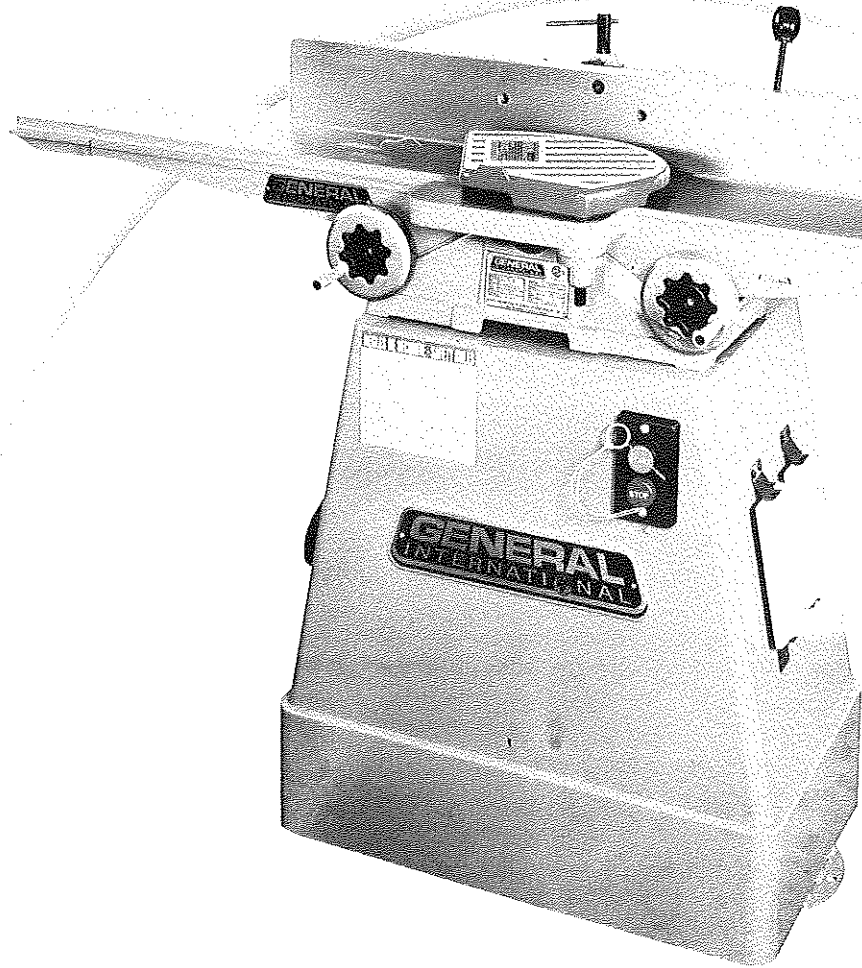




6" DELUXE JOINTER 80-100/ 80-100L

OPERATING MAINTENANCE INSTRUCTIONS



FEATURES

- Large surface ground cast iron tables will ensure accuracy.
- Heavy duty, three-knife cutterhead allows fast cutting and superior finish.
- Jack screws system for easy knife adjustment.
- Heavy duty center mounted with large cast iron fence with 90° and 45° positive stops for quick adjustment.
- In-feed and out-feed tables are adjusted by handwheels for more precision. A rabbeting ledge is built into the table.
- 4" (102mm) dust collection outlet included.
- Safety hand paddles included.
- Extra long tables to assure a perfectly flat and true table surface up to 55". (Model 80-100L).

SPECIFICATIONS

Table size (80-100):	7 1/4" x 45 3/8"
Table size (80-100L):	7 1/4" x 55"
Maximum cutting width:	6" (152 mm)
Maximum cutting depth:	1/2" (13 mm)
Rabbeting capacity:	1/2" (13 mm)
Fence sizes:	4" x 29" (102 x 737 mm)
Number of knives:	3
Cutterhead speed:	4800 R.P.M.
Motor:	1 HP, 110/220 V, 1 ph.
Weight:	275 LBS (125 kg)

SAFETY RULES

READ CAREFULLY BEFORE OPERATING THE MACHINE

1. Learn the machine's applications and limitations, as well as the specific potential hazards particular to this machine. Follow available safety instructions and safety rules carefully.
2. Keep working area clean and be sure adequate lighting is available.
3. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.
4. Keep hands well away from blades and all moving parts. Do not clear chips and sawdust away with hands. Use a brush.
5. Make sure the blades are moving at operation speed before cutting.
6. Do not push the blades too hard. The jointer will perform better and be safer working at the rate for which it was designed.
7. Whenever possible use a dust collector with shaving hood to minimize health hazards.
8. Never leave the machine with the power on.
9. Stop the feeder before stopping the Jointer.
10. Keep children away. Make sure that visitors are kept at a safe distance from the work area.
11. Use recommended speed cutting blades and accessories, and workpiece material.
12. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
13. Be sure blades are securely locked in the machine.
14. Use suitable support if stock does not have a flat surface.
15. Do not force the machine. It will do the job better and be safer at a rate for which it was designed.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the tool again.
17. Be sure that key and adjusting wrenches have been removed before turning power on.
18. Use only accessories designed for the machine.
19. Make sure tool is properly grounded. If tool is equipped with three-prong plug, it should be plugged into a three-pole electrical receptacle. Never remove the third prong.
20. Always disconnect tool before servicing and when changing accessories such as blades.
21. Make sure that switch is in "OFF" position before plugging in cord.
22. Hold material firmly against the table.
23. Use ONLY recommended accessories. Use of accessories NOT recommended by General International may result in a risk of injury.
24. Do not use this jointer for other than its intended use. If used for other purposes, General International disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

GENERAL ® INTERNATIONAL guarantee

All component parts of GENERAL INTERNATIONAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL INTERNATIONAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months from date of purchase. In order to obtain warranty, all defective parts must be returned pre-paid to GENERAL INTERNATIONAL MFG. Co Ltd. Repairs made without our written authorization voids all guarantees.

6" DELUXE JOINTER

80-100/80-100L

GENERAL® INTERNATIONAL Jointers are carefully tested and inspected before shipment and if properly used will give perfect results. However, a reasonable amount of care and attention is necessary to ensure perfect performance and accurate work. It is imperative that you take a few moments to familiarise yourself with these instructions, as they will no doubt save you a lot of time and trouble.



UNPACKAGE AND CLEANUP

To ensure maximum performance from your GENERAL® INTERNATIONAL 6" Jointer, clean it properly; and install it accurately before use. As soon as you receive your Jointer, we recommend you follow these procedures:

1. Finish removing the contents of the shipping carton and compare with the contents list.
2. Report damage, if any to your local distributor.
3. Clean all rust protected surfaces with a mild solvent or kerosene. Do not use lacquer thinner; paint thinner, or gasoline. These will damage painted surfaces.
4. To prevent rust, apply a light coating of paste wax to surface.

CONTENTS LIST

Jointer Box

- 1 Jointer Assembly
- 1 Fence Assembly w/ Fence Handle
- 1 Cutter Guard
- 1 Belt Guard
- 1 V-Belt
- 4 1/4-20 x 1/2 Pan HD. Screw
- 4 1/4 Flat Washers
- 3 Mounting Bolts
- 3 3/8" Lock Washers
- 2 Push Blocks
- 2 Handle wheel
- 1 Lock bolt
- 1 Lock Nut
- 1 1/2" Flat Washer
- 2 Open-End Wrenches
- 1 3mm Hex Wrench
- 1 6mm Wrench(80-100L)
- 1 Knife Setting Gauge
- 2 Extension Wing(80-100L)
- 4 Setting Screw m6 x 1.0 x 14 (80-100L)
- 4 5/16" Hex. screw(80-100L)
- 4 5/16" Lock Washer(80-100L)

Stand Box

- 1 Stand with Motor
- 1 Door Stand
- 1 Dust Chute Adapter w/ Mounting Hardware
- 4 1/4"-20 x 1/2" Pan HD. Screw.
- 4 1/4" Flat Washer
- 4 1/8"-40 x 3/8" Pan HD. Screw.
- 4 1/8" Flat Washer

Tools Needed

- 1 Flat Head Screwdriver

INSTALLATION AND SETUP

1. Your jointer and your stand are shipped in 2 separate boxes, please inspect and verify both cartons before assembling.
2. Remove your jointer and stand from the boxes, place your jointer onto the stand, bolt the jointer to the stand through the pre-drilled holes.
3. Insert the screws through the inside of the stand; securely tighten with bolts in order to hold in position.
4. Install your machine on a fixed solid foundation. Verify if machine stand remains steady and properly balanced.
5. Place your machine properly, avoiding obstacles that may interfere while work operations are being performed.

••••• **CAUTION!** •••••

NEVER ATTEMPT TO CONNECT TO AN OUTLET WITH A GREATER POWER SOURCE VOLTAGE THAN REQUIRED!

••••• **ATTENTION!** •••••

ALWAYS VERIFY THAT THE MACHINE IS PROPERLY GROUNDED TO AVOID ELECTRIC SHOCK TO THE WORK OPERATOR!

ELECTRICAL REQUIREMENTS

Before connecting the machine to the power source verify that the voltage supplied corresponds as specified on the nameplate of the machine. A power source with greater voltage than needed can result in serious injury to the user as well as damage the machine. If in doubt, contact a qualified electrician before connecting to the power source.

GROUNDING

Machine must be properly grounded in order to avoid electric shock to the work operator. The use of an extension cord is not recommended, if necessary use a three-prong extension cord and outlet (immediately replace the extension cord if worn out, cut or damaged). If in doubt contact a qualified electrician. (Fig.1 & 2)

The Jointer has been pre-wired at the factory for 110V operations. Connect to a circuit breaker no greater than 110V, to avoid shock or fire; replace the power cord if it gets worn out, cut or damaged in any way replace immediately. To switch to 220V proceed with the following steps: Fig.3

1. Turn the machine "Off" and disconnect from the power source.
2. Open the motor junction box, a diagram has been designed to illustrate the correct wiring for 110 and 220 Volt operations.
3. Change the wire connections for 220 Volts according to the diagram; close the motor junction once finished.

Fig. 1

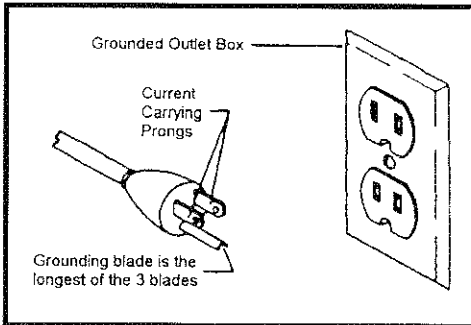


Fig. 2

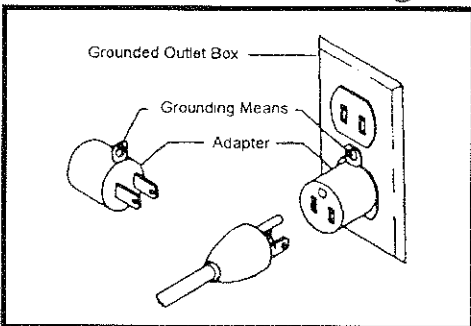
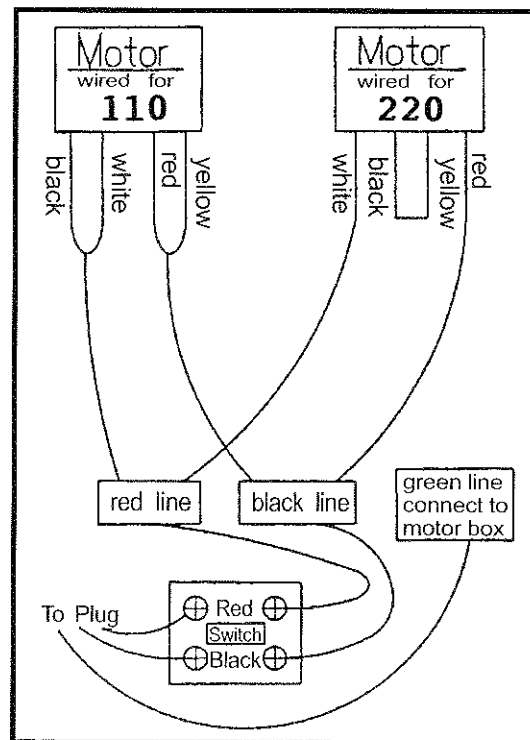


Fig. 3



.....**WARNING!**.....

DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE PERFORMING ANY ADJUSTMENTS, OR REPLACEMENTS TO THE MACHINE! FAILURE TO COMPLY WILL RESULT IN SERIOUS INJURIES!

.....**ATTENTION!**.....

ALL WORK OPERATORS MUST READ AND FULLY UNDERSTAND THE OPERATORS MANUAL BEFORE PERFORMING ANY WORK OPERATIONS! FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES TO THE WORK OPERATOR AND THE MACHINE!

MOTOR MOUNTING

Note: Before mounting; attach the wires to the motor, this method will allow easy and convenient mounting. To install the motor:

1. Verify if the motor is rotating in the proper direction. If not, reverse the rotation according to the instructions accompanying the motor, once completed begin mounting motor to motor bracket.
2. Remove rear panel.
3. Install the motor on the motor bracket, bolt in place.
4. Install the pulley and the V-belt; line up both pulleys using a straight edge.

Note: The motor bracket or the pulley on the motor shaft can be moved to align both pulleys.

5. Adjust the motor base for proper belt tension by loosening the bolts that fasten the motor to the base and slide the motor until proper tension is achieved.
6. Proper tension is achieved when light finger pressure deflects the center span of the belt at about 1-inch.

ADJUSTMENTS

The General ® International 6" Jointer has been factory adjusted and is ready to operate, however a checkup is recommended both to familiarise yourself with the machine and to be certain that all parts are in working order.

TABLES

Refer to Fig.4,5,6

The rear table should be adjusted fairly tight as it rarely moves. If too loose or too tight, loosen the lock nuts (B) and adjust the gib screws (A) on the backside of the machine then lock in place.

The front table is adjusted in the same manner. As it will move very often, care should be taken that the table is not too loose on its slides as it will make it difficult to plane true work and also permit dust to get in the slides and throw your table out of alignment.

These adjustments are provided to take up wear on the slides. It is seldom necessary to adjust the rear table as it remains in a fixed position most of the time and will not show any wear during the life of the machine but it may be necessary to re-adjust the front table after long use.

Fig. 4

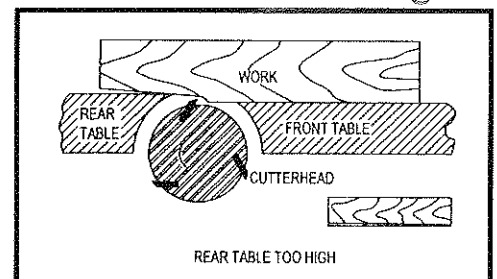


Fig. 5

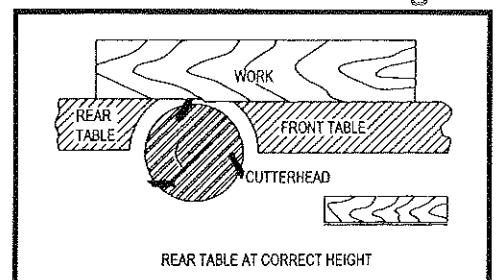
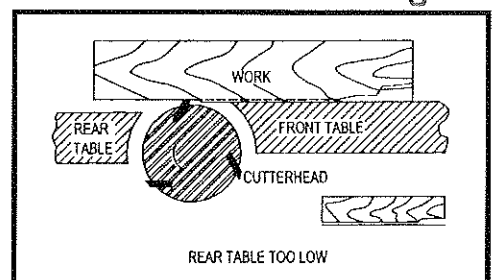


Fig. 6



ADJUSTING THE GIBS

1. Loosen the three Infeed table lock nuts (A) (Fig.7) and the two Outfeed table lock nuts (B) (Fig.8).
2. Adjust the three gib adjusting screw (C) on the Infeed table (Fig.7) and the two gib adjusting screws (D) on the Outfeed table (Fig.8) until smooth Infeed table traverse is found.
3. Tighten all lock nuts.

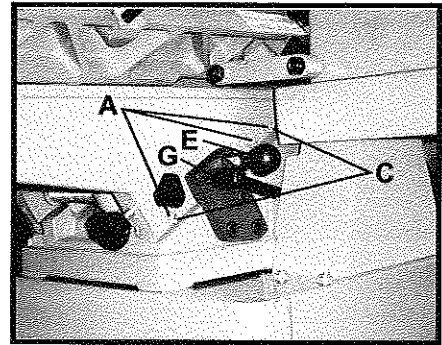


Fig. 7

DEPTH OF CUT ADJUSTMENT

1. Move the Infeed table up or down, in order to set the depth of cut.
2. The table can be moved by turning the handle (C) in front of the table (Fig.9)
3. Loosen the Infeed table position fix the lever, before turning the handle. Tighten the Infeed table position lock fix lever (G) after the Infeed table is adjusted (Fig.7)
4. NOTE: The depth of cut stops at the 0", 1/8", and 1/2" positions.
5. When adjusting the Infeed table vertically, the table will lock at the 1/8" positive stop. Pull out the index stop knob (E) to continue moving the table (Fig.7)
6. The depth of cut adjustment can be read on the depth scale (F), located at the front of the Infeed table (Fig.10)

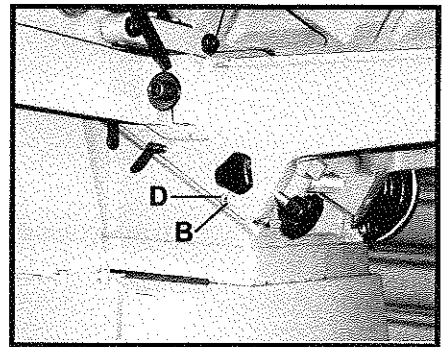


Fig. 8

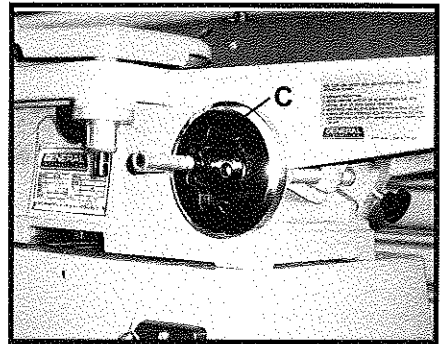


Fig. 9

KNIVES

Accurate work can be achieved when the knives in the cutterhead are parallel to the tables and jut out equally from the cutterhead. General ® International recommends that this be verified before starting any work operations. (Fig.11) Follow this method in order to verify:

1. Raise the rear table until it is even with the base at the slide.
2. Place two (2) straight edges on the rear table extension over the cutterhead the rotate the cutterhead by hand; the knives should slightly touch the straight edges.
3. If the knife is too high or too low at either end, loosen the screw of the lock bar with a small wrench.
4. The knife can be gently pushed up or tapped down with a soft object until it slightly touches the straight edges.
5. Re-tighten to screws to hold in position.
6. Repeat these steps until all knives are equal.

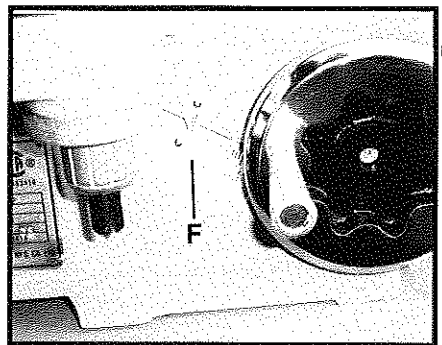


Fig. 10

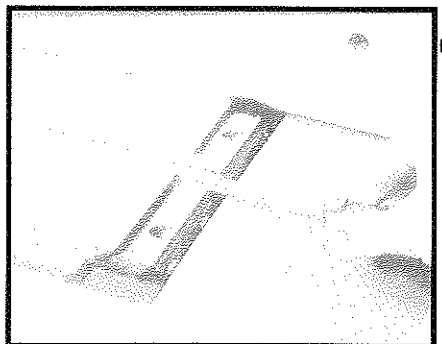


Fig. 11

7. It is extremely important that the knives are all leveled with the rear table. The knives should jut out about 0.10mm to 0.15mm past the rabbeting clearance in the rear table.
8. To obtain maximum performance, we recommend that the knives be kept sharp at all times. If the knives are dull the finishes will suffer accordingly and a jointer with dull knives is dangerous to operate.

SETTING KNIVES

When the knives are removed, care must be used in resetting them. Two straight edges or straight pieces of hardwood are placed on the rear table, a knife is inserted and the screws of the lock bar must be gently tightened. The cutter head is then revolved backwards carefully and the knife is tapped down gently with a softy object. The knife must slightly touch the straight edge without moving them (Fig.12).

Re-tighten the screws, and set the other knives in the same manner. Verify that all the screws are properly tightened, the accuracy of the knife set-up will effect the quality and precision of your work piece.

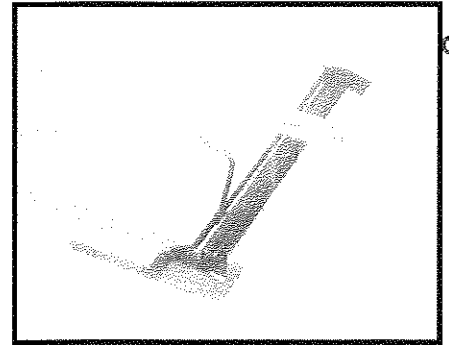


Fig. 12

FENCE

The fence can be moved across the full width of the table and is held in place by tightening the locking handle (A). The fence tilts to any desired angle, to tilt the fence it is necessary to unlock the side handle (B) and swing back the stop (Fig.13).

The fence bracket also acts as a rear knife guard by covering the part of the cutter-head that is not being used behind the fence.

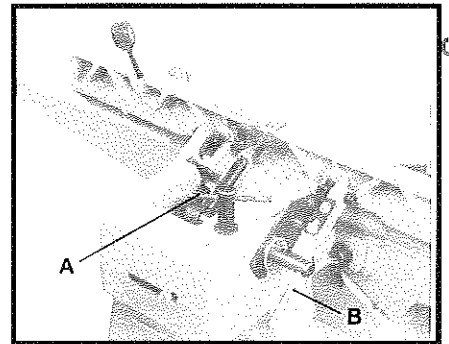


Fig. 13

ADJUSTING THE 45° FENCE INWARD POSITIVE STOP

1. Loosen lock lever (C) (Fig.14).
2. Tilt fence inward.
3. Re-tighten the lock lever (C).
4. Place a square (D) onto the table and against the fence (Fig.15).
5. Verify if the angle between the fence and the table is 45°.
6. If adjustments are required loosen the nut (H) and turn the adjustment screw (J) until you have obtained a 45° angle.
7. Re-tighten nut (H).

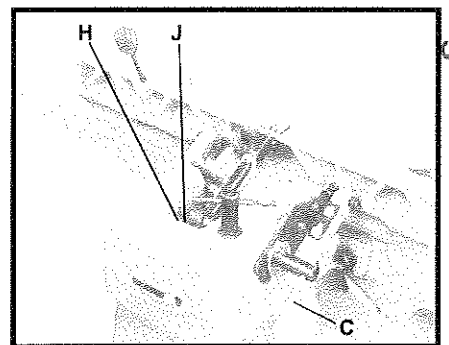


Fig. 14

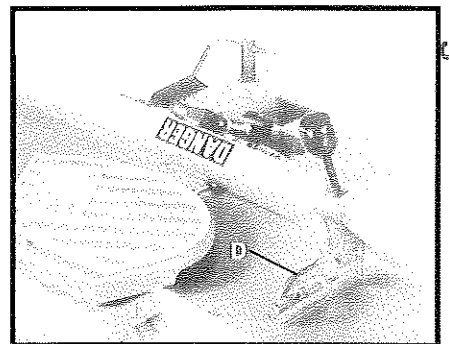


Fig. 15

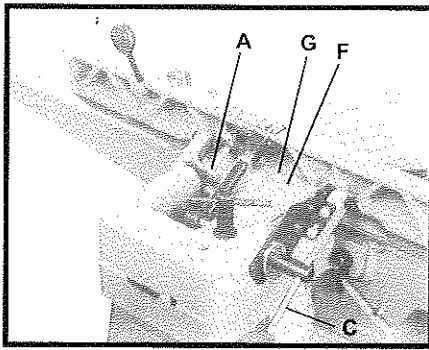


Fig. 16

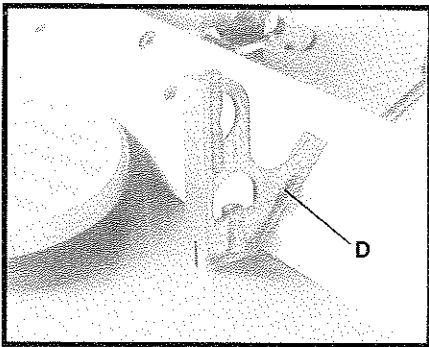


Fig. 17

ADJUSTING THE 45° FENCE OUTWARD POSITIVE STOP

1. Loosen lock lever (C) (Fig.16).
2. Pull out and turn plunger (A).
3. Tilt the fence outward.
4. Re-tighten lock lever (C).
5. Place a square (D) onto the table against the fence (Fig.17)
6. Verify if the angle between the fence and the table is 45°.
7. If adjustments are required for fence tilting; loosen nut (F).
8. Adjustment screw (G) should be turned until you have obtained a 45° outward angle.
9. Re-tighten nut (F).

ADJUSTING THE 90° FENCE POSITIVE STOP

1. The operator must engage screw (A) to plate (B) before adjusting the 90° angle between the fence and the table.
2. Tighten fence lock lever (C) (Fig.18).
3. Place a square on the table against the fence (Fig.19).
4. Verify that the fence is squared to the table.
5. If adjustments are required; loosen set nut (F) and adjust screw (A).
6. Re-tighten nut (F).
7. Adjust the fence until squareness between the fence and the table is obtained.

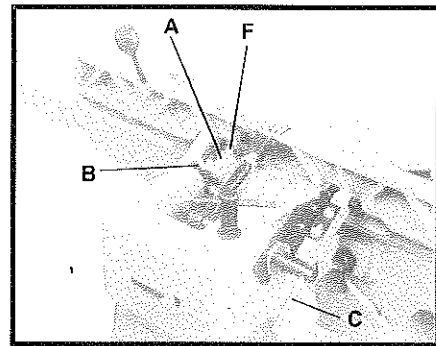


Fig. 18

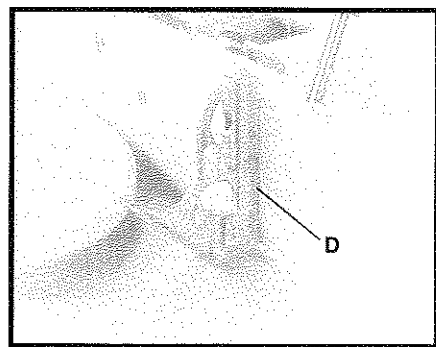
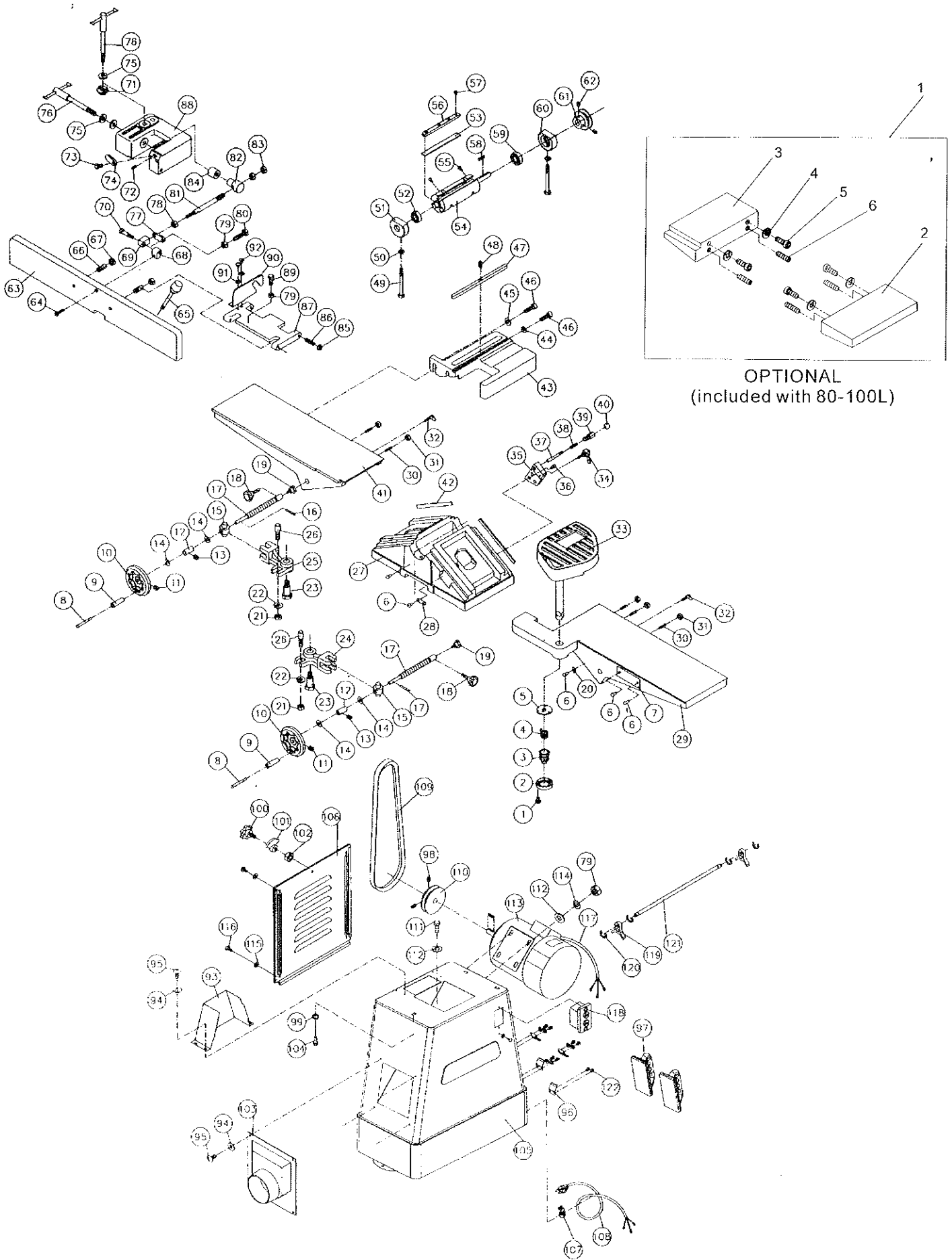


Fig. 19

LUBRICATION / MAINTENANCE

- The ball bearings of the cutter head are permanently sealed and lubricated; therefore requires no further lubrication.
- We recommend that the table and all of the adjustment screws be lightly oil or greased occasional; this will allow the table to move smoothly.
- To keep your jointer clean and in perfect condition, we recommend that your remove any dust and particles from your machine once work operations are completed.



OPTIONAL
(included with 80-100L)

**PARTS LIST
80-100**

PART NO.	DESCRIPTION	SPECIFICATION	QTY
80100-01	SCREW	5/32"-32NCx5/8"	3
80100-02	RETAINER		1
80100-03	SPRING KNOB		1
80100-04	SPRING		1
80100-05	RETAINING WASHER		1
80100-06	RIVET	2 X 5	5
80100-07	NAME PLATE		1
80100-08	HANDLE SHAFT BOLT		2
80100-09	HANDLE		2
80100-10	HANDLE WHEEL		2
80100-11	SET SCREW	1/4"-20NCx3/8"	2
80100-12	BUSHING		2
80100-13	SET SCREW	5/16"-18NCx3/8"	2
80100-14	WASHER	10 x 22 x 0.8	4
80100-15	ADJUSTING NUT	5/8"-11NC	2
80100-16	PIN	3 X 25	2
80100-17	ADJUSTING SCREW	5/8"-11NC	2
80100-18	LOCK KNOB	32x5/16"-18NCx1-1/4"	2
80100-19	LOCK KNOB	25x1/4"-20NCx1/2"	2
80100-20	POINTER		1
80100-21	HEX NUT	1/2"-12NC	2
80100-22	WASHER	13.3 x 21x 2.6	2
80100-23	PIVOT PIN	1/2"-12NC	2
80100-24	BALL CRANK		1
80100-25	BALL CRANK		1
80100-26	SHOULDER PIN	1/2"-12NC	2
80100-27	BASE		1
80100-28	DEPTH SCALE		1
80100-29	FRONT TABLE		1
80100-30	SET SCREW	1/4"-20NC x 1"	6
80100-31	HEX NUT	1/4"-20NC	6
80100-32	LOCK SCREW	7/8" x 1/4"-20NC x1"	3
80100-33	CUTTERHEAD GUARD		1
80100-34	LEVER	1/4"-20NCx7/8"	1
80100-35	FIXING BRACKET		1
80100-36	CAP SCREW	5/16"-18NCx3/4"	3
80100-37	FIX. SHAFT	1/4"-20NC	1
80100-38	SPRING		1
80100-39	SPRING SLOT	1/2"-12NC	1
80100-40	KNOB HEAD	22 x 1/4"-20NC	1
80100-41	REAR TABLE		1
80100-42	GIB	165 x11 x 3.2	2
80100-43	FENCE BASE CASTING		1
80100-44	WASHER	3/8"x20x3	1
80100-45	WASHER	3/8" x 25 x 3	1
80100-46	HEX SOCKET CAP SCREW	3/8"-16NCx1-1/2"	2
80100-47	KEY	3/8" x 3/8" x 225	1
80100-48	SPRING PIN	4 X 12	1
80100-49	BOLT	3/8"-24UNF	2
80100-50	LOCK WASHER	10.2 X 16.2 X 2.2	2
80100-51	BEARING HOUSING		1
80100-52	BALL BEARING	6202ZZ	1
80100-53	KNIFE	153.96 X 16.5 X 2.5	3
80100-54	CUTTERHEAD		1
80100-55	SCREW	M5x0.8Px12	6
80100-56	KNIFE LOCK BAR	152.4 X 14 X 7	3
80100-57	HEX SCREW	1/4"-28UNF	12
80100-58	KEY	5 X 5 X 25	1
80100-59	BALL BEARING	6203ZZ	1
80100-60	BEARING HOUSING		1
80100-61	CUTTERHEAD PULLEY		1
80100-62	SET SCREW	1/4"-20NCx3/8"	2
80100-63	FENCE BODY		1
80100-64	FLAT HEX SOCKET SCREW	5/16"-18NCx15/8"	1
80100-65	KNOB		1
80100-66	FENCE LINK	1/2"-20NF	2

**PARTS LIST
80-100**

PART NO.	DESCRIPTION	SPECIFICATION	QTY
80100-67	HEX NUT	1/2"-20NF(T= 1/4")	2
80100-68	BLOCK	5/16"-18NC	1
80100-69	BLOCK	5/16"-18NC	1
80100-70	BOLT	13.9 x 36 (5/16"-18NC)	1
80100-71	LOCK NUT	1/2"-12NC	1
80100-72	SPRING PIN	4 X 12	2
80100-73	HEX CAP BOLT		1
80100-74	PLATE		1
80100-75	WASHER	17.5 X 38 X 3T	3
80100-76	LOCK HANDLE		2
80100-77	PLATE		1
80100-78	HEX NUT	7/16"-20NC	1
80100-79	HEX NUT	5/16"-18NC	6
80100-80	HEX CAP BOLT	5/16"-18NC X 1-1/2"	1
80100-81	STUD		1
80100-82	SWIVEL BLOCK		1
80100-83	HEX NUT	5/8"-18NF	2
80100-84	BUSHING		1
80100-85	HEX NUT	3/8"-16NC	4
80100-86	THREADED STUD	3/8"-16NC	4
80100-87	TILT PLATE		1
80100-88	CASTING		1
80100-89	HEX CAP BOLT	5/16"-18NCx1"	1
80100-90	PLATE		1
80100-91	WASHER	1/4" X 13 X 0.8	2
80100-92	PAN HD MACHINE SCREW	1/4"-20NC X 1/2"	2
80100-93	COVER		1
80100-94	WASHER		8
80100-95	PAN HD MACHINE SCREW		8
80100-96	SPRING PLATE		4
80100-97	PUSH BLOCK		2
80100-98	SET SCREW		2
80100-99	SPRING WASHER		3
80100-100	KNOB		1
80100-101	DOOR LATCH		1
80100-102	HEX NUT		1
80100-103	DUST CHUTE		1
80100-104	HEX SCREW		3
80100-105	STAND		1
80100-106	DOOR		1
80100-107	CORD CLAMP		1
80100-108	POWER CORD		1
80100-109	BELT		1
80100-110	MOTOR PULLEY		1
80100-111	HEX SCREW		4
80100-112	WASHER		8
80100-113	MOTOR		1
80100-114	SPRING WASHER		4
80100-115	WASHER		4
80100-116	PAN HD MACHINE SCREW		4
80100-117	MOTOR WIRE		1
80100-118	SWITCH ASS'Y		1
80100-119	KNIFE GAGE		2
80100-120	RETAINING RING		4
80100-121	CLUB OF KNIFE GAGE		1
80100-122	SCREW		8

OPTIONAL (INCLUDED WITH 80-100L)

80100-001	EXTENSION TABLE ASS'Y		1
80100-002	FRONT EXTENSION TABLE		1
80100-003	REAR EXTENSION TABLE		1
80100-004	SPRING WASHER	8.2x15.4	4
80100-005	CAP SCREW	5/16"-18NCx3/4"	4
80100-006	SET SCREW	M6x1.09x14	4