



# Model 0006 6" Jointer Owner's Manual



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## SAFETY INSTRUCTIONS

For Your Safety Read Instruction Manual Before Operating Jointer

As with all machines, there is a certain amount of hazard involved with the use of this jointer. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

**Wear eye protection.**

**Always keep** cutter head and drive guards in place and in proper operating condition. Do not remove guard for rabbeting operations.

**Never make** jointing , planning, or rabbeting cut deeper than 1/8 in.

**Always use** hold-down/push blocks for jointing material narrower than 3 inches, or planning material thinner than 3inches.

**Never perform** jointing. Planning, or rabbeting cuts (with jointers provided with a rabbeting guard) on pieces shorter than 8 inches (203 mm) in length.

**Keep guards in place and** in working order.

**Remove adjusting keys and wrenches.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on .

**Keep work area clean.** Cluttered areas and benches invite accidents.

**Don't use in dangerous environment.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

**Keep children away.** All visitors should be kept safe distance from work area.

**Make workshop kid proof** with padlocks, master switches, or by removing starter keys.

**Don't force tool.** It will do the job better and safer at the rate for which it was designed.

**Use right tool.** Don't force tool or attachment to do a job for which it was not designed.

**Use proper extension cord.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating Table (see Figure 9) shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

**Wear proper apparel.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.

**Always use safety glasses.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

**Secure work.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.

**Don't overreach.** Keep proper footing and balance at all times.

**Maintain tools with care.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

**Disconnect tools** before servicing; when changing accessories, such as blades, bits, cutters, and the like.

**Reduce the risk of unintentional starting.** Make sure switch is in off position before plugging in.

**Use recommended accessories.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.

**Never stand on tool.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.

**Check damaged parts.** Before further use of the tools, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

**Direction of feed.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

**Never leave tool running unattended. Turn power off.** Don't leave tool until it comes to a complete stop.

**Do not** perform jointing operation on material shorter than 8 in, narrower than 3/4 in, or less than 1/4 in thick.

**Do not** perform planing operation on material shorter than 8 in, narrower than 3/4 in, or wider than 6" in or thinner than 1/2 in.

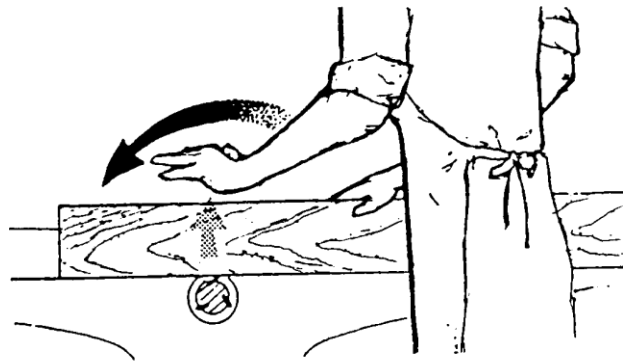
**Maintain** the proper relationships of infeed and outfeed table surfaces and cutter head knife path.

**Support** the work piece adequately at all times during operation; maintain control of the work at all times.

**Do not back** the work toward the infeed table.

**Do not attempt** to perform an abnormal or a little-used operation without study and the use of adequate hold-down/push blocks, jigs, fixtures, stops and the like.

**Hand safety.** It is good practice to move the hands in an alternate motion from back to front as the work continues through the cut. Never pass the hands directly over the cutter knife. As one hand approaches the knives remove it from the stock in an arc motion and place it back on the stock in a position beyond the cutterknife.



**Three inch rule.** When working a piece of wood on the jointer, follow the 3 inch radius rule. The hands must never be closer than 3 inches to the cutter head.

**Health hazards.** Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- \* Lead from lead-based paint.
- \* Crystalline silica from bricks and cement and other masonry products.
- \* Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

**Familiarize yourself with the following safety notices used in this manual:**



**CAUTION:** (This means that if precautions are not heeded, it may result in minor or moderate injury and/or possible machine damage)



**WARNING:** (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

## Receiving the Jointer

Upon delivery, open the shipping container and check that all parts are in good condition. If you discover any damage or shortage report it to your dealer immediately. Keep all crates and packing until the machine is assembled and in working order. Before proceeding with assembly, adjustments, and operation, familiarize yourself with the machine by reading this manual. If you have any questions, contact your dealer or Oliver Machinery technical service at 888-559-5065.

**Warning:** This machine is very heavy and requires two people to safely assemble and move it. Do not do this alone as it could lead to personal injury.

## Installation of Stand Assembly

Identify the following parts and prepare them to assembly the stand.

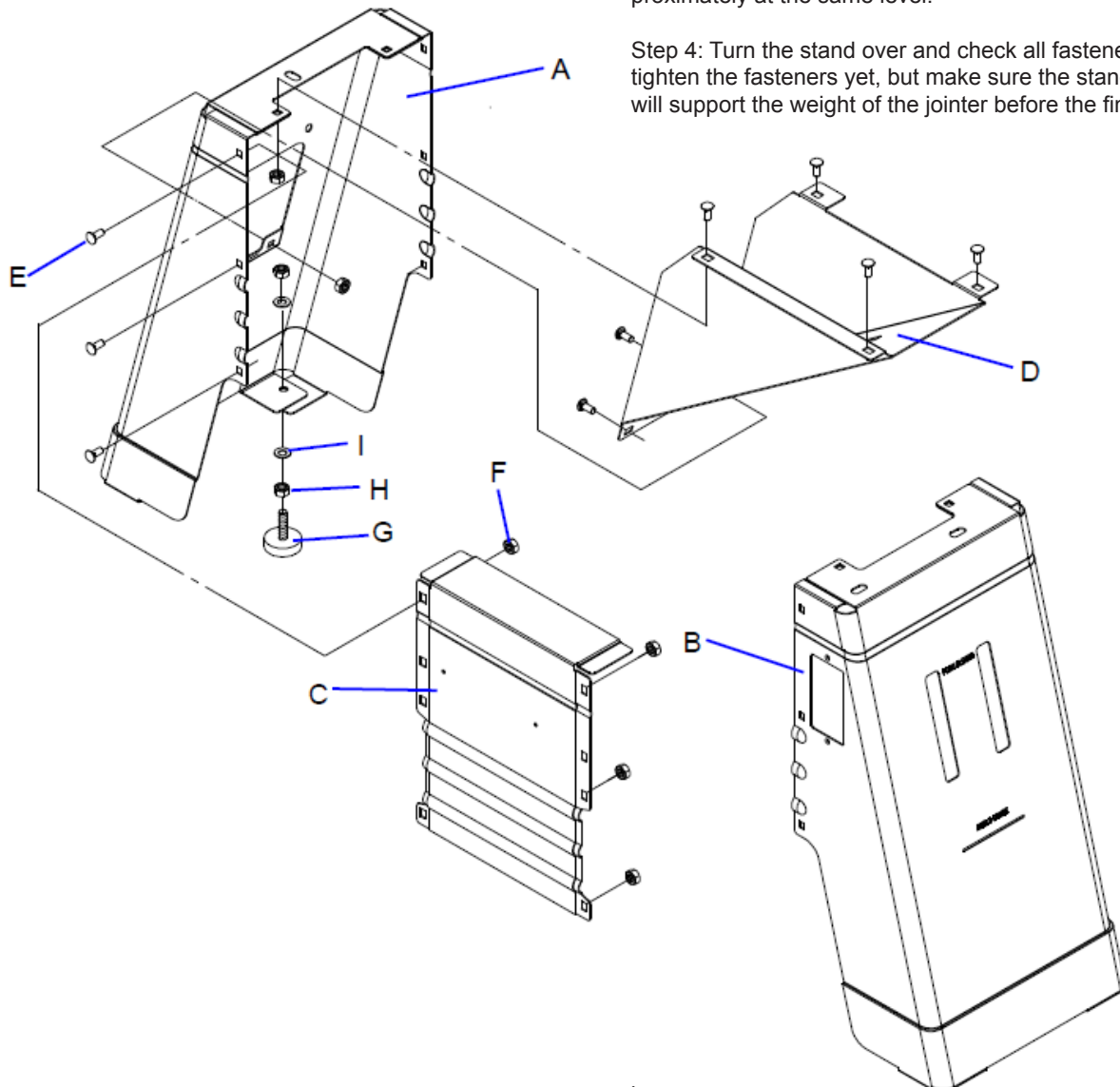
A: Stand-Left.....	1
B: Stand-Right.....	1
C: Front Panel.....	1
D: Motor Bracket.....	1
E: Shoulder Bolt 5/16" x 1/2".....	12
F: Hex Nut 5/16".....	12
G: Leveling Foot.....	4
H: Hex Nut 3/8".....	8
I: Flat Washer 3/8".....	8

Step 1: Assemble Stand-Left (A), Stand-Right (B) and Front Panel (C) with Shoulder Bolts (E) and Hex Nuts (F). Finger tighten only at this time.

Step 2: Mount Motor Bracket (D) in the stand assemble from step 1 using the Shoulder Bolts (E) and Hex Nuts (H). Finger tighten only at this time.

Step 3: Carefully turn the stand assembly over (upside down) and place on a protected surface. Install the Leveling Foot (G) on each corner using two Hex Nuts (H) and two Flat Washers (I) on either side on the flange of the stand. Adjust so each foot is approximately at the same level.

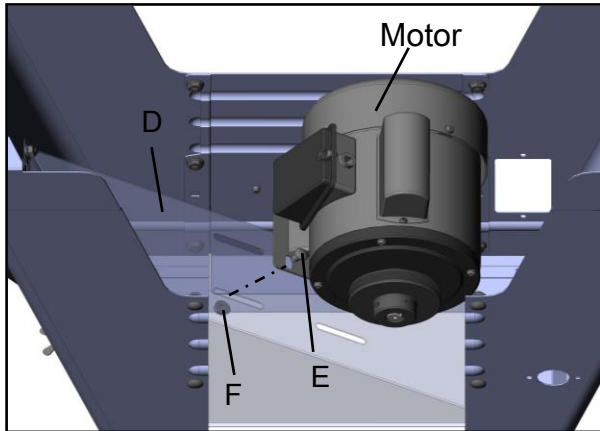
Step 4: Turn the stand over and check all fasteners. Do not fully tighten the fasteners yet, but make sure the stand is ridged as it will support the weight of the jointer before the final tightening.



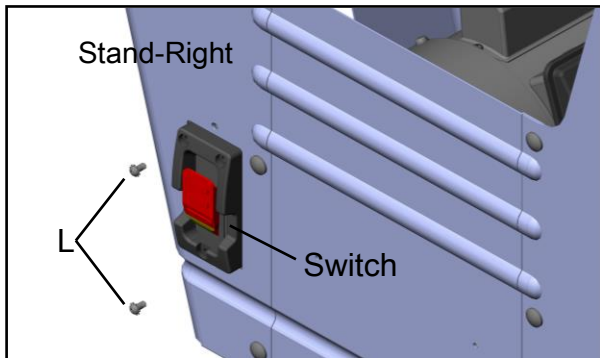
### Installation Motor & Switch

Step 4: Put the motor & switch assembly on the Motor Bracket (D) and lock by Shoulder Screw (E)\*4 & Hex. Nut (F)\*4 but not tighten all screws.

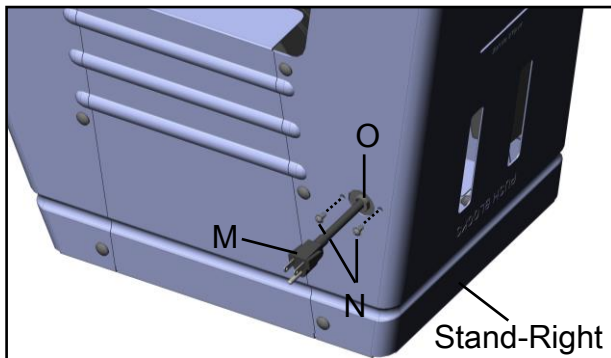
**Warning:** The motor & switch assembly is heavy. **Do not** assemble motor by yourself; ask someone to help is required.



Step 5: Place the switch into the rectangle hole on stand-right and tighten by 2 Round Head Phillips screw w/teeth washer (L)



Step 6: The plug (M) need to pass through the round hole on the stand-right and fix the power Fixing plate (O) by Round Head Phillips screw w/flat washer (N)\* 2

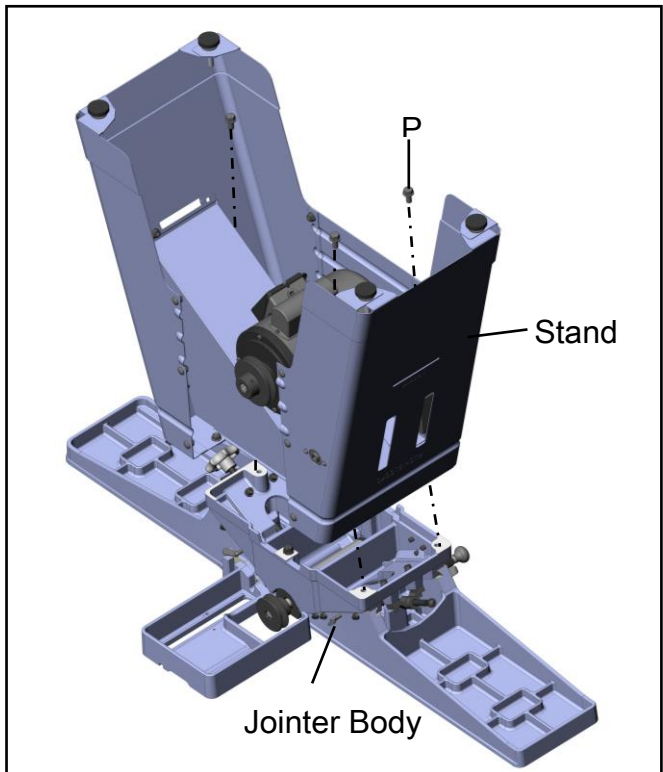


### Installation Joints Body & Stand

Step 7: Put a large clean carton board or plastic paper on the floor to protect the jointer table top surface.

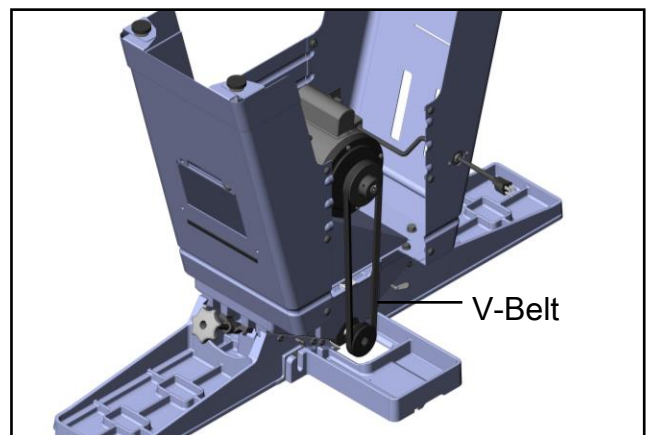
Step 8: Turn over the jointer Body then put the stand of step 6 to the jointer base by 3 Hex. Screw w/washer 3/8" x16NCx3/4" (P) but not tighten all screws

**Warning:** The jointer body & stand are heavy. Be careful and asking help when needed.



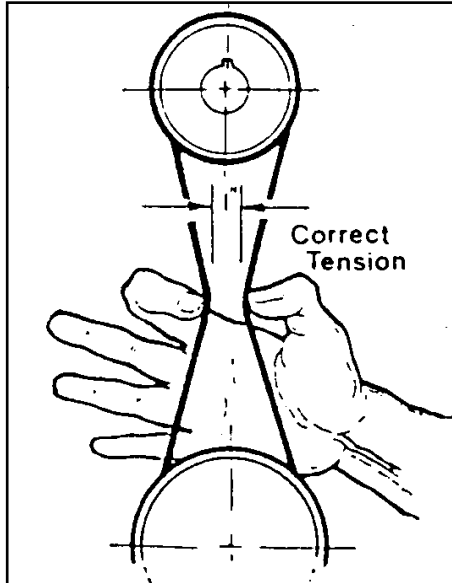
### Installation V-Belt

Step 9: To attach the V-belt over cutterhead pulley and motor pulley.



## Checking Belt Tension

Step 10: Pull down on the motor to achieve the desired belt tension (the correct belt tension is achieved when the belt can be deflected approximately one inch at the center belt span using light finger pressure) Snug tight the 4 Shoulder Screw (E) & Hex. Nut (F).

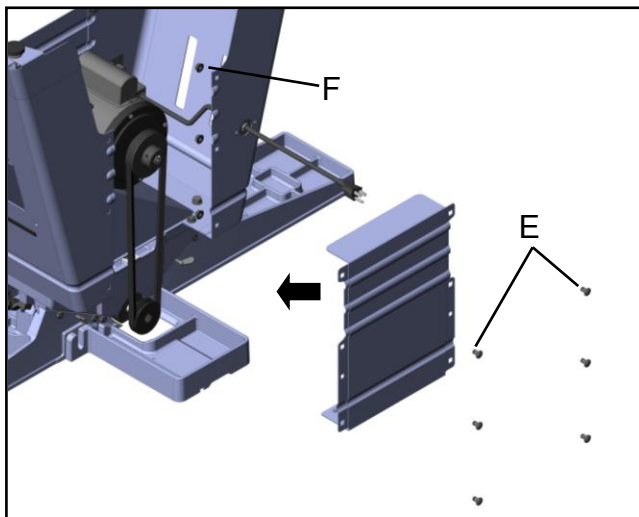


## Installation Rear Panel

Step 11: Assemble the rear panel after the V-belt adjustment with 3 Shoulder Screw (E) & Hex. Nut (F) then tighten all of screws on the stand assembly.

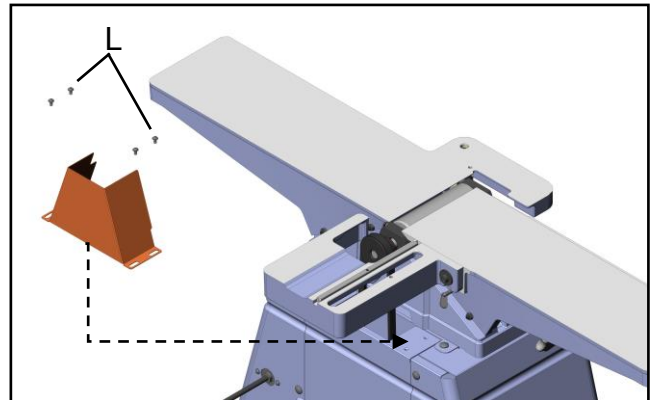
Then Turn over the jointer .

**Warning:** The jointer with stand is heavy. Be careful and asking help is required.



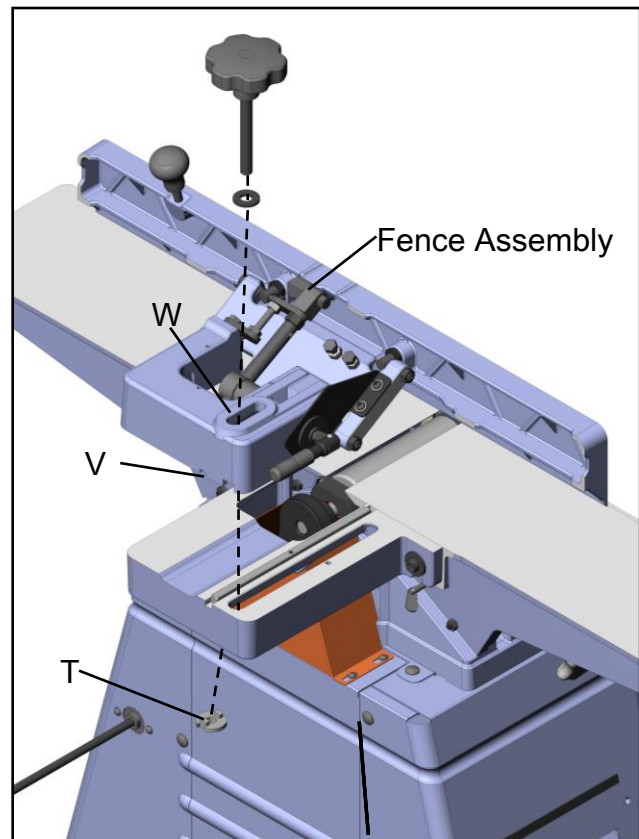
## Installation Pulley Cover

The pulley cover is mounted with 2 Round Head phillips screw w/teeth washer (L) to the threaded holes in the Stand.



## Installation Fence

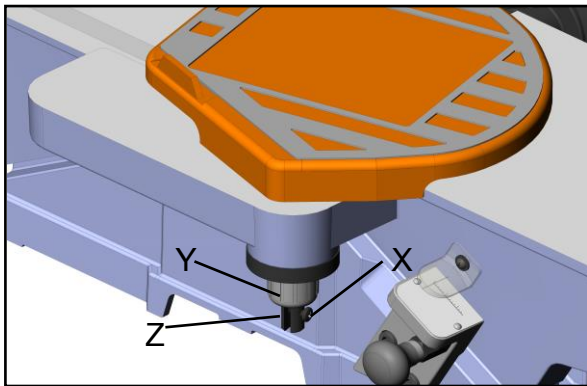
1. Take the lock Knob (R), flat washer (S), and lock nut (T) from the hardware bag..
2. Place the Key (U) on the Fence bracket slot then put the fence assembly onto the table (B) Be sure the key stock (U) on the bed lines up with the channel (V) in the fence casting.
3. Place the flat washer (S) on slot (W); insert the lock Knob (R) through the fence casting and the table casting.
4. Thread the lock nut (T) onto the lock Knob (R). Make sure the tab on the nut faces up and engages the slot in the table casting.



## Installation Blade Guard & Removal

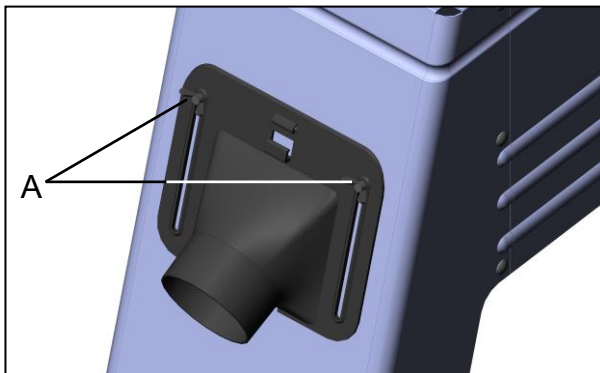
**WARNING:** Use the jointer guard for all operations. Do not connect the plug to power source

1. Loosen the Round Head phillips screw (A) from guard post (Z)
2. Turn knob (Y) counterclockwise to create tension on spring, and hold it there.
3. Insert guard post (Z) down through hole in front of ledge.
4. Slightly turn knob (Y), if necessary, until the guard seats itself, and the spring engages the slot at the end of the guard post.
5. Check the guard for proper tension. If guard does not spring back into place when pulled back from cutterhead, remove guard and adjust spring tension by repeating steps 1-3 until correct tension is achieved. NEVER run the jointer without the guard being in place and in perfect working order.
6. Tighten the Round Head phillips screw (A) from guard post (Z)



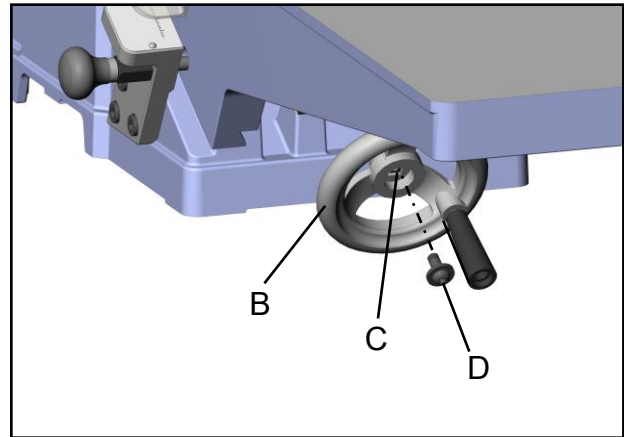
## Installation Dust Chute

Mount the dust chute to the pre-tapped holes in the side of the stand with 2 wing screws (A).



## Installation Handwheel

Slip the handwheel (B) onto the elevation shaft (C) (under the infeed table) then tighten with the Round Head phillips screw w/washers (D)

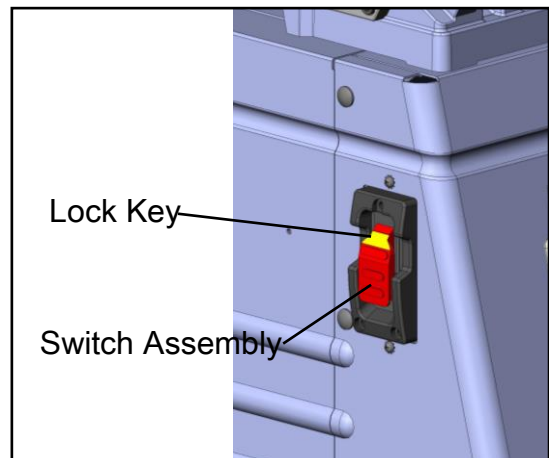


Installations are completed.

## Safety Switch

This Jointer has a rocker style switch with a removable locking key to prevent unauthorized use. If you intend to be away from the machine for a long period of time and there is any chance of its use by others, especially children, Remove the lock key with the switch in the "OFF" position. Store it in a safe, inconspicuous place in your workshop. To turn the planer on, insert the red locking key and turn the switch to the ON position. The planer will then be operable. To turn the planer off, turn the switch to the "OFF" position.

**WARNING:** Always be sure the switch is in the "OFF" position before connecting the jointer to the power source.





## Grounding Instructions



**WARNING: If the machine does not come wired to run, the electrical and motor wiring must be done by a qualified electrician. The machine must be properly grounded to help avoid electrical shock and possible death. Follow the recommendations made by the National Electrical Code for grounding.**

1. All grounded, cord connected tools:  
In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green, with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately

2. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating less than 150 volts:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch A, Fig. 1. The tool has a grounding plug that looks like the plug illustrated in Sketch A.

A temporary adapter, which looks like the adapter illustrated in Sketches B and C in Fig. 1, may be used to connect this plug to a 2-pole receptacle as shown in Sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

**Note:** In Canada, the use of a temporary adapter is not permitted by the Canadian Electrical Code

3. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150-250 volts, inclusive:  
This tool is intended for use on a circuit that has an

outlet that looks like the one illustrated in Sketch D Fig. 1. The tool has a grounding plug that looks like the plug illustrated in Sketch D.

Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel and after reconnection, the tool should comply with all local codes and ordinances.

## Extension Cords

Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Fig. 2 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

## Rewiring Motor for 230Volts

When rewiring the supplied electric motor for 230 volts, be sure power cord is unplugged then change the connections as illustrated in the diagram in the motor wiring box. Always secure wire nuts with friction tape.

A new plug will be required for 230 volts as illustrated in Fig. 1, Sketch D.

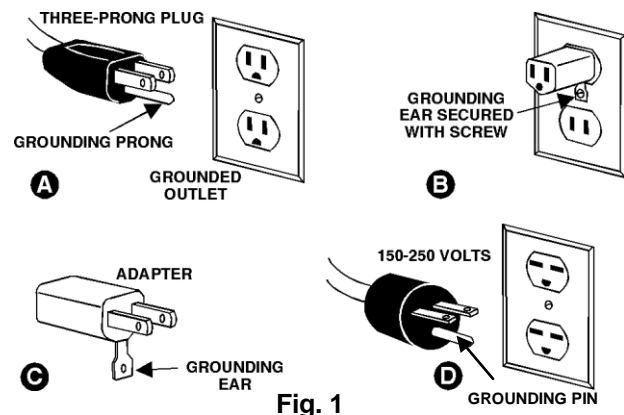


Fig. 1

**Note:** In Canada, the use of a temporary adapter is not permitted by the Canadian Electrical Code.

Ampere Rating	Volts	Total length of cord in feet			
Ampere Rating	115/230	25'	50'	100'	150'
More Than	Not More Than	AWG			
0	6	18	16	16	12
6	10	18	16	14	12
10	12	16	16	14	12
12	16	14	12	Not recommended	

Fig. 2

**Note:** The reconnection shall be made by qualified service personnel.

## Adjustments

**Warning:** Always disconnect the machine from the power source before making any adjustments..  
Failure to heed this warning can lead to serious personal injury.

**Note :** Clockwise raises the table,  
counterclockwise lowers the table.

### To adjust outfeed table

The Jointer table is adjusted at manufactory and should no further adjustment required. To align the tip of knife & outfeed table as below if necessary.

1. Loosen thumb screw (A), Fig. 3
2. Turn Knob (B) under the outfeed table.
3. Put a straight gauge (C) on the outfeed table extending over the cutter head then rotate the cutterhead by hand until the knife tip just touch the straight gauge, Fig. 4
4. When set, retighten thumb screw (A).

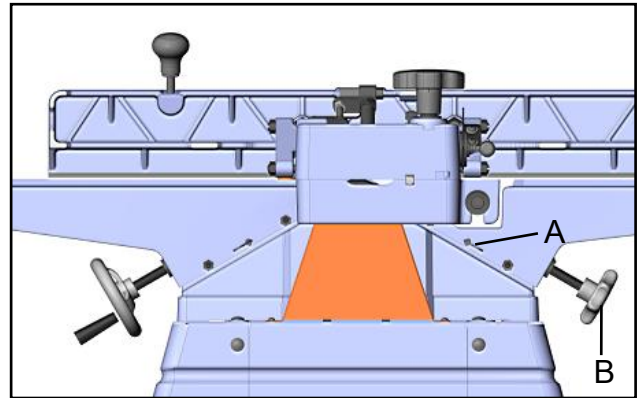


Fig. 3

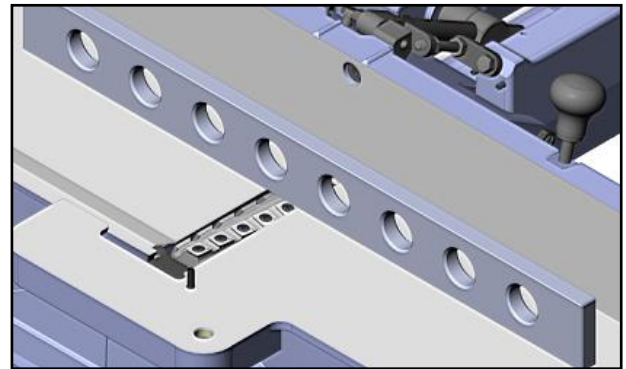


Fig. 4

### To adjust infeed table:

1. Loosen the thumb screw (D), Fig. 5
2. Place a straight gauge (C) cross the outfeed table & infeed table
3. Turn the handwheel (E) until the outfeed table & infeed table on the same level.
4. Tighten the thumb screw (D).
5. Loosen Round Head phillips screw (F), Fig.6 then adjust the pointer (G) by hand until the pointer line alignment with scale "0" .

**NOTE:** The fine adjustment handle has 1/16" travel per rotation.

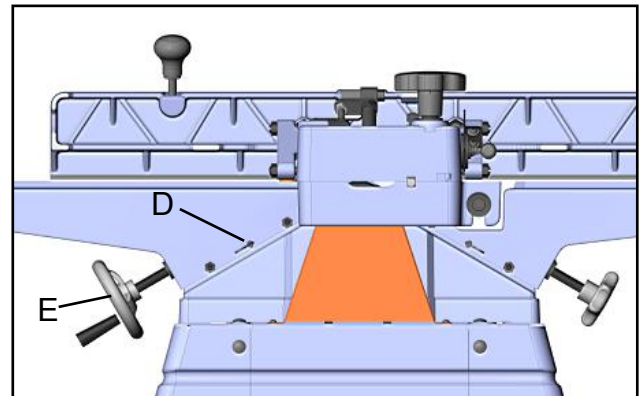


Fig. 5

**Warning:** There is a Depth Stop Limited on the back side that must be released if cutting a depth greater than 1/8".  
If hand wheel seems jammed, please check and release the Depth Stop Limiter on the front of jointer.

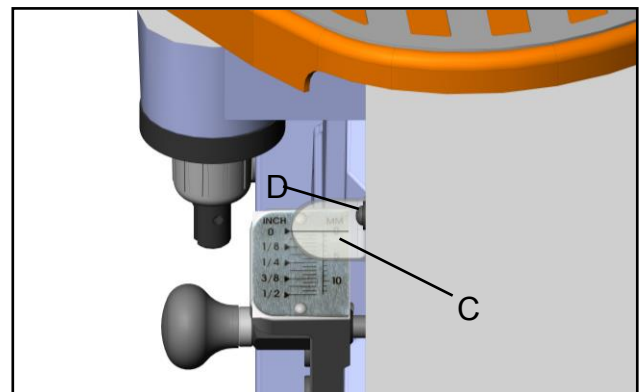


Fig. 6

## Table Gibs and Leveling

The table gibs on your machine are factory adjusted and may never require readjustment.

Should any adjustment become necessary, do the following:

1. Lightly loosen the 2 wing screw (A), Fig. 7. By loosening 6 lock nuts (B) then tighten 6 Set screws (C), should be loose enough to move the table.
2. Tighten 2 Wing screws
3. Support the end of the table and at the same time, raise it up slightly. Snug the gib screws. Any adjustment of the gibs is very minute, perhaps even 1,000th of an inch. If the gibs are too tight the adjustment handles will be difficult to turn. If the gibs are too loose the tables could sag. Keep checking the level of the tables with a straightedge until leveling is achieved. When tables are level, tighten the lock screws.

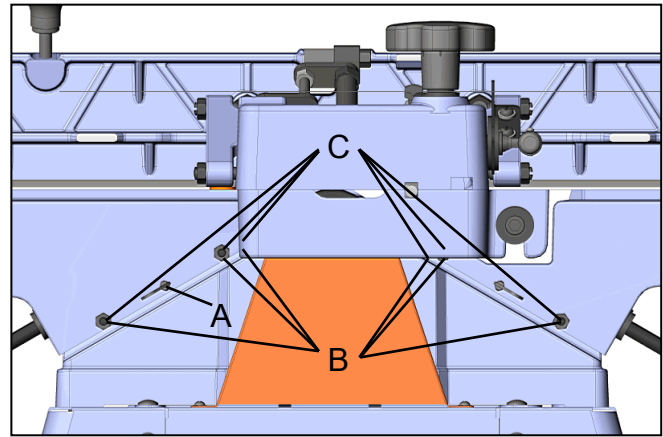


Fig. 7

**Warning:** It is recommended that another person hold and support the table when performing these adjustments.

## Fence Adjustments: Tilt

Fence adjustments are made with the lock knob (D) shown in Fig. 8

To slide the fence forward or back on the table, loosen lock knob (D), slide the fence to the desired position and tighten lock knob (D) to secure fence.

To tilt the fence **forward**:

1. Loosen locking handle (E), Fig. 8
2. Place a machinist protractor or triangle on the table and against the fence. Adjust the fence to the desired angle and tighten locking handle (E) to secure the fence.

To tilt the fence **back**:

1. Loosen locking handle (E), Fig. 8
2. Flip back the stop block (F).
3. Adjust the fence to the desired angle and tighten locking handle (E) to secure fence.

**Caution:** When the jointing operation is finished with the fence tilted back, do not forget to flip the pivot stop block back to its original position.

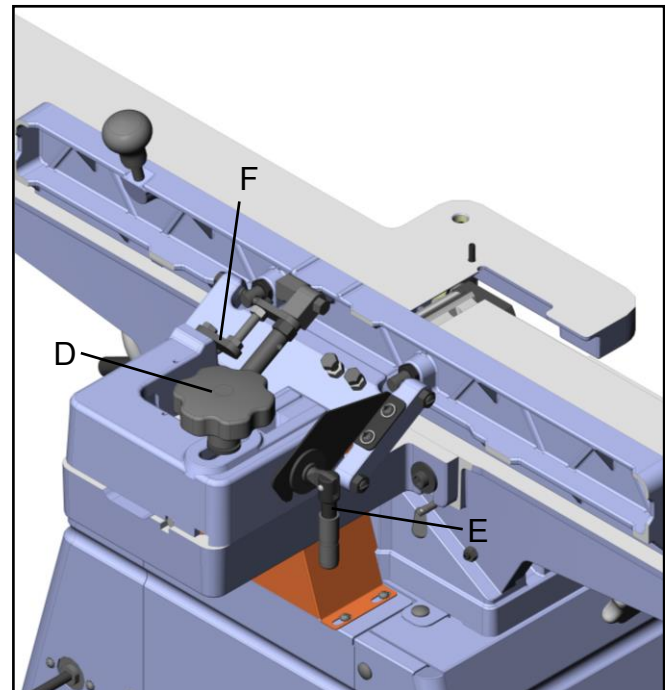


Fig. 8

**NOTE:** The lock knob (D, Fig. 8) can be adjusted to a more convenient position by loosening the nuts on its opposite end, turning the handle to the proper position, and retightening the nuts.

## Fence Stop Adjustments

Periodically check the 90° and 45° backward (135°) tilt accuracy of the fence with an angle measuring device, such as an adjustable square or machinist's protractor.

### 90° Fence Adjustment

Referring to Fig. 9 :

The 90° stop is controlled by the stop bolt (A) and the stop plate (B).

1. Set the infeed table to approximately the same height as the outfeed table.
2. Move the fence by releasing lock knob (D) and pushing the fence assembly until it overlaps the tables.
3. Tighten lock knob (D).
4. Adjust the fence to a 90° angle by releasing lock handle (C).

**Note:** The stop bolt (A) should be resting against the stop plate (B).

5. Place an angle measuring device (H) Fig.10 on the table colsed to fence surface and pulling up the fence handle (G) to confirm a 90° setting then tightening the lock handle (C).
6. Loosen the hex nut (E) until the stop bolt head (A) touch stop block (F) surface.
7. Tighten the hex nut (E) to retain the setting.
8. Double check to the fence is setting square with table .

### 45° & 135° Fence Backward Stop Adjustment

Referring to Fig. 11:

**Note:** The 45° fence backward stop is controlled by the stop bolt (A) and 135° fence backward stop is controlled by the stop bolt (B).

1. Loosen the lock knob (D). Move the stop plate (E) out of the way and position the fence at the 45° or 135° angle. Make sure the fence sits against on the correct stop bolt.
2. Tighten the lock knob (D)
3. Place an angle measuring device on the table Fig. 12 and against the fence to confirm 45° & 135° setting (A Fig.27).
4. To adjust, loosen the lock nut (F) or (G) , turn the stop bolt (A) or (B) until a 45° or 135° angle is obtained.
5. Tighten the lock nut (F) or (G).
6. Double check to the fence is setting correct angel with table .

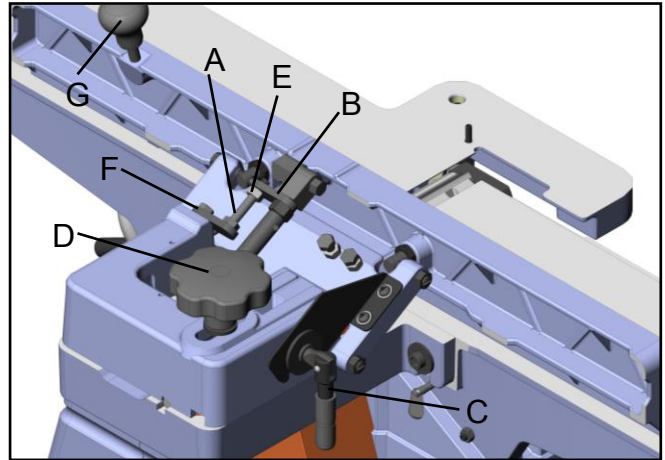


Fig. 9

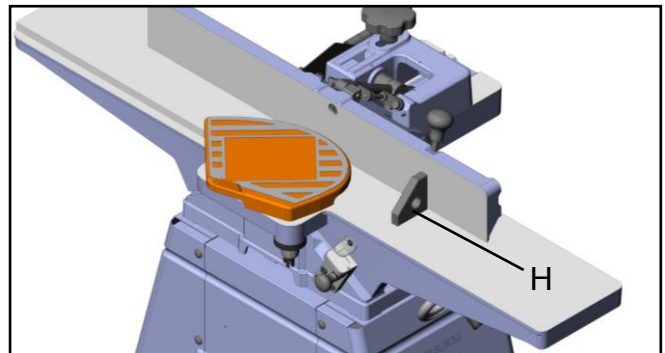


Fig. 10

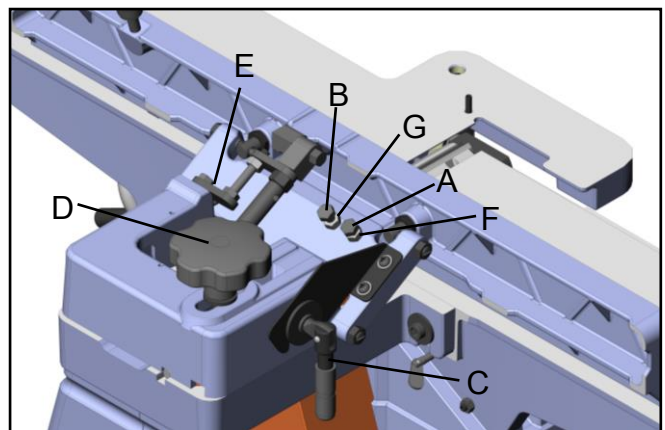


Fig. 11

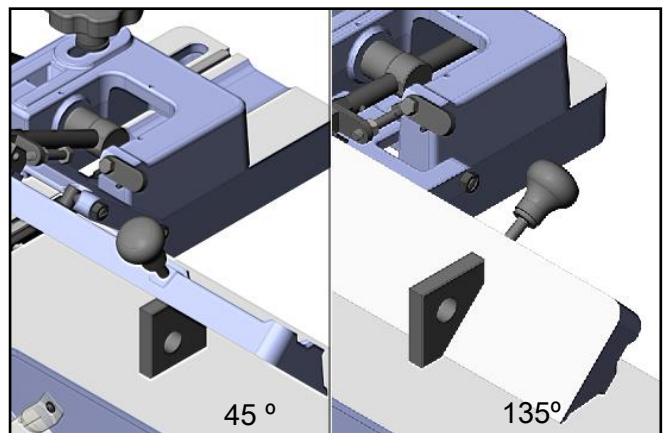


Fig. 12

## Helical Cutterhead

**WARNING:** Knife inserts are dangerously sharp. Use extreme caution when inspecting, removing or replacing knife inserts.

The knife inserts on the Jointer are four-sided. When dull, simply remove each insert, rotate it 90° for a fresh edge, and re-install it. No further adjustment is necessary. Use the two provided torx wrenches to remove the knife insert screw. Use one of the torx wrenches to help hold the cutterhead in Position, and the other to remove the screw. See Fig. 13. It is advisable to rotate all inserts at the same time to maintain consistent cutting. However, if one or more knife inserts develops a nick, rotate only those inserts that are affected.

Each knife insert has an etched reference mark so you can keep track of the rotations.

**IMPORTANT:** When removing or rotating inserts, clean saw dust from the screw, the insert, and the cutterhead platform. Dust accumulation between these elements can prevent the insert from seating properly, and may affect the quality of the cut.

Before installing each screw, lightly coat the screw threads with machine oil and wipe off any excess.

Securely tighten each screw which holds the knife inserts before operating the jointer!

**Make sure all knife insert screws are tightened securely. Loose inserts can be propelled at high speed from a rotating cutterhead, causing injury.**



FIG. 13

## Cutterhead Removal

If removal of the cutterhead is necessary, do the following:

**WARNING:** Disconnect jointer from power source.

1. Remove the entire fence assembly by releasing lock handle and removing hex nuts (see page 6) lift the fence off the machine.
  2. Loosen the bolts connecting the motor to the motor mount and remove the drive belt from cutterhead pulley (see page 5).
  3. Lower both infeed and outfeed tables to expose the cutterhead.
  4. Remove the two bolts and spring washers which secure the cutterhead to the base, as shown in Fig. 14
  5. Remove the cutterhead assembly, with studs attached, by lifting cutterhead straight up from base. The belt pulley may be left on cutterhead to assist in raising the cutterhead.
  6. Remove pulley and both bearing housings with attached studs from the cutterhead.
- NOTE:** You may wish to keep on hand an extra cutterhead in order to maintain shop productivity.
7. When mounting new cutterhead to base, make sure the curved seats of the base are cleaned and free of dust and grease.

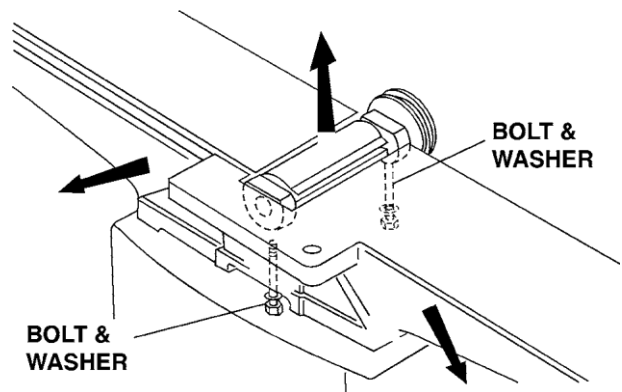


FIG. 14

## Depth of Cut

Depth of cut is determined by the height of the infeed table relative to the high point of the knives on the cutterhead.

When facing the width of a board (as opposed to the edge of a board), NEVER attempt to take off more than 1/64" with each pass.

The depth of cut is indicated by the scale located on the front of the jointer base as shown in Fig. 15.

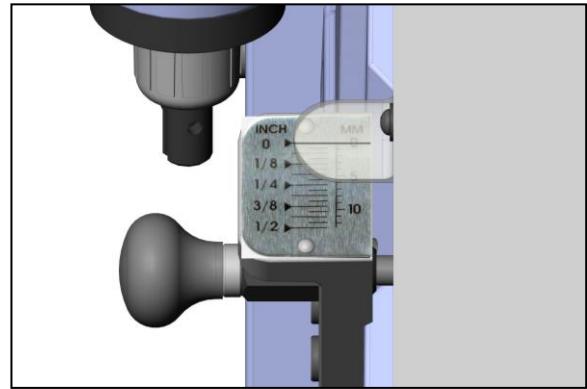


FIG. 15

## Jointing Knives

After extended use it will be necessary to sharpen the knives on the cutterhead assembly so that all knives protrude exactly the same height above the cutterhead .

To joint the knives:



**WARNING: Disconnect machine from power source. Use approved eye protection whenever sharpening blades.**

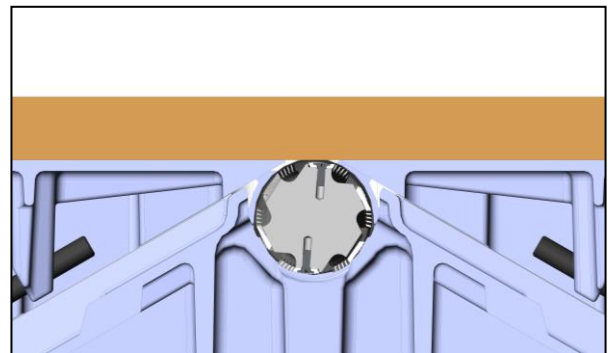


FIG. 16

1. Remove the cutterhead guard
2. Place a metal straightedge across both tables as shown in Fig.16, and make sure both tables are set to the exact height of the high point of the knives.
3. Clamp a block of wood across the infeed table as shown in Fig. 17 in order to block the end of a fine India stone or oilstone during the jointing operation. This helps to prevent kickback of the stone.
4. Turn machine on.
5. Keeping hands well clear of the cutterhead, place the stone into position as shown in Fig. 17, and slide the oilstone back and forth across both tables until the knives are lightly jointed.
6. **TURN MACHINE OFF** and visually inspect each knife. If only the high knife has been touched, lower the **OUTFEED** table 0.003" and continue the sharpening process until all three knives have been touched by the stone.
7. Replace cutterhead guard.

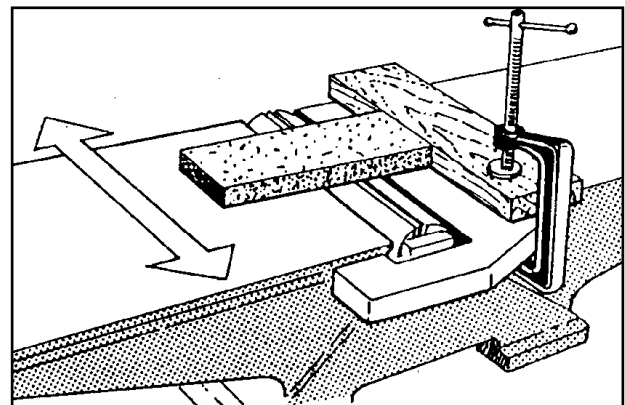


FIG. 17

## Basic Operations

Before making any cuts on the stock, make a few practice cuts by raising the infeed table to "0" and with the power disconnected. In this manner you will acquaint yourself with the feel of jointer operations.

### Surfacing

Adjust depth of cut. It is better to make cuts of approximately 1/64 inch. This will enable you to have better control over the material being surfaced. Make several passes if necessary to obtain proper stock removal.

Never surface pieces shorter than 12 inches or thinner than 3/8 inch without the use of a special work holding fixture. Never surface pieces thinner than 3 inches without the use of a push block. On stock 8" to 12" long use a single two-handed push block (Fig. 18). On stock longer than 12 inches use two push blocks (Fig. 19). With narrow stock use the type push block shown in Fig. 20. When surfacing short stock over 4 inches wide, use two (2) push blocks to guide material over cutterhead (Fig. 21).

two handed push block

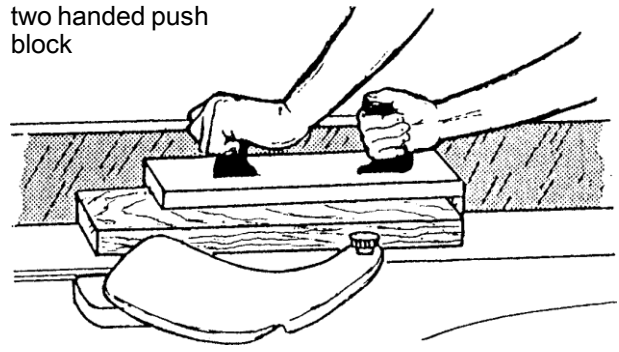


FIG. 18

two push blocks for stock longer than 12 inches

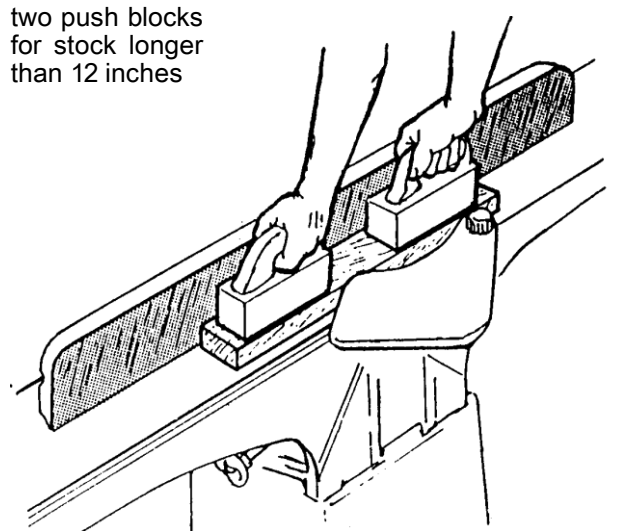


FIG. 19

L-shaped push block for narrow stock

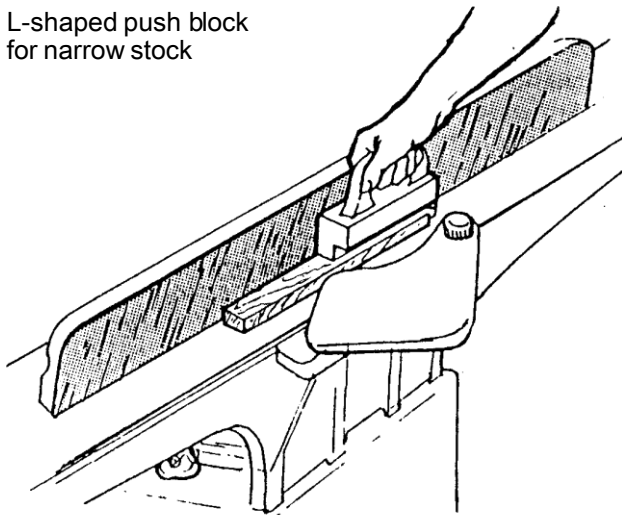


FIG. 20

two push blocks with dowels for short stock over 4 inches wide

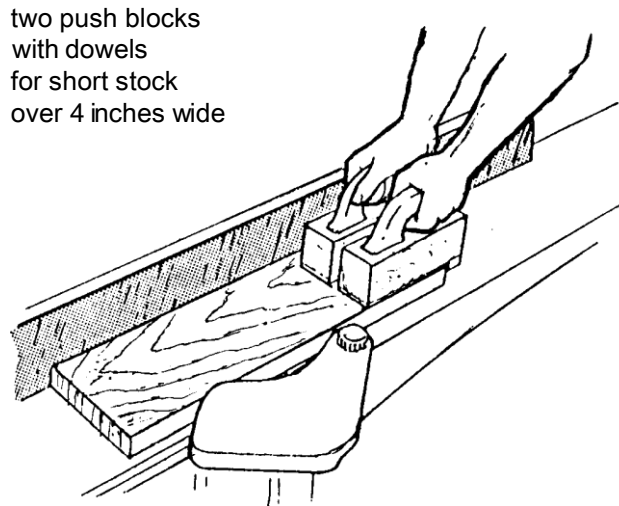


FIG. 21

## Surfacing: Long Boards

The use of push blocks will help to insure against hands coming in contact with cutterhead in the event of a kickback and as trailing end of board passes over cutterhead.

When surfacing long stock, place push block near the front of piece and start feeding wood with the right hand until guard has opened and cut is started (Fig. 22).

Place second push block near the rear of infeed table and continue feeding stock using the hand over hand method (Fig. 23).

Before the left hand is in the 3 inch area of the cutterhead move it over to the outfeed side (Fig. 24).

As soon as possible follow with the right hand over to the outfeed side and continue through with cut (Fig.25).

Begin by feeding stock with right hand and apply pressure to front of stock with push block.

When the stock is longer than twice the length of the infeed and outfeed tables, another helper or support table must be used to support the stock.

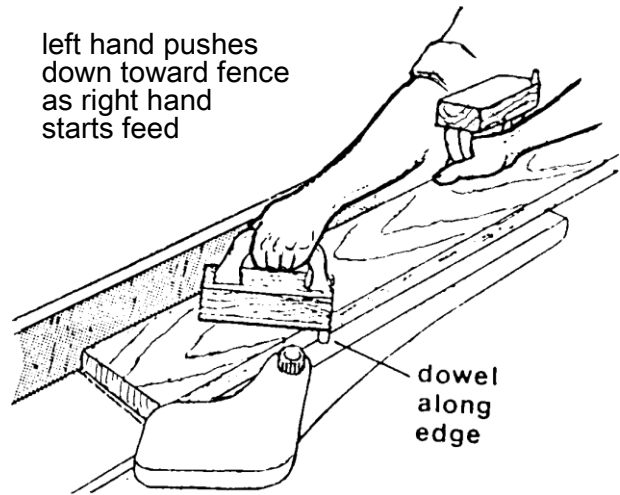


FIG. 22

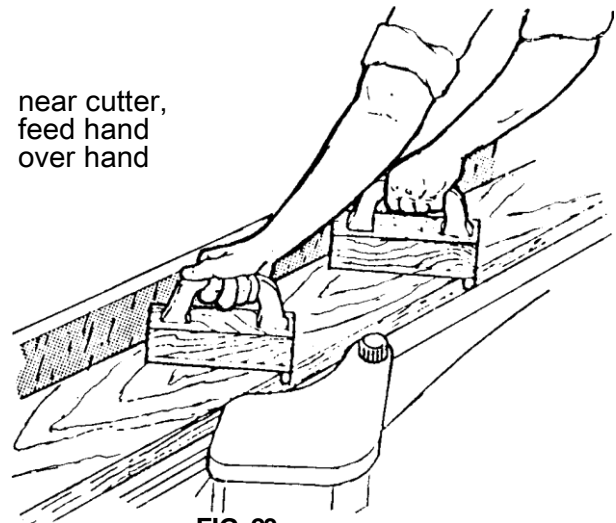


FIG. 23

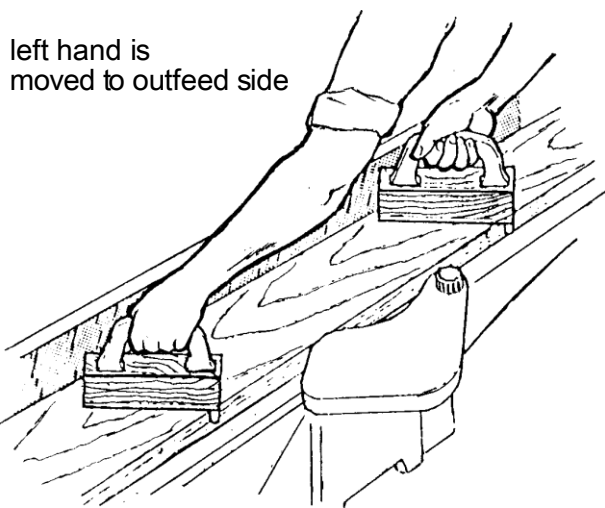


FIG. 24

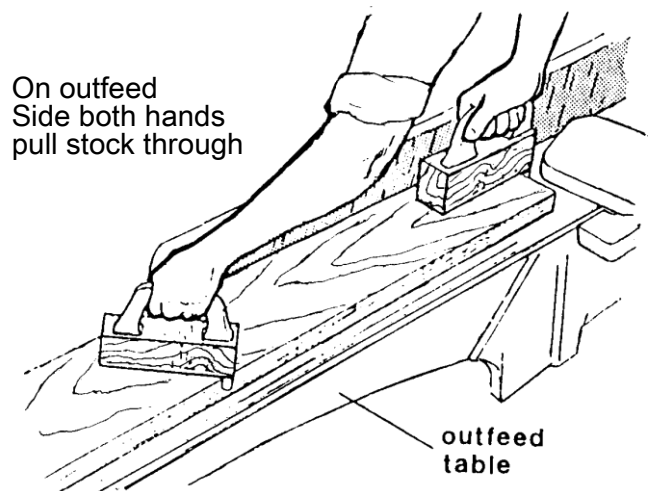


FIG. 25



## Jointing (or Edging)

Never edge a board that is less than 3 inches wide, less than 1/4 inch thick, or 12 inches long, without using a push block.

**CAUTION:** When workpiece is twice the length of the jointer infeed or outfeed table use an infeed or outfeed support.

Begin by feeding stock with right hand and apply pressure to front of stock with push block. When edging, make cuts of approximately 1/16 inch for hardwood and 1/8 inch for softwood.

When edging wood wider than 3 inches lap the fingers over the top of the wood, extending them back over the fence such that they will act as a stop for the hands in the event of a kickback. Keep stock against the fence (Fig. 26).

## Beveling

When beveling never make cut deeper than 1/16 inch. Make certain material being beveled is over 12 inches long, more than 1/4 inch thick and 1 inch wide. Set fence to desired angle.

**CAUTION:** Although fence may be tilted in or out for bevel cut, We recommends for safety reasons the fence be tilted in, if possible, making a cradled cut (Fig. 27).

For wood wider than 3 inches, hold with fingers close together near the top of the stock, lapping over the board and extending over the fence. When beveling material less than 3 inches wide, use beveled push blocks and apply pressure toward the fence. Keep fingers near top of push block (Fig. 28).

When beveling short material use one bevel hold down and apply pressure toward the fence. Keep thumb above the ledge on hold down block (Fig. 29).

## Cross Grain

**NOTE:** When beveling around four edges of a workpiece, make cross grain cuts first. This will help clean up any chipping or splintering when beveling the end grain. For long boards, follow the same hand-over-hand procedure used for surfacing long boards.

move fence forward to expose only amount of cutterhead required

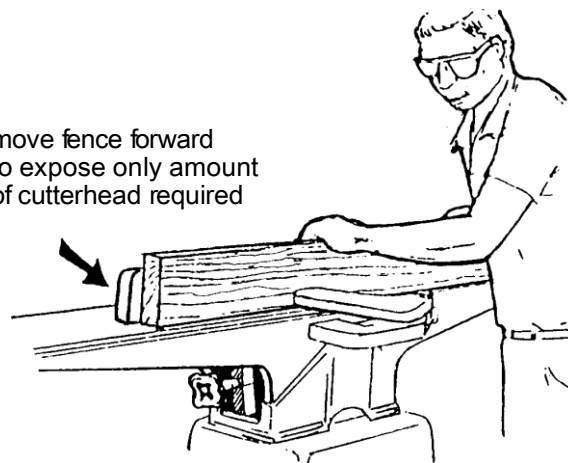


FIG.26

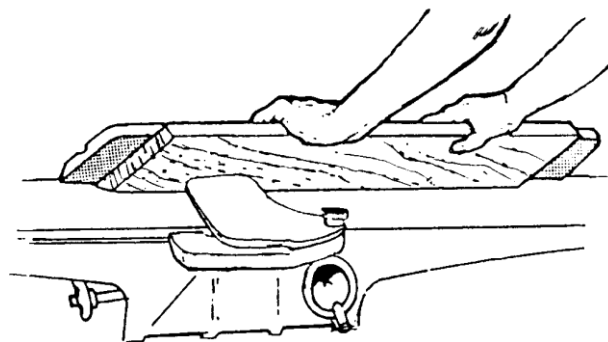


FIG. 27

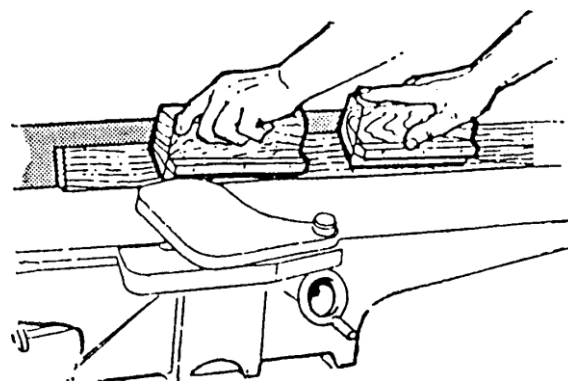


FIG. 28

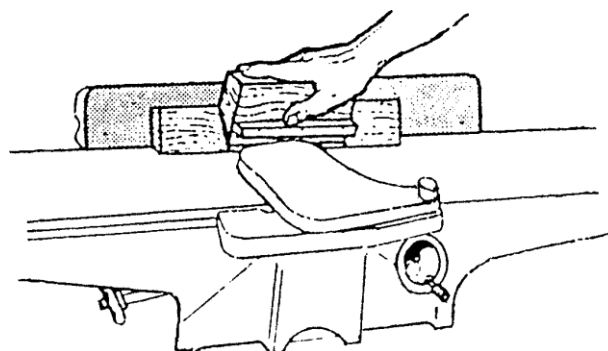


FIG. 29

## Skewing ( Shear Cutting)

When edging or facing burl or birds-eye maple, it is not unusual to deface or mar the surface being finished. This is caused by the cutterhead blades at times cutting against the grain. In order to prevent the defacing or marring of this type wood, it is necessary to skew, or angle finish, the material being worked. See Fig. 30.

1. Release the fence locking handle and remove the two hex nuts and flat washer holding the fence to the fence support (see page 4). Remove the fence.
2. Remove the key from the fence slide base.
3. Replace the fence assembly at the desired angle across the cutterhead. Secure the fence to the support with the two hex nuts and flat washer, then tighten the fence locking handle.

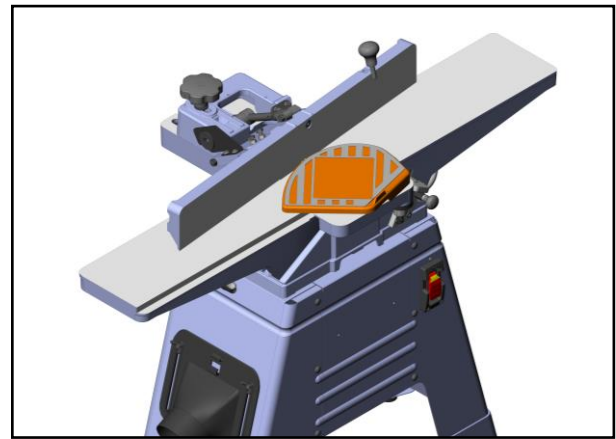
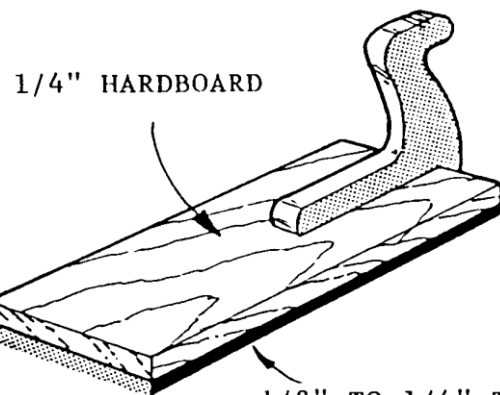


FIG. 30



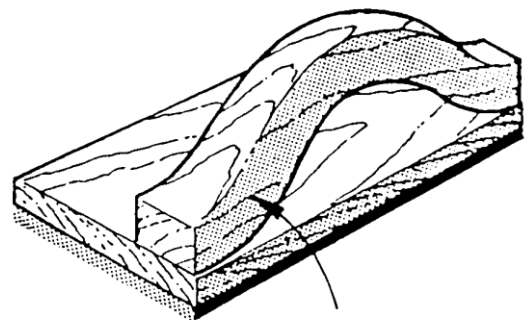
1/4" HARDBOARD

1/8" TO 1/4" THICK  
SOFT RUBBER  
KEEP SURFACE CLEAN  
AND FREE OF GRIT.

## Push Blocks

Push blocks are simple, yet necessary tools to assist the operator especially when jointing thin or short stock. Illustrated in Figure 32 are three types of push blocks commonly used in jointing. Push blocks may be obtained commercially or easily constructed.

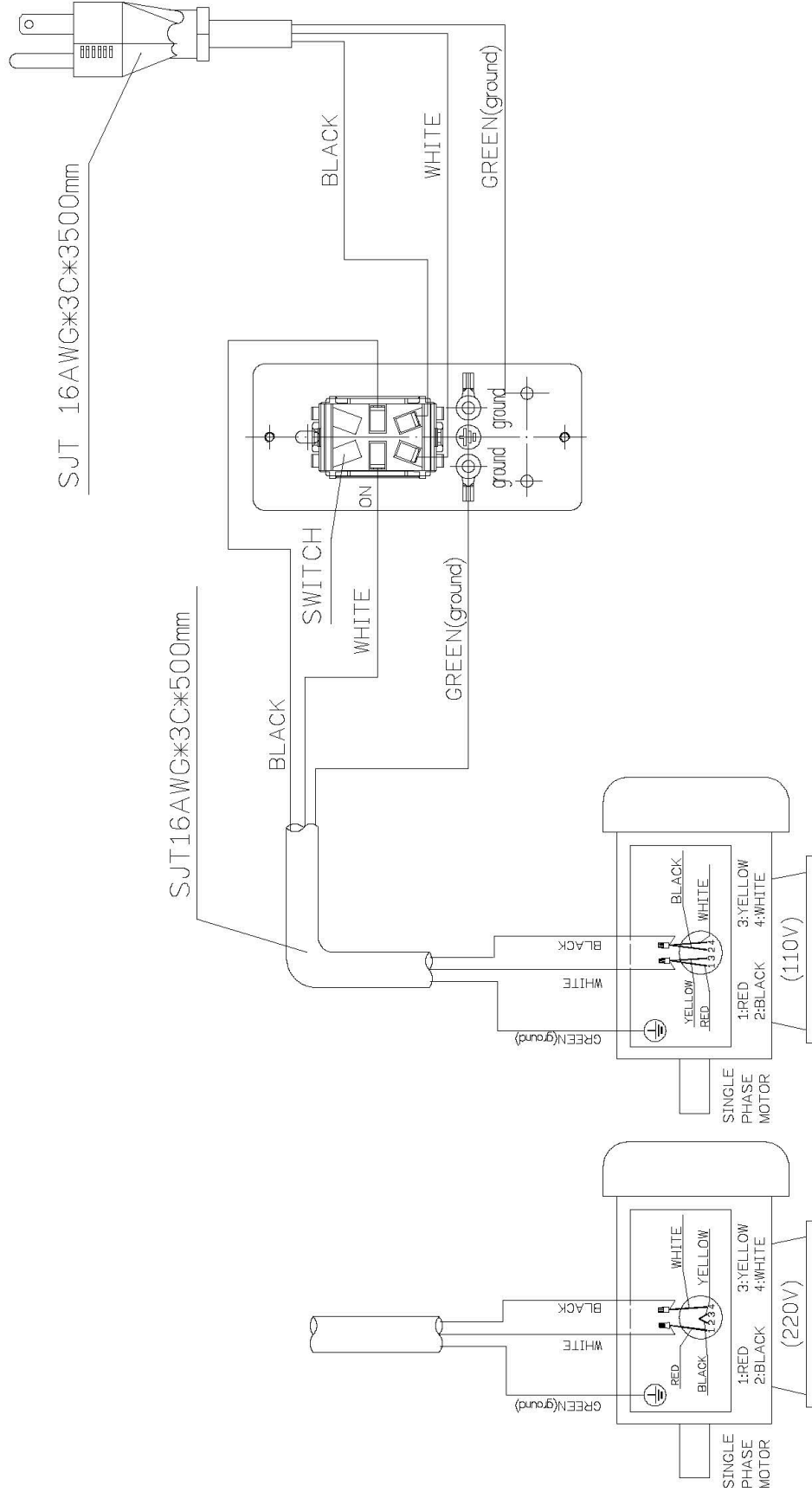
NOTE: The Jointer is supplied with two push block for feeding stock as below showing



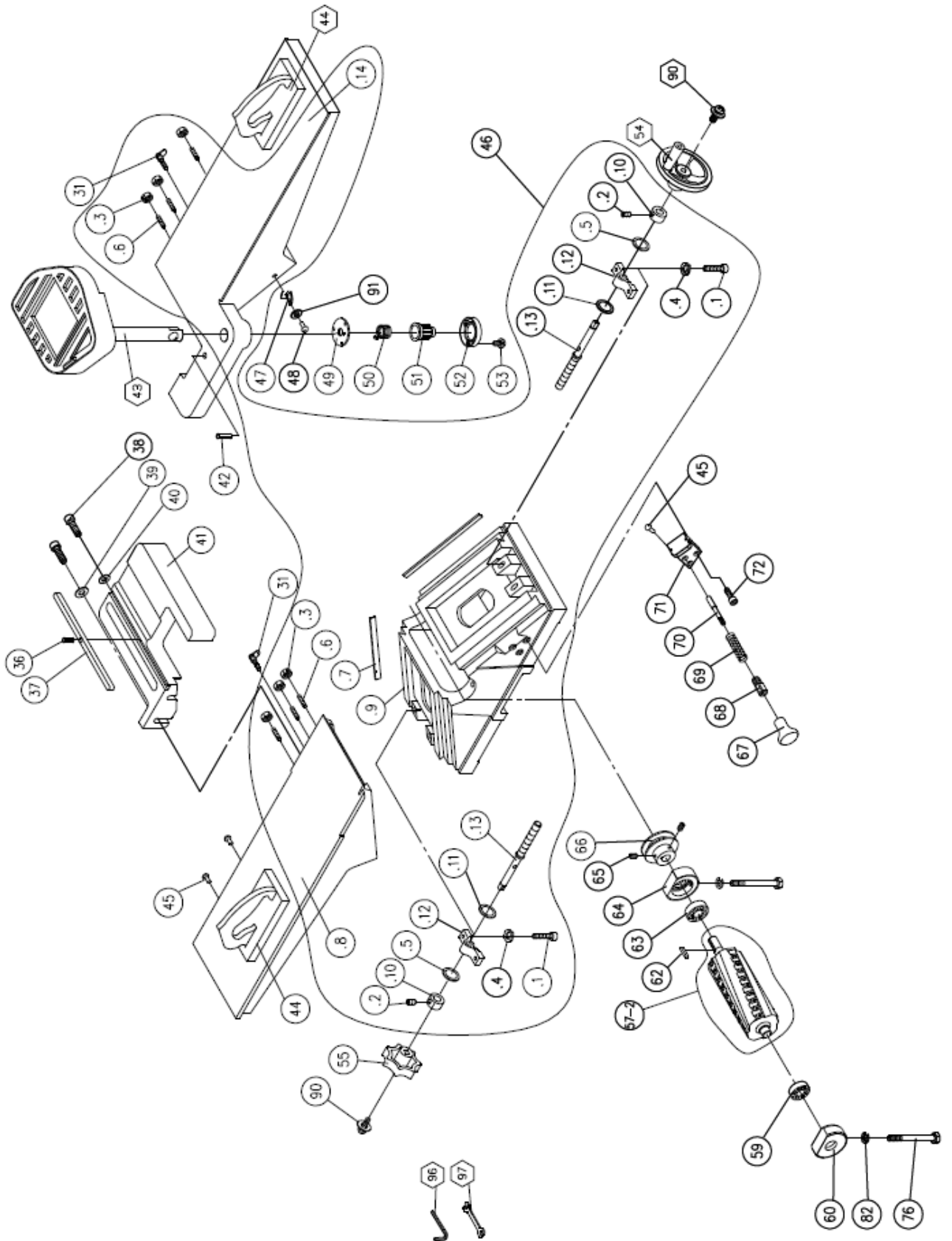
WOOD DOOR HANDLE OR  
SHAPE FROM 1-1/4" STOCK

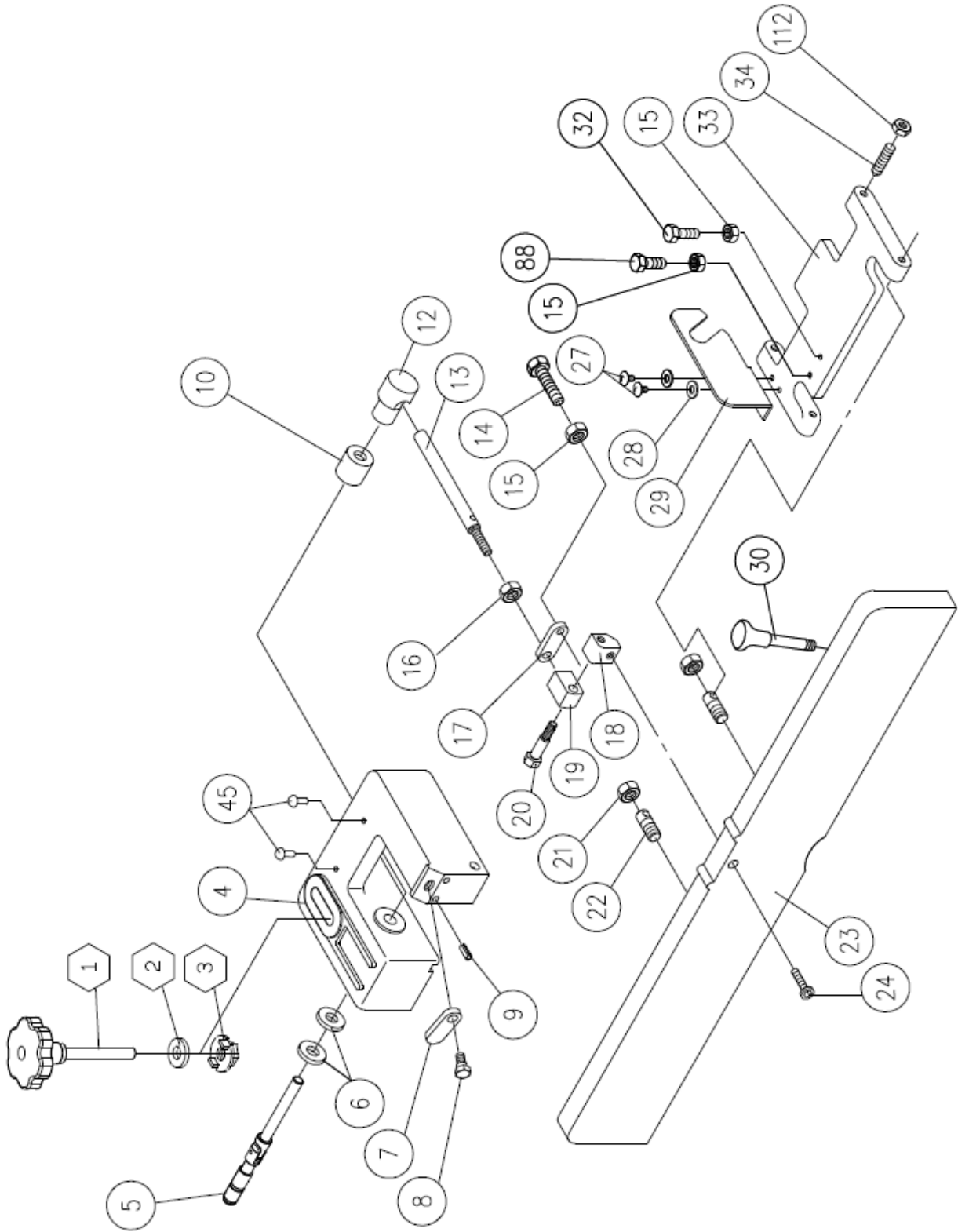
FIG. 31

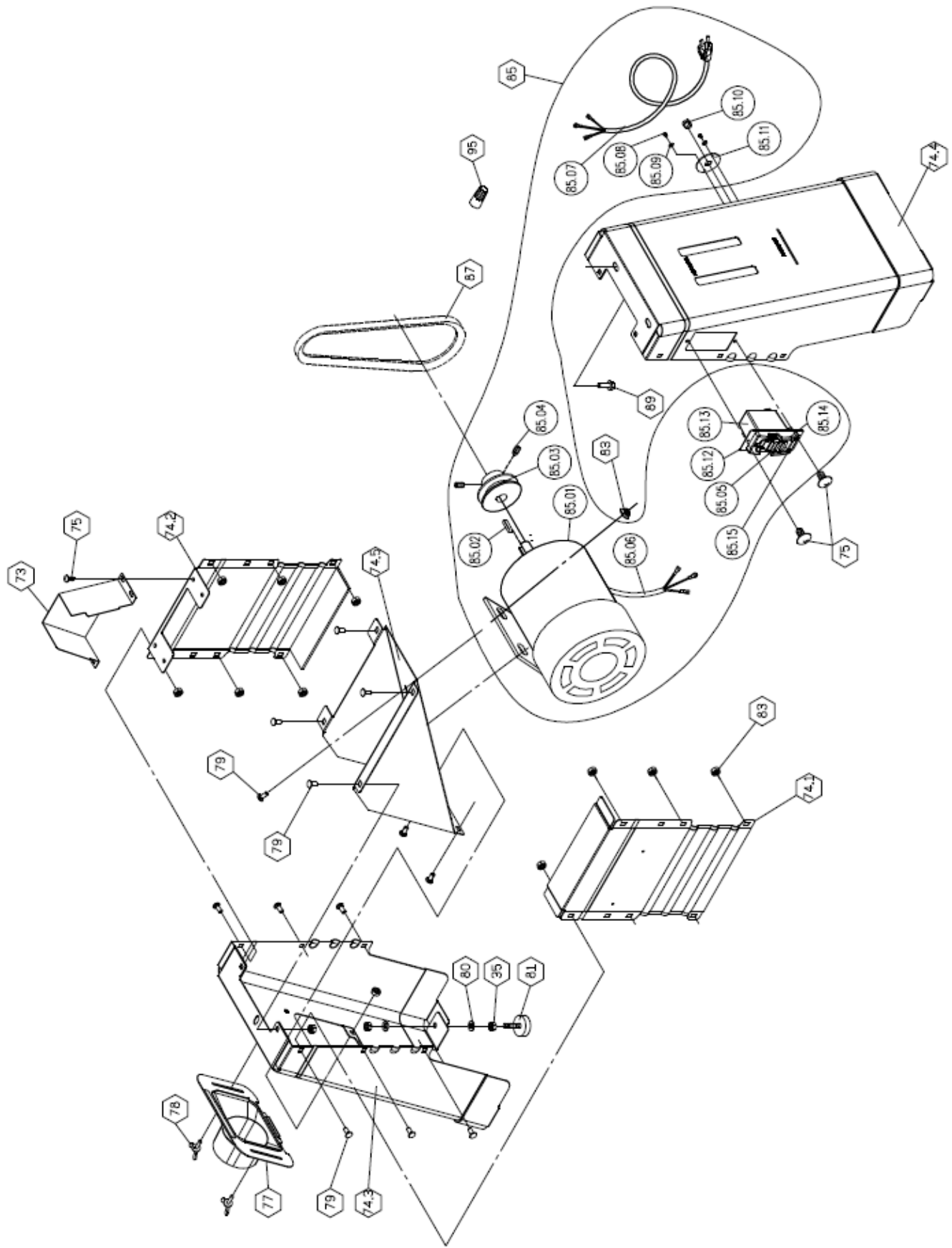
# Wiring Diagrams



# Parts Diagrams







## Parts List

Key	Part No.	Descriptions	Q'ty	
1	230031-619	KNOB FENCE	1	
2	006003-091	FLAT WASHER	13*28*3.0t	1
3	380209-901	T-NUT		1
4	051301-000	FENCE BRACKET		1
5	230032-000	LOCKING HANDLE		1
6	006003-097	FLAT WASHER	13.5*40*3.0t	2
7	170047-901	PLATE STOP		1
8	290003-901	BOLT SHOULDER		1
9	011002-103	SPRING PIN	4*12	2
10	130055-903	SLEEVE FENCE		1
12	130009-903	BLOCK ASM DEPTH		1
13	360068-901	SHAFT LOCK		1
14	003003-708	HEX. SCREW	5/16"-18NC*1-3/4"	1
15	009005-300	HEX. NUT	5/16"-18NC	3
16	009008-300	HEX. NUT	7/16"-14NC	1
17	170598-901	STOP FENCE		1
18	130008-903	NUT HANDLE		1
19	130007-903	NUT PIVOT		1
20	290004-901	BOLT SHOULDER 10*6		1
21	009014-300	HEX. NUT	1/2"-20NF	2
22	360676-901	STUD PIVOT		2
23	051300-000	FENCE		1
24	003602-702	FLAT HD SOC. SCREW	5/16"-18NC*1-5/8"	1
27	003301-701	PAN HD SCREW	1/4"-20NC*1/2"	2
28	006003-033	FLAT WASHER	6.7*16*1.0t	2
29	170048-901	BRACKET FENCE		1
30	230033-000	KNOB FENCE TILT		1
31	230053-000	SCREW WING		2
32	003003-705	HEX. SCREW	5/16"-18NC*1"	1
33	051303-000	TILT PLATE		1
34	230015-901	STUD PIVOT		4
35	009006-300	HEX. NUT	3/8"-16NC	8
36	011002-105	SPRING PIN	4*20	1
37	380080-000	KEY		1
38	003105-703	CAP SCREW	3/8"-16NC*1-1/2"	2
39	006003-082	FLAT WASHER	10.5*28*3.0t	1
40	006003-069	FLAT WASHER	10*20*3.0t	1
41	051302-000	FENCE SLIDE BRACKET		1
42	011003-107	SPRING PIN	5*30	1
43	920217-000	BLADE GUARD ASSEMBLY		1
44	250040-629	PUSH BLOCK		2
45	002301-201	RIVET	2*5	6
46	924143-001	TABLE ASS'Y		1
47	250046-620	POINTER INDICATOR		1
48	003305-703	PAN HD SCREW	5/32"-32NC*1/4"	1
49	170045-901	RETAINER		1
50	280009-000	SPRING		1
51	110024-000	KNOB		1
52	110004-000	RETAINING KNOB		1

Key	Part No.	Descriptions	Q'ty	
53	003305-706	PAN HD SCREW	5/32"-32NC*5/8"	3
54	920170-001	HANDWHEEL		1
55	240001-000	KNOB OUTFEED		1
57-2	924263-001	HELICAL CUTTERHEAD ASSEMBLY	BYRD 3 SLOTS	1
59	030206-002	BALL BEARING	6202	1
60	050018-901	BEARING HOUSING		1
62	012003-009	KEY	5*5*25	1
63	030207-002	BALL BEARING	6203	1
64	050019-901	BEARING HOUSING		1
65	003201-702	SET SCREW	1/4"-20NC*3/8"	2
66	050020-901	PULLEY		1
67	250232-619	KNOB PLUNGER		1
68	380085-901	HOUSING PLUNGER		1
69	280010-000	SPRING		1
70	360033-901	PLUNGER		1
71	050076-000	BLOCK ASM DEPTH		1
72	003104-703	CAP SCREW	5/16"-18NC*3/4"	3
73	170095-000	PULLEY COVER		1
74	924265-001	STAND ASSEMBLY		1
74.1	174178-000	PANEL ASM FRONT		1
74.2	170110-000	PANEL REAR		1
74.3	170111-000	STAND- LEFT		1
74.4	170112-000	STAND- RIGHT		1
74.5	170113-000	MOTOR BRACKET		1
75	004501-701	ROUND HEAD SCREW W/TEETH	3/16"-24NC*3/8"	6
76	003006-301	HEX. SCREW	3/8"-24NF*89mm	2
77	920215-001	DUST CHUTE		1
78	005301-701	WING SCREW	1/4"-20NC*1/2"	2
79	003801-706	SHOULDER SCREW	5/16"-18NC*1/2"	22
80	006003-081	FLAT WASHER	10.5*27*2.0t	8
81	230081-000	FOOT LEVELING		4
82	006307-300	SPRING WASHER	10.2*18.5	2
83	009401-300	HEX. LOCKING NUT	5/16"-18NC	22
85	901016-001	MOTOR & SWITCH ASSEMBLY	1HP*120/240V*60HZ*1PH	1
87	014102-000	V-BELT	A36	1
88	003003-706	HEX. SCREW	5/16"-18NC*1-1/4"	1
89	004902-101	HEX SCREW W/WASHER	3/8"-16NC*3/4"	3
90	005803-101	PAN HD SCREWW/WASHERS	1/4"-20NC*5/8"	2
91	006003-001	FLAT WASHER	4.3*10*1.0t	1
96	040003-000	HEX. WRENCH	3mm	1
97	040201-000	OPEN WRENCH	8*10	1
95	021201-000	WIRE CLIP NUT	SW-P3	1
112	009022-300	HEX. NUT	3/8"-16NC	4