

## JET JPM-13CS 13" Planer/Molder

Having a planer in the shop is a huge step in the right direction towards making straight projects. Being able to create custom moldings with the same machine enhances that value – and your potential project list - substantially.

The JET 13" Planer/Molder has been designed and built with the home woodworking shop in mind. It embodies a perfect balance of capacity and function along with our legendary JET durability in a space-saving 23 31/32"W x 36 1/2"D x 43 1/2"H package. Add a budget-saving price and the JET 13" Planer/Molder is hard to pass up.



The JET JPM-13CS 13" Planer/Molder features the capacity, durability and ease of use that will make your shop more effective without breaking the bank!

### Power Base



The 1 1/2 HP motor (left) has plenty of power for planing and molding operations. Wheels built into the base cabinet (right) make moving the machine easy. The pedal locks and unlocks the wheels.



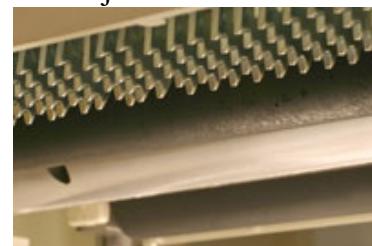
The JET 13" Planer/Molder comes built on an all-steel cabinet. The cabinet has internal wheels that make moving this 225-lb machine where you have the most room easy. The wheels lock to keep the JET 13" Planer/Molder stationary when in use.

Also within the cabinet is the 1 1/2Hp, 115/230V, 3450-RPM

motor. Our motors are rated using a continuous duty cycle to give the truest indication of the power generated, unlike the "peak" or "max developed" figures so many others use. The motor delivers its power to the cutterhead assembly through a pair of V-belts running in precision-machined multi-groove pulleys. A removable side door on the cabinet provides access to the motor and its belt-tensioning mount should adjustment become necessary in the future.

### Cutting and Feeding

The JET 13" Planer/Molder features an all steel, precision machined 2 9/16"-diameter cutterhead fitted with three full-width knives. The knives are retained by three-piece wedge-shaped gibs that allow installing many molding knife profiles without removing the planer blades.



The anti-kickback fingers, rubber-covered feed rollers and the precision cutterhead make this machine safe and effective.



The straight planing knives are retained with gib bars, broken into three segments to accommodate the molding knives. A jack screw under each end of the planing knives and this easy to use knife height gauge make setting this machine up fast and simple.

wrench and brass drift rod and then remove the spacers between it and the planing knife. Insert the molding knife and align it before tightening the gib bar. We even include a simple molding knife gauge that makes getting all three molding knives perfectly aligned with each other fast and easy.

Rubber covered infeed and outfeed rollers keep the stock moving at a consistent pace to make the best use of the 13,500 CPM (cuts per minute) generated by the cutterhead turning at 4500 RPM. The rubber feed roller surface gets a good grip on the wood without marring the profiled surface of molded wood. Both of the feed rollers are easily adjustable to maintain their performance. The feed roller adjustments are located on the top of the JET 13" Planer/Molder to be easily accessible without having to take the machine apart.



Behind the cover on the left is the feed rate gear set. Swapping these gears on their shafts changes the feed rate from 10 FPM to 20 FPM as shown on the diagram on the cover.

Knife height is critical to the performance of any planer and the longevity of the cutting edge. We incorporated jacking screws near each end of the planing knives to make setting them simple. We also include an easy to use knife setting gauge that allows getting all of the knives level and equal in height to each other. That insures that they share the workload equally to create the best possible surface on the wood and to maintain their cutting edges longer.

The center gib section makes installing most molding knives (2"-wide and under) easy. Simply loosen the center gib bar with the included



Installing molding knives 2"-long and under does not require removing the planing knives or the outboard gib bars. The spacers seen here are replaced with the molding knife and the same short gib bar is used to secure it.



The JET 13" Planer/Molder has two feed rates, 20FPM (feet per minute) used primarily for dimensioning wood when lots of material is being removed quickly. 10FPM is used for finish cuts when the smoothest possible surface is desired. This slower feed rate is also used for molding operations.

Reversing the drive gears on their shafts changes the feed rate. Those gears are beneath an easy to remove cover on the side of the JET 13" Planer/Molder.

Just inside the infeed side of the cutterhead housing is a row of steel anti-kickback fingers. These fingers are gravity operated and each works independently to accommodate whatever material width is presented. Anti-kickback fingers help keep the wood within the cutterhead housing should something go wrong during the cutting.

## Table and Extensions



The main cast iron table and the twin-roller extensions add up to 36 1/2" of support that makes working with large pieces of wood much easier.

The JET 13" Planer/Molder has a 19 1/4"-long by 14"-wide cast iron main table. A precision-ground steel column at each corner guides the main table. The table is raised and lowered through its 6" of available travel by lead screws on either side, driven by an easy to use hand crank on top of the machine. Handy metric and inch scales flank the infeed housing opening to make adjusting cut depth simple and accurate. Each scale has its own adjustable pointer.

The 8 1/2"-long by 14 1/2"-wide two-roller extension tables expand the overall support surface to 36 1/2" and makes working with even large pieces easy and accurate. The tables have a simple two-bolt mount on either side that makes adjusting them to match the main table surface fast and easy.