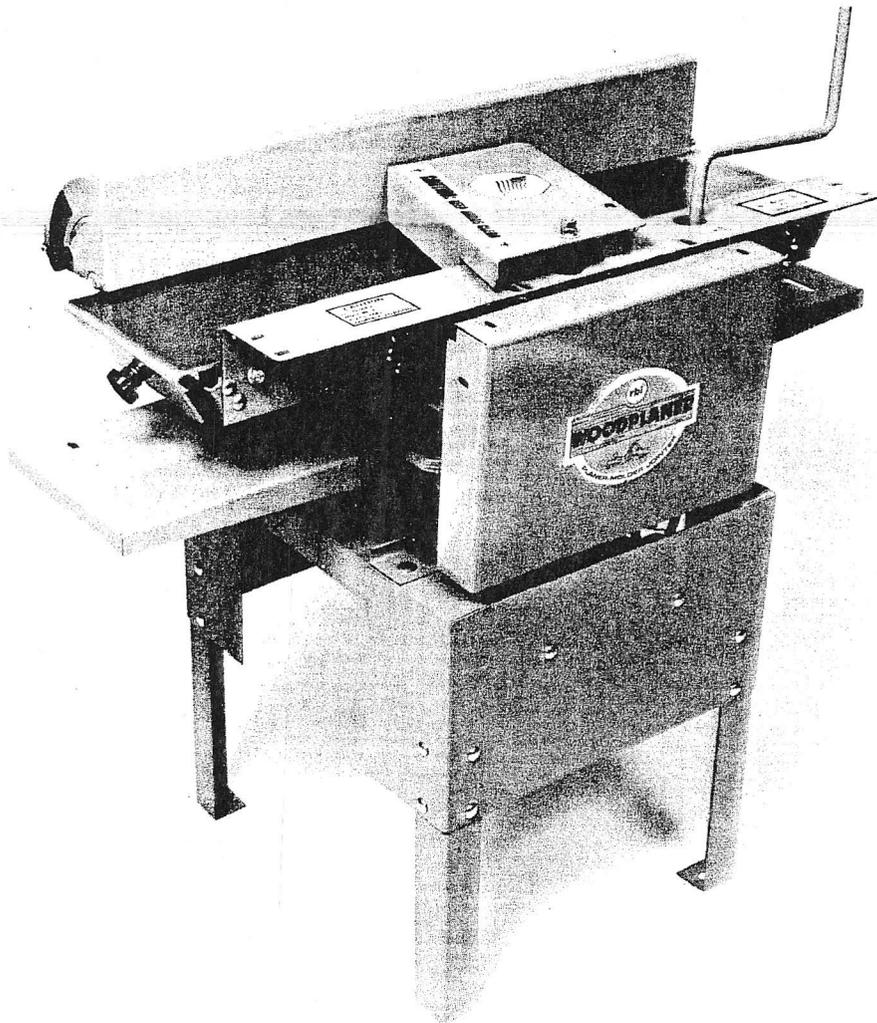


**\*MODEL 532**

## **JOINTER ATTACHMENT SPECIFICATIONS**

JOINTING: CUTTING WIDTH 7" MAX  $\frac{3}{4}$ " MIN  
MINIMUM LENGTH OF STOCK 10"  
MINIMUM THICKNESS OF STOCK  $\frac{1}{4}$ "  
MAXIMUM CUTTING DEPTH PER PASS  $\frac{1}{8}$ "  
CUTTING ANGLE 45° TO 90°  
FEED MANUAL  
TABLE LENGTH 32"



*\* Accessories for your model 408 or 612 planer-molder not included in the basic planer package, are available at additional cost.*

# INSTALLATION:

Installation of your Model 532 Jointer on Your Model 408 or 612 Planer Molder

Remove your Jointer from the shipping carton. Check for damages. Damages or shorted parts are to be reported to the transportation carrier. Manufacturer is not responsible for shipping damage. Please report shipping damage immediately to carrier.

## JOINTER ASSEMBLY - 1 ATTACHING GROUP

### MODEL 408 PLANER

4 - 5/16" F/W

#### PLANER PREPARATION

1. Disconnect Electrical Source
2. Remove Hood (requires the nuts and washers in the Jointer installation)
3. Remove chipbreaker and attaching hardware (requires the nuts and washers in the Jointer installation).
4. Place the Model 532 Jointer on a table or other flat surface. Check, using a straight edge, to see if the infeed and outfeed tables are level the full length, both sides. (This is necessary to get a straight, even cut of your board) If not, turn the infeed table adjusting knob clockwise to raise the infeed table to its highest position. Loosen the four bolts holding the outfeed table to the frame and adjust it level to the infeed table (see diagram). Tighten the bolts holding the outfeed table.

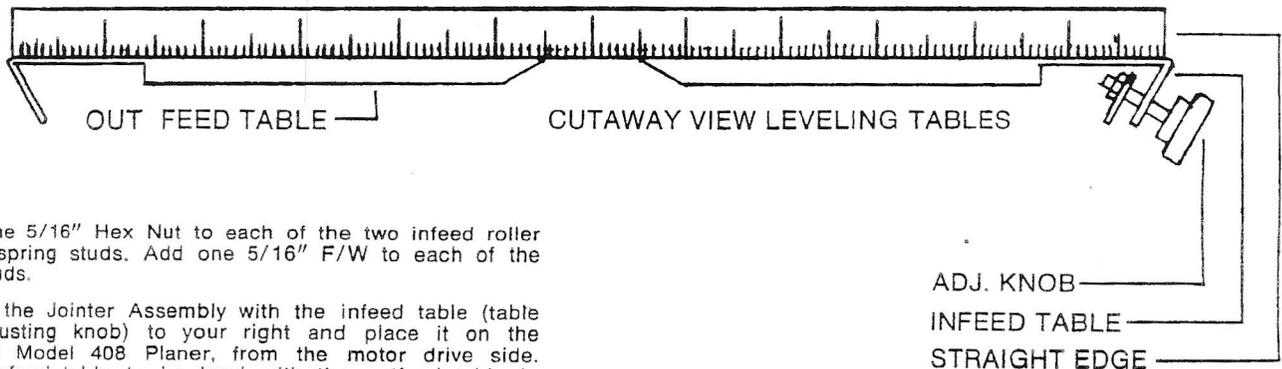
### MODEL 612 PLANER

4 - 3/8" F/W

2 - 3/8" Hex Nuts

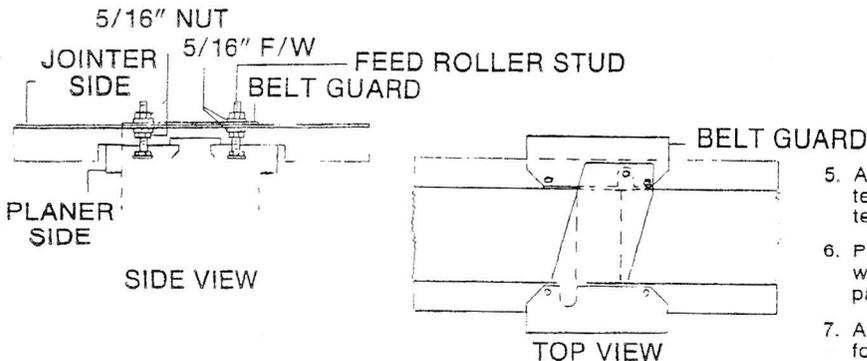
#### PLANER PREPARATION

1. Disconnect Electrical Source
2. Remove Hood (requires the nuts and washers in the Jointer installation)
3. Remove chipbreaker and attaching hardware. Replace 3/8-16 Hex Nut. Secure.
4. Place the Model 532 Jointer on a table or other flat surface. Check, using a straight edge, to see if the infeed and outfeed tables are level the full length, both sides. (This is necessary to get a straight, even cut of your board). If not turn the infeed table adjusting knob clockwise to raise the infeed table to the highest position. Loosen the four bolts holding the outfeed table to the frame and adjust it level to the infeed table (see diagram). Tighten the bolts holding the outfeed table.



5. Apply one 5/16" Hex Nut to each of the two infeed roller tension spring studs. Add one 5/16" F/W to each of the same studs.
6. Pick up the Jointer Assembly with the infeed table (table with adjusting knob) to your right and place it on the prepared Model 408 Planer, from the motor drive side. NOTE: Infeed table to be level with the outfeed table in the raised position.
7. Attach the guards, one on each side, to the two mounting bolts on each side of the Planer, using 4 - 5/16" F/W and 4 - 5/16" Hex Nuts (Start only.)

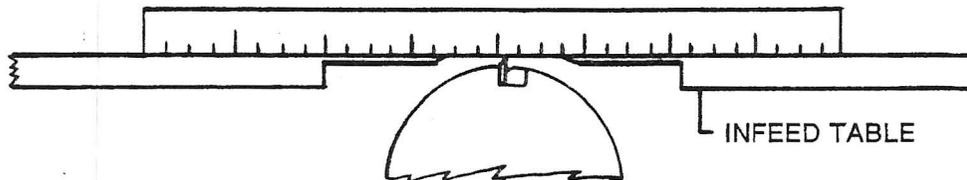
**NOTE:** Jointer Belt guards use the RB-09 (L.S.) and RB-08 R.S. hood ends. Mount on top of the jointer sides using jointer mounting bolts.



5. Apply one 3/8" Hex Nut to each of the two infeed roller tension spring studs. Add one 3/8" F/W to each of the four tension spring studs.
6. Pick up the Jointer Assembly with the infeed table (table with adjusting knob) to your left and place it on the prepared Model 612 Planer, from the motor drive side.
7. Add one 3/8" F/W and one 3/8" Hex Nut to each of the four mounting studs. (Start only.)
8. Lay a straight edge (level) the length of the infeed and outfeed tables (see diagram). Adjust the Jointer up or down, using the same mounting nuts, until the **same height as the knife radius**. (turn cutterhead). Repeat on the other side (Adjust the Jointer near level with the Planer and

each mounting nut.) Tighten the top mounting nuts and recheck knife clearance. (NOTE: Table tops must be the same height as the cutterhead knife radius for proper Jointing.) Minor adjustments up or down of the four mounting nuts may be required.

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9. Check cutterhead rotation by hand for clearance of knives, in no cut and 1/8" cut positions. Check pulleys, belts and guards for adequate clearance.

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Installation Complete. Proceed to Operation Instructions.

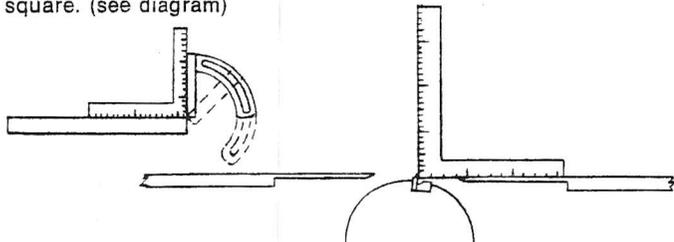
Installation Complete. Proceed to Operation Instructions.

## SAFETY:

1. Wear eye protection and ear protection if required.
2. Never operate Jointer without all guards in place.
3. Always use holddown push blocks when jointing material.
4. Use Planer for planing face surfaces.
5. Keep hands and clothing away from cutterhead.
6. Feed wood into the cutter blades, against the direction of rotation of the cutter blades.
7. Consult specification sheet for wood dimensions for jointing.
8. Do not attempt to perform an abnormal or little used operation without study and use of adequate holddown push blocks, jigs, fixtures, stops, etc.
9. Do not stand in line of infeed or outfeed of jointer.
10. Maintain control of board during jointing (CAUTION: Kickback can occur. Keep clear of infeed.)
11. Maintain the infeed table parallel to the outfeed table and the cutterhead.

## OPERATION:

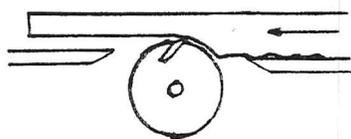
1. Adjust the infeed table down by turning the adjustment handle C.C.W. one turn of the adjustment handle will give a depth of cut approx 1/32". This can be checked by a square. (see diagram)



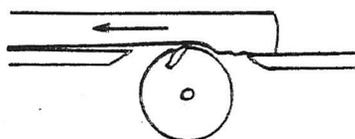
2. Check cutterhead knife clearance by turning by hand.
3. Adjust fence to desired angle, board face to edge, 90° to 45°. See figure.
4. Remove all wrenches, etc. from machine. Check electrical switch to off position.

5. Connect electrical supply. Turn machine on.
6. Feed board, with wood grain into the cutterhead while maintaining pressure against table and fence and controlling board to prevent kickback. Use holddown push blocks as required. Keep hands and clothing away from cutterhead.
7. It may be required to repeat the operation more than once to obtain a straight cut the full length of the side face.
8. If an uneven or unsmooth cut is obtained, you may be cutting against the grain, reverse the board and run again.
9. The fence may be angled for degree cuts along board edge. A deeper cut, max 1/8", may be removed with additional pass.
10. Jointing ends of boards is not recommended (due to splintering and inability to maintain board alignment to cutterhead).

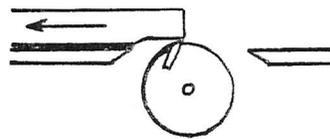
## JOINTER PROBLEMS



OUTFEED TABLE TOO LOW.



THE WOOD STARTS TO TIP FORWARD.



CAUSING A JUMP AT THE END.

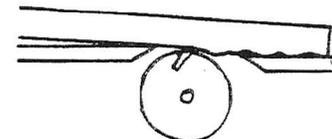


TABLE TOO HIGH RESULTS IN A TAPERED CUT.

## \* 532 PARTS LIST

Key #	Part #	Description	Quantity	Key #	Part #	Description	Quantity
1.	RZ-81	5/16" Hex Nut .....	11	17.	RB-107	10-32 Hex Nut .....	4
2.	RB-150	5/16" F/W .....	10	18.	RB-507	Knob .....	2
4.	RB-502	Cutterhead Guard .....	1	19.	RB-508	Fence Support Bracket, Outfeed .....	1
5.	RB-63	Spring, Cutterhead Guard return .....	1	20.	RB-509	Fence .....	1
6.	RB-503	Spacer, Cutterhead Guard .....	1	21.	RB-510	L.H. Jointer Side .....	1
7.	RB-504	5/16" Carriage Bolt .....	1	22.	RB-511	Table .....	2
8.	RB-99	1/4" x 5/8" Carriage Bolt .....	22	23.	RB-512	Degree Label .....	1
9.	RB-505	R.H. Jointer Side .....	1	24.	RB-513	Speed Nut .....	1
10.	RBZ-207	1/4" L/W .....	20	25.	RB-514	Adjusting Handle infeed table .....	1
11.	RBZ-208	1/4" Hex Nut .....	20	26.	RB-515	Table Adjustment Collar .....	1
12.	RZ-181	5/16" x 1" Hex Bolt .....	8	27.	RB-517	Spacer Slide Infeed Table .....	4
13.	RB-506	Center Brace .....	3	28.	RB-516	Fence support bracket, infeed .....	1
14.	RB-177	1/4" F/W .....	6	29.	RB-518	Attaching Rivet .....	1
15.	RZ-178	5/16" L/W .....	8	31.	RB-520	Pointer .....	1
16.	RB-106	10-32 x 1/2" Machine Screw .....	2				

