HFT Bauer 1621

Bauer 15 Amp 12-1/2 Inch Portable Thickness Planer Instruction Manual

Model: 1621 | Brand: HFT Bauer

1. Introduction

Thank you for choosing the Bauer 15 Amp 12-1/2 Inch Portable Thickness Planer. This tool is designed for smoothing and dimensioning wood to a consistent thickness. It features a powerful 15-amp motor for efficient cutting of hardwoods and a robust four-carriage frame to minimize snipe and twisting, ensuring smooth, satin finishes. Please read this manual thoroughly before operating the planer to ensure safe and effective use. Keep this manual for future reference.

2. Important Safety Information

Always follow basic safety precautions to reduce the risk of fire, electric shock, and personal injury.

- **Read All Instructions:** Familiarize yourself with the controls and proper use of the planer.
- **Wear Eye Protection:** Always wear ANSI-approved safety goggles or a face shield.
- **Wear Hearing Protection:** Use ear protection during operation.
- **Dress Properly:** Do not wear loose clothing, gloves, neckties, or jewelry that can get caught in moving parts. Secure long hair.
- **Maintain Work Area:** Keep the work area clean, well-lit, and free of clutter. Ensure adequate space around the planer.
- **Avoid Dangerous Environments:** Do not use power tools in damp or wet locations, or expose them to rain.
- **Keep Children Away:** Do not allow children or untrained personnel near the planer or power cord.
- **Use Proper Extension Cords:** If an extension cord is necessary, ensure it is rated for outdoor use and has the correct gauge for the planer's amperage.
- **Disconnect Power:** Always disconnect the planer from the power source before making adjustments, changing accessories, or performing maintenance.
- **Avoid Accidental Starting:** Ensure the switch is in the OFF position before plugging in the tool. The planer includes an integrated safety switch to prevent accidental starts.
- **Secure Workpiece:** Ensure the workpiece is properly supported before feeding it into the planer.

- **Inspect Blades:** Regularly check planer blades for sharpness and damage. Replace dull or damaged blades promptly.
- **Dust Collection:** Connect the planer to a dust collection system to minimize airborne dust and maintain a clear work area.

3. Setup and Assembly

3.1 Unpacking and Inspection

Carefully remove the planer and all accessories from the packaging. Inspect the tool for any damage that may have occurred during shipping. If any parts are damaged or missing, contact customer service immediately.

3.2 Included Accessories

The following items are included with your Bauer Thickness Planer:

- (2) Planer Knives
- (2) Magnetic Knife Removal Tools
- 1-5/32 inch Hex Wrench
- Dust Hood

3.3 Workstation Preparation

Place the planer on a stable, level workbench or stand capable of supporting its weight and the weight of the workpiece. Ensure there is sufficient space for feeding material into and out of the planer, especially considering the extra-long in-feed and out-feed tables. Connect the dust hood to a suitable dust collection system to maintain a clean and safe working environment.



Figure 1: The Bauer 15 Amp 12-1/2 Inch Portable Thickness Planer ready for operation. This image shows the overall design and robust construction of the planer, including the in-feed and out-feed tables.

4. Operating Instructions

4.1 Power Connection

Ensure the planer's power switch is in the OFF position. Plug the power cord into a grounded 120V AC outlet. The integrated safety switch prevents accidental starts.

4.2 Adjusting Cutting Depth

The planer features a high-precision gear and pinion lift system for easy and reliable adjustment of the cutting depth. Turn the depth adjustment crank to raise or lower the cutter head to the desired thickness. Refer to the depth scale for accurate measurements. Avoid taking excessively deep cuts, especially on hardwoods, to prevent motor overload and ensure a smooth finish.

4.3 Feeding Material

The planer is equipped with an automatic feed system and dual rollers for easy material passage. Ensure the workpiece is free of nails, screws, or other foreign objects that could damage the blades. Place the leading edge of the workpiece onto the in-feed table and gently guide it into the planer. The automatic feed will engage and pull the material through. The extra-long in-feed and out-feed tables provide over 31 inches of material support, reducing snipe.



Figure 2: The Bauer Thickness Planer actively planing a long wooden board. This illustrates the effective use of the extended in-feed and out-feed tables for supporting the workpiece.

4.4 Achieving Optimal Finish

The two-knife cutter head is designed to leave a blemish-free surface. For the best finish, take multiple shallow passes rather than one deep pass. Rotate the workpiece 180 degrees between passes to ensure even material removal and prevent cupping.

5. Maintenance

Regular maintenance ensures the longevity and optimal performance of your planer. Always disconnect the power before performing any maintenance.

- **Cleaning:** After each use, clean the planer thoroughly. Remove sawdust and debris from the cutter head, feed

rollers, and tables using a brush or compressed air.

- **Blade Inspection and Replacement:** Regularly inspect the planer knives for sharpness, nicks, or damage. Dull or damaged blades can lead to poor finishes and increased motor strain. Use the provided magnetic knife removal tools for safe blade replacement. Refer to the manufacturer's guidelines for specific blade replacement procedures.
- **Lubrication:** Periodically lubricate moving parts, such as the gear and pinion lift system, according to the manufacturer's recommendations to ensure smooth operation.
- **Cord Inspection:** Check the power cord for any signs of damage, fraying, or cuts. Replace damaged cords immediately.

6. Troubleshooting

Problem	Possible Cause	Solution
Planer does not start	No power; Safety switch not engaged; Faulty power cord/outlet	Check power connection; Ensure safety switch is reset; Test outlet with another device; Inspect power cord.
Poor surface finish (e.g., snipe, tear-out)	Dull/damaged blades; Too deep a cut; Insufficient material support; Incorrect feed rate	Replace/sharpen blades; Take shallower passes; Ensure proper in-feed/out-feed support; Allow automatic feed to operate smoothly.
Motor stalls or overheats	Overload (too deep a cut); Dull blades; Insufficient ventilation	Reduce cutting depth; Replace/sharpen blades; Ensure clear ventilation openings; Allow motor to cool.
Material not feeding smoothly	Dirty/worn feed rollers; Excessive resin buildup on tables	Clean feed rollers; Clean tables with appropriate cleaner; Check for obstructions.

7. Specifications

Feature	Specification
Brand	HFT Bauer
Model Number	1621
Amperage	15 Amps
Cutting Width	12.5 Inches
Cutting Depth (Max)	6 Inches
Power Source	Corded Electric
Material (Base)	Cast Iron
Included Items	(2) Planer Knives, (2) Magnetic Knife Removal Tools, 1-5/32 inch Hex Wrench, Dust Hood
GTIN/UPC	193175634450



Figure 3: An overview of the Bauer Thickness Planer's key features and specifications, including its 15 Amp motor, 12-1/2 inch portable design, and two-knife cutter head.

8. Warranty Information

For detailed warranty information, please refer to the warranty card included with your product or visit the official HFT Bauer website. Keep your purchase receipt as proof of purchase for any warranty claims.

9. Customer Support

If you have any questions, require technical assistance, or need to order replacement parts, please contact HFT Bauer customer support. Contact information can typically be found on the product packaging or the official HFT Bauer website. When contacting support, please have your product model number (1621) and serial number ready.

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