



User Manual

Read and understand this manual before using machine.

6" STATIONARY JOINTER WITH HELICAL CUTTER HEAD

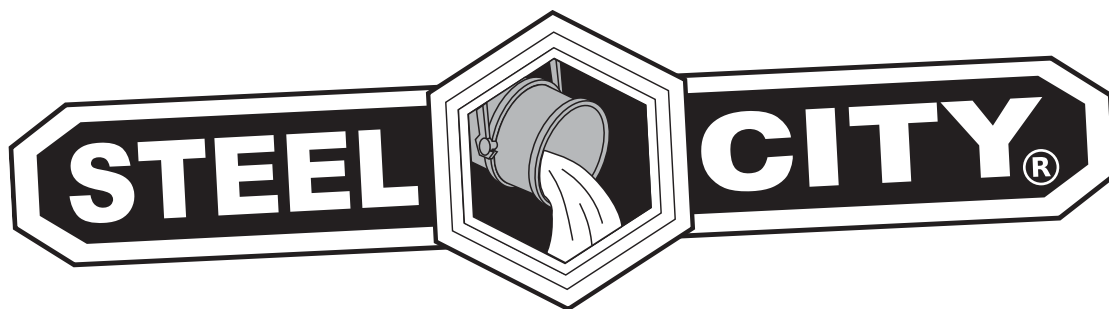


Model Number
40630CH
40630GH



STEEL CITY TOOL WORKS
VER. 01.11

Manual Part No. SC76070



THANK YOU for purchasing your new Steel City Planer. This planer has been designed, tested, and inspected with you, the customer, in mind. When properly used and maintained, your planer will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This planer is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your planer or Steel City Tool Works, please visit our web site at **www.steelcitytoolworks.com** .

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INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

WARRANTY

STEEL CITY TOOL WORKS 2 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC ("SCTW") warrants this "STEEL CITY TOOL WORKS" machinery to be free of defects in workmanship and materials for a period of 2 years from the date of the original retail purchase by the original owner. (Granite components are warranted for 10 years. Please inform SCTW within 30 days for any damages or defects on the Granite components found upon receipt of the products to qualify for the 10 year limited warranty. See the Granite warranty statement supplied with those products.)

Important Notice:

- Proof of Purchase must be present when requesting Warranty service.
- All warranty communications should be directed to Steel City Tool Works Technical Service 1-877-724-8665.
- Warranty Card must be completed and returned within 90 Days from original Purchase Date.

What is covered under the 2 year Limited Warranty:

- This warranty covers all defects in workmanship or materials and normal wear items such as motors, switches, cords, gears and bearings for 2 years following the date of purchase of the tool. Warranties on other Steel City Tools may vary.

How to get Service:

- To obtain service for this Steel City Tool you must return it; Freight Prepaid, or take in to an authorized service center for Steel City Tools. You may obtain the Service Location or Service Technician location nearest to you by calling (toll free) 1-877-724-8665.
- When requesting warranty service you must present the original dated sales receipt and Date code, which can be found on the original carton and machine body. SCTW will repair or replace, at its expense and at its option, any SCTW machine, machine part (Motor, Switch and Cords), or machine accessory which in normal use has proven to be defective.

What is not covered:

- This warranty applies only to the original purchaser at retail and may not be transferred. This warranty only covers defects arising from normal usage and does not cover any malfunction, failure or defect resulting from misuse, abuse, neglect, alteration, modification or repair by other than an authorized Service Center or Technician of Steel City Tool Works. Consumable accessories provided with the tool such as, but not limited to , brushes, blades, belts, bits are not covered.
- Steel City Tool Works make No Warranties, Representations or Promises as to the Quality or Performance of its Power Tools other than those specifically stated in this Warranty.

Except as set forth above, SCTW makes no express or implied representations or warranties with respect to its machinery, or its condition, merchant-ability, or fitness for any particular purpose or use. SCTW furnishes the above warranties in lieu of all other warranties, express or implied, including the warranties of merchantability and fitness for a particular purpose, which are hereby specifically disclaimed. SCTW shall not be liable for any (a) special, indirect, incidental, punitive or consequential damages, including without limitation loss of profits, arising from or related to this warranty, the breach of any agreement or warranty, or the operation or use of its machinery, including without limitation damages arising from damage to fixtures , tools , equipment, parts or materials, direct or indirect loss caused by any other party, loss of revenue or profits, financing or interest charges , and claims by any third person, whether or not notice of such possible damages has been given to SCTW; (b) damages of any kind for any delay by or failure of SCTW to perform its obligations under this agreement ; or (c) claims made a subject of a legal proceeding against SCTW more than one (1) year after such cause of action first arose.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the laws of the Commonwealth of Pennsylvania, without regard to conflicts of law's provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW, or any claim related to the performance of any agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

WARRANTY CARD

Name _____
 Street _____
 Apt. No. _____
 City _____ State _____ Zip _____
 Phone Number _____
 E-Mail _____

Product Description: _____
 Model No.: _____ Serial No.: _____

NOTE: The **Proof of Purchase** must be submitted along with this card in order to have the Warranty to take into effect. Fail to submit the Proof of Purchase may invalidate your Product Warranty.

The following information is given on a voluntary basis and is strictly confidential.

1. Where did you purchase your STEEL CITY machine?
 Store: _____
 City: _____ Online: _____

2. How did you first learn of Steel City Tool Works?
 _____ Advertisement _____ Mail Order Catalog
 _____ Web Site _____ Friend
 _____ Local Store _____ Other _____

3. Which of the following magazines do you subscribe to?
 _____ American Woodworker _____ Cabinetmaker
 _____ Canadian Woodworking _____ Family Handyman
 _____ Fine Homebuilding _____ Fine Woodworking
 _____ Journal of Light Construction _____ Old House Journal
 _____ Popular Mechanics _____ Popular Science
 _____ Popular Woodworking _____ Today's Homeowner
 _____ WOOD _____ Woodcraft
 _____ WOODEN Boat _____ Woodshop News
 _____ Woodsmith _____ Woodwork
 _____ Woodworker _____ Woodworker's Journal
 _____ Workbench _____ Other _____

4. Which of the following woodworking / remodeling shows do you watch?
 _____ Backyard America _____ The American Woodworker
 _____ Home Time _____ The New Yankee Workshop
 _____ This Old House _____ Woodwright's Shop
 Other _____

5. What is your annual household income?
 _____ \$20,000 to \$29,999 _____ \$30,000 to \$39,999
 _____ \$40,000 to \$49,999 _____ \$50,000 to \$59,999
 _____ \$60,000 to \$69,999 _____ 70,000 to \$79,999
 _____ \$80,000 to \$89,999 _____ \$90,000 +

6. What is your age group?
 _____ 20 to 29 years _____ 30 to 39 years
 _____ 40 to 49 years _____ 50 to 59 years
 _____ 60 to 69 years _____ 70 + years

7. How long have you been a woodworker?
 _____ 0 to 2 years _____ 2 to 8 years
 _____ 8 to 20 years _____ over 20 years

8. How would you rank your woodworking skills?
 _____ Simple _____ Intermediate
 _____ Advance _____ Master Craftsman

9. How many Steel City machines do you own? _____

10. What stationary woodworking tools do you own?
Check all that apply.
 _____ Air Compressor _____ Band Saw
 _____ Drill Press _____ Drum Sander
 _____ Dust Collection _____ Horizontal Boring Machine
 _____ Jointer _____ Lathe
 _____ Mortiser _____ Panel Saw
 _____ Planer _____ Power Feeder
 _____ Radial Arm Saw _____ Shaper
 _____ Spindle Sander _____ Table Saw
 _____ Vacuum Veneer Press _____ Wide Belt Sander
 Other _____

11. Which benchtop tools do you own? *Check all that apply.*
 _____ Belt Sander _____ Belt / Disc Sander
 _____ Drill Press _____ Band Saw
 _____ Grinder _____ Mini Jointer
 _____ Mini Lathe _____ Scroll Saw
 _____ Spindle / Belt Sander _____ Other _____

12. Which portable / hand held power tools do you own?
Check all that apply.
 _____ Belt Sander _____ Biscuit Jointer
 _____ Dust Collector _____ Circular Saw
 _____ Detail Sander _____ Drill / Driver
 _____ Miter Saw _____ Orbital Sander
 _____ Palm Sander _____ Portable Thickness Planer
 _____ Saber Saw _____ Reciprocating Saw
 _____ Router _____ Other _____

13. What machines / accessories would you like to see added to the STEEL CITY line?

14. What new accessories would you like to see added?

15. Do you think your purchase represents good value?
 _____ Yes _____ No

16. Would you recommend STEEL CITY products to a friend?
 _____ Yes _____ No

17. Comments:

FOLD ON DOTTED LINE

PLACE
STAMP
HERE

Steel City Tool Works
3656 Enterprise Avenue
Hayward, CA 94545

FOLD ON DOTTED LINE

PRODUCT SPECIFICATIONS

Motor Specifications:

Type	Universal
Amps	12
Voltage	120
Phase	Single
Hertz	60
RPM	19,000

Product Dimensions:

Length	31"
Width	20-1/2"
Height	37-3/8"
40630CH Total Net Weight	104 lbs.
40630GH Total Net Weight	114 lbs.

Product Specifications:

Table	6-1/4" x 45"
Number of Helical Knives	12 (2 Sided HSS)
Maximum Speed of Cutterhead	11800 RPM
Knife Cuts Per Minute	11800 CPM
Maximum Depth-of-Cut	1/8"
Fence Size Overall	5" x 25"

Shipping Dimensions:

Carton Type	Cardboard
Length	49-3/8"
Width	19-5/8"
Height	17-1/8"
40630CH Gross Weight	104 lbs.
40630GH Gross Weight	114 lbs.

ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: www.steelcitytoolworks.com.

DEFINITION OF TERMS

Edge Jointing: The process of making the edge of a piece of stock straight and square

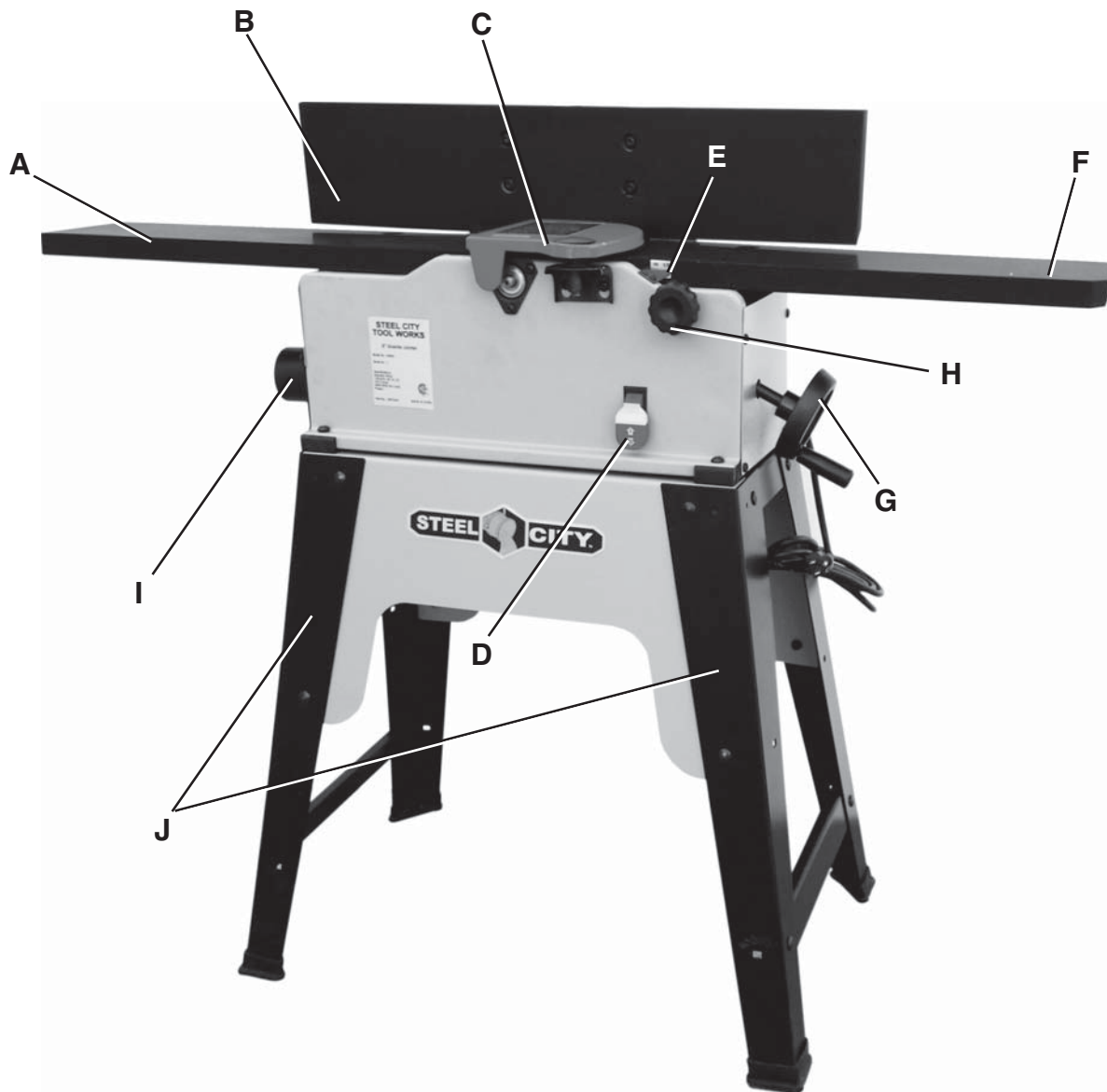
Face Jointing: Similar to edge jointing except rather than the edge it is the face of the board that is being machined flat and square.

Gum, Pitch or Resin: A sticky sap based residue that comes from wood products.

Rabbet: A rectangular cut or groove along or near the edge of a piece of wood that allows another piece to fit into it to form a joint

Snipe: Gouging or depression of the board at the ends. Snipe can occur either at the beginning of the board going into the jointer or at the end of the board as it comes out of the jointer.

FEATURE IDENTIFICATION



- | | | |
|---------------------|-----------------------------------|------------------|
| A) Outfeed Table | E) Depth Indicator | I) Dust Port |
| B) Fence | F) Infeed Table | J) Jointer Stand |
| C) Cutterhead Guard | G) Infeed Table Adjustment Handle | |
| D) On/Off Switch | H) Infeed Table Lock | |

GENERAL SAFETY

WARNING

TO AVOID serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

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, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

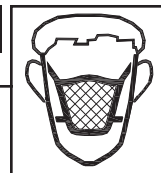
CAUTION

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

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

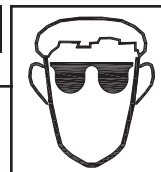
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

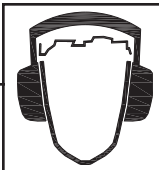
1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

WARNING



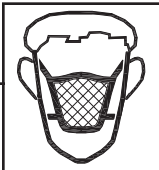
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠ WARNING



3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

⚠ WARNING



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.
5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.
6. **ALWAYS** unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.
7. **AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

⚠ WARNING



8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

⚠ WARNING



9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.
10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.
12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.
13. **DO NOT** store anything above or near the machine.
14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.
15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.
16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.
17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.
18. **KEEP** protective guards in place and in working order.
19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.
20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.
21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.
22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.
23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.
24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. **THE USE** of extension cords is not recommended for 230V equipment. It is better to arrange the placement of your equipment and the installed wiring to eliminate the need for an extension cord. If an extension cord is necessary, refer to the chart in the Grounding Instructions section to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin.
27. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
28. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
29. Information regarding the safe and proper operation of this tool is also available from the following sources:

Power Tool Institute
1300 Summer Avenue
Cleveland, OH 44115-2851
www.powertoolinstitute.org

National Safety Council
1121 Spring Lake Drive
Itasca, IL 60143-3201

American National Standards Institute
25 West 43rd Street, 4th floor
New York, NY 10036
www.ansi.org

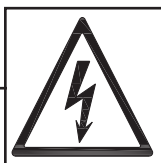
ANSI 01.1 Safety Requirements for
Woodworking Machines, and the U.S. Department
of Labor regulations
www.osha.gov

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PRODUCT SAFETY

1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

WARNING



4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain. Store indoors in a dry area.
5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
8. **ALWAYS** turn the power switch "OFF" before unplugging the jointer.

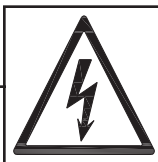
WARNING



9. **DO NOT** handle the plug or jointer with wet hands.
10. **USE** only accessories as described in this manual. **USE** accessories only recommended by Steel City.

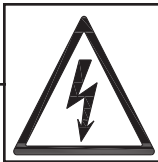
11. **DO NOT** pull the jointer by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
12. **DO NOT** unplug the jointer by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the jointer is not operating properly, or has been damaged, left outdoors or has been in contact with water.
14. **DO NOT** use the jointer as a toy. **DO NOT** use near or around children.
15. **ENSURE** that the machine sits firmly before using. If the machine wobbles or is unstable, correct the problem by using shims or blocks prior to operation.
16. This machine is designed to process wood **ONLY**.

WARNING



17. **NEVER** position fingers or thumbs near the infeed roller.
18. Long pieces of stock should **ALWAYS** be supported with some type of fixture.
19. **DO NOT** operate jointer with dull or damaged blades.
20. **MAKE CERTAIN** that the jointer is properly adjusted prior to use.
21. **DO NOT** try and remove excessive amounts of wood in one single pass.
22. **INSPECT** all stock before planing, ensuring that there are no foreign objects embedded in the wood, loose knots, or knots that may become loose during operation.

WARNING



23. **DO NOT** attempt to remove jams until power is disconnected and all moving parts have come to a complete stop.
24. **MAKE SURE** that there is adequate operating space on both the infeed and outfeed sides of the jointer before operating.
25. **DO NOT** attempt to plane wood that is less than 7" long or less than 1/8-inch thick.

ELECTRICAL REQUIREMENTS

TO PREVENT electrical shock, follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

TO REDUCE the risk of electrical shock, **DO NOT** use machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.

DO NOT connect the machine to the power source before you have completed the set up process.

DO NOT connect the machine to the power source until instructed to do so.

The motors in these machines are designed to run on 115 volts.

GROUNDING INSTRUCTIONS

⚠ WARNING



This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

IMPROPER ELECTRICAL CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

Fig. A

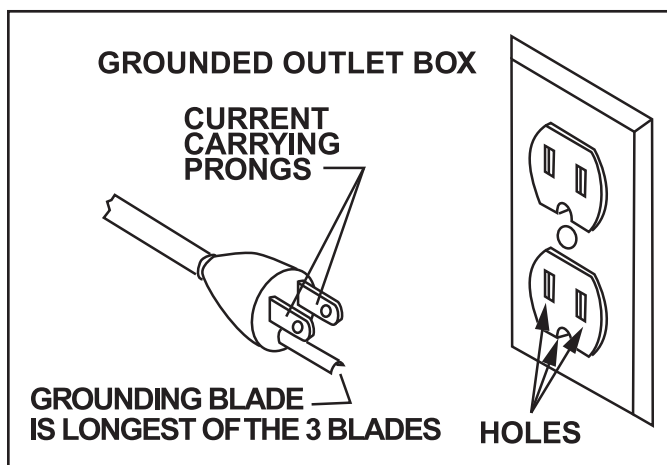
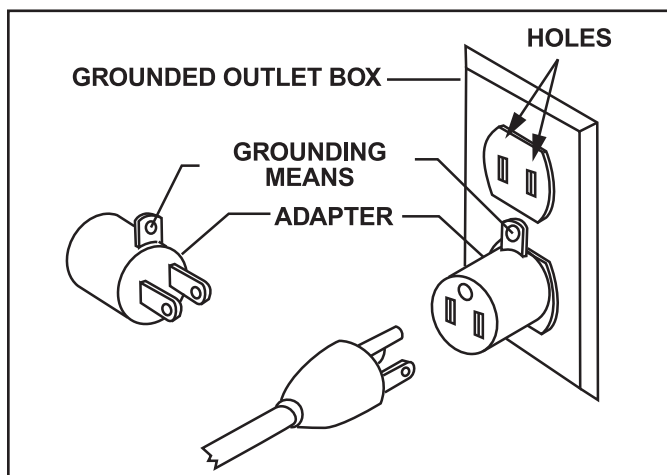


Fig. B



PLUGS / RECEPTACLES

⚠ WARNING



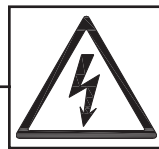
- Electrocuting or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 115 volt, 60 hertz, single phase motor. Never connect the green or ground wire to a live terminal.

A machine with a 115 volt plug should only be connected to an outlet having the same configuration as the plug.

EXTENSION CORDS

⚠ WARNING



To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

⚠ CAUTION

USE ONLY a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)				
115 VOLT OPERATION ONLY				
	25' LONG	50' LONG	100' LONG	150' LONG
0 to 6 Amps	18 AWG	16 AWG	16 AWG	14 AWG
6 to 10 Amps	18 AWG	18 AWG	14 AWG	12 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG	12 AWG

UNPACKING & INVENTORY

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Remove any protective materials and coatings from all of the parts and the planer. The protective coatings can be removed by spraying WD-40 on them and wiping it off with a soft cloth. This may need to be redone several times before all of the protective coatings are removed completely.

After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

⚠ WARNING

If any parts are missing, do not attempt to plug in the power cord and turn "ON" the machine. The machine should only be turned "ON" after all the parts have been obtained and installed correctly. **For missing parts, contact Steel City at 1-877-SC4-TOOL.**



- A. Jointer
- B. Fence
- C. Cutterhead Guard
- D. Panel
- E. Leg Assmely Hardware Package
- F. Upper Support Bracket
- G. Dust Port
- H. Raise/ Lower Handle

- I. Feet Pad
- J. Screw Package
- K. Wrench Package
- L. Push Block
- M. Fence Knob
- N. Leg Assembly
- O. Lower Support Bracket

ASSEMBLY

ASSEMBLY TOOLS REQUIRED:
ASSEMBLY TIME ESTIMATE:

- 3mm, 4mm and 5mm Hex Wrench; 10mm Open End Wrench
- Assembly for this machine takes approximately 1 hour.

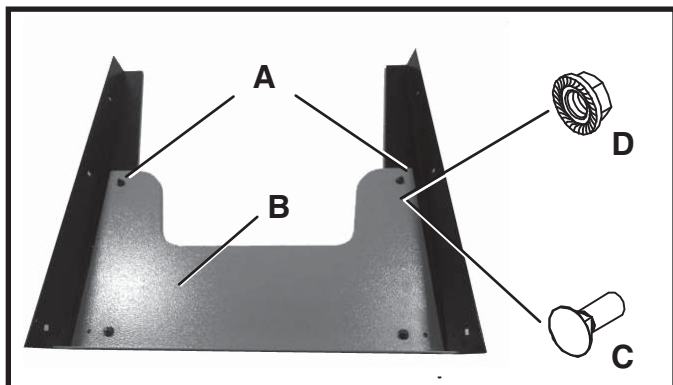
⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

LEG STAND ASSEMBLIES

1. Attach 2 stand legs (A) to the side panel (B) that carries the logo. Using four of each carriage bolts (C), SC80462, and flange hex nuts (D), SC82133, to assemble the legs and front panel together. Tighten the nuts finger tight. **SEE FIG. 1**

Fig. 1



2. Repeat the above step for the remaining legs and side panel. Tighten the nuts finger tight.
3. Insert four carriage bolts (A), SC80462, through the front and back leg & panel assembly. Assemble it with the top (B) and down (C) support brackets on one side, then attach flange hex nuts (A), SC82133, to bolts. Tighten the nuts finger tight. **SEE FIG. 2 & FIG. 5**

Fig. 2

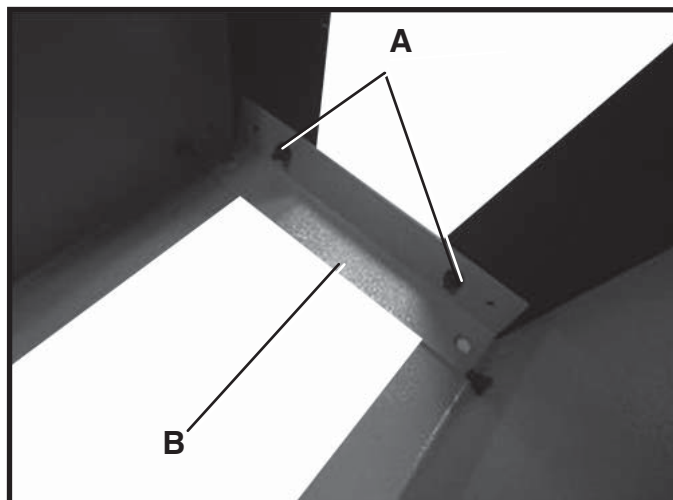
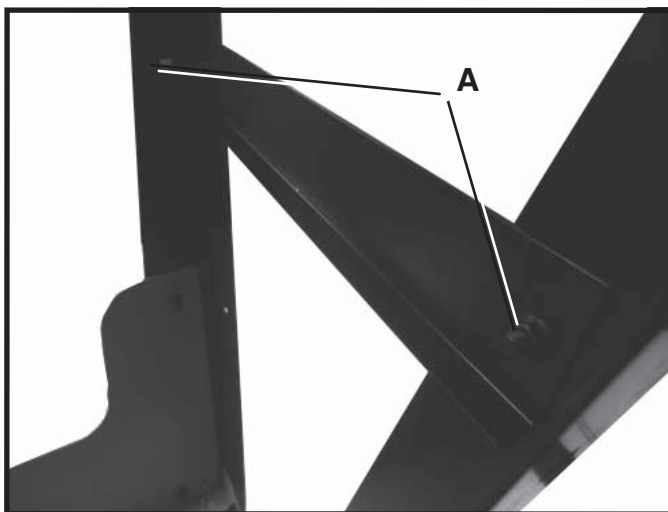
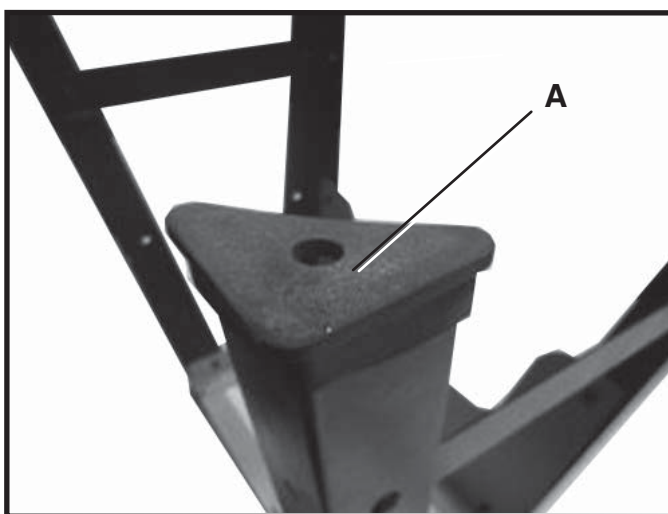


Fig. 4



4. Repeat the above step to attach leg & panel assembly to the remaining top and down support brackets.

Fig. 5



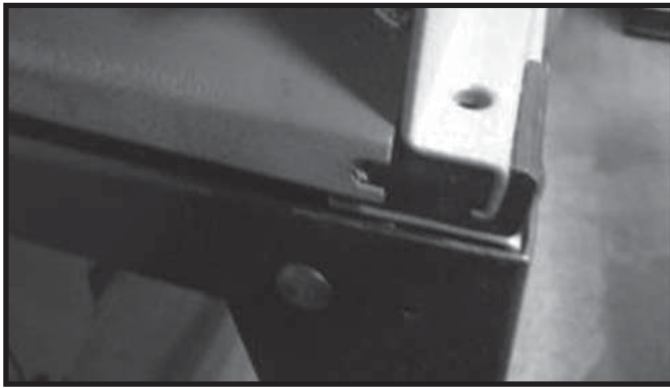
5. Press the leveling pad (A) onto each leg, set the stand upright and tighten all stand fasteners securely. **SEE FIG. 5**

JOINTER & STAND ASSEMBLIES

NOTE: The jointer assembly is heavy and bulky. Two people are required to lift the tool.

1. Carefully place the jointer onto the stand, making sure the holes in the jointer feet (A) aligns with the holes (B) in the stand. **SEE FIG. 6**

Fig. 5

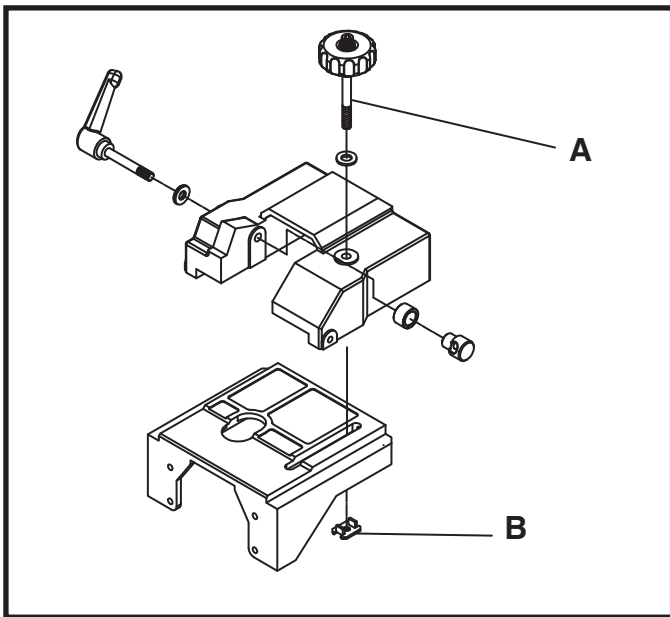


2. Secure the jointer in position using the four socket pan head screws and lock washers.

JOINTER FENCE INSTALLATION

1. Place fence assembly on to the jointer, making sure that key of fence support is aligned with keyway of fence body. **SEE FIG. 6**
2. Place knob with washer (A) through fence body.
3. Secure fence by tightening locking block (B) to the knob thread.

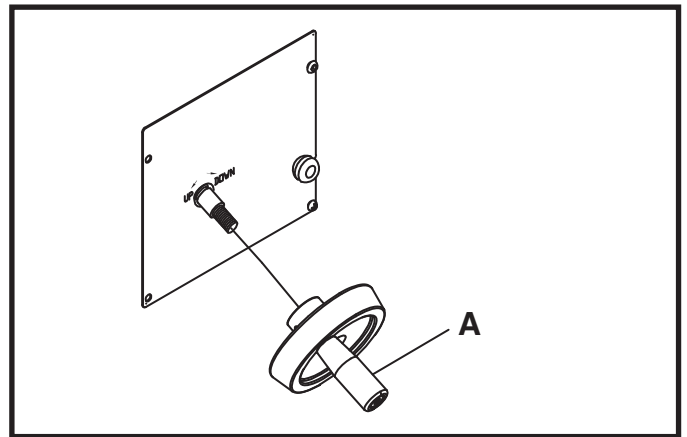
Fig. 6



ATTACH HANDWHEEL ASSEMBLY

1. Place handwheel assembly (A) onto shaft and secure in position by tightening set screw. **SEE FIG. 6A**

Fig. 6A

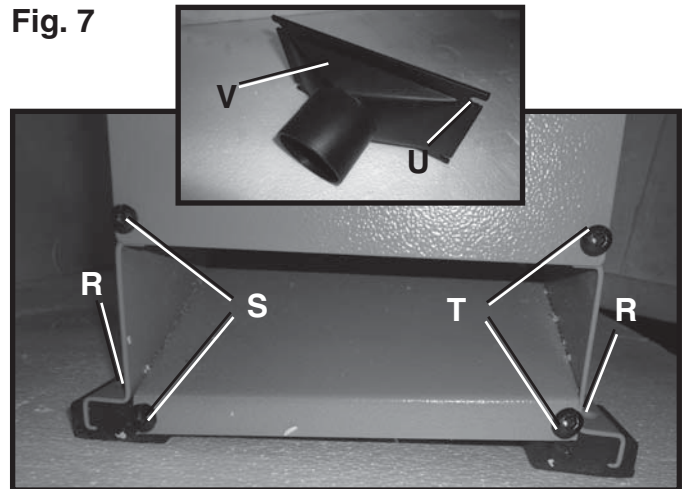


VACUUM HOSE ADAPTOR

A vacuum hose adaptor (V) Fig. 7 is supplied with the jointer to help connect it to a standard 2 inch vacuum hose. To assemble the adaptor:

1. Remove two screws (S) Fig. 7. Loosen screws (T).
2. Slide adaptor's slots (U) under loosened screws (T).

Fig. 7



OPERATIONS

NOTICE: This operations section was designed to give instructions on the basic operations of this jointer. However, it is in no way comprehensive of every jointer operation. It is strongly recommended that you read books, trade magazines, or get formal training to maximize the potential of your planer while minimizing the risks.

STARTING AND STOPPING JOINTER

1. The on/off switch (A) Fig. 8A is located on the front of the jointer. To turn the machine "ON", move switch (A) up to the "ON" position.
2. To turn the machine "OFF", move the switch down to the "OFF" position. The switch can be locked by taking off the switch key as shown on Fig. 8B

Fig. 8A

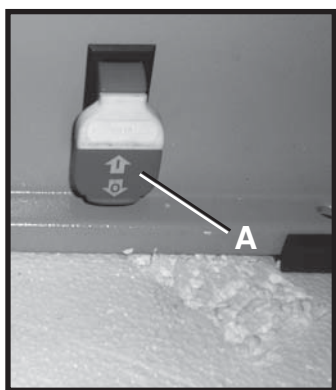
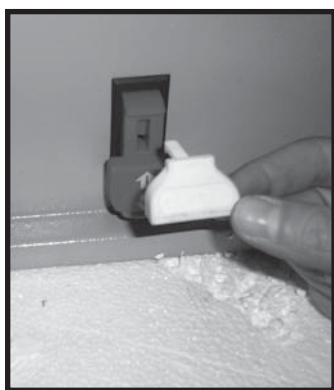


Fig. 8B



⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

DEPTH OF CUT

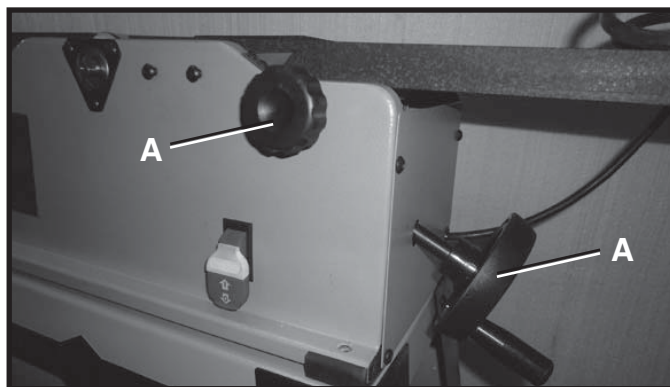
The depth of cut can be adjusted by positioning the infeed table with respect to the cutterhead. Infeed table can be raised or lowered by turning the handwheel.

Turn the locking knob counter-clockwise to loosen the table leadscrew. When the table is set to be at the desired height level, turn the locking knob clockwise to secure and lock the table in position.

Turning the handwheel counter-clockwise will lower the infeed table. This causes more wood to be removed from the workpiece. By turning the handwheel clockwise will raise the infeed table, which results in less wood to be removed from the workpiece.

NOTE: Do not make jointing or planing cuts deeper than 1/8".

Fig. 9

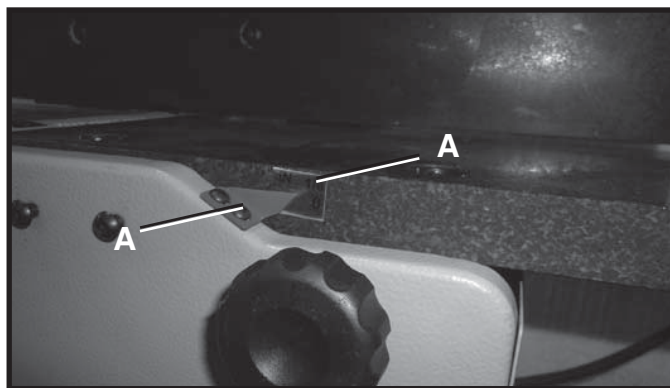


CHECK THE DEPTH OF CUT

- Place a straight edge on the outfeed table surface, extending over the infeed table. Align both tables to the same height.
- Adjust depth indicator to zero if needed.

NOTE: This jointer will make a maximum 1/8" deep cut. To reduce any danger of kickback and possible injuries, it is recommended to take cuts of 1/16" or less.

Fig. 10



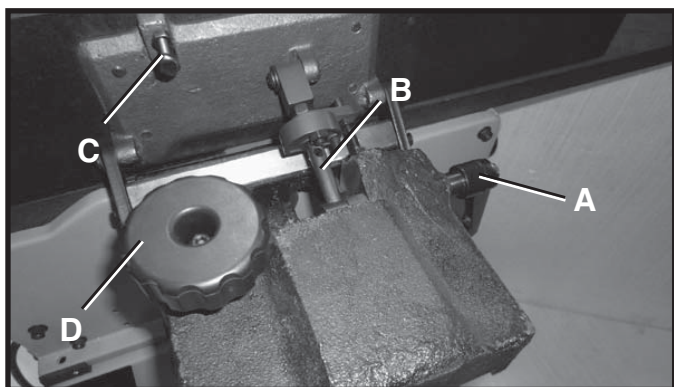
⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

POSITIONING FENCE

The fence can be adjusted to cut any angle from 0°-45°, inward and outward. The fence can be tilted inward up to 45° (towards the cutterhead) to maintain greater stability of a narrow workpiece. The fence can also be tilted up to 45° outward (away from cutterhead) for larger angle cutting operations.

Fig. 11



To adjust tilting angle (SEE FIG. 11):

- Loosen fence tilting handle (A).
- The fence tilting handle is spring loaded. To continue turning the handle, gently pull the handle away from the fence and return it to the original position.
- Release the handle and continue loosening.
- Manually tilt fence inward/outward to the desired angle. Use a bevel scale or protractor to measure tilt angle.

NOTE: The fence has positive stops at 0°(B), (90° from table), 45° inward and 45° outward (SEE FIG. 12 & 13).

NOTE: The '0°' stop (B) is movable. It is placed at the right detent when in use. It is placed at the center detent when using the 45° outward stop (C).

- Tighten fence tilting handle (A).
- To continue tightening, gently pull the handle away from fence and return the handle to the original position.
- Release the handle and continue tightening.
- Make sure the fence is tight and secure. The fence can be positioned so that any desired width of the blade is exposed.

To adjust fence position:

- Loosen fence sliding knob (D).
- Slide fence forward to the desired position.
- Tighten fence sliding knob (D).
- Make sure fence is tight and secure.

CAUTION: Do not remove the cutterhead guard. Make sure that the cutterhead is covered all the time.

CAUTION: Do not slide fence away from the jointer body. All sides of the cutterhead must be covered all the time.

Fig. 12

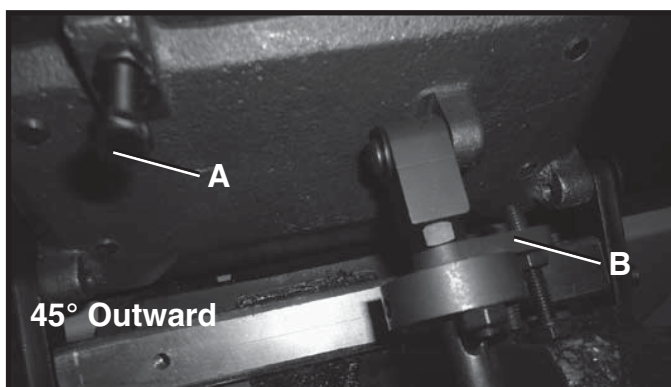


Fig. 13



CUTTERHEAD GUARD

The cutterhead guard provides protection over the cutterhead. It must always be in place and function properly. Check the guard to make sure it functions properly.

To check:

- Pass a 1/4" thick piece of wood over the cutterhead between the guard and the fence. The guard will spread and leave way for the wood piece to pass. The guard must return to the original position automatically when the wood piece is removed.
- Push the cutterhead guard all the way until it stops, and release it several times. It should always return to its original position by the spring action.

CAUTION: If the cutterhead guard fails to operate properly, replace the guard immediately. Please call 1-877-724-8665 for Technical Support.

AVOID DAMAGE TO CUTTERS

Jointer is a precision woodworking machine and should only be used on quality lumber. Using bad lumber could result in a poor quality cut on subsequent pieces. For proper functioning, it is suggested to use the jointer with a dust collecting system, attached to the exhaust port in the rear of the jointer. Attaching a dust collecting system is especially required when taking deeper cuts to prevent clogging of wood chips.

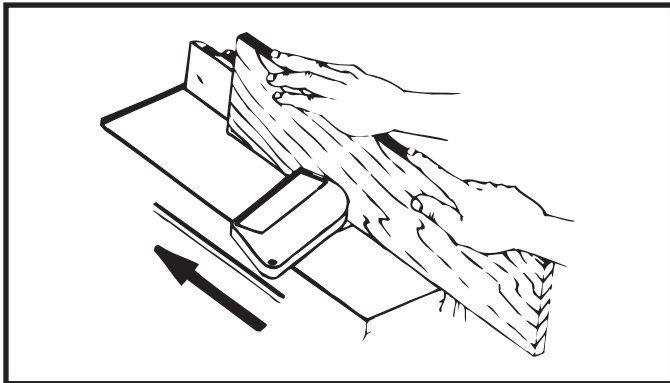
- Do not use dirty boards. Dirt and stones are abrasive and will wear the cutter tips.
- Remove nails and staples. Jointer should only cut wood.
- Avoid knots. Heavy cross-grain makes knots hard and they can come loose and jam the jointer.
- Assess value of badly warped boards. Operator can be tempted to use too deep of cut to square boards quickly. Use several passes to maintain a level surface.

FEEDING WORKPIECE

Feed rate refers to rate at which wood is passed over blades. An even feed will produce a uniform surface. To feed workpiece:

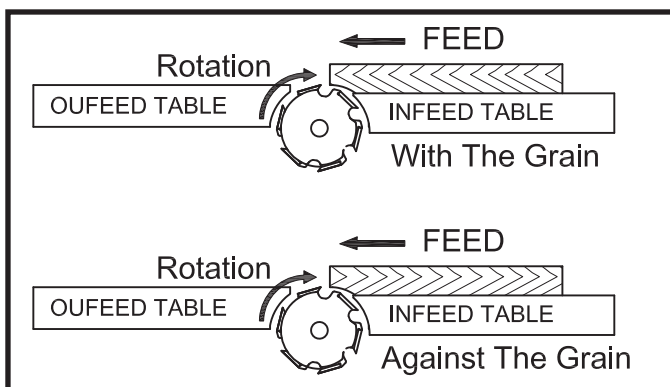
- Hold the board firmly down on both tables and against the fence.
- Keep fingers close together.
- Feed the board at a continuous even rate of speed. Any hesitation or stopping could cause a “step” to be cut on the edge of the board. **SEE FIG.14**

Fig. 14



- As the trailing hand passes over the cutterhead, remove the leading hand.
- Continue feeding while placing the leading hand behind the trailing hand until the entire length of the board is cut.

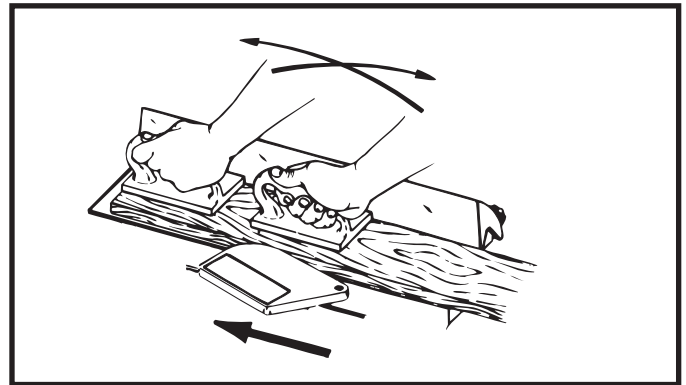
Fig. 15



- Feed with the grain whenever possible. **SEE FIG. 15**
- If the nature of the workpiece is such that it must be fed against the grain, take very light cuts and feed slowly.

- When using long workpieces, to avoid injury from slips or kickbacks and to exert even pressure on the cutterhead, use extra supports at both infeed and outfeed ends.

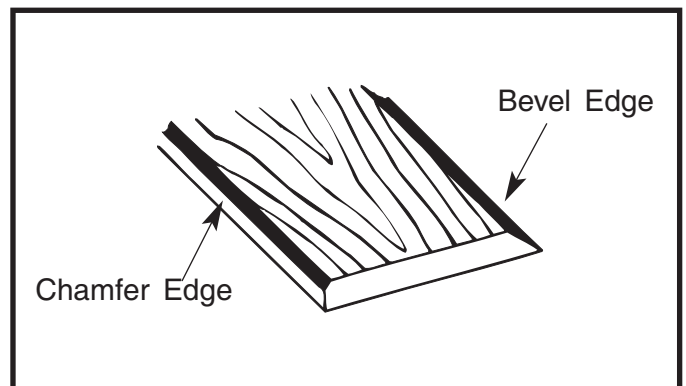
Fig. 16



USING HOLD DOWN/PUSH BLOCKS

- Always use hold-down/push-blocks when jointing wood that is narrower than 3", planing wood thinner than 3". **SEE FIG. 16**
- Grasp the hold-down/push-blocks firmly.
- Position the push-blocks flat on top of workpiece and push the workpiece down against the table.
- Use a hand-over-hand motion to maintain control over the workpiece at all times.
- When planing workpiece between 1/2 - 3/4" and narrower than the push-blocks, tilt the push-blocks so that it clears the cutterhead guard while feeding.

Fig. 17



BEVELING AND CHAMFERING

- The fence on the jointer is adjustable from 45° inward to 45° outward. Adjust the fence to the desired angle and tighten the fence tilting handle
- Beveling refers to cutting the entire edge of a board at an angle. Beveling may require several passes due to the depth of cut needed. **SEE FIG. 17**
- Chamfering refers to removing only the corner of the edge of a board. Normally a chamfer is made on one pass; so a 1/16" depth of cut is made. **SEE FIG. 17**

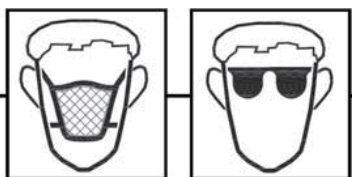
MAINTAINENCE

DO NOT begin cleaning up until you have read and understand all of the clean up instructions.

DO NOT USE FLAMMABLE MATERIALS TO CLEAN JOINTER.

CLEANING

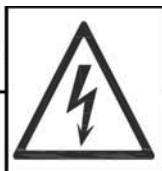
⚠ WARNING



With the machine unplugged, blow off motor with low pressure air to remove dust or dirt. Air pressure above 50 P.S.I. should not be used as high-pressure air may damage insulation. The operator should always wear a respirator and eye protection when using compressed air.

Do not allow chips and dust to accumulate under jointer. Keep area clean and in safe order.

⚠ WARNING



Turn the power switch "OFF" and unplug the power cord from its power source prior to any maintenance.

LUBRICATION

The jointer has sealed lubricated bearings in the motor housing that do not require any additional lubrication from the operator.

⚠ WARNING

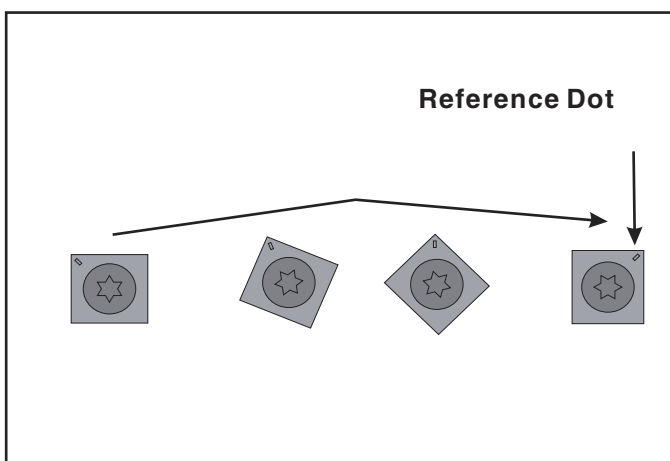
Repairs to the jointer should be performed by trained personnel only. Contact your nearest Steel City Dealer for authorized service. Unauthorized repairs or replacement with non-factory parts could cause serious injury to the operator and damage to the jointer.

ROTATING / CHANGING CUTTERS

The 6" cutterhead is equipped with 2 indexable carbide cutters; Each cutter can be rotated to reveal many one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90 to reveal a fresh cutting edge (Fig. 18).

In addition, each cutter has a reference dot on one corner. As the cutter is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves back around to its starting position, the cutter should be replaced.

Fig. 18



To rotate or change a carbide cutter:

1. DISCONNECT THE JOINTER FROM THE POWER SOURCE!
2. Remove any sawdust from the head of the carbide cutter Torx screw.
3. Remove the Torx screw and carbide cutter.
4. Clean all dust and dirt off the cutter and the cutterhead pocket from which the cutter was removed, and replace the cutter so a fresh, sharp edge is facing outward.

NOTE: Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between the cutter and cutterhead will slightly raise the cutter, and make a noticeable marks on your work-pieces the next time you plane.

5. Lubricate the Torx screw threads with a light machine oil, wipe the excess oil off the threads, and torque the Torx screw to 48-50 inch/ pounds.

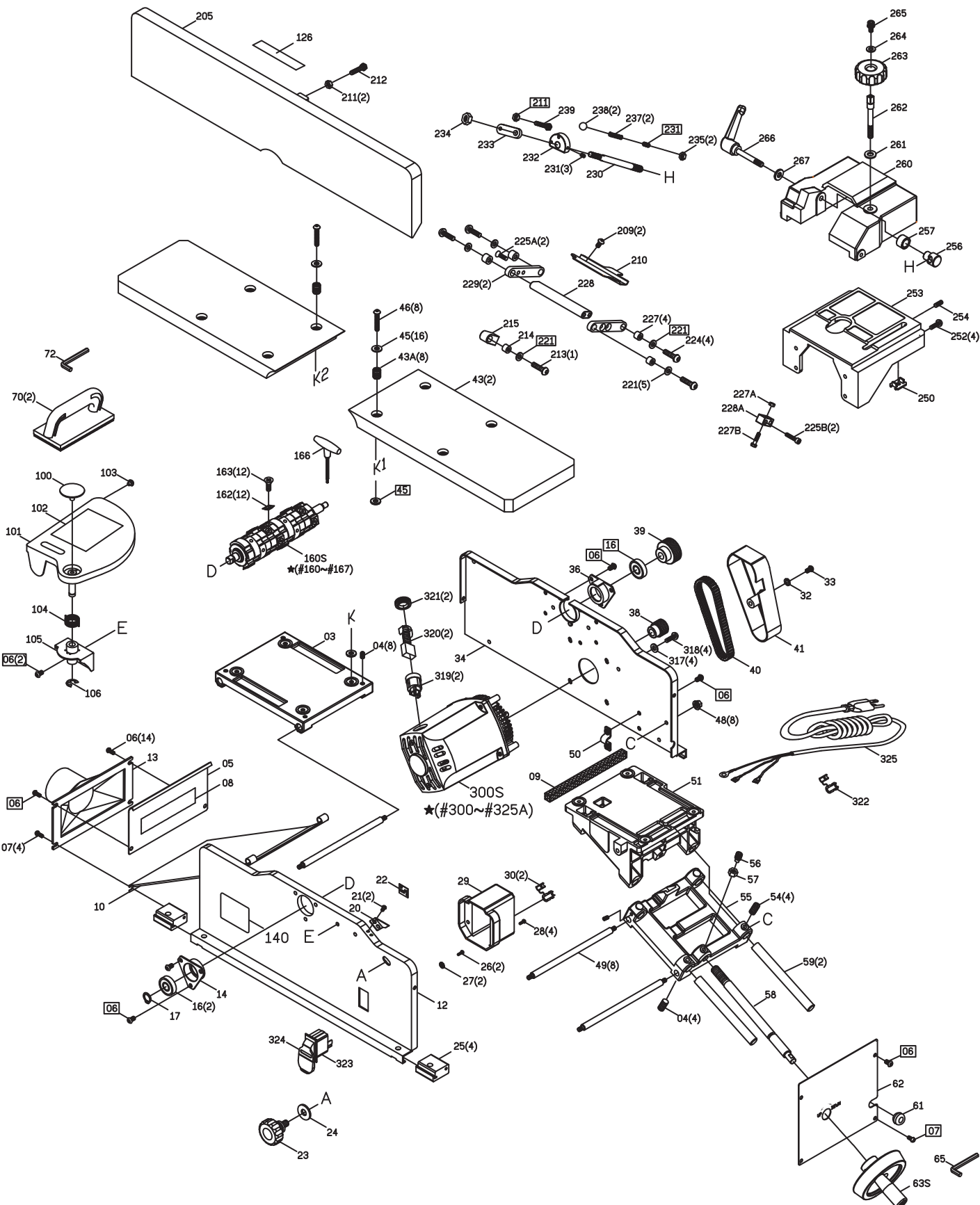
TROUBLESHOOTING GUIDE

Motor and Machine Operation

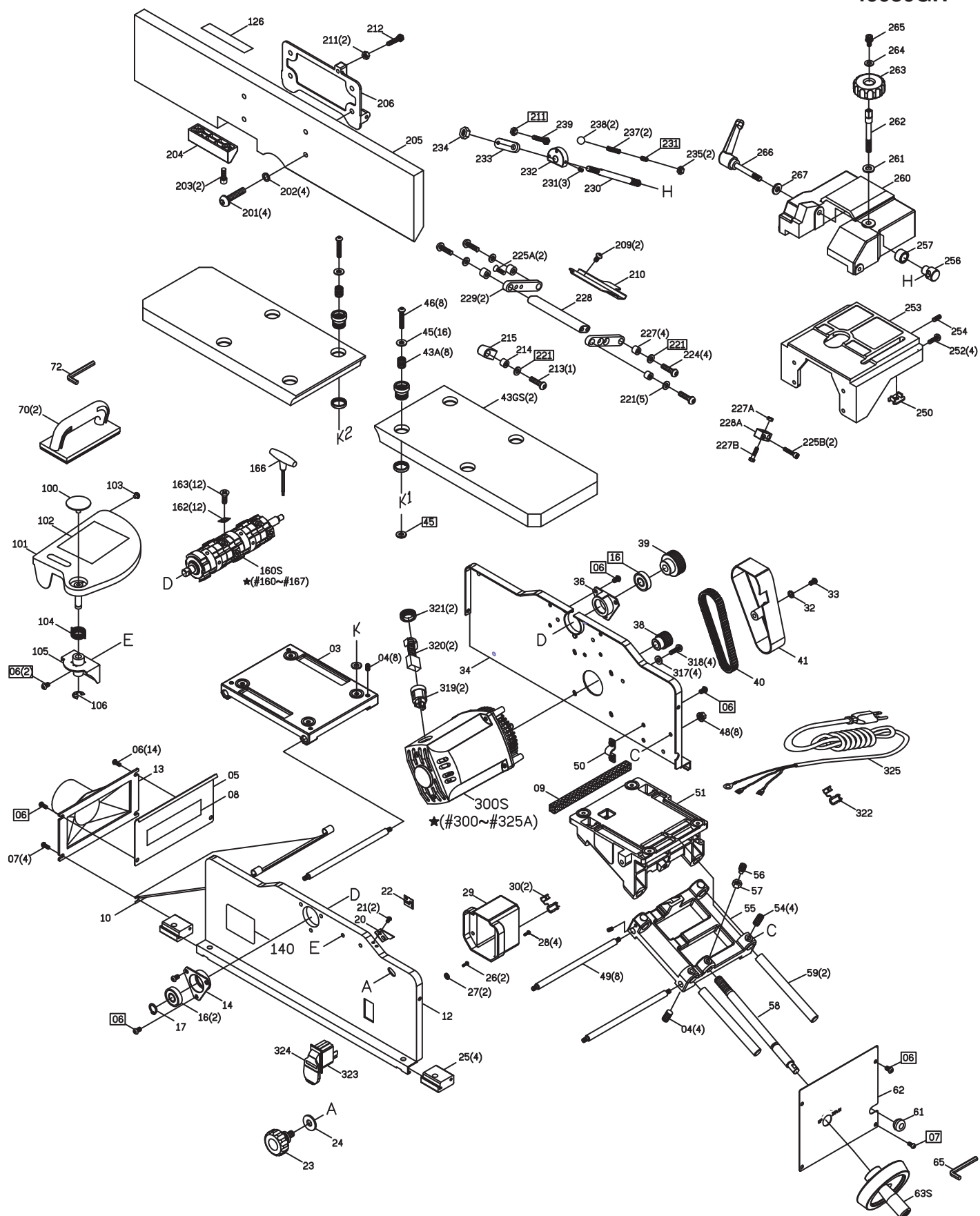
PROBLEM	LIKELY CAUSE(S)	SOLUTION
Snipe (depressions at end of workpiece)	Dull cutter blades. Infeed or outfeed tables out of adjustment.	Replace or turn cutter blades. Readjust tables.
Torn grain.	Too deep a blade setting. Workpiece being fed against grain. Dull cutter blades.	Reduce depth of cut. Feed other end of board first. Replace or turn cutter blades.
Fuzzy/rough grain.	High wood moisture content. Dull cutter blades. Too deep a blade setting. Incorrect feeding speed.	Dry wood before planing. Replace or turn cutter blades. Reduce depth of cut. Use slower feed rate.
Board thickness does not match depth scale indicator.	Depth scale incorrectly set.	Adjust depth scale.
Will not start.	Not plugged in. Blown circuit. Lockout key removed.	Check power source. Replace fuse, reset breaker, or call electrician. Replace lockout key.
Interrupted operation.	Unit overloaded. Circuit overloaded.	Reduce load. Operate on circuit separate from other appliances or motors or connect to circuit with adequate amp rating.

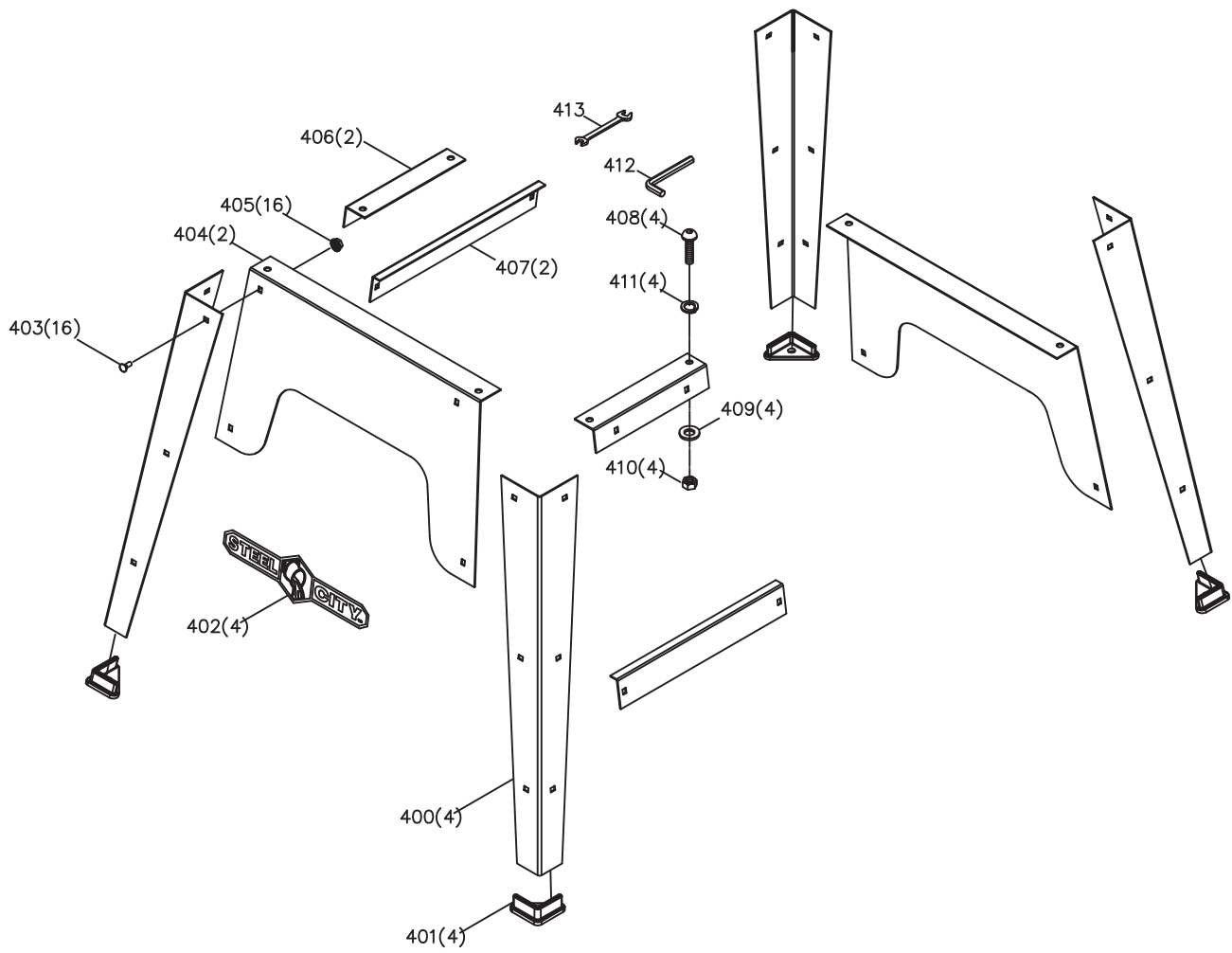
PARTS

40630CH



40630GH





KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
3	SC10643	OUTFEED SUPPORT	1	105	SC10676	BRACKET	1
4	SC80444	HEX SOC SET SCREW	8	106	SC85307	EXT RETAINING RING	1
5	SC10644	END COVER	1	126	SC76066	CAUTION LABEL	1
6	SC80445	BUTTON HD SCREW	14	140	SC76071	SPEC. LABEL	1
7	SC80446	SELF TAP SCREW	4	160S1	SC90006	SPIRAL CUTTERHEAD ASSEMBLY	1
8	SC76062	LABEL	1	162	SC10240H	INSERT	12
9	SC10645	FOAM SEAL	1	163	SC80116	TORX SOCKET HEAD CAP SCREW	12
10	SC10646	DUST CHUTE	1	166	SC10259	TORX WRENCH	1
12	SC10647	FRONT FRAME	1	201	OR91806	SCREW HEX HD	4
13	SC10648	VACUUM ADAPTOR	1	202	OR90248	SPRING WASHER	4
14	SC10649	BEARING RETAINER	1	203	SC80464	SOC HEAD CAP SCREW	2
16	SC83013	BEARING	2	204	SC10718	PAD	1
17	SC85306	EXTERNAL RETAINING RING	1	205	SC10719	FENCE	1
20	SC10650	POINTER	1	206	SC10720	SUPPORT PLATE	1
21	SC80447	SCR HEX SOC BUT HD	2	209	SC80452	SCR HEX SOC BUT HD	2
22	SC76064	DEPTH SCALE	1	210	SC10691	PLATE	1
23	SC10671	HANDLE WHEEL A"SS	1	211	OR90235	HEX NUT	2
24	SC82127	FLAT WASHER	1	212	SC80455	HEX HEAD SCREW	1
25	SC10651	FOOT	4	213	SC80456	SCR HEX SOC BUT HD	1
26	OR95507	SCR SEMS L/WASH	2	214	SC10692	SPACER (L)	1
27	SC82128	LOCKWASHER EXT	2	215	SC10693	COLLECTION BLOCK	1
28	SC80448	SCREW HEX HD	4	221	SC10694	WASHER	5
29	SC10652	SWITCH COVER	1	224	SC10695	SCR HEX SOC BUT HD	4
30	SC72057	STRAIN RELIEF	2	225	SC80457	PAN HEAD SCREW	2
32	OR90502	SPRING WASHER	1	225B	SC80465	SOC HEAD CAP SCREW	2
33	SC80449	BUTTON HD SCREW	1	227	SC10696	SPACER (S)	4
34	SC10653	REAR FRAME	1	227A	SC81121	HEX NUT	2
36	SC10654	BEARING RETAINER	1	227B	SC80466	SOC HEAD CAP SCREW	2
38	SC10655	DRIVE PULLEY	1	228	SC10697	CONNECTION ROD	1
39	SC10656	CUTTERHEAD PULLEY	1	228A	SC10725	BLOCK	1
40	SC10657	BELT	1	229	SC10698	CONNECTION PLATE	2
41	SC10658	BELT GUARD	1	230	SC10699	SLIDE SHAFT	1
43GS	SC	TABLE	2	231	SC80453	HEX SOC HD SET SCREW	3
43A	SC10660	ADJUST SCREW	8	232	SC10700	POSITION RING	1
45	SC82130	FLAT WASHER	16	233	SC10701	STOPPING PLATE	1
46	SC80450	BUTTON HD SCREW	8	234	OR90307	HEX NUT	1
48	SC81120	HWX FLANGE	8	235	OR90235	HEX NUT	2
49	SC10661	TIE ROD	8	236	SC10702	NUT	2
50	SC10662	CORD CLAMP	1	237	SC10703	SPRING	2
51	SC10663	INFEED SUPPORT	1	238	SC10704	BALL	2
54	SC80453	HEX SOC SET SCREW	4	239	OR91750	HEX HEAD SCREW	1
55	SC10664	BRACKET	1	250	SC10705	LOCKING BLOCK	1
56	SC10665	HEX SOC SET SCREW	1	252	SC80458	SCREW HEX HD	4
57	OR90235	HEX NUT	1	253	SC10706	FENCE BRACKET	1
58	SC10688	ADJUSTING ROD	1	254	SC80460	HEX SOC HD SET SCREW	1
59	SC10667	SHAFT	2	256	SC10707	BRACKET	1
61	SC10668	GROMMET	1	257	SC10708	RING	1
62	SC10669	END COVER	1	258	OR92191	HEX HEAD SCREW	1
63S	SC10689	HANDLE WHEEL	1	259	OR90235	HEX NUT	1
65	OR90290	HEX WRENCH	1	260	SC10709	FENCE SLIDE	1
70	SC10670	PUSH BLOCK	2	261	SC82132	FLAT WASHER	1
72	SC10684	HEX WRENCH	1	262S	SC90008	KNOB ASS	1
100	SC10672	HOLE PLUG	1	262	SC10710	STOPPING ROD	1
101	SC10673	GUARD ASSY	1	263	SC10711	KNOB	1
102	SC76065	WARNING LABEL	1	264	SC82131	FLAT WASHER	1
103	SC10674	BUMPER SHOE	1	265	SC80461	SCR SEMS L/WASH	1
104	SC10675	SPRING	1	266	SC10712	CLAMP LEVER MALE SCREW	1

KEY NO.	PART NO.	DESCRIPTION	QTY.
267	SC82132	FLAT WASHER	1
300S	SC90007	MOTOR A'SS	1
317	SC82131	FLAT WASHER	4
318	SC80452	SCR HEX SOC BUT HD	4
319	SC72058	HOLDER BRUSH	2
320	SC72059	BRUSH	2
321	SC72060	CAP BRUSH	2
322	SC72061	STRAIN RELIEF	1
323	SC72062	UL LOCKING	1
324	SC72063	KEY SWITCH	1
325	SC72064	LINE CORD	1
400S		STAND A'SS	1
400	SC10713	LEG	4
401	SC10714	LEVELING PAD	4
402	SC76063	Logo label	1
403	SC80462	Carriage bolt	16
404	SC10715	PLANE	2
405	SC82133	Nut Hex Flanged	16
406	SC10716	TOP SUPPORT	2
407	SC10717	DOWN SUPPORT	2
408	SC80463	SCREW HEX HD	4
409	SC82132	FLAT WASHER	4
410	OR90307	NUT	4
411	OR90248	SPRING WASHER	4
412	OR91728	WRENCH	1
413	OR74491	WRENCH	1
502	SC76070	MANUAL	1

KEY NO.	PART NO.	DESCRIPTION	QTY.
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◆ NOTES ◆



STEEL CITY TOOL WORKS

www.steelcitytoolworks.com

1-877-SC4-TOOL

(1-877-724-8665)

2 Year Warranty

