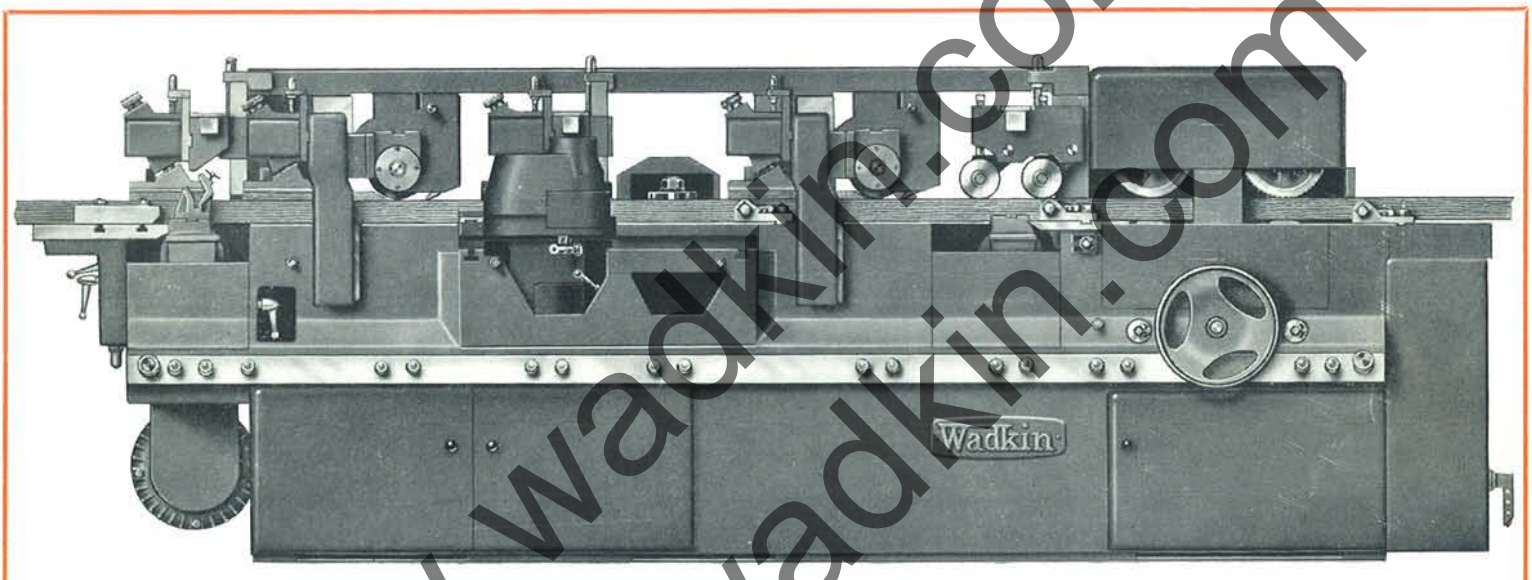
Wadkin

9" FB 225

PLANER AND MOULDER

British Standard Classification 12.34



DIMENSIONS AND CAPACITIES

Maximum size of timber admitted	9¾" x 4¾"	247 x 120 mm
Maximum size of finished work	9" x 4"	225 x 100 mm
Feed speeds	20, 30, 40, 45, 50, 60, 65, 75, 87, 100, 130, 150 ft/min.	6, 9, 12, 14, 15, 18, 20, 22, 26, 30, 39, 45 m/min.
H.p. of feed motor	7·5/3·75	7·5/3·75
Speed of feed motor	1500/3000 r.p.m. on 50 cycles 1800/3600 r.p.m. on 60 cycles	1500/3000 r.p.m. on 50 cycles 1800/3600 r.p.m. on 60 cycles
Speed of all cutter spindles	4200/6000 r.p.m.	4200/6000 r.p.m.
H.p. of cutter spindle motors –		
1st bottom	7½ (10 to special order)	7½ (10 to special order)
1st top	10 (15 to special order)	10 (15 to special order)
Fence side	7½ (10 to special order)	7½ (10 to special order)
Near side	7½ (10 to special order)	7½ (10 to special order)
2nd top	10 (15 to special order)	10 (15 to special order)
2nd bottom	10 (15 to special order)	10 (15 to special order)
Normal minimum cutting circle – all heads	6"	150 mm
Maximum swing –		
1st bottom	7½"	190 mm
1st top	10"	254 mm
Side heads	8½"	215 mm
2nd top	10"	254 mm
2nd bottom	10"	254 mm
Note: Standard square and circular blocks have a common minimum cutting circle diameter of	6"	150 mm
Spindle diameter	40 mm	40 mm
Spindle cone angle	40° included	40° included
Diameter of feed rolls	8"	200 mm
Maximum height	53"	1530 mm
Bed height	33"	840 mm
Floor space, six head machine	5' 3" x 12' 5"	1600 x 3785 mm
Net weight, six head machine	11000 lb	4990 kg.
Shipping dimensions, six head machine	390 cu. ft.	11m³.

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The machine is suitable for planing and moulding timber up to 9" x 4" (225 x 100 mm) finished size and is offered with the following head arrangements:

Model 91 – 1st bottom, fence side, near side, top.

Model 92 – 1st bottom, fence side, near side, top, 2nd bottom.

Model 95 – 1st bottom, 1st top, fence side, near side, 2nd top.

Model 96 – 1st bottom, 1st top, fence side, near side, 2nd top, 2nd bottom.

CONSTRUCTION. The machine base consists of a substantial one-piece body, ensuring rigidity and accuracy of alignment. On to this are mounted the entire feedworks, including the gearbox and all the cutter spindle stands. All motors are mounted on this body, those for the feed and the near side head being housed internally.

FEEDWORKS. Two top and two bottom rolls feed the timber through the machine. All rolls are readily removable and in two sections, allowing wear to be equalised. The first top and first bottom rolls are normally fluted. The top rolls swing round a centre pivot and are spring loaded with the rise and fall adjustment by a handwheel at the front of the machine. The bottom rolls are mounted in square slides and height adjustment is by an eccentric shaft below each roller. Additional height setting screws are readily accessible internally to give pitching adjustment to the bottom rolls.

The top feed rolls are gear driven and the bottom feed rolls chain driven from a common input shaft which is concentric with the top roll swing pivot shaft. This is driven through a Duplex roller chain from a three-speed gear box in turn driven through a two-stepped vee pulley drive from a two-speed motor. Thus 12 feed speeds are available. All shafts in the gearbox and feedworks are on ball or roller bearings. "Inching" and reversing facilities are provided.

Pneumatically pressurised feedworks can be supplied in lieu of spring loaded feedworks with rise and fall push buttons and independent pressure control to each top roll, with direct reading pressure gauges.

CUTTER SPINDLES. All cutter spindles are mounted in two deep groove ball bearings and are driven through two stepped pulleys and vee belts to give two speeds. Belt changing for speed selection is simple and easy of access.

The horizontal spindles also incorporate a removable outboard bearing with independent slide, the rise and fall of which is controlled by a second vertical screw. This slide has a secure lock to both slide and screw.

The vertical spindles are staggered 12" (300 mm) with the fence side head leading. This allows a continuous bed throughout the machine.

All cutterblocks are self-centring between an integral rear cone and loose front cone and locked by a nut on the spindle. Both vertical and horizontal adjustment is provided on all spindles and these adjustments are quite accessible and can be made whilst the machine is running.

Arbors for a Wadkin Setting-up Stand, Model FDT, and Wadkin Universal Grinder, Model NH, are available to order.

JOINTERS. Both straight and profile loose jointers (one to cover both side heads and one to cover all horizontal heads) can be supplied to order. In addition the machine can be supplied with a built-in straight jointer for the first bottom head.

PRESSURES AND CHIPBREAKERS. The front side head chipbreaker is radial and spring loaded incorporating adjustments for moulding iron projection and variation in basic cutting circles of blocks. Top head chipbreakers are radial, weight loaded and integral with the dust hoods and also incorporate all necessary adjustments. All pressures are spring loaded and readily adjustable and all roller pressures are mounted on anti-friction bearings requiring no attention.

FENCES. The infeed fence is fixed and the outfeed carried from a slide adjusted by micrometer screw. Adjustable nose pieces are fitted at the fence side head opening.

ELECTRICAL EQUIPMENT. All electrical control gear is mounted in a steel box at the infeed end of the machine and a mechanically interlocked mains isolator is incorporated. The push buttons are mounted along a special section conduit immediately adjacent to each head, with a feed control button at each end of the machine. All motors are totally enclosed fan cooled and full overload and no-volt protection is provided.

DUST EXHAUST. All heads are provided with carefully developed dust hoods and they have, or lead to, outlets suitable for simple connections. A specially developed unit connection is available.

DETAILS INCLUDED WITH THE MACHINE. All motors, cabling and control gear including isolating switch. Square cutterblocks to each head with each block complete with one pair of chipper irons, nuts, bolts and washers. Set of spanners. Exhaust hoods to each head. Lubricating guns for oil and grease with small can of lubricant. Maintenance and operational instruction book.

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