



# 6" Jointer with Helical Cutterhead

## Owner's Manual



## **Warranty**

Oliver makes every effort possible to assure that its equipment meets the highest possible standards of quality and durability. All products sold by Oliver are warranted to the original customer to be free from defects for a period of 2 (two) years on all parts, excluding electronics and motors, which are warranted for 1 year. Oliver's obligation under this warranty shall be exclusively limited to repairing or replacing (at Oliver's option) products which are determined by Oliver to be defective upon delivery F.O.B. (return freight paid by customer) to Oliver, and on inspection by Oliver. This warranty does not apply to defects due, directly or indirectly, to misuse, abuse, negligence, accidents, unauthorized repairs, alterations, lack of maintenance, acts of nature, or items that would normally be consumed or require replacement due to normal wear. In no event shall Oliver be liable for death, personal or property injury, or damages arising from the use of its products.

## **Warning**

Read this manual thoroughly before operating the machine. Oliver Machinery disclaims any liability for machines that have been altered or abused. Oliver Machinery reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

## **For More Information**

Oliver Machinery is always adding new Industrial Woodworking products to the line. For complete, up-to-date product information, check with your local Oliver Machinery distributor, or visit [www.olivermachinery.net](http://www.olivermachinery.net)

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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 , planing, or rabbeting cut deeper than 1/8 in.

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

**Never perform** jointing, planing, 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.

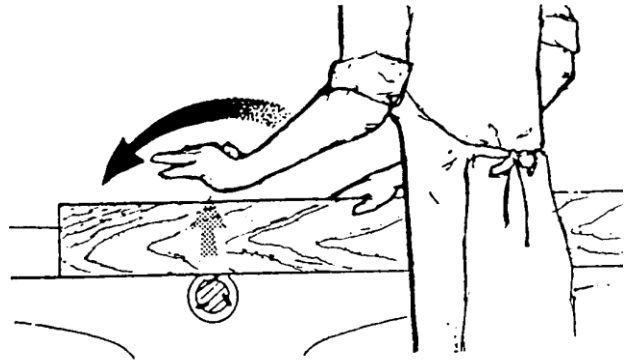
**Maintain** the proper relationships of infeed and outfeed table surfaces and cutter head knife path.

**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 Jointer

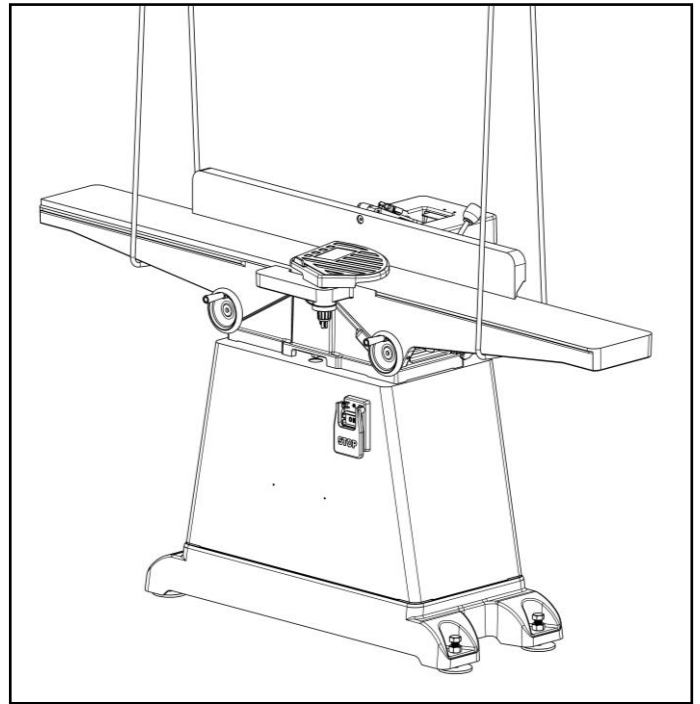
Upon delivery, open shipping containers and check that all parts are in good condition. Any damage should be reported to your distributor and shipping agent immediately. Before proceeding further, read your manual and familiarize yourself thoroughly with assembly, maintenance and safety procedures.

**Warning:** This machine is very heavy. Please don't move or assembly this machine alone. Ask someone to help for safety required.

## Unpacking and cleaning

To ensure maximum performance from your 6" 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.



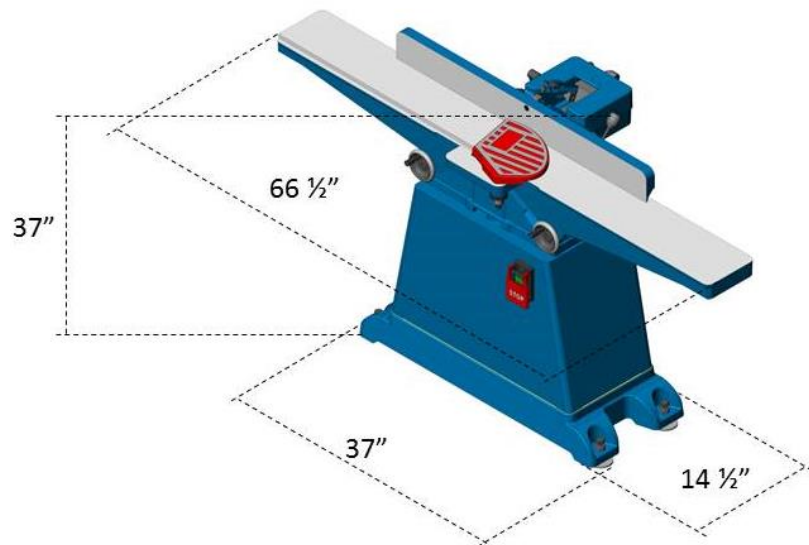
## Using a sling

Please using a sling to carry machine, lifting handles must be pulled out (Fig.1). Try keeping sling parallel to machine and hold steady.

## Placement the 6" 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 planer (366 lbs-166kgs) and the operator.

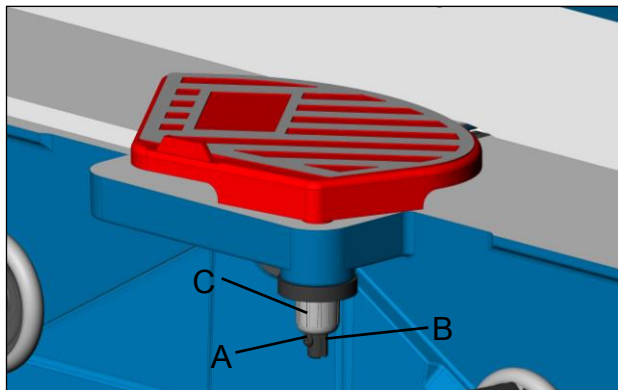
Using the dimensions shown as below (L1600mmx694.7mmx1330.6mm), plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic or other tools or machinery.



## 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 (B)
2. Turn knob (C) counterclockwise to create tension on spring, and hold it there.
3. Insert guard post (B) down through hole in front of ledge.
4. Slightly turn knob (V), 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 (B)



## Safety Switch

The jointer is equipped with a push-button switch that will accept a safety padlock (not included). See Fig.10. To safeguard your machine from unauthorized operation and accidental starting by young children, the use of a padlock is required.

### To start the machine

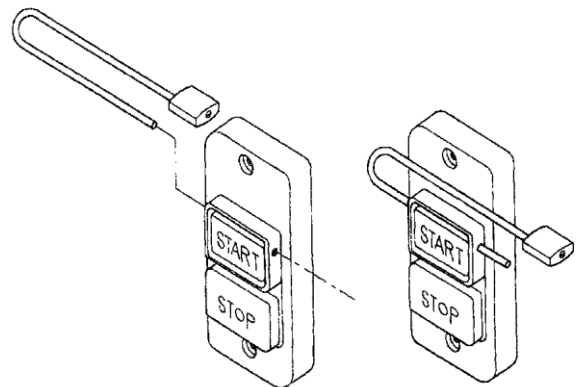
Lift the red stop switch panel and remove the lock-out pin. Lower the stop panel and push the green "ON" button. Wait for the cutter head to reach full speed before jointing.

### To stop the machine

Push on the RED "STOP" panel and wait for the cutter head to come to a complete stop.

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.



## 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.

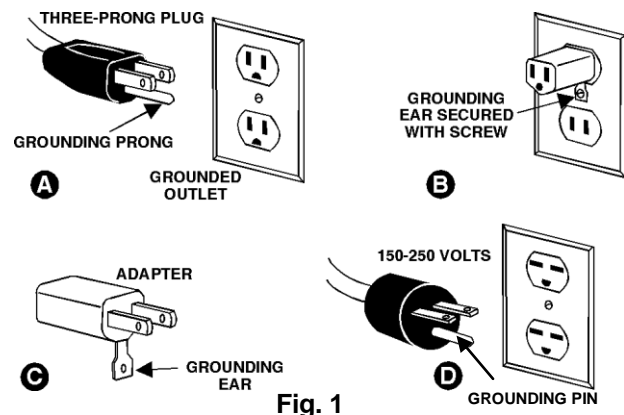


Fig. 1

**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 outfeed table should be set level with the highest point of the knives, Fig. 3. 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 cutter head and upper pulley, remove the cutter head guard and fence.
3. Set a straightedge (D) onto the outfeed table so that it sits over the cutter head but does not completely cross the gap between the tables and touch the in feed table, Fig. 4.
4. Turn the upper pulley by hand, until any one of the knives is at it's highest point.
5. Loosen the outfeed table height adjustment hand wheel lock knob (F) then loosen the table height setting locking levers (E), Fig. 5.
6. Use handwheel (G) to adjust the out-feed table height so that the knife barely touches the straight-edge, Fig. 6.
7. Re-tighten lock knob (F) and locking levers (E) to secure the outfeed table in position and lock the hand wheel

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

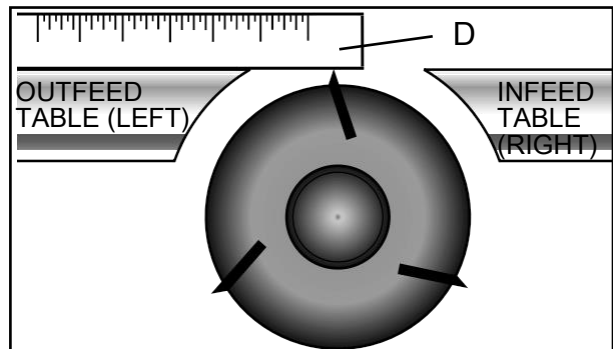


Fig. 3

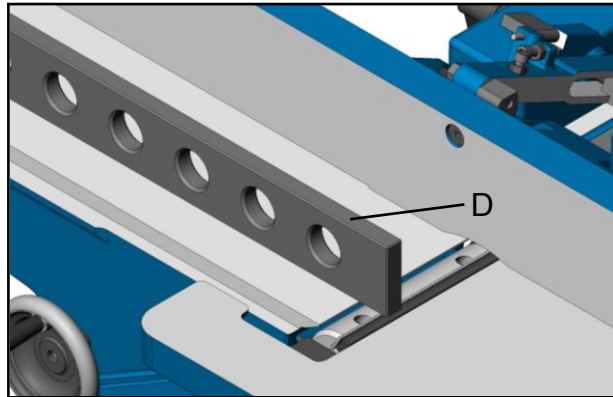


Fig. 4

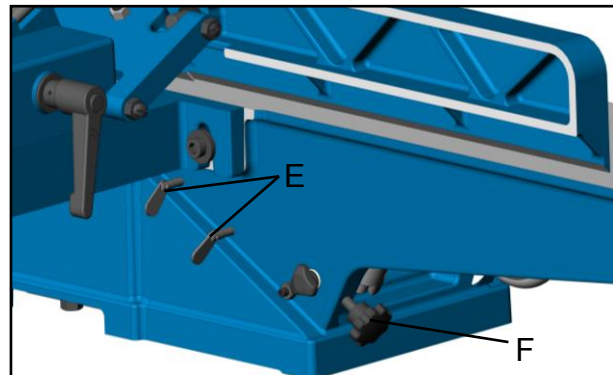


Fig. 5

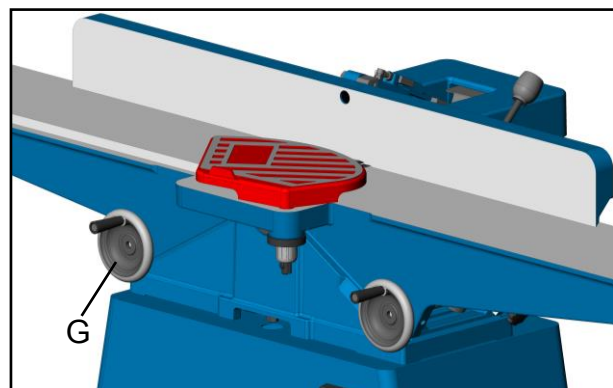


Fig. 6

## 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.7.

**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 adjustment hand wheel lock knob (A), Fig. 7.
2. Pull & hold back the 1/8" depth stop lock pin (B), Fig. 7.

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

3. Use handwheel (C, Fig.9) to adjust infeed table height to the desired depth of cut and then release the 1/8" depth stop lockpin (B) and retighten lock knob (A) to secure the infeed table in position and lock the handwheel.

**Note:** Refer to the graduated depth scale (D). Loosen the in disconnected from the power source.

## To adjust outfeed 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. 10.

To set the table minimum height:

1. Loosen bolt (E).
2. Adjust infeed table to the desired minimum height then re-tighten bolt (E).

To set the table maximum height:

1. Loosen bolt (F).
2. Adjust infeed table to the desired maximum height then re-tighten bolt (F).

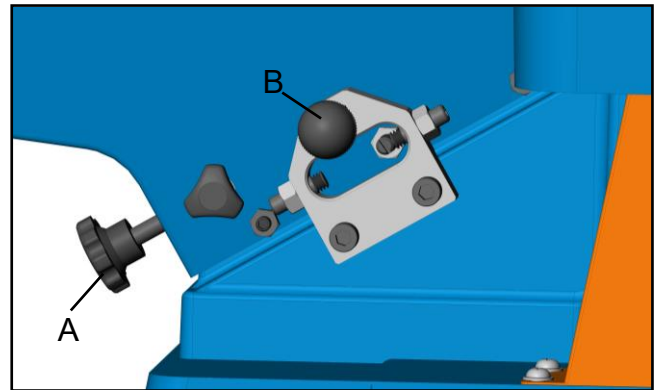


Fig. 7

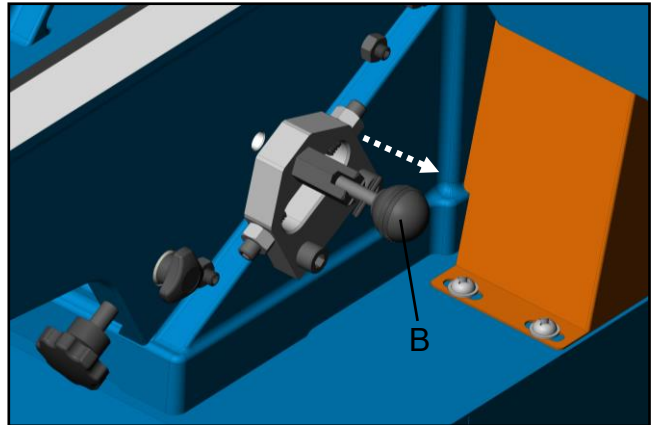


Fig. 8

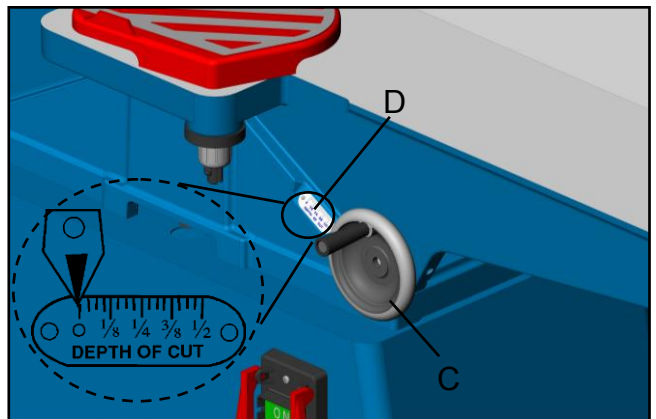


Fig. 9

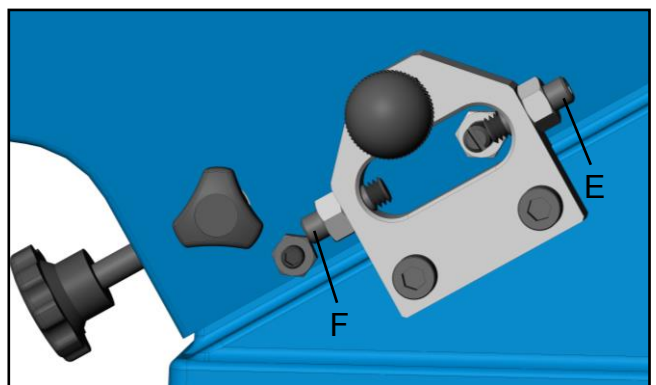


Fig. 10

## 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 7 lock nuts (B) then tighten 7 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 gib 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 (Fig. 6), tighten the lock screws.

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

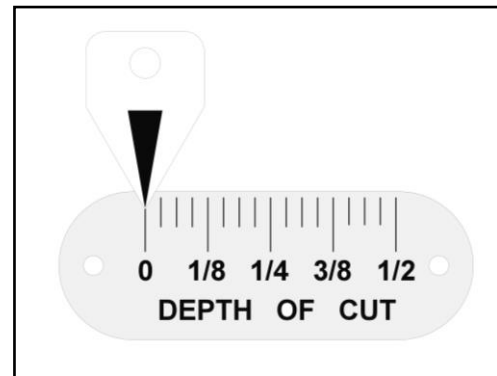


Fig. 6

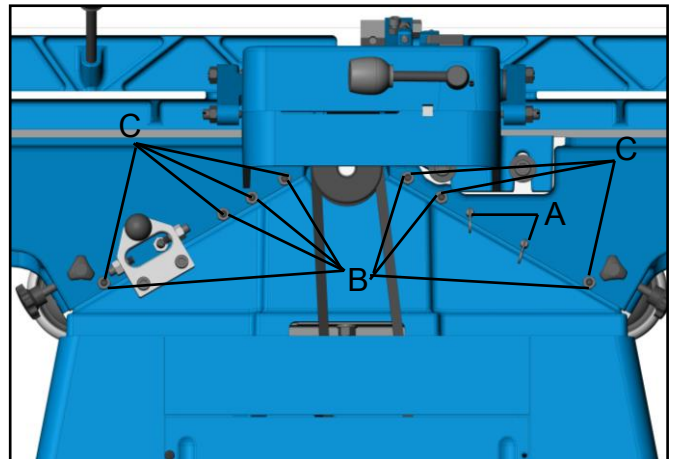


Fig. 7

## 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.

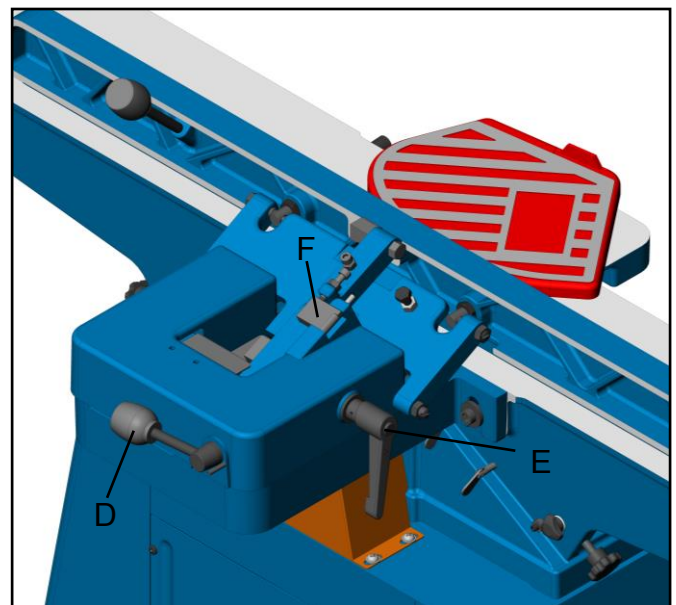


Fig. 8

**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 (G) Fig.10 on the table closed to fence surface and pulling up the fence handle (F) to confirm a 90° 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.

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

Referring to Fig. 11:

**Note:** The 45° fence backward stop is controlled by the stop bolt (H) and 135° 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° or 135° 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. 12 and against the fence to confirm 45° & 135° setting.
4. To adjust, loosen the lock nut (J) or (K) , turn the stop bolt (H) or (I) until a 45° or 135° angle is obtained.
5. Tighten the lock nut (J) or (K).
6. Double check to the fence is setting correct angel with table.

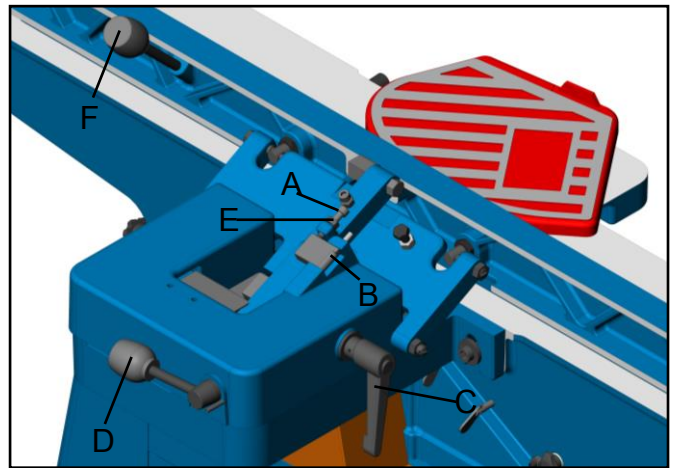


Fig. 9

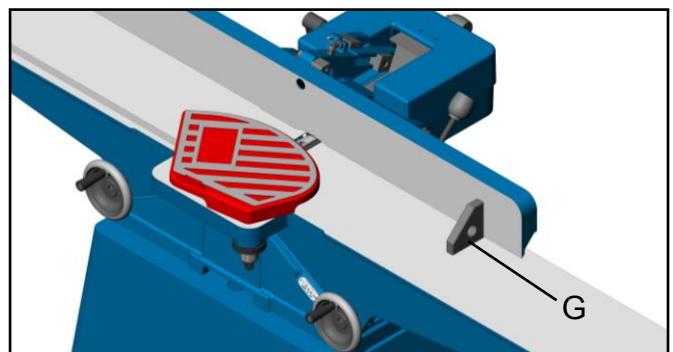


Fig. 10

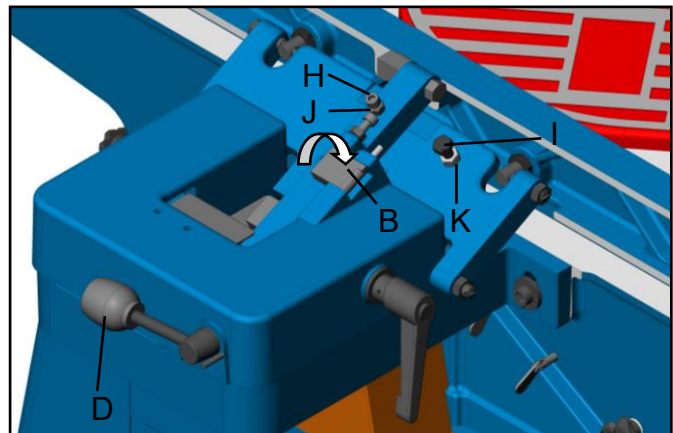


Fig. 11

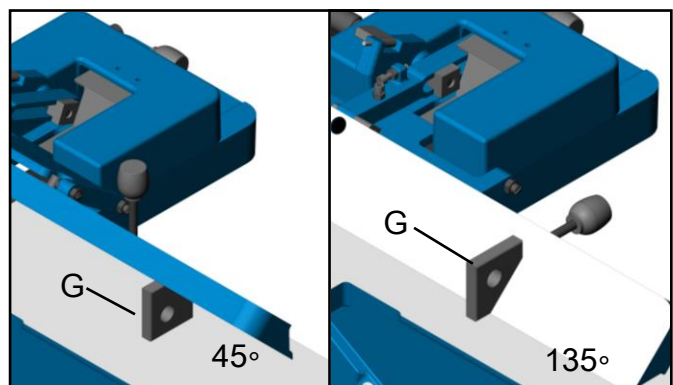


Fig. 12

## 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 wrench 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.**

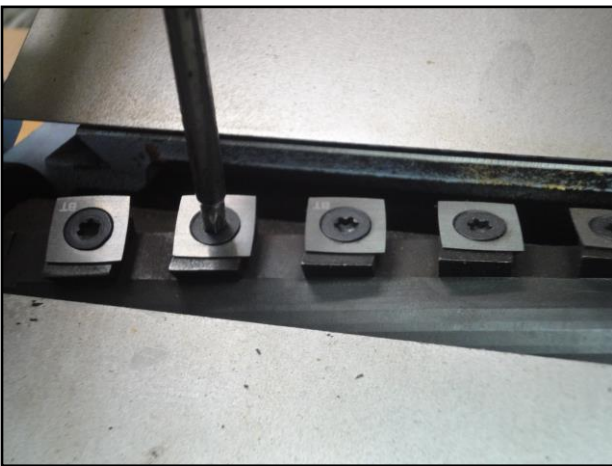


FIG. 13

## 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 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.

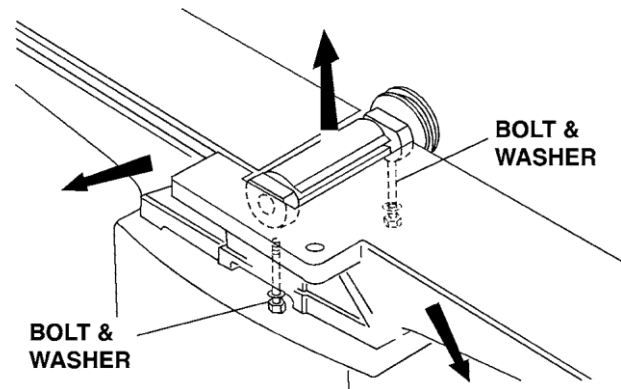


FIG. 14

## 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:



**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.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.

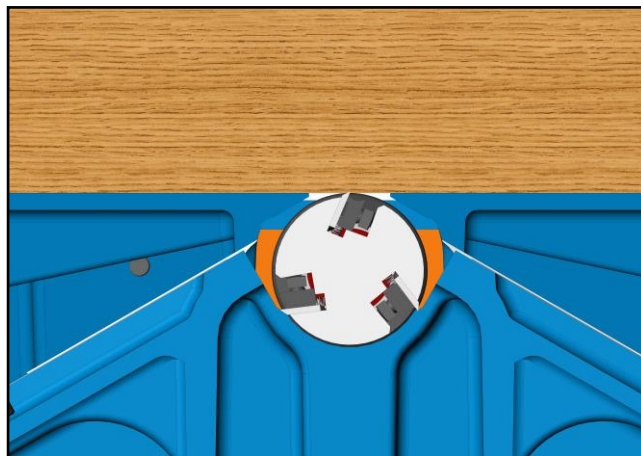


FIG. 16

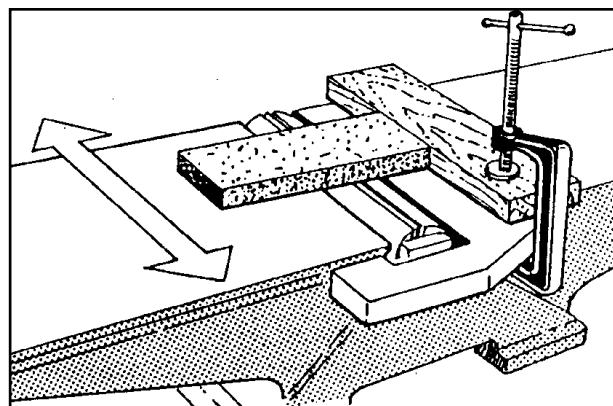


FIG. 17

## 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. Remove the pulley cover & cover on the rear stand , Fig 18.
2. Remove the Fence Assembly
3. Take the old belt from machine & motor pulleys.
4. Install a new belt on the machine & motor pulleys, Fig. 19
5. Place a metal straightedge (A) across both pulleys Fig.20 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 (B, Fig. 21) to make sure pulley alignment.
7. Put the fence, belt guard and stand cover back to machine & tighten all screws.

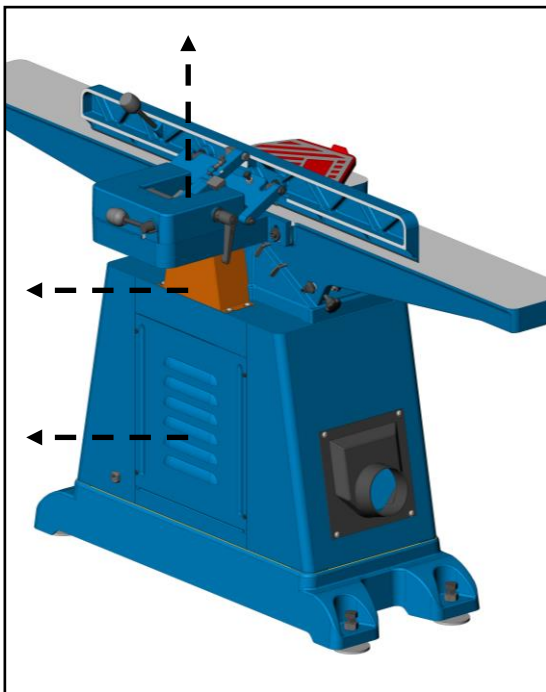


FIG. 18



FIG. 19

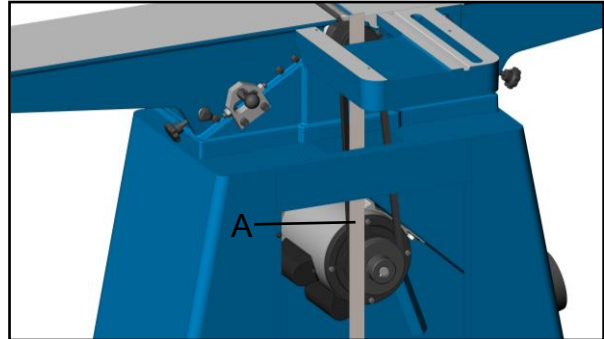


FIG. 20



FIG. 21

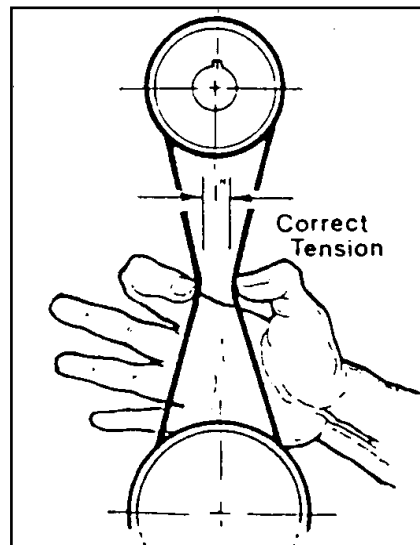


FIG. 22

## 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. 23). On stock longer than 12 inches use two push blocks (Fig. 24). With narrow stock use the type push block shown in Fig. 25. When surfacing short stock over 4 inches wide, use two (2) push blocks to guide material over cutterhead (Fig. 26).

two handed push block

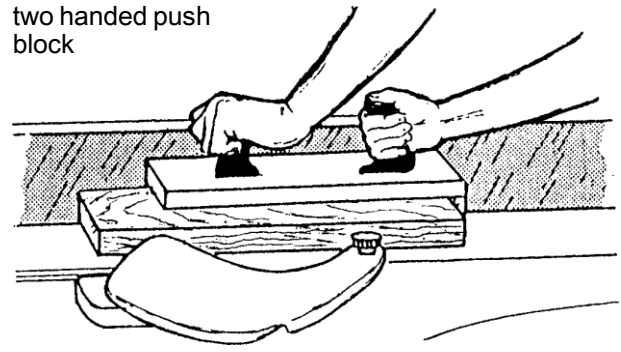


FIG. 23

two push blocks for stock longer than 12 inches

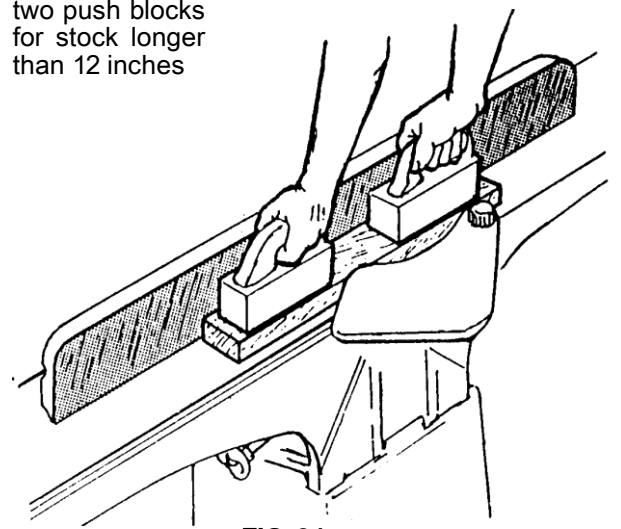


FIG. 24

L-shaped push block for narrow stock

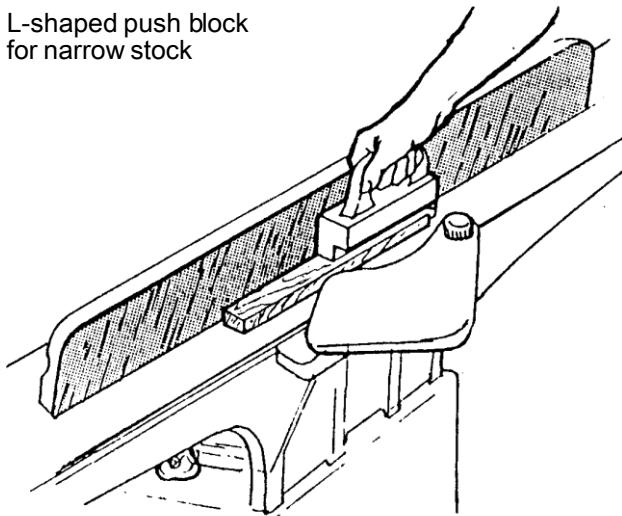


FIG. 25

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

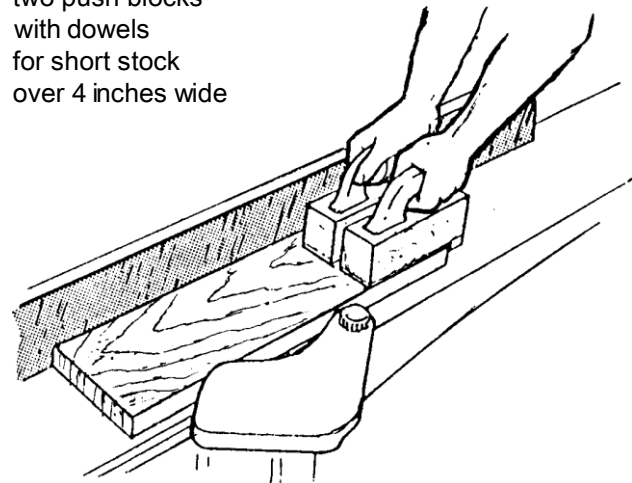


FIG. 26



## 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. 27).

Place second push block near the rear of infeed table and continue feeding stock using the hand over hand method (Fig. 28).

Before the left hand is in the 3 inch area of the cutterhead move it over to the outfeed side (Fig. 29).

As soon as possible follow with the right hand over to the outfeed side and continue through with cut (Fig.30).

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.

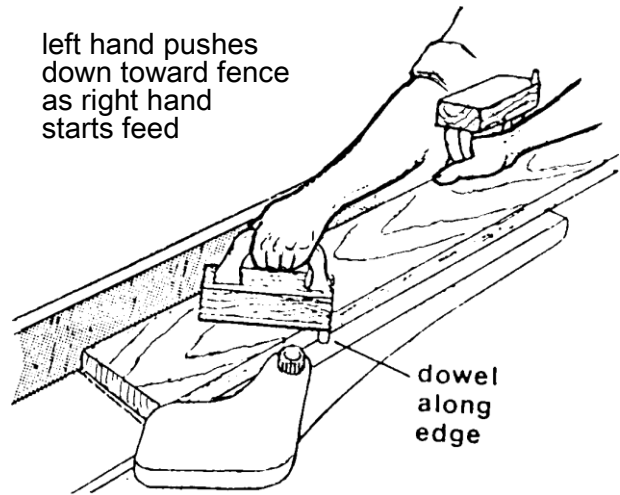


FIG. 27

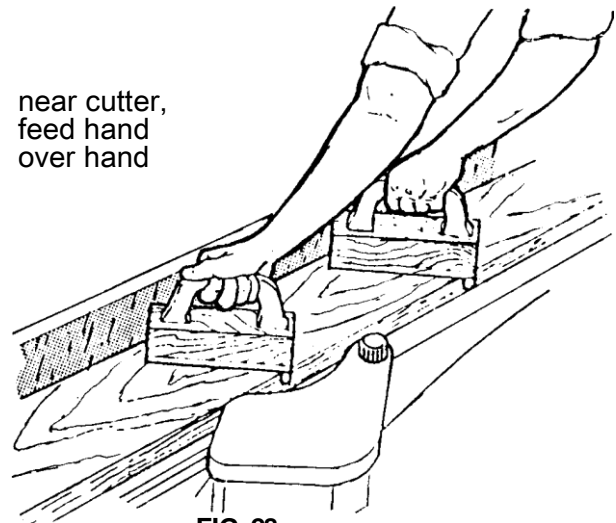


FIG. 28

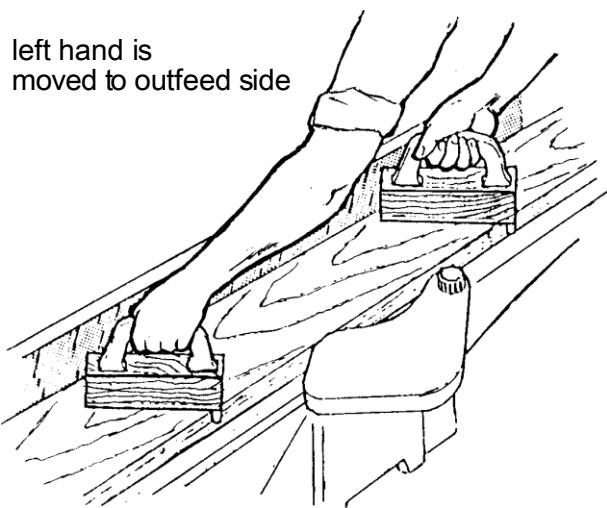


FIG. 29

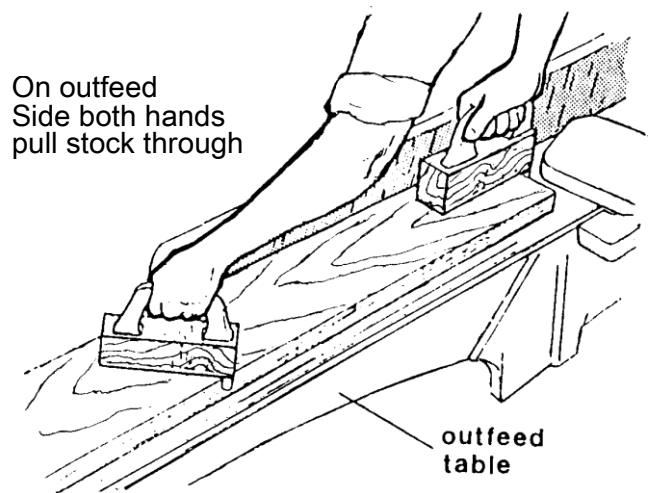


FIG. 30

## 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. 31).

## 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. 32).

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. 33).

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. 34).

## 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

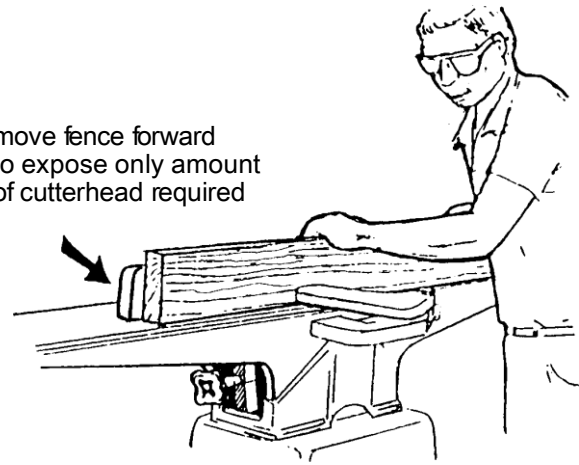


FIG.31

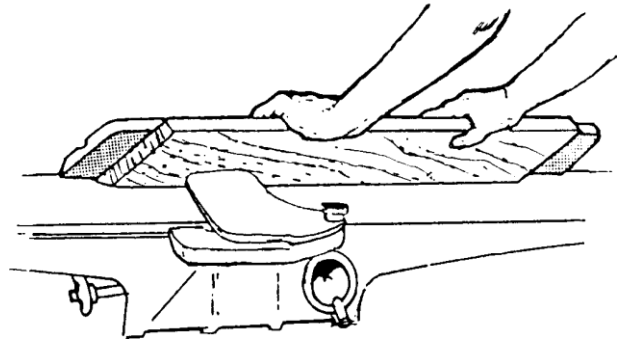


FIG. 32

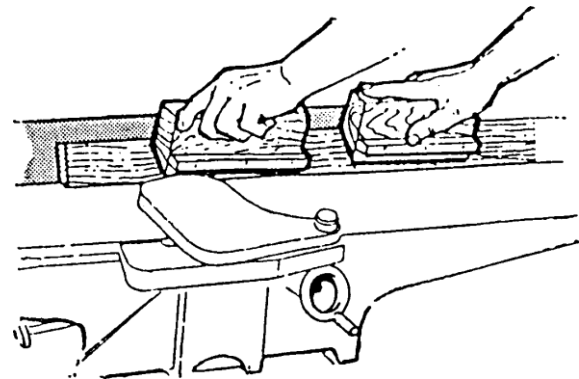


FIG. 33

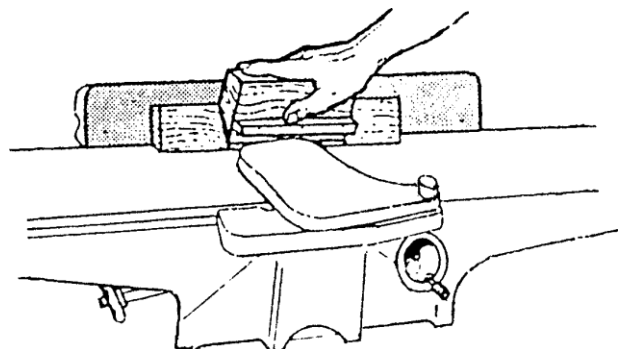


FIG. 34

## 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. 35.

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.

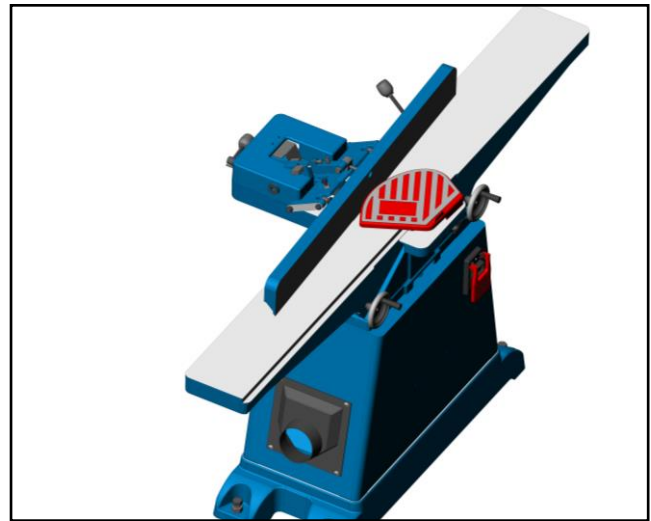
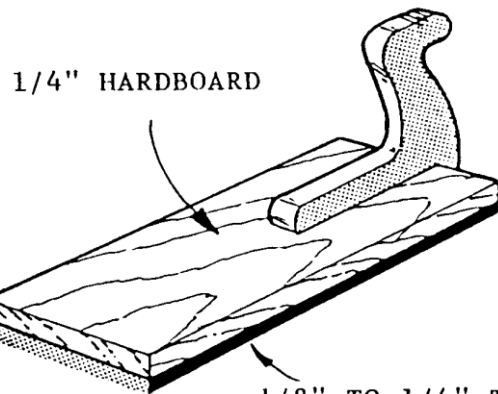
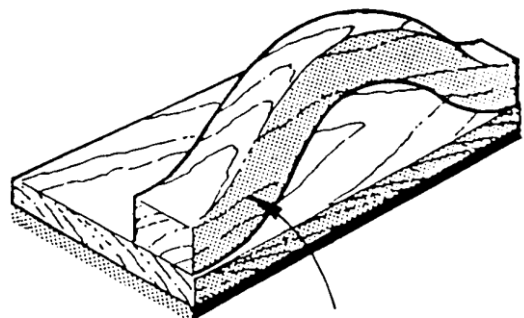


FIG. 35



1/4" HARDBOARD

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



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

FIG. 36

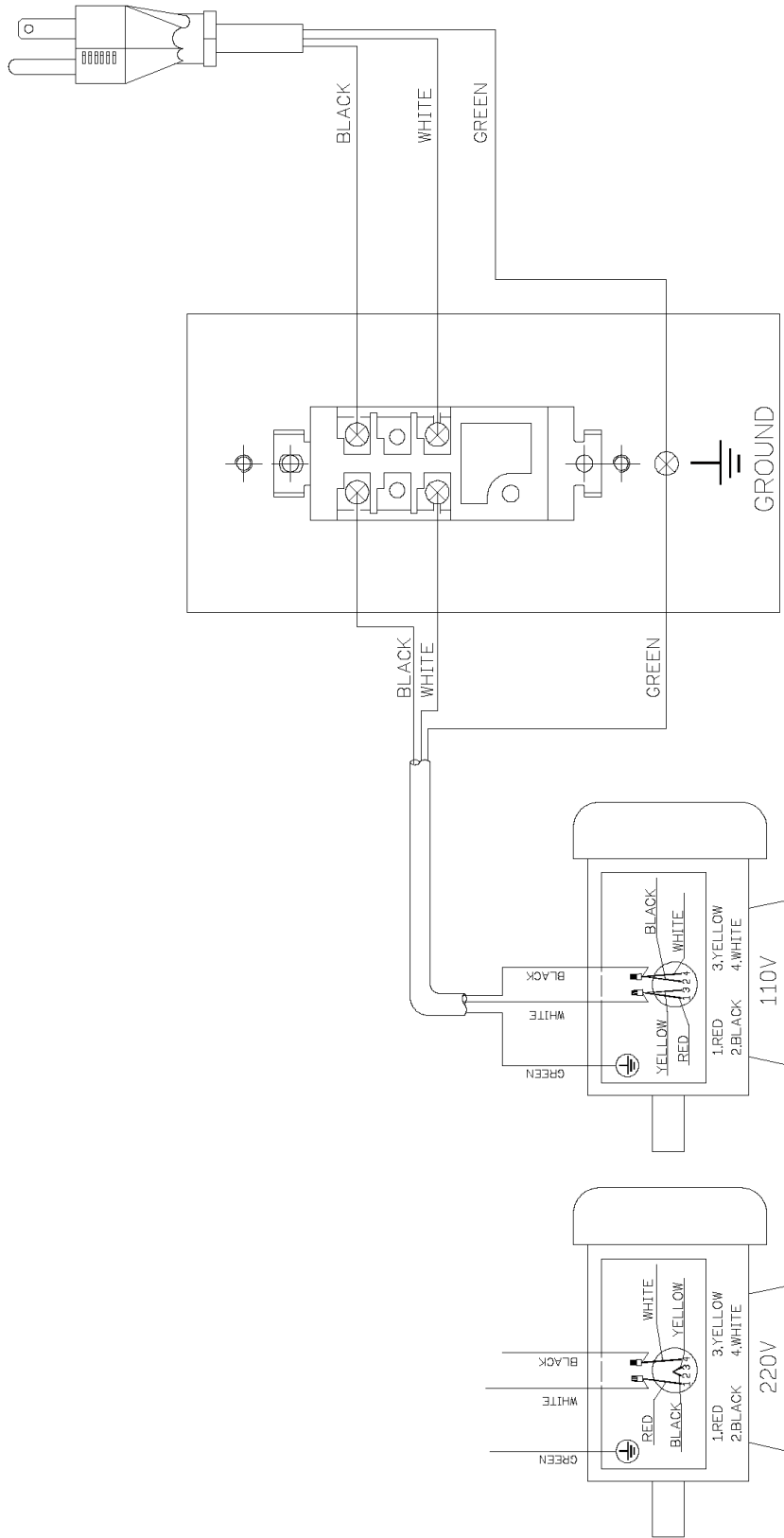
## Push Blocks

Push blocks are simple, yet necessary tools to assist the operator especially when jointing thin or short stock. Illustrated in Fig. 36 are three types of push blocks commonly used in jointing. Push blocks may be obtained commercially or easily constructed.

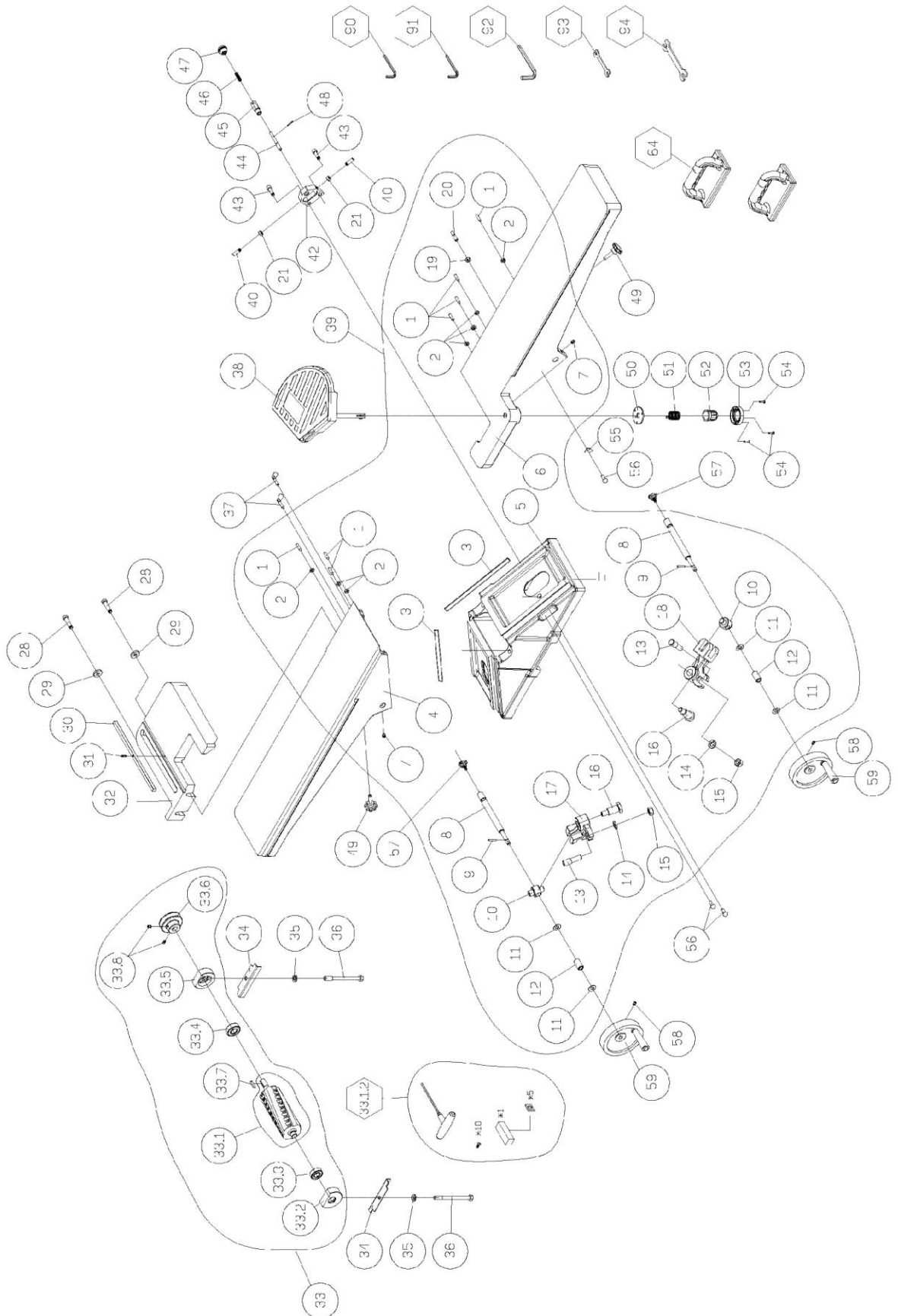
**Note:** The Jointer is supplied with two push block for feeding stock as below showing

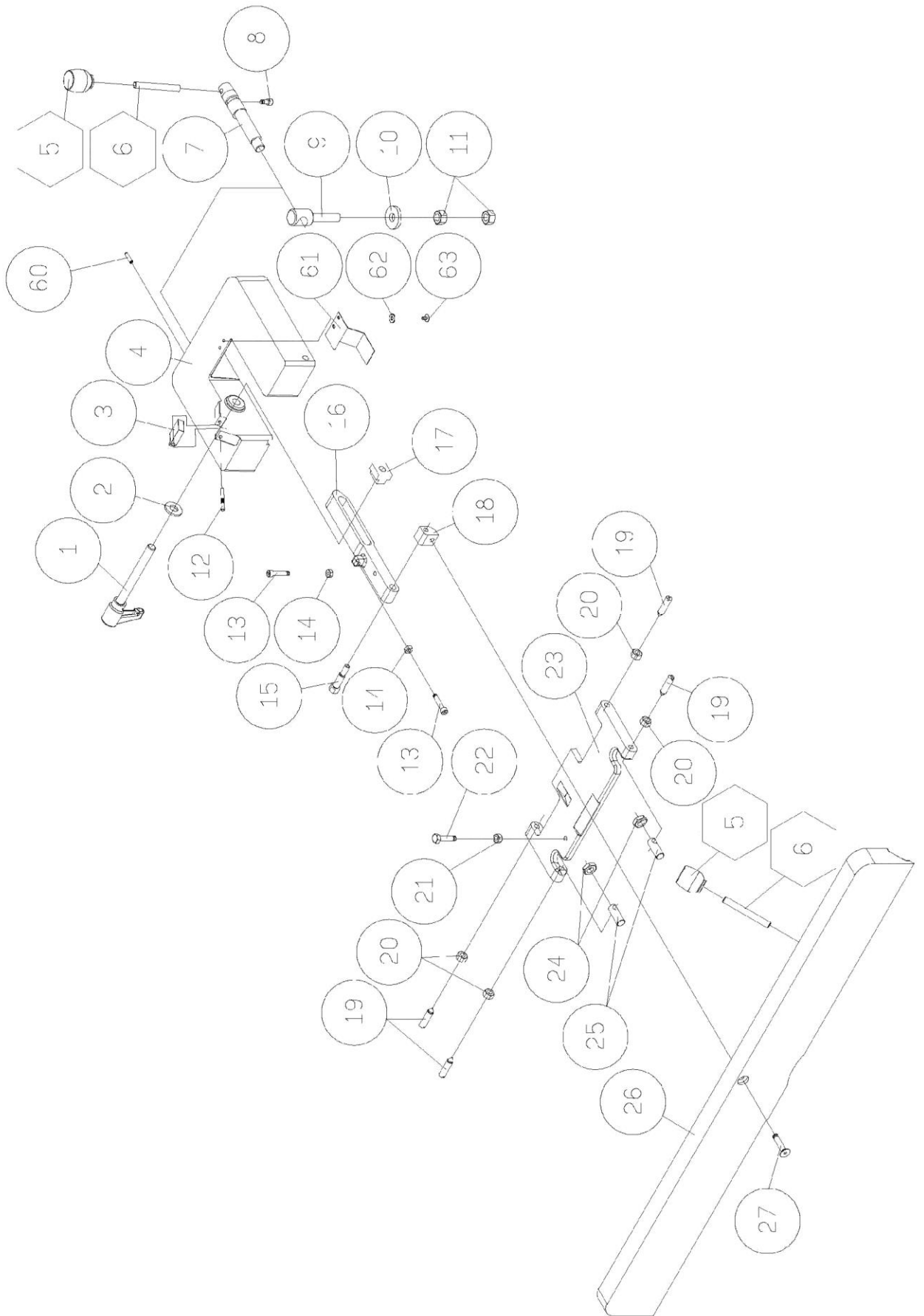


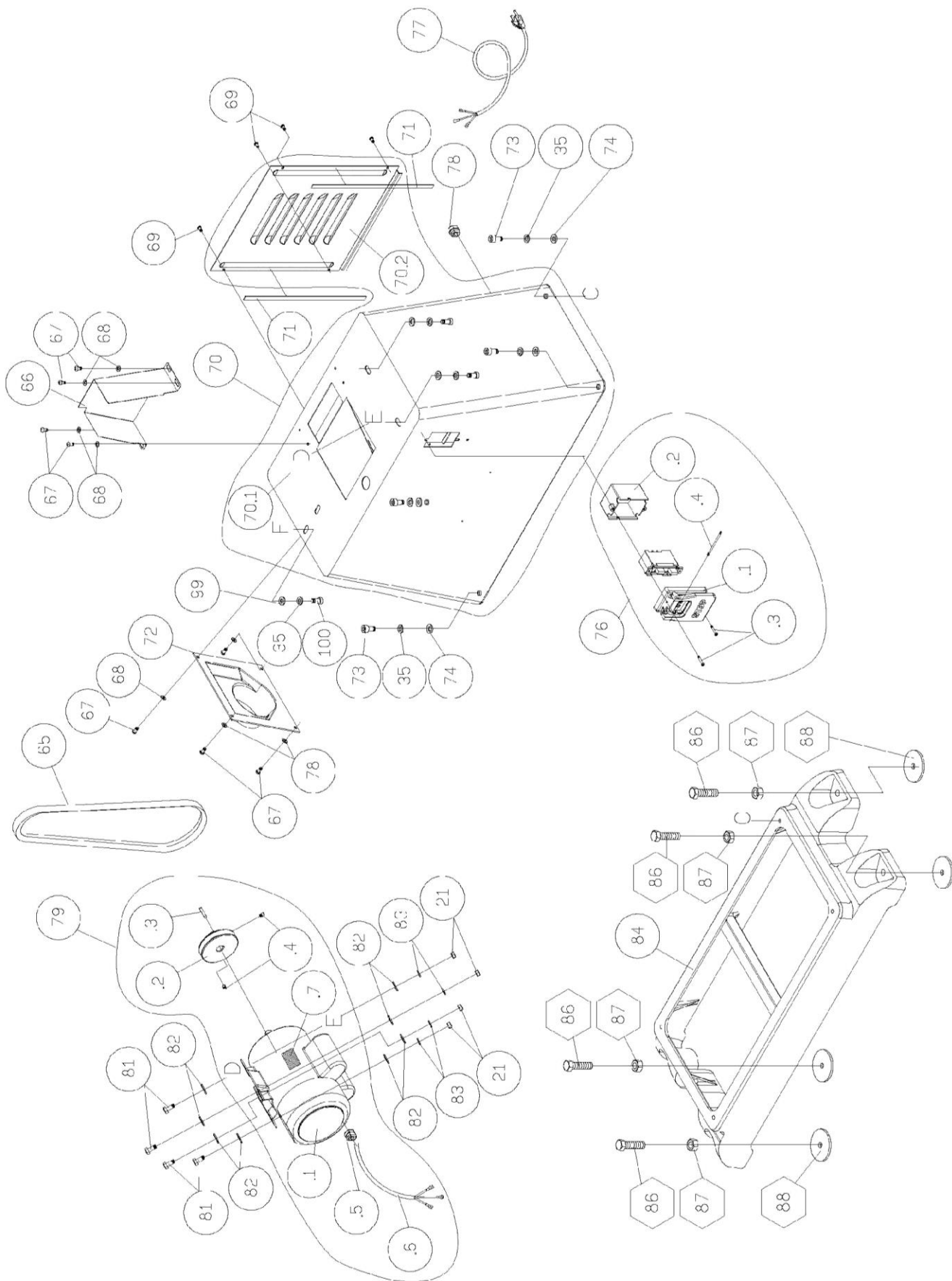
# Wiring Diagrams



# Parts Diagrams







## Parts List

Key	Part No.	Descriptions	Q'ty
1	230035-000	LOCK HANDLE	1
2	006001-091	FLAT WASHER	13*28*3.0t
3	130019-903	PLATE STOP	1
4	050093-000	CLAMP	1
5	250034-615	KNOB FENCE TILT	2
6	360038-901	HANDLE SHAFT	2
7	360074-901	CRANK	1
8	003103-102	CAP SCREW	1/4"-20NC*1/2"
9	360075-901	CLAMP SCREW	1
10	172285-905	FLAT WASHER	13*35*5.0t
11	009011-100	HEX. NUT	1/2"-12NC
12	360078-000	PIN	1
13	003103-104	CAP SCREW	1/4"-20NC*1-1/4"
14	009004-200	HEX. NUT	1/4"-20NC
15	290007-901	BOLT SHOULDER	10*6
16	050094-000	SHAFT LOCK	1
17	130018-903	SQUARE NUT	1
18	130008-903	NUT HANDLE	1
19	230015-901	STUD PIVOT	4
20	009022-100	HEX. NUT	3/8"-16NC
21	009005-200	HEX. NUT	5/16"-18NC
22	003003-206	HEX. SCREW	5/16"-18NC*1-1/4"
23	050092-000	TILT PLATE	1
24	009010-100	HEX. NUT	1/2"-20NF
25	360676-901	STUD PIVOT	2
26	050091-000	FENCE	1
27	003602-101	FLAT HD SOC. SCREW	5/16"-18NC*1-1/2"
28	003105-103	CAP SCREW	3/8"-16NC*1-1/2"
29	006001-073	FLAT WASHER	10.2*25*4.0t
30	380082-902	KEY	1
31	011002-104	SPRING PIN	4*14
32	051312-000	FENCE SLIDE BRACKET	1
33	922039-001	HELICALCUTTERHEAD ASSEMBLY	4-SLOT
	970303-001	KNIFE INSERT	10PCS/BOX
	038201-101	TORX SCREW	#10-32NF*1/2"
	040702-000	TORX SCREW DRIVER	CR-V T-25
33.2	050018-901	BEARING HOUSING	1
33.3	030206-002	BALL BEARING	6202
33.4	030207-002	BALL BEARING	6203
33.5	050019-901	BEARING HOUSING	1
33.6	050020-901	PULLEY	1
33.7	012003-009	KEY	5*5*25
33.8	003201-102	SET SCREW	1/4"-20NC*3/8"
34	172317-902	COVER	2
35	006307-100	LOCK WASHER	10.2*18.5



Key	Part No.	Descriptions		Q'ty
36	003006-302	HEX. SCREW	3/8"-24NF*119mm	2
37	230053-000	SCREW WING		2
38	920155-000	CUTTERHEAD GUARD ASS'Y		1
39	922909-000	TABLE ASS'Y		1
40	003202-104	SET SCREW	5/16"-18NC*1"	2
42	381094-901	FIXED PLATE		1
43	003104-104	CAP SCREW	5/16"-18NC*1"	2
44	360989-901	PLUNGER		1
45	381023-901	HOUSING PLUNGER		1
46	280010-000	SPRING		1
47	230156-615	KNOB PLUNGER		1
48	011001-106	SPRING PIN	3*20	1
49	230009-000	KNOB		2
50	170045-901	RETAINER		1
51	280009-000	SPRING		1
52	110024-000	KNOB		1
53	110004-000	RETAINING KNOB		1
54	003305-206	PAN HD SCREW	5/32"-32NC*5/8"	3
55	571984-000	POINTER		1
56	002301-201	RIVET	2*5	3
57	230014-000	TRIANGLE BOLT		2
58	003202-101	SET SCREW	5/16"-18NC*3/8"	2
59	920154-000	HANDWHEEL		2
60	011002-108	SPRING PIN	4*36	1
61	170127-901	PLATE		1
62	006001-032	FLAT WASHER	6.6*13*1.0t	2
63	003403-102	PAN HEAD SCREW	1/4"-20NC*1/2"	2
64	250035-629	PUSH BLOCK		2
65	014112-000	V-BELT	A38	1
66	170657-000	BELT GUARD		1
67	003301-201	PAN HD SCREW	1/4"-20NC*1/2"	8
68	006002-032	FLAT WASHER	6.6*13*1.0t	8
69	000303-103	PAN HD SCREW	M5*0.8P*10	1
70	923299-000	STAND ASS'Y		1
70.1	173161-000	STAND		1
70.2	170263-000	COVER		1
71	200005-615	PAD		2
72	250036-615	DUST CHUTE		1
73	000105-101	CAP SCREW	M10*1.5P*20	4
74	006001-069	FLAT WASHER	10*20*3.0t	4
76	937681-000	ON-OFF SWITCH		1
76.1	841007-001	ON-OFF SWITCH		1
76.2	250479-615	BOX SWITCH		1
76.3	000302-209	PAN HD SCREW	M4*0.7P*25	2
76.4	380332-905	PIN		1

Key	Part No.	Descriptions		Q'ty
77	453011-013	POWER CORD	SJT14AWG*3C*2400mm	1
78	020004-000	STRAIN RELIEF	SB8R-1	1
79	900808-000	MOTOR ASSEMBLY	1.5HP*110/220V*60HZ*1PH	1
79.1	603077-000	MOTOR	1.5HP*110/220V*60HZ*1PH	1
79.2	012003-010	KEY	5*5*30	1
79.3	050021-901	MOTOR PULLEY		1
79.4	003201-102	SET SCREW	1/4"-20NC*3/8"	2
79.5	473003-006	MOTOR CORD	SJT14AWG*3C*750mm	1
81	003003-203	HEX. SCREW	5/16"-18NC*3/4"	4
82	006002-056	FLAT WASHER	8.5*23*2.0t	8
83	006305-100	LOCK WASHER	8.2*15.4	4
84	051151-000	BASE		1
86	000006-105	HEX. SCREW	M16*2.0P*60	4
87	008011-100	HEX. NUT	M16*2.0P	4
88	172277-902	GASKET		4
90	040003-000	HEX. WRENCH	3mm	1
91	040005-000	HEX. WRENCH	5mm	1
92	040007-000	HEX. WRENCH	8mm	1
93	040201-000	OPEN WRENCH	8*10	1
94	040203-000	OPEN WRENCH	11*13	1
99	006001-068	FLAT WASHER	10*20*2.0t	3
100	003105-101	CAP SCREW	3/8"-16NC*3/4"	3