



HOFFMANN

OPERATING MANUAL

for

BH – 556

Edge Lipping Planer

Hoffmann Machine Company, Inc.

1386 Drexel Road Valdese, NC 28690 USA

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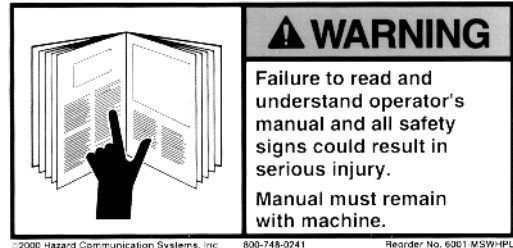


1. Safety and Warning Labels

A number of important warning labels have been attached to this handheld power planer for your information and protection.

For your own safety, please take a moment to locate and read all warning labels before operating this machine. If a label has been removed, defaced or is illegible, please contact Hoffmann Machine Company, Inc. to request a free replacement.

NEVER REMOVE ANY SAFETY OR WARNING LABEL!



2. General Machine Description

The Hoffmann BH 556 Lipping Planer is a handheld planing machine. It is designed solely for flush planing of applied solid wood and laminate edges.

The machine can be used on solid hard and softwood edges as well as veneer and laminate edgebanding materials.

Depending on the material being planed and the feed rate, up to 3mm = 1/8" material can be removed in one pass.

The machine uses the panel surface as reference for the planing operation, which explains why imperfections, high or low spots, etc. in the panel could adversely effect the planing result. Unsatisfactory results due to poor panel surfaces, insufficient preparation or improper operation are not covered under our warranty and are not grounds for replacement or refund.

USE OF THIS MACHINE FOR ANY OTHER OPERATION IS DANGEROUS AND WILL VOID THE WARRANTY. The manufacturer cannot be held liable if the machine is used for any operations other than outlined in this manual.

3. Operator Training

The Hoffmann BH 556 Lipping Planer is to be operated, maintained and repaired only by properly trained and qualified personnel. It is imperative that the operator has carefully read and understood these operating instructions, and that he or she is aware of all potential risks resulting from operating this machine.

For proper planing results, the operator should take the time to practice the handling and use of the machine on spare materials before using the machine on actual production parts.

All applicable safety procedures and rules, including but not limited to all OSHA Rules and Regulations, are to be adhered to.

Any unauthorized modification or alteration to this machine by the operator or owner will immediately void the machine warranty. The manufacturer cannot be held liable if the machine is used for any operations other than outlined in this manual or if the machine is modified or altered.

If the operator does not possess sufficient English language skills to completely understand all sections of this manual, especially the sections on Warning Labels and Safety Rules, it is the responsibility of the purchaser to retain a qualified translator to translate this entire manual.

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4. Safety Rules

Read and understand these safety rules before operating this machine!

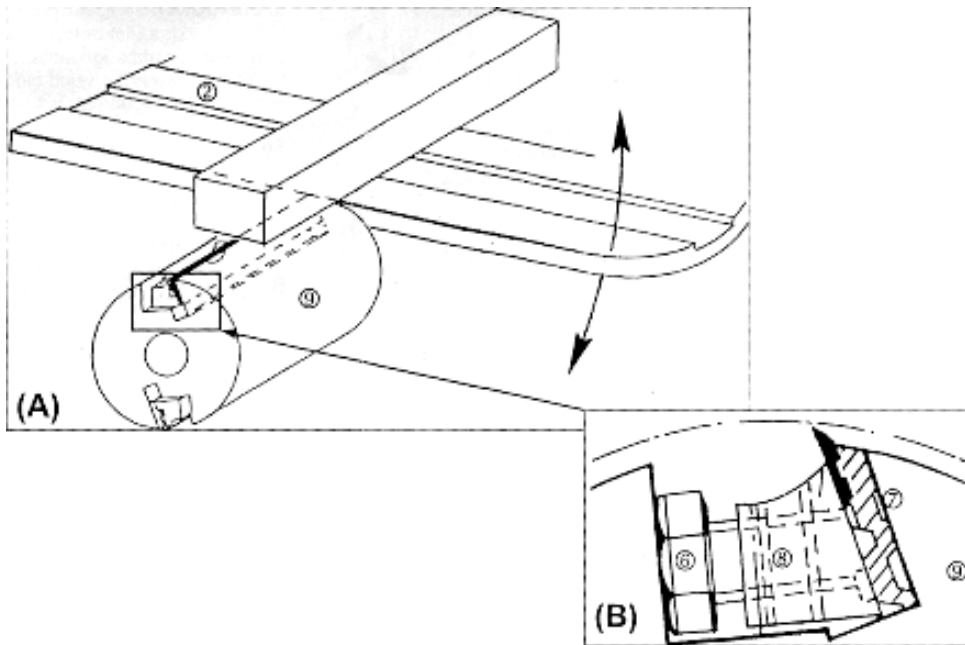
1. Always disconnect the machine from the electrical power supply before attempting any adjustment, repair or maintenance procedure (change of blades, depth-of-cut adjustment, removal of wood dust, etc.).
2. Always wear eye and ear protection as well as a respirator suitable for wood dust.
3. Always use suitable dust collection system. Duct must be properly connected to dust extraction port.
4. Never operate the machine without first installing the side handle.
5. Always use both hands to operate the machine.
6. Small workpieces, panels, etc. must be securely fastened to work table before planing.
7. Always check workpiece for nails, screws, stones or other embedded material. All foreign material must be removed prior to planing.
8. Keep all electrical power tools out of reach of children at all times.
9. Do not allow power cord to lie on floor, in the way of passing personnel or the machine operator. It will cause a trip hazard.
10. Make sure the electrical outlet is properly grounded.
Never remove the grounding prong from the power plug!
11. Use only grounded extension cords, minimum size: 14-gauge (AWG).
12. Remove or confine loose hair, clothing and jewelry to avoid entanglement.
13. Avoid a dangerous environment. Do not expose electrical equipment to rain. Do not use in presence of flammable liquids or gases.
14. Keep the area around the machine clean and free from scrap, sawdust, wood chips, oil and grease to avoid the danger of slipping.
15. Use only sharp and flawless original Hoffmann carbide blades.
16. Replace worn blades immediately. Always replace blades in sets of two.
17. Check the machine upon receipt as well as before every use for improper functioning and worn or damaged parts. Make sure the blades are securely installed.
18. Always check the proper function of the cutter head guard before operating the machine. Never operate this machine with damaged or missing blade guard!
19. Broken or defective parts must not be used until replaced or repaired by a qualified technician.
20. When interrupting work or upon leaving the area, machine must be disconnected to avoid unauthorized operation.
21. Only trained and qualified personnel must be allowed to use machine.
22. Only original Hoffmann replacement parts must be used to rebuild machine.

5. Operation

1. Initial Set-Up

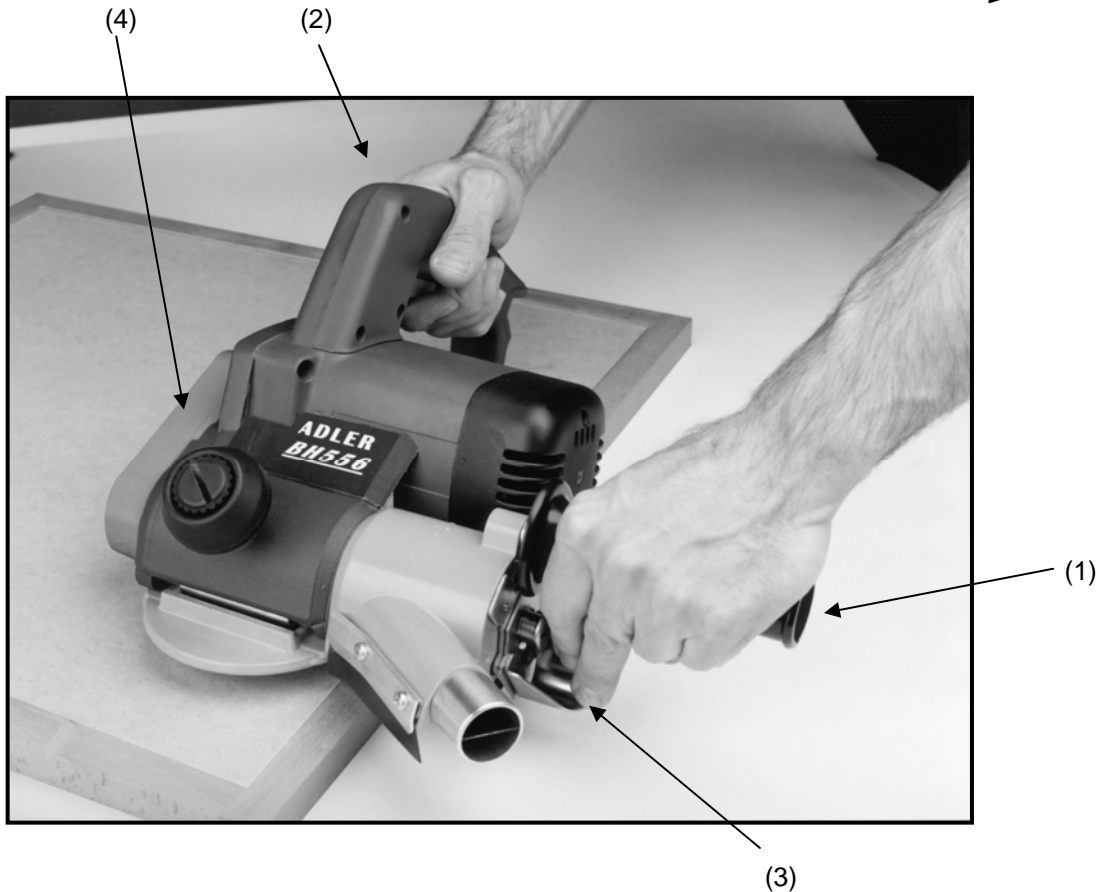
DISCONNECT ELECTRICAL POWER SUPPLY BEFORE ATTEMPTING ANY ADJUSTMENT OR MAINTENANCE WORK!

With a straight edge, check if blades are in line with base plate. Use two small Allen screws in knife clamping plate to adjust blade up or down, if necessary. Blades should be in-line with base plate and project not more than 1.1mm above cutterhead body. (see drawing B)
Attach side handle (1) on cutterhead housing.



2. Operation

- a) Set machine on panel and connect power supply.
- b) Hold machine with main handle (2) and lift cutterhead off the panel with side handle (1). Cutterhead must be clear off panel before machine is switched on!
- c) Switch on machine.
- d) Using two fingers, pull back blade guard (3) to expose rotating cutterhead.
- e) SLOWLY lower machine onto panel.
- f) To stop, lift machine off panel.
- g) Release power switch and blade guard.
- h) Set down machine only after cutterhead has come to a complete stop.



3. Adjusting cutterhead to panel surface

- a) Check with straight edge to assure cutterhead is set higher than base plate before continuing.
- b) To adjust the cutterhead setting, switch on the machine and set it on a piece of flat panel (panel does not need to have wood edge attached).
Caution: Make sure panel is secured to table with clamps, screws, etc. If cutterhead setting is incorrect, an unsecured panel could be thrown off the table possible causing an injury!
- c) SLOWLY turn the front adjustment knob (4) to lower the rotating cutterhead onto the panel. Turning the knob clockwise will raise the cutterhead off of the panel, turning it counterclockwise will lower the cutterhead onto the panel. (A coin may be used to turn the inner portion of the knob.)
The knob is equipped with a built-in spring to produce a ratchet action. Each "click" of the ratchet raises or lowers the cutterhead approx. 1/10mm – 4/1000".
- d) When adjusted correctly, the blades will slightly touch the panel without leaving any marks.

4. Feed rate

The maximum feed rate depends on various factors including depth of cut (how much material is removed), width of cut (how wide the edge is), condition of blades, material being planed, etc.

While the BH 556 can remove up to 1/8" of material in one pass, it is recommended that the wooden edge be glued as precise as possible, generally about 1/16" higher than the panel.

A power plane can only produce a clean cut when it is operated at full RPM!



5. Maintenance

The BH 556 is equipped with solid carbide blades, which are indexed and reversible.

The blades cannot be sharpened and must be replaced with Original Hoffmann Replacement Blades when dull.

Always replace blades in pairs.

Caution: Check condition of blades before every use and replace dull or worn blades immediately. Using dull blades results in rough surfaces on the finished product and could cause motor damage.

Blade Change

- a) Disconnect electrical power supply from machine.
- b) Pull back pivoting blade guard.
- c) Loosen set screws (60) in cutterhead with 8mm wrench.
- d) Slide blades sideways out of holder.
- e) Clean blade holder and screws and remove all wood residue.
- f) Install new blades. Important: The indentation in the knife set plate must be properly aligned with the knife clamping plate.
The ridge in the knife set plate must rest in the groove in the blade back.
- g) Blade assembly must be centered in cutterhead.
- h) Tighten the locking screws with the enclosed 8mm wrench.
- i) If set properly, blades should extend 1.1mm past cutterhead body.

Brush Change

Always replace brushes in pairs. Use only Original Hoffmann Parts.

- a) Remove screws (29) and motor cover (30).
- b) Remove old brushes and insert new ones (31) in same manner.
- c) Replace motor cover (30) and secure with screws (29).

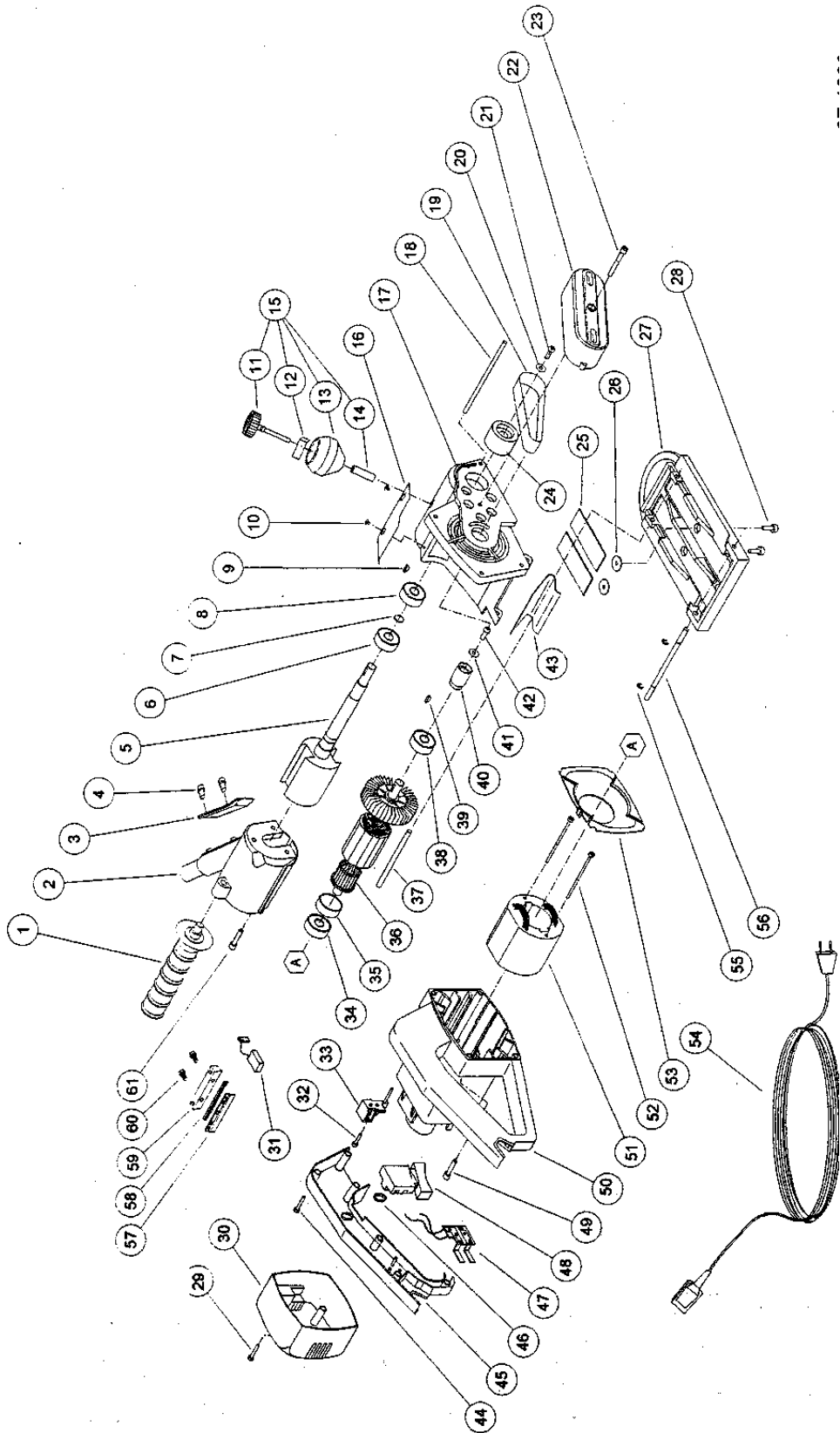
6. Cleaning of Machine

Clean machine regularly with compressed air. Keep swivel guard in good operating order. Remove glue residue immediately from base plate.

Never use paint thinner or alcohol to clean machine – damage may occur.

7. Service and Repairs

Spare and replacement parts are available from Hoffmann Machine Company, Inc. Please contact your local power tool service center for repair work.



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Item	Part Number	Description
1	202 210 001	side handle
2	202 210 002	cutter head cover, complete
3	202 210 003	chip deflector
4	000 000 408	screw, M4 x 8
5	202 200 050	arbor with cutter head
6	000 406 003	ball bearing, 6003 - 2RS
7	202 201 033	retaining ring
8	000 406 201	ball bearing, 6201 - 2RS
9	202 201 017	woodruff key, 3x5
10	000 010 408	screw, M4 x 8
11	202 201 036	fine adjustment screw
12	202 201 041	steel spring
13	202 201 038	knob, M10
14	202 201 040	threaded stem, M10/M5
15	202 201 061	fine adjustment knob set, complete
16	202 210 016	name plate "ADLER BH 556"
17	202 210 017	machine housing
18	202 210 018	front pivot pin
19	202 201 019	drive belt, 18 x 275
20	202 210 020	washer, M5
21	000 000 514	screw, M5 x 14
22	202 210 022	belt cover
23	000 020 535	screw, M5 x 35
24	202 210 032	arbor pulley, 38.5mm
25	202 201 035	leaf spring
26	202 201 043	washer, 5 x 20
27	202 201 037	base plate
28	000 000 512	screw, M5 x 12
29	202 210 029	screw, M4 x 19
30	202 210 030	motor cover
31	202 211 031	carbon brush, 120 volt, for BH556
32	202 210 032	screw, M4 x 13
33	202 210 033	brush holder
34	000 406 010	ball bearing, 6000 - 2RS
35	202 210 035	rubber bearing cup
36	202 211 036	rotor complete, 120 volt, for BH556
37	202 201 055	front shaft
38	000 406 001	ball bearing, 6001 - 2RS
39	202 201 017	woodruff key, 3x5
40	202 210 040	motor pulley, 20.8mm
41	202 210 020	washer, M5
42	000 000 514	screw, M5 x 14
43	202 201 025	adjustment plate
44	202 210 029	screw, M4 x 19
45	202 210 045	main handle cover
46	202 210 046	power switch locking pin
47	202 210 047	printed circuit
48	200 503 211	power switch, BH 556
49	000 020 520	screw, M5 x 20
50	202 210 050	motor housing
51	202 211 051	stator, 120 volt, for BH 556
52	202 210 052	screw, M4 x 60
53	202 210 053	stator cover
54	000 510 021	power cord, 120 volt, for BH556
55	000 235 005	retaining ring
56	202 201 058	rear pivot pin
57	202 200 049	knife set plate
58	200 807 055	knives, reversable, carbide, 10 pc. Box
59	202 200 047	knife clamping plate with screws
60	202 200 046	clamping plate screws, M5 x 8
61	000 020 516	screw, M5 x 16
62	202 211 062	label, S/N & technical data, 120 volt
63	202 200 400	open end wrench, 8mm



8. Hoffmann Machine Company, Inc. Warranty

Hoffmann Machine Company, Inc. (hereinafter called "seller") guarantees all machines and parts of its own manufacture against defects in material and workmanship for a period of twelve (12) months from the date of shipment, under normal use and service by buyer (one eight hour production period per day). No other warranties are to be implied with respect thereto. The liability of seller under its warranty is limited to adjustment, in accordance with the warranty adjustment terms set forth below, for products which are found to be defective by seller in the form in which they were originally shipped. In no event will seller be liable for collateral, consequential or other damages of any kind or nature.

SELLER MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

Warranty Adjustment Terms

1. Adjustments will be limited to claims which are presented promptly after the product is found to be defective, and within the aforesaid warranty period.
2. All products claimed to be defective will be subject to inspection and test by seller. Normally, seller will request return of products for inspection and test, however, seller reserves the right to make inspection and test on buyer's premises. Returns are to be made only as and if authorized by seller.
3. Buyer will pay all packaging, inspection, labor and transportation costs involved. Credit for the transportation costs only will be issued by seller provided adjustment subsequently is allowed.
4. No adjustments will be allowed for products which have been subjected to abuse, improper installation or application, alteration, accident or negligence in use, storage, transportation or handling; nor for products on which original identification markings have been removed, defaced or altered.
5. Final determination as to whether any adjustment is allowable, and as to the extend thereof, rests with the seller. Full adjustment, if allowed, normally will be made by replacement in kind on an exchange basis. Pro rata adjustment, if allowed, normally will be made by issuance of credit. In all cases, however, the seller reserves the right to make adjustments by repair, replacement or credit.
6. Replacement for products found subject to adjustment, whether new or repaired, will be shipped F.O.B. City of destination with transportation charges prepaid by seller.

Installation

Buyer shall install machinery purchased from seller at buyer's cost and expense, unless otherwise expressly stipulated in writing. At the request of buyer, seller will recommend competent engineers to supervise the installation, and to instruct buyer in the proper operation of the machinery and equipment. During such period of supervision and instruction, such personnel shall be deemed to be employees of the buyer who shall pay the wages, remuneration, board and traveling expenses of such personnel and shall not make seller liable, directly or indirectly, in any manner whatsoever, for any damages resulting from any act of commission or omission or any misfeasance or malfeasance, on the part of said personnel.



9. Terms and Conditions of Sale

1. Application and Scope:

The terms and conditions contained herein apply to proposals made, and to purchase orders received, by HOFFMANN MACHINE COMPANY, INC. (hereinafter called "Seller"), and sets forth the entire agreement between the parties hereto, and supersedes all communication, representations or agreements, whether oral or written, between the parties hereto with respect to the subject matter herein, and no agreement or understanding varying or extending the terms or conditions hereof will be binding unless expressly agreed to in writing by Seller. No conditions stated by Buyer in its purchase order or orders shall be binding upon Seller if in conflict with, inconsistent with, or in addition to, the terms and conditions contained herein, unless expressly accepted in writing by Seller. Seller's failure to object to any provision contained in any communication or purchase order from Buyer shall not be deemed a waiver of the terms and conditions herein. All orders or contracts are subject to approval and acceptance by Seller at its main office in North Carolina. These Terms and Conditions are within the sole discretion of Seller and are subject to change with or without prior notice.

2. Quotations and F.O.B. Point:

Prices are quoted and all sales are made F.O.B. Sellers facility and, unless otherwise indicated in the proposal, prices quoted are effective for a maximum thirty (30) days after the date of any proposal.

3. Terms of Payment:

All invoices are due and payable as set forth on the front of the invoice. Each delivery shall be considered a separate and independent transaction and payment thereof shall be made on terms set forth on invoice covering same. If delivery is delayed by Buyer, payment shall become due when Seller is prepared to make delivery. If, in the sole judgment of the Seller, the financial condition of Buyer at any time does not justify continuation of manufacture or of delivery as originally specified, Seller may vary terms of payment by requiring full or partial payment in advance, or otherwise, or may ship to Buyer's order against sight draft with bill of lading attached.

4. Taxes:

Unless the quotation expressly provides otherwise, the amount of any present or future Federal, State or local sales, excise or other tax applicable to the products purchased hereunder, or to the manufacture or sale thereof (including, without limitation, state or local privilege or excise taxes based on gross revenue), and any taxes or amounts in lieu thereof paid or payable by Seller in respect of the foregoing (excluding, however, taxes based on net income), shall be added to the purchase prices and shall be paid by Buyer. In lieu thereof, Buyer may provide Seller with an appropriate tax exemption certificate acceptable to the taxing authorities.

5. Warranty:

The products covered herein are warranted, for a period of twelve (12) months from date of shipment, against defects in material and workmanship under normal use and service by Buyer. The liability of Seller under its warranty is limited to adjustment, in accordance with the Warranty Adjustment Terms set forth below, for products which are found to be defective by Seller in the form in which they were originally shipped. In no event will Seller be liable for collateral, consequential or other damages of any kind.

SELLER MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

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9. Terms and Conditions of Sale (continued)

6. Warranty Adjustment Terms:

- (a) Adjustments will be limited to claims which are presented promptly after the product is found to be defective, and within the aforesaid warranty period.
- (b) All products claimed to be defective will be subject to inspection and test by Seller. Normally, Seller will request return of products for inspection and test, however, Seller reserves the right to make inspection and test on Buyer's premises. Returns are to be made only as and if authorized in writing by Seller.
- (c) Buyer will pay all packaging, inspection, labor and transportation costs involved. Credit for the transportation costs only will be issued by Seller provided adjustment subsequently is allowed.
- (d) No adjustments will be allowed for products which have been subjected to abuse, improper installation or application, alteration, accident or negligence in use, storage, transportation or handling; nor for products on which original identification markings have been removed, defaced or altered.
- (e) Final determination as to whether any adjustment is allowable, and as to the extent thereof, rests with Seller. Full adjustment, if allowed, normally will be made by replacement in kind on an exchange basis. Pro rate adjustment, if allowed, normally will be made by the issuance of credit. In all cases, however, Seller reserves the right to make adjustment by repair, replacement or credit.
- (f) Replacement for products found subject to adjustment, whether new or repaired, will be shipped F.O.B. city of destination with transportation charges prepaid by Seller.

7. Installation:

Buyer shall install machinery purchased from Seller at Buyer's cost and expense, unless otherwise expressly stipulated in writing.

8. Packaging and Shipment:

All products shipped hereunder will be packaged in accordance with standard commercial practice for domestic shipment. Seller's liability as to delivery ceases upon making delivery of products purchased hereunder to carrier at Seller's facility, in good condition, the carrier acting as Buyer's agent. All claims for damages must be filed with the carrier or Buyer's insurer as appropriate. Seller will select the method of shipment unless Buyer does so in writing at least ten (10) days in advance of the scheduled delivery date. Equipment held for Buyer because of Buyer's delay in acceptance, shall be at Buyer's risk and expense. Seller does not assume liability for shipping in the least expensive manner.

9. Deliveries:

It is the desire of Seller to meet requested delivery schedules, however, Seller shall not incur any liability, consequential, collateral or otherwise, due to any delay or failure to deliver for any reason, other than arbitrary refusal by Seller to perform. Any delivery indication furnished by Seller only represents the best estimate of the time required to make shipment.

10. Assignment:

Buyer shall not assign this purchase order or any interest herein or any rights thereunder, without the prior written consent of Seller.

11. Termination:

Seller may terminate the purchase order or any part thereof herein referred to or any other purchase order or orders then outstanding by written, telegraphic or electronic mail notice to Buyer if Buyer becomes insolvent or is subject to proceedings under any law relating to bankruptcy, insolvency or relief of debtors. Upon such termination Seller shall be entitled to receive reimbursement for reasonable termination charges.



9. Terms and Conditions of Sale (continued)

12. Cancellations or Returns:

Buyer shall not cancel any order nor return any equipment without first obtaining the written consent of Seller. In any event, in case of refusal or inability of Buyer to accept a delivery, the Buyer shall nevertheless be liable for freight, express, storage, handling, restocking and any other expense resulting. In no event are orders for machines or parts built to customers' specification subject to cancellation and Buyer shall be liable for work done and materials used.

13. Specifications:

(a) Phone order specifications are filled at Buyer's risk unless confirmed in writing prior to commencement of manufacture.

(b) If equipment is found not to meet original specifications, Seller shall have a reasonable time to make adjustments.

14. Law Governing:

Buyer's purchase order shall be governed by and construed according to the laws of the State of North Carolina. The courts of the State of North Carolina shall have jurisdiction over any controversy that may arise out of the dealings between Buyer and Seller.

15. Force Majeure:

Seller shall not be liable under this agreement by reason of its delay in the performance of or failure to perform any of its obligations hereunder if such delay or failure is caused by acts of God or the public enemy, riots, incendiaries, interference by civil or military authority, compliance with government laws, rules and regulations or any fault beyond its control.

16. Acceptance:

Payment for or a deposit made for the products shall constitute a contract embodying all of terms and conditions stated herein.

17. Ownership:

All products remain the sole property of the Seller until all charges, including all transportation, crating and installation costs, are paid in full.

18. Severability:

The provisions of these Terms and Conditions are intended to be severable. If, for any reason, any of the above provisions should be found unenforceable or invalid in whole or in part, in any jurisdiction, such provision be ineffective only to the extent the determination of invalidity or unenforceability in that jurisdiction. Any such determination shall not affect the enforceability or validity of the remaining provisions.