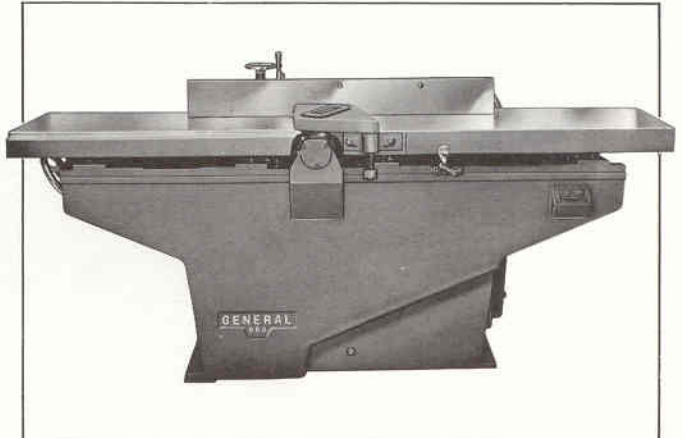


## 16" JOINTER OPERATING AND MAINTENANCE INSTRUCTIONS

### SPECIFICATIONS:

Cutting capacity:	
Width	16"
Depth	5/8"
Rabetting Capacity	5/8" x 16"
Fence Tilts To	45°
Maximum Opening at Cutter-Head	8"
Height of Tables	33"
Length of Tables	96"
Width of Tables	19"
Cutting Circle	5"
Speed of Cutter-Head	4,500 R.P.M.
Recommended Motor	3-5 H.P.
Floor Space	7' x 3'-2"
Net Weight	1,600 lbs
Shipping Weight	1,800 lbs



### EQUIPMENT INCLUDED WITH THE MACHINE

Cutter-Head Motor:  
Magnetic starter  
Start-stop push button station and wiring  
One set of 4. H.S. knives mounted in cutter-head  
Safety guard  
Knife setting wrench

### OPTIONAL EQUIPMENT

Knife Grinding and Jointing attachment  
Extra set of H.S. Knives 5/32" x 1-1/4" x 16"  
Rabetting arm

General planers and jointers are carefully tested and inspected before shipment and if properly used will give perfect results. However, reasonable amount of care and attention are 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 planer and jointer is shipped in a wooden crate and wrapped in waterproof paper. All machined surfaces have been covered with special grease to prevent rusting. Remove this protective covering with a mild solvent, never use a paint solvent.

**Foundation** - If the floor consists 4" to 6" concrete, no special foundation is required to install the machine. A good wooden base is also satisfactory. Layout of Fig. 1 gives the spacing of the foundation bolts.

**Important** - It is most important that the machine be carefully levelled both lengthwise and crosswise before final bolting down. The machine is levelled by placing a spirit level across the table in both directions and shims inserted underneath the machine. When the machine is level and resting firmly, tighten the bolts. It is essential that this procedure be carried out carefully to ensure the correct alignment of the tables.

**Wiring** - All wiring is completed at the factory and it is only necessary to bring the power line to the machine to put it in operation. Motor and starter is supplied as per customers' requirements and can be 208-220, 440 or 550 volts, 60 cycles. Be sure that the line voltage is the same as stamped on the motor.

### LUBRICATION

Once a week, the machine should be thoroughly cleaned and all machined surfaces wiped and a light film of oil applied to prevent rusting.

All moving parts should be oiled every week with a light oil, such as the inclined wedges of the table, elevating screws and shafts and bearings fence parts.

The helical gears of the front table should be greased every month using a light grease.

The cutter-head bearings have sufficient grease for 3 months when leaving the factory and a small amount of high quality bearing grease should be added every 3 months.

**IMPORTANT:** Care should be taken that the proper amount of grease be used as too much or too little will cause the bearing to overheat and damage them.



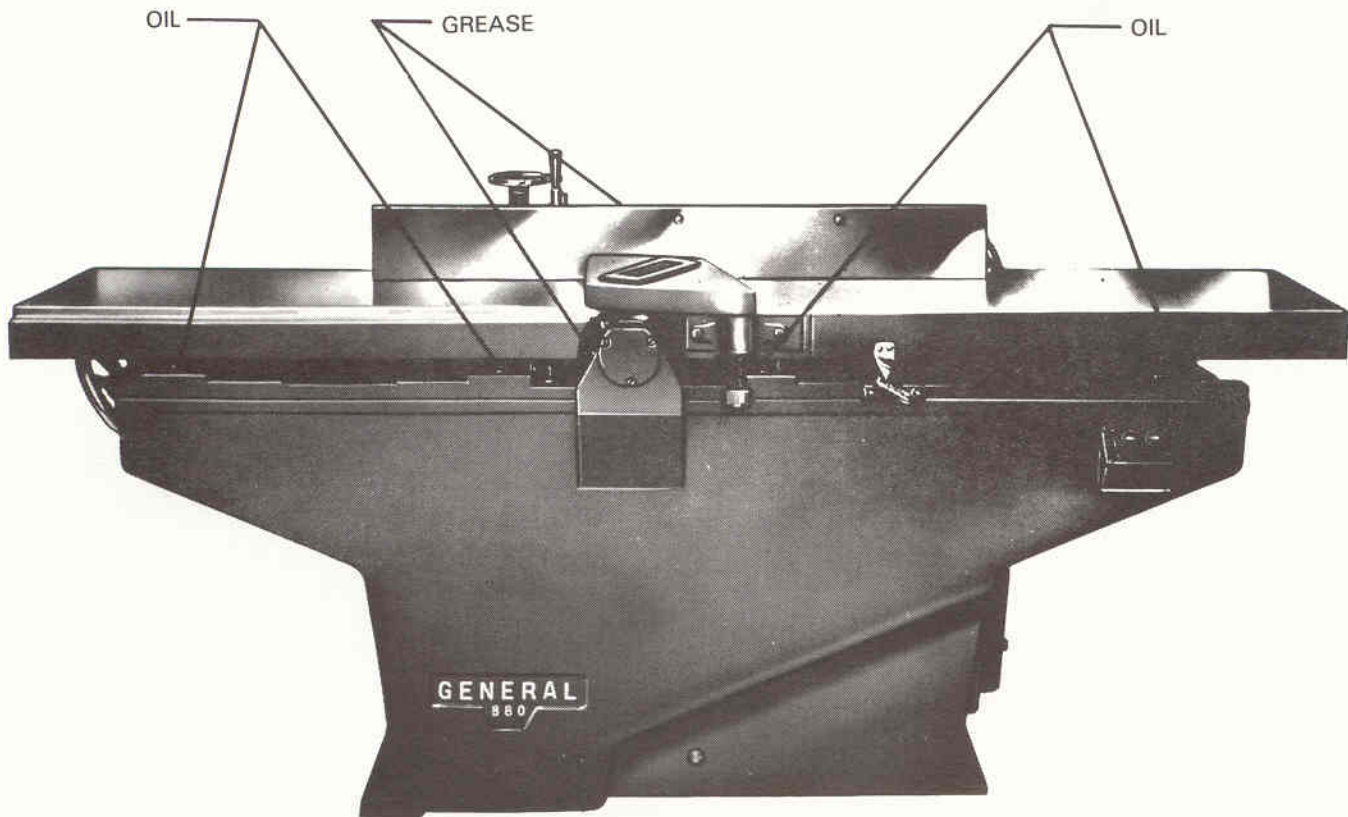


Fig. 2

### LUBRICATION

#### PLACES TO OIL

Front Table	Elevating Shaft Guard Pivot	Inclined wedges Elevating screw
Rear Table	Elevating screw	Inclined wedges

#### PLACES TO GREASE

Cutter-head	2 grease fitting (cutter-head)
Front Table	Helical gears

#### GENERAL ADJUSTMENTS

A planer and jointer will perform accurately only when the table and knives are well set, and great care should be taken in adjusting them properly. Although the machine left the factory completely adjusted and ready to operate, a check-up is recommended to familiarize yourself with it and to be sure that everything is in order.

#### TABLES

The rear table must be parallel to the frame. To check, loosen the screws that hold the carriage to the frame and move the table assembly back. With scale and caliper measure if the dimensions at the four corners are the same, if not this can be corrected by adjusting on inclined wedge.

When the four corners are equal, tighten the inclined wedges in place. The carriage should now fit flatly on the frame, if not, the inclined wedges should be re-adjusted until this is eliminated. Otherwise, the table will be out of true when the carriage is tightened back in place on the frame, the surface of the table should be 5-1/2" above the frame.

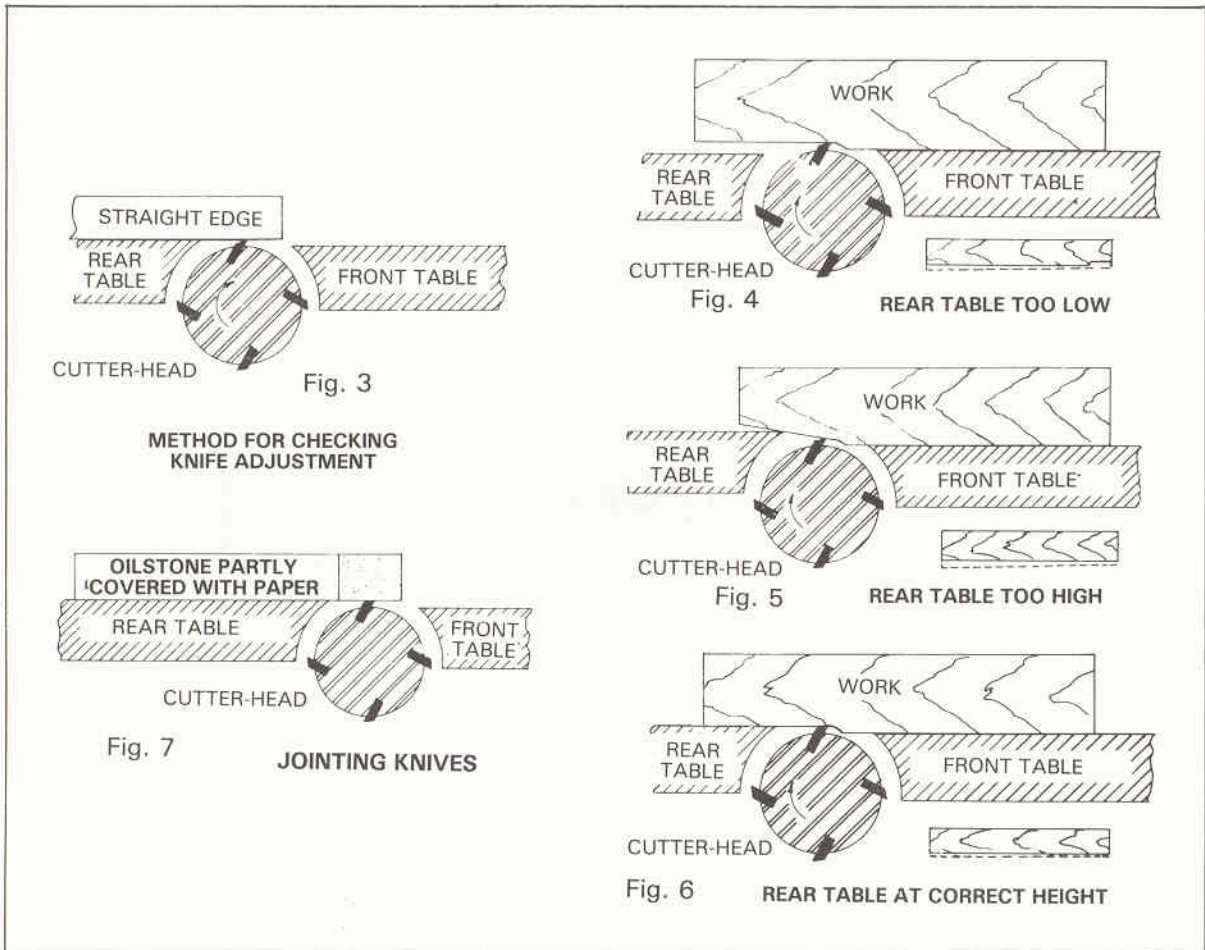
The front table should now be adjusted parallel to the rear table by means of a straight edge. The inclined wedge of the high or low corner is moved until the table is perfectly parallel with the rear table.

The opening of the table and the cutter-head is 2" when both are level with it. The pointer indicating the depth of cut should be adjusted to zero when the front table is level with the rear table. The scale will now give the exact thickness of cut, up to 5/8".

#### THE 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: With the rear table at 5-1/2" from the frame, 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 screws of the chip-breaker and the knife can be raised with the adjusting screws or cap down with a soft object until they just touch the straight edges, then the screws are tightened securely. This is repeated until the knives are equal.



It is very important that the knives be all exactly level with the rear table. These knives should protrude 1/32" to 1/16" past the rabbeting 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.

The cutter-head is then revolved backward carefully and the knife is raised or tapped down with a soft object until it just touches the straight edges without moving them.

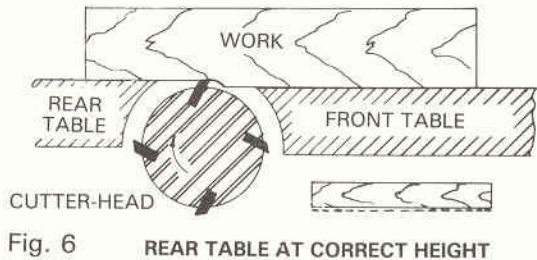
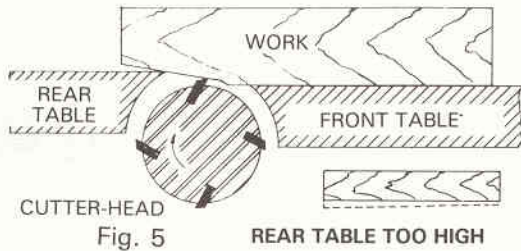
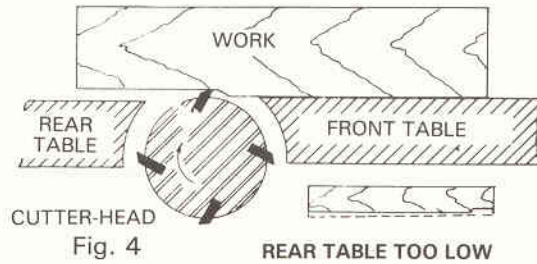
When the screws are tightened, set the other knives in the same manner. Go over the screws to make sure that they are tight and then joint the knives lightly. Do not hurry this operation because upon its accuracy depends the quality of the work the machine will do.

### SETTING THE 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 chip-breaker are tightened lightly.

### FENCE

The fence can be moved across the full width of the table and is held in place by tightening the two handles. It tilts to any angle desired with positive adjustable stops at 45° or 90°.



The fence bracket has been made to act as a rear knife guard by covering the part of the cutter-head that is not used behind the fence. If the fence should get out of square, it is only necessary to re-adjust the stop screws.

### JOINTING THE KNIVES

Use a fine carborundum stone, which is covered partly with paper as shown in Fig. 7 to avoid marking the surface of the table. With the stone on the rear 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, clean, smooth cut.



GENERAL MANUFACTURING CO. LTD.  
DRUMMONDVILLE, P.Q.

16" JOINTER OUTLINE

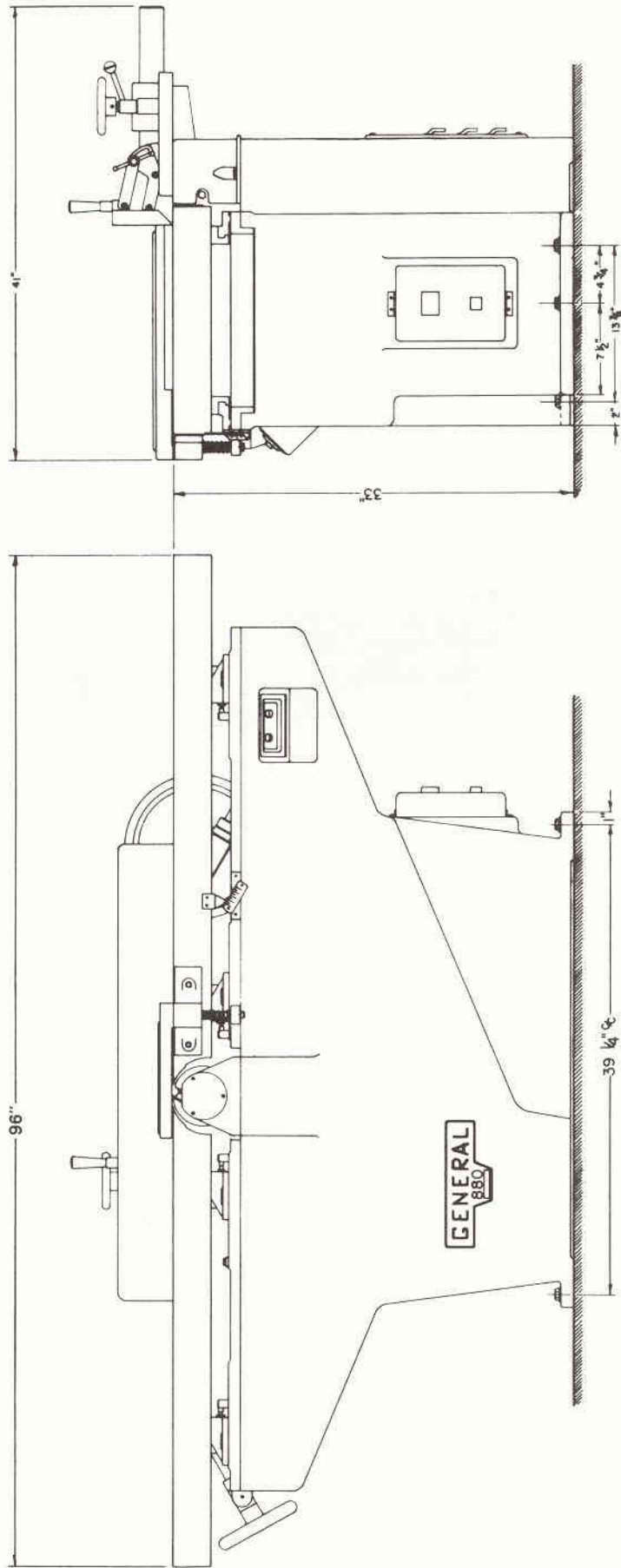


Fig. 1

## REPLACEMENT PARTS

**IMPORTANT: Always give part number and description of  
item when ordering  
Also give serial N°. and size of jointer**

Part N°.	DESCRIPTION	QTY	Part N°.	DESCRIPTION	QTY
	<b>FRAME ASSEMBLY</b>		P 50	Wing Screw 3/8" X 1"	1
781-2	Collar	2		<b>FRONT TABLE ASSEMBLY</b>	
781-4	Screw		782-1	Lower Wedge	2
781-8	Starter		782-2	Lower Wedge	2
881	Frame		782-3	Upper Wedge	2
881-1	Motor base		782-4	Upper Wedge	2
881-3	Plate		782-10	Collar	3
881-5	Cover		782-11	Stopper	4
881-6	Pulley Guard		782-12	Washer	8
881-7	Motor Pulley				
P 31	Hex. H. Screw 3/8" X 1 1/2"	1	783-6	Front Handwheel	
P 32	Hex. H. Screw 3/8" X 1 1/4"	2	783-9	Gear Box	
P 33	Hex. H. Screw 5/16" X 3/4"	2	783-14	Indicator Bracket	
P 34	Jam Nut 1/2" N.C.	3	783-15	Scale	
P 35	Socket S. Screw 5/16" X 5/16"	3	783-16	Indicator	
P 36	R.H. Screw 5/16" X 1/2"	4	882-10	Collar	4
P 37	R.H. Screw 8-32" X 1/2"	4	883	Front Table	
P 38	R.H. Screw 1/4" X 1/2"	2	883-5	Front Carriage	
P 39	Lock Washer 3/8"	1	883-7	Front Screw	
P 40	Rubber Band RW-60 55"	1	883-8	Nut	
P 71	V-Belt a-53		882-8		
	<b>REAR TABLE ASSEMBLY</b>		882-12	Shaft	
782-1	Lower Wedge	2	883-12		
782-2	Lower Wedge	2	883-17	Rabetting Arm	
782-3	Upper Wedge	2	883-19	Steel Lip	
782-4	Upper Wedge	2	1329-A	Pinion	2
782-6	Rear Handwheel		P 51	Hex. H. Screw 7/16" X 1 1/2"	8
782-9	Bearings		P 52	Hex. H. Screw 7/16" X 1 3/4"	4
782-11	Stopper	4	P 53	Jam Nut 1/2"	2
782-12	Washer	8	P 54	Jam Nut 3/8"	4
882	Rear Table		P 55	Sq. H. Set Screw 1/2" X 2"	2
882-7	Rear Screw		P 56	Sq. H. Set Screw 3/8" X 1"	4
882-8	Nut		P 57	Socket Set Screw 5/16" X 5/16"	1
882-5	Rear Carriage		P 58	R. H. Screw 1/4" X 5/8"	2
882-10	Collar		P 59	R.H. Screw 10-32 X 3/8"	2
882-13	Steel Lip		P 60	F.H. Screw 3/8" X 7/8"	6
P 41	Hex. H. Screw 7/16" X 1 1/2"	8	P 61	Drive Screw 2" X 1/4"	2
P 42	Hex. H. Screw 7/16" X 1 3/4"	4	P 62	Roll Pin 3/16" X 1"	2
P 43	Jam Nut 1/2"	4	P 63	Roll Pin 3/16" X 1 1/2"	3
P 44	Jam Nut 3/8"	4	P 64	Roll Pin 3/16" X 1 7/8"	1
P 45	Sq. H. Set Screw 1/2" X 2"	4	P 65	Dilite Bushing AA 885 3/4" X 7/8" X 3/4"	7
P 46	Sq. H. Set Screw 3/8" X 1"	4	P 66	Bearing Nice 607	1
P-47	Socket Set Screw 5/16" X 5/16"	4			
P 48	F.H. Screw 3/8" X 7/8"	5"			
P 49	Roll Pin 3/16" X 1 1/2"	1"			

### GENERAL MFG. CO. LTD

MANUFACTURER OF CIRCULAR SAWS, BAND SAWS, WOOD LATHES,  
PLANERS, JOINTERS, MORTISERS, DRILL PRESSES, SHAPERS AND SANDERS

## REPLACEMENT PARTS

**IMPORTANT: Always give part number and description of  
item when ordering**

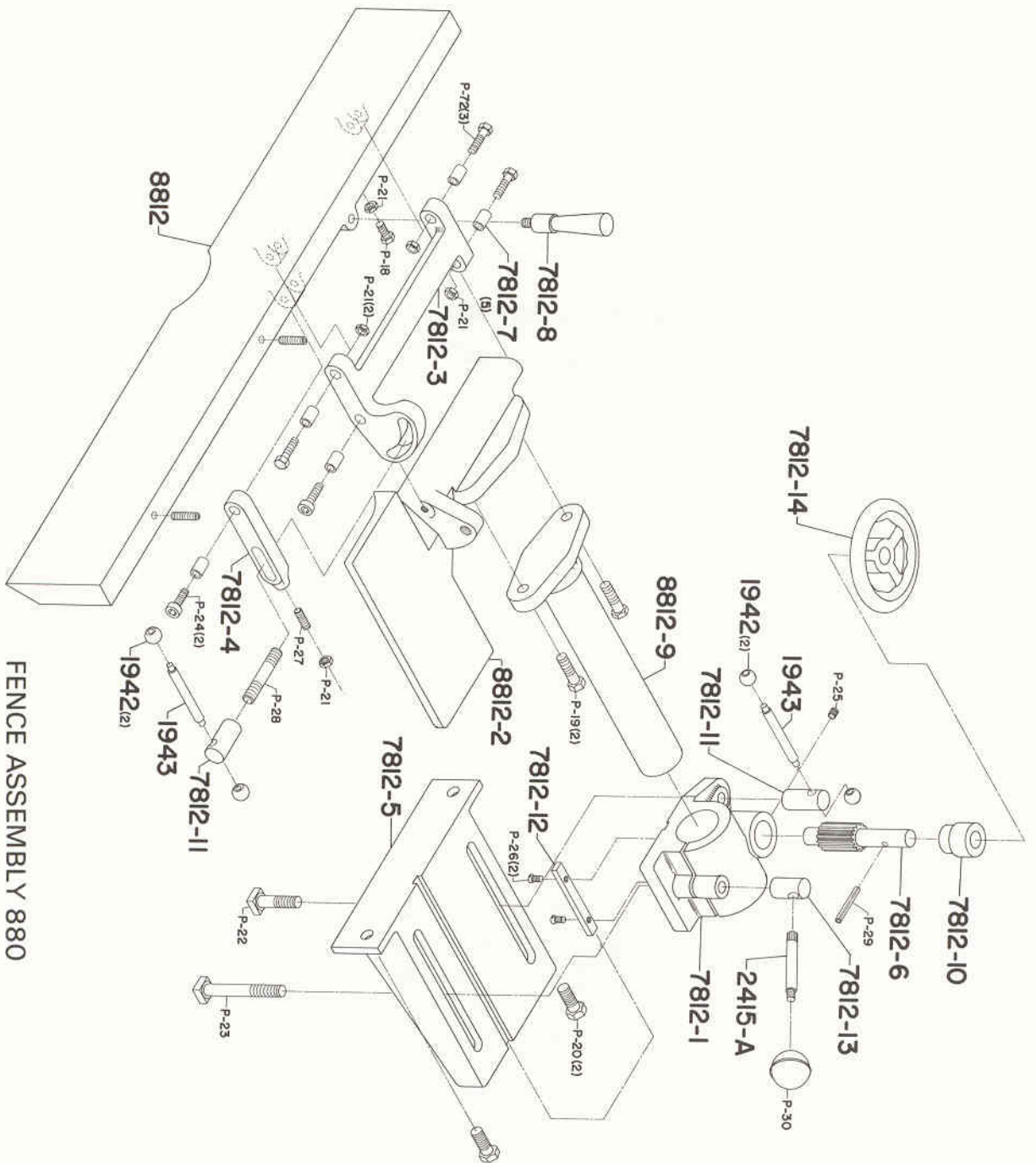
**Also give serial N°. and size of jointer**

Part N°.	DESCRIPTION	QTY	Part N°.	DESCRIPTION	QTY
P 67	Scale # 783-15	1	P 16	Grease Fit. 1/4-28 N°. 5010	2
P 68	Push Button	1	P 17	H.S. Knives 5/32 X 1- 1/4 X 16"	4
P 69	Starter	1	<b>FENCE ASSEMBLY</b>		
P 70	Motor	1	1942	Ball	4
<b>GUARD ASSEMBLY</b>			1943	Handle	2
7820-1	Pin		2415-A	Handle and Ball	
7820-3	Washer		7812-1	Arm Housing	
7820-4	Groove Pin		7812-3	Fence Link	
7820-5	Spring		7812-4	Locking Link	
8820	Guard	Alum.	7812-5	Table arm	
8820-2	Pin Holder		7812-6	Pinion	
P 1	Hex. H. Screw 7/16" X 1 1/4"	2	7812-7	Bushing	5
P 2	Spring see (7820-5)	1	7812-8	Fence Handle	
P 3	groove Pin Type 1 3/16" X 1 3/4"	1	7812-9	Arm	
P 4	Groove Pin Type 1 3/16" X 3/4"	2	7812-10	Collar	
<b>CUTTER-HEAD ASSEMBLY</b>			7812-11	1/2" Bolt	2
435-8	Chip-Breaker Screws	32	7812-12	Key	
785-9 (3334)	Bolts	8	7812-13	1/2" Bolt	
885	Cutter-Head		7812-14	Handwheel	
885-1	Chip-Breaker	4	8812	Fence	
885-2	L.H. Housing		8812-2	Fence Bracket	
885-3	L.H. Cover Ext.		P 18	HEX. H. Screws 5/16" X 1 1/4"	1
885-4	L.H. Cover Int.		P 19	Hex. H. Screws 7/16" X 1 1/2"	2
885-5	R.H. Housing		P 20	Hex. H. Screws 1/2" X 1 1/4"	2
885-6	R.H. Cover Ext.		P 21	Jamnut 5/16"	5
885-7	R.H. Cover Int.		P 22	Sq. H. Machine Bolt 1/2" X 2"	1
885-8	Cutter-head Pulley		P 23	Sq. H. Machine Bolt 1/2" X 4"	1
P 6	Hex. H. Screw 1/2" X 1 1/4"	4	P 24	Socket H. Screw 5/16" X 1 1/4"	2
P 7	Hex. H. Screw See (435-8)	32	P 25	Socket Set Screw 5/16" X 5/16"	1
P 8	Socket Set Screw 5/16"	1	P 26	F.H. Screw 10-32 X 3/8"	2
P 9	F.H. Screw 1/4" X 2 3/4"	6	P 27	Headles Slotted screw 5/16" X 1"	1
P 10	F.H. Screw 10-32 X 1"	8	P 28	Stud 1/2" X 3"	1
P 11	R.H. Ball Brg. N°. 1306	1	P 29	Groove Pin Type 3/16" X 1 1/2"	1
P 12	L.H. Ball Brg. N°. 1307	1	P 30	Plastic Ball 1" X 5/16" NC	1
P 13	Wrench 7/16"	1	P 72	Hex. H. Screw 5/16" X 1 1/4" 3	
P 14	Bearing Nut N°. N-06	1			
P 15	Bearing Nut N°. N-07	1			

### GENERAL MFG. CO. LTD

MANUFACTURER OF CIRCULAR SAWS, BAND SAWS, WOOD LATHES,  
PLANERS, JOINTERS, MORTISERS, DRILL PRESSES, SHAPERS AND SANDERS





FENCE ASSEMBLY 880





