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DE / GB / PT / SP

PLANER PRD254HC JOINTER

IN GOOD HANDS

ORIGINAL INSTRUCTION MANUAL





ABOUT US

Peugeot Professional Tools was born out of several obvious reasons.

The first was to combine the know-how of **Peugeot**—which has mastered the art of cutting since 1810—with the expertise of **Tivoly**, a metalworker since 1917, to create a wide range of machines and tools designed for construction and maintenance professionals.

It also stemmed from a clear desire to serve craftsmen and small businesses driven by strong family values and a rich heritage.

For these professionals, **Peugeot Professional Tools** offers machines and tools designed specifically for their needs. **These are reliable, durable tools that can be repaired in France** and in countries covered by distribution agreements by local industrial and family-run partners.

Trusted equipment, backed by a longer warranty, with logistics and

French after-sales service. The assurance of dealing with the very people who assembled these tools and know every component inside and out.

From exceptional projects to everyday job sites, these tools are designed to withstand the most demanding conditions and stand the test of time.

Peugeot Professional Tools was born from one simple truth: that our tools are in good hands. The hands of those who work behind the scenes and give their all to satisfy their customers.

Since 1810, much has changed, but the hands have remained the same. The hands of passionate individuals—dedicated craftsmen, technicians, and installers—who take pride in themselves and their work.

Peugeot Professional Tools: tools in good hands.

THANK YOU FOR YOUR PURCHASE.

We are delighted that you have chosen Peugeot Professional Tools. Every detail has been designed to provide you with an exceptional experience, and we hope you enjoy using it as much as we enjoyed creating it for you.

Your trust is essential to us, and we are delighted to support you every step of the way as you experience the Peugeot Outils Professionnels brand.

Your purchase is covered by a 2-year warranty, which can be extended for an additional 2 years—

comments. To take advantage of this, sign up at www.peugeot-outils-pro.com

If you have any questions or need assistance, our team is here to provide you with the best possible service.

To contact our customer service department, email service@peugeot-outils-pro.com, call [+33\(0\)4.79.89.59.00](tel:+330479895900), or visit at www.peugeot-outils-pro.com

Thank you for choosing Peugeot Professional Tools. Your satisfaction is our priority.

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1 INTRODUCTION



For safety reasons, read this instruction manual carefully before using this machine. Failure to follow the instructions may result in injury to persons and/or damage to the machine.

This instruction manual is intended for the operator, the set-up technician, and the maintenance technician.

This instruction manual is an important part of your equipment. It provides rules and guidelines that will help you use this machine safely and effectively. You must familiarize yourself with the machine's functions and operation by carefully reading this instruction manual. For your safety, it is particularly important that you read and follow all recommendations on the machine and in this instruction manual.

These recommendations must be strictly followed at all times during the use and maintenance of the machine. Failure to follow the safety guidelines and warnings in this instruction manual and on the machine, and/or using the machine in a manner other than that recommended in this instruction manual, may result in machine failure and/or injury.

Please keep this instruction manual with the machine or in a location that is easily accessible at all times for future reference. Ensure that all personnel involved in the operation of this machine review it periodically.

If the instruction manual is lost or damaged, please contact us or your dealer to obtain a new copy.

Always use PEUGEOT OUTILS PROFESSIONNELS components and parts. Replacing components or parts with non-PEUGEOT OUTILS PROFESSIONNELS items may cause damage to the machine and endanger the operator.

This manual describes the safety instructions that the user must follow. It is the responsibility of the employer or the user, pursuant to Article L.4122-1 of the Labor Code, to ensure their own health and safety and that of others affected by their actions or omissions, in accordance, in particular, with the instructions provided to them.

The employer must conduct an assessment of the specific risks associated with its operations, must train workers on the machine and on the prevention of these risks, and must appropriately inform workers responsible for operating or maintaining work equipment of the instructions or guidelines that apply to them.

2 PICTOGRAMMES

2.1 MACHINE SAFETY PICTOGRAMS

Meaning of the safety pictograms affixed to the machine (keep them clean and replace them when they are illegible or peeling off):



Safety glasses must be worn



Protective clothing must be worn



Respirator must be worn



Read the instruction manual carefully



Danger: Sharp edge



Danger: risk of entanglement



Hearing protection must be worn



Safety shoes must be worn



Do not wear loose-fitting clothing, clothing with wide sleeves, jewelry, bracelets, watches, wedding rings, etc.
Wear hair covers if you have long hair



Do not wear gloves while operating the machine



Do not touch



Danger: Electrical hazard

2.2 PICTOGRAMS IN THIS INSTRUCTION MANUAL



Immediate danger to people and damage to the machine



Possible damage to the machine or its surroundings



When changing tools or cleaning, wear protective gloves



Note



Electrical work must be performed by qualified personnel authorized to perform low-voltage electrical work.

3 SÉCURITÉ

3.1 GENERAL SAFETY REQUIREMENTS



To reduce the risk of fire, electric shock, mechanical injury, and personal injury when using power tools, follow the basic safety guidelines.

This instruction manual takes into account only reasonably foreseeable behaviors.

Our machines are designed and manufactured with the operator's safety always in mind.

We assume no liability for any damage resulting from inexperience, improper use of the machine, and/or damage to the machine, and/or failure to follow the instructions and safety rules contained in this instruction manual.

As a general rule, accidents always occur as a result of misuse or failure to read the instruction manual.

Please note that any modification to the machine will void our warranty.

Check that all safety guards are present, in good condition, and functioning properly before starting work.

Ensure that moving parts are functioning properly, that there are no damaged components, and that the machine is operating perfectly during startup.

Only qualified and authorized personnel are permitted to repair or replace damaged parts.

Keep the work area clean and tidy.

Ensure that the entire work area is visible from the workstation.

Cluttered work areas and workbenches are a potential source of injury.

Do not use the machine outdoors, in very damp areas, or in the presence of flammable liquids or gases.

Position the machine in a sufficiently lit work area.

Young workers under the age of eighteen are prohibited from using the machine.

Do not allow anyone, especially children or animals, who is not authorized to be in the work area to touch the tools or electrical cables, and keep them away from the work area.

Never leave the machine while it is running. Always disconnect the power supply. Do not leave the machine until it has come to a complete stop.



Do not overload the tool; it will perform better and be safer when used at the speed for which it is designed.

Do not use small tools to perform work intended for a larger tool.

Do not use tools for tasks for which they are not intended.



Do not damage the power cord.

Never pull on the power cord to unplug it from the outlet.

Keep the power cord away from heat sources, greasy surfaces, and/or sharp edges.

Protect the power cord from moisture and any potential sources of damage.

Check the power cord periodically, and if it is damaged, have it repaired by an authorized service provider.

A defective switch must be replaced by an authorized service provider.

Do not use the machine if the switch does not turn it on or off.



Do not overestimate your strength.

Always maintain a stable position and good balance.

Pay attention to what you are doing, use common sense, and do not operate the machine when tired.

Always use both hands to operate this machine.

The use of any accessories other than those described in the instruction manual may pose a risk of injury to people.

The user is responsible for the machine and must ensure that:

The reel is used only by people who are familiar with the instructions and authorized to do so.

Safety rules have been followed.

Users have been informed of the safety rules. Users have read and understood the instruction manual.

Responsibilities for maintenance and any necessary repairs have been clearly assigned and followed. Any defects or malfunctions have been immediately reported to an authorized repair technician or your dealer.

The reel must be used for the applications described in this manual.

Any use other than that specified in this instruction manual may be hazardous.

Mechanical and/or electrical safety devices must not be removed or bypassed.

No modifications and/or conversions may be made.

PEUGEOT OUTILS PROFESSIONNELS assumes no liability for damage caused to persons, animals, or property resulting from failure to comply with the instructions and safety rules contained in this instruction manual

3.2 SPECIFIC SAFETY REQUIREMENTS

- Before each use, check that the machine is not damaged. Do not use the machine with damaged parts.
- Replace damaged inserts immediately. The workpiece may ricochet off a damaged insert.
- When working on long workpieces, use appropriate supports on both sides of the machine. Avoid awkward body positions. Make sure your feet are on a solid surface and maintain your balance at all times.
- Before starting the machine, check that there are no objects (such as tools) inside the machine.
- When machining a workpiece in planing mode, it may become jammed in the rotating shaft and be propelled toward the operator if the anti-reverse device is not in perfect working order. Always use cutting inserts that are sharp and in perfect condition. Always check that the workpiece does not contain any foreign objects (screws, nails, knots, etc.).
- Never place your hands on the cutting shaft. Always use the bridge-type guard. Turn off the machine and unplug it when not in use.
- Make sure that no part of your body or clothing can get caught in the cutting shaft (do not wear a tie or long-sleeved clothing). Tie back long hair.
- Wear gloves during any maintenance or cleaning of the cutting shaft.
- Dust and wood chips are hazardous to your health and must never be inhaled. To prevent this, use a suitable chip vacuum:
 - Match the vacuum cleaner hose to the diameter of the machine's suction nozzle (75 mm).
 - Minimum air volume: 815 m³/h
 - Minimum vacuum pressure at the machine's suction nozzle: 740 Pa
 - Minimum air velocity at the machine's suction nozzle: 20 m/s
- Do not submerge the machine in water or wash it with a high-pressure water jet, as this may cause water to enter the electrical components.
- Do not use solvents or harsh detergents.
- Store the machine in a dry place and out of the reach of children.

3.3 OPERATOR SAFETY



For the operator's safety, ensure that protective screens and guards are in good condition and in place. Ensure that non-operating parts are always covered by a protective guard.

This machine is designed for a single operator.

The operator must wear appropriate personal protective equipment:

- Safety goggles.
- Hearing protection.
- Safety shoes.
- Respiratory protection.



The operator must wear close-fitting clothing and, if necessary, hair covers for long hair.

The operator must not wear, for example:

- Loose-fitting clothing or clothing with wide sleeves.
- Bracelets, watches, wedding rings, or jewelry.
- Any other objects that could get caught on the machine's moving parts.



4 DESCRIPTIF ET FONCTIONNEMENT

4.1 INTENDED USE OF THE MACHINE

The PRD254HC is a machine designed for planing and surfacing wood. Machining any material other than wood is permitted only with the manufacturer's approval.

In the event of misuse or the machining of materials other than those mentioned above, the manufacturer assumes no liability.

Under proper conditions of use and maintenance, safe operation and performance are guaranteed for several years.

To ensure this, familiarize yourself with the machine's various functions.

4.2 SPECIFICATIONS

- Mobile planer/jointer for construction sites or stationary use in a workshop
- Ground cast aluminum infeed and outfeed tables
- Helical shaft with carbide inserts that significantly reduces noise and ensures optimal surface quality
- Precise and quick adjustment of the planing thickness
- Integrated, fold-down chip extraction hood – Ø75 mm
- Perpendicular guide with continuous tilt from 90° to 45°

	Max. cutting width (mm)	Max. cutting depth (mm)		Cutting tool	Power supply	Motor (kW)	Weight (kg)	Dimensions (W x D x H) (mm)
PRD254HC	254	Planer: 2	Planer: 2	Helical shaft, Ø50 mm, with 24 inserts carbide	230V – single-phase	1.5	331	970 x 460 x 990

4.3 MACHINE DESCRIPTION



1. Width adjustment handle for bridge-type guard
2. Bridge-type guard
3. Bridge-type guard height adjustment handle for the bridge-type guard
4. Infeed table
5. Control panel
6. Base
7. Parallel guide
8. Planing depth adjustment knob
9. Planing depth adjustment knob
10. Output table

5 INSTALLATION

5.1 PACKAGING

The machine is packaged on a pallet in a wooden crate. When unpacking, remove each part, check its overall condition, and then proceed with assembly.

If the product does not appear to be in good condition, or if any parts are broken or missing, contact your retailer. Keep the instruction manual for future reference.

5.2 HANDLING AND TRANSPORT

The machine can be transported in two ways:

- With a pallet jack: To do this, secure the machine to the pallet using 4 screws.
- By several people: To do this, the machine must be carried using straps or blocks placed under the planer's frame.



Never lift the machine by the infeed or outfeed tables. They are not designed to support the machine's weight.

5.3 SETTING UP THE MACHINE



Installation Environment:

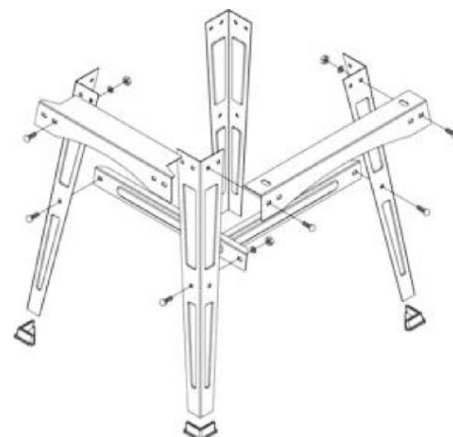
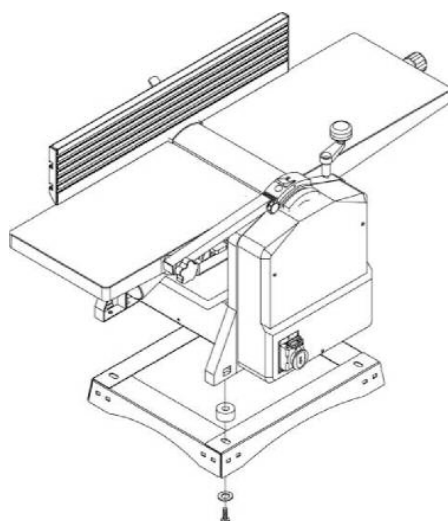
- Power supply Electrical compliant the machine's specifications (230 V single-phase).
- Ambient temperature between +5°C and +40°C.
- Relative humidity not exceeding 90%.
- Adequate ventilation at the installation site.
- The work area must be sufficiently lit to ensure safety: lighting must be 500 LUX.

5.4 INSTALLATION

Unpainted surfaces are coated with oil to protect them from rust. Remove the oil with a solvent or degreaser before use.

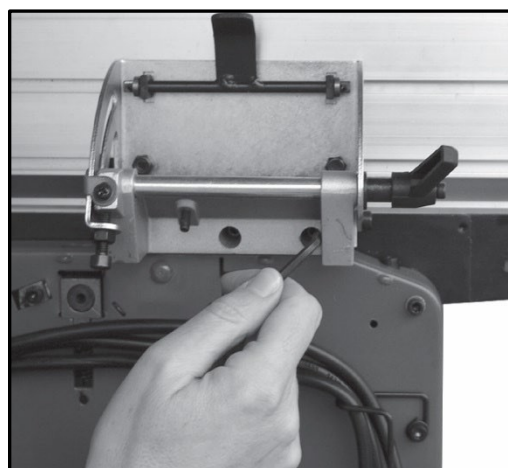
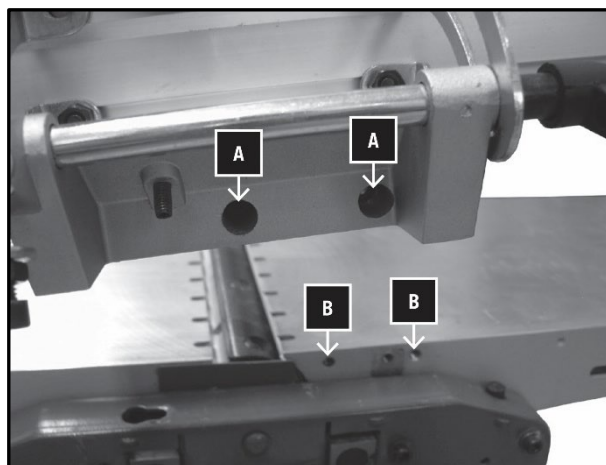
Assembling the base:

1. Assemble the base using the screws provided, as shown in the diagram opposite
2. Place the machine on the base and secure it

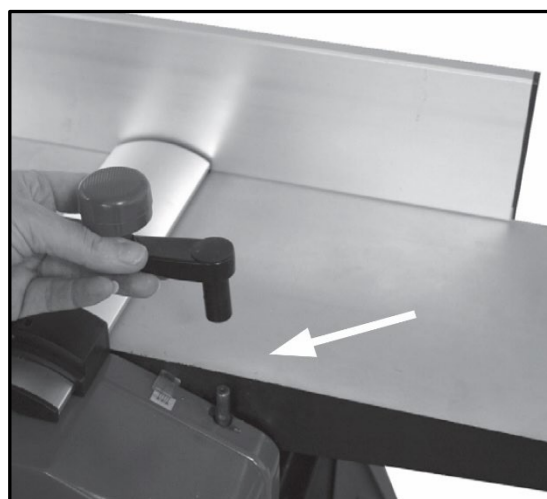


Assembling the parallel guide:

1. Remove the screws from holes (B)
2. Insert the screws into the holes (A) on the parallel guide
3. Secure the parallel guide to the machine using the holes (B)

**Installing the planing depth adjustment knob**

Place the knob on the shaft on the side of the planing table



5.5 ELECTRICAL CONNECTION



Electrical work must be performed by qualified personnel authorized to work on low-voltage electrical systems.



**Check that the cutting shaft is rotating in the correct direction.
The warranty does not cover damage caused by an incorrect connection.**

**ELECTRICAL PRESENCE**

Make sure the mains voltage matches the machine's voltage and that the electrical outlet is in good condition and properly grounded.

Verify that the electrical outlet in your installation is compatible with the plug on the machine's power cord.

The electrical outlet must comply with the "EN 60309-1" standards.

Connect the machine using the power cord.

Make sure the machine's power switch is in the "0" position. Verify that the electrical system to which the machine will be connected is properly grounded in accordance with current safety standards.

We remind the user that there must always be a circuit breaker installed upstream of the electrical system to protect all conductors against short circuits and overloads.

This protection must always be selected based on the machine's electrical specifications, as indicated on the nameplate:

- Voltage: 230 V three-phase
- Frequency: 50 Hz
- Current: 6.5 A
- Motor power: 1.5 kW

For the PRD254HC, the protection must be 10 A.



**Use cables and cable reels with a cross-section and length appropriate for the machine's power rating, and unroll them completely.
Electrical connections and extension cords must be protected from splashes and kept on dry surfaces.**



Using the machine with a damaged power cord is strictly prohibited. Regularly check the condition of the power cord, the cable grommet, and the switch.



Do not unplug the machine from the electrical outlet by pulling on the power cord; pull only on the plug.

6 AJUSTEMENTS ET PRÉPARATION



Before performing any maintenance or adjustments, turn off the machine and unplug it to prevent accidental startup. Inspect the machine before beginning any work to ensure it is complete and in good condition. Ensure there is sufficient space to work around the machine. Install safety equipment according to the instructions and verify that it is functioning properly.

6.1 ADJUSTING THE CUTTING DEPTH IN PLANING MODE

Adjusting the height of the infeed table allows you to set the cutting depth for a planing operation.

To adjust the cutting depth, turn the knob (A) until the desired cutting depth is achieved.

The maximum cutting depth for this machine is **2 mm** for planing. However, it is important to consider the following factors when selecting the appropriate cutting depth:

- Type of wood (hardwood or softwood)
- Moisture content of the wood
- Feed rate
- Condition of the carbide inserts



The height of the exit table is factory-set for use with a carbide-tipped helical shaft and must not be adjusted.

6.2 ADJUSTING THE CUTTING DEPTH IN PLANING MODE

Adjusting the height of the planing table allows you to set the cutting depth.

To adjust the cutting depth, turn the knob (A) until the desired cutting depth is achieved (1 turn = 3 mm).

The maximum cutting depth for this machine is **2 mm** for surface planing. However, it is important to consider the following factors into account when selecting the appropriate cutting depth:

- Type of wood (hardwood or softwood)
- Wood moisture content
- Feed rate
- Condition of carbide inserts



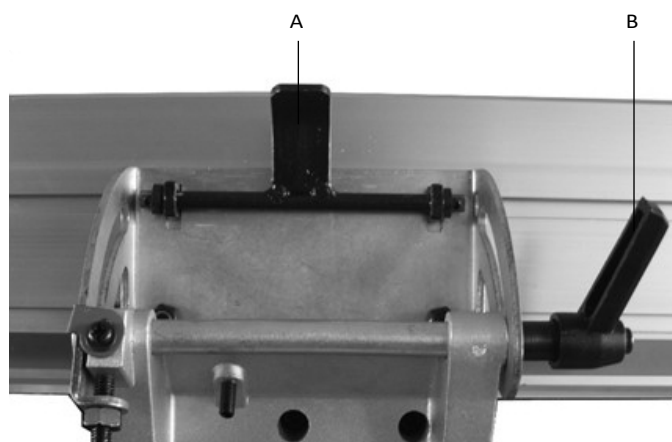
6.3 ADJUSTING THE TILTABLE GUIDE

The tilting guide ensures lateral support of the workpiece during planing.

To begin, use a square to verify that the guide is perpendicular to the planing tables.

To adjust the guide's lateral position, lift the handle (A) and slide the guide to the desired position. Lower the handle (A) to lock the guide in place.

To adjust the angle of the tilting guide, loosen the handle (B) to release the guide. Then position the guide at the desired angle using the graduated ruler and tighten the handle (B) to lock the guide in place.



Before using the machine for the first time, it is important to verify that the guide is at a 90° angle to the table.

7 UTILISATION

Before starting work on the machine:

- Before performing any operation on the machine, make sure it is complete and in good condition.
- Make sure there is enough space around the machine to move freely.
- Adjust the tilting guide and the bridge-type guard
- Make sure all the cutting inserts are in good condition and cut properly. If one or more inserts are damaged, rotate them a quarter turn (see section 8.2).
- Make sure all the blade screws are tight.
- Make sure the anti-reverse devices move freely and return to their original position after being lifted (see section 8.4).
- Install the dust extraction system according to the instructions and test to ensure it is working properly.
- Machine only workpieces that can be safely positioned and guided.
- Carefully inspect the workpiece for any foreign objects (nails, screws) that could interfere with proper operation.

- When planing, use supports (roller tables, table extensions) for workpieces longer than the infeed and outfeed tables.
- Make sure the cutting shaft rotates freely and in the correct direction.
- Before starting the machine, make sure no one is standing near it.

During operation:

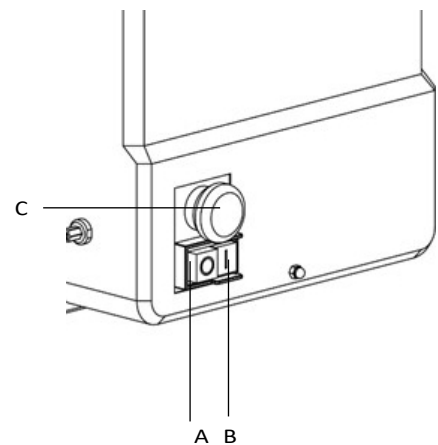
- Always wear: safety shoes, hearing protection, and close-fitting clothing.
- Never place your hands on the workpiece without first installing the bridge-type guard.
- Always turn off the machine before changing workpieces or in the event of a malfunction.
- Never remove or bypass safety devices while the machine is running.
- People with long hair must tie their hair back before working with the machine.
- Never wear gloves while machining workpieces.

7.1 STARTING AND STOPPING THE MACHINE



Before starting the machine, make sure the planing table feed clutch is in the down position.

- To start the machine, press the green start button (A)
- To turn off the machine: press the red stop button (B)
- The machine is equipped with a latching emergency stop switch (C): when this switch is pressed, the machine stops and cannot be restarted without turning the knob clockwise to unlock it.



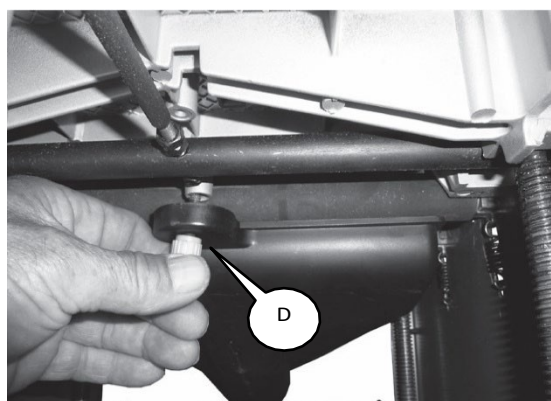
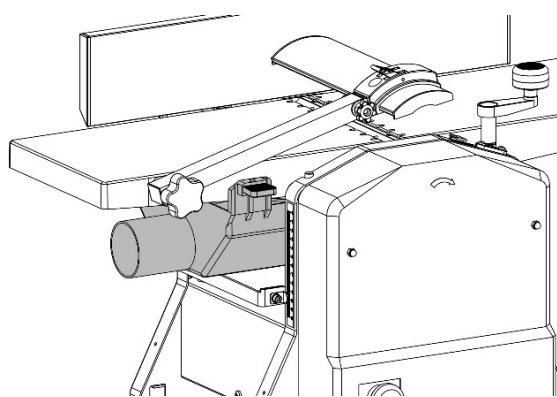
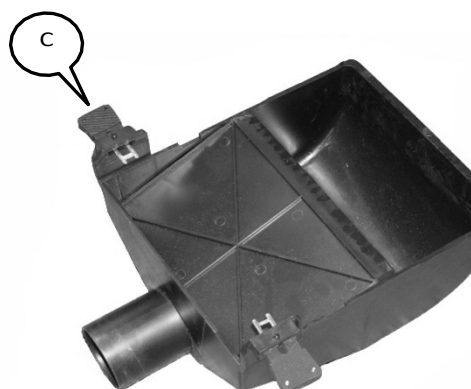
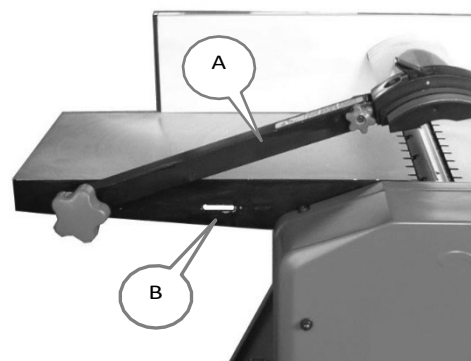
7.2 PLANING



The minimum thickness of the finished planed workpiece is 5 mm. Be careful when machining a thin workpiece; it may split if the cutting depth is too great.

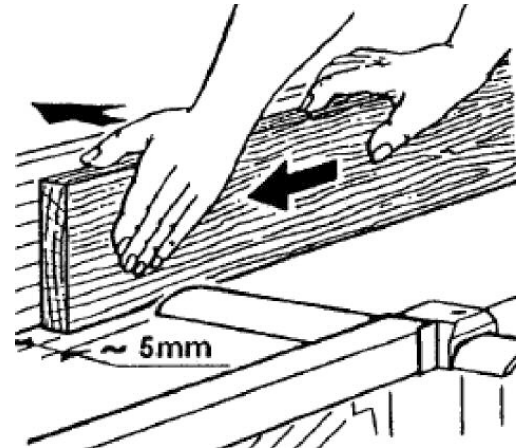
Installing the dust extraction system:

1. Lift the bridge-type protective guide (A) to clear the slots (B)
2. Move the parallel guide to clear the space near the slot (B) at the rear of the machine
3. Release the connectors (C) by pulling on them slightly
4. Lower the planing table as far as possible by turning the knob (D)
5. Place the dust collection system under the exit table and insert the connectors (C) into the slots (B)
6. Tighten the screw (D) into the hole located under the output table



Planing workpieces up to 75 mm thick:

1. Set the desired cutting depth as described in section 6.1 (max. 2 mm)
2. Check that the dust extraction system is properly connected to the nozzle and that it is running
3. Set the tilting guide to 90° and to the correct width
4. Adjust the bridge-type guard:
 - a. Use the knob (C) to position the bridge-type guard approximately 2 mm above the workpiece
 - b. Place the workpiece against the tilting guide and push it slightly under the bridge-type guard (without letting it pass over the cutting shaft)
 - c. Lift the latch (D) to release the guide
 - d. Move the bridge-type guard toward the tilting guide
 - e. Lower the latch (D)
 5. Start the machine
6. Stand in front of the machine
7. Machine the workpiece:
 - a. Keep your hands flat on the workpiece
 - b. Hold the workpiece with your left hand and push with your right hand
 - c. As soon as possible, use both hands on the other side of the bridge-type guard
 - d. Throughout the planing operation, maintain lateral pressure against the tilting guide
8. Turn off the machine if no other workpiece is to be machined



Position to assume for planing



It is essential to use a push block for workpieces shorter than 250 mm.

C

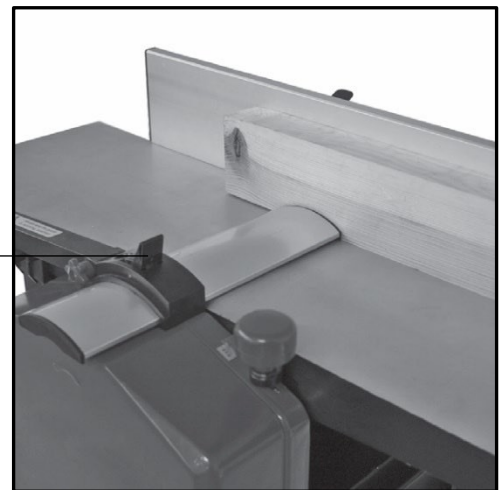


Planing workpieces thicker than 75 mm:

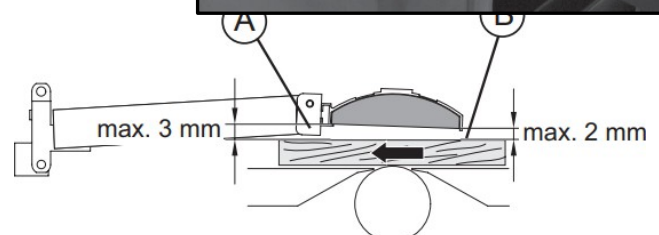
Only the position of the bridge-type guard changes compared to planing workpieces less than 75 mm thick.

4. Adjust the bridge-type guard:
 - a. Lift the latch (D)
 - b. Position the bridge-type guard approximately 5 mm from the workpiece
 - c. Place the workpiece against the tilting guide and push it forward past the bridge-type guard (without letting it pass over the cutting shaft)
 - d. Place the bridge-type guard against the workpiece
 - e. Lower the latch (D)
 - f. Use the knob (C) to lower the bridge-type guard to the edge of the table

D

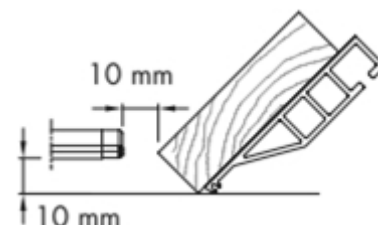
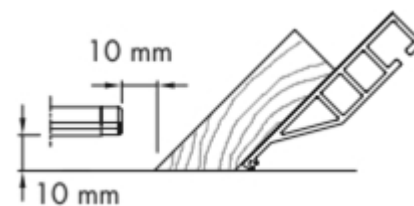


It is essential to use a push block for pieces shorter than 250 mm.



Chamfering and miter cuts:

1. Set the desired cutting depth as indicated in section 6.1 (max 2 mm)
2. Check that the dust extraction system is properly connected to the nozzle and that it is running
3. Adjust the tilting guide to the desired angle (see section 6.2)
4. Adjust the bridge-type guard:
 - a. Lift the latch (D) to release the guide
 - b. Push the bridge-type guard aside to allow the workpiece to pass through
 - c. Place the workpiece against the tilting guide and push it past the bridge-type guard (without letting it pass over the cutting shaft)
 - d. Place the bridge-type guard 10 mm from the workpiece
 - e. Lower the clamp (D)
 - f. Use the knob (C) to position the bridge-type guard 10 mm from the table
5. Turn on the machine
6. Stand in front of the machine
7. Machine the workpiece:
 - a. To prevent the workpiece from slipping on the tilting guide, rest the workpiece mostly on the tilting guide and only lightly against the table
 - b. Push the workpiece with your right hand while holding it steady with your left hand
8. Turn off the machine if no other workpiece needs to be machined



If a workpiece is too small to be held securely by hand, a push block must be used. If the workpiece is too small for the push block to grip it properly, a special fixture must be used.

7.3 PLANING

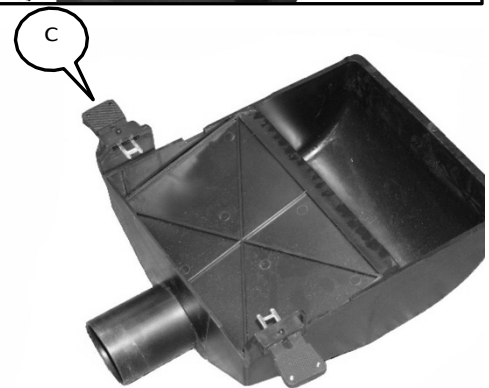
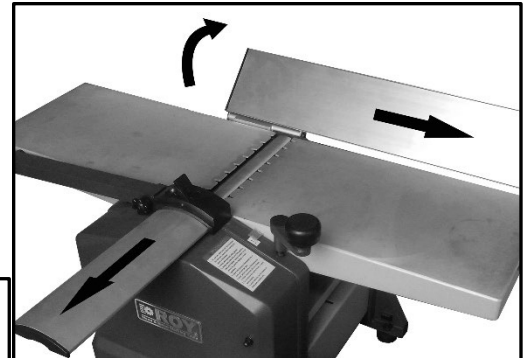
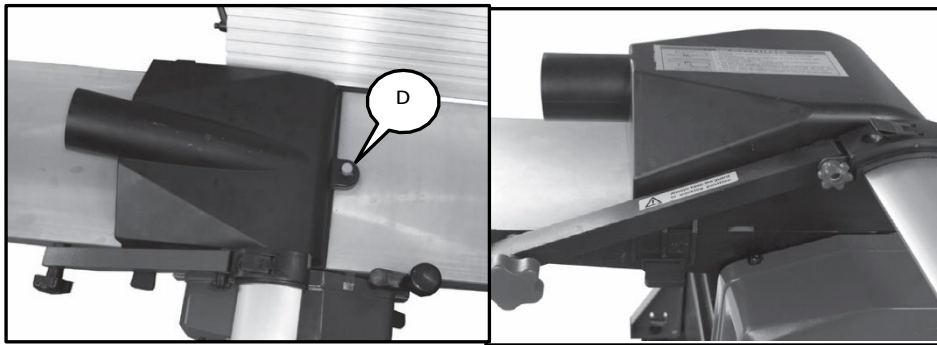


Pieces that already have one side planed can be planed to the desired thickness. The pieces are inserted with the planed side facing down, and the top of the piece is machined.

The minimum thickness of the finished planed piece is 5 mm. Never machine a piece if the final thickness is less than 5 mm.

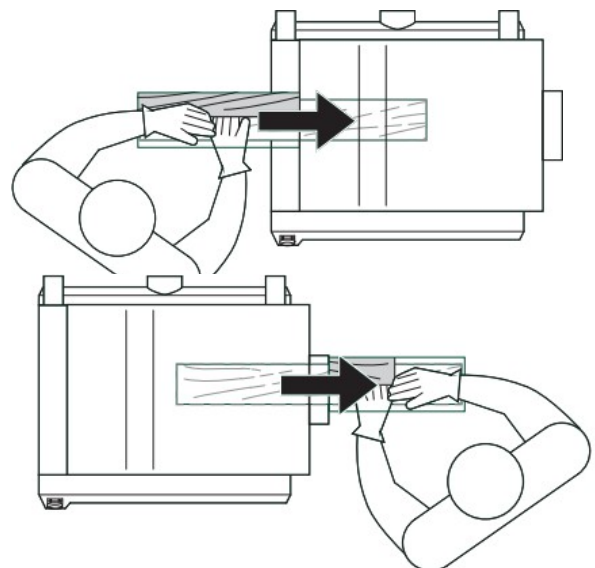
Installing the dust extraction system:

1. Lift the bridge-type protective guard (A) to clear the slots (B)
2. Move the rip fence and the bridge-type protective guard
3. Release the connectors (C) by pulling them slightly
4. Place the dust collection system on the exit table and push the connectors (C) into the slots
5. Tighten the screw (D) into the hole on the input table



Planing procedure:

1. Check that the dust collection system is properly connected to the nozzle and that it is running
2. Check that the backstop devices are working properly (see section 8.4)
3. Adjust the cutting depth as described in section 6.2
4. Start the machine
5. Stand in front of the machine
6. Machine the workpiece:
 - a. Push the workpiece until it is drawn in by the feed rollers
 - b. Support the workpiece as it exits the other side of the machine
7. Turn off the machine if no other workpieces are to be machined



A maximum of 2 workpieces can be machined at the same time. The thickness of the workpieces must not vary by more than 1 mm. Make sure both workpieces are properly fed by the feed rollers.

8 MAINTENANCE



Disconnect the power supply before performing any maintenance or servicing. Wear gloves and safety goggles

To maintain the efficiency of the machine and its components, it is necessary to perform maintenance.

The most important maintenance tasks are listed below.

Failure to perform the prescribed tasks will result in premature wear and reduce the machine's performance.

Before performing any maintenance, it is essential to disconnect the machine from the power supply to prevent accidental startup.



8.1 MAINTENANCE SCHEDULE

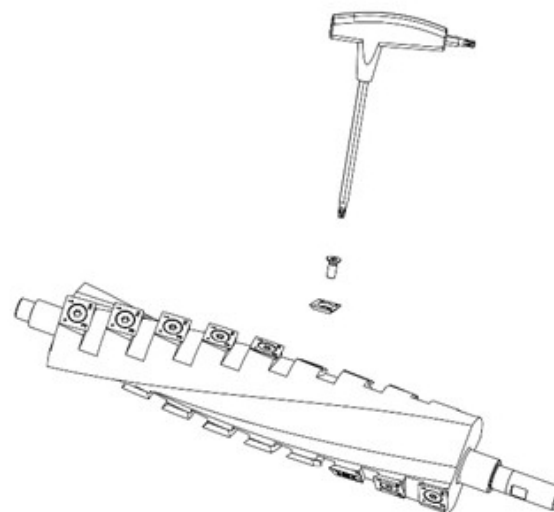
Interval	Which component	To do
Every day	Machine	Clean and remove chips
	Tables	Clean and remove chips
	Tilting guide and bridge-type guard	Clean and remove chips
	Backstop devices	Check for proper operation and clean them (see section 8.4)
Monthly	Drive belt	Check condition and tension
	Feed rollers	Clean off residue
	Table height adjustment screws	Lubricate
Every 6 months	Drive chain	Check condition and lubricate if necessary
	Sprockets	Check condition and lubricate if necessary

8.2 REPLACING CARBIDE INSERTS



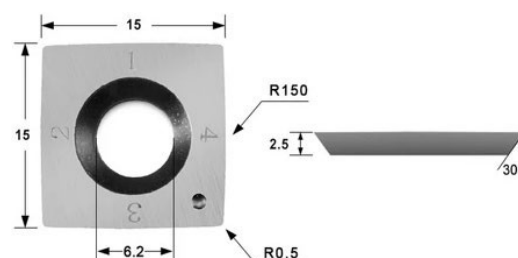
Carbide inserts are extremely sharp; always wear gloves when handling them. Always use a torque wrench to tighten the screws securing the carbide inserts. Tightening torque: 5.5 N·m

1. Clear access to the shaft by pushing the bridge-type protective guard
2. Loosen the screw securing the insert
3. Remove the insert from its housing and use a cloth or compressed air to remove any residue
4. Clean the housing and the insert with a resin remover and a brush
5. Reinstall the insert by turning it a quarter turn. The sides of the inserts are numbered 1 through 4. If all 4 sides of the insert are worn, replace it with a new one
6. Check that the insert clamping screw is in good condition and clean it
7. Tighten the screw with a torque wrench to 5.5 N·m



Always use inserts measuring 15 x 15 x 2.5 R150 mm.

To ensure optimal machine performance, always use PEUGEOT OUTILS PROFESSIONNELS carbide inserts.

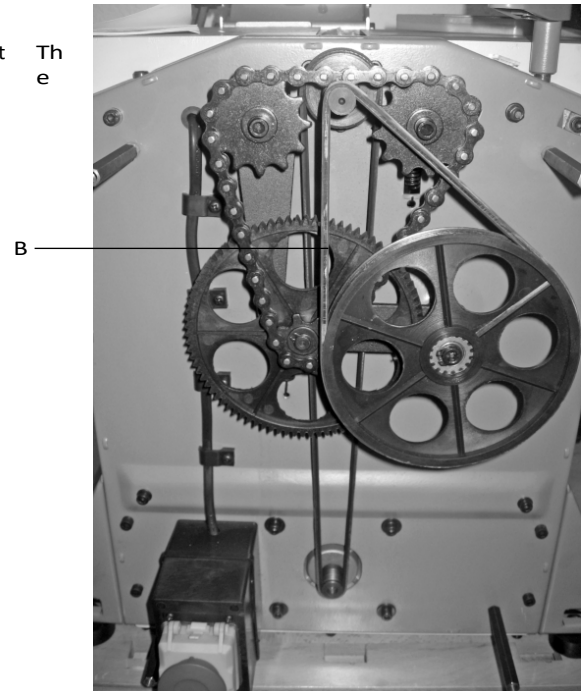


8.3 CHECKING THE DRIVE BELT TENSION

The drive belt may become loose over time. It is necessary to check its condition regularly. The belt must not have any cracks or tears. If it does, it must be replaced.

To check the belt tension, proceed as follows:

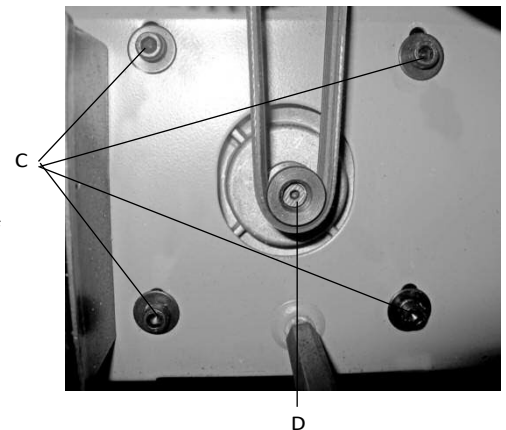
1. Remove the 3 screws (A) from the cover and remove the cover
2. Check the belt tension (B) by pressing down on it with your thumb. The belt should not move more than 10 mm at its center.



If the tension is incorrect, you must retension the drive belt:

1. Loosen the motor mounting screws (C)
2. The belt tension is achieved by the weight of the motor:
 - a. Push the motor (D) down until the desired tension is achieved
 - b. Tighten the screws (C) while continuing to apply pressure to the motor
 - c. Clean the pulleys and belts
 - d. Reinstall the cover

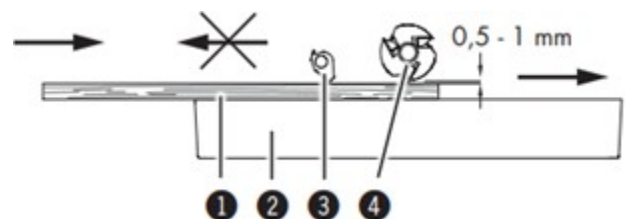
The planer's feed belt does not require adjustment. However, check it for any signs of wear; if any are found, it must be replaced.



8.4 CHECKING THE BACKSTOP DEVICES

The anti-reverse devices must be checked daily. If they malfunction, the workpiece may be propelled toward the operator.

1. Make sure the machine is turned off
2. Check that the anti-reverse devices are functioning properly;
 - a. Place a workpiece in the machine as if to machine it
 - b. Adjust the table height so that the board is 0.5–1 mm from the cutting shaft
 - c. It must not be possible to remove the workpiece
 - d. Push the workpiece out of the machine
3. Clean any residue from the anti-reverse devices



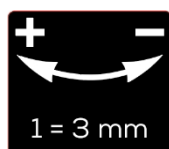
1. Board
2. Planing table
3. Backstop devices
4. Cutting shaft

8.5 TABLE OF DEFECTS

Defects	Solutions
The machine won't start	The emergency stop switch has not been reset
	Position the vacuum system correctly and check that the connectors are fully inserted into the slots on the table to engage the safety mechanism
Squeaking noises upon startup	The belt is not tight enough
The angle of the tilting guide is incorrect	Reposition the stops on the tilting guide
The surface finish is not good after planing	Check all carbide inserts and turn or replace those that are dull or worn
Scratches or nicks in the wood on the front or back of the workpiece after planing	The tension of the feed roller springs is incorrect and must be checked
The machine is vibrating excessively	Check the levelness of the floor
	Tighten all screws
	Replace or rotate damaged pads
	Check the condition and tension of the drive belt and replace or retension it if necessary

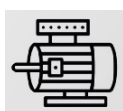
8.6 DESCRIPTION OF THE PICTOGRAMS USED ON THE MACHINE

A. Raising/lowering the planing table



This arrow indicates which way to turn the knob to raise or lower the planing table. It also indicates that one turn of the knob corresponds to a 3 mm movement of the table.

B. Nameplate



: Motor specifications: power, voltage, frequency, amperage



: Machine weight



: Shaft rotational speed



: Maximum width and minimum/maximum thickness of the workpiece that can be



machined : Maximum cutting thickness and minimum workpiece length for use in planing mode

IP 54

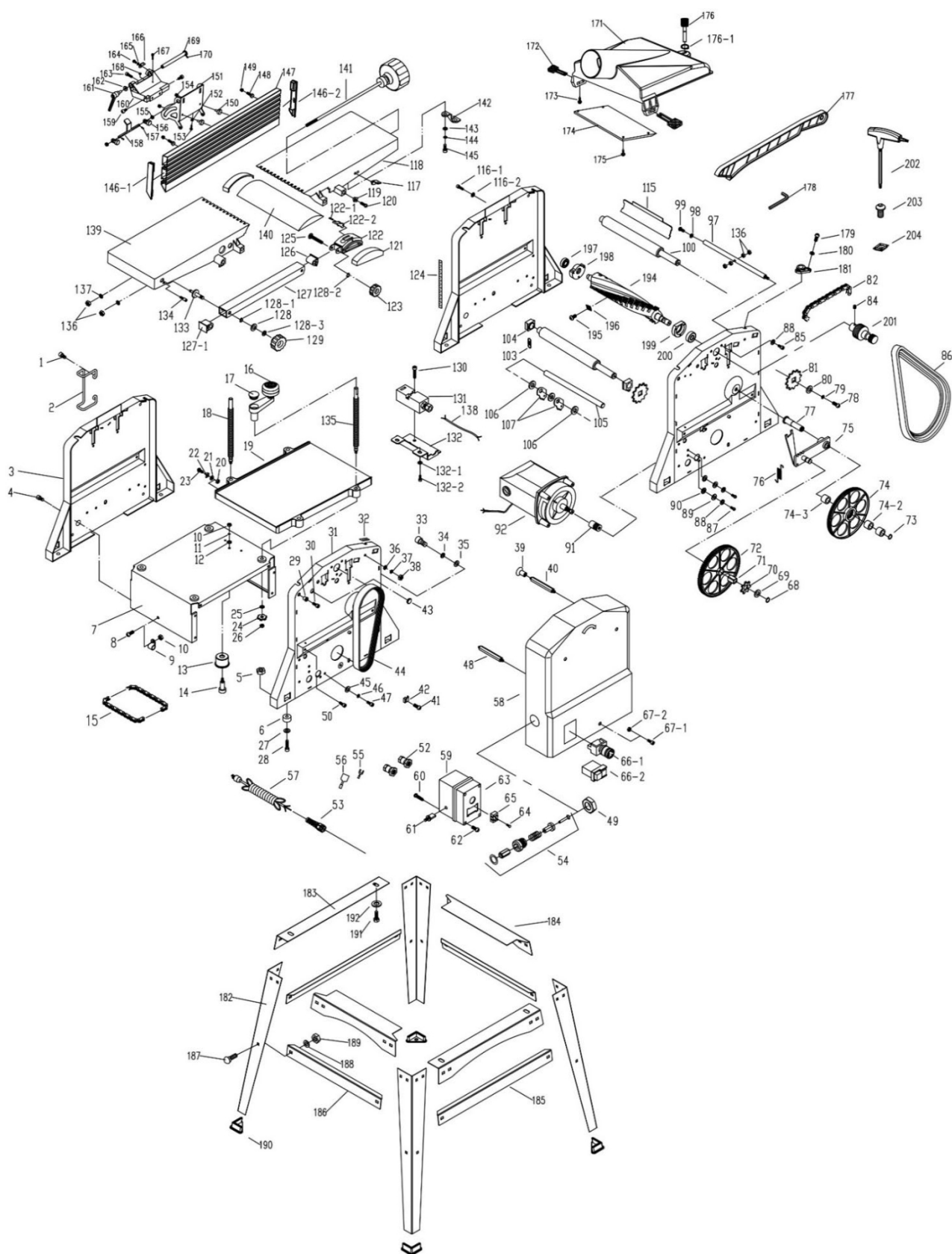
: Machine protection rating

C. Maintenance



: Instructions to follow during maintenance

9 VUE ÉCLATÉE



Reference	Description	Quantity
1	M5×10 pan-head screw	4
2	Cable hook	2
3	Back plate	1
4	M5×10 pan head screw	8
5	Hex nut	4
6	Foot	4
7	Base	1
8	M5×16 pan-head screw	1
9	Cable clamp	1
10	Hex nut	2
11	5mm lock washer	1
12	5mm flat washer	1
13	Chain tension pulley	1
14	Shaft	1
15	Chain	1
16	Crank Assembly	1
17	Handle cap	1
18	Screw	3
19	Jointer table	1
20	M5 hex nut	1
21	5mm flat washer	1
22	Indicator	1
23	M5×16 pan-head screw	1
24	Sprocket	4
25	8mm flat washer	4
26	M6 lock nut	4
27	8mm flat washer	4
28	M8×12 pan head screw	4
29	Positioning sleeve	4
30	M5×20 pan-head screw	4
31A	Front plate	1
32	Ruler	1
33	M8×16 pan-head screw	1
34	8mm lock washer	1
35	8mm flat washer	1
36	8mm flat washer	1
37	Lock washer, 8 mm	1
38	M8 hex nut	1
39	Crimp nut	3
40	Hexagonal bar	2
41	M5×10 pan-head screw	5
42	Cable clamp	5
43	Rubber sleeve	2
44	Belt	1
45	5mm flat washer	4
46	Lock washer, 5 mm	4
47	Pan-head screw	4
48	Hexagonal bar	1
49	M14 hex nut	1
50	M5×6 pan-head screw	4
51	Clamp	1

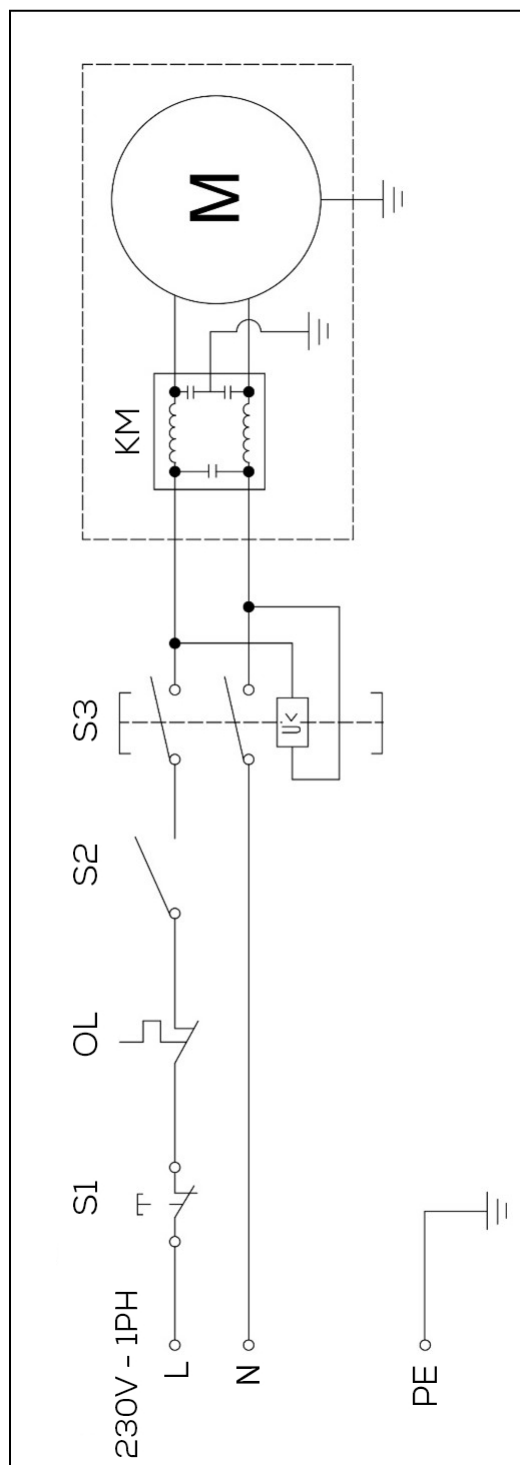
52	Sleeve	2
53	Socket	1
54	Reset button assembly	1
55	Quick connector	4
56	Insulating sleeve	4
57	Power cord	1
58	Lid	1
59	Rear switch box	1
60	Self-tapping screw	2
61	Circuit breaker	1
62	Self-tapping screw	4
63	Front switch box	1
64	Self-tapping screw	2
65	Terminal block	1
66-1	Emergency stop button	1
66-2	Main switch	1
67-1	Pan head screw	3
67-2	Lock nut	3
68	9mm retaining ring	1
69	Flat washer	1
70	Sprocket	1
71	Square bushing	1
72	Gear	1
73	12mm retaining ring	1
74	Pulley with sprocket	1
74-2	Bushing	1
74-3	Needle bearing	2
75	Mounting plate assembly	1
76	Spring	1
77	Shaft	1
78	M6×10 pan-head screw	2
79	6mm lock washer	2
80	6mm flat washer	2
81	Sprocket	2
82	Chain	1
84	M6×8 set screw	2
85	M5×12 pan-head screw	3
86	Belt	1
87	M5×10 pan-head screw	2
88	5mm lock washer	2
89	5mm flat washer	2
90	5mm serrated washer	2
91	Motor pulley	1
92A	Motor	1
97	Rod	1
98	8mm flat washer	1
99	M8×12 pan head screw	1
100	Feed roller	2
103	Spring	3
104	Bearing housing	5
105	Shaft	1
106	Spacer	27

107	Check valve	26
115	Flap	1
116-1	M5×10 pan-head screw	3
116-2	5mm lock washer	3
117	Indicator	1
118	Input table	1
119	Guide Sleeve	4
120	M5×20 pan-head screw	4
121	Protective cover	2
122	Protective bracket	1
122-1	Pin	1
122-2	Button	1
123	Button	1
124	Scale	1
125	Square-head bolt	1
126	Arm cap	1
127	Support arm	1
127-1	Cap	1
128	10mm flat washer	1
128-1	8mm circlip	1
128-2	6mm circlip	1
128-3	8mm lock washer	1
129	Knob	1
130	M4×25 pan-head screw	2
131	Safety switch	1
132	Switch mounting plate	1
132-1	5mm flat washer	4
132-2	M5×8 pan head screw	4
133	Shaft	1
134	Pin	1
135	Lifting screw	1
136	M6 hex nut	2
137	6mm lock washer	2
138	Inner wire	1
139	Output table	1
140	Knife block protection	1
141	Table adjustment screw	1
142	Mounting plate	1
143	5mm flat washer	2
144	Lock washer, 5 mm	2
145	M5×12 pan-head screw	2
146-1	Guide cover A	1
146-2	Guide cover B	1
147	Guide	1
148	M8×10 Hex Head Bolt	2
149	M8 lock nut	2
150	Guide screw	2
151	Corner bracket	2
152	M6 hex nut	1
153	M6×20 pan-head screw	1
154	M5 lock nut	2
155	Locking block	2

156	Guide screw	2
157	Pin	2
158	Locking handle	2
159	Positioning screw	2
160	Guide support base	1
161	Locking handle	1
162	6mm flat washer	1
163	M5×20 pan-head screw	2
164	M4×8 round-head screw	1
165	4mm flat washer	1
166	Indicator	1
167	Cylinder-head screw	1
168	M5 hex nut	1
169	Rod	1
170	Pin	1
171	Dust chute	1
172	Wrench	2
173	Self-tapping screw	2
174	Dust chute cover	1
175	Self-tapping screw	4
176	Knob	1
176-1	6mm circlip	1
177	Safety push pin	1
178	Allen wrench	1
179	M4×8 pan-head screw	2
180	4mm flat washer	2
181	Guide block	1
182	Base	4
183	Long frame	2
184	Short frame	2
185	Long spacer	2
186	Short spacer	2
187	Square-head bolt	24
188	6mm flat washer	24
189	M6 hex nut	24
190	Foot	4
191	M8×30 Hex Head Bolt	4
192	8mm flat washer	4
194	Helical knife block	1
195	Insert screw	24
196	Carbide insert	24
197	6001-2RS ball bearing	1
198	Rear bearing housing	1
199	Front bearing housing	1
200	6002-2RS ball bearing	1
201	Spindle pulley	1
202	Torx wrench	2
203	Insert screw	5
204	Carbide insert	5

10 SCHÉMA ÉLECTRIQUE

PRD254HC ELECTRICAL DIAGRAM



S1: Momentary-action stop switch OL:
Overload protection S2: Safety switch
S3: Main switch KM: Filter
M: Motor

11 NIVEAU SONORE

The noise level emitted by this machine during operation depends on the type of material being ground and the type of grinding wheel. For this reason, the measurement data are relative.

The risk of hearing damage to the operator depends on the duration of exposure to noise.

The operator must wear ear protection or other appropriate personal protective equipment when the sound power level exceeds 85 dB(A) in the workplace.

- Average sound pressure level:
LpAm = 97.1 dB(A)
- Sound power level:
LwA = 110.1 dB(A)

The calculation of sound power was performed taking into account factors such as: reverberation in the test area, noise absorption by the floor, and other factors that may interfere with the measurements. This estimate indicates that, based on the obtained values, the margin of error is approximately 3 dB(A).

The values provided are emission levels and do not necessarily represent levels that allow for safe working conditions. Although there are correlations between emission levels and exposure levels, these cannot be reliably used to determine whether additional precautions are necessary. Factors influencing actual exposure levels include workshop characteristics, other noise sources, etc., such as the number of machines and nearby manufacturing processes. Furthermore, permissible exposure limits may vary from country to country. However, this information enables the machine operator to better assess the risks.



12 NIVEAU VIBRATIONS

The vibration data transmitted by this machine during operation will depend on the type of material being ground and the type of grinding wheel. For this reason, the measurement data are relative.

Exposure to vibrations can have serious consequences for a worker's health. A person exposed daily to high-amplitude vibrations may develop neurological and joint disorders over the long term. These values must be taken into account when assessing the level of exposure.

Regular and frequent exposure to a highly vibrating power tool exposes workers' hands and arms to chronic disorders known as "vibration syndrome."

- Average hand/arm vibration level:
A(8) < 2.5 m/s²

The assessment of the exposure level is based on the calculation of the daily exposure value A(8), normalized to an 8-hour reference period.

Whenever an employee is exposed to A(8) vibrations exceeding the daily exposure action level of 2.5 m/s², the employer must assess the risks associated with the employee's assigned task and implement control measures.

Exposure values for vibrations transmitted to the hand-arm system:

- Daily exposure limit value A(8) = 5 m/s²
- Daily action-triggering exposure value A(8) = 2.5 m/s²

13 PROTECTION DE L'ENVIRONNEMENT

Your machine contains many recyclable materials.

This logo indicates that used machines must not be mixed with other waste.

This ensures that machines are recycled under optimal conditions, in accordance with the European Directive 2012/19/EU on Waste Electrical and Electronic Equipment (WEEE).

Contact your local city hall or your dealer to find out where the nearest collection points for used machines are located near your home.

Thank you for your cooperation in protecting the environment.



14 GARANTIE

If the machine is covered under warranty, repairs must be performed exclusively by an authorized service center. The machine's warranty is valid for 2 years from the date of purchase by the user.

This product comes with a 2-year extended warranty, provided that the user registers the product on the PEUGEOT OUTILS PROFESSIONNELS website (www.peugeot.outils-pro.com) within 30 days of the purchase date. This extended warranty is subject to the same terms and conditions as the original warranty.

Accessories and consumables are not covered by the warranty.

It is important to keep the receipt, which serves as the warranty certificate.

The warranty is limited to the free repair or replacement of defective parts, following an assessment by the manufacturer.

For any requests for information or replacement parts related to the machine, you must provide the exact information listed on the nameplate.

The warranty does not cover damage caused by the user or by a repair technician not authorized by Tivoly.



Link to the General Warranty Terms and Conditions:

CE “ORIGINAL” DECLARATION OF CONFORMITY

The undersigned (Manufacturer/Importer):

TIVOLY

266 ROUTE PORTES DE TARENTEISE 73790 TOURS-EN-SAVOIE

Hereby declares that the following new machine:

- Description: **PLANER AND JOINTER**
- Brand: **PEUGEOT PROFESSIONAL TOOLS**
- Model: **PRD254HC**
- Part Number: **PPM00600001**
- Serial No.:

Complies with applicable harmonized legislation:

- **Machinery Directive 2006/42/EC (until January 19, 2027)**
- **EU Regulation 2023/1230 (effective January 20, 2027)**
- **EN ISO 19085-1 Safety Standard for Woodworking Machinery**
- **Safety standard for combined planer/jointer machines EN ISO 19085-7**

Complies with the applicable essential safety requirements:

- **Low Voltage Directive 2014/35/EU**
- **Electromagnetic Compatibility Directive 2014/30/EU**
- **WEEE Directive 2012/19/EU**
- **RoHS-2 Directive 2011/65/EU**
- **REACH Regulation 1907/2006**
- **Noise Directive 2003/10/EC**
- **Vibration Directive 2002/44/EC**

This product is covered by an EC type-examination certificate in accordance with the Machinery Directive 2006/42/EC, issued by the notified body TÜV Rheinland (No. 0197).

The EC type-examination certificate bears the number 15006194046.

Dated in TOURS-EN-SAVOIE
The

Stéphane Le Mounier, Chief
Executive Officer



Person authorized to compile the technical file:

- **Mr. LE MOUNIER – TIVOLY – 266 ROUTE PORTES DE TARENTEISE 73790 TOURS-EN-SAVOIE**

	TIVOLY: Corporate Headquarters: 266 ROUTE PORTES DE TARENTEISE 73790 TOURS-EN-SAVOIE www.peugeot-outils-pro.com In its ongoing effort to improve the quality of its products, TIVOLY reserves the right to modify their specifications. The information, photos, exploded views, and diagrams contained in this document are not binding.	CUSTOMER SERVICE Phone: +33(0)4 79 89 59 00 June 2026 Edition Manual PRD254HC
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