

## CHAIN DRIVE

The chain drive is adjusted before the machine leaves the factory, but may require adjustment after long usage.

To adjust the chain drive the jockey pulley can be moved to the correct tension. (Fig.5.13)

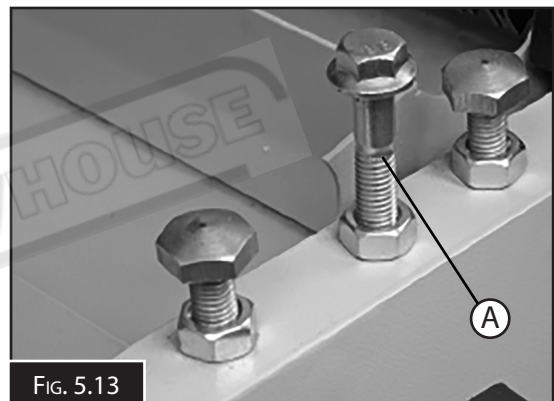
NOTE: Care should be taken when adjusting the jockey pulley and should only be attempted by an experienced service engineer. Incorrect tension may cause the chain to break or damage the sprockets.



## 5.5 RE-TIGHTENING THE TABLE LOCK DOWN HANDLES.

If the table lock downs becomes loose they can be adjusted by altering the height of the table lock stud.

Hold the stud firmly and loosen the lock nut, adjust the stud, lightly 'pinch' with the lock nut, and try. ("A" in Fig.5.13)



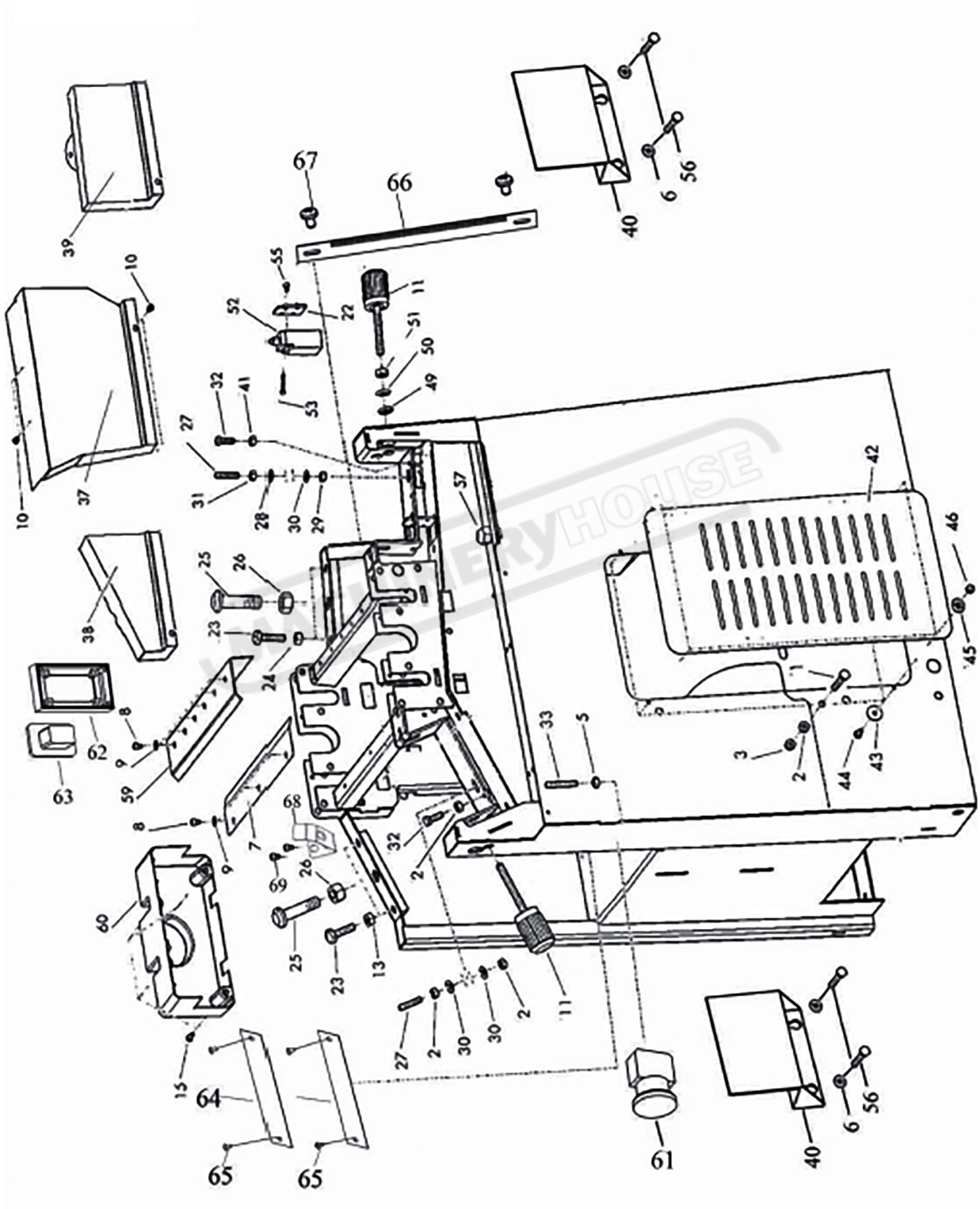
## SPARE PARTS SECTION

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

### HOW TO ORDER SPARE PARTS

1. Have your machines model number, serial number & date of manufacture on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to [www.machineryhouse.com.au/contactus](http://www.machineryhouse.com.au/contactus) and fill out the enquiry form attaching a copy of scanned parts list.

**PT-254S SPARE PARTS DIAGRAM A**



## OPERATION MANUAL

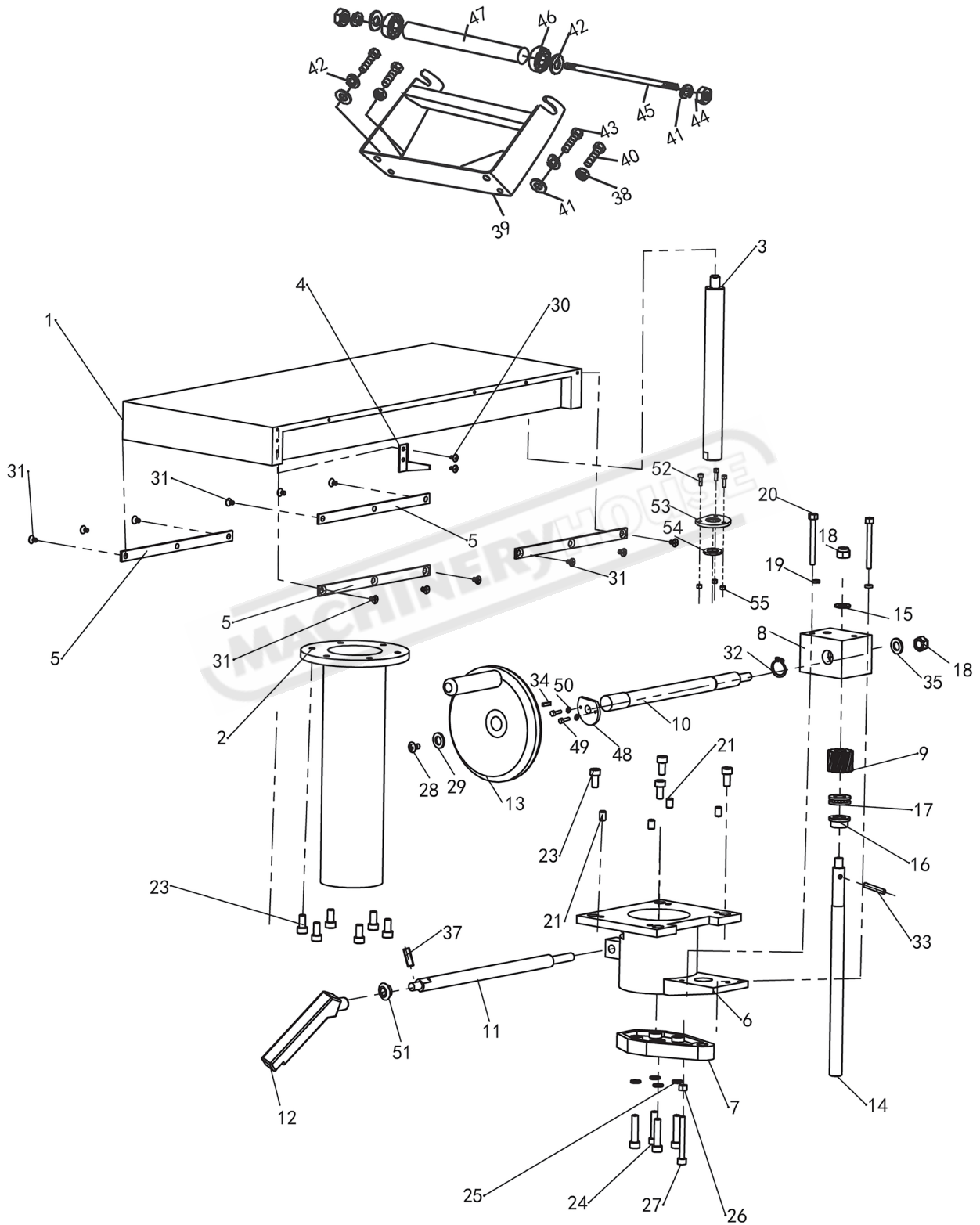
### PT-254S PARTS LIST DIAGRAM A

No.	Description	No.	Description
A-1	Screw hex head M8x45	A-32	Screw hex head M8x25
A-2	Nut hex M8	A-33	Set screw M8x50
A-3	Nut hex,lock M8	A-37	Guard,belt
A-5	Nut hex M8	A-38	Guard belt,left
A-6	Pan head screw M6x10	A-39	Guard belt,right
A-7	Cover plate,feed roller	A-40	Cover,terminal box
A-8	Allen screw M6x10	A-41	Nut hex M8
A-9	Spring washer 6mm	A-42	Cover plate,friction wheel
A-10	Pan head screw M6x10	A-43	Flat washer 6mm
A-11	Adjust handle, planer table	A-44	Screw hex head M6x12
A-15	Pan head screw M6x30	A-45	Flat washer 6mm
A-16	Nut hex M6	A-46	Cap nut M7
A-17	Cover plate,control panel	A-49	Wave washer
A-18	Emergency-off button	A-50	Wave washer
A-19	Planer-off button	A-51	Nut hex M10
A-20	Planer-on button	A-52	Limit switch
A-21	Control panel	A-54	Pan head screw M4x30
A-22	Connection Plate,Micro Switch	A-55	Allen screw M5x10
A-23	Stop screw,table	A-56	Pan head screw M6x8
A-24	Nut hex M10	A-57	Strain relief
A-25	Lock screw,table	A-58	Transport retainer
A-26	Nut hex M16	A-59	Guard cover,feed roller
A-27	Set screw M8x40	A-60	Plastic Gear cover
A-28	Washer 8mm	A-63	Power Switch
A-29	Nut hex M8	A-64	Fence bracket
A-30	Washer 8mm	A-65	Flat washer
A-31	Nut hex M8	A-66	Pan head screw M8x12
		A-67	Stop spring plate
		A-68	Pan head screw M5x8



# OPERATION MANUAL

## PT-254S SPARE PARTS DIAGRAM B

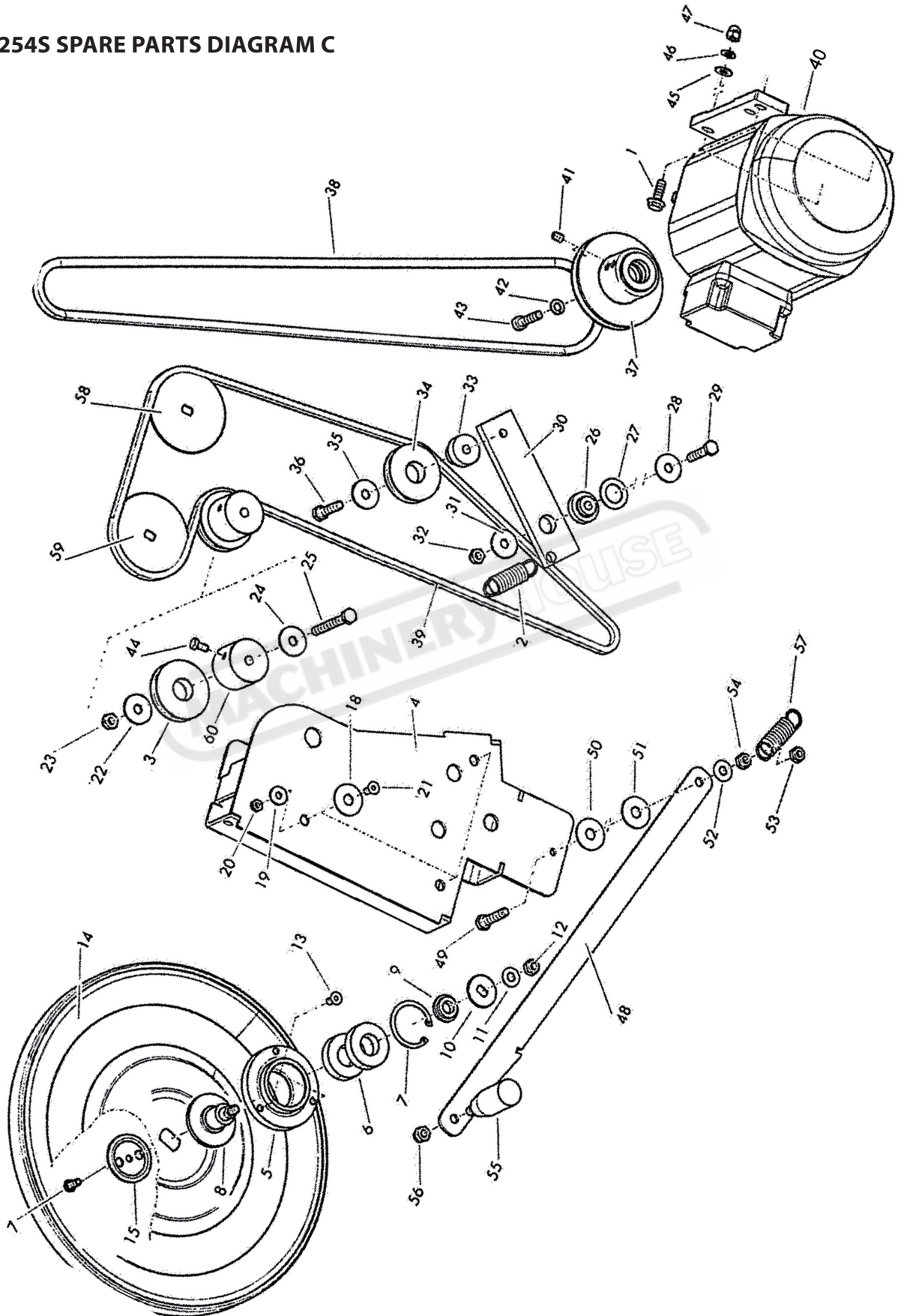


## OPERATION MANUAL

### PT-254S PARTS LIST. DIAGRAM B

No.	Description	No.	Description
B-2	Rise and fall clamp lever	B-30	Nut hex M8
B-3	Screw hex head M6x16	B-31	Scale rule
B-4	Allen screw M10x50	B-32	Washer 6mm
B-5	Cone gear A	B-33	Spring washer 6mm
B-6	Cone gear B	B-34	Screw hex head M6x16
B-8	Raise guide rail	B-35	Roll pin 6x22
B-9	Collar stop	B-36	Scale,body
B-10	Rise and fall shaft	B-37	Flat washer 6mm
B-11	Bearing 6003	B-40	Collar,stop
B-12	Pan head screw M6x12	B-41	Set screw M6x6
B-13	Fixed guide rail	B-42	Set screw M6x6
B-14	Raise and fall guide rod	B-44	Support roller
B-15	Bush for rise and fall guide rod	B-45	Hex head screw M8x25
B-16	Bearing 6303	B-46	Washer 10mm
B-17	Washer 8mm	B-47	Spring washer 10mm
B-18	Pan head screw M6x12	B-48	Hex head screw M10x30
B-19	Ring circle	B-49	Hex nut M10
B-20	Handle-wheel	B-50	Spring washer 10mm
B-25	Insert,table bolt	B-51	Washer 10mm
B-26	Nut adjust	B-52	Threaded rod
B-27	Wave washer	B-53	Bearing 6202
B-28	Special thread	B-54	Roller
B-29	Thin washer	B-55	Key
		B-56	Flat washer 8mm
		B-57	Hex.bolt M6

**PT-254S SPARE PARTS DIAGRAM C**

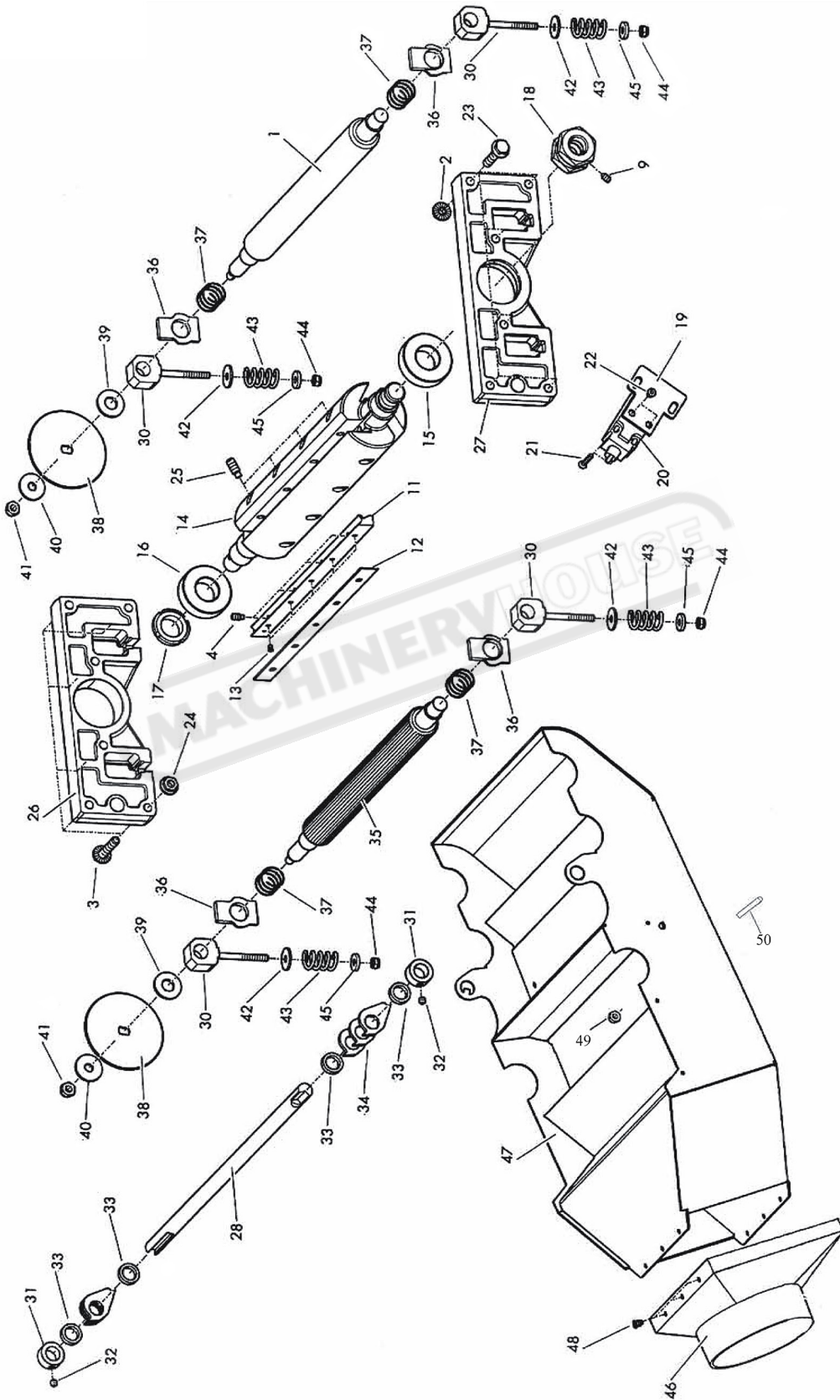


## OPERATION MANUAL

### PT-254S PARTS LIST. DIAGRAM C

No.	Description	No.	Description
C-1	Screw hex w/flange M8x25	C-31	Flat washer 8mm
C-2	Pull spring	C-32	Lock nut M8
C-3	Tension pulley	C-33	Spacer
C-4	Guide friction pulley	C-34	Tension pulley
C-5	Spacer lock	C-35	Flat washer 8mm
C-6	Ball bearing 6004-2Z	C-36	Hex head screw M8x45
C-7	Circle ring 42mm	C-37	Motor pulley
C-8	Shaft friction pulley	C-38	Drive belt XPZ 1250
C-9	Spacer,friction pulley	C-39	Drive chain 05B-1-172
C-10	Sprocket B	C-40	Motor
C-11	Flat washer 8mm	C-41	Set screw M8x10
C-12	Lock nut M8	C-42	Spring washer 6mm
C-13	Sunk head screw M6x16	C-43	Allen screw M8x40
C-14	Friction Pulley	C-44	Hex head screw M6x16
C-15	Ring	C-45	Special washer 8mm
C-17	Screw hex head M6x12	C-46	Spring washer 6mm
C-18	Nylon ring	C-47	Cap nut M8
C-19	Washer 6mm	C-48	Lever,friction pulley
C-20	Lock nut M6	C-49	Hex head screw M8x45
C-21	Sunk head screw M6x16	C-50	Plastic washer
C-22	Flat washer 8mm	C-51	Plastic washer
C-23	Lock nut M8	C-52	Flat washer 8mm
C-24	Flat washer 8mm	C-53	Lock nut M8
C-25	Screw hex head M8x70	C-54	Lock nut M8
C-26	Collar	C-55	Lever handle
C-27	Plastic washer	C-56	Cap nut M8
C-28	Flat washer 8mm	C-57	Pull spring
C-29	Hex head screw M8x45	C-58	Sprocket A
C-30	Tension plate	C-59	Sprocket A
		C-60	Shaft tension pulley

**PT-254S SPARE PARTS DIAGRAM D**



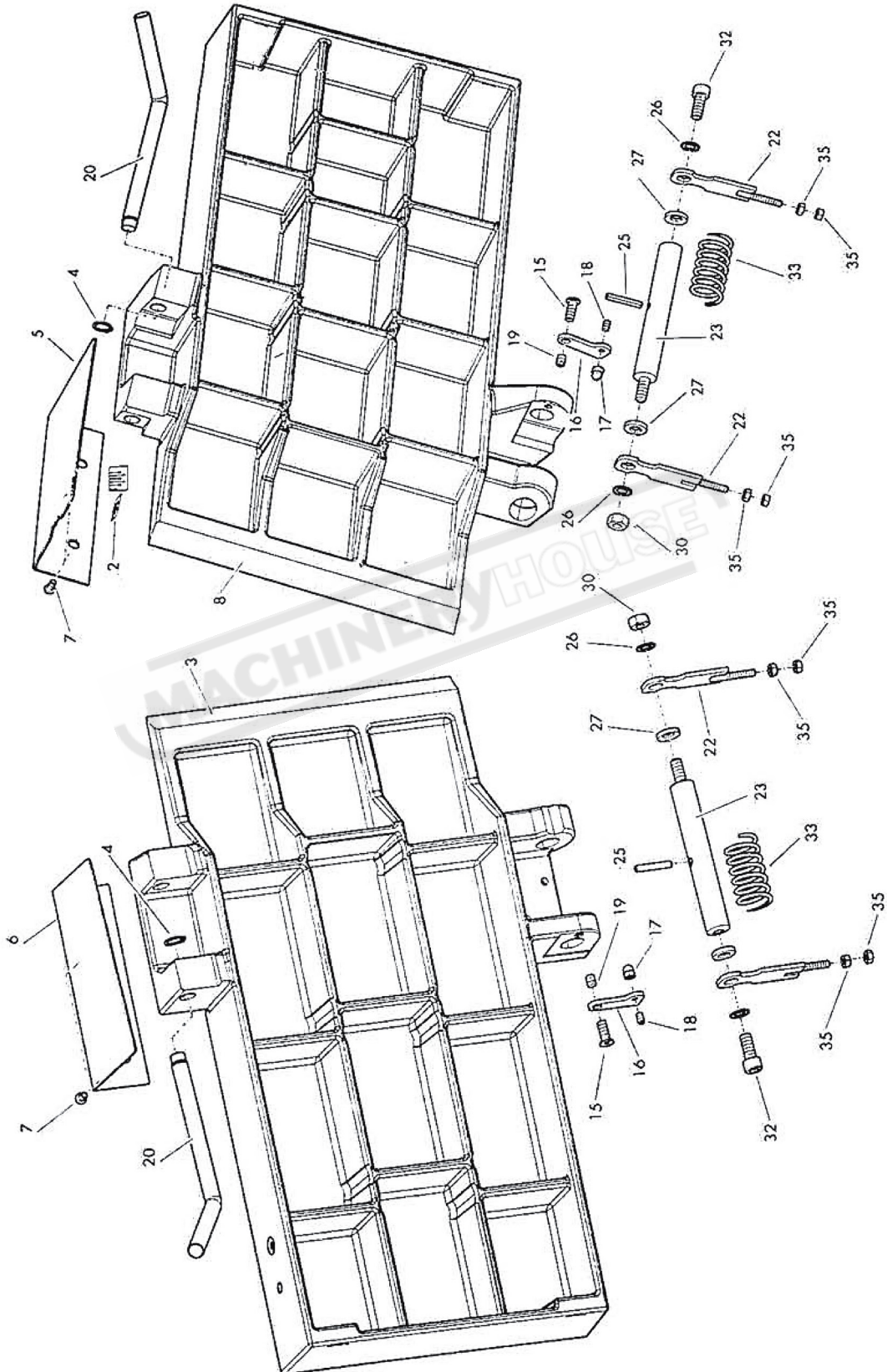


## OPERATION MANUAL

### PT-254S PARTS LIST. DIAGRAM D

No.	Description	No.	Description
D-1	Outfeed roller	D-32	Set screw M6x6
D-2	Nut hex w/flange M8	D-33	Spacer
D-3	Screw hex w/flange M8x40	D-34	Recoil lock
D-4	Set screw M6x12	D-35	Infeed roller
D-9	Set screw M6x10	D-36	Square spacer
D-11	Blade holder	D-37	Pressure spring
D-12	Cutter Blade	D-38	Sprocket A
D-14	Cutter block	D-39	Spacer sprocket
D-15	Deep groove bearing 6205-P5-2Z	D-40	Flat washer 8mm
D-16	Deep groove bearing 6205-P5-2Z	D-41	Lock nut M8
D-17	Lock nut for block	D-42	Flat washer 6mm
D-18	Spindle special Hex nut	D-43	Pressure spring for rollers
D-19	Mount,limit switch	D-44	Lock nut M6
D-20	Limit switch	D-45	Flat washer 6mm
D-21	Sunk head screw M4x35	D-46	Dust port
D-22	Nut hex M4	D-47	Combined vacuum hood
D-23	Screw hex w/flange M8x40	D-48	Rivet
D-24	Nut hex w/flange M8	D-49	Pan head screw M4x16
D-25	Set screw for block M8x20	D-50	Seat,locking shaft
D-26	Bearing house,rear	D-51	locking shaft
D-27	Bearing house,front	D-52	Spring
D-28	Shaft,dust hood	D-53	Nut M6
D-30	Glide piece	D-54	Locking plate
D-31	Collar	D-55	Cross sunk head screw M4x12

**PT-254S SPARE PARTS DIAGRAM E**



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**OPERATION MANUAL**

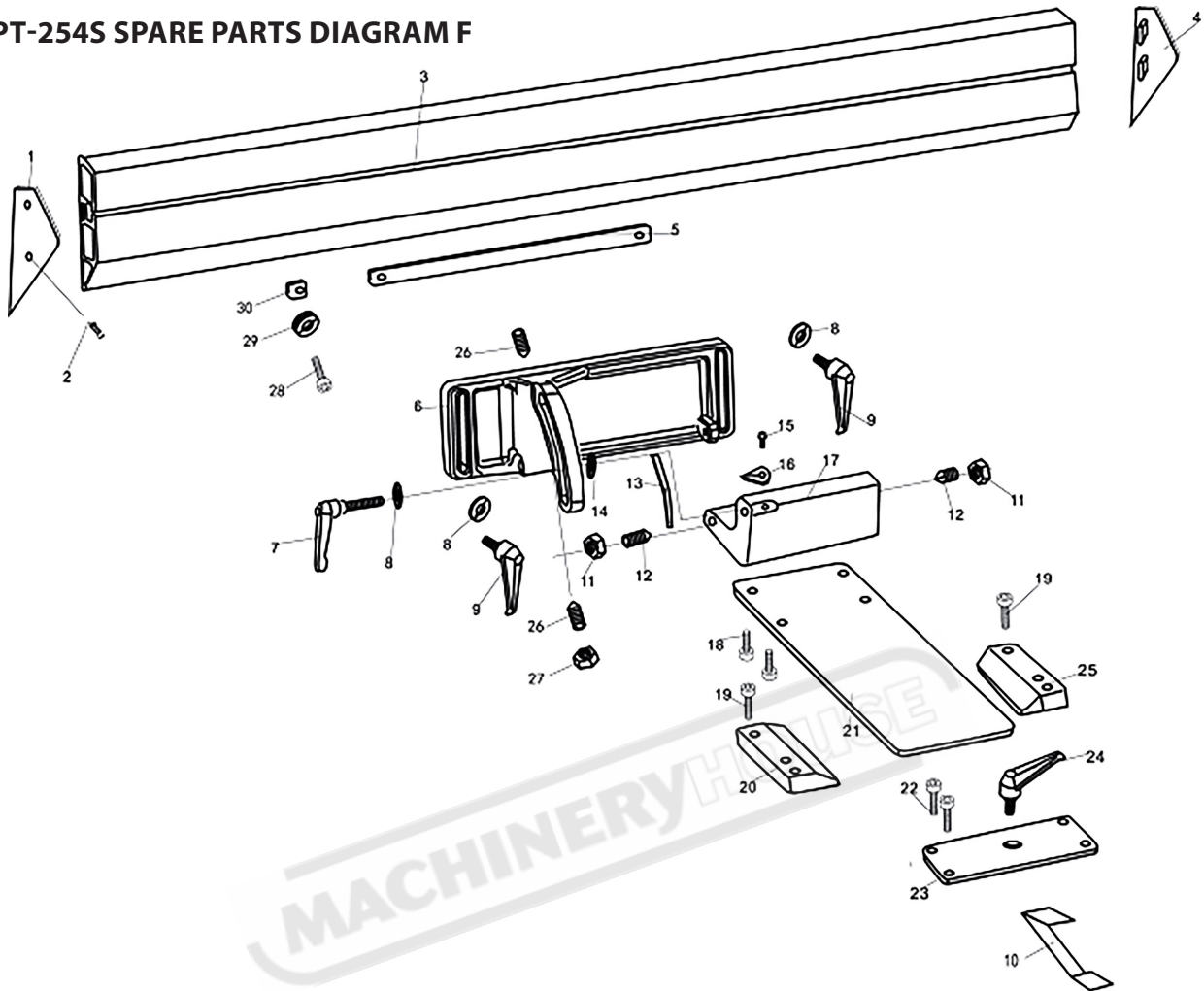

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**PT-254S PARTS LIST. DIAGRAM E**

No.	Description	No.	Description
E-2	Indicator scale	E-19	Set screw M6x6
E-3	Out-feed table	E-20	Clamping lever
E-4	Circle ring 15mm	E-22	Slide piece from table
E-5	Guard,in-feed table	E-23	In-Out feed table shaft
E-6	Guard,out-feed table	E-25	Roll pin 6x35
E-7	Pan head screw M6x12	E-26	External lock washer 10mm
E-8	In-feed table planer	E-27	Wave washer
E-15	Screw	E-30	Nut hex M10
E-16	Bracket	E-32	Allen screw M10x35
E-17	Cap nut M6	E-33	Spring
E-18	Set screw M6x10	E-35	Nut hex M6

MACHINERYHOUSE

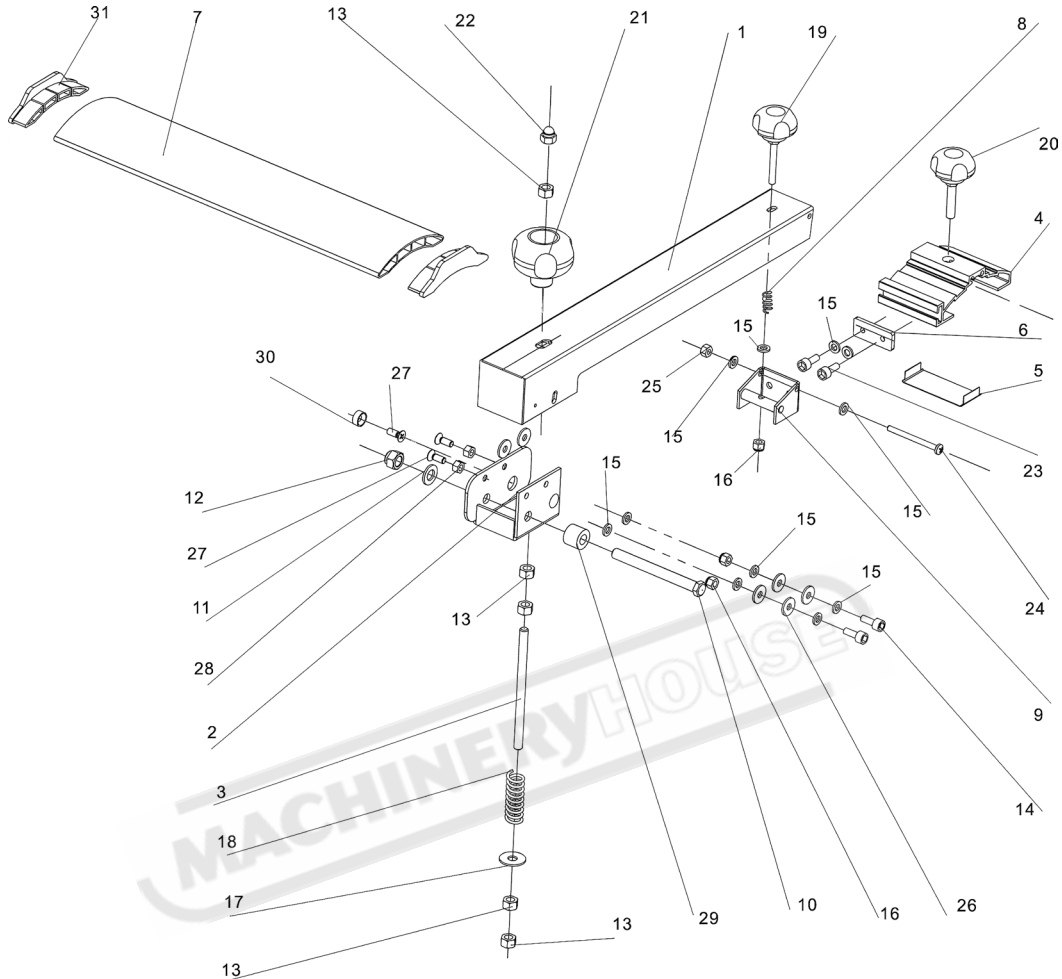
**PT-254S SPARE PARTS DIAGRAM F**



**PT-254S PARTS LIST. DIAGRAM F**

No.	Description	No.	Description
F-1	Left Hand Cover For Fence	F-16	Pointer
F-2	Pan Head Screw	F-17	Fence block
F-3	Rip Fence	F-18	Allen bolt
F-4	Right Hand Cover For Fence	F-19	Allen bolt
F-5	Connection Plate	F-20	Left fixing plate
F-6	Fence Plate	F-21	Sliding plate
F-7	Adjusting Handle	F-22	Allen screw
F-8	Washer	F-23	Clamping plate
F-9	Adjusting Handle	F-24	Adjusting handle
F-10	Insert Board For Fence	F-25	Right fixing plate
F-11	Nut	F-26	Locking screw M6x12
F-12	Set Screw	F-27	Nut M6
F-13	Scale	F-28	Cross sunk head screw M6x12
F-14	Set Screw	F-29	Stop spacer
F-15	Pan Head Screw	F-30	Locking plate

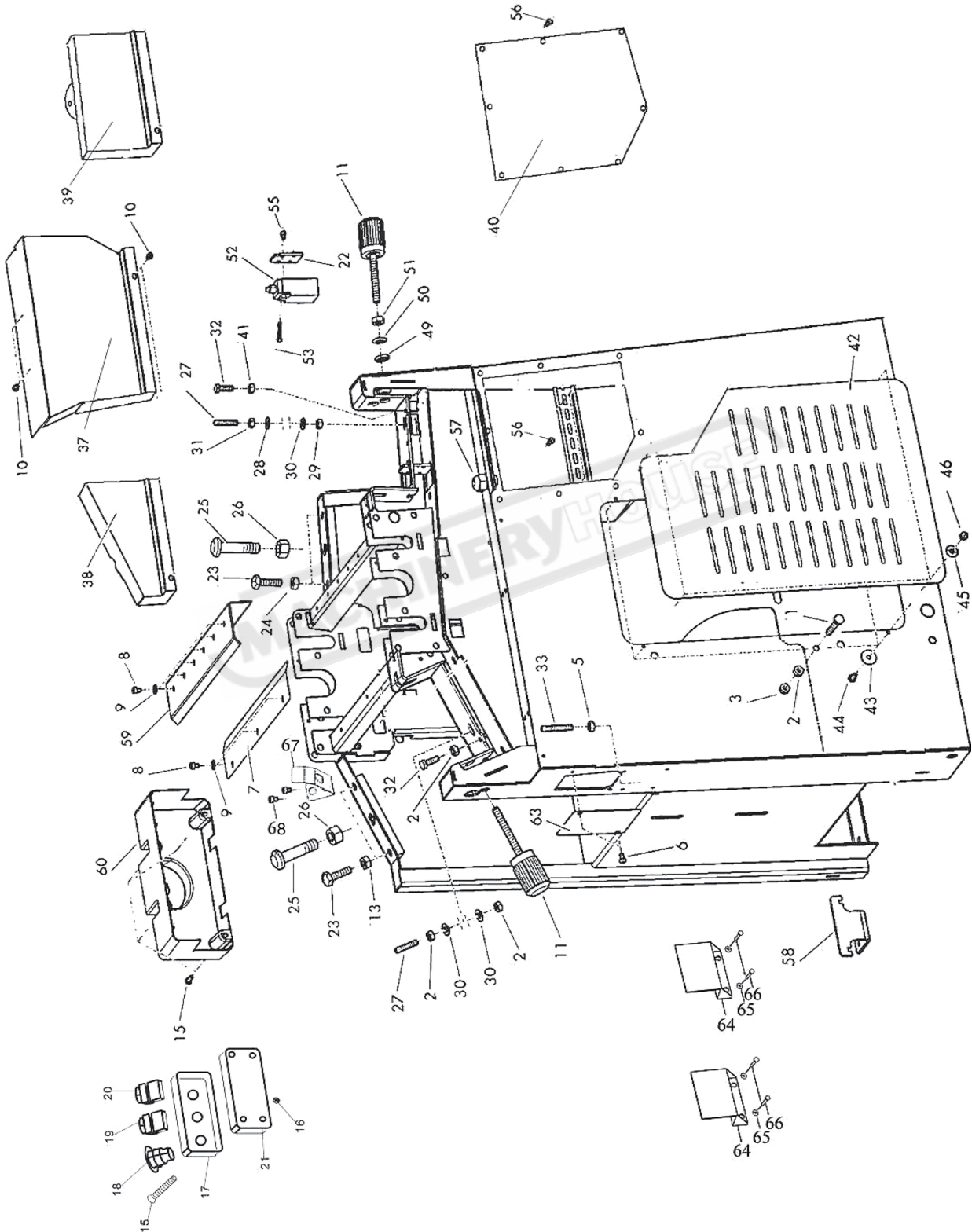
**PT-254S SPARE PARTS DIAGRAM G**



**PT-254S PARTS LIST. DIAGRAM G**

No.	Description	No.	Description
G-1	Bridge guard arm	G-16	Hex lock nut M6
G-2	Swivel base,guard	G-17	Flat washer 8mm
G-3	Rod,spring	G-18	Spring for guard
G-4	Joint,bridge guard	G-19	Star knob screw M6x35
G-5	Insert for guard	G-20	Star knob screw M8x35
G-6	Bolt guide	G-21	Star knob for guard
G-7	Protective guard plate	G-22	Cap nut M8
G-8	Spring	G-23	Allen screw M6x10
G-9	Knot	G-24	Pan head screw M5x65
G-10	Hex head screw M10x100	G-25	Hex lock nut M6
G-11	Washer 10mm	G-26	Spacer
G-12	Hex lock nut M10	G-27	Cross sunk head screw M6x16
G-13	Hex nut M8	G-28	Hex lock nut M6
G-14	Allen screw M6x20	G-29	Spacer
G-15	Washer 6mm	G-30	Spacer
		G-31	End cap guard

**PT-305S SPARE PARTS DIAGRAM A**

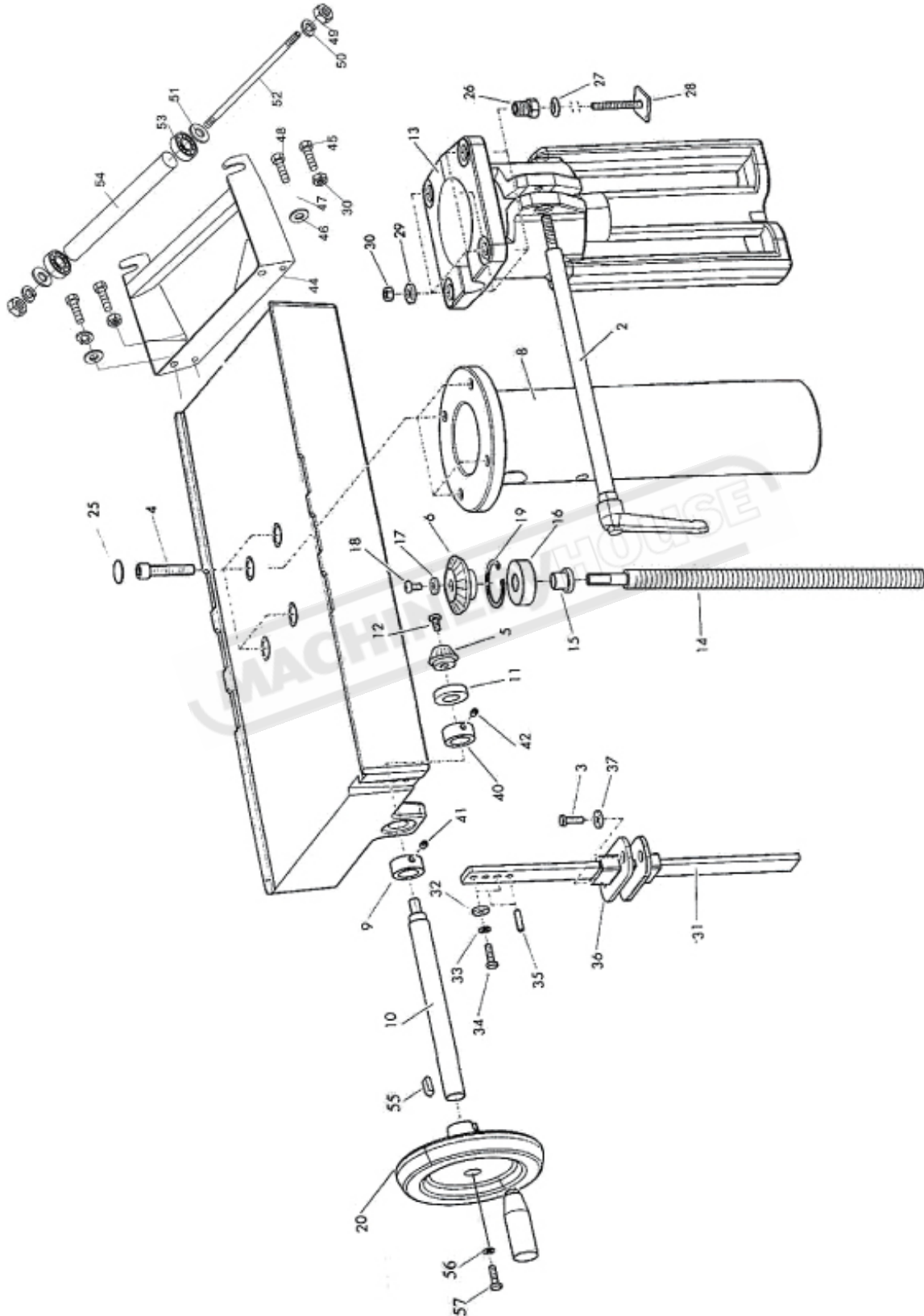


## OPERATION MANUAL

### PT-305S PARTS LIST. DIAGRAM A

No.	Description	No.	Description
A-1	Screw hex head M8x45	A-32	Screw hex head M8x25
A-2	Nut hex M8	A-33	Set screw M8x50
A-3	Nut hex,lock M8	A-37	Guard,belt
A-5	Nut hex M8	A-38	Guard belt,left
A-6	Pan head screw M6x10	A-39	Guard belt,right
A-7	Cover plate,feed roller	A-40	Cover,terminal box
A-8	Allen screw M6x10	A-41	Nut hex M8
A-9	Spring washer 6mm	A-42	Cover plate,friction wheel
A-10	Pan head screw M6x10	A-43	Flat washer 6mm
A-11	Adjust handle, planer table	A-44	Screw hex head M6x12
A-15	Pan head screw M6x30	A-45	Flat washer 6mm
A-16	Nut hex M6	A-46	Cap nut M7
A-17	Cover plate,control panel	A-49	Wave washer
A-18	Emergency-off button	A-50	Wave washer
A-19	Planer-off button	A-51	Nut hex M10
A-20	Planer-on button	A-52	Limit switch
A-21	Control panel	A-54	Pan head screw M4x30
A-22	Connection Plate,Micro Switch	A-55	Allen screw M5x10
A-23	Stop screw,table	A-56	Pan head screw M6x8
A-24	Nut hex M10	A-57	Strain relief
A-25	Lock screw,table	A-58	Transport retainer
A-26	Nut hex M16	A-59	Guard cover,feed roller
A-27	Set screw M8x40	A-60	Plastic Gear cover
A-28	Washer 8mm	A-63	Power Switch
A-29	Nut hex M8	A-64	Fence bracket
A-30	Washer 8mm	A-65	Flat washer
A-31	Nut hex M8	A-66	Pan head screw M8x12
		A-67	Stop spring plate
		A-68	Pan head screw M

**PT-305S SPARE PARTS DIAGRAM B**



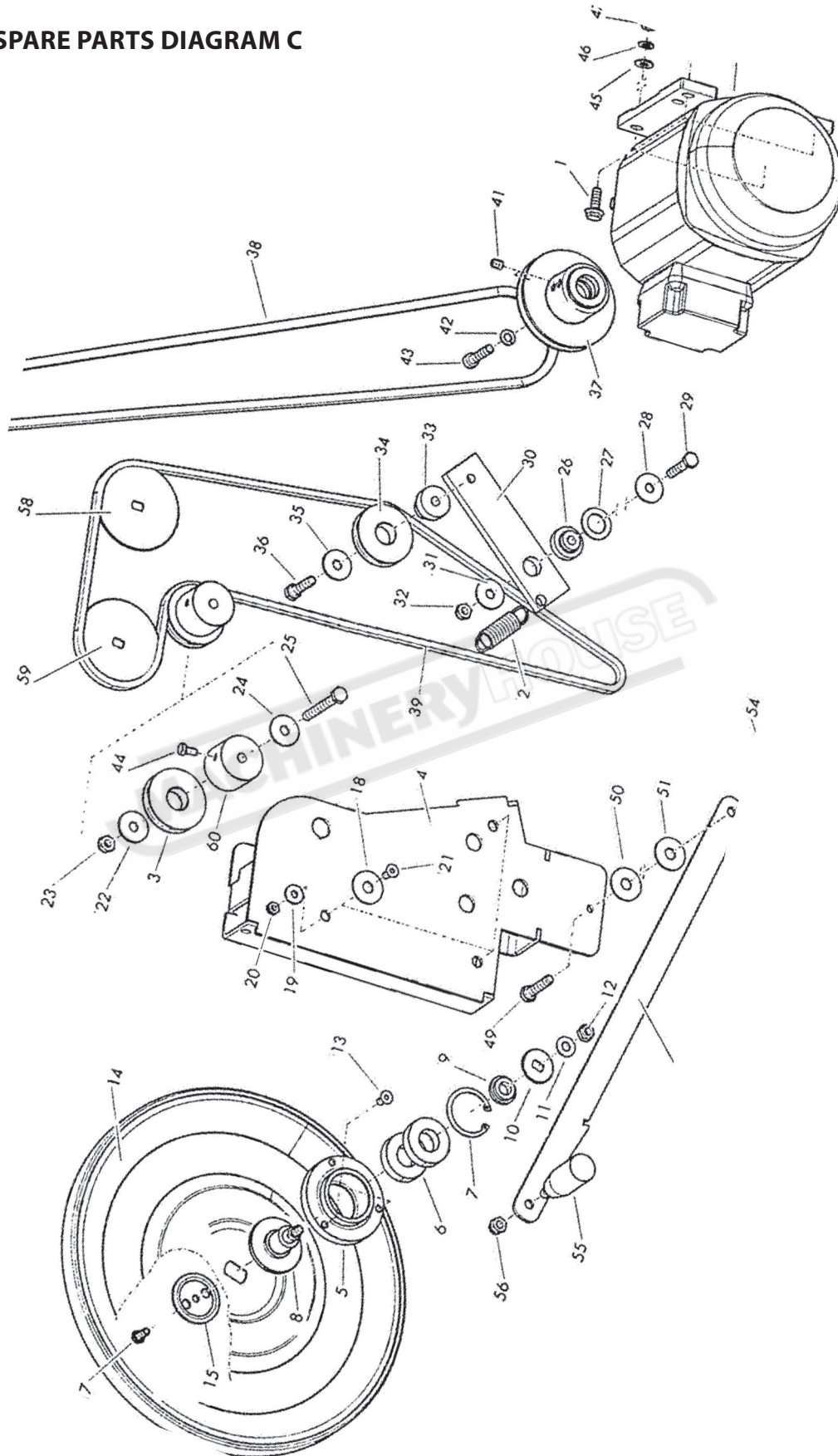


## OPERATION MANUAL

### PT-305S PARTS LIST. DIAGRAM B

No.	Description	No.	Description
B-2	Rise and fall clamp lever	B-30	Nut hex M8
B-3	Screw hex head M6x16	B-31	Scale rule
B-4	Allen screw M10x50	B-32	Washer 6mm
B-5	Cone gear A	B-33	Spring washer 6mm
B-6	Cone gear B	B-34	Screw hex head M6x16
B-8	Raise guide rail	B-35	Roll pin 6x22
B-9	Collar stop	B-36	Scale,body
B-10	Rise and fall shaft	B-37	Flat washer 6mm
B-11	Bearing 6003	B-40	Collar,stop
B-12	Pan head screw M6x12	B-41	Set screw M6x6
B-13	Fixed guide rail	B-42	Set screw M6x6
B-14	Raise and fall guide rod	B-44	Support roller
B-15	Bush for rise and fall guide rod	B-45	Hex head screw M8x25
B-16	Bearing 6303	B-46	Washer 10mm
B-17	Washer 8mm	B-47	Spring washer 10mm
B-18	Pan head screw M6x12	B-48	Hex head screw M10x30
B-19	Ring circle	B-49	Hex nut M10
B-20	Handle-wheel	B-50	Spring washer 10mm
B-25	Insert,table bolt	B-51	Washer 10mm
B-26	Nut adjust	B-52	Threaded rod
B-27	Wave washer	B-53	Bearing 6202
B-28	Special thread	B-54	Roller
B-29	Thin washer	B-55	Key
		B-56	Flat washer 8mm
		B-57	Hex.bolt M6

**PT-305S SPARE PARTS DIAGRAM C**

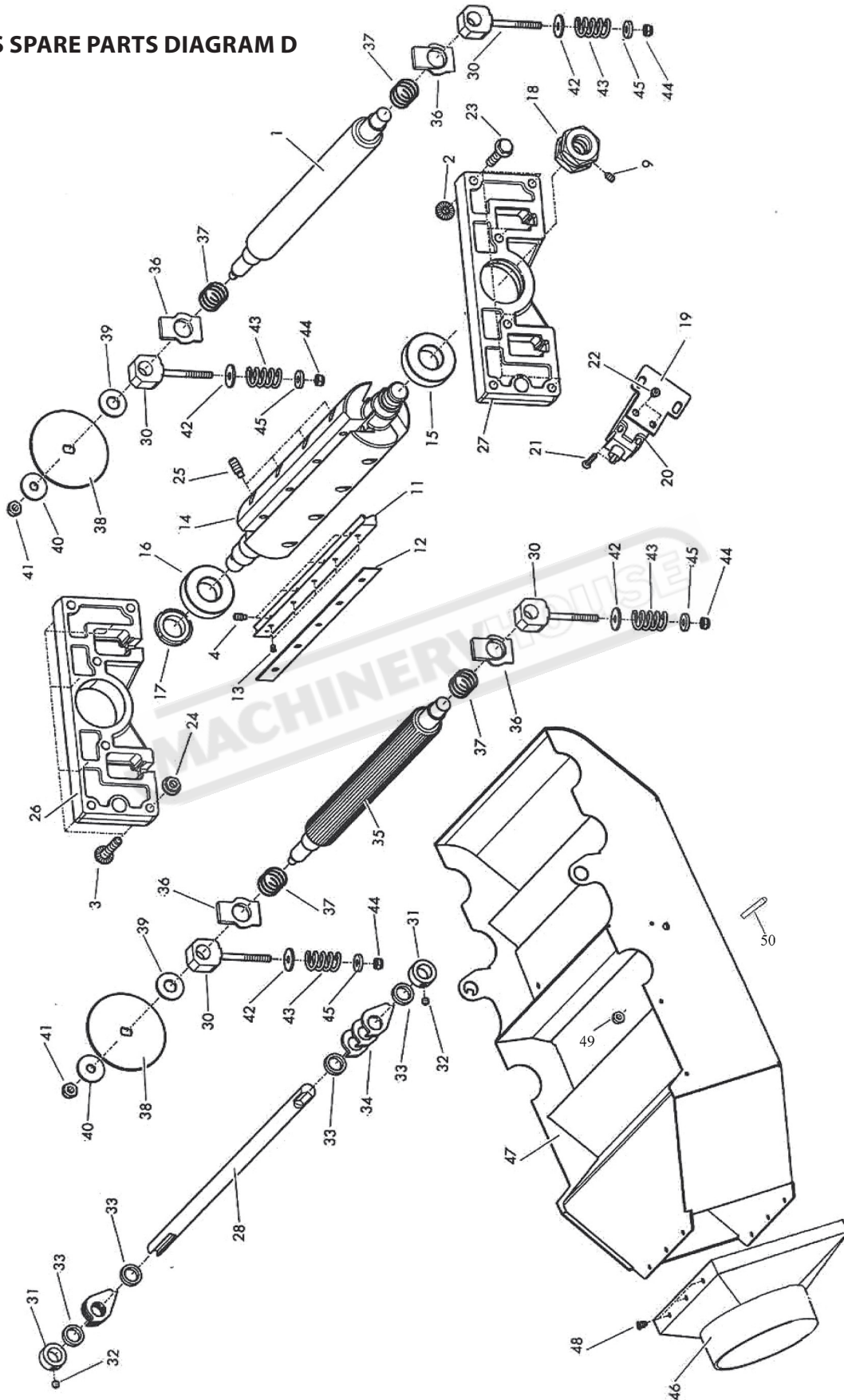


## OPERATION MANUAL

### PT-305S PARTS LIST. DIAGRAM C

No.	Description	No.	Description
C-1	Screw hex w/flange M8x25	C-32	Lock nut M8
C-2	Pull spring	C-33	Spacer
C-3	Tension pulley	C-34	Tension pulley
C-4	Guide,friction pulley	C-35	Flat washer 8mm
C-5	Spacer lock	C-36	Hex head screw M8x45
C-6	Ball bearing 6004-2Z	C-37	Motor pulley
C-7	Circle ring 42mm	C-38	Drive belt XPZ 1340/3Vx530
C-8	Shaft friction pulley	C-39	Drive chain 05B-1-172
C-9	Spacer friction pulley	C-40	Motor
C-10	Sprocket B	C-41	Set screw M8x10
C-11	Flat washer 8mm	C-42	Spring washer 6mm
C-12	Lock nut M8	C-43	Allen screw M8x40
C-13	Sunk head screw M6x16	C-44	Hex head screw M6x16
C-14	Friction pulley	C-45	Special washer 8mm
C-15	Ring	C-46	Spring washer 6mm
C-17	Screw hex head M6x12	C-47	Cap nut M8
C-18	Nylon ring	C-48	Lever,friction pulley
C-19	Washer 6mm	C-49	Hex head screw M8x45
C-20	Lock nut M6	C-50	Plastic washer
C-21	Sunk head screw M6x16	C-51	Plastic washer
C-22	Flat washer 8mm	C-52	Flat washer 8mm
C-23	Lock nut M8	C-53	Lock nut M8
C-24	Flat washer 8mm	C-54	Lock nut M8
C-25	Screw hex head M8x70	C-55	Handle for lever
C-26	Collar	C-56	Cap nut M8
C-27	Plastic washer	C-57	Pull spring
C-28	Flat washer 8mm	C-58	Sprocket A
C-29	Hex head screw M8x45	C-59	Sprocket A
C-30	Tension plate	C-60	Shaft,tension pulley
C-31	Flat washer 8m		

**PT-305S SPARE PARTS DIAGRAM D**

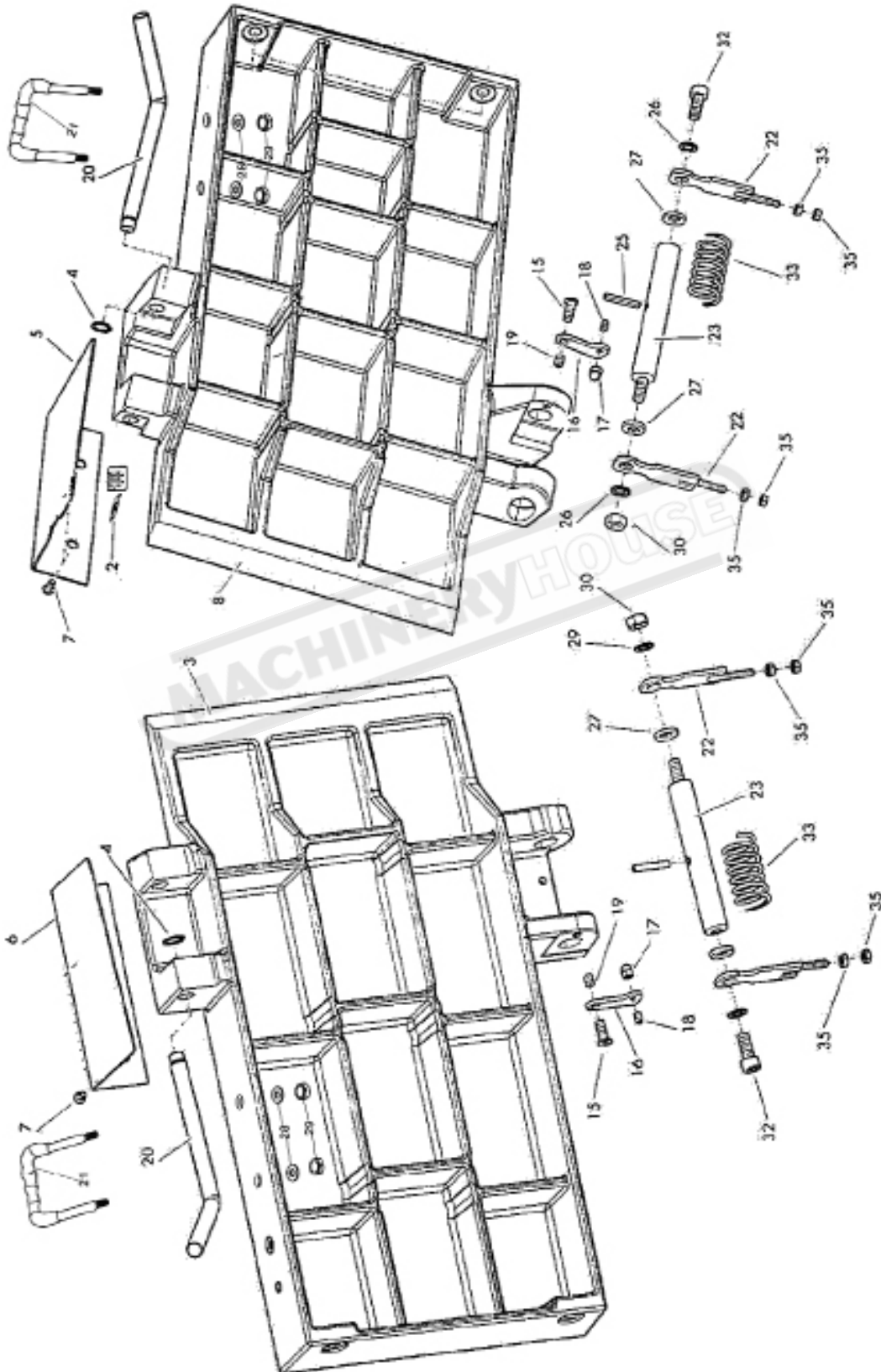


## OPERATION MANUAL

### PT-305S PARTS LIST DIAGRAM D

No.	Description	No.	Description
D-1	Outfeed roller	D-27	Bearing house,front
D-2	Nut hex w/flange M8	D-28	Shaft,dust hood
D-3	Screw hex w/flange M8x40	D-30	Glide piece
D-4	Set screw M6x12	D-31	Collar
D-9	Set screw M6x10	D-32	Set screw M6x6
D-11	Blade holder	D-34	Recoil lock
D-12	Cutter blade	D-35	Infeed roller
D-14	Cutter block	D-36	Square spacer
D-15	Deep groove bearing 6205-P5-2Z	D-37	Pressure spring
D-16	Deep groove bearing 6205-P5-2Z	D-38	Sprocket A
D-17	Lock nut for block	D-39	Spacer sprocket
D-18	Spindle special Hex nut	D-40	Flat washer 8mm
D-19	Mount,limit switch	D-41	Lock nut M8
D-20	Limit switch	D-42	Flat washer 6mm
D-21	Sunk head screw M4x35	D-43	Pressure spring
D-22	Nut hex M4	D-44	Lock nut M6
D-23	Screw hex w/flange M8x40	D-45	Flat washer 6mm
D-24	Nut hex w/flange M8	D-46	Dust port
D-25	Set screw for block M8x20	D-47	Combined vacuum hood
D-26	Bearing house,rear	D-48	Rivet
		D-49	Pan head screw M4x16
		D-50	Locking shaft

**PT-305S SPARE PARTS DIAGRAM E**



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**OPERATION MANUAL**

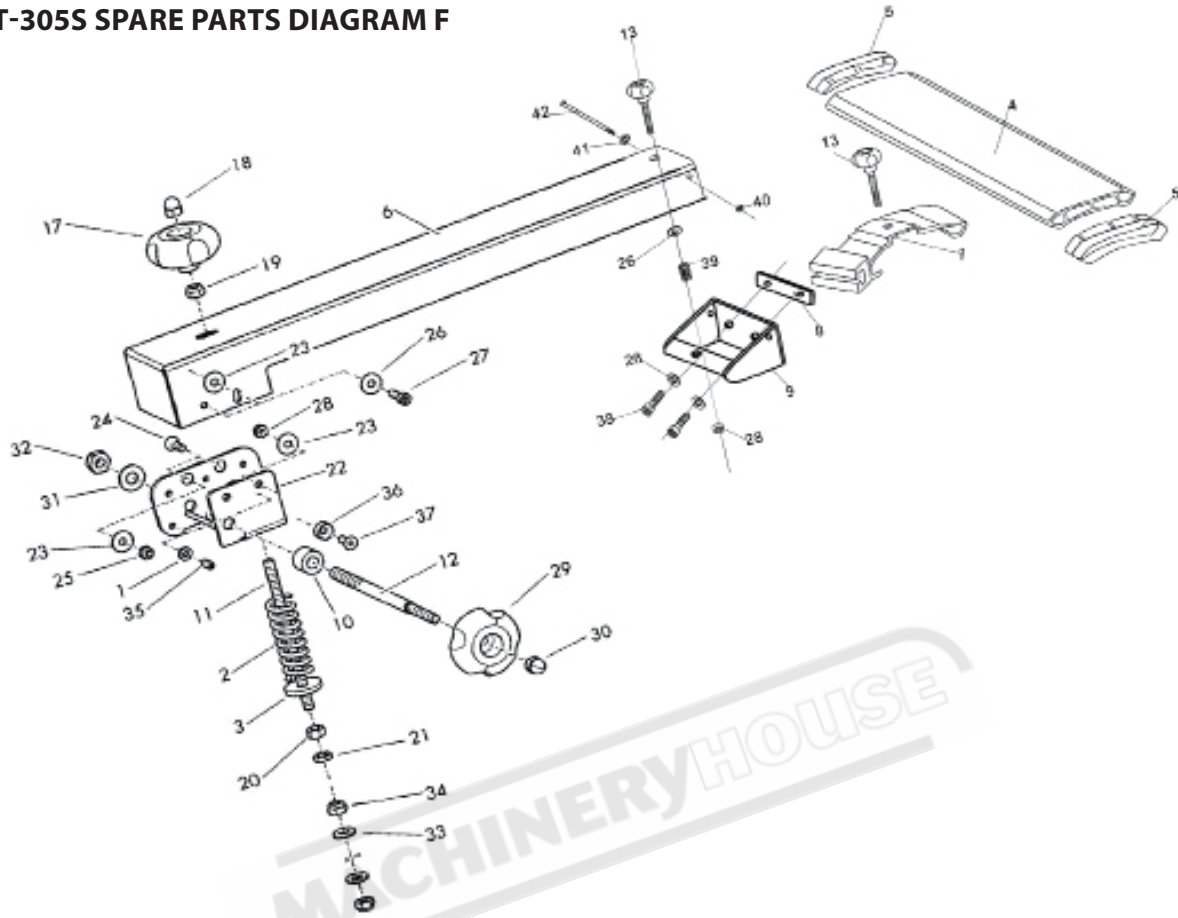

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**PT-305S PARTS LIST DIAGRAM E**

No.	Description	No.	Description
E-2	Indicator scale	E-20	Clamping lever
E-3	Out-feed table	E-21	Table turning handle
E-4	Circle ring 15mm	E-22	Slide piece from table
E-5	Guard,in-feed table	E-23	In-Out feed table shaft
E-6	Guard,out-feed table	E-25	Roll pin 6x35
E-7	Pan head screw M6x12	E-26	External lock washer 10mm
E-8	In-feed table,planer	E-27	Wave washer
E-15	Screw	E-28	Washer 8mm
E-16	Bracket	E-29	Nut hex M8
E-17	Cap nut M6	E-30	Nut hex M10
E-18	Set screw M6x10	E-32	Allen screw M10x35
E-19	Set screw M6x6	E-33	Spring
		E-35	Nut hex M6

MACHINERYHOUSE

**PT-305S SPARE PARTS DIAGRAM F**



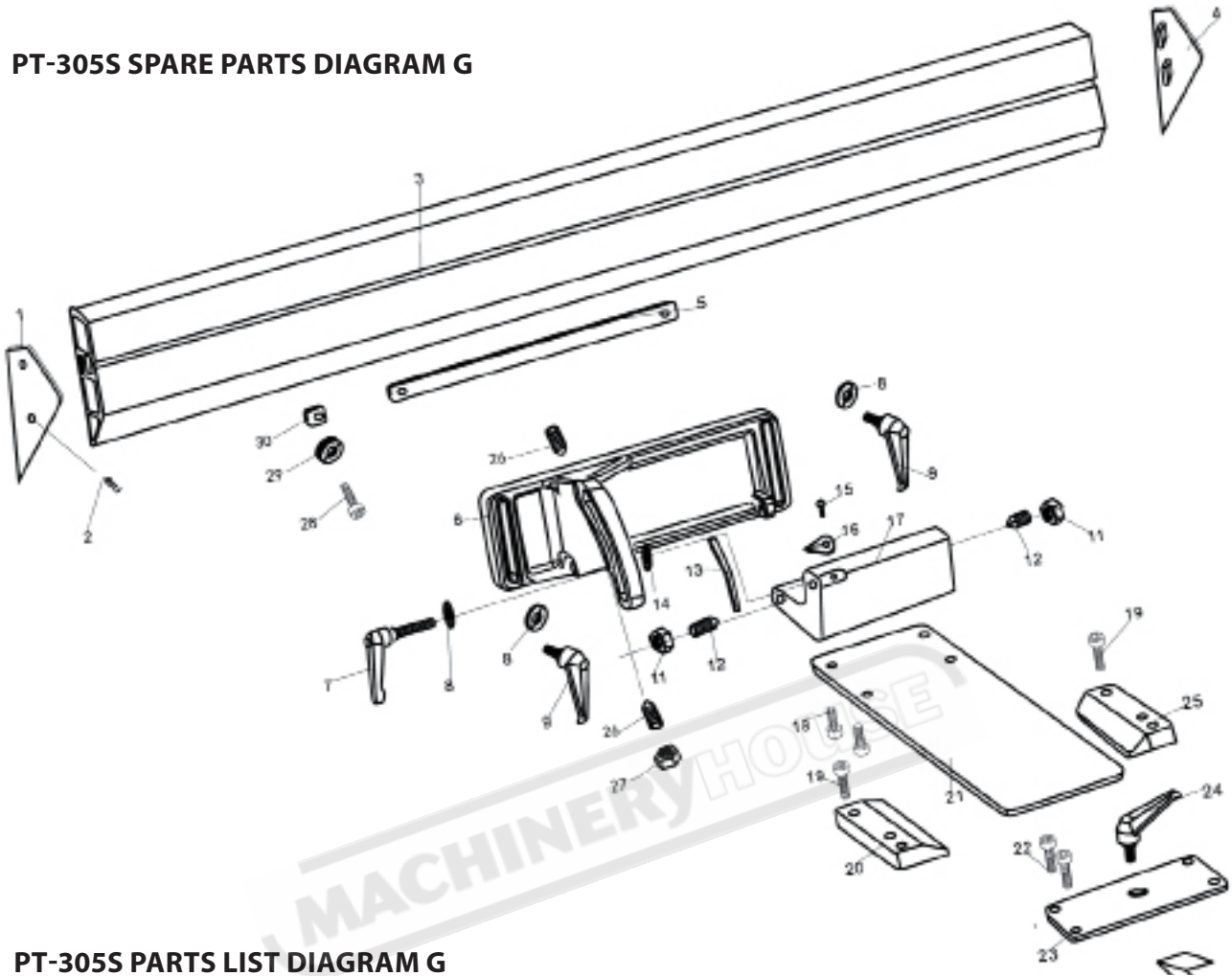
**PT-305S PARTS LIST DIAGRAM F**

No.	Description	No.	Description
F-1	Nut hex M6	F-22	Swivel base
F-2	Spring	F-23	Large washer
F-3	Flat washer	F-24	Sunk head screw M6x16
F-4	Protective guard plate	F-25	Lock nut M6
F-5	End cap protective guard	F-26	Washer 6mm
F-6	Bridge guard arm	F-27	Allen screw M6x20
F-7	Joint,bridge guard	F-28	Lock nut M6
F-8	Blot guide	F-31	Washer 10mm
F-9	Knot	F-32	Lock nut M6
F-10	Spacer	F-33	Washer 8mm
F-11	Screw rod M8x145	F-34	Lock nut M8
F-12	Screw hex head M10x120	F-35	Set screw M6x12
F-13	Star knob for guard	F-36	Spacer,lock
F-17	Star knob for guard	F-37	Sunk head screw M6x16
F-18	Cap nut M8	F-38	Allen screw M6x10
F-19	Nut hex M8	F-39	Spring
F-20	Nut hex M8	F-40	Hex nut M5
F-21	Nut hex M8,thin	F-41	Washer 5mm
		F-42	Pan head screw M5x60



**OPERATION MANUAL**

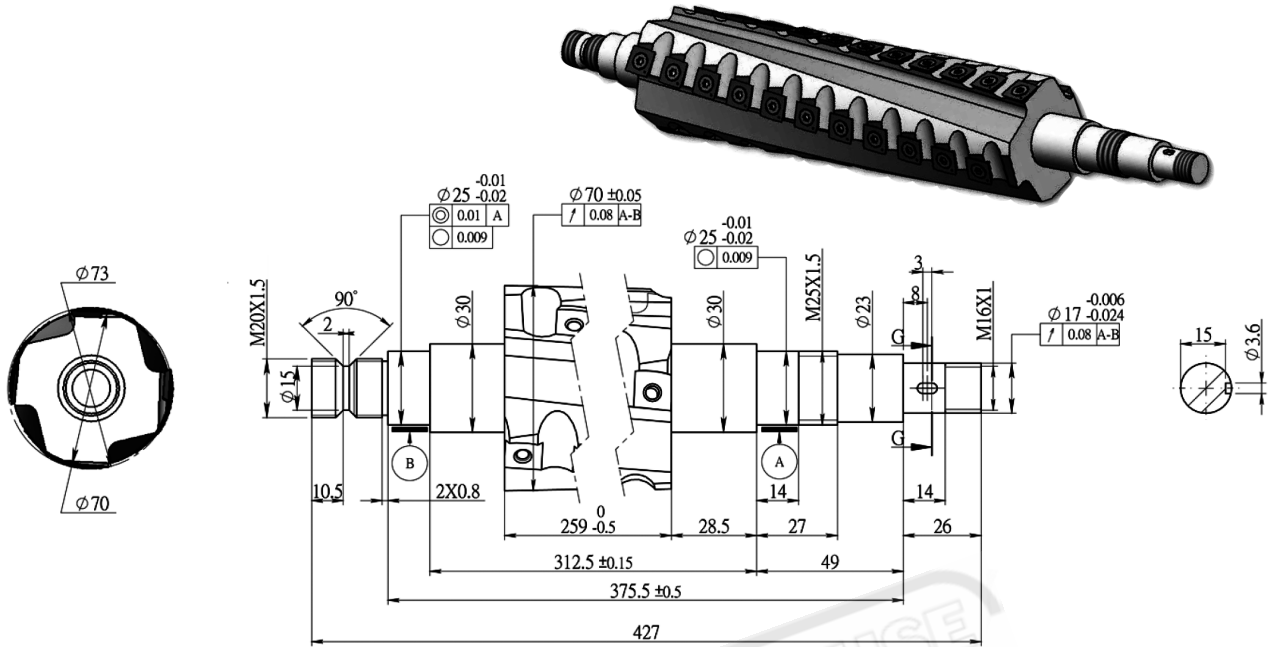
**PT-305S SPARE PARTS DIAGRAM G**



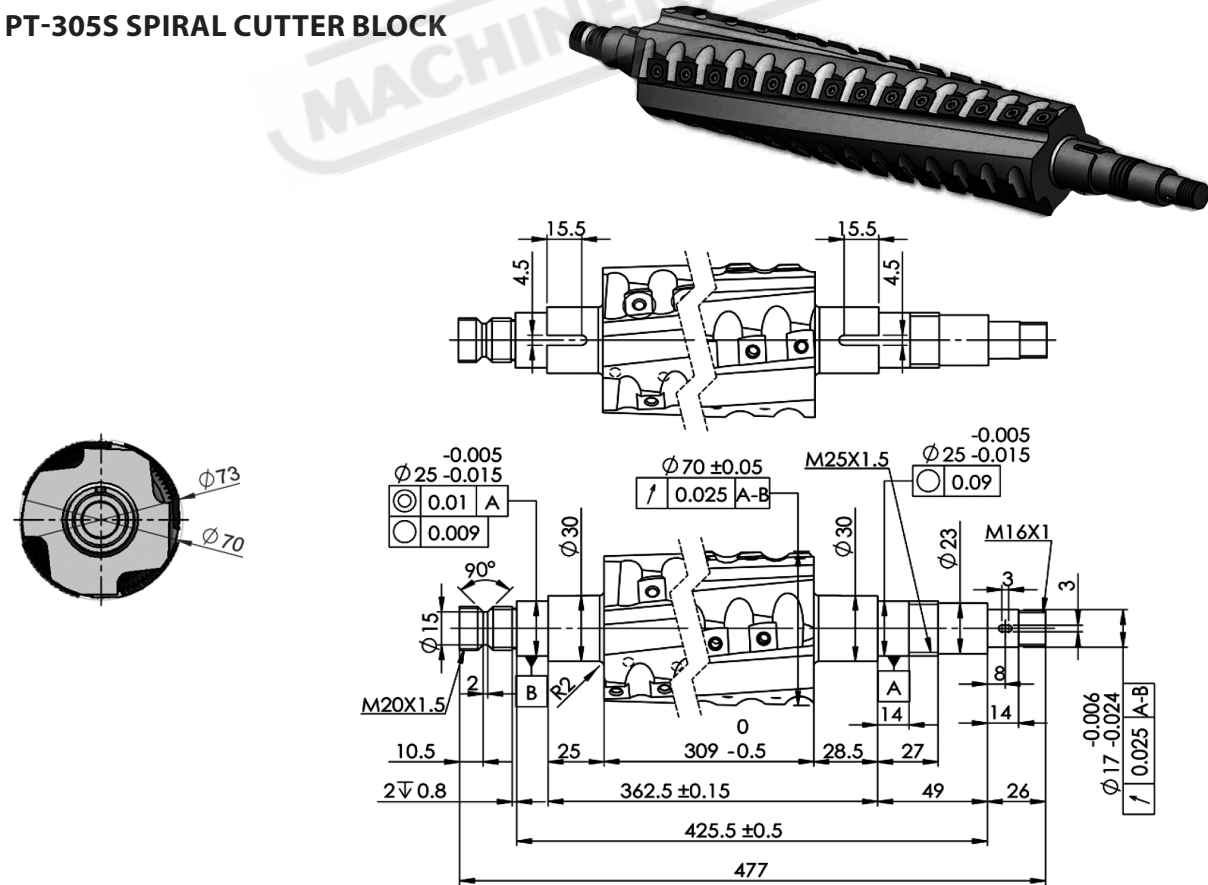
**PT-305S PARTS LIST DIAGRAM G**

No.	Description	No.	Description
G-1	Left hand cover for fence	G-16	Pointer
G-2	Pan head screw	G-17	Fence block
G-3	Rip fence	G-18	Allen bolt
G-4	Right hand cover for fence	G-19	Allen bolt
G-5	Connection plate	G-20	Left fixing plate
G-6	Fence plate	G-21	Sliding plate
G-7	Adjusting handle	G-22	Allen screw
G-8	Washer	G-23	Clamping plate
G-9	Adjusting handle	G-24	Adjusting handle
G-10	Insert board for fence	G-25	Right fixing plate
G-11	Nut	G-26	Locking screw M6x12
G-12	Set screw	G-27	Nut M6
G-13	Scale	G-28	Cross sunk head screw M6x12
G-14	Set screw	G-29	Stop spacer
G-15	Pan head screw	G-30	Locking plate

**PT-254S SPIRAL CUTTER BLOCK**

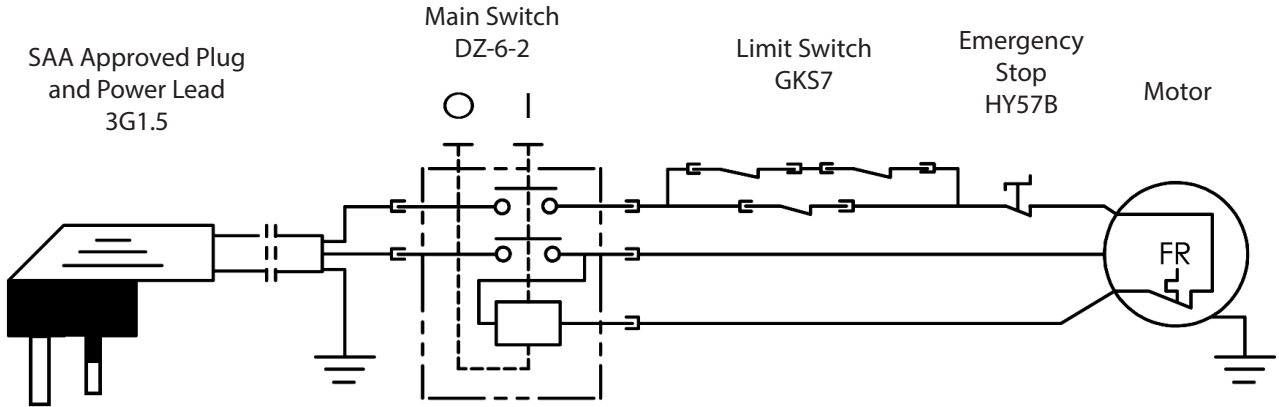


**PT-305S SPIRAL CUTTER BLOCK**

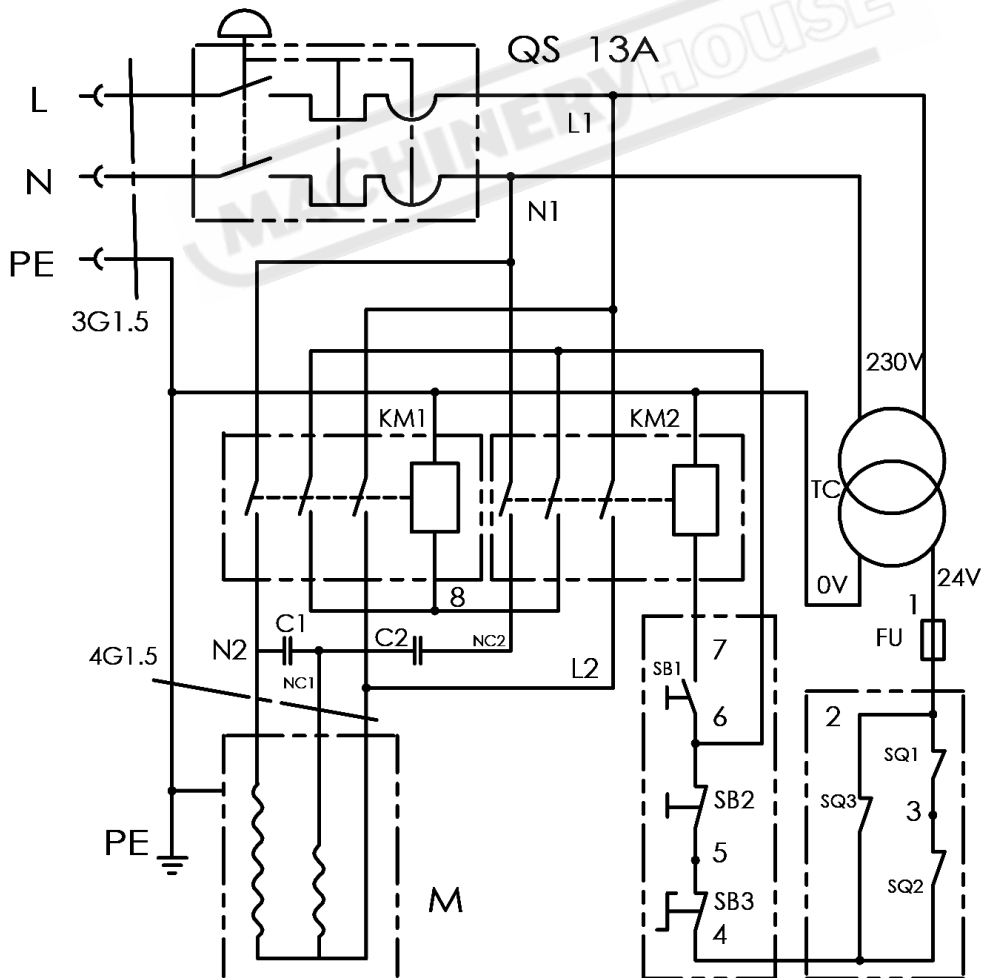


**OPERATION MANUAL**

**PT-254S ELECTRICAL DIAGRAM**



**PT-305S ELECTRICAL DIAGRAM**



**OPERATION MANUAL**


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**PT-305S ELECTRICAL PARTS LIST**

Code	Description	Specification	Qty.
OS	Overload Circuit Breaker	RB6/13A	1
TC	Transformer	BK50 230/24V	1
FU	Fuse	2A	1
SQ01, SQ02, SQ03	Micro Switch	QKS7	3
SB	Start Button	Y090-10S	1
SB2	Stop Button	Y090-01S	1
SB3	Emergency Stop	HY57B	1
KM1, KM2	Contactora	CJX2-1810	2
C1	Running Capacitor	CBB60.40uF.450V	1
C2	Start Capacity	CBB60.150uF.265V	1

MACHINERYHOUSE