Get Acquainted with Your Jointer...

Before using it, familiarize yourself with the major parts and controls by studying the cut-a-way view below. Read and follow the instructions carefully — then you'll get the most from your jointer-planer.

The fence, cutter guard and instructions are packed in supports that hold jointer in carton. Be sure all parts are removed before destroying carton.

**MOTOR** — A ¼ or ½ HP, 1725 RPM motor is recommended.

**BELT-MOTOR PULLEY** — Use a 4” dia. motor pulley and a ½” wide x 9/32” thick x 36” long V-belt. If motor is 3450 RPM, use a 2” dia. motor pulley.

**KEEP THE BLADES SHARP** — The jointer does better work, faster and safer, when the cutting edges are sharp. When the surface of the planed wood begins to have a slight fuzzy look, when you feel the stock chattering, or when it seems difficult to feed the stock across the blades — it's time to sharpen the blades. Generally honing is all that's necessary, if this is ineffective have the blades sharpened by someone who specializes in such work.
INSTALLATION

1 Jointer and motor mounted on bench top.

2 (Right) Motor mounted on shelf beneath jointer. Use a dust chute to protect motor.

MOUNTING JOINTER

For best results, use a sturdy, level bench. Bench should be about 29" high — this can vary depending upon the height of the operator. Motor may be mounted either on bench top or shelf below jointer, whichever is most desirable, see Figures 1 and 2.

Mounting Jointer with Motor on Bench Top —

1 — Bench top should be not less than 14" wide x 25" long — use good, strong, thick lumber. Position jointer so that base is almost flush with front of bench.
2 — Mark and drill mounting holes.
3 — Cut a 4" wide x 6½" long hole in bench top for chip disposal.
4 — Before bolting jointer, make sure base rests solidly on bench — use shims if necessary. Uneven mounting could throw tables out of alignment.
5 — Lubricate bearings, see LUBRICATION, page 3.

Mounting Jointer for Underneath Drive —

1 — Bench top should be not less than 14" wide x 16" long — use good, strong, thick lumber. Position jointer so that base is almost flush with front of bench.
2 — Mark and drill mounting holes.
3 — Cut hole in bench top for both chip disposal and drive belt.
4 — Before bolting jointer, make sure base rests solidly on bench — use shims if necessary. Uneven mounting could throw tables out of alignment.
5 — A dust chute, made from plywood, should be used to keep dust and chips off the motor.
6 — Lubricate bearings, see LUBRICATION, page 3.

MOUNTING MOTOR

1 — Slide pulley on motor and lock securely with set screw.
2 — Mount motor on bench or shelf. Place belt over pulleys, shifting motor until pulleys are in a straight line and belt is tight. IMPORTANT — Maintain proper belt tension — belt should be just tight enough to prevent slipping. If the belt is too loose it will slap — if too tight, belt and pulleys will overheat and overload motor. Motor may be bolted directly to bench, or mounted on a Motor Rail.
3 — Remove belt and check motor rotation before operating jointer. Cutterhead should rotate counterclockwise viewed from pulley end.

MOUNTING FENCE

Fasten fence to front table with bolt and fence lock knob — see Figure 3. Lock fence in place with the fence lock knob.

MOUNTING CUTTER GUARD

Turn knurled knob on the guard about three-quarter turn clockwise, then insert into hole in top of front table. To change the spring tension, remove guard and turn knob. Spring should have a little more than enough tension to keep guard over the cutters and against fence.

Do not adjust screw in side of table — it is set to hold guard assembly in place and permit quick removal.
CONTROLS
(See illustration on cover)

1 — Knob beneath front table raises and lowers table for depth of cut. When lowering table for depth of cut, bring it down just below actual depth required, then raise it to correct height. This moves all slack from the screw.

2 — Fence lock knob controls both width and angular positions of fence. To position, merely release fence slide lock. Fence tilts 0° to 45° left or right. Use front table edge as an indicator for tilt gauge, see Figure 4. When a very accurate setting is desired, use a combination square or protractor to set the fence — see Figure 6.

CAUTION: Stop motor before making any fence adjustments.

4 Use front table edge as tilt gauge indicator.

KEEP YOUR JOINTER IN TIP-TOP CONDITION . . .
It’s Easy if You Follow These Suggestions

1. Adjusting Fence Perpendicular to Table — Loosen fence lock knob, and with a square, set fence perpendicular to table — see Figure 6. The 90 degree mark should be even with top of table. To adjust, merely loosen screws.

Adjusting Cutter Blades — The blades have been accurately machined and set at the factory and need no further attention other than honing and sharpening. If, after honing or sharpening the blades, a gouge or step appears on the planed surface, one or more of the blades are not at the correct height or not level with the rear table. To adjust, see MOUNTING BLADES IN CUTTERHEAD, parts 3 and 4, page 4.

3. To Eliminate Spindle End Play —
   (a) Loosen set screw in spindle pulley.
   (b) Push cutterhead firmly to the right, against fibre washer, at the same time forcing pulley against washer on opposite side of spindle bearing — see Figure 7. Lock pulley in this position.
   (c) Rotate spindle by hand to make sure it turns freely — DO NOT HAVE SPINDLE ADJUSTMENT TOO TIGHT.

LUBRICATION

Before Operating Jointer, Lubricate Bearings Thoroughly

Use S.A.E. No. 20 Machine Oil

1 — Spindle Bearings — Lubricate regularly thru holes in jointer frame.

2 — Front Table and Frame Ways — Oil at regular intervals.

3 — Table Adjusting Screw — Oil at regular intervals.

5 Use a square to set fence right angles to table when an accurate cut is desired.

7 To eliminate spindle end play, push cutterhead in direction indicated and pulley in opposite direction.
SHARPENING THE CUTTER BLADES

KEEP THE BLADES SHARP — The jointer does better work, faster and safer, when the cutting edges are sharp. When the surface of the planed wood begins to have a slight fuzzy look, when you feel the stock chattering, or when it seems difficult to feed the stock across the blades — it's time to sharpen the blades. Generally honing is all that's necessary, if this is ineffective have the blades sharpened by someone who specializes in such work — or replace the blades.

HONING BLADES

Before honing the blades, check their alignment with the rear table (see MOUNTING BLADES IN CUTTER-HEAD, parts 3 and 4). Then lower front table about 1/8" below cutting edge of blades. Partly cover the stone with paper — so it won't scratch the table — and lay it on front table. Turn cutterhead and adjust table so that stone is resting flat on the bevel of the blade. Hold the pulley or wedge the cutterhead in this position so it cannot turn and rub the stone with an even pressure lengthwise of the blade until the blade is sharp — see Figure 8.

GRINDING BLADES

When honing is ineffective, grind the blades. Remove the blades from the cutterhead by turning lock screws clockwise — use the wrench furnished. If you're not familiar with grinding the blades, have them sharpened by someone who specializes in such work.

If the blades are badly nicked they should be replaced with a new set, No. 6151.

1. Clean cutterhead slots, blades and chippers.
2. Insert blade and chipper with lock screws in the cutterhead slot — see Figure 9. Make sure groove in chipper is up. Adjust blade so it projects 1/16" beyond left edge of cutterhead — side opposite pulley. It's important that each blade projects the same amount — accurate rabutting is impossible if they do not. Snug up the blade lock screws but do not tighten securely.
3. Place a steel rule on the rear table with one end projecting over the cutter blade — see Figure 10.
4. Revolve cutterhead by hand and adjust blade to touch steel rule — BUT NOT MOVE IT. Repeat on opposite side of rear table. If a blade is high, tap it lightly with a piece of wood — if it's low, raise by inserting a small screw driver under bottom edge. Before tightening screws make sure chip breaker seats firmly against bottom of cutterhead slot. Blade is held firmly in position by turning set screws counterclockwise, tightening them securely against cutterhead.
5. Repeat above operations for other two blades, then re-check blade alignment. Before operating, turn cutterhead by hand to make sure blades clear table and base.

MOUNTING BLADES IN CUTTER-HEAD

The blades must be carefully reset in the cutterhead, It is very important that each blade is the same height and level with the rear table along its entire length.

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5. Repeat above operations for other two blades, then re-check blade alignment. Before operating, turn cutterhead by hand to make sure blades clear table and base.
OPERATION

11 (Above) Use a pusher block for planing thin wood. (Left) Construct wood pusher block similar to the one shown.

PLANING

Wood up to 4" wide may be surfaced without removing the guard or fence.

Start the planing operation by first holding the work with both hands over the front table. Place the left hand on the front portion of stock as soon as the stock rests solidly on the rear table. When the right hand approaches the blades, the work is held down firmly with the left hand, using the right hand to guide and hold the stock against the fence.

Always plane a board WITH the grain. If the direction of the grain changes, feed the stock SLOWLY. When planing wood wider than 4", remove the guard and fence. Take thin successive cuts across the board.

CAUTION: When planing boards under 1/2" thick, always use a pusher block, to feed the work past the blades; see Figure 11.

Holes in the fence can be used to fasten an auxiliary wood facing to help support large work. If motor is mounted on bench, it may be necessary when planing large boards to raise jointer with blocks so stock will clear motor.

JOINTING

When making square or bevel joints, an equal amount of pressure must be applied to hold the work securely against both the fence and table. Use the left hand to hold work firmly on rear table, the right to feed and guide the work against the fence. Feed the work into the blades at a uniform speed. When jointing ends of stock, take very light cuts — a heavy cut may tear the grain at the end of the stock. If the board is wider than its finished dimensions, plane the ends first, then the sides. If the board is already planed to width, a short cut of 1/2" to 1" is made at one end, then the work reversed and fed from the opposite side, see Figure 15. Holes in the fence can be used to fasten an auxiliary wood facing to help support large boards.

CAUTION: If a large amount of jointing must be done, the fence should be moved occasionally to distribute the wear over the blades. Jointing constantly in the same position will eventually wear a groove in the blades.

Successive Steps in Jointer Operation
BEVELING AND CHAMFERING

Tilt the fence and lock it in the desired position. Take medium cuts until bevel is near full shape — take light finishing cuts. It's usually better to tilt fence to the left as shown in Figure 17 — it's easier to feed, hold the work, and safer for the operator.

RABBETING

Remove guard and slide fence toward left edge of table until it's the same distance from left end of CUTTER BLADES as the width of the rabbet desired, see Figure 16.

The maximum depth of rabbet is 5/16". Lower the front table to depth desired — the full depth of rabbet can be made in one cut — if cut is wide and deep a better finish is obtained by first taking a roughing cut, then a light finishing cut. Feed the work slowly if cut is wide or deep.

TAPER CUTTING

Tapers on stock that are shorter in length than 10" — the length of front table — can be made in one cut — however, a light finish cut is necessary to extend taper full length of stock. Lower the front table about 1/32" less than the full depth of taper desired. Take taper cut by placing stock against fence and position so that front edge will fall on rear table. Raise the table and take light finish cut on full length of stock.

When long tapers are to be cut, the stock is divided into a number of equal parts, each part slightly less than the length of the front table. The depth of the taper must also be divided into a corresponding number of equal parts. If an 18" board was to be tapered 3/16", the board would be divided into two equal parts and the front table set to 3/16" depth of cut.

Two cuts are necessary — cut the rear of the stock first by placing the board over the blades at the center mark. The second cut is started at the far end and proceeds the full length of the board to complete the taper, see Figure 20.
To cut short tapers, make a templete or fixture with the same taper as required on the pieces you’re making. Cut templete long enough to sufficiently support the work, with one end about 1/16” thick. Mark templete to the work with brads, positioning it near the point where the taper starts — see Figure 19.

Short tapers are cut by pulling the work over the blades. Lower the front table. An auxiliary wood fence should be used to help support and guide the work. Position work on rear table so that start of taper is over the blades. The stock is then pulled over the blades to make the taper — see Figure 19. Take several cuts if angle of taper requires it.

**SUGGESTIONS FOR SAFE OPERATION AND MACHINE MAINTENANCE**

- Keep guard on machine whenever possible.
- Keep blades sharp — check alignment regularly.
- Be sure the blades are locked securely in the cutterhead.
- Keep fence locked securely.
- STOP the machine when making adjustments.
- Always examine stock carefully before planing to make sure it’s free of loose knots, nails and old paint.
- When planing thin stock always use a pusher block or topping board to feed the work past the cutters. Keep your hands on top of the work.
- When a very smooth finish is required, take cuts of 1/32” or less, and feed the stock slowly.
- Mount machine properly — follow the instructions on page 2.
- Cut a hole in bench top to simplify chip removal.
- Maintain proper belt tension — keep the belt just tight enough to prevent it from slipping.
- Keep set screws in motor and arbor pulleys tight to prevent scoring of motor shaft and arbor.
- Keep the jointer tables and fence covered with oil or wax when jointer is not in use.
- Always plane a board WITH the grain. If the direction of the grain changes, feed the stock slowly.
PARTS FOR NO. 9350 4" JOINTER-PLANER

ORDERING INFORMATION

IMPORTANT — The following information must be furnished on all repair part orders —
1 — Quantity Required
2 — NUMBER and NAME of Part
3 — Model Number

Parts shown without part numbers are standard parts and should be purchased locally.

Be sure to give Model Number on this part.
Plate located on jointer base.

MOTOR PULLEY AND BELT — EXTRA
- 4 1/4" dia. Motor Pulley
- V-belt, 1/2" wide x 3/8" thick x 36" long

Dealer can supply belt and pulley recommended.

J4-7 FENCE
J4-9 SCALE
J4-11X CUTTER GUARD ASSEMBLY
J4-12X CUTTER GUARD ASSEMBLY

J4-1 FRAME
J4-13 SPRING J4-15 CHUCK
J4-18 WEDGE

J4-17 CHIP BREAKER (3 Req'd)
J4-20 SPRING

J4-21 LOCK SCREWS (9 Req'd)
J4-22 BEARING

J4-26 STUD
J4-27 COLLAR

J4-10 BEARING
J4-29 NUT

J4-28 SPRING
J4-30 GROOVE PIN

J4-31 WASHER
J4-32 HEX. CAP SCR.

6151 BLADE (Set of 3)

ATLAS PRESS CO. KALAMAZOO, MICH., U.S.A.