



OWNER'S MANUAL

JJ-8CS Woodworking Jointer



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This manual has been prepared for the owner and operators of a JET JJ-8CS. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your jointer, and to aid in using the machine safely, read this manual thoroughly and follow all instructions carefully.

Warranty & Service

The JET Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these JET Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Performax or Powermatic tools.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848.

More Information

Remember, the JET Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local JET Group distributor.

JET Group Warranty

The JET Group (including Performax and Powermatic brands) makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

THE JET GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE, FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. THE JET GROUP SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

The JET Group sells through distributors only. Members of the JET Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

⚠ WARNING

Wear eye protection.

Always keep cutterhead and drive guards in place and in proper operating condition. Do not remove guard for rabbeting operations.

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

Always use hold-down/push blocks for jointing material narrower than 3", or planing material thinner than 3".

Never perform jointing, planing, or rabbeting cuts (with jointers provided with a rabbeting guard) on pieces shorter than 8" (203mm) in length.

- Keep guards in place and in working order.
- Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
- Keep the work area clean. Cluttered areas and benches invite accidents.
- Don't use in a dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- Keep children away. All visitors should be kept a safe distance from the work area.
- Make the workshop kidproof with padlocks, master switches, or by removing starter keys.
- Don't force the machine. It will do the job better and safer at the rate for which it was designed.
- Use the right tool. Don't force a machine or attachment to do a job for which it was not designed.
- Use the proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw. An undersized cord will cause a drop in the line voltage resulting in power loss and overheating. The following table shows the correct size to use depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. Remember, the smaller the gauge number, the heavier the cord.

Volts	Total Length of Cord in Feet			
	120V	25	50	100
240V	50	100	200	300
	AWG			
	14	12	Not Recommended	

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- Always use safety glasses. Also use a face or dust mask if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
- Secure work. Use clamps or a vise to hold the work when practical. It's safer than using your hands and it frees both hands to operate the tool.

- Don't overreach. Keep proper footing and balance at all times.
- Maintain tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- Always disconnect the machine from the power source before servicing.
- Reduce the risk of unintentional starting. Make sure the switch is in the off position before plugging in.
- Use recommended accessories. Consult the operator's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
- Never stand on a machine. Serious injury could occur if the machine is tipped or if the blade is unintentionally contacted.
- Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- Direction of feed. Feed work into the blade against the direction of rotation of the blade only.
- Never leave the machine running unattended. Turn power off. Don't leave the machine until it comes to a complete stop.
- Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - * Lead from lead-based paint.
 - * Crystalline silica from bricks and 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 specifically designed to filter out microscopic particles.

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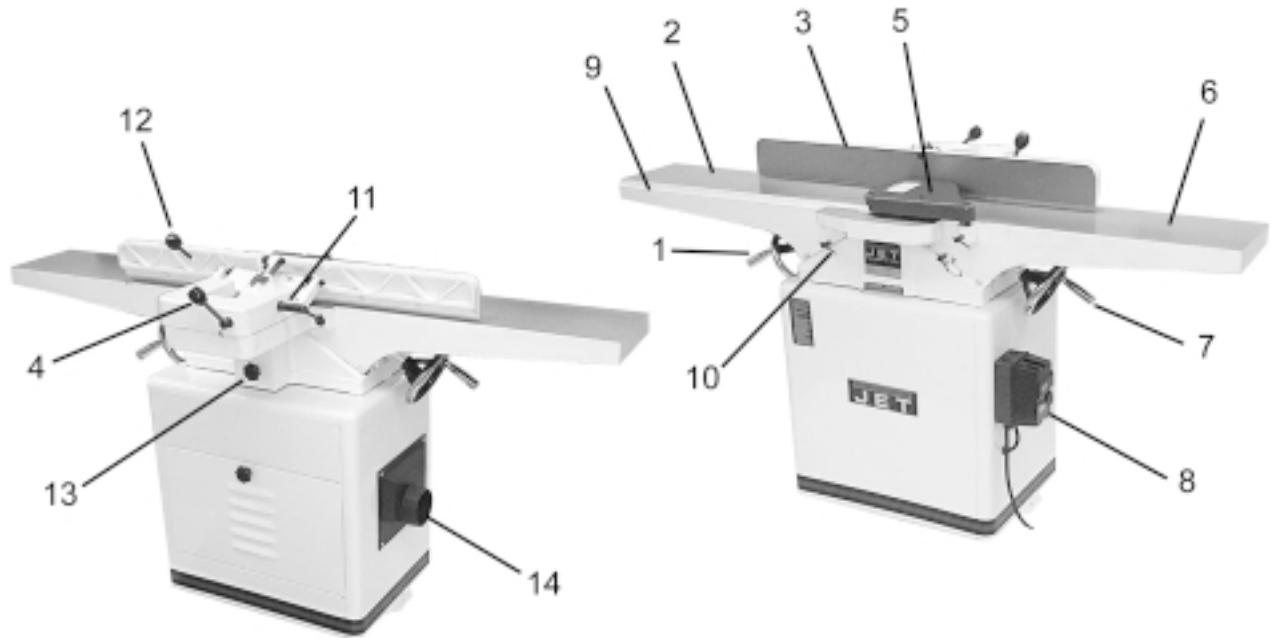
Introduction

The JET JJ-8CS woodworking jointer you have purchased is a high quality machine tool that will give you years of superior service. You will get maximum performance and enjoyment from your new jointer if you will take a few moments now to review the entire manual before beginning assembly and operation. Become familiar with the details of operation and be sure to review the controls page to start to become familiar with some of the unique words associated with a jointer.

The JET JJ-8CS jointer, as well as all JET products, are backed by a nationwide network of authorized distributors and/or service centers. Please contact your nearest distributor should you require parts or service. Parts are also available directly from JET by calling 1-800-274-6848.

Now that you have purchased a jointer, it is a good time to consider a dust collection system. See your local JET distributor for the complete line of dust collectors and the full line of JET Dust Collector Hoses and Accessories. Customize your installation and obtain maximum performance with JET's dust hoods, hoses, clamps, fittings, and blast gates.

Levers and Controls



- | | |
|--------------------------------|----------------------------|
| 1. Handwheel for Outfeed Table | 8. On/Off Switch |
| 2. Outfeed Table | 9. Rabbeting Ledge |
| 3. Fence | 10. Table Lock Knob |
| 4. Fence Adjustment Handle | 11. Fence Tilt Lock Handle |
| 5. Cutter Guard | 12. Fence Control Handle |
| 6. Infeed Table | 13. Belt Guard |
| 7. Handwheel for Infeed Table | 14. Dust Chute |

Specifications:

JJ-8CS

Stock Number	708458K
Cutting Capacity	8" W x 1/2" D
Cutterhead Speed	5,500 RPM
Number of Knives	3
Rabbeting Capacity	1/2"
Table Surface	9" W x 66-1/2" L
Fence	4" W x 38-1/2" L
Blade Size	8" x 11/16" x 1/8"
Fence Tilts Right and Left	45°
Positive Stops	45°, 90°
Motor	2 HP, 1 Ph, 230V Only
Net Weight (approx.)	398 lbs.
Shipping Weight (approx.)	470 lbs.

The specifications in this manual are given as general information and are not binding. JET Equipment and Tools reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Contents of Shipping Cartons

Note: unit shipped in two cartons.

Stand Carton

1. Stand with Motor
1. Stand Door
1. Dust Chute w/ Mounting Hardware

Main Unit Carton

1. Bed Assembly w/ Fence
1. Cutter Guard
3. Mounting Bolts
3. 3/8" Lock Washers
1. Belt Guard
3. Hex Wrenches (3, 4 & 5mm)
2. Handwheels
2. Handles
2. V-Belts
1. Can of Touch-Up Paint
1. 8/10mm Open End Wrench
1. 12/14mm Open End Wrench
1. Owner's Manual
1. Knife Gauge Assembly
1. Warranty Card



Tools Required for Assembly

#1 Cross Point Screw Driver

6-8" Adjustable Wrench or 17 and 19mm Wrench

Unpacking and Cleanup

1. Carefully remove all contents from both shipping cartons. Compare contents of the shipping cartons with the list of contents above. Place parts on a protected surface.
2. Report any shipping damage to your local distributor.
3. Clean all rust protected surfaces (bed, fence, etc.) with kerosene or diesel oil. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.



CAUTION

**Cutterhead blades are extremely sharp!
Use care when cleaning!**

4. Apply a thin layer of paste wax to the bright surfaces of the fence and tables to prevent rust.
5. Set packing material and shipping cartons to the side. Do not discard until machine has been set up and is running properly.

Installing Bed to Stand

1. Use an assistant or hoist mechanism to place bed assembly on top of stand. Be sure identification label on the bed faces the same direction as the label on the stand (Fig. 1).
2. Line up two holes in top of stand with holes in bed assembly by viewing through access door in stand.
3. Attach bed assembly to stand with two 3/8" lock bolts and lock washers (Fig. 2). Hand tighten only at this time.
4. Line up third hole in stand with hole in bed assembly by viewing through dust chute.
5. Install third 3/8" lock bolt and lock washer through dust chute to secure bed to stand.
6. Tighten all three mounting bolts with 14mm wrench.



Fig. 1



Fig. 2

Installing Handwheels

1. Remove protective tape from shaft, and remove screw and washer.
2. Press handwheel (A, Fig. 3) onto shaft, aligning the key way with the key. If necessary, use a hammer with a block of wood to tap the handwheel completely onto the shaft.
3. Re-install screw and washer (B, Fig. 3).
4. Mount handle (C, Fig. 3) onto handwheel.

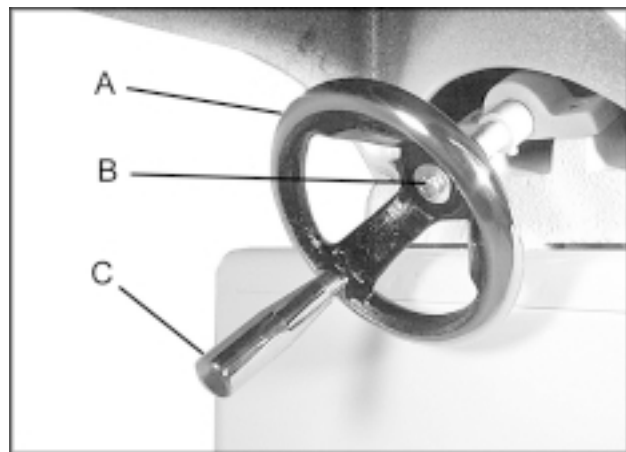


Fig. 3

Assembling Knife-Setting Gauge

1. Place the two bases (A, Fig. 4) onto each end of the bar (B, Fig. 4). Snap the four E-rings (C, Fig. 4) into the grooves on the bar as shown.

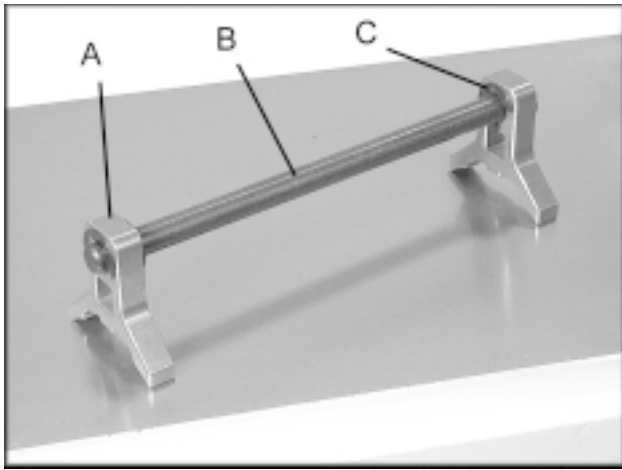


Fig. 4

90° Fence Adjustment

Note: whenever making an adjustment to the fence, lift the fence up slightly after releasing the lock handle to avoid scratching the table.

1. Set infeed table to the same height as the outfeed table.
2. Move the fence by releasing lock handle (A, Fig. 5) and pushing the fence assembly until it overlaps the tables.
3. Adjust the fence to a 90° angle by releasing lock handle (B, Fig. 5), pulling up on handle (C, Fig. 5), and re-tightening lock handle (B, Fig. 5).
4. Place a combination square on the infeed table. (Fig. 6)
5. If fence is not square to table, release lock handle (B, Fig. 5), loosen nut (D, Fig. 5), and turn bolt (E, Fig. 5) until fence is square to table.
6. Tighten nut (D, Fig. 5) to retain the setting. Tighten lock handle (B, Fig. 5).

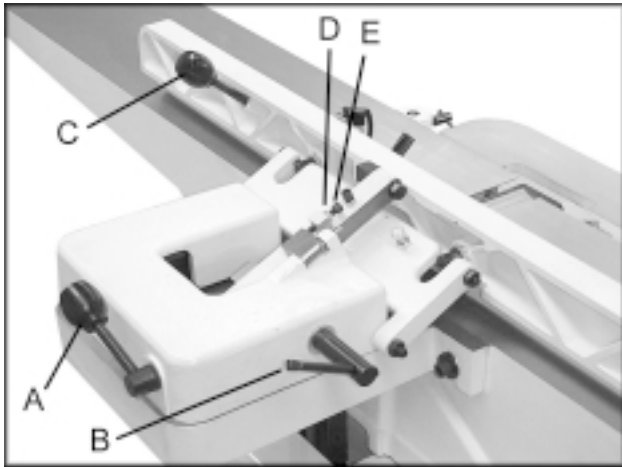


Fig. 5



Fig. 6

45° Fence Adjustment

Note: Whenever making an adjustment to the fence, lift the fence up slightly after releasing the lock handle to avoid scratching the table.

1. Loosen lock handle (A, Fig. 7). Move the stop plate (B, Fig. 7) out of the way and position the fence at the 45° angle. Make sure the fence sits against the stop bolt (C, Fig. 7).
2. Place a combination square (D, Fig. 7) on the fence and table to confirm a 45° setting.
3. To adjust, loosen lock nut (E, Fig. 7), turn bolt (C, Fig. 7) until a 45° angle is obtained, and tighten lock nut (E, Fig. 7). Tighten lock handle (A, Fig. 7).

4. Position of the table and straight edge should look like figure 9. Use care when handling the straight edge near the blades so as not to damage them.

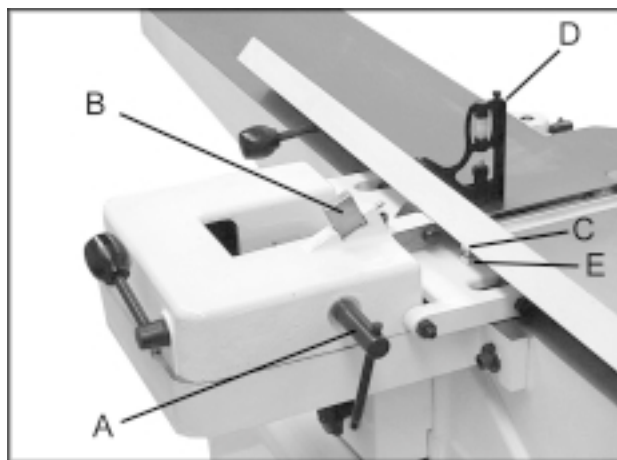


Fig. 7

Leveling Outfeed Table with Cutterhead Knives

⚠ WARNING

Machine should be disconnected from power source at this time!

Cutterhead blades are extremely sharp!

Use caution when hands are near the cutterhead!

Failure to comply may cause serious injury!

For most jointing operations, the surface of the outfeed table must be level with the knife tips of the cutterhead at their highest point of revolution. The knife tips must project equally from the cutterhead.

The outfeed table and cutterhead are adjusted at the factory and should not require adjustment.

1. Carefully number each blade with a magic marker to make them easier to differentiate.
2. Rotate the cutterhead by turning the cutterhead pulley and determine the 12 o'clock position of knife number one. The 12 o'clock position is the highest point a blade will reach in the cutting arc.
3. Loosen table lock screw (A, Fig. 8) and raise the outfeed table to the height of blade number one by turning handwheel (B, Fig. 8). Counter-clockwise will cause the outfeed table to raise. Clockwise will cause the outfeed table to lower. Set a straight edge (C, Fig. 8) on the outfeed table and across the cutterhead.

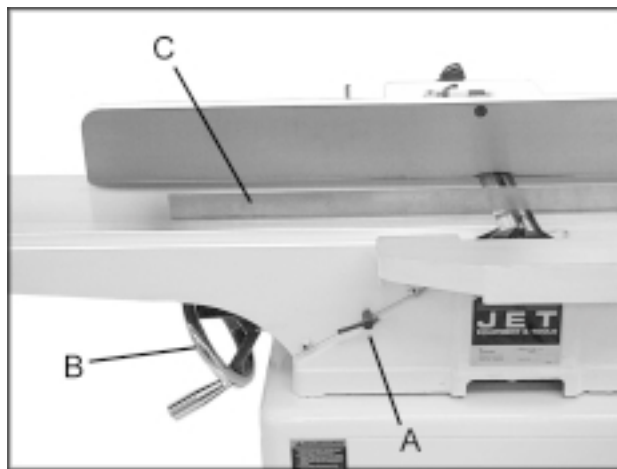


Fig. 8

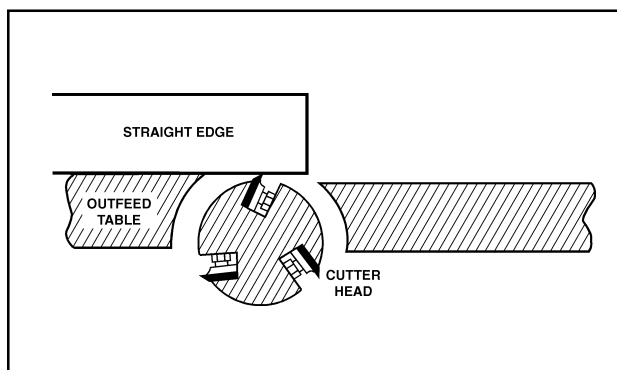


Fig. 9

5. When the outfeed table and blade number one are the same height, tighten table lock screw.
6. The knives must be parallel with the outfeed table. Bring the straight edge forward to the front of the outfeed table and confirm that blade number one is at the same height at the front of the table as it is at the back of the table.
7. If blade is higher or lower at one point, slightly loosen five screws (A, Fig. 10) by turning clockwise as viewed from the infeed table.

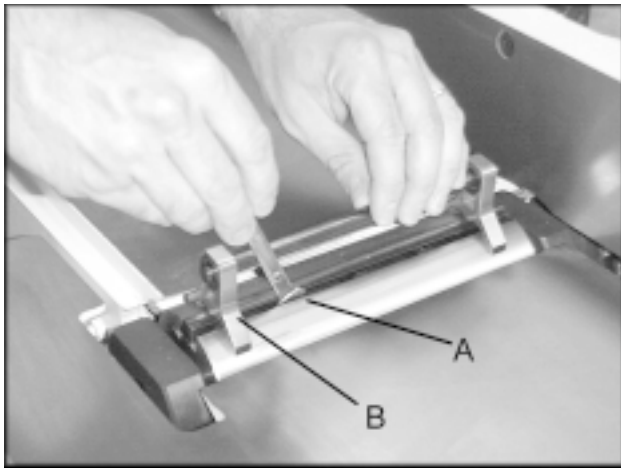


Fig. 10

8. Place the knife setting gauge (B, Fig. 10) on the cutterhead over the blade. Continue loosening the five screws until the springs push the knife up into contact with the gauge. Alternately tighten the five screws to hold each blade in place.
9. Repeat this process with blades two and three. **The outfeed table and cutterhead knives are correctly adjusted when all three blades are parallel to the outfeed table and all three blades are set at the same height in the cutterhead.**

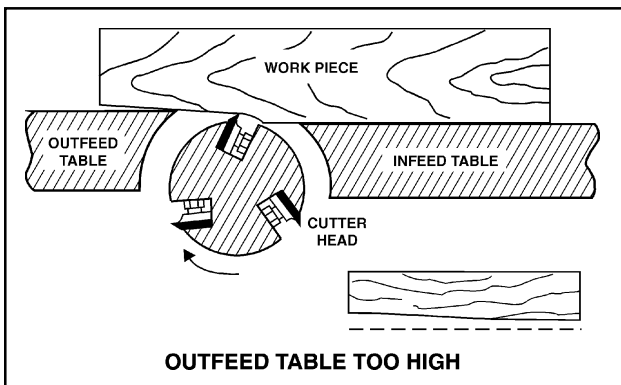


Fig. 11

After the outfeed table has been set at the correct height, do not change it except for special operations or after replacing the knives.

If the outfeed table is set too high, a curved finished surface results. (Fig. 11)

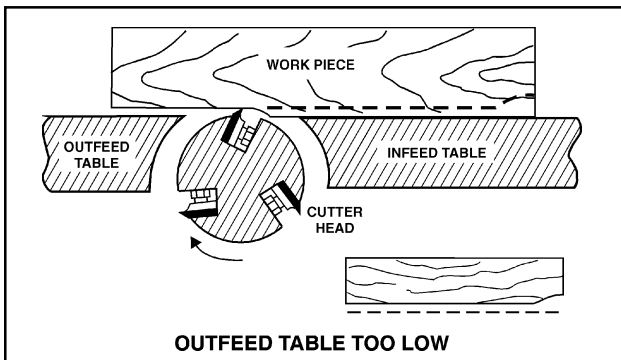


Fig. 12

If the outfeed table is set too low, gouging results at the end of the cut. (Fig. 12)

Figure 13 illustrates the outfeed table at the correct height.

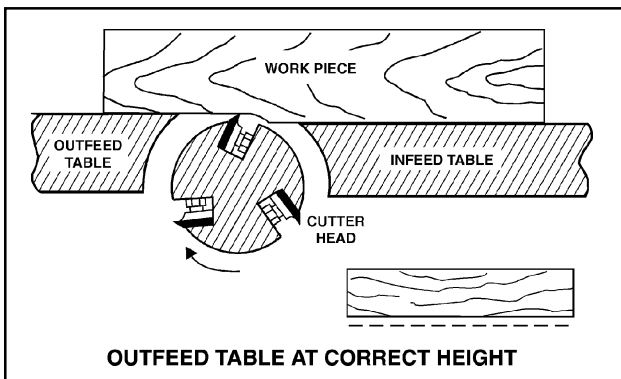


Fig. 13

Installing V-Belts

1. **Disconnect the machine from the power source, unplug.**
2. Remove the lock knob (A, Fig. 14) and belt guard (B, Fig. 14).
3. Place v-belts onto cutterhead pulley grooves and through opening in stand.
4. Pull v-belts down and place onto motor pulley (Fig. 15). If necessary, loosen the mounting screws (A, Fig. 15) and slightly lift motor. Re-tighten the screws when belt is placed.
5. Check to make sure that motor pulley and cutterhead pulley are vertically aligned and the v-belt does not contact the sides of the opening in the base. If the pulleys are not aligned, loosen the screws (A, Fig. 15) on the motor base and slide the motor until the belt is aligned. Re-tighten screws.
6. The v-belt is properly tensioned when finger pressure on the belt half way between the two pulleys causes 1/2" deflection. If the belt is too loose, loosen the lower screws (B, Fig. 15) on the mounting plate and push down on the plate. When belt tension is correct, re-tighten screws.
7. After two hours of operation, check belt tension again. Re-tension if necessary.
8. Re-install belt guard and lock knob.

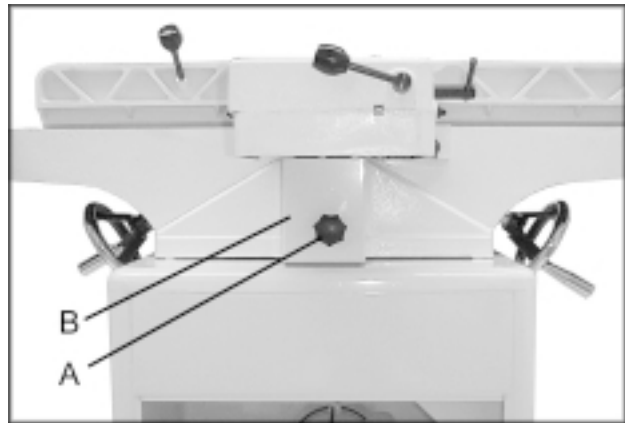


Fig. 14

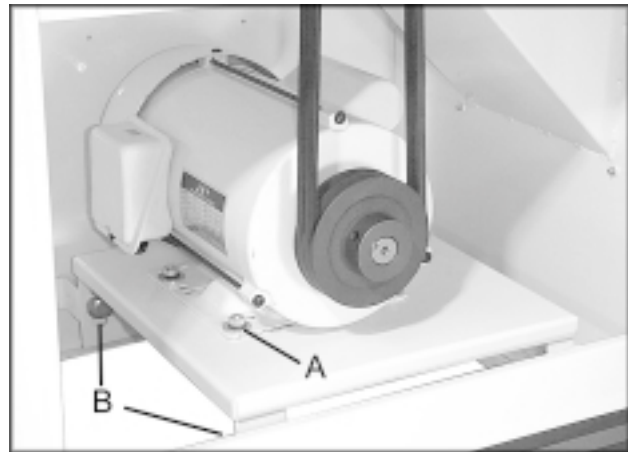


Fig. 15

Installing Cutterhead Guard

1. Orient guard (Fig. 16) in proper position and insert post into hole in table. Tighten lock screw (A, Fig. 16).



Fig. 16

Installing Access Cover

1. Install access cover by placing bottom of panel into access in stand and fastening by turning latch (Fig. 17).

If the access door latch needs adjustment:

1. Remove the access door from the stand.
2. Loosen the hex lock nut (A, Fig. 17). Rotate the latch a quarter turn clockwise to tighten and counterclockwise to loosen.
3. Tighten the lock nut (A, Fig. 17).
4. Re-install the access door.

Installing Dust Chute

1. Attach the dust chute (Fig. 18) to the stand with four screws and four flat washers, through the pre-tapped holes in the stand.

Electrical Connections

WARNING

All electrical connections must be done by a qualified electrician! Failure to comply may result in serious injury!

Remove the cover of the electrical box (A, Fig. 19) and mount the box to the right side of the stand using the two screws provided. Insert the motor leads through the hole in the stand as shown, and insert a grommet (B, Fig. 19). Consult the wiring diagram on page 28 when wiring.

The JJ-8CS jointer is rated at 230V, single phase only. Confirm that the power at the source is compatible with the jointer before inserting plug into the outlet. The jointer is designed to be used with a plug and outlet as in Fig. 20.

Important: Make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.



Fig. 17

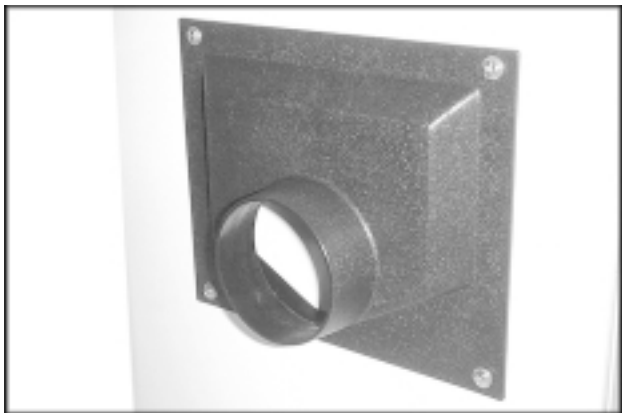


Fig. 18

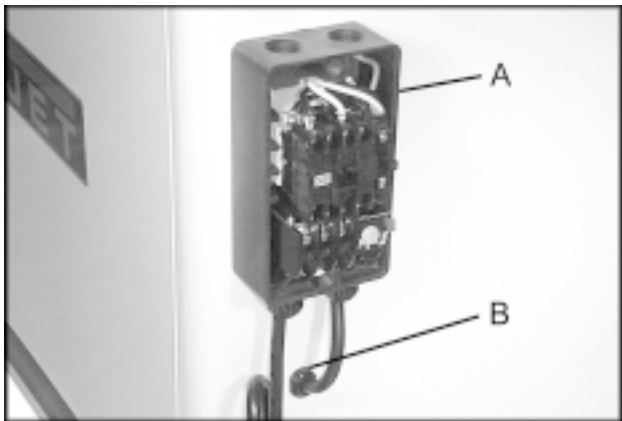


Fig. 19

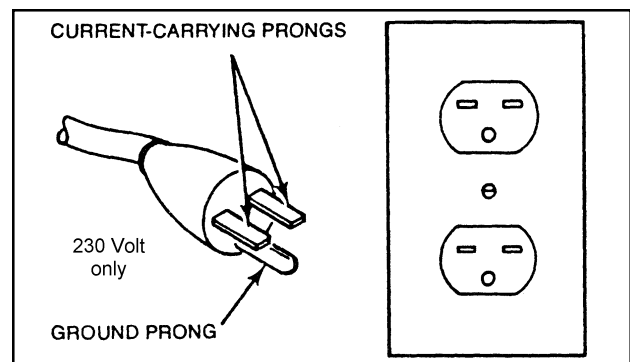


Fig. 20

Operation

WARNING

Keep all guards in place and in adjustment at all times during the cutting procedure!
Keep hands away from the cutterhead! Do not pass hands directly over the cutterhead!
The use of push sticks and/or handle pads are highly recommended when using the jointer!
Failure to comply may cause serious injury!



Fig. 21

Jointing cuts or edge jointing are made to square an edge of a workpiece. The workpiece is positioned on the jointer with the narrow edge of the workpiece on the infeed table and the major flat surface of the workpiece against the fence (Fig. 21).

Planing cuts are similar. The major surface of the workpiece is placed on the table with the narrow edge of the workpiece against the fence (Fig. 22).

For jointing and planing cuts pressure is directed three ways; into the fence to ensure a square cut, forward to advance the stock, and downward to avoid chatter and vibration.

For jointing when the material is higher than the fence, the left hand applies pressure into the fence and down toward the table while the right hand pushes forward from behind. Be sure to keep the right hand high up on the material. (Fig. 21)

For jointing material that is lower than the fence, use push sticks to protect the hands. For planing, use handle pads. (Fig. 22) **Never place the right hand on the trailing edge of the material. Hand placement on the trailing edge of the material may cause the hand to come into contact with the blade.**

Feed work from right to left at a steady, moderate speed. If you feed the material too slowly, the wood will burn in places. If you feed the material too quickly, ridges will appear in the finished surface.



Fig. 22

Jointing Warped Material

If the work to be jointed is cupped or warped, take light, repetitive cuts until the surface is flat. Forcing the material flat against the table will still leave a warped piece after the cuts have been made.

WARNING

Never joint any material shorter than eight inches!

The material may tip into the jointer's throat and be kicked back!

Avoid jointing thin material which could become jammed under the fence or blade guard!

Failure to comply may cause serious injury!

Direction of Grain

Feed the material with of the grain to avoid tearout (Fig. 23). If the direction of the grain changes somewhere in the board, try reducing depth of cut and slow the feed speed down to avoid tearout. If results still aren't satisfactory, turn the material around and try feeding through the other way.

Bevel Cut

To cut a bevel, lock the fence at the desired angle and run the material through, pressing the work firmly against the fence and tables (Fig. 24). Several passes may be necessary for the desired result.

Taper Cut

WARNING

Taper cuts require the removal of the cutterhead guard. Use extreme caution when making taper cuts and replace the guard immediately after completion!

Failure to comply may cause serious injury!

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

Instead of laying the piece down on the infeed table, lower the forward end of the work onto the outfeed table. Use caution, however, as the piece will span

the knives, and they will take a "bite" from the work with a tendency to kick back unless the piece is held firmly. Push the work forward as in ordinary jointing. The effect is to plane off all the stock in front of the knives to an increasing depth, leaving a tapered surface.

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

Practice is required in this operation. Beginners are advised to make trial cuts with scrap material.

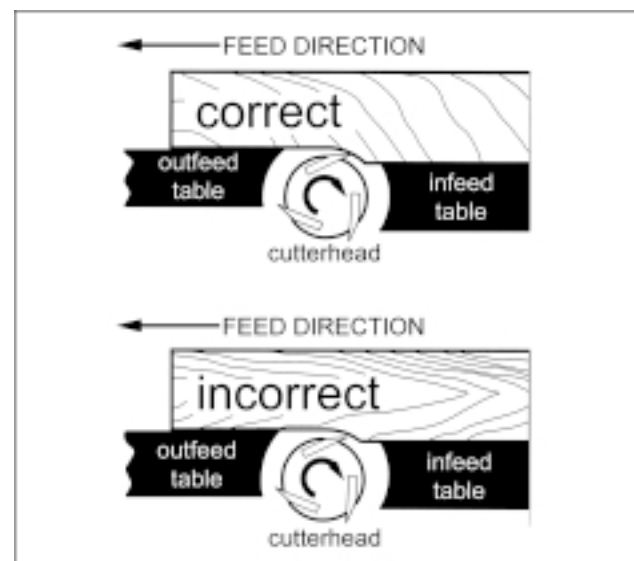


Fig. 23



Fig. 24

Rabbet Cut

WARNING

Rabbeting requires the removal of the cutterhead guard. Use extreme caution when making rabbeting cuts and replace the guard immediately after completion! Failure to comply may cause serious injury!

1. Adjust the fence so that the distance between the end of the knives and fence is equal to the width of the rabbet (Fig. 25).
2. Lower the infeed table an amount equal to the depth of the rabbet. If the rabbet is quite deep, it may be necessary to cut in two or more passes.
In that event, the table is lowered an amount equal to about half the depth of the rabbet for the first pass, then lowered again to proper depth to complete the cut.

Removing and Replacing Knives

WARNING

Disconnect the machine from the power source before making any adjustment or repair!

All knife lock bolts must be firmly tightened or risk ejection of the knife(s) and lock bar from the cutterhead!

Failure to comply may cause serious injury!

1. **Disconnect machine from the power source.**
2. Remove blade guard by loosening lock screw (A, Fig. 26) and lifting up on blade guard. **Caution: blades are sharp! Use great care when hands are around blade area!**
3. Loosen the five lock screws (Fig. 27). **Note:** Loosen screws by turning in a clockwise direction as viewed from the infeed table. Carefully remove the knife (A, Fig. 28), and the lock bar with screws (B, Fig. 28). Repeat for the other two blades.
4. Before assembly, clean all parts thoroughly and clear cutterhead knife slots of any dust or debris.
5. Insert knife into the cutterhead channel making sure it faces the proper direction.



Fig. 25



Fig. 26

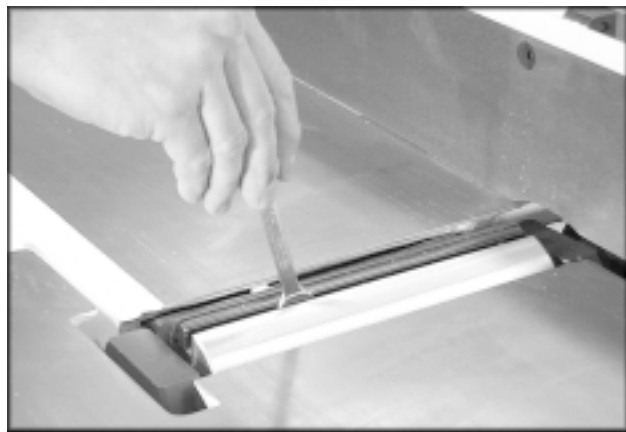


Fig. 27

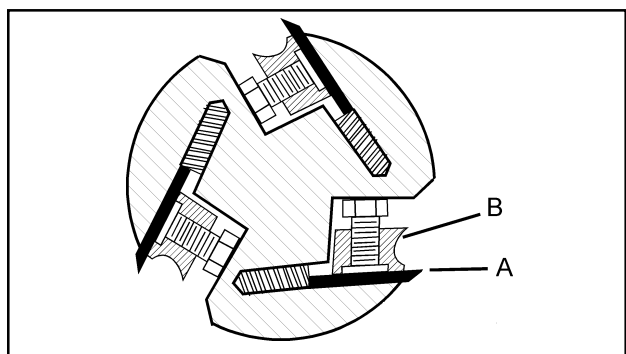


Fig. 28

6. Insert lock bar and screws and tighten to hold in place. Blades are set at the proper height when the top of the blade is 1/16" above the cutterhead.
7. Repeat for other two blades.
8. To set the knives to the outfeed table and to the same height in the cutterhead, see section titled "Leveling Outfeed Table to Cutterhead Knives" found on page 10 of this manual.

Gib Adjustment

After a period of use, the gibs may become loose and need adjusting:

1. Loosen three lock nuts (A, Fig. 29) and gib lock screw (B, Fig. 29)
2. Tighten each set screw 1/4 turn starting at the bottom and working up. If a 1/4 turn does not remove all play, take another 1/4 turn. Repeat a 1/4 turn at a time for all three set screws until play is removed.
3. Tighten lock screw (B, Fig. 29) and lock nuts (A, Fig. 29).

Lubrication

1. Use a good grade of light grease on the steel adjusting screws located in the raising and lowering mechanisms of the work tables.
2. Occasionally, apply a few drops of light machine oil to the gibs. This permits the tables to slide freely.
3. The cutterhead ball bearings are lifetime lubricated and need no further care.

Blade Care

 **WARNING**

Blades are extremely sharp! Use caution when cleaning or changing. Failure to comply may cause serious injury!

When gum and pitch collect on the blades, carefully remove with a strong solvent. Failure to remove gum and pitch build-up may result in excessive friction and overheating.

When blades become dull, touch up blades. See "Sharpening the Knives" on page 18.

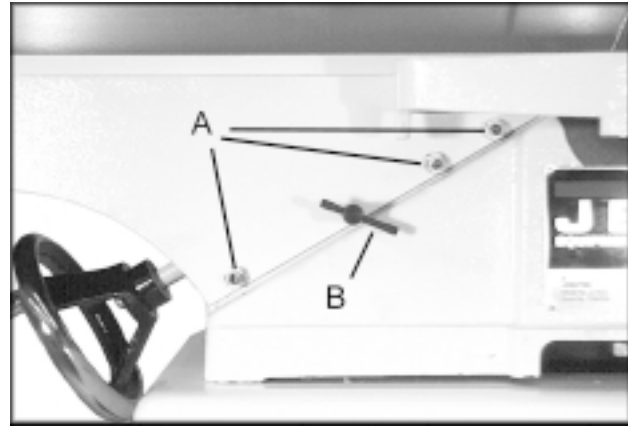


Fig. 29

Sharpening the Knives

WARNING

Blades are extremely sharp! Use caution when handling. Failure to comply may cause serious injury!

1. **Disconnect the machine from the power source.**
2. Remove the fence, blade guard and belt cover.
3. To protect the infeed table from scratches, partially cover the sharpening stone with paper. (Fig. 30)
4. Lay the stone on the infeed table.
5. Lower the infeed table and turn the cutterhead by turning the cutterhead pulley. The infeed table height is set properly when the stone's surface is flush with the knife bevel.
6. Keep the cutterhead from rotating by grasping the cutterhead pulley while sliding the stone back and forth across the table.
7. Take the same amount of passes for all three blades.

When the blades have been sharpened and still are not cutting efficiently, trying to touch up the blades further will only cause the formation of a second beveled edge. When this starts to happen, it is time to replace blades with another set.

It is recommended to keep a second set of blades on hand so that they may be installed while the first set is being professionally sharpened.

Cutterhead Removal

WARNING

Blades in the cutterhead are sharp! Use extreme caution when handling the removal of the cutterhead. Failure to comply may cause serious injury!

The entire cutterhead assembly may be removed for cleaning or for bearing and blade replacement. Some woodworkers keep a spare cutterhead with replacement blades should the original cutterhead have to be repaired.

To remove the cutterhead (including bearings, studs, and housing) from the base casting:

1. **Disconnect the machine from the power source.**
2. Remove the fence assembly, cutterhead guard, and belt guard.
3. Remove the v-belt from the cutterhead pulley.
4. Loosen set screw (A, Fig. 31) using a hex wrench and remove the cutterhead pulley (B, Fig. 31) and key (C, Fig. 31).
5. Remove nuts (D, Fig. 31) and lock washers (E, Fig. 31).
6. Lift assembly straight up. Studs (F, Fig. 31) will still be attached to the bearing housings.
7. Before replacing the cutterhead back into the casting, thoroughly clean the "saddle" and the bearing housings of saw dust and grease so that they seat properly.
8. To re-install the cutterhead, reverse the above steps.

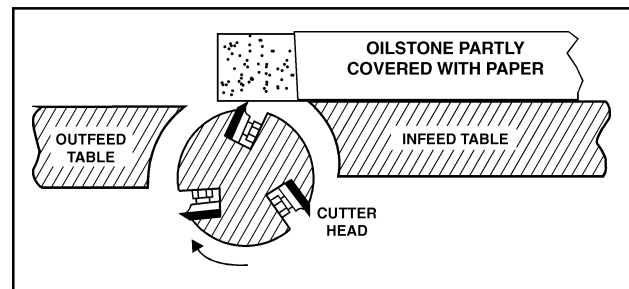


Fig. 30

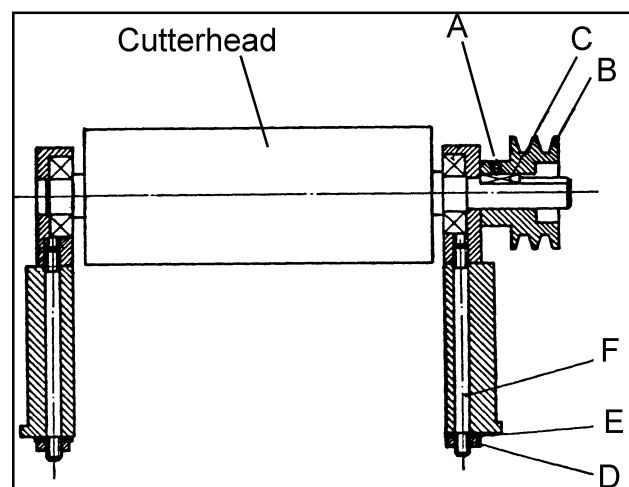
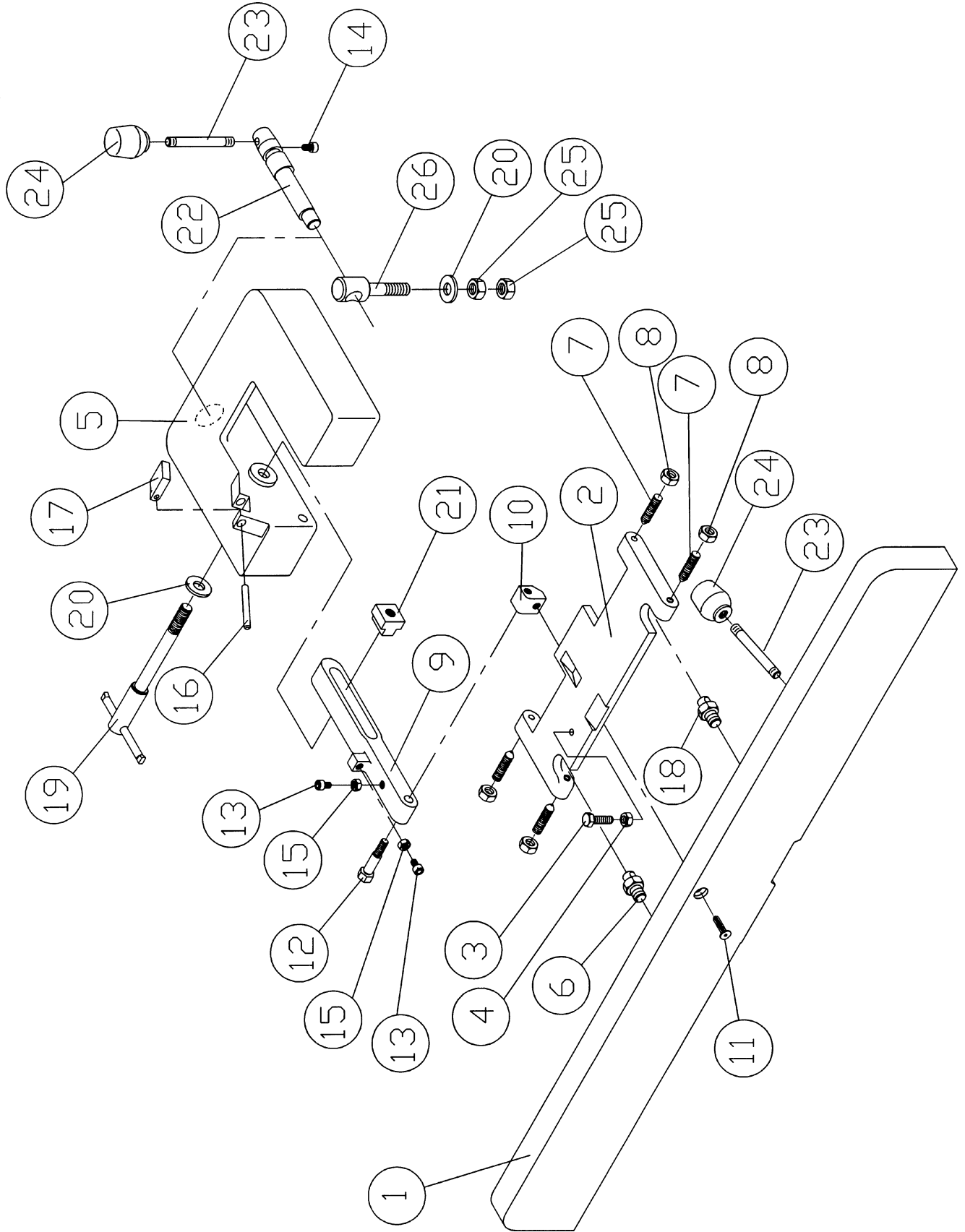


Fig. 31

Trouble-shooting

Trouble	Possible Cause	Solution
Finished stock is concaved on the end.	Knife tip is higher than the outfeed table.	Raise outfeed table so it is level with knife tip.
Back side of finished stock is thicker than the front side.	Outfeed table is higher than knife tip.	Adjust outfeed table so it is level with knife tip.
Stock is concave in the middle.	Table flatness should be checked with a machinist's square.	Adjust the screws below the table to raise the table ends.
Both ends of finished stock are cut deeper than the middle.	Ends of tables are higher than middle.	Raise table ends with adjustment screws below tables.
Infeed or outfeed tables are loose.	Loose gib.	Tighten gibs.
Ripples on planed surface. Kickbacks	<ol style="list-style-type: none"> 1. One blade set higher than the others. 2. Feeding wood too fast. 3. Cutting blades are set too high above outfeed table, or they may not be level with outfeed table. 	<ol style="list-style-type: none"> 1. Readjust blades. 2. Feed wood slower. 3. Readjust blades.
Excessive motor noise.	<ol style="list-style-type: none"> 1. Motor 2. Pulley set screw is loose. 	<ol style="list-style-type: none"> 1. Have motor checked by a qualified repair station. 2. Tighten set screw.
Motor fails to develop full power, or stalls.	<ol style="list-style-type: none"> 1. Circuit overloaded with lights, tools, etc. 2. Undersize wires or circuit too long. 3. Voltage too low. 4. Fuses or circuit breakers do not have sufficient capacity. 	<ol style="list-style-type: none"> 1. Do not share the circuit. 2. Increase wire sizes, or reduce length of wiring. 3. Request voltage check from the power company. 4. Have a qualified electrician install proper size fuses or circuit breakers.
Motor starts slowly or fails to come to full speed.	<ol style="list-style-type: none"> 1. Motor 2. Belt tension too tight. 3. Bad start capacitor. 	<ol style="list-style-type: none"> 1. Have motor checked by a qualified repair station. 2. Adjust belt tension. 3. Replace start capacitor.

Fence Assembly

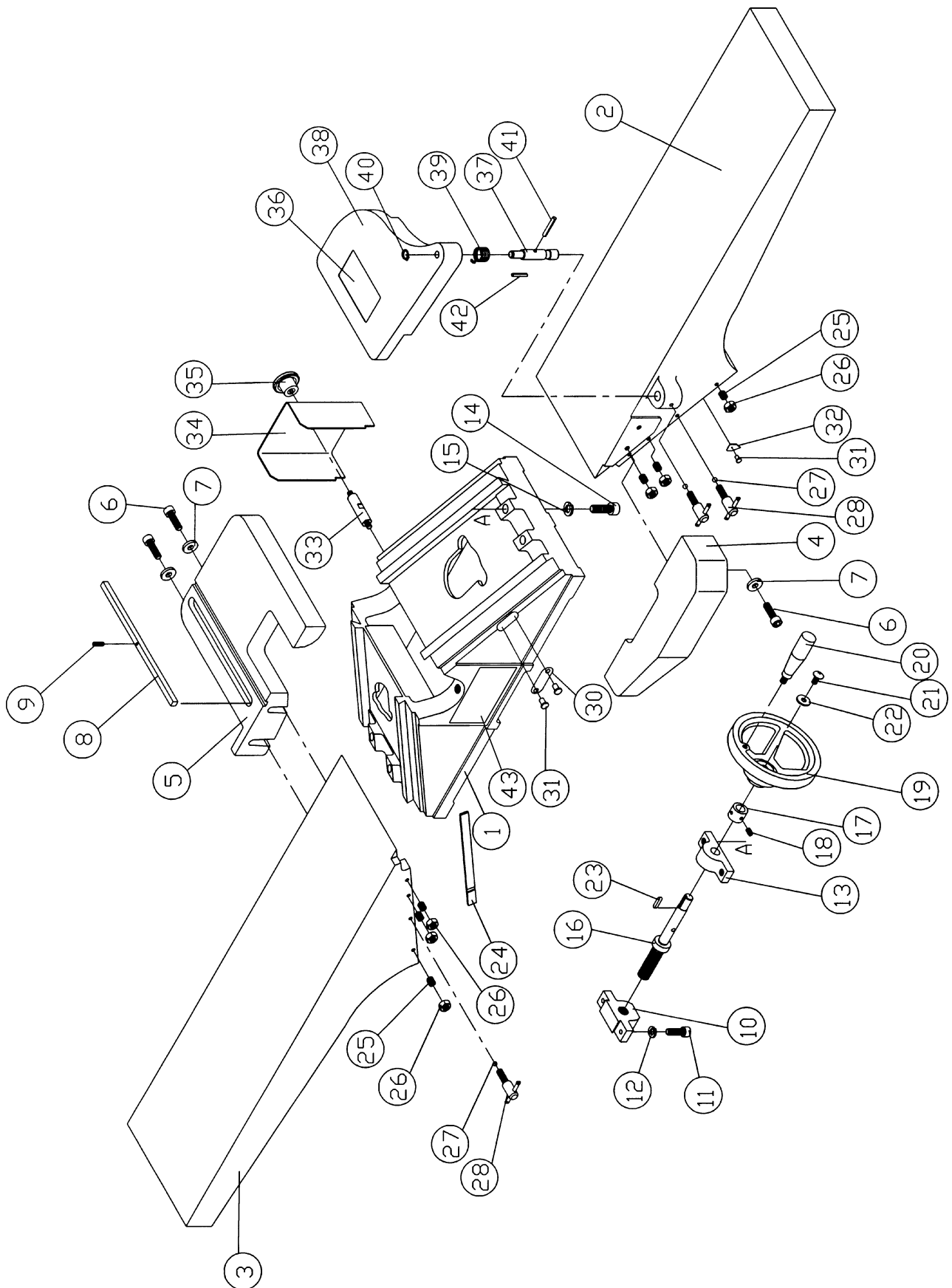


Parts List for the JJ-8CS Woodworking Jointer

Fence Assembly

Index No.	Part No.	Description	Size	Qty.
1	JC-F01	Fence Body		1
2	JC-F02	Fence Link		1
3	TS-0051061	Hex Head Screw	5/16"-18 x 1-1/4"	1
4	TS-0561021	Nut	5/16"-18	1
5	JC-F03	Fence Bracket		1
6	JC-F04	Bolt		2
7	JC-F05	Bolt	3/8"-16	4
8	TS-0561031	Nut	3/8"	4
9	5D-A004	Locking Link		1
10	JC-F07	Joint Plate		1
11	5C-E051	Flat Head Bolt	5/16"-18 x 1-1/2"	1
12	JC-F08	Screw		1
13	TS-0207081	Socket Head Cap Screw	1/4"-20 x 1-1/2"	2
14	TS-0207021	Socket Head Cap Screw	1/4"-20 x 1/2"	1
15	TS-0050061	Nut	1/4"-20	2
16	JC-F09	Pin	5x50	1
17	JC-F10	Stop Block		1
18	TS-0561052	Nut	1/2"-20	2
19	JC-F11	Locking Bolt w/Handle		1
20	TS-0680061	Flat Washer	1/2"	2
21	TS-0561051	Hex Nut	1/2"-13	1
22	JC-F14	Eccentric Shaft		1
23	JC-F15	Handle		2
24	LA-H34	Knob		2
25	TS-0561051	Hex Nut	1/2"-13	2
26	JC-F16	Eye Bolt		1

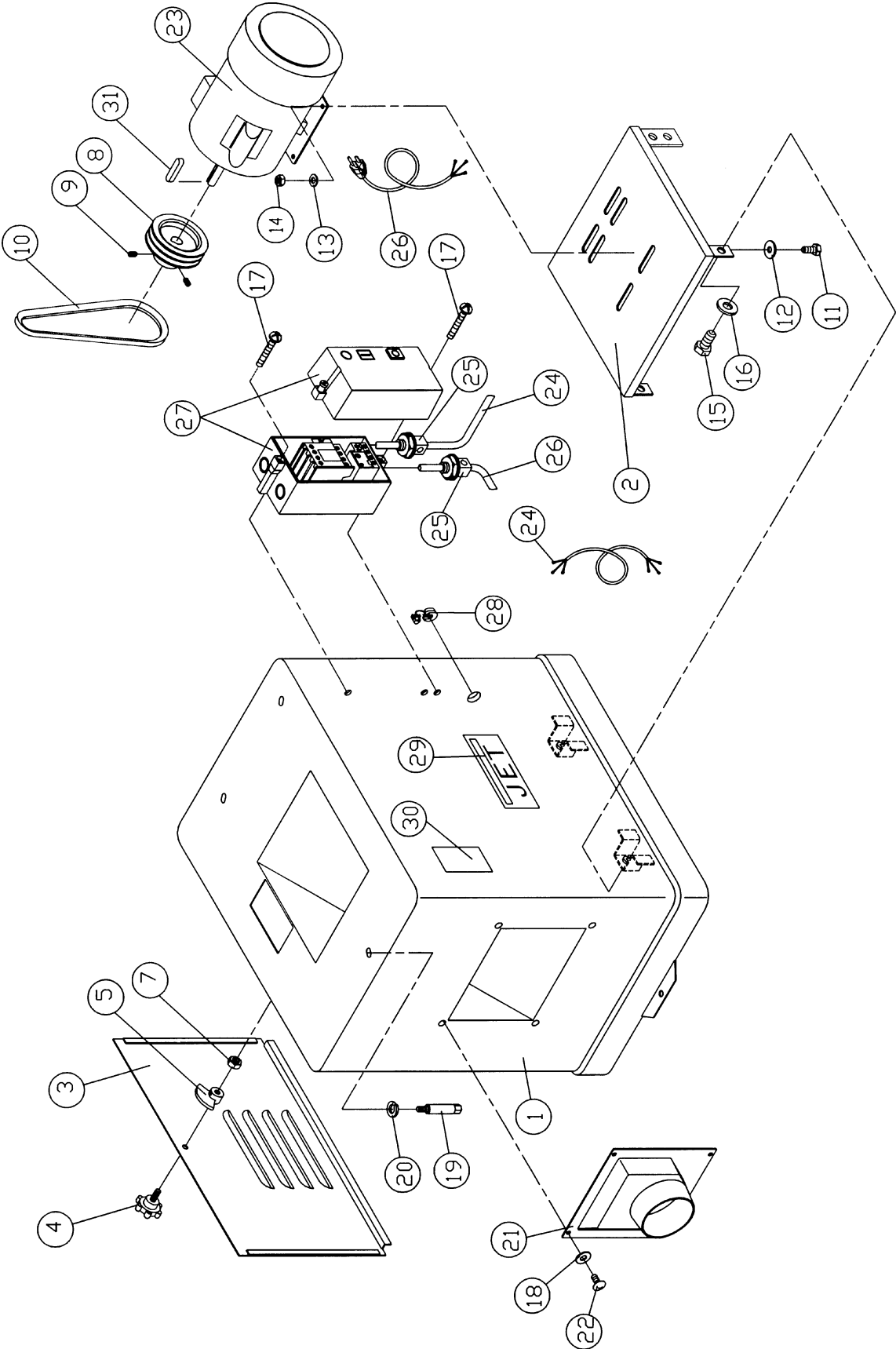
Bed Assembly



Bed Assembly

Index No.	Part No.	Description	Size	Qty.
1	JC-T01	Base		1
2	JC-T02	Front Table		1
3	JC-T03	Rear Table		1
4	JC-T04	Rabbeting Arm		1
5	JC-T05	Table Bracket		1
6	TS-0060071	Cap Screw	3/8"-16 x 1-1/2"	4
7	TS-0720091	Lock Washer	3/8"	4
8	JC-T07	Key	9.5 x 9.5 x 273	1
9	5F-E153	Spring Pin	4 x 16	1
10	JC-T08	Feed Screw Bracket		2
11	TS-0060061	Socket Head Cap Screw	3/8"-16 x 1-1/4"	4
12	TS-0720091	Lock Washer	3/8"	4
13	JC-T09	Bracket		2
14	TS-0070031	Cap Screw	1/2"-13 x 1-1/2"	4
15	TS-0720111	Lock Washer	1/2"	4
16	JC-T10	Feed Screw		2
17	JC-T11	Ring		2
18	TS-0267041	Set Screw	1/4"-20 x 3/8"	4
19	JC-T12	Wheel		2
20	PA-C42	Handle		2
21	5C-D003	Pan Head Machine Screw	5/16"-18 x 1/2"	2
22	TS-0680031	Flat Washer	5/16"	2
23	F5-G107	Key	5 x 5 x 22	2
24	JC-T13	Gib		2
25	TS-0270091	Set Screw	5/16"-18 x 1"	6
26	TS-0561021	Hex Nut	5/16"-18	6
27	5I-D003	Ball		2
28	JC-T15	Stop Handle		3
30	JC-T16	Scale		1
31	5F-H051	Rivet		7
32	JC-T17	Depth Pointer		1
33	PA-C49	Guard Bolt		1
34	JC-T18	Pulley Cover		1
35	PA-C53	Nut		1
36	JC-T19	Warning Label		1
37	JC-T20	Guard Shaft		1
38	JC-T21	Cutterhead Guard		1
39	JC-T22	Spring		1
40	5F-A002	Retaining Ring	STW-11	1
41	5F-E208	Spring Pin		1
42	5F-E258	Spring Pin	5 x 28	1
43	JJ8CS-ID	I.D. Label	6 x 36	1

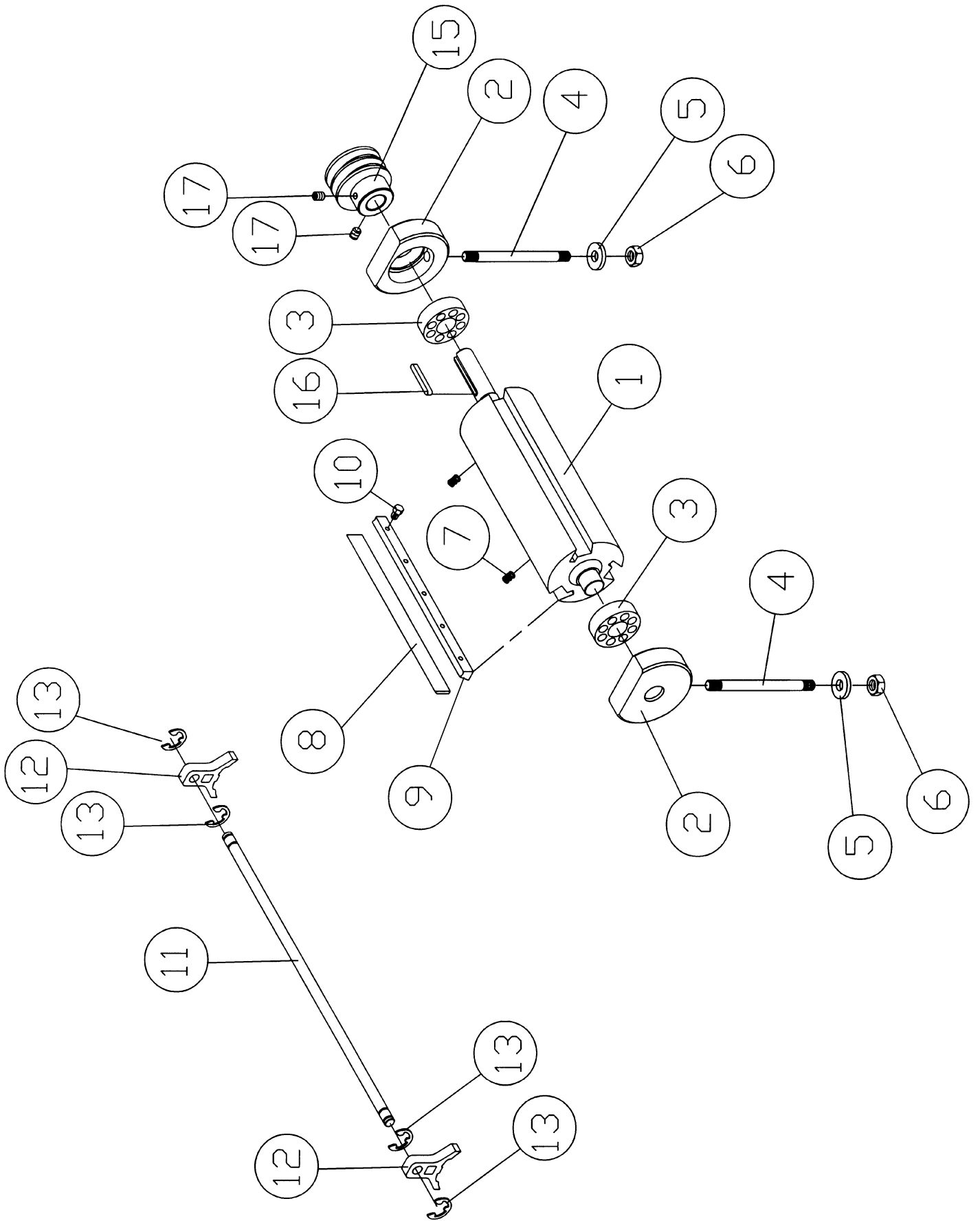
Stand and Motor Assembly



Stand and Motor Assembly

Index No.	Part No.	Description	Size	Qty.
1	JC-M01W	Stand		1
2	JC-M02W	Motor Mount		1
3	JC-M03W	Cover		1
4	JC-M04	Screw		1
5	JC-M05	Key		1
7	TS-0561031	Hex Nut	3/8"-16	1
8	JC-M06	Motor Pulley		1
9	TS-0271071	Set Screw	3/8"-16 x 3/4"	2
10	VB-M52	V-Belt		2
11	TS-0081031	Hex Head Screw	5/16"-18 x 3/4"	4
12	TS-0680031	Flat Washer	5/16"	4
13	TS-0680031	Flat Washer	5/16"	4
14	TS-0561021	Hex Nut	5/16"-18	4
15	TS-0070011	Hex Head Screw	1/2"-13 x 1"	4
16	TS-0680061	Flat Washer	1/2"	4
17	JCS10-079C	Screw	3/16"-UNC x 3/4"	2
18	TS-0680021	Flat Washer	1/4"	4
19	JC-M07	Lock Bolt	3/8"-16	3
20	TS-0720091	Lock Washer	3/8"	3
21	JC-M03	Dust Chute		1
22	TS-0813032	Pan Head Screw	1/4"-20 x 1/2"	4
23	JJ8-917W	Motor	2HP, 1Ph	1
24	JJ8-918	Motor Cord		1
25	JJ8-919	Strain Relief		2
26	JJ8-920	Power Cord		1
27	JJ8-921A	Switch		1
28	JJ8-923	Strain Relief		1
29	JJ8CS-JL	JET Label		1
30	JC-T23	Warning Label		1
31	5FK-C13	Key	5x5x35	1
	JJ8CS-HK	Hardware Kit (not shown)		

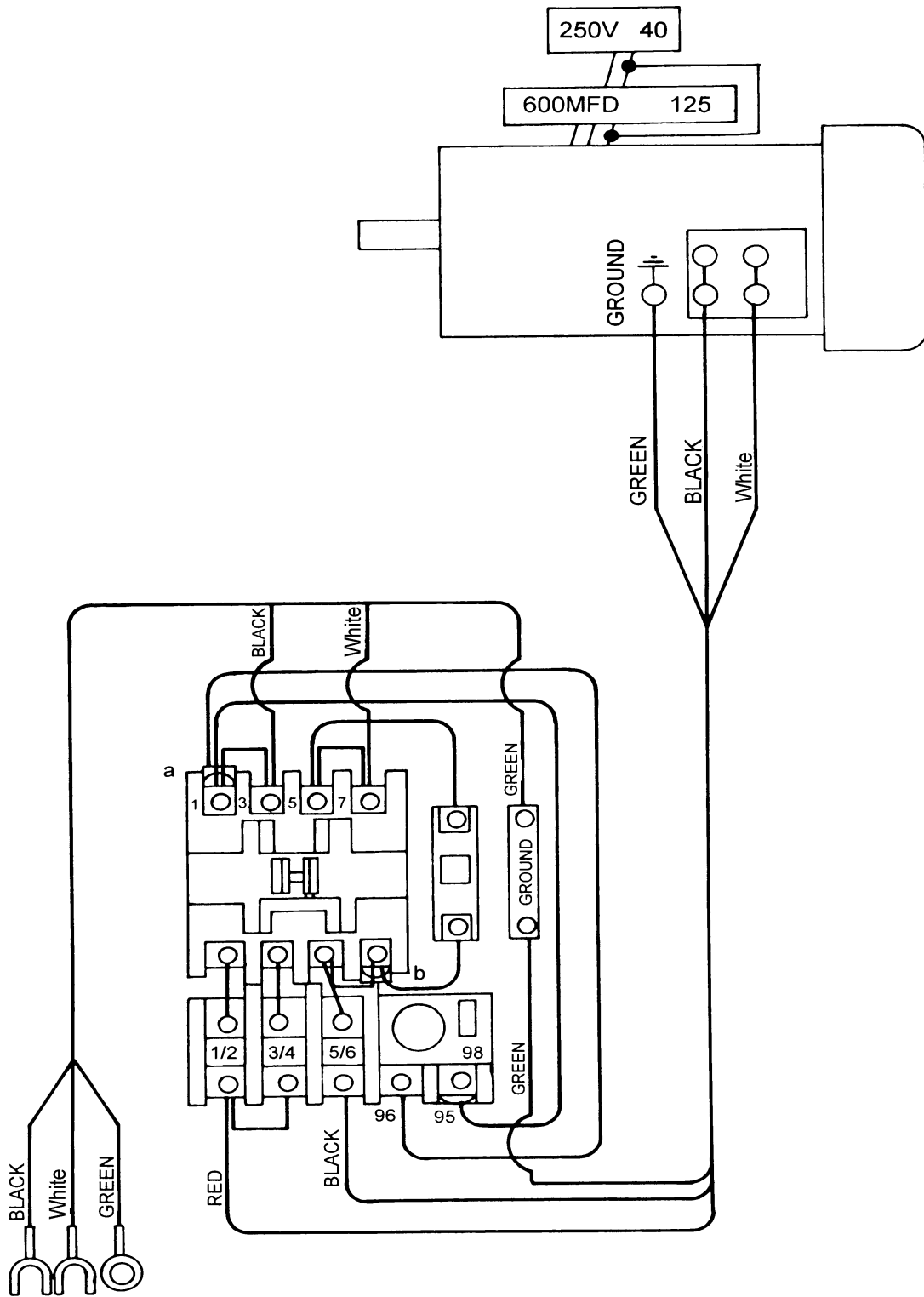
Cutterhead Assembly



Cutterhead Assembly

Index No.	Part No.	Description	Size	Qty.
1	JC-C01	Cutterhead		1
2	JC-C02	Bearing Housing		2
3	5H-A104	Bearing		2
4	JC-C03	Cutterhead Set Bolt		2
5	TS-0680041	Flat Washer	3/8"	2
6	TS-0561031	Nut	3/8"-UNC	2
7	PA-C05	Spring		6
8	708802	Knife		3
9	JC-C05	Knife Lock Bar		3
10	JC-C06	Screw		15
11	JC-C07	Knife Gauge Rod		1
12	JC-C08	Knife Gauge		2
13	TS-0680041	Retaining Ring	STW-9"	4
15	JC-C09	Machine Pulley		1
16	5F-G107	Key	5 x 5 x 22	1
17	TS-0270031	Set Screw	5/16"-18NC x 3/8"	2

Wiring Diagram



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