



CXP02
1/4-HP FOUR SPEED
POWER FEEDER
User Manual



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GENERAL SAFETY INSTRUCTIONS FOR MACHINES

Extreme caution should be used when operating all power tools. Know your power tool, be familiar with its operation, read through the owner's manual and practice safe usage procedures at all times.

- ❖ **ALWAYS** read and understand the user manual before operating the machine.
- ❖ **CONNECT** your machine **ONLY** to the matched and specific power source.
- ❖ **ALWAYS** wear safety glasses respirators, hearing protection and safety shoes, when operating your machine.
- ❖ **DO NOT** wears loose clothing or jewelry when operating your machine. Wear protective hair covering.
- ❖ **A SAFE ENVIRONMENT** is important. Keep the area free of dust, dirt and other debris in the immediate vicinity of your machine.
- ❖ **BE ALERT! DO NOT** use prescription or other drugs that may affect your ability or judgment to safely use your 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 a tool unattended while it is in operation.
- ❖ **NEVER** allow unsupervised or untrained person to operate the machine
- ❖ **NEVER** reach over the table when the tool is in operation.
- ❖ **ALWAYS** keep blades, knives and bits sharpened and properly aligned.
- ❖ **ALL OPERATIONS MUST BE** performed with the guards in place to ensure safety.
- ❖ **ALWAYS** use push sticks and feather boards to safely feed your work through the machine.
- ❖ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❖ **ALWAYS** keep bystanders safely away while the machine is in operation.
- ❖ **NEVER** attempt to remove jammed cutoff pieces until the blade has come to a full stop.

CXP02 POWER FEEDER SPECIFIC SAFETY INSTRUCTIONS

- ❖ **ALWAYS READ** and understand the user manual before operating the power feeder.
- ❖ **MAKE SURE** the cutting tools are rotating at the operating speed before feeding the work-piece into the cutter.
- ❖ **NEVER OVERLOAD** the cutting tool by feeding too quickly. The tool will perform better and be safer at the rate for which it is designed.
- ❖ **KEEP YOUR FINGERS** away from the rotating parts. Make sure hands and clothing are safely away from the rotating parts or the work-piece.
- ❖ **DO NOT FEED** long work-pieces without providing proper support at the out-feed end of the table.
- ❖ **ALWAYS STOP** the feeder first, then the machine.
- ❖ **MAKE SURE** before making any adjustments, the switch is in the “OFF” position and the cord is un-plugged from the power source.
- ❖ **BEFORE OPERATING** your feed make sure you have read and understood all the safety instructions in the manual and you are familiar with your feeder. If you fail to do so, serious injury could occur.

WARNING

The safety instructions given above can not be complete because the environment in every shop is different. Always consider safety first as it applies to your individual working conditions.



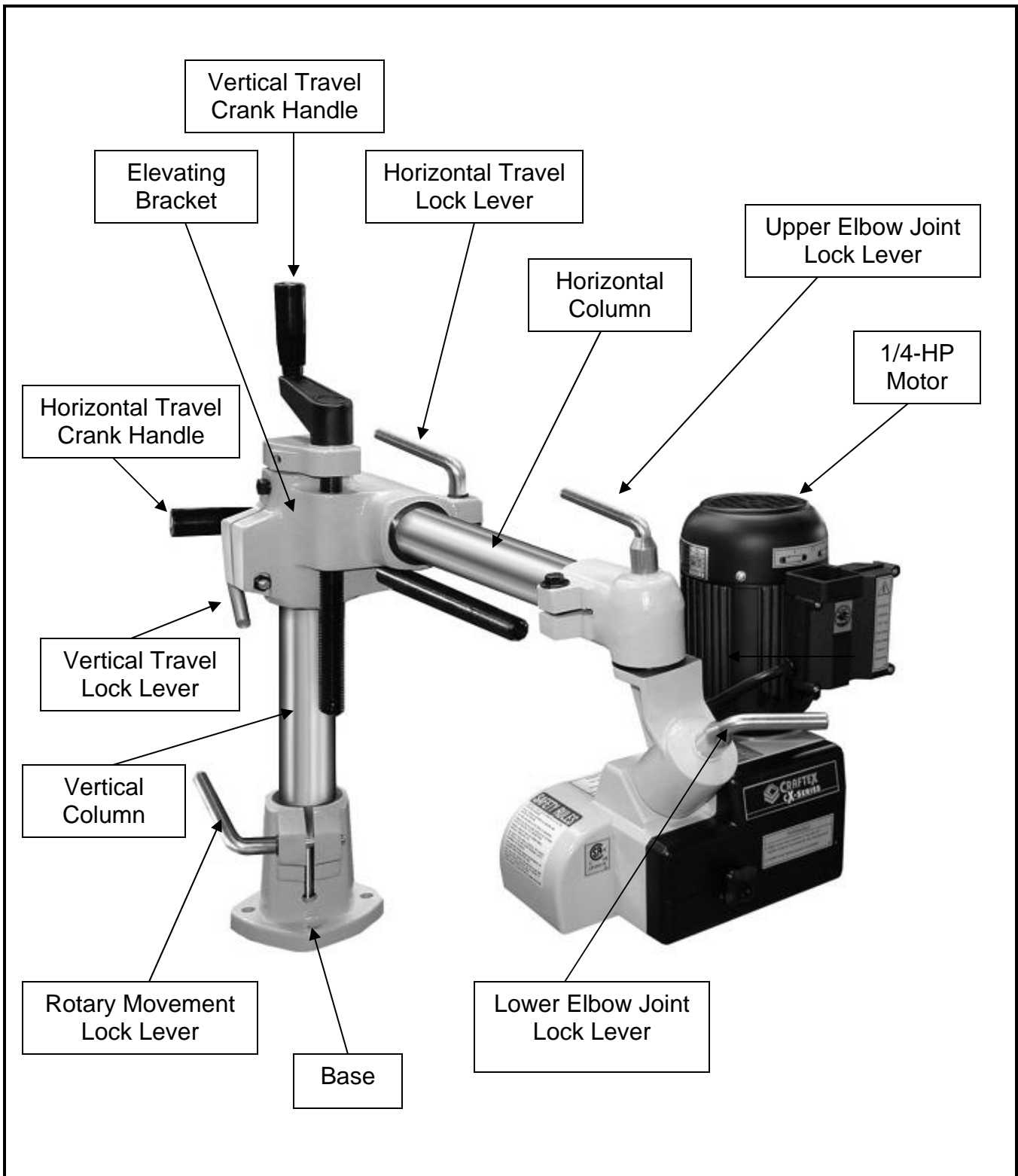
CXP02 POWER FEEDER FEATURES

MODEL CXP02 – 1/4-HP FOUR SPEED POWER FEEDER

As part of the growing line of Crafttex woodworking equipment, we are proud to offer the CXP02, A 1/4-HP Four Speed Power Feeder. The Crafttex name guarantees Craft Excellence. By following the instructions and procedures laid out in this user manual, you will receive years of excellent service and satisfaction. The CXP02 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- ❖ Motor 1/4-HP, 110-Volts, Single Phase, 60-Hz, 1720-RPM
- ❖ Power Transfer Gear Box
- ❖ Number of Speeds..... Four
- ❖ Feed Speeds 20, 26, 33, 43 FPM
- ❖ Swing..... 360-Degree
- ❖ Vertical Movement..... 6-3/4"
- ❖ Horizontal Movement..... 9-3/4"
- ❖ Feed Direction Forward and Reverse
- ❖ Number of Rollers..... 3
- ❖ Roller Width 1-1/8"
- ❖ Roller Diameter..... 3-1/16"
- ❖ Roller Construction Synthetic Rubber
- ❖ Housing Construction Cast Aluminum
- ❖ Column Construction Steel
- ❖ Paint Powder Coated Paint
- ❖ Length/Width/Height 34" x 13" x 24"
- ❖ Weight 75 lbs
- ❖ Warranty 3 Years

CXP02 1/4-HP POWER FEEDER PHYSICAL FEATURES



UNPACKING

The power feeder is properly packaged and shipped completely in a box for safe transportation. When unpacking, carefully inspect the box and ensure that nothing has been damaged during transit.

Open the box and check that the power feeder and the parts are in good condition.

POWER FEEDER POSITIONS

Position the power feeder on the table top of your machine to determine where to drill the base mounting holes so that you minimize the power feeder swing and adjustments.

The figure below shows the power feeder mounting position on a table saw, a jointer and a shaper.

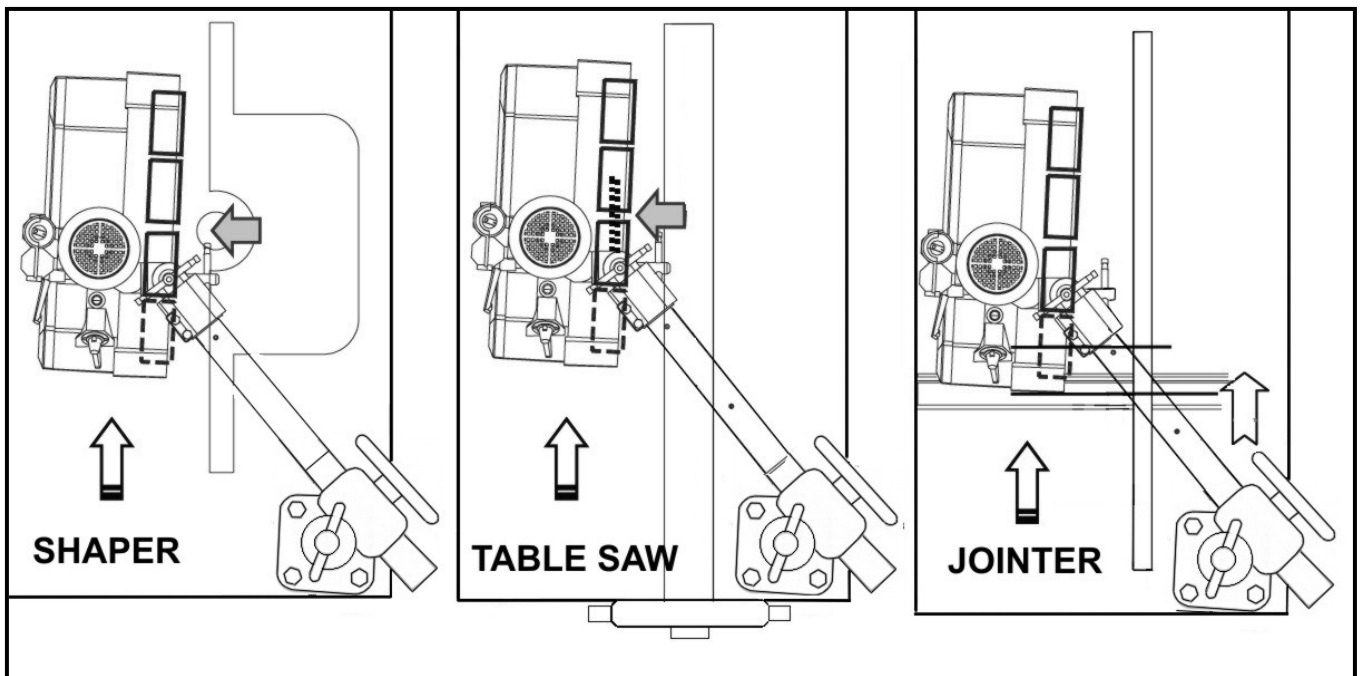


Figure-1 Power feeder mounting position on a shaper, table saw and jointer

MOUNTING

Place the power feeder base on the table surface where you want to mount the power feeder.

Mark the 4 holes on the table surface through the holes on the base using a center punch.

Remove the base, drill and tap 4 holes on the table surface.

Mount the base on the table surface using 4 sets of bolts and spring washers (not provided). Make sure the bolts are longer than the mounting base thickness plus the table top thickness.

ASSEMBLY

Insert the vertical column assembly into the base opening and tighten the lever as shown in figure-2.

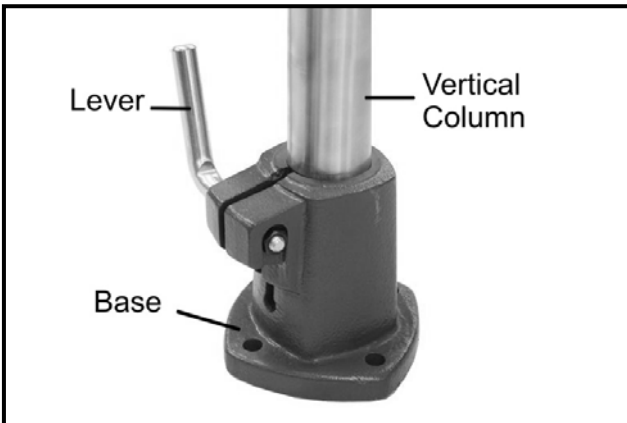


Figure-2 Vertical column secured into the base opening

Now slide the horizontal column assembly into the elevating bracket as shown in figure-3.

Slide the elevating bracket with the horizontal column onto the vertical column as shown in figure-3 and tighten the levers.

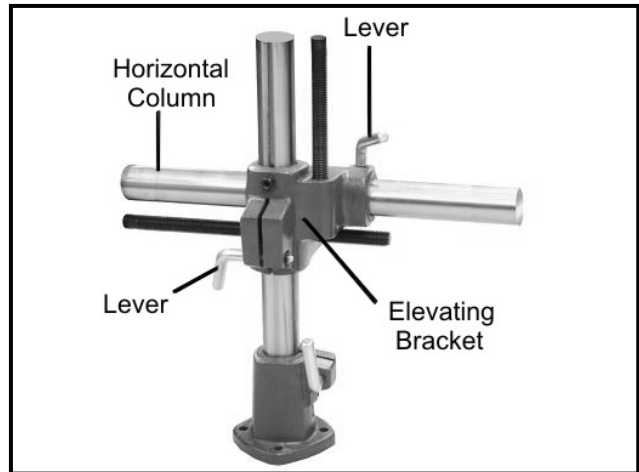


Figure-3 Horizontal column and elevating bracket assembly

Now attach the column caps on the top of the vertical column and to the left end of the horizontal column and secure it using set screws (provided) as shown in figure-4.

Install the crank handle assemblies on to the vertical and horizontal column caps and secure it using screws provided. See figure-4.

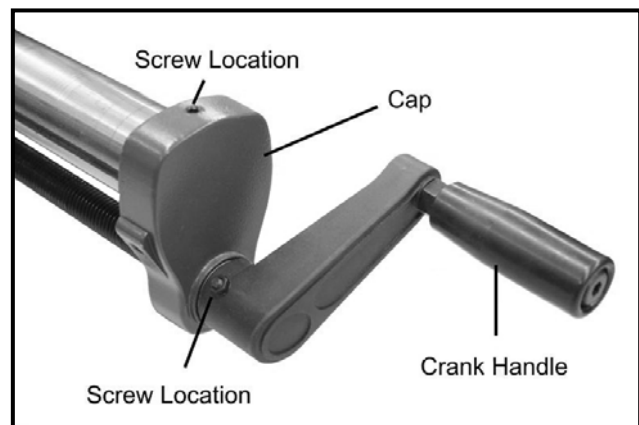


Figure-4 Installing the column cap and crank handle assembly

Slide the elbow joint with the power feeder assembly on to the horizontal column as shown in figure-5 and tighten the screw to secure the elbow to the column.

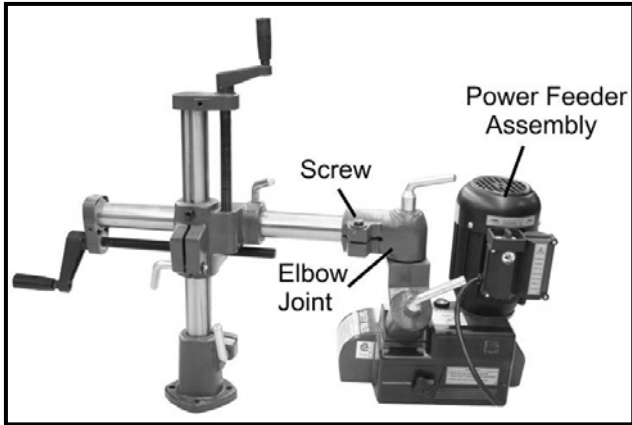


Figure-5 Attaching the power feeder assembly to the horizontal column

POWER CONNECTION & GROUNDING

CXP02 Power Feeder is a supplemental tool, which works in conjunction with your shaper, table saw or jointer etc... It's recommended to be used with a machine that is wired in compliance with your national or local electrical regulation.

Make sure that the appliance is connected to an outlet having the same configuration as the plug. If an adaptor plug is used, it must be attached to the metal screw of the receptacle.

SPEED CHANGES

The CXP02 is a four speed power feeder and the feed rates are; 20, 26, 33 and 43 feet per minute.

To change the speed of your power feeder:

Make sure the switch is in the OFF position and the cord is disconnected from the power source.



Figure-6 Forward/reverse switch in the OFF position

Look at the feed rate list below and select the right feed rate required.

The feed rate table is also attached to the inside of the gear cover on your power feeder.

	Gears	Speed / Minute
		60 HZ
<div style="display: flex; align-items: center; justify-content: center;"> <div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin-right: 10px;"> B </div> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-right: 10px;"> A </div> </div>	A20 - B30	6M(20FT)
	A24 - B26	8M(26FT)
	A26 - B24	10M(33FT)
	A30 - B20	13M(43FT)

Remove the gears cover on your machine by un-screwing the knob securing the cover.

Remove the two hex nuts securing the gears and remove the chain and the gears.

Take a look at the feed rate table given on page-9 and install the gears as instructed to achieve the required speed.

Re-install the hex nuts.

Make sure the gear hubs are facing in towards the power feeder. See figure-7.

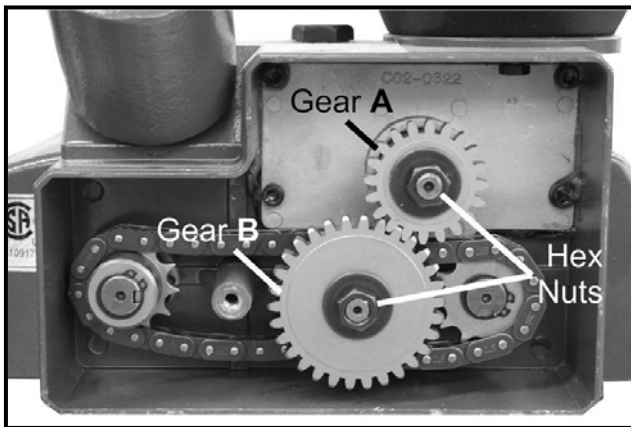


Figure-7 Change gears

FEED RATE SETTINGS

Choosing the right feed rate is important to achieve efficiency and quality. It is closely related to the speed of your machine, the sharpness of cutter, the hardness and the thickness of the material to be cut.

Feed rate chart below is for reference only.

Feeding speed Thickness of work piece	Spindle Speed		
	6000 R.P.M.	8000 R.P.M.	10000 R.P.M.
6 mm	9	15	23
10 mm	8	12	15
20 mm	5	9	12
25 mm	3	5	6

MAINTENANCE

During the life of your tool, you will need to practice some regular maintenance to keep your feeder in peak performance condition.

WARNING

When installing / removing and servicing any part of the machine, make sure the power switch is in the off position and the cord is disconnected from the power source. Failure to do so may result in serious personal injury or death.

ROLLER REPLACEMENT

Turn the switch to OFF position and un-plug the cord from the power source.

Remove the screws securing the rollers and replace the rollers with the new ones.

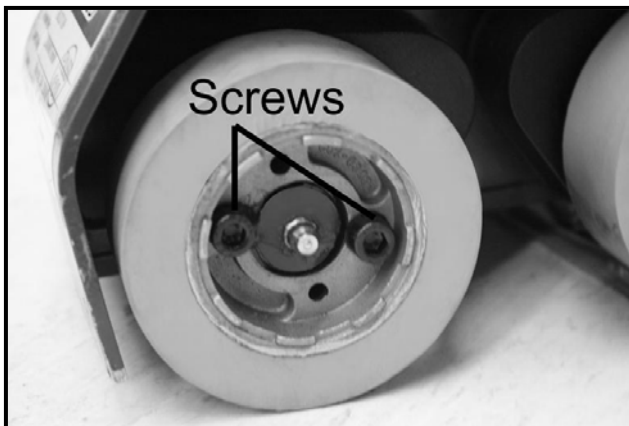


Figure-8 Removing the screws securing the roller

Remember that, rotating the roller positions periodically will prolong the life of rollers.

LUBRICATING THE ROLLERS

Using a grease gun, apply a thin layer of grease after every 200 hours or 30 days into the fittings.

GEARS AND CHAINS

Lubricate the gears and chains periodically with grease.

GEAR BOX

Change the gear box oil after every 1000 hours or 6 months, if you are using your power feeder 8 hours every day.

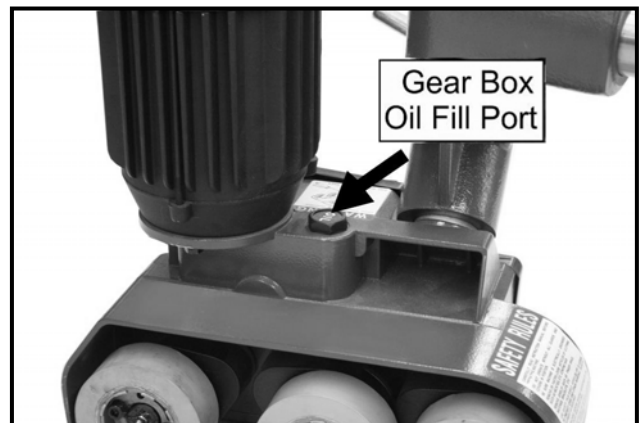
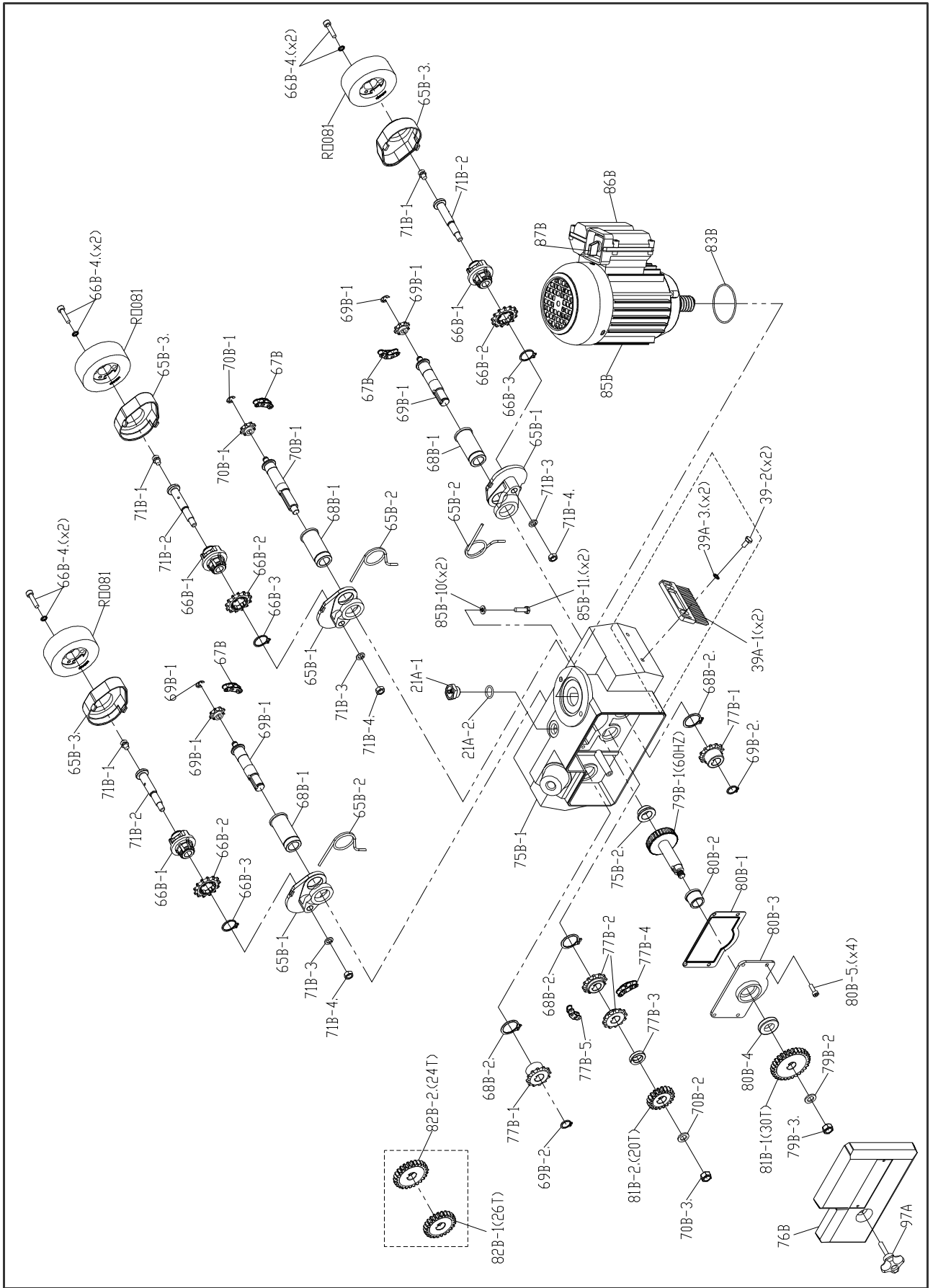


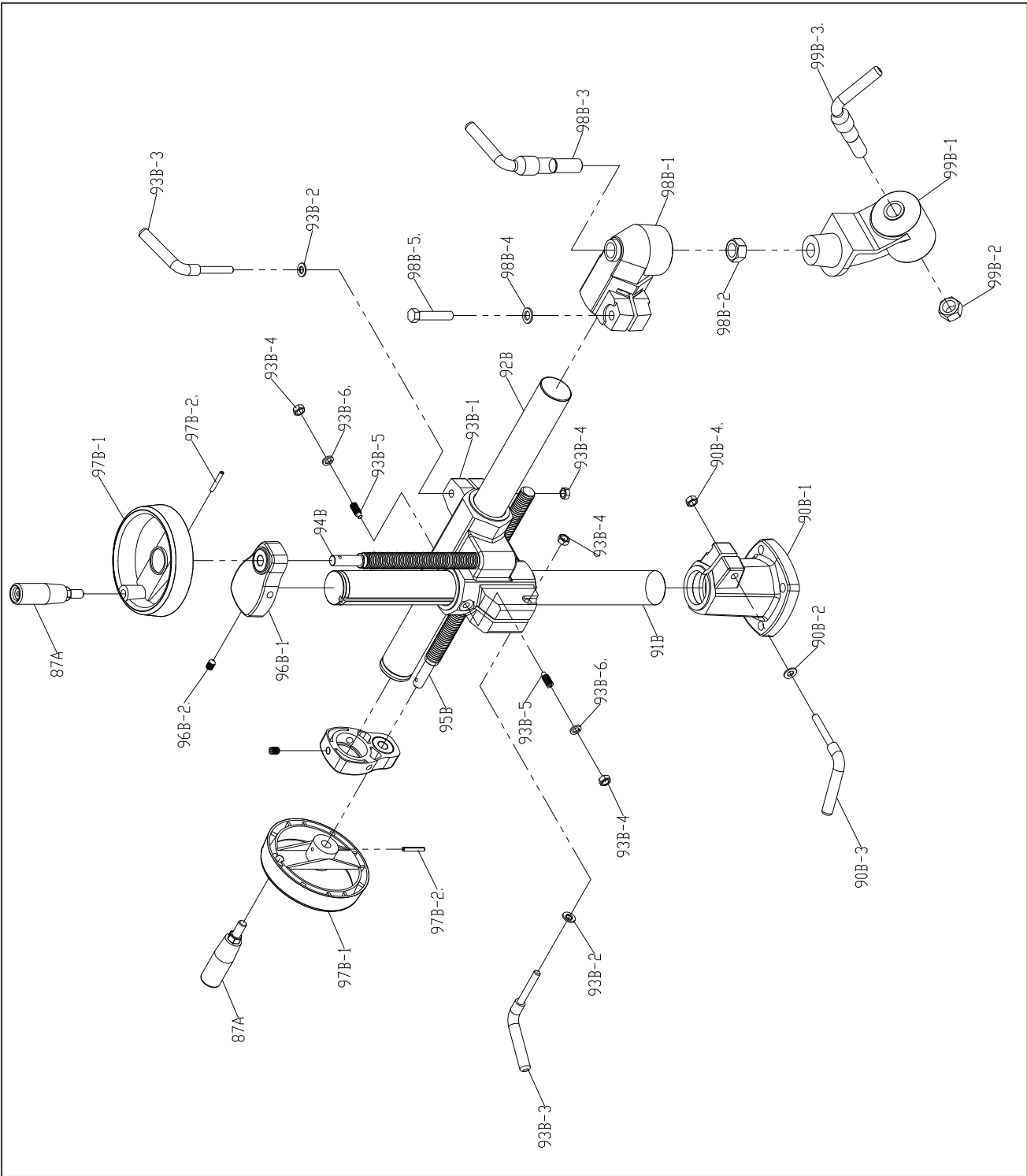
Figure-9 Gear box oil fill port

CLEANING

Dust build up around the motor can decrease the life of the motor. Make sure the motor and the rollers remain free and clear of all dust and debris build up.



Part #	Code #	Description	Q'ty	Part #	Code #	Description	Q'ty	Part #	Code #	Description	Q'ty
21A	21A	Oil-Cap Kit	1	70B	70B	Sprocket Shaft Kit (S)	1	79B-3	N11010R	Nut (M10-1.5P)	1
21A-1	U010008	Oil Cap	1	70B-1	G320017A	Sprocket Shaft	1	80B	80B	Wormgear Cover Kit	1
21A-2	Q010015	"O" Ring (P15)	1	70B-2	N015925	Flat Washer (3/8"x25D)	1	80B-1	U210007	Oil Seal	1
39A	39A	Brush Kit (2 each)	2	70B-3	N11010R	Nut (M10-1.5P)	1	80B-2	A500302	Bushing (29Dx23Dx(15+3))	1
39A-1	U010088	Brush	1	71B	71B	Roller Spindle Kit (S)	3	80B-3	C020322	Wormgear Cover	1
39A-2	S600612	Hex Screw (M6-1.0Px12)	2	71B-1	T315106	Grease Nipple (M6-1.0Px1.0)	1	80B-4	O021701	Oil Seal (17x32x7l)	1
39A-3	N050057	Lock Washer (1/4")	2	71B-2	G320067	Sprocket Shaft	1	80B-5	S900512	Cap Screw (M5-0.8Px12L)	4
65B	65B	Sprocket Case Kit	3	71B-3	N030008	Spring Washer (8.3x1.8t)	1	81B	81B	Gear Kit 20T/30T(S)	1
65B-1	C020331	Sprocket Case	1	71B-4	N11008R	Nut (M8-1.25P)	1	81B-1	A500327	Gear (30T)	1
65B-2	N950003	Spring (φ30xφ3)	1	75B	75B	Frame Kit (32)	1	81B-2	A500324	Gear (20T)	1
65B-3	U010054	Case Cap	1	75B-1	C020321	Frame (32)	1	82B	82B	Gear Kit 24T/26T(S)	1
66B	66B	Roller Supporter(S)	3	75B-2	A500306	Bushing (29Dx23Dx(7+3))	1	82B-1	A500323	Gear (26T)	1
66B-1	C020334A	Roller Supporter	1	76B	U010031	Back Cover (AF32)	1	82B-2	A500326	Gear (24T)	1
66B-2	A500336	Sprocket (13T)	1	77B	77B	Transmission Kit	1	83B	O010060	"O" Ring (G60)	1
66B-3	N510022	Snap Ring (22)	1	77B-1	A500303	Sprocket	2	85B1	85B1	Motor Kit (1/4HP, 1Ph)	1
66B-4	S900625	Cap Screw (M6-1.0Px25L)	2	77B-2	A500307	Double Sprocket	2	85B3	85B3	Motor Kit (1/4HP, 3Ph)	1
67B	K330018	Chain (18S)	3	77B-3	A500308	Bushing	1	85M1	85M1	Motor/Switch (1/4HP, 1Ph)	1
68B	68B	Tube Kit (S)	3	77B-4	K330030	Chain (30S)	1	85M3	85M3	Motor/Switch (1/4HP, 3Ph)	1
68B-1	A500331	Tube	1	77B-5	K330022	Chain (22S)	1	86B	86B	Switch Box Kit (S)	1
68B-2	N510026	Snap Ring (26)	1	79B	79B	Worm Gear Kit 60Hz	1	87B	J120007	Switch	1
69B	69B	Sprocket Shaft Kit (S)	2	79B-1	G320016	Wormgear Spindle 60Hz	1	97A	U010051	Knob (M6-1.0Px30L)	1
69B-1	G320018A	Sprocket Shaft	1	79B-2	N015925	Flat Washer (3/8"x25D)	1	RO081	C020302	Roller (φ80x30mm)	3
69B-2	N510015	Snap Ring (15)	1								



Part #	Code #	Description	Q'ty
87A	U010011	Wheel-Handle (M10-P1.5x70L)	2
90B	90B	Base Kit (S)	1
90B-1	A200326	Column Base (S)	1
90B-2	N015816	Flat Washer (5/16"x16)	1
90B-3	G020012	Lever (M8)	1
90B-4	N11008R	Nut (M8-1.25P)	1
91B	G020013	Elevating Column (465L)	1
92B	G020014	Overarm (465L)	1
93B	93B	Elevating Bracket Kit (S)	1
93B-1	A200327	Elevating Bracket (S)	1
93B-2	N015816	Flat Washer (5/16"x16)	2
93B-3	G020012	Lever (M8)	2
93B-4	N11008R	Nut (M8-1.25P)	4
93B-5	G000008	Set Screw (M8-1.25P x20L)	2
93B-6	N030008	Spring Washer (8.3x1.8t)	2
94B	G320092	Elevating Screw (M18-P2.5x240)	1
95B	G320091	Extension Screw (M18-P2.5x320)	1
96B	96B	Column Cap Kit (S)	2
96B-1	G020323A	Column Cap (S)	1
96B-2	G000005	Set Screw (M8-1.25P x12L)	3
97B	97B	Handwheel Kit (S)	2
97B-1	G020301	Handwheel (S)	1
97B-2	N810430	Lock Pin (4x30L)	1
98B	98B	Overarm Cone Kit (S)	1
98B-1	A200328	Overarm Cone (S)	1
98B-2	N11216R	Nut (M16-P1.5)	1
98B-3	G020011	Lever (M16-P1.5)	1
98B-4	N015925	Flat Washer (3/8"x25D)	1
98B-5"	S601050	Hex Screw (M10-1.5Px50L)	1
99B	99B	Swivel Cone Kit (S)	1
99B-1	A200321	Swivel Cone (S)	1
99B-2	N11216R	Nut (M16-P1.5)	1
99B-3"	G020011	Lever (M16-P1.5)	1



WARRANTY

CRAFTEX 3 YEARS LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **three years** for parts and 90 days for labor (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 etceteras.

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 or call 1-800-461-BUSY. 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 (2879), 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.