

		Using MFF80/ MFF81	Using HH40/ HH40E
Max. surfacing width 90°	mm	80	82
Max. surfacing width 45°	mm	45	45
Max. thickening capacity	mm	80 x 80	80 x 80
Max. planing depth	mm	3.75	4.0
Thickening table	mm	500 x 80	500 x 80
Surfacing fence length	mm	350	350
Weight	kg	3.7	3.7

## Manufacturer's Declaration



ADE80

Elu declares that the attachment mentioned above has been designed in compliance with 89/392/EEC.

### Technical data

This attachment must not be put into service until it is established that the Power Tool to be connected to this attachment is in compliance with 89/392/EEC (identified by the CE-marking on the Power Tool).

Director Engineering and Product Development  
Horst Großmann

## Safety instructions

**Observe the safety regulations in the instruction manual of the Power Tool to be connected to this attachment. Also observe any applicable additional safety rules. Read the following safety instructions before attempting to operate this product.**

**Keep these instructions in a safe place!**

The attention of UK users is drawn to the "woodworking machines regulations 1974" and any subsequent amendments.

### General

- The attachment must be level and stable at all times.
- Keep the work top clear of foreign objects.
- Use the attachment with the Power Tools and accessories specified in this manual only.

- Secure the Power Tool carefully.
- Work with closed hands.
- Make sure that your work area is properly lighted.

## Surfacing/thickening

### 1 Dust extraction

As the planer produces dust and chips, the use of dust extraction equipment is recommended. Proper dust extraction is especially important if beech or oak dust is produced.

### 2 Wear safety goggles

Also use a face or dust mask to protect against dust or flying particles.

### 3 Protection devices

Only operate the Power Tool and attachment with all guards properly in place.

### 4 Inspect workpiece

Remove any nails, staples and other metal parts.

### 5 Cutter blades

Use sharp and undamaged cutter blades only.

### 6 Damaged parts

Before operation, inspect the attachment, the Power Tool, the power cable and the plug carefully for signs of damage. Have any damage repaired by an Elu authorized repair agent before using the tool or attachment.

### 7 Starting the planer

Before switching on, remove all adjustment spanners from the planer and attachment.

### 8 Operating the planer and attachment

Do not overload the planer by feeding it at a too high rate. Always feed the material against the rotational direction of the cutter block. Always use a push stick, especially when working with smaller workpieces.

### 9 Stopping the planer

After switching off, the cutter block will continue to run for a few seconds. Do not attempt to block it.

### 10 Maintain your attachment with care

Keep the attachment clean and in good condition for better and safer performance. Follow the instructions for maintenance. Keep all controls dry, clean and free from oil and grease.

### 11 Have your attachment repaired by an Elu authorized repair agent

This attachment is in accordance with the relevant safety regulations. To avoid danger, it must only be repaired by qualified technicians.

## Package contents

The package contains:

- 1 Surfacing/Thickening attachment
- 1 Support foot
- 1 Support bracket with foot
- 1 Support for handle
- 1 Switch edge for MFF80/MFF81
- 1 Switch strap for HH40/HH40E
- 1 Plastic bag containing:
  - 5 screws
  - 5 nuts
  - 1 securing clip
- 2 fence securing knobs
- 1 Instruction manual
- 1 Exploded drawing

- Check for damage to the tool, parts or accessories which may have occurred during transport.
- Take the time to thoroughly read and understand this manual prior to operation.

## Description (fig. A1 & 2)

Your Elu Surfacing/Thickening attachment ADE80 (Type 3) has been designed to extend the versatility of your MFF80/MFF81 or HH40/HH40E planer by converting it into a compact planer/thicknesser.

### A1

- 1 Switch strap
- 1a Switch wedge for use with HH40 models
- 2 Securing clip
- 3 Wing nuts
- 4 Bench clamp holes
- 5 Thickening adjuster
- 6 Aluminium frame
- 7 Thickening table
- 8 Table height adjuster
- 9 Thickening scale
- 10 Surfacing adjuster
- 11 Planing depth adjuster
- 12 Blade guard for thickening

### A2

- 13 Reversible fence
- 14 Thickening table clamp
- 15 Fence securing knobs
- 16 Rear support foot
- 17 Support bracket with foot
- 18 Planer mounting rods

### No-volt release switch

A no-volt release switch is available as an option (E38676). It offers the following advantages:

- Optimum safety: It prevents the machine from restarting inadvertently in the event of a power loss.
- It allows easier switching of the planer.

## Assembly and adjustment



Do not mount any Power Tools other than the MFF80/MFF81 or HH40/HH40E.

### Assembling the attachment (fig. A & B)

The screws and nuts required to assemble the attachment are supplied with the surfacing/thickening attachment.

- Slacken the thickening table clamp (14).
- Raise the thickening table (7) by rotating the table height adjuster (8).
- Mount the rear support foot (16), the arm (28) and support bracket with foot (17) using the nuts and screws (21 through 27) as shown.

### Mounting the planer (fig. C)

- Remove the wing nuts (3) and the securing clip (2).
- Hinge the planer mounting rods (18) up and mount the planer as shown.
- Reinstall the wing nuts (3).
- Pivot the planer into surfacing or thickening position and tighten the wing nuts (3).
- Fit the securing clip (2) in the appropriate groove of the rear mounting rod.

### Calibration (fig. A & D)

The calibration procedure needs to be performed only once.

- Remove the calibration fence (20) and place it on the thickening table (7), gauge cams (29) up.
- Set the table height to 15 mm using the table height adjuster (8).
- Secure the adjustment using the thickening table clamp (14).
- Pivot the planer into thickening position and check that all four gauge cams (29) are level against the planing shoe. Adjust as required.

- Tighten the wing nuts (3).
- Loosen the thickening table clamp (14) and lower the thickening table (7).
- Remove the calibration fence and reinstall it in its original position as a side guard.

### Adjusting the planing depth

- For planing depth adjustment, refer to the instruction manual of the planer.
- Make shallow cuts only, passing the material several times if required. For optimal results, select a maximum planing depth of 1.5 mm.

### Thickening position (fig. A & E)

- Remove the reversible parallel fence (13) by loosening the star knobs (15).
- Swivel the support bracket (17) aside or remove it and pivot the planer into thickening position. The planer mounting rods (18) now rest in the brackets (30).

### Thickening table height adjustment (fig. A)

- Loosen the thickening table clamp (14).
- Raise or lower the table by rotating the table height adjustment screw (19).
- Tighten the thickening table clamp (14).

### Surfacing position (fig. B & F)

- Remove the calibration fence.
- Loosen the thickening table clamp (14).
- Set the thickening table (7) to bottom position.
- Swivel the blade guard (12) aside and pivot the planer into surfacing position. The planer mounting rod (18) now rests in the support bracket (17).
- Check that the rear of the planer rests on the arm (28 in fig. B).
- If required, loosen the screw (26) using a screwdriver.
- Adjust the arm (28 in fig. B) in its slot and secure the screw.
- Tighten wing nut (3) to lock the planer in surfacing position.

### Mounting the reversible parallel fence (fig. A2)

- Lower the side guard of the planer and install the reversible parallel fence (13).
- Tighten the star knobs (15).
- For 45° bevelled workpieces, remove the star knobs (15), reverse the fence, refit the star knobs and level the fence on the planer shoe.

### Adjusting the blade guard (fig. G)

The blade guard (12) is mounted on a support bracket (17) that can be pivoted away when the planer is not in surfacing position. In surfacing position, the bracket also serves as a support to the planer mounting rod. The blade guard height is adjustable.

- Loosen the surfacing adjuster (10), adjust the blade guard height in the slot (31) and tighten the screw.

### Adjusting the planer in surfacing position to be 90° to the reversible fence (fig. C & G)

The calibration procedure needs to be performed only once.

- Use a square to check that the angle is 90°.

If this is not the case:

- Remove the reversible fence (13).
- Loosen the wing nuts (3).
- Pivot guard (12) away.
- Pivot the planer up.
- Adjust the height adjustment screw (19) accordingly.

### Dust extraction

- Use the dust extraction adapter of your planer and install it as described in the instruction manual of the planer.

**Instructions for use**



- Always observe the safety instructions and applicable regulations.
- For short workpieces, always use a push stick.

**Prior to operation:**

- Check that the Power Tool is mounted as described above.
- Check that all guards and fences are in perfect working order and mounted correctly.
- Connect a dust extractor.
- Set the required planing depth (refer to the instruction manual of your planer).

**Switching ON and OFF (fig. A)**

- Press the ON/OFF-switch of your planer.
- Lock the Power Tool in ON-position using the switch strap (1) or wedge (1a for HH40).
- To stop the tool, remove the switch strap or wedge.

**When using a no-volt release switch (option)**

- Press the ON/OFF-switch of your planer.
- Lock the Power Tool in ON-position.
- Lift the plug cover and plug in the Power Tool behind the connector.
- Connect the machining table to the mains by plugging an extension cable into the connector of the no-volt release switch.
- To switch the planer ON, press the green button of the no-volt release switch.
- To switch the planer OFF, press the red button of the no-volt release switch.

**HH40E**

On electronic planers, the brake will not operate if switched off via the no-volt release switch.

**Surfacing**

**Surfacing at 90° (fig. A2)**

- Press the material firmly against the parallel fence and on the planer shoe and feed it against the rotating cutter block.
- The blade guard will yield and return to its original position automatically.
- Always work with closed hands.
- Keep your hands away from the rotating cutter block!

**Surfacing at 45° (fig. H)**

- Reverse the parallel fence (13) as described above.
- Proceed as described for surfacing at 90°.

**Thickening (fig. I)**

- Set the thickening table (7) to the required height allowing for the chip clearance.
- Place the workpiece on the thickening table (7) and feed the workpiece smoothly under the guide blade (32) and parallel to the planing shoe.
- At the outfeed side, pull the workpiece out holding it down.
- In case of excessive resistance, reduce the planing depth and check the blades.

The sliding chip fence (33) can be opened for a better view of the thickening operation.

- Slacken the screw (34) and slide the chip fence (33) in the direction of the arrow (35).
- Wear safety goggles during this operation.

**Maintenance**

Your Elu attachment has been designed to operate over a long period of time with a minimum of maintenance. Continuous satisfactory operation depends upon proper tool care and regular cleaning.

- Remove dust and chips using compressed air.



**Lubrication**

Your attachment requires no additional lubrication.



**Cleaning**

Regularly clean the attachment with a soft cloth.

**Elu After-Sales service**

All Elu products are thoroughly tested before leaving the factory. However, if the product needs repair, please contact your dealer or the Elu Head Office for the address of the nearest Elu authorized repair agent (please refer to the back of this manual).



**Unwanted products and the environment**

Take your attachment to an Elu authorized repair agent where it will be disposed of in an environmentally safe way.

**GUARANTEE**

**• 30 DAY NO RISK SATISFACTION GUARANTEE •**

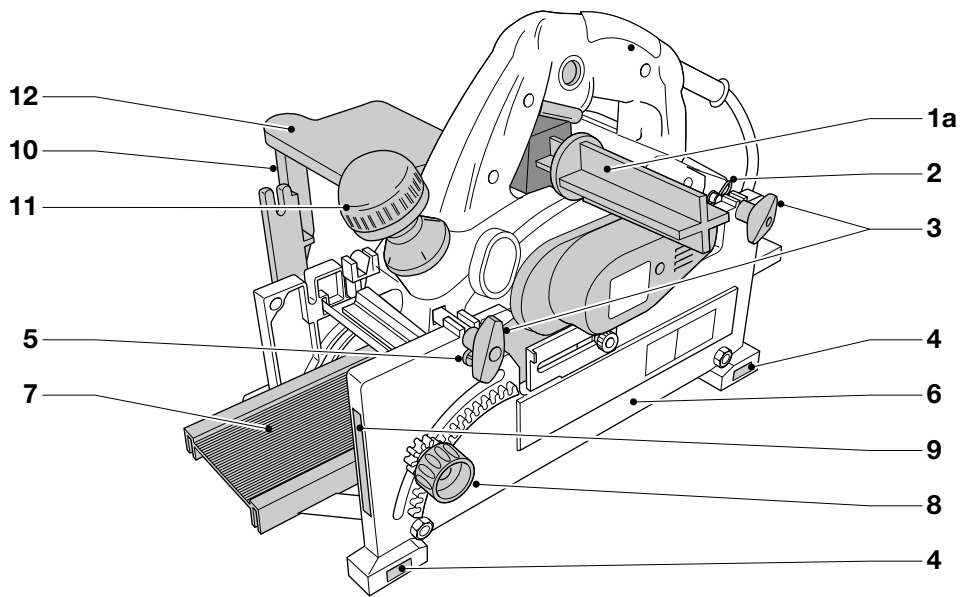
If you are not completely satisfied with the performance of your Elu tool, simply return it within 30 days, complete as purchased, to your Elu dealer, for a full refund or exchange. Proof of purchase must be provided.

**• ONE YEAR FULL WARRANTY •**

If your Elu product becomes defective due to faulty materials or workmanship within 12 months from the date of purchase, we guarantee to replace all defective parts free of charge or, at our discretion, replace the unit free of charge provided that:

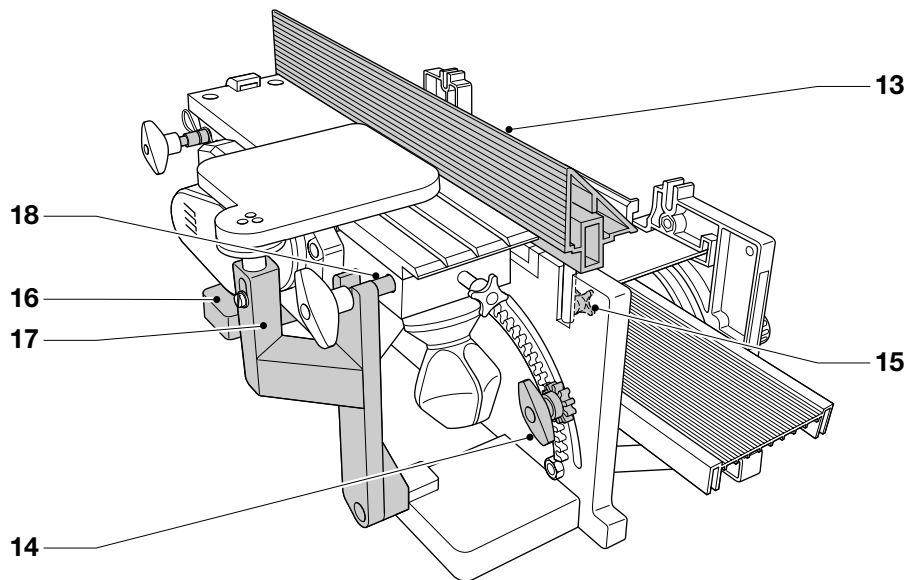
- The product has not been misused.
- Repairs have not been attempted by unauthorized persons.
- Proof of purchase date is provided.

This guarantee is offered as an extra benefit and is additional to consumers statutory rights.



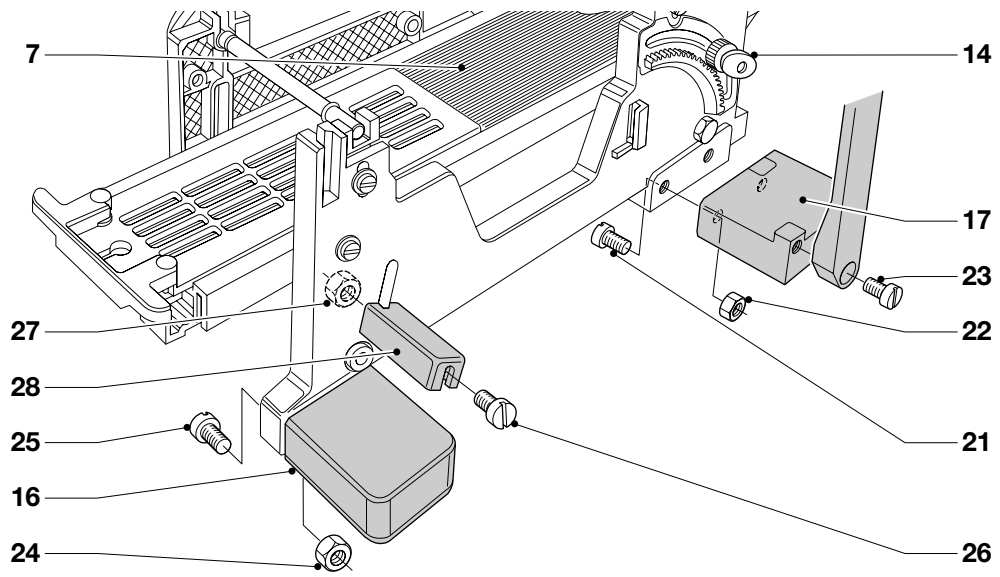
**A1**

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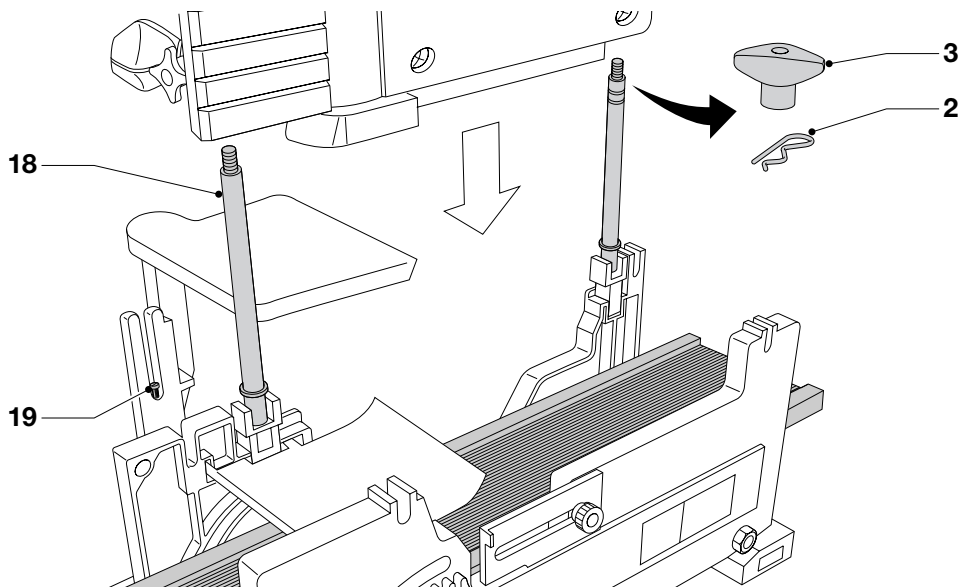
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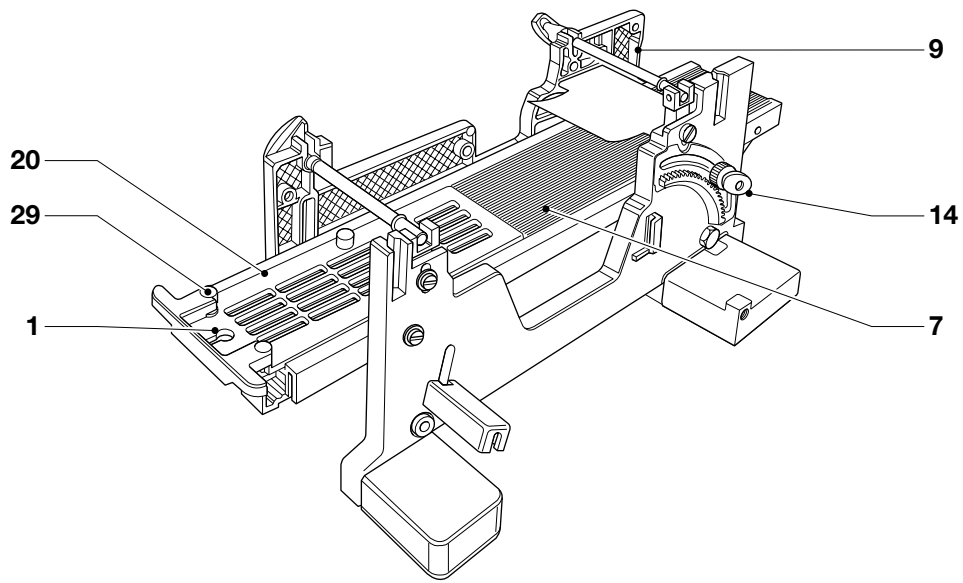
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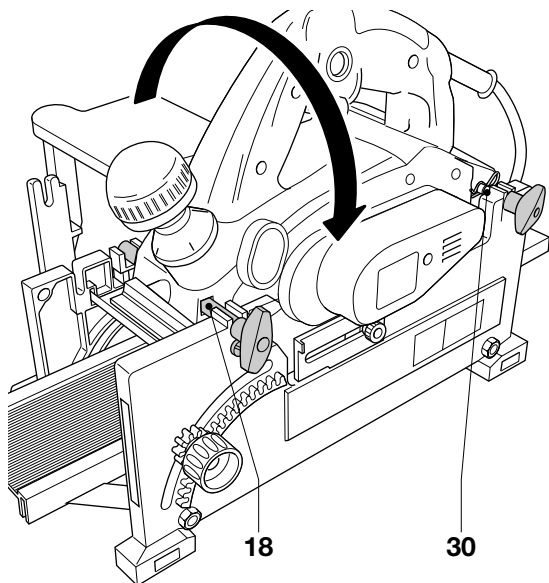


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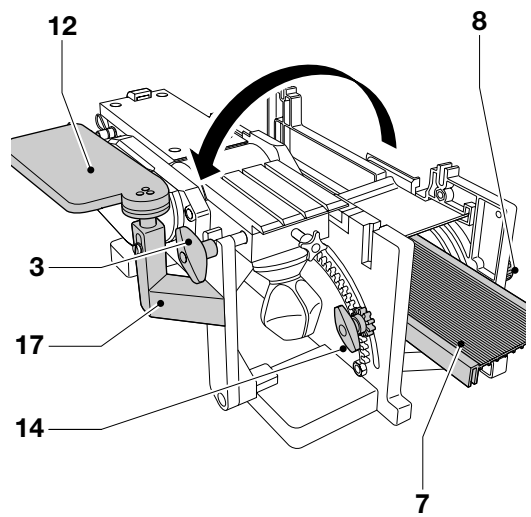
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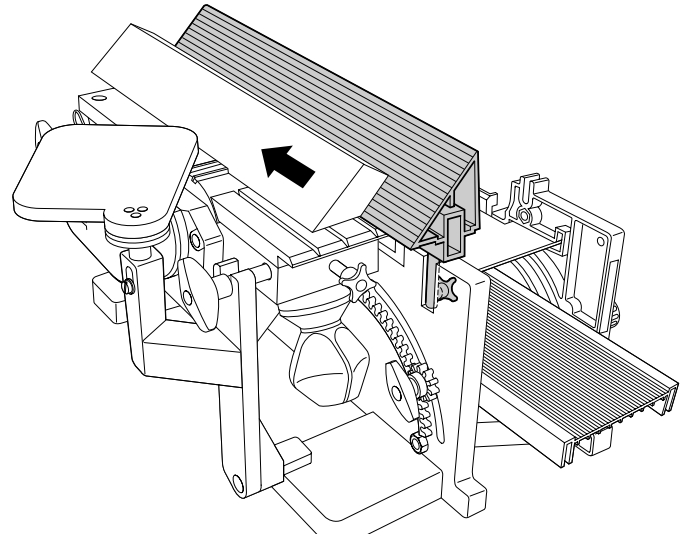
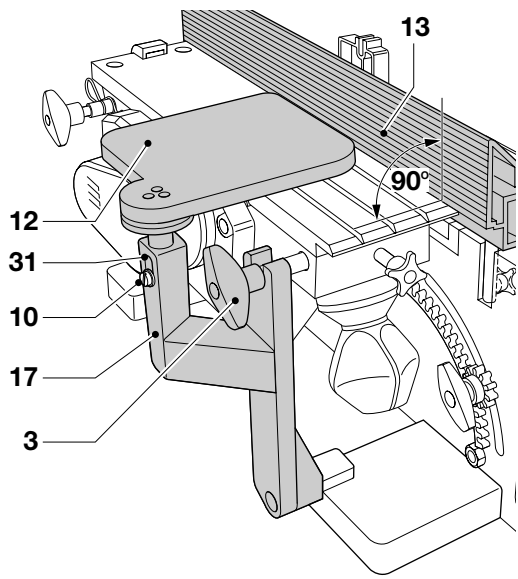
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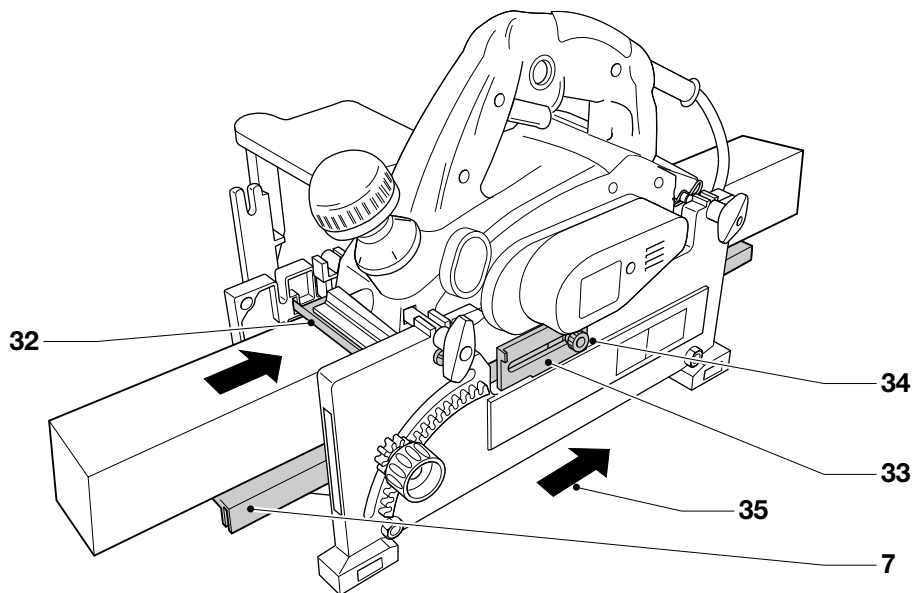


**F**



**G**

**H**



**I**