

## OPERATING PROCEDURE FOR:

# 8" POWERMATIC® PARALLELOGRAM JOINTER

---

### SAFETY RULES:

As with all machines, there is a certain amount of hazard involved with the use of this jointer. Use the machine with the respect and caution demanded where safety precautions are concerned. **WARNING!!! The cutterhead is capable of amputating you fingers or hand if they come in contact.** Following the safety rules will minimize the potential for this occurring. **You are responsible for you own safety.**

**Read and understand** these operating procedures for this machine before attempting operation.

**Personal Protective Equipment.** At a minimum eye protection and hearing protection must be worn when operating this machine. Eye protection must be safety glasses with side shields, goggles, or face shield, which meet ANSI Z87.1. Remove tie and loose jewelry. Button sleeves or roll up sleeves above the elbow. Remove loose outer clothing and confine long hair.

**Use the appropriate NIOSH approved respirator** in dusty work conditions (N95, N100, P95 or P100). Wood dust has been listed as a known carcinogen by the U.S. government.

**Guards.** Keep the machine guards in place for every operation for which they can be used.

**Work Area.** Keep the floor around the machine clean to minimize the danger of tripping or slipping. Be sure the infeed and outfeed tables are free of scrap or foreign material. Make sure the dust collector is hooked up and operating.

**Operator Position.** Maintain a balanced stance and keep your body under control at all times, so that you do not fall or lean against the cutterhead or moving parts. Do not overreach or use excessive force to perform any machine operation. Stand next to the infeed table and walk the board past the cutterhead.

**Careless Acts.** Give the work you are doing your undivided attention. Looking around, carrying on a conversation, and "horseplay" are careless acts that can result in serious injury.

**Disconnect machine** before performing any service or maintenance. A machine under repair must be Locked Out using the Club Lockout procedure until the maintenance is complete.

**Maintain Tools In Top Condition.** Keep knives sharp and clean for safe and best performance. Dull knives increase noise levels, tearout and glazed surfaces. If a carbide insert is chipped or broken, it must be replaced. Notify the Shop Leader.

**Hand Safety.** Keep hands clear of the cutting area. Follow the 3-inch rule: The hands must never be closer than 3 inches to the cutter head at any time.

**Always** use a two push blocks when surfacing (face jointing) stock.

**Material Condition.** CAUTION! Do not joint boards with loose knots or with nail or any foreign material on its surface. Do not joint chipboard or panel board. **Reclaimed or pressure treated wood is not to be jointed on this machine.**

**Machine Adjustments.** Make all machine adjustments with power disconnected, except depth of cut adjustments and fence adjustments. Make fence adjustments only when the machine is not running.

**Job Completion.** If the operator leaves the machine area for any reason, the jointer should be turned “off” and the cutterhead should come to a complete stop before his departure. In addition, if the operation is complete, the operator should clean the jointer and the work area. Never clean the jointer with the power “on” and never use the hands to clear sawdust and debris; use a brush.

**If you are not** thoroughly familiar with the operation of jointer, obtain advice from the Shop Leader.

**Drugs, Alcohol, Medication.** Do not operate this machine while under the influence of drugs, alcohol, or any medication. Do not operate this machine if you are tired, sick, or distracted.

**Familiarize yourself** with all caution and warning decals used on this machine.

---

**Specifications:**

Maximum jointing width .....	8”
Maximum jointing thickness-edging.....	1/2”
Maximum jointing thickness-surfacing .....	1/16”
Minimum jointing length .....	12”
Minimum jointing width .....	3/4”
Minimum jointing thickness .....	1/4”
Table size .....	8” x 83”
Horsepower .....	2
Weight.....	610 lb

---

**OPERATION:**

Turn on the dust collection system by opening the blast gate below the outfeed table.

The fence should be adjusted to create minimum exposure of the cutter head. Lock the fence in place.

Verify that the fence is 90 degrees to the table. This is done for most edge jointing operations.

The fence can be tilted inward or outward to make beveled cuts. In either case, the board is held tight to the fence. Tilting the fence outward is preferred because it is easier and safer to push the board against the fence than it is to hold the board up to it.

Set the infeed table for desired depth of cut. For face jointing, 1/32" to 1/16" is usually appropriate. Deeper cuts can be made, but it takes more effort to push the board through the cutter head.

Turn on the power and allow the jointer to come to full speed. Listen for any odd noises, rubbings, vibrations, etc. If any are present, notify the Shop Leader.

Check work piece for knots, holes, staples or any foreign material that might damage knives or pose a risk of kickback. Loose knots can come dislodged and thrown at the operator.

If possible, determine the grain direction of each piece and feed *so that the jointer is cutting down hill on the grain.*

When surfacing hardwoods, a 1/32" depth of cut is often appropriate. Do not exceed 1/16" depth of cut. When jointing edges, a cut of up to 1/2" may be made if the board is 4' or wider, but in most cases, the depth of cut should not exceed 1/8" if a fine finish is desired.

In order to minimize the difficulty of handling large pieces of stock, cut the stock into 2' – 6' lengths if longer lengths are not required. This will minimize the amount of material that will need to be removed from cupped or twisted boards to flatten them.

At the start of the cut, the left hand holds the work piece firmly against the infeed table and the fence while the right hand pushes the work piece in a smooth, even motion toward the cutter head. After the cut is under way, the new surface rests on the outfeed table. The left hand is moved to the outfeed table and holds the work piece down firmly. The right hand presses the work piece forward and before the right hand reaches the cutter head it should be moved to the work piece on the outfeed table. **Never pass hands directly over the cutter head.**

If surfacing cupped or bowed material, put the concave side down and make successive passes with minimal downward pressure until work piece is flat. Excessive pressure will flatten it as it passes the cutterhead, and then spring back and remain curved after cut is completed.

When dimensioning stock, joint the face first. Then hold the surfaced face tight against the fence while jointing the edge.

Obtain approval from the Shop Leader prior to surfacing boards wider than 8". A special guard is required for this operation.

When job is complete, shut off machine and clean the area.