

Jet or Powermatic 64A Insert

(46J85.05)

The following instructions were provided by the manufacturer.

*Fits **Jet** models: JTS-10, JCS-10, JWTS-10, JTAS-10, JWCS-10 and **Powermatic #64** and **#64A** (and other makes with 3-9/16" x 12-1/2" x 7/16" deep opening)

Warnings

- Disconnect saw from power source before fitting or removing insert.
- Always wear eye protection.
- Be sure blade is not in contact with insert before switching on.
- Do not attempt to tilt the arbor while the blade is in the insert! The blade will bind, causing severe damage and possible injury! For bevelled cuts, a separate, dedicated insert must be prepared. Pre-set the angle and then proceed as instructed below.
- Insert must be securely clamped down with a board before plunging blade up through it to cut kerf.
- If using blade stabilizers, check clearance before raising blade.

Installing and Fitting Your Insert

- Lower the blade completely.
- Place insert in table with pin at front and starter pocket located over blade.
- Run levelling screws down until insert is stable and flush with table top. (Use a 3/32" hex allen wrench.)
- Back out front end adjustment screw and side adjustment screw to achieve a fit that is snug yet removable.
- If the insert will not go down flush with table top because it is resting on top of blade, then raise up using levelling screws until insert is sitting steady about 1/16" above table top. This should provide adequate clearance for blade.
- *Splitter:* If your saw has a splitter, you'll need to cut a slot at the rear of the insert to accommodate it. Trace the outline of the slot from your original metal insert and

cut with bandsaw or hacksaw. Leave the bridge between the splitter and the blade slot as thick as possible.

Cutting the Blade Slot (Kerf)

- Check that insert is fitted properly and blade is clear. Using a stick, reach under the table and rotate the blade manually to check for blade clearance.
- Fully cover the insert with a board and clamp at each end to the table saw top.
- Reconnect power to saw. Switch on. Slowly and cautiously raise blade up to cut its way through the insert. **Keep hands off of table top, stay clear and wear eye protection.** Raise blade to maximum height at this time.
- Lower blade, turn off saw and remove board. Your insert is now ready for use!

Important Tips for Use

- Only recommended for use with carbide-tipped cutters.
- *Dado Blade* — Use same procedures outlined above, but use additional caution due to excessive material being machined from insert during the slotting procedure.
- Under certain conditions your saw blade may generate an undesirable scraping noise. Planer type blades and/or excessive arbor run-out and/or blade distortion may be causing intermittent contact with insert slot. To remedy this, remove the insert and slightly widen the slot using a file or sanding paddle.
- Ideally, a separate insert should be used with each blade, dado stack, or angle set-up. This will ensure a true "zero-clearance" effect and give you maximum benefit from your inserts.