

DJ-30 12" Jointer

(Model 37-360, Three Phase)
(Model 37-361, Single Phase)



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To learn more about DELTA MACHINERY
visit our website at: www.deltamachinery.com.

For Parts, Service, Warranty or other Assistance,

please call 1-800-223-7278 (In Canada call 1-800-463-3582).

SAFETY GUIDELINES - DEFINITIONS

This manual contains information that is important for you to know and understand. This information relates to protecting YOUR SAFETY and PREVENTING EQUIPMENT PROBLEMS. To help you recognize this information, we use the symbols below. Please read the manual and pay attention to these sections.

▲ DANGER Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

▲ WARNING Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

▲ CAUTION Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION Used without the safety alert symbol indicates potentially hazardous situation which, if not avoided, may result in property damage.

▲ WARNING **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 paints,
- crystalline silica from bricks and cement and other masonry products, and
- 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, always wear **MSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

GENERAL SAFETY RULES



▲ WARNING **READ AND UNDERSTAND ALL WARNINGS AND OPERATING INSTRUCTIONS BEFORE USING THIS EQUIPMENT.** Failure to follow all instructions listed below, may result in electric shock, fire, and/or serious personal injury or property damage.

IMPORTANT SAFETY INSTRUCTIONS

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it. Figure out an alternative procedure that feels safer. **REMEMBER:** Your personal safety is your responsibility. For additional information please visit our website www.deltamachinery.com.

▲ WARNING This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, **DO NOT** use the machine until you have first contacted Delta to determine if it can or should be performed on the product.

**Technical Service Manager
Delta Machinery
4825 Highway 45 North
Jackson, TN 38305
(IN CANADA: 505 SOUTHGATE DRIVE, GUELPH, ONTARIO N1H 6M7)**

GENERAL SAFETY RULES

⚠ WARNING FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY.

- 1. FOR YOUR OWN SAFETY, READ THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learning the machine's application, limitations, and specific hazards will greatly minimize the possibility of accidents and injury.
- 2. WEAR EYE PROTECTION. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses are NOT safety glasses. **USE CERTIFIED SAFETY EQUIPMENT.** Eye protection equipment should comply with ANSI Z87.1 standards, hearing equipment should comply with ANSI S3.19 standards, and dust mask protection should comply with MSHA/NIOSH certified respirator standards. Splinters, air-borne debris, and dust can cause irritation, injury, and/or illness.
- 3. WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- 4. DO NOT USE THE MACHINE IN A DANGEROUS ENVIRONMENT.** The use of power tools in damp or wet locations or in rain can cause shock or electrocution. Keep your work area well-lit to prevent tripping or placing arms, hands, and fingers in danger.
- 5. MAINTAIN ALL TOOLS AND MACHINES IN PEAK CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories. Poorly maintained tools and machines can further damage the tool or machine and/or cause injury.
- 6. CHECK FOR DAMAGED PARTS.** Before using the machine, check for any damaged parts. Check for alignment of moving parts, binding of moving parts, breakage of parts, and any other conditions that may affect its operation. A guard or any other part that is damaged **should be properly repaired or replaced.** Damaged parts can cause further damage to the machine and/or injury.
- 7. KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 8. KEEP CHILDREN AND VISITORS AWAY.** Your shop is a potentially dangerous environment. Children and visitors can be injured.
- 9. REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure that the switch is in the "OFF" position before plugging in the power cord. In the event of a power failure, move the switch to the "OFF" position. An accidental start-up can cause injury.
- 10. USE THE GUARDS.** Check to see that all guards are in place, secured, and working correctly to prevent injury.
- 11. REMOVE ADJUSTING KEYS AND WRENCHES BEFORE STARTING THE MACHINE.** Tools, scrap pieces, and other debris can be thrown at high speed, causing injury.
- 12. USE THE RIGHT MACHINE.** Don't force a machine or an attachment to do a job for which it was not designed. Damage to the machine and/or injury may result.
- 13. USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by Delta may cause damage to the machine or injury to the user.
- 14. 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 product will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. See the Extension Cord Chart for the correct size depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- 15. SECURE THE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. Loss of control of a workpiece can cause injury.
- 16. FEED THE WORKPIECE AGAINST THE DIRECTION OF THE ROTATION OF THE BLADE, CUTTER, OR ABRASIVE SURFACE.** Feeding it from the other direction will cause the workpiece to be thrown out at high speed.
- 17. DON'T FORCE THE WORKPIECE ON THE MACHINE.** Damage to the machine and/or injury may result.
- 18. DON'T OVERREACH.** Loss of balance can make you fall into a working machine, causing injury.
- 19. NEVER STAND ON THE MACHINE.** Injury could occur if the tool tips, or if you accidentally contact the cutting tool.
- 20. NEVER LEAVE THE MACHINE RUNNING UNATTENDED. TURN THE POWER OFF.** Don't leave the machine until it comes to a complete stop. A child or visitor could be injured.
- 21. TURN THE MACHINE "OFF", AND DISCONNECT THE MACHINE FROM THE POWER SOURCE** before installing or removing accessories, before adjusting or changing set-ups, or when making repairs. An accidental start-up can cause injury.
- 22. MAKE YOUR WORKSHOP CHILDPROOF WITH PADLOCKS, MASTER SWITCHES, OR BY REMOVING STARTER KEYS.** The accidental start-up of a machine by a child or visitor could cause injury.
- 23. STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE. DO NOT USE THE MACHINE WHEN YOU ARE TIRED OR UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.** A moment of inattention while operating power tools may result in injury.
- 24. THE DUST GENERATED** by certain woods and wood products can be injurious to your health. Always operate machinery in well-ventilated areas, and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR JOINTERS

▲ WARNING FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY.

1. **DO NOT OPERATE THIS MACHINE** until it is completely assembled and installed according to the instructions. A machine incorrectly assembled can cause serious injury.
2. **OBTAIN ADVICE** from your supervisor, instructor, or another qualified person if you are not thoroughly familiar with the operation of this machine. Knowledge is safety.
3. **FOLLOW ALL WIRING CODES** and recommended electrical connections to prevent shock or electrocution.
4. **KEEP KNIVES SHARP** and free from rust and pitch. Dull or rusted knives work harder and can cause kickback.
5. **TIGHTEN THE INFEED/OUTFEED TABLES** before starting the machine. Loss of control of the workpiece can cause serious injury.
6. **PROPERLY SECURE THE BLADES IN THE CUTTERHEAD** before turning the power "ON". Loose blades may be thrown out at high speeds.
7. **NEVER TURN THE MACHINE "ON"** before clearing the table of all objects (tools, scraps of wood, etc.). Flying debris can cause serious injury.
8. **NEVER TURN THE MACHINE "ON"** with the workpiece contacting the cutterhead. Kickback can occur.
9. **AVOID AWKWARD OPERATIONS AND HAND POSITIONS.** A sudden slip could cause a hand to move into the cutterhead.
10. **KEEP ARMS, HANDS, AND FINGERS** away from the cutterhead to prevent severe injury.
11. **NEVER MAKE CUTS** deeper than 1/8" (3.2mm) to prevent kickback.
12. **NEVER JOINT OR PLANE A WORKPIECE** that is shorter than 10" (254mm), narrower than 3/4" (19.0MM), or less than 1/2" (12.7mm) thick. Jointing smaller workpieces can allow your hand to contact the cutterhead causing severe injury.
13. **USE HOLD-DOWN/PUSH BLOCKS** for jointing or planing any workpiece lower than the fence. Jointing or planing small workpieces can result in kickback and severe injury.
14. **HOLD THE WORKPIECE FIRMLY** against the table and fence. Loss of control of the workpiece can cause kickback and result in serious injury.
15. **NEVER PERFORM "FREE-HAND" OPERATIONS.** Use the fence to position and guide the workpiece. Loss of control of the workpiece can cause serious injury.
16. **DO NOT** attempt to perform an abnormal or little-used operation without study and the use of adequate hold-down/push blocks, jigs, fixtures, stops, etc.
17. **DO NOT FEED A WORKPIECE** from the outfeed end of the machine. The workpiece will be thrown out of the opposite end at high speeds.
18. **DO NOT ATTEMPT** to back out a workpiece while the cutters are still rotating.
18. **DO NOT FEED A WORKPIECE** that is warped, contains knots, or is embedded with foreign objects (nails, staples, etc.) to prevent kickback.
19. **MAINTAIN THE PROPER RELATIONSHIP OF INFEED AND OUTFEED TABLE SURFACES** and cutterhead knife path. Loss of control of the workpiece can cause serious injury.
20. **PROPERLY SUPPORT LONG OR WIDE WORKPIECES.** Loss of control of the workpiece can cause injury.
21. **NEVER PERFORM LAYOUT, ASSEMBLY, OR SET-UP WORK** on the table/work area when the machine is running. A sudden slip could cause a hand to move into the cutterhead. Severe injury can result.
22. **TURN THE MACHINE "OFF"**, disconnect the machine from the power source, and clean the table/work area before leaving the machine. **LOCK THE SWITCH IN THE "OFF" POSITION** to prevent unauthorized use. Someone else might accidentally start the machine and cause injury to themselves.
23. **ADDITIONAL INFORMATION** regarding the safe and proper operation of power tools (i.e. a safety video) is available from the Power Tool Institute, 1300 Sumner Avenue, Cleveland, OH 44115-2851 (www.powertoolinstitute.com). Information is also available from the National Safety Council, 1121 Spring Lake Drive, Itasca, IL 60143-3201. Please refer to the American National Standards Institute ANSI 01.1 Safety Requirements for Woodworking Machines and the U.S. Department of Labor OSHA 1910.213 Regulations.

SAVE THESE INSTRUCTIONS.
Refer to them often
and use them to instruct others.

POWER CONNECTIONS

A separate electrical circuit should be used for your machines. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and matching receptacle which will accept the machine's plug. Before connecting the machine to the power line, make sure the switch (s) is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine. All line connections should make good contact. Running on low voltage will damage the machine.

⚠ DANGER DO NOT EXPOSE THE MACHINE TO RAIN OR OPERATE THE MACHINE IN DAMP LOCATIONS.

MOTOR SPECIFICATIONS

Your machine is wired for (see SPEC PLATE VOLTAGE), 60 HZ alternating current. Before connecting the machine to the power source, make sure the switch is in the "OFF" position.

GROUNDING INSTRUCTIONS

⚠ DANGER THIS MACHINE MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

1. All grounded, cord-connected machines:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and matching 3-conductor receptacles that accept the machine's plug, as shown in Fig. A.

Repair or replace damaged or worn cord immediately.

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

If the machine is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. A, the machine will have a grounding plug that looks like the plug illustrated in Fig. A. A temporary adapter, which looks like the adapter illustrated in Fig. B, may be used to connect this plug to a matching 2-conductor receptacle as shown in Fig. B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box. Whenever the adapter is used, it must be held in place with a metal screw.

NOTE: In Canada, the use of a temporary adapter is not permitted by the Canadian Electric Code.

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

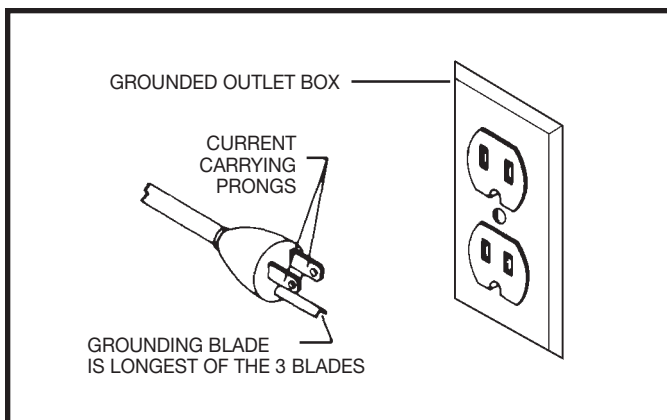


Fig. A

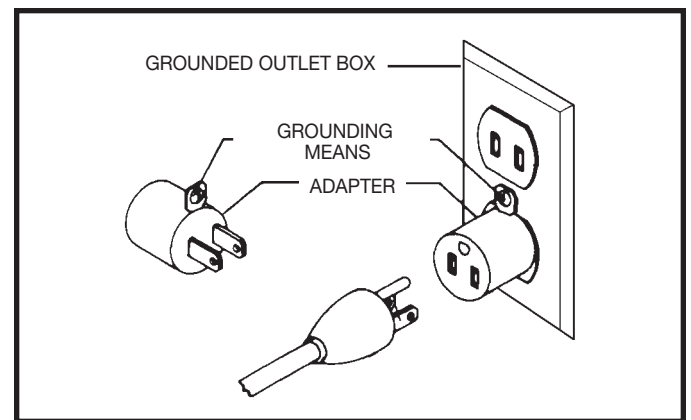


Fig. B

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

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

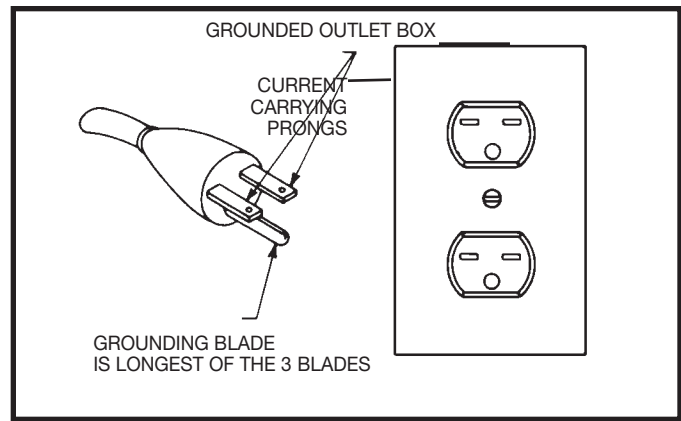


Fig. C

4. Permanently connected machines:

If the machine is intended to be permanently connected, the machine should be connected to a grounded metal permanent wiring system, or to a system having an equipment-grounding conductor.

THREE PHASE OPERATION

Three phase jointers are not supplied with a power cord. They must be permanently connected to the building electrical system and grounded according to the National Electrical Code. Since they must be permanently connected to the building electrical system, extension cords cannot be used with three phase jointers.

EXTENSION CORDS

CAUTION Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and matching receptacle which will accept the machine's plug. When using an extension cord, be sure to use one heavy enough to carry the current of the machine. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Fig. D-1 shows the correct gauge to use depending on the cord length. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

MINIMUM GAUGE EXTENSION CORD			
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES			
Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	240	up to 50	18 AWG
0-6	240	50-100	16 AWG
0-6	240	100-200	16 AWG
0-6	240	200-300	14 AWG
6-10	240	up to 50	18 AWG
6-10	240	50-100	16 AWG
6-10	240	100-200	14 AWG
6-10	240	200-300	12 AWG
10-12	240	up to 50	16 AWG
10-12	240	50-100	16 AWG
10-12	240	100-200	14 AWG
10-12	240	200-300	12 AWG
12-16	240	up to 50	14 AWG
12-16	240	50-100	12 AWG
12-16	240	GREATER THAN 100 FEET NOT RECOMMENDED	

Fig. D-2

FUNCTIONAL DESCRIPTION

FOREWORD

Delta Model 37-360 and 37-361 (DJ-30) are 12" Precision Jointers with a cutting capacity of 12" (304mm) wide, 3/4" deep (19mm max.) and 3/4" (19mm) rabbeting. Model 37-360 includes a three-phase 3 HP motor that is wired for 220V (can be wired at 460V). Model 37-361 includes a single phase 3 HP motor wired for 230V. Both include a fence, three-knife cutterhead, cutterhead guard, and push blocks.

DEFINITIONS OF JOINTING AND PLANING OPERATIONS



Fig. 2

JOINTING OPERATIONS – Jointing cuts or edge jointing is the simplest and most common operation which can be done on the jointer and these cuts are made to square an edge of a workpiece. The fence is square with the table and the depth of cut is approximately 1/8 inch. 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, as shown in Fig. 2. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table.

⚠ WARNING

Never pass your hands directly over the cutterhead. Use push blocks to feed the workpiece whenever possible.

The hand over the outfeed table presses the work down so that the newly-formed surface will make perfect contact with the table. The hand over the infeed table (usually the right hand) exerts no downward pressure, but simply advances the work to the cutterhead. Both hands exert pressure to keep the work in contact with the fence.



Fig. 3

PLANING OPERATIONS – Planing or surfacing is identical to the jointing operation except for the position of the workpiece. For planing, the major flat surface of the workpiece is placed on the infeed table of the jointer with the narrow edge of the workpiece against the fence, as shown in Fig. 3. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table establishing a flat surface on the workpiece. Always use push blocks when performing planing operations and **NEVER** pass your hands directly over the cutterhead.

UNPACKING AND CLEANING

Carefully unpack the machine and all loose items from the shipping container(s). Remove the protective coating from all unpainted surfaces. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the unpainted surfaces with a good quality household floor paste wax.

NOTICE: THE PHOTO ON THE MANUAL COVER ILLUSTRATES THE CURRENT PRODUCTION MODEL. ALL OTHER ILLUSTRATIONS CONTAINED IN THE MANUAL ARE REPRESENTATIVE ONLY AND MAY NOT DEPICT THE ACTUAL COLOR, LABELING OR ACCESSORIES AND ARE INTENDED TO ILLUSTRATE TECHNIQUE ONLY.

REMOVING SHIPPING CRATE

Your new 12" Jointer is shipped complete in one wooden shipping crate. Remove the crate from around the machine leaving the bottom of the machine fastened to the shipping skid at this time. Remove the fence assembly, dust hood and all loose items from the shipping crate. Figure 4 illustrates all the loose items supplied with your machine.

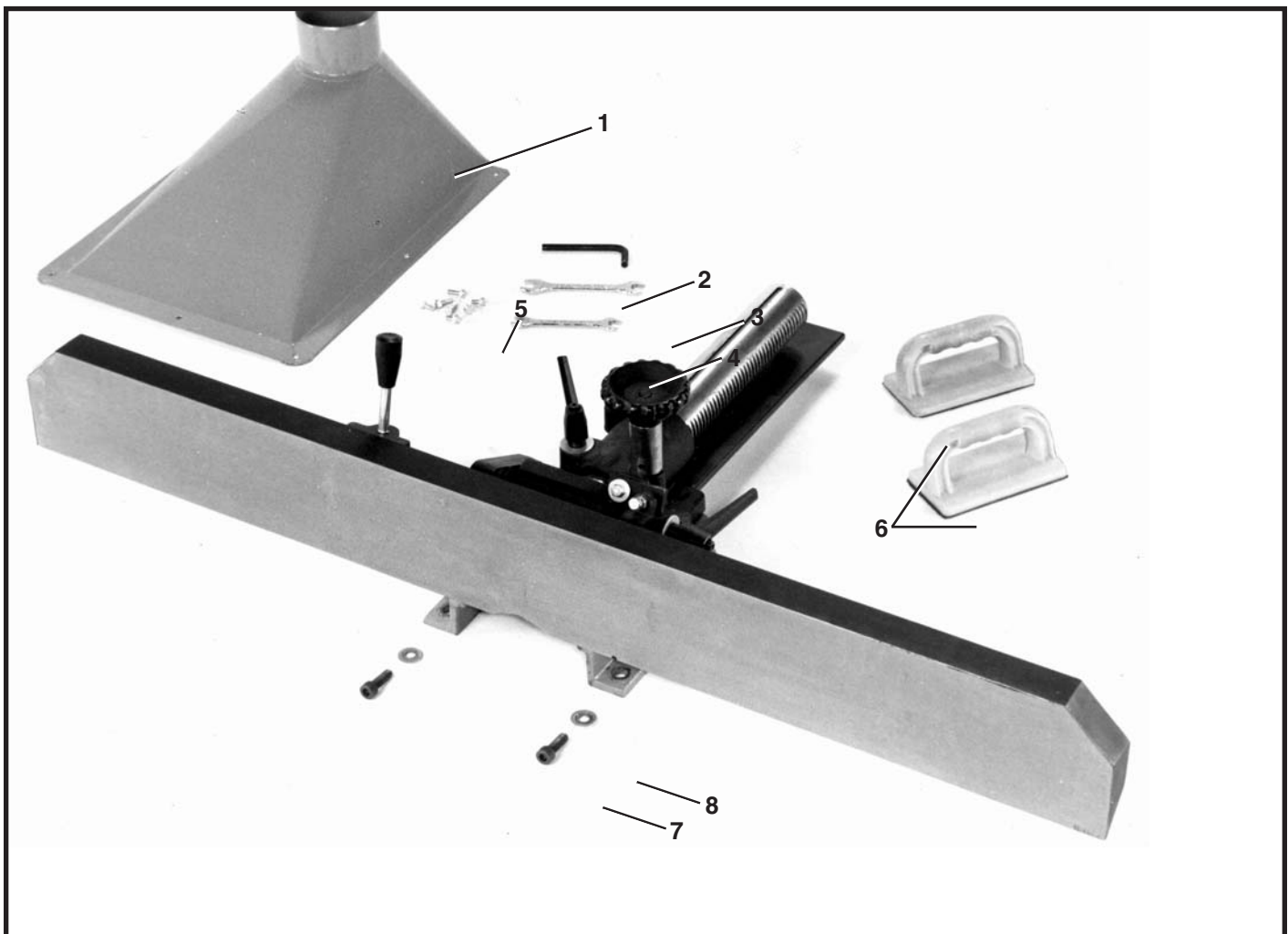


Fig. 4

- | | | |
|-----------------------------------------|-------------------------------------------|---------------------------------------------------|
| 1 - Dust Hood | 6 - Push Blocks (2) | 10 - 4mm T-Handle wrench
(not shown) |
| 2 - 8mm Hex wrench | 7 - 1-1/8" long
Socket Head Screws (2) | 11 - 3mm and 10mm Hex wrench
(not shown) |
| 3 - 12 and 14mm open end wrench | 8 - Flat Washers (2) | 12 - 17mm and 19mm Open end
wrench (not shown) |
| 4 - 10 and 12mm open end wrench | 9 - Fence Assembly | |
| 5 - 5/8" long Button Head
Screws (7) | | |

REMOVING MACHINE FROM SHIPPING SKID

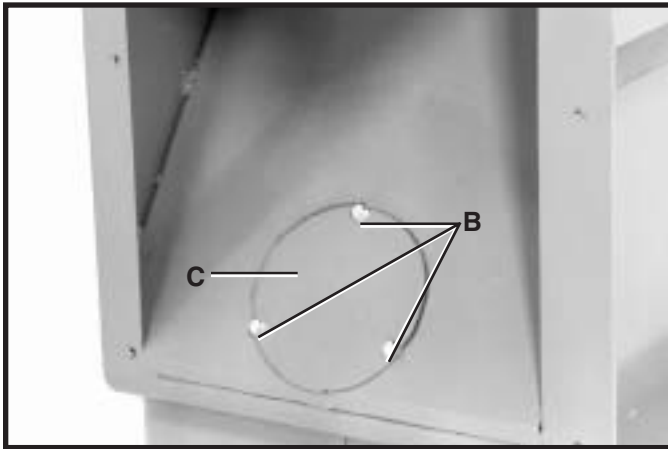


Fig. 6

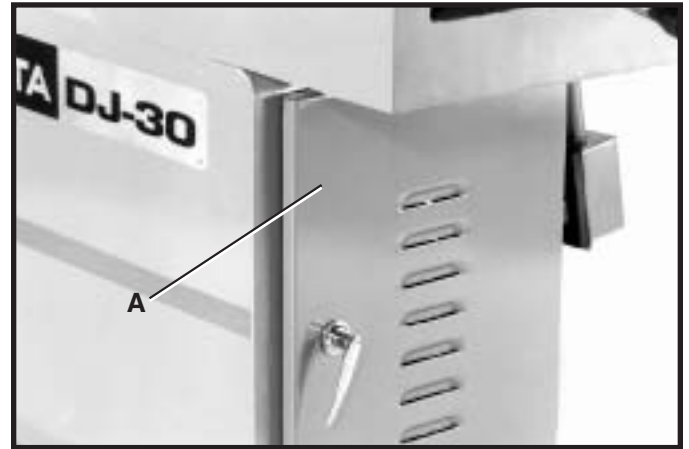


Fig. 5

1. Open door (A) Fig. 5, under infeed table and remove mounting hardware that fastens infeed end of machine to skid
2. Remove three screws (B) Fig. 6, and remove cover (C) from dust chute located under outfeed table. Remove mounting hardware located inside cover (C) that fastens outfeed end of machine to skid and replace cover (C).



Fig. 7

3. Remove machine from shipping skid and position in permanent location.

⚠ WARNING THE JOINTER IS VERY HEAVY AND A FORKLIFT OR HOIST WITH STRAPS UNDER THE TABLE BRACKETS SHOULD BE USED TO MOVE THE MACHINE.

Figure 7 illustrates the machine removed from the shipping skid.

SELECTING FLOOR SPACE

It is important that the machine be set on a solid, level foundation. If rocking occurs, place metal shims at the corners between the base and the floor. Lag screws or bolts may be used if desired to secure the machine to the floor using the same holes that fastened the machine to the shipping skid.

ASSEMBLY

ASSEMBLING DUST HOOD

1. Assemble the dust hood (A) Fig. 8, to the outfeed end of the jointer base using the seven 5/8" long button head screws (B) as shown.

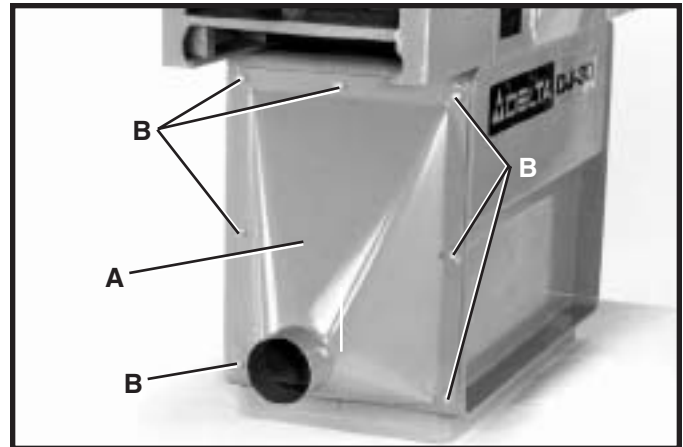


Fig. 8

MOVING START-STOP SWITCH TO THE UP POSITION

1. For shipping purposes, the start-stop switch and switch arm (A) is shipped in the down position, as shown in Fig. 9. Simply remove the two screws (B) Fig. 9, rotate switch and switch arm (A) 180 degrees, as shown in Fig. 10, and replace the two screws (B).

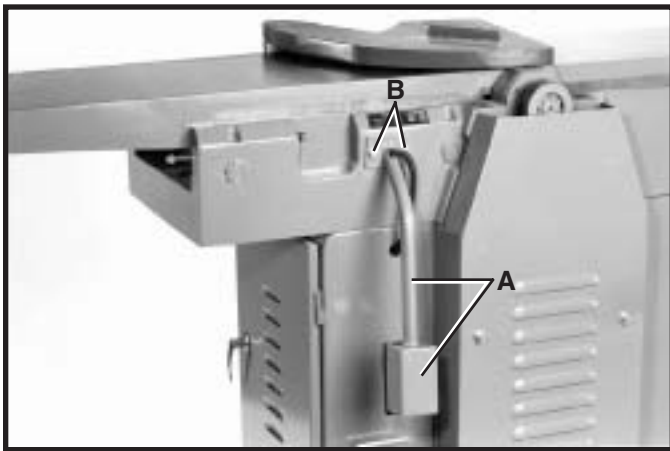


Fig. 9

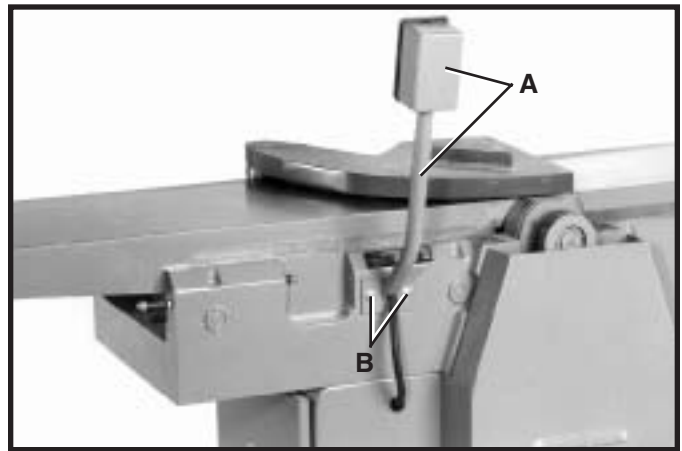


Fig. 10

ASSEMBLING JOINTER FENCE

1. Assemble the jointer fence assembly (A) Fig. 11, to the machine cabinet, as shown, using the two 1-1/8" long screws (B) and flat washers supplied.

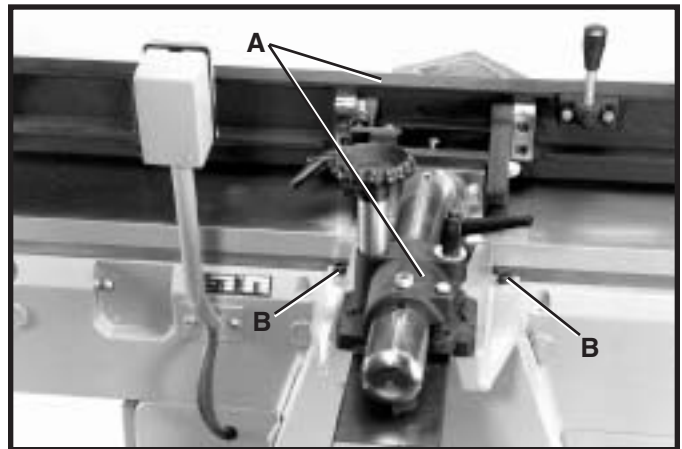


Fig. 11

SINGLE PHASE INSTALLATION

IMPORTANT: The jointer cutterhead is a high inertia load which causes the motor to draw a high inrush current during starting. The jointer must be connected to an electrical circuit protected by a properly sized fuse or circuit breaker to handle this high inrush of current. We recommend either a 30 Amp time lag fuse, or a 40 Amp motor start circuit breaker.

If your machine is supplied with single phase electricals, proceed as follows when connecting your machine to an electrical power system:

1. Remove screw (A) Fig. 12, and terminal strip cover (B).

2. Remove plastic covering (C) Fig. 13, that snaps into terminal strip.

3. Bring power line through access hole in bottom of terminal strip box and connect the two power lines to terminals (D) Fig. 14, and the green ground wire to ground screw (E).

4. Replace plastic covering (C) Fig. 13, and terminal strip cover removed in **STEP 1**.

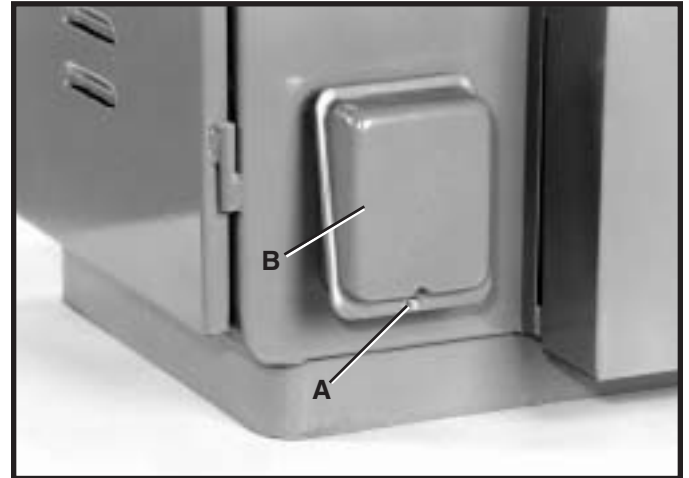


Fig. 12



Fig. 13



Fig. 14

THREE PHASE INSTALLATION

If the motor on your machine is wired for 200, 230 or 460 Volts, Three Phase, proceed as follows when connecting your machine to an electrical power system.

1. Remove screw (A) Fig. 15, and terminal strip cover (B).

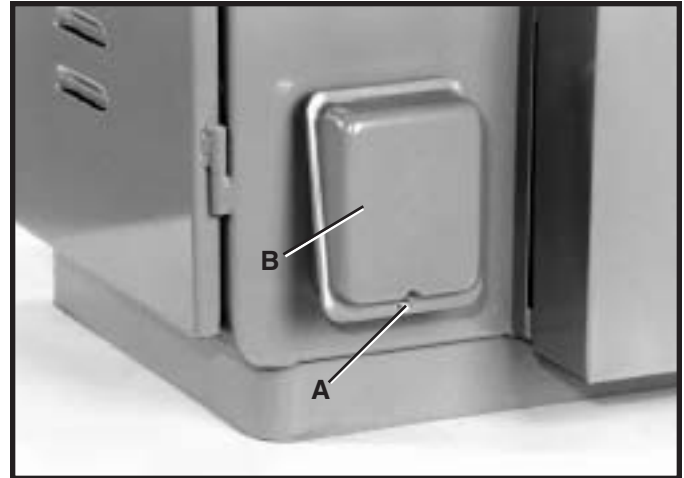


Fig. 15

2. Remove plastic covering (C) Fig. 16, that snaps into terminal strip.



Fig. 16

3. Bring three phase power line through access hole in bottom of terminal strip box and connect the three power lines to terminals (D) Fig. 17, and the green ground wire to ground screw (E).

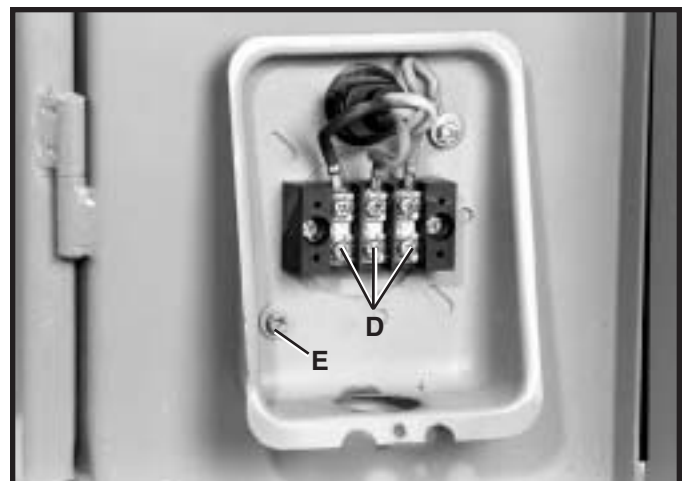


Fig. 17

⚠ WARNING The rotation of the cutterhead must be in a clockwise direction when viewed from the left side of the machine; that is, the knives must be rotating toward the infeed table from the top. If the cutterhead rotation is incorrect, disconnect the machine from the power source and interchange any two of the three incoming power lines connected to terminals (D) Fig. 17.

OPERATING CONTROLS AND ADJUSTMENTS

START-STOP SWITCH

The start-stop switch is conveniently located on a post, behind the jointer fence, for easy accessibility. To start the machine, simply press the start button (A) Fig. 18, and to stop the machine, press the stop button (B).

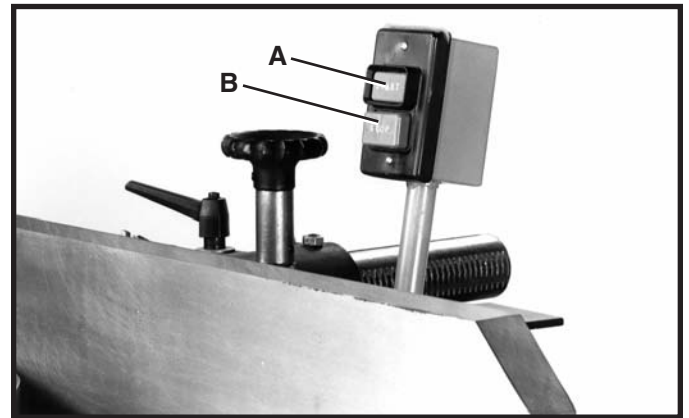


Fig. 18

FENCE OPERATION

1. The fence (A) Fig. 19, can be moved across the table by loosening lock lever (B) and rotating handwheel (C). After the fence is moved to its desired position, retighten lock lever (B) securely. **NOTE:** Lock lever (B) can be repositioned by pulling out the handle and repositioning it on the serrated nut located underneath the hub of the handle. As the fence (A) is moved across the table, the sliding portion of the column (D) guards the cutterhead in back of the fence as shown.

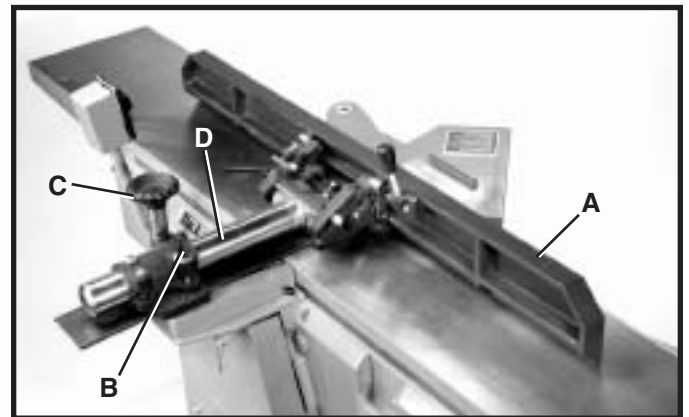


Fig. 19

2. To tilt the fence (A) to the right, as shown in Fig. 20, or to the left, as shown in Fig. 21, loosen lock handle (E) move the fence to the desired angle and tighten handle (E) securely. **NOTE:** Handle (E) Figs. 20 and 21, is spring-loaded and can be repositioned by pulling out the handle and repositioning it on the serrated nut located underneath the hub of the handle. Also, when tilting the fence to the right (outward) as shown in Fig. 20, the stop (F) Fig. 20, must be rotated to the up position as shown. **IMPORTANT:** When cutting a bevel, we suggest that whenever possible the fence (A) be tilted toward the table, as shown in Fig. 21. The fence will then form a V-shape with the tables, and the work is easily pressed into the pocket while passing it across the knives.

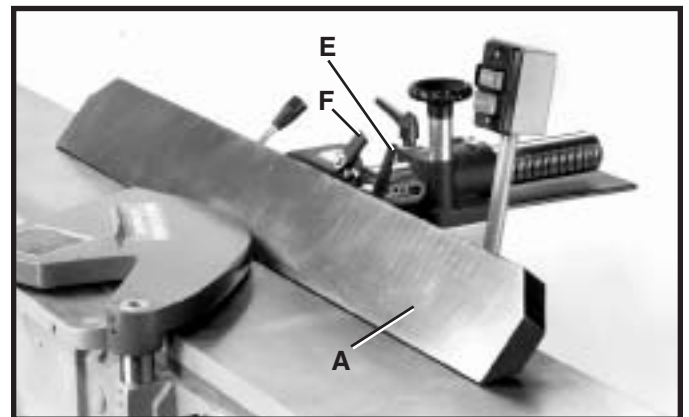


Fig. 20

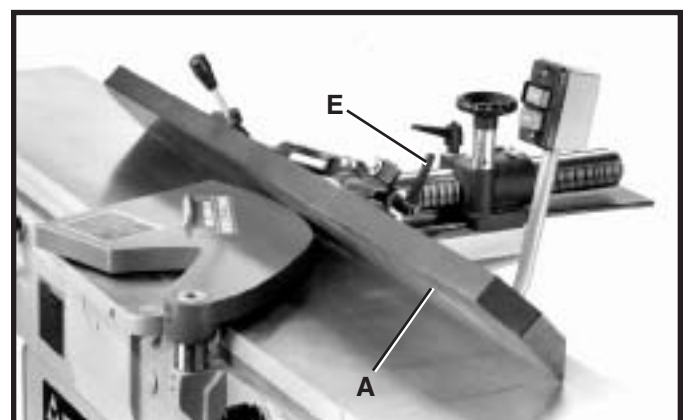


Fig. 21

ADJUSTING FENCE POSITIVE STOPS

The fence on your jointer is equipped with positive stops at the most used fence positions of 90 degrees and 45 degrees right and left. To check and adjust the positive stops, proceed as follows:

1. Position the fence 90 degrees to the table making sure end of stop screw (A) is against stop (B) as shown in Fig. 22. Then tighten lock handle (C).
2. Using a square (D) Fig. 23, check to see if the fence is at 90 degrees to the table as shown.
3. If the fence is not at 90 degrees to the table, loosen lock handle (C) Fig. 22, and lock nut (E). Turn stop screw (A) until end of screw (A) contacts stop (B) when fence is 90 degrees to the table and lock handle (C) is tightened.

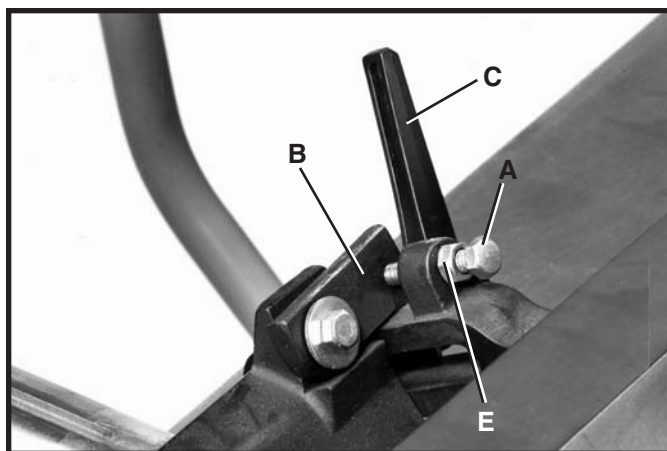


Fig. 22

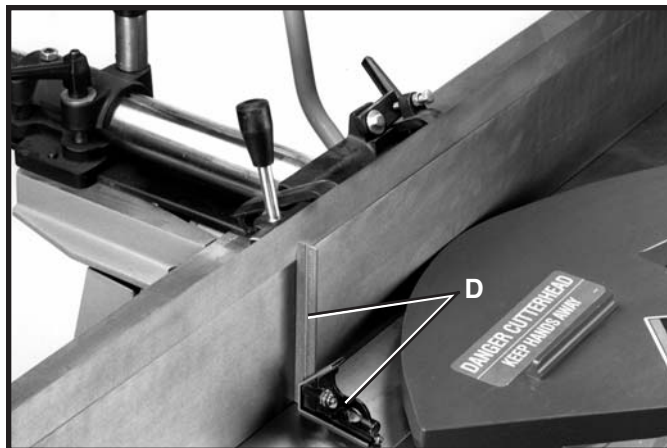


Fig. 23

4. Tilt the fence inward as far as possible and using a combination square (F) Fig. 24, check to see if the fence is tilted inward 45 degrees to the table, as shown. If an adjustment is necessary, loosen nuts (G) Fig. 25, and adjust screws (H) until ends of screws (H) contact brackets (J) when the fence is at 45 degrees to the table.

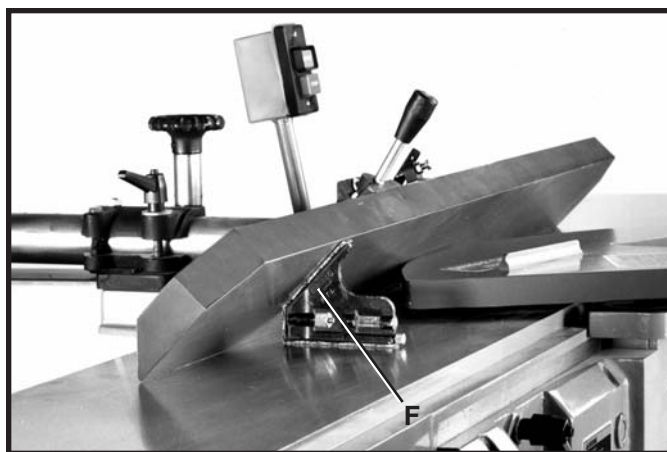


Fig. 24

⚠ WARNING Always make certain the fence locking handle (E) is tightened before operating machine.

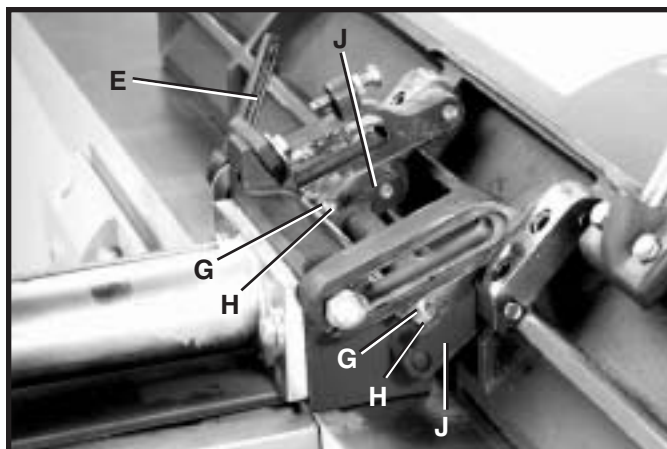


Fig. 25

5. Tilt the fence outward as far as possible and using a combination square (F) Fig. 26, check to see if the fence is tilted outward 45 degrees to the table, as shown. **NOTE:** 90 degree stop (B) must be rotated up in order to tilt the fence outward. If an adjustment is necessary, loosen lock nut (K) Fig. 27, and adjust screw (L) until head of screw (L) contacts back of fence (M) when the fence is at 45 degrees to the table.

⚠ WARNING Always make sure fence locking handle (E) is tightened before operating machine.

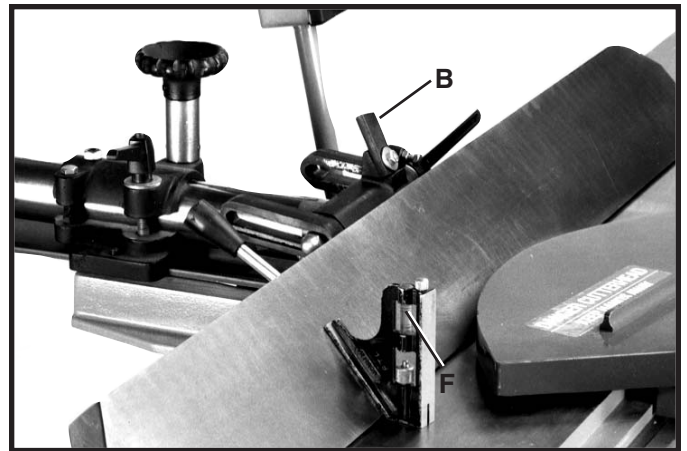


Fig. 26

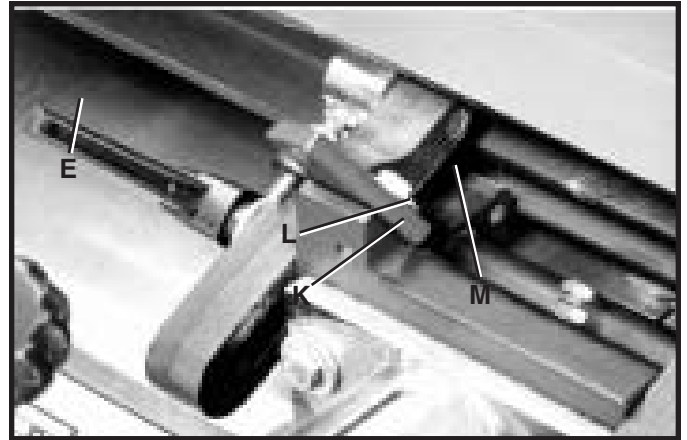


Fig. 27

INFEED TABLE ADJUSTMENTS

To raise or lower the infeed table, loosen table lock handle (A) Fig. 28, and move the table raising and lowering hand lever (B) up or down until the table is at the desired position and tighten table lock handle (A). **NOTE:** The table lock handle (A) can be repositioned by pulling out the handle and repositioning it on the serrated nut located under the handle.

The depth of cut of the infeed table (position of table in relationship with the cutting circle) can be read with the English/Metric scale and pointer (G) Fig. 28.

Positive stops are provided on the jointer to limit the height and depth of the infeed table. To adjust the stops, simply loosen two locknuts (C) and (D) Fig. 29, and turn the two adjustment screws (E) and (F) as necessary. Retighten locknuts (C) and (D). We recommend that the height of the infeed table be adjusted so the table at its highest point will be 1/2mm below the highest point of the knives. This is an important feature of your jointer which enables you to rapidly position the infeed table for a finish or a final cut.

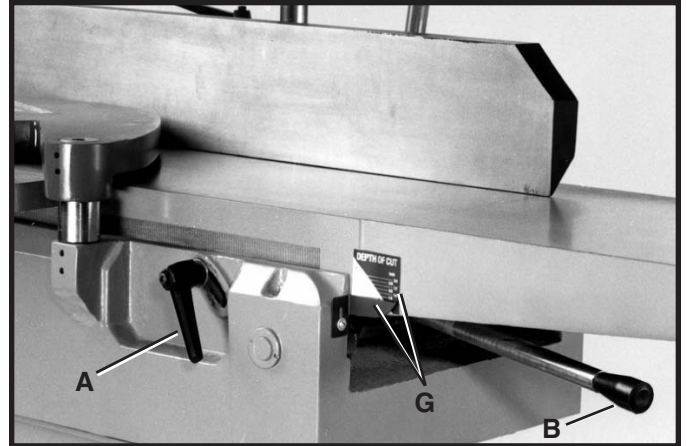


Fig. 28

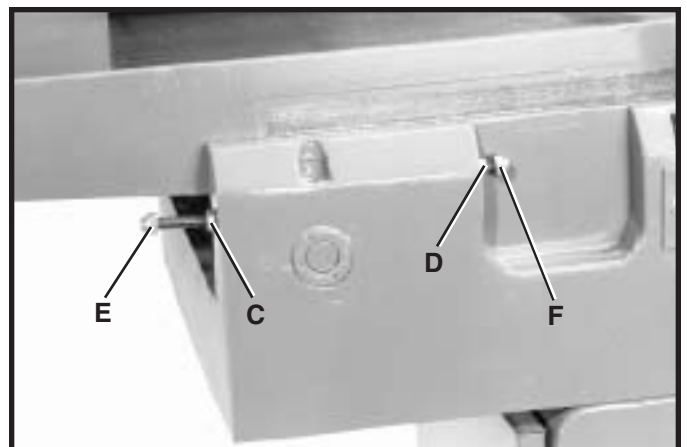


Fig. 29

OUTFEED TABLE ADJUSTMENTS

For most jointing operations the outfeed table must be exactly level with the knives at their highest point of revolution. To move the outfeed table, loosen lock handle (A)

(A) Fig. 30, and move the table raising and lowering hand lever (B) up or down until the table is level with the knives.

It may be necessary to adjust the positive stops. Loosen the two locknuts (D) and (E) Fig. 31, and the two adjusting screws (F) and (G) when moving the table up or down.

When the table is exactly level with the knives at the highest point of revolution, tighten lock handle (A) Fig. 30, and turn adjusting screw (F) Fig. 31, until it bottoms; then tighten locknut (D). Screw (G) is also a positive stop for the lower limit of the outfeed table. We suggest that this stop also be tightened when the outfeed table is set level with the knives. This will prevent the outfeed table from accidentally being lowered.

ADJUSTING BELT TENSION

The jointer is shipped with two V-belts assembled and properly tensioned to the cutterhead and motor pulley. If it becomes necessary to adjust belt tension, proceed as follows:

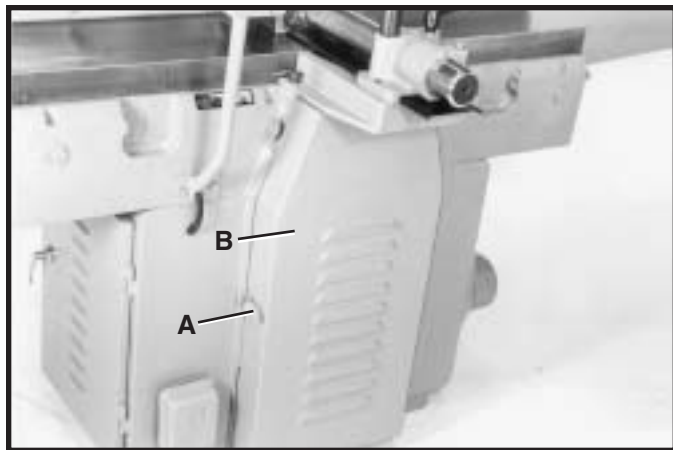


Fig. 32

1. **DISCONNECT THE MACHINE FROM THE POWER SOURCE.**

2. Pull outward on latch handle (A) Fig. 33, and open hinged access door (B).

3. Fig. 31, illustrates the V-belts (C), motor pulley (D) and cutterhead pulley (E). There should be approximately 1/2 inch deflection in the center span of the belts (C) using light finger pressure. To adjust belt tension refer to **STEP 4**.



Fig. 30

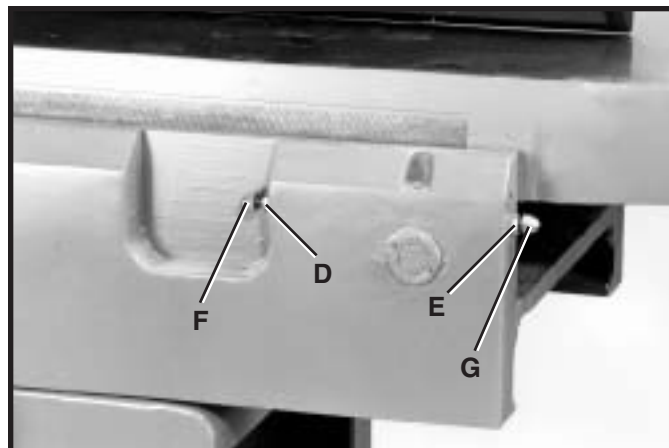


Fig. 31

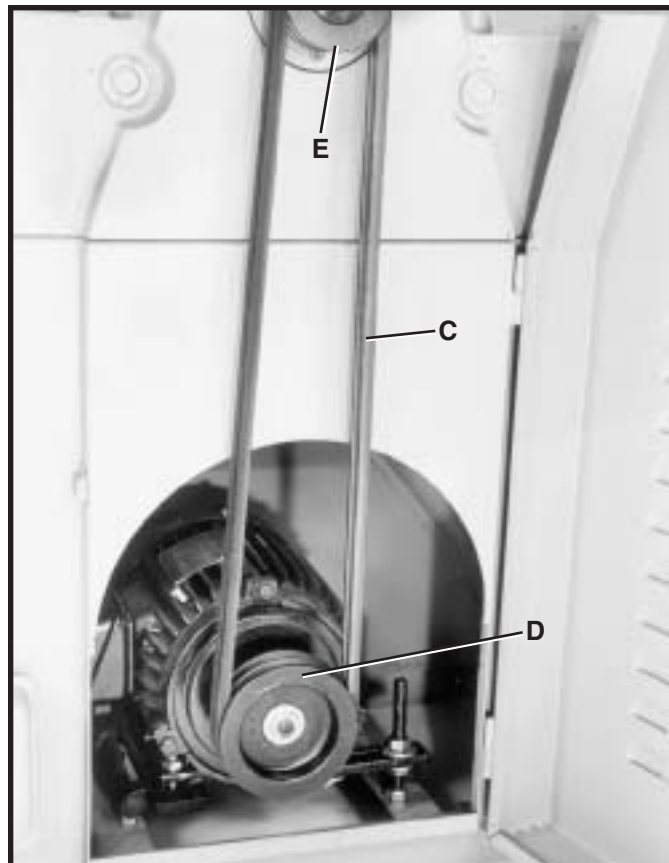


Fig. 33

4. To adjust belt tension, turn nuts (F) and (G) Fig. 34, to move motor plate (H) up or down until there is approximately 1/2 inch deflection at the center span of the belts, as explained in **STEP 3**.

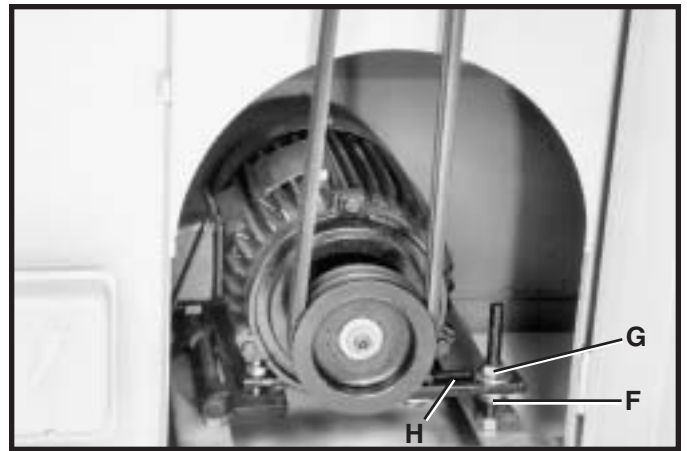


Fig. 34

ADJUSTING SPRING TENSION OF CUTTERHEAD GUARD

The cutterhead guard (A) Fig. 35, completely covers the cutterhead. During operation the material being jointed or planed pushes the guard (A) out of the way and at the completion of the cut, the guard (A) springs back over the cutterhead providing full coverage. If it ever becomes necessary to adjust the spring tension of the cutterhead guard (A), loosen two screws (B) and turn screw (C) clockwise to increase or counterclockwise to decrease the spring tension. Then tighten the two screws (B).

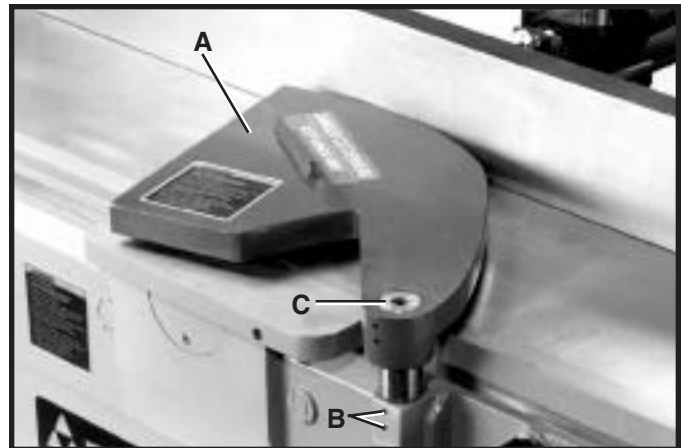


Fig. 35

⚠ WARNING

Before operating jointer, check guard to make sure it functions properly and quickly returns to the closed position.

OPERATION

CUTTERHEAD ROTATION

⚠ WARNING The rotation of the cutterhead must be in a clockwise direction when viewed from the left side of the machine; that is, the knives must be rotating toward the infeed table from the top. If the cutterhead rotation is incorrect, disconnect the machine from the power source and proceed as follows:

Single Phase Machines – Interchange leads T5 and T8 in the motor junction box.

Three Phase Machines – Interchange any two of the three incoming power lines.

The following directions will give the beginner a start on jointer operations. Use scrap pieces of lumber to check settings and to get the feel of the operations before attempting regular work.

⚠ CAUTION THE KNIVES ON THE JOINTER WILL NOT WEAR EVENLY BY FEEDING THE WOOD THROUGH THE SAME SPOT ON THE TABLE EVERY TIME. FEED THE WOOD THROUGH THE JOINTER AT DIFFERENT SPOTS ON THE TABLE WHEN POSSIBLE, TO HELP ELIMINATE UNEVEN WEAR OF THE KNIVES.

⚠ WARNING ALWAYS USE CUTTERHEAD GUARD AND KEEP HANDS AWAY FROM CUTTERHEAD. ALWAYS USE PUSH BLOCKS WHENEVER POSSIBLE. NEVER MAKE JOINTING AND PLANING CUTS DEEPER THAN 1/8" IN ONE PASS.

PLACEMENT OF HANDS DURING FEEDING

At the start of the cut, the left hand holds the work firmly against the infeed table and fence, while the right hand pushes the work toward the knives. After the cut is underway, the new surface rests firmly on the outfeed table as shown in Fig. 36. The left hand should then be moved to the work on the outfeed table, at the same time maintaining flat contact with the fence. The right hand presses the work forward, and before the right hand reaches the cutter-head, it should be moved to the work on the outfeed table.

⚠ WARNING NEVER PASS HANDS DIRECTLY OVER THE CUTTERHEAD AND USE PUSH BLOCKS WHENEVER POSSIBLE.

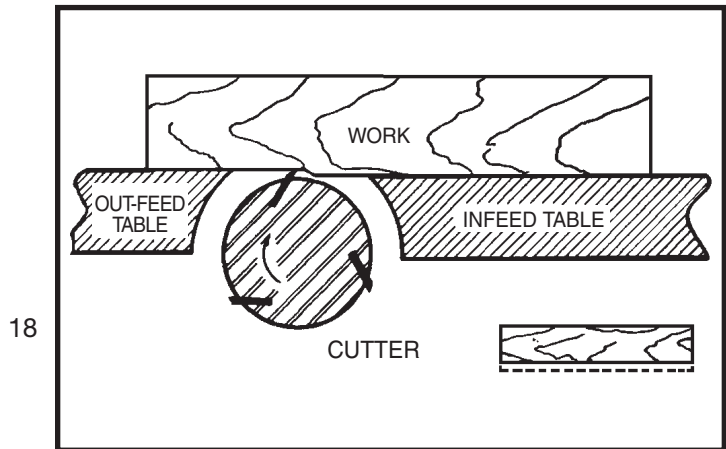


Fig. 36

JOINTING AN EDGE

This is the most common operation for the jointer. Set the guide fence square with the table. Depth of cut should be the minimum required to obtain a straight edge. Hold the best face of the piece firmly against the fence throughout the feed as shown in Fig. 37.

DO NOT perform jointing operations on material shorter than 10 inches, narrower than 3/4 inch or less than 1/2 inch thick.

NEVER pass your hands directly over the cutterhead and use push blocks to feed the workpiece whenever possible.



Fig. 37

PLANING OR SURFACING

Planing or surfacing is identical to the jointing operation except for the position of the workpiece. For planing, the major flat surface of the workpiece is placed on the infeed table of the jointer with the narrow edge of the workpiece against the fence, as shown in Fig. 38. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table establishing a flat surface on the workpiece. Always use push blocks when performing planing operations and **NEVER** pass your hands directly over the cutterhead.

DO NOT perform planing or surfacing operations on material shorter than 10 inches, narrower than 3/4 inch, wider than 12 inches or less than 1/2 inch thick.



Fig. 38

BEVELING

To cut a bevel, lock the fence at the required angle and run the work across the knives while keeping the work firmly against the fence and tables. Several passes may be necessary to arrive at the desired result. When the angle is small, there is little difference whether the fence is tilted to the right or left. However, at greater angles approaching 45 degrees, it is increasingly difficult to hold the work properly when the fence is tilted to the right. The advantage of the double-tilting fence is appreciated under such conditions.

When tilted to the left, the fence forms a V-shape with the tables, and the work is easily pressed into the pocket while passing it across the knives as shown in Fig. 39. If the bevel is laid out on the piece in such direction that this involves cutting against the grain, it will be better to tilt the fence to the right.



Fig. 39

TAPER CUTS

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

Instead of laying the piece on the infeed table, lower the forward end of the work onto the outfeed table. Do this very carefully, as the piece will span the knives and they will take a "bite" from the work, with a tendency to kickback unless the piece is firmly held. Now push the work forward as in ordinary jointing. The effect is to plane off all the stock in front of the knives to 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 according to the regular method for jointing, with the infeed table raised to its usual position.

Practice is required in this operation, and the beginner is advised to make trial cuts on waste material. Taper cuts over part of the length and a number of other special operations can easily be done by the experienced craftsman.

CUTTING A RABBET

When making a rabbet cut, as shown in Fig. 40, the cutterhead guard must be removed. **AFTER THE RABBET CUT IS COMPLETED, BE CERTAIN GUARD IS REPLACED.**

⚠ WARNING Use pushblocks whenever possible, as shown.

1. Adjust the fence so that the distance between the end of the knives and the fence is equal to the width of the rabbet.
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 it 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.



Fig. 40

JOINTING OR PLANING WARPED WOOD

If the wood to be jointed is dished or warped, take light cuts until the surface is flat. Avoid forcing such material down against the table; excessive pressure will spring it while passing the knives, and it will spring back and remain curved after the cut is completed.

DIRECTION OF GRAIN

Avoid feeding the wood into the jointer against the grain as shown in Fig. 41. The result will be chipped and splintered edges. Feed with the grain as in Fig. 42, to obtain a smooth surface.

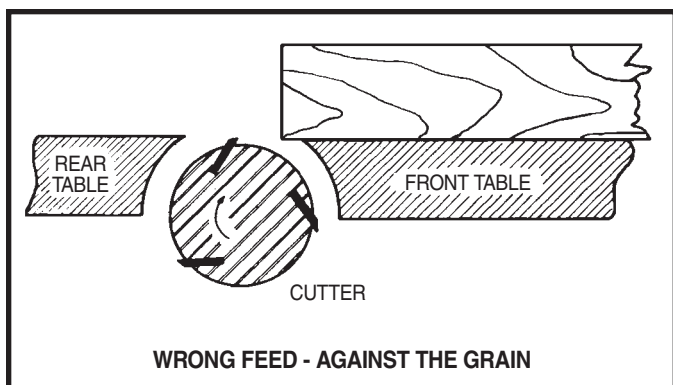


Fig. 41

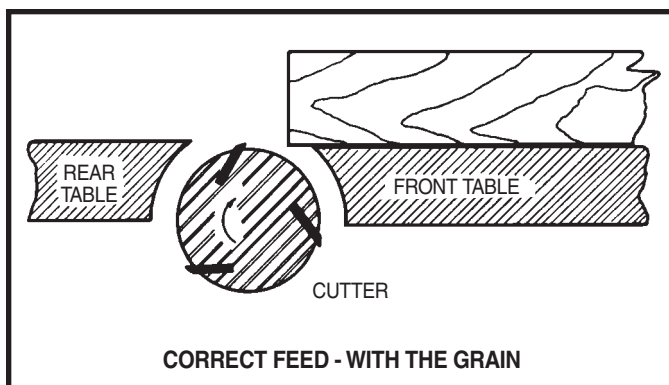


Fig. 42

MAINTENANCE

REMOVING, REPLACING AND SETTING 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 THE POWER SOURCE.**
2. Move the fence to the right until it is clear of the cutterhead.

3. Loosen two screws (A) Fig. 43, and remove cutterhead guard assembly.

⚠ WARNING BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES. WEAR PROTECTIVE GLOVES WHEN HANDLING THE KNIVES.

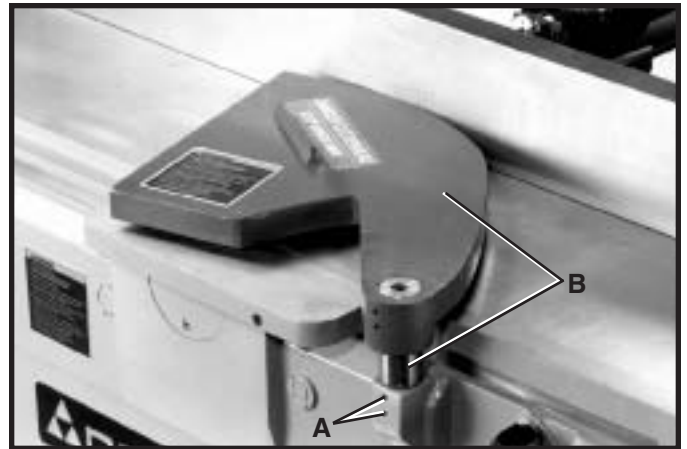


Fig. 43

4. Using wrench (C) Fig. 44, slightly loosen the six knife locking screws (D) in each knife slot by turning the screws (D) clockwise. This relieves stress in the cutterhead.

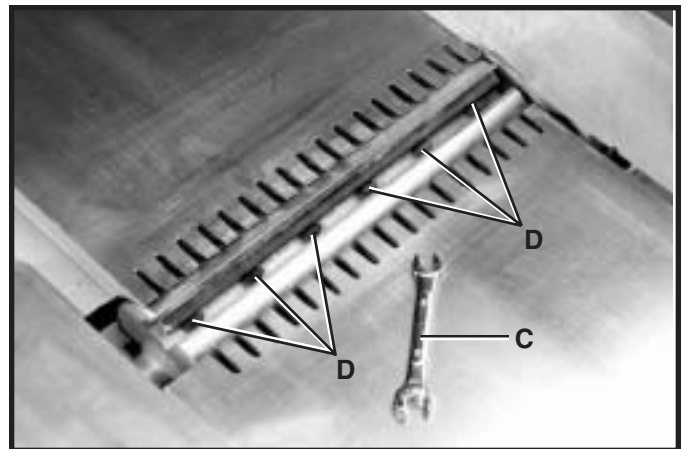


Fig. 44

5. Loosen screws (D) Fig. 44, further, and remove the knife, knife locking bar and lifter springs located under the knives. Remove the remaining two knives in the same manner.

6. Before replacing the knives, make certain the knife locking bars are thoroughly clean and free of gum and pitch and adjust the height of the outfeed table to be .015" above the cutterhead body as follows:

- A. Using a straight edge (E) Fig. 45, and feeler gages (F) that equal .015" adjust the height of the outfeed table to be .015" above the cutterhead body (G). Then lock the outfeed table in place.

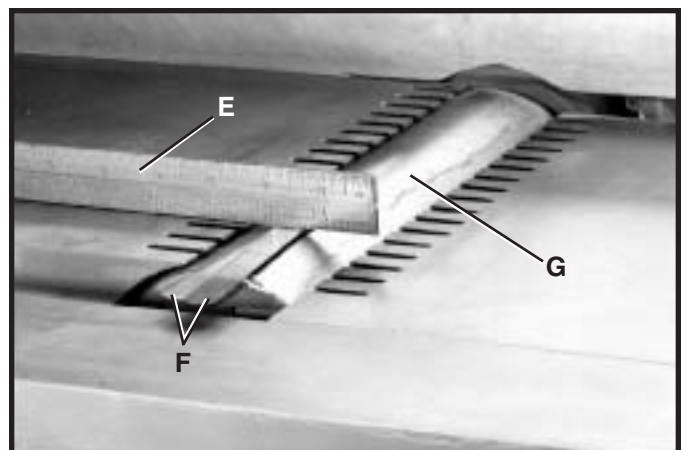


Fig. 45

7. **IMPORTANT:** For ease in rotating the cutterhead during the knife setting operation, pull outward on latch (H) Fig. 46, and open hinged access door (J). This provides access to the cutterhead pulley (K) Fig. 47, and belt (L) allowing you to rotate the cutterhead.

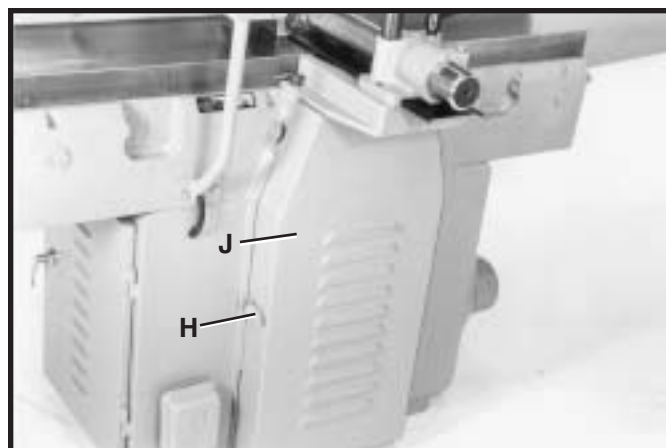


Fig. 46

CAUTION After knives are adjusted, make certain the access door (J) is in the closed and locked position.

8. Replace the knife locking bars, lifter springs and knives into each slot in the cutterhead.

WARNING CARE MUST BE TAKEN WHEN INSERTING THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP. Push the knives down as far as possible and snug up the knife locking screws by turning them counterclockwise just enough to hold the knives in position.

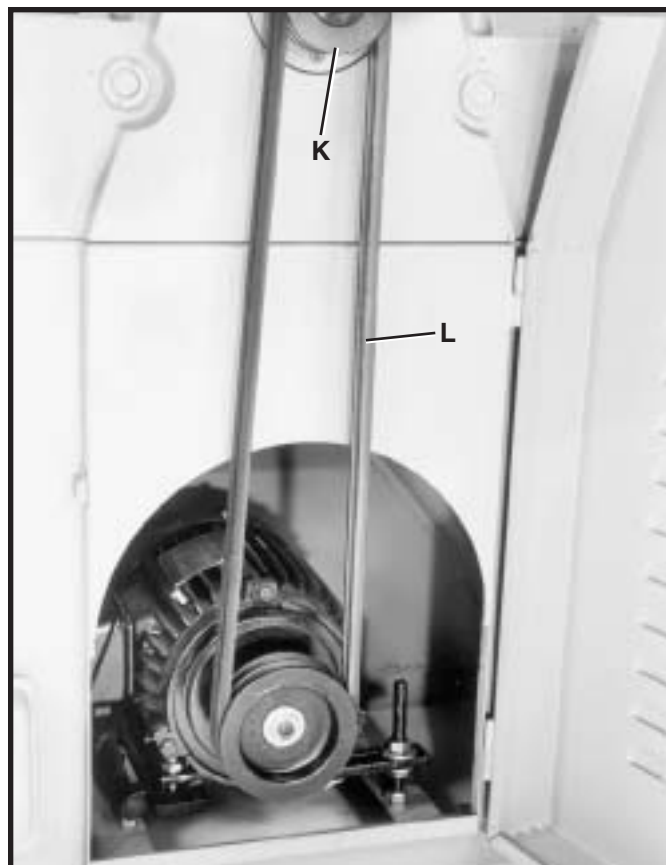


Fig. 47

9. Construct a "U" shaped block out of hardwood similar to the one shown at (M) Fig. 48, and place this block on the rear table over the cutterhead, as shown. Using wrench (C), loosen knife locking screws by turning them clockwise. The knife (O) will lift up and contact the ends of the gage block (M). The knives are adjusted correctly when the cutting edge of the knife contacts the gage block when the knife is at its highest point. When you are certain the knife is adjusted properly, tighten the knife locking screws by turning them counterclockwise.

10. Adjust the remaining two knives in the same manner.

WARNING MAKE CERTAIN THAT ALL KNIVES ARE SECURELY FASTENED IN CUTTERHEAD BEFORE TURNING ON POWER.

11. Replace cutterhead guard.

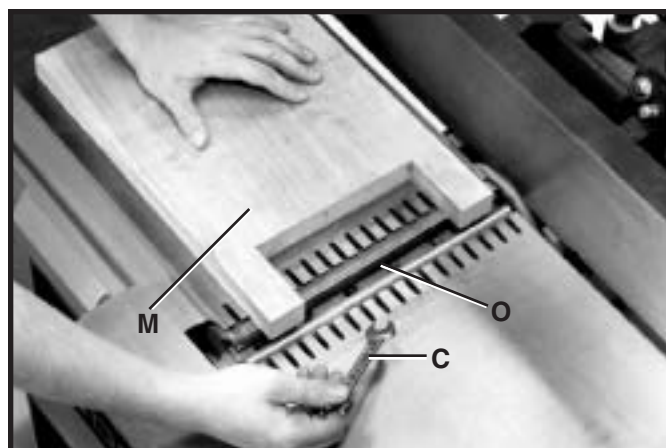


Fig. 48

MAINTENANCE

KEEP MACHINE CLEAN

Periodically blow out all air passages with dry compressed air. All plastic parts should be cleaned with a soft damp cloth. NEVER use solvents to clean plastic parts. They could possibly dissolve or otherwise damage the material.

▲WARNING Wear ANSI Z87.1 safety glasses while using compressed air.

FAILURE TO START

Should your machine fail to start, check to make sure the prongs on the cord plug are making good contact in the outlet. Also, check for blown fuses or open circuit breakers in the line.

LUBRICATION

Apply household floor paste wax to the machine table and extension table or other work surface weekly.

PROTECTING CAST IRON FROM RUST

To clean and protect cast iron tables from rust, you will need the following materials: 1 pushblock from a jointer, 1 sheet of medium Scotch-Brite™ Blending Hand Pad, 1 can of WD-40®, 1 can of degreaser, 1 can of TopCote® Aerosol. Apply the WD-40 and polish the table surface with the Scotch-Brite pad using the pushblock as a holddown. Degrease the table, then apply the TopCote® accordingly.

ACCESSORIES

A complete line of accessories is available from your Delta Supplier, Porter-Cable • Delta Factory Service Centers, and Delta Authorized Service Stations. Please visit our Web Site www.deltamachinery.com for a catalog or for the name of your nearest supplier.

▲WARNING Since accessories other than those offered by Delta have not been tested with this product, use of such accessories could be hazardous. For safest operation, only Delta recommended accessories should be used with this product.



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Authorized Service Stations are located in many large cities. Telephone **800-438-2486** or **731-541-6042** for assistance locating one. Parts and accessories for Porter-Cable-Delta products should be obtained by contacting any Porter-Cable-Delta Distributor, Authorized Service Center, or Porter-Cable-Delta Factory Service Center. If you do not have access to any of these, call **800-223-7278** and you will be directed to the nearest Porter-Cable-Delta Factory Service Center. Las Estaciones de Servicio Autorizadas están ubicadas en muchas grandes ciudades. Llame al **800-438-2486** ó al **731-541-6042** para obtener asistencia a fin de localizar una. Las piezas y los accesorios para los productos Porter-Cable-Delta deben obtenerse poniéndose en contacto con cualquier distribuidor Porter-Cable-Delta, Centro de Servicio Autorizado o Centro de Servicio de Fábrica Porter-Cable-Delta. Si no tiene acceso a ninguna de estas opciones, llame al **800-223-7278** y le dirigirán al Centro de Servicio de Fábrica Porter-Cable-Delta más cercano.

CANADIAN PORTER-CABLE • DELTA SERVICE CENTERS

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Calgary, Alberta
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Fax: (403) 735-6144

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Burnaby, B.C.
V5A 4T8
Phone: (604) 420-0102
Fax: (604) 420-3522

MANITOBA

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Winnipeg, Manitoba
R3H 0H2
Phone: (204) 633-9259
Fax: (204) 632-1976

ONTARIO

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Guelph, Ontario
N1H 6M7
Phone: (519) 767-4132
Fax: (519) 767-4131

QUÉBEC

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St-Jean Baptiste, Suite 160
Québec, Québec
G2E 5E2
Phone: (418) 877-7112
Fax: (418) 877-7123

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St-Laurent, (Montréal),
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