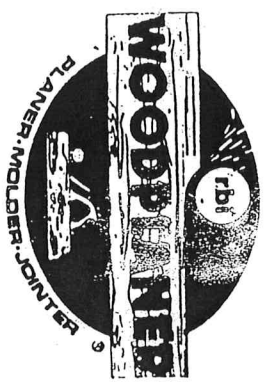
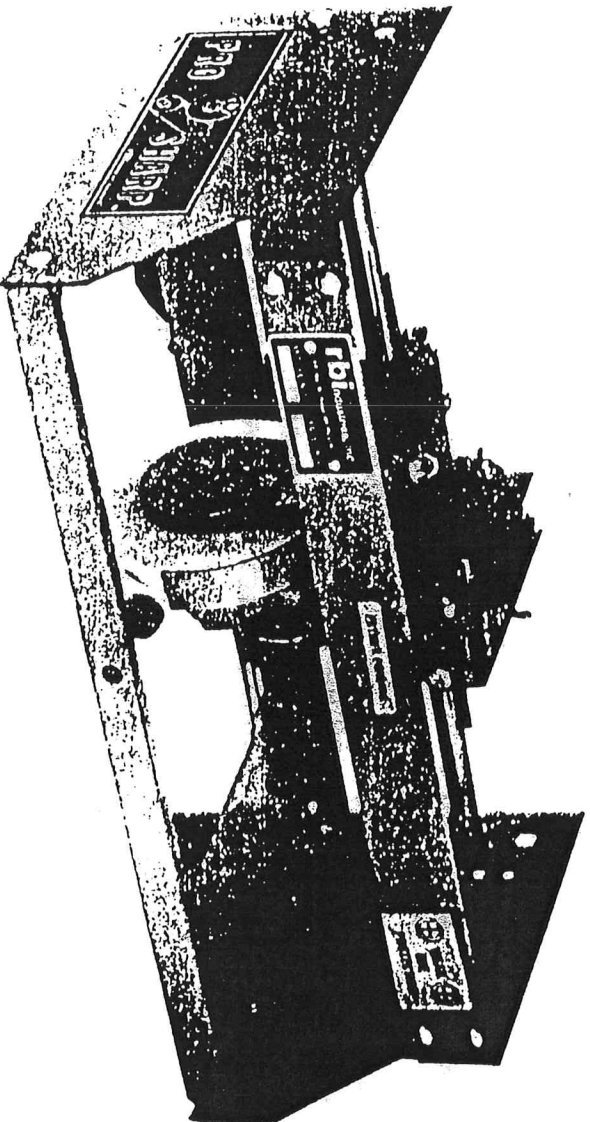


# rbj



# Pro-Sharp™



Patent Pending



**READ THOROUGHLY BEFORE  
OPERATING**



PS #0183

# WARRANTY

We guarantee each R.B.I. Pro-Sharp to be free from defects in material and workmanship for 1 year from date of delivery to original user. This warranty does not cover damage sustained in transit, normal wear or from misuse of this piece of equipment.

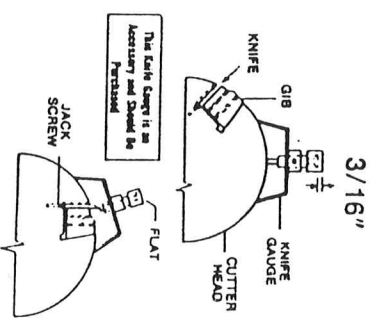
This warranty does not obligate us to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts, nor shall it apply to any planer upon which repairs or alterations have been made unless authorized by us.

We make no warranty in respect to components, not of our manufacture, including motors, such being subject to the warranties of their respective manufacturers.

We shall in no event be liable for consequential damages or contingent liabilities arising out of the failure of any Pro-Sharp to operate properly. No express, implied or statutory warranty other than herein set forth is made or authorized to be made by us.

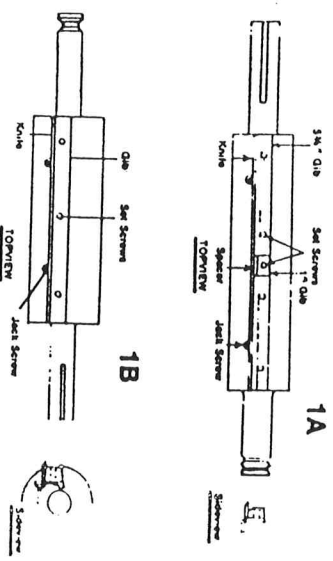
## PRO-SHARP INSTALLATION

1. Disconnect Electrical Source.
2. Remove Hood or Jointer
3. Clean the cutterhead and knives of all gum and resin material. Alcohol, paint thinner, turpentine or kerosene are used. **CAUTION:** The use of cleaning materials is dangerous. Follow the label instructions of the manufacturer when using.
4. Adjust knife height to 3/16".



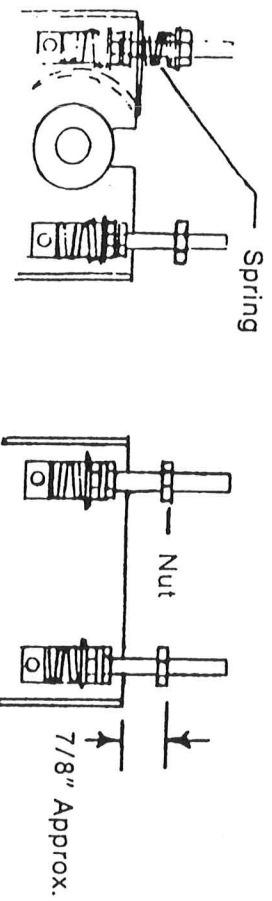
## PLANER KNIFE ADJUSTMENT

- (A) Loosen all set screws in one cutterhead gip slot 1/4".
- (B) Tap gibs down in the cutterhead slot.
- (C) Remove and clean the knife, gibs and slot.
- (D) Replace the gibs in the slot and slide in the knife.
- (E) Adjust the gibs up to just hold the knife in place. Using the two jack screws, raise the knife to 3/16" the complete length of the knife.
- (F) Tighten the gip set screws, checking to be sure knife doesn't rise as it is tightened.
- (G) Repeat for the remaining two knives.

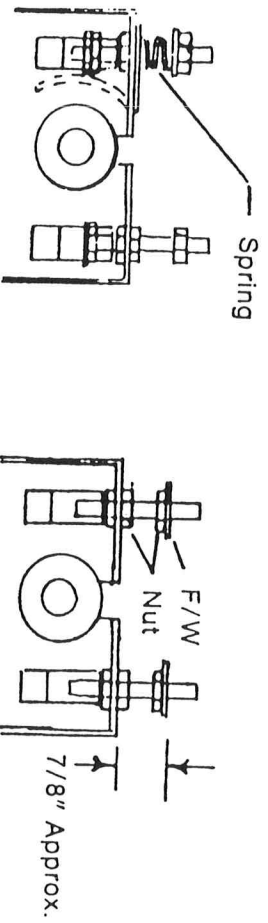


## PLANER PREPARATION

**MODEL 408**  
REMOVE THE  
CHIPBREAKER  
AND ATTACHING  
SPRINGS, ETC.



**MODEL 612**  
REMOVE THE  
CHIPBREAKER  
AND ATTACHING  
SPRINGS, ETC.

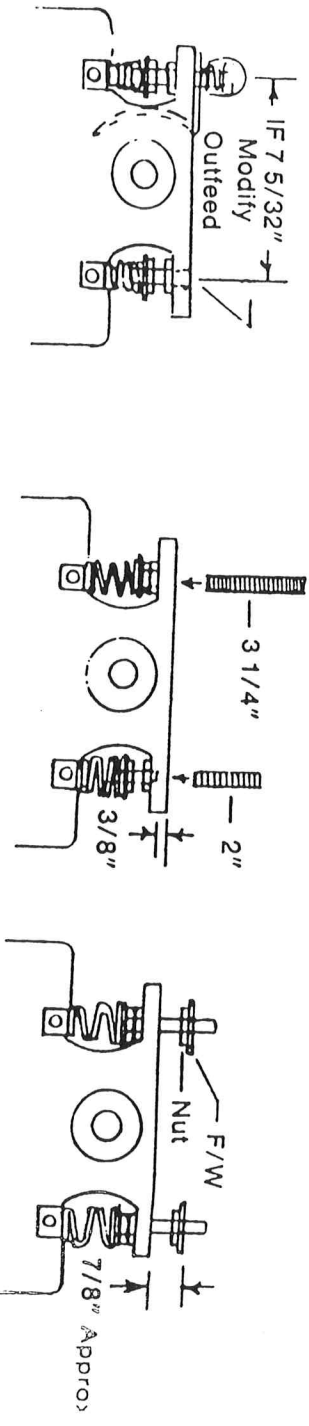


**BELSAW 910,912,**

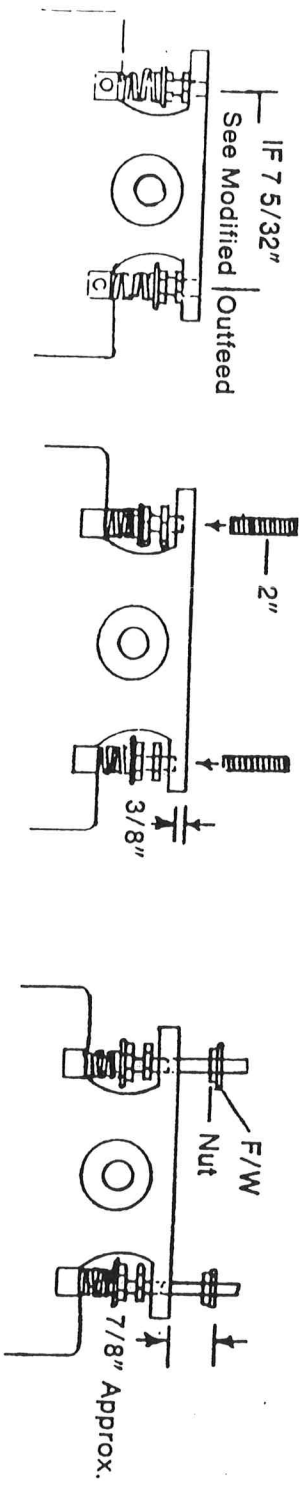
**SEARS 306,233900**

**FOLEY 344,**

IF YOUR PLANER LOOKS LIKE THIS REMOVE RUBBER TIP, BOLT, SPRING AND CHIPBREAKER. REPLACE WITH THE 3/4" STUDS. SCREW DOWN THE OUTFEED SOCKET HEAD STUDS 3/8", ADD THE 2" STUDS WITH NUTS AND FLAT WASHERS.



IF YOUR PLANER LOOKS LIKE THIS SCREW DOWN THE SOCKET HEAD SET SCREWS 3/8", ADD THE 2" STUDS WITH NUTS AND F/W'S

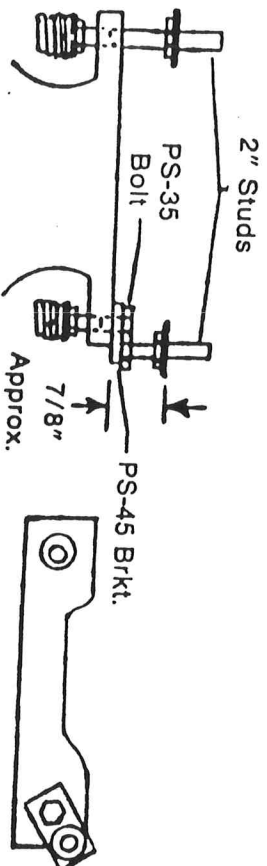
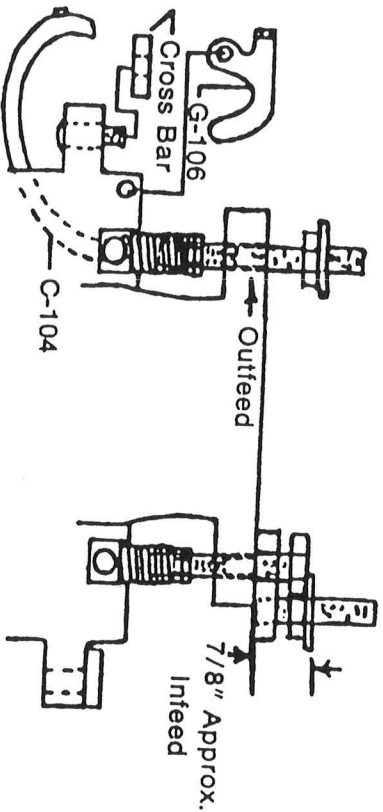
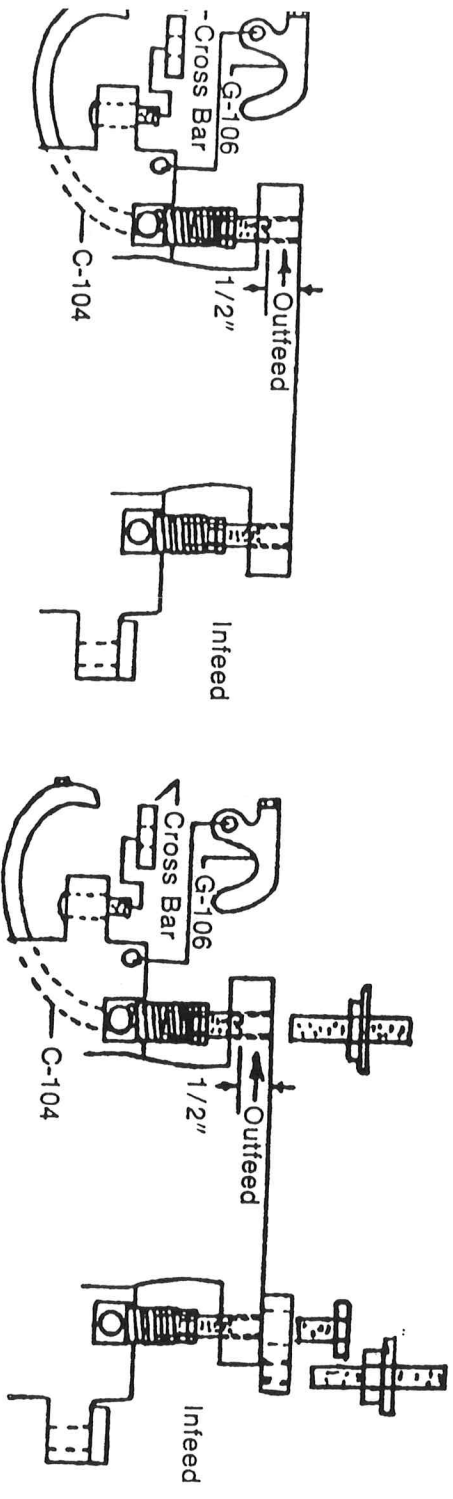


MODIFICATION ON PLANERS WITH 7 5/32" DIMENSION  
 MODIFY OUTFEED SIDE ONLY WITH PS-45 BRACKET, PS-35 BOLT

### BELSAW MODEL 905 PLANER

Screw down all four feed roller tension spring studs 1/2" or more. **CAUTION:** (Do not screw out the bottom). Remove the pressure bar (G-106) and attaching

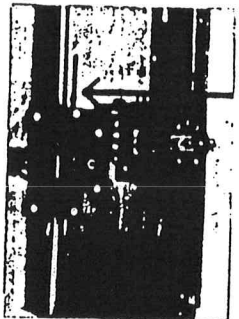
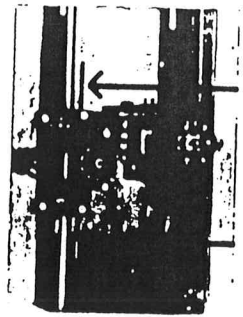
hardware. Remove the rear, outfeed, cross bar. This will allow hinging back of the chipbreaker shield (C-104) for access to the cutterhead.



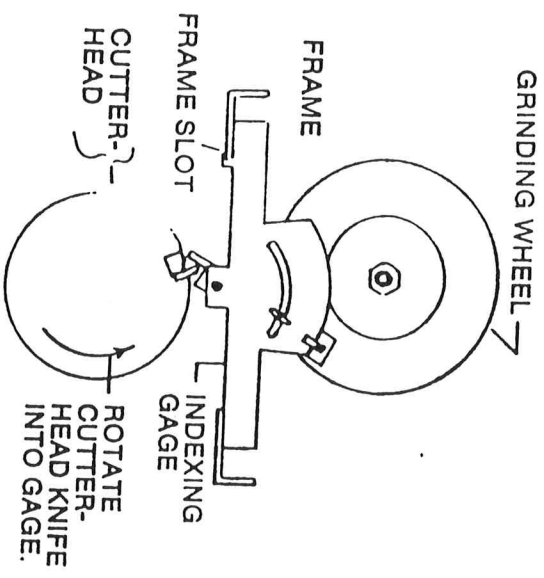
FOR PLANERS WITH 7 5/32" BETWEEN THE FEED ROLLER TENSION STUDS



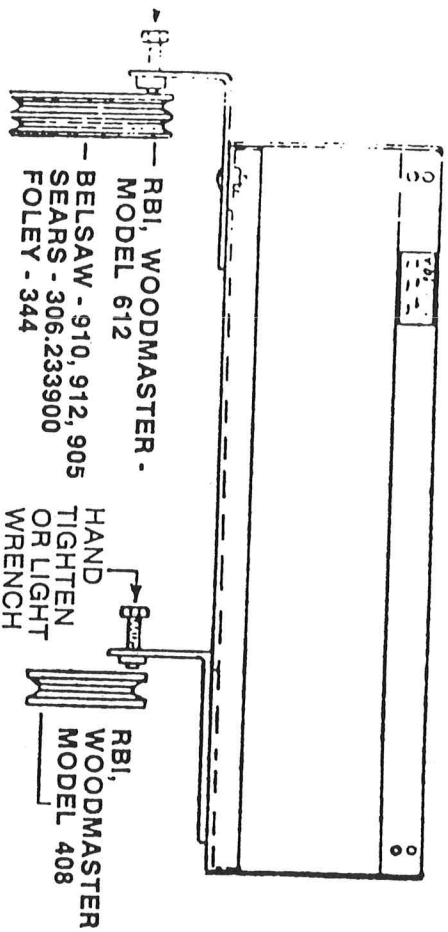
D. Adjust the limit rod or rods to allow the grinding wheel to travel the complete length of the knife and lock in place.



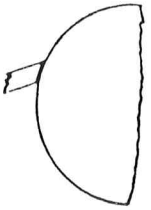
E. Set the indexing gage (PS-40) at 30° and slide into place in the frame notch. Rotate the cutterhead until the knife contacts the gage. See Figure



F. Tighten the head hold bracket set screw to hold the cutterhead in position. Remove the indexing gage. Mark the Knife as #1.



G. Lower the grinding wheel turning the adjusting stud C.C.W. until it contacts the knife. Slide the unit back and forth across the knife and adjust to just touch the knife. Clearance should be within .015" side to side. Note the adjustments. See Figure. Turn the adjusting stud C.W. three full turns.



Dial Reading

KNIFE #1 .020

I. Repeat E & F & G and label knife #2.

Dial Reading  
KNIFE #1 .020  
KNIFE #2 .050

I. Repeat E, F & G and label Knife #3

KNIFE #1 .020 ← LOWEST KNIFE  
KNIFE #2 .050  
KNIFE #3 .045 GRIND FIRST

J. Note the knife which is lowest and this is the knife to be ground first.

K. Repeat E, F & G, Except this time, adjust the grind wheel down until just clears the knife.

L. Connect Electrical Source and turn grinder on

M. Lower the grinding wheel into the knife and move across the knife several times.

N. Lower the grinder down .005 on gage at a time and move across the knife several times. Continue until entire knife edge has been ground. NOTE dial setting for depth of grind for other two knives.

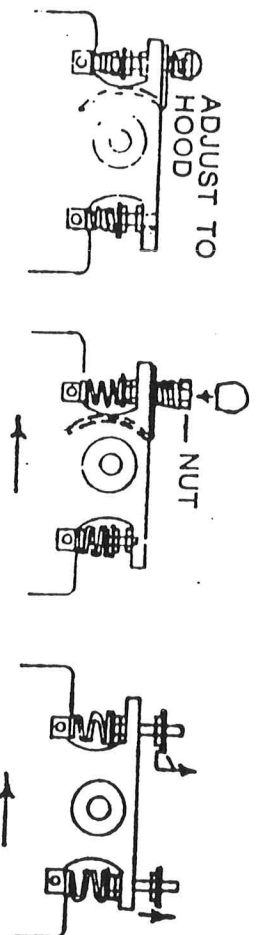
O. Repeat K, M & N and grind to the same dial setting as noted in "N" for the two remaining knives.

## PRO-SHARP REMOVAL

P. Remove the Pro-Sharp from the machine.

Q. Debur the back of the knife (Use a hone to remove the burr from the back of the knife). Reverse planer preparation steps for replacing chipbreaker assembly, hood for the RBI and Woodmaster 408 and 612; Belsaw 910-912 with the chipbreaker on the hood and Belsaw 905.

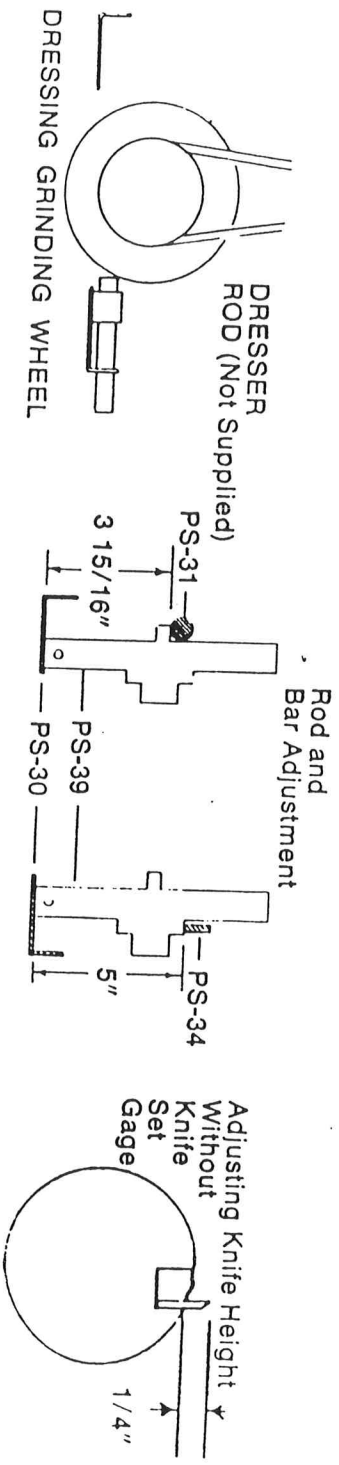
For Belsaw 910 & 912 with the chipbreaker on the bearing housing, follow the reverse procedure except leave in the 3-1/4" stud and replace the chipbreaker and spring with a nut on top. Adjust tension on the infeed and outfeed rollers and install rubber tip over the nut.



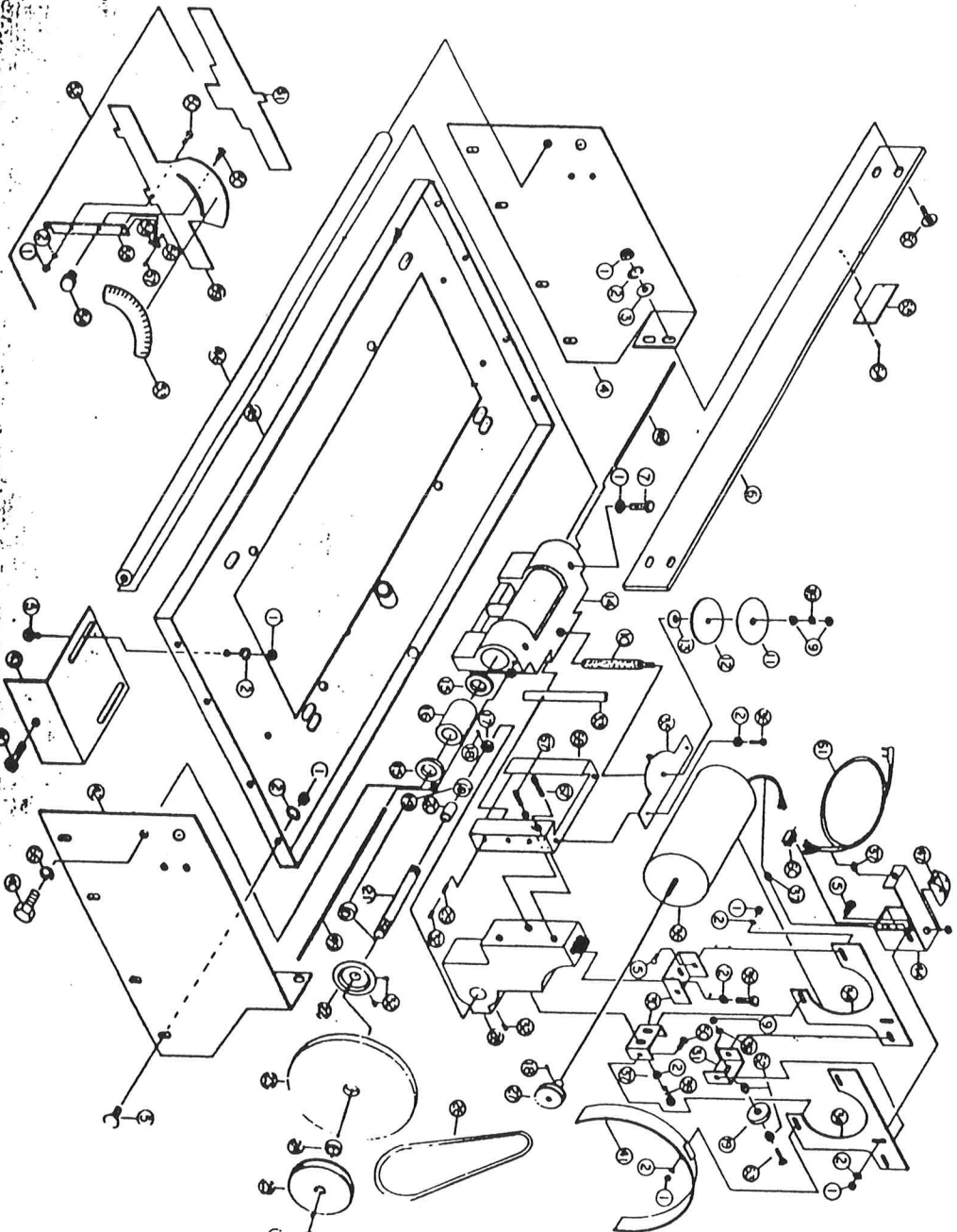
LEAVE 3-1/4" STUD IN PLACE OF BOLT FOR CHIPBREAKER MOUNTING

## GRINDING HINTS

1. Constantly move the grinder back and forth across the knife to keep from getting the knife hot and burning it.
2. Do not take too big of a cut and overload the motor. .005" maximum.
3. The grinding wheel will require dressing from time to time to assure even outside diameter roundness.
4. If the grind wheel, after dressing and proper mounting using PS-39 Gauge, does not slide parallel to the cutterhead, use the PS39 Gauge to check the PS-31 Shaft and PS-34 Top Support Bar to see if they are parallel to the bases. Adjust the sides (PS-02 or PS-25) to set.
5. If you do not have a knife set gauge, adjust your knives to illustration below. **CAUTION:** Use your judgment as to the amount of knife held in the cutterhead for additional knife advancement and knife replacement.



KEY PART NO.	DESCRIPTION	NUMBER REQUIRED	KEY PART NO.	DESCRIPTION
1.	RBZ-208 1/4-20 Hex Nut	25	35.	PS-22 Adj. Mount Plate
2.	RBZ-207 L/W 1/4"	25	36.	PS-23 Motor
3.	RB-177 F/W 1/4"	4	37.	RB-101 Strain Relief Bushing
4.	PS-02 LH Side	1	38.	PS-43 1/4"-20 x 3/4" Hex Bolt
5.	RB-99 1/4 x 1/2 Carriage Bolt	13	39.	RZ-178 5/16" L/W
6.	PS-34 Top Support Bar	1	40.	RZ-63 3/8"-16 x 1" Hex Hd Bolt
7.	PS-52 1/4"-20 x 1" Hex Bolt	4	41.	PS-24 Guard, Grind Wheel
8.	RZ-68 1/2"-13 Hex Nut	1	42.	PS-25 R.H. Side
9.	RZ-81 5/16" Hex Nut	3	43.	PS-26 Head Hold Bracket
10.	PS-37 1/2"-20 Thd. Stud	1	44.	PS-51 Base
11.	PS-01 Depth Decal	1	45.	PS-30 Switch Mount
12.	PS-03 Decal Mounting Bracket	1	46.	RB-111 Shaft
13.	RB-150 5/16" F/W	2	47.	RB-31 4-3/4" Lock
14.	PS-04 Rod Carrier Casting	1	48.	PS-32 4-3/4" Stod Model (ALL)
15.	PS-05 Seals	4	49.	PS-33 7-7/8" Stop Model (408 Only)
16.	PS-06 Linear Ball Bushing	2	50.	PS-29 1/4-20 x 3/4" Carriage Bolt
17.	PS-53 #10-32 Allen S/S	1	51.	PS-39 Mounting Gage
18.	PS-28 1/2"-32 Allen S/S	2	52.	PS-40 Cutterhead Indexing Gage Assy.
19.	PS-07 Ball Bearing	3	53.	RB-512 Degree Label
20.	PS-08 Bearing Spacer	1	54.	RB-507 Knob
21.	PS-09 Arbor Shaft	1	55.	PS-41 Cutterhead Indexing Knife Gage Bracket
22.	PS-10 Grinding Wheel Face	1	56.	RB-107 10-32 Nut
23.	PS-11 Grinding Wheel	1	57.	RB-106 Pointer
24.	PS-12 Bushing	1	58.	PS-42 Cutterhead Indexing Gage Bracket
25.	PS-13 Pulley	1	59.	PS-44 Switch
26.	PS-14 Motor Pulley	1	60.	PS-44 Plug-in Cord
27.	PS-15 Motor Mounting Housing	1	61.	RB-53 Bearing Support Spacer
28.	PS-16 1/4-20 Cone Point Allen S/S	3	62.	PS-48 #4 U-Drive Screw
29.	RB-403 Motor Mount Attaching Bracket	2	63.	RZ-181 Serial Tag
30.	PS-48 Bearing Mount Front Support	1	64.	RZ-52 L/W 3/8
31.	PS-49 1/4-20 Allen S/S	6	65.	PS-36 Screw
32.	RZ-83 Adj. Guide Dove Tail	1	66.	RZ-71 Adj. guide dove tail
33.	PS-20 Motor Bracket	2	67.	PS-17 2" Stop
34.	PS-47	1	68.	PS-55





**HOW AND WHERE TO ORDER REPLACEMENT PARTS AND ACCESSORIES  
TO SPEED DELIVERY AND REDUCE ERROR OF REPLACEMENT PARTS,  
ALWAYS INCLUDE THE FOLLOWING INFORMATION:**

1. Give the complete identification of the machine.
  - A. Machine Name .....
  - B. Model Number .....
  - C. Serial Number .....
2. Give the identification of the part.
  - A. Part Number .....
  - B. Part Name .....
  - C. If necessary, return the old part as a sample.

3. Give us an address to return the part to

Ship to: .....  
Your Name (Please Print) .....

Address .....  
Street ..... P. O. Box ..... Rural Route .....

City .....

State ..... Zip .....

Country .....

4. Send your order to:

**rbi**Industries, inc.

201 First Street • Pleasant Hill, Mo. 64080  
PHONE:  
(816) 987-2121



**rbi**industries, inc.

201 First Street • Pleasant Hill, Mo. 64080

PHONE:

(816) 987-2121