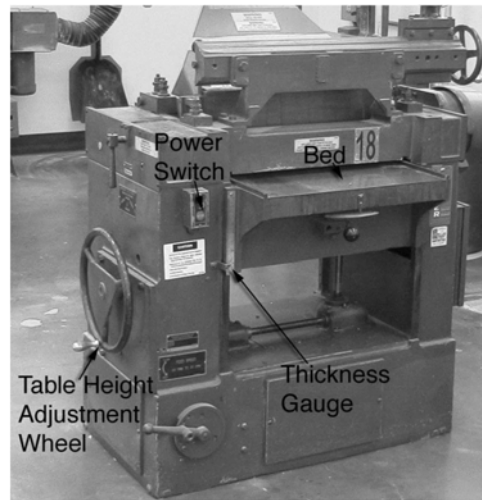


PLANER



The planer is used to smooth lumber to an even thickness. After flattening one side of a board on the jointer, the board is run through the planer with the flat side down on the table, which supports the board and acts as a reference surface. The cutterhead, located above the workpiece, then smooths the opposite face and makes it parallel to the jointed face. The width of the cutterhead, which defines the size of a planer, indicates the widest board that can be surfaced.

1. Do not remove more than 1/32" of wood at one time.
2. Adjust the initial depth of cut to the thickest part of the board.
3. The stock must be longer than the distance between the infeed and outfeed rollers. The minimum length of stock for planing is 12 inches.
4. Do not plane stock to less than 1/4" thick. To plane thinner stock, run it through the planer with a backer board. For this **special setup**, obtain the supervisor's permission.
5. Never put your hands into the planer.
6. If a board needs to be realigned on the table after being gripped by the cutterhead, use care to keep your fingers clear of the table and feed rollers.
7. Never change depth of cut after stock has been started through the planer.
8. Do not plane stock with large cracks or loose knots.
9. Always plane wood with the grain, never across or perpendicular to the grain; the planer will shred the wood.
10. Always ensure that the machine has reached full speed before inserting the wood in the machine.
11. Plane pieces of varying thickness in progressive order, starting with the thickest first.
12. Because of the possibility of flying particles, do not look into the planer while the machine is running. Stand in an upright position and to one side while you are operating this machine.
13. The maximum length of stock which can be surfaced or planed is limited only by the location of walls and other equipment surrounding the planer.

14. A planer will produce two flat, parallel faces only when the surface which was put on the table was flat and smooth to begin with. Planing a warped board will only produce a warped board of even thickness.
15. Kickbacks are infrequent but possible on a planer.
16. Only the supervisor may adjust the speed of the planer's feed rollers.
17. If the stock gets stuck in the planer, do the following, in this order:
 - a) Gently push the stock into the planer; do not overly force the material.
 - b) If that doesn't work, shift the stock at a slight angle while keeping your fingers clear of the table.
 - c) If that doesn't work, lower the table 1/8 turn of the adjustment wheel and repeat steps a and b until the stock starts feeding again. If the stock still will not proceed through the planer repeat steps a, b, and c until the stock starts feeding again. Do not turn the wheel more than 1/8 turn at a time; the feed rollers could lose contact with the stock and a kickback could occur.
 - d) Note: Do not turn the power off while stock is in the planer; you could damage the cutterhead.

PLANER TEST

True or False:

1. _____ It is okay to remove 1/4" of stock on each pass.
2. _____ The length of the stock must be longer than the distance between the in-feed and out-feed rollers.
3. _____ After the in-feed rollers grip the stock, it is safe to look directly into the planer.
4. _____ The thickness setting should be set for the thickest part of the board.
5. _____ Wood may not be safely planed across the grain.
6. _____ It is not possible to get a kickback on the planer.
7. _____ The maximum amount of material to be removed in one pass is 1/32".
8. _____ It is okay to start feeding stock as the planer comes up to speed.