MK3 Workcentre Owners: An adaptor kit with MK3 fitting and operating instructions (part no. EPA061) is required for fitting this product to a MK3 Workcentre. In Australia this kit can be ordered through our Victorian or NSW branch by forwarding a cheque for $10.00. For customers outside of Australia, please contact your international office as listed on Page 12.

Assembly and Operating Instructions
(Series 2000 Workcentres only)

Thank you for purchasing a Triton Planer Attachment Kit. Please study these instructions carefully, especially the Safety Warnings on Page 8, prior to use and ensure that anyone else who uses the product also reads them.

While the setup procedure may seem quite complex, the planer will be accurate, and you'll be able to quickly remove and re-fit it for hand-held use if you follow the setup instructions carefully.
FITTING THE PLANE R TO THE CHASSIS
Fit the Alignment Plate (1) to the lower side of the
Plane r Chassis (2) (flange outward) using the M4
Screws (3) and Flange Nuts (4). Tighten firmly with a
Phillips-head screwdriver. Fig. 1

Remove the 4 perforated cardboard packers from the
carton flaps. Sit the chassis on top of the packers, as
shown, and allow the heads of the alignment plate
screws to overhang the edge of your worktable. Fig 5.

Fit Alignment Plate centrally, as shown, for most planers.
Some planers may require relocation to other holes.

Fit the Front Clamps (5) to the chassis, using the
long M6 Screws (6), Washers (7) and Hex Nuts (8)
(the nuts locate inside the clamp bases). Fig. 2. Do
not tighten yet. Most planers mount using the planers
fence holes - an exception is shown in Fig. 4.

Adjust your planer to 'O' (front and rear shoes in line)
and sit it flat on your assembly table with the rear shoe
contacting the edge of the alignment plate. Relocate
the alignment plate to suit your planer if required.

Push and tap the plastic Wing Knobs (9) onto the
hexagonal ends of the clamp bolt. Extend the
clamps, by tightening the wing knobs until the conical
ends locate into the planer fence holes. Fig. 5.
Ensure the cones locate exactly central within the
fence holes, otherwise they will alter the planer
alignment when fully tightened.

If everything appears correctly lined up, tighten the
Phillips-head screws holding the front clamp bases.
Then tighten the cones into the fence holes ensuring
the rear planer shoe remains in full contact with the
edge of the plate. DO NOT OVERTIGHTEN.

Fit the Rear Clamp (10) to the chassis using a long
M6 screw, washer and hex nut. Fit the wing knob and
tighten the clip into a location which allows the
clamp to align with the planer handle. Fig. 6. Flip the
orientation of the clamp if necessary. If a suitable
location cannot be found, relocate the clamp into the
lower slot and position it further down the handle.

Tension the clamp until it just touches the planer,
as shown. Do not overtighten as this will skew the
planer alignment.
Fit the Handle Bracket (11) over the planer handle and fasten it to the chassis using the short M6 Screws (12), Large Washers (13), and Flange Nuts (14). Ensure the planer is flat on your work table, then hold the bracket against the planer handle and tighten into position with a Philips-head screwdriver. Fig 7.

Fit the Handle Clamp (15) to the handle bracket using the short M6 Screws (12), Washers (7), and M6 Flange Nuts (14). Pull it up and across until it firmly surrounds the planer handle, then tighten into position. Fig. 8.

Tighten the rear clamp half to one turn to push the planer handle snugly into the clamp assembly. Check that there is no free movement of the handle, and repeat the above steps if necessary.

Place a straight edge across the base of the rear shoe, to check it is level with the chassis. Fig. 9. There should be a 2-3mm gap between the straight edge and either side of the chassis.

Ensure the gap is identical on either side by adjusting the position of the rear and front clamps.

With your planer shoes still set exactly in line use a straight edge down the length of the chassis and measure from the square tubes at each end of the chassis to check that the planer is parallel. Fig. 10. The reading at the rear should be equal or 1-2mm less than the front, but should never be greater. Make adjustments to the handle bracket assembly (repeat Fig's 7 & 8) until you are satisfied with the alignment.

Re-check that the planer is level across the chassis (Fig. 9) and make any necessary adjustments.

FITTING TO THE WORKCENTRE

Remove the Workcentre table and turn it upside down.

Insert the M6 Flange nuts (14) into the underside of the Nut Carriers (16) so that it locates fully inside the cavity. Fig. 11 (inset).

With the flange of the nut facing up (toward you), insert the nut carriers into the slots in the front and rear table reinforcing ribs. They can be inserted from either side of the slot. Fig. 11.

Loosely fit a short Coach Bolt (17) and Round Knob (18) to the Front & Rear table brackets (19 & 20). Fig. 12.
Fit the brace with holes in it at the end furthest away from the table T-slots and fit both braces with the plastic toggles facing away from the T-slots. Fig 15.

**Fig. 16**

**Turn the table over and re-fit to the Workcentre.**

Ensure the table brackets are fully located and tightened. Locate the braces with the toggles resting on the Workcentre base channel. **Fig. 17**. Loosen the nuts and adjust the toggle positions until the braces “snap” down into place. **Fig. 17 (inset)**. The correct position should support the table without lifting it.

**Fig. 17**

**Re-tighten the nuts.**

Fit Round Knobs (18) to the front and rear height adjustment brackets and lock them tilted outward slightly, for easy mounting of the planer chassis. **Fig. 18**.

**Fig. 18**
Slide the planer chassis down between the brackets and insert a long Coach Bolt (27), as shown, through the square tubes at each end while supporting the chassis. **Fig. 19.**

Fit the Height Indicators (28) and Round Knobs (18) to the coach bolts. **Fig. 20.**

Lift the chassis to full height and tighten the round knobs. Loosen the pivot knobs and pivot the chassis vertical to the table then tighten. **Fig. 21.**

Use a square to check that the planer blade is 90 degrees to the table, as shown. If necessary, loosen the screws and relocate the front and rear angle stops up or down their slots until the blade is square, then re-tighten.

Loosen the height adjustment knobs and lower the chassis until the top of planer blade is level with the table. The best way is to place a flat board on the table and adjust the chassis until the top of the blade just touches the underside of the board. **Fig. 22.**

Ensure that the chassis is level by measuring up from the square tubes to the top of the height brackets. **Fig. 23.** Independently adjust both ends of the chassis until an equal reading is reached at both ends. Re-check that the blade is still flush with the table and make adjustments if necessary.

Apply the Scale Labels (29) to the height brackets. Peel the 'Front' label from its backing and insert it under the front scale indicator (nearest to the front shoe of the planer). Align '0' to the top edge of the indicator and press into place, wrapping it around the fold in the bracket. **Fig. 24.** Apply the rear label.

Return the planer to full height.

Fit the Pressure Fingers (30) to the height brackets using the short Coach Bolts (17), Springs (31), Washers (7) - fitted at each end of the springs, and Nyloc nuts (26). **Fig. 25.** They should both point inward toward the planer (see also Fig. 27).

Tighten the nut until the bolt just protrudes through it. The tighter the nut, the greater the tension of the pressure finger. Adjust the tension as desired once you have performed some cuts.

The pressure fingers can be easily re-located to any of the four pre-set positions, or angled outwards when not required. Pull the pressure finger outward to disengage the locating pins then slide and/or rotate it to the desired position. **Fig. 26.**
Loosen the plastic wing nut on the Planer Guard (32) and insert it fully into the front chassis tube. Retract the guard and tighten the wing-nut to secure it in place. Fig. 27.

Make sure the switch is off (Fig. 31) and plug the planer into its switchbox, then bring power to the switchbox via a 10 Amp extension lead. Using a separate lead to that of your Workcentre enables independent operation of your saw and planer.

Press the switch with your finger to switch the power “ON”. Fig. 30. Tap the stop plate with your hand to switch it “OFF”. Fig. 31.

Push the Dust Hose (37) through the hole in the top of the chassis and position it over your planers dust outlet. Fig. 32.

Bend the hose over and secure it using the Plastic Chain (38) twist locked through the slots in the chassis edge, as shown.

Fit the Dust Bag (39) over the end of the hose and tighten the draw string. Fig. 33.

As the bag fills, during use, be sure that it is seated on the ground. Relocate the bag further down the hose if necessary.

Insert tube closer into rear tube

Pressure fingers point inward toward the planer

Fit the Tube Closer (33) into the rear chassis tube, as shown.

Attach the Switch-box (34) to the front brace by screwing the Self-Tapping Screws (35) into the lower holes in the rear of the switchbox. Fig. 28.

Depress the planers trigger and fit the Trigger Strap (36). Fig. 29.

Do not leave the trigger permanently locked on. When you have finished work for the day release the trigger strap and allow the spring in the trigger to relax.
BEFORE GETTING STARTED

For best results from your planer, you should use the long, straight Workcentre fence (with or without a jig) to guide the workpiece, rather than the short, inaccurate shoe of the planer. Free-hand cuts can be made directly against the planer shoes, however accuracy cannot be maintained using this method.

To accurately use your rip fence scales, and to allow consecutive use of your saw and planer, we recommend the jig(s) shown below. For narrow edge work (e.g. veneered board), the simpler of the two jigs is ideal. For planing of wider faces and for double-passes, the rigid, high-faced jig is strongly recommended.

### Making a simple jig
Cut a 327 x 1000mm piece from a sheet of 19 mm MDF or similar. Lower the saw blade below the table and remove the overhead guard. Set the rip fence to "0" and check the width of the jig between the rip fence and the rear planer shoe. If necessary do a planing cut or two until the board is accurate at "0". Then fit the 25 mm x 25mm battens, to stop the jig sliding along the fence. Removing a 500 x 250mm section from the board will enable your saw and overhead guard to remain set up for some of your planing cuts.

![Diagram of a simple jig]

**Hint:** Attaching the outriggers with screws enables them to be adjusted if the planer position is altered (e.g. if adjusting the angle stops).

### Making a high-faced jig
Construct the High-Faced jig illustrated using 19mm MDF or similar. Attach an 80-150mm high face at exactly 90 degrees to the table. Small cleats are fitted to the outriggers, overhanging the ends of the Workcentre to prevent sliding.

Before fitting them, set your rip fence to "0" and plane the outriggers to the exact width by running the high face against the Workcentre fence.

![Diagram of a high-faced jig]

SAFETY WARNINGS
- Ensure that the safety guard is fitted and working at all times.
- Always keep your hands well clear of the cutter and never trail fingers behind the workpiece.
- Always use a push-stick when planing narrow material, as shown.
- Switch off the power and unlock the trigger before making any tool adjustments.
- Always feed the workpiece from the front.

RECOMMENDED OPERATING PROCEDURES
- Perform a test cut on scrap material to check that a 90 degree face is achieved. If necessary adjust the planer chassis to the correct angle using the stop shown in Fig. 21.
- Ensure the planers front shoe is adjusted to maximum depth for all applications except free-hand planing.
- The Planer Attachment Kit is capable of much wider, heavier cuts than the planer hand-held. If your planer shows signs of overloading slow down your rate of feed or consider making several, shallower passes.
- The pressure fingers should be engaged for all applications except free-hand planing or rebating. When using the simple jig always locate the pressure fingers in the lowest position. When using the high-faced jig they should be positioned to approximately half the height of the workpiece being planed.
- When planing tall, narrow workpieces always use a high faced Jig.
- For increased blade life when regularly planing sheet material adjust the height of the chassis to bring other sections of the blade into operation, as shown.
Free-Hand Planing
Although planing directly against the planers shoes (rather than using the Workcentre fence) will create a clean, smooth face, it usually results in an inaccurate face. Wherever possible it is recommended that the Workcentre fence be used.

Always pay careful attention to your hand positions when performing free-hand cuts, keeping them well clear of the blade at all times.

Step 1: Disengage the pressure fingers as shown in Fig. 26.
Step 2: Adjust your desired depth of cut using the planers front shoe. Note: this is one of the few operations which makes use of the planers front shoe.
Step 3: Feed the workpiece carefully past the blade while pushing it evenly against the planers shoes.

Dressing to Width Using the Workcentre Fence
Step 1: Temporarily disengage the pressure fingers as shown in Fig. 26.
Step 2: For workpieces between 250 and 940mm wide, set the Workcentre fence to the left as per normal sawing operation. For material less than 250mm wide, reverse the scales on the fence before inserting it from the left. Note the scales are not directly usable in these configurations which is why the jigs are recommended.

Step 3: Place the workpiece between the planers rear shoe and the Workcentre fence. Adjust the fence position until there is no clearance and temporarily lock it in position with identical scale readings front and rear.
Step 4: Remove the workpiece and reposition the fence toward the planer by the amount of material to be removed (say 1mm).
Step 5: Re-engage the pressure fingers.
Step 6: Start the planer and feed the workpiece slowly past the planer without pausing.

Dressing to Width Using a Jig
Step 1: Rip your workpiece to width on the Workcentre allowing an extra 1 or 2mm per edge for dressing. (If the Planer Attachment Kit is in the way of the offcut, loosen the pivot knobs and lower it to the fold-down position as shown above.)
Step 2: Re-position the Workcentre fence to the exact desired width and drop the jig in place. If necessary lower the saw blade and remove the overhead guard.
Step 3: Feed the workpiece smoothly past the blade without pausing.
Double Passes for Wider Faces
You can double the width of cut of your planer, by end-for-ending the work, but to maintain accuracy use of a high-faced jig is essential.

Double-passes are quite critical and the slightest mis-alignment can show up as a step in your workpiece. Perform a few test cuts on scrap, and fine-tune the planer angle as shown in Fig. 23 until any mis-alignment ridge is removed.

A good result requires a relatively straight and true workpiece. Bowed, twisted or cupped workpieces cannot always be corrected. For best results with cupped workpieces, ensure that the face of your jig is at least as high as your workpiece and that you plane the convex surface first.

Step 1: Drop the high faced jig in place and set the rip fence to the desired cut width.
Step 2: Adjust the height of the pressure fingers if necessary and perform the first cut.
Step 3: Turn the workpiece end for end and complete the second cut as shown above. Do not trail fingers behind the work.

Rebating
You can rebate to the maximum capacity of your planer. Refer to your planer's manual for its rebate capability. Deep rebates will require several passes.

Step 1: Dis-engage the pressure fingers as shown in Fig. 26.
Step 2: Adjust the planer to the desired rebate height using the scales on the height adjustment brackets.
Step 3: Perform the cuts using the Workcentre fence or jig as detailed in the preceding “Dressing” segments. As the pressure fingers cannot be used when rebating you must take extra care to ensure that the workpiece is always guided against the face of the fence or jig.

45° Bevelling Using the Workcentre Fence
Whilst it is possible to plane the whole bevel, it is much quicker to first saw the bevel and use the plane as the finishing operation only.

When planing small workpieces great care should be taken with your hand positions. Wooden pushers should be used wherever possible.

Step 1: Saw the 45° bevel first on your Workcentre, allowing an extra 1 or 2mm for dressing.
Step 2: Dis-engage the pressure fingers as shown in Fig. 26.
Step 3: Lower the saw blade and remove the overhead guard. Insert the fence with the 45° face toward the planer and re-position the bevel guides to clear the planer and chassis.
Step 4: Insert the bevelled workpiece between the fence and the planer shoe and adjust the fence until there is no clearance and lock it in position.
Step 5: Re-engage the pressure fingers.
Step 6: Perform the first cut on the fence as initially adjusted.
Step 7: Adjust the front and rear fence settings toward the planer by the desired amount (ie. 0.5 to 1.0mm) and perform the cut again.
Step 8: Repeat Step 7 as necessary.
Beveling on the Series 2000 Bevel Ripping Guide

While it is possible to plane the whole bevel, it is much quicker to first saw the bevel and use the plane as the finishing operation only.

When planing small workpieces great care should be taken with your hand positions. Use a sandpaper faced batten, as detailed in the Bevel Ripping Guide instructions, for control of the workpiece.

Planing with a MK3 Extension Table

Planing wide workpieces with the MK3 Extension Table is similar to planing against the Workcentres fence. The jig(s) can be used against the extension table fence without any further adjustment.

Planing with the Sliding Extension Table

Planing wide workpieces in the fixed rip position (table locked) is similar to planing against the Workcentres fence using one of the jigs. The jigs battens will be spaced too widely for the extension table so use the workpiece hold-down clamps on the extension table fence to hold the jig in place.

Step 1: Saw the desired bevel first on your Workcentre and Bevel Ripping Guide, allowing an extra 1 or 2mm for dressing.

Step 2: Dis-engage the pressure fingers as shown in Fig. 26.

Step 3: Lower the saw blade and remove the overhead guard. Insert the Bevel Ripping Guide into the tracks and slide it toward the planer.

Step 4: Insert the bevelled workpiece between the fence and the planer shoe and adjust the fence until there is no clearance and lock it in position.

Measure from the end of the tracks on the Workcentre end panels to the printed scales on the Bevel Ripping Guide tracks. Reposition until parallel and make a mark on the Bevel Ripping Guide tracks, with a permanent marker, to aid future setups.

Step 5: Re-engage the pressure fingers.

Step 6: Perform the first cut on the Bevel Ripping Guide as initially adjusted.

Step 7: Adjust each end of the guide in by the desired amount (ie. 0.5 or 1.0mm) and perform the cut again.

Step 8: Repeat Step 7 as necessary.

If using the planer to square up a slightly out-of-square sheet, several passes may be required. Position the workpiece with the corner which is less than 90° forward and the tapered edge running away from the planer.
WHEN NOT IN USE

When not in use the Planer Attachment Kit can be lowered into the fold-down position or removed completely.

Fold-down Position
Loosen the pivot knobs as shown and lower the planer until it hangs freely beneath the table. It can remain there while performing tablesaw cuts on your Workcentre.

If you wish to perform other operations on your Workcentre (eg. docking or routing) you will need to remove the Planer Attachment Kit entirely, but the table mounting brackets remain in place.

Removing the Planer Attachment Kit
Remove the Dust Bag and hose and lower the planer to the fold-down position. Loosen the two attachment knobs under the table, as shown, and carefully slide the Planer Attachment Kit out from its tracks.

First loosen the plastic wing-nut and remove the planer guard. Loosen the rear clamp by around 6 - 10 turns and the top front clamp (located on the same side of the chassis as the rear clamp) by 3 - 4 turns. The planer can now be rotated and lifted out of the chassis. To retain your planers alignment do not loosen the lower front clamp.

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