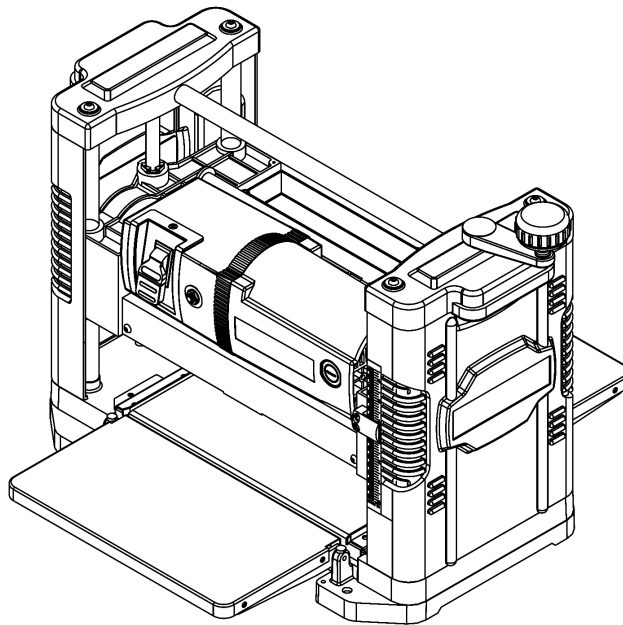




12-1/2 IN THICKNESS PLANER



bit.ly/wenvideo

IMPORTANT:

Your new tool has been engineered and manufactured to WEN's highest standards for dependability, ease of operation, and operator safety. When properly cared for, this product will supply you years of rugged, trouble-free performance. Pay close attention to the rules for safe operation, warnings, and cautions. If you use your tool properly and for its intended purpose, you will enjoy years of safe, reliable service.

NEED HELP? CONTACT US!

Have product questions? Need technical support?
Please feel free to contact us at:

 **800-232-1195** (M-F 8AM-5PM CST)

 **techsupport@wenproducts.com**

 **WENPRODUCTS.COM**



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TECHNICAL DATA

Model Numbers:	6550, 6550T
Motor:	120V, 60 Hz, 15A
Cutterhead Speed:	8500 RPM
Cuts Per Minute:	17,000 cuts per minute
Feed rate:	26 FPM
Maximum Depth of Cut:	3/32" (for workpieces under 6" wide) 1/32 (for workpieces over 6" wide)
Table Size:	12-1/2 x 9-3/8"
Extension Table Size:	12-1/2 x 6-3/4"
Base Size:	21 x 12-1/2"
Workpiece Width (max.):	12-1/2"
Workpiece Thickness (max.):	6"
Workpiece Thickness (min.):	1/4" (1/2" recommended min.)
Minimum Depth Stop Height:	5/32" (not recommended)
Dust Chute:	Outer Diameter - 2-1/20 in. (52.5 mm) Inner Diameter - 1-7/8 in. (47.5 mm)
Weight:	73 lbs

GENERAL SAFETY RULES

Safety is a combination of common sense, staying alert and knowing how your item works. **SAVE THESE SAFETY INSTRUCTIONS.**



WARNING: To avoid mistakes and serious injury, do not plug in your tool until the following steps have been read and understood.

1. **READ** and become familiar with this entire instruction manual. **LEARN** the tool's applications, limitations, and possible hazards.
2. **AVOID DANGEROUS CONDITIONS.** Do not use power tools in wet or damp areas or expose them to rain. Keep work areas well lit.
3. **DO NOT** use power tools in the presence of flammable liquids or gases.
4. **ALWAYS** keep your work area clean, uncluttered, and well lit. **DO NOT** work on floor surfaces that are slippery with sawdust or wax.
5. **KEEP BYSTANDERS AT A SAFE DISTANCE** from the work area, especially when the tool is operating. **NEVER** allow children or pets near the tool.
6. **DO NOT FORCE THE TOOL** to do a job for which it was not designed.
7. **DRESS FOR SAFETY.** Do not wear loose clothing, gloves, neckties, or jewelry (rings, watches, etc.) when operating the tool. Inappropriate clothing and items can get caught in moving parts and draw you in. **ALWAYS** wear non-slip footwear and tie back long hair.
8. **WEAR A FACE MASK OR DUST MASK** to fight the dust produced by sawing operations.



WARNING: Dust generated from certain materials can be hazardous to your health. Always operate the tool in a well-ventilated area and provide for proper dust removal. Use dust collection systems whenever possible.

9. **ALWAYS** remove the power cord plug from the electrical outlet when making adjustments, changing parts, cleaning, or working on the tool.
10. **KEEP GUARDS IN PLACE AND IN WORKING ORDER.**
11. **AVOID ACCIDENTAL START-UPS.** Make sure the power switch is in the OFF position before plugging in the power cord.
12. **REMOVE ADJUSTMENT TOOLS.** Always make sure all adjustment tools are removed from the saw before turning it on.
13. **NEVER LEAVE A RUNNING TOOL UNATTENDED.** Turn the power switch to OFF. Do not leave the tool until it has come to a complete stop.

GENERAL SAFETY RULES

14. **NEVER STAND ON A TOOL.** Serious injury could result if the tool tips or is accidentally hit. **DO NOT** store anything above or near the tool.
15. **DO NOT OVERREACH.** Keep proper footing and balance at all times. Wear oil-resistant rubber-soled footwear. Keep the floor clear of oil, scrap, and other debris.
16. **MAINTAIN TOOLS PROPERLY.** **ALWAYS** keep tools clean and in good working order. Follow instructions for lubricating and changing accessories.
17. **CHECK FOR DAMAGED PARTS.** Check for alignment of moving parts, jamming, breakage, improper mounting, or any other conditions that may affect the tool's operation. Any part that is damaged should be properly repaired or replaced before use.
18. **MAKE THE WORKSHOP CHILDPROOF.** Use padlocks and master switches and **ALWAYS** remove starter keys.
19. **DO NOT** operate the tool if you are under the influence of drugs, alcohol, or medication that may affect your ability to properly use the tool.
20. **USE SAFETY GOGGLES AT ALL TIMES** that comply with ANSI Z87.1. Normal safety glasses only have impact resistant lenses and are not designed for safety. Wear a face or dust mask when working in a dusty environment. Use ear protection such as plugs or muffs during extended periods of operation.

SPECIFIC RULES FOR THE PLANER



WARNING: For your own safety, read all of the instructions and precautions before operating tool.

WARNING: Operation of any power tool can result in foreign objects being thrown into eyes which can result in severe eye damage. Always wear safety goggles complying with United States ANSI Z87.1 (shown on package) before commencing power tool operation.

CAUTION: Always observe the following safety precautions:

1. Whenever adjusting or replacing any parts on planer, turn switch OFF and remove plug from power source.
2. Make sure all guards are properly attached and securely fastened.
3. Make sure all moving parts are free from interference.
4. Always wear eye protection or face shield.
5. Make sure blades are properly aligned and properly attached to cutterhead.
6. Do not plug in planer unless the switch is in the off position. After turning the switch on, allow the planer to come to full speed before operating.

SPECIFIC RULES FOR THE PLANER

7. Keep hands clear of all moving parts.
8. Do not force cut. Slowing or stalling will overheat motor. Allow automatic feed to function properly.
9. Use quality lumber. Blades last longer and cuts are smoother with good quality wood.
10. Do not plane material shorter than 15", narrower than 3/4", wider than 12-1/2" or thinner than 1/2".
11. Never make planing cut deeper than 3/32".
12. For workpieces longer than 24", use material support stands.
13. Always feed from infeed side to outfeed side, and do not attempt to reverse direction of workpiece being planed while it is being fed through the planer.
14. Take precautions against kickback. Do not permit anyone to stand or cross in line of cutterhead's rotation. Kickback or thrown debris will travel in this direction.
15. Turn switch off and disconnect power whenever planer is not in use.
16. Replace knives as they become damaged or dull.
17. Keep planer maintained. Follow maintenance instructions.
18. Don't plane against the grain of the wood. (Refer to Operation Section, Page 12)

ELECTRICAL INFORMATION

GROUNDING INSTRUCTIONS

IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides the path of least resistance for an electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching outlet that is properly installed and grounded in accordance with ALL local codes and ordinances.

DO NOT MODIFY THE PLUG PROVIDED. If it will not fit the outlet, have the proper outlet installed by a licensed electrician.

IMPROPER CONNECTION of the equipment grounding conductor can result in electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment grounding conductor to a live terminal.

CHECK with a licensed electrician or service personnel if you do not completely understand the grounding instructions or whether the tool is properly grounded.

CAUTION: In all cases, make certain the outlet in question is properly grounded. If you are not sure, have a licensed electrician check the outlet.

ELECTRICAL INFORMATION



WARNING: This tool is for indoor use only. Do not expose to rain or use in damp locations.

GUIDELINES FOR USING EXTENSION CORDS

Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The table below shows the correct size to be used according to cord length and nameplate ampere rating. When in doubt, use a heavier cord. The smaller the gauge number, the heavier the cord.

Make sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat and damp/wet areas.

Use a separate electrical circuit for your tools. This circuit must not be less than a #12 wire and should be protected with a 15 A time-delayed fuse. Before connecting the motor to the power line, make sure the switch is in the OFF position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

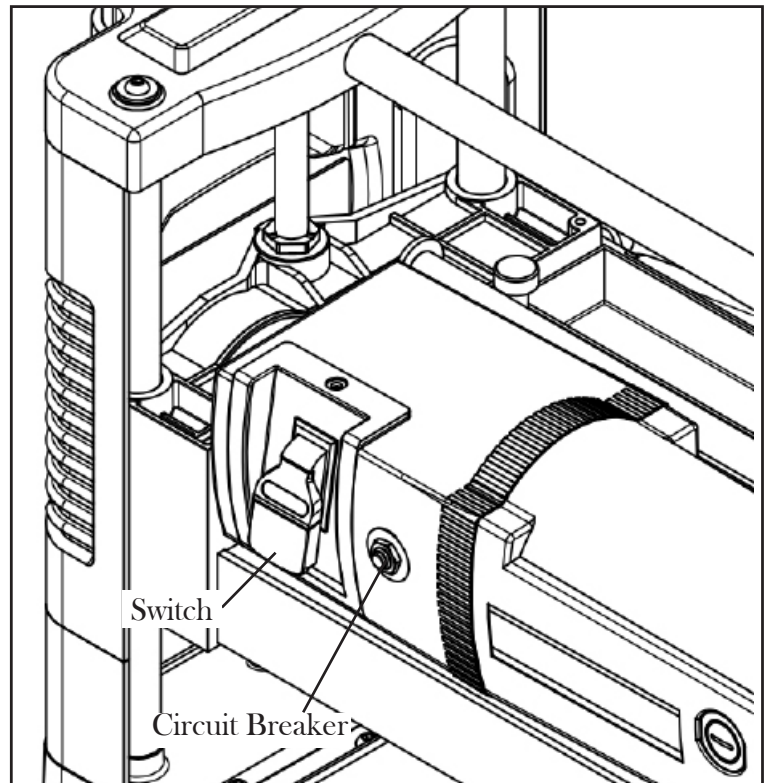
WARNING: This tool must be grounded while in use to protect the operator from electric shock.

AMPERAGE	REQUIRED GAUGE FOR EXTENSION CORDS			
	25 ft.	50 ft.	100 ft.	150 ft.
15 A	14 gauge	12 gauge	10 gauge	8 gauge

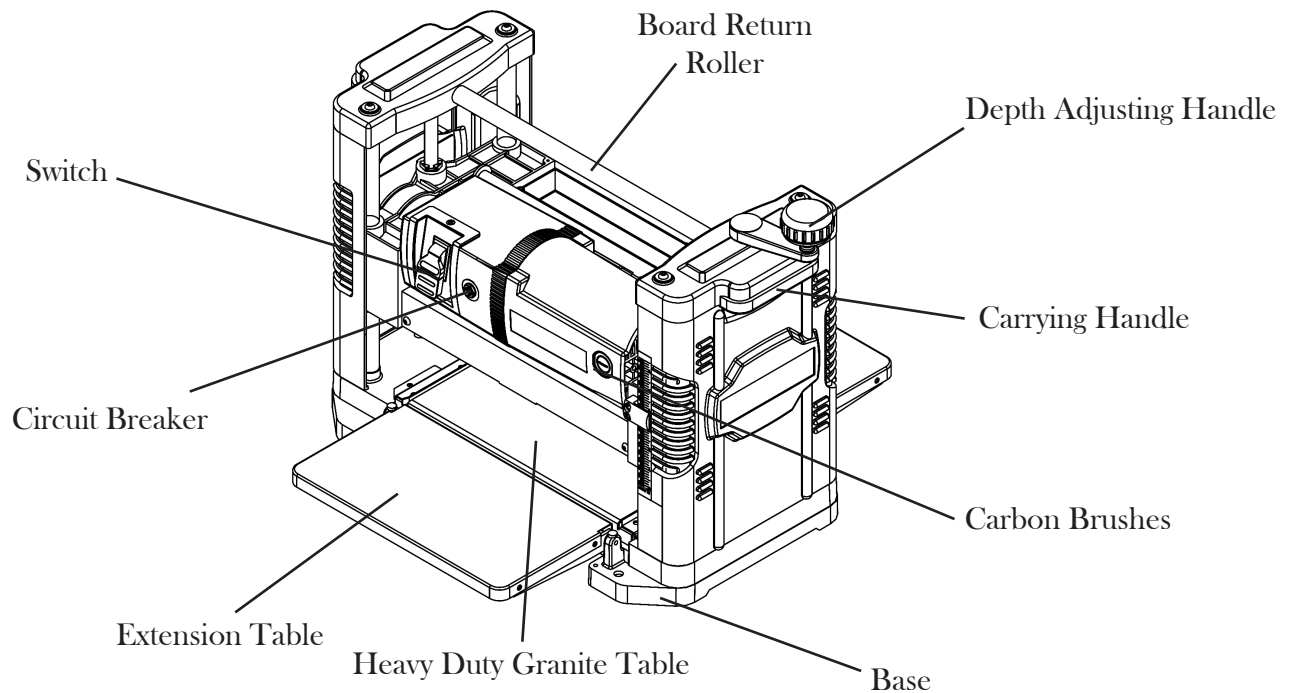
CIRCUIT BREAKER

This planer is equipped with a motor protection device-circuit breaker. The breaker will automatically shut the planer off when excessive current is consumed. If the breaker is tripped, turn the planer off and reset the circuit by pressing the button.

CAUTION: Be sure to turn the planer off prior to resetting the circuit breaker to avoid unintentional start-up of the planer.



KNOW YOUR PLANER



ASSEMBLY AND ADJUSTMENTS

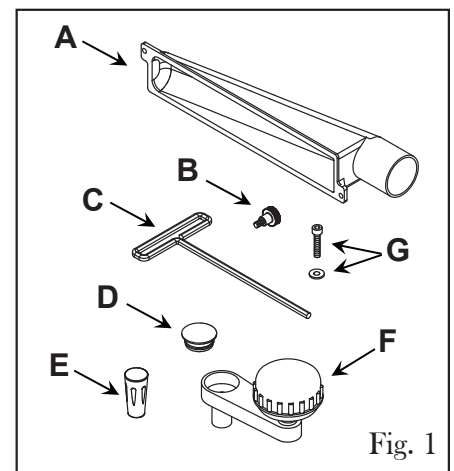
UNPACKING (Fig. 1)

The planer comes assembled as one unit. Additional parts which need to be fastened to planer should be located and accounted for before assembling.

- A Dust Chute
- B Thumb Screw (2) (pre-installed on planer)
- C T-handle Hex Wrench
- D Plug
- E Magnet
- F Depth adjusting handle
- G Bolt with Flat Washer



WARNING: Do not attempt assembly if parts are missing.
Use this manual to order replacement parts.

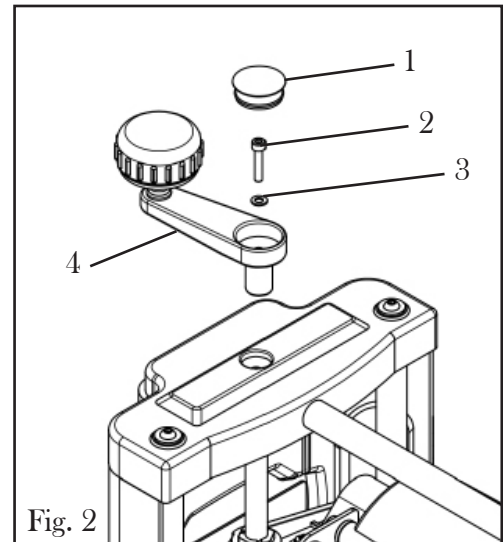


ASSEMBLY AND ADJUSTMENTS

ATTACHING THE CRANK HANDLE (Fig. 2)

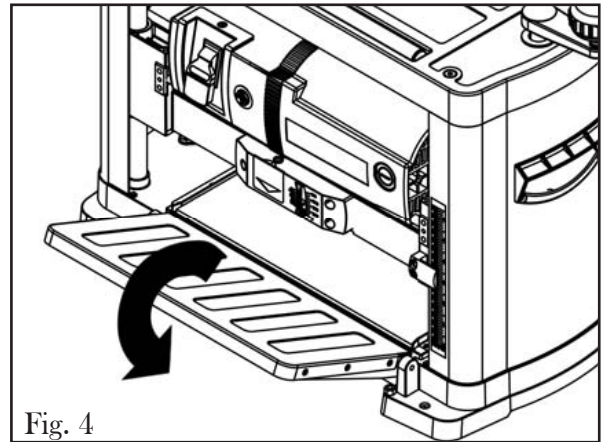
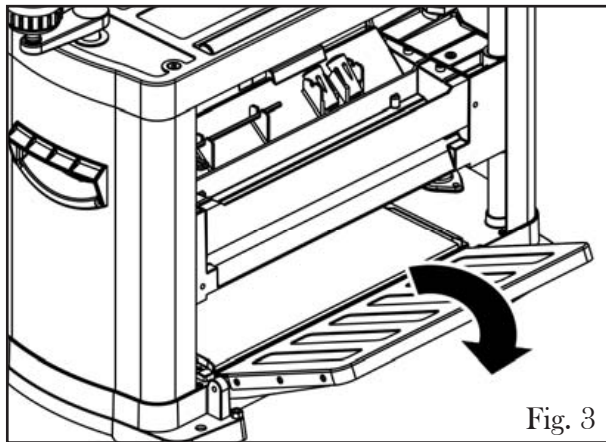
It's time to put this thing together! First, place the washer (Fig. 2 - 3) over the socket head bolt (Fig. 2 - 2) and feed the bolt into the handle (Fig. 2 - 4). Tighten the bolt to secure the handle in position on top of the planer. Place the handle cap (Fig. 2 - 1) onto the handle as shown in Fig. 2.

NOTE: With each full rotation on the depth-adjustment handle, the planer's height adjusts 1/16". For example, 1/4 of a rotation is 1/64", 1/2 of a rotation is 1/32", and 1 full rotation is 1/16".

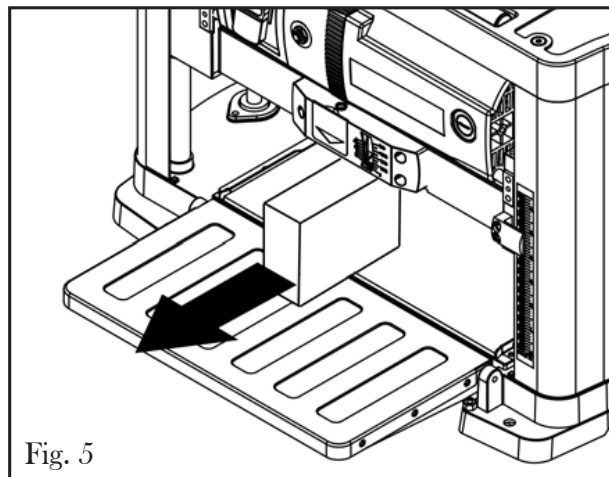


PREPARING THE TABLES (Fig. 3 - 5)

Lower the infeed and outfeed tables.



Remove the foam insert located between the main table and the blade drum (Fig. 5).



ASSEMBLY AND ADJUSTMENTS

ATTACH DUST CHUTE (Fig. 7)

Thickness planers are best used with the aid of a dust collector. To install the dust chute, simply mount it to the roller case using the two thumb screws (Fig. 7-1). The dust chute can be mounted in either direction to direct the flow of chips to either side of planer.

After mounting, connect wet/dry vacuum hose to dust chute. Be sure to turn the vacuum on before operating the planer.

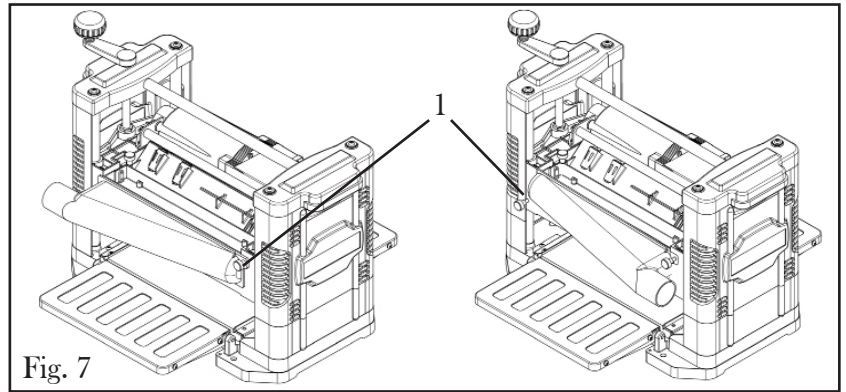


Fig. 7

NOTE: If you do not plan on using a dust collection system of any kind, we recommend removing the dust chute so that the wood chips and debris can fly freely from the back of the planer. This will however make a mess in your shop. The other option would be to leave it on and then regularly clean the wood out of the dust chute throughout operation. Any sort of damage caused by a lack of dust extraction or a buildup of wood chips voids the warranty. Maybe you should just get a dust collector.

MOUNT PLANER TO WORK SURFACE

The planer should always be mounted to a stable, level bench or table in a place with ample lighting. Make sure there is plenty of room for moving the workpiece through the entire cut. Neither the operators or the bystanders should have to stand in line with the wood while using the tool.

The base of the planer has four mounting holes. Mount the planer to the workbench or to the tool stand using bolts, flat washers and hex nuts (sold separately). Fig. 8 shows the base dimensions, mounting holes and required space to allow for installation to a work table. Securely mount the planer to the work table by bolting it through the holes. Fig. 9 shows the location of where the holes are located on each side of the planer. Make sure the planer does not rock and that the work table is level.

NOTE: We recommend the WEN 6588 Rolling Planer Stand for both stability and easy transportation around the workshop.

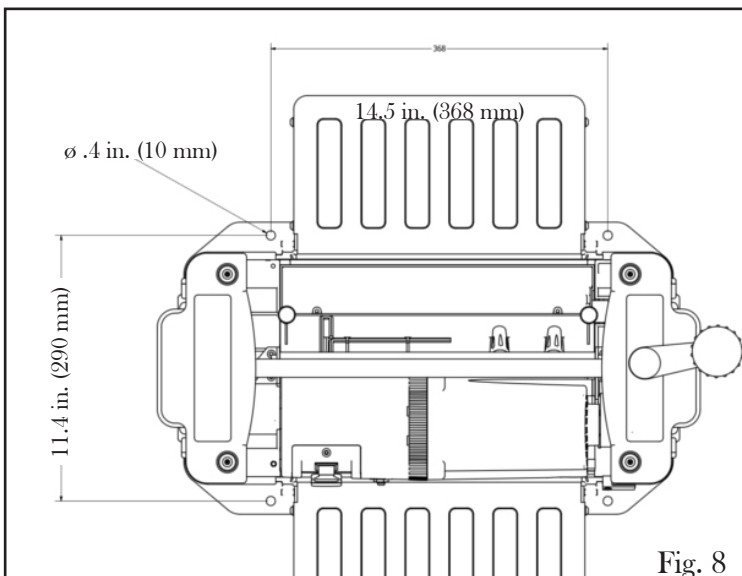


Fig. 8

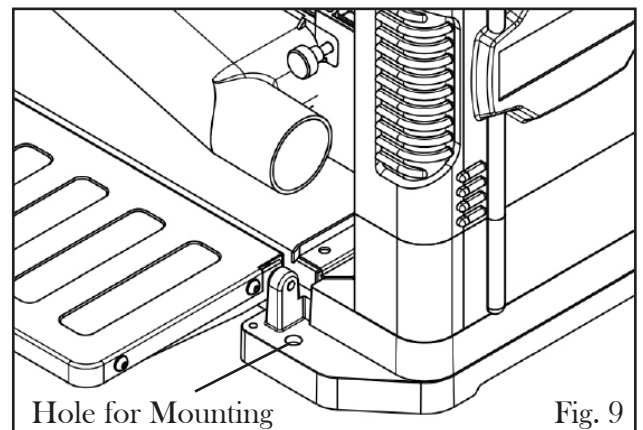


Fig. 9

OPERATION



WARNING: Do not connect planer to the power source until all assembly steps have been completed.

ON/OFF SWITCH (Fig. 10)

The ON/OFF switch is located on the front of the planer motor. To turn the planer ON, move the switch to the up position. To turn the planer OFF, move the switch to the down position.

SWITCH LOCK (Fig. 11)

Remove the red tab to engage child-safety lock and prevent unwanted start-ups. To lock the switch, turn the switch to OFF position and disconnect the planer from its power source. Pull the yellow portion of the key out. The switch cannot be turned on with the key removed. To turn the machine back on, slide the key into the slot on the switch until it snaps into place.

NOTE: The key can be removed from the switch while in the ON position. This allows for the device to be turned off but still prevents it from being turned back on.

AVOID DAMAGE TO BLADES

Thickness planers are a precision woodworking machine and should be used on quality lumber only. Do not plane dirty boards; dirt and small stones are abrasive and will wear out blade.



WARNING: REMOVE NAILS AND STAPLES. Use planer to cut wood only. Avoid knots. Heavily cross-grained wood makes knots hard. Knots can come loose and jam blade.



WARNING: Any article that encounters planer blades may be forcibly ejected from planer creating risk of injury. Make sure the wood is free from outside materials before attempting to plane.

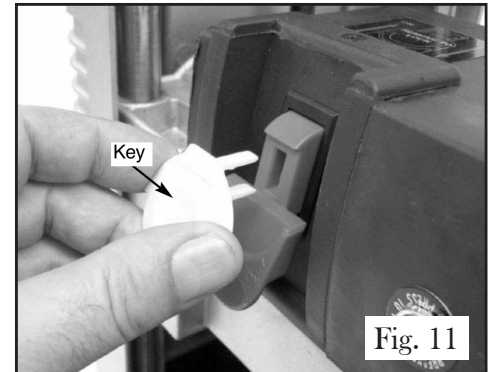
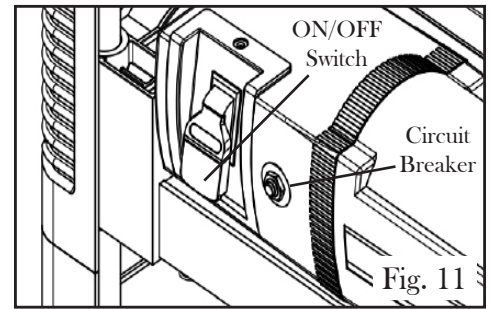
HEIGHT OF CUT (Fig. 12 - 2)

Rotate the crank handle to adjust the height of the cutterhead. The depth scale shows the height of the cutterhead above the main table. Quality of thickness planing depends on the operator's judgement about the depth of cut. Depth of cut depends on the width, hardness, dampness, grain direction and grain structure of the wood. Maximum thickness of wood which can be removed in one pass is 3/32" for planing operations.



WARNING: NEVER PLANE AGAINST THE GRAIN DIRECTION OF THE WOOD. DO NOT PLANE END GRAIN, AS THE WOOD COULD SPLINTER OR POSSIBLY EXPLODE.

CAUTION: Do not plane board which is less than 14-1/2" long; force of cut could split board and cause kickback.



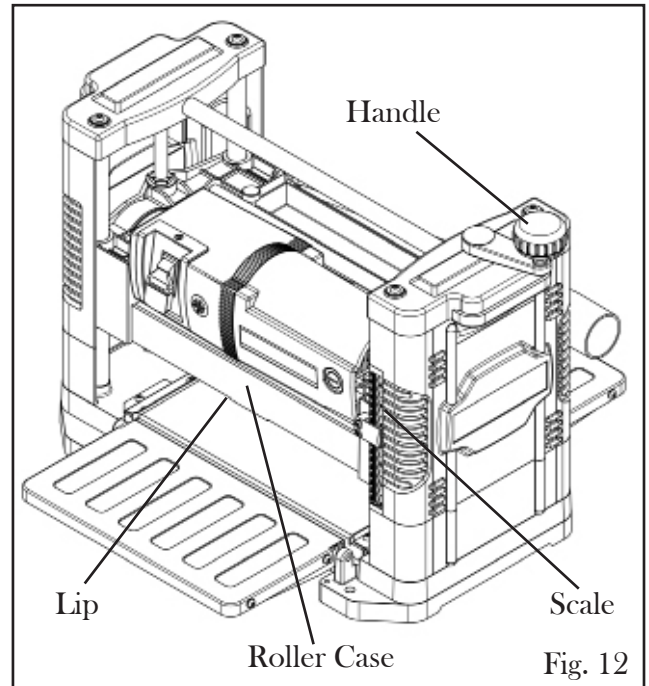
OPERATION

DEPTH OF CUT (Fig. 12)

The front of the roller case features a small $\frac{1}{16}$ " depth-limiting lip in the center of the cutterhead body in order to establish the maximum cutting depth as $\frac{1}{32}$ " instead of $\frac{3}{32}$ " for boards wider than $5\text{-}\frac{3}{4}$ ".

While the planer could handle a $\frac{3}{32}$ " cut on $12\text{-}\frac{1}{2}$ " wide boards, it will not only shorten the lifespan of the motor and cutting blades, but also will give an imperfect finish. The smaller the cutting depth, the better the finished product will be. It's best to give multiple passes on a piece of wood on a lower depth than it is to give a single pass on a higher depth.

Each full rotation on the depth-adjustment handle changes the height by $\frac{1}{16}$ ". For example, $\frac{1}{4}$ of a rotation is $\frac{1}{64}$ ", $\frac{1}{2}$ of a rotation is $\frac{1}{32}$ ", and 1 full rotation is $\frac{1}{16}$ ".



- The depth of cut should be less than $\frac{1}{32}$ of an inch. Run the board a few times before adding depth to ensure the best possible cuts.
- For optimum planing performance, the depth of cut should be less than $\frac{1}{64}$ of an inch per pass. Run the board a few times before adding depth to ensure the best possible cuts.
- Boards should be planed with shallow cuts until the work has a level side (or alternatively the use of a power jointer can be employed). Once a level surface has been created, flip the lumber and create parallel sides.
- Plane alternate sides until the desired thickness is obtained. When half of the total depth of cut is taken from each side, the board will have a uniform moisture content. Any additional drying should not cause it to warp.
- Depth of cut should be shallower when work is wider.
- When planing hardwood, make light cuts or plane the wood in thin widths.
- Make a test cut with a test piece and verify the thickness produced.
- Check accuracy of test cut prior to working on finished product.

OPERATION

PREPARE WORK

Thickness planers work best when at least one side of the lumber is flat. Use a surface planer or a jointer to create a flat surface. Twisted or severely warped boards can jam the planer and should not be used. Rip lumber in half to reduce magnitude of warp.

Work should be fed into the planer in same direction as the grain of the wood. Sometimes grain will change directions in middle of board. In such cases, if possible, cut board in middle before planing so grain direction is correct. **NEVER PLANE AGAINST THE GRAIN DIRECTION OF THE WOOD. DO NOT PLANE END GRAIN, AS THE WOOD COULD SPLINTER OR POSSIBLY EXPLODE.**

CAUTION: Do not plane board which is less than 14-1/2 inches long; force of cut could split board and cause kickback.

CHECK FOR WORN BLADES

Condition of blades will affect the precision of cuts. Observe the quality of the cut that the planer produces to check the condition of the blades. Dull blades will tear, rather than sever wood fibers and produce fuzzy appearances. Raised grain will occur when dull blades pound on wood that has varying density. Raised edges will also be produced where the blades have been nicked. Blades on this planer are reversible and should always be reversed or replaced as a matched set. Keeping a spare set of blades on hand is recommended. Replacement blades can be ordered from wenproducts.com

AVOIDING SNIPE

Thickness planers tend to leave a small bit of snipe at the end of the planed boards, particularly for longer workpieces. Snipe is a small dip that occurs from the weight of the board tilting downwards, thus pushing the other end of the board into the cutter head, creating an uneven finish. Snipe will occur when boards are not supported properly or when only one feed roller is in contact with the work at beginning or end of cut.

The best way of avoiding snipe is to cut your lumber long enough that you can saw off the snipe after the board has been planed. Leave 1-2" on both ends that can be later removed. Other less efficient ways include gently pushing the board up while feeding the work until the outfeed roller starts advancing it. Then, move to the rear and receive the planed board by gently pushing it up when the infeed roller loses contact with it. The third option is to have another dummy board flush against the beginning and end of the workpiece. That way, this piece of scrap wood will be the recipient of all of the snipe. Snipe is more apparent when deeper cuts are taken. Lower depths help prevent snipe.

It is also recommended to have the infeed and outfeed extension tables slightly inclined upwards to form a V shape, with the difference between the outermost edges of the extension tables and center of granite tables being about 1 mm.

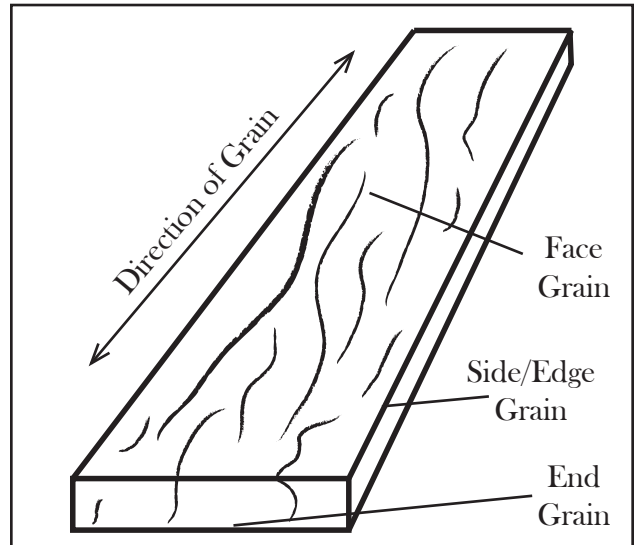
OPERATION

THE DO'S AND DONT'S OF GRAIN DIRECTION

It is important that the cutterhead always cuts in the same direction as the grain. There are six sides to every board: two face grains, two side/edge grains, and two end grains. Never plane with the end grain facing upwards. Only plane side and face grains. Otherwise, the board has a chance of splintering and exploding inside of the planer.

When planing side and face grain, always plane in the direction of the grain. Do not go against the grain, otherwise the board also has a chance of splintering and exploding.

WARNING: NEVER PLANE AGAINST THE GRAIN DIRECTION OF THE WOOD. DO NOT PLANE END GRAIN, AS THE WOOD COULD SPLINTER OR POSSIBLY EXPLODE.



FEEDING WORK

The planer is supplied with planing blades mounted in the cutterhead with the infeed and outfeed rollers pre-adjusted to the correct heights. The feed rate is automatic but will vary slightly depending on the type of wood (feed rate refers to the rate at which the lumber travels through the planer). To feed the workpiece:

1. Align the work perpendicular to the rollercase so that the work feeds through the planer straight, making sure that the board is travelling in the same direction as the grain and that you are only planing either side or face grain. Boards longer than 24" should have additional support from free standing material stands. Position the workpiece with the face to be planed on top.
2. Raise/lower rollercase to produce the depth of cut desired.
3. Stand on the side of the planer. Do not stand directly in front or behind the planer.
4. Turn the planer on and direct the board into the planer. Gently slide workpieces into the infeed side of the planer until the infeed roller advances the workpiece. Let go of the workpiece and allow the automatic feed to advance the board through the planer.
5. Do not push/pull on workpiece. Catch the planed lumber by grasping it in same manner as it was fed as it comes out the backside. Make sure not to stand directly behind the planer while catching fed lumber. Do not grasp any portion of board which has not gone past the out-feed roller.

CAUTION: To avoid risk of injury due to kickbacks, do not stand directly in line with the front or rear of planer.

6. Repeat as needed. Planer has return rollers on top so an assistant can pass the work back to operator. Keep in mind that multiple shallow cuts result in smoother surfaces than a single pass with a larger cutting depth.

NOTE: Assistant must follow same precautions as operator.

MAINTENANCE

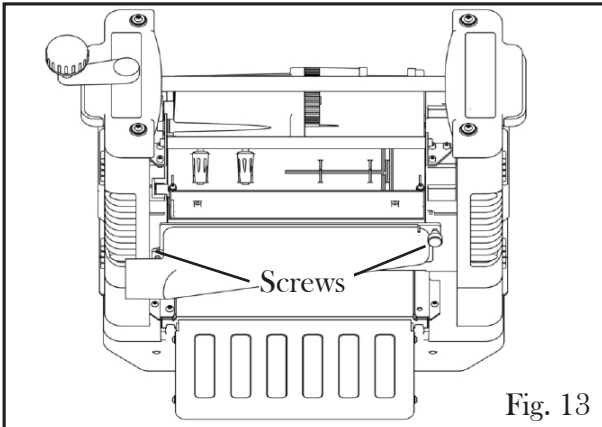


Fig. 13

CHANGING BLADES (Fig. 13 - 16)

FOR VIDEO INSTRUCTIONS VISIT:

<http://bit.ly/planerblades>

WARNING: Always turn the planer OFF and disconnect it from the power source before starting any maintenance work.

1. Remove the dust chute by unscrewing the thumb screws that are located in their opposing corners (Fig. 13).

2. Loosen and remove the two hex screws from the blade guard on the rear side of the cutterhead. Remove the blade guard (Fig. 14)

3. Press down on the red spindle release button located on the left side that allows the cutterhead to rotate properly. Rotate it until the six gib bolts are exposed and secure them in place. (Fig. 15).

4. Loosen and remove the six bolts from the gib (Fig. 15).

5. Remove the gib using the provided magnets.

CAUTION: Blade edges are extremely sharp. Keep fingers away from the blades at all times.

6. The blade is located in position by two pins. Gently lift the old blades from the cutterhead using magnets. Do not make contact with the blade using fingers. Use magnets only.

7. Reverse or replace blade and carefully position it on the two pins using magnets.

8. Replace the gib and align the holes on the gib with holes on the blade using the magnets.

9. Secure gib to cutterhead using six bolts removed earlier.

10. Replace the dust chute and secure it in place with the two thumb screws.

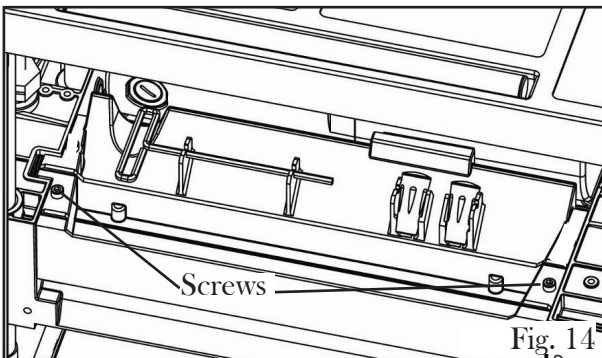


Fig. 14

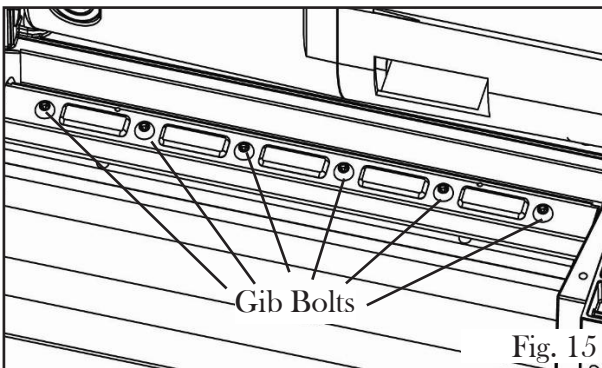


Fig. 15

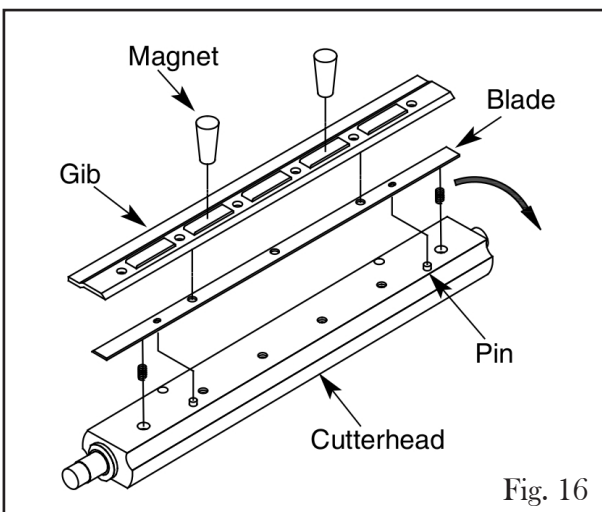


Fig. 16

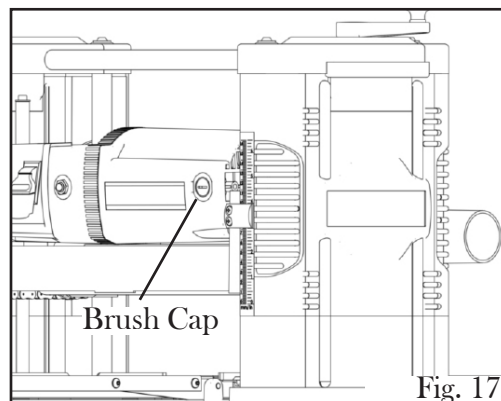
MAINTENANCE

WARNING: Turn planer off and disconnect from power source before performing any maintenance.

BRUSH INSPECTION AND REPLACEMENT (Fig. 17)

Brush life depends on the load of the motor. Regularly inspect brushes after 100 hours of use. Brushes are located on either side of the planer motor, on both the front and rear side of the planer.

Loosen brush cap and carefully remove brush from motor. Replace brushes if the spring is damaged. Replace brushes if the carbon is worn. Tighten brush caps after replacement.



ADJUSTING THE TABLE LEVEL

Small screws appear underneath either side of both the infeed and outfeed tables, directly next to the hinge. These screws can be adjusted to make sure the tables are exactly level with the main working table. Small adjustments can be made, using a test piece of wood for test cuts.

LUBRICATION

Motor and cutterhead bearings are sealed and need no lubrication. Gears and elevation screws should be cleaned of debris and greased as needed.

CLEANING THE PLANER

Keep planer clean of any wood chips, dust, dirt or debris. After 10 hours of operation, the chains and gears should have wood chips, dust and old grease removed. Use common automotive bearing grease to lubricate all chains and gears. Be sure all chains and gears have plenty of grease. Clean the granite table using a soft, damp cloth. Do not use any waxes, oils or solvents on the table.

TROUBLESHOOTING

ADJUSTING INFEED/OUTFEED EXTENSION TABLE

We recommend setting your infeed and outfeed tables so that the ends of the table extensions are approximately 1 to 2 mm above the top of the granite table.

1. Locate the table elevation adjustment screw and nut on both sides of the planer, next to the hinge (Fig. 18).
2. Raise the extension table to expose the screws (Fig. 19).
3. Using two 10 mm crescent wrenches or a suitable Phillips screwdriver, loosen the screw by holding the nut with a crescent wrench and turning the screw head counterclockwise.

NOTE: Keep track of the number of turns you apply to each screw. Make sure that both the left- and right-hand screws on the table are turned the same number of times.

4. When both screws are adjusted to the height you want the table to be, tighten down the nut against the base of the planer by holding the screw head with a crescent wrench or Phillips screwdriver and turning the nut clockwise. Repeat for the other screw.
5. Test the table height. If adjustments need to be made, repeat steps 3 to 4 as needed, ensuring that both screws have been turned the same number of times.
6. Repeat steps 1-5 on the other table until you are satisfied with the height.
7. Test the adjustments on a scrap piece of wood, making further adjustments as necessary until you are satisfied.



Fig. 18

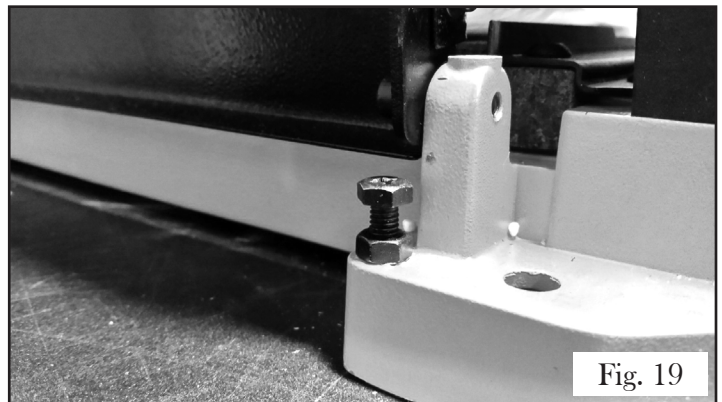


Fig. 19

TROUBLESHOOTING

IF THE MATERIAL DOES NOT FEED PROPERLY, CHECK FOR:

- dull blades: rotate or replace as necessary (refer to Changing Blades section).
- excess clogging in the dust hood (refer to Attach Dust Chute in the Assembly and Adjustments section).
- a broken V-Belt (refer to Replacing V-Belt in the Maintenance section).

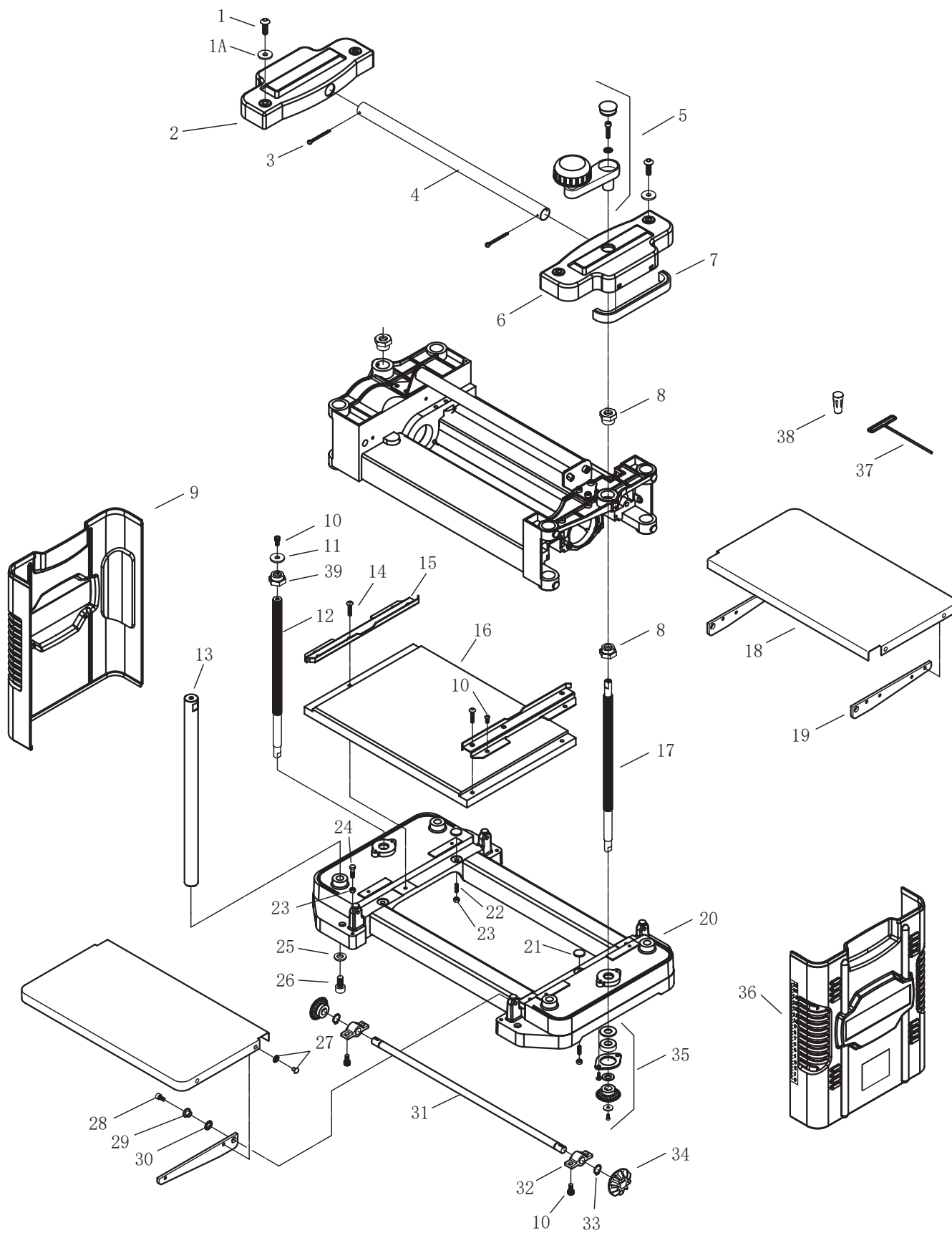
IF THE CIRCUIT BREAKER TRIPS REPEATEDLY:

- dull blades could be present. Dull blades can cause motor overloading. Rotate or replace as necessary (refer to Changing Blades section).
- reduce the depth of cut. An overly aggressive cut could cause motor overloading (refer to Depth of Cut in the Operation section)

IF THE UNIT DOES NOT RUN, CHECK TO SEE:

- if the unit is plugged in. Ensure unit is plugged into the appropriate outlet (refer to Electrical Information).
- if the circuit breaker needs to be reset.
- if the motor brushes are depleted. Replace as necessary (refer to Brush Inspection and Replacement under the Maintenance section).

EXPLODED VIEW AND PARTS LIST

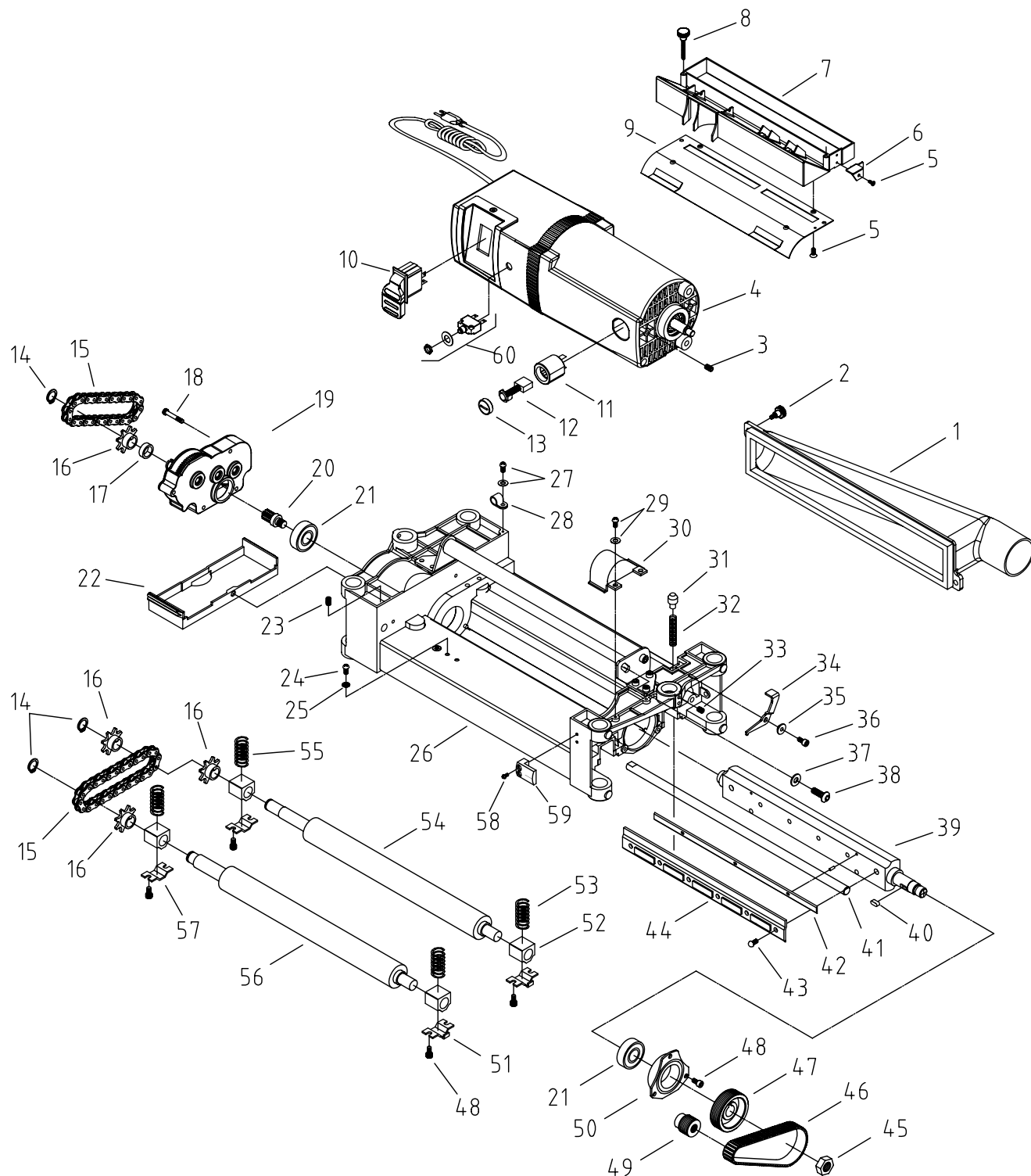


EXPLODED VIEW AND PARTS LIST

No.	Part No.	Description	Qty.
1	6550-101	Screw	4
1A	6550-101A	Flat washer 6	4
2	6550-102	Left Cap	1
3	6550-103	Cotter Pin	2
4	6550-104	Roller	1
5	6550-105	Handle Assembly	1
6	6550-106	Right Cap	1
7	6550-107	Grip	2
8	6550-108	Elevating Nut (RH)	2
9	6550-109	Left Side Cover	1
10	6550-110	Bolt	9
11	6550-111	Spacer	1
12	6550-112	Elevating Screw (LH)	1
13	6550-113	Column	4
14	6550-114	Screw	3
15	6550-115	Guide	2
16	6550-116	Table	1
17	6550-117	Elevating Screw (RH)	1
18	6550-118	Extension Table Assembly	2
19	6550-119	Table Support	4

No.	Part No.	Description	Qty.
20	6550-120	Base	1
21	6550-121	Plate	3
22	6550-122	Set Screw	3
23	6550-123	Nut	4
24	6550-124	Adjustment Screw	4
25	6550-125	Lock Washer 10	4
26	6550-126	Bolt	4
27	6550-127	Screw with washer	8
28	6550-128	Screw	4
29	6550-129	Bushing	4
30	6550-130	Wavy Washer	4
31	6550-131	Shaft	1
32	6550-132	Support	2
33	6550-133	Retaining Ring	2
34	6550-134	Bevel Gear	4
35	6550-135	Elevation Screw Bearing Assembly	2
36	6550-136	Right Side Cover	1
37	6550-137	Wrench	1
38	6550-138	Magnet	2
39	6550-139	Elevating Nut (LH)	2

EXPLODED VIEW AND PARTS LIST



EXPLODED VIEW AND PARTS LIST

No.	Part No.	Description	Qty.
1	6550-201	Dust Exhaust Port	1
2	6550-202	Thumb Screw	2
3	6550-203	Set Screw	2
4	6550-204	Motor Assembly	1
5	6550-205	Screw	4
6	6550-206	Push Plate	1
7	6550-207	Dust Chute	1
8	6550-208	Thumb Screw	2
9	6550-209	Chute Plate	1
10	6550-210	Switch W/ Key	1
11	6550-211	Brush Holder	2
12	6550-212	Brush (Set Of 2)	1
13	6550-213	Brush Cap	2
14	6550-214	Retaining Ring	3
15	6550-215	Chain	2
16	6550-216	Sprocket	4
17	6550-217	Spacer	1
18	6550-218	Bolt	4
19	6550-219	Gearbox Assembly	1
20	6550-220	Pinion	1
21	6550-221	Ball Bearing 6203ZZ	2
22	6550-222	Cover	1
23	6550-223	Set Screw	1
24	6550-224	Screw	2
25	6550-225	Washer 5	2
26	6550-226B	Rollercase	1
27	6550-227	Screw With Washer	1
28	6550-228	Cord Clamp	1
29	6550-229	Screw With Washer	2
30	6550-230	Belt Guard	1

No.	Part No.	Description	Qty.
31	6550-231	Plunger	1
32	6550-232	Spring	1
33	6550-233	Set Screw	4
34	6550-234	Cutterhead Lock	1
35	6550-235	Spacer	1
36	6550-236	Screw	1
37	6550-237	Flat Washer (N8)	1
38	6550-238	Bolt	1
39	6550-239	Cutterhead	1
40	6550-240	Key 5 X 5 X 12	1
41	6550-241	Rod	1
42	6550-242	Blade (Set Of 2)	1
43	6550-243	Locking Bolt	12
44	6550-244	Gib	2
45	6550-245	Nut	1
46	6550-246	Belt	1
47	6550-247	Cutterhead Pulley	1
48	6550-248	Bolt	11
49	6550-249	Motor Pulley	1
50	6550-250	Bearing Retainer	1
51	6550-251	RH Retainer	2
52	6550-252	Bearing Block	4
53	6550-253	RH Spring	2
54	6550-254	Outfeed Roller	1
55	6550-255	LH Spring	2
56	6550-256	Infeed Roller	1
57	6550-257	LH Retainer	2
58	6550-258B	Screw, M5	2
59	6550-259B	Depth Indicator, M5 Holes	1
60	6550-260	Circuit Breaker	1

LIMITED TWO YEAR WARRANTY

WEN Products is committed to building tools that are dependable for years. Our warranties are consistent with this commitment and our dedication to quality.

LIMITED WARRANTY OF WEN CONSUMER POWER TOOLS PRODUCTS FOR HOME USE

GREAT LAKES TECHNOLOGIES, LLC (“Seller”) warrants to the original purchaser only, that all WEN consumer power tools will be free from defects in material or workmanship for a period of two (2) years from date of purchase. Ninety days for all WEN products, if the tool is used for professional use.

SELLER’S SOLE OBLIGATION AND YOUR EXCLUSIVE REMEDY under this Limited Warranty and, to the extent permitted by law, any warranty or condition implied by law, shall be the repair or replacement of parts, without charge, which are defective in material or workmanship and which have not been misused, carelessly handled, or misrepaired by persons other than Seller or Authorized Service Center. To make a claim under this Limited Warranty, you must make sure to keep a copy of your proof of purchase that clearly defines the Date of Purchase (month and year) and the Place of Purchase. Place of purchase must be a direct vendor of Great Lakes Technologies, LLC. Third party vendors such as garage sales, pawn shops, resale shops, or any other secondhand merchant void the warranty included with this product. Contact techsupport@wenproducts.com or 1-800-232-1195 to make arrangements for repairs and transportation.

When returning a product for warranty service, the shipping charges must be prepaid by the purchaser. The product must be shipped in its original container (or an equivalent), properly packed to withstand the hazards of shipment. The product must be fully insured with a copy of the warranty card and/or the proof of purchase enclosed. There must also be a description of the problem in order to help our repairs department diagnose and fix the issue. Repairs will be made and the product will be returned and shipped back to the purchaser at no charge.

THIS LIMITED WARRANTY DOES NOT APPLY TO ACCESSORY ITEMS THAT WEAR OUT FROM REGULAR USAGE OVER TIME INCLUDING BELTS, BRUSHES, BLADES, ETC.

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