



8" JOINTER



MODEL: KC-203C

INSTRUCTION MANUAL

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IMPORTANT INFORMATION

2-YEAR
LIMITED WARRANTY
FOR THIS 8" JOINTER

KING CANADA TOOLS
OFFERS A 2-YEAR LIMITED WARRANTY
FOR INDUSTRIAL USE.

PROOF OF PURCHASE

Please keep your dated proof of purchase for warranty and servicing purposes.

REPLACEMENT PARTS

Replacement parts for this tool are available at our authorized KING CANADA service centers across Canada. For servicing, contact or return to the retailer where you purchased your product along with your proof of purchase.

LIMITED TOOL WARRANTY

KING CANADA makes every effort to ensure that this product meets high quality and durability standards. KING CANADA warrants to the original retail consumer a 2-year limited warranty as of the date the product was purchased at retail and that each product is free from defects in materials. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations and lack of maintenance. KING CANADA shall in no event be liable for death, injuries to persons or property or for incidental, special or consequential damages arising from the use of our products. To take advantage of this warranty, the product or part must be returned for examination by the retailer. Shipping and handling charges may apply. If a defect is found, KING CANADA will either repair or replace the product.

PARTS DIAGRAM & PARTS LISTS

Refer to the Parts section of the King Canada web site for the most updated parts diagram and parts list.

GENERAL SAFETY INSTRUCTIONS FOR POWER TOOLS



1. KNOW YOUR TOOL

Read and understand the owners manual and labels affixed to the tool. Learn its application and limitations as well as its specific potential hazards.

2. GROUND THE TOOL.

This tool is equipped with an approved 3-conductor cord and a 3-prong grounding type plug to fit the proper grounding type receptacle. The green conductor in the cord is the grounding wire. **NEVER** connect the green wire to a live terminal.

3. KEEP GUARDS IN PLACE.

Keep in good working order, properly adjusted and aligned.

4. REMOVE ADJUSTING KEYS AND WRENCHES.

Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

5. KEEP WORK AREA CLEAN.

Cluttered areas and benches invite accidents. Make sure the floor is clean and not slippery due to wax and sawdust build-up.

6. AVOID DANGEROUS ENVIRONMENT.

Don't use power tools in damp or wet locations or expose them to rain. Keep work area well lit and provide adequate surrounding work space.

7. KEEP CHILDREN AWAY.

All visitors should be kept a safe distance from work area.

8. MAKE WORKSHOP CHILD-PROOF.

-with padlocks, master switches or by removing starter keys.

9. USE PROPER SPEED.

A tool will do a better and safer job when operated at the proper speed.

10. USE RIGHT TOOL.

Don't force the tool or the attachment to do a job for which it was not designed.

11. WEAR PROPER APPAREL.

Do not wear loose clothing, gloves, neckties or jewelry (rings, watch) because they could get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Roll up long sleeves above the elbows.

12. ALWAYS WEAR SAFETY GLASSES.

Always wear safety glasses (ANSI Z87.1). Everyday eyeglasses only have impact resistant lenses, that are **NOT** safety glasses. Also use a face or dust mask if cutting operation is dusty.

13. DON'T OVERREACH.

Keep proper footing and balance at all times.

14. MAINTAIN TOOL WITH CARE.

Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. DISCONNECT TOOLS.

Before servicing, when changing accessories or attachments.

16. AVOID ACCIDENTAL STARTING.

Make sure the switch is in the "OFF" position before plugging in.

17. USE RECOMMENDED ACCESSORIES.

Consult the manual for recommended accessories. Follow the instructions that accompany the accessories. The use of improper accessories may cause hazards.

18. NEVER STAND ON TOOL.

Serious injury could occur if the tool tips over. Do not store materials such that it is necessary to stand on the tool to reach them.

19. CHECK DAMAGED PARTS.

Before further use of the tool, a guard or other parts that are damaged should be carefully checked to ensure that they will operate properly and perform their intended function. Check for alignment of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other parts that are damaged should be properly repaired or replaced.

20. NEVER LEAVE MACHINE RUNNING UNATTENDED.

Turn power "OFF". Don't leave any tool running until it comes to a complete stop.



ADDITIONAL SAFETY INSTRUCTIONS FOR YOUR JOINTER

READ AND UNDERSTAND INSTRUCTION MANUAL BEFORE OPERATING JOINTER

1. DO NOT ALTER OR MISUSE THE TOOL.

These tools are precision built. Any alteration or modification not specified is misuse and may result in dangerous conditions.

2. AVOID GASEOUS AREAS.

Do not operate electric tools in gaseous or explosive environments. Motors in these tools normally spark and may result in dangerous conditions.

3. BEFORE CONNECTING TO THE POWER SOURCE.

Make sure the voltage supplied is the same as that specified on the nameplate of the tool. A power source with a voltage greater than that specified for the tool can result in serious injury to the operator, as well as damage to the tool. If in doubt, DO NOT PLUG IN TOOL. Using a power source with a voltage less than the nameplate rating is harmful to the motor.

4. STABILITY OF THE JOINTER.

Your jointer must be bolted securely to a stand or a workbench. In addition, if there is any tendency for the jointer to tip over or move during certain operations, such as cutting long, heavy boards, bolt your jointer stand or workbench to the floor.

5. LOCATION.

This jointer saw is intended for indoor use only.

6. MISSING OR MALFUNCTIONING PARTS.

If any part of the jointer is missing, malfunctioning, has been damaged or broken...such as the motor switch, or other operating control, a safety device or the power cord...cease operating immediately until the particular part is properly repaired or replaced.

7. CLEARING THE TABLE OF ALL OBJECTS.

Never turn your jointer on before clearing the table of all objects (tools, scraps of wood...) except for the workpiece and related feed and support devices for the operation planned.

8. AVOID AWKWARD HAND POSITIONS.

A sudden slip could cause a hand to move into the blade.

9. FEEDING SPEED.

Do not feed the material too fast while cutting. Only feed the material fast enough so that the blade will cut. Keep fingers away from the blade.

10. DO NOT perform any layout, assembly or setup work on the table while the jointer is operating.

11. Never perform a jointing or planing operation with cutterhead or drive guard removed.

12. Never make a jointing or planing cut deeper than 1/8".

13. Always use hold downs or push blocks for jointing material narrower than 3" or planing material thinner than 3".

14. Never joint or plane material less than 10" long.

15. ALWAYS KEEP HANDS AND FINGERS AWAY FROM CUTTERHEAD.

16. Disconnect machine from power source before making repairs or adjustments.

17. Do not operate while under the influence of drugs, alcohol, or medication.

8" JOINTER ASSEMBLY



ASSEMBLY INSTRUCTIONS

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

ASSEMBLING JOINTER TO STAND

1. The outfeed end of the jointer will be located at the side of the stand with the dust chute (A) Fig. 2.
2. Unlock back panel lock knob at the rear of the enclosed stand, lift back panel and remove. Figure 2 illustrates the enclosed stand with the back panel removed.
3. Line up three holes (F) and (L) Fig. 2, on top stand with three holes located at the bottom of the jointer base and fasten the jointer to the base with three $\frac{3}{8}$ - 16 x 2" long hex head screws (G) Fig. 3, six flat washers (H), three lock washers (J), and three hex nuts (K). **CAUTION: THE JOINTER IS EXTREMELY HEAVY. WE STRONGLY SUGGEST THAT TWO OR MORE PEOPLE LIFT THE MACHINE ONTO THE STAND OR LIFT THE JOINTER MECHANICALLY. IMPORTANT:** Mounting screws for fastening the jointer to the stand through holes (F) should be started downward from the jointer base. Screw for mounting the jointer to the stand through hole (L) should be started upward from the inside of the stand.

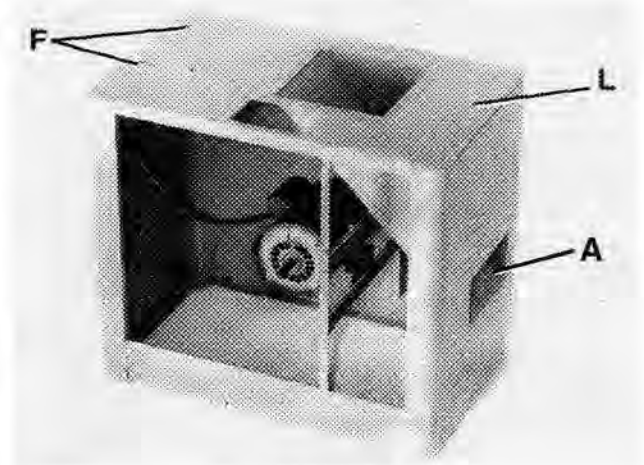


FIGURE 2

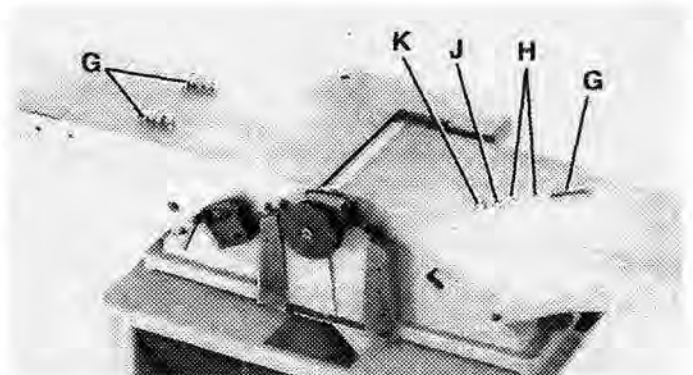


FIGURE 3



8" JOINTER ASSEMBLY

ASSEMBLING MOTOR PULLEY

Assemble motor pulley (A) Fig. 4, on the motor shaft (B) with the hub of the pulley in the outer position as shown. Make certain key (C) is inserted in the keyway of the motor pulley and shaft. Tighten set screw (which is located on the pulley hub) against the motor shaft (B).

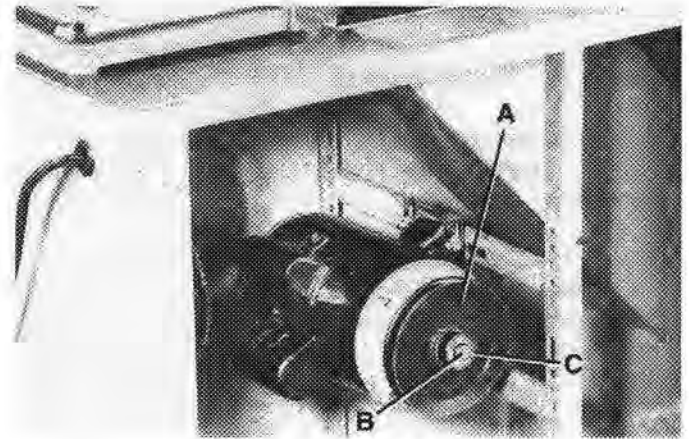


FIGURE 4

ASSEMBLING BELT AND ALIGNING PULLEYS

1. Place belt (A) Fig. 5, inside the grooves of cutterhead pulley (B) and motor pulley (C). Repeat for the second belt (not illustrated).
2. Make certain the motor pulley (C) Fig. 6, is aligned with cutterhead pulley (B) by placing a straight edge (D) onto the face of each pulley as shown.
3. If an adjustment is necessary, the motor pulley (C) Fig. 6, can be moved in or out on the motor shaft, or the motor can be moved by loosening four mounting screws, two of which are shown at (E) Fig. 6. After adjustment is made tighten the four mounting screws or the set screw on the hub of the motor pulley, depending on which adjustment you made.

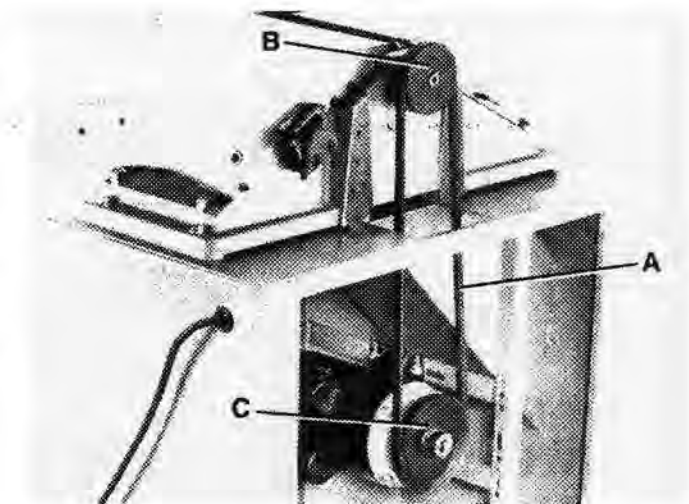


FIGURE 5

ADJUSTING BELT TENSION

Proper belt tension is obtained when there is approximately 1" deflection at the center span of the belts, using light finger pressure. If an adjustment is necessary, the motor can be raised or lowered by loosening four mounting screws, two of which are shown at (E) Fig. 6.

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

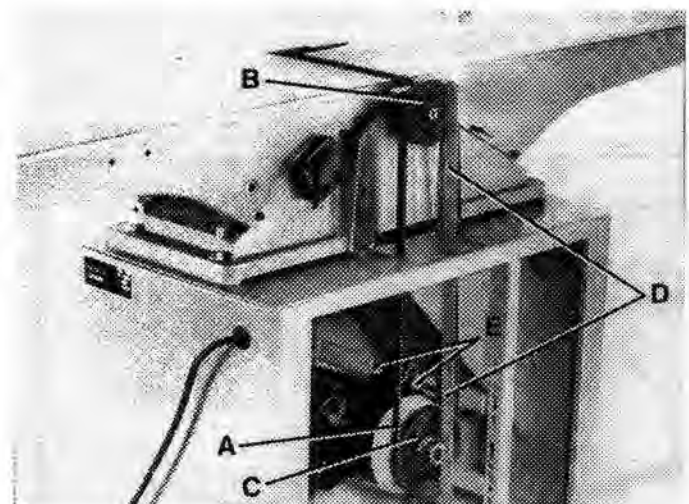


FIGURE 6

8" JOINTER ASSEMBLY



ASSEMBLING CUTTERHEAD PULLEY GUARD / CARRIAGE MOUNTING BRACKET

1. Align two pins (A) Fig. 7, in mounting bracket (C) with two holes (B) at the rear of jointer (D).
2. Using the supplied hex. key (E), fasten mounting bracket (C) Fig. 8, to the jointer with four M8 x 55mm long hex socket head screws, lock washers, and flat washers (F), three of which are shown.

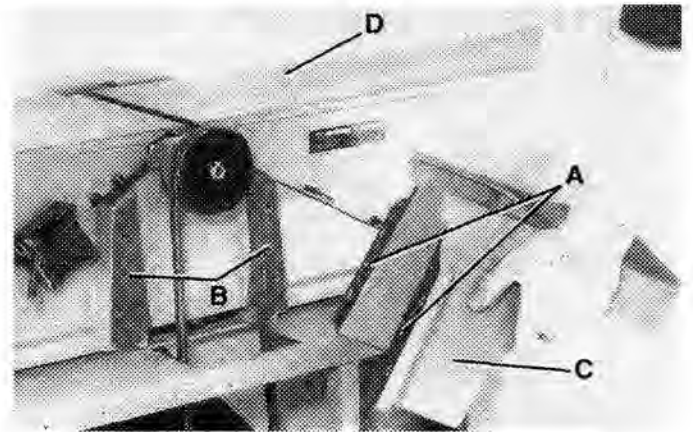


FIGURE 7

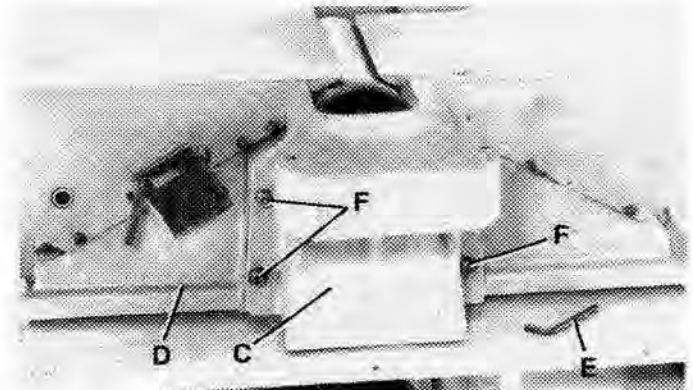


FIGURE 8

ASSEMBLING FENCE CARRIAGE ASSEMBLY

1. Fasten fence carriage assembly (A) Fig. 9, to cutterhead pulley guard/carriage mounting bracket (B) using two M8 x 20mm long hex socket head screws, lock washers, and flat washers (C) through holes in fence carriage assembly, one of which is shown at (D).
2. Fig. 10 illustrates the fence carriage assembly (A) properly mounted to the jointer.

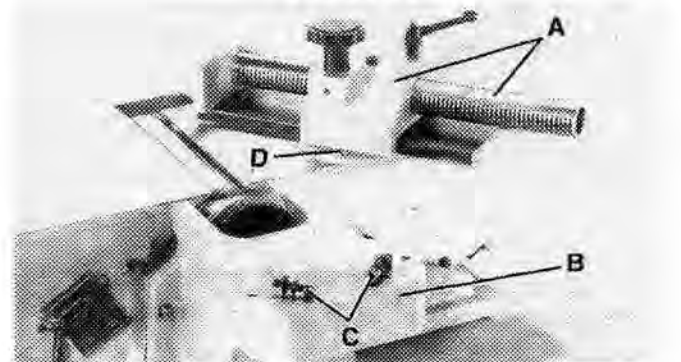


FIGURE 9

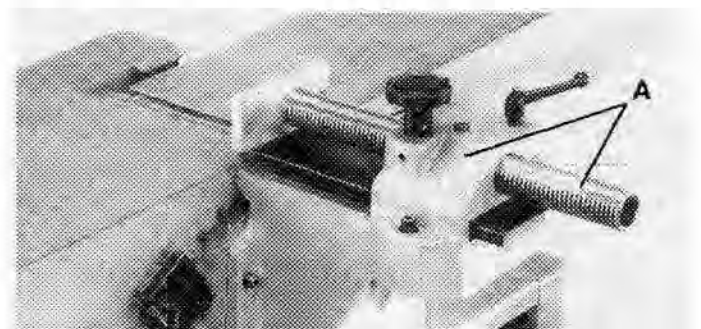


FIGURE 10



8" JOINTER ASSEMBLY

ASSEMBLING FENCE

1. Align two threaded holes (G) Fig. 11, in fence (A) with two holes (C) in fence carriage (B) and fasten fence to carriage assembly with two socket hex. screws, lock washers, and flat washers (D).

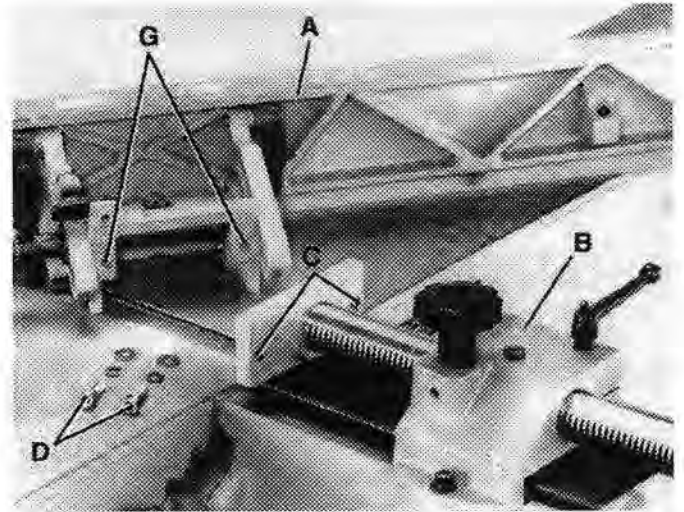


FIGURE 11

2. Fig. 12 illustrates the fence (A) properly mounted to carriage assembly (B).

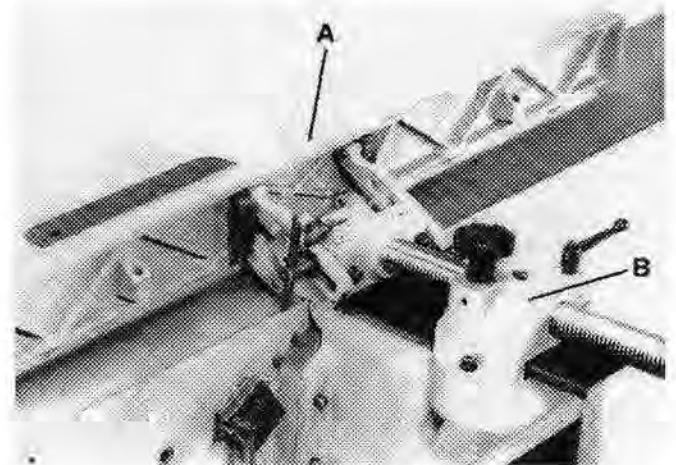


FIGURE 12

3. Thread two fence adjustment handles (E) Fig. 13, into the rear of fence (A) as shown.

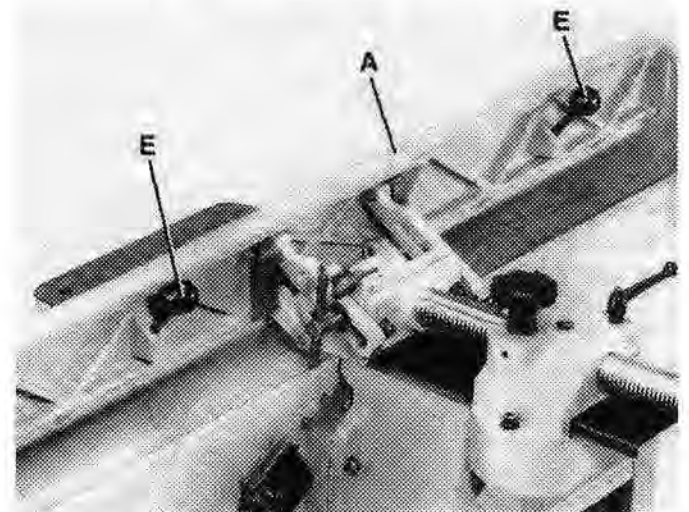


FIGURE 13

8" JOINTER ASSEMBLY



ASSEMBLING CUTTERHEAD GUARD

1. Remove set screw (not shown) from post (A) Fig. 14, of cutterhead guard (B).
2. Insert post (A) Fig. 14, through hole (C) in the infeed table. **NOTE:** A spring is supplied in knob assembly (D) Fig. 14, that returns the guard (B) over the cutterhead after a cut has been made. Turn knob (D) to provide tension on the spring inside knob assembly (D) Fig. 14, engages inside the slot of the post. If spring tension is too much, or too little that it does not allow the cutterhead guard to spring back over the cutterhead, adjust the spring tension as necessary by removing the guard and rotating knob (D).
3. Thread set screw (E) Fig. 15, which was removed in **STEP 1**, back into post (A) to keep cutterhead guard (B) in position during operation.

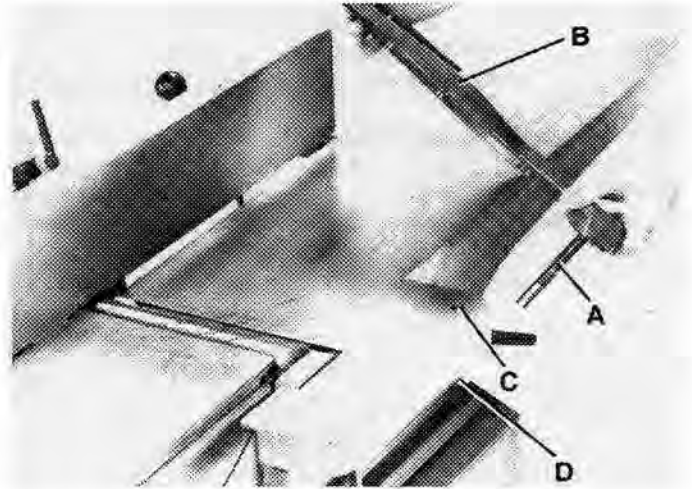


FIGURE 14

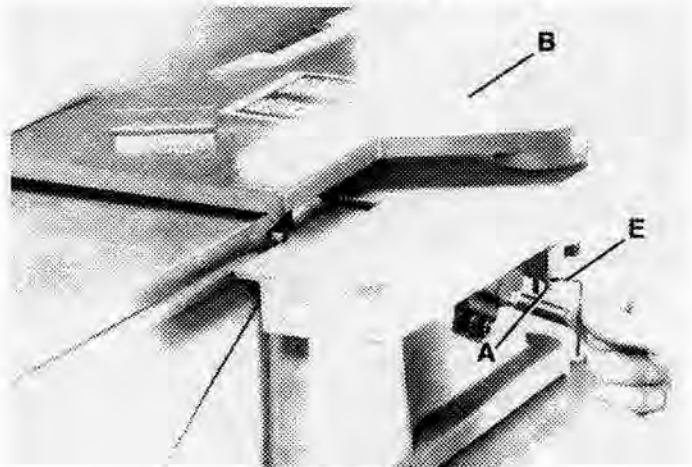


FIGURE 15

4. Fig. 16 illustrates the cutterhead guard (B) assembled to the jointer.

ASSEMBLING DUST CHUTE

The jointer has a built-in dust chute to expel sawdust efficiently during cuts. If you will be connecting a dust collection system to the jointer, a dust collector connector is supplied and can be fastened to the jointer stand with four screws.

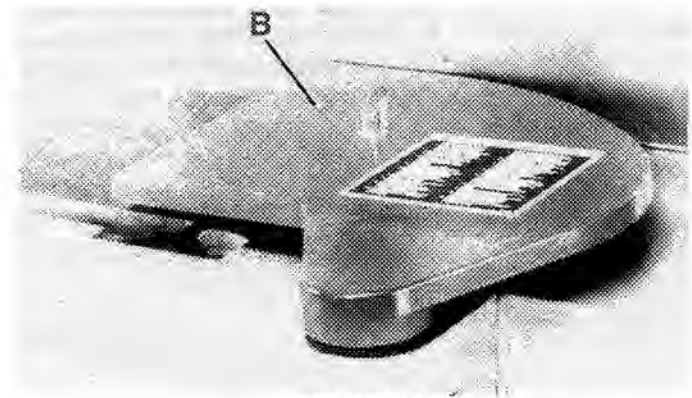


FIGURE 16



ELECTRICAL REQUIREMENTS 8" JOINTER

WARNING!

ALL ELECTRICAL CONNECTIONS MUST BE DONE BY A QUALIFIED ELECTRICIAN. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY! ALL ADJUSTMENTS OR REPAIRS MUST BE DONE WITH THE JOINTER DISCONNECTED FROM THE POWER SOURCE. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY!

POWER SUPPLY

WARNING: YOUR JOINTER MUST BE CONNECTED TO A 20-AMP, BRANCH CIRCUIT AND USE A 20-AMP TIME DELAY FUSE OR CIRCUIT BREAKER. FAILURE TO CONNECT IN THIS WAY CAN RESULT IN INJURY FROM SHOCK OR FIRE.

Your jointer must be properly grounded. Not all outlets are properly grounded. If you are not sure if your outlet is properly grounded, have it checked by a qualified electrician.

WARNING: IF NOT PROPERLY GROUNDED, THIS JOINTER CAN CAUSE ELECTRICAL SHOCK, PARTICULARLY WHEN USED IN DAMP LOCATIONS. TO AVOID SHOCK OR FIRE, IF THE POWER CORD IS WORN OR DAMAGED IN ANY WAY, HAVE IT REPLACED IMMEDIATELY.

GROUNDIRG

This jointer must be grounded. If it should malfunction or break-down, grounding provides a path of least resistance for electric current, to reduce the risk of electric shock. This jointer is equipped with a cord having an equipment-grounding conductor and grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances. **WARNING:** TO MAINTAIN PROPER GROUNDING OF YOUR JOINTER, DO NOT REMOVE OR ALTER THE GROUNDING PRONG IN ANY MANNER.

POWER CORD & PLUG

The motor supplied with your King Canada 8" jointer is a single phase, 240V motor. There is no plug supplied with the motor, therefore to operate at 240V, a plug with two flat, current-carrying prongs in tandem, and one round or "U" shaped longer ground prong, as shown in Fig. 17, must be installed. This plug is used only with proper mating 3-conductor grounded receptacle, as shown in Fig. 17.

EXTENSION CORDS

Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and 3-hole receptacle which will accept the tool's plug.

When using extension cord, be sure to use one heavy enough to carry the current of the tool. An undersized extension cord will cause a drop in line voltage, resulting in loss of power and overheating. Figure 17A shows the correct gauge to use depending on the extension cord length. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the extension cord.

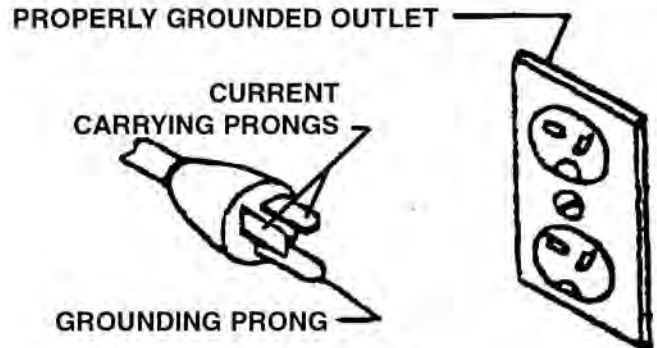


FIGURE 17

WIRE LENGTH & SIZE 240V LINES

0-50 ft. = NO.14
51-100 ft. = NO.12
101 ft & up = Not Recommended

FIGURE 17A

OPERATING CONTROLS AND ADJUSTMENTS

8" JOINTER



INFEEED TABLE ADJUSTMENTS

1. To raise or lower the infeed table, loosen table lock handle (A) Fig. 18, which is located at the rear of the infeed table and loosen locking handle (B) Fig. 19, which is located at the front of the infeed table.

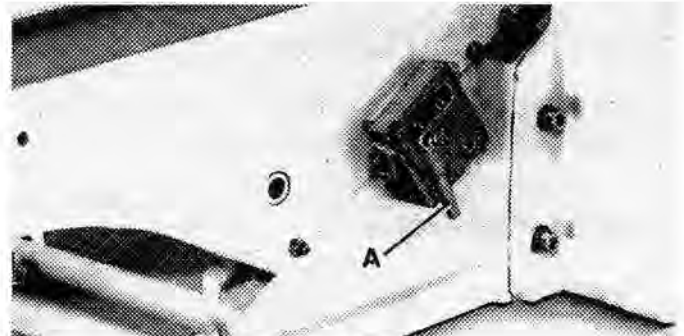


FIGURE 18

2. Turn the infeed table adjustment handwheel (C) Fig. 19.

3. **IMPORTANT:** When lowering the infeed table, a depth stop (D) Fig. 19, will automatically stop the table at a 1/8" depth-of-cut. To move the table past this point, the depth stop (D) Fig. 20, must be raised, while simultaneously lowering the infeed table. Always make certain table locking handles (A) Fig. 18, and (B) Fig. 19, are tight before operating the jointer. The locking handles are springloaded and can be repositioned by pulling outward on the handle and repositioning it on the serrated nut located underneath the handle.

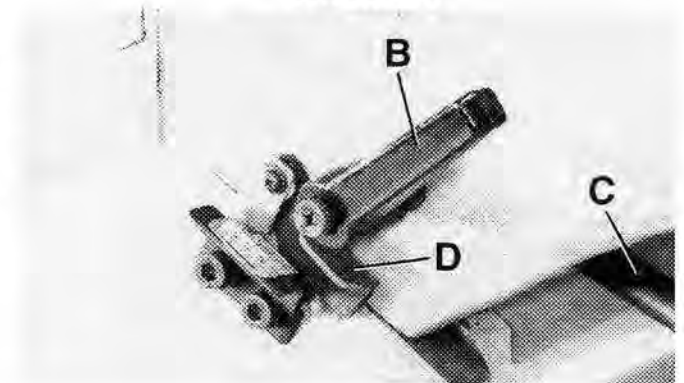


FIGURE 19

4. The depth-of-cut of the infeed table (position of the infeed table in relation to the cutting circle) is indicated on scale (E) Fig. 20. **NOTE:** Maximum depth-of-cut with this jointer is 1/2", which can be accomplished in cuts of 1/8" increments.

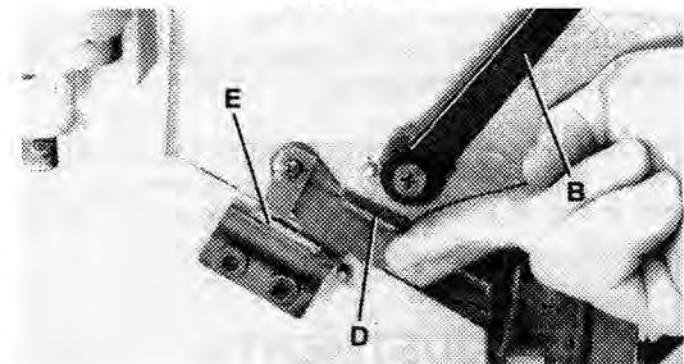


FIGURE 20

INFEEED TABLE POSITIVE STOPS

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

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

2. Loosen two lock nuts (A) and (B) Fig. 21, and turn the adjustment screws (C) and (D), which are located at the rear of the infeed table, as required. A good suggestion is to set the upper positive stop (D) against stud (E) for your finish or final cut. This means that you will be able to rapidly set the infeed table for a finish or final cut without checking the scale and pointer. Also, the lower positive stop (C) can be set against stud (E) at the maximum depth of cut, if desired.

3. Tighten locking nuts (A) and (B) Fig. 21, after adjustments are made.

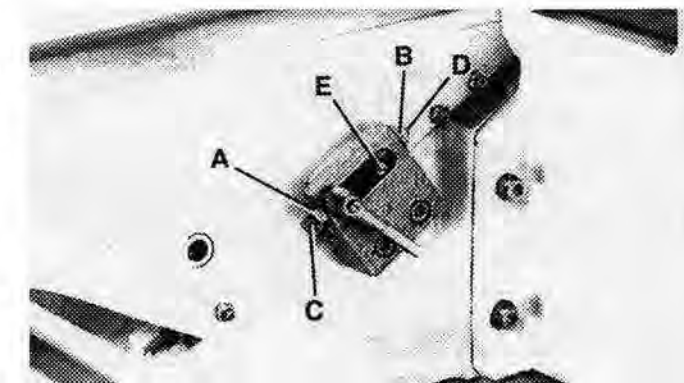


FIGURE 21



OPERATING CONTROLS AND ADJUSTMENTS

8" JOINTER

OUTFEED TABLE ADJUSTMENTS

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

1. MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.
2. Loosen locking screw (A) Fig. 22, and turn handwheel (B). When the outfeed table is exactly level with the cutterhead knives at their highest point of revolution, tighten screw (A).

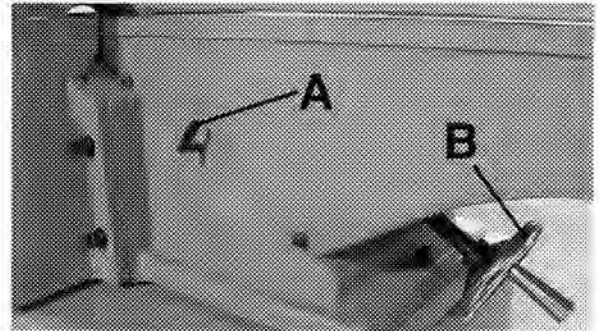


FIGURE 22

KNIFE ADJUSTMENTS

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

1. MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.
2. Remove set screw holding the cutterhead guard (A) Fig. 23, in position and remove cutterhead guard.
3. Loosen table locking handles and lower infeed table as described in section "INFEED TABLE ADJUSTMENTS".
4. Place a steel straight edge on the outfeed table, extending over the cutterhead as shown in Fig. 24.
5. Carefully rotate the cutterhead by hand. The knives should just touch the straight edge.
6. If the knife is too high or too low at either end, slightly turn the five screws, four of which are shown at (D) Fig. 25, in the knife locking bar clockwise to loosen, using the wrench (E) supplied. Then adjust the height of the knife by turning the knife raising screws (F) Fig. 26, counterclockwise to lower and clockwise to raise the knife. **NOTE: If the knife is to be lowered, it will be necessary to carefully push down on the knife after screws (F) have been turned. WARNING: BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP. IMPORTANT: Tighten knife locking screws (D) after adjustments have been made.**
7. Repeat these procedures for adjusting the two remaining knives if necessary.

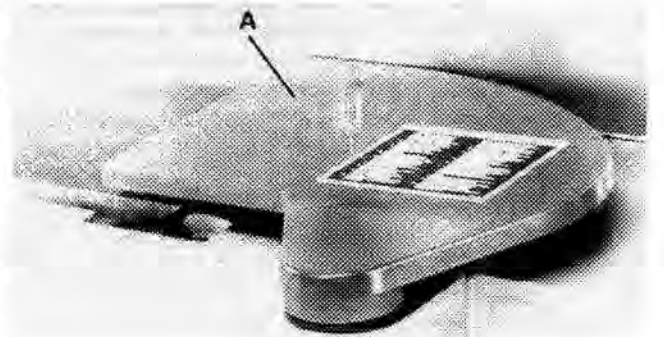


FIGURE 23

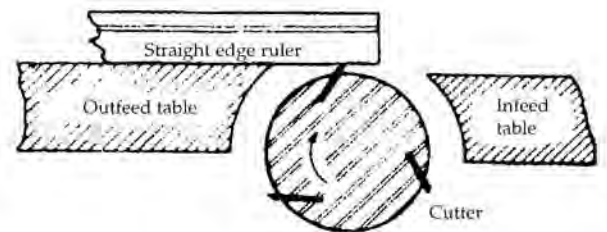


FIGURE 24

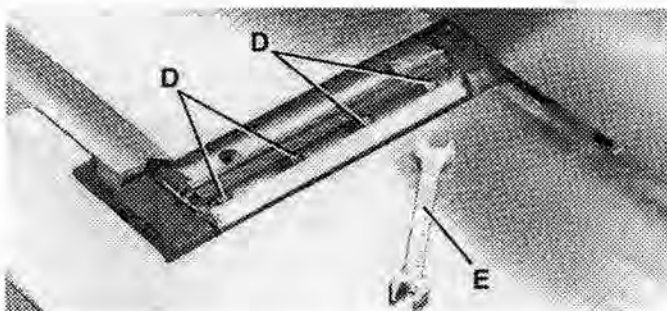


FIGURE 25

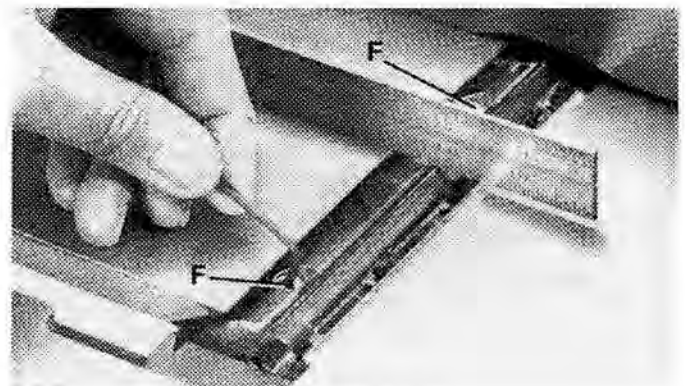


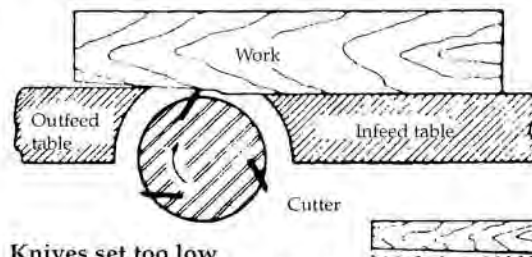
FIGURE 26

OPERATING CONTROLS AND ADJUSTMENTS

8" JOINTER



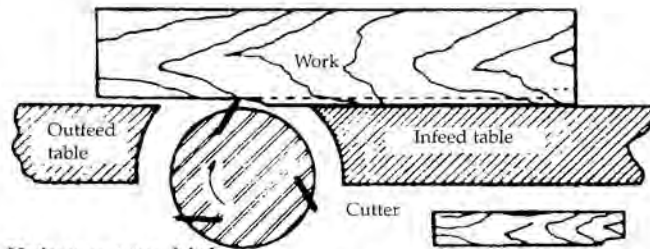
8. If the knives are set too low, the result will be as shown in Fig. 27, and the surface will be curved:



Knives set too low

FIGURE 27

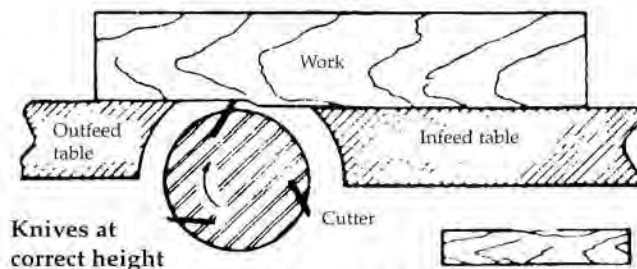
9. If the knives are set too high, the work will be gouged at the end of the cut, as shown in Fig. 28.



Knives set too high

FIGURE 28

10. As a final check, run a piece of work slowly over 6" to 8" over the knives. The work should rest firmly on both tables as shown in Fig. 29, with no open spaces under the finished cut.



Knives at correct height

FIGURE 29

ADJUSTING TABLE GIBS

"Gibs" are provided to take up any play that may develop between the mating dovetail ways of the base and the infeed and outfeed tables, due to excessive wear. The gib for the infeed table is shown at (A) Fig. 30. Proper gib adjustment is necessary for the functioning of the jointer. The gib was adjusted at the factory and should not require any further adjustment. However, if it ever becomes necessary to adjust the gib due to excessive wear, proceed as follows:

1. To adjust the infeed table gib, loosen locking knobs (C) Fig. 31 and (F) Fig. 32. Loosen three lock nuts (B) Fig. 31, and tighten or loosen three adjustment screws (D) as necessary. **NOTE:** Adjust the lower screw first and as you proceed to the upper adjustment screws, gently raise the outboard edge of the table. This will offset any tendency for the table casting to "droop or sag" and permit the gib to be adjusted to the proper fit to the upper adjustment screws. Tighten three lock nuts (B) Fig. 31, and two table locking levers.

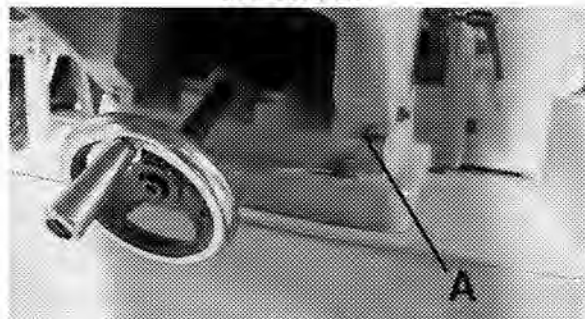


FIGURE 30

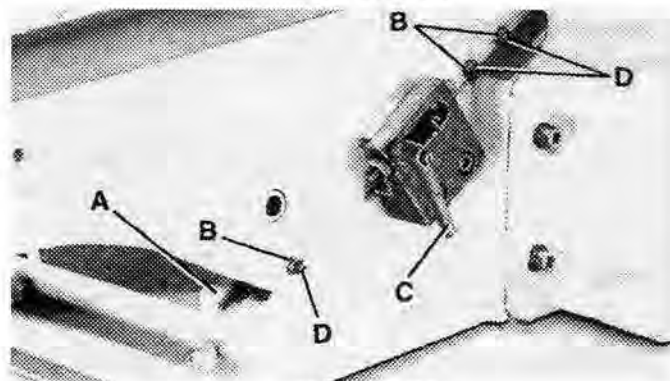


FIGURE 31



OPERATING CONTROLS AND ADJUSTMENTS 8" JOINTER

2. To adjust the out feed table, loosen locking lever (H) Fig. 33. Loosen two lock nuts (E) and tighten or loosen two adjustment screws (G) as necessary. **NOTE:** Adjust the lower adjustment screw first and as you proceed to the upper adjustment screw, gently raise the outboard edge of the table. This will offset any tendency for the table casting to "droop or sag" and permit the gib to be adjusted to the proper fit to the upper adjustment screws. Tighten two lock nuts (E) locking lever (H).

FENCE OPERATION

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

1. To move the fence across the table, loosen locking handle (A) Fig. 34, and turn knob (B) accordingly until the fence is in the desired position; tighten locking handle (A). As the fence is moved across the table, the rear cutterhead guard (C) Fig. 34, extends over the knives in back of the fence for operator safety.
2. To tilt the fence in or out, loose locking handle (D) Fig. 34. While holding fence tilting handle (E) Fig. 35, rotate flip stop (F) and tilt the fence in or out to the desired angle and tighten locking handle (D). **IMPORTANT:** When cutting bevels and the angle is small, there is little difference whether the fence is tilted in or out; however, at angles approaching 45°, it may become difficult to hold the work securely against the fence when it is tilted outward. In this case, we suggest that the fence (G) be tilted toward the table, as shown in Fig. 36. The fence will form a V-shape with the table, and the work is easily pressed into the pocket while passing across the knives.

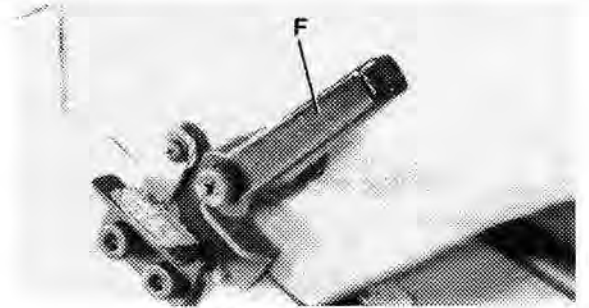


FIGURE 32

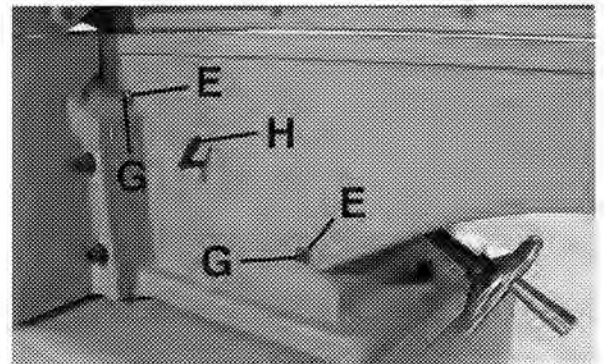


FIGURE 33

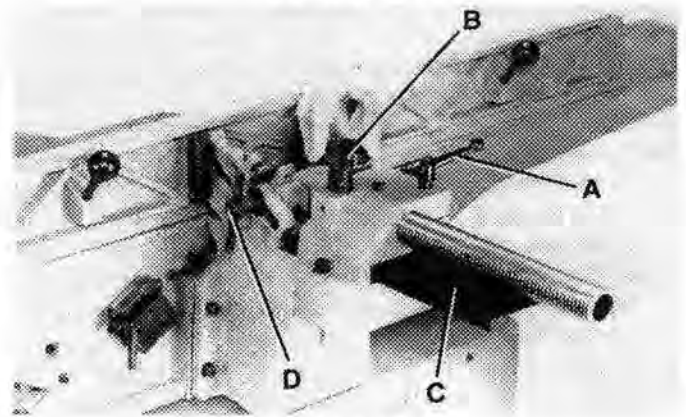


FIGURE 34

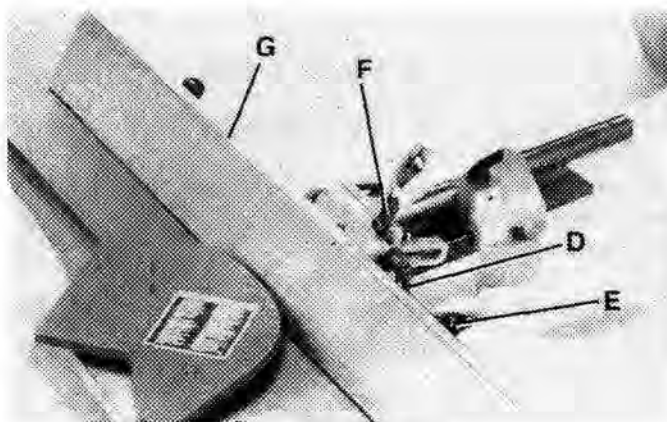


FIGURE 35

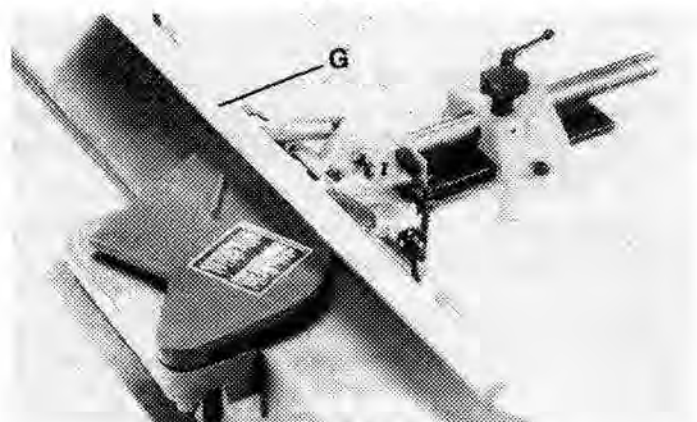


FIGURE 36

OPERATING CONTROLS AND ADJUSTMENTS

8" JOINTER

KING
INDUSTRIAL

ADJUSTING FENCE POSITIVE STOPS

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

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**
2. Position the fence at 90° to the table. Make certain flip stop (F) Fig. 37, is lowered as shown, and adjustment screw (H) is contacting the flip stop (F); then tighten locking handle (D).
3. Place a square (K) Fig. 37, on the table and against the fence, as shown, and check if the fence is 90° to the table.
4. If an adjustment is necessary, loosen locking handle (D) Fig. 37 and lock nut (L). Rotate adjustment screw (F) until you are certain the fence is 90° to the table. Tighten lock nut (L).
5. Rotate flip stop (F) Fig. 38, tilt fence outward as far as it will go and tighten locking handle (D). Place a square (K) on the table and against the fence to check if the fence is 45° outward to the table.
6. If an adjustment to the positive stop is necessary, loosen locking handle (D) Fig. 38, and lock nut (M). Rotate adjustment screw (N) until you are certain the fence is 45° outward the table.
7. Tilt the fence (G) Fig. 39, inward as far as it will go and tighten locking handle (D). Using a square (K) on the table and against the fence, check if the fence is 45° inward to the table.
8. If an adjustment is necessary, loosen lock nut (P) Fig. 39. Rotate screw (R) until you are certain the fence is 45° inward to the table.

REMOVING, REPLACING AND RESETTING KNIVES

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

1. **DISCONNECT THE MACHINE FROM ITS POWER SOURCE.**
2. Move the fence to the rear and remove the cutterhead guard. **WARNING: BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES.**
3. Using wrench (A) Fig. 40, slightly loosen the locking screws, three of which are shown at (B) Fig. 40, in each knife slot by turning the screws (B) clockwise. This relieves stress in the cutterhead.
4. Loosen screws (B) Fig. 40, further and remove knife (C) Fig. 41, and knife locking bar (D).

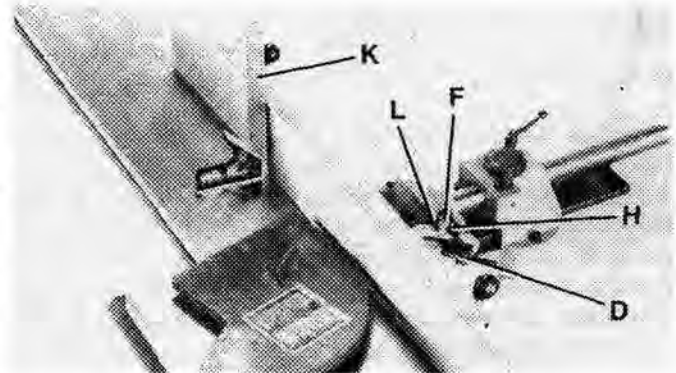


FIGURE 37

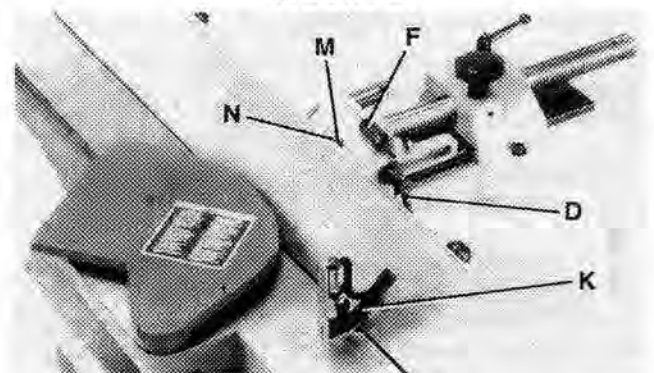


FIGURE 38

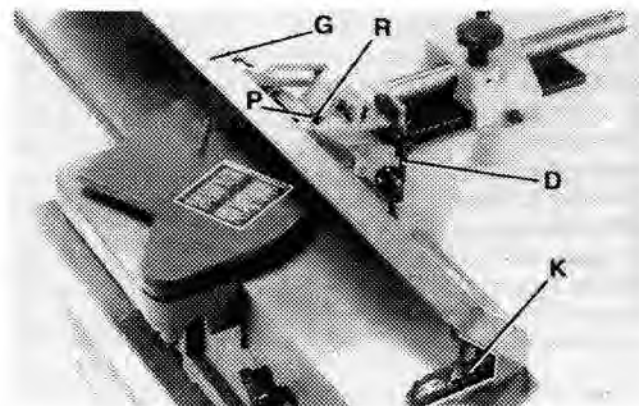


FIGURE 39

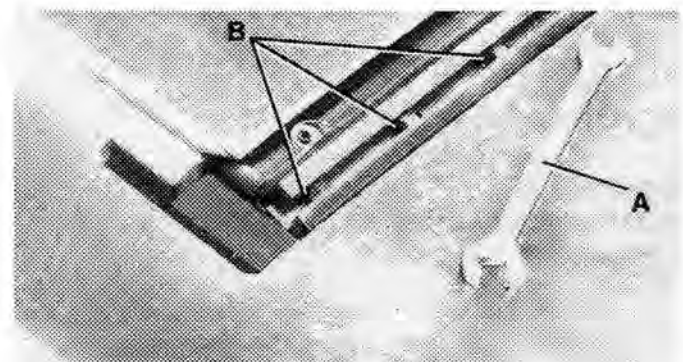


FIGURE 40



OPERATING CONTROLS AND ADJUSTMENTS 8" JOINTER

- Fig. 41 illustrates the knife (C) and knife locking bar (D) removed from the cutterhead. Remove the remaining two knives and locking bars, in the same manner.
- Using wrench supplied, lower the two knife adjustment blocks by turning screws (F) counterclockwise in all three slots of the cutterhead.
- Before replacing knives make certain the knife locking bars are thoroughly clean and free of gum and pitch.
- Replace the knife locking bars (D) Fig. 41, and knives (C) into each slot in the cutterhead. **WARNING: CARE MUST BE TAKEN WHEN INSERTING THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP.** Push the knife down as far as possible and snug up the five screws (B) Fig. 40, three of which are shown, by turning each screw counterclockwise just enough to hold the knife in position. Replace the remaining two knives in the same manner. **NOTE: KNIVES MUST BE INSTALLED CORRECTLY AS SHOWN IN FIG. 42.**
- The knives are adjusted correctly when the cutting edge of the knife extends out 0.060" from the cutterhead diameter.
- Carefully rotate the cutterhead (G) Fig. 43, until the round portion of the cutterhead is on top as shown.
- Place a 0.060" feeler gage (H) Fig. 43, on the cutterhead and using a straight edge (J) on the rear table adjust the height of the rear table until it is 0.060" above the cutting head diameter, as shown.
- Lock the rear table in position and remove the feeler gage.
- Lower the infeed table and place a straight edge (J) Fig. 44, on the out-feed table extending over the cutterhead as shown.
- Rotate the cutterhead by hand until the knife is at its highest point at each end of the cutterhead. To raise the knife, use wrench (E) Fig. 44, and turn raising screw clockwise until the knife just touches the straight edge (J) on each end and center of the cutterhead when the knife is at its highest point. When you are certain the knife is adjusted properly, tighten the five locking screws (B) Fig. 44, three of which are shown, by turning them counterclockwise.
- Adjust the remaining two knives in the same manner. **WARNING: MAKE CERTAIN THAT ALL KNIVES ARE SECURELY FASTENED IN CUTTERHEAD BEFORE TURNING ON POWER.**
- Replace cutterhead guard.

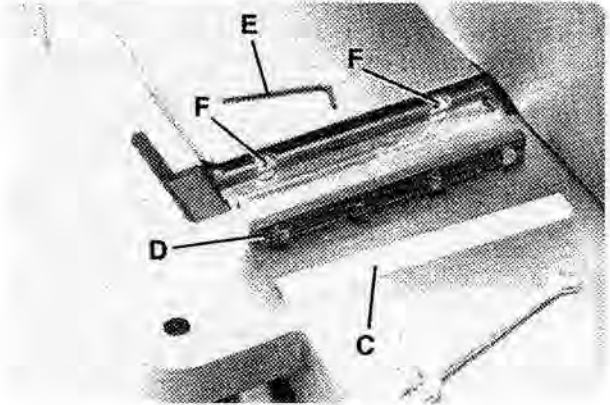


FIGURE 41

Mating surfaces of cutterhead to blade and blade to bar to be tight and parallel

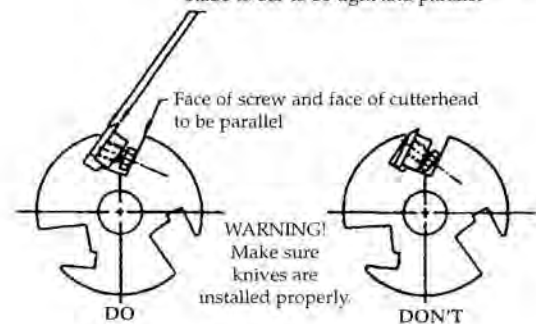


FIGURE 42

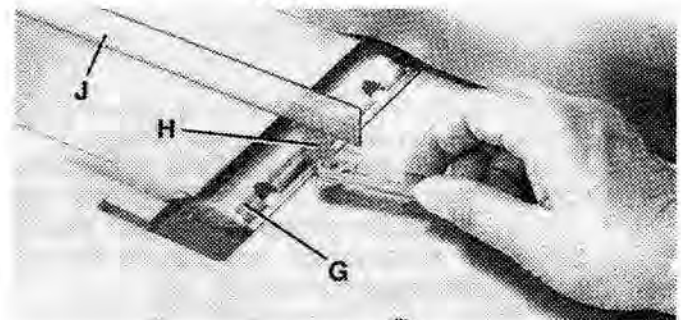


FIGURE 43

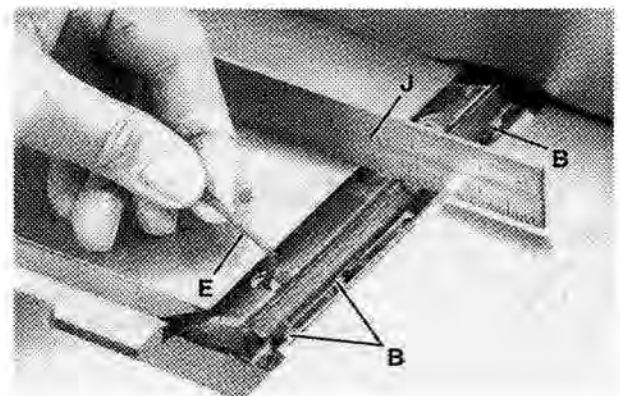


FIGURE 44