

Jointer Table Adjustment Procedure

(for jointers with parallelogram table action)

Note: The tables on these types of jointers are adjusted by means of eccentric bushings that are located at the four corners of each table. Rotating the bushings will raise/lower the table at that point. The most important tool required is a good, machined straight edge. The accuracy of the adjustment depends entirely on the quality of the straight edge.

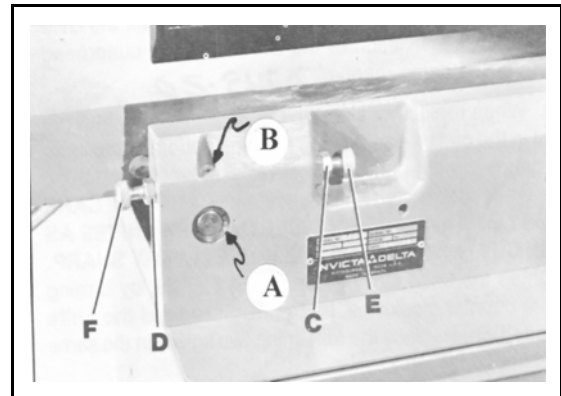


Fig. 1 shows the DJ-15 and DJ-20:

(A) shows the eccentric bushing.

(B) shows the set screw hole.

Important-There are 2 set screws in this location.

Remove the outer screw and loosen the inner screw 1/2 of a turn.

Fig. 1

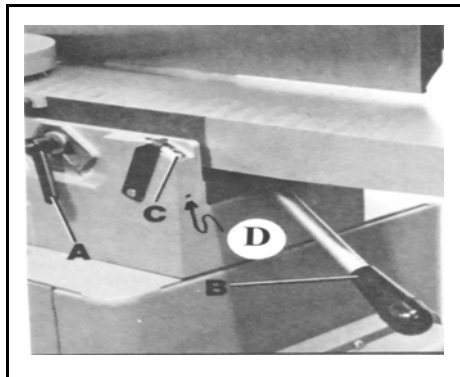


Fig. 2

Fig. 2 (D) Shows the set screw location, at the end of the base, for the 8th bushing of the DJ-15 & DJ-20.

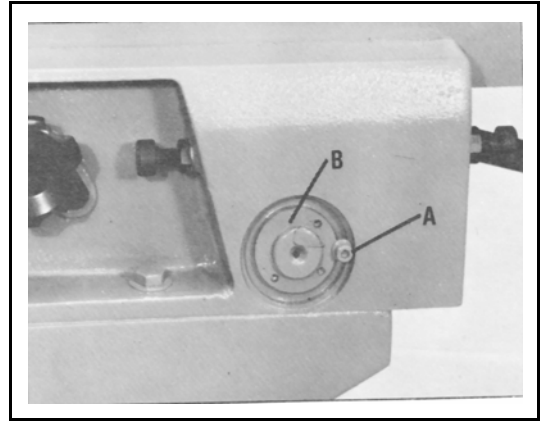


Fig. 3 RJ-42
(A) shows the bushing lock screw.
(B) shows the eccentric bushing.

Fig. 3

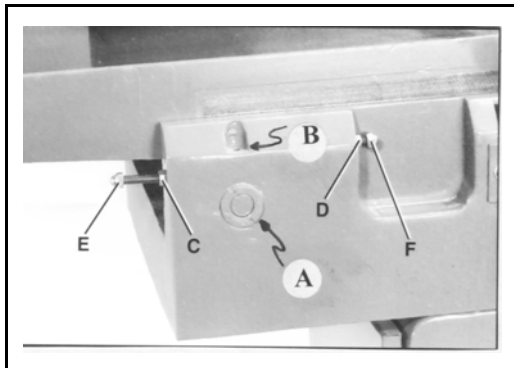


Fig. 4

Fig. 4
DJ-30

(A) shows the eccentric bushing.
(B) shows the set screw hole.
This unit only has one set screw per bushing.

Preparation:

1. Disconnect the machine from the power source.
2. Remove the guard and slide the fence carriage all the way to the rear of its travel.
3. The individual infeed and outfeed table flatnesses must be checked, and be in tolerance, before attempting to level the tables. To check, lay a straight edge lengthwise down the center of each individual table. Using a set of feeler gauges, measure the largest gap between the table surface and the straight edge. This gap should not exceed:
DJ-15 & DJ-20 =.008" ; DJ-30 =.010" ; and RJ-42 =.015".

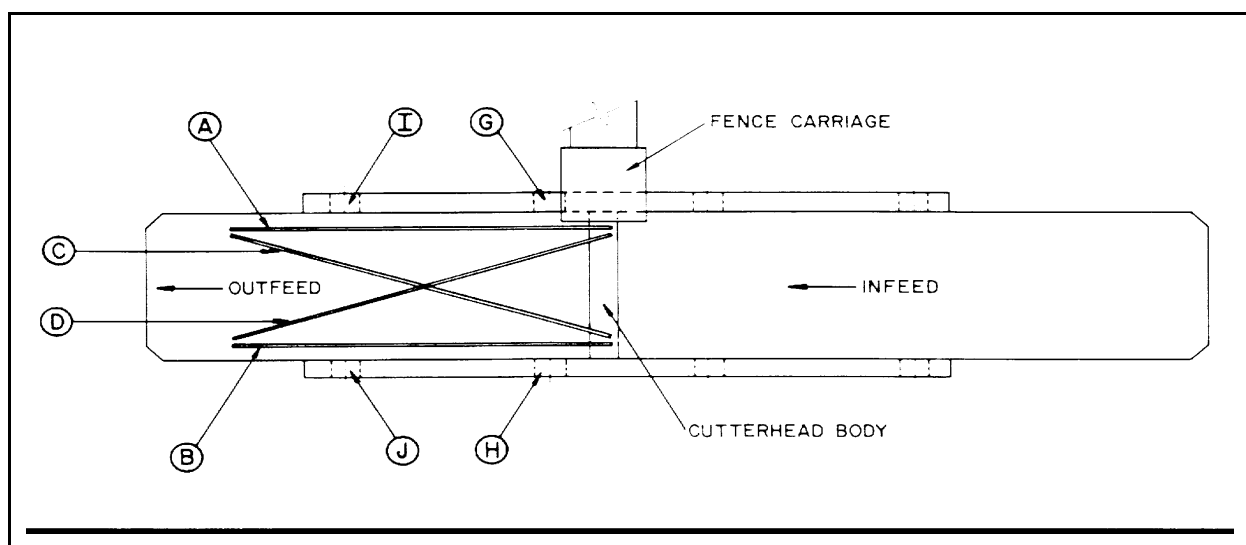


Fig. 5

Begin the alignment procedure:

1. Lower the infeed table 1/4" below the cutterhead.
2. Place the straight edge over the cutterhead body and at the rear of the outfeed table (A, Fig. 5).
3. Loosen the positive stops on the outfeed table. Unlock the table lock knob/lever and raise or lower the outfeed table until the end of the straight edge clears the cutterhead by **exactly** .010". Use a feeler gauge to measure the clearance. Re-tighten the table lock knob/lever.

Note: the .010" gap is a critical dimension.

Alignment Procedure (con't)

4. Place the straight edge over the cutterhead body at the front of the outfeed table (B, Fig. 5). Again, the cutterhead to straight edge gap should be **exactly** .010".
5. If an adjustment is necessary, proceed as follows: Locate the eccentric bushing (H, Fig. 5) and loosen its locking set screw(s) or lock screw. Rotate the bushing clockwise or counter-clockwise to obtain the .010" gap that is required between the straight edge and the cutterhead body. Re-tighten the bushing's set/lock screw.
6. Place the straight edge diagonally over the cutterhead body and outfeed table (C, Fig. 5). The cutterhead body to straight edge gap must measure **exactly** .010". If an adjustment is needed, locate the eccentric bushing (I, Fig. 5) and adjust as in step 5.
7. Place the straight edge diagonally over the cutterhead body and outfeed table (D, Fig. 5). The cutterhead body to straight edge gap must measure **exactly** .010". If an adjustment is needed, locate the eccentric bushing (J, Fig. 5) and adjust as in step 5.

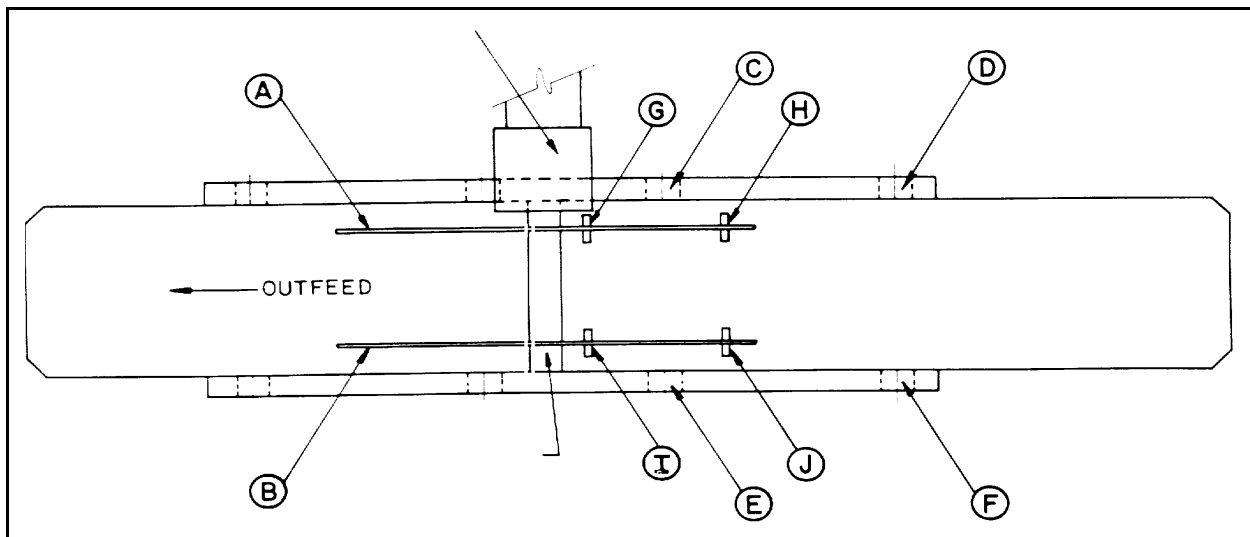


Fig. 6

(Use Figure 6 for the following steps)

8. Place the straight edge across the outfeed table and onto the infeed table as shown in (A, Fig. 6). While holding down firmly on the outfeed end of the straight edge, place a .010" feeler gauge under the straight edge at location (G, Fig. 6). Raise the infeed table up until the .010" feeler gauge just touches the bottom of the straight edge and tighten the infeed table lock knob/lever.

Alignment Procedure (con't)

(referencing: Figure 6)

9. While holding down firmly on the outfeed end of the straight edge, insert a .010" feeler gauge at location (H, Fig. 6). This measurement should also be .010". If an adjustment is needed, locate the eccentric bushing (D, Fig. 6) and adjust as in step 5.

10. Place the straight edge across the outfeed table and onto the infeed table as shown in (B, Fig. 6). While holding down firmly on the outfeed end of the straight edge, insert a .010" feeler gauge at location (I, Fig. 6). If an adjustment is needed, locate eccentric bushing (E, Fig. 6) and adjust as in step 5.

11. While holding firmly down on the outfeed end of the straight edge, insert a .010" feeler gauge at location (J, Fig. 6). If an adjustment is needed, locate the eccentric bushing (F, Fig. 6) and adjust as in step 5.

Note: On some models the pointer must be removed to rotate the bushing.

12. Raise the outfeed table to its working height (dead level with the knives when they are at the top of the cutting circle) and tighten the positive stop screws and table lock lever/handle.

13. Replace all covers, guards and pointers that were previously removed.

14. In cases where the infeed and outfeed tables were severely out of parallel, it may be necessary to repeat steps 3 through 11 a second time to "fine tune" the table parallelism.

