Model 0008
8” Jointer
Owner’s Manual

C US
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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 planning operation on material shorter than 8 in , narrower than 3/4 in, or wider than 8" in or thinner than 1/2 in.

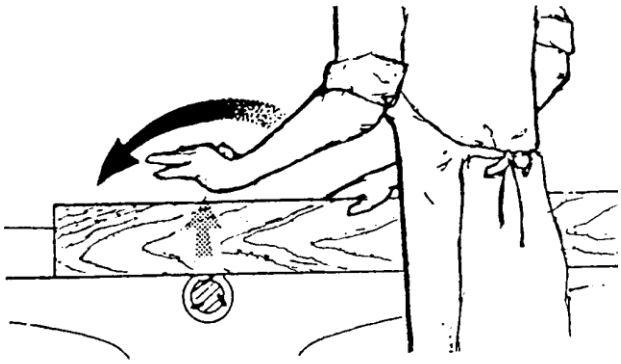
Maintain the proper relationships of infeed and outfeed table surfaces and cutter head knife path.

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

Do not back the work toword 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).

Unpacking and cleaning

To ensure maximum performance from your 8" jointer, clean it properly; and install it accurately before use. As soon as you receive the jointer, we recommend you follow these procedures:

1. Finish removing the contents of the shipping carton and compare with the contents list.

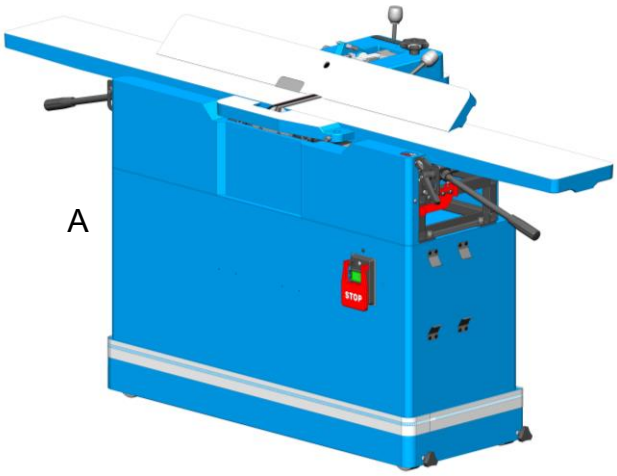
2. Report damage, if any to your local distributor.

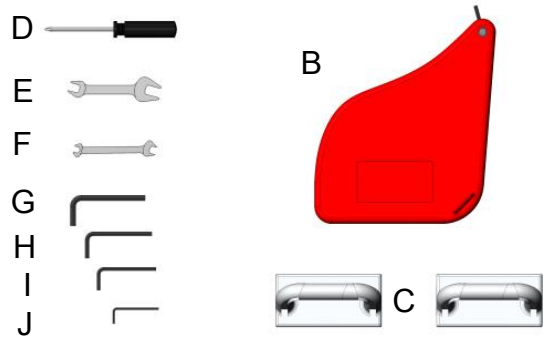
3. Clean all rust protected surfaces with a mild solvent or kerosene. Do not use lacquer thinner; paint thinner, or gasoline. These will damage painted surfaces.

4. To prevent rust, apply a light coating of paste wax to surface.

Although some users prefer a wax coating for the table surfaces, white talcum powder rubbed in vigorously once a week with a blackboard eraser will fill any casting pores and form a moisture barrier. Talcum powder will not stain wood or mar finishes.

A. Jointer with Fence Assembly.....1
B. Blade Guard 1
C. Push Block 2
D. Screw Driver.....1
E. Open Wrench 11*13.....1
F. Open Wrench 8*10.....1
G. HEX. Wrench 8mm.....1
H. HEX. Wrench 6mm.....1
I. HEX. Wrench 5mm.....1
J. HEX. Wrench 3mm.....1



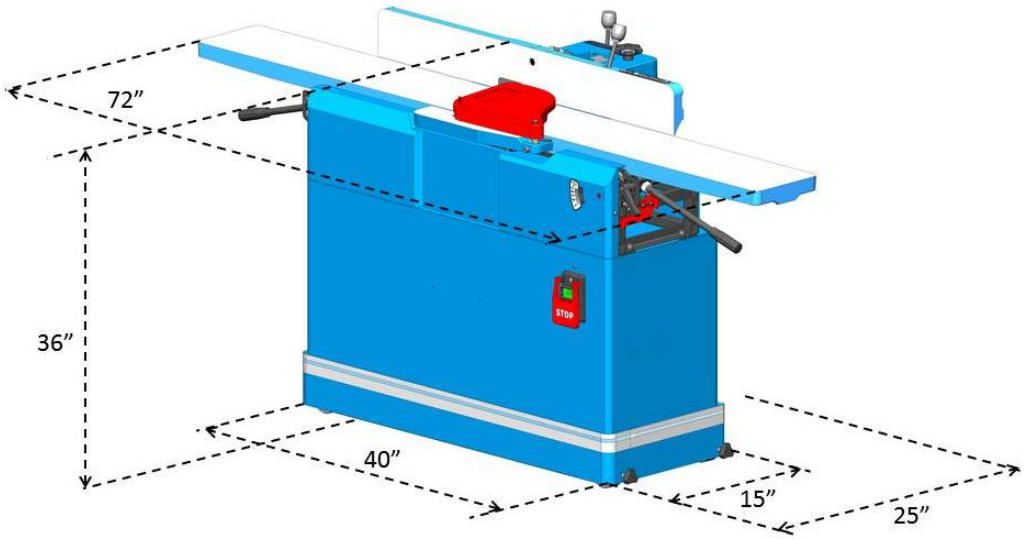


Extra parts:

BYRD Helical Cutterhead with a sleeve screw driver. a Trox sleeve & 3 inserts

Placement the 8" jointer

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the Jointer (366 lbs-166kgs) and the operator. Using the dimensions shown as below (L 72"x W25"x H 36"), plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic or other tools or machinery.



Switch

The jointer is equipped with a push-button switch, Fig. 1 that will accept a safety padlock (not included).

To safeguard your machine from unauthorized operation and accidental starting by young children, the use of a padlock is required.

When you have finished using the machine be sure to re-install the lock-out pin and unplug the jointer from the power source.

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

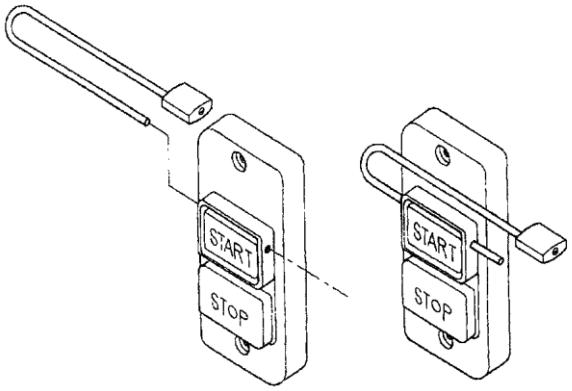


Fig. 1

Installation Blade Guard & Removal

WARNING: The Jointer knives are extremely sharp. Use caution when working with or around the cutterhead. Use the jointer guard for all operations. Do not connect the plug to power source

1. Loosen the CAP screw (A) on the rabbet arm (B), Fig. 2
2. Insert a spanner or similar object to hole the pin (C).
3. Twist the pin (D) by spanner go to the end by clockwise and hold it there.
4. Put the blade guard post into the hole on the appropriated position, tighten the CAP screw then remove the spanner.
5. Note: the blade guard could not touch the rabbet arm surface for smooth move.
6. Check the guard for proper tension. If guard does not swing back to contact the fence. Repeating steps 1-4 until correct tension is achieved. NEVER run the jointer without the guard being in place and in perfect working order.

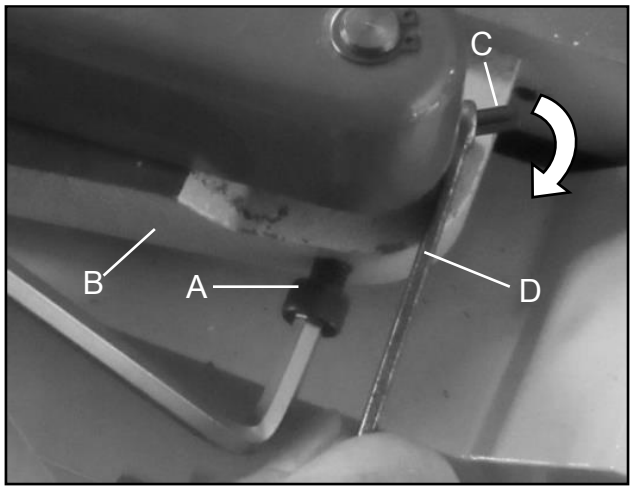


Fig. 2

Grounding Instructions

WARNING: If the machine does not come wired to run, the electricals 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 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. 3. 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. 4 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

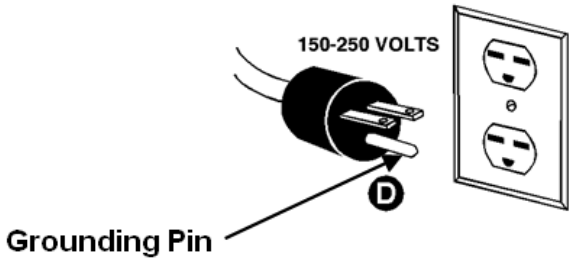


Fig. 3

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

Fig. 4

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.

To adjust outfeed table

The outfeed table should be set level with the highest point of the knives, Fig. 14. The height of the outfeed table should be verified and adjusted prior to first use. It should also be verified and readjusted periodically to compensate for knife wear and also upon knife replacement.

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. Make sure that the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutterhead and upper pulley, remove the blade guard.
3. Set a straightedge (A, Fig. 5 & 6) onto the outfeed table so that it sits over the cutterhead but does not completely cross the gap between the tables and do not touch the infeed table.
4. Turn the upper pulley by hand, until any one of the knives is at its highest point.
5. Loosen the CAP screw (B, Fig. 7) by 8mm Hex. wrench.
6. Push up or down the height adjustment handle (C, Fig. 7) to adjust the outfeed table height so that the knife tip barely touches the straight-edge.
7. Re-tighten the CAP screw (B) to secure the outfeed table in position.
8. If the outfeed table couldn't low to correct position release the Hex. nut (D) then loosen the Hex. bolt (E), Fig. 8.
9. Lower the outfeed table to the location of the appropriate by height adjustment handle (C) then tighten the CAP screw (B).
10. Re-tighten the Hex. nut (D)
11. Re-tighten the Hex. bolt (E).

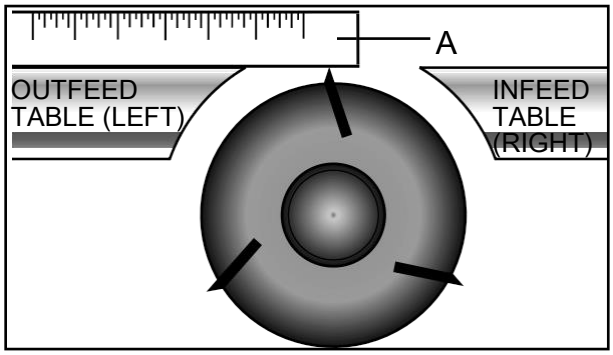


Fig. 5

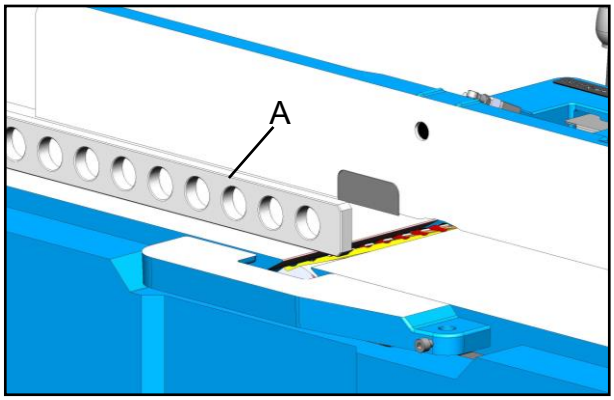


Fig. 6

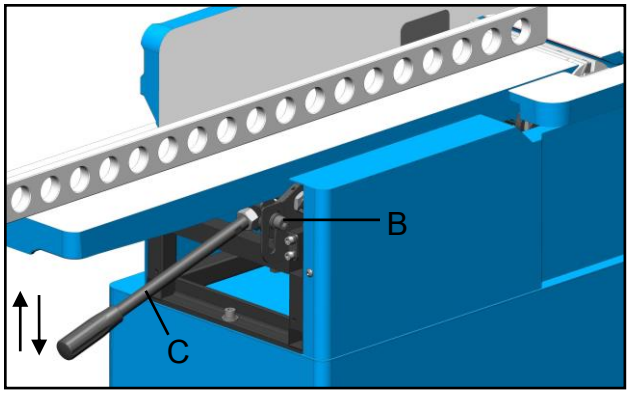


Fig. 7

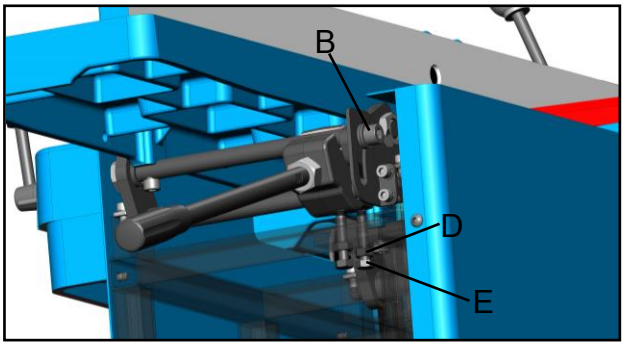


Fig. 8

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.9.

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 back of jointer.

1. Loosen the in-feed table height locking handle (A), Fig. 9.
2. PULL out the 1/8" depth stop plate (C) then raise or lower the height adjustment handle (B) to the desired depth of cut then retighten lock handle (A) to secure the infeed table in position, Fig. 18.

Waning : Never adjust the table height with the lock pin engaged as this will break the pin.

Note: Refer to the graduated depth scale (D, Fig. 10) . Do not connect the plug to power source

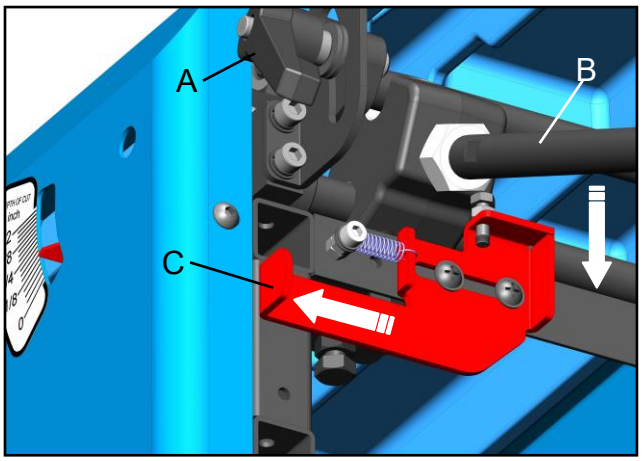


Fig. 9

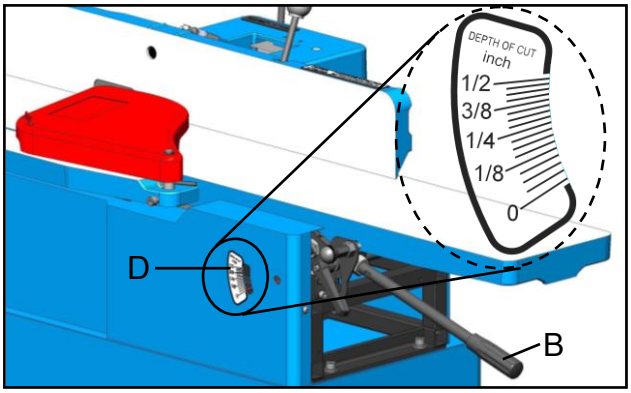


Fig. 10

To adjust infeed table

In addition to the 1/8" depth stop, 2 other depth stops can be set by setting the infeed table minimum and maximum height, Fig. 11.

To set the table minimum height:
1. Loosen locking handle (A).
2. Upper the infeed table to the desired minimum height.
3. Check the pointer (F) on the correct position if not, loosen the round head phillips screw (G) make sure the pointer on "0" position.
4. Re-tighten locking handle (A).

To set the table maximum height:
1. Loosen locking handle (A).
2. Lower the infeed table to the desired maximum height then re-tighten locking handle (A).

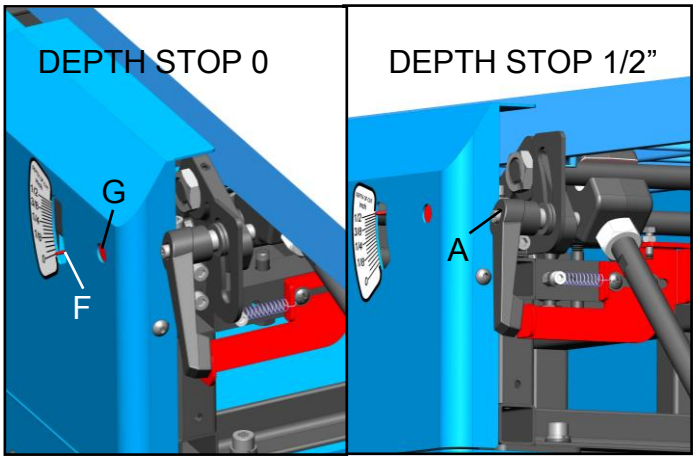


Fig. 11

Table Leveling

The table level on your machine is factory adjusted and may never require readjustment.

Should any adjustment become necessary, do the following:

1. Loosen 8 screws (B, Fig.12) on the rear cover by 4mm Hex. wrench , take off the rear cover.

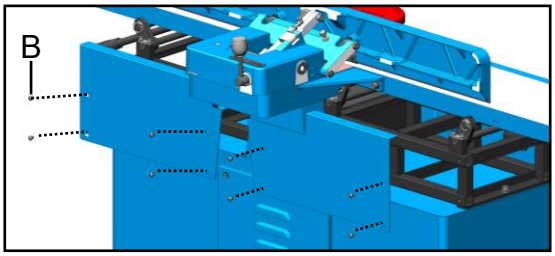


Fig. 12

2. Loosen 2 screws (I, Fig.13) on the front cover.

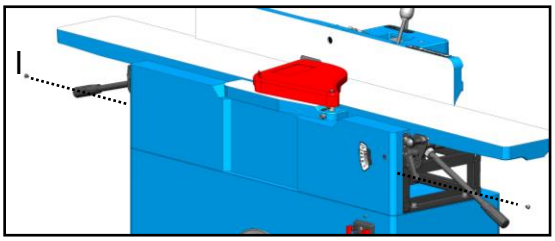


Fig. 13

3. Loosen 4 CAP screws (J) on the base frame by 5mm Hex. Wrench, remove the front cover (K), Fig. 14.

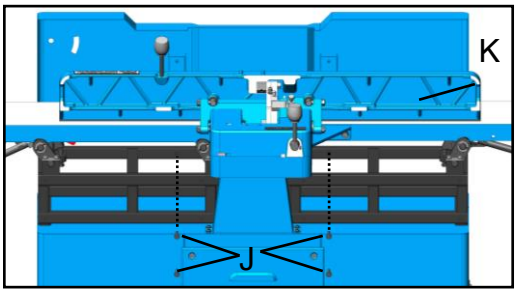


Fig. 14

4. Loosen CAP screw (L) on the rabbet arm by 6mm Hex. wrench, remove the blade guard (M), Fig. 15.

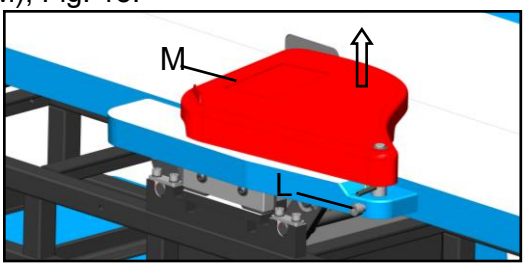


Fig. 24

5. Loosen the Hex. Nut (N) under the fence bracket (O), remove the fence assembly (P), FigFig. 16

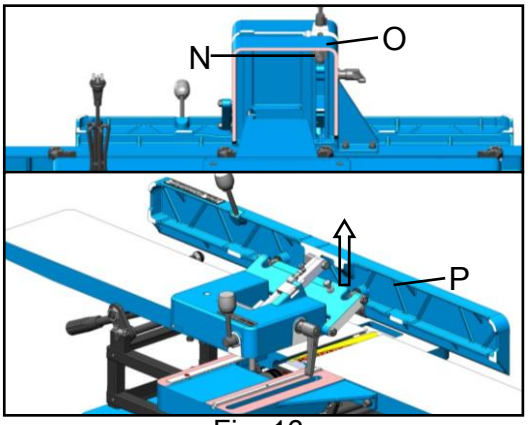


Fig. 16

6. Set a straightedge (Q) on the front that must cross the infeed table & outfeed table, adjust 4 eccentric sleeves(R) by 24mm open wrench. Keep checking the level of the tables with a straightedge until leveling is achieved, Fig. 17.

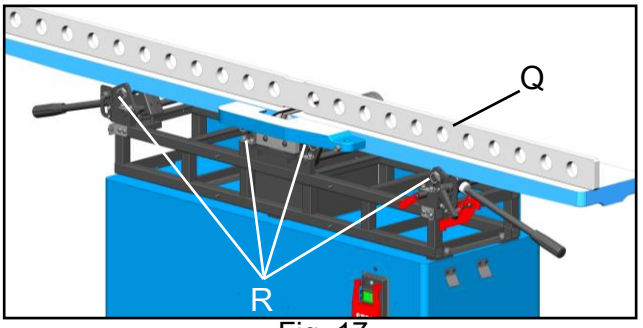


Fig. 17

7. Set a straightedge (Q) on the rear that must cross the infeed table & outfeed table, adjust 4 eccentric sleeves (S) by 24mm open wrench. Keep checking the level of the tables with a straightedge until leveling is achieved, Fig. 18.

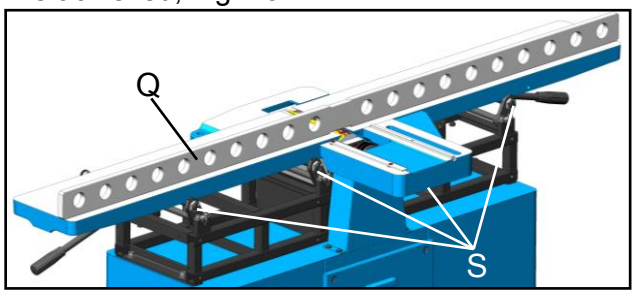


Fig. 18

8. Put the fence .blade guard. front cover & rear cover back to machine & tighten all of screws.

Warning: Do not connect the plug to power source

Fence Adjustments: Tilt

Warning: Do not connect the plug to power source

Fence adjustments are made with the lock knob (D) shown in Fig. 19
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. 19
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. 19
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.

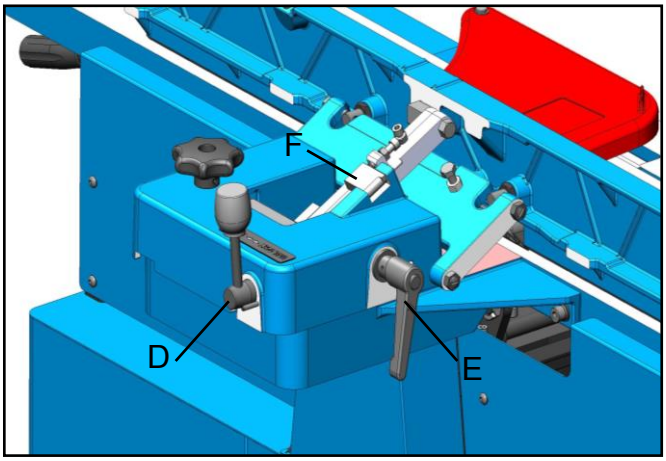


Fig. 19

NOTE: The lock knob (D, Fig. 20) 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.

0º Fence Adjustment

Referring to Fig. 20:
The 90º 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 90º 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 (G) Fig.21 on the table closed to fence surface and pulling up the fence handle (F) to confirm a 90º setting then tightening the lock handle (C).
6. Loosen the hex nut (E) until the stop bolt (A) touch stop block (B) surface.
7. Tighten the hex nut (E) to retain the setting.
8. Double check to the fence is setting square with table.

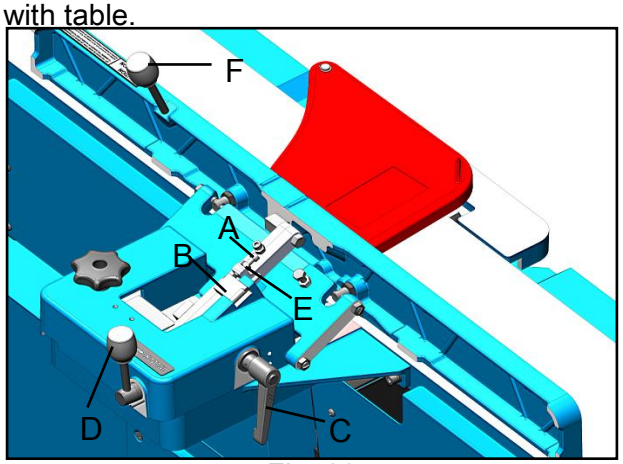


Fig. 20

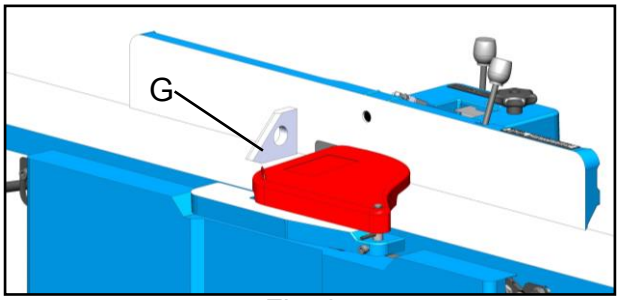


Fig. 21

45º & 135 º Fence Backward Stop Adjustment

Referring to Fig. 22:

Note: The 45º fence backward stop is controlled by the stop bolt (H) and 135 º fence backward stop is controlled by the stop bolt (I).

1. Loosen the lock knob (D). Move the stop plate (B) out of the way and position the fence at the 45 º or 135º angles. 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. 23 and against the fence to confirm 45 º & 135º setting.
4. To adjust, loosen the lock nut (J) or (K), turn the stop bolt (H) or (I) until a 45 º or 135º angles is obtained.
5. Tighten the lock nut (J) or (K).
6. Double check to the fence is setting correct angel with table.

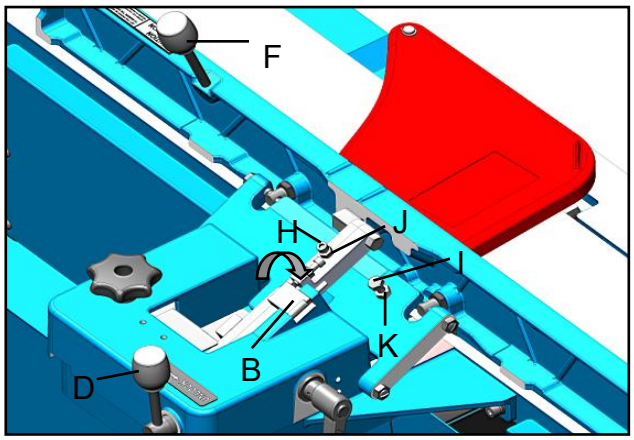


Fig. 22

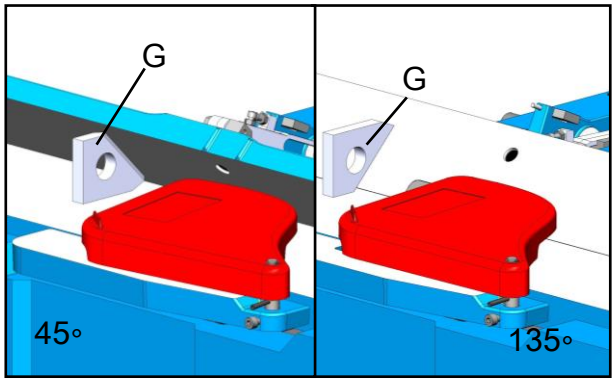


Fig. 23

Helical Cutterhead

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 provided screw driver & torx sleeve to remove the knife insert screw. See Fig. 24. 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.

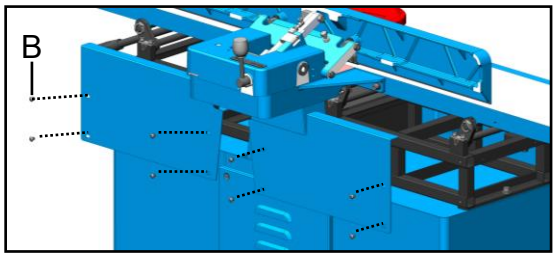
Fig. 24

Cutterhead Removal

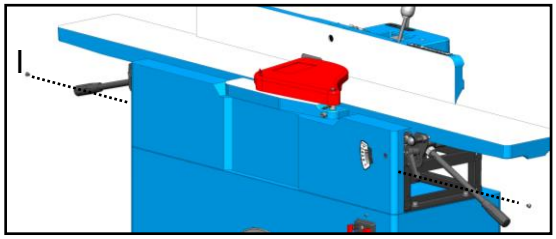
If removal of the cutterhead is necessary, do the following:

WARNING: Disconnect jointer from power source.

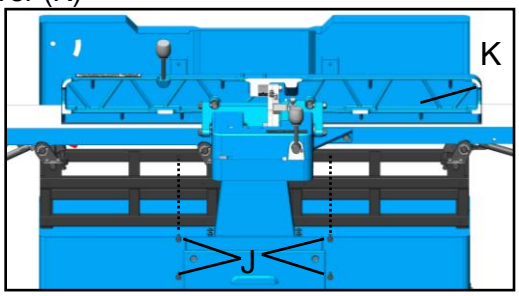
Step1. Loosen 8 screws (B) on the rear cover by 4mm Hex. Wrench , take off the rear cover.



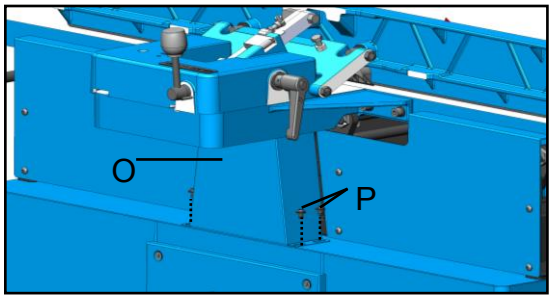
Step 2. Loosen 2 screws (I) on the front cover.



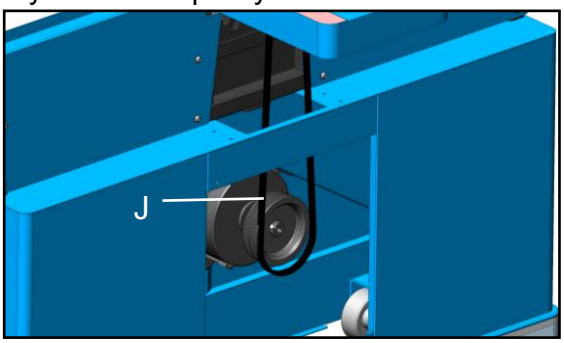
Step 3. Loosen 4 CAP screws (J) on the base frame by 5mm Hex. Wrench, remove the front cover (K)



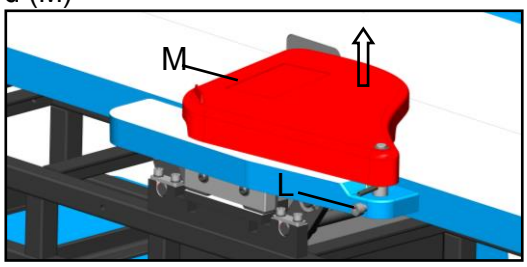
Step 4. The pulley cover (O) is mounted by 4 Round Head phillips screw w/teeth washers (P) to the threaded holes in the Stand, Fig. 10.



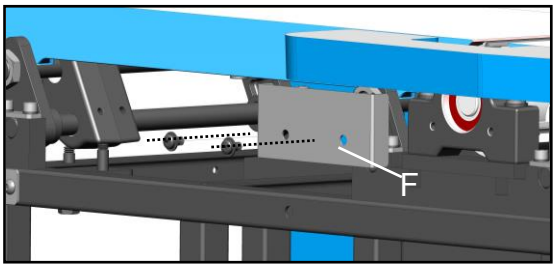
Step 5. Remove the V-belt (J) from cutterhead pulley and motor pulley.



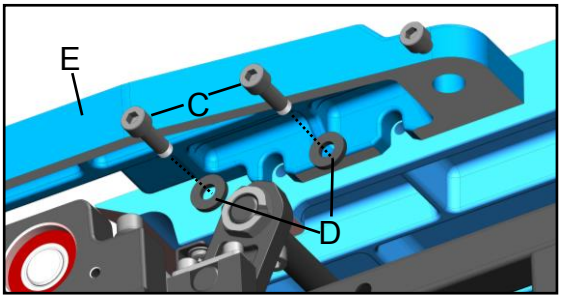
Step. 6 Loosen CAP screw (L) on the rabbet arm by 6mm Hex. Wrench, remove the blade guard (M)



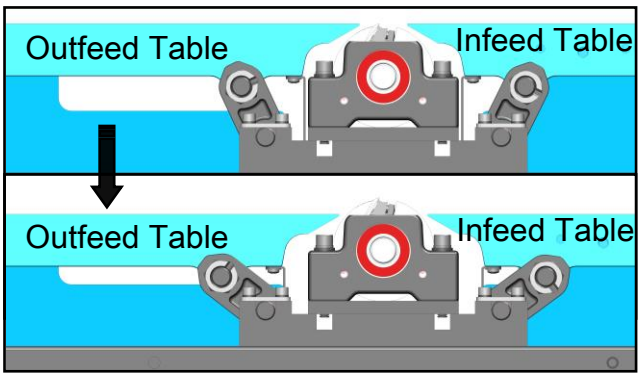
Step 7. Loosen 2 Round Head Phillip Screw w/Washers (E) then remove cutterhead cover (F)



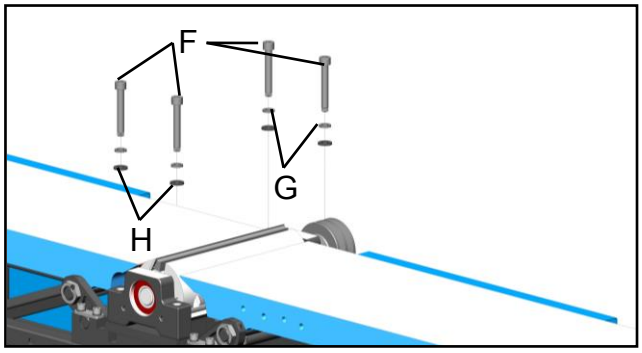
Step 8. Loosen 2 CAP Screws(C). Flat Washers then remove rabbetting arm from Infeed Table.



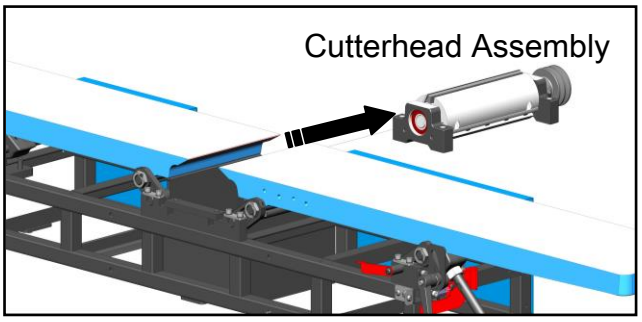
Step 9. Lower both of Infeed Table & Outfeed Table on the Lowest position (1/2")



Step 10. Loosen 4 CAP screws (F). Spring Washers(G) & Flat Washers (H)



Step 11. Push out the cutterhead assembly from machine front end



Step 12. Reverse operation Step 1 to Stop 11 for assembly all parts back to machine.

NOTE: You may wish to keep on hand an extra cutterhead in order to maintain shop productivity.

Warning : Make Sure all of screws are tighten when assembly all of parts back on machine.

Replacement

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:

Note: SET THE KNIFE NO MORE THAN 0.06" ABOVE CUTTERHEAD. TO MINIMISE THE DANGER OF KICKBACK AND POTETIAL INJORY.

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

1. Remove the cutterhead guard
2. Place a metal straightedge across both tables as shown in Fig.25, 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. 25 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. 34, 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.

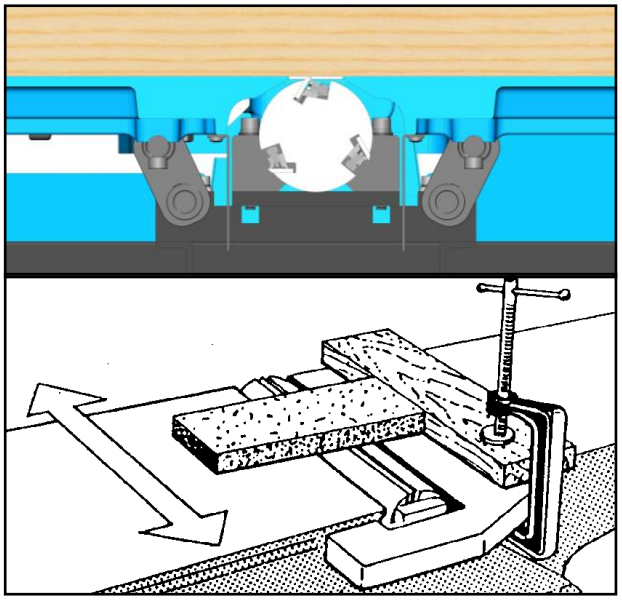


Fig. 25

Replacement the Belts

After extended use it will be necessary to adjustment or change the belts on the jointer, do the following:

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

1. Loosen screws (A) & (B) then remove the pulley cover (C) & cover (D) on the rear stand , Fig 26.
2. Remove the fence assembly
3. Take out the old belts from machine & motor pulleys.
4. Install new belts (E) on the machine & motor pulleys, Fig. 27
5. Place a metal straightedge (F) across both pulleys Fig.28 to check the pulley alignment.
6. Check that the motor pulley and machine pulley are aligned; this will keep the belt vertical and help prevent excess wear on it. If adjustment is necessary, loosen the set screws in the motor pulley using a hex wrench, and slide the pulley as needed until alignment is achieved. Re-tighten set screws. If the pulleys are not aligned, try to adjust the motor position by motor mount screws (G), Fig. 29) to make sure pulley alignment.
7. When the belt can be deflected approximately one inch at the center belt span using light finger pressure as shown in Fig. 30
8. Snug tight the four motor mount screws (G).
9. Put the fence, pulley cover and cover back to machine & tighten all screws.

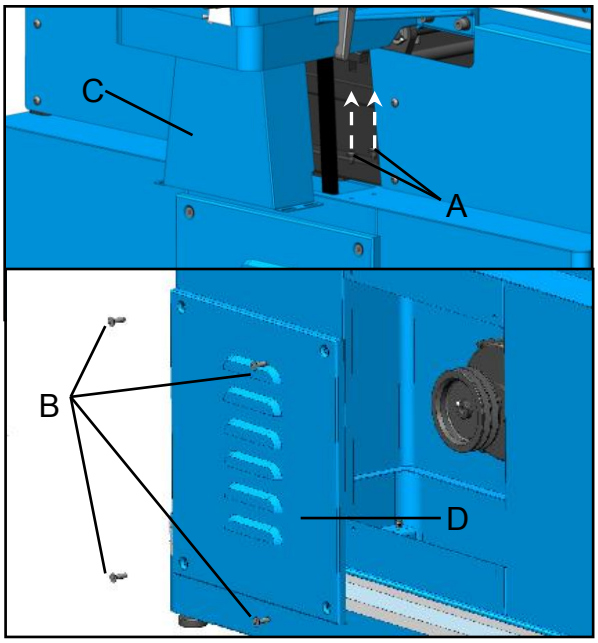


Fig. 26

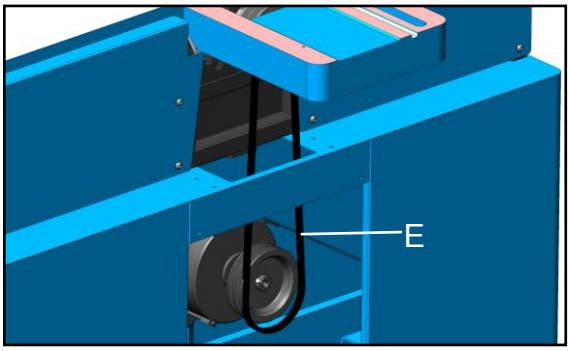


Fig. 27

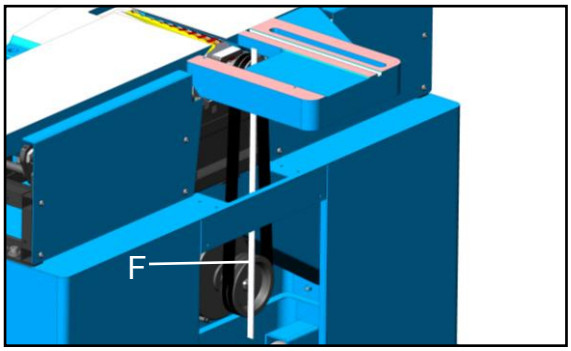


Fig. 28

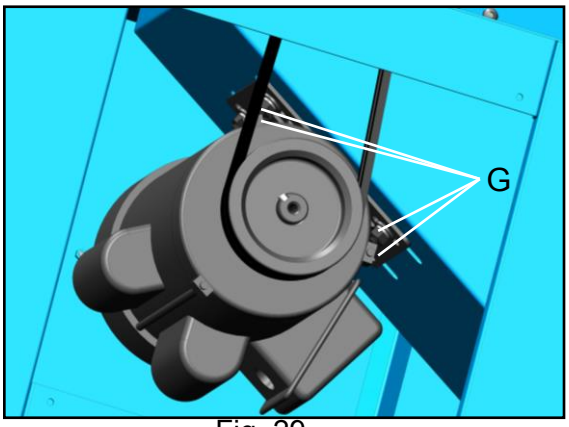


Fig. 29

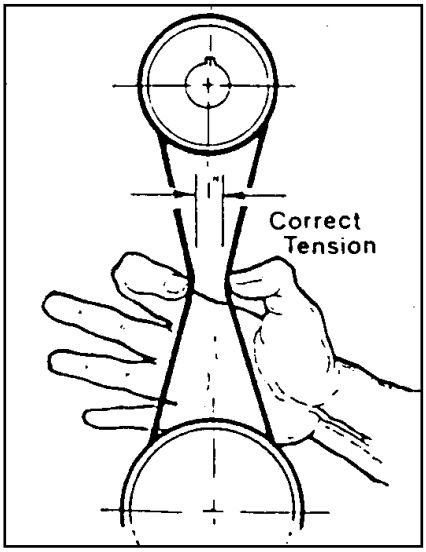


Fig. 30

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. 31). On stock longer than 12 inches use two push blocks (Fig. 32). With narrow stock use the type push block shown in Fig. 33. When surfacing short stock over 4 inches wide, use two (2) push blocks to guide material over cutterhead (Fig. 34).

two handed push block

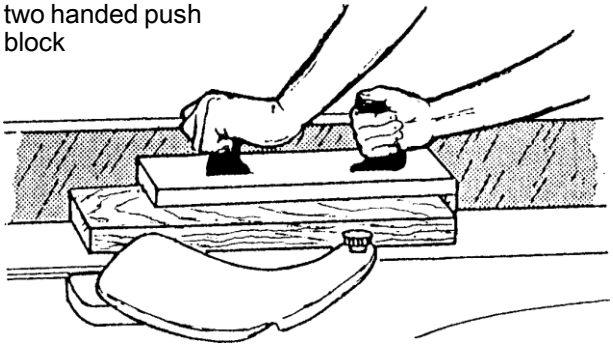


Fig. 31

two push blocks for stock longer than 12 inches

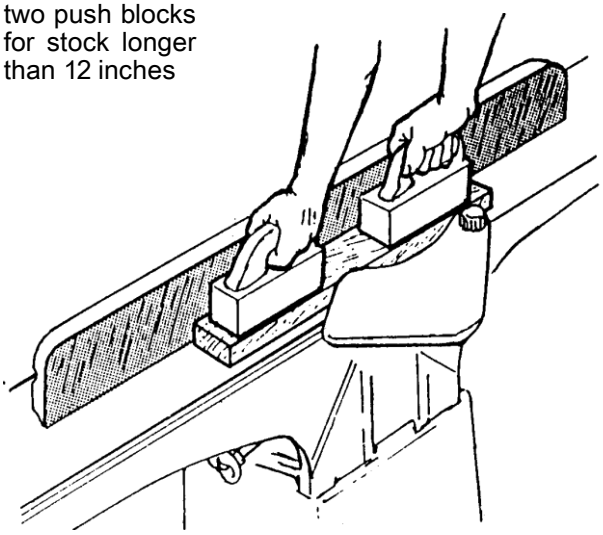


FIG. 32

L-shaped push block for narrow stock

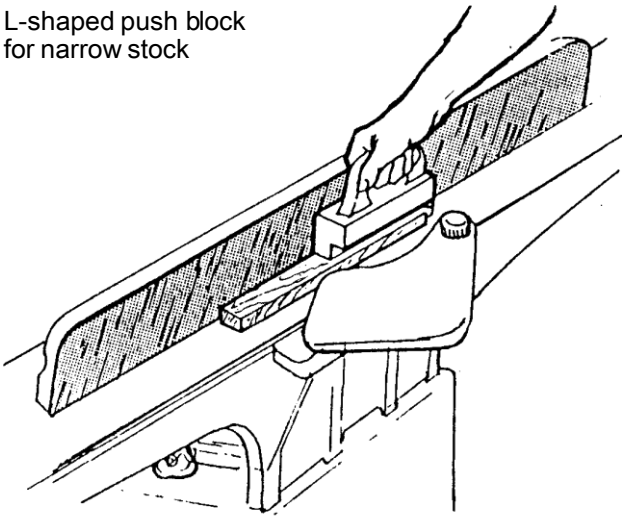


FIG. 33

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

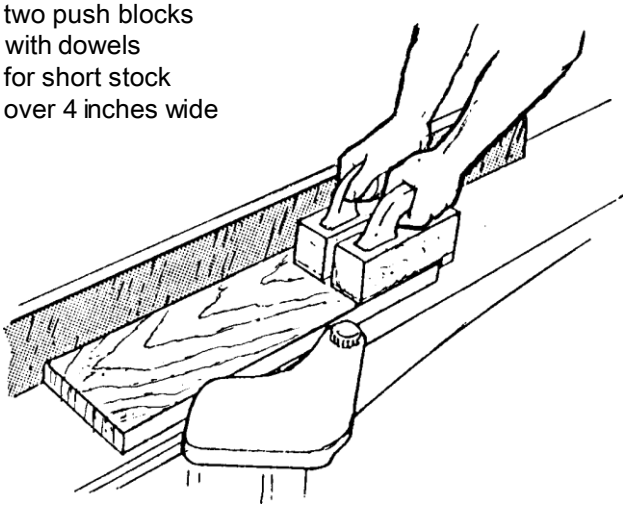


FIG. 34

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. 35).

Place second push block near the rear of infeed table and continue feeding stock using the hand over hand method (Fig. 36).

Before the left hand is in the 3 inch area of the cutterhead move it over to the outfeed side (Fig. 37).

As soon as possible follow with the right hand over to the outfeed side and continue through with cut (Fig.38).

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.

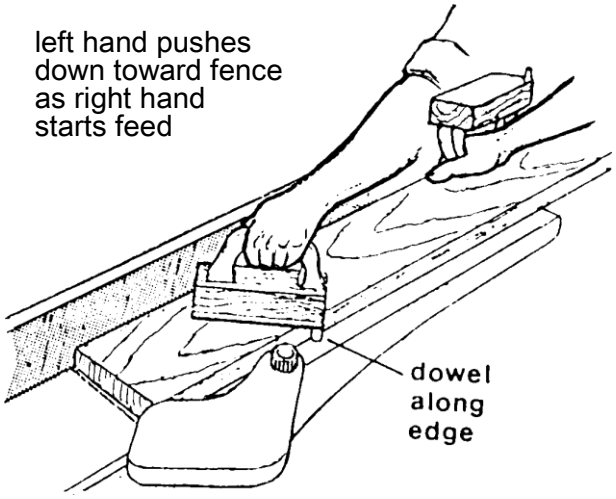


FIG. 35

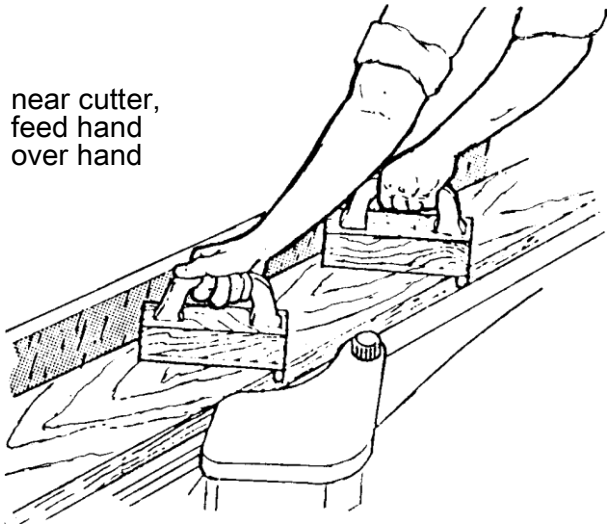


FIG. 36

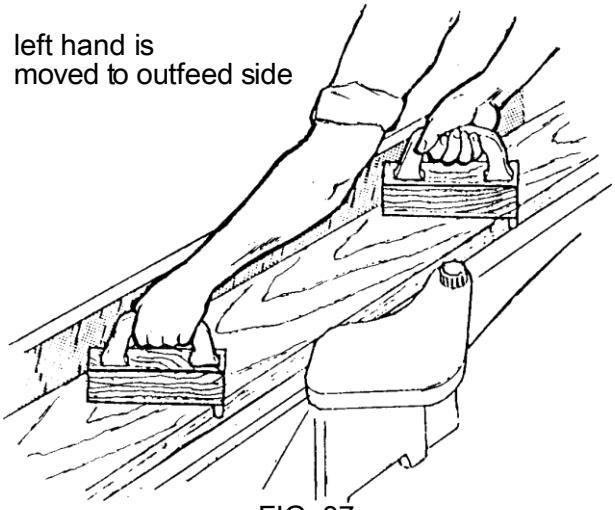


FIG. 37

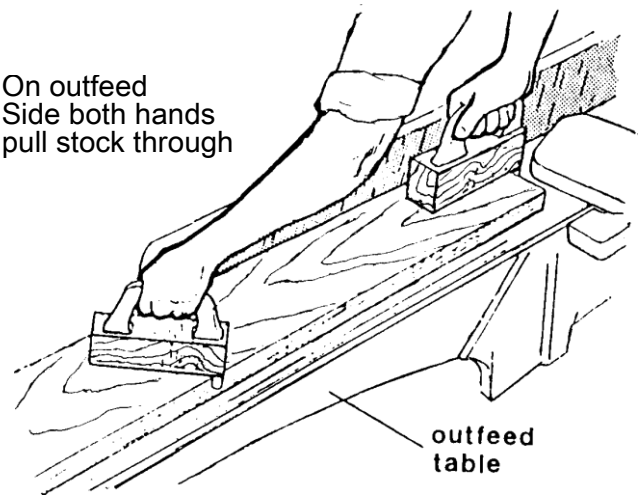


FIG. 38

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. 39).

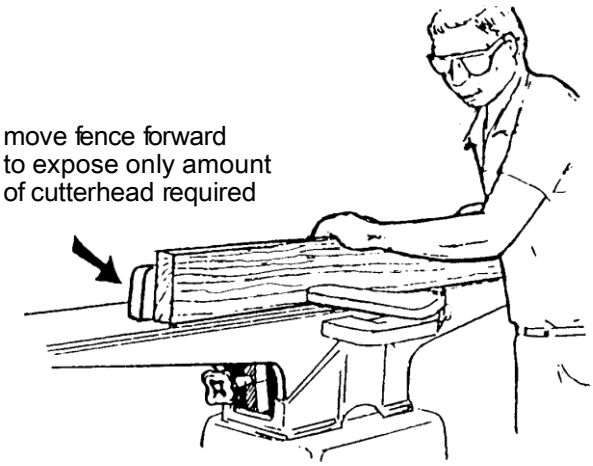


FIG.39

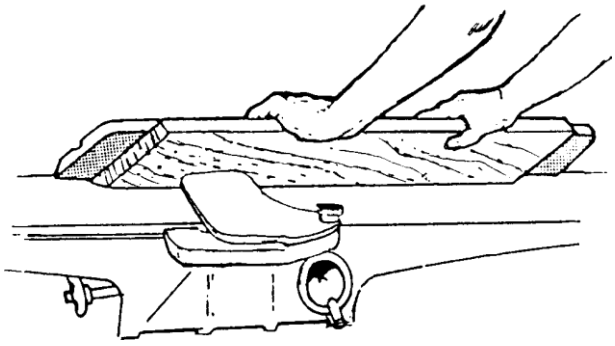


FIG. 40

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. 40).

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. 41).

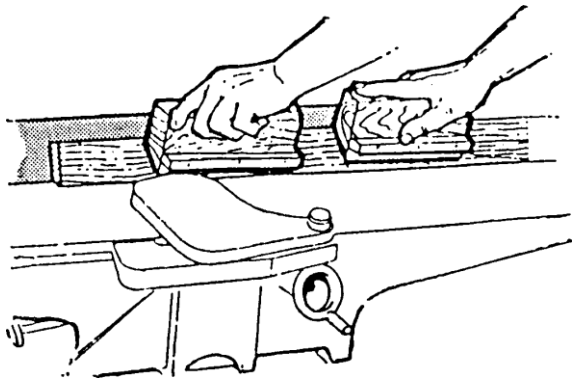


FIG. 41

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. 42).

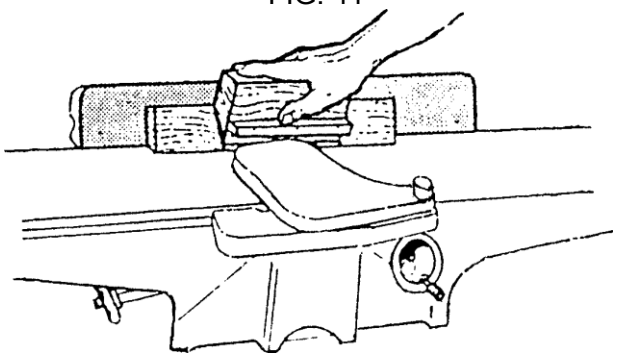


FIG. 42

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.

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. 43.

1. Release the fence locking handle and remove the two hex nuts and flat washer holding the fence to the fence support. 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.

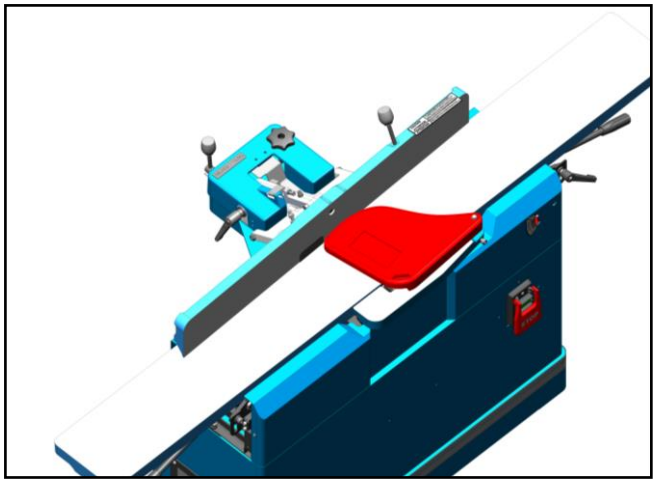
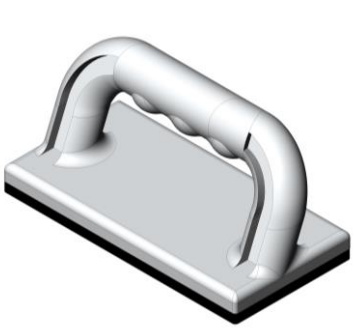


FIG. 43

Push Blocks

Push blocks are simple, yet necessary tools to assist the operator especially when jointing thin or short stock. Illustrated in Fig. 44 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



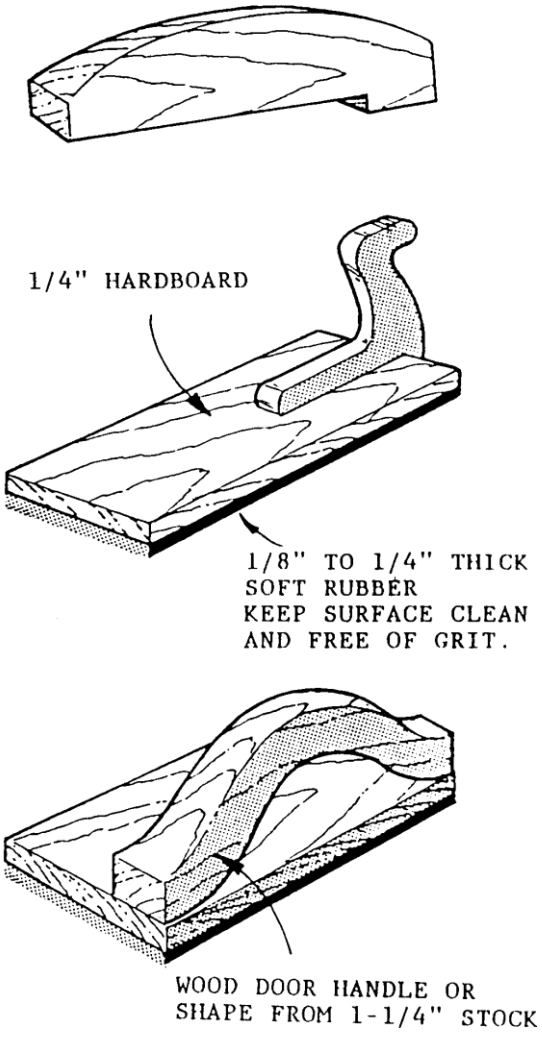
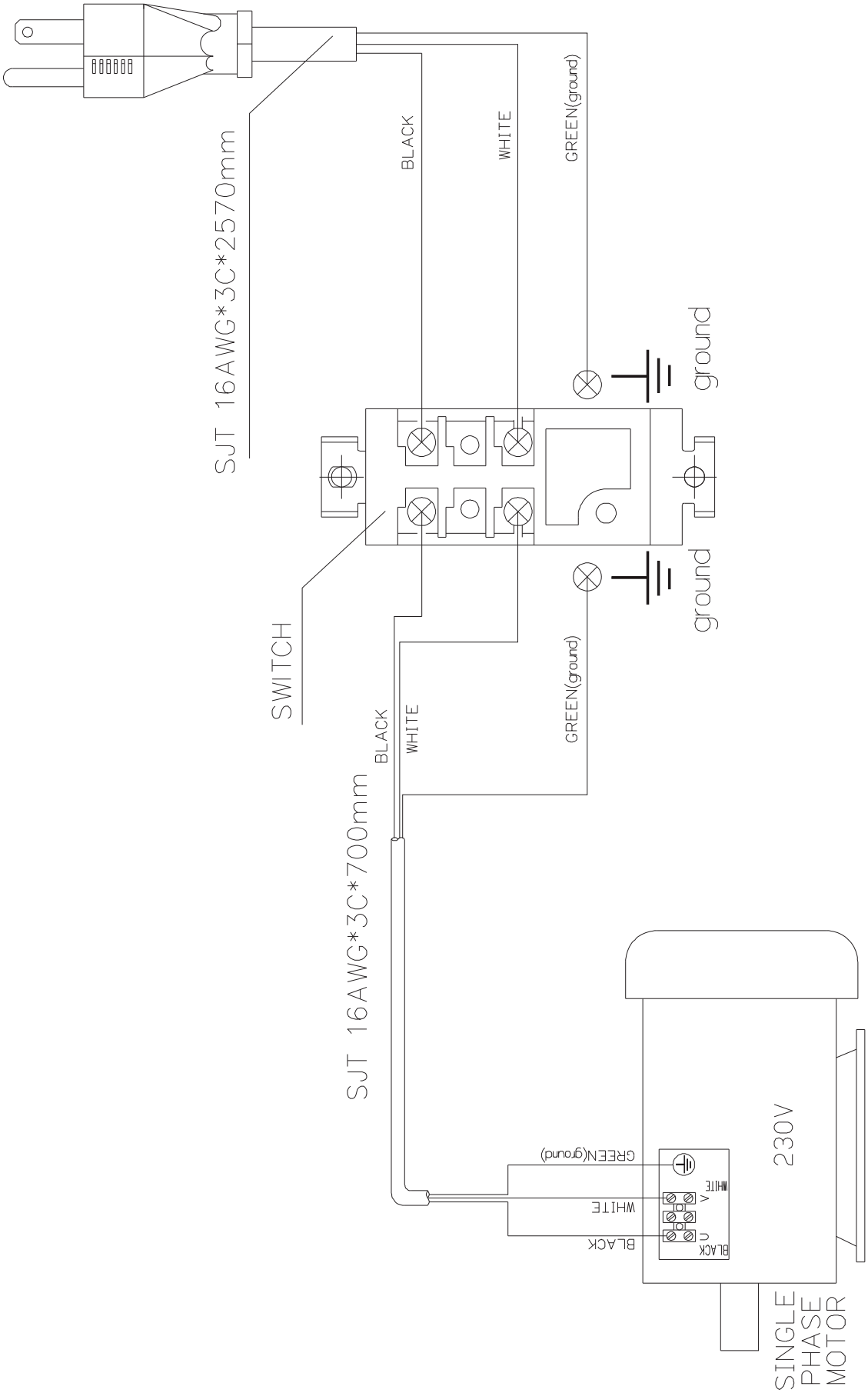
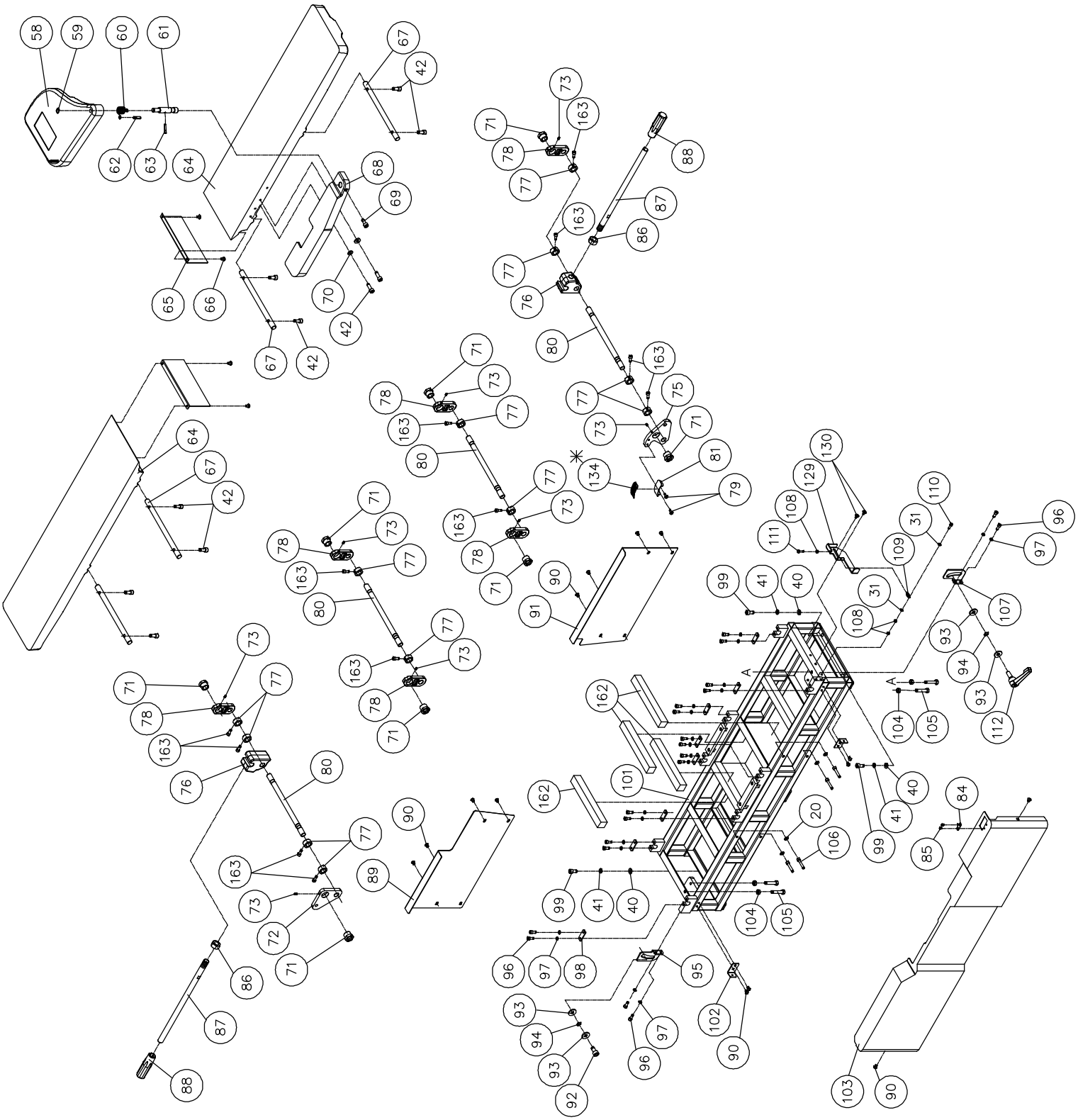


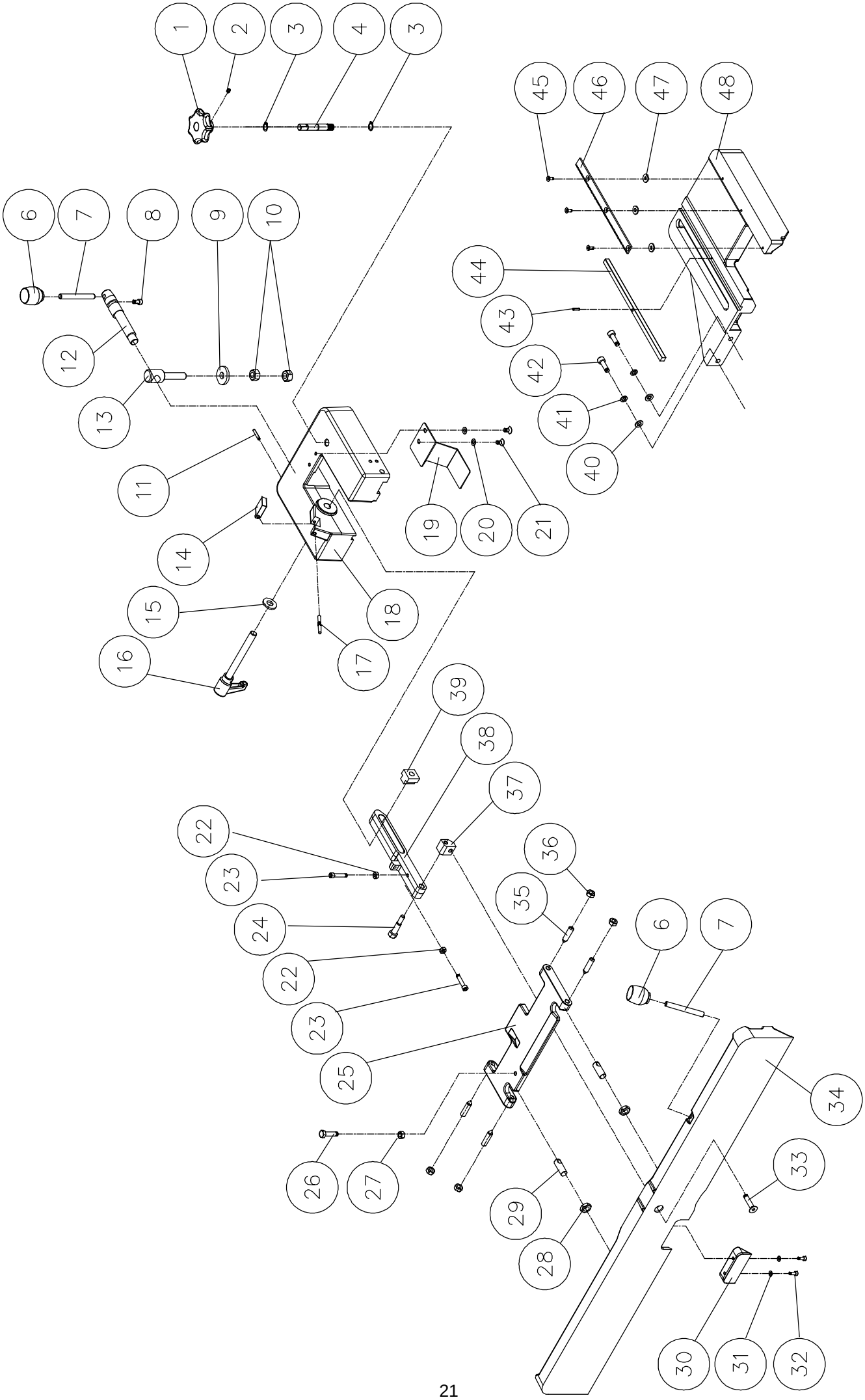
FIG. 44

Wiring Diagrams



Parts Diagrams

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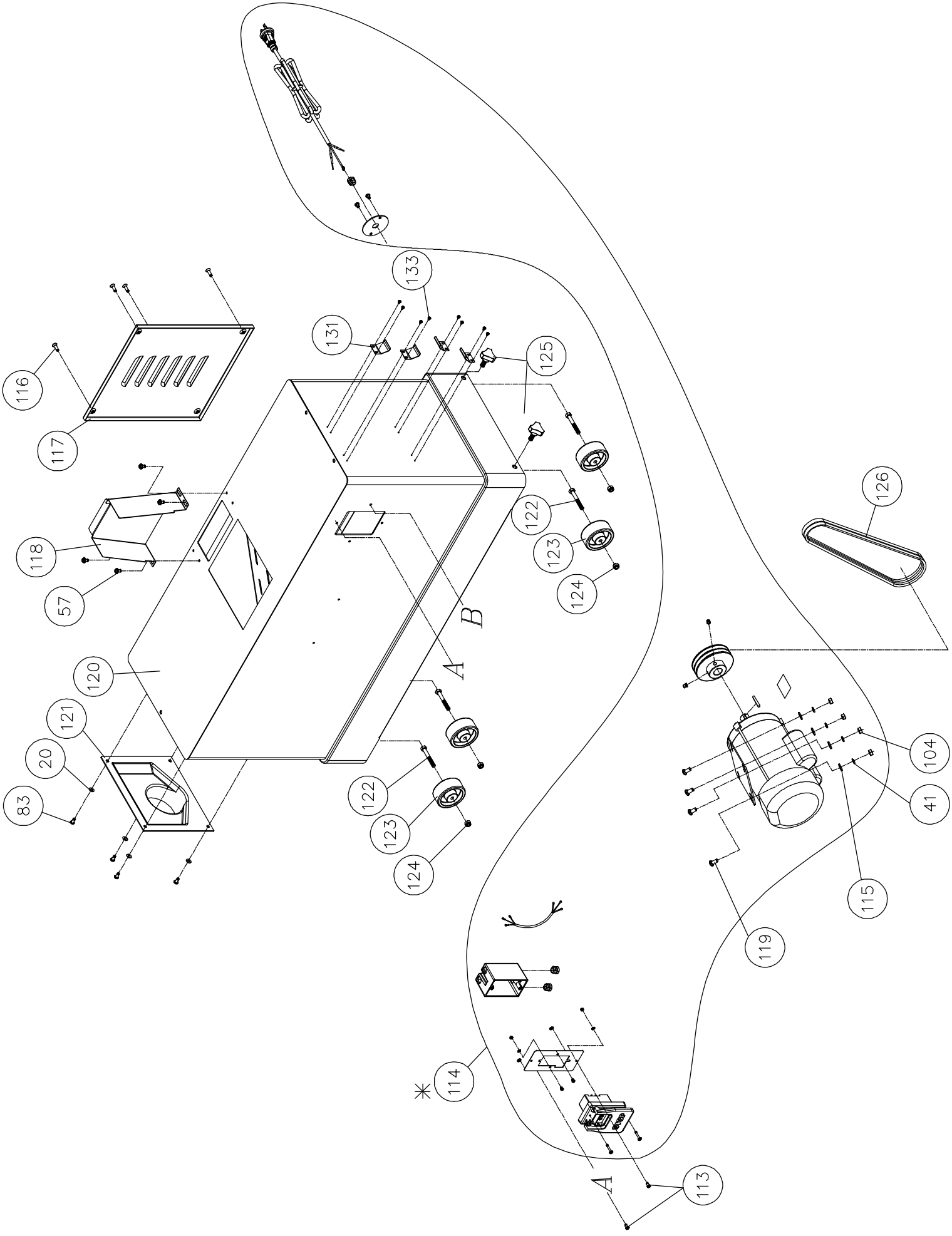
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Parts List

Key	Part No.	Descriptions		Q'ty
1	240080-904	KNOB		1
2	001902-109	SET LOCK SCREW	M6*1.0P*6	1
3	010003-000	RETAINING RING	STW-12	2
4	381336-901	SHAFT		1
5	250035-629	PUSH BLOCK		2
6	250034-615	KNOB FENCE TILT		2
7	360038-901	HANDLE SHAFT		2
8	003103-102	CAP SCREW	1/4"-20NC*1/2"	1
9	172285-905	FLAT WASHER	13*35*5.0t	1
10	009011-100	HEX. NUT	1/2"-12NC(19.05B*11.11H)	2
11	011002-106	SPRING PIN	4*25	1
12	360074-901	CRANK		1
13	360075-901	CLAMP SCREW		1
14	130019-903	PLATE STOP		1
15	006001-091	FLAT WASHER	13*28*3.0t	1
16	230035-000	LOCK HANDLE		1
17	360078-000	PIN		1
18	051332-000	FENCE BRACKET COVER		1
19	170127-901	PLATE		1
20	006003-022	FLAT WASHER	6.3*13*1.0t	10
21	003403-102	PAN HEAD PHILLIPS SCREW	1/4"-20NC*1/2"	2
22	009004-100	HEX. NUT	1/4"-20NC(11B*5.5H)	2
23	003103-104	CAP SCREW	1/4"-20NC*1-1/4"	2
24	290007-901	BOLT SHOULDER 10*6		1
25	051313-000	TILT PLATE		1
26	003003-106	HEX. SCREW	5/16"-18NC*1-1/4"	1
27	009005-100	HEX. NUT	5/16"-18NC(12.7B*6.75H)	5
28	009010-100	HEX. NUT	1/2"-20NF(19.05B*6.35H)	2
29	360676-901	STUD PIVOT		2
30	250462-615	PACKING		1
31	006001-009	FLAT WASHER	5.2*10*1.0t	4
32	003102-102	CAP SCREW	3/16"-24NC*1/2"	2
33	003602-101	PAN HEAD HEX. SCREW	5/16"-18NC*1-1/2"	1
34	051331-000	FENCE		1
35	230015-901	STUD PIVOT		4

Parts List

Key	Part No.	Descriptions		Q'ty
1	240080-904	KNOB		1
2	001902-109	SET LOCK SCREW	M6*1.0P*6	1
3	010003-000	RETAINING RING	STW-12	2
4	381336-901	SHAFT		1
5	250035-629	PUSH BLOCK		2
6	250034-615	KNOB FENCE TILT		2
7	360038-901	HANDLE SHAFT		2
8	003103-102	CAP SCREW	1/4"-20NC*1/2"	1
9	172285-905	FLAT WASHER	13*35*5.0t	1
10	009011-100	HEX. NUT	1/2"-12NC(19.05B*11.11H)	2
11	011002-106	SPRING PIN	4*25	1
12	360074-901	CRANK		1
13	360075-901	CLAMP SCREW		1
14	130019-903	PLATE STOP		1
15	006001-091	FLAT WASHER	13*28*3.0t	1
16	230035-000	LOCK HANDLE		1
17	360078-000	PIN		1
18	051332-000	FENCE BRACKET COVER		1
19	170127-901	PLATE		1
20	006003-022	FLAT WASHER	6.3*13*1.0t	10
21	003403-102	PAN HEAD PHILLIPS SCREW	1/4"-20NC*1/2"	2
22	009004-100	HEX. NUT	1/4"-20NC(11B*5.5H)	2
23	003103-104	CAP SCREW	1/4"-20NC*1-1/4"	2
24	290007-901	BOLT SHOULDER 10*6		1
25	051313-000	TILT PLATE		1
26	003003-106	HEX. SCREW	5/16"-18NC*1-1/4"	1
27	009005-100	HEX. NUT	5/16"-18NC(12.7B*6.75H)	5
28	009010-100	HEX. NUT	1/2"-20NF(19.05B*6.35H)	2
29	360676-901	STUD PIVOT		2
30	250462-615	PACKING		1
31	006001-009	FLAT WASHER	5.2*10*1.0t	4
32	003102-102	CAP SCREW	3/16"-24NC*1/2"	2
33	003602-101	PAN HEAD HEX. SCREW	5/16"-18NC*1-1/2"	1
34	051331-000	FENCE		1
35	230015-901	STUD PIVOT		4

Key	Part No.	Descriptions		Q'ty
36	009022-100	HEX. NUT	3/8"-16NC(13.83B*6.68H)	4
37	130008-903	NUT HANDLE		1
38	051334-000	SHAFT LOCK		1
39	130018-903	SQUARE NUT		1
40	006001-049	FLAT WASHER	8.5*16*2.0t	9
41	006305-100	SPRING WASHER	8.2*15.4	13
42	000104-108	CAP SCREW	M8*1.25P*25	12
43	011002-104	SPRING PIN	4*14	1
44	380082-902	KEY		1
45	000701-103	PAN HEAD HEX. SCREW	M5*0.8P*12	3
46	171841-902	LEAD SCREW		1
47	006001-034	FLAT WASHER	6.7*16*2.0t	3
48	051355-000	FENCE BRACKET		1
49	000104-123	CAP SCREW	M8*1.25P*55	4
50	012003-008	KEY	5*5*22	1
51	050096-901	CUTTERHEAD PULLEY		1
52	004403-705	SET LOCK SCREW	5/16"-18NC*3/8"	3
53	051356-902	BEARING HOUSING		2
54	030208-001	BALL BEARING	6204	2
55	924046-000	HELICAL CUTTERHEAD ASSEMBLY	5 SLOTS	1
56	174277-902	BLADE GUARD		1
57	001603-102	ROUND HEAD PHILLIP SCREW W/WASHER	M6*1.0P*10/6*13.2*1.0t	6
58	090020-000	BLADE GUARD		1
59	010002-000	RETAINING RING	STW-11	1
60	280013-901	SPRING		1
61	360459-901	BLADE GUARD SHAFT		1
62	011004-106	SPRING PIN	6*28	1
63	011003-110	SPRING PIN	5*40	1
64	051357-000	TABLE		2
65	174238-902	BLOCKED DUST PLATE		2
66	001602-101	ROUND HEAD PHILLIP SCREW W/WASHER	M5*0.8P*10/5*12*0.8t	4
67	361239-902	SHAFT		4
68	051358-000	RIBBET		1
69	002601-102	CAP LOCK SCREW	M8*1.25P*20	1
70	006001-163	FLAT WASHER	8.5*19*3t	2
71	130350-903	BUSHING		8

Key	Part No.	Descriptions		Q'ty
72	130351-903	SUPPORTING PLATE		1
73	001901-102	SET LOCK SCREW	M5*0.8P*8	8
75	130371-903	CONNECTING ROD PLATE-R		1
76	051359-902	LIFTING BASE		2
77	361241-902	BUSHING		12
78	130352-903	ROD BRACKET		6
79	002402-101	ROUND HEAD PHILLIPS SCREW W/WASHER	M5*0.8P*12/5*10.5*1.0t	2
80	361271-902	CONNECTING ROD		4
81	174407-902	SCALE BRACKET		1
83	000304-103	ROUND HEAD PHILLIPS SCREW	M6*1.0P*12	4
84	174406-156	POINTER INDICATOR		1
85	000805-101	ROUND HEAD HEX SCREW	M4*0.7P*6	2
86	008011-200	HEX. NUT	M16*2.0P(24B*13H)	2
87	361244-902	HEIGHT ADJUSTMENT ROD		2
88	250496-615	HEIGHT ADJUSTMENT HANDLE		2
89	174241-000	REAR COVER-L		1
90	000801-108	ROUND HEAD HEX SCREW	M6*1.0P*8	14
91	174242-000	REAR COVER-R		1
92	000105-101	CAP SCREW	M10*1.5P*20	1
93	006001-068	FLAT WASHER	10*20*2.0t	4
94	006703-100	WAVE WASHER	WW-10	2
95	174243-902	FIXING BRACKET-L		1
96	000103-105	CAP SCREW	M6*1.0P*15	20
97	006317-100	SPRING WASHER	6.1*10.3	20
98	174244-902	FIXING PLATE		8
99	000104-106	CAP SCREW	M8*1.25P*20	3
101	924333-000	FRAMEWORK ASSEMBLY		1
102	174245-902	BRACKRT		2
103	174405-000	FRONT COVER		1
104	008006-100	HEX. NUT	M8*1.25P(13B*6.5H)	6
105	000003-108	HEX. SCREW	M8*1.25P*40	4
106	000103-110	CAP SCREW	M6*1.0P*35	4
107	174247-902	FIXING BRACKET-R		1
108	008004-100	HEX. NUT	M5*0.8P(8B*4H)	3
109	280082-000	SPRING		1
110	000102-116	CAP SCREW	M5*0.8P*15	1

Key	Part No.	Descriptions		Q'ty
111	000001-102	HEX. SCREW	M5*0.8P*16	1
112	230343-000	LOCK HANDLE		1
113	000303-103	ROUND HEAD PHILLIPS SCREW	M5*0.8P*10	2
114	901027-001	MOTOR & SWITCH ASSEMBLY	2HP*220V*60HZ*1PH	1
114.01	603073-000	MOTOR	2HP*230V*60HZ*1PH*2P*8A	1
114.03	012003-011	KEY	5*5*35	1
114.04	050099-901	MOTOR PULLEY		1
114.05	004404-102	SET LOCK SCREW	3/8"-16NC*3/8"	2
114.06	000302-809	ROUND HEAD PHILLIPS SCREW	M4*0.7P*25	2
114.07	841007-001	ON-OFF SWITCH	35A*120V/20A*230V	1
114.08	174365-902	SWITCH PLATE		1
114.09	250480-615	SWITCH BOX		1
114.10	020003-000	STR	SB7R-3	3
114.11	000302-101	ROUND HEAD PHILLIPS SCREW	M4*0.7P*6	2
114.12	006501-100	TOOTH WASHER	4.3*8.5(BW-4)	2
114.13	008002-200	HEX. NUT	M4*0.7P(7B*3.2H)	2
114.14	570695-000	GROUNDING LABEL		2
114.15	473002-020	SWITCH CORD	SJT16AWG*3C*1000mm	1
114.16	453012-020	POWER CORD	SJT 16AWG*3C*2570mm	1
114.17	000304-101	ROUND HEAD PHILLIPS SCREW	M6*1.0P*8	2
114.18	174239-902	CORD FIXING PLATE	SB7R-3	1
115	006001-053	FLAT WASHER	8.5*19*2.0t	4
116	000403-104	PAN HEAD PHILLIPS SCREW	M6*1.0P*20	4
117	170445-000	COVER		1
118	170673-000	PULLEY COVER		1
119	003801-202	CARRIAGE SCREW	5/16"-18NC*3/4"	4
120	174249-000	STAND		1
121	250052-615	DUST CHUTE		1
122	000003-313	HEX. SCREW	M8*1.25P*60	4
123	250399-615	WHEEL		4
124	008306-100	HEX. LOCKING NUT	M8*1.25P(13B*9H)	4
125	230388-000	BOLT		2
126	014019-000	V-BELT	M39	2
129	174287-156	FIXING PLATE		1
130	290028-901	CARRIAGE SCREW		2
131	270003-901	CLIP		4

Key	Part No.	Descriptions		Q'ty
133	001102-102	ROUND HEAD TAPPING SCREW	M4*1.59P*8	8
142	040003-000	HEX. WRENCH	3mm	1
143	040005-000	HEX. WRENCH	5mm	1
144	040006-000	HEX. WRENCH	6mm	1
145	040007-000	HEX. WRENCH	8mm	1
146	040201-000	OPEN WRENCH	8*10	1
147	040203-000	OPEN WRENCH	11*13	1
148	040401-000	SCREW DRIVER		1
163	002602-101	CAP LOCK SCREW	M6*1.0P*12	12