

EJ-16



EXTREMA MACHINERY COMPANY, INC.

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GENERAL SAFETY RULES

There is a certain amount of hazard involved with the use of woodworking machinery. Using the machine with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, severe personal injury to the operator can occur.

1. Read the operation manual before operating this machine.
2. If you are not thoroughly familiar with the machine operation, obtain advice from a supervisor or other qualified person.
3. The machine should be disconnected from the power source before performing maintenance or adjustments to the internal mechanisms, or when making repairs.
4. After maintenance job is finished, check to see if there are any tools or objects left on the machine. Close all safety guards.
5. Before leaving the machine, make sure the work area is clean.
6. Check timber for loose knots, nails, or other items, which may cause a hazard or affect the machine's performance.
7. Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to it. Keep the machine in top condition for best and safest performance.
8. Keep all guards in place and in working order.
9. Do not force the machine. It will do the job better and be safer working at the rate for which it was designed.
10. All children and visitors should be kept a safe distance from the working area.
11. The operator should keep proper footing and balance at all times.
12. Do not operate the machine while under the influence of drugs, alcohol, or any other medication.
13. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the cutterhead.
14. Never leave the machine until it comes to a complete stop, and never leave the machine running unattended.
15. The employer is responsible for selecting competent and qualified employees.
16. The employer must make sure that employees study and utilize this safety information.
17. Supervisors must alert personnel of any unsafe practices they observe.
18. All employees should be aware of first aid facilities and be encouraged to use them, regardless of the severity of the injury.
19. Fire prevention must be practiced and fire protection must be available to prevent loss of life, personal injury, and property damage.
20. Safety shoes should be worn to provide protection against rolling objects, falling objects, and sharp edges in the workplace.
21. Eye protection should be worn and such devices should be carefully selected, fitted and used. Compulsory wearing of glasses with impact resistant lenses and side shields is a good safety policy. All eye protection should conform to ANSI 87 standards.
22. Wear hearing protection when operating the machine.
23. Do not wear rings, necklaces or jewelry around moving machinery.
24. Do not wear loose fitting clothes. Clothing should be comfortable, but long sleeves, neckties, etc, should not be worn.
25. Do not wear gloves or other hand covering articles around moving machinery.
26. Cover long hair with a hair net or cap.

27. Protective guards and shields must be in place at all times unless they must be removed for specific service or maintenance. They should be immediately replaced when service or maintenance is completed.
28. Make sure that operator clearly knows how to stop the machine before starting work.
29. Never clean or remove chips while the machine is running.
30. Maintain the machine in good operating condition. Report unusual conditions or machine malfunctions immediately.
31. Do not alter or remove guards and warning labels.
32. Keep the immediate area clean. Do not allow the floor to become slippery, or covered with dust or obstacles. Dust that accumulates in the work area is a hazard that can cause you to fall or slip against the machine or its controls.
33. Employees should be required to report to their supervisors any hazardous condition of the machine or in the immediate area.

ELECTRICAL SAFETY RULES

1. Do not alter or bypass any protective interlock.
2. Before starting the machine, read and observe all warning labels and markings such as nameplates and identification plates.
3. Only personnel who are properly trained and have adequate knowledge and skill should undertake all electrical/electronic troubleshooting and repair.
4. Use extra precautions in damp areas to prevent yourself from accidental grounding.
5. Make sure your body and your tools are clear of electrical grounding.
6. The control panel doors should be opened only when it is necessary to check the electrical equipment or electrical wiring.
7. Before applying power to any equipment, establish without a doubt that all persons are clear.
8. Be alert and be sure you can work with no outside distractions.
9. Avoid wearing metal frame glasses or wearing a metallic necklace or chain, and never work on electrical equipment while wearing rings, watches, or bracelets.
10. When replacing conductors, make sure they conform to the manufacturer's specifications, including proper color-coding.
11. Do not alter the electrical circuits. If machine damage is caused by an unauthorized alteration, the user is responsible, not the manufacturer.
12. Always assume the electrical power is ON and treat circuit as live. This caution develops a habit that may prevent an accident.
13. Give capacitors time to discharge. Otherwise, it should be done manually with care.
14. Use proper test equipment to make certain you have an open circuit. Test equipment must be checked and calibrated at regular intervals.
15. Open the control panel doors only when it is necessary to check the electrical equipment or wiring. After closing the door, make sure the disconnecting means are operating with the disconnecting handle mechanism in its proper position.
16. All covers on junction boxes must be closed before leaving any job.

SHIPPING & RECEIVING INSTRUCTIONS

This machine has been carefully inspected and tested before packing. It was delivered in good condition and was shipped in one wooden pallet.

When receiving this machine, inspect the wooden pallet and check to see if there is any damage. Then check the machine model and all items as according to the packing list.

If there is any damage on the machine or any missing parts, report it to your local distributor or the machine manufacturer immediately.

UNPACKING & CHECKING CONTENTS

The machine has been well packed at the manufacturer's factory and shipped in good condition. The machine is shipped in one wooden pallet.

Upon receiving the machine, carefully unpack it and check all items as according to the packing list.

If you find any part is missed or damaged, contact your local distributor or the manufacturer of the machine immediately. Do not attempt to operate the machine until the missing parts are obtained and are installed correctly.

CLEANING THE MACHINE

The machine is coated with rust preventative oil before shipment. When the machine has been moved to the proper work site, wipe the oil from the machine using a soft cloth soaked in kerosene. Do not use gasoline, lacquer thinner, or any other volatile solvent, as these may damage the paint surface of the machine.

LIFTING THE MACHINE

The machine should be lifted or moved by a forklift. Make sure the lading capacity of the forklift is sufficient to raise the machine. Pay special attention to the machine balance while lifting the machine to prevent the machine from falling. The forks of the forklift must protrude over the machine bottom for uniform distribution of the entire machine weight.

INSTALLING THE MACHINE

The machine does not need to be bolted into the concrete floor, but should be placed on a solid and level concrete floor. Leave proper space around the machine for conveniently handling the work pieces. Make leveling adjustments after the machine has been placed in the desired location of the work site.

SPECIFICATIONS

| | |
|--------------------------|--|
| Table Area | |
| Max Planing Width | |
| Table Height | |
| Fence Slant | |
| Motor (HP) | |
| Cutterhead Speed | |
| Cutterhead Diameter | |
| Blade Quantity | |
| Machine Weight | |
| Gross Weight | |
| Packing Size (L x W x H) | |

405S1

| No | Part Name & Specification | Qty | Size | Part No |
|-----------|--------------------------------------|------------|-------------|----------------|
| 1 | Base Assembly | 1 | | 405S001A |
| 2 | Cutterhead Assembly | 1 | | 405S02 |
| 3 | Right Plate (Long) | 1 | | 405S20 |
| 4 | Left Plate (Short) | 1 | | 405S24 |
| 5 | Plate Elevation Assembly | 2 | | 500S06 |
| 6 | Stop Assembly | 1 | | 500S047 |
| 7 | Aluminum Fence Seat Down Plate | 1 | | 405078 |
| 8 | Hex Cap Bolt | 4 | M10 x 16mm | AC1016 |
| 9 | Aluminum Fence Assembly | 1 | | 405S066 |
| 10 | Lock Rod | 1 | | 3A044 |
| 11 | Motor Assembly | 1 | | 405S05 |
| 12 | Hex Cap Bolt | 2 | | A1030 |
| 13 | Return Shaft | 1 | | 405S045 |
| 14 | Hex Cap Bolt | 1 | M10 x 16mm | FK830 |

405S001A

| No | Part Name & Specification | Qty | Size | Part No |
|-----------|--------------------------------------|------------|-------------|----------------|
| 1 | Base | 1 | | 405001A |
| 2 | Flat Support Spectacle Granule | 6 | | 350005 |
| 3 | Flat Lifting Twisting Arm (Left) | 1 | | 350003 |
| 4 | Flat Lifting Twisting Arm (Right) | 1 | | 350004 |
| 5 | Flat Lifting Twisting Arm (Left) | 7 | | 500002 |
| 6 | Flat Long Spindle | 4 | | 405006 |
| 7 | Front Plate | 1 | | 405011A |
| 8 | Right Rear Plate (Long) | 1 | | 405009 |
| 9 | Left Rear Plate (Short) | 1 | | 500008 |
| 10 | Rear Cover Fixing Knob | 4 | | 500007 |
| 11 | Hex Nut | 8 | M10 | AR10 |
| 12 | Washer | 16 | M10 | SW10 |
| 13 | Hex Cap Bolt | 8 | M10 x 45mm | AC1045 |
| 14 | Spring Washer | 16 | 3/8" | SS3-8 |
| 15 | Hex Cap Bolt | 8 | M10 x 70 | AC1070 |
| 16 | Washer | 8 | | SE8 |
| 17 | Hex Head Bolt | 8 | M8 x 25mm | A825 |
| 18 | Flat Long Spindle Fixing Seat | 1 | | 500084 |
| 19 | Set Bolt | 7 | M8 x 8mm | AS88 |
| 20 | Base Rear Cover | 1 | | 500076 |
| 21 | Crosshead Bolt | 8 | M6 x 10 | AX610 |
| 22 | Front Cover Fixing Knob | 4 | | 500010 |

405S02

| No | Part Name & Specification | Qty | Size | Part No |
|-----------|--------------------------------------|------------|-------------|----------------|
| 1 | Cutterhead | 1 | | 405027A |
| 2 | Front Cutterhead Cass (Small) | 1 | | 500028A |
| 3 | Rear Cutter Cass (Large) | 1 | | 500040A |
| 4 | Bearing | 1 | 6206 | BE6206VV |
| 5 | Bearing | 1 | 6208 | BE6208 |
| 6 | Front Cass Dust Proof Cover | 1 | | 500029A |
| 7 | Brake Nut | 1 | | 500030A |
| 8 | Rear Cass Dust Proof Cover | 1 | | 500037A |
| 9 | Bearing Lock Nut | 1 | | 500036A |
| 10 | Cutterhead Belt Wheel | 1 | | 500035 |
| 11 | Cutterhead Stop Plate | 1 | | 500034A |
| 12 | Cutterhead Belt Wheel Knob | 1 | | 500033A |
| 13 | Brake Rod Assembly | 1 | | 500S02 |
| 14 | Spring Washer | 6 | | SPN006 |
| 15 | Cutter | 3 | 16" | E16 |
| 16 | Bib | 3 | | 405032A |
| 17 | Cutter Knob | 21 | | 500031A |
| 18 | Spring Washer | 4 | 3/8" | SS3-8 |

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|----|-----------------------|---|-----------|---------|
| 19 | Hex Head Bolt | 4 | M10 x 30 | A1030 |
| 20 | Hex Cap Bolt | 6 | M5 x 16mm | AC516 |
| 21 | Rear Cutter Cass Door | 1 | | 500039A |
| 22 | Catch Plate | 1 | | DR02 |
| 23 | Catch Plate | 1 | | D03 |
| 24 | Cross Head Bolt | 3 | | AX415 |
| 25 | Knob | 1 | | FN535 |
| 26 | Hex Nut | 2 | | AR5 |

500S06

| No | Part Name & Specification | Qty | Size | Part No |
|----|---------------------------------|-----|---------|----------|
| 1 | Lifting Fixing Seat | 1 | | 500017 |
| 2 | Lifting Hand Wheel | 1 | | 500018 |
| 3 | Lifting Large Umbel Gear | 1 | | 500013 |
| 4 | Lifting Knob | 1 | | 500014 |
| 5 | Lifting Seat Shaft Rod | 1 | | 500015 |
| 6 | Lifting Small Umbel Gear Rod | 1 | | 500016 |
| 7 | Lifting Screw | 1 | | 500012 |
| 8 | S Retainer Ring | 1 | | CS40 |
| 9 | C Ring | 1 | S22 | CS22 |
| 10 | C Ring | 3 | S28 | CS28 |
| 11 | Hand Wheel Fixing Washer | 1 | | SK110550 |
| 12 | Lock Knob | 1 | | FK1020 |
| 13 | Knob | 1 | | FD3-8S |
| 14 | Hexagon Head Bolt | 3 | | AB825 |
| 15 | Hex Nut | 1 | M8 | ARB8 |
| 16 | Hexagon Socket Head Fixing Bolt | 2 | | AS612 |
| 17 | Oiler | 1 | | G3-16 |
| 18 | Key | 1 | | KD515 |
| 19 | Spring Washer | 2 | 5/16" | SS5-16 |
| 20 | Set Screw | 1 | 3/8"-2" | AS3-820 |
| 21 | Hex Nut | 1 | 3/8" | AR3-8 |

405S024A

| No | Part Name & Specification | Qty | Size | Part No |
|----|---------------------------|-----|-----------|---------|
| 1 | Right Plate (Long) | 1 | | 405020 |
| 2 | Front Cover Silence | 2 | | 405022 |
| 3 | Plate Support Rod | 8 | | 500021 |
| 4 | Hex Nut | 8 | M14 | AR14 |
| 5 | Washer | 8 | | SS304 |
| 6 | Hex Cap Bolt | 10 | M6 x 25mm | AC625 |
| 7 | Dust Proof Cover | 2 | | 405023 |
| 8 | Hex Head Bolt | 6 | | A612 |

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|----|--------------------|---|-----|--------|
| 9 | Hex Cap Bolt | 8 | | AS865 |
| 10 | Hex Nut | 8 | M10 | AR10 |
| 11 | Hex Head Bolt | 8 | | A820 |
| 12 | Left Plate (Short) | 1 | | 405024 |

500S02

| No | Part Name & Specification | Qty | Size | Part No |
|----|---------------------------|-----|--------|---------|
| 1 | Rear Cutter Cass Door | 1 | | 500044 |
| 2 | Washer | 1 | | 500043 |
| 3 | Handle | 1 | | 500042 |
| 4 | Brake Casing | 1 | | 500041 |
| 5 | Spring Washer | 1 | | PS320 |
| 6 | Screw Bolt | 1 | M6 x 6 | AS66 |

405S05

| No | Part Name & Specification | Qty | Size | Part No |
|----|---------------------------|-----|------------|----------|
| 1 | Motor | 1 | 5HP | MT1905A |
| 2 | Motor Belt Wheel | 1 | | 20P010A |
| 3 | Motor Plate | 1 | | 500083 |
| 4 | Spring Washer | 4 | 3/8" | SS3-8 |
| 5 | Hex Head Bolt | 4 | M10 x 30 | A1030 |
| 6 | Hex Nut | 4 | M10 | AR10 |
| 7 | Spring Washer | 2 | 1/2" | SW1-2 |
| 8 | Hex Head Bolt | 2 | M12 x 25 | A1225 |
| 9 | Key | 1 | 7 x 7 x 65 | KD765 |
| 10 | Screw Bolt | 1 | | AS5-1604 |

500S049

| No | Part Name & Specification | Qty | Size | Part No |
|----|--------------------------------|-----|--------|---------|
| 1 | Return Tin Mandrel | 1 | | 500052 |
| 2 | Return Tin Head Top | 1 | | 500053 |
| 3 | Return Tin Turn Table | 1 | | 500054 |
| 4 | Return Tin Force Torque Spring | 1 | | 500051 |
| 5 | Return Tin Lower Head | 1 | | 500049 |
| 6 | Return Tin | 1 | | 500050 |
| 7 | Pin | 1 | 4 x 12 | PS412 |
| 8 | Pin | 1 | 4 x 16 | PS416 |
| 9 | Hex Cap Bolt | 1 | | AC410 |
| 10 | Pin | 4 | 3 x 8 | PS308 |

405S066B

| No | Part Name & Specification | Qty | Size | Part No |
|-----------|--------------------------------------|------------|------------------|----------------|
| 1 | Adjust Shaft | 1 | | 20V015 |
| 2 | Cutterhead Top Plate | 1 | | 405060A |
| 3 | Rotary Gear Pipe | 1 | | 405063 |
| 4 | Fence Skewness Spectacle Arm | 2 | | 405065 |
| 5 | Skewness Main Seat | 1 | | 405066B |
| 6 | Fence Support Seat | 1 | | 405071A |
| 7 | Fence Skewness Support Shaft (Long) | 2 | | 405073 |
| 8 | Fence Skewness Support Shaft (Down) | 1 | | 405073 |
| 9 | Aluminum Fence | 1 | | 405075 |
| 10 | Fence Skewness Support Shaft (Left) | 1 | | 405079 |
| 11 | Fence Skewness Support Shaft (Right) | 1 | | 405080 |
| 12 | Skewness Main Seat Anchor Iron | 1 | | 405081 |
| 13 | Aluminum Angle Fence Fasten | 1 | | 405083 |
| 14 | Fence Base Spindle | 2 | | 405084 |
| 15 | Hand Wheel | 1 | | 405085 |
| 16 | Rotary Adjustment Gear Shaft | 1 | | 500061 |
| 17 | Rotary Gear Pipe Sliding Seat | 1 | | 500062B |
| 18 | Hex Head Bolt | 1 | M6 x 35mm | A635 |
| 19 | Hex Head Bolt | 1 | M6 x 40mm | A640 |
| 20 | Hex Head Bolt | 8 | M8 x 50mm | A850 |
| 21 | Hex Cap Bolt | 2 | M10 x 30mm | AC1030 |
| 22 | Hex Cap Bolt | 2 | M10 x 60mm | AC1060 |
| 23 | Hex Cap Bolt | 2 | M6 x 35mm) | AC635 |
| 24 | Hex Cap Bolt | 6 | M8 x 50mm | AC850 |
| 25 | Hex Nut | 1 | 5/16" | AR5-16 |
| 26 | Hex Nut | 2 | M6 | ARE6 |
| 27 | Hex Nut | 1 | M8 | ARE8 |
| 28 | Screw Bolt | 1 | 5/16" x 1" | AS5-161 |
| 29 | Set Screw | 1 | M6 x 10mm | AS610 |
| 30 | Set Bolt | 2 | M6 x 8mm | AS68 |
| 31 | Set Screw | 2 | M8 x 25mm | AS825 |
| 32 | Crosshead Bolt | 2 | M6 x 10mm | AS610 |
| 33 | Knob | 1 | 3/8" | FD3-8 |
| 34 | Washer | 2 | 16 x 1/4" x 2mm | SE1-4 |
| 35 | Washer | 8 | 23 x 5/16" x 3mm | SE5-16 |
| 36 | Disk Washer | 2 | M6 | SF6 |
| 37 | Spring Washer | 2 | M10 | SS10 |
| 38 | Spring Washer | 2 | 3/8" | SS3-8 |
| 39 | Spring Washer | 6 | 5/16" | SS5-16 |
| 40 | Knob | 2 | 1/2" x 25mm | TRS1-225 |
| 41 | Knob | 1 | 5/16" | YK5-16 |

405S066

| No | Part Name & Specification | Qty | Size | Part No |
|-----------|--------------------------------------|------------|-------------|----------------|
| 1 | Skewness Main Set | 1 | | 405066 |
| 2 | Aluminum Fence Move Seat | 1 | | 405066A |
| 3 | Fence Skewness Spectacle Arm | 2 | | 405065 |
| 4 | Fence Skewness Support Shaft (Long) | 2 | | 405072 |
| 5 | Aluminum Fence | 1 | | 405075 |
| 6 | Fence Skewness Support Shaft (Down) | 1 | | 405073 |
| 7 | Fence Support Seat | 1 | | 405071A |
| 8 | Fence Skewness Support Shaft (Left) | 1 | | 405079 |
| 9 | Fence Skewness Support Shaft (Right) | 1 | | 45080 |
| 10 | Knob | 1 | ½" x 25 | TRS1-225 |
| 11 | Skewness Main Seat Anchor Iron | 1 | | 405071 |
| 12 | Aluminum Angle Fence Fasten | 1 | | 405083 |
| 13 | Washer | 4 | | SE10 |
| 14 | Hex Head Bolt | 4 | M10 x 35mm | A1035 |
| 15 | Washer | 2 | M6 | SF6 |
| 16 | Hex Cap Bolt | 2 | M6 x 35mm | AC635 |
| 17 | Hex Head Bolt | 1 | M6 x 35mm | A635 |
| 18 | Hex Nut | 2 | M6 | SF6 |
| 19 | Hex Head Bolt | 1 | M6 x 40 | A640 |
| 20 | Washer | 8 | | SE8 |
| 21 | Hex head Bolt | 8 | M8 x 50mm | A850 |
| 22 | Set Bolt | 2 | M6 x 8mm | AS68 |
| 23 | Set Screw | 1 | M8 x 25mm | AS825 |
| 24 | Set Screw | 1 | M6 x 10mm | AS610 |