



Additional Instructions

for thickness planer type PANHANS 436|100

Increase contact pressure of the segmented pressure beam



Valid for machine type:

Thickness planer 436|100
with optional segmented pressure
beam for plastics processing

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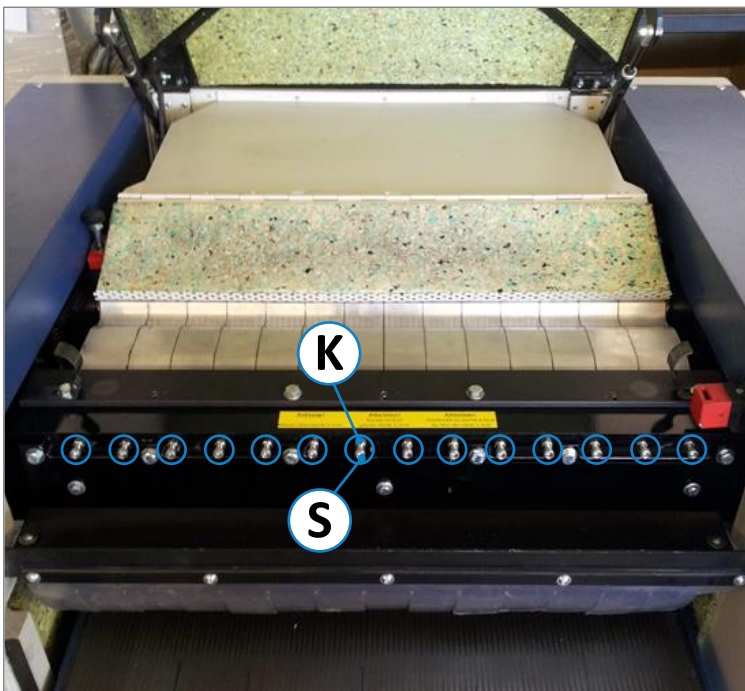
Increase contact pressure of the segmented pressure beam

This option is only available for 436|100 thickness planers with segmented pressure beams that have optional special equipment for plastics processing.

To enable a higher contact pressure of the workpiece on the thickening table, the pretension of the springs can be increased if necessary. For this purpose, the springs of the link pressure beam are pretensioned by an additional 10 mm compared to the standard setting.



Note: The ideal spring tension for machining plastics must be determined by trials on the workpiece.



Adjusting the preload:

1. The preload is adjusted with the cover open using the 14 M6 screws (S).
2. First loosen the 14 lock nuts (K) and then use a 5 mm Allen key to adjust the M6 screws (S) to the desired pretension. Then tighten the lock nuts (K) again.
3. For each turn of the M6 screws (S) the pretension of the segmented pressure beam increases or decreases by 1 mm.

Figure 1 : Adjusting the contact pressure for the segmented pressure beam



Note: To obtain a consistent planing result, always adjust all 14 spring preload screws (S) by the same amount. screws (S) for the spring preload must always be adjusted by the same value.



Note: A further increase in the factory-set spring pretension of the segmented pressure beam is at the expense of the maximum chip removal of 8 mm.