



Operating Instructions and Parts Manual 13-inch Portable Thickness Planer

Models JWP-13BTK and JWP-13BTHH



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1.0 IMPORTANT SAFETY INSTRUCTIONS

⚠ WARNING

– To reduce risk of injury:

1.1 General Machine Safety Rules

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or are removed.
4. This planer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a planer, do not use until proper training and knowledge have been obtained.
5. Do not use this machine for other than its intended use. If used for other purposes, JET disclaims any express or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI Z87.1 approved safety glasses or face shield while using this machine. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
7. Before operating this machine, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Do not operate this machine while tired or under the influence of drugs, alcohol, or any medication.
10. Make certain the switch is in the OFF position before connecting the machine to the power supply.
11. Make certain the machine is properly grounded.
12. Always unplug the machine before making any adjustments. Accidental machine startup may cause serious injury from contact with the rotating cutterhead.
13. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
14. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
15. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
16. Provide for adequate space surrounding work area and non-glare, overhead lighting.
17. Keep the floor around the machine clean and free of scrap material, oil and grease.
18. Keep visitors a safe distance from the work area. Keep children away.
19. Make your workshop child proof with padlocks, master switches or by removing starter keys.
20. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
21. Maintain a balanced stance at all times so that you do not fall into the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
22. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
23. Use recommended accessories; improper accessories may be hazardous.
24. Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
25. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use bare hands.
26. Do not stand on the machine. Serious injury could occur if the machine tips over.

27. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
 28. Remove loose items and unnecessary workpieces from the area before starting the machine.
 29. Don't use in a dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- ## 1.2 Planer Specific Safety Rules
30. Do not force work through the machine; allow the planer to apply the proper feed rate.
 31. Never stand directly in line with either infeed or outfeed. Always stand to one side, in case kickback occurs.
 32. Make sure workpiece is free of nails, screws, stones and other foreign objects which could damage the knives and/or present a safety hazard. Do not plane boards with loose knots, or that have severe warp.
 33. Make sure knives are securely installed in cutterhead. Loose knives can be propelled from the tool at high speed causing serious injury.
 34. Do not start the machine while cutterhead is contacting the workpiece.
 35. Allow cutterhead to reach full speed before feeding the workpiece.
 36. Never reach into the machine when the cutterhead is rotating.
 37. Use caution when feeding boards. When a board is engaged by the feed roller, it will be forced down onto the infeed table, causing a pinching hazard. Keep hands clear.
 38. Do not attempt to plane excessively warped boards.
 39. Support very long workpieces with an assistant or support stand.
 40. Do not attempt to feed boards from the outfeed side.
 41. Do not plane boards shorter than 14-inches in length.
 42. Do not exceed 1/8-inch depth of cut per pass.
 43. Keep knives sharp for best results and safer operation. Rotate for a fresh edge or replace as needed.
 44. Plane in the direction of the board's grain. Planing against the grain can result in tear-out and splintering of the wood and increase risk of kickback. Do not plane end grain.
 45. Check the feed rollers before use for chips and sawdust lodged between components. If the rollers are not seated securely, they will not hold stock firmly against the bed, increasing the risk of kickback.

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

CAUTION

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

WARNING

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

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3.0 About this Manual

This manual covers the safe operation and maintenance procedures for the JET Model JWP-13BTK and JWP-13BTHH benchtop planer. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your tool has been designed and constructed to provide consistent, long-term operation when used in accordance with the instructions in this document.

If you have any questions or comments, please contact your local supplier or JET. JET can also be reached at our website: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠ WARNING Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

Register your product using the mail-in card provided or register online: www.jettools.com/product-registration

To quickly reach the product registration webpage, scan the QR code below.



4.0 Features of JWP-13BTK & JWP-13BTHH Planer

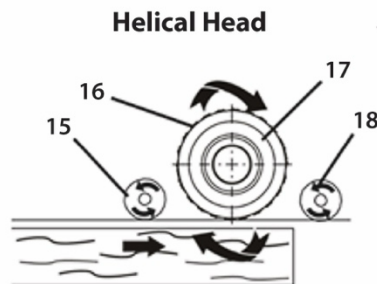
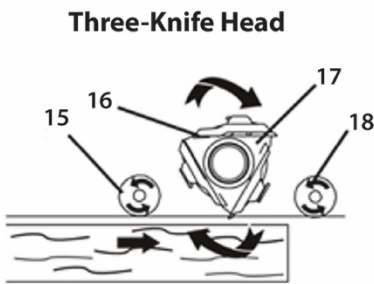
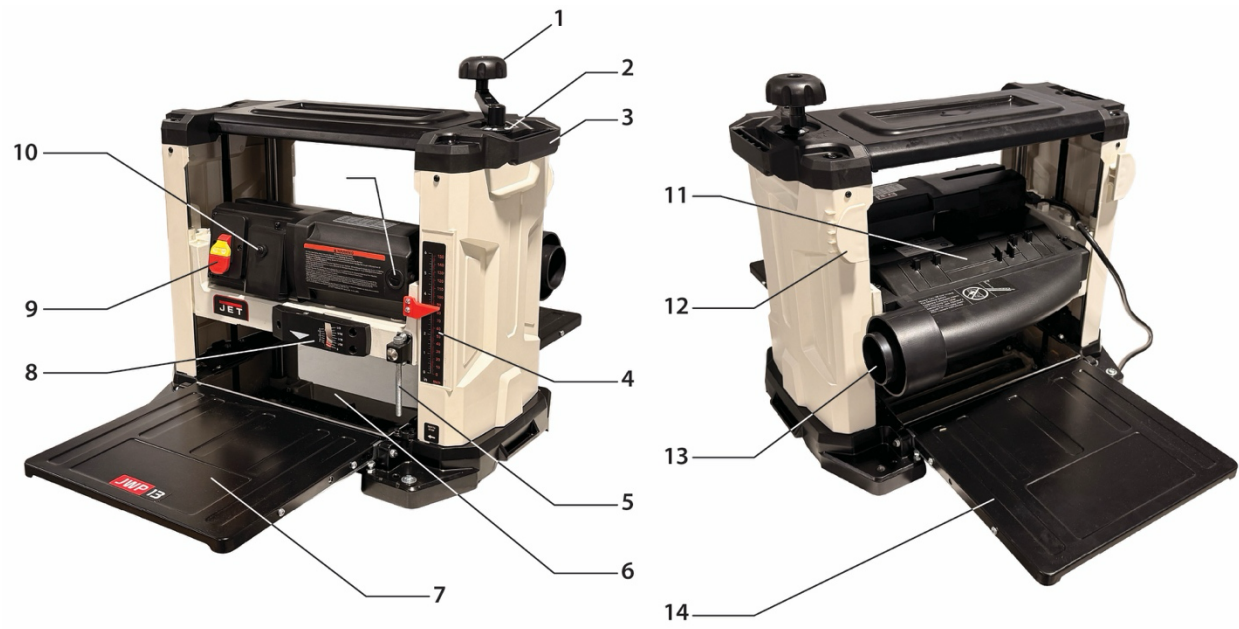


Figure 4-1

Included Tools



4.1 Product Identification

- 1 Crank Handle
- 2 Dial
- 3 Carrying Handle
- 4 Thickness Scale
- 5 Depth Stop
- 6 Bed
- 7 Infeed Table
- 8 Depth of Cut Gauge
- 9 ON/OFF Switch
- 10 Reset Button

- 11 Cutterhead Cover
- 12 Power Cord Storage
- 13 Dust Port
- 14 Outfeed Table
- 15 Infeed Roller
- 16 Planer Knife
- 17 Cutter Head
- 18 Outfeed Roller
- 19 Push Stick
- 20 Helical Knife Torx Screws (JWP-13BTHH only)
- 21 Torx Screwdrivers (JWP-13BTHH only)
- 22 T-Handle Hex Tooldriver
- 23 Helical Knives (JWP-13BTHH only)

5.0 Specifications

Table 2

Model Number	JWP-13BTK		JWP-13BTHH	
Stock Number	JT1-2988		JT1-2989	
Motor and Electricals				
Horsepower / RPM	P1=1.650kW, P2=1.000kW, S1=22,000 RPM			
Phase	Single			
Voltage	120V			
Cycle	60 HZ			
Listed FLA (Full Load Amps)	15A			
Overload Protector	125V AC. 18A			
Power Cord	3 x 14AWG			
Sound Emission	93dB		91dB	
Cutterhead				
Cutterhead Speed (RPM)	9,500			
Cutterhead Diameter (In.)	1.84" (46.74mm)			
Number of Knives	3 Knives		30 Inserts	
Cutting Specifications				
Maximum Depth of Cut Up (up to 6" width)	1/8" (3.17mm)			
Maximum Full Width Depth of Cut	1/16" (1.58mm)			
Maximum Planing Width	13" (330mm)			
Maximum Planing Thickness	6" (150mm)			
Minimum Planing Length	14" (356mm)			
Feed Rate (FPM)	24.6			
Table Size (L x W)	13" x 12" (330.2 x 304.8mm)			
Extension Table Size (L x W)	13.1" x 11.8" (332.74 x 299.72mm)			
Table Movement Per One Revolution of Handwheel	1/16" (1.58mm)			
Structure and Material				
Recommended Minimum Dust Extraction	550 CFM			
Dust Port Diameter	4" Outside / 2-1/2" Inside			
Depth Scale	0-6" (0-152.4mm)			
Depth of Cut	0-1/8" (0-3.17mm)			
Net Weight	66 lbs. (30kg)			
Shipping Weight	71 lbs. (32kg)			

¹ Subject to local and national electrical codes.

² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

L = length, W = width, H = height

FPM = feet per minute CFM = cubic feet per minute RPM = revolutions per minute

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

⚠ WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

6.0 Setup and Assembly

6.1 Shipping Contents

- 1 Planer
- 1 Crank handle (installed)
- 4 Socket head cap screw M5x25
- 1 Dust hood (installed)
- 1 T-handle hex screwdriver, 3mm
- 2 Torx screwdriver (JWP-13BTHH only)
- 5 M5 x 10 Hex Screws (JWP-13BTHH only)
- 5 Replacement Helical Head Cutting Knives (JWP-13BTHH only)
- 1 Operating Instructions & Parts Manual
- 1 Product registration card

Tools Required for Assembly:

4mm hex wrench

3mm T-handle hex screwdriver (provided)

Additional tools may be needed for adjustments or maintenance procedures.

6.2 Unpacking

1. Remove all contents from shipping carton. Do not discard carton or packing material until planer is assembled and running satisfactorily.
2. Inspect the contents for shipping damage or missing parts. If either is discovered, report it immediately to your distributor.

6.3 Installing

Recesses are included at both top and bottom for carrying the planer.

The planer should be secured to a stable and level workbench or table using fasteners (not provided) through the four holes in the base. This is especially important when processing large boards or taking deeper cuts to prevent the machine from shifting during the process. An alternative method is to fasten it to a thick plywood piece and then clamp the plywood to the bench or table; this ensures stability while still allowing portability.

Leave sufficient space around the planer for complete processing of boards through infeed and outfeed sides.

Install the crank handle, matching the flats on handle base and lead screw. Secure the handle with the provided socket-head cap screw using a 4mm hex wrench.

1. Drill holes into supporting surface, where necessary.

2. Put bolts through from the top and secure from below with nuts (A, Figure 6-1).

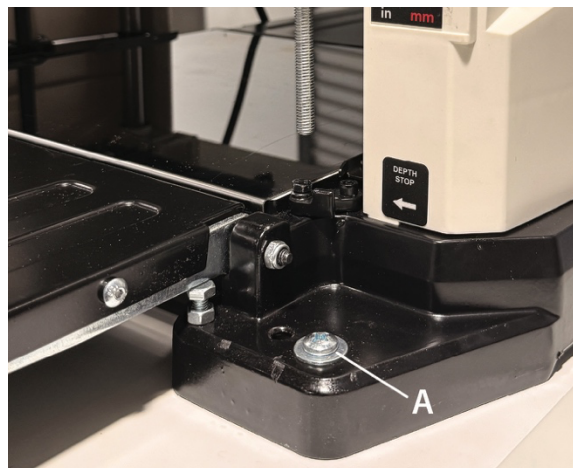


Figure 6-1

6.4 Dust Collection

It is strongly recommended that a dust collection system be used with this planer, with a minimum capacity of 550 CFM.

Note: A dryer vent hose is not acceptable for collecting wood dust and chips.

IMPORTANT: If a dust collection system is not used, do not install the dust hood. Using the dust hood without dust collection will accelerate the accumulation of chips and dust around the cutterhead.

6.5 Knife Inspection

The knife inserts in the cutterhead are secured in position by the manufacturer. However, the operator should confirm the tightness of each knife insert before operating the planer. Refer to sect. 8.3 for accessing the cutterhead.

⚠ WARNING

Check the tightness of all knife inserts in the cutterhead before operating the planer. Loose knife inserts can be ejected from the cutterhead at high speed, causing serious injury.

6.6 Wrench Storage

The provided T-handle hex wrench can be stored on top of the cutterhead cover by snapping it into the prongs. The remaining two prongs can hold a 4mm hex wrench (not provided). See Figure 6-2.

IMPORTANT: After extended use, if the prongs no longer hold the wrench securely, refrain from using them, as a loose wrench could vibrate off, creating a safety hazard.



Figure 6-2: Wrench Storage

7.0 Electrical Connections

The planer is wired for 120-volt power. The planer comes with a plug designed for use on a circuit with a *grounded outlet*, as shown in Figure 7-1, A.

Keep in mind that a circuit used by other machines, tools, lights, heaters, etc., simultaneously will increase the electrical load. A dedicated circuit to the machine will offer best results.

Before connecting to power source, be sure switch is in *off* position.

It is recommended that the planer be connected to a dedicated 30-amp circuit with circuit breaker or fuse. If connected to a circuit protected by fuse, use time delay fuse marked “D”. **Local codes take precedence over recommendations.**

7.1 Grounding Instructions

1. All Grounded, Cord-connected Tools:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current, reducing the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation that has a green outer surface, with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

⚠ WARNING

Check with a qualified electrician or service personnel if the grounding instructions are not fully understood, or if you are in doubt about whether the tool is properly grounded. Failure to comply may cause serious or fatal injury.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

2. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating **less than 150 volts**:

This tool is intended for use on a circuit with an outlet that looks like the one illustrated in Figure 7-1, A. An adapter, shown in B, may be used to connect this plug to a 2-pole receptacle if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and similar components extending from the adapter must be connected to a permanent ground, such as a properly grounded outlet box.

In Canada, the use of a temporary adapter is not permitted by the Canadian Electrical Code, C22.1.

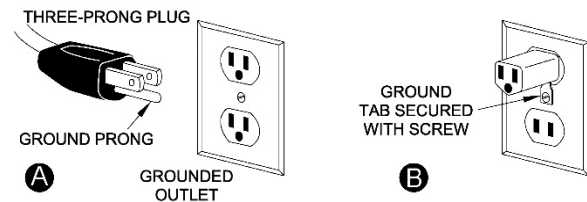


Figure 7-1

7.2 Extension Cords

The use of extension cords is discouraged; try to position equipment within reach of the power source. If an extension cord becomes necessary, be sure it is heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage, leading to power loss and overheating.

Table 3 shows the recommended sizes based on cord length and nameplate amperage rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Ampere Rating		Volts	Total length of cord in feet			
More Than	Not More Than	120	25	50	100	150
			AWG			
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not Recommended	

Table 3: Extension Cord Recommendations

8.0 Adjustments

⚠ WARNING

Always unplug the machine before making any adjustments. Accidental machine startup may cause serious injury from contact with the rotating cutterhead.

8.1 Height Adjustment

Use the crank handle (A, Figure 8-1) to adjust the planing thickness.

- A maximum of 1/8 in. (3.17mm) material can be removed per pass. See *Section 9.6 Planing Workpieces* for specific instructions on maximum depth of cut.
- Workpieces up to 6 inches thick (152mm) can be planed.
- The height adjustment is made by means of the crank handle (A, Figure 8-1). Each full turn of the crank raises or lowers the cutterhead by 1/16 inch (1.58mm). Moving each small grid of the dial, the cutterhead rises or lowers by 1/128 in (0.2mm).

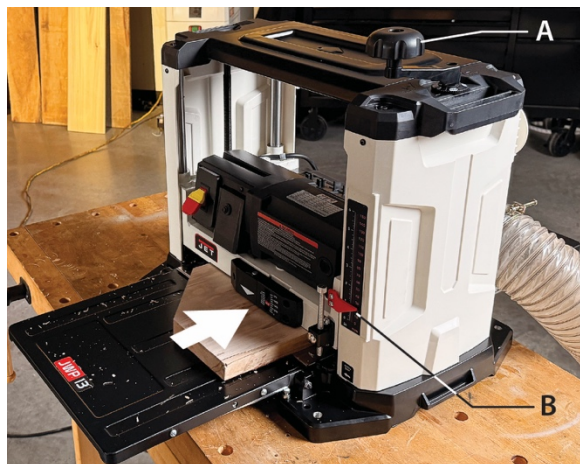


Figure 8-1

The set planing thickness is indicated on the thickness scale (B, Figure 8-1).

8.2 Aligning the Infeed and Outfeed Tables

To achieve an optimal planing result, all bearing surfaces must be level with each other.

Note: Before starting work, always check to see that the bearing surfaces of the center table, infeed table and outfeed table are level with each other.

⚠ WARNING

Always unplug the machine before making any adjustments. Accidental machine startup may cause serious injury from contact with the rotating cutterhead.

1. Fold down both infeed and outfeed tables (A & B, Figure 8-2).

2. Place a straight board (C, Figure 8-2), try square, straight edge, or similar item across the infeed and outfeed tables.

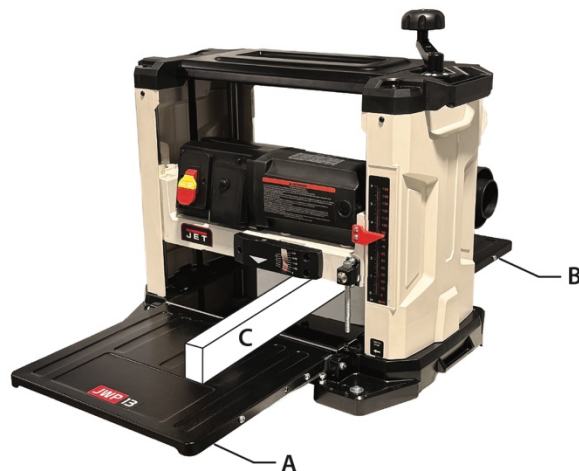


Figure 8-2

If Readjustment is Necessary:

3. Fold both infeed and outfeed tables up.
4. Loosen lock nut on both stop screws (A, Figure 8-3).
5. Adjust both stop screws until the infeed and outfeed tables are level with the planer's center table.

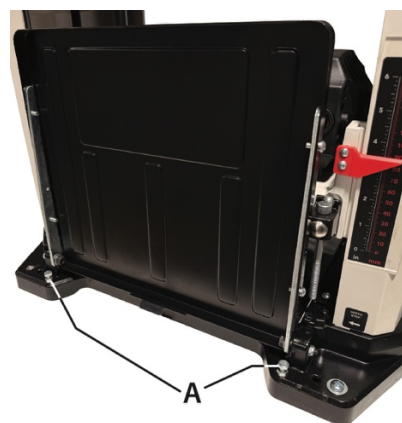


Figure 8-3

6. Fold down the infeed and outfeed tables and recheck.
7. When infeed and outfeed tables are properly aligned, secure all stop screws with the lock nuts (A, Figure 8-3).

8.3 Knife Replacement

Note: Dull planer knives will cause:

- reduced planing performance.
- increased risk of kickback.
- motor overloads.

⚠ WARNING

Always unplug the machine before making any adjustments. Accidental machine startup may cause serious injury from contact with the rotating cutterhead.

⚠ WARNING

Planer knives are very sharp. Wear gloves when changing planer knives.

⚠ WARNING

Never turn the cutterhead directly by hand. When changing the planer knives, only turn the cutterhead by the drive belt.

8.3.1 Preparations

1. Unplug power cable.
2. Fold down both infeed and outfeed tables.
3. Loosen the four dust port mounting screws (A, Figure 8-4). Note: Only loosen the screws. They do not need to be removed.
4. Remove the dust port.
5. Loosen the two cutterhead cover screws located on each end of the cutterhead cover (B, Figure 8-5). Note: Only loosen the screws. They do not need to be removed.
6. Remove the cutterhead cover.
7. Remove the drive belt cover (C, Figure 8-6)

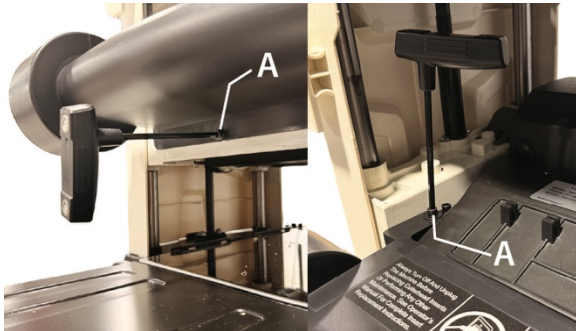


Figure 8-4

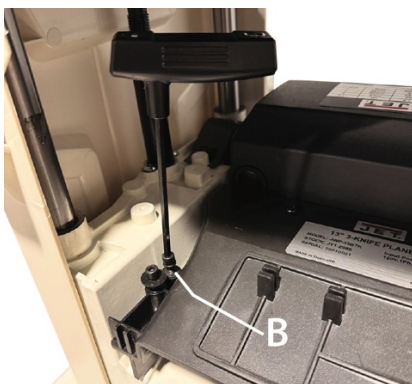


Figure 8-5



Figure 8-6

8.3.2 Positioning the Cutterhead

1. Using the drive belt, rotate the cutterhead while pressing the cutterhead locking lever (A, Figure 8-7). When the cutterhead rotates to the locking position, the locking lever will move into the locking position. Release pressure on the cutterhead locking lever.
2. With the cutterhead position locked, you can remove/install the planer knife/knives. See Section 8.3.3 and Section 8.3.4 for removing and installing planer knives.
3. Repeat for the remaining knife positions.

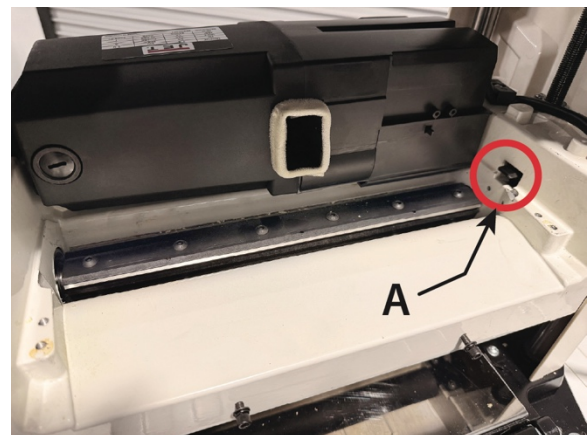


Figure 8-7

8.3.3 Removing the Planer Knives

⚠ WARNING

Planer knives are very sharp. Wear gloves when changing planer knives.

For Model JWP-13BTK:

1. Using the supplied hex wrench, loosen and remove all screws of the planer knife press strip (A, Figure 8-8).
2. Remove the planer knife press strip (B, Figure 8-8).
3. Carefully remove the knife (C, Figure 8-8) from the cutterhead.

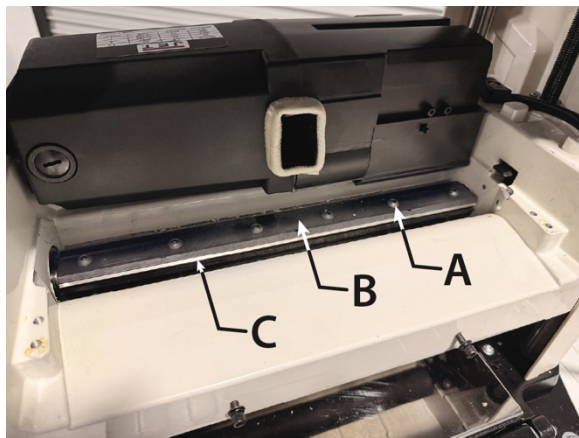


Figure 8-8

4. Remove the two springs from the holes in the cutterhead.
5. Repeat steps 1 through 4 for remaining knives.
6. Clean all surfaces of cutterhead and planer knife press strip with a suitable solvent.

CAUTION Do not use any cleaning agents (e.g., to remove resin residue) that could corrode the machine's light metal components.

For Model JWP-13BTHH:

Note: The planer helical head cutting knives have a cutting edge on all four sides. When the cutting side is dull, rotate each knife 90 degrees to use the next sharp side. Before removing the helical head cutting knives, mark the dull edge with a permanent marker so you will know which side to use next.

1. Using a permanent marker, mark the dull side of each knife for reference when reinstalling later.
2. Using the supplied Torx screwdriver, loosen and remove each screw and helical head cutting knife from the cutterhead (Figure 8-9).



Figure 8-9

3. Clean all surfaces of the cutterhead with a suitable solvent.

CAUTION Do not use any cleaning agents (e.g., to remove resin residue) that could corrode the machine's light metal components.

8.3.4 Installing the Planer Knives

WARNING Only use JET replacement knives with this planer.

WARNING Always replace or reverse all three planer knives at the same time.

For Model JWP-13BTK:

Note: The Model JWP-13BTK planer knives have a cutting edge on both the front and rear sides. If the opposite edge is sharp, turn the knife and install. If not, replace with new knives.

1. Fit both springs into the holes in the cutterhead.
2. Apply a light coat of oil to the planer knife.
3. Position the planer knife on the cutterhead. There are two guide pins in the cutterhead to help you position the knife properly.
4. Add screws and tighten the planer knife press strip. To avoid distorting the planer knife press strip, start tightening the screws in the center and work outward.
5. Replace and fasten the cutterhead cover.
6. Make sure no assembly tools or loose parts remain in the machine.

For Model JWP-13BTHH:

Note: The planer helical head cutting knives have a cutting edge on all four sides. When the cutting side is dull, rotate each knife 90 degrees to use the next sharp side. Before removing the helical head cutting knives, mark the dull edge with a permanent marker so you will know which side to use next.

1. Use the supplied Torx screwdriver to attach each helical head cutting knife to the cutterhead using the screws removed earlier. Be sure to orient the cutting knife 90 degrees from its last position so the dull side is not on the cutting side.
2. Replace and fasten the cutterhead cover.
3. Make sure no assembly tools or loose parts remain in the machine.

9.0 Operation

Thickness planing is the process of sizing lumber to a desired thickness while creating a level surface parallel to the opposite side of the board.

Note: The cutterhead may throw off a slight spray of lubricant when the machine is first turned on. Allow it to run for a few moments, then shut it off and wipe any oil off the tables before proceeding.

WARNING To avoid the risk of injury from kickbacks, do not stand directly in line with the front or rear of the planer.

9.1 General Recommendations

1. Many factors determine the appropriate depth of cut, such as wood width, density, grain structure, and moisture content. For best results, use shallow cuts and multiple passes. Excessive depth of cut can place additional strain upon the motor.
2. Use shallower cuts on wider workpieces.
3. A thickness planer works best when the lumber has at least one flat surface. Use a jointer to create a flat surface. If this is not possible, make several passes of the same surface through the planer until it is flat. Then flip the material over to plane the opposite surface.
4. Plane alternate sides until desired thickness is obtained. When half of the total cut has been taken from each side, the board will have a uniform moisture content and additional drying will not cause it to warp.
5. Make a test cut on scrap wood to verify thickness; check its accuracy before working on the finished product.
6. Avoid knots. Heavily cross-grained wood makes knots hard. Knots can come loose and jam the knives.
7. Do not plane dirty boards; dirt and small stones are abrasive and will wear out the knife inserts.
8. Do not plane boards less than 14-inches long. It is recommended that when planing short boards you butt them end-to-end to avoid kickback and reduce snipe.
9. For optimum planing performance, the depth of cut should be less than 1/16-inch.
10. Recommended *maximum* depth of cut:
 - Hard/Softwood up to 6" wide.....1/8"
 - Hard/Softwood 6" to 13" wide.....1/16"
11. Before starting work, check to see that the following are in proper working order:
 - Power cable and plug
 - ON/OFF switch
 - Cutterhead cover
 - Push stick
12. Assume proper operating position when planing:
 - Stand to the side of the infeed table.
 - When working with two people, the second person must stay a sufficient distance from the planing machine and stand to the side of the infeed or outfeed table, respectively.
13. If the type of work requires, use the following:
 - Workpiece support (e.g. roller support) – to keep the machine from tipping over when working long workpieces.

- Push stick (feeding aid) – for short workpieces.
- Dust collector
- Sliding wax – to enhance the gliding of the workpieces through the machine, apply a light coat of sliding wax to the surfaces of the infeed and outfeed tables.

14. Avoid typical operator mistakes:

- Do not exceed the specified workpiece dimensions.
- To reduce the risk of kickback, do not force the workpiece.

9.2 Cutterhead Cover

1. The cutterhead cover (A, Figure 9-1) prevents the rotating cutterhead from being touched from the top.
2. The cutterhead cover must be in place until the cutterhead has come to a complete stop and the power cable is unplugged.

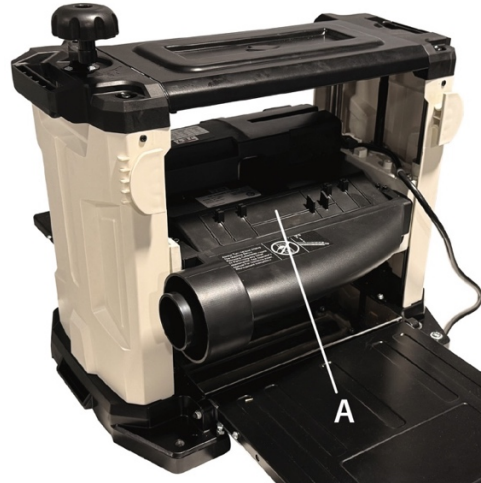


Figure 9-1

9.3 Basic Operating Procedure

1. Turn crank handle to desired setting. Use depth gauge if needed.
2. Turn on planer.
3. Turn on dust collection system.
4. Place material flat-side down on infeed table and slide it straight into machine until it is engaged by infeed roller. Do not push or pull on the workpiece as it is being planed.
5. Move to rear of planer, out of the line of feed, and grasp the workpiece as it exits the machine.
6. Turn crank handle to lower cutterhead to desired cut depth for next pass. Flip the material over and re-feed it through machine.
7. Repeat procedure as necessary. If a jam occurs, turn planer OFF and raise head to withdraw the workpiece.

9.4 ON/OFF Switch

- Switch (A, Figure 9-2)
- Reset button (B, Figure 9-2)

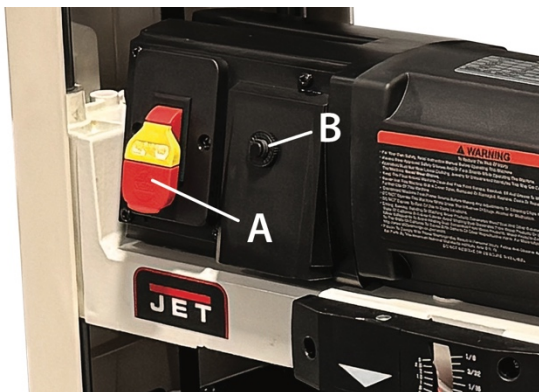


Figure 9-2

9.5 Before Planing a Workpiece

9.5.1 Test the Machine When Idling:

1. Fold down both infeed and outfeed tables.
2. Make sure the planer knives can turn freely.
3. Move cutterhead to desired planing thickness.
4. Plug in the power supply cable's plug and start the motor by pulling out the bottom of the ON/OFF switch (A, Figure 9-2).
5. Once the machine has reached full speed, pay attention to noise and vibrations.

CAUTION If noise and/or vibrations appear to be unusually high, turn OFF the machine immediately and unplug. Check machine for parts that may have worked loose; fasten any loose parts properly, where necessary.

9.6 Planing Workpieces

The thickness planer can remove up to 1/8 in (3.17mm) in a single pass.

However, this maximum depth of cut may be used only:

- With very sharp planer knives
- When planing soft wood
- When the maximum workpiece width is 6 inches or less

Otherwise, there is a risk of overloading the machine.

It is strongly recommended that you make several passes at a shallower depth of cut, to achieve the desired workpiece thickness.

Note: The ideal depth of cut to be used depends on several factors, such as type of wood, workpiece width or the state of dryness of the wood.

If you are planing mainly very wide (13-inch (330mm) workpieces, the motor is subjected to heavy loads. Plane narrow workpieces in between, or take a break to let the motor rest.

9.6.1 Workpiece Dimensions

- Do not use workpieces shorter than 14 inches. (356 mm). With shorter workpieces, there is a risk of kickback.
- Do not use workpieces that are thinner than 3/16 in. (5 mm). The cutterhead cannot be set lower.
- Use only workpieces wider than 3/4 inch (19 mm).
- Use extra workpiece supports for workpieces that are longer than 59 in. (1500 mm).
- Never thickness several workpieces at the same time. Risk of personal injury if individual pieces are uncontrolled and caught by the cutterhead.

1. Fold down both infeed and outfeed tables.
2. Set the planing thickness with the crank (A). The planing thickness is indicated by the scale (B). See Figure 9-3.
3. Start motor.

WARNING To avoid the risk of injury from kickbacks, do not stand directly in line with the front or rear of the planer.

WARNING Adjust the planing thickness only when the cutterhead is stopped.

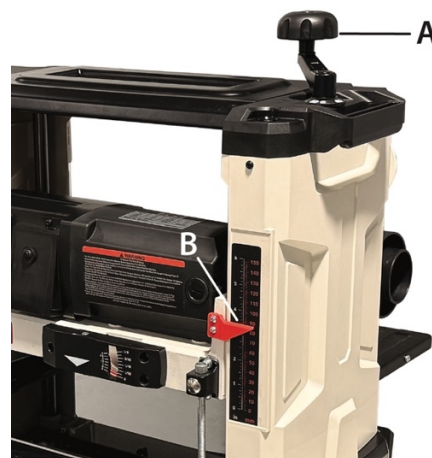


Figure 9-3

WARNING Never reach with your hands into the machine when guiding the workpiece.

WARNING Never force the workpiece into the machine by pushing or shoving. The machine will automatically draw the workpiece in using the infeed roller.

4. Slide workpiece slowly over the infeed table. It will then be automatically fed through the planer.
5. Release workpiece when the infeed roller starts automatically moving it through the planer.
6. Remove workpiece from outfeed side of planer after the outfeed rollers stop automatically moving it. For longer workpieces, be sure to support the workpiece as it exits the planer and outfeed table.
7. Switch machine off if no further planing is to be done immediately afterwards.

9.7 Planing Warped Wood

WARNING

Do not attempt to plane a board which is warped along its length. A warped board can jam itself against the cutterhead knives resulting in kickback and/or damage to the planer.

Note that if a significantly cupped board is fed into the planer, the feed rollers will press it flat for the pass, but the wood will spring back into cupped form when it has cleared the rollers. For best results, one side of the material should be run through a jointer to achieve a flat surface for planing. However, if a board is only moderately cupped, you may attempt to plane it.

If the board is narrow enough, consider using a table saw or band saw to rip the top of the warp before planing. If this is not practical, feed the board into the planer, concave side down, and plane the top until it presents a flat surface.

Turn the board over and plane the bottom edges until they are flush with the middle. After planing the board, use a table saw or band saw to square the board's edges with the top and bottom surfaces.

Cupping can often be diminished by ripping the board into narrower pieces on a table saw or band saw. See Figure 9-4.

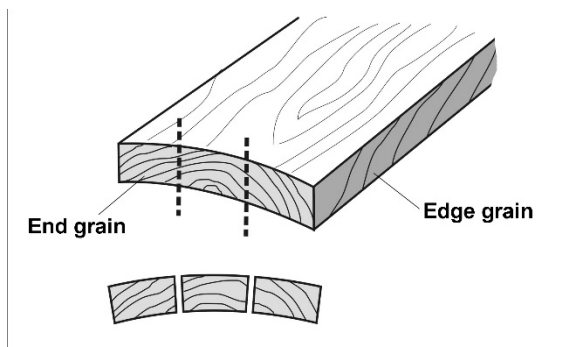


Figure 9-4: Cupping Reduction

9.8 Grain Direction

Always feed the board so the knives are cutting in the same direction as the wood grain, as shown in Figure 9-5. If you cut against the grain, the wood can

“chip out” leaving an undesirable finish. See Figure 9-6.

TIP: On rough lumber, you may need to rip one edge on a table saw or band saw to more easily observe a board's grain direction. Also, the grain on some wood species may change direction in the middle of the board – if possible, cut the board in the middle so the grain direction will be consistent on both pieces. Otherwise, use personal judgment as to which direction is more favorable and safer for feeding.

Edge grain (see Figure 9-4) may be planed if the stock is wide enough to rest firmly upon the table.

Do not attempt to plane end-grain (see Figure 9-4) as this can result in splintering of the stock and potential kickback.

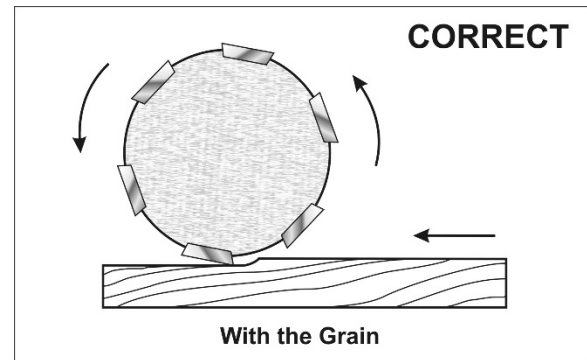


Figure 9-5

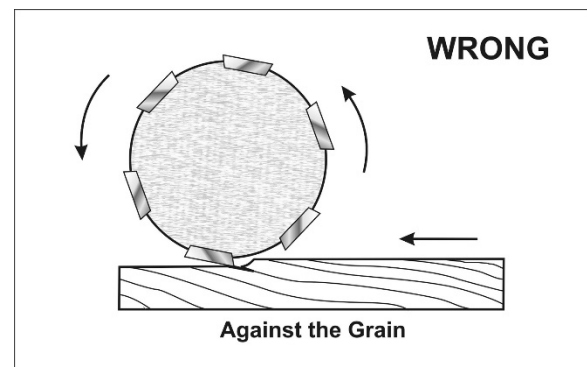


Figure 9-6

9.9 Knots and Trouble Spots

Wood with knots, “wild” grain, or extensive figuring is always difficult to surface and requires extra care. Check that any knots are solid. Do not plane stock with loose knots. Take light cuts. Be especially cautious of kickbacks and stop cutting immediately if the board will not feed smoothly.

9.10 Snipe

Snipe refers to a depression at either end of the board caused by an uneven force on the cutterhead when the work is entering or leaving the planer. Snipe may occur when the board is not supported properly or when only one feed roller is in contact with the board at the beginning or end of the cut.

If the snipe is deep, be more careful how the board is supported. Keep it parallel to and flat on the table at all times. Use an extra support, such as a roller stand, at both the infeed and outfeed ends of the planer.

Other methods to prevent snipe are reducing the depth of cut, and feeding additional boards butted closely to leading and trailing ends of the workpiece.

If snipe cannot be avoided, cut the material longer than needed and trim the ends after planing.

9.11 Ridges

Damaged or nicked knives can leave ridges along the length of a board.

Always inspect each board carefully before attempting to plane it. Do not attempt to plane second-hand lumber with nails below the surface, painted wood, plywood, hardboard, wood with a glue bead, or any material other than solid wood.

⚠ WARNING

Do not attempt to plane second-hand lumber, painted or varnished wood, plywood or particle board. These materials can damage planer knives. Failure to comply may cause serious injury.

9.12 Planing Rough Lumber

⚠ CAUTION

Make sure wood is properly dried before planing. Wet or “green” lumber may clog the machine and lead to damage.

Air-dried wood should stand for at least a year per inch of thickness of the rough-cut stock. The moisture content of air-dried wood should be about 12% to 15%. Kiln-dried woods should have a moisture content of approximately 10%. Wood to be used in fine furniture should have a moisture content of 7% to 8%.

Joint one edge of the rough-cut lumber before planing. This will help you determine the direction of grain travel. Feed the board into the planer so the knives cut with the grain, see Figure 9-5.

Measure the rough lumber at several locations to find the thickest part. As wood dries, its dimensions vary, including its thickness. Set the planer to take a very shallow cut on the highest, thickest part of the board. Continue to take very shallow cuts until you can determine whether there are any knots or unusual grain patterns.

After completing one side, inspect the opposite side for irregularities, then process it using the same procedure as for the first side.

9.13 Planing Glued-Up Boards

⚠ WARNING

Glued-up stock must dry at least 24 hours before being planed. Failure to comply may cause the stock to separate in the planer, leading to kickback and serious injury.

The JWP-13BTK and JWP-13BTHH planers are designed for planing solid wood. Other material, including glue, will dull or damage the knives. However, when you need to “true-up” glued-together stock, follow these suggestions.

As you glue the stock, scrub off any excess glue from the surface with a wet rag. This prevents glue beads from forming on the wood surface. Allow the glue to dry at least 24 hours. Check the surface for any glue that you missed and remove with a scraper, chisel, or sander.

Set the cutterhead for a shallow depth of cut. When you are finished planing the glued-up board, unplug the planer and check planer knives for built-up pitch or other signs of wear.

10.0 User-Maintenance

⚠ WARNING

Disconnect power to planer (unplug) before performing any maintenance. Failure to comply may result in serious personal injury.

⚠ WARNING

Burning hazard! Right after planing the planer knives may be hot – let the machine cool down before servicing.

⚠ CAUTION

The machine's plastic parts may be affected and damaged by the use of solvents. Never let gasoline, petroleum-based products, or similar substances come in contact with the plastic parts of the machine. These substances contain chemicals that may damage, weaken, or destroy plastics.

A regular, periodic schedule of simple maintenance procedures can greatly extend the machine's life.

10.1 General Cleaning

Periodically, use a brush or vacuum to clear dust and chips from inside the machine. Do not use bare hands.

Wipe the tables clean with a soft rag. In addition, a light coat of non-silicone paste wax applied periodically to the tables will promote smooth feeding of stock. Do not use silicone-based protectants on the tables, as it may impede proper sealing or varnishing of the finished piece.

Remove dirt and wood dust with a clean cloth.

Remove planing chips and wood dust from all accessible areas, including the dust port and/or the slot in the cutterhead cover (e.g., with a vacuum cleaner).

Clean both infeed and outfeed rollers. Any deposit on the rollers can be removed with a nonflammable cleaning agent for rubber rollers.

10.2 Periodic Cleaning

Refer to Figure 10-1.

Soiling of the machine by wood dust or dirt may be the reason for poorly planed workpieces. For perfect planing results the machine should be periodically cleaned, and the bearing surfaces of the tables waxed.

1. Unplug power cable.
2. Fold down both infeed and outfeed tables.
3. Loosen the four dust port mounting screws (A, Figure 10-1). Note: Only loosen the screws. They do not need to be removed.
4. Remove the dust port and clean with cloth.
5. Loosen the two cutterhead cover screws located on each end of the cutterhead cover (B,

Figure 10-2). Note: Only loosen the screws. They do not need to be removed.

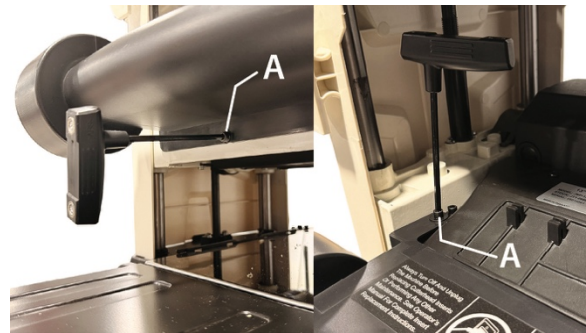


Figure 10-1

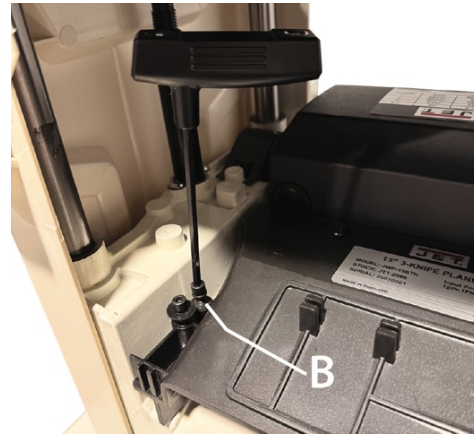


Figure 10-2

6. Remove the cutterhead cover and clean with cloth.
7. Using a vacuum cleaner, remove planing chips from:
 - Height adjustment
 - Cutterhead
 - Motor ventilation slots
8. Clean guide bars and spindles of the height adjustment with spray oil (e.g. WD-40), then apply a light film of medium viscosity machine oil.
9. Replace and fasten the cutterhead cover.
10. Replace and fasten the dust port.
11. Apply a light coat of wax for better gliding of the workpiece on:
 - Infeed table
 - Center table
 - Outfeed table

Note: Apply only a thin coat of wax. Too much wax may be absorbed by the wood, causing discoloration.

10.3 Cleaning the motor

When kept clean, the motor requires no maintenance.

- Remove oil or wood dust buildup on or in the motor.
- Motor bearings do not require any lubrication. The feed rollers are made of rubber material and should be inspected after every hour of operation.

The planer knives should also be lightly oiled to prevent rust.

All bearings in this machine are lubricated with a high-grade grease. Under normal operating conditions, this provides sufficient lubrication for the machine's entire service life. Additional lubrication is not required.

10.4 Lubrication

Periodically check that guide bars and spindles of the height adjustment are clean and lightly oiled. Use a medium-viscosity machine oil.

11.0 Troubleshooting

Symptom	Possible Cause	Correction*
Planer will not start.	No incoming power.	Check plug connection.
	Low voltage.	Have power line inspected for proper voltage.
	Circuit breaker on planer motor tripped.	Allow motor to cool and press reset switch.
	Fuse blown or breaker tripped at panel.	Check power source. Replace fuse or reset breaker.
	Motor brushes worn or damaged.	Inspect and replace brushes if needed.
	Short circuit in line cord or plug.	Inspect cord or plug for damaged insulation and shorted wires.
	Defective or loose switch or wiring.	Have a qualified electrician inspect switch and wiring.
	Motor failure.	Have motor inspected by qualified personnel.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
Motor stalls or overheats, resulting in tripped breaker.	Motor overloaded.	Reduce load on motor; try less depth of cut or slower feed rate. Make sure knife inserts are sharp.
	Low voltage.	Correct the low voltage conditions.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
	Motor failure.	Have motor inspected by qualified personnel.
Machine slows when operating.	Cutting too deeply.	Select shallower depth of cut.
	Drive belt is loose (stretched).	Replace belt.
	Motor brush failure.	Inspect and replace brushes if needed.
Snipe.	Dull knife inserts.	Rotate or replace knife inserts.
	Inadequate support of long boards.	Use an assistant or roller stand to support long workpieces.
	Lumber is not butted properly.	Butt the stock pieces end-to-end as they pass through the planer.
	Cutterhead not parallel to table.	Contact JET technical service.
Fuzzy grain.	Wood has high moisture content.	Remove moisture by drying or use different stock.
	Dull knife inserts.	Rotate or replace knife inserts.
Torn grain.	Too heavy a cut.	Remove less material.
	Knives cutting against grain.	Cut with the grain.
	Dull knife inserts.	Rotate or replace knife inserts.
Rough/raised grain.	Dull knife inserts.	Rotate or replace knife inserts.
	Too heavy a cut.	Reduce depth of cut and make more passes.
	Wood has high moisture content.	Remove moisture by drying or use different stock.
Poor feeding of lumber.	Excessive warpage of stock.	Use different stock.
	Planer bed rough or dirty.	Clean pitch and residue; wax planer bed.
	Feed roller surfaces are dirty.	Clean feed rollers with cloth and mild cleaner.
	Dull knives, or debris building up on cutterhead.	Clean cutterhead; rotate or replace knife inserts; clean out dust hood if being used.
	Drive belt slipping or damaged.	Replace belt.

Symptom	Possible Cause	Correction*
Uneven depth of cut side to side.	Knife projection is not uniform.	Inspect all knife inserts for positioning and tightness.
	Table is not parallel to cutterhead.	Contact JET technical service.
Head difficult to adjust.	Lack of lubrication on corner posts and lead screws.	Lubricate posts and lead screws.
Head cannot be lowered.	Thickness gauge is preventing further movement.	Reset thickness gauge dial setting.
	Buildup of debris on leadscrews and/or columns.	Clean affected areas, and re-grease.
Board thickness doesn't match thickness scale.	Thickness scale out of adjustment.	Recalibrate thickness scale/cursor, and make test cuts.
Chain keeps coming off sprocket(s).	Chain or sprocket(s) are worn.	Inspect and replace as needed.



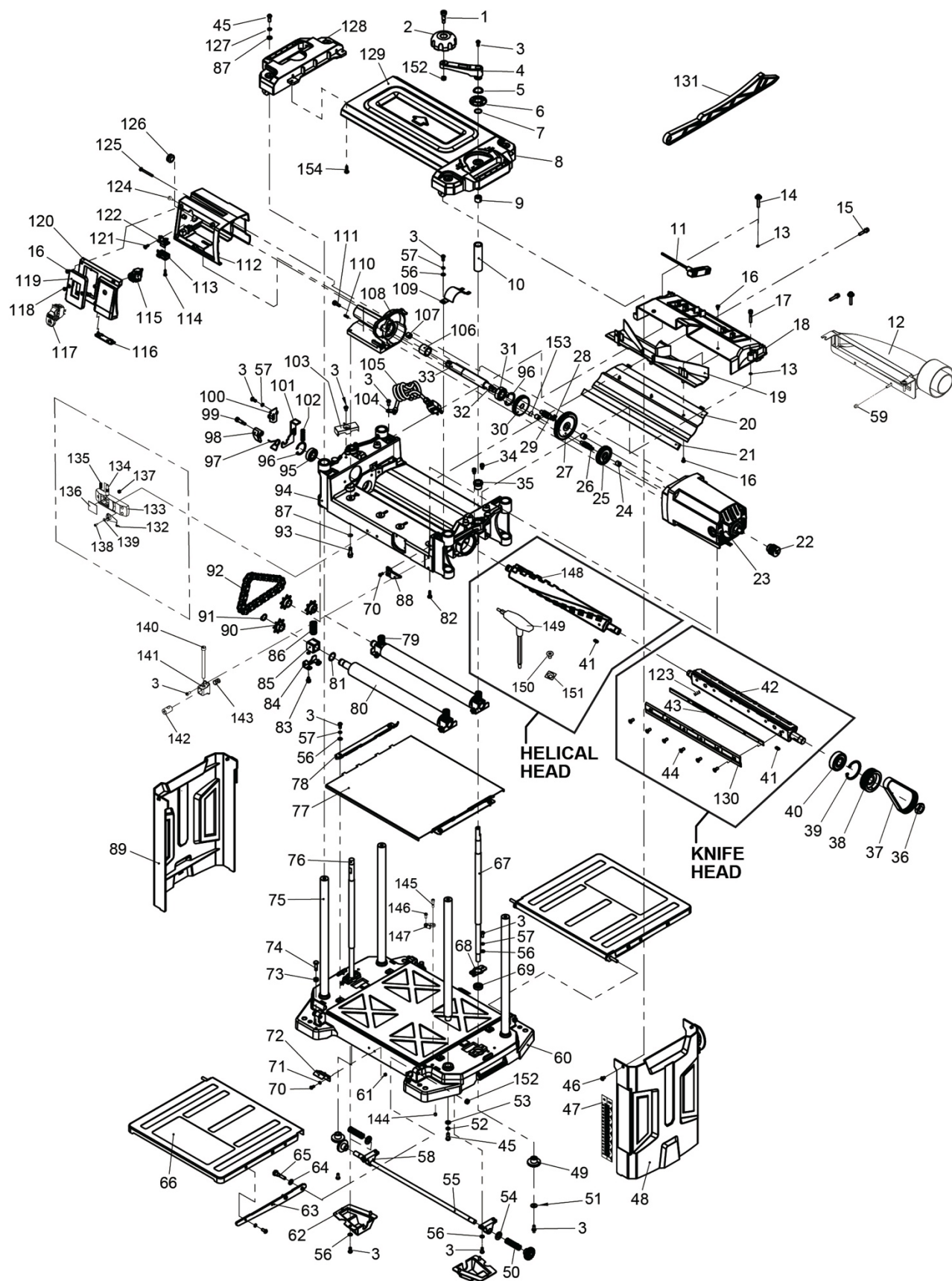
Some corrections may require a qualified electrician.

12.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores or may be ordered from JET. Some parts are shown for reference only and may not be available individually.

12.1.1 Benchtop Planer Assembly – Exploded View



12.1.2 Benchtop Planer Assembly – Parts List

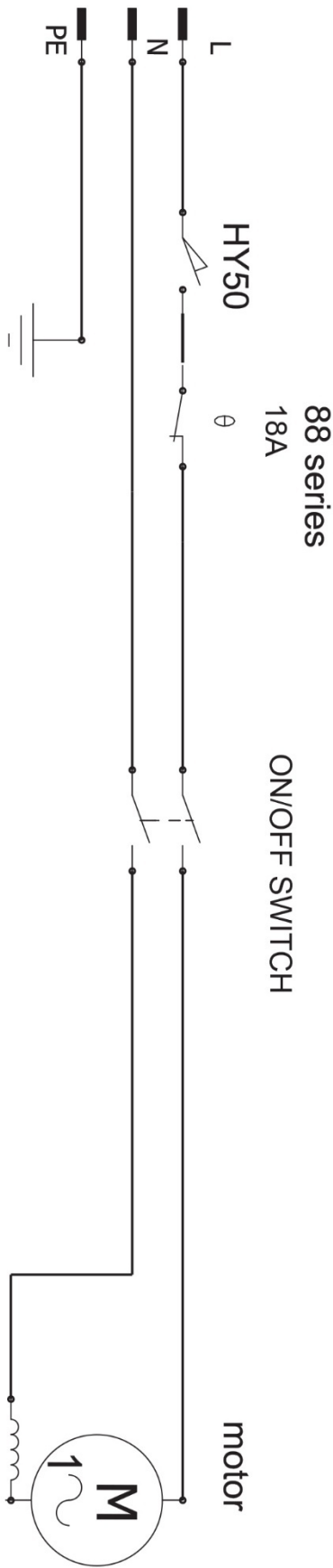
Index No	Part No	Description	Size	Qty
1	JT1-3338	Hex Socket Head Shoulder Screw	M8×16	1
2	JT1-3388	Lifting Handle		1
3	JT1-3396	Socket Head Button Screw	M5×12	33
4	JT1-3402	Lifting Crank		1
5	**	Wave Spring Washer		1
6	JT1-3414	Scale		1
7	JT1-3422	Retaining Rings, EXT	M18	1
	JT1-3499	Lifting Handle Assembly (includes #1-7, & 152)		1
8	JT1-3430	Upper Right Cover		1
9	JT1-3434	Needle Roller Bearing		2
10	JT1-3352	Limit Sleeve		1
11	JT1-3339	L-Shaped Magnetic Hex Wrench		1
12	JT1-3333	Dust Port		1
13	JT1-3374	O-Ring	φ6×φ1.5	4
14	JT1-3378	Hex Screw with Large Flat Washer Assembly		2
	**	Socket Head Cap Screw	M5×30	
	**	Flat Washer	M5	
15	JT1-3384	Hex Screw, Spring Washer and Flat Washer Assembly		2
	**	Socket Head Cap Screw	M5×25	
	**	Flat Washer	M5	
	**	Lock Washer	M5	
16	**	Phillips Screw	ST4.2×10	9
17	JT1-3386	Hex Screw and Spring Washer Assembly		2
	**	Socket Head Cap Screw	M5×30	
	**	Lock Washer	M5	
18	JT1-3343	Dust Plate		1
19	JT1-3387	Dust Groove		1
20	JT1-3344	Scraper Plate		1
21	JT1-3389	Sponge Strip		1
	JT1-3500	Scraper Plate Assembly (includes #20 & 21)		1
22	JT1-3351	Motor Multi-V Belt Pulley		1
23	JT1-3332	Motor		1
24	JT1-3390	Copper-Based Powder Metallurgy Bearing 1		2
25	JT1-3391	1st Stage Shaft Bevel Gear		1
26	JT1-3392	1st Stage Gear Shaft		1
27	JT1-3393	2nd Stage Shaft Gear		1
28	JT1-3394	Flat Key	3×3×8	2
29	JT1-3395	2nd Stage Gear Shaft		1
30	JT1-3397	Output Shaft Gear		1
31	JT1-3398	Powder Metallurgy Bearing 1		1
32	**	Flat Key	C4×4×10	1
33	JT1-3399	Gearbox Output Shaft		1
34	**	Socket Head Button Screw	M5×10	4
35	JT1-3400	Lifting Screw Nut		2
36	JT1-3345	Hex Thin Nut	M16P1.5	1
37	JT1-3334	PJ Multi-V Belt		1
38	JT1-3342	Driven Multi-V Belt Pulley		1
39	JT1-3401	Retaining Ring, INT	M47	1
40	JT1-3403	Deep Groove Ball Bearing	6303-2RZ	1
41	JT1-3404	Flat Key	4×4×12	1
42	JT1-3405	3-Flute 3-Hole Planer Cutter Shaft (Knife Head Only)		1
43	JT1-3406	Planer Cutter, 3 Cutters Per Set (Knife Head Only)		1
44	JT1-3329	Socket Head Button Screw (Knife Head Only)	M6×16	18
45	JT1-3407	Hex Screw, Spring Washer and Flat Washer Assembly		8
	**	Socket Head Cap Screw	M6×15	
	**	Flat Washer	M6	
	**	Lock Washer	M6	

Index No	Part No	Description	Size	Qty
46	**	Phillips Screw	ST4.2×10	4
47	JT1-3408	Lifting Scale		1
48	JT1-3409	Right Side Cover		1
49	JT1-3410	Bevel Gear		4
50	JT1-3411	Gear Shaft Compression Spring		2
51	**	Fender Washer	M5	2
52	**	Spring Washer	M6	5
53	**	Flat Washer, Class C	M6	4
54	**	Flat Washer, Class C	M10	2
55	JT1-3412	Bevel Gear Connecting Shaft		1
56	**	Flat Washer, Class C	M5	18
57	**	Lock Washer	M5	36
58	JT1-3413	Bevel Gear Seat		2
59	**	Hex Nut, Nylon Lock	M5	2
60	JT1-3415	Base		1
61	**	Hex Nut, Nylon Lock	M4	4
62	JT1-3416	Gear Cover		2
63	JT1-3417	Extension Bracket		4
64	**	Saddle Spring Washer	M8	4
65	JT1-3418	Hex Socket Hex Head Eccentric Shoulder Screw		4
66	JT1-3346	Auxiliary Worktable		2
67	JT1-3419	Right Lifting Screw		1
68	JT1-3420	Bearing Pressure Plate		2
69	JT1-3421	Deep Groove Ball Bearing	61900-2RZ	2
70	**	Hex Socket Pan Head Screw	M4×10	6
71	**	Lock Washer	M4	4
72	JT1-3423	Spring Steel Sheet		2
73	**	Hex Nut	M6	9
74	JT1-3424	Hex Cap Screw	M6×20	4
75	JT1-3425	Guide Post		4
76	JT1-3426	Left Lifting Screw		1
77	JT1-3427	Worktable Pad		1
78	JT1-3428	Pad Press Strip		2
79	JT1-3429	Rubber Roller Compression Reinforcement Spring		1
80	JT1-3347	Roller		2
81	JT1-3431	Rubber Roller Gasket		4
82	JT1-3432	Cross Recessed Hex Head Flange Self-Tapping Screw	ST4.8×16	4
83	**	Phillips Screw, Spring Washer and Flat Washer Assembly		8
	**	Pan Head Machine Screw	M5×10	
	**	Flat Washer	M5	
	**	Lock Washer	M5	
84	JT1-3433	Roller Pressure Plate		4
85	JT1-3336	Roller Bearing		4
86	JT1-3335	Rubber Roller Compression Spring		3
87	**	Flat Washer	M6	6
88	JT1-3337	Pointer		1
89	JT1-3330	Left Side Cover		1
90	JT1-3348	Reduction Sprocket		3
91	**	Retaining Rings, EXT	M15	3
92	JT1-3331	Reduction Chain		1
93	JT1-3435	Hexagon Screw and Spring Washer Assembly		2
	**	Socket Head Cap Screw	M6×20	
	**	Lock Washer	M6	
94	JT1-3349	Lifting Seat		1
95	JT1-3436	Deep Groove Ball Bearing	6002-2RZ	1
96	JT1-3437	Retaining Ring, INT	M32	2
97	JT1-3438	Sprocket Tension Torsion Spring		1
98	JT1-3439	Sprocket Tension Plate		1
99	JT1-3440	Hex Screw		1

Index No	Part No	Description	Size	Qty
100	JT1-3353	Cutter Shaft Positioning Plate Pressure Plate		1
101	JT1-3354	Cutter Shaft Positioning Plate		1
102	JT1-3355	Cutter Shaft Positioning Compression Spring		1
103	JT1-3356	Wire Fixing Plate		1
104	JT1-3357	Wire Mounting Fastener - UL-1/4		1
105	JT1-3358	Plug Power Cord		1
106	JT1-3359	Powder Metallurgy Bearing 2		1
107	JT1-3360	Copper-Based Powder Metallurgy Bearing 2		2
108	JT1-3361	Gearbox Housing		1
109	JT1-3362	Belt Cover		1
110	**	Cylindrical Pin	φ4×12	2
111	**	Pan Head Machine Screw	M4x12	3
112	JT1-3363	Electrical Box		1
113	JT1-3364	Micro Switch - HY50 - Long Handle		1
114	**	Phillips Screw	ST3.5×16	1
115	JT1-3340	Overcurrent Protector		1
116	JT1-3365	Light cover		1
117	JT1-3366	Electromagnetic Switch - KJD20-2		1
118	**	Phillips Screw	ST3.5×9.5	2
119	JT1-3350	Switch Panel		1
120	JT1-3367	Electrical Box Panel		1
121	**	Phillips Screw	ST4.2×12.7	2
122	JT1-3368	Limit Switch Base		1
123	JT1-3369	Planer Knife Shaft Compression Spring (Knife Head Only)		6
124	**	Phillips Screw, Spring Washer and Flat Washer Assembly		1
	**	Pan Head Machine Screw	M4×12	
	**	Flat Washer	M4	
	**	Lock Washer	M4	
125	JT1-3370	Pan Head Machine Screw	M4×40	1
126	JT1-3371	Wire Sheath		1
127	**	Lock Washer	M6	4
128	JT1-3372	Upper Left Cover		1
129	JT1-3373	Upper Cover		1
130	JT1-3375	Planer Knife Press Strip (Knife Head Only)		3
131	JT1-3376	Push Stick (Long)		1
132-139	JT1-3377	Cutting Depth Display Assembly		1
132	**	Depth Probe Pointer		1
133	**	Cutting Depth Display Box		1
134	**	Probe		1
135	**	Probe Compression Spring		1
136	**	Box Cover		1
137	**	Hex Nut	M4	1
138	**	Pan Head Machine Screw	M4×10	1
139	**	Positioning Sleeve		1
140	JT1-3379	Height Limit Rod		1
141	JT1-3380	Height Positioning Seat		1
142	JT1-3381	Limit Block		1
143	**	Scale Compression Spring		1
144	**	Hex Nut, Nylon Lock	M5	1
145	**	Socket Head Cap Screw	M5×20	1
146	**	Hex Cap Screw - Grade 8.8 – Black Oxide Coated	M5×8	1
147	JT1-3382	Height Positioning Block		1
148	JT1-3341	Helical Cutter Assembly (Helical Head Only)		1
149	JT1-3383	Hex Wrench (Helical Head Only)		1
150	**	Hex Screw - M5×10 (Helical Head Only)		30
151	JT1-3385	Knife (Helical Head Only)		30
152	**	Hex Nut, Nylon Lock	M6	5
153	**	Retaining Rings, EXT	M12	1
154	**	Phillips Screw	ST5.5x16	4

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

13.0 Electrical Schematic



14.0 Warranty and Service

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

Warranty Period

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

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

Who is Covered

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

What is Covered

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

Warranty Limitations

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

How to Get Technical Support

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

More Information

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

How State Law Applies

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

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

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

Product Listing with Warranty Period

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

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



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