



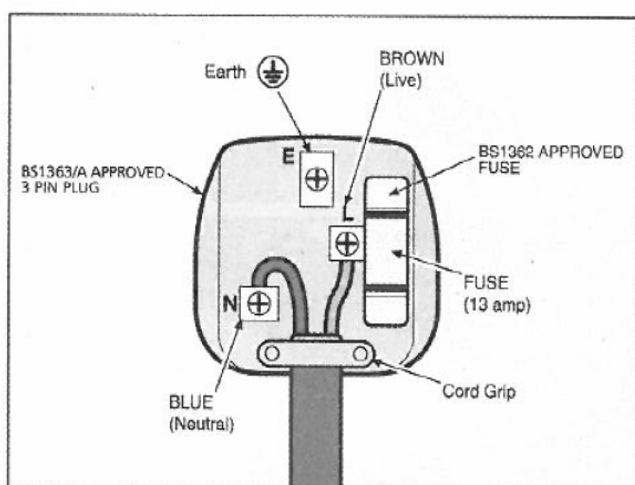
07904 BISCUIT JOINER



ELECTRICAL INFORMATION

CONNECTION OF THE MAINS PLUG

Important! The wires in the mains lead fitted to this product are coloured in accordance with the following code:



Brown: Live (L) or Red

Blue: Neutral (N) or Black

THIS PRODUCT IS DOUBLE INSULATED AND THEREFORE DOES NOT REQUIRE A CONNECTION TO EARTH.

3 PIN PLUG MUST COMPLY TO BS1363/A. FUSE MUST COMPLY TO BS1362.



If for any reason the 13 amp plug fitted to this product requires replacement it must be wired in accordance with the following instruction:

DO NOT CONNECT THE BROWN LIVE OR BLUE NEUTRAL TO THE EARTH PIN MARKED E (⊕) ON THE 3 PIN PLUG.

Connect the Blue wire to the terminal marked Neutral (N). Connect the Brown wire to the terminal marked Live (L). Ensure that the outer insulation is gripped by the cord grip and that the wires are not trapped when replacing the plug cover. The mains lead on this product is fitted with a 13 amp (BS1363/A) plug. A 13 amp (BS1362) fuse must be fitted in the plug.

IF IN DOUBT CONSULT A QUALIFIED ELECTRICIAN.

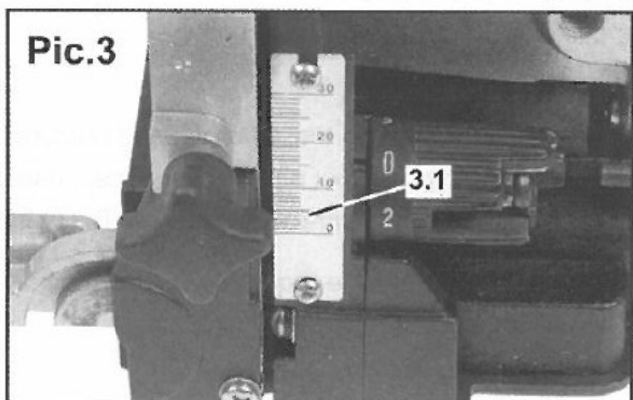
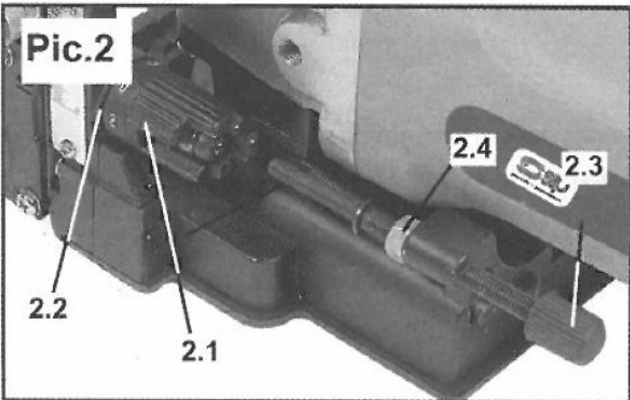
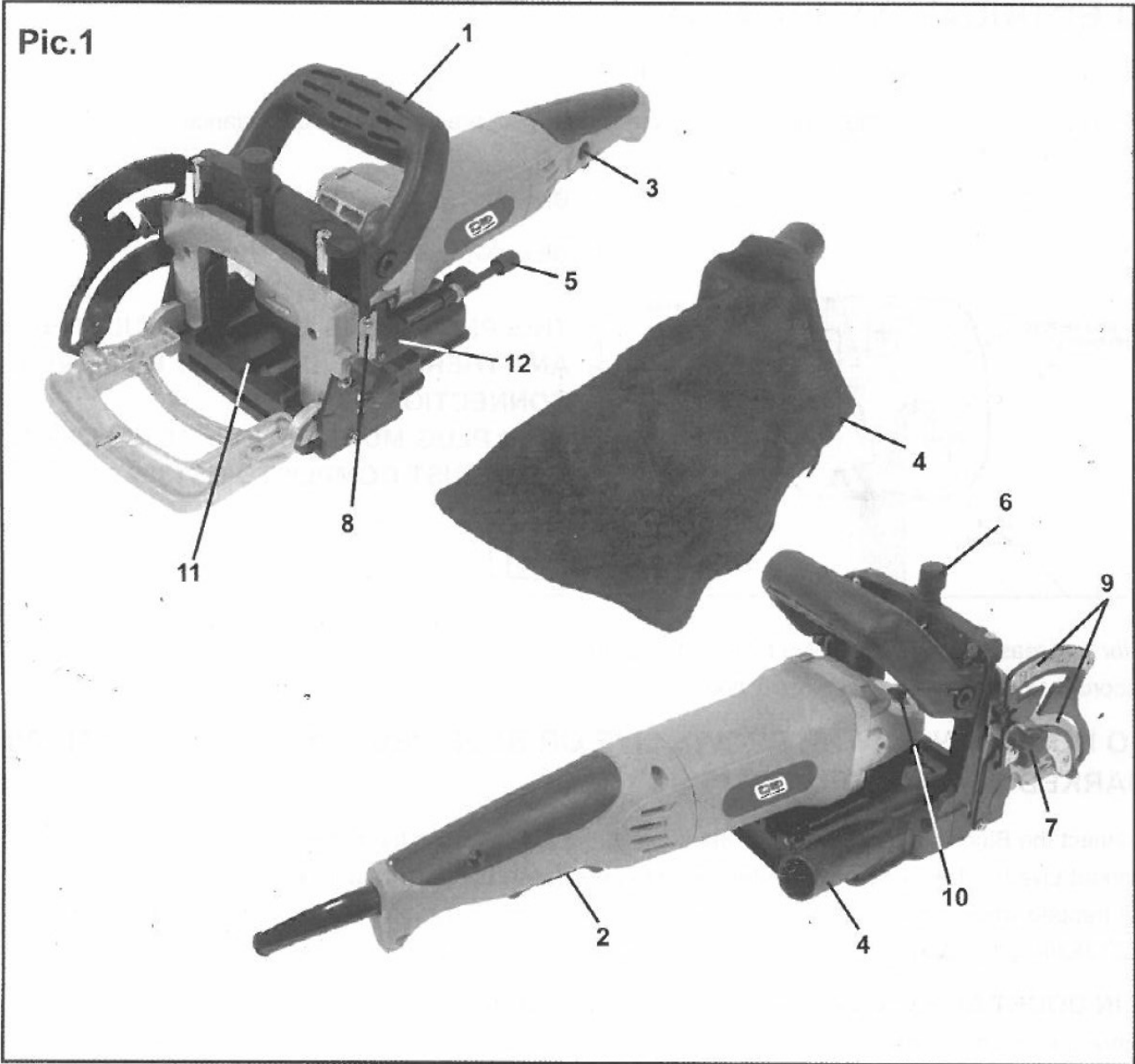
There are no user serviceable parts inside except those referred to in the manual. Always refer servicing to qualified service personnel. Never remove any part of the casing unless qualified to do so; this unit contains dangerous voltages.

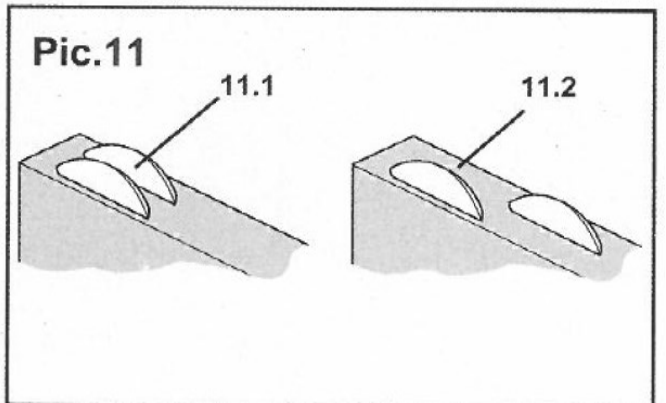
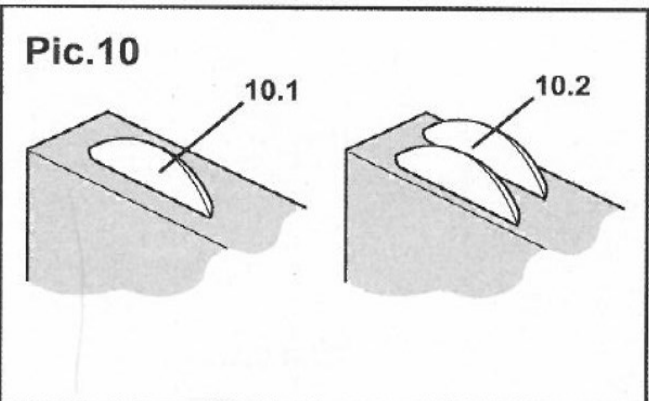
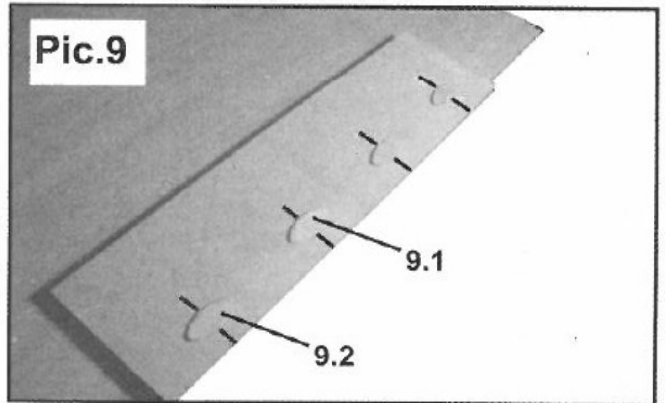
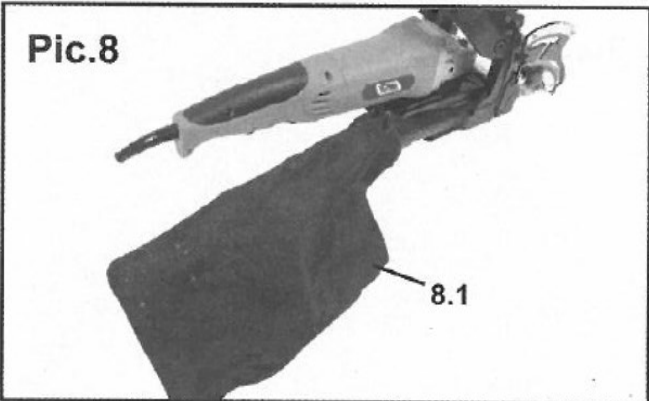
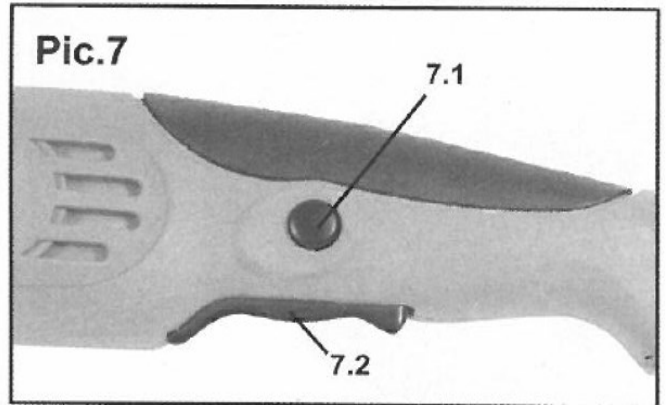
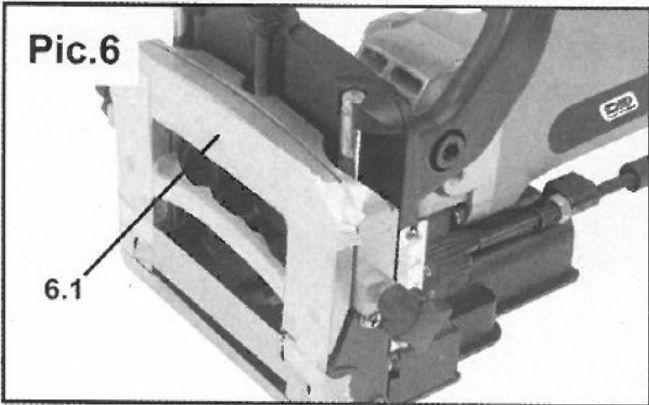
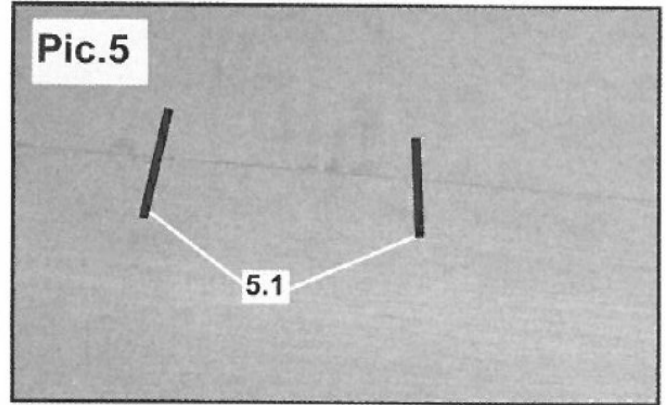
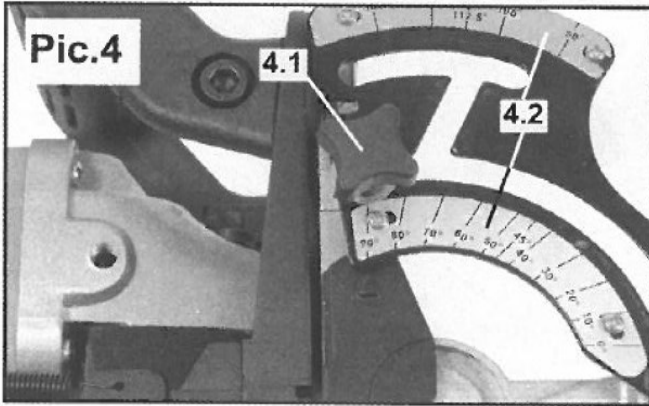
WARNING!

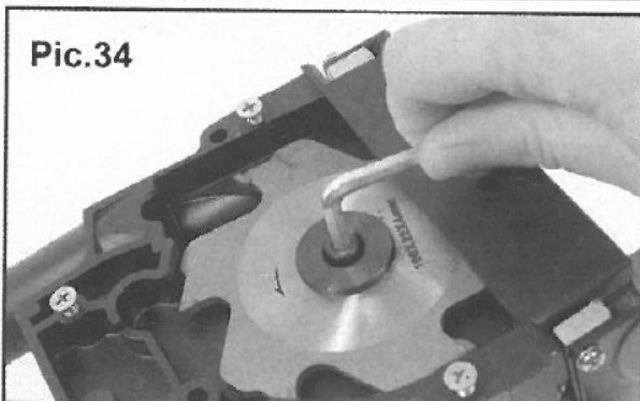
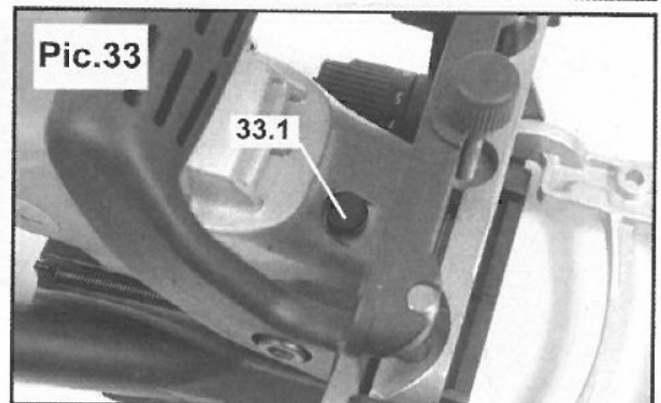
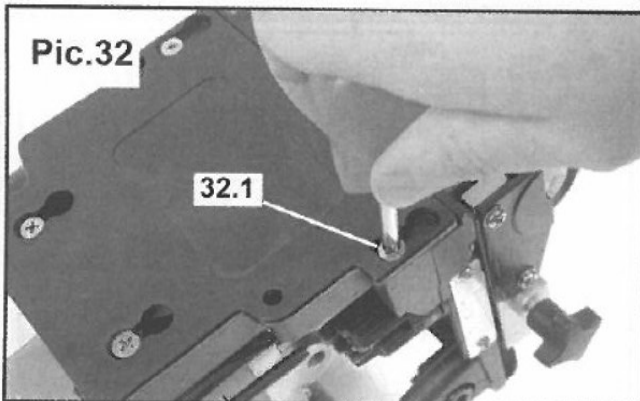
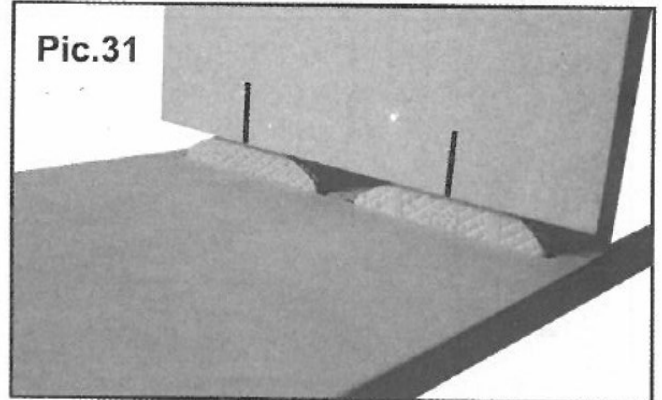
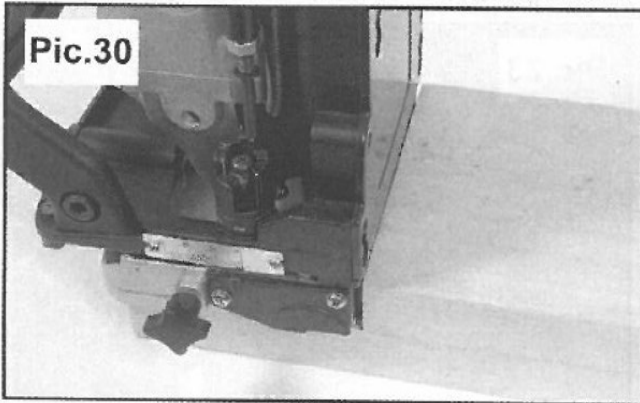
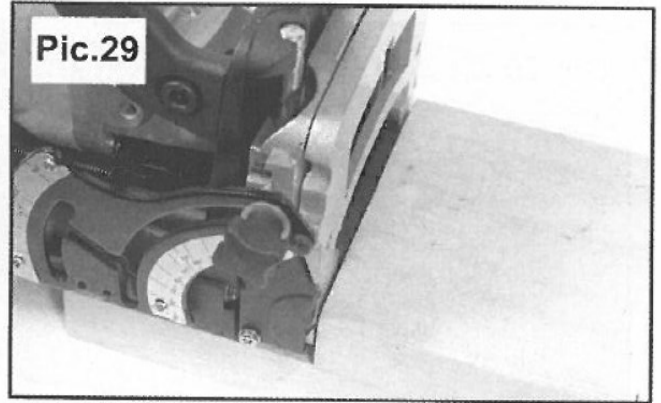
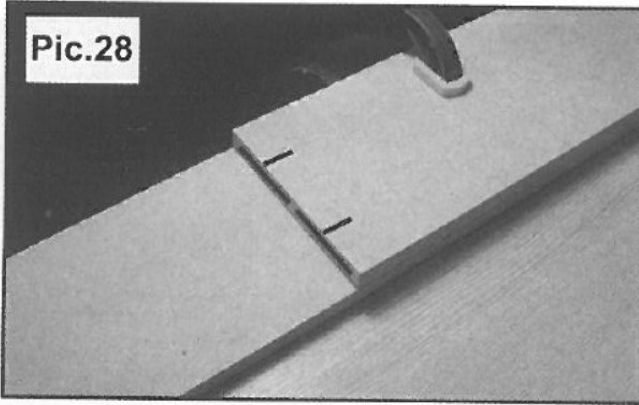
For your protection if this tool is to be used outdoors do not expose to rain or use in damp locations. Do not place tool on damp surfaces, use a workbench if available. For added protection use a suitable residual current device (R.C.D.) at the socket outlet.

NOTE: If the mains cable requires replacing it must be replaced with an identical one and fitted by a qualified person.

07904 BISCUIT JOINER







SPECIFIC SAFETY INSTRUCTIONS

WARNING!

TWO HANDED OPERATION REQUIRED

This machine requires the use of two hands to ensure safe operation and should not be used when working from ladders and step ladders.

If this machine is to be used when working at height a suitable, stable platform or scaffold tower with hand rails and kick boards should be used.

WARNING!

Some wood and wood type products especially MDF (Medium Density Fibreboard) can produce dust that can be hazardous to your health. We recommend the use of an approved face mask with replaceable filters when using this machine in addition to using the dust extraction facility.

Ensure that power tools are disconnected from the mains supply when not in use, before servicing, lubricating or making adjustments and when changing accessories such as blades, bits and cutters.

Do Not use cutters made from High Speed Steel.

Do Not stop the cutter by forcing the machine.

Always use the correct type of cutter for the operation to be carried out.

Do Not use cutters that are bent or have missing teeth this is highly dangerous and could result in a serious accident causing injury to the operator and bystanders and damage to the machine.

Only use cutters that are recommended by the supplier and that are in good condition.

Do Not use cutters that are larger than specified, only use cutters that are rated for the machine. The rotational speed (Min-1) shown on the cutter should always be HIGHER than the rotational speed (Min-1) of the Machine.

Ensure that the directional arrow marked on

the cutter corresponds with the rotational direction of the motor.

Ensure that cutter retraction mechanism operates correctly.

Always ensure that the toothed rim of the cutter does not extend beyond the front edge of the Joiner.

Always keep the shaft and cutter backing and securing flanges clean.

Whenever replacing cutters ensure that the recessed surface of the blade collar fits snugly against the surface of the cutter. Ensure that the cutter securing flange is securely tightened Do not over tighten.

Use only cutters that are recommended by the manufacturer.

Do Not attempt to remove shavings from inside the cutter housing with the mains supply connected and always keep fingers away from the cutter housing.

Do Not start the machine with the blade in contact with the work piece.

Check the work piece for any protruding nails, screw heads or anything that could damage the blade.

The work piece should always be clamped to a work bench to avoid kickback.

Hold the machine correctly and adopt a stable stance,

Do Not attempt to modify the machine or its accessories in any way.

Approved Ear defenders should be worn when using the Joiner for extended periods.

Always allow the machine to come to a complete stop and disconnect from the power supply before leaving the unit unattended.



SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER

GENERAL SAFETY RULES

WARNING! Read all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. The term "power tool" in all of the warnings listed below refers to your mains operated (corded) power tool or battery operated (cordless) power tool.

SAVE THESE INSTRUCTIONS

1) WORK AREA

- a) **Keep work area clean and well lit.** Cluttered and dark areas invite accidents.
- b) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- c) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

2) ELECTRICAL SAFETY

- a) **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) **Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c) **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d) **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.

- e) **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.

3) PERSONAL SAFETY

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- b) **Use safety equipment. Always wear eye protection.** Safety equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c) **Avoid accidental starting. Ensure the switch is in the off position before plugging in.** Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.
- d) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e) **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- f) **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.



SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER

g) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used. Use of these devices can reduce dust related hazards.

4) POWER TOOL USE AND CARE

a) Do not force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.

b) Do not use the power tool if the switch does not turn it on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.

c) Disconnect the plug from the power source before making any adjustments, changing accessories, or storing power tools. Such preventive safety measures reduce the risk of starting the power tool accidentally.

d) Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Power tools are dangerous in the hands of untrained users.

e) Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.

f) Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.

g) Use the power tool, accessories and tool bits etc., in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from intended could result in a hazardous situation.

5) SERVICE

a) Have your power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

COMPONENTS LIST (PIC 1)

1. Handle.	7. Fence angle locking knob.
2. On/Off Switch.	8. Fence height scale.
3. Safety button.	9. Fence angle scale.
4. Dust extraction outlet and bag.	10. Spindle Lock.
5. Plunge depth adjustment screw.	11. Cutter housing
6. Fence height adjustment screw.	12. Plunge depth selector

Operating Instructions

Jointing with a Biscuit Jointer

You have purchased a precision woodworking

tool. The Biscuit Jointer is designed for the jointing of timber, particle board and similar wood based products.



SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER

It provides an accurate, effective and convenient alternative to other means of jointing such as doweling. It is also particularly useful for edge jointing long boards of either natural wood or manufactured sheeting. The 100mm (4") cutter is plunged into the wood to the required depth, which can be pre-set depending on the biscuit to be used.

Table1. Typical biscuit sizes

Biscuit No.	Width	Typical depth of cut
# 20	24 mm	12mm
# 10	19 mm	10 mm
# 0	15 mm	8 mm

Using biscuits

Glue is applied to the biscuit which is inserted into the elliptical slot made by the cutter. The moisture in the glue is absorbed by the biscuit which expands as the glue sets, resulting in an extremely strong joint. The adjustable fence allows the height and angle of the blade to be positioned to suit different joint requirements. The depth of cut can be pre-set using the depth pre-set control dial, to suit the biscuit to be used. Two biscuits can be used, one above the other, for extra strength. The jointer can also be used to create a continuous groove, the width of which can be increased simply by adjusting the fence up or down and carrying out several passes.

Plunge depth adjustment (Pic.2)

The plunge depth can be set to suit the size of the biscuit being used. The numbers on the depth adjustment dial (Pic.2)(2.1) coincide with the most common sizes of biscuit.

To select the plunge depth, align the appropriate number on the plunge depth selector with the recessed line on the tool's housing (Pic.2)(2.2). Plunge the Jointer and measure the depth of plunge. If this does not match the depth for the selected biscuit as shown in Table1, use the fine adjustment screw (Pic.2)(2.3) to either increase

or decrease the plunge depth as required. To make this adjustment, slacken the adjusting screw lock nut (Pic.2)(2.4) and turn the fine adjusting screw anti clockwise to increase the plunge depth and clockwise to decrease the plunge depth, re-tighten the locking nut. Always check that depth cut by first making test cuts in a scrap piece of material. Repeat as necessary until the correct plunge depth is achieved. As the width and thickness of the biscuits may vary slightly it may be necessary to select a biscuit to fit the slot cut into the work piece, or moisten the biscuits slightly to achieve a tight fit where required.

Vertical fence position setting (Pic.3 & 4)

To set the vertical position of the slot rotate the height adjustment knob. Using the fence height scale (Pic.3)(3.1) adjust the fence height to the required position and secure with the locking knob.

The adjustable fence provides a sturdy, precise reference surface to determine the point at which the slots for the biscuit will be cut. The indicated distance on the height scale is the distance from the centre of the cutter to the underside of the fence, when the fence is set at 90°.

The adjustable angle feature allows a full range of angle settings, from 0° to 90° as well as a reverse 45° bevel which allows outside registration on mitre joints (See section on Mitre Joints). To adjust the height of the fence, slacken the fence height locking knob and adjust the fence to the required depth aligning the height scale with the pointer then tighten the fence height locking knob.

The fence angle can be set by slackening the fence angle locking knob (Pic.4)(4.1) and aligning the required angle on the protractor scale (Pic.4)(4.2) with the pointer then tighten the fence angle locking knob.

Angle cutting setting (Pic.4)

This machine is capable of cutting angled biscuit slots at angles of between 0° and 135°, which are used when strong joints are required at mitre joints etc. To set the required angle, slacken the fence angle locking knob (Pic.4)(4.1) set the required angle using the angle scale and pointer and secure with the locking knob.

Operation (Pics.5 to 14)

Biscuit jointers can be used for making a wide variety of strong, accurate joints in pieces of timber or wood sheeting. To cut the biscuit slot, the body of the jointer is moved towards the material. By using the various features of the tool it is possible to create a wide variety of different joints. Always mark both pieces to be jointed with a reference line indicating the centre position of each biscuit slot. This will allow accurate alignment of the Jointer with the work piece (Pic.5)(5.1).

If the edge of the work piece has a decorative surface the upper and lower front edges of the jointer must be covered with tape that has a smooth surface, such as electricians insulation tape (Pic.6)(6.1). This will prevent the decorative finish from being damaged.

Starting and stopping (Pic.7)

This machine is fitted with a "Safety button" to prevent accidental starting. To start the machine press in the safety button on the side of the handle (Pic.7)(7.1), then squeeze the On/Off trigger (Pic.7)(7.2). When the machine starts the safety button can be released. To stop the machine release the On/Off trigger.

Dust extraction (Pic.8)

The biscuit Jointer is supplied with a dust extraction outlet for use with a dust collection bag (Pic.8)(8.1), vacuum cleaner or dust extraction system.

Attach the dust collection bag to the outlet. When the bag becomes full, the dust will back-up into the outlet and the cutter housing. Make sure the Jointer is unplugged from the mains

supply socket before attempting to remove any build up of saw dust from inside the outlet. It is safer to remove the bottom cover plate and the outlet to clear any blockage.

It is strongly recommended that the dust extraction facility is used at all times.

General operation.

The biscuit jointer is used primarily for producing strong accurate joints in timber and wood type products including chip board and MDF. The range of joints that can be produced is limited only by the imagination of the user.

Biscuit size selection.

As previously discussed earlier the three biscuit sizes are #0, #10, and #20. As a guide it is recommended that the ideal biscuit to use is the largest biscuit that will physically fit in the application. For most applications the #20 biscuit will be the most commonly used. Set the plunge depth selector to the corresponding biscuit size ensuring the plunge depth has been set correctly. Always test the plunge depth on a scrap piece of material.

Biscuit location and layout (Pics.9 to 11)

As a general rule biscuits can be spaced and located at the operators discretion, however it is recommended that for edge joints the biscuits should be spaced every 150mm to 200mm (6" to 8") on centres (Pic.9)(9.1). The two outer biscuits should be positioned so that their outer edges should be at least 50mm (2") from the edge of the work piece (Pic.9)(9.2), this will prevent break out at the edge of the work piece. If break out is inevitable when jointing narrow stock the exposed tip of the biscuit can be trimmed off when the glue has set.

When jointing material up to 25mm (1") thick, it is recommended that a single biscuit located on the centre of the material thickness is used (Pic.10)(10.1). For material that is thicker than 25mm (1") it may be desirable to use two biscuits at each location, one at a height of about 1/3rd the thickness of the wood and the other at about 2/3rd the thickness of the

material to give greater strength (Pic.10) (10.2). Note: It is possible that thick pieces of timber may require two biscuits these could be either in line (Pic.11)(11.1) offset (Pic.11)(11.2) or a combination of the two.

Material layout (Pic.12)

To layout the positions of the biscuits on to the work piece, position the mating surfaces of the two pieces of material together in the correct position that they are to be assembled. Mark the centre point of the material and scribe a pencil line at 90° to the edges of the two work pieces (Pic.12)(12.1). Continue to layout the position of the biscuits working outwards from the centre of the material ensuring that the two outer biscuits are located 50mm (2") (Pic.12)(12.2) from the outside edges of the work piece. These marks will be used to line up with the centre registration lines on the biscuit jointer.

Making the cut (Pics.13 & 14)

Before making any cut ensure that all the settings have been checked, that all the locking knobs and screws are tight and the correct depth setting has been set and selected. Clamp the work piece to a suitable work bench, align the centre registration line on the biscuit jointer with the layout line on the work piece (Pic.13)(13.1). Switch on the biscuit jointer and allow the motor to reach full speed, Gripping the auxiliary handle with one hand and the other gripping the motor housing (Pic.14), position the fence firmly and squarely against the work piece, plunge the cutter until it stops against the plunge depth stop. Still holding the fence firmly and squarely against the work piece allow the return spring to retract the cutter from the work piece, switch off and allow the cutter to stop rotating before repeating the operation for the remaining cuts. Repeat this operation for the second work piece. As it will take some time to get a feel for the operation of the biscuit jointer it is recommended that some time is spent practicing on a scrap piece of material until the operation can be carried out smoothly.

Dry assembly

When all the biscuit cuts have been made it is worth spending some time dry assembling the joint to make sure that all the cuts are in the correct position and are at the correct depth.

Gluing up

It is important that the biscuits are coated with glue, the moisture in the glue is absorbed by the biscuit which expands as the glue sets; resulting in an extremely strong joint. Apply glue into the slots using a nozzle applicator, small brush or thin scrap of wood. Place the biscuits in position and clamp the joint until the glue starts to be squeezed out of the joint do not clamp too tight or all the glue will be squeezed out of the joint resulting in a weak joint.

Applications

The five most popular joints (Pics.15 to 31)

Edge to edge joint (Pics.15 & 16)

The simplest and most common application for the biscuit jointer is the edge to edge joint. This is most commonly used for jointing two or more boards together. Note: It is possible that thick pieces of timber may require two biscuits at each location, one at a height of about 1/3rd the thickness of the wood, and the other at about 2/3rd the thickness.

1. Prepare the work pieces and place them on a work bench in the position that they are to be assembled.
2. Layout the positions for the biscuits starting from the centre working outwards ensuring that the two outside positions are 50mm (2") in from the ends of the board (Pic.15)(15.1).
3. Ensure that all the settings have been checked, that all the locking knobs and screws are tight and the correct depth setting has been set and selected.

4. Clamp the work piece to a suitable work bench, align the centre registration line on the biscuit joiner with the layout line on the work piece.
5. Switch on the biscuit joiner and allow the motor to reach full speed,
6. Gripping the auxiliary handle with one hand and the other gripping the motor housing, position the fence firmly and squarely against the work piece, plunge the cutter until it stops against the plunge depth stop.
7. Still holding the fence firmly and squarely against the work piece allow the return spring to retract the cutter from the work piece.
8. Switch off and allow the cutter to stop rotating before repeating the operation for the remaining cuts.
9. Repeat this operation for the second and subsequent work pieces.
10. Apply glue into the slots using a nozzle applicator, small brush or thin scrap of wood.
11. Place the biscuits in position (Pic.16)(16.1) and clamp the joint until the glue starts to be squeezed out of the joint do not cramp too tight or all the glue will be squeezed out of the joint resulting in a weak joint.

Frame or mitre joints (Pics.17 & 18)

Typical applications for this type of joint are picture and mirror frames. Using the biscuit joiner this joint is quicker and easier to construct than the conventional dowel or mortise and tenon joint.

1. The material used for picture and mirror frames may not allow even the #0 to be fully concealed if this is the case ensure that any break out occurs on the inside edge of the frame the exposed tip of the biscuit can be trimmed off when the glue has set.

2. Prepare the work pieces and place them on a work bench in the position that they are to be assembled.
3. Layout the positions for the biscuits at the centre of the work piece (Pic.17)(17.1).

Repeat stages 4 to 10 for edge jointing above.

11. Place the biscuits in position (Pic.18)(18.1) and clamp the joint until the glue starts to be squeezed out of the joint do not cramp to tight or all the glue will be squeezed out of the joint resulting in a weak joint.

Corner joints (Pics.19 & 20)

This is another common joint for butt jointing frames and is quicker and easier to construct than the conventional dowel or mortise and tenon joint.

1. If the material used for this type of frame is thin it may not allow even the #0 biscuit to be fully concealed if this is the case ensure that any break out occurs on the inside edge of the frame the exposed tip of the biscuit can be trimmed off when the glue has set.
2. Prepare the work pieces and place them on a work bench in the position that they are to be assembled.
3. Layout the positions for the biscuits on the work piece (Pic.19)(19.1).

Repeat stages 4 to 10 for edge jointing above.

11. Place the biscuits in position (Pic.20)(20.1) and clamp the joint until the glue starts to be squeezed out of the joint do not cramp to tight or all the glue will be squeezed out of the joint resulting in a weak joint.

Edge mitre joints (Pics.21 to 25)

Edge mitre joints are most commonly used in box structures or for constructing multi sided forms such as pedestals where it is desirable to conceal the end grain.

The following procedure will produce a 4 sided box form.

1. Prepare the work pieces and place them on a work bench in the position that they are to be assembled.
2. Layout the positions for the biscuits on the outside of the joint starting from the centre, working outwards ensuring that the two outside positions are 50mm (2") in from the ends of the board (Pic.21)(21.1).
3. Set the fence to an angle of 90°.
4. Set the fence height so that the cut will be made towards the inside of the joint this will give a greater material thickness (Pic.22)(22.1)
5. Determine the maximum plunge depth so that the cutter will not protrude through the outside face of the material and select an appropriate sized biscuit.
6. Ensure that all the settings have been checked, that all the locking knobs and screws are tight and the correct depth setting has been set and selected.
7. Clamp the work piece to a suitable work bench, align the centre registration line on the biscuit jointer with the layout line on the work piece (Pic.23).

Repeat stages 4 to 10 for edge jointing above.

1. Place the biscuits in position (Pic.24)(24.1) and clamp the joint until the glue starts to be squeezed out of the joint do not cramp to tight or all the glue will be squeezed out of the joint resulting in a weak joint.

The above procedure will produce a box with four sides at an angle of 90°. For box forms with 4,5,6, and 8 sides refer to the table (Pic.25) for the correct angle settings.

"Tee" Joints (Pic.26 to 31)

The biscuit jointer can be used to produce a Tee

joint and is an alternative to dadoing. Tee joints are typically used when attaching shelves to the inside of a case. The shelf material must be at least 16mm (5/8") thick.

1. Prepare the work pieces and place them on a work bench in the position that they are to be assembled in the form of an upside down "T".
2. Scribe a pencil line along the joint on the case side at the position of the top edge of the shelf (Pic.26).
3. Layout the biscuit positions on the shelf material only. starting from the centre, working outwards ensuring that the two outside positions are 50mm (2") in from the ends of the board (Pic.27).
4. Lay the shelf material on top of the case side material and align the shelf edge with the scribed pencil line, on the case side.
5. Ensuring that both work pieces are correctly aligned, clamp them together onto the work bench (Pic.28).
6. Set the fence to an angle of 0°. Ensure that all the settings have been checked, that all the locking knobs and screws are tight and the correct depth setting has been set and selected.
7. Using the bottom registration plate align the centre registration line on the biscuit jointer with the layout line on the work piece (Pic.29). Repeat stages 4 to 10 for edge jointing above. And cut the vertical and horizontal cuts (Pic.30) for each biscuit location
8. Place the biscuits in position (Pic.31) and clamp the joint until the glue starts to be squeezed out of the joint do not cramp to tight or all the glue will be squeezed out of the joint resulting in a weak joint.

Joining a number of pieces

1. A wide board can be successively formed by joining several pieces of timber together using the above procedure.
2. Place the pieces together and successively join each piece using the edge to edge joints.

Groove Cutting

1. To cut a continuous groove, first adjust the jointer for making a straight biscuit joint.
2. Place the Jointer at one end of the of the work, switch on and plunge the blade.
3. Feed the Jointer along the work piece to the other end of the work piece, retract the cutter and switch off.

Tongue and Groove cutting

A tongue can also be cut onto the edge of a piece of timber by varying the height of each pass until the top surface of the tongue is reached and then turning the work over repeating the procedure.

Cutter removal (Pic.32 to 34)

Make sure the Jointer is unplugged from the mains supply socket. Turn the Jointer over and unscrew the four screws retaining the base plate (Pic.32)(32.1). Remove all saw dust and debris from inside the cutter housing. Locate and depress the spindle lock button located on the top of the gearbox housing (Pic.33)(33.1), rotate the cutter by hand until the spindle is locked. Using the hex key supplied remove the clamping nut (Pic.34) (turn the hex key anti-clockwise to release the cutter clamping nut). Remove the cutter from the spindle. Before fitting the new cutter thoroughly clean inside the cutter housing, spindle and cutter flanges. Refitting is a reversal of removal. Ensure that the cutter runs freely by rotating it by hand before re-attaching the bottom cover plate.

Important: The direction of rotation of the cutter, must be the same as the direction of rotation marked by an arrow on the gearbox

housing.

Plug the machine into a mains socket outlet and run the machine with no load to check the free running of the motor and cutter before using it to cut into any material.

Maintenance

1. Keep the machine's air vents clean and free from debris at all times.
2. Remove dust and dirt regularly from the machine.
3. Lubricate all moving parts at regular intervals.
4. Never use caustic agents to clean plastics.

Technical Specification	
Voltage	230V~50Hz
Rated input	900W
No load speed	n_0 10800 min ⁻¹
Cutting angle	0 - 135°
Max/Min blade	100 x 22.2mm bore
Sound Power Level	92dB(A)
Sound Pressure Level	103dB(A)
Vibration Level	2.597m/s ²



SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER

The rating plate on your tool may show symbols. These represent important information about the product or instructions on its use.



Conforms to relevant safety standards.



Read the instruction manual.



General warning.



Waste electrical products should not be disposed of with household waste. Please recycle where facilities exist. Check with your Local Authority or retailer for recycling advice.



Product conforms to RoHS requirements.



This machine conforms to class 2 double insulation for additional protection.



For protection against injury wear ear defenders and safety goggles.



SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER

DECLARATION OF CONFORMITY

We

SIP (Industrial Products) Ltd
Gelders Hall Road
Shepshed
Loughborough
Leicestershire
LE12 9NH
England

As The Manufacturer's Authorised Representative Within the EC
Declare that the

Biscuit Joiner - SIP Pt. No. 07904
Suppliers Part No. MIJ-KZ-100

Conforms to the requirements of the following Directives, as indicated.

2006/42/EC
2004/108/EC
2002/95/EC
As Amended By
2008/35/EC

Machinery Directive
EMC Directive
ROHS Directive

And the following harmonised standard(s)

EN 55014-1:2006+A1:2009
EN 55014-2:1997+A1:2001+A2:2008
EN 61000-3-2:2006+A1:2009+A2:2009
EN 61000-3-3:2008
EN 60745-1:2009
EN 60745-2-19:2009

Signed: 

Mr P. Ippaso - Director - SIP (Industrial Products) Ltd
Date: 27/02/2012.

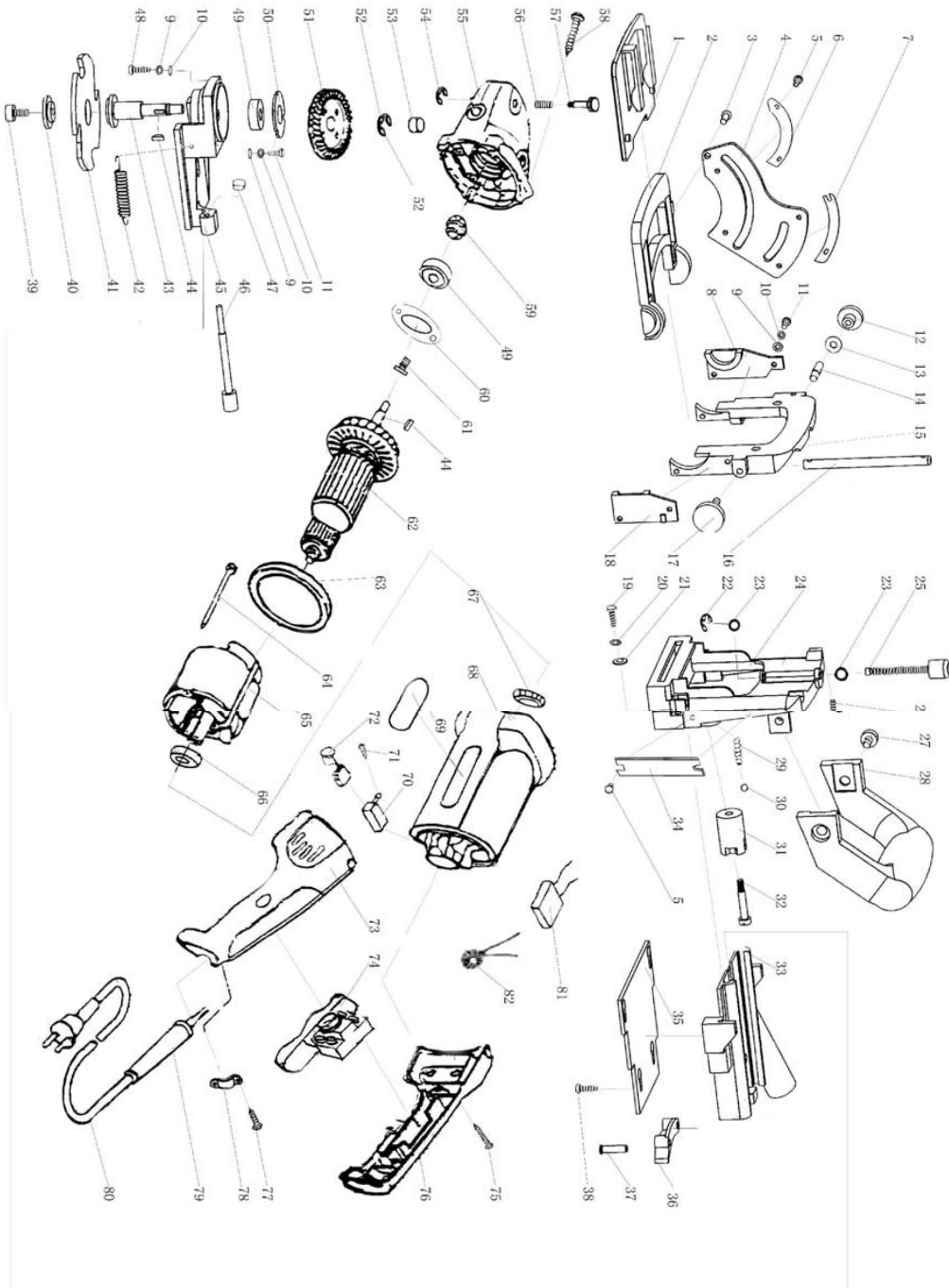




SIP INDUSTRIAL

machinery specialists since 1968

07904 BISCUIT JOINER



07904 BISCUIT JOINER

NO.	Part name	Qt.	NO.	Part name	Qt.
1	Pillow board	1	44	Woodruff key 3X10	2
2	Turning board	1	45	Fore cover	1
3	Locking screw (screw board)	1	46	Limit screw (circlip for shaft 4)	1
4	Scale board	1	47	Nut M6	1
5	Screw M3X3.5	6	48	Screw M4X18	4
6	Ruler (1)	1	49	Bearing 6000-2Z	2
7	Ruler (2)	1	50	Bearing cover	1
8	Orientation board (left)	1	51	Big gear	1
9	Plain washer 4	4	52	Circlip for shaft 9	1
10	Spring washer 4	4	53	Oil bearing	1
11	Screw M4X10	4	54	Circle for shaft 6	1
12	Nut of handle	1	55	Gear box	1
13	Plain washer 6	1	56	Self-locking spring	1
14	Locking screw (screw board)	1	57	Self-locking pin (whole)	1
15	Moving board	1	58	Self-tapping screw 4X22	4
16	Guide pole	2	59	Pinion gear	1
17	Screw	1	60	Bearing cover	1
18	Orientation board (right)	1	61	Tapping screw M4X10	5
19	Screw M5X22	2	62	Rotor	1
20	Spring washer 5	2	63	Wind guard	1
21	Plain washer 5	2	64	Self-tapping screw 4X70	2
22	Circlip for shaft 4	1	65	Stator	2
23	Plain washer 6	2	66	Bearing 627-2Z	1
24	Anxious rack	1	67	Bearing bushing	1
25	Regulate screw	1	68	House	1
26	Tapping screw M4X18	4	69	Trade mark	1
27	Hex screw M8X12	2	70	Brush holder	2
28	Assistant handle	1	71	Self-tapping screw 3X8	2
29	Spring (limit)	1	72	Carbon brush	2
30	Steel ball Φ 5	1	73	Left handle	1
31	Limit block	1	74	Switch	1
32	Screw	1	75	Self-tapping screw 4X18	4
33	Base	1	76	Right handle	1
34	Ruler (3)	1	77	Self-tapping screw 4X14	2
35	Base cover	1	78	Cable pressboard	1
36	Block	1	79	Cable armor	1
37	Pin (limit)	1	80	Cable	1
38	Tapping screw M5X12	4	81	Capacitor 0.22 uF	1
39	Hex screw M6X16	1	82	Inductance 80uH	2
40	Saw cover	1			
41	Saw	1			
42	Restoration spring	2			
43	Spindle	1			