



CT088
8" PROFESSIONAL JOINTER
with CABINET STAND
User Manual



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SAFETY RULES

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it. Figure out an alternative procedure that feels safer. **REMEMBER:** Your personal safety is your responsibility.

This machine was designed for certain applications only. Craftex strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, **DO NOT** use the machine until you have first contacted us to determine if it can or should be performed on the product.

WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
2. **KEEP GUARDS IN PLACE and in working order.**
3. **ALWAYS WEAR EYE PROTECTION.**
4. **GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
5. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on".
6. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
7. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lit.
8. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
9. **MAKE WORKSHOP CHILDPROOF** – with padlocks, master switches, or by removing starter keys.
10. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
11. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
12. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
13. **ALWAYS USE SAFETY GLASSES.** Wear safety glasses. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.
14. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
15. **DON'T OVERREACH.** Keep proper footing and balance at all times.
16. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
17. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
18. **USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by us may cause hazards or risk of injury to persons.
19. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord.
20. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
21. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
22. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
23. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
24. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol or any medication.
25. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
26. **WARNING:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR JOINTERS

1. **WARNING:** Do not operate the jointer until it is completely assembled and installed according to the instructions.
2. **IF YOU ARE NOT** thoroughly familiar with the operation of jointers, obtain advice from your supervisor, instructor or other qualified person.
3. **KEEP** cutterhead sharp and free of all rust and pitch.
4. **BEFORE** starting machine, check cutterhead guard to make sure it is not damaged and operates freely.
5. **ALWAYS** make sure exposed cutterhead behind the fence is guarded, especially when jointing near the edge.
6. **NEVER** perform jointing or planing operations with the cutterhead guard removed.
7. **MAKE CERTAIN** the infeed and outfeed tables are tightened before starting the machine.
8. **NEVER** start the jointer with the workpiece contacting the cutterhead.
9. **ALWAYS** hold the workpiece firmly against the tables and fence.
10. **NEVER** perform any operation "free – hand" which means using your hands to support or guide the workpiece. **ALWAYS** use the fence to position and guide the work.
11. **AVOID** awkward operations and hand positions where a sudden slip could cause your hand to move into the cutterhead.
12. **ALWAYS** use hold – down/ push blocks for jointing material less than 3 inches in height or planing material thinner than 3 inches.
13. **DO NOT** perform jointing operations on material shorter than 10 inches, narrower than 3/4 inch or less than 1/2 inch thick.
14. **DO NOT** perform planing operations on material shorter than 10 inches, narrower than 3/4 inch, wider than 6 inches or less than 1/2 inch thick.
15. **NEVER** make jointing or planing cuts deeper than 1/8 inch. On cuts more than 1/8 – 1/2 inches wide, adjust depth of cut to 1/16 inch or less to avoid overloading machine and to minimize chance of kick – back (work thrown back toward you).
16. **MAINTAIN** the proper relationship of infeed and outfeed table surfaces and cutterhead knife path.
17. **SUPPORT** the workpiece adequately at all times during operation; maintain control of the work at all times.
18. **DO NOT** back the workpiece toward the infeed table.
19. **DO NOT** attempt to perform an abnormal or little-used operation without study and the use of adequate hold – down/push blocks, jigs, fixtures, stops, push blocks, etc.
20. **SHUT OFF** power before servicing or adjusting jointer.
21. **DISCONNECT** jointer from power source and clean the machine before leaving the machine.
22. **MAKE SURE** the work area is clean before leaving the machine.
23. **SHOULD** any part of your jointer be missing, damaged, or fail in any way, or any electrical component fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged or failed parts before resuming operation.
24. **THE USE** of attachments and accessories not recommended by us may result in the risk of injuries.
25. **SAVE THESE INSTRUCTIONS.** Refer to them often and use them to instruct others.

UNPACKING AND CLEANING

Your new jointer and stand are shipped in two containers. Carefully unpack the jointer, stand and all loose items in each container. Fig.2 illustrates all items shipped in the jointer container, and Fig.3 illustrates all items shipped in the stand container. **CAUTION: The jointer is extremely heavy. We strongly suggest that two or more people lift the jointer, or lift the jointer mechanically.** Remove the protective coating from the table surface and all unpainted parts. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the table surface with a good quality paste wax. Buff out the wax thoroughly to prevent it from rubbing onto the workpieces.

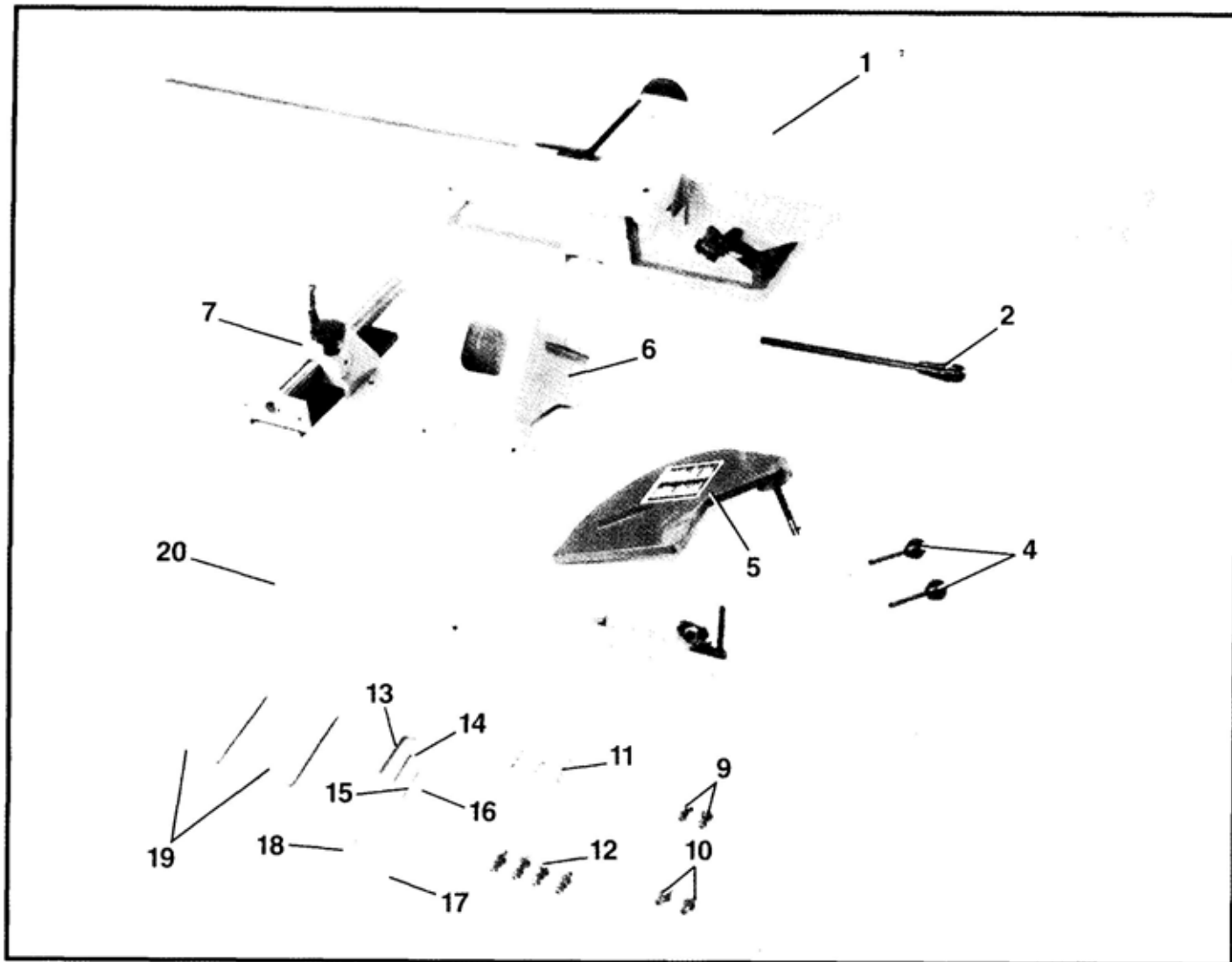


Fig. 2

- | | |
|---|---|
| 1. Jointer | 12. Mounting hardware for Cutterhead Pulley Guard/Carriage Mounting Bracket |
| 2. Table Raising Handle | 13. 6mm Allen Wrench |
| 4. Fence Tilting Handles | 14. 4mm Allen Wrench |
| 5. Cutterhead Guard | 15. 3mm Allen Wrench |
| 6. Cutterhead Pulley Guard/Carriage Mounting Bracket | 16. 2.5mm Allen Wrench |
| 7. Fence Carriage Assembly | 17. 8 - 10mm Open End Wrench |
| 9. Mounting hardware for fence carriage assembly to carriage mounting bracket | 18. 12 - 14mm Open End Wrench |
| 10. Mounting hardware for fence to fence carriage assembly | 19. Push Blocks (2) |
| 11. Mounting hardware for jointer to stand | 20. Fence |

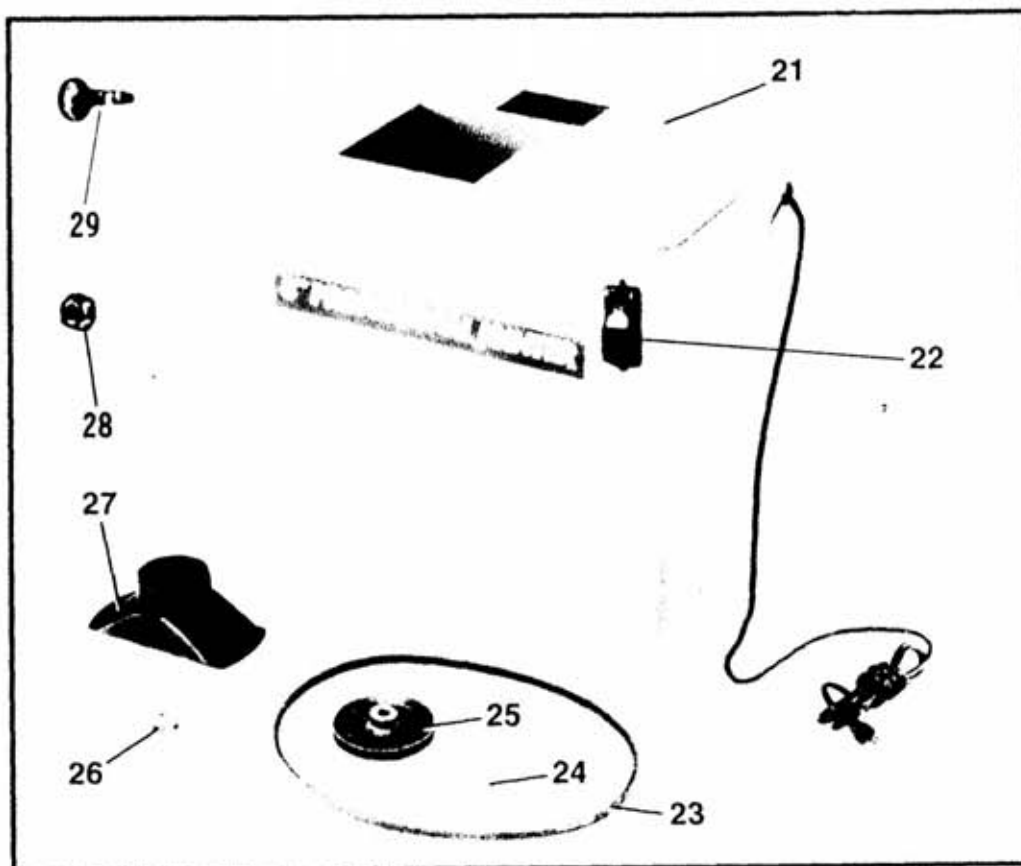


Fig. 3

- | | |
|-----------------------------------|------------------------------|
| 21. Stand with Pre - Wired Switch | 26. M5 x 10 BOTTOV HD SCR(4) |
| 22. Hardware for Mounting Switch | 27. Dust Chute |
| 23. V - Belt | 28. HEX NUT |
| 24. Key | 29. PIASTIC COVERED PAD |
| 25. Pulley | |

ASSEMBLY INSTRUCTIONS

WARNING: FOR YOUR OWN SAFETY, DO NOT CONNECT THE JOINTER TO A POWER SOURCE UNTIL THE JOINTER IS COMPLETELY ASSEMBLED AND YOU HAVE READ AND UNDERSTOOD THE ENTIRE OWNERS MANUAL.

STAND AND ELECTRICALS

Your jointer stand (A) Fig. 4, is shipped with the motor and switch completely wired, and the motor has been factory mounted.

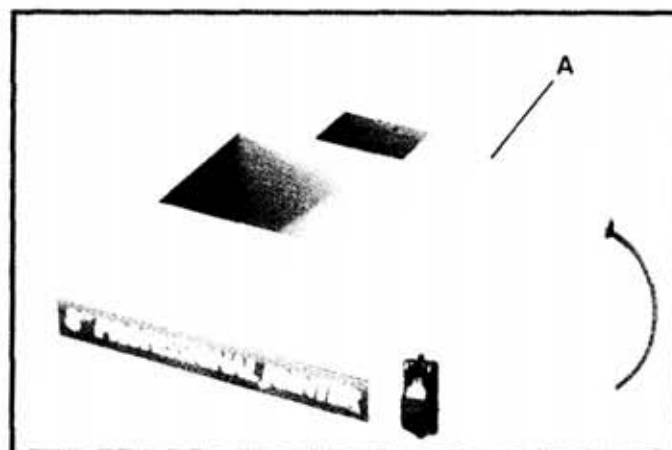


Fig. 4

ASSEMBLING JOINTER TO STAND

1. The outfeed end of the jointer will be located at the side of the stand with the dust chute (B) Fig. 5.
2. Remove three screws (C) Fig. 5, and loosen three screws (D). Remove back panel (E) from stand by lifting panel upward.
3. Line up three holes (F) and (L) Fig. 6, on top of stand with three holes located at the bottom of the jointer base and fasten the jointer to the base with three $3/8 - 16 \times 2"$ long hex head screws (G) Fig. 7, six flat washers (H), three lockwashers (J), and three hex nuts (K). **CAUTION: THE JOINTER IS EXTERMEY HEAVY. WE STRONGLY SUGGEST THAT TWO OR MORE PEOPLE LIFT THE MACHINE ONTO THE STAND OR LIFT THE JOINTER MECHANICALLY. IMPORTANT:** Mounting screws for fastening the jointer to the stand through holes (F) should be started downward from the jointer base. Screw for mounting the jointer to the stand through hole (L) should be started downward from the jointer base. Screw for mounting the jointer to the stand through hole (L) should be started upward from the inside of the stand.

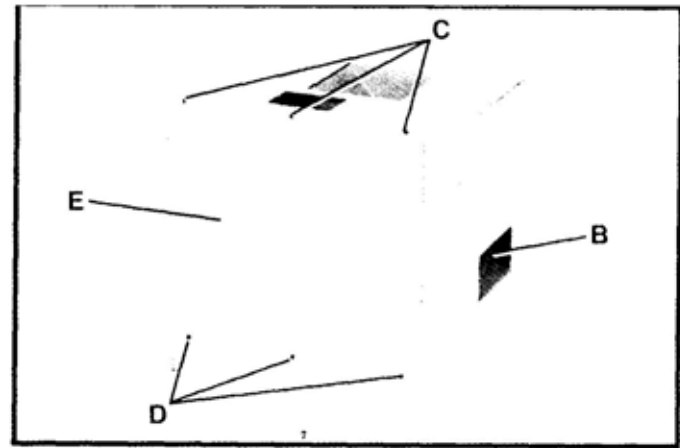


Fig. 5

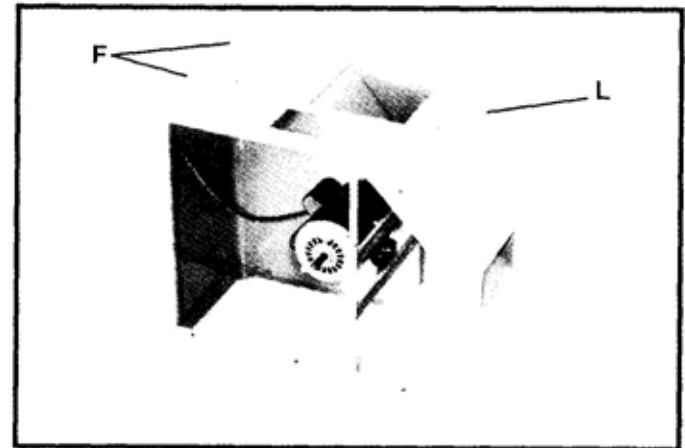


Fig. 6

ASSEMBLING INFEED TABLE ADJUSTMENT HANDLE

1. Thread locknut (A) Fig. 8, clockwise onto the end of adjustment handle (B) as far as it will go.
2. Thread handle (B) Fig. 8, into block (C) which is located under infeed table (D). Tighten locknut (A) Fig. 9, against block (C) as shown.



Fig. 7

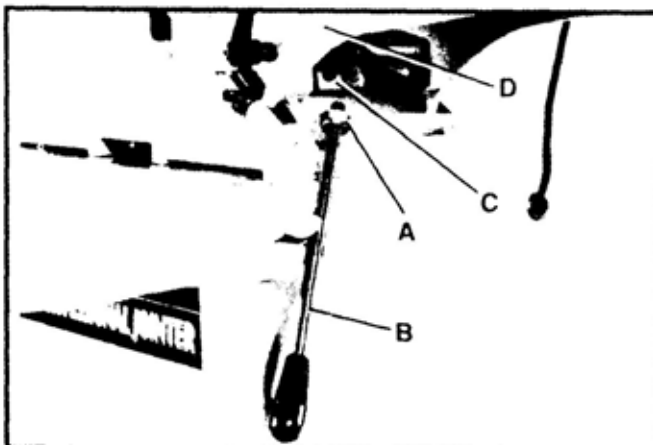


Fig. 8

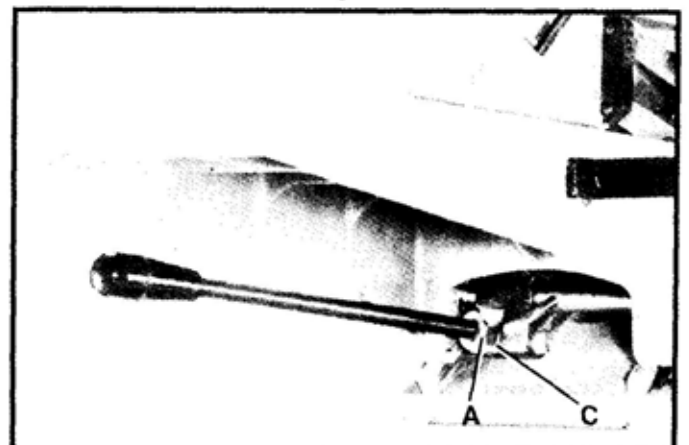


Fig. 9

ASSEMBLING MOTOR PULLEY

Assemble motor pulley (A) Fig. 10, on the motor shaft (B) with the hub of the pulley in the outer position as shown. Make certain key (C) is inserted in the keyway of the pulley and motor shaft. Tighten set screw (which is located on the pulley hub) against the motor shaft (B)

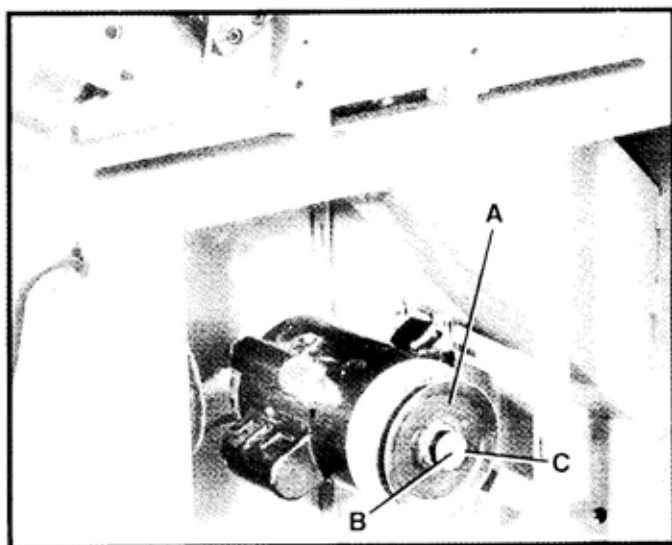


Fig. 10

ASSEMBLING BELT AND ALIGNING PULLEYS

1. Place belt (A) Fig. 11, inside the grooves of cutter – head pulley (B) and motor pulley (C).

2. Make certain the motor pulley (C) Fig. 12, is aligned with cutterhead pulley (B) by placing a straight edge (D) onto the face of each pulley as shown.

3. If an adjustment is necessary, the motor pulley (C) Fig. 12, can be moved in or out on the motor shaft, or the motor can be moved by loosening four mounting screws, two of which are shown at (E) Fig. 12. After adjustment is made, tighten the four motor mounting screws or the set screw on the hub of the motor pulley, depending on which adjustment you made.

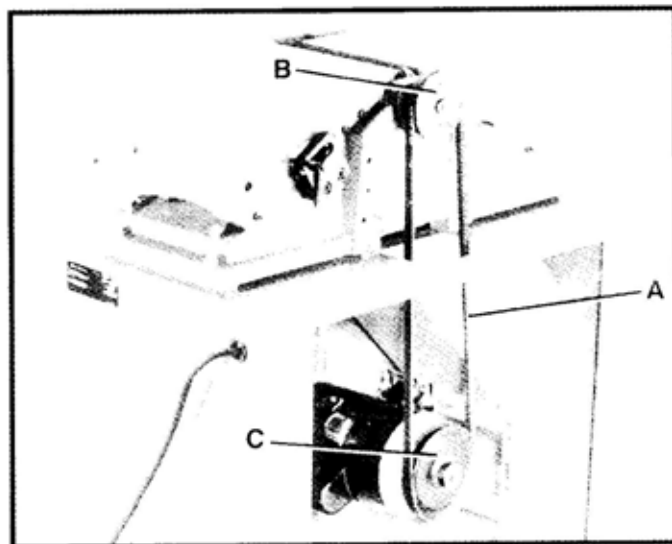


Fig. 11

ADJUSTING BELT TENSION

Proper belt tension is obtained when there is approximately 1" deflection at the center span of the belt, using light finger pressure. If an adjustment is necessary, the motor can be raised or lowered by loosening four mounting screws, two of which are shown at (E) Fig. 12.

Tighten motor mounting hardware after proper tension is applied. **NOTE:** Make certain the motor pulley is aligned with the cutterhead pulley. Reassemble the rear panel to the stand which was removed in **STEP 2** of "ASSEMBLING JOINTER TO STAND".

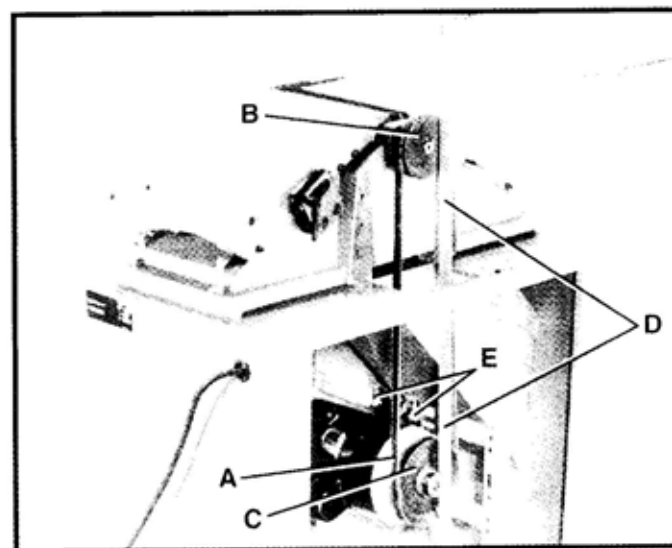


Fig. 12

ASSEMBLING CUTTERHEAD PULLEY GUARD/ CARRIAGE MOUNTING BRACKET

1. Align two pins (A) Fig. 13, in mounting bracket (C) with two holes (B) at the rear of jointer (D).

2. Using the supplied wrench (E), fasten mounting bracket (C) Fig. 14, to the jointer with four M8 × 55mm long hex socket head screws, lockwashers, and flat washers (F), three of which are shown.

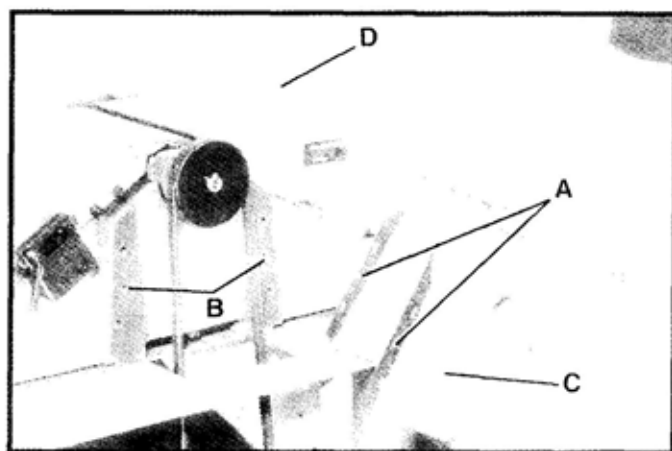


Fig. 13

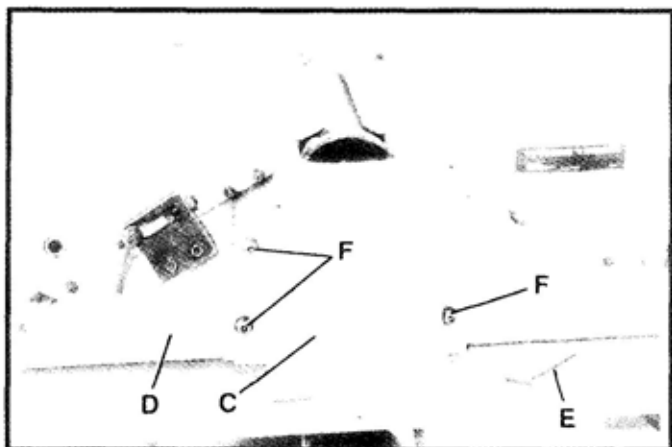


Fig. 14

ASSEMBLING FENCE CARRIAGE ASSEMBLY

1. Fasten fence carriage assembly (A) Fig. 15, to cutter-head pulley guard/carriage mounting bracket (B) using two M8 × 20mm long hex socket head screws, lockwashers, and flat washers (C) through holes in fence carriage assembly, one of which is shown at (D).

2. Fig. 16, illustrates the fence carriage assembly (A) properly mounted to the jointer.

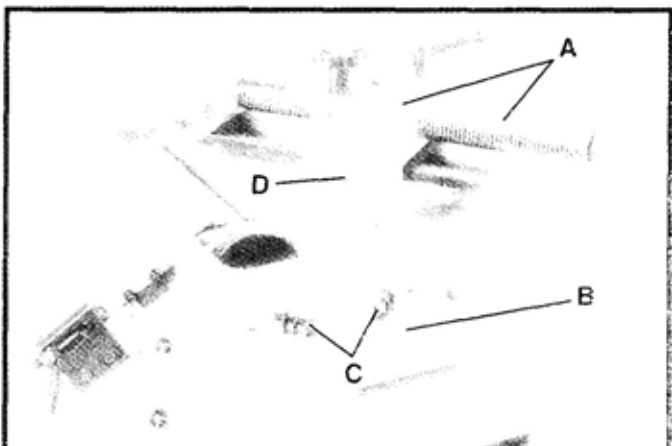


Fig. 15

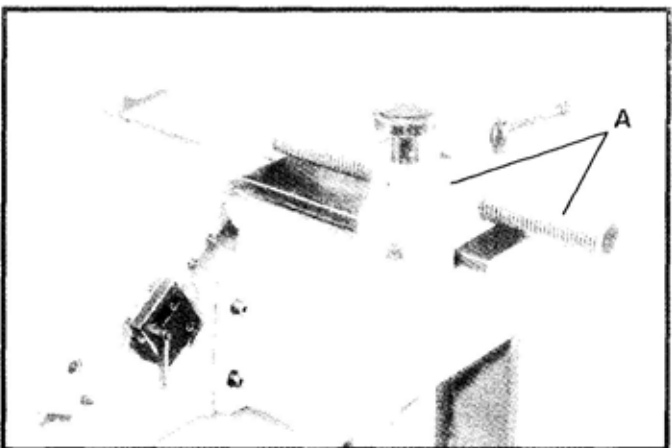


Fig. 16

ASSEMBLING FENCE

1. Align two threaded holes (G) Fig. 17, in fence (A) with two holes (C) in fence carriage (B) and fasten fence to carriage assembly with two M8 × 25mm hex socket head screws, lockwashers, and flat washers (D).

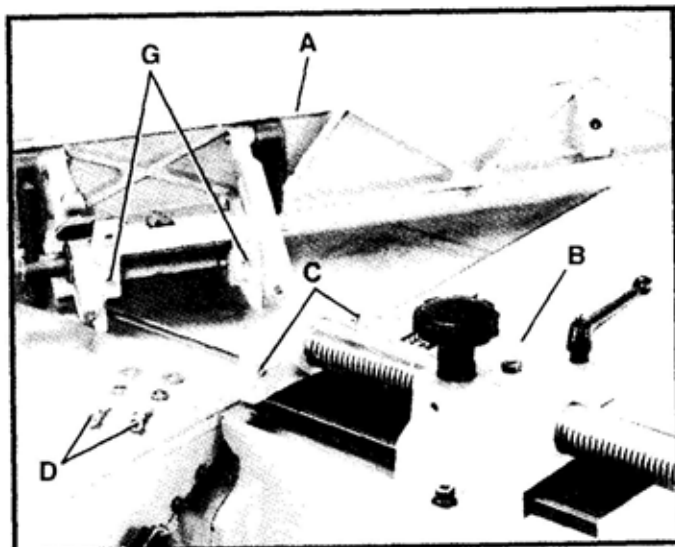


Fig. 17

2. Fig. 18, illustrates the fence (A) properly mounted to carriage assembly (B).

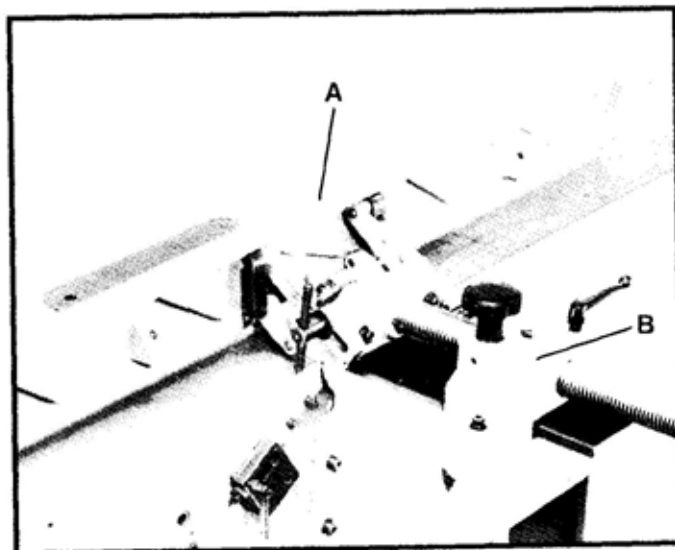


Fig. 18

3. Thread two fence adjustment handles (E) Fig. 19, into the rear of fence (A) as shown.

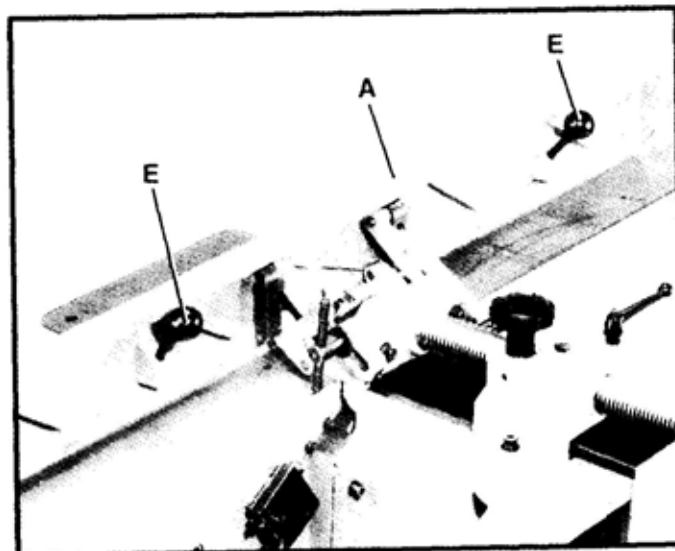


Fig. 19

ASSEMBLING CUTTERHEAD GUARD

1. Remove set screw (not shown) from post (A) Fig. 20, of cutterhead guard (B).

2. Insert post (A) Fig. 20, through hole (C) in the infeed table. **NOTE:** A spring is supplied in knob assembly (D) Fig. 20, that returns the guard (B) over the cutterhead after a cut has been made. Turn knob (D) to provide tension on the spring inside knob assembly (D) Fig. 20, engages inside the slot of the post. If spring tension is too much, or too little that it does not allow the cutterhead guard to spring back over the cutterhead, adjust the spring tension as necessary by rotating the guard and rotating knob (D).

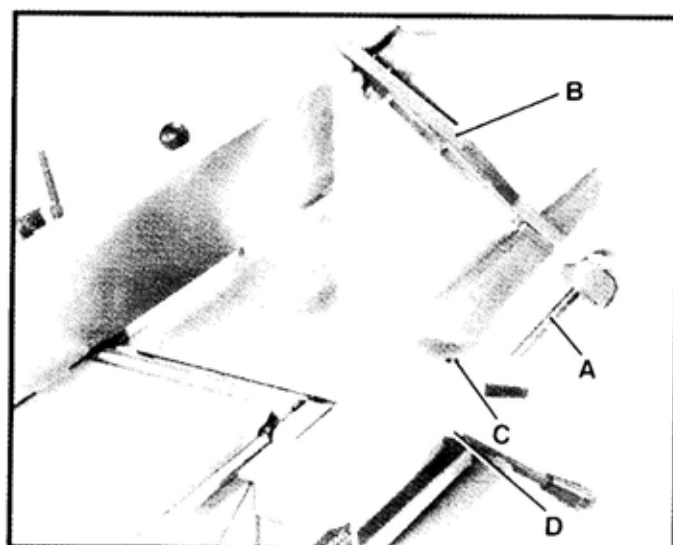


Fig. 20

3. Thread set screw (E) Fig. 21, which was removed in STEP 1, into post (A) to keep cutterhead guard (B) in position in open position.

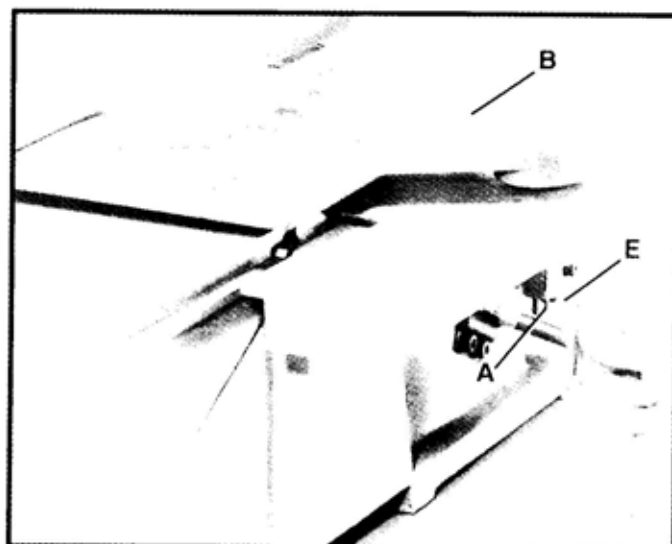


Fig. 21

4. Fig. 22, shows the cutterhead guard (B) assembled to the joint.

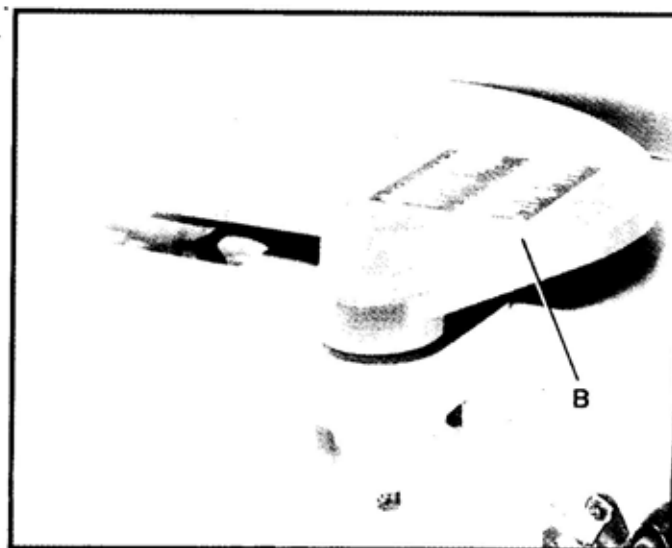


Fig. 22

ASSEMBLING DUST CHUTE

The jointer has a built-in dust chute (A) Fig. 26, to expel sawdust efficiently during cuts. If you will be connecting a dust collection system to the jointer, a dust collector connector (B) Fig. 27, is supplied and can be fastened to the jointer stand (C) with four screws (D) as shown.

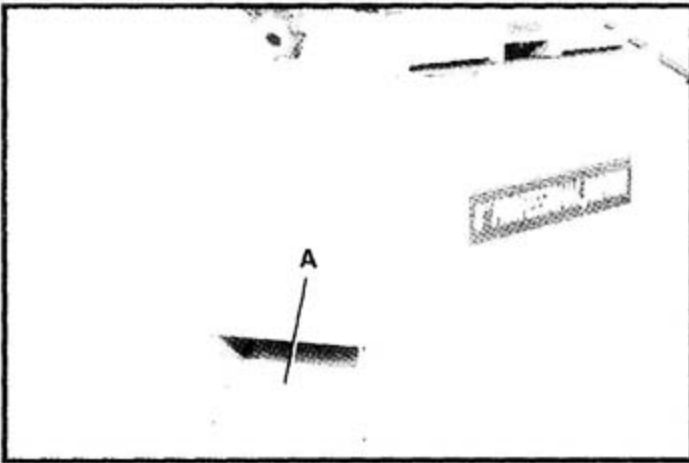


Fig. 26

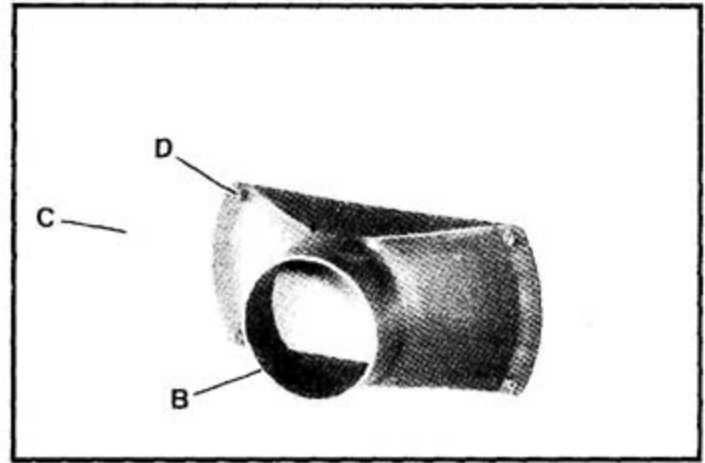


Fig. 27

CONNECTING JOINTER TO POWER SOURCE

POWER CONNECTIONS

A separate electrical circuit be used for your tools. This circuit should not be less than # 12 wire and should be protected with 20 Amp fuse. Have a certified electrician replace or repair a worn cord immediately. Before connecting the motor to a power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as stamped on the motor nameplate. Running on low voltage will damage the motor.

WARNING: DO NOT EXPOSE THE TOOL TO RAIN OR OPERATE THE TOOL IN DAMP LOCATIONS.

GROUNDING INSTRUCTIONS

CAUTION: THIS TOOL MUST BE GROUDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment - grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes in the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the tool's plug,

as shown in Fig. 28.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a normal 220-volt circuit and has a grounded plug that looks like the plug illustrated in Fig. 28.

If a properly grounded outlet is not available, a temporary adapter, shown in Fig. 29, may be used for connecting the 3-prong grounding type plug to a 2-prong receptacle. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear, lug, or the like extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box cover. Whenever the adapter is used, it must be held in place with a metal screw.

NOTE: In Canada, the use of a temporary adapter is not permitted by the Canadian Electric Code.

CAUTION: In All Cases, Make certain the receptacle in question is properly grounded. If you are not sure have a certified electrician check the receptacle.

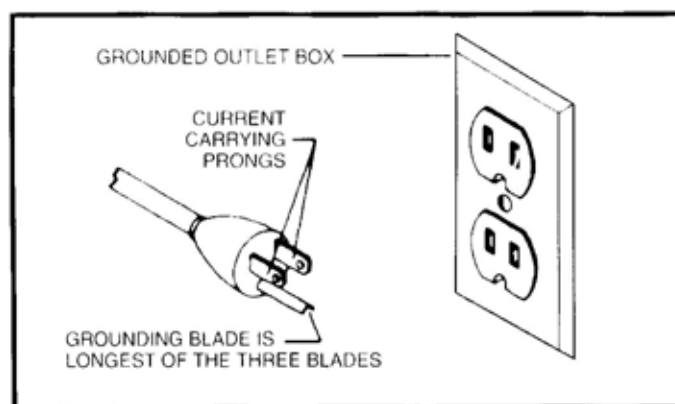


Fig. 28

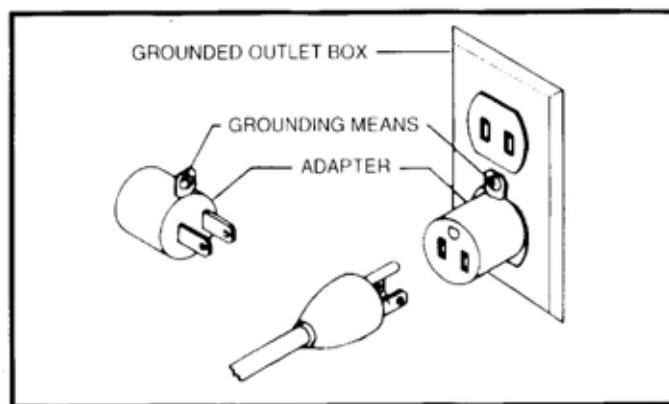


Fig. 29

CHANGING VOLTAGE

The motor supplied with your Craftex 8" Professional Jointer is a 220 Volt, Single phase motor and is wired for 220 Volt operation.

The plug supplied with the motor has two flat, current-carrying prongs in tandem, and one round or "U" shaped longer ground prong, as shown in Fig.30. This plug is used only with the proper mating 3-conductor grounded receptacle, as shown in Fig. 30.

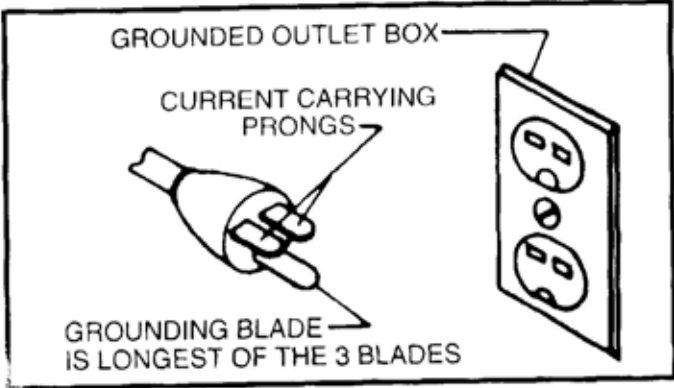


Fig. 30

EXTENSION CORDS

Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and a 3-prong receptacle which will accept the tool's plug. When using an extension cord, be sure to use one heavy enough to carry the current of the jointer. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Fig.31 shows the correct size to use depending on cord length. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

TOTAL LENGTH OF EXTENSION CORD FOR 120 VOLT OPERATION	TOTAL LENGTH OF EXTENSION CORD FOR 240 VOLT OPERATION	MINIMUM WIRE GAGE OF EXTENSION CORD
0 - 25 FT	0 - 50 FT	14 AWG
26 - 50 FT	51 - 100 FT	12 AWG
Greater than 50 FT	Greater than 100 FT	Not Recommended

Fig. 31

INFEED TABLE ADJUSTMENTS

1. To raise or lower the infeed table, loosen table locking handle (A) Fig. 35, which is located at the rear of the infeed table and loosen locking handle (B) Fig. 36, which is located at the front of the infeed table.

2. Raise or lower the infeed table adjustment lever (C) Fig. 36.

3. **IMPORTANT:** When lowering the infeed table, a depth stop (D) Fig. 36, will automatically stop the table at a $1/8"$ depth-of-cut. To move the table past this point, the depth stop (D) Fig. 37, must be raised, while simultaneously lowering the infeed table. Always make certain table locking handles (A) Fig. 35, and (B) Fig. 36, are tight before operating the jointer. The locking handles are springloaded and can be repositioned by pulling outward on the handle and repositioning it on the serrated nut located underneath the handle.

4. The depth-of-cut of the infeed table (position of the infeed table in relation to the cutting circle) is indicated on scale (E) Fig. 37. **NOTE:** Maximum depth-of-cut with this jointer is $1/2"$, which can be accomplished in cuts of $1/8"$ increments.

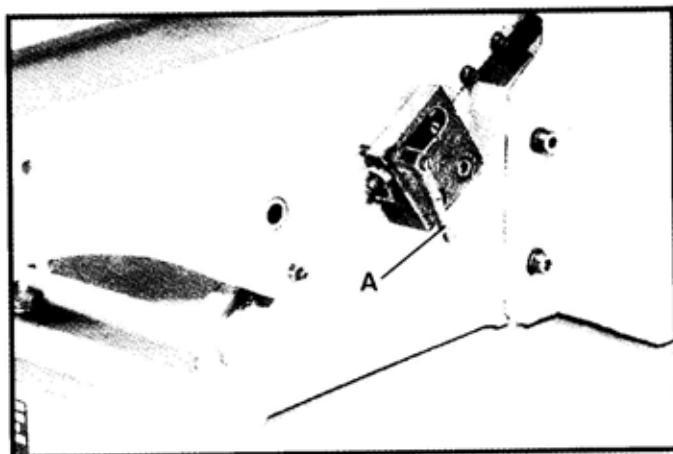


Fig. 35

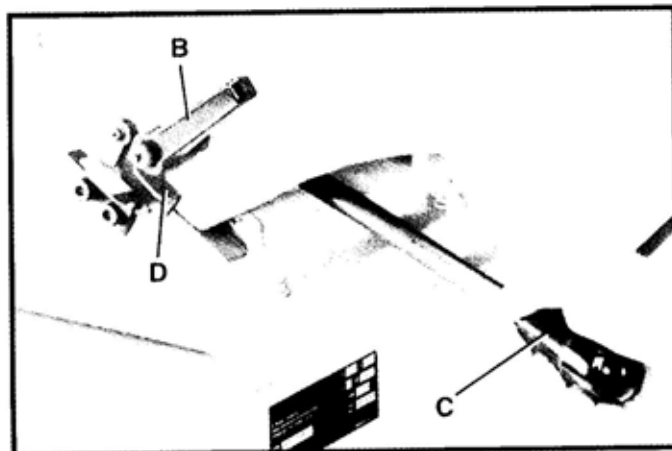


Fig. 36

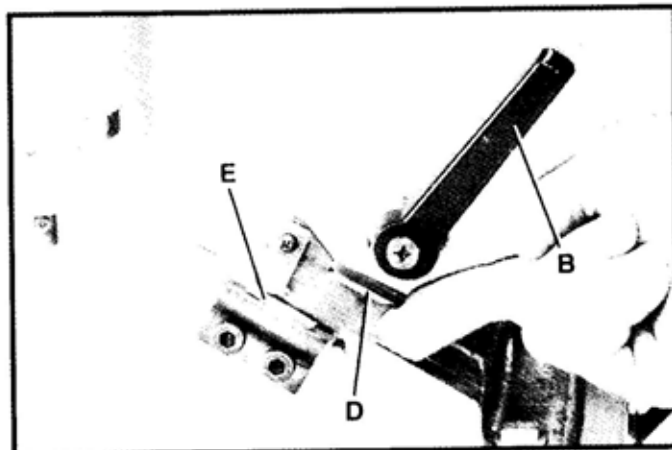


Fig. 37

INFEED TABLE POSITIVE STOPS

Positive stops are provided to limit the height and depth of the infeed table. To adjust the positive stops:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**

2. Loosen two locknuts (A) and (B) Fig.38, and turn the adjustment screws (C) and (D), which are located at the rear of the infeed table, as required. A good suggestion is to set the upper positive stop (D) against stud (E) for your finish or final cut. This means that you will be able to rapidly set the infeed table for a finish or final cut without checking the scale and the pointer. Also, the lower positive stop (C) can be set against stud (E) at the maximum depth of cut, if desired.

3. Tighten locking nuts (A) and (B) Fig.38, after adjustments are made.

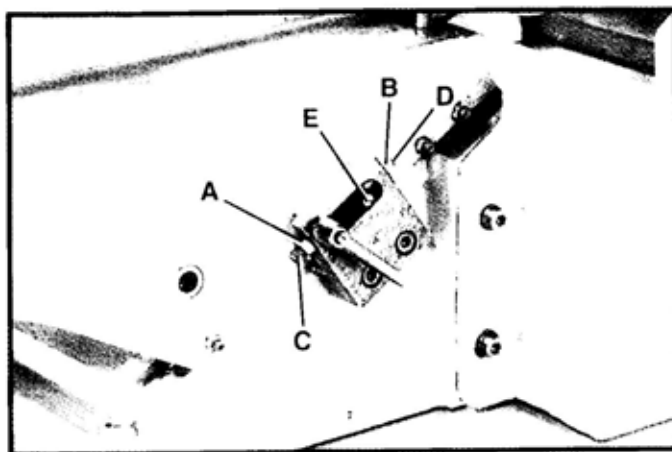


Fig. 38

OUTFEED TABLE ADJUSTMENTS

In order to perform accurate jointing operations, the outfeed table must be exactly level with the cutterhead knives at their highest point of revolution. This means that the knives must be parallel to the outfeed table and project equally from the cutterhead. To adjust the outfeed table:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE**

2. Loosen locking screw (A) Fig.39, and turn knob (B). When the outfeed table is exactly level with the cutterhead knives at their highest point of revolution, tighten screw (A).



Fig. 39

KNIFE ADJUSTMENTS

In order to do accurate work, the knives must be level with the outfeed table. To check and adjust, if necessary, proceed as follows:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE**

2. Remove set screw holding the cutterhead guard (A) Fig. 40, in position and remove cutterhead guard.

3. Loosen table locking handles and lower infeed table as described in section "INFEED TABLE ADJUSTMENTS".

4. Place a steel straight edge on the outfeed table, extending over the cutterhead as shown in Fig. 41.

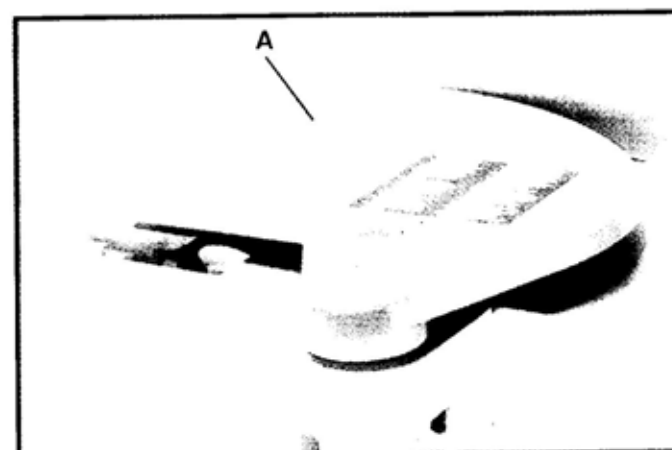


Fig. 40

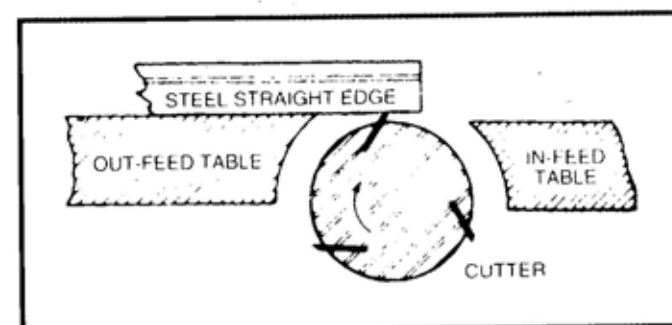


Fig. 41

5. Carefully rotate the cutterhead by hand. The knives should just touch the straight edge.

6. If the knife is too high or too low at either end, slightly turn five screws, four of which are shown at (D) Fig. 42, in the knife locking bar clockwise to loosen, using wrench (E) supplied. Then adjust the height of the knife by turning the knife raising screws (F) Fig. 43, counterclockwise to lower or clockwise to raise the knife. NOTE: If the knife must be lowered, it will be necessary to carefully push down on the knife after screws (F) have been turned. **WARNING: BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP. IMPORTANT:** Tighten knife locking screws (D) after adjustments have been made.

7. Repeat the procedures for adjusting the remaining two knives if necessary.

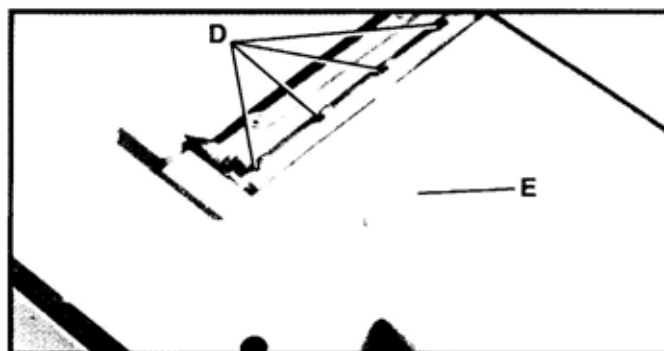


Fig. 42

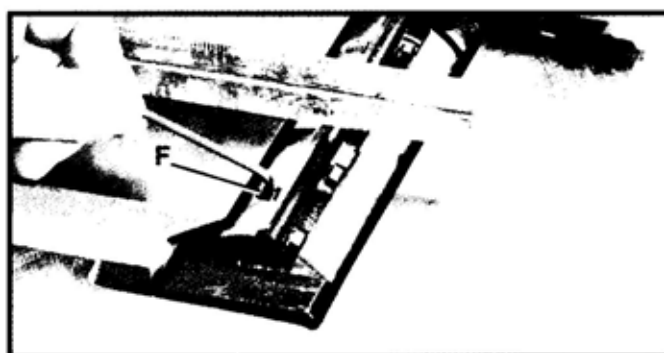


Fig. 43

8. If the knives are set too low, the result will be as shown in Fig. 44, and the surface will be curved.

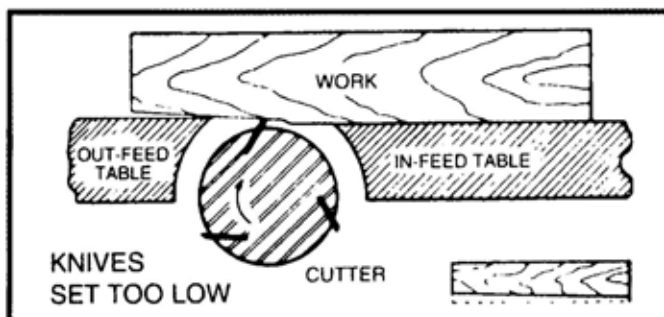


Fig. 44

9. If the knives are set too high, the work will be gouged at the end of the cut, as shown in Fig. 45.

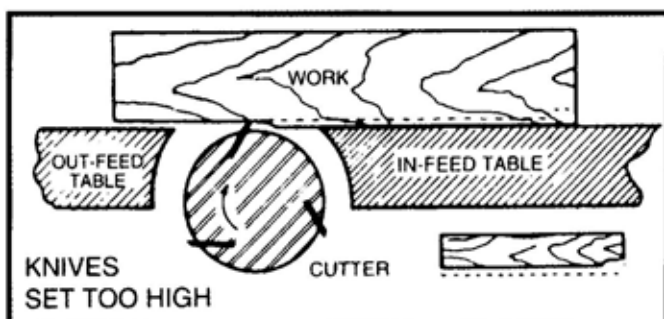


Fig. 45

10. As a final check, run a piece of work slowly over 6 to 8 inches over the knives. The work should rest firmly on both tables as shown in Fig. 46, with no open spaces under the finished cut.

11. Replace the cutterhead guard that was removed in STEP 2.

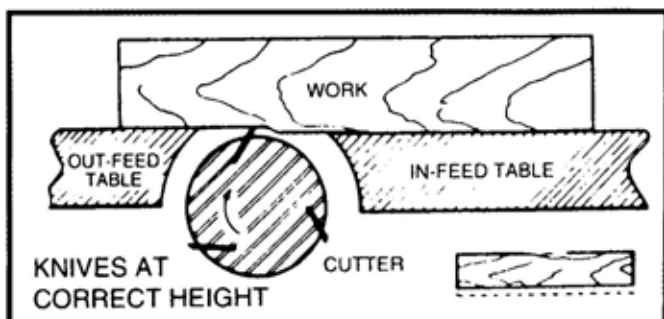


Fig. 46

ADJUSTING TABLE GIBS

"Gibs" are provided to take up any play that may develop between the mating dovetailed ways of the base and the infeed and outfeed tables, due to excessive wear. The gib for the infeed table is shown at (A) Fig. 47. Proper gib adjustment is necessary for the functioning of the jointer. The gib was adjusted at the factory and should not require further adjustment. However, if it ever becomes necessary to adjust the gib, due to excessive wear, proceed as follows.

1. To adjust the infeed table gib, loosen locking knobds (C) Fig. 48 and (F) Fig. 49. Loosen three locknuts (B) Fig. 48, and tighten or loosen three adjustment screws (D) as necessary. **NOTE:** Adjust the lower screw first and as you proceed to the upper adjustment screws, gently raise the outboard edge of table. This will offset any tendency for the table casting to "droop or sag" and permit the gib to be adjusted to the proper fit to the upper adjustment screws. Tighten three locknuts (B) Fig. 48, and two table locking levers.

2. To adjust the outfeed table, loosen locking lever (H) Fig. 50. Loosen two locknuts (E) and tighten or loosen two adjustment screws (G) as necessary. **NOTE:** Adjust the lower adjustment screw first and as you proceed to the upper adjustment screw, gently raise the outboard edge of the table. This will offset any tendency for the table casting to "droop or sag" and permit the gib to be adjusted to the proper fit to the upper adjustment screws. Tighten two locknuts (E) and locking lever (H).

IMPORTANT: Do not leave the adjustment screws too loose when adjusting the table gibs. It should take a little effort to raise and lower the tables. Jointers are finishing machines and you cannot expect to perform accurate finishes if the tables are loose and "sloppy".

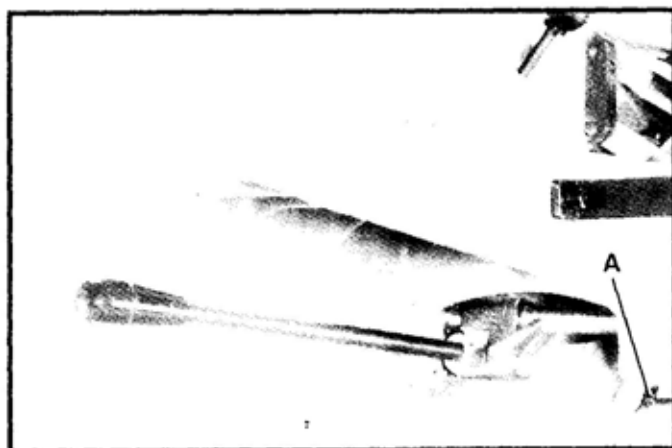


Fig. 47

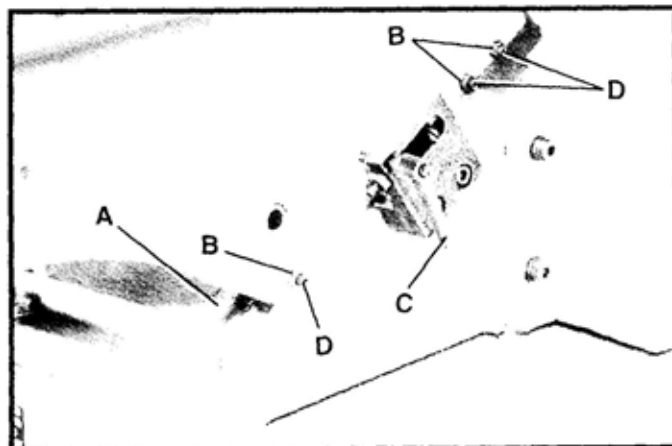


Fig. 48

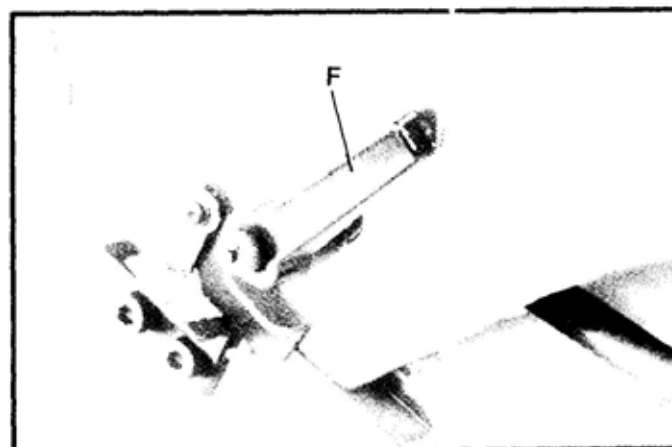


Fig. 49

IDENTIFICATION PLATE

The identification plate (K) Fig. 50, is located at the rear of the infeed table. Record the serial number and model number on the front of this manual for future reference.

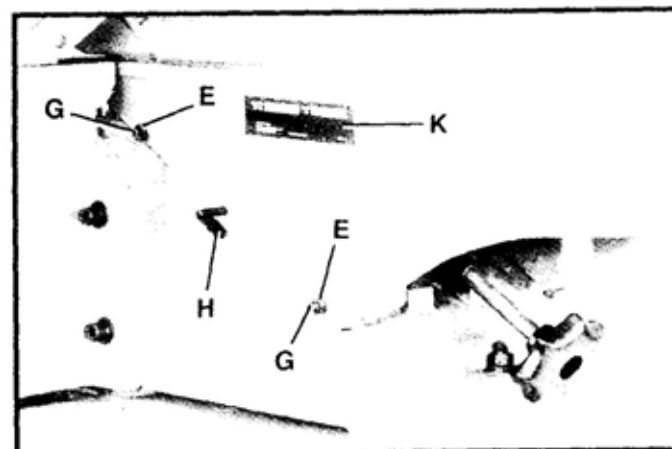


Fig. 50

FENCE OPERATION

The fence can be moved across the table and can be tilted up to 45 degrees right or left at any position on the table as follows:

NOTE: SWITCH HAS BEEN REMOVED FOR CLARITY OF ILLUSTRATIONS ONLY.

1. To move the fence across the table, loosen locking handle (A) Fig. 51, and turn knob (B) accordingly until the fence is in the desired position; tighten locking handle (A). As the fence is moved across the table, the rear cutter – head guard (C) Fig. 51, extends over the knives in back of the fence for operator safety. **NOTE:** Locking handle (A) Fig. 51, is spring – loaded and repositioning it on the serrated nut located under the hub of the handle.

2. To tilt the fence in or out, loosen locking handle (D) Fig. 51. While holding fence tilting handle (E) Fig. 52, rotate flip stop (F) and tilt the fence in or out to the desired angle and tighten locking handle (D). **IMPORTANT:** When cutting bevels and the angle is small, there is little difference whether the fence is tilted in or out; however, at angles approaching 45 degrees, it may become difficult to hold the work securely against the fence when it is tilted outward. In this case, we suggest that the fence (G) be tilted toward the table as shown in Fig. 53. The fence will form a V – shape with the table, and the work is easily pressed into the pocket while passing across the knives.

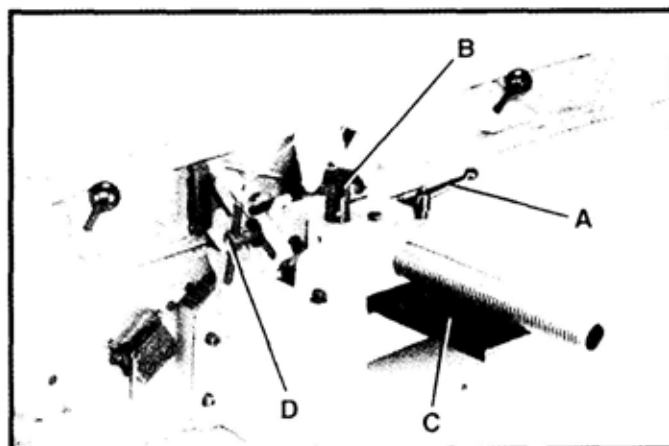


Fig. 51

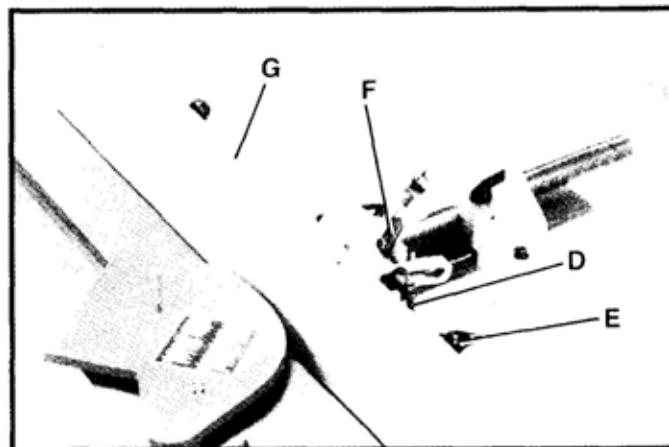


Fig. 52

ADJUSTING FENCE POSITIVE STOPS

NOTE: SWITCH HAS BEEN REMOVED FOR CLARITY OF ILLUSTRATIONS ONLY!

The fence has been equipped with positive stops that allow you to rapidly tilt the fence to 90 degree and 45 degree angles, inward and outward, to the table. To check and adjust the positive stops, proceed as follows:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE**

2. Position the fence at 90 degrees to the table. Make certain flip stop (F) Fig. 54, is lowered as shown, and adjustment screw (H) is contacting the flip stop (F); then tighten locking handle (D).

3. Place a square (K) Fig. 54, on the table and against the fence as shown to check if the fence is 90 degrees to the table.

4. If an adjustment is necessary, loosen locking handle (D) Fig. 54, and locknut (L). Rotate adjustment screw (F) until you are certain the fence is 90 degrees to the table. Tighten locknut (L).

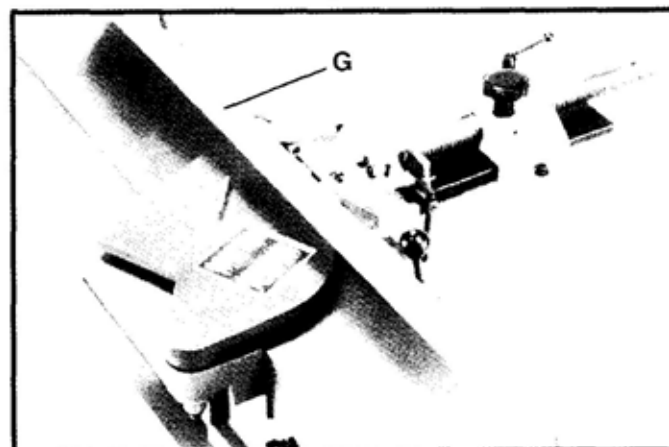


Fig. 53

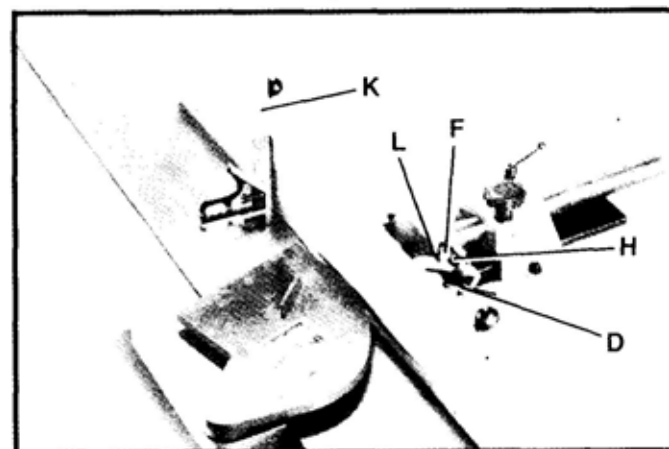


Fig. 54

5. Rotate flip stop (F) Fig. 55, and tilt the fence outward as far as it will go and tighten locking handle (D). Place a square (K) on the table and against the fence to check if the fence is 45 degrees outward to the table.

6. If an adjustment to the positive stop is necessary, loosen locking handle (D) Fig. 55, and locknut (M). Rotate adjustment screw (N) until you are certain the fence is 45 degrees outward to the table. Tighten locknut (M).

7. Tilt the fence (G) Fig. 56, inward as far as it will go and tighten locking handle (D). Using a square (K) on the table and against the fence, check if the fence is 45 degrees inward to the table.

8. If an adjustment is necessary, loosen locknut (P) Fig. 56. Rotate screw (R) until you are certain the fence is 45 degrees inward to the table. Tighten locknut (P) and locking handle (D).

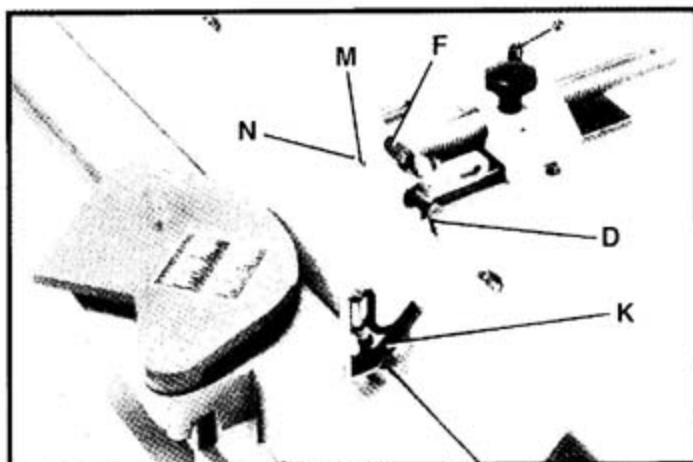


Fig. 55

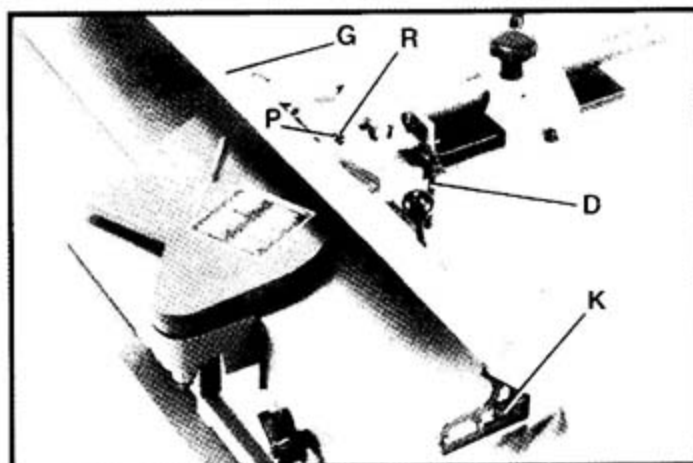


Fig. 56

REMOVING, REPLACING, AND RESETTNG KNIVES

If the knives are removed from the cutterhead for replacement or regrinding, care must be used in removing, replacing, and resetting them as follows:

1. **DISCONNECT THE MACHINE FROM THE POWER SOURCE.**

2. Move the fence to the rear and remove the cutterhead guard. **WARNING: BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES.**

3. Using wrench (A) Fig. 57, slightly loosen the locking screws, three of which are shown at (B) Fig. 57, in each knife slot by turning the screws (B) clockwise. This relieves stress in the cutterhead.

4. Loosen screws (B) Fig. 57, further and remove knife (C) Fig. 58, and knife locking bar (D).

5. Fig. 58, illustrates the knife (C) and knife locking bar (D) removed from the cutterhead. Remove the remaining two knives and locking bars, in the same manner.

6. Using wrench supplied, lower the two knife adjustment blocks by turning screws (F) counterclockwise in all three slots of the cutterhead.

7. Before replacing knives make certain the knife locking bars are thoroughly clean and free of gum and pitch.

8. Replace the knife locking bars (D) Fig. 58, and knives (C) into each slot in the cutterhead. **WARNING: CARE MUST BE TAKEN WHEN INSERTING THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP.** Push the knife down as far as possible and snug up the five screws (B) Fig. 57, three of which are shown, by turning each screw counterclockwise just enough to hold the knife in position. Replace the remaining two knives in the same manner. **NOTE: KNIVES MUST BE INSTALLED CORRECTLY AS SHOWN IN FIG. 59.**

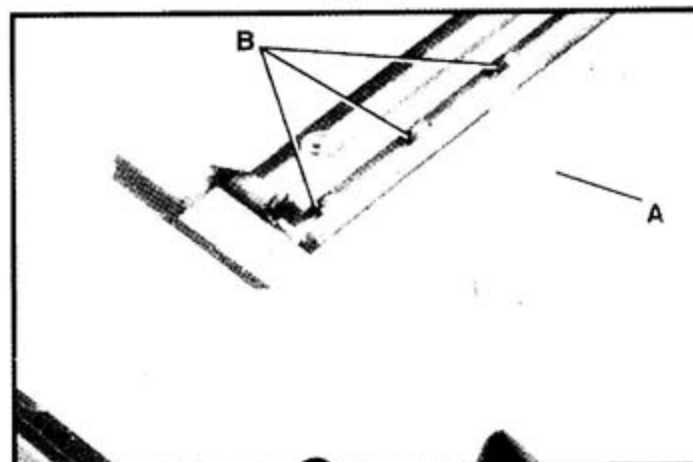


Fig. 57

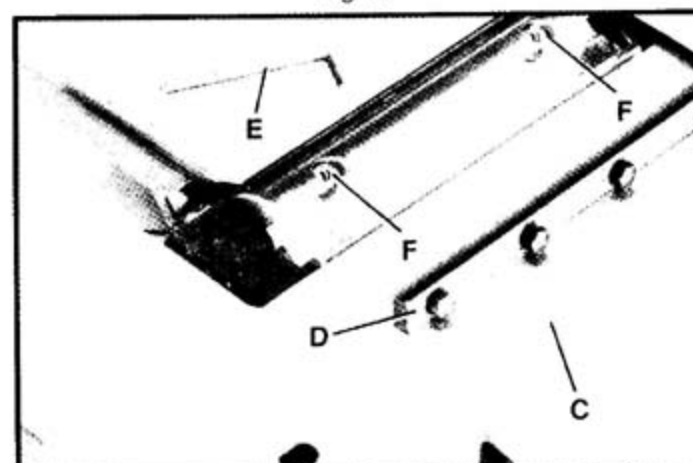


Fig. 58

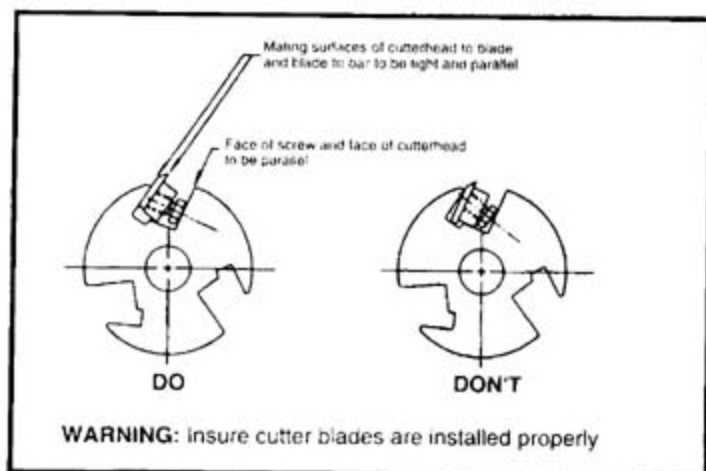


Fig. 59

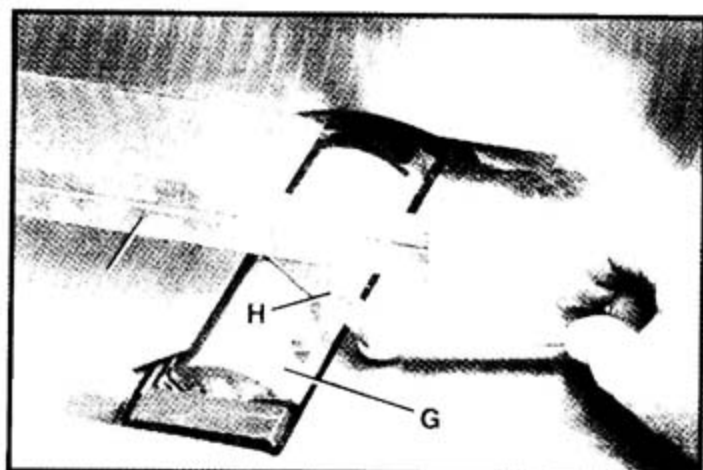


Fig. 60

9. The knives are adjusted correctly when the cutting edge of the knife extends out .060" from the cutterhead diameter.

10. Carefully rotate the cutterhead (G) Fig. 60, until the round portion of the cutterhead is on top as shown.

11. Place a .060" feeler gage (H) Fig. 60, on the cutterhead and using a straight edge (J) on the rear table adjust the height of the rear table until it is .060" above the cutting-head diameter, as shown.

12. Lock the rear table in position and remove the feeler gage.

13. Lower the infeed table and place a straight edge (J) Fig. 61, on the outfeed table extending over the cutterhead as shown.

14. Rotate the cutterhead by hand until the knife is at its highest point at each end of the cutterhead. To raise the knife, use wrench (E) Fig. 61, and turn raising screw clockwise until the knife just touches the straight edge (J) on each end and center of the cutterhead when the knife is at its highest point. When you are certain the knife is adjusted proper-

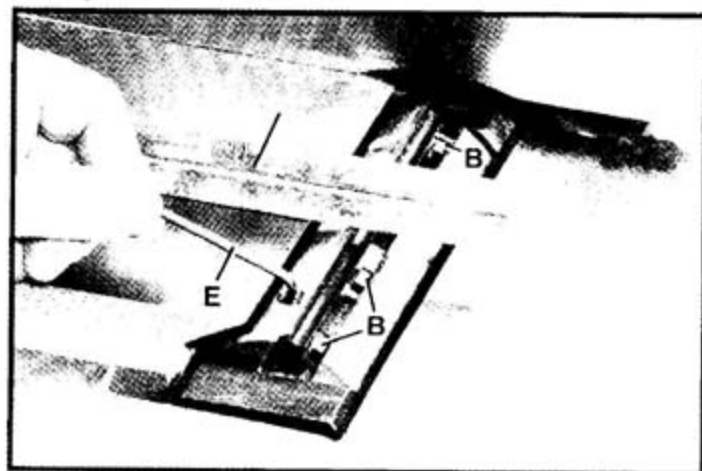


Fig. 61

ly, tighten the five locking screws (B) Fig. 61, three of which are shown, by turning them counterclockwise.

15. Adjust the remaining two knives in the same manner.
WARNING; MAKE CERTAIN THAT ALL KNIVES ARE SECURELY FASTENED IN CUTTERHEAD BEFORE TURNING ON POWER.

16. Replace cutterhead guard.

MAINTENANCE AND REPAIRS

After considerable use, the knives will become dull and it will not be possible to do accurate work. Unless badly damaged by running into metal or other hard material, the knives may be sharpened as follows:

WHETTING KNIVES

DISCONNECT THE MACHINE FROM THE POWER SOURCE. Use a fine carborundum stone, cover it partly with paper as indicated in Fig. 62 to avoid marking the table. Lay the stone on the infeed table, lower the table and turn the cutterhead forward until the stone lies flat on the bevel of the knife as shown. Hold the cutterhead from turning, and whet the bevelled edge of the knife, stroking lengthwise by sliding the stone back and forth across the table. Do the same amount of whetting on each of the three knives.

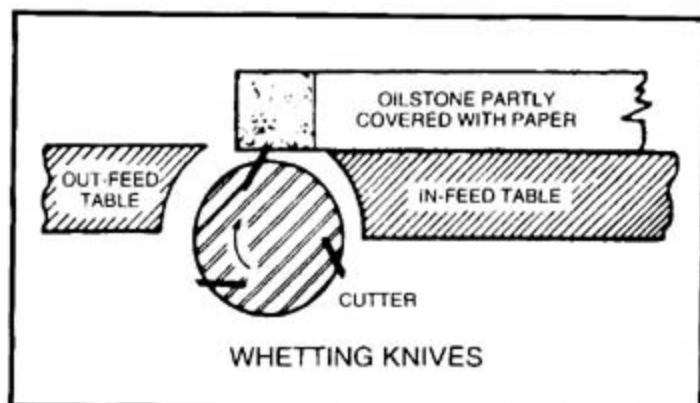


Fig. 62

OPERATIONS

The following directions will give the beginner a start on jointer operations. Use scrap pieces of lumber to check settings and to get the feel of the operations before attempting regular work.

WARNING: ALWAYS USE CUTTERHEAD GUARD AND KEEP HANDS AWAY FROM CUTTERHEAD.

ALWAYS USE PUSH BLOCKS WHENEVER POSSIBLE.

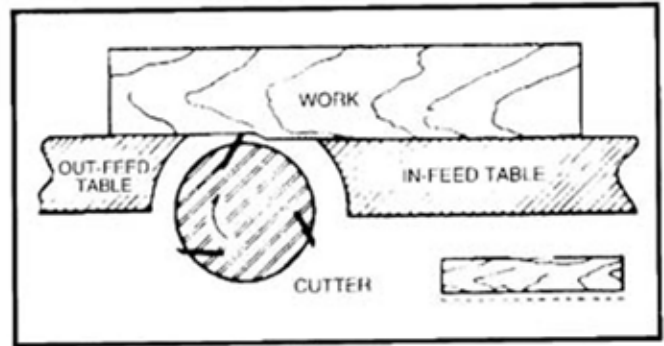


Fig. 63

DEFINITIONS OF JOINTING AND PLANING OPERATIONS

Jointing Operations - Jointing cuts or edge jointing is the simplest and most common operation which can be done on the jointer and these cuts are made to square an edge of a workpiece. The fence is square with the table and the depth of cut is approximately $1/8$ inch. the workpiece is positioned on the jointer with the narrow edge of the workpiece on the infeed table and the major flat surface of the workpiece against the fence, as shown in Figs. 63 and 64. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table. The hand over the outfeed table presses the work down so that the newly-formed surface will make perfect contact with the table. The hand over the infeed table (usually the right hand) exerts no downward pressure, but simply advances the work to the cutterhead. Both hands exert pressure to keep the work in contact with the fence.



Fig. 64

IMPORTANT: DO NOT PERFORM JOINTING OPERATIONS ON MATERIAL SHORTER THAN 10 INCHES, NARROWER THAN $3/4$ INCH, OR LESS THAN $1/2$ INCH THICK. REFER TO FIG. 85

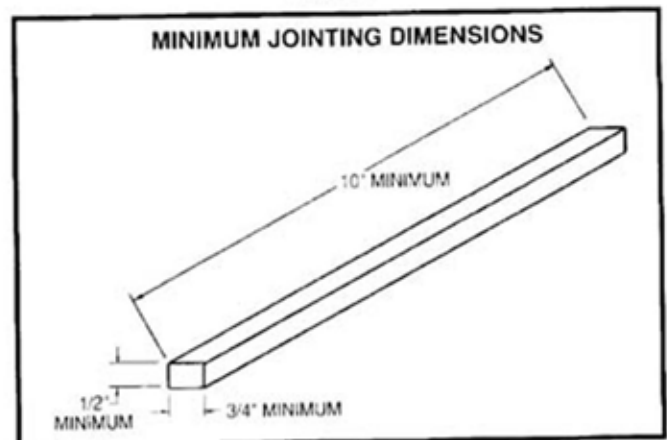


Fig. 65

Planing Operations - Planing or surfacing are identical to the jointing operation except for the position of the workpiece. For planing, the major flat surface of the workpiece is placed on the infeed table of the jointer with the narrow edge of the workpiece against the fence, as shown in Fig. 66. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table establishing a flat surface on the workpiece. Always use push blocks when performing planing operations.

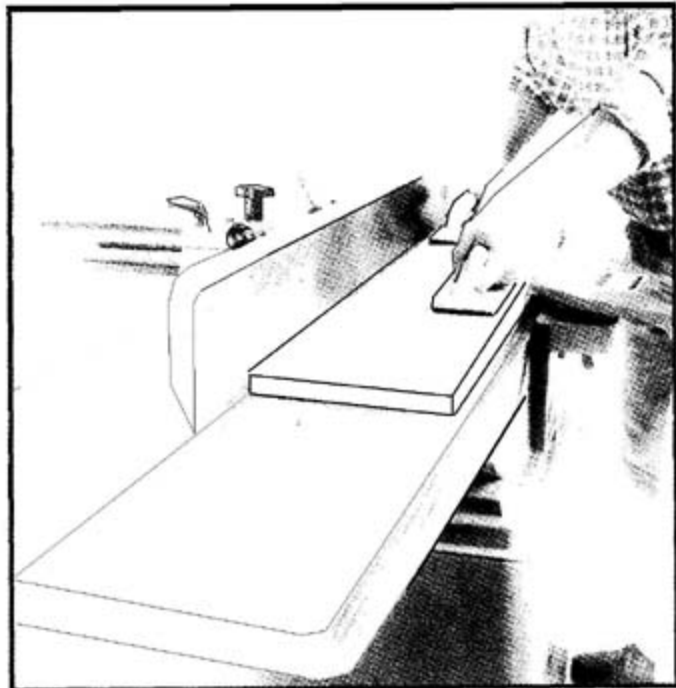


Fig. 66

BEVELING

To cut a bevel, lock the fence at the required angle and run the work across the knives while keeping the work firmly against the fence and tables. Several passes may be necessary to arrive at the desired result. When the angle is small, there is little difference whether the fence is tilted to the right or left. However, at greater angles approaching 45 degrees, it is increasingly difficult to hold the work properly when the fence is tilted to the right. The advantage of the double-tilting fence is appreciated under such conditions.

When tilted to the left, the fence forms a V-shape with the tables, and the work is easily pressed into the pocket while passing it across the knives. If the bevel is laid out on the piece in such direction that this involves cutting against the grain, it will be better to tilt the fence to the right.

Fig. 67, illustrates a slight bevel being cut onto the edge of a workpiece.

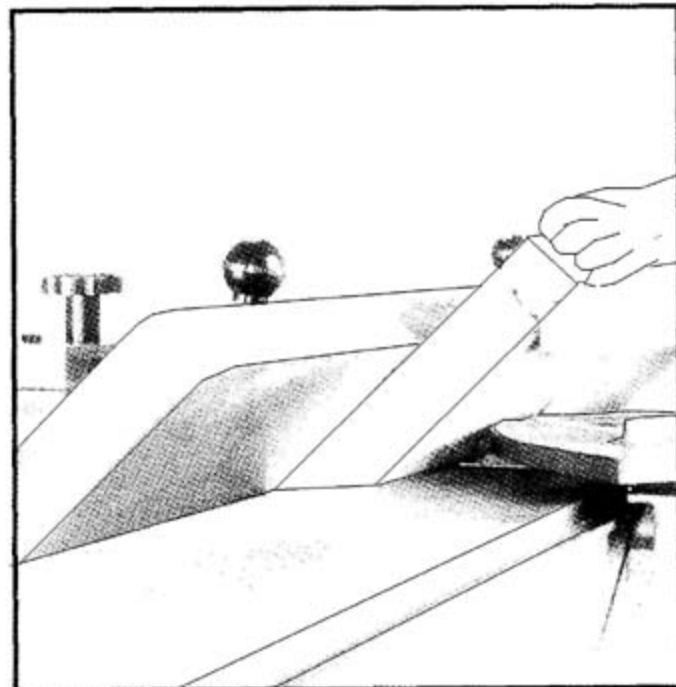


Fig. 67

TAPER CUTS

One of the most useful jointer operations is cutting an edge to a taper. The method can be used on a wide variety of work. Tapered legs of furniture are a common example.

Instead of laying the piece on the infeed table, lower the forward end of the work onto the outfeed table. Do this very carefully, as the piece will span the knives, and they will take a "bite" from the work with a tendency to kick back unless the piece is firmly held. Now push the work forward as in ordinary jointing. The effect is to plane off all the stock in front of the knives, to increasing depth, leaving a tapered surface.

The ridge left by the knives when starting the taper may be removed by taking a very light cut according to the regular method for jointing, with the infeed table raised to its usual position.

Practice is required in this operation, and the beginner is advised to make trial cuts on waste material. Taper cuts over part of the length and a number of other special operations can easily be done by the experienced craftsman.

CUTTING A RABBET

When making a rabbet cut, as shown in Fig. 68, the cutter-head guard must be removed. **AFTER THE RABBET CUT IS COMPLETED, BE CERTAIN GUARD IS REPLACED.**

1. Adjust the fence so that the distance between the end of the knives and the fence is equal to the width of the rabbet.
2. Lower the infeed table an amount equal to the depth of the rabbet. If the rabbet is quite deep, it may be necessary to cut it in two or more passes. In that event, the table is lowered an amount equal to about half the depth of the rabbet for the pass, then lowered again to proper depth to complete the cut.



Fig. 68

PLANING WARPED PIECES

If the wood to be planed is dished or warped, take light cuts until the surface is flat. Avoid forcing such material down against the table; excessive pressure will spring it while passing the knives, and it will spring back and remain curved after cut is completed.



Fig. 69

PLANING SHORT OR THIN WORK

When planing short or thin pieces, always use push blocks to minimize all danger to the hands. Fig. 69, illustrates using the push blocks properly.

DO NOT PERFORM PLANING OPERATIONS ON MATERIAL SHORTER THAN 10 INCHES, NARROWER THAN 3/4 INCH, WIDER THAN 8 INCHES, OR LESS THAN 1/2 INCH THICK (REFER TO FIG. 70).

MINIMUM AND MAXIMUM PLANING DIMENSIONS

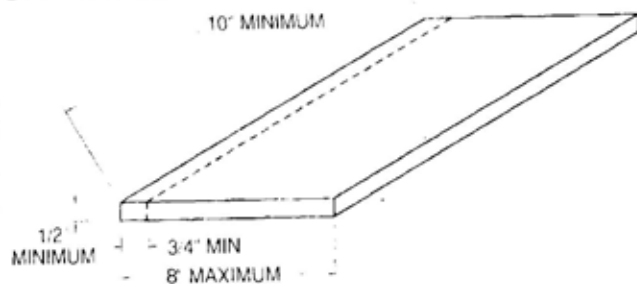


Fig. 70

DIRECTION OF GRAIN

Avoid feeding work into the jointer against the grain as shown in Fig. 71. The result will be chipped and splintered edges. Feed with the grain as shown in Fig. 72, to obtain a smooth surface.

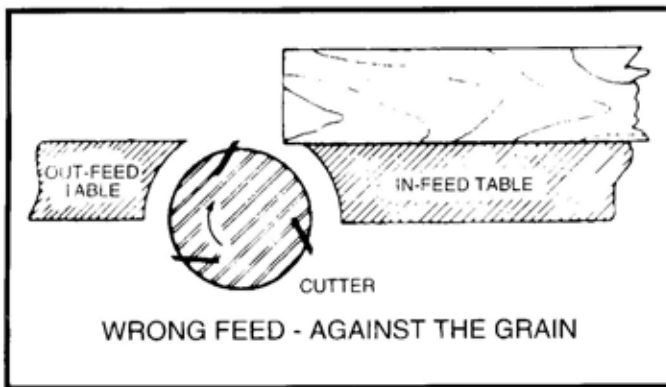


Fig. 71

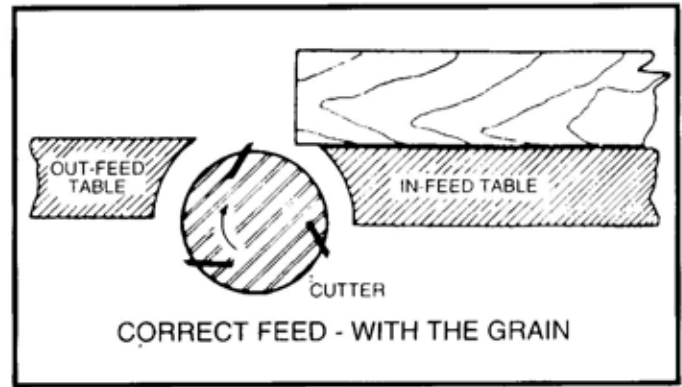


Fig. 72

CONSTRUCTING A PUSH STICK

Narrow pieces of stock that are close to 10 inch minimum length should be handled with a push stick and push block. Fig. 73, is a pattern for a push stick.

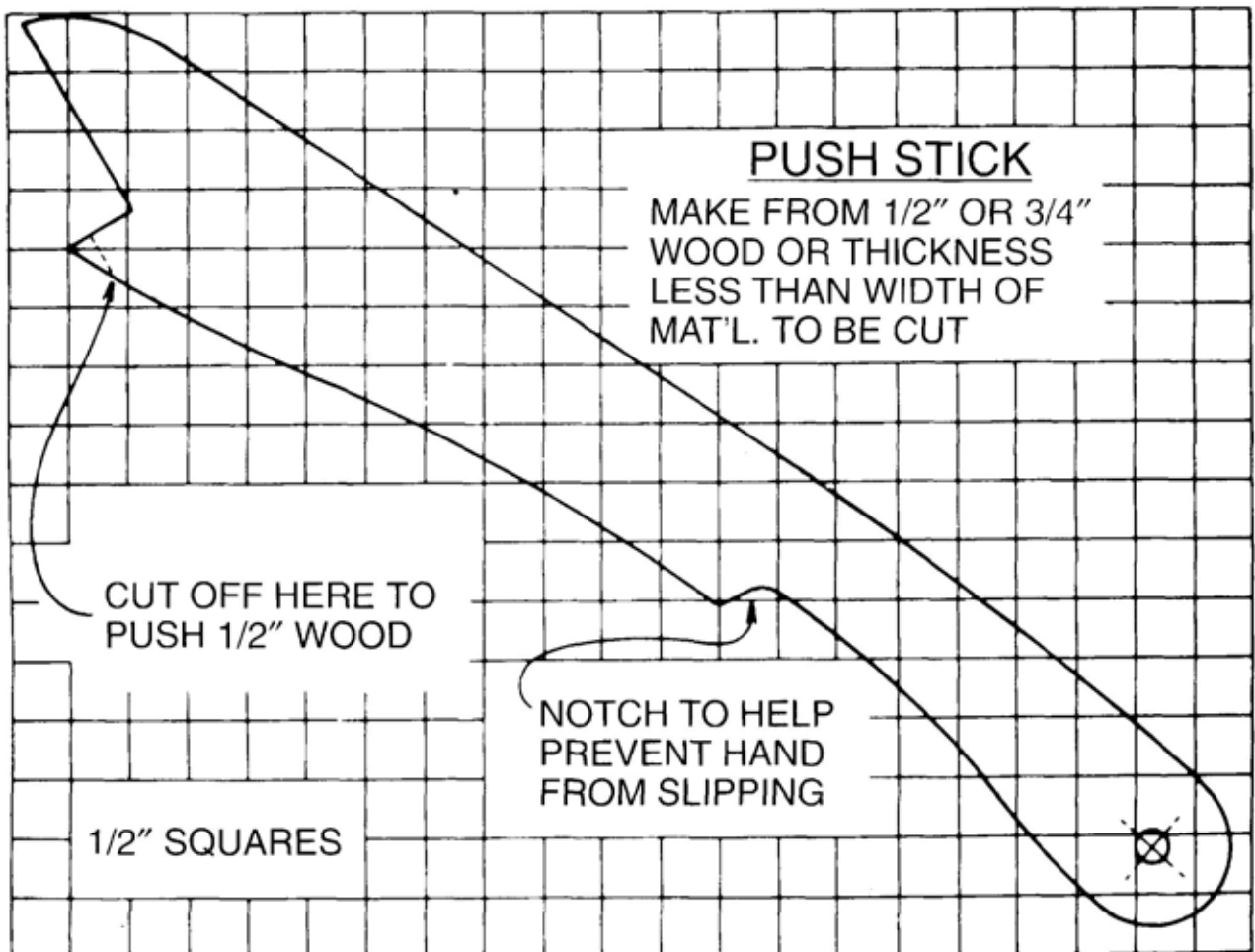


Fig. 73



CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **2 year** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

Proof of purchase is necessary.

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras.

Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY(2879), and have your credit card and part number handy.

- All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.
- Returns must be pre-authorized by us in writing.
- **We do not accept collect shipments.**
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse (see locations on inside back cover of this manual).
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an unused condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.

For more information, please call Toll Free: **1-800-461-BUSY** or visit **www.busybeetools.com**