



OWNER'S MANUAL



B1363N WOOD SHAPER



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GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating this machine.
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing drill bits, hollow chisels, router bits, shaper heads, blades, knives or making other adjustments or repairs.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **NEVER** make crosscuts with the rip fence in place.
- ❑ **NEVER** attempt cut material that is warped or twisted.
- ❑ **NEVER** stand or lean on the tool.
- ❑ **DO NOT** force the tool – tools work best when allowed to perform @ own speed.
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** use push sticks and featherboards to safely feed your work through the machine.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

INTRODUCTION

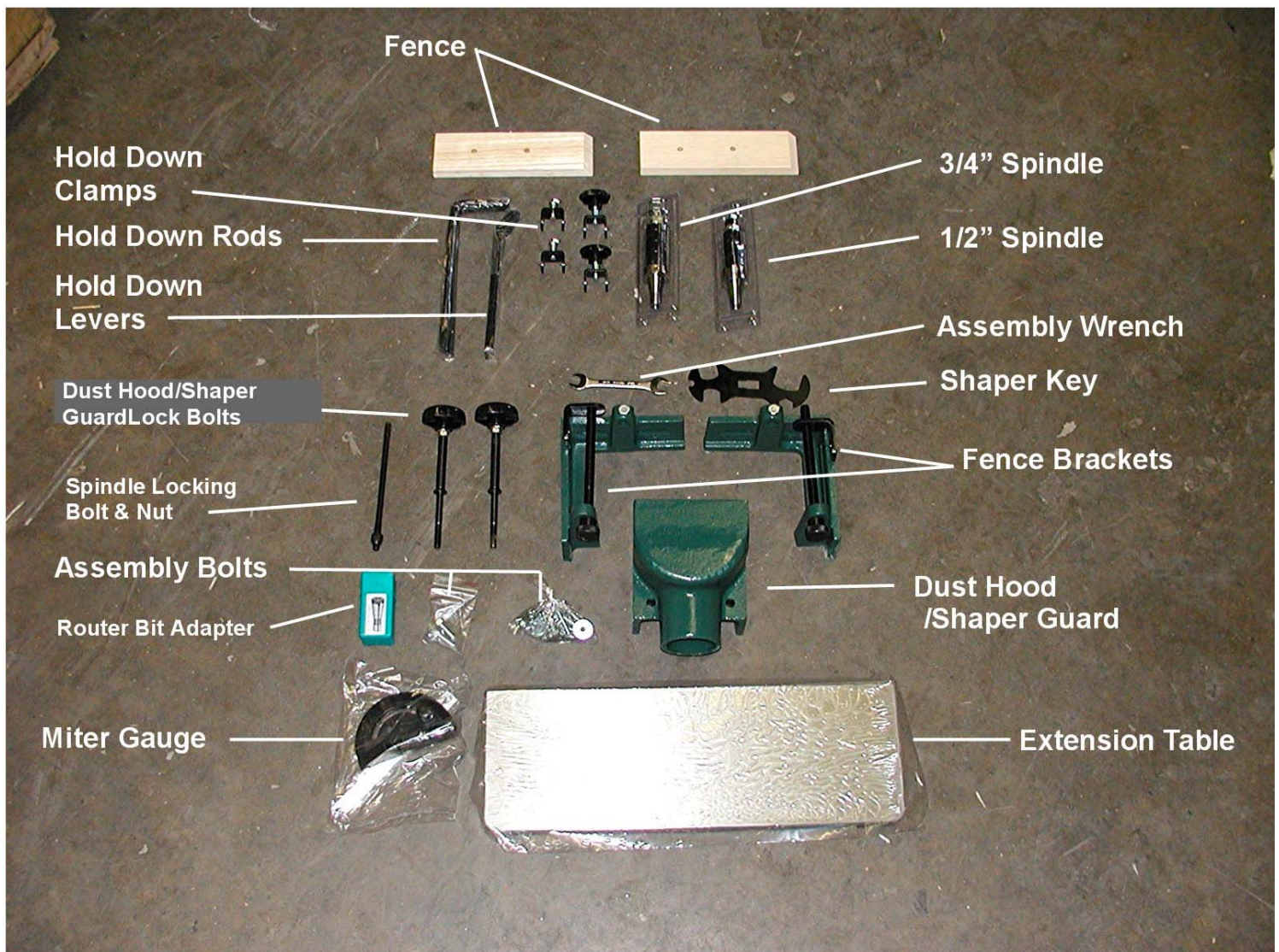
As part of the growing line of Craftex woodworking equipment, we are proud to offer the B1363N. The Craftex name guarantees **Craft Excellence**. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The B1363N is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

Features

- ❑ Motor, 1 horsepower.
- ❑ Voltage, 110/220-volt motor pre-wired for 110 volts.
- ❑ Reversing Switch.
- ❑ Speeds, 7,000 and 10,000 RPM's.
- ❑ Belt drive with 2-stage pulley.
- ❑ Spindle Sizes, 1/2" and 3/4".
- ❑ Spindle adapter for 1/2" and 1/4" router bits.
- ❑ Table inserts, 1 1/4" and 3 1/2" with a fixed opening of 5 1/8".
- ❑ Two independently adjustable hardwood fences.
- ❑ Four adjustable hold-down/hold-in clamps.
- ❑ Mitre gauge.
- ❑ Cast-iron, two position spindle guard with integrated 3" dust port.
- ❑ Table size with cast iron extension, 25" x 20".
- ❑ Weight: 100 kg.

PACKAGE CONTENTS

Your B1363N Wood Shaper is shipped in a cardboard carton strapped on a pallet. Upon removing the packing material and positioning the machine, you will find the assembly components in two cartons packed inside it. Carefully remove them and set them aside. The cartons contain the components as pictured here.



ASSEMBLY

Unpack the two cardboard cartons contained in the interior of the cabinet. These are accessible through the access door.

The cast-iron top of the B1363N, the cast-iron top of the extension table and some of the components are coated with a protective lubricant. This lubricant should be thoroughly removed with mineral spirits. The surfaces should be wiped clean and a coat of paste wax should be applied and then buffed.

From the parts carton, select the three long hex bolts and the cast iron extension table. Fasten the extension table to the shaper top using the threaded holes provided. Be sure that the extension table is perfectly level with the shaper table.

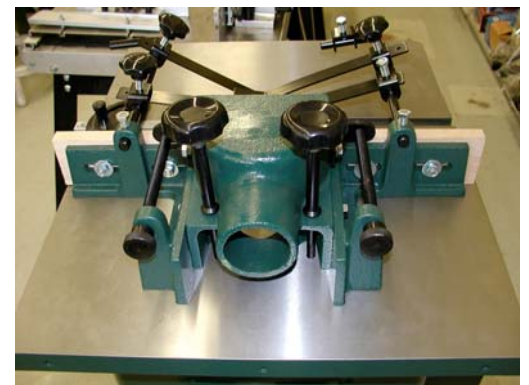


Select the two dust hood/shaper guard bolts and the dust hood/shaper guard from the parts carton. Position the dust hood/guard over the two threaded holes on the cast-iron table top and screw the bolts through the guard into the threaded holes and tighten as per the illustration.



Note: There are two positions in which you can place the dust hood.

The installed dust hood/shaper guard should look like the illustration at the right.

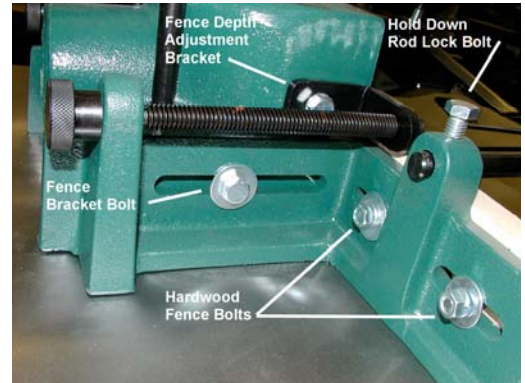


ASSEMBLY... CONTINUED

Installing The Dust Hood/ Guard & Fence Assembly

Select the two fence brackets, four hex-bolts and two flat washers. Assemble the fence brackets to both sides of the dust hood/shaper guard using one bolt and washer for each bracket.

Use the remaining two bolts to assemble the fence adjustment brackets to the dust hood/shaper guard housing as pictured.



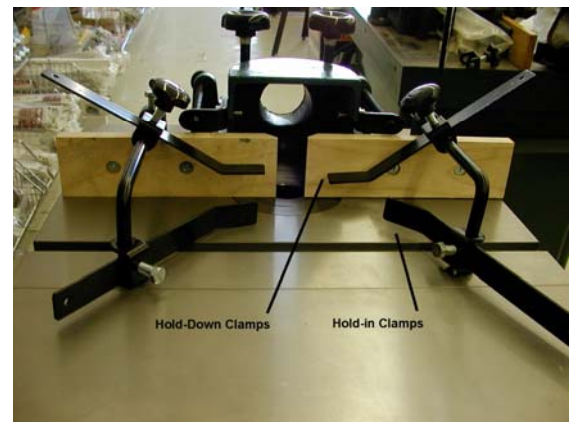
Select the two hardwood fence pieces and four flat-head bolts, washers and nuts and assemble the fence to the two fence brackets. Be sure that the hardwood fence pieces have the mitered edges at the shaper head opening. Do not tighten the bolts just yet.

Select the two hold down rods, two hex bolts, four hold down clamp straps and four hold down clamps. Install two (the ones with the plastic knobs) of hold down clamps on the long portion of the rods and feed the clamp straps through the slots in the hold down clamps. Slightly tighten the knobs. Install the rods in the fence through the holes provided and slightly tighten with the two hex bolts.

Install the two remaining (the ones with the exposed hex bolts) to the short portion of the rods and feed the remaining straps through the slots. Slightly tighten the bolts.

The assembled hold down, hold in clamp set-up should be as pictured here.

NOTE: NEVER OPERATE THE B1363N SHAPER WITHOUT THE DUST HOOD/GUARD AND FENCE ASSEMBLY SECURELY IN PLACE.



ASSEMBLY...CONTINUED

Installing The Shaper Head Spindles

Remove the dust hood/shaper guard assembly by unscrewing the two threaded hold-down rods and set aside
Remove the two shaper table inserts.
Raise the shaper shaft to its full height.



There are two shaper-head spindles included, a 1/2" and a 3/4". Select the one of your choice. Install the longer threaded end of the spindle-locking rod bolt into the bottom of the shaper spindle.



Install the spindle into the shaft as shown, being sure to engage the spindle locking detents. The spindle locking rod will protrude through the under part of the shaft. Use the locking rod nut to secure the assembly.



ASSEMBLY... CONTINUED

Installing The Shaper Head Spindles

Install the required table inserts being sure that they are flush with the table surface. Three adjustable levellers are provided for this.

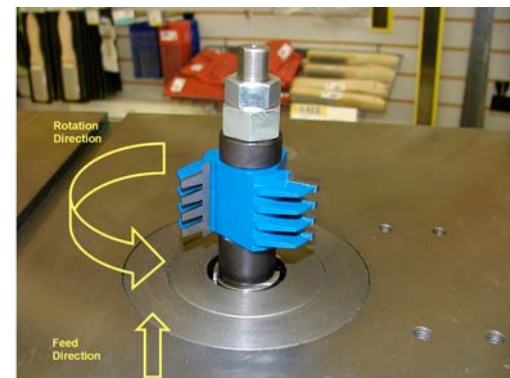


Remove the locking nuts (caution, the lowermost nut has conventional threads while the uppermost nut have reverse threads) from the top of the spindle and the required spacers to accommodate the shaper bit that you have selected. Re-install the locking nut. The installation should resemble the illustration.

Lower the shaft to the desired height but it will depend on how you want to position the shaper bit.

Reinstall the dust hood/guard assembly and adjust the fences as required.

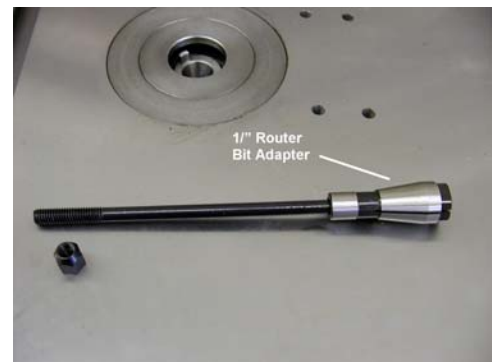
NOTE: The shaper bits may be installed so that they cut clockwise or counter-clockwise. Stock is *always* fed against the rotation.



The B1363N includes both a 1/2" and 1/4" router bit adapter. Install the 1/2" adapter on the threaded spindle-locking rod and feed it through the shaft and lock it with the rod bolt.

Install your router bit in the collet and tighten it securely.

Reinstall the dust hood/guard assembly and adjust the fences as required

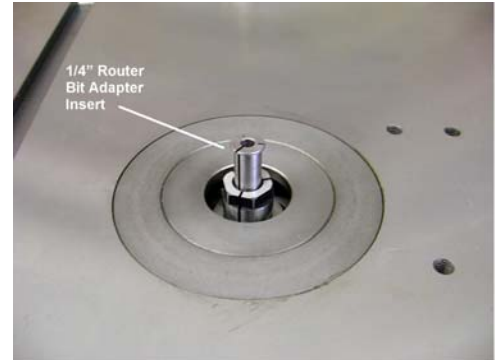


ASSEMBLY...CONTINUED

Installing The Shaper Head Spindles

To install the 1/4" router bit adapter, loosen the 1/2" router bit collet and insert the adapter in the collet. Tighten the collet securely. Reinstall the dust hood/guard assembly and adjust the fences as required

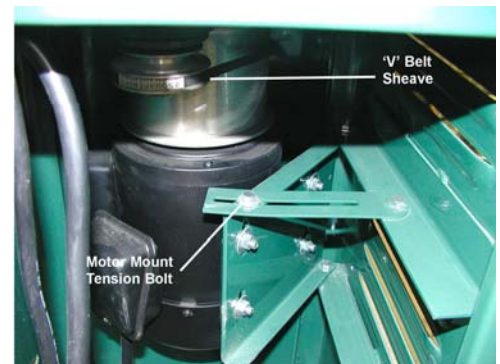
NOTE: NEVER OPERATE THE B1363N SHAPER WITHOUT THE DUST HOOD/GUARD AND FENCE ASSEMBLY SECURELY IN PLACE.



ADJUSTING THE SPEEDS.

The B1363N is a two-speed shaper with the speeds controlled by a belt and pulley system. To adjust the shaper head speed from either 7,000 or 10,000 RPM's you must open the motor access door.

Loosen the motor mount bolt to relieve the belt tension, reposition the drive belt on the sheave (pulley) to the smaller or larger diameter position. Push the motor mount to tighten the belt tension and then tighten the motor mount bolt securely.



MITRE GAUGE

The mitre gauge included with the B1363N Wood Shaper may be adjusted if necessary as follows: Loosen the lock-knob and invert the gauge. Place the inverted mitre gauge in the mitre slot at the edge of the shaper table. Press the gauge against the edge and tighten the lock-knob. Your mitre gauge is now square to the table. Invert it and set it back in the slot. Adjust the pointer by loosening the pointer screw and setting it to 90 degrees. Tighten the screw.



OPERATING INSTRUCTIONS

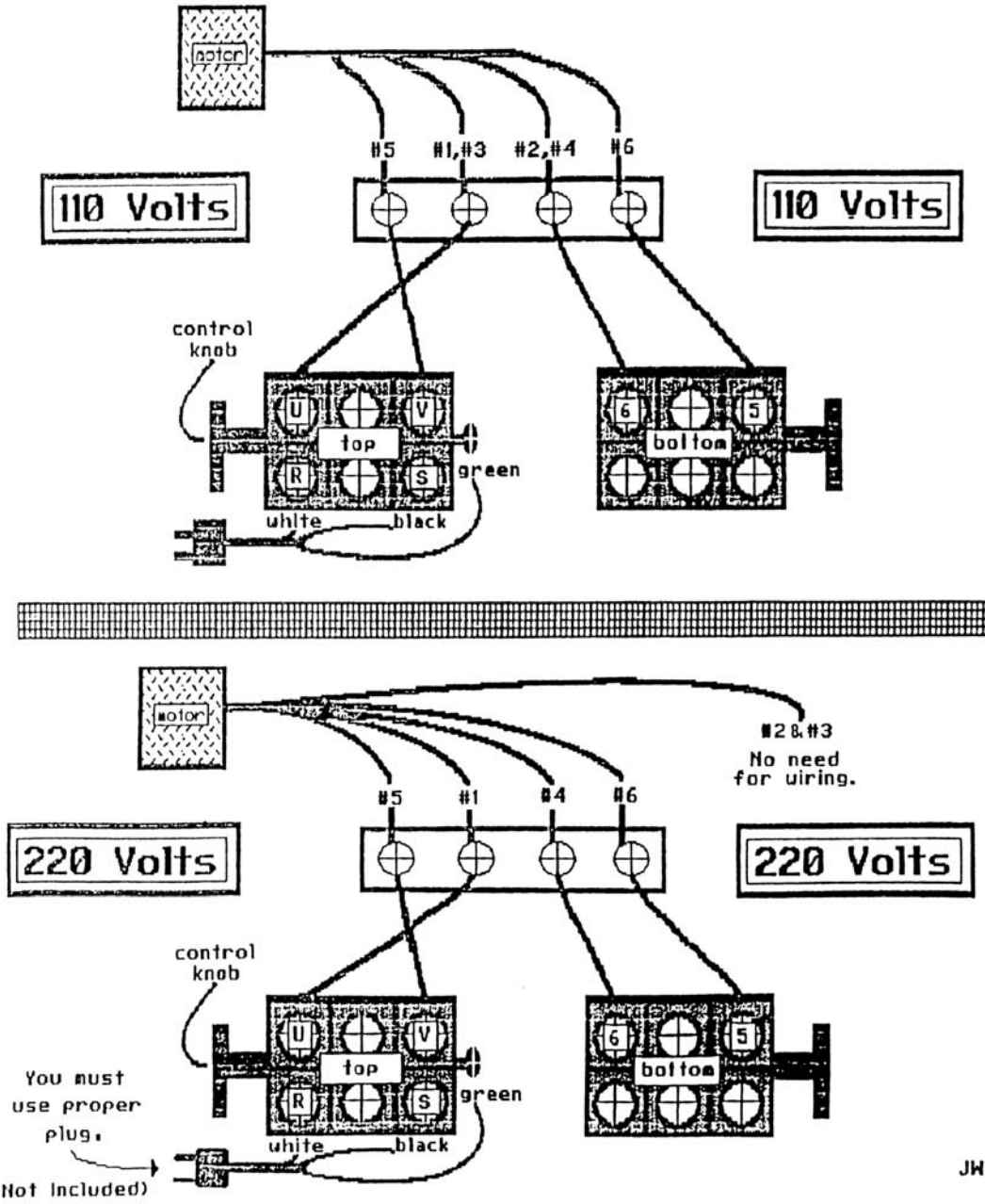
BEFORE CONNECTING THE B1363N TO A POWER SOURCE OR TURNING THE MACHINE ON, THE FOLLOWING SAFETY MEASURES SHOULD BE CHECKED.

- ❑ Be sure that you are connecting the tool to the appropriate power source.
- ❑ Make certain that the dust hood/guard is securely positioned.
- ❑ Make certain that the hardwood fences are correctly adjusted.
- ❑ Make certain that the hold-downs and hold in straps are correctly positioned and secure.
- ❑ Make certain that the shaper bit is correctly positioned on the spindle for the work that you plan to do and that the shaper is secure on the spindle.
- ❑ Make certain that the spindle nut is tightened down correctly.
- ❑ Make certain that the shaper bit is at the correct elevation.
- ❑ Make certain that the spindle elevation lock is engaged.
- ❑ Make certain that you have selected the correct speed for the shaper bit being used.
- ❑ Make certain that you feed your work against the rotation of the shaper bit.
- ❑ Make certain that you enjoy yourself while adhering to all safety instructions.



B1363N WIRING PLAN

1 ϕ 110/220V double lines(6 wires)

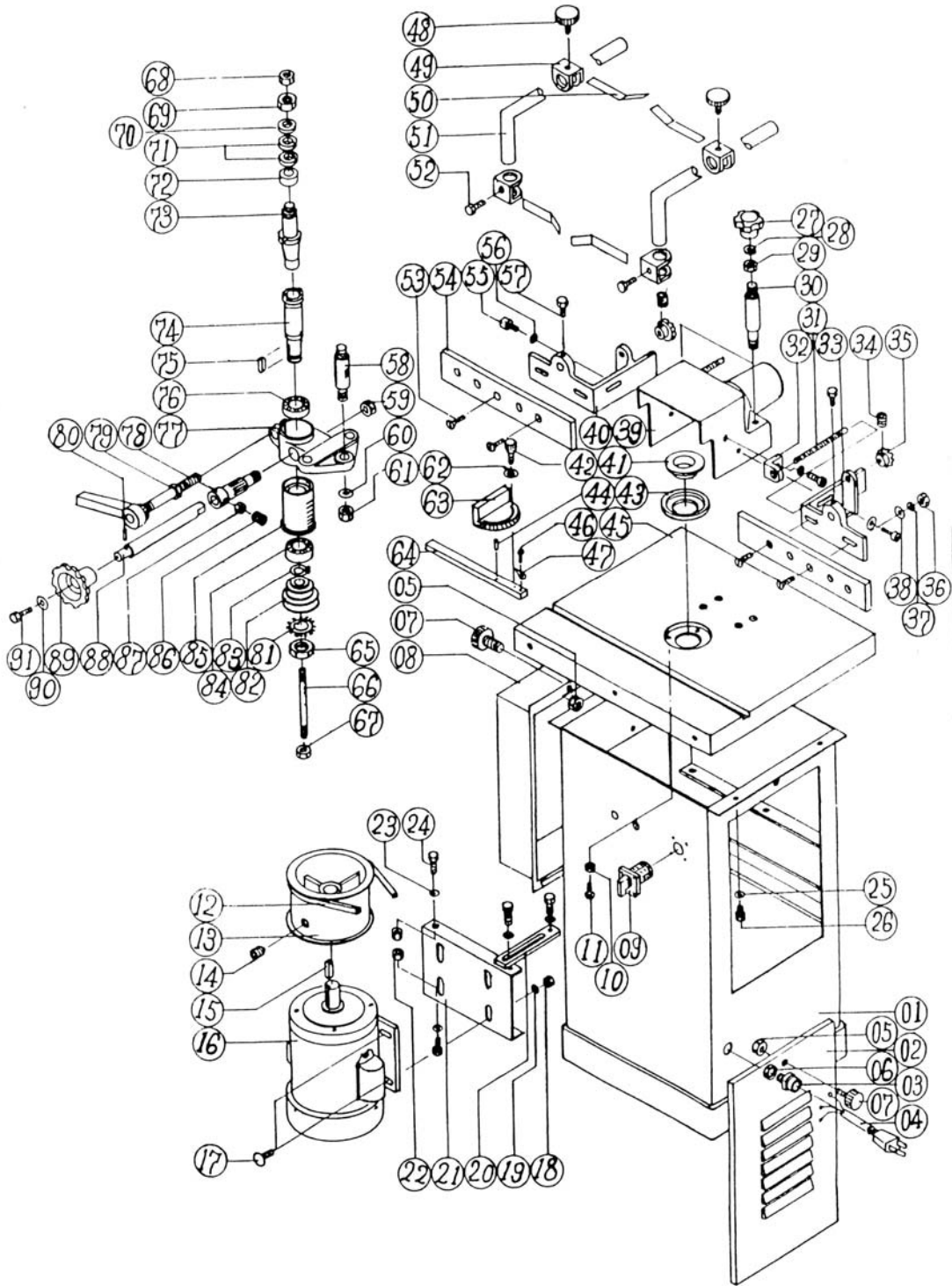


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PARTS LIST

NO.	Description	QTY.	NO.	Description	QTY.
01	Cabinet	1	47	Indicator	1
02	Cover	1	48	Lock Knob	1
03	Cable Lock Screw	1	49	'U' Type Bracket	4
04	Cable	1	50	Spring Steel Hold-Down	4
05	1/4" Cable Nut	2	51	'L' Bar	2
06	Cable Lock Screw	1	52	3/8" x 1" Screw	2
07	Cover Screw	2	53	5/16" x 1 1/2" Screw	4
08	Motor Cover	1	54	Fence	2
09	Forward/Reverse Switch	1	55	3/8" x 1" Screw	2
10	3/16" Nut	3	56	Dim. 3/8" Flat Washer	2
11	3/16"x 1 1/4" Screw	3	57	3/8" x 1" Screw	2
12	K23 Belt	1	58	Double Head Screw Bar	3
13	Motor Pulley	1	59	1/2" x 20 Thread Nut	1
14	1/4" x 3/8" Socket Head Screw	1	60	Dim. 1/2" Flat Washer	3
15	5mm Key	1	61	1/2" Nut	3
16	Motor	1	62	Dim. 1/4" Flat Washer	1
17	5/16" Screw	4	63	Miter Gauge	1
18	5/16" Nut	4	64	Miter Gauge Bar	1
19	Dim. 5/16" Flat Washer	4	65	Spindle Nut	1
20	Lock Bar	1	66	Double Head Screw Bar	1
21	Motor Plate	1	67	3/8" Nut	1
22	5/16" Nut	2	68	5/8" Nut	1
23	Dim. 5/16" Flat Washer	4	69	3/4" Nut	1
24	5/16" x 1" Screw	4	70	Collar	1
25	Dim. 3/8" Flat Washer	3	71	Collar	1
26	3/8" x 3/4" Screw	3	72	Collar	1
27	Lock Knob	2	73	Spindle	1
28	Dim. 3/8" Spring Washer	2	74	Shaft	1
29	3/8" Nut	2	75	5mm Key	1
30	Dust Chute Lock Bar	2	76	600S Z Bearing	1
31	Adjustable Screw Bar	2	77	Spindle Bracket	1
32	Fence Support	2	78	Raising Handle	1
33	Right Fence	1	79	Lock Handle	1
34	1/4" x 1/4" Socket Head Screw	2	80	Key	1
35	Adjustable Screw	2	81	Gear Washer	1
36	5/16" Nut	4	82	Spindle Pully	1
37	Dim. 5/16" Spring Washer	4	83	Clip	1
38	Dim. 5/16" Flat Washer	4	84	600S Z Bearing	1
39	Dust Chute	1	85	Spindle Column	1
40	Left Fence	1	86	5/16" x 5/8" Socket head Screw	1
41	Table Insert	1	87	5/16" Nut	1
42	Handle	1	88	Extension Bar	1
43	Table Insert	1	89	Handle Wheel	1
44	Key	1	90	Dim. 1/4" Flat Washer	1
45	Table	1	91	1/4" x 1" Screw	1
46	3/16" x 3/8" knob	1	92	Screw Box	1

B1363N SCHEMATIC DIAGRAM



B1363N ACCESSORIES

The following accessories are available from Busy Bee Tools and will fit your B1363N Wood Shaper.

Rub Collar Sets.

Bump Free Operation.
Machined From Solid Steel.
Sealed Bearings.

Model	Inside Dia.	Outside Dia.
W1114	3/4"	1 5/8"
W1115	3/4"	1 11/16"
W1118	3/4"	1 7/8"
W1119	3/4"	2"
W1120	3/4"	2 1/8"
W1125	3/4"	2 1/2"
W1126	3/4"	2 3/4"



**6pc Door and Cabinet
Shaper Set, Carbide
Tipped**



LIMITED
LIFE-TIME
WARRANTY

Model # SCT065



**4pc Door &
Raised Panel
Set**



LIMITED
LIFE-TIME
WARRANTY

Model # SCT270

*For a complete listing of shaper
cutters and other handy accessories
for your shaper, visit
www.busybeetools.com*





CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

Proof of purchase is necessary.

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etcetera.

Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY, and have your credit card and part number handy.

All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.

- Returns must be pre-authorized by us in writing.
- **We do not accept collect shipments.**
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.



