

# OPERATION MANUAL

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# DOUBLE-SIDED PLANER

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# WINTER DUOMAX

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## **WARNING!**

*The operator must thoroughly read this manual before operation.  
Keep this manual for future reference.*

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## **3. INSTALLATION**

### **3.1. SAFETY RULES FOR MACHINE LIFTING**

1. Pay special attention to the balance of the machine while lifting.
2. Use a forklift with sufficient loading capacity to lift the machine.
3. Have another person help guide the way when lifting the machine.
4. The forks of forklift must protrude from under the machine underside.
5. **The forklift must only be driven by an experienced forklift driver.**

### **3.2. SELECTION OF LOCATION**

Requirement of operating environment the operating temperature for this machine should be between +5°C and +40°C , while the relative humidity should not exceed 50% at a maximum temperature of +40°C .

### **3.3. LIFTING THE MACHINE**

1. The machine can be lifted by a forklift.
2. Their forks should insert through the slots at the machine bottom.
3. Attention should be paid to the balance of the machine while lifting.
4. The weight of the machine is listed below.

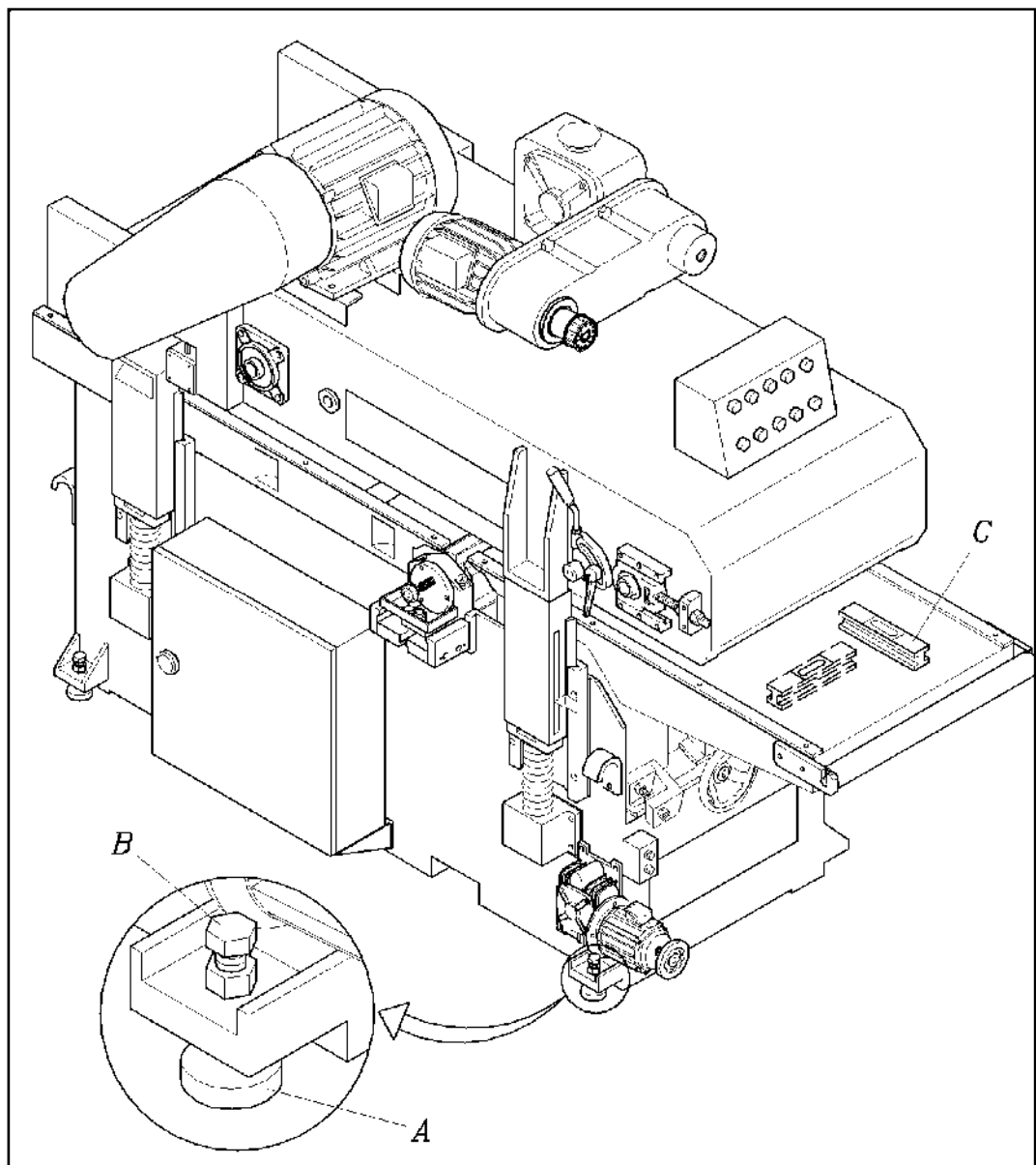
Model	Machine weight	Forklift capacity (tons)
GT-400BRD-CE	1,900Kgs	3 tons
GT-610BRD-CE	2,500Kgs	3 tons

**3.5. INSTALLATION AND LEVELLING**

Install this machine on a solid and level concrete floor. Leave proper space around the machine for handling the materials to be machined. Four steel pads are furnished with the machine, which are to be placed under the levelling screws at the four corners.

After the machine has been located at a proper work site, proper leveling needs to be made. The following steps should be taken:

1. Place the steel pads (A) under the levelling screws (B).
2. Place a precision level gauge (C) on the table at infeed end, outfeed end and middle position.
3. Adjust the leveling screws until proper leveling is obtained.



**3.6. POWER SUPPLY REQUIREMENT**

Insufficient voltage from factory power source may affect the power output of the motor and the function of the controller.

**It is important to connect this machine to the correct voltage in the factory power source. Use only an independent power source.**

Table for power supplies requirement:

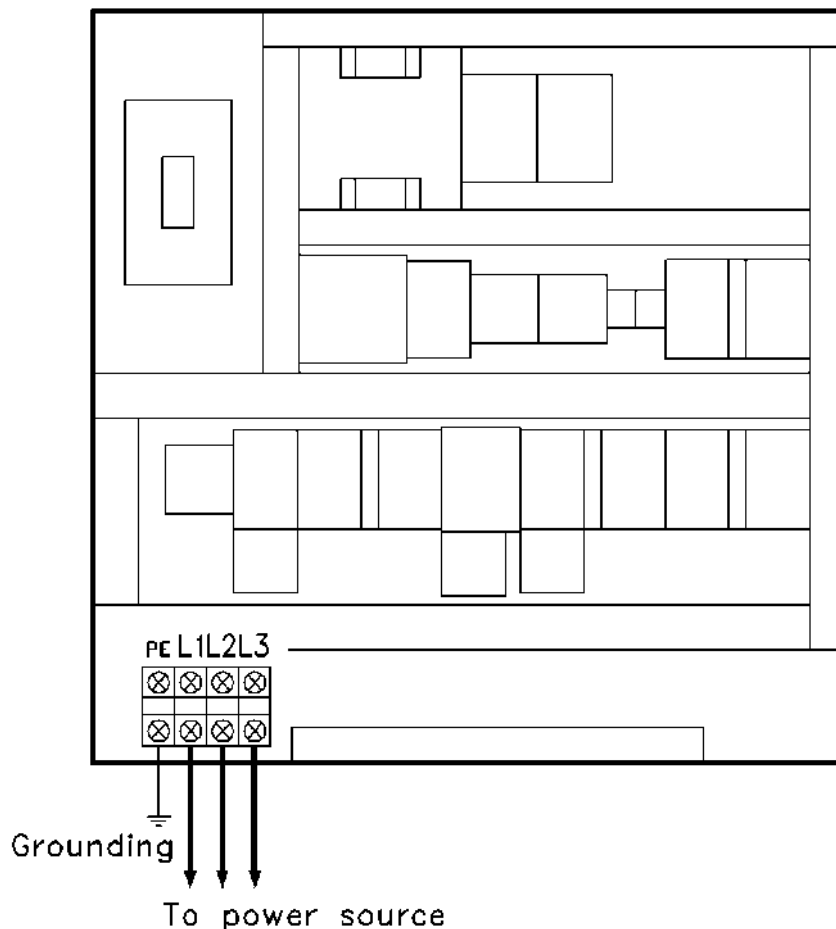
Model	Kw	Voltage	Current	Breaker capacity	Wire size
GT-400BRD-CE	15Kw	220V, 50/60Hz	68 A	100 A	22 mm <sup>2</sup>
GT-400BRD-CE	15Kw	400V, 50Hz	36 A	75 A	14 mm <sup>2</sup>
OPTION	20.5Kw	220V, 50/60Hz	93 A	125 A	22 mm <sup>2</sup>
OPTION	20.5Kw	400V, 50Hz	50 A	100 A	14 mm <sup>2</sup>
GT-610BRD-CE	20.5Kw	400V, 50Hz	50 A	100 A	14 mm <sup>2</sup>
OPTION	28Kw	400V, 50Hz	68 A	125 A	14 mm <sup>2</sup>

**3.7. CONNECT POWER SOURCE WIRES**

1. Before connecting the power wires make sure the voltage between the machine and your factory power source is the same.
2. Connect the power wires to the L1, L2, L3 connection points inside the electrical control box.
3. The machine must be properly grounded to prevent possible injury from electrical shock.
4. For wiring to different voltage, be sure to rewire upper cutterhead motor, lower cutterhead motor, infeed table elevation motor, spike conveyor motor and transformer to the correct voltage. Also, be sure to replace fuses to protect the electrical components. See the current consumption as instructed on model variation chart or contact our distributor.
5. All electrical connections should be performed by qualified electrical personnel.

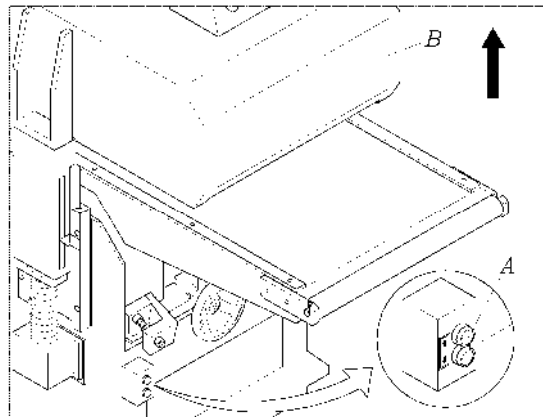
**WARNING**

Grounding should be based on the local regulations.



**3.8. CHECK POWER WIRES CONNECTION**

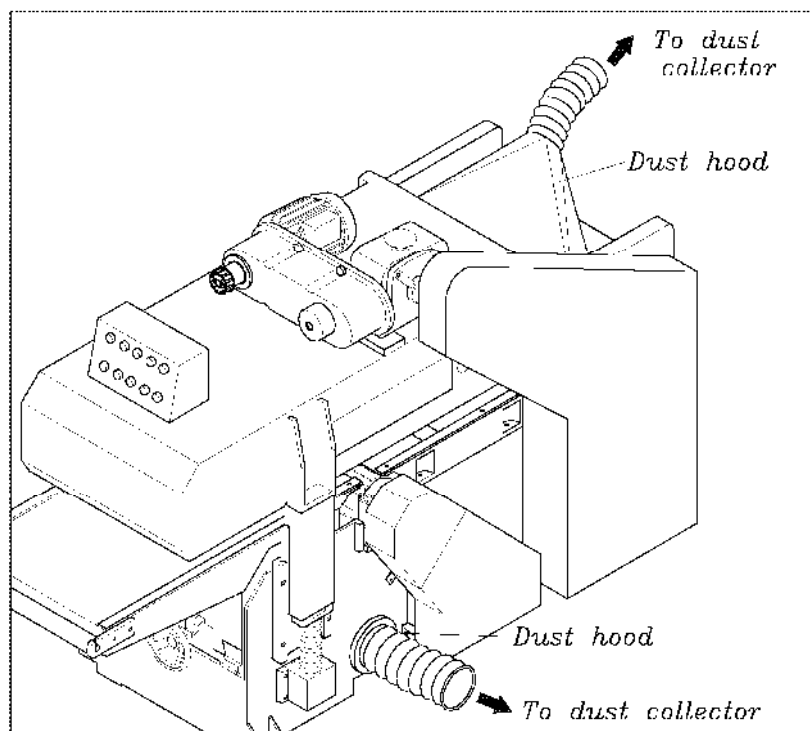
1. After the power wires have been connected it is necessary to check if the power wires are connected to the correct connection points.
2. Press the power switch on the control panel.
3. Press the upper planing table raise switch (A) then the upper planing table (B) should move upward. If not, any two of the three power wires "L1, L2, L3" inside the control box need to be changed.

**3.9. CONNECT DUST COLLECTION SYSTEM**

1. There are two dust hoods provided on the machine for sucking dust from upper and lower cutterhead.
2. Fit the flexible hose to the two dust hoods and connect them to the dust collector.
3. The outlet diameter for each dust hood is 125mm.

 **WARNING**

Do not perform cutting operations until the dust collection system is started.



CA

Upper planning table unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Upper planning table	1	31	Spring	1
2	Motor	1	32	Shaft	1
3	Screw	4	33	Hexagon nut	1
4	Washer	4	34	Shaft	1
5	Hexagon nut	4	35	Roller	1
6	Hexagon nut	2	36	Bearing	2
7	Screw	2	37	Retaining ring	2
8	Bush	1	38	Adjustment piece	2
9	V-belt pulley	1	39	Hexagon nut	2
10	Washer	1	40	Spring	2
11	Spring washer	1	41	Fixing piece	2
12	Screw	1	42	Setscrew	2
13	Washer	4	43	Hexagon nut	2
14	Variable speed unit	1	44	Screw	4
15	Washer	4	45	Spring washer	1
16	Screw	4	46	V-belt guard shaft	1
17	Key	1	47	Hexagon nut	1
18	Chain wheel	1	48	Washer	6
19	Setscrew	2	49	V-belt guard shaft	1
20	Roller chain	1	50	V-belt guard	1
21	Chain joint	1	51	Hexagon nut	2
22	Hexagon nut	1	52	Dust suction hood	1
23	Shaft	1	53	Screw	2
24	Washer	2	54	Plate	2
25	Link	1	55	Spring washer	8
26	Hexagon nut	1	56	Screw	8
27	Chain wheel	1	57	Chain guard	1
28	Bearing	1	58	Washer	4
29	Hexagon nut	1	59	Spring washer	4
30	Screw	1	60	Screw	4

CA

Upper planning table unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
61	Washer	1	91		
62	Screw	1	92		
63	Slide guard (L)	1	93		
64	Slide guard (R)	1	94		
65	Screw	12	95		
66	Infeed safety device	1	96		
67	Screw	4	97		
68	Spring washer	2	98		
69	Screw	2	99		
70	Outfeed safety cover	1	100		
71	Screw	3	101		
72	Outfeed guard	1	102		
73	Plate	1	103		
74	Washer	4	104		
75	Screw	4	105		
76	Guard	1	106		
77	Spring washer	4	107		
78	Screw	4	108		
79			109		
80			110		
81			111		
82			112		
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88			118		
89			119		
90			120		



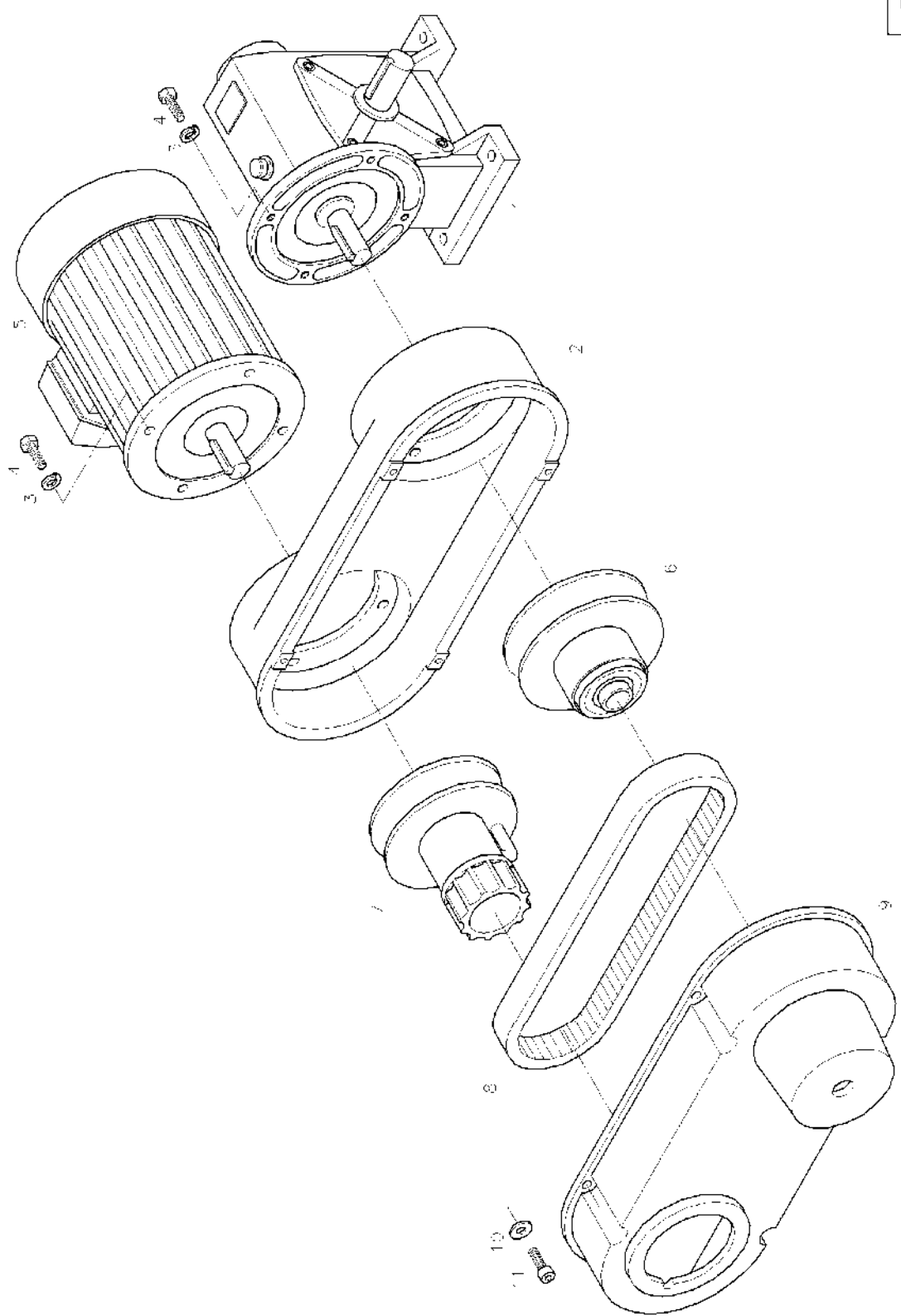


CB

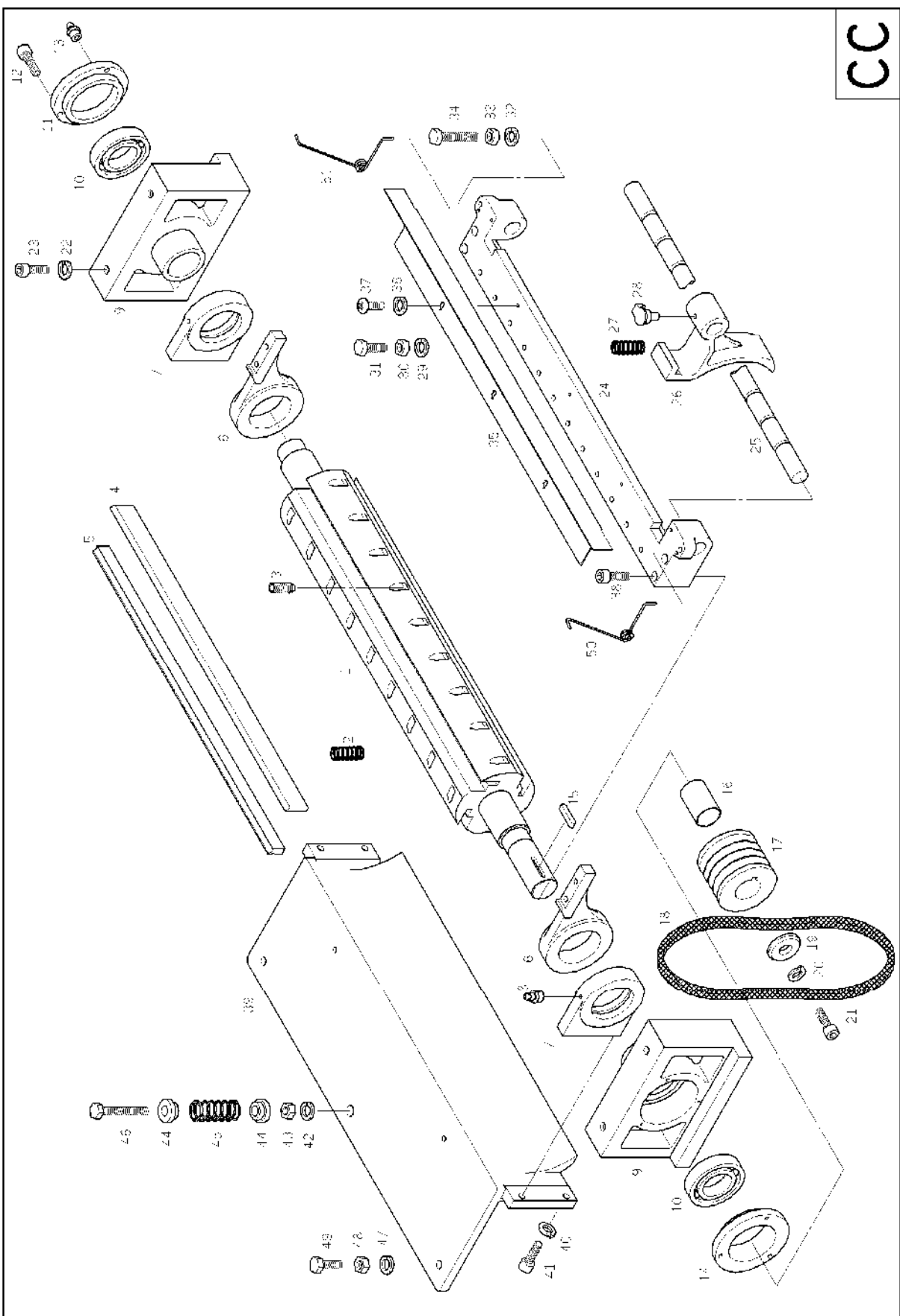
Variable speed unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Worm gear reducer	1	31		
2	Rear cover	1	32		
3	Spring washer	8	33		
4	Screw	8	34		
5	Motor	1	35		
6	Driven pulley	1	36		
7	Drive pulley	1	37		
8	Belt	1	38		
9	Front cover	1	39		
10	Washer	4	40		
11	Screw	4	41		
12			42		
13			43		
14			44		
15			45		
16			46		
17			47		
18			48		
19			49		
20			50		
21			51		
22			52		
23			53		
24			54		
25			55		
26			56		
27			57		
28			58		
29			59		
30			60		



			Upper cutterhead unit			CC	
						2000/12/10	
NO.	Description	Q'ty	NO.	Description	Q'ty		
1	Upper cutterhead	1	31	Screw	15		
2	Spring	8	32	Washer	2		
3	Set screw	40	33	Hexagon nut	2		
4	Knife	4	34	Screw	2		
5	Gib	4	35	Plate guard	1		
6	Pressure plate bracket	2	36	Spring washer	5		
7	Outfeed pressure plate bracket	2	37	Screw	5		
8	Grease nipple	2	38	Screw	4		
9	Bearing housing	2	39	Outfeed plate	1		
10	Bearing	2	40	Spring washer	4		
11	Bearing cap	1	41	Screw	4		
12	Screw	6	42	Spring washer	1		
13	Grease nipple	2	43	Hexagon nut	1		
14	Bearing cap	1	44	Ring	2		
15	Key	1	45	Spring	1		
16	Bush	1	46	Screw	1		
17	Pulley	1	47	Spring washer	2		
18	Belt	1	48	Hexagon nut	2		
19	Fixing piece	1	49	Screw	2		
20	Spring washer	1	50	Spring	1		
21	Screw	1	51	Spring	1		
22	Spring washer	4	52				
23	Screw	4	53				
24	Front pressure plate bracket	1	54				
25	Shaft	1	55				
26	Front bracket trunnion	15	56				
27	Spring	15	57				
28	Oil cap	15	58				
29	Spring washer	15	59				
30	Hexagon nut	15	60				



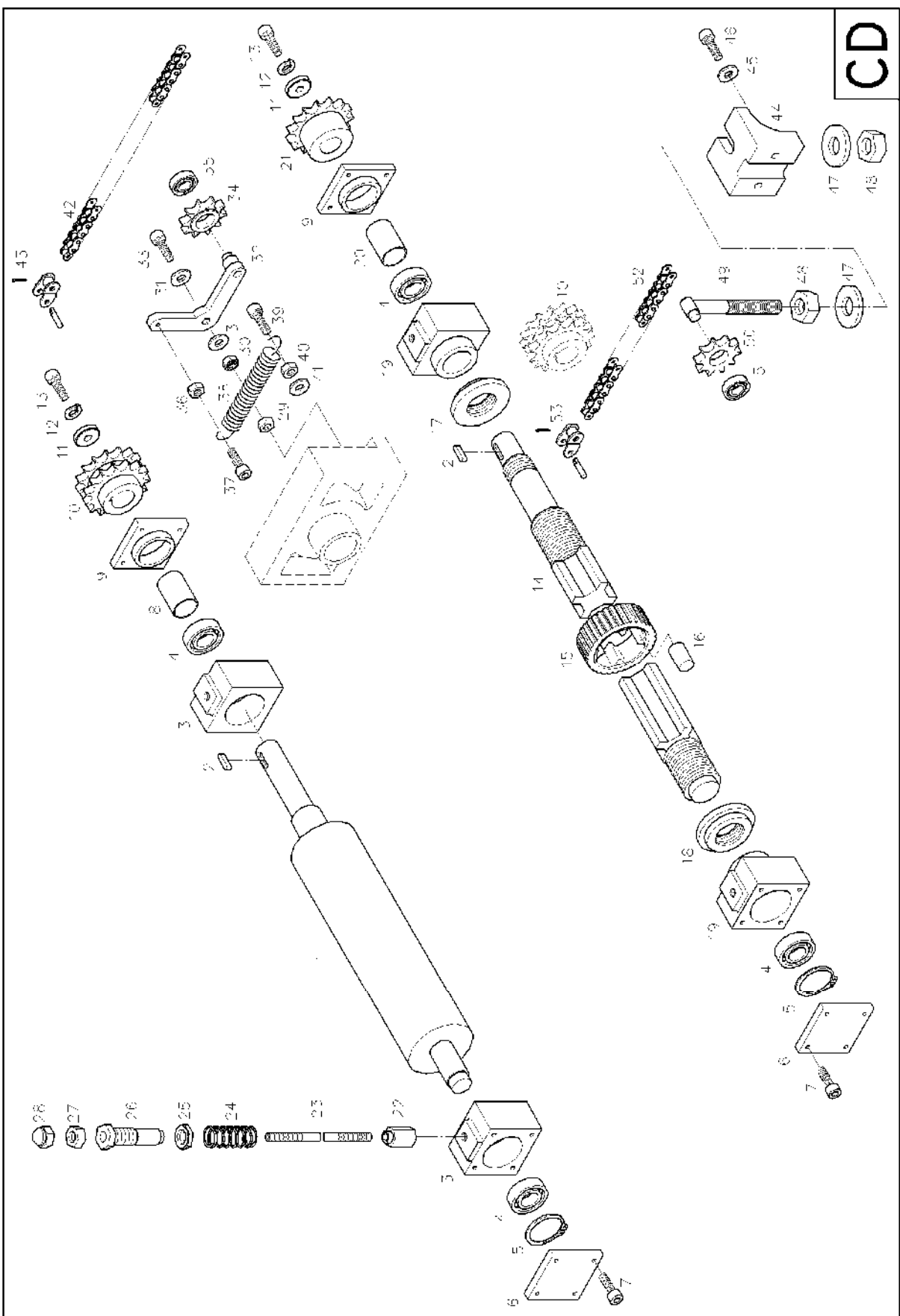
CD

## Pressure roller unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Outfeed roller	1	31	Washer	2
2	Key	2	32	Link	1
3	Bearing housing	2	33	Screw	1
4	Bearing	4	34	Chain wheel	1
5	Retaining ring	2	35	Bearing	1
6	Bearing cover	2	36	Hexagon nut	1
7	Screw	16	37	Screw	1
8	Bush	1	38	Spring	1
9	Bearing cover	2	39	Screw	1
10	Chain wheel	1	40	Hexagon nut	1
11	Washer	2	41	Washer	1
12	Spring washer	2	42	Roller chain	1
13	Screw	2	43	Chain joint	1
14	Corrugated shaft	1	44	Bracket	1
15	Corrugated wheel	24	45	Washer	2
16	Rubber rod	96	46	Screw	2
17	Wheel holder (right)	1	47	Washer	2
18	Wheel holder (left)	1	48	Hexagon nut	2
19	Bearing housing	2	49	Support shaft	1
20	Bush	1	50	Chain wheel	1
21	Chain wheel	1	51	Bearing	1
22	Fix nut	4	52	Roller chain	1
23	Adjustment screw	4	53	Chain joint	1
24	Adjustment spring	4	54		
25	Adjustment nut	4	55		
26	Pressure adjustment screw	4	56		
27	Hexagon nut	4	57		
28	Domed cap nut	4	58		
29	Hexagon nut	1	59		
30	Hexagon nut	1	60		

CD



CE

## Spike conveyor unit

2002/08/03

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Flange bearing	2	31	Bracket	4
2	Spring washer	8	32	Shaft	1
3	Screw	8	33	Shaft	1
4	Spike chain wheel	4	34	Chain wheel	2
5	Drive shaft	1	35	Setscrew	4
6	Kay	5	36	Tension adjustment nut	1
7	Hexagon nut	4	37	Tension adjustment screw	1
8	Screw	4	38	Hexagon nut	1
9	Hexagon nut	4	39	Tension adjustment nut	1
10	Setscrew	4	40	Chain joint	1
11	Retaining ring	1	41	Roller chain	1
12	Torque limiter	1	42	Screw	8
13	Fixing piece	1	43	Plate	4
14	Spring washer	1	44	Screw	8
15	Screw	1	45	Screw	80
16	Adjustment base	1	46	Pin fix plate	40
17	Spring washer	1	47	Bush	80
18	Hexagon nut	1	48	Feed pin	880
19	Adjustment lever	1	49	Spring	880
20	Hexagon nut	1	50	Screw	80
21	Hand knob	1	51	Bush	80
22	Washer	1	52	Pin fix plate	40
23	Adjustable hand lever	1	53	Hexagon nut	80
24	Spacer	1	54	Hexagon nut	80
25	Setscrew	1	55	Driven shaft	1
26	Spike conveyor upper bracket	2	56	Spike conveyor chain	2
27	Spring washer	6	57	Flange bearing	2
28	Screw	6	58	Slideway	4
29	Spike conveyor guide chute	2	59	Screw	12
30	Fix screw	4	60	Fixing block	2

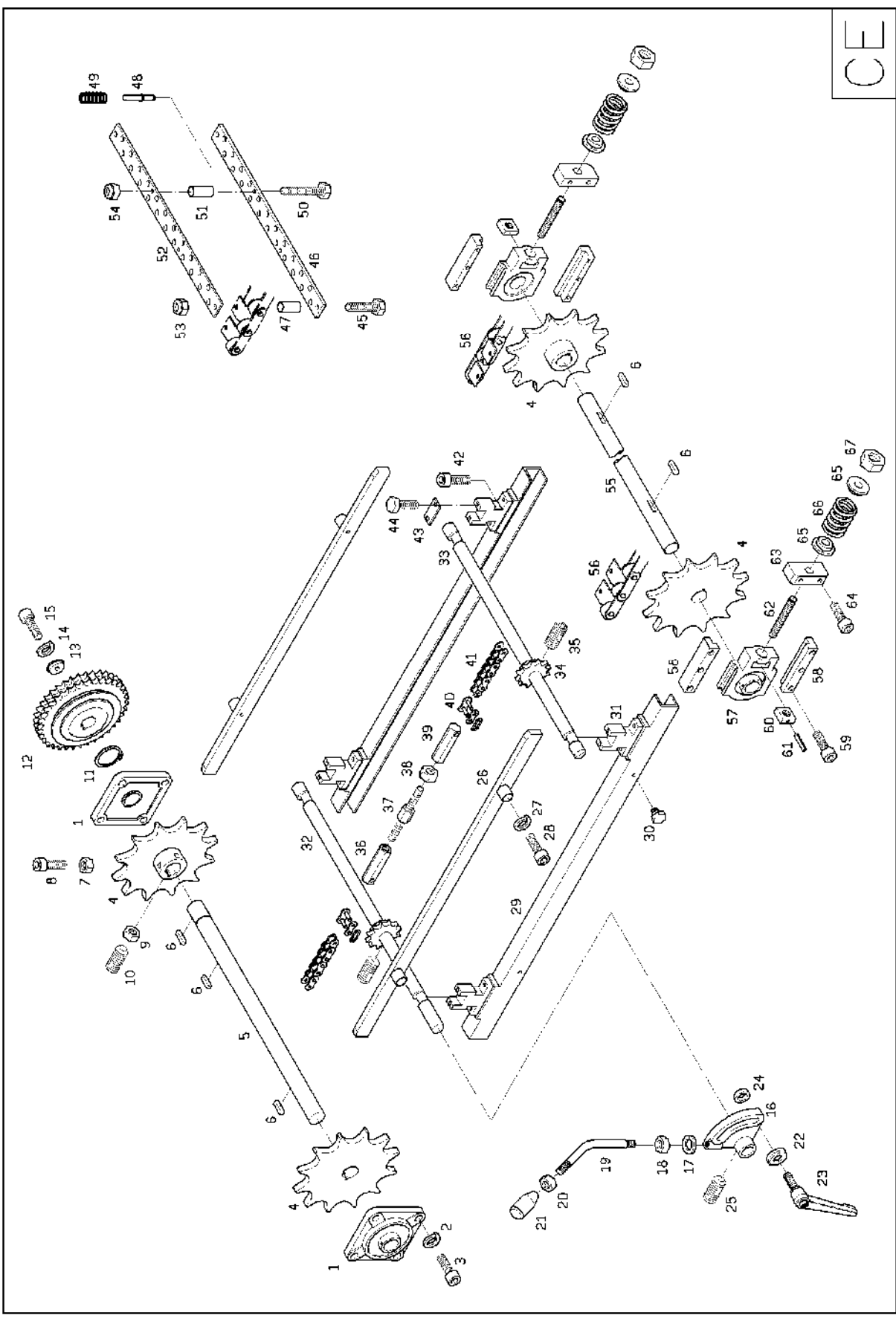


CE

Spike conveyor unit

2002/08/03

NO.	Description	Q'ty	NO.	Description	Q'ty
61	Spring pin	2	91		
62	Screw	2	92		
63	Bracket	2	93		
64	Screw	4	94		
65	Ring	4	95		
66	Spring	2	96		
67	Hexagon nut	2	97		
68			98		
69			99		
70			100		
71			101		
72			102		
73			103		
74			104		
75			105		
76			106		
77			107		
78			108		
79			109		
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81			111		
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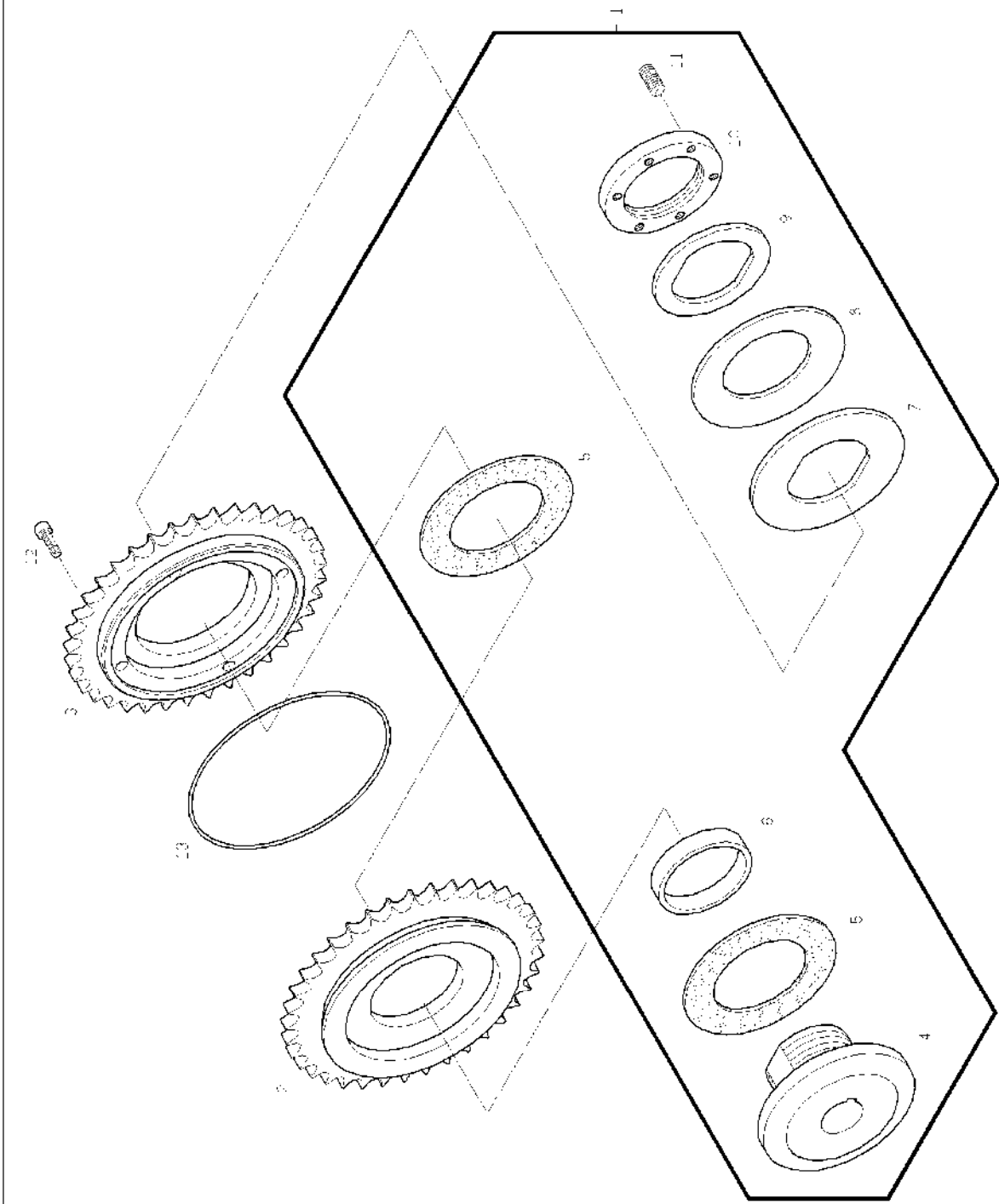


CF

Torque limiter unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Torque limiter	1	31		
2	Chain wheel	1	32		
3	Chain wheel	1	33		
4	Body	1	34		
5	Lining	2	35		
6	Bush	1	36		
7	Friction piece	1	37		
8	Disk spring	1	38		
9	Pressure adjustment piece	1	39		
10	Adjustment nut	1	40		
11	Setscrew	6	41		
12	Screw	4	42		
13	O-ring	1	43		
14			44		
15			45		
16			46		
17			47		
18			48		
19			49		
20			50		
21			51		
22			52		
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27			57		
28			58		
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30			60		

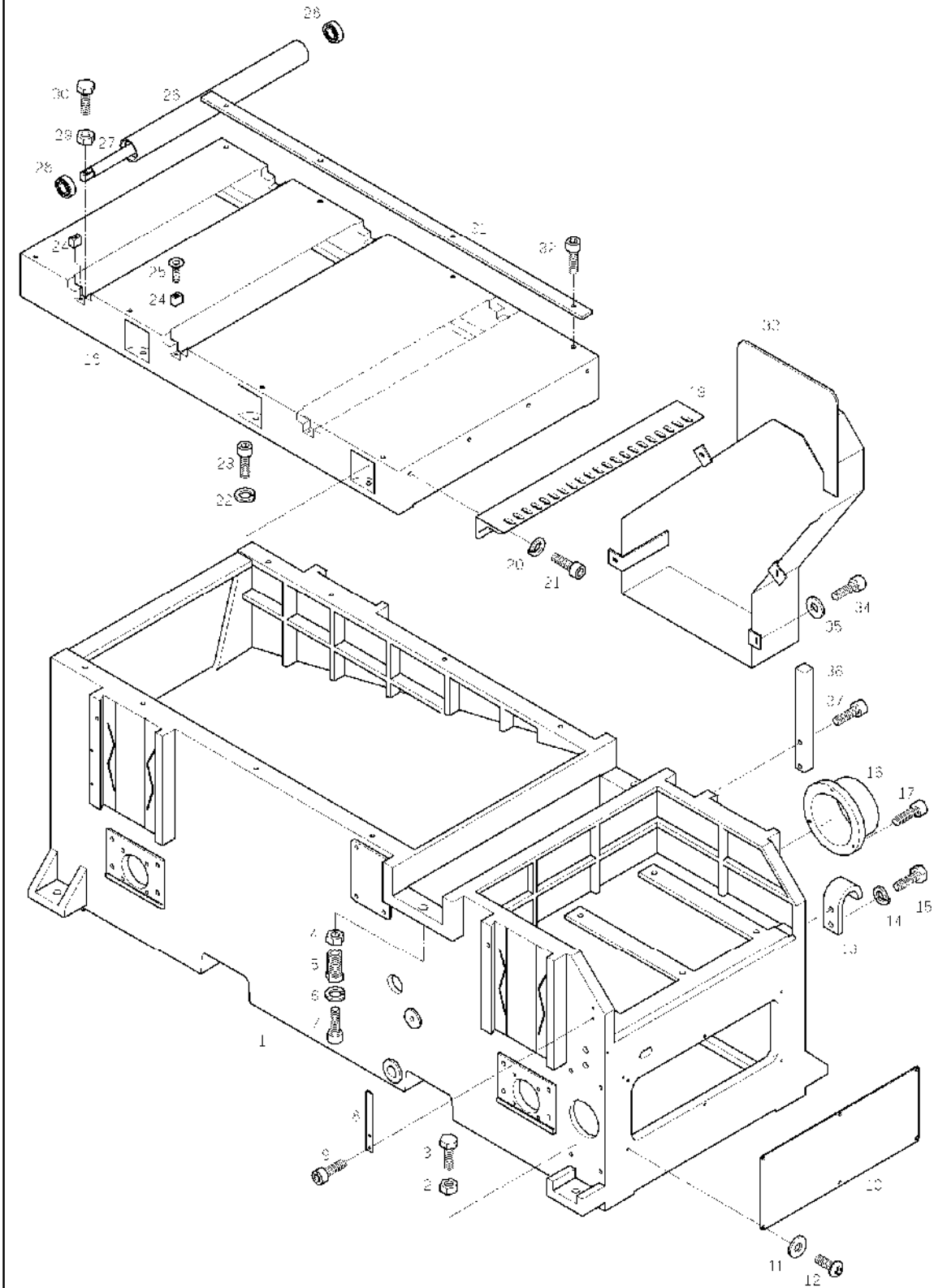


CG

## Machine bad unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Machine bad	1	31	Fence	2
2	Hexagon nut	4	32	Screw	8
3	Adjustment screw	4	33	Belt guard	1
4	Fixing nut	2	34	Screw	4
5	Adjustment screw	2	35	Washer	4
6	Spring washer	2	36	Support rod	1
7	Screw	2	37	Screw	2
8	Graduated scale	1	38		
9	Screw	2	39		
10	Plate	1	40		
11	Washer	6	41		
12	Screw	6	42		
13	Lifting hook	4	43		
14	Spring washer	8	44		
15	Screw	8	45		
16	Dust hood outlet	1	46		
17	Screw	3	47		
18	Rear working table	1	48		
19	Outlet plate	2	49		
20	Spring washer	4	50		
21	Screw	4	51		
22	Spring washer	6	52		
23	Screw	6	53		
24	Fixing pieces	4	54		
25	Screw	4	55		
26	Roller	3	56		
27	Roller shaft	3	57		
28	Bearing	6	58		
29	Hexagon nut	6	59		
30	Screw	6	60		



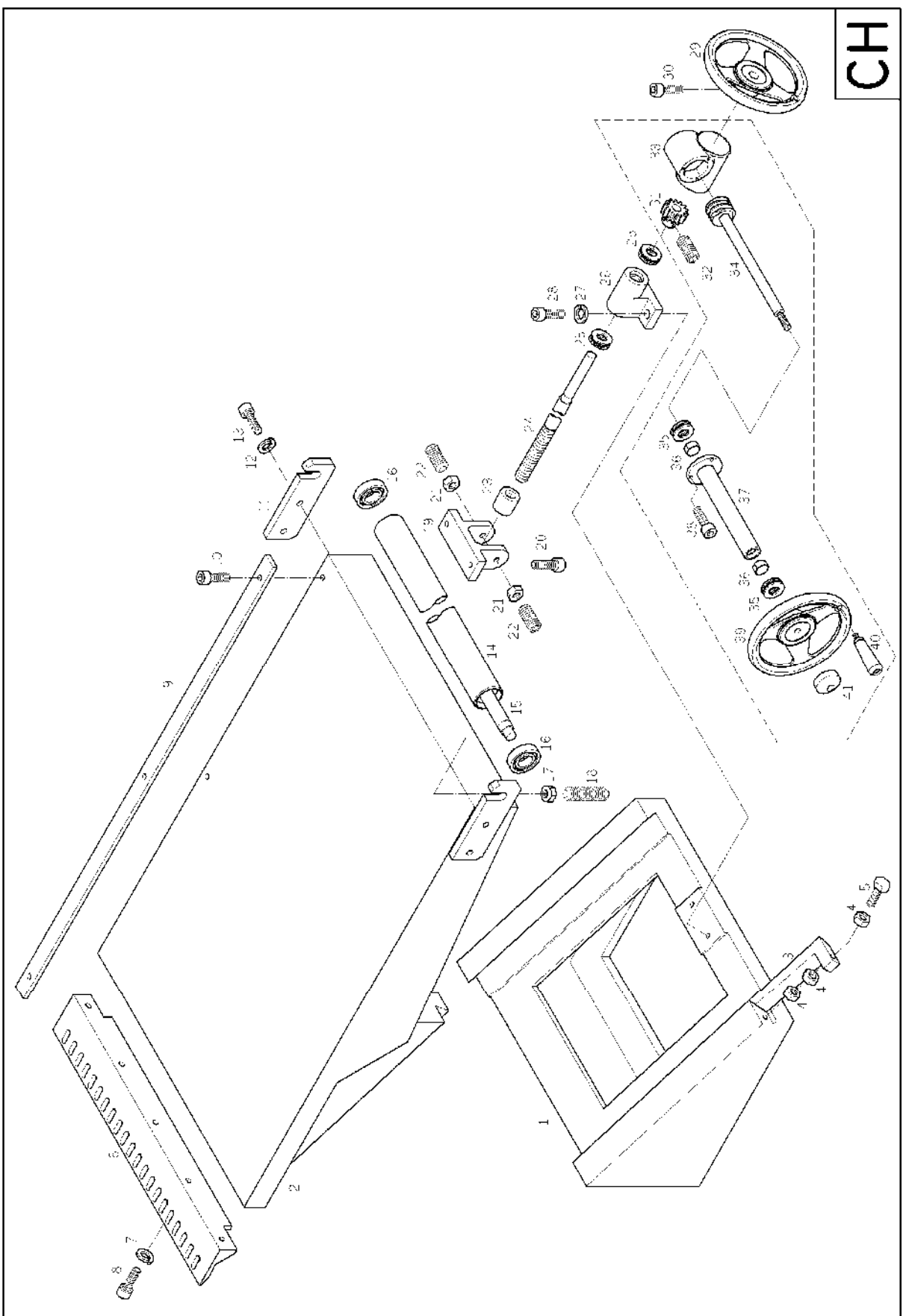
CH

Infeed table unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Table elevation base	1	31	Worm gear	1
2	Infeed table	1	32	Setscrew	2
3	Tapered gib	1	33	Worm box	1
4	Hexagon nut	3	34	Worm	1
5	Screw	1	35	Thrust ball bearing	2
6	Outlet plate	1	36	Du bush	2
7	Spring washer	4	37	Bearing housing	1
8	Screw	4	38	Screw	3
9	Fence	2	39	Hand wheel	1
10	Screw	6	40	Revolving handle	1
11	Roller bracket	2	41	Fixing nut	1
12	Spring washer	4	42		
13	Screw	4	43		
14	Roller	1	44		
15	Shaft	1	45		
16	Bearing	2	46		
17	Hexagon nut	2	47		
18	Screw	2	48		
19	Adjustment nut holder	1	49		
20	Screw	2	50		
21	Hexagon nut	2	51		
22	Setscrew	2	52		
23	Elevation adjustment nut	1	53		
24	Elevation adjustment screw	1	54		
25	Thrust ball bearing	2	55		
26	Bearing housing	1	56		
27	Spring washer	2	57		
28	Screw	2	58		
29	Adjustment hand wheel	1	59		
30	Screw	1	60		

CH



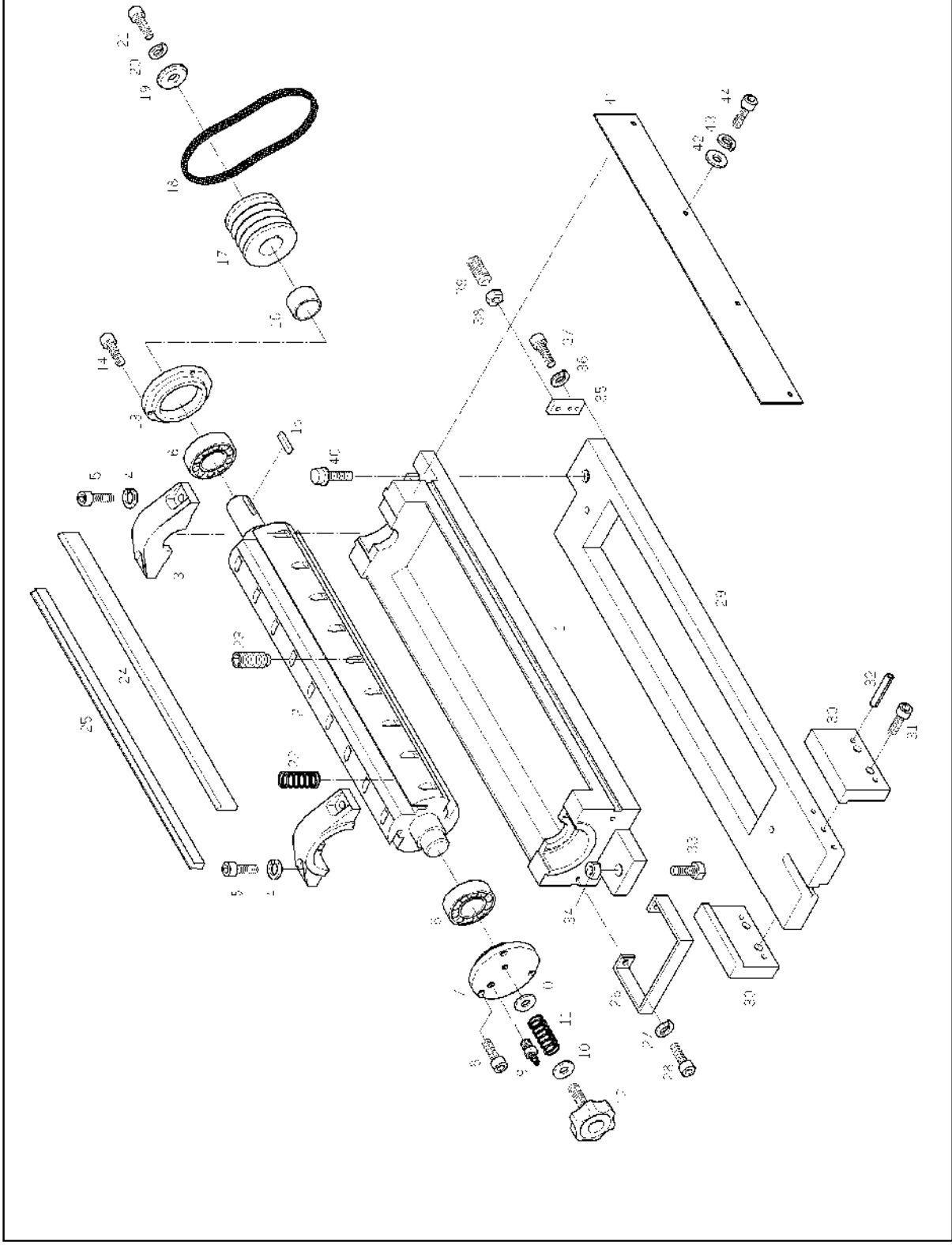


CI

## Lower cutterhead unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Cutterhead holder	1	31	Screw	4
2	Cutterhead	1	32	Spring pin	4
3	Bearing upper housing	2	33	Screw	1
4	Spring washer	4	34	Hexagon nut	1
5	Screw	4	35	Fixing piece	1
6	Bearing	2	36	Spring washer	2
7	Bearing cap	1	37	Screw	2
8	Screw	3	38	Hexagon nut	1
9	Grease nipple	2	39	Setscrew	1
10	Washer	2	40	Fixing screw	1
11	Spring	1	41	Plate	1
12	Knob	1	42	Washer	4
13	Bearing cap	1	43	Spring washer	4
14	Screw	3	44	Screw	4
15	Key	1	45		
16	Bush	1	46		
17	V-belt pulley	1	47		
18	V-belt	1	48		
19	Fixing piece	1	49		
20	Spring washer	1	50		
21	Screw	1	51		
22	Spring	8	52		
23	Setscrew	40	53		
24	Knife	4	54		
25	Gib	4	55		
26	Pulling handle	1	56		
27	Spring washer	2	57		
28	Screw	2	58		
29	Lower plate	1	59		
30	Guide	2	60		



CJ

Elevation unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Elevation block	4	31	Chain wheel	1
2	Thickness indication pointer	1	32	Pin	4
3	Washer	1	33	Setscrew	4
4	Screw	1	34	Washer	16
5	Graduation scale	1	35	Screw	16
6	Gib	4	36	Elevation motor	1
7	Washer	16	37	Chain wheel	1
8	Hexagon nut	32	38	Setscrew	1
9	Setscrew	16	39	Roller chain	1
10	Spring washer	8	40	Chain joint	1
11	Screw	8	41	Sensor ring	1
12	Elevation nut (L)	2	42	Setscrew	2
13	Fixing block	4	43	Bracket	1
14	Spring washer	8	44	Sensor	2
15	Screw	8	45	Washer	1
16	Dust guard bellow	4	46	Screw	1
17	Elevation screw (L)	2	47	Guard	1
18	Key	4	48	Touch bracket	1
19	Spacer	4	49	Screw	1
20	Thrust bearing	8	50	Limiter fixing plate	1
21	Elevation bracket	4	51	Limiter fixing plate	1
22	Bevel gear	4	52	Screw	4
23	Washer	4	53	Tension adjustment base	1
24	Spring washer	4	54	Setscrew	2
25	Hexagon nut	4	55	Washer	1
26	Spring pin	4	56	Spring washer	1
27	Bevel gear	4	57	Screw	1
28	Flange bearing	4	58	Support base	1
29	Chain wheel	1	59	Bearing	1
30	Shaft	2	60	Chain wheel	1

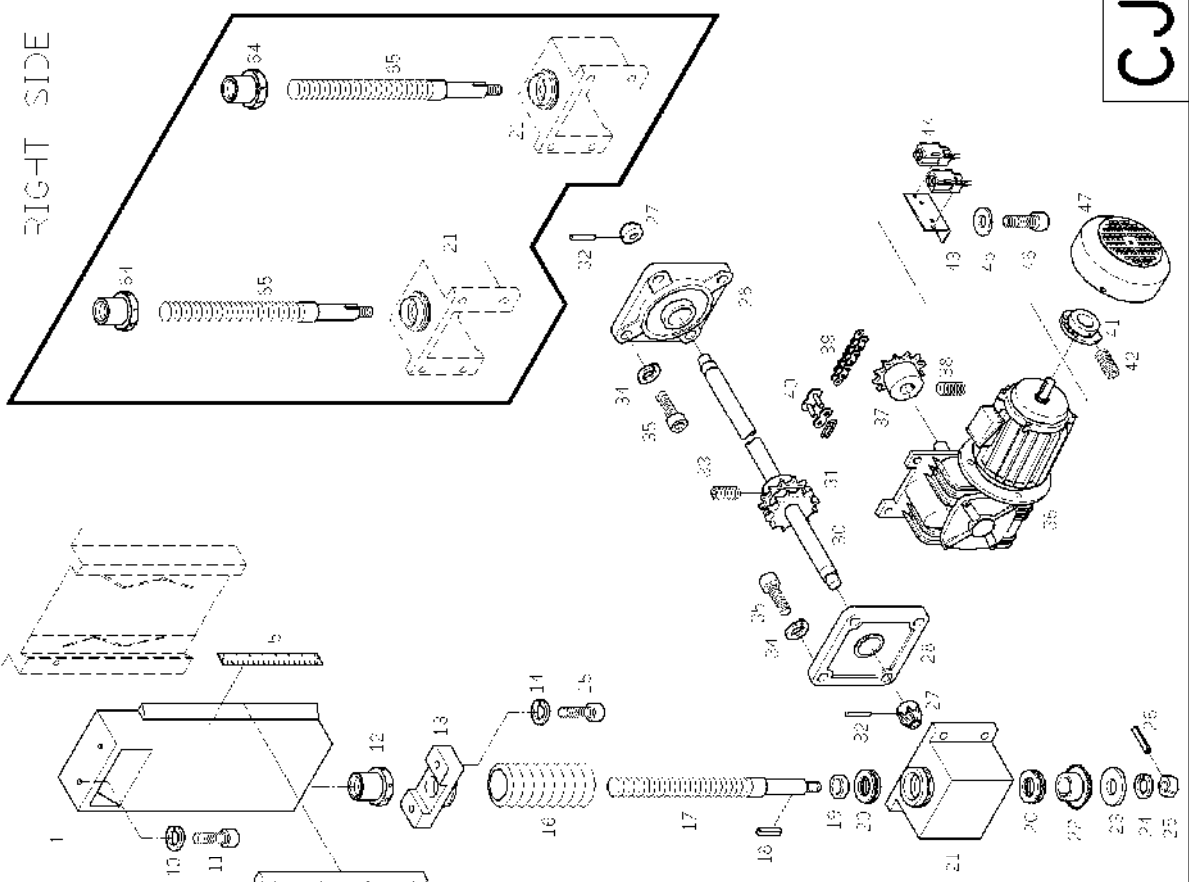
CJ

Elevation unit

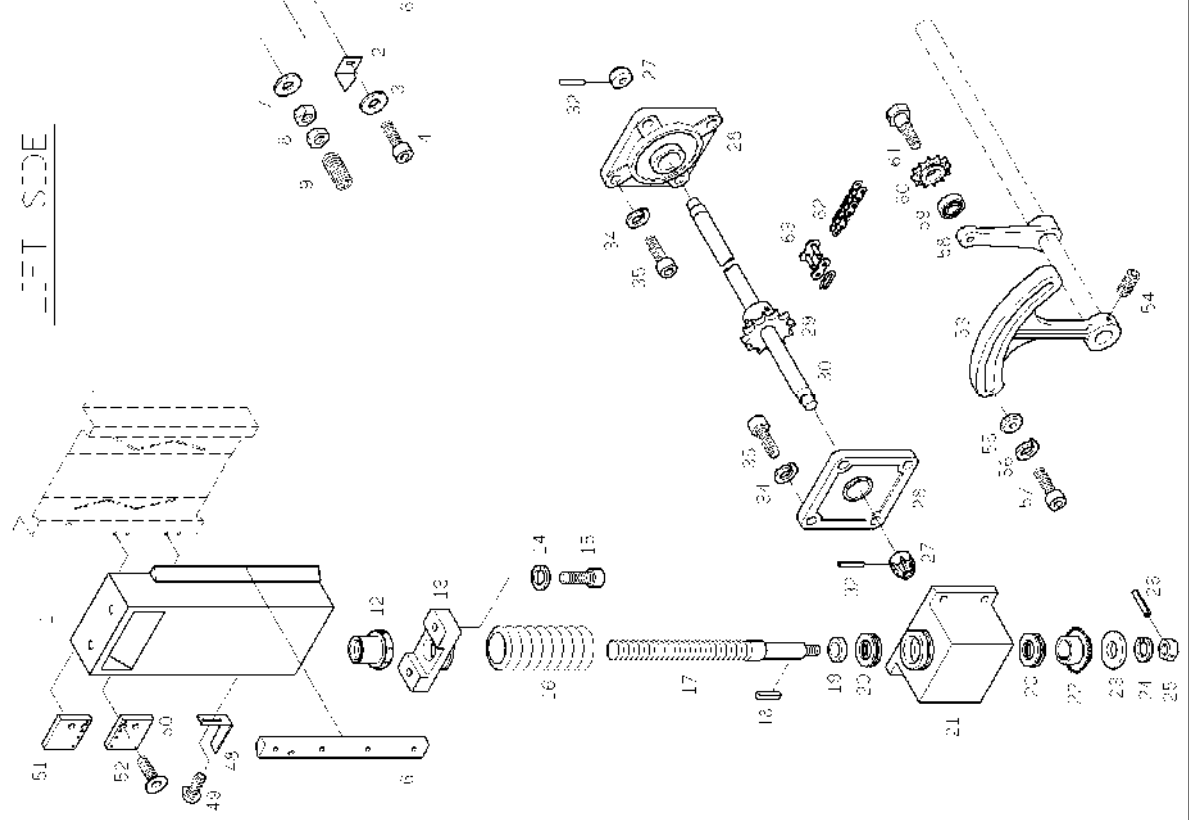
2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
61	Fix screw	1	91		
62	Roller chain	1	92		
63	Chain joint	1	93		
64	Elevation nut (R)	2	94		
65	Elevation screw (R)	2	95		
66			96		
67			97		
68			98		
69			99		
70			100		
71			101		
72			102		
73			103		
74			104		
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77			107		
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88			118		
89			119		
90			120		

RIGHT SIDE



LEFT SIDE



CK

Lower cutterhead driver unit

2000/12/10

NO.	Description	Q'ty	NO.	Description	Q'ty
1	Motor bracket	1	31	Fixing piece	1
2	Shaft	1	32	Spring washer	1
3	Retaining ring	2	33	Screw	1
4	Washer	1	34		
5	Spring washer	1	35		
6	Screw	1	36		
7	Connection rod	1	37		
8	Retaining ring	2	38		
9	Dowel pin	1	39		
10	Fork	1	40		
11	Dowel pin	1	41		
12	Retaining ring	2	42		
13	Housing	1	43		
14	Screw	3	44		
15	Adjustment base	1	45		
16	Fixing piece	1	46		
17	Spring washer	1	47		
18	Screw	1	48		
19	Fixing piece	1	49		
20	Hexagon nut	1	50		
21	Adjustable hand lever	1	51		
22	Spring washer	1	52		
23	Hexagon nut	1	53		
24	Adjustment lever	1	54		
25	Hand knob	1	55		
26	Drive motor	1	56		
27	Washer	4	57		
28	Screw	4	58		
29	Spacer	1	59		
30	Pulley	1	60		

