

Instruction manual

Planer-Thicknesser

ADH 200

ADH 200 AS

ADH 250

ADH 305



ADH 200



ADH 250



ADH 200 AS



ADH 305

ADH-SERIES

Imprint

Product identification

Planer-Thicknesser	Item No.
ADH 200	5905199
ADH 200 AS	5905200
ADH 250	5905250
ADH 305	5905305

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Information about the operating instructions

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Subject to technical changes and errors.

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1 Introduction

You have made an excellent choice in purchasing a HOLZSTAR Planer-Thicknesser.

Carefully read the operating instructions prior to commissioning.

They describe correct commissioning, intended use and safe as well as efficient operation and maintenance of the Planer-Thicknesser.

The operating instructions form part of the Planer-Thicknesser. Always keep them at the Planer-Thicknesser's location of use. Please also observe the local accident prevention regulations and general safety regulations for the use of the Planer-Thicknesser.

1.1 Copyright

The contents of these instructions are protected by copyright and are the sole property of Stürmer Maschinen GmbH. Their use is permitted within the framework of the use of the planer and thicknessing machine. Any other use is not permitted without the written consent of the manufacturer.

Passing on as well as duplication of this document, utilization and communication of its contents are forbidden, as far as not expressly permitted. Violations will result in liability for damages. We register trademark, patent and design rights to protect our products, insofar as this is possible in individual cases. We emphatically oppose any infringement of our intellectual property.

1.2 Customer service

Please contact your specialist retailer if you have any questions regarding your Planer-Thicknesser or require any technical information. Your specialist retailer will be happy to support you with specialist advice and information.

Germany:

Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt / Germany

Repair service:

Fax: 0951 96555-111
E-Mail: service@stuermer-maschinen.de
Internet: www.holzstar.de

Spare parts orders:

Fax: 0951 96555-119
E-Mail: ersatzteile@stuermer-maschinen.de

Please submit any information and experiences you make during application of the machine as these may be valuable for product improvements.

1.3 Disclaimer

All data in this operation manual has been compiled on the basis of the state-of-the-art, valid standards and guidelines as well as our many years of expertise and experience.

The manufacturer shall not be liable for damage in the following cases:

- Failure to comply with the operation manual,
- Unintended use
- Deployment of untrained staff
- Conversions at one's own responsibility
- Technical modifications
- Use of unauthorised spare parts

The actual scope of delivery may deviate from the descriptions and illustrations in this document as a result of special variants, optional extras or recent, technical modifications. The obligations defined in the supply contract shall apply in addition to the general terms and conditions and the manufacturer's general terms and conditions as well as the statutory regulations valid at the time of the conclusion of the contract.

2 Safety

This section provides an overview of all important safety packages for personal protection as well as safe and reliable operation. The individual sections contain additional, task-specific safety information.

2.1 Legend of symbols

Safety instructions

Safety instructions in this operation manual have been highlighted with symbols. Safety instructions are indicated by signal terms that express the degree of risk involved.



WARNING!

This combination of symbol and signal term indicates a potentially dangerous situation which may cause death or serious injury if not averted.



DANGER!

This combination of symbol and signal term indicates an immediate dangerous situation which may cause death or serious injury if not averted.



ATTENTION!

This combination of symbol and signal term indicates a potentially hazardous situation which may cause minor or light injuries if it is not averted.



IMPORTANT!

This combination of symbol and signal term indicates a potentially dangerous situation which may cause material damage or harm the environment if it is not averted.



NOTE!

This combination of symbol and signal term indicates a potentially dangerous situation which may cause material damage or harm the environment if it is not averted.

Tips and recommendations



Tips and recommendations

This symbol highlights useful tips and recommendations as well as information for efficient and reliable operation.

Observe the safety information in these operating instructions to minimise the risk of personal injury as well as material damage and prevent hazardous situations.

2.2 Operator responsibility

Operators are defined as the persons who operate the machine for commercial or profit-based purposes or provide the machine to third parties for use or application and bear the legal product responsibility in terms of the protection of users, staff or third parties during operation.

Obligations of the operator:

If the machine is used for commercial purposes, operators are subject to the legal stipulations in terms of occupational safety. For this reason, the safety instructions in these operating instructions as well as the safety, accident prevention and environmental protection regulations valid at the installation location must be complied with. In this process, the following shall apply in particular:

- Operators shall obtain information about valid occupational safety regulations and determine additional hazards as part of a risk assessment which result from the specific operating conditions at the machine's installation location. Said risk assessment shall be reflected in operating instructions for machine operation.
- During the entire machine operating time operators must check whether the operating instructions they created meet current standards and adapt the operating instructions where necessary.
- Operators shall clearly manage and specify the responsibilities for installation, operation, troubleshooting, maintenance and cleaning.
- Operators must make sure that all persons handling the machine have read and understood these operating instructions. Operators must also regularly train staff and notify of the hazards.
- Operators shall provide staff with the required protective equipment and wearing the required protective equipment shall be mandatory.

Operators shall also be responsible for maintaining the machine in a technically perfect condition. For this reason, the following shall apply:

- Operators shall make sure that the maintenance intervals described in these operating instructions are complied with.
- Operators shall regularly check that the safety equipment is fully functional and complete.

2.3 Operating staff qualification

The different tasks described in these operating instructions require different levels of skills in terms of the qualifications of operating staff working with the machine.



WARNING!

Risk from inadequately qualified persons!

Inadequately qualified persons are unable to assess the risks when handling the machine, thus putting themselves and others at risk of severe injuries.

- All work must be carried out by qualified persons only.
- Keep inadequately qualified persons and children away from the work area.

Exclusively persons of whom it can be expected that they reliably complete assigned tasks shall be authorised to carry out any tasks. Persons whose reactions have been impaired shall not be authorized, e.g. drug users, users under the influence of alcohol or medication.

These operating instructions specify the following personal qualifications for the different tasks:

Operating staff:

Operating staff has undergone an induction by the operator about the entrusted tasks and potential hazards resulting from improper behaviour. Tasks which go beyond normal operation may only be carried out by the operator if they are listed in the operation manual and the operator has made him/herself familiar with them.

Qualified electrician:

Due to the electrician's specialised training, know-how, experience and knowledge of pertinent standards and regulations the electrician is in a position to work on the electrical systems, and autonomously identify and avoid potential hazards.

Specialist staff:

As a result of specialist training, expertise, experience and skills in terms of the relevant standards and regulations, specialist staff is able to complete the tasks they are entrusted with and independently identify hazards and avert risks.


Manufacturer:


Certain work must be carried out by manufacturer specialist staff only. Other staff is not permitted to carry out this work. Contact our customer service to have the work carried out.

2.4 Personal protective equipment


Personal protective equipment is intended to protect the health and safety of persons at work. Staff must wear the personal protective equipment indicated in individual sections of these operating instructions when carrying out the different tasks on the machine.


The personal protective equipment is described in the following section:

 **Hearing protection**
Hearing protection helps to protect the hearing from harmful noise and other loud sounds.

 **Eye protection**
Protective glasses protect the eyes against projected parts and splashes of liquid.

 **Protective gloves**
Protective gloves protect the hands from components with sharp objects as well as friction, abrasion, and deep-cut injuries.

 **Safety boots**
The safety boots protect the feet against crushes, falling parts and slipping over on slippery underground.

 **Protective clothing**
Protective work clothing means tight-fitting clothing with low tear resistance.

2.5 Safety data sheets

Safety data sheets on hazardous materials can be obtained from your specialist dealer or by calling +49 (0)951/96555-0. Specialist dealers can find safety data sheets in the download area of the partner portal.

2.6 Safety labels on the Planer-Thickener

The following safety labels and instructions are attached to the Planer-Thickener s (Fig. 1) and must be observed.



Fig. 1: Safety labels

If safety labels on the machine are damaged or missing, this can cause errors, personal injury and material damage. The safety symbols attached to the machine must not be removed. Damaged safety symbols must be replaced immediately.

As soon as the signs are not clearly visible and comprehensible at first glance, the machine must be stopped until new signs have been attached.

2.7 General safety measures

- The surface and thickness planer may only be operated and maintained by persons who have read and understood these operating instructions. The operator must be sufficiently trained in application, setting and operation.
- Do not switch on the machine until immediately before starting machining. Do not leave the machine, which is ready for operation, unattended.
- Never open the protective covers while the planer is in operation.
- Keep the workplace and the floor in the vicinity of the surface planer and thicknessing machine free of any objects that could endanger your stability or pose a tripping hazard. Keep the workplace tidy. Disorder can result in accidents.
- Check the danger zone before and during work to ensure that no unauthorized persons are present.
- Protect the machine from moisture and humidity to avoid electrical hazards.
- Do not use the machine in the vicinity of flammable gases, liquids and solids. There is a risk of explosion or fire due to possible flying sparks.
- Only use the machine in dry rooms or in a dry environment and ensure that the working area is sufficiently illuminated.
- Ensure that an extraction hose is connected to the extraction system and the machine before starting it up.
- Operate the machine only with safety devices fully and correctly attached and do not modify anything on the machine.
- Always wear ear protection when working with the planer and thicknesser. Wearing loose clothing (ties, scarves, open jackets and clothing that is not tight-fitting) is prohibited. A hair net must be worn for long hair.
- Use only original spare parts.
- To protect against electric shock, have the machine connected to a suitable and fused power connection only by a qualified electrician.
- Protect the power supply cable from heat, oil and sharp edges.

2.8 Machine-specific safety measures

- Before operation, inspect all workpieces for foreign objects, e.g. nails and screws.
- Use suitable supports, e.g. roller blocks (optional equipment), when handling heavy or bulky workpieces.
- Use a sliding block or sliding block when planing small workpieces.
- Use additional supports such as a horizontal clamping device when planing narrow workpieces.
- Always adjust the jointer/thicknesser guard to the workpiece width. The unused part of the cutter-block must be covered.

- Do not use planing knives that are cracked or have changed shape.
- Wear gloves when changing the planing knives.
- Replace a damaged power cord immediately.
- When routing the power cord, make sure that it is not crushed, bent, or wet.
- Before switching on, check that all repair and adjustment tools have been removed.
- Before any maintenance and repair, the surface planer and thicknessing machine must be secured against start-up.
- All guards and safety devices must be reinstalled immediately after repair or maintenance is completed.

2.9 Safety devices

Non-return device

The anti-kickback device prevents a workpiece from kicking back against the operator while the cutter is rotating.

Safety switch chip exhaust hood

The chip extraction hood safety switch is located under the dressing table. As long as the switch is not in contact with the dressing table, the switch prevents the motor from starting.

Bridge protection of the planer shaft

The bridge guard is used to cover the planer shaft during dressing. When storing the machine, the planing shaft must be completely covered by the bridge guard.



Fig. 2: Bridge protection of the planer shaft

Motor circuit breaker

The engine is equipped with thermal protection to protect against overload. After the thermal protection has been triggered, several minutes must be waited before the machine can be put back into operation. To reset the thermal protection, press the switch Figure 3.

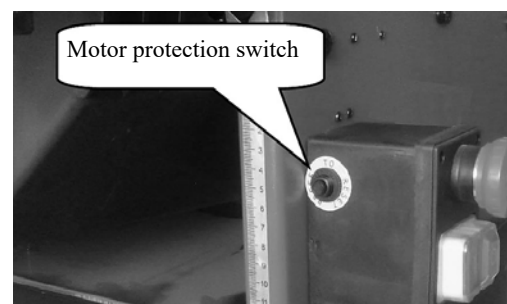


Fig. 3: Motor protection switch

3 Intended use

The Planer-Thicknesser is used for planing and thickening of boards and strips of wood and is designed and built for use in non-hazardous environments. Processing of solid wood, chipboard, panels and profiles is possible.

For work in enclosed spaces, an exhaust system must be used that complies with legal requirements.

The Planer-Thicknesser may only be operated within the specified power limits (Technical data).

3.1 Reasonably foreseeable misuse

- Simultaneous dressing or thickness planing of several workpieces.
- Machining of workpieces that are too large or too heavy or that are not fixed or not fixed enough.
- Machining of unacceptable materials such as metals or plastics.
- Installation of spare parts and use of accessories not approved by the manufacturer.
- Maintenance work on an unsecured machine.

The planer and thicknesser has not been designed for commercial, craft or industrial use.

If the surface planer and thicknessing machine is used in any way other than that described above (under 3 Intended use), it is no longer intended for its intended use.

No liability is assumed for damage due to improper use.

Stürmer Maschinen GmbH accepts no liability for constructive and technical modifications to the Planer-Thicknesser.

Claims of any kind for damage due to improper use are excluded.

3.2 Residual risks

When used as intended, residual risks may arise even if the relevant safety regulations are observed.

- Hearing damage during prolonged work on the machine with defective hearing protection
- Fire hazard
- Danger from electric current
- Danger from wood dust
- Danger to the upper limbs in case of contact with the planing shaft

4 Technical Data

Model	ADH 200	ADH 200 AS
Length	790 mm	790 mm
Width / Depth	470 mm	470 mm
Height	450 mm	465 mm
Weight	23 kg	29 kg
Supply voltage	230 V	230 V
Dressing table length	737 mm	737 mm
Dressing table width	210 mm	210 mm
Chip removal max. dressing	2 mm	2 mm
Thickness table length	255 mm	255 mm
Thickness table width	204 mm	204 mm
Working height thickness min.	5 mm	5 mm
Working height thickness max.	120 mm	120 mm
Chip removal max. thickness	2 mm	
Feed rate	7 m/min	7 m/min
Planer shaft diameter	50 mm	50 mm
Number of planing knives	2	2
Planing shaft speed	8000 min ⁻¹	8500 min ⁻¹
Planing width max.	204 mm	204 mm
Suction nozzle diameter thickness	63 mm	58 mm
Suction nozzle diameter dressing	63 mm	
Sound pressure level Lp	82 dB	
Sound power level Lw	93 dB	

Model	ADH 250	ADH 305
Length	1105 mm	1135 mm
Width / Depth	550 mm	600 mm
Height	570 mm	570 mm
Weight	40 kg	42 kg
Supply voltage	230 V	230 V

Model	ADH 250	ADH 305
Dressing table length	1050 mm	1075 mm
Dressing table width	260 mm	310 mm
Chip removal max. dressing	2 mm	2 mm
Thickness table length	450 mm	500 mm
Thickness table width	254 mm	305 mm
Working height thickness min.	6 mm	6 mm
Working height thickness max.	160 mm	160 mm
Feed rate	7 m/min	7 m/min
Planer shaft diameter	50 mm	50 mm
Number of planing knives	2	2
Planing shaft speed	8500 min ⁻¹	9500 min ⁻¹
Planing width max.	254 mm	305 mm
Suction nozzle diameter thickness	80 mm	100 mm
Absorbed power	1,5 kW	1,8 kW

4.1 Type plate

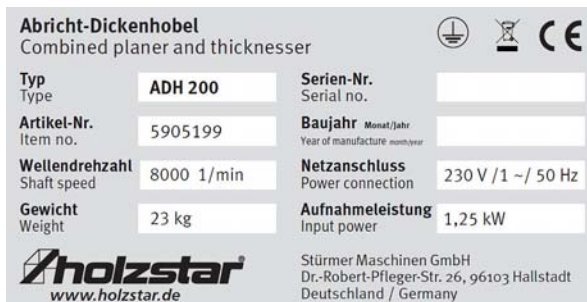


Fig. 4: Type plate ADH 200

5 Transport, packaging, storage

5.1 Delivery and transport

Delivery

Check the Planer-Thicknesser for visible transport damage upon delivery. In case of visible damage to the Planer-Thicknesser, immediately notify the carrier or your retailer.

Transport

Improper transport is accident-prone and can cause damage or malfunctions for which we do not grant any liability or guarantee.

Transport the scope of delivery secured against shifting or tilting with a sufficiently dimensioned industrial truck to the installation site.



WARNING!

Severe or fatal injuries may occur if parts of the machine tumble or fall down from the forklift truck, pallet truck or from the transport vehicle. Follow the instructions and information on the transport box.

Note the total weight of the machine. The weight of the machine is indicated in the "Technical data" of the machine. When the machine is unpacked, the weight of the machine can also be read on the rating plate. Only use transport devices and load suspension gear that can hold the total weight of the machine.



WARNING!

The use of unstable lifting and load suspension equipment that might break under load can cause severe injuries or even death. Check that the lifting and load suspension gear has sufficient load-bearing capacity and that it is in perfect condition.

Observe the accident prevention regulations issued by your Employers Liability Insurance Association or other competent supervisory authority, responsible for your company.

Fasten the loads properly.

General risks during internal transport



WARNING: DANGER OF TIPPING

The device may be lifted unsecured by a maximum of 2cm.

Employees must be outside the danger zone, the reach of loads.

Warn employees and, if necessary, advise employees of the hazard.

Devices may only be transported by authorized and qualified persons. Act responsibly during transport and always consider the consequences. Refrain from daring and risky actions.

Gradients and descents (e.g. driveways, ramps and the like) are particularly dangerous. If such passages are unavoidable, special caution is required.

Before starting the transport check the transport route for possible danger points, unevenness and disturbances as well as for sufficient strength and load capacity.

Danger points, unevenness and disturbance points must be inspected before transport. The removal of danger spots, disturbances and unevenness at the time of transport by other employees leads to considerable dangers.

Careful planning of internal transport is therefore essential.

5.2 Packaging

All used packaging materials and packaging aids of the Planer-Thicknesser are recyclable and generally need to be transported to the material recycling. Crush the packaging material made of cardboard and supply it to the waste paper collection. The films are made of polyethylene (PE) and the upholstery parts are made of polystyrene (PS). These materials have to be delivered to a recycling station of the responsible dumping company.

5.3 Storage

The Planer-Thicknesser must be stored thoroughly cleaned in a dry, clean and frost-free environment. Cover the machine with a protective tarpaulin. Environment temperature range: -25 °C to +55 °C.

6 Description of the device

Illustrations in these operating instructions may differ from the original.

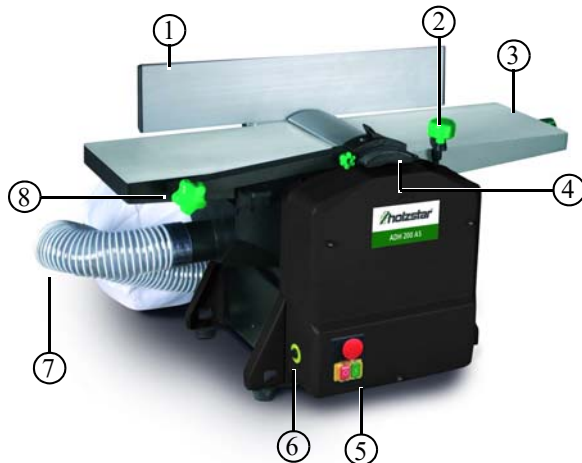


Fig. 5: Planer-Thicknesser ADH 200 AS

- 1 Stop
- 2 Height adjustment thickness planer
- 3 Dressing table
- 4 Blade shaft cover
- 5 ON / OFF switch with emergency stop button
- 6 Motor protection switch
- 7 Suction hose
- 8 Height adjustment splitter shaft cover

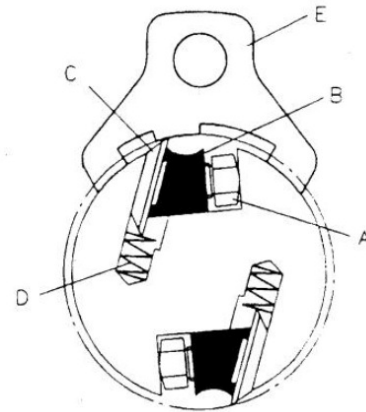


Fig. 6: Planer knife

- A Screw
- B Clamping segment
- C Planer
- D Spring
- E Bearing

6.1 Scope of delivery

6.1.1 ADH 200

- Handle
- Hexagon wrench
- 2 x hexagon socket screw
- Stop
- Sliding stick
- Intake nozzle
- Operating instructions

6.1.2 ADH 200 AS

- Reversible chip extraction hood
- Integrated suction
- Chip collection bag
- Infinitely adjustable aluminum dressing fence from 0° to 45°
- Operating instructions

6.1.3 ADH 305

- integrated storage compartment
- 2 HSS planing knives
- Operating instructions

6.2 Accessories

ADH 200 and ADH 200 AS

- Reducing socket, not flanged Ø 100 mm wide, 80 mm narrow

Item number: 5142421

- Reducing socket, not flanged Ø 100 mm wide, 60 mm narrow

Item number: 5142427

- Strip planer knife, 210 x 22 x 1,8 mm HSS (2 pieces)

Item number: 5915200

ADH 250 und ADH 305

- Reducing socket, not flanged Ø 100 mm wide, 80 mm narrow

Item number: 5142421

- Reducing socket, not flanged Ø 100 mm wide, 60 mm narrow

Item number: 5142427

- Strip planer blade ADH 250, 258 x 22 x 2 mm HSS (2 pieces)

Item number: 5915250

- Strip planer blade ADH 305, 308 x 22 x 1.8 mm HSS (2 pieces)

Item number: 5915300

7 Installation and erection

7.1 Requirements for the place of installation

The Planer-Thicknesser must be stably erected on a level and solid ground. There must be enough space for the operating personnel, for the transport of material as well as for adjusting and maintenance. The place of installation should meet the following criteria:

- Make sure that the floor has sufficient load bearing capacity and is level.
- The background must not let any lubricant through.
- The Planer-Thicknesser must only be installed and operated in a dry, frost-free and well-ventilated place.
- Avoid places nearby machines generating chips or dust.
- Provide sufficient space for the staff preparing and operating the machine and transporting the material. Also consider that the machine is accessible for setting and maintenance works.
- Provide for sufficient illumination (Minimum value: 300 lux)
- There must be a extraction device with min. 690 m³/h extraction capacity, min. 20 m/s flow rate at the hood connection; Hose diameter see Technical Data, max. hose length 4 m.

7.2 Installation of the Planer-Thicknesser



CAUTION!

Observe the weight of the machine! The machine may only be set up by two persons together. Check the auxiliary equipment for sufficient dimensioning and load-bearing capacity.



DANGER!

To ensure sufficient stability of the machine, it should be screwed to the base. For this purpose, there are 4 holes at the bottom of the machine housing.

The planer and thicknesser is delivered in a carton and is already mostly assembled. Only a few parts need to be assembled after delivery.

Assemble the machine with the following steps:

Assembly ADH 200

Step 1: Unpack the machine and check that the scope of delivery is complete.

Step 2: Insert hexagon socket head screws into the hole (A) of the workpiece stop.

Step 3: Place the workpiece stop on the machine and screw the screws (A) into the holes of the machine (B) and tighten.

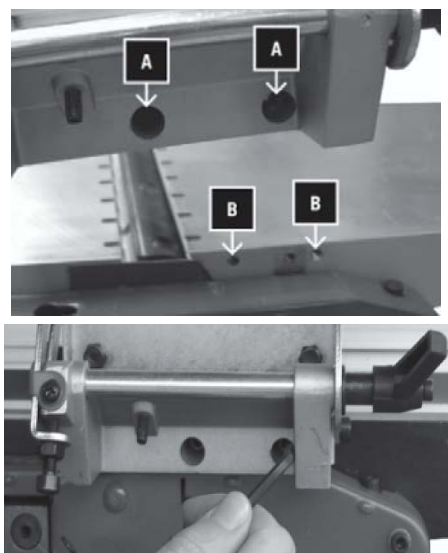


Fig. 7: Mount workpiece stop

Step 4: Install the rotary handle for height adjustment.

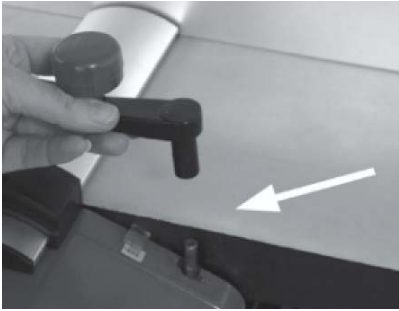


Abb. 8: Rotary handle height adjustment

Step 5: Lift the splitter shaft guard (A, Fig.9) to the uppermost position.

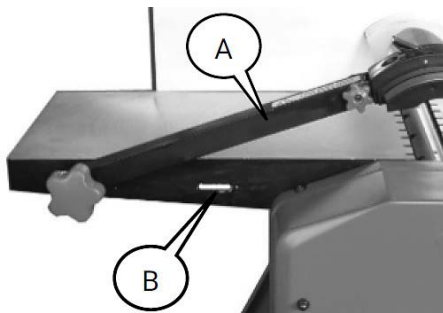


Fig. 9: Raise splitter shaft guard

Step 6: Unfold the holders (C, Fig.10) of the suction hood.

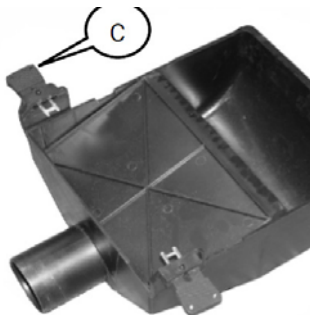


Fig. 10: Unfolding the brackets

Step 7: Move the thickening table to the lowest position.

Step 8: Mount the suction hood (C, Fig.10) in the grooves (B, Fig.9) below the machine.



Fig. 11: Mount suction hood

Step 9: Fasten the suction hose to the suction connection on the machine housing using a hose clamp.

Step 10: Fasten the other end of the suction hose to the suction connection of the suction unit using a hose clamp.

Installation on a workbench

The planer and thicknesser can also be permanently mounted on a workbench. The following sketches show the hole spacing of the feet of the planer and thicknesser.

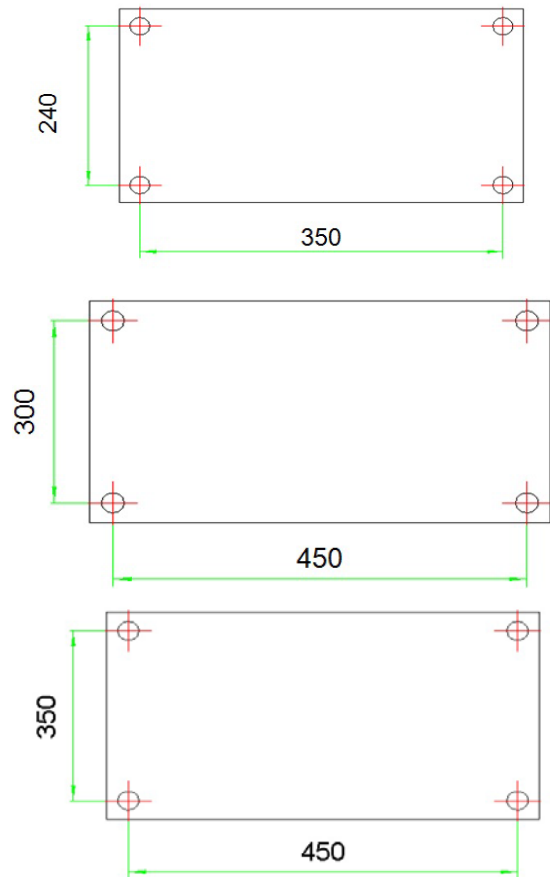


Fig. 12: Hole separation ADH 200 & 200 AS / ADH 250 / ADH 305

7.3 Electrical connection



DANGER!

Lebensgefahr durch Stromschlag!

There is a danger to life in case of contact with live components. Switched-on electrical components can perform uncontrolled movements and lead to serious injuries. All work on the electrical installation may only be carried out by a qualified electrician.

The machine is equipped with a power cord that must be connected to a proper power outlet.

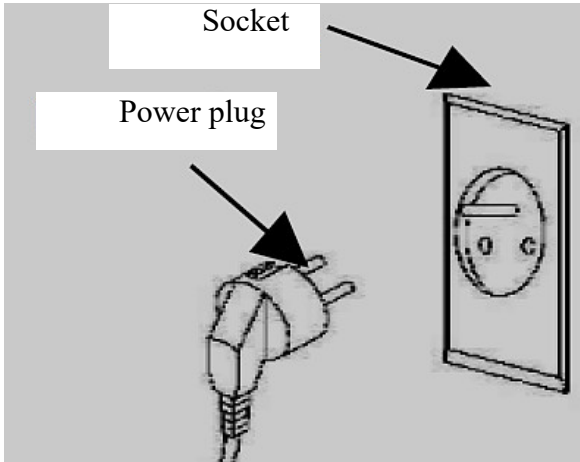


Fig. 13: Power supply cable

Grounding instructions

To protect the operator from electric shock, the machine must be grounded during operation.

In the event of a malfunction, grounding provides a path of least resistance for the electric current and reduces the risk of electric shock. The machine is equipped with an electrical cord with a grounding conductor and a grounding plug. The plug **MUST** be plugged into an appropriate outlet that is properly installed and grounded in accordance with ALL local codes and ordinances.

8 Adjustments

8.1 Adjusting the cutter cover

The height of the splitter shaft cover is adjusted using the rotary handle (E) located on the left side of the machine.

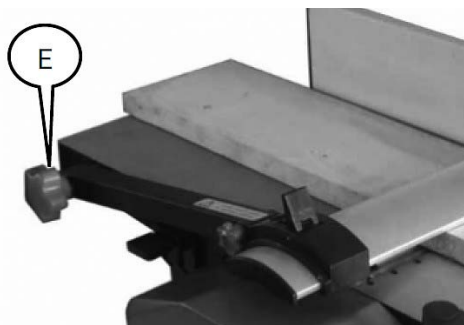


Fig. 14: Height adjustment of the splitter shaft cover

After releasing the locking handle (F), the cutter cover can be pushed aside and adjusted to the correct width of the workpiece to be machined.

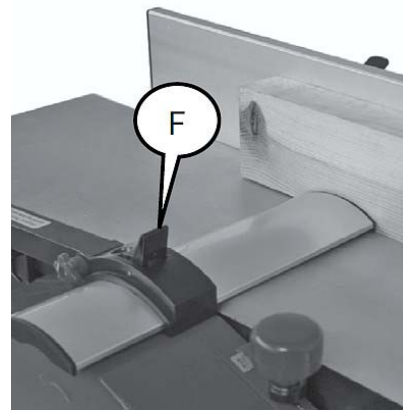


Fig. 15: Move splitter shaft cover

8.2 Set workpiece stop

Loosen the locking lever (H) to adjust the angle of the workpiece stop. Tighten the locking lever again before operation.

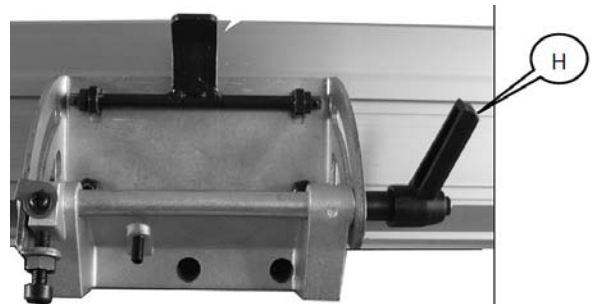


Fig. 16: Set workpiece stop

8.3 Chip removal Dressing table adjust

Turn the rotary handle (J) to the left or right to increase or decrease the chip removal.

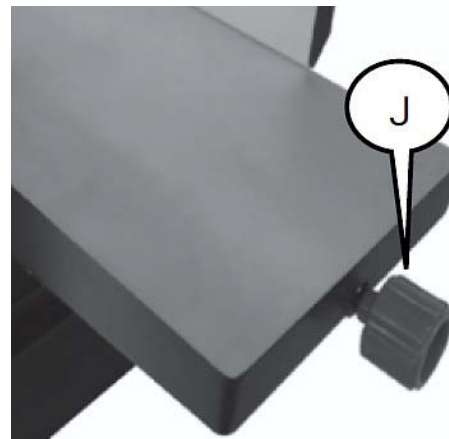


Fig. 17: Adjusting the clamping removal of the dressing table

9 Operation of the planner-Thicknesser



DANGER!

The mains plug must be disconnected before carrying out any adjustment work on the machine.



WARNING!

Danger to life!

There is danger to the life of the operator and other persons if they do not observe the following rules.

- The Planer-Thicknesser may only be operated by an instructed and experienced person. other persons must keep away from the working area during operation.
- The operator must not work when under the influence of alcohol, drugs or medication.
- The operator must not work if he is overtired or suffers from diseases that impair concentration.
- There is a risk of injury to the upper limbs when working on the machine improperly.
- Before commissioning, check the electrical connection, lines and contacts.



Wear hearing protection!



Wear protective goggles!



Wear safety shoes!



Wear protective work clothing!

9.1 Planing

In a planing can be reached out a depth up to 2 mm. This depth may be reached only by:

- Sharp planers
- Soft woods
- Maximum workpiece width

If these characteristics are not observed, there is a risk of overloading. Therefore: Edit a workpiece always in repeat worksteps, until the desired material thickness is reached. The planing of workpiece with the machine make as follow:

Step 1: Assemble the chip extraction hood under at the machine table. On the chip extraction hood be find two plug connectors, which after positioning must be pressed in the direction of the machine table. For positioning these two plugs must pulled outside.



NOTE!

The bracket (Fig. 18, yellow arrow) on the chip extraction hood activated a safety switch on the machine. The machine can not be started if this safety switch is not activated!



Fig. 18: Installation of the chip extraction hood

Step 2: Set the angle fence on the desired height with handle assembly at spindle with reference to scale. The angle fence can be released and clamped via a clamp lever screw. A scale is attached with the angle.



Fig. 19: Adjustment of the angle fence

Step 3: Set the desired planing depth by you adjusting lever on desired depth on the scale.

Step 4: Adjust the cover so that the knife shaft is covered.

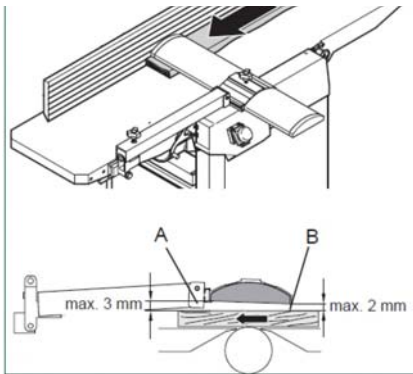


Fig. 20: Adjustment of the knife shaft cover

Step 5: Power the machine on with the green ON switch.

Step 6: Press the workpiece with one hand against the Infeed table and angle fence. After that move the workpiece with the other hand constant..

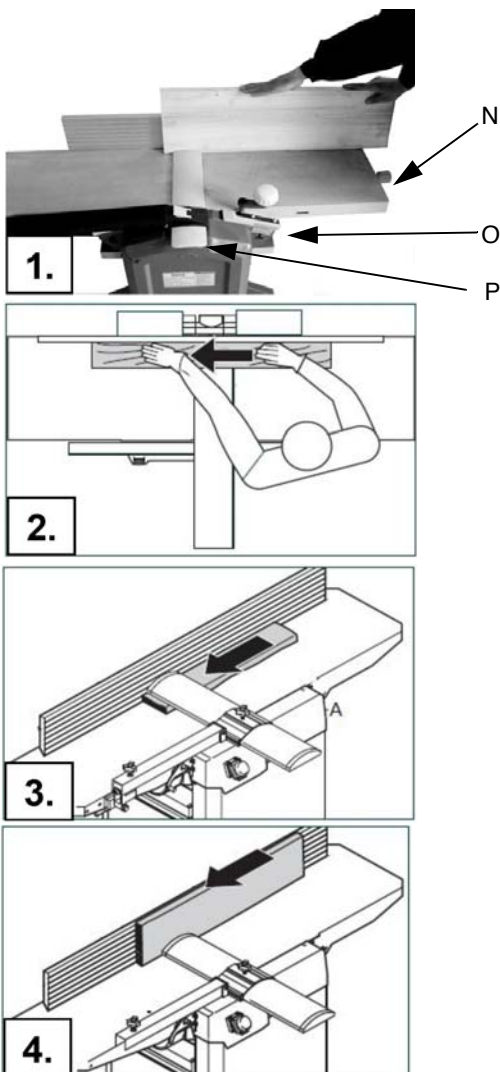


Fig. 21: Adjustment of the material guide on the planer

Step 7: After completion of the work cycle, switch off the machine with the red STOP button.

9.2 Thicknessing

Step 1: Make sure that the machine is switched off and disconnected from the power supply.

Step 2: Disassemble the side fence and tilt the knife shaft cover to the rightmost position

Step 3: Raise the knife shaft cover [Pos. P, Fig. 11] to the highest position

Step 4: Disassemble you the dust extraction hose. Then open the bracket [Pos. Q, Fig. 11] on the chip extraction hood and disassembey this. Place the chip extraction hood on the table and assembly again brackets. Make sure to the correct lock. Brackets to serve also as limit switch.



NOTE!

The bracket (Fig. 22, yellow arrow) on the chip extraction hood activated a safety switch on the machine. The machine can not be started if this safety switch is not activated!



Fig. 22: Assembly of dust extraction hood

Step 5: Assemble the extraction hose again.

Step 6: Adjust the table height using the handwheel and the scale. Remember: The current workpiece height minus Desired chip removal is the end height.

Step 7: Power the machine on with the green ON switch.

Step 8: Place the workpiece with the working area upwards

Step 9: If the workpiece not moved by automatic workpiece feed pull the workpiece manual out.

Step 10: After completion of the work cycle, switch off the machine with the red STOP button.

Step 11: During a further working action, must be maintained wait until the planer blade stands still.

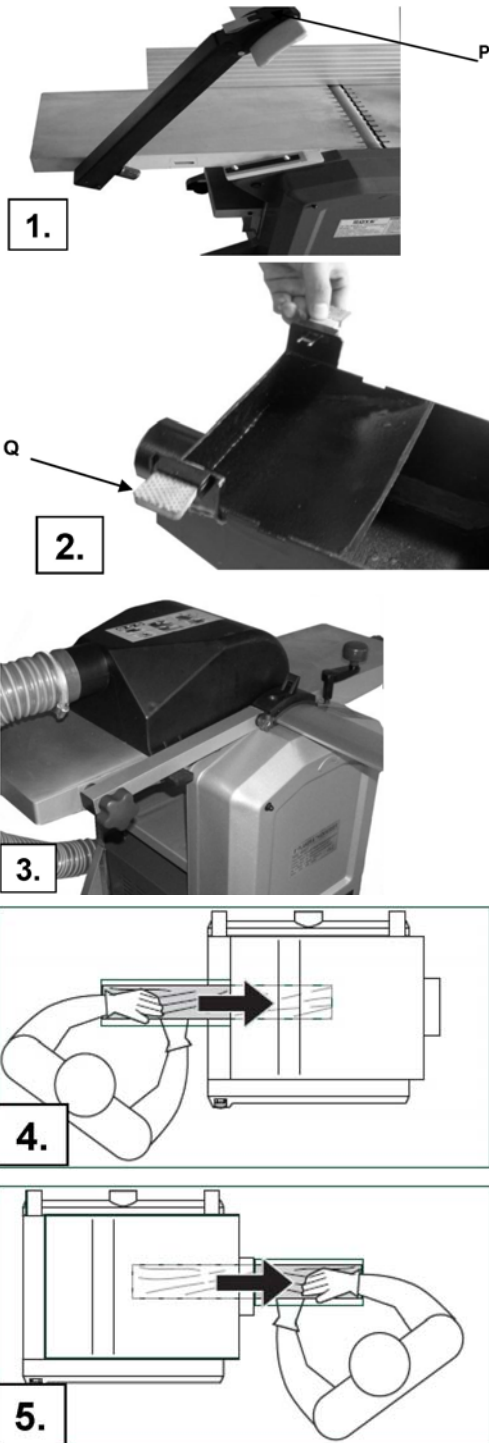


Fig. 23: Adjustment of the material guide on the Thicknesser

9.3 Adjustment of the planer knives



NOTE!

Disconnect the Planer-Thicknesser from power before servicing!



NOTE!

The setting gauge is not included in the delivery and must be ordered separately.

With the help of the setting gauge, the planing knives can be mounted with the correct projection.

Step 1: Disconnect the Planer-Thicknesser from power.

Step 2: Move the table height to zero and place the adjust gauge on the table.

Step 3: Place the adjust gauge with the both surfaces A on the table. The surface B must be stood directly above the knife. A little loosen the screw on the cutter block.

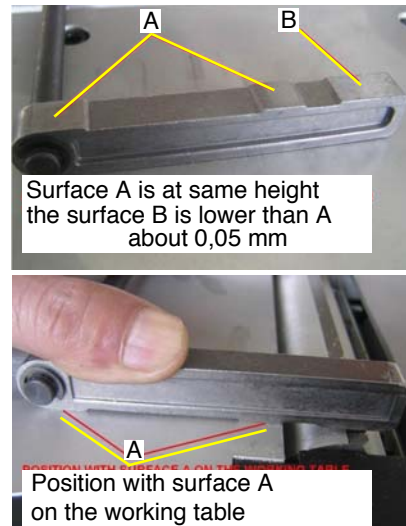


Fig. 24: Adjustment of the cutter block on the surface B

Step 4: Turn the planer shaft and place the knife to the height of the surface B. Tighten the screws of the planer again. Check the height by rotating the planer shaft again. The knife should touch lightly the surface B. Repeat steps 2 & 3, if that is not the case.

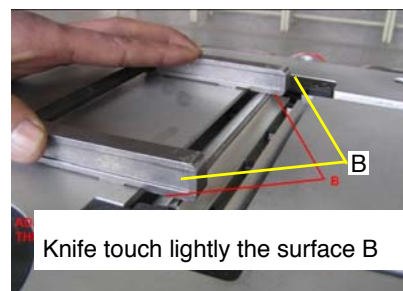


Fig. 25: Adjustment of the cutter block on the surface B

9.4 Workflow



DANGER!

Before starting work, make sure, that the cutter block cover and the chip extraction hood are mounted. The cutter block must sharp and set correctly.

- Step 1: Make adjustments to the machine for the thickening operation and connect the extraction device.
- Step 2: Plug the power supply in the socket.
- Step 3: Switch on the extraction device.
- Step 4: Power the machine on with the green ON switch
- Step 5: Place the workpiece and execute the thickening operation
- Step 6: After completion of the work cycle, switch off the machine with the red STOP button and pull out power supply. Put out the extraction device.

10 Care, maintenance and repair



DANGER!

- Before starting cleaning and maintenance work, switch off the machine and disconnect the power plug.
- Connections and repairs may only be carried out by qualified personnel.

Daily care and maintenance

- Clean the machine after each use.
- Replace damaged safety devices immediately.

Weekly care and maintenance

- Clean the housing and machine surfaces.
- Clean guards, air slots and motor housing.
- Check the planing knives for damage and replace them if necessary.

Monthly maintenance

- Check the fastening screws of the machine and tighten them if necessary.
- Check electrical safety devices and guards and replace if necessary.

10.1 Care after working

Cleaning instructions for the planer and thicknesser planer

- Clean the machine from chips and wood dust with compressed air (Attention: Wear protective goggles and dust mask (particle filter - filter class 2)!) and/or with a dry cloth.
- Clean motor and switch with a dry cloth. Never use water!
- Clean housing and machine surfaces only with a damp cloth and some cleaning agent. Do not use solvents. These could attack the plastic parts of the machine. Make sure that no water can get into the interior of the machine.
- Spray or oil all unpainted metal surfaces with a little anti-rust spray.
- Keep guards, air vents and motor housings as free of dust and dirt as possible. Rub them with a clean cloth or blow out dust and dirt with compressed air at low pressure.
- Caution: Wear protective goggles when working with compressed air!
- Empty and clean the suction device.

10.2 Maintenance and repair

The following maintenance and repair work may only be performed by qualified personnel.

- Check appropriate tension of drive belt
- Switches and safety devices Check planer knives for wear or damage.
- Check planer blade for wear or damage.
- Every 3 months, monthly if used daily, check drive belt, replace if worn or damaged.

If the Planner-Thicknesser does not function properly, contact a specialist dealer or our customer service. The contact details can be found in chapter 1.2 Customer service.

All protective and safety devices must be refitted immediately after repair and maintenance work has been completed.

10.2.1 Functional check

The Planer-Thicknesser is delivered ready for use. Before each use, a functional check should be carried out.

Step 1: The driving belt must be tension.

Step 2: The planer knife must rotate free and must not clamp.

Step 3: Check the connecting cable for damage.

10.2.2 Extraction device

Check daily the extraction device on the sufficient function. If the extraction device does not work or is restricted, it must be restored. Only then can the Planer-Thicknesser be put into operation.

10.2.3 Lubrication

Regularly lubricate the bearings, especially the bearing of the infeed and outfeed roller and pulley(after 10 hours of operation), and all the guides of the machine. Oil the threaded rods and shafts.

10.2.4 Change of the drive belt

The drive belt must not come into contact with oil or grease. It must be checked regularly for wear, cracks or brittleness. Replace the drive belt if necessary, at least once a year.

Proceed as follows to replace and adjust the drive belt:

Step 1: Switch off the machine and disconnect the power plug.

Step 2: Set the cutter head cover to the uppermost position.

Step 3: Loosen screws and remove cover.

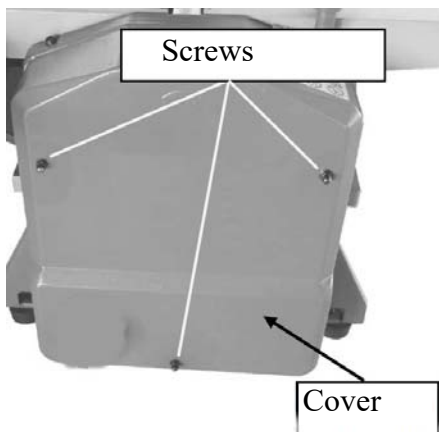


Fig. 26: Disassemble cover

Step 4: Remove the drive belt from the shaft.

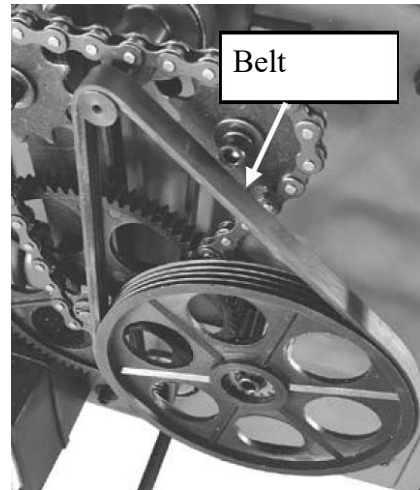


Fig. 27: Remove the belt from the drive shaft

Step 5: Disconnect the motor drive belt from the planer shaft pulley and motor.

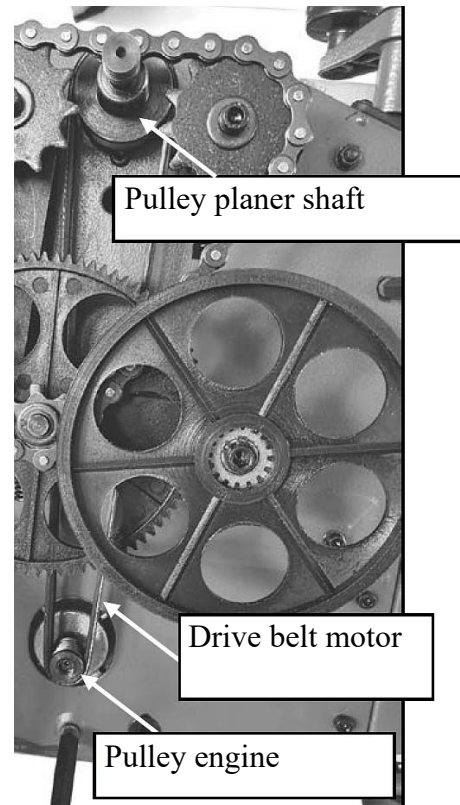


Fig. 28: Loosen drive belt motor

Step 6: Loosen the four motor mounting screws to loosen the position of the motor up and down.

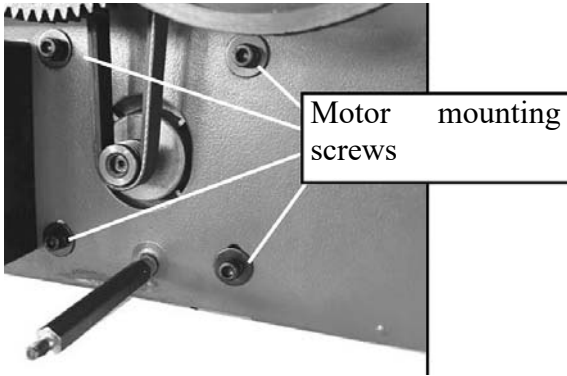


Fig. 29: Motor mounting screws

Step 7: Lift the feed roller on the left and remove the motor drive belt.

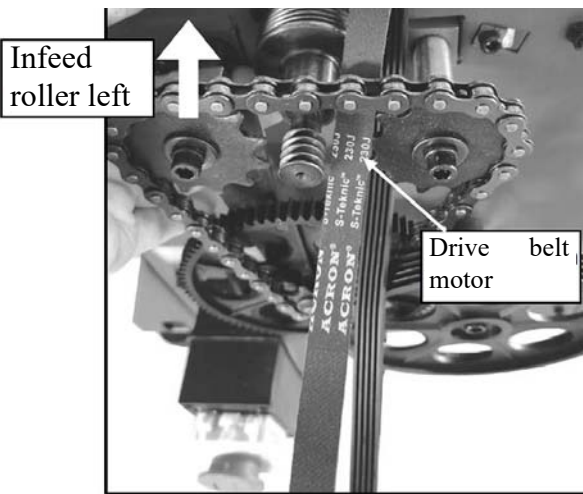


Fig. 30: Remove drive belt motor

Step 8: Hook the new drive belt over the motor pulley and then over the planer shaft pulley.

Step 9: Tighten the motor fastening screws (Fig.31) again.

Step 10: Check the belt tension and, if necessary, adjust the tension using the motor fixing screws.

Step 11: Refit the shaft drive belt.

Step 12: Refit the cover.

10.2.5 Replacing the planing knives



Wear protective gloves!

Regularly check the blades of the planing knives, as most of the problems in planing occur because of too blunt knives.

Proceed as follows to replace and adjust the planing knives:

Step 1: Switch off the machine and disconnect the power plug.

Step 2: Remove the cutter cover.

Step 3: Loosen the workpiece stop and push it to the rear.

Step 4: Move the thickness planing table to the lowest position by turning the handwheel.

Step 5: Loosen and remove screws (Pos.A, Fig.31).

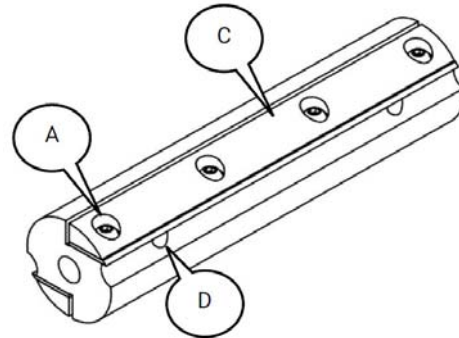


Fig. 31: Loosen and remove screws

Step 6: Remove the planing knife (Pos.B, Fig.32) and knife holder (Pos.C, Fig.32).

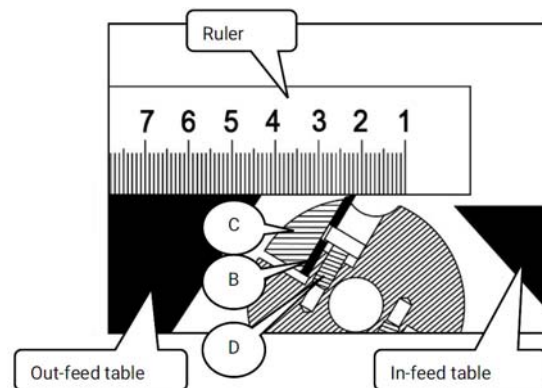


Fig. 32: Remove the planing knife

Step 7: Clean the cutter holder and cutter head.

Step 8: Insert the new planing knife and fix it with the screws (pos.D, fig.32).

Step 9: Place the knife holder (Pos.C, fig.32) on the new planing knife.

Step 10: Slightly tighten the screws (Pos.A,fig.32).

Step 11: Adjust the planing knife according to chapter 8.3.

Step 12: Tighten screws (Pos.A,fig.31) after successful adjustment.

Step 13: Repeat the sequence of steps 5 to 12 for the other planing knives.

11 Troubleshooting

Fault	Possible cause	Remedy
Engine does not start	Power supply is ON/OFF Switch is defective. Protective switch is ON	Check the power connection by expert staff. Cool the motor, then restart
The motor is running, but planer knife does not turn.	The driving is torn	Replace the drive belt.
Motor is hot	1. Motor protection defective 2. Motor is overloaded 3. Blunt planer knife	1. Remove the power plug from the socket and check/repair the machine by expert staff. 2. Cool the motor. 3. Replace or sharpen the planer knife.
The motor dies, the workpiece is burned when planing	1. Blunt planer knife 2. The tool is deformed.	1. Replace or sharpen the planer knife. 2. Replace the tool.
Handwheels are difficult to move.	1. Dirt or chips in the machine deposit and block the hand wheel.	1. Clean the machine and lubricate the bearing.

12 Disposal, recycling of used devices

For environmental benefits it is necessary to ensure that all components of the machine are only disposed of by the provided and allowed means.

12.1 Decommissioning

Immediately decommission used machines in order to avoid later misuse and endangering of the environment or of persons.

Step 1: Dispose of all environmentally hazardous operating materials of the used device.

Step 2: If required, disassemble the machine into easy-to-handle and usable components and parts.

Step 3: Supply the machine components and operating materials to the provided disposal routes.

12.2 Disposal of electrical devices

Electrical devices include numerous recyclable materials as well as environmentally hazardous components.

These components must be disposed of separately and professionally. In case of doubt, please contact your municipal waste management company.

For the recycling process, please request the assistance of a specialized waste disposal centre if required.

12.3 Disposal of lubricants

The manufacturer of the lubricant makes the disposal instructions for the used lubricants available. If applicable, ask for the product-specific data sheets.

12.4 Disposal via municipal collection points

Disposal of used electrical and electronic equipment (Applicable in the countries of the European Union and other European countries with a separate collection system for these appliances).



The symbol on the product or its packaging indicates that this product should not be treated as normal household waste, but must be returned to a collection point for the recycling of electrical and electronic equipment. By helping to properly dispose of this product, you are protecting the environment and the health of others. Environment and health are endangered by improper disposal. Material recycling helps to reduce the consumption of raw materials. For more information about recycling this product, contact your local community, municipal waste management, or the shop where you purchased the product.

13 Spare parts



DANGER!

Danger of injury by the use of wrong spare parts!

Dangers may result for the user and damages as well as malfunctions may be caused by using wrong or damaged spare parts.

- Only use original spare parts of the manufacturer or spare parts admitted by the manufacturer.
- Always contact the manufacturer in case of uncertainties.



Loss of warranty

The manufacturer's warranty will become null and void if non admitted spare parts are being used.

13.1 Order of spare parts

The spare parts may be purchased with the authorised dealer.

Indicate the following basic information for spare part orders:

- Type of device
- Serial number
- Position number
- Quantity
- Year of manufacture
- Required mode of dispatch (mail, freight, sea, air, express)
- Address of dispatch

Spare part orders which do not include the above indications may not be taken into consideration. If the indications regarding the mode of dispatch are missing, the product is dispatched at the discretion of the supplier.

You will find indications regarding the device type, article number and year of manufacturing on the type plate which is fixed on the machine.

Example

The engine for the Planer-Thicknesser ADH 200 AS must be ordered. The engine has the number 92 in the spare parts drawing 1.

By ordering spare parts, send a copy of the spare parts drawing (1) with the marked part (engine) and marked position number (92) to the dealer or spare parts department and provide the following information:

- Device type: **Planer-Thicknesser ADH 200 AS**
- Item number: **5905200**
- Drawing number: **1**
- Position number: **92**

13.2 Spare parts drawings

The following drawings are intended to help in case of service, to identify necessary spare parts. To order send a copy of the parts drawing with marked components to your dealer.

13.2.1 Spare parts drawing ADH 200

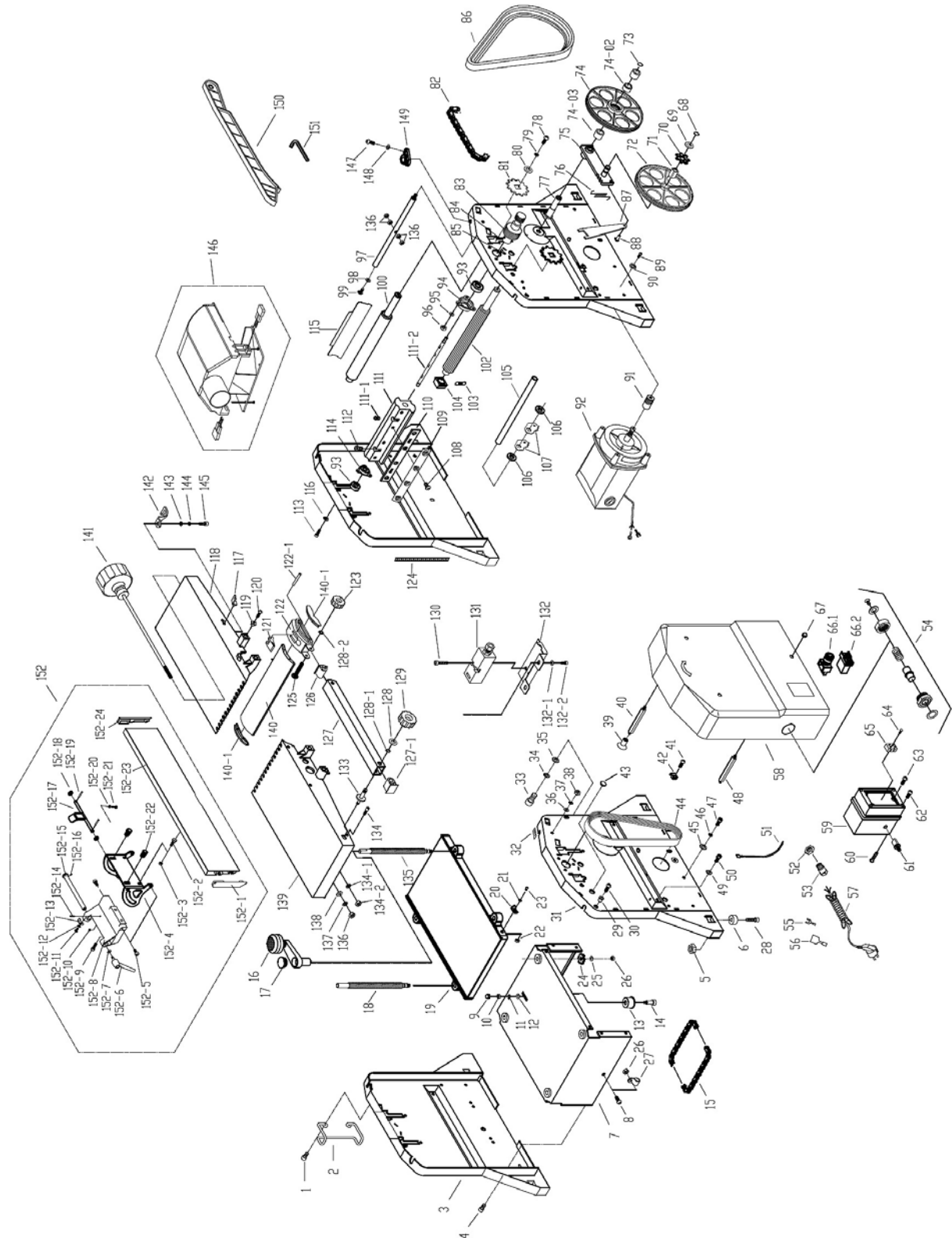


Fig. 33: Spare parts drawing ADH 200

13.2.2 Spare parts drawing ADH 200 AS

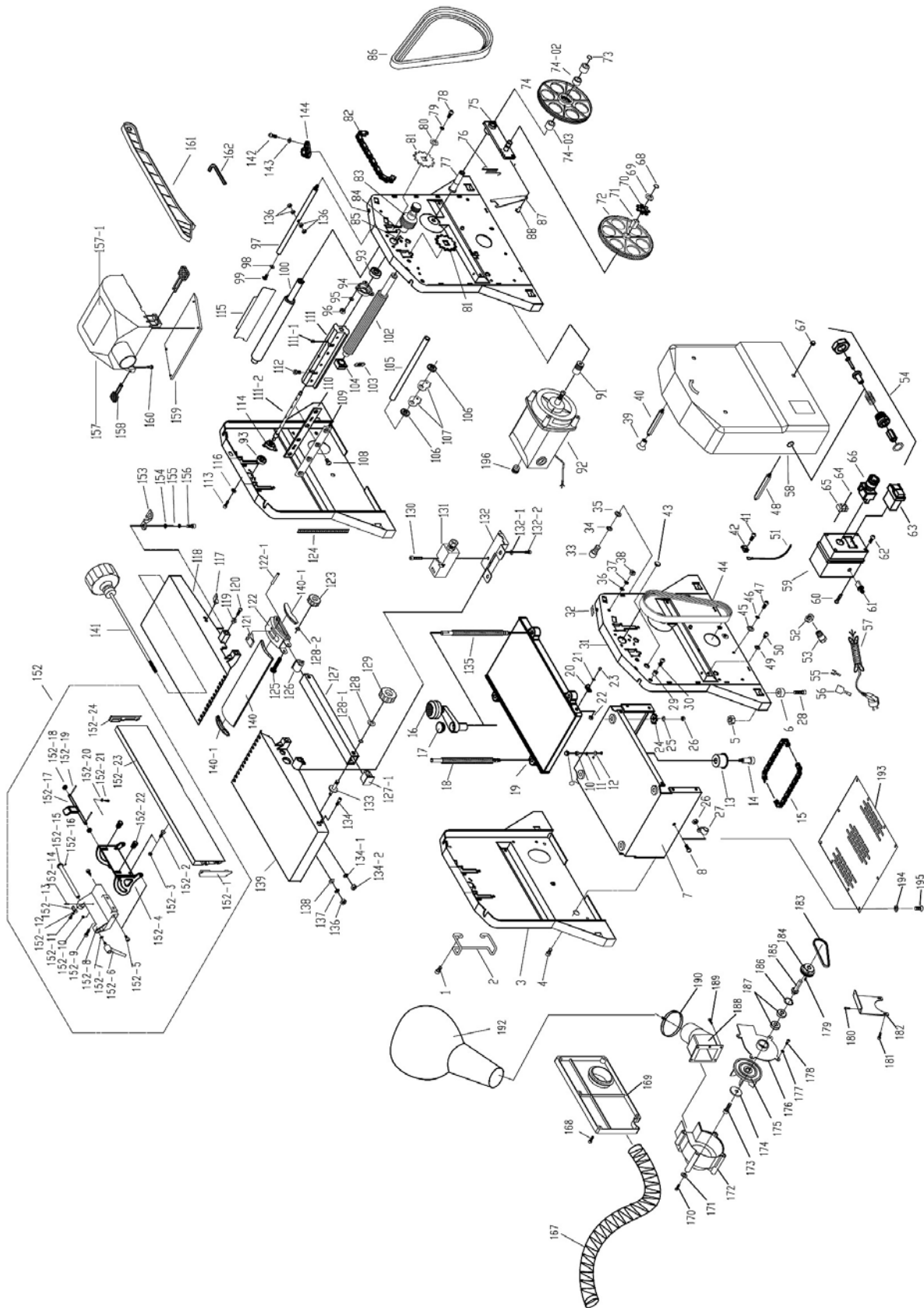


Fig. 34: Spare parts drawing ADH 200 AS

13.2.3 Spare parts drawing ADH 250

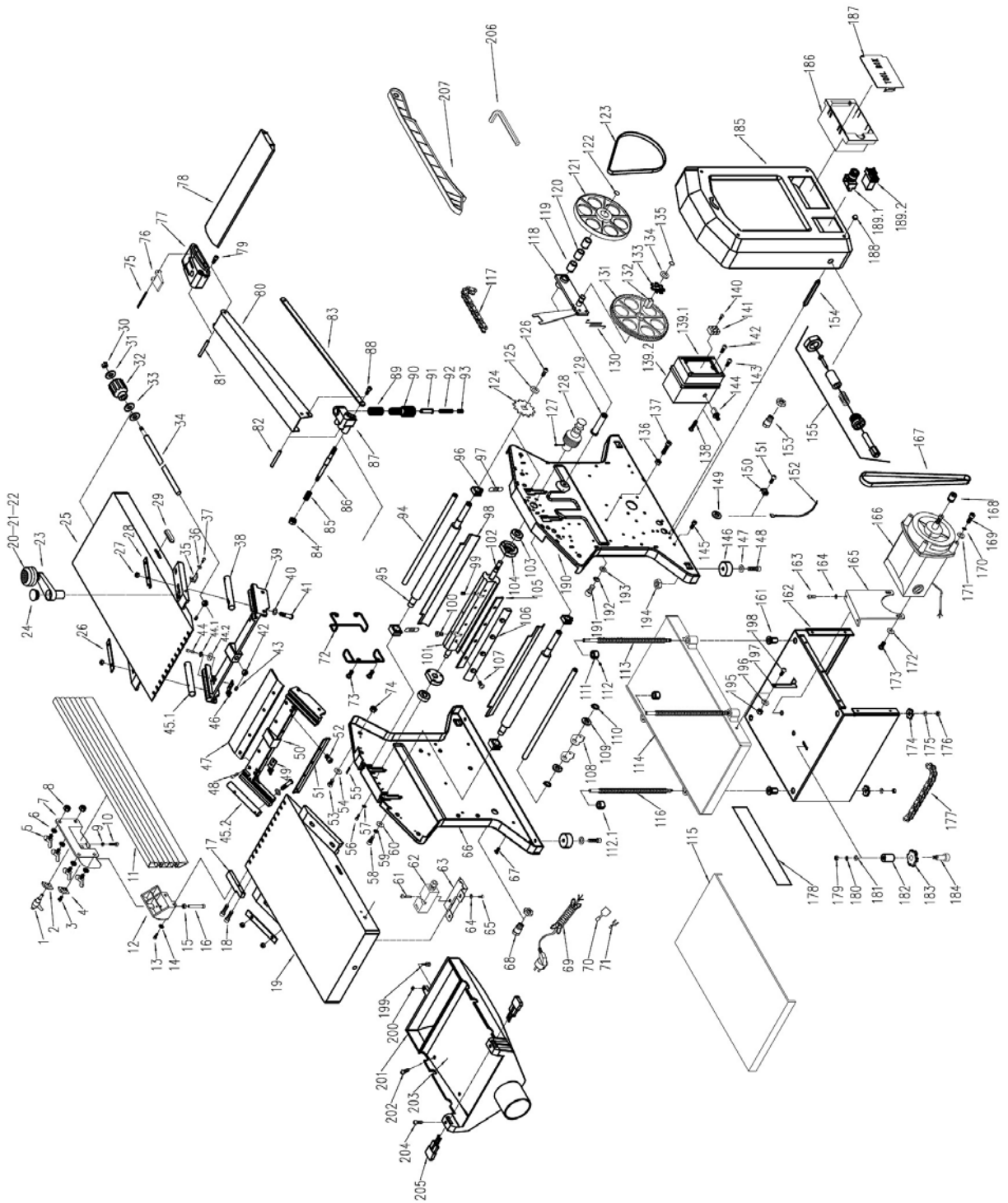


Fig. 35: Spare parts drawing ADH 250

13.2.4 Spare parts drawing ADH 305

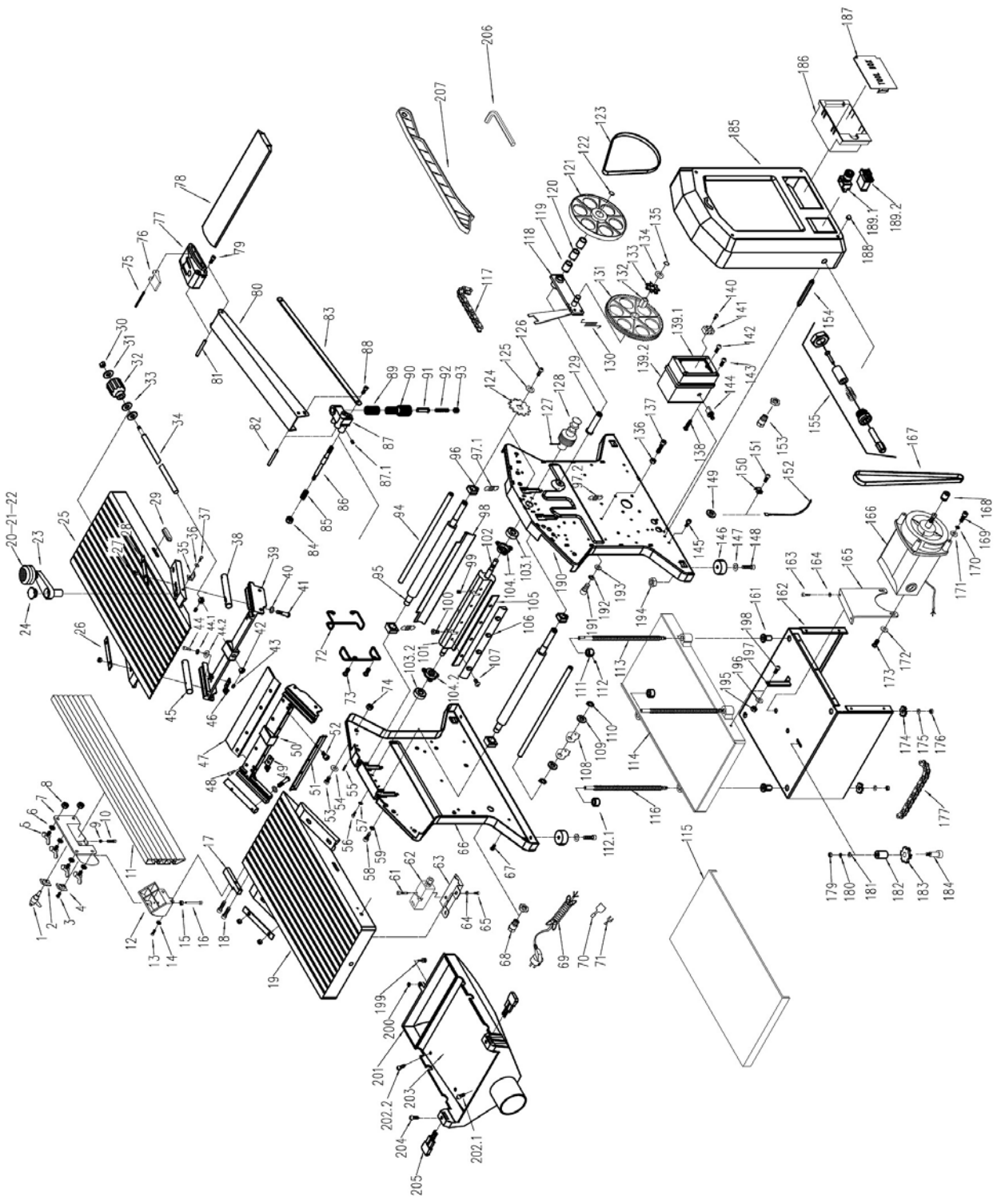


Fig. 36: Spare parts drawing ADH 305

14 Electrical wiring diagram

14.1 ADH 200

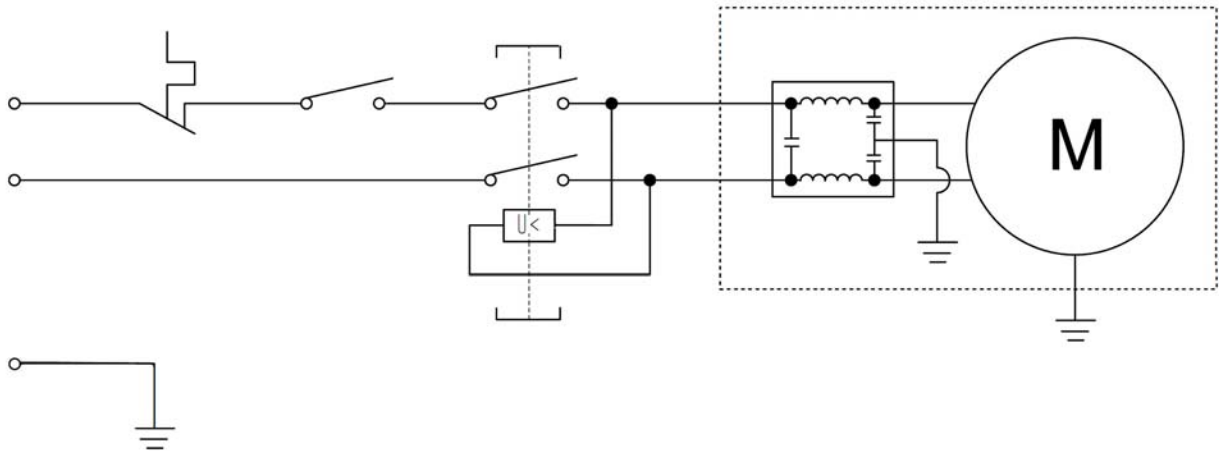


Fig. 37: Electrical wiring diagram ADH 200

14.2 ADH 200 AS, ADH 250, ADH 305

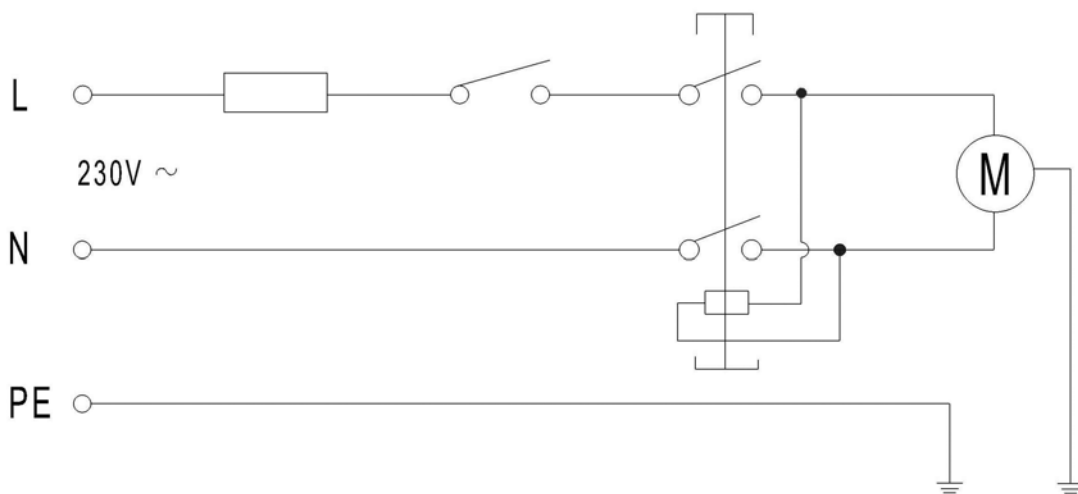


Fig. 38: Electrical wiring diagram ADH 200 AS, ADH 250, ADH 305

15 EC Declaration of Conformity

As per machine directive 2006/42/EC, Appendix II 1.A

Manufacturer / distributor: Stürmer Maschinen GmbH
 Dr.-Robert-Pfleger-Str. 26
 D-96103 Hallstadt

hereby declares that the following product

Product Category: Holzstar® Woodworking machines

Machine typ: Planer-Thicknesser

Designation of the machine *:	<input type="checkbox"/> ADH 200 AS	Item number *:	<input type="checkbox"/> 5905200
	<input type="checkbox"/> ADH 200		<input type="checkbox"/> 5905199
	<input type="checkbox"/> ADH 250		<input type="checkbox"/> 5905250
	<input type="checkbox"/> ADH 305		<input type="checkbox"/> 5905305

Serial number*: _____

Year of manufacture*: 20____

* please fill in according to the information on the type plate

corresponds, on the basis of its design and construction, as well as the version that we have put into circulation, with the relevant fundamental health and safety requirements of (subsequent) EU Directives.

Applicable EU directives: 2014/30/EU EMC-Directive
 2012/19/EU WEEE-Directive

Applicable EU regulations: 1907/2006/EU REACH-Regulation

The following harmonized standards have been applied:

DIN EN 62841-1:2016-07	Electric motor-operated hand-held tools, transportable tools and lawn and garden machinery - Safety - Part 1: General requirements
DIN EN 61029-2-3:2012-01	Safety of transportable motor-operated electric tools - Part 2-3: Particular requirements for planers and thicknessers
DIN EN 55014-1:2018-08	Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 1: Emission
DIN EN 55014-2:2016-01	Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 2: Immunity - Product family standard
DIN EN IEC 61000-3-11:2021-03	Electromagnetic compatibility (EMC) - Part 3-11: Limits; Limitation of voltage changes, voltage fluctuations and flicker in public low-voltage supply systems; Equipment with rated current ≤ 75 A and subject to conditional connection
DIN EN IEC 61000-3-2:2019-12	Electromagnetic compatibility (EMC) - Part 3-2: Limits - Limits for harmonic current emissions (equipment input current ≤ 16 A per phase)

Responsible for documentation: Kilian Stürmer, Stürmer Maschinen GmbH,
 Dr.-Robert-Pfleger-Str. 26, D-96103 Hallstadt
 Hallstadt, 14.06.2021



Kilian Stürmer
 Manager



16 Notes

