

POWERMATIC[®]

WMH TOOL GROUP

Operating Instructions and Parts Manual

24-inch Wood Planer

Model WP2412



WMH TOOL GROUP

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Part No. M-0460285
Revision B 6/04
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This manual has been prepared for the owner and operators of a Powermatic Model WP2412 Planer. Its purpose, aside from machine operation, is to promote safety using accepted operating and maintenance procedures. To obtain maximum life and efficiency from your planer and to aid in using it safely, please read this manual thoroughly and follow the instructions carefully.

Warranty and Service

WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can provide quick service or information.

In most cases, a WMH Tool Group Repair Station can assist in authorizing repair work, obtaining parts, or perform routine or major maintenance repair on your Powermatic product.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848, or visit our web site at www.wmhtoolgroup.com

More Information

Remember, WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit our web site at www.wmhtoolgroup.com

WMH Tool Group Warranty

WMH Tool Group makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product at our discretion, or refund the purchase price if we cannot readily and quickly provide a repair or replacement. We will return the repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

WMH Tool Group sells through distributors only. Members of the WMH Tool Group reserve the right to effect at any time, without prior notice, alterations to parts, fittings and accessory equipment, which they may deem necessary for any reason whatsoever.

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Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This planer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a planer, do not use until proper training and knowledge have been obtained.
5. Do not use this planer for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this planer. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this planer, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting tools and wrenches. Form a habit of checking to see that adjusting tools and wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after maintenance is complete.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**



Warnings

20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the knives or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep knives sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

WARNING

This means that if precautions are not heeded, it may result in serious injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Introduction

This manual is provided by WMH Tool Group covering the safe operation and maintenance procedures for a Model WP2412 Powermatic Planer. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or WMH Tool Group. WMH Tool Group can also be reached at our web site: www.wmhtoolgroup.com.

Description

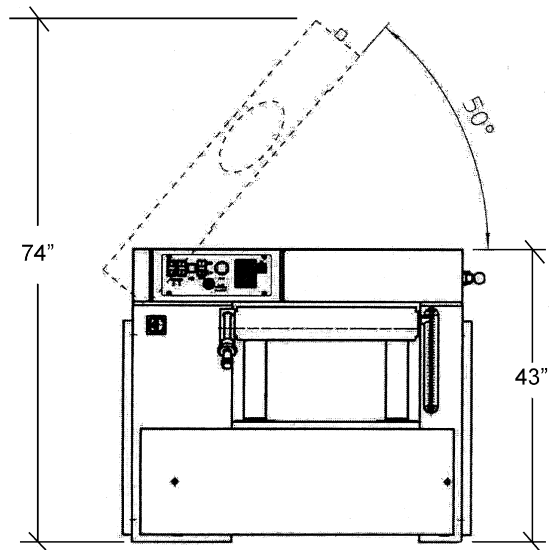
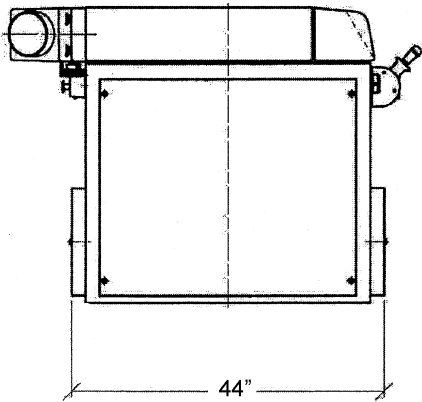
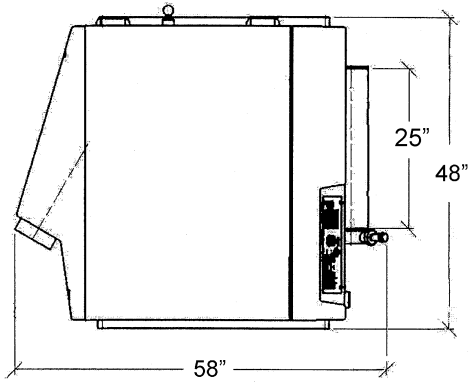
This multi-featured 15 horsepower planer is built for the rugged, industrial environment. It features a quick change Tersa™ cutterhead with reversible knives, segmented infeed roller with sectional chip breaker, and dual drive chains and sprockets. The cutterhead and infeed and outfeed rollers have double bearings. The planer frame is built with heavy plate steel, and the cast iron table is supported by four massive columns – this machine will not vibrate under load. Knife changes are quick with the self-seating knives. The planer will accomodate rough to finish work, and multiple piece planing.

Specifications

| | |
|--|----------------------------|
| Model Number..... | WP2412 |
| Stock number | 1791295 |
| Main motor (TEFC)..... | 15HP, 3Ph, 230V, 60Hz, 60A |
| Table raising motor (TEFC)..... | .0.75HP |
| Feed Motor (TEFC)..... | 1HP |
| Variable feed speed (ft/min.) | 16 to 72 |
| Cutterhead speed (RPM) | 5200 RPM |
| Cutterhead diameter (in) | 4.75 |
| Knives TERSA™ (in)..... | four @ 25" |
| Max. chip removal single pass (in) | 0.3125 |
| Serrated infeed roller (in) | 2.75 |
| Outfeed rollers (in)..... | 2.75 |
| Table dimensions (in)..... | 24.8 x 45.6 |
| Thickness capacity (in) | 12 |
| Dust port (in)..... | 6 |
| Belts | three V-belts |
| Overall dimensions (in LxWxH) | 58 x 48 x 43 |
| Overall dimensions (crated) (in LxWxH) | 63 x 53 x 49 |
| Net weight (lbs)..... | 2,310 |
| Shipping weight (lbs)..... | 2,640 |

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WHM Tool Group reserves the right to change specifications at any time and without prior notice, without incurring obligations.

WP2412 Planer Dimensions



Unpacking

Open shipping crate and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Read this instruction manual thoroughly for assembly, maintenance and safety instructions.

Contents of the Shipping Container

- 1 Planer
- 3 Lifting hooks
- 4 Open-end wrenches (10, 13-17, 19-22, and 24mm)
- 5 Hex wrenches (4, 5, 6, 8 and 10mm)
- 1 Brass punch
- 1 Owner's manual
- 1 Warranty card



⚠WARNING

Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.

Installation

Tools required for installation

wrench set (provided)
level
forklift or crane with straps

1. Remove the crate from around the planer and any fasteners securing the planer to the skid.
2. Remove the side covers and place the lifting hooks into the slots (Figure 1). Place straps under them and lift the machine off the skid. The planer should be located on a sturdy floor, preferably concrete, in a dry area with sufficient lighting. Leave enough space around the machine for loading and offloading stock and routine maintenance work.
3. When the planer is situated, use the leveling screws (Figure 2) to level the machine.
4. Exposed metal areas of the planer have been factory coated with a protectant. This should be removed with a soft cloth and kerosene. Do not use an abrasive pad. Do not let solvent contact the plastic parts of the machine, as it may damage them.



Figure 1

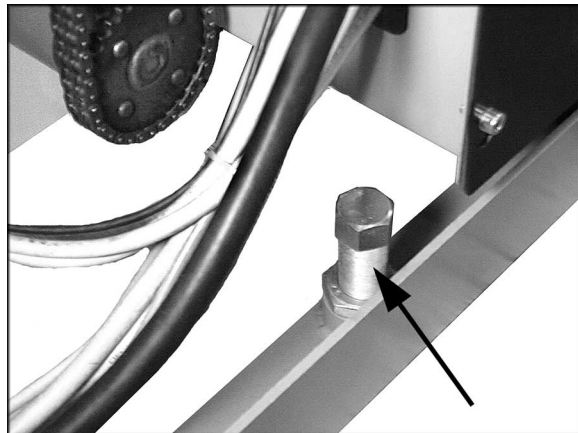


Figure 2

Electrical Connections

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. The machine must be properly grounded to help prevent electrical shock and possible fatal injury.

The planer may be fitted with a 230 volt plug, or may be "hard-wired" directly to your electrical panel. If hard-wired to a panel, make sure a disconnect is available for the operator.

IMPORTANT: The 230 volt model of the WP2412 planer is wired for 230 volt only; it is not convertible to 460 volt.

1. Make sure the machine's plug is disconnected from the power source. If it is hard-wired, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the saw will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired. Always follow proper Lock Out/Tag Out procedures when performing any wiring on this machine.

2. Make sure the voltage of the power source corresponds to the voltage of the planer as recorded on the motor plate.
3. Open the electrical enclosure on the left side of the machine (Figure 3) by loosening the screws and sliding the panel upward.
4. Connect the three phases to the terminals marked L1, L2, L3 (Figure 4).
5. Connect the green neutral wire to terminal "N".
6. Connect the machine to power (or install the fuses or reset the breakers at the power source).
7. Test the rotation of the cutterhead. Turn on the main power switch (see Figure 5) and then the main motor switch (Figure 5). The pulley on the main motor (on the side near the electrical enclosure) should rotate counterclockwise. If it rotates clockwise, stop the machine with the red stop button (Figure 5).
8. Disconnect machine from power source, and exchange leads L1 and L2.
9. Reconnect power, and close the electrical cover.

Dust Collection

It is strongly recommended this planer be connected to a dust extraction system, via the 6" (160mm) dust port at the rear of the planer. Your dust collector should have at least 1500 CFM capacity.

Adjustments

Controls

Figure 5 shows the control panel for the planer.

Starting procedure

NOTE: The planer will not start if the hood is raised, or if the brake release light is on (see below).

1. Turn Main Switch to position "I". [NOTE: The main switch has a lock-out hole, through which a padlock or similar device can be inserted, when the switch is in "O" position]
2. Push the Main Motor Start button; the motor will start in Star-Delta. After a few seconds you will hear the motor switch over to full speed operation. NOTE: The inverters (see Figure 3) have been factory programmed and their settings should not be altered.

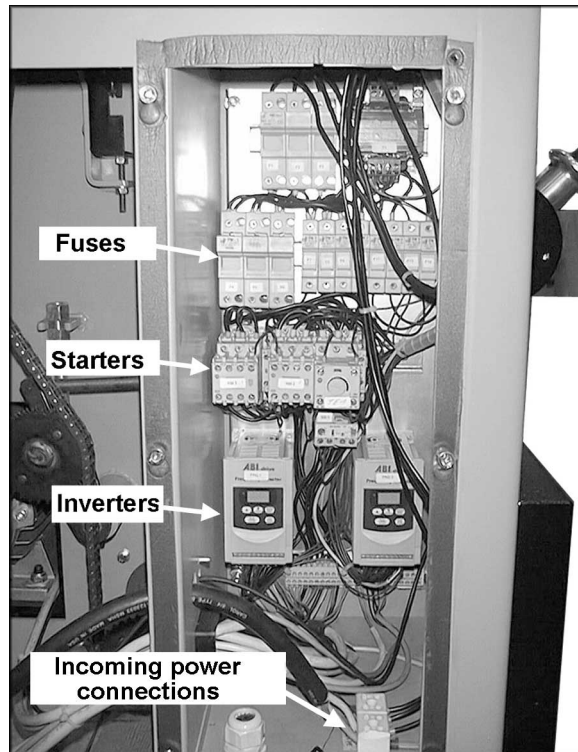


Figure 3

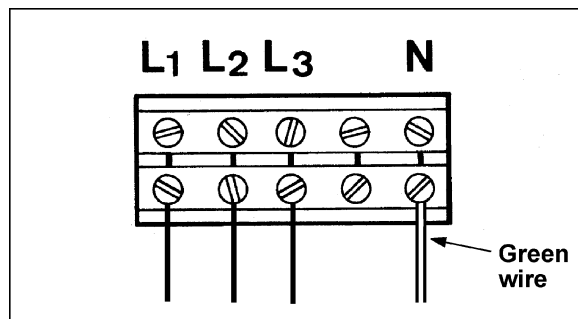


Figure 4

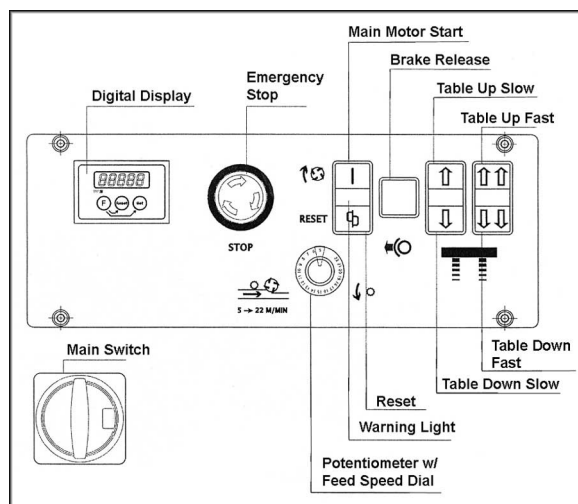


Figure 5

3. The Reset button (Figure 5) will light up if the machine becomes overloaded. Press this button to re-start the machine.
4. The Emergency Stop Button shuts down all operations on the planer. An automatic brake stops the motor within 10 seconds. A similar stop button can be found at the back of the machine. To restart the machine, simply twist the stop button and allow it to pop back up
5. To begin the feed motor and rotation of the feed rollers, press the Potentiometer button on the dial. Rotate the dial to set the feed speed. Speed ranges from 16 to 72 feet per minute. The numbers on the dial are shown as 1 to 11; the higher the number, the faster the speed. To stop the feed motor press the Potentiometer button again.
6. The Brake Release switch frees the cutterhead so that it can be moved by hand (e.g. when changing knives). When the brake release is on, the switch stays lit. As a safety feature, the planer's motor will not start if the brake release switch is lit. And if the switch is pushed during operations, the motor will automatically stop. To restart the planer, de-press the brake release switch; the light will turn off.
7. To raise the table press the up-arrow buttons; to lower the table press the down-arrow buttons. The single arrows raise the table slowly, the double arrows rapidly.

Calibrating Digital Display

Before operating the planer, the digital display should be checked for accuracy and calibrated if necessary. Use a scrap board.

1. Set the table to just under the thickness of your scrap board, using the scale next to the table (Figure 6). Feed the board through the planer to achieve a planed side.
2. Raise the table slightly until the adjoining scale pointer is set evenly on a number.
3. Flip the board over and feed it through the planer, then carefully measure its thickness with calipers. Compare this with the digital display.
4. If the display needs correcting, press and hold "Function," and press "Reset". The display will return to zero.
5. Press and hold "Function," and press "Set" until the display shows the thickness of your board. Tapping the "Set" button will move the display by increments; holding down the "Set" button will move the display rapidly.



Figure 6

Changing Fuses

Disconnect planer from power source, and open the electrical enclosure. Pull open the cover on a fuse holder, as shown in Figure 7, and slide out the old fuse. Replace it with a new one of the proper amperage. Close the cover.

CAUTION Do not use a fuse with amperage rating different than what is listed on the cover of the fuse holder.

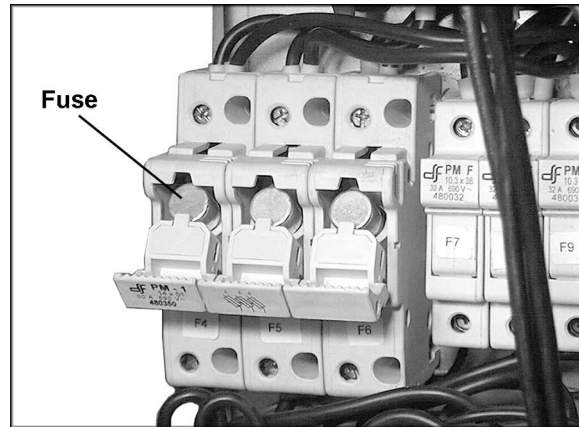


Figure 7

Changing Knives

The planer has a Tersa™ Monobloc cutterhead. Knife changing is simple, and the two-sided knives are self seating once the cutterhead begins rotating. Tersa™ knives are available from your dealer or most woodworking supply stores.

WARNING Do not loosen any screws on the cutterhead.

1. Push brake release button (see Figure 5). The brake release light will come on.
2. Pull out on the lever at the right side of the machine, and raise the hood.

CAUTION After prolonged use of the planer, the cast iron frame and areas around the cutterhead may be hot.

3. Disconnect machine from power source.
4. Rotate the cutterhead to gain access to a knife. Use the provided brass punch to gently tap down the segmented gibs, as shown in Figure 8. This will release the knife.
5. Align the knife and carefully slide it through the hole in the side of the bearing casting (Figure 9).
6. To install a new knife (or the same knife reversed for a new edge), insert it through the hole. Make sure the knife is properly seated upon the bead (Figure 8) and the ends are not protruding past the ends of the cutterhead. When the machine is started later, the gibs will automatically secure the knife in place.
7. Repeat this procedure for the other three knives.
8. Lower the hood and reconnect power to the machine. Press the brake release button (Figure 5). The warning light will go out.

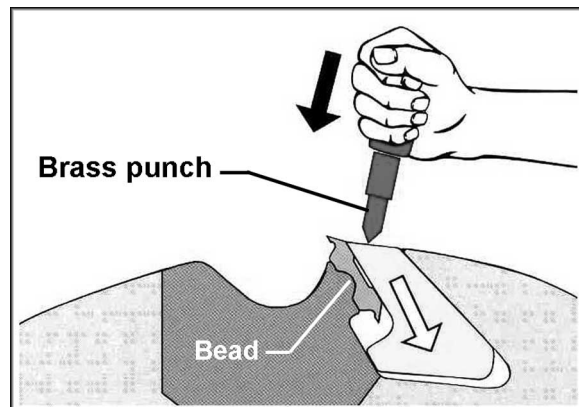


Figure 8

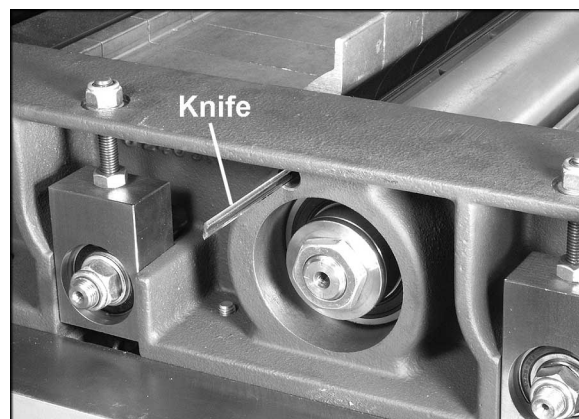


Figure 9

9. After adjusting or changing knives, the digital display should be checked and recalibrated if necessary. See "Calibrating Digital Display."

Belt Tension & Replacement

Note: Belts should be replaced as a matched set of three.

1. Loosen the three bolts (A, Figure 10) which hold the motor support bracket to the frame.
2. Turn the hex nuts (B, Figure 10) on the tension rod as needed.
3. When finished, tighten the three bolts (A, Figure 10).

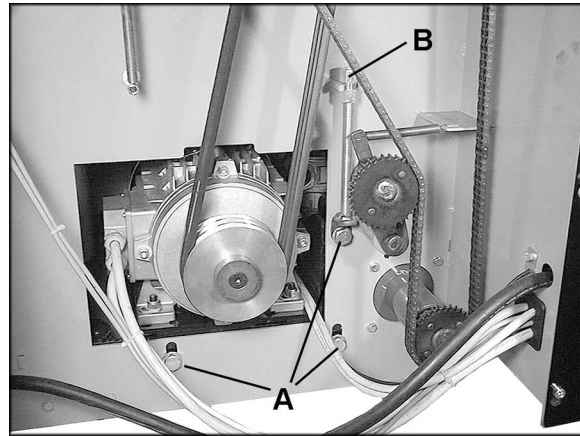


Figure 10

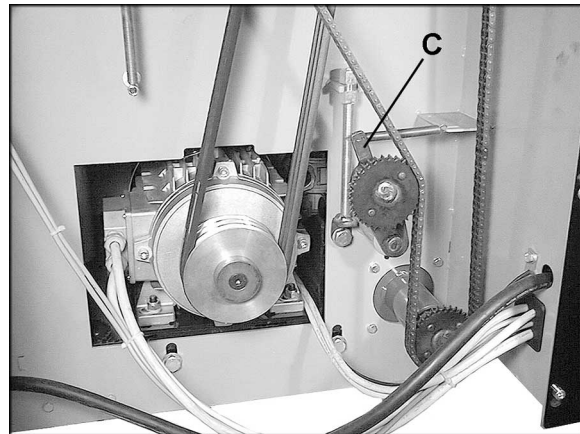


Figure 11

Drive Chain Replacement

The drive chains do not require tension adjustment, since tension is always assured by an idle chain tensioner (C, Figure 11).

To replace the main drive chain, pull the tensioner (C, Figure 11) backward and remove the chain from around the sprockets. When the new chain has been mounted, always make sure the tensioner is well placed on the chain.

To replace the chain for the table raising mechanism, pull the lever (D, Figure 12) to the back and remove the chain. When the new chain has been mounted, push the lever (D, Figure 12) back into position.

CAUTION Do not turn the sprockets on the table raising screws with the chain removed. Doing so will misalign the table.

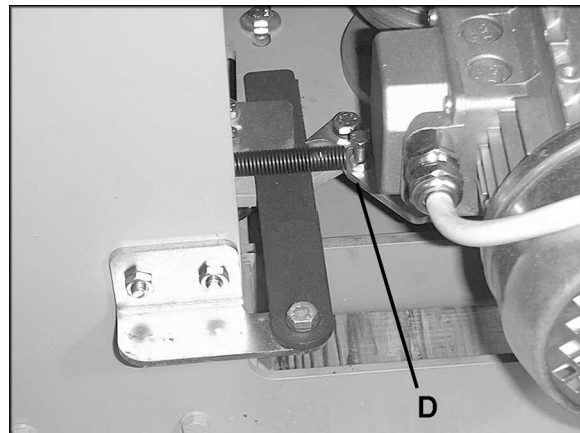


Figure 12

Feed Rollers

The infeed and outfeed rollers and chipbreaker have been factory set. However, if spring tension adjustment should ever be necessary, use the appropriate adjustment assembly located beneath the lip of the frame – one is shown in Figure 13.

1. Loosen the nut and turn the screw in or out. When finished, tighten nut.
2. Perform the same adjustment at the opposite end of the roller.

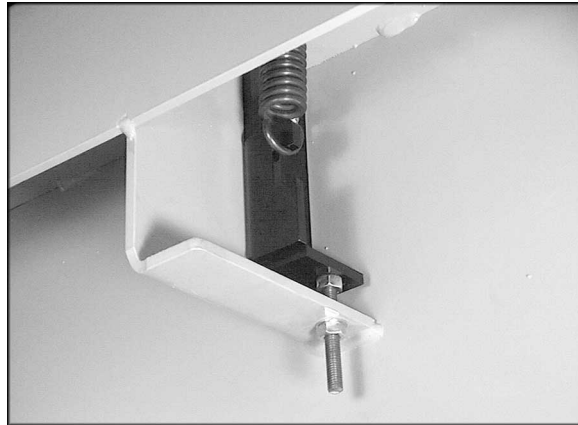


Figure 13

Table Rollers

The table rollers can be raised or lowered with the handle (Figure 14). A label is affixed near the handle for reference.



Figure 14

Maintenance

⚠WARNING Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Follow lockout/tagout procedures. Failure to comply may cause serious injury.

The anti-kickback fingers must hang down freely and operate independently by gravity. They should be inspected frequently and cleaned whenever necessary.

The table should be kept clean and free of rust or deposits.

The lead screws and posts beneath the table, and the drive chains, should be kept clean and oiled.

Periodically blow out saw dust from the motor's cooling fan.

Troubleshooting: Operating Problems

| Trouble | Probable Cause | Remedy |
|--|--|---|
| Snipe (NOTE: Snipe can be minimized but not eliminated) | Table rollers not set properly. | Adjust rollers to proper height. |
| | Inadequate support of long boards. | Support long boards with extension rollers. |
| | Uneven feed roller pressure front to back. | Adjust feed roller tension. |
| | Dull knives. | Reverse or replace knives. |
| | Lumber not butted properly. | Butt end to end each piece of stock as they pass through. |
| Fuzzy Grain | Planing wood with high moisture content. | Remove moisture content from wood by drying, or choose other stock. |
| | Dull knives. | Reverse or replace knives. |
| Torn Grain | Too heavy a cut. | Adjust proper depth of cut. |
| | Knives cutting against grain. | Cut along the grain. |
| | Dull knives. | Reverse or replace knives. |
| Rough or Raised Grain | Dull knives. | Reverse or replace knives. |
| | Too heavy a cut. | Adjust proper depth of cut. |
| | Moisture content too high. | Remove moisture content from wood by drying, or choose other stock. |
| Rounded, glossy surface | Dull knives. | Reverse or replace knives. |
| | Feed speed too slow. | Increase speed. |
| | Cutting depth too shallow. | Increase depth. |
| Poor feeding of lumber | Inadequate feed roller pressure. | Adjust feed roller tension. If proper tension cannot be achieved, replace feed rollers. |
| | Planer bed rough or dirty. | Clean pitch and residue, and wax planer table. |
| | Transmission v-belt slipping. | Tighten transmission v-belt. |
| | Surface of feed rollers too smooth. | Lightly roughen the feed roller surface with sandpaper. |
| | Bed rollers too low. | Raise bed rollers to proper depth for stock. |

Troubleshooting: Mechanical & Electrical Problems

| Trouble | Probable Cause | Remedy |
|--|---|---|
| Board thickness does not match digital display | Digital display not calibrated properly. | Follow calibration procedures. |
| Chain jumping | Inadequate chain tension. | Adjust chain tension. |
| | Sprockets misaligned. | Align sprockets. |
| | Sprockets worn. | Replace sprockets. |
| Machine will not start/restart or repeatedly trips circuit breaker or blows fuses. | No incoming power. | Verify unit is connected to power, and main switch is set to "I". |
| | Overload automatic reset has not reset. | When planer overloads on the circuit breaker built into the motor starter, it takes time for the machine to cool down before restart. Allow unit to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter inside the electrical enclosure. |
| | Planer frequently trips. | One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to take a lighter cut. If too deep a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is correct then there is probably a loose electrical lead. Check amp setting on motor starter. |
| | Building circuit breaker trips or fuse blows. | Verify that planer is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter. |
| | Loose electrical connections. | Go through all the electrical connections on the planer including motor connections, verifying the tightness of each. Look for any signs of electrical arcing which is a sure indicator of loose connections or circuit overload. |
| | Motor starter failure. | Examine motor starter for burned or failed components. If damage is found, replace motor starter. If motor starter looks okay but is still suspect, you have two options: Have a qualified electrician test the motor starter for function, or purchase a new starter and establish if that was the problem on changeout. <i>(continued)</i> |

| Trouble | Probable Cause | Remedy |
|--|------------------------|--|
| Machine will not start/restart or repeatedly trips circuit breaker or blows fuses. | Motor starter failure. | If you have access to a voltmeter, you can separate a starter failure from a motor failure by first, verifying incoming voltage at 220+/-20 and second, checking the voltage between starter and motor at 220+/-20. If incoming voltage is incorrect, you have a power supply problem. If voltage between starter and motor is incorrect, you have a starter problem. If voltage between starter and motor is correct, you have a motor problem. |
| | Motor failure. | If electric motor is suspect, you have two options: Have a qualified electrician test the motor for function or remove the motor and take it to a qualified electric motor repair shop and have it tested. |
| | Miswiring of the unit. | Double check to confirm all electrical connections are correct and properly tight. The electrical connections other than the motor are pre-assembled and tested at the factory. Therefore, the motor connections should be double checked as the highest probability for error. If problems persist, double check the factory wiring. |
| | On/off switch failure. | If the on/off switch is suspect, you have two options: Have a qualified electrician test the switch for function, or purchase a new on/off switch and establish if that was the problem on changeout. |

Replacement Parts

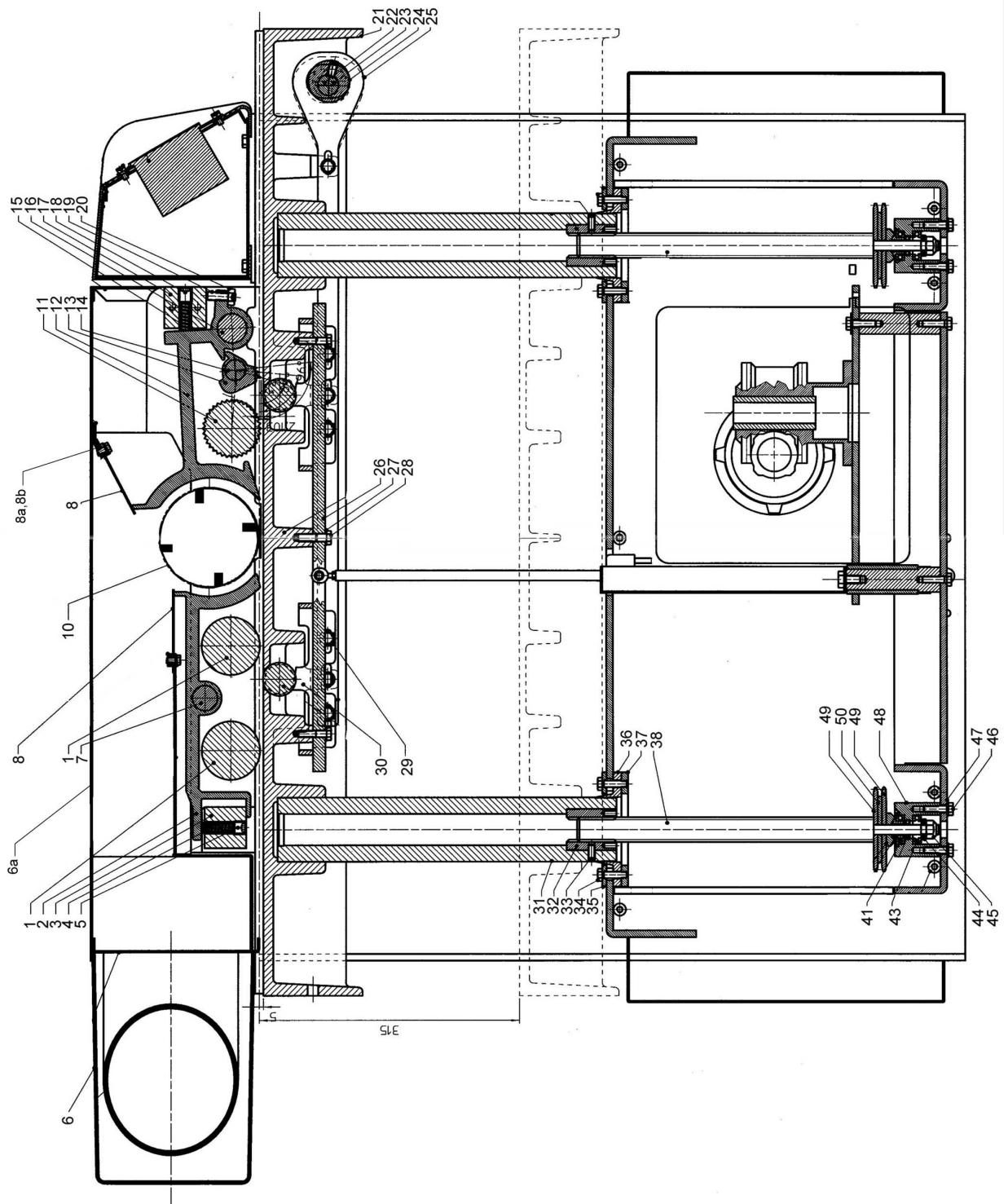
Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:00 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Parts List: Drawing No. 1

| Index No. | Part No. | Description | Size |
|-----------|-------------|--------------------------------|----------|
| 1 | WP2412-101 | Outfeed Roller | |
| 2 | WP2412-102 | Chipbreaker Section | |
| 2a | WP2412-102A | Chipbreaker Section Spacer | |
| 3 | WP2412-103 | Spring Bar | |
| 3a | TS-1504081 | Socket Head Cap Screw | M8 x 40 |
| 4 | WP2412-104 | Spring | |
| 5 | WP2412-105 | Socket Set Screw | M16 x 16 |
| 6 | WP2412-106 | Suction Outlet Cover | |
| 6a | WP2412-106A | Dust Hood Assembly | |
| 7 | WP2412-107 | Chipbreaker Axle | |
| 8 | WP2412-108 | ABS Chip Deflector | |
| 8a | TS-1482021 | Hex Cap Screw | M6 x 12 |
| 8b | TS-1550041 | Flat Washer | M6 |
| 10 | WP2412-110 | Tersa™ Monobloc Cutterhead | |
| 11 | WP2412-111 | Infeed Roller Axle | |
| 11a | WP2412-111A | Infeed Section Spacer | |
| 11b | WP2412-111B | Infeed Serrated Roller Section | |
| 11c | WP2412-111C | Infeed Roller Section Spring | |
| 11d | WP2412-111D | Complete Infeed Roll Assembly | |
| 12 | WP2412-112 | Chipbreaker Section | |
| 12a | WP2412-112A | Chipbreaker Section Spacer | |
| 13 | WP2412-113 | Anti-Kickback Finger | |
| 13a | WP2412-113A | Anti-Kickback Finger Spacer | |
| 14 | WP2412-114 | Anti-Kickback Finger Axle | |
| 15 | WP2412-104 | Spring | |
| 16 | WP2412-116 | Chipbreaker Axle | |
| 17 | WP2412-103 | Spring Bar | |
| 17a | TS-1504081 | Socket Head Cap Screw | M8 x 40 |
| 18 | WP2412-105 | Socket Set Screw | M16 x 16 |
| 19 | TS-2279351 | Socket Set Screw | M10 x 35 |
| 20 | TS-1540071 | Hex Nut | M10 |
| 21 | WP2412-121 | Planer Table | |
| 22 | TS-1525041 | Socket Set Screw | M10 x 20 |
| 23 | WP2412-123 | Roller Actuator Axle | |
| 24 | WP2412-124 | Roller Raise Eccentrics | |
| 25 | WP2412-125 | Roller Raise Actuator | |
| 26 | WP2412-126 | Strip | |
| 27 | TS-1550061 | Flat Washer | M8 |
| 28 | TS-1490061 | Hex Cap Screw | M8 x 35 |
| 29 | WP2412-129 | Spacer | |
| 30 | WP2412-130 | Right Brace | |
| 30a | WP2412-130A | Left Brace | |
| 31 | WP2412-131 | Table Column | |
| 32 | WP2412-132 | Table Raise Nut | |
| 33 | TS-1524051 | Socket Set Screw | M8 x 20 |
| 34 | TS-1490031 | Hex Cap Screw | M8 x 20 |
| 35 | WP2412-135 | Upper Column Disc | |
| 36 | WP2412-136 | Table Column Seal Ring | |
| 37 | WP2412-137 | Lower Column Backup Disc | |
| 38 | WP2412-138 | Table Raising Screw | |
| 38a | WP2412-138A | Table Raising Screw Assembly | |
| 41 | BB-51104 | Table Raise Screw Bearing | 51104 |
| 43 | BB-51104 | Table Raise Screw Bearing | 51104 |
| 46 | TS-1490051 | Hex Cap Screw | M8 x 30 |
| 47 | TS-1550061 | Flat Washer | M8 |
| 48 | WP2412-148 | Bearing Housing | |

| Index No. | Part No. | Description | Size |
|------------------|-----------------|--|-------------|
| 49 | WP2412-149 | Table Raise Sprocket | |
| 50 | WP2412-150 | Spacer Disc | |
| | WP2412-151 | Top Cover Plate (not shown) | |
| | WP2412-152 | Rear Frame Reinforcement (not shown) | |
| | WP2412-153 | Top Cover Corner Strip (not shown) | |
| | WP2412-154 | Brass Punch - Knife Change (not shown) | |

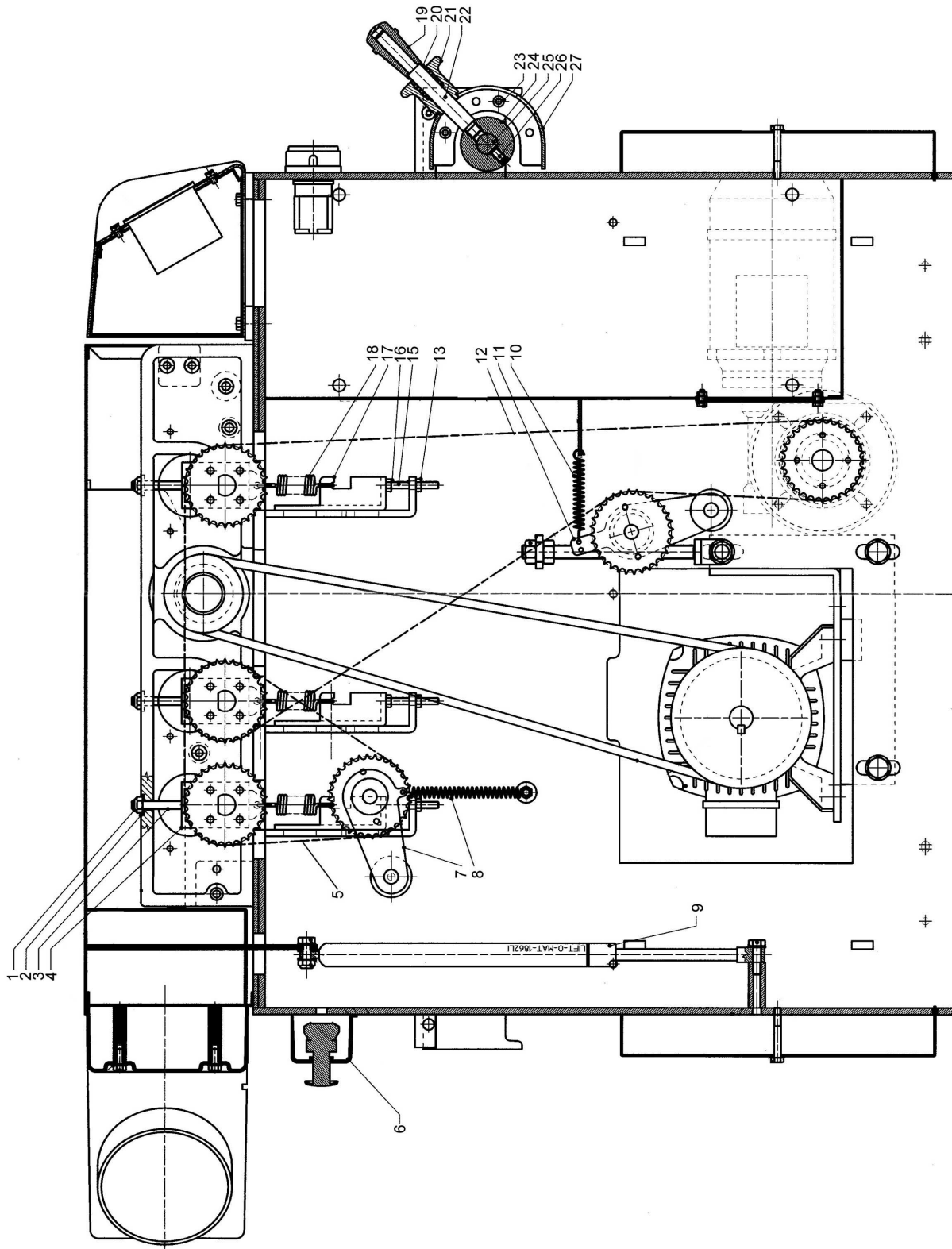
Drawing No. 1



Parts List: Drawing No. 2

| Index No. | Part No. | Description | Size |
|-----------|------------|--------------------------------|----------|
| 1 | TS-1541041 | Nylon Insert Locknut | M10 |
| 2 | TS-1550071 | Flat Washer | M10 |
| 3 | WP2412-203 | Upper Feed Roller Adjust Stud | |
| 4 | WP2412-204 | Feed Roller Bearing Housing | |
| 5 | WP2412-205 | Outfeed Roller Feed Chain | |
| 6 | WP2412-206 | E-Stop Housing | |
| 7 | WP2412-207 | Short Chain Tensioner Assembly | |
| 8 | WP2412-208 | Tensioner Spring | |
| 9 | WP2412-209 | Hood Raising Lift | |
| 10 | WP2412-208 | Tensioner Spring | |
| 11 | WP2412-211 | Long Chain Tensioner Assembly | |
| 12 | WP2412-212 | Feed Chain | |
| 13 | TS-1541031 | Nylon Insert Locknut | M8 |
| 15 | WP2412-215 | Lower Feed Roller Adjust Stud | |
| 16 | TS-1540061 | Hex Nut | M8 |
| 17 | WP2412-217 | Feed Roller Pressure Bracket | |
| 18 | WP2412-218 | Feed Roller Pressure Spring | |
| 19 | WP2412-219 | Table Roller Handle | |
| 20 | WP2412-220 | Handle Spring | |
| 21 | WP2412-221 | Locking Handle | |
| 22 | WP2412-222 | Lever | |
| 23 | TS-1504041 | Socket Head Cap Screw | M8 x 20 |
| 24 | WP2412-224 | Bushing | |
| 25 | WP2412-123 | Roller Actuator Axle | |
| 26 | TS-1525041 | Socket Set Screw | M10 x 20 |
| 27 | WP2412-227 | Handle Cover Plate | |

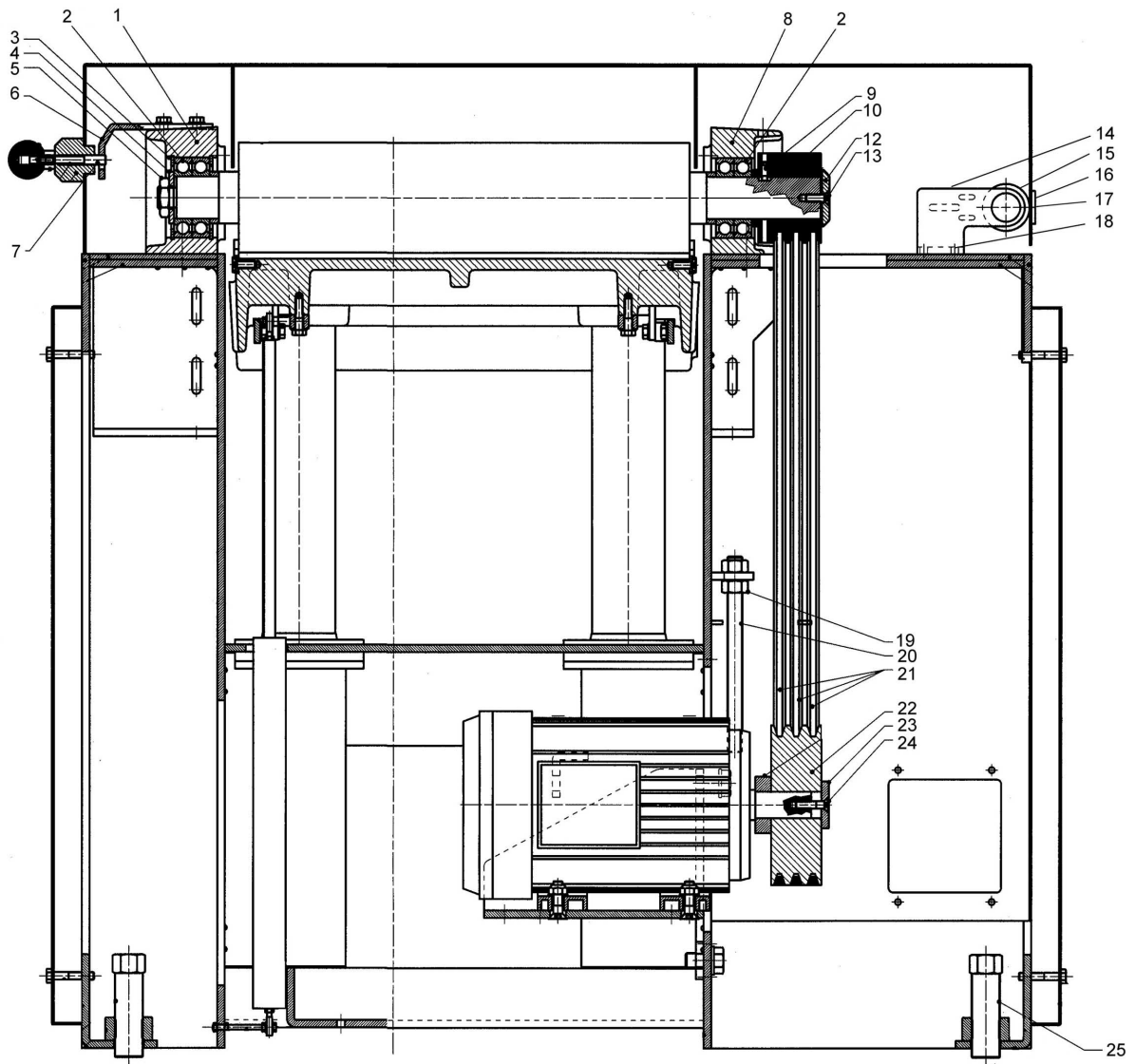
Drawing No. 2



Parts List: Drawing No. 3

| Index No. | Part No. | Description | Size |
|-----------|-------------|-----------------------------|-----------------|
| 1 | WP2412-301 | Main Bearing Housing, Left | |
| 2 | BB6209VV | Cutterhead Bearing | 6209-2RS |
| 3 | WP2412-303 | Retaining Ring | |
| 4 | WP2412-304 | Disc | |
| 5 | TS-2312241 | Hex Jam Nut | M24 |
| 6 | WP2412-306 | Hood Latch | |
| 7 | WP2412-307 | Hood Latch Pin | |
| 8 | WP2412-308 | Main Bearing Housing, Right | |
| 9 | TS-1524051 | Socket Set Screw | M8 x 20 |
| 10 | WP2412-310 | Cutterhead Pulley | |
| 12 | WP2412-312 | Disc | |
| 13 | TS-1515031 | Socket Head Flat Screw | M8 x 25 |
| 14 | WP2412-314 | Hood Hinge | |
| 15 | WP2412-315 | Hinge Pin, Front | |
| 15a | WP2412-315A | Hinge Pin, Rear | |
| 16 | WP2412-316 | Hinge Reinforcement Plate | |
| 17 | TS-1515031 | Socket Head Flat Screw | M8 x 25 |
| 18 | TS-1504041 | Socket Head Cap Screw | M8 x 20 |
| 19 | WP2412-319 | Adjustment Nut | |
| 20 | WP2412-320 | Belt Adjustment Rod | |
| 21 | WP2412-321 | Drive Belts | |
| 22 | WP2412-322 | Motor Pulley | 38mm arbor dia. |
| 23 | WP2412-323 | Washer | |
| 24 | TS-1515041 | Socket Head Flat Screw | M8 x 30 |
| 25 | WP2412-325 | Frame Leveling Bolt | |
| 25a | WP2412-325A | Leveling Bolt Nut | |

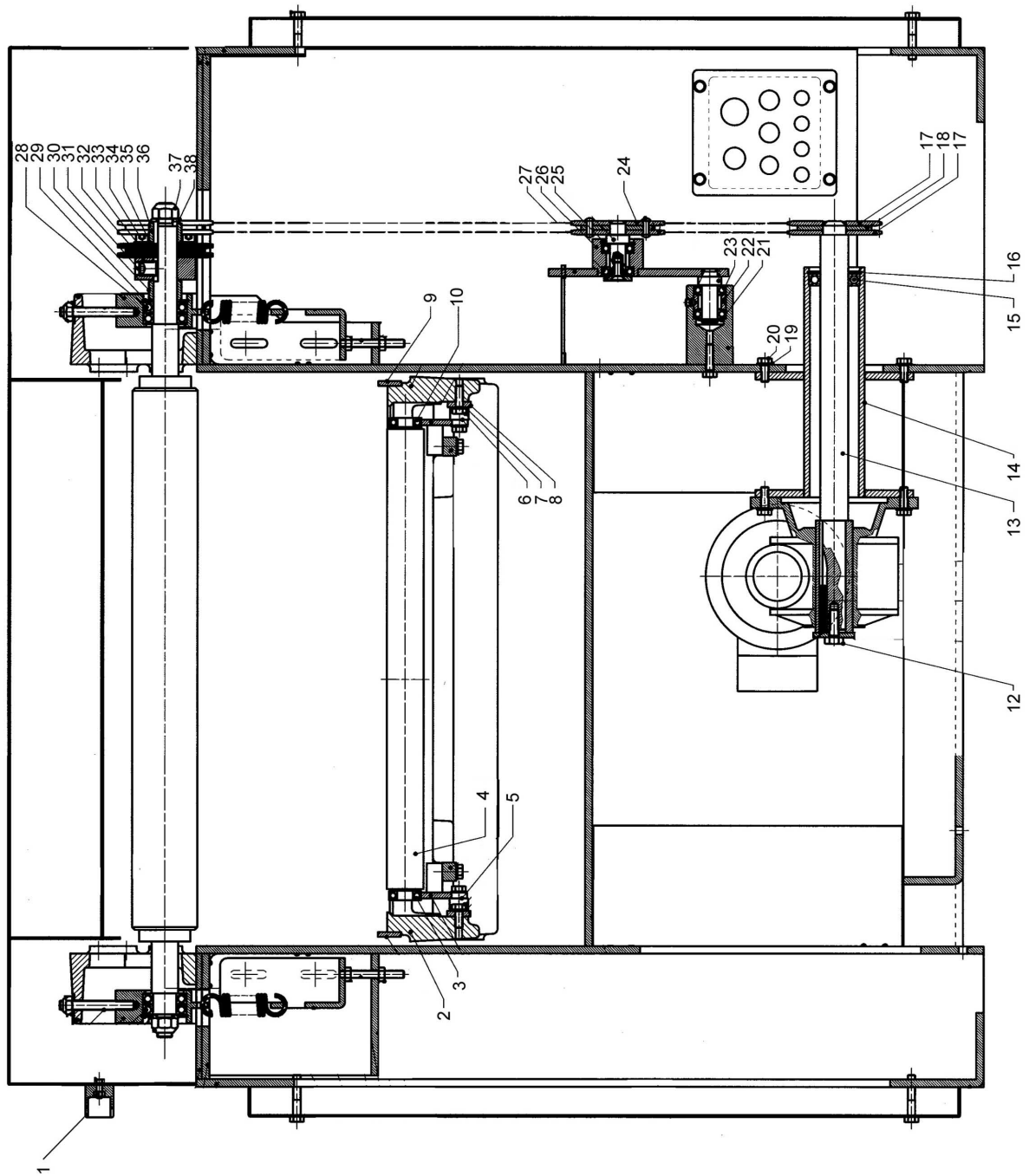
Drawing No. 3



Parts List: Drawing No. 4

| Index No. | Part No. | Description | Size |
|-----------|-------------|-------------------------------|----------|
| 1 | WP2412-401 | Hood Handle | |
| 2 | WP2412-121 | Planer Table | |
| 3 | BB6003V V | Table Roller Bearing | 6003-2RS |
| 4 | WP2412-404 | Table Roller | |
| 5 | WP2412-405 | Bushing | |
| 6 | TS-1490041 | Hex Cap Screw | M8 x 25 |
| 7 | TS-1550061 | Flat Washer | M8 |
| 8 | WP2412-125 | Roller Raise Actuator | |
| 9 | WP2412-409 | Side Strip | |
| 10 | BB6003V V | Table Roller Bearing | 6003-2RS |
| 12 | TS-1491041 | Hex Cap Screw | M10 x 30 |
| 13 | WP2412-413 | Feed Axle | |
| 14 | WP2412-414 | Feed Unit Assembly | |
| 15 | BB-6006V V | Feed Unit Bearing | 6006-2RS |
| 16 | WP2412-416 | Retainer Ring | |
| 17 | WP2412-417 | Sprocket | |
| 18 | WP2412-418 | Sprocket Spacer | |
| 19 | TS-1550061 | Flat Washer | M8 |
| 20 | TS-1490031 | Hex Cap Screw | M8 x 20 |
| 21 | WP2412-421 | Retaining Ring | |
| 22 | WP2412-422 | Spacer | |
| 23 | BB-6003V V | Bearing | 6003-2RS |
| 24 | WP2412-424 | Sprocket Assembly | |
| 25 | WP2412-425 | Retainer Ring | |
| 26 | WP2412-426 | Bushing | |
| 27 | BB-6003V V | Bearing | 6003-2RS |
| 28 | BB-6005V V | Feed Roller Bearings | 6005-2RS |
| 29 | WP2412-429 | Retaining Ring | |
| 30 | WP2412-430 | Bushing | |
| 31 | WP2412-105 | Socket Set Screw | M16 x 16 |
| 32 | WP2412-432 | Outfeed Roller Sprocket Mount | |
| 32a | WP2412-432A | Infeed Roller Sprocket Mount | |
| 33 | WP2412-433 | Sprocket | |
| 34 | WP2412-434 | Spacer | |
| 35 | WP2412-433 | Sprocket | |
| 36 | WP2412-436 | Bushing Spacer | |
| 37 | TS-2342161 | Nylon Insert Locknut | M16 |
| 38 | TS-155010 | Flat Washer | M16 |

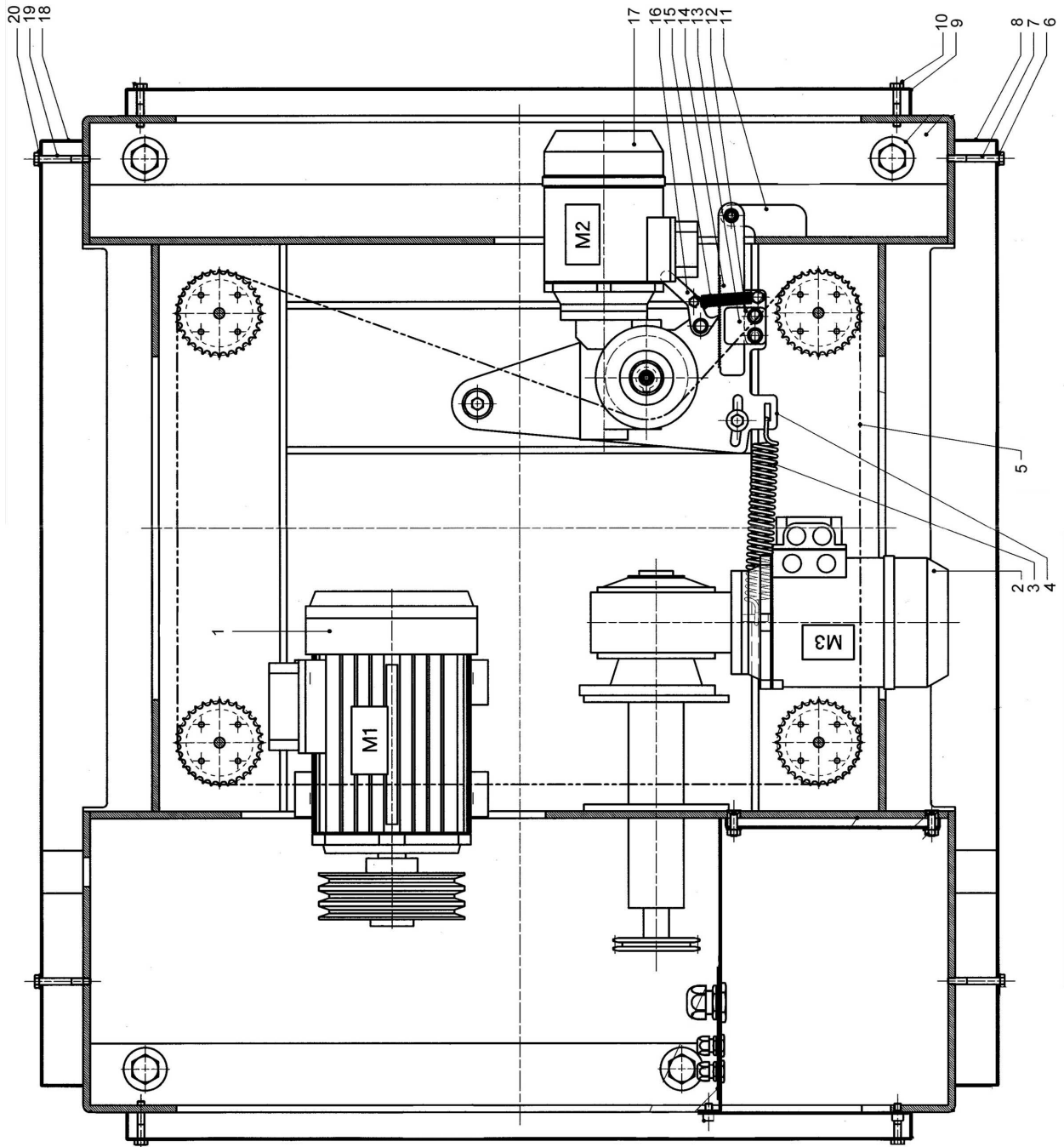
Drawing No. 4



Parts List: Drawing No. 5

| Index No. | Part No. | Description | Size |
|-----------|------------|--------------------------------|-----------------|
| 1 | WP2412-501 | Main Motor | 15HP, 230V, 3Ph |
| 2 | WP2412-502 | Feed Motor with Reducer | 1HP |
| 3 | WP2412-503 | Spring | |
| 4 | WP2412-504 | Gear Box Mounting Plate | |
| 5 | WP2412-505 | Table Raising Chain | |
| 6 | TS-1550061 | Flat Washer | M8 |
| 7 | TS-1490111 | Hex Cap Screw | M8 x 60 |
| 8 | WP2412-508 | Front Cover | |
| 9 | WP2412-509 | Side Cover | |
| 10 | TS-1490081 | Hex Cap Screw | M8 x 45 |
| 11 | WP2412-511 | Plate | |
| 12 | WP2412-512 | Plate Spanner | |
| 13 | WP2412-513 | Support Plate | |
| 14 | WP2412-514 | Toothed Lever | |
| 15 | WP2412-515 | Spring | |
| 16 | WP2412-516 | Adjustment Pawl | |
| 17 | WP2412-517 | Table Raise Motor with Reducer | .3/4HP |
| 18 | WP2412-518 | Rear Cover | |
| 19 | TS-1490111 | Hex Cap Screw | M8 x 60 |
| 20 | TS-1550061 | Flat Washer | M8 |
| | WP2412-LH | Lifting Hooks (not shown) | |

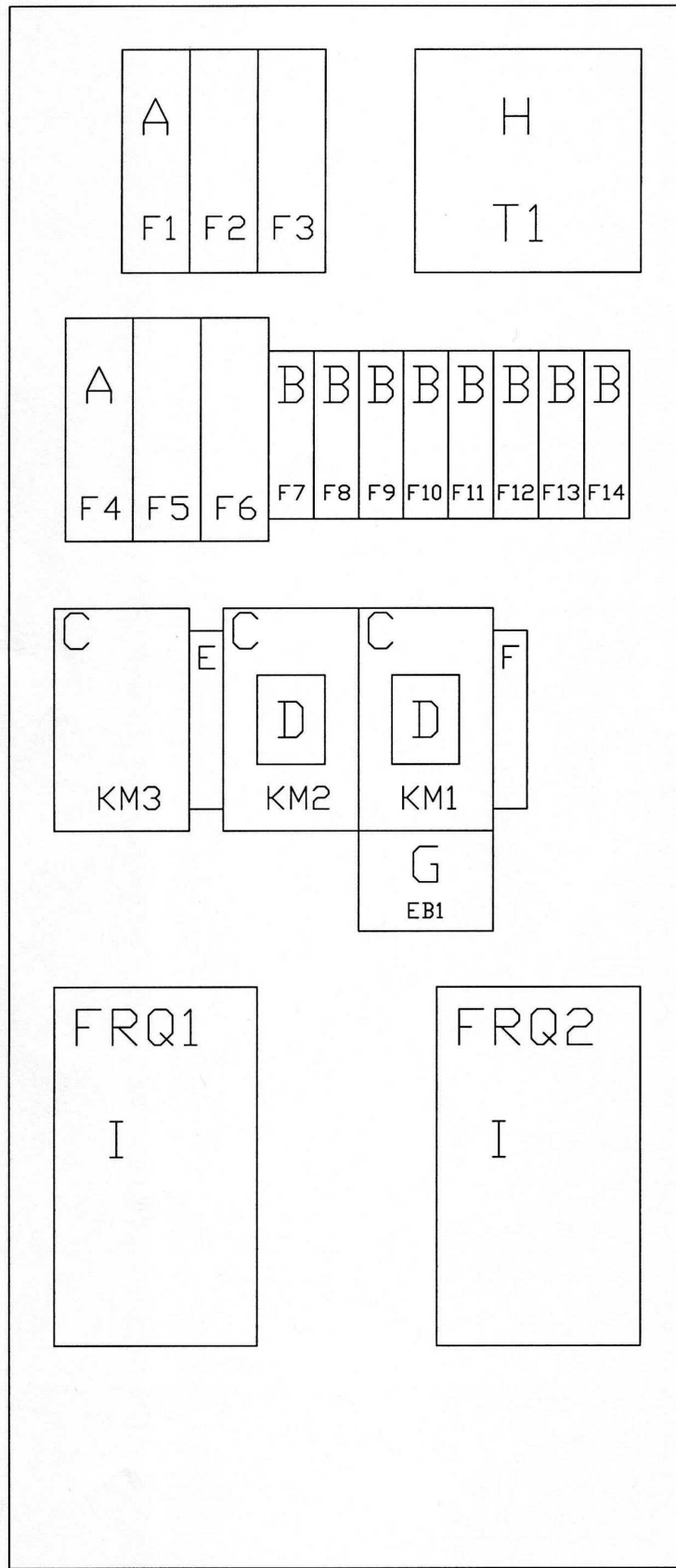
Drawing No. 5



Parts List: Electrical Box

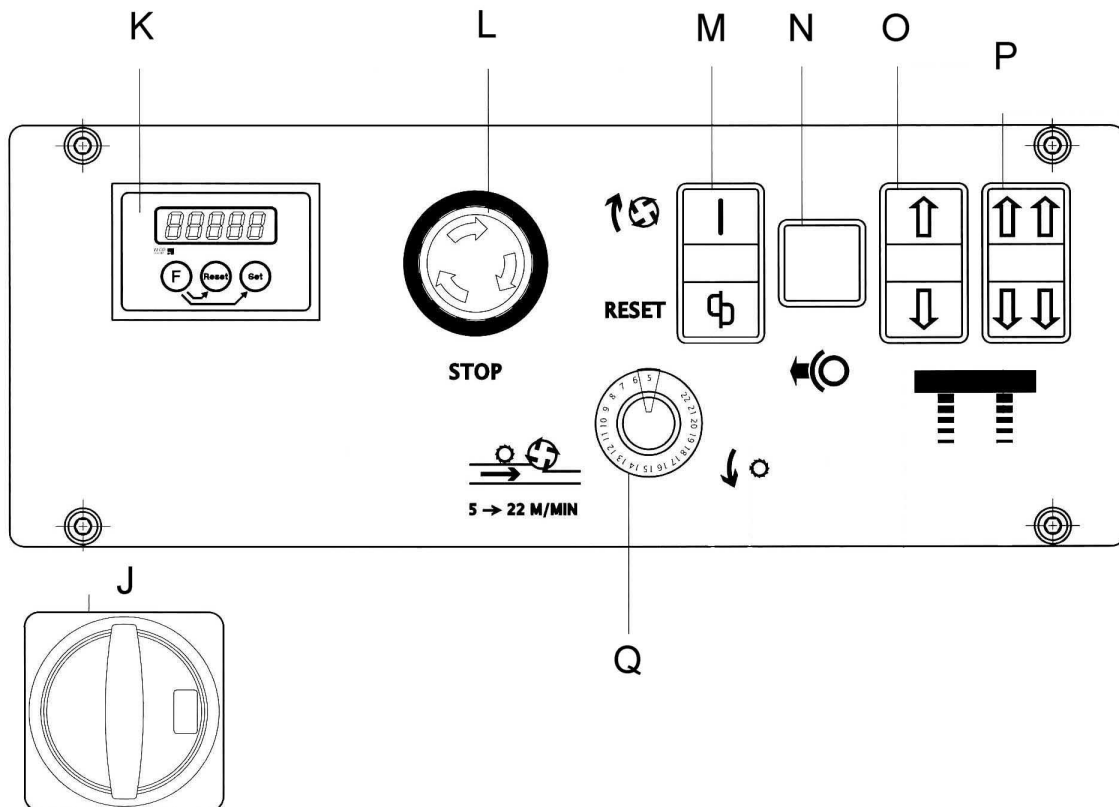
| Index No. | Part No. | Description | Size |
|-----------|------------|--|---------------|
| A | WP2412-601 | Fuse Holder | 3 poles, 50 A |
| B | WP2412-602 | Fuse Holder | 1 pole, 32A |
| C | WP2412-603 | Magnetic Starter | |
| D | WP2412-604 | Auxiliary Contact | |
| E | WP2412-605 | Mechanical Interlock between Mag. Starters | |
| F | WP2412-606 | Timer Relay Star-Delta | |
| G | WP2412-607 | Thermal Overload Relay | |
| H | WP2412-608 | Transformer | |
| I | WP2412-609 | Frequency Variator | |

Electrical Box

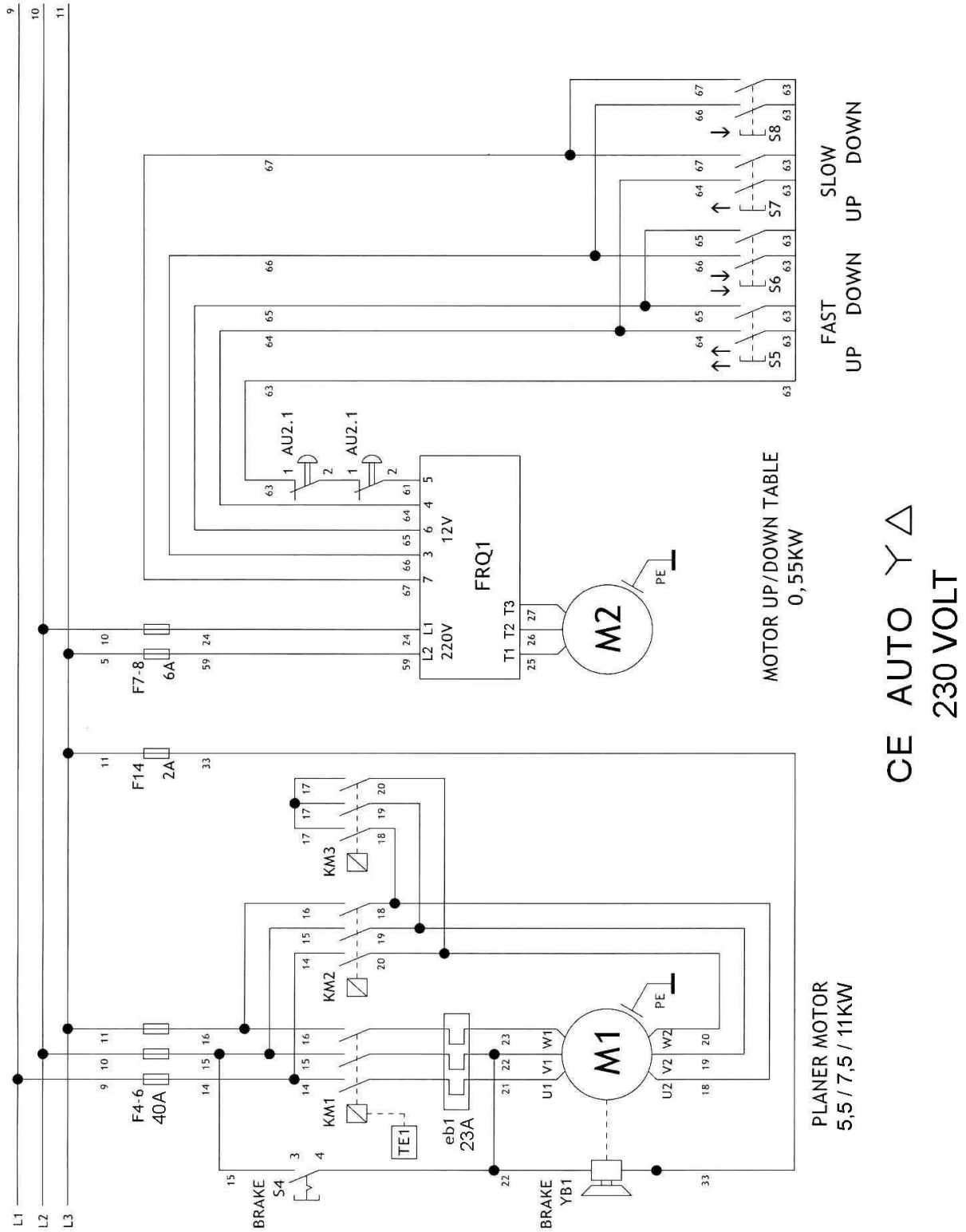


Parts List: Control Panel

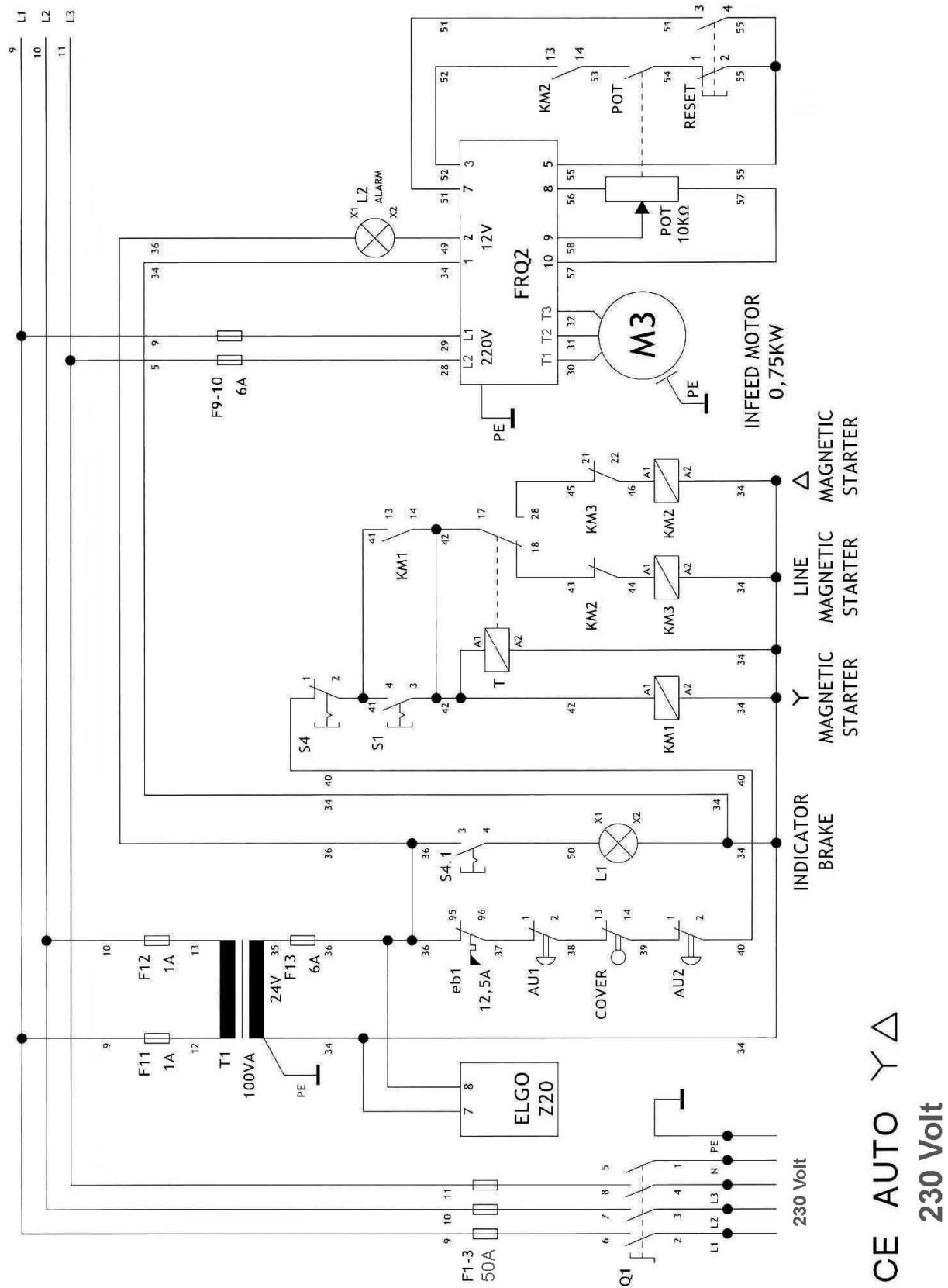
| Index No. | Part No. | Description | Size |
|-----------|------------|-------------------------------|------|
| J | WP2412-701 | Main On-Off Switch | |
| K | WP2412-702 | ELGO Read-out Z 20 | |
| L | WP2412-703 | E-Stop Operator | |
| M | WP2412-704 | Motor On/Table Reset Operator | |
| N | WP2412-705 | Brake Release Operator | |
| O | WP2412-706 | Table Slow Operator | |
| P | WP2412-707 | Table Fast Operator | |
| Q | WP2412-708 | Potentiometer | |
| | WP2412-709 | ELGO Magnetic Tape | |
| | WP2412-710 | Sensor Cable | |
| | WP2412-711 | Hood Limit Switch | |
| | WP2412-712 | Fuse | 50A |
| | WP2412-713 | Fuse | 40A |
| | WP2412-714 | Fuse | 6A |
| | WP2412-715 | Fuse | 2A |
| | WP2412-716 | Fuse | 1A |
| | WP2412-717 | Open Contact | |
| | WP2412-718 | Closed Contact | |



Electrical Connections – 230 Volt



Electrical Connections – 230 Volt



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