

HOME CRAFT SHAPER

Operating and Maintenance Instructions

The Homecraft Shaper No. 43-110 is furnished complete with fence, 5/16" and 1/2" standard spindles, table insert, starting pin, belt guard, motor bracket and 2 15/32" spindle pulley, assembled. The motor must be purchased separately to suit available electric current and meet the customer's power requirements. Refer to the detailed drawing on page 3.

Complete directions for mounting and maintaining the machine are contained in these instructions. Complete information, hints and suggestions, about the accessories and their uses in special operations are contained in our illustrated handbook No. 4535, "Getting the Most Out of Your Shaper." Send in the pink card with the requested information, to secure your free copy.

MOTOR, PULLEYS AND BELT

Use a constant speed motor of 1/2 hp or greater capacity which will develop sufficient power for all shaper operations. Operating on 60-cycle current will develop a spindle speed of 9000 rpm. On 50-cycle current a spindle speed of 7500 rpm will be developed. A 5 3/8-inch motor pulley (specify 1/2 or 3/4-inch bore) is used in conjunction with the 2-15/32-inch spindle pulley furnished with the machine.

V-belt No. 49-105 has an outside circumference of 30-inches, and is of the correct length for use with 6-inch frame motors. Use a No. 49-106 belt, which is 32-inches long, when using an 8 1/2-inch frame motor.

SWITCH AND POWER CONNECTIONS

Before connecting the motor to the power line, be sure that the electric current is of the same characteristics as stamped on the motor name plate.

Do not connect the motor to a circuit which will be overloaded. When using an extension cord be sure it is of sufficient capacity. The large black and yellow motor leads are from the running coils, and the small red and green leads are from the starting coils. Refer to Fig. 1 when connecting the reversing switch to the motor.

Repulsion start-induction run Marathon motors are reversed by shifting the positions of the brushes. The brush holder ring beneath the cover plate on the front motor bracket has three marks on it one marked R, the center one plain, and the other marked L. The lines marked R and L are to coincide with a mark on the motor bracket. To reverse motor, shift the reversing handle completely to one side or the other in order to obtain full starting torque.

If no reversing switch is used, connect one line lead to black and green and the other line to yellow and red for clockwise rotation. For counter clockwise rotation, connect one line lead to black and red and the other line to yellow and green. Refer to Fig. 2

for connecting "On and Off" switch. Two holes must be drilled in rear of switch box for installation.

MOUNTING SHAPER

The shaper is packed in a single carton with legs, table insert, spindle sleeve, height raising mechanism and clamping device assembled. Motor bracket, fence and belt guard are included in the same carton. The spindles, guide pin, wrenches, bolts, nuts and other small parts are in a cloth bag.

Mount the machine on a stand or bench of such height that the shaper table will be approximately 34-inches from the floor level. Most operators will find this a convenient height.

Bolt the machine to the stand or bench top using 5/16-inch carriage bolts of proper length through the mounting holes in the legs.

Suspend the motor bracket from the rear of the table support, using the two hexagon head cap screws SP-672, through the slots in the casting. Mount motor on bracket and bolt in place. Align motor and spindle pulley and place belt on machine. Avoid excessive belt tension which would reduce the life of the belt and bearings. The correct tension is such that the belt can be flexed about 1/2-inch midway between the pulleys, using finger pressure. Refer to the drawing on page 3.

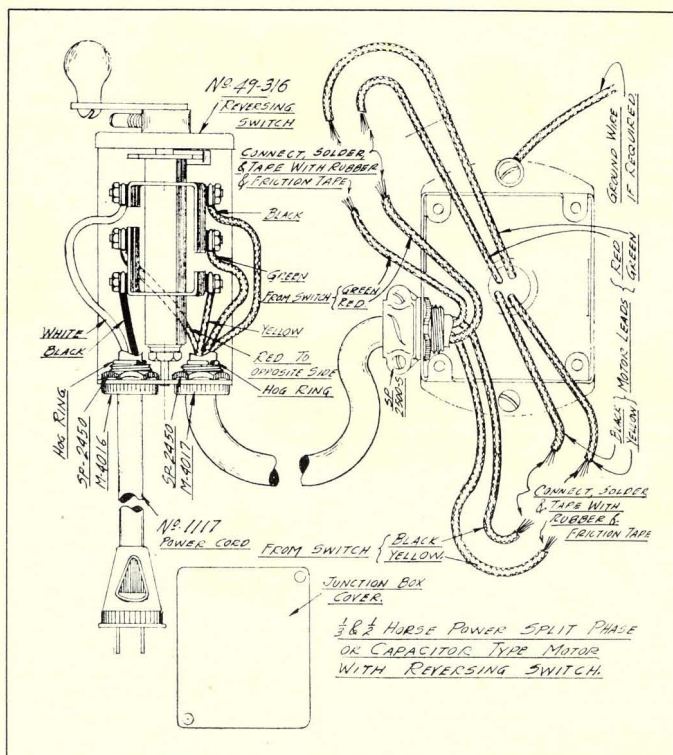


Fig. 1.

LUBRICATION

The spindle runs in sealed ball bearings which require no lubrication. Occasionally place a small amount of oil on the outside of the hollow spindle sleeve to allow free movement of the height adjustment. Wipe all bright surfaces with an oily cloth to prevent rusting.

Table 1. REPLACEMENT PARTS

IMPORTANT:

Give both the Part Number and the Description of each item when ordering from this list; also the Serial Number of the machine on which the parts are to be used.

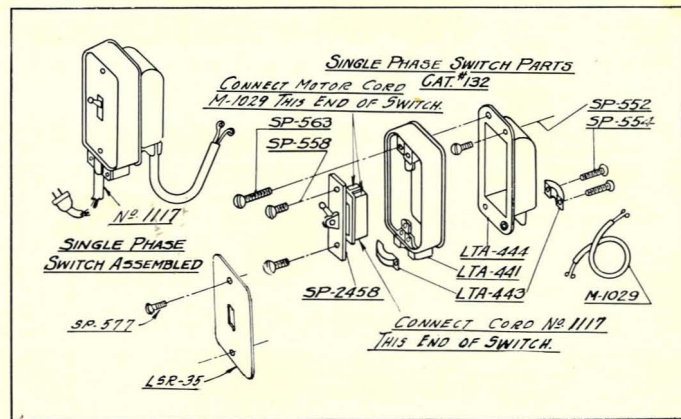
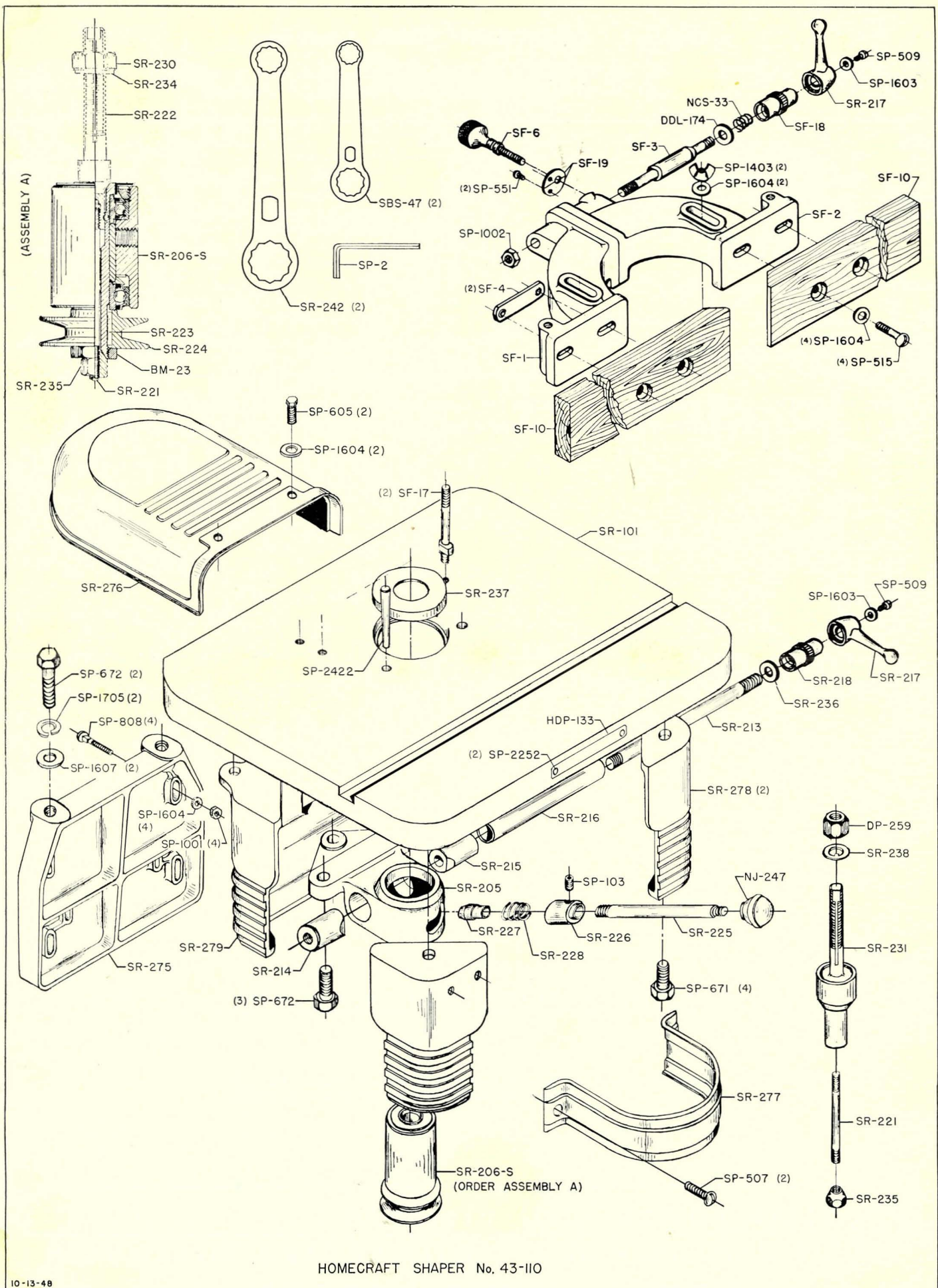


Fig. 2.

Part No.	Description	No. Req.	Part No.	Description	No. Req.
TABLE					
HDP-133	Name Plate, 11/16 x 4 3/4"	1	SR-226	Spring Retaining Collar, Tapped 5/16"-18	1
SR-101	Table, 15 1/2 x 18", with 3/8 x 3/4" Miter Gage Groove	1	SR-227	Bearing Cone, .434" I.D., 3/4" O.D. x 1-1/32" Long	1
SR-237	Table Insert, 1 3/8" I.D., 3" O.D. x 3/8" Thick	1	SR-228	Coil Spring, 3/4" Diameter, 3/4" Free Length, Flat Ends	1
SR-278	Table Leg, Front	2	SR-236	Steel Bushing, 33/64" I.D., 7/8" O.D. x 1/4" Thick, with Shoulder	1
SR-279	Table Support, Rear, with Integral Motor Plate and Guard Mounting Plate	1	SP-103	5/16-18 x 1/4" Headless Set Screw, Cup Point	1
SP-371	1/2-20 x 1" Hexagon Head Cap Screw	4	SP-509	1/4-20 x 1/2" Round Head Machine Screw	1
SP-2252	#2 x 3/16" Drive Screw	2	SP-672	1/2-20 x 1 1/4" Hexagon Head Cap Screw	3
SP-2422	#6 x 2 3/4" Taper Pin	1	SP-1603	1/4" Steel Washer, 9/16" O.D. x 3/64" Thick	1
SPINDLES					
BM-23	Special .679"-28 Hex. Jam Nut, 17/64" Thick, Right Hand Thread	1	MOTOR-BRACKET AND GUARD		
DP-259	Special 5/16"-24 Hex. Nut, 7/16" Thick	1	SR-275	Motor Mounting Plate, 7 5/8 x 9"	1
SR-206-S	Spindle Sleeve, with Bearings, Spacers, Housing and 2 15/32" Pulley, Assembled	1	SR-276	Belt Guard	1
SR-221	Tie Rod, .228 x 4-1/16", 1/4"-28 Thread Both Ends, for Cutter Spindle	2	SR-277	Spindle Pulley Guard	1
SR-222	1/2" Cutter Spindle, 4 3/4" long, 1/2"-16 Acme Thread ..	1	SP-507	5/16-18 x 3/4" Round Head Machine Screw	2
SR-222-S	1/2" Cutter Spindle, with Keyed Washer and Hexagon Nut	1	SP-605	5/16-18 x 1/2" Hexagon Head Cap Screws	2
SR-223	Steel Pin, 3/32 x 7/8", Tapered Ends	1	SP-672	1/4-20 x 1 1/4" Hexagon Head Cap Screw	2
SR-224	2 15/32" Spindle Pulley, .670" Bore, with Keyway	1	SP-808	5/16-18 x 1" Carriage Bolt	4
SR-230	Special 1/2"-16 Hexagon Nut, 7/16" Thick, Acme Thread ..	1	SP-1001	5/16-18 Hexagon Jam Nut	4
SR-231	5/16" Cutter Spindle, 3 5/8" Long, 5/16"-24 Acme Thread ..	1	SP-1604	5/16" Steel Washer, 3/4" O.D. x 1/16" Thick	6
SR-231-S	5/16" Cutter Spindle, with Keyed Washer and Hexagon Nut	1	SP-1607	1/2" Steel Washer, 1 1/4" O.D. x 5/64" Thick	2
SR-234	Special 1/2" Keyed Lockwasher, 7/8" O.D. x 5/64" Thick ..	1	SP-1705	1/2" Split Lockwasher, 7/8" O.D. x 1/8" Thick	2
SR-235	Special 1/4"-28 Hexagon Nut, 9/16" Thick, Cone Face ..	1	FENCE		
SR-238	Special 5/16" Keyed Lockwasher, 1/2" O.D. x .050" Thick	1	SF-1	Fence Body, Left Half, Casting Only	1
When new bearings or other parts are required, order complete cartridge SR-206-S, or send the old one to the factory for repairs. This is advisable because of the close fit of the parts and the preload on the bearings.					
SPINDLE HEIGHT ADJUSTMENT AND CLAMPING MECHANISM					
NJ-247	Handle Ball, 1 1/2" Diameter, with 3/8"-24 Tapped Hole ..	1	SF-1-S	Shaper Fence Body, Assembled, Less Wooden Face Plates and Mounting Parts	1
SR-205	Bracket for Spindle Housing	1	SF-2	Fence Body, Right Half, Casting Only	1
SR-205-R	Bracket, with Spindle Sleeve Assembly, Height Adjustment and Clamp, without Cutter Spindle	1	SF-3	Clamp Stud, 3/4 x 6-7/16", 7/16"-14 Thread Both Ends, 3/8"-16 Slide Hole	1
SR-213	Stud, 1/2-13 x 10 3/8", Threaded Both Ends	1	SF-4	Clamp Plate, 3/16 x 3/4 x 3 1/8", with Two 5/16"-18 Tapped Holes	2
SR-214	Spindle Height Clamp Sleeve, Left, Tapped 1/2"-13, Steel	1	SF-6	Knurled Adjusting Screw, 3/8-16 x 2 3/8", with Grooved Shoulder	1
SR-215	Spindle Height Clamp Sleeve, Right, with Shoulder, Steel	1	SF-10	Wooden Face Plate, 13/16 x 2 3/4 x 11 3/8 Inches	2
SR-216	Spacing Sleeve, 3/4" I.D., 7/8" O.D. x 6 1/8" Long	1	SF-17	Clamp Stud, 3 1/4" Long, 5/16"-18 and 5/16"-24 Threaded Ends, with 3/8 x 9/16 Inch Shoulder for Wrench ...	2
SR-217	Ball-End Adjustable Clamp Handle, Serrated Bore	1	SF-18	7/16"-14 Serrated Nut, 1/4"-20 Tapped Head	1
SR-218	1/2"-13 Serrated Nut, 1/4"-20 Tapped Head	1	SF-18-S	7/16"-14 Serrated Nut, with adjustable Clamp Handle, Assembled	1
SR-225	Stud, 7/16 x 5-27/32", 3/8"-24 and 1/8" Pipe Threaded Ends	1	SF-19	Half Collar, 1 1/8" Diameter, 5/64" Thick for Adjusting Screw	2
			SR-217	Ball-End Adjustable Clamp Handle, Serrated Bore	1
			SP-509	1/4-20 x 1/2" Round Head Machine Screw	1
			SP-515	5/16-18 x 1 1/4" Round Head Machine Screw	4
			SP-551	#10-32 x 1/4" Round Head Machine Screw	2
			SP-1002	7/16"-14 Hexagon Jam Nut	1
			SP-1403	5/16"-18 Wing Nut	2
			SP-1603	1/4" Steel Washer	1
			SP-1604	5/16" Steel Washer, 3/4" O.D. x 1/16" Thk.	6
			NCS-33	Coil Spring, 37/64" Dia. 1/2" Free Length, Flat Ends ..	1
			DDL-174	Special 29/64" Steel Washer, 1" O.D. x 1/8" Thick ...	1

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Homecraft Shaper No. 43-110

Fig. 3.

Table 1. REPLACEMENT PARTS (Continued)

IMPORTANT: Give both the Part Number and the Description of each item when ordering from this list; also the Serial Number of the machine on which the parts are to be used.

Part No.	Description	No. Req.	Part No.	Description	No. Req.
ACCESSORIES					
SBS-47	Double End 7/16 and 9/16" Hex. Box Wrench		987	Safety Ring Guard Attachment	
SP-2	5/32" Hex. Wrench for Socket Screws		1186	Sliding Shaper Jig	
SR-242	Double End 9/16 and 7/8" Hex. Box Wrench 3/8" Slot ...		1190	Stub Spindle for 3 Lip Cutters with 1/2" Hole	
SR-253	Special Table Insert 2 1/8" I.D. 3" O.D. with 2 3/8" Dia. Guide Shoulder		43-803	5 3/8" Motor Pulley, 1/2" Bore, with Set Screws	
SR-254	Special Table Insert 1 3/8" I.D. 3" O.D. with 1 5/8" Dia. Guide Shoulder		43-804	5 3/8" Motor Pulley, 3/4" Bore, with Key and Set Screws ..	
873	Additional Clamp Screw with Block for Sliding Jig		49-105	V-Belt, 30" O.C.	
982	Shaper Fence		49-106	V-Belt, 32" O.C.	
983	Spring Type Holddown Attachment		49-305	Steel Stand, 26 1/2" High, 12-7/16" x 16-7/16" Top	
			49-316	Reversing Switch	
			Refer to the catalog for complete listing of various collars, cutters and knives, which are available in sets, or individually.		

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