



Operating Instructions and Parts Manual

15-inch Thickness Planer

Models JWP-15DX and JWP-15HH



JET

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1.0 Warranty and service

JET® warrants every product it sells against manufacturers’ defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer’s defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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3.0 Safety warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This planer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a planer, do not use until proper training and knowledge have been obtained.
5. Do not use this planer for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this planer. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this planer, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the planer is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. **Keep children away.**

21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the knives or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep knives sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Make sure the workpiece is securely attached or clamped to the table. Never use your hand to hold the work piece.
28. Turn off the machine and disconnect from power before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

-- SAVE THESE INSTRUCTIONS --

4.0 Introduction

This manual is provided by JET covering the safe operation and maintenance procedures for a JET Model JWP-15DX and JWP-15HH Planer. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

5.0 Specifications

Model Number.....	JWP-15DX.....	JWP-15HH
Stock Number.....	708538.....	708543
Maximum Cutting Width (in.).....	14-7/8.....	14-7/8
Maximum Cutting Thickness (in.).....	6.....	6
Full Width Cutting Depth (in.).....	1/8.....	1/8
Maximum Cutting Depth (in.).....	3/16.....	3/16
Minimum Planing Length (in.).....	8.....	8
Number of Knives.....	3.....	68 knife inserts
Cutterhead Speed (RPM).....	4,500.....	4,500
Cuts Per Minute.....	13,500.....	not applicable
Cutterhead Diameter (in.).....	2-7/8.....	2-7/8
Feed Rate (FPM).....	16 and 20.....	16 and 20
Dust Chute Diameter (in.).....	4.....	4
Motor.....	TEFC, 3HP, 1Ph, 230V, 60Hz.....	TEFC, 3HP, 1Ph, 230V, 60Hz
Overall Dimensions (LxWxH)(in.).....	48 x 28 x 43-1/2.....	48 x 28 x 43-1/2
Net Weight (lbs.).....	475.....	475
Gross Weight (lbs.).....	590.....	590

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.0 Unpacking

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Planer is assembled and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Report any missing parts to your distributor. Read this manual thoroughly for assembly, maintenance and safety instructions.

6.1 Contents of shipping container

(see Figure 1 to help identify parts)

- 1 Planer
- 1 Dust Hood
- 2 Extension Tables
- 1 Handwheel
- 1 Handle
- 2 Magnet Tools – *Model JWP-15DX only*
- 4 Hex Wrenches (3,4,5 and 6mm)
- 1 T-handle Hex Wrench (4mm) – *Model JWP-15DX only*
- 3 Open-end Wrenches (8-10, 12-14,14-17)
- 3 Bags of Fasteners (*contents on page 7*)
- 1 Owner's Manual
- 1 Warranty Card

Contents of fastener bags (Figure 2):

- A – (for installing Handwheel)
 - 1 Direction Label
 - 1 Hex Nut
 - 1 Flat Washer
 - 1 Key
- B – (for installing Extension Tables)
 - 6 Hex Cap Screws, M8x25
 - 6 Socket Set Screws, M8x20
- C – (for installing Dust Hood)
 - 6 Hex Washer Head Screws, M6x12

Model JWP-15HH ONLY:

- 2 Star Point Screwdrivers
- 1 Set of 10 Knife Inserts
- 10 Knife Insert Screws

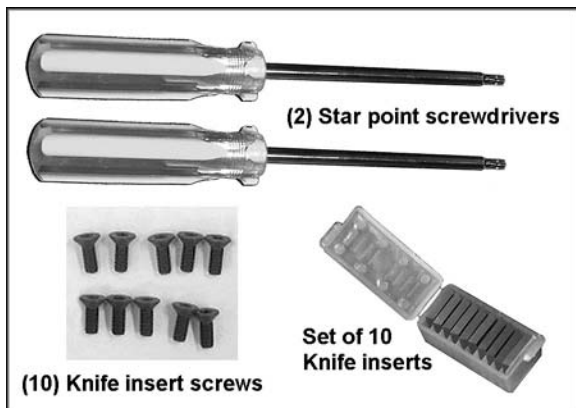


Figure 2a (JWP-15HH only)

IMPORTANT: If you purchased the helical head planer, before operating the machine verify that each knife insert has been properly torqued. Refer to sect. 9.6 for information.

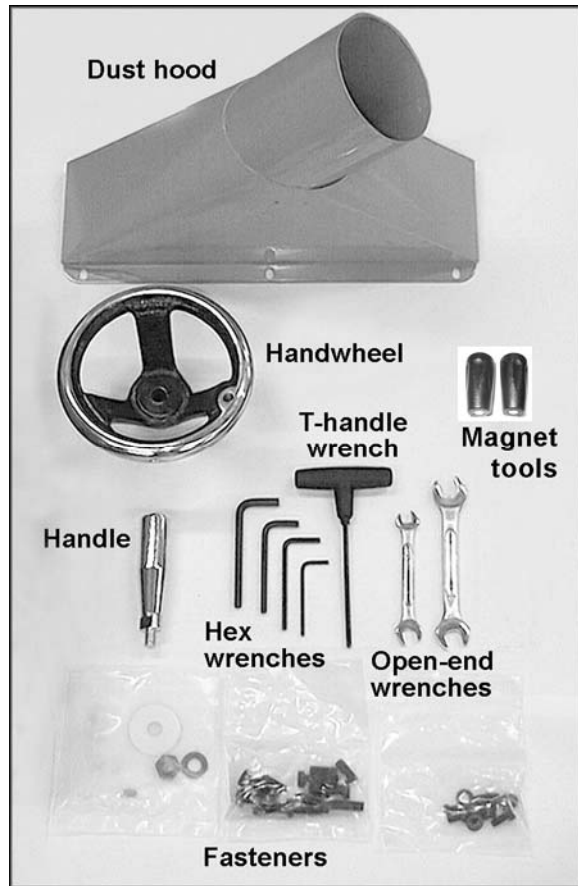


Figure 1

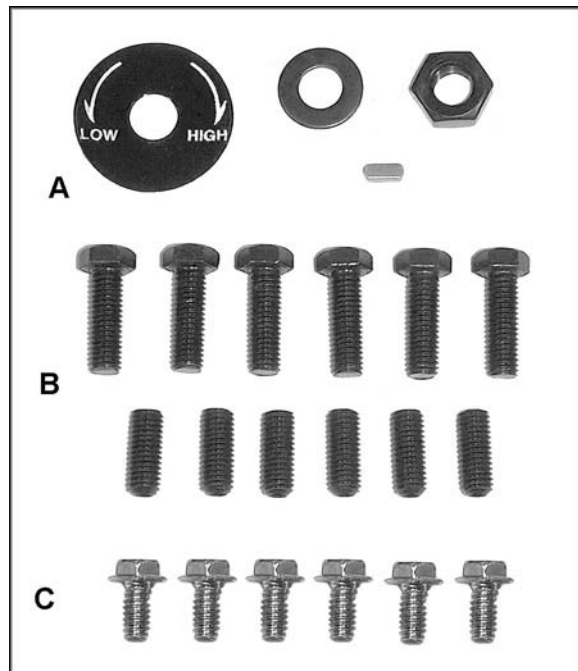


Figure 2

7.0 Assembly

Tools required for assembly:

Forklift or hoist with slings
Open-end wrenches (provided)
Hex wrenches (provided)
16mm open-end wrench

Remove the screws holding the planer to the pallet and use a forklift or hoist to lift the planer off the pallet. Forks and straps should always be placed under the four lifting handles when lifting this machine (Figure 3). The lifting handles can be pushed back in when not in use.

The planer should be operated in a well-lit area with good ventilation. It can be rolled on its casters to the desired location. Press the foot pedal (Figure 4) to lock the casters during operation or adjustments.

Exposed surfaces, such as tables, rollers, cutterhead, etc., have been given a protective coating at the factory. This should be removed with a soft cloth moistened with a good commercial solvent. Do not use acetone, gasoline, lacquer thinner, or other solvents with a low flash point. Do not use an abrasive pad because it may scratch the polished cast iron surfaces.

CAUTION Use care when cleaning around the cutterhead area; knives are extremely sharp.

7.1 Handwheel

1. Place the key into the slot on the shaft (Figure 5), and mount the handwheel to the shaft, making sure it is oriented so that it slips over the key.
2. Peel off the backing of the directional label, and attach it to the center of the handwheel. Place flat washer and hex nut on shaft and tighten with 16mm wrench.
3. Mount the handle in the threaded hole in the handwheel, and tighten with a 12mm wrench placed over the flat on the nut.

7.2 Control box

Mount the control box as shown in Figure 6, with the two socket head cap screws which you'll find mounted to the head casting. Use a 5mm hex wrench.

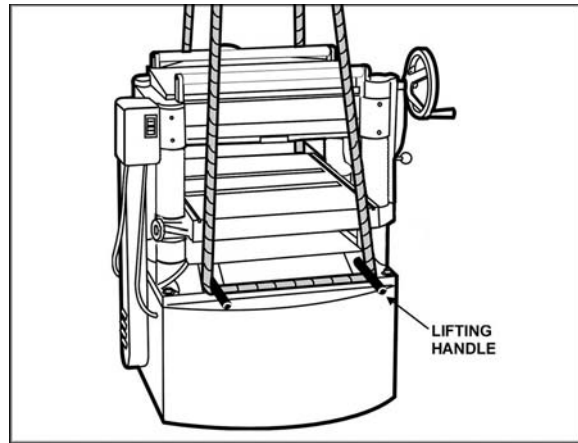


Figure 3

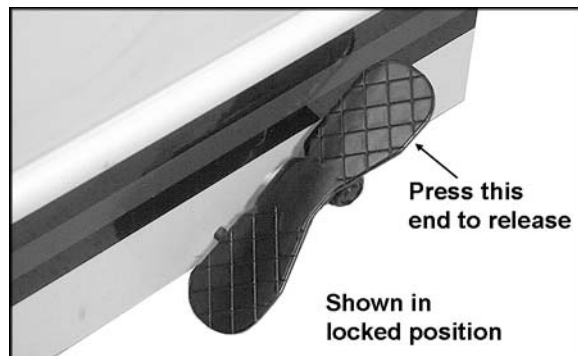


Figure 4

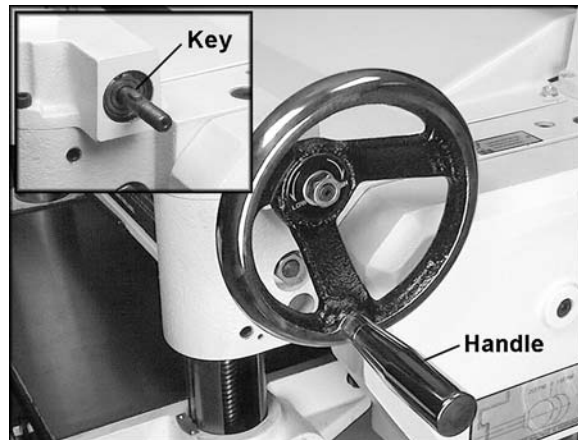


Figure 5

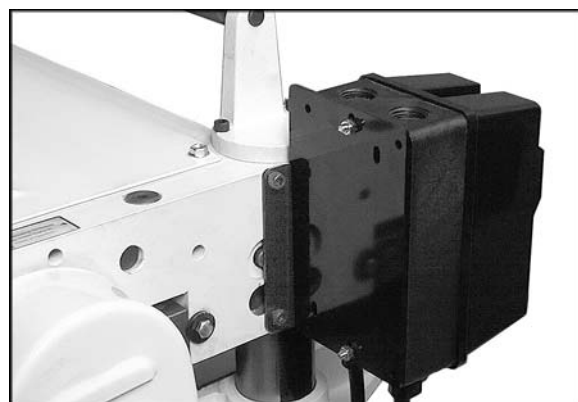


Figure 6

7.3 Extension tables

The JWP-15DX extension tables have rollers; the JWP-15HH extension tables are cast iron. Both are installed in the same manner.

1. Mount an extension table to the edge of the main table with three M8 x 25 hex cap screws and washers (Figure 7) using a 12mm wrench. Do not fully tighten yet.
2. The extension table must be leveled with the main table. Place a straight edge (such as a carefully jointed board, or a steel bar) across the extension table and the main table. Move the straight edge to various points along the table during the procedure.

NOTE: The straight edge should not lie over the raised table rollers, as this would distort the leveling process. Either place the straight edge just short of the table rollers, or lower the table rollers completely into the table (see page 12) until the extension tables have been installed.

3. Insert three socket set screws below the hex cap screws, using a 4mm hex wrench, and screw them in or out as needed until tables are level.
4. Securely tighten the hex cap screws.
5. Mount the second extension table to the opposite side of the planer table, using the same procedure.

7.4 Dust hood

Mount the hood to the rear of the head casting with six M6 x 12 hex washer head screws (A, Figure 8).

It is strongly recommended that you use a dust collection system with this planer. If you are not using a dust collection system, do not attach the dust hood to the planer, as the accumulation of dust inside the hood may create a safety hazard, or eventually cause jamming of the roller system in the cutterhead.

8.0 Grounding instructions

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock.



Figure 7

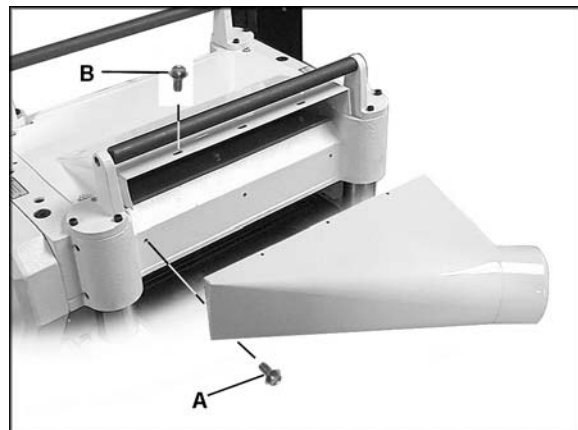


Figure 8

This machine's power cord must be fitted with an appropriate UL/CSA listed 230 Volt plug (similar to the one shown in Figure 9), or it can be "hard-wired" directly to a control panel. If hard-wired, make sure a disconnect is available for the operator.

If a plug is installed, it must have an equipment-grounding conductor and a grounding prong. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify the plug – if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding connector.

If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

It is recommended that this 15-inch planer be connected to a dedicated, minimum 30 amp circuit with a 30 amp circuit breaker or time delay fuse. **Local codes take precedence over recommendations.**

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

8.1 Extension cords

The use of an extension cord is not recommended for this machine – try to position the machine within reach of the power supply. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

The chart in Figure 10 shows the correct size cord to use based on cord length and motor plate amp rating. If in doubt, use the next heavier gauge. The smaller the gauge number the heavier the cord.

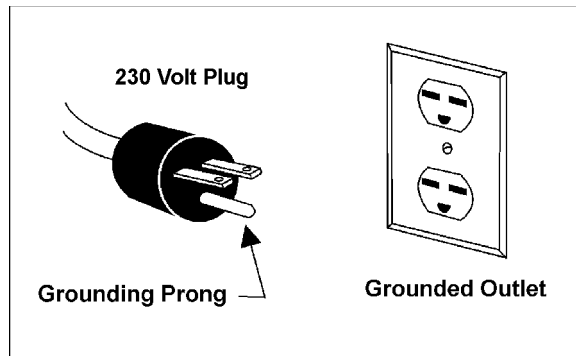


Figure 9

Recommended Gauges (AWG) of Extension Cords

Amps	Extension Cord Length *					
	25 feet	50 feet	75 feet	100 feet	150 feet	200 feet
< 5	16	16	16	14	12	12
5 to 8	16	16	14	12	10	NR
8 to 12	14	14	12	10	NR	NR
12 to 15	12	12	10	10	NR	NR
15 to 20	10	10	10	NR	NR	NR
21 to 30	10	NR	NR	NR	NR	NR

*based on limiting the line voltage drop to 5V at 150% of the rated amperes.
NR: Not Recommended.

Figure 10

9.0 Adjustments

⚠WARNING Disconnect machine from power source before making adjustments (except feed rate).

9.1 Belt tension

Inspect the tension of the belts frequently during the first few times you use the planer. Belts often stretch during this trial period. If they require tightening, proceed as follows:

1. Remove the belt guard and the rear panel.
2. Loosen the bottom nut on the motor adjustment screw (Figure 11) with a 17mm wrench.
3. Turn the top nut on the adjustment screw to lower the motor plate, which will increase the belt tension.
4. Proper tension is achieved when there is slight deflection in the belt midway between the pulleys, using moderate finger pressure.
5. Tighten the bottom nut on the adjustment screw (Figure 11).

9.2 Pulley alignment

The pulleys should be in line for proper belt operation.

1. Remove the belt guard and place a straight edge against the faces of both pulleys (Figure 12).
2. If the straight edge does not lie flat on both pulley faces, as shown in Figure 13, open the rear panel and loosen the four hex nuts on the motor plate (these are shown in Figure 11) with a 12mm wrench.
3. Nudge the motor left or right until the pulleys are in alignment.
4. Tighten hex nuts and replace covers.

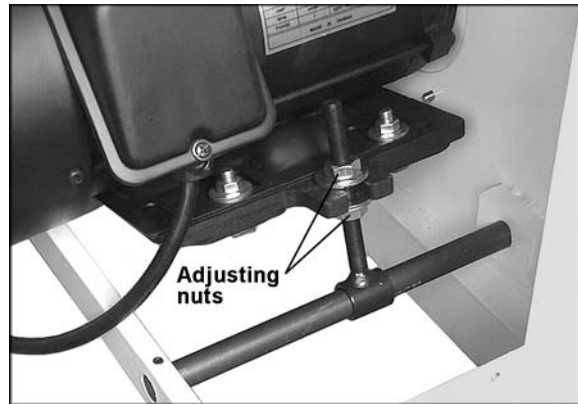


Figure 11

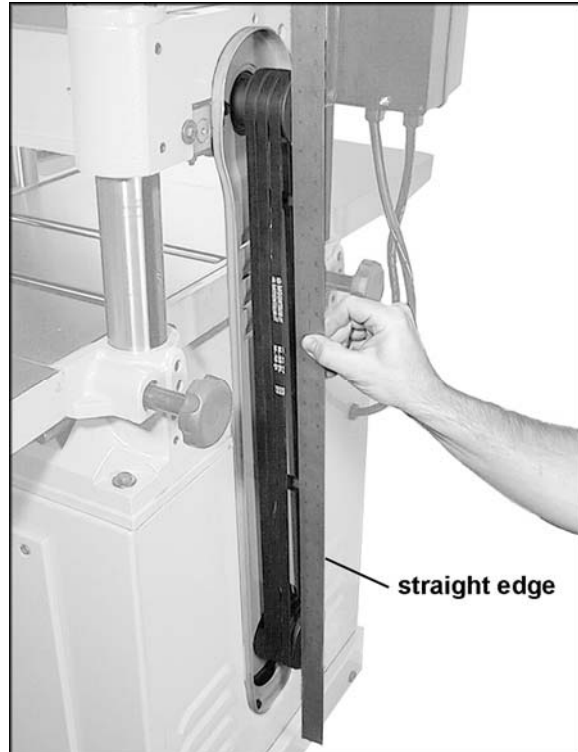


Figure 12

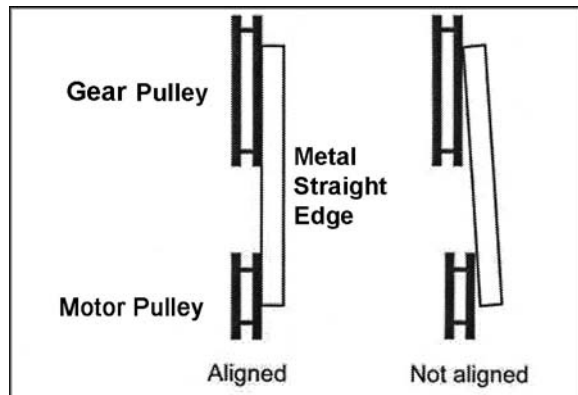


Figure 13

9.3 Table Rollers

Your planer is supplied with two table rollers (Figure 14) which turn as the stock is fed into the machine, thus reducing friction. It is not possible to give exact dimensions on the proper height setting of the table rollers because each type of wood behaves differently. As a general rule, however, when planing rough stock the table rollers should be set at high position. When planing smooth stock the rollers should be set at low position.

NOTE: When raising the roller higher above the table, the range is from zero to 0.06" (Figure 15).

The table rollers are factory set for average planing and are parallel to the table surface. If you desire to adjust the table rollers higher or lower, proceed as follows:

1. Disconnect machine from power source.
2. Lay a straight edge across both rollers.
3. On one side of the table, loosen the set screws (A, Figure 14) with a 3mm hex wrench, and turn the eccentric shafts (B, Figure 14) to raise or lower the rollers.
4. When proper height is achieved, tighten set screws.
5. Adjust the rollers from the opposite side of the table in the same manner.

IMPORTANT: Be sure that the height of front and rear rollers are the same. And the table rollers must always be set parallel to the table.

9.4 Cutterhead

Although your planer was carefully adjusted at the factory, it should be checked before being put into operation. Any inaccuracies due to rough handling in transit can be corrected by following the directions in this manual.

To check the adjustments you will need feeler gauges, and a home-made gauge block made of hardwood. This gauge block can be made by following the dimensions shown in Figure 16.

9.5 Installing and replacing knives (straight cutterhead only)

CAUTION Use caution and proceed slowly when working with and around the knives – they are extremely sharp.

The planer knives are double-sided. If one side becomes dull, the knife can simply be rotated to use the new edge. When both edges have become worn, the knife must be replaced.

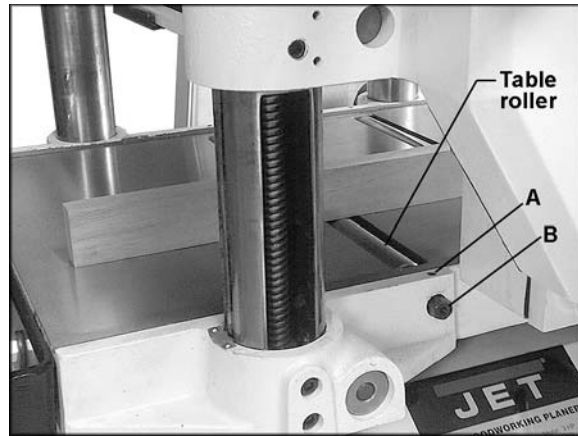


Figure 14

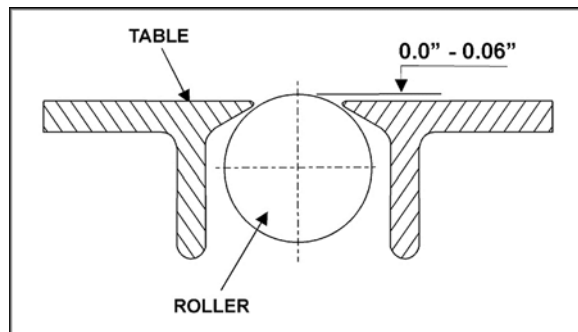


Figure 15

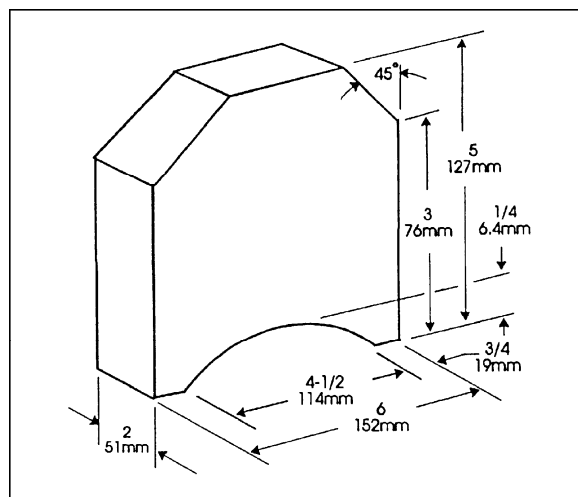


Figure 16

Care must be exercised in setting knives into the cutterhead. Replace all three knives at the same time. Proceed as follows:

1. Disconnect machine from power source.
2. Remove the gib screws and the gib (Figure 17) using a T-handle hex wrench.
3. Remove old knife, and clean cutterhead slot and gibs.
4. Install new knife, making sure the knife fits properly over the two pins in the cutterhead slot. Make sure the blade is oriented in the proper direction. Use the provided magnet tools to help safely position the knives.
5. Place the gibs evenly over the knife, and insert and tighten the gib screws, beginning at one end of the knife and working toward the other end.

⚠WARNING After installing knives, check again carefully. Make certain all gib screws are tightened securely. Loose knives can be thrown from the cutterhead, causing injury.

9.6 Replacing or rotating knife inserts (helical cutterhead only)

The knife inserts on the model JWP-15HH are four-sided. When dull, simply remove each insert, rotate it 90° for a fresh edge, and re-install it.

Use the provided star point screwdriver to remove the knife insert screw. See Figure 17a. It is advisable to rotate all inserts at the same time to maintain consistent cutting. However, if one or more knife inserts develops a nick, rotate only those inserts that are affected.

Each knife insert has an etched reference mark so you can keep track of the rotations.

IMPORTANT: When removing or rotating inserts, clean saw dust from the screw, the insert, and the cutterhead platform. Dust accumulation between these elements can prevent the insert from seating properly, and may affect the quality of the cut.

Before installing each screw, lightly coat the screw threads with machine oil and wipe off any excess.

Securely tighten each screw which holds the knife inserts before operating the planer!

⚠WARNING Make sure all knife insert screws are tightened securely. Loose inserts can be propelled at high speed from a rotating cutterhead, causing injury.

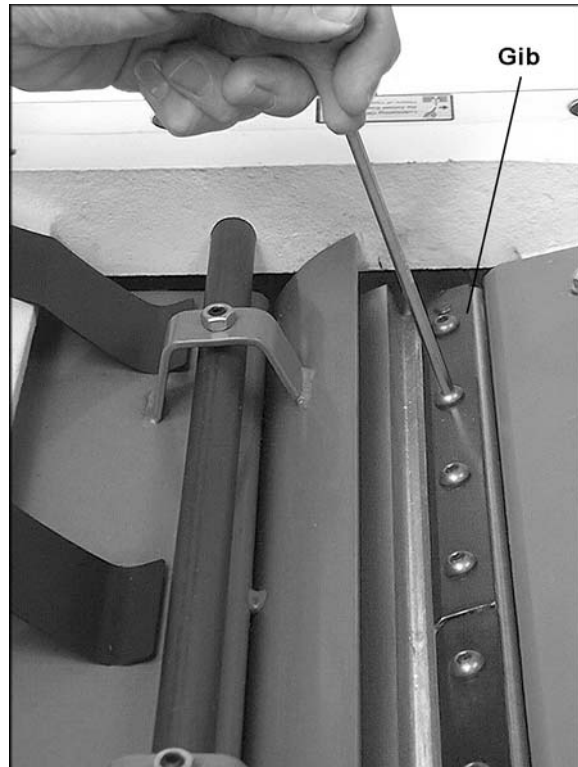


Figure 17
(Model JWP-15DX only)

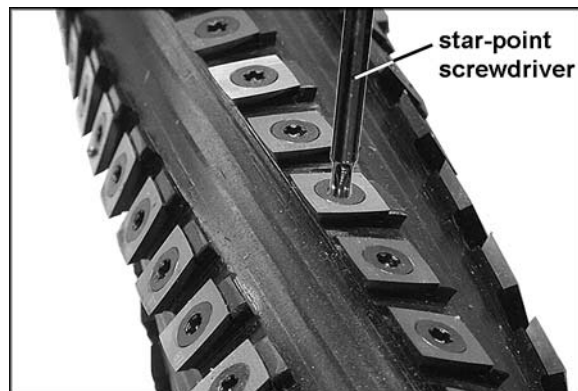


Figure 17a
(Model JWP-15HH only)

IMPORTANT: Maximum torque for tightening the screws is 45 to 55 inch pounds (3.75 to 4.6 foot pounds).

9.7 Inspect work table parallel to cutterhead

The work table is set parallel to the cutterhead at the factory and no further adjustment should be necessary. If your machine is planing a taper, first check to see if the knives are set properly in the cutterhead. Then check to see if the work table is set parallel to the cutterhead. Proceed as follows:

1. Disconnect machine from power source.
2. Place the gauge block (Figure 18) on the work table directly under the edge of a knife as shown. Make slight contact by gently raising table.
3. Move the gauge block to the opposite end of the work table. NOTE: Distance from the work table to edge of knife should be the same at both ends.

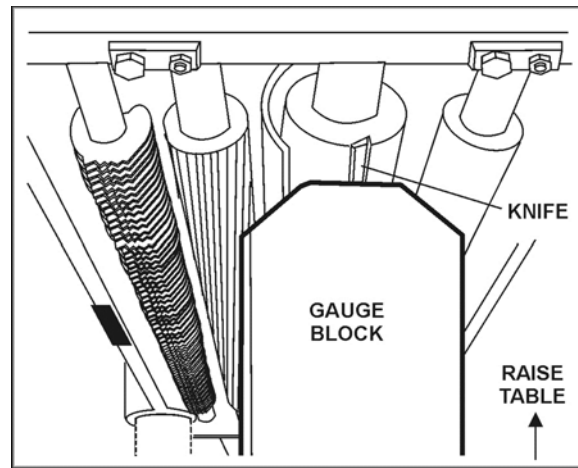


Figure 18

9.8 Adjusting work table parallel to cutterhead (fine adjustment)

If the gap difference determined in the previous section is greater than 0.004" and less than 0.016", perform the adjustment procedure as follows:

1. Determine which side of the table must be raised to correct the gap.
2. Locate the two socket head cap screws in the table casting for each of the columns (Figure 19). Loosen both sets of screws for each column on the side you wish to adjust.
3. Push down or pull up the cutterhead assembly in the desired direction. Hold the assembly in position and retighten the cap screws.
4. Re-check the table-to-cutterhead parallelism again as described in the previous section, then repeat steps 1 through 3 until the deviation is less than 0.004".

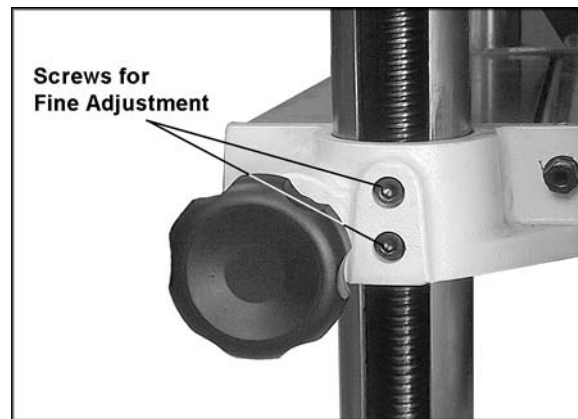


Figure 19

9.9 Adjusting work table parallel to cutterhead (major adjustment)

If the work table is not parallel to the cutterhead, perform the adjustment procedure as follows:

1. Disconnect machine from power source.
2. Remove bolts holding the planer to the stand. Carefully tilt planer on its side to expose underside of base (Figure 20).
3. Remove bolt (A, Figure 20) and loosen bolt (B, Figure 20) which will allow you to move the idler sprocket assembly (C, Figure 20) far enough to release tension on the chain.

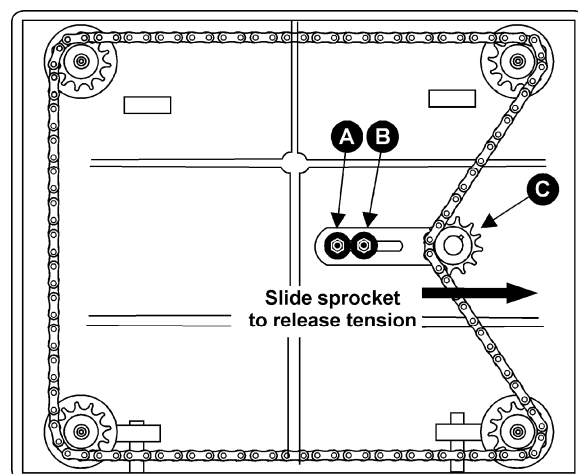


Figure 20

4. Remove the chain from the particular sprocket on the corner of the base that you need to adjust.
5. Turn the sprocket by hand to bring that corner into adjustment with the other three corners. NOTE: Turning sprocket clockwise will increase the distance between the working table and the head casting; counterclockwise will decrease the distance. This adjustment is very sensitive and it should not be necessary to turn the sprocket more than one or two teeth.
6. When adjustments are correct, replace chain around corner sprocket, slide idler sprocket (C-Figure 20) back to re-tension chain, tighten bolt (B, Figure 20) and insert and tighten bolt (A, Figure 20).

9.10 Know the transmitting rollers of your planer

(Figure 21)

- A. Anti-Kickback Fingers
- B. Infeed Roller
- C. Chipbreaker
- D. Cutterhead
- E. Outfeed Roller

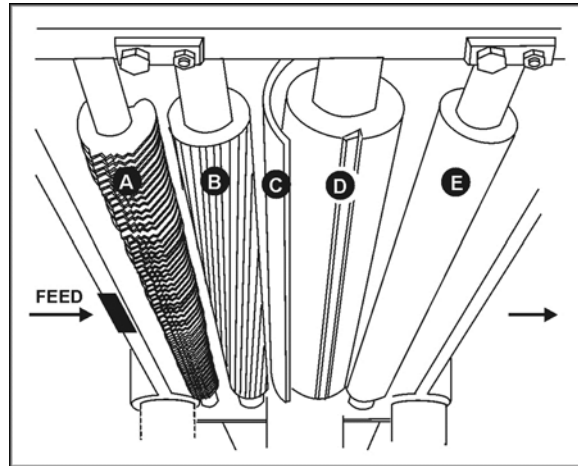


Figure 21

9.11 Anti-kickback fingers

The anti-kickback fingers (A, Figure 21) are an important safety feature, as they help prevent kickback of stock. They operate by gravity and should be inspected frequently to make sure they are free of gum and pitch, so that they move independently and operate correctly.

9.12 Infeed and outfeed roller spring tension

The infeed roller (B, Figure 21) and outfeed roller (E, Figure 21) are those parts of your planer that feed the stock while it is being planed.

The infeed and outfeed rollers are under spring tension and this tension must be sufficient to feed the stock uniformly through the planer without slipping but should not be so tight that it causes damage to the board. The tension should be equal at both ends of each roller.

To adjust the spring tension of the infeed and outfeed rollers, turn screws (Figure 22) with a hex wrench. A clockwise turn increases tension on the pressure spring. See Figure 23. A counterclockwise turn decreases tension. Adjust the screws at the other end of the rollers with the same number of turns.

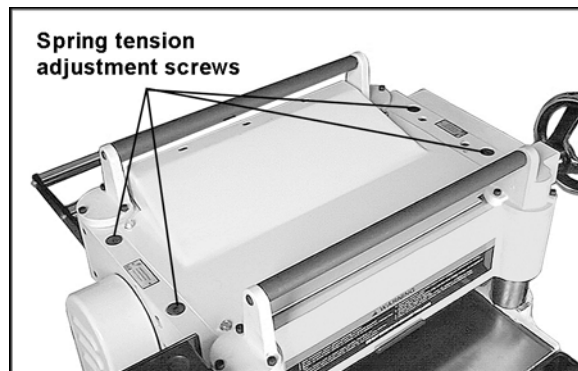


Figure 22

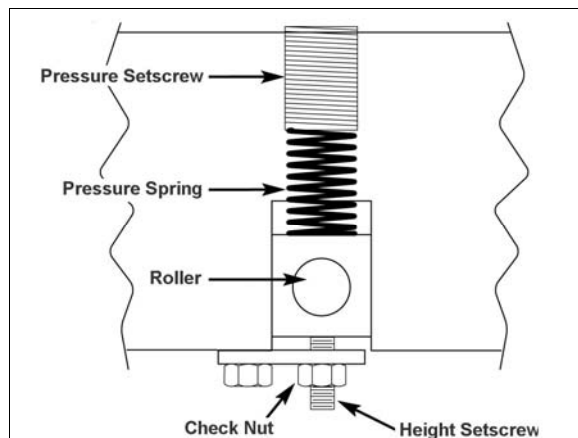


Figure 23

9.13 Height of infeed roller, chipbreaker and outfeed roller

The infeed roller, chipbreaker and outfeed roller are adjusted at the factory. The height relationship between these items and the cutterhead is crucial for accurate and safe planing. The infeed roller, chipbreaker, and outfeed roller should each be set at 0.02" (0.5mm) below the cutting circle. See Figure 24.

If any adjustments are necessary for the infeed roller, chipbreaker, or outfeed roller, they should be done carefully. Use the following steps as an example of procedure.

NOTE: This procedure uses a home-made gauge block and feeler gauges, which should be sufficient for most planer operations. If very precise measurements are desired, however, use a dial indicator device.

9.14 Outfeed roller height

1. Disconnect machine from power source.
2. Make sure the knives are set properly as previously explained under "Knife Adjustment."
3. Place the gauge block (F, Figure 25) on the table directly beneath the cutterhead (D, Figure 25).
4. Using a 0.02" (0.5mm) feeler gauge (G, Figure 25) placed on top of the gauge block, raise the work table until the knife just touches the feeler gauge when the knife is at its lowest point. Do not move the work table any farther until the outfeed roller is adjusted.
5. Remove the feeler gauge and move the gauge block (F, Figure 25) under one end of the outfeed roller. The bottom of the outfeed roller should just touch the top of the gauge block. If an adjustment to the outfeed roller is necessary, loosen the lock nut (J, Figure 26) and turn screw (H, Figure 26) until the outfeed roller just touches the gauge block. Then tighten lock nut (J, Figure 26).
6. Check and adjust the opposite end of the outfeed roller in the same manner.

9.15 Infeed roller height

Use the exact same procedure for checking the infeed roller as you did for the outfeed roller. Use the .02" (0.5mm) feeler gauge atop the gauge block. If adjustment is necessary, use the lock nut and screw on each end of the infeed roller.

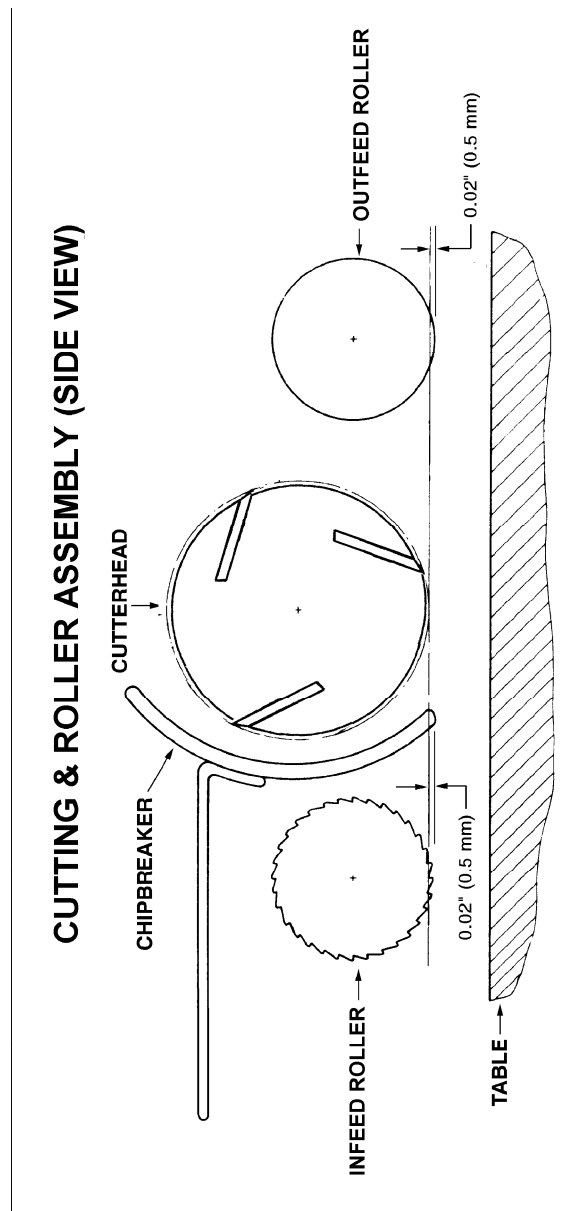


Figure 24

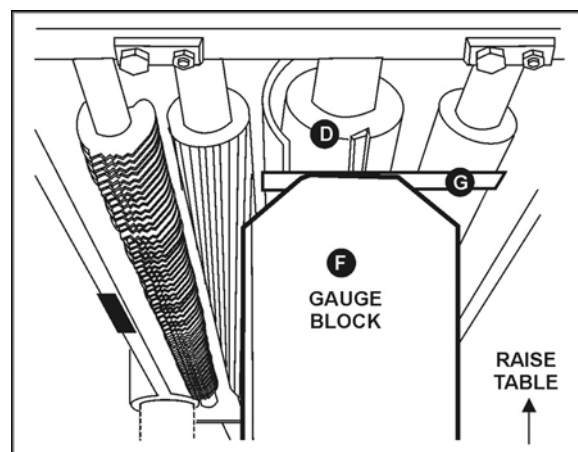


Figure 25

9.16 Chipbreaker height

The chipbreaker breaks off the larger chips before the stock reaches the cutterhead. Use the gauge block and a .02" (0.5mm) feeler gauge to check the height of the chipbreaker, following the same procedure as explained in the previous sections. If adjustment is needed:

1. Remove top cover of planer.
2. Loosen the lock nuts (A, Figure 27) at both ends of the chipbreaker, and turn the set screws (B, Figure 27) to raise or lower the chipbreaker as needed. The set screws should be turned the same amount.
3. When the chipbreaker contacts the gauge block, tighten both lock nuts (A, Figure 27).

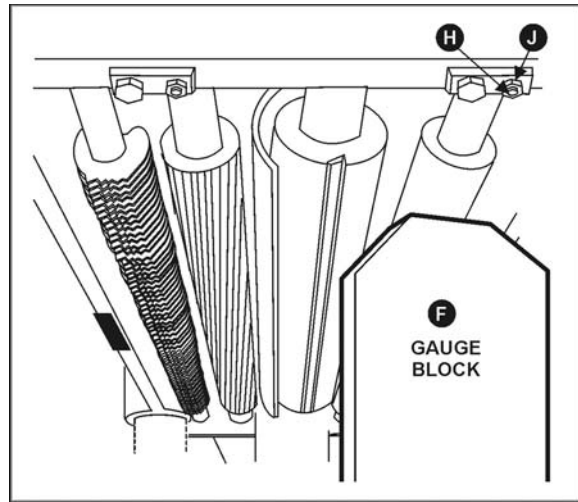


Figure 26

9.17 Chip deflector

The chip deflector (C, Figure 27) keeps wood chips from falling into the outfeed roller. The deflector should be set approximately 1/16" to 1/8" from the tip of the knives. Make sure the deflector is oriented so the bevel on its front edge matches the shape of the cutterhead.

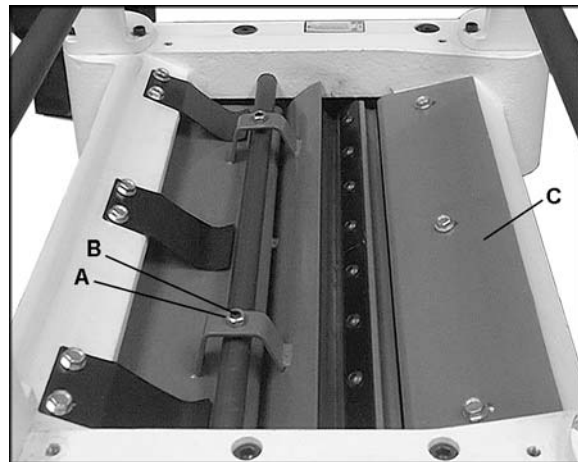


Figure 27

9.18 Feed speed control

Your machine is equipped with a spiral, serrated infeed roller and a solid steel outfeed roller. When the feed rollers are engaged, they turn to feed the stock. The feed rollers slow automatically when the machine is under heavy load for best planing in all conditions. The feed rollers are driven by chains and sprockets (see Figure 28) which take power directly from the cutterhead through the oil bath gear box. The drive chain does not need tensioning, as a tension device (Figure 28) maintains proper tension at all times.

To gain access to the chain and sprockets (for example, when performing maintenance) proceed as follows:

1. You may find it easier to remove the sprocket guard by first removing the handwheel from the machine, though this is not mandatory.
2. Remove the socket head cap screw from the center of the cover using a 6mm hex wrench. Remove the left triangular back plate (2 screws) using a 10mm wrench. See Figure 29.
3. Pull the sprocket guard off the machine.

NOTE: Always re-install cover before operating planer.

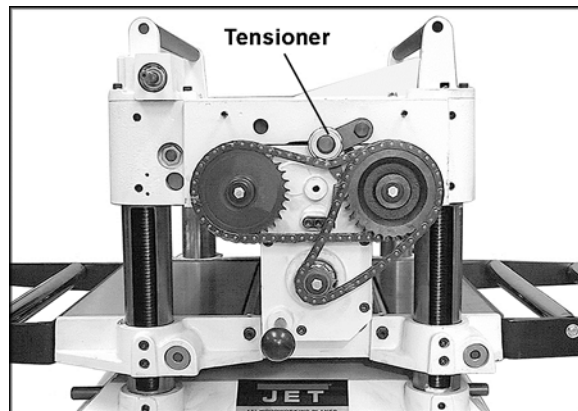


Figure 28

The gear box has two feed speeds. These are set by pulling out or pushing in the shift lever (Figure 30). Always change feed speed while the machine is running. A label showing the lever positions is affixed just above the lever. It is also shown in Figure 30.

CAUTION Do not attempt to change feed speed while stock is passing through the machine. Damage to the gearbox may result.

9.19 Stock return rollers

The two rollers on top the machine serve as a convenient rest for stock. They save time and motion for the operator as the stock is returned to the infeed side.

9.20 Depth of cut

The cutting depth scale (Figure 31) is a combination inch/metric scale, with a cutting range from 0 to 6" (152.4mm).

The distance of upward or downward movement is controlled by the handwheel. Before moving the table up or down, loosen the locking handles (Figure 31). After obtaining proper table position, tighten the locking handles.

Maximum depth of cut is 3/16". A limiter on the front of the head casting limits the depth of cut on full width planing under 1/8".

10.0 Maintenance

WARNING Before doing maintenance on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Failure to comply may cause serious injury.

Periodic inspections are required to ensure that the machine is in proper adjustment, that all screws are tight, that belts are in good condition and properly tensioned, that dust has not accumulated in the electrical enclosures, and that there are no worn or loose electrical connections.

Buildup of sawdust and other debris can cause your machine to plane inaccurately. Periodic cleaning is not only recommended but mandatory for accurate operation.

Close-fitting parts, such as the cutterhead slots and gibs, should be cleaned with a cloth or brush and non-flammable solvent, and freed from clinging foreign matter.

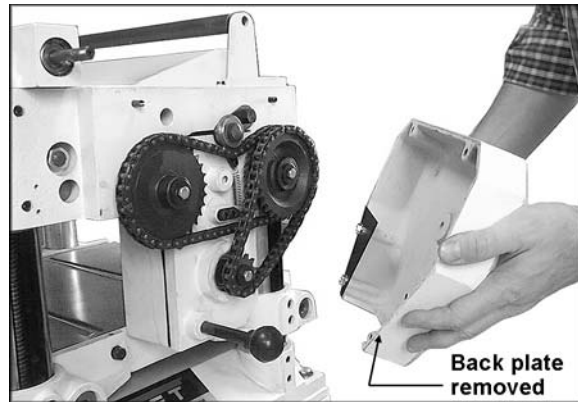


Figure 29

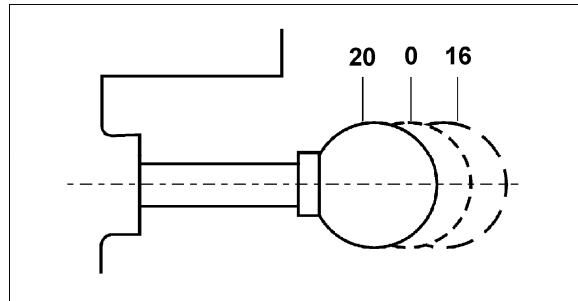


Figure 30

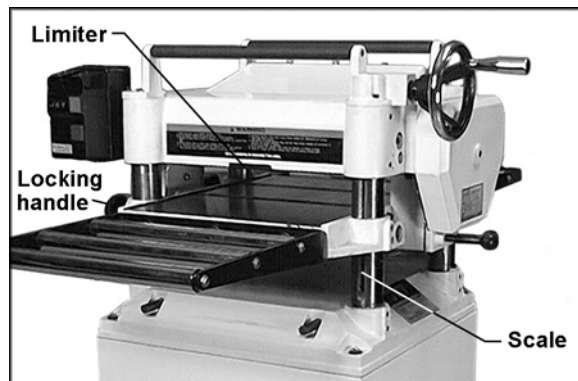


Figure 31

Remove resin and other accumulations from feed rollers and table with a soft rag and non-flammable solvent.

Periodically check all the chains for proper tension and adjust accordingly if needed.

The table should be kept clean and free of rust. Some users prefer a paste wax on exposed steel and cast iron surfaces. The wax provides a layer of protection as well as reducing friction between lumber and the table, making cuts faster and smoother. Avoid any wax that contains silicone or other synthetic ingredients. These materials can find their way into lumber and can make staining and finishing difficult.

Another option is talcum powder applied with a blackboard eraser rubbed in vigorously once a week; this will fill casting pores and form a moisture barrier. This method provides a table top that is slick and allows rust rings to be easily wiped from the surface. Important also is the fact that talcum powder will not stain wood or mar finishes as wax pickup does.

10.1 Lubrication

All ball bearings are factory lubricated and sealed for life. They require no further lubrication.

The lubricant in the gear box must be drained and replaced every 2,500 hours. Multi-purpose gear box lubricant will be suitable.

To replace the lubricant:

1. Remove the drain plug (A, Figure 32) with a 14mm wrench. Drain dirty oil thoroughly.
2. Insert and tighten the drain plug. (A, Figure 32).
3. Remove filler cap (B, Figure 32) and fill with clean lubricant through the hole. Fill until the oil reaches the top of the filler plug port for correct oil level.
4. Install and tighten filler cap (B, Figure 32).

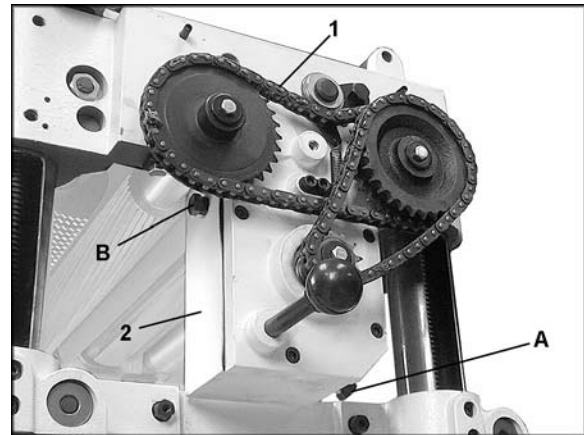


Figure 32

The item numbers on this chart are referenced to the surrounding Figures on pages 19 and 20.

No.	Position	Interval	Suitable Types of Lubricant	Fig. No.
1	Drive Chain	Inspect and lubricate monthly	Grease	32
2	Gear Box	When operated more than 2,500 hours	70 to 90 weight gear oil	32
3	Return Rollers	Inspect frequently	SAE-30	33
4	Worm Gear	Inspect and lubricate monthly	Grease	34
5	Lead Screw	Inspect and lubricate monthly	Grease	34
6	Column	Inspect and lubricate weekly	Clean columns and apply SAE-30	34
7	Table Chain	Inspect monthly, lubricate when needed	Grease, or good quality bicycle chain lubricant	35
8	Feed Rollers	Inspect and lubricate daily before startup	SAE-30	36

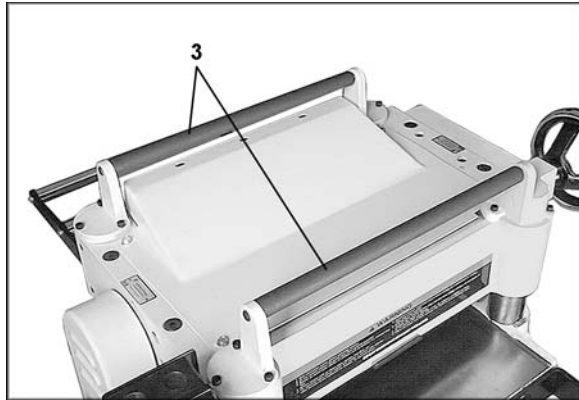


Figure 33



Figure 34

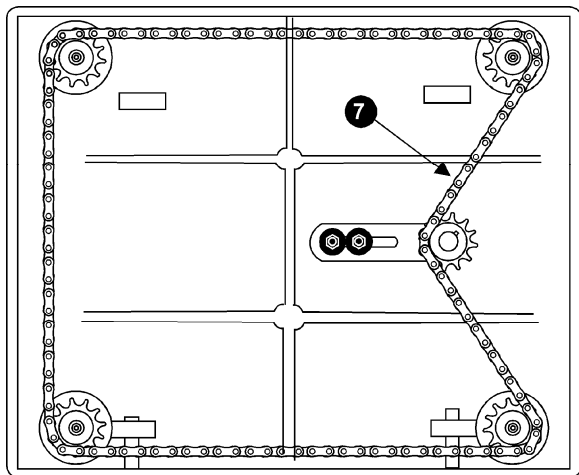


Figure 35

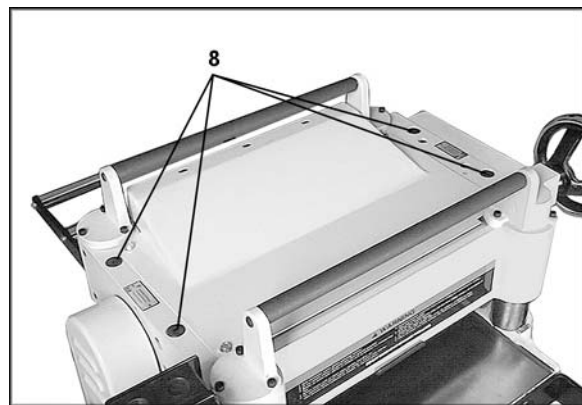


Figure 36

11.0 Troubleshooting the JWP-15DX/15HH

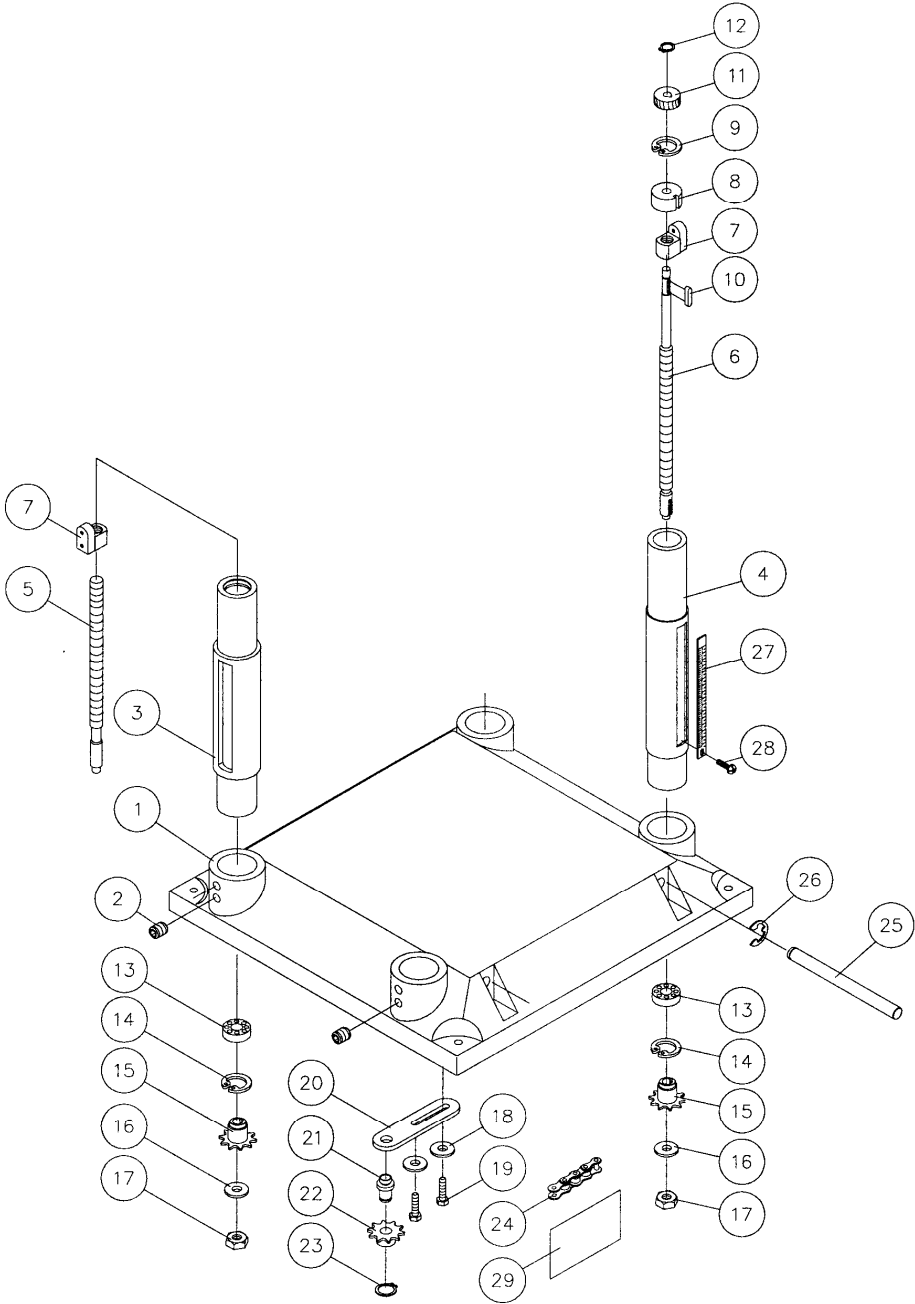
11.1 Performance problems

Trouble	Probable Cause	Remedy
Snipe. (NOTE: Snipe can be minimized until negligible, but not eliminated.)	Table rollers not set properly.	Adjust rollers to proper height.
	Inadequate support of long boards.	Support long boards with extension rollers.
	Uneven feed roller pressure front to back.	Adjust feed roller tension.
	Dull knives.	Replace knives.
	Lumber not butted properly.	Butt end to end each piece of stock as they pass through machine.
Fuzzy grain.	High moisture content in wood.	Remove moisture by drying, or use different stock.
	Dull knives.	Replace knives.
Torn grain.	Too heavy a cut.	Adjust proper depth of cut.
	Knives cutting against grain.	Cut along the grain.
	Dull knives.	Replace knives.
Rough/Raised grain.	Dull knives.	Replace knives.
	Too heavy a cut.	Adjust proper depth.
	Moisture content too high.	Remove moisture by drying, or use different stock.
Rounded, glossy surface.	Dull knives.	Replace knives.
	Feed speed too slow.	Increase speed.
	Cutting depth too shallow.	Increase depth.
Poor feeding of lumber.	Inadequate feed roller pressure.	Adjust feed roller tension. If proper tension cannot be achieved, replace feed rollers.
	Planer table rough or dirty.	Clean pitch and residue, and apply paste wax to planer table.
	V-belt is slipping.	Tighten v-belt.
	Surface of feed roller is clogged.	Clear pitch and residue out of teeth.

11.2 Mechanical and electrical problems

Trouble	Probable Cause	Remedy
Uneven depth of cut side to side.	Knives are worn.	Replace knives.
	Cutterhead not level with bed.	Level the bed.
Board thickness does not match depth of cut scale.	Depth of cut scale incorrect.	Adjust depth of cut scale.
Chain is jumping.	Inadequate tension.	Adjust chain tension.
	Sprockets misaligned.	Align sprockets.
	Sprockets worn.	Replace sprockets.
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	No incoming power.	Verify unit is connected to power.
	Overload automatic re-set has not re-set.	When the planer overloads on the circuit breaker built into the motor starter, it takes time for the machine to cool down before restart. Allow unit to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter inside the electrical box.
	Planer frequently trips.	One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to take a lighter cut. If too deep a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is correct then there is probably a loose electrical lead. Check amp setting on motor starter.
	Building circuit breaker trips or fuse blows.	Verify that planer is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter.
	Loose electrical connections.	Go through all the electrical connections on the planer including motor connections, verifying the tightness of each. Look for any signs of electrical arcing which is a sure indicator of loose connections or circuit overload.

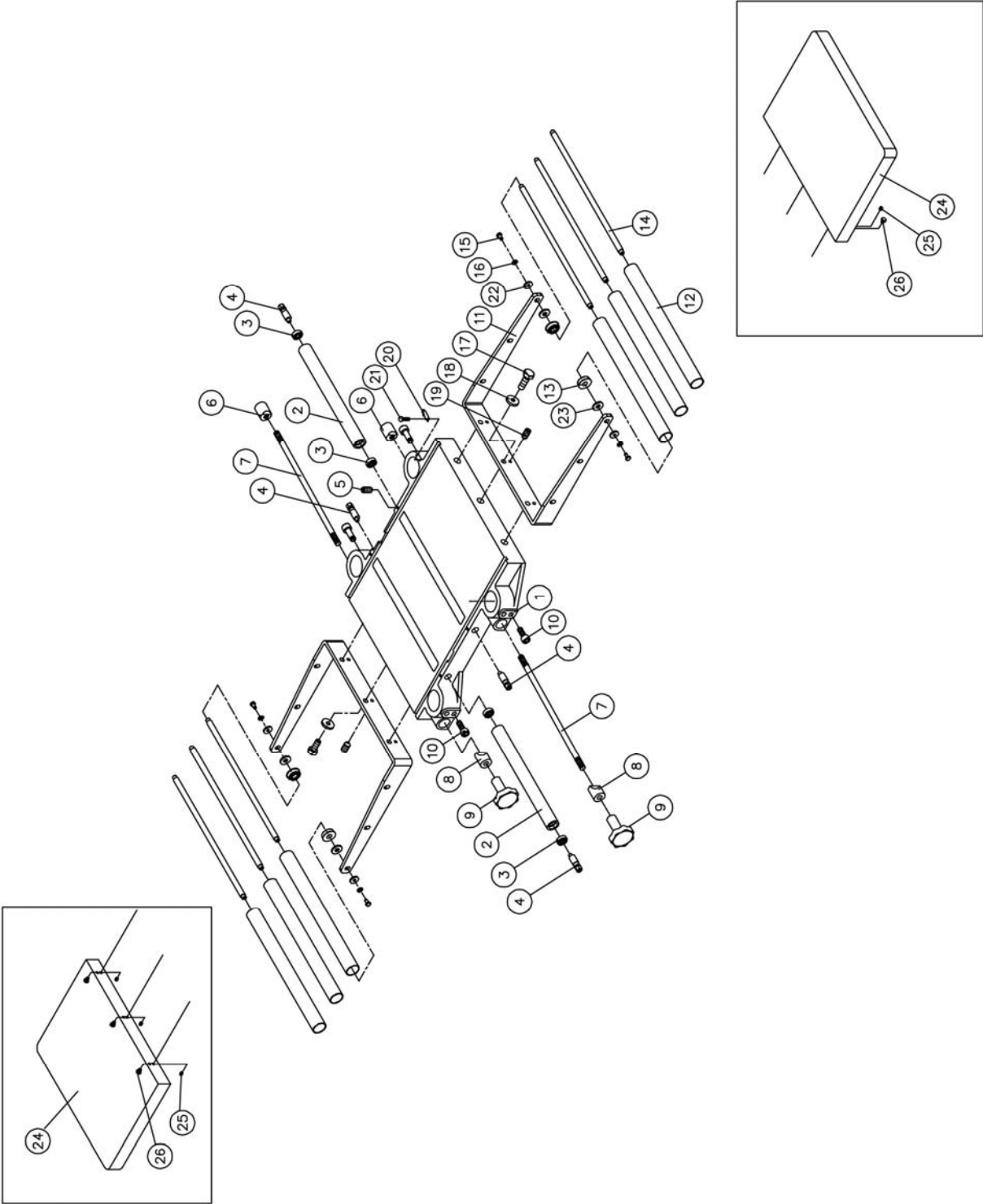
12.1.1 Base Assembly – Exploded View



12.1.2 Base Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	JWP15H-201	Base		1
2	TS-1525021	Set Screw	M10x12	8
3	JWP15H-203	Column		3
4	JWP15H-204	Column		1
5	JWP15H-205	Lead Screw		3
6	JWP15H-206	Lead Screw		1
7	JWP15H-207	Nut		4
8	JWP15H-208	Bushing		1
9	JWP15H-209	Retaining Ring	RTW-38	1
10	JWP15H-210	Key	4x4x10	1
11	JWP15H-211	Gear		1
12	JWP15H-212	Retaining Ring	STW-10	1
13	BB-6202Z	Ball Bearing	6202Z	4
14	JWP15H-214	Retaining Ring	RTW-35	4
15	JWP15H-216	Sprocket		4
16	TS-1550071	Washer	M10	4
17	TS-1540072	Nut	M10x1.25P	4
18	TS-1550061	Washer	M8	2
19	TS-1490041	Hex Cap Screw	M8x25	2
20	JWP15H-221	Bracket		1
21	JWP15H-222	Shaft		1
22	JWP15H-223	Sprocket		1
23	JWP15H-224	Retaining Ring	STW-15	1
24	JWP15H-225	Chain		1
25	JWP15H-226	Lifting Handle		4
26	JWP15H-227	E-Clip	ETW-12	4
27	JWP15H-228	Scale		1
28	TS-1531012	Screw	M3x6	1
29	PJE-B01	I.D. Label		1

12.2.1 Table Assembly – Exploded View



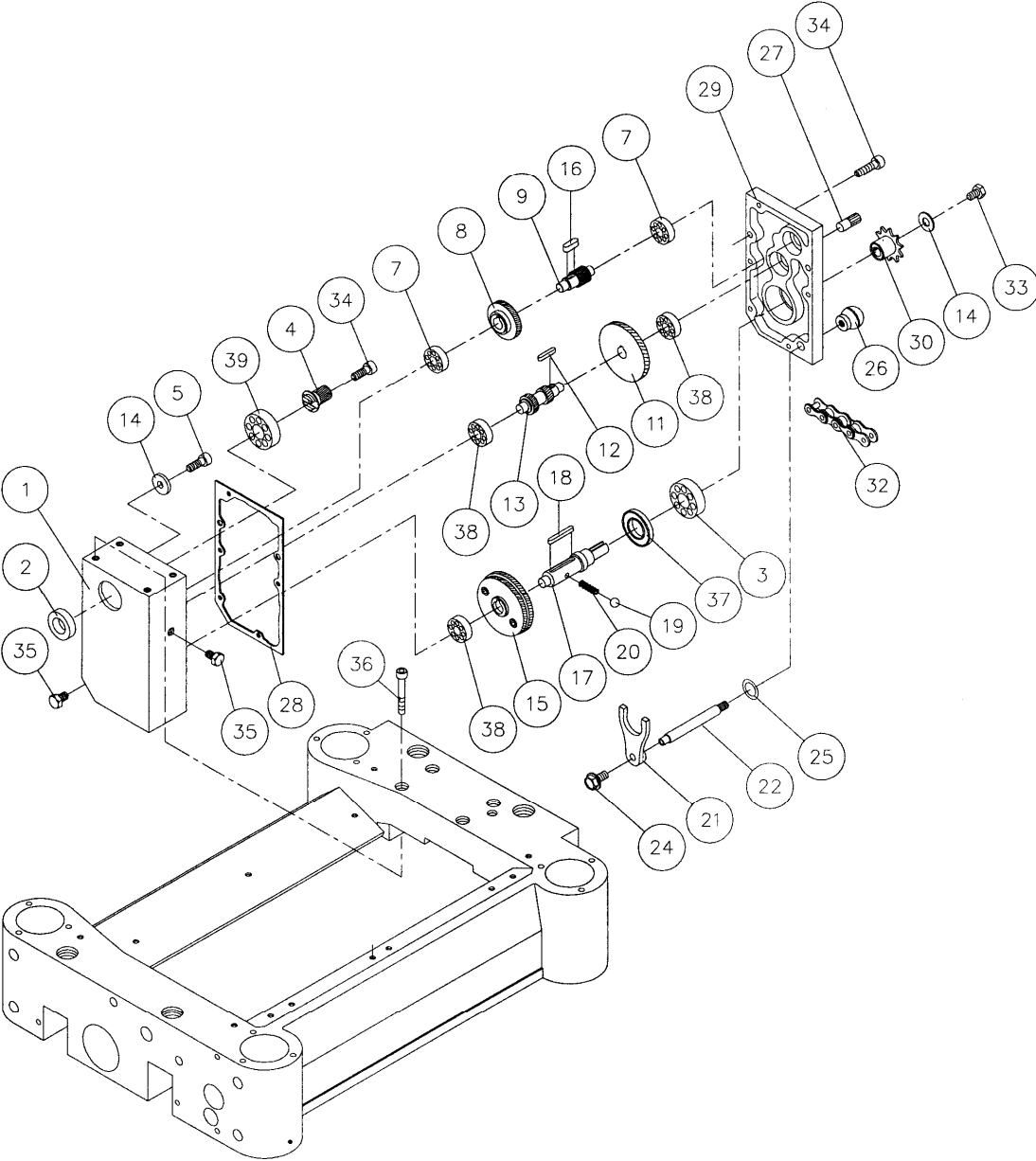
12.2.2 Table Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	JWP15H-101	Middle Table		1
2	JWP15H-102	Roller		2
3	BB-608Z	Ball Bearing	608Z	4
4	JWP15H-104	Eccentric Shaft		4
5	TS-1523041	Set Screw	M6x12	4
6	JWP15H-106	Threaded Lock Bushing		2
7	JWP15H-107	Lock Bolt		2
8	JWP15H-108	Lock Bushing		2
9	JWP15H-109	Knob		2
10	TS-1503051	Socket Head Cap Screw	M6x20	8
11	PJ020801	Roller Frame*		2
12	JWP15H-112	Roller*		6
13	JWP15H-113	Roller Bushing*		12
14	JWP15DX-114	Shaft*		6
15	TS-1482021	Hex Cap Screw*	M6x12	12
16	TS-2361061	Lock Washer*	M6	12
17	TS-1490031	Hex Cap Screw*	M8x20	6
18	TS-1550061	Washer*	M8	6
19	TS-1524031	Set Screw*	M8x12	6
20	JWP15H-230	Cut Limit Pointer		1
21	JWP15H-231	Rivet	2x5	2
22	TS-1550041	Flat Washer*	M6	12
23	TS-1550071	Flat Washer*	M10	12
24	JWP15HH-124	Extension Table**		2
25	TS-1524051	Socket Set Screw**	M8x20	6
26	TS-1490041	Hex Cap Screw**	M8x25	6

* Index #11 thru 19, 22 and 23 are used only on model JWP-15DX

** Index # 24, 25 and 26 are used only on model JWP-15HH

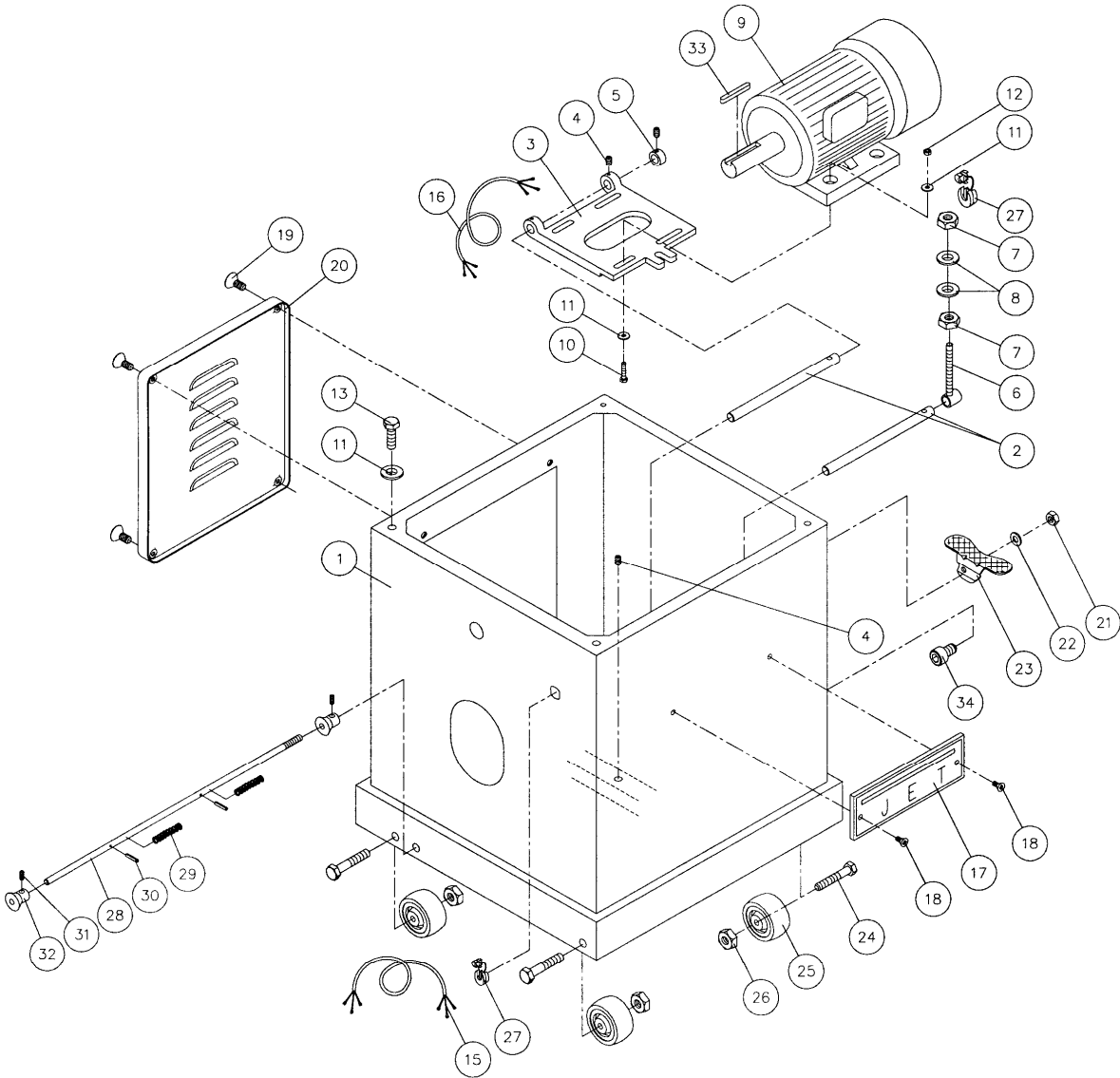
12.3.1 Gear Box Assembly – Exploded View



12.3.2 Gear Box Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	JWP15H-301	Gear Box		1
2	6284843	Oil Seal		1
3	BB-6204Z	Ball Bearing	6204Z	1
4	JWP15H-304	Gear	16T	1
5	TS-1503031	Socket Head Cap Screw	M6x12	1
7	BB-6201	Ball Bearing	6201	2
8	JWP15H-309	Gear	47T	1
9	JWP15H-310	Shaft	18T	1
11	JWP15H-312	Gear	71T	1
12	JWP15H-313	Key	5x5x10	1
13	JWP15H-314	Shaft	18T, 22T	1
14	TS-1550041	Washer	M6	2
15	JWP15H-317	Gear Assembly	96T/92T	1
16	6292768	Key	5x5x12	1
17	JWP15H-323	Shaft		1
18	JWP15H-320	Key	6x6x40	1
19	JWP15H-321	Ball		1
20	JWP15H-322	Spring		1
21	JWP15H-329	Clutch		1
22	JWP15H-330	Handle		1
24	JWP208-038A	Hex Washer Head Screw	M6x12	1
25	JWP15H-333	Oil Seal		1
26	JWP15H-334	Knob		1
27	JWP15H-335	Pin		2
28	JWP15H-336	Gasket		1
29	JWP15H-337	Cover		1
30	JWP15H-325	Sprocket	12T	1
32	JWP15H-327	Chain		1
33	TS-1482031	Hex Cap Screw	M6x16	1
34	TS-1503061	Socket Head Cap Screw	M6x25	5
35	JWP15H-339	Oil Plug		2
36	TS-1504101	Socket Head Cap Screw	M8x50	4
37	OS-25476	Oil Seal		1
38	BB-6201Z	Ball Bearing	6201Z	3
39	BB-6204ZZ	Ball Bearing	6204ZZ	1

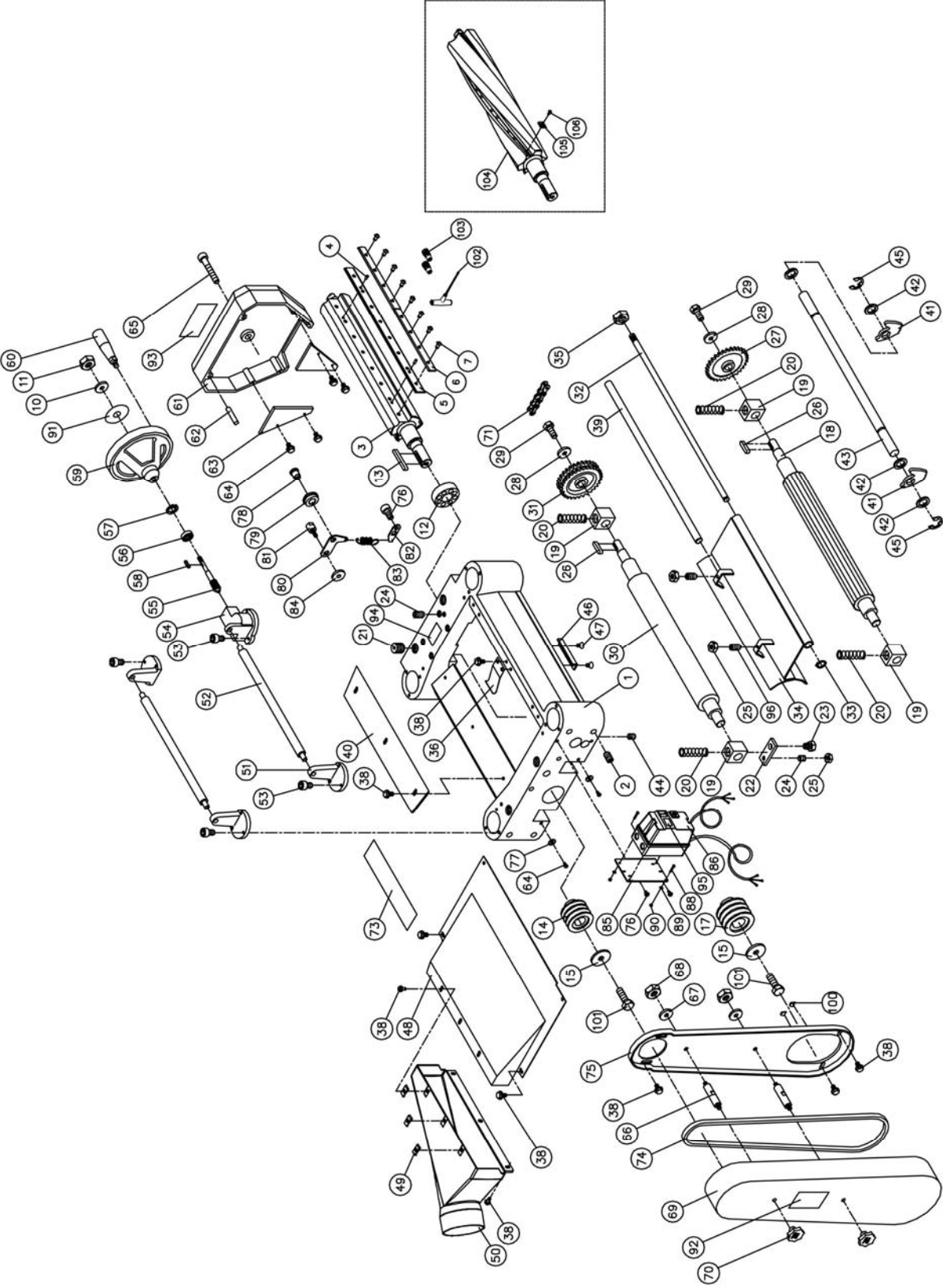
12.4.1 Stand and Motor Assembly – Exploded View



12.4.2 Stand and Motor Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	PJN-S01	Base		1
2	JWP15H-404	Support Bar		2
3	JWP15H-406	Motor Mount		1
4	TS-1523011	Set Screw	M6x6	4
5	JWP15H-408	Collar		1
6	JWP15H-409	Adjusting Bolt		1
7	TS-1540072	Nut	M10x1.25P	2
8	TS-0680061	Washer	1/2	2
9	JWP15H-412	Motor	3HP	1
10	TS-1490051	Hex Cap Screw	M8x30	4
11	TS-1550061	Washer	M8	12
12	TS-1540061	Hex Nut	M8	4
13	TS-1490081	Hex Cap Screw	M8x45	4
15	JWP15H-418	Power Cable		1
16	PAG-M02	Motor Cable		1
17	PG-M02	Jet Plaque		1
18	TS-2245081	Flat Head Screw	M5x8	2
19	TS-2286201	Flat Head Screw	M6x20	4
20	PJH-S02	Door		1
21	TS-1540071	Hex Nut	M10	1
22	TS-1550071	Flat Washer	M10	1
23	PJN-S02	Foot Brake		1
24	TS-0060111	Hex Cap Screw	3/8-16x2-1/2	4
25	PG-M05	Wheel		4
26	TS-0561031	Hex Nut	3/8-16	4
27	5MA-L05	Strain Relief Bushing		2
28	PJN-S03	Shaft		1
29	PG010033	Spring		2
30	HG010911	Spring Pin	4x20	2
31	TS-1523011	Set Screw	M6x6	2
32	PJN-S04	Eccentric Cam		2
33	5FK-C13A	Key	5x5x30	1
34	TS-1503031	Socket Head Cap Screw	M6x12	1

12.5.1 Head Assembly – Exploded View



12.5.2 Head Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	JWP15H-001	Head Casting		1
2	TS-1525021	Set Screw	M10x12	8
	JWP15DX-CA	Cutter Head Assembly (Index #3 thru #7)*		1
3	JWP15DX-003	Cutter Head*		1
4	JWP15DX-004	Pin*		6
5	708817	Knives (Set of 3)*		1
6	JWP15DX-006	Knife Bar*		6
7	TS-2246122	Button Head Socket Screw*	M6x12	24
10	TS-1550071	Washer	M10	1
11	TS-1540072	Hex Nut	M10x1.25P	1
12	BB-6205ZZ	Ball Bearing	6205ZZ	1
13	JWP15DX-013	Key	8x8x36	1
14	JWP15H-014	Machine Pulley		1
15	JWP15H-015	Washer		2
17	JWP15H-017	Motor Pulley		1
18	JWP15H-018	Infeed Roller		1
19	JWP15H-019	Bushing		4
20	JWP15H-020	Spring		4
21	JWP15H-021	Set Screw	M22x1.5Px20	4
22	JWP15H-022	Plate		4
23	TS-1490031	Hex Cap Screw	M8x20	4
24	TS-1523051	Set Screw	M6x16	5
25	TS-1540041	Nut	M6	6
26	JWP15H-026	Key	5x5x22	2
27	JWP15H-027	Sprocket		1
28	TS-0680021	Washer	1/4	2
29	TS-1482031	Hex Cap Screw	M6x16	2
30	JWP15H-030	Outfeed Roller		1
31	JWP15H-031	Sprocket		1
32	JWP15H-032	Locking Bolt		1
33	JWP15H-033	Retaining Ring	STW-12	1
34	JWP15H-034	Chipbreaker		1
35	TS-1540081	Hex Nut	M12	1
36	JWP15H-036	Plate Spring		3
38	JWP208-038A	Hex Washer Head Screw	M6x12	23
39	JWP15H-039	Shaft		1
40	JWP15H-040	Deflector Plate		1
41	JWP15H-041	Anti-Kickback Finger		39
42	JWP15H-042	Collar		40
43	JWP15H-043	Shaft		1
44	TS-1524031	Set Screw	M8x12	1
45	JWP15H-045	Retaining Ring	ETW-15	2
46	JWP15H-046	Limit Plate		1
47	JWP208-053A	Flat Head Screw	M5x8	2
48	JWP15H-048	Upper Cover		1
	JWP15DX-CHA	Collector Hood Assembly (Index #49, #50)		1
49	JWP15DX-049	Plate		3
50	JWP15DX-050	Collector Hood		1
51	JWP15H-051	Roller Stand		3
52	JWP15H-052	Roller		2
53	TS-1503051	Socket Head Cap Screw	M6x20	12
54	JWP15H-054	Worm Gear Box		1
55	JWP15H-055	Worm		1
56	BB-6200Z	Ball Bearing	6200Z	1
57	JWP15H-057	Retaining Ring	RTW-30	1

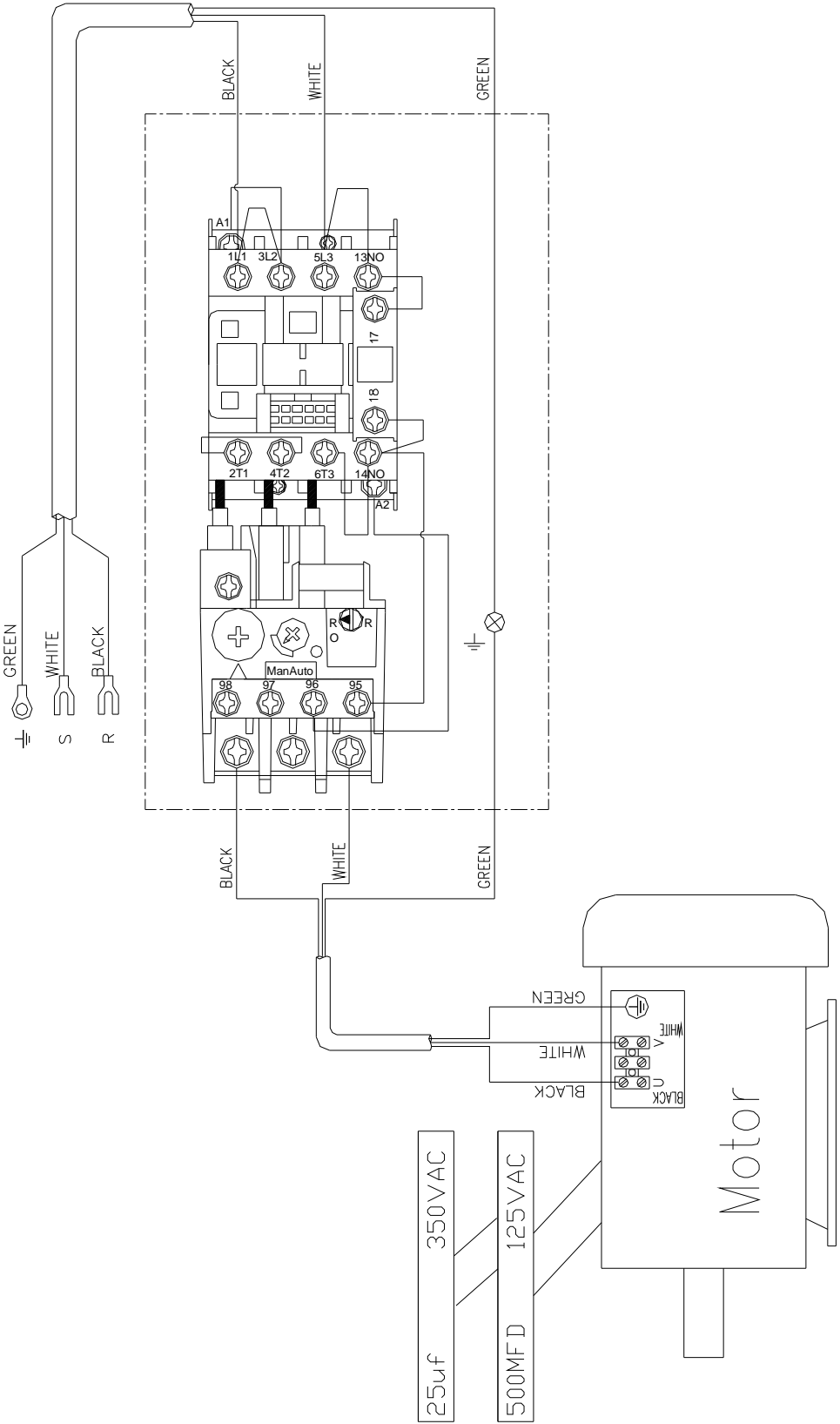
* Index # 3, 4, 5, 6 and 7 are used only on straight cutterhead, model JWP-15DX

58	JWP15H-058	Key	4x4x10	1
59	JWP15H-059	Hand Wheel		1
60	JWP15H-060	Handle		1
61	JWP15H-061	Cover		1
62	JWP15H-062	Spring Pin		2
63	PF-C22	Plate		2
64	TS-1482021	Hex Cap Screw	M6x12	8
65	TS-1504091	Socket Head Cap Screw	M8x45	1
66	JWP15H-067	Bolt		2
67	TS-0680031	Washer	5/16	2
68	TS-0561021	Hex Nut	5/16-18	2
69	JWP208-084	Pulley Cover		1
70	JWP15H-072	Knob		2
71	JWP15H-073	Chain		1
73	PG-C05	Label		1
74	VB-M59	V-Belt	M-59	3
75	JWP208-079	Pulley Guard		1
76	TS-1503021	Socket Head Cap Screw	M6x10	4
77	PF-C26	Washer		4
78	PA-C56	Stud		1
79	PA-C57	Idle Pulley		1
80	PA-C58	Bracket		1
81	PA-C59	Stud		1
82	PA-C60	Hanger		1
83	PA-C61	Spring		1
84	PA-C62	Washer		1
85	JWP15H-076A	Switch Bracket		1
86	JWP15H-077A	Switch		1
88	TS-081C102	Screw	#10-24X1-3/4	2
89	JWP15H-079	Tooth Washer		2
90	TS-0560071	Hex Nut	#10-24	2
91	PF-C27	Direction Indicator Label		1
92	PA-C67	Label		1
93	PA-G18-1	Label		1
94	PA-C66	Label		1
95	PJE-C04	Label		1
96	TS-1523041	Set Screw	M6x12	2
100	JWP15DX-100	Pad		2
101	TS-1490041	Hex Cap Screw	M8x25	2
102	JWP15DX-102	T-Handle Wrench*		1
103	JWP13DX-079	Magnet Tool Assembly*		2
	1791223	Helical Cutterhead Assembly (index #104 through #106)**		1
104	JWP15HH-104	Helical Cutterhead **		1
105	1791212	Knife Insert (sold in set of 10)**		68 total
106	JWP208HH-111	Knife Insert Screw**	#10-32x1/2"	68
107	JJ6HH-113	Star Point Screwdriver (not shown)**		2

* Index #102 and 103 are used only on straight cutterhead, model JWP-15DX

** Index #104 thru 107 are used only on helical cutterhead, model JWP-15HH

13.0 Electrical Connections





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