



# Operating Instructions and Parts Manual

## 8-inch Woodworking Jointer

Model JWJ-8HH-BLK



**JET**  
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**Part No. M-JT1-1373**  
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# 1.0 Warranty and Service

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

### Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

### Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

### What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

### Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

### How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

### More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

### How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

### Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

### Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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### 3.0 Safety Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This jointer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a jointer, do not use until proper training and knowledge have been obtained.
5. Do not use this jointer for anything other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. This machine has an industrial-grade low-friction corrosion-resistant coating we call JET Black. This coating is on the infeed and outfeed tables and the fence. While the JET Black coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance.
7. Always wear approved safety glasses/face shields while using this jointer. Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.
8. Before operating this jointer, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
9. Wear ear protectors (plugs or muffs) if noise exceeds safe levels.
10. Do not operate this machine while tired or under the influence of drugs, alcohol, or any medication.
11. Make certain switch is in OFF position before connecting machine to power supply.
12. Make certain machine is properly grounded.
13. Make all machine adjustments or maintenance with machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep work area clean. Keep floor around machine clean and free of scrap material, oil, and grease. Dirty and cluttered floors invite accidents.
19. Keep visitors a safe distance from the work area. Keep children away.
20. Make your workshop child proof with padlocks, master switches, or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation, and "horse-play" are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall, slip, or lean into the knives. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain control of workpiece at all times. Make sure the work piece is stabilized during operation. Firmly hold workpiece down against table while jointing. Always use a hold-down or push block when surfacing stock.
26. When working a piece of wood on the jointer, follow the 3-inch rule: The fingers and hands must never be closer than 3 inches to the cutterhead at any time.
27. Do not joint material shorter than 10-inches, narrower than 3/4-inch, or less than 1/4-inch thick.
28. Do not make cuts deeper than 1/8-inch for jointing cuts and 1/16-inch for planing cuts. Deeper cuts could overload the machine and increase the chance of kickback.
29. Never apply pressure to stock directly over the cutterhead. This may result in the stock tipping

- into the cutterhead along with the operator's fingers.
30. Never back the workpiece toward the infeed table.
  31. Always keep cutterhead and guards in place and in proper working order.
  32. Always use hold-down/push blocks for jointing material narrower than 3 inches, or thinner than 3 inches.
  33. Maintain the proper relationships of infeed and outfeed table surfaces and cutterhead knife path.
  34. Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table 1 of Section 8.3 *Extension Cords* shows correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
  35. Turn off the machine and disconnect from power source before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
  36. Do not stand on the machine. Serious injury could occur if the machine tips over.
  37. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
  38. Remove loose items and unnecessary work pieces from the area before starting the machine.
  39. Do not use in dangerous environment. Don't use jointer in damp or wet locations or expose to rain. Keep work area well lighted.
  40. Allow machine to reach operating speed before use.
  41. Maintain tools with care. Keep knives sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.

**Familiarize yourself with the following safety notices used in this manual:**



This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.



This means that if precautions are not heeded, it may result in serious, or possibly even fatal, injury.

## SAVE THESE INSTRUCTIONS

### 4.0 About this Manual

This manual is provided by JET covering the safe operation and maintenance procedures for a JET Model JWJ-8HH-BLK Jointer. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. You can also reach us at our web site: [www.jettools.com](http://www.jettools.com).

Register your product using the mail-in card provided or register online:

[www.jettools.com/product-registration](http://www.jettools.com/product-registration)

**To quickly reach the product registration webpage, scan the QR code below.**



**Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!**

## 5.0 Specifications

Model .....	JWJ-8HH-BLK
Stock Number .....	JT1-1373
Motor .....	TEFC 2 HP, 230V, 60Hz, 1 PH
Full Load Amps .....	9A
Starting Amps.....	38A
Running Amps.....	2.94A
Motor Speed.....	3400 RPM
Cutting Capacity.....	8"
No Load Cutterhead Speed .....	5500 RPM
Full Width Cutting Depth .....	1/8"
Helical Cutter Head .....	4 Rows, 36 Four-Sided Inserts
Cutter Head Diameter .....	2-15/16"
Table Size (overall) .....	9-1/2" W x 70-7/8" L
Infeed Table Length .....	34-11/16"
Outfeed Table Length .....	34-11/16"
Fence .....	5" H x 40-1/2" W
Fence Tilting.....	45°L, 90°, 135°
Positive Stops .....	45°L, 90°, 45°R
Height, Floor to Outfeed Table.....	33"
Dust Port Diameter.....	4"
Net Weight, approximate .....	405 lbs.
Shipping Weight, approximate .....	472 lbs.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

# 6.0 Features

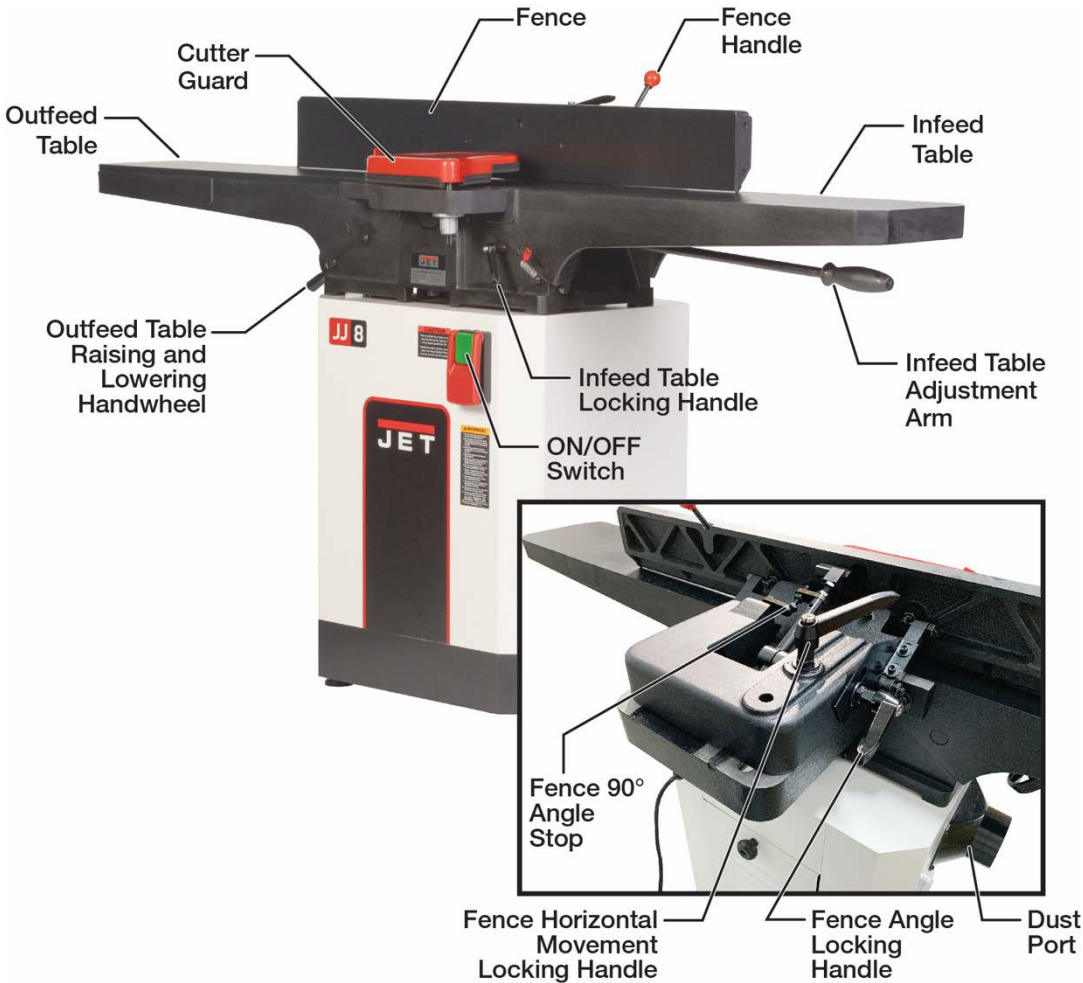


Figure 6-1

## 7.0 Setup and Assembly

**⚠WARNING** Do not connect machine to power source before or during setup and assembly.

**⚠CAUTION** This machine has an industrial-grade low-friction corrosion-resistant coating on the infeed and outfeed tables and the fence. While the coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance. Use care when unpacking and locating the machine and during all setup and assembly procedures.

Your new jointer is shipped in two cartons: the stand carton and the jointer carton. Carefully unpack the stand, jointer, and any loose items. Inspect for damage. Any damage should be reported immediately to your distributor and shipping agent. Do not discard any shipping material until the jointer is assembled and running properly. Before proceeding further, read your manual thoroughly to familiarize yourself with proper assembly, maintenance and safety procedures.

Remove the protective coating from the cutterhead and loose items packed with the machine. This coating may be removed with a soft cloth moistened with Kerosene. Do not use acetone, gasoline or lacquer thinner for this purpose. Do not use solvents on plastic parts.

Compare the contents of your cartons with the following parts list to make sure all parts are included. Missing parts, if any, should be reported to your distributor.

### 7.1 Shipping Contents

The items below are shipped with the jointer.

#### Stand Contents (Figure 7-1):

- 1 – Stand with Motor – A
- 1 – Dust Port – B
- 4 – Dust Port Mounting Hardware – C
- 4 – Rubber Feet with M10 Hex Nuts – D
- 1 – Stand Door (not shown)

#### Jointer Contents (Figure 7-2):

- 1 – Bed Assembly – E
- 1 – Cutterhead Guard Assembly – F
- 1 – Belt Guard Assembly - G
- 1 – Fence Base Assembly – H
- 2 – Drive Belts - I
- 3 – Hex Cap Screws, M10 x 20 – J
- 3 – Lock Washer, 10mm – K
- 3 – Flat Washer, 10mm - L
- 1 – Lifting Bar Assembly – M
- 1 – Handwheel, Key, & Washer – N
- 1 – Fence Handle – P
- 1 – Fence – Q

- 2 – Push Blocks – R
- 6 – Hex Wrenches, 2.5, 3, 4, 5, 6, 8mm – S
- 1 – Locking Handle/Bolt – T
- 1 – Owner's Manual (not shown)
- 1 – Warranty Card (not shown)

#### Tools Contents (Figure 7-3):

- 2 – Star-Point Screwdrivers
- 5 – Knife Inserts
- 5 – Knife Insert Screws, M5 x 12

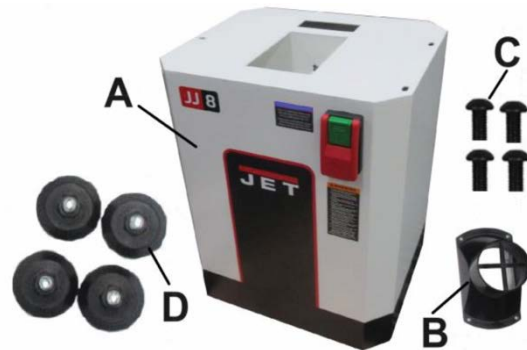


Figure 7-1



Figure 7-2



Figure 7-3



## 7.2 Assembly

**CAUTION** This machine has an industrial-grade low-friction corrosion-resistant coating on the infeed and outfeed tables and the fence. While the coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance. Use care when installing and assembling the machine.

### 7.2.1 Stand Assembly

Refer to Figures 7-4 through 7-7:

1. Turn door lock knob (A) counterclockwise to unfasten door. Pull the top of the door (B) out and lift the door from stand.
2. Look inside the stand and locate the welded nuts (C) used for mounting the rubber feet. Make sure the M10 hex nut is attached to the four rubber feet (D). Attach rubber feet to the bottom of cabinet (see Figure 7-6).
3. Attach dust port (E) to stand using four M5x10 screws (F).
4. Check stand for stability and level. Adjust the feet as needed.

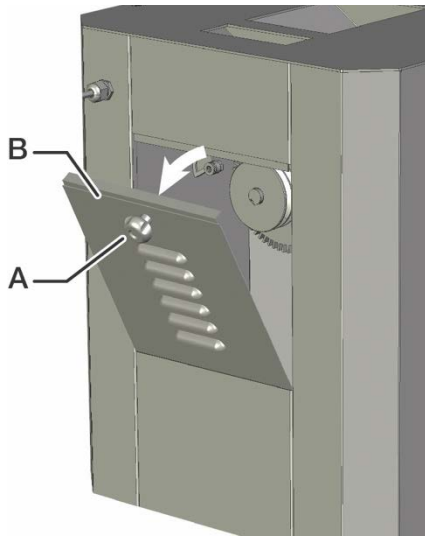


Figure 7-4

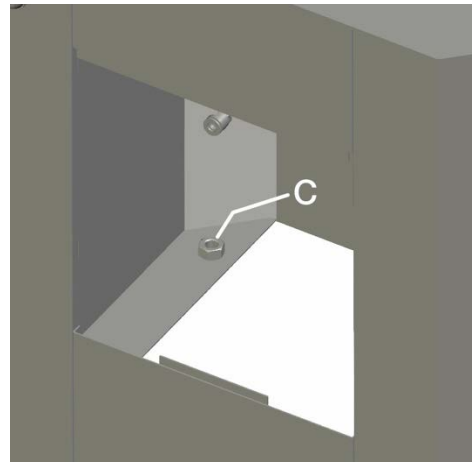


Figure 7-5

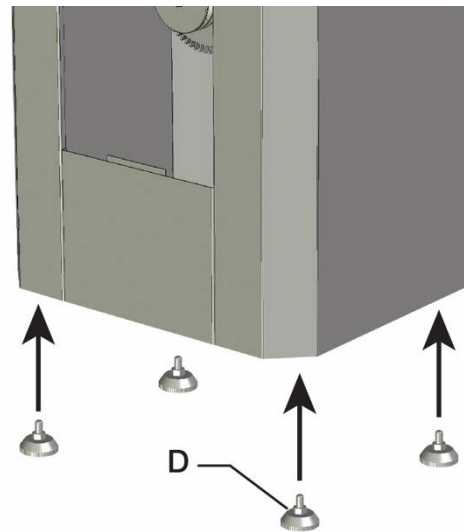


Figure 7-6

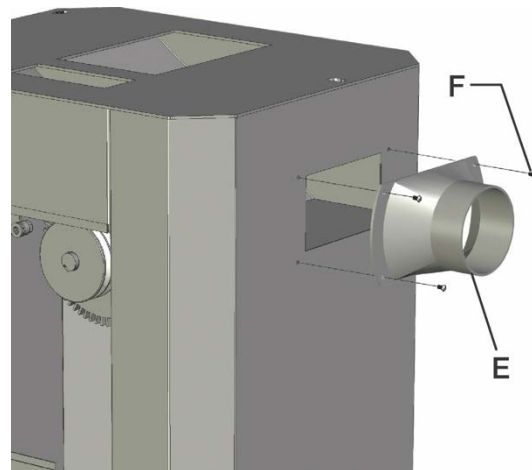


Figure 7-7

## 7.2.2 Installing Joints to Stand

**⚠WARNING** The jointer is heavy! Use great care and adequate resources when lifting the assembly out of the crate and onto the stand! Do not lift from the ends of the infeed and outfeed tables. Lift as close to the table seat as possible. Failure to comply may cause serious injury and/or damage to the jointer and/or property!

Refer to Figure 7-8:

1. Place the main jointer (A) onto the stand (B). Align the main jointer threaded mounting holes with the mounting holes on the stand top.
2. Using three M10 x 20 screws, 10mm lock washers, and 10mm flat washers (C), go through the bottom of the stand top and attach the main jointer to the stand.

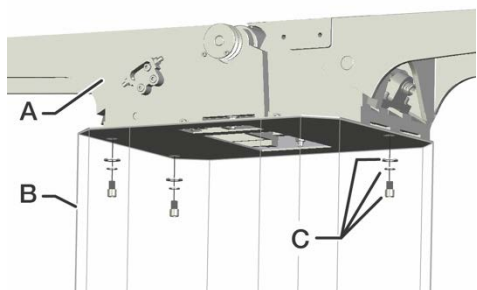


Figure 7-8

## 7.2.3 Installing Drive Belts

Refer to Figures 7-9 & 7-10 :

1. There are two drive belts (A). Install both belts over the cutterhead pulleys (B) and motor pulleys (C). You should be able to walk the belts onto the pulleys. If not, loosen the four motor mounting bolts (D) and slide the motor up to install belts. After belts are installed, move the motor down to properly tension the drive belts, then firmly tighten the motor mounting bolts.
2. Install the belt cover (E) to the jointer table assembly (F) using two M8x10 mounting screws and 8mm flat washers (G).

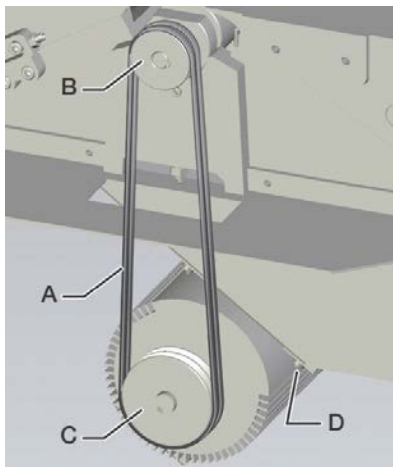


Figure 7-9

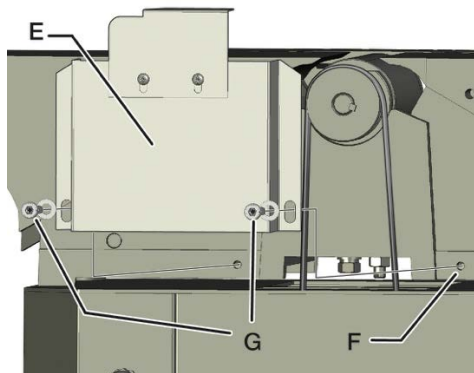


Figure 7-10

## 7.2.4 Installing Fence Base Assembly and Fence

### Fence Base Assembly

Refer to Figures 7-11A, 7-11B, & 7-11C:

1. Assemble two M10x35 mounting screws with 10mm lock washers and 10mm flat washers (A).
2. Insert mounting screws into threaded mounting holes (D & E) on the jointer table assembly. Turn mounting screws several times to hold them in place.
3. Align fence base assembly mounting slots (B & C) above mounting screws and slide down over screws. Make sure the flat washers/lock washers remain on the outside of the fence base assembly mounting plate.
4. Further tighten the mounting screws to be close to the fence base assembly mounting plate, but still loose.
5. Position the fence base assembly so that the top surface of the lower bed (F) is level with the outfeed table surface (G). Firmly tighten the mounting screws (A).
6. Reach beneath the lower bed (F) and hold the T-nut (J). Loosen and remove the shipping hex bolt (I) from the upper bed (H). Be careful not to drop and lose the T-nut.
7. Replace shipping hex bolt with locking handle/bolt (K, included in accessory bag). Thread the locking handle/bolt into the T-nut (J) beneath the lower bed (F).
8. Check the fence base assembly upper bed (H) clearance by loosening the upper bed adjustment lock handle (K) and slide the upper bed towards the jointer tables. The fence base assembly upper bed should clear the jointer outfeed table surface (G).

**IMPORTANT:** If the top surface of the fence base assembly lower bed (F) is not level with the outfeed table surface (G), damage to the outfeed table's JET Black coating could occur.

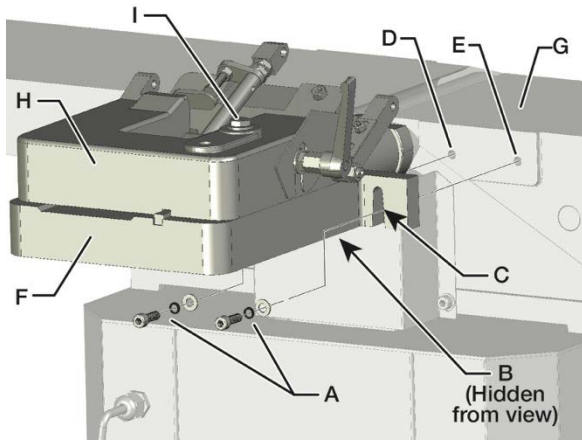


Figure 7-11A

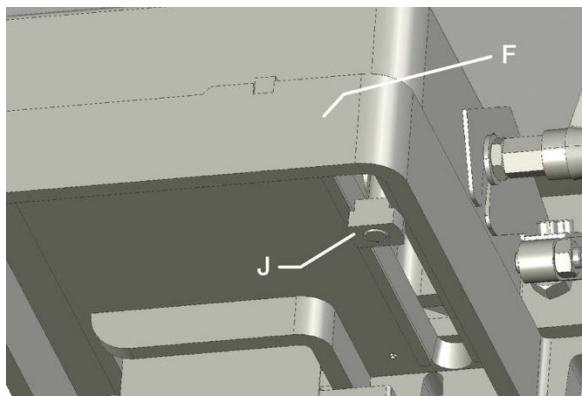


Figure 7-11B

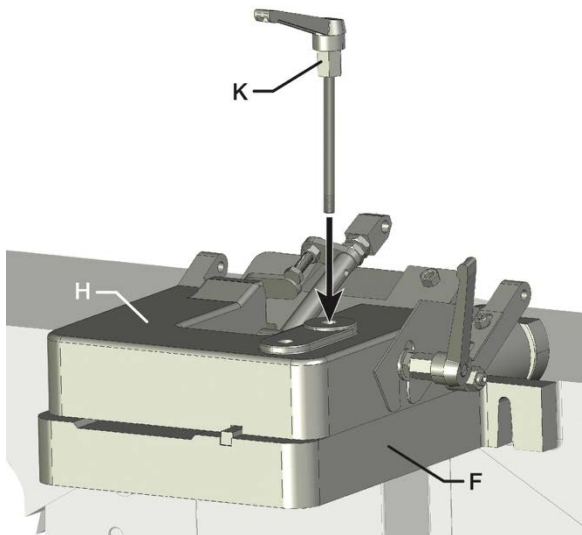


Figure 7-11C

## Fence

Refer to Figure 7-12:

1. Attach fence handle (A) to fence (B).
2. Loosen fence base assembly upper bed adjustment lock (C) and fence tilt adjustment lock (D).
3. Place fence on jointer table assembly. Make sure the protective fence pad blocks (E) are the only surfaces of the fence that contact the feed and outfeed tables.
4. Loosen and back out the two cone screws (F) on the fence base assembly tilt plate (G). Do not remove the cone screws but leave the cone tips exposed from their mounting holes.
5. Pull center arm support bar (H) to align support bar hinge block (I) with fence hinge block (J). Insert center arm hinge axle (K) through support bar hinge block (I) and fence hinge block (J).
6. Adjust fence (B), tilt plate (G), and fence base assembly upper bed (L) as needed to align tips of cone screws (F) with the horizontal holes in the two fence hinge axes (M).
7. Tighten both cone screws (F) until they seat into the horizontal holes of the two fence hinge axes (M). Lock cone screws in place by tightening two M10 hex nuts (N) against tilt plate.
8. Make sure fence 90° stop plate (O) is flipped down into place to contact the 90° stop bolt (P).
9. Using the fence handle (A), adjust the fence to a 90° angle. With a 90° square, check that the fence is 90° from the tables. If the fence is not at 90°, adjust the angle using the 90° stop bolt (P) and nut. When the 90° angle is correct, tighten the fence tilt adjustment lock (D).
10. Slide the fence bed assembly upper bed to the desired location and tighten the upper bed adjustment lock (C).

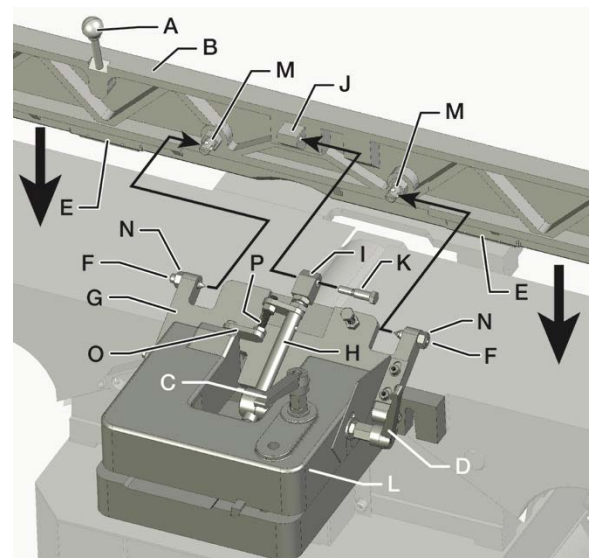


Figure 7-12

## 7.2.5 Installing Outfeed Table Adjustment Handwheel and Infeed Table Adjustment Handle

### Outfeed Table Adjustment Handwheel

Refer to Figures 7-13 & 7-14:

1. Place key (A) into key slot of the handwheel shaft (B).
2. Align key notch in handwheel (C) with key and handwheel shaft and slide handwheel onto shaft.
3. Attach handwheel to shaft using M6x10 screw and 6mm flat washer (D).

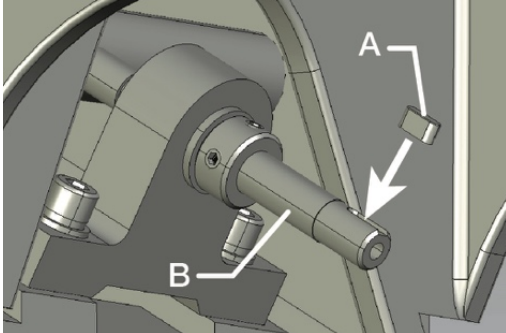


Figure 7-13

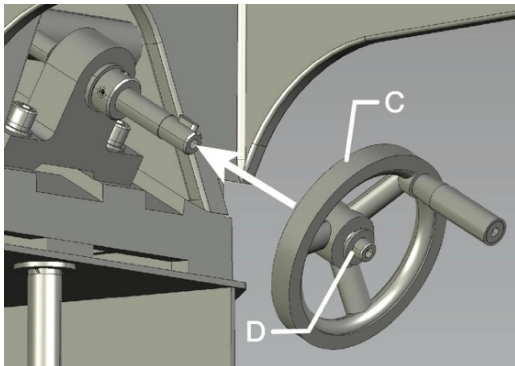


Figure 7-14

### Infeed Table Adjustment Handle

Refer to Figures 7-15:

1. Screw infeed table adjustment handle (A) into threaded mounting hole under infeed table.

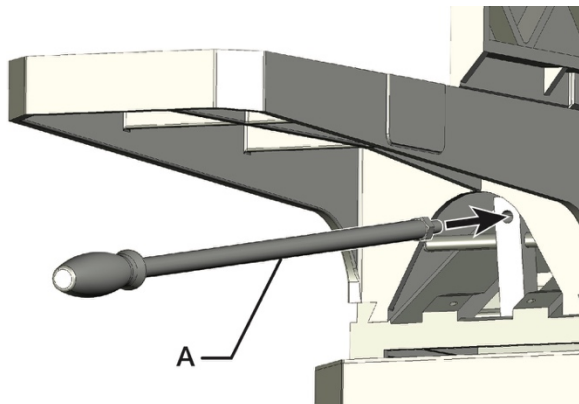


Figure 7-15

## 7.2.6 Installing Cutterhead Guard

Refer to Figures 7-16:

1. Place cutterhead guard (A) into mounting hole as shown in Figure 7-16.

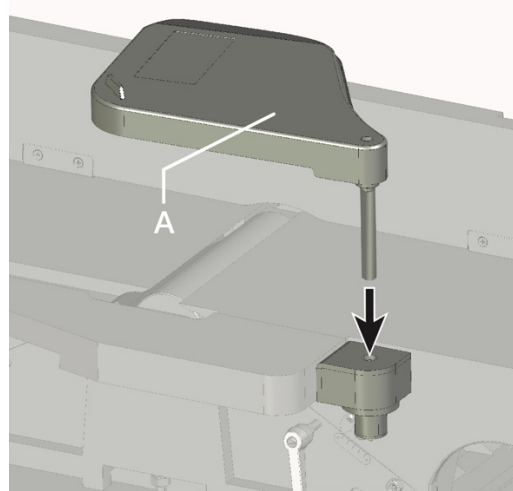


Figure 7-16

## 7.3 Dust Collection

Refer to Figures 7-17:

A jointer produces a significant volume of wood chips and dust. The use of a dust collection system is strongly recommended. It will help keep the shop clean, as well as reduce potential health hazards caused by inhalation of wood dust. We recommend your dust collector has a minimum rating of 400 CFM.

JET has a full line of dust collection systems available. See your dealer or visit our website at [www.jettools.com](http://www.jettools.com).

Connect the hose of your dust collection system to the 4-inch dust port on the jointer (A). Secure hose tightly with a hose clamp.

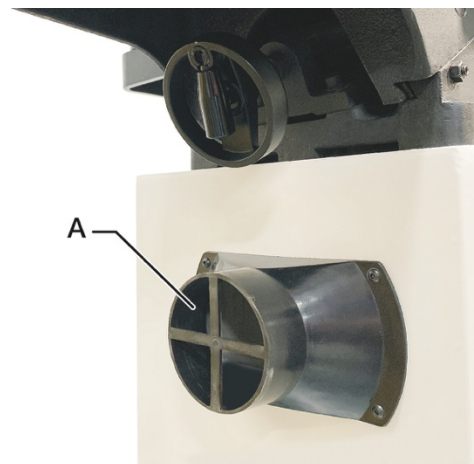


Figure 7-17



## 8.0 Electrical Connections

**⚠WARNING** Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

Before connecting to power source, be sure OFF button is pressed.

It is recommended that the jointer be connected to a dedicated 20-amp circuit with a 20-amp circuit breaker or time-delay fuse marked "D". **Local codes take precedence over recommendations.**

### 8.1 Grounding Instructions

This machine must be grounded. 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 tool 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 a risk of electric shock. The conductor with insulation 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.

**⚠WARNING** Check with a qualified electrician or service person if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded. Failure to comply may cause serious or fatal injury.

### 8.2 230 Volt Operation

Referring to Figures 8-1:

This model is intended for use on a 230V circuit and has a grounded outlet that matches the machine's electrical cord plug, as shown in Figure 8-1. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this machine. If the machine must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified electrician. After reconnection, the machine should comply with all local codes and ordinances.

Make sure the voltage of your power supply matches the specifications on the motor plate of the machine.

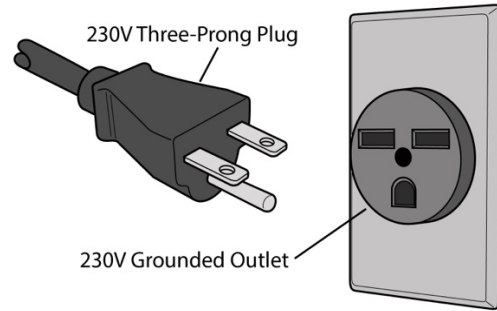


Figure 8-1

### 8.3 Extension Cords

The use of extension cords is discouraged. If possible, position your machine within reach of the power supply. If an extension cord becomes necessary, use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug. Make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Do not use a damaged or worn extension cord. Repair or replace before use.

Use Table 1 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

#### Recommended Gauges (AWG) of Extension Cords

Amp Rating		Volts	Total length of cord in feet			
More Than	Not More Than	120	25	50	100	150
		240	50	100	200	300
		AWG				
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not Recommended	

Table 1

## 9.0 Adjustments

**⚠WARNING** Before making adjustments, disconnect machine from the power source to guard against accidental startup.

**⚠CAUTION** This machine has an industrial-grade low-friction corrosion-resistant coating on the infeed and outfeed tables and the fence. While the coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance. Use care when making adjustments to the machine.

### 9.1 Fence Placement

#### Moving Fence Horizontally Across Infeed and Outfeed Tables

Refer to Figure 9-1:

1. Disconnect the machine from the power source.
2. Loosen fence base assembly upper bed adjustment lock (A).
3. Grasp fence (B) and/or fence base assembly upper bed (C) and move fence to desired location.
4. Tighten fence base assembly upper bed adjustment lock (A).

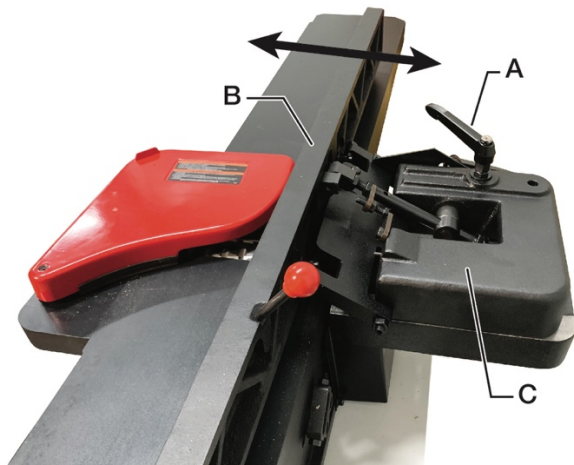


Figure 9-1

### 9.2 Fence Angle Adjustment

#### Angling Fence Between 90° and 45°

Refer to Figure 9-2:

1. Disconnect the machine from the power source.
2. Loosen fence tilt adjustment lock (A).
3. Grasp fence handle (B) and swing top of fence towards the front of jointer.
4. Use an angle finder tool to adjust fence to desired angle and tighten fence tilt adjustment lock (A).

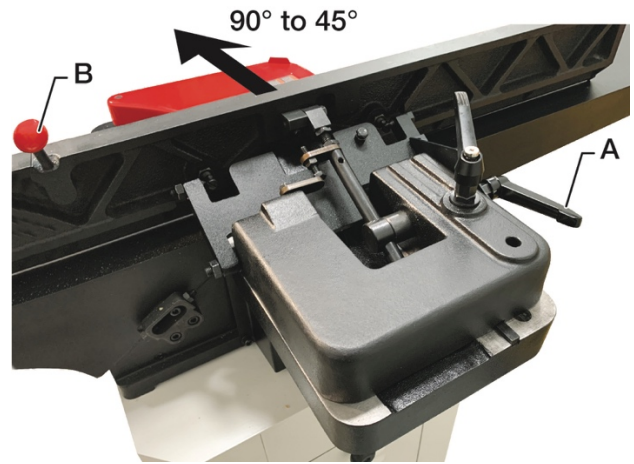


Figure 9-2

### 9.3 Fence Angle Adjustment

#### Angling Fence Between 90° and 135°

Refer to Figure 9-3:

1. Disconnect the machine from the power source.
2. Loosen fence tilt adjustment lock (A).
3. Grasp fence handle (B) and slightly nudge the top of fence towards the front of jointer.
4. Swing fence 90° stop plate (C) up to allow 90° stop bolt (D) to move back.
5. Grasp fence handle (B) and swing top of fence towards the rear of jointer.
6. Use an angle finder tool to adjust fence to desired angle and tighten fence tilt adjustment lock (A).

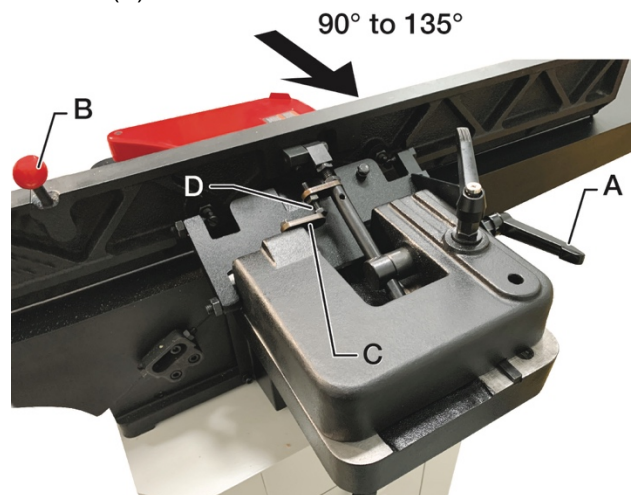


Figure 9-3

## 9.4 Leveling Outfeed Table to Cutterhead Knives

**⚠WARNING** Disconnect machine from the power source to guard against accidental startup. Knife inserts are extremely sharp. Use caution when hands are near the cutterhead.

Refer to Figures 9-4 through 9-9:

The tables have been leveled with each other from the factory, but this should be confirmed by the user, and checked periodically, by placing a steel straight edge across both tables.

For most jointing operations, the surface of the outfeed table must be level with the knife tips of the cutterhead at their highest point of revolution. The knife tips must project equally from the cutterhead.

To level the outfeed table to the cutterhead knives:

1. Rotate the cutterhead by turning the motor pulley or moving the drive belts. Rotate until a knife insert cutting edge is in the 12 o'clock position. The 12 o'clock position is the highest point a knife insert will reach in the cutting arc.
2. The center lock nut (A) and set screw (B) are very tight in order to lock the outfeed table in position. Before adjusting the outfeed table, loosen the center lock nut first, and then loosen the center set screw.
3. Turn the outfeed table handwheel (C) counterclockwise to raise the outfeed table (D) to be just higher than the knife insert on the cutterhead.
4. Place a straight edge on the outfeed table (E). Position the right side of the straight edge over the knife insert that has been rotated to the 12 o'clock position (F).
5. Turn the outfeed table handwheel (C) clockwise to lower the outfeed table. Adjust the outfeed table downward until the straight edge just touches the blade tip of the knife insert. **IMPORTANT:** Use care when handling the straight edge near the knife inserts so as not to damage them.
6. When the outfeed table and knife insert are the same height, firmly tighten the center set screw (B) first, and then tighten the center lock nut (A).

After the outfeed table has been set at the correct height, do not change it except after replacing the knife inserts.

If the outfeed table is set too high, a tapered finished surface results (see Figure 9-7).

If the outfeed table is set too low, snipe results at the end of the cut (see Figure 9-8).

Figure 9-9 illustrates the outfeed table at the correct height.

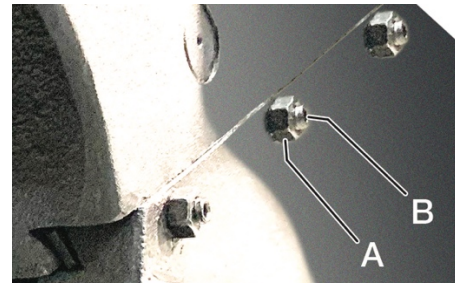


Figure 9-4

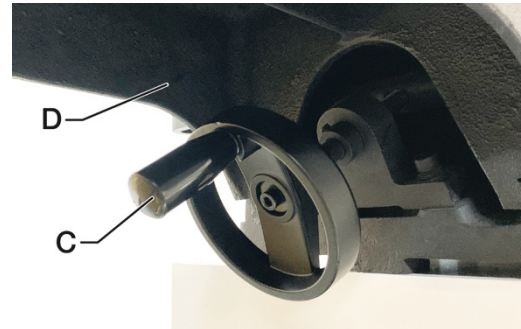


Figure 9-5

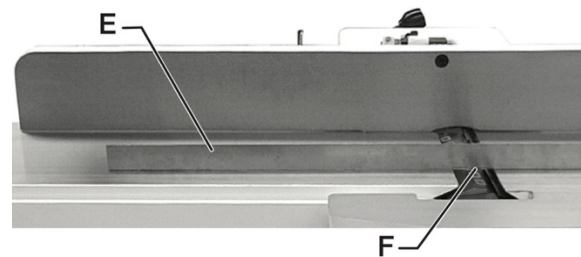
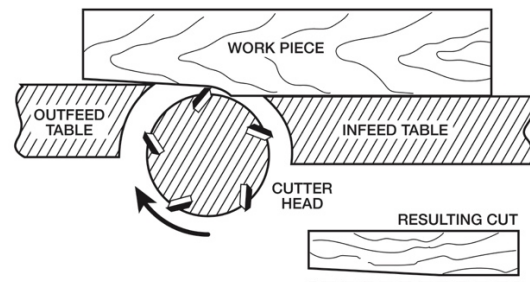
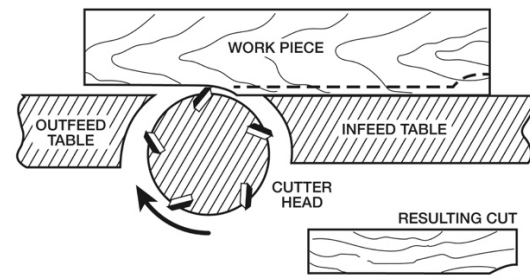


Figure 9-6



OUTFEED TABLE TOO HIGH

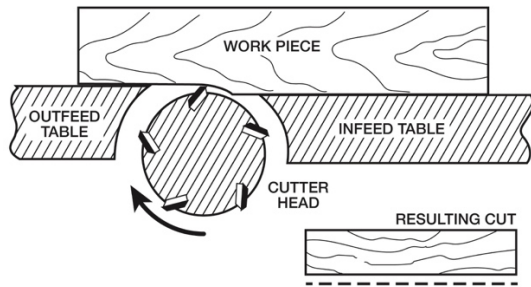
Figure 9-7



OUTFEED TABLE TOO LOW

Figure 9-8





OUTFEED TABLE AT CORRECT HEIGHT

Figure 9-9

## 9.5 Replacing or Rotating Knife Inserts

Refer to Figure 9-10:

The knife inserts are four-sided. When dull, simply remove each insert, rotate it 90° for a fresh edge, and re-install it.

Use the two provided star point screwdrivers to remove the knife insert screw (see Figure 9-10). Use one of the screwdrivers to help hold the cutterhead in position, and the other to remove the screw. It is advisable to rotate all inserts at the same time to maintain consistent cutting. However, if one or more knife inserts develops a nick, rotate only those inserts that are affected.

Each knife insert has an etched reference mark so that you can keep track of the rotations.

**IMPORTANT:** When removing or rotating inserts, clean saw dust from the screw, the insert, and the cutterhead platform. Dust accumulation between these elements can prevent the insert from seating properly and may affect the quality of the cut.

Before installing each screw, lightly coat the screw threads with machine oil and wipe off any excess.

Securely tighten each screw which holds the knife inserts before operating the planer!

**WARNING** Make sure all knife insert screws are tightened securely. Loose inserts can be propelled at high speed from a rotating cutterhead, causing injury.

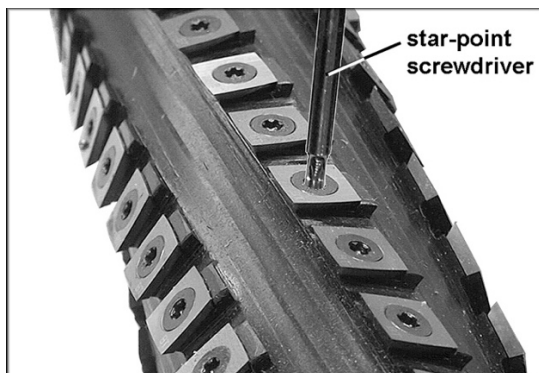


Figure 9-10

## 9.6 Infeed Table Depth Stop

Refer to Figure 9-11:

The *infeed table travel limiter* located on the back of the table sets the upper and lower range for the infeed table height adjustment and should not require any adjustments.

The *infeed table depth stop* (A) limits the depth of a cut (set by adjusting the infeed table handwheel) to a maximum depth of 1/8". For normal operations, a depth of cut of 1/8" or less is recommended.

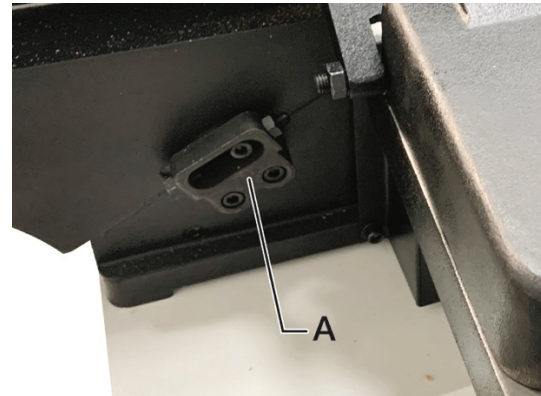


Figure 9-11

## 9.7 Gib Adjustment

Refer to Figure 9-12:

The gibs are located on both the infeed and outfeed tables. After a period of use, the gibs may become loose and need adjusting:

1. The center lock nut (A) and set screw (B) are very tight in order to lock the outfeed table in position. Before adjusting the gib, loosen the center lock nut first, and then loosen the center set screw.
2. Loosen two lock nuts (C) at the bottom and top of the table seat.
3. Tighten the bottom and top set screws (D) 1/4 turn. If a 1/4 turn does not remove all play, take another 1/4 turn. Repeat a 1/4 turn for both set screws until play is removed.
4. Tighten two lock nuts (C) at the bottom and top of the table seat.
5. Firmly tighten the center set screw (B) first, and then tighten the center lock nut (A).

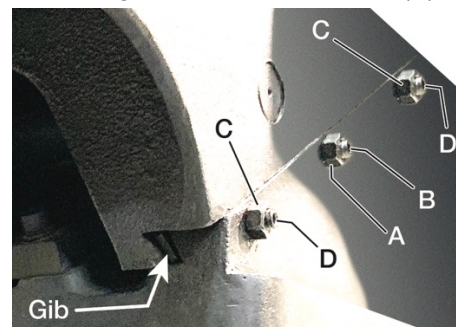


Figure 9-12



## 10.0 Operation

**▲WARNING** Read and understand all safety information in Section 3.0 *Safety Warnings* before operating this machine.

**▲WARNING** Keep all guards in place and in adjustment at all times during the cutting procedure! Keep hands away from the cutterhead! Do not pass hands directly over the cutterhead! The use of push sticks and/or handle pads are highly recommended when using the jointer! Failure to comply may cause serious injury!

**▲WARNING** Do not make cuts deeper than 1/8-inch for jointing cuts and 1/16-inch for planing cuts. Deeper cuts could overload the machine and increase the chance of kickback.

**▲CAUTION** This machine has an industrial-grade low-friction corrosion-resistant coating on the infeed and outfeed tables and the fence. While the coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance. Use care when operating the machine.

**RABBETING NOTICE:** This jointer has a helical cutting head and is not suitable for rabbeting cuts. Do not attempt rabbeting operations.

**Jointing Cuts** are made to square an edge of a workpiece. The workpiece is positioned on the jointer with the narrow edge of the workpiece on the infeed table and the major flat surface of the workpiece against the fence (see Figure 10-1).

**Face Jointing Cuts** are similar, however, the major surface of the workpiece is placed on the table with the narrow edge of the workpiece against the fence (see Figure 10-2).

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

For jointing cuts, when the material is higher than the fence, the left hand applies pressure into the fence and down toward the table while the right hand pushes forward from behind. Be sure to keep the right hand high up on the material (see Figure 10-1).

For jointing material that is lower than the fence, use push sticks to protect the hands. For planing, use handle pads (see Figure 10-2).

**▲WARNING** Never place the right hand on the trailing edge of the material. Hand placement on the trailing edge of the material may cause the hand to come into contact with the knife inserts.

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



Figure 10-1



Figure 10-2

### 10.1 Jointing Warped Material

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

**▲WARNING** Never joint any material shorter than eight inches! The material may tip into the jointer's throat and be kicked back! Avoid jointing thin material which could become jammed under the fence or blade guard! Failure to comply may cause serious injury!

### 10.2 Direction of Grain

Feed the material with the grain to avoid tearout (see Figure 10-3). If the direction of the grain changes somewhere in the board, try reducing depth of cut and slow the feed speed down to avoid tearout. If results still aren't satisfactory, turn the material around and try feeding through the other way.

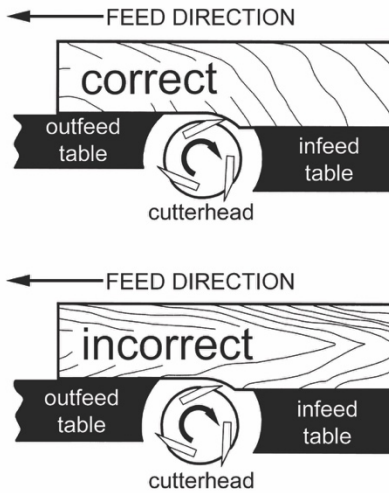


Figure 10-3

### 10.3 Bevel Cut

To cut a bevel, lock the fence at the desired angle and run the material through, pressing the work firmly against the fence and tables (see Figure 10-4). Do not make cuts deeper than 1/8" in a single pass. Several passes may be necessary for the desired result.



Figure 10-4

### 10.4 Taper Cut

**WARNING** Taper cuts require the removal of the cutterhead guard. Use extreme caution when making taper cuts and replace the guard immediately after completion! Failure to comply may cause serious injury!

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 is a common example.

Instead of laying the piece down on the infeed table, lower the forward end of the work onto the outfeed table. Use caution, however, 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 held firmly. Push the work forward as in ordinary jointing. The effect is to plane off all the stock in front of the knives to an 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 in the regular jointing procedure, with the infeed table raised to its normal position.

Practice is required in this operation. Beginners are advised to make trial cuts with scrap material.

## 11.0 Maintenance

**WARNING** Disconnect machine from power source before doing any maintenance. Failure to comply may cause serious injury.

**WARNING** Make sure all knife insert screws are tightened securely. Loose inserts can be propelled at high speed from a rotating cutterhead, causing injury.

**CAUTION** This machine has an industrial-grade low-friction corrosion-resistant coating on the main table and the infeed and outfeed tables. While the coating is durable, it can be damaged if metal or other hard and/or sharp objects strike, gouge, or scratch the surface. Significant damage to the coating may affect its performance. Use care when performing maintenance on this machine.

Periodic or regular inspections are required to ensure that the machine is in proper adjustment, that all screws are tight, that belts are in good condition, that dust has not accumulated in the electrical enclosures, and that there are no worn or loose electrical connections.

Buildup of sawdust and other debris can cause your machine to perform inaccurately. Periodic cleaning is not only recommended but mandatory for accurate jointing.

Close-fitting parts should be cleaned with a cloth or brush and non-flammable solvent.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

### 11.1 Lubrication

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

## 11.2 Cutterhead Removal

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

The entire cutterhead assembly may be removed for bearing replacement or cutterhead replacement.

To remove the cutterhead (including bearings, studs, and housing) from the base casting:

1. Disconnect the machine from the power source.
2. Remove the fence assembly, cutterhead guard, and belt guard. See Section 7.2 *Assembly* to understand how to remove these parts.
3. Lower infeed and outfeed tables to create widest opening above cutter head assembly.
4. Remove the v-belt from the cutterhead pulley.
5. Loosen set screw (A) using a hex wrench and remove the cutterhead pulley (B) and key (C).

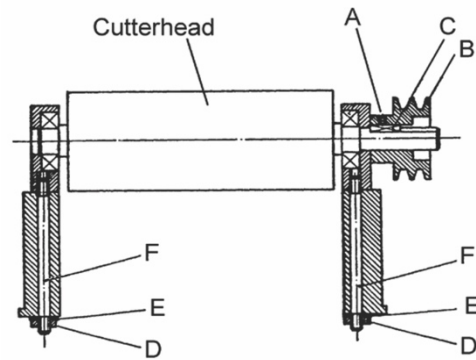


Figure 11-1

6. Unscrew M10 hex nuts (D) with M10 lock washers (E) from two ends bolts (F).
7. Lift assembly straight up.
8. Before replacing the cutterhead back into the casting, thoroughly clean the “saddle” and the bearing housings of saw dust and grease so that they seat properly.
9. To re-install the cutterhead, reverse the above steps.

## 12.0 Troubleshooting

Trouble	Probable Cause	Remedy
Finished stock is concave on the end.	Knife tip is higher than outfeed table.	Raise outfeed table so it is level with knife tip.
Back side of finished stock is thicker than the front side.	Outfeed table is higher than knife tip.	Adjust outfeed table so it is level with knife tip.
Both ends of finished stock are cut deeper than the middle.	Ends of tables are higher than middle.	Adjust table ends with adjustment screws below tables.
Infeed or outfeed tables are loose.	Loose gib.	Tighten gibs.
Ripples on planed surface. Kickbacks.	Feeding wood too fast.	Feed wood more slowly.
Excessive motor noise.	Motor	Have motor checked by a qualified repair station.
	Pulley set screw is loose.	Tighten set screw.
Motor fails to develop full power or stalls.	Circuit overloaded with lights, tools, etc.	Do not share the circuit.
	Undersize wires or circuit too long.	Increase wire sizes or reduce length of wiring.
	Voltage too low.	Request voltage check from the power company.
	Fuses or circuit breakers do not have sufficient capacity.	Have a qualified electrician install proper size fuses or circuit breakers.
Motor starts slowly or fails to come to full speed.	Motor	Have motor checked by a qualified repair station.
	Belt tension too tight.	Adjust belt tension.
	Bad start capacitor.	Replace start capacitor.

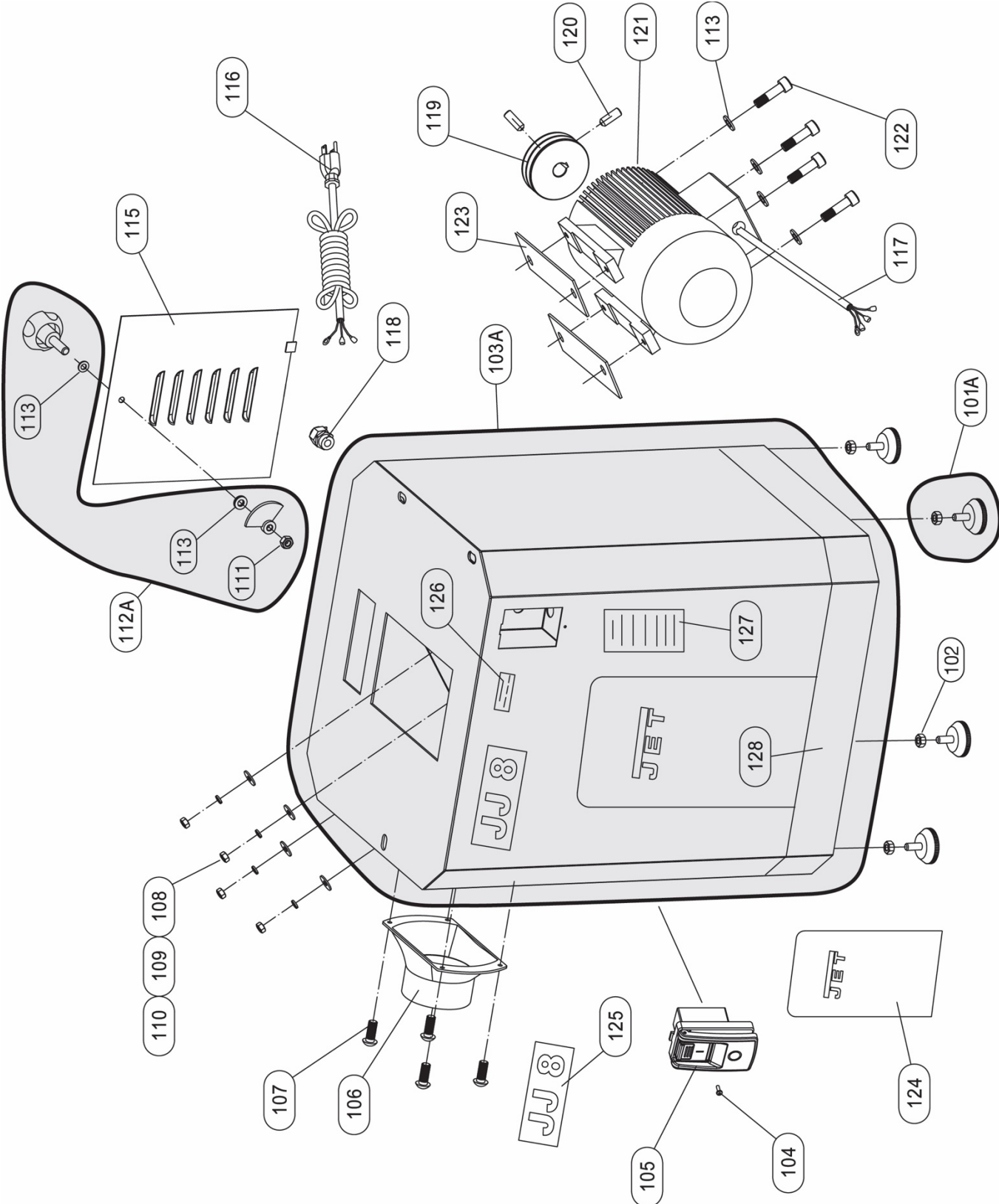
## 13.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET.

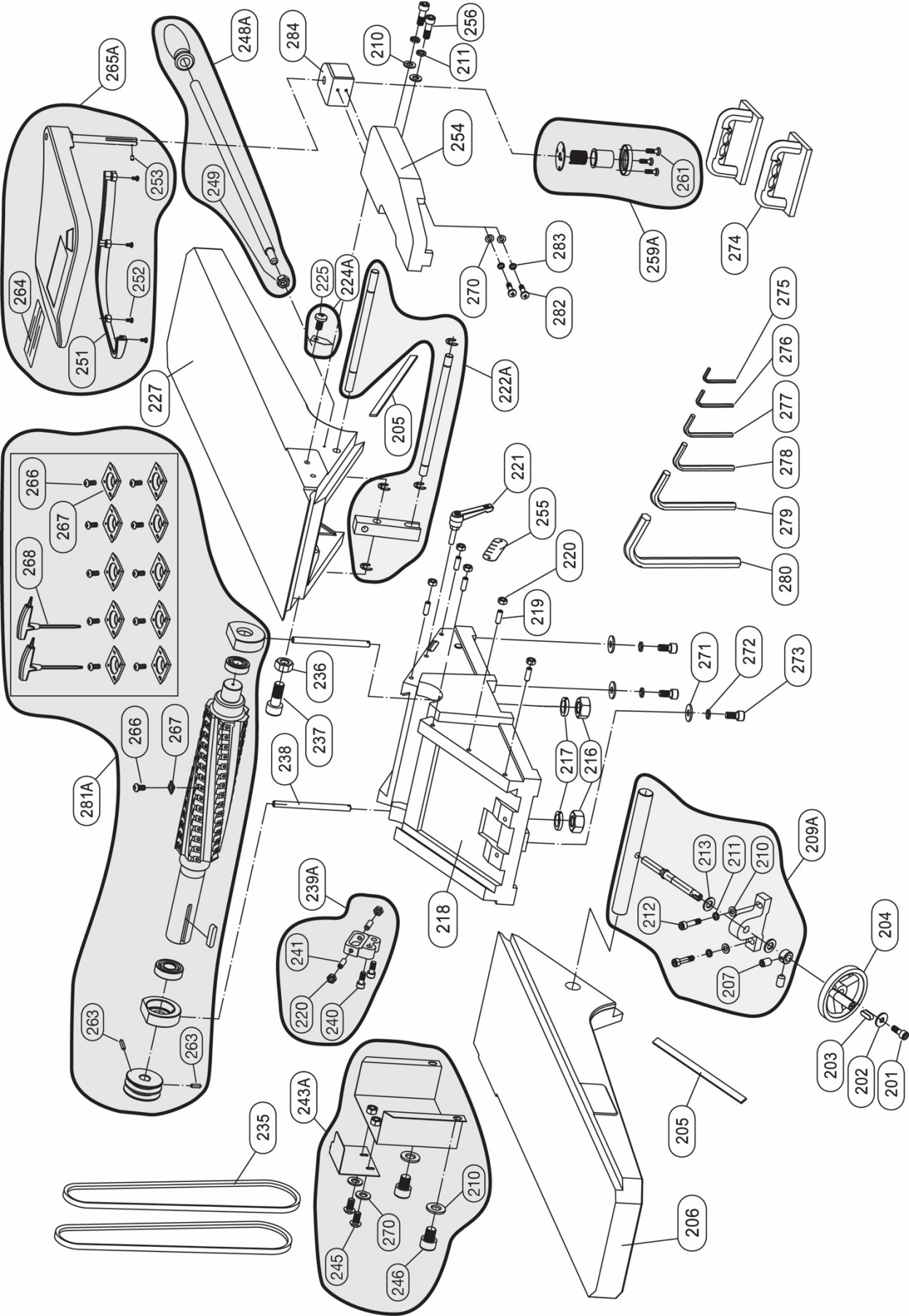
Some parts are shown for reference only and may not be available individually.

13.1.1 JWJ-8HH-BLK Jointer Assembly – Exploded View

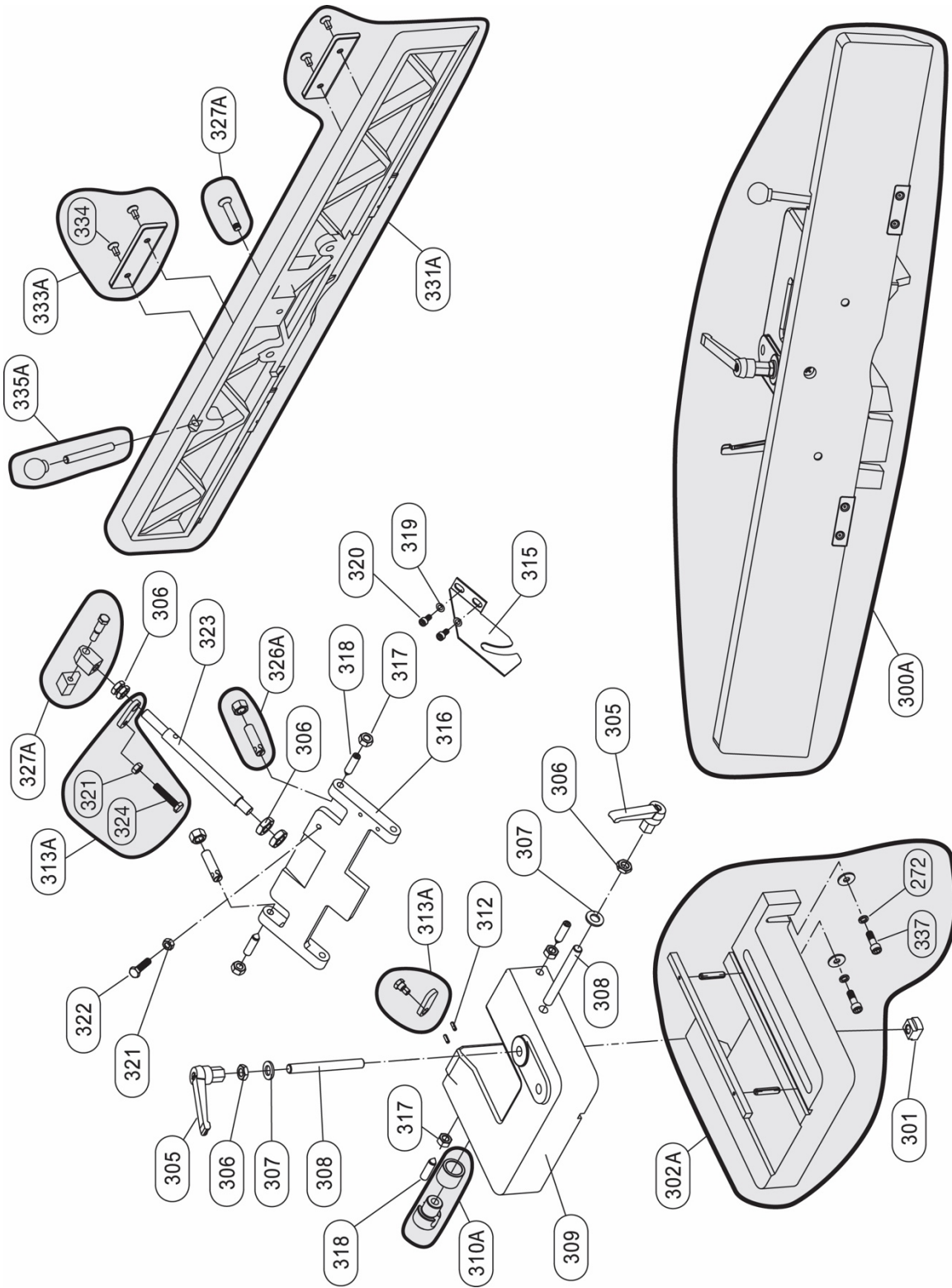




13.1.2 JWJ-8HH-BLK Jointer Assembly – Exploded View



13.1.3 JWJ-8HH-BLK Jointer Assembly – Exploded View



## 13.2 JWJ-8HH-BLK Jointer Assembly – Parts List

Note: Assemblies are highlighted in gray.

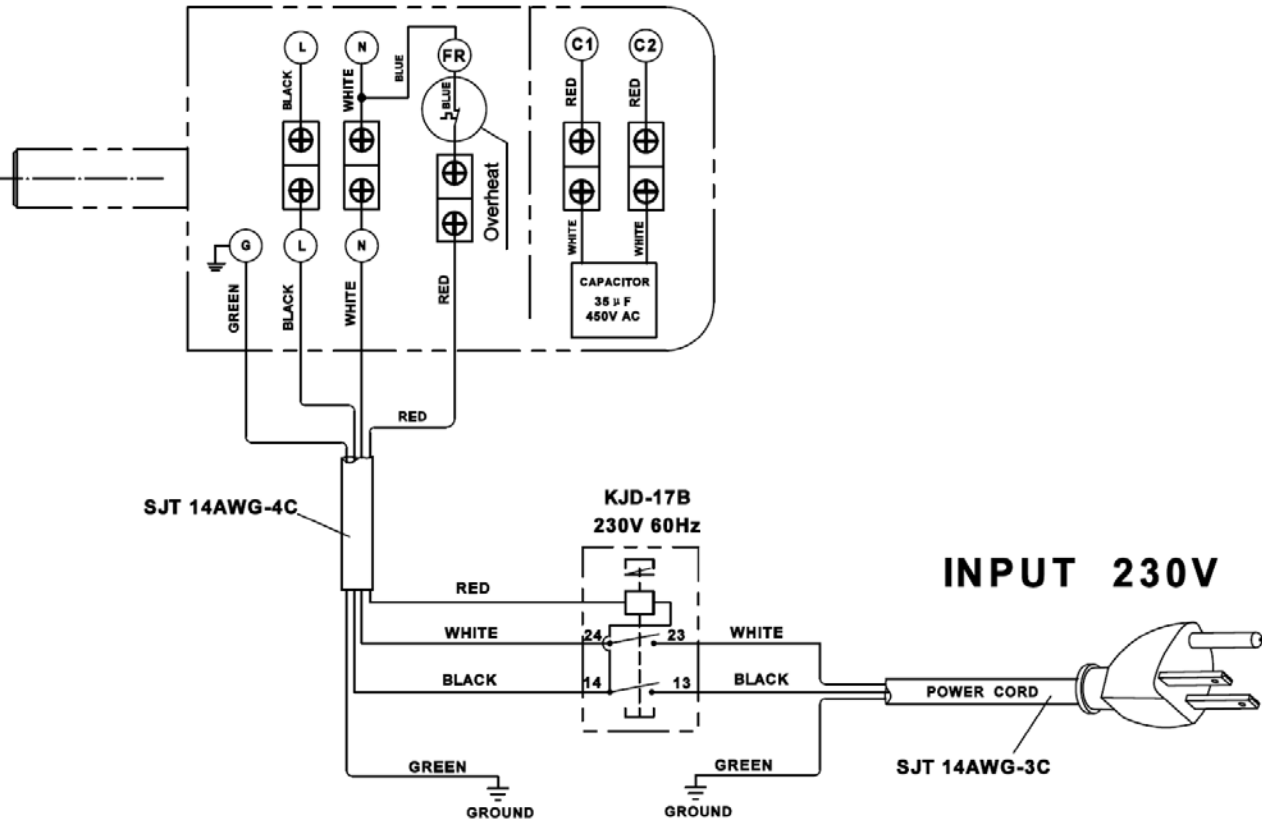
Index No.	Part No.	Description	Size	Qty
101A	JWJ8HHBLK-101A	Foot Assembly		4
102	**	Hex Nut	M10	6
103A	JWJ8HHBLK-103A	Base Cabinet Assembly		1
104	**	Pan Head Machine Screw	M4x10	1
105	JWJ8HHBLK-105	Switch	KJD17B 230V	1
106	JWJ8HHBLK-106	Dust Port		1
107	**	Socket Head Button Screw	M5x10	4
108	**	Hex Nut	M8	4
109	**	Lock Washer	8 mm	4
110	JWJ8HHBLK-110	Large Flat Washer	8 mm	3
111	**	Nylon Lock Hex Nut	M8	1
112A	JWJ8HHBLK-112A	Lock Block Assembly		1
113	**	Flat Washer	8 mm	7
115	JWJ8HHBLK-115	Door		1
116	JWJ8HHBLK-116	Power Cord SJT14AWGx3C, 6-15P/230V		1
117	JWJ8HHBLK-117	Motor Cord SJT14AWG x 4C, 1.20m		1
118	JWJ8HHBLK-118	Strain Relief	M20x1.5	2
119	JWJ8HHBLK-119	Motor Pulley		1
120	**	Socket Set Screw	M6x16	2
121	JWJ8HHBLK-121	Motor Assembly	2HP,230V	1
121C	JWJ8HHBLK-121C	Motor Fan Cover (not shown)		1
121F	JWJ8HHBLK-121F	Motor Fan (not shown)		1
121J	JWJ8HHBLK-121J	Junction Box (not shown)		1
121R	JWJ8HHBLK-121R	Running Capacitor (not shown)	35µF, 450V AC	1
122	**	Socket Head Cap Screw	M8x30	4
123	JWJ8HHBLK-123	Rubber Pad		1
124	JWJ8HHBLK-124	JET Logo with Adhesive	8x15T	1
125	JWJ8HHBLK-125	JJ8 Model Logo with Adhesive		1
126	JWJ8HHBLK-126	Warning Label 01, JWJ-8HH-BLK		1
127	JWJ8HHBLK-127	Warning Label 02, JWJ-8HH-BLK		1
128	JWJ8HHBLK-128	Black Sticker for Stand, JWJ-8HH-BLK		1
201	**	Socket Head Cap Screw	M6x10	1
202	JWJ8HHBLK-202	Large Washer	6mm	1
203	JWJ8HHBLK-203	Key A4X12	A 4X12	1
204	JWJ8HHBLK-204	Handwheel		1
205	JWJ8HHBLK-205	Wedge Iron		2
206	**	Outfeed Table (PTFE)		1
207	**	Socket Set Screw	M6x6	2
209A	JWJ8HHBLK-209A	Screw Shaft Seat Assembly		1
210	**	Flat Washer	8 mm	2
211	**	Lock Washer	8 mm	2
212	**	Socket Head Cap Screw	M8x30	2
213	**	Flat Washer	12 mm	2
216	**	Hex Nut	M10	2
217	**	Lock Washer	10mm	2
218	**	Table Seat		1
219	**	Socket Set Screw	M8x30	6
220	**	Socket Flat Head Screw	M8	8
221	JWJ8HHBLK-221	Locking Handle		1
222A	JWJ8HHBLK-222A	Lifting Block Assembly		1
223	JWJ8HHBLK-223	E-Ring	9 mm	4
224A	JWJ8HHBLK-224A	Pointer Assembly		1
225	**	Pan Head Machine Screw	M4x8	1
227	**	Infeed Table (PTFE)		1
235	JWJ8HHBLK-235	Driving Belt	O-880	2
236	JWJ8HHBLK-236	Thin Hex Nut	M8	1
237	**	Socket Head Cap Screw	M8x20	1
238	JWJ8HHBLK-238	Two Ends Bolt		2
239A	JWJ8HHBLK-239A	Setting Block Assembly		1
240	**	Socket Head Cap Screw	M8x25	2
241	**	Socket Set Screw	M8x20	1
243A	JWJ8HHBLK-243A	Belt Cover A Assembly		1



Index No.	Part No.	Description	Size	Qty
245	**	Socket Head Button Screw	M5x10	2
246	**	Socket Head Cap Screw	M8x10	2
248A	JWJ8HHBLK-248A	Lifting Bar Assembly		1
249	**	Hex Nut	M12	1
251	JWJ8HHBLK-251	POM Strip		1
252	**	Pan Head Machine Screw	M4x10	4
253	**	Socket Set Screw	M5x8	1
254	**	Rabbeting Arm		1
255	JWJ8HHBLK-255	Ruler		1
256	**	Hex Cap Screw	M8x35	2
259A	JWJ8HHBLK-259A	Spring Housing Assembly		1
261	**	Pan Head Machine Screw	M4x12	3
263	**	Socket Set Screw	M6x10	2
264	JWJ8HHBLK-264	Warning Label for Blade Guard		1
265A	JWJ8HHBLK-265A	Blade Guard Assembly		1
266	JJ6HHBT-081	Knife Insert Screw	M5x12	36
267	1791212	Knife Inserts (sold in sets of 10)		36
268	JJ6HHBT-085	Star Point Screwdriver	T20	2
270	**	Flat Washer	5 mm	2
271	JWJ8HHBLK-271	Large Flat Washer	10 mm	5
272	**	Lock Washer	10 mm	4
273	**	Socket Head Cap Screw	M10x20	3
274	JWJ8HHBLK-274	Push Block		2
275	JET750-55	Hex wrench	2.5mm	1
276	TS-152704	Hex wrench	3mm	1
277	TS-152705	Hex wrench	4mm	1
278	TS-152706	Hex wrench	5mm	1
279	TS-152707	Hex wrench	6mm	1
280	TS-227D081	Hex Wrench	8mm	1
281A	JWJ8HHBLK-281A	Cutterhead, Helical Body Assembly		1
282	**	Pan Head Machine Screw	M5x20	2
283	**	Lock Washer	5 mm	2
284	JWJ8HHBLK-284	Blade Guard Base		1
300A	JWJ8HHBLK-300A	Fence Assembly-Complete		1
301	JWJ8HHBLK-301	Special Nut		1
302A	JWJ8HHBLK-302A	Bracket Assembly		1
305	JWJ8HHBLK-305	Locking Handle		2
306	JWJ8HHBLK-306	Thin Hex Nut	M12	6
307	**	Flat Washer	12 mm	2
308	JWJ8HHBLK-308	Two Ends Bolt		2
309	JWJ8HHBLK-309	Fence Bracket		1
310A	JWJ8HHBLK-310A	Locking Sleeve Assembly		1
312	JWJ8HHBLK-312	Spring Pin	4x12	2
313A	JWJ8HHBLK-313A	Locating Plate Assembly		1
315	JWJ8HHBLK-315	Locking Plate		1
316	JWJ8HHBLK-316	Tilt Plate		1
317	**	Hex Nut	M10	4
318	JWJ8HHBLK-318	Cone Screw		4
319	**	Flat Washer	6 mm	2
320	**	Socket Head Cap Screw	M6x12	2
321	**	Hex Nut	M8	1
322	**	Hex Cap Screw	M8x20	1
323	JWJ8HHBLK-323	Support Bar		1
324	**	Hex Cap Screw	M8x35	1
326A	JWJ8HHBLK-326A	Fence Hinge Axile Assembly		2
327A	JWJ8HHBLK-327A	Hinge Axile Assembly		1
331A	JWJ8HHBLK-331A	Fence Body (PTFE) Assembly		1
333A	JWJ8HHBLK-333A	Pad Block Assembly		2
334	**	Socket Head Flat Screw	M4x10	4
335A	JWJ8HHBLK-335A	Handle Bar Assembly		1
337	**	Socket Head Cap Screw	M10x35	2

\*\* These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

# 14.0 Electrical Connections



# NOTES



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