



## OWNER'S MANUAL



## CT055 – 15" THICKNESS PLANER



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## GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating this machine.
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing drill bits, hollow chisels, router bits, shaper heads, blades, knives or making other adjustments or repairs.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **NEVER** make crosscuts with the rip fence in place.
- ❑ **NEVER** attempt cut material that is warped or twisted.
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** use push sticks and featherboards to safely feed your work through the machine.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

## **CT055 THICKNESS PLANER SPECIFIC SAFETY INSTRUCTIONS**

- ❑ If you are not familiar with the operation of a thickness planer, you should obtain the advice and/or instruction from a qualified professional.
- ❑ **Never** reach into or through the throat of the thickness planer. Even with the power turned off, the cutter-knives are very sharp.
- ❑ Keep the cutter head and knives clean and free of tar and pitch.
- ❑ Be sure that the motor switch is properly grounded.
- ❑ Check each and every board to be surfaced for loose knots, nails, screws and any other foreign materials and defects before planing.
- ❑ Turn off power before removing wood shavings and sawdust.
- ❑ Keep hands away from the surface of the wood as it nears the infeed rollers.
- ❑ Make all adjustments with the power OFF.
- ❑ Always keep the CT055 clean and free of sawdust and wood chips. They may contain moisture that could cause the cast-iron surfaces to rust.

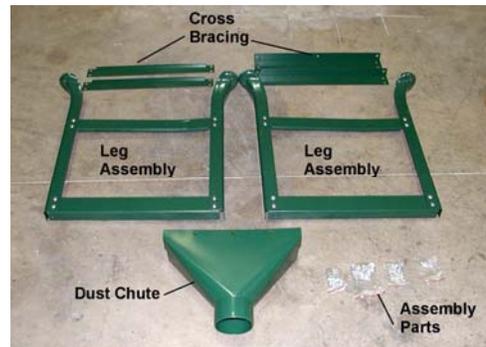
## **CT055 15" THICKNESS PLANER FEATURES**

As part of the growing line of Crafttex woodworking equipment, we are proud to offer the CT055. The Crafttex name guarantees Craft Excellence. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The CT055 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- ❑ Motor: 2HP, 220 volt, single phase.
- ❑ Twin 'V' Belt Drive.
- ❑ Cutter Head Speed: 5,000 RPM's.
- ❑ Feed Rate: Two Speeds, 17 FPM and 20 FPM plus neutral.
- ❑ Capacity: 15" width, 6" height.
- ❑ Maximum Cutting Depth: 3/16".
- ❑ Minimum Thickness: 1/4".
- ❑ Table Size: 20" x 16".
- ❑ Overall Height: 48".
- ❑ Gross Weight: 192 kg.
- ❑ Carton Size: 21" x 26" x 30".
- ❑ All Ball Bearing and Cast-Iron Construction
- ❑ Precision Ground Table with two Rollers and will accept fixed in-feed and out-feed tables.
- ❑ Power Head is supported by 4 heavy-duty columns.
- ❑ Power Head is raised and lowered evenly by 4 chain-driven jack screws.
- ❑ Head Locks front and rear minimize snipe.
- ❑ Oil-Bath Gear Box supplies 2 speeds and neutral to the in-feed and out-feed rollers.
- ❑ Three-Blade Cutter Head for extremely smooth surfacing.
- ❑ Sturdy Steel Stand provides a table height of 29".
- ❑ 4" Dust Hood is included.
- ❑ Knife-Setting Tools are included.

# CT055 15" THICKNESS PLANER CARTON CONTENTS

## Stand, partially assembled



## Small parts and fasteners



## UNPACKING

Your CT055 is shipped with a protective coating on most unpainted parts. Kerosene or a paint thinner should be used to carefully remove all traces of it. Care should be taken when cleaning the cutter head. Packaged small parts should be cleaned as well.

For added protection we suggest that you apply paste wax to the planer table and then buff dry.

## CT055 15" THICKNESS PLANER BASE ASSEMBLY

The CT055 comes complete with a heavy-duty sheet metal stand that requires assembly.



Assemble the stand as illustrated using the 24 nuts and bolts provided. Do not tighten the nuts and bolts at this time.

The sketch shows the correct relationship of the nuts and bolts to the stand.

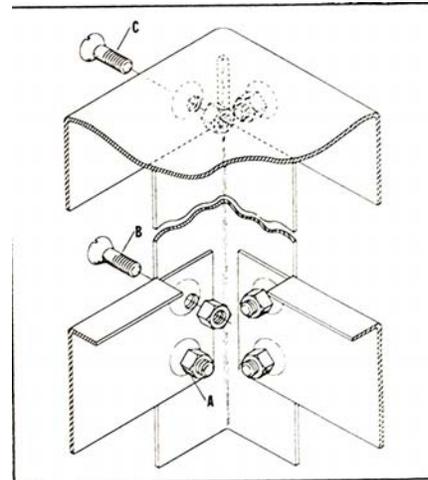
Place the assembled stand on a level surface.

Tighten the nuts and bolts in the following order.

First, tighten the 8 lower tie-bar bolts and nuts.

Secondly, tighten the 8 upper tie-bar bolts and nuts

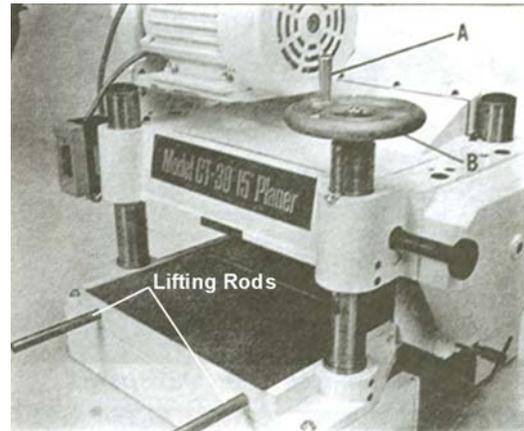
and thirdly, tighten the 8 top shelf nuts and bolts.



## CT055 15" THICKNESS PLANER ASSEMBLY

Remove all of the crating materials and safely discard being careful of the sharp nails that may still be attached to the wooden parts.

The CT055 should now be resting on the base of the crate and wrapped in a protective plastic bag. Roll the bag down so that you can access the four holes to install the lifting rods included in the parts bag.

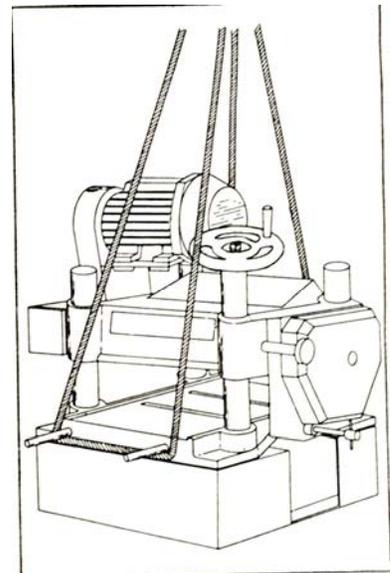


### Assembling CT055 To Base

The CT055 Planer is a very heavy tool (192 kg) and requires mechanical or hydraulic hoisting assistance to place the tool on the base.

Determine the area that the CT055 will be positioned and using a sling with the lifting rods in place, position the planer and fasten it securely to the base.

**CAUTION: The CT055 is a very heavy machine and should be hoisted onto its stand using mechanical or hydraulic assistance.**



Set the planer on the stand so that the mounting holes on the planer and the stand are lined up. Install the four long hex bolts through the holes and using the four nuts and washers. Securely tighten the nuts and bolts.

**NOTE:** If you wish to reposition the CT055 you should do so now while you still have lifting assistance. You may want to set the unit on a mobile base for versatility and this should be done now as well.

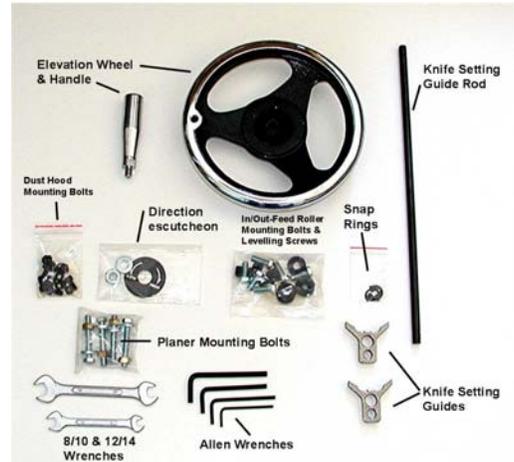
# CT055 15" THICKNESS PLANER ASSEMBLY

## Installing the Table Elevation Wheel & Handle.

Select the Table Elevation Wheel and Handle from the loose parts bag. The elevator post on top of the thickness planer has a temporary strip of tape around it to retain the post key. Remove and discard the tape.

Position the wheel on the post so that the key slides into the key way on the wheel and push it down.

Place the escutcheon on top of the wheel and secure it with the washer and nut from the parts bag.



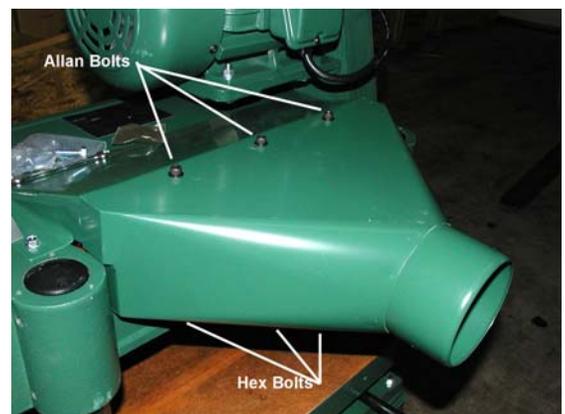
## Installing Elevation Wheel & Handle, Continued

Install the Handle into the threaded hole in the Elevation Wheel and tighten it with the supplied wrench.

## Installing the Dust Hood

Select the Dust Hood from the parts and the Allen bolts, flat washers, lock washers and nuts from the parts bag.

Install the Dust Hood on top of the rear of the CT055 as shown, using the Allen bolts to secure the Dust Hood to the top of the planer. Install the bolts, washers, lock washers and nuts to the unit and securely fasten it. The washers, lock washers and bolts may be installed through the 4" opening and tightened with the supplied Allan wrench.



Three additional hex bolts are provided to secure the bottom flange of the Dust Hood in the threaded holes provided.

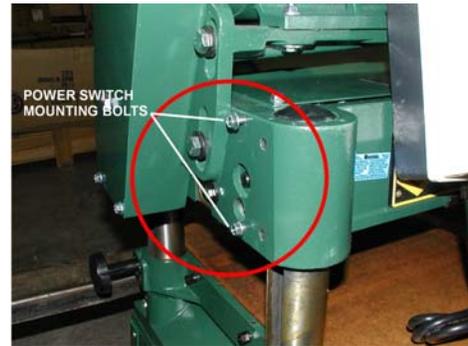
# CT055 15" THICKNESS PLANER ASSEMBLY

## Installing the Magnetic Motor Switch.

The Magnetic Motor Switch on the CT055 is pre-wired and ready to be used on a 220-volt single-phase electrical outlet. Be certain that the outlet is properly grounded.

The cable from the Motor Switch should run under the Thickness Planer and then mounted on the body at the front left side of the Planer.

You will find 2 hex bolts loosely installed in the Motor Switch position. Loosen them and use them to secure the Motor Switch.



## Assembling the Knife-Setting Gauge

From the loose parts select the two gauges, the gauge shaft and the four snap rings.

Install two of the snap rings to the inner grooves of the gauge shaft, install the two gauges and the two remaining snap rings into the outside grooves.

The assembly of the CT055 should now be complete.

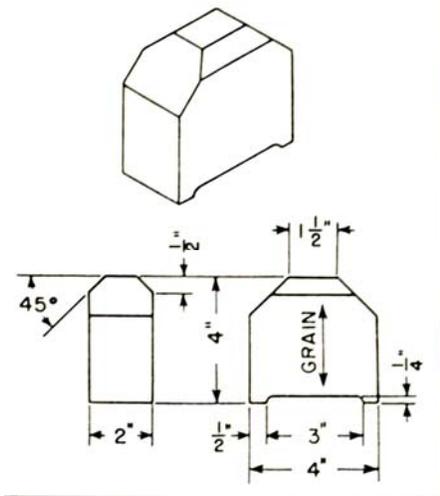


# CT055 15" THICKNESS PLANER PREPARING FOR OPERATION

## Adjusting the CT055 For Use

Craftex takes great pains to ensure that your CT055 Thickness Planer is correctly aligned at the factory and ready for use when you receive it. However, rough handling during shipping may have altered the settings. To ensure the accurate operation of your planer there are some settings that should be verified prior to the initial use of your planer.

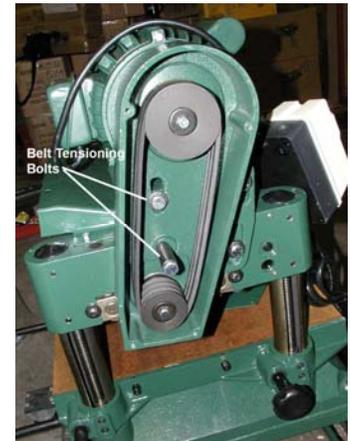
For some adjustments it will be necessary to fabricate a gauge block out of hardwood such as maple or oak as illustrated.



**NOTE: BE SURE THAT THE POWER CORD IS DISCONNECTED BEFORE MAKING ANY ADJUSTMENTS.**

## BELT TENSION

Remove the belt housing by removing the 4 screws on the housing cover. Check the tension of the 3 belts. Should they prove to be too loose, loosen the belt tensioning bolts. Using a hardwood lever, place it under the motor housing and place a wood fulcrum on the body of the machine. Raise the motor until the belts are taut and tighten the tensioning bolts.



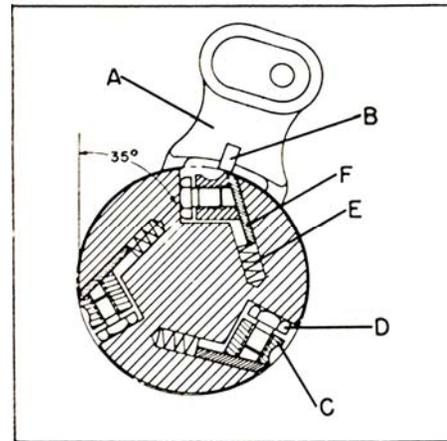
# **CT055 15" THICKNESS PLANER PREPARING FOR OPERATION**

## **KNIFE REPLACEMENT AND ADJUSTMENTS**

Remove the screws holding the knife-head cover and set aside.

Remove the chip ejector.

To check the knives for correct height, use a knife gauge and set it on all 3 knives as in the illustration. When the gauge is properly placed on the cutter head, the knives should 'just' make contact with the center protrusion of the gauge as shown in 'B'.



## **CAUTION: KNIVES ARE VERY SHARP, HANDLE WITH CARE.**

Should an adjustment be required to any or all knives, slightly loosen all of the bolts "D" on the locking bars "C". Loosen these just enough to ease the tension on the cutter head but not to disturb the knife setting. Adjust the knives one at a time. Adjust the knife (or knives) that must be reset by further loosening the 5 bolts on the locking bar. The knives are set on lifter springs "E" and the affected one will raise until it comes in contact with the knife gauge. Slightly tighten the bolts just enough to retain the knife position. If additional knives require adjustment, repeat the above procedure.

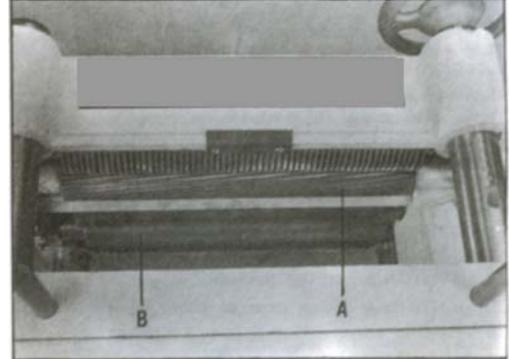
When all knives (if required) are set, tighten all bolts **starting with the end bolts first**. Tighten the center bolts next and then tighten the remaining bolts.

**NOTE:** Should a nick appear on the knives, a slight shifting of one of the knives will correct it.

# CT055 15" THICKNESS PLANER PREPARING FOR OPERATION

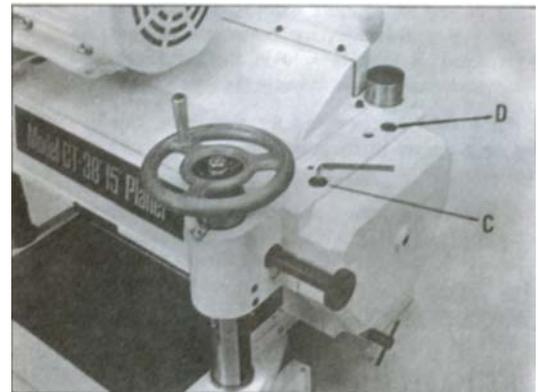
## ADJUSTING THE FEED ROLLER SPRING TENSION

The infeed and the outfeed rollers feed the stock while it is being planed. The rollers are under spring tension and the tension must be sufficient to uniformly feed the stock without slippage and conversely, not too tight so as to cause damage to the board. The tension at both ends of the rollers must be equal.



To adjust the tension of the infeed roller, rotate the Allen screw "C" on both sides of the planer.

To adjust the tension of the outfeed roller, rotate the Allen screw "D" on both sides of the planer.

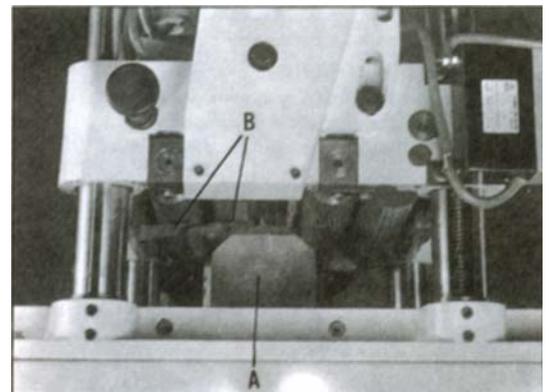


## ADJUSTING THE HEIGHT OF OUTFEED ROLLER

The height of the outfeed roller is pre-set at the factory at 1mm below the knife-edge.

To adjust the outfeed roller, proceed with the following steps: Confirm that all 3 knives have been properly adjusted (see Knife Adjustment And Replacing above).

Place the shop-built hardwood gauge block "A" on the planer table surface directly below the cutter head as shown. **Carefully (the knives are very sharp) rotate the cutter head by hand so that one of the knife edges is at its lowest position.**

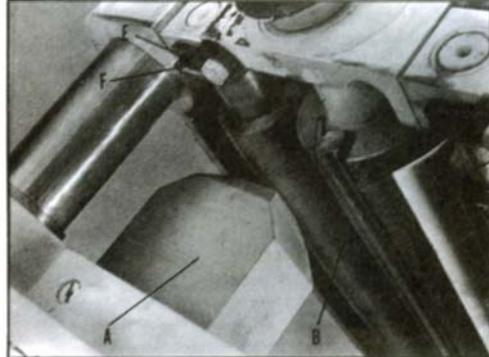


## **CT055 15" THICKNESS PLANER PREPARING FOR OPERATION**

Using a 1mm feeler gauge "B" held in place over the top surface of the gauge block, raise (or lower) the planer table until the knife edge *just* touches "C" the feeler gauge. **Do not raise or lower the planer table any further until the outfeed roller is adjusted.**

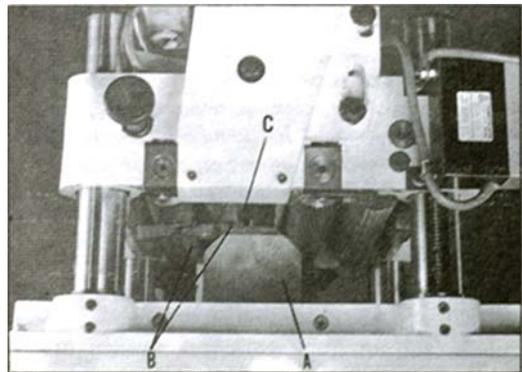
Move the gauge block "A" under one end of the outfeed roller "B". The outfeed roller should *just* touch the top of the gauge block. Should an adjustment be required, loosen locknut "C" and turn screw "D" until the roller *just* touches the gauge block. Tighten the locknut.

Repeat this procedure on the opposite end of the outfeed roller.



### **Adjusting Chipbreaker**

The chipbreaker is located on top of the planer and extends down around the front of the cutter head. The chipbreaker raises as the stock is fed through the planer and 'breaks or curls' the wood chips from the planer much the same as the iron on a hand plane. The bottom of the chipbreaker must be parallel to the knives and set 1mm below them.



To check and adjust the chipbreaker proceed with the following steps.

Confirm that all 3 knives have been properly adjusted (see Knife Adjustment and Replacing above).

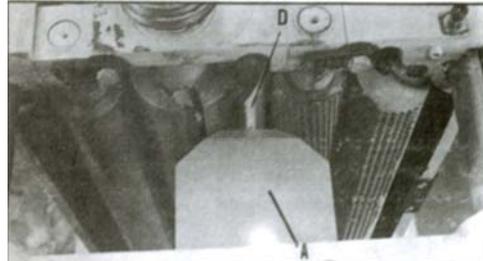
Place the shop-built hardwood gauge block "A" on the planer table "B" directly below the cutter head "C" as shown.

**Carefully, the planer knives are very sharp. Rotate the cutter head by hand so that one of the knives is at the lowest position.**

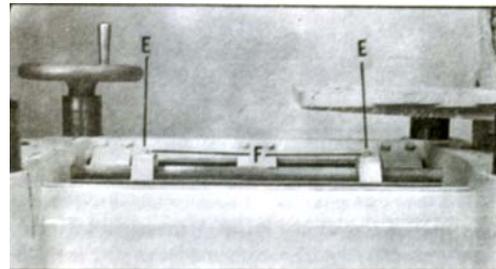
## **CT055 15" THICKNESS PLANER PREPARING FOR OPERATION**

Raise or lower the planer head and use an 0.40 feeler gauge on top of the gauge block. The knife-edge should *just* touch the feeler gauge. **Do not raise or lower the planer head until the chipbreaker is adjusted.**

Move the gauge block "A" (without the feeler gauge) under one end of the chipbreaker "D". the chipbreaker should *just* touch the gauge block. Repeat this step at the other end as well.

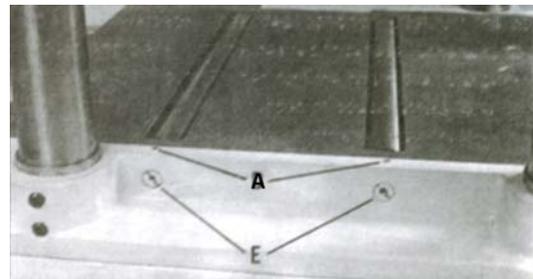


Should an adjustment be required, remove the knife cover plate on top of the planer and loosen nuts "F" and rotate screws "E" until the bottom of the chipbreaker *just* touches the gauge block. Re-tighten the nuts and replace the knife cover.



### **Adjusting Table Rollers**

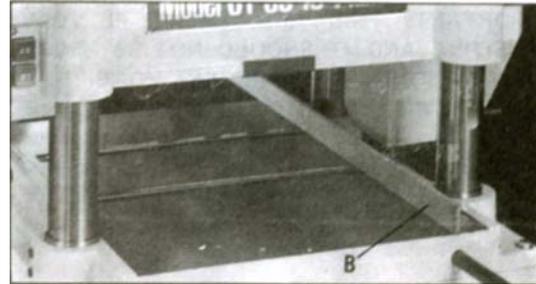
There are two table rollers "A" on the CT055 to aid in the feeding of the stock by reducing friction. These rollers are factory set for average planing and are set flush with the planer table surface. If you are planing *rough* lumber on a constant basis you may want to raise the rollers to their 'High' position to further reduce friction. Conversely, if you are planing finished lumber you will want the rollers set to the 'Low' position. The following procedure shows you how to change these settings.



## **CT055 15" THICKNESS PLANER PREPARING FOR OPERATION**

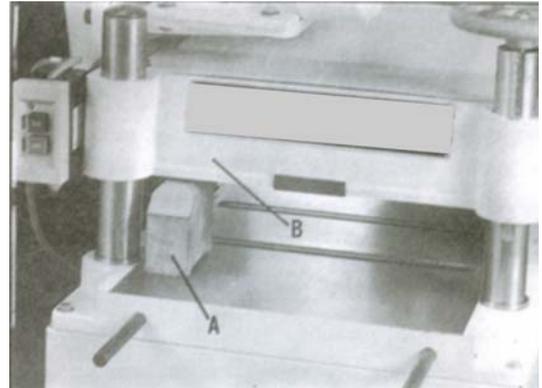
**Disconnect the power cord.**

Lay a straightedge "B" across both rollers and rotate the screws "E" to raise or lower the rollers on that side of the table. Repeat the process on the other side of the table, being particularly careful to ensure that the rollers are always parallel to the table surface.



### **Adjusting the Cutter Head Parallel to the Table**

The Cutter Head is set parallel to the planer table and no further adjustment should be required. Should your CT055 be planing a taper, first check to see that the knives are set correctly in the Cutter Head. Then, check to see if the table is set parallel to the Cutter Head as follows:

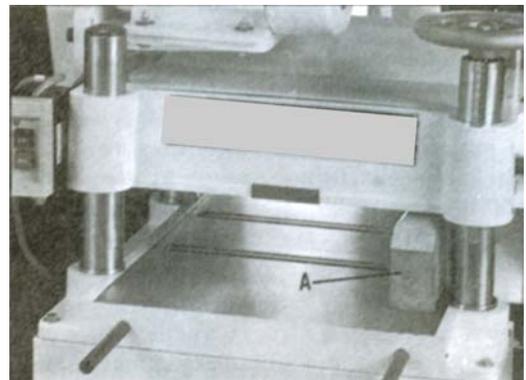


**Disconnect the power source.**

Raise the Cutter Head and then place the gauge block "A" on the infeed table directly under the front edge of the head casting "B". Lower the Cutter Head until the edge *just* touches the gauge block.

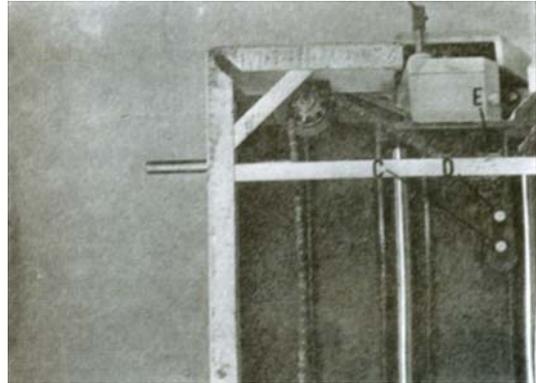
Move the gauge block to the opposite end of the Cutter Head casting. The distance between the casting and the gauge block should be identical.

Repeat the above on the outfeed end of the table.



## **CT055 15" THICKNESS PLANER PREPARING FOR OPERATION**

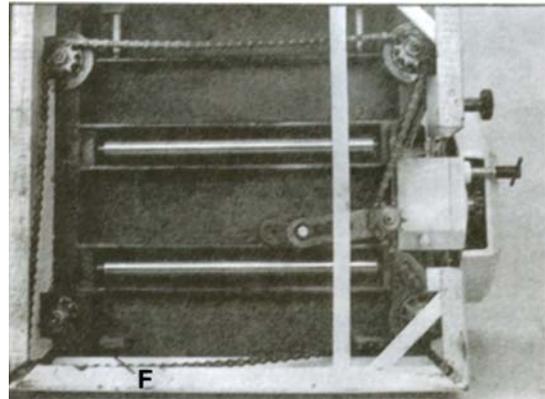
Should the Cutter Head Casting be out of parallel, carefully tilt the planer on its side as illustrated. Remove bolt "C" and loosen bolt "D" which will allow you to move the idler sprocket assembly "E" far enough to release the tension on the chain. Remove the chain from the sprocket on the end of the head casting that must be adjusted. In "F", the chain has been removed.



Turn sprocket "F" by hand to bring that corner into adjustment with the other three corners.

**IMPORTANT: THIS ADJUSTMENT IS VERY SENSITIVE AND IT SHOULD NOT BE NECESSARY TO TURN THE SPROCKET MORE THAN ONE OR TWO TEETH.**

Turning the sprocket clockwise will *decrease* the distance between the table and head casting; counter-clockwise turning will *increase* the distance.



# **CT055 15" THICKNESS PLANER LUBRICATION & MAINTENANCE**

## **Maintaining the CT055 Thickness Planer**

Regular maintenance of the CT055 is the responsibility of the owner to ensure long-term accuracy and the safety of the machine. Proper maintenance is also a condition of the warranty.

### **Lubrication**

The gearbox oil should be changed once a year.

The gearbox drain plug is shown at "A".

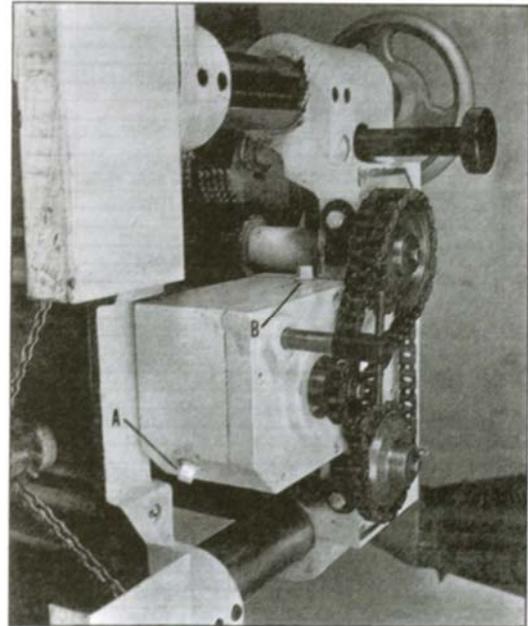
The oil fill and level indicator screw is shown at "B".

Replace the drain plug and fill the gearbox with approved gear oil. Oil should be replaced once a year.

(Use 80-90Wt. gear oil in normal situations, and use 50 Wt. oil for unheated winter shops)

Replace the gearbox cover.

The four table and cutting head raising screws should be lubricated as required using common grease.



### **Waxing the Planer Table**

The CT055 will operate more smoothly if you keep the planer table waxed and polished. Use a quality paste wax and buff to a high shine.

### **Maintaining the Knives**

On occasion the knives on the CT055 may strike a nail or even a grain of sand and nick them. This will leave a raise line on your planed wood. This nick may be cancelled out by simply moving one of the knives slightly left or right.

Refer to **Knife Replacement and Adjusting**.

Even though the knives may appear to be sharp, tar and resin build-up will affect the planing efficiency. Check and clean the knives on a regular basis.

## **CT055 15" THICKNESS PLANER OPERATION**

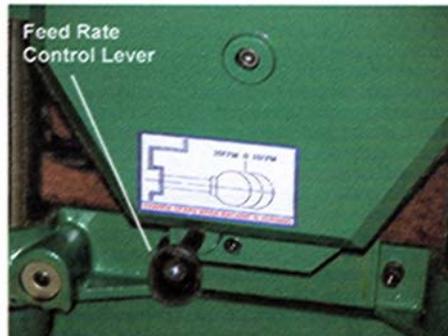
Your CT055 Thickness Planer is a precision instrument that will provide you with many years of excellent service if properly maintained and operated.

Before planing any stock, determine the thickest part of the board and then set the elevation wheel so that no more than 1/8" of material is removed at each pass.

Tighten the elevation post locks to ensure there will be no vertical movement of the cutter head and to assist in the prevention of 'snipe'. To further ensure this, a suitable infeed and outfeed table system should be installed.



Switch on the CT055 and set the gearbox lever to the desired feed rate and then insert the board into the planer. Allow the CT055 to feed the board into the cutter head. NEVER force-feed it or allow the board to be 'pulled' from the outfeed end.



If a board jams, immediately set the gearbox to 'neutral', turn off the power and release the post locks. Remove the board. Raise the cutter head slightly and start again.















