

Planer Quick Start Guide

This planer runs on 220V (208V really because, 3 phase power).

Don't plane anything that might have metal in it, like nails, staples or screws. Any metal that hits the blades ruins them.

Do not plane anything that is very thin, 3/16" is the minimum thickness.

Only plane natural wood, no plywood, MDF or other composites.

The off button has to be twisted to reset itself.

Please read the next 10 pages of this guide to gain an understanding of the operation of the planer itself.

The full manual is available online and a paper copy is here in the shop.

This SOP compiled by @pberglund

Internal Components

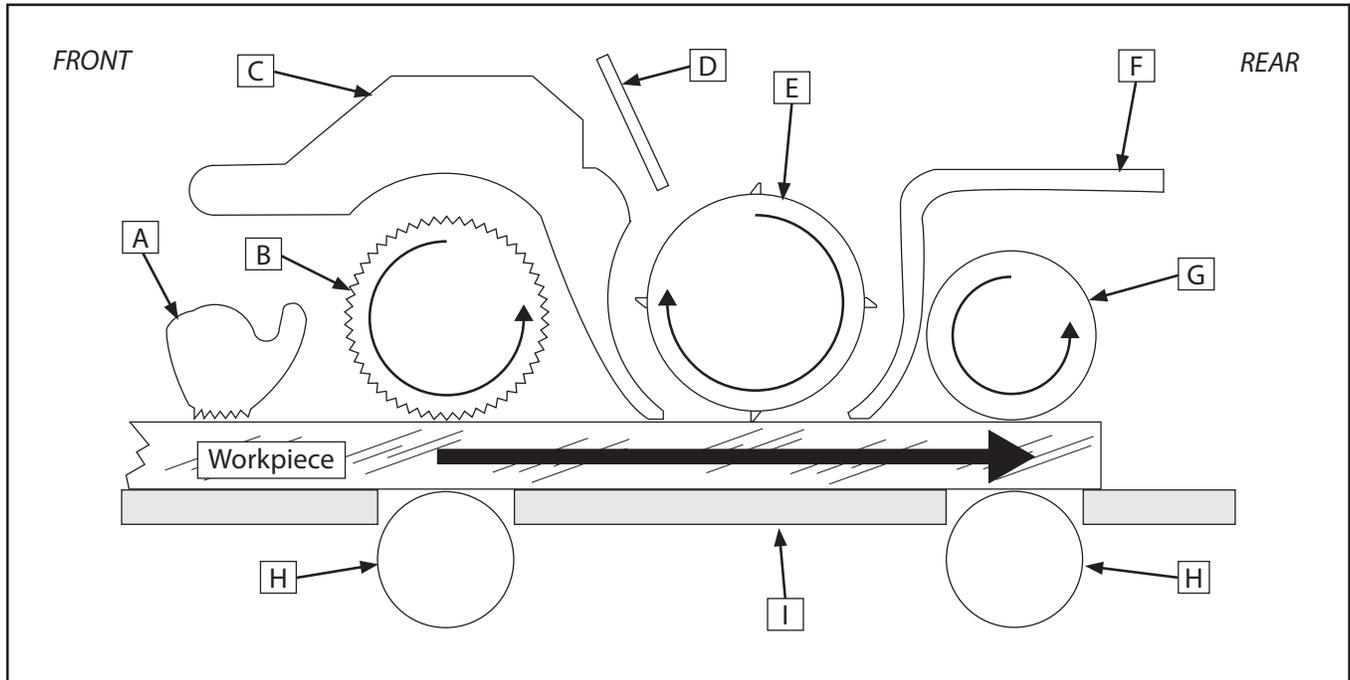


Figure 4. Workpiece path and major planing components (side cutaway view).

- A. Anti-Kickback Fingers:** Provide additional safety for the operator.
- B. Serrated Infeed Roller:** Pulls the workpiece toward the cutterhead.
- C. Chip Breaker:** Breaks off chips created by the cutterhead to prevent tear out and diverts the chips to the dust hood.
- D. Chip Deflector:** Directs chips into the dust hood.
- E. Cutterhead:** Holds the knives/indexable carbide inserts that remove material from the workpiece.
- F. Pressure Bar:** Stabilizes the workpiece as it leaves the cutterhead and assists in deflecting wood particles toward the dust hood (ST1014 only).
- G. Outfeed Roller:** Pulls the workpiece through the planer.
- H. Table Rollers:** Provide upward pressure on the workpiece, enabling the feed rollers to pull the workpiece along.
- I. Planer Table:** Provides a smooth and level path for the workpiece as it moves through the planer.

Please read the general planer safety guidelines on the next two pages.

WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Planers

WARNING

Amputation, serious cuts, entanglement, or death can occur from contact with rotating cutterhead or other moving parts! Flying chips can cause blindness or eye injuries. Workpieces or knives thrown by cutterhead can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed hazards and warnings below.

KICKBACK. Know how to reduce the risk of kickback and kickback-related injuries. “Kickback” occurs during the operation when the workpiece is ejected from the machine at a high rate of speed. Kickback is commonly caused by poor workpiece selection, unsafe feeding techniques, or improper machine setup/maintenance. Kickback injuries typically occur as follows: (1) operator/bystanders are struck by the workpiece, resulting in impact injuries (i.e., blindness, broken bones, bruises, death); (2) operator’s hands are pulled into blade, resulting in amputation or severe lacerations.

AVOID CONTACT WITH MOVING PARTS. Never remove guards/covers or reach inside the planer during operation or while connected to power. You could be seriously injured if you accidentally touch the spinning cutterhead or get entangled in moving parts. If a workpiece becomes stuck or sawdust removal is necessary, turn planer **OFF** and disconnect power before clearing.

DULL/DAMAGED KNIVES/INSERTS. Only use sharp, undamaged knives/inserts. Dull or damaged knives/inserts increase the risk of kickback.

INSPECTING STOCK. To reduce the risk of kickback injuries or machine damage, thoroughly inspect and prepare the workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or foreign material. Workpieces with minor warping should be jointed first or planed with the cupped side facing the table.

BODY PLACEMENT. Stand to one side of planer during the entire operation to avoid getting hit if kickback occurs.

GRAIN DIRECTION. Planing across the grain is hard on the planer and may cause kickback. Plane in the same direction or at a slight angle with the wood grain.

PLANING CORRECT MATERIAL. Only plane natural wood stock with this planer. DO NOT plane MDF, OSB, plywood, laminates or other synthetic materials that can break up inside the planer and be ejected towards the operator.

LOOKING INSIDE PLANER. Wood chips fly around inside the planer at a high rate of speed during operation. To avoid injury from flying material, DO NOT look inside planer during operation.

CUTTING LIMITATIONS. To reduce the risk of kickback hazards or damage to the machine, do not exceed the maximum depth of cut or minimum board length and thickness found in the Data Sheet. Only feed one board at a time.

INFEED ROLLER CLEARANCE. The infeed roller is designed to pull material into the spinning cutterhead. To reduce the risk of entanglement, keep hands, clothing, jewelry, and long hair away from the infeed roller during operation.

FEED WORKPIECE PROPERLY. To reduce the risk of kickback, never start planer with workpiece touching cutterhead. Allow cutterhead to reach full speed before feeding, and do not change feed speed during cutting operation.

WORKPIECE SUPPORT. To reduce the risk of kickback, always make sure workpiece can move completely across table without rocking or tipping. Use auxiliary support stands for long stock.

SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem **BEFORE** operating the machine again. The Troubleshooting table in the **SERVICE** section of this manual can help.

WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools and loose objects away from machine.
2. Push STOP button in.
3. Connect machine to power supply.
4. Twist STOP button clockwise until it springs out (see **Figure 21**). This resets the switch so the machine can start.

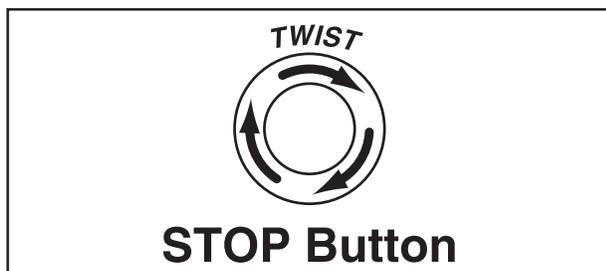


Figure 21. Resetting the switch.

5. Press START button to turn machine **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.
6. Press STOP button to turn machine **OFF**.
7. WITHOUT resetting STOP button, try to start machine by pressing the START button. The machine should not start.

—If the machine *does not* start, the STOP button safety feature is working correctly. Congratulations! The Test Run is complete.

—If the machine *does* start (with the STOP button pushed in), immediately disconnect power to the machine. The STOP button safety feature is not working correctly and must be replaced before further using the machine. Call Tech Support for help.

NOTICE

After approximately 16 hours of operation, V-belts will stretch and seat into pulley grooves and need to be properly tensioned to avoid severely reducing life of V-belts. Refer to Tensioning/Replacing V-Belts on Page 36 for detailed instructions.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

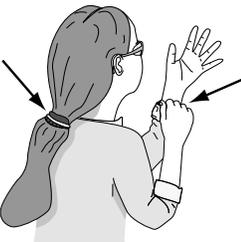
Step-by-step instructions for these adjustments can be found in the **SERVICE** section starting on **Page 39**.

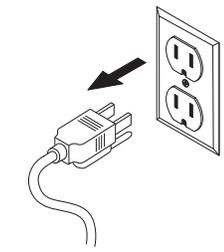
Factory adjustments that should be verified:

- Check V-belt tension (**Page 37**).
- Adjusting table height (**Page 42**).
- Pulley alignment (**Page 49**).

OPERATIONS

⚠ WARNING Eye injuries or respiratory problems can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.		
		

	⚠ WARNING Loose hair/clothing could get caught in machinery and cause serious personal injury. Keep clothing and long hair away from moving machinery.
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	⚠ WARNING DO NOT investigate problems or adjust the lathe while it is running. Wait until the machine is turned OFF, unplugged and all working parts have come to a complete stop before proceeding!
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Overview

This machine will perform many types of operations beyond the scope of this manual. Many of these can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

The overview below provides the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand. Due to its generic nature, this overview is **NOT** intended to be an instructional guide.

To complete a typical operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for planing.
2. Puts on safety glasses or face shield, a respirator, and ear protection.
3. Places workpiece on table with flat side down and correctly adjusts table height for workpiece thickness and depth of cut.

—If workpiece is bowed, operator surface planes workpiece on a jointer until one side is flat. Doing so ensures that it sits solidly on planer table during operation.

4. When all safety precautions have been taken, turns planer **ON**.
5. Stands to one side of planer path to reduce risk of kickback injuries, then feeds workpiece into planer until infeed roller grabs it.

Note: Infeed and outfeed rollers control feed rate of workpiece as it passes through planer. Operator does not push or pull on workpiece.

—If cut is too deep and bogs down planer, operator immediately reduces depth of cut.

6. Once workpiece is clear of outfeed roller and stops moving, operator removes workpiece from outfeed table and measures workpiece thickness. If further planing is required, operator raises table slightly (approximately $\frac{1}{4}$ to $\frac{1}{2}$ turn of the handwheel), then feeds workpiece into front of planer again.
7. Operator repeats this process until desired thickness is achieved, then turns machine **OFF**.

Workpiece Inspection

Some workpieces are not safe to use or may require modification before they are. **Before cutting, inspect all workpieces for the following:**

- **Material Type:** This machine is only intended for workpieces of natural wood fiber. Attempting to use workpieces of any other material that may break apart during operation could lead to serious personal injury and property damage.
- **Foreign Objects:** Inspect lumber for defects and foreign objects (nails, staples, embedded gravel, etc.). If you have any question about the quality of your lumber, DO NOT use it. Remember, wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.
- **Large/Loose Knots:** Loose knots can become dislodged during operation. Large knots can cause kickback and machine damage. Always use workpieces that do not have large/loose knots.
- **Wet or "Green" Stock:** Avoid using wood with a high water content. Wood with more than 20% moisture content or wood exposed to excessive moisture (such as rain or snow), will cut poorly and cause excessive wear to the machine. Excess moisture can also hasten rust and corrosion of the machine and/or individual components.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!
- **Minor Cupping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table. On the contrary, a workpiece supported on the bowed side will rock during operation and could cause severe injury from kickback.

Wood Types

The species of wood, as well as its condition, greatly affects the depth of cut the planer can effectively take with each pass.

The chart in the figure below shows the Janka Hardness Rating for a number of commonly used species. The larger the number, the harder the workpiece, and the less material should be removed in any one pass for good results.

Note: *The Janka Hardness Rating is expressed in pounds of force required to embed a 0.444" steel ball into the surface of the wood to a depth equal to half the ball's diameter.*

Species	Janka Hardness
Ebony	3220
Red Mahogany	2697
Rosewood	1780
Red Pine	1630
Sugar Maple	1450
White Oak	1360
White Ash	1320
American Beech	1300
Red Oak	1290
Black Walnut	1010
Teak	1000
Black Cherry	950
Cedar	900
Sycamore	770
Douglas Fir	660
Chestnut	540
Hemlock	500
White Pine	420
Basswood	410
Eastern White Pine	380
Balsa	100

Figure 22. Janka Hardness Rating for some common wood species.

Planing Tips

- Inspect your lumber for twisting or cupping, and surface one face on a jointer if necessary before planing workpiece.
- Scrape off all glue when planing glued-up panels. Dried glue can quickly dull knives/inserts.
- DO NOT plane more than one piece at a time.
- Never remove more than the recommended amount of material on each pass. Only remove a small amount of material on each pass when planing wide or dense stock.
- Support the workpiece on both ends. Get assistance from another person if you are planing long lumber, or use roller stands to support the workpiece.
- Measure the workpiece thickness with calipers to get exact results.
- Carefully inspect all stock to make sure it is free of large knots or foreign objects that may damage your knives/inserts, cause kickback, or be ejected from the planer.
- When possible, plane equal amounts on each side of the board to reduce the chance of twisting or cupping.
- Use the entire width of the planer to wear knives/inserts evenly. With narrow workpieces, alternate between far left, far right, and the middle of the table. Your knives/inserts will remain sharp much longer.
- To avoid "chip marks," always plane WITH the grain direction of the wood. Never plain cross-grain or end-grain.
- Plane ONLY natural wood fiber. Do not plane wood composites or other materials that could break up in the planer and cause operator injury or damage to planer.
- Always true cupped or warped stock on a jointer before planing.

Cutting Problems

Below is a list of wood characteristics you may encounter when planing. The following descriptions of defects will give you some possible answers to problems you may encounter while planing different materials. Possible solutions follow the descriptions.

Chipped Grain

Problem: Usually a result of cutting against the grain, planing lumber with knots or excessive amount of cross grain, or using dull knives/inserts.

Note: *Some amount of chipping is normal with highly figured wood.*

Solution: Decrease the depth of cut. Reduce the feed rate. Inspect your lumber and determine if its grain pattern is causing the problem. If the lumber does not show substantial crossgrain, inspect your knives/inserts.

Fuzzy Grain

Problem: Usually caused by surfacing lumber with too high of a moisture content. Sometimes fuzzy grain is an unavoidable characteristic of some woods, such as basswood. Fuzzy grain can also be caused by dull knives/inserts.

Solution: Check the lumber with a moisture meter. If moisture is greater than 20%, sticker the lumber and allow it to dry. Otherwise, inspect the knife/insert condition.

Snipe

Problem: Occurs when board ends have more material removed than the rest of the board. Usually caused when the workpiece is not properly supported as it goes through the machine. In many cases, however, a small amount of snipe is inevitable.

Solution: Hold workpiece up slightly as it leaves the outfeed end of the planer. The best way to deal with snipe is by planing lumber longer than your intended work length and then cutting off the excess after planing is completed.

Pitch & Glue Build-up

Problem: Glue and resin buildup on the rollers and cutterhead will cause overheating by decreasing cutting sharpness while increasing drag in the feed mechanism. The result can include scorched lumber, uneven knife/insert marks, and chatter.

Solution: Clean the rollers and cutterhead.

Chip Marks or Indentations

Problem: Chip indentation or chip bruising is the result of wood chips not being thrown away from the cutterhead and out of the machine. Instead they are carried around the cutterhead, deposited on the planed surface and crushed by the outfeed roller. Some of the causes of chip indentation are:

- Wood chips/sawdust not being properly expelled from the cutterhead.
- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (over 20%) or surface moisture (refer to **Page 25**).
- Dull knives.
- Excessive depth of cut.

Solution:

- Use a proper dust collection system; adjust chip deflector in or out as necessary.
- Lumber must be completely dry, preferably kiln-dried (KD). Air-dried (AD) lumber must be seasoned properly and have no surface moisture. DO NOT surface partially-air-dried (PAD) lumber.
- Make sure planer knives/inserts are sharp.
- Reduce depth of cut.

Rippled Cut

Problem: Regularly spaced indentations across face of workpiece are caused by excessive outfeed roller pressure or excessive feed rate.

Solution: Reduce outfeed roller pressure; reduce feed rate.

Depth of Cut

Table Movement per Handwheel Revolution

One Full Revolution..... $\frac{1}{16}$ "

The depth of cut on a planer means the amount of material that is removed from the top of the workpiece as it passes underneath the cutterhead.

The depth of cut is set by adjusting the distance of the table below the cutterhead. This distance is the thickness of the workpiece minus the depth of cut. The planing depth of cut is controlled by using the table height handwheel on the right side of the machine. Rotating the handwheel clockwise raises the table.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than $\frac{1}{16}$ ". A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

The depth of cut can be referenced directly from the inch/millimeter scale on the front of the planer, as shown in **Figure 23**. The range of material thickness that can be planed is $\frac{3}{16}$ "–8".

Note: The scale functions as a general guide only, and is not intended for low-tolerance, precision results.

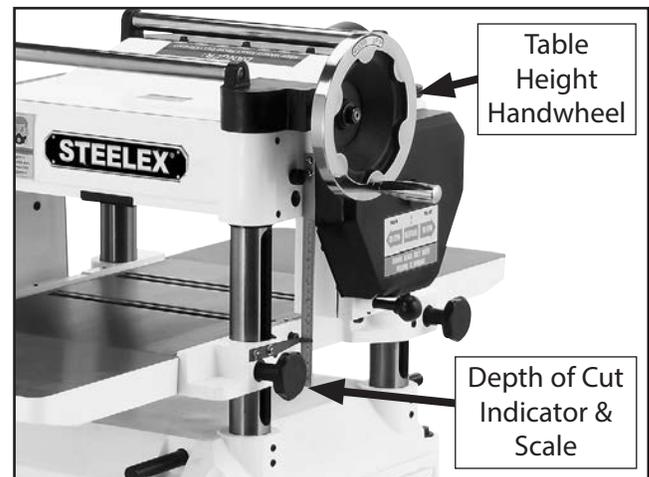


Figure 23. Depth of cut indicator and scale.

Bed Roller Height

Bed Roller Height Range 0.002"–0.020"

The correct height of the bed rollers will vary, depending on the type of material you intend to plane. However, as a general rule, keep the bed roller height within 0.002"–0.020" above the table surface, as illustrated in **Figure 24**.

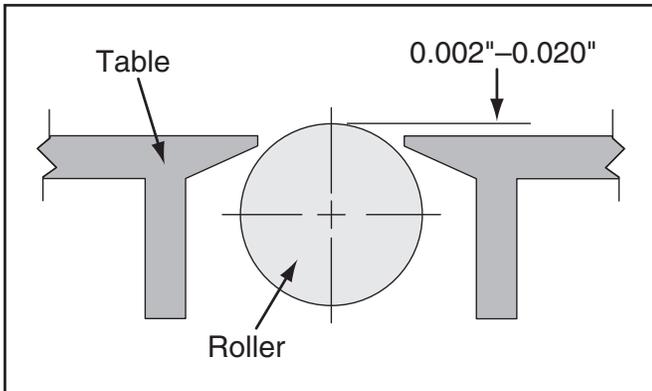


Figure 24. Recommended bed roller height above the table surface.

When planing rough stock, set the rollers high to keep the lumber from dragging along the bed. When planing milled lumber, set the rollers low to help minimize snipe.

To ensure accurate results and make the adjustment process quicker and easier, we recommend using a Rotacator (refer to **Page 32**) to gauge the bed roller height from the table surface. If a Rotacator is not available, a straightedge and feeler gauges can be used, but care must be taken to achieve accurate results.

NOTICE

Bed rollers that are not adjusted to the correct height or out of alignment with each other can cause poor finishes, inconsistent planing thickness, and other undesirable results.

Tools Needed	Qty
Hex Wrench 4mm (ST1007, ST1012)	1
Hex Wrench 3mm (ST1014)	1
Hex Wrench 6mm.....	1
Rotacator	1

To adjust bed rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Completely lower table to give yourself enough room to work.
3. Loosen set screws (see **Figure 25**) above each of four roller adjustment cams (there are two on each side of planer).

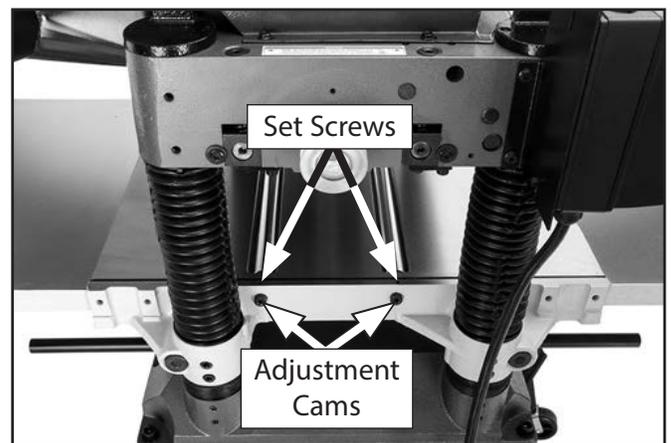


Figure 25. Bed roller height controls.

4. Rotate eccentric adjustment cams to raise or lower bed rollers to desired height above table surface.
5. Verify both sides of each roller are at the same height, then re-tighten set screws to secure in place.
6. Re-check roller heights to make sure they did not change while being secured.
—If roller heights are not correct, repeat this procedure until they are.

Setting Feed Rate

The infeed and outfeed rollers move the workpiece through the planer while keeping it flat and providing a consistent rate of movement. The speed that these rollers move the workpiece through the planer is the feed rate.

Generally, low feed rates are used for dimensioning passes, while higher feed rates are used for finishing passes.

Figure 26 illustrates the three different positions of the feed rate control knob:

- Push knob in to use high feed rate of 30 FPM.
- Pull the knob out to use the low feed rate of 16 FPM.
- Move knob to center position to place gearbox in neutral.

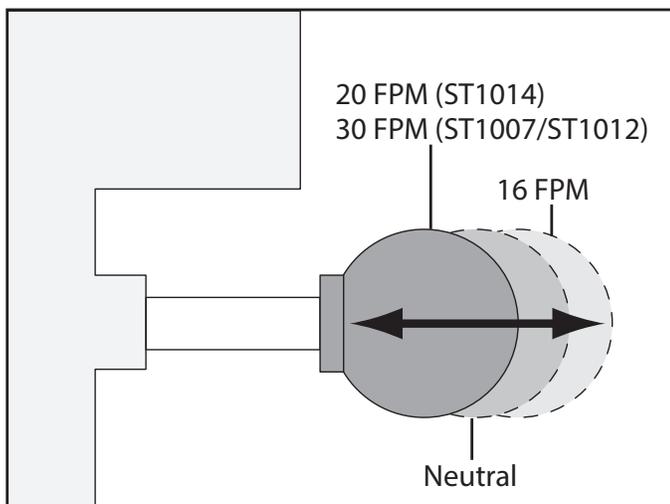
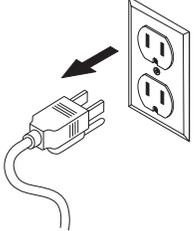


Figure 26. Feed rate control knob positions.

NOTICE

Only change the feed rate when the planer is running, but DO NOT attempt to change the feed rate during any cutting operations or damage to the gearbox will result.

Adjusting/Replacing Knives (ST1007)



⚠ WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

⚠ CAUTION

Cutterhead knives are extremely sharp. Accidental contact with knives can result in severe cuts. Take great caution whenever working with or around cutterhead knives. Wear heavy leather gloves to reduce risk of severe cuts.

NOTICE

To maintain accurate and consistent planing results, we do not recommend sharpening knives yourself. Instead, just replace dull knives or have them professionally sharpened.

Setting the height of the knives correctly is crucial to the proper operation of your planer and is very important in keeping the knives sharp. If one knife protrudes higher than the others, it will do the majority of the work, dull much faster, and produce poor cutting results.

The knife-setting jig that is included with the Model ST1007 is designed to set the knives 0.059" higher than the cutterhead surface.

Note: *If you need to replace or sharpen a knife, you can remove the knife from the cutterhead during **Step 5** of the following procedure. Thoroughly clean out any debris from the knife slots before replacing the knives.*

Tools Needed	Qty
Phillips Screwdriver	1
Open-End Wrench 12, 13mm	1 Ea.
Hex Wrench 3mm.....	1
Knife-Setting Jig	1