CT202-12” JOINTER
With SPIRAL CUTTER-HEAD

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GENERAL SAFETY INSTRUCTIONS

Extreme caution should be used when operating all power tools. Know your power tool, be familiar with its operation, read through the owner's manual and practice safe usage procedure at all times.

- **CONNECT your machine ONLY to the matched and specific power source.**
- **ALWAYS wear safety glasses respirators, hearing protection and safety shoes, when operating your machine.**
- **DO NOT wear loose clothing or jewelry when operating your machine.**
- **A safe environment is important. Keep the area free of dust, dirt and other debris in the immediate vicinity of your machine.**
- **DISCONNECT the power source when changing drill bits, hollow chisels, router bits, shaper heads, blades, knives or making other adjustments or repairs.**
- **ALWAYS keep all safety guards in place and ensure their proper function.**
- **NEVER reach over the table when the tool is in operation.**
- **ALWAYS keep blades, knives and bits sharpened and properly aligned.**
- **NEVER leave a tool unattended while it is in operation.**
- **BE ALERT! DO NOT use prescription or other drugs that may affect your ability or judgment to safely use your machine.**
- **ALWAYS use push sticks and feather boards to safely feed your work through the machine.**
- **ALWAYS make sure that any tools used for adjustments are removed before operating the machine.**
- **Always keep the bystanders safely away while the machine is in operation.**

CT202-12” Jointer
Specific Safety Instructions

- **Always lock the mobile base before operating the machine.**
- **Always use push blocks when jointing stock that does not provide a reasonable distance of safety for your hands.**
- **Never make cuts deeper than 1/8” in a single pass to prevent overloading the machine and to prevent dangerous kickback.**
- **Always make sure that the exposed cutter head behind the fence is guarded particularly when jointing near the leading edge such as in rabbetting.**
- **Always make adjustments with the power OFF.**
- **Maintain the proper relationship of the in-feed and out-feed table surfaces and the cutter head knife path.**
- **All operations must be performed with the guards in place to ensure safety.**
- **Never back your work-piece into the spinning cutter-head.**
- **Never allow your hands to pass directly over the cutter head.**
- **Always inspect your stock before feeding it over the cutter-head.**
- **IF you are not familiar with the operations of a jointer, you should obtain the advice and/or instructions from a qualified professional.**

IMPORTANT: The safety instructions given above can not be complete because the environment in every shop is different. Always consider safety first as it applies to your individual working conditions.

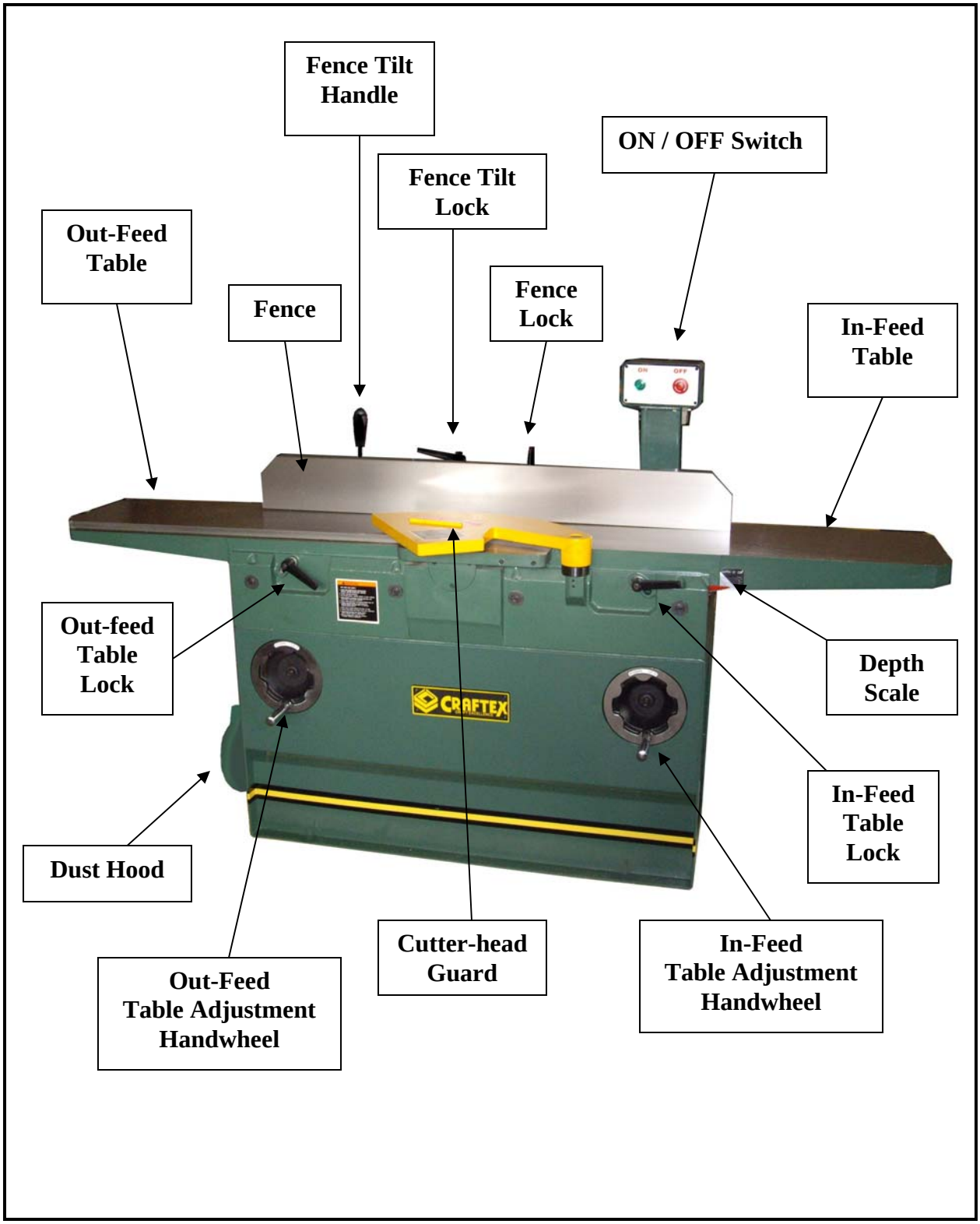
JOINTER FEATURES

MODEL CT202-12” JOINTER WITH SPIRAL CUTTER-HEAD

As part of the growing line of Craftex woodworking equipment, we are proud to offer the CT202-12” Jointer with Spiral Cutter-Head. The Craftex name guarantees Craft Excellence. By following the instructions and procedures laid out in this owner’s manual, you will receive years of excellent service and satisfaction. The CT202 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- Motor: 3 HP, 220 Volts, Single Phase, 15 Amps
- 3 ‘V’ Belts Drive.
- Max. Depth of Cut – 1/8”
- Max. Width of Cut – 12”
- Cutter-Head Type: Spiral Cutter-Head with German Made Carbide Inserts
- Cutter Head Speed: 4950 RPM
- Number of Carbide Inserts: 60
- Cuts per Minute – 19800
- Table Size: 12-3/4” Width, 83-1/2” Length and Height (from floor) 31-11/16”
- Fence Size: 1 1/2” Width, 46-3/4” Length, 5-3/8” Height, 45 & 90 Degrees Stops
- Die Cast Metal Cutter-Head Guard
- All Ball Bearing and Cast-Iron Construction
- Precision Ground Cast Iron In-feed and Out-feed
- Parallelogram Beds
- Powder Coated Body
- 5” Dust Hood is included
- Carton Size: 89” x 30” x 40-1/2”
- Net Weight 890 lbs
- Warranty – 2 YEARS

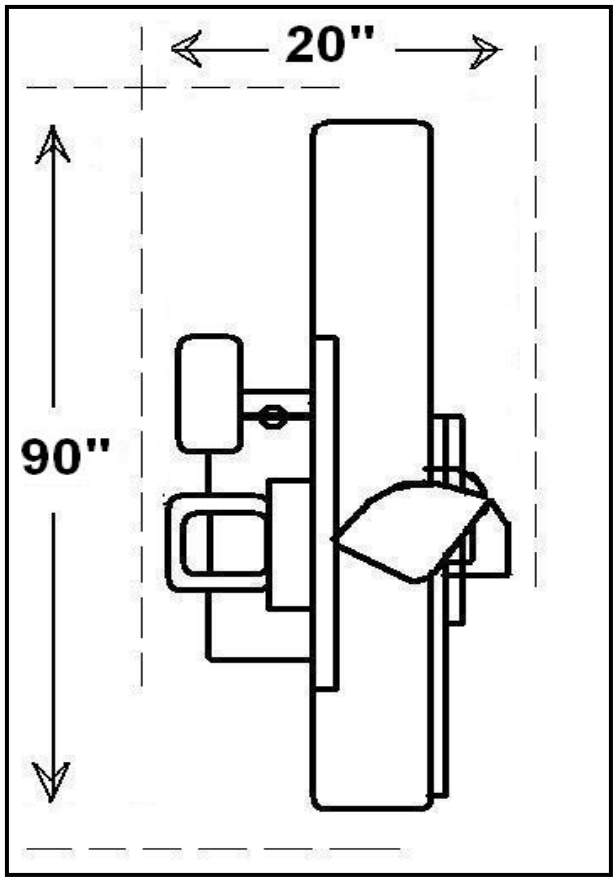
PHYSICAL FEATURES



Setup

To setup the machine you need an assistant to help you. For the protection of your eyes both of you need to have safety glasses. The unpainted surfaces of the jointer are coated with rust prevention waxy oil and you will want to remove this before you begin assembly. Use a solvent cleaner that will not damage painted surfaces

When setting up your machine, you will want to find an ideal spot where your jointer will most likely be positioned most of the time. Consider your complete work environment as well as working comfortable with the jointer before placing your machine in the ideal spot.



Minimum working space for your planer

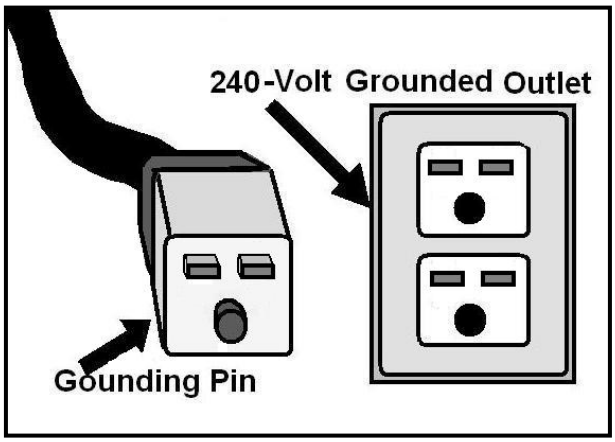
Unpacking

The machine is properly packaged in a wooden crate for safe transportation. When un-packing, carefully inspect the crate and ensure that nothing has been damaged during transit. Open the crate and check that the machine is in good condition. The machine is heavy and you should use a fork truck or get assistance to move the machine for safe moving method. You should also clean the cutter-head, in-feed and out-feed tables, and the fence before assembly and operation.

Proper Grounding

The machine is pre-wired to be used with a 240-volts power supply. Ensure the cord is plugged into a grounded power outlet.

To prevent possible electrical hazards, have a qualified electrician ensure that the line is properly wired



240-Volts Outlet for the Jointer (CT202)

Assembly

The machine comes virtually fully assembled from the factory. You will only need to rotate and install the switch bar and assemble the cutter-head guard. See Figure1

Figure 1: Un-packing the jointer

Installing the Cutter-Head Guard

To install the cutter-head guard move the fence backward so that you have enough space. Then insert the cutter-head guard shaft and use the set screws to tight it. See Figure 2

Figure 2: Cutter-head guard installed

The guard is provided with spring so that when it gets pulled backward, it spring back forward over the cutter-head.

After you are done installing the guard, test the guard by pulling it backward. See figure 3. If the guard doest not spring back over the cutter head: it means that the guard is not installed properly. Re-install it following the directions above.

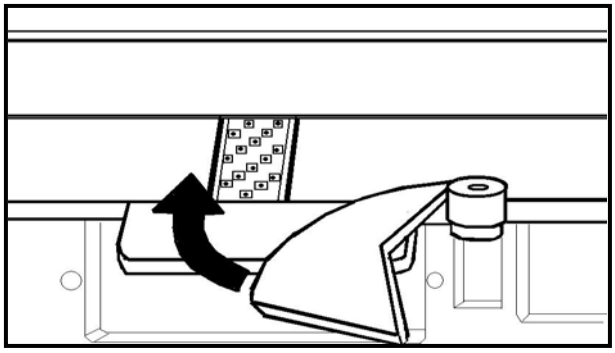


Figure 3: Cutter-head guard springing back over the cutter-head

Installing the Pedestal Switch

The pedestal switch comes attached upside down to the machine. To install the switch, remove the screws that hold the switch bar to the machine, and then rotate the switch bar 90°. Now, attach the switch bar to the jointer with the help of the screws and washers. See Figure 4

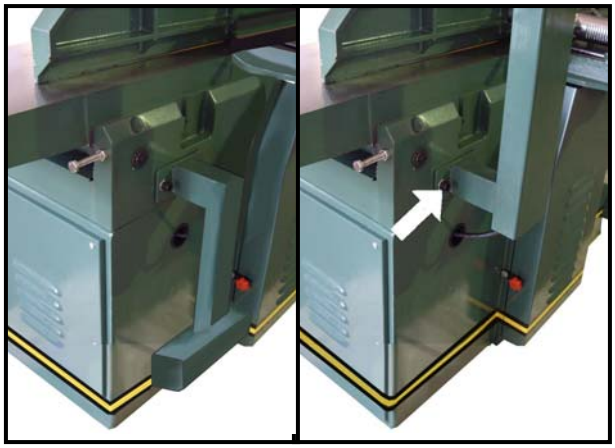
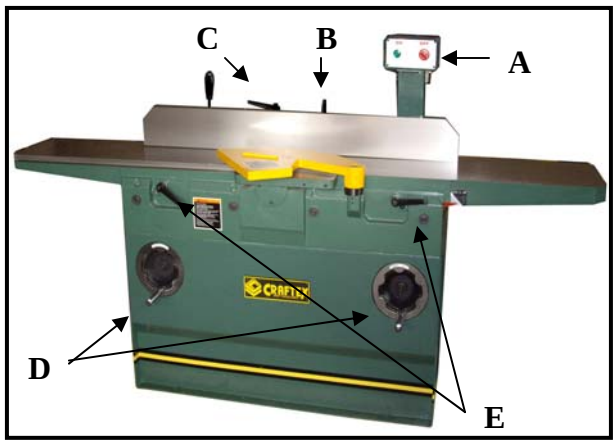


Figure 4: Rotating the pedestal switch 90°

Operations & Adjustments

Basic Controls

The basic controls of the jointer are shown in the figure below. Use this figure and read the text to know what the basic controls of your machine are.



Basic Controls of the Jointer

A. On/Off button: Starts and stops the jointer.

B. Fence Lock: Locks the fence so that it does not move forward or backward during any operation.

C. Fence Tilt Lock: Locks the fence in your desired angle so that it does not move during the operation.

D. Table Adjustment Wheels: Move the table forward and backward.

E. Table Lock: Locks the table to the position you want.

TEST RUN

Once you have assembled your machine completely, then it is time for a test run to make sure that the machine works properly and is ready for operation.
During the test run if there is an unusual noise coming from the machine or the machine vibrates, there problem might be because of the following:

1- Belts slapping cover
2- V-belts worn or loose
3- Pulley loose
4- Motor mounts loose or broken

After you investigate and if you find that the problem with your machine is one of the above,

1- Replace or realign the belts with a matched set
2- Replace the belts with a new matched set
3- Realign or replace shaft, pulley, setscrew and key
4- Tighten or replace the motor mount

WARNING

Before starting the jointer please make sure that you have read and understood the manual and you are familiar with the functions and safety features on this machine. Failure to do this may cause serious personal injury

Operations & Adjustments

Surface Planing

When surface planing on a jointer make sure the stock is clean of nails, staples or any other object. Set the cutting depth to 1/32" and make sure the fence is set to 90 degrees. Place the concave face of the stock flat on the in-feed table and run the jointer. Push the stock over the cutter head with the help of push blocks. See Figure 5

Figure 5: Surface planing operation
(Shown in use with 8" Jointer)

IMPORTANT
Never plane stock against the grain direction of the wood. It can cause a kick back or there is a possibility of tear-out on the wood.

Before planing stock always make sure that the stock is dry & clean and does not have nails, staples or any other object on it.

Do not joint stock having loose knots. It can cause a serious damage to the work piece or injury to the operator.

Edge Jointing

Edge jointing is to make the edge of the stock flat and suitable for joinery or finishing. To edge joint on the jointer make sure the stock is clean of nails, staples or any other object. Set the cutting depth to 1/16" & 1/8" and make sure the fence is set to 90 degrees. Place the concave face of the stock flat on the in-feed table and run the jointer. Use push blocks to push the stock over the cutter head. Repeat the same procedure until the edge of the stock is flat.

Figure 6: Edge jointing operation
(Shown in use with 8" Jointer)

IMPORTANT
To save your hands, always use push blocks when surface planing on the jointer. If you fail to use push blocks, the cutter-head touch your hand and can cause a serious injury to your hand.

Operations & Adjustments

Bevel Cutting

Bevel cutting is the cutting operation to cut a desired angle on the edge of the work piece.

To perform bevel cutting operation on a jointer, first of all make sure that the work-piece is dry, clean and free of nails or any kind of metal that can damage the cutter-head.

The fence of the jointer can be set to different angles and it has a stop that can hold the fence in that position so that it doest not move while operation.

It is recommended to set the cutting depth between 1/16” and 1/8” when doing bevel cutting.

Now, set the fence to your desired angle and start the jointer. Use push blocks to push the stock over the cutter-head. If the stock is cupped, make sure to put the concave face of the stock flat on the in-feed table. See figure 7

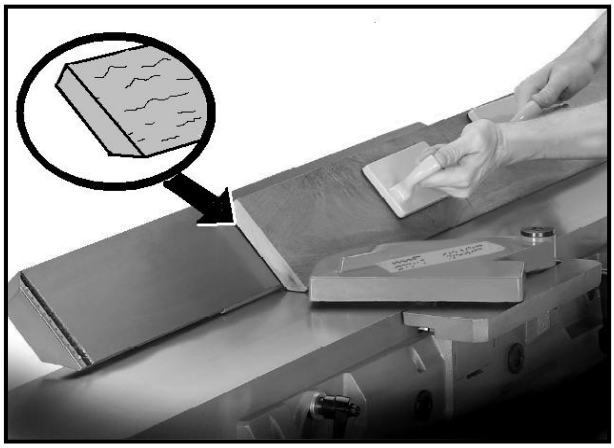


Figure 7: Bevel Cutting Operation
(Shown in use with 8” Jointer)

Operations & Adjustments

Inspecting the Cutter-Heads

The cutter-heads are supposed to be at the same height with each other and with the out-feed table. If one of the carbide inserts is higher than the others, you will get a poor result while doing any cutting operation.

To inspect the cutter-heads disconnect the jointer from the power source and remove the cutter-head guard so that you can have access to the cutter-head.

Now, take a straight edge and put it on the out-feed table so that it hangs over the cutter-head. Rotate the cutter head body and check the height of each carbide insert with the out-feed table. The inserts should just touch the bottom of the straight edge. If the inserts are set too high or too low then they should be adjusted.

Adjusting /Replacing Carbide Inserts

The carbide inserts get dull after sometimes and need to be adjusted or replaced occasionally.

To adjust or replace the carbide inserts, disconnect the machine from the power source and remove the cutter head guard to expose the cutter head with the carbide inserts.

Now, take a hex key and loosen the screws on the carbide inserts that hold each carbide insert to the cutter head body. See Figure 8

IMPORTANT: *The carbide inserts are very sharp and can cut your hand very easily. Be careful while adjusting / replacing them. Use gloves to prevent personal injury.*

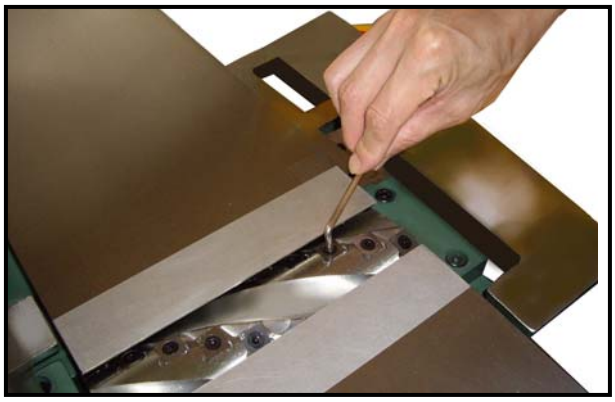


Figure 8: Removing the carbide inserts

Clean all the dust and debris on the cutter-head body and on the insert and replace it with a new one.

IMPORTANT: *Remember if the dust and debris on the cutter-head body is not cleaned, it will make the insert out of height alignment and may result in poor cutting performance.*

The carbide insert has a square shape and thus it has four cutting edges. When one edge of the carbide insert gets dull, simply rotate it 90 degrees and you will get a new and fresh cutting edge. When all four edges of the carbide insert are used replace it with a new one.

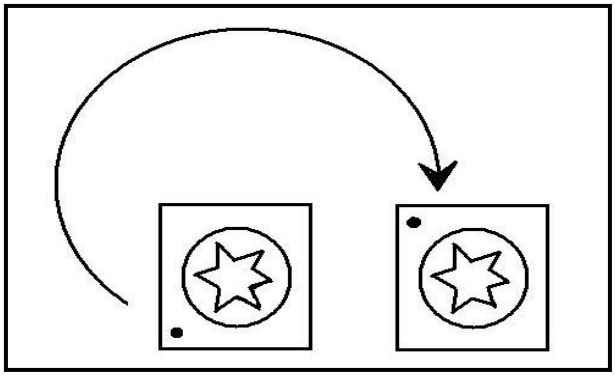


Figure 9: Rotating carbide insert 90°

Operations & Adjustments

Table Parallelism

For the best cutting results, the in-feed and out-feed tables of the jointer must be paralleled to the cutter-head and to each other.

The tables of your jointer are adjusted in the factory. Since table parallelism adjustment is a complex task so it is recommended to make sure if your table really needs to be adjusted before you start adjusting.

To check the table parallelism, disconnect the power to the jointer and remove the cutter head guard. Now, loosen the out-feed table lock, jam nuts and positive stop bolts (at the back of the jointer). Remove screws in the 4 eccentric bushings located under the out-feed table and loosen the set-screws. Take a straight edge and place it on the out feed table so that it hangs over the cutter head. Turn the eccentric bushings and lower the out-feed table until the straight edge sits flat on the out-feed table and just touches the cutter head. Tighten the loosen screws. See Figure 10

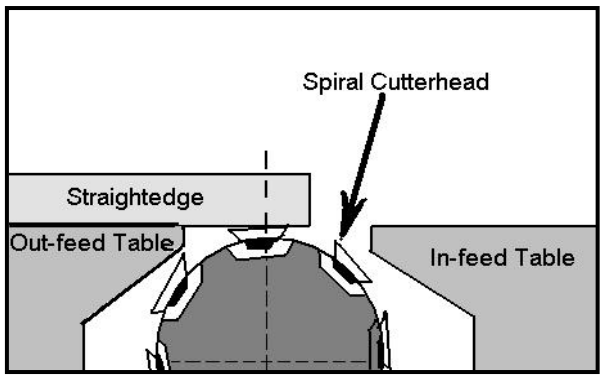


Figure 10: Adjusting out-feed table with the cutter-head

Now, place the straightedge halfway across the in-feed table and halfway over the out-feed table to adjust the in-feed table with the out-feed table. See Figure 11

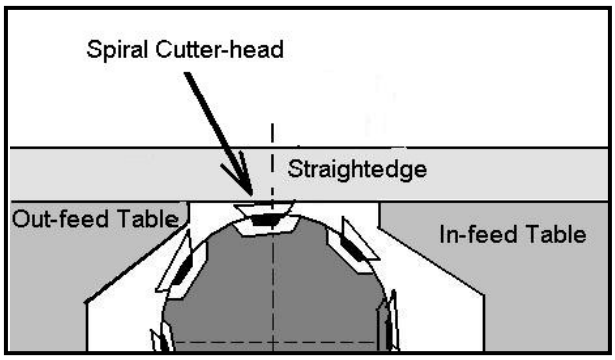


Figure 11: In-feed and Out-feed table Parallelism

Remove the screws in the 4 eccentric bushings under the in-feed table and loosen the screws underneath those set screws. Now make in-feed table parallel to the out-feed table by turning the eccentric bushings under the in-feed table. Once both tables are parallel, tighten the set screws.

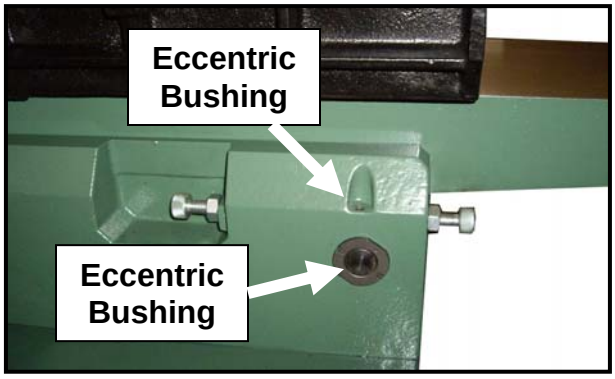


Figure12: Eccentric bushings and set-screws location

Operations & Adjustments

Setting the Out-feed Table Height

The height of the out-feed table must be equal to the height of the cutter-head knives.

To adjust the out-feed table height, first of all disconnect the jointer from power source. Remove the cutter-head guard and fence and loosen the out-feed table lock, the jam nuts and positive stop bolts located at the front and at the back of the machine.

Now place a straightedge on the out-feed table so that it hangs over the cutter-head. Lower the out-feed table until the straightedge is 1/16" above the cutter-head body. See Figure-13

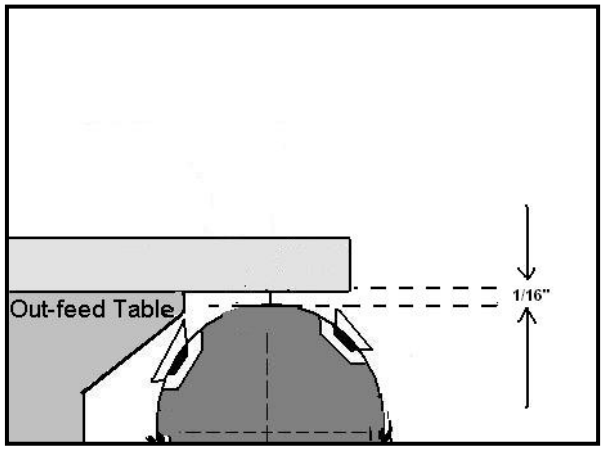


Figure13: Out-feed table Height

Now, tighten the out-feed table lock and the positive stop bolts and the jam nuts located at the back and front of the machine. Set the knife height to the new out-feed table height.

Setting the In-feed Table Height

The positive stop bolts located at the back of the machine allows you to adjust the height of the in-feed table.

The recommended setting for the minimum depth of cut is 1/32" and the maximum depth of cut is 1/8" for most of the operations.

IMPORTANT
Do not exceed 1/8"Do not exceed 1/8" cut per pass on the machine or kick-back and serious injury may occur.

There are two positive stop bolts and each bolt controls the top and bottom range of table movement. The jam nut is to lock the bolts in place so that they do not move during the operation. See Figure-14

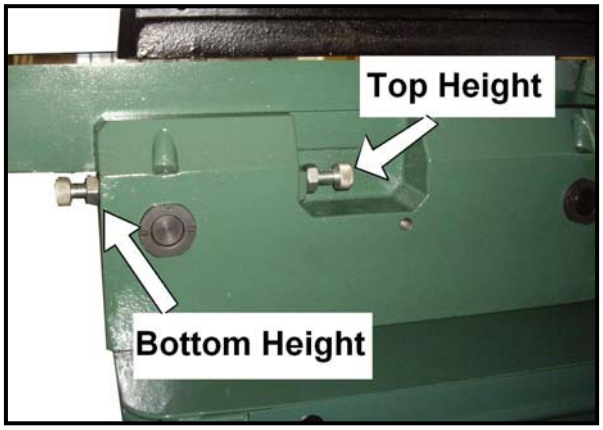
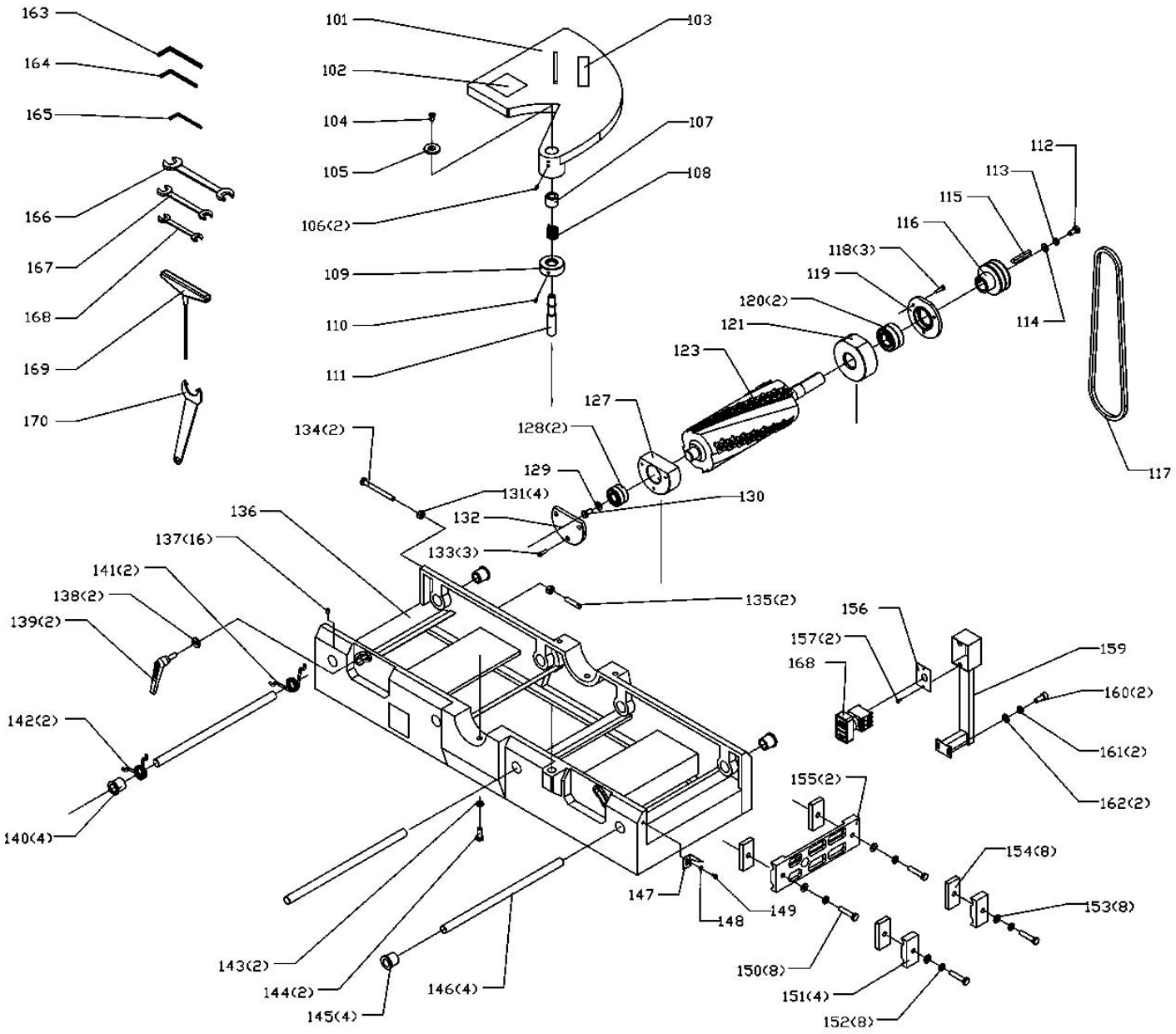


Figure-14 Table positive bolts

CT202-12” Jointer Base
Parts Breakdown

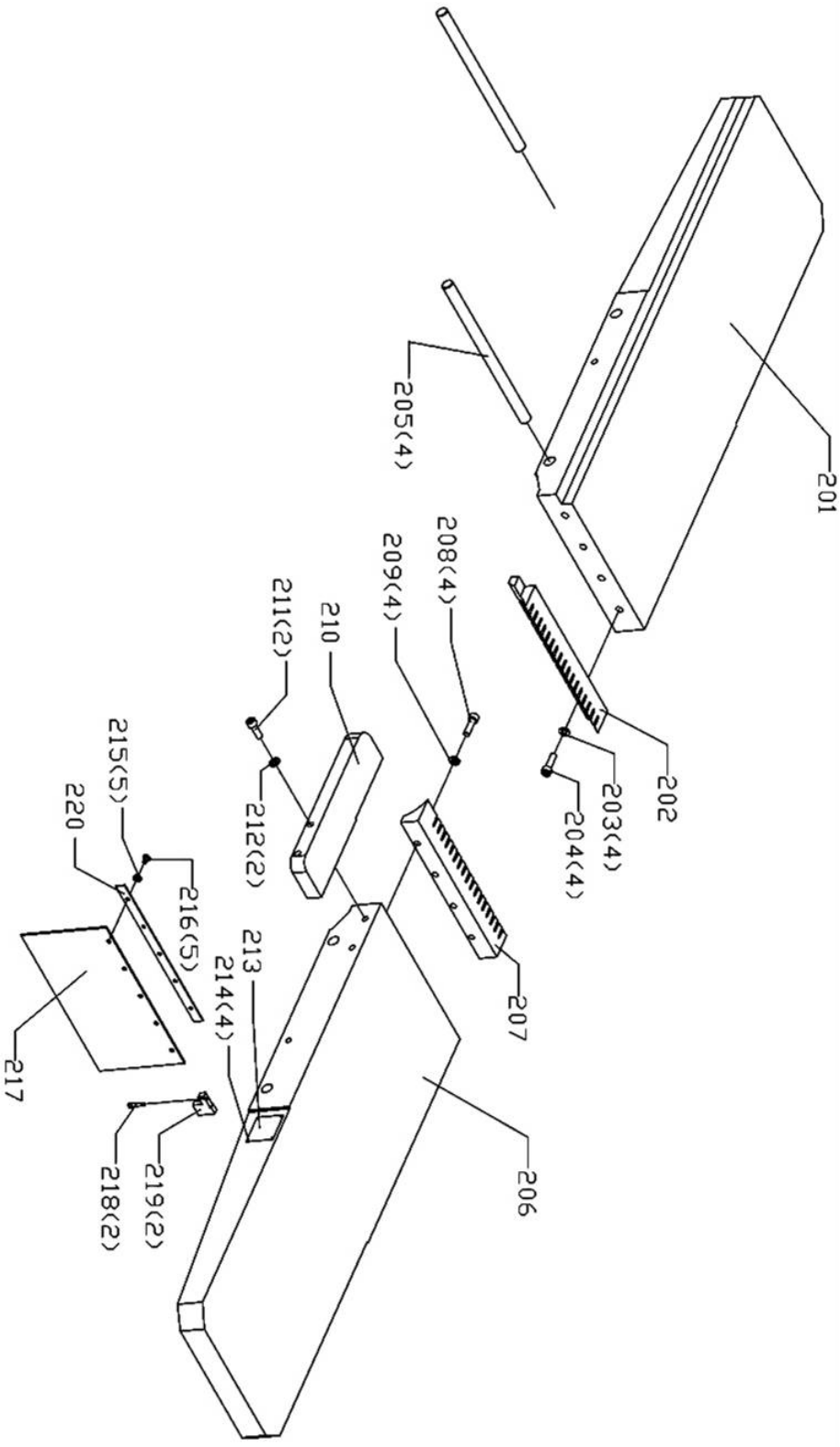


CT202-12” Jointer
Base Parts List

REF #	PART#	DESCRIPTION
101	DJ30-101	GUARD
102	DJ30-102	WARNING LABEL
103	DJ30-103	WARNING LABEL
104	GB2673	M8X16 FLAT HD SCR
105	DJ30-105	SPECIAL WASHER
106	GB80	M6X12 HEX SOC SET SCR
107	DJ30-107	ADAPTOR
108	DJ30-110	SPRING
109	DJ30-108	SHAFT COLLAR
110	GB80	M6X12 HEX SOC SET SCR
111	DJ30-109	SHAFT
112	DJ30-111A	SCR.(LEFT THREAD)
113	GB859	10MM LOCK WASHER
114	DJ30-111	WASHER
115	GB1096	C8X60 KEY
116	DJ30-114	PULLEY
117		A56” V-BELT
118	GB70	M6X20 HEX SOC HD SCR
119	DJ30-116	RH BEARING COVER
120		6206Z BEARING
121	DJ30-118	RH BEARING SUPPORT
123		SPIRAL CUTTERHEAD
127	DJ30-124	LH BEARING SUPPORT
128		6204Z BEARING
129	GB96	8MM FLAT WASHER
130	DJ30-126A	SCR.(LEFT THREAD)
131	GB6170	M10 HEX NUT
132	DJ30-127	LH BEARING COVER
133	GB70	M6X20 HEX SOCK HD SCR
134	GB5783	M10X150 HEX HD SCR
135	GB80	M10X60 HEX SOC SET SCR
136	DJ30-137	BASE
137	GB80	M6X12 HEX SOC SET SCR
138	97	FLAT WASHER

REF #	PART#	DESCRIPTION
139	DJ30-131	LOCK HANDLE
140	DJ30-136	ECCENTRIC BUSHING
141	DJ30-218	SPRING
142	DJ30-219	SPRING
143	GB859	10MM LOCK WASHER
144	GB5783	M10X25 HEX HD SCR
145		SHAFT SLEEVE
146	DJ30-135	SHAFT
147		POINTER
148	GB97	5MM FLAT WASHER
149	GB818	M5X10 CROSS PAN HD SCR
150	GB5783	M10X50 HEX HD SCR
151		SPECIAL COLLAR
152	GB859	10MM LOCK WASHER
153	GB97	10MM FLAT WASHER
154		CLAMP
155		CLAMP PLATE
156		SWITCH PLATE
157		ST4.2X8 TAPPING SCREW
158		SWITCH
159		SWITCH BRACKET
160	GB70	M10X25 CAP SCREW
161	GB859	10MM SPRING WASHER
162	GB97	10MM WASHER
163		10MM HEX.KEY(10MM)
164		8MM HEX.KEY(8MM)
165		3MM HEX.KEY(3MM)
166		OPEN END WRENCH(17-19MM)
167		OPEN END WRENCH(12-14MM)
168		OPEN END WRENCH(10-12MM)
169		LONG T-HEX.KEY(4MM)
170		SPECIAL ADJUSTING WRENCH

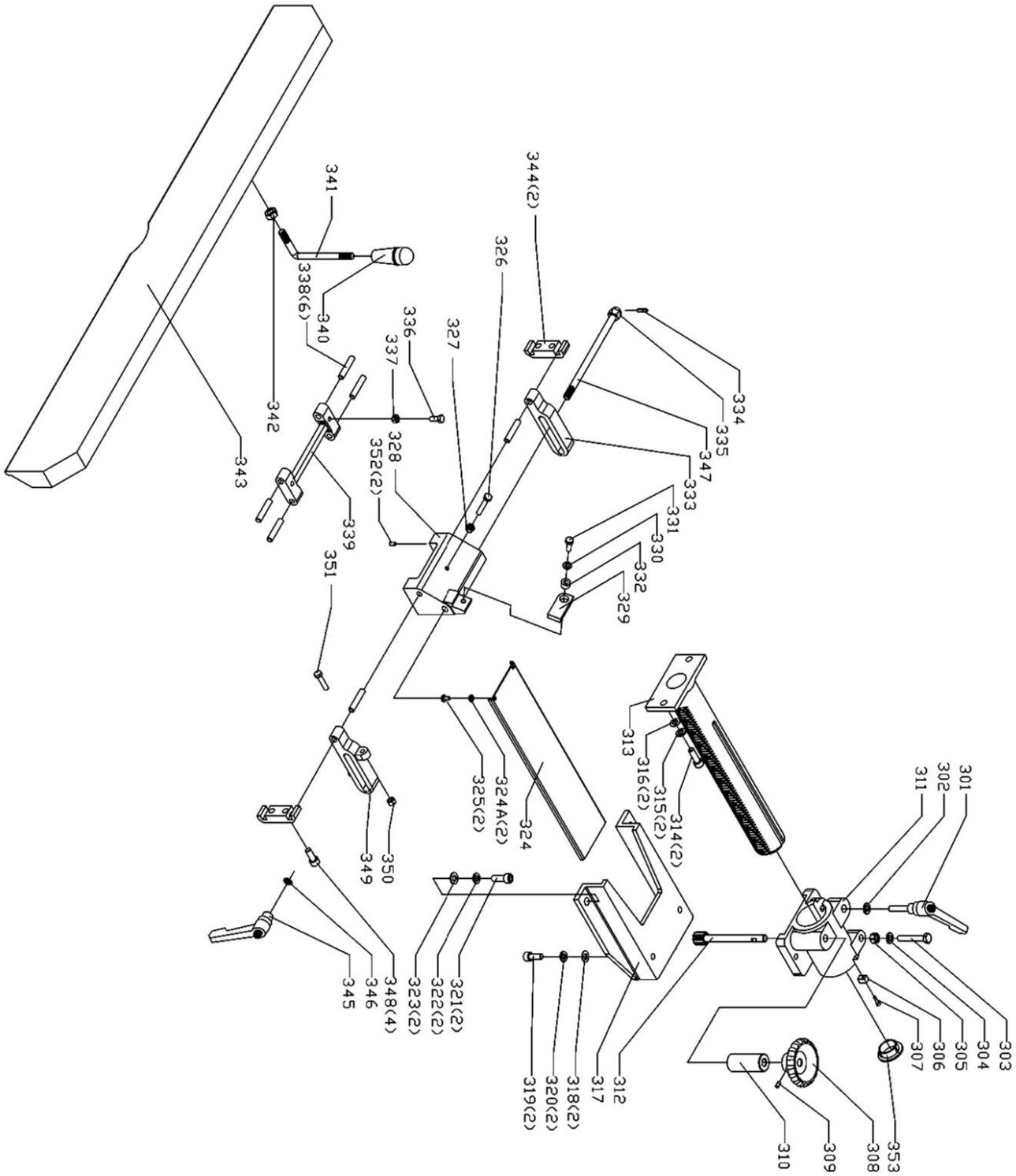
CT202-12” Jointer
Table Parts Breakdown



CT202-12” Jointer
Table Parts List

REF #	PART#	DESCRIPTION
201	DJ30-201	OUTFEED TABLE
202	DJ30-202	TABLE LIP
203	GB859	10MM LOCK WASHER
204	GB70	M10X35 HEX SOC HD SCR
205	DJ30-205	SHAFT
206	DJ30-206	INFEED TABLE
207	DJ30-207	TABLE LIP
208	GB70	M10X35 HEX SOC HD SCR
209	GB859	10MM LOCK WASHER
210	DJ30-210	RABBET LEDGE
211	GB70	M10X30 HEX SOC HD SCR
212	GB859	10MM LOCK WASHER
213	DJ30-212	DEPTH LABEL
214	GB827	2X4MM RIVET
215	GB97	6MM FLAT WASHER
216	GB	M6X10 CHEESE HD SCR
217	DJ30-215	DUST DEFLECTOR
218	GB70	M5X25 HEX SOC HD SCR
219	DJ30-217	BLOCK
220	DJ30-220	PLATE

CT202-12” Jointer
Fence Parts Breakdown

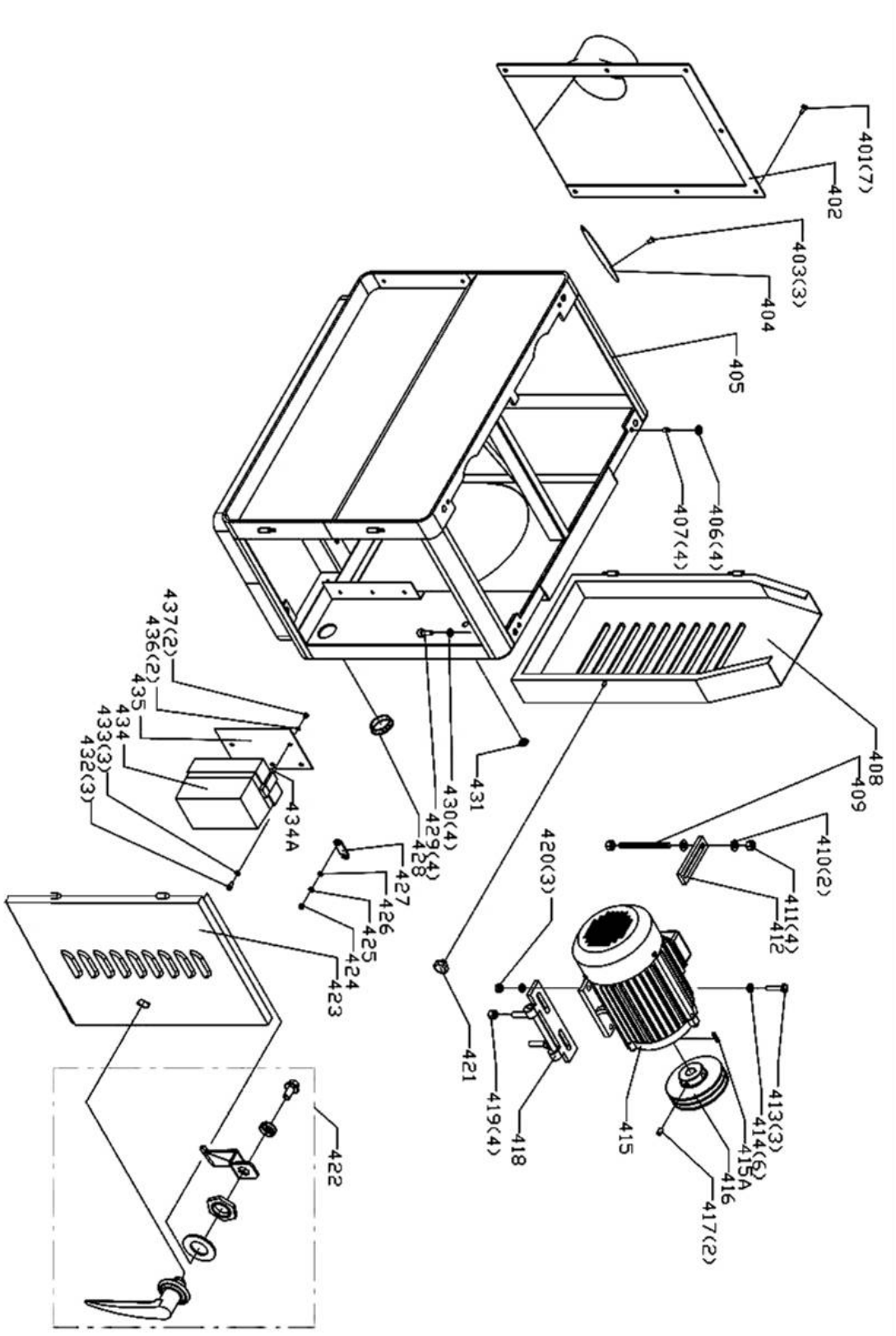


CT202-12” Jointer
Fence Parts List

301	DJ30-301	LOCK HANDLE
302	DJ30-302	FLAT WASHER
303	GB5783	M10X60 HEX HD SCR
304	DJ30-304	FLAT WASHER
305	GB6170	M10 HEX NUT
306	DJ30-305	GUID BLOCK
307	GB70	M4X15 HEX SOC HD SCR
308	DJ30-307	HAND WHEEL
309	GB80	M6X12 HEX SOC SET SCR
310	DJ30-309	ADAPTER
311	DJ30-310	BRACKET
312	DJ30-311	GEAR SHAFT
313	DJ30-312	GEAR COLUMN
314	GB70	M10X30 HEX SOC HD SCR
315	GB859	10MM LOCK WASHER
316	DJ30-315	FLAT WASHER
317	DJ30-316	FENCE SUPPORT
318	DJ30-317	FLAT WASHER
319	GB70	M10X25 HEX SOC HD SCR
320	GB859	10MM LOCK WASHER
321	GB70	M12X30 HEX SOC HD SCR
322	GB859	12MM LOCK WASHER
323	DJ30-322	FLAT WASHER
324	DJ30-323	GUARD
324 A	GB859	6MM LOCK WASHER
325	GB	M6X12 HEX SOC PAN SCR

326	GB5783	M8X55 HEX HD SCR
327	GB6170	M8 HEX NUT
328	DJ30-327	FENCE BRACKET
329	DI30-327A	BLOCK
330	DJ30-327B	FLAT WASHER
331	GB5783	M8X25 HEX HD SCR
332	DJ30-327D	SLEEVE
333	DJ30-328	LEFT BRACKET
334	GB879	5X20 SPRING PIN
335	GB923	M12 HEX NUT
336	GB5783	M8X20 HEX HD SCR
337	GB6170	M8 HEX NUT
338	DJ30-333	PIN
339	DJ30-334	SUPPORT
340	DJ30-335	KNOB
341	DJ30-336	HANDLE ROD
342	GB6170	M12 HEX NUT
343	DJ30-338	FENCE
344	DJ30-339	REAR CLAMP
345	DJ30-340	HANDLE
346	DJ30-341	FLAT WASHER
347	DJ30-342	SHAFT
348	GB70	M10X25 HEX SOX HD SCR
349	DJ30-344	RIGHT BRACKET
350	GB6170	M8 HEX NUT
351	GB5783	M8X35 HEX HD SCR
352	GB80	M6X12 HEX SOC HD SCR
353	DJ30-346	COLUMN COVER

CT202-12” Jointer
Cabinet Parts Breakdown



CT202-12” Jointer
Cabinet Parts List

401	GB	M6X18 HEX SOC PAN HD SCR
402		DUST HOOD
403		M6X10 DUST CHUTE COVER
404		HEX SOC PAN HD SCR
405		CABINET
406		RUBBER WASHER
407	GB818	M8X15 HEX SOC HD SCR
408		PULLEY COVER
409		ROD
410		FLAT WASHER
411	GB6170	M12 HEX NUT
412		PLATE
413	GB5783	M10X45 HEX HD SCR
414		FLAT WASHER
415		MOTOR
415A	GB1096	C5X45 KEY
416		MOTOR PULLEY
417	GB80	M10X16 HEX SOC HD SET SCR
418		MOTOR BRACKET
419	GB6170	M12 HEX NUT
420	GB6170	M10 HEX NUT
421		CROSS PAN HD SCR
422		HANDLE ASSY
423		ACCESS DOOR
424	GB923	M6 SPECIAL NUT
425		LATCH
426		FLAT WASHER
427		HEX NUT
428		SLEEVE
429	GB70	M10X25 HEX SOC HD SCR
430	GB93	10MM LOCK WASHER
431		SMALL STRAIN RELIEF
432	GB70	M6X10 CROSS PAN HD SCR
433	GB97	6MM FLAT WASHER
434		MAGNETIC SWITCH
434A	GB818	CROSS PAN HD SCR M5X20
435		SWITCH PLATE
436	GB97	5MM FLAT WASHER
437	GB6170	M5 HEX NUT

WARRANTY

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 **two years** 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 or call 1-800-461-BUSY. 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
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used 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.