

6" Professional Jointer

(Model 37-195)

(Model 37-275X)

INSTRUCTION MANUAL



PART NO. 909995 - 01-22-03
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visit our website at: www.deltamachinery.com.

For Parts, Service, Warranty or other Assistance,

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SAFETY GUIDELINES / DEFINITIONS

This manual contains information that is important for you to know and understand. This information relates to protecting YOUR SAFETY and PREVENTING EQUIPMENT PROBLEMS. To help you recognize this information, we use the symbols to the right. Please read the manual and pay attention to these sections.

▲ 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 which, if not avoided, may result in minor or moderate injury

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

▲ WARNING **SOME DUST CREATED BY POWER SANDING, SAWING, GRINDING, DRILLING, AND OTHER CONSTRUCTION ACTIVITIES** contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead-based paints,
- crystalline silica from bricks and cement and other masonry products, and
- arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

GENERAL SAFETY RULES

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it. Figure out an alternative procedure that feels safer. **REMEMBER:** Your personal safety is your responsibility.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, **DO NOT** use the machine until you have first contacted Delta to determine if it can or should be performed on the product.

Technical Service Manager
Delta Machinery
4825 Highway 45 North
Jackson, TN 38305
(IN CANADA: 505 SOUTHGATE DRIVE, GUELPH, ONTARIO N1H 6M7)

▲ WARNING Read Operator's Manual. Do not operate equipment until you have read Operator's Manual for **Safety, Assembly, Operation, and Maintenance Instructions.**

▲ WARNING **FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.

2. **KEEP GUARDS IN PLACE** and in working order.

3. **ALWAYS WEAR EYE PROTECTION.** Wear safety glasses. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty. These safety glasses must conform to ANSI Z87.1 requirements. **NOTE:** Approved glasses have Z87 printed or stamped on them.

4. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on".

5. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.

6. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.

7. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.

8. **MAKE WORKSHOP CHILDPROOF** – with padlocks, master switches, or by removing starter keys.

9. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.

10. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.

11. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DON'T OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.

16. **USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by Delta may cause hazards or risk of injury to persons.

17. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord. In the event of a power failure, move switch to the "OFF" position.
18. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
19. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure 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.
20. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

21. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
22. **STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING A POWER TOOL. DO NOT USE 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.
23. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
24. **THE DUST GENERATED** by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR JOINTERS

⚠ WARNING FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY.

- WARNING:** Do not operate the jointer until it is completely assembled and installed according to the instructions.
- IF YOU ARE NOT** thoroughly familiar with the operation of jointers, obtain advice from your supervisor, instructor or other qualified person.
- KEEP** cutterhead sharp and free of all rust and pitch.
- BEFORE** starting machine, check cutterhead guard to make sure it is not damaged and operates freely.
- ALWAYS** make sure exposed cutterhead behind the fence is guarded, especially when jointing near the edge.
- NEVER** perform jointing or surfacing operations with the cutterhead guard removed.
- MAKE CERTAIN** the infeed and outfeed tables are tightened before starting the machine.
- NEVER** start the jointer with the workpiece contacting the cutterhead.
- ALWAYS** hold the workpiece firmly against the tables and fence.
- NEVER** perform any operation "Free-hand" which means using your hands to support or guide the workpiece. **ALWAYS** use the fence to position and guide the work.
- AVOID** awkward operations and hand positions where a sudden slip could cause your hand to move into the cutterhead.
- ALWAYS** use hold-down/push blocks for jointing material less than 3 inches in height or surfacing material thinner than 3 inches.
- DO NOT** perform jointing operations on material shorter than 10 inches, narrower than 3/4 inch or less than 1/2 inch thick.
- DO NOT** perform surfacing operations on material shorter than 10 inches, narrower than 3/4 inch, wider than 6 inches or less than 1/2 inch thick.
- NEVER** make jointing or surfacing cuts deeper than 1/8 inch. On cuts more than 1-1/2 inches wide, adjust depth of cut to 1/16 inch or less to avoid overloading machine and to minimize chance of kick-back (work thrown back toward you).
- MAINTAIN** the proper relationship of infeed and outfeed table surfaces and cutterhead knife path.
- SUPPORT** the workpiece adequately at all times during operation; maintain control of the work at all times.
- DO NOT** back the workpiece toward the infeed table.
- DO NOT** attempt to perform an abnormal or little-used operation without study and the use of adequate hold-down/push blocks, jigs, fixtures, stops, push blocks, etc.
- SHUT OFF** power before servicing or adjusting jointer.
- DISCONNECT** jointer from power source and clean the machine before leaving it.
- MAKE SURE** the work area is clean before leaving the machine.
- SHOULD** any part of your jointer be missing, damaged, or fail in any way, or any electrical component fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged or failed parts before resuming operation.
- THE USE** of attachments and accessories not recommended by Delta may result in the risk of injuries.
- ADDITIONAL INFORMATION** regarding the safe and proper operation of this product is available from the National Safety Council, 1121 Spring Lake Drive, Itasca, IL 60143-3201 in the Accident Prevention Manual for Industrial Operation and also in the Safety Data Sheets provided by the NSC. Please also refer to the American National Standard Institute ANSI O1.1 Safety Requirements for Woodworking Machinery and the U.S. Department of Labor OSHA 1910.213 Regulations.

**SAVE THESE INSTRUCTIONS.
Refer to them often
and use them to instruct others.**

POWER CONNECTIONS

A separate electrical circuit should be used for your machines. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and matching receptacle which will accept the machine's plug. Before connecting the machine to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine. All line connections should make good contact. Running on low voltage will damage the machine.

⚠ DANGER DO NOT EXPOSE THE MACHINE TO RAIN OR OPERATE THE MACHINE IN DAMP LOCATIONS.

MOTOR SPECIFICATIONS

Your machine is wired for 120 volt, 60 HZ alternating current. Before connecting the machine to the power source, make sure the switch is in the "OFF" position.

GROUNDING INSTRUCTIONS

⚠ DANGER THIS MACHINE MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

1. All grounded, cord-connected machines:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and matching 3-conductor receptacles that accept the machine's plug, as shown in Fig. A.

Repair or replace damaged or worn cord immediately.

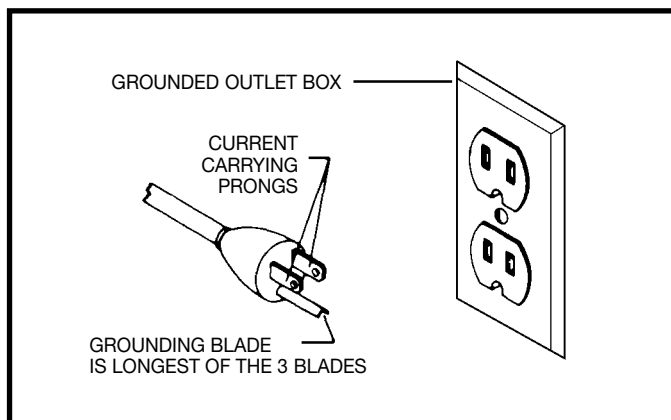


Fig. A

2. Grounded, cord-connected machines intended for use on a supply circuit having a nominal rating less than 150 volts:

If the machine is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. A, the machine will have a grounding plug that looks like the plug illustrated in Fig. A. A temporary adapter, which looks like the adapter illustrated in Fig. B, may be used to connect this plug to a matching 2-conductor receptacle as shown in Fig. B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box. Whenever the adapter is used, it must be held in place with a metal screw.

NOTE: In Canada, the use of a temporary adapter is not permitted by the Canadian Electric Code.

3. Grounded, cord-connected machines intended for use on a supply circuit having a nominal rating between 150 - 250 volts, inclusive:

If the machine is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. C, the machine will have a grounding plug that looks like the plug illustrated in Fig. C. Make sure the machine is connected to an outlet having the same configuration as

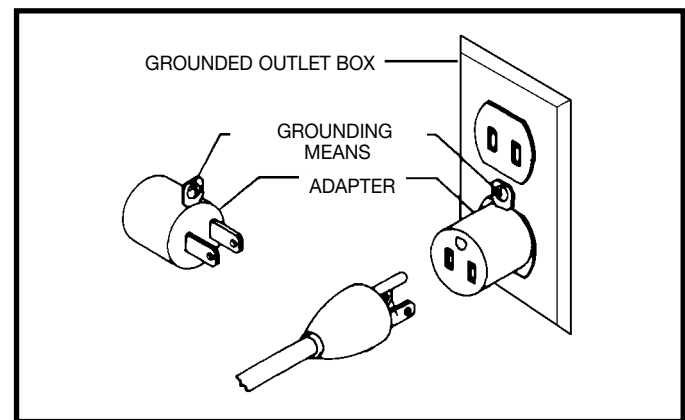


Fig. B

the plug. No adapter is available or should be used with this machine. If the machine must be re-connected for use on a different type of electric circuit, the re-connection should be made by qualified service personnel; and after re-connection, the machine should comply with all local codes and ordinances.

⚠ DANGER IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE HAVE A QUALIFIED ELECTRICIAN CHECK THE RECEPTACLE.

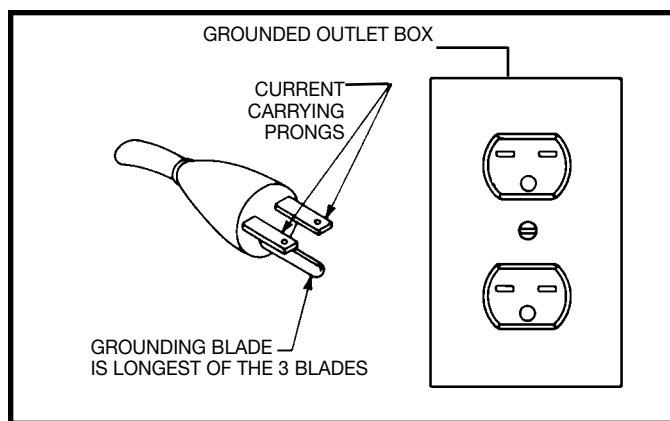


Fig. C

EXTENSION CORDS

CAUTION Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and matching receptacle which will accept the machine's plug. When using an extension cord, be sure to use one heavy enough to carry the current of the machine. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Fig. D, shows the correct gauge to use depending on the cord length. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

MINIMUM GAUGE EXTENSION CORD			
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES			
Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	120	up to 25	18 AWG
0-6	120	25-50	16 AWG
0-6	120	50-100	16 AWG
0-6	120	100-150	14 AWG
6-10	120	up to 25	18 AWG
6-10	120	25-50	16 AWG
6-10	120	50-100	14 AWG
6-10	120	100-150	12 AWG
10-12	120	up to 25	16 AWG
10-12	120	25-50	16 AWG
10-12	120	50-100	14 AWG
10-12	120	100-150	12 AWG
12-16	120	up to 25	14 AWG
12-16	120	25-50	12 AWG
12-16	120	GREATER THAN 50 FEET NOT RECOMMENDED	

Fig. D

MINIMUM GAUGE EXTENSION CORD			
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES			
Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	240	up to 50	18 AWG
0-6	240	50-100	16 AWG
0-6	240	100-200	16 AWG
0-6	240	200-300	14 AWG
6-10	240	up to 50	18 AWG
6-10	240	50-100	16 AWG
6-10	240	100-200	14 AWG
6-10	240	200-300	12 AWG
10-12	240	up to 50	16 AWG
10-12	240	50-100	16 AWG
10-12	240	100-200	14 AWG
10-12	240	200-300	12 AWG
12-16	240	up to 50	14 AWG
12-16	240	50-100	12 AWG
12-16	240	GREATER THAN 100 FEET NOT RECOMMENDED	

Fig. D

OPERATING INSTRUCTIONS

FOREWORD

Delta Model 37-195 is a 6" Professional Jointer with a cutting capacity of 6-1/8" (156mm) width, 1/8" depth (3mm max.) and 1/2" (13mm) rabbeting. Unit includes; heavy-duty 1 hp, 120/240 volt induction motor, stand, dust chute, fence, three-knife cutterhead, cutterhead guard, and push blocks.

UNPACKING AND CLEANING

Carefully unpack the machine and all loose items from the shipping container(s). Remove the protective coating from all unpainted surfaces. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the unpainted surfaces with a good quality household floor paste wax.

NOTICE: THE MANUAL COVER PHOTO ILLUSTRATES THE CURRENT PRODUCTION MODEL. ALL OTHER ILLUSTRATIONS ARE REPRESENTATIVE ONLY AND MAY NOT DEPICT THE ACTUAL COLOR, LABELING OR ACCESSORIES AND MAY BE INTENDED TO ILLUSTRATE TECHNIQUE ONLY.

JOINTER PARTS

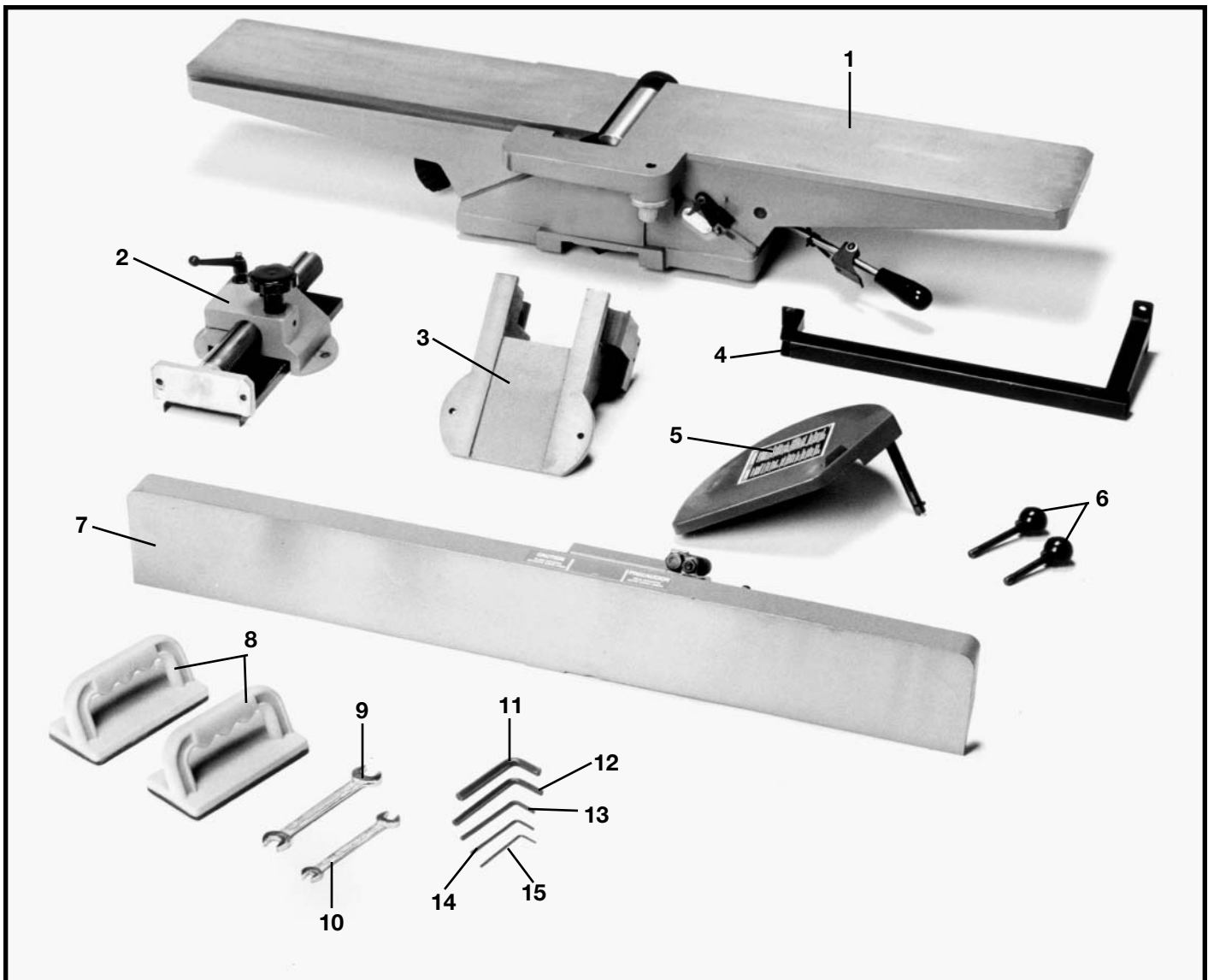


Fig. 4

1. Jointer
2. Fence Carriage Assembly
3. Cutterhead Pulley Guard/Carriage Mounting Bracket
4. Switch Mounting Bracket
5. Cutterhead Guard
6. Fence Tilting Handles (2)
7. Fence
8. Push Blocks (2)
9. 12-14mm Open End Wrench
10. 8-10mm Open End Wrench
11. 8mm Hex Wrench
12. 6mm Hex Wrench
13. 4mm Hex Wrench
14. 3mm Hex Wrench
15. 2.5mm Hex Wrench

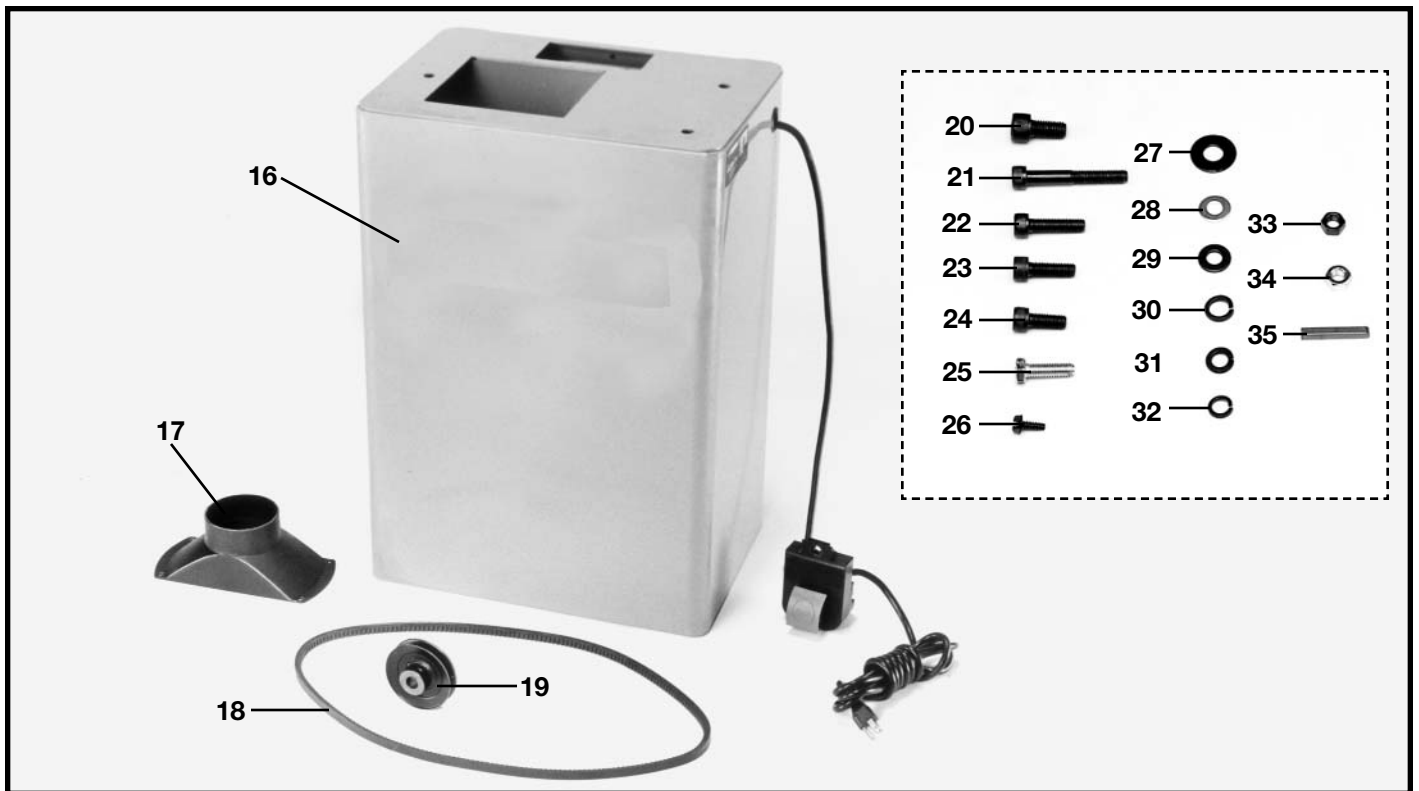


Fig. 5

- | | |
|--|---------------------------------------|
| 16. Stand with Pre-Wired Switch | 26. #10-16x1/2" Sheet Metal Screw (4) |
| 17. Dust Chute | 27. M10 Flat Washer (3) |
| 18. V-Belt | 28. 11/32" Flat Washer (1) |
| 19. Pulley | 29. M8 Flat Washer (10) |
| 20. M10x1.5x20mm Hex Socket Head Screw (3) | 30. M10.2 Lockwasher (3) |
| 21. M8x1.25x55mm Hex Socket Head Screw (4) | 31. M8.1 Lockwasher (10) |
| 22. M8x1.25x30mm Hex Socket Head Screw (2) | 32. 5/16" Lockwasher (1) |
| 23. M8x1.25x25mm Hex Socket Head Screw (2) | 33. M8x1.25 Hex Nut (2) |
| 24. M8x1.25x20mm Hex Socket Head Screw (2) | 34. 5/16-18 Hex Nut (1) |
| 25. 5/16-18x1" Hex Head Screw (1) | 35. Key |

ASSEMBLY

⚠ WARNING FOR YOUR OWN SAFETY, DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL THE MACHINE IS COMPLETELY ASSEMBLED AND YOU READ AND UNDERSTAND THE ENTIRE INSTRUCTION MANUAL.

STAND AND ELECTRICALS

Your Jointer stand (A) Fig. 6, is shipped with the motor and switch completely wired, and the motor mounted.

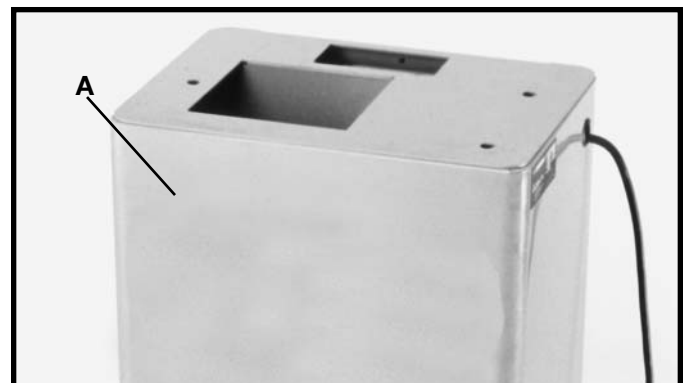


Fig. 6

ASSEMBLING JOINTER TO STAND

1. The outfeed end (N) Fig. 9, of the jointer must be pointing toward the end of the stand with dust chute opening (B) Fig. 7.

2. Remove three screws (C) Fig. 7, and loosen two screws (D). Then remove back panel (E) from stand by lifting upward.

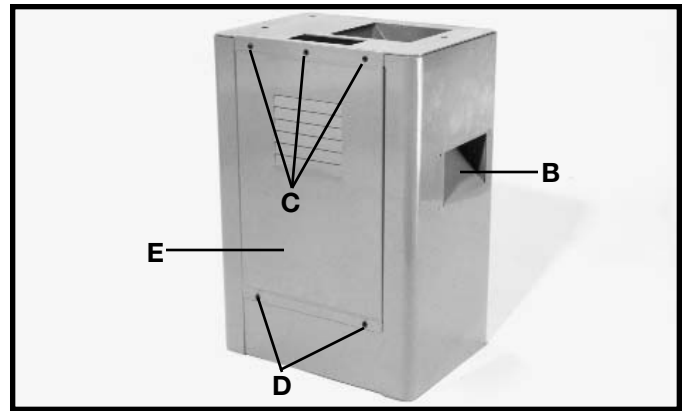


Fig. 7

3. Line up the three holes (F) Fig. 8, on the top of stand with the three threaded holes on the bottom of the jointer base. Using the supplied 8mm hex wrench (G) Fig. 9, fasten the jointer to the stand. Place a M10.2 lockwasher (I), on a M10x1.5x20mm hex socket head screw (H), and a M10 flat washer onto the screw. Insert the screw through the hole in the stand and thread the screw into the tapped hole in the bottom of the jointer, and tighten securely. Repeat this process for the two remaining holes in the stand and the jointer. **NOTE:** The mounting hole located on the dust chute end of the stand is accessed by reaching up through the dust chute.

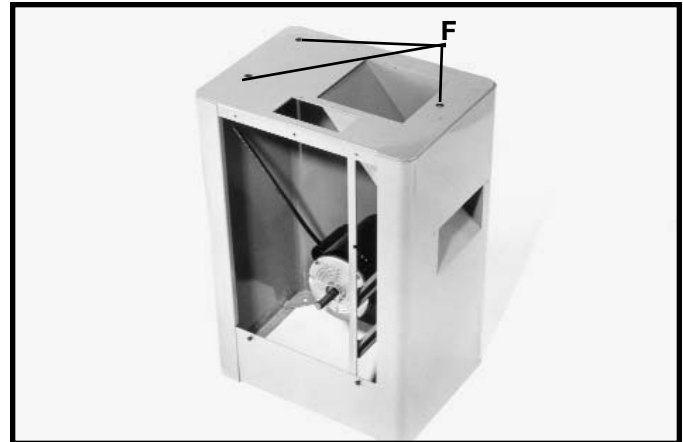


Fig. 8

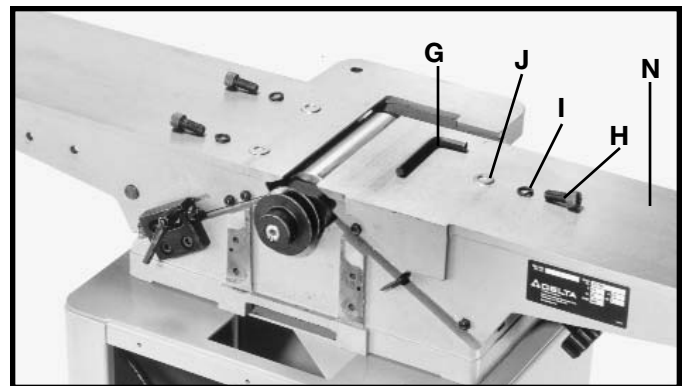


Fig. 9

ASSEMBLING MOTOR PULLEY

Assemble motor pulley (K) Fig. 10, to motor shaft with the hub of the pulley in the outer position as shown. Make certain key (L) is inserted in the keyway of the pulley and motor shaft, then tighten set screw (M) using the 2.5mm hex wrench (not shown).

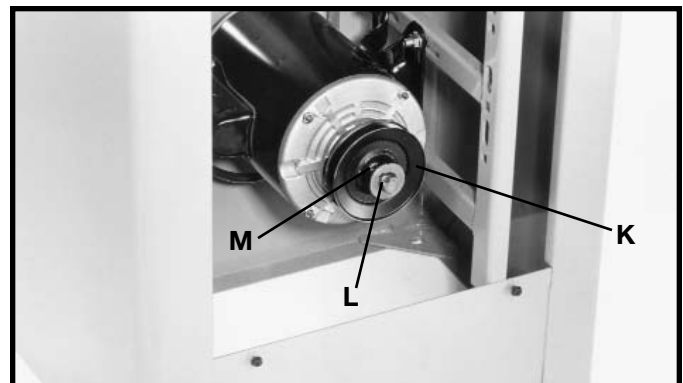


Fig. 10

ASSEMBLING BELT AND ALIGNING PULLEYS

1. Place belt (A) Fig. 11, in groove of cutterhead pulley (B) and motor pulley (C).
2. Make certain the motor pulley (C) Figs. 11 and 12, is properly aligned with cutterhead pulley (B) by placing a straight edge (D) Fig. 12, onto the face of each pulley as shown.
3. If an adjustment is needed, the motor pulley can be moved in or out on the motor shaft, or the motor can be shifted by loosening motor mounting screws, two of which are shown at (E) Fig. 11. After adjustments are made, tighten motor mounting hardware and motor pulley set screw.

ADJUSTING BELT TENSION

1. Correct belt tension is obtained when there is approximately 1" deflection at the center span of the belt using light finger pressure.
2. If an adjustment is required, the motor can be raised or lowered to obtain the correct belt tension.
3. Tighten motor mounting hardware after tension is applied, making sure alignment of the pulleys is not disturbed.
4. Re-attach back panel of stand which was removed in **STEP 2** of "ASSEMBLING JOINTER TO STAND".

ASSEMBLING CUTTERHEAD PULLEY GUARD/CARRIAGE MOUNTING BRACKET

1. Position two alignment pins (A) Fig. 13, with two alignment holes (B) in jointer base.
2. Using the supplied 6mm hex wrench (E) Fig. 14, fasten bracket (C) onto jointer base (G). Place a M8.1 lockwasher then an M8 flat washer on an M8x1.25x55mm hex socket head screw. Insert the screw (D) Fig. 14, through the hole in bracket (C), and thread the screw into the jointer base (B) Fig. 13, and tighten securely. Repeat this process for the three remaining holes in the bracket and jointer.

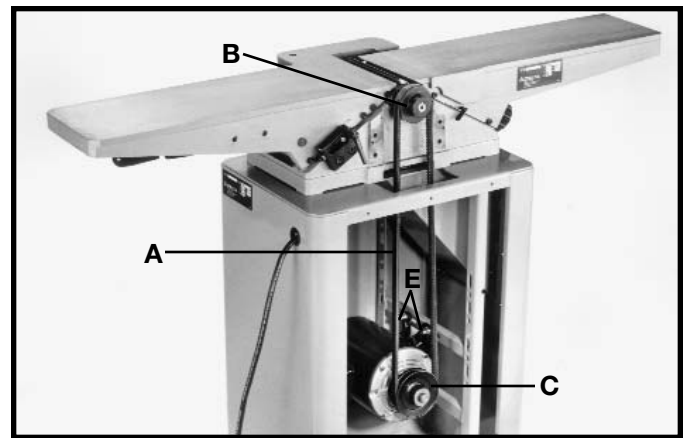


Fig. 11

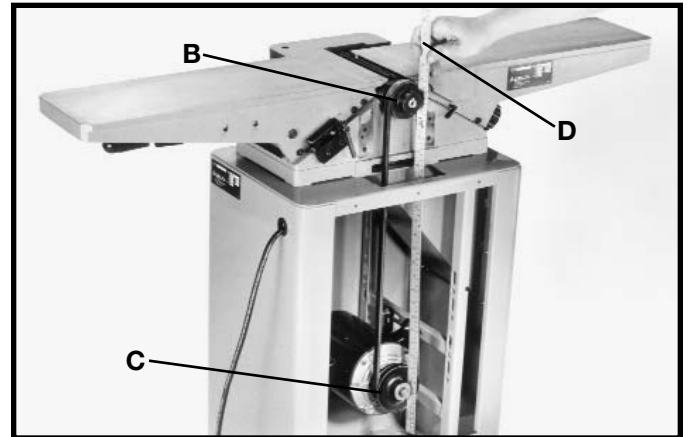


Fig. 12

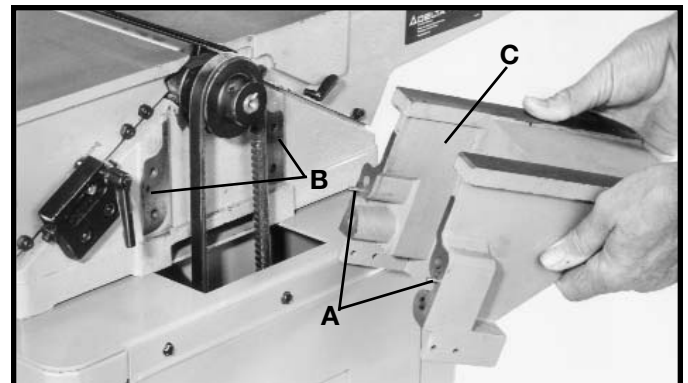


Fig. 13

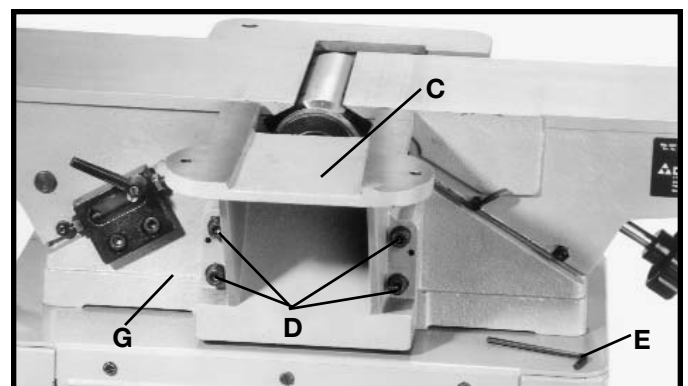


Fig. 14

ASSEMBLING FENCE CARRIAGE ASSEMBLY

1. Fasten fence carriage assembly (A) Fig. 15, to cutterhead pulley guard/carriage mounting bracket (C). Align the holes in the fence carriage assembly (A) one of which is shown at (D), with the holes in the pulley guard/carriage mounting bracket (C). Place a M8.1 lockwasher (E), then an M8 flat washer on an M8x1.25x20mm hex socket head screw (B). Insert the screw through the hole in the fence carriage assembly, and thread the screw into the tapped hole in the cutterhead pulley guard/carriage mounting bracket and tighten securely. Repeat this process for the remaining hole in the fence carriage assembly and the cutterhead pulley guard/carriage mounting bracket.

2. Fig. 16, illustrates fence carriage assembly properly mounted.

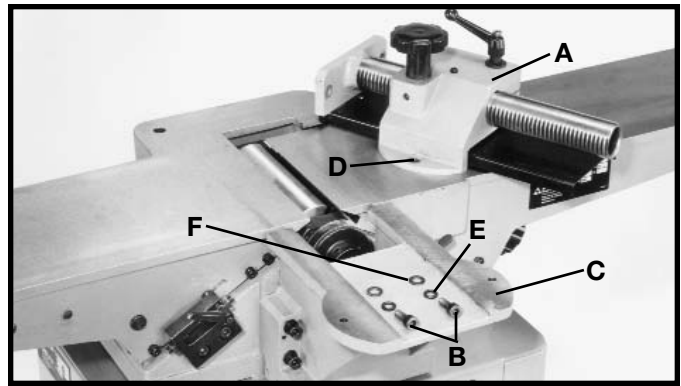


Fig. 15

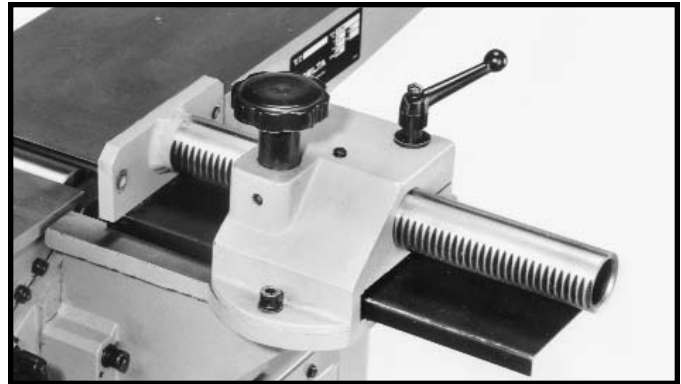


Fig. 16

ASSEMBLING FENCE

1. Fasten fence (A) Fig. 17, to fence carriage assembly (C) through holes (D). Align the two holes (G) in the fence with the two holes (D) in the carriage assembly (C). Place a M8.1 lockwasher (E), then an M8 flat washer (F), on an M8x1.25x25mm hex socket head screw (B). Insert the screw through hole (D) in the carriage assembly and thread the screw into the tapped hole (G) in the fence, and tighten securely. Repeat this process for the remaining hole in the fence and carriage assembly.

2. Fig. 18 illustrates fence properly mounted.

3. Thread shorter fence handle (E) Fig.19, into infeed end of fence (A) and longer fence handle (G) into outfeed end as shown.

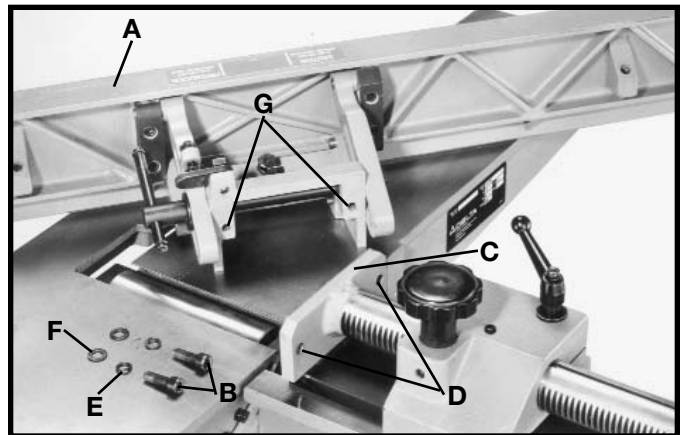


Fig. 17



Fig. 18

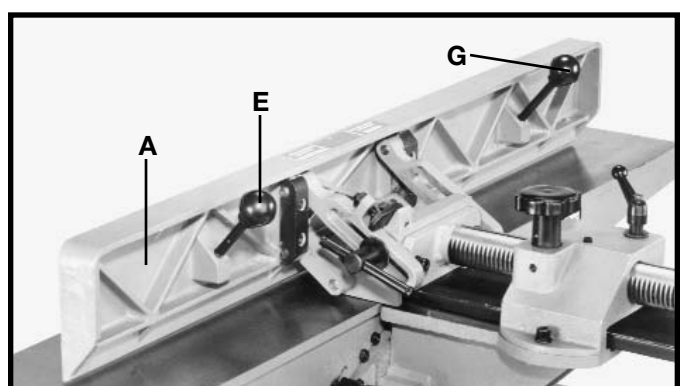


Fig. 19

ASSEMBLING CUTTERHEAD GUARD

1. Remove set screw (A) Fig. 20 from cutterhead guard post (F) with the 2.5mm hex wrench. Insert post (F) through hole in the infeed table. **NOTE:** A spring is supplied in knob assembly (E) that returns the guard (C) over the cutterhead after a cut has been made. Turn knob (E) counter-clockwise to provide tension on the spring before inserting post (F). Make certain the spring engages in the slot of the post. If spring tension is too tight or too loose, adjust the spring accordingly by removing the guard and rotating knob (E).

2. Thread set screw (A) Fig. 21 back into post (F) Fig. 20, to keep cutterhead guard (C) in position during jointer operation.

3. Fig. 21, illustrates the cutterhead guard (C) assembled to the infeed table.

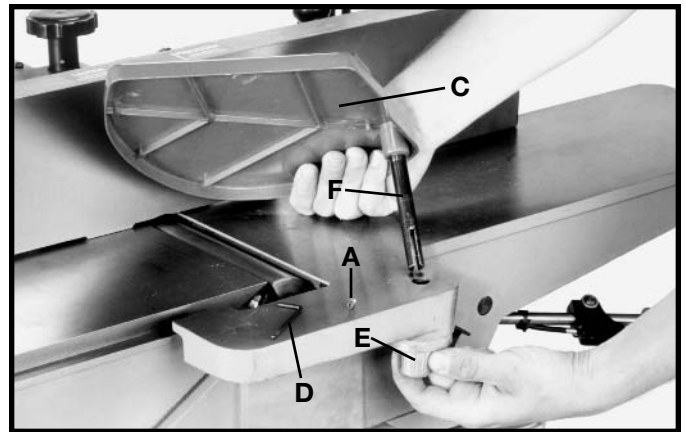


Fig. 20

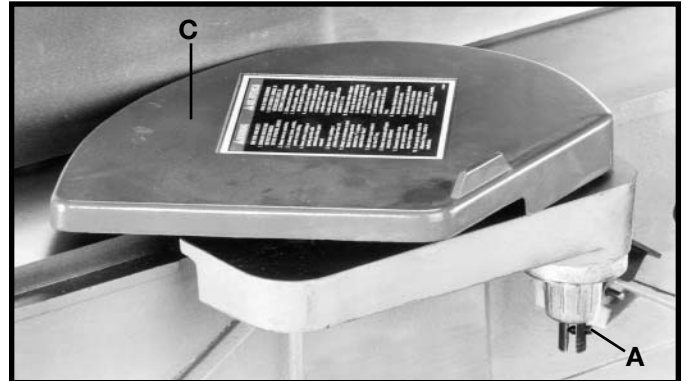


Fig. 21

ASSEMBLING SWITCH AND MOUNTING BRACKET

1. Align the two holes in the switch mounting bracket (A) Fig. 22, with the two holes (D) in the back of the infeed table (B). Place an M8 flat washer (E) Fig. 22, on an M8x1.25x30mm hex socket head screw (C). Insert the screw through the hole (D) Fig. 22, in the switch mounting bracket (A) and the hole in the back of the infeed table (B). Place a M8.1 lockwasher (F) Fig. 22, onto the screw (C). Thread a M8x1.25 hex nut (G) Fig. 22, onto the screw (C) and tighten securely. Repeat this process for the remaining hole in the switch mounting bracket and the infeed table.

2. Align the hole in the switch (E) Fig. 23, with the hole (G) in the mounting bracket. Place an 11/32" flat washer (I) Fig. 23, on a 5/16-18x1" hex head screw (H). Insert the screw through the hole in switch (E) and hole (G) in the mounting bracket. Place a 5/16" lockwasher (J) on screw (H). Thread a 5/16-18 hex nut (K) on the screw and tighten securely.

3. Fig. 24, illustrates the switch properly mounted.

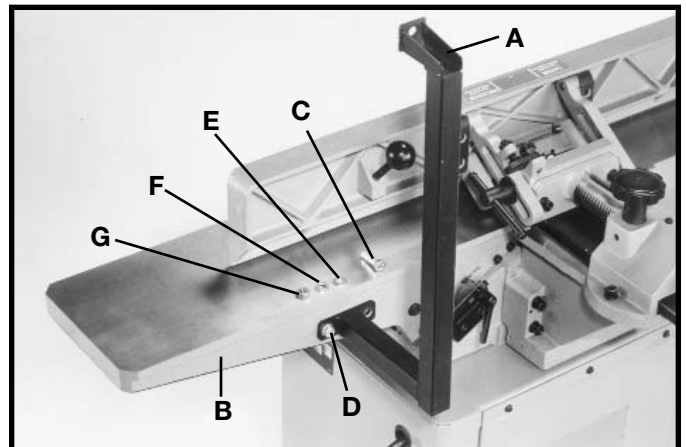


Fig. 22

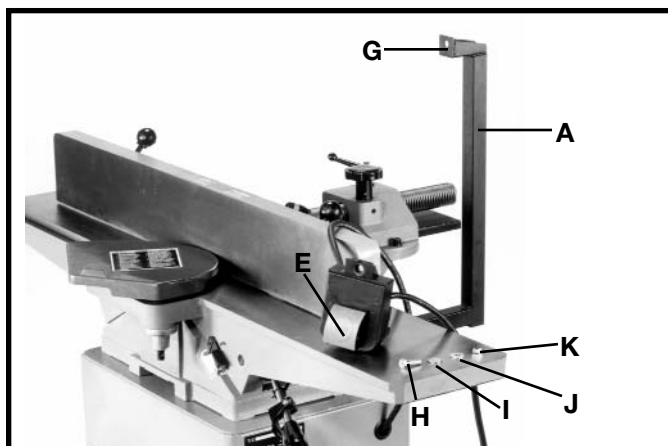


Fig. 23



Fig. 24

ASSEMBLING DUST CHUTE

The jointer stand has a built-in dust chute (A) Fig. 25. If this machine is to be used with a dust collection system, the supplied dust collector connector (B) Fig. 26, can be fastened to jointer stand (C) with four #10-16x1/2" sheet metal screws (D) as shown.

A standard 4" dust collection hose can be attached to dust collector connector.

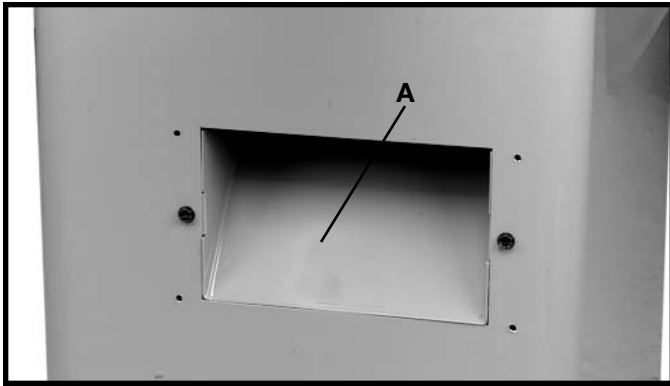


Fig. 25

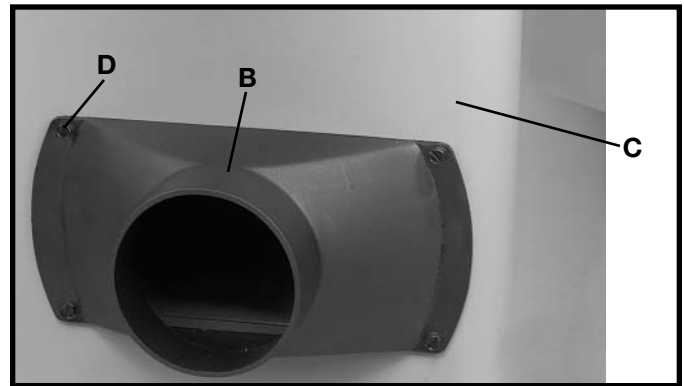


Fig. 26

OPERATING CONTROLS AND ADJUSTMENTS

STARTING AND STOPPING JOINTER

1. The on/off switch is located underneath the switch shield (B) Fig. 31. To start the jointer, move switch (A) up to the "ON" position.
2. To turn the jointer "OFF", push down on switch shield (B) Fig. 32, as shown.

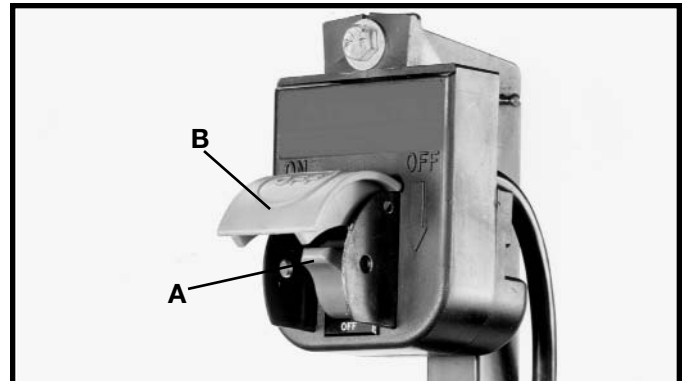


Fig. 31

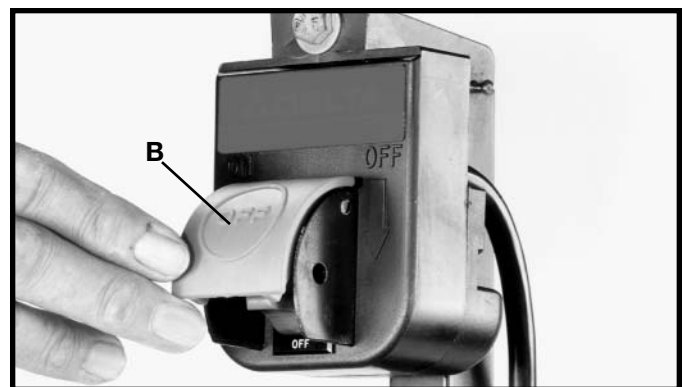


Fig. 32

LOCKING SWITCH IN THE “OFF” POSITION

IMPORTANT: When the tool is not in use, the switch should be locked in the “OFF” position to prevent unauthorized use. Insert the shank of padlock (C) Fig. 33, through the holes in the switch plate to lock the on/off switch trigger (A).

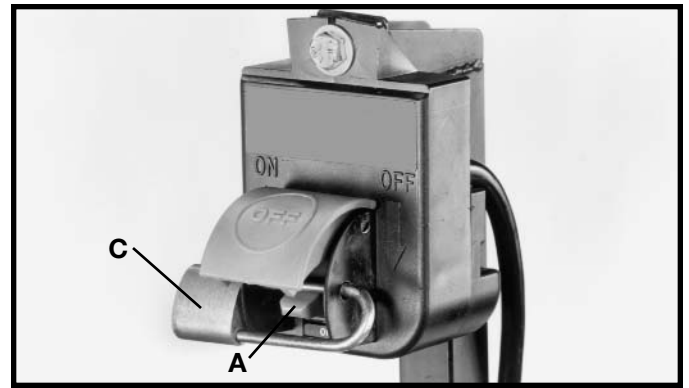


Fig. 33

INFEED TABLE ADJUSTMENTS

1. To raise or lower the infeed table, loosen table lock handle (A) Fig. 34, located on the rear side of infeed table.

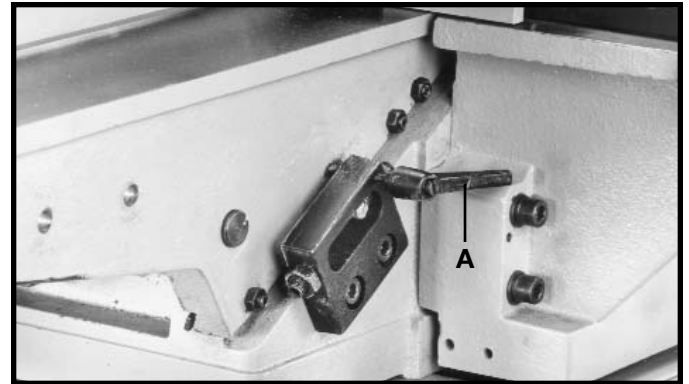


Fig. 34

2. Grasp the infeed table raising/lowering handle (B) Fig. 35, and squeeze locking lever (C), and raise or lower handle (B).

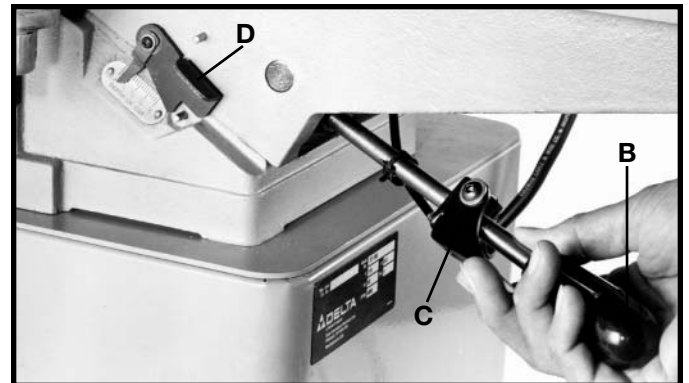


Fig. 35

3. **NOTE:** When raising or lowering the infeed table, a depth stop (D) Figs. 35 and 36, will automatically stop the table at an 1/8" depth-of-cut. To move the table past this point, the depth stop must be lifted as shown, and the table can be moved up or down.

CAUTION Always make sure table lock handle (A) Fig. 34, is tightened before operation. The table lock handle (A) is spring-loaded and can be repositioned by pulling out the handle and repositioning it on the serrated nut located under the handle.

4. The depth-of-cut of the infeed table (position of table in relationship with the cutting circle) can be indicated with the pointer (E) Fig. 36. Maximum depth-of-cut is 1/2".

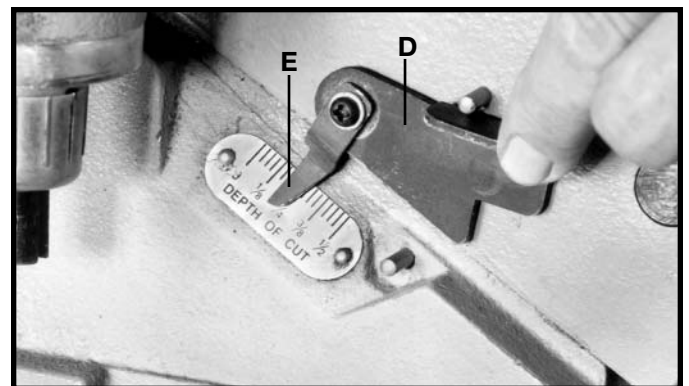


Fig. 36

INFEED TABLE POSITIVE STOPS

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

Positive stops are provided to limit the height and depth of the infeed table. To adjust the stops, loosen two locknuts (F) and (G) Fig. 37, and turn the two adjusting screws (J) and (K) as required. Then retighten the locknuts (F) and (G). A good suggestion is to set the upper positive stop (J) for your finish or final cut. This means that you will be able to rapidly set the infeed table for a finish or final cut without checking the scale and pointer. Also the lower positive stop (K) can be set for the maximum depth-of-cut or if you desire to limit the depth-of-cut, adjust the stop screw (K) accordingly.

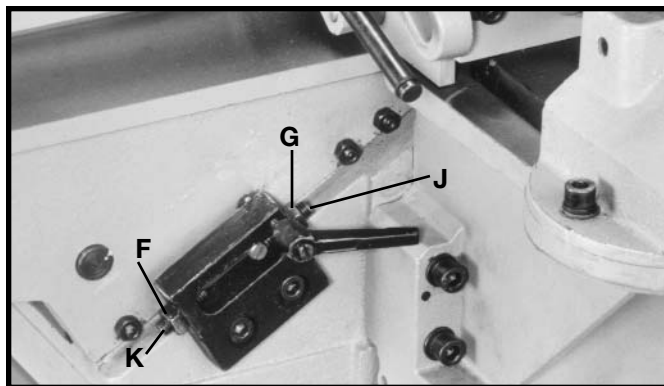


Fig. 37

OUTFEED TABLE ADJUSTMENTS

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. In order to perform accurate jointing operations, the outfeed table must be exactly level with the knives at their highest point of revolution. This means that the knives must be parallel to the outfeed table and project equally from the cutterhead.
2. To move the outfeed table up or down, loosen lock-screw (A) Fig. 38, and turn hand knob (B). When the outfeed table is exactly level with the knives at their highest point of revolution, tighten lock-screw (A).

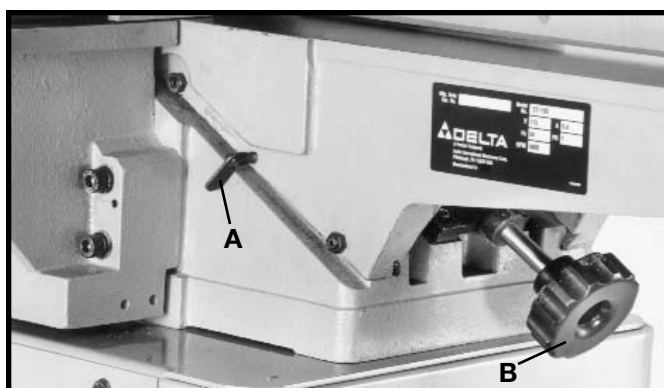


Fig. 38

KNIFE ADJUSTMENTS

In order to do accurate work, the knives must be exactly level with the outfeed table. To check and adjust, proceed as follows:

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. Loosen infeed table lock lever and lower infeed table as described under section "INFEED TABLE ADJUSTMENTS".
2. Remove cutterhead guard (C) Fig. 39.
3. Place a steel straight edge on the outfeed table, extending over the cutterhead as shown in Fig. 40.
4. Carefully rotate the cutterhead by hand. The knives should just touch the straight edge.



Fig. 39

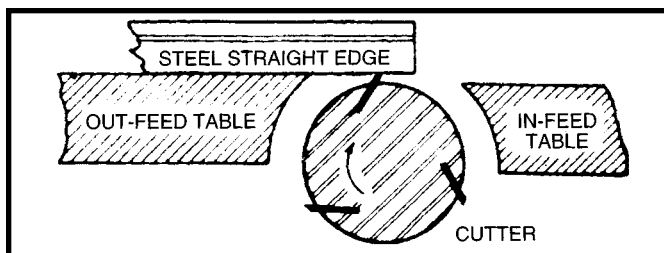


Fig. 40

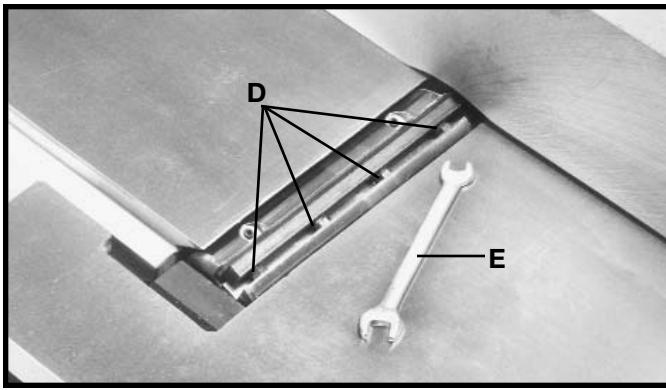


Fig. 41

5. If the knife is high or low at either end, slightly turn the four screws (D) Fig. 41, in the knife locking bar clockwise to loosen using the wrench (E) supplied. Then adjust the height of the knife by turning the knife raising screws (F) Fig. 42, counterclockwise to lower and clockwise to raise the knife.

⚠ WARNING CARE MUST BE TAKEN WHEN HANDLING THE KNIVES, AS THE CUTTING EDGES ARE VERY SHARP.

If the knife is to be lowered it will be necessary to carefully push down on the knife with a scrap piece of wood, after screws (F) have been turned. Tighten four screws (D) Fig. 41, by turning them counterclockwise, after adjustment is made.

6. Repeat these procedures for adjusting the remaining two knives if necessary, and replace cutterhead guard removed in **STEP 2**.

7. If the knives are set too low, the result will be as shown in Fig. 43, and the finished surface will be curved.

8. If the knives are set too high, the work will be gouged, curved, or bowed at the end of the cut, as shown in Fig. 44.

9. As a final check, run a piece of work slowly over the knives for 6 to 8 inches. The wood should rest firmly on both tables as shown in Fig. 45, with no open spaces under the finished cut.

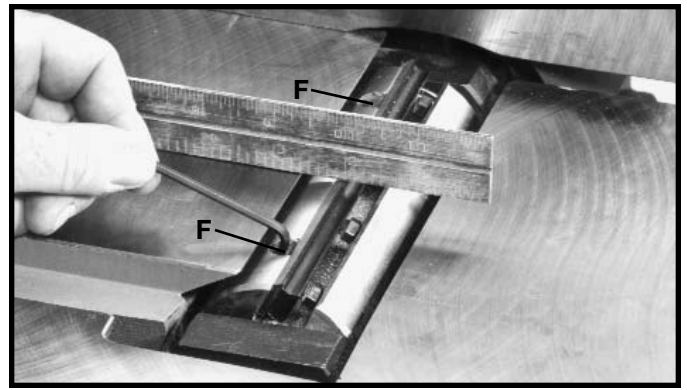


Fig. 42

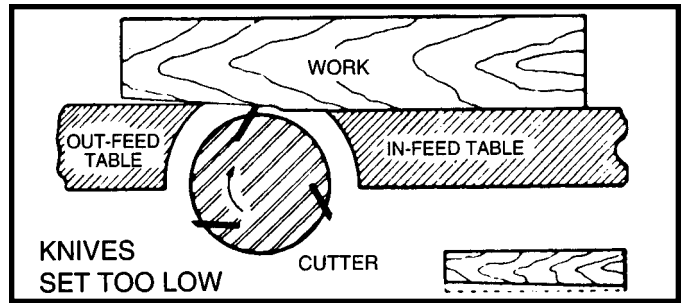


Fig. 43

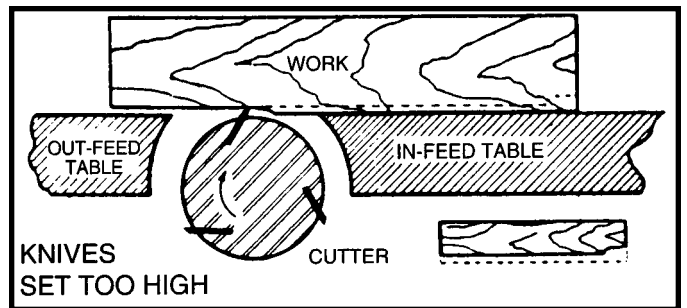


Fig. 44

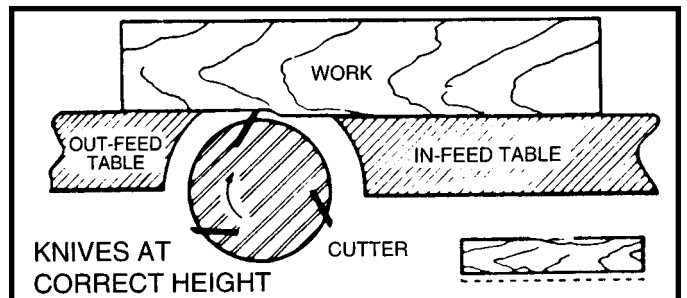


Fig. 45

ADJUSTING TABLE GIBS

“Gibs” are provided to take up all play between the mating dovetail ways of the base and the infeed and outfeed tables. The “gib” for the infeed table is shown at (A) Fig. 46, and the “gib” for the outfeed table is shown at (B) Fig. 47. Proper “gib” adjustment is necessary for the correct functioning of the jointer. The “gibs” were adjusted at the factory and should require no further adjustment. If, however, it becomes necessary to adjust the “gibs”, proceed as follows:

1. To adjust the infeed or outfeed table “gibs”, loosen three locknuts (F) Fig. 46, for the infeed table or two locknuts (G) Fig. 47, for the outfeed table. For the infeed table, make sure the table locking lever (H) Fig. 46, is loose. For the outfeed table, make sure the table locking screw (E) Fig. 47, is loose.

2. Tighten or loosen three gib adjustment screws (C) Fig. 46, as necessary for the infeed table or two gib adjustment screws (D) Fig. 47, as necessary for the outfeed table; starting with the lower screw first and as you proceed to the top screw, gently raise the outboard edge of the table that is being adjusted. This will offset any tendency for the table casting to “droop or sag” and permit the gib to be adjusted to a secure fit. After the gib adjustment screws have been adjusted, tighten locknuts (F) Fig. 46, (G) Fig. 47, table locking screw (E) Fig. 47, and infeed table locking lever (H) Fig. 46.

IMPORTANT: Do not leave the adjusting screws too loose. It should take a little bit of effort to move the tables up or down.

FENCE OPERATION

The fence can be moved across the table and can tilt 45 degrees right or left at any position on the table as follows:

NOTE: SWITCH HAS BEEN REMOVED FOR CLARITY OF ILLUSTRATIONS ONLY.

1. To move the fence across the table, loosen lock handle (A) Fig. 48, and turn knob (B) until desired fence location is reached. Then tighten lock handle (A). As the fence is moved across the table, the rear cutterhead guard (C) covers and guards the cutterhead in back of the fence.

NOTE: Lock handle (A) is spring-loaded and can be repositioned by pulling up on the handle and repositioning it on the serrated nut located underneath the hub of the handle.

2. To tilt the fence in or out, loosen lock handle (D) Fig. 48. While holding fence tilting handle (E) Fig. 49, rotate 90° flip stop (G) and tilt the fence to the desired angle, in or out, and tighten lock handle (D) Fig. 48. **IMPORTANT:** When cutting bevels and the angle is small, there is little difference whether the fence is tilted in or out; however, at angles approaching 45 degrees it may become difficult to hold the work securely against the fence when the fence is tilted out. In these cases we suggest that the fence be tilted toward the table, as shown in Fig. 50. The fence will form a V-shape with the tables and the work is easily pressed into the pocket while passing across the knives.

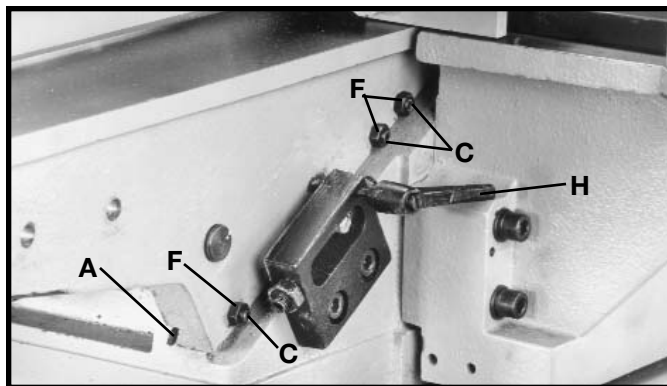


Fig. 46

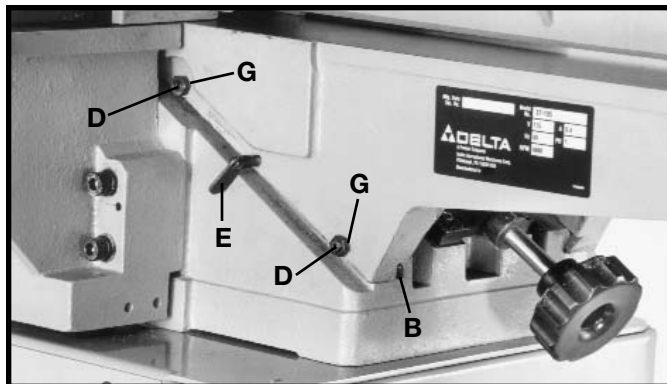


Fig. 47

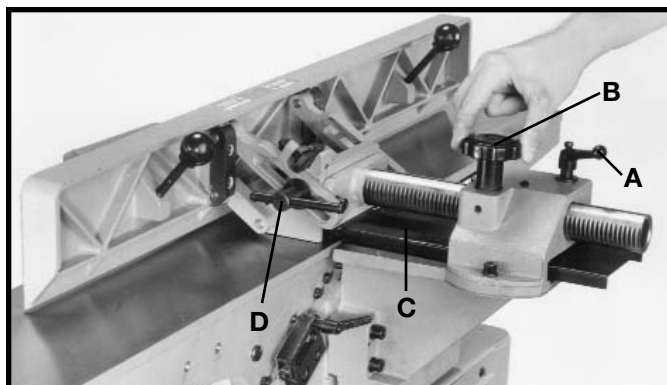


Fig. 48

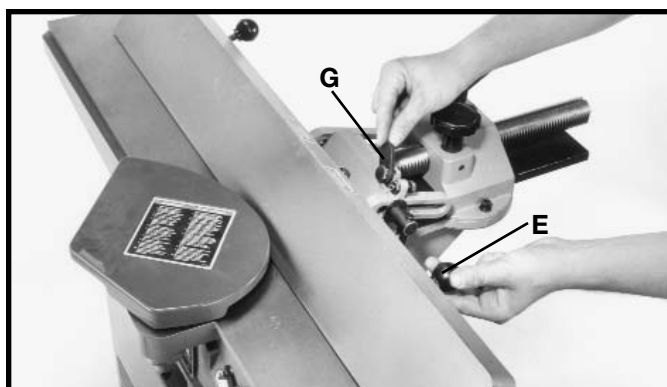


Fig. 49

ADJUSTING FENCE POSITIVE STOP

NOTE: SWITCH HAS BEEN REMOVED FOR CLARITY OF ILLUSTRATIONS ONLY.

The fence on this jointer is equipped with positive stops that allow you to rapidly tilt the fence to the 90 and 45 degree angle to the table in the inward or outward position. To check and adjust the positive stops, proceed as follows:

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. Position the fence at 90 degrees to the table. Make certain flip stop (G) Fig. 51, is in the lowered position as shown, and adjustment screw (A) is contacting the flip stop. Then tighten lock handle (B).
2. Place a square (C) Fig. 51, on the table and against the fence to determine if the fence is 90 degrees to the table.
3. If an adjustment is necessary, loosen lock handle (B) Fig. 51, and lock nut (D). Turn adjustment screw (A) until you are certain the fence is 90 degrees to the table. Then tighten lock handle (B) and lock nut (D).
4. Loosen lock handle (B) Fig. 52, and rotate flip stop (G). Then tilt fence out as far as it will go and tighten lock handle (B).
5. Using a square (C) Fig. 52, check to determine if the fence is 45 degrees to the table, as shown.
6. If an adjustment is necessary, loosen lock handle (B) Fig. 52, and lock nut (E). Turn adjustment screw (H) until you are certain the fence is 45 degrees to the table. Then tighten lock handle (B) and lock nut (E).
7. Loosen lock handle (B) Fig. 53, and tilt fence as far in as it will go and tighten lock handle.
8. Using a square (C) Fig. 53, check to determine if the fence is 45 degrees to the table.
9. If an adjustment is necessary, loosen lock handle (B) Fig. 53, and lock nut (J). Turn adjustment screw (K) until you are certain the fence is 45 degrees to the table. Then tighten lock handle (B) and lock nut (J).



Fig. 50

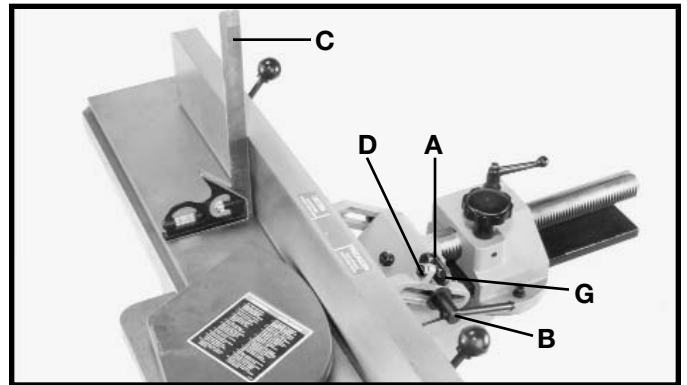


Fig. 51

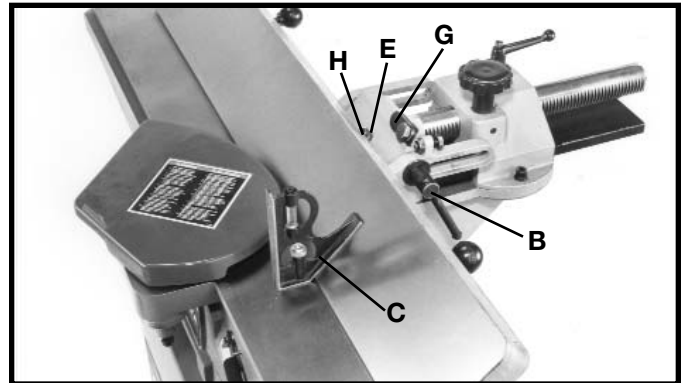


Fig. 52

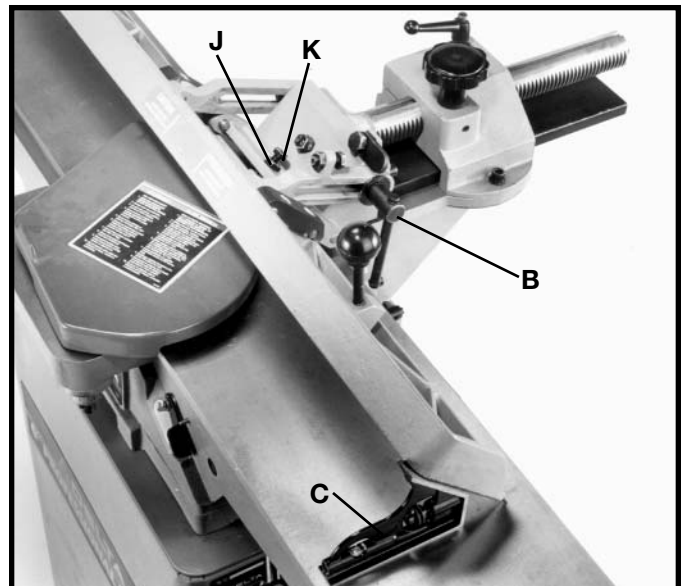


Fig. 53

REMOVING, REPLACING, AND RESETTING KNIVES

If the knives are removed from the cutterhead for replacement or sharpening, care must be used in removing, replacing, and resetting them.

⚠ WARNING **DISCONNECT MACHINE FROM POWER SOURCE.**

1. Move the fence to the rear and remove the cutterhead guard.

⚠ WARNING **BE EXTREMELY CAREFUL THAT YOUR HANDS DO NOT COME IN CONTACT WITH THE KNIVES. THE KNIVES ARE VERY SHARP.**

2. Using wrench (A) Fig. 54, slightly loosen the four locking screws (B) in each knife slot by turning the screws (B) clockwise.

3. Loosen screws (B) Fig. 54, further and remove knife and knife locking bar.

4. Fig. 55, shows the knife (C) and knife locking bar (D) removed from the cutterhead. Remove the remaining two knives and locking bars, in the same manner.

5. Using wrench (E) Fig. 55, lower the two knife adjustment blocks by turning screws (F) counterclockwise in all three slots of the cutterhead.

6. Before replacing knives make certain the knife locking bars are thoroughly clean and free of gum and pitch.

7. Replace the knife locking bars (D) Fig. 55, and knives (C) into each slot in the cutterhead.

⚠ WARNING **CARE MUST BE TAKEN WHEN INSERTING THE KNIVES AS THE CUTTING EDGES ARE VERY SHARP.** Push the knife down as far as possible and snug up the screws (B) Fig. 54, by turning each screw counterclockwise just enough to hold the knife in position. Replace the remaining two knives in the same manner.

CAUTION **KNIVES MUST BE INSTALLED CORRECTLY AS SHOWN IN FIG. 56.**

8. The knives are adjusted correctly when the cutting edge of the knife extends out .060" from the cutterhead diameter.

9. Carefully rotate the cutterhead (G) Fig. 57, until the round portion of the cutterhead is on top as shown.

10. Place a .060" feeler gage (H) Fig. 57, on the cutterhead and using a straight edge (J) on the rear table adjust the height of the rear table until it is .060" above the cuttinghead diameter, as shown.

11. Lock the rear table in position and remove the feeler gage.

12. Lower the infeed table and place a straight edge (J) Fig. 58, on the outfeed table extending over the cutterhead as shown.

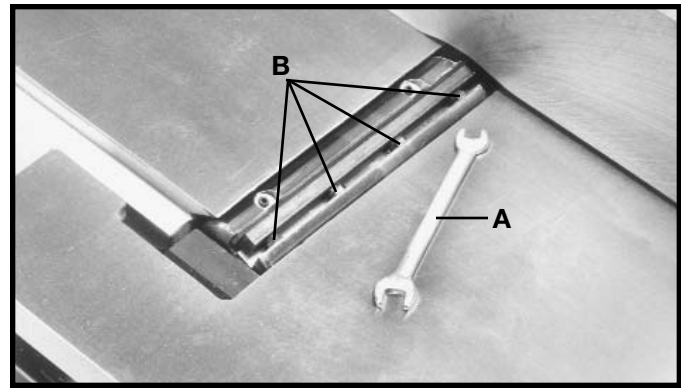


Fig. 54

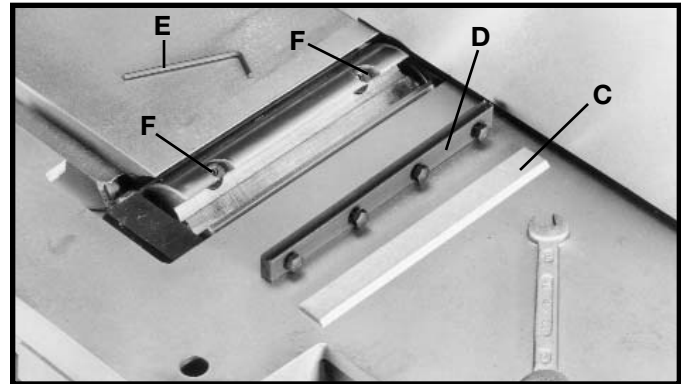


Fig. 55

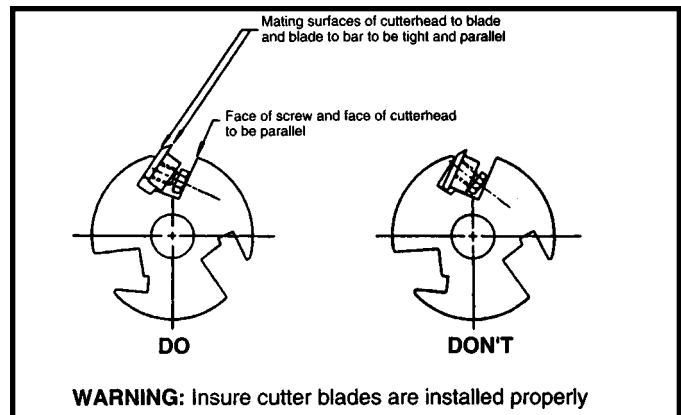


Fig. 56

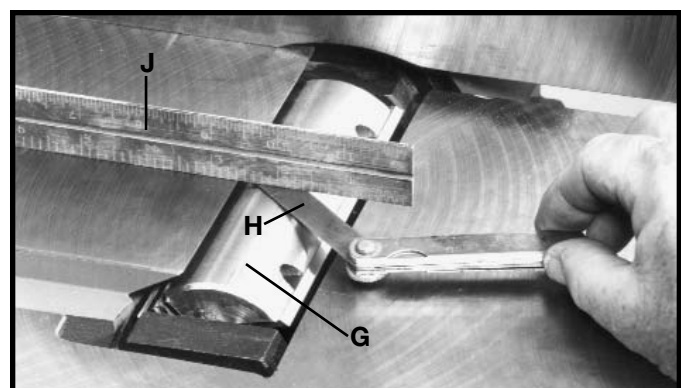


Fig. 57

13. Rotate the cutterhead by hand until the knife is at its highest point at each end of the cutterhead. To raise the knife, use wrench (E) Fig. 58, and turn raising screw clockwise until the knife just touches the straight edge (J) on each end and center of the cutterhead when the knife is at its highest point. When you are certain the knife is adjusted properly, tighten the four locking screws (B) by turning them counterclockwise.

14. Adjust the remaining two knives in the same manner.

⚠ WARNING MAKE CERTAIN THAT ALL KNIVES ARE SECURELY FASTENED IN CUTTERHEAD BEFORE TURNING ON POWER.

15. Replace cutterhead guard.

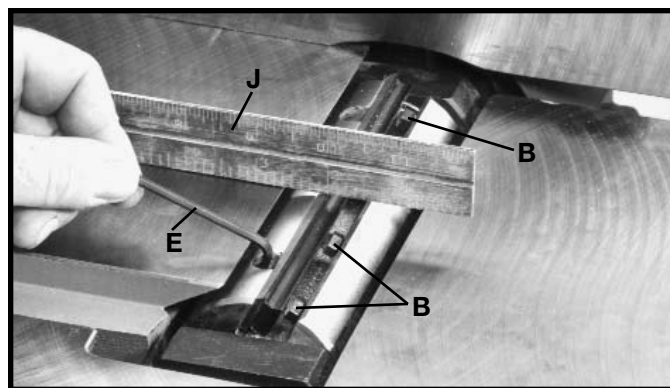


Fig. 58

OPERATION

The following directions will give the beginner a start on jointer operations. Use scrap pieces of lumber to check settings and to get the feel of the operations before attempting regular work.

CAUTION THE KNIVES ON THE JOINTER WILL NOT WEAR EVENLY BY FEEDING THE WOOD THROUGH THE SAME SPOT ON THE TABLE EVERY TIME. FEED THE WOOD THROUGH THE JOINTER AT DIFFERENT SPOTS ON THE TABLE WHEN POSSIBLE, TO HELP ELIMINATE UNEVEN WEAR OF THE KNIVES.

⚠ WARNING ALWAYS USE CUTTERHEAD GUARD AND KEEP HANDS AWAY FROM CUTTERHEAD. ALWAYS USE PUSH BLOCKS WHENEVER POSSIBLE. NEVER MAKE JOINTING AND PLANING CUTS DEEPER THAN 1/8" IN ONE PASS.

PLACEMENT OF HANDS DURING FEEDING

At the start of the cut, the left hand holds the work firmly against the infeed table and fence, while the right hand pushes the work toward the knives. After the cut is underway, the new surface rests firmly on the outfeed table as shown in Fig. 61. The left hand should then be moved to the work on the outfeed table, at the same time maintaining flat contact with the fence. The right hand presses the work forward, and before the right hand reaches the cutterhead, it should be moved to the work on the outfeed table.

⚠ WARNING NEVER PASS HANDS DIRECTLY OVER THE CUTTERHEAD.

JOINTING AN EDGE

This is the most common operation for the jointer, these cuts are made to square an edge of a workpiece. Set the guide fence square with the table. Depth of cut should be the minimum required to obtain a straight edge. Hold the best face of the piece firmly against the fence throughout the feed as shown in Fig. 61.

CAUTION MAXIMUM DEPTH OF CUT SHOULD NOT BE MORE THAN 1/8" IN ONE PASS.

CAUTION DO NOT PERFORM JOINTING OPERATIONS ON MATERIAL SHORTER THAN 10 INCHES, NARROWER THAN 3/4 INCH, OR LESS THAN 1/2 INCH THICK (REFER TO FIG. 62).

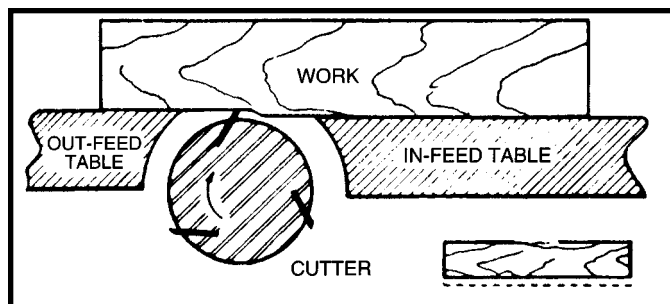


Fig. 60



Fig. 61

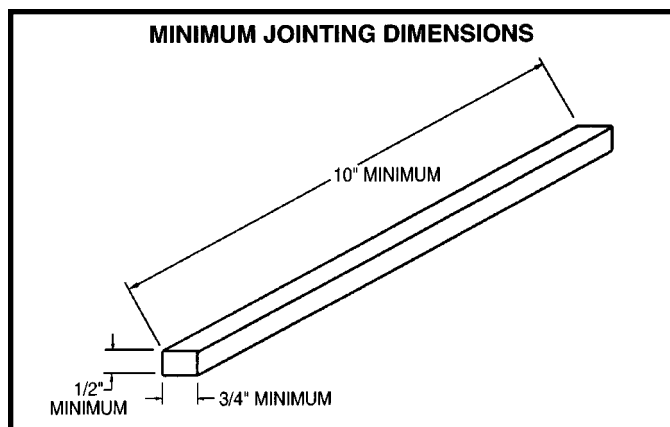


Fig. 62

SURFACING

Surfacing is identical to the jointing operation except for the position of the workpiece. For surfacing, the major flat surface of the workpiece is placed on the infeed table of the jointer with the narrow edge of the workpiece against the fence, as shown in Fig. 63. The workpiece is moved from the infeed table, across the cutterhead to the outfeed table establishing a flat surface on the workpiece

⚠ WARNING ALWAYS USE PUSH BLOCKS WHEN PERFORMING SURFACING OPERATIONS AND NEVER PASS YOUR HANDS DIRECTLY OVER THE CUTTERHEAD.

CAUTION MAXIMUM DEPTH OF CUT SHOULD NOT BE MORE THAN 1/8" IN ONE PASS.

BEVELING

To cut a bevel, lock the fence at the required angle and run the work across the knives while keeping the work firmly against the fence and tables. Several passes may be necessary to arrive at the desired result. When the angle is small, there is little difference whether the fence is tilted to the right or left. However, at greater angles approaching 45 degrees, it is increasingly difficult to hold the work properly when the fence is tilted to the right. The advantage of the double-tilting fence is appreciated under such conditions. When tilted to the left, the fence forms a V-shape with the tables, as shown in Fig. 64, and the work is easily pressed into the pocket while passing it across the knives. If the bevel is laid out on the piece in such direction that this involves cutting against the grain, it will be better to tilt the fence to the right.

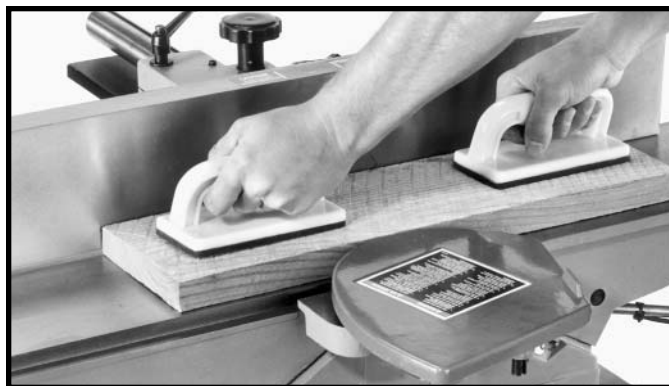


Fig. 63



Fig. 64

TAPER CUTS

One of the most useful jointer operations is cutting an edge to a taper. This method can be used on a wide variety of work. Tapered legs of furniture are a common example. Instead of laying the piece on the infeed table, lower the forward end of the work onto the outfeed table. Do this very carefully, as the piece will span the knives, and they will take a "bite" from the work with a tendency to kick back unless the piece is firmly held. Now push the work forward as in ordinary jointing. The effect is to surface off all the stock in front of the knives, to increasing depth, leaving a tapered surface. The ridge left by the knives when starting the taper may be removed by taking a very light cut according to the regular method for jointing, with the infeed table raised to its usual position. Practice is required in this operation, and the beginner is advised to make trial cuts on waste material. Taper cuts over part of the length and a number of other special operations can easily be done by the experienced craftsman.

CUTTING A RABBET

When making a rabbet cut, as shown in Fig. 65, the cutterhead guard must be removed.

⚠ CAUTION AFTER THE RABBET CUT IS COMPLETED, BE CERTAIN GUARD IS REPLACED.

1. Adjust the fence so that the distance between the end of the knives and the 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 quite deep, it may be necessary to cut it in two or more passes. In that event, the table is lowered an amount equal to about half the depth of the rabbet for the first pass, then lowered again to proper depth to complete the cut.



Fig. 65

SURFACING WARPED PIECES

If the wood to be surfaced is dished or warped, take light cuts until the surface is flat. Avoid forcing such material down against the table; excessive pressure will spring it while passing the knives, and it will spring back and remain curved after the cut is completed.

SURFACING SHORT OR THIN WORK

⚠ CAUTION WHEN SURFACING SHORT OR THIN PIECES, ALWAYS USE PUSH BLOCKS TO MINIMIZE ALL DANGER TO THE HANDS. Fig. 66, illustrates using the Delta Push Blocks properly.

⚠ CAUTION DO NOT PERFORM SURFACING OPERATIONS ON MATERIAL SHORTER THAN 10 INCHES, NARROWER THAN 3/4 INCH, WIDER THAN 6 INCHES, OR LESS THAN 1/2 INCH THICK (REFER TO FIG. 67).

DIRECTION OF GRAIN

Avoid feeding work into the jointer against the grain as shown in Fig. 68. The result will be chipped and splintered edges. Feed with the grain as shown in Fig. 69, to obtain a smooth surface.



Fig. 66

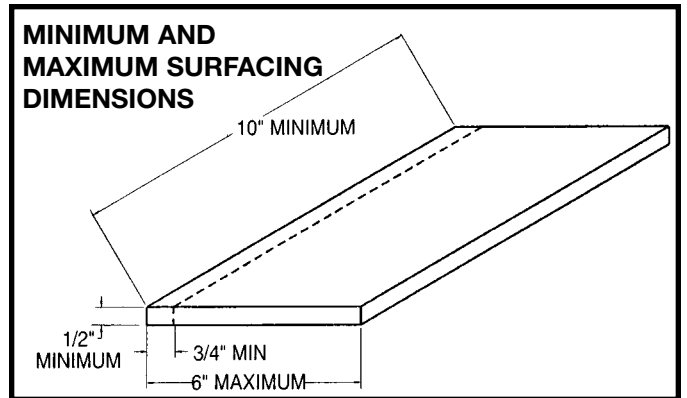


Fig. 67

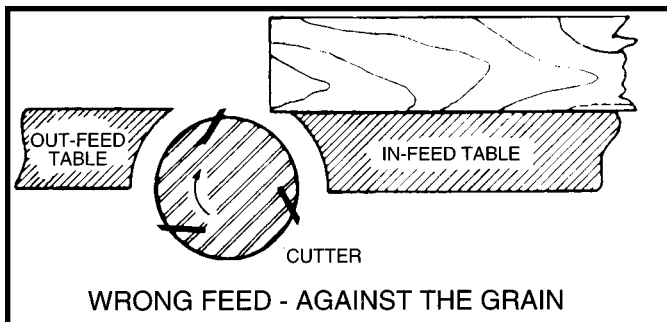


Fig. 68

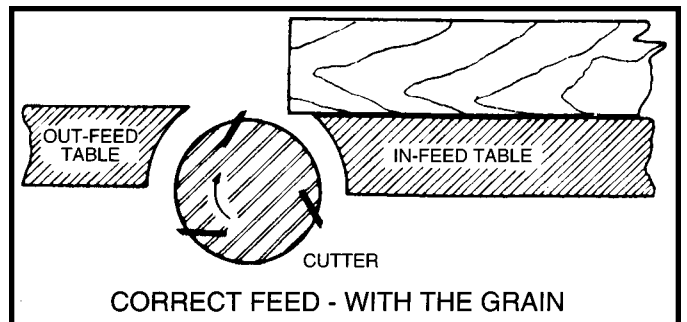


Fig. 69

MAINTENANCE AND REPAIRS

After considerable use, the knives will become dull and it will not be possible to do accurate work. Unless badly damaged by running into metal or other hard material, the knives may be sharpened as follows:

WHETTING KNIVES

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

Use a fine carborundum stone, cover it partly with paper as indicated in Fig. 59 to avoid marking the table. Lay the stone on the infeed table, lower the table and turn the cutterhead forward until the stone lies flat on the bevel of the knife as shown. Hold the cutterhead from turning, and whet the beveled edge of the knife, stroking lengthwise by sliding the stone back and forth across the table. Do the same amount of whetting on each of the three knives.

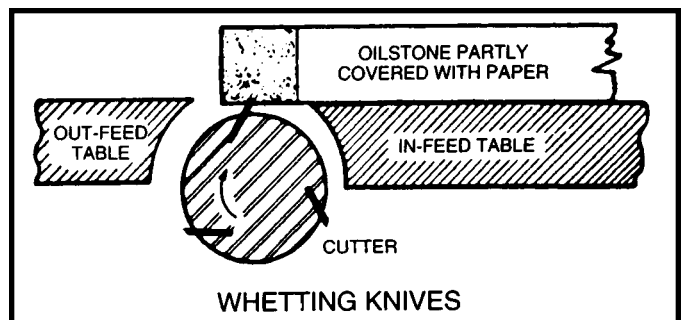
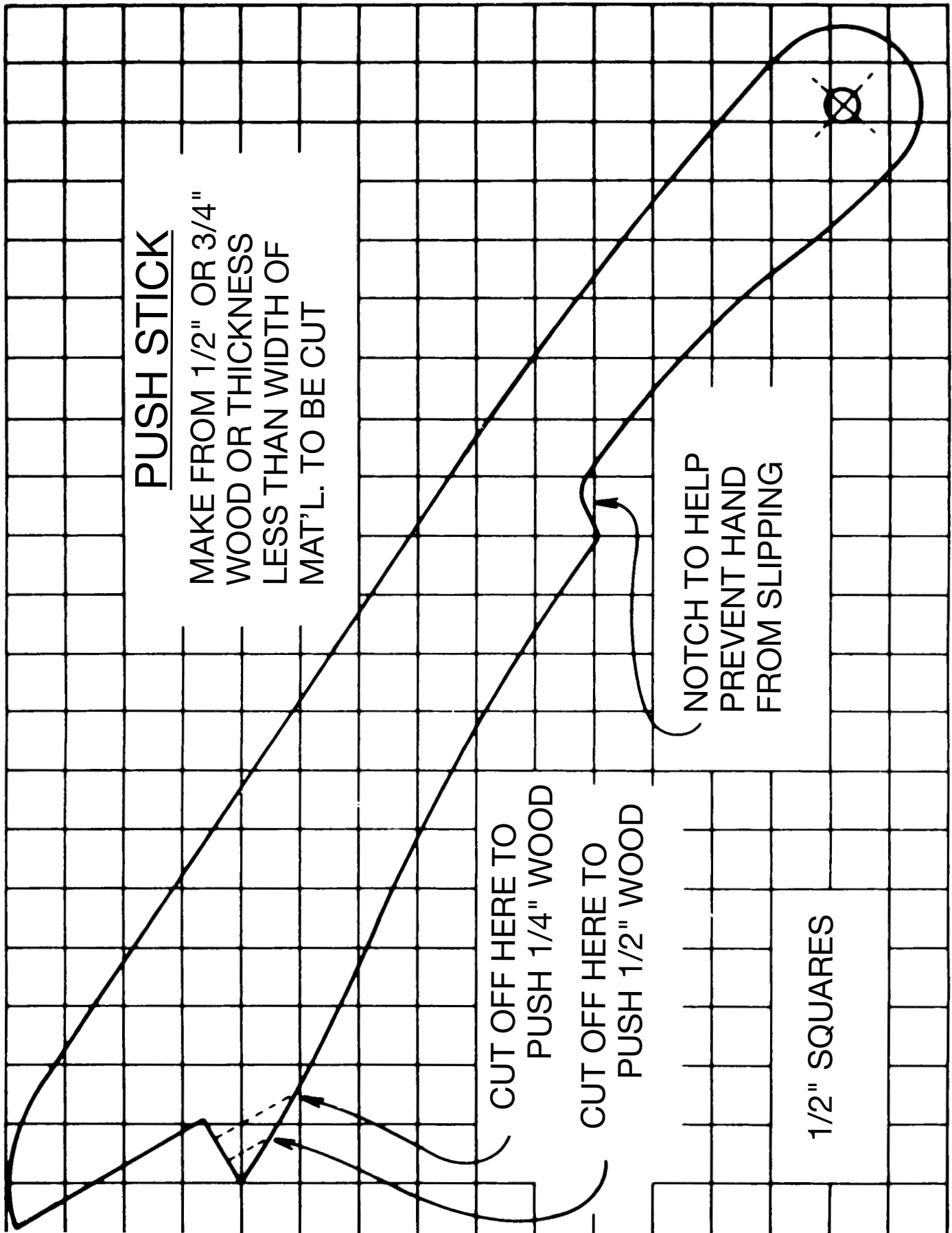


Fig. 70

CONSTRUCTING A PUSH STICK

CAUTION Narrow pieces of stock that are close to 10 inch minimum length should be handled with a push stick and push block. The Fig. below is a pattern for a push stick.



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A complete line of accessories is available from your Delta Supplier, Porter-Cable • Delta Factory Service Centers, and Delta Authorized Service Stations. Please visit our Web Site www.deltamachinery.com for a catalog or for the name of your nearest supplier.

▲ WARNING Since accessories other than those offered by Delta have not been tested with this product, use of such accessories could be hazardous. For safest operation, only Delta recommended accessories should be used with this product.



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