



®

MODEL 130

## SINGLE SURFACE PLANER 355,6 mm / 14" OPERATING AND MAINTENANCE INSTRUCTIONS

### ORDERING INFORMATION

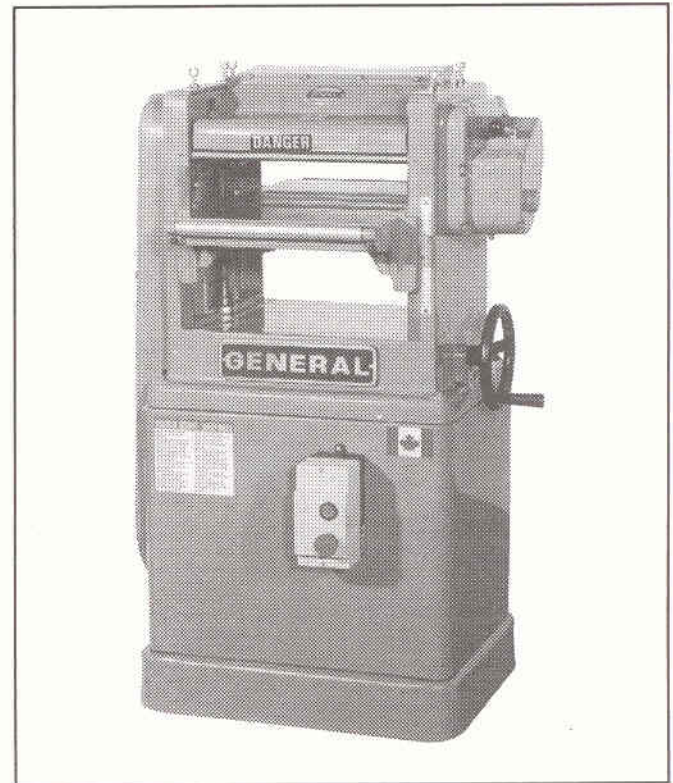
**130-1**  
355.6 mm / 14". Single surface thickness planer, floor model, as illustrated with cutter-head pulley, set of 3 knives, 2 matched V-belts, motor pulley, enclosed stand with adjustable motor mounting, less motor control.

### SPECIFICATIONS

CAPACITY	
• Width	355.6 mm / 14"
• Thickness	152.4 mm / 6"
• Minimum thickness	1.58 mm / 1/16"
• Minimum length (not butted)	177.8 mm / 7"
• Maximum depth of cut	3 mm / 1/8"
FEED	
• Feet per minute	381 mm / 15'
CUTTER-HEAD	
• Cutting circle	76.2 mm / 3"
KNIVES	
• Number of knives	3
SPEED	
• Speed	4 500 R.P.M.
• Feed rolls :	50.8 mm / 2" diameter power driven, in-feed roll corrugated, out-feed roll smooth, table rolls idle.
TABLE	
• Size of the table	355.6 X 564 mm / 14" X 21 - 1/2"
• With outside rollers	355.6 X 622.3 mm / 14" X 24-1/2"
• Floor space	622.3 X 762 X 1104.9 mm 24-1/2" X 30" wide X 43-1/2" high
• Shipping weight	~ 221 kg / 487 lbs
• Knife setting gauge	1.3 kg / 3 lb.

**130-2**  
Set of 3 H.S. knives  
358.7 mm / 14-1/8" long..... 0.9 kg / 2 lbs.

**130-4**  
Shaving hood 127 mm / 5" diameter



MODEL NO	SERIAL NO
130-1	

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

All replacements parts can be obtained from :

## GENERAL MFG. CO. LTD

835, Cherrier Street  
Drummondville, Québec, Canada  
J2B 5A8

Phone number : (819) 472-1161

Fax number : (819) 472-3266

Webb site : [www.general.ca](http://www.general.ca)

E-mail address : [general@general.ca](mailto:general@general.ca)

# SAFETY RULES

## Read carefully before operating the machine

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(1) Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to this machine. Follow available operating instructions and safety rules carefully.

(2) Keep working area clean and be sure adequate lighting is available.

(3) Do not wear loose clothing, gloves, bracelets, necklaces or ornaments. Wear face, eyes, ears, respiratory and body protection devices, as indicated for the operation or environment.

(4) Keep the machine guards in place at all times when machine is in use. Disconnect power before servicing machine.

(5) Keep hands well away from cutter-head and all moving parts. Do not clear chips and saw dust away with hands. Use a brush.

(6) Do not feed different thicknesses of wood side by side. Thinner pieces will kick back and cause serious injury. Never stand directly in line with work piece.

(7) Do not attempt to plane pieces shorter than 8" and thinner than 1/16". Maximum depth of cut 1/8".

(8) Always keep knives sharp and well adjusted. Make sure that the chipbreaker screws are tight.

(9) When ever possible use a dust extractor with shaving hood to minimize health hazards.

(10) Never leave the machine with the power on.

(11) Be positive that hold-downs and antikickback devices are positioned properly and that the work-piece is being fed through the cutting tool in the right direction.

(12) Do not use a dull, a gummy, a bent or a cracked cutting tool.

(13) Be sure that keys and adjusting wrenches have been removed before turning power on.

(14) Use only accessories designed for the machine.

(15) Adjust the machine for minimum exposure of cutting tool necessary to perform the operation.

(16) Do not use this planer for other than its intended use. If used for other purposes, General disclaims any real or implied warranty and holds itself harmless for any injury that may result from that use.

### GENERAL Guarantee

All component parts of GENERAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality GENERAL agrees to repair or replace any genuine part or parts which upon examination proves to be defective in workmanship or material within a period of 24 months. In order to obtain warranty, all defective parts must be returned prepaid to GENERAL MFG. Repairs made without our written authorization voids all guarantees.

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# SINGLE SURFACE PLANER 355,6 mm / 14"

A planer requires a reasonable amount of care and attention to insure perfect performance and accurate work, and no matter how good the manufacturer makes the machine, the operator must take good care of it if it is to continue to give the best result. It will take just a few moments to read and familiarize yourself with these instructions and they will probably save you a lot of trouble and time.

## INSTALLATION

Your GENERAL 14" Planer is shipped complete, wrapped in waterproof paper and packed in a crate. Remove the crate and paper. The protective coating applied on the exterior part of the machine should be wiped off with solvent. Do not use thinner, as it will damage the paint.

## POWER REQUIRED

We recommend the use of a 2 HP motor for average work, however if wide pieces at capacity of cut are planed, a 3 HP motor will be necessary. Use three-phase current whenever the power is available. The motor bracket of the sub-base have holes in it to receive Nema frame motors up to 184 T. The cutter-head is driven by two matched V-belts and a 3600 RPM motor should be used. This motor with the two groove pulley of the cutter-head will give a speed of 4 500 RPM to the cutter-head, and a lineal feed rate of 15 feet per minute. At this feed, 75 cuts per inch are taken a minute, and it will give a smooth finish requiring the minimum of sanding.

## MOUNTING THE MOTOR

Remove the belt guard from the planer. Then place the two groove motor pulley on the motor shaft but do not tighten in place. The motor is then placed on the brackets through the front opening, attach the motor to the brackets with screws and nuts.

V-belts must run true to prevent excess wear and loss of power, and must be matched to exact length. Therefore, the pulleys must be in alignment. To line up the pulleys accurately, take an ordinary plumb placing it in the groove of the cutter-head pulley. Then move the motor pulley to line up and tighten the set screw of the pulley.

If necessary the motor and its mounting brackets can be shifted on the tie rods by loosening the collars; moved to the desired position and the collars tighten again.

The belts must have the correct tension and are just right when they can be depressed 3/4" by pressing with the thumb on one side. To obtain the correct belt tension, adjust the nuts on the eye bolts below the tie bar and lock in place. Now replace belt guard of the planer.

Be sure when the wiring is done that the motor rotates in the right direction as the cutter-head must turn toward you when facing the front in the position to plane stock.

## ADJUSTMENTS

Your planer leaves the factory completely adjusted and ready to operate, however a check-up is recommended both to familiarize yourself with it and to be sure that everything is in order.

## TABLE

The table is raised or lowered by the handwheel at the right side. This handwheel turns the elevating shaft through helical gears which in turn lowers or raises the table. Any wear that develops between the table and the side columns can easily be taken-up by the adjustable gibs. As the table must be raised and lowered easily, yet must not be loose, this adjustment should be checked and readjusted if needed. This is done by loosening the locknuts at the rear of the table, readjusting each screw and locking again.

## FEED ROLLS

These rolls are most important in keeping the stock feeding smoothly and must be adjusted with care. To adjust the top rolls proceed as follows : two pieces of hard wood of exactly the same width 5"x18" long are placed on the table one on each side. Leaving a space on both sides to access the adjusting screws at each end of the rolls. Then the table is raised until the knives just touch the wood. The adjusting screws at each end of the rolls are loosened and turned until they just touch the roll blocks, then the two screws for the front roll (corrugated) are loosened 1/2 turn and the two screws for the rear roll (smooth) are loosened 1/4 turn, now all are locked in place with the jam nuts.

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The pressure on the top feed rolls can be adjusted easily by tightening or loosening the screws on top of the columns. Do not use more pressure than necessary to feed the stock. Occasionally the surface of the rolls and of the table will become gummed-up, this should be wiped off but never scraped off. If knives are not installed at the same height, the above procedure must be prepared. A knife setting gauge will eliminate the re-adjustment.

## TABLE ROLLS

The table rollers are also most important in keeping stock feeding smoothly. They are adjusted by using a straight edge and a feeler gauge, raising or lowering the rolls to .005 for hard wood and .010 for soft wood. The adjustment is made under the table by the screws provided. The outside table rolls are placed level with the table. Table rolls must not be set too high as they will cause undercutting at both ends of the stock.

## CHIPBREAKER AND PRESSURE BAR

To adjust, use the same procedure as for the upper rolls, placing two equal pieces of hard wood on the table and raising it until the knives barely touch. When the adjusting screws on the chip-breaker touch the rolls blocks, they are loosened 1/2 turn and locked. The screws for the pressure bar are only loosened 1/4 turn and locked. The pressure on the pressure bar is adjusted the same way and just the right amount should be used to prevent any undercutting at the end of the stock as it leaves the planer.

## CUTTER-HEAD

The cutting circle is 3" diameter with three knives. It is very important that the knives be exactly parallel with the table otherwise the stock will be thicker on one side. The knives must all be set equal to a true circle otherwise the cutting load will be shared by only one or two knives and the finish of the stock will suffer accordingly. The knives are held securely in place by combination chip-breaker wedge clamps and square head screws.

The knives should protrude about 1/16" above the chip breaker and to adjust or replace after sharpening proceed as follows : Two pieces of hard wood dressed on both sides and of equal thickness are placed on the table under the cutter-head one on each side. Now place one knife in the cutter-head and clamp lightly in place after it protrudes the proper distance above the chip-breaker wedge clamp.

The table is now raised until the knives barely touch the wood blocks. The other knives are now inserted and clamped just enough to hold them in place. Rotate the cutter-head in a back-ward motion by hand and the wooden blocks will force all the blades into the same position in the head. Now tighten all the screws a little at a time and repeating until they are all tight.

By using blocks of an exact dimensions (example 2-1/2" thick) raising the table to indicate 2-1/2" on the thickness scale when you are replacing the knives, the setting of the scale, top rolls, chip-breakers and pressure bar need not be changed once they have been adjusted and we recommended that this method be used.

## GEAR BOX MECHANISM

This gear box mechanism reduces the speed of the cutter-head to drive the feed rolls through sprockets and roller chains. The shifter rod outside the gear box, stops or starts the feed by a three jaw clutch. To replace worn-out roller chains and sprockets, the gear box must be removed. This is done by taking off the cover, then the worm at the end of the cutter-head and proceed to remove the balance of the gear box . The box can be removed. To re assembly, reverse the procedure.

## LUBRICATION

The cutter-head runs in two sealed ball bearings which are prelubricated for their entire life and require no further attention. The ball bearings of the table rolls and the thrust bearings of the elevating screws have been packed with grease and will not require further attention. The porous bronze bushing of the upper rolls are saturated with oil and will run a considerable time without attention but should still be oiled periodically by the holes provided in the roll blocks. The same applied to the bushings of the elevating mechanisms.

The helical gears of the elevating screws should be packed with grease before placing on the stand after which little attention is required. The outside table rolls, table and columns ways, and elevating screws should be oiled often.

The gear box should be filled with gear lubricant S.A.E. 90 or equivalent by the plug provided at the top of the gear box. Fill to the level of the rear plug. Any excess will cause overheating. The amount of lubricant should be checked every month as the mechanisms inside must never run dry. The oil should be drained by the plug underneath the gear box and refilled with new lubricant every six (6) months.

## REPLACEMENT PARTS

**IMPORTANT** : Always give part number and description of item when ordering.  
Also give serial No.

PART NO	OLD NUMBER	DESCRIPTION	QTY
P-2	P-28	Bearing (6205-2RS)	2
P-4	P-29	3/16" X 3/4" 606 Woodruff key	1
P-7	P-10	5/16" X 5/16" Allen Screw	4
P-8		3/8" Hex. Jam Nut	12
P-9	P-52	Shifter Locking Ball Steel 1/4"	1
P-40	P-21	3/8" X 1/2" Socket Head Cap Screw	2
P-41	P-14	1/4" X 1/2" Right Head Screw	4
P-46	P-15	5/16" X 1" Headless Screw	6
P-51	P-17	5/16" Hex Jam Nut	10
P-70	P-1	Oilite Bearing AA-885	4
P-73	P-9	3/8" X 1- 1/2" Square Head Set Screw	2
P-74	P-6	3/16" X 1-1/2" Grov-Pin	3
P-78	P-47	Shifter Rod Ball 1" 5/16"	1
P-83	P-36	10/32" X 3/8" Flat Head Screw	6
P-99	P-18	5/16" X 7/8" Cap Screw	12
P-114	P-3	3/16" X 1-1/4" Grov-Pin	4
P-129	P-44	1/4" X 5/8" Flat Head Screw	8
P-166		"T" Handle	1
P-196	P-30	3/4" Hex Jam Nut N.F.	1
P-201	P-4	Bearing B-1616	1
P-209	P-5	5/16" X 7/8" Cap Screw	8
P-271	P-46	5/16" X 1- 3/4" Socket Head Cap Screw	5
P-275	P-48	Oil Plug 1/4"	2
P-279	P-43	Bearing 6203-2RS	1
P-327	P-34	Name plate	1
P-333	P-51	Compression Spring 263-7	1
P-345	P-53	Eye Bolt	1
P-365		"T" Handle	1
P-378	P-4	Thrust Bearing (607)	2
P-381	P-11	3/16" X 3/4" Grov-Pin	2
P-540	P-12	6" Depth Scale (B48)	1
P-543	P-20	5/16" X 1- 1/2" Square Head Set Screw	2
P-544	P-7	3/8" X 1- 3/4" Square Head Set Screw	4
P-545	P-24	Roller Chain 45P	1
P-548	P-31	Compression Spring (1321-1)	4
P-549	P-32	Compression Spring (1315-1)	2
P-551	P-35	5/16" X 3/4" Flat Head Screw	6
P-545	P-25	Boller Chain 45P	1
P-557	P-39	Soft Worm (1346)	1
P-558	P-37	Hardened Worm	1
P-559	P-41	Thrust Bearing W 7/8	1

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**JOINTERS, MOTISERS, DRILL PRESSES, SHAPERS AND SANDERS.**

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**IMPORTANT :** Always give part number and description of item when ordering.  
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PART NO	OLD NUMBER	DESCRIPTION	QTY
P-560	P-38	Oil Seal 087-137	1
P-562	P-45	Expansion Plug FP-7 1"	3
P-640	P-19	5/16" X 1- 1/4" Square Head Set Screw	4
P-641	P-13	8/32" X 5/16" Pan Head Screw	3
P-666	P-42	Oil Seal 062-137	1
P-765	P-49	1/4" X 1- 1/2" Socket head Cap Screw	5
P-870	P-16	Roll Bearing (1607 DS)	4
P-871	P-33	Oilite bushing (A-835-5)	4
P-1024	P-40	Bronze Worm Gear	1
102-8SA		Door Assembly	1
131		Base	1
132		Left Column	1
133		Right Column	1
134		Table	1
135		Cutter-Head	1
136		Bearing Housing	2
137		Shifter	1
138		Shifter Rod	1
139		Cover	2
356-21		Pointer	1
781-7		Motor Pulley 3600 RPM	1
1302	P-26	1/8" C 3/4" X 14- 1/8" (1302) ACC	3
1310		Infeed Roll Grooved	1
1311		Outfeed Roll	1
1312		Bearing Block	2
1312A		Bearing Block Assembly	2
1313		Outside Table Roll	2
1315		Pressure Bar	1
1316		Outfeed Roll Cover	1
1317		Pressure Adjusting Screw	6
1318		Spacer	1
1319		Chipbreaker	1
1319A		Guard	1
1320		Clutch	1
1320A		Clutch Fork	1
1321		Worm Gear W / Jaws	1
1322		The Rod	2
1323		Idler Roll	2
1324		Clamp	4
1325		Bearing Retainer	4

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# REPLACEMENT PARTS

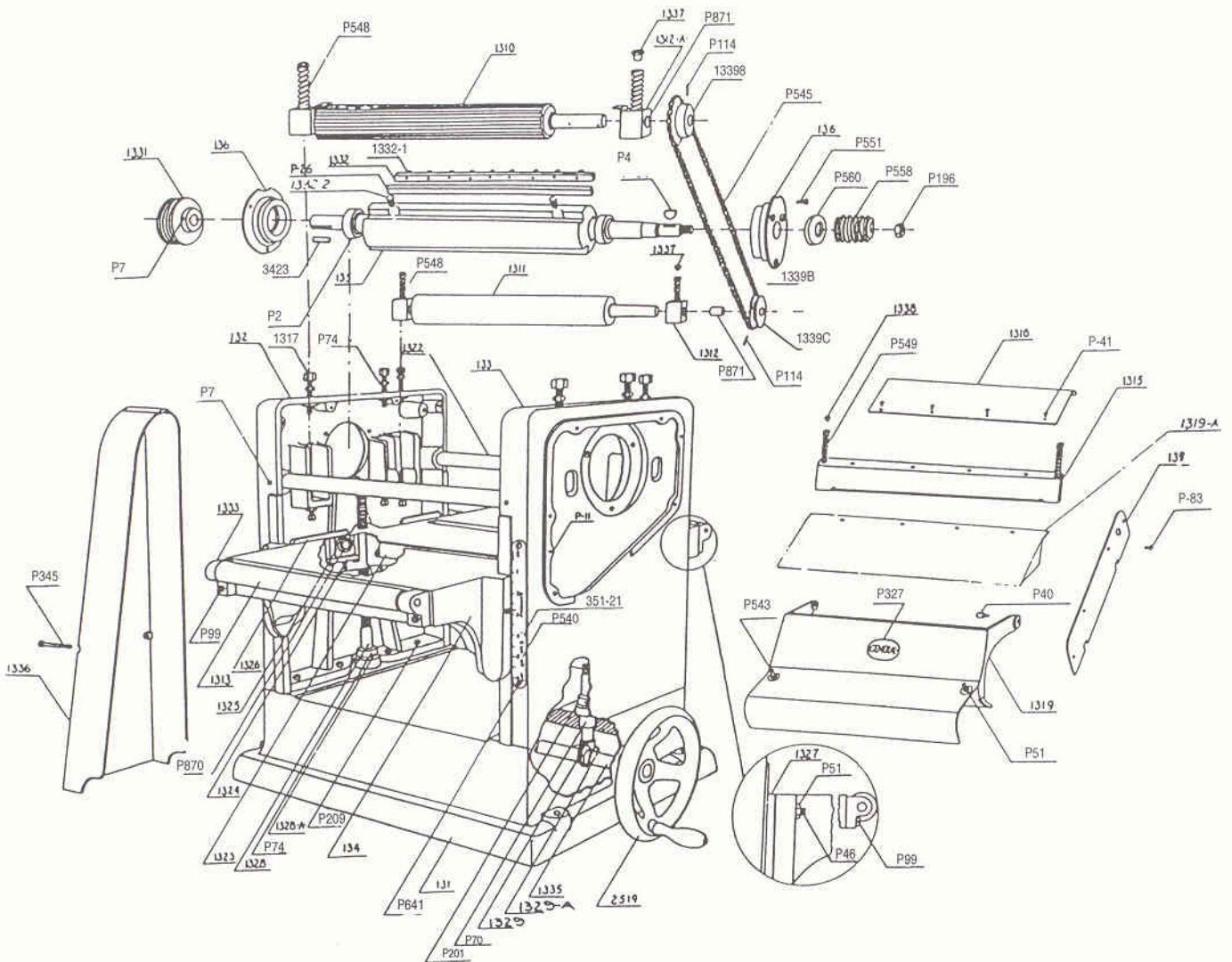
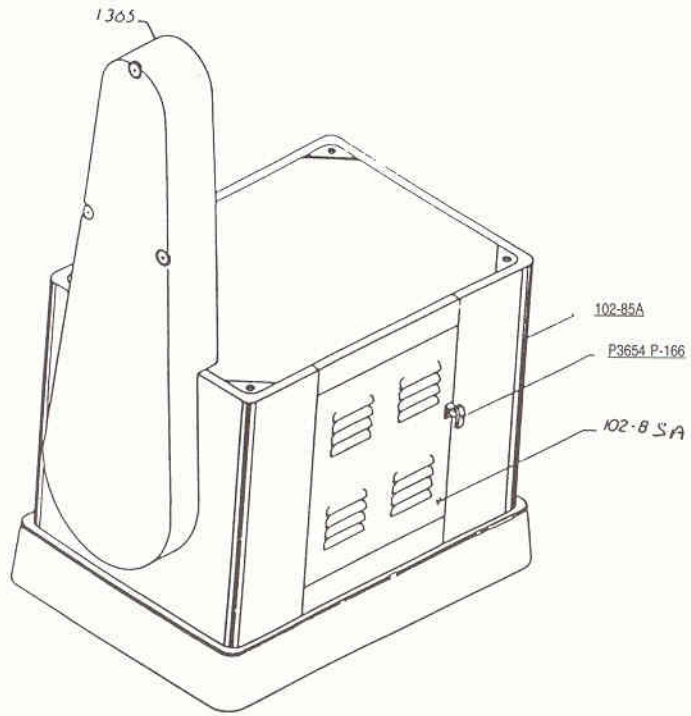
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PART NO	OLD NUMBER	DESCRIPTION	QTY
1326		Guide Bar	4
1327		Gib	2
1328		Elevating Screw	2
1328A		Screw Collar	2
1329		Helical Gear 16T	2
1329A		Helical Gear 10T	2
1331		Arbor Pulley	1
1332		Chipbreaker	3
1332-1	P-27	1- 1/4" X 1/2" Screw (1332-1)	27
1332-2		Adjusting Nut W/Screw 10-32 X 3/4 Sol S.S.	6
1333		Outside Roll Bracket	4
1335		Elevating Shaft	1
1336		Belt Guard (Old Style)	1
1337		Spring Pad	4
1338		Spring Pad	2
1339-B	P-22	18T Sprocket 3/4" Bore (1339-B)	1
1339-C	P-23	18T Double Sprocket (1339-C)	1
1341		3400 R.P.M. Motor Pulley 7/8" Bore	1
1341A		1800 R.P.M. Motor Pulley 1-1/4" Bore	1
1342		Gear Box	1
1343		Gear Box Cover	1
1343-1	P-50	Gasket (1343-1)	1
1344		Intermediate Shaft	1
1345		Clutch Shaft	1
1350		Leg	4
1351		Motor Support	2
1352		Motor Support Rod	2
1353		Rod Anchor	2
1354		Collar	2
1355		Front and Rear Panel	2
1356		Side Panel	2
1357		Belt Guard (Old Type)	1
1360		Cabinet assembly	1
1365		Belt Guard (New F.G.)	1
2519		Handwheel (354-9-14 and 15)	1
3423	P-54	Flat Key (3423)	1
		4L-640 V-Belt	
		4L-680 V-Belt	1
		4L-700 V-Belt	1
E-4		E-4 Rubber Mounts	4

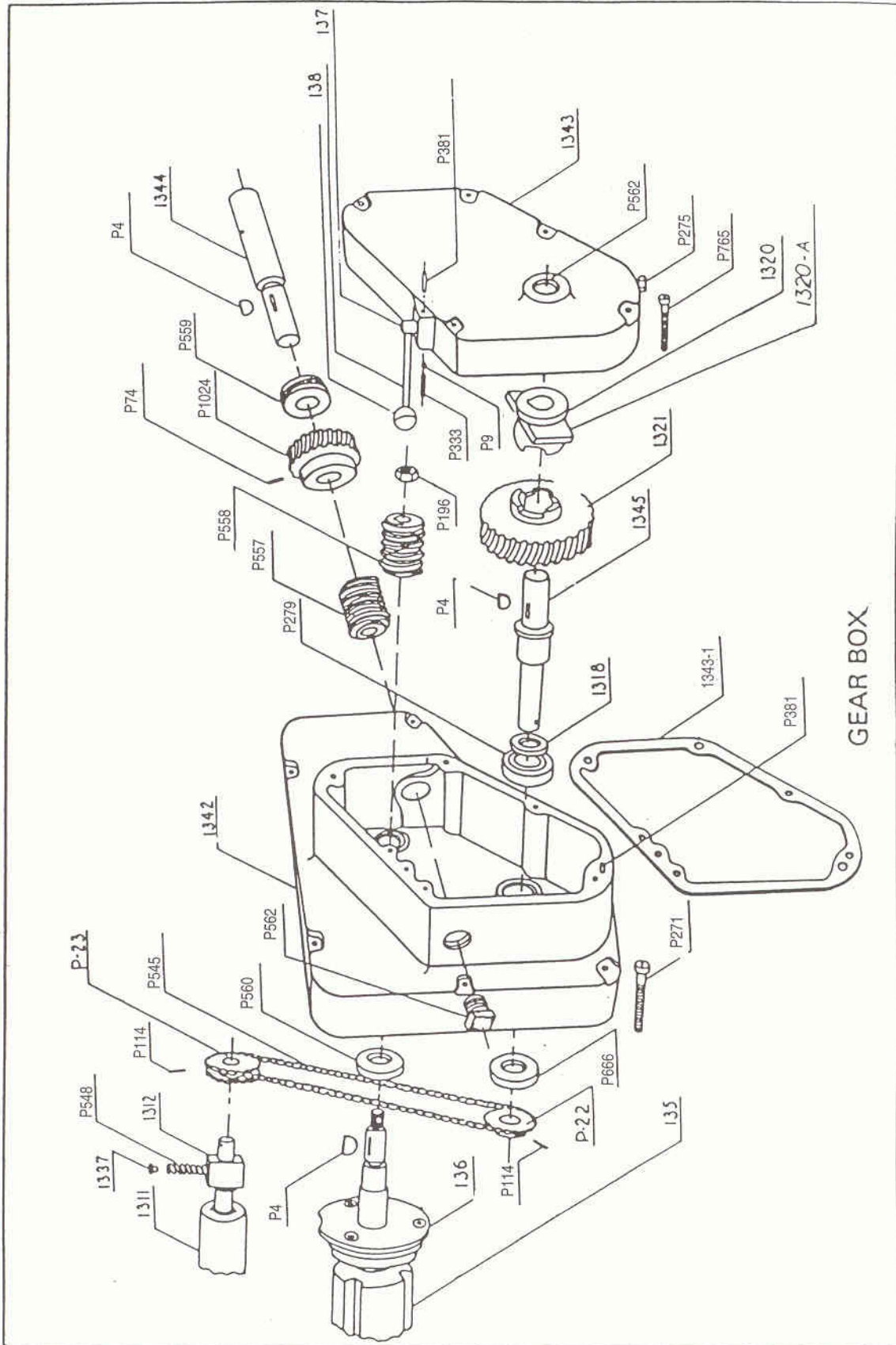
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NEW MODEL







GEAR BOX