

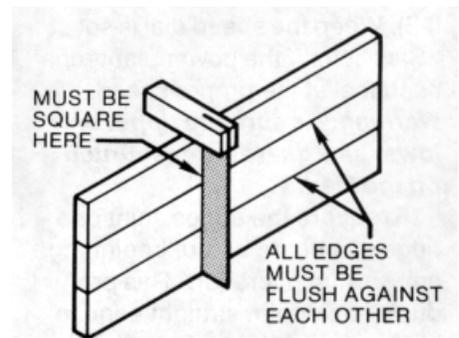
**Figure 6-5.** (A) Begin the cut using your left hand to steady the stock and your right hand to feed it forward. (B) As the stock nears the halfway point, reposition your left and to the outfeed side of the jointer. (C) Continue to steady the stock with your left hand while you move your right hand to the outfeed table. Finish the cut by pushing the end of the stock past the cutterhead with both hands.

The deeper the cut or the harder the wood, the slower you should run the jointer. If the jointer runs too slow, you may get a rough cut, so you'll want to experiment with scrap until you can select the proper speed for the stock you're jointing.

### SAW-JOINTER COMBINATION

The Mark V was designed so that the table saw and the jointer can be used in combination (Figure 6-3). When the speed dial is set at "Saw-Joint," the power plant runs each tool at the proper speed. **Warning:** Be sure the upper and lower saw guards are mounted on the Mark V.

To square the edges, joint one edge of a board before beginning any sawing operation. This produces a smooth, straight edge to place against the rip fence and assures a straight, parallel cut. When you're ripping, cut the stock slightly oversize so that you can also joint the second edge.



**Figure 6-6.** When jointed boards are butted edge-to-edge, they should have these qualities.

## EDGE JOINTING

The edging cut is made by moving the stock so the knives will be cutting with the grain of the wood (Figure 6-4). Warning: Working against the grain seldom produces a satisfactory surface; it also increases the danger of kickback and splintering.

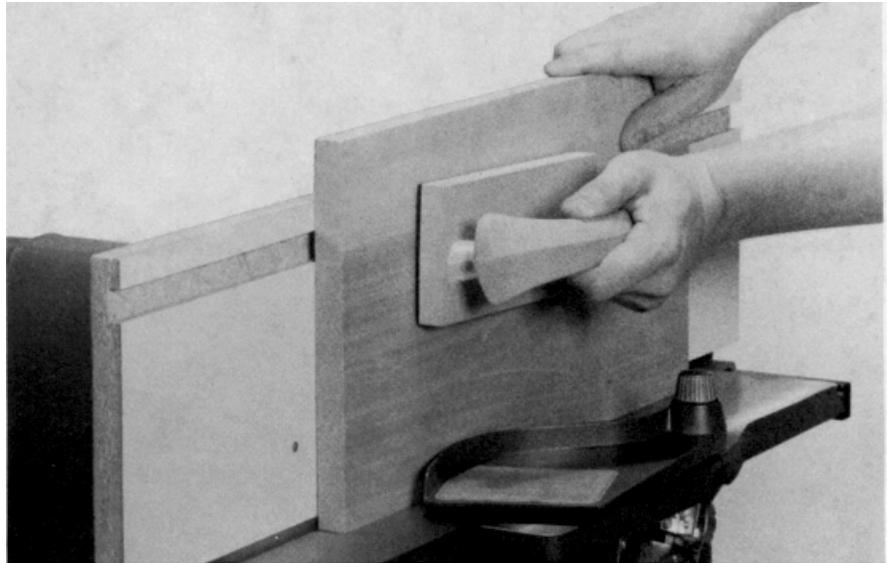
If the cutting action is not smooth or if you feel the stock pushing back against your hands, the chances are that you are working against the grain. Stop the pass immediately and reverse the position of the stock.

If you have to make a cut against the grain, take a very light cut and make the pass very, very slowly. Depth-of-cut settings on edge jointing cuts never should exceed  $1/8"$ . A setting of from  $1/32"$  to  $1/16"$  usually does the best job and wastes less wood.

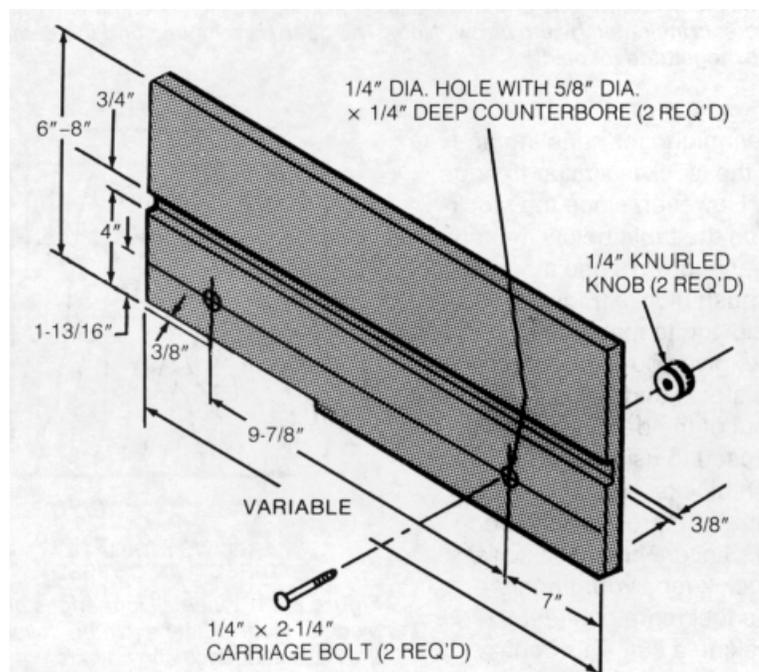
Although the jointing cut is a smooth movement from start to finish, it may be thought of in the three steps shown in Figure 6-5. The better side of the stock is placed against the fence with the work edge down on the infeed table. Hands should be placed to hold the stock down on the table and snugly against the fence. The left hand holds the stock down 4" to 6" before the first bump on the top of the fence and guides the stock. This permits both side and down pressure to hold the stock firmly against the fence and flat on the table. The right hand is placed near the end of the stock and feeds the stock forward.

Warning: If the stock is below the top of the fence, always use a push stick or push block to complete the pass.

As the stock moves over the cutterhead, the guard moves aside to permit its passage. The left hand does most of the work of keeping the stock snug against the fence and down on the table, while the right hand moves it forward. Always try to keep hands hooked over the top of the



**Figure 6-7.** The high fence extension provides extra support when you are jointing extra-wide stock.



**Figure 6-8.** Construction details of fence extension.

stock. Warning: Do not allow your hands to pass directly over the cutterhead.

At the end of the cut, the hands are still in about the same position on the stock. Avoid heavy downward pressure at the end of the cut, since this might tilt the stock into the cutter, resulting in a gouged end.

If the machine is properly adjusted and the pass is made correctly, the jointed board will have edges that are square with its face. Edges of a group of jointed boards will fit against each other without gaps, checking out in all respects shown in Figure 6-6.

### JOINTING EXTRA-WIDE STOCK

Wide boards that project significantly above the top of the fence require careful handling so they won't tilt as you make the pass. The best way to joint extrawide stock is to equip the jointer with an extra-high (even extra-long) fence extension that you can bolt in place using the two holes that are in the fence.

Jointing passes are then made in normal fashion but with extra support provided by the fence extension to keep the stock from tilting (Figure 6-7).

Figure 6-8 shows how the fence extension is made. The height may vary according to its intended use. For example, a high fence is very helpful for jointing wide boards because it makes it easier to be sure the face is flat on the fence, and the edge is therefore going to be cut square to the fence.

### EDGE JOINTING PROBLEM STOCK

Stock with knots, "wild grain," or extensive figuring is always difficult to joint; therefore, it requires extra care. For best results, feed the stock slowly and take very light cuts. Warning: Be especially cautious of kickbacks and stop cutting immediately if the stock will not feed smoothly.

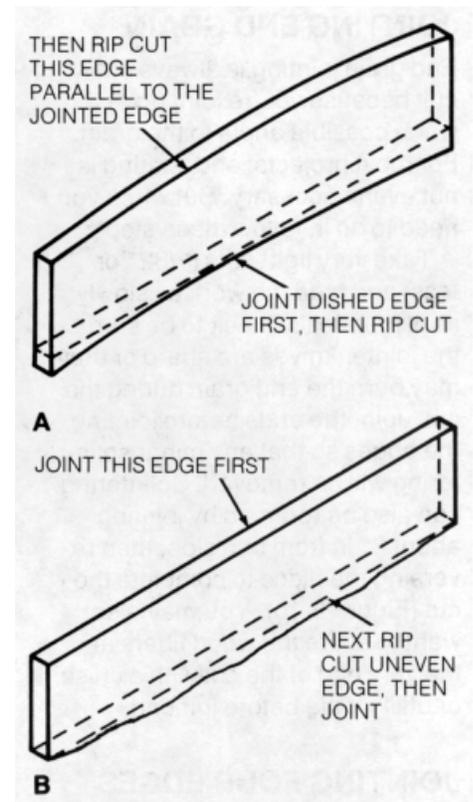
Whenever possible, stock that is distorted like the piece shown in Figure 6-9A should be jointed on the dished edge first. This is to provide adequate bearing surface for the jointing cuts that will produce one even edge so the stock may be ripped parallel on the table saw.

Warning: Use extra care when a curved edge must be jointed, since only a small area of the edge will bear on the table surface. The first pass will provide a flat area that will facilitate subsequent passes.

Stock having one uneven edge, as shown in Figure 6-9B, is handled by jointing the one straight edge first. This edge rides against the rip fence and is rip cut to remove the uneven edge; then the rip cut edge is jointed.

These guidelines apply to stock that has minor edge imperfections.

Warning: Don't waste time on badly distorted material. It can be dangerous and you may not have much



**Figure 6-9.** (A) The concave edge of a dished board can be straightened by making several light cuts. (B) When a board has an uneven edge, joint the opposite edge first. Next rip cut the uneven edge, then joint.