

## 6" AND 8" JOINTERS OPERATING AND MAINTENANCE INSTRUCTIONS

### SPECIFICATIONS

Capacity .....	12,7 x 152,4 mm / 1/2" x 6"
Length of tables .....	1079,5 mm / 42-1/2"
Overall width .....	304,8 mm / 12"
Recommended speed .....	4200 R.P.M.
Motor for average work .....	1/2 H.P.
Rabbetting capacity .....	12,7 mm / 1/2"
Overall height .....	279,4 mm / 11"
Overall length .....	1219,2 mm / 48"
Pulley for 1725 R.P.M. motor .....	158,7 mm / 6-1/4" dia.
Height on stand .....	889 mm / 35"

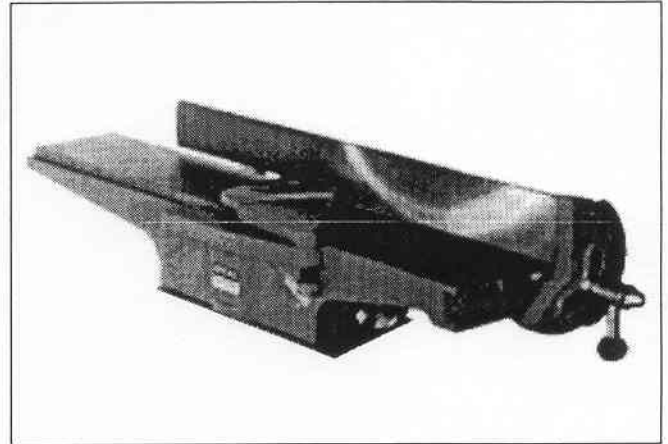
A jointer requires a reasonable amount of care and attention to insure perfect performance and accurate work. No matter how good the manufacturer made the machine, the operator must take care of it, if it is to continue to give the best results. It will take just a few moments to read and familiarize yourself with these instructions but they might save you a lot of trouble and time.

### INSTALLATION

Remove your jointer from the container or crate. Remove the bolts that hold it to the crate and take the plastic film away. Tables, fence and mechanism surfaces have been oil coated to prevent rusting. It is not necessary to remove this oil coat. However, if you wish, you can use fuel or varsol to do so. CAUTION: Never use lacquer reducer or remover as paint solvent will damage the paint. Your jointer is now ready to be placed on a stand or bench. In the case of the 6" (150 mm) jointer, you will have to reassemble the fence and the guard.

### POWER AND SPEED REQUIRED

For light work or home workshop a 1/3 HP capacitor motor is sufficient to drive this machine. For average work or steady production a 1/2 HP capacitor motor should be used.



With a standard 1725 RPM motor a 6-1/4" (160 mm) out. dia. pulley must be used to give the cutter head a speed of 4500 RPM which is recommended for satisfactory results. A higher speed would shorten bearings life with no benefit to the work. Be sure the motor runs in the right direction, so that the cutter head revolves towards the front table. If not, reverse motor wires as per instructions supplied with motor.

### ADJUSTMENT

This jointer left 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.

1- The rear table should be 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. Next, place the table in a position that is flush with the base at the slides.

2- The knives must be adjusted level with the back table in the following manner: Two straight edges (or straight pieces of hardwood) are placed on the back table.

The jack screws of the chipbreaker in the cutter

head are loosened with the small wrench. The knife is then pried up or tapped down (with a plastic hammer or some soft object in order not to damage the edge) until it just touches the straight edges; then the screws are tightened.

This is repeated for the other knives. It is very important that all knives are perfectly flush with the rear table. The knife ends should protrude 1/32" to 1/16" (about 1 mm) past the rabbeting clearance.

3- The front table is adjusted in the same manner as the rear table. As it will be very often moved, it should not be adjusted too tight. However, care must be taken so that the table is not loose on its slides as it will make it difficult to plane true work. Moreover, it will permit dust to get in the slides and throw your table out of alignment.

This adjustments gibbs and screws are also 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.

4- The front table should now be raised level with the rear table. The pointer on the front of the machine must be placed at zero as the knives just touch the work. The scale will now give you the exact thickness of cut up to 1/2 inch (12 mm).

## FENCE

The fence can be tilted to any desired angle until 45° one way or the other.

**To tilt the fence,** it is necessary to unlock the nut nearest the fence with the double end wrench, to draw back the movable stop, and then, while holding the fence with the other hand, to tilt it to the desired angle. The angle of tilt is indicated on the inclination scale.

The fence can also be easily and positively indexed to 45°, 90° or 135° when the specific adjustment screw reaches the movable stop block. Then the nut is tightened.

**To move the fence on the table,** it is necessary to loosen the other nut with the wrench, to place the fence where desired and lock it again. These two movements of the fence can be quickly performed.

**If the fence should get out of square,** it will be necessary to adjust it as follows: Push the stop forward and unlock the fence. Adjust the fence at 90° with a square and lock it in place. Then adjust the screw to touch the stop and lock it with the jam nut. Follow the same procedure to adjust the fence at 45° or 135°.

## LUBRICATION

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

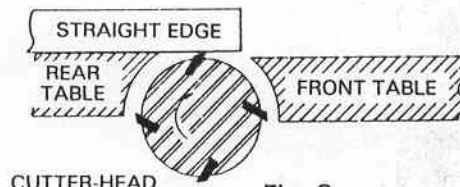


Fig. 3

METHOD FOR CHECKING  
KNIFE ADJUSTMENT

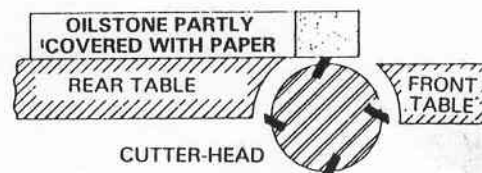


Fig. 7

JOINTING KNIVES

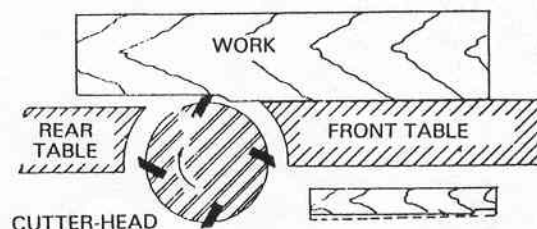


Fig. 4

REAR TABLE TOO LOW

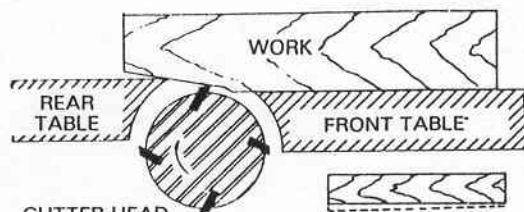


Fig. 5

REAR TABLE TOO HIGH

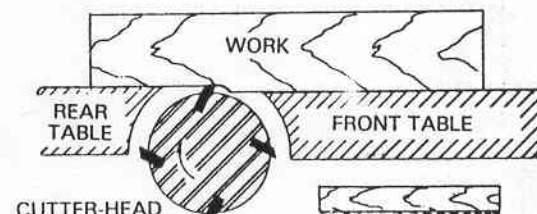


Fig. 6

REAR TABLE AT CORRECT HEIGHT

## REPLACEMENT PARTS FOR 6" (152.4 mm) JOINTER

*When ordering: Always give part number and description  
of each item. Also give serial number and size jointer.*

Ref. No.	Part No.	Description	Quant.	No. de réf.	No. de pièce	Description	Quant.
<b>Cutter Head Parts</b>				63	P-347	Spring pin 5/32 x 1	2
1	1185	Cutter head	1	<b>Fence Parts</b>			
6	1185-2	Left bearing case	1	12	11812	Fence	1
6A	1185-1	Right bearing case	1	13	11812-1	Sliding plate	1
16	1185-3	Chip breaker	3	14	11812-2	Tilting plate	1
30	1185-4	2-1/2" (63.5 mm) O.D. Pulley	1	18	11812-3	Sliding nut plate	1
40	P-341	3/8" x 4" Hex. bolt	2	21	11812-4	Swivel stud	1
43	485-6	Chip breaker screw	12	22	11812-6	Fence stud	1
44	P-7	5/16" x 5/16" Socket set screw	2	23	11812-7	Pivot w / P-344 spr. pin	1
51	P-189	Ball-bearing 6202-2RS	1	24	11812-8	Double action wrench	1
52	P-279	Ball-bearing 6203-2RS	1	25	11812-9	Handle	2
56	P-340	Knives 1/8" x 3/4" x 6"	3	26	P-33	50-CPlastic Knob	1
57	1840	Moteur Pulley	1	27	11812-10	Washer	1
<b>Table and Base Parts</b>				28	11812-11	3/8" Acorn nut	1
2	1181-10	Handwheel	2	31	11812-12	Pointer	1
2A	1181-7	Screw	2	32	P-87	3/16" x 1-3/4" Roll pin	1
3	1181-5	Collar	2	33	11812-5	Stop block	1
3A	1181-6	Collar	2	36	P-342	Inclination scale	1
7	1181-3	Screw block	2	45	P-38	5/16" x 1-1/4" Soc. Head screw	3
8	1181-2	Front table	1	46	P-3	1/4" x 1/4" Socket set screw	1
9	1181-1	Rear table	1	47	P-886	1/4" x 1" Socket set screw	3
10	1181	Base	1	48	P-106	5/8-18 Jam nut	1
15	1181-8	Gib	2	54	P-199	1/4-20 Jam nut	1
17	1181-9	Gib screws	8	55	P-315	Drive screw	3
31	J-80-19	Pointer	1	60	P-105	5/16" x 1/2" Set screws	1
37	P-338	1181-18A Depth scale	1	<b>Guard Parts</b>			
38	P-337	191-8 Name plate	1	11	11820-1	Guard pin	1
41	P-305	5/16" x 1-1/2" Hex. cap. screw	4	20	11820	Guard	1
44	P-7	Set screw 5/16" x 5/16"	2	42	P-126	3/16" x 1-1/4" Spring pin	1
54	P-199	Jam nuts 1/4" x 20	6	50	P-685	Tension spring	1
55	P-315	#2 x 1/4" Drive screws	4	62	11820-3	Castle washer	1
58	P-336	1/4" x 3/4" Set screws	6				
59	P-120	Tapping screw	1				

## REPLACEMENT PART FOR 8" (203.2 mm) JOINTER

*When ordering: Always give part number and description  
of each item. Also give serial number and size of jointer.*

Ref. No.	Part No.	Description	Quant.	Ref. No.	Part No.	Description	Quant.
<b>Cutter Head Parts</b>				<b>Fence Parts</b>			
1	381	Cutter head	1	12	11812	Fence	1
6	485-2	Left hand bearing case	1	13	11812-1	Sliding plate	1
6A	485-1	Right hand bearing case	1	14	11812-2	Tilting plate	1
16	485-3	Chip breaker	3	18	11812-3	Sliding nut plate	1
30	3835	2-1/2" (63.5 mm) O.D. Pulley	1	21	11812-4	Swivel stud	1
40	P-341	3/8" x 5-1/2 Hex. bolt	2	22	11812-6	Fence stud	1
43	485-6	Chip breaker screw	15	23	11812-7	Pivot w/spring pin P-344	1
44	P-7	5/16" x 5/16" Socket set screw	1	24	11812-8	Double action wrench	1
52	P-194	Ball-bearing (6204-2RS)	2	25	11812-9	Handle	2
56	P-350	1/8" x 3/4" x 8" Blade (3801)	3	26	P-33	Plastic knob	1
57	1840	Motor pulley	1	27	11812-10	Washer	1
<b>Table and Base Parts</b>				28	11812-11	3/8" Acorn nut	1
2	182	Ball handle w/screw	2	31	11812-12	Pointer	1
3	183	Collar	2	32	P-87	3/16" x 1-3/4" Roll pin	1
7	187	Nut	2	33	11812-5	Stop block	1
8	389	Rear table	1	36	11812-13	Inclination scale P342	1
9	388	Front table	1	45	P-38	5/16" x 1-1/4" Soc. head screw	3
10	3810	Base	1	46	P-3	1/4" x 1/4" Socket set screw	1
15	3815A	Gib	1	47	P-886	1/4" x 1" Slotted set screw	3
15	3815B	Gib	1	48	P-106	5/8"-18 Jam nut	1
31	J-80-19	Depth pointer	1	54	P-199	1/4"-20 Jam nut	1
38	P-337	Name plate 191-8	1	<b>Guard Parts</b>			
41	P-223	5/16" x 7/8" Hex. cap screw	2	11	1811	Guard pin	1
54	P-199	1/4" Jam nut	10	20	3820	Guard	1
58	P-270	1/4" x 7/8" Socket set screw	10	42	P-247	1/8" x 3/4" Cotter pin	2
				50	P-10	Tension spring 3821	1

**GENERAL**

**DÉGAUCHISSEUSES 6" ET 8" / 6" AND 8" JOINTERS**

