

# **JET**

**EQUIPMENT & TOOLS**

## **Operator's Manual**

### **JJ-60S Jointer**



NRTL / C  
LR108026

**JET EQUIPMENT & TOOLS, INC.**  
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No. M-708455 10/96

# Important Information

**2 YEAR**  
LIMITED WARRANTY

JET offers a two year limited warranty on this product

## REPLACEMENT PARTS

Replacement parts for this tool are available directly from JET Equipment & Tools. To place an order call **1-800-274-6844**. Please have the following information ready:

1. Visa, MasterCard or Discover Card number
2. Expiration date
3. Part number listed within this manual
4. Shipping address other than a Post Office box

## REPLACEMENT PART WARRANTY

JET Equipment & Tools makes every effort to assure that parts meet high quality and durability standards and warrants to the original retail consumer/purchaser of our parts that each such part(s) be free from defects in materials and workmanship for a period of thirty (30) days from the date of purchase.

## PROOF OF PURCHASE

Please retain your dated sales receipt as proof of purchase to validate the warranty period.

## LIMITED TOOL AND EQUIPMENT WARRANTY

JET makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: **2 YEAR LIMITED WARRANTY ON THIS JET PRODUCT.** Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities or to a lack of maintenance. **JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY OR FOR INCIDENTAL, CONTINGENT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.** To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an authorized service station designated by our Auburn office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, JET will either repair or replace the product or refund the purchase price, if we cannot readily and quickly provide a repair or replacement, if you are willing to accept such refund. JET will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

 **WARNING**

**Wear eye protection.**

**Always keep cutterhead and drive guards in place and in proper operating condition. Do not remove guard for rabbeting operations.**

**Never make a jointing, planing, or rabbeting cut deeper than 1/8".**

**Always use hold-down/push blocks for jointing material narrower than 3", or planing material thinner than 3".**

**Never perform jointing, planing, or rabbeting cuts on pieces shorter than 8" (203mm) in length.**

**This jointer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a jointer, do not use until proper training and knowledge have been obtained.**

- **KEEP GUARDS IN PLACE** and in working order.
- **REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
- **KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- **DON'T USE IN A DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from the work area.
- **MAKE THE WORKSHOP KIDPROOF** with padlocks, master switches, or by removing starter keys.
- **DON'T FORCE THE MACHINE.** It will do the job better and safer at the rate for which it was designed.
- **USE THE RIGHT TOOL.** Don't force a machine or attachment to do a job for which it was not designed.
- **USE THE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw. An undersized cord will cause a drop in the line voltage resulting in power loss and overheating. The table on page two shows the correct size to use depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. Remember, the smaller the gauge number, the heavier the cord.

- **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
- **SECURE WORK.** Use clamps or a vise to hold the work when practical. It's safer than using your hands and it frees both hands to operate the tool.
- **DON'T OVERREACH.** Keep proper footing and balance at all times.
- **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- **ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE SERVICING.**
- **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the off position before plugging in.
- **USE RECOMMENDED ACCESSORIES.** Consult the operator's manual for recommended accessories. The use of improper accessories may cause the risk of injury to persons.
- **NEVER STAND ON A MACHINE.** Serious injury could occur if the machine is tipped or if the blade is unintentionally contacted.
- **CHECK DAMAGED PARTS.** Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- **DIRECTION OF FEED.** Feed work into the blade against the direction of rotation of the blade only.
- **NEVER LEAVE THE MACHINE RUNNING UNATTENDED. TURN POWER OFF.** Don't leave the machine until it comes to a complete stop.

Volts	Total Length of Cord in Feet			
	25	50	100	150
120V				
240V	50	100	200	300
			AWG	
	14	12		Not Recommended

## 115 Volt Operation

As received from the factory, your jointer is ready to run at 115 volt operation. This jointer, when wired for 115 volt, is intended for use on a circuit that has an outlet and a plug that looks the one illustrated in Figure A. A temporary adapter, which looks like the adapter as illustrated in Figure B, may be used to connect this plug to a two-pole receptacle, as shown in Figure B if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. **This adapter is not applicable in Canada.** The green colored rigid ear, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box, as shown in Figure B.

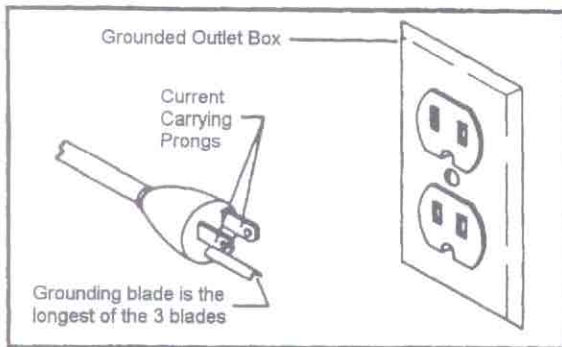


Fig. A

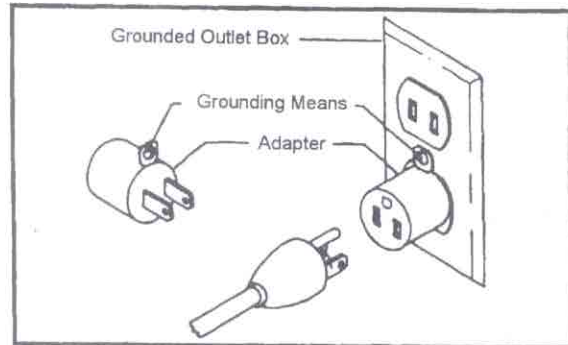


Fig. B

## 230 Volt Operation

If 230V, single phase operation is desired, the following instructions must be followed:

1. Disconnect the machine from the power source.
2. This jointer is supplied with four motor leads that are connected for 115V operation, as shown in Figure C. Reconnect these four motor leads for 230V operation, as shown in Figure D.
3. The 115V attachment plug, supplied with the jointer, must be replaced with a plug suitable for 230V operation. This plug is illustrated in Fig. E. Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The jointer must comply with all local and national codes after the 230 volt plug is installed.
4. The jointer with a 230 volt plug should only be connected to an outlet having the same configuration as illustrated by the grounded outlet box in Figure E. No adapter is available or should be used with the 230 volt plug.

**Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.**

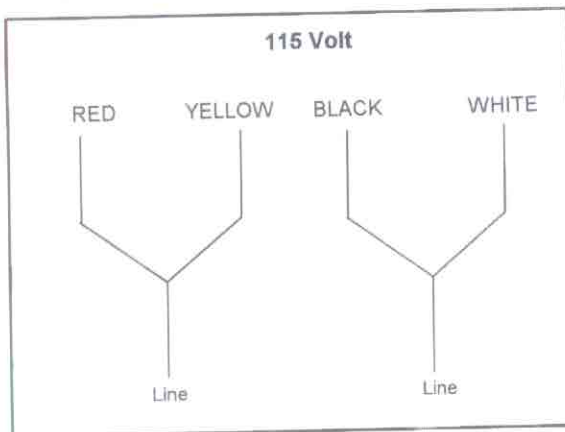


Fig. C

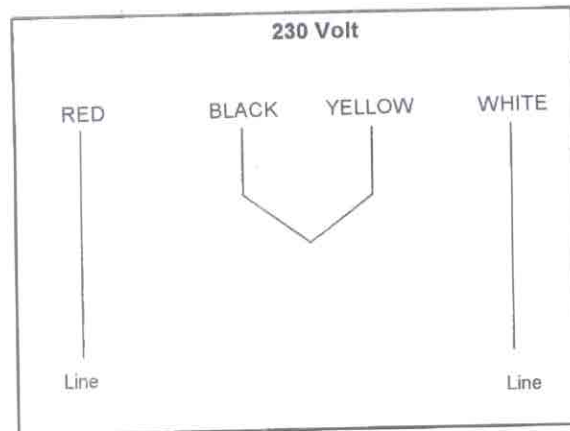


Fig. D

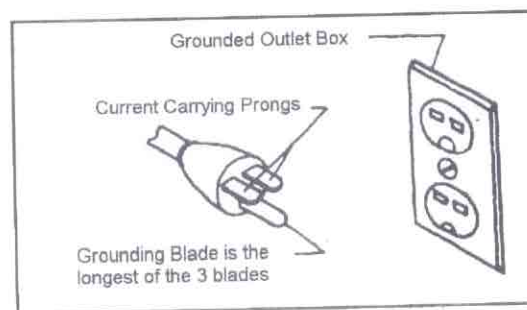


Fig. E

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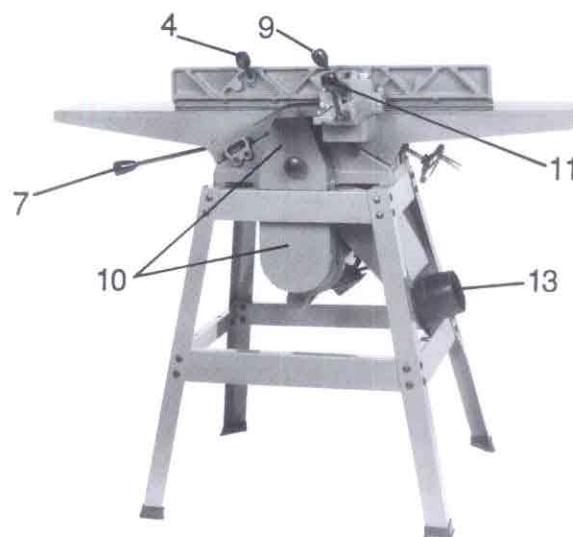
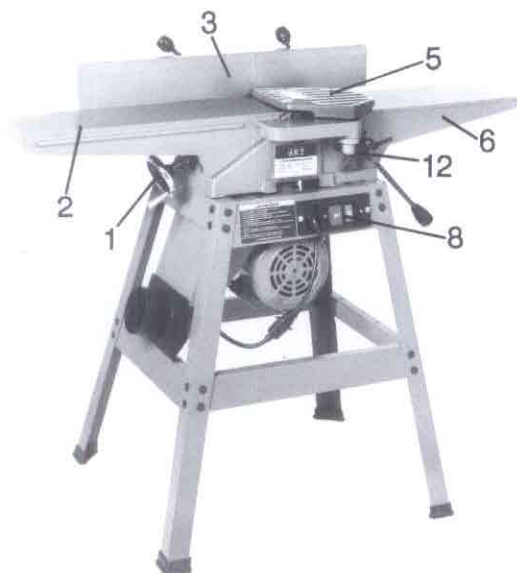
## Introduction

The JET JJ-60S woodworking jointer you have purchased is a high quality machine tool that will give you years of superior service. You will get maximum performance and enjoyment from your new jointer if you will take a few moments now to review the entire manual before beginning assembly and operation. Become familiar with the details of operation and be sure to review the controls page to start to become familiar with some of the unique words associated with a jointer.

The JET JJ-60S jointer, as well as all JET products, are backed by a nationwide network of authorized distributors and/or service centers. Please contact your nearest distributor should you require parts or service. Parts are also available directly from JET by calling 1-800-274-6844.

Now that you have purchased a jointer, it is a good time to consider a dust collection system. See your local JET distributor for the complete line of dust collectors and the full line of JET Dust Collector Hoses and Accessories. Customize your installation and obtain maximum performance with JET's dust hoods, hoses, clamps, fittings, and blast gates.

## Levers and Controls



1. Hand Wheel for Outfeed Table
2. Outfeed Table
3. Fence
4. Fence Adjustment Handle
5. Cutter Guard
6. Infeed Table
7. Lever for Infeed Table

8. On/Off Switch
9. Fence Tilt Lock Handle
10. Belt Guard
11. Fence Control Handle
12. Depth Stop Limiter
13. Dust Chute

### Specifications:

### JJ-60S

Stock Number .....	708455
Cutting Capacity .....	6"W x 1/2"D
Cutterhead Speed .....	4850 RPM
Number of Knives .....	3
Rabbeting Capacity .....	1/2"
Rabbit Ledge .....	3-1/8" x 8-3/4"
Table Surface .....	7"W x 46"L x 31-3/4"H
Fence .....	4"H x 27-3/4"L
Blade Size .....	6-1/16" x 5/8" x 1/8" T
Fence Tilts Right .....	45°
Positive Stops .....	45°, 90°
Motor .....	3/4 HP, 1Ph
.....	115/230V, Prewired 115V
Net Weight (approx.) .....	180 lbs.

The specifications in this manual are given as general information and are not binding. JET Equipment and Tools reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.



## Contents of Shipping Container

1	Bed Assembly	4	Stand Leg
1	Fence Assembly w/ Lock Handle	4	Rubber Feet
1	Cutterhead Guard	4	Cross Brace
1	Pulley Guard	4	Stand Top
1	Upper Belt Guard	1	Lower Belt Guard
1	V-Belt	1	Lower Cover
1	Infeed Table Lever	1	Motor
1	Outfeed Table Hand Wheel	1	Switch Assembly
2	Push Blocks	1	Dust Chute Bracket
1	Accessory Package	1	Dust Guard Plate
1	Operator's Manual	1	Dust Hose Adapter
1	Warranty Card		

## Tools Required for Assembly

#2 Cross Point Screw Driver

## Unpacking and Cleanup

1. Carefully finish removing all contents from the shipping carton. Compare contents of the shipping carton with the list of contents above. Place parts on a protected surface.
2. Report any shipping damage to your local distributor.
3. Clean all rust protected surfaces (bed, fence, etc.) with kerosene or diesel oil. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.  
**Caution:** Cutterhead blades are extremely sharp! Use care when cleaning!
4. Apply a thin layer of paste wax to the bright surfaces of the fence and tables to prevent rust.
5. Set packing material and shipping cartons to the side. Do not discard until machine has been set up and is running properly.

## Assembly

### Stand Assembly

Note: Hand tighten all stand hardware until the bed has been mounted and tightened to the stand.

1. Push four rubber feet (A, Fig. 1) onto the bottom end (without holes) of four stand legs (B, Fig. 1).
2. Attach left and right cross braces (C, Fig. 1) to the four stand legs with 8 5/16" x 1/2" carriage bolts (E, Fig. 1), 8 5/16" flat washers (F, Fig. 1), and 8 5/16" hex nuts.
3. Attach front and rear cross braces (D, Fig. 1) to the four stand legs with 8 5/16" x 1/2" carriage bolts (E, Fig. 1), 8 5/16" flat washers (F, Fig. 1), and 8 5/16" hex nuts (G, Fig. 1).
4. Attach front and rear stand tops (H, Fig. 1) with 8 5/16" x 1/2" carriage bolts, eight 5/16" flat washers, and eight 5/16" hex nuts.
5. Attach left and right stand tops (J, Fig. 1) with 8 5/16" x 1/2" carriage bolts, eight 5/16" flat washers, and eight 5/16" hex nuts.
6. Attach the motor mount bracket (A, Fig. 2) to the left cross brace and the stand top with four 5/16" carriage bolts (B, Fig. 2), four 5/16" flat washers (C, Fig. 2), and four 5/16" hex nuts (D, Fig. 2).
7. Loosely mount the motor (A, Fig. 3) to the motor plate (B, Fig. 3) with four 5/16" x 3/4" hex cap bolts (C, Fig. 3), four 5/16" flat washers (D, Fig. 3), four 5/16" lock washers (E, Fig. 3), and four 5/16" hex nuts (F, Fig. 3). Make sure the motor shaft and pulley face toward the rear of the machine.
8. With the help of a second person, carefully lift the jointer bed onto the stand top.

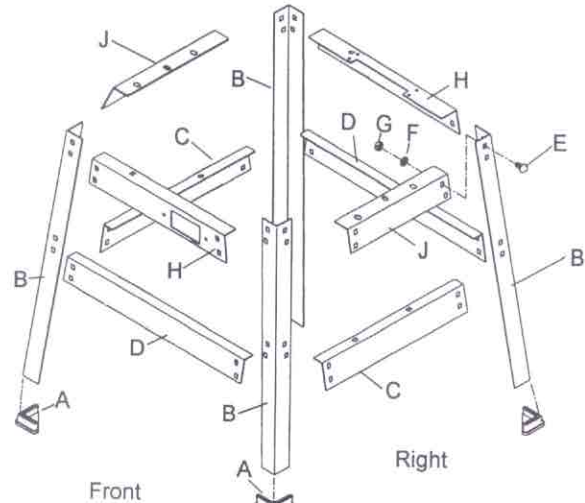


Fig. 1

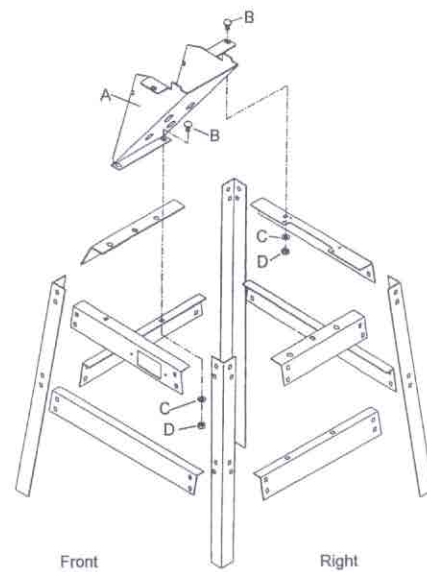


Fig. 2

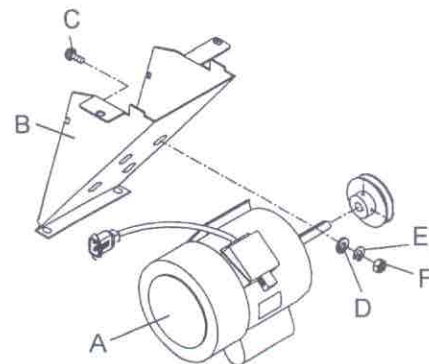
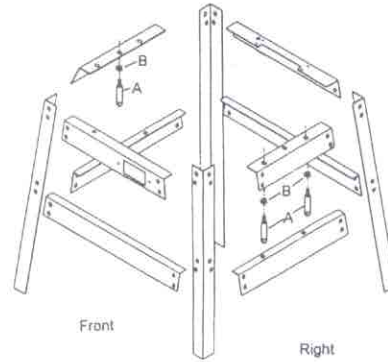


Fig. 3

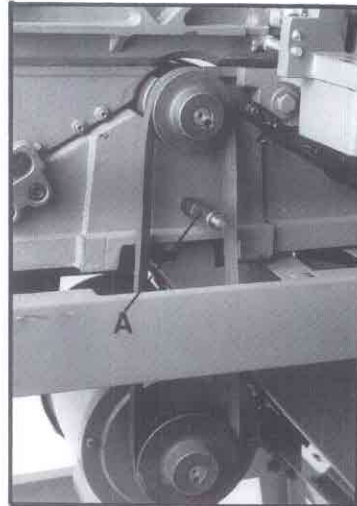
9. Line up holes in the stand top with holes in the jointer base and secure with three lock bolts (A, Fig. 4) and three lock washers (B, Fig. 4).
10. Level the stand and tighten all stand hardware securely. Do not over tighten.



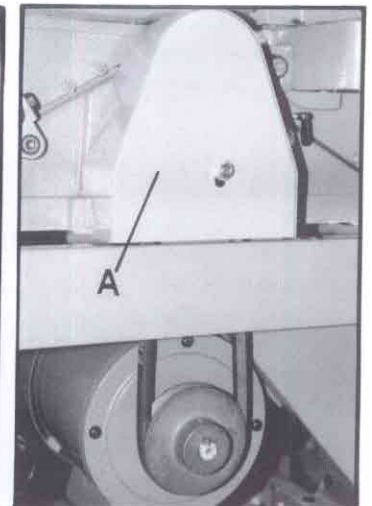
**Fig. 4**

### V-Belt and Pulley Cover Assembly

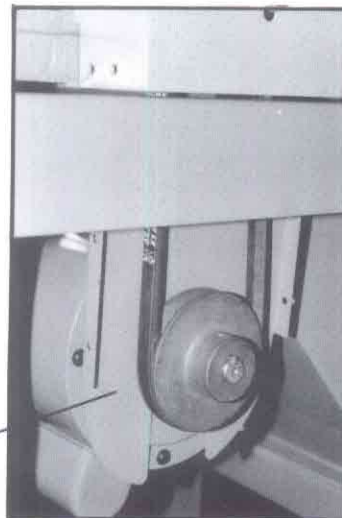
1. Place the V-belt on the motor and cutterhead pulleys (Fig. 5).
2. Align the pulleys (if necessary) by loosening the set screws on the pulley, sliding along the shaft, and then tightening the set screws.
3. Tension the belt by pushing down on the motor and tightening the hardware holding the motor to the motor plate. The V-belt is properly tensioned when moderate finger pressure on the belt half way between the two pulleys is approximately 1/2".
4. Insert the belt guard stud (A, Fig. 5) into the rear of the jointer base and tighten. The stud has a flat spot to accommodate a wrench.
5. Attach the upper belt guard (A, Fig. 6) to the jointer with one 5/16" flat washer and one 5/16" hex nut.
6. Position the lower belt guard backing cover (A, Fig. 7) behind the v-belt and onto the motor shaft.
7. Attach the lower belt guard to the lower belt guard cover with four 5/32" x 1/4" pan head screws and four M4 flat washers.
8. Attach the lower belt guard to the upper belt guard with four 1/4" x 3/8" pan head screws. See Fig. 7A.



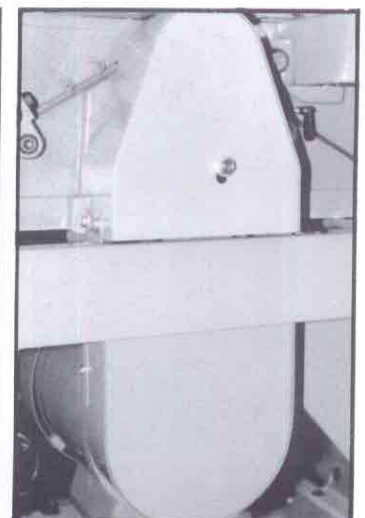
**Fig. 5**



**Fig. 6**



**Fig. 7**



**Fig.7A**

## Dust Chute and Adapter Assembly

1. Install the dust guard plate (A, Fig. 8) to the motor plate (B, Fig. 8) by inserting the pins on the dust plate into the grooves on the motor plate.

If the jointer is to be used without a dust collector, secure the dust guard plate (A, Fig. 8) to the motor plate (B, Fig. 8) with two wing screws (C, Fig. 8). Do not install the adapter plate (D, Fig. 8) if a dust collector is not used. Installing the adapter plate without a dust collector may cause saw dust to back up and clog the jointer.

If the jointer is to be used with a dust collector, match the holes in the adapter plate (D, Fig. 8) with the holes in the dust guard plate (A, Fig. 8) and secure to the motor plate with two wing screws (C, Fig. 8).

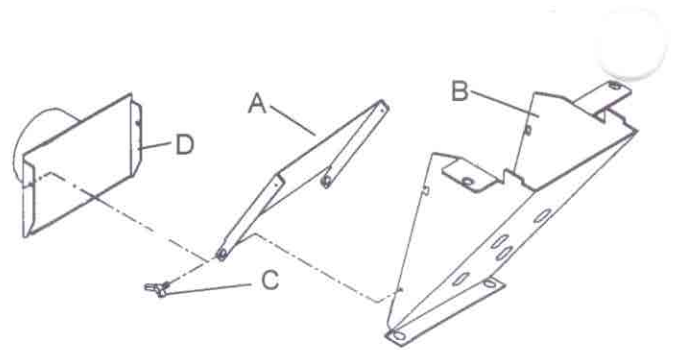


Fig. 8

## Fence Assembly

1. Remove two hex nuts and a flat washer from the clamping bolt (A, Fig. 9) on the fence assembly.
2. Place the fence assembly onto the bed assembly. Make sure the key stock (B, Fig. 9) on the bed engages the slot (C, Fig. 9) in the fence casting.
3. Place the flat washer and the two hex nuts back onto the clamping bolt and adjust so the lock handle works properly. Proper operation is approximately one quarter turn from locked to unlocked.
4. Fasten the cutter guard (B, Fig. 10) to the fence with the two 1/4" x 1/2" pan head screws and two 1/4" flat washers.

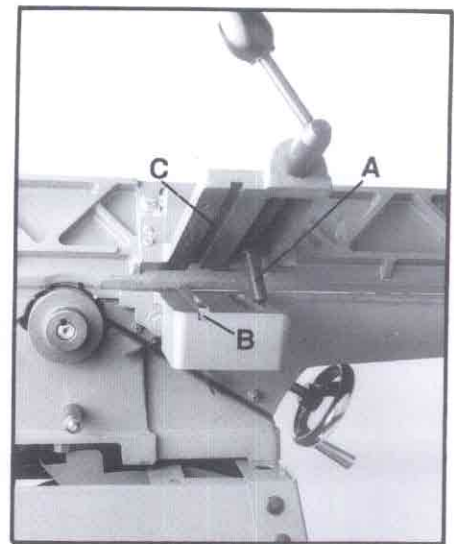


Fig. 9

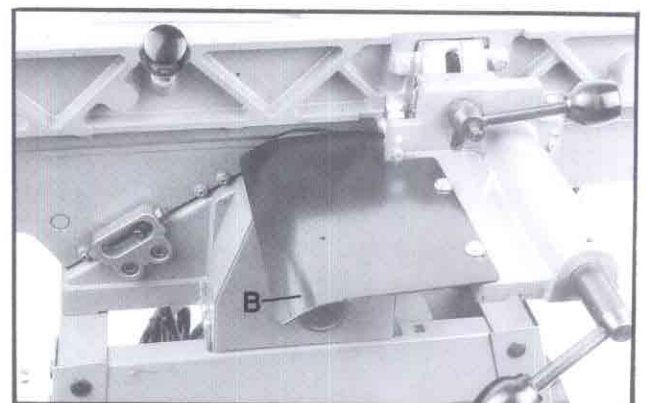


Fig. 10

## Handwheel and Hand Lever Assembly

1. Fasten the handwheel (A, Fig. 11) to the handwheel post with one 1/4" x 1/2" pan head screw and one 1/4" flat washer.
2. Thread the handle (B, Fig. 11) into the block on the right side of the jointer. Tighten the hex nut to hold in place.

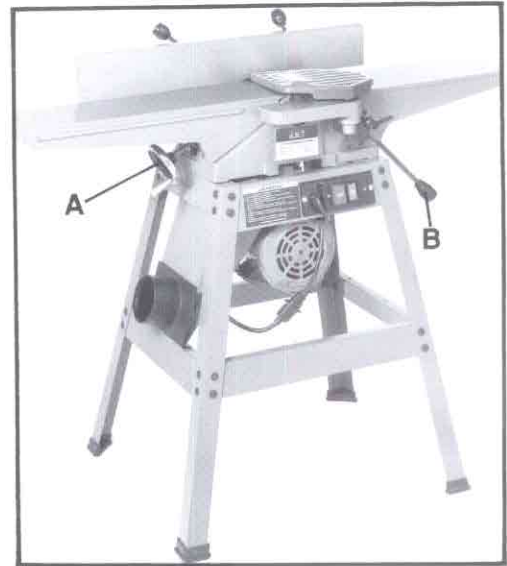


Fig. 11

## Electrical Switch Assembly

1. Attach the switch assembly to the inside of the stand top with two 3/16" x 1/2" pan head screws and two flat washers.
2. Connect the switch plug to the motor plug. **Do not connect the machine to the power source!**

## Cutter Guard Assembly

1. Turn the spring knob (A, Fig. 12) approximately one and one half revolutions counter-clockwise and hold.
2. Insert the guard post into the hole in the table. Make sure the spring engages the slot in the guard post.
3. Check for proper operation. The guard must return fully to the fence when released. If the guard does not return fully; pull the guard, apply more tension to the spring knob, and re-insert the guard. If the guard closes too quickly and strikes the fence too hard, release some tension on the spring.



Fig. 12

## 90° Fence Adjustment

**Note:** whenever making an adjustment to the fence, lift the fence up slightly after releasing the lock handle to avoid scratching the table.

1. Set infeed table to the same height as the outfeed table.
2. Move the fence by releasing lock handle (A, Fig. 13) and pushing the fence assembly until it overlaps the tables.
3. Adjust the fence to a 90° angle by releasing lock handle (B, Fig. 13), pulling up on handle (C, Fig. 13), and locking handle (B, Fig. 13).
4. Place a combination square on the infeed table. (Fig. 14)
5. If the fence is not square to the table, release lock handle (A, Fig. 15), loosen lock nuts (B, Fig. 15), and turn bolts (C, Fig. 15) until the fence is square to the table.
6. Tighten lock nuts (B, Fig. 15) to retain the setting. Tighten lock handle (A, Fig. 15).

## 45° Fence Adjustment

**Note:** whenever making an adjustment to the fence, lift the fence up slightly after releasing the lock handle to avoid scratching the table.

1. Loosen lock handle (A, Fig. 15). Move the fence to a 45° angle. Make sure the fence sits against the stop bolts (D, Fig. 15).
2. Place a combination square on the fence and table to confirm a 45° setting. (Fig. 16)
3. To adjust, loosen lock nuts (E, Fig. 15), turn bolts (D, Fig. 15) until a 45° angle is obtained, and tighten lock nuts (E, Fig. 15). Tighten lock handle (A, Fig. 15).

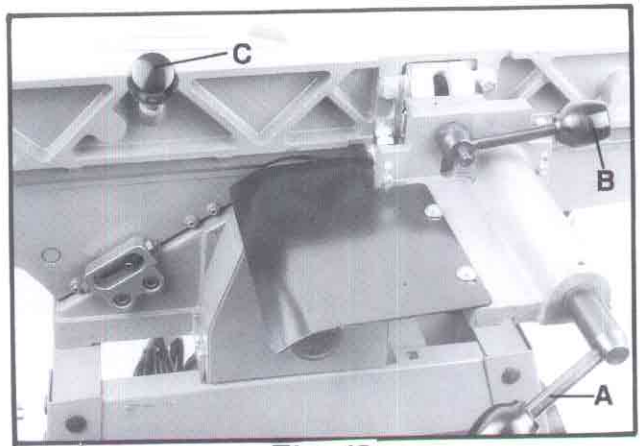


Fig. 13



Fig. 14

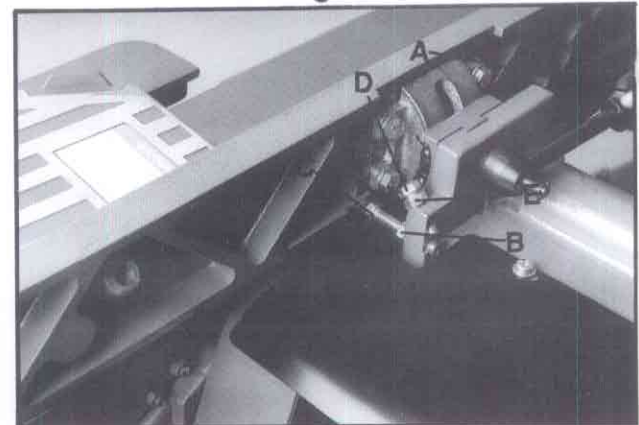


Fig. 15

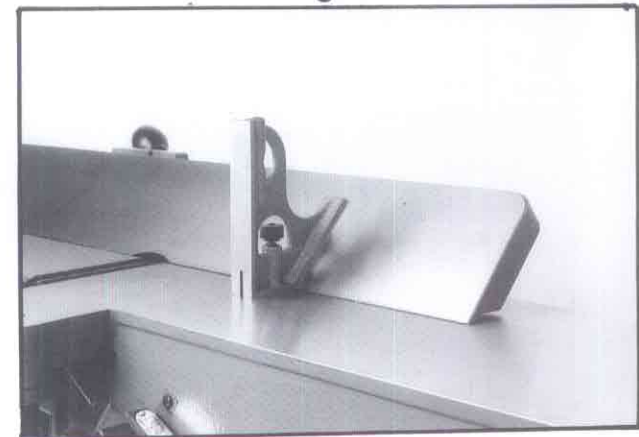


Fig. 16

## Depth Stop Limiter

The depth stop limiter (A, Fig. 17) limits the depth of a cut to 1/8". Loosen the lock handle (B, Fig. 17) and pull out on the stop handle (C, Fig. 17). Lower the table and the stop engages after 1/8" of travel. Never override the depth stop limiter and try to take more than a 1/8" cut at any single pass.

## Setting Outfeed Table to Cutterhead Knives

 **WARNING**

**Do not connect machine to power source at this time!**

**Cutterhead blades are extremely sharp! Use caution when hands are near the cutterhead! Failure to comply may cause serious injury!**

1. Carefully number each blade with a magic marker to make them easier to differentiate.
2. Rotate the cutterhead by turning the cutterhead pulley and determine the 12 o'clock position of knife number one. The 12 o'clock position is the highest point a blade will reach in the cutting arc.
3. Loosen table lock screws (A, Fig. 18) and raise the outfeed table to the height of blade number one by turning the hand wheel. Counter-clockwise will cause the outfeed table to raise. Clockwise will cause the outfeed table to lower.
4. Set a straight edge on the outfeed table. Position of the table and straight edge should look like Figure 19. Use care when handling the straight edge near the blades so as not to damage them.
5. When the outfeed table and blade number one are the same height, tighten the table lock screws. **Do not change the setting for the outfeed table again. This will only change if the blades are replaced.**
6. Bring the straight edge toward the left of the jointer and confirm that blade number one is at the same height at the left of the table as it is at the right side of the table. (Fig. 20)

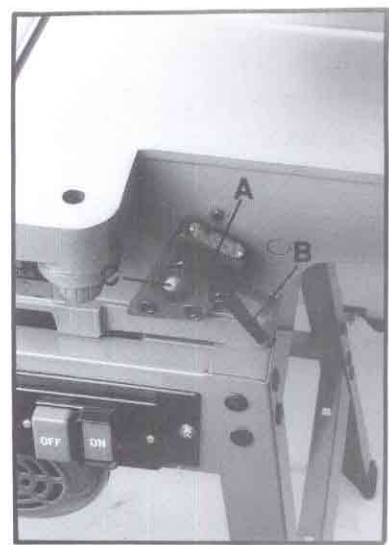


Fig. 17

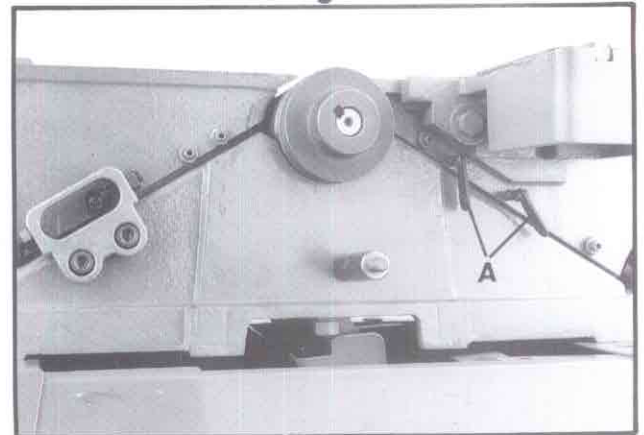


Fig. 18

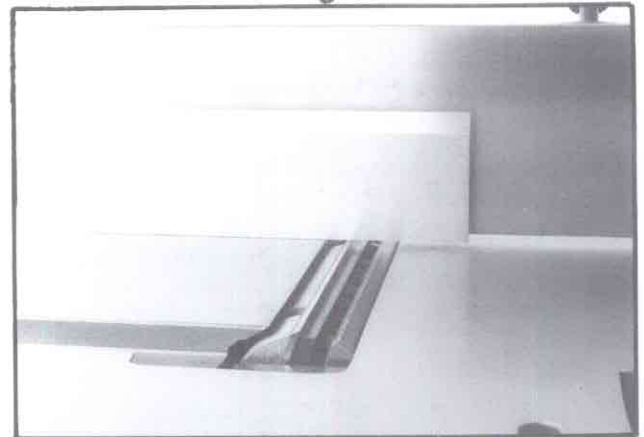


Fig. 19

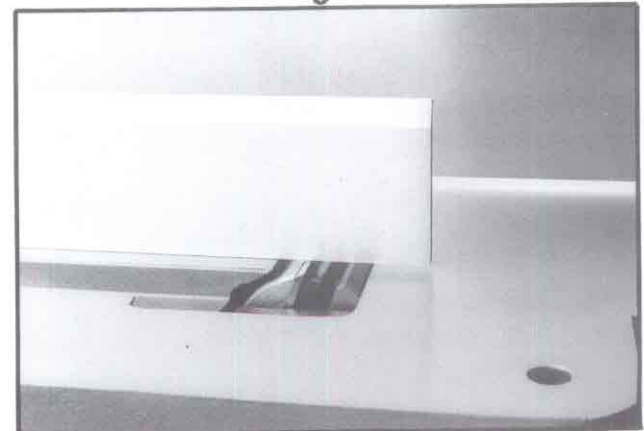
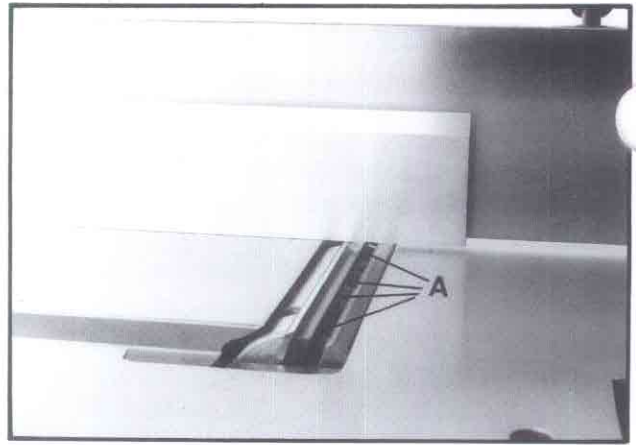


Fig. 20

7. If blade is higher or lower at the left of the table than it is at the right, slightly loosen four screws (A, Fig. 21) by turning clockwise as viewed from the infeed table. To lower the blade, carefully push down on the blade with a block of wood. To raise the blade, carefully lift each end of the blade. **Blades are set at the proper height when the top of the blades are 1/16" above the cutterhead.** Alternately tighten four screws to hold each blade in place.
8. Repeat this process with blades two and three. **The outfeed table and cutterhead knives are correctly adjusted when all three blades are parallel to the outfeed table and all three blades are set at the same height in the cutterhead.**

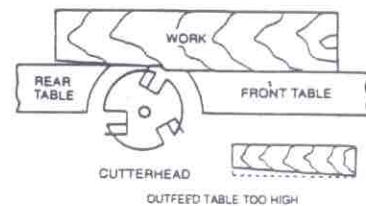


**Fig. 21**

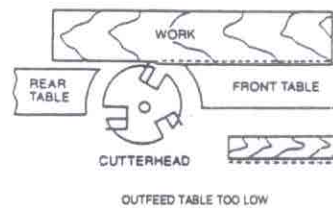
If the outfeed table is set too high, a curved finished surface results. (Fig. 22)

If the outfeed table is set too low, gouging results at the end of the cut. (Fig.23)

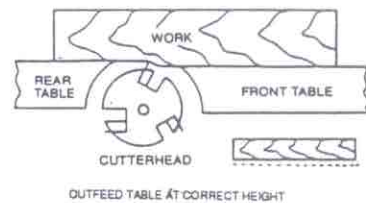
Figure 24 illustrates the outfeed table at the correct height.



**Fig. 22**



**Fig. 23**



**Fig. 24**

## Operation

### **WARNING**

**Keep all guards in place and in adjustment at all times during the cutting procedure!**

**Keep hands away from the cutterhead! Do not pass hands directly over the cutterhead!**

**The use of push sticks and/or handle pads are highly recommended when using the jointer!**

**Failure to comply may cause serious injury!**

Jointing cuts or edge jointing are made to square an edge of a workpiece. The workpiece is positioned on the jointer with the narrow edge of the workpiece on the infeed table and the major flat surface of the workpiece against the fence.

Planing cuts are similar. The major surface of the workpiece is placed on the table with the narrow edge of the workpiece against the fence.



For jointing and planing cuts pressure is directed three ways; into the fence to ensure a square cut, forward to advance the stock, and downward to avoid chatter and vibration.

For jointing when the material is higher than the fence, the left hand applies pressure into the fence and down toward the table while the right hand pushes forward from behind. Be sure to keep the right hand high up on the material. (Fig. 25)

For jointing material that is lower than the fence, use push sticks to protect the hands. For planing, use handle pads. (Fig. 26) **Never place the right hand on the trailing edge of the material. Hand placement on the trailing edge of the material may cause the hand to come in contact with the blade.**

Feed work from right to left at a steady, moderate speed. Feed the material too slowly and the wood will burn in places. Feed the material too quickly and ridges will appear in the finished surface.

### Jointing Warped Material

If the work to be jointed is cupped or warped, take light, repetitive cuts until the surface is flat. Forcing the material flat against the table will still leave a warped piece after the cuts have made.



Fig. 25

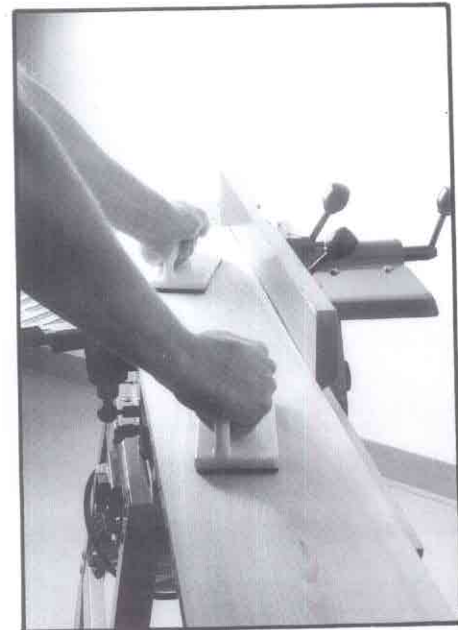


Fig. 26

**⚠ WARNING**

**Never joint any material shorter than eight inches! The material may tip into the jointer's throat and be kicked back!**

**Avoid jointing thin material which could become jammed under the fence or blade guard!**

**Failure to comply may cause serious injury!**

### Direction of Grain

Feed the material in the direction of the grain to avoid tearout. If the direction of the grain changes somewhere in the board, try reducing depth of cut and slow the feed speed down to avoid tearout. If results still aren't satisfactory, turn the material around and try feeding through the other way. (Fig.'s 27 and 28)

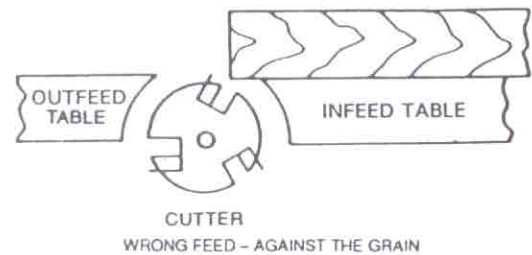


Fig. 27

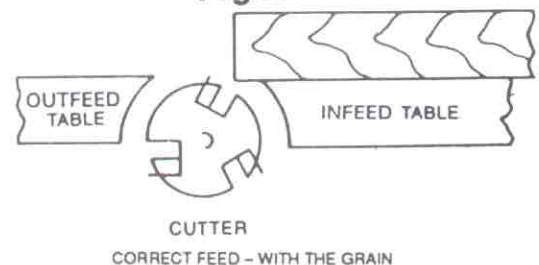


Fig. 28

## Bevel Cut

To cut a bevel, lock the fence at the desired angle and run the material through, pressing the work firmly against the fence and tables. Several passes may be necessary for the desired result.

## Rabbet Cut

1. Adjust the fence so that the distance between the end of the knives and fence is equal to the width of the rabbet.
2. Lower the infeed table an amount equal to the depth of the rabbet. If the rabbet is more than 1/8", it may be necessary to cut in two or more passes. (Fig. 29)

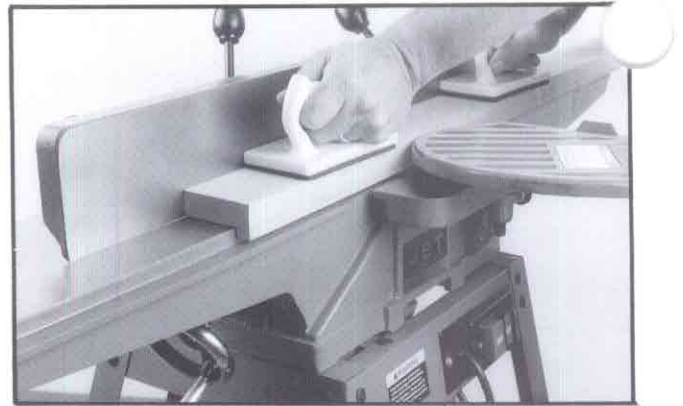


Fig. 29

## Removing and Replacing Knives

### ⚠ WARNING

**Disconnect the machine from the power source before making any adjustment or repair!**

**All knife lock bolts must be firmly tightened or risk ejection of the knife(s) and lock bar from the cutterhead!**

**Failure to comply may cause serious injury!**

1. **Disconnect machine from the power source.**
2. Remove blade guard by turning knob (A, Fig. 30) clockwise while lifting up on blade guard. **Caution: blades are sharp! Use great care when hands are around blade area!**
3. Loosen four screws (A, Fig. 31). **Note:** Loosen screws by turning in a clockwise direction as viewed from the infeed table. Carefully remove the knife (B, Fig. 31), the lock bar with screws (C, Fig. 31), and the springs (D, Fig. 31). Repeat for the other two blades.
4. Before assembly, clean all parts thoroughly and clear cutterhead knife slots of any dust or debris.
5. Insert knife into the cutterhead channel making sure it faces the proper direction. (Fig. 31)



Fig. 30

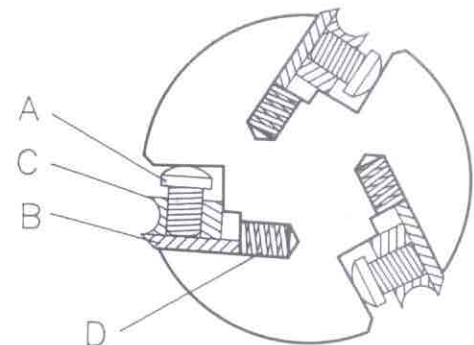


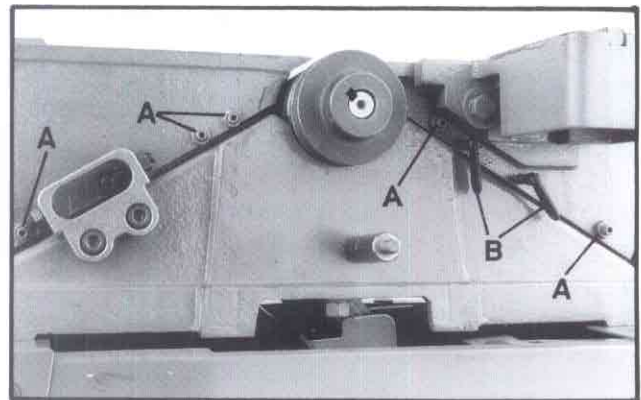
Fig. 31

6. Insert the springs, the lock bar and screws and tighten to hold in place. Blades are set at the proper height when the top of the blade is 1/16" above the cutterhead. Do not tighten firmly at this time.
7. Repeat for other two blades.
8. To set the knives to the outfeed table and to the same height in the cutterhead, see section titled " Setting Outfeed Table to Cutterhead Knives" found on page 13 of this manual.

### Gib Adjustment

After a period of use, the gibs may become loose and need adjusting:

1. Loosen lock nuts (A, Fig. 32) and table lock screws (B, Fig. 32) Note: infeed table has three gib adjustment screws - outfeed table has only two.
2. Tighten each set screw 1/4 turn starting at the bottom and working up. If a 1/4 turn does not remove all play, take another 1/4 turn. Repeat a 1/4 turn at a time for all three (or two) set screws until play is removed.
3. Tighten table lock screws (B, Fig. 32) and lock nuts (A, Fig. 32).



**Fig. 32**

### Lubrication

1. Use a good grade of light grease on the steel adjusting screws located in the raising and lowering mechanisms of the work tables.
2. Occasionally, apply a few drops of light machine oil to the gibs. This permits the tables to slide freely.
3. The cutterhead ball bearings are lifetime lubricated and need no further care.

## Blade Care

### WARNING!

**Blades are extremely sharp! Use caution when cleaning or changing. Failure to comply may cause serious injury!**

When gum and pitch collect on the blades, carefully remove with a strong solvent. Failure to remove gum and pitch build up may result in excessive friction and overheating.

When blades become dull, touch up blades. See "Sharpening the Knives".

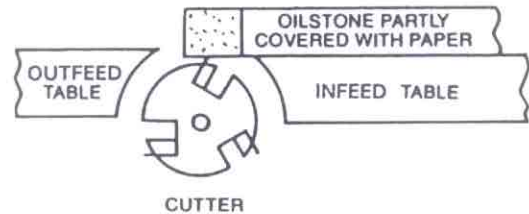
## Sharpening the Knives

### WARNING!

**Blades are extremely sharp! Use caution when handling. Failure to comply may cause serious injury!**

1. **Disconnect the machine from the power source.**
2. Remove the blade guard and belt cover.
3. To protect the infeed table from scratches, partially cover the sharpening stone with paper. (Fig. 33)
4. Lay the stone on the infeed table.
5. Lower the infeed table and turn the cutterhead by turning the cutterhead pulley. The infeed table height is set properly when the stone's surface is flush with the knife bevel.
6. Keep the cutterhead from rotating by grasping the cutterhead pulley while sliding the stone back and forth across the table.
7. Take the same amount of passes for all three blades.

When the blades have been sharpened and still are not cutting efficiently, trying to touch up the blades further will only cause the formation of a second beveled edge. When this starts to happen, it is time



**Fig. 33**

to replace blades with another set. It is recommended to keep a second set of blades on hand so that they may be installed while the first set is being professionally sharpened.

## Cutterhead Removal

**⚠ WARNING!**

**Blades in the cutterhead are sharp! Use extreme caution when handling the removal of the cutterhead. Failure to comply may cause serious injury!**

The entire cutterhead assembly may be removed for cleaning or for bearing and blade replacement. Some woodworkers keep a spare cutterhead with replacement blades should the original cutterhead have to be repaired.

To remove the cutterhead (including bearings and housings) from the base casting:

1. **Disconnect the machine from the power source.**
2. Remove the fence assembly, front blade guard, and belt guard.
3. Remove the V-belt from the cutterhead pulley.
4. Separate the bed assembly from the stand assembly.
5. Loosen set screw using a hex socket wrench and remove the cutterhead pulley and key.
6. Loosen bolts (A, Fig. 34) and lock washers.
7. Lift assembly straight up.
8. Before replacing the cutterhead back into the casting, thoroughly clean the "saddle" and the bearing housings of saw dust and grease so that they seat properly.
9. To re-install the cutterhead, reverse the above steps.



**Fig. 34**

## Push Sticks and Push Blocks

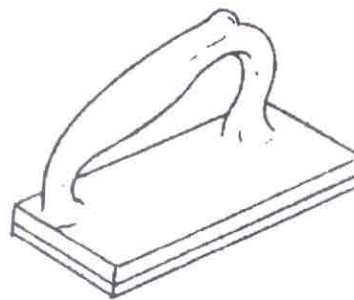
It is highly recommended to use push sticks or push blocks whenever possible. These will aid the operator especially when planing or jointing thin or short work. Always use push blocks for planing operations.

A simple, yet effective push stick (Fig. 35) may be fashioned from scrap wood. The lip at the rear catches the trail edge of the workpiece while the hand on top applies pressure down and forward.



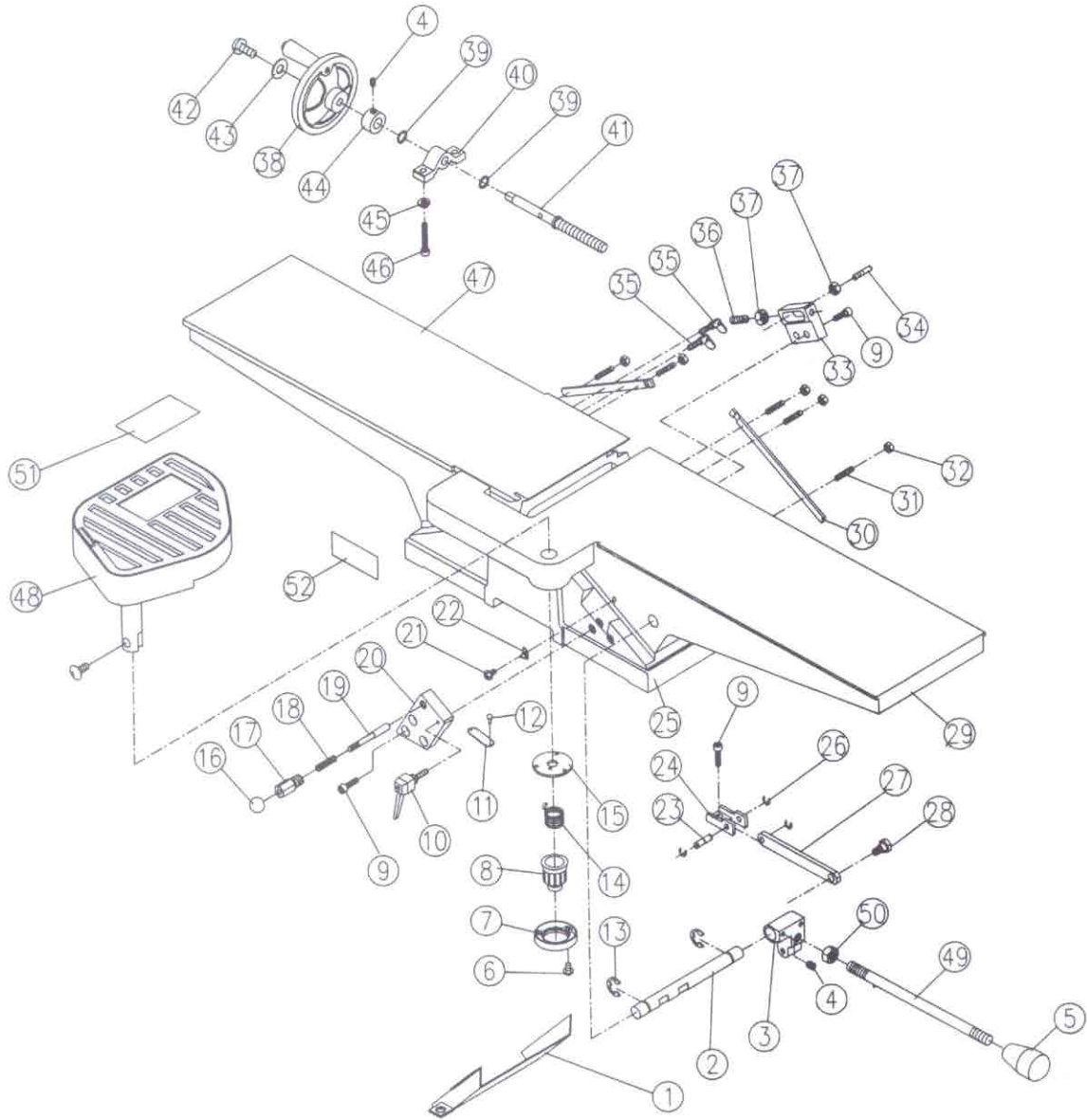
**FIG - 35**

Two push blocks (Fig. 36) come with the jointer. They have convenient handles and are rubber backed for superior holding ability. Purchase more JET push blocks (stock # 708815) from your local JET Equipment and Tools distributor or directly from JET. Call 1-800-274-6848 to order.



**FIG - 36**

# Bed Assembly



## Parts List for the JJ-60S Jointer

### Bed Assembly

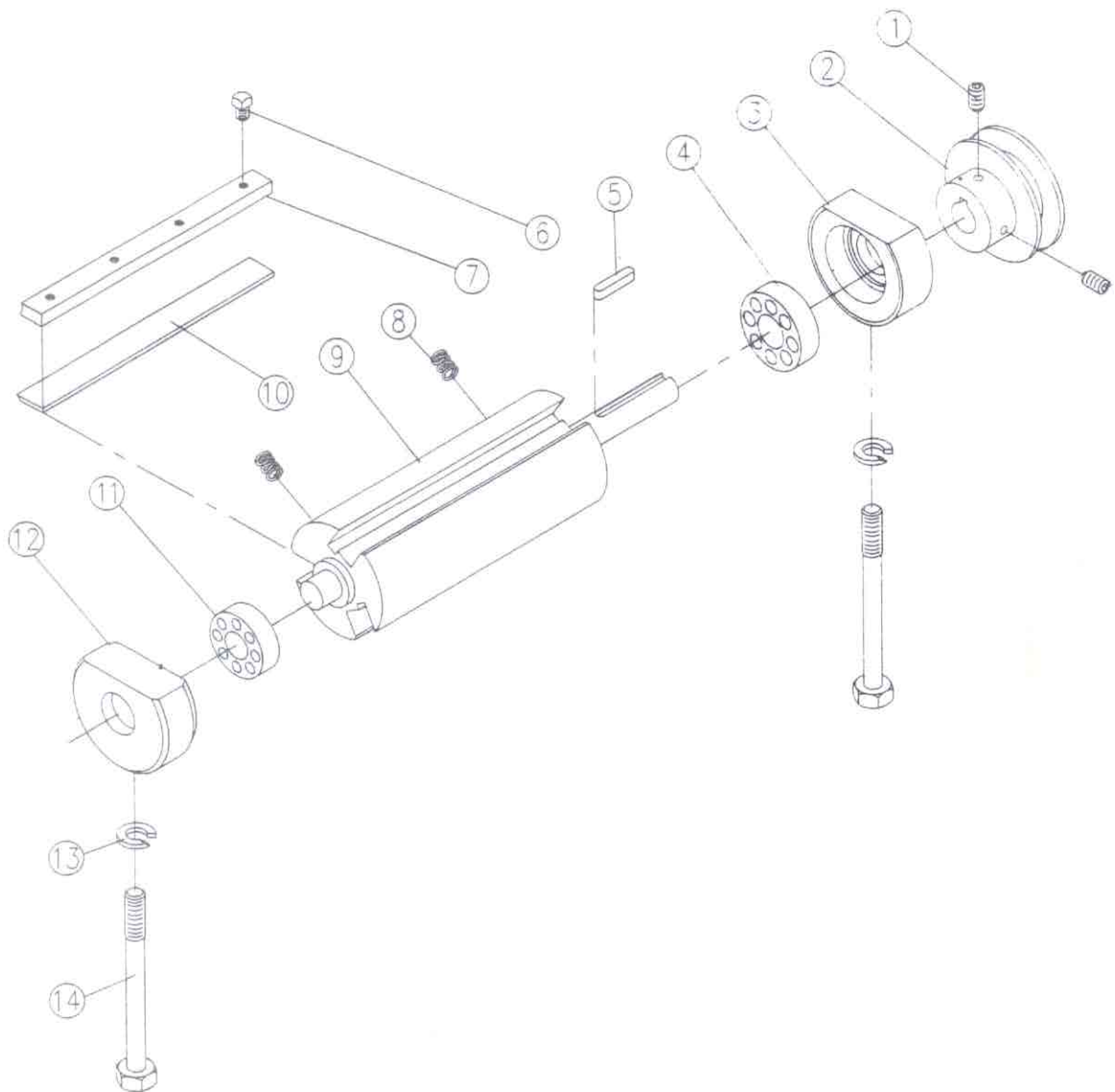
Index No.	Part No.	Description	Size	Qty.
1	JEI-B16	Dust Guard Plate		1
2	JEI-B15	Rod		1
3	JEI-B14	Block		1
4	TS-0267021	Set Screw	1/4-5/16	3
5	JEI-B13	Knob		1
6	5C-D006	Round Head Screw	5/32 x 5/8	3
7	JH-T27	Retainer		1
8	JH-T26	Knob		1
9	TS-0208041	Hex Socket Cap Screw	5/16 x 3/4	6
10	5CO-D09B	Lock Handle		1
11	JJ6-19	Label		1
12	5F-H051	Rivet	2 x 5	2
13	5FC-A13	C-Ring		2
14	JH-T25	Spring		1
15	JH-T24	Plate		1
16	5DF-B05	Knob		1
17	JEA-B09	Stud		1
18	JEA-B08	Spring		1
19	JEA-B07	Stud		1
20	JEI-B05	Block		1
21	5CD-B02A	Round Head Screw	5/32 x 1/4	1
22	JEI-B04	Pointer		1
23	JEI-B07	Stud		1
24	JEI-B08	Plate		1
25	JEX-B01	Base		1
26	5FC-A08	E-Clip		3
27	JEI-B09	Bar		1
28	JEI-B10	Hex Cap Bolt		1
29	JEI-B11B	Infeed Table		1
30	JJ-T04	Gib		2
31	TS-0267091	Set Screw	1/4-20 x 1	5
32	TS-0561011	Hex Nut	1/4-20	5
33	JEI-B02	Block		1
34	JEI-B01	Stud		1
35	JH-T30	Lock Screw		2
36	TS-0270071	Set Screw	5/16 x 3/4	2
37	TS-0561021	Hex Nut	5/16	3
38	JEX-X18	Handwheel		1
39	JEA-B26	Washer		2
40	JEA-B27	Block		3
41	JEA-B25	Leadscrew		1
42	TS-081B05	Pan Head Screw *	1/4-20 x 1/2	1
43	TS-0680021	Washer *	1/4	1
44	JEA-B28	Bushing		1
45	TS-0720081	Washer	5/16	2
46	5CB-F15A	Screw	1/4 x 5/16	2
47	JEA-B04	Outfeed Table		1



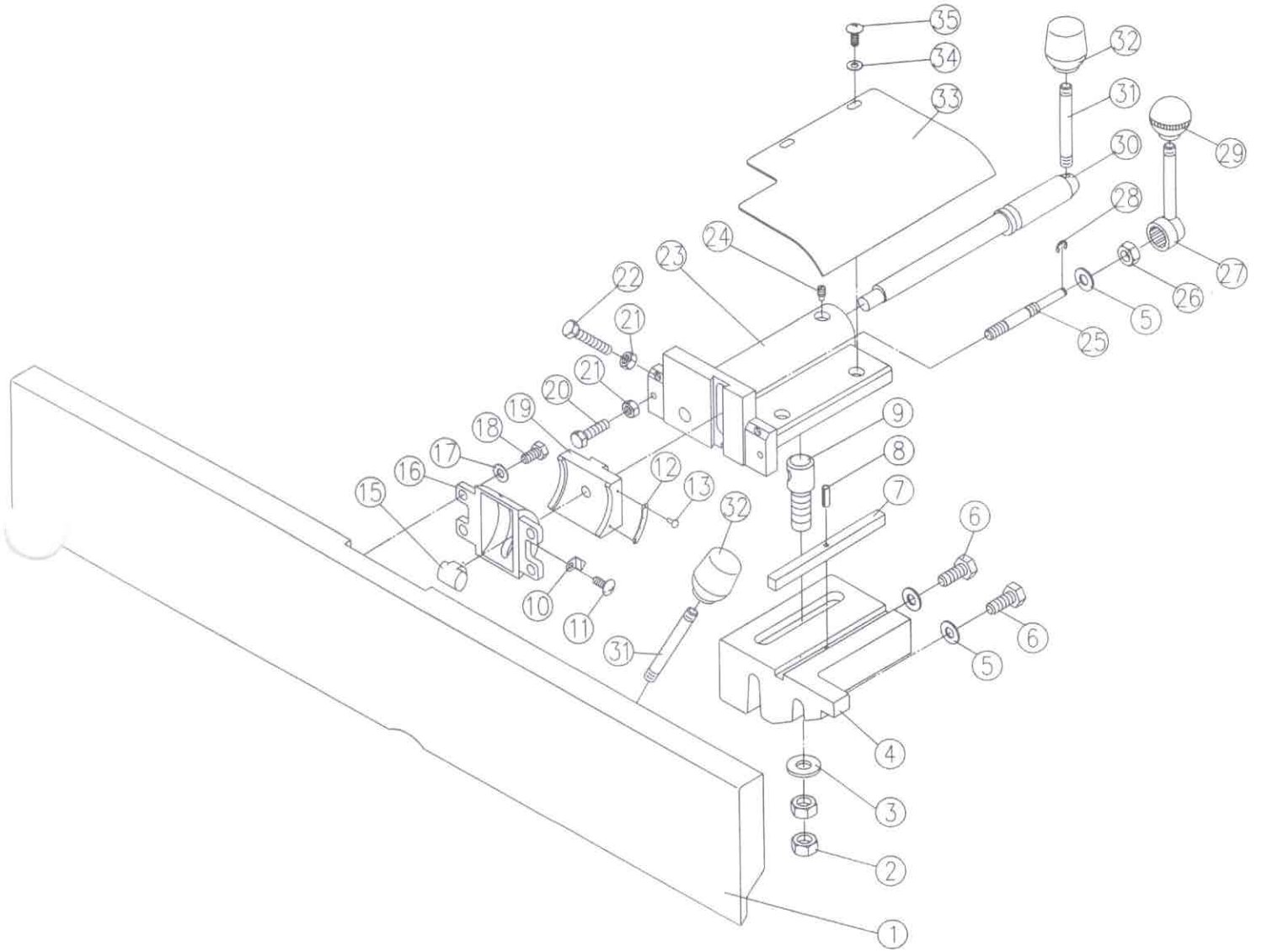
48	JH-T22	Cutterhead Guard	1
49	JEI-B12	Handle	1
50	TS-0561051	Hex Nut	1/2 1
51	JJ6-01CS	Warning Label	1
52	JJ6-02OS	Nameplate	1

## Cutterhead Assembly

/	JEX-C	Cutterhead Assembly CP	1
1	TS-0267041	Set Screw 1/4 x 3/8	2
2	JH-C07	Pulley	1
3	JH-C04	Bearing Housing	1
4	BB-6203ZZ	Ball Bearing	1
5	5F-G108	Key 5 x 5 x 25	1
6	JC-C06	Lock Screw	12
7	JI-C02	Lock Bar	3
8	PA-C05	Spring	6
9	JEX-C01	Cutterhead	1
10	708801	Knife	3
11	BB-6202ZZ	Ball Bearing	1
12	3H-C02	Bearing Casing	1
13	TS-0720091	Lock Washer 3/8	2
14	JEA-B01	Bolt	2



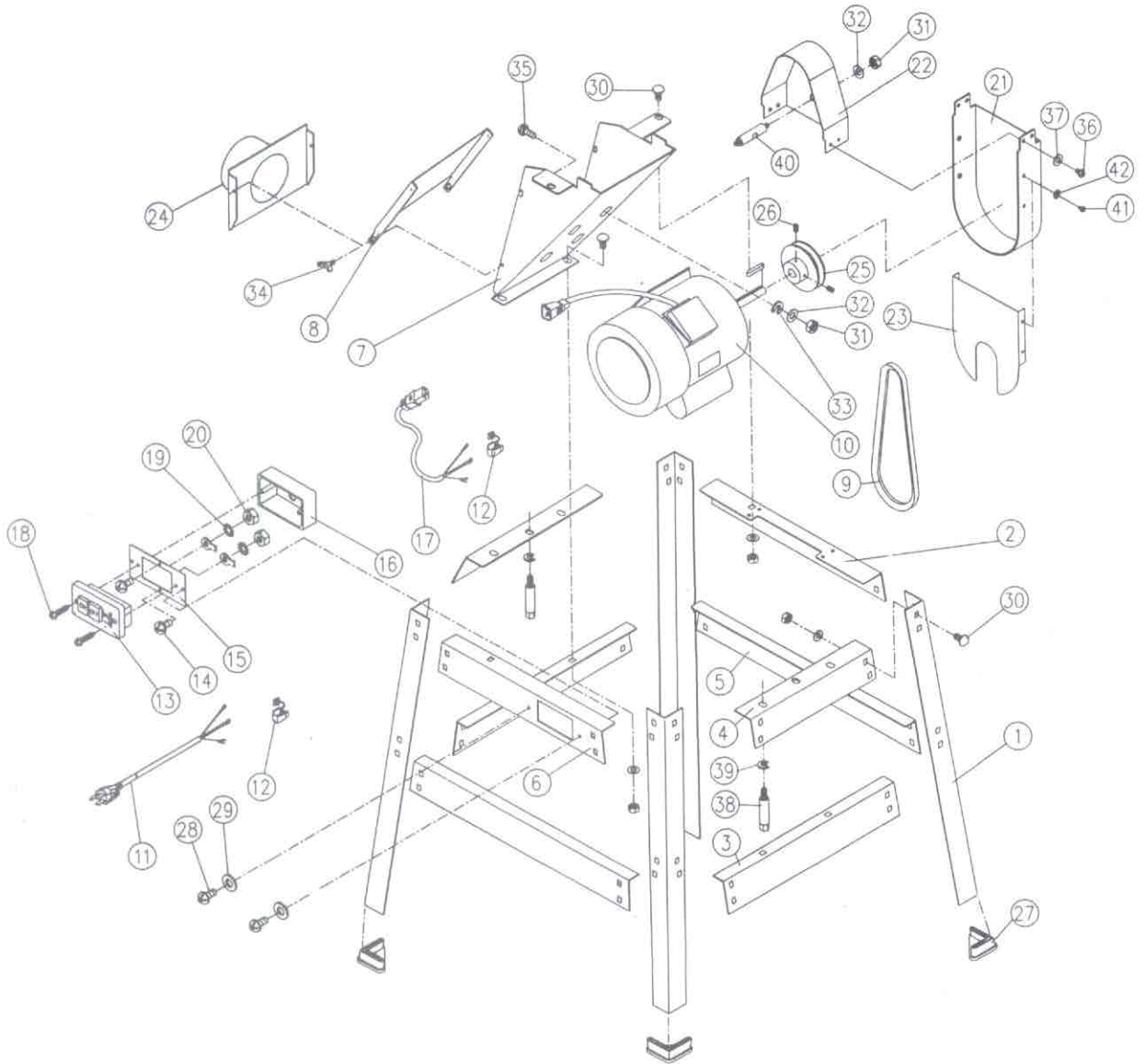
# Fence Assembly



## Fence Assembly

.....	JEB-F	Fence Assembly CP (#1-35)		1
1	.....	JI-F01	Fence	1
2	.....	TS-0561052	Hex Nut	1/2-20 NF
3	.....	TS-0680061	Flat Washer	1/2
4	.....	JI-F02	Table Block	1
5	.....	TS-0680041	Washer	3/8
6	.....	TS-0060051	Hex Cap Bolt	3/8 x 1-1/4
7	.....	JI-F03	Key	1
8	.....	5F-E153	Pin	4 x 20
9	.....	JI-F16	Shaft Toggle	1
10	.....	JI-F11	Pointer	1
11	.....	TS-081902	Screw	1
12	.....	JI-F12	Angle Indicator	1
13	.....	5FJ-F05	Rivet	2
15	.....	JI-F04	Pivot Nut	1
16	.....	JI-F05	Angle Bracket	1
17	.....	TS-0680031	Washer	5/16
18	.....	TS-0081031	Hex Cap Bolt	5/16 x 3/4
19	.....	JI-F06	Fence Slide	1
20	.....	TS-0051061	Hex Cap Bolt	5/16 x 1-1/4
21	.....	TS-0561021	Hex Nut	5/16
22	.....	TS-0081081	Hex Cap Screw	1/4 x 1-3/4
23	.....	JI-F13	Slide Block	1
24	.....	JI-F15	Screw	1
25	.....	JI-F07	Stud	1
26	.....	5DA-D09	Hex Nut	1
27	.....	JEB-F08	Lock Handle	1
28	.....	5FC-A08	E-Clip	1
29	.....	JI-F10	Knob	1
30	.....	JI-F14	Shaft	1
31	.....	JEB-F09	Handle	2
32	.....	5DF-I09	Knob	2
33	.....	JI-F17	Pulley Guard	1
34	.....	TS-0680021	Washer *	1/4
35	.....	TS-081B05	Round Head Screw *	1/4 x 1/2

# Stand and Motor Assembly



## Stand and Motor Assembly

1	JEI-S09	Stand Leg		4
2	JEI-S08	Stand Top (rear)		1
3	JEI-S11	Cross Brace (left and tight)		2
4	JEI-S10	Stand Top (left and right)		2
5	JEI-S13	Cross Brace (front and rear)		2
6	JEX-S04	Stand Top (front)		1
7	JEI-S05	Dust Chute		1
8	JEI-S03	Dust Chute Plate		1
9	VB-A32	V-Belt		1
10	JEX-X09	Motor		1
	JI-X04-A	Centrifugal Switch (not shown)		1
	JI-X04-B	Capacitor (not shown)		1
	JI-X04-C	Capacitor Cover (not shown)		1
	JI-X04-D	Junction Box (not shown)		1
	JI-X04-E	Junction Box Cover (not shown)		1
10A	JEX-S01	Motor Cord		1
11	JEX-S03	Power Cord		1
12	5MA-I04	Stain Relief		2
13	MHA-S07A	Switch		1
	MHA-S07A-1	Switch Assy. CP (inc.#11-20)		1
14	5C-D010	Screw		2
15	JEY-S07	Switch Plate		1
16	MHA-S27	Switch Box		1
17	JEX-S02A	Switch Cord		1
18	5AL-C10B	Screw		2
19	TS-1550011	Washer	M3	2
20	TS-1540011	Hex Nut	M3	2
21	JEI-S07	Lower Belt Guard		1
22	JEX-S05	Upper Belt Guard		1
23	JEX-S07	Cover		1
24	JEI-S02	Dust Hose Adapter		1
25	JH-M10	Motor Pulley *		1
26	TS-0267021	Set Screw *	1/4 x 3/8	2
27	JEI-S14A	Rubber Foot *		4
28	5CD-C06B	Screw *		2
29	5EB-A04	Washer *		2
30	5CK-F06B	Carriage Bolt *	5/16 x 1/2	36
31	TS-0561021	Hex Nut *	5/16	41
32	TS-0680031	Washer *	5/16	41
33	TS-0720081	Lock Washer *	5/16	4
34	5AF-D06B	Wing Nut *		2
35	5CK-F08B	Carriage Bolt *	5/16 x 3/4	4
36	5CD-D04B	Screw *	1/4 x 3/8	4
37	TS-0680021	Washer *	1/4	4
38	JC-M07	Lock Bolt *		3
39	TS-0720091	Lock Washer *	3/8	3
40	PJC-C05	Stud *		1
41	5CD-B02B	Pan Head Screw *	5/32 x 1/4	4
42	5EB-A01	Pan Head Screw *	M4	4
	JJ6OS-HK	Hardware Kit (not shown)		1

\* included in JJ6OS-HK Hardware Kit

# Electrical Schematic

