

Operating Instructions

— Planer

— DH 330



DH 330

DH-SERIES

Imprint

Product identification

Planer	Item number
DH 330	5904330

Manufacturer

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

Fax: 0049 (0) 951 96555-55

E-Mail: info@holzstar.de

URL: www.holzstar.de

Indication regarding the operating instructions

Original instructions

Edition: 18.02.2021

Version: 1.07

Language: English

Author: SN/FL

Indication regarding the Copyright

Copyright © 2021 Stürmer Maschinen GmbH, Hallstadt, Germany.

The contents of these operating instructions are the sole property of the company Stürmer Maschinen GmbH. Passing on as well as copying of this document, the use and distribution of its content are prohibited if not explicitly permitted. Contraventions are liable to compensation.

Subject to technical modifications and error.

Contents

Imprint.....	2
Contents	2
1 Introduction	3
1.1 Copyright	3
1.2 Customer service.....	3
1.3 Disclaimer.....	3
2 Safety	3
2.1 Legend of symbols.....	3
2.2 Operator responsibility.....	4
2.3 Operating staff qualification	4
2.4 Personal protective equipment	5
2.5 Safety labels on the planer	5
2.6 For your own safety	6
2.7 General safety instruction.....	7
2.8 Residual risks	8
3 Intended Use	8
4 Technical Data.....	9
4.1 Table.....	9
4.2 Type plate.....	9
5 Transport, packaging, storage.....	9
5.1 Delivery and transport.....	9
5.2 Packaging.....	10
5.3 Storage	10
6 Description of device.....	10
7 Setting up and connection.....	11
7.1 Requirements for the place of operation.....	11
7.2 Space requirement	11
7.3 Setting up of the Planer	12
7.4 Electrical connection.....	14
8 Operation	15
8.1 Thickness planing of workpiece.....	16
9 Care, maintenance and repair.....	17
9.1 Care after work	17
9.2 Inspection and replacement of brushes.....	17
9.3 Maintenance	18
9.4 Knife replacement.....	18
9.5 Servicing	19
10 Troubleshooting.....	19
11 Disposal, recycling of used devices	20
11.1 Decommissioning	20
11.2 Disposal of electrical equipment.....	20
11.3 Disposal of lubricants.....	20
11.4 Disposal via municipal collection points.....	20
12 Spare parts	20
12.1 Ordering spare parts.....	20
12.2 Spare parts drawing for machines from serial number 1210621630001	21
12.3 Spare parts drawing for machines up to serial number 1210591210051	22
13 Electrical circuit diagram	23
14 EC Declaration of Conformity	24
15 Notes	25

1 Introduction

You have made an excellent choice in purchasing a HOLZSTAR planer.

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.

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

1.1 Copyright

The contents of these operating instructions are protected by copyright. Their use is permitted within the context of using the planer. Any further use shall not be permitted without written consent by the manufacturer.

To protect our products, we register our rights to our brands, patents and designs where possible in each individual case. We take strong action against any violation of our intellectual property.

1.2 Customer service

Please contact your specialist retailer if you have any questions regarding your planer 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:



Head protection

The industrial helmet protects the head against falling objects and bumping into stationary objects.



Hearing protection

The hearing protection protects the ears against damages of hearing due to noise.



Eye protection

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



Protective dust-mask

The dust protection mask protects the respiratory tract from wood chips and wood dust.



Protective gloves

The protective gloves provide protection for the hands against sharp-edged components, as well as against friction, abrasions or deeper injuries.



Safety boots

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



Protective clothes

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



CAUTION!

Impurged, possibly contaminated body protection products can cause illnesses. Clean them after each use and once a week.

2.5 Safety labels on the planer

The following safety labels and instructions are attached to the planer (Fig. 1) and must be observed.



Fig. 1: Safety labels
1 Warning of danger | 2 Warning of dangerous electrical voltage | 3 Warning of danger of entanglement | 4 Ground symbol | 5 Mandatory signs

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.

2.6 For your own safety



WARNING!

The planer is a dangerous machine that can cause serious injury if left unattended. It is therefore essential that you follow the following safety instructions:

- The planer may only be put into operation and operated by persons who are familiar with the planer-thicknesser and are aware of the dangers involved in working with the planer.
- Persons under the age of 18 may only use the planer within the framework of vocational training and under the supervision of an instructor. In this case, the minimum age is 16 years.

The European standards must be observed when installing, operating, maintaining and repairing the planer. For the European standards not yet transposed into the respective national law, the still valid country-specific regulations must be applied.

Operators of the planer outside the scope of the European Standards are obliged to comply with the safety and accident prevention regulations applicable in the country of operation. If necessary, appropriate measures must be taken to comply with the country-specific regulations before the planer is put into operation.



DANGER!

Do not use your fingers to look for end position switches in order to be able to switch on the planer in a way other than intended.

Safety during operation

Before using the planer, make sure that

- There is no danger to persons.
- No things are damaged.
- Do not work in any way that is dangerous to safety.
- Use personal protective equipment such as a dust mask, hearing protection and protective goggles.
- Use an extraction system to extract wood and sawdust. The extraction speed must be 20 m/s at the extraction head.

The residual hazards listed below are always the responsibility of planners and cannot be completely averted by safety devices.



ENTANGLEMENT HAZARD!

Ensure that no parts of the body or clothing can be caught by the machine and pulled in during operation. Wear tight-fitting clothing and if necessary a hair net.

Danger due to insecure position.

For long workpieces, use suitable workpiece supports on both sides of the planer. Avoid an unfavorable posture. Make sure that you stand securely. Keep the working area clean.

Danger to other persons in the working area

Keep the unauthorised persons, especially children, away from the danger area. Point out the hazards of the planer to persons who will help you when working on the planer.

Danger from touching the rotating cutter head

Always keep sufficient distance to the cutter head. Switch off the thickness planer when it is not in use.

Risk of the workpiece hitting back

The workpiece is picked up by the cutter head and thrown against the operator. Work only with the non-return device functioning correctly. Only use sharp planing knives. Check the workpiece for foreign objects before starting work.



Protective gloves

Use protective gloves when changing the planing knife.

Consider work area's environment.

Do not use the planer in the rain or in a humid environment. Ensure that the workplace is adequately lit. Do not operate planer near flammable gases or liquids. Keep uninvolved persons, especially children, away from the danger area. Point out the dangers to the machine to persons who help you with work on the planer.

Risk due to defects on the planer.

Before each use, check the planer for damage or dismantled, defective protective covers and protective devices. Do not use the planer if a part is defective. Replace blunt planing knives immediately. There is a risk of kickback if a blunt planer knife gets caught in the surface of the workpiece.

Danger of overloading the planer

Only operate the planer in the specified power range. Use the planer only for the purpose for which it is intended.

Before each switch-on, make sure that there are no objects such as tools in the planer.

2.7 General safety instruction



ATTENTION!

Repairs, maintenance and upgrades may only be carried out by qualified personnel with the machine switched off and secured (pull the mains plug!)

- The design of the machinery must not be altered and it must not be used for purposes other than those provided for by the manufacturer.
- Use the safety devices. Never work without guards and keep them operational. Check the functionality before starting work.
- Always keep the machine and your working environment clean and free of obstacles!
- Never work under the influence of concentration-disturbing illnesses, fatigue, drugs, alcohol or medication.
- Remove tool keys, set-up tools and other loose parts from the machine after assembly or repair before switching on the machine.
- All safety and danger instructions on the machine must be observed and kept in perfect condition.
- Keep children and persons not familiar with the machine away from your working environment, the machine and tools.
- The machine may only be used, equipped and maintained by persons who are familiar with it and have been informed of the dangers (minimum age 18 years).
- If the machine is moved, even at a short distance, it must be disconnected from the mains supply. Before the machine is put back into operation, it must be properly connected to the power supply.
- The operator must switch off the engine when leaving the workplace. Pull out the plug! Disconnect the appliance when not in use.
- The machine can only be used if it is connected to the effective chip and dust extraction system.
- The machine must be earthed. The yellow / green wire is the grounding cable.
- Only tools according to EN 847-1: 2005 may be used. Check the machine at each start to ensure that the protective equipment and switches are in order. Do not use the machine if the protective equipment, the switch, the electrical connections, the plug or other parts of the machine are damaged.
- Do not pull on the power cord to pull the plug out of the socket.
- When using this equipment, avoid physical contact with grounded objects (e.g. pipes, radiators, electric cookers, refrigerators).
- Wear tight-fitting work clothing, safety glasses, safety shoes, and hearing protection. Tie long hair together. Do not wear jewellery such as watches, bracelets, necklaces, rings, scarves or gloves (moving/rotating parts!) when working.
- Never leave the machine unattended in operation and remain with the machine until the tool has come to a complete standstill. Then pull the mains plug to protect against unintentional switch-on.
- Do not remove the workpiece until the tool has come to a complete stop and you have switched off the machine.
- Protect the machine from moisture (danger of short circuit!).
- Never use electric tools and machines in the vicinity of flammable liquids and gases (danger of explosion!).
- Faults which impair safety must be rectified immediately.
- Before each use of the machine, make sure that no parts are damaged. Damaged parts must be replaced immediately to avoid sources of danger!
- Do not overload the machine! You will work better and safer in the specified performance range. Use the correct tool! Ensure that the tools are not damaged.
- Do not use faulty or damaged extension cords.
- Only use original spare parts and accessories to avoid possible hazards and accident risks.
- Only use the accessories recommended for this unit.
- Follow the instructions provided with the accessories. The use of incorrect accessories can lead to hazards.
- Use only accessories designed for this machine to avoid injury from ejected parts or workpieces.
- Do not use accessories unless you have fully read the manual or operating instructions for this accessory.
- To avoid injury from unexpected start-up, do not plug the power cord into a wall outlet during unpacking and installation. This cable must always be disconnected when assembling or adjusting the unit.
- If any part is missing or damaged, do not connect the equipment until the missing or damaged part has been replaced and assembly is complete.
- Do not use blunt cutting blades as this will increase the risk of setbacks.
- If short pieces of wood are to be planed, position the workpieces with a sliding stick.
- Do not use the machine for folding or rolling wood.
- Regularly check that the cutting block and the non-return device are working properly.
- Only use well sharpened cutting blades to work better and safer.
- Do not use cracked cutting blades or blades that are no longer in their original shape.
- Use appropriate aids to support heavy or bulky parts when they are to be used. Such aids are the additional units: Jack-up and Universal Trucks.
- Check regularly that the cutting blade is securely attached.

- The cutting blade must not be more than 1 mm or 10% above the cutting block.
- Wear suitable gloves when changing the cutting blade.
- Do not wear work gloves when working on the thickness planer; safe in cases where the workpiece is rough.
- Make sure that the dust extraction unit is switched on before starting the work.
- If the push rod and push bar are damaged, contact Customer Service to have them replaced immediately.

2.8 Residual risks

Even if all safety regulations are observed and the machine is used correctly, there are still residual risks, which are listed below:

- Contact with rotating parts or hot tools Injuries caused by flying workpieces or workpiece parts
- Fire hazard with insufficient ventilation of the motor
- Impairment of hearing during prolonged work without hearing protection.



NOTE!

It should be noted that each machine has residual risks. Great care must be taken when carrying out all operations (even the simplest ones). Safe working depends on the user!

3 Intended Use

The planer DH 330 is used for dressing and thickening boards and strips. This machine was developed for cutting wood and plastic materials. Do not cut metal with the machine.

Proper use also includes compliance with all the information in these instructions. Any use beyond the intended use or any other use is considered misuse.



WARNING!

The machine may only be operated in a technically perfect condition. Any faults must be rectified immediately.

Unauthorized modifications to the machine or improper use of the machine as well as disregard of the safety regulations or the operating instructions exclude the manufacturer's liability for any resulting damage to persons or objects and invalidate the warranty claim!



WARNING!

Danger in case of misuse!

A misuse of the Planer can result in dangerous situations.

- Only operate the planer in the power range given in the technical specifications.
- Never operate the machine without the safety devices.
- Never work up other materials that do not correspond to those which are required for the intended use.
- Only operate the the planer in a technically flawless status.
- Never machining several workpieces at the same time.

The planer is designed exclusively for processing solid wood. The permissible dimensions of the workpieces must be observed. The processing of other materials is not intended and not permitted.

Every workpiece must be inspected for foreign objects such as screws or nails before machining. The planer is designed and built for use in a non-hazardous environment.

If the planer is used differently than mentioned above, if it is modified without the approval of HOLZSTAR@wood-working machines, the planer will no longer be used as intended.



WARNING!

Severe injuries due to improper use.

Modifications and changes to the operating values of the planer are prohibited.

They endanger people and can lead to damage to the planer.

Always keep the operating instructions close to the planer.

- All persons involved in installation, commissioning, operation and maintenance must have the necessary qualifications to observe these operating instructions exactly. In case of improper use
- may cause danger to persons,
- the planer and other material assets can be endangered,
- the function of the planer may be impaired.

Stürmer Maschinen GmbH assumes no liability for constructive and technical changes to the planer. Claims of any kind due to damage due to improper use are excluded.



WARNING!

The planer may only be operated with functioning safety devices.

Switch off the planners immediately if you discover that a safety device is faulty or has been dismantled!

All additional equipment provided by the operator must be equipped with the prescribed safety devices. You as the operator are responsible for this!

4 Technical Data

4.1 Table

Data	DH 330
Input power drive motor [kW]	1,5 kW
Output power drive motor [kW]	0,9 kW
Electrical connection [V]	230 V
Phase (s) [Ph]	1
Mains frequency [Hz]	50 Hz
Max. material removal	2,8 / 2,8 mm
Feed speed	6 m/min
Number of planing knives	2
Sound pressure level Lp	85 dB
Sound power level Lw	94 dB
Working height max.	152 mm
Working height min.	6 mm
Dimension (L x W) thicknessing table	235 x 330 mm
Max. planing width.	330 mm
Planing shaft speed	8500 min ⁻¹
Dimensions LxWxH	640 x 585 x 490 mm
Extraction port Ø	52,5 / 64,5 / 101 mm
Weight [kg]	33 kg

4.2 Type plate

Dickenhobel Planer			Serien-Nr. Serial no.	
Typ Type	DH 330	Baujahr Year of manufacture		
Artikel-Nr. Item no.	5904330	Netzanschluss Power connection	230 V	
Motoraufnahmeleistung Engine power input	1,5 kW	Werkstückhöhe max. Workpiece height max.	152 mm	
Motorabgabeleistung Engine power output	0,9 kW	Werkstückhöhe min. Workpiece height min.	6 mm	
Max. Spanabnahme Max. chip removal	2,8 mm	Hobelbreite max. Working width max.	330 mm	
Vorschubgeschwindigkeit Feed speed	6 m/min	Hobelwellendrehzahl Cutting block speed	8500 1/min	
Schalleistungspegel LwA Sound power level	94 dB	Gewicht Weight	33 kg	
		Stürmer Maschinen GmbH Dr.-Robert-Pfleger-Str. 26, 96103 Hallstadt Deutschland / Germany		

Fig. 2: Type plate DH 330

5 Transport, packaging, storage

5.1 Delivery and transport

Delivery

After delivery, check the planer for visible transport damage. If you discover any damage to the planer, report it immediately to the transport company or dealer.

Transport



CAUTION!

Injuries caused by parts falling over or off a forklift, pallet truck or transport vehicle.

Only use means of transport that can carry the total weight and are suitable for it.

Improper transport of individual devices, unsecured devices stacked on top of each other or next to each other in packed or already unpacked condition 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.

General risks during internal transport



CAUTION: 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.

Transport with a forklift/lift truck:

After assembly on a pallet, the planer can be transported with a forklift truck or a lift truck.

5.2 Packaging

All packaging materials and packaging aids used by the planer are recyclable and must always be recycled.

The films are made of polyethylene (PE) and the padding parts of polystyrene (PS). You hand these materials over to a recycling collection point or to the disposal company responsible for you.

5.3 Storage



WARNING!

Keep the planer in a safe place so that it cannot be operated by unauthorised persons and so that nobody can injure themselves on the planer.
Do not store the machine unprotected outdoors or in a humid environment.

Store the planer thoroughly cleaned in a dry, clean and frost-free environment. Cover the machine with a protective tarpaulin.

6 Description of device

The illustrations in these operating instructions serve the general comprehension and may deviate from the actual type.

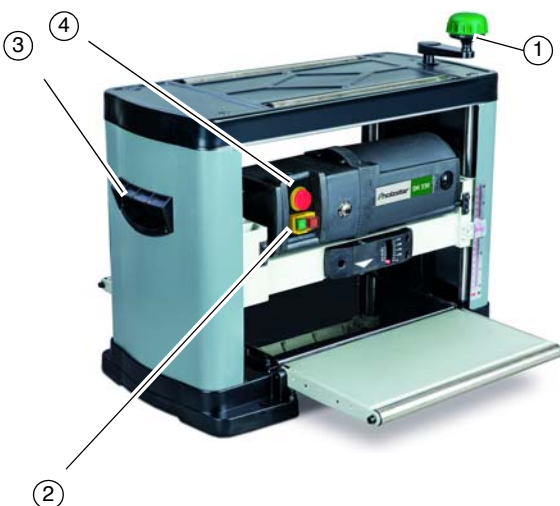


Fig. 3: Planer

- 1 Hand crank: height adjustment of the planer
- 2 STOP/ START Button
- 3 Carrying handle
- 4 Emergency button

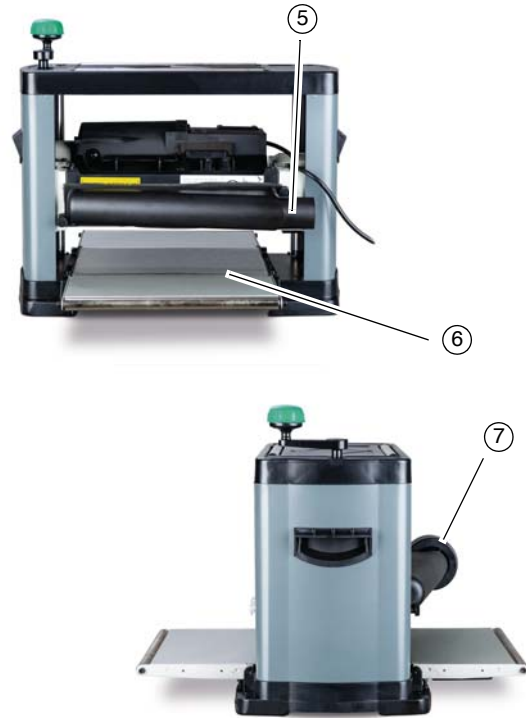


Fig. 4: Planer

- 5 Dust chute
- 6 Outfeed table
- 7 Adapter of the dust chute

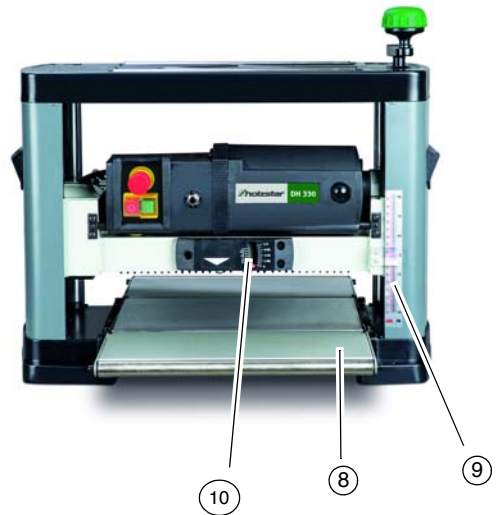


Fig. 5: Planer

- 8 Infeed table
- 9 Height scale
- 10 Mechanical material removal display

7 Setting up and connection

7.1 Requirements for the place of operation

The planer must be installed securely on a level and firm surface. Ensure that there is sufficient freedom of movement for working. The place of operation should meet the following criteria:

- The underground must be even, solid and vibration-free.
- The underground must not allow any lubricants to pass through.
- The installation or working area must be dry and well ventilated.

7.2 Space requirement

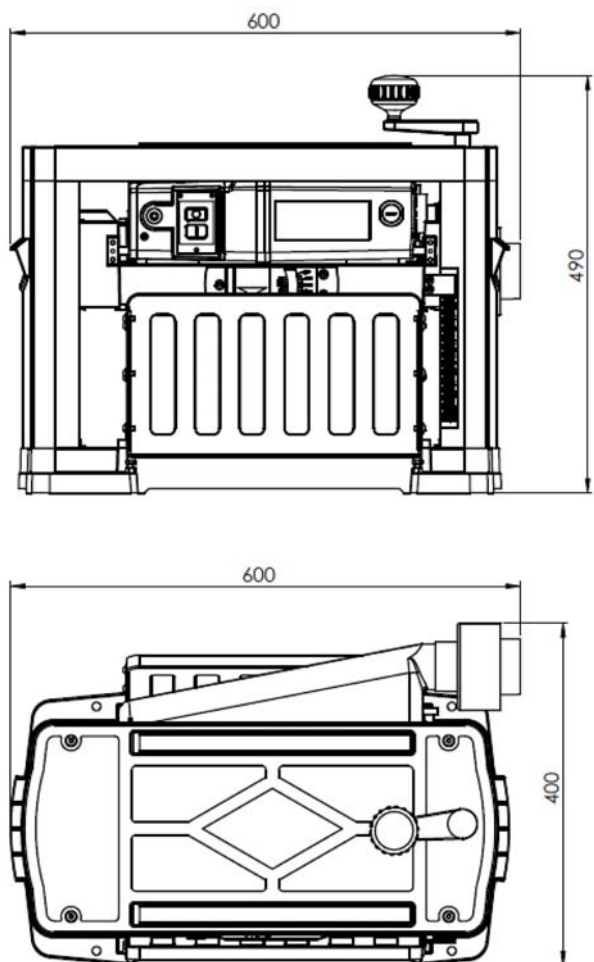
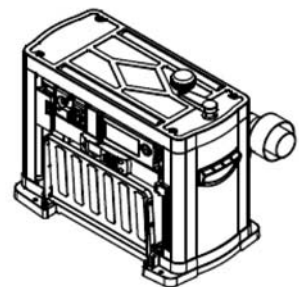
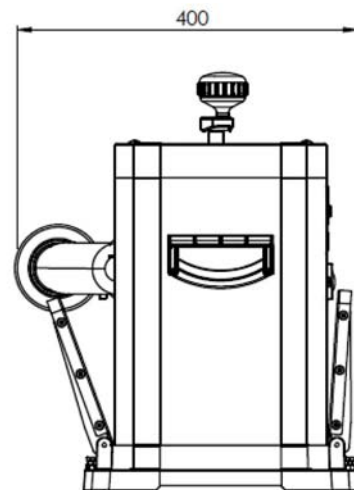


Fig. 6: Space requirement Planer DH 330

- No machines causing dust or chips should be operated near the machine.
- There must be sufficient space for the operating personnel, for material transport and for adjustment and maintenance work (see installation plan).
- The place of operation must have good lighting.
- There must be an extraction device with sufficient dimensions for the machine.



7.3 Setting up of the Planer



CAUTION!

Risk of injury from an improperly installed machine!
Check the stability of the machine after setting it up on stable ground.



CAUTION!

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



ATTENTION!

Place the machine on a level, firm and free work surface. If the surface is soft, use a board as a base for the machine.

The machine is delivered in a box and is already largely assembled. Only a few parts have to be assembled after delivery.

- Install the planer exactly according to these instructions.
- Only use the parts included in the scope of delivery.

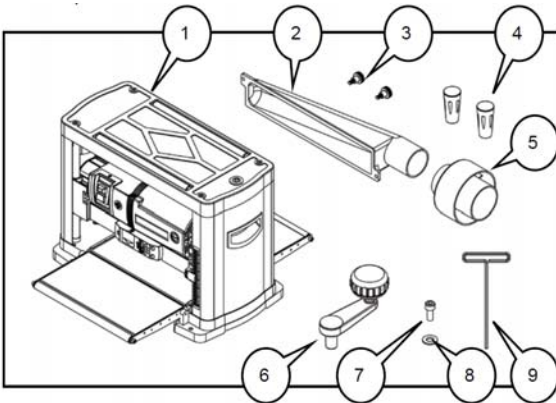


Fig. 7: Machine components

- 1 Planer
- 2 Dust chute
- 3 Tumb screw
- 4 Magnet
- 5 Adapter
- 6 Crank handle
- 7 Socket head bolt
- 8 Flat washer
- 9 Hex wrench

Mounting



WARNING!

Do not connect the machine to the power supply until assembly is complete.
Failure to do so may result in unintentional start-up and possible serious injury.



ATTENTION!

Do not make any modifications to the parts.

Step 1: Unpack the power cable from the cable storage under the output table.

Step 2: Lower the infeed and outfeed tables.

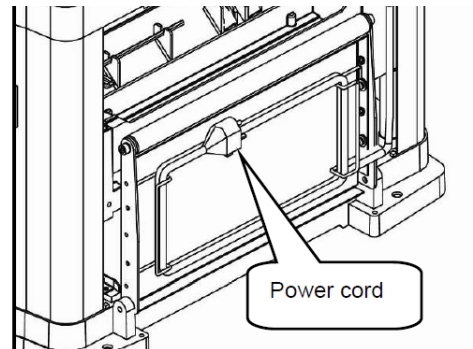


Fig. 8: Power cord

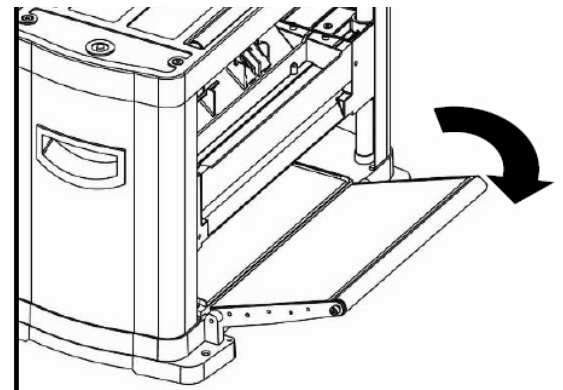


Fig. 9: Folding the side table out

Step 3: Place the washer over the socket head bolt and feed the bolt into the handle..

Step 4: Tighten the bolt to secure the handle in position.

Step 5: Place the handle cap onto the handle.

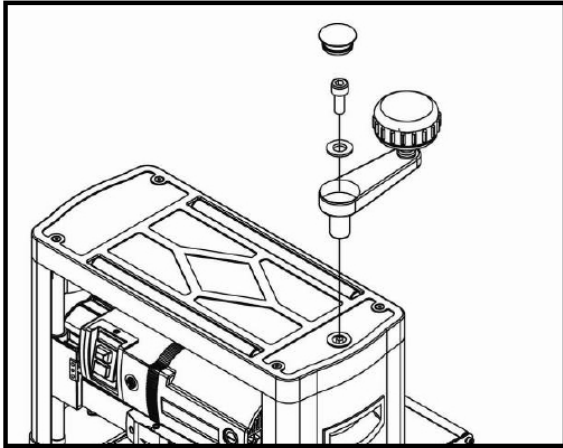


Fig. 10: Mounting of the hand crank

Step 6: Remove the polystyrene insert located between the main table and the blade drum. Peel the protective film from the main table.



ATTENTION!

Only start up the machine when it is stable!

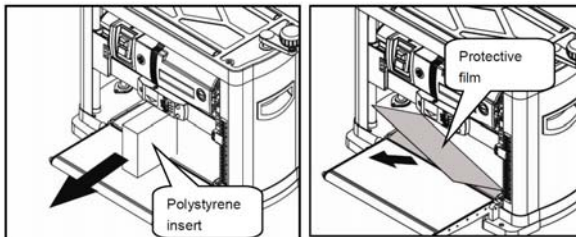


Fig. 11: Remove the transport insert

Step 7: Attach the dust chute to the machine using two thumb screws.

Step 8: The dust chute can be mounted to direct chips to either side of planer.



NOTE!

It is recommended that the planer be used with a dust extraction system for a cleaner and safer working environment. Using a dust extraction system will also help prevent clogging of the dust chute. An adapter is provided for matching dust extraction system better.

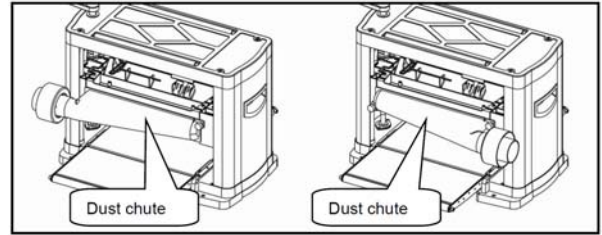


Fig. 12: Mounting of the dust chute

The planer features four holes in the base for mounting to a workbench or worktable.

The planer should be mounted level bench or table before operation.

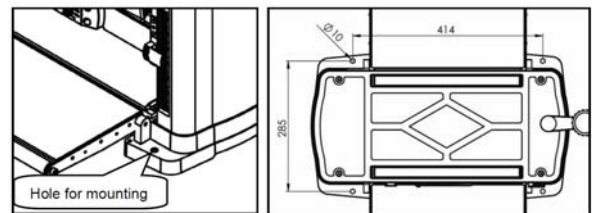


Fig. 13: Mounting holes

The machine must be anchored in the ground with screws before operation.

Mounting the suction hose



Tips and recommendation

The dust and dust extractor must have sufficient power at a flow speed of min. 20 m / s.



Fig. 14: Suction connection

Step 1: Mount the suction hose to the adapter.

7.4 Electrical connection



DANGER!

Risk of death due to electric shock!

Contact with live components may result in fatal injury.

Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

All work on the electrical installation may only be carried out by a qualified electrician.

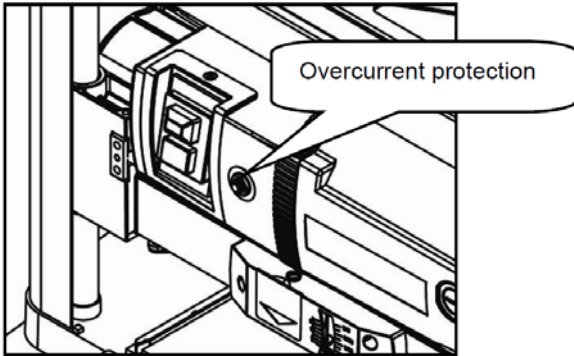


Fig. 15: Overcurrent protection



ATTENTION!

There is an overcurrent protection device in the circuit.

Use the planer only in a dry environment. Use the planer only on an electrical supply that meets the following requirements.

- Fuse protection with a sufficiently dimensioned residual current circuit breaker (FI circuit breaker).
- Only use a socket outlet with earthing contact (properly earthed socket outlet).
- Route the power cord so that it does not interfere with work and cannot be damaged.
- Protect the power cord from heat, aggressive liquids, and sharp edges.
- To avoid electrical hazards, fire, or damage to the tool, use appropriate circuit protection.
- Use a separate circuit for your tools.
- To avoid electric shock or fire, the power cord must be replaced immediately if it is worn or damaged in any way.
- Make sure that the electrical current meets the requirements of the nameplate on the machine.



DANGER!

Risk of death due to electric shock!

Contact with live components may result in fatal injury. Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

- Disconnect the mains plug before making any adjustments to the machine.

Check motor direction of rotation

After the electrical connection, check that the direction of rotation of the spindle corresponds to the direction indicated on the plate. If the direction of rotation is incorrect, the connections of the phase lines L1 and L2 must be replaced.



WARNING!

The planer is only intended for indoor use.

Never use planer in the rain or in areas where steam is present.



WARNING!

Improper connection of the equipment grounding conductor may result in electric shock.

This tool must be grounded during operation to protect the operator from electric shock.

IN THE EVENT OF MALFUNCTION OR INTERRUPTION, grounding provides a path of least resistance to electrical current and reduces the risk of electric shock. This tool is equipped with a power cable that has a ground wire and ground plug. The plug **MUST** be plugged into a suitable outlet that is properly installed and grounded in accordance with ALL local regulations. **DO NOT CHANGE THE CONNECTOR.** Have the correct socket installed by a qualified electrician if it does not fit into the socket. **IMPROPER CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with green insulation (with or without yellow stripes) is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment-grounding conductor to a live terminal. **CHECK** with a qualified electrician or service person if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

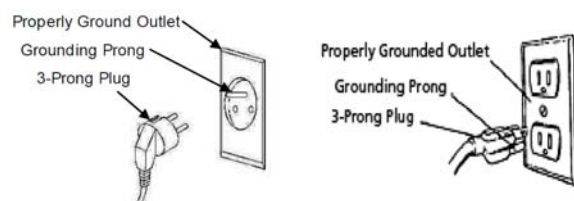


Fig. 16: Properly earthed socket outlet

Guidelines for extension cords

- Make sure that the extension cord is in good condition.
- When using an extension cord, be sure to use one heavy enough to carry the current your product will draw.
- An undersized cord will cause a drop in line voltage, resulting in loss of power and cause overheating.
- Make sure that the extension cord is properly wired and in good condition.
- Always replace a damaged extension cord or have it repaired by a qualified person before using it.
- Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

8 Operation



WARNING!

Danger to life!

There is a danger to life for the operator and other persons if they do not comply with the following rules.

- The planer may only be operated by an instructed and experienced person.
- 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 illnesses affecting his concentration.
- The planer may only be operated by one person. Other persons must stay away from the work area during operation.
- Check the machine for damaged parts. If the protective equipment or guards are damaged, replace them immediately.
- Test whether the moving parts can move freely for the necessary function.



ATTENTION!

The following must be observed for safe operation:

- Do not lean too far forward when operating the planer.
- When operating the planer, always stand securely with both legs on the ground and ensure that you always keep your balance.
- Do not work with the machine if the ON/OFF switch or the speed controller cannot be moved correctly.



WARNING!

The following must be observed for safe operation:

- Handle your tools with care: they can be very sharp.
- When the machine is switched on, the workpiece must not touch the tools.
- Let the machine run for a while after turning it on for the first cut. During the running-in phase, be aware of vibrations or drum noises that indicate improper tool attachment.



NOTE!

The use of tools or devices other than those specified in the operating instructions may pose a hazard to the user.



CAUTION!

Risk of crushing!

Improper work on the machine may result in injury to the upper limbs.



ATTENTION!

Before commissioning, check the electrical connection, cables and contacts.



Wear hear protection!



Use protective goggles!



Wear safety boots!



Wear protective clothes!

- Observe all safety and danger notices on the machine.
- If larger workpieces are to be handled in such a way that the table top must be tilted, a table extension or a special lift truck (additional accessory) must be used.
- Pay attention to the direction of rotation of the tool and the correct entry direction of the workpiece.
- Cloths, cables and similar objects must not be placed on the work surface when the machine is in operation.
- After prolonged operation of the machine, external metal parts and equipment may become hot.
- Support the workpiece sufficiently.
- Use additional tools such as horizontal holders to machine smaller workpieces.

8.1 Thickness planing of workpiece

Step 1: Rotate the height adjustment handle for raising or lowering the cutterhead. The depth scale shows the height of cutterhead above the main table.

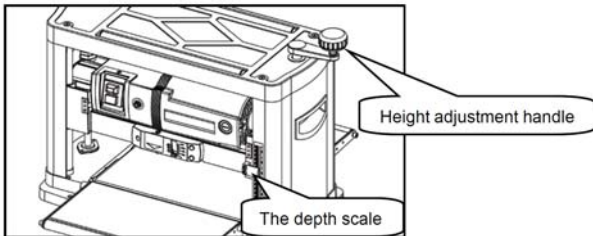


Fig. 17: Height adjustment of the planer

A spring loaded depth-of-cut gauge is attached to front of roller case. The pointer on depth-of-cut gauge accurately displays the depth-of-cut per pass when workpiece is positioned below the gauge.

Step 1: Cranking the handle moves the roller case down and the pointer shows the desired depth-of-cut.

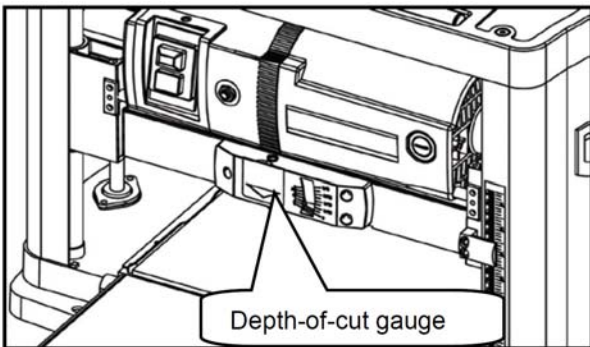


Fig. 18: Depth-of-cut gauge

Step 2: Adjust the depth of cut to make an initial light (0.5mm) cut.
Note that one revolution of the height adjustment handle is equivalent to 2 mm depth of cut.

Step 3: Switch on the machine and wait until the motor has reached full speed.

Step 4: Press the board against the in-feed table and feed it into the machine.

Step 5: Release the board when the machine starts to cut and let the board feed into the machine automatically.

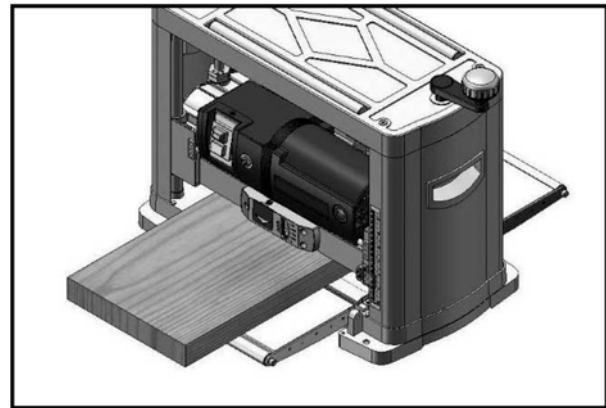


Fig. 19: Planing of a board



NOTE!

When making repetitive cuts the workpiece can be passed over the top of the thicknesser utilising the top rollers.

Avoiding snipe

Snipe is caused by the board tilting slightly towards the beginning and the end of the thicknessing operation.

It shows as lines at the ends of the board, parallel with the cutterhead.

To avoid snipe:

either support the board on extension tables set to the same level as the in-feed and out-feed tables,

OR

mount the machine in a recess in the bench so that the feed tables are level with the bench.

Check before starting work:

- ON/OFF switch
- Non-return device
- Cutter cover



ATTENTION!

- The hands must not get inside the device! There is a risk of injury from rotating planing knives.
- Do not tilt the workpiece (may strike back).
- Do not remove jammed parts until the motor has stopped and the mains plug has been disconnected.
- Replace blunt planing knives (Risk of kickback).

9 Care, maintenance and repair



DANGER!

Risk of fatal injury due to electric shock!

Contact with live components may result in fatal injury. Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

- Before starting cleaning and maintenance work, switch off the machine and pull out the mains plug.
- Connections and repairs to the electrical equipment may only be carried out by a qualified electrician.

9.1 Care after work



WARNING!

Risk from insufficiently qualified persons!

Insufficiently qualified persons cannot assess the risks of repair work on the machine and expose themselves and others to the risk of serious or fatal injury.

- Have all maintenance work carried out by qualified personnel only.
- The machine may only be used, serviced or repaired by persons who understand the possible dangers and have been instructed in the dangers. Independent modifications to the machine exclude any liability on the part of the manufacturer for damage resulting from these modifications.



Use protective gloves!



NOTE!

Never use strong cleaning agents for any cleaning tasks. This may damage or destroy the device.

Step 1: Disconnect the mains plug from the socket.

Step 2: Empty and clean the suction device.

Step 3: Clean the machine from chips and planing dust with compressed air and/or with a dry cloth.



Wear a dust mask!

Step 4: Spray or oil all unpainted metal surfaces with a little anti-rust spray.

Step 5: Oil the shaft and bearings.

Step 6: Check the machine for damage to the safety devices and the planing knife. If necessary, carry out or arrange for the repair to be carried out in accordance with the safety instructions.

Step 7: Check the machine regularly:

- Appropriate tension of the drive belt.
- Loose bolts and nuts.
- Worn or damaged switches.
- Worn or damaged planing knives.

9.2 Inspection and replacement of brushes

Step 1: Loosen the brush cover and carefully remove the brush from the motor.

Step 2: Replace the brushes if the carbon is worn out.

Step 3: Replace the brushes and reattach the brush cover.

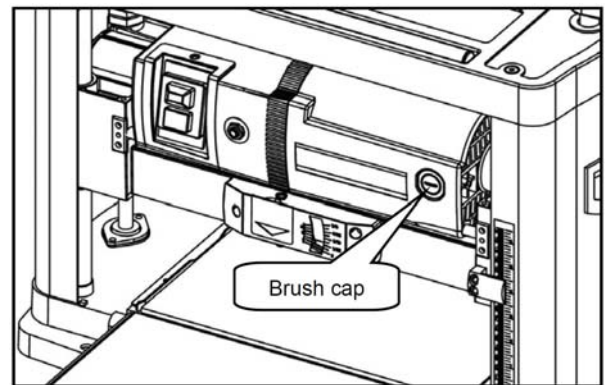


Fig. 20: Brush cover



WARNING!

Switch off the planer and disconnect it from the power source. The life of the brush depends of load on the motor. Check the brushes regularly after 50 hours of operation. The brushes are located on both sides of the planer motor.

Cleaning the planer

Step 1: Fold out the infeed and outfeed tables.

Step 2: Unscrew the cutter cover.

Step 3: Remove the wood shavings with a vacuum cleaner or brush.

- Height adjustment device of the planing knife
- cutter block
- Ventilation slots of the motor.

Step 4: Tighten the knife shaft cover.

Step 5: Lightly oil the height adjustment device (spindles) of the planing knife.

Step 6: Apply a thin layer of wax to the infeed and outfeed tables.

9.3 Maintenance

Bevore work with the planer	
<ol style="list-style-type: none"> 1. Inside the unit 2. Threaded rods for height adjustment 3. Suction nozzle (if you are working without suction) 	Remove wood shavings and dust

Daily	
<ol style="list-style-type: none"> 1. Threaded rods for height adjustment 2. Alignment of the infeed and outfeed tables. 3. Connection cable. 4. Carbon brushes (motor) 	<ol style="list-style-type: none"> 1. Lightly oil the guides. 2. Check and align if necessary. 3. Check for damage (cable break), replace if necessary. 4. Check and replace if necessary.

Function testing

A functional test should be carried out before each use.

Step 1: The planing knife must rotate freely and must not jam.

Step 2: Check the connecting cable for damage.

Suction

Check the suction system daily for sufficient function. If the extraction system does not function or functions only to a limited extent, it must be repaired. Only then may the planer be put into operation.



Use protective gloves!

Danger of cuts on the planing knives. Wear protective gloves when changing the planing knives.

9.4 Knife replacement



Use protective gloves!

The protective gloves prevent the hands from sharp-edged components, as well as from friction, abrasions or deeper injuries.

If the machine planes unevenly or tends to chisel, the knives must be changed.

Proceed as follows to change the knives:

Step 1: Remove the dust chute.

Step 2: Loosen and remove the four screws from the knife cover on the back of the planer.

Step 3: Remove the blade guard.

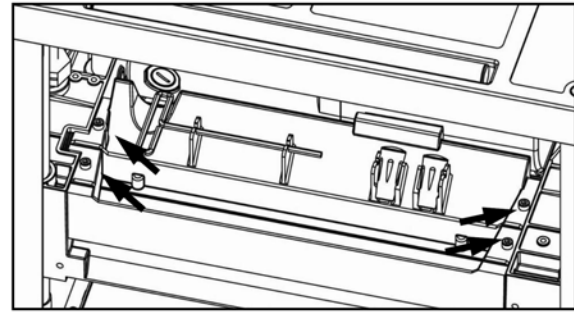


Fig. 21: Remove the blade guard

Step 4: Carefully turn cutterhead by hand.

Step 5: Loosen and remove six bolts from the gib.

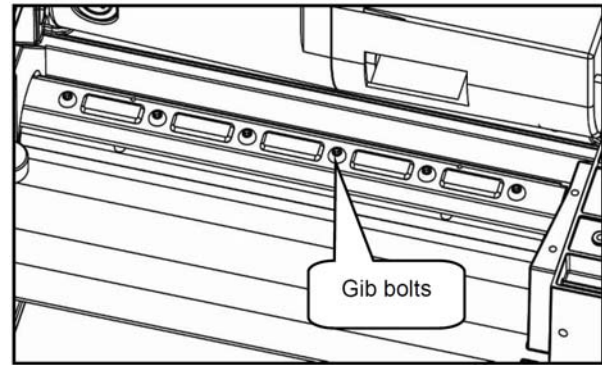


Fig. 22: Remove the blade guard

Step 6: Remove gib using magnets provided.



ATTENTION!

Blade edges are extremely sharp. Keep fingers away from blades at all times.

Step 7: Blade is located in position by two pins. Gently lift old blades from cutterhead using magnets. Do not make contact with the blade using fingers. Use magnet only.

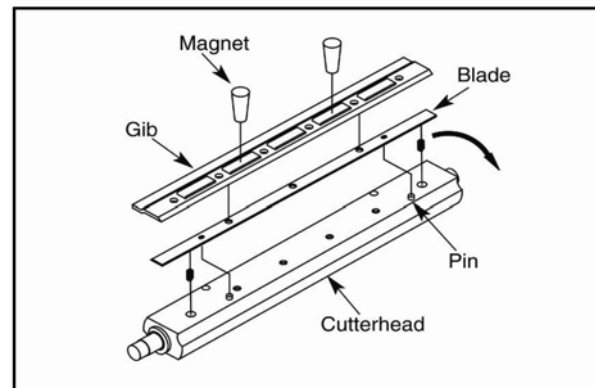


Fig. 23: Blade change at the cutter head



Fig. 24: Blade change with the help of magnets

Step 8: Reverse or replace blade and carefully position it on the two pins using magnets.

Step 9: Reset the bar and align the holes of the bar with the holes of the holes on the knife by using the magnets.

Step 10: Secure gib to cutterhead using six bolts removed earlier.



WARNING!

Only use suitable planing knives. Unsuitable, or incorrectly mounted, blunt, or damaged planing knives can come loose and/or significantly increase the risk of recoil.

- Mount only with original parts.

9.5 Servicing

As a result of wear and tear, maintenance work may have to be carried out on the machine.



NOTE!

Maintenance work may only be carried out by qualified personnel with mechanical knowledge.

If the planer 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 reinstalled immediately after completion of repair and maintenance work.

10 Troubleshooting

Fault	Possible cause	Solution
Motor does not start	<ol style="list-style-type: none"> 1. No mains voltage. 2. Undervoltage relay was triggered by a short voltage drop. 3. Motor overheated due to blunt planing knife, excessive load, chip accumulation in housing. 4. Carbon brushes worn out. 	<ol style="list-style-type: none"> 1. Have check the power connection, plug, socket, cable and fuse by qualified personnel 2. Switch on again. 3. Remove the cause of the overheating, allow the planer to cool for a few minutes and then switch it on again. 4. Replace the carbon brushes.
Performance decreases	Plane knives are blunt.	Replace the planing knives.
Machined surface too rough	<ol style="list-style-type: none"> 1. Planing knife blunt. 2. Planing knife clogged by chips. 3. Workpiece still contains too much moisture. 	<ol style="list-style-type: none"> 1. Insert sharp planing knives. 2. Remove chips. 3. Dry the workpiece.
Machined surface cracked	<ol style="list-style-type: none"> 1. Planing knife blunt. 2. Planing knife clogged by chips.. 3. The workpiece has been machined against the direction of growth. 4 Too much material planed off in one operation. 	<ol style="list-style-type: none"> 1. Insert sharp planing knives. 2. Remove chips. 3. Machining the workpiece from the direction opposite to it 4. Machine the workpiece in several operations.
Workpiece feed too low	<ol style="list-style-type: none"> 1. Workpiece contact surface is dirty. 2. Thicknessing table rollers difficult to move. 	<ol style="list-style-type: none"> 1. Clean contact surface, oil lightly. 2. Replace thicknessing table rollers.
Workpiece is jammed	Too much material was planed off at once.	Machining the workpiece in several operations.

11 Disposal, recycling of used devices

Please take care in your own interest and in the interest of the environment that all component parts of the machine are only disposed of in the intended and permitted way.

11.1 Decommissioning

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

Step 1: Eliminate all environmentally hazardous operating materials from the used device.

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

Step 3: Dispose of machine components and operating materials by the disposal channels provided.

11.2 Disposal of electrical equipment

Please note that electrical equipment contains a variety of recyclable materials and environmentally harmful components. Contribute to the separation and proper disposal of these components. In case of doubt, please contact your municipal waste disposal.

If necessary, the help of a specialised waste disposal company should be used for processing.

11.3 Disposal of lubricants

The disposal instructions for the lubricants used are provided by the lubricant manufacturer. If necessary, ask for the productspecific data sheets.

11.4 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.

12 Spare parts



DANGER!

Risk of injury due to 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.



Tips and recommendations

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

12.1 Ordering spare parts

The spare parts may be purchased with the authorised dealer or directly with the manufacturer. Please find the corresponding contact data in Chapter 1.2 Customer service.

Indicate the following basic information for requests or orders of spare parts:

- Type of device
- Item No.
- Position No.
- Year of construction:
- Quantity
- 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 information regarding the device type, item No. and year of construction on the type plate which is fixed on the device.

Example

The engine for the the planer DH 330 must be ordered. The engine has the number 73 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 (73) to the dealer or spare parts department and provide the following information:

- Type of device: **Planer DH 330**
- Item number: **5904330**
- Drawing number: **1**
- Position number: **73**

12.2 Spare parts drawing for machines from serial number 1210621630001

The following drawings is intended to help identify necessary spare parts when servicing. Send a copy of the parts drawing with the marked components to your authorized dealer to order.

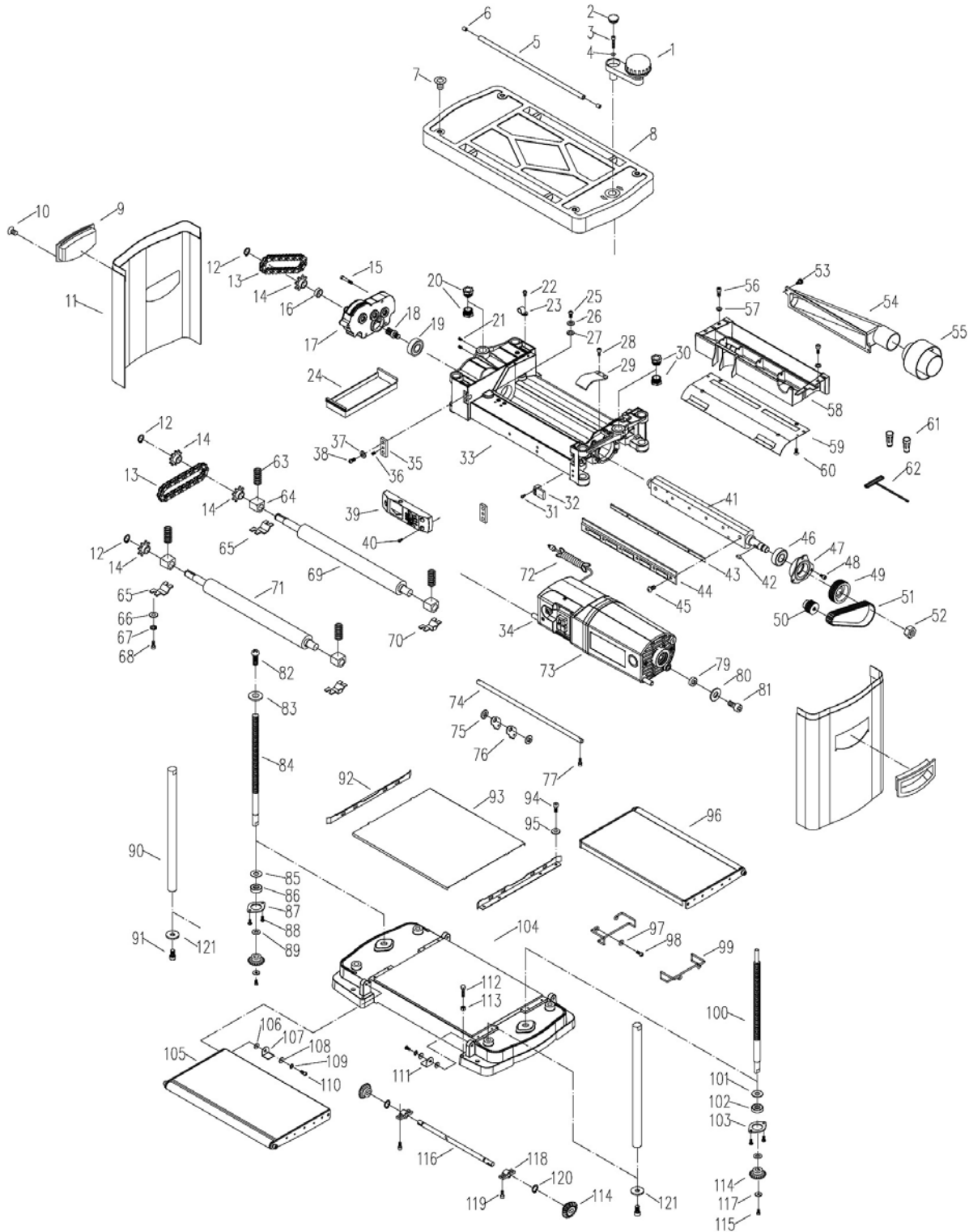


Fig. 25: Spare parts drawing Planer DH 330

12.3 Spare parts drawing for machines up to serial number 1210591210051

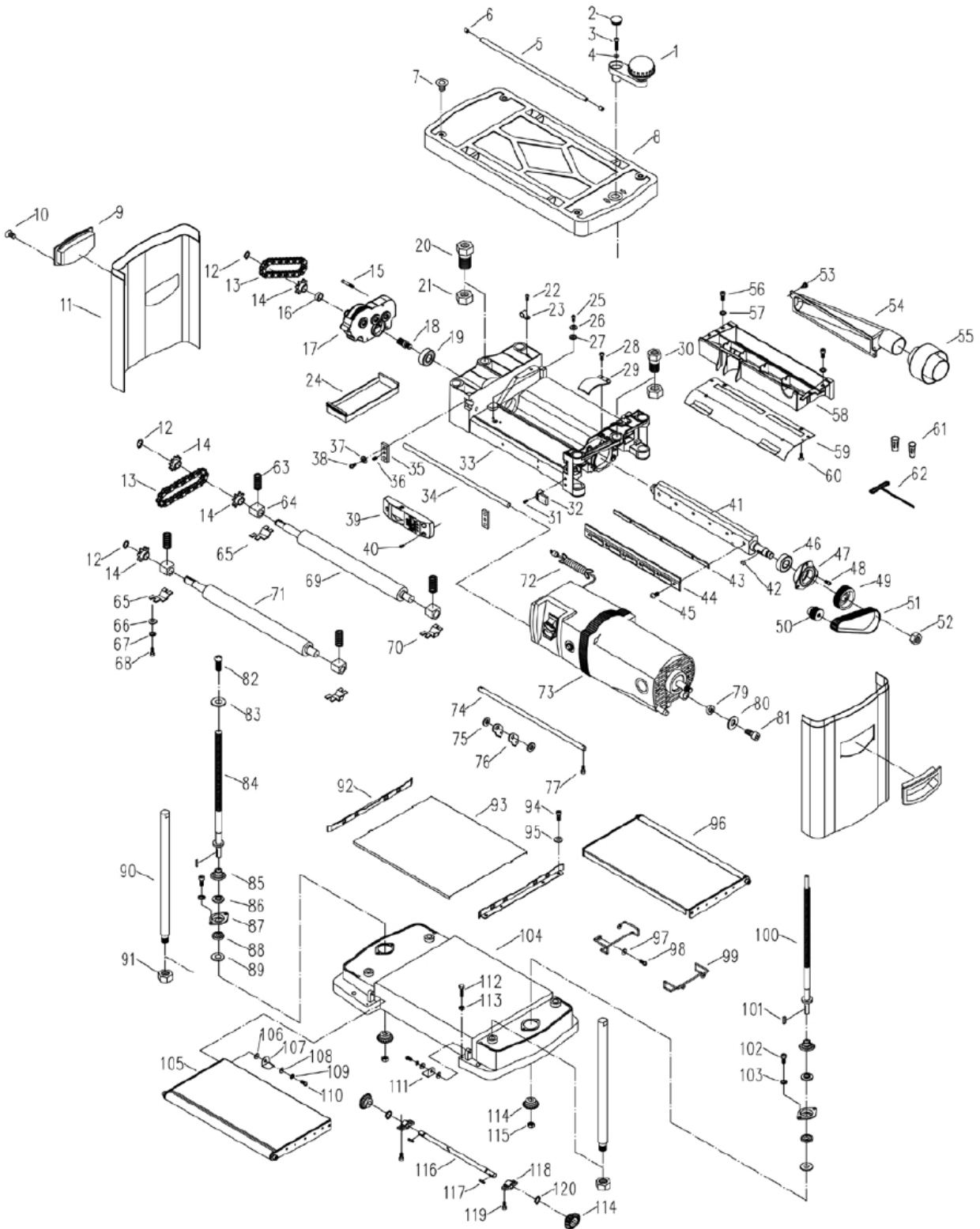


Fig. 26: Spare parts drawing Planer DH 330

13 Electrical circuit diagram

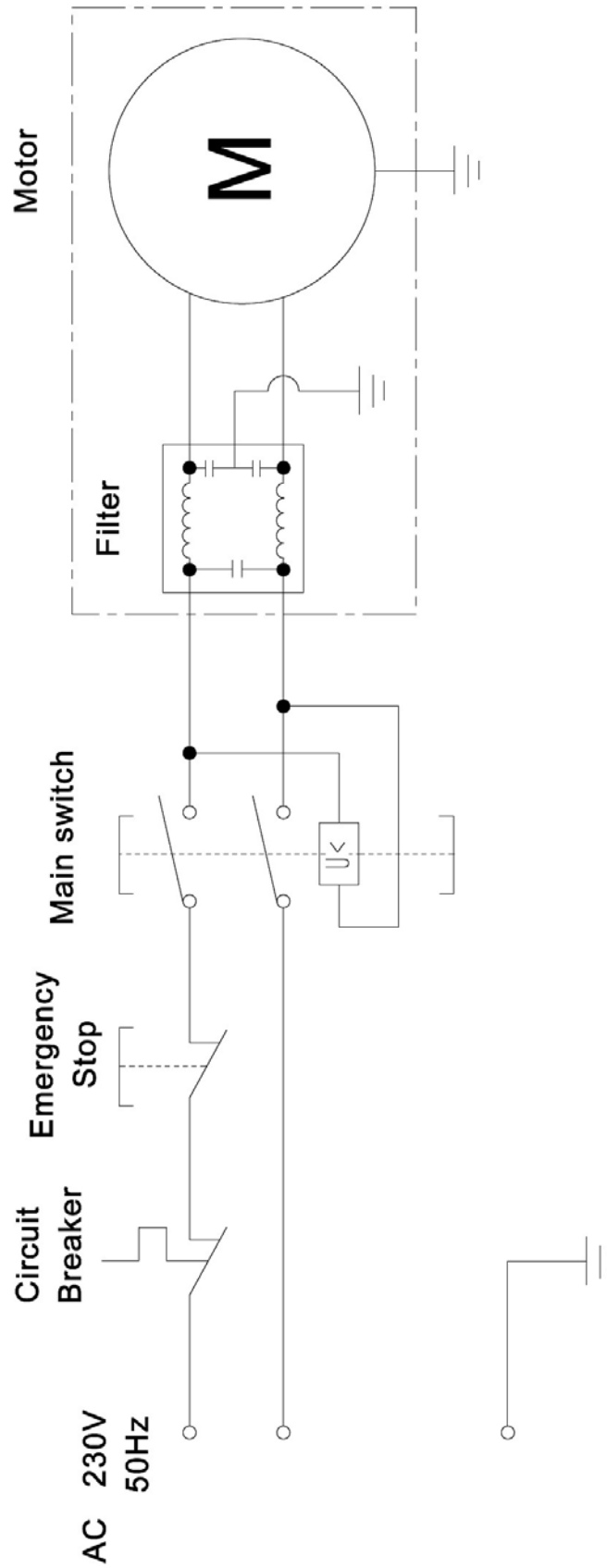


Fig. 27: Electrical circuit diagram

14 EC Declaration of Conformity

According to machine directive 2006/42/EC Annex II 1.A

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

herewith declares that the following product

Product group: Holzstar® Woodworking machines

Maschine type: Planer

Designation of the machine: DH 330

Item number: 5904330

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.

Relevant EU Directives: 2014/30/EU EMC-Directive
2012/19/EU WEEE-Directive

The following harmonized standards have been applied:

EN 60204-1:2019-06 Safety of machines - Basic concepts, general principles for design - Part 1: General requirements

DIN EN ISO 12100:2011-03 Safety of machinery. General principles for design. Risk assessment and risk reduction (ISO 12100:2010)

EN 861:2012-09 Safety of woodworking machines - Surface planing and thicknessing machines

Person responsible for the documentation: Kilian Stürmer, Stürmer Maschinen GmbH,
Dr.-Robert-Pfleger-Str. 26, D-96103 Hallstadt

Hallstadt, 18.02.2021



Kilian Stürmer
Managing Director



15 Notes

