

10.0 Operation

Important: Before operating the jointer, make sure all knives or knife inserts are seated and secure in the cutterhead.

If you are inexperienced at jointing, use scrap pieces of lumber to check settings and get the feel of operations before attempting regular work.

Stabilize long workpieces by using an assistant, or roller stands set level with the outfeed or infeed table surface.

The fence should be adjusted to create minimum exposure to the cutterhead during the jointing operation.

Check the following before operating the jointer:

- ❑ Outfeed table must be set level with the high point of the knives or knife inserts.
- ❑ Fence adjusted for minimum exposure of cutterhead, and locked at desired angle.
- ❑ The cutterhead guard must be in place and operating properly (except when rabbeting).
- ❑ Infeed table set for desired depth of cut.
- ❑ Stand away from the cutterhead and turn the machine on for a few moments. Listen for any odd noises, rubbings, vibrations, etc. Correct such problems before attempting operations on the jointer.
- ❑ Carefully check your workpiece for knots, holes, staples or any foreign material that might damage knives or pose a risk of kickback. Also check the workpiece for grain orientation.

10.1 Hand placement

⚠WARNING Never pass hands directly over the cutterhead.

At the start of the cut, the left hand holds the workpiece firmly against the infeed table and fence while the right hand pushes the workpiece in a smooth, even motion toward the cutterhead (Figure 10-1). After the cut is under way, the new surface rests firmly on the outfeed table. The left hand is transferred to the outfeed side and presses down on this part of the workpiece, at the same time maintaining flat contact with the fence. The right hand presses the workpiece forward and before the right hand reaches the cutterhead it should be moved to the work on the outfeed table.



Figure 10-1

10.2 Surfacing

⚠WARNING Always use a hold down or push block when surfacing stock.

Surfacing, or jointing the face of stock, is shown in Figure 10-2. Adjust the infeed table for depth of cut. Cuts of approximately 1/16" at a time are recommended, as this allows better control over the material being surfaced. More passes can then be made to reach the desired depth.

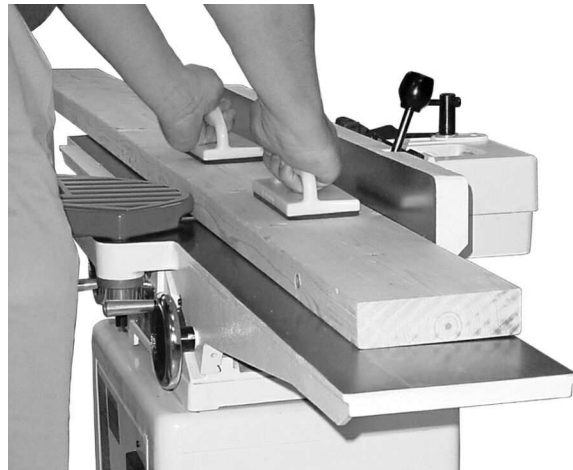


Figure 10-2

10.3 Edge jointing

Edge Jointing (Figure 10-3) is the most common operation for the jointer. Set fence square with the table. Depth of cut should be the minimum required to obtain a straight edge. Do not make cuts deeper than 1/8" in a single pass. Hold the best face of the workpiece firmly against the fence throughout the feed.



Figure 10-3

10.4 Rabbeting

A rabbet is a groove cut along the edge of a board. See Figure 10-4. The width and thickness of the wood to be rabbeted depends upon the width and length of the rabbet. However, never rabbet a piece of wood less than 12" long.

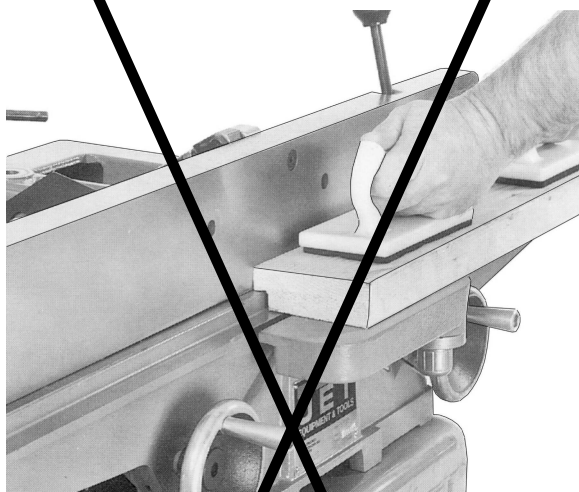


Figure 10-4

Note: The knives must be extended beyond the cutterhead by 1/32". See the *Setting Knives for Rabbeting and Nicks* section on page 20 for this procedure.

WARNING A rabbet cut requires removal of the guard. Use extreme caution and keep hands clear of cutterhead. Always re-install guard immediately after rabbeting operation is completed.

Use push blocks to rabbet cut whenever possible. The rabbeting capacity is 1/2".

1. Disconnect jointer from power source.
2. Set fence for desired width of rabbet.

3. Check width of the rabbet by measuring the distance from the end of a knife in the cutterhead to the fence.
4. Re-connect power. It is easier and safer to take a series of shallow cuts. Lower the infeed table 1/32" at a time and make successive cuts until the desired depth of rabbet has been obtained. See Figure 10-4.

10.5 Jointing short or thin work

When jointing short or thin work pieces, use a push block to eliminate all danger to the hands. Two push blocks are shipped with your jointer. You can also make your own easily from scrap material. Examples are shown in Figure 10-5.

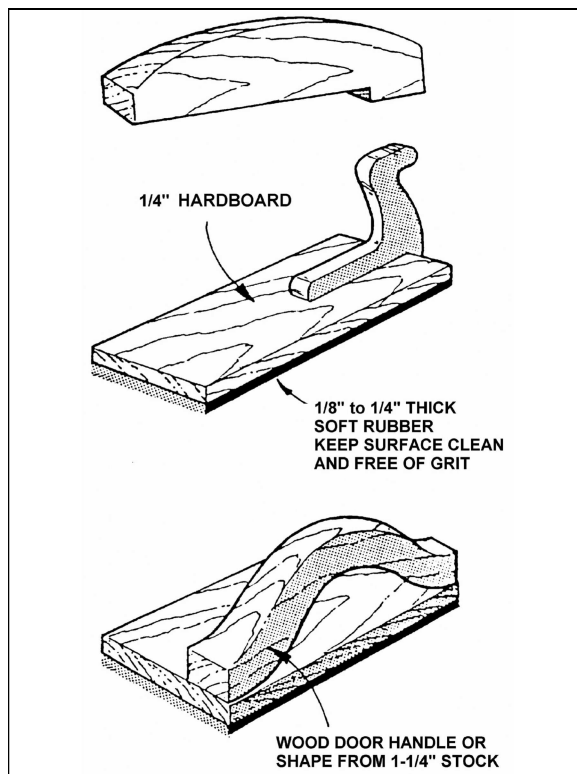


Figure 10-5

10.6 Jointing warped surfaces

If the wood to be jointed is cupped or bowed, place the concave side down, and take light cuts until the surface is flat.

Avoid forcing such material down against the table – excessive pressure will spring it while passing the knives, and it will spring back and remain curved after the cut is completed.

10.7 Beveling

To cut a bevel, lock the fence at the required angle and run the work piece across the knives while keeping it firmly against the fence and tables. Several passes may be necessary to achieve the desired result.

CAUTION Although the fence may be tilted in or out for a bevel cut, it is recommended for safety reasons that the fence be tilted in toward the operator, making a cradled cut.

10.8 Direction of grain

Avoid feeding work into the jointer against the grain. This may result in chipped and splintered edges. See Figure 10-6. Feed *with* the grain to obtain a smooth surface, as shown in Figure 10-7.

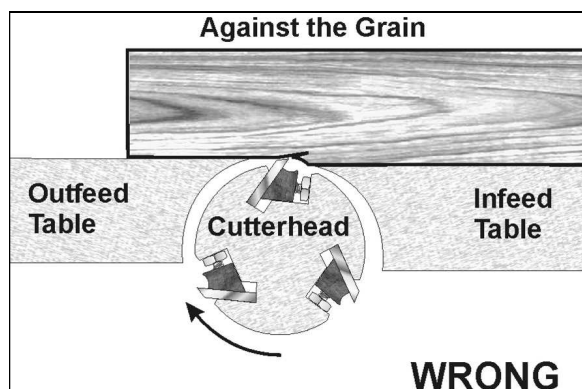


Figure 10-6

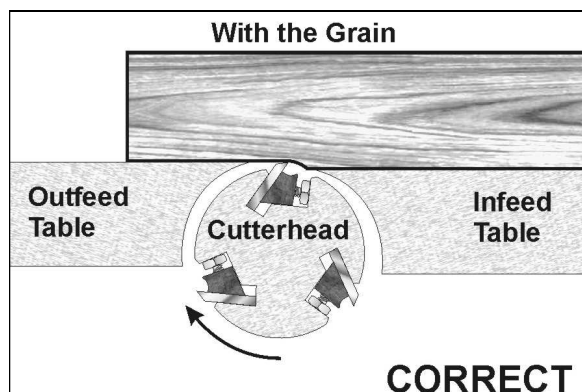


Figure 10-7

11.0 Maintenance

11.1 Blade care

WARNING Blades are extremely sharp. Use caution when cleaning or changing. Failure to comply may cause serious injury.

When gum and pitch collect on the blades, carefully remove with a strong solvent. Failure to remove gum and pitch build-up may result in excessive friction, blade wear and overheating.

When blades become dull, replace them.

11.2 Cutterhead removal

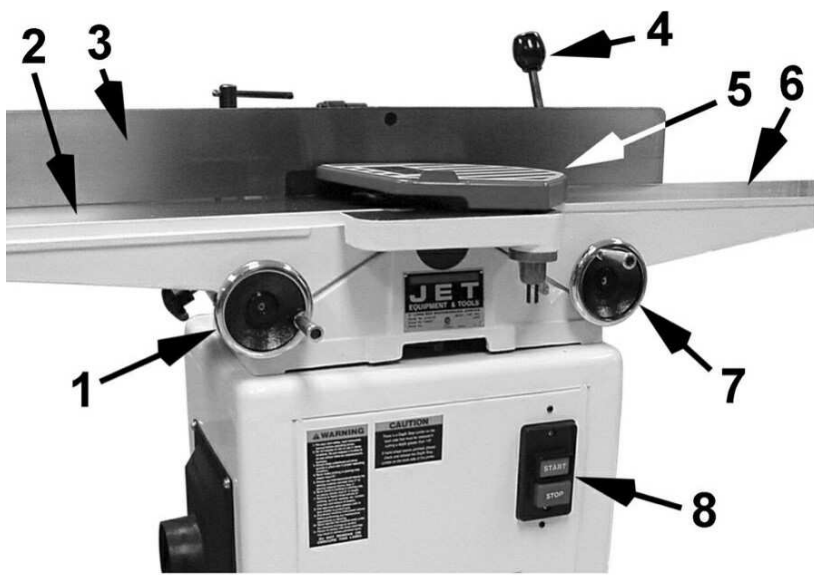
The entire cutterhead assembly may be removed for clearing or for bearing and blade replacement. Some woodworkers keep a spare cutterhead with replacement blades should the original cutterhead have to be repaired.

WARNING Blades in the cutterhead are sharp. Use extreme caution when handling the removal of the cutterhead. Failure to comply may cause serious injury.

To remove the cutterhead (including bearings, studs, and housing) from the base casting:

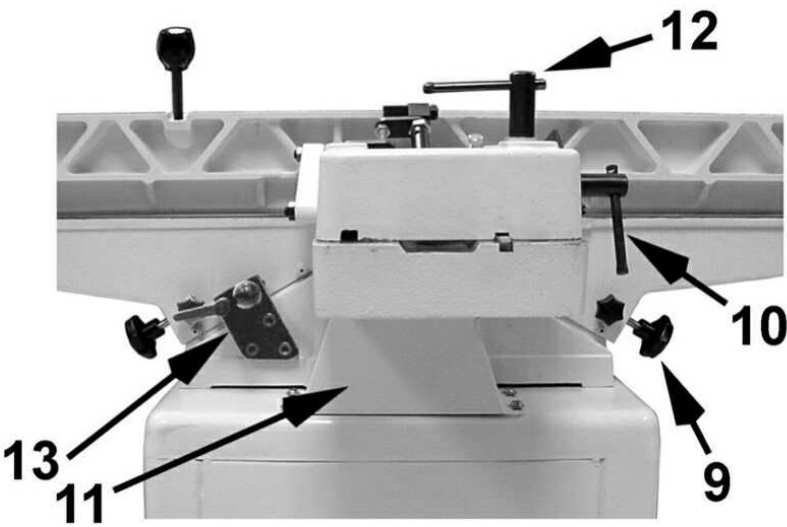
Refer to Figure 10-8:

1. Disconnect the machine from the power source.
2. Remove the front *blade guard* (A) and screw (H).
3. Remove the *lock handle* (B), *washer* (C) and *lock nut* (D) securing the *fence assembly* (E) to the *table* (F).
4. Lift the *fence assembly* (E) from the table.
5. From the left side of the stand, remove the *dust chute* (G). From the back of the machine remove the *cabinet access cover* (not shown).



Front

1. Outfeed handwheel
2. Outfeed table
3. Fence
4. Fence handle
5. Cutter guard
6. Infeed table
7. Infeed handwheel
8. On/Off switch
9. Table lock knob
10. Fence tilt lock
11. Belt guard
12. Fence travel lock
13. Depth limiter



Back