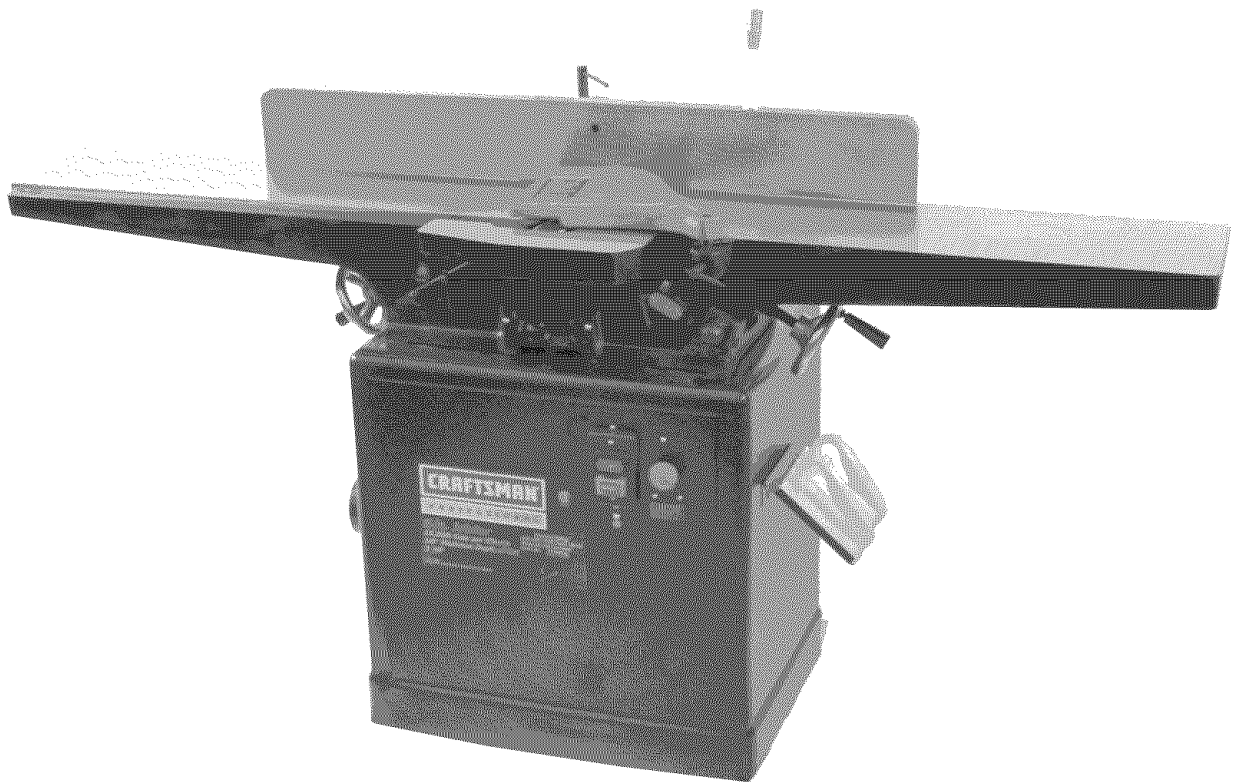


# Operator's Manual



## 8" JOINTER AND JOINTER STAND

Model No.  
351.217030



**CAUTION:** Read and follow all Safety Rules and Operating Instructions before First Use of this Product.

Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.  
[www.sears.com/craftsman](http://www.sears.com/craftsman)

23056.00 Draft (01/21/05)

SAFETY

ASSEMBLY

OPERATION

MAINTENANCE

PARTS LIST

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## WARRANTY

### FULL ONE YEAR WARRANTY

If this product fails due to a defect in material or workmanship within one year from the date of purchase, Sears will at its option repair or replace it free of charge. Contact your nearest Sears Service Center (1-800-4-MY-HOME) to arrange for product repair, or return this product to place of purchase for replacement.

If this product is used for commercial or rental purposes, this warranty will apply for 90 days from the date of purchase.

This warranty applies only while this product is used in the United States.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

**Sears, Roebuck and Co., Dept. 817WA, Hoffman Estates, IL 60179**

## SAFETY RULES

**WARNING:** For your own safety, read all of the rules and precautions before operating tool.

**CAUTION:** Always follow proper operating procedures as defined in this manual even if you are familiar with use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.

### BE PREPARED FOR JOB

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses complying with United States ANSI Z87.1. Everyday glasses have only impact resistant lenses. They are **NOT** safety glasses.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

## PREPARE WORK AREA FOR JOB

- Keep work area clean. Cluttered work areas invite accidents.
- Do not use power tools in dangerous environments.
- Do not use power tools in damp or wet locations. Do not expose power tools to rain.
- Work area should be properly lighted.
- Proper electrical receptacle should be available for tool. Three prong plug should be plugged directly into properly grounded, three-prong receptacle.
- Extension cords should have a grounding prong and the three wires of the extension cord should be of the correct gauge.
- Keep visitors at a safe distance from work area.
- Keep children out of workplace. Make workshop child-proof. Use padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.

## TOOL SHOULD BE MAINTAINED

- Always unplug tool prior to inspection.
- Consult manual for specific maintaining and adjusting procedures.
- Keep tool lubricated and clean for safest operation.
- Remove adjusting tools. Form habit of checking to see that adjusting tools are removed before switching machine on.
- Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.
- Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect a tool's operation.
- A guard or other part that is damaged should be properly repaired or replaced. Do not perform makeshift repairs. (Use parts list provided to order replacement parts.)

## KNOW HOW TO USE TOOL

- Use right tool for job. Do not force tool or attachment to do a job for which it was not designed.
- Disconnect tool when changing blades.
- Avoid accidental start-up. Make sure that the switch is in the OFF position before plugging in.
- Do not force tool. It will work most efficiently at the rate for which it was designed.
- Keep hands away from moving parts and cutting surfaces.
- Never leave tool running unattended. Turn the power off and do not leave tool until it comes to a complete stop.
- Do not overreach. Keep proper footing and balance.
- Never stand on tool. Serious injury could occur if tool is tipped or if blade is unintentionally contacted.
- Know your tool. Learn the tool's operation, application and specific limitations.

- Use recommended accessories (refer to page 19). Use of improper accessories may cause risk of injury to persons.
- Handle workpiece correctly. Protect hands from possible injury.
- Turn machine off if it jams. Blade jams when it digs too deeply into workpiece. (Motor force keeps it stuck in the work.)

**CAUTION:** Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

## UNPACKING

Refer to Figure 1.

Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer.

The jointer is shipped complete in one crate along with a carton for the stand. Additional parts which need to be fastened to jointer and jointer stand should be located and accounted for before assembling.

- A. Jointer
- B. Stand
- C. Fence
- D. Fence Bracket Assembly
- E. Fence Locking Handle
- F. Push Block (2)
- G. Push Block Holder
- H. Blade Gauge
- I. Blade Guard Assembly
- J. Belt Guard
- K. Locking Studs (3)
- L. Handwheel Assembly (2)
- M. Dust Port
- N. V-Belt (2)

Angle Gauge (Not Shown)

Hardware Bag (Part No. 23200.00) includes Fence Grip Handle, M10 Flat Washer (3), M10 Lock Washer (3), M5 x 10 Socket Head Bolt (4), M5 Flat Washer (4), 5 x 5 x 25mm Key (2), 3, 4 and 5mm hex wrenches, 8/10mm, 12/14mm and 17/19mm open end wrenches.

**IMPORTANT:** Table is coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild solvents, such as mineral spirits, and a soft cloth. Avoid getting solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil. Paste wax is recommended for table tops.

**WARNING:** Never use highly volatile solvents. Non-flammable solvents are recommended to avoid possible fire hazard.

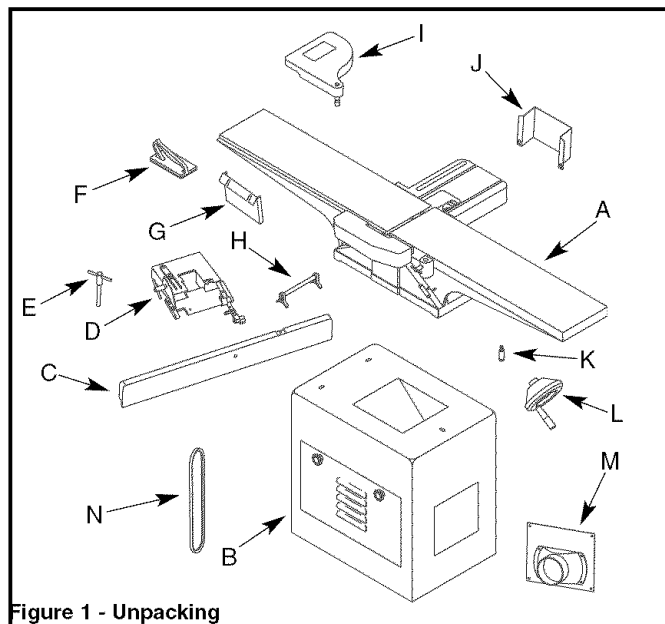


Figure 1 - Unpacking

## ASSEMBLY

**CAUTION:** Do not attempt assembly if parts are missing. Use this manual to order replacement parts.

### JOINTER INSTALLATION

Refer to Figure 2.

Before jointer or stand are assembled, a suitable location should be chosen. The jointer and jointer stand weigh approximately 400 lbs when completely assembled. They should be assembled on location.

- Jointer needs to be set on a flat, level surface.
- Make sure there is ample room on either side of jointer to accommodate desired workpiece size.
- Good lighting and correct power supply are also required for a proper work area.
- Place stand in its designated spot. Door panel for access to motor is on back side.

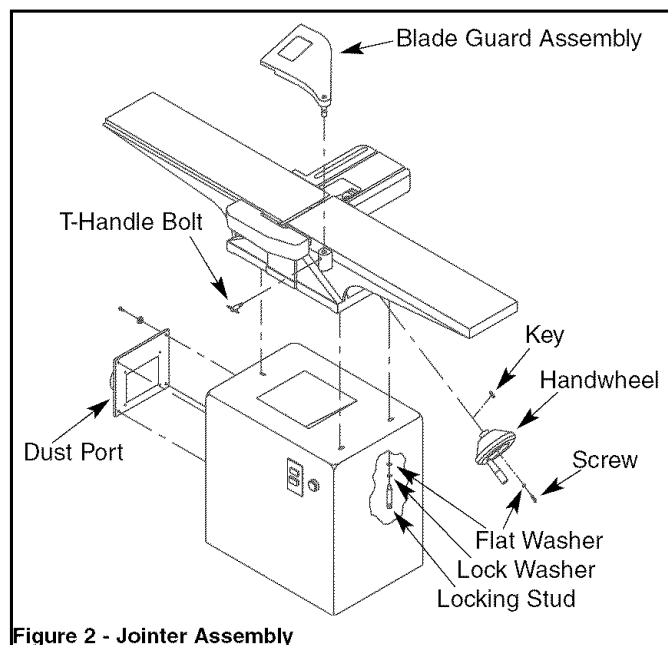


Figure 2 - Jointer Assembly

## MOUNT JOINTER

Refer to Figure 2, page 3.

- Place jointer on stand and attach it.

**NOTE:** At least two people are required to lift the 300 lb. jointer.

- Jointer is held to stand by three locking studs, three lock washers and flat washers.
- Threaded mounting holes in base of jointer must be lined up with holes in top of stand. Using a flashlight will assist in quickly locating the holes.
- One location for a stud which fastens the jointer to stand is reached through the chip chute.
- Location for other two locking studs are reached through the doorway of the stand.

## INSTALL V-BELTS

Refer to Figure 12.

Jointer uses a two-belt system for more efficient power transfer. Motor mounting plate pivots at one side to provide for easy mounting and easy belt tensioning.

- Loosen front bolts (Key No. 11) so that motor mounting plate (Key No. 9) is loose.

**NOTE:** The front bolts are located in the slotted end of the plate.

- Pull up on motor mounting plate and install V-Belts onto driven pulley and motor pulley.
- Apply tension to the belts by pushing down on plate and tightening bolts.
- Make sure belts are tensioned properly. Belt is properly tensioned when moderate pressure applied to the belts (between the pulleys) will deflect the belts about  $\frac{1}{2}$ ".
- If belts do not have the proper tension, the motor mounting plate can be adjusted by loosening front bolts. Move plate, tighten bolts and recheck belt tension.

## MOUNT HANDWHEELS

Refer to Figure 2, page 3.

- Handwheels attach to the leadscrews for table height adjustment. The leadscrew is coupled to the handwheel with a key.
- Loosen and remove screw and flat washer from leadscrew.
- Place key into keyway on the leadscrew.
- Slide handwheel onto leadscrew.
- Fasten handwheel to leadscrew with screw and flat washer.

## MOUNT BELT GUARD

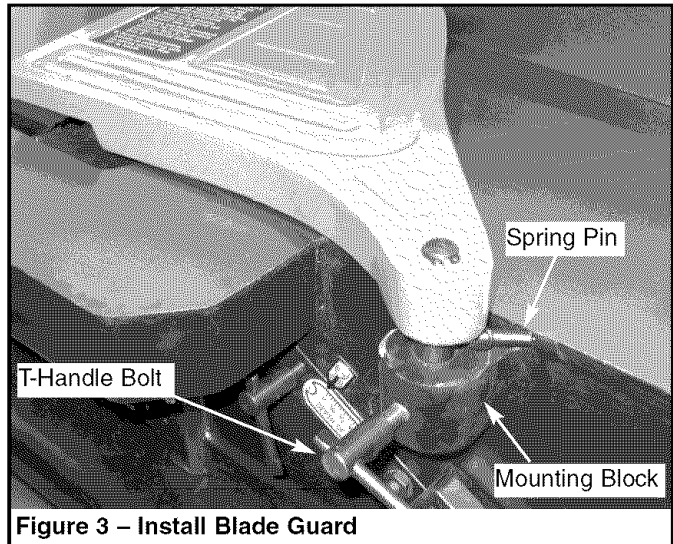
Refer to Figure 13.

- Loosen and remove two bolts and washers (Key Nos. 8 and 44) on the back of the jointer base.
- Position belt guard (Key No. 15) on back of jointer and secure in position with bolts and washers.

## MOUNT BLADE GUARD

Refer to Figures 2 and 3, pages 3 and 4.

- The blade guard assembly employs a spring loaded return located between the blade guard and guard shaft. Blade guard assembly can be attached or removed without altering spring action.
- The infeed table includes a mounting block which is part of the casting. Insert guard shaft into the mounting block.
- Position blade guard assembly with spring pin facing toward front of infeed table (see Figure 3).
- Secure in position with T-handle bolt.
- Tension will be applied to guard when fence is installed.



## MOUNT FENCE BRACKET ASSEMBLY

Refer to Figure 13.

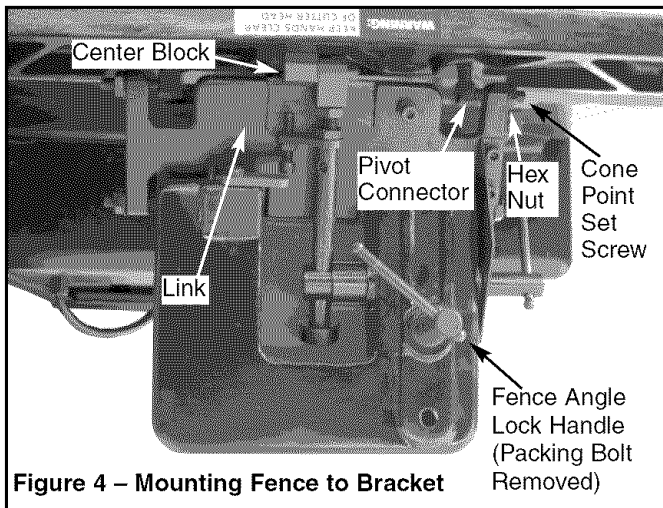
- Loosen the two socket head bolts (Key No. 41) of the outfeed table. Do not remove bolts. Loosen just enough to fit bracket over bolts.
- Place the fence bracket assembly over the bolts. Carefully tighten bolts, making sure to keep the top surfaces of the fence bracket assembly and outfeed table flush to each other.

## MOUNT FENCE TO BRACKET

Refer to Figures 4 and 14, pages 5 and 19.

- Swing blade guard forward, over and past cutterhead. Secure in position.
- Loosen hex nuts (Key No. 6) several turns.
- Position fence in front of the link (Key No. 10). Make sure blade relief in fence is against the table, over the cutterhead.
- Turn the cone point set screws (Key No. 7) equally until they seat firmly in the pivot connectors (Key No. 5).
- Check that fence is parallel to both jointer tables. If not parallel, loosen set screws, turn pivot connector as needed, and then tighten set screws into pivot connectors.

- Secure set screws by tightening hex nuts.
- Remove hex head packing bolt from top of fence bracket assembly and discard. Insert fence angle lock handle and thread into nut. Make sure nut is aligned in bracket slot.
- Remove socket head bolt from fence block (Key No. 16). Insert bolt through fence and thread bolt securely into block.
- Attach fence grip (Key No. 3) to fence.
- Release blade guard. Blade guard should swing against fence and completely cover cutterhead.



## MOUNT DUST COLLECTION PORT

Refer to Figure 2.

- Jointer stand has a built-in chip chute. The dust collection port covers the end of the chip chute.
- Attach port with pan head screws and flat washers.
- Port has a 4" diameter opening to attach to a standard hose.
- Port will not inhibit the chip flow. A dust collector must be used.

## ATTACH PUSH BLOCK SHELF

Refer to Figure 12.

- Place shelf (Key No. 29) over bolt and washer (Key Nos. 17 and 27) located on stand beneath infeed table.
- Tighten bolt to secure shelf in position.

# INSTALLATION

## POWER SOURCE

Refer to Figure 5.

**WARNING:** Do not connect jointer to the power source until all assembly steps have been completed.

The motor is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below specified voltage. Running the unit on voltages which are not within range may cause overheating and motor

burnout. Heavy loads require that voltage at motor terminals be no less than the voltage specified on nameplate.

## GROUNDING INSTRUCTIONS

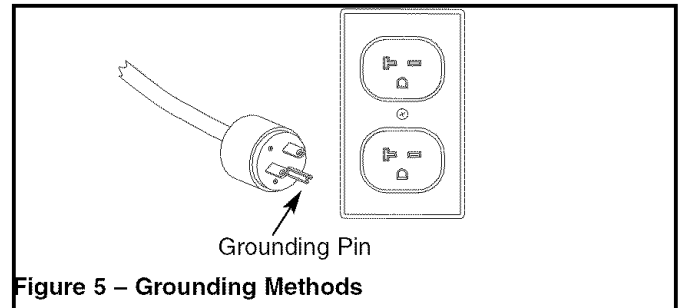
**WARNING:** Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

Check with a qualified electrician if grounding instructions are not understood or if in doubt as to whether the tool is properly grounded.

This tool is equipped with an approved 3-conductor cord rated up to 250V and a 3-prong grounding type plug rated at 250V (See Figure 5) for your protection against shock hazards.

Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

**WARNING:** Do not permit fingers to touch the terminals of plug when installing or removing from outlet.



Plug must be plugged into a 230V matching outlet (See Figure 5) that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify plug provided. If it will not fit in outlet, have proper outlet installed by a qualified electrician.

Inspect tool cords periodically, and if damaged, have repaired by an authorized service facility.

Green (or green and yellow) conductor in cord is the grounding wire. If repair or replacement of the electric cord or plug is necessary, do not connect the green (or green and yellow) wire to a live terminal.

Where a 2-prong wall receptacle is encountered, it must be replaced with a properly grounded 3-prong receptacle installed in accordance with National Electric Code and local codes and ordinances.

**WARNING:** This work should be performed by a qualified electrician.

## EXTENSION CORDS

- The use of any extension cord will cause some drop in voltage and loss of power.
- Wires of the extension cord must be of sufficient size to carry the current and maintain adequate voltage.
- Use the table to determine the minimum wire size (A.W.G.) extension cord.

- Use only 3-wire extension cords having 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug.
- If the extension cord is worn, cut, or damaged in any way, replace it immediately.

**EXTENSION CORD LENGTH**

Wire Size	A.W.G.
Up to 50 ft. ....	12

**NOTE:** Using extension cords over 50 ft. long is not recommended.

**MOTOR**

The stand is assembled with motor and wiring installed. The 230 Volt AC capacitor start motor has the following specifications:

Horsepower .....	2
Voltage .....	230
Amperes .....	8.6
Hertz .....	60
Phase .....	Single
RPM .....	3450

**ELECTRICAL CONNECTIONS**

Refer to Figure 6.

**WARNING:** All electrical connections must be performed by a qualified electrician. Make sure unit is off and disconnected from power source while motor is mounted, connected, reconnected or anytime wiring is inspected.

Jointer has an approved 230 volt three-conductor line cord with a three-prong grounding type plug, and a 230 volt magnetic contactor that is prewired in the factory (See Figure 6).

- Connect jointer to a supply circuit protected by a 20 AMP circuit breaker or time delay fuse.

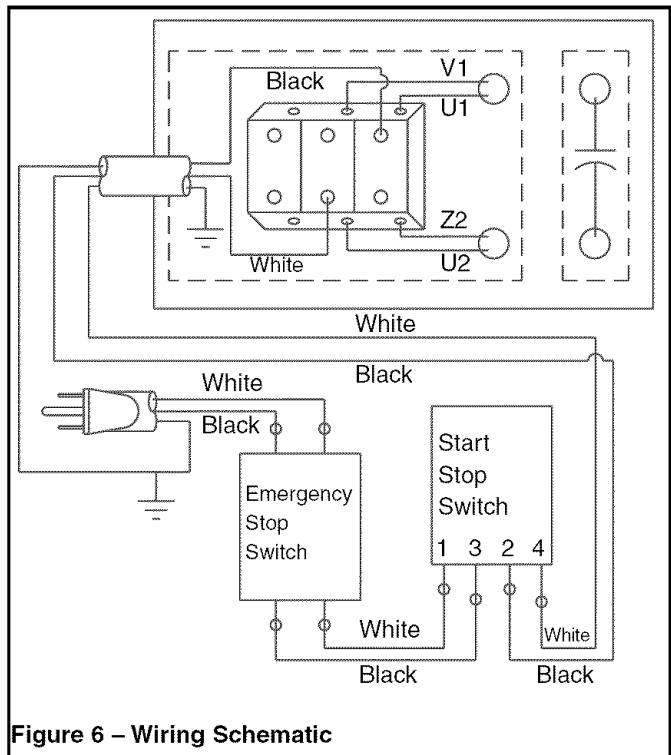


Figure 6 – Wiring Schematic

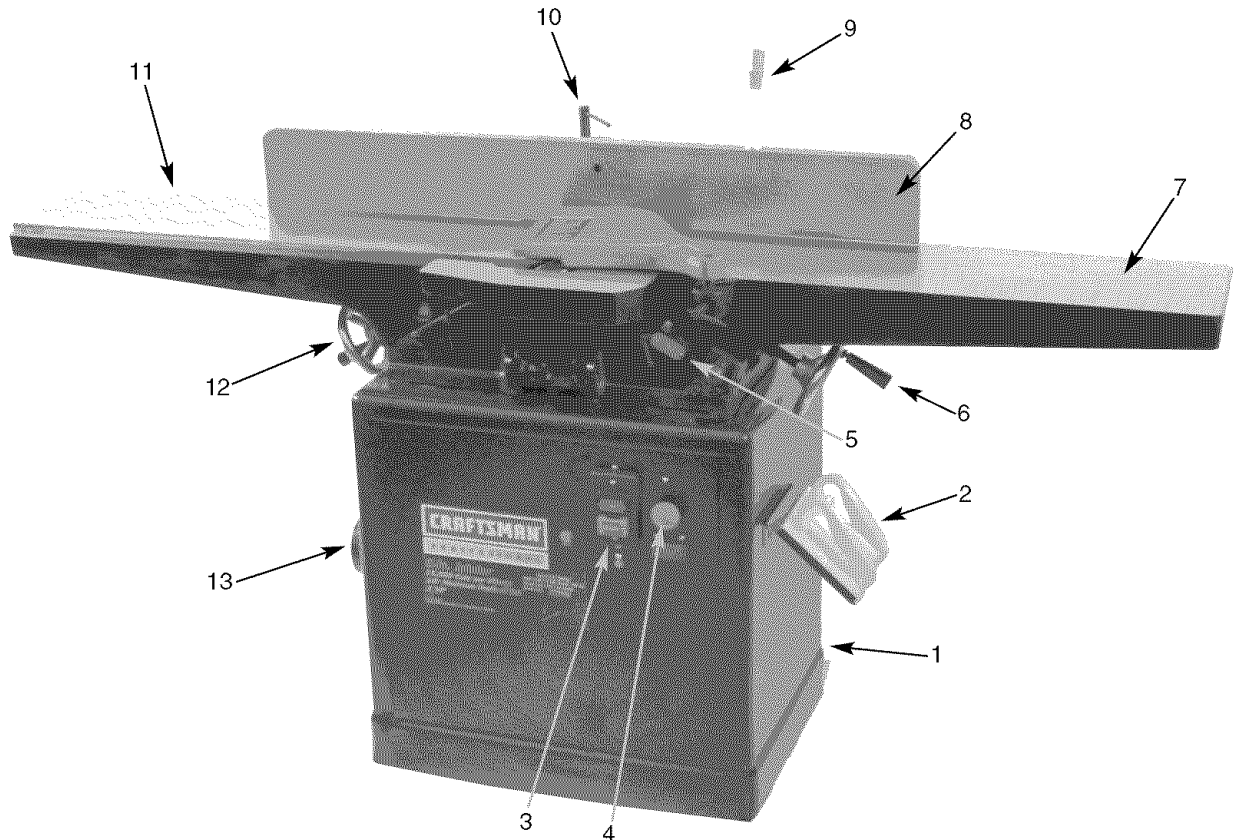
**OVERLOAD PROTECTION**

The magnetic contactor has overload protection that helps to prevent damage to the motor. The overload protection will automatically turn off the magnetic contactor when an overload occurs. Be sure to disconnect jointer from power source when resetting overload protector. The protection is reset by opening the contactor box and pressing the reset button.

**CHECK CONNECTIONS**

- Plug in the line cord to a 230 volt power source.
- Turn and release the emergency stop button.
- Depress the start button. The motor must rotate counterclockwise facing shaft end.
- Depress the stop button. The motor must stop.
- Depressing the start button with the emergency stop button pressed down must not start the motor.
- If any of the above steps do not work properly, disconnect jointer from power source and recheck the connections.

## KNOW YOUR JOINTER



- |                              |                             |
|------------------------------|-----------------------------|
| 1 Stand                      | 8 Fence                     |
| 2 Push Blocks                | 9 Fence Grip                |
| 3 Start/Stop Switch          | 10 Fence Angle Lock Handle  |
| 4 Emergency Stop Switch      | 11 Outfeed Table            |
| 5 Depth Scale and Limit Stop | 12 Outfeed Table Hand Wheel |
| 6 Infeed Table Hand Wheel    | 13 Dust Collection Port     |
| 7 Infeed Table               |                             |

## OPERATION

Refer to Figures 7-14, pages 8-10 and 19.

Craftsman 8" Jointer is used to surface the faces and edges of boards, produce a flat surface on warped boards and shape rabbets, bevels, chamfers and tapers. The jointer features heavy cast iron infeed and outfeed tables with precision ground work surfaces and leadscrews for precise table height adjustments. Rigid, center mount guide fence is fully adjustable and is provided with positive stops at 45, 90, and 135° positions. Jointer Stand includes chip chute with 4" adapter for dust collection and safety electrical control that reduces the risk of accidental start-up. Includes 2 HP, 3450 RPM motor.

## SPECIFICATIONS

Table size	70½ x 9¼"
Fence size	40 x 5"
Blade size (3)	8¼ x 15/16 x 1/8"
Maximum cut	1/8" Deep
Overall dimension	96¼ x 25 x 36"
Dust collection port	4" Diameter
Motor	2HP, 3450 RPM

Jointing: This is a surfacing operation in which a small amount of wood is removed from the edges and faces of boards to get smooth, straight and even surfaces, such that two edges running across the planing blades would fit together perfectly, forming a seamless joint.

- Do not perform jointing operations on material shorter than 10", narrower than ¾", or less than ¼" thick.
- Never make jointing cuts deeper than 1/8".
- Always keep cutter head and blade guards in proper working condition.

- Maintain the proper relationships of infeed and outfeed table surfaces and cutter head blade path.
- Do not back the work toward the infeed table.
- Support the workpiece adequately at all times during operation; maintain control of the workpiece.
- Use hold-down/push blocks for jointing material narrower than 3".
- 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, and the like.

**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.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures vary, 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. Always wear **MSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

The Craftsman jointer can produce a smooth surface on any lumber. Precision of cut will only be as accurate as the settings.

## OPERATING CONTROLS

### ON, OFF AND EMERGENCY STOP SWITCHES

Refer to Figure 7.

- The Emergency Stop Switch is located to the right of the ON and OFF switches.
- Push the switch cover UP to access the ON and OFF switches.
- ON switch is green and marked "I", OFF switch is red and marked "O".
- Pressing the Emergency Stop or OFF will turn off the machine. The Emergency Stop Switch will need to be twisted and released before the jointer can be restarted.

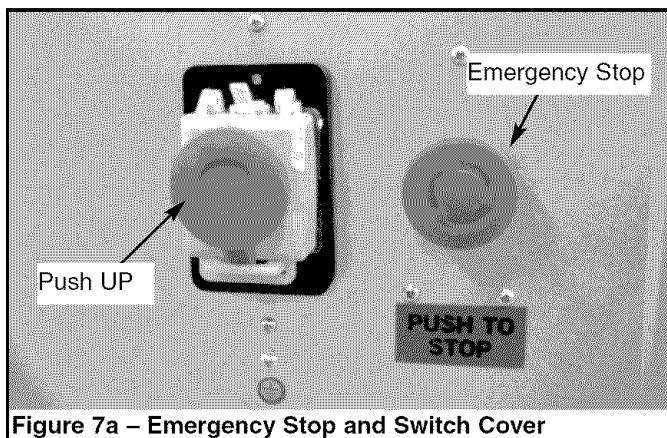


Figure 7a – Emergency Stop and Switch Cover

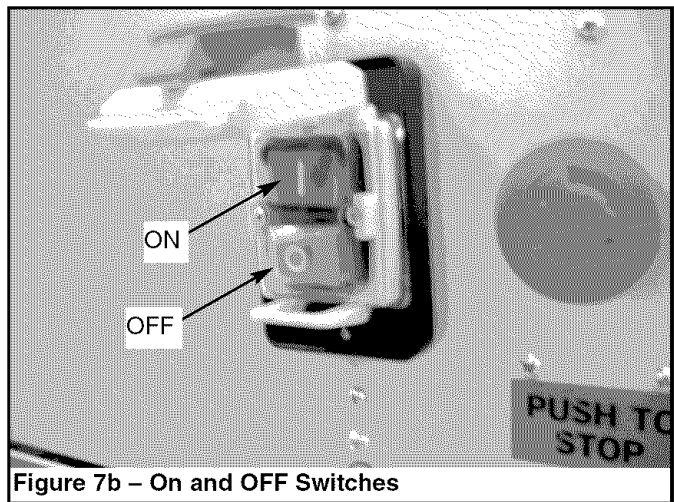


Figure 7b – On and OFF Switches

### POSITIONING FENCE

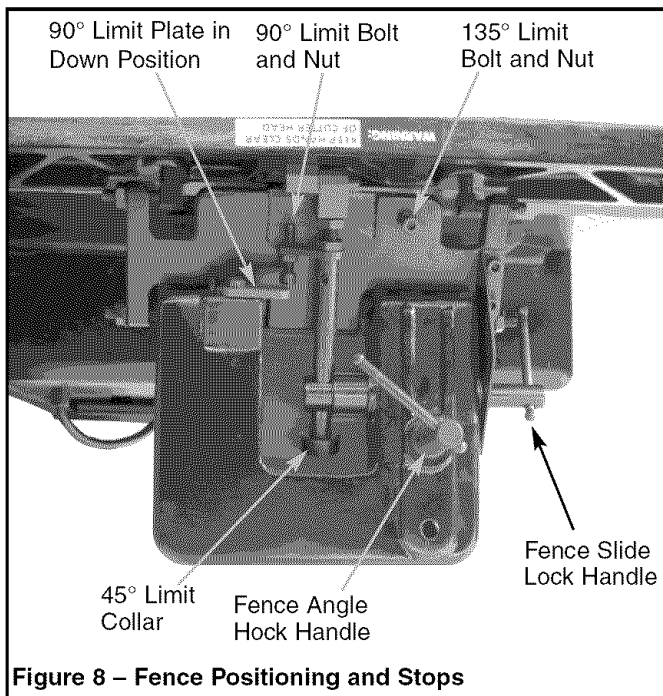
Refer to Figures 8 (page 9) and 15.

- Fence is usually set at 90° to the table for producing square lumber.
- Fence can be positioned anywhere from an inward 45° to an outward 45°.
- The angle position is locked by fence angle lock handle (Key No. 19).
- Fence grip (Key No. 3) is used to change the fence angle.
- Collar (Key No. 12) should be adjusted to stop the fence at the inward 45° position.
  - Use angle gauge provided to check or set the inward 45° position.
  - Make sure the position of collar is locked with set screw (Key No. 13).
- The 90° position is stopped when socket head bolt (Key No. 2) contacts stop plate (Key No. 22).
  - The stop plate must be in the DOWN position to make contact with bolt.
  - Use angle gauge provided to check or set the 90° position.
  - Make sure the position of the bolt is locked with nut (Key No. 9).
- The outward 45° (135°) position is stopped by the hex bolt (Key No. 8).

**CAUTION:** Make sure the stop plate (Key No. 22) is in the UP position (vertical) before attempting to set fence at outward 45° (135°) position.

- Use angle gauge provided square to check or set the outward 45° (135°) position.
- Make sure position of stop is locked with nut (Key No. 9).
- Fence can be positioned to expose desired length of blade.
  - Guide position is fixed by fence slide lock handle (Key No. 19).
  - When moving fence, lift with the grip (Key No. 3) while pulling T-bolt handle (Key No. 19) to avoid dragging the fence on the table.





**Figure 8 – Fence Positioning and Stops**

## ADJUSTING TABLE MOTION

Refer to Figure 14.

Both the infeed and outfeed table use a leadscrew, guided by adjustable wear plates.

- Release the position locking by loosening the T-handle bolt (Key No. 43).
- Raise and lower the table by turning handwheel (Key No. 31).
- Make sure that action is constant for entire length of travel. There should be a slight drag.
- To adjust drag loosen set screws and nuts (Key Nos. 27 and 42). Adjust set screws until a slight drag on table action is felt. Then hold set screw in position and tighten nut.
- After drag is adjusted and table is in desired position, secure table in position by tightening T-handle bolt.

## POSITIONING INFEEED TABLE

Refer to Figure 14.

The position of infeed table determines depth of cut. Infeed table also needs to be lowered to make certain adjustments.

- Positive stop prevents the table from being lowered more than 1/8" (Key No. 16).
- Table can be lowered past the stop (for rabbeting operation, etc.) by simultaneously pulling knob outward and turning table handwheel.

## ADJUSTING BLADE HEIGHT

Refer to Figure 14.

To produce an even surface on a workpiece, the blade edges must be the same distance from axis of cutter head. A blade gauge (Key No. 60) has been provided to make blade height adjustment easy.

- Lower the infeed table as far as it will go.
- Place the blade gauge so that it rests on the cutter head and straddles the blade.
- Loosen the five locking bolts (Key No. 6).
- Press the blade gauge firmly against the cutter head and make sure that the blade touches the contact points.
- If blade does not touch contact points or gauge does not touch cutter head, use the jack screws (Key No. 4) to adjust blade accordingly.
- Tighten the bolts to secure the blade in position.

## RABBETING

The jointer blades have a second blade on the outward radial edge. These edges must also be aligned to perform rabbeting.

- Make sure blades protrude the same distance from end of cutter head. The blades should not protrude more than 1/8".
- Use the blade gauge when repositioning blades to keep them adjusted as described in "Adjusting Blade Height".
- By repositioning the infeed table and fence, a wide range of rabbet joints can be cut.

**WARNING:** Rabbeting requires removal of blade guard. Blade guard must be replaced correctly when rabbeting is completed. (See Assembly, "Mount Blade Guard")

## ADJUSTING OUTFEED TABLE

The outfeed table supports the wood after it has been cut. Outfeed table will be set about .003" below the level of blade edge. The wood is compressed at the cut and the outfeed table must be adjusted to compensate for it.

- Raise outfeed table above height of blade.
- Position one blade edge point to the highest point on its path.
- Rest a straightedge on the table.
- Lower outfeed table until blade and straightedge contact.
- Gently rotate cutter head and allow it to move the straightedge. Blade should pull the straight edge with out visibly lifting it from the table.
- Make sure all blades move the straightedge the same amount. Also check both sides of blade. If all blades do not line up, blade height should be readjusted.
- Lock outfeed table position with the T-handle bolt (Figure 14, Key No. 43). Position should not need to be changed.
- Proper adjustment of outfeed table can also be determined by examining the cut (See Figure 9, page 10).

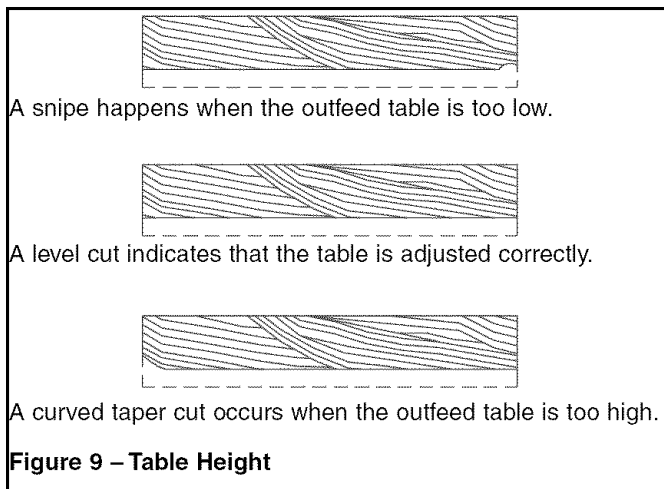
## CHECKING BLADE HEIGHT

Refer to Figure 9.

Once outfeed table is set, a straightedge can be used to check blade height.

- Follow the procedure described above in “Adjusting Outfeed Table”.
- This examination should be performed each time before unit is used.
- When blades do not contact the straightedge, blades are dull.
- Although the outfeed table may be lowered to compensate for dull blades, the quality of cut will be reduced (See Maintenance).

**WARNING:** Using dull blades reduces life of blades and creates greater wear on all machine parts.

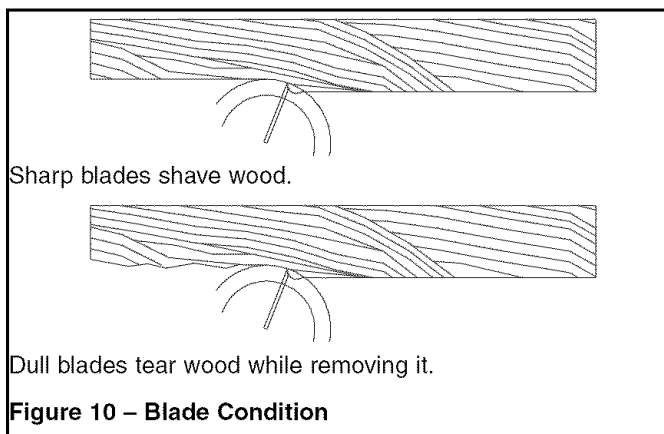


## CHECKING FOR WORN BLADES

Refer to Figure 10.

Condition of blades will affect precision of cut. If blade wear is not observed when checking the blade height, the quality of cut will indicate the blade condition.

- Dull blades will tear rather than sever the wood fiber.
- A raised grain will occur when dull blades pound on wood where there is difference in density.
- A raised ridge will be produced where the blades have been nicked.



## AVOID DAMAGE TO BLADES

Jointer is a precision woodworking machine and should only be used on quality lumber. Jointing bad lumber could result in a poor quality cut on subsequent pieces.

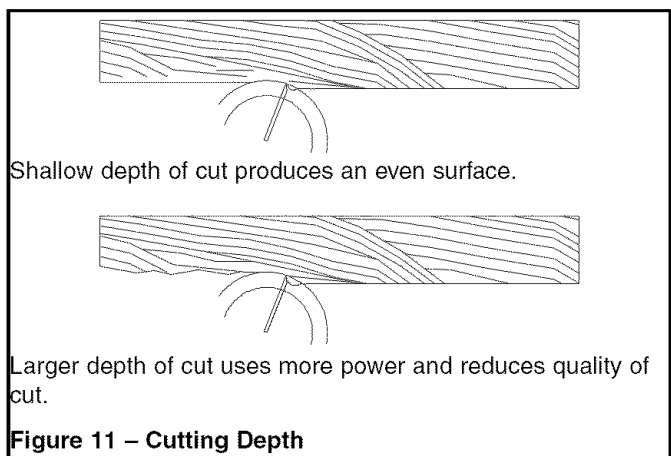
- Do not plane dirty boards. Dirt and stones are abrasive and will wear blades.
- Remove nails and staples. Jointer should only cut wood.
- Avoid knots. Heavy cross-grain makes knots hard and they can come loose and jam the jointer.
- Assess value of badly warped boards; operator can be tempted to use too deep of cut to square boards quickly. When work is finished board is not useful size.

## CUTTING DEPTH

Refer to Figure 11.

The surface that a jointer will produce will be smoother if shallower depth of cut is used. The positive stop for a 1/8" cut indicates the intended maximum depth of cut.

- Warped boards should not be cut in one pass. Use several passes to maintain a level surface.
- Plane alternate sides of a board, each at half the desired depth of cut; this will create a more even moisture content in the wood and help prevent future warpage.
- Deep cuts require more power and cause greater wear on all machine parts.



## FEEDING WORK

Refer to Figure 12, page 11.

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

- Keep enough pressure to hold work to both tables and fence.
- Use push blocks to hold wood onto both the infeed and outfeed tables and be careful not to push on wood above blades.
- Push work across blades by using push blocks with a walking motion.

**WARNING:** Always keep at least one block on the wood to prevent kickback.

- Support work on both infeed and outfeed tables. Over half the board must rest on tables before and after cut to keep wood from tilting off table. Use roller extension or stand when long boards are jointed (See Recommended Accessories, page 19).
- Feed wood in grain direction (See Figure 11). Wood fed against grain will result in chipped and splintered edges. Sometimes grain will switch direction in the middle of a length of board. If possible, cut board before jointing.

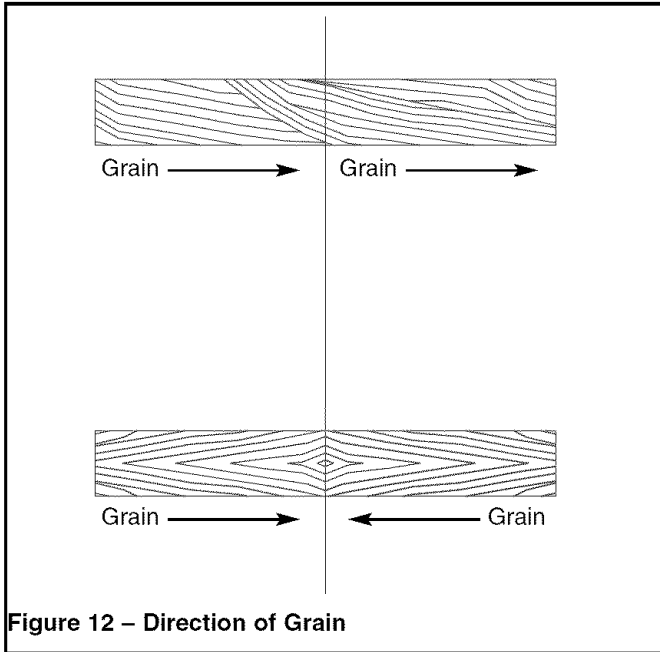


Figure 12 – Direction of Grain

## MAINTENANCE

Jointer will operate best if it is kept in good operating condition. Keep unit adjusted as described in “Operation.” Also, blades must be kept clean and sharp to ensure quality of cut and efficiency of operation.

**WARNING:** Make certain that unit is disconnected from power source before servicing.

### BLADE CARE

- Gum and pitch will collect on blades and cause excess friction when working.
- Blades will overheat and wear at an accelerated rate. Use a gum and pitch remover to keep blades clean.
- Blades can be kept sharp by whetting them with a fine sharpening stone.
  - Partially cover the stone with paper to protect the table top.
  - Position infeed table so stone will contact blade along its beveled surface.
  - Stroke the stone across blade from one side to other while stone is also moved slightly in the direction of feed.
  - Make sure to do the same number of strokes on each blade.
- Blades that are noticeably nicked or worn must be resurfaced to a new beveled edge. Remove blades (one at a time).
  - Lower infeed table.
  - Hold blades with blade gauge.
  - Loosen bolts (Figure 14, Key No. 6).
  - Remove blade.

**NOTE:** Many shops do not have capability to resurface blades. Yellow Pages should list Sharpening Services or Tool Grinding.

- Sometimes replacing blades is less expensive than resurfacing them. Keeping a spare set of blades on hand is recommended. Blades should always be sharpened or replaced in sets of three.

### LUBRICATION

- Motor and cutter head bearings are sealed and need no lubrication.
- Fence guide and table leadscrews should be cleaned of debris and greased as needed.
- Occasionally apply a few drops of light machine oil to gibs to keep tables sliding free in relation to base.

### MACHINED SURFACES

- Surface of tables and fence should be kept smooth and clean for easy work feed.
- Apply a paste wax to surfaces to keep them slick and to prevent corrosion.

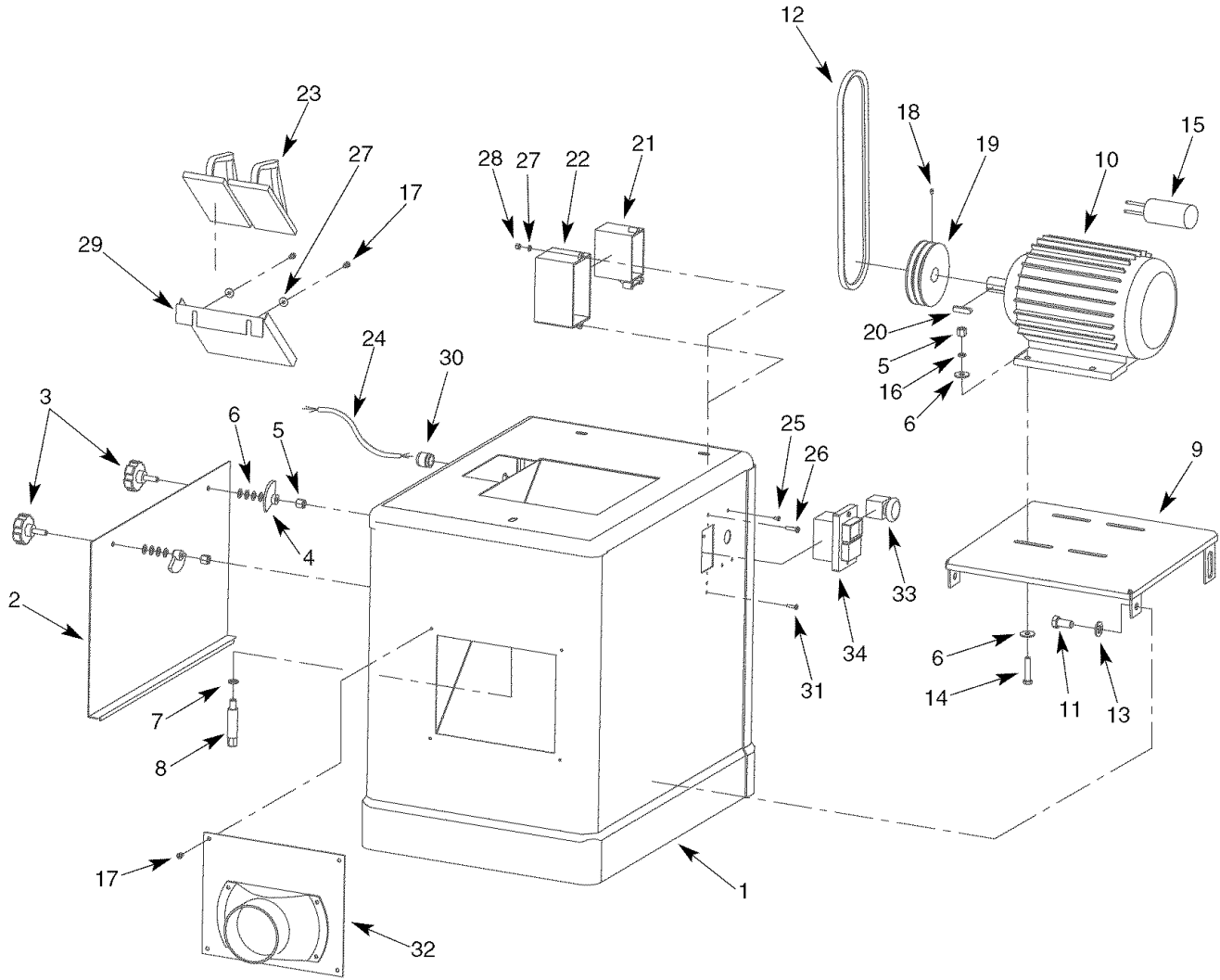
## TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE(S)	CORRECTIVE ACTION
Snipe gouging at ends of board)	<ol style="list-style-type: none"> <li>1. Dull Blades</li> <li>2. inadequate support of long boards</li> <li>3. Uneven feed</li> <li>4. Outfeed table is not aligned</li> <li>5. Extension rollers misaligned</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace or sharpen blades; See "Blade Care", page 11</li> <li>2. Support long boards</li> <li>3. See "Feeding Work", page 10</li> <li>4. Check outfeed table position</li> <li>5. Adjust extension rollers</li> </ol>
Fuzzy grain	<ol style="list-style-type: none"> <li>1. Planing wood with a high moisture</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove high moisture content from wood by drying</li> </ol>
Torn grain	<ol style="list-style-type: none"> <li>1. Too heavy a cut</li> <li>2. Blades cutting against grain</li> <li>3. Dull blades</li> </ol>	<ol style="list-style-type: none"> <li>1. See "Cutting Depth", page 10</li> <li>2. See "Feeding Work", page 10</li> <li>3. Replace or sharpen blades See "Blade Care", page 11</li> </ol>
Rough raised grain	<ol style="list-style-type: none"> <li>1. Dull blades</li> <li>2. Too heavy a cut</li> <li>3. Moisture content too high</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace or sharpen blades; See "Blade Care", page 11</li> <li>2. Review "Cutting Depth", page 10</li> <li>3. Dry wood or use dry wood</li> </ol>
Uneven depth of cut, side to side	<ol style="list-style-type: none"> <li>1. Blade height not uniform</li> <li>2. Fence not perpendicular to jointer bed</li> </ol>	<ol style="list-style-type: none"> <li>1. See "Adjusting Blade Height", page 9</li> <li>2. See "Positioning Fence, page 8</li> </ol>
Table elevation adjusts with difficulty	<ol style="list-style-type: none"> <li>1. Wear plate not adjusted</li> <li>2. Leadscrew dirty</li> <li>3. Leadscrew worn</li> <li>4. Friction between base and tables</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust wear plates</li> <li>2. Clean and lubricate leadscrews</li> <li>3. Replace leadscrew</li> <li>4. Clean, lubricate</li> </ol>
Depth of cut does not match scale	<ol style="list-style-type: none"> <li>1. Indicator not set correctly</li> <li>2. Blade projection incorrect</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust indicator, securely tighten</li> <li>2. Set blade projection correctly; See "Adjusting Blade Height", page 9</li> </ol>
Will not start/reset	<ol style="list-style-type: none"> <li>1. Not plugged in</li> <li>2. Circuit breaker/fuse</li> <li>3. Motor failure</li> <li>4. Loose wire</li> <li>5. Contactor overload tripped</li> <li>6. Contactor overload tripped</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power source</li> <li>2. Check power source, replace fuse</li> <li>3. Have motor checked by qualified electrician</li> <li>4. Having wiring checked by a qualified electrician</li> <li>5. Have qualified electrician replace</li> <li>6. Reset contactor overload by pressing reset button on contactor</li> </ol>
Motor stoppage. Fuses are blown or circuit breakers are tripped repeatedly	<ol style="list-style-type: none"> <li>1. Unit overload</li> <li>2. Fuses or circuit breakers do not have sufficient capacity</li> <li>3. Circuit overload</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load</li> <li>2. Connect unit to circuit with adequate amp rating or install proper size fuses or breakers</li> <li>3. Reduce the load. Do not use other appliances or motor on same circuit when using jointer</li> </ol>
90° and 45° cuts inaccurate	<ol style="list-style-type: none"> <li>1. Fence stops not adjusted properly</li> <li>2. Fence bottom not even with outfeed table due to wood chips under fence</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust fence stops. See "Positioning Fence", page 8.</li> <li>2. Clean wood chips from underside of fence.</li> </ol>

## NOTES

# Model 351.217030

## Figure 13 - Replacement Parts Illustration for Stand



## REPLACEMENT PARTS LIST FOR STAND

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	N/A	Stand	1
2	23202.00	Door	1
3	23203.00	Knob	2
4	23204.00	Latch	2
5	STD840812	8-1.25mm Hex Nut*	6
6	STD851008	8mm Flat Washer*	16
7	STD851010	10mm Flat Washer*	3
8	23205.00	Locking Stud	3
9	23206.00	Motor Mounting Plate	1
10	23207.00	Motor (Includes Key No. 15)	1
11	16311.00	12-1.75 x 25mm Socket Head Bolt	4
12	23278.00	V-Belt	2
13	STD851012	12mm Flat Washer*	4
14	STD870840	8-1.25 x 40mm Socket Head Bolt*	4
15	23277.00	Capacitor 200MFD	1
16	STD852008	8mm Lock Washer*	4
17	STD863508	5-0.8 x 8mm Pan Head Screw*	6
18	01516.00	5-0.8 x 8mm Set Screw	1
19	23208.00	Motor Pulley	1
20	23209.00	8 x 7 x 32mm Key	1
21	23210.00	Cover	1
22	23211.00	Cover	1
23	23212.00	Push Block	2
24	23213.00	Line Cord	1
25	23214.00	3.5 x 9.5mm Threadforming Screw	3
26	STD863520	5-0.8 x 20mm Pan Head Screw*	2
27	STD851005	5mm Flat Washer*	4
28	STD840508	5-0.8mm Hex Nut*	2
29	23215.00	Storage Shelf	1
30	23216.00	Strain Relief	1
31	STD863416	4-0.7 x 16mm Pan Head Screw*	2
32	23217.00	Dust Collection Port	1
33	23218.00	Emergency Stop Switch	1
34	23219.00	On/Off Switch	1
Δ	23056.00	Operator's Manual	1

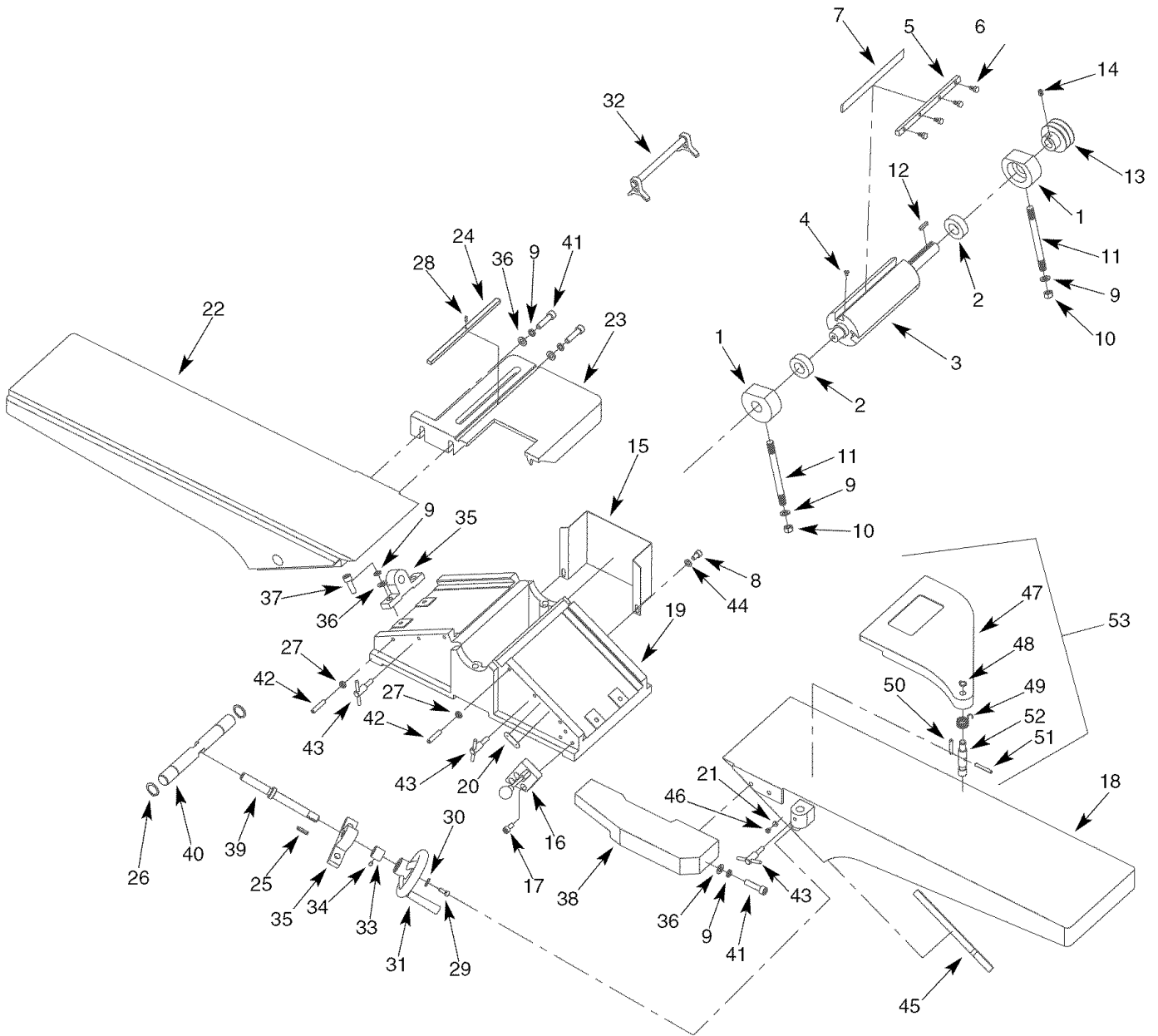
\* Standard hardware item available locally

N/A Not available as replacement part

Δ Not shown

# Model 351.217030

## Figure 14 - Replacement Parts Illustration for Jointer





## REPLACEMENT PARTS LIST FOR JOINTER

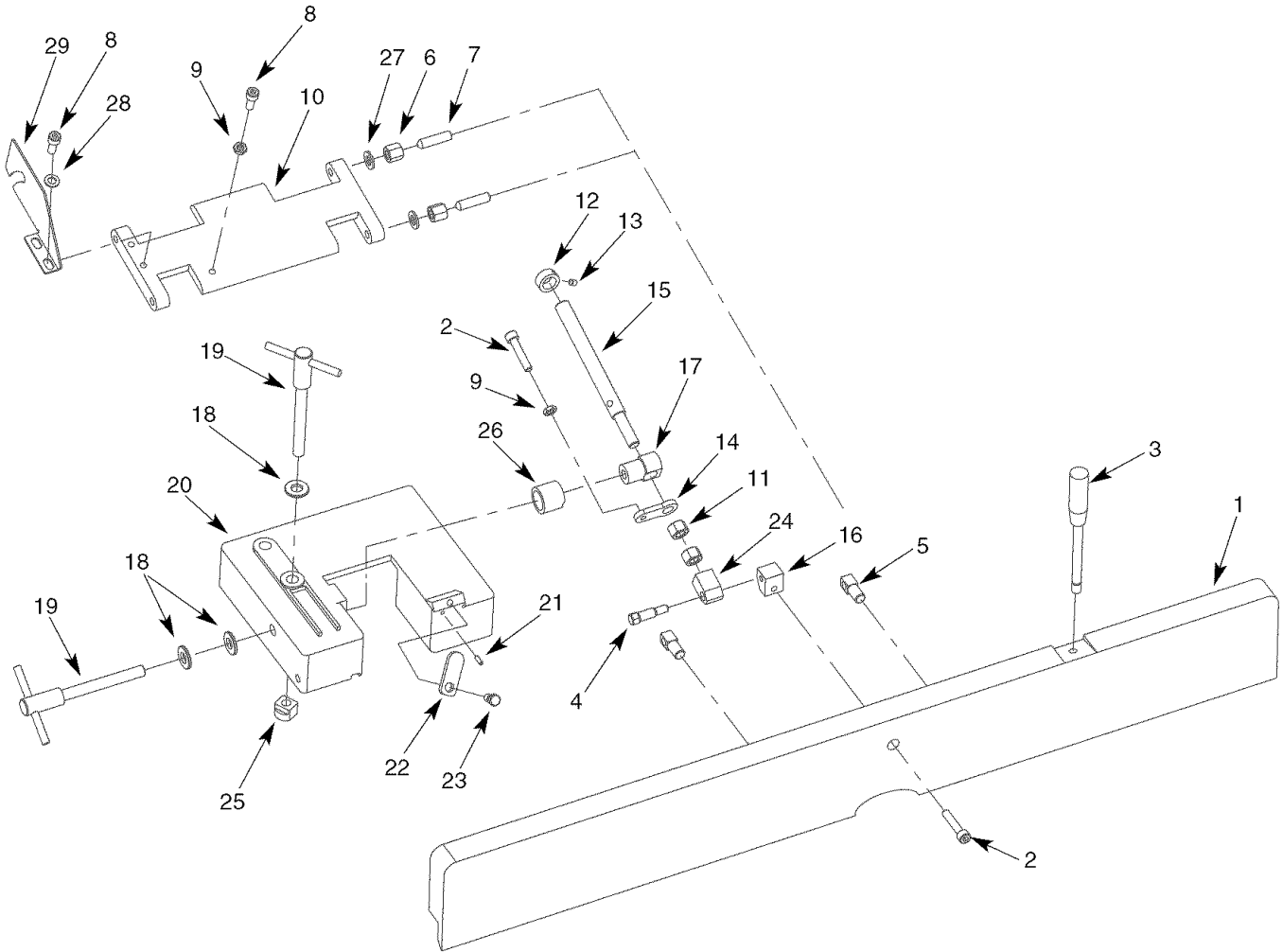
KEY			
NO.	PART NO.	DESCRIPTION	QTY.
1	23240.00	Bearing Housing	2
2	STD315241	6204ZZ Ball Bearing*	2
3	23241.00	Cutter Head	1
4	23242.00	Jack Screw	6
5	23243.00	Blade Lock Bar	3
6	23244.00	Blade Lock Bolt	12
7	23245.00	Blade (Set of 3)	1
8	02661.00	8-1.25 x 14mm Socket Head Bolt	2
9	STD852010	10mm Lock Washer*	10
10	STD841010	10-1.5mm Hex Nut*	2
11	23246.00	Threaded Stud	2
12	00975.00	5 x 5 x 25mm Key	1
13	23247.00	Driven Pulley	1
14	01516.00	5-0.8 x 8mm Set Screw	1
15	23248.00	Belt Guard	1
16	23255.00	Depth Stop Assembly	1
17	STD870816	8-1.25 x 16mm Socket Head Bolt*	3
18	23249.00	Infeed Table	1
19	N/A	Base	1
20	23266.00	Scale	1
21	23267.00	Pointer	1
22	23272.00	Outfeed Table	1
23	23273.00	Fence Guide Table	1
24	23274.00	Guide Bar	1
25	23256.00	5 x 5 x 32mm Key	1
26	01900.00	3AMI-25 Retaining Ring	4
27	STD840812	8-1.25mm Hex Nut*	4

KEY			
NO.	PART NO.	DESCRIPTION	QTY.
28	08634.00	4 x 12mm Spring Pin	1
29	STD870616	6-1.0 x 16mm Socket Head Bolt*	2
30	STD851006	6mm Flat Washer*	2
31	23257.00	Handwheel Assembly	2
32	23275.00	Blade Gauge Assembly	1
33	23259.00	Collar	2
34	06983.00	6-1.0 x 8mm Set Screw	4
35	23276.00	Shoulder Bracket	2
36	STD851010	10mm Flat Washer*	8
37	07186.00	10-1.5 x 30mm Socket Head Bolt	4
38	23260.00	Table Arm	1
39	23261.00	Leadscrew	2
40	23262.00	Leadscrew Bracket	2
41	05367.00	10-1.5 x 40mm Socket Head Bolt	4
42	23263.00	8-1.25 x 40mm Set Screw	4
43	23264.00	T-Handle Bolt	3
44	STD851008	8mm Flat Washer*	2
45	23265.00	Wear Plate	2
46	STD863506	5-0.8 x 6mm Pan Head Screw*	1
47	23268.00	Blade Guard with Label	1
48	00519.00	3AMI-12 Retaining Ring	1
49	23269.00	Spring	1
50	07825.00	6 x 35mm Spring Pin	1
51	02752.00	6 x 40mm Spring Pin	1
52	23270.00	Guard Shaft	1
53	23271.00	Blade Guard Assembly (incl. Key Nos. 47-52)	1

\* Standard hardware item available locally  
 N/A Not available as replacement part

# Model 351.217030

## Figure 15 - Replacement Parts Illustration for Fence



## REPLACEMENT PARTS LIST FOR FENCE

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	23221.00	Fence	1
2	STD870840	8-1.25 x 40mm Socket Head Bolt*	2
3	23223.00	Fence Grip	1
4	23239.00	Shoulder Bolt	1
5	23224.00	Pivot Connector	2
6	STD841010	10-1.5mm Hex Nut*	4
7	23403.00	10-1.5 x 40mm Cone Point Set Screw	4
8	STD870820	8-1.25 x 20mm Socket Head Bolt*	3
9	STD840812	8-1.25mm Hex Nut*	2
10	23225.00	Link	1
11	STD841217	12-1.75mm Hex Nut*	2
12	23226.00	Collar	1
13	06983.00	6-1.0 x 8mm Set Screw	1
14	23227.00	Plate	1
15	23228.00	Adjustment Bar	1
16	23229.00	Fence Block	1
17	23230.00	Clamp	1
18	STD851012	12mm Flat Washer*	3
19	23231.00	T-handle Bolt	2
20	23232.00	Fence Guide Box	1
21	08634.00	4 x 12mm Spring Pin	3
22	23233.00	Stop Plate	1
23	23234.00	Bolt	1
24	23235.00	Connecting Block	1
25	23236.00	Nut	1
26	23237.00	Sleeve	1
27	STD851010	10mm Flat Washer*	4
28	STD851008	8mm Flat Washer*	2
29	23284.00	Guard	1
Δ	23238.00	Angle Gauge	1

\* Standard hardware item available locally

Δ Not shown

Recommended Accessories		
Δ	Roller Table	9-22242
Δ	Support Stand	9-21417
Δ	Push Block Set	9-23000

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