GENERAL

Model 480

203,2 mm / 8" LONGBED JOINTER

OPERATING AND MAINTENANCE INSTRUCTIONS

Ordering information

480-1
Jointer with set of 3 steel knives, 2-way tilting fence, safety cutter-head guard, arbor pulley, motor pulley, V-belt, enclosed steel base, less motor and starter.
Shipping weight . . . . . 200 kg/440 lbs.

480
Jointer with set of 3 steel knives, 2-way tilting fence, safety cutter-head guard, arbor pulley, less motor pulley, V-belt, enclosed steel base, motor and starter.
Shipping weight . . . . . 163.2 kg/360 lbs.

480-2
Enclosed steel base complete with belt guard, shaving chute and adjustable motor mounting.
Shipping weight . . . . . 36.2 kg/80 lbs.

480-3
Set of three 8"
H.S. steel knives . . . . . 0.90 kg / 2 lbs.

Specifications

Cutting capacity:
Depth . . . . . 12.7 mm / 1/2"
Width . . . . . 203.2 mm / 8"
Rabbetting
capacity . . . . 12.7 x 203.2 mm / 1/2" x 8"
Fence tilts right or left . . . . . 45°
Fence 101.6 x 863.6 mm / 4" wood x 34"
Length of tables . . . . . 1625.6 mm / 64"
Height of table . . . . . 838.2 mm / 33"
Table ways . . . . . Dovetailed
Cutting circle . . . . . 82.5 mm / 3-1/4" dia.
Cutter-head speed . . . . . 4500 R.P.M.
13500 cuts per minute
Cutter-head bearings . . . . . Sealed for life
Recommended motor . . . . . 1 - 1-1/2 H.P.
Overall dimensions:
Width . . . . . 622.3 mm / 24-1/2"
Length . . . . . 1625.6 mm / 64"
Height . . . . . 996.9 mm / 39-1/4"
Net weight . . . . . 163.2 kg / 360 lbs.
Shipping weight . . . . . 200 kg / 400 lbs.



MODEL NO.
480-1

SERIAL NO.

IMPORTANT: When ordering replacement parts, always give model number, serial number of machine and part number. Also give description and quantity of each item.

All replacements parts can be obtained from:

GENERAL MFG. CO. LTD.
835, Cherrier St.
Drummondville, Quebec, Canada
J2B 5A8
Tel.: (819) 472-1161
Fax: (819) 472-3266

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GENERAL Jointers are carefully tested and inspected before shipment and if properly used will give perfect results. However, reasonable amount of care and attention is necessary to insure perfect performance and accurate work. It is imperative that you take a few moments to read and familiarize yourself with these instructions and they will probably save you a lot of trouble and time.

INSTALLATION

Your Jointer and stand are shipped separately. The Jointer in a crate and the stand in a carton. Remove the crate and carton and your Jointer is now ready to place on its stand. The Jointer should now be bolted to the stand by holes provided. The screws are put in from inside the stand. The surface of the tables, fence and mechanisms have been covered with grease to prevent rusting. This should be cleaned off with a mild solvent, never used a paint solvent.

POWER REQUIRED

For average work, a 1 H.P. motor will furnish enough power for this machine. The motor suggested is 1 H.P. 1725 Rpm. A standard motor of 1725 Rpm., with the 6¼" dia. pulley supplied with the machine will give a cutter-head speed of 4500 Rpm. This is the recommended speed, as no benefit will be noticeable by running the cutter-head at higher speed, excepting that the life of the bearings would be shortened considerably.

MOUNTING MOTOR

To install the motor, removed the rear panel. Before mounting the motor in the base, we suggest that the wire be attached to the motor before bolting it in, as it will be much more convenient, also be sure that the motor rotates in the right direction if not, reverse the rotation according to the instructions accompanying the motor. The motor can then be placed on the motor bracket in the stand and bolted in place. After installing the motor, put on the pulley and V-belt. It is important to have both pulleys lined up. This is done by using a straight edge. To line up the pulleys, you may either move the motor brackets or move the pulley on the motor shaft. To adjust the motor base for proper belt tension, loosen or tighten the nuts of the two eyes bolts until correct tension is arrived at. The tension of the belt, is correctly adjusted when the belt will touch one another by pulling them together, afterwhich, the adjustment is locked in place with jam nuts.

ADJUSTMENTS

The 8" Jointer leaves the factory completely adjusted and ready to operate, however a check up is recommended both to familiarize yourself with it and to be sure that everything is in order.

TABLE: The rear table should be adjusted fairly tight as it rarely moves. If too loose or too tight loosen the locknuts and adjust the gib screws on the back side of the machine then lock in place.

The Front table is adjusted in the same manner. As it will move very often, care should be taken that the table is not loose on it slides as it will make it difficult to plane true work and also permit dust to get in the slides and throw your table out of alignment. These adjustments are provided to take up wear on the slides. It is seldom necessary to adjust the rear table as it remains in a fixed position most of the time and will not show any wear during the life of the machine but it may be necessary to readjust the front table after long use.

Turning the handwheel of the front table moves the table up or down on the inclined ways and this regulates the depth of cut.

The pointer indicating the depth of cut should be adjusted at zero when the front table is level with the rear table. The scale will now give the exact thickness of cut, up to 1/2 inch.

KNIVES

Accurate work is possible only when the knives in the cutter-head are parallel to the tables and project equally from the cutter-head. We recommend that this adjustment be checked when the Jointer is received.

To check the adjustment proceed as follows: Raise the rear table until it is flush with the base at the slide. Place two straight edges on the rear table extending over the cutter-head then rotate the cutter-head by hand, the knives should just touch the straight edges. If a knife is too high or too low at either end, loosen the jack screws of the chipbreaker with the small wrench furnished with the machine, and the knife can be pried up or tap down with some soft object until they just touch the straight edges, then the screws are tightened securely. This is repeated until all knives are equal.

It is very important that the knives be all exactly level with the rear table. The knives should protrude 1/32 to 1/16 past the rabbetting clearance in the rear table. To obtain maximum performance, we suggest that the knives be kept sharp. If the knives are left

to become too dull, the finish will suffer accordingly and a Jointer with dull knives is dangerous to operate.

FENCE

The fence can be moved across the full width of the table and is held in place by tightening the far locking handle. It tilts to any angle desired with positive adjustable stops at 45° right or left and 90°. To tilt the fence, it is necessary to unlock the rear handle and swing back the stop. When it is desired to tilt the fence to an angle other than those with fixed stops, proceed in the same way and use the scale to determine the degree of angle then lock in place.

The fence bracket has been made to act as a rear knifeguard by covering the part of the cutter-head that is not used behind the fence. If the fence should get out of square, the adjustments are as follows: The stop is pulled out. The fence unlocked then adjusted at 90° with a square and locked in place, then adjust the screw to touch the stop and lock in place. Follow the same procedure to adjust the fence at 45° right or left.

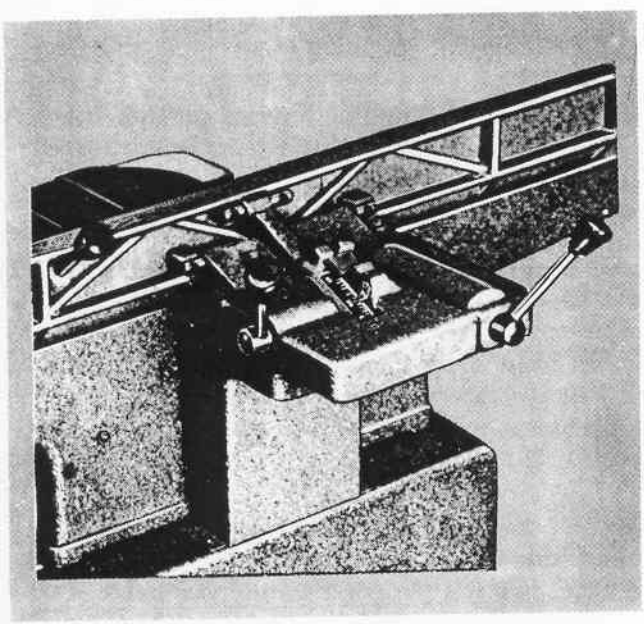


FIG. 2 VIEW SHOWING FENCE MECHANISM

SETTING KNIVES

When the knives are removed, care must be used in resetting them. Two straight edges or straight pieces of hardwood are placed on the back table. A knife is inserted and the screws of the chipbreaker are tighten lightly. The cutter-head is then revolved backward carefully and the knife is tapped down with a soft object until it just touches the straight edges without moving them.

The screws are then tighten, set the other knives in the same manner. Go over the jack screws to make sure that they are tight and then joint the knives lightly as described further. Do not hurry this operation because upon its accuracy depend the quality of the work the machine will do.

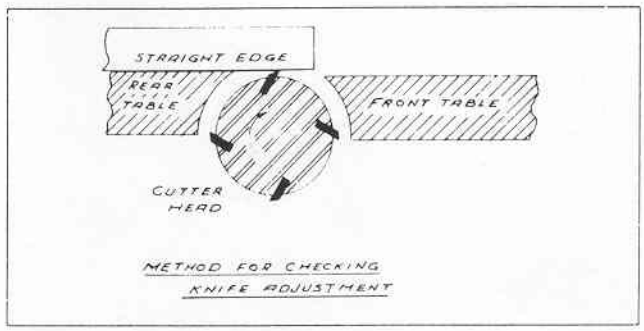


FIG. 3

JOINTING KNIVES

Use a fine carborundum stone, which is covered partly with paper as shown in figure 4 to avoid marking the surface of the table. With the stone on the rear table after having raised this table, start the machine and then move the stone across the rear table lengthwise of the knives, so they are sharpened their entire length.

Keep the stone flat on the table. If the knives are not touching the stone at all points across their length, lower the rear table slightly and repeat the operation . . . If a fine wire edge appears on the knives of the cutter-head, this can be removed by honing. When the knives have been jointed properly and carefully, each knife of the cutter-head will make a nice, smooth, clean cut.

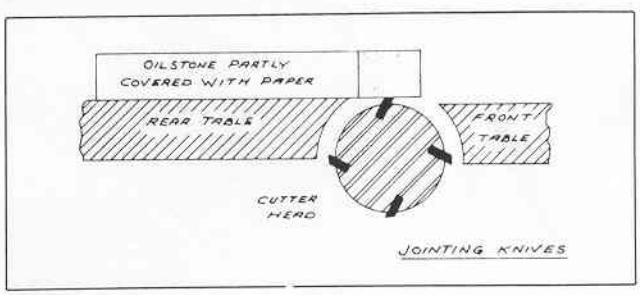


FIG. 4

LUBRICATION

The ball-bearings of the cutter-head are greased-sealed and require no lubrication for their entire life. A few drops of light oil on the table ways and on the raising or lowering screws should be applied occasionnally. This will give a smoother action when the tables are moved.

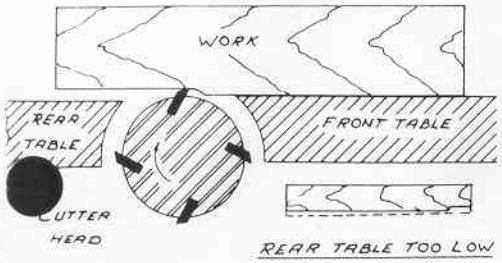


FIG.5

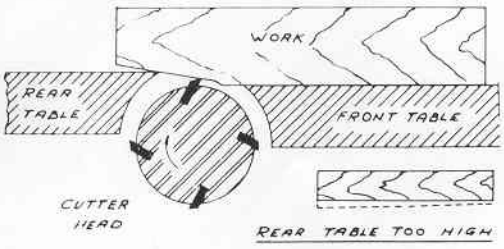


FIG. 6

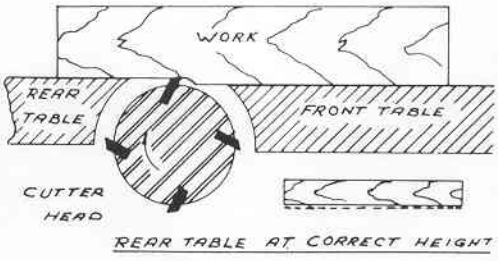
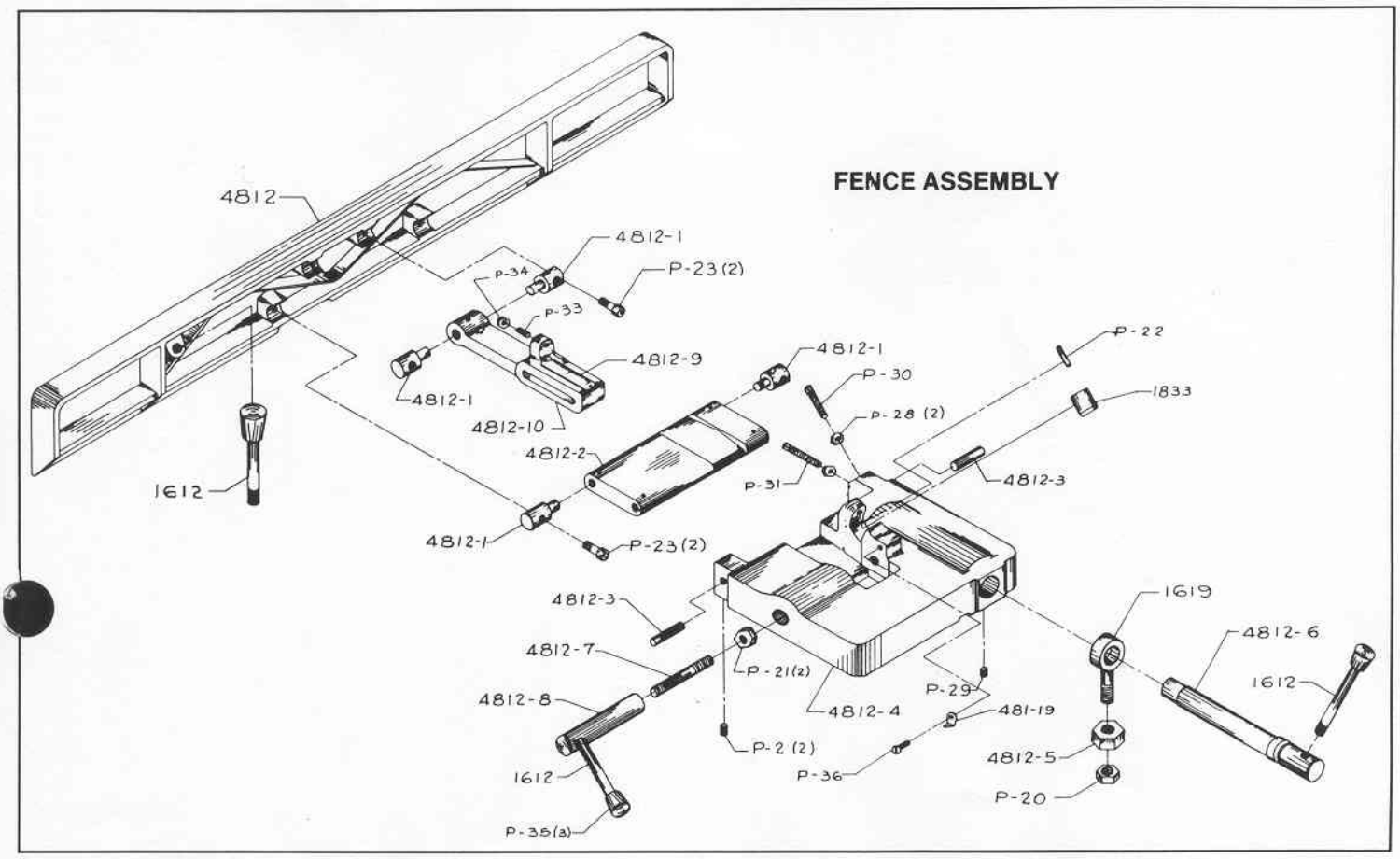
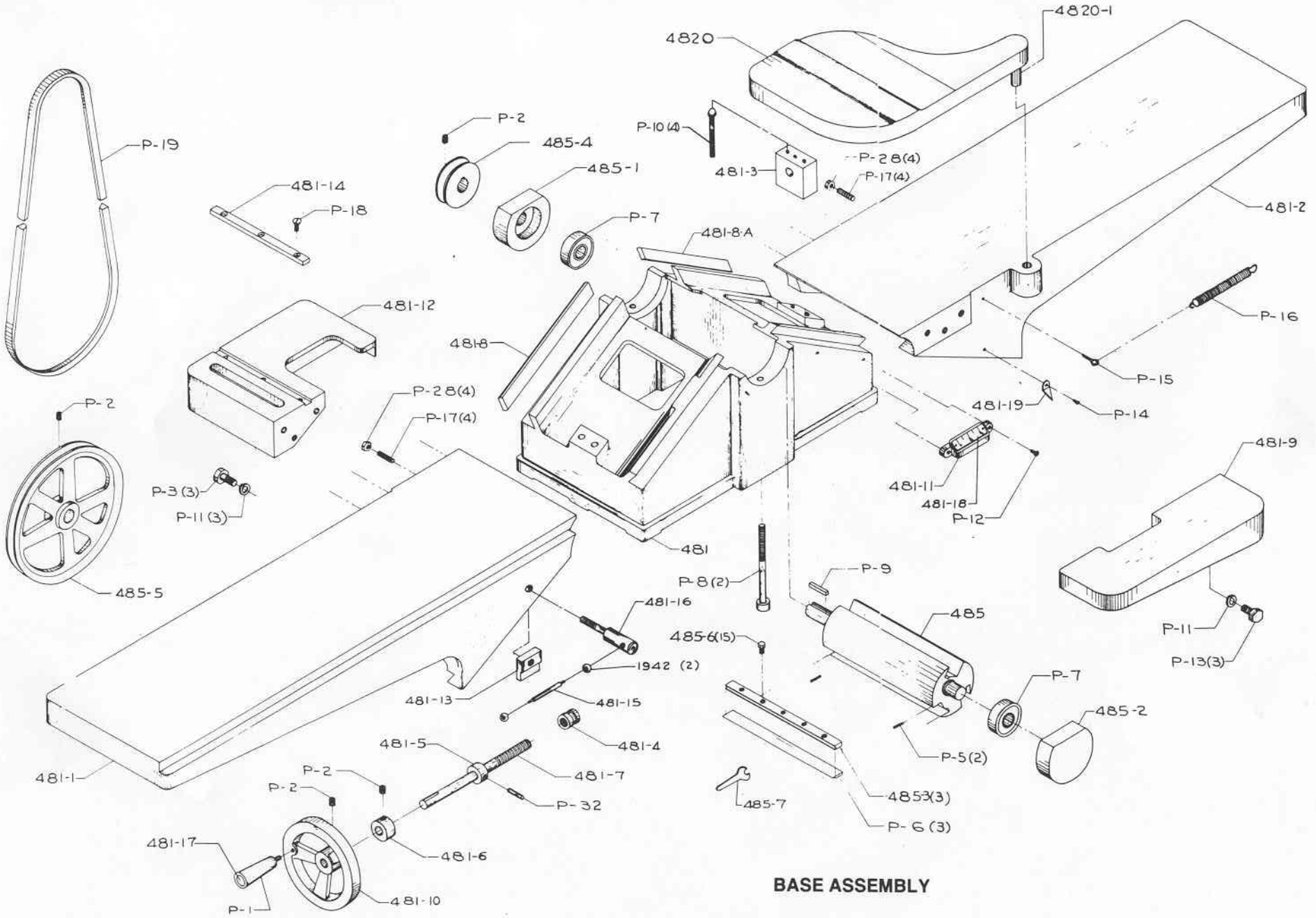


FIG. 7



Part No.	Description	Quantity
	FENCE ASSEMBLY	
4812	Fence	1
4812-1	Pivot	4
4812-2	Fence link	1
4812-3	Link pin	2
4812-4	Fence bracket	1
4812-5	Hex nut	1
4812-6	Locking shaft	1
4812-7	Stud	1
4812-8	Locking nut	1
4812-9	Degree plate	1
4812-10	Locking link	1
4812-19	Degree pointer	1
P-2	Socket set screws 5/16 x 5/16	2
P-20	Jam nut 1/2 NF	1

Part No.	Description	Quantity
P-22	Grooved pin 3/16 x 1-3/4	1
P-29	Dog Point set screws 1/4 x 1/4	1
P-33	Slotted set screws 1/4 x 1	1
P-35	Knob 10017 7/16	3
1612	Handle	3
1619	Eyebolt	1
1833	Stop	1
P-30	Sq. H. set screw 5/16 x 1	1
P-31	Sq. H. set screw 5/16 x 1-1/4	1
P-28	H. Jam nut 5/16	2
P-34	H. Jam nut 1/4	1
P-35	Plastic knob 10017 7/16	3
P-36	R.H. Mach. screws 8/32 x 5/16	1
P-21	Jam nut 3/8	2



BASE ASSEMBLY

REPLACEMENT PARTS

IMPORTANT: ALWAYS GIVE PART NUMBER AND DESCRIPTION OF EACH ITEM WHEN ORDERING — ALSO GIVE SERIAL NO. AND SIZE OF JOINTER.

Part No.	Description	Quant.
	BASE ASSEMBLY	
481	Base	1
481-1	Rear table	1
481-2	Front table	1
481-3	Block	2
481-4	Thd. bushing	2
481-5	Rear collar	2
481-6	Collar	2
481-7	Raising screw	2
481-8	Gib	2
481-9	Rabbetting arm	1
481-10	Handwheel	2
481-11	Scale bracket	1
481-12	Table bracket	1
481-13	Nut	2
481-14	Key	1
481-15	Handle	2
481-16	Lock screw	2
481-17	Axe de manivelle (3356-1)	2
481-18	Scale	1
481-19	Depth pointer (356-21)	1
P-1	Handle (691-P)	2
P-2	Socket screws 5/16 x 5/16	6
P-3	Cap screws 3/8 x 1	3
P-10	Cap screws 3/8 x 2-1/4	4
P-11	Lockwashers	4
P-12	Fill. Mach. screws 10/32 x 1/2	2
P-13	Cap screws 5/16 x 1	3
P-14	Screws 8/32 x 5/16	1
P-17	Slotted set screws 5/16 x 1	8
P-18	F.H. Mach. screws 10/32 x 1/2	3
P-28	Jam nut 5/16	8
P-32	Roll pin 5/32 x 1	2
1942	Ball	2
	CUTTER-HEAD ASSEMBLY	
485	Cutter-head	1
485-1	R.H. Bearing case	1
485-2	L.H. Bearing case	1
485-3	Chipbreaker	3
485-4	Pulley	1
485-5	Motor pulley	1
485-6	H.H. Mach. screw (Spe)	15
485-7	Wrench	1
P-2	Socket set screws 5/16 x 5/16	2
P-5	Springs (485-8)	6
P-6	Knives	3
P-7	Bearing (6204-2RS)	2
P-8	Socket cap screws 3/8 x 5	2
P-19	Vee Belt 4655 1800 RPM	
	Vee Belt 4650 3600 RPM	
	GUARD ASSEMBLY	
4820	Guard	1
4820-1	Pin	1
P-15	Cotter pin 3/16 x 3/4	2
P-16	Spring (4820-2)	1