

LAGUNA®

JX|12 Sheartec:II Jointer Manual



Owner's Manual
MJ12X88P-0130

Thank you for investing in a jointer by Laguna Tools. This jointer is one of a family of unique machines proudly offered by Laguna Tools. Every Laguna machine is engineered for years of dependable service. Please feel free to contact Laguna Tools if you have a question or suggestion. We appreciate working with you and your choice of a Laguna Tools machine for your shop.

Regards,
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President & Founder Laguna Tools

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This manual applies to the JX12 jointers. Enter the model number and serial number below for quick reference when ordering accessories, supplies or parts. NOTE: The model and serial number plate can be found on back or side of the jointer.

Model: _____

Serial: _____

Purchase Date:_____

Safety











Read and understand all warnings and operation instructions before using any tool or equipment. Always follow basic safety precautions to reduce the risk of personal injury. Improper operation, maintenance or modification of tools or equipment could result in serious injury and property damage. There are certain applications for which tools and equipment are designed. This product should NOT be modified and/or used for any application other than for which it was designed.

It is important for you to read and understand this manual. The information it contains relates to protecting your safety and preventing problems.

Safety Call-outs

⚠ DANGER!
A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY. SOMETIMES DISPLAYED AS ⚠ DANGER!
⚠ WARNING
A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY. SOMETIMES DISPLAYED AS ⚠ WARNING!
⚠ CAUTION!
A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, MAY RESULT IN MINOR OR MODERATE INJURY. SOMETIMES DISPLAYED AS ⚠ CAUTION!
NOTICE!
A HELPFUL TIP FROM OUR TECHNICAL STAFF. SOMETIMES DISPLAYED AS NOTICE!

Safety Symbols

- | | | | |
|---|--|---|--------------------------|
|  | Disconnect from power before proceeding. |  | Wear ear protection. |
|  | Be aware of possible laceration danger. |  | Wear Eye Protection. |
|  | Be aware of possible crushing danger. |  | Wear a full face shield. |
|  | Be aware of possible crushing danger. |  | Wear lung protection. |
|  | Electrical Hazard. |  | Requires X People |

⚠ PROP 65 WARNING

SOME DUST CREATED BY POWER SANDING, SAWING, GRINDING, DRILLING, AND OTHER CONSTRUCTION ACTIVITIES CONTAINS CHEMICALS KNOWN TO THE STATE OF CALIFORNIA TO CAUSE CANCER, BIRTH DEFECTS OR OTHER REPRODUCTIVE HARM. SOME EXAMPLES OF THESE CHEMICALS ARE:

- LEAD FROM LEAD-BASED PAINTS.
- CRYSTALLINE SILICA FROM BRICKS, CEMENT AND OTHER MASONRY PRODUCTS.
- ARSENIC AND CHROMIUM FROM CHEMICALLY-TREATED LUMBER.

YOUR RISK FROM THESE EXPOSURES VARIES, DEPENDING ON HOW OFTEN YOU DO THIS TYPE OF WORK. TO REDUCE YOUR EXPOSURE TO THESE CHEMICALS: WORK IN A WELL VENTILATED AREA, AND WORK WITH APPROVED SAFETY EQUIPMENT, SUCH AS THOSE DUST MASKS THAT ARE SPECIALLY DESIGNED TO FILTER OUT MICROSCOPIC PARTICLES.

⚠ APPLICATIONS WARNING

- THIS MACHINE WAS DESIGNED FOR CERTAIN APPLICATIONS ONLY. WE STRONGLY RECOMMEND 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 THE MANUFACTURER TO DETERMINE IF IT CAN OR SHOULD BE PERFORMED ON THE PRODUCT.
- IF YOU HAVE ANY QUESTIONS RELATIVE TO ITS APPLICATION DO NOT USE THE PRODUCT UNTIL YOU HAVE CONTACTED THE MANUFACTURER AND WE HAVE ADVISED YOU.

⚠ WARNING!

Machine & Workshop Safety Instructions

Read and understand all warnings and operating instructions before using this equipment. Failure to follow all instructions listed below, may result in electric shock, fire, and/or serious personal injury or property damage. Machinery 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, feather boards, 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.

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended start-up or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications, modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine OFF and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or wrongly adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

WARNING!

Jointer Specific Safety Instructions

LIKE ALL MACHINES, THERE IS DANGER ASSOCIATED WITH THE MACHINE. INJURY IS FREQUENTLY CAUSED BY LACK OF KNOWLEDGE OR FAMILIARITY. USE THIS MACHINE WITH RESPECT. IF NORMAL SAFETY PRECAUTIONS ARE OVERLOOKED OR IGNORED, SERIOUS PERSONAL INJURY MAY OCCUR.

1. KICKBACK

"KICKBACK" IS WHEN THE WORK PIECE IS THROWN OFF THE JOINTER TABLE BY THE CUTTER HEAD. ALWAYS USE PUSH BLOCKS AND SAFETY GLASSES TO REDUCE THE LIKELIHOOD OF INJURY FROM "KICKBACK". THE "KICKBACK ZONE", IS THE PATH DIRECTLY THROUGH THE END OF THE IN FEED TABLE. NEVER STAND OR ALLOW OTHERS TO STAND IN THIS AREA DURING OPERATION. IF KICK BACK OCCURS, SEVERE INJURY MAY RESULT.

2. CUTTER HEAD ALIGNMENT

TO REDUCE THE POSSIBILITY OF KICKBACK, KEEP THE TOP EDGE OF THE OUT FEED TABLE ALIGNED WITH THE CUTTER HEAD INSERT AT TOP DEAD CENTER (TDC).

3. PUSH BLOCKS

THE CUTTER HEADS ARE EXTREMELY DANGEROUS AND YOU MUST NEVER PASS YOUR HANDS OVER THE CUTTER HEAD. ALWAYS USE PUSH BLOCKS WHENEVER SURFACE PLANNING. HAND SAFETY. IT IS GOOD PRACTICE TO MOVE THE HANDS IN AN ALTERNATE MOTION FROM BACK TO FRONT AS THE WORK CONTINUES THROUGH THE CUT. NEVER PASS YOUR HANDS DIRECTLY OVER THE CUTTERHEAD. AS ONE HAND APPROACHES THE CUTTERHEAD REMOVE IT FROM THE STOCK IN AN ARC MOTION AND PLACE IT BACK ON THE STOCK IN A POSITION BEYOND THE CUTTERHEAD. YOUR HANDS MUST NEVER BE CLOSER THAN 3 INCHES TO THE CUTTER HEAD.

4. SUPPORTING THE WORK

ONLY MAKE CUTS IF THE WORK PIECE IS STABLE AND NEVER ATTEMPT TO CUT UNSTABLE PLANKS, OR INJURY MAY OCCUR.

5. CUTTING DEPTH

NEVER EXCEED THE MAXIMUM CUTTING DEPTH AS STATED IN THE SPECIFICATION FOR YOUR MACHINE. IT IS FAR BETTER TO TAKE SEVERAL SMALL CUTS RATHER THAN LARGE CUTS.

6. DIRECTION OF CUT

JOINTING AGAINST THE GRAIN OR JOINTING END GRAIN IS DANGEROUS AND COULD PRODUCE CHATTER OR EXCESSIVE CHIP OUT. ALWAYS JOINT WITH THE GRAIN.

7. GUARDS

GUARDS ARE DESIGNED TO REDUCE THE RISK OF INJURY. ALWAYS USE THE GUARDS. IF IT IS IMPERATIVE TO USE THE MACHINE WITHOUT THE GUARDS, [RABBETING] ALWAYS REPLACE THE GUARDS.

8. CUTTING DIRECTION

ONLY CUT FROM THE IN FEED TABLE TO THE OUT FEED TABLE, AND ALWAYS COMPLETE THE CUT. DO NOT STOP THE WOOD PROGRESS UNTIL THE JOB HAS CLEARED THE CUTTER HEAD COMPLETELY. ONLY CUT WITH THE GRAIN OR AT A SLIGHT ANGLE TO THE GRAIN.

9. STOCK

YOUR SAFETY WILL BE GREATLY ENHANCED IF YOU ONLY USE GOOD LUMBER. ONLY WORK WITH LUMBER AFTER YOU HAVE INSPECTED IT COMPLETELY. STAPLES, NAILS LOOSE KNOTS AND ANY OTHER METAL IN THE PLANK WILL DAMAGE YOUR CUTTER HEAD AND COULD CAUSE INJURY AND OR FIRE. IF YOU HAVE ANY QUESTION ABOUT A PIECE OF LUMBER, DO NOT USE IT.

SAVE THESE INSTRUCTIONS.

Refer to them often and use them to instruct others.

Electrical Safety

⚠ WARNING!

- RUNNING ON A DIFFERENT VOLTAGE THAN STATED BELOW WILL DAMAGE THE MACHINE. NEVER RUN THE MACHINE IN WET OR DAMP CONDITIONS.
- ELECTROCUTION, FIRE, SHOCK, OR EQUIPMENT DAMAGE MAY OCCUR IF MACHINE IS NOT PROPERLY GROUNDED AND CONNECTED TO POWER SUPPLY.

Motor Specifications

The standard main motor is typically a 5 HP, single phase, but always confirm on the motor/machine label. It does NOT include a cord or plug. Have a qualified electrician install a cord and plug or hard wire into disconnect following all applicable codes. Confirm your motor electrical configuration before connecting power! It is listed on the serial plate on the back of the machine and on the motor label. Before connecting the machine to the power source, make sure the starter and/or switches are in the "OFF" position.

Power Supply

A separate electrical circuit should be used for each machine. This circuit should not be less than the wiring listed below and should be protected with an appropriate circuit breaker based on the total running and start-up amperage's (listed below). If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and matching receptacle which will accept the machine's plug.

MJ12X88P-0130

VOLTAGE	220V
---------	------

PHASE	1PH
-------	-----

HERTZ	60Hz
-------	------

FULL LOAD AMPERAGE	23 Amp
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⚠ WARNING! Below are RECOMMENDATIONS to be used for this machine based on the above information. Variables that may affect this are:

- Actual voltage supplied to the machine
- Electrical code that must be met in your local province.

An electrician will verify that all the demands are met to properly wire the machine. If you have absolutely any doubt when wiring this machine - please consult with a qualified electrician.

PLUG/RECEPTACLE	Not Included
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WIRING (Gauge)	See Jacket Printing
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CIRCUIT BREAKER	30 Amp (min.)
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If this information is different than what is stated on the Motor Specification Plate - omit this information. It is possible that the documentation is outdated to a machine change - such as a different motor. Always check the motor plate prior to any wiring. If any doubts, please consult a certified electrician.

Know when to use a time delay fuse! AKA Slow blow fuse. Generally, if the motor uses a start capacitor, a time delay fuse is required. This type of fuse will not trip with the initial amperage needed to start the machine, which is typically double that of the running amperage. Most woodworking machines should use this type of fuse.

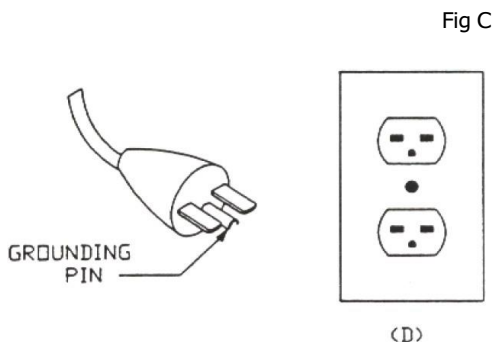
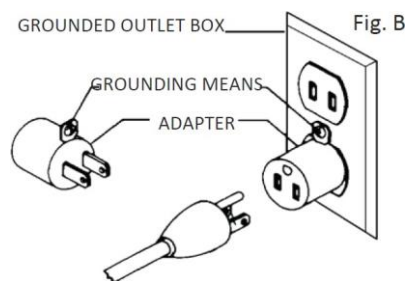
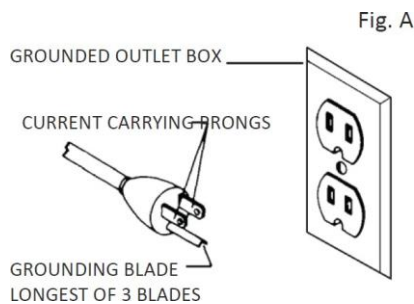
Note: most commercial circuit breakers are slow-blow or "time-delay" by default, to compensate for start-up.

Grounding Methods

⚠ DANGER!

THIS MACHINE MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK. IN ALL CASES, MAKE CERTAIN THAT THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE, HAVE A QUALIFIED ELECTRICIAN CHECK THE RECEPTACLE.

Grounding Methods Provided by CSA Group. (A) Receptacle with nominal rating less than 150 volts. (B) 150 volt receptacle without grounding pin fitted with adapter. (C) 150-250 volt receptacle.



1. All grounded, cord-connected machines:

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 a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is 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 plugs and 3 pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

2. Grounded, cord-connected machines intended for use on a supply circuit having a nominal rating less than 150 volts:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. A. The tool has a grounding plug that looks like the plug illustrated in Fig A. A temporary adapter, which looks like the adapter illustrated in Fig B may be used to connect this plug to a 2 pole receptacle as shown in Fig B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. This adapter is not permitted in Canada. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

3. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150 – 250 volts, inclusive:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig C. The tool has a grounding plug that looks like the plug illustrated in Fig C. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after reconnection, the tool should comply with all local codes and ordinances.

Extension Cords

⚠ WARNING! 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 matching receptacle which will accept the machine’s plug. When using an extension cord, be sure to use one heavy enough to carry the current of the machine. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

MINIMUM GAUGE EXTENSION CORD 120V
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES

Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	120	up to 25	18 AWG
0-6	120	25-50	16 AWG
0-6	120	50-100	16 AWG
0-6	120	100-150	14 AWG
6-10	120	up to 25	18 AWG
6-10	120	25-50	16 AWG
6-10	120	50-100	14 AWG
6-10	120	100-150	12 AWG
10-12	120	up to 25	16 AWG
10-12	120	25-50	16 AWG
10-12	120	50-100	14 AWG
10-12	120	100-150	12 AWG
12-16	120	up to 25	14 AWG
12-16	120	25-50	12 AWG
12-16	120	GREATER THAN 50 FEET NOT RECOMMENDED	

MINIMUM GAUGE EXTENSION CORD 240V
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES

Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	240	up to 50	18 AWG
0-6	240	50-100	16 AWG
0-6	240	100-200	16 AWG
0-6	240	200-300	14 AWG
6-10	240	up to 50	18 AWG
6-10	240	50-100	16 AWG
6-10	240	100-200	14 AWG
6-10	240	200-300	12 AWG
10-12	240	up to 50	16 AWG
10-12	240	50-100	16 AWG
10-12	240	100-200	14 AWG
10-12	240	200-300	12 AWG
12-16	240	up to 50	14 AWG
12-16	240	50-100	12 AWG
12-16	240	GREATER THAN 100 FEET NOT RECOMMENDED	

Specifications

JX|12 Sheartec:II Jointer

JX|12 SHEARTEC: II
MJ12X88P-0130

VOLT HP MOTOR AMP. RECOM. SIZE BRKR.	230V 5HP 1PHASE 60HZ/23Amp. 30 Amp. (min.)
CSA	YES
BED SIZE	12 X 88"
INFEED TABLE PULL-OUT EXTENSION	10"
RABBETTING CAPACITY	3/4"
FENCE SIZE	5-3/4 47" ALU FENCE
FENCE TILT	+45/90 DEGREE
MAX. DEPTH OF CUT	1/8"
TABLE HEIGHT FROM FLOOR	32"
SAFETY BAR SHUT-OFF	YES
WHEELS BUILT-IN	OPTIONAL
BRACKET TO MOUNT LIGHT	YES
110V OUTLET FOR LIGHT	YES
BRACKET TO MOUNT FEEDER	YES
DUST PORT DIAMETER	6"
CUTTERHEAD INSERT #	66 X 4-SIDED CARBIDE, 6 ROW
CUTTERHEAD RPM	5500
CUTTERHEAD DIAMETER	3-7/8"
BED ADJUSTMENT	PARALLELOGRAM
DIMENSIONS SET UP APPROX.	92" X 40"
DIMENSIONS SHIPPING	91" X 32" X 45"
NET/SHIP WEIGHT	LBS. 876/1043
# OF BOXES	1 BOX

Machine Overview

JX|12 Sheartec:II Jointer

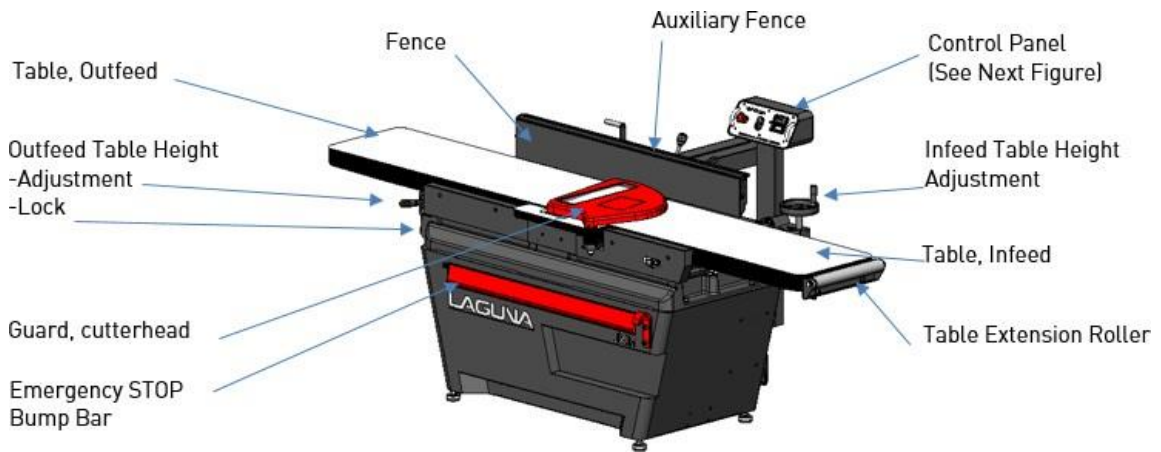


Figure 1: Main Components



Figure 2: Control Panel

- A. Emergency Stop (E-STOP); stops all functions of machine, however, power continues to machine. NOTICE! To reset E-STOP, rotate switch clockwise until the button "pops" out. NOTICE! E-STOP bump bar (red) located on front of frame.
- B. ON/OFF Switch; Starts and Stops rotation of cutterhead. NOTICE! Will not work if the E-STOP is engaged.

Setup

Setup Overview (MUST READ)

When setting up your Jointer, please take a moment to read this overview prior to starting.

The machine comes mostly assembled. You may have to assemble the leveling feet (if casters are not installed) and calibrate the thickness scale.

After Setup, there may be a few adjustment to be made. All of these adjustments are done prior to shipping the machine, however if additional adjustments are required, please follow the adjustment guides.

⚠ CAUTION! If you have any doubt about the described procedure, seek professional assistance. Do not attempt any procedure that you feel is unsafe, or that you do not have the physical capability of achieving.

Placement & Unboxing

Your Machine will likely be delivered by a third-party delivery service. Before unpacking your new machine, first inspect the packaging, the invoice, and the shipping documents supplied by the driver. When unpacking your machine, separate all enclosed items from the packing materials and inspect them for damages. Ensure that there is no visible damage to either the packaging or the machine BEFORE the driver leaves. Save all packaging materials until you are satisfied with the machine and/or have resolved any issues concerning any missing or damaged items.

NOTICE!

- ALL SHIPPING DAMAGE MUST BE NOTED UPON DELIVERY AND SIGNED BY THE OWNER AND THE DELIVERY DRIVER. IF YOU FIND ANY DAMAGED ITEMS IN YOUR PACKAGE, YOU MUST CONTACT LAGUNA TOOLS TO FILE A COMPLAINT. IN ORDER TO RETURN DAMAGED GOODS UNDER THE LIMITED WARRANTY TO LAGUNA TOOLS, INC., YOU MUST HAVE THE ORIGINAL PACKAGING. ALL CLAIMS OF LOSS OR DAMAGED GOODS MUST BE REPORTED TO LAGUNA TOOLS WITHIN 24 HOURS OF DELIVERY. PLEASE CONTACT THE LAGUNA TOOLS, INC. CUSTOMER SERVICE DEPARTMENT TO MAKE CLAIMS FOR ANY DAMAGED ITEMS/PARTS.
- IT IS PROBABLE THAT YOU WILL FIND SAWDUST WITHIN YOUR MACHINE. THIS IS BECAUSE THE MACHINE HAS BEEN TESTED PRIOR TO SHIPMENT FROM THE FACTORY AND OR LAGUNA TOOLS. WE TEST MACHINES PRIOR TO SHIPPING TO CUSTOMERS, BUT MOVEMENT CAN TAKE PLACE DURING TRANSPORTATION. SOME ADJUSTMENTS MAY HAVE TO BE UNDERTAKEN BY THE CUSTOMER. THESE ADJUSTMENTS ARE COVERED IN THE VARIOUS SECTIONS OF THIS MANUAL.

Placement

Before you remove your machine from the packaging, select the area where you will use your machine. There are no hard and fast rules for its location, but below are a few guidelines:

1. There should be sufficient area at the front of the machine to allow you to work on it comfortably.
2. There should be sufficient area at the back of the machine to allow access for adjustments and maintenance to be conducted.
3. Adequate lighting. The better the lighting the more accurately and safely you will be able to work.
4. Solid floor. You should select a solid flat floor, preferably one made of concrete or something similar.
5. Locate it close to a power source and dust collection.

6. Allow an area for the storage of blanks, finished products and tools.

⚠ WARNING!

- THE MACHINE WEIGHS 1043 LBS (473KG) (THE JX16 WEIGHS 1254 LBS (568KG)). ENSURE THAT YOU HAVE ENOUGH PEOPLE TO DO THE JOB SAFELY.
 - IF YOU HAVE ANY DOUBT ABOUT THE DESCRIBED PROCEDURE, SEEK PROFESSIONAL ASSISTANCE. DO NOT ATTEMPT ANY PROCEDURE THAT YOU FEEL IS UNSAFE, OR THAT YOU DO NOT HAVE THE PHYSICAL CAPABILITY OF ACHIEVING.

Unboxing

This step requires a forklift. The machine is heavy, be careful when lifting and handling it! Failure to comply may cause serious injury and/or damage to the machine and/or property! Use a forklift to remove the machine from pallet and place on floor.

NOTICE! Another option to remove the jointer from the pallet is to attach the included hooks to frame of machine at each of the four corners (Fig. 3). The hooks and bolts are included in the hardware kit. The machine can then be lifted with a harness and forklift. Remove and save hooks for later movement scenarios.



FIGURE 3: COVER REMOVED FROM CRATE



FIGURE 4: CRATE REMOVED

The Jointer comes packed in a single crate. Before attempting to assemble this machine, follow these directions:

1. Remove the top covering the machine, typically screwed (or nailed) in place.
2. Remove the two ends of the crate.
3. Remove the top cross pieces and the sides of the crate.
4. Cut the banding (use gloves & eye protection) being careful not to be in the path of the banding when cut.
5. Remove any packing material such as cardboard or foam.
6. Using the information below, ensure that all parts are present and in good condition.

Alternate Method

Another option to remove the jointer from the pallet is to attach the two hooks to frame of machine at each of the top (2 diagonal) corners of the base (Fig. 5). The hooks and bolts are included in the hardware.

The holes are drilled in the machine with nuts welded to the back of the base. The machine can then be lifted with a harness and forklift. Remove and save hooks for later movement scenarios.

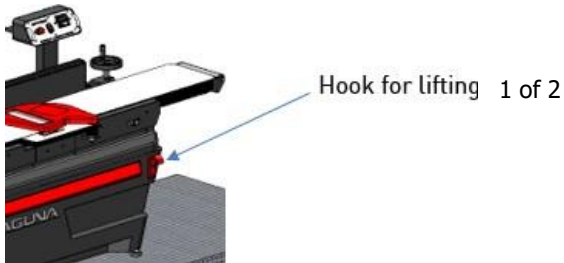


FIGURE 5: HOOK FOR LIFTING (1 OF 2)

Inventory List

The following depicts items shipped with your machine. Before assembling, ensure that you have received all parts shown below. Machine parts should arrive sealed in plastic bags. Remove parts from plastic bags before laying them out to inventory them.

Inventory

- 2 Push Blocks
- 1 3mm Hex Wrench
- 1 6mm Hex Wrench
- 1 8/10mm Wrench
- 1 11/13mm Wrench

Tools/items Required: Assembly & Adjustment

- T-25 Torx Wrench
- 3mm Hex Wrench
- 6mm Hex Wrench
- 8mm Hex Wrench (not included)
- 8/10mm Wrench
- 11/13mm Wrench

⚠ DANGER!

FOR YOUR OWN SAFETY, DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL THE MACHINE IS COMPLETELY ASSEMBLED! PLEASE ALSO MAKE SURE THAT YOU READ AND UNDERSTAND THE ENTIRE MANUAL.

Assembly

Machine Preparation and Setup:

1. The (typical) machine is supplied with four casters, installed, which can be used to level the machine. Level the machine by rotating the dial on the caster, Fig. 6. *NOTE: When casters are factory installed, you can skip ahead to #3, "cleaning".*

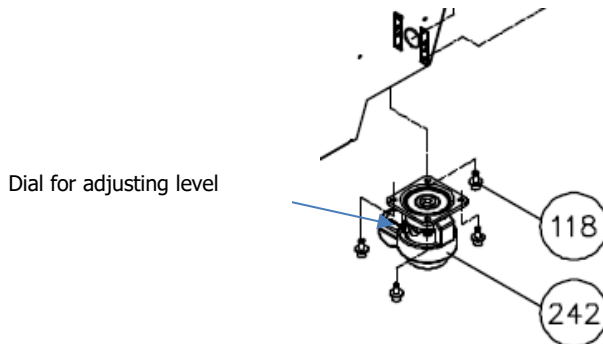


Figure 6: Typical Caster

2. Leveling feet and universal casters are an available option. If your model does not include leveling feet or casters, installation instructions are below. Depending on the model they may require installation. Raise and block one side of jointer. Install two leveling feet into threaded nut welded into corner of base. Lower jointer and repeat for other side. Adjust as needed to prevent "wobble" of machine.



FIGURE 7: LEVELING FEET

3. Clean all rust protected surfaces with a commercial de-greaser. DO NOT use acetone, gasoline, lacquer thinner or any type of cleaner that could damage paint. Coat cleaned surfaces with WD-40® or Teflon based lube.

⚠ CAUTION!

BE CAREFUL WHEN WORKING ON OR NEAR CUTTERHEAD AS THE KNIVES ARE VERY SHARP!

Installing Caster Set JK0008 (optional, depending on model)

Installing optional universal caster set. See Universal Caster Part List for # references:

1. Raise jointer with leveling feet for attaching caster set.
2. Assemble swivel caster into swivel caster bracket (angled bracket) by placing bolt #5 through bracket and caster and securing with lock nut #4. Then place bolt #6 down through bracket into caster mount.
3. Attach swivel caster to infeed center bottom of frame with four bolts #1, washers #2 and nuts #3. Tighten all four bolts.
4. Assemble caster (wheel) #.2 to bracket #.1 using bolt #.3 and nut #.4. Repeat this process for second caster, if not pre-assembled.
5. Attach caster assembly #9 to outfeed side of frame using two bolts #1, two washers #2 and two nuts #3. Repeat process for both casters. Tighten all four bolts.



FIGURE 8: SWIVEL CASTER ASSEMBLY

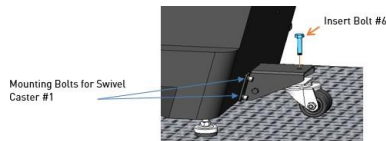


FIGURE 9: ATTACHING SWIVEL CASTER



FIGURE 10: ATTACHING CASTERS

Parts List for Universal Caster Set

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
	JK0008	UNIVERSAL CASTER SET		1
1	000104-106	CAP SCREW	M8-1.25X20	12
2	006305-100	SPRING WASHER	8.2-13.7	8
3	006001-049	FLAT WASHER	8.5-16X2.0	8
4	008306-100	LOCK NUT	M8-1.25P(13BX9H)	1
5	000003-312	HEX NUT	M8-1.25X100	1
6	000004-104	HEX SCREW	M10-1.5X35	1
8	920306-001	SWIVEL WHEEL		1
9	970526-001	WHEEL		2
.1	174877-904	BRACKET		1
.2	250400-000	WHEEL		1
.3	003005-106	HEX SCREW	3/8"-16X2-1/2"	1
.4	009102-200	LOCK NUT	3/8"-16 (14.2BX11.5H)	1
10	174876-904	BRACKET, SWIVEL CASTER		1
11	174931-904	UNIVERSAL BRACKET		1

Power Supply Circuit Requirements

The power source circuit for your machine must be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.

Circuit Size (5HP, 220V, 1-Phase)30 AMP minimum

⚠ DANGER!

IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE, HAVE A QUALIFIED ELECTRICIAN CHECK THE RECEPTACLE.

Motor Specifications

The standard main motor is typically a 5 HP, single phase, depending on jointer model. It does NOT include a cord or plug. Have a qualified electrician install a cord and plug or hard wire into a disconnect following all applicable codes. Confirm your motor electrical configuration before connecting power! It is

⚠ WARNING

WHEN COMPLETED, THE MACHINE MUST CONFORM TO THE NATIONAL ELECTRIC CODE AND ALL LOCAL CODES AND ORDINANCES.

listed on the serial plate on the back of the machine and on the motor label. Before connecting the machine to the power source, make sure the starter and/or switches are in the "OFF" position.

Connecting Power (See also wiring diagram)

1. Plug power cord into appropriate dedicated circuit or turn ON disconnect, if so installed.

⚠ WARNING

DISCONNECT POWER SUPPLY TO JOINTER BEFORE CONTINUING! ONLY CONNECT POWER WHEN REQUIRED.

Calibrating the Thickness Scale



FIGURE 11: THICKNESS SCALE

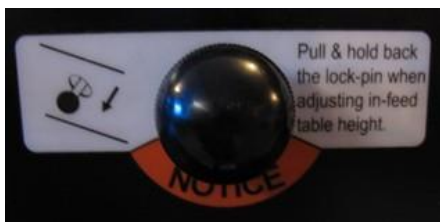


FIGURE 12: Lock Pin

1. Rotate the Infeed Table Height Adjustment Handle (Fig. 11) while pulling out on the "Lock Pin" (Fig. 12) to approximately 1/64". NOTE: The Lock Pin must be pulled out during adjustments to prevent machine damage.
2. Make a test cut half-way on sample material. Measure The depth of cut/stock removal on the sample. If not 1/64", adjust pointer to actual cut dimension by loosening the two Phillips screws (Fig. 11) and adjusting red pointer and tightening the two screws.

Adjusting the Fence

The fence can be adjusted to use all or a portion of the cutterhead. To adjust, loosen the Fence Slide Lock (Fig. 13) and slide the fence to the desired position.

NOTICE! Secure both locks when fence is in position.

⚠ DANGER!

DO NOT OPERATE JOINTER WITHOUT LOCKING THE FENCE!



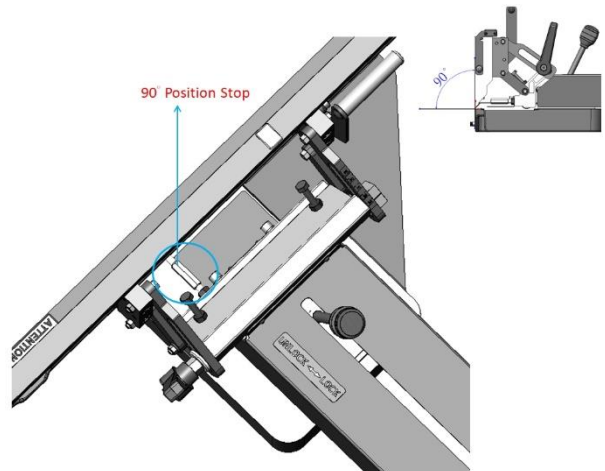
FIGURE 13: FENCE COMPONENTS



FIGURE 14 & 14A: Fence Stops

To adjust the fence perpendicular or angled to the bed, loosen the Fence Slide Lock (Fig. 13) and adjust the fence to the desired position.

The 90-degree position has an included reference STOP (Fig. 14). To adjust, flip the stop into position, loosen the lock nut and rotate the adjusting screw until the fence is at 90 degrees to the table. Tighten the lock nut and flip the stop back if making other angled adjustments. To check the 90 degree setting, place a square on the outfeed table and against the fence.



Auxiliary Fence

The auxiliary fence is used for better control and push-pad clearance, when jointing low material or when material is better controlled by a low fence (Fig. 15 & 16). To operate this fence, with power OFF, slightly lift from top of main fence to unlock and rotate until it is securely against the table and side of the main fence. When not in use, rotate to top of fence and lower on top of fence to lock in place.



FIGURE 15: AUXILIARY FENCE LOWERED



FIGURE 16: AUXILIARY FENCE IN-USE

Calibrating the DRO (Digital Read Out)

1. Remove the battery cover of the DRO and install 2 AAA batteries.

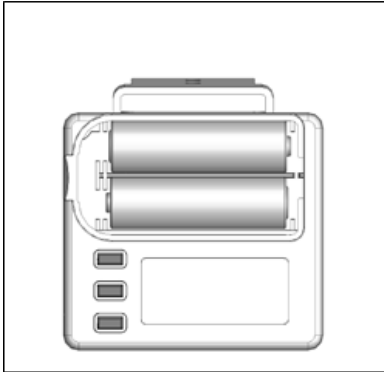


FIGURE 17: DRO BATTERIES

2. Turn jointer OFF, with the cutter head not rotating, and power disconnected.
3. Use the Infeed Table Height Adjustment handle (Fig. 11) to adjust the table to approximately 1/32" lower than outfeed table, while simultaneously pulling on the lock pin (Fig. 12).
4. Connect power to the jointer and turn ON and joint a face of a test board, using Push Pad's. NOTICE! Drawing pencil marks across the width of the top of the calibrating board in several locations can make it easier to determine when the entire surface has been processed.
5. Plane the opposite face of the test board until fully planed and uniform.
6. Joint the end 5-6" of the test board and pull board back off of cutterhead using Push Pad's. Turn power OFF.
7. Using a caliper measure the thickness of the full thickness and the thickness of the 5-6" partial pass. Note the difference between the two thicknesses and adjust DRO setting to this setting. NOTICE! See DRO diagrams for more information on choosing inch or mm and programming.

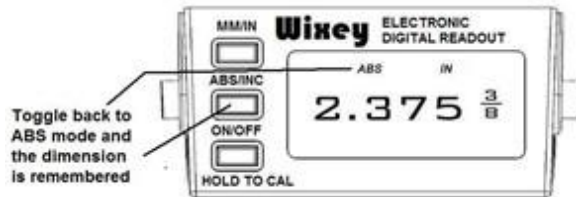
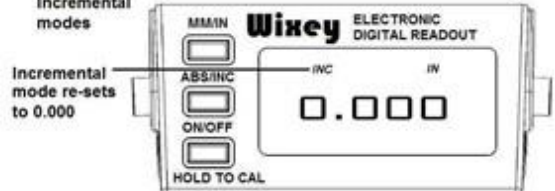
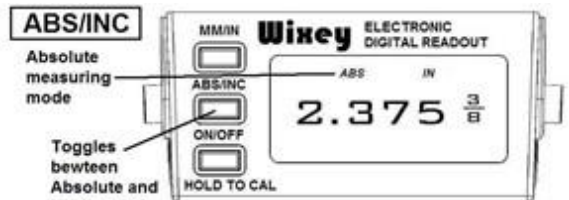
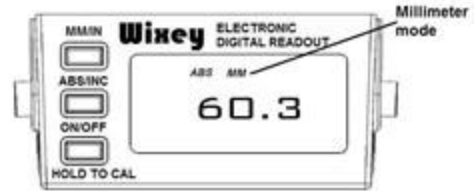
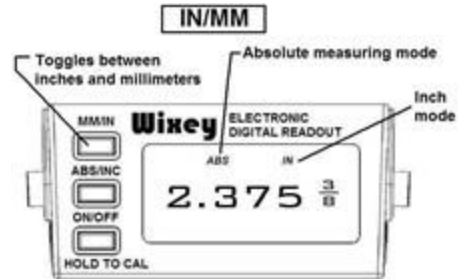
ON/OFF and CALIBRATION



- PUSH MOMENTARILY TO TURN OFF AND ON
- HOLD FOR 3-5 SECONDS TO ENTER CALIBRATION MODE. THE "ABS IN" FLASHES
- TO CHANGE THE DISPLAY VALUE FROM 0.000 USE THE + OR - BUTTONS.



- A SHORT PRESS INCREASES ONE DIGIT. HOLDING THE BUTTON COUNTS FAST.
- PRESS THE ON/OFF BUTTON MOMENTARILY TO SET THE CALIBRATION VALUE. THE "ABS IN" WILL STOP FLASHING



Figures 18-24 DRO

Operation

⚠ CAUTION!

PLACE THE JOINTER ON A SECURE AND STABLE SURFACE FOR OPERATION. CLAMP OR BOLT THE JOINTER INTO POSITION.

1. Establish the proper depth of cut. 1/64" is the recommended maximum cut for the best finish with least chance of kick-back when jointing.



FIGURE 25: INFEED TABLE EXTENSION

NOTICE! The infeed table extension (Fig. 25) can be extended for support of long material. Loosen the two locking studs under the bed, pull extension out and tighten the two locking studs.

2. Start dust collection.
3. Start jointer.
4. Feed stock into cutterhead, while maintaining contact of the stock on the bed and against the fence. Maintain control and support of stock as the stock opens the guard and contacts the cutterhead. Maintain a good, firm stance while pushing stock across the jointer. Move hands along stock when feeding to maintain control of stock. Lift hands from stock as they come near cutterhead and reposition them on outfeed side. DO NOT allow hands to come within three inches of the cutterhead.

⚠ WARNING

USE PUSH BLOCKS FOR FACE JOINTING! DO NOT PLACE YOUR HANDS NEAR CUTTERHEAD OR GUARD!

5. Reposition yourself to the outfeed side of jointer and control and support stock until it is past cutterhead and the guard has fully closed.

Edge and Face jointing:



FIGURE 26: EDGE JOINTING



FIGURE 27: FACE JOINTING/PLANING

Beveling

The fence can be adjusted up to 45 degrees angled toward the infeed/outfeed tables (bed) or away from the infeed/outfeed tables (bed) for beveling. There is less chance of stock slippage when the fence is angled down, toward the tables (Fig. 28). Angling the fence toward the tables is also a safer method to bevel, when the application allows.

The 90-degree position includes two reference STOPS (Fig. 29). To adjust the stops, loosen the lock nut and rotate the stud, using a hex wrench, until the fence is at 90 degrees to the bed. Lock the nuts on the studs to maintain the position of the two dedicated STOPS. NOTE: Adjust both STOPS at the same time to the same setting. Lock the fence into position with the bevel lock (Fig. 29).



FIGURE 28: BEVELING

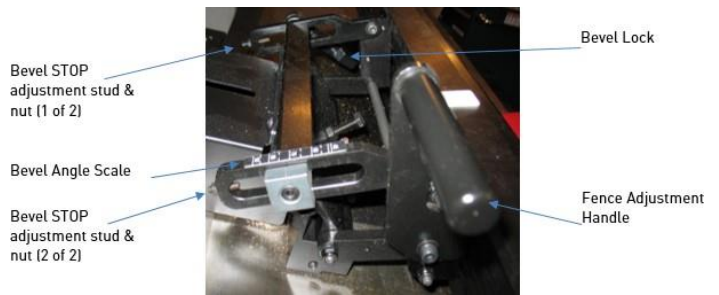


Figure 29: 90-Degree STOPS

Rabbeting

Rabbeting is a groove along the edge of stock. The stock can be on edge or face, depending on the dimensions required for the rabbet.

Position fence for width of rabbet cut. This is the distance from the outmost edge of the outermost knife insert to the fence.

Set depth of cut with the Infeed Table Adjustment Handle. Do not set deeper than 1/64" per pass. Several passes may be required to reach the desired depth. Adjust the infeed table for each pass (1/64" max.) until the rabbet is completed.



FIGURE 30: RABBETING



FIGURE 31: REMOVING GUARD FOR RABBETING

NOTICE!

(SPRING LOADED GUARD (RED) MAY NEED TO BE REMOVED FOR RABBETING WIDE STOCK.) LOOSEN HEX BOLT AND LIFT GUARD WITH PIN FROM MACHINE (FIG. 31).

⚠ DANGER!

REPLACE GUARD AS SOON AS MACHINE STOPS AFTER RABBET IS CUT!
NEVER ALLOW HANDS NEAR CUTTERHEAD WHEN THE GUARD IS REMOVED!

Helpful Tips

- IF FACE OF MATERIAL IS CUPPED, JOINT WITH THE CUP "DOWN" (BOTH EDGES OF STOCK RESTING ON TABLE) TO PREVENT ROCKING AND MAINTAIN STABILITY AS THE STOCK IS PROCESSED.
- AFTER JOINTING ONE FACE, USE A PLANER ON THE BACK OF MATERIAL TO MAINTAIN CONSISTENT THICKNESS.
- IF MATERIAL IS SEVERELY CUPPED, IT MAY MAKE SENSE TO RIP THE MATERIAL INTO NARROWER WIDTH TO JOINT AND THEN GLUE BACK TOGETHER TO MAINTAIN GREATEST POTENTIAL MATERIAL THICKNESS.
- BE ESPECIALLY CAREFUL WHEN JOINTING TWISTED MATERIAL AS IT CAN ROCK ON BED AS BEING PROCESSED.
- USE PUSH-BLOCKS WHEN FACE JOINTING.
- USE PUSH-BLOCKS FOR SHORT AND THIN MATERIAL.
- JOINT WITH THE GRAIN TO REDUCE TEAR-OUT.
- MAKE SHALLOW CUTS ON TWISTED MATERIAL.

Maintenance

General

Keep your machine clean. At the end of each day, clean the machine. Wood contains moisture, and if sawdust or wood chips are not removed they will cause rust.

In general, we recommend that you only use a Teflon-based lubricant on the jointer. Regular oil attracts dust and dirt. Teflon lubricant tends to dry and has less of a tendency to accumulate dirt and saw dust. Periodically check that all nuts and bolts are tight.

Daily checks

1. Clean the machine and lubricate unpainted surfaces with a Teflon lubricant. Wipe off any excess and buff with a dry polishing cloth. This will reduce the likelihood of rust forming and reduce the friction on the tables as the wood is machined.
2. Check knife inserts for nicks and sharpness.
3. Generally inspect the machine for damage and loose or worn parts.

Weekly checks

1. Clean the cutter head. Do not touch knife inserts!
2. Check knife inserts for nicks and sharpness.
3. Inspect the machine for damage and loose or worn parts.
4. Check the dust extraction for blockages and any large pieces that could cause blockages.

Monthly checks

1. Check the drive belt for wear, splits and cuts.
2. Clean the motor compartment and the motor to ensure that the motor cooling fins work efficiently.
3. Inspect the machine for damage and loose or worn parts. NOTICE! It is recommended that you use a Teflon based lubricant.

Routine Inspections

It is a good idea to routinely inspect any quality woodworking tool in order to keep it in optimum condition. This includes inspecting all hardware for tightness, ensuring the filter is clean, and cleaning debris and grime from any surfaces and moving parts. In addition, make sure to:

- Clean out-feed rollers and table with a non-flammable solvent to remove pitch, gum and other unwanted build-up.
- Periodically clean the inside of the machine for dust control.
- Keep pulleys and belts free from dirt, dust, oil and grease.
- Replace worn belts as needed.
- Replace worn knives or sharpen.

Knife rotation/replacement

⚠ CAUTION!

KNIFE INSERTS ARE DANGEROUSLY SHARP. USE EXTREME CAUTION WHEN INSPECTING, REMOVING, OR REPLACING KNIFE INSERTS.

⚠ WARNING

- TURN JOINTER OFF AND DISCONNECT POWER BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS!
- MAKE SURE ALL KNIFE INSERT SCREWS ARE TIGHTENED SECURELY. LOOSE INSERTS CAN BE PROPELLED AT HIGH SPEED FROM A ROTATING CUTTERHEAD, CAUSING INJURY.
TORQUE EACH SCREW TO 52-60 IN/LBS.



Figure 32: Sheartec:II Cutterhead



Figure 33: Holding Cutterhead

1. The knife inserts on the jointer are four-sided. When dull (or nicked), remove each knife, rotate it 90° for a fresh edge, and re-install it (52-60 in/lb.). No further adjustment is necessary. Use a Torx wrench (T25) to remove the knife insert screw. Use a second Torx wrench to hold the cutterhead (from rotating) in position (in another screw). **⚠ WARNING! DO NOT USE YOUR HAND TO HOLD THE CUTTERHEAD!** See Fig. 33.
2. It is advisable to rotate all inserts at the same time to maintain consistent cutting. However, if one or more knife inserts develops a nick, rotate only those inserts that are affected. Each knife insert has an etched reference mark so you can keep track of the rotation. Torque each screw to 52-60 in/lbs.
3. **IMPORTANT:** When removing or rotating inserts, clean sawdust from the screw, the insert, and the cutterhead platform. Dust accumulation between these elements can prevent the insert from seating properly and may affect the quality of the cut.
4. Before installing each screw, lightly coat the screw threads with machine oil and wipe off any excess. Securely tighten each screw which holds the knife inserts before operating the jointer!

Outfeed Table Adjustment:

⚠ WARNING

- TURN OFF AND DISCONNECT POWER BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS!

The outfeed table is adjusted at the factory to be level with (or within .006" of) the Top Dead Center (TDC) of the knife inserts.

To adjust the Outfeed Table, loosen the Adjustment Lock (Fig. 34) for the Outfeed Table with an 8mm hex wrench (not included). Adjust the height of the Outfeed Table with the Adjustment Handle for the Outfeed Table (Fig. 34). Tighten the Adjustment Lock.

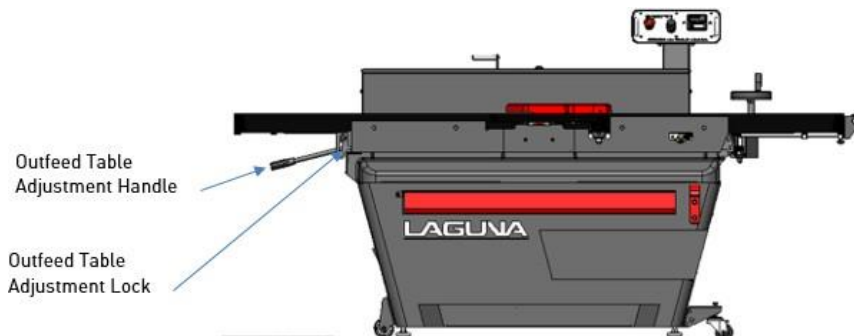


FIGURE 34: OUTFEED TABLE ADJUSTMENT

Poly Drive Belt Adjustment:

⚠ WARNING

- TURN OFF AND DISCONNECT POWER BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS!

The poly-drive-belt (Fig. 35, C) tension is set at the factory. Proper tension is achieved when the belt can be depressed approximately 1/4" mid-way between the pulleys.

If adjustment is needed remove the four screws holding the back panel to the stand of the jointer.

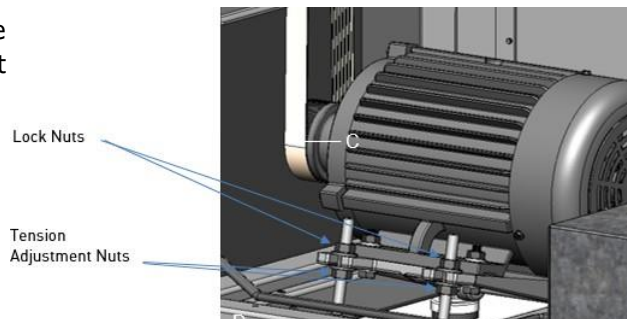


FIGURE 35: POLY-V-BELT TENSION

The motor is attached with four bolts on a pivot plate. Loosen the two tension adjustment nuts on the underside of the pivot plate until proper tension is achieved (Fig. 35).

When the drive belt is properly tensioned, tighten the top two nuts on the tension adjustment studs bolts and replace the back cover.

Adjusting Tables Coplanar:

⚠ WARNING

- TURN OFF AND DISCONNECT POWER BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS!

The alignment of the infeed and outfeed tables has been precisely set at the factory. However, misalignment can be incurred from shipping movement. Follow these steps to check and adjust.

OVERVIEW

These instructions are intended to assist when alignment of the infeed, outfeed or both tables require adjustment. It is **important** to note that the outfeed table must be parallel and flush with the cutterhead before adjusting the infeed table. Always make this adjustment first if needed.

If the infeed table cannot be adjusted parallel to the outfeed table (e.g., not enough adjustment within the eccentric adjustment collars), then the outfeed table will require adjustment to bring into the same plane as the **infeed table**, but the outfeed table must **ALWAYS remain parallel** and **flush** with the cutterhead. Always make this adjustment first if needed.

Coplanarity Test:

STEP 1: DISCONNECT THE MACHINE FROM POWER!

STEP 2: Remove the cutterhead guard by loosening the set screw(s) and removing guard. (See GUARD INSTALLATION).

STEP 3: Slide the fence assembly back.

STEP 4: Place a straight edge across the tables in positions as shown in **FIG. 36**. In each position, the straight edge should rest flat and fit flush with both infeed and outfeed tables (not on an insert knife). If it does not, follow the steps in Outfeed Table and Infeed Table adjustments.

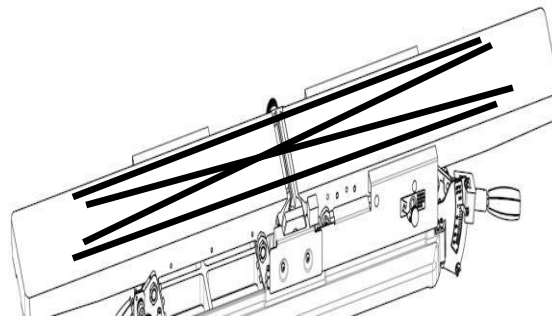


Figure 36: Checking tables for alignment

Outfeed Table:

Paralleling to cutterhead and establishing proper height to cutterhead

STEP 1: While the machine is disconnected from power source, cutterhead guard is removed, and fence is away or removed; remove rear access panel of stand, to obtain access of drive belt.

STEP 2: Place a straight edge on the outfeed table halfway over the cutterhead as shown in **FIG. 37**. Rotate drive belt, if necessary, to bring an insert knife to top-dead-center for referencing to straight edge.

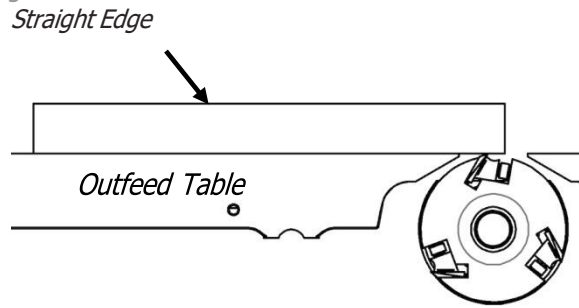


Figure 37: Checking Outfeed Table

STEP 3: Use a hex wrench (not included) to loosen Screw Lock (S.L.) to release outfeedtable adjustment lever as shown in **FIG. 38**.

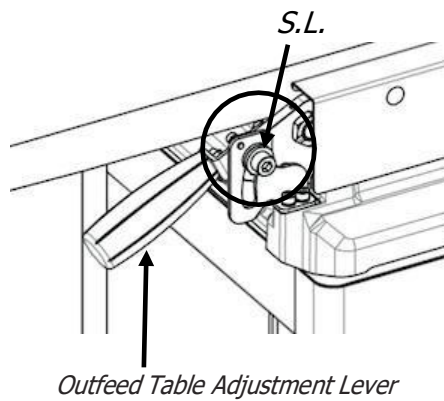


Figure 38: Screw Lock (S.L)

STEP 4: Loosen cap screw on the back (inside) of the outfeed table adjustment lever as shown in **FIG. 39**. Lower the outfeed table to adjust the straight-edge level with the top dead center of the knife inserts as in **FIG. 37**.

NOTE: When the half-moon shape of the CAP screw indicator touches the plate, it results in the lowest position of the outfeed table and is a reference to the top-dead-center of the inserts.

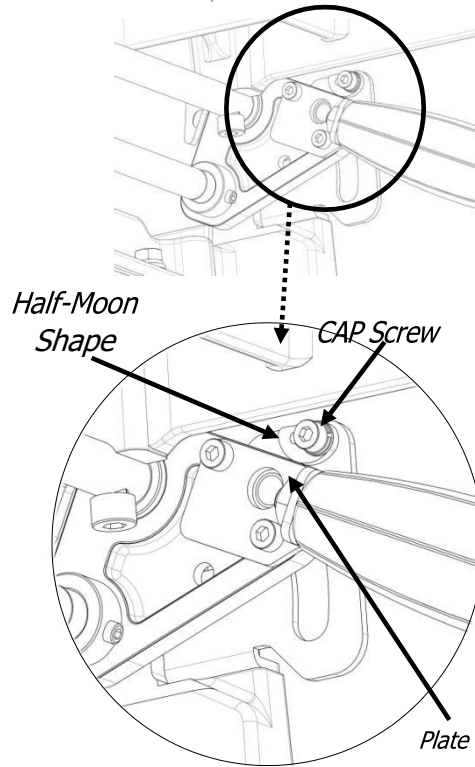


FIG. 39: Back View of Outfeed Table Adjustment

STEP 5: Place a straight edge in positions shown in FIG. 40 to make sure outfeed table is parallel with the cutterhead.

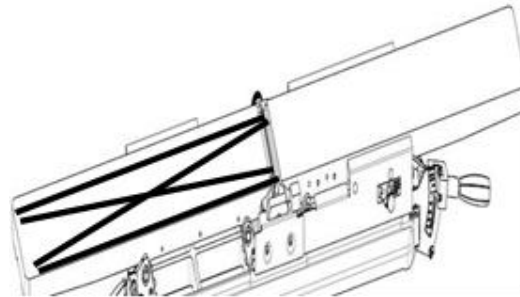


Figure 40: Checking Infeed Table

STEP 6: If the outfeed table is not parallel to the cutter head; loosen the set screws for the eccentric bushings **FIG. 52**. Rotate the eccentric bushing(s) to adjust the outfeed table parallel to the cutter head. Make sure eccentric bushings are seated and tighten set screws.

Step 7: Confirm outfeed table is flush with cutter head (insert knives at top-dead-center). Tighten lock when adjusted. If straight edge does not rest flat on outfeed table, repeat STEP 4. If it sits flat on outfeed, go to Infeed Table to check the parallelism of infeed table.

Infeed Table:

STEP 1: Before checking parallelism on infeed table, confirm the outfeed table is parallel and flush with insert tips at top-dead-center.

STEP 2: Place straight edge across infeed and outfeed tables as in **FIG. 41**. If inserts interfere with straight edge, rotate the cutterhead.

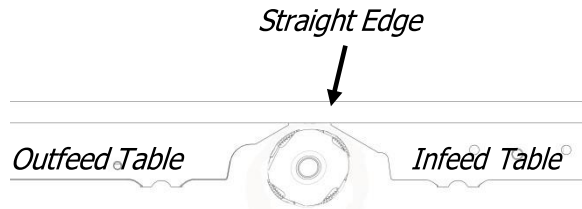


Figure 41: Straight Edge

STEP 3: Place straight edge in positions shown in **FIG. 42**.

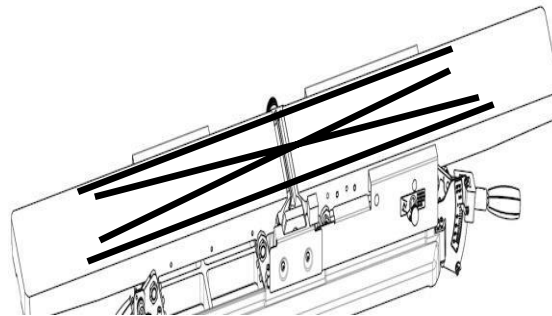


Figure 42: Checking Bed Alignment

STEP 4: If straight edge lies uniformly flat against both infeed and outfeed tables in all positions; re-install fence, blade guard and rear access panel. If it does not fit uniformly flat against both infeed tables and outfeed tables in any position, go to [Table Parallelism Adjustment](#).

STEP 5: After verifying the parallelism on the outfeed table, make sure the eccentric bushing(s) are seated snugly and tighten set screw(s) into eccentric bushing(s) **FIG. 47**.

STEP 6: Remove infeed table depth stop release knob and infeed table cover, loosen set screws and place straight edge across infeed and outfeed tables as in **FIG. 45**, and adjust eccentric bushings under infeed table as STEP 4 for outfeed table.

Table Parallelism Adjustment:

When the infeed table is not parallel with the outfeed table, it can be adjusted. **NOTE:** This adjustment needs to be done very precisely and typically does not require re-adjustment once set.

Before following the steps below, doublecheck the alignments as shown in [Infeed Table](#) to be certain that table adjustment is required.

STEP 1: Place a straight edge on outfeed table over the cutterhead and slightly touching the cutterhead body as shown in **FIG. 43**.

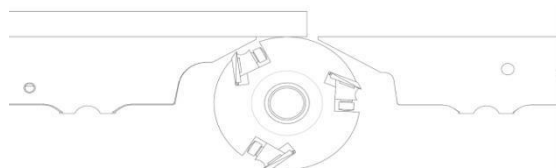


Fig.43: Straight Edge

STEP 2: Remove the plugs and loosen CAPscrews to release and remove outfeed tablecover as in **FIG. 44.**

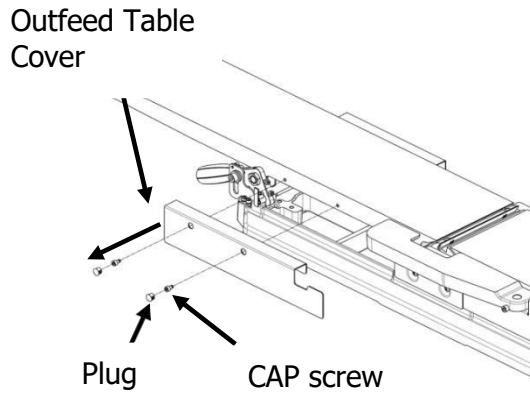


Fig. 44: Table Cover

STEP 3: Loosen set screws as shown in FIG. 45.

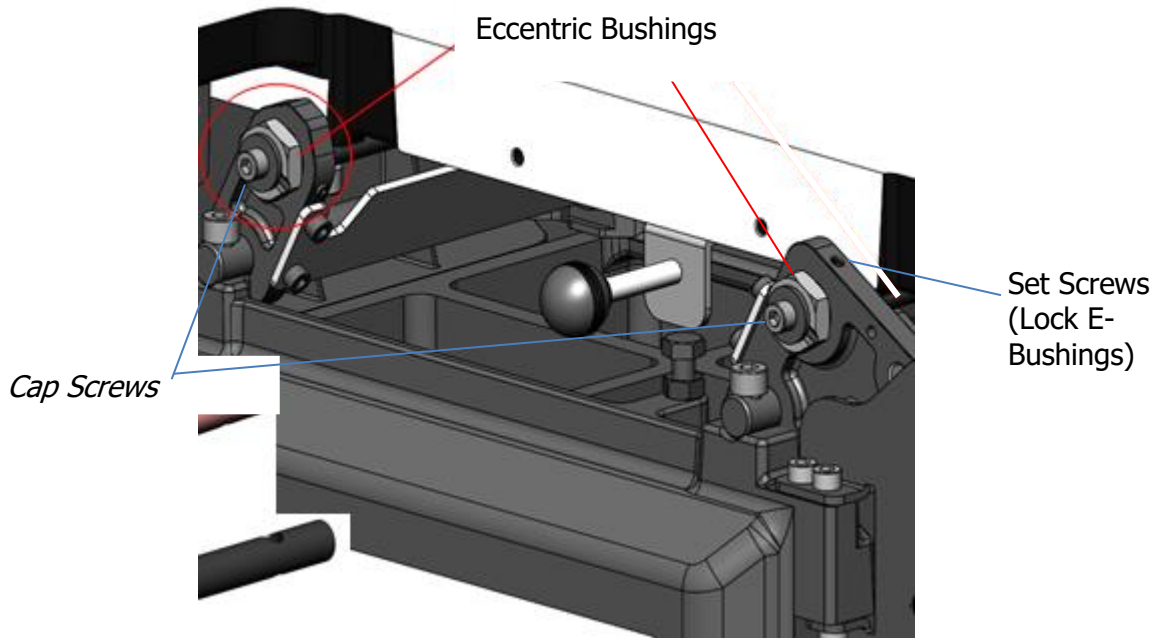


Fig 45: Eccentric Bushings, Cap Screws & Set Screws

STEP 4: Place straight edge to all the positions shown in **FIG. 46** and loosen set screw(s) adjust the eccentric bushings, as in **FIG. 45**, until straight edge slightly touches the cutterhead insert knife (at top-dead-center) at each position.

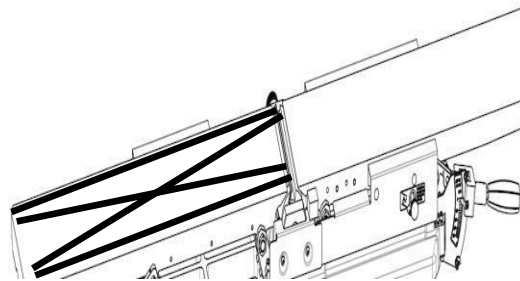


Figure 46: Checking table

STEP 5: After verifying the parallelism on the outfeed table, make sure the eccentric collars are seated snugly into its bracket, and tighten cap screws with washers and then tighten set screws into eccentric bushings (Fig. 45).

STEP 6: Remove infeed table "depth stop release knob" and infeed table cover, loosen set screws and place straight edge across infeed tables as in Fig. 47, and adjust eccentric bushings under infeed table (as in Step 4) for outfeed table.

STEP 7: Verify parallelism in each position as in Fig. 47 confirm eccentric bushings are snug and tighten cap screws and then set screws in eccentric bushings on infeed table.

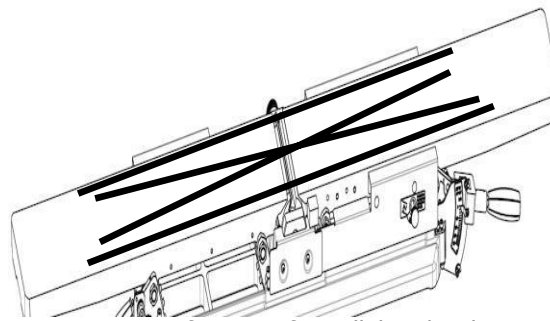


Figure 47: Verification of parallelism/coplanar

STEP 8: Tighten cap screws and set screws in eccentric brushings under infeed table.

STEP 9: Re-install table covers and infeed table depth stop release knob.

NOTE: Confirm the Eccentric Bushings are fully seated (hex collar pushed snug into bracket) and cap screws are tight, before tightening set screws. This prevents excessive play and side-to-side bed movement.

Troubleshooting

Symptom	Possible Cause	Possible Solution
MACHINE WILL NOT START	<ol style="list-style-type: none"> 1. FUSE BLOWN OR CIRCUIT BREAKER TRIPPED 2. CORD DAMAGED 3. NOT CONNECTED TO POWER SOURCE 4. CONNECTED TO WRONG VOLTAGE 5. EMERGENCY STOP BUTTON PRESSED 	<ol style="list-style-type: none"> 1. REPLACE FUSE OR RESET CIRCUIT BREAKER 2. HAVE CORD REPLACED 3. CHECK CONNECTION 4. CHECK VOLTAGE 5. ROTATE EMERGENCY STOP BUTTON CLOCKWISE UNTIL IT POPS OUT
CUTTERHEAD DOES NOT COME UP TO SPEED	<ol style="list-style-type: none"> 1. LOW CURRENT 2. MOTOR NOT WIRED FOR CORRECT VOLTAGE 	<ol style="list-style-type: none"> 1. CONTACT LOCAL ELECTRIC COMPANY 2. REFER TO MOTOR NAMEPLATE FOR CORRECT VOLTAGE
WORKPIECE DIFFICULT TO PUSH	<ol style="list-style-type: none"> 1. TOO MUCH MATERIAL BEING REMOVED IN ONE PASS 2. DULL KNIVES 	<ol style="list-style-type: none"> 1. REDUCE THE AMOUNT OF MATERIAL BEING REMOVED 2. ROTATE OR REPLACE KNIVES
SNIPE	<ol style="list-style-type: none"> 1. MATERIAL NOT SUPPORTED PROPERLY AS IT EXITS OUTFEED TABLE 2. OPERATOR PUSHING DOWN ON TRAILING END OF MATERIAL 3. OUTFEED TABLE TOO LOW 	<ol style="list-style-type: none"> 1. SUPPORT MATERIAL FOR ENTIRE CUT 2. ELIMINATE DOWNWARD PRESSURE ON TRAILING END 3. ADJUST OUTFEED TABLE LEVEL WITH CUTTERHEAD ACHIEVED
FUZZY GRAIN	<ol style="list-style-type: none"> 1. WOOD WITH A HIGH MOISTURE CONTENT 2. DULL KNIFE INSERT(S) 	<ol style="list-style-type: none"> 1. ALLOW WOOD TO DRY PROPERLY 2. ROTATE OR REPLACE 3. KNIFE INSERT(S)
LINE(S) OR RIDGES IN FINISHED SURFACE	<ol style="list-style-type: none"> 1. NICKED OR DAMAGED KNIFE INSERT(S) 	<ol style="list-style-type: none"> 1. ROTATE OR REPLACE KNIFE INSERT(S)

Dust Collection

To ensure proper operation and longest knife life it is important to maintain full air flow to your dust collection system. Make sure the filter media is clean and there are no obstructions in the ducting or hoses.

Wiring

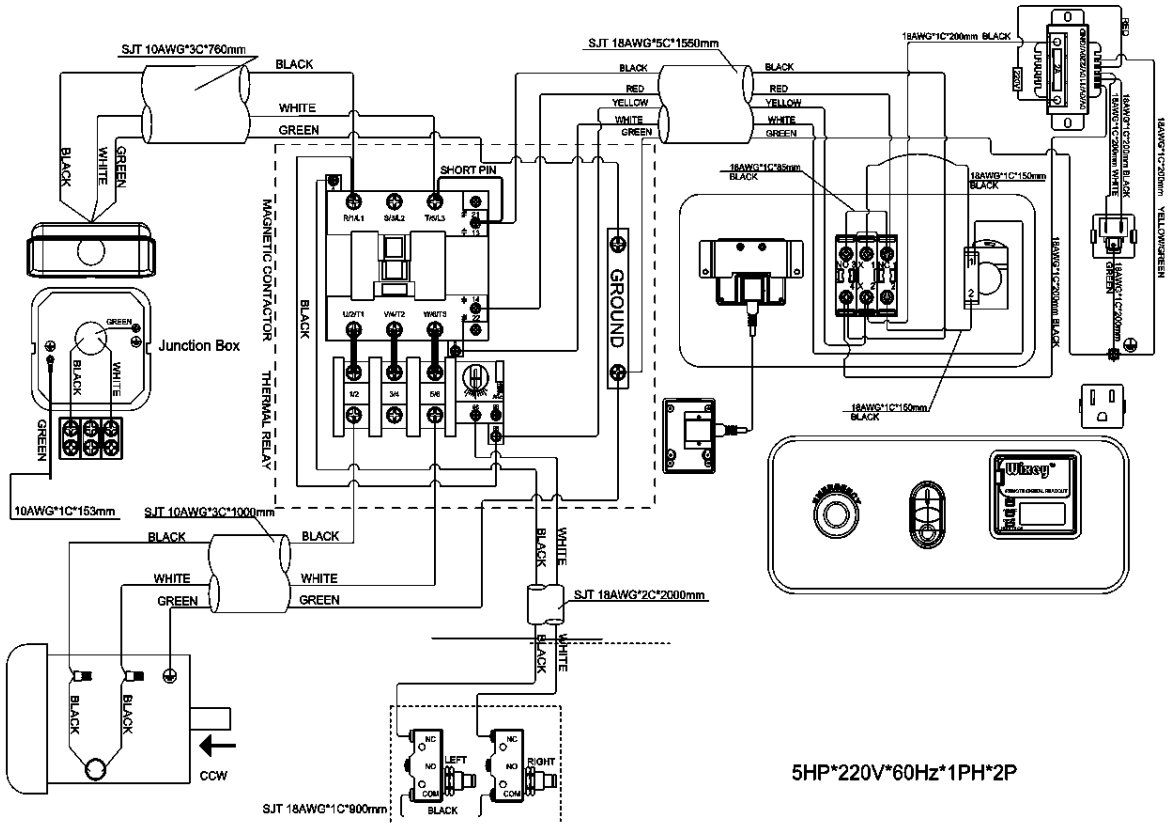
⚠ WARNING

REVIEW [ELECTRICAL SAFETY](#) PRIOR TO ANY WIRING PROCEDURES.

MJ12X88P-0130

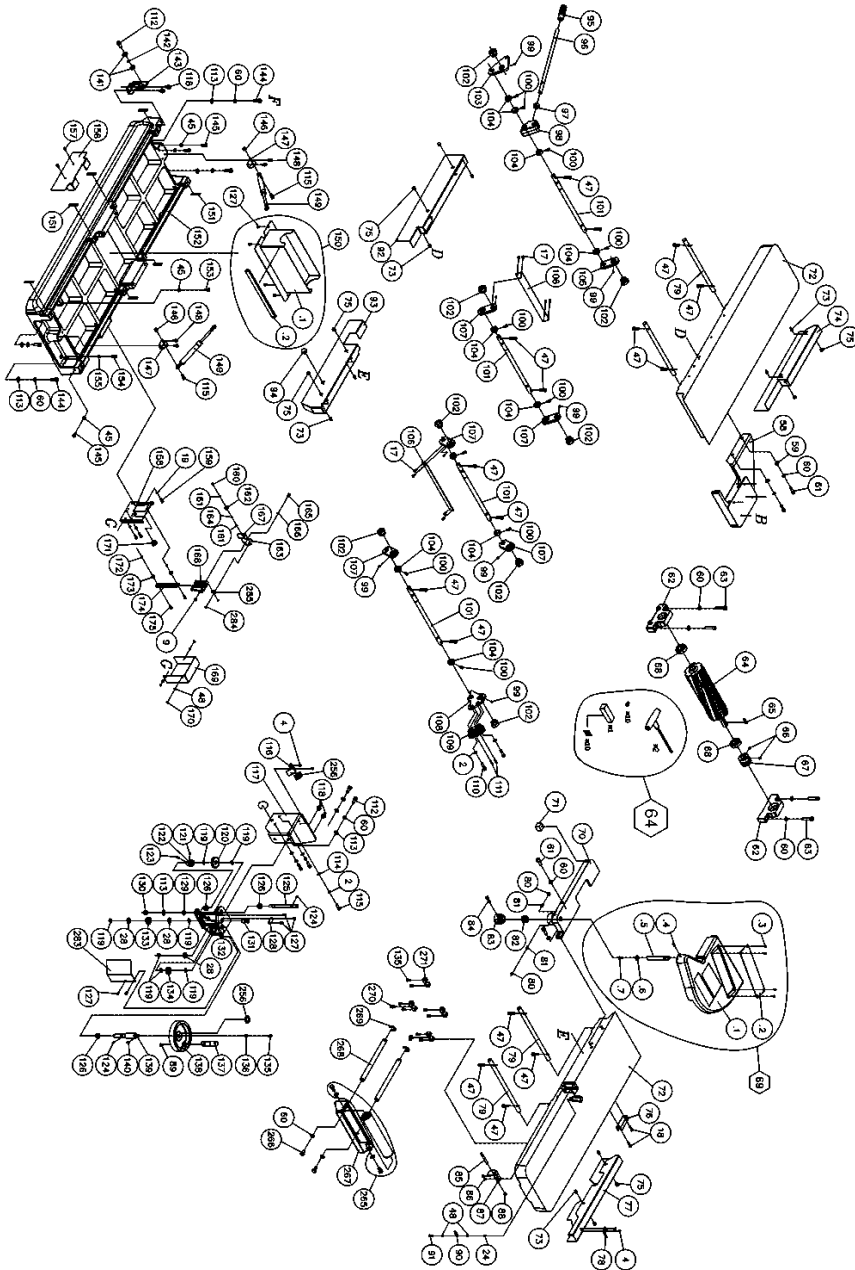
VOLTAGE	220V
PHASE	1PH
HERTZ	60Hz
FULL LOAD AMPERAGE	23 Amp
<p>⚠ WARNING! Below are RECOMMENDATIONS to be used for this machine based on the above information. Variables that may affect this are:</p> <ul style="list-style-type: none"> Actual voltage supplied to the machine Electrical code that must be met in your local province. <p>An electrician will verify that all the demands are met to properly wire the machine. If you have absolutely any doubt when wiring this machine - please consult with a qualified electrician.</p>	
PLUG/RECEPTACLE	Not Included
WIRING (Gauge)	See Jacket Printing
CIRCUIT BREAKER	30 Amp

JX|12 ShearTec: II Wiring Diagram MJ12X88P-0130

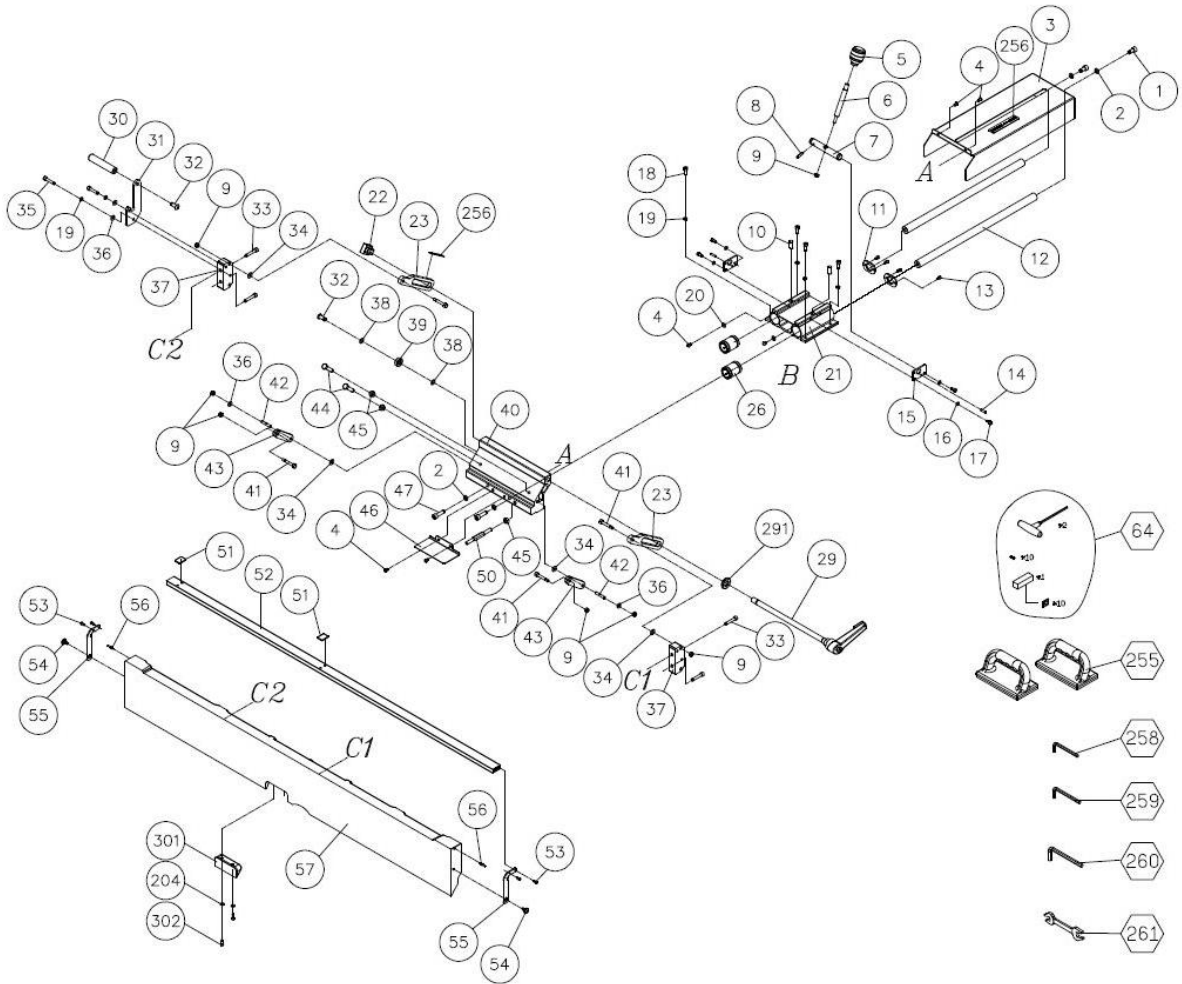


JX12 Sheartec:II Parts

Cutterhead & Drivetrain



Fence



REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
1	000104-104	CAP SCREW	M8-1.25X16	2
2	006305-100	LOCK WASHER	8.2-13.7	10
3	174771-308	FENCE COVER		1
4	000804-101	ROUND HEAD HEX SCREW	M5-0.8X8	12
5	250683-615	KNOB		1
6	361438-904	HANDLE ROD		1
7	361439-901	SWING AXIS		1
8	011003-104	SPRING PIN	5X25	1
9	008304-800	LOCK NUT	M6-1.0(10BX7H)	8
10	330066-000	BUSHING		2
11	330069-000	BRASS SHEET		2
12	361329-000	ROD		2
13	000101-101	CAP SCREW	M4-0.7X8	4
14	011002-110	SPRING PIN	4X16	2
15	174615-904	FIXING PLATE		2
16	006302-300	LOCK WASHER	5.1-9.3	4
17	000102-103	CAP SCREW	M5-0.8X10	18
18	002602-102	CAP LOCK SCREW	M6-1.0X20	6
19	006303-100	LOCK WASHER	6.5-10.5	9
20	006001-010	FLAT WASHER	5.2-12X1.5	6
21	310543-909	LINE RAIL SEAT		1
22	130383-903	SQUARE NUT		1
23	381411-904	SLIDE ARM		2
24	008004-100	HEX NUT	M5-0.8(8BX4H)	3
25	000202-105	SET SCREW	M5-0.8X30	1
26	034403-001	LINEAR BEARING	LM20UU	2
28	006001-125	FLAT WASHER	15.5-25X2.5	1
29	230432-000	UNIVERSAL HANDLE		1
30	361333-904	FENCE HANDLE		1
31	174620-904	HANDLE FIXING PLATE		1
32	000802-102	ROUND HEAD HEX SCREW	M8-1.25X20	2
33	000103-110	CAP SCREW	M6-1.0X35	4
34	006004-205	FLAT WASHER	6.8-14X0.3	4
35	000103-108	CAP SCREW	M6-1.0X25	2
36	006011-023	FLAT WASHER	6.3-13X2.0	8
37	300119-911	BLOCK		2
38	006001-044	FLAT WASHER	8.5-16X0.8	2
39	030101-001	BALL BEARING	608	1
40	310542-911	FENCE FIX SEAT		1
41	381464-901	BOLT		2
42	361359-902	SHAFT		2

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
43	174622-904	TILT PLATE		2
44	000003-108	HEX SCREW	M8-1.25X40	1
45	008006-100	HEX NUT	M8-1.25(13BX6.5H)	5
46	174956-904	SAFETY PLATE		1
47	000104-110	CAP SCREW	M8-1.25X30	18
48	006001-009	FLAT WASHER	5.2-10X1.0	7
49				
50	361367-902	CONNECT ROD		1
51	250602-621	FRICTION PLATE		2
52	310522-911	AUXILIARY FENCE		1
53	001102-804	ROUND HEAD TAPPING SCREW	M4-1.59X12	4
54	290104-902	SHOULDER SCREW		2
55	174614-904	SUPPORT PLATE		2
56	360249-905	CONNECT PIN		2
57	051349-196	FENCE	w/wear plate hole	1
58	051396-196	FENCE BRACKET		1
59	006001-068	FLAT WASHER	10-20X2.0	10
60	006307-100	LOCK WASHER	10.2-18.5	23
61	000105-103	CAP SCREW	M10-1.5X30	7
62	051400-902	REAR BEARING HOUSING		2
63	000105-107	CAP SCREW	M10-1.5X50	4
64	923253-001	SHEAR-TEC II CUTTERHEAD ASSY.		1
	038201-702	TORX SCREW	#10-32X12.5	10
	040703-000	TORX WRENCH	T-25	2
OP	922841-001	SHEAR-TEC II KNIFE INSERTS	10PCS/BOX	1
65	012004-002	KEY	6X6X30	1
66	001903-105	SET LOCK SCREW	M8-1.25X8	4
67	381072-902	PULLEY		1
68	030209-002	BALL BEARING	6205	2
69	924973-001	CUTTERHEAD GUARD ASSEMBLY		1
69.1	300136-000	CUTTERHEAD GUARD		1
69.2	251435-620	WINDOW		1
69.3	000401-201	FLAT HEAD PHILLIPS SCREW	M4-0.7X8	4
69.4	000204-105	SET SCREW	M8-1.25X20	1
69.5	361437-901	SHAFT		1
69.6	006001-021	FLAT WASHER	6.2-22X3	1
69.7	000103-105	CAP SCREW	M6-1.0X15	1
70	051183-000	RABBET ARM		1
71	200105-615	SPONGE	30X30X22(LXWXH)	1
72	051423-197	TABLE		2
73	000103-102	CAP SCREW	M6-1.0X10	8
74	174645-196	REAR BASE COVER - L		1

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
75	042505-000	CORD PLUG	HP-13	8
76	300118-909	BEARING BRACKET		1
77	174646-196	REAR BASE COVER - R		1
78	174649-156	POINTER		1
79	361298-901	SUPPORT SHAFT		4
80	009004-100	HEX NUT	1/4-20(11BX5.5H)	2
81	230275-000	SET SCREW	1/4"-20X3/4"	2
82	280165-000	TORSION SPRING		1
83	380825-901	SHAFT SEAT		1
84	000104-708	CAP SCREW	M8-1.25X25	1
85	361336-902	HANDLE SHAFT BOLT		1
86	290028-901	SHOULDER SCREW		2
87	174655-902	FIXING PLATE		1
88	009103-100	LOCK NUT	1/4-20(11BX8H)	1
89	000702-104	FLAT HD. SOC. SCREW	M6-1.0X16	1
90	280082-000	TENSION SPRING		1
91	000102-116	CAP SCREW	M5-0.8X15	1
92	174644-196	FRONT COVER - L		1
93	174643-196	FRONT COVER - R		1
94	230156-615	KNOB PLUNGER		1
95	250496-615	HANDLE		1
96	361300-902	UP-DOWN ROD		1
97	008011-100	HEX NUT	M16-2.0(24BX13H)	1
98	051401-902	UP-DOWN SEAT		1
99	001902-102	SET LOCK SCREW	M6-1.0X8	8
100	002602-101	CAP LOCK SCREW	M6-1.0X12	10
101	361335-902	ROD		4
102	381392-902	BUSHING		8
103	174513-902	ROD CONNECTING PLATE - L		1
104	381393-902	SPACER		10
105	174512-904	ROD PLATE		1
106	174639-000	FIXING ROD PLATE		2
107	174650-904	ROD CONNECTING PLATE - R		5
108	174515-904	ROD CONNECTING PLATE - REAR		1
109	070070-902	LEAD SCREW		1
110	000104-111	CAP SCREW	M8-1.25X35	2
111	011103-103	PARALLEL PIN	5.0X20	2
112	000105-102	CAP SCREW	M10-1.5X25	3
113	006001-075	FLAT WASHER	10.3-22X2.0	7
114	006001-038	FLAT WASHER	8-16X1.6	3
115	000104-106	CAP SCREW	M8-1.25X20	5
116	174656-904	SCALE SEAT		1

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
117	174516-902	LEAD SCREW SEAT		1
118	001501-101	CAP SCREW W/SPRING WASHER & WASHER	M8-1.25X20/8.2-15.4/8.5-19X2	4
119	010006-000	RETAINING RING	STW-15	5
120	320398-000	GEAR	50T	1
121	000203-101	SET SCREW	M6-1.0X6	1
122	361301-902	WORM GEAR		1
123	011003-114	SPRING PIN	5X20	1
124	012003-001	KEY	5X5X8	2
125	361302-902	GUARD POST		1
126	330067-000	BUSHING		3
127	000801-101	ROUND HEAD HEX SCREW	M6-1.0X10	14
128	174518-902	PACKING		1
129	006004-070	FLAT WASHER	10-22X0.8	1
130	008308-100	LOCK NUT	M10-1.5P(17BX12H)	1
131	381469-902	FIXING BOLT		1
132	051407-902	SUPPORT SEAT		1
133	320413-000	GEAR	30T	1
134	320397-000	GEAR	30T	1
135	000103-103	CAP SCREW	M6-1.0X12	13
136	006001-025	FLAT WASHER	6.4-16X1.0	1
137	230284-000	FOLDING HANDLE		1
138	090392-000	HANDWHEEL		1
139	361395-902	HANDWHEEL SUPPORT SHAFT		1
140	012002-006	KEY	4X4X16	1
141	006001-071	FLAT WASHER	10-25X3.0	2
142	006703-100	WAVE WASHER	WW-10	1
143	174514-902	LOCKING PLATE - L		1
144	000105-105	CAP SCREW	M10-1.5X40	8
145	000003-105	HEX SCREW	M8-1.25X25	3
146	008306-100	LOCK NUT	M8-1.25P(13BX9H)	2
147	174653-901	CYLINDER BRACKET		2
148	001502-102	CAP SCREW W/SPRING WASHER & WASHER	M6-1.0X16/6.5-10.5/6.3-13X1.0	4
149	660292-000	CYLINDER		2
150	924666-001	DUST HOOD ASSEMBLY		1
150.01	174654-008	DUST HOOD		1
150.02	200106-615	SPONGE		1
151	200024-615	PACKING		7
152	051430-196	BASE		1
153	000003-106	HEX SCREW	M8-1.25X30	1
154	000002-106	HEX SCREW	M6-1.0X30	1
155	008005-100	HEX NUT	M6-1.0(10BX5H)	1
156	174647-196	CUTTERHEAD FRONT COVER		1

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
157	000801-104	ROUND HEAD HEX SCREW	M6-1.0X20	2
158	174612-308	RULER BRACKET		1
159	000103-106	CAP SCREW	M6-1.0X16	3
160	000301-204	PAN HEAD SCREW	M3-0.5X15	1
161	006002-139	FLAT WASHER	3-8X1.0	2
162	030127-001	BALL BEARING	606	1
163	008315-200	LOCK NUT	M3-0.5P(5.5BX4H)	1
164	360906-902	BUSHING		1
165	000002-101	HEX SCREW	M6-1.0X12	1
166	006001-155	FLAT WASHER	6-12X1	1
167	174652-000	BRACKET		1
168	491128-000	SENSOR	WR5501	1
169	174611-308	DUST COVER		1
170	000102-101	CAP SCREW	M5-0.8X6	3
171	021801-000	EASY FIT GROMMET	NB-1722	2
172	006001-131	FLAT WASHER	5.3-10X2.0	6
173	006001-181	FLAT WASHER	5-16X3.0	2
174	950785-001	MAGNETIC RULER ASSEMBLY	3/4"	1
175	002603-702	CAP LOCK SCREW	M5-0.8X16	2
176	174618-904	FENCE COVER - R		1
177	029001-701	FLAT HEAD TAPPING SCREW	M4-1.41X10	4
178	174619-904	FENCE COVER - L		1
179	174926-196	CONTROL BOX		1
180	174927-904	BRACKET FOR LAMP		1
181	575282-000	CONTROL BOX COVER		1
182	000805-101	ROUND HEAD HEX SCREW	M4-0.7X6	6
183	000301-101	PAN HEAD SCREW	M3-0.5X6	4
184	300117-909	HANDLE		2
185	491153-000	EMERGENCY STOP	NPB22-H01R	1
186	471037-083	CONNECT CORD	18AWG/1CX150MM	2
187	491127-000	POWER SWITCH	M22DP-SF11E230WB(I,O)	1
188	471037-054	CONNECT CORD	ST18AWG/1CX85MM	1
189	490488-000	BATTERY	AAA	2
190	491210-000	DIGITAL READ OUT	WR5502CT(WIXEY)	1
191	730139-001	NETWORK CABLE	CAT 5E/RJ-45-CT-A X2000MM	1
192	174750-000	FIXING PLATE		1
193	001101-205	ROUND HEAD TAPPING SCREW	M3-1.06X6	2
194	000805-705	ROUND HEAD HEX SCREW	M4*0.7P*8	2
195	491185-000	TRANSFORMER		1
196	008103-100	HEX CUP NUT	M4-0.7	2
197	471037-106	CONNECT CORD	18AWG/1CX200MM	1

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
198	471037-107	CONNECT CORD	18AWG/1CX200MM	1
199	491184-000	SOCKET	125V/15A	1
200	174928-904	SOCKET BRACKET		1
201	000302-102	PAN HEAD SCREW	M4-0.7X8	4
202	006501-100	INT. TOOTH WASHER	4.3-8.5(BW-4)	1
203	006002-200	FLAT WASHER	4.3-8X0.8	1
204	006001-001	FLAT WASHER	4.3-10X1.0	1
205	021103-100	STRAIN RELIEF	ACC-3-B	1
206	021802-000	EASY FIT GROMMET	NB-2430	3
207	924571-001	CONTROL BOX ARM		1
208	000005-111	HEX SCREW	M12-1.75X30	3
209	006308-100	LOCK WASHER	12.2-21.6	3
210	006001-136	FLAT WASHER	12.2-23X2.0	4
211	000104-117	CAP SCREW	M8-1.25X70	1
212	006001-054	FLAT WASHER	8.5-20X2.0	1
213	381391-308	BRACKET FOR POWER FEEDER		1
214	000403-104	FLAT HEAD PHILLIPS SCREW	M6-1.0X20	4
215	170479-196	COVER		1
216	000101-110	CAP SCREW	M4-0.7X30	4
217	490229-615	LIMIT SWITCH COVER	KSSCB-2	2
218	491101-000	LIMIT SWITCH	MJ2-1307	2
219	006002-002	FLAT WASHER	4.3-12X0.8	8
220	174932-000	LIMIT SWITCH BRACKET		2
221	280274-000	SPRING		2
222	008301-200	LOCK NUT	M4-0.7P(7BX5H)	4
223	471037-095	CONNECT CORD	18AWG/1CX900MM	1
224	901346-001	MOTOR W/PULLEY ASSEMBLY	5HP/230V/60HZ/1PH	1
225	008007-100	HEX NUT	M10-1.5P(17BX8H)	4
226	000804-103	ROUND HEAD HEX SCREW	M5-0.8X10	4
227	190074-901	SPACER		2
228	361303-902	MOTOR PLATE SHAFT		2
229	050321-008	MOTOR SHAFT		1
230	380249-901	ADJUST ROD ASSEMBLY		2
231	008009-100	HEX NUT	M12-1.75P(19BX10H)	4
232	006001-091	FLAT WASHER	13-28X3.0	4
233	001902-105	SET LOCK SCREW	M6-1.0X12	2
234	014343-000	POLY-V-BELT	490J-9	1
235	174641-008	DUST CHUTE		1
237	170638-156	HOOK		2
238	174642-000	PULLEY COVER		1
239	001603-102	ROUND HEAD PHILLIPS SCREW W/WASHER	M6-1.0PX10/6-13.2X1.0	4

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
240	175109-196	STAND		1
241	340007-615	BLOCK		5
242	230424-000	WHEEL (or)		4
	230403-000	LEVELING FOOT		4
243	174954-156	EMERGENCY STOP PLATE		1
244	938112-001	MAGNETIC SWITCH ASSEMBLY	5HP/220V-240V/1PH	1
244.1	170977-901	SWITCH PLATE		1
244.2	821017-066	MAGNETIC SWITCH	5HP/220V-240V/1PH	1
244.3	021313-000	STRAIN RELIEF	MG25A-18B	2
244.4	021377-000	STRAIN RELIEF	MG25AS-10B	2
244.5	000303-104	PAN HEAD SCREW	M5-0.8X12	2
244.6	473005-025	CONNECT CORD	SJT 10AWG/3CX1000MM	1
244.7	473005-026	CONNECT CORD	SJT 10AWG/3CX760MM	1
244.8	475001-007	CONNECT CORD	SJT 18AWG/5CX1550MM	1
244.9	472001-050	CONNECT CORD	SJT 18AWG/2CX2000MM	1
245	000303-104	PAN HEAD SCREW	M5-0.8X12	4
246	250573-615	BUSHING		4
247	490336-000	TERMINAL BLOCK	HD-30-A3(600V/40A)	1
248	000303-109	PAN HEAD SCREW	M5-0.8X35	4
249	023701-015	STRAIN RELIEF	MGB25-18B	1
250	491116-008	OUTLET BOX		1
251	490124-008	OUTLET BOX COVER		1
252	003303-102	PAN HEAD SCREW	3/16"-24X1/4"	1
253	471008-001	CONNECT CORD	10AWG/1CX153MM	1
254	006502-300	INT. TOOTH WASHER	5.3-10(BW-5)	2
255	250035-629	PUSH BLOCK		2
258	040005-000	HEX WRENCH	5MM	1
259	040006-000	HEX WRENCH	6MM	1
260	040007-000	HEX WRENCH	8X100MM	1
261	040206-000	OPEN WRENCH	17/19	1
265	660324-000	EXTENSION ROLLER		1
266	000004-101	HEX SCREW	M10*1.5P*20	2
267	174930-904	ROLLER BRACKET		1
268	361411-902	EXTENSION ROD		2
269	010202-000	RETAINING RING	ETW-17	6
270	250705-000	WING SCREW		2
271	130395-903	BUSHING BLOCK		4
282	002401-101	ROUND HEAD PHILLIPS SCREW W/WASHER	M4-0.7X12/4-10X0.8	4
283	174949-904	SHAFT COVER		1
284	000303-201	PAN HEAD SCREW	M5-0.8X6	1
285	174953-000	FIXING PLATE		1
286	174955-904	FIXING BRAKE PLATE		1

REF NO	PART NUMBER	DESCRIPTION	SPECIFICATION	QTY
289	010003-000	RETAINGING RING	STW-12	1
290	043322-000	O-RING	P11	1
291	381516-904	PACKING		1
295	290003-901	SCREW		1
297	472001-072	CORD. CONNECTING	SJT 18AWG/2C/700mm	1
298	472001-073	CORD, CONNECTING	SJT 18AWG/2C/1400mm	1
299	002601-102	CAP LOCK SCREW	M8-1.25x20	8
300	006001-056	FLAT WASHER	8.5x23x2	8
301	250462-615	BLOCK		1
302	000101-103	CAP SCREW	M4-0.7x12	2

WARRANTY & REGISTRATION

THANK YOU!

Welcome to the Laguna Tools® group of discriminating woodworkers. We understand that you have a choice of where to purchase your machines and appreciate the confidence you have in the Laguna Tools® brand.

Through hands-on experience, Laguna Tools® is constantly working hard to make innovative, precision products. Products that inspire you to create works of art, are a joy to operate, and encourage your best work.

Laguna Tools®
Imagination, Innovation, and Invention at Work

WARRANTY & REGISTRATION

Every product sold is warranted to be free of manufacturers' defective workmanship, parts, and materials. For any questions about this product, the intended use or what it was designed for, customer service, or replacement parts, please contact our customer service department:

Laguna Tools® Customer Service
2072 Alton Parkway, Irvine, California 92606, USA
1-800-332-4049
customerservice@lagunatools.com
www.lagunatools.com/why/customer-service/
8AM to 5PM PST, Monday through Friday

For warranty claims or to report damage upon receiving – please reach out to our warranty department:

Laguna Tools® Warranty Service
2072 Alton Parkway, Irvine, California 92606, USA
1-949-474-1200
customerservice@lagunatools.com
www.lagunatools.com/policies/warranty
8AM to 5PM PST, Monday through Friday

REGISTRATION

To prevent voiding this warranty, all products sold must be registered within thirty (30) days of receiving the product. Registering the product will enable the original purchaser to receive notifications about important product changes, receive customer service, and be able to file a warranty claim against defective workmanship, parts, or materials.

WHO IS COVERED

The applicable warranty covers only the initial purchaser of the product from the date of receiving the product. To file such claims, the original purchaser must present the original receipt as proof of purchase.

WHAT IS COVERED

The warranty covers any defects in the workmanship of all parts and materials that make up the machine unless otherwise specified. Any part, determined by Laguna Tools®, to have a defect will be repaired or replaced (and shipped), without charge. The defective item/part must be returned to Laguna Tools® with the complaint and proof of purchase in the original packaging that it was received in. In the event the item/part is determined to be not covered by this warranty, the customer will be responsible for the cost to replace the item/part and all related shipping charges.



WARRANTY LIMITATIONS

This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, or lack-of inadequate dust collection. The warranty may be voided against proof of misuse/abuse, damage caused where repair or alterations have been made or attempted by others, using the product for purposes other than those described as intended use (unless with consent by Laguna Tools®), modification to the product, or use with an accessory that was not designed for the product. It is the responsibility of the user to understand basic woodworking machinery settings and procedures and to properly maintain the equipment in accordance with the standards provided in this manual.

LENGTH OF WARRANTY

All new machines and optional accessories sold through an authorized dealer carry a two-year warranty effective the date of receiving the product. Machines sold for either commercial or industrial use have a one-year warranty. Wearable parts like throat plates, bandsaw guides, etc., have a ninety-day warranty.

Table A-1 Warranty Lengths

2 Year – New Machines Sold Through an Authorized Dealer
2 Year – Accessories Sold as Machine Options (excluding blades)
1 Year – Machines Sold for Commercial or Industrial Use
1 Year – Blades and Accessories outside of Machine Options
90 Days – Wearable Parts

Aside from being free of defects upon receiving, consumable parts, like cutters and abrasives, are not covered by this warranty unless otherwise stated by Laguna Tools®. These parts are designed to be used at the expense of the operator and are available for replacement or inventory purchase. The determination of a consumable part will be made on a case-by-case basis by Laguna Tools®.

SHIPPING DAMAGE

Laguna Tools® is not responsible for damage or loss caused by a freight company or other circumstances not in the direct control of Laguna Tools®. All shipping-related claims for loss or damage goods must be made to Laguna Tools within twenty-four hours of delivery.

HOW TO RECEIVE SUPPORT

To file a warranty-claim please contact the warranty department at 1-949-474-1200. To receive customer service or technical support please contact the customer service department at 1-800-332-4094. Parts, under warranty, are shipped at the expense of Laguna Tools® either by common carrier, FedEx ground services or similar method. Technical support to install replacement parts is primarily provided by phone, fax, email, or the Laguna Tools Customer Support Website.

LAGUNA



LAGUNA AMERICAN HEADQUARTERS

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South Carolina: 825 Bistline Dr. Ste 101, West Columbia, SC 29172, U.S.A. Phone: +1-800-234-1976
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