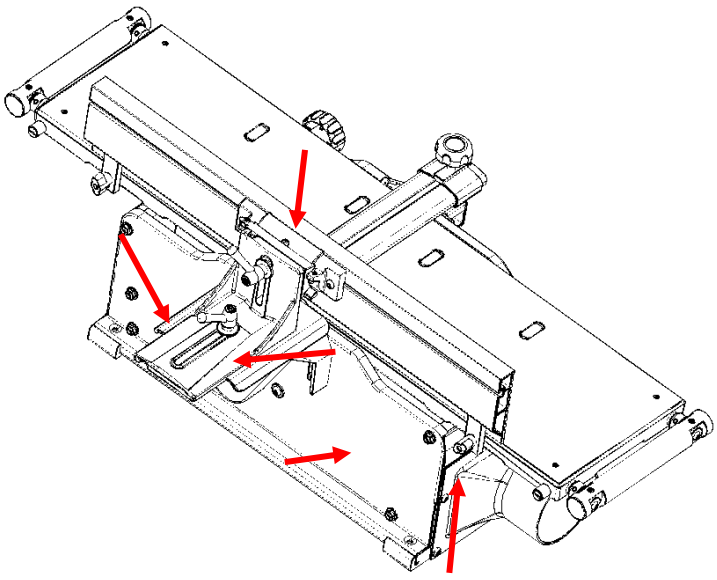
Warning labels on the machine are for safety reasons. Failure to observe them can lead to injuries.

- Observe warning labels on the machine.
- Keep warning labels legible.
- If warning labels are damaged or illegible, contact the dealer. He can arrange for replacement.

The following warning labels can be found on the machine:

Sign	Meaning
	Warning against reaching into the cutterhead.
	Warning against reaching in.
	Warning against reaching into the dust port.
	General instructions for the safe operation of the machine.

The warning labels are located in the following places on the machine:



1.3 Limitation of liability

All information and instructions in this manual have been prepared in accordance with applicable standards and regulations.

In the following cases, the manufacturer or importer is not liable for damages:

- Failure to observe the instructions
- Other use than the intended use
- Unauthorized modifications or technical changes
- Use of unauthorized spare parts

1.4 Warranty

This product is subject to the statutory warranty according to Austrian law from the time the product is handed over.

There is no basic claim to replacement or rescission.

In the event of a complaint, the responsible dealer must be contacted in order to agree on how to proceed.

1.5 Terms of guarantee

Neureiter GmbH grants a five-year manufacturer's guarantee on this product from the date of purchase.

If defects in material or workmanship occur during the intended use of the machine, the dealer needs to be contacted. After submission of a copy of the invoice, the defect in question will be verified in coordination with the service department and, as required, it will be repaired or the product will be replaced. The organisation of a possible transport (after consultation with the Neureiter service department) lies within the responsibility of the customer. The packaging must be safe for transport.

If it is determined that the complaint lies outside the granted terms of guarantee (e.g. in the case of defects arising from normal wear, improper use, power overload, overvoltage, unauthorized modifications of the machine, use of force, failure to observe the safety precautions or own attempts of repair), the customer has to pay the full costs for transport and repair.

Only the terms of guarantee cited here are valid, any side agreements are not recognized unless they are presented in written form and signed (documented) by the manufacturer/importer. No claim whatsoever arises from verbal agreements that have not been documented.

The present terms of guarantee are valid in German-speaking countries; elsewhere different terms of guarantee may apply. In this case, the local dealer can provide information.

The above guarantee in no way restricts statutory warranty claims.

2 Safety

2.1 Intended use

The EXMAC jointer A200 is used for face jointing wood that is at least 250 mm long, 19 mm wide and 12.7 mm thick and for edge jointing wood that is at least 250 mm long, 19 mm wide and 6.35 mm thick.

Material that can be processed with the jointer:

- solid wood (all types)

The machine is designed exclusively for its intended use. The intended use also includes the observation of all instructions given in this manual. Any use other than the intended use is not permitted. The machine is only suitable for private use, not for industrial use. The machine is designed for indoor use. The machine must be operated with a suitable dust collector.

The jointer is designed for a service life of 10 years.

The minimum age for using the machine is 16 years.

2.2 Basic health and safety instructions

2.2.1 Workplace safety

WARNING

Risk of injury due to inadequate safety conditions at the workplace!

Messy, unlit or poorly ventilated work areas and slippery floors can lead to accidents.

- Keep the work area clean and well lit.
- Ensure adequate ventilation.
- Keep the immediate work area and floor free from dirt and leftover pieces.
- Ensure there is a sufficiently large work space around the machine.

WARNING

Risk of fire due to flying sparks!

Flying sparks can ignite dust, vapours or chips.

- Keep the work area and floor clean.
- Avoid explosive environments where flammable liquids, gases or dusts are present.

2.2.2 Electrical safety

WARNING

Danger to life due to electric shock!

In case of unsuitable plugs, physical contact with earthed surfaces, water entering the machine, damaged or entangled cables and lack of earthing, there is a risk of electric shock.

- Use suitable plugs and sockets.
- Do not modify plugs.
- Do not use adapter plugs.
- Avoid physical contact with earthed surfaces (pipes, heaters, etc.).
- Protect the machine from moisture, vapours, wetness and rain.
- Only touch the machine and its plug with dry hands.
- Avoid misusing the power cord (do not pull on the power cord to remove the plug, for example).
- Keep the power cord away from heat, oil, sharp edges and moving parts.
- Avoid tangling the power cord.
- Use a suitable residual-current circuit breaker.
- Only connect a type F plug to an earthed socket.

2.2.3 Personal safety

WARNING

Risk of injury due to missing experience and carelessness!

Missing experience, carelessness and distraction can lead to serious injuries.

- Before using the machine for the first time, study the subject and ask qualified persons for training.
- Be careful and attentive when using the machine.
- Do not use the machine if you are tired or under the influence of drugs, alcohol or medication.
- Keep children and other people away while using the machine.

WARNING

Risk of injury due to unintentional start-up and use by third parties!

There is a risk of injury if the machine is started unintentionally or if it is started by inexperienced persons or children.

- Protect the machine from unintentional start-up and operation by third parties (especially children).
- Only leave the machine if it is switched off and at a standstill.
- Disconnect the machine from the power supply when not in use.
- Before connecting the machine to the power supply and before transporting the machine, make sure that the machine is switched off.
- Only allow the machine to be used by persons who are familiar with it and who have read this manual.

WARNING

Risk of injury due to missing personal protective equipment, unsuitable clothing and abnormal posture!

Injuries can occur due to missing protective equipment and incorrect posture. Loose clothes, jewellery or long hair can be caught and drawn into moving parts of the machine, which can lead to injuries.

- Observe the specifications for personal protective equipment in these operating instructions and wear personal protective equipment.
- Wear safety glasses or a face shield.
- Wear suitable clothing.
- Do not wear loose clothing and jewellery.
- Wear a headgear or hairnet.
- Avoid wearing gloves.
- Maintain a good posture, ensure secure footing and maintain balance at all times.

WARNING

Health risk due to dusts!

During woodworking, harmful dusts can be produced causing serious respiratory diseases.

- Only work in well-ventilated rooms.
- Wear respiratory protection.
- Avoid contact with dust.
- Use suitable dust collectors and air filtering systems.
- Clean exposed body parts with soap and water.

WARNING

Risk of injury due to tipping over!

If the machine is climbed onto or is unstable, there is a risk that it will tip over and cause injuries. Objects placed on the machine could fall and lead to injuries.

- Do not climb onto the machine.
- Make sure the machine is stable.
- Screw the machine to the installation surface.
- Avoid storing objects on or around the machine.

WARNING

Risk of injury when ignoring safety rules!

Ignoring the safety rules and careless behaviour can lead to serious injuries within a fraction of a second.

- Always follow the safety rules, even if you have a lot of experience with the machine.

WARNING

Risk of injury due to adjusting tools, spanners or loose objects that have not been removed!

Adjusting tools or spanners in a rotating part of the machine can cause injuries. Loose objects on the machine which start to move when the machine is switched on can cause injuries.

- Before switching on the machine, remove loose objects, adjusting tools and spanners from the machine.

2.2.4 Use and care of the machine

WARNING

Risk of injury due to unintended use and overload!

There is a risk of injury if the machine is used for other purposes than those intended or if the machine is overloaded.

- Only use the machine for its intended use and within the specified performance range.

WARNING

Risk of injury from using the machine despite defective components!

Damaged machines or components pose a risk of accidents.

- Before using the machine, ensure that it is intact and functional.
- Before using the machine, check whether any parts are broken or damaged.
- Only use the machine with intact components and switches.
- Check cables regularly for damage.
- Have damaged parts repaired immediately.
- If problems arise, switch off the machine immediately and contact the dealer if necessary.

WARNING

Risk of injury due to improper care and maintenance of machine and knives!

Improperly maintained machines and knives pose a risk of accidents. Slippery handles can lead to a loss of control.

- Follow the maintenance instructions in this manual.
- Maintain the machine with care.
- Only use knives that are suitable for the machine.
- Keep knives sharp and clean.
- Keep handles and gripping surfaces dry, clean and free from oil and grease.

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally when performing adjustment, cleaning or maintenance work or when removing jams.

- Before carrying out the above-mentioned activities, switch off the machine and disconnect it from the power supply.

2.2.5 Service

WARNING

Risk of injury due to improper repair!

Improper repair can impair the safety of the machine and pose a risk of injury.

- Have the machine repaired only by qualified personnel and only with original spare parts.

2.3 Personal protective equipment

	**Ear protection:** Always wear an ear protection when using the machine.
	**Safety glasses / Face shield:** Always wear at least safety glasses when working on the machine. If necessary, use a full eye protection or face shield, since normal eyeglasses are usually only shock-resistant and safety glasses only protect the eyes. A face shield protects eyes and face.
	**Protective footwear:** Wear protective footwear and make sure the floor is non-slip.
	**Respiratory protection:** When processing different types of wood, exotic wood-based and other materials, and when performing certain tasks like sanding, sawing or drilling, dusts are produced that are harmful to health. Operate the machine only in well-ventilated areas and wear respiratory protection. Use a suitable dust collector and, if necessary, an air filtering system.

2.4 Operator obligations

The operator is the person who operates the machine for commercial or private purposes.

The operator must keep the machine in good condition. He undertakes to check the safety devices for correct functioning and to leave them on the machine. Any structural change to the machine is prohibited. Commercial operators must ensure that the legal obligations regarding occupational safety are complied with.

WARNING

Risk of injury due to use by insufficiently qualified persons!

Insufficiently qualified persons cannot correctly assess the risks involved in using the machine. There is a risk of serious or fatal injury.

- Observe the chapter on basic health and safety instructions and the warning notices in these operating instructions and on the machine.
- Before using the machine for the first time, obtain information on the subject and ask qualified persons for training.

2.5 Safety devices

Safety devices serve to protect persons and material. Without intact safety devices serious injuries can occur.

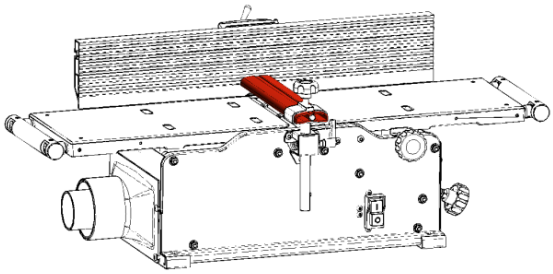
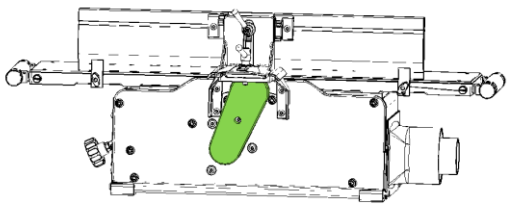
WARNING

Risk of injury due to defective or missing safety devices!

Defective or missing safety devices do not fulfil their purpose. Serious injuries can result.

- Only operate the machine with functioning safety devices.
- Switch off the machine immediately if safety devices are defective or removed.
- Only use additional equipment installed by the operator with prescribed safety devices.

Overview of safety devices

Bridge guard above the cutterhead The bridge guard above the cutterhead protects against reaching into the cutterhead. The position of the bridge guard can be adapted according to the use. It has to cover the largest possible area of the cutterhead (when face jointing the whole cutterhead).	
Belt cover The cover above the drive belt prevents access to the moving parts located there. Removing the cover is only possible with a tool.	

3 Machine description

3.1 Functional description

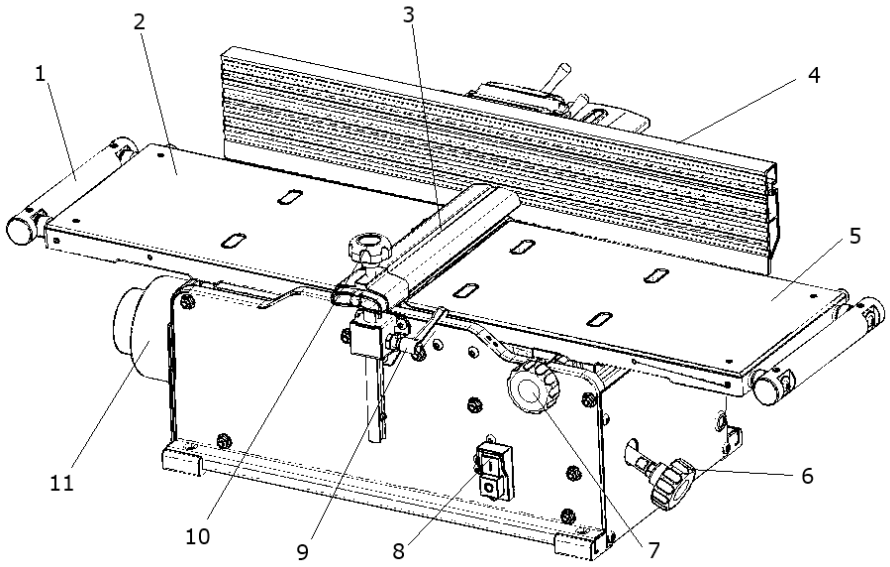
The jointer is used for machining rough sawn wood. It is used to plane a wooden workpiece flat and/or joint an edge in a specific angle.

The workpiece is placed on the infeed table on the right side of the machine and moved over the cutterhead situated in the centre of the machine. The helically arranged knives on the cutterhead remove a layer of wood. The workpiece is taken off at the outfeed table at the left side of the machine. The infeed table, which is adjustable in height, is positioned lower than the outfeed table, which is set at height of the knife cutting circle and is not height-adjustable. The difference in height between infeed table and outfeed table determines the depth of cut. The fence at the rear of the machine is for guiding the workpiece and creating a specific angle (90° and 45°).

3.2 Description of the jointer

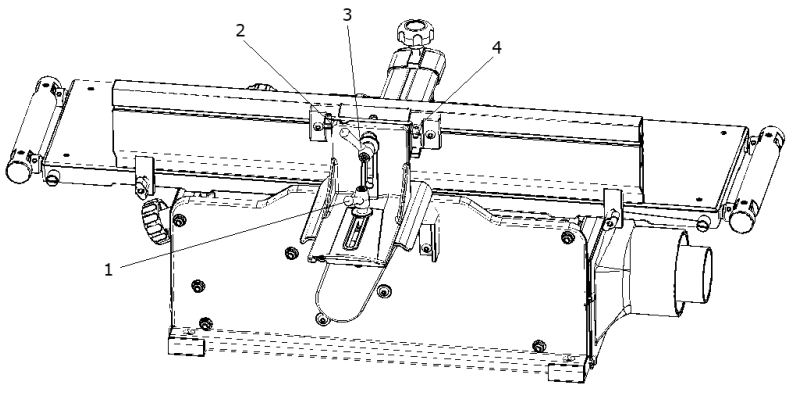
3.2.1 Front

1. Table extension
2. Outfeed table
3. Bridge guard
4. Fence
5. Infeed table
6. Height adjustment infeed table
7. Infeed table lock
8. ON/OFF switch
9. Clamping lever bridge guard height adjustment
10. Star knob screw bridge guard depth adjustment
11. Dust collection port



3.2.2 Rear

1. Fence slide clamping lever
2. 90°-stop
3. Fence lever
4. 45°-stop



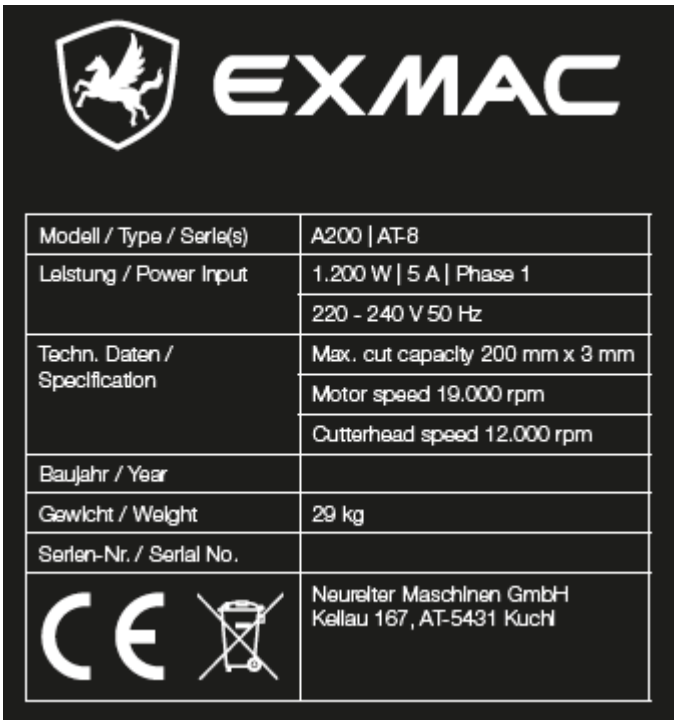
3.3 Technical data

Machine dimensions	Length (extensions in)	approx. 836 mm
	Length (extensions out)	approx. 1350 mm
	Width	approx. 530 mm
	Height	approx. 330 mm
Table dimensions	Length	approx. 770 mm
	Length with extension	approx. 1350 mm
	Width	approx. 204 mm
Fence dimensions	Length	approx. 610 mm
	Height	approx. 111 mm
Weight	Gross / net	32 kg / 29 kg
Drive	Type of drive	Induction motor, single-phase
	Operating mode	S6
	Voltage	230 Volt
	Power	1200 W (1.6 HP)
	Frequency	50 Hz
	Current	5 A
	Motor speed	19,000 rpm ±10%
Cutterhead	Cutterhead speed	12,000 rpm
	Cutterhead diameter	50.8 mm
	Knives	4-sided – 16 pcs.
Workpiece	Minimum length	250 mm
	Maximum width	203 mm
	Minimum width	19 mm
	Minimum thickness (face jointing)	12.7 mm
	Minimum thickness (edge jointing)	6.35 mm
Depth of cut	Max. depth	3.175 mm
Dust collection port	Diameter	100 mm
	Diameter with included adapter	63.5 mm
Noise emission	Sound pressure level	86.75 dB(A)
	Sound power level	92 dB(A)

The measurement is carried out in accordance with the standards EN ISO 3746:2011 & EN ISO 4871:2009.

The measured emission level cannot reliably be used to determine the actual noise level in the workplace, since factors such as the duration and type of work, the workshop size and the existence of other sources of noise (e.g. machines running at the same time) have a decisive influence on the noise level. The acceptable exposure rates may vary from country to country. An ear protection must be worn when using the machine.

Nameplate



3.4 Installation site requirements

Requirement	Recommendation
Installation site	Fasten the machine near a power source (type F socket) on a solid, level and stable installation surface (workbench, table) (see chapter "Assembly and installation").
Lighting	Pay attention to good lighting.
Ambient temperature	+10°C to +32°C
Ventilation	Ensure adequate ventilation. Use a dust collector.
Working height	Comfortable working height depending on user's body size.
Working space	Make sure there is enough space on the infeed and outfeed sides of the machine for handling the workpieces.

3.5 Electrical equipment

WARNING

Danger to life due to electric current!

When touching live parts, there is an immediate danger to life due to electric shock. Damaged insulations or electrical components can be life-threatening.

- Have work on the electrical system components carried out only by qualified electricians.
- Before working on electrical system components, switch off the machine and pull the power plug. Do not leave the power plug unattended and secure it against being plugged in.
- In case of damaged insulations, switch off the machine immediately and have them repaired.
- Keep the power cord away from heat, oil, sharp edges and moving parts.

WARNING

Danger to life due to electric current!

If a wrong extension cord is used, there is a risk of fire due to overheating, and danger to life due to an electric shock.

- Avoid using an extension cord.
- If the use of an extension cord is unavoidable, make sure that the extension cord is designed for the intended purpose. (In case of doubts, choose a short, thick cord or contact a qualified electrician).

WARNING

Danger to life due to electric current!

If the earthing conductor is connected incorrectly, there is an immediate danger to life due to electric shock.

- Connect the earthing conductor (green-yellow sheathed) correctly.
- Keep the earthing conductor away from life terminals when changing the cable or plug.

NOTICE

Electrical cables and sockets must comply with local electrical codes!

- Observe electrical codes.
- In case of doubt, contact a qualified electrician.

NOTICE

In order to operate the machine, a suitable household 230 V type F socket is required.

If the machine is operated outside of this voltage, it may run irregularly or may be damaged.

- Use a suitable type F socket.
- Observe the indications in these operating instructions.

4 Transport, packaging and storage

4.1 Transport dimensions

Dimensions	Length	930 mm
	Width	390 mm
	Height	355 mm
Weight	Gross	32 kg

4.2 Notes on storage and transport

NOTICE

Possible damage to the machine due to incorrect storage!

If the machine is stored incorrectly, parts of the machine can be damaged.

- Store the machine in a dry, dust-free environment.
- Keep the machine away from aggressive media.
- Protect the machine from excessive sunlight.
- Make sure that the ambient temperature does not exceed 32°C.
- Before assembly, give the machine sufficient time to adapt to the temperatures at the installation site.

NOTICE

Possible damage to the machine due to incorrect transport!

If the machine is transported incorrectly, parts of it may be damaged.

- Follow the instructions on the machine's packaging.
- If a machine that has already been assembled is to be transported, hold the machine by the base, not by the tables.

4.3 Notes on packaging

The packaging is intended to protect components from damage and corrosion. Only remove the packaging shortly before assembly.

NOTICE

Danger to the environment due to incorrect disposal of packaging material!

Incorrectly disposed of packaging material can damage the environment.

- Dispose of packaging material in accordance with applicable regulations.

4.4 Unloading and unpacking

WARNING

Risk of crushing when unloading the machine!

The machine is heavy. When unloading, there is a risk of body parts being crushed.

- Unpack the machine with the help of a second person.
- Make sure that no limbs are under or between machine components.
- Be careful when unloading the machine.

WARNING

Danger of cutting!

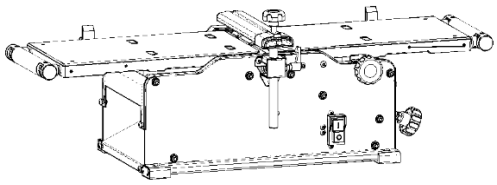
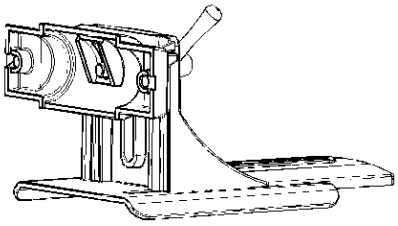
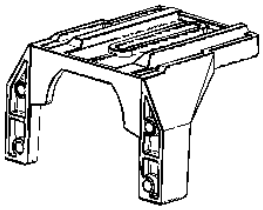
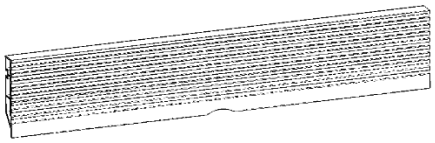
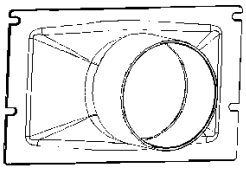
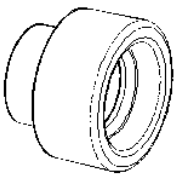
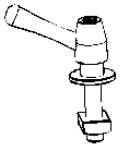
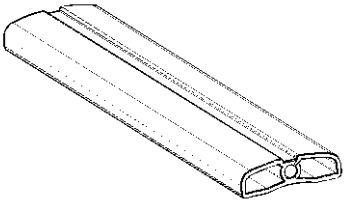
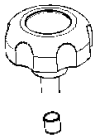
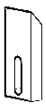
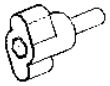
The knives are very sharp. In case of contact, there is a danger of cuts.

- Keep hands, fingers and other parts of the body away from the knives.
- Be particularly careful when handling near the knives.

Unpacking the machine

1. Before unpacking, check the box for damages.
2. Carefully take packaging material, machine and other parts out of the box.
3. Remove the packaging material.
4. Lay out all parts on a clean work surface.
5. Remove all protective materials.
6. Moisten a cloth with a suitable cleaning agent and use it to remove coatings from all machine parts except the cutterhead.
7. Check the content of the delivery for completeness.
   Notice: Some parts shown may already be installed. Some parts can be found in the machine.
8. If any parts are missing, contact the dealer.
9. Do not start up the machine until all parts are present and assembled.
10. If there are still residues of the oil film from the manufacturing process on the cutterhead, clean the cutterhead before starting up. See chapter “Cleaning the cutterhead”.

4.5 Transport package content

		
1x jointer	1x fence slide	1x fence bracket
		
1x fence	1x dust collection port 100 mm	1x adapter 100 mm to 63.5 mm
		
1x fence slide clamping lever with washer and square nut	1x bridge guard	1x star knob screw with spacer
		
2x square nut with screw	2x end stop	2x wing screw
		
1x star head T-bar key	1x set of hex keys (4 mm and 2 mm)	2x push block

5 Assembly and installation

WARNING

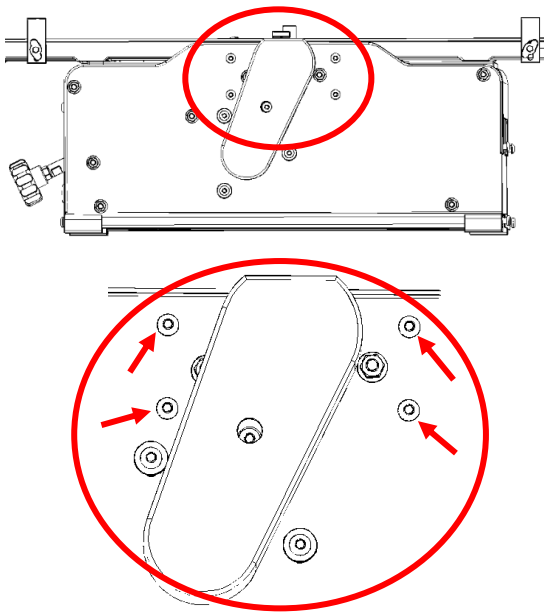
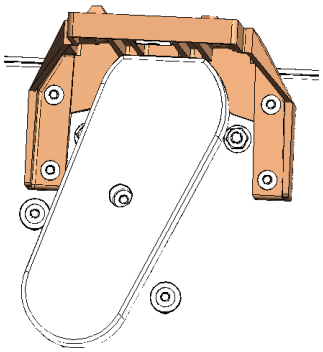
Risk of injury due to unintentional start-up!

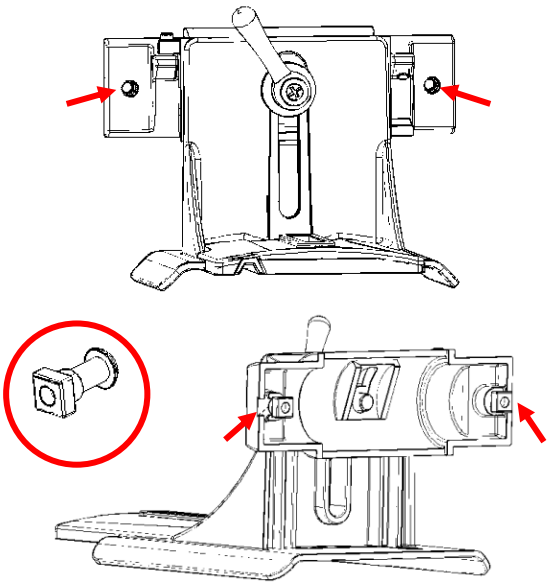
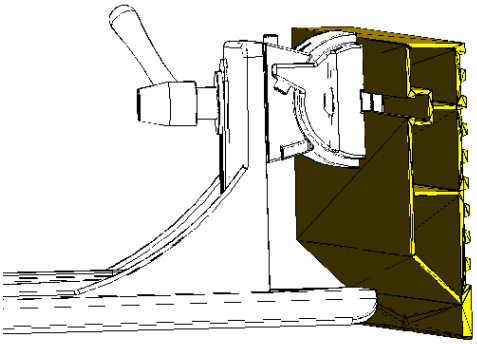
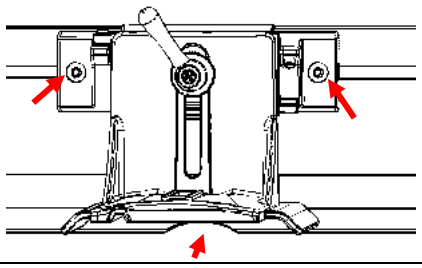
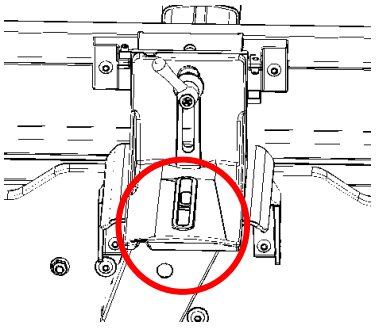
There is a risk of injury if the machine starts accidentally during assembly.

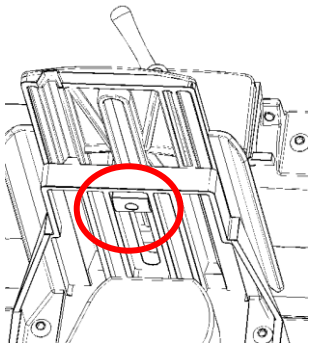
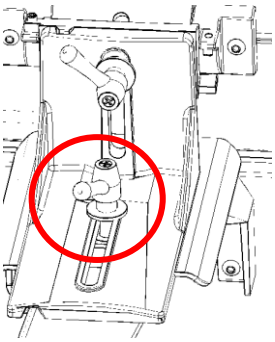
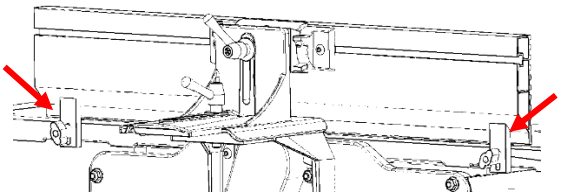
- Keep the machine switched off and disconnected from the power supply during assembly.

The machine is delivered largely pre-assembled. Only a few parts need to be assembled:

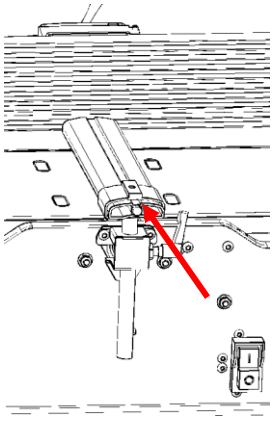
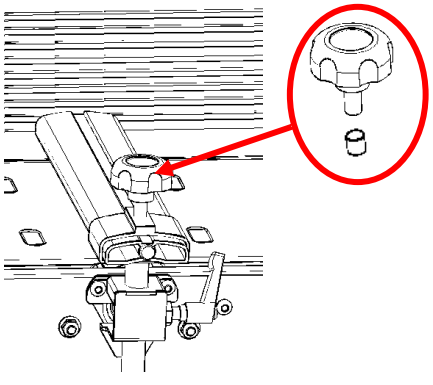
5.1 Mounting the fence

1. Remove the four screws shown at the rear of the machine with the supplied 4 mm hex key.	
2. Attach the fence bracket using the four previously removed screws and the 4 mm hex key. 3. Tighten the screws securely.	

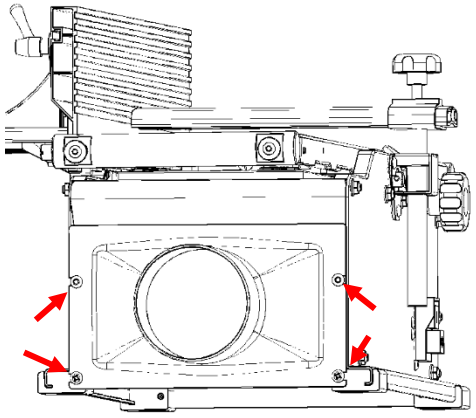
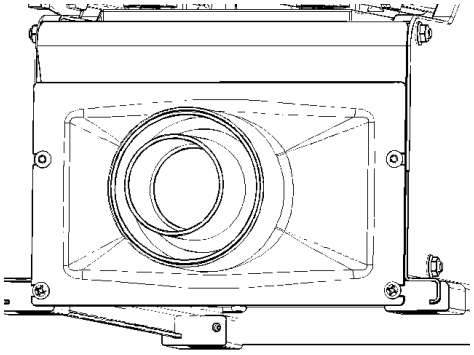
4. Remove the supplied square nuts from the screws. 5. Insert the screws from the outside into the holes on the fence slide. 6. Screw the square nuts from the inside onto the screws by hand for about 3 turns, but do not tighten them yet.	
7. Slide the fence with its back facing towards the fence slide and its bevelled side downwards onto the square nuts as shown. If necessary, turn the square nuts slightly.	
8. As soon as the fence is centred, tighten the two screws on the back with the 4 mm hex key. The arc-shaped cutout on the lower edge of the fence should later be positioned above the cutterhead.	
9. Slide the fence slide with the mounted fence onto the fence bracket from the rear until the oblong holes of the fence bracket are half exposed.	

10. Place the square nut with its convex side facing downwards on the underside of the fence bracket.	
11. Put the clamping lever through the washer and place it onto the fence bracket from above. 12. Screw on the square nut from below only far enough so that the fence can still be moved easily. 13. Slide the fence with the fence slide all the way back.	
14. Fix one end stop at each end of the fence at an appropriate height with a wing screw.	

5.2 Attaching the bridge guard

1. Insert the bridge guard into the provided support on the front of the machine.	
2. Insert the supplied plastic spacer into the hole. This protects the bridge guard from damage. 3. Screw in the star knob screw.	

5.3 Attaching the dust collection port

1. Remove the top socket head screw and the bottom cross-head screw on the right side of the opening on the outfeed side. 2. Loosen the top socket head screw and the bottom cross-head screw on the left side of the opening. 3. Thread the supplied dust collection port into the screws on the left side of the opening. 4. Fix the dust collection port on the right side with the previously removed screws. 5. Tighten the screws on the left side.	
6. If necessary, insert the supplied adapter into the dust collection port. 7. Connect the dust collector (see notice below).	

NOTICE

Notes on the dust collector!

A dust collector is mandatory when using this machine.

- Preferably use a big dust collector with a hose with a diameter of 100 mm (no adapter required).
- Alternatively, use a cyclone dust collector with a 63.5 mm hose (supplied adapter required).

5.4 Work ergonomics

CAUTION

Physical impairments due to incorrect posture and incorrect positioning of the machine!

Incorrect positioning of the machine and unsuitable posture can lead to posture problems and rapid fatigue which may increase the risk of accidents.

- Maintain a good posture, ensure secure footing and maintain balance at all times.
- Position the machine at a comfortable height.
- Pay attention to an ergonomic posture.

5.5 Mounting on table or workbench

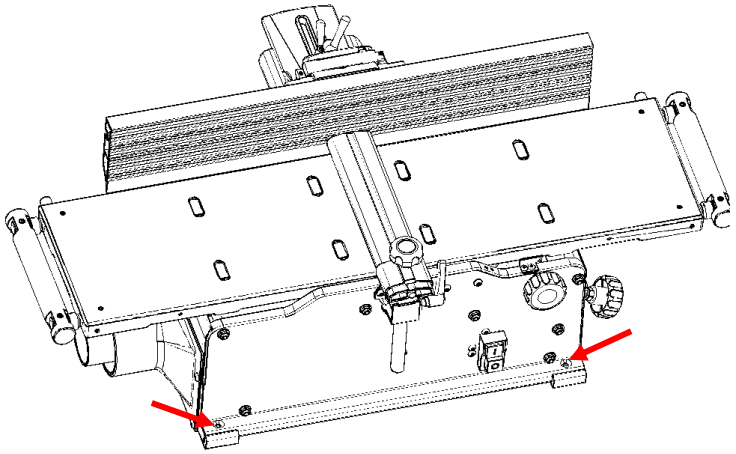
NOTICE

Instructions for mounting!

The machine may only be operated if it is screwed to the installation surface (table, workbench, etc.).

- Screw the machine to a solid and level installation surface that has a sufficient load capacity.

The machine is equipped with 2 holes with a diameter of approximately 10 mm on the front and back (base thickness approx. 22 mm) with which the machine is attached to the installation surface.

Screw the machine at the front and the back to the installation surface using four suitable screws (not included). Use suitable washers, spring washers and nuts to secure the screws.	

6 Settings on the machine

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally during setting procedures.

- Before carrying out setting procedures, switch off the machine and disconnect it from the power supply.

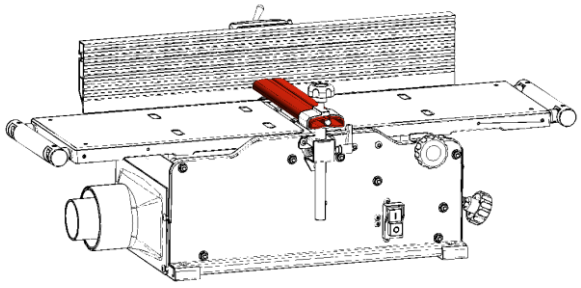
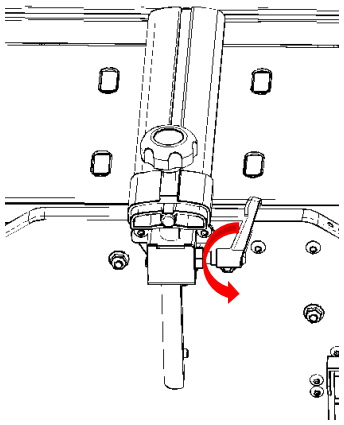
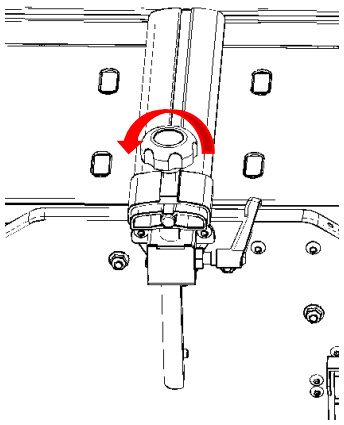
WARNING

Danger of cutting!

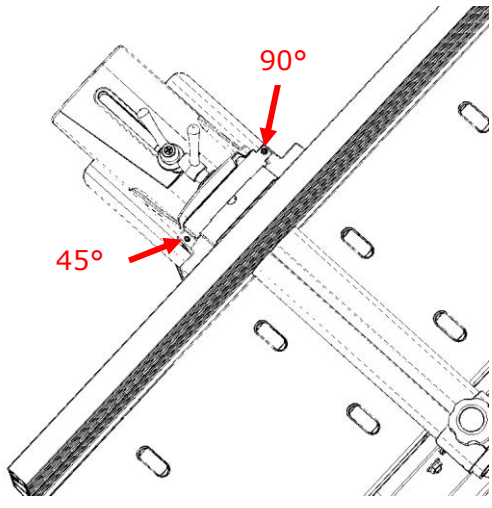
The knives are very sharp. In case of contact, there is a danger of cuts.

- Keep hands and fingers away from the knives.
- Be particularly careful when handling near the knives.
- Before each use, check the correct setting and functioning of the bridge guard.
- When the machine is not in use, make sure that the bridge guard covers the entire cutterhead.

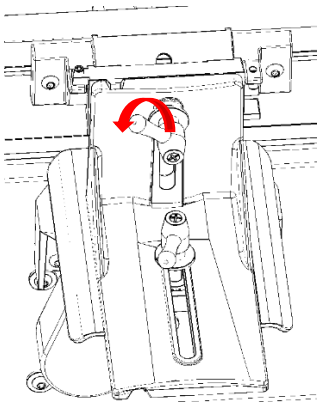
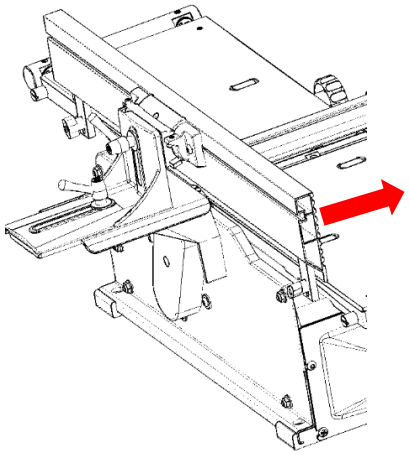
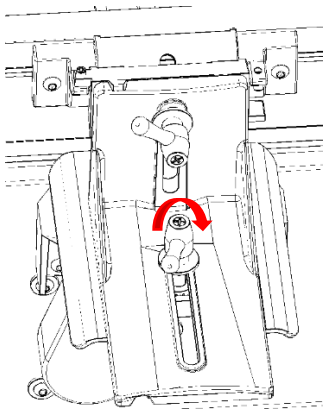
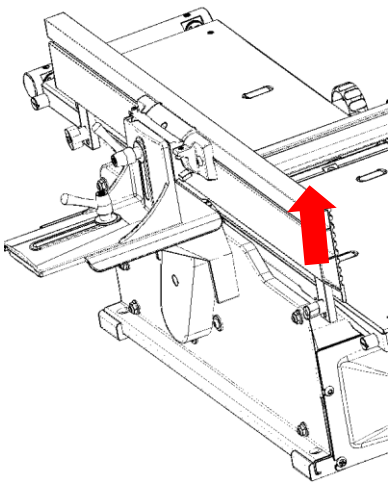
6.1 Setting the bridge guard

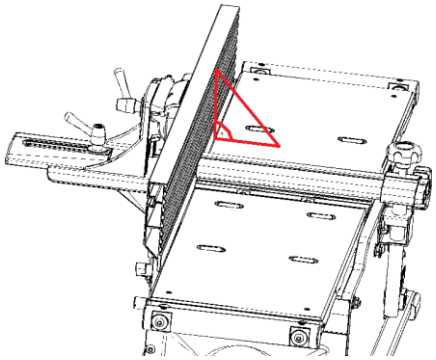
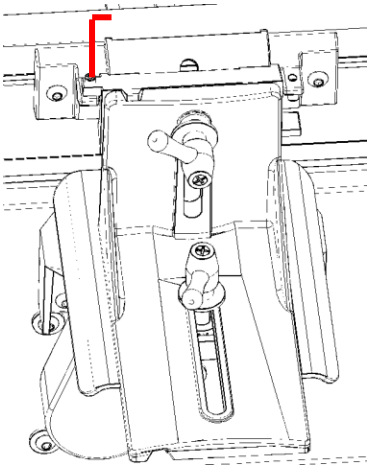
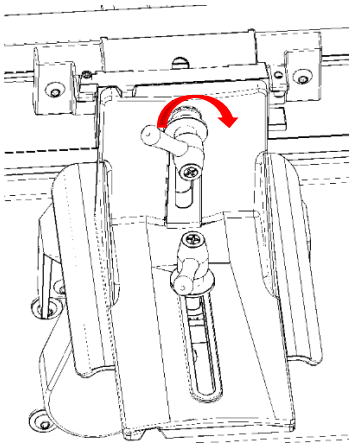
The height of the bridge guard is adjustable from 0 to 85 mm. It needs to be adapted to the workpiece thickness.	
1. Loosen the clamping lever on the bridge guard. 2. Adjust the height of the bridge guard. 3. Tighten the clamping lever.	
To joint an angled edge, the depth of the bridge guard can be adjusted accordingly. 1. Loosen the star knob screw. 2. Adjust the bridge guard depth. The bridge guard should cover as large an area of the cutterhead as possible. 3. Tighten the star knob screw.	

6.2 Setting the fence

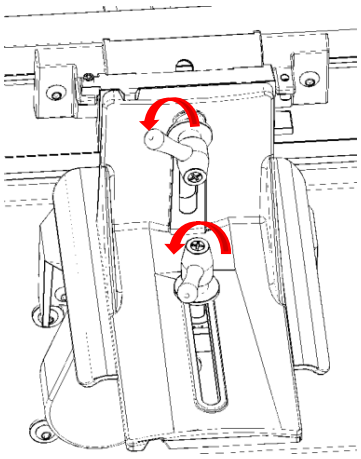
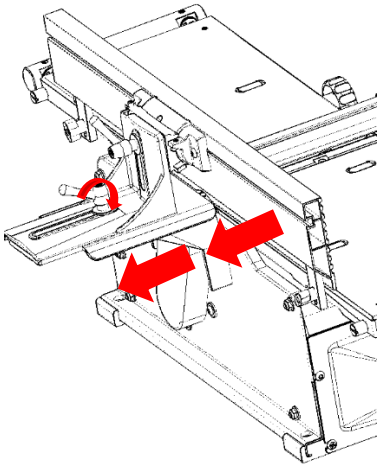
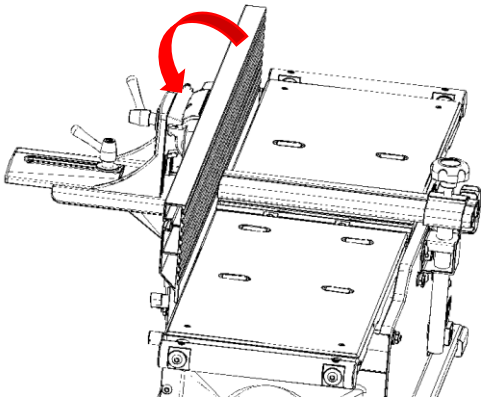
The fence can be tilted from 90 to 45 degrees. Two adjustable stop screws (set screws) on top of the fence slide are used to adjust the angle (see figure on the right).	

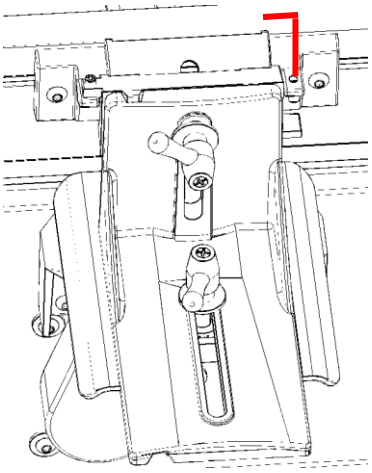
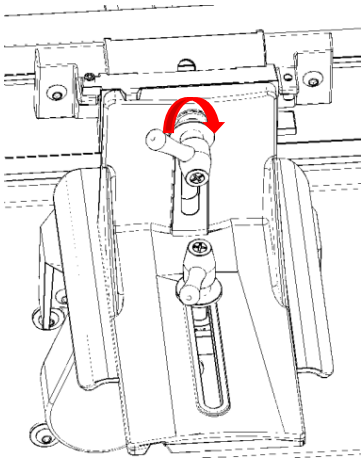
6.2.1 Setting the 90° fence stop

1. Slightly loosen the fence lever that locks the fence in place.	
2. Lift the fence slightly so that there is a gap between fence and tables. 3. Slide the fence forward by approx. 25 mm. 4. Leave the fence lever slightly loosened.	
5. Tighten the fence slide clamping lever.	
6. Lift the fence approx. 1.6 mm above the table. 7. Place a suitable spacer (e.g. a pack of playing cards) underneath to keep the fence at height. The fence must be raised as it will move as soon as the fence lever is tightened.	

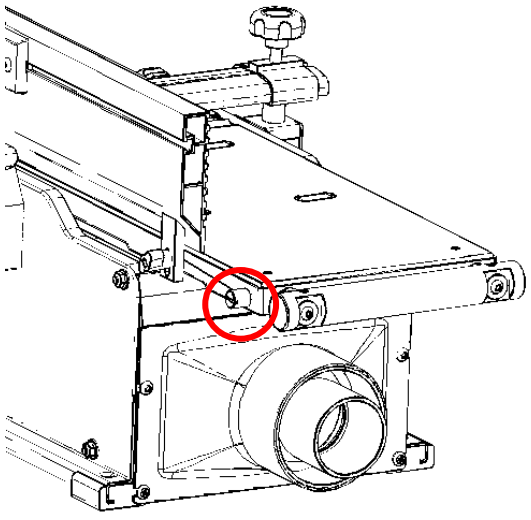
8. Place a square onto the table. 9. Adjust the fence accordingly.	
10. Adjust the 90° stop screw using the supplied 2.5 mm hex key. The stop screw should only lightly touch the fence.	
11. Tighten the fence lever. 12. Remove the spacer. 13. Use the square to check if the fence stays at 90°. 14. If the angle is not correct, repeat the adjustment procedure.	

6.2.2 Setting the 45° fence stop

1. Slightly loosen the fence lever and the fence slide clamping lever.	
2. Slide the fence back completely. 3. Tighten the fence slide clamping lever.	
4. Place a 45° square onto the table and tilt the fence accordingly so that 135° are obtained on the side of the table. 5. Place a spacer under the fence.	

6. Adjust the 45° stop screw using the supplied 2.5 mm hex key. The 45° stop screw is very deep in the hole. If necessary, use a torch to locate it.	
7. Tighten the fence lever. 8. Remove the spacer. 9. Check the 45° angle. 10. If the angle is not correct, repeat the adjustment procedure. 11. If the angle is correct, the fence lever can now be used to set the fence at the desired angle.	

6.3 Setting the table extension

1. To unlock the table extension, loosen the knurled screw on the back of the machine. 2. Pull out the table extension as far as necessary. 3. Tighten the knurled screw.	

6.4 Cleaning the cutterhead

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally while cleaning the cutterhead.

- Before cleaning the cutterhead, switch off the machine and disconnect it from the power supply.

WARNING

Danger of cutting!

The knives are very sharp. In case of contact, there is a danger of cuts.

- Watch hands and fingers.
- Never turn the cutterhead by hand.
- Wear heavy leather gloves when handling the cutterhead.

NOTICE

Carrying out the cleaning procedure!

It is possible that residues of the oil film required for the manufacturing process can still be found on the cutterhead. These residues need to be removed before using the machine.

- Run scrap pieces through the machine until the oil film is removed.
- Only carry out the cleaning procedure described below if the oil film is still present after having run scrap pieces through the machine several times.

NOTICE

Damage to the paint caused by solvents!

Solvents or cleaning agents can cause damages to the paint.

- When cleaning, make sure that no solvents or cleaning agents come into contact with painted surfaces.

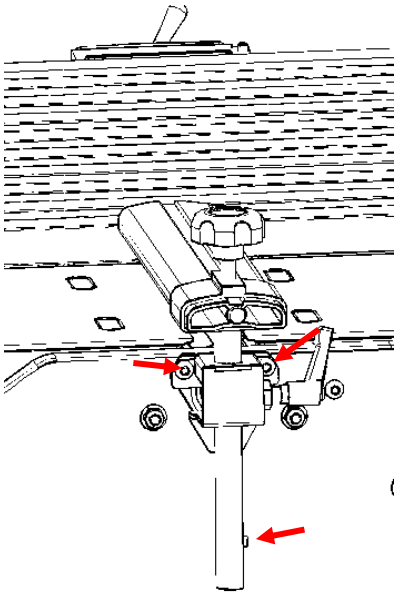
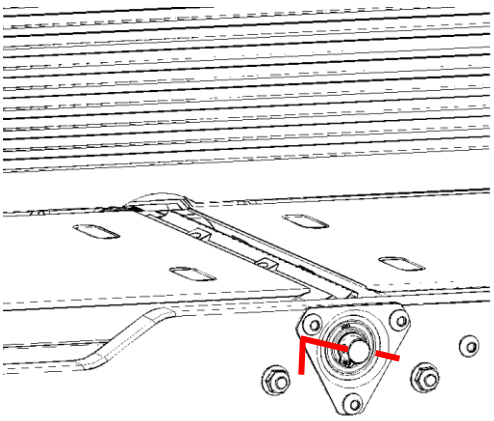
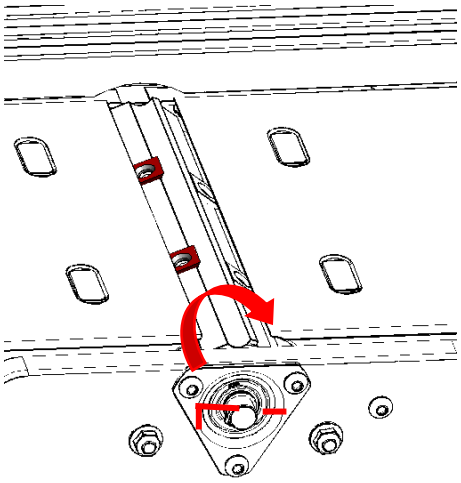
NOTICE

Dirty and worn knives!

Resin and dirt can build up on the knives. Worn knives can affect the planing result.

- Check knives regularly for build-up of resin and dirt and clean them if necessary.
- Check knives regularly for wear. If necessary, rotate or replace the knives.

The cutterhead is cleaned as follows:

1. Ensure good lighting.	
2. Remove the two screws that hold the bridge guard holder and take off the bridge guard. If it is difficult to loosen the screws, remove the small screw at the end of the rod with a hex key and pull the rod out upwards.	
3. Insert the supplied 4 mm hex key into the hole at the outer end of the cutterhead to hold the cutterhead in position.	
4. Rotate the 4 mm hex key to turn the cutterhead until one row of knives is facing upwards. 5. Carefully remove the knives with the supplied star head T-bar key. 6. Continue turning the cutterhead using the 4 mm hex key and gradually remove all the knives.	
7. Separate the knives from the screws and place them in separate containers with mineral spirit or non-chlorinated brake cleaner.	

8. Wipe down the bare cutterhead using a cloth and a solvent and remove any oil.	
9. Blow off each seat and each screw hole on the cutterhead with a compressor or a compressed air duster. This makes it easier to reinsert the knives.	
10. Lubricate the star head screw threads with light machine oil. 11. Wipe off any excess oil.	
12. Insert the knives in a row into the seats and tighten them slightly.	
13. Once all knives have been reinserted in a row, tighten the knives (approx. 5.5 Nm).	
14. Fasten the remaining knives in the same way.	
15. Reinstall the bridge guard.	

NOTICE

Oil residues after cleaning!

After cleaning the cutterhead, there may still be oil residues.

- Run scrap pieces through the machine to make sure that there are no oil residues anymore.
- If there are still oil residues, repeat the cleaning procedure.

7 Operating the jointer

WARNING

Risk of injury due to missing experience!

This chapter provides basic instructions on how to operate the machine. However, for optimum use of the machine, it is beneficial to study the subject and to be trained by qualified persons. Missing experience can lead to serious injuries.

- Before using the machine for the first time, study the subject and ask qualified persons for training.

NOTICE

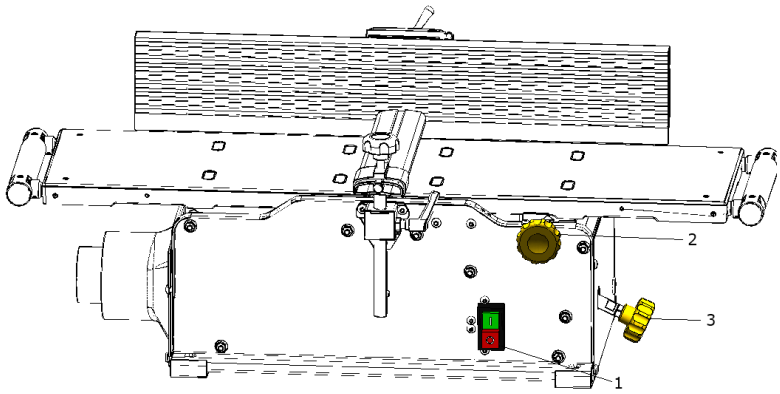
Possible damages to the machine!

This machine is only suitable for processing wood and for its intended use. Processing other materials and unintended use can result in damages to the machine and warranty loss.

- Only process wood.
- Only use the machine for its intended use.

7.1 Operating elements

1. ON/OFF switch
2. Infeed table lock knob
3. Height adjustment knob infeed table

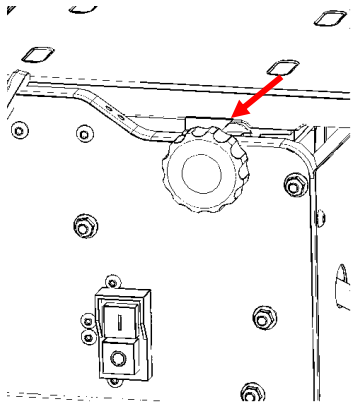
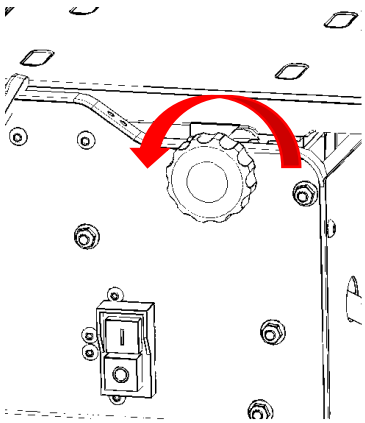
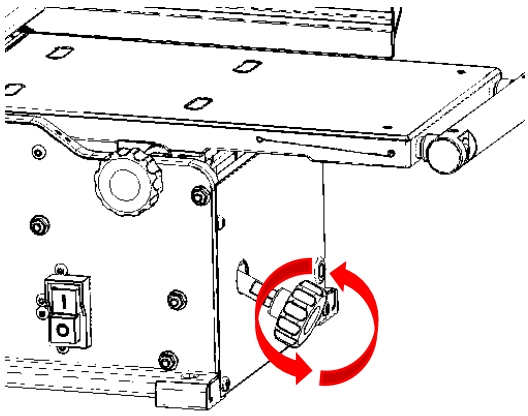
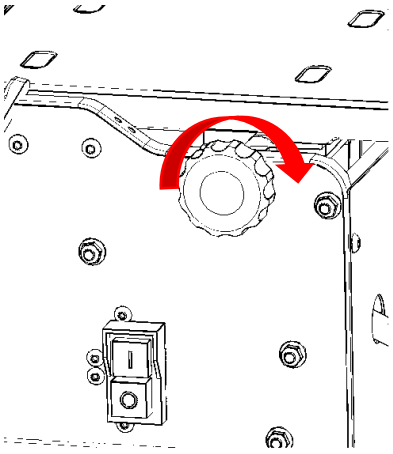


7.1.1 ON and OFF switch

The ON and OFF switches are located on the front of the machine.

- Switch on the machine by pressing the green ON switch (I).
- Switch off the machine by pressing the red OFF switch (O).

7.1.2 Setting the depth of cut

The depth of cut that can be set on the machine ranges from very thin to approx. 3.2 mm. The tip of the pointer indicates the set depth of cut on the scale. To set the depth of cut, proceed as follows:	
1. Loosen the infeed table lock by turning the knob anti-clockwise.	
2. Raise the infeed table by turning the height adjustment knob anti-clockwise, lower the infeed table by turning the height adjustment knob clockwise.	
3. Tighten the infeed table lock by turning the knob clockwise.	

7.2 Using the jointer

7.2.1 Starting up the jointer

WARNING

Risk of injury due to machine movements!

If the machine is not screwed to the installation surface and therefore starts moving, there is a risk of injury.

- Screw the machine to the installation surface (see chapter “Assembly and installation”).

WARNING

Danger of being pulled in!

Loose clothes, jewellery or long hair can be caught and pulled in by moving parts of the machine which can lead to injuries.

- Observe the specifications for personal protective equipment in these operating instructions.
- Wear personal protective equipment.
- Wear suitable clothing.
- Do not wear loose clothing and jewellery.
- Wear a headgear or hairnet.
- Avoid wearing gloves.

WARNING

Danger of cutting!

The knives are very sharp. In case of contact, there is a danger of cuts.

- Keep hands and fingers away from the knives.
- Be particularly careful when handling near the knives.
- Never apply downward pressure directly above the cutterhead.
- Leave the bridge guard on the machine and adjust it correctly.
- Use push blocks.
- Keep push blocks within easy reach.
- Never push the workpiece on the outfeed table back towards the infeed table.
- Avoid unusual working methods. Before carrying out such working methods, check whether suitable hold-down or pushing devices, fixtures or stops can be used.

WARNING

Risk of injury due to kickback and splinters!

Workpieces being thrown back and splinters can cause injuries.

- Wear personal protective equipment.
- Wear safety glasses or a face shield.
- Observe the basic safety instructions and the labels on the machine.
- Stand at the side, not directly behind the infeed table.
- Check the condition and suitability of the workpieces before processing them.
- Avoid processing heavily crooked wood. Its supporting surface is too small.
- Always process the whole workpiece and do not end the cut prematurely.
- Always support the workpiece and keep control of it.

WARNING

Risk of injury due to insufficient workpiece dimensions!

If workpieces are fed that have insufficient dimensions, they can be thrown out of the machine and cause serious injuries. There is also an increased risk that fingers or hands get into the cutterhead if workpieces with insufficient dimensions are processed.

- When face jointing, only feed workpieces that are at least 250 mm long, 19 mm wide and 12.7 mm thick.
- When edge jointing, only feed workpieces that are at least 250 mm long, 19 mm wide and 6.35 mm thick.

WARNING

Risk of injury due to flying metal parts!

Metal parts getting into the cutterhead can be thrown out and cause injuries. They can also cause damages to the machine and flying sparks, creating a risk of fire.

- Make sure that no metal parts get into the cutterhead.

NOTICE

Possible damages to the machine!

If the machine is constantly operated at maximum depth of cut (3.175 mm), at maximum width (203 mm) or under continuous load, the motor is subject to a high load. This can damage the motor or affect the service life of the motor.

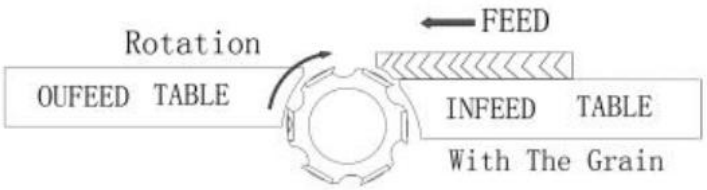
- Set a depth of cut lower than the maximum.
- Prefer workpiece widths smaller than the maximum workpiece width.
- Give the motor sufficient time to cool down between individual work steps (do not switch off the machine).

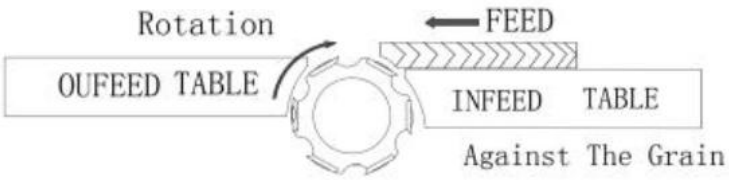
NOTICE

Notes on face jointing!

The best results are only achieved with a correctly set machine and intact, sharp knives. The maximum possible depth of cut depends on the type of wood, workpiece width and workpiece properties (such as grain, degree of dryness). The depth of cut influences the final result and how much strain is placed on the motor.

- Before starting up, make sure that the machine is correctly set.
- Before starting up, make sure that the knives are intact and sharp.
- Only use knives suitable for the machine.
- The wider the workpiece and the harder the type of wood, the less the cutting depth.
- A reduced depth of cut is good for the machine and the result.
- Give green wood enough time to achieve the necessary degree of dryness.
- Never process more than one workpiece at a time.
- Run the workpiece through the machine at different points. Adjust the fence accordingly. If the workpiece always runs through the machine at the same point, the knives will wear unevenly.
- Always place the concave side of the workpiece on the infeed table. To identify the concave side, place the workpiece on the table and check which side wobbles more. The side that wobbles less is the concave side.
- Always feed the workpiece in the direction of the grain (see figure below). Feeding against the grain will result in splintered edges and tear outs.





- If the workpiece is roughly sawn, crooked or twisted, several passes are necessary to achieve a flat surface. With such workpieces, apply light downward pressure and set a very thin depth of cut.

NOTICE

Dirty and worn knives!

Resin and dirt can build up on the knives. Worn knives can affect the planing result.

- Check knives regularly for build-up of resin and dirt and clean them if necessary.
- Check knives regularly for wear. If necessary, rotate or replace the knives.

Operating the machine

1. Observe the safety notices at the beginning of the chapter and the basic safety instructions.
2. Make sure that infeed and outfeed tables are clean.
3. If necessary, apply a suitable lubricant to the tables. Pay attention to the cutterhead - danger of cutting. The lubricant ensures that the workpiece slides better on the tables and protects the tables from corrosion.
4. Before using the machine for the first time, check that the knives are firmly in place.
5. Use scrap wood for first planing attempts and perform tests. This helps to gain experience in how to set up the machine correctly and how to handle the machine.
6. Set the desired depth of cut.
7. Adjust the fence.
8. Adjust the bridge guard. When face jointing, the bridge guard must cover the whole cutterhead. When edge jointing, the bridge guard reaches up to the workpiece that is placed on its edge.
9. If necessary, pull out the table extension.
10. For longer workpieces, be sure to use an additional support (e.g. roller stand). Place the support as centrally as possible.
11. Take a position on the side of the machine, do not stand directly behind the infeed table.

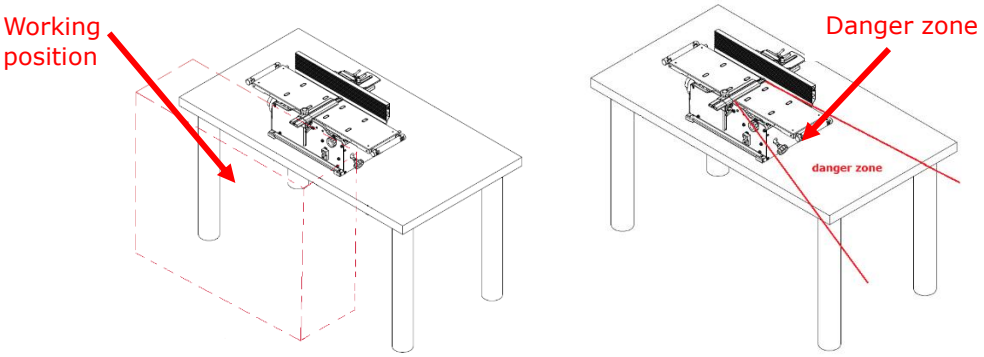
NOTICE

Notes on the correct working position!

The correct working position prevents injuries.

The correct working position is on the side of the machine.

The danger zone of this machine is behind the infeed table. Never stand behind the infeed table! Only your hands may be reaching into the danger zone.



12. Press the ON switch.
13. Feed the workpiece. The workpiece needs to be positioned differently depending on whether the face or the edge shall be jointed (see below).

Face jointing

1. Place the workpiece with the larger face and the concave side facing downwards onto the infeed table. The smaller edge is touching the fence. The concave side of the workpiece faces down, the workpiece is oriented in the direction of the grain.
2. Adjust the bridge guard to the thickness of the workpiece. The bridge guard must cover the whole are of the cutterhead.
3. Move the workpiece from the infeed table over the cutterhead (under the bridge guard) to the outfeed table. Pay attention to the correct hand position (see below). Never reach under the bridge guard!
4. Remove the workpiece from the outfeed table. Pay attention to the correct hand position (see below).
5. Repeat the face jointing procedure until the surface is flat.

NOTICE

Notes on the correct hand position!

The correct hand position prevents injuries.

1. At the beginning of the cut, use the push block in your left hand to push the workpiece onto the infeed table and against the fence. Use the push block in your right hand to move the workpiece towards the cutterhead.
2. As soon as one hand has space on the workpiece on the outfeed table side, switch to the outfeed table with your left hand and hold the workpiece down there. Continue to push the workpiece against the fence and move it further with your right hand.
3. As soon as there's enough space on the outfeed table side for both hands, switch to the outfeed table side with your right hand and only apply pressure here. Never move the workpiece back towards the cutterhead.

WARNING

Danger of cutting!

If the push blocks are not used, there is an increased risk of injury, which is why the use of the push blocks is strongly recommended. If the push blocks are not used, the correct finger position is essential to avoid serious injuries.

On the infeed table:

- Only place your hands on the upper surface.
- Fingers and hands must not protrude over the edges.
- The fingers of both hands must be closed.

On the outfeed table:

- Grip the workpiece by its sides. Make sure there is sufficient distance from the cutterhead.
- For long workpieces, press the workpiece down at the end of the machine so that you can grasp it on the side that is tilted up and remove it.
- Never reach behind the workpiece where the cutterhead is located.

Edge jointing

1. Set the fence to 90°.
2. Adjust the depth of the bridge guard to the workpiece. The bridge guard should cover as large an area of the cutterhead as possible.
3. Place the workpiece on its edge on the infeed table with the face jointed surface against the fence.
4. Use the push blocks in your hands to apply pressure downwards and against the fence and guide the workpiece over the cutterhead. If the push blocks aren't used, always place your hands flat on the workpiece and keep your fingers closed.
5. Remove the workpiece and check the right angle.

NOTICE

Notes on the jointer!

It is normal for the workpiece to be slanted after several passes. A jointer can only joint **one** surface and **one** edge (two sides of the workpiece in total). A jointer cannot create two surfaces or edges that are parallel to each other or four surfaces at right angles to each other.

- To create two parallel surfaces, use a thickness planer.
- To create two parallel edges, use a table saw.

8 Care and maintenance

8.1 Maintenance, cleaning and machine care

Regular maintenance increases the service life of the machine.

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally during maintenance and cleaning.

- Before carrying out maintenance and cleaning, switch off the machine and disconnect it from the power supply.

WARNING

Danger of cutting!

The knives are very sharp. In case of contact, there is a risk of injury.

- Keep hands and fingers away from the knives.
- Be particularly careful when handling near the knives.
- Wear heavy leather gloves when handling the cutterhead.

NOTICE

Possible damages to the machine!

Compressed air above 3.5 bar can damage to motor insulation.

- Use low-pressure air to blow off the motor.

Interval	Note	Location	Measure
After each use		Machine and surroundings	Clean machine and surroundings of chips, dust and dirt or blow off chips.
		Infeed and outfeed tables	Check tables for build-up of resin, rubber, dirt, etc. and clean with a suitable resin remover if necessary.
		Infeed and outfeed tables	Check the sliding ability of the tables and apply lubricant if necessary. A poor sliding surface affects the result.
Regularly		Moving parts	Clean moving parts regularly with penetrating oil and lubricate them with a light coat of medium-weight machine oil.
		Motor	Blow dust and dirt off the motor with low-pressure air (less than 3.5 bar).
		Screws, nuts, clamps	Regularly check all clamps, screws and nuts for tightness.
		Knives	Check knives for build-up and clean them if necessary.
		Gearbox	Use a nylon brush to remove dust from the belt pulleys.
After approx. 50 operating hours		Cutterhead	Check screws and knives on the cutterhead for tightness. Repeat the check regularly.

Lubricants and cleaning agents to be used

Use standard lubricants and cleaning agents.

NOTICE

Risk of fire dure to improperly stored cleaning rags!

Cleaning rags or polishing wool soaked in oils, greases, solvents and cleaning agents are flammable.

- Store oil-soaked cleaning rags separately in suitable closed metal containers.
- Dispose of oil-soaked cleaning rags and polishing wool separately and in accordance with applicable regulations.

8.1.1 Rotating the knives

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally when rotating the knives.

- Before rotating the knives, switch off the machine and disconnect it from the power supply.

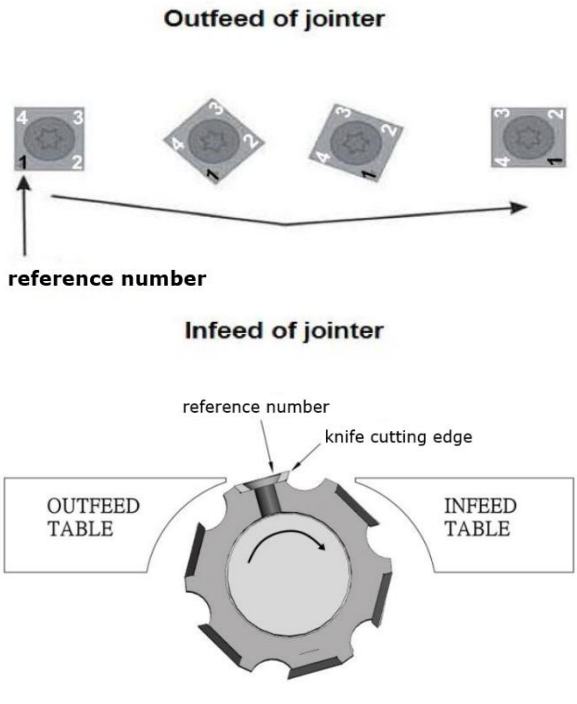
WARNING

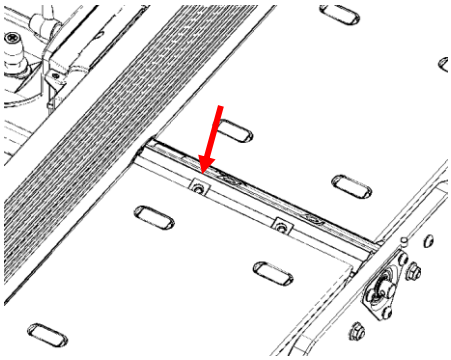
Danger of cutting!

The knives are very sharp. In case of contact, there is a danger of cuts.

- Watch hands and fingers.
- Never turn the cutterhead by hand.
- Wear heavy leather gloves when handling the cutterhead.

On the 203 mm long cutterhead, there are 16 four-sided carbide knives. If one of the cutting edges is damaged or blunt, the knife can be rotated 90° to use another cutting edge. The knives have numbers on the corners that help determine which cutting edges have already been used and which are still new. To rotate the knives, proceed as follows:



1. Blow dust and chips off the head of the star head screw that secures the knife.	
2. Remove the star head screw and the knife.	
3. Blow dirt and dust off the knife and of its seat with compressed air (wear respiratory protection).	
4. Remove wood residues from the cutterhead and the knife using mineral spirit or non-chlorinated brake cleaner.	
5. Rotate the knife so that a new, fresh cutting edge points outwards.	
6. Lubricate the star head screw threads with light machine oil.	
7. Wipe off any excess oil.	
8. Tighten the star head screw with approx. 5.5 Nm. The knife will align itself when tightened.	

8.1.2 Working on electrical system components

WARNING

Danger to life due to electric current!

When touching live parts, there is an immediate danger to life due to electric shock.

Damaged insulations or electrical components can be life-threatening.

- Have work on the electrical system components carried out only by qualified electricians.
- Before working on electrical system components, switch off the machine and pull the power plug. Do not leave the power plug unattended and secure it against being plugged in.
- In case of damaged insulations, switch off the machine immediately and have them repaired.

8.1.3 Use of recommended spare parts

WARNING

Risk of injury due to the use of unsuitable spare parts!

Original spare parts are available which are specifically designed for this machine. Spare parts from other manufacturers are often unsuitable. Using them can cause a risk of injury or damage the machine.

- Only use original spare parts. Ask a specialist dealer for information.

9 Troubleshooting

9.1 Troubleshooting

WARNING

Risk of injury due to unintentional start-up!

There is a risk of injury if the machine starts accidentally when performing certain troubleshooting activities, such as removing jams.

- If necessary, switch off the machine and disconnect it from the power supply.

WARNING

Danger of cutting!

The knives are very sharp. In case of contact, there is a risk of injury.

- Keep hands and fingers away from the knives.
- Be particularly careful when handling near the knives.
- Leave the bridge guard on the machine whenever possible.

The following list is intended to provide aid when troubleshooting. In case of problems, the dealer can help. Unusual and unexpected faults should be reported to him.

Fault	Possible cause	Possible remedy
Machine does not start	No current	Check the power plug, the power supply.
	Tripped fuse	Check the fuse and reset it if necessary. In case of doubt, contact a qualified electrician.
	Unsuitable voltage	Connect the machine according to the nameplate.
Fuse burn or circuit breaker is triggered	Machine overload	Reduce the load.
		Operate the machine on a circuit separate from other equipment or on a circuit with sufficient amperage.
	Short circuit in power cord or plug	Contact a qualified electrician. Have the power cord or plug repaired.

Fault	Possible cause	Possible remedy
Weak motor performance	Mains connection overloaded by lamps, devices and other motors	Reduce the load.
	Cables undersized or too long	Reduce the cable length or choose larger cables.
Motor overheated	Motor overloaded	Reduce the load, depth of cut.
	Restricted air circulation through motor	Clean the motor.
Motor dies or switches off during cut	Motor overloaded	Reduce the load, depth of cut.
	Short circuit in motor or loose or damaged cables	Contact a qualified electrician.
	Triggered circuit breaker	Reduce the number of machines on the same circuit. Contact a qualified electrician.
Cutterhead slows down when cutting or squeaks when switched on	Worn belt	Replace the belt.
	Blunt knives	Rotate or replace the knives.
Vibrations during operation	Loose or damaged knives	Tighten or replace the knives.
	Damaged belt	Replace the belt.
	Worn cutterhead bearings	Check/replace the cutterhead bearings.
Infeed table hard to adjust	Infeed table lock fully or partially locked	Completely release the infeed table lock.
Workpiece is stopped at the beginning of the cut	Outfeed table too high	Adjust the outfeed table to the cutterhead (see “Checking and adjusting the levelness and parallelism of the tables”).

Fault	Possible cause	Possible remedy
Tear outs, splinters on the workpiece	Knots or opposite grain direction in wood	Check the workpiece. Only process clean workpieces.
	Damaged knives	Rotate or replace the knives.
	Workpiece is fed too quickly	Feed the workpiece more slowly.
	Excessive depth of cut	Reduce the depth of cut (especially with hardwoods). Lightly moisten the workpiece before processing it.
Raised fibres after processing	Excessive moisture content of wood	Reduce the moisture content of the wood. Allow the wood to dry sufficiently before processing it.
	Blunt knives	Rotate or replace the knives.
Long lines that run along the length of the workpiece after processing	Damaged or blunt knives	Rotate or replace the knives.
Uneven cutter marks, wavy surface or chatter marks on the workpiece surface	Workpiece is fed too quickly	Feed the workpiece more slowly.
	Knives not at the same height	Clean the cutterhead and the knives.
Concave or convex workpiece edge	Uneven pressure on infeed and outfeed tables during cut	Apply even pressure on the workpiece during the cut.
	Workpiece excessively crooked or twisted	Cut the workpiece to length before processing it.
	Tables not level	Level the tables.
	Insufficient number of passes	Depending on the condition of the workpiece and on the depth of cut, 3-5 passes may be necessary until a good result is achieved.
Workpiece after processing on one edge thinner than on the other	Infeed table not parallel to cutterhead	Adjust the infeed table.
When edge jointing, no right angle to a flattened surface is achieved	Fence not correctly adjusted	Adjust the fence (see chapter "Settings on the machine").
	Fence not at right angles to both tables	Level the tables (see "Checking and adjusting the levelness and parallelism of the tables")

9.1.1 Checking and adjusting the levelness and parallelism of the tables

NOTICE

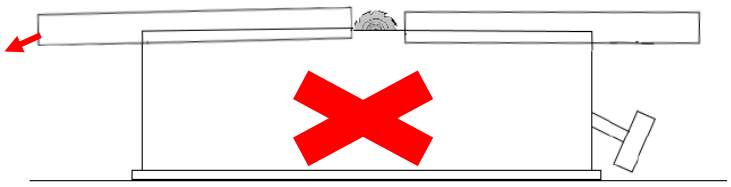
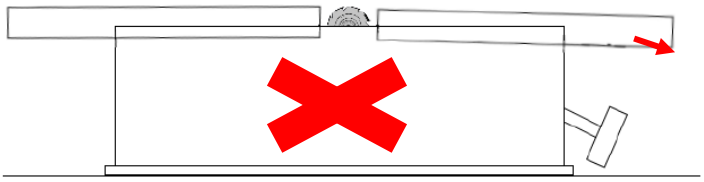
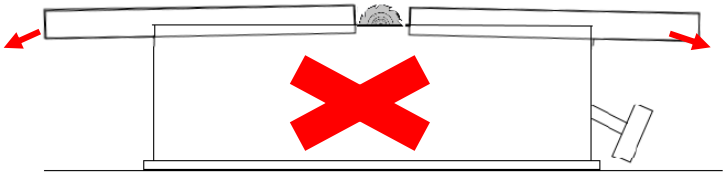
Unnecessary adjustments!

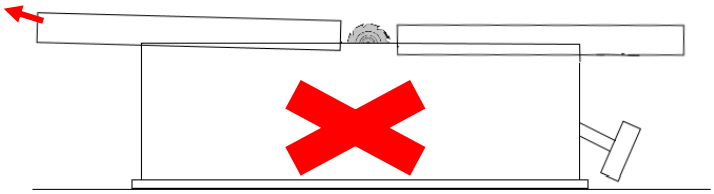
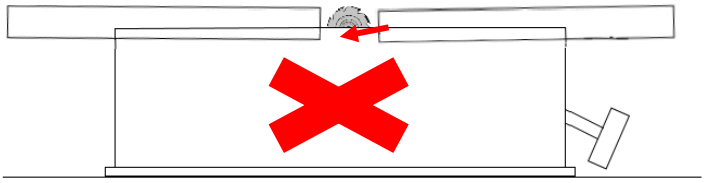
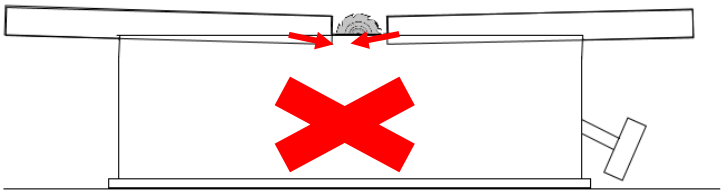
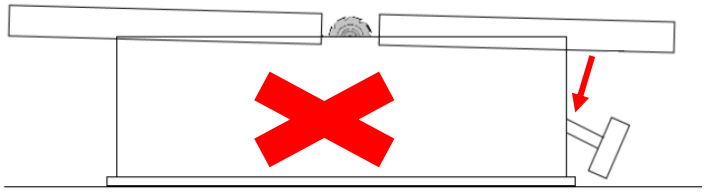
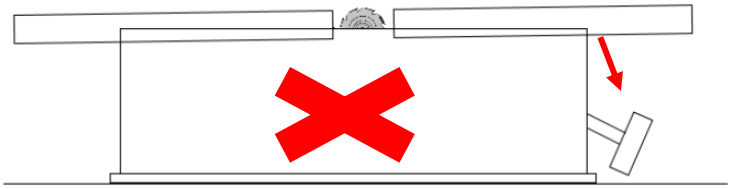
Adjusting the tables is a complex process. The tables are correctly adjusted at the factory. Unnecessary adjustments often do not lead to better results.

- Before adjusting the tables, make sure that the readjustment is really necessary.
- Before adjusting the tables, check other settings on the machine (e.g. fence).
- Before adjusting the tables, check the knives.
- Before adjusting the tables, rule out operating errors.
- Before adjusting the tables, process scrap pieces of wood to check that all other settings are correct.
- Before adjusting the tables, check the workpiece. If the wood is warped, crooked or twisted, consult videos or articles.
- Before adjusting the tables, set the 90° and 45° stops (see chapter "Setting the fence").
- Before adjusting the tables, observe the following texts and illustrations.

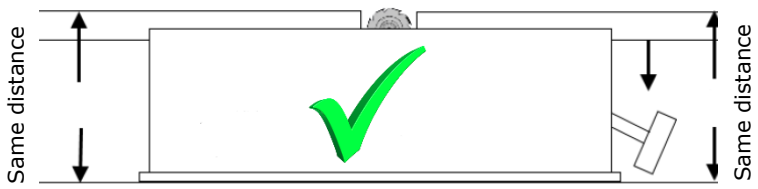
Incorrect table settings

Before adjusting the table, it is necessary to identify incorrect settings. The following illustrations serve as a guide:

Incorrect settings that cause inward-curved (concave) surfaces.	
▪ The outfeed table slants downwards away from the cutterhead.	
▪ The infeed table slants downwards away from the cutterhead.	
▪ Both tables slant downwards away from the cutterhead.	

Incorrect settings that cause outward-curved (convex) surfaces.	
▪ The outfeed table slants upwards away from the cutterhead.	
▪ The infeed table slants downwards towards the cutterhead.	
▪ Both tables slant downwards towards the cutterhead.	
Incorrect settings despite levelness	
▪ Level tables tilted down to the right. The infeed table drops at an angle.	
▪ Level tables tilted down to the left. The infeed table drops at an angle.	

Correct table setting

▪ The tables are level and parallel to the correctly aligned base. The infeed table does not drop at an angle. The tables are parallel to the base over their entire length. After planing, the surfaces are not concave or convex.	

Procedure for checking and adjusting the parallelism and levelness

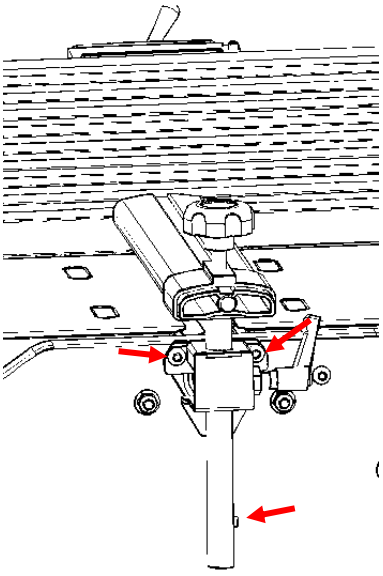
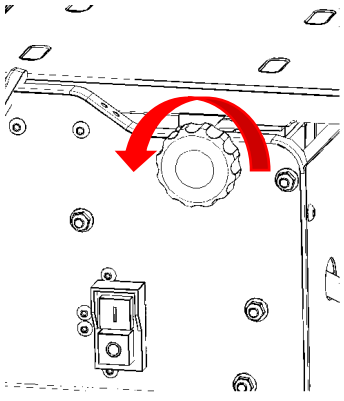
The infeed and outfeed tables are correctly adjusted at the factory. However, incorrect handling during transport can cause the tables to be misaligned and no longer level or parallel to the cutterhead. Incorrect settings affect the planing result. Use a metal ruler with a length of at least 590 mm to check.

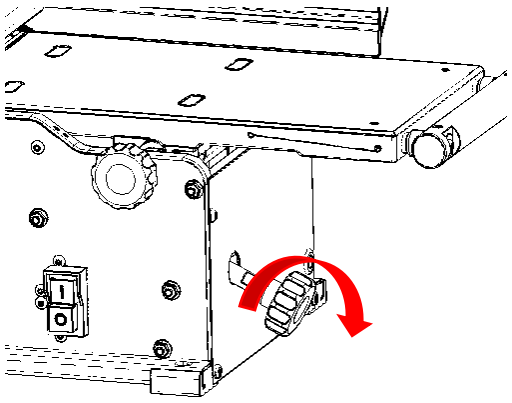
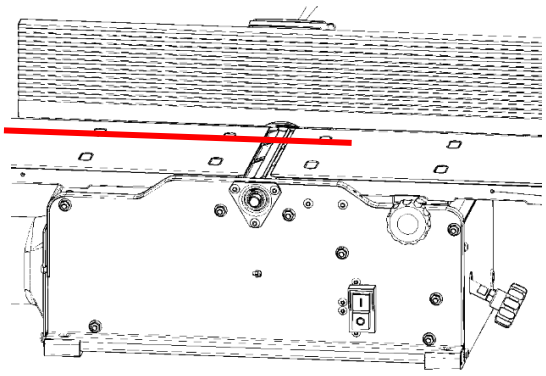
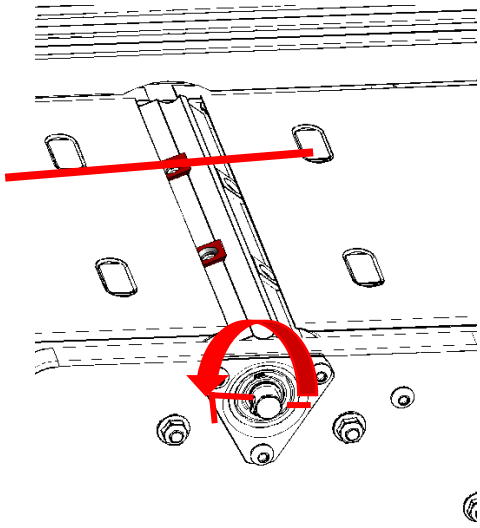
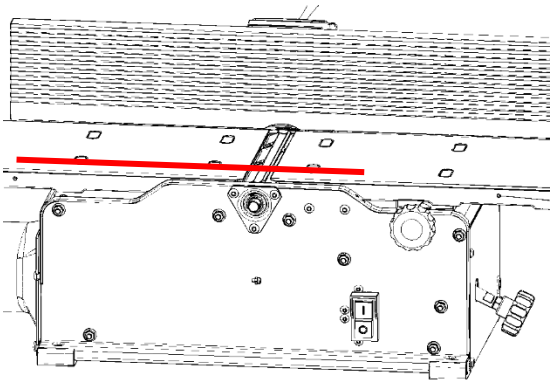
WARNING

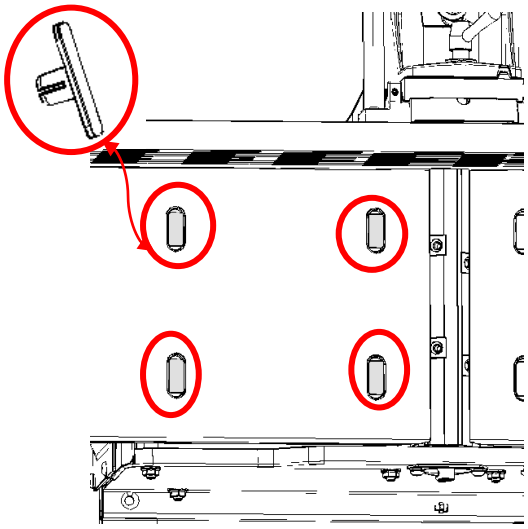
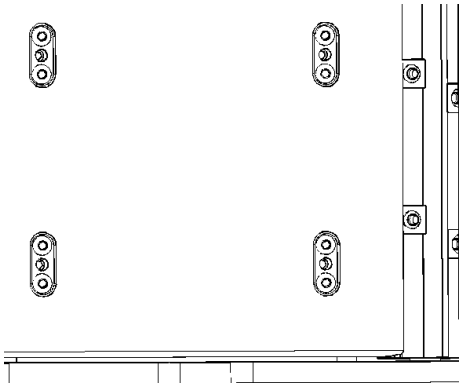
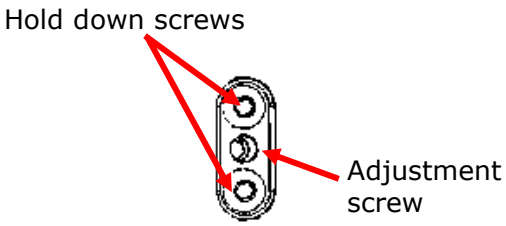
Danger of cutting!

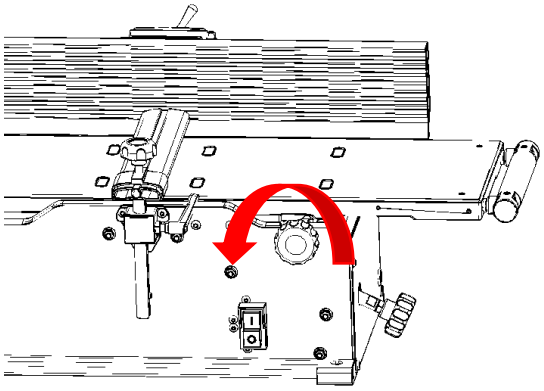
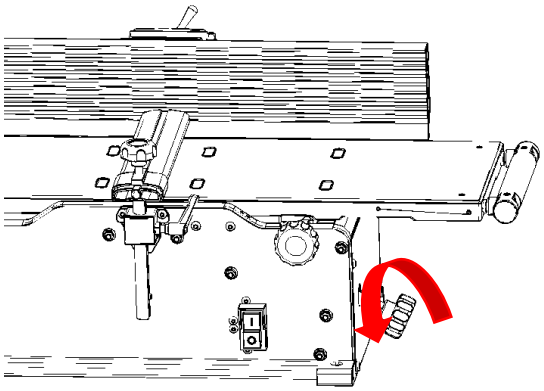
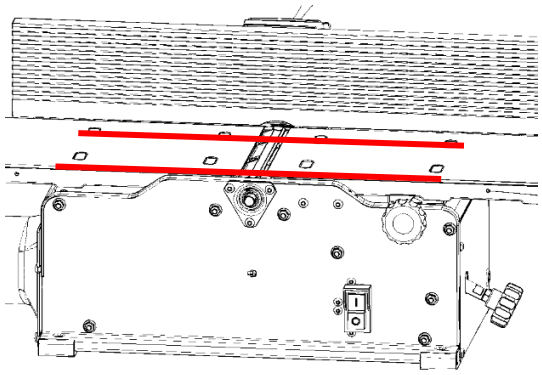
The knives are very sharp. In case of contact, there is a risk of injury.

- Keep hands and fingers away from the knives.
- Be particularly careful when handling near the knives.

1. Remove the two screws that hold the bridge guard holder and take off the bridge guard. If it is difficult to loosen the screws, remove the small screw at the end of the rod with a hex key and pull the rod out upwards.	
2. Release the infeed table lock by turning the knob anti-clockwise.	

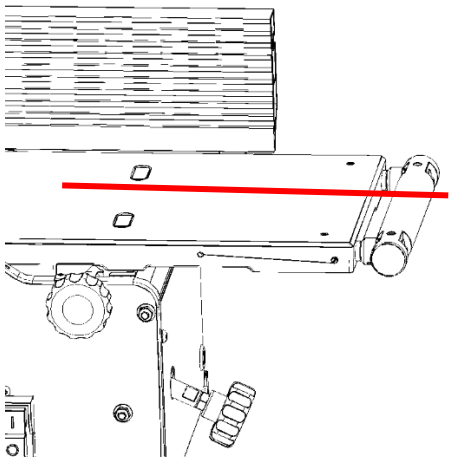
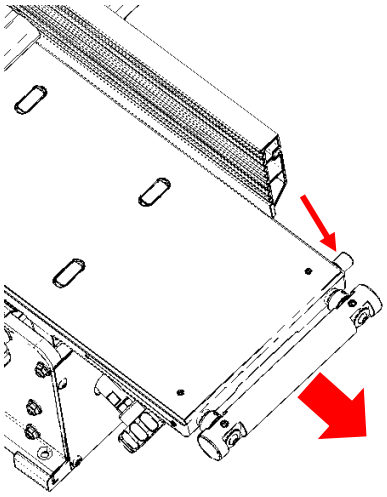
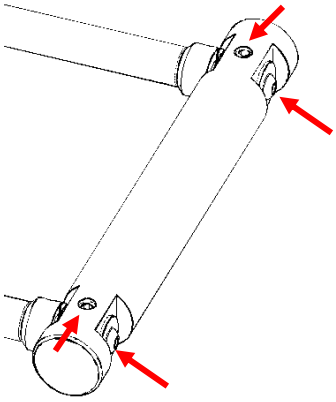
3. Lower the infeed table to the lowest position by turning the height adjustment knob clockwise.	
4. Place a metal ruler with a length of at least 590 mm near the fence onto the outfeed table and over the tip of the knife nearest the fence. Check for parallelism.	
5. Insert the supplied hex key into the hole at the outer end of the cutterhead. 6. Rotate the cutterhead anti-clockwise until the tip of the knife nearest the fence is at its apex. The metal ruler should lie flat on the outfeed table and the tip of the knife should just touch the metal ruler without lifting it or should be slightly lower than the metal ruler.	
7. Place the metal ruler on the front edge of the machine onto the outfeed table and over the tip of the knife nearest the front edge. 8. Check parallelism as described above. 9. If the outfeed table is parallel to the cutterhead, continue with the infeed table check (see point 19).	

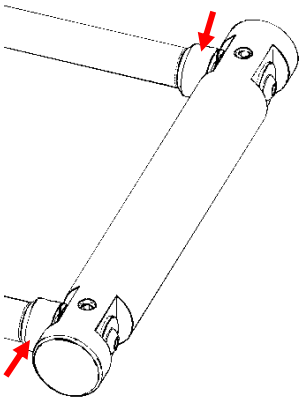
10. If the outfeed table is not parallel to the cutterhead (if the metal ruler is raised when rotating the cutterhead), the outfeed table needs to be adjusted:	
11. There are four covers on the table surface under which the adjustment and hold down screws are located. Identify the holes required for adjustment taking into account the instructions for the correct setting given at the beginning of the chapter.	
12. Remove the covers from these holes with your finger or an appropriate tool (e.g. flat-head screwdriver).	
13. Loosen the hold down screws in the corresponding hole with a hex key. 14. Adjust the adjustment screw in the middle with the star head T-bar key. Turn counterclockwise to raise the table. Turn clockwise to lower the table. **Notice!** One full turn equals 1 mm! Only slight changes should be made here!	
15. Once the table is adjusted properly, tighten the hold down screws. 16. Check the adjustment with the metal ruler. 17. If necessary, repeat the adjustment.	
18. Once the outfeed table is properly adjusted, reinsert the covers.	

19. Start adjusting the infeed table. **Notice!** Once you have started adjusting the infeed table, do not make any more adjustments on the outfeed table. 6. Loosen the infeed table lock until a part of the thread of the star knob screw is exposed.	
20. Raise the infeed table using the height adjustment knob until the threaded portion of the infeed table lock knob touches the top of the slotted hole. This sets the infeed table to zero depth of cut relative to the outfeed table. If the depth of cut indicator is not at zero, reposition the label after finishing the adjustments. If necessary, request a replacement label from your dealer.	
21. Place a metal ruler over both tables. Check at the back and the front of the machine whether the infeed table is level with the outfeed table.	
22. If the infeed table is not level with the outfeed table, adjust the infeed table in the same way as the outfeed table before (see point 11).	
23. Once the tables are level, check the fence stops and adjust them if necessary (see chapter “Setting the fence”).	

9.1.2 Adjusting the table extensions

The table extensions are correctly adjusted at the factory. However, it can happen that the table extensions become misaligned and are no longer level or parallel. In this case, proceed as follows:

1. Place a ruler onto the infeed table and over the right-hand table extension. 2. Check for parallelism. The ruler should lie flat on the infeed table and just touch the table extension or leave a small gap.	
3. Loosen the locking screw on the back. 4. Pull the table extension out approx. 127 mm. 5. Tighten the locking screw on the back.	
6. Loosen the screws and set screws with the supplied hex key.	

7. Rotate the eccentric collars behind the table extension to adjust the height accordingly. 8. Once the correct height has been achieved, tighten the set screws and screws. 9. Check for parallelism again. If necessary, repeat the adjustment. 10. Adjust the table extension on the outfeed table in the same way.	

9.2 Restoring normal operation

In the event of faults, switch off the machine, disconnect it from the power supply, eliminate the cause, plug the machine back in und press the ON switch.

10 Decommissioning and disposal

The following instructions for final decommissioning and disposal of the machine must be observed:

NOTICE

Danger to the environment due to incorrect disposal!

Incorrectly disposed of materials can damage the environment.

- When decommissioning the machine, adhere to the applicable laws and regulations for disposal.
- Do not dispose of the machine or parts of it together with domestic waste.
- Dispose of the parts of the machine in such a way as to prevent any harm to health or the environment.
- Check which materials can be recycled and recycle them properly.

NOTICE

Danger to the environment due to incorrect disposal!

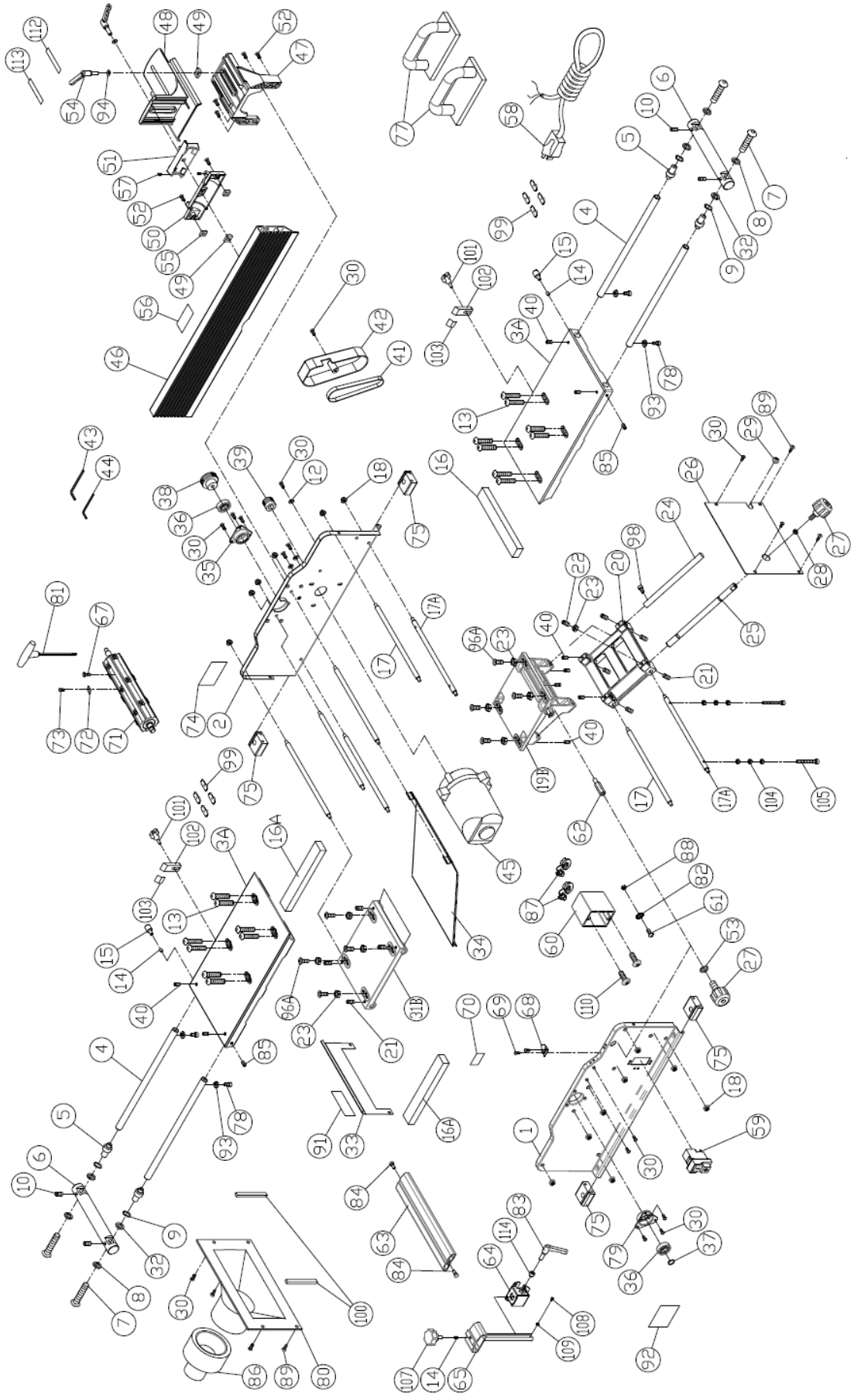
Oils, greases, solvents and cleaning agents are hazardous to the environment and must not be allowed to reach sewage or normal domestic waste. The same applies to cleaning rags or polishing wool soaked in oils, greases, solvents and cleaning agents.

- Dispose of oils, greases, solvents and cleaning agents as well as cleaning rags and polishing wool soaked in them at local recycling centres.

The defective machine can also be disposed of via the responsible dealer.

11 Annex

11.1 Exploded view

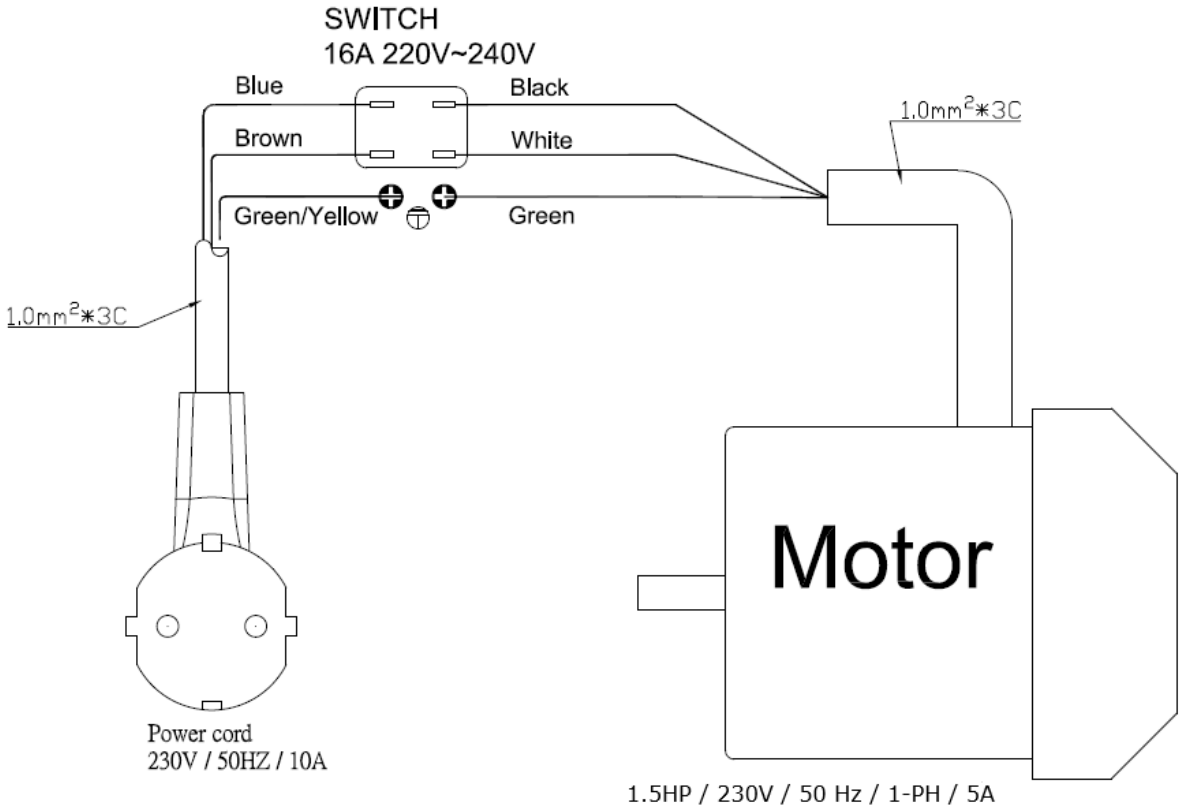


Ref.	Part no.	Designation	Spec.
1	EX-A200-1	1x front frame	
2	EX-A200-2	1x rear frame	
3A	EX-A200-3A	2x table	
4	EX-A200-4	4x shaft	
5	EX-A200-5	4x eccentric collar	
6	EX-A200-6	2x table extension	
7	EX-A200-7	4x round-head screw	M6x45
8	EX-A200-8	4x washer	M6
9	EX-A200-9	4x wave washer	WW14
10	EX-A200-10	4x set screw	M8x6
12	EX-A200-12	3x washer	M6
13	EX-A200-13	16x round-head screw	M6x30
14	EX-A200-14	3x PU block	
15	EX-A200-15	2x locking screw	¼"
16	EX-A200-16	1x foam seal	
16A	EX-A200-16A	2x foam seal	
17	EX-A200-17	6x tie rod	
17A	EX-A200-17A	2x tie rod	
18	EX-A200-18	16x hex flange nut	M6
19B	EX-A200-19B	1x infeed table support	
20	EX-A200-20	1x bracket	
21	EX-A200-21	9x set screw	M6x5
22	EX-A200-22	1x set screw	M6x12
23	EX-A200-23	9x nut	M6
24	EX-A200-24	1x shaft	
25	EX-A200-25	1x adjusting rod	
26	EX-A200-26	1x right cover	
27	EX-A200-27	2x star knob screw	M8x18
28	EX-A200-28	1x nut	M8
29	EX-A200-29	1x cable gland	
30	EX-A200-30	16x round-head screw	M6x10
31B	EX-A200-31B	1x outfeed table support	
32	EX-A200-32	4x washer	M14
33	EX-A200-33	1x left cover	
34	EX-A200-34	1x dust chute	
35	EX-A200-35	1x bearing retainer	

Ref.	Part no.	Designation	Spec.
36	EX-A200-36	2x bearing	6201
37	EX-A200-37	1x circlip	S-12
38	EX-A200-38	1x drive pulley	
39	EX-A200-39	1x motor pulley	
40	EX-A200-40	9x POM set screw	M6x6
41	EX-A200-41	1x belt	125J-5V
42	EX-A200-42	1x belt cover	
43	EX-A200-43	1x hex key	4 mm
44	EX-A200-44	1x hex key	2.5 mm
45	EX-A200-45	1x motor	
46	EX-A200-46	1x fence	
47	EX-A200-47	1x fence bracket	
48	EX-A200-48	1x fence slide	
49	EX-A200-49	2x special nut	M8
50	EX-A200-50	1x bevel bracket	
51	EX-A200-51	1x intermediate bracket	
52	EX-A200-52	6x round-head screw	M6x15
53	EX-A200-53	1x washer	M8-D18x2T
54	EX-A200-54	2x handle	M8x35
55	EX-A200-55	2x square nut	M6
56	EX-A200-56	1x warning label	
57	EX-A200-57	2x set screw	M5x10
58	EX-A200-58	1x power cord	
59	EX-A200-59	1x switch	
60	EX-A200-60	1x switch box	
61	EX-A200-61	2x round-head screw	#10-24 UNCx½"
62	EX-A200-62	1x position rod	
63	EX-A200-63	1x bridge guard	
64	EX-A200-64	1x bridge guard holder	
65	EX-A200-65	1x bracket	
67	EX-A200-67	4x flat head screw	M5x15
68	EX-A200-68	1x pointer	
69	EX-A200-69	2x round-head screw	M4x6
70	EX-A200-70	1x depth scale	
71	EX-A200-71	1x cutterhead	203 mm
71A	EX-A200-71A	5x pin	

Ref.	Part no.	Designation	Spec.
72	EX-A200-72	16x knife	
73	EX-A200-73	16x star head screw	M5x15
74	EX-A200-74	1x nameplate	
75	EX-A200-75	4x foot	
77	EX-A200-77	2x push block	
78	EX-A200-78	4x round-head screw	M6x6
79	EX-A200-79	1x bearing retainer	
80	EX-A200-80	1x dust collection port	
81	EX-A200-81	1x star head T-bar key	
82	EX-A200-82	2x tooth washer	M5
83	EX-A200-83	1x handle	5/16"x20
84	EX-A200-84	2x bumper block	
85	EX-A200-85	2x set screw	¼"-20UNC
86	EX-A200-86	1x dust collection adapter	
87	EX-A200-87	2x strain relief	SR-6P1
88	EX-A200-88	2x nut	#10-24
89	EX-A200-89	4x tap screw	¼"-20UNCx¾"
91	EX-A200-91	1x warning label	
92	EX-A200-92	1x logo	
93	EX-A200-93	4x spring washer	M6
94	EX-A200-94	2x washer	M8-D23x2T
96A	EX-A200-96A	8x set screw	M6x16
98	EX-A200-98	1x cap screw	M6x10
99	EX-A200-99	8x cover table	
100	EX-A200-100	2x foam	70x7x5
101	EX-A200-101	2x wing screw	M5x18
102	EX-A200-102	2x stop plate	
103	EX-A200-103	2x foam	
104	EX-A200-104	6x nut	M5
105	EX-A200-105	2x round-head screw	M5x65
107	EX-A200-107	1x star knob screw	
108	EX-A200-108	1x cap screw	M3x6
109	EX-A200-109	1x nut	M3
110	EX-A200-110	2x tap screw	M4x10
112	EX-A200-112	1x warning label	
113	EX-A200-113	1x warning label	
114	EX-A200-114	1x PU block	

11.3 Wiring diagram



11.4 EC Declaration of conformity

EC – Declaration of Conformity

For machines (according to EC-Directive 2006/42/EC)

CE

No. of Declaration of Conformity:	Neu-EX-244-902-EN
Distributor:	Neureiter Maschinen GmbH Gewerbegebiet Brennhoflehen Kellau 167 A – 5431 Kuchl
Responsible person for technical documentation:	Ludwig Neureiter Kellau 167 A – 5431 Kuchl
Object of the declaration:	Jointer
Product designation:	**EXMAC A200**
Technical name:	*AT-8*

The serial number, crucial technical information and marks of conformity can be found on the rating plate of each machine.
The distributor bears the sole responsibility for issuing this EC Declaration of Conformity.
The object of the declaration described above is in conformity with the relevant **Union harmonisation legislation**:

Machinery Directive 2006/42/EC

The following harmonised standards and technical specifications have been applied:

EN ISO 12100:2010	Safety of machinery – General principles for design – Risk assessment and risk reduction
EN 61029-1:2009/A11:2010	Safety of transportable motor-operated electric tools – Part 1: General requirements
EN 61029-2-3:2011	Safety of transportable motor-operated electric tools – Part 2-3: Particular requirements for planers and thicknessers

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Kuchl, 22 October 2024
Ludwig Neureiter (owner)

EX-A200-Neu-EX-244-902-EN


EXMAC