

When using the tool, the blade should be retracted behind the front registration mark. The blade should be retracted 1/4 of a turn and they will retract back behind the front registration mark. The blade should be retracted 1/4 of a turn and they will retract back behind the front registration mark.

3. BOTTOM REGISTRATION SURFACE

For certain applications, you may want to use the bottom surface of the plate jointer for alignment. When using the bottom registration surface, the adjustable fence should be set to 0° and the height setting is unimportant. This surface is used primarily when making "T" joints (see applications section). The distance between the centerline of the blade and the bottom registration surface is fixed at 15.2 mm (3/4"). Thick stock, the 3 red marks on the bottom registration surface indicate the centerline (or the desired point) of the biscuit cut and the approximate width of a #20 biscuit so that you'll know where the edge of the blade is and can prevent breaking through the workpiece. Align the shoe so that neither outside mark extends beyond the end of the workpiece. If either side does, there is a good chance that the blade will break through the surface and ruin your work.

4. DUST EXTRACTION

There are three options provided for collecting dust from your plate jointer as described below.

A. Adjustable Direction Elbow (See Figure 10)

This attachment inserts into the dust exhaust port on the right side at the rear of the base assembly and clicks into place. To remove, pull out firmly. The directional elbow rotates easily to aim the dust in the most convenient direction, suitable for the particular application.

B. Dust Adapter (See Figure 11)

This attachment, when inserted as described above, allows the use of several common sizes of vacuum hose to be attached for direct vacuum pick-up of the dust.

C. Seal Bag (See Figure 12)

The dust bag provided fits snugly over the dust adapter described above. To empty the bag, open the zipper underneath and dump dust out.

NOTE: When the bag becomes full, the dust will back up into the adapter and the exhaust port on the right rear of the tool. To clean out, turn off and unplug the tool and remove packed dust. The bag will hold the dust generated from approximately 75 to 100 #20 biscuit cuts before filling up.

General Operation

Plate jointers are primarily used for making cabinetry and furniture, joining millwork or other similar applications where a precise accurate joint is required in wood or wood products. These tools are typically found in shops of joiners and can be made with your Plate Jointer. We will limit our discussion to six basic joints that can be used to build on and adapt to your own applications. The following are some basic set-up steps that will apply to all biscuit joints.

1. BISCUIT SIZE SELECTION

As mentioned, there are three biscuit sizes: #0, #10 and #20. It is a good rule of thumb to use the largest biscuit size that will physically fit in the application. Unless you are joining narrow face or picture frames or using 1/2" or thinner stock, you will find the #20 biscuit size to suit most applications. After selecting the biscuit size, set the depth adjustment screw to the proper depth. The depth adjustment screw is located on the side of the tool. The depth adjustment is correctly set by first testing in a scrap piece. This is extremely important as you do not want to discover during glue-up that your biscuit slots are not quite deep enough.

2. BISCUIT LOCATION AND LAYOUT

Generally, biscuits may be spaced and located at your discretion. For edge joints, a good rule of thumb is to space biscuits every 150 mm (6-10") on center. It is further recommended that biscuits be placed so that the centerline of the end biscuits is 50 mm (2-1/4") from the end of the workpiece. When joining face frames or picture frames where the workpiece is narrow, you may want to choose the smaller biscuit sizes to keep from "breaking out" on the end of the stock. Breaking out should be avoided if possible, but if not you can assemble the joint and trim off the exposed biscuit by using the glue sets (see Figure 13). When working with material up to 1" thick, we advise you to use a single biscuit located in the center of the material thickness. If thicker stock is to be joined, you may choose to use 2 biscuits across the thickness for greater strength (see Figure 14). Biscuit locations should be marked by first positioning the mating pieces exactly as they are to be assembled. Next, make a mark at 90° to the center of the biscuit location at the desired location. Consistent marking is important. See the Application section for more specific information on joint layout. The marks you make will then be aligned with one of the center registration marks on the tool, again, depending upon your specific application.

3. MAKING THE CUT

Prior to making any cut, be sure that all fence adjustments are set and lock knobs are tight. Also, be sure you have selected the proper depth setting. Clamp your workpiece firmly and align the plate jointer's center registration mark with your layout mark. Turn on the tool and let the blade come up to full speed (approximately 1 second). Grasping the switch handle and auxiliary handle and positioning the fence firmly and squarely against the workpiece, plunge the blade until it breaks through the stock. Continuing to hold the tool securely and firmly, allow the return spring to retract the blade from the work and then release the switch to shut the tool off. It will take some practice to obtain a "feel" for the tool to produce accurate joints, so practicing in scrap wood first is advisable.

4. JOINT ASSEMBLY

After your joints are cut, you may wish to test fit everything together before gluing. When you are satisfied with your joints, evenly spread any good quality woodworking glue in each slot as well as on the mating flat surfaces of your parts. Place biscuits in the slots, assemble the joint and clamp until dry. For a biscuit joint to be most effective, it is important that it be in contact with the glue. This is because the biscuits absorb the moisture in the glue and expand to form a tight joint.

Applications

1. EDGE TO EDGE JOINTS (See Figure 15)

This is the simplest to make and most common joint for the plate jointer. Follow the steps below to produce this joint.

- Prepare the workpieces and lay them on a work surface exactly as they are to be assembled.
- Spacing biscuits 50 mm (2-1/4") from the ends and 150 mm (6-10") on center (6-10") apart; layout the biscuit centers.
- Set up the plate jointer by first selecting the proper depth setting. Set the fence to 90°. Set the height adjustment to position the biscuit in the approximate center of the stock thickness.
- Clamp the workpiece and position the tool so that the center indicator mark lines up with the first layout mark (see Figure 17). Turn on the tool and make the plunge cut. Retract the tool and release the trigger to turn the tool off. Repeat for each layout mark.
- Glue, assemble and clamp the joint.
- For stock thicker than 1", you may wish to use double biscuits at each location. Set the height adjustment to allow at least 4.75 mm (3/16") of stock between the biscuit and the edge of the work surface. Make all cuts at this fence height. Position the fence for the second cut. Repeat the cut. The second cut should be at least 4.75 mm (3/16") of stock between the biscuit and the outside wall and between the biscuits themselves (see Figure 18).

2. FRAME JOINTS (See Figure 19)

Frame joints are an ideal application for biscuit joinery. With the plate jointer you can create a very strong, precise joint that is much faster to make than a dovetail or mortise and tenon joint. Figure 19 shows two types of frame joints. Follow the steps outlined below.

- Arrange the workpieces on a flat work surface exactly as they are to be assembled.
- Select the proper biscuit size based on the length of the joint. If the frame pieces are too narrow for a #20 biscuit, you will have to allow the biscuit to protrude slightly and then trim it off after the joint is dry (see Figure 13).
- Lay out the biscuit locations.
- Set up the tool by selecting the depth that corresponds to the chosen biscuit size. Lock the fence at 90° and adjust the fence height to center the biscuit in the stock thickness.
- Clamp the workpiece and position the Plate Jointer to make the first cut (see Figure 20).
- Turn on the tool and make the plunge cut.
- Repeat for each layout mark.
- Glue, assemble and clamp the frame.

3. CORNER JOINTS (See Figure 21)

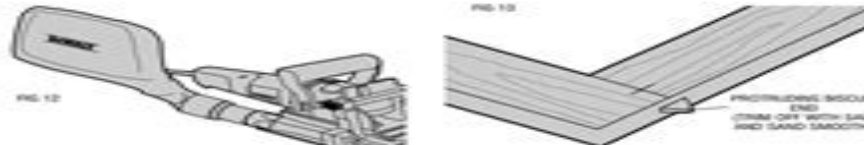
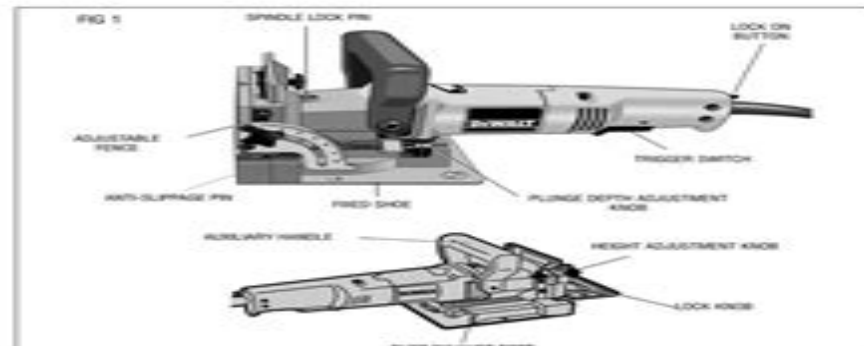
Corner joints are simple and excellent application for biscuit joinery. Follow the procedure below.

- Arrange the workpieces exactly as they are to be joined.
- Select the biscuit size and layout the biscuit locations.
- Set up the tool by selecting the proper depth setting, adjusting the fence to center on the stock thickness and setting the angle to 90°.
- For this joint, you will make cuts into the edge of one workpiece and the face of another. The edge cut is performed the same as for edge to edge joints. The face cut is made by clamping the workpiece and aligning the tool as shown in Figure 22. Turn the tool on, make the plunge cut and repeat for each layout mark.
- Glue, assemble and clamp the joint.

4. OFFSET JOINTS (See Figure 23)

You may wish to have a deliberate offset between two workpieces. This is easily accomplished with your plate jointer by performing the following steps.

- Arrange the workpieces as they are to be assembled and layout the biscuit locations.
- Set up the tool by selecting the proper biscuit size and adjusting the fence angle to 90°. Select the workpiece that will be set back and set the fence height to center the fence within the thickness of that piece.
- Clamp the workpiece, align the tool and make the plunge cut.
- Next, adjust the fence up by an amount equal to the desired offset. Use the scale and pointer located on the right side of the tool under the fence lock knob.
- Clamp the second workpiece, align the tool and make the plunge cut.
- Glue, assemble and clamp the joint.



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