

# Model 50 6" JOINTER

## MAINTENANCE INSTRUCTIONS AND PARTS LIST



# POWERMATIC®

Strength and performance right down the line.

POWERMATIC  LOUDAILLE INC.

# FORWARD

Safety first!

This manual has been prepared for the owner and operators of a Powermatic Model 50-6" Jointer.

Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating procedures. Read the safety instructions thoroughly before operating the machine!

In order to obtain maximum life and efficiency from your Powermatic Jointer and to aid in operating the Jointer with safety, read this manual thoroughly and follow all instructions carefully.

The specifications put forth in this manual were in effect at the time of publication. However, owing to Powermatic's policy of continuous improvement, changes to these specifications may be made at any time without obligation on the part of Powermatic Houdaille, Inc.

## WARRANTY

This machine and its component parts have been carefully inspected at various stages of production and each finished machine is subjected to a final inspection before shipment. We agree that for a period of eighteen (18) months from date of delivery from our authorized dealer to replace, at our option, any machine (or component part thereof) proving defective within the above period, F.O.B. our plant providing such machine (or component part) is returned prepaid to our plant, or a designated service center of the undersigned, for our examination. **THIS WARRANTY DOES NOT INCLUDE REPAIR OR REPLACEMENT REQUIRED BECAUSE OF MISUSE, ABUSE, OR BECAUSE OF NORMAL WEAR AND TEAR; OR ELECTRICAL MOTORS WHICH ARE WARRANTED BY THEIR MANUFACTURER AND WHICH SHOULD BE TAKEN TO THEIR LOCAL AUTHORIZED REPAIR STATION FOR SERVICE. FURTHER, WE CANNOT BE RESPONSIBLE FOR THE COST OF REPAIRS MADE OR ATTEMPTED OUTSIDE OF OUR FACTORY OR DESIGNATED SERVICE CENTER WITHOUT OUR AUTHORIZATION. NO CLAIMS FOR DEFECTS WILL BE HONORED IF SERIAL NUMBER PLATE HAS BEEN REMOVED. THIS WARRANTY IS MADE EXPRESSLY IN PLACE OF ALL OTHER WARRANTIES OR GUARANTEES, EXPRESS OR IMPLIED, WITH RESPECT TO FITNESS, MERCHANTABILITY, QUALITY OR OPERATIVENESS. THIS WARRANTY BECOMES EFFECTIVE ONLY WHEN THE ACCOMPANYING CARD IS FULLY AND PROPERLY FILLED OUT AND RETURNED TO THE FACTORY WITHIN TEN (10) DAYS FROM DATE OF DELIVERY.**

## SAFETY INSTRUCTIONS

1. **Read and understand** the safety and operating instructions found in this manual. **Know** the limitations and hazards associated with this jointer. A safety rule decal is installed on each machine to serve as a reminder of basic safety practice.

**Grounding of the Jointer** — Make certain that the machine frame is electrically grounded and that a grounding lead is included in the incoming electrical service. In cases where a cord and plug are used make certain that the grounding lug connects to a suitable ground. Follow the grounding procedure indicated by the National Electric Code.

3. **Eye Safety** — Wear an approved safety shield, goggles or glasses to protect eyes when operating the jointer.
4. **Apparel** — Before operating machine, remove tie, rings, watch and other jewelry, and roll up sleeves above elbows. Remove all loose clothing and confine long hair. Protective type foot wear should be worn.
5. **Work Area** — Keep the floor around the machine clean and free of scrap material, sawdust, oil or grease to minimize the danger of tripping or of slipping.

The manufacturer recommends the use of anti-skid floor strips on the floor area where the operator normally stands, and that each machine work area be marked off.

6. **Guards** — Keep machine guards in place, make certain they are operable, and use them at all times on operations where they can be used. On operations requiring removal of the cutterhead guard, make certain the guard is replaced immediately following the completion of that operation.
7. **Don't Overreach** — Maintain a balanced stance and keep your body under control at all times. Do not overreach or use excessive force to perform any operation.
8. **Maintain Tools in Top Condition** — Keep tools sharp and clean for safe and best performance. Dull tools may cause kickbacks and chatter. Broken tools or tools that are not securely locked in the cutterhead can be thrown out of the jointer causing severe or fatal injury. Check the condition and adjustment of the tools before making any cuts. Follow the instructions on knife sharpening, installation and adjustments.
9. **Operator Position** — Stand to one side and out of line of the cutterhead knives and make certain that any other person near the machine does the same.
10. **Hand Safety** — Always use an approved push block or push stick when jointing stock that does not provide a distance of safety for your hands.
11. **NEVER** surface stock less than 12" long × 3" wide × 1" thick or edge stock less than 12" long × 3" wide × 1/4" thick without a hold down push block. **NEVER** joint stock under 6" long without the use of special fixtures.
12. **Machine Adjustments** — Make all adjustments with the power off. Make certain that the fence is adjusted for the operation to be performed and that it is locked for angle and location.
13. **Avoid Accidental Starting** — Make certain switch is "OFF" before connecting power to the jointer.
14. **Careless Acts** — Give the work you are doing and the cutterhead your undivided attention. Looking around, carrying on a conversation and "horse play" are careless acts that can result in serious injury.
15. **Job Completion** — If the operator leaves the machine area for any reason the jointer should be turned "OFF" and the cutterhead should come to a complete stop before his departure. In addition, if the operation is complete clean up the jointer and the work area. **NEVER** clean the jointer with it "ON" and never use the hands to clear sawdust and debris, use a brush.
16. **Disconnect Machine** — Before performing any service or maintenance and when changing blades.
17. **Work Area** — Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust.
18. **Replacement Parts** — Use only Powermatic or factory authorized replacement parts and accessories, otherwise, the jointer warranty and guarantee will be null and void.
19. **Misuse** — Do not use this Powermatic Jointer for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless for any injury which may result from that use.



**WARNING: DO NOT EQUIP OR USE THIS JOINTER WITH A MOTOR LARGER THAN 3/4 HORSEPOWER AT 3600 R.P.M. OR OPERATE THE CUTTERHEAD IN EXCESS OF 5000 R.P.M. USE OF A LARGER HORSEPOWER MOTOR OR HIGHER CUTTERHEAD SPEED VOIDS THE WARRANTY AND POWERMATIC HOLDS ITSELF HARMLESS FOR ANY INJURY WHICH MAY RESULT.**

**SPECIFICATIONS:  
 POWERMATIC — MODEL 50-6" JOINTER**

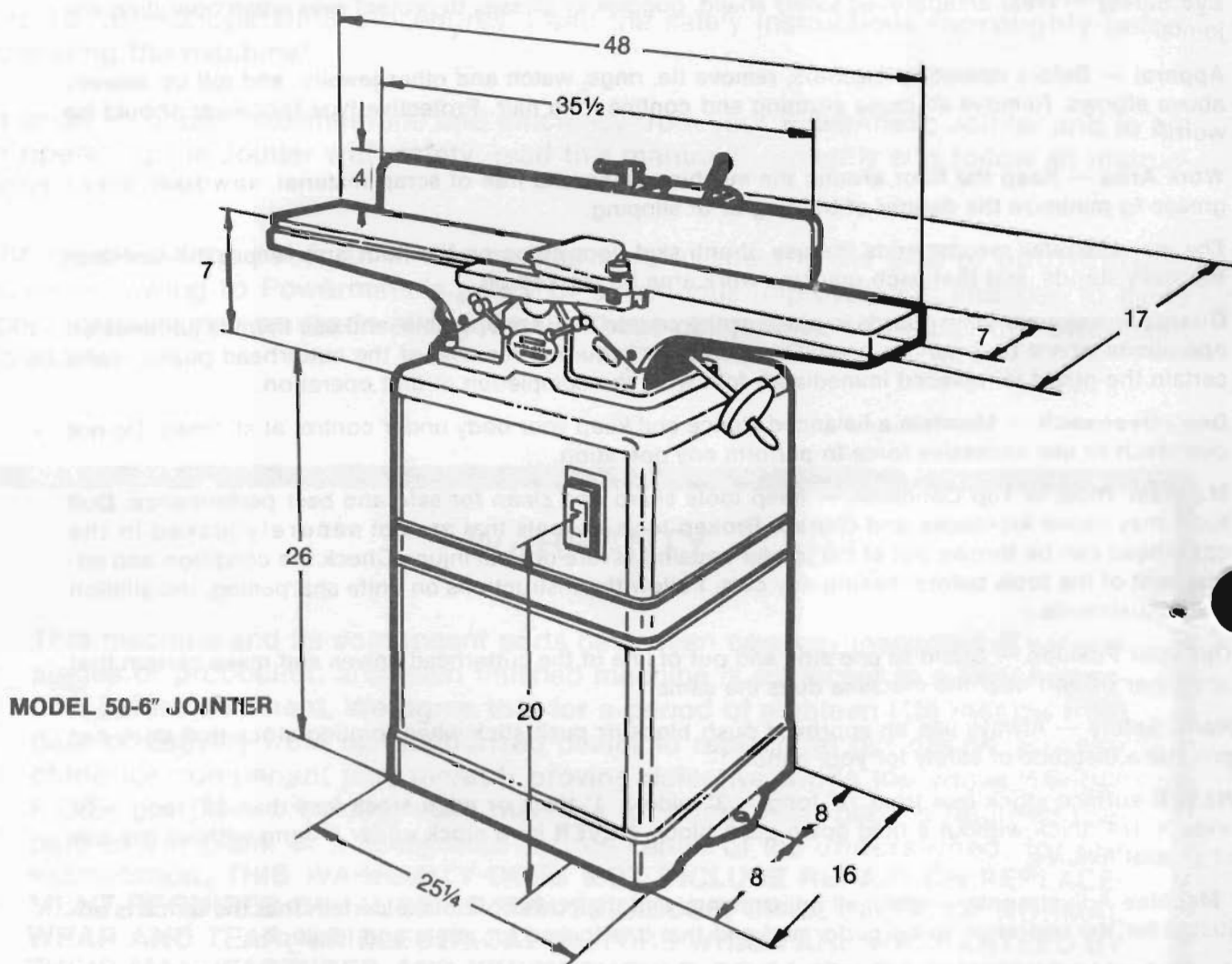


Table .....	7" x 48"
Head cutting arc .....	3"
Knives (3) H.S. steel .....	1/8" x 3/4" x 6"
Speed of head (recommended) .....	5000 r.p.m.
Knife-cuts-per-minute .....	15,000
Maximum depth of cut .....	1/2"
Maximum rabbeting cut .....	0" up to 1/2" x 6"
Fence size overall .....	4" x 34-1/2"
Fence tilt, right or left .....	45°
Height, less stand .....	14"
Height, with stand .....	40"
Motor recommended .....	1/2 or 3/4 HP
Weight, domestic crated, with stand & motor .....	290 lbs. Approx.
Weight, domestic crated, less stand .....	190 lbs. Approx.
Weight, domestic crated, with stand .....	265 lbs.

\* The above specifications, dimensions and design characteristics are subject to change without notice.

## Receiving the Jointer:

Remove the jointer assembly and base from their respective shipping cartons and inspect for damage. Any damage should be reported to your distributor immediately.

Clean protective coating from jointer assembly and base with a suitable solvent. **Caution:** Do not use gasoline or highly volatile solvents.

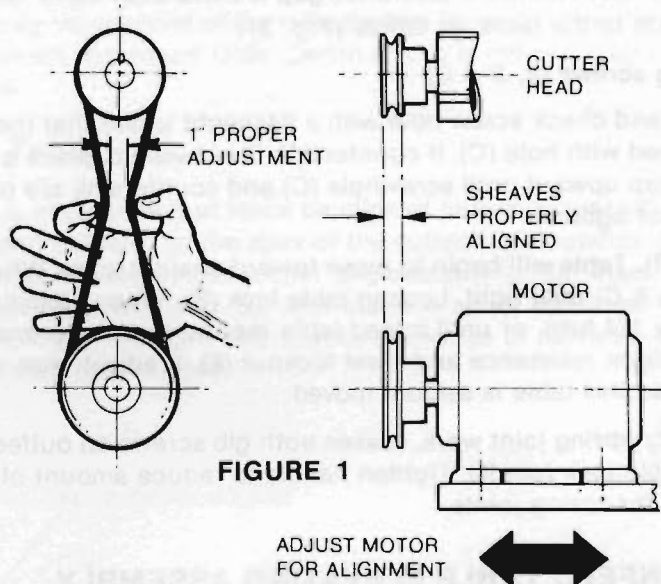
Before proceeding further, read your instruction manual thoroughly to familiarize yourself with proper assembly, setup, maintenance and safety procedures.

## Installation of the Jointer:

Mount base to the floor with high quality anchor bolts. Bolts are attached through the mounting holes on each side of the base.

After base has been secured to a solid foundation, align the holes in the bottom of the jointer with the holes in the top of the base and secure with the three mounting bolts provided.

Attach the drive belt as shown in (Fig. 1) and adjust belt. Using thumb and index finger, compress belt at center until it becomes taut. At this point the distance between the insides of the belt should be one inch. Using the adjusting slot on the motor support, raise or lower motor support base to obtain proper tension and retighten base.



Check all mounting screws and set screws to see that they are locked.

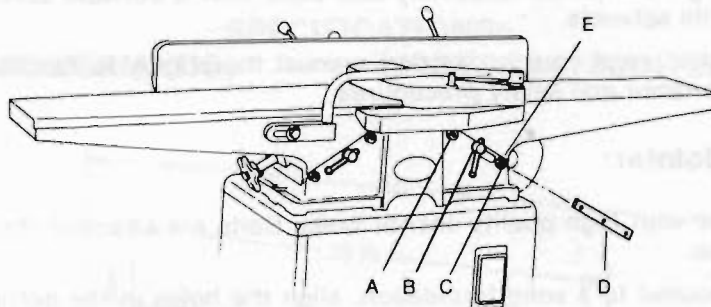


FIGURE 2

## JOINTER ADJUSTMENTS

### Leveling Tables:

Check clearance gap on the infeed and outfeed tables by placing a straight edge (steel or carefully jointed wood) across the full length of both tables. If clearance gap is more than .0015" on either table, the following adjustments must be made to the table, or tables (Fig. 2).

Loosen gib and table locking screws (A, B & C).

Remove lower gib screw (C) and check screw hole with a flashlight to see that the countersink in the steel wear gib (D) is properly aligned with hole (C). If countersink is not visible, place a screwdriver or chisel on the end of the wear gib and tap upward until screw hole (C) and countersink are properly aligned. Replace lower gib screw (C) but do not tighten.

Carefully tighten table lock (B). Table will begin to move toward straight edge. When table touches straight edge, reset the gib screws (A & C) until tight. Loosen table lock (B). When adjusting infeed table, back off screws (A & C) approximately 1/4 turn, or until infeed table may be moved up and down by raising mechanism handwheel with only slight resistance and reset locknut (E). If adjustment is being made to outfeed table, leave gib screws tight as this table is seldom moved.

To loosen the outfeed table for spring joint work, loosen both gib screws on outfeed table. Amount of end-drop is controlled with the table lock handle. Tighten handle to reduce amount of drop. A 1/32" drop usually creates the ideal concave for spring joints.

### INFEEED TABLE ELEVATING ASSEMBLY

After a period of time the infeed table elevating wheel may bind against the base, therefore preventing proper table adjustment.

If binding occurs, loosen the collar set screws on each side of the rear table raising bar and turn handwheel counter-clockwise until it has cleared the bind point approximately one inch (Fig. 3).

Push the collars against the rear table raising bar and tighten the set screws with an allen wrench.

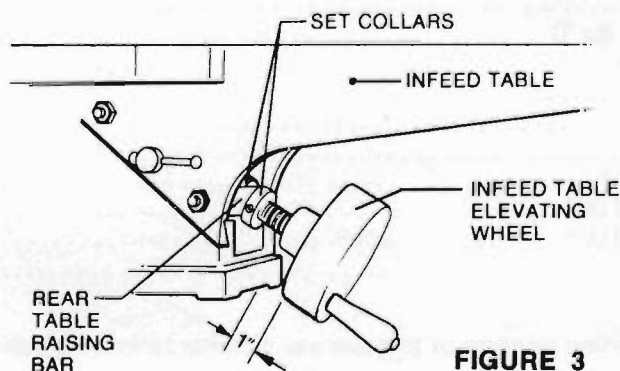


FIGURE 3

## Table Removal:

To remove table loosen setscrews in table, raising screw collars (Fig. 3). Turn raising screw counterclockwise and remove. Remove production locking screws, gib locking screws and wear gib. Remove the jointer from its base and place on its side. Remove cap screws from jointer. See cutterhead removal and remove cutterhead. Slide tables upward.

Installation can be accomplished by reversing the removal procedure.

## Gib Adjustment:

Gib adjustment must be maintained to insure against play between the jointer and the infeed and outfeed tables. To adjust gibs loosen the gib and table locking screws (Fig. 3). Remove lower gib screw and with a flashlight check to see that countersink hole in wear jib is in alignment with the screw hole. If countersink is not visible, or if it does not line up with screw hole, place a screwdriver on the end of the gib and gently tap upward until the countersink and screw hole are in complete alignment. Retighten screws.

If after performing the preceding adjustment, play is still evident between jointer and tables, remove gib screws and table locking handle and remove gib. Check gib to make certain drill spots for the set screws do not go all the way through the gib or have not dimpled the opposite side. If either of these conditions exist order a new gib.

Replace gib, making certain that countersink is in line with locking screw holes. Replace screws and level table.

Whenever gib adjustment has been made, re-check tables to be certain they are still level. (See "LEVELING TABLES").

## Depth of cut adjustment:

Depth of cut is determined by height level of the infeed table. Raise or lower the infeed table by turning the handwheel located underneath the infeed table. Depth of cut is indicated by the depth gauge located on the side of the jointer ways.

## Squaring Fence With Table:

Before operating jointer it is imperative that fence be aligned perpendicular (90°) to the outfeed table. After outfeed table height has been adjusted to the apex of the cutter blade rotation (See "LEVELING TABLES") use a machinist's all purpose square to get proper alignment (Fig. 4). Placing square on outfeed table near cutterhead, loosen lock nut (A) (Fig. 5) and insert a small rod in adjusting post (B). Turn post clockwise to move top of fence to the right and counterclockwise to move fence to the left. When fence is square with outfeed table reset lock nut (A).

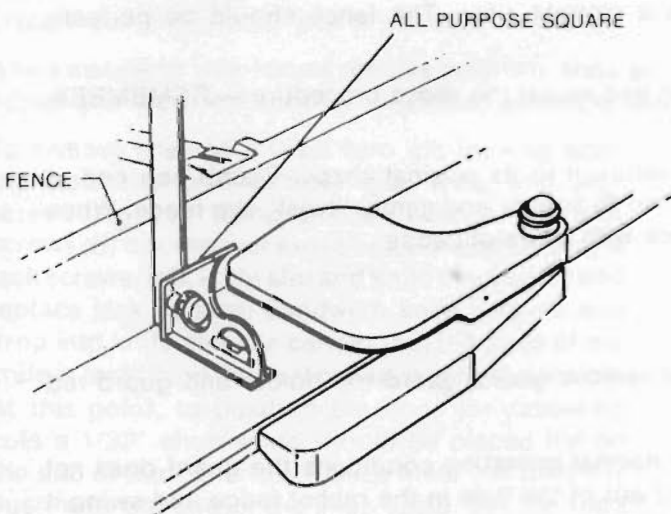


FIGURE 4

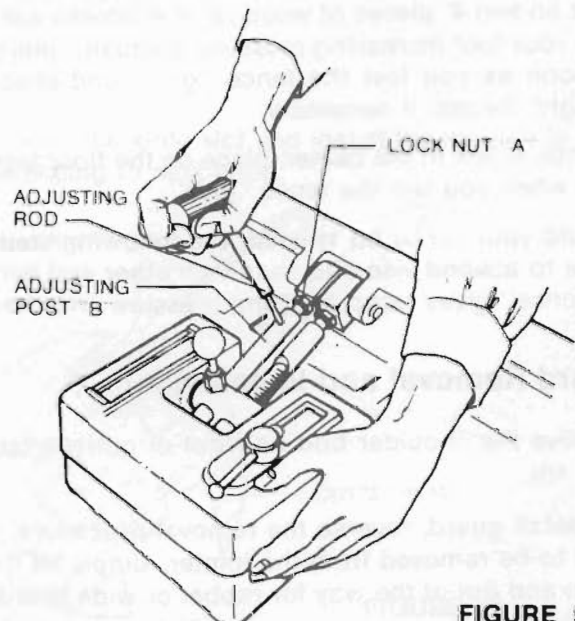


FIGURE 5



Should the fence fail to return to 90° and play is evident in the fence, remove the fence-lock plunger mechanism by loosening the jam nut and inspect plunger assembly conical retainer. If retainer shows signs of wear or scarring, grind the conical portion slightly until (Fig. 14) it will properly engage in the annular groove in the stop rod. Replace plunger assembly and tighten jam nut.

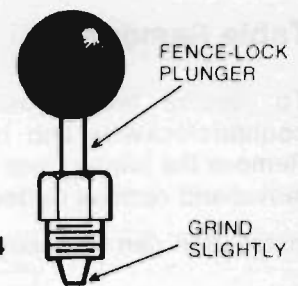


FIGURE 14

### Fence Tilt Adjustment:

The fence tilting scale is located on the fence tilt degree rod. When fence is properly aligned, it will be perpendicular to the outfeed table and the tilting scale pointer will read 0°

Fence may be tilted forward or backward by pulling up on the fence-lock plunger (Fig. 15)

The backward tilt stop adjustment is located on the fence mounting hinge and consists of a 5/16" x 1" squarehead screw with jam nut. To adjust backward tilt to 45°, raise or lower the tilt stop screw (Fig. 15) as required until the pointer reads 45° on the tilt scale. When desired degree is reached hold screw with wrench and tighten jam nut.

To tilt the fence forward pull up on the fence stop plunger and tilt fence. The nuts on the end of the scale rod are used to set the forward tilt stop at 45°. The front nut is used for adjusting and the rear nut to lock the setting. Check with a combination square and re-adjust as required.

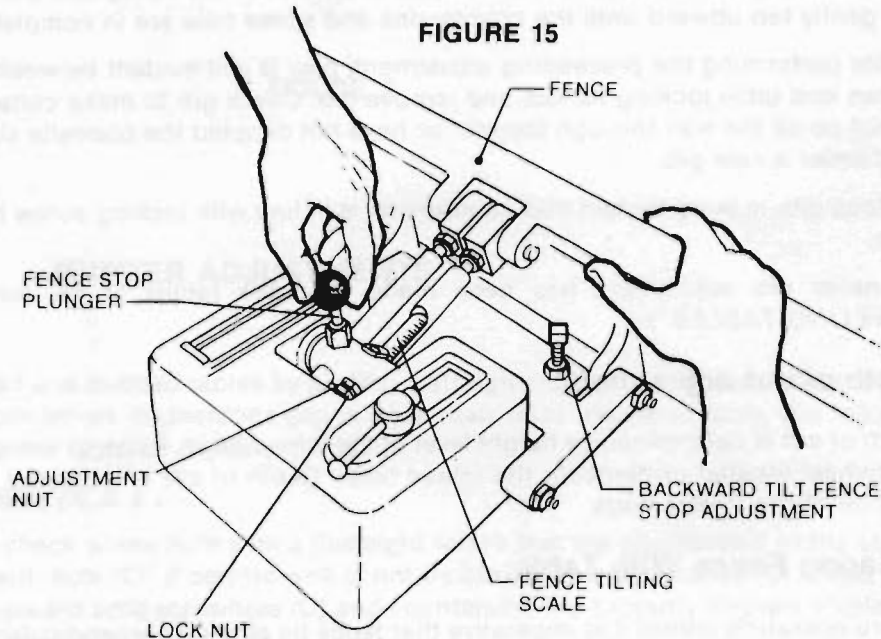


FIGURE 15

### Straightening Warped Fence:

The fence furnished with your jointer is a finished casting. Under certain conditions it is possible that the fence may become warped. If fence is high (bowed) in the center, remove fence and place face up on the floor on two 4" pieces of wood (2" x 4" blocks will suffice). Gently apply pressure to the center of the fence with your foot increasing pressure gradually until you feel the fence "give" slightly. Stop applying pressure as soon as you feel the fence "give" and check with a straight edge. The fence should be perfectly straight. Repeat if necessary.

If fence is low in the center, place on the floor face down and repeat the above procedure — REMEMBER, stop when you feel the fence "give"

Should your fence be twisted, the following steps will return it to its original shape. Clamp one end of fence to a wood vise and sandwich other end between two 2" boards and gently "twist" the fence. When the fence "gives" stop applying pressure and check fence with a straight edge.

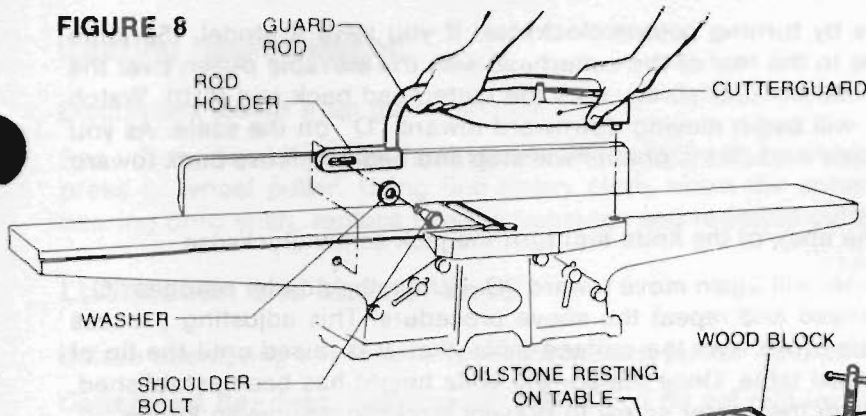
### Guard Removal and Installation:

Remove the shoulder bolt on front of outfeed table and remove guard, guard rod holder and guard rod (Fig. 16).

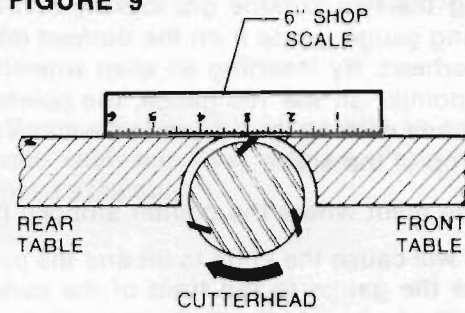
To install guard, reverse the removal procedure. Under normal operating conditions the guard does not have to be removed from the jointer, simply lift it up and out of the hole in the rabbet ledge and swing it down and out of the way for rabbet or wide board operations.



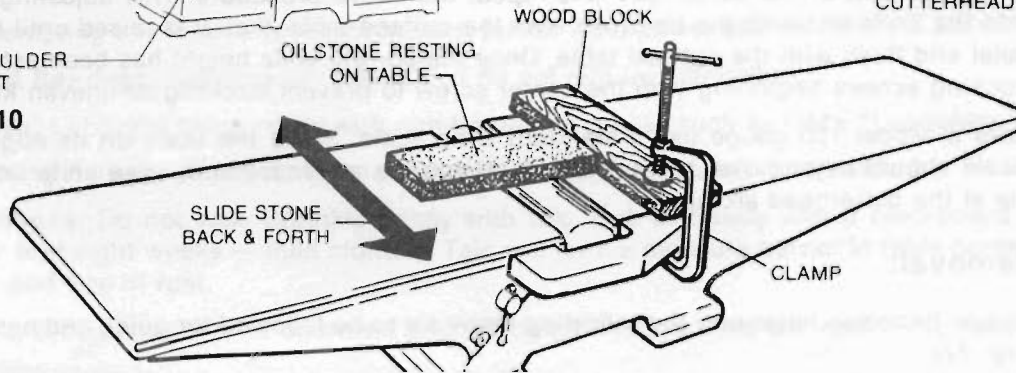
**FIGURE 8**



**FIGURE 9**



**FIGURE 10**



**Sharpening Knives:**

After extended use you will find it necessary to sharpen the knives on the cutterhead assembly. Before starting sharpening procedures you should first disconnect the machine from its power source and remove the cutter guard (See "GUARD REMOVAL").

Place a 6" shop scale across the infed and outfeed tables. Set tables to the exact height of the knife at the apex of the knife arc (Fig. 9).

Clamp a block of wood across the infed table so that the end of a sharpening stone may be placed against the wood block during jointing operation, to prevent kickback of the stone.

Lower outfeed table .003.. Turn machine on. **Caution:** Keep hands clear of turning cutterhead.

Place a hard 10" Arkansas oilstone over cutterhead with ends resting on infed and outfeed tables. Slide the oilstone back and forth across the tables until knives are jointed lightly.

Turn the machine off and visually inspect each knife.

Continue the sharpening process until every knife has been touched by the stone (Fig. 10)

After sharpening knives, place shop scale on the outfeed table. Raise the outfeed table to the original setting parallel with the knife at the apex of the arc.

Weekly sharpening will keep knives in the proper cutting condition.

If knives are excessively worn or nicked they must be reground to a new bevel. If this is the case, follow the procedure indicated in the section "INSTALLING NEW KNIVES."

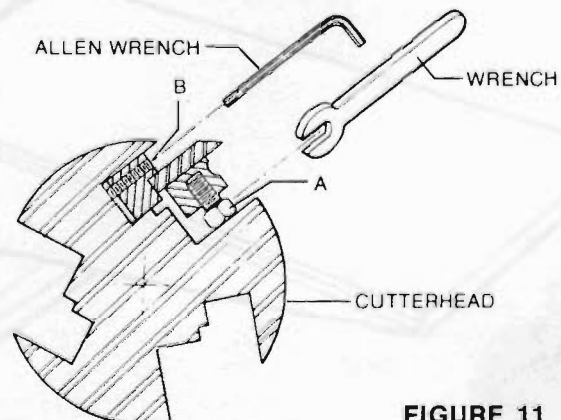
**Installing New Knives:**

Disconnect jointer from power source.

When installing new knives remove only one knife at a time, clean the knife slot and install the new knife. Adjust and lock new knife in cutterhead assembly before proceeding to next knife.

To remove the old knives, turn gib locking bolts (A) clockwise and remove gib, knife and jack screws (Fig. 11). Using an allen wrench, turn jack screws (B) counterclockwise one (1) turn. Clean the jack screws, gib, knife slot and knife thoroughly and replace jack screws. Sandwich knife and gib and drop into knife slot. Be certain that the back of the knife is resting on the seat milled in jack screw plug.

At this point, to position the knife for rabbeting cuts a 1/32" shop scale should be placed flat on the end of the cutterhead. Slide knife out until it is flush with the end of the shop scale. Set the knife locking gib 1/32" from the end of the knife.



**FIGURE 11**

Snug the two outside gib locking screws by turning counterclockwise. If you have a Model 150 knife setting gauge, place it on the outfeed table to the rear of the cutterhead with the movable platen over the cutterhead. By inserting an allen wrench into the jack screw, rock the cutterhead back and forth. Watch the pointer on the 150 gauge, the pointer will begin moving downward toward "O" on the scale. As you continue rocking the cutterhead with an allen wrench the pointer will stop and begin to move back toward the top of the scale.

At the point where the pointer stopped (the apex of the knife arc) turn the jack screw clockwise.

This will cause the knife to lift and the pointer will again move toward "O." When the pointer reaches "O," move the gauge to the front of the cutterhead and repeat the above procedure. This adjusting process puts the knife into the knife slot with the tip lower than the outfeed table, then it is raised until the tip of the knife is parallel and flush with the outfeed table. Once the correct knife height has been established, secure the gib locking screws beginning with the center screw to prevent buckling or uneven knives.

If you do not have a Model 150 gauge use a standard shop scale. Stand the scale on its edge on the outfeed table. Scale should extend over the cutterhead. Using the above method, raise knife until it just touches the scale at the cutterhead arc apex.

### Cutterhead Removal:

If cutterhead removal becomes necessary the following steps are to be followed for quick and easy cutterhead removal (Fig. 12).

1. Disconnect jointer from power source.
2. Remove drive belt.
3. Loosen and remove the cutterhead sheave.
4. Loosen gib locking screws and production locking handle on infeed table.
5. Raise the infeed table to its highest point by turning the table elevating wheel clockwise.
6. Completely disengage the two (2) bearing cap retaining screws at each end of the cutterhead assembly (A).
7. From the driven end, lift the cutterhead assembly up and slide it towards the front of the base.

Installation can be accomplished by reversing the removal procedure.

NOTE: AFTER REASSEMBLY INFEED TABLE WILL HAVE TO BE RELEVELLED (SEE "LEVELING TABLES").

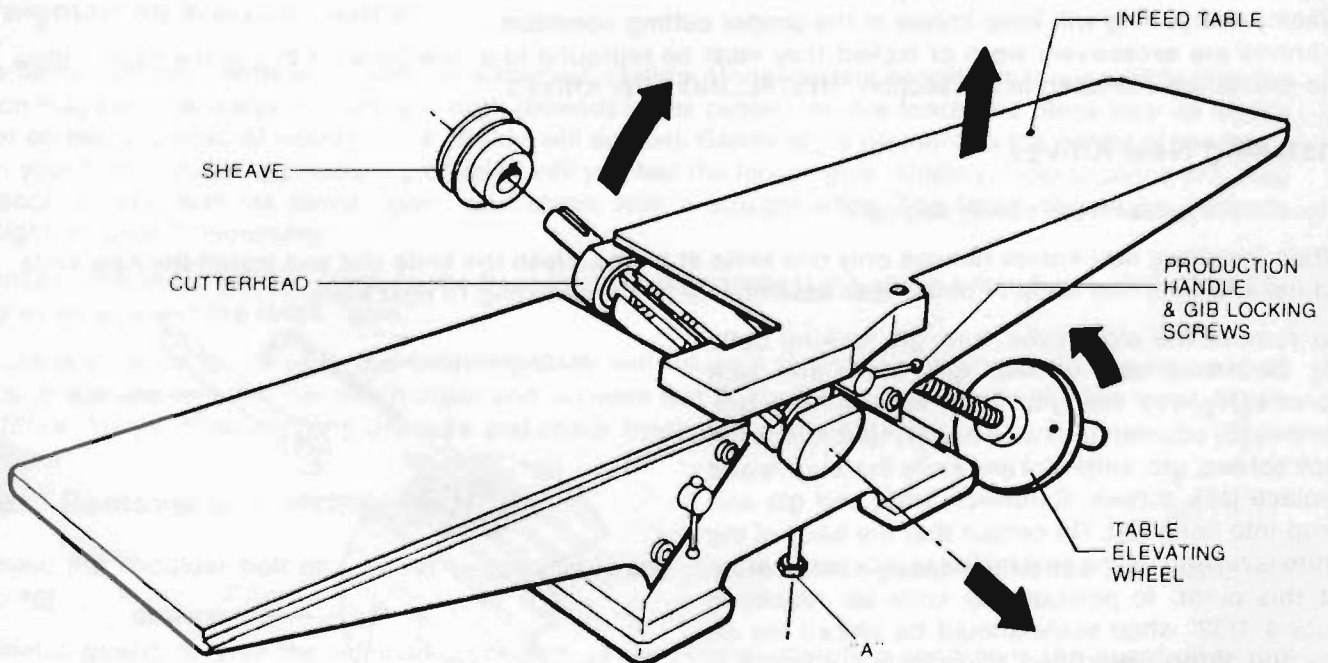


FIGURE 12

## **Bearing Replacement:**

Disconnect jointer from power source.

See "Cutterhead Removal" and remove the cutterhead assembly. Remove bearing housings with an arbor press or wheel puller. Using fine emery cloth, clean the cutterhead shaft and coat with oil. Press new bearing onto shaft, replace bearing housings and re-install cutterhead assembly.

## **Lubrication and Maintenance :**

Before attempting any maintenance disconnect jointer from power source.

**Cutterhead Bearings:** Bearings are sealed and do not require lubrication.

**Table Ways:** Lubricate twice yearly with non-hardening grease such as Fiske "Lubriplate."

**Table Raising Screws:** Lubricate twice yearly with Fiske "Lubriplate" or equivalent.

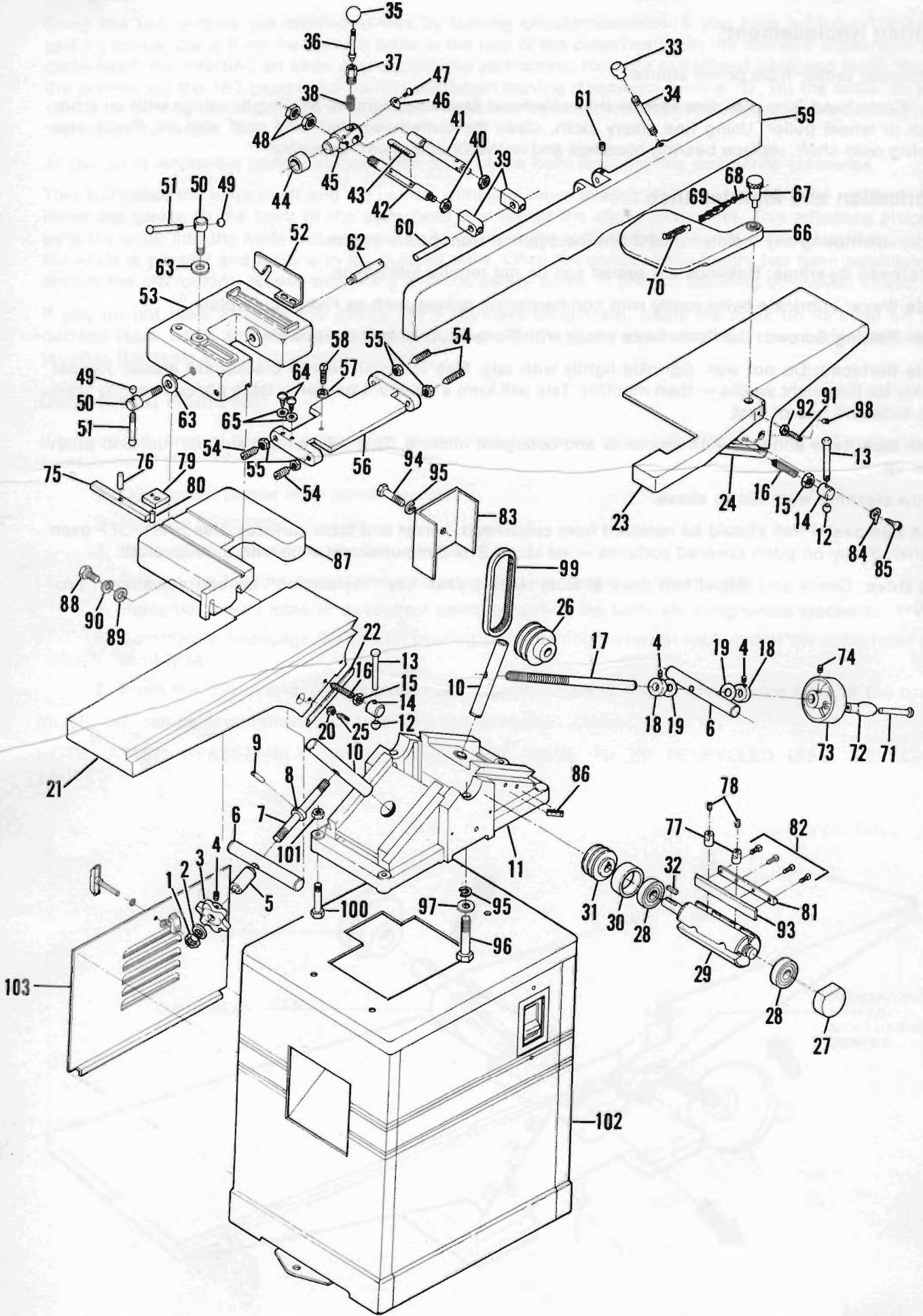
**Table Surfaces:** Do not wax. Sprinkle lightly with talc. Rub in briskly with a blackboard eraser. Repeat weekly for first eight weeks — then monthly. Talc will form a moisture barrier in table pores, keeping table tops slick and free of rust.

Clean table tops annually with ammonia and detergent mixture. This will remove surface rust and pitch build up.

Follow cleaning with talc as above.

**Pitch Removal:** Pitch should be removed from cutterhead, knives and table surfaces. Use EASY-OFF oven cleaner. Spray on pitch covered surfaces — let stand 2 or 3 minutes and wipe with a clean cloth.

**Belt Drive:** Check and adjust belt drive at least twice a year. See "Installation" for belt adjustment procedure.





6" JOINTER - BASIC UNIT			
ITEM NO.	PART NO.	DESCRIPTION	QTY.
	2042009	BASE ASSY. (INCL. ITEMS 1 THRU 25)	1
1	6518008	NUT, HEX. 1/2 - 13 JAM	1
2	6861501	WASHER FLAT 1/2" PLAIN	1
3	3271008	HANDWHEEL - 3-1/2"	1
4	6715013	SCREW SOC. HD. SET 5/16" - 18 X 3/8" LG.	3
5	3070007	BUSHING ADJ. SCREW	1
6	3044031	BAR, REAR TABLE RAISING	2
	2690009	SCREW, ASSY. TABLE RAISING (INCL. ITEMS 7 THRU 9)	1
7	3690024	SCREW, ADJ. REAR TABLE	1
8	3096219	COLLAR, REAR ADJ. SCREW	1
9	6626056	PIN, SPRING 5/32 X 3/4 SPS 21-S-156-0750	1
10	3529017	OPERATING NUT, TABLE	2
11	3042070	BASE, 6" JOINTER J-6-1	1
	2695012	SCREW-LOCK, ASSY. (INCL. ITEMS 12 THRU 16)	2
12	3406016	KNOB HANDLE, LOCKSCREW	2
13	3068002	HANDLE, LOCKSCREW	1
14	3448203	LOCK, TABLE SCREW	1
15	6515007	NUT, JAM 5/16" - 18 STEEL, PLAIN	1
16	6715147	SCREW SOC. SET 5/16" - 18 X 1-3/8" FLAT POINT	1
17	3690030	SCREW, TENSION, ADJ.	1
18	3096222	COLLAR, TABLE RAISING	2
19	6861600	WASHER, NYLATRON 9/16" I.D. X 1.0" O.D. X 1/16"	2
20	6514001	NUT, HEX., 1/4" - 20	1
21	3797054	TABLE, REAR J-6-3	1
22	3244010	GIB, TABLE REAR	1
23	3797050	TABLE, FRONT J-6-2	1
24	3244009	GIB, TABLE FRONT	1
25	6714130	SCREW, SLOTTED HD. SET 1/4" - 20 X 1" LG.	4
26	6807033	SHEAVE AK-34 5/8" BORE	4
	2109002	CUTTERHEAD ASSY. (INCL. ITEMS 27 THRU 32)	1
27	3298001	HOUSING, BEARING	1
28	6060005	BEARING BALL N.D. #Z99503	2
29	3112005	CUTTERHEAD	1
30	3298005	HOUSING, BEARING DRIVE END	1
31	6807027	SHEAVE, CUTTERHEAD AK-25 SINGLE GROOVE 5/8 BORE BROWNING TYPE 2	1
32	3388004	KEY, SQUARE 3/16" X 3/16" X 1"	1
	2195007	FENCE ASSY. (INCL. ITEMS 33 THRU 65)	1
	2268005	HANDLE ASSY., FENCE TILTING (INCL. ITEMS 33 THRU 34)	1
33	3406201	KNOB, TEARDROP	1
34	3670039	ROD, HANDLE	1
	2670009	ROD, ASSY., TILT (INCL. ITEMS 35 THRU 48)	1
	2440005	LOCK ASSY. PLUNGER (INCL. ITEMS 35 THRU 38)	1
35	3406208	KNOB, ROUND 1" DIA. NYLON 1/4 - 20	1
36	3601204	PLUNGER, FENCE STOP	1
37	3529012	OPERATING NUT, FENCE STOP PLUNGER	1
38	6813007	SPRING, COMPRESSION, JS-3-3/8" O.D. X 1-1/4"	1
39	3064038	BRACKET, TABLE STOP	2
40	6567006	NUT HEX. JAM 7/16" - 20	2
41	3670023	ROD, TILTING STOP	1
42	3670049	ROD, TILT DEGREE	1
43	3684205	SCALE, FENCE TILTING	1
44	3728003	SLEEVE, FENCE TILTING	1
45	3092010	CLAMP, FENCE TILT	1
46	3604008	POINTER	1
47	6706079	SCREW, ROUND HD. 6-32 X 1/4"	1
48	3526205	HEX. - 5/8" - 18 THIN HT.	2
	2695010	SCREW-LOCK ASSY. (INCL. ITEMS 49 THRU 51)	2
49	3406016	KNOB HANDLE	4
	3268002	HANDLE	2
	3965006	SCREW LOCK	2
	3064233	BRACKET, FENCE LOCK	1
53	3042055	BASE, FENCE SLIDE	1
54	6716117	SCREW 3/8" - 16 X 1-1/2" SLOTTED SET W/60° POINT	4
55	6516009	NUT, HEX., JAM 3/8" - 16	4

6" JOINTER - BASIC UNIT			
ITEM NO.	PART NO.	DESCRIPTION	QTY.
56	3282009	HINGE, FENCE MTG.	1
57	6515007	NUT, HEX., JAM 5/16" - 18	1
58	6715088	SCREW, SQ. HD. 5/16" - 18 X 1"	1
59	3196005	FENCE, TABLE	1
60	3584213	PIN, HINGE BLOCK MTG.	1
61	6714008	SCREW, SOC. SET 1/4 - 20 X 5/16" CUP PT.	1
62	3697002	SCREW, SHOULDER	1
63	6861501	WASHER, FLAT 1/2"	3
64	6714114	SCREW 1/4" - 20 RD. HD. X 3/8" LG.	2
65	6861101	WASHER 1/4" PLAIN FLAT	2
	2250011	GUARD ASSY. CUTTERHEAD (INCL. ITEMS 66 THRU 70)	1
66	3250013	GUARD CUTTERHEAD	1
67	3583020	PIN, CUTTERHEAD GUARD	1
68	6622005	PIN, CUTTER	1
69	3083018	CHAIN, SASH #8 X 2-3/8" LG.	1
70	6813022	SPRING, EXTENSION #5000-389 D + B 3/8" O.D. X 2-3/4" LG.	1
	2271013	HANDWHEEL ASSY. (INCL. ITEMS 71 THRU 74)	1
71	6624006	PIN, GROOVE, STEEL PLAIN 1/4 X 3 GROOVE PIN	1
72	3268201	HANDLE, NYLON MACHINE	1
73	3271048	HANDWHEEL, 4" DIA.	1
74	6715013	SCREW, SOC. SET 5/16" - 18 X 3/8" LG. CUP PT.	1
	2386002	KEY ASSY., FENCE SLIDING (INCL. ITEMS 75 THRU 76)	1
75	3388030	KEY 3/8" X 3/8" X 8-9/16"	1
76	6626059	SPRING, SPS 21-S-156-0875, 5/32" X 7/8"	1
	2438001	LIFTER ASSY., CUTTERHEAD KNIFE (INCL. ITEMS 77 THRU 78)	6
77	3438201	LIFTER, KNIFE CUTTERHEAD	1
78	6714129	SCREW, SOC. SET 1/4" - 20 X 3/4" LG. NYLOC	1
	2526001	NUT ASSY., FENCE SLIDING (INCL. ITEMS 79 THRU 80)	1
79	3528004	LOCK-NUT, FENCE SLIDE	1
80	6626038	PIN, SPRING 1/4" X 1" LG.	1
	2724001	SHIM, ASSY. CUTTERHEAD (INCL. ITEMS 81 THRU 82)	1
81	3244011	GIB, CUTTERHEAD KNIFE	1
82	3690065	SCREW, ADJ. SHIM	4
83	3250006	GUARD, BELT	1
84	3604004	POINTER, TABLE DEPTH SCALE	1
85	6706035	SCREW, ROUND HD. MACH. #6 - 32 X 1/4" LG. ZINC PLATE	1
86	3684220	SCALE, TABLE HEIGHT ADJ.	1
87	3776021	SUPPORT, FENCE	1
88	6716035	SCREW HEX. HD. CAP 3/8 - 16 X 1-3/4	2
89	6861301	WASHER, FLAT 3/8"	2
90	6861300	WASHER, HELICAL LOCK SPRING 3/8" STEEL PLAIN	2
91	6715017	SCREW, SOC. SET 5/16" - 18 X 1"	1
92	6515007	NUT, HEX. JAM 5/16" - 18 STEEL PLAIN	1
93	6427001	KNIFE, CUTTERHEAD (SET OF 3)	1
94	6715045	SCREW, HEX. HD. CAP 5/16" - 18 X 2-1/2"	1
95	6861200	WASHER HELICAL LOCKSPRING 5/16"	3
96	6715046	SCREW HEX. HD. CAP 5/16" - 18 X 4"	2
97	6861201	WASHER FLAT 5/16" STEEL PLAIN	2
98	6714004	SCREW SOC. SET 1/4 - 20 X 1/4	1
99	6077027	BELT 4L-550	1
100	6716035	SCREW HEX. HD. 3/8 - 16 X 1-3/4	3
101	6516009	NUT HEX. JAM 3/8 - 16	3
102	2759029	ASSEMBLY, JOINTER STAND	1
103	2136012	ASSEMBLY, DOOR	1

# SCHEMATIC, COMPOSITE ELECTRICAL for MODEL 50-6" JOINTER

## MANUAL

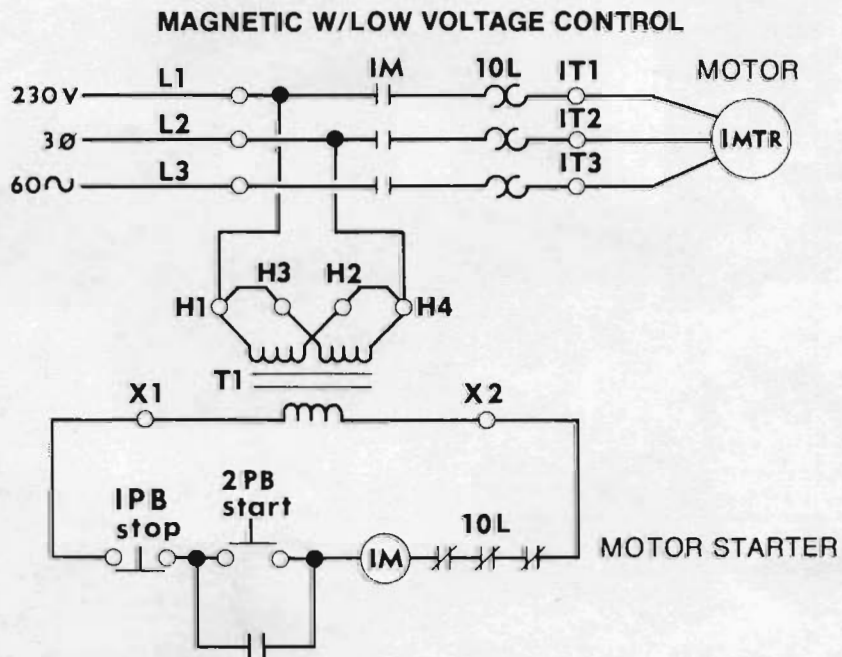
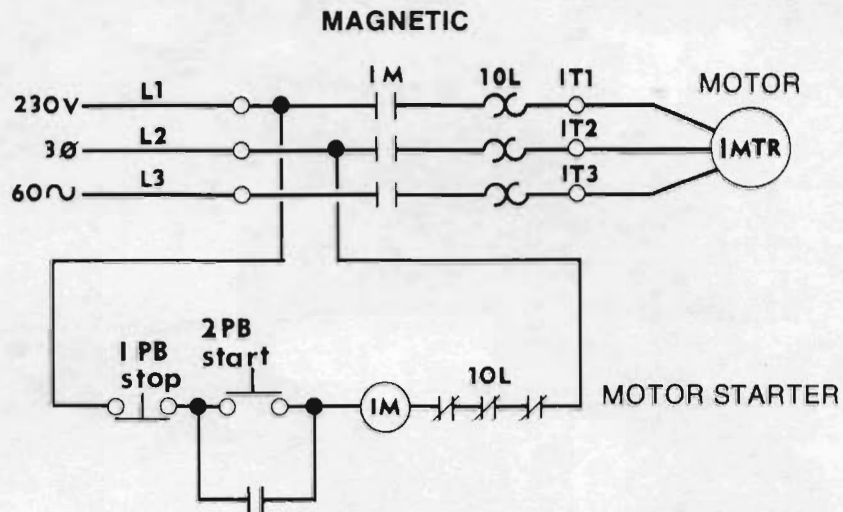
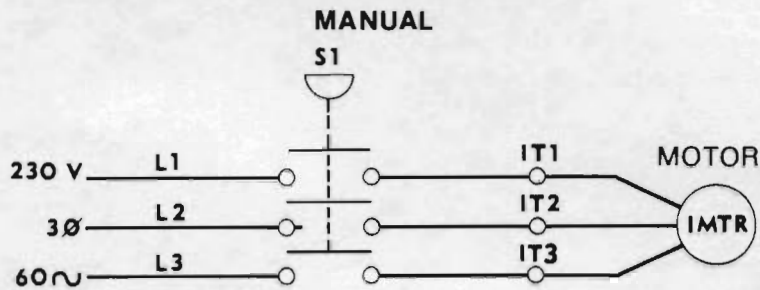
REF.	QTY.	POWERMATIC NO.	MFG. DESCRIPTION
S1	1	(30) 6821135 (10) 6821134	SWITCH, FURNAS 12BA34P SWITCH, FURNAS 12BA24P

## MAGNETIC

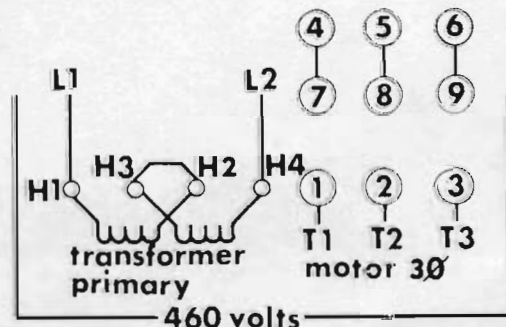
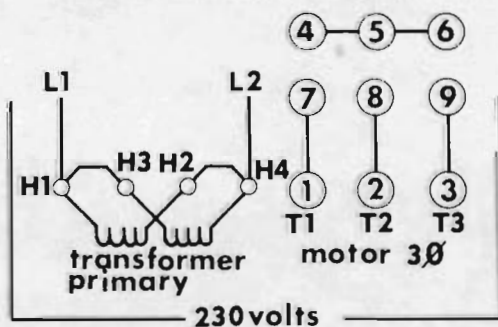
REF.	QTY.	POWERMATIC NO.	MFG. DESCRIPTION
M1	1	(30) 6816111 (10) 6816105	STARTER, MAGNETIC, FURNAS, 14BF32BC71 STARTER, MAGNETIC, FURNAS, 14CF12BA7
(PB 1) (PB 2)		6821014	SWITCH, FURNAS, MOMENTARY PB, B2873IB

## MAGNETIC WITH LOW VOLTAGE CONTROL

REF.	QTY.	POWERMATIC NO.	MFG. DESCRIPTION
(PB 1) (PB 2)	1	6821014	SWITCH, FURNAS, MOMENTARY PB, B2873IB
T1	1	6831068	TRANSFORMER 115/230-24V, 50 VA
		6831069	TRANSFORMER 230-460-24V, 75 VA
		6831070	TRANSFORMER 230/460-115V, 50VA
1M (WITH XMF)	1	6816119	STARTER, MAG. W/XMR. 10, 24V, FURNAS 14CF107013
		6816138	STARTER, MAG. W/XMR. 10, 115V, FURNAS 14CF107017
		6816122	STARTER, MAG. W/XMR. 30, 24V, FURNAS 14BF32BJ71BD
		6816126	STARTER, MAG. W/XMR. 30, 115V, FURNAS 14BF32BA71BA
MTR.	1	6470801	MOTOR, ELECT. 3/4 HP, 10 3600 RPM, 115/230V, 56 FR
		6470809	MOTOR, ELECT. 3/4 HP, 30, 3600 RPM, 200V, 56 FR
		6470810	MOTOR, ELECT. 3/4 HP, 30, 3600 RPM, 230/460V, 56 FR



NOTE: FOR SINGLE PHASE UNITS, OMIT LINE L3



# SCHEMATIC COMPOSITE ELECTRICAL

## MODEL 50-8 JOINTER



REF	SYMBOL	DESCRIPTION	MANUFACTURER
1	[Symbol]	AC 110V	GENERAL ELECTRIC
2	[Symbol]	STOP	GENERAL ELECTRIC
3	[Symbol]	START	GENERAL ELECTRIC
4	[Symbol]	RELAY	GENERAL ELECTRIC
5	[Symbol]	MOTOR	GENERAL ELECTRIC

### MAGNETIC WITH LOW VOLTAGE CONTROL

REF	SYMBOL	DESCRIPTION	MANUFACTURER
1	[Symbol]	AC 110V	GENERAL ELECTRIC
2	[Symbol]	STOP	GENERAL ELECTRIC
3	[Symbol]	START	GENERAL ELECTRIC
4	[Symbol]	RELAY	GENERAL ELECTRIC
5	[Symbol]	MOTOR	GENERAL ELECTRIC



**POWERMATIC HOUDAILLE, INC.**  
McMinnville, Tennessee 37110