Planer

Model 10055

Owner's Manual

For Models Manufactured Since 03/2025

175370

Oliver Machinery
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WWW.OLIVERMACHINERY.NET

Stock Number: 10055.201
Manual Version: 1.0.2

READ AND UNDERSTAND ALL INSTRUCTIONS IN THIS MANUAL BEFORE ATTEMPTING TO ASSEMBLE OR OPERATE THE MACHINE.

FOLLOW THE INSTRUCTIONS AND THINK SAFETY!

THE OWNER OF THIS MACHINE IS SOLELY RESPONSIBLE FOR THE SAFETY OF ANYONE USING THIS MACHINE. SUCH RESPONSIBILITY INCLUDES BUT NOT LIMITED TO THE FOLLOWING:

- **PROPER ASSEMBLY, OPERATION, INSPECTION, MAINTENANCE, AND RELOCATION OF THE MACHINE.**
- **PROPER TRAINING FOR THE OPERATORS AND ENSURES THIS MANUAL IS AVAILABLE AT ALL TIMES.**
- **USAGE AUTHORIZATION.**
- **USAGE OF SAFETY AND PROTECTION DEVICES. UPDATED MANUAL MAY BE ONLINE.**

OLIVER MACHINERY DISCLAIMS ANY LIABILITY FOR MACHINES THAT HAVE BEEN ALTERED OR ABUSED. OLIVER MACHINERY RESERVES THE RIGHT TO EFFECT AT ANY TIME, WITHOUT PRIOR NOTICE, THOSE ALTERATIONS TO PARTS, FITTINGS, AND ACCESSORY EQUIPMENT WHICH THEY MAY DEEM NECESSARY FOR ANY REASON WHATSOEVER.

**** SAVE THIS MANUAL FOR FUTURE REFERENCE. ****

PROP 65 NOTICE

WARNING: Drilling, sawing, sanding, or machining wood products can expose you to wood dust and/or other chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Avoid inhaling wood dust and other harmful chemicals. Use a dust mask and other safety devices for personal protection.

For more information, go to http://www.P65Warnings.ca.gov/wood

Table of Contents

Introduction

Thank you for choosing Oliver! This manual contains important information on safely setting up, operating, and maintaining this machine. Please take the time to read through this manual and make sure you understand all instructions.

While this manual may provide tips on optimizing the result of your workpiece, the manual is not intended as a substitute for formal woodworking training. If you need to know how to safely complete a woodworking task, please consult knowledgeable and qualified sources before proceeding further.

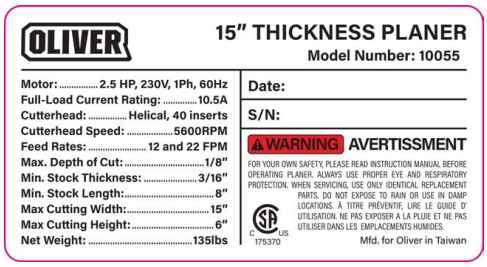
We made every effort to keep this manual up-to-date. Instructions, specifications, drawings, and photographs in this manual should match the machine delivered. If you find anything that seems confusing in this manual, or if some instructions are not available, please check our website for an updated manual:

WWW.OLIVERMACHINERY.NET/MANUALS

Alternatively, you can contact our technical support for help:

1-800-559-5065

Before calling, please note the manufacture date and the serial number. You can find the information on a nameplate on the top cover. The information allows the support staff to properly troubleshoot the issue and determine if an updated manual is available for your machine.



Please let us know how well this manual serves you. If you have any suggestions, please call the number above or email us at:

info@olivermachinery.net

We love to hear from our customers and make improvements.

Specifications

Quick View

Model	10055 Planer
Stock Number	10055.201
Motor	Induction motor 2.5HP, 230V, 1Ph
Max. Stock Width	15"
Max Depth of Cut	3/64” (full width) 1/8" (stock less than 6-1/2" wide)
Dimensions	48-3/4”(L) x 28”(W) x 18-1/2”(H)
Footprint	23-1/4”(L) x 19”(W)
Fully Assembled Weight	146 lbs.
Warranty	1 Year (Motor and electronics) 2 Years (All other parts)

Product Dimensions

Width x Depth x Height (Fully Assembled)	48-3/4”(L) x 28”(W) x 18-1/2”(H)
Footprint	23-1/4” (L) x 19”(W)
Fully Assembled Weight	146 lbs.

Shipment Info

Package Type	Wood pallet with corrugated paper board cover
Content	Planer and accessories
Dimensions	Approx. 29-1/2” (L) x 27-1/4”(W) x 21”(H)
Weight	171 lbs.
Approximate Setup Time	30 minutes
Must Ship Upright	Yes
Stackable	No

Electricals

Power Requirement	230V, 1Ph, 60Hz
Full Load Current Rating	10.5A
Recommended circuit size	15A
Power Switch Type	Safety lock-out switch
Connection Type	NEMA 6-15 plug
Overload Protection	Equipped

Motor

Motor Type	Induction motor
Horsepower	2.5HP
Speed	3450 RPM
Efficiency	80%
Power Transfer Mechanism	Poly V-belt and pulleys
Bearing type	Permanently sealed ball bearing

Planer Capacity and Performance

Maximum Stock Width	15"
Maximum Depth of Cut	1/8" (Stock less than 6-1/2" wide) 3/64”(Full width)
Maximum Stock Thickness	6"
Minimum Stock Thickness	3/16"
Minimum Stock Length	8"
Feed Rate	12 or 22 FPM
Number of Cuts Per Square Inch	104@12FPM 62@20FPM

Cutterhead and Carriage

Cutterhead Type	Oliver HCX helical shearing cutterhead
Cutterhead Diameter	2-3/8"
Cutterhead Speed	5600 RPM
Number of Cutter Inserts	40
Number of Rows of Cutter Inserts	4
Cutter Insert Type	Four-sided, indexable carbide
Cutter Insert Diameters	15mm x 15mm x 2.5mm
Cutting Angle	79.3°
Skew Angle	12°
Cutter Insert Screw Tensioning Torque	55 lbs.-inch
Infeed Roller Type	Rubber
Outfeed Roller Type	Rubber
Headstock Height Change Per Turn of Crank	1/16"

Measurements

Measurement Units	Inch/mm
Primary Measurement Device	Digital readout
Digital Readout Resolution	0.005"/0.05mm
Digital Readout Accuracy	+/- 0.0025"/0.05mm
Additional Measurement Devices	Manual thickness scale Material removal gauge Depth stops

Table

Table Dimensions	48-3/4” x 15” (With extension tables) 23-3/4” x 15” (Without extension tables)
Material	Steel

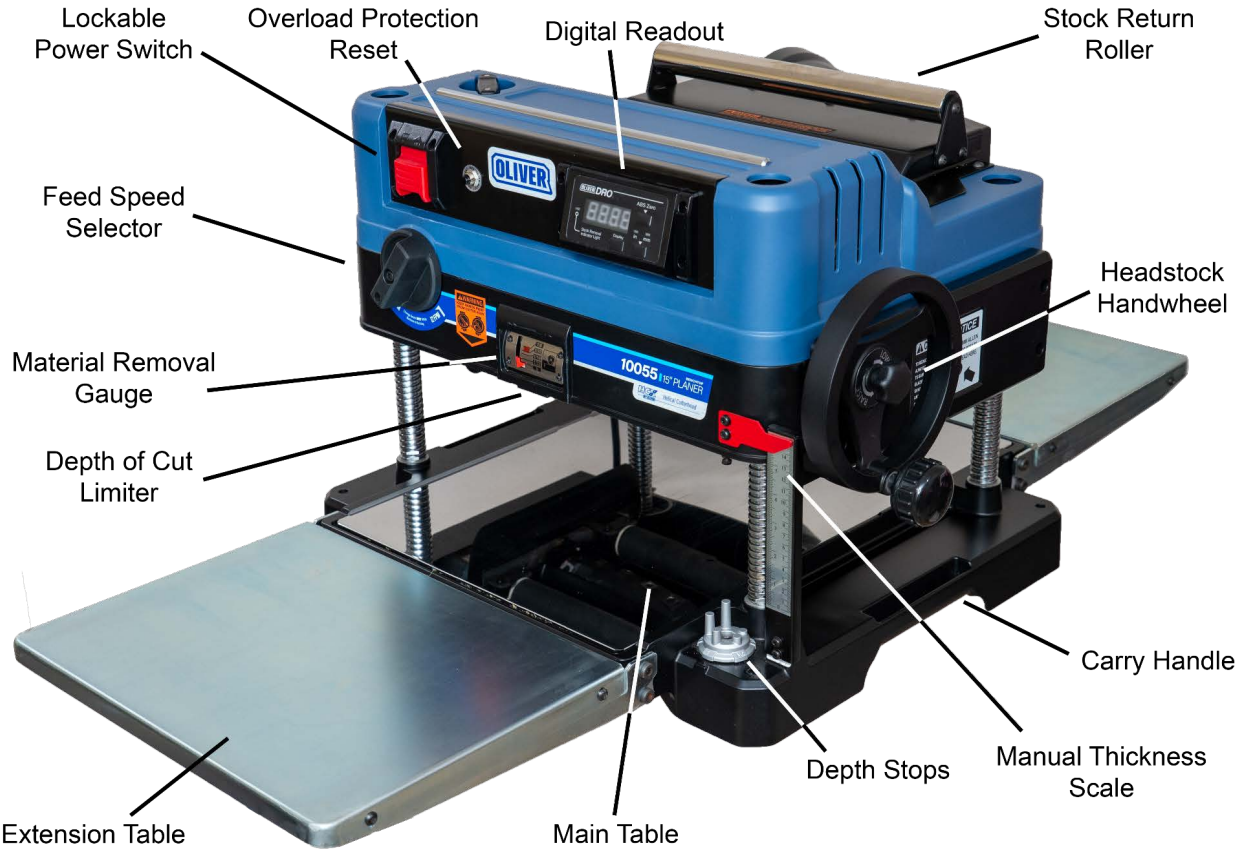
Safety

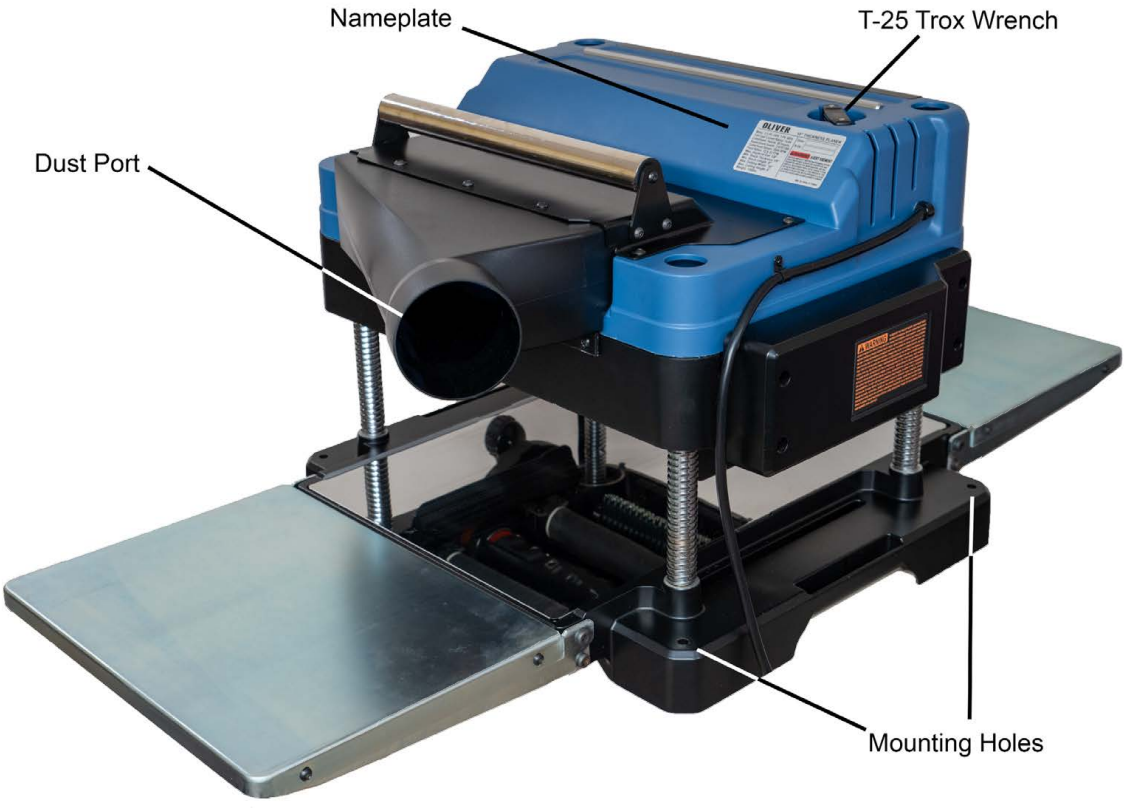
Number of Dust Ports	1
Dust Port Size	4"
Anti-Kickback Device	Equipped
Minimum CFM Required	600 CFM
Sound Rating @ 2' distance	90 dB

Others

Serial Number Location	On the top cover
Spare Parts Included	5 Oliver HCX cutter inserts
Certification	CSA 175370
Country of Origin	Taiwan

Identification





Safety

Oliver Machinery has made every attempt to provide a safe, reliable, easy-to-use piece of machinery. Safety, however, is ultimately depending on the individual machine operator. **Before operating this machine, please become familiar with the following safety labels and guidelines.**

DANGER	This indicates an imminently hazardous situation which, if not avoided, **WILL** cause death or serious injury.
WARNING	This means if the warning is not taken seriously, it **CAN** cause death or serious injury.
CAUTION	This means if the precaution is not taken, it **MAY** cause minor or moderate injury.
IMPORTANT	This is a tip for properly operating the machine to avoid machine damage.

General Safety Guidelines

1. **FAMILIARIZE** yourself with all safety instructions found in this manual. Know the limitations and hazards associated with this machine. Do not operate or service this machine until you are properly trained.

2. **ELECTRICAL GROUNDING**, when done properly, reduces the risk of electrocution, shocks, and fire. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and a plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in your area's electrical code.

3. **DISCONNECT** the machine from power before performing any service, maintenance, or adjustments. A machine under repair should be RED TAGGED to show it should not be used until the repair is complete.

4. **EYE PROTECTION**: Always wear an approved safety face shield, goggles, or glasses that comply with ANSI Z87.1 and CSA Z94.3 standards. Common eyeglasses are not safety glasses and may not provide adequate protection.

5. **EAR PROTECTION**: Use hearing protective devices where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations. When in doubt, use it.

6. **OTHER PERSONAL PROTECTION**: Before operating this machine, remove tie, rings, watch, and other jewelry. Roll up sleeves above elbows. Remove all loose outer clothing and confine long hair. Wear professional work boots to protect your feet from injuries and slippage. Do not wear gloves unless it is instructed to perform a particular step(s) in the manual.

7. **GUARDS**: Keep machine guards in place for all applicable operations. If any guards are removed for maintenance, DO NOT OPERATE the machine until all guards are reinstalled.

8. **WORKPLACE SAFETY**: Keep the floor around the machine clean. Scrap material, sawdust, oil, and other liquids increase the risk of tripping or slipping. Be sure to clean up the table before starting the machine. Make certain the work area is well-lit and that a proper exhaust system is used to minimize dust. Use anti-skid floor strips on the floor area where the operator normally stands and mark off the machine work area. Provide adequate workspace around the machine.

9. **ACCESS CONTROL** should be enforced so only trained personnel can access the work area and operate the machine. Use a padlock to lock the power switch when the planer is not in use.

10. **STAY ALERT** at all times. Do not operate this machine while under the influence of drugs/alcohol or when not feeling well.

11. **NEVER STAND ON MACHINE.**

12. **REPLACEMENT PARTS:** Use only genuine Oliver Machinery replacement parts and accessories recommended for this machine. Generic parts made by other manufacturers may create a safety hazard and WILL void the factory warranty and other guarantees.

13. **PROPER USE:** Do not use this machine for anything other than its intended use. If used for other purposes, Oliver Machinery disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use.

Safety Guidelines Specific to Planer

Before Work Begins:

1. **USE ONLY NATURAL, SOLID WOOD.** Do not plane any material such as plywood, MDF, OSB, laminate, or anything that can disintegrate during operation. Do not plane treated lumber or anything that contains harmful chemicals, as this will spread wood dust that contains such harmful chemicals. Do not attempt to plane any workpiece that contains loose knots or foreign materials.

2. **CHECK CUTTER INSERTS:** Make sure cutter inserts are sharp, clean, and free from damage. Forcing dull/damaged cutter inserts to work invites accidents and impacts finish quality. Use the recommended amount of torque to securely fasten all inserts onto the cutterhead.

3. **SERVICING CUTTER INSERTS:** Wear heavy-duty leather gloves to protect your hands when installing new cutter inserts or rotating the existing ones. Ensure the cutterhead is thoroughly clean before installing the insert. Debris between the cutter insert and its seat can create uneven pressure, causing the insert to break, and body injuries may occur.

4. **SUPPORT LONG WORKPIECE** with auxiliary stock feeding rollers/tables. This helps to avoid injuries and improve the quality of the finish. Bolt down the machine to prevent tipping.

When Using the Planer:

1. **DUST COLLECTION SYSTEM** is required for this planer. Please make sure the system is turned on and provides enough suction before starting the planer.

2. **KICKBACK** happens when a workpiece is ejected, usually towards the infeed side of the planer, during operation. **This can cause serious injuries or even death.** The operator should be cautious about possible kickbacks.

    - **ALWAYS** wear proper protection devices.
    - **NEVER** stand directly behind a workpiece while it is being fed into the planer.
    - **NEVER** look inside the planer when the motor is running.
    - **NEVER** plane boards that are shorter than 8", as mentioned in the specifications.

3. **PROPER WORKPIECE FEEDING** avoids kickback. Never start the machine with the workpiece engaging the cutterhead. Never start feeding until the planer has reached its full speed. Ensure feed rollers apply an adequate amount of pressure on the workpiece.

    - **KEEP HANDS AWAY FROM THE CUTTERHEAD** when the planer is running.
    - **NEVER** force a workpiece through the planer. Reduce the depth of cut as needed.
    - **ONLY** plane one board at a time.
    - For warped workpieces, face joint the workpiece with a jointer before planing.

4. **STUCK WORKPIECE** can only be removed after the planer is powered off and the cutterhead comes to a complete stop. Raise the headstock to dislodge the stuck workpiece from the anti-kickback fingers for removal. Do not use hands or push sticks to force-feed a workpiece through the planer, as it can result in severe injuries and/or machine damage.

5. **DEPTH OF CUT SETTINGS:** Do not force the planer to exceed the maximum depth of cut capacity found in the specification. Failing to comply can cause machine damage and injuries. Reduce the depth of cut for hard materials as that increases the planer's workload.

After Operation

1. **STOP THE MACHINE** if the operator leaves the machine for any reason.
2. **WAIT** until the machine comes to a complete stop.
3. **CLEAN UP** the work area before departure.

Electricals

WARNING **Faulty electrical work can cause electrocution and is a fire hazard.**

All electrical work must be completed by a licensed electrician and must meet the local electrical code in your area, or the warranty is void.

Minimum Circuit Size Requirement

Stock Number	**Minimum Circuit Size Required**
10055.201	15A

Please ensure the electrical circuit for this machine meets the minimum circuit size requirement. The minimum circuit size requirement applies to a dedicated circuit that provides power to one 10055 Planer. If more items are sharing the same circuit, consult a qualified electrician to ensure the designated circuit is properly sized for safe operation.

If a circuit is available but does not meet the minimum circuit size requirement listed above, a new circuit must be installed for this machine.

Grounding

WARNING **Improper grounding can cause electric shock, fire, and equipment damage.**

Proper grounding reduces the risk to the operator in the event of electrical malfunction or breakdown. This machine must be connected to the grounding conductor when available, and all grounding connections must meet or exceed the electrical code requirements in your area. Furthermore, all grounds must be verified and must meet or exceed the electrical requirement of the machine.

Indoor Use Only

This machine is designed for indoor use only. Operating this machine outdoors increases its exposure to moisture, which in turn increases the risk of electric shock.

Electrical Wiring

This machine is pre-wired for 240V with a cord and plug. Using an extension cord to bring power to the planer is not recommended. If you must use an extension cord to connect to a power source, select a durable cord type with a high-temperature rating (90C° or above). Use the minimum amount of extension cord as needed.

Minimum cord size (AWG) required based on amperage draw and length of the cord:

Amps	**Power Cord Length**				
	25 feet	50 feet	75 feet	100 feet	> 100 feet
< 5	16	14	14	14	Not Recommended
5 to 8	14	14	14	12	
8 to 12	14	14	12	10	
12 to 15	12	12	10	10	
15 to 20	10	10	10	NR	
21 to 30	10	NR	NR	NR	

WARNING **Use properly sized wires that meet or exceed the power requirement of your machine. Using undersized wires may cause overheating and increase the risk of fire and machine damage.**

Setup

Shop Preparation

Space Requirement

The dimensions of this machine are 48-3/4”(L) x 28”(W). You will need additional space to manipulate your workpiece and connect to the dust collection systems.

Electricals

If you plan to install this machine in a permanent location, make sure a properly sized circuit and electrical outlet are available nearby. Please refer to "Electricals" on page 13 for details regarding electrical requirements.

Lighting

Adequate lighting is needed to operate this machine. Overhead, non-glare lighting should be installed.

Safety Labels

If this machine introduces a new safety hazard to your workplace, display proper warning signs in highly visible locations.

Dust Collection

Wood dust created by this planer is a health hazard. Position this planer in a spot where it has access to a dust collection system.

Dust masks should be available for using the planer.

⚠ **CAUTION**	**Use a dust collection system that is rated above 600 CFM. Doing so improves air quality in the workplace and prevents the machine from jamming.** **When the machine is further away from the duct collector, the effective suction and CFM measured at the dust ports decrease. Ensure there is significant suction at the dust port so dust and debris can be effectively removed from the machine.**

Receiving

If this planer is delivered to you, please check for any significant damages on the packaging before signing the delivery confirmation.

This machine has a shipping weight of 171 lbs. and a net weight of 146 lbs. Please be sure help is available to move the machine to its final location.

IMPORTANT	If items are damaged, please call us immediately at **1-800-559-5065**

⚠ **WARNING**	**10055 Planer has a gross weight of 171 lbs. and a net weight of 146 lbs.** **Safe moving techniques and proper lifting equipment are required, or serious personal injury may occur.**

⚠ **WARNING**	**Do not lift your shipment by the strap. The straps are not designed to hold the total weight of your shipment. They may snap without warning and cause serious injury and machine damage.** **Straps may spring back violently when released and cause injury. Always wear safety goggles and gloves when removing the straps.**

Unboxing

1. The corrugated paperboard cover is secured by the straps on the wood pallet. Remove the straps to remove the top cover and the packaging inside.
2. Inside the package, you should find the planer and two boxes that contain all loose parts and accessories.

3. Remove the mounting bolts at the corners of the planer to release the planer from the pallet.

Inventory

Carefully unwrap the packaging and make sure all components are included in the shipment. Lay out all items received and inventory them.

Item	*Description*		*Qty.*
1	Dust shroud with 4" dust port		1
2	Dust shroud mounting thumb screws		4
3	Headstock handwheel		1
4	Headstock handwheel knob assembly (Knob, flat washer, and spring)		1 each
5	Spare cutter inserts and mounting screws		5 each
6	Extension tables		2
7	Extension tables socket head cap crews		8

NOTICE: If you cannot find an item in the list above, please check if it is still attached to the packaging. Occasionally, the item may have been pre-installed in the factory. See "**Parts List**" on page 41 to check if a component is included or installed.

NOTICE: This machine comes with various standard-sized, non-proprietary parts that can be purchased at local hardware store. If any of these parts are missing, getting them from the local store is the fastest way to get the machine running. We can also deliver any missing parts.

Additional Items Recommended for Machine Assembly and Maintenance

Item	Purpose
Safety glasses	Protection.
Leather gloves	Protection.
T-25 Trox driver bit	Cutter inserts rotation/replacement (55 lbs.-inch).
Torque wrench/screwdriver	Cutter inserts rotation/replacement (55 lbs.-inch).
Metric Hex Wrench Set	Parts installation & removal.
Philips Screwdriver	General maintenance.

Assembly

This planer is mostly assembled in the factory. There are a few more items to set up before the machine is ready for a test run. The approximate time for cleaning and assembly is approximately 30 minutes.

Headstock Handwheel Installation

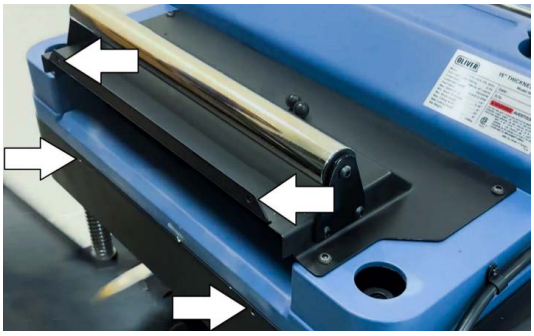
1. Slide the washer and spring (inventory item #4) into the headstock handwheel knob.

2. Install the handwheel on the right side of the planer. Rotate the handwheel so the flat surfaces on the handwheel and the shaft are aligned and the handwheel is fully inserted.
3. Thread the knob into the handwheel shaft and tighten.

4. The spring-loaded knob keeps the handwheel from rolling when it's fully tightened. Untighten the knob by 1-2 turns to allow the handwheel to move.

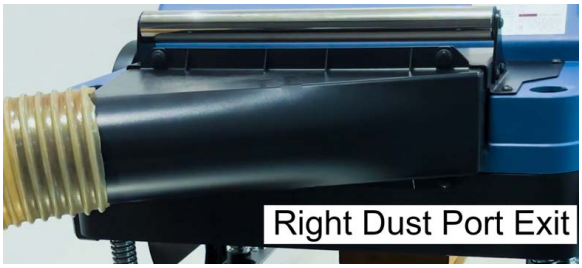
Dust Shroud Installation

1. Locate the four screw holes on the headstock for mounting the dust shroud.



2. Use the provided thumb screws to secure the dust shroud.

TIP: The bi-directional dust shroud design allows wood chips to exit from the left or right side of the planer. Left is the preferred direction as it allows optimal dust extraction.



Extension Table Installation

1. Locate the screw holes near the end of the planer's main table.
2. Align the holes on the extension tables and install the mounting screws.

3. Ensure the mounting screws are fully seated and tightened to support the extension tables.

Waxing

The steel planer table and extension tables have a low-resistance finish. To minimize stock feeding resistance, wax these surfaces with paste wax before first use and wax routinely thereafter.

Dust Collection

This wood planer can generate a lot of wood shavings and dust. You must connect this planer to a dust collection system so all dust and wood chips can be effectively removed and contained.

The minimum CFM requirement for this planer is 600 CFM at the dust port, which means your dust collection system should have a rating greater than 600 CFM, as air friction and leakage reduce effective CFM at the dust port.

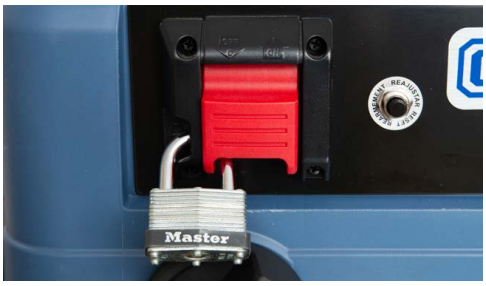
IMPORTANT	**Running this planer without a dust collection system or using a dust collection system with inadequate suction may cause dust and shavings to accumulate inside the planer. This can damage the machine and cause other hazardous situations. Check your dust collection system regularly to make sure it is not jammed or filled up.**

Bench Mounting (Optional)

Mounting this planer on a stable surface prevents it from tipping. Using four 5/16" bolts for mounting provides maximum strength and stability.

Controls and Components

ON / OFF Switches



- To start this planer, lift the power switch paddle.
- To stop, press the paddle down.

NOTICE: This power switch can be locked with a padlock. Lock the power switch to protect unexpected guests from getting injured.

Overload Protection Reset Button

The overload protection button is right next to the power switch. If the planer is overloaded and stopped, the reset button will pop up. Wait for 3 minutes for the machine to cool down. Reduce the workload, then press the reset button before resuming operation.

Depth of Cut Adjustment

Each turn of the headstock handwheel changes the depth of cut by 1/16".Turn clockwise to lower the cutterhead and increase the depth of cut. Turn counterclockwise to raise the cutterhead and reduce the depth of cut.

The spring-loaded knob keeps the handwheel from rolling when it's fully tightened. Untighten the knob by 1-2 turns to allow the handwheel to move.

Feed Rate Selector

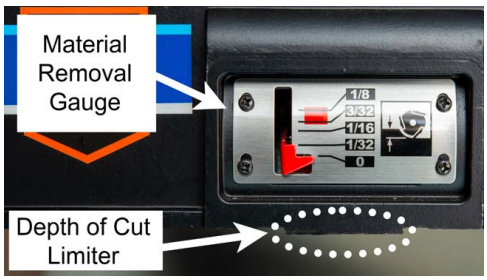
10055 Planer can feed stock at 12 or 22 FPM (feet per minute). The high feed rate allows faster processing time for milling stock to approximate thickness. Use the low feed rate to create a fine finish.

To change the feed rate, turn on the planer and wait for the motor to come to full speed, then rotate the selector and set the feed rate.

IMPORTANT	**Only change the feed rate when the machine is running at full speed. Failure to do so may cause the gearbox to jam and damage the machine.**

Material Removal Gauge

The material removal gauge shows the amount of stock to be removed. The sensor bar is located behind the depth of cut limiter.



Depth of Cut Limiter

This non-moving part protects the motor from overloading by limiting the depth of cut of wide stock to 3/64”.

Depth Stops

Allows quick and repeatable adjustments for thickness planing. Five settings are available: 3/16", 1/4", 1/2", 3/4", and 1”.

To plane stock to the thickness of the above:

1. Raise the headstock above the desired thickness setting.
2. Rotate the depth stop gauge to the desired thickness setting.
3. Lower the headstock until the positive stop bolt rests on the depth stop gauge.

IMPORTANT	**Do not force the headstock to go below the height limited by the depth stop. Permanent planer damage may occur.**

Digital Readout (DRO)

This planer is equipped with a DRO that shows the current thickness settings so the operator can adjust the height of the headstock and plane the workpiece to the desired thickness.

This DRO has a resolution of 0.005" or 0.05mm.

The DRO display turns off if the thickness setting remains unchanged for 5 minutes. It will turn back on when the headstock position changes or when someone presses any buttons on the DRO.

When the planer is connected to the power, the DRO stores the current value when it remains unchanged for 2 seconds. The DRO displays "- - - -" when it saves the value. The saved value persists even when the planer is cut off from power. However, the DRO won't register headstock position changes without power. Therefore, it is recommended to recalibrate the DRO each time the planer reconnects to a power source to ensure proper thickness settings of the DRO.

DRO Controls

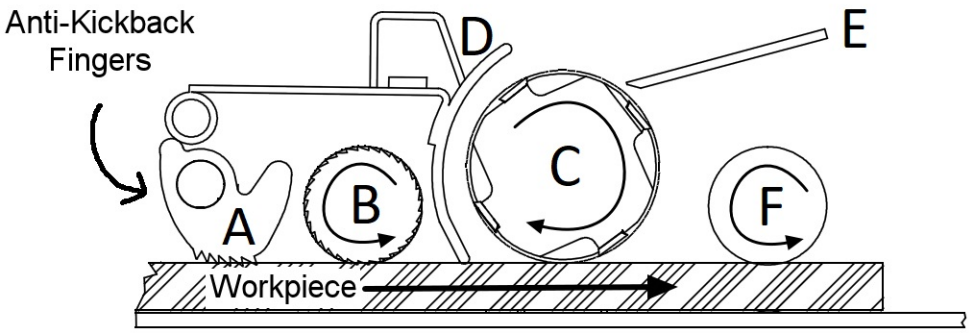
Display Button	Press this button to turn on/off the display.
IN/MM Button	Toggle measuring unit between metric (mm) and US standard (inch).
ABS Zero Button	Short press to set the display value to 0 and use the DRO to measure the offset between thickness settings. Long press to set the value to 0.185. This function is to reset the value to the minimum distance between the planer table and the cutterhead (see "DRO Calibration" below).
Stock Removal Indicator Light	This light turns on when the DRO displays a value less than zero.

DRO Calibration

1. Rotate the depth stop to the 3/16" position. This is the planer's minimum thickness setting.
2. Lower the headstock until the depth positive stop bolt rests on the depth stop.
3. Long press the "ABS Zero" button for 2 seconds, and the value of the DRO should reset to "0.185", which matches the depth stop settings.
4. The DRO will stay calibrated unless the user short-presses the "ABS Zero" button and sets the value to zero.

Components for Planing Wood

This diagram shows the components involved in planing a piece of wood:



How it works:

1. As a workpiece enters the planer, the anti-kickback fingers **[A]** engage the workpiece to prevent accidental kickback.
2. When the workpiece enters the planer**,** the infeed roller **[B]** pulls the workpiece towards the cutterhead **[C]**.
3. Cutterhead then planes the workpiece to the desired thickness.
4. Wood chips and dust generated by the cutterhead are collected by the chip breaker **[D]** and diverted toward the dust shroud **[E]**.
5. As the workpiece moves past the cutterhead, the outfeed roller **[F]** pulls the workpiece away from the planer.

Test Run

To familiarize yourself with this planer and ensure everything is well-calibrated, you are advised to run the following tests before commencing production work.

Step 1: Verify all electrical components are functional.

1. Remove all tools and debris from the planer table and the extension tables.
2. Make sure the power switch is in the OFF position.
3. Connect the machine to the power source.
4. Make sure the DRO is turned on.
5. Flip the power switch to ON. The planer should start running with no excessive vibration or noise.
6. Flip the power switch to OFF to stop the machine.

Step 2: Verify that the planer is functional and calibrated.

1. Connect the planer to a dust collection system.
2. Move the headstock to the lowest position. The headstock should stop at the 3/16" mark as shown on the manual thickness scale or the height set by the depth stop.
3. Raise the headstock all the way up. It should stop approximately at the 6" mark on the manual thickness scale.
4. Ensure all anti-kickback fingers can move freely.
5. Observe the DRO readings. It should reflect the movements of the headstock.
6. Prepare a piece of good quality, straight-grain wood board with a flat bottom for a test run. It is advised to choose a board that is close to 15" wide and at least 2 feet long.
7. Start the dust collection system.
8. Set the depth of cut to approximately 3/64” for a test pass.
9. Turn on the dust collection system and the planer, then begin feeding the workpiece. The feed rollers should pull the workpiece through the planer. Verify the entire top surface is planed.
10. Turn off the planer and dust collection system, then inspect the workpiece for any defective finish.
11. Using a caliper, check that the workpiece thickness is uniform side-to-side and front-to-back. This ensures the cutterhead is parallel with the planer table.
12. Check the manual thickness scale. It should point at the same value as shown on the caliper.
13. Check for excessive snipe. A minimum amount of snipe may occur at the ends of the board, and it is expected.

Congratulations! You have completed the test run, and your planer is ready for production work. If you discover any issues from the tests, please refer to the troubleshooting section and maintenance section to diagnose issues and make adjustments.

Accessories

Oliver Machinery has a collection of accessories for your planer. Please visit our website, **OLIVERMACHINERY.NET,** to purchase these items.

You may also call **1-800-559-5065** or email **PARTS@OLIVERMACHINERY.NET** to purchase these items. We are available Monday through Friday, 7:30 AM - 4 PM Pacific Time.

> ⚠ **WARNING** **Using unapproved accessories may cause the machine to malfunction, resulting in serious injury and/or machine damage. Only use accessories recommended for this machine.**

Cutter Inserts

Genuine HCX four-sided indexable carbide cutter inserts compatible with the Oliver **10055 Planer**. Sold in box of 10.

Part numbers:
Cutter Inserts (Box of 10) - **P-15mm4S**
Torx Screws - **038201-101**

Mobile Tool Stand

Need to move the planer around the shop? This tool stand comes with a pre-drill table top for mounting the planer, an ergonomic height-adjustable metal frame, and four heavy-duty locking swivel casters. The casters are equipped with leveling rubber feet to keep the planer stationary even on an uneven floor.

Part number: **A-ADJSTAND.001**

Please visit our website at **WWW.OLIVERMACHINERY.NET/ACCESSORIES** for other recommended accessories.

Operation

For safety and to achieve the best results, please take the following steps before processing any workpiece with this planer.

Step 1: Preparation

Only Use Natural and Quality Wood

Only plane good quality natural wood materials. Cracked stock, boards with loose knots, plywood, and other engineered wood products can break apart and cause severe kickbacks, which can lead to severe injuries and machine damage.

Do not plane treated lumber or anything that contains harmful chemicals, as this will spread wood dust that contains such harmful chemicals.

NEVER plane boards that are shorter than 8", as mentioned in the specifications.

Inspect the Workpiece

Carefully inspect the workpiece for foreign objects. Nails, staples, rock chips, and other objects embedded on the wood surface will damage the planer. To avoid chipping or dulling the cutter inserts, clean the workpiece with a stiff brush to remove all dirt and foreign objects before planing, especially for rough-sawn or reclaimed lumber. Use a metal detector to scan for metal objects as needed.

Check Moisture Content

Check the moisture content of stock before the operation. "Green wood" with moisture content over 20% will not cut properly and may jam the machine. Excessive moisture content can also cause the planer's unpainted surface to rust. Besides, as the workpiece dries, the once-flattened surface can become fuzzy and warped again. Allowing a workpiece to dry and stabilize before it is processed is recommended.

Warped Stock

Boards with moderate cupping, bowing, or twisting should have one side face-jointed before being processed by a planer. It is acceptable to process a slightly cupped board. Make sure the concave side is facing down, and begin with light cuts.

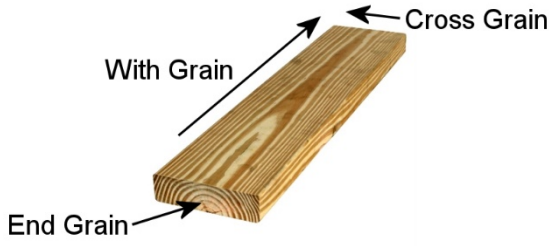
Avoid using boards that are severely warped, as they can be unstable and might cause severe kickbacks during operation.

Glue Deposits

Glue left on the workpiece surface can dull cutters and impact cut quality. Scrape off all glue deposits from the workpiece before the operation.

Wood Grain Direction

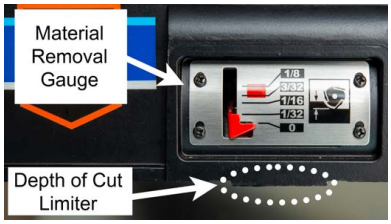
This planer is designed to plane WITH the grain direction of the wood. Do not plane cross-grain or end-grain. Severe kickback and chipping may occur.



Step 2: Setting the Depth of Cut

Each rotation of the headstock handwheel changes the depth of cut by 1/16. To make small and repeatable depth of cut adjustments, use the DRO. The manual thickness scale provides a quick view of the cutterhead's position, and the depth stop provides five thickness presets.

This planer can remove at most 1/8" of materials per pass. For stocks that are over 6-1/2" wide, the planer can remove at most 3/64" of materials per pass. The depth of cut limiter limits the depth of cut of wide stock. To plane narrow stock with a greater depth of cut, feed the stock on either side of the planer table and avoid the limiter.

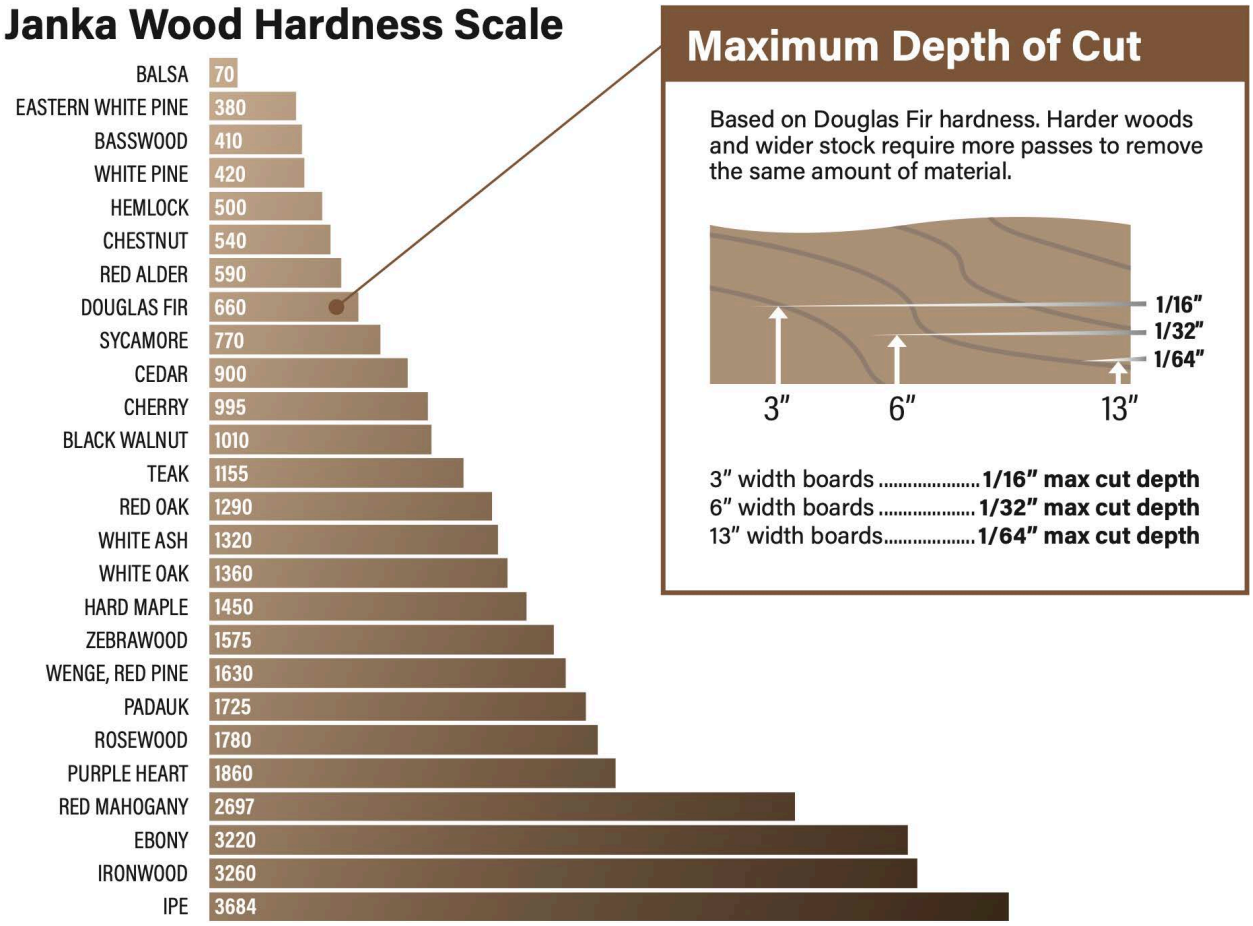


When a workpiece is fed slightly past the limiter, the material removal gauge shows the amount of material to be removed. Take light passes and reduce the feed rate when approaching the desired thickness.

Wood Hardness

Reduce the maximum depth of cut for wood types that are extremely hard or extremely soft. Hardwood increases the planer's workload, and very soft wood species may get a poor finish when receiving aggressive cuts.

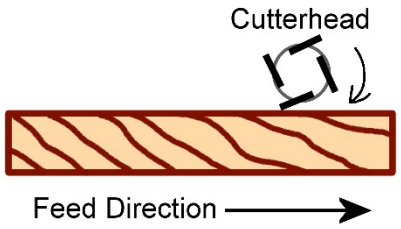
The Janka scale shows the hardness of wood types that are commonly used. It ranks the hardness of various wood types by measuring the amount of force (in lbs.) required to embed a 0.444" steel ball halfway into the wood.



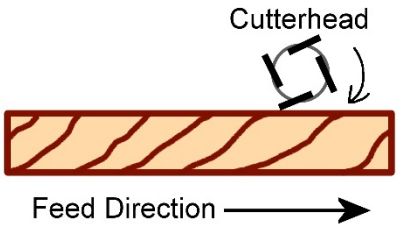
Step 3: Determining the Feed Direction

Inspect the workpiece and identify the direction of the edge grain. Choose a feed direction such that cutters will cut WITH grain to minimize tearouts.

Good – Planer cuts WITH the grain.



Not Ideal – Planer cuts AGAINST the grain.



Sometimes, it is impossible to cut with the grain for the entire length of a workpiece. In this case, try feeding the workpiece in the opposite direction and see what works best. Reducing the depth of cut can also help improve cut quality.

Step 4: Planing Wood to Desired Thickness

With the above preparation steps completed, the workpiece is ready for planing.

⚠ **WARNING**	**Always wear goggles and other protective devices when operating this machine. Stay on the side of the planer to avoid kickback-related accidents. NEVER look inside the planer during operation. Failing to comply may result in serious injuries or death.**

⚠ **CAUTION**	**Use an ear protection device to prevent hearing loss. Ensure the dust collection system is functional, and use a dusk mask to avoid inhaling harmful airborne particles.**

1. Put on protection devices.
2. If you have a long workpiece, make sure it is properly supported throughout the process. Bolt down the planer on a stable surface as needed.
3. Measure the workpiece thickness and set the initial depth of cut to no more than 1/32". This allows feed rollers to properly engage the workpiece and not remove too much material for a test pass.
4. Turn on the dust collection system and planer.
5. While standing on the side of the workpiece, gently feed the workpiece with the face jointed side down. Once the infeed roller engages the workpiece, allow the machine to feed the workpiece. **DO NOT** force feed the workpiece through the planer.

   If the infeed roller does not engage the workpiece:
   - The headstock height is set too high.
   - Stop the machine and wait for it to come to a complete stop, then raise the headstock to remove the workpiece.
   - Lower headstock height and restart from step 4.

If the machine stalls or the workpiece gets stuck:

- The headstock height is set too low.
- Stop the machine and wait for it to come to a complete stop, then raise the headstock to remove the workpiece.
- Reduce the depth of cut, and restart from step 4.

6. If the workpiece is feeding properly, wait until the entire workpiece clears the outfeed roller, then remove the workpiece. Support the workpiece as it exits the planer.
7. After the initial pass, measure the workpiece thickness in the midsection.

If more material needs to be removed, continue with the following steps.

8. If you need to remove a lot of material, run a few passes with deeper cuts, then finish with a light pass.
9. The depth of cut for each pass should be less than 1/8". For workpieces 6-1/2" or wider, the depth of cut is limited to 3/64”. Reduce the maximum depth of cut for harder wood types. Use DRO to adjust the depth of cut.
10. Repeat until the workpiece has reached the desired thickness.

Turn off the planer when the work is completed.

Common Wood Planing Problems

Snipe

When a workpiece is not properly supported as it enters or leaves the machine, the ends of the workpiece will have more materials removed than the rest of the section. To mitigate this problem, hold the workpiece up slightly as it enters and leaves the machine. Sometimes, a small amount of snipe is inevitable. The best way to eliminate snipe completely is to prepare a workpiece of extra length and then trim the ends when the planing is done. You can also try adusting the the outside edges of the infeed and outfeed tables to above level 1mm at a time, see page 34.

Chipping

Happens when cutting against the grain direction. See "**Select Feed Direction**" in this section. For highly figured lumber and areas near a knot, some amount of chipping is normal. In this case, moistening the problematic area before planing can sometimes mitigate the issue.

Chipping can also be caused by dirty or dull cutters. If chipping happens while planing straight grain stocks, inspect cutter inserts and remove all resin buildups. Rotate/replace dull cutter inserts when they are dull.

Indentation

This can happen when some foreign object is pressed on the workpiece when it passes through the planer. Remove all resin buildups from the rollers, cutterhead, and table. Also, check the dust collection system and ensure wood chips are effectively removed.

Grooves or ridges along the plane direction

Check the cutter inserts to make sure they are not shifted, chipped, or destroyed.

Fuzzy Grain

This can happen when planing wood with high moisture content or if the cutter is dull. Sometimes, this is unavoidable due to the nature of certain wood types. To mitigate this issue, avoid using wood with high moisture content and use sharp cutters.

Maintenance

Routine maintenance keeps your planer in top shape. Please follow the maintenance schedule below and use the maintenance record worksheet in the manual to document all tasks completed.

NOTICE: Maintenance schedule may vary for individual users due to different situations and safety requirements.

⚠ **WARNING**	**Disconnect the machine from the power source before any maintenance work is performed. After servicing the planer, remove all wrenches and tools before restarting the machine. Failure to comply can cause serious injury!**

Maintenance Schedule

Interval	Task
Every day	Remove dust buildups from the planer.
	Inspect the power cord and plug for signs of aging and damage. Replace as needed.
Every week	Inspect cutterhead, rollers, and anti-kickback fingers. Remove any dust and resin accumulation.
	Inspect/rotate/replace worn cutter inserts.
	Wax planer table and extension tables.
Every 6 months	Inspect the elevation of the extension tables. Adjust as needed.
	Inspect the poly V-belt and replace it if it shows signs of cracking or glazing.

Notice: Motor bearings are permanently sealed and lubricated and do not require lubrication.

Rotate/Replace Cutter Inserts

⚠ CAUTION **Cutter inserts are extremely sharp. Protect your hands with thick leather gloves to avoid injuries.**

1. **Disconnect the planer from the power source!!**
2. Remove the dust shroud.
3. Remove the cutterhead cover screws with a 4mm hex wrench.

4. Remove dust and resin accumulations on the cutterhead and areas nearby.

5. Use a 4mm hex wrench to manually rotate the cutterhead and inspect the cutter inserts.

6. Rotate cutter inserts 90° clockwise when they get dulled or nicked.
7. To rotate/replace a cutter insert, remove the Torx screw with a T-25 Torx bit. Turn **COUNTERCLOCKWISE** to loosen the screw.
8. With the cutter insert removed from its seat, thoroughly clean the seat with a vacuum.

IMPORTANT: Obstacles between the insert and its seat will create uneven pressure against the insert. This will impact cut quality and may cause the insert to break.

9. Inspect the Torx screw. Replace any damaged screws. Lubricate screw thread with a thin coat of lightweight machine oil or anti-seize.

   IMPORTANT: Do not apply an excessive amount of lubrication, or the Torx screw and the cutter insert will not sit properly.

10. Reinstall the cutter insert with the Trox screw and the marked cutting edge facing out. Secure the cutter insert with 55 lbs.-inch of torque. Use a torque wrench to tighten the screws if one is available.

    IMPORTANT: Do not overtighten the screw, or the inserts may break. Do not use power tools to tighten the Torx screws, as it can strip the screws.

11. Reinstall the cutterhead cover and dust shroud after servicing the cutterhead.

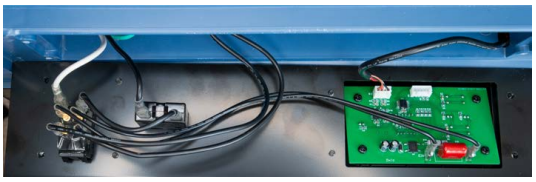
Inspect / Replace Poly V-Belt

1. **Disconnect the planer from the power source!!**
2. The drive belt of the planer is located behind the right panel. To access the drive belt, begin by removing the headstock handwheel and the three screws marked in the picture.

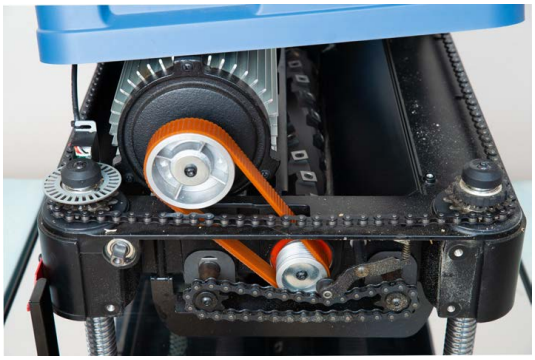
3. Loosen these four screws on the front panel.

4. Temporarily open the front panel and remove the two socket cap hex screws behind the panel.

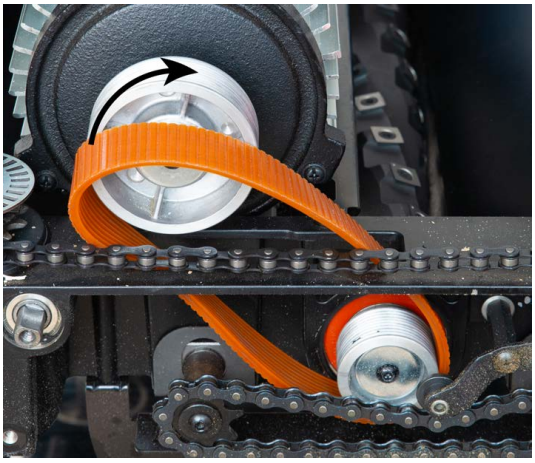
TIP: Take a picture of the back of the panel to keep track of the wiring, so the wires can be easily reattached when needed.



5. Reattach the front panel, then lift the right side of the top panel to expose both motor and cutterhead pulleys. Be careful not to damage any exposed electrical wires.



6. Inspect the drive belt for signs of wear and tear. Replace the belt as needed.
7. To replace the drive belt, walk the old belt away from the motor pulley, then remove the belt from the cutterhead pulley and slip the belt through the openings.
8. Reverse the previous step to install the new belt. A new belt can be very tight, so walk the belt back to the pulleys one groove at a time on the motor pulley. Refrain from using sharp tools to pry the belt back in place, as it may damage the new belt and pulleys.



9. Rotate the pulleys and make sure the drive belt is fully seated into the grooves of the pulleys.
10. Reverse steps 2-5 to re-install the top cover, front panel, right panel, and handwheel after servicing the belt.

Inspect / Adjust Extension Tables

The extension tables should be adjusted so that they are level with the planer's main table.

To Adjust the Extension Tables

1. **Disconnect the planer from the power source!!**
2. Place a long straight edge that spans across the planer table and the extension tables. Adjust the tables to be level on the left and right side and secure adjustment srews.

3. If adjustment is needed, loosen the extension table mounting screws and adjust the extension tables. Tighten the mounting screws after the adjustments.

The left and right side of both extension tables should be flush with the main table.

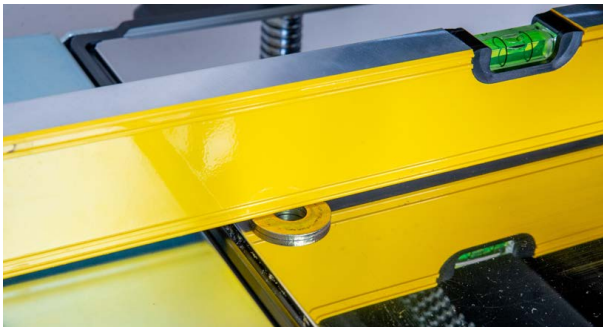
To Adjust for Potential Snipe

When planing heavy stock, the weight of the stock may cause the extension tables to dip below the planer table causing snipe. If this happens, raise outer edges of the extension tables in 1mm increments up to 3mm.

1. **Disconnect the planer from the power source!!**

2. Using pennies or flat washers as a reference under the straight edge on the main table.

   There should be a gap formed between the straight edge and the planer's main table. Inside edges should be level, outside edges can be lifted slightly in approximately 1mm increments as needed.

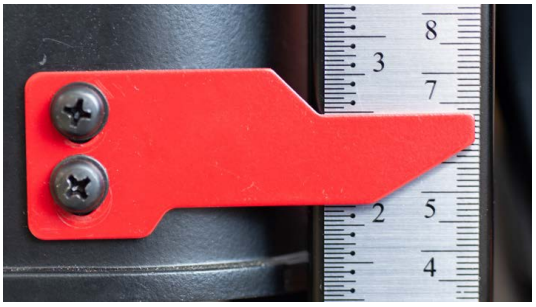


3. The straight edge should rest on the outside edge of the extension tables while leaving a 1mm gap between the straight edge and the main table.

Adjust Cutterhead Height Scale

The cutterhead height scale is pre-calibrated in the factory. It can be re-adjusted to accommodate a different viewing angle or if the pointer is shifted.

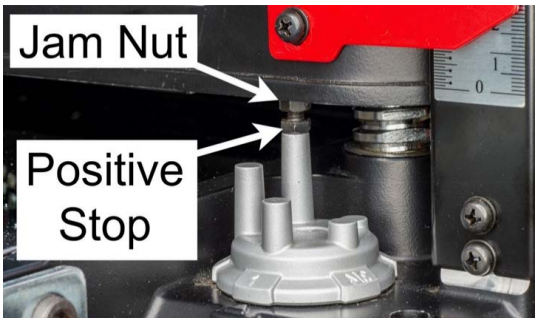
1. Prepare a piece of scrap board with a flat bottom for calibration.
2. Plane the board down to the desired thickness. Use a caliper to measure the mid-section of the board for thickness.
3. Loosen the screws that hold the pointer in place.



4. Shift the pointer so it is pointing at the exact value of the thickness of the board.
5. Re-tighten the screws.

Depth Stop Positive Stop Adjustment

1. Prepare a scrap board that is slightly over one of the depth stop's presets (3/16", 1/4", 1/2", 3/4", 1").
2. Rotate the depth stop to the desired position. For instance, dial the depth stop to 1" when using a 1-1/8 scrap board for adjustments.
3. Lower the headstock until it rests on the depth stop.
4. Switch the DRO to incremental mode and make sure the value is zeroed. This value indicates the original position of the headstock. Do not reset this value until completing the adjustments steps.
5. Plane the scrap board. Use a caliper to measure the thickness of the midsection of the board. The measurement should match the depth stop's preset.
6. If the measurement is different from the preset, adjustment is necessary. Calculate the difference, then loosen the jam nut and slightly back off the positive stop nut.



7. Use the DRO to adjust the headstock position to compensate for the error.
8. Hand rotates the positive stop nut so it presses against the depth stop, then holds the nut in place and tightens the jam nut.
9. Plane another scrape board to verify the adjustments. Repeat the adjustment steps as needed.

Anti-Kickback Fingers Inspection

This planer is equipped with anti-kickback fingers. Once engaged, the workpiece can only move toward the cutterhead. This safety device prevents accidental kickbacks, which can cause serious injuries.

Inspect the anti-kickback fingers regularly to ensure they can move freely. Make sure their claws are clean and sharp enough to stop a board from moving backward. Clean and apply a very light coat of SAE-30 machine oil as needed to prevent rust.

Replace anti-kickback fingers if they are damaged or worn.

> ⚠
> **CAUTION**
>
> **Do not operate this planer without functioning anti-kickback fingers. Failure to comply can result in serious injury.**

Troubleshooting

Mechanical / Electrical Issues

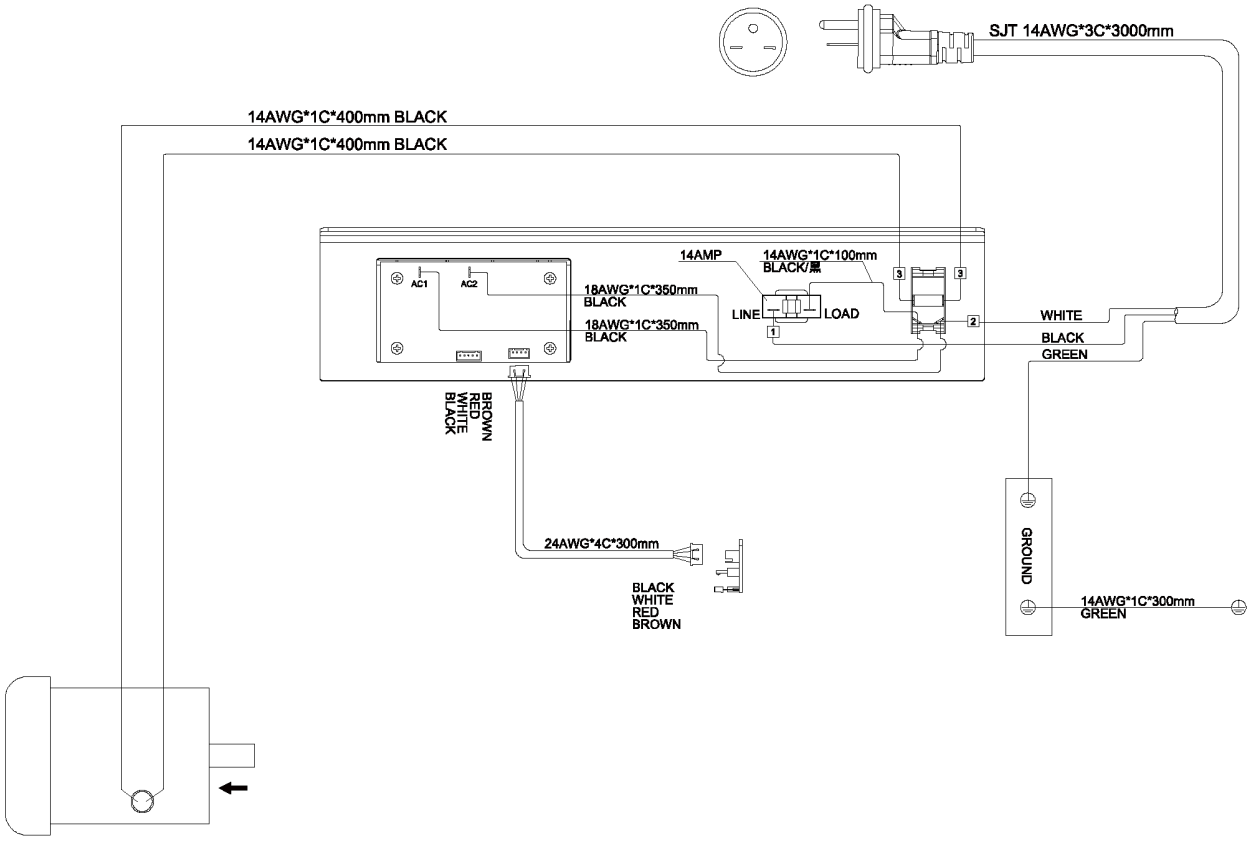
Problem	Possible Cause	Possible Solution
Machine does not start.	Machine is not connected to a power source.	1. Make sure the machine is plugged in. 2. Check the electrical panel for a tripped circuit breaker or a blown fuse. 3. Ensure all electrical connections have good contacts.
	Low voltage/current.	1. If an extension cord is used, use a shorter/heavier extension cord. 2. Have an electrician to check/repair the power circuit.
	Overload protection triggered.	Press the overload protection reset button to reset.
	Faulty switch/motor.	Contact customer service for further assistance.
Machine trips thermal protection/circuit breaker or blow fuses.	Machine is undersized for the operation.	Reduce the depth of cut.
	Workpiece moisture level is too high.	Only plane wood with moisture level below 20%.
	Machine is jammed.	Inspect the cutterhead and make sure it is not obstructed by woodchips. Check dust shroud and clear blockages.
	Too much load on a circuit.	Make sure the power circuit is sized for this machine. If the circuit is shared, ensure it is sized to supply power for all items in the circuit.
	Motor issue.	Contact customer service for further assistance.
Machine stalls during operation.	Machine is undersized for the operation.	Reduce the depth of cut.
	Dull cutters.	Rotate/replace cutter inserts.
	Belt slipping.	Clean belt and pulleys. Replace the belt as needed.
	Motor issue.	Contact customer service for further assistance.
Machine stopped during operation.	Overload protection triggered.	Hit the OFF button and allow the machine to cool down for at least 3 minutes, then press the overload protection reset button. Reduce the depth of cut before resuming work.
Digital readout is not functional.	Display is turned off.	Press any button on the DRO to reactivate the display.
	Malfunctioning circuit board.	Contact customer service for further assistance.

Problem	Possible Cause	Possible Solution
Workpiece does not feed smoothly.	Dirty planer table/feed rollers.	Clean table and rollers. Apply paste wax on the planer table and extension tables to reduce drag. Do not use silicone lubrication.
	Belt slipping.	Clean belt and pulleys. Replace the belt as needed.
Machine vibrates excessively or makes unexpected noise.	Damaged cutter inserts.	Replace cutter inserts.
	Machine stands on an uneven surface.	Reposition on a flat, level surface.
	Drive belt worn, slipping, or hitting belt cover.	Clean belt and pulleys. Replace the drive belt if it shows signs of aging.
	Loose components.	Tighten the fasteners of the component.
Board thickness does not match the scale's measurement.	Manual thickness scale pointer is mispositioned.	Adjust the scale.
	DRO is not calibrated.	Re-calibrate the DRO.
	Depth stop’s positive stop is mispositioned.	Adjust the positive stop.
Unable to turn headstock handwheel.	Headstock is stopped by depth stop.	Adjust the depth stop's minimum height setting. Minimum cutterhead height is 5/32".
	Handwheel knob is fully tightened.	Loosen the knob by 1-2 turns.

Finish Quality Issues

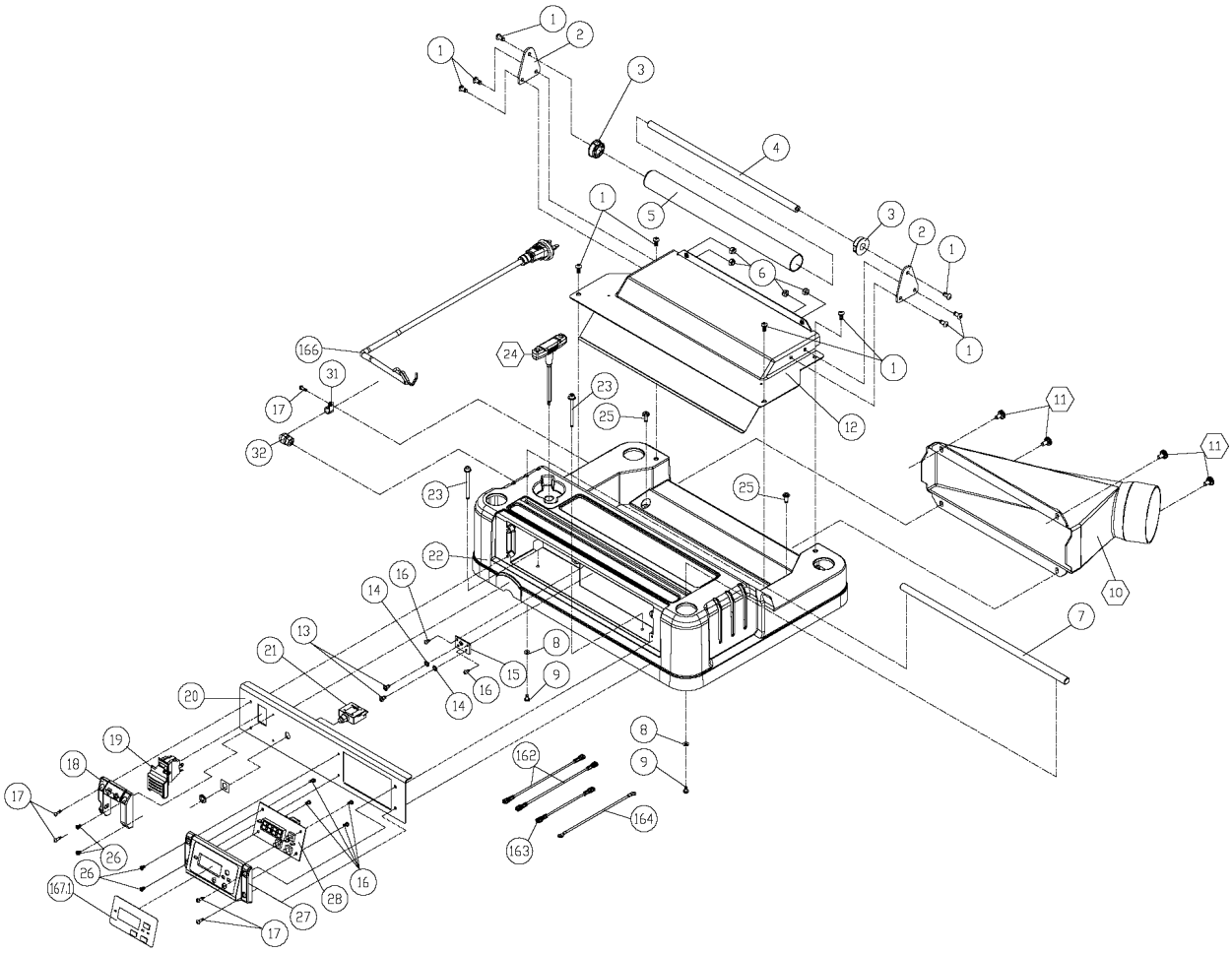
Problem	Possible Cause	Possible Solution
Workpiece came out twisted.	Workpiece is twisted before the cut.	Planer is not the tool to flatten a twisted workpiece. Flatten one side with a jointer before proceeding with a planer.
Excessive snipe.	Extension wing slope down.	Adjust extension table elevation.
	Long workpiece is not supported properly.	Use auxiliary rollers to support the long workpiece.
	A small amount of sniping can happen sometimes.	Add an extra 6" length on a workpiece for planing, and then trim off the ends.
End of workpiece chipping.	Aggressive depth of cut for the wood type.	Reduce the depth of cut.
	Planing end grain.	Do not plane end grain. Use a drum sander instead.
Chipping in workpiece surface.	Dull or damaged cutter.	Rotate/replace cutter insert.
	Planing against/across grain or knots.	Avoid planing workpieces with knots. Plane with grain whenever possible. Moisten problematic areas before planing.
	Too much material was removed in one pass.	Reduce the depth of cut.
Indentation in workpiece surface.	Dirty rollers.	Remove all buildups on infeed and outfeed rollers.
	Inefficient chip removal.	Check the dust collection system for suction.
Fuzzy-looking finish.	Wood moisture content is too high.	Only process wood with less than 20% moisture content.
	Dull cutter.	Rotate/replace cutter insert.
	Some wood types tend to have fuzzy grain.	Adjust the depth of cut. Use sharp cutters.
Glossy-looking finish.	Dull cutter.	Rotate/replace cutter insert.
	Cutting depth too shallow.	Increase the depth of cut.
Long lines or ridges run along the length of the board.	Chipped or incorrectly installed cutter.	Rotate/replace cutter insert.

Wiring Diagram

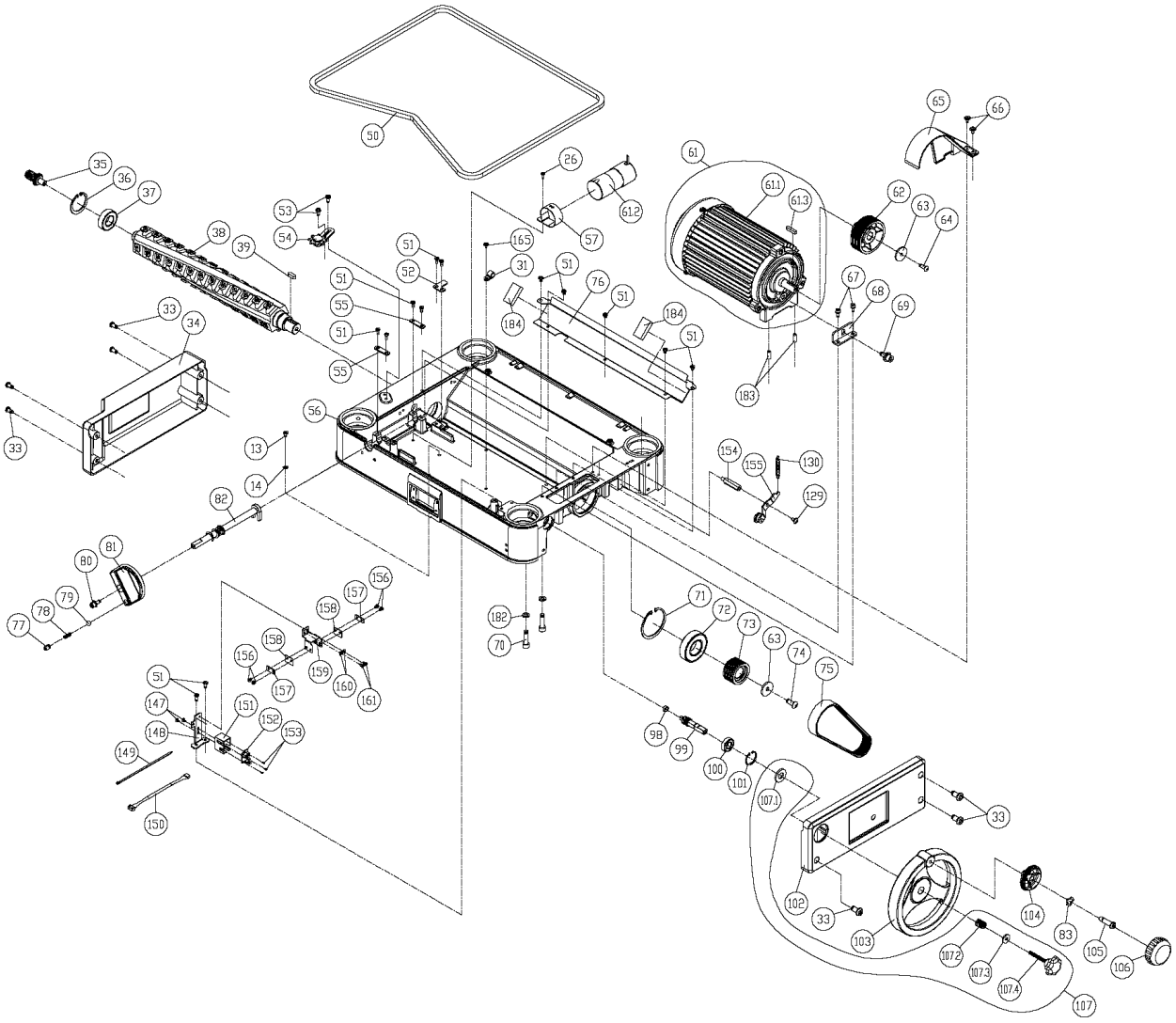


Parts List

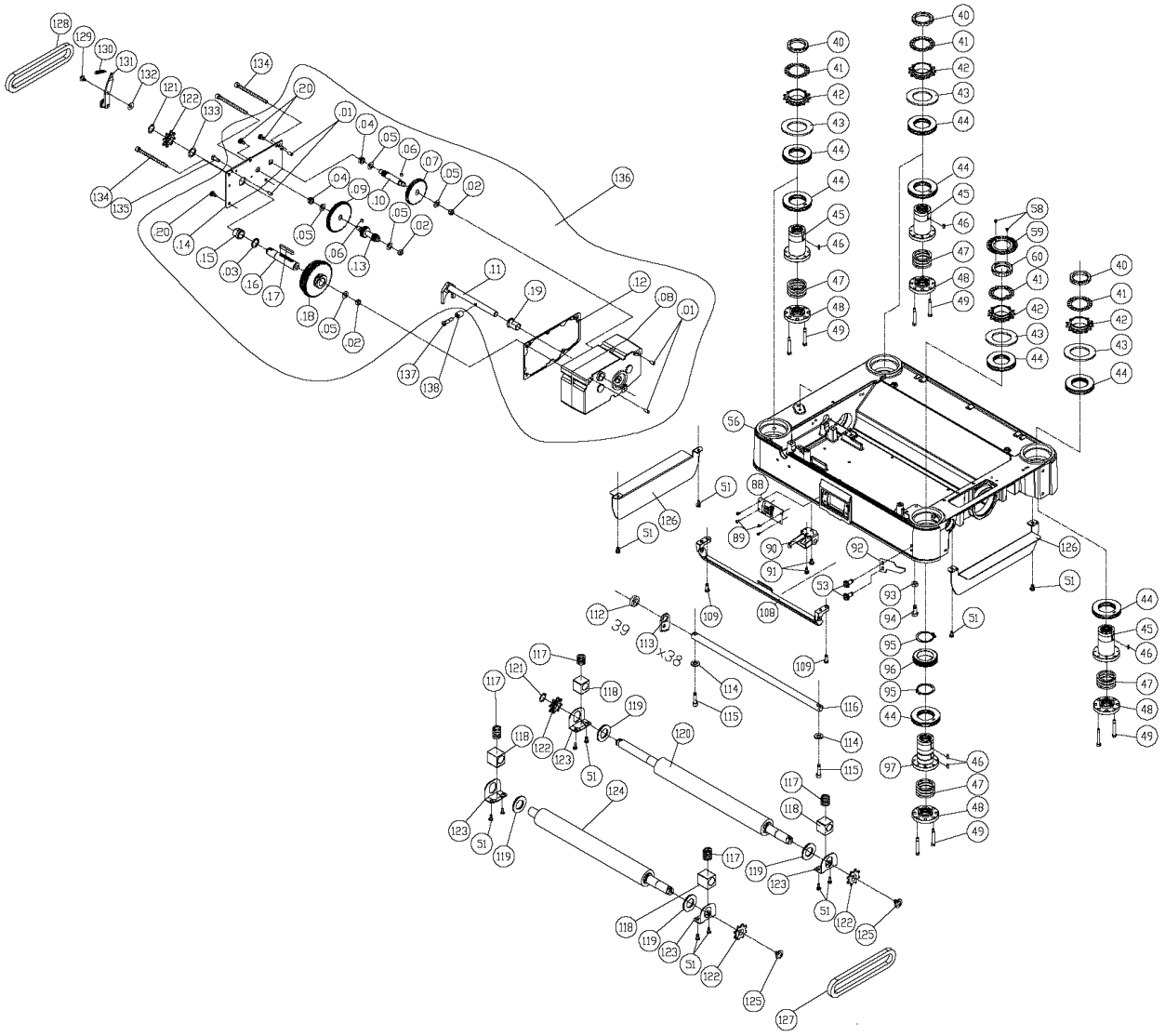
Top Cover



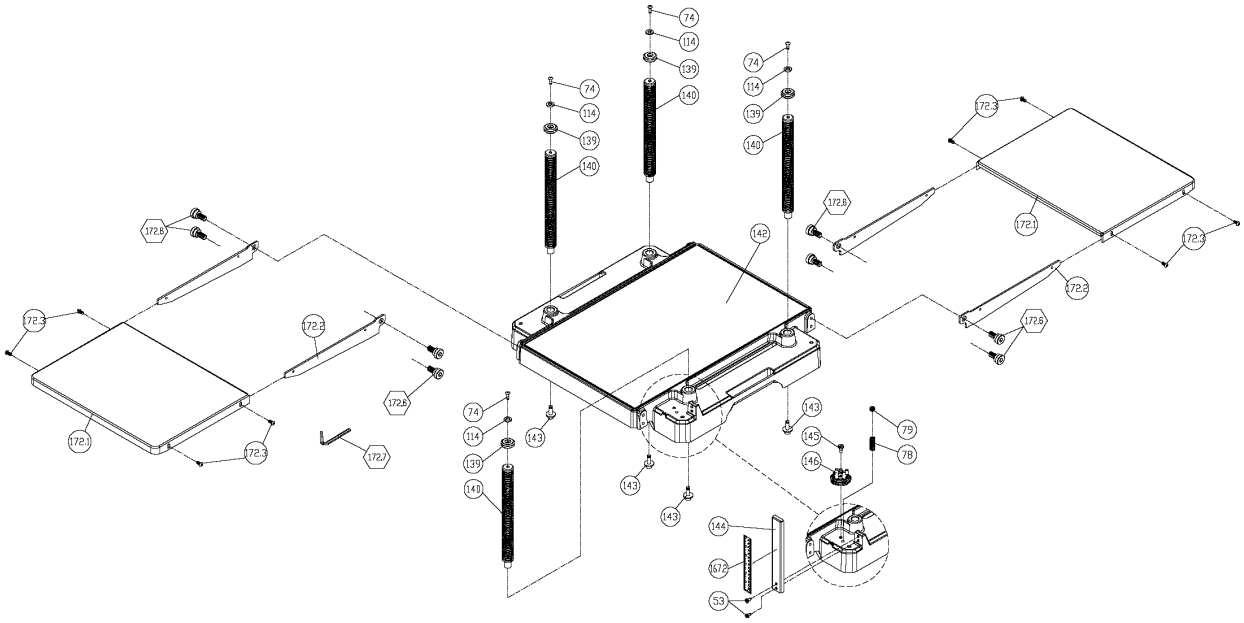
Motor and Cutterhead



Head Casting



Base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172.7

Key	Part Number	Description	Specification	QTY
1	000801-102	Round Head Hex Screw	M6*1.0P*12	10
2	175335-904	Roller Bracket		2
3	250251-615	Bushing		2
4	361543-901	Roller Shaft		1
5	190331-906	Roller		1
6	008304-100	Locking Nut	M6*1.0P	4
7	361542-906	Support Rod		1
8	006003-009	Flat Washer	5.2*10*1.0t	2
9	002002-101	Round Head Phillips Screw	M5*0.8P*8	2
10	251546-615	Dust Chute		1
11	230452-000	Knob	M6*12L	4
12	175325-008	Dust Hood		1
13	000303-102	Round Head Screw	M5*0.8P*8	4
14	006502-100	Teeth Washer	5.3*10(BW-5)	3
15	175330-000	Grounding Plate		1
16	001201-804	Self Tapping Screw	M4*1.41P*8	6
17	001201-801	Self Tapping Screw	M4*1.41P*12	5
18	250658-615	Switch Cover		1
19	830014-001	Safety Switch Assembly		1
20	175323-904	Front Cover		1
21	924567-001	Overload Switch Assembly	14AMP(220V-240V)	1
22	251530-000	Top Cover		1
23	001702-101	CAP Screw w/Flat Washer	M5*0.8P*60-5.3*12*1.0t	2
24	925317-000	T Wrench	T25	1
25	001602-106	Round Head Phillip Screw w/Flat Washer	M5*0.8P*15/5*12*0.8t	2
26	000302-102	Round Head Phillips Screw	M4*0.7P*8	4
27	251532-615	DRO Cover		1
28	491289-000	DRO		1
29	008005-100	Hex. Nut	M6*1.0P	4
30	010602-000	Retaining Ring	CRTW-12	4
31	021103-100	Cable Clamp	ACC-3-B	2
32	020203-000	Strain Relief	SR11-2(HEYCO)	1
33	000304-103	Round Head Screw	M6*1.0P*12	7
34	251528-615	Side Cover-L		1
35	320426-000	Worm Shaft		1
36	010106-000	Retaining Ring	RTW-42	1

Key	Part Number	Description	Specification	QTY
37	030214-002	Ball Bearing	6004	1
38	925325-001	Helical Cutterhead Assembly	with 40 inserts	1
39	012004-001	Key	6*6*20	1
40	130094-903	Locking Nut		3
41	170746-901	Lock Washer		4
42	150016-000	Sprocket		4
43	250413-615	Dustproof Sheet		4
44	920133-000	Bearing		8
45	300039-000	Lead Screw Seat		3
46	012001-003	Key	3*3*10	5
47	280083-901	Spring		4
48	130090-000	Backlash Nut		4
49	000102-814	Socket Head Cap Screw	M5*0.8P*44.3	8
50	016231-000	Chain	#410-140P	1
51	000303-803	Round Head Screw	M5*0.8P*10	25
52	170753-901	Plate		1
53	002402-101	Round Head Phillips Lock Screw w/washer	M5*0.8P*12/5*10*1.0t	6
54	925320-000	Lift Tension Wheel Assembly		1
55	170292-901	Fixing Plate		2
56	090403-008	Head Casting		1
57	491290-000	Buckle		1
58	000301-111	Round Head Screw	M3*0.5P*4	2
59	175331-000	Sensing Piece		1
60	130428-903	Nut		1
61	901399-000	Motor Assembly with Key	2.5HP*1Ph*230V*60HZ	1
61.2	496346-000	Running Capacitor	30UF/450VAC(LAI)(50*90.5)	1
61.3	012202-009	Key	5*5*25	1
62	090407-000	Motor Pulley		1
63	006002-212	Flat Washer	6.5*30*3t	2
64	002602-103	Cap Locking Screw	M6*1.0P*16	1
65	251551-615	Belt Cover		1
66	001602-101	Round Head Phillips Screw & Flat Washer	M5*0.8P*10/5*12*0.8t	2
67	048902-104	CAP Lock Screw w/Spring Washer	M5*0.8P*12L-5.1*9.3*1.3t	2
68	175406-000	Motor Bracket		1

Key	Part Number	Description	Specification	QTY
69	001501-101	CAP Screw w/Spring Washer & Flat Washer	M8*1.25P*20/8.2*13.7/8.5*19*2t	1
70	002601-110	Cap Locking Screw	M8*1.25P*30	2
71	010109-000	Retaining Ring	RTW-62	1
72	030210-002	Ball Bearing	6206	1
73	090408-000	Cutter Head Pulley		1
74	002501-805	Round Head Hex. Lock Screw	M6*1.0P*16	5
75	014383-000	Poly-V-Belt		1
76	175424-904	Inner Chip Guard		1
77	000204-103	SET Screw	M8*1.25P*12	1
78	280052-000	Spring		2
79	017002-000	Steel Ball	Ø6	2
80	049901-001	CAP Lock Screw w/Spring Washer & Flat Washer	M6*1.0P*15/6.5*10.5/6.2*13*1.5t	1
81	251527-615	Knob		1
82	925387-000	Gear Lever Assembly	PJ42	1
83	006702-100	Wavy Washer	WW-8	1
88	175426-000	Depth Scale		1
89	000301-101	Round Head Screw	M3*0.5P*6	4
90	921977-000	Depth Pointer		1
91	048101-101	Round Head Phillips Screw w/Spring Washer	M5*0.8P*10-5.1*9.3*1.3t	2
92	175326-156	Pointer		1
93	008004-100	Hex. Nut	M5*0.8P	1
94	000001-109	Hex. Screw	M5*0.8P*12	1
95	010014-000	Retaining Ring	STW-35	2
96	320227-000	Gear		1
97	300038-000	Main Lead Screw Seat		1
98	160019-000	Copper Bushing		1
99	320234-901	Gear (s)		1
100	030113-001	Ball Bearing	6001ZZ(A)	1
101	010112-000	Retaining Ring	RTW-28	1
102	251529-615	Side Cover-R		1
103	090405-008	Handwheel		1
104	251533-615	Knob		1
105	360302-901	Knob Shaft		1

Key	Part Number	Description	Specification	QTY
106	250262-615	Knob Cover		1
107	925385-001	Lock Handle Assembly		1
107.1	006001-091	Flat Washer	13*28*3.0t Black	1
107.2	280134-000	Compression Spring		1
107.3	006001-036	Flat Washer	6.7*19*2.0t Black	1
107.4	230453-000	Knob	M6x50L	1
108	925388-001	Limited Plate	PJ42	1
109	048101-102	Round Head Phillips Screw w/Spring Washer	M5*0.8P*16-5.1*9.3*1.3t	2
112	250060-615	Spacer		38
113	170165-905	Anti-Kickback Plate		39
114	006001-024	Flat Washer	6.4*12*1.5t	6
115	002602-106	Cap Locking Screw	M6*1.0P*25	2
116	361339-902	Shaft for Anti-Kickback Plate		1
117	280084-901	Roller Spring		4
118	130089-000	Roller Bushing		4
119	660001-000	Packing		4
120	340144-000	Outfeed Roller		1
121	010006-000	Retaining Ring	STW-15	2
122	380257-901	Chain Sprocket		4
123	170623-902	Roller Bushing Bracket		4
124	340143-000	Infeed Roller		1
125	048602-101	Round Head Hex. Screw w/Washer	M6*1.0P*10L*19*2t	2
126	175328-904	Cover		2
127	016232-000	Chain	#410-34P	1
128	016214-000	Chain	#410-30P	1
129	290028-901	Shoulder Screw		2
130	280082-000	Tension Spring		2
131	920145-001	Tension Wheel Assembly-L		1
132	006001-010	Flat Washer	5.2*12*1.5t	1
133	006001-100	Flat Washer	15.5±0.1*21*0.8±0.05	1
134	000103-117	Socket Head Cap Screw	M6*1.0P*85	3
135	290029-902	Tension Shoulder Screw		1

Key	Part Number	Description	Specification	QTY
136	925321-001	Gearbox Assembly		1
136.01	360555-000	Fixing Pin		4
136.02	160019-000	Copper Bushing		3
136.03	006001-100	Flat Washer	15.5±0.1*21*0.8±0.05	1
136.04	160034-000	Bushing		2
136.05	006001-044	Flat Washer	8.5*16*0.8t	5
136.06	012002-002	Key	4*4*7	2
136.07	320425-000	Gear		1
136.08	090098-000	Gearbox		1
136.09	320253-000	Gear		1
136.10	320231-000	Gear		1
136.11	925322-000	Gear Shift Pawl Assembly		1
136.12	340048-000	Packing		1
136.13	320233-000	Gear Shaft		1
136.14	170747-000	Gearbox Cover		1
136.15	160033-000	Bushing		1
136.16	360556-902	Sliding Rod		1
136.17	012003-013	Key	5*5*40	1
136.18	320254-000	Gear		1
136.19	160035-000	Bushing		1
136.20	000303-803	Round Head Philips Screw	M5*0.8P*10	3
137	290030-902	Shoulder Screw		1
138	130091-903	Gear Wheel		1
139	251531-615	Lead Screw Cover		4
140	360553-906	Shaft		4
142	090404-008	Base		1
143	002801-101	CAP Lock Screw w/teeth Washer & Flat Washer	M8*1.25P*25-7.4*13-8*23*2.0t	4
144	175329-904	Scale Bracket		1
145	290011-901	Shoulder Screw		1
146	090406-148	Depth Indicator		1
147	001101-203	Round Head Tapping Screw	M3*1.06P*8	2
148	175425-000	Sensor Bracket		1
149	021010-000	Wire Tie	ALT-150M-B	1
150	474048-023	Connect Cord	24AWG*4C*300mm	1
151	251509-615	Sensor Box		1

Key	Part Number	Description	Specification	QTY
152	491196-000	Sensor	CT	1
153	001106-601	Round Head Tapping Screw	M2*0.63P*6	3
154	381528-902	Support Shaft		1
155	925323-000	Tension Wheel Assembly-R		1
156	000302-116	Round Head Phillips Screw	M4*0.7P*5	4
157	175422-000	Pressure Plate		2
158	340146-615	Scraper	NBR、	2
159	175423-000	Scraper Holder		1
160	006002-200	Flat Washer	4.3*8*0.8t	2
161	000302-202	Round Head Phillips Screw	M4*0.7P*8	2
162	471037-192	Connect Cord	18AWG*1C*350mm	2
163	471044-037	Connect Cord	14AWG*1C*100mm	1
164	471044-034	Connect Cord	14AWG*1C*300mm	1
165	001601-801	Round Head Phillips Screw w/Flat Washer	M4*0.7P*8/4*10*0.8t	1
166	453012-029	Power Cord w/Plug	14AWG*3C*2800mm	1
167.1	575917-000	Switch Label		1
172	925368-000	Extension Wing Assembly		1
.1	174683-905	Extension Wing		1
.2	174687-905	Extension Bracket		2
.3	000801-101	Round Head Hex Screw	M6*1.0P*10	4
.6	290112-901	Shoulder Screw	M8*1.25P	8
.7	040004-000	Hex Wrench (Local Purchase)	4*70mm	1
182	006305-100	Spring Washer	8.2*13.7	2
183	011102-108	Pin	4*12	2
184	200126-000	Sponge	40*10*20mm(L*W*H)	2

Spare Parts

Part Number	Description	QTY
P-15mm4S	Box of 10 - 15mm x 15mm x 2.5t - 4-Sided Carbide Inserts	5
038201-101	Torx Screw for HCX Cutterhead	5

Maintenance Record

Date	Task	Operator

Notes

Warranty and Service

Oliver Machinery makes every effort to assure that its equipment meets the highest possible standards of quality and durability. All products sold by Oliver Machinery are warranted to the original customer to be free from defects for a period of two (2) years on all parts excluding electronics and motors which are warranted for one (1) year from the date of shipment. Oliver Machinery's obligation under this warranty shall be exclusively limited to repairing or replacing products or parts or components, at its sole option, determined by Oliver Machinery to be defective. Oliver Machinery shall not be required to provide other form of indemnity or compensation including but not limited to compensatory damages.

This warranty does not apply to defects due to direct or indirect misuse, abuse, negligence, accidents, unauthorized repairs, alternation outside our facilities, lack of maintenance, acts of nature, or items that would normally be consumed or require replacement due to normal wear and tear.

OTHER TERMS

To obtain and exercise the warranty right, please call 800-559-5065 or fill out warranty request form online at www.olivermachinery.net.
Warranty parts are shipped via Parcel or Ground. Additional charges will occur and charge to customers if express shipping is required.

DISCLAIMER

Under no circumstances shall Oliver Machinery be liable for death, personal or property injury, or damages arising from the use of its products.

Oliver Machinery reserves the right to make changes without prior notice to its products to improve function or performance or design.

FOR MORE INFORMATION

If you need assistance or have questions beyond what is covered in the scope of this warranty information, please call 800-559-5065 or email us at info@olivermachinery.net.

Appendix

US Standard – Metric Conversion Chart

Fractions	Decimal In.	Millimeters
1/64	.0156	.396
1/32	.0312	.793
3/64	.0469	1.190
1/16	.0625	1.587
5/64	.0781	1.984
3/32	.0937	2.381
7/64	.1094	2.778
1/8	.125	3.175
9/64	.1406	3.571
5/32	.1562	3.968
11/64	.1719	4.365
3/16	.1875	4.762
13/64	.2031	5.159
7/32	.2187	5.556
15/64	.2344	5.953
1/4	.25	6.350
17/64	.2656	6.746
9/32	.2812	7.143
19/64	.2969	7.540
5/16	.3125	7.937
21/64	.3281	8.334
11/32	.3437	8.731
23/64	.3594	9.128
3/8	.375	9.525
25/64	.3906	9.921
13/32	.4062	10.318
27/64	.4219	10.715
7/16	.4375	11.112
29/64	.4531	11.509
15/32	.4687	11.906
31/64	.4844	12.303
1/2	.5	12.700

Fractions	Decimals In.	Millimeters
33/64	.5156	13.096
17/32	.5312	13.493
35/64	.5469	13.890
9/16	.5625	14.287
37/64	.5781	14.684
19/32	.5937	15.081
39/64	.6094	15.478
5/8	.625	15.875
41/64	.6406	16.271
21/32	.6562	16.668
43/64	.6719	17.065
11/16	.6875	17.462
45/64	.7031	17.859
23/32	.7187	18.256
47/64	.7344	18.653
3/4	.75	19.050
49/64	.7656	19.446
25/32	.7812	19.843
51/64	.7969	20.240
13/16	.8125	20.637
53/64	.8281	21.034
27/32	.8437	21.431
55/64	.8594	21.828
7/8	.875	22.225
57/64	.8906	22.621
29/32	.9062	23.018
59/64	.9219	23.415
15/16	.9375	23.812
61/64	.9531	24.209
31/32	.9687	24.606
63/64	.9844	25.003
1.0	1.	25.400

Oliver Machinery is always adding new Industrial Woodworking products to the line.

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