INSTRUCTIONS for ASSEMBLING OPERATING MAINTAINING

DURO TOOLS

MODEL D3034

5" JOINTER

ASSEMBLING INSTRUCTIONS

Please read the assembling instructions before attempting final assembly.

1. Remove from the carton and paper wrappings all items to be used to complete the assembly.

2. The jointer fence post which is 8-3/8" long is to be inserted in hole on side of jointer with the V slot up. Turn jointer on side or upside down and tighten hollow head set screw into the recessed groove in the post.

3. Fence and operating parts are assembled and unit is ready to slip onto fence post. Be certain the locking handle does not protrude through tapped hole, then slide entire assembly onto fence post.

4. MOTOR: 5/8" Shaft

   A. USE:

   1. A 340500 (5") V Pulley and a 360246 (46") V Belt with our 3910 SEBC 1/3 H.P. 1725 RPM Motor.

   2. A 340250 (2-1/2") V Pulley and a 360242 (42") V Belt with a 3450 RPM Motor.

   3. Belts referred to above when using our steel stand.

   4. Our 3161 Steel Stand for convenient and practical mounting of tool and motor. NOT TOO MUCH TENSION ON BELT.

   B. WIRING DIRECTIONS:

   1. Wire motor to switch following directions on plate or tag.

   2. Cutter blade must run toward front. For instructions on reversing of motor see plate or tag.

   Our 3910 SEBC 1/3 H.P. Motor is sufficiently powerful for average work.

OPERATING INFORMATION

1. Fence may be moved across table by loosening fence lock handle.

2. Fence may be tilted by loosening tilting lock handle and two wing nuts.

3. Loosen lock handle at left front side of jointer. Ball crank under the front table lowers or raises table to secure desired depth of cut.

4. JOINTING:

   A. Jointing is the operation of truing up the edges of boards so that they may be joined together by applying glue, thereby giving greater widths of lumber, or of truing edges for angle joints, or for smoothing wood for other purposes.

   B. If the edges of the boards to be jointed are quite irregular, it is wise to pass them thru a band or rip saw and finish on the jointer.

   C. "JOINTING" can be mastered in a short time if "DIRECTIONS" are followed carefully. Lumber which reaches the jointer with a fairly smooth edge should be ready for gluing after one or two passes over the jointer head. Rough or irregular lumber will require many passes.

   When ready to joint, lower the front table to desired depth and lock (DO NOT LOWER THE REAR TABLE EXCEPT WHEN REPLACING BEARINGS OR CUTTER HEAD.) Lock the fence in the desired position, then turn on the motor. Place the material on the front table, with the left hand press the work down and against the face of the fence. Use the right hand to feed the wood to the cutter head. As soon as sufficient stock has been cut off, so that the front end of the board rests on the rear table, transfer the pressure of the left hand to that part of the work now on the rear table, but continue to feed the work with the right hand.

   D. When greater section of the lumber has been jointed, the right hand should also be on the rear table, exerting downward pressure. This method will keep the cut true at all times. Once you start to pass the wood across the cutter head, do not stop, otherwise you may have scalloped or rough edges. It is wiser to feed the work into the cutter head with the grain rather than against the grain.

   E. When jointing across the grain take very light cuts. Set the jointer not over 1/16 of an inch deep, as deeper cuts may tear the grain. Start jointing and cut into the width about 1/2" at one edge, then reverse the piece and go straight across. Be certain that when you reach the

section already cut that all of your down pressure is on the wood now on the rear table, otherwise you will not have a true cut.

F. Do not keep the fence locked at one point but change it from time to time so that the cutting will be spread over the entire surface of the knives.

CAUTION: We do not advise that you attempt to joint pieces shorter than 3" in length. When jointing pieces from 3" to 9", use a form such as a push block, to keep the fingers as far away from the blades as possible. This will help prevent the wood from kicking back.

G. Rabbetting is the process of making a rectangular cut in the edge of a piece of wood. If pieces of wood so cut, that is, rabbetted, are put together so that the groove is on the inside of a frame, this groove acts as a recess for glass or any other material. If a groove is on the outside of the frame, it permits one frame to lap over the other. For example: the screen or glass insert frame in a combination screen and storm door.

Many times rabbet edges are used as the means of securing more solid glue joints.

The rabbetting arm is on the front table and the rabbet capacity is approximately 3/8" depth and 5" width. We do not advise that the jointer be set at its maximum capacity, but that more than one pass be made, to secure maximum depth of cut, otherwise you may split the wood.

Move, the fence across the table to the desired width, then drop the front table to the desired depth.

H. When a bevel is to be cut, loosen fence lock handle and wing nuts, set the fence at the degree of tilt desired.

It is quite difficult to hold wood when full 45° bevels are being cut, therefore, we suggest that you set the bottom of the fence inward or tilted to the right, thereby creating a V or a pocket which helps to hold the wood or trap it into position. If pressure is kept constant, you will have no difficulty in cutting the correct bevel.

MAINTENANCE INFORMATION

1. TABLE:

Occasionally check the accuracy of depth pointer. Secure a steel straight edge or a strip of wood which has a true edge sufficiently long to extend over both tables. Bring the front table up so that it is flush with the rear table and then check depth pointer. If not at zero, loosen round head machine screw and reset the pointer.

2. FENCE TILT:

Occasionally check the accuracy of tilt pointer by setting a carpenter's or machinist's square on table and against fence. Line fence up with steel slide in square. If pointer does not indicate zero reset it by loosening round head machine screw.

3. SHARPENING AND ADJUSTING JOINTER BLADES:

When the jointer blades become dull, but not nicked, they may be sharpened in the head, thereby saving a great deal of time.

Lower the front table until the bevel of the blade and the table are flush. Lock the head so it cannot move (this may be done by using a C clamp to lock the belt to the bench or stand), then lower the front table slightly more.

Secure a very fine oil stone and cover the part which will rest on the table with a thin piece of paper so it will not scratch the table. Pass the stone over the blade until the blade has a very sharp edge. Repeat this operation on the second and third blades.

If blades are badly nicked, remove them from the cutter head and have them ground by a grinding service company in your community. The edge of the blade must be ground straight.

Resetting the blades in the head is a task requiring great patience and extreme care, otherwise the jointer will not cut efficiently.

Insert the three blades 303413 and the chip breakers (with the grooved side up) into the head. Slightly tighten the chip breaker screws, which are in the chip breakers, so that the blades will not fall out as you turn the head. Secure a straight edge, such as the steel edge from a carpenter's or machinist's square or a perfectly straight edged piece of wood. Place the straight edge on the back table so that it over-hangs the head, almost reaching the front table, but not touching same. Bring the blade up until it touches the straight edge at both ends, then tighten screws. The blade should be so set that it does not lift the straight edge as the head is turned backward. It should be possible to feel a very slight pressure on the straight edge as the blade passes under it. After the blade has been set at one end, check at the other end and set it accordingly. Securely tighten all screws so that the blade will not move, then recheck. Repeat this operation on the second and third blades. NOTE: THIS MUST BE DONE CAREFULLY BEFORE THE MOTOR IS TURNED ON.

4. BEARINGS:

A. LUBRICATION:

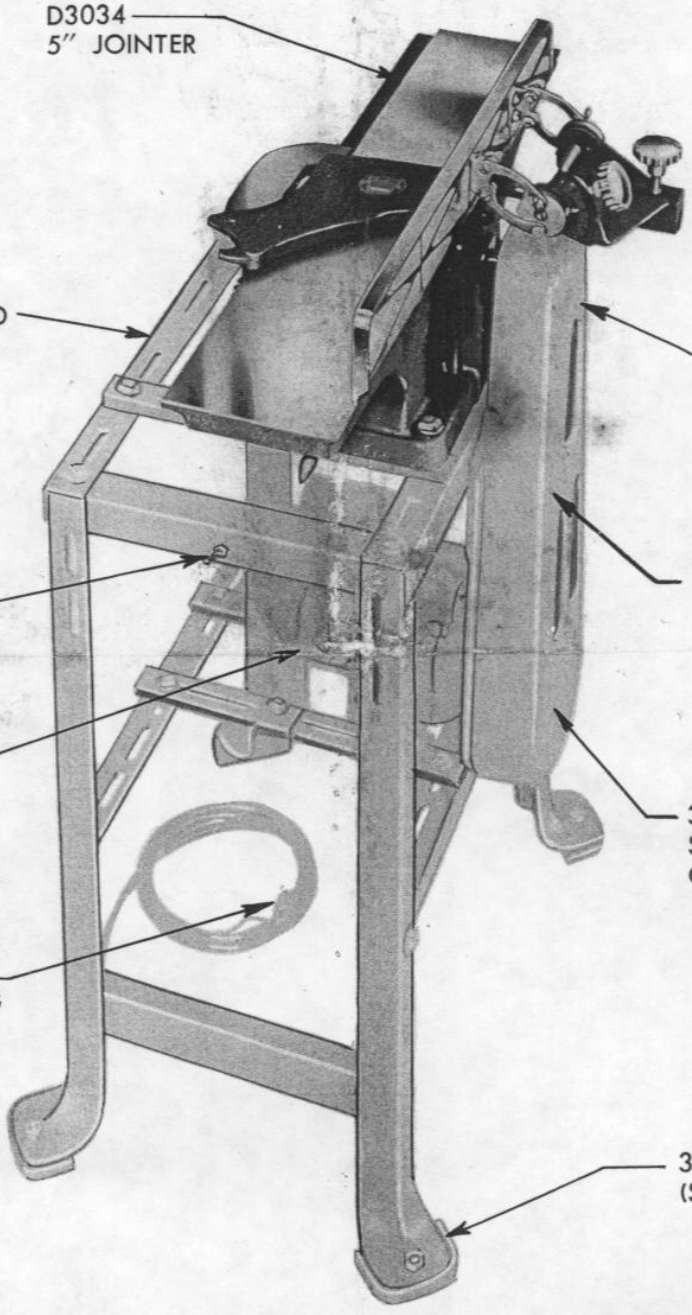
The ball bearings have been packed at time of assembly with sufficient grease to provide lubrication for several years of normal operation.

B. BEARING REPLACEMENT:

If it becomes necessary to replace these ball bearings, we suggest you follow this procedure.

1. Turn jointer on its side and remove the machine screws holding the bearing seats.
2. Lower both tables, remove the bearing and seat assemblies.
3. Replace the bearings and reassemble the head, bearings and bearing seats into the jointer.
4. Secure a long straight edge, place it on rear table, extended over the cutter head. When you barely feel the knives touching the straight edge but not moving it, the rear table is in correct position, lock it.
5. Extend straight edge to front table, bring table up to where it touches the straight edge. It should now be in its normal position. Check the pointer and if not at zero, reset it.

PHANTOM SKETCH — INDICATES ITEMS AND THEIR PART NUMBERS. THESE ITEMS WILL INCREASE THE EFFICIENCY OF YOUR TOOL. WHEN ORDERING ANY OF THESE ITEMS PLEASE USE PART NUMBER FOR THE PART YOU WISH TO PURCHASE.



DARK PICTURE — INDICATES TOOL AS YOU PURCHASED IT.

DURO METAL PRODUCTS CO. 2651 N. Kildare Ave., Chicago 39, Ill.

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