MODEL ST1006/ST1011
8" JOINTER
OWNER'S MANUAL
(For Models Manufactured since 03/16)
WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures 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 those dust masks that are specially designed to filter out microscopic particles.

Woodstock International, Inc. is committed to customer satisfaction. Our intent with this manual is to include the basic information for safety, setup, operation, maintenance, and service of this product.

We stand behind our machines! In the event that questions arise about your machine, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: tech-support@shopfox.biz. Our knowledgeable staff will help you troubleshoot problems and process warranty claims.

If you have comments about this manual, please contact us at:

Woodstock International, Inc.
Attn: Technical Documentation Manager
P.O. Box 2309
Bellingham, WA 98227
manuals@woodstockint.com
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INTRODUCTION

Contact Info

We are committed to customer satisfaction. If you have any questions or need help, use the information below to contact us.

IMPORTANT: Before contacting, please get the original purchase receipt, serial number, and manufacture date of your machine. This information is required for all Technical Support calls and it will help us help you faster.

Woodstock International Technical Support
Phone: (360) 734-3482
Email: techsupport@woodstockint.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Technical Documentation Manager
P.O. Box 2309
Bellingham, WA 98227
Email: manuals@woodstockint.com

Manual Accuracy

We are proud to provide a high-quality owner’s manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs contained inside. Sometimes we make mistakes, but our policy of continuous improvement also means that sometimes the machine you receive will be slightly different than what is shown in the manual.

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, check our website for an updated version. We post current manuals and manual updates for free on our website at www.woodstockint.com.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the Manufacture Date and Serial Number from the machine ID label (see below). Also, if available, have a copy of your original purchase receipt on hand. This information is required for all Tech Support calls.

Machine Descriptions

Following are the differences between the models covered in this manual:

- Model ST1006 = 8”, 3 HP, with 3-Knife Cutterhead
- Model ST1011 = 8”, 3 HP, with Helical Cutterhead
### MACHINE SPECIFICATIONS

#### MODEL ST1006
**8" JOINTER WITH ADJUSTABLE BEDS**

#### Product Dimensions:
- **Weight**: 510 lbs.
- **Length x Width x Height**: 76-1/2 x 23-1/2 x 33 in.
- **Footprint (Length x Width)**: 44-1/2 x 16-1/2 in.

#### Shipping Dimensions:

<table>
<thead>
<tr>
<th>Carton #1</th>
<th>Carton #2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Type</strong></td>
<td>Wood Crate, 388 lbs.</td>
</tr>
<tr>
<td><strong>Content</strong></td>
<td>Machine, 157 lbs.</td>
</tr>
<tr>
<td><strong>Weight</strong></td>
<td></td>
</tr>
<tr>
<td><strong>Length x Width x Height</strong></td>
<td>81 x 24 x 11 in.</td>
</tr>
<tr>
<td><strong>Weight</strong></td>
<td>157 lbs.</td>
</tr>
<tr>
<td><strong>Length x Width x Height</strong></td>
<td>38 x 20 x 28 in.</td>
</tr>
</tbody>
</table>

#### Electrical:
- **Power Requirement**: 240V, Single-Phase, 60 Hz
- **Prewired Voltage**: 240V
- **Full-Load Current Rating**: 15A
- **Minimum Circuit Size**: 20A
- **Connection Type**: Cord & Plug
- **Power Cord Included**: Yes
- **Power Cord Length**: 6 ft.
- **Power Cord Gauge**: 12 AWG
- **Plug Included**: Yes
- **Included Plug Type**: 6-20
- **Switch Type**: Magnetic Switch w/Overload Protection

#### Motor:
- **Type**: TEFC Capacitor-Start Induction
- **Horsepower**: 3 HP
- **Phase**: Single-Phase
- **Amps**: 15A
- **Speed**: 3450 RPM
- **Power Transfer**: Belt Drive
- **Bearings**: Sealed & Permanently Lubricated
### Main Specifications:

#### Operation
- **Bevel Jointing**: 0 – 45 deg. L/R
- **Maximum Width of Cut**: 8 in.
- **Maximum Depth of Cut**: 1/8 in.
- **Minimum Workpiece Length**: 10 in.
- **Minimum Workpiece Thickness**: 1/2 in.
- **Maximum Rabbeting Depth**: 5/8 in.
- **Number of Cuts Per Minute**: 21,400

#### Fence Information
- **Fence Length**: 35 in.
- **Fence Width**: 1-1/4 in.
- **Fence Height**: 5 in.
- **Fence Stops**: 45, 90, 135 deg.

#### Cutterhead Information
- **Cutterhead Type**: 4 Knife
- **Cutterhead Diameter**: 3-3/16 in.
- **Cutterhead Speed**: 4800 RPM

#### Knife Information
- **Number of Knives**: 4
- **Knife Type**: HSS, Single-Sided
- **Knife Length**: 8 in.
- **Knife Width**: 3/4 in.
- **Knife Thickness**: 1/8 in.
- **Knife Adjustment**: Jack Screws or Springs

#### Table Information
- **Table Length**: 76-5/16 in.
- **Table Width**: 8 in.
- **Table Thickness**: 1-1/2 in.
- **Floor-to-Table Height**: 32-5/8 in.
- **Table Adjustment Type**: Lever Action
- **Table Movement Type**: Parallelogram

#### Construction
- **Body Assembly**: Cast Iron
- **Cabinet**: Pre-Formed Steel
- **Fence Assembly**: Cast Iron
- **Guard**: Die Cast Metal
- **Table**: Precision-Ground Cast Iron
- **Paint Type/Finish**: Powder Coated

#### Other Information
- **Number of Dust Ports**: 1
- **Dust Port Size**: 4 in.
**MACHINE SPECIFICATIONS**

**MODEL ST1011**

**8” JOINTER WITH MOBILE BASE**

**Product Dimensions:**
- **Weight:** 508 lbs.
- **Length x Width x Height:** 76-1/2 x 23-1/2 x 33 in.
- **Footprint (Length x Width):** 44-1/2 x 16-1/2 in.

**Shipping Dimensions:**
- **Carton #1**
  - **Type:*** Wood Crate
  - **Content:** Machine
  - **Weight:** 388 lbs.
  - **Length x Width x Height:** 81 x 24 x 11 in.

- **Carton #2**
  - **Type:** Cardboard Box
  - **Content:** Stand
  - **Weight:** 157 lbs.
  - **Length x Width x Height:** 38 x 20 x 28 in.

**Electrical:**
- **Power Requirement:** 240V, Single-Phase, 60 Hz
- **Full-Load Current Rating:** 15A
- **Minimum Circuit Size:** 20A
- **Connection Type:** Cord & Plug
- **Power Cord Included:** Yes
- **Power Cord Length:** 6 ft.
- **Power Cord Gauge:** 12 AWG
- **Plug Included:** Yes
- **Included Plug Type:** 6-20
- **Switch Type:** ON/OFF Push Button Switch w/Large Shut-Off Paddle

**Motor:**
- **Type:** TEFC Capacitor-Start Induction
- **Horsepower:** 3 HP
- **Phase:** Single-Phase
- **Amps:** 15A
- **Speed:** 3450 RPM
- **Power Transfer:** Belt Drive
- **Bearings:** Sealed & Permanently Lubricated
Main Specifications:

**Operation**
- Bevel Jointing: 0 – 45 deg. L/R
- Maximum Width of Cut: 8 in.
- Maximum Depth of Cut: 1/8 in.
- Minimum Workpiece Length: 10 in.
- Minimum Workpiece Thickness: 1/2 in.
- Number of Cuts Per Minute: 21,400

**Fence Information**
- Fence Length: 36 in.
- Fence Width: 1-1/4 in.
- Fence Height: 5 in.
- Fence Stops: 45, 90, 135 deg.

**Cutterhead Information**
- Cutterhead Type: Spiral
- Cutterhead Diameter: 3-3/8 in.
- Number of Cutter Spirals: 4
- Number of Indexable Cutters: 40
- Cutterhead Speed: 5350 RPM

**Cutter Insert Information**
- Cutter Insert Type: Curved Indexable Carbide
- Cutter Insert Length: 15 mm
- Cutter Insert Width: 15 mm
- Cutter Insert Thickness: 2.5 mm

**Table Information**
- Table Length: 76-3/8 in.
- Table Width: 8 in.
- Table Thickness: 1-1/2 in.
- Floor-to-Table Height: 32-5/8 in.
- Table Adjustment Type: Lever-Action
- Table Movement Type: Parallelogram

**Construction**
- Body Assembly: Cast Iron
- Cabinet: Pre-Formed Steel
- Fence Assembly: Cast Iron
- Guard: Die Cast Metal
- Table: Precision-Ground Cast Iron
- Paint Type/Finish: Powder Coated

**Other Information**
- Number of Dust Ports: 1
- Dust Port Size: 4 in.
- Mobile Base: Built-In
Machine Features

The instructions in this manual will be easier to understand if you become familiar with the location and names of the basic features of your new machine. Use the list below with the letters in Figure 1 and Figure 2 to identify the 8" jointer feature locations.

Figure 1. Front view of machine.

A. Outfeed Table  
B. Fence  
C. Cutterhead Guard  
D. Control Panel  
E. Infeed Table  
F. Infeed Table Adjustment Lever  
G. Cutting Depth Scale  
H. Infeed Table Lock  
I. Mobile Base Lock Pedal  
J. Outfeed Table Lock  
K. Dust Port  
L. Outfeed Table Adjustment Lever  
M. Fence Tilt Handle  
N. Fence Tilt Lock  
O. Outfeed Table Positive Stops  
P. Fence Lock  
Q. Belt Guard  
R. Infeed Table Positive Stops

Figure 2. Back view of machine.

WARNING
To reduce your risk of serious injury, read this entire manual BEFORE using machine.
Controls & Components

This section covers the basic controls used during routine operations.

STOP Button: Stops motor when pushed in and disables the START button. Enable the START button by twisting the STOP button until it springs forward in the out position.

START Button: Starts motor only if the STOP button is in the out position (see Figure 3).

Table Movement: To move the infeed table, loosen the table lock (see Figure 4), move the table with the table lever, then tighten the table lock. The infeed table will only move through the preset range of the positive stops. To adjust the infeed table positive stops, refer to Setting Infeed Table Height on Page 47.

Fence Movement: The fence has a lock handle that keeps it in position (see Figure 5). To move the fence, loosen the lock handle and slide the fence where needed.

Fence Tilting: The tilt lock (see Figure 5) secures the fence at any position in the available range. The plunger locks into an indexing ring to easily set the fence tilt to 90°. Positive stops stop the fence at 45° inward and 45° outward, for common 45° bevel cuts. Even when the fence is resting against the positive stops, the tilt lock must be tightened before cutting.

The outfeed table is preset with positive stops, so no range of movement is allowed (if it gets accidentally unlocked it will not move). To adjust the outfeed table positive stops refer to Setting Outfeed Table Height on Page 46.

Figure 3. START/STOP button locations.

Figure 4. Table control locations.

Figure 5. Fence lock, tilt lock and stop block locations.
SAFETY
For Your Own Safety, Read Instruction Manual
Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

- **DANGER** Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.
- **WARNING** Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.
- **CAUTION** Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.
- **NOTICE** This symbol is used to alert the user to useful information about proper operation of the machine.

**SAFETY INSTRUCTIONS FOR MACHINERY**

**OWNER’S MANUAL.** Read and understand this owner’s manual BEFORE using machine.

**TRAINED OPERATORS ONLY.** Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

**MENTAL ALERTNESS REQUIRED.** Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

**ELECTRICAL EQUIPMENT INJURY RISKS.** You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

**DISCONNECT POWER FIRST.** Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner’s manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine OFF and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.
Additional Safety for Jointers

WARNING

Serious cuts, amputation, entanglement, or death can occur from contact with rotating cutterhead or other moving components! Flying chips can cause blindness or eye injuries. Workpieces or inserts/knives thrown by cutterhead can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

KICKBACK. Occurs when workpiece is ejected from machine at a high rate of speed. To reduce the risk of kickback-related injuries, use quality workpieces, safe feeding techniques, and proper machine setup or maintenance.

GUARD REMOVAL. Operating jointer without guard exposes operator to knives/inserts. Except when rab-beting, never remove guards for regular operations or while connected to power. Turn jointer OFF and disconnect power before clearing any shavings or sawdust from around cutterhead. After rabbeting or maintenance is complete, immediately replace all guards and ensure they are properly adjusted before resuming regular operations.

DULL/DAMAGED KNIVES/INSERTS. Dull knives/inserts can increase risk of kickback and cause poor workpiece finish. Only use sharp, undamaged knives/inserts.

OUTFEED TABLE ALIGNMENT. Setting outfeed table too high can cause workpiece to hit table and get stuck, increasing risk of kickback. Setting outfeed table too low may cause workpiece to become tapered from front to back. Always keep outfeed table even with knives/inserts at top dead center (highest point during rotation).

INSPECTING STOCK. Impact injuries or fire may result from using poor workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Workpieces with minor warping should be surface planed first with cupped side facing infeed table.

GRAIN DIRECTION. Jointing against the grain or end grain can increase the risk of kickback. It also requires more cutting force, which produces chatter or excessive chip out. Always joint or surface plane WITH the grain.

MAXIMUM CUTTING DEPTH. To reduce risk of kickback, never cut deeper than 1/8” per pass.

CUTTING LIMITATIONS. Cutting a workpiece that does not meet the minimum dimension requirements can result in breakup, kickback, or accidental contact with cutterhead during operation. Never perform jointing, planing, or rabbeting cuts on pieces smaller than 8” long, 3/4” wide, or 1/4” thick.

PUSH BLOCKS. Not using push blocks when surface planing may result in accidental cutterhead contact. Always use push blocks when planing materials less than 3” high or wide. Never pass your hands directly over cutterhead without a push block.

WORKPIECE SUPPORT. Loss of workpiece control while feeding can increase risk of kickback or accidental contact with cutterhead. Support workpiece continuously during operation. Position and guide workpiece with fence. Support long or wide stock with auxiliary stands.

FEED WORKPIECE PROPERLY. Kickback or accidental cutterhead contact may result if workpiece is fed into cutterhead the wrong way. Allow cutterhead to reach full speed before feeding. Never start jointer with workpiece touching cutterhead. Always feed workpiece from infeed side to outfeed side without stopping until cut is complete. Never back work toward infeed table.

SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than 1/8” (0.125”) from cutterhead body.
Circuit Requirements

**WARNING**
Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

This machine must be connected to the correct size and type of power supply circuit, or fire or electrical damage may occur. Read through this section to determine if an adequate power supply circuit is available. If a correct circuit is not available, an electrician or qualified service personnel MUST install one before you can connect the machine to power.

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

**WARNING**
Incorrectly wiring or grounding this machine can cause electrocution, fire, or machine damage. To reduce this risk, only an electrician or qualified service personnel should do any required electrical work on this machine.

Full-Load Current Rating
The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

ST1006/ST1011
Full-Load Current Rating....................... 15 Amps

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

**ST1006/ST1011 Circuit Requirements**
- Nominal Voltage.............................................. 240V
- Cycle ............................................................... 60 Hz
- Phase ................................................. Single-Phase
- Power Supply Circuit.................................20 Amps
- Plug/Receptacle............................................NEMA 6-20

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**NOTICE**
The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.
Grounding Requirements

This machine MUST be grounded. In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current to travel—in order to reduce the risk of electric shock.

Improper connection of the equipment-grounding wire will increase the risk of electric shock. The wire with green insulation (with/without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

![Grounded 6-20 Receptacle](image.png)

**Figure 6.** Typical 6-20 plug and receptacle.

**CAUTION**

No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

Extension Cords

We do not recommend using an extension cord with this machine. Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases with longer extension cords and smaller gauge sizes (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size .......................... 12 AWG
Maximum Length (Shorter is Better) ......... 50 ft.

**WARNING**

The machine must be properly set up before it is safe to operate. DO NOT connect this machine to the power source until instructed to do later in this manual.
Unpacking

The Model ST1006/ST1011 was carefully packed when it left our warehouse. If you discover your machine is damaged immediately call your dealer.

Save the containers and all packing materials for possible inspection by the carrier or its agent. Otherwise, filing a freight claim can be difficult.

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

⚠️ WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Straightedges</td>
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</tr>
<tr>
<td>Additional People</td>
<td>4</td>
</tr>
<tr>
<td>Phillips Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 17mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 14mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 13mm</td>
<td>1</td>
</tr>
<tr>
<td>Dust Collection System</td>
<td>1</td>
</tr>
<tr>
<td>Dust Hose 4&quot;</td>
<td>1</td>
</tr>
</tbody>
</table>

⚠️ WARNING

READ and understand this entire instruction manual before using this machine. Serious personal injury may occur if safety and operational information is not understood and followed. DO NOT risk your safety by not reading!

⚠️ WARNING

UNPLUG power cord before you do any assembly or adjustment tasks! Otherwise, serious personal injury to you or others may occur!
Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

Note: If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Wood Crate (Figure 7) QTY
A. Jointer Assembly.................................................. 1
B. Carriage ............................................................. 1
C. Fence ..................................................................... 1
D. Push Blocks ......................................................... 1
E. Extension Table...................................................... 1
F. Cutterhead Guard................................................... 1
G. Hex Wrenches 2.5, 4, 5, 6, 8mm............................... 1 Ea.
H. Handle .................................................................... 1
I. Fence Tilt Lever....................................................... 1
J. Open-End Wrench 8/10, 12/14mm............................ 1 Ea.
K. Knife Setting Jig (Not Shown) (ST1006) .................. 1
K. Indexable Carbide Inserts (Not Shown) (ST1011)........... 1

Cardboard Box (Figure 8) QTY
L. Stand Assembly w/Motor ........................................ 1
M. Pedestal Switch .................................................... 1
N. Caster Wheel Assembly ........................................... 1
O. Belt Guard ............................................................ 1
P. Dust Port .................................................................. 1
Q. V-Belt ..................................................................... 1

If any parts are missing, find the part number in the back of this manual and contact Woodstock International, Inc. at (360) 734-3482 or at techsupport@woodstockint.com.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Hardware (See Hardware Recognition Chart)
• Hex Bolts M8-1.25 x 50 (Wheel/Stand).................... 1
• Hex Bolts M10-1.5 x 55 (Wheel/Stand).................... 1
• Flat Washer 8mm (Wheel/Stand)............................... 2
• Flat Washers 10mm (Wheel/Stand, Carriage, Pedestal) .... 6
• Hex Nuts M10-1.5 (Wheel/Stand).............................. 6
• Cap Screws M8-1.25 x 25 (Jointer/Stand) ............... 2
• Cap Screws M10-1.5 x 30 (Carriage)...................... 2
• Flange Bolts M6-1 x 10 (Belt Guard)...................... 2
• Hex Nuts M6-1 (Belt Guard) .................................... 2
• Flat Washers 6mm (Belt Guard) ............................... 2
• Cap Screws M6-1 x 20 (Extension Table) ............... 2
• Cap Screws M10-1.5 x 30 (Carriage)...................... 2
• Cap Screws M8-1.25 x 30 (Fence) ......................... 2
• Cap Screws M10-1.5 x 25 (Pedestal)...................... 2
• Lock Washers 10mm (Pedestal) ............................. 2
• Phillips Screws M5-.8 x 16 (Dust Port) ................. 4
• Flat Washers 5mm (Dust Port) .............................. 4

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

Note: If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.
Hardware Recognition Chart

Use this chart to identify hardware during the inventory/assembly process.

Lines are 1\(\frac{1}{16}\) inch apart.

Washers are measured by the inside diameter.

Washers are 5\(\frac{1}{8}\), 9\(\frac{1}{16}\), and 1\(\frac{1}{2}\) inch.

Lines are 1 mm apart.

Hardware includes:
- Cap Screw
- Carriage Bolt
- Flange Bolt
- Button Head Screw
- Phillips Head Screw
- Hex Bolt
- Flat Head Screw
- Tap Screw
- Set Screw
- Wing Nut
- External Retaining Ring
- Internal Retaining Ring
- E-Clip
- Lock Nut
- Hex Wrench
- Key
- Flat Washer
- Lock Washer
- Hex Nut
Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine’s unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer’s instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat Steps 2–3 as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

WARNING
Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

CAUTION
Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE
Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.
Site Considerations

Weight Load
Refer to the Machine Specifications for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation
Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/COVERS as required by the maintenance and service described in this manual. See below for required space allocation.

Physical Environment
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation
Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

CAUTION
Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Figure 9. Working clearances.
Assembly

To assemble jointer:

1. Carefully lay the stand on its side.

2. Use (1) M8-1.25 x 50 hex bolt and (1) 8mm flat washer to bolt the wheel assembly to the stand, as shown in Figure 10.

![Figure 10. Bolting wheel assembly to stand.](image)

3. Use (2) M10-1.5 x 55 hex bolts, (2) 10mm flat washers, and (2) M10-1.5 hex nuts to further secure the wheel assembly to the stand, as shown in Figure 11.

![Figure 11. Securing wheel assembly to stand.](image)

4. Turn the stand rightside up and remove the back cover.

5. With assistance, lift the jointer onto the stand and align the mounting holes.

6. Use (8) M8-1.25 x 25 cap screws and (8) 8mm lock washers to secure the jointer to the stand, as shown in Figure 12.

![Figure 12. Securing the jointer to stand.](image)

7. Loosen motor bracket bolts shown in Figure 13.

![Figure 13. Motor bracket bolts (black arrows) and motor mount bolts (white arrows).](image)
8. Put the V-belt on motor pulley, then roll it onto the cutterhead pulley, as shown in Figure 14.

9. Check the alignment of the pulleys to make sure the V-belt is straight up and down.

—If the pulleys are aligned, go to Step 13.

—If the pulleys are NOT aligned, follow Steps 10–12.

10. Remove V-belt and loosen motor mount bolts (see Figure 13).

11. Shift the motor horizontally as needed to align the pulleys, and tighten the motor mount bolts.

12. Re-install the V-belt on the pulleys.

13. Pull down on the motor with one hand to keep tension on the V-belt, and tighten the motor bracket bolts with your other hand.

**Note:** DO NOT use a mechanical device to push the motor down farther than you can by hand or you will overtighten your V-belt, which will lead to shortened bearing life in the motor or cutterhead.

14. Use (2) M6-1 x 10 flange bolts, (2) M6-1 hex nuts, and (2) 6mm flat washers to install the belt guard, as shown in Figure 15.

15. Replace the cover on the back of the jointer stand.

16. Use (2) M6-1 x 20 cap screws to attach the extension table to the front of the jointer, as shown in Figure 16, but do not fully tighten the cap screws yet.

**CAUTION**

The belt guard MUST be installed before operating the jointer or the moving V-belt will be exposed, creating an entanglement hazard at the back of the jointer.
17. Use a straightedge to make the extension table flush with the infeed table, then tighten the two cap screws to secure extension table in place.

**NOTICE**

The outfeed table MUST be level with the knives at their highest point during rotation or else the workpiece cannot be fed across the jointer safely. The outfeed table height is factory set, but we recommend that you check it to make sure that it didn’t change during shipping.

18. Place a straightedge on the outfeed table so it extends over the cutterhead.

19. Carefully rotate the cutterhead pulley and notice if the knife contacts the straightedge when the knife is at its highest point in the rotation (top dead center or TDC), as shown in Figure 17.

![Figure 17. Make sure outfeed table is level with knives at their highest point of rotation (TDC).](image)

—The knife will barely touch the straightedge when the outfeed table is set correctly. If the outfeed table is set correctly, continue with the next step.

—If the knife lifts the straightedge or does not contact the straightedge, the outfeed table must be adjusted. Do the procedure given in **Setting Outfeed Table Height Even with Knives** on **Page 30**, then continue with the next step in this section.

—If one knife is even with the outfeed table but other knives are not, then the knife height must be adjusted. Refer to **Adjusting/Replacing Knives** on **Page 39**.

20. Use (2) M10-1.5 x 30 cap screws and (2) 10mm flat washers to attach the fence carriage base to the back of the jointer, as shown in **Figure 18**.

![Figure 18. Fence carriage base mounted on the back of the jointer.](image)

21. Mount the lock handle on the carriage.

22. Attach the fence to the carriage with the two M8-1.25 x 30 cap screws, as shown in **Figure 19**.

![Figure 19. Attaching fence to carriage.](image)
23. Install the tilt lever in the fence (see Figure 20).

![Figure 20. Installing the tilt lever.](image)

24. Insert the shaft of the cutterhead guard into the hole at the front of the infeed table, making sure that the flat part of the shaft faces the set screw.

25. Tighten the set screw against the shaft (see Figure 21) to secure the cutterhead guard.

![Figure 21. Securing the cutterhead guard.](image)

26. Test that the cutterhead guard is working correctly by pulling it back and letting go. The cutterhead guard should quickly spring back over the cutterhead when you do this.

—If the guard does not quickly spring back over the cutterhead when you perform this test, then remove it and repeat Steps 24–26. Do not continue with the assembly until the cutterhead guard is working correctly.

27. Use (2) M10-1.5 x 25 cap screws, (2) 10mm lock washers, and (2) 10mm flat washers to attach the pedestal switch to the back of the jointer, as shown in Figure 22.

![Figure 22. Attaching pedestal switch to the back of the jointer.](image)

**WARNING**

The cutterhead guard is a critical safety feature on this machine—you MUST install and verify that it is working as intended before using the jointer! Failure to do this will greatly increase the chances of a serious injury when operating the jointer.
28. Use the four M5-.8 x 16 Phillips head screws and 5mm flat washers to install the dust port on the jointer stand, as shown in Figure 23.

Figure 23. Attaching dust port to jointer stand.

Dust Collection

Recommended CFM at Dust Port: .......... 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

Items Needed

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust Collection System</td>
<td>1</td>
</tr>
<tr>
<td>Dust Hose 4&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Hose Clamps 4&quot;</td>
<td>2</td>
</tr>
</tbody>
</table>

To connect a dust collection hose:

1. Fit a 4" dust hose over the dust port, as shown in Figure 25, and secure it in place with a hose clamp.

Figure 25. Dust hose attached to dust port.

2. Tug the hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.

Knife Setting Jig

Assemble the knife setting jig as shown in Figure 24.

Figure 24. Knife setting jig assembly.

CAUTION

This machine creates substantial amounts of dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust collection system.
Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The Troubleshooting table in the SERVICE section of this manual can help.

⚠️ WARNING
Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

⚠️ WARNING
DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.

2. Push STOP button in (see Figure 26).

3. Connect machine to power supply.

4. Twist STOP button clockwise until it pops out (see Figure 27). This resets switch so machine will start.

Figure 27. Resetting the switch.

5. Push START button to start machine. A correctly operating machine runs smoothly with little or no vibration or rubbing noises.

6. Press STOP button to turn machine OFF.

7. WITHOUT resetting STOP button, press START button. Machine should not start.

— If machine does not start, the STOP button safety feature is working correctly. Congratulations! The Test Run is complete.

— If machine does start (with STOP button pushed in), immediately disconnect power to machine. The STOP button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.
Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, it is possible some of these adjustments may have changed during transportation and handling.

Before making any further service adjustments, we recommend operating the machine on a trial basis to ensure the best possible results.

**Factory adjustments that should be verified:**

- Model ST1006 Knife Settings (refer to Page 39).
- Table Parallelism (refer to Page 43).
- Depth-of-Cut Scale Calibration (refer to Page 47).
- Fence Stop Accuracy (refer to Page 48).

Tighten Belt

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt will stretch and seat into the pulley grooves. After this time, you must re-tension the belt to avoid slippage and burn out. Refer to Page 49 when you are ready to perform this important adjustment.

**Note:** Pulleys and belt can get hot. This is a normal condition. Allow them to cool before making adjustments.

A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate a problem with the machine or belt.
OPERATIONS

Overview

The Model ST1006/ST1011 will perform many types of operations that are beyond the scope of this manual. Many of these operations can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced jointer operator before performing any unfamiliar operations. Above all, your safety should come first!

To complete typical operation, operator does following:

1. Examines workpiece to verify it is safe and suitable for cutting.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Puts on safety glasses, respirator, and ear protection.
7. Starts jointer.
8. Holds workpiece firmly against infeed table and fence, and slides it into cutterhead at a steady and controlled rate until entire length of workpiece has advanced beyond cutterhead to outfeed table.
9. Repeats cutting process until desired results are achieved.
10. Stops jointer.

WARNING

Eye injuries or respiratory problems can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.

WARNING

Loose hair/clothing could get caught in machinery and cause serious personal injury. Keep clothing and long hair away from moving machinery.

WARNING

DO NOT investigate problems or adjust the lathe while it is running. Wait until the machine is turned OFF, unplugged and all working parts have come to a complete stop before proceeding!

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects.
Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

• **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.

• **Jointing and surface planing with the grain is safer for the operator and produces a better finish.** Cutting against the grain increases the likelihood of kickback and workpiece tear-out. DO NOT cut against the grain! Cutting with the grain is feeding the stock across the cutterhead so the grain points down and back, as viewed from the front edge of the stock (see Figure 28).

Note: If the grain changes direction along the edge of the workpiece, decrease the depth of cut and make additional passes.

- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.

- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.

Note: Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.

- **Make sure your workpiece exceeds the minimum dimension requirements, as shown in Figure 29, before processing it through the jointer, or the workpiece may break or kick-back during the operation.**

- **Only process natural wood fiber through your jointer.** Your jointer is designed to cut only natural wood stock. This machine is NOT designed to cut metal, glass, stone, tile, products with lead-based paint, or products that contain asbestos—cutting these materials with a jointer may lead to injury.

Figure 28. Proper grain alignment with the cutterhead.

Figure 29. Minimum stock dimensions for jointer.
Squaring Stock

Squaring stock involves four steps performed in the order below:

1. **Surface Plane On The Jointer**: The concave face of the workpiece is surface planed flat with the jointer (see Figure 30).

   ![Figure 30. Surface plane on the jointer.](image1)

2. **Surface Plane On a Thickness Planer**: The opposite face of the workpiece is surface planed flat with a thickness planer (see Figure 31).

   ![Figure 31. Surface plane on a thickness planer.](image2)

3. **Edge Joint On The Jointer**: The concave edge of the workpiece is jointed flat with the jointer (see Figure 32).

   ![Figure 32. Edge joint on the jointer.](image3)

4. **Rip-Cut On A Table Saw**: The jointed edge of the workpiece is placed against a table saw fence and the opposite edge cut off (see Figure 33).

   ![Figure 33. Rip-cut on a table saw.](image4)
Surface Planing

The purpose of surface planing (see Figures 34–35) on the jointer is to make one flat face on a piece of stock to prepare it for thickness planing on a planer.

NOTICE
If you are not experienced with a jointer, set depth of cut to "0" and practice feeding workpiece across the tables as described for each of the jointing procedures. This process will better prepare you for actual operation.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see Stock Inspection & Requirements section).

2. Set infeed table height to desired cutting depth for each pass.

**IMPORTANT:** For safety reasons, do not exceed a cutting depth of \( \frac{1}{16} \)" per pass when surface planing.

3. Set fence to 90˚.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

**IMPORTANT:** To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

6. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.

**IMPORTANT:** Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

7. Repeat Step 6 until entire surface is flat.

**Tip:** When squaring up stock, cut opposite side of workpiece with a planer instead of the jointer to ensure both sides are parallel.

**WARNING**

Failure to use push blocks when surface planing could result in your hands contacting rotating cutterhead, which will cause serious personal injury. ALWAYS use push blocks when surface planing on jointer!
Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface that is suitable for joinery or finishing, as shown in Figures 36–37. It is also a necessary step when squaring rough or warped stock.

Figure 36. Example of edge jointing operation.

Figure 37. Illustration of edge jointing results.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see Stock Inspection & Requirements section).

2. Set infeed table height to desired cutting depth for each pass.

   IMPORTANT: For safety reasons, cutting depth should never exceed 1/8" per pass.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

   IMPORTANT: To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

6. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.

   IMPORTANT: Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

7. Repeat Step 6 until the entire edge is flat.

Tip: When squaring up stock, cut opposite edge of workpiece with a table saw instead of the jointer—otherwise, both edges of workpiece will not be parallel with each other.
Bevel Cutting

Bevel cuts (see Figures 38–39) can be made by setting the fence at the desired angle and feeding the workpiece firmly along the fence face, with the bottom inside corner firmly against the table. The cutting process typically requires multiple passes or cuts to bevel the entire edge of a workpiece.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see Stock Inspection & Requirements section).

2. Set infeed table height to cutting depth desired for each pass.

   **Note:** Cutting depth for bevel cuts is typically between $\frac{1}{16}''$ and $\frac{1}{8}''$, depending on hardness and width of stock.

3. Set fence tilt to desired angle of cut.

4. Place workpiece against fence and infeed table with concave side face down.

5. Start jointer.

6. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

   **Note:** When your leading hand gets within 4" of the cutterhead, lift it up and over cutterhead, and place push block on portion of the workpiece once it is 4" past cutterhead. Now, focus your pressure on outfeed end of the workpiece while feeding, and repeat same action with your trailing hand when it gets within 4" of cutterhead. To help keep your hands safe, DO NOT let them get closer than 4" from moving cutterhead at any time during operation!

7. Repeat cutting process, as necessary, until you are satisfied with the results.

---

Figure 38. Fence setup for a bevel cut of 45°.

Figure 39. Illustration of bevel cutting results.
Rabbet Cutting (ST1006)

The purpose of rabbet cutting (see Figures 40–42) is to remove a section of the workpiece edge, as shown below. When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

To rabbet cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see Stock Inspection & Requirements section).

2. Set infeed table height to desired cutting depth for each pass.

   **IMPORTANT:** For safety reasons, cutting depth should never exceed 1/8” per pass.

3. Remove cutterhead guard.

4. Set fence to 90˚ and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.

5. Start jointer.

6. Place workpiece firmly against fence and infeed table.

   **IMPORTANT:** To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

7. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during entire cut.

   **IMPORTANT:** Keep hands at least 4” away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

8. Repeat Step 7 until rabbet is cut to depth.

**WARNING**

When cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes operator to moving cutterhead. ALWAYS replace cutterhead guard after rabbet cutting!
ACCESSORIES

The following lathe accessories may be available through your local Woodstock International Inc. Dealer. If you do not have a dealer in your area, these products are also available through online dealers. Please call or e-mail Woodstock International Inc. Customer Service to get a current listing of dealers at: 1-800-545-8420 or at sales@woodstockint.com.

The **D1123 Knife Honer (ST1006)** sharpens planer and jointer knives to a razor keen edge without removing having to remove them from cutterheads. Features two 400-grit stones, a flat stone for sharpening bevels, and a diagonal stone for flat edges.

Our **D3383 4" Precision Square** is made of hardened tempered polished steel, these 4" precision squares are perfect for precision 90° layout and machine set-up. The blade measures 4" and the beam 3. Blade edges and beam faces are accurate to within ± 0.0006".

The **D4018 Indexable Carbide Inserts (Set of 10)** measure 14mm x 14mm x 2mm and are the replacement inserts for the ST1011.

The **D4613 8" HSS Jointer Knives (Set of 4)** are the replacement blades for the Steelex ST1006.
MAINTENANCE

General

Regular periodic maintenance on your STEELEX® Model ST1006/ST1011 will ensure its optimum performance. Make a habit of inspecting your machine each time you use it.

Check for the following conditions and repair or replace when necessary:

- Loose mounting bolts.
- Worn switch.
- Worn or damaged cords and plugs.
- Damaged V-belt.
- Any other condition that could hamper the safe operation of this machine.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Note: This maintenance schedule is based on average daily usage. Adjust the maintenance schedule to match your usage, to keep your planer running smoothly.

Daily:

- Vacuum all dust on and around the table.
- Clean machine and protect unpainted cast-iron.
- Tighten loose mounting bolts.
- Check/sharpen/replace damaged or worn knives (Page 38).

Every Month:

- Check V-belt tension, damage, and wear (Page 48).
- Clean/vacuum dust buildup from inside cabinet and off of motor.

Cleaning/Protecting

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of a high-quality metal protectant.

Lubrication

NOTICE

Failure to follow reasonable lubrication practices as instructed in this manual for your machine could lead to premature failure of components and void the warranty.

Your jointer features bearings that are lubricated and sealed at the factory. These bearings do not require any further attention unless they need to be replaced. If a bearing fails, your planer will probably develop a noticeable rumble or vibration, which will increase when the machine is under a load. The bearings are standard sizes and can be replaced through Woodstock.

V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned (refer to the instructions on Page 48).
The following troubleshooting tables cover common problems that may occur with this machine. If you need replacement parts or additional troubleshooting help, contact our Technical Support.

Note: Before contacting Tech Support, find the machine serial number and manufacture date, and if available, your original purchase receipt. This information is required to properly assist you.

**Motor and Electrical**

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
</table>
| Machine does not start or a breaker trips immediately after startup. | 1. STOP button depressed.  
2. Incorrect power supply voltage or circuit size.  
3. Power supply circuit breaker tripped/fuse blown.  
4. Motor wires connected incorrectly.  
5. Wiring open/has high resistance.  
6. START/STOP switch at fault.  
7. Start capacitor at fault.  
8. Thermal overload relay has tripped.  
9. Contactor not energized/has poor contacts.  
10. Centrifugal switch at fault.  
11. Motor at fault. | 1. Rotate button head to reset.  
2. Ensure correct power supply voltage and circuit size.  
3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.  
5. Check/fix broken, disconnected, or corroded wires.  
6. Replace switch.  
7. Test/replace.  
8. Reset; adjust trip load dial if necessary; replace.  
9. Test all legs for power/replace.  
10. Adjust/replace centrifugal switch if available.  
11. Test/repair/replace. |
| Machine stalls or is underpowered. | 1. Workpiece material not suitable.  
2. Excessive feed rate.  
3. Excessive depth of cut.  
4. Dull knives/inserts.  
5. Dust collection problem, causing internal components to clog up with shavings.  
6. Belt slipping; oil/grease on belt.  
7. Pulley loose or not properly aligned.  
10. Run capacitor at fault.  
11. Contactor not energized/has poor contacts.  
12. Motor at fault. | 1. Ensure workpiece is suitable for jointing (Page 27).  
2. Reduce feed rate.  
3. Reduce depth of cut.  
4. Sharpen/replace knives (Page 38); rotate/replace inserts (Page 41).  
5. Clear blockages; move machine closer to dust collector; upgrade dust collector.  
6. Tension/replace belt (Page 48); clean belt; ensure pulleys are aligned (Page 49).  
7. Re-align pulleys; replace shaft key; tighten pulley set screw.  
8. Clean motor, let cool, and reduce workload.  
9. Test for good contacts/correct wiring.  
10. Test/repair/replace.  
11. Test all legs for power/replace.  
12. Test/repair/replace. |
| Machine has vibration or noisy operation. | 1. Motor or other component loose.  
2. Belt worn or loose.  
3. Motor fan rubbing on fan cover.  
4. Pulley loose or not properly aligned.  
5. Knives/inserts at fault.  
6. Cutterhead bearings at fault.  
7. Centrifugal switch at fault.  
8. Motor bearings at fault. | 1. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid.  
2. Inspect/replace belt (Page 48).  
3. Fix/replace fan cover; replace loose/damaged fan.  
4. Re-align pulleys; replace shaft key; tighten pulley set screw.  
5. Resharpen/replace knives; set knife alignment/height correctly.  
6. Replace bearing(s)/realign cutterhead.  
7. Replace.  
8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. |
## Operations

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
</table>
| Tables are hard to adjust. | 1. Table lock is engaged/partially engaged.  
2. Table stops blocking movement. | 1. Completely loosen table locks.  
2. Loosen/reset table stop bolts. |
| Excessive snipe (gouge in end of board that is uneven with rest of cut). | 1. Outfeed table is set too low, or knives (straight knife cutterheads only) set too high.  
2. Operator pushing down on trailing end (infeed side) of workpiece as it leaves cutterhead. | 1. Align outfeed table with cutterhead knives/inserts at top dead center (Page 45).  
2. Focus most of the workpiece pressure against outfeed table while cutting. |
| Workpiece stops in middle of cut. | 1. Outfeed table set too high. | 1. Align outfeed table with cutterhead knives/inserts at top dead center (Page 45). |
| Workpiece chipping, tear-out, indentations, or overall rough cuts. | 1. Not feeding workpiece to cut "with the grain."  
2. Dull knives/inserts.  
3. Workpiece not suitable for jointing.  
4. Nicked or chipped knives or inserts.  
5. Feeding workpiece too fast.  
6. Excessive depth of cut.  
7. Lack of proper dust collection or clogged dust port. | 1. Turn workpiece 180° before feeding again.  
2. Sharpen/replace knives; rotate/replace insert(s) (Page 38).  
3. Ensure workpiece is suitable for jointing (Page 27).  
4. Replace knives (Page 38); rotate/replace insert(s) (Page 41).  
5. Reduce feed rate.  
6. Reduce depth of cut.  
7. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector. |
| Fuzzy grain left in workpiece. | 1. Wood has high moisture content.  
2. Dull knives/inserts. | 1. Ensure wood moisture content is less than 20%. Allow to dry if necessary.  
2. Replace/rotate knives/inserts (Page 38). |
| Long lines or ridges that run along the length of the board. | 1. Nicked or chipped knives/inserts.  
2. Loose or incorrectly installed insert(s).  
3. Dirt or debris under carbide inserts (spiral cutterheads only). | 1. Replace/rotate knives/inserts (Page 38).  
2. Remove/replace insert(s) and install properly (Page 41).  
3. Remove inserts, properly clean mounting pocket and re-install (Page 41). |
| Uneven cutter marks, wavy surface, or chatter marks across face of workpiece. | 1. Feeding workpiece too fast.  
2. Knives/inserts not positioned at even heights in the cutterhead.  
3. Dirt or debris under carbide inserts (spiral cutterheads only). | 1. Reduce feed rate.  
2. Position knives so they are set up evenly in cutterhead (Page 38). Remove, clean, and re-install any inserts that are "raised" in cutterhead (Page 41).  
3. Remove inserts, properly clean mounting pocket and re-install (Page 41). |
| Glossy surface; scorching or burn marks on workpiece. | 1. Dull knives/inserts.  
2. Feed rate too slow. | 1. Sharpen/replace knives; rotate/replace insert(s) (Page 38).  
2. Increase feed rate. |
| Workpiece is concave or convex along its length after jointing. | 1. Workpiece not held with even pressure against outfeed table during cut.  
2. Workpiece too uneven at start of operation.  
3. Outfeed table not parallel with infeed table. | 1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut.  
2. Take partial cuts to remove extreme high spots before doing a full pass.  
3. Check/adjust table parallelism (Page 42). |
General

This section covers the most common service adjustments or procedures that may need to be made during the life of your machine.

If you require additional machine service not included in this section, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: techsupport@woodstockint.com.

Inspecting Knives

The height of the knives can be inspected with a straightedge to ensure that they are set even with the outfeed table at their highest point in the cutterhead rotation, or top dead center (TDC).

To inspect the knives:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard or block it open.
3. Using a straightedge on outfeed table, check height of each knife at positions shown in Figure 47.

—Knives are set correctly set when they just touch bottom of straightedge at TDC in each of straightedge positions.
—If knives do not touch straightedge or they lift up at any position, then those knives need to be adjusted.

Figure 47. Using a straightedge to inspect knives.

WARNING

MAKE SURE that your machine is unplugged during all service procedures! If this warning is ignored, serious personal injury may occur.
Adjusting/Replacing Knives (ST1006)

Setting the knives correctly is crucial to the proper operation of the jointer and it plays an important role in keeping the knives sharp. If one knife is higher than the others, it will do the majority of the work, and thus, become dull much faster.

There are two options for setting the knives—the straightedge method and the knife-setting jig method. Each option has advantages and disadvantages; the correct one for you will become a matter of personal preference. For best results, the tables must be parallel with each other (refer to Checking/Adjusting Table Parallellism on Page 42) and the outfeed table height must be properly set (refer to Setting Outfeed Table Height on Page 45).

Straightedge Method: A high-quality straightedge (or Jointer Pal®) is held flat against the outfeed table and the knife heights are set to the bottom of the straightedge, (see Figure 52). Because the knife projection height from the cutterhead is dependent on the outfeed table height, the outfeed table must be set as described in Setting Outfeed Table Height on Page 45 for this method to work correctly.

Figure 48. Example of straightedge method for setting knife heights.

When using the straightedge method to set the knives, you will not need to move the outfeed table once it is set and you will always be assured that the knives are even with the outfeed table in their highest point of rotation (TDC)—even if the cutterhead is not parallel with the outfeed table.

Knife-Setting Jig Method: Both tables are lowered to fit the jig on the cutterhead, as shown in Figure 49, and the knife heights are set to just touch the middle pad of the jig.

The knife setting jig makes it easy to ensure that the knives project out of the cutterhead evenly. After using the knife setting jig to set the knives, you have to re-adjust the outfeed table height to ensure that it is even with the knives at their highest point of rotation.

If you are using the positive stops on the tables, they will need to also be reset before operation. Also, for the knife setting jig to work correctly, the outfeed table must be parallel with the cutterhead.

Figure 49. Example of knife-setting jig positioned over cutterhead knife.
The Model ST1006 comes with both jack screws and springs inside the cutterhead to provide two options for adjusting the knives (see Figure 50).

Note: Only one of these options is needed to set the knives—Step 5 gives the details.

![Figure 50. Cutterhead profile diagram.](image)

5. Loosen the cutterhead gib bolts (see Figure 51), starting in the middle, and alternating back and forth until all of the gib bolts are loose, but not falling out.

![Figure 51. Gib bolt loosening/tightening direction.](image)

**First Time Only**

If this is the first time you are setting the knives, remove the gib and knife from the cutterhead. Decide which adjustment option you are going to use between the jack screws and the springs.

—If you decide to use the jack screws, remove the springs from the cutterhead (they are located directly below the knives).

—If you decide to use the springs, just thread the jack screws completely into the cutterhead so they will not get lost. Replace the gib and knife.

6. Remove and clean the gibs and clean inside the cutterhead slot to remove all pitch or sawdust. Coat the knives and gibs with a metal protectant, then fit the gibs back in the cutterhead with the new knives.

**Tools Needed**

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Knife-Setting Jig</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 3mm</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrench 10mm</td>
<td>1</td>
</tr>
</tbody>
</table>

To adjust/replace the knives:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Remove the cutterhead guard from the table and move the fence back as far as it will go.

3. Open the back cover to expose the cutterhead pulley.

4. Rotate the cutterhead pulley to get access to one of the cutterhead knives.
7. Adjusting the knife heights:

Jack Screws: Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (see Figure 58) and rotate the jack screws to raise or lower the knife. When the knife is set correctly, it will barely touch the bottom of the straightedge or the knife setting jig middle pad (depending on which method you are using). Snug the gib bolts tight enough to just hold the knife in place. Repeat on the other side of the cutterhead, then repeat Steps 5–7 with the rest of the knives.

Springs: Push the knife down with the straight-edge or middle pad of the knife setting jig, keeping the straightedge flat against the outfeed table or the knife setting jig feet evenly against the cutterhead (depending on which method you are using). Tighten the gib bolts just tight enough to hold the knife in place. Repeat on the other side of the cutterhead, then repeat Steps 5–7 with the rest of the knives.

8. Rotate the cutterhead to the first knife you started with. Slightly tighten all the gib bolts, starting at the ends and working your way to the middle by alternating left and right (see Figure 53). Repeat this step on the rest of the knives.

9. Repeat Step 8.

10. Repeat Step 8, but final tighten each gib bolt.

11. If you used the knife setting jig to set the knife heights, use the straightedge to adjust the outfeed table height evenly with the knives at top dead center (the highest point in their rotation). If you used the straightedge to set the knife heights, skip to the next step.

12. Replace the cutterhead guard and the close the back cover.
Rotating/Replacing Cutterhead Inserts (ST1011)

This spiral cutterhead is equipped with 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 (see Figure 54).

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.

Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phillips Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Torque Wrench</td>
<td>1</td>
</tr>
<tr>
<td>T-20 Torx Bit</td>
<td>1</td>
</tr>
<tr>
<td>Precision Straightedge</td>
<td>1</td>
</tr>
</tbody>
</table>

To rotate or replace spiral cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!

2. Remove cutterhead guard from table, and lower infeed and outfeed tables as far as they go, to provide access to cutterhead (see Figure 55).

3. Remove cabinet rear access panel to expose cutterhead pulley.

4. Rotate cutterhead pulley to provide access to insert(s) to be rotated/replaced.

5. Put on heavy leather gloves for protection.

6. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area.

7. Remove Torx screw and insert, then clean all dust and debris from both parts and pocket they were removed from.

   Tip: Use low-pressure compressed air or vacuum nozzle to clean cutterhead pocket.

8. Re-install insert so that a fresh cutting edge faces outward, making sure it is properly seated in cutterhead pocket.

   —If all four insert cutting edges have been used, replace insert with a new one. Always position reference dot in same position when installing a new insert.

9. Lubricate Torx screw threads with a small amount of light machine oil, wipe excess off, and torque screw to 48–50 inch/pounds.

   Note: If too much oil is applied to the threads, excess will attempt to squeeze out of threaded hole as you install insert and force it to raise slightly, making it out of alignment.
Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback may occur.

To check the outfeed table parallelism:

1. DISCONNECT MACHINE FROM POWER!

2. Remove the cutterhead guard and fence.

3. Loosen the outfeed table lock located at the front of the machine, and loosen the jam nuts and adjustment bolts located at the back of the machine (see Figure 56).

4. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge just touches the cutterhead body, as shown in Figure 57 (rotate the cutterhead if necessary).

5. Place the straightedge in the positions shown in Figure 58. In each position, the straightedge should touch the cutterhead and sit flat on the outfeed table.

—If the straightedge touches the cutterhead and sits flat across the outfeed table in each position, then the outfeed table is already parallel with the cutterhead. Check the infeed table to make sure that it is parallel with the outfeed table.

—If the straightedge does not touch the cutterhead and sit flat on the outfeed table in any of the positions, then the outfeed table is not parallel with the cutterhead. Correct the outfeed table parallelism, then correct the infeed table parallelism.

Figure 56. Table positive stop bolts.

Figure 57. Adjusting outfeed table even with cutterhead body.

Figure 58. Straightedge positions for verifying if outfeed table is parallel with cutterhead.
To check the infeed table parallelism:

1. Follow all the steps for checking the outfeed table parallelism to first make sure that the outfeed table is parallel with the cutterhead.

2. Raise the outfeed table higher than the cutterhead.

3. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in Figure 59.

4. Place the straightedge in the positions shown in Figure 60. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.

   —If the straightedge sits flat against both the infeed and outfeed table, then the tables are parallel.

   —If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then the infeed table needs to be adjusted parallel with the outfeed.

Adjusting Table Parallelism

For safe and proper cutting results, the tables must be parallel with the cutterhead. Adjusting them to be parallel is a task of precision and patience, and may take up to one hour to complete. Luckily, this is considered a permanent adjustment and should not need to be repeated for the life of the machine.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

The tables have four eccentric bushings under each corner that allow the tables to be adjusted parallel. These eccentric bushings are locked in place by piggybacked set screws (one on top of the other) and adjusted when the eccentric bushing is rotated.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead, then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements must be made from the cutterhead body—not the knives—or results may get skewed the next time you change knives.

IMPORTANT: The next steps are intended to be performed in succession with the same steps for checking the outfeed table. Do not continue until you have followed those steps.
To adjust the table parallelism:

1. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge just touches the cutterhead body, as shown in Figure 57 (rotate the cutterhead if necessary).

2. Remove the set screw from each of the four eccentric bushings (see Figure 61) under the outfeed table, and loosen the set screws underneath those removed set screws.

3. Place the straightedge in one of the positions shown in Figure 62, and adjust the table (a small hammer and punch or pin-type spanner wrench may be necessary to turn the eccentric bushings) so that the straightedge touches the cutterhead while lying flat across the outfeed table. Repeat this step with each of the remaining straightedge positions as many times as necessary until the outfeed table is parallel with the cutterhead.

4. Tighten/replace the set screws in the eccentric bushings on the outfeed table.

5. Remove the set screw from each of the four eccentric bushings under the outfeed table, and loosen the set screws underneath those removed set screws.

6. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in Figure 59.

7. Place the straightedge in one of the positions shown in Figure 60, and adjust the eccentric bushings under the infeed table so the straightedge lies flat against both tables. Repeat this step with each of the remaining straightedge positions as many times as necessary until the infeed table is parallel with the outfeed table.

8. Tighten/replace the set screws in the eccentric bushings on the infeed table.

9. Set the outfeed table height (see Page 30).

10. Set the knives (refer to Page 38).

11. Reinstall the cutterhead guard and fence.
Setting Outfeed Table Height

The outfeed table height must be even with the top of the cutterhead knives. If the outfeed table is set too low, there will be snipe. 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.

Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Straightedge</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrench 16mm</td>
<td>1</td>
</tr>
</tbody>
</table>

To set outfeed table height:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard, fence, and cabinet rear access panel.
4. Loosen outfeed table lock located at front of machine, and loosen jam nuts and positive stop bolts located at back of machine just behind outfeed table (see Figure 63).
5. Place straightedge on outfeed table so it extends over cutterhead.
6. Use motor pulley to rotate cutterhead until one of the knives or inserts is at top dead center (its highest point during rotation), as illustrated in Figures 64–65.

![Figure 64. Knife or insert at top dead center.](image)

7. Use outfeed table adjustment lever to set outfeed table so that knife or insert barely touches straightedge, as illustrated in Figure 65.

![Figure 65. Using straightedge to check outfeed table height.](image)

8. Tighten outfeed table lock located at front of machine, and tighten outfeed positive stop bolts and jam nuts located at back of machine (see Figure 63) so that outfeed table will not move during operation.
9. Re-install cutterhead guard, fence, and cabinet rear access panel.
Setting Infeed Table Height

The infeed table on the Model ST1006/ST1011 has positive stop bolts that, when properly set up, allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

We recommend setting the minimum depth of cut to 1/32" and the maximum depth of cut to 1/8" for most operations. DO NOT exceed 1/8" cut per pass on this machine or kickback and serious injury may occur!

Each positive stop bolt (see Figure 66) controls the top or bottom range of the table movement. The jam nut locks the positive stop bolt in position so it will not move during operation.

Calibrating Depth Scale

The depth-of-cut scale can be calibrated or "zeroed" to make sure the cutting depth shown on the scale matches the actual cutting depth (per pass).

Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Straightedge</td>
<td>1</td>
</tr>
<tr>
<td>Phillips Screwdriver #2</td>
<td>1</td>
</tr>
</tbody>
</table>

To calibrate the depth scale:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the infeed table positive stop bolts (see Figure 66).
3. Use a straightedge to help adjust the infeed table exactly even with the outfeed table, as shown in Figure 67.
4. Using a screwdriver, adjust the scale pointer to "0" (see Figure 68), then reset the infeed table positive stops.

Figure 66. Positive stop bolts for infeed table.
Figure 67. Infeed table even with outfeed table.
Figure 68. Depth scale adjusted to "0" position.
Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45° inward, 90°, and 45° outward (135°).

To set 45° inward fence stop:

1. DISCONNECT MACHINE FROM POWER!

2. Tilt the fence approximately 45° inward (Figure 69) onto the positive stop bolts, using a 45° square as a gauge.

3. Loosen the jam nut on the 45° inward positive stop bolt shown in Figure 69.

4. Adjust the positive stop bolts until the fence is exactly 45° inward while resting on the bolts (verify the angle with a 45° square).

5. Retighten the jam nut loosened in Step 2.

To set 90° fence stop:

1. Loosen the set screw in the plunger lock collar shown in Figure 70, and loosen the fence tilt lock.

2. Using a 90° square, adjust the fence to the 90° position, as shown in Figure 71.

3. Tighten the set screw in the plunger lock collar.

4. Adjust the indicator (if necessary) to 0° to calibrate the fence tilt scale.

To set 45° outward fence stop:

1. Loosen the fence tilt lock, and position the fence against the 45° outward positive stop bolt.

2. Loosen the jam nut on the 45° outward fence positive stop bolt (see Figure 72).

3. Adjust the 45° outward positive stop bolt until the fence is exactly 45° outward while resting on the bolt, as shown in Figure 72.

4. Retighten the jam nut loosened in Step 2.
Tensioning/Replacing V-Belt

To ensure optimum power transmission from the motor to the cutterhead, the belt must be in good condition (free from cracks, fraying and wear) and properly tensioned. As the machine is used, the belts will slightly wear and stretch, eventually losing their efficiency of transmitted power until they can be retensioned.

Also, a new belt typically has a break-in period, and should be checked/retensioned after the first 16 hours of belt life, as it will stretch and seat during this time.

**Tool Needed**

| Qty | Wrenches or Sockets 13mm | 2 |

**Tensioning Belt**

1. **DISCONNECT MACHINE FROM POWER**!

2. Remove cabinet rear access panel and loosen motor bracket fasteners shown in *Figure 73*.

3. Press down on motor to keep tension on belt.

4. Press belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately $\frac{1}{4}"$ deflection when pushed, as shown in *Figure 74*.

   —If there is more than $\frac{1}{4}"$ deflection when you check belt tension, repeat the tensioning procedure until it is correct.

   ![Figure 74. Correct belt deflection when properly tensioned.](image)

**Replacing Belt**

1. **DISCONNECT MACHINE FROM POWER**!

2. Remove cabinet rear access panel and loosen motor bracket fasteners shown in *Figure 73*.

3. Have another person lift motor as you remove belt and replace it with a new one. It may help to use a 2x4 as a lever to raise motor.

4. Follow Steps 4–5 in **Tensioning Belt** procedure above to set correct belt tension.

5. Tighten motor bracket fasteners (see *Figure 73*) and replace cabinet rear access panel.
Pulley Alignment

Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplanar) for optimum performance.

Each pulley can be adjusted by loosening the motor mount bolts, sliding the motor in or out, and retightening the fasteners to lock the motor pulley in place.

**To align the pulleys:**

1. **DISCONNECT MACHINE FROM POWER!**
2. Open the back cover and remove the belt guard.
3. Visually check the alignment of the two pulleys to make sure that they are aligned and that the V-belts are straight up and down (see Figure 75).
   - If the pulleys are aligned, go to Step 8.
   - If the pulleys are NOT aligned, do Steps 4–7.

   **Figure 75.** Pulleys aligned.

4. Loosen the motor mount bolts shown in Figure 76.

   **Figure 76.** Motor mount bolts for adjusting pulley alignment (white arrows).

5. Shift the motor horizontally as needed to align the motor pulley with the cutterhead pulley.
6. Tighten the motor mount bolts.
7. Close the back cover and reinstall the belt guard.
ELECTRICAL COMPONENTS

Motor Junction Box

Control Panel Assembly

ON Switch

STOP/Reset Switch

Magnetic Switch Assembly

Contactor

To Control Panel

Thermal Overload Relay

To Motor

To Power Source
ST1006/ST1011 Wiring Diagram

**DANGER**

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

**COLOR KEY**

- BLACK
- WHITE
- GREEN
- RED
- BLUE

240 VAC

MAGNETIC SWITCH ASSEMBLY

240V MOTOR

ST1006/ST101 1 8” Jointer (Mfd. Since 3/16)
ST1006/ST101 8" Jointer (Mfd. Since 3/16)
## Stand Parts List

<table>
<thead>
<tr>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>XST1006001</td>
<td>FLAT WASHER 5MM</td>
</tr>
<tr>
<td>2</td>
<td>XST1006002</td>
<td>MOTOR ACCESS PANEL</td>
</tr>
<tr>
<td>3</td>
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Labels/Cosmetics

**WARNING**

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again.

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WARRANTY

Woodstock International, Inc. warrants all STEELEX® machinery to be free of defects from workmanship and materials for a period of two years from the date of original purchase by the original owner. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, lack of maintenance, or reimbursement of third party expenses incurred.

Woodstock International, Inc. will repair or replace, at its expense and at its option, the STEELEX® machine or machine part which in normal use has proven to be defective, provided that the original owner returns the product prepaid to the STEELEX® factory service center or authorized repair facility designated by our Bellingham, WA office, with proof of their purchase of the product within two years, and provides Woodstock International, Inc. reasonable opportunity to verify the alleged defect through inspection. If it is determined there is no defect, or that the defect resulted from causes not within the scope of Woodstock International Inc.'s warranty, then the original owner must bear the cost of storing and returning the product.

This is Woodstock International, Inc.'s sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant that STEELEX® machinery complies with the provisions of any law or acts. In no event shall Woodstock International, Inc.'s liability under this warranty exceed the purchase price paid for the product, and any legal actions brought against Woodstock International, Inc. shall be tried in the State of Washington, County of Whatcom. We 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.

Every effort has been made to ensure that all STEELEX® machinery meets high quality and durability standards. We reserve the right to change specifications at any time because of our commitment to continuously improve the quality of our products.
Name ____________________________________________
Street ____________________________________________
City ___________________________ State ___________________________ Zip ___________________________
Phone # ___________________________ Email ___________________________ Invoice # ___________________________
Model # ___________ Serial # ___________ Dealer Name ___________________________ Purchase Date ___________________________

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?
   - Advertisement
   - Friend
   - Mail Order Catalog
   - Website
   - Other: ____________________________________________

2. How long have you been a woodworker/metalworker?
   - 0-2 Years
   - 2-8 Years
   - 8-20 Years
   - 20+ Years

3. How many of your machines or tools are **STEELEX**®?
   - 0-2
   - 3-5
   - 6-9
   - 10+

4. Do you think your machine represents a good value?  Yes  No

5. Would you recommend **STEELEX**® products to a friend?  Yes  No

6. What is your age group?
   - 20-29
   - 30-39
   - 40-49
   - 50-59
   - 60-69
   - 70+

7. What is your annual household income?
   - $20,000-$29,000
   - $30,000-$39,000
   - $40,000-$49,000
   - $50,000-$59,000
   - $60,000-$69,000
   - $70,000+

8. Which of the following magazines do you subscribe to?
   - Cabinetmaker
   - Popular Mechanics
   - Today's Homeowner
   - Family Handyman
   - Popular Science
   - Wood
   - Hand Loader
   - Popular Woodworking
   - Wooden Boat
   - Handy
   - Practical Homeowner
   - Woodshop News
   - Home Shop Machinist
   - Precision Shooter
   - Woodsmith
   - Journal of Light Cont.
   - Projects in Metal
   - Woodwork
   - Live Steam
   - RC Modeler
   - Woodworker West
   - Model Airplane News
   - Rifle
   - Woodworker's Journal
   - Modeltec
   - Shop Notes
   - Other:
   - Old House Journal
   - Shotgun News

9. Comments: ____________________________________________
   ____________________________________________
   ____________________________________________
   ____________________________________________
   ____________________________________________