



OPERATING INSTRUCTIONS AND PARTS LIST FOR JOINTER

Model Number 2432 and 2432B

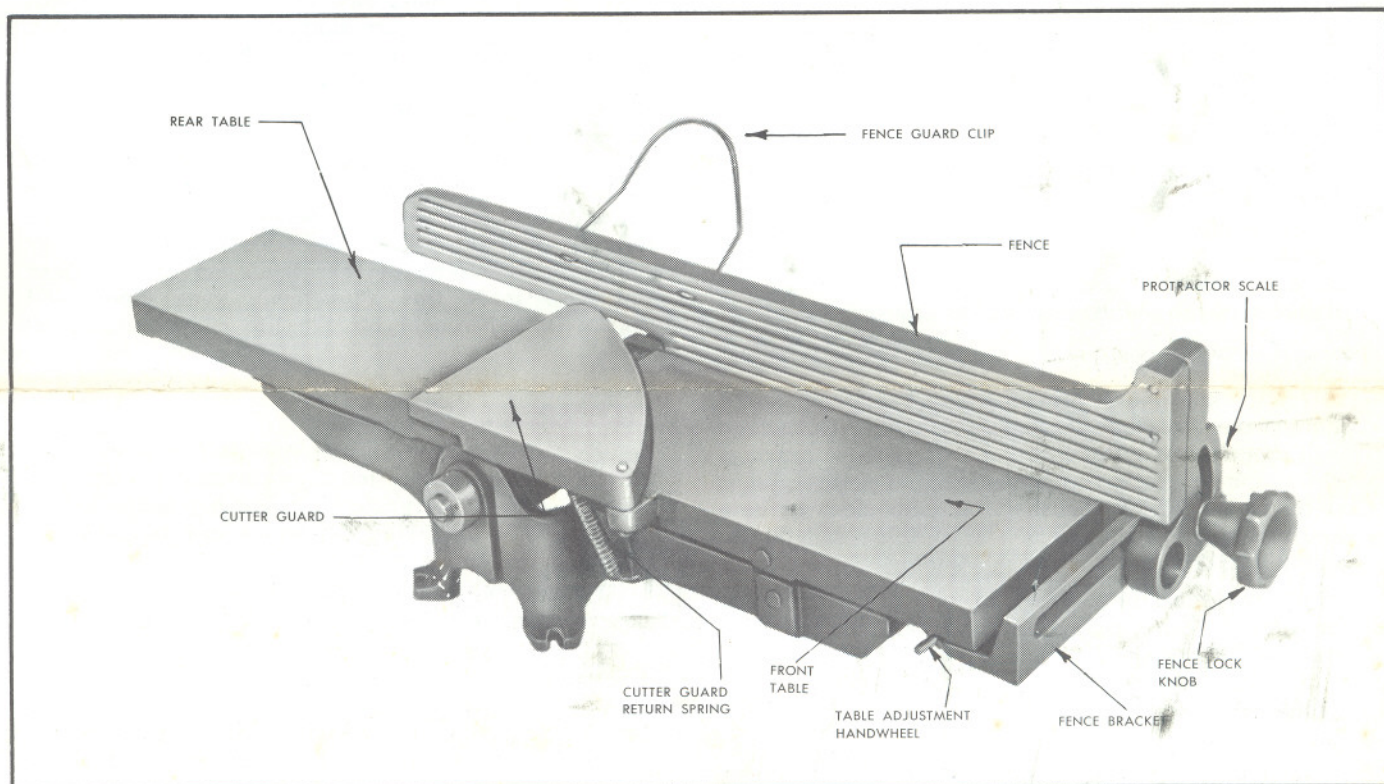


FIGURE 1

ASSEMBLY:

This jointer has been completely assembled, inspected and tested at the factory. To protect the tool from damage during shipment, the cutter guard and fence have been removed.

To reassemble, insert the cutter guard, No. 35, into the hole provided in the movable table, No. 13.

The return spring, No. 34, for the cutter guard is attached to the guard with a cotter pin, No. 36. Connect the opposite end of the spring to the lug on the under side of the table (as shown in Figure 1) by simply placing the loop of the spring over the lug.

To assemble the fence; place the fence, No. 1, with the protractor, No. 10, attached to it on the table as shown in figure 1. Slip the fence slide lock, No. 14, between the fence bracket, No. 15, and the table, No. 13, with the round projection of the fence slide lock passing through the fence bracket. No. 15, and resting on the outside of the protractor segment. The threaded stud on the fence slide lock should also pass through the slot in the fence bracket and then through the segmental shaped hole in the protractor segment, No. 10. Place the washer, No. 16,

on the fence slide lock threaded stud and screw the fence lock knob on, locking the entire assembly, see figure 2. Note that the large round hole on the left side of the protractor casting serves no purpose in the actual assembly. (It is designed simply to lighten the casting.)

The fence can be aligned square with the cutter head by adjusting the fence bracket, No. 15, with the two screws, No. 19, that hold it to the table. The fence can be adjusted to lie flat on the table by loosening the two screws No. 9 that hold it to the fence clamp, No. 10 and repositioning.

NOTE: DO NOT ATTEMPT TO USE THE JOINTER-PLANER UNTIL YOU HAVE ADJUSTED THE CUTTER BLADES. THIS INFORMATION WILL BE FOUND IN A LATER SECTION: "REPLACEMENT AND ADJUSTMENT OF CUTTER BLADES" ON THE OPPOSITE PAGE.

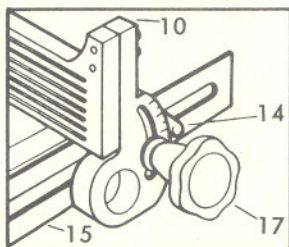


FIGURE 2

INSTALLATION:

The jointer should be bolted securely to a tool stand or to a solidly built work bench. Four $\frac{3}{8}$ " wide slots are provided in the base for this purpose.

The motor should be installed below the tool.

MOTOR:

A $\frac{1}{3}$ h.p. or larger, 1725 r.p.m. motor equipped with a 4 inch diameter pulley is recommended for the jointer.

When purchasing the 4" motor pulley, mentioned above, be sure to specify the shaft diameter of your motor. Install the motor so that the direction of rotation of the cutter head is counterclockwise as viewed from the pulley side of the jointer.

SPEED:

The recommended motor equipped with a 4 inch diameter pulley will give an arbor speed of approximately 3600 r.p.m.

BELT:

The jointer pulley is designed to use a standard ½ inch "V" Belt.

The length of this belt may be determined after the motor position has been selected, by measuring with a piece of string or flexible tape around the outside diameter of the pulleys, not in the grooves.

LUBRICATION:

2432: This machine is provided with two precision oil impregnated bearings located in the base casting on both sides of the cutter head. Although these bearings will retain oil, it is recommended that several drops of oil be placed on the shaft on both sides of both bearings before each use of the machine and during prolonged (15 minutes or more) running.

2432B: This machine is provided with precision sealed for life ball bearings. No additional lubrication is needed.

CONTROLS:

The position of the fence is maintained by the clamping action of the fence lock knob, No. 17. The fence may be positioned at any point across the table by loosening fence lock knob, No. 17, and moving the fence along the fence bracket, No. 15.

Note that the angle of the fence also is adjusted by the fence lock knob. When loosened, the entire fence can be rotated to the desired angle. By marking the face of the projection on the fence slide lock at "O" with the fence square to the table, approximate angle settings can be read at all positions off the protractor scale. For exact settings it is recommended that a bevel be placed between the fence and the table with the desired angle on the bevel.

DEPTH OF CUT:

The depth of cut is regulated by adjusting the table adjustment handwheel, No. 24, (this is a screw with a cross pin in it located underneath the front side of base as shown in Figure 1). The exact depth of cut can be determined by measuring the difference in elevation between the front (movable) and the rear (fixed) table.

ADJUSTMENT OF TABLES:

The tables of your machine were carefully leveled and aligned at the factory. It is possible, however, that misalignment might have occurred in transit; and the tables should be checked. To check the table follow this procedure.

- (1) Screw the movable (front) table to a position level with the fixed table.
- (2) Place a straight edge across the two tables

trying all angles and positions on the table to determine whether the tables are level with each other.

(3) If the tables are level, do not attempt to make any further adjustment. The tables will stay level for the life of your machine.

(4) To level the tables adjust the eight screws provided on the under side of the fixed (rear) table. Four of these screws are slotted head set screws, No. 31, tapped into the base casting. These are the screws used for the actual leveling; they push against the under side of the table. The other four screws, No. 32, are hex head cap screws which are tapped into the table itself. These screws will lock the table in adjustment. Loosen the hex head cap screws first. Then adjust the slotted head set screws so that the table is level. And lastly, lock the table in adjustment by tightening (securely) the hex head cap screws. Once you have made this adjustment, your tables will remain in adjustment for the life of your machine.

REPLACEMENT AND ADJUSTMENT OF CUTTER BLADES:

Before you use your machine, or after re-sharpening, the cutter head knives must be carefully adjusted to insure a smooth, accurate, even cutting action of the machine. The following procedure can be used for adjusting the cutter knives.

(1) Raise the movable (front) table to a position exactly even with the fixed table (zero depth of cut).

(2) With a straight flat piece of hard wood bring the blades to a position of just touching the wood as the wood rests across the two tables. Check by rotating the shaft slowly by hand and insuring that each blade just touches the wood. Check this on both ends of the blade cutting edge. (right and left)

(3) Tighten the blades snugly with the hex socket key, No. 37, provided with your machine. Three socket cap screws are provided to lock each blade in the cutter head.

SAFETY:

Always stop the tool before making any adjustments.

After installing blades (cutter knives) see that all nine socket cap screws are tightened securely.

Do not operate the machine without aligning and setting the cutter blades (see section entitled REPLACE-
MENT AND ADJUSTMENT OF CUTTER BLADES).

Tighten all pulley set screws and cutter knife cap screws after a few hours of operation.

When surfacing thin stock (½ inch or less) a push block should always be used.

Keep cutter guard in position when tool is in operation.

Do not feed work into the machine with your fingers on the outboard side of the fence. The fence guard clip is provided as a reminder to prevent injury to fingers from portion of the cutter on the outboard side of the fence.

Do not attempt to plane or joint wood that has nails or metal parts in it where the nails or metal parts might possibly come into contact with the cutter blades. (knives)

Use a pusher with a hold down on top of the board when cutting short boards.

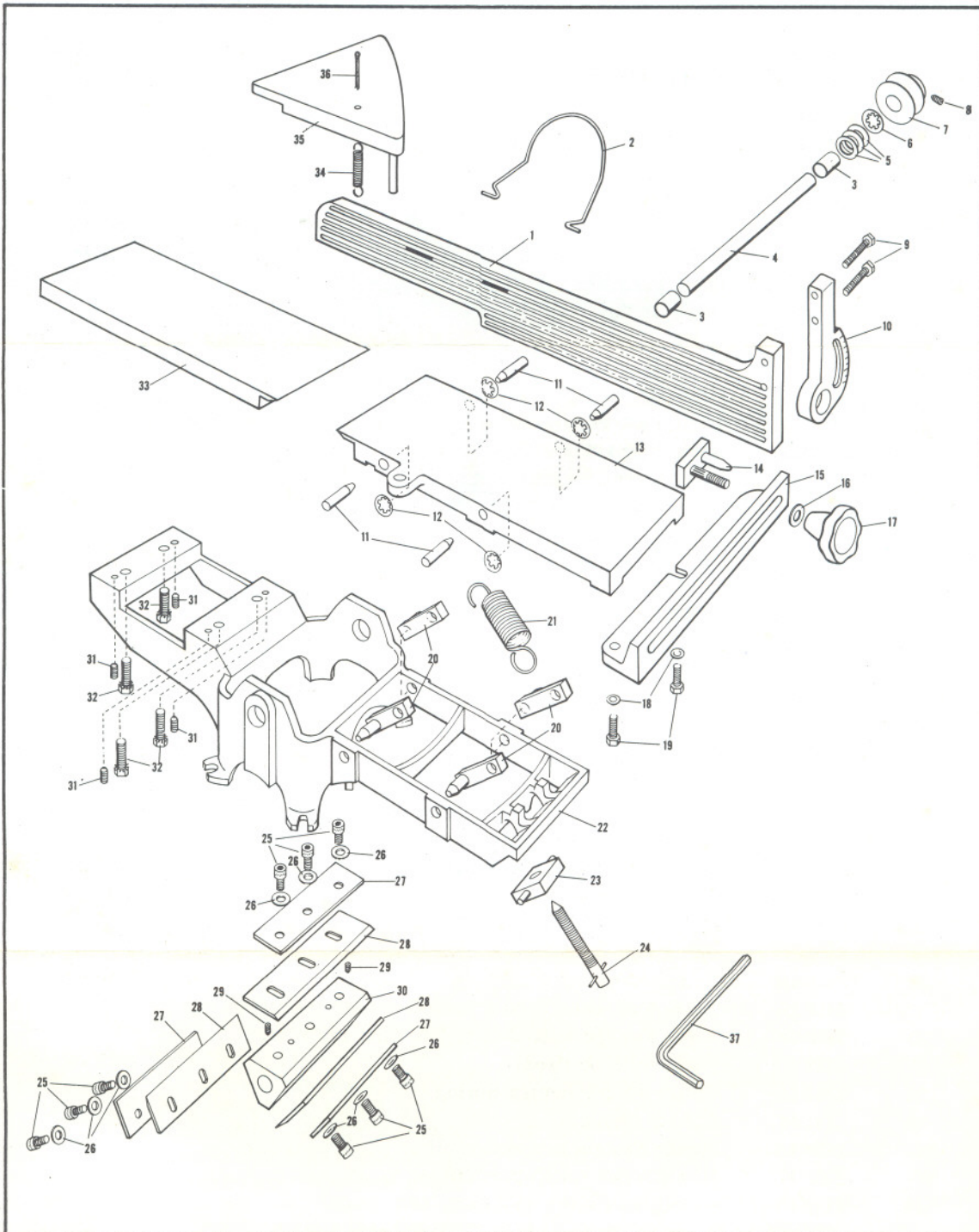


FIGURE 3 (See Parts List Page 4)

PARTS LIST

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

1. The PART NUMBER.
2. The PART NAME.
3. The MODEL NUMBER 2432 or 2432B.
4. The NAME of Item—JOINTER.

Key No.	Order by Part No.	PART NAME	Post Paid Price
1	2432-34	Fence	3.00 ea.
2	2432-42	Fence Guard Clip25 ea.
3	2432-15	Bearings25 pr.
3A	2432B-15	Ball Bearings	2.80 pr.
4	2432-14X	Shaft	1.50 ea.
5	2432-15B	Shaft Shim Washers25 ea.
6	2432-15C	Shaft Push Nut25 ea.
7	2432-27	Drive Pulley80 ea.
*8	2432-28	Drive Pulley Set Screw, $\frac{3}{16}$ x $\frac{3}{16}$ socket set screw.....	
*9	2432-35B	Fence Clamp Fasteners, $\frac{1}{4}$ x $\frac{3}{4}$ hex head cap screws.....	
10	2432-31	Fence Clamp (protractor scale)75 ea.
11	2432-3B	Table Fasteners, knurled pins $\frac{3}{16}$ x $1\frac{1}{4}$75 set of 4
12	2432-4B	Rocker Link Push Nuts, $\frac{3}{16}$25 set of 4
13	2432-3A	Table (front or movable)	4.00 ea.
14	2432-32	Fence Slide Lock50 ea.
15	2432-30	Fence Bracket60 ea.
*16	2432-35C	Fence Lock Knob Washer, $\frac{1}{4}$ x $\frac{5}{8}$	
17	2432-33	Fence Lock Knob30 ea.
*18	2432-35D	Fence Bracket Washers, $\frac{1}{4}$ x $\frac{5}{8}$	
*19	2432-35A	Fence Bracket Fasteners, $\frac{1}{4}$ -20 x $\frac{3}{4}$ hex head cap screws....	
20	2432-4A	Rocker Links	1.80 set of 4
21	2432-8	Table Spring50 ea.
22	2432-1	Base Casting	4.50 ea.
22A	2432B-1	Base Casting (Ball Bearing)	7.00 ea.
23	2432-5	Table Height Nut25 ea.
24	2432-6	Height Nut Screw (table adjustment handwheel).....	.35 ea.
*25	2432-10	Fasteners for Knives, $\frac{1}{4}$ -20 x $\frac{3}{8}$ socket head cap screws.....	
26	2432-10A	Fastener Washers for Knives, $\frac{1}{4}$ x .010 thick.....	.50 set of 9
27	2432-29	Chip Breakers	1.00 set of 3
28	2432-12	Knives (cutters)	2.25 set of 3
*29	2432-11	Spindle Lock Screws, $\frac{1}{4}$ -20 x $\frac{3}{16}$ socket set screws.....	
30	2432-9B	Cutter Head	3.50 ea.
*31	2432-2A	Table Fasteners, $\frac{1}{4}$ -20 x $\frac{3}{4}$ slotted head set screws.....	
*32	2432-2B	Table Fasteners, $\frac{1}{4}$ -20 x $\frac{3}{4}$ hex head cap screws.....	
33	2432-3	Table (rear or fixed)	3.75 ea.
34	2432-31	Cutter Guard Return Spring25 ea.
35	2432-36	Cutter Guard80 ea.
*36	2432-43	Spring Fastener, $\frac{1}{8}$ cotter pin	
*37	2432-44	Hex Wrench for Cutter Knives, $\frac{3}{16}$	
38	2432-1B	Instruction Sheet and Parts List	N/C

*Standard Hardware Items — May Be Purchased Locally.

This sheet is intended for instruction and repair parts only and is not a packing slip.
The parts shown and listed may include accessories not necessarily part of this tool.



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