Jointer

4265C Series

Owner's Manual

For Models Manufactured Since 06/2024

C US
175370

Oliver Machinery
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Stock Number: 4265C.051T
4265C.053T
Manual Version: 3.0.0

READ AND UNDERSTAND ALL INSTRUCTIONS IN THIS MANUAL BEFORE ATTEMPTING TO ASSEMBLE OR OPERATE THE MACHINE.

FOLLOW THE INSTRUCTIONS AND THINK SAFETY!

THE OWNER OF THIS MACHINE IS SOLELY RESPONSIBLE FOR THE SAFETY OF ANYONE USING THIS MACHINE. SUCH RESPONSIBILITY INCLUDES BUT IS NOT LIMITED TO:

- **PROPER ASSEMBLY, OPERATION, INSPECTION, MAINTENANCE, AND RELOCATION OF THE MACHINE.**
- **PROPER TRAINING FOR THE OPERATORS AND ENSURES THIS MANUAL IS AVAILABLE AT ALL TIMES.**
- **USAGE AUTHORIZATION.**
- **USAGE OF SAFETY AND PROTECTION DEVICES.**

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.

**** SAVE THIS MANUAL FOR FUTURE REFERENCE. ****

PROP 65 NOTICE

WARNING: Drilling, sawing, sanding, or machining wood products can expose you to wood dust, and/or other chemicals that are known to the State of California to cause cancer, birth defects, or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Avoid inhaling wood dust and other harmful chemicals. Use a dust mask and/or other safety devices for personal protection.

For more information go to http://www.P65Warnings.ca.gov/wood

Table of Contents

Introduction

Thank you for choosing Oliver! This manual contains important information on how to safely set up, operate, and maintain this machine. Please take the time to read through this manual, and make sure you understand all the instructions.

While this manual may provide tips on optimizing the result of your workpiece, the manual is not intended as a substitute for formal woodworking training. If you need to know how to safely complete a woodworking task, please consult knowledgeable and qualified sources before proceeding further.

We made every effort to keep this manual up-to-date. Instructions, specifications, drawings, and photographs in this manual should match the machine delivered. If you find any differences or anything that seems confusing in this manual, or some instructions are not available, please check our website for an updated version:

WWW.OLIVERMACHINERY.NET/MANUALS

Alternatively, you can contact our technical support for help:

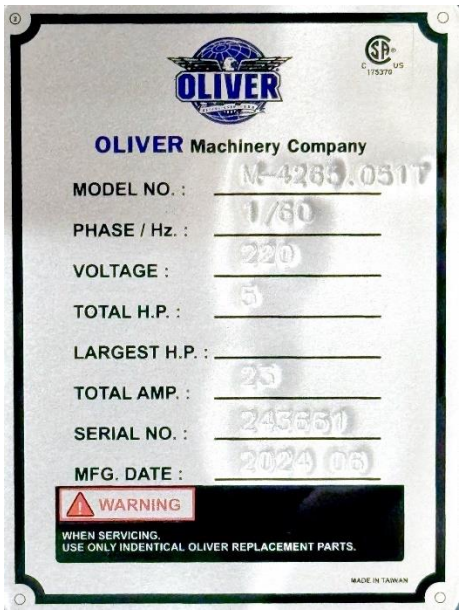
1-800-559-5065

Before calling, please note down the manufacture date and the serial number of the machine. You can find the information on a nameplate located on the back of the machine, right above the electrical junction box. This information is needed to provide proper technical support and to determine if an updated manual is available for your machine.

Please let us know how well this manual serves you. If you have any suggestions, please call the number above or email us at:

info@olivermachinery.net

We love to hear from our customers and make improvements.



Specifications

Quick View

Model	4265C.051T / 4265C.753T Jointer	
Stock Number	4265C.051T	4265C.053T
Motor	TEFC Induction Motor 5HP, 230V, 1Ph	TEFC Induction Motor 5HP, 230V, 3Ph
Jointer Size	12”	
Max. Depth of Cut (Jointing)	1/8"	
Max. Depth of Cut (Rabbeting)	3/4”	
Bevel Joining	45° -135°	
Dimensions	88-1/4”(L) x 39-1/2”(W) x 50”(H)	
Footprint	52-1/2”(L) x 20-1/2”(W)	
Fully Assembled Weight	814 lbs.	
Warranty	1 Year (Motor and electronics) 2 Years (All other parts)	

Product Dimensions

Jointer Fully Assembled	88-1/4”(L) x 39-1/2”(W) x 50”(H)
Footprint	52-1/2” (L) x 20-1/2”(W)
Fully Assembled Weight	814 lbs.

Shipment Info

Type	Wood crate with pallet base
Content	Jointer with included accessories
Dimensions	91” (L) x 32”(W) x 50”(H)
Weight	980 lbs.
Approximate Setup Time	60 minutes
Must Ship Upright	YES
Stackable	NO

Electricals

Stock Number	4265C.051T	4265C.053T
Power Requirement	230V, 1Ph, 60Hz	230V, 3Ph, 60Hz
Full Load Current Rating	23A	13.5A
Recommended circuit size	30A	20A
Power Switch Type	Magnetic switch with overload protection.	
Connection Type	Cord and plug not included. Electrical hookup is required.	
Overload Protection	Equipped	

Motor

Stock Number	4265C.051T	4265C.053T
Motor Type	TEFC Induction Motor	
Horsepower	5HP	5HP
Speed	3450 RPM	3450 RPM
Efficiency	78.1%	78.4%
Power Factor	0.9	0.904
Power Transfer Mechanism	Poly V-belt and pulleys	
Bearing type	Permanently sealed ball bearing	

Jointer Capacity and Performance

Maximum Stock Width	12”
Maximum Depth of Cut for Jointing	1/8"
Maximum Depth of Cut for Rabbeting	3/4”
Minimum Width of Cut for Rabbeting	3/8”
Minimum Stock Thickness	1/2”
Minimum Stock Length	12”

Fence

Dimensions	47-3/16” (L) x 6”(H)
Fence Travel	11-15/16”
Fence Stops	45°, 90°, and 135°
Material	Precision ground cast iron

Cutterhead

Cutterhead Type	Helical
Cutterhead Diameter	3-55/64”
Cutterhead Speed	5500 RPM
Number of Cutter Inserts	66
Number of Rows of Cutter Inserts	6
Cutter Insert Type	Four-sided, indexable carbide
Cutter Insert Diameters	15mm x 15mm x 2.5mm
Cutter Blade Angle	30 degree
Cutter Insert Screw Tensioning Torque	52-60 lb-in

Table

Table Dimensions	88-1/4”(L) x 12”(W)
Table Height Above Ground	34-1/4”
Table Lifting / Adjustment Mechanism	Parallelogram
Material	Precision ground cast iron

Measurements

Measurement Unit	Inch/mm
Measurement Device	Wixey digital readout
Digital Readout Resolution	1/32” / 0.005” / 0.1mm
Digital Readout Accuracy	±1/500” / 0.002” / 0.05mm
Backup Measurement Device	Cutting depth scale with a pointer.

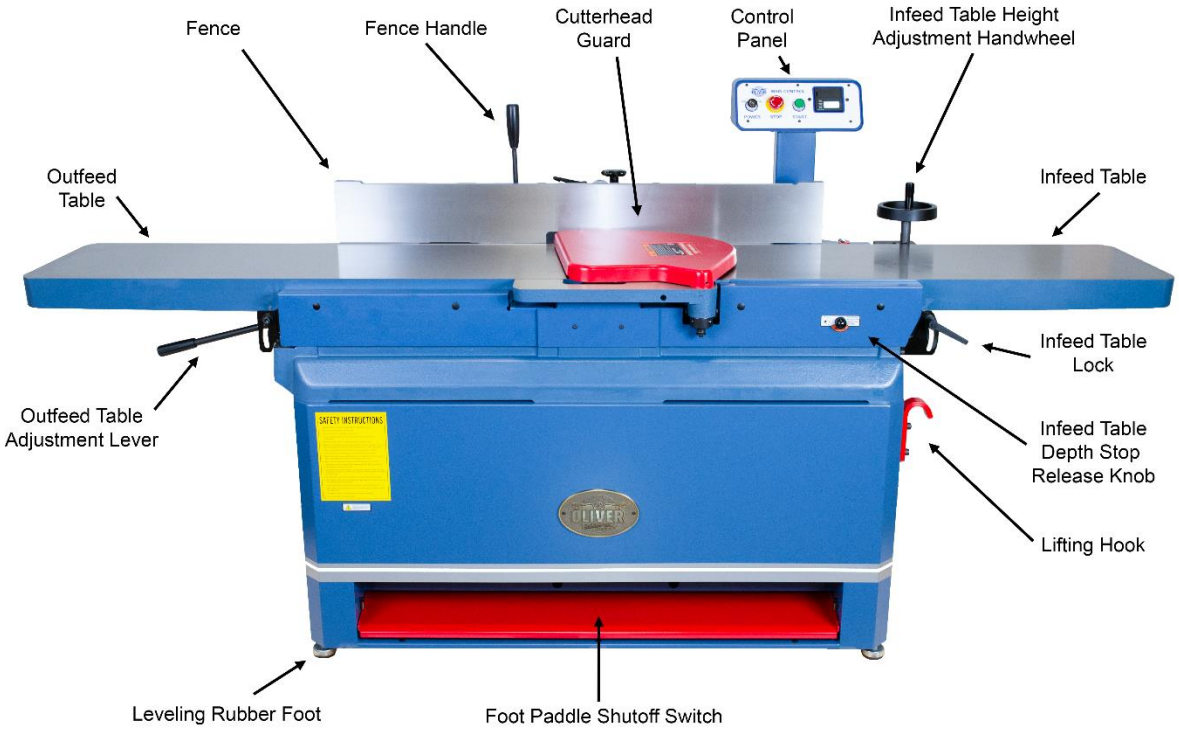
Safety

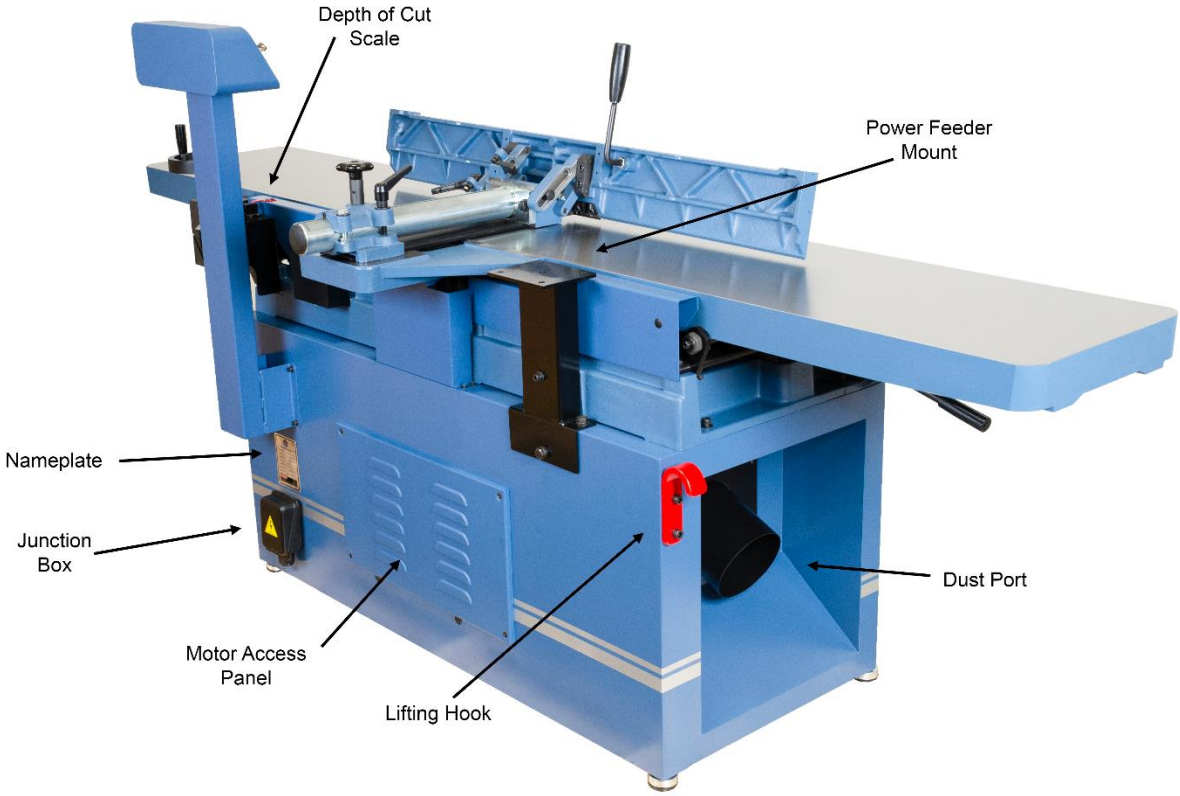
Stock Number	4265C.051T	4265C.053T
Number of Dust Ports	1	
Dust Port Size	6”	
Minimum CFM Required	700 CFM	
Sound Rating @ 2’ distance	90-95 dB	92-96 dB

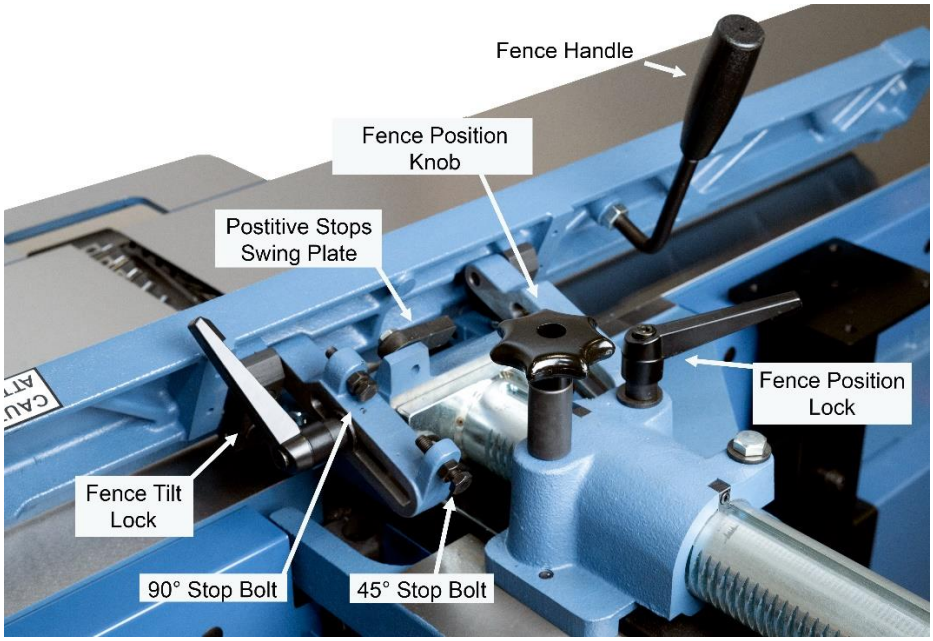
Others

Serial Number Location	On the back of the machine.
Spare Parts Included	Ten cutter inserts and compatible Torx screws.
Certification	CSA 175370
Country of Origin	Taiwan

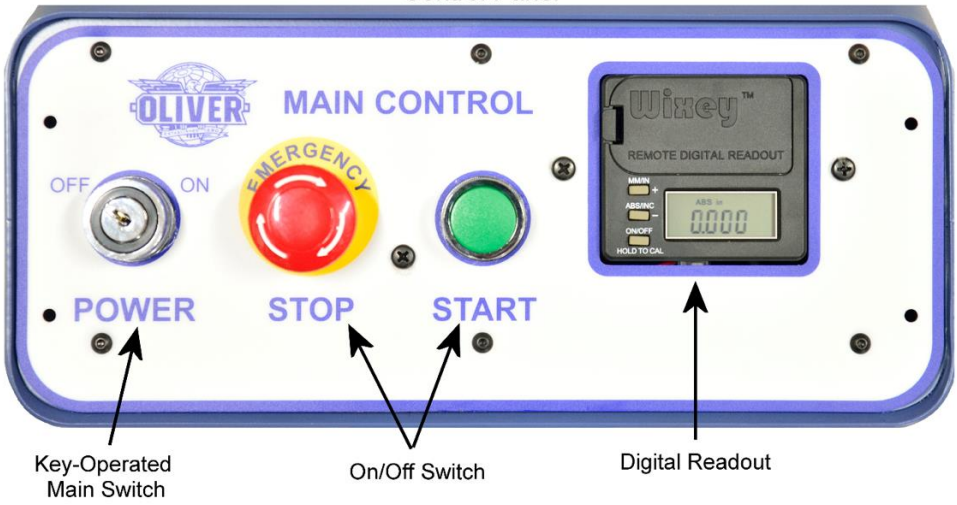
Identification







Control Panel



Safety

Oliver Machinery has made every attempt to provide a safe, reliable, easy-to-use piece of machinery. Safety, however, is ultimately depending on the individual machine operator. **Before operating this machine, please become familiar with the following safety labels and guidelines.**

DANGER	This indicates an imminently hazardous situation which, if not avoided, **WILL** cause death or serious injury.
WARNING	This means if the warning is not taken seriously, it **CAN** cause death or serious injury.
CAUTION	This means if the precaution is not taken, it **MAY** cause minor or moderate injury.
IMPORTANT	This is a tip for properly operating the machine to avoid machine damage.

General Safety Guidelines

1. **FAMILIARIZE** yourself with all safety instructions found in this manual. Know the limitations and hazards associated with this machine. Do not operate/service this machine until you are properly trained.

2. **ELECTRICAL GROUNDING**, when done properly, reduces the risk of electrocution, shocks, and fire. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and a plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the electrical code of your area.

3. **DISCONNECT** the machine from power before performing any service, maintenance, or adjustments. A machine under repair should be RED TAGGED to show it should not be used until the repair is complete.

4. **EYE PROTECTION**: Always wear an approved safety face shield, goggles, or glasses that comply with ANSI Z87.1 and CSA Z94.3 standards. Common eyeglasses are not safety glasses, and may not provide adequate protection.

5. **EAR PROTECTION**: Use hearing protective devices where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations. When in doubt, use it.

6. **OTHER PERSONAL PROTECTION**: Before the operation, remove tie, rings, watch, and other jewelry. Roll up sleeves above elbows. Remove all loose outer clothing and confine long hair. Protective footwear should be used. Do not wear gloves when operating woodworking machinery. However, it is recommended to wear protective gloves when servicing machines.

7. **GUARDS**: Keep machine guards in place for all applicable operations. If any guards are removed for maintenance, DO NOT OPERATE the machine until all guards are reinstalled. Check clearance between the guards and the cutter before starting the machine.

8. **WORKPLACE SAFETY**: Keep the floor around the machine clean. Scrap material, sawdust, oil, and other liquids increase the risk of tripping or slipping. Be sure to clean up the table before starting the machine. Make certain the work area is well-lighted and that a proper exhaust system is used to

minimize dust. Use anti-skid floor strips on the floor area where the operator normally stands and mark off the machine work area. Provide adequate workspace around the machine.

9. **ACCESS CONTROL** should be enforced so only trained personnel can access the work area and operate the machine. When possible, lock the machine when it is not in use.

10. **STAY ALERT** at all times. Do not operate this machine while under the influence of drugs/alcohol, or when not feeling well.

11. **NEVER STAND ON MACHINE.** This prevents injuries from tipping-related accidents and accidental contact with cutters.

12. **REPLACEMENT PARTS:** Use only genuine Oliver Machinery replacement parts and accessories recommended for this machine. Generic parts made by other manufacturers may create a safety hazard and WILL void the factory warranty and other guarantees.

13. **PROPER USE:** Do not use this machine for anything other than its intended use. If used for other purposes, Oliver Machinery disclaims any real or implied warranty and holds itself harmless for any injury or damage that may result from that use.

Safety Guidelines Specific to Jointer

Before Work Begins:

1. **USE ONLY NATURAL, SOLID WOOD.** Do not joint any material such as plywood, MDF, OSB, laminate, or anything that can disintegrate during operation. Do not joint treated lumber or anything that contains harmful chemicals, as this will spread wood dust that contains such harmful chemicals. Do not attempt to joint any workpiece with loose knots or with any other foreign materials.

2. **CHECK CUTTER INSERTS:** Make sure cutter inserts are sharp, clean, and free from damage. Forcing dull/damaged cutter inserts to work invites accidents and impacts finish quality. Use the recommended amount of torque to securely fasten all inserts onto the cutterhead.

3. **SERVICING CUTTER INSERTS:** Wear heavy-duty leather gloves to protect your hands when installing new cutter inserts or rotating the existing ones. Ensure the cutterhead is thoroughly cleaned before installing the insert. Debris between the cutter insert and the platform can create uneven pressure, causing the insert to break, and body injuries may occur.

4. **CHECK CUTTERHEAD GUARD:** Make sure the cutterhead guard is installed and properly tensioned. The cutterhead guard should spring back and push against the fence after it is rotated away and released.

5. **CHECK OUTFEED TABLE HEIGHT AND ALIGNMENT** to avoid a workpiece getting stuck while feeding. Make sure the outfeed table is locked.

6. **CHECK DEPTH OF CUT SETTING.** The maximum depth of cut for each pass is 1/8”.

7. **LOCK** the fence at all times except when setting the fence position and tilt angle.

8. **SUPPORT LONG WORKPIECE** with auxiliary stock feeding rollers/tables. This reduces the risk of injuries and improves the quality of the finish.

When Jointing:

1. **DUST COLLECTION SYSTEM** is required for this jointer. Please make sure the system is on and provide enough suction before starting the jointer.

2. **KICKBACK** happens when a workpiece is ejected at high speed during operation. This can cause serious injuries or even death. Sudden movements of the workpiece from kickback can also cause hands or other body parts to get pulled into the cutterhead. When feeding a workpiece, the operator must not push from the rear of the workpiece.

3. **PROPER STOCK FEEDING** reduces the chance of kickback. NEVER start the machine with anything engaging the cutterhead. NEVER start feeding until the jointer has reached its full speed. Use the right amount of downward pressure and forward force for feeding.

4. **INSPECT WORKPIECE.** Ensure the workpiece is free from nails, loose knots, and other foreign material. Use a metal detector to scan for metal objects as appropriate.

5. **NEVER** joint material shorter than 12”, thinner than 1/2”, or narrower than 2”. This reduces the risk of accidental contact with the cutterhead and kickback.

6. **NEVER** perform a rabbet cut with material width or thickness less than 3/4”, or shorter than 12”.

7. **FOLLOW THE 3-INCH RULE.** Always use push blocks when jointing materials less than 3” in thickness or width. Keep your hands at least three inches away from the cutterhead at all times when the machine is running.

8. **CUPPED WORKPIECE** should be jointed with the cupped side facing down. This prevents the workpiece from rocking when feeding through the jointer.

9. **PAY ATTENTION TO THE GRAIN DIRECTION.** Always cut WITH the grain whenever possible. Jointing against or across the grain, or jointing the end grain increases the chance of tear-out and kickback.

After Operation

1. **STOP THE MACHINE** if the operator leaves the machine for any reason.
2. **WAIT** until the machine comes to a complete stop.
3. **LOCK** the power switch.
4. **CLEAN UP** before departure.

Electricals

WARNING

Faulty electrical work can cause electrocution and is a fire hazard. Make sure the voltage of your power circuit matches the power requirement of this machine, and that the circuit is sized to supply power to the jointer.

All electrical work must be completed by a licensed electrician and must meet the local electrical code in your area. Otherwise, the warranty is void.

Minimum Circuit Size Required for Model 4265C.051T / 4265C.753T Jointer

Stock Number	**Minimum Circuit Size Required**
4265C.051T	30A
4265C.053T	20A

Please ensure the electrical circuit for this machine meets the minimum circuit size requirement. The minimum circuit size requirement applies to a dedicated circuit that provides power to one 4265C.051T / 4265C.753T Jointer. If more machines are sharing the same circuit, consult a licensed electrician to ensure the designated circuit is properly sized for safe operation.

If a circuit is available, but not meeting the minimum circuit size requirement listed above, a new circuit must be installed for this machine.

Grounding

WARNING **Improper grounding can cause electric shock, fire, and equipment damage.**

Proper grounding reduces the risk to the operator in the event of electrical malfunction or breakdown. This machine must be connected to the grounding conductor when available, and all grounding connections must meet or exceed the electrical code requirements in your area. Furthermore, all grounds must be verified and must meet or exceed the electrical requirement of the machine.

Electrical Wiring

This machine is not pre-wired with a cord and a plug. If you plan to connect the machine directly to the electrical panel ("Hardwiring"). Please ensure there is a readily accessible electrical disconnect near the machine. Refer to the section "Wiring Diagram" for wiring your machine to a power source.

If you choose to connect this machine with a plug and a cord, please use a UL/CSA listed plug. If you need an extension cord to connect to the power outlet, select a durable cord type with a high-temperature rating (90C° or above). Both plug and power cord must be sized to meet the amperage requirement of your machine.

Minimum cord size (AWG) required based on amperage draw and length of the cord:

Amps	**Power Cord Length**				
	25 feet	50 feet	75 feet	100 feet	> 100 feet
< 5	16	14	14	14	NR
5 to 8	14	14	14	12	
8 to 12	14	14	12	10	
12 to 15	12	12	10	10	
15 to 20	10	10	10	NR	
21 to 30	10	NR	NR	NR	

*NR: Not Recommended

WARNING **Use properly sized wires that meet or exceed the power requirement of your machine. Using undersized wires may cause overheating and increase the risk of fire and machine damage.**

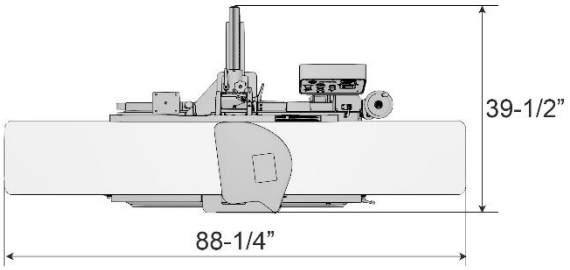
WARNING **Improper copper-aluminum wire connection is a fire hazard. If the power circuit available uses aluminum wires, use certified CU/AL wire connectors.**

Setup

Shop Preparation

Space Requirement

The dimensions of this machine are 88-1/4”(L) x 39-1/2”(W). You will need additional spaces for manipulating your workpiece, electrical connection, and dust collection.



Load Limits

This machine has a shipping weight of 980 lbs., and a net weight of 814 lbs. Please ensure all lifting tools and building structures have adequate load capacity, for transporting and supporting the total weight of this machine, the operator, and related items.

Electricals

Ensure a properly sized circuit and an electrical terminal are available near the machine. If the machine is to be hardwired, there must be a readily accessible power disconnect nearby, so that the machine can be disconnected from the power source for servicing and adjustments. If the machine is to be connected with a cord and a plug, please ensure a matching outlet is installed near the machine.

Please refer to the previous chapter “Electricals” on page 15 for details regarding electrical requirements.

Lighting

Adequate lighting is needed for operating this machine. Overhead, non-glare lighting should be installed.

Safety Labels

If this machine introduces a new safety hazard to your workplace, display proper warning signs in a highly visible location(s).

Dust Collection

Wood dust created by this jointer is a health hazard. Connect a dust collection system to this machine. Check air suction regularly to ensure the pipes are not clogged.

Dust masks should be available for using the jointer.

⚠ **CAUTION**	**Use a dust collection system that is rated above 700 CFM. Doing so improves air quality in the workplace, and prevents the machine from jamming.** **Piping of the dust collection system introduces additional air resistance and decreases the effective CFM measured at the dust ports. Ensure there is significant suction at the dust port, so dust and debris can be effectively removed from the machine.**

Receiving

Your shipment should come with one wood crate. Upon receiving your shipment, check for any significant damages before signing the delivery confirmation.

IMPORTANT	If items are damaged, please call us immediately at **1-800-559-5065**

Moving the Machine into the Shop

Your machine will be delivered by freight service, and it will be left outside of your workshop by default. On the day of delivery, please be sure help is available to move the machine to its final location.

⚠ **WARNING**	**4265C.051T / 4265C.753T Jointer has a gross weight of 980 lbs. and a net weight of 814 lbs.** **Safe moving techniques and proper lifting equipment are required, or serious personal injury may occur.**

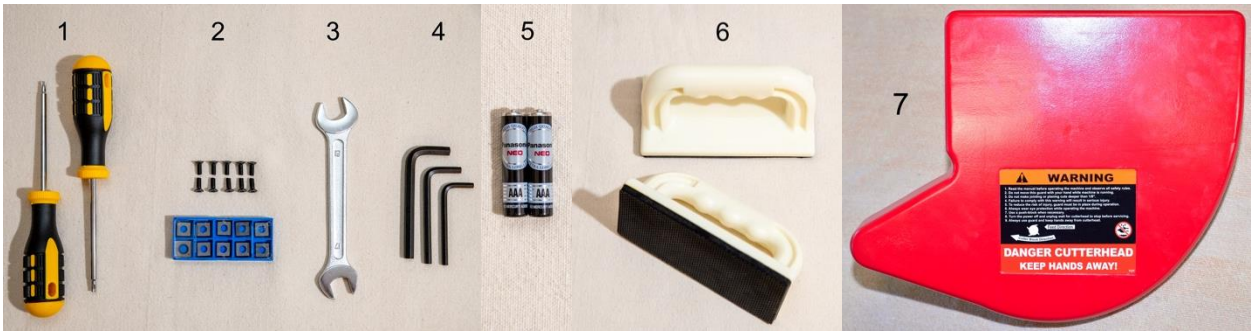
⚠ **WARNING**	**Your shipment may be secured by the straps. Do not lift your shipment by the strap. They are not designed to hold the total weight of your shipment. They may snap without warning and cause serious injury and machine damage.** **Always wear safety goggles and gloves when removing straps, as they may spring back violently when released and cause injury.**

Unboxing

The crate contains a jointer that is mostly assembled. It also contains two paper boxes with loose parts and accessories. Everything is packed inside a large plastic bag.

Inventory

Carefully unwrap the packaging and inventory the items received:



Item	*Description*	*Quantity*
1	T-25 Torx Screwdrivers	2
2	Spare Cutter Inserts and Torx Screws	10 each
3	17/19 mm Combination Wrench	1
4	Metric hex wrench set (5,6,8 mm)	1 each
5	AAA Batteries	2
6	Push blocks	2
7	Cutterhead guard	1

NOTICE: If you cannot find an item in the list above, please check if it is still attached to the packaging or inside the cabinet. Occasionally the item may have been pre-installed in the factory. See "**Parts List**" on page 55 to check if a component is included or installed.

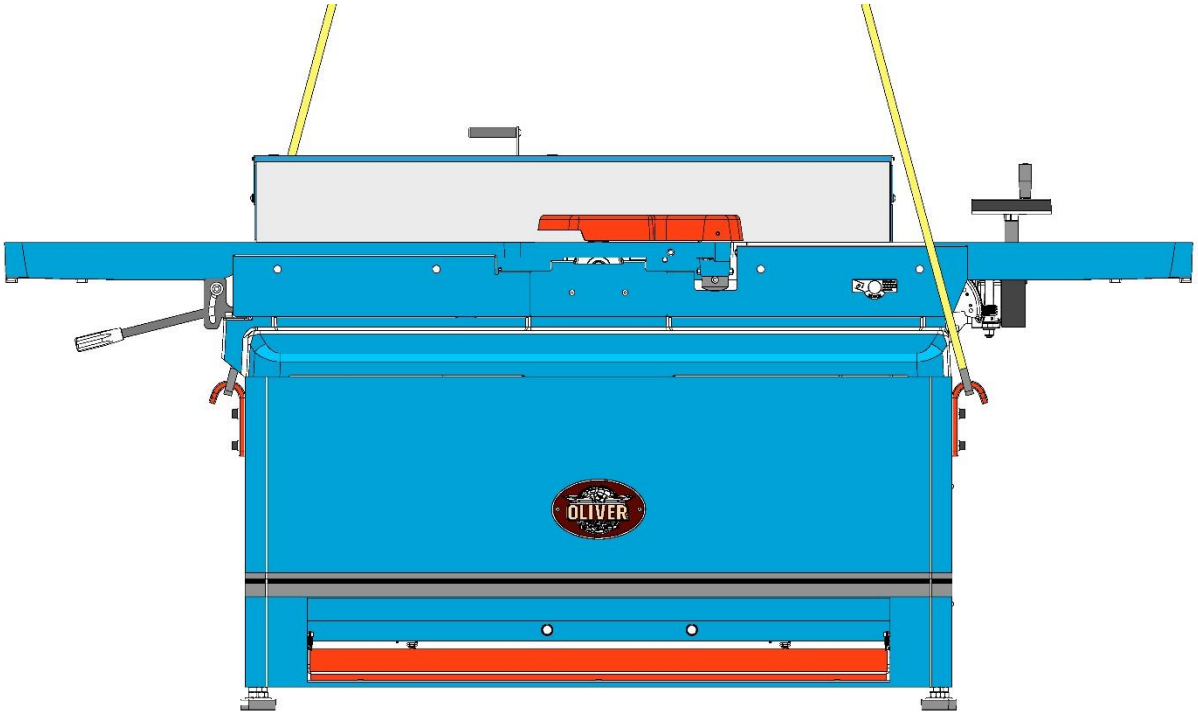
NOTICE: This machine comes with various standard-sized, non-proprietary parts. If any of these parts are missing, we are happy to deliver them to you. To have the machine up and running as soon as possible, you can also find these parts at your local hardware store.

Additional Items Recommended for Machine Setup

Item	**Purpose**
Safety Glasses	Protection
Disposable Gloves	Protection
Paper Towel / Rags	Cleaning
Rust Inhibitor	Cast iron rust protection.
Straight edge	Check alignments.
Metric Combination Wrench Set	Assembly and Maintenance
Metric Hex Wrench Set	Assembly and Maintenance
Torque Wrench	Cutter inserts installation and for checking Torx screw tension (52-60 lb-in).
T25 Star Bit Socket	Cutter insert installation.
Ring Terminal Connector and Crimping Tool	Connecting machine to power. ***IMPORTANT: Always follow local electrical code for electrical work.***

Removing Machine from Crate

When all items are ready for machine setup, attach the lifting sling to the lifting hooks located at the two corners of the cabinet. Gently lift the machine from the pallet and move it to its final location.



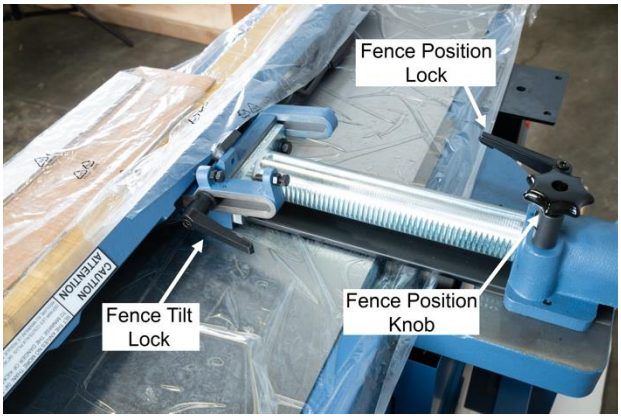
⚠ **WARNING**	**4265C.051T / 4265C.753T Jointer has a net weight of 814 lbs. All lifting devices must be capable of handling the load, or serious personal injury and machine damage may occur.**

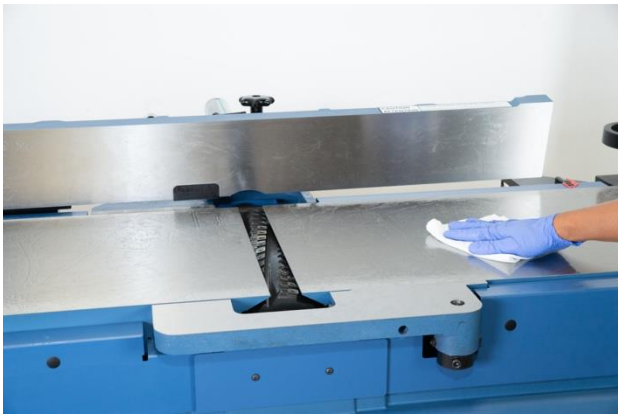
IMPORTANT	**Use the lifting hooks for lifting the jointer. Do not lift the machine by the tables as it may alter the alignment of the tables.**

Cleaning

To prevent rusting, the unpainted cast iron parts of this jointer are covered with machine oil and plastic film.

Loosen the fence tilt lock. Raise the fence above the table, then lock the fence in place. Release the fence position lock, and use the fence position knob to move the fence backward and expose the entire jointer table. Remove the packaging materials and wipe off machine oil with paper towels or rags.





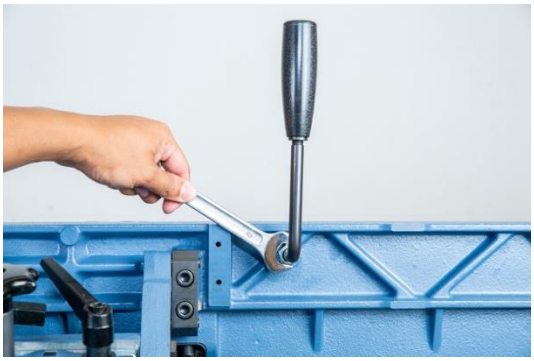
After the initial cleaning, routinely coat the unpainted cast iron surface with rust preventive such as Boeshield® T-9 or paste wax. Do not use rust preventives that contain silicone, which is known to interfere with certain finishes and glues.

Assembly

This jointer is mostly assembled in the factory. There are a few more steps to complete before the machine is ready for a test run. The approximate time for cleaning and assembly is approximately 60 minutes.

Setup Fence Handle

The fence handle makes it easier to lift and adjust the tilt of the fence. Raise the fence handle to an easily reachable position. Then tighten the jam nut on the handle to lock it in place.

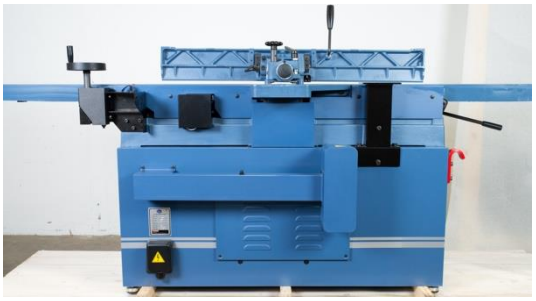


Inspect / Adjust Jointer Tables

The jointer tables are calibrated in the factory and should not require adjustments initially. See “Inspect / Adjust Jointer Tables” on page 40 to perform these steps if needed.

Setup Control Panel

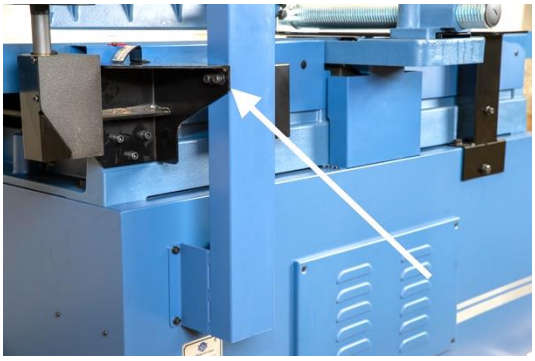
1. To prevent damage, the control panel is lowered when it is shipped from the factory. The control panel assembly is heavy, please have two people remount the control panel assembly.



2. Remove all six cap screws from the control panel post.

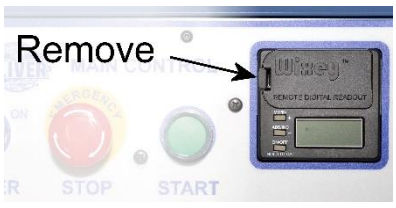
3. Rotate the control panel pedestal to the upright position, then remount it back to the cabinet.

4. Attach the last two cap screws through the table adjustment handwheel bracket.



Install Batteries for Digital Readout

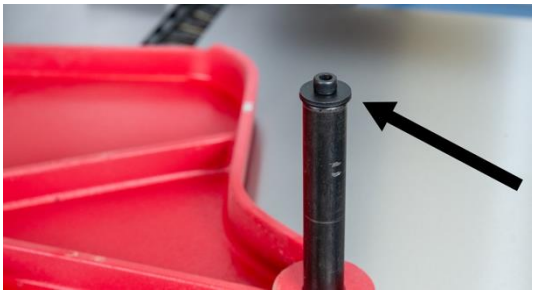
Locate the digital readout on the control panel. Remove the battery cover and install two AAA-sized batteries.



Install Cutterhead Guard

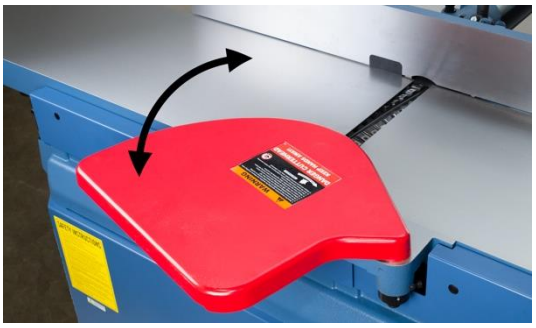
1. Loosen the fence tilt lock and raise the fence above the table. Lock the fence in place. Release the fence position lock, and move the fence to the back.

2. Remove the safety screw and washer from the cutterhead guard's shaft.



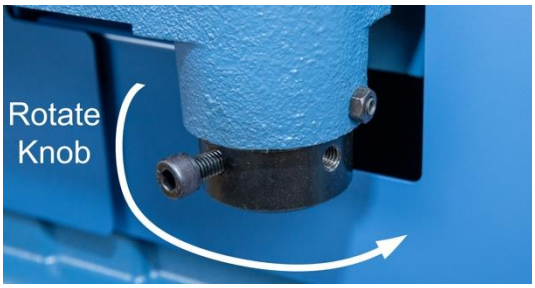
3. Insert the cutterhead guard shaft into the hole on the rabbeting table.

4. The guard must be installed as low as possible, but not scratching the table.



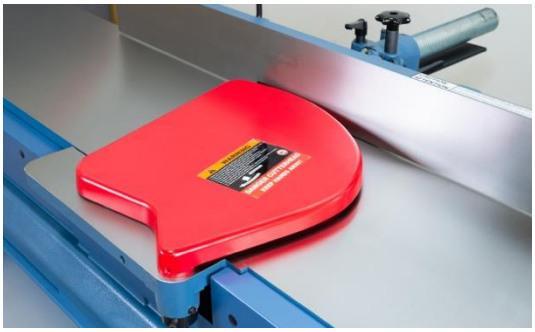
5. There is a spring-loaded knob at the bottom of the rabbeting table. It has a socket head cap screw to secure the cutterhead guard shaft and keeps the guard pushing against the fence.

   Rotate the knob counterclockwise until you can feel the tension from the spring, then rotate it for another 1/2 to 1 turn. Hold the knob in position and tighten the socket head cap screw.



   TIP: Use any of the four holes on the knob to install the socket head cap screw.

6. Positioned the fence at the rear edge of the jointer table. Ensure the guard is pressing against the fence, and it can spring back to its original position after it is rotated away.



7. Reinstall the cutterhead guard safety washer and screw.

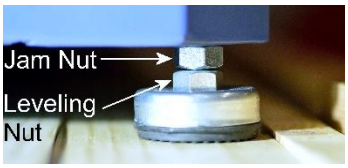
⚠ WARNING ⚠

Always operate this jointer with a cutterhead guard, except for some rabbeting operations. Serious personal injury may occur when operating a jointer without a cutterhead guard.

Leveling Machine

Position this jointer on a level, stable floor. If the machine is rocking on the floor, or if it vibrates excessively during operation, adjust the rubber feet to level the machine:

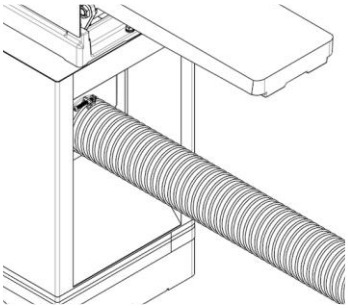
1. Loosen the jam nut to unlock the leveling foot.
2. Rotating the leveling foot to adjust its height.
3. Make adjustments on all other leveling feet until the machine is completely leveled.
4. Tighten the jam nuts of all adjusted leveling feet.



Dust Collection

This jointer can generate a lot of wood shavings and dust. Connect a dust collection system to this machine.

The minimum CFM requirement for this jointer is 700 CFM at the dust port, which means your dust collection system should have a rating greater than 700 CFM, as air friction and leakage reduce effective CFM at the dust port.



IMPORTANT

Running this jointer without a dust collection system, or using a dust collection system with inadequate suction, will cause dust and shavings to accumulate inside the jointer. This can damage the machine and cause other hazardous situations. Check your dust collection system regularly to make sure it is not clogged or filled up.

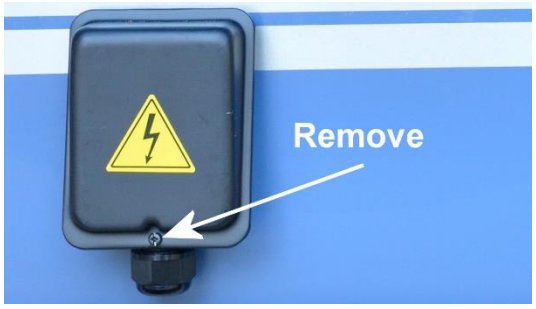
Wiring and Grounding

DANGER **Deenergize the electrical circuit before touching any enclosed, electrified parts. Touching an electrified part WILL result in serious personal injury or death.**

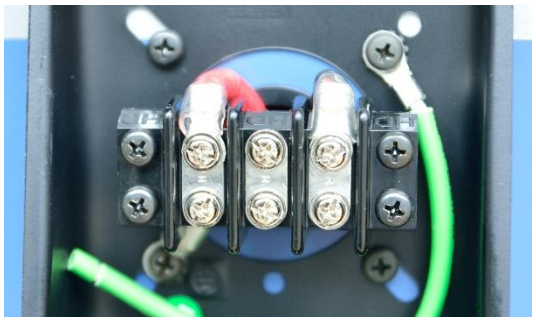
WARNING **This jointer is a heavy-duty, industrial-grade machine. The electrical work must be completed by a licensed electrician and meet the local electrical code requirements. Failure to comply can create lethal electrical and fire hazards and void this machine's warranty.**

Wiring Instructions

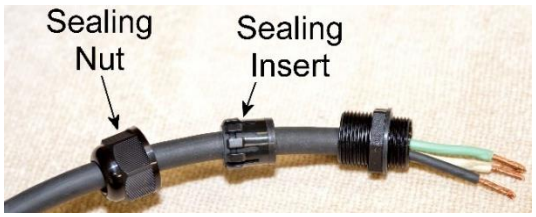
1. **Power off before connecting any wires!!**
2. Remove the screw that secures the junction box cover.



3. The wire connector inside the junction box accepts hot conductors with ring/spade terminals. The ground conductor can be connected with a wire nut.



4. Insert the power cord through the strain relief. The strain relief can be temporarily removed from the junction box to make this task easier.



5. The picture below shows an example of how a single-phase 230V model can be connected to a power source with the ring terminals and a wire nut.

   Please refer to the section “Wiring Diagram” for connecting a specific model to a power source.

   IMPORTANT: Always refer to the local electrical code for properly connecting any machinery to a power source.

6. Hand tighten the sealing nut of the strain relief to keep the cord in place.
7. Re-install the junction box cover.

Controls and Components

Control Panel

Key-Operated Main Switch
This switch enables access control to the jointer. To restrict access, lock the switch at the "OFF" position, and keep the key in a safe place.

Emergency Stop Button with Reset
This stop button is equipped with an emergency shutoff feature. When it is pressed, the machine will stop, and the stop button will need to be reset before the machine can start again. To reset, rotate the mushroom button clockwise until it pops up.

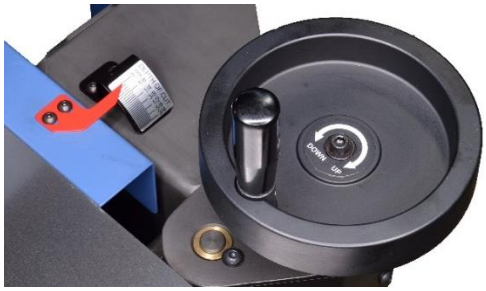
Foot Paddle Shutoff Switch
The foot paddle shutoff switch is a safety enhancement feature that allows the operator to stop the jointer while keeping both hands on the workpiece.


Foot Paddle Shutoff Switch

Start Button
When the main switch is unlocked and the emergency stop button is reset, press START will start the machine.

Depth of Cut Adjustment

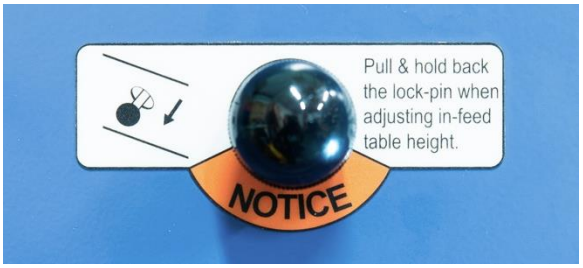
The depth of cut is set by changing the infeed table's height, and the depth of cut value is shown on the depth of cut gauge and DRO. The infeed table height adjustment handwheel is located below the control panel:



- Turn **CLOCKWISE** to reduce depth of cut.
- Turn **COUNTERCLOCKWISE** to increase depth of cut.
- The handle of the handwheel can be folded down as needed.

Infeed Table Depth Stop Release Knob

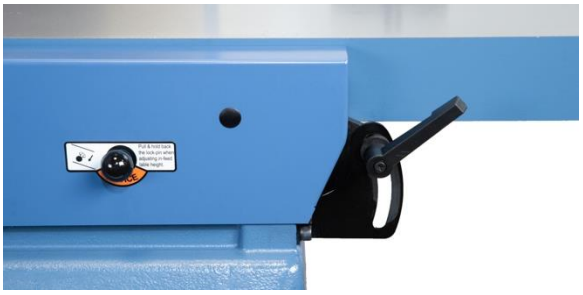
As a safety feature, this machine comes with a positive depth stop to prevent the depth of cut goes beyond 1/8” for jointing operations. To get more than 1/8” depth of cut for rabbeting operations, pull and hold the knob when lowering the infeed table past the 1/8” mark on the depth of cut scale.



Infeed Table Lock

Use the infeed table lock to provide additional support to the infeed table for jointing heavy workpieces.

IMPORTANT: Make sure to release this lock before changing the infeed table height.

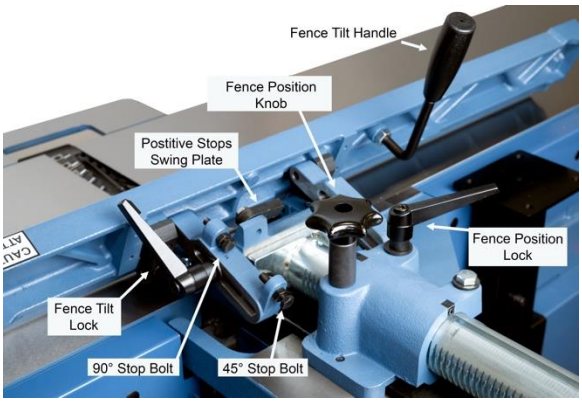


Outfeed Table Height Adjustment

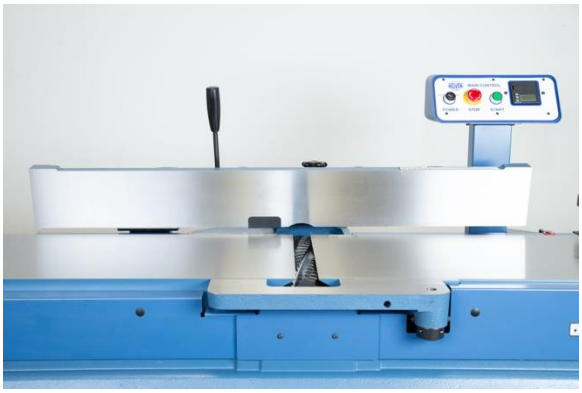
The outfeed table height adjustment lever is located below the outfeed table. The outfeed table height is locked by a socket head cap screw and the table must be locked while the machine is in operation.

Fence

This precision ground cast iron fence has three adjustable positive stops at 45°, 90°, and 135°.



The fence can be retracted and raised above the table to provide additional clearance for servicing the cutterhead.



Digital Readout (DRO)

This jointer is equipped with a Wixey DRO with 0.005”/0.1mm resolution.

On/Off Button
To turn on/off this DRO. It is also for calibration in ABS (absolute) mode.

MM/IN Button
Toggles between measurement units inch and mm. When displaying in inches and the reading is a multiple of 1/32”, the fractional value will show on the screen.

ABS/INC Button
Toggles between **Absolute** and **Incremental** mode.

The absolute mode shows the total depth of cut. Once calibrated, the setting will be memorized unless the battery is exhausted, OR if a user recalibrates the DRO.

The incremental mode shows the distance the infeed table traveled since the last reset. The readings can be reset by leaving the incremental mode.

DRO Calibration

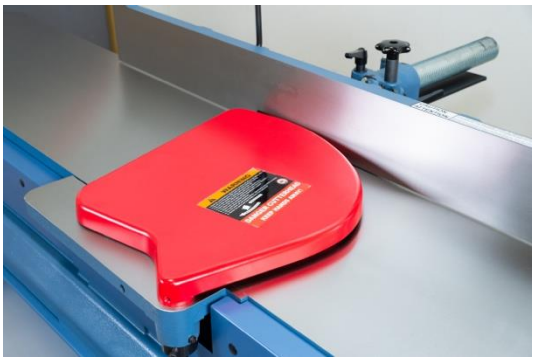
1. **Disconnect the jointer from the power source!!**
2. Set the infeed table depth of cut to zero. It may be helpful to check the setting with a scrap piece.
3. Turn on the DRO and switch to ABS mode.
4. Hold the ON/OFF button for 3-5 seconds until “ABS” is blinking on display. As the button is released, readings will be reset to zero.
5. Press the ON/OFF button again to leave calibration mode.

Test Run

Each jointer has been inspected and calibrated before leaving the factory to meet our quality and precision standards. Due to various reasons, this jointer may need to be re-adjusted when it arrives at your workshop. It is recommended to complete this test run before using the jointer for production work and repeat if the jointer is relocated.

Complete these quick tests to verify components are functional.

1. Remove all tools and debris from the machine. Ensure the jointer is disconnected from the power source.
2. Set the fence to 90 degrees using the positive stop. Verify the positive stop is set correctly.
3. Move and lock the fence to the back to expose the entire jointer table. Ensure the cutterhead guard is pushing against the fence. Rotate the guard to expose the entire cutterhead, then gently release the guard. The cutterhead guard should spring back to its original position.



WARNING: If the cutterhead guard fails to push against the fence, STOP HERE. Adjust guard tension before resuming the test run.

4. Use the provided key to turn the main switch to the OFF position, and press the emergency STOP button.
5. Connect the machine to the power source.
6. Press the START button. The machine should not turn on.
7. Turn the main switch to ON, and press the START button. The machine should not turn on.
8. Reset the emergency STOP switch by rotating it clockwise. The button should pop up. Press the START button, and the machine should turn on. The machine should be running with no excessive noise or vibration.
9. Disconnect the machine from the power source while it is running, then reconnect the machine to power. The machine should **NOT** restart.
10. Turn on the DRO. Rotate the infeed table adjustment handwheel to raise/lower the infeed table. DRO's readings should reflect the movements of the table, and the table should stop at 1/8" when is lowered without releasing the infeed table depth stop.
11. Set the infeed table depth of cut to 1/32".
12. Turn on the dust collection system, and surface plane a test workpiece. See "Surface Planing" on page 32 for detailed instructions. The workpiece should move through the jointer with ease.
13. Step on the foot paddle shutoff switch to stop the jointer.
14. Inspect the workpiece for unusual tearouts and other defects.

Congratulations! You have completed the test run! Now your jointer is ready for production work. If you discover any issues from the tests, please refer to the troubleshooting section and maintenance section to diagnose issues and make adjustments.

Operation

Preparation

For safety and to achieve the best results, please take the following steps before jointing a workpiece.

Inspect Workpiece

Only use this jointer for natural, quality wood materials. Cracked stock, board with loose knots, plywood, and other engineered wood products can break apart and cause severe kickbacks, which can lead to severe injuries and machine damage.

Do not use this jointer to cut treated lumber or anything that contains harmful chemicals. This will spread wood dust that contains such harmful chemicals.

Inspection

Carefully inspect workpieces for foreign objects. Nails, staples, rock chips, and other objects embedded on the wood surface will damage the jointer. It is advised to clean a workpiece with a stiff brush to remove all dirt and foreign objects ahead of time, especially for rough-sawn or reclaimed lumber. Use a metal detector to scan for metal objects as needed.

Check Dimensions

To avoid accidental contact with the cutterhead, NEVER process stock that is:

1. Shorter than 12”
2. Thinner than 1/2", or
3. Less than 2” wide (for surface planing).

Support Long Workpiece

Support long stock with rollers or other devices to avoid injuries. This also helps to create a smooth, consistent finish.

Check Moisture Content

Check the moisture content of workpieces. “Green wood” with moisture content over 20% will not cut properly and may jam the machine. Excessive moisture content will also cause the jointer’s unpainted surface to rust. Besides, as the workpiece dries, the once-flattened surface can become fuzzy and warped again. It is recommended to allow a workpiece to dry and stabilize before it is processed.

Warped Stock

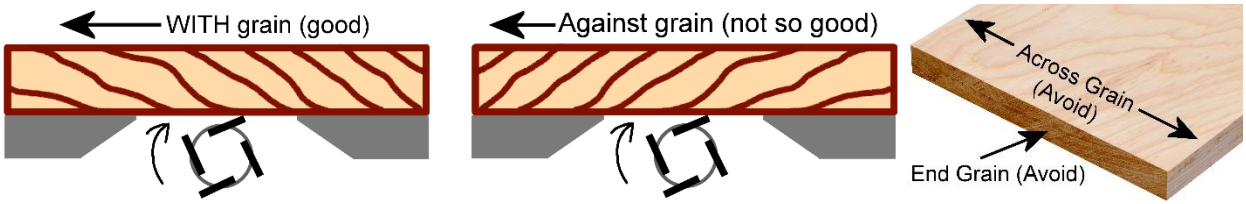
Avoid using severely warped boards, as they can be unstable and might cause severe kickbacks or disintegrate when it is cut.

Glue Deposits

Glue left on the workpiece surface can dull cutters and lower cut quality. Scrape off all glue deposits from the workpiece before the work begins.

Inspect Wood Grain

To achieve optimal results, cut WITH the grain. Inspect the wood grain from the side of a workpiece to determine the feed direction. Avoid cutting against/across/end grain as severe kickback and chipping may occur.

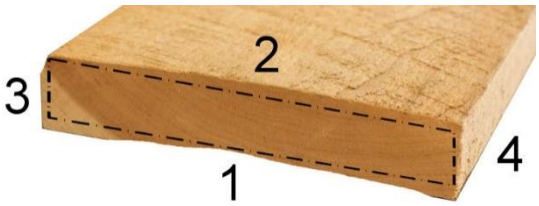


Some workpieces have complex wood grains and it is impossible to cut with the grain for the entire length of a workpiece. In this case, try feeding the workpiece in the opposite direction and see what works best. Reducing the depth of cut and feed rate can also help improve cut quality.

Squaring Stock

Jointer is commonly used in conjunction with a planer and table saw for squaring stock. It takes four steps for squaring stock:

1. Surface Planing - The bottom face of the stock is flattened by a jointer. The concaved face should be chosen for this step.
2. Thickness Planing - The top face of the stock is flattened by a thickness planer. In this step, the workpiece can be planed down to the desired thickness.



3. Edge Jointing - The concaved edge is straightened and squared on a jointer.
4. The last edge is straightened with a rip cut on a table saw, with the jointed edge placed against the table saw fence. In this step, the workpiece can be cut to the desired width.

WARNING

Serious injury or death can result from machine kickback or accidental contact with the cutterhead. Follow these safety rules to reduce your risks for all jointing operations:

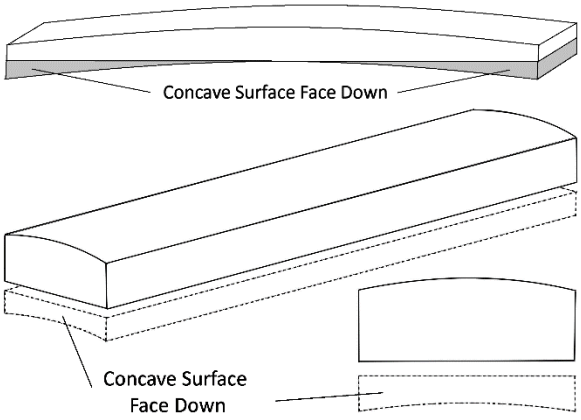
- **Lock the fence and the outfeed table before starting the jointer.**
- **Begin operation with the concave, or the most stable surface for jointing.**
- **Feed stock in front of the jointer with a stable stance and at a steady rate.**
- **NEVER feed the stock by pushing the stock from the rear.**
- **Use eye and ear protection devices.**
- **The cutterhead guard must be installed at all times except when cutting rabbets.**
- **Keep hands at least 3" away from the cutterhead.**
- **Use push blocks whenever possible.**

CAUTION

Ensure the dust collection system is functional and use a dust mask. Inhaling harmful airborne particles can cause serious, long-term health issues.

Surface Planing

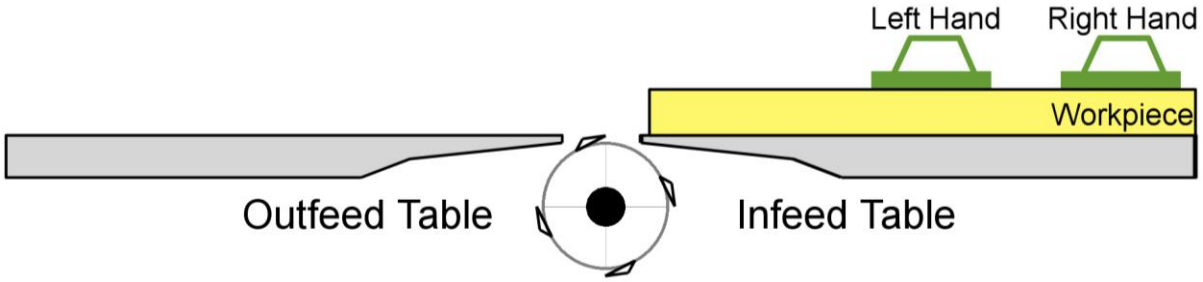
1. Inspect stock for quality issues and grain orientation before the operation. Begin surface planing with the concave face when present (see examples on the right).



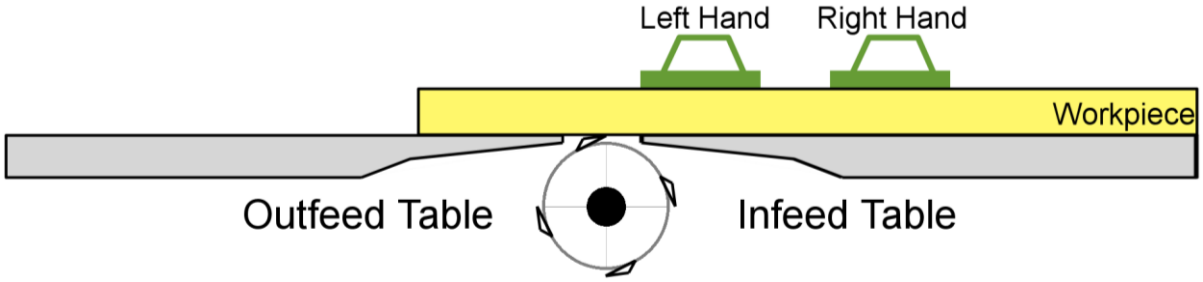
2. Adjust the depth of cut. Woodworkers typically set the depth of cut to 1/16” or less to allow better control over the workpiece and to reduce wastage.

   If needed, this jointer is capable of removing 1/8" of materials per pass.

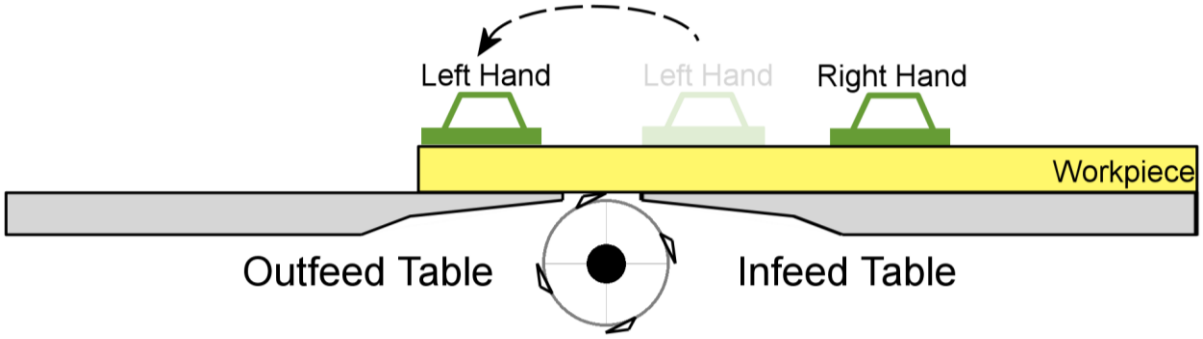
3. Lock the fence at 90°.
4. Start the jointer and the dust collection system.
5. To initiate a cut, stand near the infeed table and slightly behind the cutterhead. Place the workpiece on the infeed table. Use the push blocks to feed stock against the fence and the infeed table.



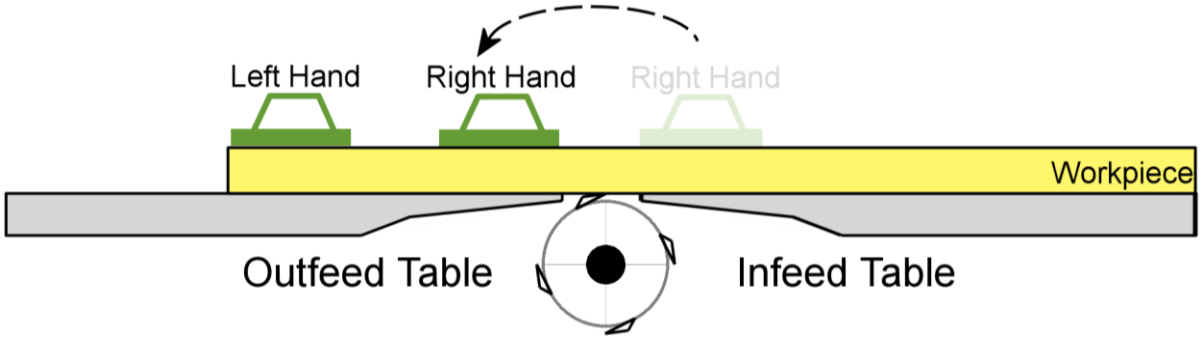
6. Feed a small section of the workpiece across the cutterhead. Keep the workpiece under control but do not apply excessive pressure to bend it flat on the table.



7. As the left feeding hand approaches the cutterhead, stop feeding. Carefully lift the left-hand push block and use it to feed the portion of the workpiece that is on the outfeed table. Maintain control of the workpiece with the right hand while repositioning the left hand.



8. As the right feeding hand approaches the cutterhead, stop feeding. Carefully lift the right-hand push block and move the entire body towards the outfeed table. Place the right-hand push block on the stock that sits on the outfeed table. Use the left hand to maintain control of the stock while repositioning the right hand.



9. From this point on, continue to feed stock only on the outfeed table until the entire length of the stock is planed. Feed stock at a steady rate to produce a smooth surface with no burn marks.
10. If the stock cannot be flattened in a single pass, repeat steps 5-9 until the entire surface is cut flat.

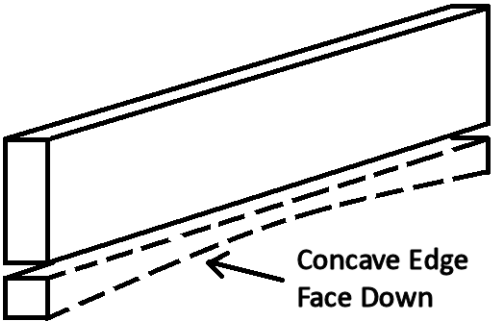
TIP: For new jointer users, practice stock feeding with the depth of cut set to 0". This helps to perfect the feeding technique before actual operations.

TIP: To ensure the entire surface is cut, some woodworkers leave pencil marks on the entire length of stock before the final passes, then verify all marks are removed after a pass.

TIP: Do not feed thin stock with excessive downward pressure. This will flatten any cup or warp workpiece as it passes through the cutterhead, and the workpiece will spring back to its original shape when pressure is released. Only apply adequate pressure to maintain control of the stock when feeding.

Edge Jointing

1. Set the fence to 90°.
2. Inspect stock for quality issues and grain orientation. Make sure the stock has a flat surface to feed against the fence. For crooked stock, begin edge jointing with the concaved edge.



3. Set the depth of cut. If an edge is almost flat and squared, set the depth of cut to only remove as much material as needed to obtain a jointed edge. This jointer can remove at most 1/8" of materials per pass.

   Stock that has a rough edge may take multiple passes to joint it straight and squared. In some extreme cases, consider using a track saw to create a roughly straight edge before jointing.

4. Start the dust collection system and the jointer.
5. Place the workpiece on the infeed table, then use push blocks to hold it against the fence and the table to initiate a cut.

   Be very careful when jointing narrow boards. Use push blocks to keep hands away from the cutterhead. Position both hands and the push blocks above the cutterhead guard when feeding.

   When edge jointing a board that is much taller than the fence, using the right hand to hold the board can provide better control. Continue to use a push block on the left hand to keep it away from the cutterhead.

   Be sure the right hand is securely resting on top of the stock and it is away from the cutterhead at all times.

6. Feed the entire length of the stock through the cutterhead. Maintain a stable, balanced stance for the entire process.
7. For long stock, feed a section past the cutterhead, then continue to feed the remaining length while standing next to the outfeed table.
8. Repeat the process until the entire edge is jointed flat and square.

TIP: Occasionally adjust fence position to make use of the outboard edge of the cutterhead. This helps to average the use of the cutters.

Beveling

Instructions and precautions for edge jointing apply to beveling. Besides:

- To set the fence bevel angle, lift the positive stop swing plate, and set the bevel angle using a protractor.
- Reduce the maximum depth of cut from 1/8” to 1/16” or less based on the width of the bevel and hardness of the workpiece.

Rabbet Cutting

A rabbet is a groove cut along the edge of a workpiece. This jointer is capable of making rabbet cuts as deep as 3/4". Depending on the requirements and constraints of your project, a jointer, or other tools such as a table saw, router, or other hand tools, can be the best tool for your rabbeting needs. Always consider safety when choosing a tool for rabbeting.

Performing a rabbet cut with this jointer will require the cutterhead guard removed. Promptly re-install the guard after the rabbeting operation is completed.

1. **Inspect stock for quality issues before the operation. The surfaces for rabbeting should be flat and squared.**
2. Remove the cutterhead guard.
3. Set the fence to 90°
4. Reposition the fence to set the width of a cut. The amount of exposed cutterhead is the width of the rabbet.

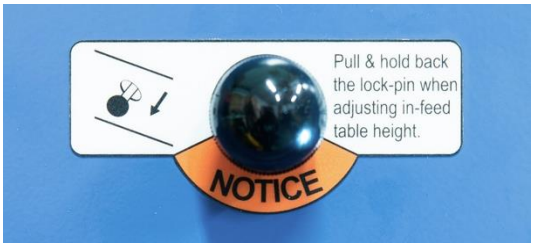
   Please beware that the cutters are installed in staggered formation, and the outermost edge of the cutter is located beyond the edge of the table. Make test cuts to confirm the width of the cut with a scrap piece.

   The fence travel is 11-15/16" leaving approximately 3/8" as the minimum width to rabbet. If the desired rabbet cut is less, an auxiliary fence must be built and secured to the jointer fence.
5. Start the jointer and dust collection system.
6. Place the workpiece against the fence and infeed-rabbeting table. Use push blocks whenever permissible.

7. Follow steps [5-9] in "Surface Planing" for feeding stock through the jointer. Repeat the process until reaching the desired depth of the rabbet cut.

   CAUTION: Beware that the rabbeting table is short and narrow. Take extra caution and support the entire workpiece throughout the operation.
8. Lower the infeed table gradually to remove a portion of the material in each pass until reaching the desired depth of cut. As much as 1/8" of materials can be removed per pass.

   CAUTION: For safety, never cut more than 1/8" per pass.
9. Disengage the infeed table depth stop when the infeed table needs to go below 1/8". This jointer can produce a rabbet that is 3/4" deep.



10. Reinstall the cutterhead guard after the rabbeting operation.

⚠ **WARNING**	**If the cutterhead guard is removed for rabbeting operation, use extreme caution when performing cuts. Reinstall the guard immediately when the operation completes.**

Common Cutting Problems

Snipe

Occurs when too much pressure is applied as a workpiece enters or leaves the cutterhead. Improper table settings can also introduce snipes.

To mitigate this problem, apply even feed pressure throughout the entire workpiece. Once the workpiece goes past the cutterhead, downward pressure should be focused on the outfeed table only. Ensure the outfeed table is not positioned excessively below the cutter head.

Chipping

Happens when cutting against the grain direction. For highly figured lumber, and areas near a knot, some amount of chipping is normal. In this case, reduce the depth of cut and feeding speed. Moistening the problematic area before jointing can sometimes mitigate the issue.

Dirty or dull cutters can also leave chip marks on the workpiece. If chipping happens while jointing straight grain stocks, inspect the cutter inserts and remove all resin buildups. Rotate/replace dull cutter inserts.

Fuzzy Grain

This can happen when planing wood with high moisture content or if the cutter is dull. Sometimes it is impossible to avoid fuzzy grain due to the nature of certain wood types. To mitigate this issue, avoid using wood with high moisture content and use sharp cutters.

Accessories

Oliver Machinery has a collection of accessories and add-ons to enhance the productivity of your jointer. Please visit our website **OLIVERMACHINERY.NET** to purchase these items.

You may also call **1-800-559-5065** or email **PARTS@OLIVERMACHINERY.NET** to place an order. We are available Monday through Friday, 7:30 AM - 4 PM Pacific Time.

Cutter Inserts

Genuine four-sided indexable carbide cutter insert that will fit the cutterhead of Oliver **4265C.051T / 4265C.753T Jointer**.

Parts number: **P-15mm 4S**

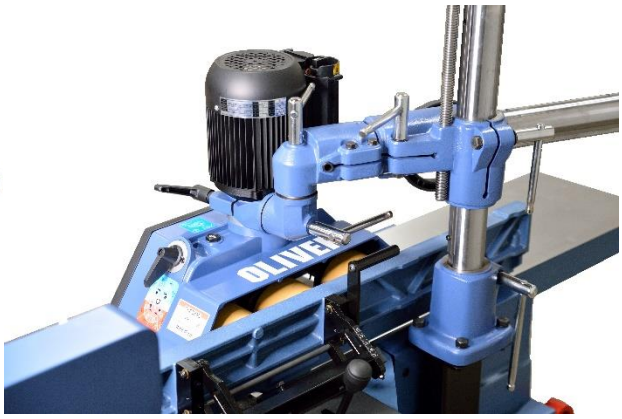
Touchup Paint

Keeping all painted surfaces in good condition not only makes your machine look nice but also keeps rust away. Oliver Machinery has pre-mixed spray paint available in Oliver-Blue for purchase.

WARNING **Using unapproved accessories may cause this machine to malfunction, resulting in serious injury and/or machine damage. Only use accessories recommended for this machine.**

Power Feeder

Two models of power feeders are available for the 4265C.051T / 4265C.753T Jointer. They can be installed on the power feeder mount located behind the outfeed table.



Features

- Polyurethane-covered rollers provide excellent grip while protecting the work surface.
- Eight feed speeds and two different models with three or four rollers to fit any application.
- A versatile stand allows adjustment of 10” in height and 18” in reach.
- Powerful TEFC motor is available in single or three-phase.
- CSA Listed

Model	**APF0038**
Stock Number	APF0038.001 1HP, 1Ph, 230V (4.2A)
Stock Number	APF0038.002 1HP, 3Ph, 230V (3.4A)
Number of Rollers	3
Roller Size	4-3/4”(D) x 2-3/8”(W)
Feed Speed	8 Speeds: 6.5 / 13 / 18 / 22 / 36 / 43 / 55 / 108 FPM
Net Weight	137 lbs.

Model	**APF0048**
Stock Number	APF0048.001 1HP, 1Ph, 230V (4.2A)
Stock Number	APF0048.002 1HP, 3Ph, 230V (3.4A)
Number of Rollers	4
Roller Size	4-3/4”(D) x 2-3/8”(W)
Feed Speed	8 Speeds: 6.6 / 13 / 18 / 22 / 36 / 43 / 55 / 108 FPM
Net Weight	146 lbs.

Please visit our website at **WWW.OLIVERMACHINERY.NET/ACCESSORIES** for other recommended accessories.

Maintenance

Routine maintenance keeps your jointer in top shape. Please follow the maintenance schedule below, and use the maintenance record worksheet in the manual to document all tasks completed. **NOTICE:** Maintenance schedule may vary for individual users due to different situations and safety requirements.

WARNING **Disconnect the machine from the power source before any maintenance work is performed. After servicing the jointer, remove all wrenches and tools before restarting the machine. Failure to comply can cause serious injury!**

Maintenance Schedule

Interval	Task
Every day	Remove dust buildups from the jointer and dust collection system.
	Inspect the power cord for signs of aging and damage. Replace as needed.
Every week	Inspect and clean the cutterhead. Remove any dust and resin accumulation.
	Inspect/rotate/replace worn cutter inserts.
	Apply rust protectant on unpainted cast iron surfaces.
	Verify infeed/outfeed tables are coplanar.
Every month	Check V-belt tension and replace it if the belt shows signs of cracking or glazing.
Every 6 months	Lubricate worm gears with grease.

Notice: Motor bearings are permanently sealed and lubricated and do not require lubrication.

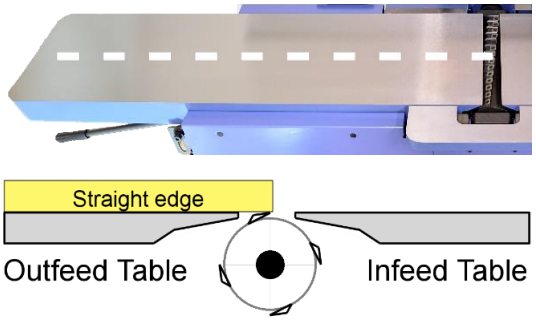
Inspect / Adjust Jointer Tables

Each jointer has been inspected and calibrated in the factory and should not require adjustments initially. When a jointer consistently makes problematic cuts, perform these checks, and make adjustments as needed.

Inspect Outfeed Table Height

1. **Disconnect the jointer from the power source!!**
2. Put on leather gloves.

3. Remove the cutterhead guard.
4. Move the fence to the back to expose the entire table.
5. Place a straight edge over the centerline of the outfeed table so it hangs over the cutterhead.

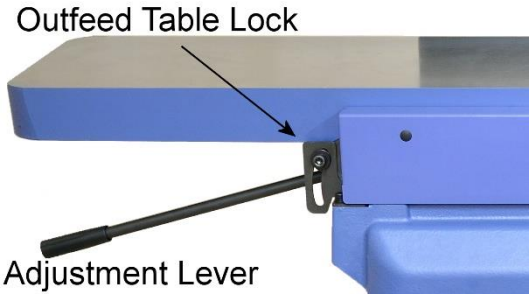


6. When the outfeed table height is properly set, cutters should be barely scraping the straight edge when the cutterhead rotates. Follow the next section to make adjustments as needed.

If the outfeed table height is set properly, jump to section "**Inspect Outfeed Table Parallelism**".

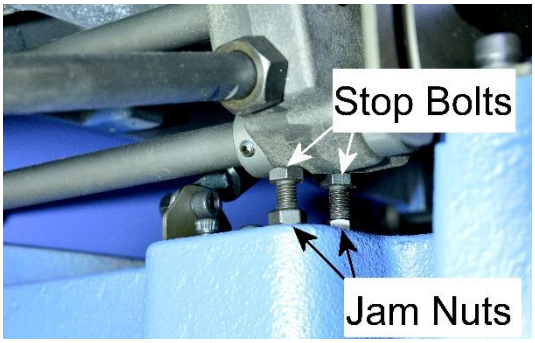
Adjust Outfeed Table Height

1. **Disconnect the jointer from the power source!!**
2. Loosen the cap screw that locks the outfeed table.



3. Adjust the outfeed table height with the lever. With a straight edge sitting on the outfeed table, cutters should barely touch the straight edge when the cutterhead rotates.
4. Below the base of the lever, there are two stop bolts for setting the maximum and minimum height of the outfeed table.

   If these stop bolts need to be adjusted, loosen the jam nuts, and retighten them after adjustments.

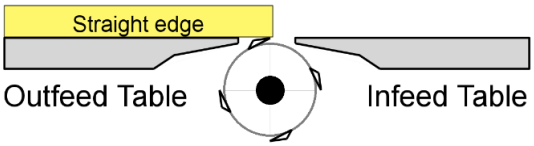


5. When the height of the outfeed table is adjusted, tighten the locking cap screw to lock its height.

Inspect Outfeed Table Parallelism

1. **Disconnect the jointer from the power source!!**
2. Place a straight edge on the outfeed table in positions as shown below:

3. Make sure the straight edge is hanging above the cutterhead:

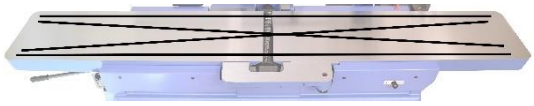


4. In each position, carefully rotate the cutterhead. When the outfeed table is in parallel with the cutterhead, cutters should barely scrape the straight edge when the cutterhead rotates.
5. If the outfeed table and cutterhead are out of alignment, move to section "**Adjust Table Parallelism/Coplanarity**".

If the outfeed table is in parallel with the cutterhead, proceed to the next section "**Inspect Infeed Table**"

Inspect Infeed Table

1. **Disconnect the jointer from the power source!!**
2. **NOTICE:** Make sure the outfeed table is properly adjusted before continue.
3. Place a straight edge that splits evenly on both the infeed and the outfeed table.
4. Raise the infeed table so that it is at the same height as the outfeed table. When proper height is set, the straight edge will sit flat and flush on the infeed and the outfeed table. Rotate the carbide cutter away if it contacts the straight edge.
5. Move the straight edge across the tables in positions as shown in the picture below. Rotate the carbide cutter away if it gets in the way.



6. In each position, the straight edge should sit flat and fit flush on both infeed and outfeed tables.
7. If infeed/outfeed tables are out of alignment, move to section "Adjust Table Parallelism/Coplanarity".
8. Otherwise, congratulations! The jointer is calibrated for your next project!

Adjust Table Parallelism/Coplanarity

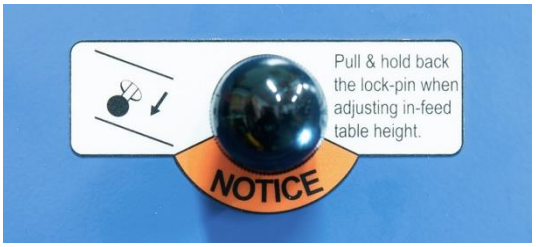
Adjusting table parallelism and coplanarity takes time, precision, and patience. The entire process can take over an hour or more. Check the amount of misalignment against tolerance before making adjustments.

For best results, use a long and precise straight edge for adjustments.

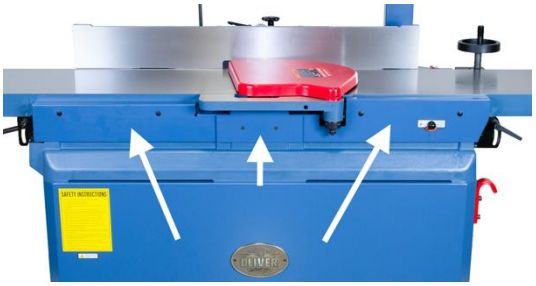
Measurement	Tolerance
Outfeed Table / Cutterhead Parallelism	<= 0.004”
Infeed / Outfeed Table Parallelism	<= 0.01”

For best results, prepare a long and precise straight edge for this task.

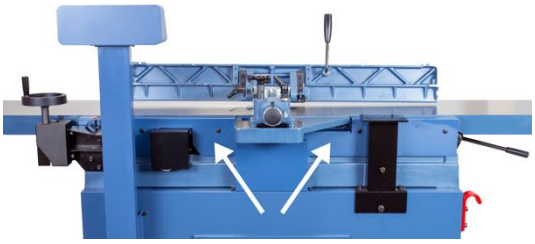
1. **Disconnect the jointer from the power source!!**
2. Remove the depth stop release knob.



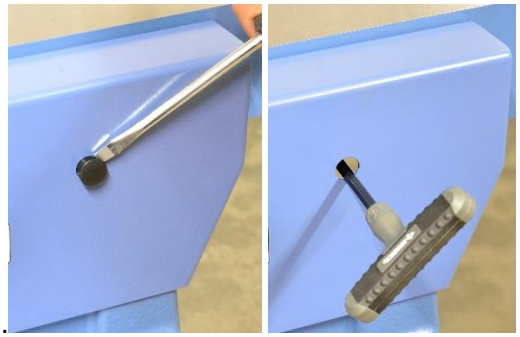
3. Remove the cutterhead cover and the front panels.



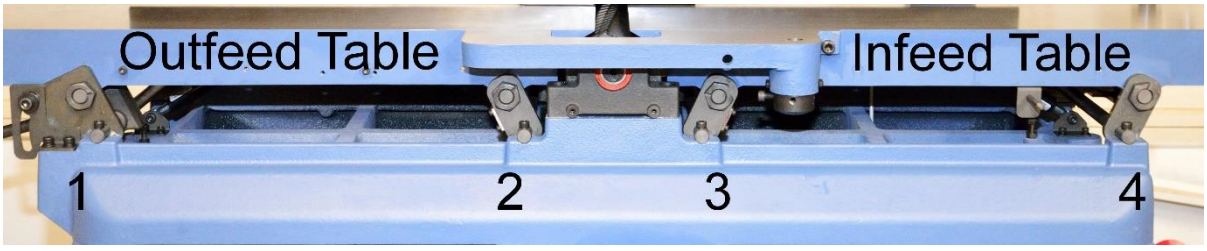
4. Remove the rear panels that conceal the parallelogram mechanism.



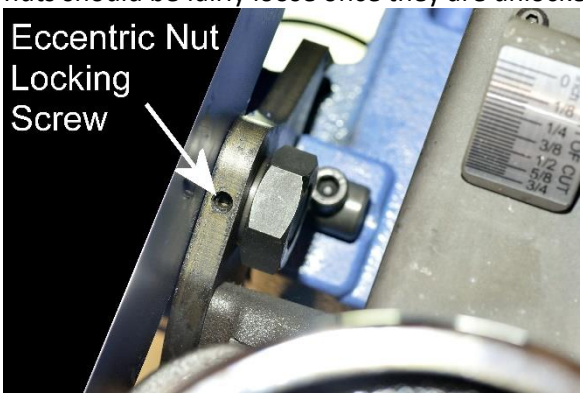
5. Each panel is secured by two socket head hex cap screws, which are covered by plastic caps. Use a straight-head screwdriver to remove the plastic cover, then remove the hex cap screw with a 5mm hex wrench.

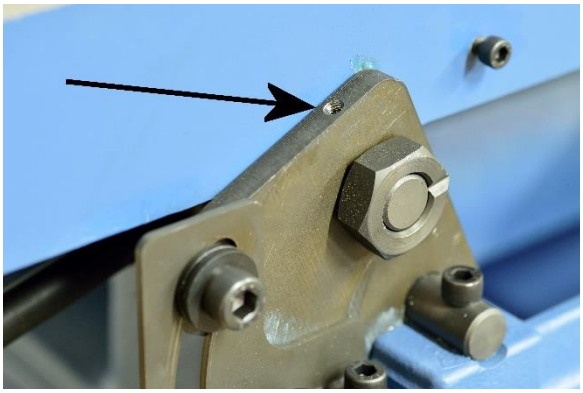


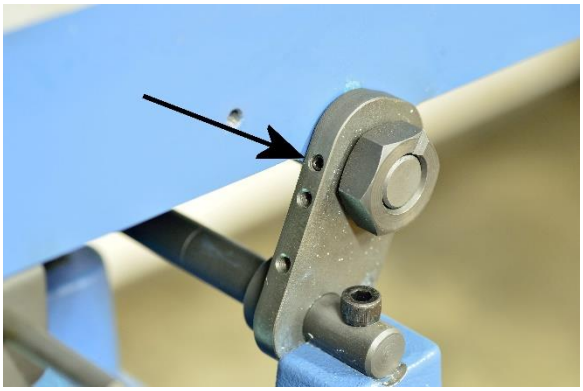
6. This picture shows the jointer with the parallelogram mechanism exposed. Table parallelism /coplanarity can be adjusted by rotating the eccentric nuts on the shafts [1-4]. There is a pair of eccentric nuts located on each end of these shafts.

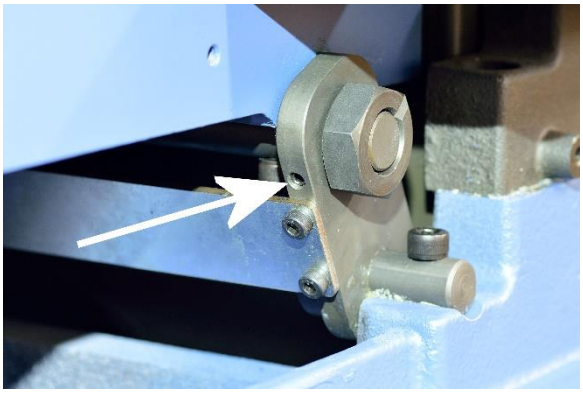


7. Locate and loosen the set screws for locking the eccentric nuts as shown in the pictures. The eccentric nuts should be fairly loose once they are unlocked.

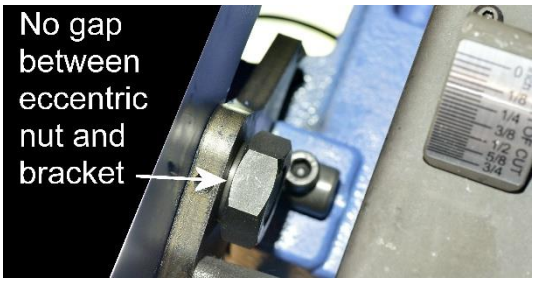








8. Adjust the outfeed table. Rotate the eccentric nuts to align the outfeed table and cutterhead.
9. **IMPORTANT:** While rotating the eccentric nuts, ensure they are pushed against the holding bracket. Leaving any gaps in between may cause the table to shift sideways.

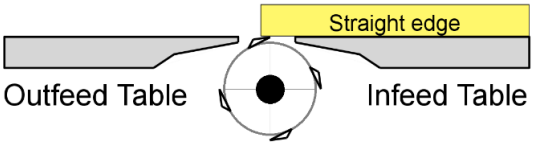


10. Repeat the steps in “Inspect Outfeed Table Parallelism” on page 41 to verify the adjustments.
11. Retighten the set screws to lock all outfeed table eccentric nuts after adjustments.
12. With the fence locked, gently rock the fence to ensure the outfeed table is stable. If the outfeed table is rocking, eliminate all gaps between eccentric nuts and the bracket.
13. Adjust the infeed/outfeed table parallelism using the infeed table eccentric nuts. Repeat the steps in “Inspect Infeed Table” on page 41 to check the adjustments. Again, leave no gaps between the eccentric nut and the bracket.
14. Tighten the set screws to lock all eccentric nuts after the adjustment.
15. With the infeed table realigned, it may need additional adjustments. See next section, “Infeed Table Adjustments” for details.
16. Reinstall all panels and cutterhead guard when all adjustments are done.

Infeed Table Adjustments

After a full table realignment, the infeed table height should be re-zeroed, and a few components of the infeed table will need to be adjusted.

1. **Disconnect the jointer from the power source!!**
2. To re-zero the infeed table height, raise the infeed table so it is approximately at the same height as the cutting arc of the cutterhead.
3. Place a straight edge over the infeed table so it hangs over the cutterhead.



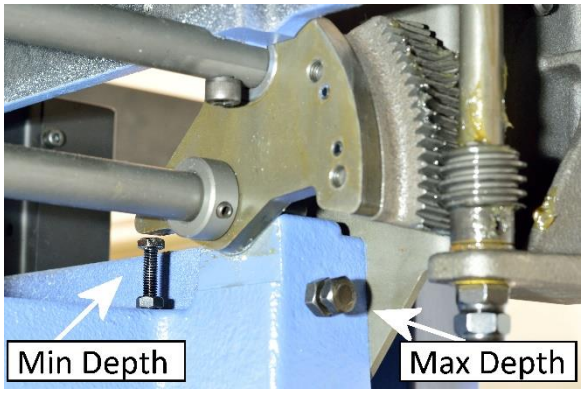
4. Fine-tune the table height to set the depth of cut to zero. When properly set, cutters should be barely scraping the straight edge when the cutterhead rotates.
5. With the infeed table height zeroed, follow the steps in "**DRO Calibration**" to re-zero the digital readout.
6. Check if the infeed table height scale is still pointing at zero. If not, loosen the two hex screws and readjust the pointer.

Infeed Table Positive Stops Adjustments

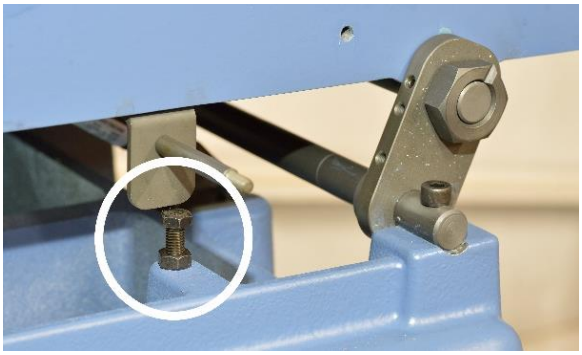
Under the infeed table, there are three positive stops:

Minimum Depth Stop - When properly adjusted, it should stop the infeed table when the depth of cut is between 0"-1/32".

Maximum Depth Stop - Prevents the infeed table from lowering too much and getting more than 3/4" depth of cut.



Depth Stop for Jointing – Limits the depth of cut to 1/8" for jointing operations. This positive stop is located behind the depth stop release knob, which is accessible when the panel is removed.



To test this depth stop, make sure the bracket as shown in the picture above aligns with the stop bolt, then lower the infeed table. If this positive stop is set correctly, the table will stop at 1/8".

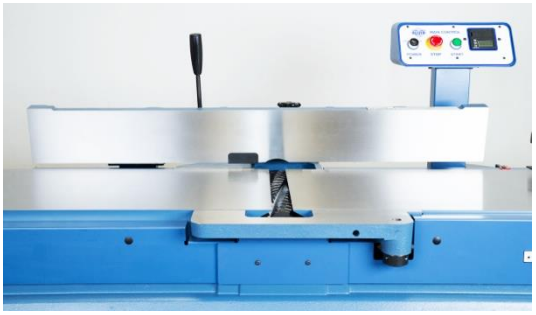
To Make Adjustments:

1. **Disconnect the jointer from the power source!!**
2. Loosen the jam nut that locks the stop bolt.
3. Rotate the stop bolt until it stops the infeed table at the correct height.
4. Re-tighten the jam nuts.

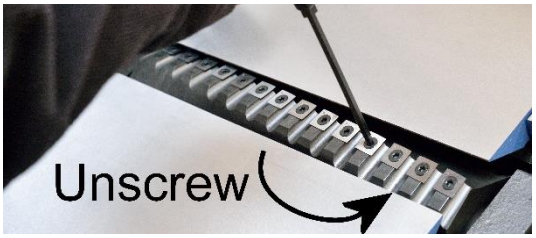
Rotate / Replace Cutter Inserts

CAUTION **Cutter inserts are extremely sharp. Wear thick leather gloves to avoid hand injuries.**

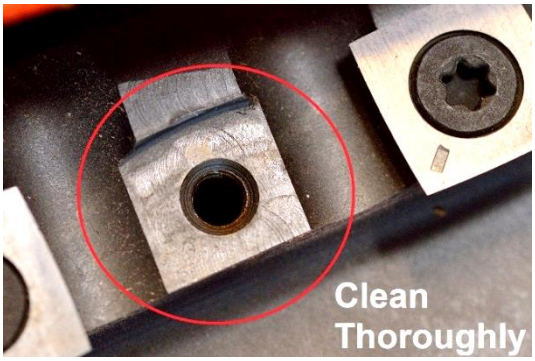
1. **Disconnect the jointer from the power source!!**
2. Put on leather gloves.
3. Remove the cutterhead guard.
4. Move the fence to the back and raise it above the table to expose the cutterhead.



5. Remove dust and resin accumulations on the cutterhead and areas nearby.
6. Inspect the cutter inserts. Rotate the cutter inserts 90° clockwise when they get dulled or nicked. Use a permanent marker to mark the new edge to be used.
7. To rotate/replace a cutter insert, remove the Torx screw with a T-25 Torx bit. Turn **COUNTERCLOCKWISE** to loosen the screw.



8. With the cutter insert removed from its platform, thoroughly clean the cutter insert platform with a vacuum or compressed air.



IMPORTANT: Obstacles between the insert and cutterhead platform will create uneven pressure against the insert. This will lower cut quality and may cause the insert to crack.

9. Reinstall the cutter insert with the marked cutting edge facing out.
10. Inspect the Torx screw. Replace any damaged screws. Lubricate screw thread with a thin coat of lightweight machine oil.

    IMPORTANT: Do not use an excessive amount of lubrication, or the Torx screw and the cutter insert will not sit properly.

11. Using a torque wrench, re-tighten the Torx screw with 52-60 lb-inch of torque.

    IMPORTANT: Do not overtighten the screw or the inserts may break. Do not use power tools to tighten the Torx screws. Excessive torque can crack the cutter inserts. It can also strip the threads of the cutterhead or the screw.

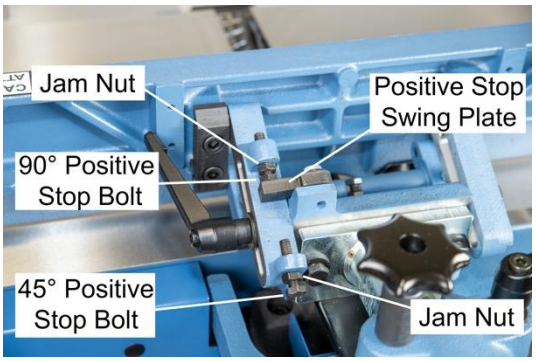
12. Reinstall the cutterhead guard and remove all tools from the table when servicing is done.

Adjust Fence Positive Stops

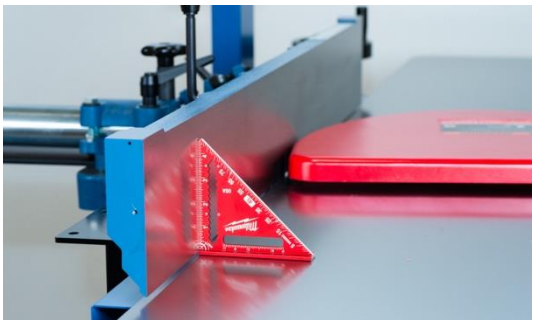
The fence assembly has three positive stops at 45°, 90°, and 135°. They were calibrated in the factory and should not require initial adjustments.

45° and 90° Positive Stop Adjustment

1. **Disconnect the jointer from the power source!!**
2. Loosen the fence tilt lock.
3. Locate the positive stop bolt that needs adjustment.



4. Loosen the jam nut.
5. Adjust the positive stop bolt and then hand tighten the jam nut. Position the fence so the positive stop bolt that needs adjustment is resting on the swing plate.
6. Lock the fence and use a square to verify the positive stop is set correctly. Repeat steps 4-5 as needed.



7. If the positive stop is set correctly, hold the bolt in place and tighten the jam nut, then recheck the positive stop with the fence locked in place.

135° Positive Stop Adjustment

1. **Disconnect the jointer from the power source!!**
2. Loosen the fence tilt lock and set the fence to 90° to expose the 135° positive stop bolt.

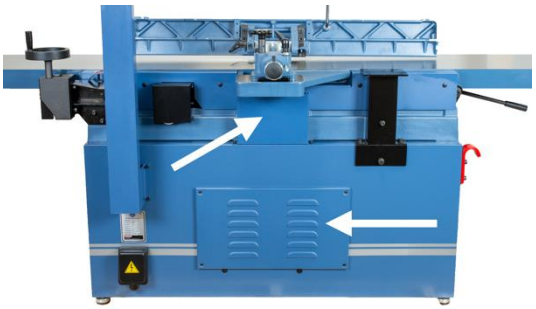
3. Loosen the jam nut.
4. Adjust the positive stop bolt and then hand tighten the jam nut. Position the fence so that the fence rests on the positive stop.
5. Lock the fence and use a protractor to check the positive stop is set up correctly. Repeat steps 3-4 as needed.

6. If the positive stop is set correctly, hold the bolt in place and tighten the jam nut, then recheck the positive stop with the fence locked in place.

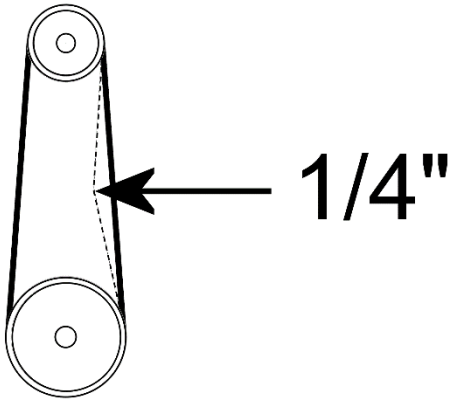
Adjust Belt Tension

CAUTION **The belt and pulleys may be hot after operations. Allow components to cool before servicing.**

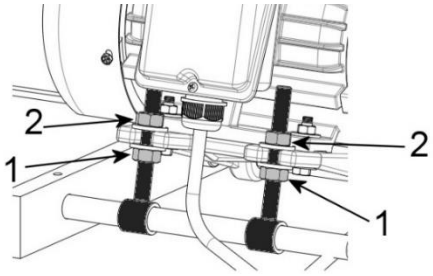
1. **Disconnect the jointer from the power source!!**
2. Remove the motor access panel and the belt cover.



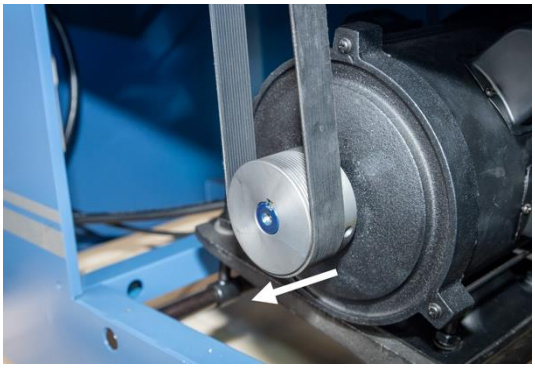
3. Apply moderate pressure on the V-belt midway between the two pulleys. Properly tensioned V-belt should deflect by approximately 1/4“.



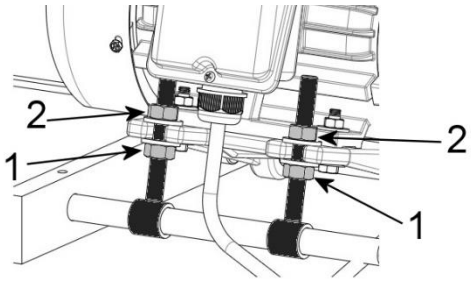
4. If V-belt tension needs to be adjusted, loosen both lower motor mounting bolts (#1). Lower the motor until proper belt tension is reached. Secure the motor mounting plate by tightening both the upper mounting bolts (#2) and the lower mounting bolts.



5. If the belt need needs to be replaced, walk the belt away from the motor pulley.



If the belt is too tight to remove, temporarily loosen the upper mounting bolts (#2). Raise the motor to loosen the belt, and remove it from the pulleys.

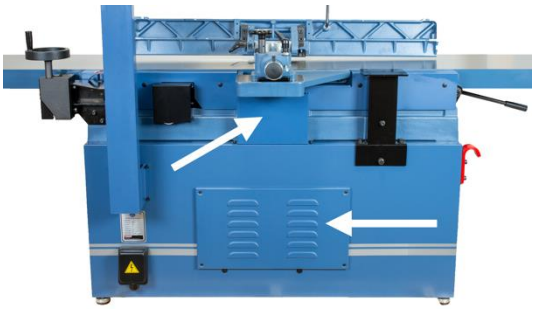


6. Install a new belt and make sure the belts sit in the grooves of the pulleys.
7. Adjust belt tension and re-secure the motor as needed.
8. Reinstall the belt cover and motor access panel when maintenance is completed.

Align Belt Pulleys

The belt pulleys were aligned in the factory and should not require further adjustments. Check pulley alignment if the belt is slipping off the pulleys, or if the belt wears prematurely.

1. **Disconnect the jointer from the power source!!**
2. Remove the motor access panel and the belt cover.



3. Use a straight edge or a tight string to check the alignment of the belt pulleys.
4. Adjustments can be made by shifting the motor pulley. First, loosen the belt, then loosen the set screws on the pulley, and the motor pulley can move along the motor shaft.

5. Realign the motor pulley with the cutterhead pulley.
6. Retighten the motor pulley locking screws.
7. Retighten the belt.
8. Close the belt cover and motor access panel after adjustments.

Troubleshooting

Mechanical / Electrical Issues

Problem	Possible Cause	Possible Solution
Machine does not start.	Machine is not connected to a power source.	1. Make sure the machine is plugged in, or the power disconnect is at the ON position. 2. Check the electrical panel for a tripped circuit breaker or a blown fuse. 3. Ensure all electrical connections have good contacts.
	Low voltage/current.	Have a licensed electrician check and repair the power circuit.
	Faulty switch/motor/ capacitor.	Contact customer service for further assistance.
Machine trips thermal protection/circuit breaker, or blow fuses.	Machine is undersized for the operation.	Reduce the depth of cut and feed rate.
	Workpiece moisture level is too high.	Only joint wood with a moisture level below 20%.
	Machine is jammed.	Make sure the cutterhead is not jammed by woodchips. Check dust chute and clear blockages.
	Too much load on a circuit.	Make sure the power circuit is sized for this machine. If the circuit is shared, ensure it is sized to supply power for all items in the circuit.
	Motor/capacitor issue.	Contact customer service for further assistance.
Machine stalls during operation.	Machine is undersized for the operation.	Reduce the depth of cut. Lower feed rate.
	Dull cutters.	Rotate/replace cutter inserts.
	Belt slipping.	1. Clean belt and pulleys. 2. Adjust belt tension. 3. Check belt and pulley alignments.
	Motor/capacitor issue.	Contact customer service for further assistance.
Machine stopped during an operation.	Thermal overload protection triggered.	Stop the jointer and wait for at least 3 minutes. When the machine is cooled down, overload protection will reset automatically. Reduce the depth of cut and feed rate when resuming the work.

Problem	Possible Cause	Possible Solution
Infeed table is stuck/difficult to adjust.	Infeed table is locked.	Loosen the infeed table lock before adjusting the infeed table.
Outfeed table is stuck/difficult to adjust.	Outfeed table is locked.	Loosen the locking screw before adjusting the outfeed table.
Digital readout is not functional.	Dead battery.	Replace battery.
Unable to lower infeed table below 1/8”	Depth stop is engaged.	Pull the infeed table depth stop release knob while lowing the infeed table. **NOTICE:** Only set depth of cut greater than 1/8” for rabbeting operations.
Outfeed table is loose and moves with the fence.	There is play in the parallelogram mechanism.	Check the parallelogram mechanism and eliminate any gaps between the eccentric nut, bracket, and shafts. Ensure all eccentric nuts are locked by the set screws, and each set screw is locked by blue Loctite.
Workpiece is caught on the edge of the outfeed table.	Outfeed table is set too high.	Adjust the outfeed table to ensure it is flush with the cutting arc of the cutterhead.
Uneven wear on cutter inserts	One section of cutterhead is used more than another.	Occasionally adjust the fence’s position so the entire cutterhead is utilized.
Machine vibrates excessively or makes unexpected noise.	Damaged cutter inserts.	Replace cutter inserts.
	Machine stands on an uneven floor.	Reposition the machine on a flat, level surface. Adjust the leveling feet.
	Belt worn, slipping, or hitting belt cover.	Clean belt and pulleys. Adjust belt tension. Replace the V-belt if it shows signs of aging.
	Improper motor mounting.	Check and adjust motor mounting.
	Loose components.	Tighten loose fasteners.
	Worn bearings.	Contact customer service for assistance.

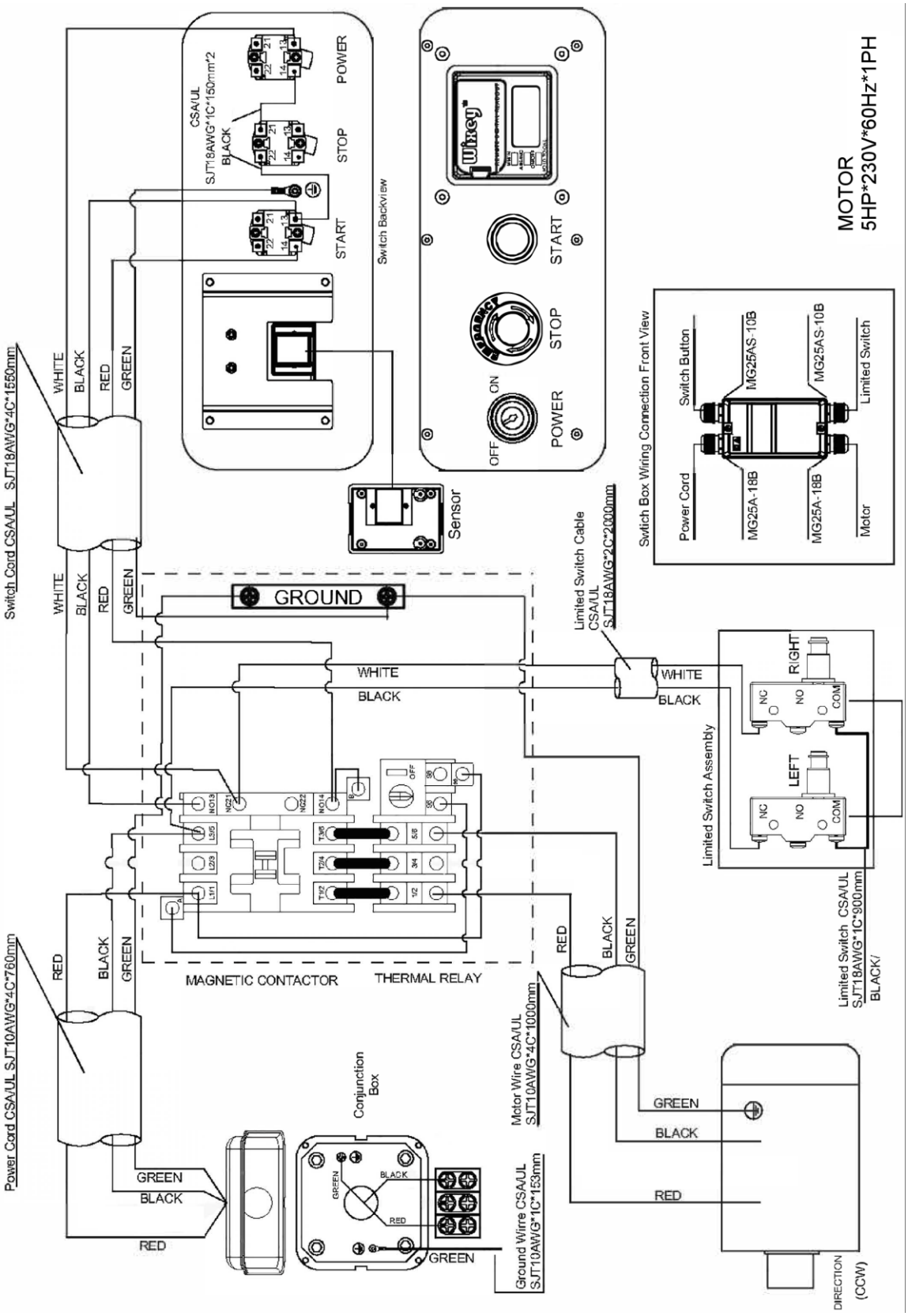
Operation / Quality-Related Issues

Problem	Possible Cause	Possible Solution
Workpiece came out twisted.	Improper feeding.	Use the outfeed table as the reference point for feeding. Apply even pressure and feed rate on the entire workpiece.
	Too much downward feeding pressure.	Avoid flattening the workpiece by applying too much downward feeding pressure. The workpiece will bounce back warped after it is cut.
	Outfeed table is not parallel with the cutterhead or infeed table.	Ensure the outfeed table is in parallel with the cutterhead, and the outfeed/infeed tables are coplanar.
	More passes are needed.	Significantly twisted boards take multiple passes to flatten.
Excessive snipe	Outfeed table is too low.	Adjust the outfeed table to ensure it is flush with the cutting arc of the cutterhead.
	Too much downward pressure when feeding the end of a workpiece.	Once the workpiece reaches the outfeed table, use the outfeed table as the reference. Reduce feeding pressure apply to the workpiece that is still on the infeed table.
Chipping	Too much material was removed in one pass.	Reduce the feed rate or the depth of cut.
	Planing across/end grain.	Do not use a jointer to cut across/end grain.
	Damaged cutter.	Rotate/replace cutter insert.
	Cutting against grain; or knots.	Avoid processing workpieces with knots. Cut WITH grain whenever possible. When jointing a workpiece with complex grain pattern, reduce the depth of cut. Sometimes moistening problematic areas can reduce chipping.
Fuzzy looking finish.	Wood moisture content is too high.	Only process wood with less than 20% moisture content.
	Dull cutter.	Rotate/replace cutter insert.
	Some wood types tend to have fuzzy grain.	Adjust the feed rate or the depth of cut. Use sharp cutters.
Glossy looking finish.	Dull cutter.	Rotate/replace cutter insert.
	Cutting depth is too shallow.	Increase the depth of cut.

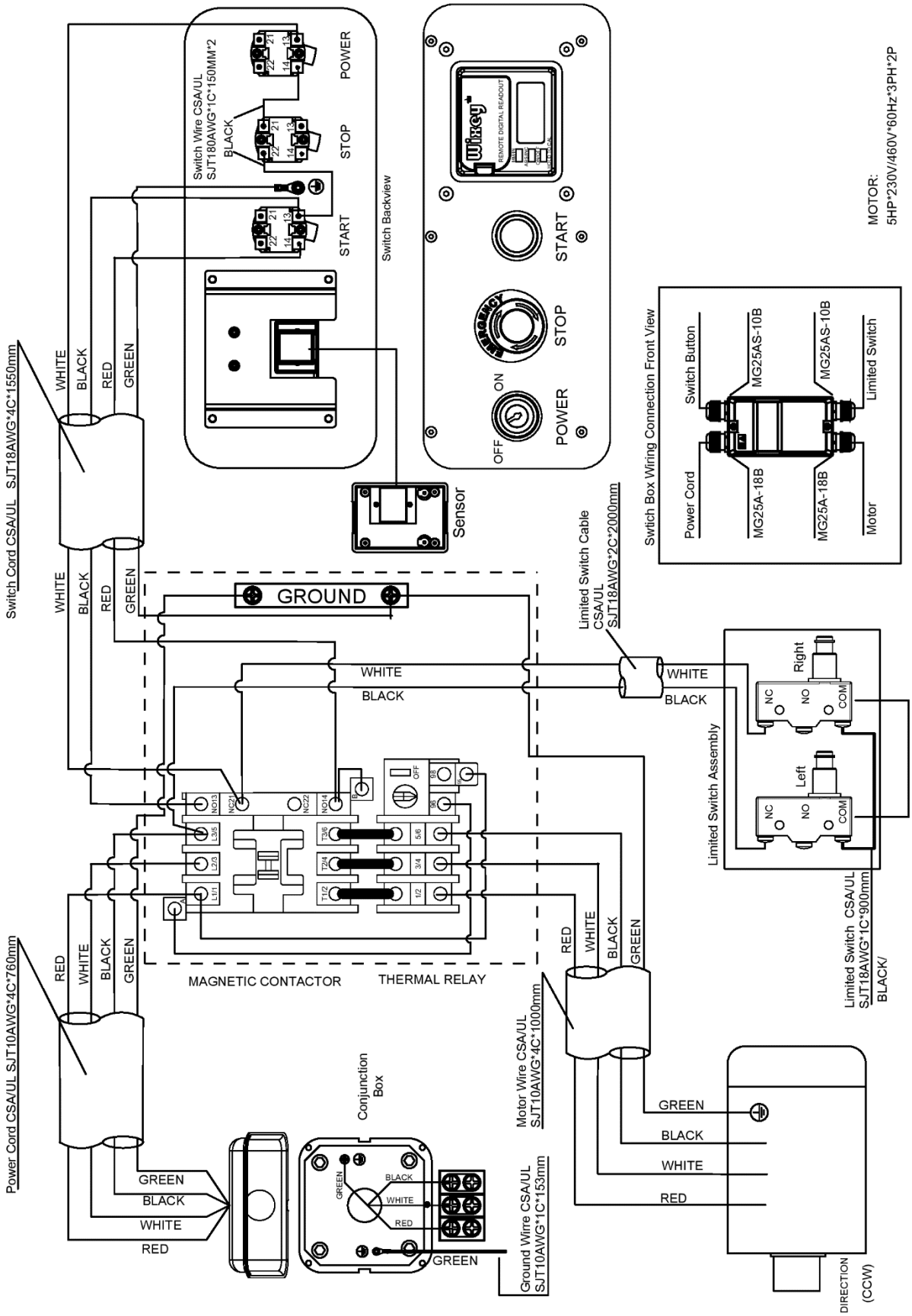
Problem	Possible Cause	Possible Solution
Long lines or ridges running along the length of the board.	Chipped cutter.	Rotate/replace cutter insert.
Finished stock has uneven front-to-back thickness.	Cutterhead is not flush with the outfeed table.	Adjust the outfeed table to ensure it is flush with the cutting arc of the cutterhead.
	Inconsistent feeding pressure was applied to the workpiece.	Apply even feeding pressure on the workpiece. Keep the feed rate consistent.
Finished stock is concave/convex in the middle.	Infeed/outfeed tables are not coplanar.	Ensure the outfeed table is parallel with the cutterhead, and the outfeed/infeed tables are coplanar.

Wiring Diagram

For Stock # 4265C.051T (230V, 1Ph)



For Stock # 4265C.053T (230V, 3Ph)



Parts List

Fence Assembly

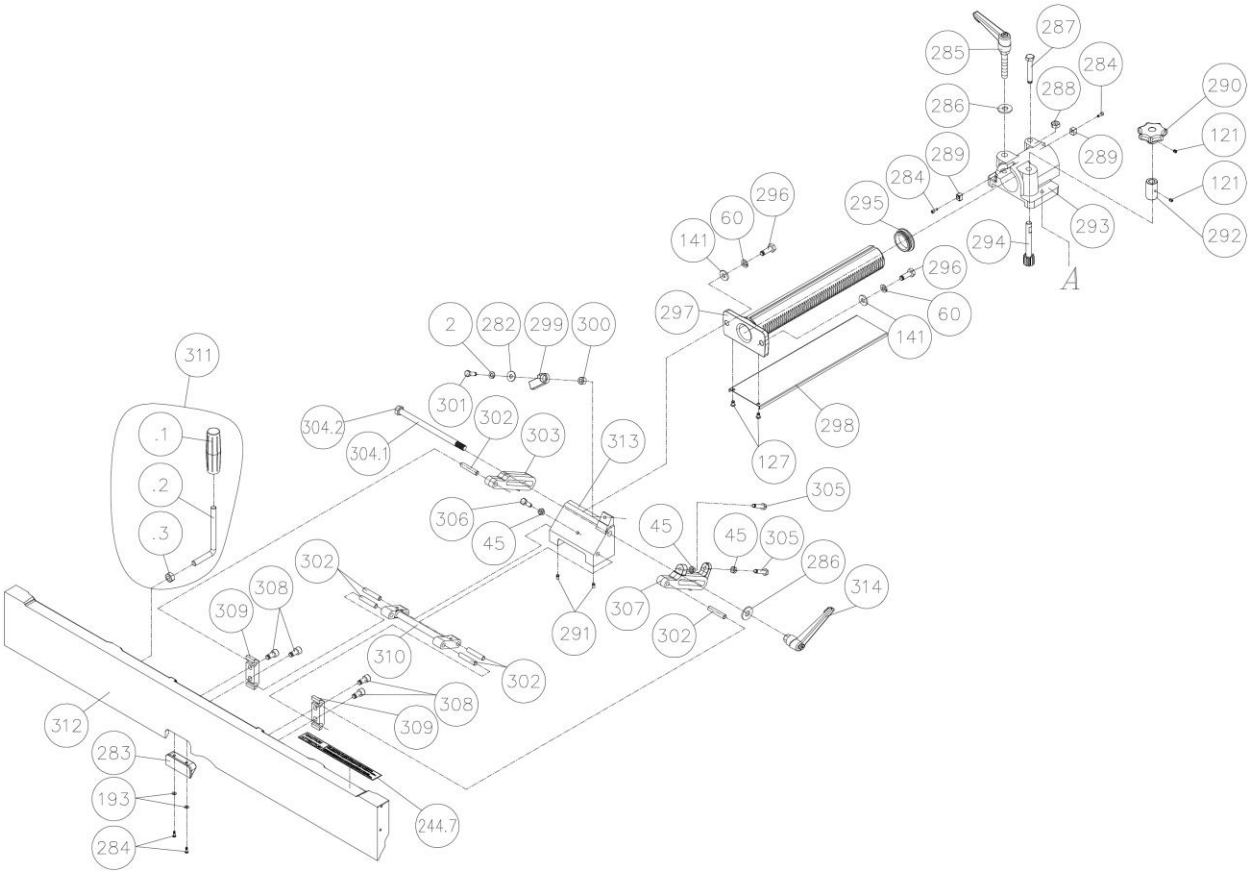
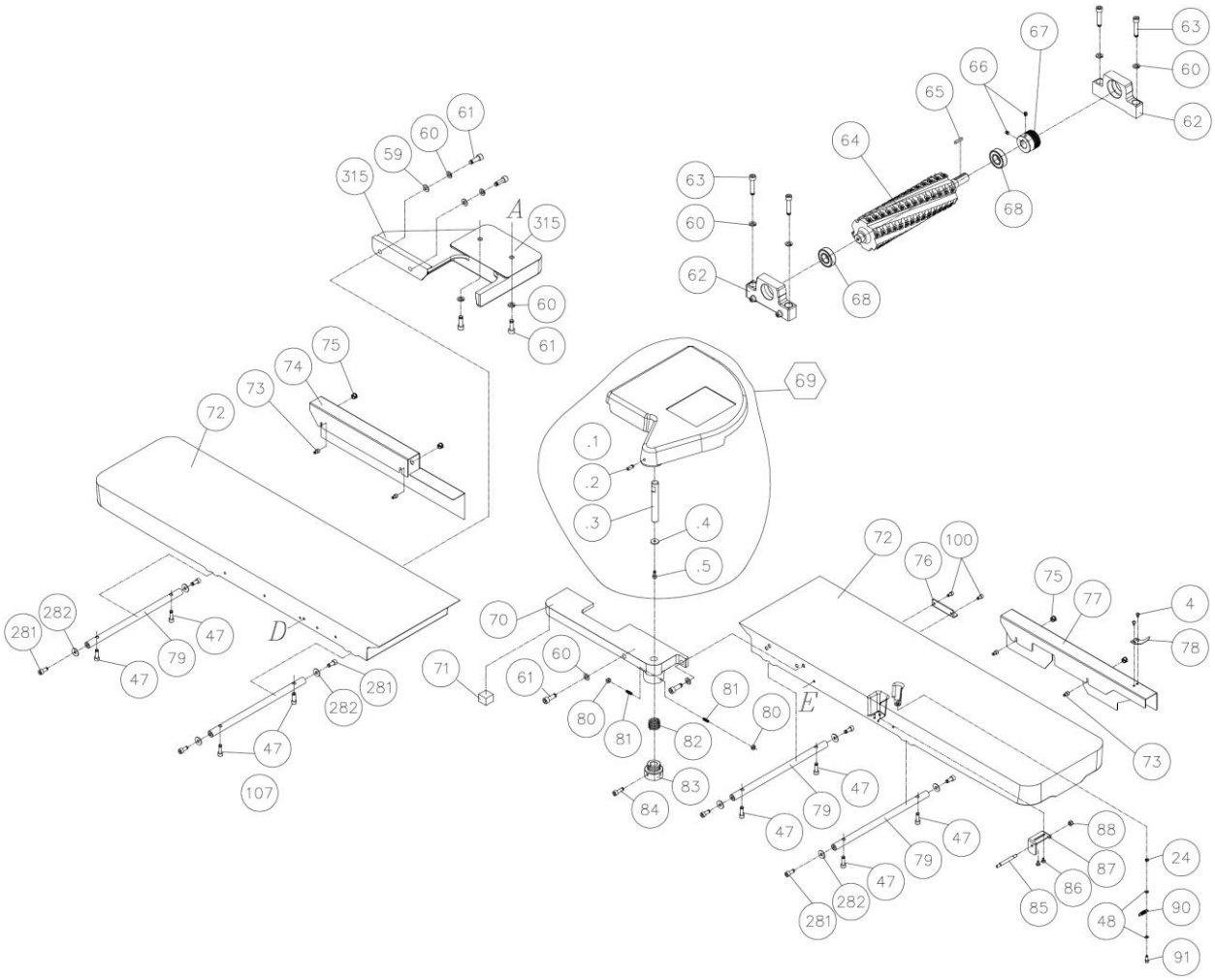
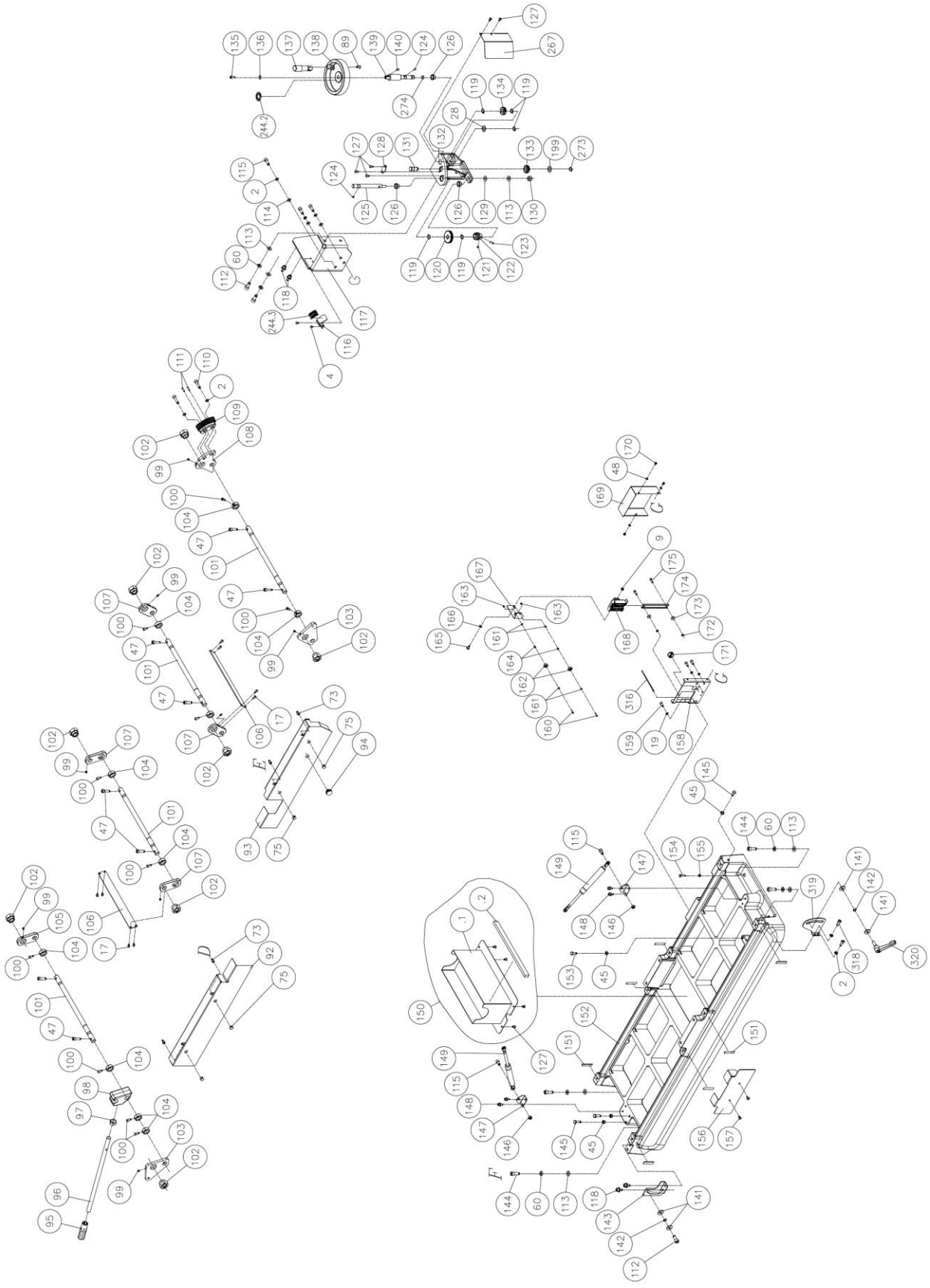


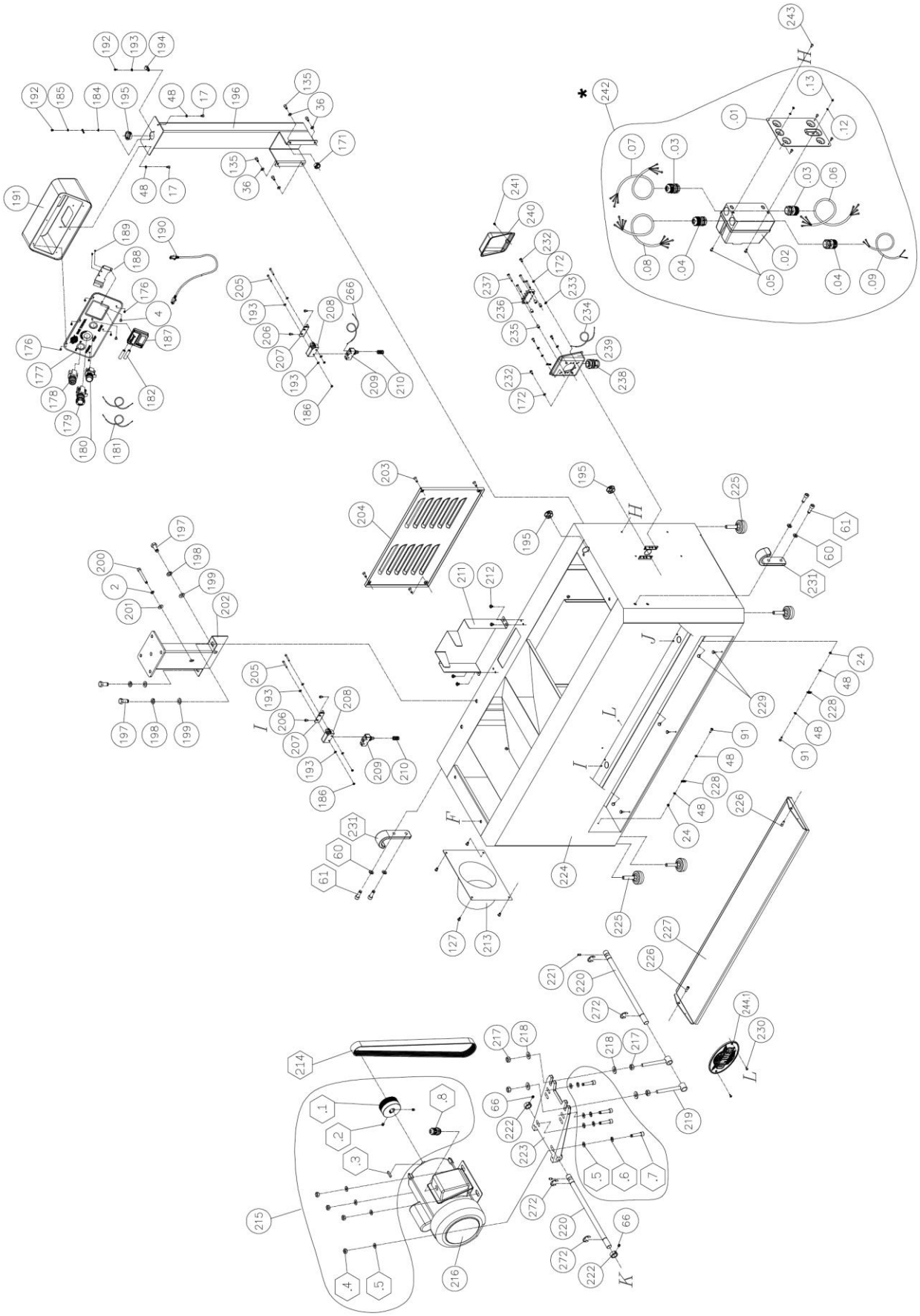
Table and Cutterhead Assembly



Base Assembly



Motor and Cabinet



Key	Part Number	Descriptions	QTY
2	006305-100	Spring Washer 8.2*13.7	9
4	000804-101	Flat Head Cap Screw M5*0.8P*8	6
9	008304-800	Lock Nut M6*1.0P(10B*7H)	1
17	000102-103	Cap Screw M5*0.8P*10	10
19	006303-100	Spring Washer 6.5*10.5	3
24	008004-100	Hex. Nut M5*0.8P(8B*4H)	3
28	006001-125	Flat Waher 15.5*25*2.5t	1
36	006011-023	Flat Washer 6.3*13*2.0t	4
44	000003-108	Hex Screw M8*1.25P*40	2
45	008006-100	Hex Nut M8*1.25P(13B*6.5H)	7
47	000104-110	Cap Screw M8*1.25P*30	16
48	006001-009	Flat Washer 5.2*10*1.0t	11
59	006001-068	Flat Washer 10*20*2.0t	2
60	006307-100	Spring Washer 10.2*18.5	21
61	000105-103	Cap Screw M10*1.5P*30	9
62	051400-902	Bearing Housing	2
63	000105-107	Cap Screw M10*1.5P*50	4
64	923748-001	Helical Cutterhead Assembly 6 Slots	1
64*	038201-101	Torx Screw #10-32UNF*1/2”	10
64*	040702-000	Torx Screwdriver T-25	2
64*	922223-001	Inserts Sold in Packs of 10	1
65	012004-002	Key 6*6*30	1
66	001903-105	Set Lock Screw M8*1.25P*8	4
67	381072-902	Cutterhead Pulley	1
68	030209-002	Ball Bearing 6205	2
69	922158-001	Cutterhead Guard Assembly	1
69.1	300135-000	Cutterhead Guard	1
69.2	000204-105	Set Screw M8*1.25P*20	1
69.3	361437-901	Guard Pivot Shaft	1
69.4	006001-021	Flat Washer 6.2*22*3t	1
69.5	000103-105	Cap Screw M6*1.0P*15	1
70	051183-000	Rabbeting Table	1
71	200105-615	Sponge 30*30*22(L*W*H)	1
72	051395-000	Table (infeed or outfeed)	2
73	000103-102	Cap Screw M6*1.0P*10	8
74	174645-000	Rear Cover (Left)	1

Key	Part Number	Descriptions	QTY
75	042505-000	Plug HP-13	8
76	175339-000	Position Bracket	1
77	174646-000	Rear Cover (Right)	1
78	174649-156	Scale Pointer	1
79	361298-901	Table Shaft	4
80	009004-100	Hex Nut 1/4”-20NC(11B*5.5H)	2
81	230275-000	Set Screw 1/4"-20NC*3/4"	2
82	280165-000	Torsion Spring	1
83	380825-901	Knob	1
84	000104-708	Cap Screw M8*1.25P*25	1
85	361336-902	Round Standoff	1
86	290028-901	Shoulder Screw	2
87	174655-902	Position Plate	1
88	009103-100	Lock Nut 1/4”-20NC(11B*8H)	1
89	000702-104	Socket Flat Head Hex Screw M6*1.0P*16	1
90	280082-000	Torsion Spring	1
91	000102-116	Cap Screw M5*0.8P*15	3
92	174644-127	Front Cover (Left)	1
93	175313-127	Front Cover (Right)	1
94	230156-615	Knob	1
95	250496-615	Handle	1
96	361300-902	Rod	1
97	008011-100	Hex Nut M16*2.0P(24B*13H)	1
98	051401-902	Elevation Bracket	1
99	001902-102	Set Lock Screw M6*1.0P*8	8
100	002602-101	Cap Lock Screw M6*1.0P*12	12
101	361335-901	Shaft	4
102	381392-902	Eccentric Bushing	8
103	174513-904	Shaft Plate	2
104	381393-902	Bushing	10
105	174512-904	Shaft Plate	1
106	174639-000	Plate	2
107	174650-904	Shaft Plate	4
108	174515-904	Shaft Plate	1
109	070070-902	Toothed Bracket	1

Key	Part Number	Descriptions	QTY
110	000104-111	Cap Screw M8*1.25P*35	2
111	011103-103	Taper Pin 5.0*20	2
112	000105-102	Cap Screw M10*1.5P*25	3
113	006001-075	Flat Washer 10.3*22*2.0t	7
114	006001-038	Flat Washer 8*16*1.6t	3
115	000104-106	Cap Screw M8*1.25P*20	5
116	174656-904	Scale Seat	1
117	174516-904	Position Bracket	1
118	001501-101	Cap Screw w/Spring Washer& Flat Washer M8*1.25P*20/8.2*15.4/8.5*19*2t	4
119	010006-000	S-Ring STW-15	5
120	320398-000	Gear 50T	1
121	000203-101	Set Screw M6*1.0P*6	3
122	361301-902	Worm Gear	1
123	011003-114	Spring Pin 5*20	1
124	012003-001	Key 5*5*8	2
125	361302-902	Position Shaft	1
126	330067-000	Bushing	3
127	000801-101	Flat Head Cap Screw M6*1.0P*10	15
128	174518-901	Plate	1
129	006004-070	Flat Washer 10*22*0.8t	1
130	008308-100	Lock Nut M10*1.5P(17B*12H)	1
131	381469-902	Position Bolt	1
132	051407-902	Bracket	1
133	320413-000	Gear 30T	1
134	320397-000	Gear 30T	1
135	000103-103	Cap Screw M6*1.0P*12	5
136	006001-025	Flat Washer 6.4*16*1.0t	1
137	230284-000	Folding Handle	1
138	090392-000	Hand Wheel Chrome	1
139	361395-902	Handwheel Shaft	1
140	012002-006	Key 4*4*16	1
141	006001-071	Flat Washer 10*25*3.0t	6
142	006703-100	Wavy Washer WW-10	2
143	174514-904	Outfeed Table Lock Plate	1
144	000105-105	Cap Screw M10*1.5P*40	4

Key	Part Number	Descriptions	QTY
145	000003-105	Hex Screw M8*1.25P*25	3
146	008306-100	Lock Nut M8*1.25P(13B*9H)	2
147	174653-901	Bracket	2
148	001502-102	Cap Screw w/Spring Washer& Flat Washer M6*1.0P*16/6.5*10.5/6.3*13*1.0t	4
149	660292-000	Hydraulic Cylinder	2
150	924666-001	Dust Cover Assembly	1
150.01	174654-008	Dust Cover	1
150.02	200106-615	Sponge	1
151	200024-615	Vibration Absorbing Pad	7
152	051430-000	Base	1
153	000003-106	Hex Screw M8*1.25P*30	1
154	000002-106	Hex Screw M6*1.0P*30	1
155	008005-100	Hex Nut M6*1.0P(10B*5H)	1
156	174647-127	Cutterhead Front Cover	1
157	000801-104	Flat Head Cap Screw M6*1.0P*20	2
158	174612-308	Digital Readout Position Plate	1
159	000103-106	Cap Screw M6*1.0P*16	3
160	000301-204	Pan Phillips Screw M3*0.5P*15	2
161	006002-139	Flat Washer 3*8*1.0t	4
162	030127-001	Ball Bearing 606	2
163	008315-200	Lock Nut M3*0.5P(5.5B*4H)	2
164	360906-902	Bushing	2
165	000002-101	Hex. Screw M6*1.0P*12	1
166	006001-155	Flat Washer 6*12*1t	1
167	175340-000	Bracket	1
168	491128-000	Sensor WR5501	1
169	174611-308	Cover	1
170	000102-101	Cap Screw M5*0.8P*6	3
171	021801-000	Snap Bushing NB-1722	2
172	006001-131	Flat Washer 5.3*10*2.0t	6
173	006001-181	Flat Washer 5*16*3.0t	2
174	950785-001	Magnetic Strip Assembly	1
175	000102-104	Cap Lock Screw M5*0.8P*12	2
176	000805-101	Flat Head Cap Screw M4*0.7P*6	6
177	574956-000	Switch Panel	1

Key	Part Number	Descriptions	QTY
178	490019-000	Key Switch	1
179	490039-000	Stop Switch	1
180	490040-000	Start Switch	1
181	471037-083	CSA Cable 18AWG*1C*150mm	2
182	490488-000	Battery (local purchase) AAA	2
184	006501-100	Outer Toothed Washer 4.3*8.5(BW-4)	1
185	006002-200	Flat Washer 4.3*8*0.8t	1
186	008002-200	Hex Nut M4*0.7P(7B*3.2H)	4
187	491210-000	Digital Readout WR5502CT	1
188	174750-000	Position Bracket	1
189	001202-602	Self-Tapping Screw M3*1.06P*6	2
190	730139-001	Transmission Cable Cat 5E* RJ-45-CT-A *2000mm	1
191	174770-127	Switch Box	1
192	000302-102	Pan Phillips Screw M4*0.7P*8	2
193	006001-001	Flat Washer 4.3*10*1.0t	11
194	021103-100	Zip Tie ACC-3-B	1
195	021802-000	Snap Bushing NB-2430	3
196	924571-001	Switch Pedestal Assembly	1
197	000005-111	Hex Screw M12*1.75P*30	3
198	006308-100	Spring Washer 12.2*21.6	3
199	006001-136	Flat Washer 12.2*23*2.0t	4
200	000104-117	Cap Screw M8*1.25P*70	1
201	006001-054	Flat Washer 8.5*20*2.0t	1
202	381391-308	Bracket	1
203	000403-104	Pan Phillips Screw M6*1.0P*20	4
204	170479-127	Rear Access Panel	1
205	000101-110	Cap Screw M4*0.7*30	4
206	000102-102	Cap Screw M5*0.8P*8	4
207	174651-000	Bracket	2
208	490229-615	Switch Cover KSSCB-2	2
209	491101-000	Micro Switch MJ2-1307	2
210	280274-000	Spring	2
211	174642-127	Belt Guard	1
212	001603-102	Phillip Head Screw w/Flat Washer M6*1.0P*10/6*13.2*1.0t	4
213	174641-308	Dust Port Hardware Bag for Motor	1

Key	Part Number	Descriptions	QTY
214	014348-000	Poly V-Belt 500J-9	1
215	850912-001	Hardware Bag for Motor	
215.1	381083-902	Motor Pulley	1
215.2	001903-101	Set Lock Screw M8*1.25P*25	2
215.3	013003-001	Key 1/4”*1/4”*1-1/2”	
215.4	008007-100	Hex. Nut M10*1.5P(17B*8H)	4
215.5	006001-068	Flat Washer 10*20*2.0t	8
215.6	006307-100	Spring Washer 10.2*18.5	4
215.7	000105-105	Cap Screw M10*1.5P*40	4
215.8	023701-015	Strain Relief MGB25-18B	
216.1	901345-001	Motor Assembly 5HP 220V 60HZ 1Ph	1
216.1.1	496233-000	Start Capacitor 400MFD/250VAC(SSEC 45*95) 5HP 1Ph	1
216.1.2	496058-000	Run Capacitor 35UF/450VAC(L.C 51*88) 5HP 1Ph	1
216.2	901403-001	Motor Assembly 5HP 220V 60HZ 3Ph	1
217	008009-100	Hex Nut M12*1.75P(19B*10H)	4
218	006001-091	Flat Washer 13*28*3.0t	4
219	380249-901	Adjusting Shaft Assembly	2
220	361303-901	Supporting Shaft	2
221	001902-105	Set Lock Screw M6*1.0P*12	2
222	190074-901	Spacer	2
223	050321-008	Motor Mounting Plate	1
224	174640-127	Stand	1
225	230403-000	Foot	4
226	000103-120	Cap Screw M6*1.0P*15	2
227	174762-156	Emergency Stop Foot Switch	1
228	280050-000	Spring	2
229	340007-615	Rubber Packing	6
230	000401-104	Pan Phillips Screw M4*0.7P*10	2
231	170638-156	Lifting Hook	2
232	000303-804	Pan Phillips Screw M5*0.8P*12	4
233	006502-300	Outer Toothed Washer 5.3*10(BW-5)	2
234	471008-001	CSA Cable 10AWG*1C*153mm	1
235	250573-615	Bushing	4
236	490336-000	Terminal Socket HD-30-A3(600V/40A)	1
237	000303-109	Pan Phillips Screw M5*0.8P*35	4

Key	Part Number	Descriptions	QTY
238	023701-015	Strain Relief MGB25-18B	1
239	491116-008	Junction Box Lower Cover	1
240	490124-008	Junction Box Upper Cover	1
241	003303-102	Pan Phillips Screw 3/16"-24NC*1/4"	1
242.1	938211-001	Switch Assembly 5HP 220V 1Ph	1
242.01	170977-901	Switch Plate	1
242.02	821017-066	Magnetic Switch 5HP 220V 1Ph	1
242*	490295-000	230V Magnetic Contactor MA-30(220V-240V) 5HP 1Ph	1
242*	494310-000	230V Overload RA-20 RA-30(18-26A) 5HP 1Ph	1
242.03	021313-000	Strain Relief MG25A-18B	2
242.04	021377-000	Strain Relief MG25AS-10B	2
242.05	000302-204	Pan Phillips Screw M4*0.7P*12	2
242.06	473005-025	CSA Cable SJT 10AWG*3C*1000mm	1
242.07	473005-026	CSA Cable SJT 10AWG*3C*760mm	1
242.08	474001-013	CSA Cable SJT 18AWG*4C*1550mm	1
242.09	472001-050	CSA Cable SJT 18AWG*2C*2000mm	1
242.09	006301-200	Spring Washer 4.1*7.7	2
242.10	008002-200	Hex. Nut M4*0.7P(7B*3.2H)	2
242.2	938013-001	Switch Assembly 5HP 220V 60HZ 3Ph	1
242.2.01	170977-901	Switch Plate	1
242.2.02	823017-042	Magnetic Switch 5HP 220V 3Ph	1
242.2*	491157-000	230V Magnetic Contactor MA-18(220V-240V) 5HP 3Ph	1
242.2*	494306-000	230V Overload RA-20 RA-20(12-18A) 5HP 3Ph	1
242.2.03	021313-000	Strain Relief MG25A-18B	2
242.2.04	021377-000	Strain Relief MG25AS-10B	2
242.2.05	000302-204	Pan Phillips Screw M4*0.7P*12	2
242.2.06	474005-015	CSA Cable SJT 10AWG*4C*1000mm	1
242.2.07	474005-016	CSA Cable SJT 10AWG*4C*760mm	1
242.2.08	474001-013	CSA Cable SJT 18AWG*4C*1550mm	1
242.2.09	472001-050	CSA Cable SJT 18AWG*2C*2000mm	1
242.2.10	006301-200	Spring Washer 4.1*7.7	2
242.2.11	008002-200	Hex. Nut M4*0.7P(7B*3.2H)	2
246	250035-629	Push Block	2
247	040005-000	Hex. Wrench 5mm	1
248	040006-000	Hex. Wrench 6mm	1

Key	Part Number	Descriptions	QTY
249	040007-000	Hex. Wrench 8*100mm	1
250	040206-000	Open Wrench 17*19	1
266	471037-095	CSA Cable 18AWG*1C*900mm	1
267	174949-904	Cover	1
272	010202-000	E Ring P Type ETW-17	4
273	010003-000	Insert (Sold in Box Of 10) STW-12	1
274	043322-000	Torx Screw P11	1
281	002601-102	CAP Screw M8*1.25P*20	8
282	006001-056	Flat Washer 8.5*23*2.0t	9
283	250462-615	Packing	1
284	000101-103	Cap Screw M4*0.7P*12	4
285	230262-000	Lock Handle	1
286	006002-096	Flat Washer 13.5*32*3.0t	2
287	000004-213	Hex. Screw M10*1.5P*65	1
288	008007-200	Hex. Nut M10*1.5P(17B*8H)	1
289	380832-901	Key	2
290	240080-904	Handwheel	1
291	000203-103	Set Screw M6*1.0P*10	2
292	380827-901	Bushing	1
293	050902-000	Base	1
294	320297-000	Shaft	1
295	250702-615	Cover	1
296	000004-103	Hex. Screw M10*1.5P*30	2
297	381047-905	Rack	1
298	172365-008	Plate	1
299	380830-901	Stop Fence	1
300	380829-901	Collect	1
301	000003-205	Hex. Screw M8*1.25P*25	1
302	360870-901	Fixing Shaft	6
303	050904-000	Sliding Arm - Left	1
304	923660-001	Lead Screw Assembly	1
304.1	380839-901	Lead Screw	1
304.2	008009-100	HEX. NUT M12*1.75P(19B*10H)	1
305	000003-107	Hex. Screw M8*1.25P*35	2
306	000003-104	Hex. Screw M8*1.25P*20	1

Key	Part Number	Descriptions	QTY
307	050903-000	Sliding Arm - Right	1
308	000105-101	Cap Screw M10*1.5P*20	4
309	380828-902	Connect Bolck	2
310	070050-000	Rod	1
311	922152-000	Handle Assembly	1
312	051534-000	Fence Body	1
313	050907-000	Block Depth	1
314	230279-000	Lock Handle	1
315	051536-000	Fence Bracket	1
316	021003-000	Zip Tie ALT-150M	1
318	000104-105	CAP Screw M8*1.25P*18	2
319	175314-904	Right Lock Plate	1
320	230343-000	Lock Handle M10*1.5P*20	1

Spare Parts

Part Number	Descriptions	Specifications	QTY
P-15mm 4S	Insert (Sold in Box Of 10)		10
038201-101	Torx Screw	#10-32UNF*1/2"	10

Maintenance Record

Date	Task	Operator

Notes

Warranty and Service

Oliver Machinery makes every effort to assure that its equipment meets the highest possible standards of quality and durability. All products sold by Oliver Machinery are warranted to the original customer to be free from defects for a period of two (2) years on all parts excluding electronics and motors which are warranted for one (1) year from the date of shipment. Oliver Machinery's obligation under this warranty shall be exclusively limited to repairing or replacing products or parts or components, at its sole option, determined by Oliver Machinery to be defective. Oliver Machinery shall not be required to provide other form of indemnity or compensation including but not limited to compensatory damages.

This warranty does not apply to defects due to direct or indirect misuse, abuse, negligence, accidents, unauthorized repairs, alternation outside our facilities, lack of maintenance, acts of nature, or items that would normally be consumed or require replacement due to normal wear and tear.

OTHER TERMS

To obtain and exercise the warranty right, please call 800-559-5065 or fill out warranty request form online at www.olivermachinery.net.
Warranty parts are shipped via Parcel or Ground. Additional charges will occur and charge to customers if express shipping is required.

DISCLAIMER

Under no circumstances shall Oliver Machinery be liable for death, personal or property injury, or damages arising from the use of its products.

Oliver Machinery reserves the right to make changes without prior notice to its products to improve function or performance or design.

FOR MORE INFORMATION

If you need assistance or have questions beyond what is covered in the scope of this warranty information, please call 800-559-5065 or email us at info@olivermachinery.net.

Appendix

US Standard – Metric Conversion Chart

Fractions	Decimal In.	Millimeters
1/64	.0156	.396
1/32	.0312	.793
3/64	.0469	1.190
1/16	.0625	1.587
5/64	.0781	1.984
3/32	.0937	2.381
7/64	.1094	2.778
1/8	.125	3.175
9/64	.1406	3.571
5/32	.1562	3.968
11/64	.1719	4.365
3/16	.1875	4.762
13/64	.2031	5.159
7/32	.2187	5.556
15/64	.2344	5.953
1/4	.25	6.350
17/64	.2656	6.746
9/32	.2812	7.143
19/64	.2969	7.540
5/16	.3125	7.937
21/64	.3281	8.334
11/32	.3437	8.731
23/64	.3594	9.128
3/8	.375	9.525
25/64	.3906	9.921
13/32	.4062	10.318
27/64	.4219	10.715
7/16	.4375	11.112
29/64	.4531	11.509
15/32	.4687	11.906
31/64	.4844	12.303
1/2	.5	12.700

Fractions	Decimals In.	Millimeters
33/64	.5156	13.096
17/32	.5312	13.493
35/64	.5469	13.890
9/16	.5625	14.287
37/64	.5781	14.684
19/32	.5937	15.081
39/64	.6094	15.478
5/8	.625	15.875
41/64	.6406	16.271
21/32	.6562	16.668
43/64	.6719	17.065
11/16	.6875	17.462
45/64	.7031	17.859
23/32	.7187	18.256
47/64	.7344	18.653
3/4	.75	19.050
49/64	.7656	19.446
25/32	.7812	19.843
51/64	.7969	20.240
13/16	.8125	20.637
53/64	.8281	21.034
27/32	.8437	21.431
55/64	.8594	21.828
7/8	.875	22.225
57/64	.8906	22.621
29/32	.9062	23.018
59/64	.9219	23.415
15/16	.9375	23.812
61/64	.9531	24.209
31/32	.9687	24.606
63/64	.9844	25.003
1.0	1.	25.400

Oliver Machinery is always adding new Industrial Woodworking products to the line.

For complete, up-to-date product information, visit us online at:

WWW.OLIVERMACHINERY.NET

or call toll-free 1-800-559-5065

** SAVE THIS MANUAL FOR FUTURE REFERENCE. **