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BISCUIT JOINTER

MODEL No. BJ600

Part No. 6462003

OPERATING & MAINTENANCE

INSTRUCTIONS

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For spare parts and servicing, please contact your nearest dealer, or Clarke International on

020 - 8988 - 7400

e-mail: Parts@clarkeinternational.com e-mail: Service@clarkeinternational.com

Hemnall Street, Epping, Essex CM16 4LG



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HAND-ARM VIBRATION

Employers are advised to refer to the HSE publication "Guide for Employers".

All hand held power tools vibrate to some extent, and this vibration is transmitted to the operator via the handle, or hand used to steady the tool. Vibration from about 2 to 1500 hertz is potentially damaging and is most hazardous in the range from about 5 to 20 hertz.

Operators who are regularly exposed to vibration may suffer from Hand Arm Vibration Syndrome (HAVS), which includes 'dead hand', 'dead finger', and 'white finger'. These are painful conditions and are widespread in industries where vibrating tools are used.

The health risk depends upon the vibration level and the length of time of exposure to it.....in effect, a daily vibration dose.

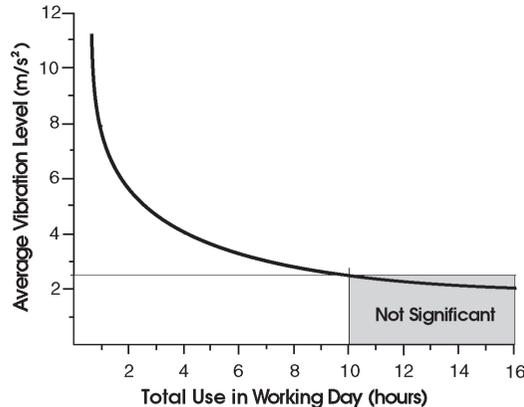
Tools are tested using specialised equipment, to approximate the vibration level generated under normal, acceptable operating conditions for the tool in question. For example, a grinder used at 45° on mild steel plate, or a sander on softwood in a horizontal plane etc.

These tests produce a value 'a', expressed in metres per second per second, which represents the average vibration level of all tests taken, in three axes where necessary, and a second figure 'K', which represents the uncertainty factor, i.e. a value in excess of 'a', to which the tool could vibrate under normal conditions. These values appear in the declaration on page 7.

You will note that a third value is given in the specification - the highest measured reading in a single plane. This is the maximum level of vibration measured during testing in one of the axes, and this should also be taken into account when making a risk assessment.

'a' values in excess of 2.5 m/s² are considered hazardous when used for prolonged periods. A tool with a vibration value of 2.8 m/s² may be used for up to 8 hours (cumulative) per day, whereas a tool with a value of 11.2 m/s² may be used for ½ hour per day only.

The graph below shows the vibration value against the maximum time the respective tool may be used, per day.



The uncertainty factor should also be taken into account when assessing a risk. The two figures 'a' and 'K' may be added together and the resultant value used to assess the risk.

It should be noted that if a tool is used under abnormal, or unusual conditions, then the vibration level could possibly increase significantly. Users must always take this into account and make their own risk assessment, using the graph as a reference.

Some tools with a high vibration value, such as impact wrenches, are generally used for a few seconds at a time, therefore the cumulative time may only be in the order of a few minutes per day. Nevertheless, the cumulative effect, particularly when added to that of other hand held power tools that may be used, must always be taken into account when the total daily dose rate is determined.

This is an important document and should be retained

DECLARATION OF CONFORMITY



We declare that this product complies with the following standards/directives:

98/37/EEC
89/336/EEC
72/23/EEC

MODEL No:	BJ600
DESCRIPTION:	BISCUIT JOINTER

Declared vibration emission value in accordance with EN12096

Measured vibration emission value - a: 2.28 m/s²

Uncertainty value - K: 5.57 m/s²

Highest measured reading in a single plane 8.18 m/s²

Values determined according to EN50144-1

IMPORTANT!



When disposing of this product, ensure it is disposed of according to all local ordinances

Please read these instructions carefully before operating the tool

Thank you for purchasing this **CLARKE** biscuit jointer. Before using the device, please read this manual thoroughly and carefully follow all instructions given. This is for your own safety and that of others around you, and is also to help you achieve a long and trouble free service from your new tool.

CLARKE GUARANTEE

This CLARKE product is guaranteed against faulty manufacture for a period of 12 months from the date of purchase. Please keep your receipt as proof of purchase.

This guarantee is invalid if the product is found to have been abused or tampered with in any way, or not used for the purpose for which it was intended.

Faulty goods should be returned to their place of purchase, no product can be returned to us without prior permission.

This guarantee does not affect your statutory rights.

PARTS & SERVICE TEL: 020 8988 7400

or e-mail as follows:

PARTS: Parts@clarkeinternational.com

SERVICE: Service@clarkeinternational.com

PARTS LIST

Item	Part No	Description	Qty	Item	Part No	Description	Qty
1	HT60001	Pin Cap	1	38	HT60038	Screw M4x14	2
2	HT60002	Pin Spring	1	39	HT60039	Gib	2
3	HT60003	Gear Case	1	40	HT60040	Screw M4x12	4
5	HT60005	Pinion	1	41	HT60041	Inner Flange	1
6	HT60006	Ball Bearing 6000	1	42	HT60042	Cutter	1
7	HT60007	Bearing Retainer	1	43	HT60043	Outer Flange	1
8	HT60008	Armature	1	44	HT60044	Base Assembly	1
9	HT60009	Dust Guard	1	45	HT60045	C/Sunk Screw M5x10	2
10	HT60010	Ball bearing 606	1	46	HT60046	Carrier Support	1
11	HT60011	Fan Baffle	1	47	HT60047	Screw M4 x 4	1
12	HT60012	Screw ST3x10	1	48	HT60048	Scale	1
13	HT60013	Stator	1	49	HT60049	Compression Spring	2
14	HT60014	Switch Pusher	1	50	HT60050	Gripper	2
15	HT60015	Rod	1	51	HT60051	Screw M5x25	2
16	HT60016	Spring	1	52	HT60052	Knob	1
17	HT60017	Stator Case	1	53	HT60053	Clamp	1
18	HT60018	Brush holder	2	54	HT60054	Indicator	1
19	HT60019	Brush	2	55	HT60055	'O' Ring	1
20	HT60020	Brush Cover	2	56	HT60056	Pinion & Rod	1
21	HT60021	Switch	1	57	HT60057	Knob	1
22	HT60022	Joint	1	58	HT60058	Washer	1
23	HT60023	Screw ST4x14	2	59	HT60059	Screw M4x8	1
24	HT60024	Cord Clamp	1	60	HT60060	Fence Angle Scale	1
25	HT60025	Rear Cover	1	61	HT60061	Fence	1
26	HT60026	Screw ST4x16	2	62	HT60062	Screw M5x22	2
27	HT60027	Cord & Plug	1	63	HT60063	Screw M4x8	1
28	HT60028	Cord Protector	1	64	HT60064	Pointer	1
29	HT60029	Shoulder Screw	1	65	HT60065	Handle	1
30	HT60030	Stop	1	66	HT60066	Screw M8x16	1
31	HT60031	Gear Case Cover	1	67	HT60067	Spring Link	1
32	HT60032	Lock Pin	1	68	HT60068	Screw M4x12	2
33	HT60033	Output Shaft	1	69	HT60069	Gear Washer	1
34	HT60034	Gear	1	70	HT60070	Ball Bearing 6201	1
35	HT60035	Guide	1	71	HT60071	Spring Washer	1
36	HT60036	Compression Spring	1	72	HT60072	Screw M5x6	1
37	HT60037	Shaft Screw	1				

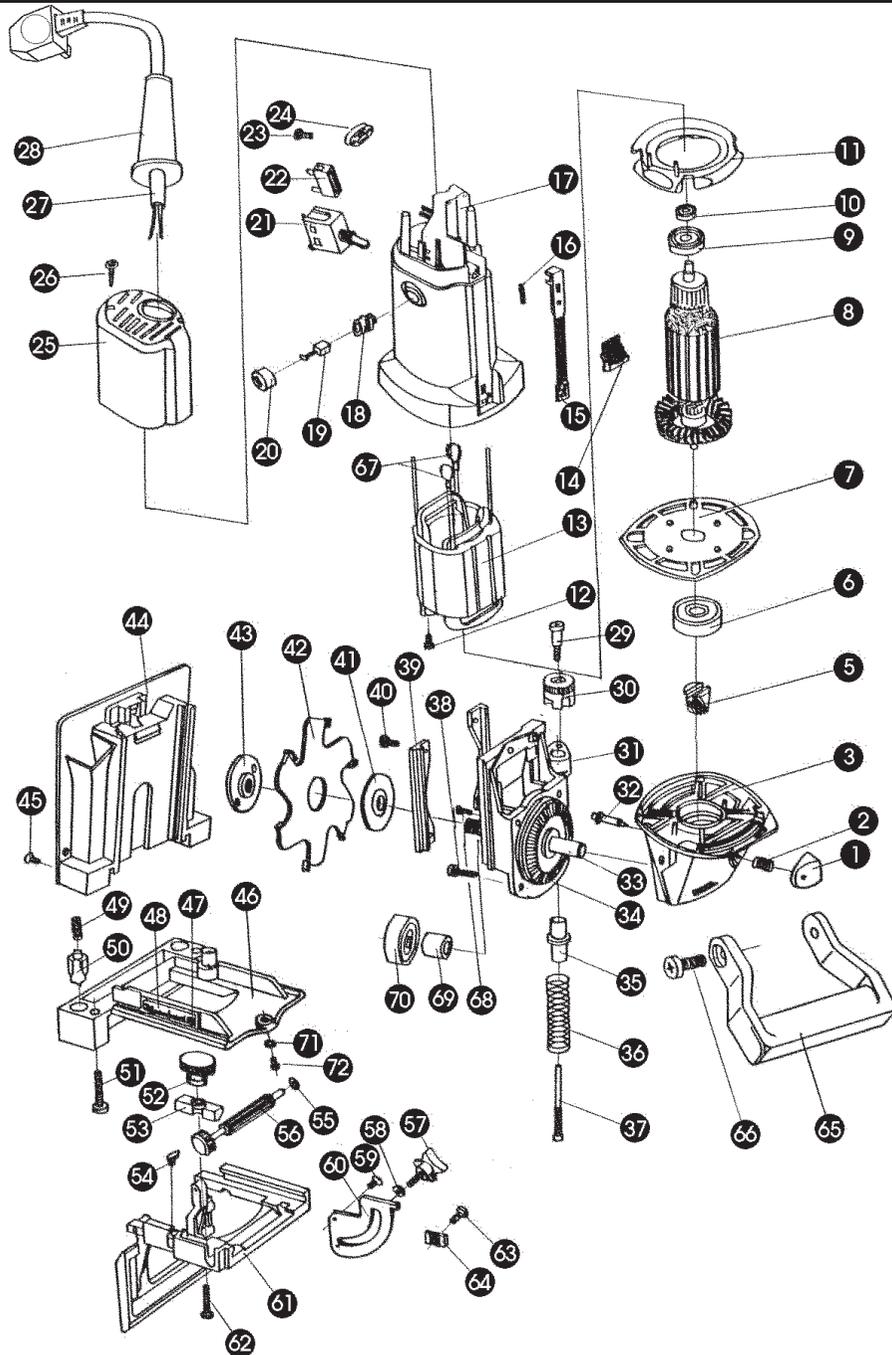
PARTS & SERVICE TEL: 020 8988 7400

or e-mail as follows:

PARTS: Parts@clarkeinternational.com

SERVICE: Service@clarkeinternational.com

PARTS DIAGRAM



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SPECIFICATIONS

Model :	BJ600
Part No :	6462003
Voltage :	230vac - 50Hz
Power Rating :	600watt Motor
Fuse Rating :	13amp
No Load Speed :	10,000 rpm
Saw Blade :	Carbide Tipped
Blade Diameter :	100mm (4")
Number of Teeth :	6
Arbor :	22mm
Sound Power level :	97.5 dBLwa
Vibration :	See Page 2 & 17

Please note that the details and specifications contained herein are correct at the time of going to print. However CLARKE International reserve the right to change specifications at any time without prior notice. Always consult the machines data plate

ACCESSORIES

The biscuit jointer is supplied with the following accessories as standard:

1. Carbide-Tipped Blade.
2. Pin Wrench.
3. Dust Bag & Dust Extractor Adapter.
4. Operating and Maintenance Instructions.

ELECTRICAL CONNECTIONS



This product is provided with a standard 13 amp, 230 volt (50Hz), BS 1363 plug, for connection to a standard, domestic electrical supply. Should the plug need changing at any time, ensure that a plug of identical specification is used.



WARNING



This appliance is Doubly Insulated, and the two wires in the mains lead should be wired up in accordance with the following colour code:

BLUE - NEUTRAL

BROWN - LIVE

- Connect the BLUE coloured cord to the plug terminal marked a letter "N"
- Connect the BROWN coloured cord to the plug terminal marked a letter "L"

If this appliance is fitted with a plug which is moulded on to the electric cable (i.e. non-rewireable) please note:

1. The plug must be thrown away if it is cut from the electric cable. There is a danger of electric shock if it is subsequently inserted into a socket outlet.
2. Never use the plug without the fuse cover fitted.
3. Should you wish to replace a detachable fuse carrier, ensure that the correct replacement is used (as indicated by marking or colour code).
4. Replacement fuse covers can be obtained from your local dealer or most electrical stockists.

Fuse Rating

The fuse in the plug must be replaced with one of the same rating (**13 amps**) and this replacement must be ASTA approved to BS1362.

If in doubt, consult a qualified electrician. Do not attempt any electrical repairs yourself.

Cable Extension

Always use an approved cable extension suitable for the power rating of this tool (see specifications), the conductor size should also be at least the same size as that on the machine, or larger. When using a cable reel, always unwind the cable completely.

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TROUBLE SHOOTING

Biscuit Jointer is overheating

This indicates the machine is dirty. Clean the ventilation holes, and blow out with compressed air or clean with a dry cloth.

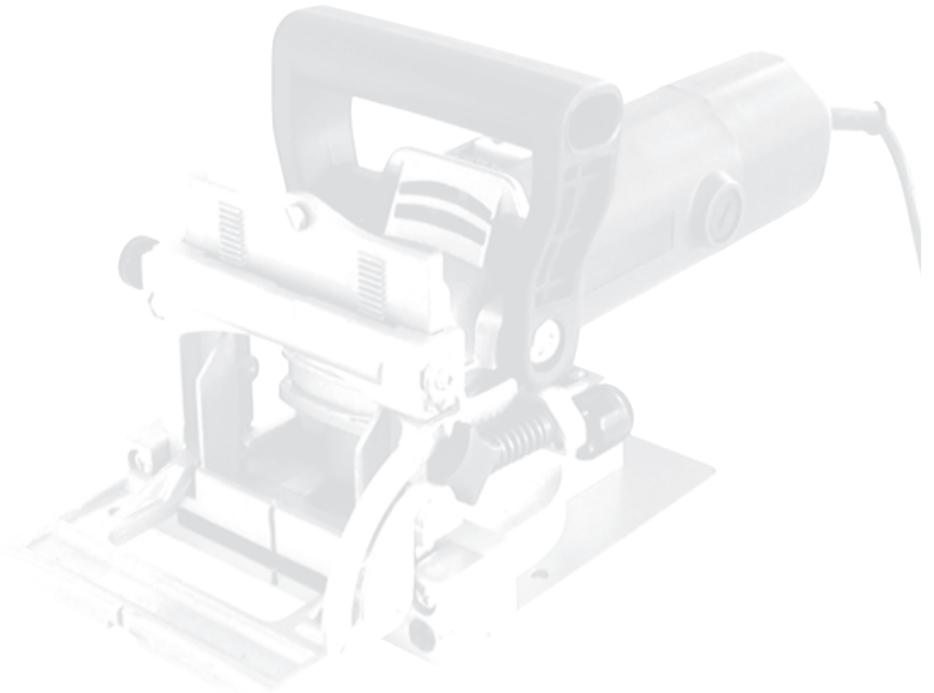
Overloading the machine will also cause overheating. Do not use for heavy duty work, and do not apply excessive pressure.

Excessive sparking occurs

This indicates worn brushes. This problem is quickly remedied but you should consult your CLARKE dealer for parts and advice.

Biscuit Jointer does not operate when switched ON

Check to ensure the fuse is sound and replace if necessary. If the fuse or blows repeatedly, consult your CLARKE dealer.



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DUST EXTRACTION

The jointer is provided with a dust extraction facility, where a vacuum extractor or dust bag may be connected to the outlet at the rear of the machine. An adapter is provided for this purpose. Please note however, that this does not preclude the user from wearing a face mask to prevent the inhalation of dust particles.

Fitting The Dust Extractor

1. Lay the base of the biscuit jointer down on a flat surface.
2. Insert adapter into the dust exhaust port, attach the dust bag ensuring the zip is facing downwards. Alternatively, fit the right angled adapter and attach a dust extractor hose (Vacuum cleaner or similar).

Removing The Adaptor

1. Remove the dust bag, if fitted and empty contents into waste bin/bag. If using a vacuum cleaner, remove hose.
2. Turn the jointer over and loosen the four base plate screws.
3. Pull the adapter free from the exhaust port, (it may be necessary to remove the screws completely in order to remove the adapter).
4. Re-tighten the four base plate screws.

It is an EEC requirement that a dust extraction facility be provided on power tools, however, due to the nature of the tool, some of the dust produced will be forced into the surrounding atmosphere, and will not be collected.

MAINTENANCE

Always inspect the tool before use, and ensure it is in top condition.

Ensure all air vents are clear, (use compressed air to clean the machine where possible).

Check the power cable to ensure it is sound and free from cracks, bare wires etc. avoid using solvents when cleaning plastic parts, most plastics are susceptible to damage from the various types of commercial solvents.

Lubricate all moving parts at regular intervals.

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SAFETY PRECAUTIONS

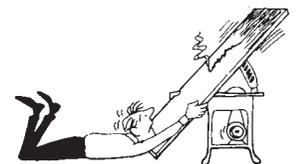


WARNING:



As with all machinery, there are certain hazards involved with their operation and use. Exercising respect and caution will considerably lessen the risk of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator or damage to property, may result.

1. **ALWAYS** Learn the machines' applications, limitations and the specific potential hazards peculiar to it. Read and become familiar with the entire operating manual.
2. **ALWAYS** use a face or dust mask.
3. **ALWAYS** check for damage. Before using the machine, any damaged part, should be checked to ensure that it will operate properly, and perform its intended function. Check for alignment of moving parts, breakage of parts, mountings, and any other condition that may affect the machines' operation. Any damage should be properly repaired or the part replaced. If in doubt, **DO NOT** use the machine. Consult your local dealer.
4. **ALWAYS** disconnect the tool/machine from the power supply before servicing and when changing accessories.
5. **ALWAYS** wear safety goggles, manufactured to the latest European Safety Standards. Everyday eyeglasses do not have impact resistant lenses, they are not safety glasses.
6. **ALWAYS** keep work area clean. Cluttered areas and benches invite accidents.
7. **ALWAYS** ensure that adequate lighting is available. A minimum intensity of 300 lux should be provided. Ensure that lighting is placed so that you will not be working in your own shadow.
8. **ALWAYS** keep children away. All visitors should be kept a safe distance from the work area, especially whilst operating the machine.
9. **ALWAYS** maintain machine in top condition. Keep tools/machines clean for the best and safest performance. Follow maintenance instructions.
10. **ALWAYS** handle with extreme care do not carry the tool/machine by its' electric c cable, or yank the cable to disconnect it from the power supply .
11. **ALWAYS** ensure the switch is off before plugging in to mains. Avoid accidental starting.
12. **ALWAYS** concentrate on the job in hand, no matter how trivial it may seem. Be aware that accidents are caused by carelessness due to familiarity.
13. **ALWAYS** keep your proper footing and balance at all times don't overreach. For best footing, wear rubber soled footwear. keep floor clear of oil, scrap wood, etc.



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14. **ALWAYS** wear proper apparel. loose clothing or jewellery may get caught in moving parts. wear protective hair covering to contain long hair.
15. **ALWAYS** use recommended accessories. the use of improper accessories could be hazardous.
16. **ALWAYS** remove plug from electrical outlet when adjusting, changing parts, or working on the machine.
17. **NEVER** operate machine while under the influence of drugs, alcohol or any medication.
18. **NEVER** leave machine running unattended. turn power off. Do not leave the machine until it comes to a complete stop.
19. **NEVER** force the machine. it will do a better and safer job at the rate for which it was designed.
20. **NEVER** use power tools in damp or wet locations or expose them to rain. Keep your work area well illuminated. do not use in explosive atmosphere (around paint, flammable liquids etc.). Avoid dangerous environment.



ADDITIONAL PRECAUTIONS FOR POWER TOOLS

1. **ALWAYS** wear ear protectors/defenders as the noise level of this machine can exceed 85dB (A).
2. **ALWAYS** use the appropriate saw blade for the material being cut.
3. **ALWAYS** remove adjusting keys and wrenches etc before switching the tool on.
4. **ALWAYS** use clamps or a vice etc to hold the workpiece. It is safer and frees up both hands to operate the tool.
5. **DO NOT** use the machine if the electric cable, plug or motor is in poor condition.
6. **DO NOT** Force the tool. The tool will do the job better and safer working at the rate it was designed for.
7. **DO NOT** remove tool from work until the blade has completely stopped and power removed.
8. **DO NOT** allow the ventilation slots in the machine to become blocked.
9. **DO NOT** touch the blade immediately after use. allow time for it to cool.
10. Replacement blades are available from your CLARKE dealer.
11. When cutting wood, ensure all nails have been removed beforehand. Nails will damage the saw blade.
12. Ensure the blade is fully tightened before use.
13. Keep the mains cable well away from the blade and ensure an adequate electrical supply is close at hand so that the operation is not restricted by the length of the cable.
14. Avoid unintentional starting. Always check that the switch is in the OFF position before plugging the tool into the power supply. Do not carry power tools with your finger on the ON/OFF switch.
15. Switch the machine OFF immediately the task is completed.

Additionally, please keep these instructions in a safe place for future reference.

10. Repeat steps 5 - 10 until all slots are cut.
11. Apply glue to all slots using a nozzle applicator, ensuring glue gets right into slots.
12. Place biscuits in all slots on one piece to be joined, bring both pieces together and clamp the joint until the biscuits swell and the glue sets.

NOTE:

On thick pieces of timber etc, it is possible to use two biscuits at each location, one at 1/3rd of the thickness and the other at 2/3rds.

Cutting A Mitre Joint

1. Slots can be cut in mitre joints with the workpiece secured flat on the bench and the fence adjusted to the mitre angle.
2. A bevelled mitre joint has a biscuit slot cut at a 90° angle to the mitre cut.

Cutting Corner Joints

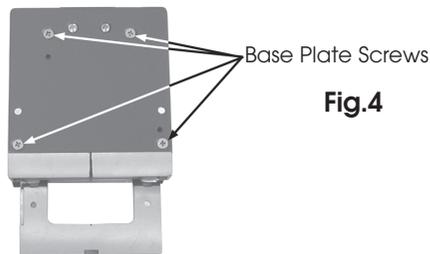
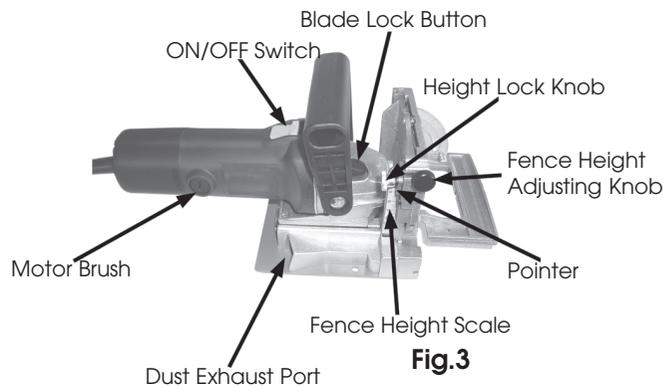
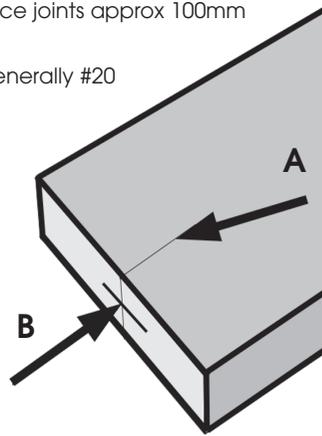
1. Set the pieces together and draw the joint centres on the outside face and end.
2. Cut the slots into the end piece.
3. Clamp the matching face piece so that it protrudes above your workbench with a backing board supporting it from behind.
4. Cut the slots in the face piece

BLADE REPLACEMENT

1. Switch off and isolate from the main power supply by removing the plug from the socket.
2. Turn the jointer over and unscrew and remove the four screws in the base plate (Fig.4 page 11). Pivot the base plate off the two location roll pins.
3. Now with the blade exposed, depress the blade lock (Fig.3 page 11), rotate the blade by hand until the blade locks.
4. Using the pin wrench supplied, loosen the blade flange by turning it anticlockwise.
5. Remove the outer blade flange.
6. Remove the blade from the inner flange.
7. Clean inner and outer blade flanges thoroughly before fitting new blade.
8. Fit the new blade in reverse order, ensure the direction of rotation of the saw blade conforms to the direction of the arrow marked on the gear case.
9. Refit the outer flange and tighten using the pin wrench.
10. Turn the blade by hand to ensure the blade lock is released, also check the blade runs freely.
11. Refit the base plate onto the two location pins and secure with the four screws removed earlier.
12. Plug in and switch the jointer on with no load, check the motor and blade run freely before attempting to use the tool again.

Making A Normal Biscuit Or Plate Joint

1. Position the mating pieces together and draw a reference mark (A) at 90° to the centre point of each proposed joint location (B), space joints approx 100mm apart.
2. Set the plunge depth to the biscuits you are using. generally #20 biscuits suit most applications. If you are using stock 15mm thick or less, you will require smaller biscuits.
3. Adjust the height of the fence as required.
4. Hold the tool by the handle with one hand and support with the other hand on the motor body.
5. Rest the fence on the workpiece, line up the centre point on the tool with the one marked on the work.
6. Switch the tool on by sliding the ON/OFF switch as far forwards as possible, latch in position by pushing down on front of switch, (motor runs continuously).
7. Maintaining a downward pressure on the fence, plunge the blade into the workpiece by pushing the whole tool forwards up to the stop until the cut is complete.
8. Release the forward pressure and allow the tool to return so the blade is clear of the workpiece. Switch the tool off by pushing down on the back of the ON/OFF switch, (the switch will unlatch and the motor will stop).
9. Allow motor to stop before removing from workpiece and putting down.



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ADDITIONAL PRECAUTIONS FOR BISCUIT JOINTERS

1. **DO NOT** lock the cover with the blade in the open position, always ensure it is operating properly, freely returning to fully cover the blade teeth.
2. **DO NOT** stop the blade by applying lateral pressure on the side of the blade.
3. **DO NOT** use blades that do not comply with the specifications in this manual.
4. **DO NOT** use high speed steel (HSS) blades.
5. **DO NOT** use blades that are deformed or cracked etc.

ADJUSTMENTS

Adjustable Fence

ALWAYS switch the tool off, and remove from power supply, by removing the plug from the socket, before making any adjustments.

The height of the fence can be adjusted to allow biscuit slots to be cut at varying depths down the material. The adjustable tilt feature allows a full range of settings from 0° to 90° for cutting slots on a mitred edge.

To adjust the height, first loosen the height lock knob (see Fig.3 page 11), rotate the knurled adjusting knob (Fig.3 page 11) until the desired height is reached, use the scale and pointer (Fig.3 page 11) to set height accurately. Tighten the height lock knob.

To adjust the angle of tilt, loosen the angle lock knob (Fig.2 page 10) move the fence until the required angle is achieved, use the angle scale and pointer (Fig.2 page 10) to accurately set the angle. Tighten the angle lock knob.

Plunge Depth Adjustment

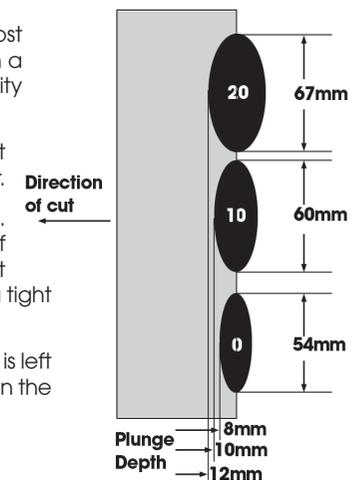
The depth of cut can be set to match the dimensions of the particular size of biscuit used.

The numbers on the plunge depth adjusting knob (Fig.2 page 10) (0-10-20) coincide with the three most common biscuit sizes. The fourth position is marked with a letter 'M', which stands for the maximum depth capacity of the tool, (approximately 14mm).

To select the required depth, rotate the depth adjustment knob, until it clicks into place at the appropriate number.

The width of a biscuit may vary between manufacturer's. The blade has been manufactured to allow fitment of the largest biscuits in the slot cut. You may need to sort out the correct sizes, and or moisten them to achieve a tight fit.

Glue is applied and the biscuit inserted into the slot that is left by the blade, the biscuit swells taking up any looseness in the joint.



Fine Depth Adjustment

The depth settings (0-10-20-M) are fixed at 8,10,12 and 14mm respectively, these can be increased to create a slight looseness in the joint to allow movement before the glue sets. To carry out this adjustment, first raise the adjustable fence to its uppermost position, also set the angle to '0'.

Insert pozidrive screwdriver into the hole, (see Fig.1), turn the depth adjustment screw anticlockwise to increase the depth.

Each full turn increases the depth by 1mm. Always check the depth adjustment by first making a test cut in a scrap piece of wood.

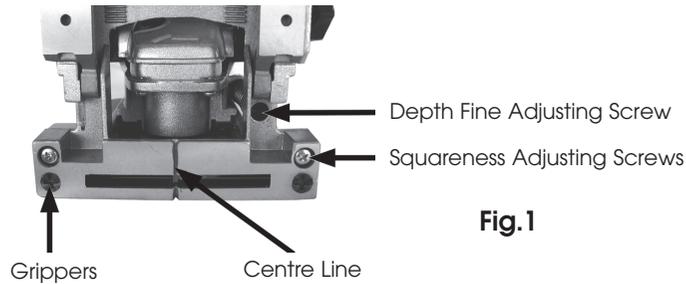


Fig.1

NOTE:

This increased depth of cut is applied to all size settings (0-10-20-M), therefore it is important to adjust back to standard if the extra depth is not required on the other sizes.

To get the maximum depth of cut possible, set the depth adjustment knob to 'M', then turn the fine adjustment screw until the depth adjustment rod is completely loosened, this will give a cutting depth of approximately 16mm, this depth may be required if using home made biscuits or strips of wood, again the depth adjustment must be returned to standard biscuit sizes when finished using the tool in this manner.

If the depth rod becomes loose and turns whilst using the tool. Either apply a thick grease or a threadlock compound to the thread, either method will allow adjustment but prevents further loosening due to vibration.

Adjusting The Blade Square With The Fence

The tool has been set up with the blade set up parallel to the fence. Check this has not changed in shipping. Ensure the tool is switched off and isolated from the main power supply by removing the plug from the socket, check that the blade moves freely and that all of the fence functions and controls are operating correctly.

Find a square edge on a scrap piece of wood, set the depth control to 'M' (maximum) and the fence set to 90°, machine a slot. Now measure the distance from the top of the square edge down to the top of the right hand side of the slot, now measure the left hand side. Both measurements should be identical. If not the fence can be adjusted by loosening the two fence square adjusting screws (Fig.1 page 8). Adjust the fence up or down on one side only keeping the block parallel to the base plate, once in position tighten both screws, take another cut and check the blade now cuts parallel to the fence. When finished, if the blade block protrudes over the base plate and you require the two to be parallel, undo the four base plate screws (Fig.4 page 10) and add a packing of insulating tape to the side that requires raising.

For most operations these two parts do not require to be perfectly parallel.

Grippers

Biscuit jointers tend to pull to the right when making a cut. Grippers have been provided to reduce this effect. When making some joints, you may wish to retract the grippers so as not to damage your workpiece. To prevent scratching rotate the grippers approximately ¼ turn and push them back behind the front plate.

Adjusting The fence For Square

To adjust the fence for square, loosen the angle pointer screw (Fig.2), using a set square between the fence and the front face of the tool, set the fence square. Place the indicator against the stop on the 90° end of the angle scale and re-tighten the screw. Check for square again, if not square repeat adjustment until it is. When the angle indicator is against the stop (pointer), the pointer should indicate 90°.

Bottom plate

For certain applications, you will want to use the bottom plate for alignment. In these cases, the adjustable fence should be set at 0, the height setting is unimportant. This surface is used primarily when making butt joints. The distance between the centerline of the blade and the bottom plate is fixed at 9.5mm which allows centering on 19mm thick stock.

OPERATION

Biscuit jointers can be used for making various types of strong, accurate joints in timber or wood sheeting ie; contiboard etc.

To cut the biscuit slot, the body of the jointer is plunged forwards towards the material..

By utilizing the various features of the tool, you can create a wide range of different types of joints.

Always mark a reference line on workpiece to line up with centre line on machine (Fig.1 page 9), to ensure accurate biscuit placement.

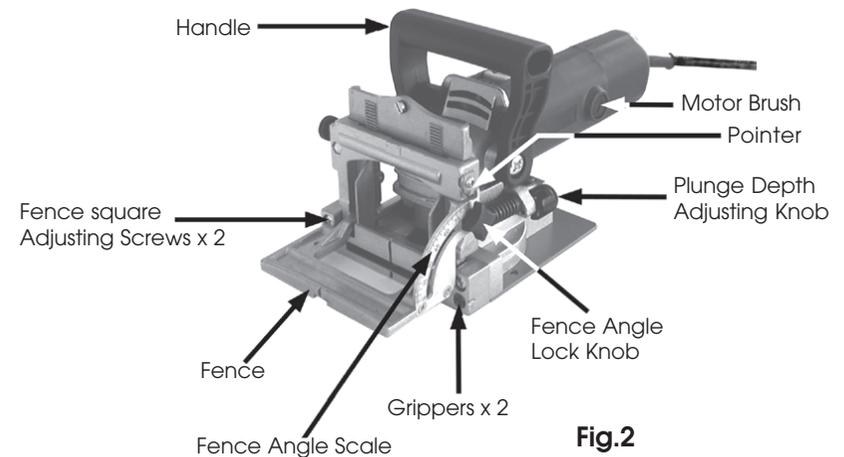


Fig.2