

SETUP & OPERATION MANUAL

FEATURES

Powerful 15 A motor with thermal overload protection.

Front and rear fold-down extension tables for smooth easy stock feeding.

Built-in inset lifting handles & onboard tool storage.

Large depth of cut adjustment handle - one full rotation equals 1/16".

Easy to read thickness indicator with graduated scale in inches and metric.

Safety on/off switch with lock-out key to prevent unauthorized use.

Depth of cut indicator.

Pre-set depth stop for repeat cuts at 1/8", 1/4", 1/2", 3/4", 1", 1 1/4", 1 1/2" and 1 3/4".

Included dust hood has both 2 1/2" and 4" dust outlets.

Helical head with 26 reversible two-sided carbide inserts.

Cutter head supported on 4 posts to ensure head stability

Snipe lock bar on cutter head to help minimize workpiece snipe.

SPECIFICATIONS

- Table area with extensions
33 3/4" x 13" (860 x 330 mm)
- Maximum planing width
13" (330 mm)
- Maximum thickness of stock
6" (152 mm)
- Minimum thickness of stock
1/8" (3 mm)
- Minimum length of stock
5" (127 mm)
- Maximum depth of cut (full width)
1/16" (1.5 mm)
- Number of inserts
26
- Cutter head speed
10 000 rpm
- Feed speed
26 fpm
- Motor
120 V, 15 A
- Weight (shipping/net)
91 lbs (41.5 kg) / 84 lbs (38 kg)

13" HEAVY-DUTY BENCH-TOP PLANER - WITH HELICAL CUTTER HEAD



MODEL
#30-060HC





GENERAL® INTERNATIONAL

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THANK YOU for choosing this General® International model 30-060 13" bench-top planer with helical cutter head. This planer has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this planer as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

DISCLAIMER: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the

unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of planer and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your unit exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® INTERNATIONAL WARRANTY

All component parts of General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® International agrees to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and hold itself harmless for any injury that may result from the improper use of its equipment.

1. Do not operate this planer when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
 2. The work area should be well lit, clean and free of debris.
 3. Keep children and visitors at a safe distance when the planer is in operation; do not permit them to operate the planer.
 4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
 5. **STAY ALERT!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
 6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector. Wear face, eye, ear, respiratory and body protection devices.
 7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the planer is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
 8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
 9. Keep hands well away from inserts and all moving parts. Use a push stick to feed stock, and a brush, not hands, to clear away chips and dust.
 10. Be sure that the inserts are securely installed in the cutter head.
 11. Always use clean, properly sharpened inserts. Dirty or dull inserts are unsafe and can lead to accidents.
 12. Inspect stock and remove all foreign objects before planing. Make sure that any stock you plane is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects that may damage the planer knives. Only process natural solid wood boards. Never plane MDF, particle board, plywood, laminates or other synthetic materials.
 13. Do not push or force stock into the cutter head. The planer will perform better and safer when working at the rate for which it was designed.
 14. Kickback is when the workpiece is ejected at high speeds by the force of the cutterhead. To minimize the risk of injury from kickback, use proper feeding technique and stand to one side, out of the path of a potential kickback.
 15. Select appropriate feed speed for the stock being planed: high speed for softwood and slow for hardwoods.
 16. Place stock firmly against the table and use suitable in-feed and out-feed support if stock is too long.
 17. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the machine again.
 18. Use of parts and accessories NOT recommended by **General® International** may result in equipment malfunction or risk of injury.
 19. Never stand or lean on machinery. Serious injury could result if the tool is tipped over or if the cutting tool is unintentionally contacted.
 20. Always disconnect the tool from the power source before servicing or changing accessories such as knives, or before performing any maintenance or cleaning, or if the machine will be left unattended.
 21. Make sure that the switch is in the "OFF" position before plugging in the power cord.
 22. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
 23. Do not use this planer for any purpose other than its intended use. If used for other purposes, **General® International** disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.
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ELECTRICAL REQUIREMENTS



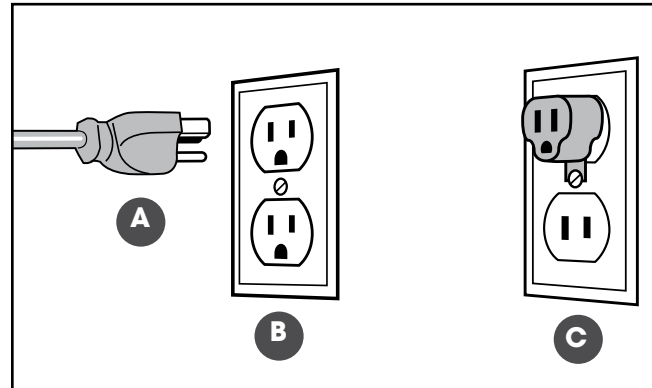
BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.

GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 120 V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug **A** to fit a grounded type receptacle **B**. Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used **C**, it must be attached to the metal screw of the receptacle.

Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.



CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

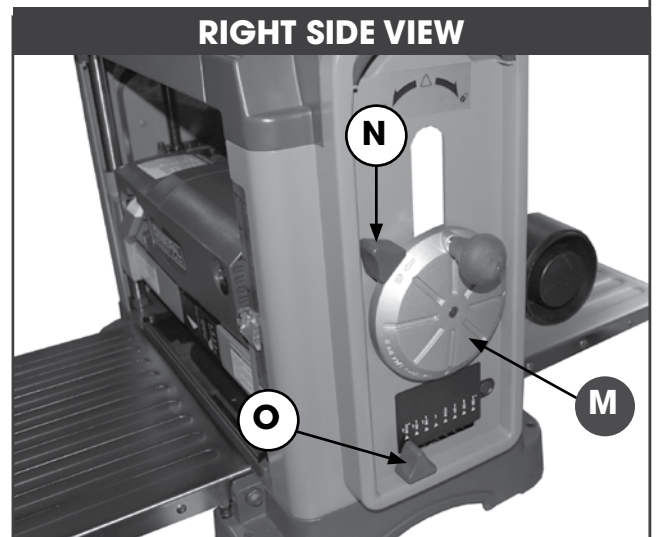
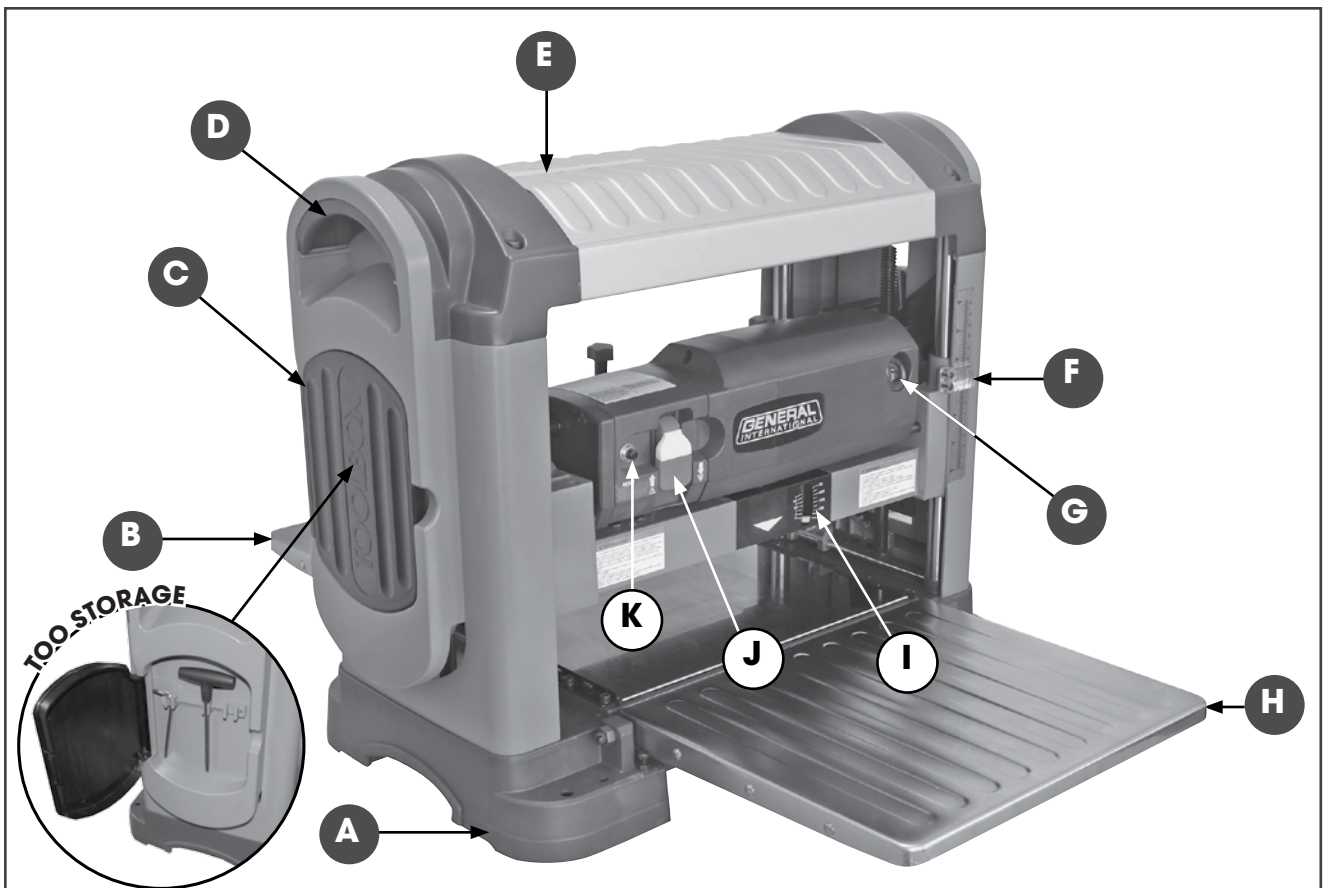
Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD

EXTENSION CORD LENGTH				
AMPERES	50 feet	100 feet	200 feet	300 feet
< 5	18	16	16	14
6 to 10	18	16	14	12
10 to 12	16	16	14	12
12 to 16	14	12	*NR	*NR

*NR = Not Recommended

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- A. BASE
- B. OUTFEED TABLE
- C. TOOL STORAGE
- D. LIFTING HANDLES (2)
- E. STOCK THICKNESS REFERENCE SCALE
- F. PLANING THICKNESS SCALE
- G. MOTOR BRUSH
- H. INFEEED TABLE

- I. DEPTH OF CUT INDICATOR
- J. SWITCH W/SAFETY KEY
- K. CIRCUIT BREAKER
- L. DUST OUTLET
- M. HEIGHT ADJUSTMENT HANDLE
- N. SNIPE LOCK LEVER
- O. PRE-SET DEPTH STOP SELECTOR

UNPACKING

Carefully unpack and remove the unit and its components from the box and check for missing or damaged items as per the list of contents below.

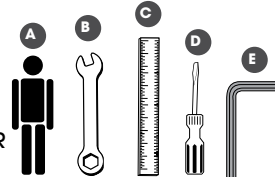
NOTE: PLEASE REPORT ANY DAMAGED OR MISSING ITEMS TO YOUR GENERAL® INTERNATIONAL DISTRIBUTOR IMMEDIATELY.

LIST OF CONTENTS

	QTY
A. PLANER.....	1
B. DUST CHUTE.....	1
C. DUST CHUTE LOCK KNOB*.....	3
D. HANDWHEEL KNOB.....	1
E. TORX KEY**.....	1
F. SWITCH KEY.....	2
G. ALLEN KEY**.....	1
H. CAP SCREW.....	2

ADDITIONAL REQUIREMENTS FOR SET UP

- A. EXTRA PERSON FOR HELP WITH LIFTING
- B. 10 MM WRENCH
- C. STRAIGHTEDGE
- D. FLAT HEAD SCREWDRIVER
- E. 5 MM ALLEN KEY



BASIC FUNCTIONS

This 13" heavy-duty bench-top planer with helical head is designed for thickness planing of solid wood only. The unit is not designed nor should it be used to surface or prepare, plywood, wood paneling, particleboard, MDF nor any other wood based by-products nor any non-wood based materials.

This unit has the capacity to plane boards of up to 13" wide having a maximum thickness of 6" and a minimum thickness of 1/8".

The cutter head of this 30-060HC planer is equipped with 26 easy to change reversible inserts that have two cutting surfaces for double the service life of standard planer knives and has an adjustable 8-position depth stop to allow repeatable planing down to the most commonly used stock thicknesses from 1/8" to 1 3/4".

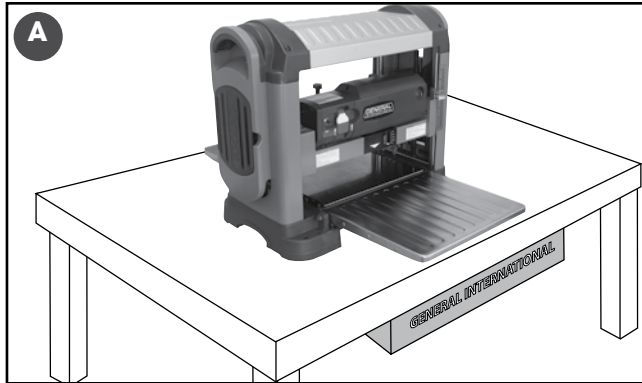
ASSEMBLY INSTRUCTIONS



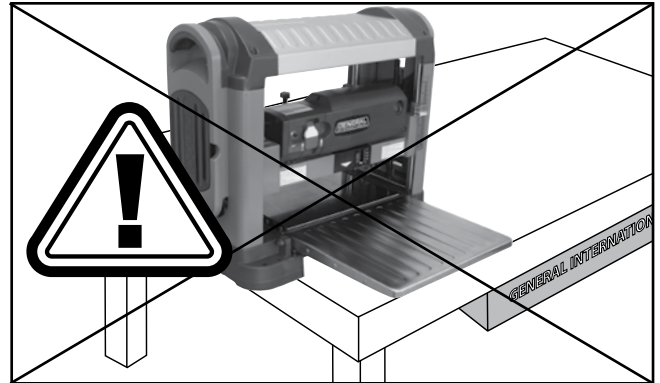
BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.

INSTALLING THE PLANER ON A STABLE SURFACE

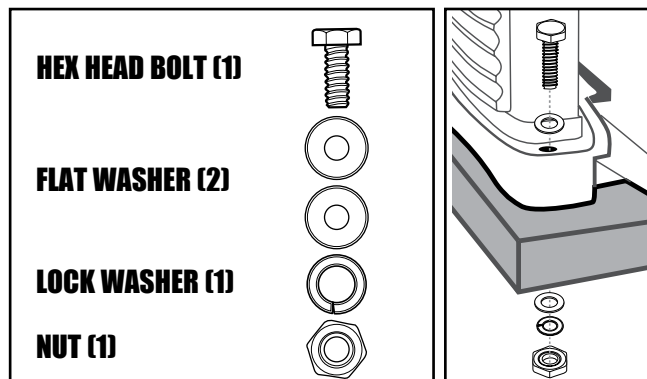
For your convenience this planer is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.



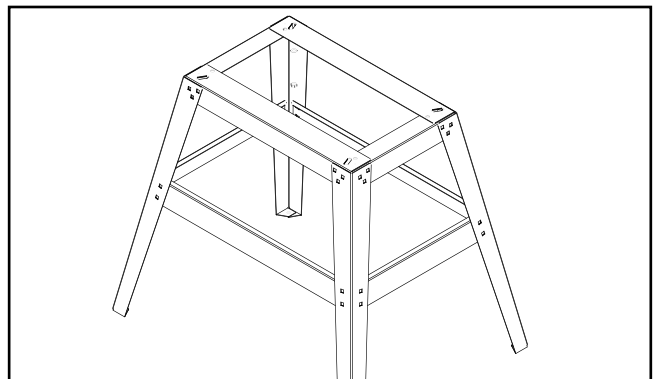
The unit should be immobilized on a flat, level, sturdy and stable surface, able to support the weight of the machine and the workpiece with ease, **A**.



Note: Never install or operate the unit over the edge of a table, workbench or other mounting surface.

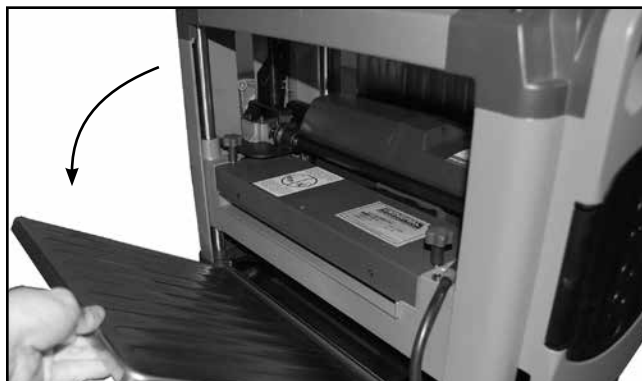


If a permanent shop placement or installation is practical, consider using the mounting holes and drilling matching through holes in your workbench or mounting surface to bolt the planer in place (hardware not included) on your workbench.

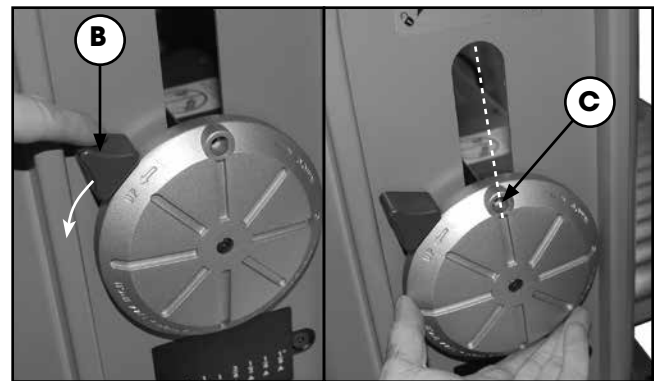


If you prefer an optional steel stand (item #99-700) is available from your local General International dealer.

ATTACH THE DEPTH OF CUT ADJUSTMENT KNOB



1. Lower the outfeed table as shown.



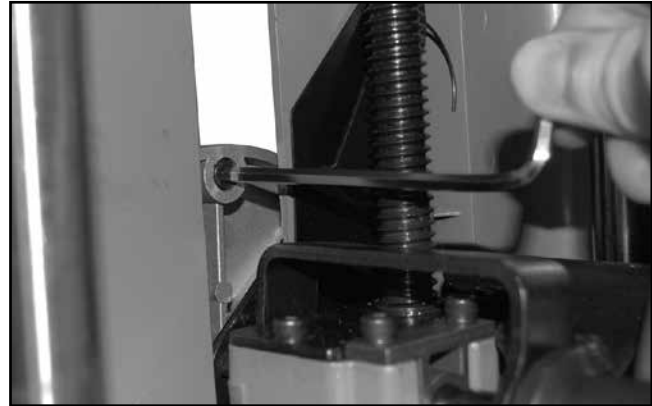
2. Push the lever **B** to the left, then align the mounting hole **C** with the opening in the frame as shown.



BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.



3. Insert the handwheel knob into its mounting hole as shown.



4. Insert the cap screw **A** into the same mounting hole from the other side of the handwheel and tighten the screw with the supplied Allen key.

INSTALLING THE LOCK-OUT KEY



1. Insert the safety key into the switch as shown.

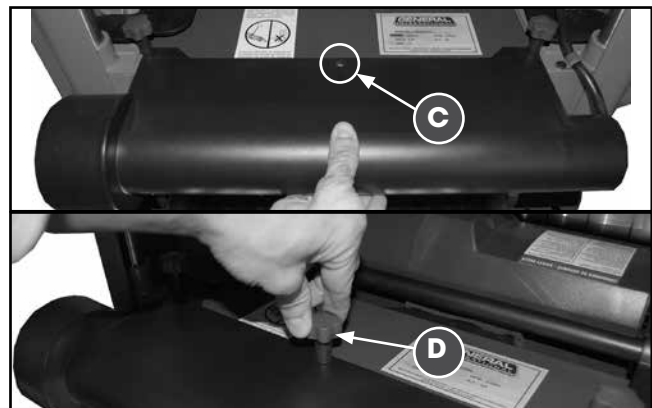


Note: Make sure the switch is in the OFF position.

INSTALLING THE DUST CHUTE



1. Slide the dust chute under the two lock knobs **B** as shown.



2. Align the center mounting hole **C** with the corresponding hole in the machine and then tighten the lock knob **D**. Tighten the two lock knobs **B**.



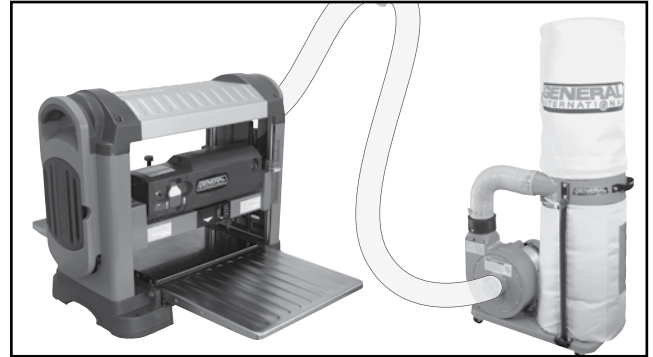
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CONNECTING TO A DUST COLLECTOR

A dust port that fits 2 1/2" & 4" hose is provided to accommodate connection to a dust collector (not included). Be sure to use appropriate sized hose and fittings (not included).

Check that all connections are sealed tightly to help minimize airborne dust.

If you do not already own a dust collection system consider contacting your **General® International** distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at www.general.ca.



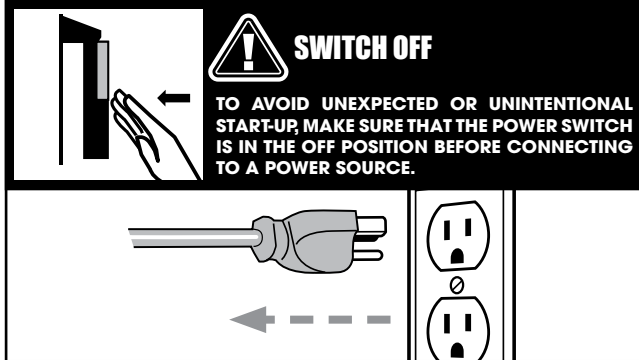
BASIC ADJUSTMENTS & CONTROLS



TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY. TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

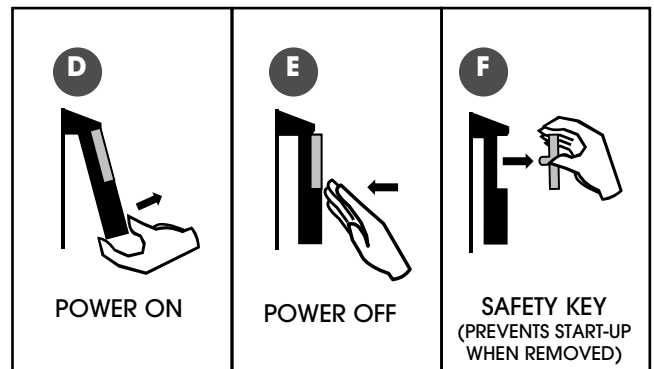
CONNECTING TO A POWER SOURCE

Once the assembly steps have been completed, plug the power cord into an appropriate outlet. Refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed. When operations have been completed unplug the machine from the power source.



Note: Use the cord storage after using the machine.

ON/OFF POWER SWITCH



This planer is equipped with a rocker style ON/OFF switch located on the front left hand side of the planer. To start the planer, insert the lock-out key and pull up on the lower portion of the switch as shown, **D**. To stop the planer, push down on the switch, **E**. To prevent unwanted or unauthorized start-up remove the lock-out key **F** and store it in a safe place, out of the reach of children, whenever the planer is not in use.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

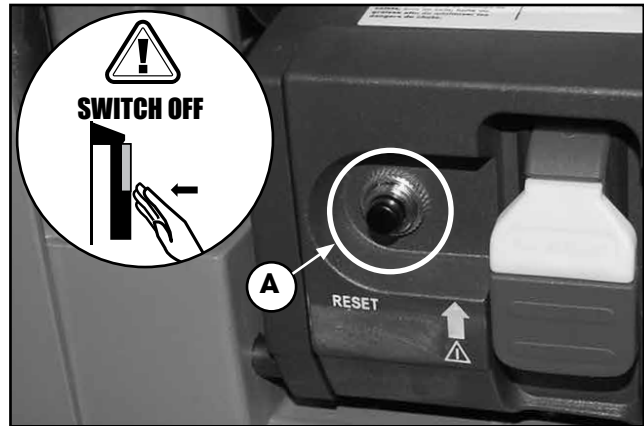
SURGE PROTECTION /CIRCUIT BREAKER



TO AVOID UNINTENTIONAL START-UP BE CERTAIN THAT THE POWER SWITCH HAS BEEN SET TO THE OFF POSITION BEFORE RE-SETTING THE CIRCUIT BREAKER.

The unit is equipped with a circuit breaker located to the left of the power switch, **A**, to protect the motor from power surges or spikes in line voltage. In the event of a power surge, the circuit breaker will be automatically tripped thereby cutting off the power to the motor.

To reset the circuit breaker after it has been tripped; set the power switch to the "off" position and depress the reset button on the circuit breaker, then restart the machine.

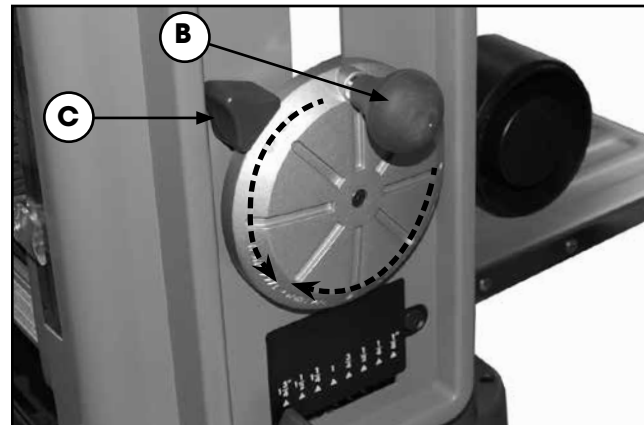


RAISING / LOWERING THE CUTTER HEAD

To adjust the depth of cut, the cutter head assembly can be raised or lowered as needed by rotating the depth of cut adjustment handle **B** located on the right side of the machine.

Before to adjust the depth of cut, make sure the cutter head is unlocked by pushing the lever **C** to the left. In order to minimize workpiece snipe, lock the cutter head by pushing the lever C all the way to the right before to operate the machine.

Note: Each full rotation of the handle will raise or lower the cutter head by 1/16".

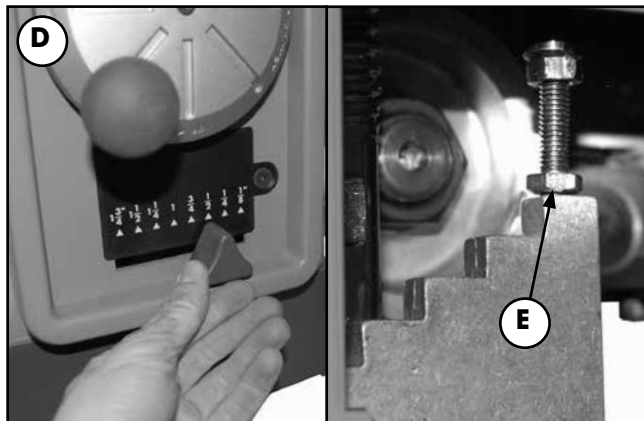


USING AND ADJUSTING THE PRE-SET DEPTH STOP

The adjustable pre-set depth gauge located on the right side of the planer, **D**, allows the user to select one of eight commonly used workpiece final thickness settings.

With the cutter head set slightly above the height of the workpiece press down and rotate the spring loaded adjustment knob to select the desired final thickness setting from either 1 3/4", 1 1/2", 1 1/4", 1", 3/4", 1/2", 1/4", 1/8". This will set the stop to prevent the cutter head from going any lower than the selected thickness, **E**.

Note: Once you have planed the workpiece down to the selected thickness, do not attempt to lower the cutter head further. Forcing the depth of cut handle when the cutter head has bottomed out on the pre-set stop pin will damage the raising mechanism.





MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

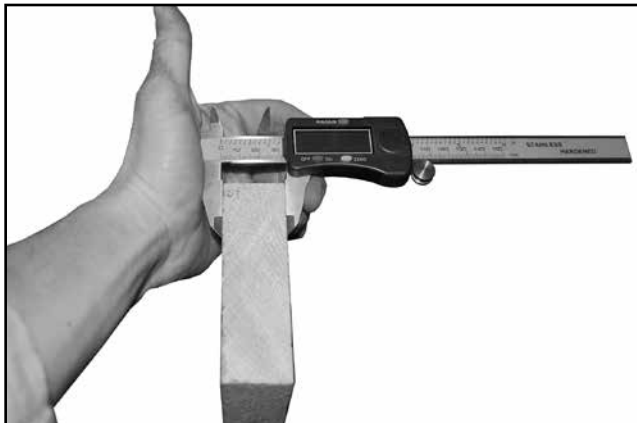
The pre-set depth gauge is adjusted at the factory, **but in some rare cases** it may eventually be necessary to re-adjust, for example after an important maintenance. Any misalignment can be fixed as follows:



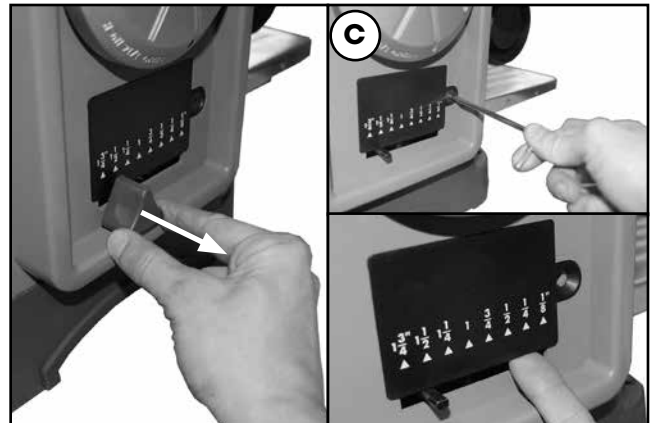
1. Set the pre-set depth stop to the maximum value $1\frac{3}{4}$ ".



2. Plane a board thicker than the pre-set depth stop value until the stop prevents you from lowering the cutter head.



3. Measure the thickness of the board. If the thickness of the board does not match the value indicated by the pre-set depth stop, go to the next step.

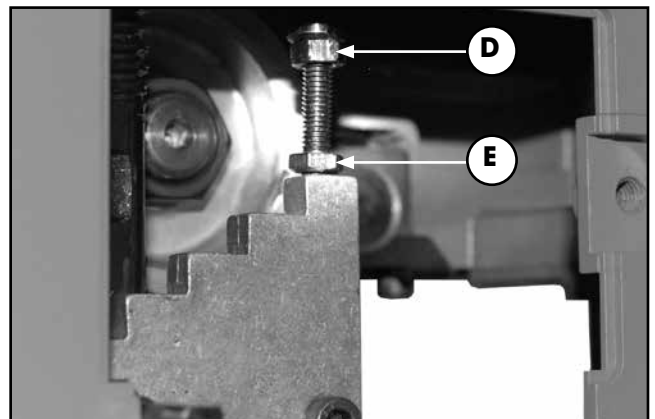


4. Pull back the stop selector to remove it. Remove the screw **C** with the supplied Allen key, then put a finger in the opening and pull back the cover to remove it.

5. Loosen the jam nut **D**.
6. Turn the stop **E** a $\frac{1}{4}$ " turn in the required direction in order to re-adjust the stop and retighten the jam nut **D**.

Note: Lower the stop nut **E** if the board is thicker than the pre-set value. Raise the stop **E** if the board is thinner than the pre-set value.

7. Set the depth stop to the next smaller thickness $1\frac{1}{2}$ ", then plane the board until the cutter head can not be lowered.
8. Measure the thickness of the board to verify that it matches the pre-set value. If needed, repeat operations **5** to **8** until the stop is adjusted correctly.
9. Once the adjustment is finished, re-install the cover, then re-install the selector.



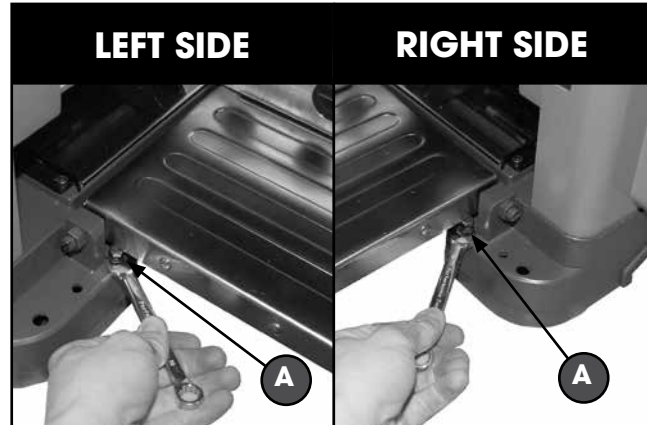


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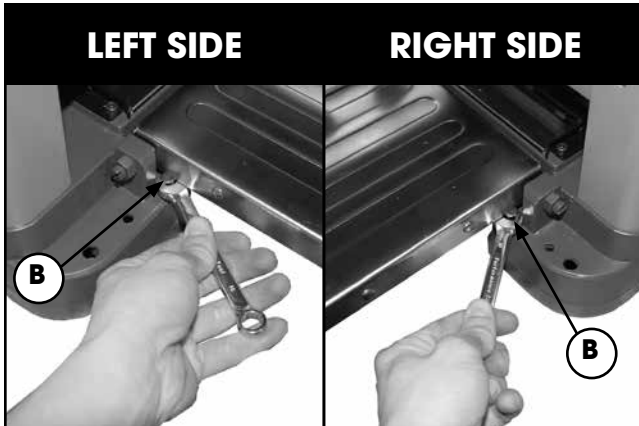
ALIGNING INFEED AND OUTFEED TABLES



1. Place a straightedge across the infeed table and the main table and verify that the two tables are aligned. If the tables are not aligned, go to the next step.



2. Loosen jam nuts **A** located in the front corners of the infeed table.



3. Turn bolts **B** in the required direction until the infeed table is aligned with the main table.

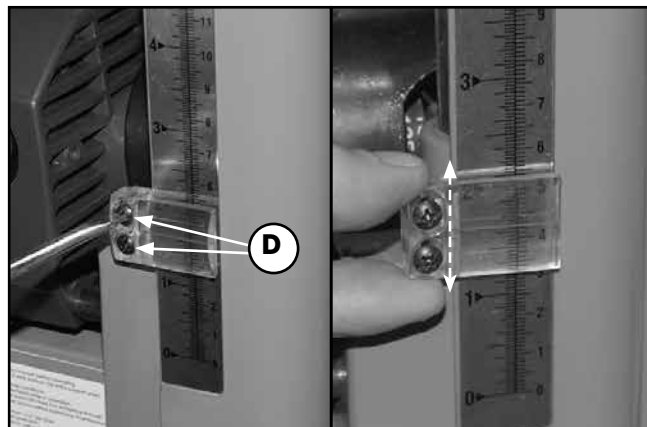


4. Retighten jam nuts **A**, then repeat steps 1 to 4 for the outfeed table.

ADJUSTING THE DEPTH OF CUT SCALE



1. Plane a board and measure its thickness to verify that is the same as the value indicated by the depth of cut scale.



2. Loosen screw **D** with a flat head screwdriver, then set the pointer on the scale so that it indicates the correct thickness. Retighten screws **D** once the adjustment is completed.

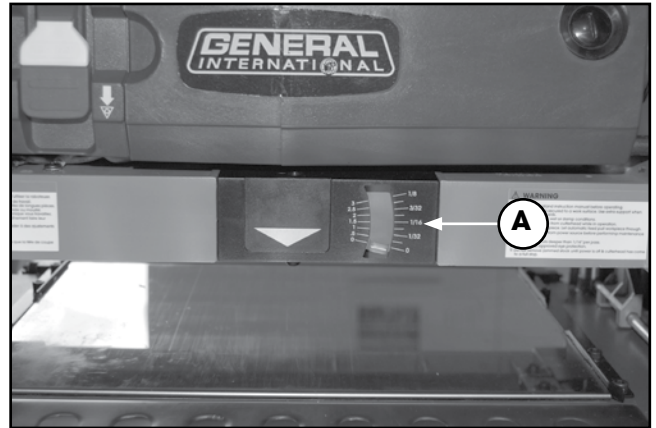


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

DEPTH OF CUT INDICATOR

The depth of cut indicator, **A**, will indicate how much material the cutter head is set to remove from the workpiece for a given pass.

The pointer will read zero until the workpiece engages the front of the cutter head. Place the workpiece under the front of the cutter head and turn the height adjustment handle clockwise until the cutter head makes contact with the workpiece & until the depth of cut indicator shows the reading that matches the desired cut.



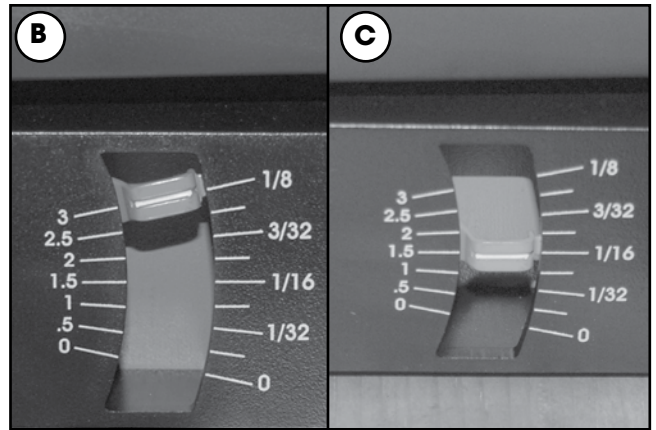
Note: Failure to follow these recommendations will lead to premature blade wear and may cause premature motor failure.

It is recommended that for both hard and soft wood:

For stock up to 6" in width, never remove more than 1/8" per pass, **B**.

For stock of 6"-13" in width, never remove more than 1/16" per pass, **C**.

Removing less material per pass and taking multiple passes is always preferred to more aggressive planing. Advantages include longer blade life, better finish quality (resulting in less time sanding later) and less likelihood of removing too much material causing the workpiece to be too thin for its intended use.



OPERATING INSTRUCTIONS

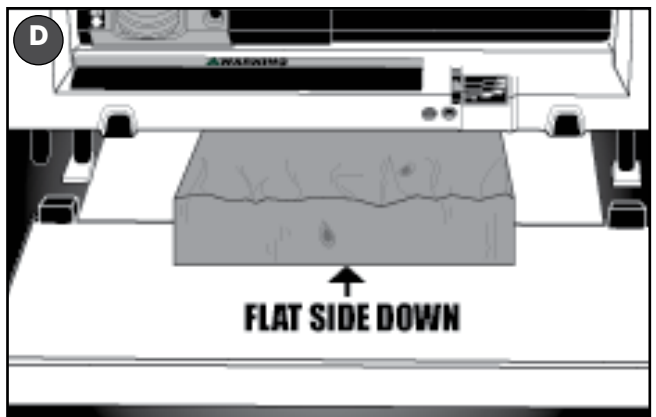
BASIC PRINCIPLES OF PLANING

This thickness planer is designed to remove material from the top face of a board in order to bring the board (or a series of boards) down to a specific desired thickness.

To obtain even, uniform thickness across the length of a board, the stock being planed must have one face that has already been machined perfectly flat (usually on a jointer) and the stock should be fed with this flat face against the table, **D**.

If it is not possible to machine one face perfectly flat before planing, take shallow passes all on the same face of the board until this face has been machined level.

Then the board should be flipped over and the leveled face should be fed face down against the table to allow you to dimension the board to final thickness.





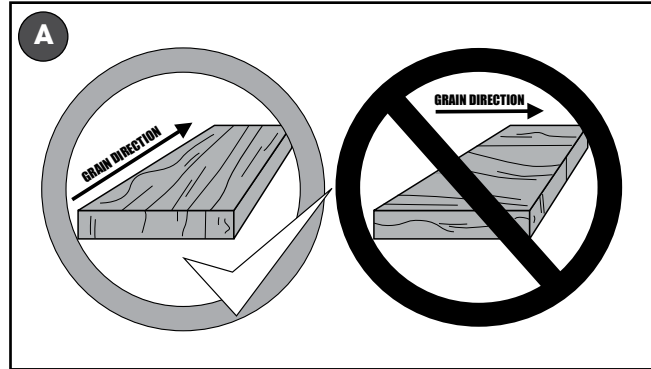
MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

SELECTING BOARDS SUITABLE FOR PLANING

This planer is not intended (and should not be used) to plane any material other than solid wood. The workpiece should always be fed through the planer **in the general direction of the grain in the wood, A.**

Before being fed through the planer all lumber should be inspected for debris and foreign objects such as staples or nails. Foreign objects stuck to, or embedded in your workpiece can be ejected from the machine at high speed and cause serious injury or damage cutter knives. **Make sure to remove all such foreign objects from the wood before running it through the planer.**

Select lumber carefully and avoid workpieces with loose or protruding knots. Workpieces that are twisted, severely deformed or warped should also be avoided. Warped, twisted, damaged or fragile stock runs an increased risk of jamming in or damaging the machine or cutters. There is also a much greater risk of injury to the operator or bystanders from kickback, where the workpiece is forcefully or violently ejected from the machine due to a jam, whenever working with such damaged or warped wood.



RATED LIMITS OF THIS PLANER



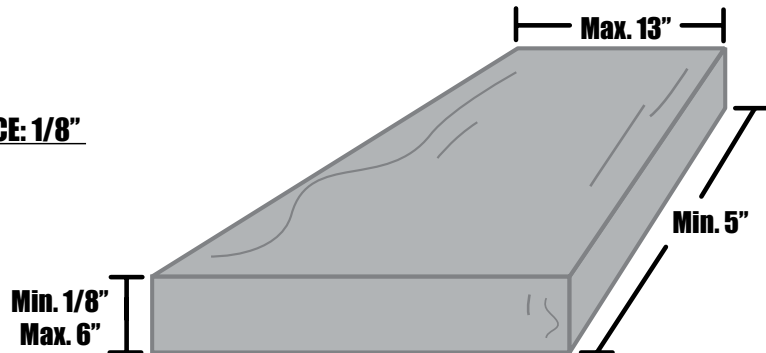
RESPECT THE RATED LIMITS OF THIS MACHINE. IGNORING THESE LIMITS AND FEEDING NON COMPATIBLE STOCK INTO THIS PLANER CAN LEAD TO SERIOUS INJURY TO THE USER OR SHOP BYSTANDERS, AND CAUSE DAMAGE TO THE WORKPIECE AND/OR THE MACHINE. IF THE STOCK YOU WISH TO PLANE DOES NOT MEET OR COMPLY WITH THE LIMITATIONS LISTED BELOW, FIND ANOTHER SAFER WAY TO PERFORM THE REQUIRED TASK.

MAXIMUM PLANING WIDTH: 13"

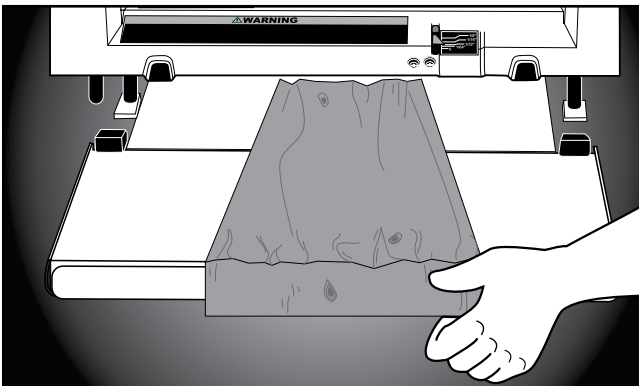
MAXIMUM WORKPIECE THICKNESS: 6"

MINIMUM THICKNESS TO WHICH A WORKPIECE: 1/8"

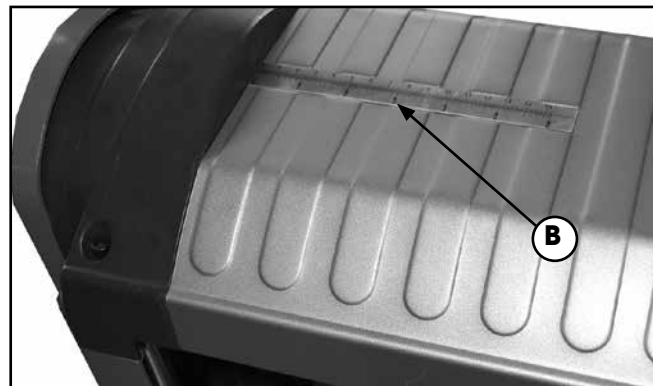
MINIMUM WORKPIECE LENGTH: 5"



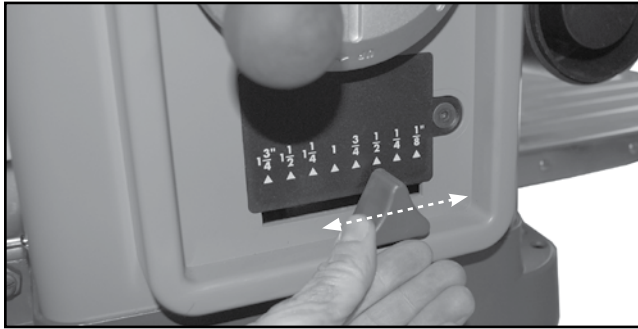
PLANING STEP-BY-STEP



1. With the planer turned off, position the workpiece on the infeed table with the flat face down and the face to be planed facing up.



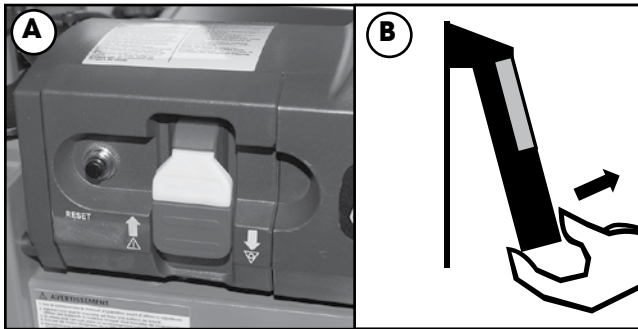
Note: Use the scale B on the top to measure the thickness of the board and make sure it doesn't exceed 6".



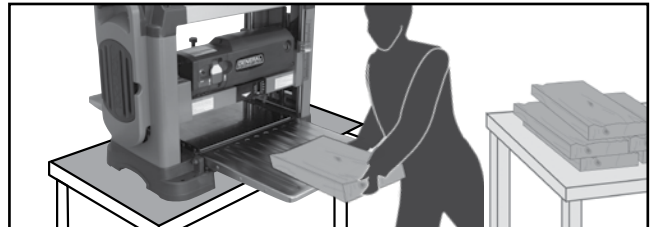
2. If a specific pre-set thickness is required, set the depth stop to the desired final workpiece thickness.



3. Slide the workpiece up to the cutter head and using the depth of cut adjustment handle, raise or lower the cutter head as needed to obtain the desired depth of cut.

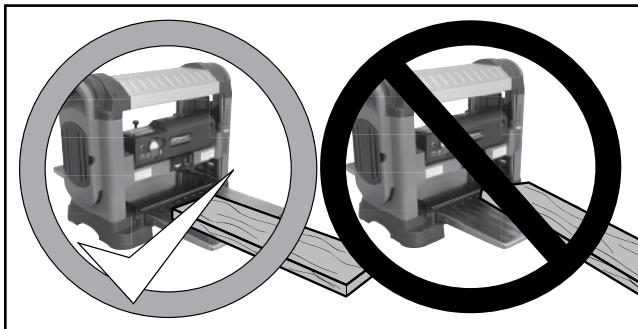


4. Set the board aside, then insert the safety key in the switch **A** and turn on the planer **B**.

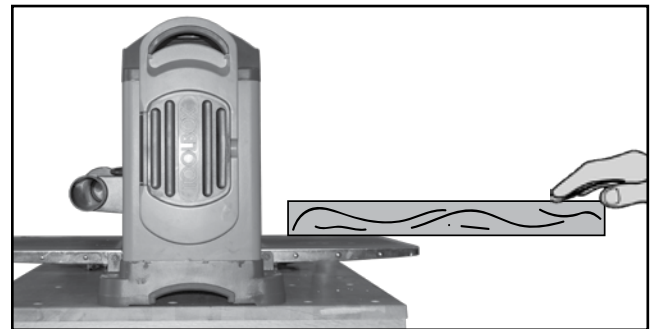


TO LIMIT THE POTENTIAL FOR INJURY IN THE EVENT OF A KICKBACK, AVOID STANDING DIRECTLY IN LINE WITH THE FRONT OR BACK OF THE PLANER WHENEVER A BOARD IS ENGAGED IN THE CUTTER HEAD.

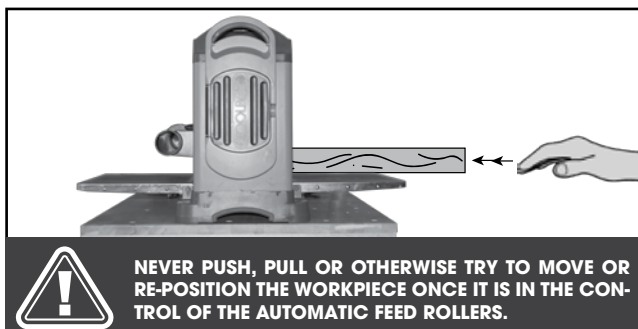
5. Stand to one side of the machine and set the board back on the infeed table with the face to be planed facing up.



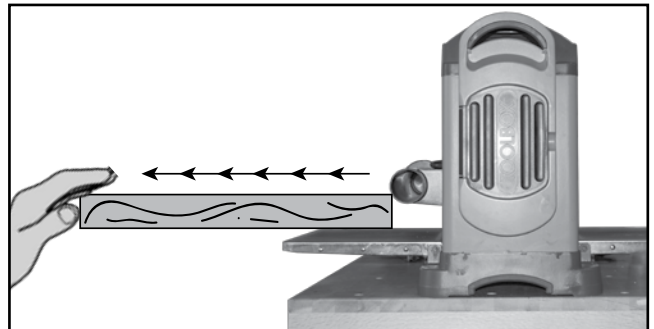
6. Align the board laterally so that it will be fed through the planer in the general direction of the grain, and allow the workpiece enough clearance to feed properly without rubbing or catching on either side of the machine.



7. Slowly slide the workpiece forward until the infeed roller "grips" the board.



8. Release the board allowing the feed roller to automatically feed the board through the planer.



9. Step to the rear of the machine and recover the planed board on the outfeed table once it has cleared the outfeed roller and has stopped advancing.

Note: Repeat these steps as needed for all boards that need to be planed to the same thickness.

MAINTENANCE

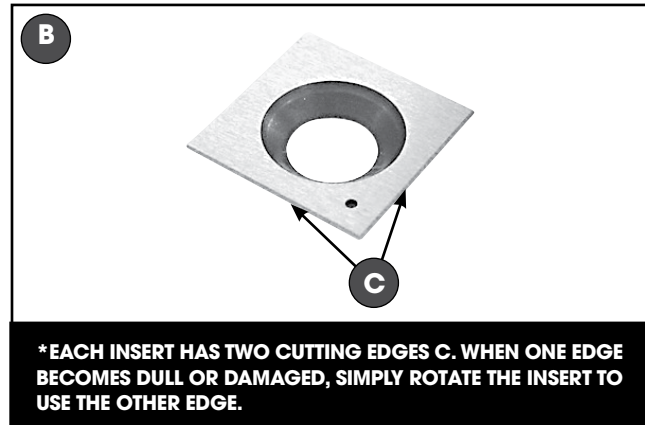
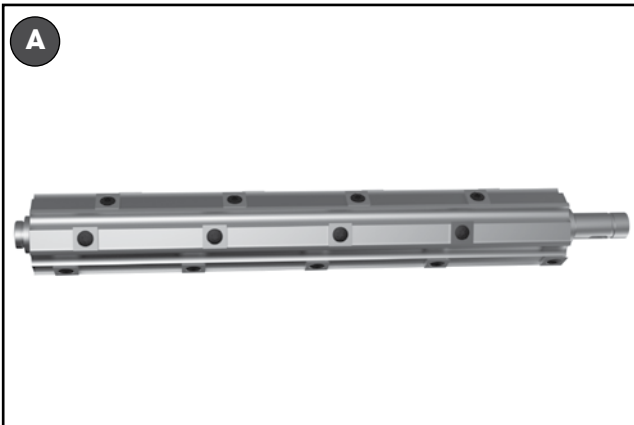


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

PERIODIC MAINTENANCE

- Inspect/test the ON/OFF switch before each use. Do not operate the planer with a damaged switch; replace a damaged switch immediately.
- Keep the machine as well as the in-feed and out-feed tables clean and free of saw dust, woodchips, pitch or glue. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the tables' surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners, protectant and dry lubricants based on what is readily available in your area.
- Avoid using silicon based products that may affect wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the planer with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- The motor and cutter head bearings are sealed and permanently lubricated - no further lubrication is required.
- The drive gears, chain and elevation screws should be cleaned of woodchips, dust, debris and old grease after every 10-15 hours of use. After cleaning, re-apply a generous coating of any common automotive bearing grease.
- Regularly inspect planed workpieces for signs of knife damage or wear and replace damaged or worn knives immediately.

INSPECTING CUTTER HEAD INSERTS



*** EACH INSERT HAS TWO CUTTING EDGES C. WHEN ONE EDGE BECOMES DULL OR DAMAGED, SIMPLY ROTATE THE INSERT TO USE THE OTHER EDGE.**

There are 26 carbide inserts installed in the cutter head **A** at the factory. With usage and normal wear over time, it will eventually become necessary to rotate and/or replace the inserts. To maintain even insert wear always reverse or replace all 26 inserts each time knife replacement is required. When needed, replacement inserts **B** can be ordered through your local General International distributor under part #30-006.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

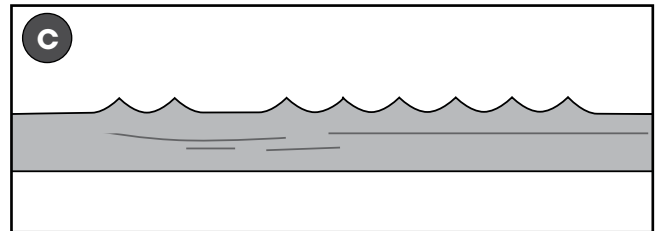
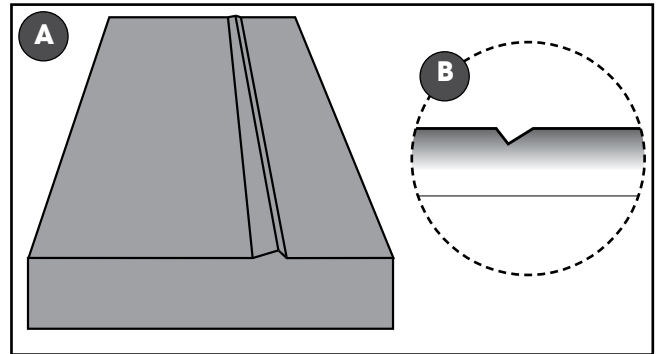
INSPECTING CUTTER HEAD INSERTS

Observing planed workpieces as they come off of the machine and looking for signs of knife damage or wear is the best method to help you to determine when knives are due to be changed.

Signs to look for include:

1. A raised ridgeline in the workpiece that runs a straight line from beginning to end of the board **D**. This is generally an indication that one or more knives has been nicked or damaged **E** by a foreign object such as a nail, staple or other hard object hidden or embedded in the workpiece.
2. A slight washboard or chatter effect **F** which can be an indication of uneven knife wear causing one knife to cut slightly deeper than the others.
3. Rough, irregular, torn or fuzzy grain on a freshly planed surface may be a sign of worn or dull blades causing the wood to tear out. Sharp blades cut crisply and leave a relatively smooth finish.

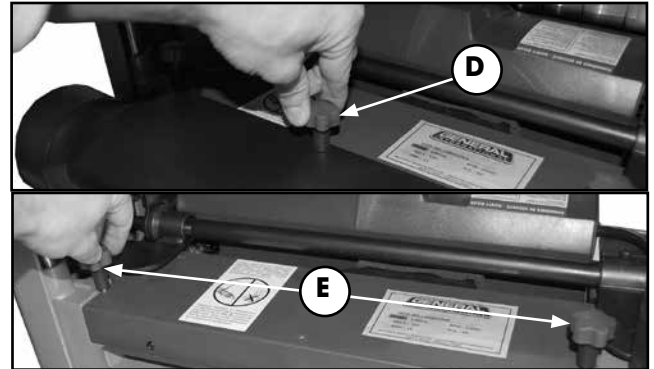
Note: Fuzzy grain can also be a sign of high moisture content in the workpiece. If inserts have recently been changed or if you suspect that moisture content and not dull inserts is the cause, set the workpiece aside and test by planing other boards with known or acceptable moisture content. If the planed results using a different workpiece are smooth, then moisture content in your wood is the problem - no adjustments can be made to the machine for this. Set the "wet" stock aside and simply work with drier wood.



CUTTER HEAD INSERT ROTATE/REPLACEMENT



1. Turn off and unplug the machine from the power source and remove the lock-out key.



2. Remove the lock knobs **D** and **E**, then remove the dust chute.



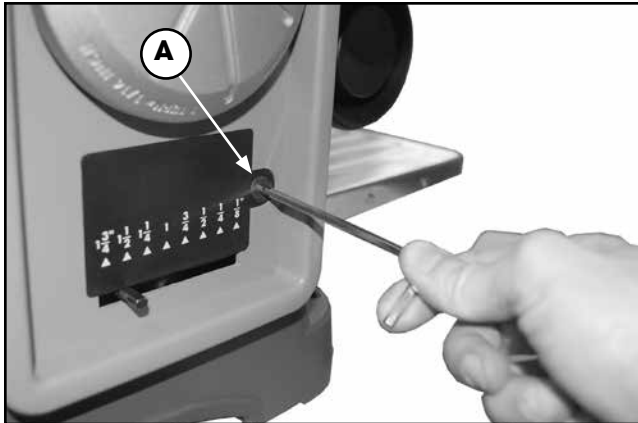
3. Remove the chip deflector as shown.



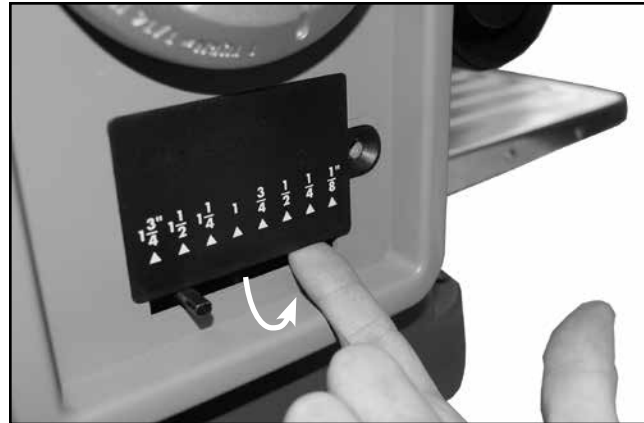
4. To remove the selector, pull back it towards you as shown.



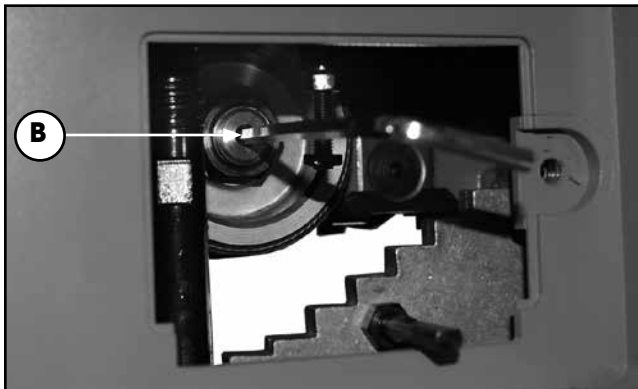
MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.



5. Remove the screw **A** with a 4 mm Allen key.



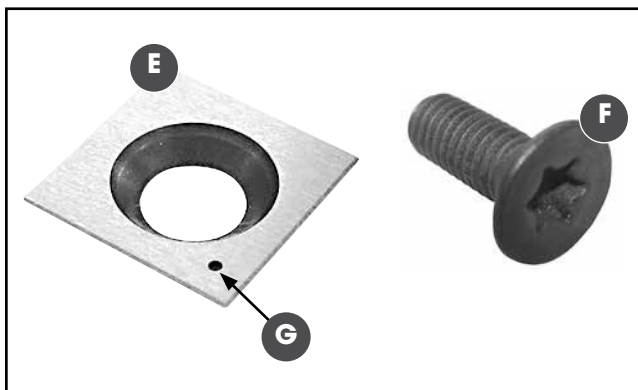
6. Slide finger into the opening and pull back the cover to detach it as shown.



7. Insert a 4 mm allen key **B** into the cutter head hole of the planer as shown to keep the cutter head from turning while changing inserts.



8. Immobilize the cutter head using a the 4 mm Allen key **C**, and remove the 26 inserts using the supplied Torx™ key **D**. Thoroughly clean the housing and cavity before turning/replacing an insert.



9. Thoroughly clean the inserts **E** and screws **F** using a lacquer thinner and small brush then apply a light coating of machine oil on the screws, taking care to remove any excess.

Note: When rotating the inserts in the cutter head, refer to the etched mark **G** on the inserts to keep track of the rotations.



10. Place each insert in the housing and firmly secure it in place with a screw.

Note: To avoid stripped screws and cracked inserts, do not overtighten the screws.



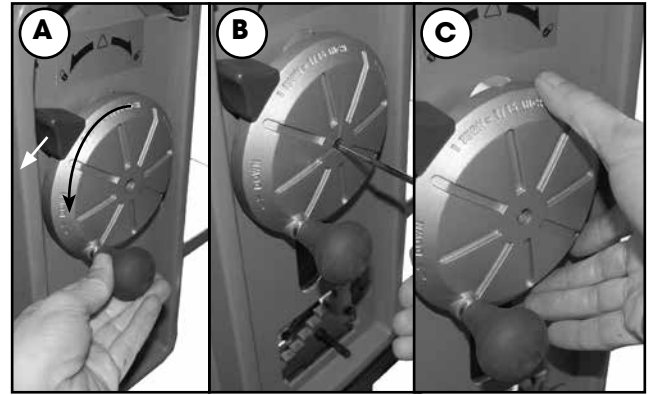
MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

BELT REPLACEMENT

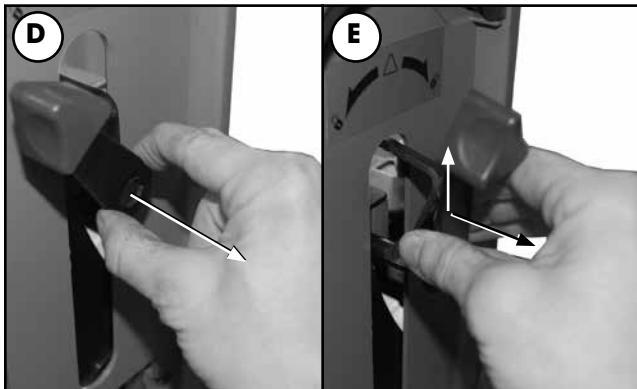
Inspect the belt after every 100 hours of service. Belts that show visible signs of wear such as cracks or fraying at the edges should be replaced immediately.



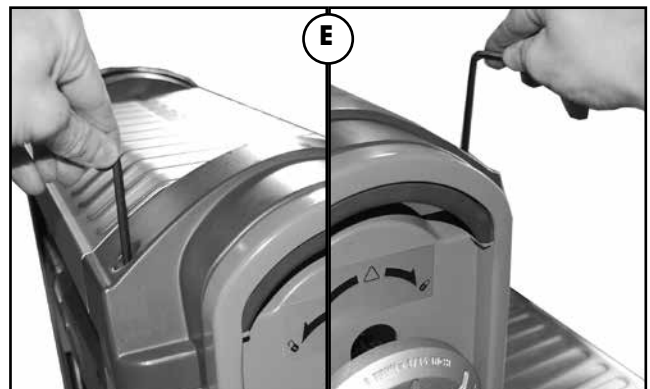
1. Turn off and unplug the machine from the power source and remove the lock-out key.



2. Unlock the cutter head and raise the cutter head to the maximum point **A**. Remove the handwheel screw with a 4 mm Allen key **B**, and pull back the handwheel to remove it **C**.



3. Pull back the lock lever **D** and then raise and pull back again to remove it **E**.



4. Remove the screws located in the top of the right cover **F**.



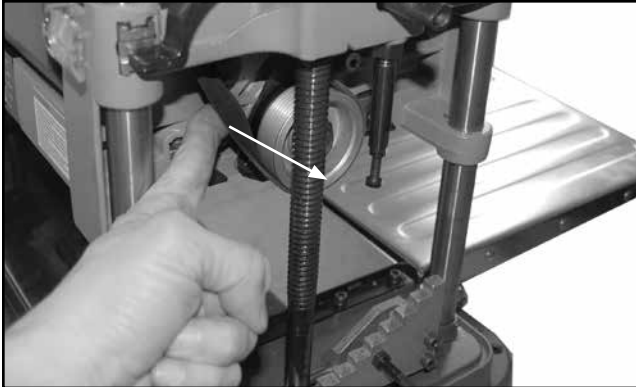
5. Handle both covers and lift them to detach them and then to remove them as shown.



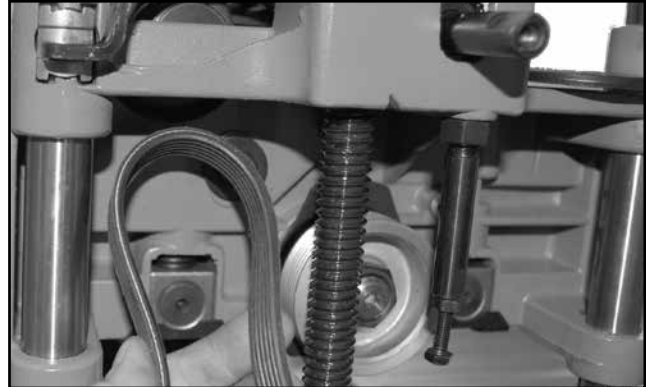
6. Remove the right side cover.



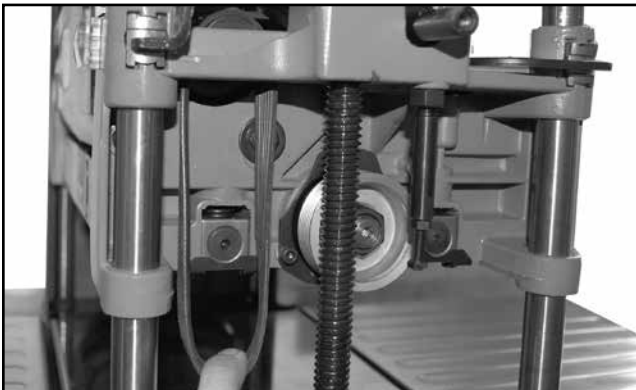
MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.



7. Pull on the belt while turning one of the pulleys counterclockwise until the belt comes off the pulley.



8. Remove the belt from the upper pulley.



9. Install the new belt on the upper pulley first.

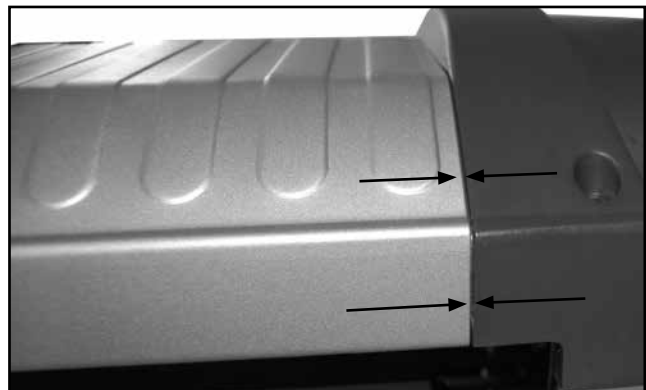


10. Slide the belt onto the edge of the lower pulley.



 **TO REDUCE RISK OF INJURY KEEP FINGERS ON TOP OF THE THE BELT**

11. Turn the upper pulley until the belt snaps into place.



Note: when re-installing all the parts, make sure the two edges of the upper covers are flush as shown.

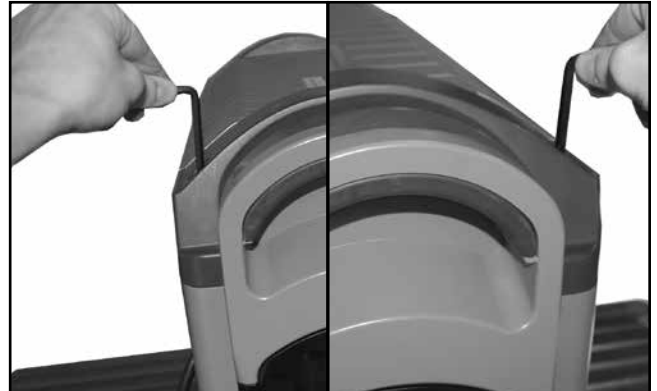


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

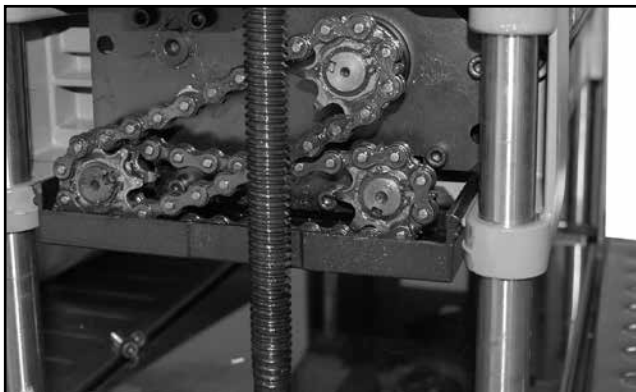
DRIVE CHAIN/GEAR LUBRICATION



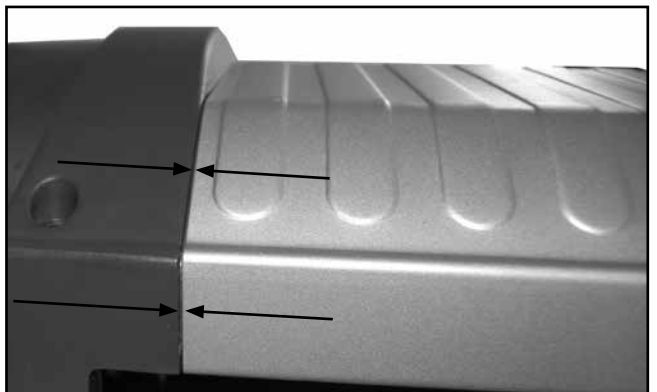
1. Turn off and unplug the machine from the power source and remove the lock-out key.



2. Remove the screws from the right side cover and detach the right side cover.



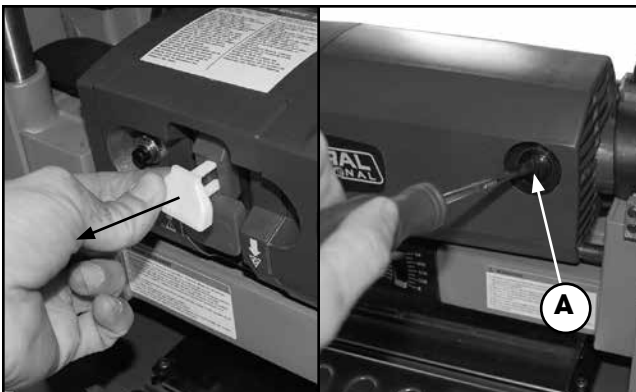
3. Remove old grease and dust deposits by wiping with a dry rag, then apply generous dabs of any common automotive bearing grease to the gears & chain, and four elevation screws.



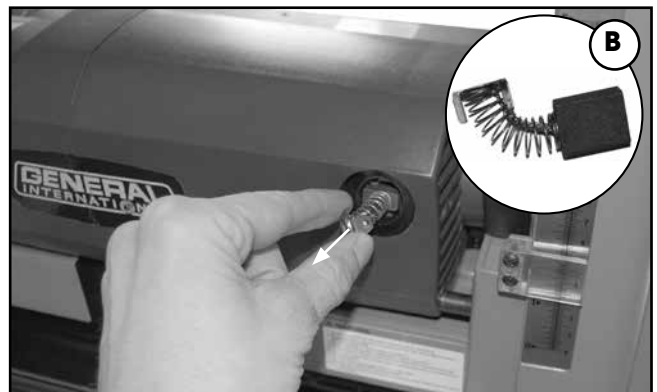
Note: when re-installing all the parts, make sure the two edges of the covers are flush as shown.

MOTOR BRUSH REPLACEMENT (AFTER ABOUT 150 HOURS OF SERVICE)

Note: Replace the brush when its length is less than 6 mm.



1. Unplug the machine from the power source and remove the lock-out key from the switch and remove the cap **A** with a flat screwdriver.



2. Remove the motor brush from its housing as shown. Install the new brush in its housing, then re-install the cap **B**.

RECOMMENDED OPTIONAL ACCESSORIES

Here is a sampling of optional accessories available from your local General International dealer that can be used with this product. For more information about our products, please visit our website at www.general.ca



DUST COLLECTORS

Dust collectors contribute to a cleaner more healthful workshop environment.

We offer a wide selection of top quality dust collectors to suit all your shop needs.



Item #10-100

DUST COLLECTOR KIT

Includes: 4" x 10' polyethylene flexible hose; 4" universal dust hood outlet; 4" wire bail hose clamps; heavy-duty clear plastic collector bags



Item #30-006

SET OF TEN CARBIDE INSERTS



Item #30-007

SET OF TEN HIGH-SPEED STEEL INSERTS



Item #30-008

SET OF TEN M5 SCREWS (FOR 30-006 & 30-007)



Item #50-150/ 167S/170

ROLLER STANDS

We offer a selection of roller stands for added in-feed or outfeed support when working with longer stock



Item #95-054

BIRCH WORKBENCH

54" x 21" with both front and end vises and a large storage shelf.

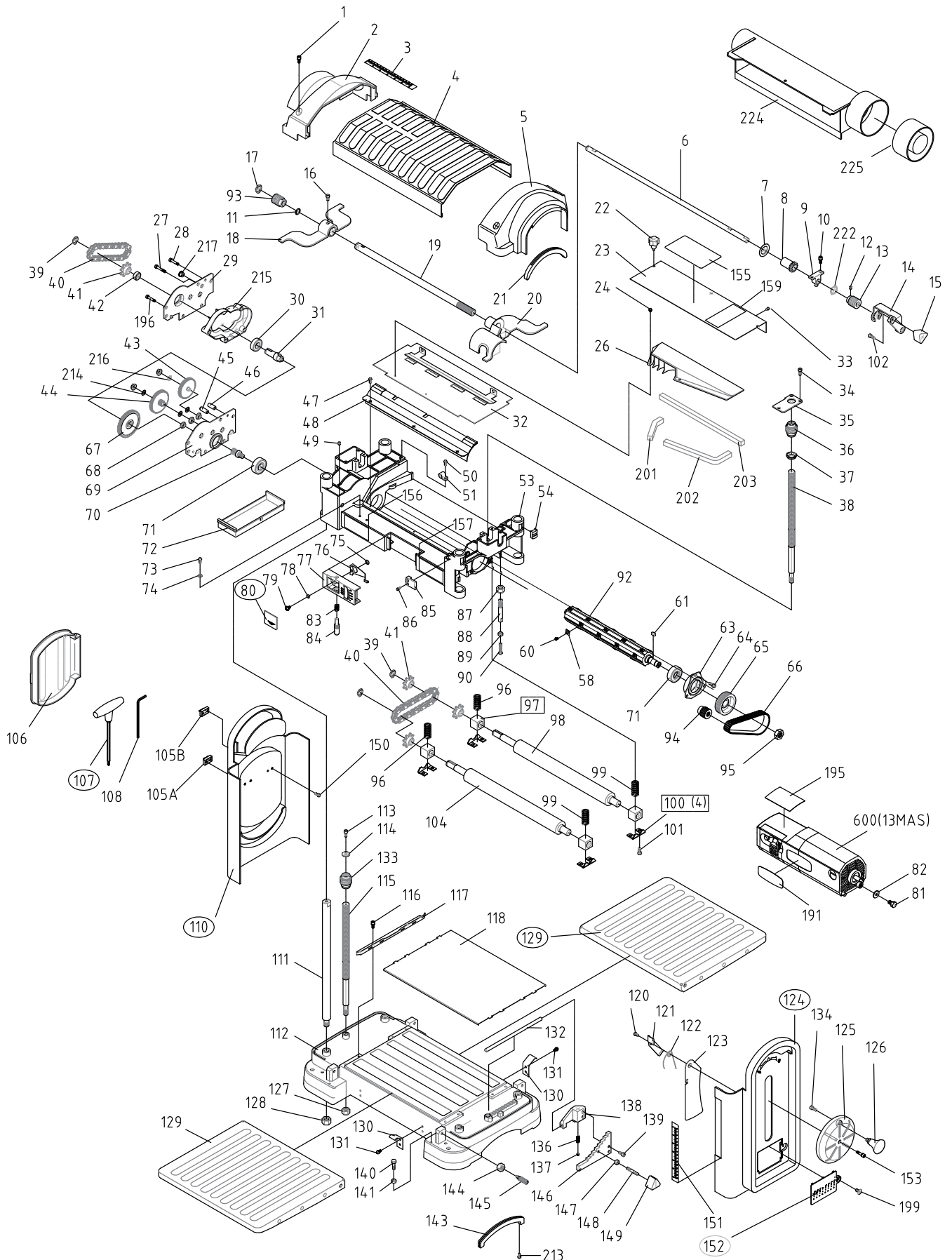


Item #99-700

HEAVY DUTY OPEN BASED STEEL STAND

Easy to assemble, wide based stable design with mounting slots for permanent planer installation. Foot print measures 33" (833) x 24 1/2". Floor to top of stand height: 28" (711mm).

DIAGRAM



PARTS LIST PLANER

IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.

PART #	REFERENCE #	DESCRIPTION	SPECIFICATION	QTY
30060-01	13P001A	CAP SCREW	M6 X P1.0 X 20L	4
30060-02	13013	LEFT UPPER COVER		1
30060-03	13006	GRADUATED SCALE		1
30060-04	13015	UPPER COVER		1
30060-05	13014	RIGHT UPPER COVER		1
30060-06	13029	TRANSMISSION SHAFT		1
30060-07	13093	WASHER	21.5X 34 X 1.8	1
30060-08	13027	NYLOCK NUT	M17 X 2.0	1
30060-09	13077	SUPPORT		2
30060-10	13P010A	CAP SCREW	M5 X P0.8 X 12L	4
30060-11	13024	WASHER	12 X 16 X 1	1
30060-12	13P012	CAP SCREW	M5 X P0.8 X 8L	2
30060-13	13026	WORM GEAR		1
30060-14	13037	HANDLE		1
30060-15	13018	SELECTOR CAP		1
30060-16	13P016	CAP SCREW	M5 X P0.8 X 12L	1
30060-17	817453-1	RETENTION RING	C17	1
30060-18	13023	LEFT LOCK PLATE		1
30060-19	13019	SLEEVE		1
30060-20	13022	RIGHT LOCK PLATE		1
30060-21	13056	UPPER PAD		2
30060-22	13076	KNOB		3
30060-23	13064	COVER		1
30060-24	13P024A	SCREW W/WASHER	M4 X P0.7 X 6L	2
30060-26	13033	AIR MANIFOLD		1
30060-27	13P027A	CAP SCREW	M5 X P0.8 X 35L	3
30060-28	13P028A	CAP SCREW	M5 X P0.8 X 27L	2
30060-29	13103	OUTER GEARBOX COVER		1
30060-30	13P030	BEARING	6002ZZ	1
30060-31	SPL1057N	GEAR SHAFT		1
30060-32	13030	DUST CHUTE		1
30060-33	13P033	SCREW	M4 X P0.7 X 6L	2
30060-34	13P034	CAP SCREW	M5 X P0.8 X 10L	6
30060-35	13072	COVER		2
30060-36	13097	WORM GEAR		1
30060-37	13083	BUSHING		2
30060-38	13095	RIGHT ELEVATING SCREW		1
30060-39	817453-4	RETAINING RING	STW15	3
30060-40	13127	CHAIN	#410-26	2
30060-41	13101	SPROCKET		4
30060-42	13102	SPACER	15 X 20 7	1
30060-43		SMALL GEAR ASSEMBLY	52T+12T	1
30060-44	SPL1054N	SMALL GEAR	58T	1
30060-45	SPL1050N	UNDERCUT SPACER		4
30060-46	SPL1049N	SPACER	5.5 X 9 X 20	2
30060-47	13P047	SCREW	M5 X P0.8 X 6L	3
30060-48	13086	DUST CHUTE PLATE		1
30060-49	13P049	SET SCREW	M5 X P0.8 X 8L	1
30060-50	13P050	SCREW	M5 X P0.8 X 8L	1
30060-51	13094	CORD CLAMP	GCL-5/16 S	1
30060-53	13002	UPPER FRAME		1
30060-54	13028	SUPPORT BLOCK		4
30060-58		INSERT		26
30060-60		INSERT SCREW		26

PARTS LIST

PLANER

IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.

PART #	REFERENCE #	DESCRIPTION	SPECIFICATION	QTY
30060-61	818654-9	KEY	5 X 12L	1
30060-63	13116	BEARING HOUSING		1
30060-64	820379-6	CAP SCREW	M5 X P0.8 X 12L	3
30060-65	13117	PULLEY CUTTER HEAD		1
30060-66	13126	BELT DRIVE	135J6	1
30060-67	SPL1055N	LARGE GEAR	70T	1
30060-68	SPL1051N	BUSHING GEAR		5
30060-69	13111	GEARBOX INNER COVER		1
30060-70	SPL1047N	PINION	12T	1
30060-71	13P071	BEARING	6203ZZ	2
30060-72	13112	GEAR BOX COVER		1
30060-73	13P073	SCREW	M5 X 8L	2
30060-74	813314-8	LOCK WASHER	M5	2
30060-75	13089	NUT	M4	1
30060-76	13044	POINTER		1
30060-77	13043	POINTER HOUSING		1
30060-78	13090	BUSHING	4.2 X 11 X3	1
30060-79	13P079A	FLANGE SCREW	M4 X P0.7 X 10L	1
30060-80	13066	POINTER COVER		1
30060-81	813310-0	SCREW	M8 X P1.25 X 20	1
30060-82	13P082	WASHER	M8 X 23 X 2T	1
30060-83	13046	SPRING	8.5 X 19 X 0.8	1
30060-84	13045	POINTER ROD		1
30060-85	13054	DEPTH INDICATOR		1
30060-86	13P086	SCREW	M3 X P0.5 X 16L	2
30060-87	13P087	HEX NUT	M10 X14 X P1.5	1
30060-88	13036	THREADED SPACER		1
30060-89	813164-6	NUT	M5 X P0.8	1
30060-90	13136	HEX HEAD BOLT	M5 X P0.8 X 25L	1
30060-92		CUTTER HEAD		1
30060-93	13096	WORM GEAR NUT		1
30060-94	13119	MOTOR PULLEY		1
30060-95	13118	NUT	M16 X P2.0L.H	1
30060-96	13082	LEFT SPRING		2
30060-97	AP13089	BLOCK BEARING		4
30060-98	13009	OUTFEED ROLLER		1
30060-99	13079	RIGHT COIL SPRING		2
30060-100	AP13084	RETAINER PLATE		4
30060-101	13P034	CAP SCREW	M5X P0.8 X 10L	8
30060-102	820379-9	CAP SCREW	M5 X P0.8 X 10L	1
30060-104	13008	ROLLER INFEED		1
30060-105		TOOL HOLDER		1
30060-105		TOOL HOLDER		1
30060-106	13060	TOOL BOX COVER		1
30060-107		TORX WRENCH	T25	1
30060-108	13081	ALLEN KEY	4MM X 100L	1
30060-110	13016	LEFT SIDE COVER		1
30060-111	13020	SUPPORT ROD		4
30060-112	13001	BASE		1
30060-113	820379-1	CAP SCREW	M5 X P0.8 X 8L	1
30060-114	13092	WASHER	5.5 X 19 X 2T	1
30060-115	13049	ELEVATING SCREW		1
30060-116	13P116A	CAP SCREW	M5 X P0.8 X 10L	8

PARTS LIST

PLANER

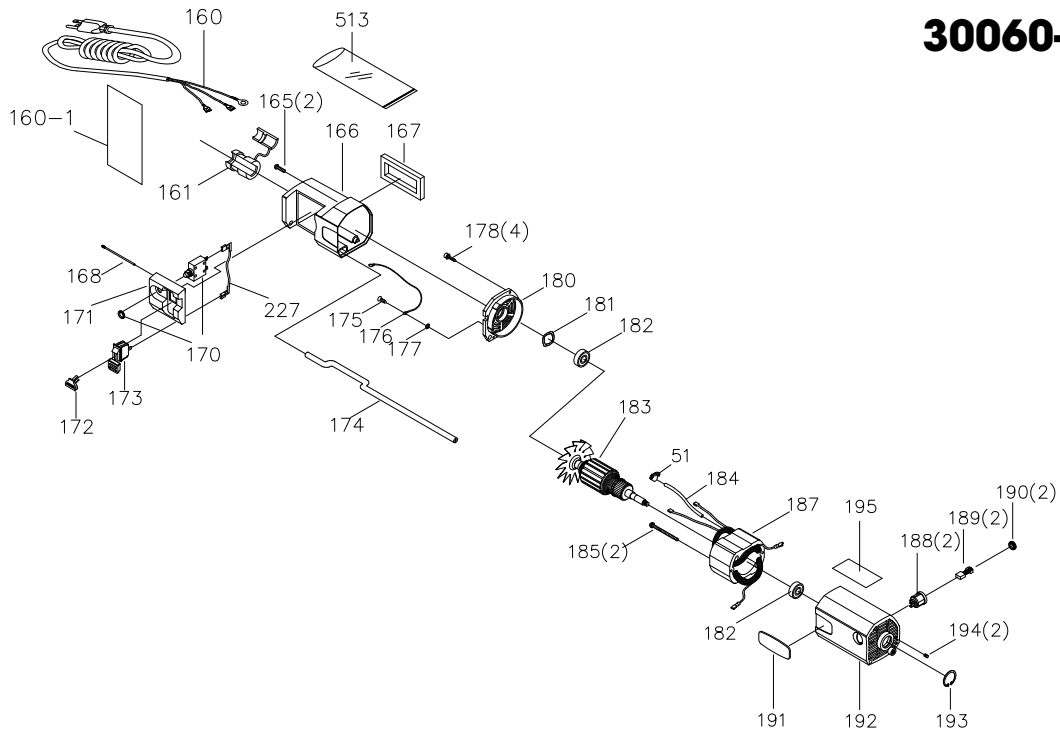
IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.

PART #	REFERENCE #	DESCRIPTION	SPECIFICATION	QTY
30060-117	13123	GUIDE RAIL		2
30060-118	13012	MAIN TABLE PLATE		1
30060-120	13P047	SCREW	M5 X P0.8 X 6L	1
30060-121	13055	PLATE STIFFENER		1
30060-122	13061	RETURN SPRING		1
30060-123	13042	GUARD PLATE		1
30060-124	13017	RIGHT SIDE COVER		1
30060-125	13032	CUTTER HEAD HANDWHEEL		1
30060-126	13071	KNOB		1
30060-127	13P127	NYLOCK NUT	M10 X P1.5	2
30060-128	813164-10	NUT	M12 X P1.75	4
30060-129	13099	FRONT TABLE		2
30060-130	13050	FLAT SPRING		4
30060-131	13P131A	CAP SCREW	M5 X P0.8 X 10L	8
30060-132	13035	ROD		1
30060-133	13025	WORM GEAR		1
30060-134	820379-9	CAP SCREW	M5 X P0.8 X 10L	1
30060-136	13087	SPRING COIL	7.62 X 15.75 X 0.7	1
30060-137	823742-1	STEEL BALL	10MM	1
30060-138	13034	GUARD BLOCK		1
30060-139	820379-2	CAP SCREW	M5 X P0.8 X 16L	2
30060-140	821388-3	HEX HEAD BOLT	M6 X P1.0 X 25L	4
30060-141	813164-7	NUT	M6 X P1.0	4
30060-143	13057	BASE PAD		2
30060-144	13P087-1	NUT	M10 X 14 X P1.5	4
30060-145	13075	ADJUSTMENT BOLT		4
30060-146	13038	PRE-SET DEPTH STOP		1
30060-147	813164-7	NUT	M6 X P1.0	1
30060-148	13039	PIN		1
30060-149	13059	DEPTH STOP SELECTOR		1
30060-150	13P150	SCREW	M4.8 X 8L	4
30060-151	13010	THICKNESS SCALE		1
30060-152	13085	DEPTH STOP COVER		1
30060-153	13P153A	FLANGE SCREW	M5 X P0.8 X 20L	1
30060-155	13144	NAME PLATE		1
30060-156		WARNING LABEL		1
30060-157		WARNING LABEL		1
30060-159	13142	KNIFE INSTRUCTION LABEL		1
30060-160-1		CORD LABEL		1
30060-191		GENERAL INTERNATIONAL LABEL		1
30060-195		SAFETY RULES LABEL		1
30060-196	13P196A	CAP SCREW	M5 X P0.8 X 30L	1
30060-199	13P199	FLAT HEAD SCREW	M6 X P1.0 X 12L	1
30060-201	13078	RIGHT GASKET		1
30060-202	13088	LEFT GASKET		1
30060-203	13100	COVER GASKET		1
30060-213	13P150	SCREW	M4.8 X 8L	4
30060-214	13160	WASHER	8.2 X 14 X 0.1T	3
30060-215	13161	GEARBOX COVER	PP7633	1
30060-216	13162	WAVE WASHER	8.5 X 12	1
30060-217	13163	PLUG		1
30060-222	13168	WAVE WASHER	12.5 X 17 X 0.3T	1
30060-224	13069	DUST CHUTE		1
30060-225	13153	DUST HOSE ADAPTOR		1

DIAGRAM & PARTS LIST

MOTOR ASSEMBLY

30060-600



IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.

PART #	REFERENCE #	DESCRIPTION	SPECIFICATION	QTY
30060-600	13MAS	MOTOR AND SWITCH ASSEMBLY	1 30060-01	1
30060-51	13094	CORD CLAMP	GCL-5/16 S	1
30060-160	13M15	POWER CORD & PLUG		1
30060-161	AP13M07	STRAIN RELIEF	HALO(6P3-4)	1
30060-165	13P165	SCREW	M5 X 20L	2
30060-166	13M01	SWITCH HOUSING		1
30060-167	13M13	FOAM GASKET		1
30060-168	13M05	SCREW		1
30060-170	13M12	OVERLOAD PROTECTION	20A	1
30060-171	13M04	SWITCH BEZEL		1
30060-172	829785	LOCK-OUT KEY		1
30060-173	829786	SWITCH		1
30060-174	13M14	MOTOR PIVOT ROD		1
30060-175	13P073	SCREW	M5X8L	1
30060-176	13M19	LEAD WIRE	300MM +/- 3MM	1
30060-177	813314-8	LOCK WASHER	M5	1
30060-178	13P178A	CAP SCREW	M4.2 X 20L	4
30060-180	13M03	MOTOR END CAP		1
30060-181	13P181	WAVE WASHER		1
30060-182	820722-3	BEARING	6201LLB	2
30060-183	13M09AS	ROTOR ASSEMBLY		1
30060-184		TUBE		1
30060-185	13P185A	CAP SCREW	M4.8 X 70L	2
30060-187	13M08AS	STATOR ASSEMBLY		1
30060-188	13M16	BRUSH HOLDER		2
30060-189	13M18	BRUSH		2
30060-190	13M17	BRUSH CAP		2
30060-191	826463-4	LABEL		1
30060-192	13M02	MOTOR HOUSING		1
30060-193	13P193	RETAINING RING	RTW32	1
30060-194	13P194	SOCKET HEAD SCREW	M5 X 12L	2
30060-195	13141	MOTOR SAFETY RULES LABEL		1
30060-227	13M33	LEAD WIRE	80 MM	1



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