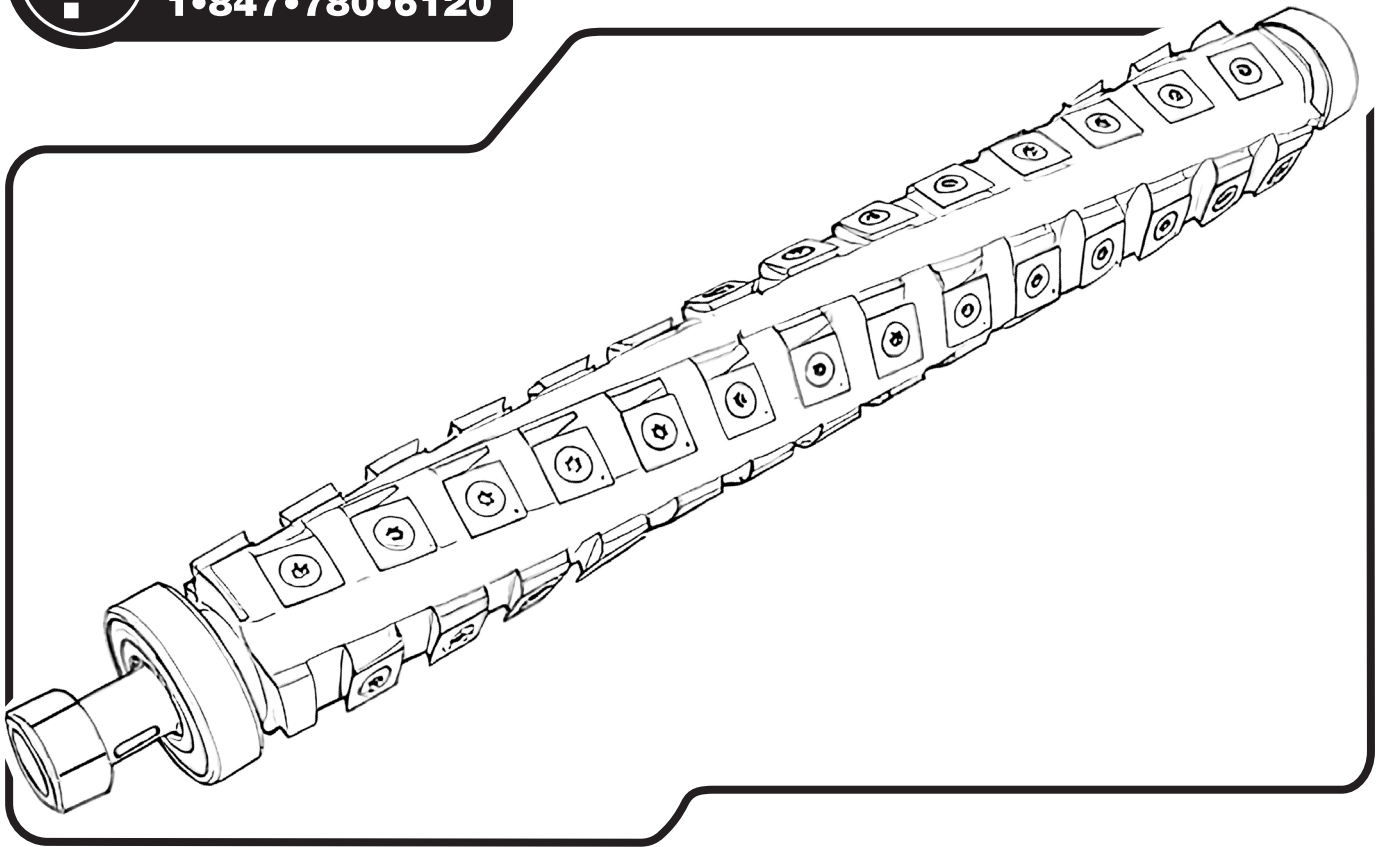


Owner's Manual

POWERTEC®

13" Helical Cutterhead



Visit us on the web at www.powertecproducts.com

You will need this manual for safety instructions, operating procedures, and warranty. Put it and the original sales invoice in a safe, dry place for future reference.

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PRODUCT SPECIFICATIONS

Carbide inserts 15 x 15 x 2.5mm

Usage: POWERTEC 72432 13" Helical Cutterhead is designed to replace the Straight-knife Cutterhead for DEWALT* DW735 and DW735X Planers.

** DEWALT is a trademark of The Black & Decker Corporation.*

WARNING

For your own safety, read and understand all warnings and operating instructions before using any tool or equipment.

WARNING

It is the responsibility of the purchaser of this product to ensure that any person using this product reads and complies with all instructions and safety precautions outlined in this instruction manual and the operating manual of the tool being used prior to use.

WARNING

Failure to follow these rules may result in serious personal injury. Remember that being careless for even a fraction of a second can result in severe personal injury.

WORK PREPARATION

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of the tool.
- Nonslip protective footwear is recommended.
- Wear protective hair covering to contain long hair.
- Wear eye and hearing protection. Always use safety glasses. Eye protection equipment should comply with ANSI Z87.1 standards. Hearing equipment should comply with ANSI S3.19 standards.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications known to cause drowsiness.

WORK AREA PREPARATION

- Keep work area clean. Cluttered work areas and benches invite accidents.
- Work area should be properly lighted.
- Do not use the Planer in a dangerous environment.
- The use of power tools in damp or wet locations or in rain can cause shock or electrocution.
- Three-prong electrical plug should be plugged directly into properly grounded, three-prong receptacle.
- Use a proper extension cord. Make sure your extension cord is in good condition and should have a grounding prong and the three wires of extension cord should be of the correct gauge.
- Keep children and visitors away. Your shop is a potentially dangerous environment. Children and visitors can be injured.
- Make your workshop childproof with padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.

TOOL MAINTENANCE

- Turn the Planer **OFF**, and disconnect the Planer from the power source prior to inspection.
- Maintain all tools and Planers in peak condition. Keep tools sharp and clean for best and safest performance.
- Follow instructions for lubricating and changing accessories.
- Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect tool's operation.
- Poorly maintained tools and Planers can further damage the tool or Planer and/or cause injury.
- A guard or any other part that is damaged should be repaired or replaced. Do not perform makeshift repairs.

TOOL OPERATION

- Avoid accidental start-up. Make sure that the tool is in the **OFF** position before plugging in.
- Use the right tool for your job. Do not force your tool or attachment to do a job for which it was not designed.
- Disconnect tool when changing parts.
- Don't force the workpiece on the Planer. Damage to the Planer and/or injury may result.
- Never leave tool running unattended. Turn the power off and do not leave tool until it comes to a complete stop.
- Do not overreach. Loss of balance can make you fall into a working Planer, causing injury.
- Never stand on tool. Injury could occur if the tool tips, or if you accidentally contact the cutting tool.
- Know your tool. Learn the tool's operation, application and specific limitations before using it.
- Use recommended accessories. Use of improper accessories may cause damage to the Planer or injury to the user.
- Handle workpiece correctly. Keep hands away from moving parts.
- Turn tool off if it jams.

CAUTION

Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

WARNING

Do not attempt to operate tool until it is completely assembled according to the instructions.

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE



CONTENTS

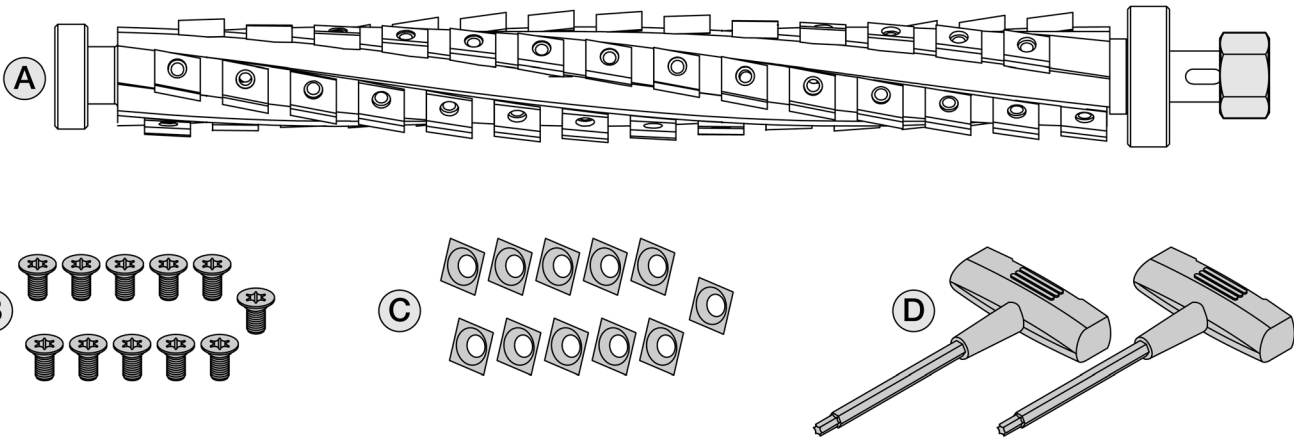
UNPACKING CONTENTS

NOTE: Check for shipping damage. Check immediately whether all parts and accessories are included. Please contact the customer service center at 1-847-780-6120.

ITEM	DESCRIPTION	QTY
A	13" Helical Cutterhead	1
B	Flat Head Torx Screws T-20 M5x12	61
C	Inserts 15 x 15 x 2.5mm	61
D	T-Handle Torx Driver T-20	2

Tools Needed (not included)

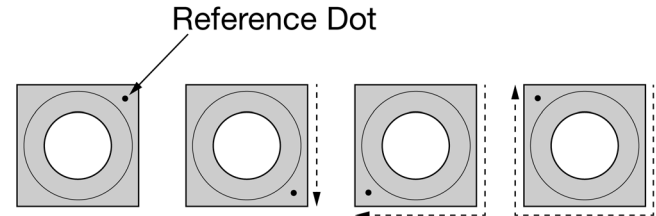
6mm Socket with Ratchet	1
24mm Socket with Ratchet	1
10mm Socket with extension	1
Retaining Ring Pliers (Internal—capable of removing both large and small retaining rings)	1
4mm Hex Wrench	1
Torx Driver T-30 (Included with DW735/X)	1
5mm Hex Wrench	1
Screwdriver	1
Steel or Dead Blow Hammer	1
Heavy Leather Gloves	1 Pair
Wood Board (Minimum 16mm thick)	1



CUTTERHEAD FEATURES:

The product is equipped with 56 indexable carbide inserts. Each insert has four cutting edges and can be rotated to expose a new edge. If one edge becomes dull or damaged, simply rotate the insert 90° to reveal a fresh cutting edge.

Each insert has a reference dot on one corner. As you rotate the insert, the position of the reference dot indicates which edges have been used and which remain new. When the reference dot returns to its original position, the insert should be replaced.



NOTE: POWERTEC is not responsible for any damage caused by improper installation of the Cutterhead. Please check with the manufacturer of your planer before installing as it may void your warranty.

SAFETY PRECAUTIONS

! WARNING

For your own safety, read the entire operating manual and safety instructions of the tool being used prior to use.

- Be aware of general power tool safety. Make sure all the safety rules are understood.
- Disconnect the Planer from power source whenever adjusting or replacing any parts.
- Do not plug Planer in unless switch is in the **OFF** position.
- Keep hands away from all moving parts.
- Ensure all adjustable parts are free from interference.
- Keep blades sharp, aligned and properly installed on Cutterhead.
- Properly secure the blades on the Cutterhead.
- Never turn the Planer **ON** with the workpiece contacting the Cutterhead.
- Do not force cut. Slowing or stalling will overheat the motor.
- Properly support long or wide workpieces.
- To prevent kickback: Never use a workpiece that is warped, contains knots, or embedded nails, staples, metal, etc.
- Do not feed a workpiece into the Planer outfeed table.
- Do not allow anyone to stand or cross in line of Cutterhead rotation. Kickback or thrown debris will travel in this direction.
- Turn switch **OFF**—disconnect power when Planer is not in use.
- Keep Planer maintained. Follow maintenance instructions.



FOR USE WITH: DEWALT DW735 AND DW735X PLANER

WARNING

Risk of personal injury. Turn off the planer and disconnect from power source before removing and installing the Cutterhead.

Blow or brush off the wood chips or debris from the planer and clean the floor around the machine to help eliminate any possible slip hazard.

- Remove T-30 Torx driver from Machine.

Figure 1



- Take the top cover off the planer after removing the 4 screws with the supplied T-30 Torx driver.

Figure 2



- Remove red wing nuts holding dust shroud and set aside.

Figure 3



- Remove the dust collection port. Rotate dust shroud away from Cutterhead so alignment arrow on fan housing aligns with OPEN line on dust shroud. Pull dust shroud away from fan housing and remove.

Figure 4



- Remove the crank wheel located on the side of the planer with T-30 Torx driver.

Figure 5



- Press Cutterhead lock lever and rotate Cutterhead until T-30 Torx screws are visible on knife clamp. Remove screws securing knife clamp.

Figure 6

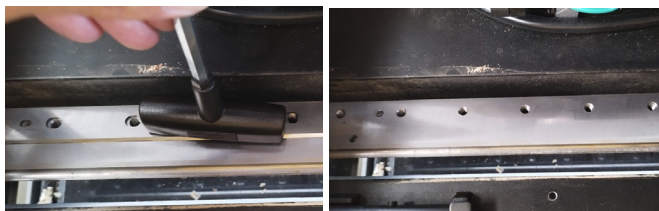


- Attract the knife using the T-handle Torx driver with magnet, then remove it. Repeat Steps 6–7 until all three knives have been removed from the Cutterhead.

⚠ WARNING

Knives are sharp. Handle with care.

Figure 7



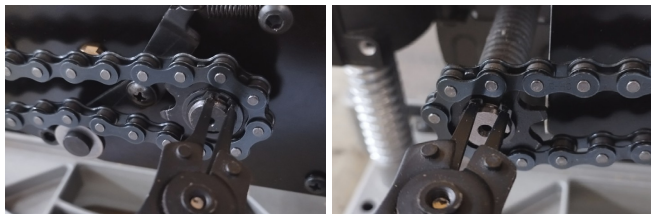
- Remove 3 screws on the left panel using T-30 Torx driver.

Figure 8



- Remove the retaining rings for both front and rear rollers.

Figure 9



- Remove the spring.

Figure 10



- Remove both the sprocket and the chain.

Figure 11



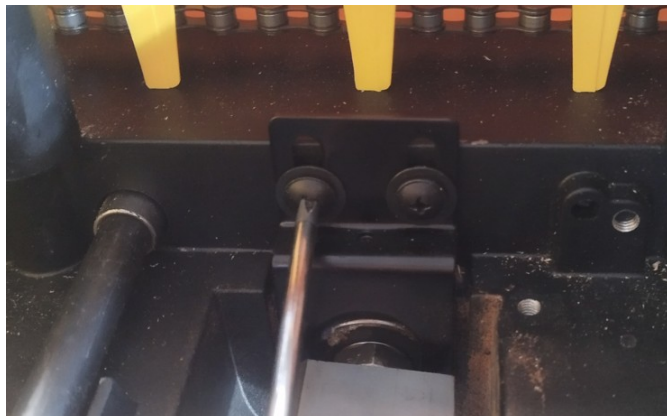
- Remove the spacer.

Figure 12



- Use a screwdriver to remove the screws securing the Cutterhead lock lever, and then detach the Cutterhead lock lever. Make sure spring remains attached to lock lever.

Figure 13



- Use a 5mm Hex wrench to remove the screws securing the gearbox.

Figure 14



- While supporting gearbox, turn speed selector switch on front panel clockwise to release

Note: Gearbox will separate from planer after turning speed selector switch to speed "2".

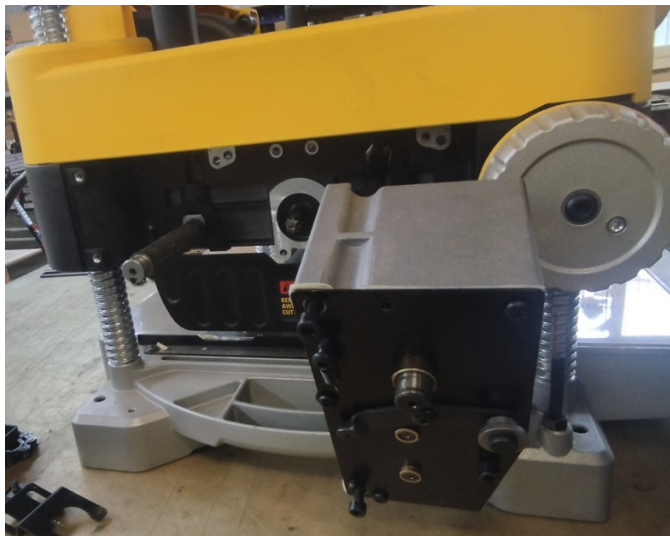
Figure 15



- Pull gearbox out by left direction and turn it 90 counterclockwise on planer mount.

NOTE: Gearbox speed selection rod and positioning pin will prevent gearbox from being completely removed from planer. Secure gearbox to planer with tape or rope to prevent it from shifting during disassembly.

Figure 16



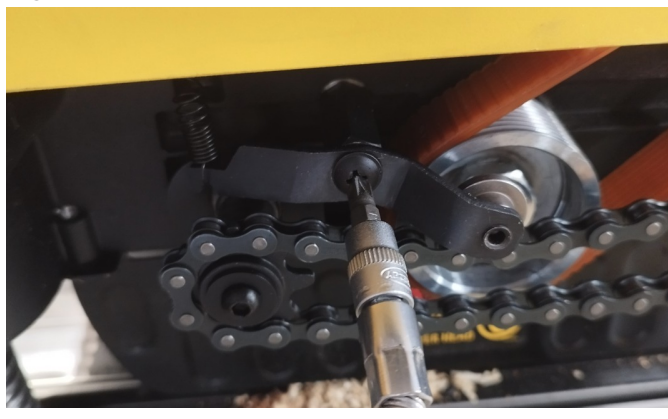
- Remove 4 screws on the right panel using T-30 Torx driver.

Figure 17



- Use a screwdriver to remove screws on tension wheel assembly and then detach spring and tension wheel assembly.

Figure 18



- Use a 4mm Hex wrench to remove both the sprockets and chain from the front and rear rollers.

Figure 19



- Remove belt from pulley by working forward and clockwise.

Figure 20



- Vertically insert a 16mm thick wooden board so that it is fully wedged between the carriage and Cutterhead.

NOTE: verify Cutterhead no longer rotates.

Figure 21



- On the left side of machine, use a 6mm socket and ratchet to remove the Helical pinion gear by turning it counterclockwise.

Figure 22



- Ensure Cutterhead is still locked from previous step shown in Figure 21. If not, remove the wooden board and Horizontally insert the board, fully wedging it between the carriage and Cutterhead.

NOTE: verify Cutterhead no longer rotates.

Figure 23



- Use a 24mm socket and ratchet to remove 24mm Hex nut securing pulley.

Figure 24



- Remove the Cutterhead pulley.

Figure 25



- Remove the key.

Figure 26



- Remove the spacer.

Figure 27



- Remove the retaining ring.

Figure 28



- Place a thicker wood board or a piece of polyfoam under the cutter head to prevent it from falling when removing it from the planer.

Figure 29



- Use a 10mm Socket and extension, place socket inside inner race of bearing on left side of Cutterhead. Gently tap the Socket extension with a hammer until Cutterhead is unseated from carriage.

Note: if bearing remains in planer, use 22mm socket and extension to tap and remove the bearing.

Figure 30



- Pull Cutterhead out from the right side.

Figure 31



- Put the 72432 Helical Cutterhead through the right hole then the left hole.

Figure 32



- Ensure the included M16 nut is threaded onto the end of the Cutterhead.

Figure 33



- Gently tap hex nut with hammer until Cutterhead is seated on carriage.

Figure 34



- Figure 35**



- Figure 36**



- Figure 37**



NOTES

[illegible]

- Reinstall key.

Figure 38



- Reinstall Cutterhead pulley.

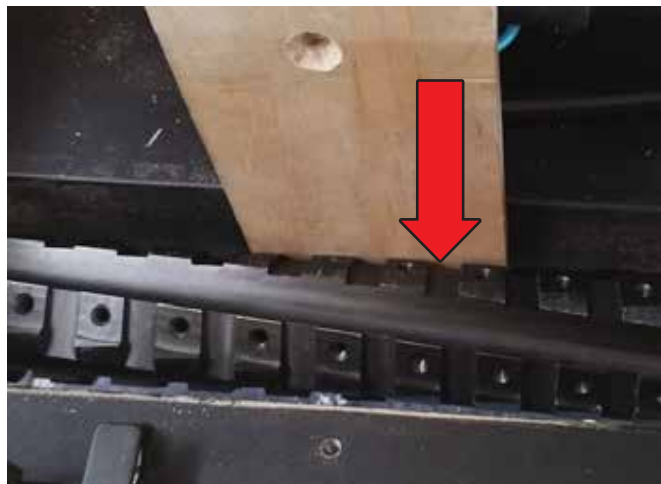
Figure 39



- Vertically insert a 16mm thick wooden board so that it is fully wedged between the carriage and Cutterhead.

NOTE: verify Cutterhead no longer rotates.

Figure 40



- Use a 24mm socket and ratchet to install 24mm Hex nut, securing pulley.

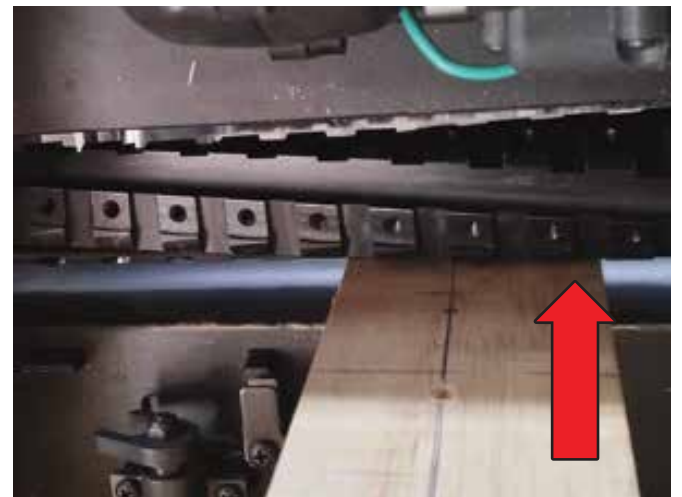
Figure 41



- Ensure Cutterhead is still locked from previous step shown in Figure 40. If not, remove the wooden board and Horizontally insert the board, fully wedging it between the carriage and Cutterhead.

NOTE: Verify Cutterhead no longer rotates.

Figure 42

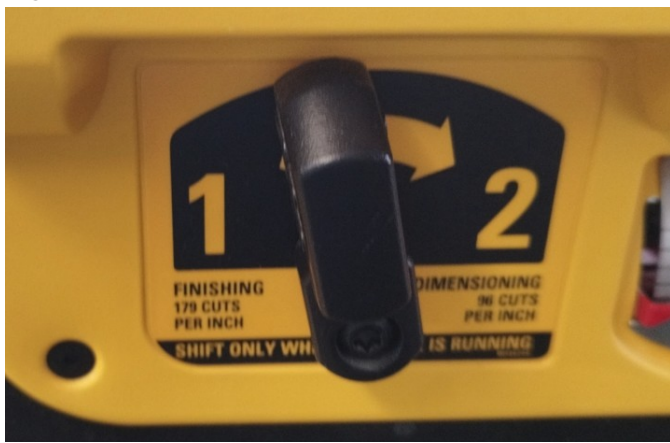


- Use a 6mm socket and ratchet to install the Helical pinion gear and secure it in place.

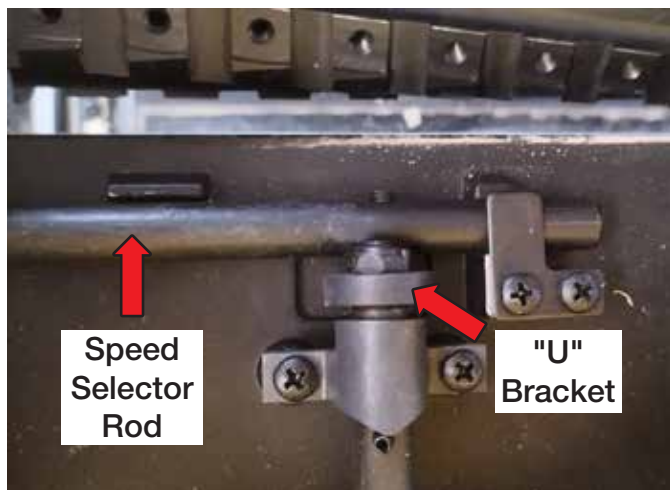
Figure 43



- Turn speed selector switch on front panel counterclockwise to speed "1". Then Reinstall gearbox. Note: aligning both locating pins on gearbox assembly with both alignment holes on planer.

Figure 44

- While installing gearbox, confirm that "U" bracket attached to speed selector switch engages with positioning pin on gearbox speed selection rod.

Figure 45

- Use a 5mm hex wrench (not included) to reinstall screws removed from gearbox.

Figure 46

- Reinstall the spacer.

Figure 47

- Reinstall both the sprocket and the chain.

Figure 48

- Re-attach the spring.

Figure 49

- Reinstall the retaining rings for both front and rear rollers.

Figure 50

- Reinstall screws removed from the left panel using the T-30 Torx driver.

Figure 51



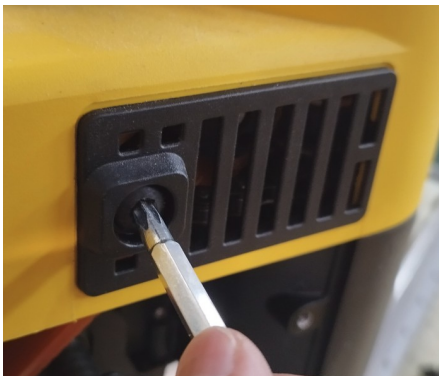
- Reinstall pulley belt, clockwise.

Figure 52



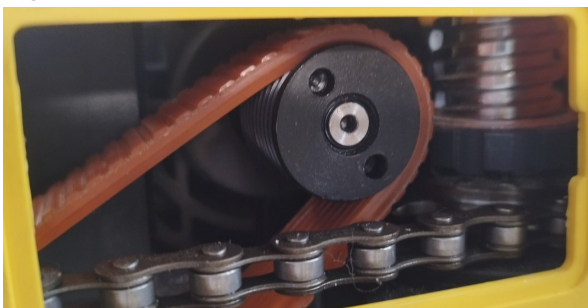
- Remove drive belt cover located on right side using the T-30 Torx driver.

Figure 53



- Verify that drive belt is centered on drive wheel.

Figure 54



- Reinstall drive belt cover using the T-30 Torx driver.

Figure 55



- Reinstall both the sprocket and the chain.

Figure 56



- Use a 4mm hex wrench to reinstall both sprockets and the chain on the front and rear rollers.

Figure 57



- Use a screwdriver to reinstall the screws on the tension wheel assembly, then reattach the tension wheel spring.

Figure 58



- Figure 59**



- Figure 60**



- Figure 61**



- Figure 62**



NOTES

[illegible]

- Reinstall the dust port onto the machine carriage.

NOTE: Align the "OPEN" mark correctly for proper fit.

Figure 63



- Reinstall red wing nuts to secure shroud.

Figure 64



- Place the top cover back onto the planer, then reinstall the 4 screws removed from the top cover using the supplied T-30 Torx driver.

Figure 65



- Replace T-30 Torx driver on the planer top cover.

Figure 66



REPLACE THE INSERTS

WARNING

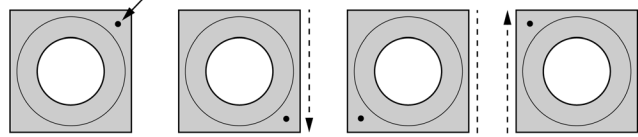
Risk of personal injury. The cutting edges of the inserts are sharp. Handle with care.

1. Turn OFF and disconnect the machine from power.
2. Access the Cutterhead by completing Steps 1–5 of the Removing Existing Cutterhead instructions.
3. Press Cutterhead lock lever and rotate Cutterhead to remove the screw and the indexable insert.
4. Clean all dust and debris from both the insert and the Cutterhead pocket from which it was removed. Reinstall the insert with a fresh, sharp edge facing outward or a new one.

NOTE: Proper cleaning is essential for achieving a smooth finish. Any contaminants trapped between the insert and the Cutterhead may raise the insert slightly, causing visible marks on your workpieces during the next planing operation.

5. Apply a light machine oil to the screw threads, wipe off any excess oil, and tighten the screw to 48–50 in-lbs.
6. Return planer to its original configuration by following Steps 62–66 of the Re-assembly instructions.

Reference Dot



GENERAL MAINTENANCE

WARNING

When servicing, use only identical replacement parts. Use of any other parts may create a hazard or cause product damage. To ensure safety and reliability, all repairs should be performed by a qualified service technician.

WARNING

Keep the product dry, clean, and free from oil and grease. Always use a clean cloth when cleaning. Never use brake fluids, gasoline, petroleum based products or any strong solvent to clean the product. Chemicals can damage, weaken or destroy plastic which may result in serious personal injury.



WARRANTY

Thank you for investing in a **POWERTEC**® power tool. This product has been designed and manufactured to meet high quality standards and is guaranteed for domestic use against defects in workmanship or material for a period of 12 months from the date of purchase. This guarantee does not affect your statutory rights.

SOUTHERN TECHNOLOGIES LLC. BENCH TOP AND STATIONARY POWER TOOL LIMITED 1 YEAR WARRANTY AND 30-DAY SATISFACTION GUARANTEE POLICY

POWERTEC products are designed and manufactured by **Southern Technologies LLC**. All warranty communications should be directed to **Southern Technologies LLC** by calling 847-780-6120 (toll free), 9 AM to 5 PM, Monday through Friday, US Pacific Time.

30-DAY SATISFACTION GUARANTEE POLICY

During the first 30 days after the date of purchase, if you are dissatisfied with the performance of this **POWERTEC** tool for any reason, you may return the tool to the retailer from which it was purchased for a full refund or exchange. You must present proof of purchase and return all original equipment packaged with the original product. The replacement tool will be covered by the limited warranty for the balance of the one year warranty period.

LIMITED ONE YEAR WARRANTY

This warranty covers all defects in workmanship or materials in this **POWERTEC** tool for a one year period from the date of purchase. This warranty is specific to this tool. **Southern Technologies, LLC** reserves the right to repair or replace the defective tool, at its discretion.

HOW TO OBTAIN SERVICE

To obtain service for this **POWERTEC** tool you must return it, freight prepaid, to **POWERTEC**. You may call (toll free) 847-780-6120 for more information. When requesting warranty service, you must present the proof of purchase documentation, which includes a date of purchase. **POWERTEC** will either repair or replace any defective part, at our option at no charge to you. The repaired or replacement unit will be covered by the same limited warranty for the balance of one year warranty period.

WHAT IS NOT COVERED

This warranty applies to the original purchaser at retailer and may not be transferred.

This warranty does not cover consumable items such as saw blades, knives, belts, discs, cooling blocks and sleeves. This warranty does not cover required service and part replacement resulting from normal wear and tear, including accessory wear.

This warranty does not cover any malfunction, failure or defect resulting from:

- 1) misuse, abuse, neglect and mishandling not in accordance with the owner's manual.
- 2) damage due to accidents, natural disasters, power outage, or power overload.
- 3) commercial or rental use.
- 4) alteration, modification or repair performed by persons not recommended by **POWERTEC**.

DISCLAIMER

To the extent permitted by applicable law, all implied warranties, including warranties of MERCHANTABILITY or FITNESS FOR A PARTICULAR PURPOSE, are disclaimed. Any implied warranties, that cannot be disclaimed under state law are limited to one year from the date of purchase. **Southern Technologies LLC** is not responsible for direct, indirect, incidental or consequential damages. Some states do not allow limitations on how long an implied warranty lasts and/or do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state. Southern Technologies LLC., makes no warranties, representations, or promises as to the quality or performance of its power tools other than those specifically stated in this warranty.

POWERTEC®

Southern Technologies, LLC
Chicago, IL 60606

