MODEL CX06HC

6” HELICAL JOINTER USER MANUAL

Version 1

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GENERAL SAFETY INSTRUCTIONS

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** wear loose clothing or jewelry when operating your machine.
- **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** 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.

WARNING!

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

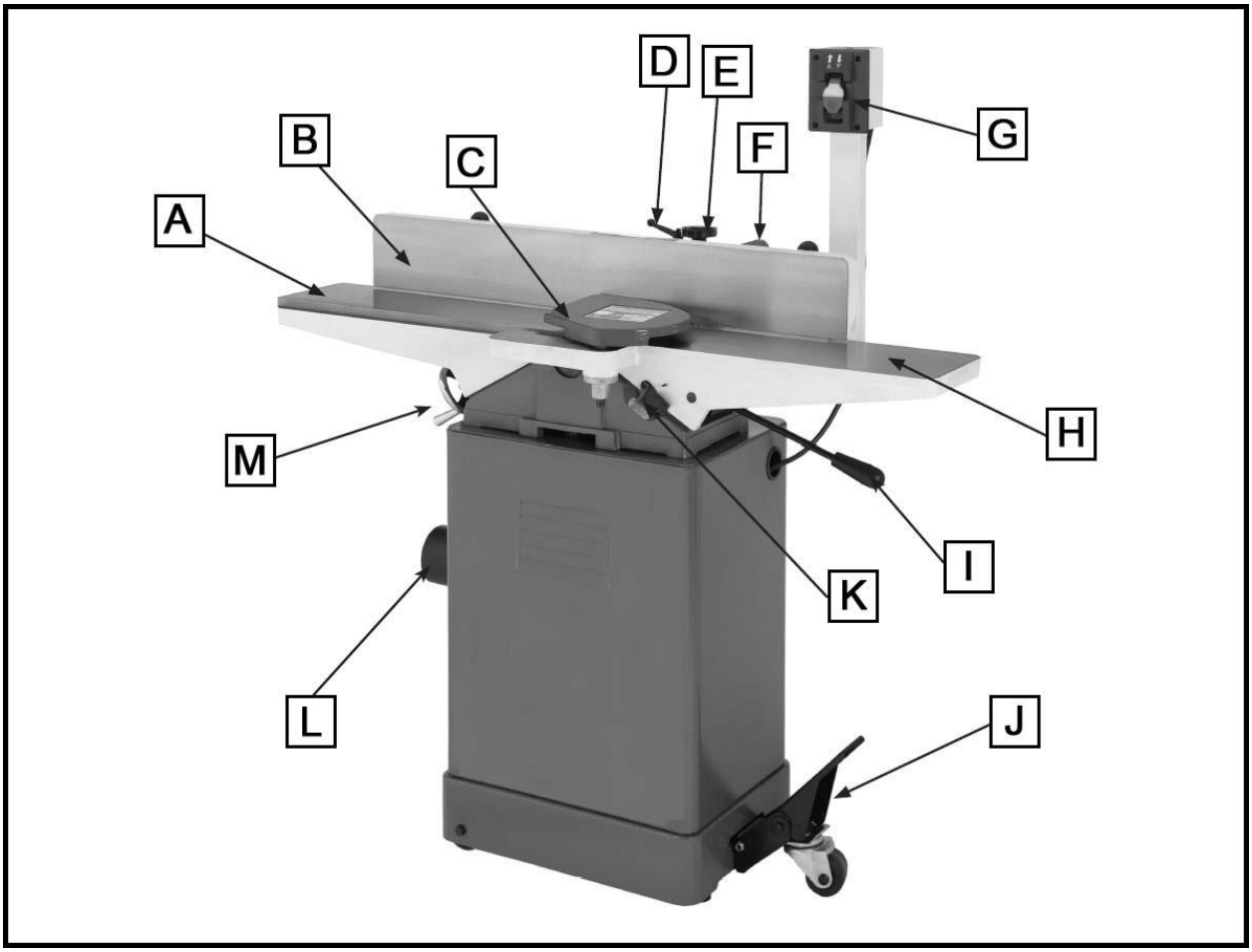
CX06HC

MACHINE SPECIFICATIONS

Table Size	6” W x 46” L
Table Height	32-1/2”
Overall length	46”
Overall Width	27-1/2”
Shipping weight	80 kg
Net Weight	74 kg
Box 1 Size	48-1/2” x 21” x15”
Box 2 Size	20-1/2” x 15-3/4” x 28-3/4”
Foot Print	18” x 13-1/2”
Maximum Depth of cut	1/8”
Maximum Width of Cut	6”
Cutterhead Diameter	2-1/2”
Cutterhead Speed	4800 RPM
Cuts Per Minute	14400
Tables	Independently Adjustable, Precision Ground Cast Iron
Stand	Preformed Steel
Ways	Dovetailed, Adjustable
Fence Assembly	Cast Iron
Body Assembly	Cast iron
Base	One Piece Steel Cabinet
Cutterhead	Helical
Number of Inserts	32
Guard	Die Cast Metal
Bearings	Sealed Permanently Lubricated
Motor:TypeTEFC	TEFC Capacitor Start Induction
Phase / Voltage	Single – 110Volt
Amps	14A
Cycle / RPM	60 Hertz / 3450 RPM
Power Transfer	V-Belt Drive
Bearings	Sealed & Lubricated Ball Bearings
Fence	Center Mounted, Positive Stops at 45 Deg & 90 Deg
Table Movement	Hand wheel/Lever and infeed & Outfeed tables
	½” Rebating Capacity Built-In

Specifications, while deemed accurate, are not guaranteed.

Identification



A. Outfeed table
B. Fence
C. Cutterhead Guard
D. Fence Lock
E. Fence Adjustment Knob
F. Fence Tilt Handle
G. Control Panel
H. Infeed Table
I. Infeed Table Lever
J. Locking Foot Pedal
K. Depth Scale
L. Dust Port
M. Outfeed Table Handwheel

POWER SUPPLY

AVAILABILITY OF POWER

Before Installation of this machine you will need to consider the proximity of your power supply circuit. If available circuits do not meet the requirements for this machine you will have to get a new circuit installed by a licensed electrician. Use of a licensed electrician will minimize the risks of fire, electrocution, damage to equipment, and will insure everything is wired in accordance to the applicable codes and standards.

FULL LOAD CURRENT RATING

This is the amount of Amps a machine draws under 100% of the rated output power.

FULL LOAD RATING FOR 120V 15AMPS

The full load current is not the maximum amount of amps the machine will draw. The machine has potential to draw current beyond the full load rating if it is overloaded. Overloading of the machine for an extended period of time can cause damage, overheating, or even fire. The risk is higher if the machine is on an undersized circuit. To help avoid these issues insure you are connected to a circuit that meets the specified circuit requirements for this piece of machinery.

WARNING!!!

Do not connect machine to power before setup has been fully completed to avoid risk of personal injury or property damage.

CIRCUIT REQUIREMENTS FOR CX06HC JOINTERS

The CX06HC has been prewired at the factory for operation on an electrical circuit that has a verified ground and meets the below requirements:

Voltage: 110V – 120V
Cycle: 60Hertz
Phase: Single
Circuit Breaker Size: 20Amps

Please Note:

1. An electrical circuit includes all electrical equipment between the breaker panel and the machine. This is why it is important to have the proper circuit size so it can safely accommodate this machine under full load for an extended period of time.
2. The circuit requirements laid out in this manual are for a dedicated circuit in which only one machine will be operational or installed at a time.

3. If you choose to connect to a shared circuit where more than one machine may be running at a time please consult with a qualified electrician to insure the circuit is properly sized for safe operation.

PLUG AND GROUNDING REQUIREMENTS

This machine must be grounded so that in the event of certain malfunctions it will reduce the chances of electrical shock by providing a path of least resistance for the electric current to travel through. For this reason the CX06HC comes with a cord with an equipment grounding wire that leads in to the grounding prong on the plug.

NOTE:
The three prong plug is only to be plugged in to the matching receptacle that is properly installed according to the local electrical codes and standards. Under no circumstances should you modify the plug to make it fit in a receptacle that it is not meant for this configuration. (see figure 1)

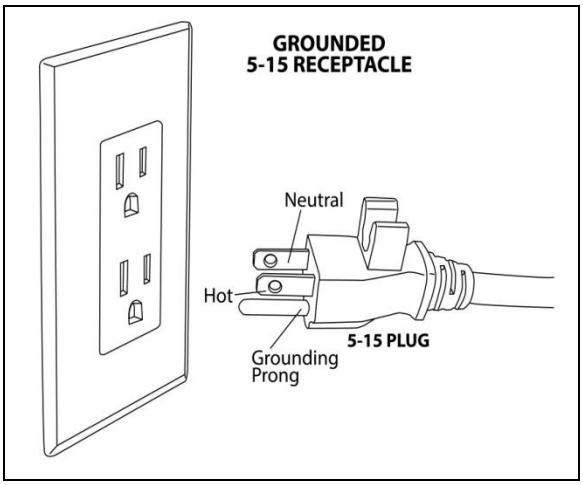


Figure 1

If there is an improper connection of a machine grounding wire it may result in a heightened risk of electric shock. If repair or replacement of the power cord is necessary in the future please consult a licensed electrician.

NOTE:
If ever you notice damage or wear to either the cord or plug disconnect it immediately from the power supply and have it replaced by a licensed electrician or service tech before any further use of the machine.

USE WITH EXTENSION CORDS

If you absolutely must require the use of an extension cord with your machine do so, on a temporary short term basis only.

NOTE:

1. We recommend that you do not use an extension cord with this machine. Also the longer the extension cord the greater the possibility of voltage drop causing the motor to work harder under powered which in turn will cause it to draw more amps. This may cause the thermal overload to trip or even the breaker in your electrical panel. It may also cause the extension cord to heat up which can be a potential fire hazard.

2. If an extension cord is used with this machine it must have a ground wire with a plug that matches the one currently installed on your machine. The extension cord must also meet the following specifications below:

Minimum Wire Gauge: ..... **14 AWG**
Maximum Cord Length: ..... **50 ft.**

SETUP

WARNING!

This machine presents a serious injury hazard to untrained users. Read through this entire manual to become familiar with controls and operations before starting the machine!

WARNING!

Always wear safety glasses during the setup and operation of this machine!

WARNING!

This Machine weighs 80kg. DO NOT overexert yourself while unpacking or moving your machine. GET ASSISTANCE!

Tools Required for Setup

The tools listed below are not included with your machine

- 48" Straightedge.....1
- Safety glasses.....1
- Dust Collection System (optional)...1
- 4" Dust Hose (optional).....1
- 4" Hose Clamp (optional).....1
- Phillips Head Screwdriver.....1
- 13mm Wrench.....1
- 17mm Wrench.....1
- 19mm Wrench.....1
- 17mm Socket Wrench.....1
- Level.....1

Unpacking

This machine has been carefully packed prior to leaving our warehouse. If you discover the machine has been damaged after you have signed for delivery, please immediately call Customer Service or your local Busy Bee Outlet.
Save all containers and packing materials for possible inspection by the carrier or its agent.

When completely satisfied with your shipment you should inventory the contents.

INVENTORY

Inventory

Check for the following items packed in the two boxes you received. In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we will replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

Box 1: (Fig. A)

		Qty
A.	Table Assembly	1
B.	Fence Carriage Assembly	1
C.	Carriage Mounting Bracket	1
D.	Infeed table Lever	1
E.	Fence Tilt Handles	2
F.	Cutterhead Guard	1
G.	Push Blocks	2
H.	Outfeed Table Handwheel	1
I.	Fence Assembly	1
J.	Knife Setting Gauge	1

Hardware & Tools

	Qty
• Wrenches 8/10mm & 12/14mm	1 each
• Hex Keys 2.5, 3, 4, 6, & 8mm	1 each
• Cap Screws M10-1.5 x 20	3
• Cap Screws M10-1.5 x 25	2
• Hex Bolts M10-1.5 x 55	2
• Lock washers 10mm	5
• Flat washers 10mm	7
• Hex Nuts M10-1.5	2
• Hex Bolt M8-1.25 x 50	1
• Cap Screws M8-1.25 x 60	4
• Cap Screws M8-1.28 x 25	4
• Cap Screws M8-1.25 x 20	2
• Lock Washers 8mm	8
• Flat Washers	11
• Phillips Head Screws M5-.8 x 15	5
• Flat Washers M5	5

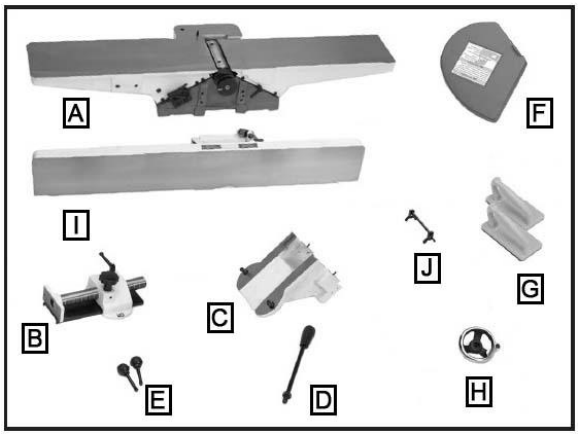


Figure A

Box 2: (Fig.B)

		Qty
A.	Cabinet	1
B.	Power Switch & Support Arm	1
C.	V-Belt	1
D.	Locking Foot Pedal	1
E.	Dust Port	1

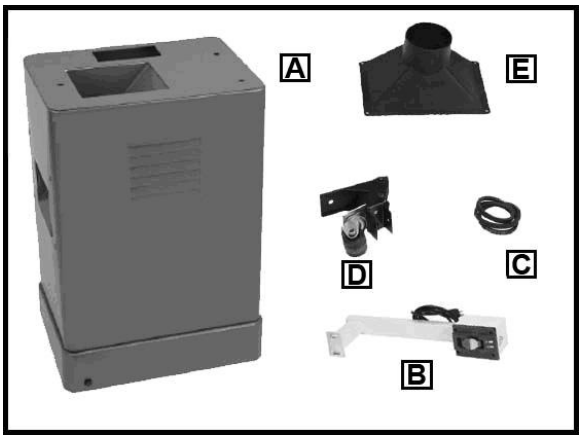


Figure B

Locking Foot Pedal

Components & Hardware Required:

	Qty
Cabinet	1
Locking Foot Pedal	1
Hex Bolts M10-1.5 x 55	2
Flat Washers 10mm	4

Hex Nuts M10-1.5	2
Hex Bolt M8-1.25 x 50	1

	Qty
Flat Washer 8mm	1

Tools Required

	Qty
17mm Wrench	1
17mm Socket Wrench	1
13mm Wrench	1
Level	1

Installing the locking foot pedal:

1. Lay the cabinet on its side as shown in (Fig.C). Notice the 3 hole in the cross brace.

Figure C

2. Place the locking foot pedal onto the cross brace. See Fig D.

3. Using the 13mm wrench, install the M8-1.28 x 50mm Hex Bolt and washer as shown in (Fig.D) (Install the hex bolt from the inside) from top to bottom so it threads into the foot pedal though the indicated holes in Fig. C.

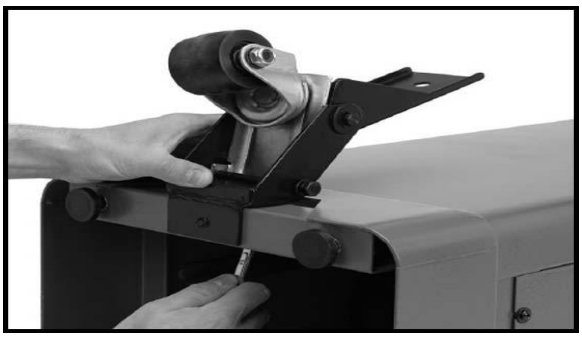


Figure D

4. Install the two M10-1.5 x 55 Hex Bolts, flat washers and nuts through the front of the locking foot pedal assembly as shown in (Fig. E)

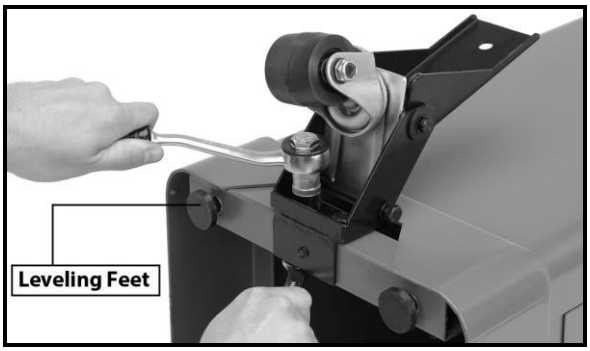


Figure E

5. Raise the cabinet to its upright position

6. Lift the foot pedal so machine remains stationary and can't roll.

7. Level the cabinet front-to-back and side-to-side by adjusting the leveling feet.

Mounting the Jointer

Components & Hardware Required:	**Qty**
Table Assembly	1
Cabinet	1
Cap Screws M10-1.5 x 20	3
Lock Washers 10mm	3
Flat Washers	3

Tools required:	Qty
8mm Hex Key	1
Extra Person for Lifting Help	1

CAUTION!
The jointer is heavy. Get assistance when lifting it in place onto the cabinet.

Mounting the jointer:

1. Remove the back cabinet cover

2. With the help of an assistant, lift the jointer onto the cabinet

3. Align the three bolt holes on the jointer to the three holes on the cabinet (Fig. F)

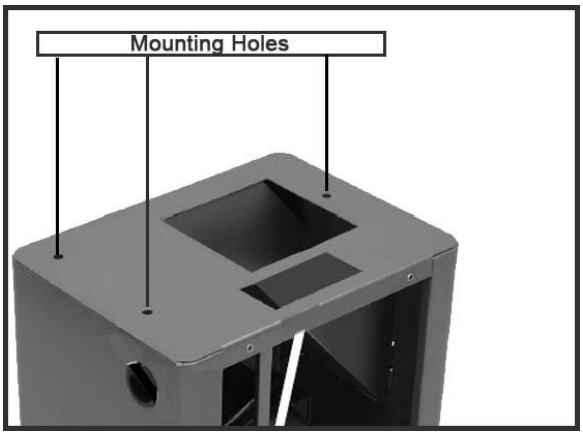


Figure F

4. With the 8mm Hex Key, secure the jointer to the cabinet with the M10-1.5 x 20 cap screws, flat washers and lock washers.

Note:
Reach through the dust vent for access to the forward mounting hole as in (Fig. G)

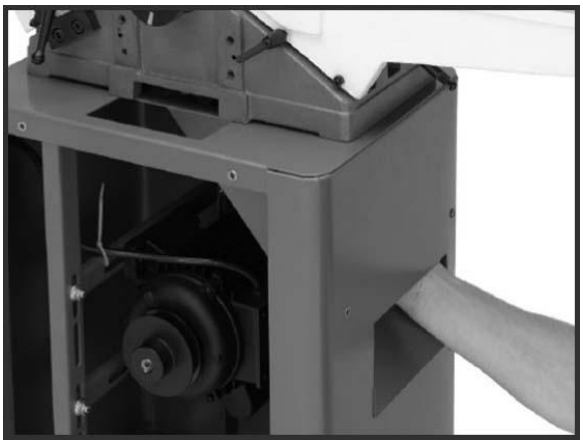


Figure G

V-Belt

Components & Hardware Required:

	Qty
V-Belt	1

Tools required:	Qty
13mm Wrench or Socket	1
6mm Hex Key	1

Installing the V-Belt

1. With the 13mm wrench, loosen but DO NOT remove the motor mount bolts

2. Lift the motor upward far enough to allow the V-belt to be placed around the cutterhead pulley and the motor pulley (Fig. H) and install V belt.

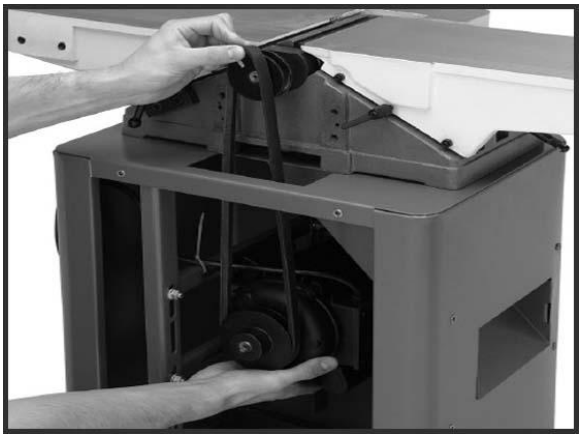


Figure H

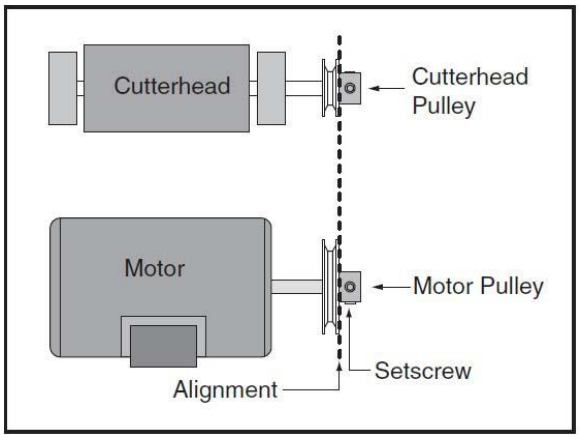


Figure I

3. Carefully allow the motor to slide downward, tensioning the V-belt with the weight of the motor.

4. Looking from the top, sight down the V-belt and pulleys and check that the pulleys are parallel and aligned with each other. (Fig. I)

    - If the pulleys are aligned, retighten the motor mount bolts and proceed to step 7

    - If the pulleys are NOT aligned, proceed to steps 5 & 6.

5. Remove the V-belt, loosen the set screws in the motor pulley and then align the motor pulley with the cutterhead pulley. If needed the motor can be loosened and moved backward and forward slightly to bring the pulleys into alignment.

6. Tighten the set screws and replace the V-belt. Repeat step 4 to check the pulley alignment, they should be perfectly aligned (Fig. I).

7. Now replace the back access cover on the cabinet then tighten motor mounting bolts.

Carriage Mounting Bracket

Components & Hardware Required:

	Qty
Carriage Mounting Bracket	1
Cap Screws M8-1.25 x 60	4
Lock Washers 8mm	4
Flat Washers	4

Tools required:

	Qty
6mm Hex Key	1

1. Align the locating pins on the back of the carriage mounting bracket with the sockets on the jointer table as shown in (Fig. J)

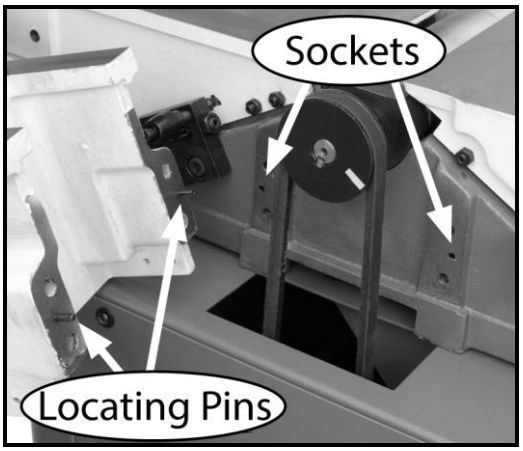


Figure J

2. Tighten the carriage mounting bracket to the jointer table with the cap screws, lock washers & flat washers supplied. (Fig. K)

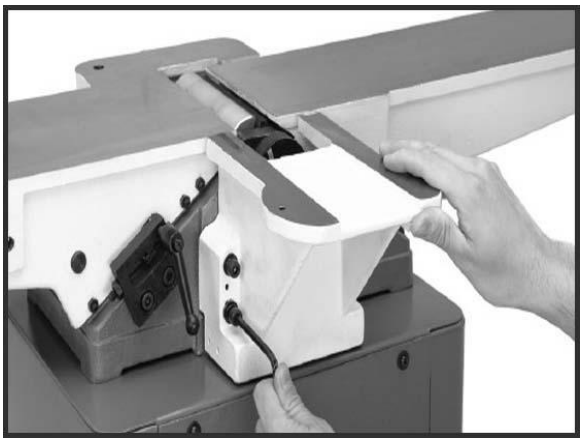


Figure K

Assembling the Fence Carriage

Components & Hardware Required:

	Qty
Fence Carriage Assembly	1
Cap Screws M8-1.25 x 20	2
Lock Washers 8mm	2
Flat Washers	2

Tools required:

	Qty
6mm Hex Key	1

1. With the fasteners listed above, secure the fence carriage to the carriage mounting bracket as in (Fig. L)

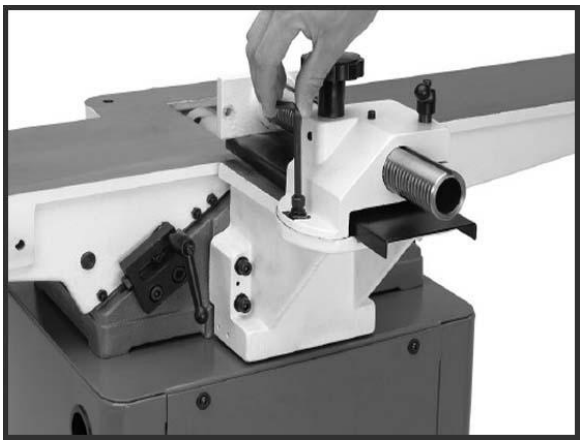


Figure L

Assembling the Fence

Components & Hardware Required:

	Qty
Fence Assembly	1
Cap Screws M8-1.25 x 25	2
Lock Washers 8mm	2
Flat Washers	2
Fence Tilting Handles	2

I. Fasten the fence assembly to the fence carriage using the M8-1.25 x 25 cap screws and washers supplied as in (Fig. M)

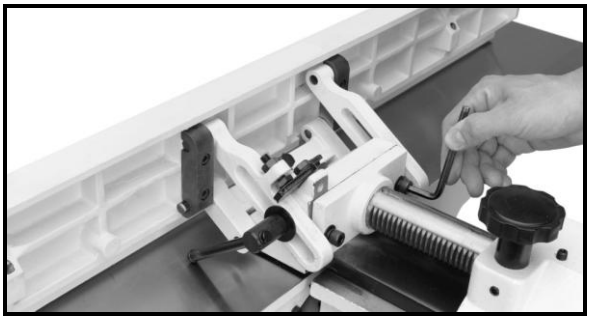


Figure M

II. Thread the fence tilting handle into the fence assembly as in (Fig. N)

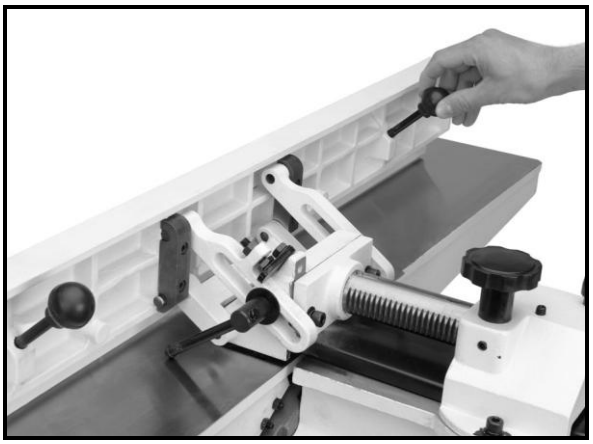


Figure N

Cutterhead Guard

CAUTION!

The cutterhead guard is a critical safety feature on this jointer and care must be taken in installation. The guard has a torsion spring mounted within it to allow it to return to its proper position after a jointing operation. The spring must have spring pressure during the installation to operate correctly.

Components & Hardware Required:

	Qty
Cutterhead Guard	1

Tools required:

	Qty
2.5mm Hex Key	1

1. Remove the set screw from the bottom of the cutterhead guard shaft. Fig O

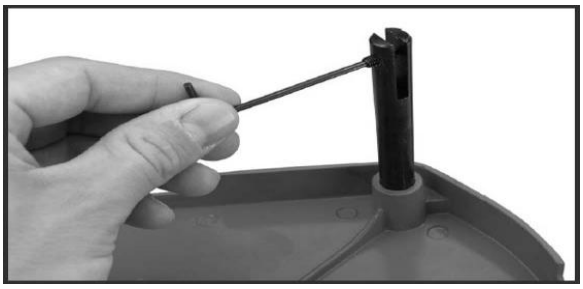


Figure O

2. Place the cutter head guard into the mounting hole on the casting of the infeed table. Fig P. Ensuring that the cutterhead guard shaft fits over the pin that is inside the grey spring knob barrel (hidden from View).

Figure P

3. Slightly raise the cutterhead guard until it is free of the pin inside the barrel.

4. While holding the cutter guard with one hand, turn the grey spring knob clockwise to increase spring tension.

5. Lower the cutter head guard ensuring that it seat over the pin in the barrel.

6. Test the return of the cutterhead guard to ensure that it returns to it home position and completely covers the cutterhead.

7. If the guard does not properly return to it home position repeat from step 3 until the guard returns to its home position and covers the cutterhead completely.

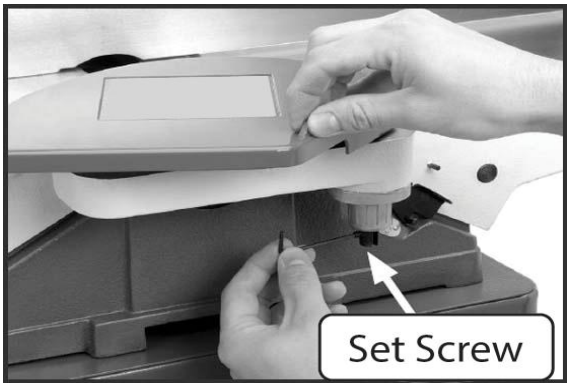


Figure Q

Dust Port Installation

Components & Hardware Required:

	Qty
Dust Port	1
Phillips Head Screws M5-.8 x 15	4
Flat Washers 5mm	4

Tools required:

	Qty
Phillips Head Screwdriver	1

Note:
If you do not choose to use a dust collector, do not install the dust port. Chips will build up within the cabinet and clog.

I. Place the dust hood over the dust vent on the cabinet and with the four screws & washers secure it to the cabinet (Fig. R). Then attach to the dust collection system.

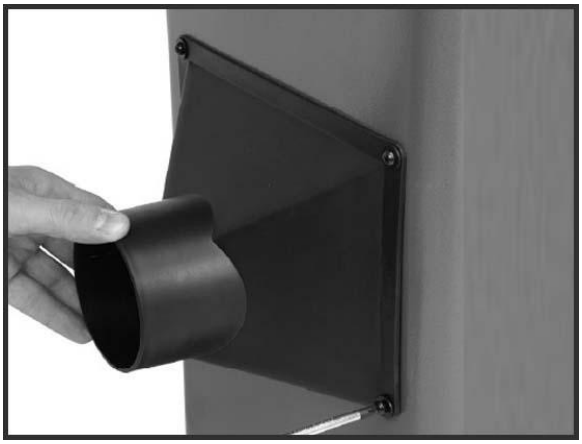


Figure R

Power Switch Install

Components & Hardware Required:

	Qty
Power Switch and Support Arm	1
Cap Screws M8-1.25 x 25	2
Flat Washers 8mm	2

Tools required:

	Qty
6mm Hex Key	1

I. With the M8-1.25 x 25 cap screws, mount and secure the support arm as in (Fig. S)

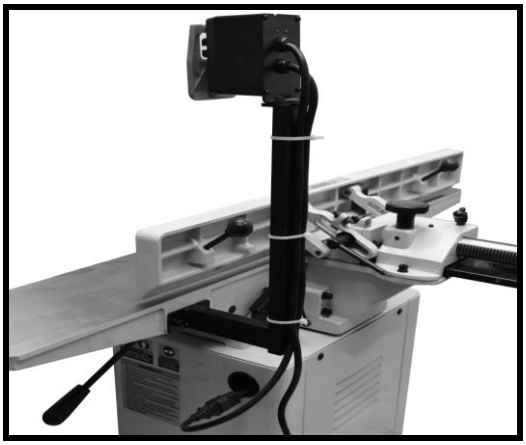


Figure S

II. Plug the power cord from the switch box into the cord coming from the cabinet of the jointer leading to the

motor. Then secure the loose cords with the hold downs shown in (Fig. T)

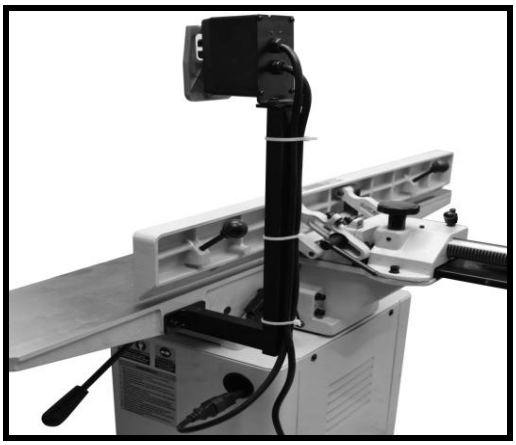


Figure T

Table Controls Installation

Components & Hardware Required:

	Qty
Outfeed Table Handwheel	1
Infeed Table Lever	1
Phillips Head Screws M5-.8 x 15	1
Flat Washers 5mm	1

Tools required:	**Qty**
Phillips Head Screwdriver	1
19mm Wrench	1

1. Remove the screw & flat washer already mounted in the outfeed handle shaft.

2. Mount & secure the handwheel to handwheel shaft as in (Fig.U)

Figure U

3. Thread the infeed lever into the hole as shown in (Fig.V) then tighten the locknut with the 19mm wrench

Figure V

Outfeed Table Height Setting

Setting Outfeed Table Height

The outfeed table height MUST be level with the carbide inserts when they are at top-dead-center. If the outfeed table is set too low, the workpiece will be tapered from front to back. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

To set the outfeed table height:

1. **DISCONNECT JOINTER FROM POWER SUPPLY!**

2. Move the cutterhead guard out of the way or remove it, and open the rear access panel.

3. Place a straightedge on the outfeed table so it extends over the cutterhead and rotate the cutterhead pulley until one of the carbide inserts is at top-dead-center (TDC), as shown in **Figure W**.

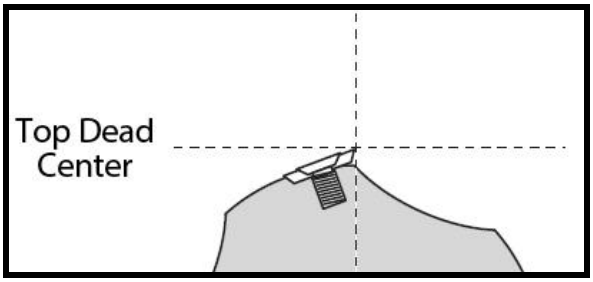


Figure W Cutterhead insert at top-dead-center

4. When correctly set, the carbide insert will just touch the straightedge when the insert is at its highest point of rotation (**Figure X**)**.**

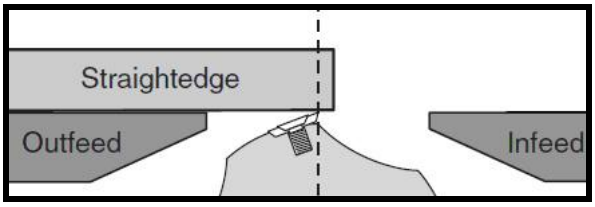


Figure X. Using a straightedge to align the outfeed table height with insert at TDC.

—If your outfeed table is correctly set, no adjustments are necessary.—If the insert lifts the straightedge off the table or the insert is below the straightedge, loosen the outfeed table lock and adjust the outfeed table height with the handwheel until the straightedge just touches an insert at its highest point of rotation.

5. Lock the outfeed table, re-install the cutterhead guard, and close the rear access panel.

Replacing Carbide Inserts

Tools Needed: **Qty**

L-Wrench Torx w/T20 Torx Driver..... 1

The cutterhead is equipped with 32 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90˚ to reveal a fresh cutting edge (**Figure Y**)

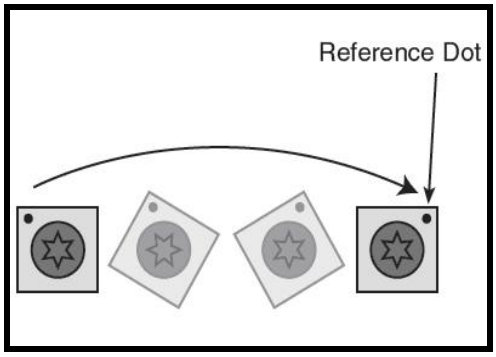


Figure Y

In addition, each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves back around to its starting position, the insert should be replaced.

To rotate or change a carbide insert:

1. **Disconnect JOINTER from power!**
2. Move the cutterhead guard out of the way, or remove it.
3. Remove any sawdust from the head of the carbide insert Torx screw.
4. Remove the Torx screw and carbide insert.
5. Clean all dust and dirt off of the insert and the cutterhead pocket from which the insert was removed, and replace the insert so a fresh, sharp edge is facing outward. Make sure the insert is seated in the pocket on the cutterhead.

Note:
Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between the insert and cutterhead will slightly raise the insert, and make noticeable marks on your workpieces the next time you cut.

6. Lubricate the Torx screw threads with light machine oil, wipe the excess oil off the threads, and torque the Torx screw to 48-50 inch/pounds.

Note:
Excess oil may squeeze between the insert and cutterhead or at the bottom of the screw hole, causing hydrostatic lock and preventing the screw from fully tightening, thereby lifting the insert or screw slightly and affecting workpiece finishes. Make sure to carefully clean off any excess oil to prevent this from happening.

Test Run

WARNING!
Long hair, loose clothing and jewelry can get caught up in the moving parts of machinery and result in serious injury. Keep Long hair and loose clothing tied up and away from the machine. Remove jewelry prior to use.

WARNING!
Chips and pieces of stock may be thrown from the machine. This can cause eye injuries, wear safety glasses at all times.

1. Before starting the machine, read the instruction manual in its entirety.
2. Check that the cutterhead guard has been installed correctly
3. Remove all tools and foreign objects from the machine.
4. Review the section **Circuit Requirements** and connect to the power source
5. Press the START button to turn on the machine.

The jointer should run smoothly with no vibration. Immediately stop the machine if you suspect any problems and refer to the trouble shooting section of this manual before re-starting.

Recommended Adjustments

Your machine has been factory preset so very little if any adjustments should be necessary, however due to any unforeseen

problems in the shipping process we recommend that you verify the following to ensure the best possible results from your machine.

I. Depth Scale calibration
II. Fence Stop Accuracy

Step by step instructions for these adjustments can be found in the SERVICE section of this manual

OPERATIONS

Operation Safety

WARNING!

Always wear safety glasses, a respirator, and hearing protection when operating this machine, damage to your eyes, lungs, and ears may result without the proper protective gear.

WARNING!

Long hair, loose clothing and jewelry can get caught up in the moving parts of machinery and result in serious injury. Keep Long hair and loose clothing tied up and away from the machine. Remove jewelry prior to use.

NOTICE:

For your own safety and experience we recommend that you seek additional training outside of this manual. Books and magazines are also good source materials to gain more experience.

Infeed Table Adjustment

Before any cut the proper infeed table adjustment must be made to safely and efficiently use this jointer. DO NOT set the infeed table depth greater than 1/16" on your first pass and never greater than 1/8" when rabbeting.

WARNING!

Beware of kickback when excessive depths of cut are made. Limit a single pass from 1/16" **to** 1/8". **Serious injury could occur in the event of kickback.**

1. Loosen the infeed table lock (Fig.Z)

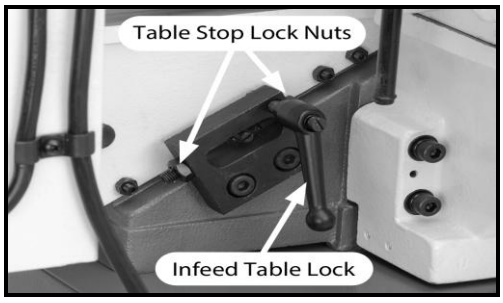


Figure Z

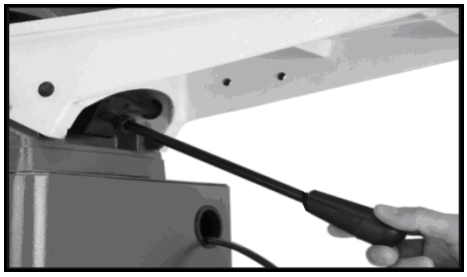


Figure AA

2. Use the infeed table lever to raise or lower the table (Fig.AA)

3. Set the infeed table to the desired depth of cut on the depth of cut scale and lock the table in position

Note:
Adjust the infeed table stops to return the table height to the same height every time by loosening the lock nuts and adjusting the set screws.

Stock Inspection

- **DO NOT joint or surface plane stock that contains knots.** If a knot becomes dislodged during the cutting operation it could cause injury to the operator and even damage the workpiece.

- **Jointing or surface planing with the grain will give a superior finish and is safer for the operator,** or feeding the stock on the table so the grain points down and toward you as viewed on the edge of the stock. (See Fig.BB). **Note:** If the grain changes direction along the edge, decrease the cutting depth and make additional passes.

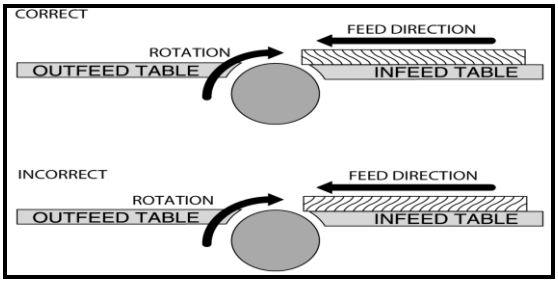


Figure BB

- **Your jointer is designed only to cut natural wood fiber products.** DO NOT joint MDF, particle board, plywood, laminates or other synthetically made materials.

- **Scrape all glue off the workpiece before jointing.** Glue deposits, either hard or soft will gum up the inserts, produce poor results and may cause kickback.

- **Remove foreign objects from the workpiece.** Always check your workpiece for foreign objects such as nails and staples. Ensure that your workpiece is free of dirt that may damage the inserts. ***NOTE:*** *Wood stacked on dirt or concrete may have small pieces of concrete or stone embedded into the surface.*

- **Use only dry wood when jointing or planing.** Wood with a moisture content of over 20% can cause unnecessary wear to the inserts, produce poor cutting results and increase the risk of kickback.

CAUTION:
Your workpiece must exceed the minimum dimensions of stock shown in (Fig.31 & 32) when edge jointing or surface planing. Stock of smaller dimensions may break or kickback during operations.

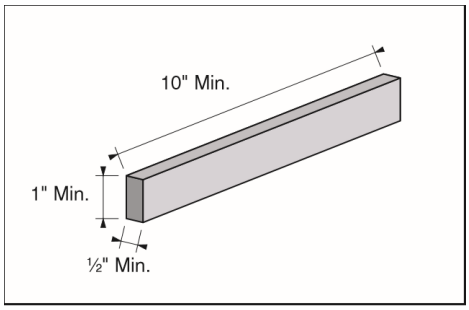


Figure CC

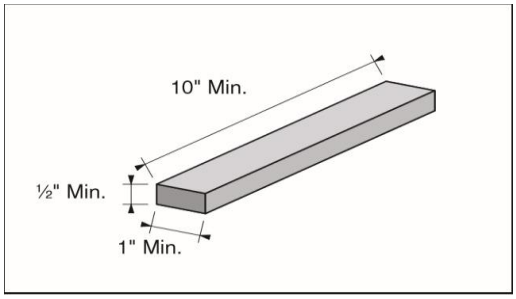
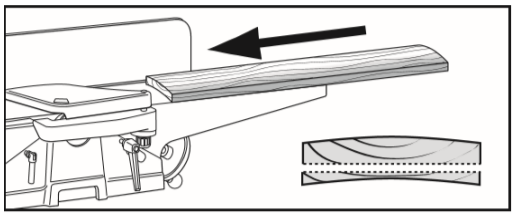


Figure DD

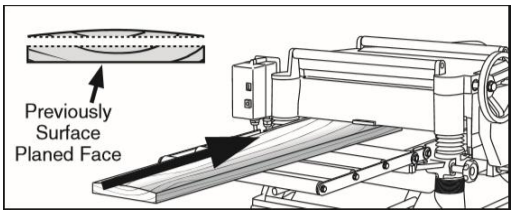
Squaring Stock

Squaring stock is accomplished by performing the following four steps in the order listed.

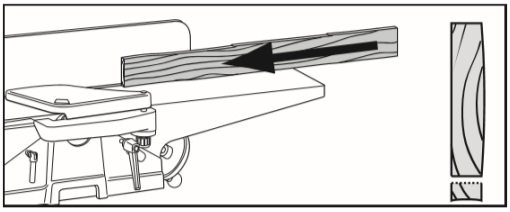
1. **Surface plane on the jointer –** The concave face of the workpiece is surface planed flat with the jointer.



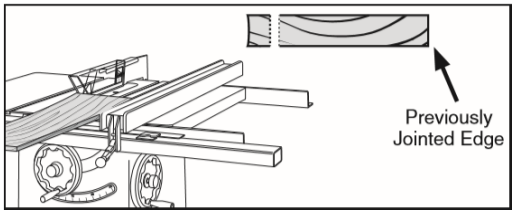
2. **Surface plane on a thickness planer –** The opposite face of the workpiece is surface planed flat with a thickness planer.



3. **Edge joint on the jointer -** The concave edge of the workpiece is is jointed flat with the jointer.



4. **Rip cut on the table saw –** With the jointed edge of the workpiece against the fence, trim off the opposite edge.



Surface Planing

The purpose of surface planing is to make one surface of a workpiece flat ref. (Fig.EE & FF) prepares the piece of stock for surface planing in a thickness planer.

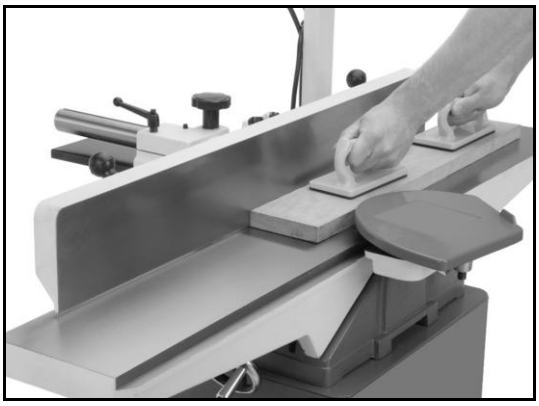


Figure EE

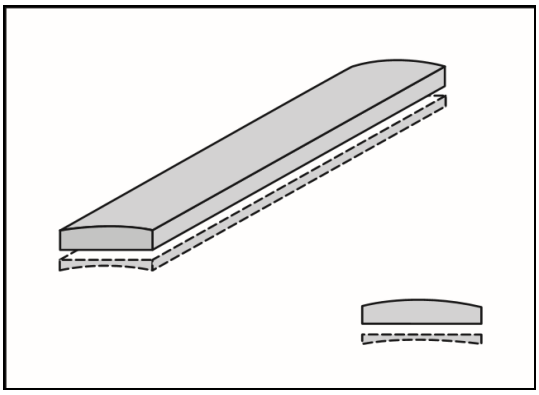


Figure FF

1. Make sure you have inspected your workpiece for knots and or foreign objects before passing it through the jointer.

2. Set the depth of cut required. (1/32” for surface planing, for hardwoods and wide workpieces use a smaller DOC.

3. Set the fence at 90 degrees.

4. I you have a cupped or warped workpiece, place the concave side down on the infeed table (Fig. FF)

5. Start the jointer

6. Using a push block in each hand, feed the workpiece over the cutterhead, keeping a constant pressure on the workpiece against the table and the fence. (Fig.EE)

Note:
When your leading hand gets within 4” of the cutterhead. Lift it up and over the cutterhead and place the push block on the portion of the workpiece that is now on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same process with your trailing hand when it gets within 4” of the cutterhead. Keep your hands safe! DO NOT let them get closer than 4” from the cutterhead when it is moving.

7. Repeat step 6 until the entire surface is flat.

   Note: if a second edge is jointed it will most likely not be parallel with the first.

Edge Jointing

Edge jointing is to produce a finished flat surface for joinery or finishing and a necessary step toward squaring rough or warped wood. (Fig.GG & HH)

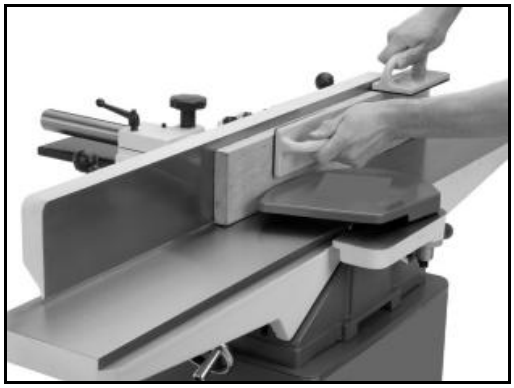


Figure GG

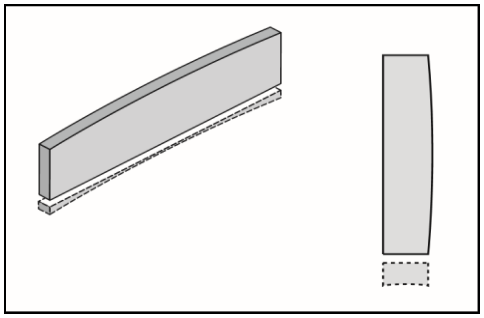


Figure HH

1. Make sure you have inspected your workpiece for knots and or foreign objects before passing it through the jointer.

2. Set the depth of cut required. (Between 1/16” to 1/8” for edge jointing, for hardwoods and wide workpieces use a smaller DOC.

3. Set the fence at 90 degrees.

4. If you have a cupped or warped workpiece, place the concave side down on the infeed table (Fig. HH)

5. Start the jointer

6. Feed the workpiece over the cutterhead, keeping a constant pressure on the workpiece against the table and the fence. (Fig. GG)

Note:
When your leading hand gets within 4” of the cutterhead. Lift it up and over the cutterhead and place it on the portion of the workpiece that is now on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same process with your trailing hand when it gets within 4” of the cutterhead. Keep your hands safe! DO NOT let them get closer than 4” from the cutterhead when it is moving.

7. Repeat step 6 until the edge is flat.

8. If a second edge is jointed it will likely not be parallel with the first.

Bevel Cutting

Cutting a specific angle on the edge of a workpiece is called bevel cutting. See (Fig.II & JJ). This jointer has preset fence stops at 45 degrees inward, 90 and 45 degrees outward (135 deg.) If you require a different angle, the preset stops can easily be adjusted to meet your needs.

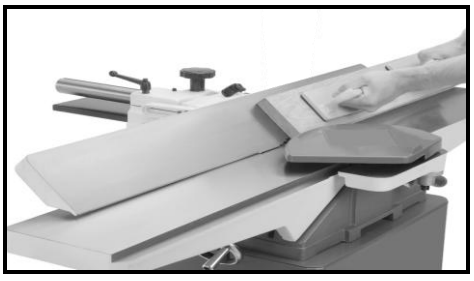


Figure II

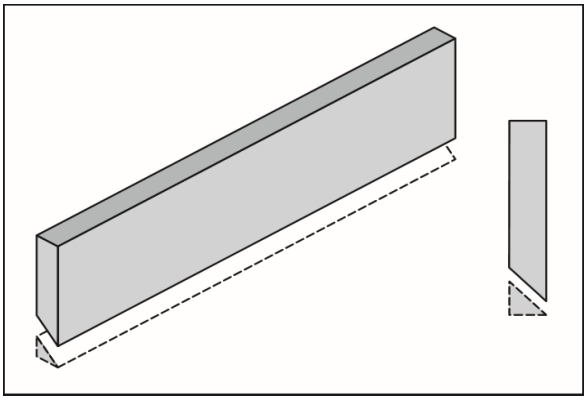


Figure JJ

1. Make sure you have inspected your workpiece for knots and or foreign objects before passing it through the jointer.

2. Set the depth of cut required. (Between 1/16” to 1/8” for bevel cutting, for hardwoods and wide workpieces use a smaller DOC.

3. Set the fence at your desired angle.

4. If you have a cupped or warped workpiece, place the concave side down on the infeed table (Fig JJ)

5. Start the jointer

6. Using a push block in each hand, feed the workpiece over the cutterhead, keeping a constant pressure on the workpiece against the table and the fence. (Fig.EE)

Note:
When your leading hand gets within 4” of the cutterhead. Lift it up and over the cutterhead and place the push block on the portion of the workpiece that is now on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same process with your trailing hand when it gets within 4” of the cutterhead. Keep your hands safe! DO NOT let them get closer than 4” from the cutterhead when it is moving.

7. Repeat step 6 until the angled cut is achieved.

   Note: if a second edge is jointed it will most likely not be parallel with the first.

Rabbet Cutting

When you need to remove only a section of the edge on a workpiece it is called rabbet cutting (Fig. KK & LL). When you combine two rabbeted edges, they create a simple yet strong method for joining stock.

Figure KK

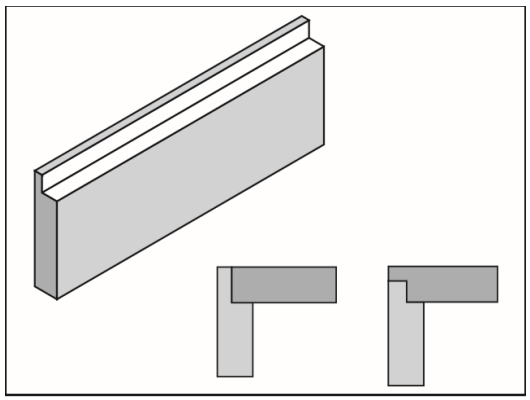


Figure LL

1. Make sure you have inspected your work piece for knots and or foreign objects before passing it through the jointer.

2. Set the depth of cut required. (Between 1/16” to 1/8” for rabbet cutting, for hardwoods and wide work pieces use a smaller DOC.

3. Remove the cutterhead guard.

4. Make sure your fence is moved forward, so the amount of infeed/Outfeed table exposed is the same size as your rabbet. Ensure the fence is set at 90 degrees.

5. Start the jointer

6. Using a push block in each hand, feed the work piece over the cutterhead, keeping a constant pressure on the work piece against the table and the fence. (Fig. EE)

Note:
When your leading hand gets within 4” of the cutterhead. Lift it up and over the cutterhead and place the push block on the portion of the work piece that is now on the Outfeed table. Now, focus your pressure on the Outfeed end of the work piece while feeding, and repeat the same process with your trailing hand when it gets within 4” of the cutterhead. Keep your hands safe! DO NOT let them get closer than 4” from the cutterhead when it is moving.

7. Repeat step 6 until the rabbet cut to your desired depth.

MAINTENANCE

To ensure the best performance of your jointer, follow the recommended maintenance schedule and specific instructions in this section. It is important to keep your machine clear of accumulated dust, moisture, and built up resin.

1. Vacuum all dust on and around the machine after daily use.

2. Wipe down the tables and unpainted surfaces with a metal protectant.

3. Check the V-belt tension and for damage or wear on a monthly basis.

4. Clean and or vacuum any dust buildup inside the cabinet and motor.

There is no **lubrication** regimen necessary for this machine as all bearings are sealed, simply leave them alone until they need to be replaced. DO NOT lubricate the fence assembly or table ways. If the tables appear to be stuck, disassemble and clean any foreign materials from the ways. Re-assemble and reset the gibs.

SERVICE

Some factory settings may need to re-adjustment at various times throughout the life of the machine. If at any time you feel unable to perform these procedures, please contact Customer Service at Busy Bee Tools for technical support.

Depth Scale Calibration

1. Set the Outfeed table height as described in **Setting the Outfeed Table Height** sub-section.

2. Place a straightedge across the infeed and Outfeed tables.

3. Adjust the infeed table until it is level with the Outfeed table. (Fig. MM)

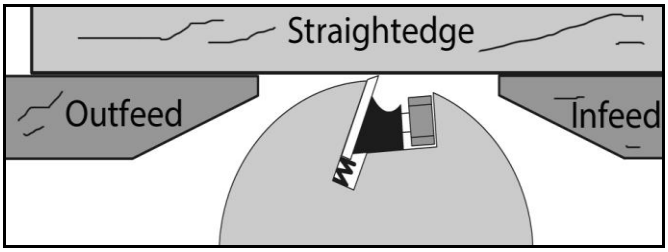


Figure MM

4. Using a screwdriver, adjust the scale pointer exactly to “0” (zero) (Fig.NN)

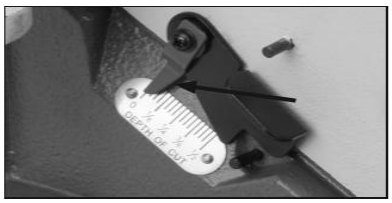


Figure NN

Setting the Fence Stops

Fence stops are adjustable nuts and bolts to simplify the task of adjusting the fence to 45 deg. inward, 90 deg., and 45 deg. outward (135 deg.)

Setting the 45 deg. Inward Fence Stop

1. With a 45 deg. square, adjust the fence to the 45 deg. inward position.

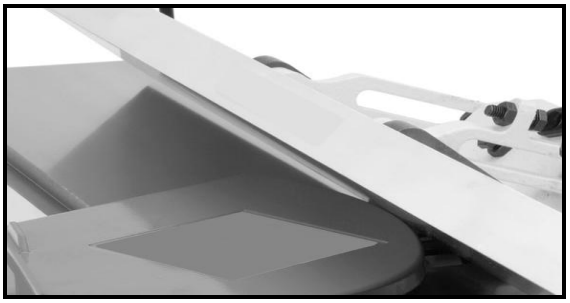


Figure OO

2. Loosen the jam nut (Fig.PP)

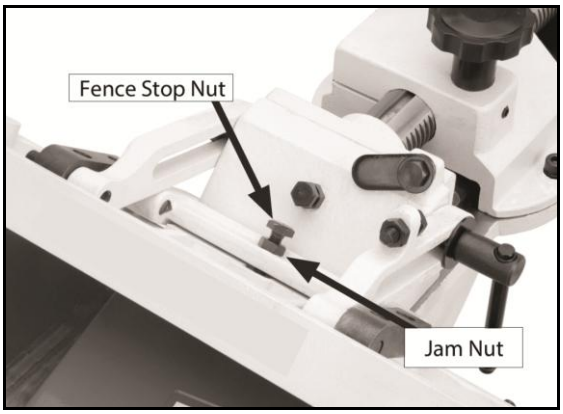


Figure PP

3. Adjust the 45 deg. inward fence stop nut until it makes contact with the back of the fence bracket, then re-tighten the jam nut from **Step 2** and recheck.

Setting the 90 deg. Fence Stop

1. Flip the 90 deg. swing stop into the position as in (Fig. QQ)

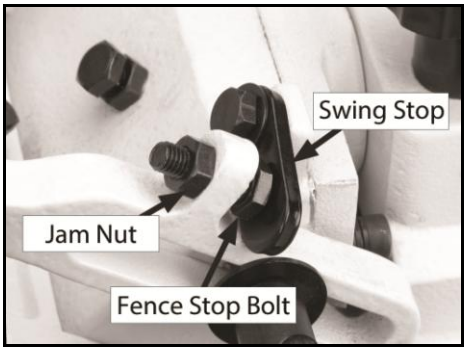


Figure QQ

2. With a 90 deg. square, adjust the fence to the 90 deg. position (Fig. RR) using the fence stop bolt and jam nut.

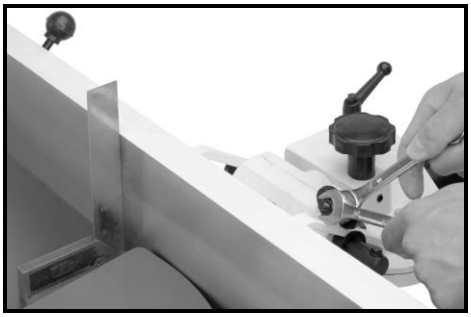


Figure RR

3. Loosen the jam nut on the 90 deg. fence stop bolt (Fig. QQ)

4. Adjust the 90 deg. fence stop bolt until it contacts the 90 deg. swing stop, then re-tighten the jam nut from **Step 3** and recheck.

Setting the 45 deg. Outward Fence stop:

1. Flip the 90 deg. swing stop out of the way (Fig. SS)

2. Using a sliding bevel adjusted to 135 deg., adjust the fence to the 135 deg. (45 deg. outward) position.

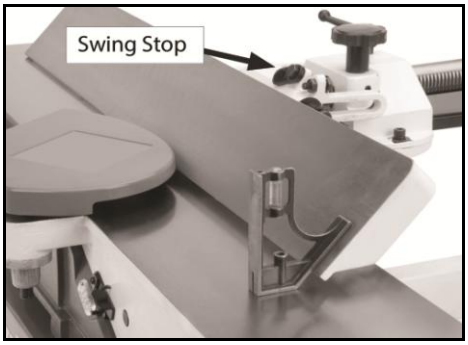


Figure SS

3. Loosen the jam nut on the 45 deg. outward fence stop bolt (Fig. TT)

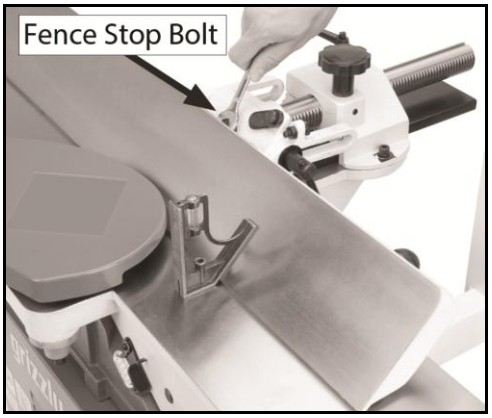


Figure TT

4. Adjust the 45 deg. outward fence stop bolt until it contacts the 90 deg. swing stop, then re-tighten the jam nut from **Step 3** and recheck.

Adjusting the Gibs

The purpose of the table gibs is to eliminate excessive play in the table movement. They also control the smoothness of the table movement.

1. With a 10mm wrench, loosen the two outfeed table gib nuts on the side of the jointer base (Fig. UU)

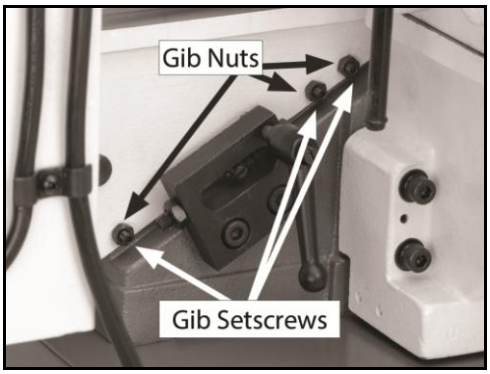


Figure UU

2. With a 3mm hex key, evenly tighten the gib setscrews a small amount, then check the table by moving it up and down. Adjust these setscrews as needed until the friction of the table movement is balanced between minimal play and ease of movement.

Note:
If you over tighten the gibs too it will reduce play but make it harder to adjust the tables.

3. Repeat **Steps 1-2** with the outer table

4. Set the Outfeed table as described in **Setting Outfeed Table Height** section.

Electrical Components

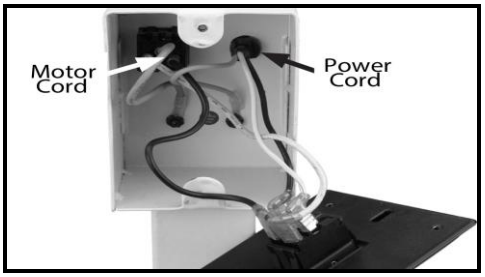


Figure VV

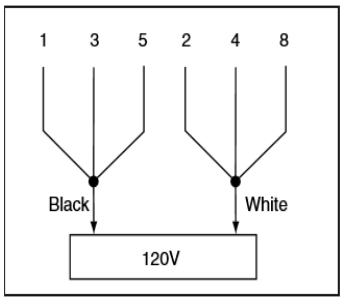


Figure WW

SERVICE

Motor & Machine Operation

1.) Symptom
Motor will not start

Possible Cause
I. Emergency stop button depressed.
II. Low voltage.
III. Open circuit in motor or loose connection

Possible Solution
I. Lift the cover on the emergency stop button to allow it to pop out.
II. Check power line for proper voltage.
III. Inspect all led connections on motor for loose or open connections.

2.) Symptom
Fuses or circuit breakers blow

Possible Cause
I. Short circuit in line cord or plug.

Possible Solution
I. Repair or replace cord or plug for damaged insulation and shorted wires.

3.) Symptom
Motor fails to develop full power (output of motor decreases rapidly with increase in voltage at motor terminals)

Possible Cause
I. Power supply circuit overloaded with lights, appliances, and other motors.
II. Undersized wires or circuits too long.

Possible Solution
I. Reduce load on circuit.
II. Increase wire size or reduce length of circuit.

4.) Symptom
Motor overheats

Possible Cause
I. Motor overloaded during operation.
II. Air circulation of the motor restricted.

Possible Solution
I. Reduce load on motor; take lighter cuts.
II. Clean out motor to provide normal air circulation.

5.) Symptom
Motor stalls or shuts off during cut

Possible Cause

I. Motor overloaded during operation.
II. Short circuit in motor or loose connections.
III. Circuit breaker tripped.

Possible Solution

I. Reduce load on motor; take lighter cuts.
II. Repair or replace connections on motor for loose or shorted terminals or worn insulation.
III. Install correct circuit breaker; reduce no. of machines running on the circuit. (circuit overload)

6.) Symptom

Blade slows when cutting or makes a squealing noise, especially on start-up

Possible Cause

I. V-belt loose.
II. V-belt worn out.

Possible Solution

I. Tighten V-belt.
II. Replace V-belt

7.) Symptom

Loud repetitious noise coming from machine

Possible Cause

I. Pulley setscrews or keys are missing or loose.
II. Motor fan is hitting the cover.
III. V-belts are damaged.

Possible Solution

I. Inspect keys and setscrews. Replace or tighten as necessary.
II. Adjust fan cover mounting position, tighten fan, or shim fan cover.
III. Replace V-belts.

8.) Symptom

Vibration when running or cutting

Possible Cause

I. Loose or damaged blade.
II. Damaged V-belt.
III. Worn cutterhead bearings

Possible Solution

I. Tighten or replace blade.
II. Replace V-belt.
III. Check/replace cutterhead bearings.

Table

I. Symptom

Tables are hard to adjust

Possible Cause

I. Table lock is engaged or partially engaged.
II. Table gibs are too tight.

Possible Solution

I. Completely loosen the table lock.
II. Re-adjust the table gibs.

II. Symptom

Excessive play in table movement

Possible Cause

I. Table gibs are too loose.

Possible Solution

I. Re-adjust the table gibs.

Cutting

1.) Symptom
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut)

Possible Cause
I. Outfeed table is set too low.
II. Operator pushing down on the end of the workpiece.

Possible Solution
I. Align outfeed table with cutterhead knife at top dead centre.
II. Reduce/eliminate downward pressure on the end of that workpiece.

2.) Symptom
Workpiece stops in the middle of the cut.

Possible Cause
I. Outfeed table is set too high.

Possible Solution
I. Align outfeed table with cutterhead knife at top dead centre.

3.) Symptom
Chipping

Possible Cause
I. Knots or conflicting grain direction in wood.
II. Nicked or chipped blades.
III. Feeding workpiece too fast.
IV. Taking too deep of a cut

Possible Solution
I. Inspect workpiece for knots and grain; use only clean stock.
II. Adjust one of the nicked knives sideways, or replace knives.
III. Slow the feed rate down.
IV. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods)

4.) Symptom
Fuzzy grain

Possible Cause
I. Wood may have high moisture content. Or surface wetness.
II. Dull knives.

Possible Solution
I. Check moisture content and allow to dry, if moisture is too high.
II. Replace knives.

5.) Symptom
Long lines or ridges that run along the length of the board

Possible Cause
I. Nicked or chipped knives.

Possible Solution
I. Adjust one of the nicked knives sideways; or replace knives.

6.) Symptom
Uneven cutter marks, wavy surface, or chatter marks across the face of the board

Possible Cause
I. Feeding workpiece too fast.
II. Inserts are dull or damaged.

Possible Solution
I. Slow the feed rate down.
II. Rotate the insert to expose a new sharp edge.

7.) Symptom

Board edge is convex or concave after jointing

Possible Cause

I. Board not held with even pressure on infeed and outfeed table during cut.
II. Board started too uneven.
III. Board has excessive bow or twist along its length.
IV. Insufficient number of passes.

Possible Solution

I. Hold board with even pressure as it moves over the cutterhead.
II. Take partial cuts to remove the extreme high spots before doing a complete pass.
III. Surface plane one face to be sure there is a good surface to put against the fence.
IV. It may take 3 to 5 passes to achieve a perfect edge, depending on the starting condition of the board and the depth of cut

8.) Symptom

Uneven cut or breakout when rabbeting

Possible Cause

I. Uneven feed rate.
II. Depth of cut too deep.
III. Nicked or chipped Inserts.

Possible Solution

I. Feed the board evenly and smoothly through the cut.
II. Raise the infeed table to take a smaller depth of cut. Never exceed 1/16” per pass when rabetting.
III. Adjust one the nicked inserts by rotating it 90° or replace insert if all 4 sides are dull or damaged.

TABLE PARTS BREAKDOWN

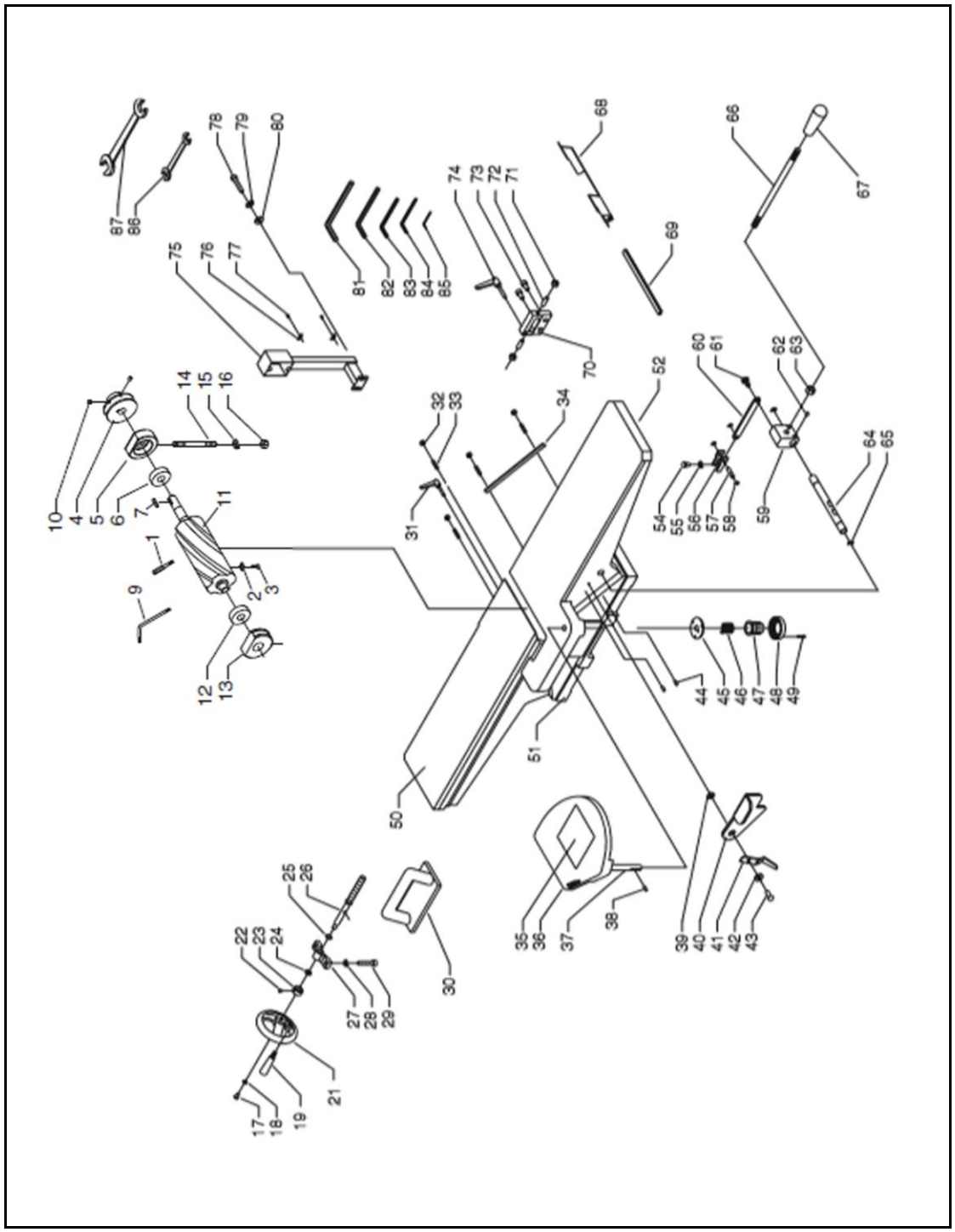
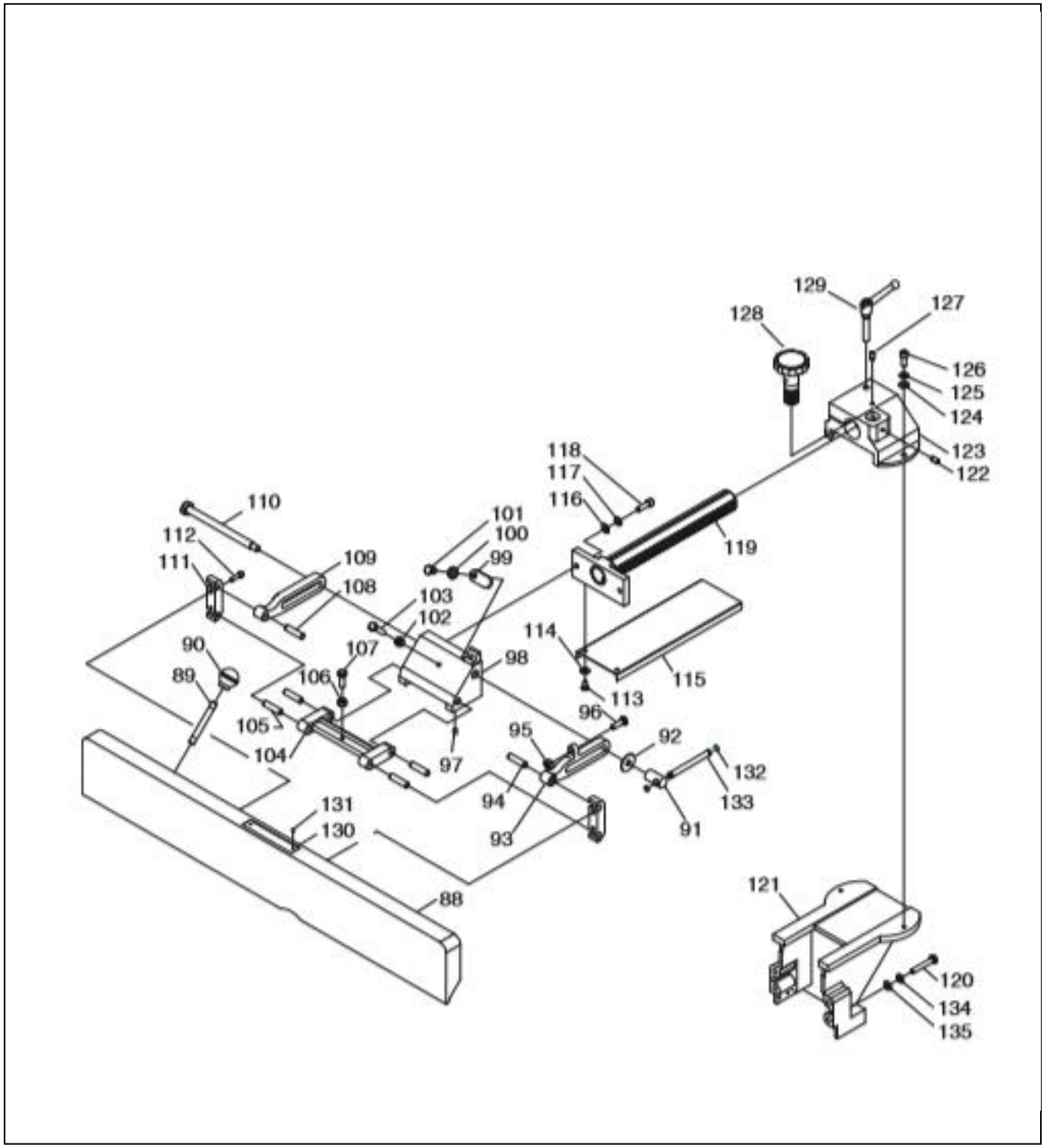


TABLE PARTS LIST

Item	Part Number	Description
1	PCX06HC01	Power Bit T20 Torx
2	PCX06HC02	Insert 14x14x2mm
3	PCX06HC03	Torx Screw
4	PCX06HC04	PULLEY
5	PCX06HC05	BEARING BLOCK RIGHT
6	PCX06HC06	BALL BEARING 6203ZZ
7	PCX06HC07	KEY 5 X 5 X 30
9	PCX06HC09	L Wrench T20 Torx
10	PCX06HC10	SET SCREW M6-1 X 10
11	PCX06HC11	6” Helical Cutterhead
12	PCX06HC12	BALL BEARING 6202ZZ
13	PCX06HC13	BEARING BLOCK LEFT
14	PCX06HC14	STUD M10-1.5 X 100
15	PCX06HC15	LOCK WASHER 10MM
16	PCX06HC16	HEX NUT M10-1.5
17	PCX06HC17	BUTTON HD CAP SCR M6-1 X 12
18	PCX06HC18	FLAT WASHER 6MM
19	PCX06HC19	HANDLE
21	PCX06HC21	HANDWHEEL
22	PCX06HC22	SET SCREW M6-1 X 6
23	PCX06HC23	COLLAR
24	PCX06HC24	FLAT WASHER 12MM
25	PCX06HC25	FLAT WASHER 12MM
26	PCX06HC26	SCREW SHAFT
27	PCX06HC27	BLOCK
28	PCX06HC28	LOCK WASHER 8MM
29	PCX06HC29	CAP SCREW M8-1.25 X 50
30	PCX06HC30	JOINTER PUSH BLOCK
31	PCX06HC31	LOCK HANDLE
32	PCX06HC32	HEX NUT M6-1
33	PCX06HC33	SET SCREW M6-1 X 25
34	PCX06HC34	GIB
35	PCX06HC35	CUTTER GUARD LABEL
36	PCX06HC36	CUTTER HEAD GUARD
37	PCX06HC37	POST
38	PCX06HC38	SET SCREW M3-.5 X 10
39	PCX06HC39	SPACER
40	PCX06HC40	STOP
41	PCX06HC41	POINTER
42	PCX06HC42	FLAT WASHER 4MM
43	PCX06HC43	BUTTON HD CAP SCR M4-.7 X 15
44	PCX06HC44	ROLL PIN 4 X 20

Item	Part Number	Description
45	PCX06HC45	PLATE
46	PCX06HC46	TORSION SPRING
47	PCX06HC47	CUP
48	PCX06HC48	RETAINER
49	PCX06HC49	BUTTON HD CAP SCR M4.7 X 18
50	PCX06HC50	OUTFEED TABLE
51	PCX06HC51	BASE
52	PCX06HC52	INFEED TABLE
54	PCX06HC54	CAP SCREW M8-1.25 X 15
55	PCX06HC55	LOCK WASHER 8MM
56	PCX06HC56	BRACKET
57	PCX06HC57	PIN
58	PCX06HC58	EXT RETAINING RING 5MM
59	PCX06HC59	BLOCK
60	PCX06HC60	LINK
61	PCX06HC61	SPECIAL BOLT
62	PCX06HC62	SET SCREW M8-1.25 X 8
63	PCX06HC63	HEX NUT M12-1.75
64	PCX06HC64	SHAFT
65	PCX06HC65	EXT RETAINING RING 12MM
66	PCX06HC66	LEVER ROD
67	PCX06HC67	HANDLE
68	PCX06HC68	DUST CHUTE
69	PCX06HC69	SEAL
70	PCX06HC70	BLOCK
71	PCX06HC71	HEX NUT M8-1.25
72	PCX06HC72	SET SCREW M8-1.25 X 25
73	PCX06HC73	CAP SCREW M8-1.25 X 16
74	PCX06HC74	LOCK LEVER ASSY
75	PCX06HC75	SWITCH MOUNTING BRACKET
76	PCX06HC76	STRAIN RELIEF
77	PCX06HC77	BUTTON HD CAP SCR M5-.8 X 12
78	PCX06HC78	CAP SCREW M10-1.5 X 25
79	PCX06HC79	LOCK WASHER 10MM
80	PCX06HC80	FLAT WASHER 10MM
81	PCX06HC81	HEX WRENCH 8MM
82	PCX06HC82	HEX WRENCH 6MM
83	PCX06HC83	HEX WRENCH 4MM
84	PCX06HC84	HEX WRENCH 3 MM
85	PCX06HC85	HEX WRENCH 2.5 MM
86	PCX06HC86	OPEN END WRENCH M8 X10
87	PCX06HC87	OPEN END WRENCH M12 X14

FENCE PARTS BREAKDOWN

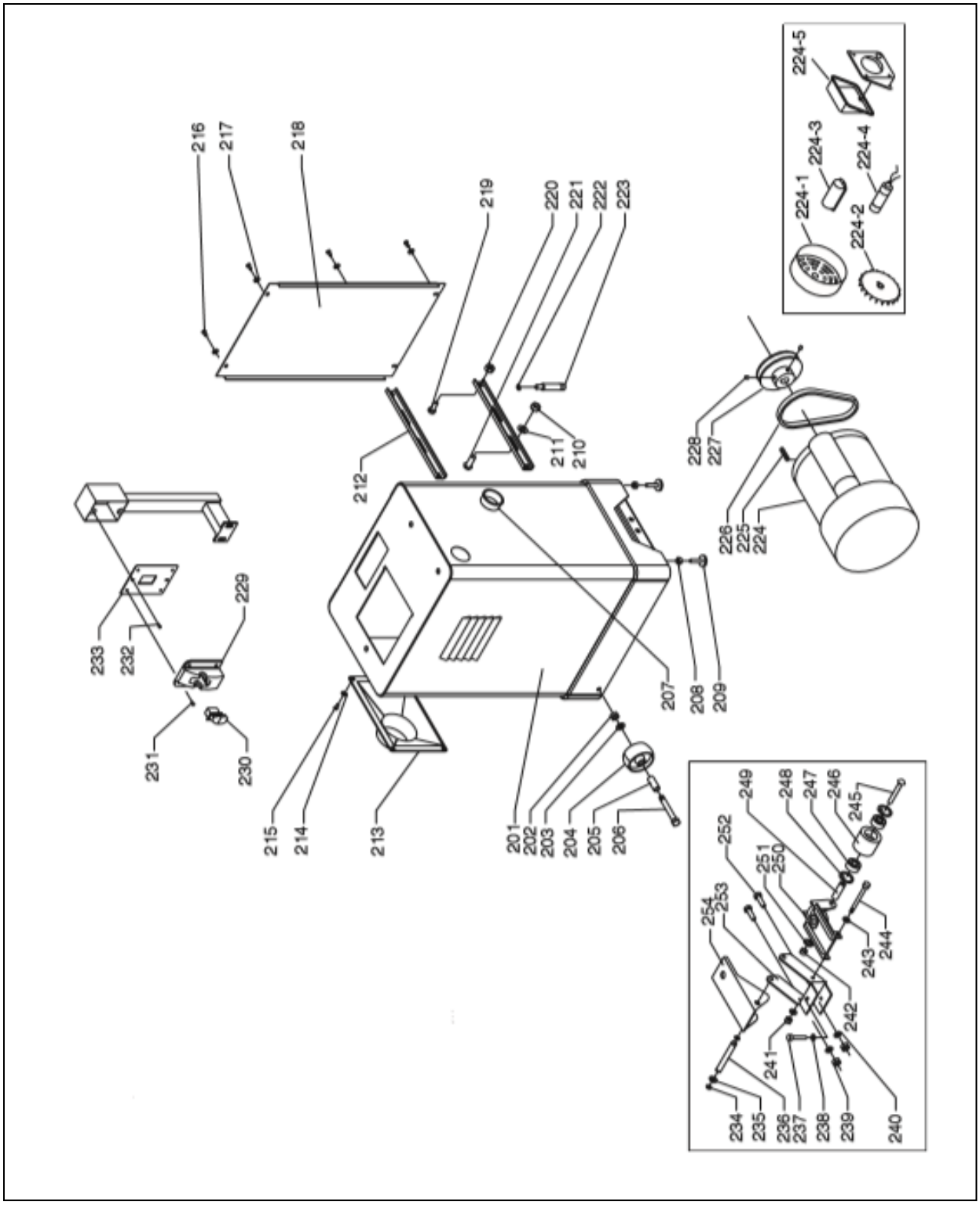


Fence Parts List

Item	Part #	Description
88	PCX06Z88	FENCE
89	PCX06Z89	LEVER ROD
90	PCX06Z90	BALL KNOB
91	PCX06Z91	HANDLE HUB
92	PCX06Z92	WASHER - FLAT 10MM
93	PCX06Z93	RIGHT BRACKET
94	PCX06Z94	PIN - ROLL 4 X 20
95	PCX06Z95	NUT HEX M8-1.25
96	PCX06Z96	BOLT - HEX HD M8-1.25 X 25
97	PCX06Z97	SCREW - SET M6-1.0 X 10
98	PCX06Z98	FENCE BRACKET
99	PCX06Z99	STOP
100	PCX06Z100	WASHER - FLAT 10MM
101	PCX06Z101	BOLT - SHOULDER M8-1.25 X 15
102	PCX06Z102	NUT - HEX M8-1.25
103	PCX06Z103	BOLT - HEX HD M8-1.25 X 25
104	PCX06Z104	SUPPORT
105	PCX06Z105	PIN
106	PCX06Z106	NUT - HEX M8-1.25
107	PCX06Z107	BOLT - HEX HD M8-1.25 X 25
108	PCX06Z108	PIN
109	PCX06Z109	LEFT BRACKET
110	PCX06Z110	SPECIAL SCREW
111	PCX06Z111	REAR CLAMP

Item	Part #	Description
112	PCX06Z112	SCREW - CAP M6-1.0 X 20
113	PCX06Z113	SCREW - PHLP HD M6-1.0 X 12
114	PCX06Z114	WASHER - LOCK 8MM
115	PCX06Z115	GUARD
116	PCX06Z116	WASHER - FLAT 8MM
117	PCX06Z117	WASHER - SPRING 8MM
118	PCX06Z118	SCREW - CAP M8-1.25 X 25
119	PCX06Z119	RAM
120	PCX06Z120	SCREW - CAP M8-1.25 X 60
121	PCX06Z121	BRACKET
122	PCX06Z122	SCREW - SET M8-1.25 X 12
123	PCX06Z123	BRACKET
124	PCX06Z124	WASHER - FLAT 8MM
125	PCX06Z125	WASHER - SPRING 8MM
126	PCX06Z126	SCREW - CAP M8-1.25 X 20
127	PCX06Z127	SCREW - SET M8-1.25 X 12
128	PCX06Z128	HANDWHEEL
129	PCX06Z129	LEVER ASSEMBLY
130	PCX06Z130	FENCE WARNING LABEL
131	PCX06Z131	ALUMINIUM RIVET
132	PCX06Z132	O RING
133	PCX06Z133	LOCK BAR
134	PCX06Z134	WASHER - LOCK 8MM
135	PCX06Z135	WASHER - FLAT 8MM

Base Parts Breakdown



Base Parts List

Item	Part Number	Description
201	PCX06HC201	CABINET
202	PCX06HC202	HEX NUT M8-1.25
203	PCX06HC203	FLAT WASHER 8MM
204	PCX06HC204	WHEEL
205	PCX06HC205	SLEEVE
206	PCX06HC206	CAP SCREW M8-1.25 X 65
207	PCX06HC207	STRAIN RELIEF
208	PCX06HC208	HEX NUT 3/8-16
209	PCX06HC209	ADJUSTING SCREW
210	PCX06HC210	HEX NUT 5/16-18
211	PCX06HC211	FLAT WASHER 10MM
212	PCX06HC212	MOTOR BRACKET
213	PCX06HC213	DUST CHUTE
214	PCX06HC214	FLAT WASHER 5MM
215	PCX06HC215	BUTTON HD CAP SCR M5-.8 X 16
216	PCX06HC216	BUTTON HD CAP SCR M5-.8 X 16
217	PCX06HC217	FLAT WASHER 5MM
218	PCX06HC218	CABINET REAR COVER
219	PCX06HC219	HEX BOLT 5/16-18 X 3/4
220	PCX06HC220	HEX NUT 5/16-18
221	PCX06HC221	CARRIAGE BOLT 5/16-18 X 1
222	PCX06HC222	LOCK WASHER 10MM
223	PCX06HC223	SPECIAL BOLT
224	PCX06HC224	MOTOR ASSY 1HP,1-PHASE
224-1	PCX06HC224-1	FAN COVER
224-2	PCX06HC224-2	MOTOR FAN
224-3	PCX06HC224-3	CAPACITOR COVER
224-4	PCX06HC224-4	START CAPACITOR 200MFD 125V
224-5	PCX06HC224-5	JUNCTION BOX
225	PCX06HC225	KEY 5 X 5 X 30
226	PCX06HC226	V-BELT A-38 4L380
227	PCX06HC227	MOTOR PULLEY
228	PCX06HC228	SET SCREW M6-1 X 6
229	PCX06HC229	SWITCH BOX
230	PCX06HC230	PADDLE SWITCH

Item	Part Number	Description
231	PCX06HC231	TAP SCREW M4 X 8
232	PCX06HC232	TAP SCREW M4 X 8
233	PCX06HC233	SWITCH PLATE
234	PCX06HC234	EXT RETAINING RING 9MM
235	PCX06HC235	FLAT WASHER 12MM
236	PCX06HC236	SHAFT
237	PCX06HC237	HEX BOLT M8-1.25 X 50
238	PCX06HC238	FLAT WASHER 8MM
239	PCX06HC239	HEX NUT M10-1.5
240	PCX06HC240	FLAT WASHER 10MM
241	PCX06HC241	HEX NUT M8-1.25
242	PCX06HC242	HEX NUT M10-1.5
243	PCX06HC243	FLAT WASHER 8MM
244	PCX06HC244	HEX BOLT M8-1.25 X 100
245	PCX06HC245	SPECIAL BOLT
246	PCX06HC246	TROLLEY WHEEL
247	PCX06HC247	BALL BEARING 6202ZZ
248	PCX06HC248	INT RETAINING RING 35MM
249	PCX06HC249	SLEEVE
250	PCX06HC250	TROLLEY UNIVERSAL KIT
251	PCX06HC251	FLAT WASHER 10MM
252	PCX06HC252	HEX BOLT M10-1.5 X 55
253	PCX06HC253	BRACKET
254	PCX06HC254	TREADLE
255	PCX06HC255	MACHINE ID LABEL
256	PCX06HC256	RESPIRATOR/GLASSES LABEL
257	PCX06HC257	READ MANUAL LABEL
261	PCX06HC261	ELECTRICITY LABEL
262	PCX06HC262	KNIFE JIG
262-1	PCX06HC262-1	ROD
262-2	PCX06HC262-2	KNIFE JIG FOOT
262-3	PCX06HC262-3	E-CLIP 9MM

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 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. Return authorization may take up to 72 hours for inspection and approval.

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.