



PLANING DISC ATTACHMENT

The Planing Disc is designed specifically for timber surfacing with the Lucas Mill. Fitting onto the output shaft that drives the saw blade, this very practical attachment allows operators to achieve a flat surface that requires only fine sanding for the final finish.

The Planing Disc is turned from a 19mm (3/4") plate of steel, shaped into a unique concave disc and fitted with 8 (Model 6) or 10 (Model 7, 8 & 10) replaceable inserts. A disc thickness of 6mm (1/4") maintains the rigidity required to prevent blade deflection & help achieve a flat surface.

The replaceable carbide inserts (fig.70) have four usable surfaces, giving the operator the opportunity to surface large amounts of slabs before replacement.

SET-UP

1. Before fitting the Planing Disc, bolt on the carbide inserts (fig.70) using 222-Loctite (supplied), applying this to the head and thread of the screws. Do not over tighten.
2. Remove the circular saw blade.
3. Bolt Planing Disc on in the same way you would bolt on the circular blade. (Refer manual page 23, chapter 6).
4. Fine-tune the Planing Disc on your mill by turning the adjustment No.2 bolt half a turn at a time to take the step out of the cut (See fig.18). (Return the No.2 bolt to original position for circular saw work).
5. **Replace the saw guard BEFORE operating.**
The machine will not start without the saw guard in place

TO LEVEL SLABS WITH THE PLANING DISC

- Cut the top off a log so it is wide enough to fit your slab.
- To hold small slabs fix a 50 x 25mm (2" x 1") board to the log at the front of the slab and along the power head side of the slab.
- **VERTICAL DEPTH** - Set the disc to the desired height. Remove a maximum of 5mm in the first pass and 1 – 2mm thereafter until desired finish is achieved.
- **HORIZONTAL ACTION** - Move the disc across 50 – 60mm (2 – 2 1/2") with each pass. The more you increase the width of cut, the more grain tear you will experience.

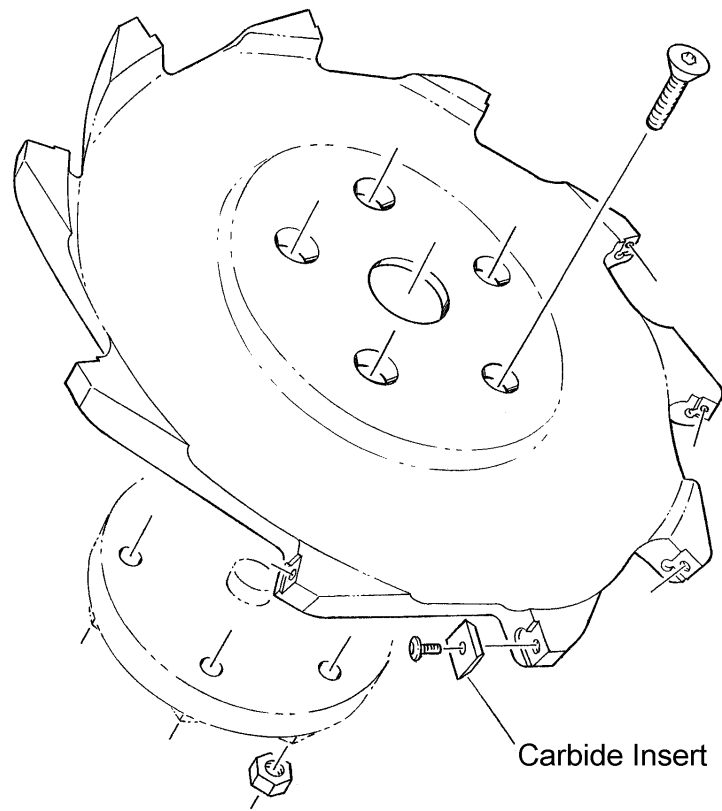
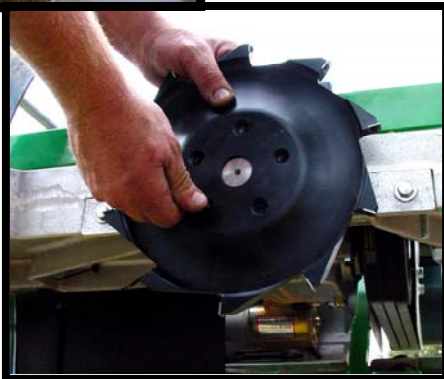
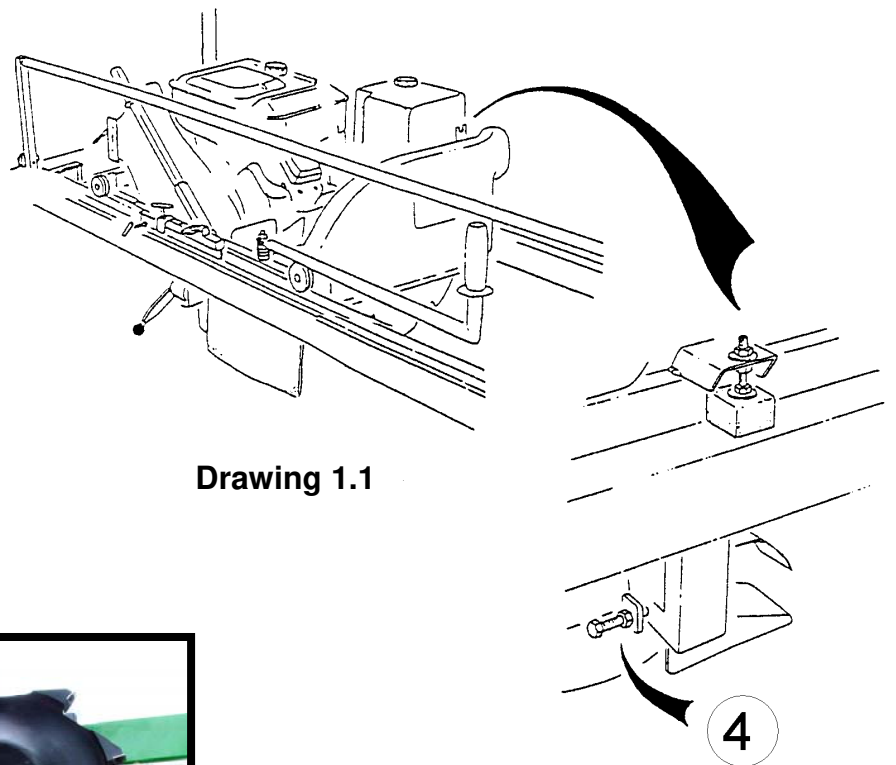
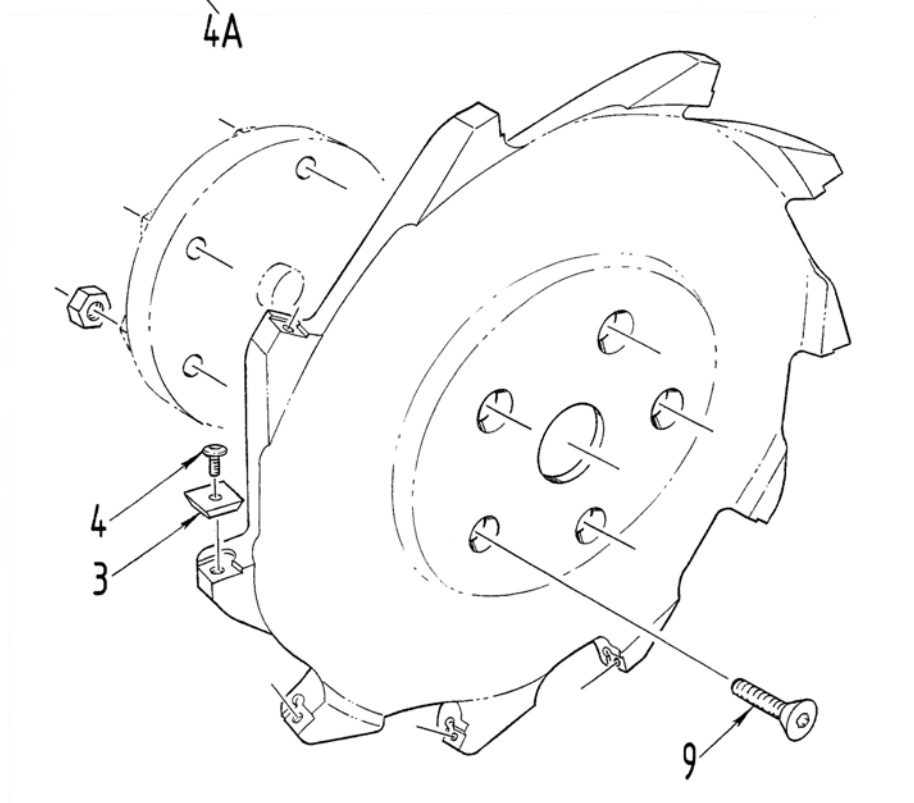
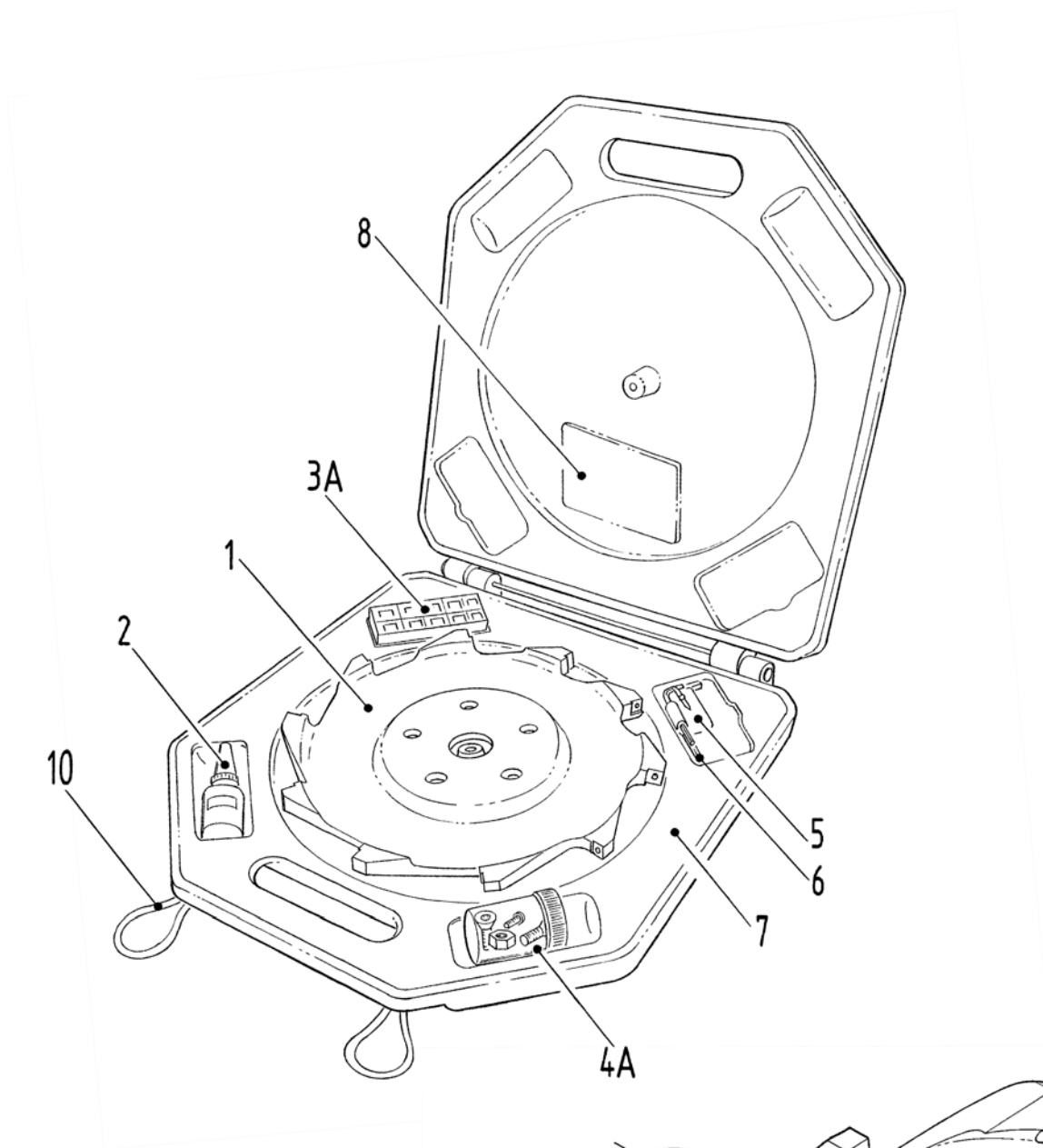


fig.70





PLANING DISC (PD)

MODEL M614 M618 (PD6)

MODEL M722 M830 M1030 (PD8)

KEY	PART NO	DESCRIPTION
	PD6-1	COMPLETE Planing Kit - Model 6 Includes Model 6 Planing Disc - case - loctite - 8 inserts & screws - 2.5 mm & 5mm allen key - 4 blade bolts & nuts - instructions
	PD8-1	COMPLETE Planing Kit - Model 7 8 & 10 Includes Model 8 Planing Disc - case - loctite - 10 inserts & screws - 2.5 mm & 5mm allen key - 5 blade bolts & nuts - instructions
1	PD6-2	Planing Disc - Model 6
	PD8-2	Planing Disc - Model 8
2	PD-3	Loctite 222 Thread Locker - Bottle
3	PD-4	Planing Disc Insert
3A	PD6-4	Insert - Planing Disc Model 6 (x8)
3A	PD8-4	Insert - Planing Disc Model 8 (x10)
4	PD-5	Screw - Button Head Cap (M4x8) Gr 12.9
4A	PD6-5	Screws - Button Head Cap (M4x8) Set of 8
4A	PD8-5	Screws - Button Head Cap (M4x8) Set of 10
5	PD-6	Allen Key - 2.5mm
6	TB-3	Allen Key - 5mm
7	PDC-7	Planing Disc Case
8	PD-8	Planing Disc Instructions
9	DT-19	Bolt - Countersunk (M8 x 25 HT) Grade 12.9 - blade bolt & nut - Model 6 7 & 8
10	PD-9	Planing Disc Case Strap