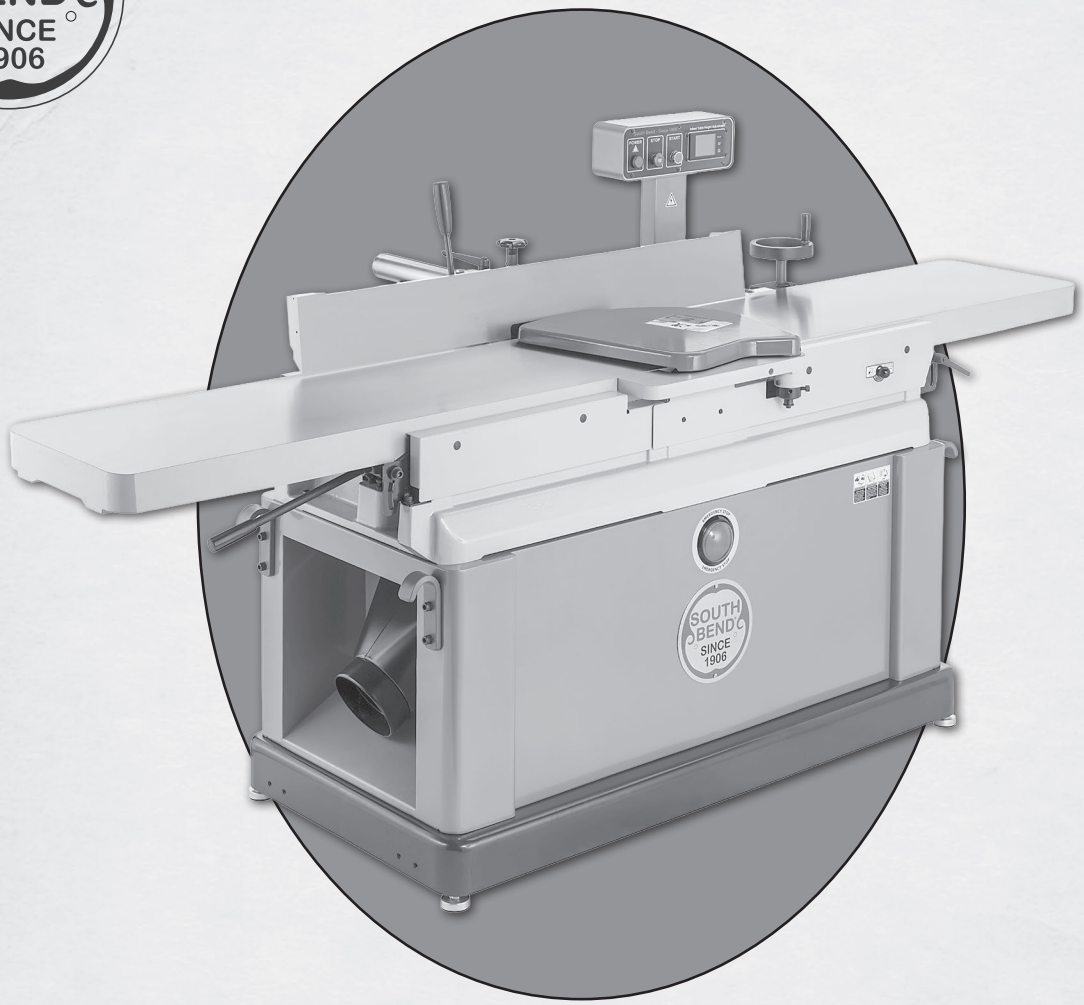
16" PARALLELOGRAM JOINTER WITH HELICAL CUTTERHEAD & DRO

MODEL SB1131/SB1132

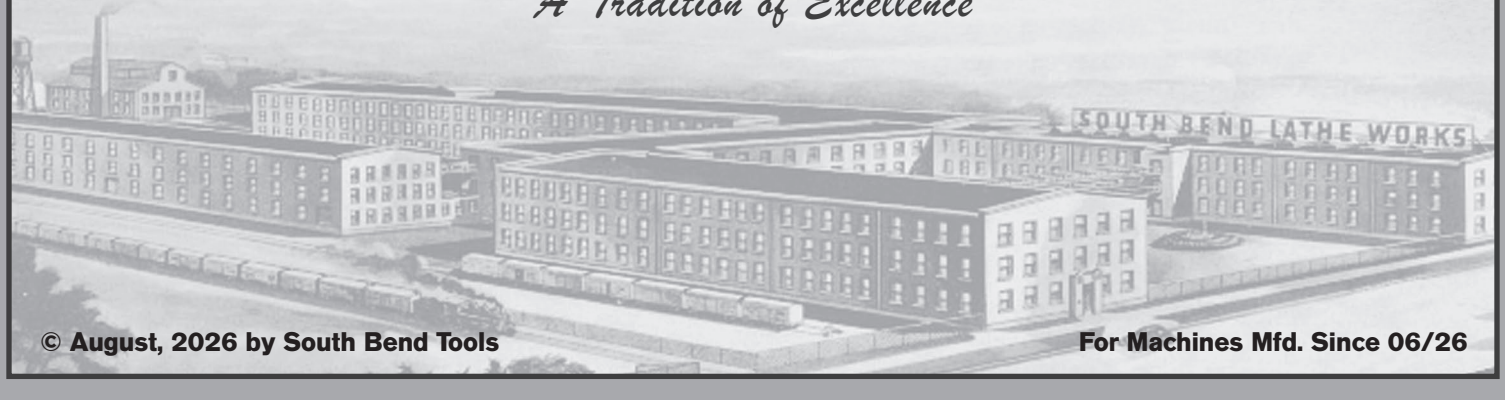


****Keep for Future Reference****

OWNER'S MANUAL

South Bend Tools®

A Tradition of Excellence



© August, 2026 by South Bend Tools

For Machines Mfd. Since 06/26

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

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

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

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

⚠ WARNING!

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

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

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as a dust mask or respirator that is specially designed to filter out microscopic particles.

Table of Contents

INTRODUCTION 2
Scope of Manual 2
Manual Feedback 2
Updates 2
Customer Service 2
Identification 3
Description of Controls & Components 4
Product Specifications 6

SAFETY 10
Understanding Risks of Machinery 10
Basic Machine Safety 10
Additional Jointer Safety 12

PREPARATION 13
Preparation Overview 13
Required for Setup 13
Power Supply Requirements 14
Converting Voltage to 440V (SB1132) 16
Correcting Phase Polarity (SB1132) 17
Unpacking 18
Inventory 18
Measuring Hardware 19
Cleaning & Protecting 20
Location 21
Lifting & Placing 22
Mounting 23
Leveling 24
Assembly 25
Dust Collection 27
Power Connection 28
Test Run 29
Inspections & Adjustments 30

OPERATION 31
Operation Overview 31
Stock Inspection & Requirements 32
Squaring Stock 33
Surface Planing 34
Edge Jointing 35
Bevel Cutting 36
Rabbet Cutting 37
Setting Depth of Cut 38

ACCESSORIES 39

MAINTENANCE 42
Maintenance Schedule 42
Cleaning 42
Unpainted Cast Iron 42
Lubrication 42
Machine Storage 43

SERVICE 44
Checking/Adjusting Table Parallelism 44
Replacing Indexable Inserts 48
Setting Positive Stops 49
Calibrating DRO 49
Setting Outfeed Table Height 50
Checking/Adjusting Cutterhead Guard 51
Setting Fence Stops 52
Replacing/Tensioning V-Belt 54
Aligning Pulleys 55

TROUBLESHOOTING 56

ELECTRICAL 59
Electrical Safety Instructions 59
SB1131 Wiring Diagram 60
SB1132 Wiring Diagram 61
Electrical Components 62

PARTS 63
SB1131 Motor & Base 63
SB1131 Fence 65
SB1131 Table 67
SB1131 Controls 69
SB1131 Labels & Cosmetics 71
SB1132 Motor & Base 72
SB1132 Fence 74
SB1132 Table 76
SB1132 Controls 78
SB1132 Labels & Cosmetics 80

WARRANTY 81

Scope of Manual

This manual helps the reader understand the machine, how to prepare it for operation, how to control it during operation, and how to keep it in good working condition. We assume the reader has a basic understanding of how to operate this type of machine, but that the reader is not familiar with the controls and adjustments of this specific model. As with all machinery of this nature, learning the nuances of operation is a process that happens through training and experience. If you are not an experienced operator of this type of machinery, read through this entire manual, then learn more from an experienced operator, schooling, or research before attempting operations. Following this advice will help you avoid serious personal injury and get the best results from your work.

Manual Feedback

We've made every effort to be accurate when documenting this machine. However, errors sometimes happen or the machine design changes after the documentation process—so the manual may not exactly match your machine. If a difference between the manual and machine leaves you in doubt, contact our customer service for clarification.

We highly value customer feedback on our manuals. If you have a moment, please share your experience using this manual. What did you like about it? Is there anything you would change to make it better? Did it meet your expectations for clarity, professionalism, and ease-of-use?

South Bend Tools
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Bellingham, WA 98227
Email: manuals@southbendtools.com

Updates

For your convenience, any updates to this manual will be available to download free of charge through our website at:

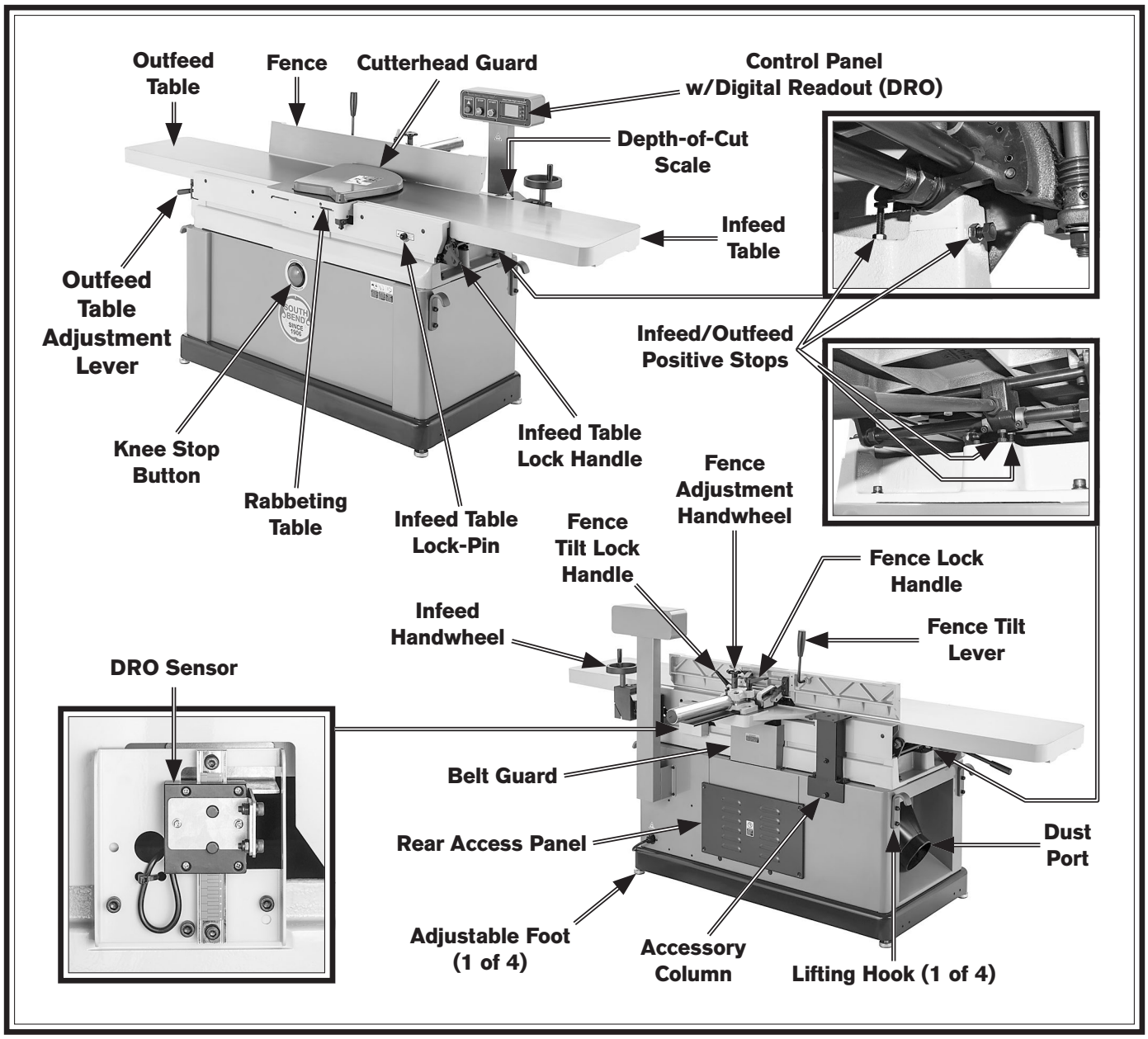
www.southbendtools.com

Customer Service

We stand behind our machines. If you have any service questions, parts requests or general questions about your purchase, feel free to contact us.

South Bend Tools
P.O. Box 2027
Bellingham, WA 98227
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Fax: (360) 734-1639 (USA Only)
Email: sales@southbendtools.com

Identification



⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

a) Wear eye protection.
b) Always keep cutterhead and drive guards in place and in proper operating condition. If removed, ALWAYS replace cutterhead guard immediately after rabbeting operations.
c) Never make cuts deeper than ⅛" per pass.
d) Always use hold-down or push blocks when jointing material narrower than 3" or planing material thinner than 3".
e) Never perform jointing, planing, or rabbeting cuts on pieces shorter than 18" in length.

Description of Controls & Components

Refer to **Figure 1–Figure 4** and the following descriptions to become familiar with the basic controls and components used to operate this machine.

Control Panel

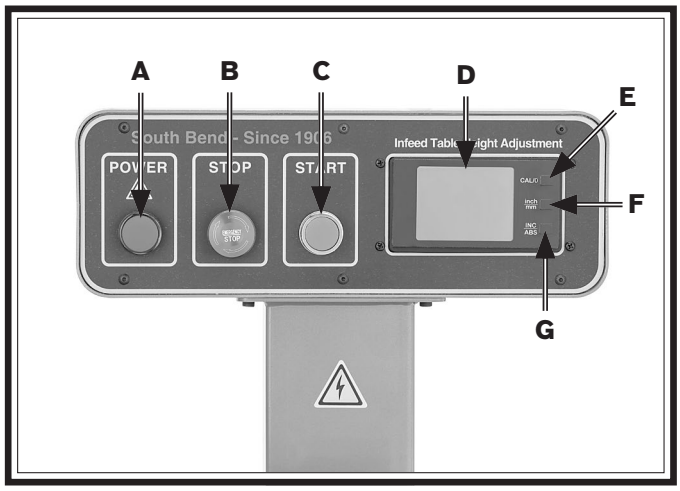


Figure 1. Control panel layout.

A. POWER Light: Illuminates when jointer is connected to power supply.

B. EMERGENCY STOP Button: Stops motor and disables START button while it remains depressed. Enable START button by turning EMERGENCY STOP button clockwise until it releases and pops out of depressed position.

C. START Button: Starts motor only if the EMERGENCY STOP button is released.

D. Digital Readout (DRO): Shows current infeed table cutting depth in inches or millimeters.

E. CAL/0 Button: Short press to reset INC value to zero; press and hold for 2 seconds to reset ABS value to zero.

F. INCH/MM Button: Press to toggle between inches and millimeters.

G. INC/ABS Button: Press to toggle between incremental and absolute measurement modes.

Safety & Support

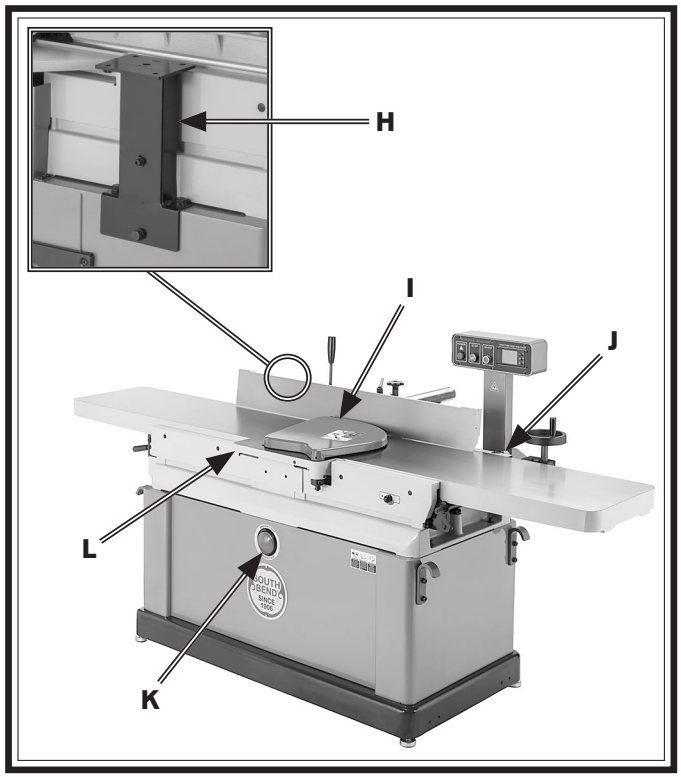


Figure 2. Safety and support features.

H. Accessory Column: Supports mounted power feeders or other accessories.

I. Cutterhead Guard: Covers cutterhead until workpiece pushes guard during operation. When workpiece leaves cutterhead, guard springs back to its starting position to minimize risk of accidental contact.

J. Depth-of-Cut Scale: Shows infeed table depth of cut setting (per pass).

K. Knee Stop Button: Stops power to motor when pressed. Can be pressed with your knee if both hands are holding workpiece.

L. Rabbeting Table: Provides workpiece support during rabbet cutting.

Tables & Fence

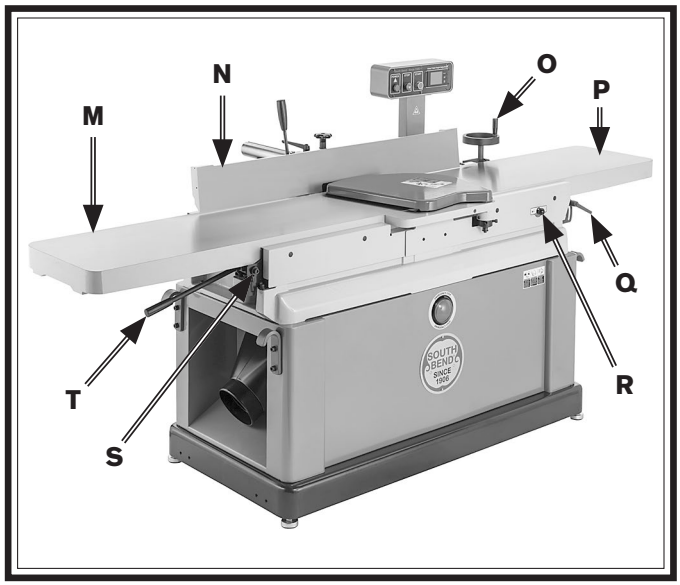


Figure 3. Tables and fence.

M. Outfeed Table: Supports workpiece after it passes over cutterhead. For optimum results, outfeed table must be adjusted evenly with highest point of cutterhead insert rotation or top dead center (TDC).

N. Fence: Supports workpiece laterally as it moves across cutterhead; determines angle of cut when edge or bevel jointing.

O. Infeed Handwheel: Raises or lowers infeed table to control depth of cut.

P. Infeed Table: Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead inserts determines depth of cut.

Q. Infeed Table Lock Handle: Tightens to secure table position; loosens for table adjustment.

R. Infeed Table Lock-Pin: Prevents depth of cut from exceeding ⅛" during operations. Pull and hold knob out to lower infeed table beyond ⅛" on depth-of-cut scale.

S. Outfeed Table Lock Screw: Tightens to secure table position; loosens for table adjustment.

T. Outfeed Table Adjustment Lever: Raises or lowers outfeed table.

Fence Controls

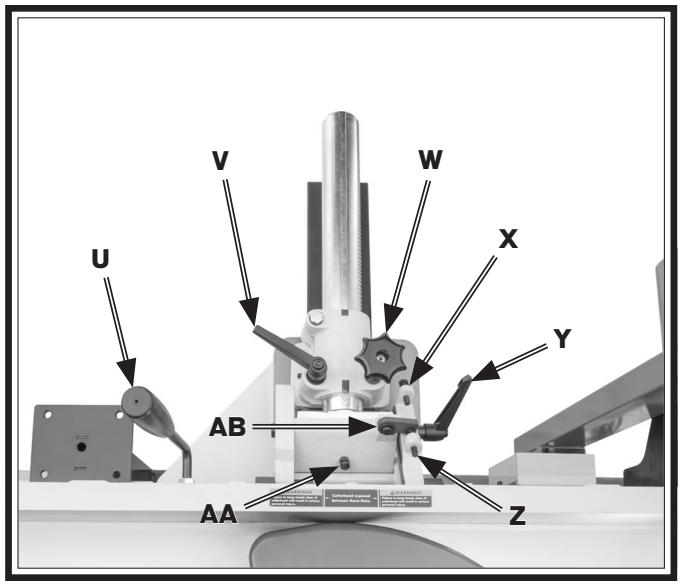


Figure 4. Fence controls.

U. Fence Tilt Lever: Tilts fence between 45°–135°.

V. Fence Lock Handle: Tightens to secure fence position along width of tables; loosens for fence adjustment.

W. Fence Adjustment Handwheel: Rotates to adjust fence position along width of tables.

X. 45° Fence Stop: Stops fence at 45° when swing stop is engaged.

Y. Fence Tilt Lock Handle: Tightens to secure fence at any position in available tilt range.

IMPORTANT: Always tighten tilt lock handle before starting machine—even when fence is resting against stops.

Z. 90° Fence Stop: Stops fence at 90° when swing stop is engaged.

AA. 135° Fence Stop: Stops fence at 135°.

AB. Swing Stop: Engages fence stops at 45° or 90°.

Product Specifications

P.O. Box 2027, Bellingham, WA 98227 U.S.A.
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Model SB1131
16" Parallelogram Jointer with Helical Cutterhead & DRO

Product Dimensions

Weight	1081 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	100 x 46-1/2 x 50 in.
Footprint (Length x Width)	55 x 27 in.

Shipping Dimensions

Type	Wooden Crate
Content	Machine
Weight	1451 lbs.
Length x Width x Height	105 x 43 x 51 in.
Must Ship Upright	Yes

Electrical

Power Requirement	230V, Single-Phase, 60 Hz
Full-Load Current Rating	23A
Minimum Circuit Size	30A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	120 in.
Power Cord Gauge	12 AWG
Plug Included	Yes
Included Plug Type	L6-30
Switch Type	Control Panel w/Magnetic Switch Protection

Motors

Main

Horsepower	5 HP
Phase	Single-Phase
Amps	23A
Speed	3450 RPM
Type	TEFC Capacitor-Start Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type	Internal

Main Specifications

Jointer Size	16 in.
Bevel Jointing	0 - 45 deg. L/R
Maximum Width of Cut	16 in.
Maximum Depth of Cut	1/8 in.
Minimum Workpiece Length	18 in.
Minimum Workpiece Thickness	1/2 in.
Maximum Rabbeting Depth	3/4 in.
Number of Cuts Per Minute	22,000

Fence Information

Fence Length	47-1/4 in.
Fence Width	1-1/2 in.
Fence Height	6 in.
Fence Stops	45, 90, 135 deg.

Cutterhead Information

Cutterhead Type	Helical
Cutterhead Diameter	4 in.
Number of Cutter Rows	4
Number of Indexable Cutters	76
Cutterhead Speed	5500 RPM

Cutter Insert Information

Cutter Insert Type	Indexable Carbide
Cutter Insert Length	15mm
Cutter Insert Width	15mm
Cutter Insert Thickness	2.5mm
Cutter Insert Curve	R98.5

Table Information

Table Length	100 in.
Table Width	16 in.
Table Thickness	2-3/4 in.
Floor to Table Height	34-3/8 in.
Table Adjustment Type	Handwheel/Lever
Table Movement Type	Parallelogram

Construction

Base	Cast Iron
Body Assembly	Cast Iron
Cabinet	Pre-Formed Steel
Fence Assembly	Cast Iron
Guard	Die-Cast Aluminum
Table	Precision-Ground Cast Iron
Paint Type/Finish	Powder Coated

Other Information

Number of Dust Ports	1
Dust Port Size	6 in.

Other

Country of Origin	Taiwan
Warranty	2 Year
Approximate Assembly & Setup Time	45 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Product Specifications

P.O. Box 2027, Bellingham, WA 98227 U.S.A.
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Model SB1132
16" 3-Phase Parallelogram Jointer with Helical Cutterhead & DRO

Product Dimensions

Weight	1079 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	100 x 46-1/2 x 50 in.
Footprint (Length x Width)	55 x 27 in.

Shipping Dimensions

Type	Wooden Crate
Content	Machine
Weight	1449 lbs.
Length x Width x Height	105 x 43 x 51 in.
Must Ship Upright	Yes

Electrical

Power Requirement	220V or 440V, 3-Phase, 60Hz
Prewired Voltage	220V
Full-Load Current Rating	20A at 220V, 10A at 440V
Minimum Circuit Size	30A at 220V, 15A at 440V
Connection Type	Permanent (Hardwire to Shutoff)
Switch Type	Control Panel w/Magnetic Switch Protection

Motors

Main

Horsepower	7.5 HP
Phase	3-Phase
Amps	20A/10A
Speed	3450 RPM
Type	TEFC Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Main Specifications

Main Specifications

Jointer Size	16 in.
Bevel Jointing	0 - 45 deg. L/R
Maximum Width of Cut	16 in.
Maximum Depth of Cut	1/8 in.
Minimum Workpiece Length	18 in.
Minimum Workpiece Thickness	1/2 in.
Maximum Rabbeting Depth	3/4 in.
Number of Cuts Per Minute	22,000

Fence Information

Fence Length	47-1/4 in.
Fence Width	1-1/2 in.
Fence Height	6 in.
Fence Stops	45, 90, 135 deg.

Cutterhead Information

Cutterhead Type	Helical
Cutterhead Diameter	4 in.
Number of Cutter Rows	4
Number of Indexable Cutters	76
Cutterhead Speed	5500 RPM

Cutter Insert Information

Cutter Insert Type	Indexable Carbide
Cutter Insert Length	15mm
Cutter Insert Width	15mm
Cutter Insert Thickness	2.5mm
Cutter Insert Curve	R98.5

Table Information

Table Length	100 in.
Table Width	16 in.
Table Thickness	2-3/4 in.
Floor to Table Height	34-3/8 in.
Table Adjustment Type	Handwheel/Lever
Table Movement Type	Parallelogram

Construction

Base	Cast Iron
Body Assembly	Cast Iron
Cabinet	Pre-Formed Steel
Fence Assembly	Cast Iron
Guard	Die-Cast Aluminum
Table	Precision-Ground Cast Iron
Paint Type/Finish	Powder Coated

Other Information

Number of Dust Ports	1
Dust Port Size	6 in.

Other

Country of Origin	Taiwan
Warranty	2 Year
Approximate Assembly & Setup Time	45 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Understanding Risks of Machinery

Operating all machinery and machining equipment can be dangerous or relatively safe depending on how it is installed and maintained, and the operator's experience, common sense, risk awareness, working conditions, and use of personal protective equipment (safety glasses, respirators, etc.).

The owner of this machinery or equipment is ultimately responsible for its safe use. This responsibility includes proper installation in a safe environment, personnel training and usage authorization, regular inspection and maintenance, manual availability and comprehension, application of safety devices, integrity of cutting tools or accessories, and the usage of approved personal protective equipment by all operators and bystanders.

The manufacturer of this machinery or equipment will not be held liable for injury or property damage from negligence, improper training, machine modifications, or misuse. Failure to read, understand, and follow the manual and safety labels may result in serious personal injury, including amputation, broken bones, electrocution, or death.

The signals used in this manual to identify hazard levels are as follows:

⚠DANGER	*Death or catastrophic harm WILL occur.*	**⚠CAUTION**	*Moderate injury or fire MAY occur.*
⚠WARNING	*Death or catastrophic harm COULD occur.*	***NOTICE***	*Machine or property damage may occur.*

Basic Machine Safety

Owner's Manual: All machinery and machining equipment presents serious injury hazards to untrained users. To reduce the risk of injury, anyone who uses THIS item MUST read and understand this entire manual before starting.

Personal Protective Equipment: Operating or servicing this item may expose the user to flying debris, dust, smoke, dangerous chemicals, or loud noises. These hazards can result in eye injury, blindness, long-term respiratory damage, poisoning, cancer, reproductive harm or hearing loss. Reduce your risks from these hazards by wearing approved eye protection, respirator, gloves, or hearing protection.

Trained/Supervised Operators Only: Untrained users can seriously injure themselves or bystanders. Only allow trained and properly supervised personnel to operate this item. Make sure safe operation instructions are clearly understood. If electrically powered, use padlocks and master switches, and remove start switch keys to prevent unauthorized use or accidental starting.

Guards/Covers: Accidental contact with moving parts during operation may cause severe entanglement, impact, cutting, or crushing injuries. Reduce this risk by keeping any included guards/covers/doors installed, fully functional, and positioned for maximum protection.

Entanglement: Loose clothing, gloves, neckties, jewelry or long hair may get caught in moving parts, causing entanglement, amputation, crushing, or strangulation. Reduce this risk by removing/securing these items so they cannot contact moving parts.

Mental Alertness: Operating this item with reduced mental alertness increases the risk of accidental injury. Do not let a temporary influence or distraction lead to a permanent disability! Never operate when under the influence of drugs/alcohol, when tired, or otherwise distracted.

Safe Environment: Operating electrically powered equipment in a wet environment may result in electrocution; operating near highly flammable materials may result in a fire or explosion. Only operate this item in a dry location that is free from flammable materials.

Electrical Connection: With electrically powered equipment, improper connections to the power source may result in electrocution or fire. Always adhere to all electrical requirements and applicable codes when connecting to the power source. Have all work inspected by a qualified electrician to minimize risk.

Disconnect Power: Adjusting or servicing electrically powered equipment while it is connected to the power source greatly increases the risk of injury from accidental startup. Always disconnect power BEFORE any service or adjustments, including changing blades or other tooling.

Secure Workpiece/Tooling: Loose workpieces, cutting tools, or rotating spindles can become dangerous projectiles if not secured or if they hit another object during operation. Reduce the risk of this hazard by verifying that all fastening devices are properly secured and items attached to spindles have enough clearance to safely rotate.

Chuck Keys or Adjusting Tools: Tools used to adjust spindles, chucks, or any moving/rotating parts will become dangerous projectiles if left in place when the machine is started. Reduce this risk by developing the habit of always removing these tools immediately after using them.

Work Area: Clutter and dark shadows increase the risks of accidental injury. Only operate this item in a clean, non-glaring, and well-lighted work area.

Properly Functioning Equipment: Poorly maintained, damaged, or malfunctioning equipment has higher risks of causing serious personal injury compared to those that are properly maintained. To reduce this risk, always maintain this item to the highest standards and promptly repair/service a damaged or malfunctioning component. Always follow the maintenance instructions included in this documentation.

Unattended Operation: Electrically powered equipment that is left unattended while running cannot be controlled and is dangerous to bystanders. Always turn the power ***OFF*** before walking away.

Health Hazards: Certain cutting fluids and lubricants, or dust/smoke created when cutting, may contain chemicals known to the State of California to cause cancer, respiratory problems, birth defects, or other reproductive harm. Minimize exposure to these chemicals by wearing approved personal protective equipment and operating in a well ventilated area.

Difficult Operations: Attempting difficult operations with which you are unfamiliar increases the risk of injury. If you experience difficulties performing the intended operation, STOP! Seek an alternative method to accomplish the same task, ask a qualified expert how the operation should be performed, or contact our Technical Support for assistance.

Additional Jointer Safety

⚠WARNING

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

Kickback: Occurs when workpiece is ejected from machine at a high rate of speed. Kickback injuries occur from getting struck by workpiece or hands being pulled into cutterhead. To reduce the risk of kickback, only use proper workpieces, safe feeding techniques, and proper machine setup or maintenance.

Guard Removal: Operating jointer without guards unnecessarily exposes operator to knives/inserts and other hazardous moving parts. Except when rabbeting, never operate jointer or allow it to be connected to power if any guards are removed. Turn jointer OFF and disconnect power before clearing any shavings or sawdust from around cutterhead. After rabbeting or maintenance is complete, immediately replace all guards and ensure they are properly installed/adjusted before resuming regular operations.

Dull or Damaged Knives/Inserts: Dull or damaged knives/inserts increase risk of kickback and cause poor workpiece finish. Only use sharp, undamaged knives/inserts.

Outfeed Table Alignment: Setting outfeed table too high can cause workpiece to hit table or get stuck while feeding. Setting outfeed table too low may cause workpiece to rock or shift while feeding. Both of these results will increase risk of kickback. Always keep outfeed table even with knives/inserts at highest point during rotation.

Inspecting Stock: Impact injuries or kickback may result from using improper workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Always joint warped workpieces with cupped side facing down.

Maximum Cutting Depth: To reduce risk of kickback, never cut deeper than ⅛" per pass.

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

Cutting Limitations: Cutting workpieces that do not meet minimum dimension requirements can result in kickback or accidental contact with cutterhead. Never perform jointing, planing, or rabbeting cuts on pieces smaller than specified in machine data sheet.

Push Blocks: Push blocks reduce risk of accidental cutterhead contact with hands. Always use push blocks when planing materials less than 3" high or wide. Never pass your hands directly over cutterhead without a push block.

Workpiece Support: Poor workpiece support or loss of workpiece control while feeding will increase risk of kickback or accidental contact with cutterhead. Support workpiece with fence continuously during operation. Support long stock with auxiliary tables if necessary.

Feed Workpiece Properly: Kickback or accidental cutterhead contact may result if workpiece is fed into cutterhead the wrong way. Allow cutterhead to reach full speed before feeding. Never start jointer with workpiece touching cutterhead. Always feed workpiece from infeed side to outfeed side without stopping until cut is complete. Never move workpiece backwards while feeding.

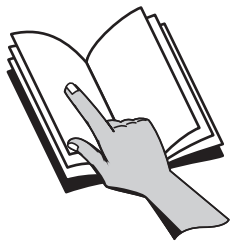
Secure Knives/Inserts: Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than ⅛" (0.125") from cutterhead body.

Preparation Overview

The purpose of the preparation section is to help you prepare your machine for operation. The list below outlines the basic process. Specific steps for each of these points will be covered in detail later in this section.

The typical preparation process is as follows:

1. Unpack the machine and inventory the contents of the box/crate.
2. Identify an acceptable location for the machine and move it to that location.
3. Clean the machine and its components.
4. Level the machine and either bolt it to the floor or place it on mounts.
5. Assemble the loose components and make any necessary adjustments or inspections to ensure the machine is ready for operation.
6. Connect the machine to the power source.
7. Test run the machine to make sure it functions properly and is ready for operation.



⚠WARNING

Incorrect use of this machine can result in death or serious injury. For your own safety, read and understand this entire document before using.

⚠WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect power until instructed to do so later in this manual.

Required for Setup

The items listed below are required to successfully set up and prepare this machine for operation.

For Lifting

- A forklift, hoist, boom crane, or other power lifting device rated for at least 1850 lbs.
- Lifting Straps (rated for at least 1850 lbs.)

For Power Connection

- A power source that meets the minimum circuit requirements for this machine (see **Power Supply Requirements** on **Page 14**).

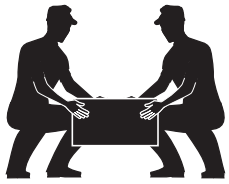
For Assembly

- Additional Person for Lifting
- Safety Glasses (for each person)
- Leather Work Gloves
- Precision Level 12"
- Phillips Head Screwdriver #2
- Wrench or Socket 13mm
- Dust Collection System
- 6" Dust Hose (length as needed)
- 6" Hose Clamps
- Disposable Rags
- Disposable Gloves
- Cleaner/Degreaser
- Quality Metal Protectant



⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine. To reduce this risk, get help from other people or lifting equipment rated for weight of this machine.

Power Supply Requirements

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed.

To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with applicable electrical codes and safety standards.



⚠WARNING

Electrocution or fire may occur if machine is not correctly grounded and attached to the power supply. Use a qualified electrician to ensure a safe power connection.

Full-Load Current Rating

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

SB1131
Full-Load Current Rating at 230V..... 23 Amps

SB1132
Full-Load Current Rating at 220V..... 10 Amps
Full-Load Current Rating at 440V..... 20 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Information

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

Note: *The circuit requirements in this manual are for a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure the circuit is properly sized.*

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or applicable electrical codes.

SB1131 Circuit Requirements

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

Nominal Voltage.....208V, 220V, 230V, 240V
Cycle..... 60 Hz
Phase..... Single-Phase
Circuit Rating..... 30 Amps
Plug/Receptacle (included).....NEMA L6-30

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

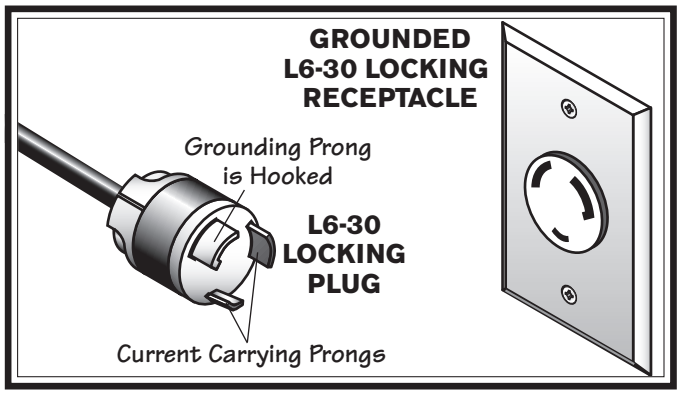
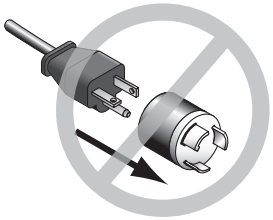


Figure 5. NEMA L6-30 plug and receptacle.

⚠CAUTION



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

SB1132 Circuit Requirements

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

Nominal Voltage.....208V, 220V, 230V, 240V
Cycle..... 60 Hz
Phase.....3-Phase
Circuit Rating..... 30 Amps

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below (refer to **Converting Voltage to 440V (SB1132)** on **Page 16** for details).

Nominal Voltage..... 440V, 480V
Cycle..... 60 Hz
Phase.....3-Phase
Circuit Rating..... 15 Amps

SB1132 Grounding Requirements

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

As specified in **SB1132 Circuit Requirements**, the machine must be hardwired to the power source, using a locking switch as a disconnecting means (see below). The machine must also be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation MUST be done by a qualified electrician.

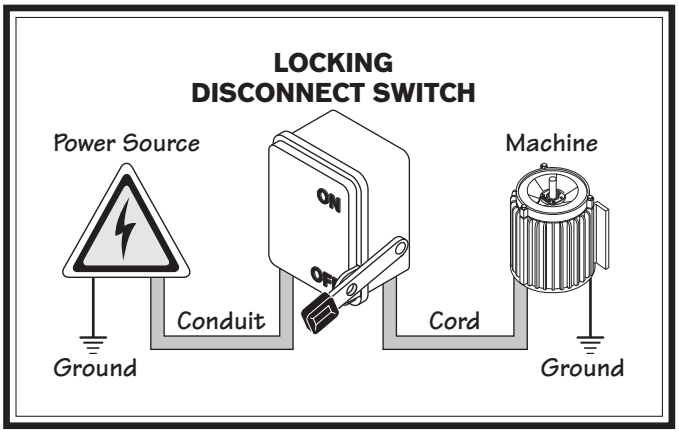


Figure 6. Recommended hardwire setup for Model SB1132.

Phase Converters (SB1132)

DO NOT use a static phase converter to create 3-phase power—it can quickly decrease the life of electrical components on this machine. If you must use a phase converter, only use a rotary phase converter.

Extension Cords

We do not recommend using an extension cord with the Model SB1131 and SB1132.

Converting Voltage to 440V (SB1132)



⚠WARNING

Electrocution, shock, fire, or damage may occur if machine is ungrounded, incorrectly connected to power, or NOT connected to a proper power supply. Only an electrician or qualified service personnel should connect this machine to power. Damage from an improper connection or power supply will NOT be covered under warranty!

The Model SB1132 can be converted for 440V operation. The voltage conversion procedure MUST be performed by an electrician or qualified service personnel.

This conversion consists of disconnecting the machine from the power source, rewiring the motor, switching the transformer fuse from 220V to 440V, and changing the thermal overload relay from 20 to 10 Amps. A wiring diagram is provided on **Page 61**.

IMPORTANT: If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Wrench or Socket 10mm	1

To convert SB1132 to 440V operation:

1. DISCONNECT MACHINE FROM POWER!

2. Open rear access panel (see **Figure 7**).

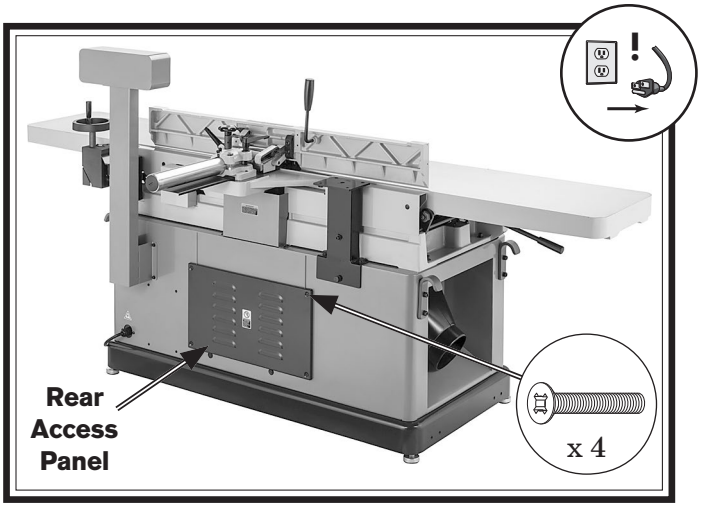


Figure 7. Location of rear access panel.

3. Open motor junction box cover, then loosen hex nuts shown in **Figure 8**.

4. Remove (3) jumpers (see **Figure 8**).

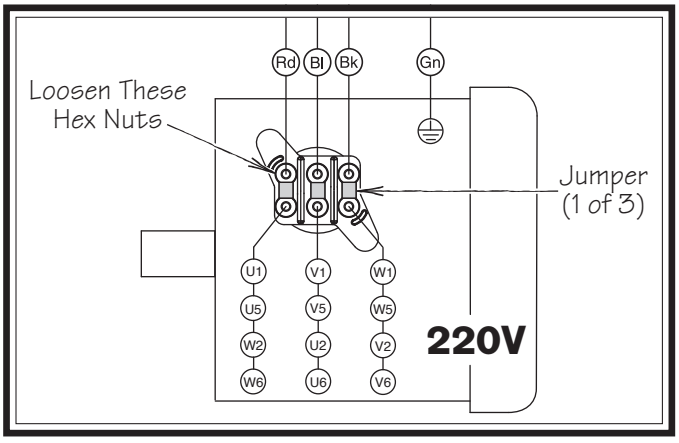


Figure 8. Motor prewired to 220V.

5. Rewire main motor for 440V operation (see **Figure 9**), then close and secure motor junction box.

   Note: *If diagram included on motor conflicts with one in this manual, motor may have changed since manual was printed. Use diagram provided on motor.*

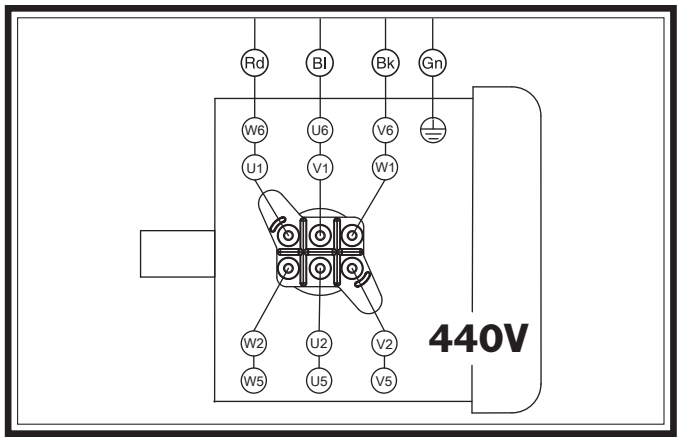


Figure 9. Motor rewired to 440V.

6. Remove magnetic switch cover and move fuse on fuse block from 220V slot to 440V slot, as shown in **Figure 10**.

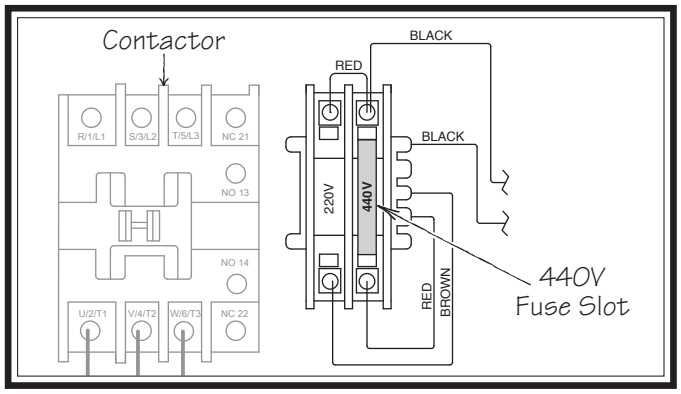


Figure 10. Fuse moved from 220V to 440V slot.

7. Turn thermal overload relay dial from 20A to 10A, as shown in **Figure 11**.

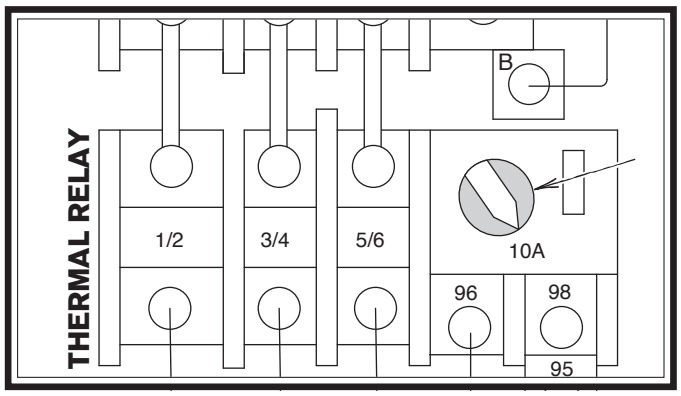


Figure 11. Overload relay dial set to 10A.

8. Install magnetic switch cover and secure.

9. Install rear access panel and secure.

Correcting Phase Polarity (SB1132)

This section is only provided for troubleshooting 3-phase power connections. If you discover during the test run that the machine will not operate, or that the motor runs backwards, the power supply connection may be wired "out of phase", meaning that the polarity is incorrect as wired. Without test equipment to determine polarity, this is a common situation with 3-phase power.

To correct phase polarity:

1. DISCONNECT MACHINE FROM POWER!

2. Remove rear access panel and open magnetic switch cover, then swap incoming RED and BLACK wires connected to L1/1 and L3/5 terminals, as shown in **Figure 12** on "To Power Supply" side of switch.

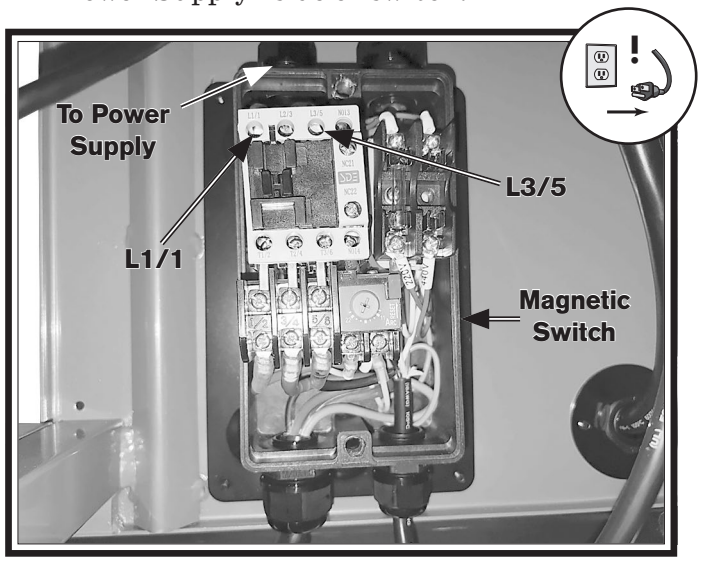


Figure 12. Location of L1/1 and L3/5 terminals.

3. Close and secure magnetic switch cover, then re-install rear access panel and secure.

4. Perform **Test Run** on **Page 29** to ensure that machine functions properly.

Unpacking

This item was carefully packaged to prevent damage during transport. If you discover any damage, please immediately call Customer Service at (360) 734-1540 for advice. You may need to file a freight claim, so save the containers and all packing materials for possible inspection by the carrier or its agent.

Inventory

Crate Inventory (Figure 13)	Qty
A. Jointer	1
B. Cutterhead Guard Assembly	1
C. Safety Push Blocks	2
D. Hex Wrenches 5, 6, 8mm	1 Ea.
E. Indexable Inserts 15 x 15 x 2.5mm	10
F. T-Handle T-25 Torx Drivers	2
G. Fence Tilt Lever	1
H. Open-End Wrench 17/19mm	1

Fastener Inventory (Figure 14)	Qty
I. Flat Head Torx Screws 10-32 x ½"	20

NOTICE

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

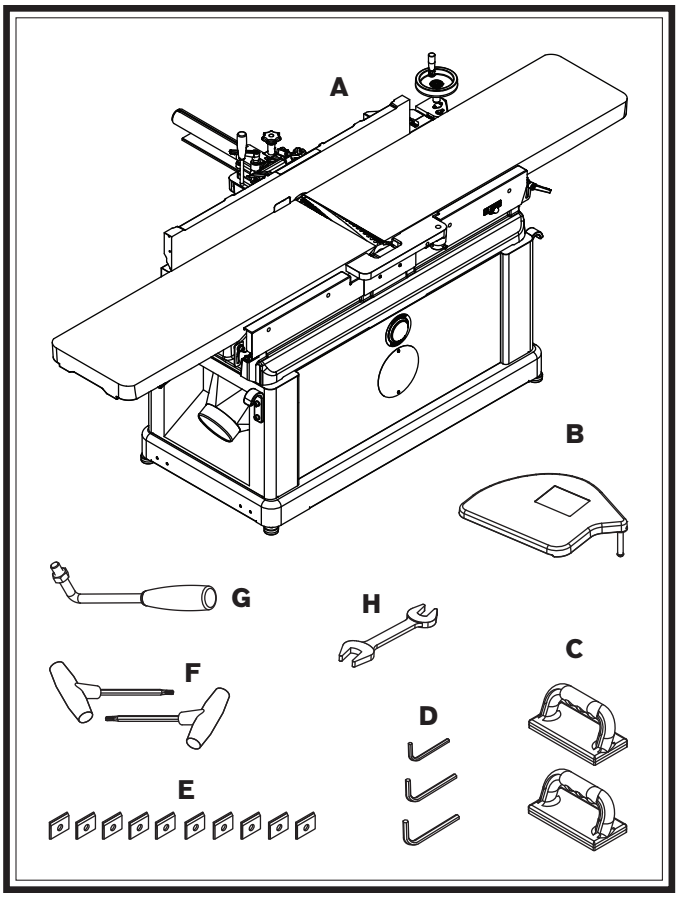


Figure 13. Crate inventory.

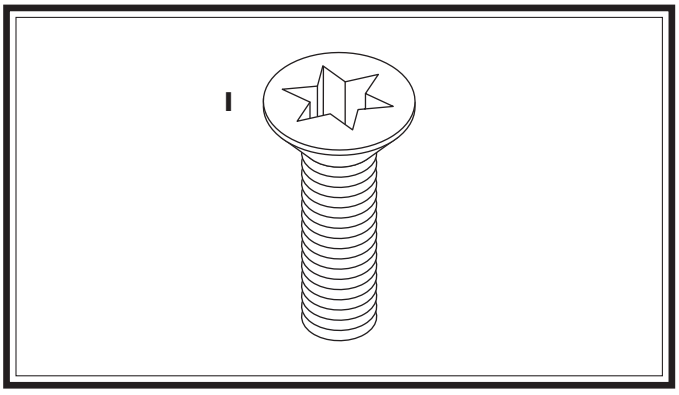


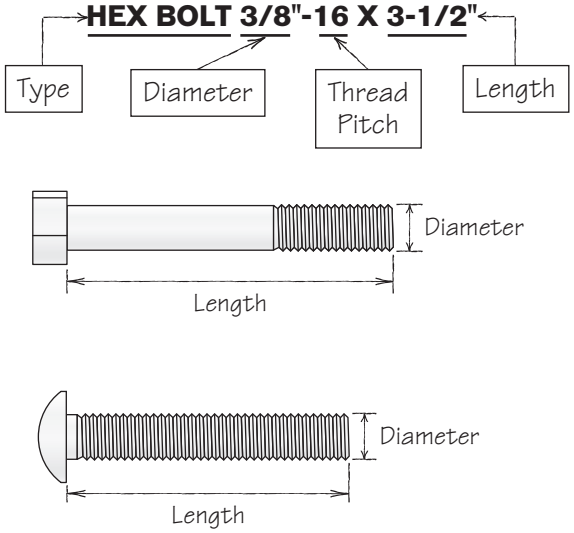
Figure 14. Fastener inventory (one of each shown).

Measuring Hardware

Use this page to understand how hardware is measured in this manual.

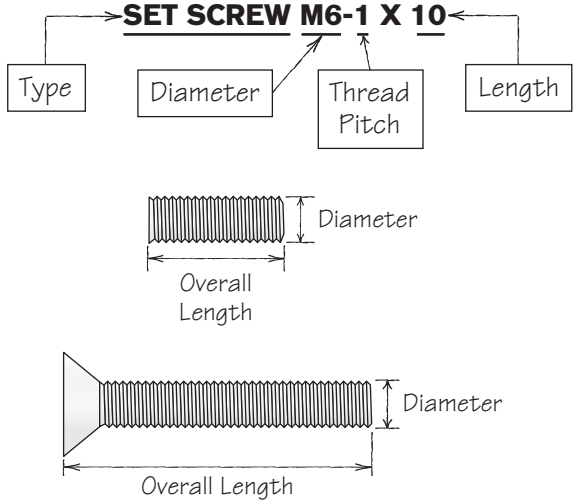
Bolts & Screws

Most bolts and screws are measured by the outside diameter of the threads, thread pitch, and the length from under the head to the opposite end:

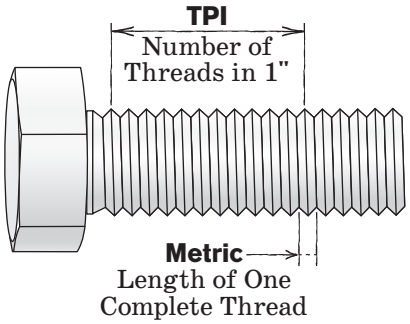


Flat Head & Set Screws

Flat head and set screws are measured by the outside diameter of the threads, thread pitch, and overall length of the fastener. These fasteners are often meant to sit flush with the adjoining surface:



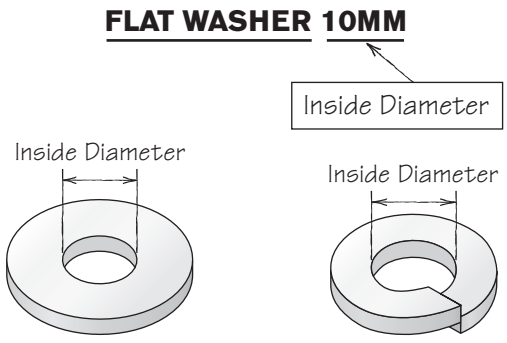
Thread pitch is the distance from the tip of one thread to the tip of the next thread. For US Standard threads, pitch is measured in threads per inch (TPI). Metric thread pitch is the length of one complete thread.



Note: *Grizzly Industrial does not typically list a thread pitch for thread-forming screws and bolts, such as tap screws, wood screws, and lag bolts.*

Washers

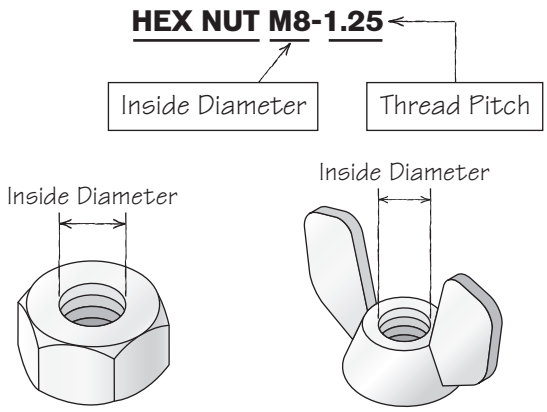
Common washers are measured by their inside diameter.



Note: *Specialized washers may list the inside diameter, outside diameter, and the thickness.*

Nuts

Nuts are measured by the inside diameter of the threads and the thread pitch.



Cleaning & Protecting

The unpainted surfaces are coated at the factory with a heavy-duty rust preventative that prevents corrosion during shipment and storage. The benefit of this rust preventative is that it works very well. The downside is that it can be time-consuming to thoroughly remove.

Be patient and do a careful job when cleaning and removing the rust preventative. The time you spend doing this will reward you with smooth-sliding parts and a better appreciation for the proper care of the unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, the following process works well in most situations.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (certain citrus-based degreasers work extremely well and they have non-toxic fumes)
- Safety glasses & disposable gloves

Note: *Automotive degreasers, mineral spirits, or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of a painted surface to make sure they will not damage it.*



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by wearing a respirator and only using these products in a well ventilated area.



⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used for cleaning. Avoid using these products to remove rust preventative.

Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.

2. Coat all surfaces that have rust preventative with a liberal amount of cleaner or degreaser and let them soak for a few minutes.

3. Wipe off the surfaces. If your cleaner or degreaser is effective, the rust preventative will wipe off easily.

   IMPORTANT: To clean off thick coats of rust preventative on flat surfaces, such as beds or tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. DO NOT use a metal scraper or it may scratch the surface.

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

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

Location

Physical Environment

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

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

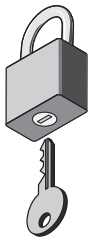
Lighting around the machine must be adequate enough to perform operations safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

Weight Load

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

Space Allocation

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



⚠CAUTION

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

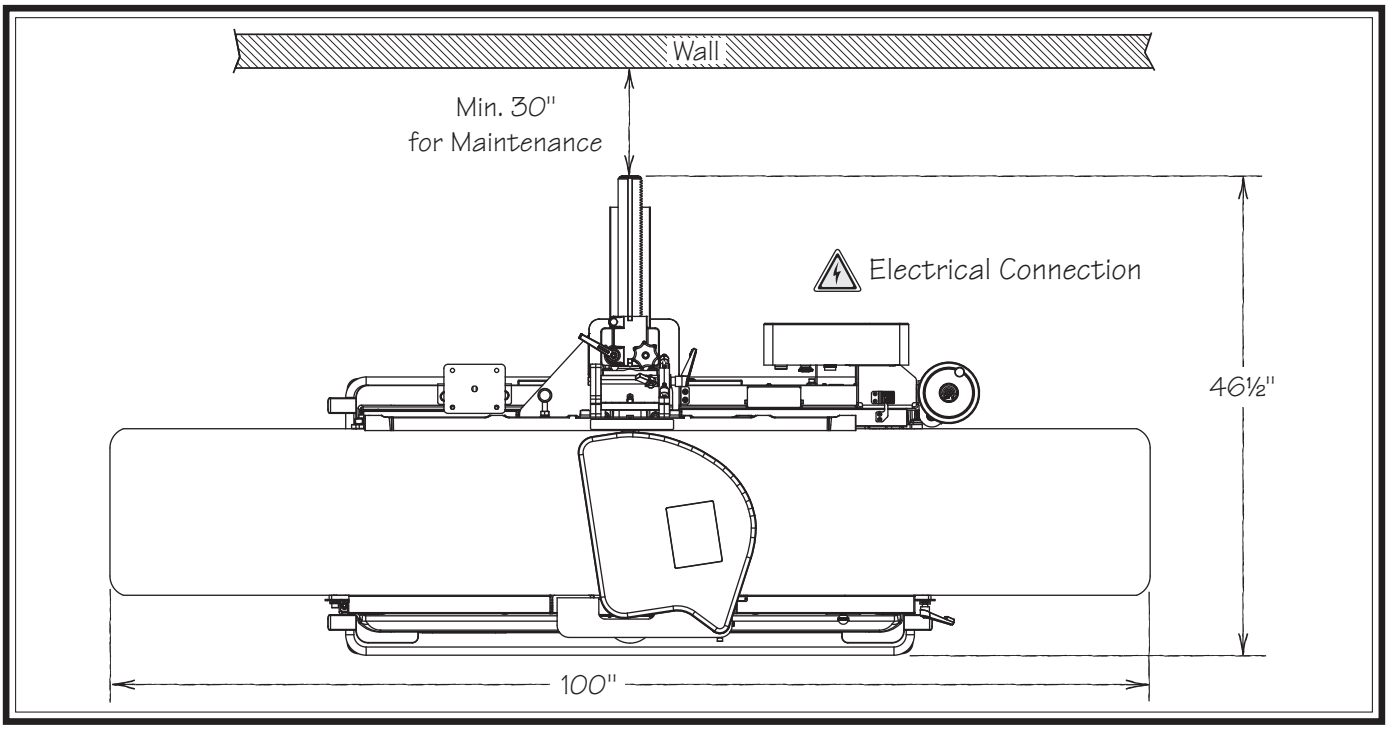
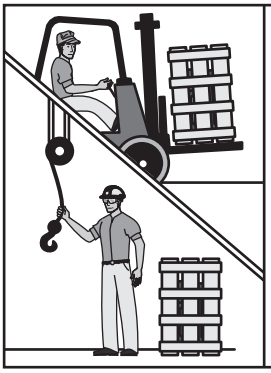


Figure 15. Working clearances.

Lifting & Placing



⚠WARNING

This machine and its parts are heavy! Serious personal injury may occur if safe moving methods are not used. To reduce the risk of a lifting or dropping injury, ask others for help and use power equipment.

The Model SB1131 & SB1132 require the use of lifting equipment such as a forklift, engine hoist, or boom crane. DO NOT attempt to lift or move jointer without necessary assistance from other people. Each piece of lifting equipment must be rated for **at least 1850 lbs.** to support dynamic loads that may be applied while lifting.

Before lifting and placing, review **Power Supply Requirements** on **Page 14**, then prepare a permanent location for the machine.

NOTICE

DO NOT lift this jointer by the tables. Doing so may affect factory-set table parallelism. Attach lifting straps to lifting hooks.

To lift & place machine:

1. Move crate to desired location.

2. Remove crate top and sides, then remove any blocks around machine base.

3. Remove any plastic wrap around machine and components.

4. Remove fasteners and shipping brackets securing machine to pallet (see **Figure 16**).

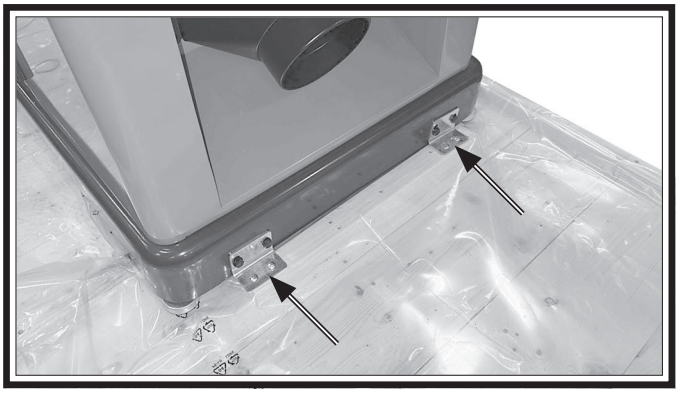


Figure 16. Location of pallet shipping brackets (2 of 4 shown).

5. Set depth-of-cut to "0", then remove (3) cap screws, lock washers, and flat washers shown in **Figure 17** to remove depth-of-cut scale assembly.

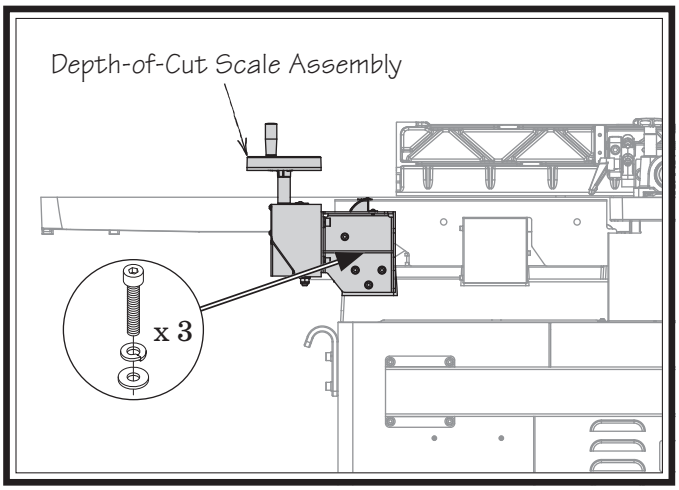


Figure 17. Location of depth-of-cut scale assembly fasteners.

6. Wrap lifting straps around lifting hooks, as shown in **Figure 18**.

IMPORTANT: Verify lifting straps are not binding on machine components.

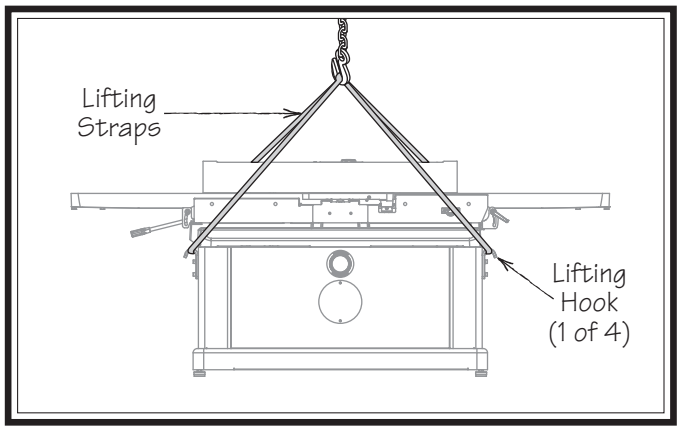


Figure 18. Jointer supported evenly at lifting hooks by lifting straps.

7. With lifting straps positioned evenly on forks or crane, lift jointer off of pallet and place it in desired location.

8. Remove lifting straps and install depth-of-cut scale assembly using fasteners removed in **Step 5**.

Mounting

Number of Mounting Holes 4
Diameter of Mounting Hardware ..... ½"

Anchoring machine to the floor prevents tipping or shifting that may occur during operation with large/heavy workpieces.

If machine is installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

Mounting to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you MUST follow the anchoring methodology specified by the code.

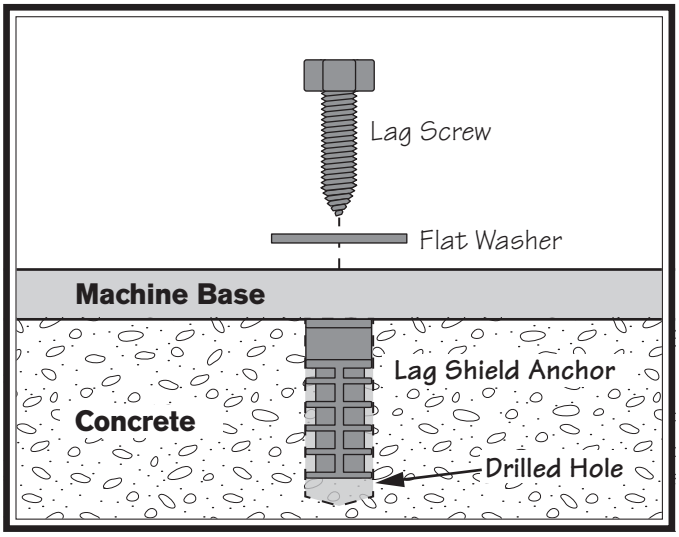


Figure 19. Popular method for anchoring machinery to a concrete floor.

Machine Mounts

The Model SB1131 and SB1132 include (4) adjustable mounts pre-installed on the machine.

Machine mounts are rubber pads mounted to a threaded stud, which can be fastened to the bottom of the machine.

Machine mounts offer certain advantages such as ease of installation, vibration dampening, and easy leveling. They also make it easier to relocate the machine later on.

The disadvantage of machine mounts is that the machine can shift or move over time. For this reason, electrical codes may limit their use if the machine is hardwired to the power source. Also, mounts may reduce the total surface area of machine-to-floor contact, depending on the design of the machine.



Figure 20. Typical machine mount.

Leveling

Generally, you can either bolt your machine to the floor or mount it on machine mounts. Although not required, we recommend that you secure the machine to the floor and level it while doing so. Because this is an optional step and floor materials may vary, hardware for securing the machine to the floor is not included.

NOTICE

We strongly recommend securing your machine to the floor if it is hardwired to the power source. Consult with your electrician to ensure compliance with local codes.

Leveling

Leveling machinery helps precision components, such as bed ways, remain straight and flat during the lifespan of the machine. Components on an unleveled machine may slowly twist due to the dynamic loads placed on the machine during operation.

For best results, use a precision level that is at least 12" long and sensitive enough to show a distinct movement when a 0.003" shim (approximately the thickness of one sheet of standard newspaper) is placed under one end of the level.

See the figure below for an example of a high precision level.

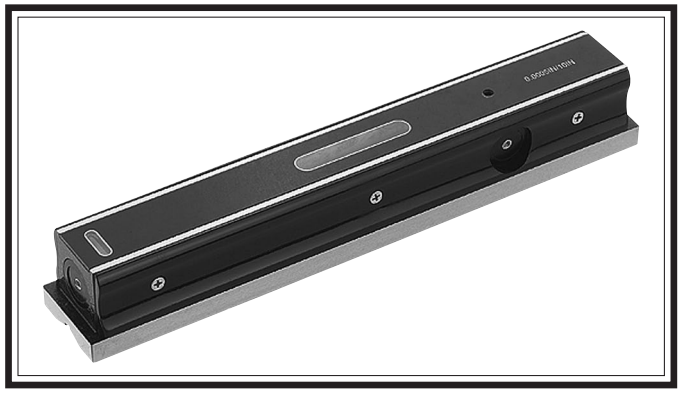


Figure 21. Example of a precision level.

To level machine:

1. Place level on table and align to either X- or Y-axis.

2. Rotate jam nut on adjustable foot until axis is level (see **Figure 22**).

   Note: *Turn nut clockwise to raise machine, and counterclockwise to lower machine.*

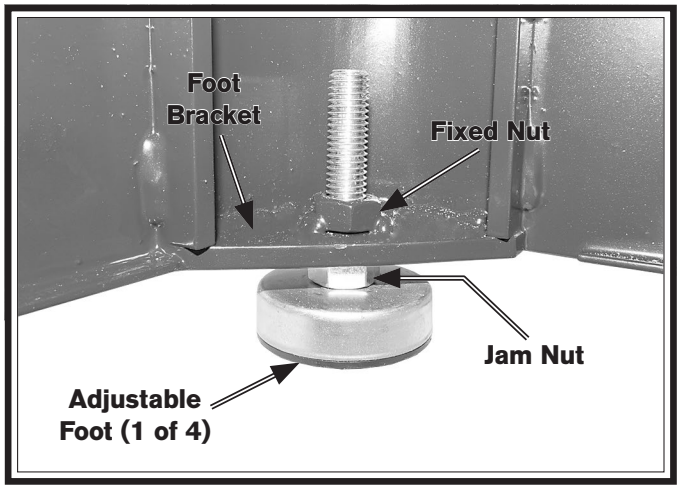


Figure 22. Adjustable foot components (viewed from machine interior).

3. Rotate level to check remaining axis and repeat **Step 2**.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, see **Required for Setup** on **Page 13** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

To assemble machine:

1. Remove (2) cap screws, lock washers, and flat washers on control panel column (see **Figure 23**) and set aside.

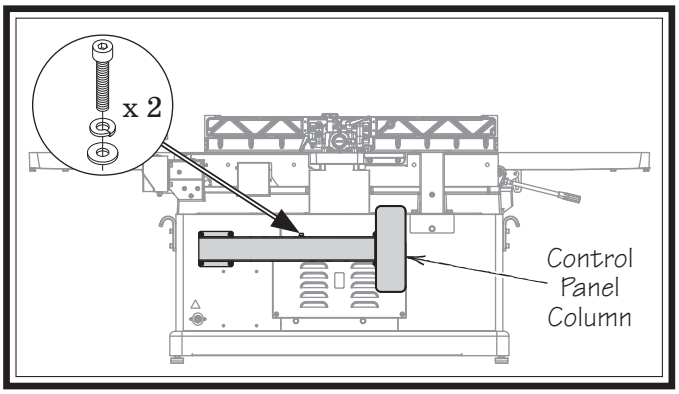


Figure 23. Location of column fasteners.

2. Remove (4) cap screws, lock washers, and flat washers securing control panel column, then rotate column upright and secure with removed fasteners (see **Figure 24**).

   Note: *Be careful not to damage control panel cord during rotation.*

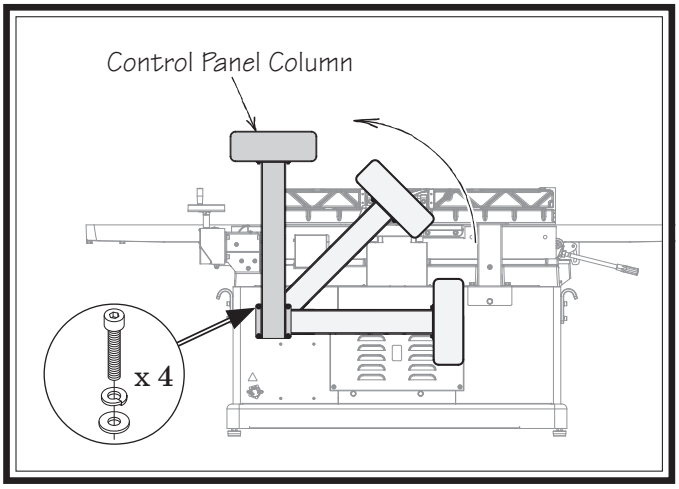


Figure 24. Rotating control panel column.

3. Use fasteners removed in **Step 1** to attach depth-of-cut scale assembly to control panel column (see **Figure 25**).

4. Loosen fence tilt lock handle and set fence tilt to 90°, then tighten lever to secure (see **Figure 25**).

5. Install fence tilt lever on rear of fence, then tighten pre-installed hex nut to secure, as shown in **Figure 25**.

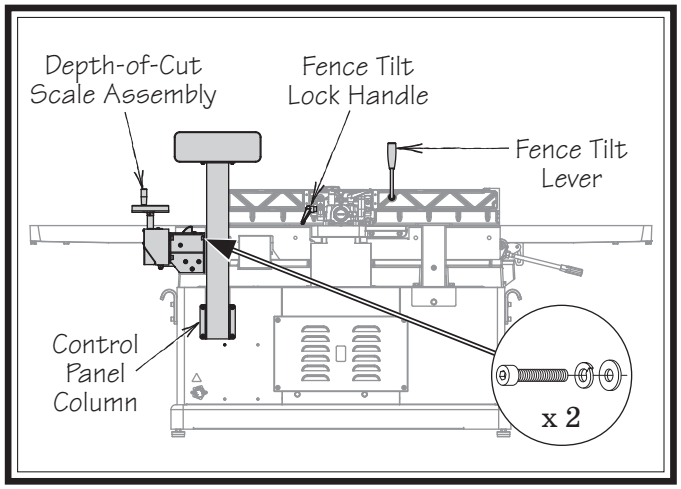


Figure 25. Control panel column and fence tilt lever installed.

6. Loosen fence lock handle and rotate fence adjustment handwheel (see **Figure 26**) until fence is all the way back and clear of tables.

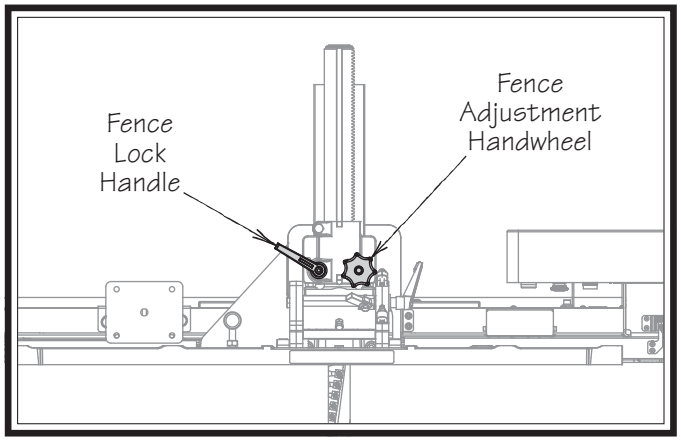


Figure 26. Location of fence adjustment components.

7. Remove cap screw and flat washer on end of cutterhead guard shaft (see **Figure 27**).

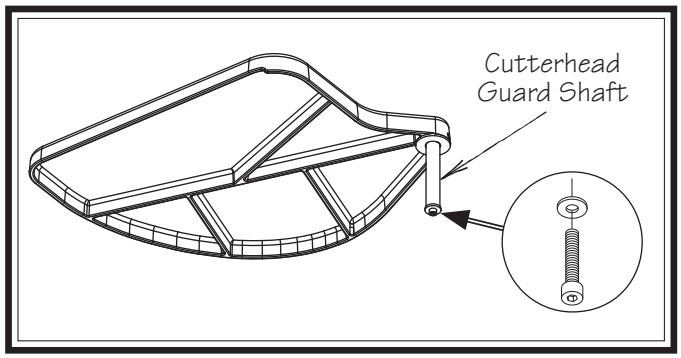


Figure 27. Location of cutterhead guard shaft fastener.

⚠CAUTION

Indexable inserts are very sharp and can easily cut your hands. ALWAYS use caution when working around these parts to reduce risk of personal injury.

8. Loosen cap screw on shaft lock and insert guard shaft into mounting hole, positioned so guard rests against fence (see **Figure 28**).

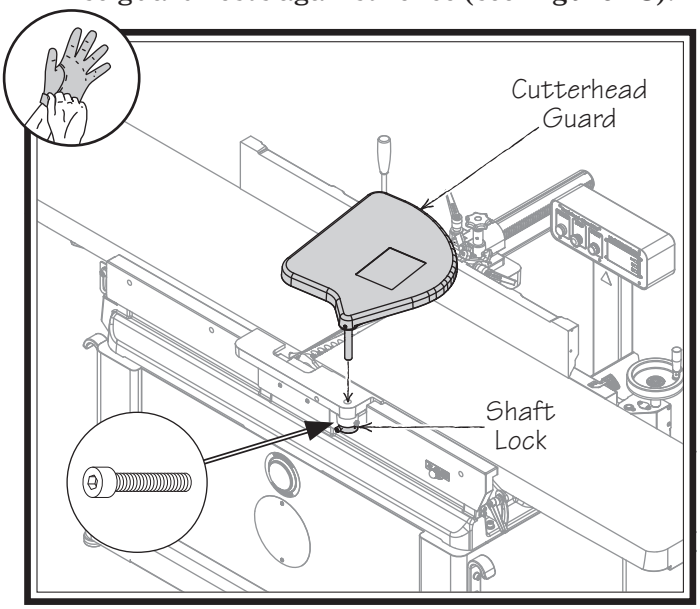


Figure 28. Installing cutterhead guard.

9. Secure shaft with cap screw and flat washer removed in **Step 6**.

10. Position cutterhead guard as low as possible without allowing it to drag on tables or rabbeting ledge. Set guard height approximately 5/16" above outfeed table, rotate shaft lock counterclockwise to pre-load spring, then tighten shaft lock cap screw to secure position.

⚠WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

11. Verify proper operation of cutterhead guard by pulling cutterhead guard back and letting it go. It should spring back over cutterhead and contact fence without dragging across tables.

— If cutterhead guard DOES NOT spring back over cutterhead and contact fence, or if it drags across tables, then it must be adjusted (refer to **Checking/Adjusting Cutterhead Guard** on **Page 51** for instructions).

12. Verify all indexable inserts are securely tightened on cutterhead.

Dust Collection

⚠CAUTION

DO NOT operate the Model SB1131 and SB1132 without an adequate dust collection system. This jointer creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 850 CFM

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

To connect machine to dust collection:

1. Fit 6" dust hose over dust port (see **Figure 29**), and secure in place with a hose clamp.

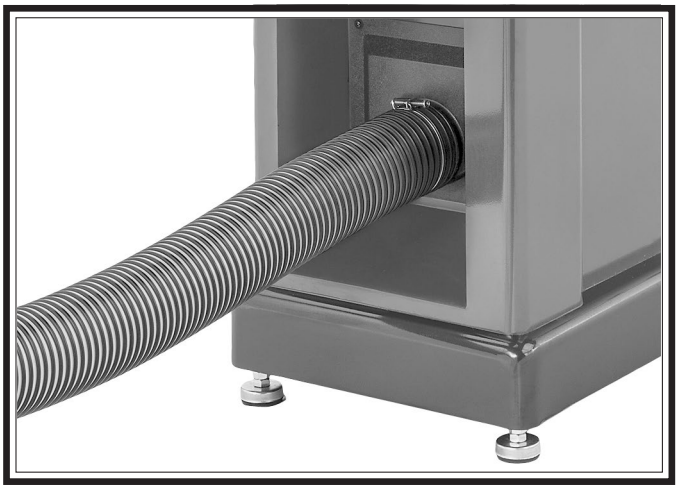


Figure 29. Example of dust collection hose attached to dust port.

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

Note: *A tight fit is necessary for proper performance.*

Power Connection



⚠WARNING

Electrocution or fire may occur if machine is ungrounded, incorrectly connected to power, or connected to an undersized circuit. Use a qualified electrician to ensure a safe power connection.

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared according to **Power Supply Requirements** on **Page 14**, and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly.

Power Connection (SB1131)

Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

If you need to disconnect the machine from power later, pull the plug completely out of the receptacle.

Note About Extension Cords: We do not recommend using an extension cord with the Model SB1131 and SB1132.

Hardwiring to Power Source (SB1132)

Hardwire setups require power supply lines to be enclosed inside of conduit, which is securely mounted and constructed in adherence to applicable electrical codes.

A hardwire setup for this machine must be equipped with a locking disconnect switch as a means to disconnect the power during adjustments or maintenance, which is a typical requirement for many lock-out/tag-out safety programs.

Figure 30 shows a simple diagram of a hardwire setup with a locking disconnect switch between the power supply and the machine.

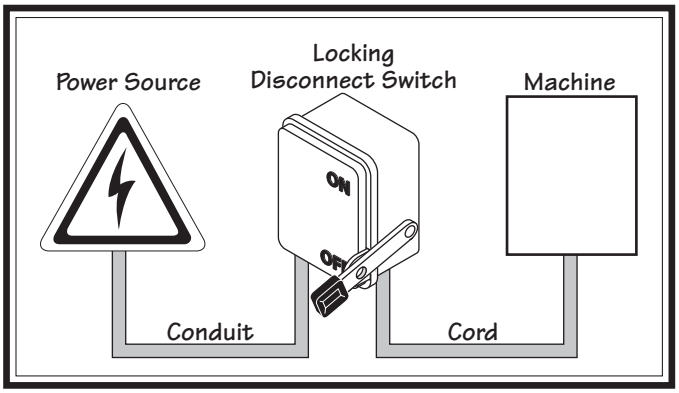


Figure 30. Typical hardwire setup with a locking disconnect switch.

Test Run

After all preparation steps have been completed, the machine and its safety features must be tested to ensure correct operation. If you discover a problem with the operation of the machine or its safety components, do not operate it further until you have resolved the problem.

Note: *Refer to **Troubleshooting** on **Page 56** for solutions to common problems that may occur. If you need additional help, contact our Tech Support at (360) 734-1540.*

The test run consists of verifying the following:

- Motor powers up and runs correctly.
- EMERGENCY STOP and Knee Stop buttons work correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear away all tools and objects used during preparation and assembly.

2. Connect machine to power source. POWER light should illuminate.

   — If light does not illuminate, check power connection.

3. Push EMERGENCY STOP button in, then twist it clockwise until it springs out (see **Figure 31**). This resets button so machine can start.



Figure 31. Resetting EMERGENCY STOP button.

4. Push START button to turn machine ***ON***. Verify machine operates smoothly without unusual problems or noises.

   — When operating correctly, machine runs smoothly with little or no vibration or rubbing noises.

   — Investigate and correct strange or unusual noises or vibrations before operating machine further. ALWAYS disconnect machine from power when investigating or correcting potential problems.

5. Press EMERGENCY STOP button to stop machine.

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

   — If machine *does not* start, EMERGENCY STOP button safety feature is working correctly.

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

7. Reset EMERGENCY STOP button, and push START button.

8. Press Knee Stop button to stop machine.

   — If machine *does* stop, Knee Stop button safety feature is working correctly.

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

Inspections & Adjustments

The following list of adjustments were performed at the factory before your machine was shipped:

- **Table Parallelism..... (Page 44)**
- **Digital Readout Calibration..... (Page 49)**
- **Outfeed Table Adjustment..... (Page 50)**
- **Fence Stop Adjustment..... (Page 52)**
- **V-Belt Tension Adjustment ..... (Page 54)**

Be aware that machine components can shift during the shipping process. Pay careful attention to these adjustments as you test run your machine. If you find that the adjustments are not set according to the procedures in this manual or your personal preferences, re-adjust them.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

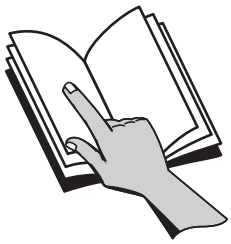
⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so they can more easily understand the controls discussed later in this manual.

Note: *Due to the generic nature of this overview, it is not intended to be an instructional guide for performing actual machine operations. To learn more about specific operations and machining techniques, seek training from people experienced with this type of machine, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.*



⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.



⚠WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.

NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, South Bend Tools will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Examines workpiece to verify it is safe and suitable for cutting.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Puts on safety glasses, respirator, and any other required protective equipment.
6. Starts dust collection, then turns jointer ***ON***.
7. Using push blocks as needed, holds workpiece firmly against infeed table and fence, and feeds workpiece into cutterhead at a steady and controlled rate until entire length of workpiece has been cut and it clears the cutterhead on the outfeed table side.
8. Repeats cutting process described above until desired results are achieved.
9. Turns jointer ***OFF***, then stops dust collection.

Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

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

- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of kickback, as well as tear-out on the workpiece.

- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock on the jointer so the grain points down and toward you as viewed on the edge of the stock (see **Figure 32**).

  Note: *If the grain changes direction along the edge of the board, decrease the cutting depth and make additional passes.*

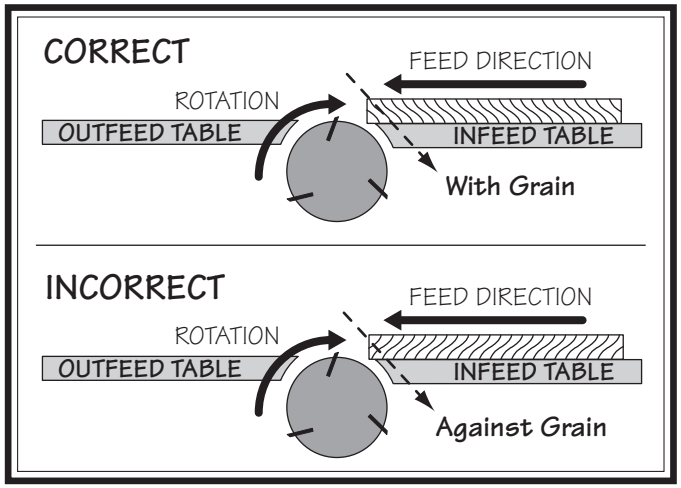


Figure 32. Proper grain alignment with cutterhead.

- **Only cut natural wood.** This jointer is only designed for cutting natural wood stock. Never use it to cut MDF, particle board, plywood, laminates, drywall, backer board, metals, glass, stone, tile, products with lead-based paint, or products that contain asbestos. Cutting these may lead to injury or machine damage.

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

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

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

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

⚠WARNING

Make sure your workpiece exceeds the minimum dimension requirements shown below before processing it through the jointer, or the workpiece may break or kick back during the operation.

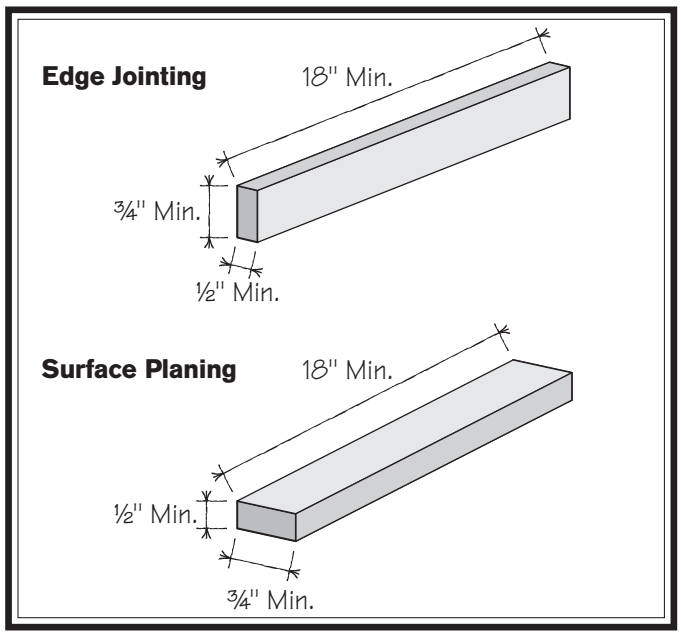


Figure 33. Minimum stock dimensions for jointer.

Squaring Stock

Squaring stock means making it flat and parallel along both length and width, and making the length and width perpendicular to one another.

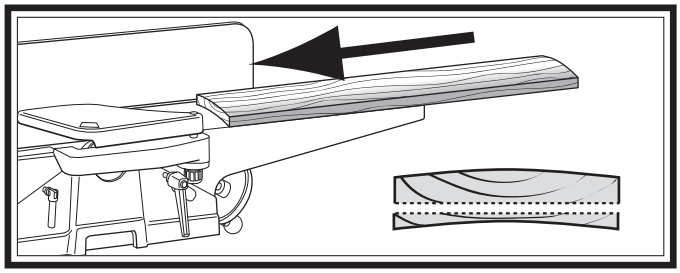
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

A properly "squared up" workpiece is essential for tasks such as accurate table saw cuts, glue-ups/laminations, cutting accurate bevels on a bandsaw, and many other applications where one surface of a workpiece is used to reference another.

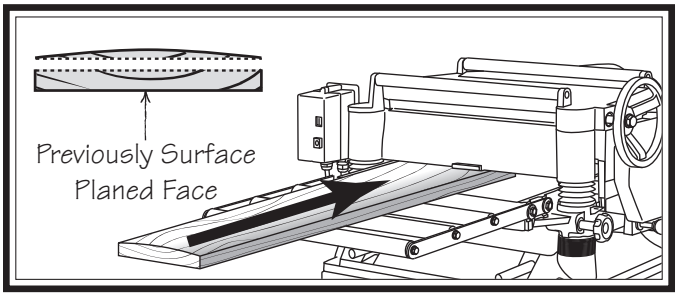
Items Needed	Qty
Table Saw	1
Jointer	1
Planer	1

Squaring stock involves four steps performed in the order below:

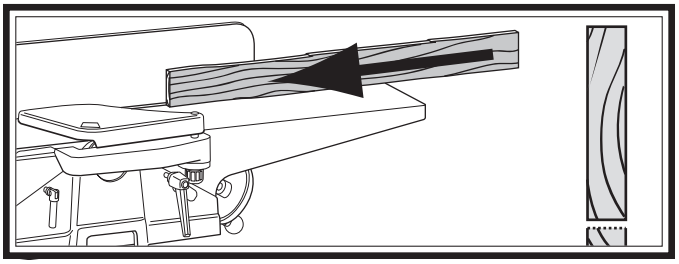
1. **Surface Plane on Jointer**—Concave face of workpiece is surface planed flat with jointer.



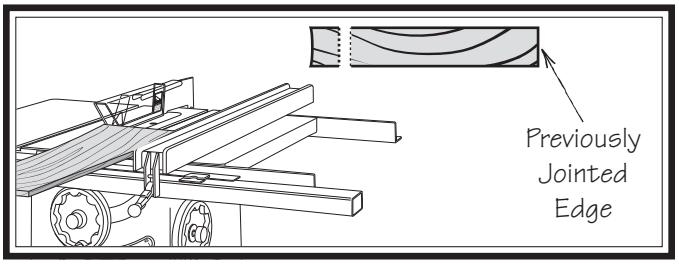
2. **Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



3. **Edge Joint on Jointer**—Concave edge of workpiece is jointed flat with jointer.



4. **Rip Cut on a Table Saw**—Jointed edge of workpiece is placed against a table saw fence and opposite edge cut off.



Surface Planing

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

⚠WARNING

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

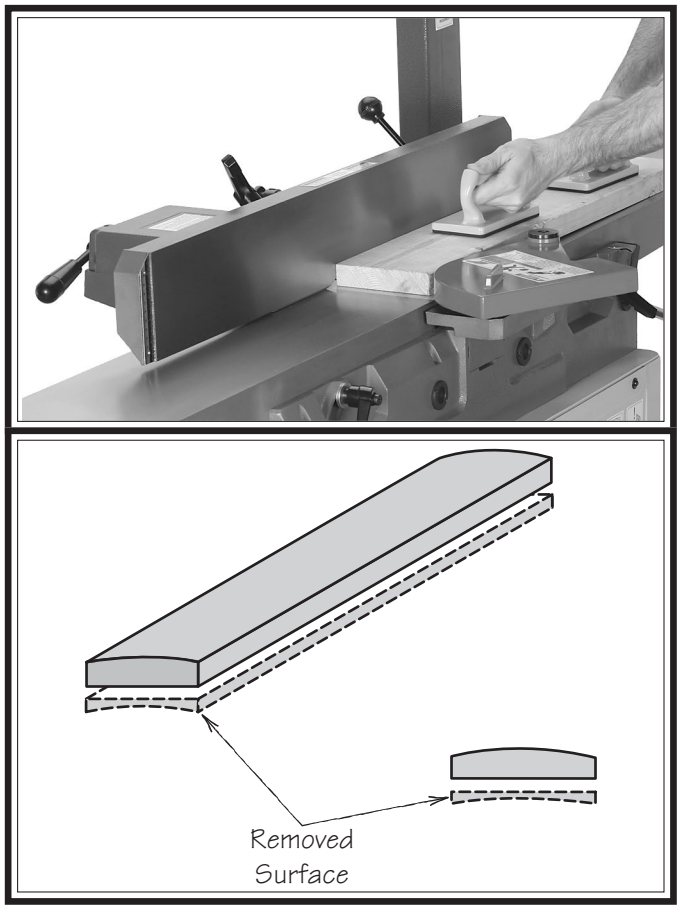


Figure 34. Example of a surface planing operation.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** on **Page 32**).

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

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of 1/16" per pass when surface planing.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

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

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

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

7. Repeat **Step 6** until entire surface is flat.

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

Edge Jointing

Edge jointing (see **Figure 35**) produces a flat and true surface along the side of a workpiece by removing uneven areas. It is an essential step for squaring up warped or rough stock and when preparing a workpiece for joinery or finishing.

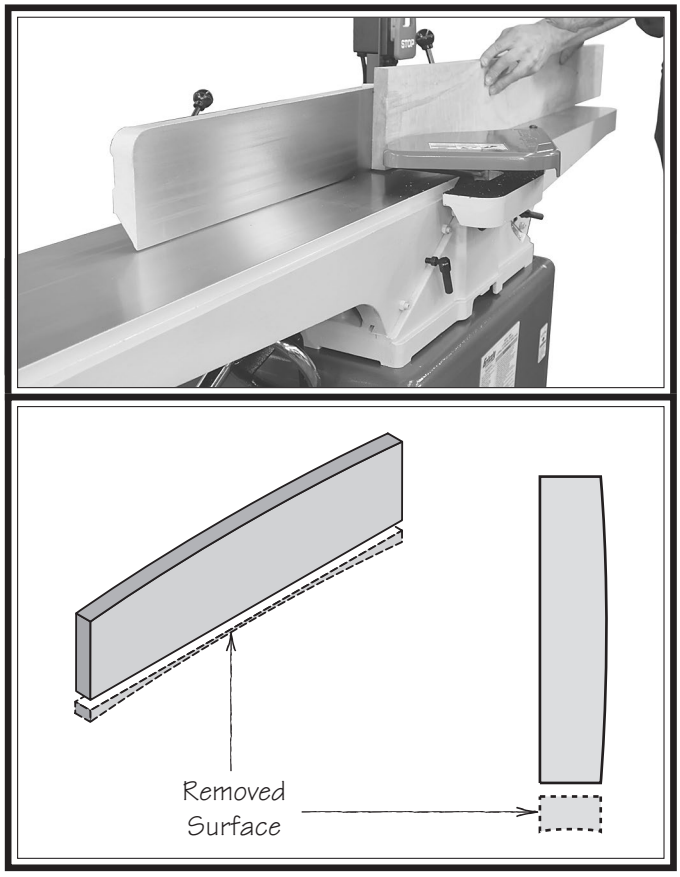


Figure 35. Example photo of an edge jointing operation.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** on **Page 32**).

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

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of ⅛" per pass.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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

Bevel Cutting

Bevel cuts (see **Figure 36**) can be made by setting the fence at the desired angle and feeding the workpiece firmly along the fence face, with the bottom inside corner firmly against the table. The cutting process typically requires multiple passes or cuts to bevel the entire edge of a workpiece.

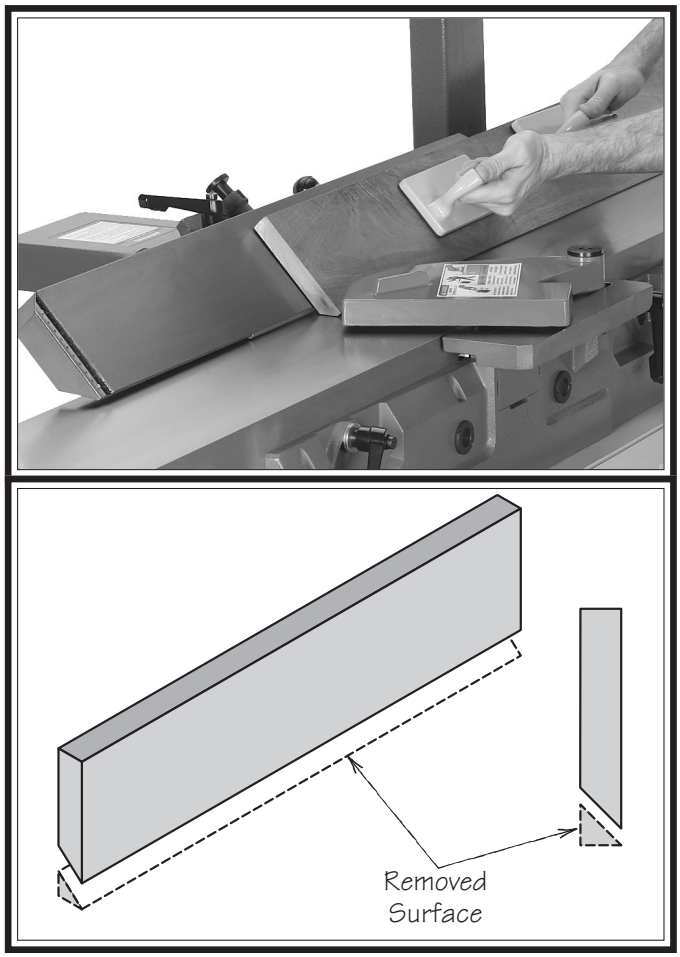


Figure 36. Example photo of fence set up for a bevel cut of 45°.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** on **Page 32**).

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

   ⚠ **CAUTION:** Cutting depth for bevel cuts is typically between 1/16" and 1/8", depending on hardness and width of stock.

3. Set fence tilt to desired angle of cut.

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

5. Start jointer.

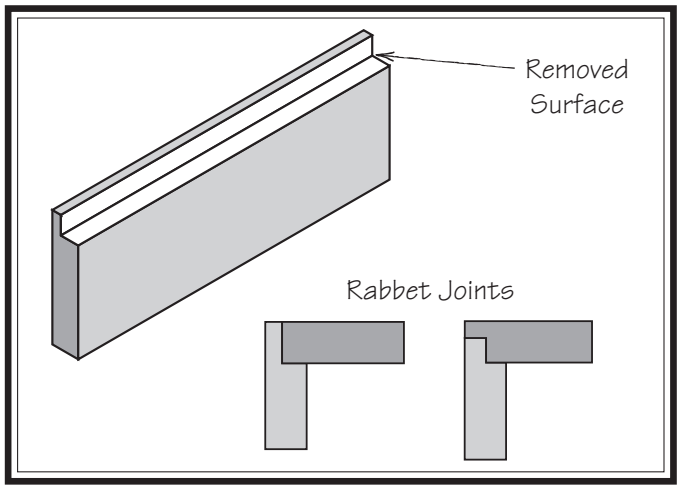
6. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

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

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

Rabbet Cutting

A rabbet cut removes a portion of a workpiece edge, so it fits together with an opposing, equally sized rabbet cut on another workpiece (see example **Figure** below). This is a classic method of joining two workpieces that is simple, yet strong.



This jointer can be used to make high-quality rabbet cuts, but there are some situations—whether it is due to an excessively large/small workpiece size or rabbet cutting width/depth—when it will not be safe or appropriate for making the rabbet cut on this jointer. In these cases, you need to use another tool or method for rabbet cutting that will be a safer alternative.

A rabbet cut can alternatively be made using a table saw, router, or even a hand saw. As with any type of cutting operation, always consider your safety first and use good judgment!

Typically, rabbet cutting with a jointer requires the cutterhead guard to be removed first, so the workpiece can slide along the rabbeting ledge during the cut. However, it is possible to make rabbet cuts with thin workpieces without removing the cutterhead guard. This is done by performing the rabbet cut with the workpiece on end (similar to when you are edge jointing).

⚠WARNING

When cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes operator to moving cutterhead. To minimize risk of injury and unnecessary exposure to cutterhead, always keep cutterhead guard installed when possible, and ALWAYS immediately replace it after performing rabbet cuts.

To rabbet cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** on **Page 32**).

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

   ⚠ **CAUTION:** To minimize risk of kickback, cutting depth should never exceed ⅛" per pass.

3. Remove cutterhead guard if necessary to perform operation (see **Figures** below).

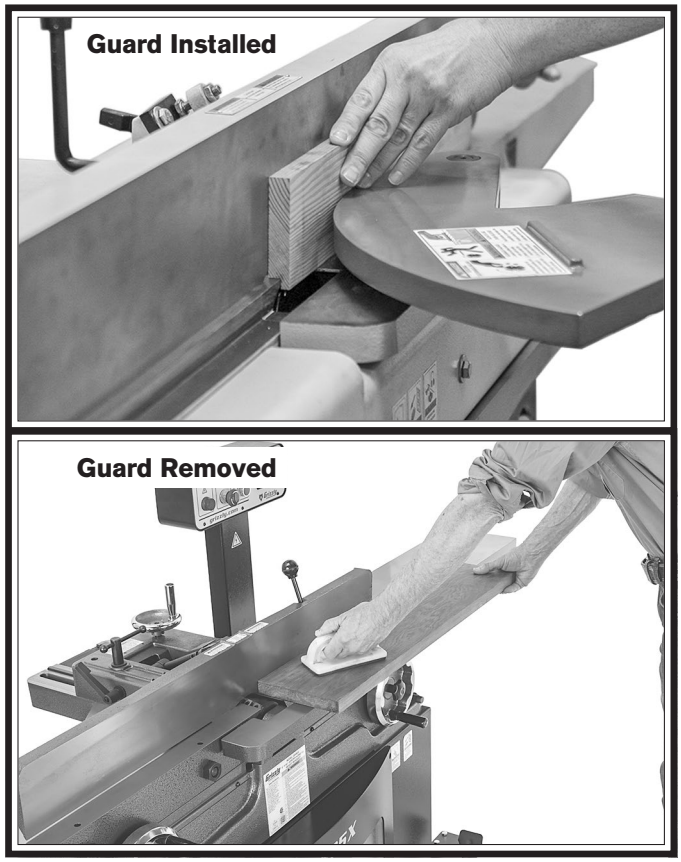


Figure 37. Example photos of rabbet cutting operations.

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

5. Start jointer.

6. Place workpiece firmly against fence and infeed table.

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

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

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

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

   Note: *Disengage infeed table lock-pin as infeed table lowers beyond ⅛".*

9. Re-install cutterhead guard if removed in **Step 3**.

Setting Depth of Cut

The depth of cut on a jointer affects the amount of material removed from the bottom of the workpiece as it passes over the cutterhead.

The depth of cut is set by adjusting the height of the infeed table relative to the outfeed table and cutterhead inserts at top dead center (TDC).

⚠WARNING

DO NOT exceed ⅛" cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!

To set depth of cut:

1. Loosen infeed table lock handle and rotate infeed handwheel until depth-of-cut scale behind infeed table (see **Figure 38**) and DRO indicate desired depth of cut.

   Note: *Digital readout can be calibrated or "zeroed" if it is not accurate (see **Calibrating DRO** on **Page 49**).*



Figure 38. Location of depth-of-cut scale.

2. Set table positive stops as desired (see **Setting Positive Stops** on **Page 49**).

3. Tighten infeed table lock handle before beginning jointer operations.

Accessories

This section includes the most common accessories available for your machine, which are available through our exclusive dealer, **Grizzly Industrial, Inc.**, at **grizzly.com**.

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended by South Bend or Grizzly.

NOTICE

Refer to Grizzly's website or latest catalog for additional recommended accessories.

H5297—6" Industrial Dust Collection Starter Kit

Our 6" Industrial Dust Collection Starter Kit has everything you need for a simple, single-machine setup. The included branch and end cap make it easy to expand your system later, so this kit can grow with your shop.



Figure 39. H5297 6" Industrial Dust Collection Starter Kit.

G0975—1½ HP Two-Stage Quiet-Series Cyclone Dust Collector

This dust collector is ready to filter out harmful woodworking debris! The cyclonic airflow carries the largest particles to a collection drum, and the patented dual-cartridge MERV-17 HEPA filtration system traps the finest sawdust. Innovative GrowlTech™ technology streamlines routine maintenance for improved efficiency with a pressure gauge, filter status indicators, automatic filter cleaner, and full-drum indicator with automatic shutoff.



Figure 40. Model G0975 1½ HP Two-Stage Quiet-Series Dust Collector.

H2993—Machinist's Square Set, 4-Pc.
Each square is finely-ground steel and all have common beam and blade widths and thicknesses, allowing them to be used in combination. The squares in the set have been manufactured to DIN875 Grade-1 standards, ensuring accuracy for both the inside and outside right angles.

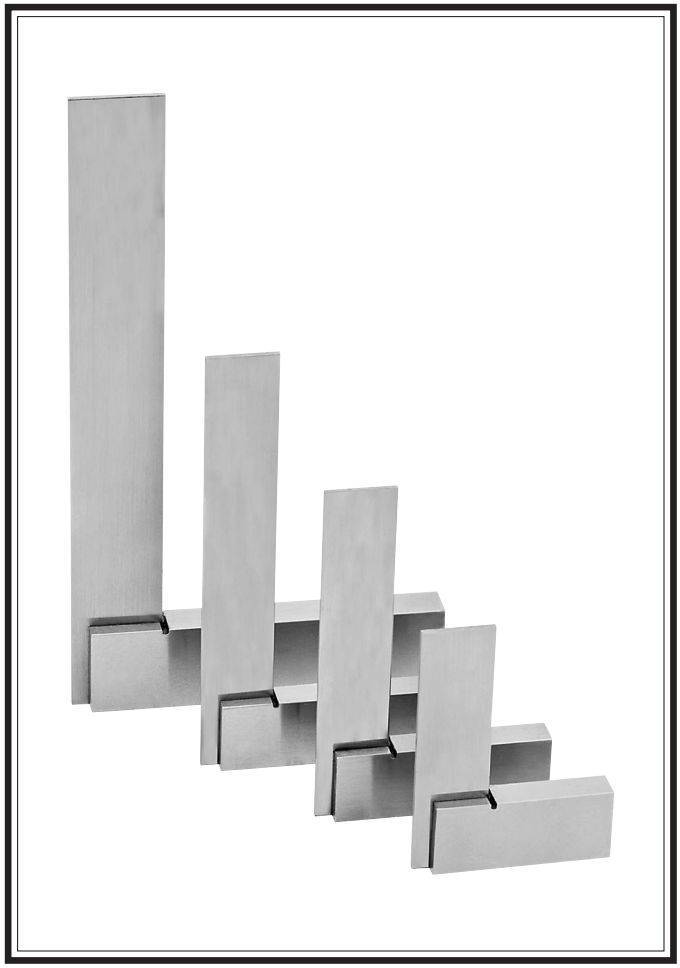


Figure 41. H2993 Machinist's Square Set.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 11 Oz. Spray



Figure 42. Recommended products for protecting unpainted cast iron/steel parts on machinery.

T21580—36" Bevel Edge Straight Edge
This 36" Bevel Edge Straight Edge is made from hardened steel with satin chrome finish and is precision ground and lapped for straightness and parallelism.

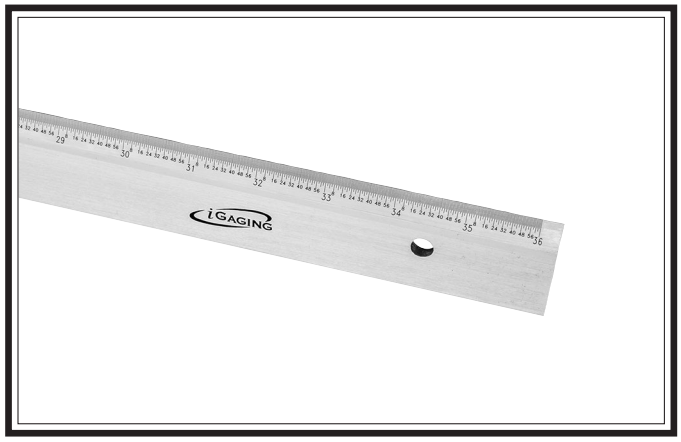


Figure 43. T21580 36" Bevel Edge Straight Edge.

T33925—1 HP VS 4-Roller Power Feeder
This 4-roller variable-speed power feeder is equipped with a 1 HP servo motor so you can feed boards with minimal down time at speeds of 3–35 FPM and 8–90 FPM. Easily view your speed choice in either US standard or metric with the LED feed rate display. A rack-and-pinion system provides smooth, methodical motion for horizontal movement, and a crank handle simplifies vertical adjustment.

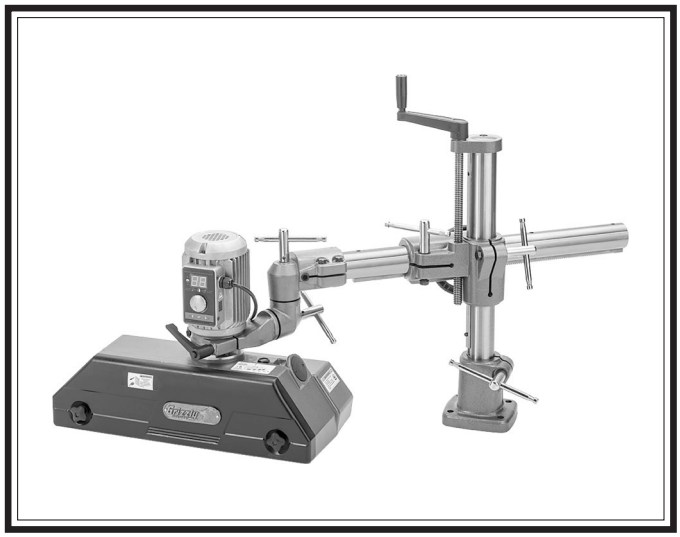


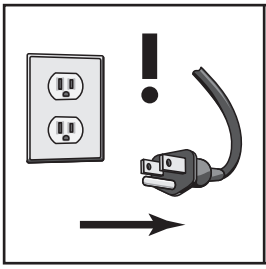
Figure 44. T33925 1 HP Variable-Speed 4-Roller Power Feeder, Single-Phase.

SB1121—South Bend Shop Stool
This sturdy stool has a 300 lb. max weight limit, and the 13"-wide premium padded seat with backrest swivels 360°. The SB1121 is 29½" tall and includes sturdy double ring design for multiple foot placement options. There is a built-in hydraulic seat adjuster that allows 4¾" of adjustment from 29½" to 34¼". Non-marring rubber are installed on the feet to protect your floors.



Figure 45. SB1121 South Bend Shop Stool.

Maintenance Schedule



⚠WARNING

Always disconnect machine from power before performing maintenance or serious personal injury may result.

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

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

Ongoing

- Loose mounting bolts.
- Damaged or dull cutterhead inserts.
- Worn or damaged wires.
- Improper height or function of cutterhead guard.
- Unprotected cast-iron surfaces.
- Dust or debris around machine.
- Any other unsafe condition.

Monthly

- Dirty or dry fence pivot points.
- Worn or damaged V-belt.
- Accumulation of dust inside stand/on motor.

Cleaning

Cleaning the Model SB1131 and SB1132 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the machine by wiping them clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep tables and fence rust-free with regular applications of products like SLIPIT®, as shown in **Figure 42** on **Page 40**.

Bare metal surfaces can quickly develop surface rust if not coated. Machinery stored near windows in direct sunlight or where paints, thinners, or certain gasses are open to the air can experience bleaching, discoloring of paint or yellowing of clear plastic guards.

Lubrication

Since all bearings on the Model SB1131 and SB1132 are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

The following is a list of components that require periodic lubrication. Be careful not to over-lubricate these components. Large amounts of lubricant will attract sawdust, causing the metal components to gum up and bind.

Fence: Clean components and place 1–2 drops of light machine oil on the fence pivot points (see **Figure 46)** as needed.

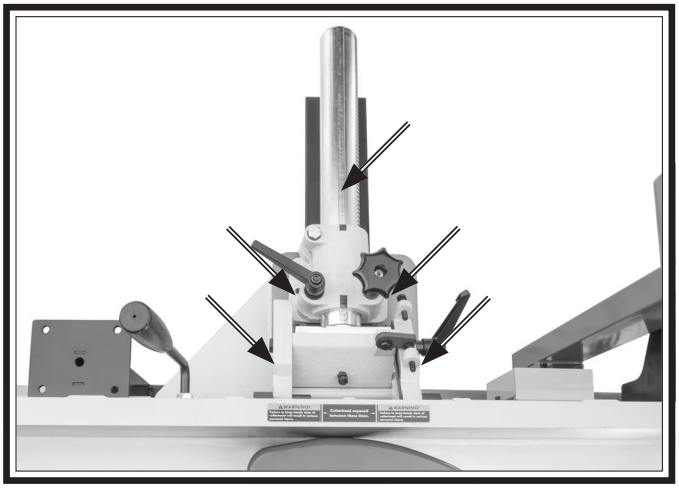


Figure 46. Fence lubrication locations.

Fence Rack: Clean components and place 1–2 drops of light machine oil on a clean cloth rag, then wipe exposed surface of fence rack (see **Figure 47**). Unlock fence and move back-and-forth through entire range of motion as needed.

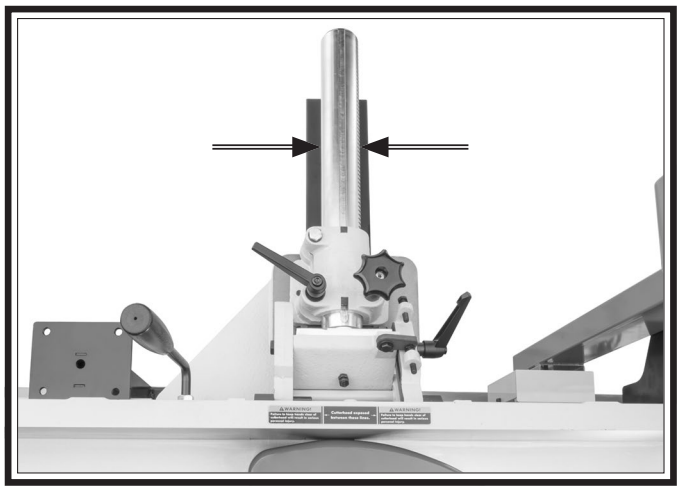


Figure 47. Fence rack lubrication locations.

Gears: Clean components and use a small brush to apply multi-purpose grease to depth-of-cut assembly worm gear components (see **Figure 48**). Raise and lower infeed table to distribute grease.

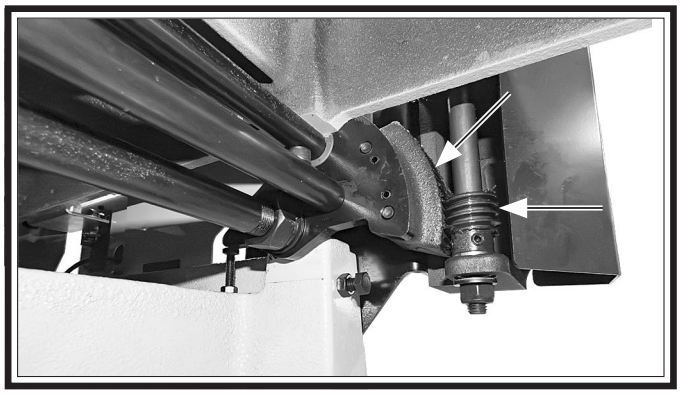


Figure 48. Worm gear lubrication locations.

Machine Storage

All machinery will develop serious rust problems and corrosion damage if it is not properly prepared for storage. If decommissioning this machine, use the steps in this section to ensure that it remains in good condition.

To prepare your machine for storage or decommission it from service:

1. DISCONNECT MACHINE FROM POWER!

2. Thoroughly clean all unpainted, bare metal surfaces, then coat them with a lightweight grease or rust preventative. Take care to ensure these surfaces are completely covered but that the grease or rust preventative is kept off of painted surfaces.

   Note: *If the machine will be out of service for only a short period of time, use way oil or a good grade of medium-weight machine oil (not auto engine oil) in place of the grease or rust preventative.*

3. Loosen or remove machine V-belts so they do not become stretched while the machine is not in use.

4. Completely cover the machine with a tarp or plastic sheet that will keep out dust and resist liquid or moisture. If machine will be stored in/near direct sunlight, use a cover that will block UV rays.

Checking/Adjusting Table Parallelism

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

Items Needed	Qty
Straightedge 48"	1
Wrench or Socket 32mm	1
Flat Head Screwdriver ⅛"	1
Hex Wrenches 4, 5, 6mm	1 Ea.
Leather Work Gloves	1

Checking Outfeed Table

1. DISCONNECT MACHINE FROM POWER!

2. Put on leather work gloves.

3. Remove cutterhead guard, and move fence all the way back and clear of tables.

   Note: *If needed, tilt fence so it does not interfere with table movement.*

4. Loosen outfeed table lock screw located on front of machine, then loosen jam nuts and positive stop bolts located under outfeed table (see **Figure 49**).

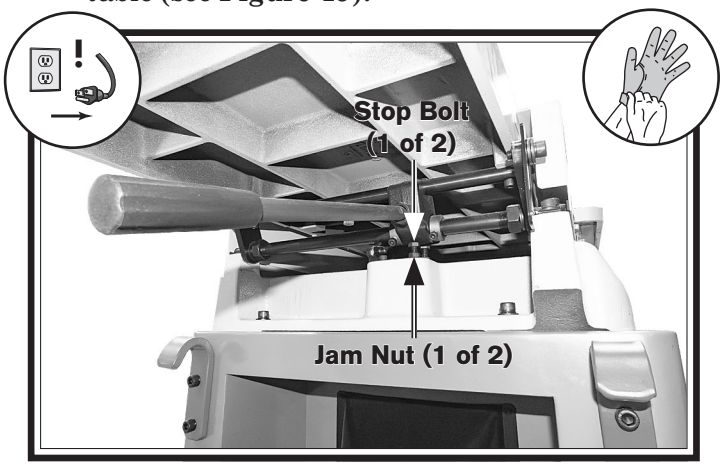


Figure 49. Outfeed table positive stop bolts.

5. Place straightedge on outfeed table so it hangs over cutterhead, then lower outfeed table until straightedge just touches cutterhead body, as shown in **Figure 50** (rotate cutterhead if necessary).

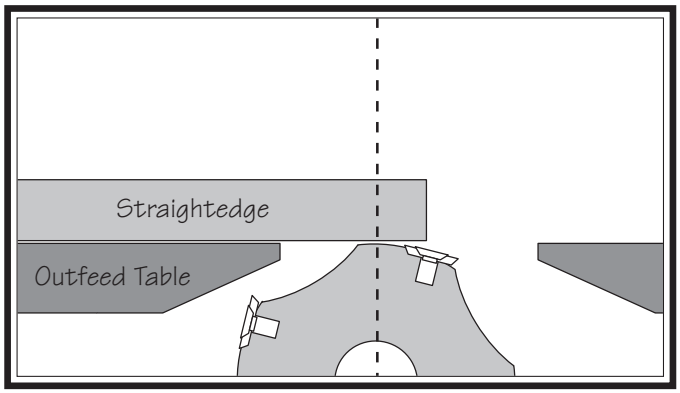


Figure 50. Adjusting outfeed table even with cutterhead body.

6. Place straightedge in positions shown in **Figure 51**. In each position, straightedge should touch cutterhead body and sit flat on outfeed table.

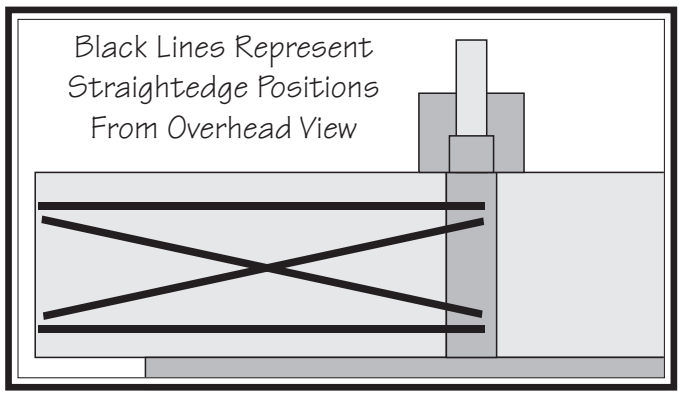


Figure 51. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

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

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

Checking Infeed Table

1. Follow all steps in **Checking Outfeed Table** on **Page 44** to make sure that outfeed table is parallel with cutterhead.

2. Raise outfeed table higher than cutterhead.

3. Loosen infeed table jam nuts shown in **Figure 52.**

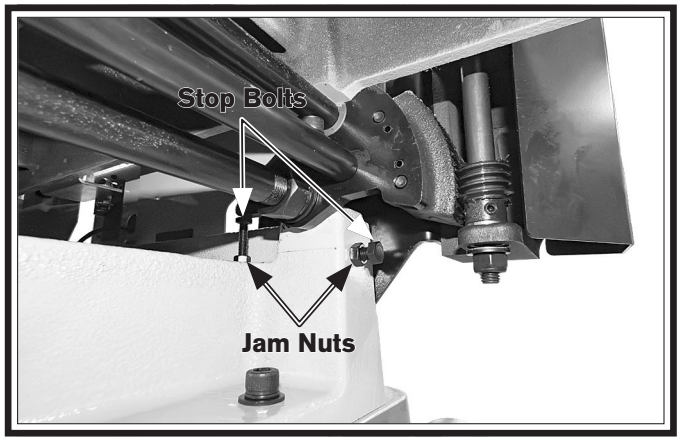


Figure 52. Infeed table positive stops.

4. Place straightedge halfway across infeed table and halfway over outfeed table, and adjust infeed table even with outfeed table, as shown in **Figure 53.**

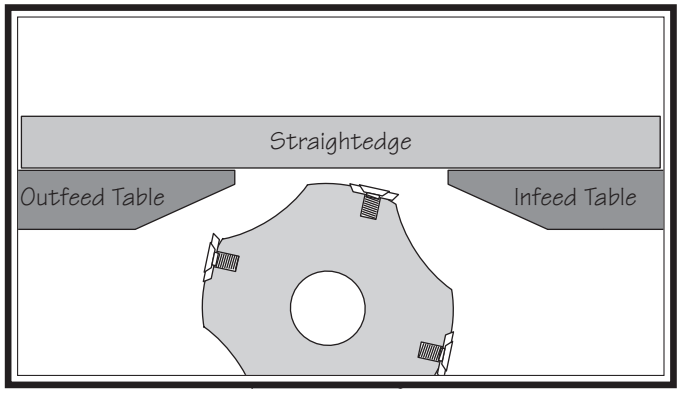


Figure 53. Infeed and outfeed tables set evenly.

5. Place straightedge in positions shown in **Figure 54.** In each position, straightedge should sit flat against both outfeed table and infeed table.

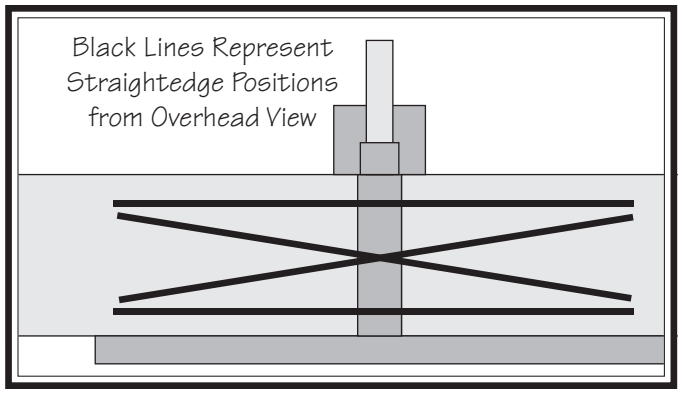


Figure 54. Straightedge positions for checking infeed/ outfeed table parallelism.

— If straightedge sits flat against both infeed and outfeed table in each positions, then tables are parallel. Set table stops and heights **(Pages 49–50)** and replace cutterhead guard.

— If straightedge *does not* sit flat against both infeed and outfeed table in any positions, then proceed to **Adjusting Table Parallelism.**

Adjusting Table Parallelism

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

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

The tables have four eccentric bushings under each corner that allow the tables to be adjusted parallel. These eccentric bushings are locked in place by set screws and adjust when rotated.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead to within 0.010"-0.012", then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements must be made from the cutterhead body—NOT the inserts.

IMPORTANT: The steps below are intended to be performed in succession with the steps involved in checking the outfeed table. DO NOT proceed until those steps are followed.

To adjust table parallelism:

1. Place straightedge on outfeed table so it hangs over cutterhead, then lower outfeed table until straightedge just touches cutterhead body, as shown in **Figure 50** on **Page 44** (rotate cutterhead if necessary).

2. Remove (4) screw covers (see **Figure 55**) covering each set screw on outfeed table.

3. Remove (4) cap screws on front and rear outfeed table covers, and (2) cap screws on cutterhead cover (see **Figure 55**), then remove covers.

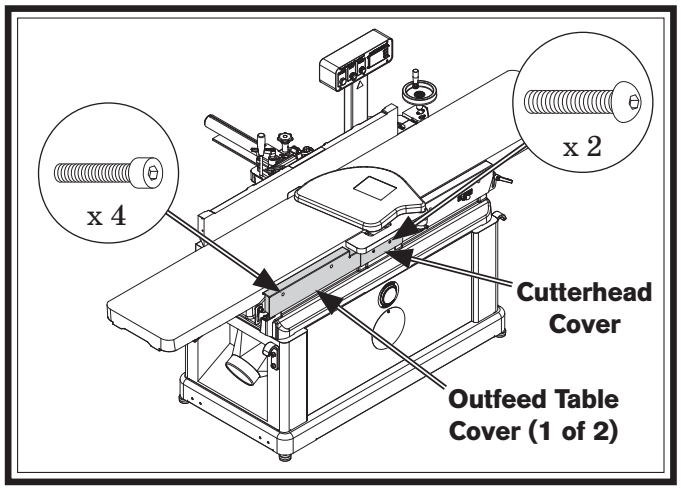


Figure 55. Location of cover fasteners.

4. Place straightedge in one of the positions shown in **Figure 54** on **Page 45**, and adjust table by loosening eccentric bushing set screws, then turning eccentric bushings (**Figure 56**–**Figure 59**) as needed so that straightedge touches cutterhead while lying flat across outfeed table. Repeat this step with each remaining straightedge position as many times as necessary until outfeed table is parallel with cutterhead to within 0.010"–0.012".

   Note: *Setting the outfeed table parallel to the cutterhead within 0.010"–0.012" will produce high quality results. Going lower than this number will produce minimal gain.*

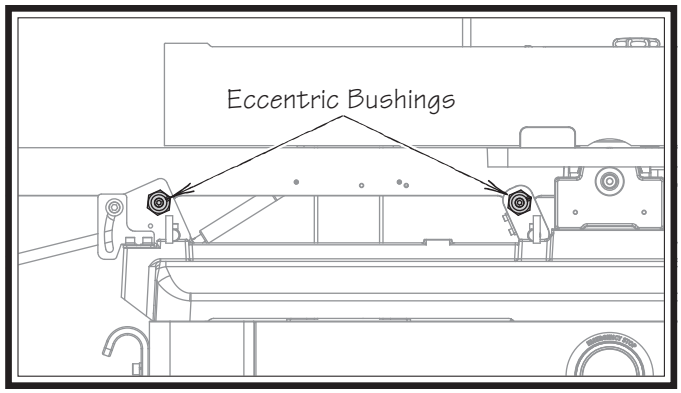


Figure 56. Front outfeed eccentric bushings.

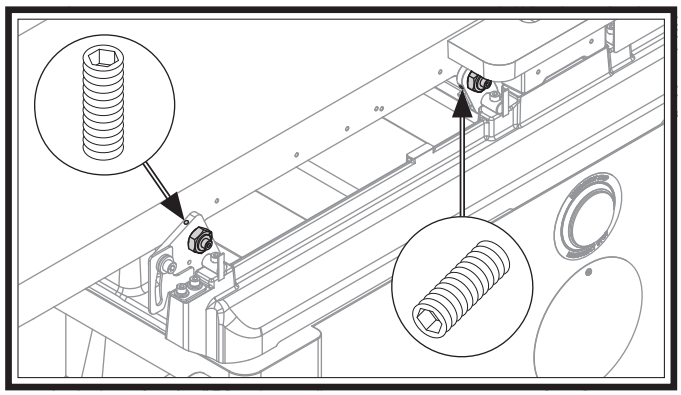


Figure 57. Front outfeed eccentric bushing set screws.

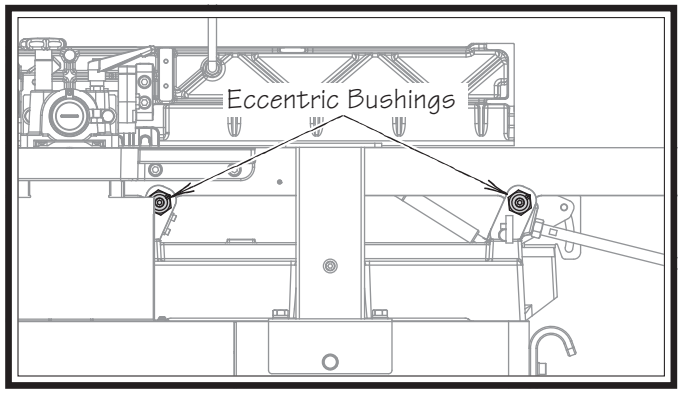


Figure 58. Rear outfeed eccentric bushings.

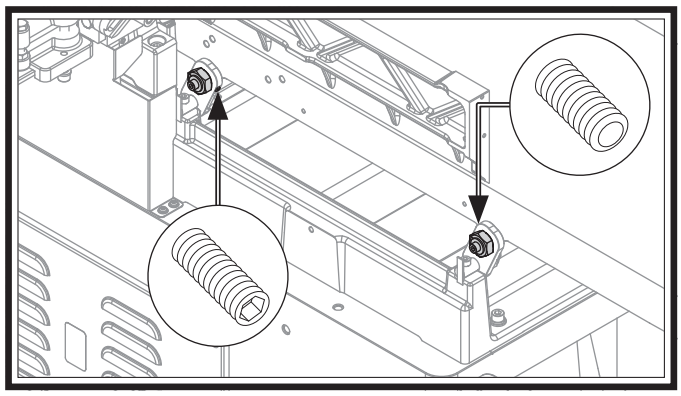


Figure 59. Rear outfeed eccentric bushing set screws.

5. Tighten set screw on eccentric bushings adjusted in **Step 4.**

6. Set depth-of-cut to "0", then remove (5) cap screws, lock washers, and flat washers shown in **Figure 60** to remove depth-of-cut scale assembly.

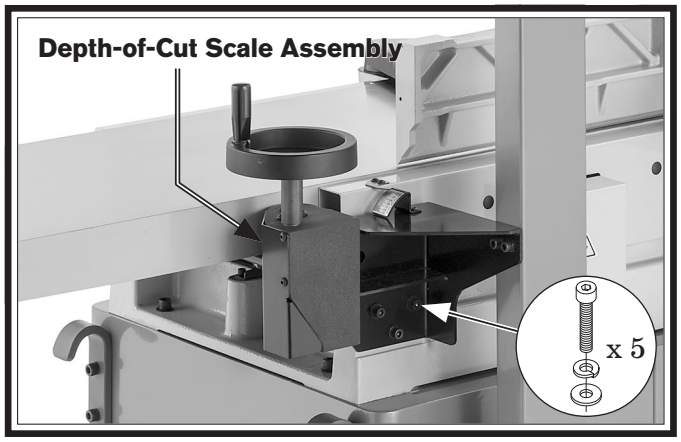


Figure 60. Location of assembly fasteners.

7. Remove (4) screw covers covering each set screw on infeed table (see **Figure 61**).

8. Loosen and remove infeed table lock-pin knob (see **Figure 61**).

9. Loosen (4) cap screws on front and rear infeed table covers (see **Figure 61**), then remove covers.

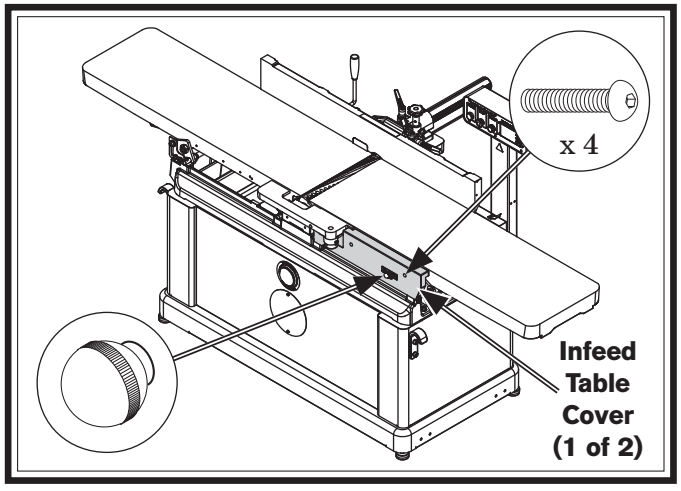


Figure 61. Location of infeed table fasteners.

10. Re-install depth-of-cut scale assembly removed in **Step 6**, then place straightedge halfway across infeed table and halfway over outfeed table, and adjust infeed table even with outfeed table (see **Figure 62**).

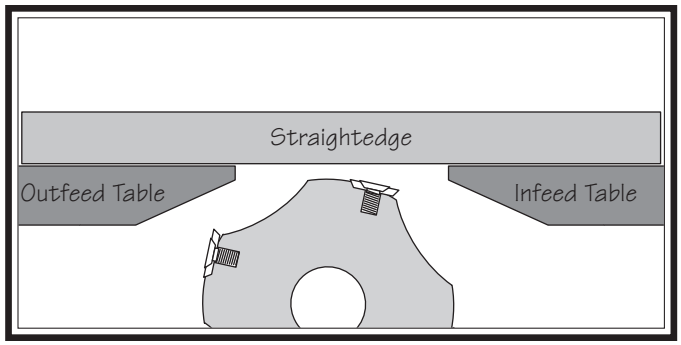


Figure 62. Infeed and outfeed tables set evenly.

11. Place straightedge in one of the positions shown in **Figure 54** on **Page 45**, and adjust eccentric bushings under infeed table (see **Figure 63**) so straightedge lies flat against both tables. Repeat this step with each remaining straightedge position as many times as necessary until infeed table is parallel with outfeed table.

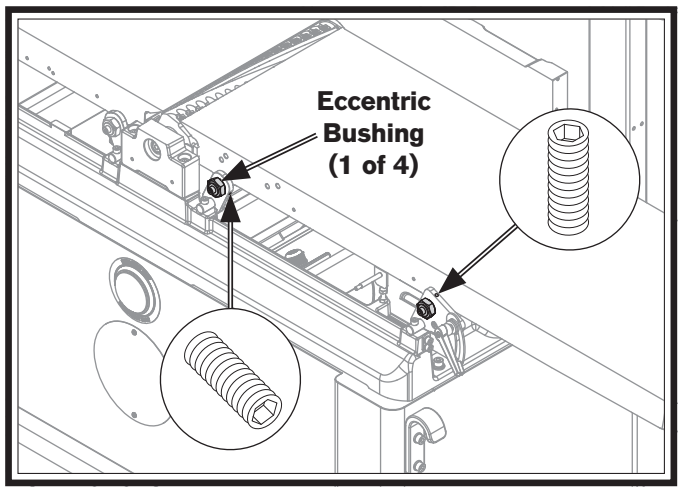


Figure 63. Location of infeed table eccentric bushings (2 of 4 shown).

12. Tighten set screw on eccentric bushings adjusted in **Step 10.**

13. Set outfeed table height (refer to **Setting Outfeed Table Height** on **Page 50**).

14. Re-install cutterhead guard and fence.

Replacing Indexable Inserts

The helical-style cutterhead is equipped with 4-sided indexable carbide inserts. Each insert can be removed, rotated, and re-installed to use either of its four cutting edges. If one cutting edge becomes dull or damaged, simply rotate it 90° (see **Figure 64)** to use a sharp cutting edge.

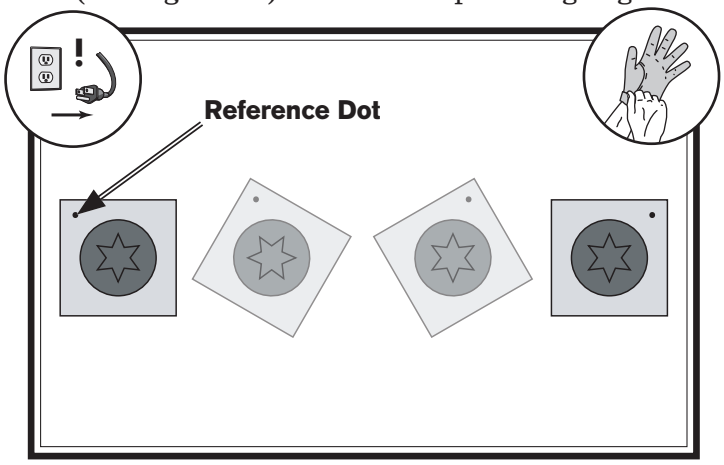


Figure 64. Insert rotating sequence.

The inserts have a reference dot on one corner. The position of the reference dot on installed inserts can be used to track which edges are sharp/unused and which edges are dull or damaged. Replace inserts once the reference dot has been rotated back to its original position.

Items Needed	Qty
Leather Work Gloves	1 Pr.
Indexable Inserts 15 x 15 x 2.5mm	As Needed
Flat Head Torx Screws 10-32 x ½"	As Needed
T-Handle Torx Driver T-25	1
Hex Wrenches 4, 5mm	1 Ea.
Light Machine Oil	As Needed
Clean Shop Rags	As Needed

⚠CAUTION

Indexable inserts are very sharp and can easily cut your hands. ALWAYS use caution when handling these parts to reduce risk of personal injury.

To replace indexable inserts:

1. DISCONNECT MACHINE FROM POWER!
2. Set fence to 90° and move it all the way back.
3. Remove cutterhead guard.
4. Remove any sawdust from head of insert Torx screw.
5. Remove Torx screw and insert.
6. Clean all dust and dirt off insert and cutterhead pocket from which insert was removed, and replace insert so a fresh, sharp edge is facing outward.

   Note: *Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will slightly raise insert, and make noticeable marks on your workpieces the next time you cut.*

7. Lubricate Torx screw threads with light machine oil, wipe excess oil off threads, and tighten Torx screw to 48–50 in.-lbs.

   Note: *Excess oil may squeeze between insert and cutterhead or in screw hole, thereby lifting insert or screw slightly and affecting workpiece finishes.*

8. Install cutterhead guard, tighten shaft lock, then refer to **Checking/Adjusting Cutterhead Guard** on **Page 51**.

Setting Positive Stops

The tables on the Model SB1131 and SB1132 have positive stop bolts that, when properly set up, allow the operator to quickly adjust the tables between finish/final cuts and shaping/heavy cuts.

We recommend setting the minimum depth of cut to 1/32" and the maximum depth of cut to 1/8" for most operations.

⚠WARNING

DO NOT exceed 1/8" cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!

Each positive stop bolt (see **Figure 65**–**Figure 66**) controls top or bottom range of table movement. The jam nuts lock the positive stop bolts in position so they remain secure during operation.

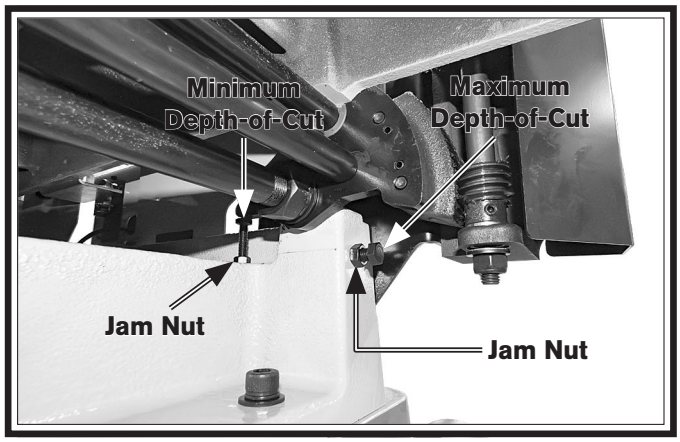


Figure 65. Infeed table positive stops.

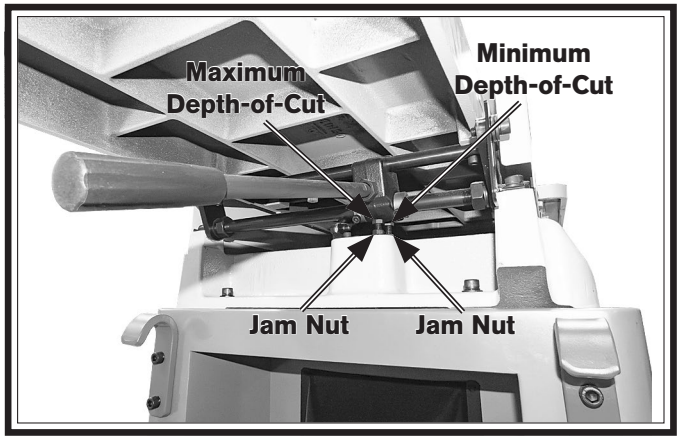


Figure 66. Outfeed table positive stops.

Calibrating DRO

The DRO can be calibrated or "zeroed" if it is not showing accurate measurements.

Tool Needed	Qty
Straightedge	1

To calibrate DRO:

1. Set outfeed table height per **Setting Outfeed Table Height** on **Page 50**.
2. Move cutterhead guard out of the way.
3. Place straightedge across infeed and outfeed tables.
4. Adjust infeed table until it is level with outfeed table (see **Figure 67**).

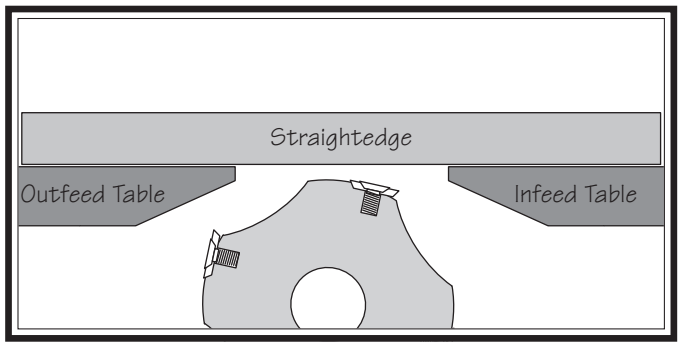


Figure 67. Infeed and outfeed tables set evenly.

5. Remove straightedge then perform one of the following actions depending on desired measurement mode:

   — **INC:** Short press CAL/0 button to reset INC value to zero.

   — **ABS:** Press and hold CAL/0 button for two seconds to reset ABS value to zero.

   Note: *The DRO features a sleep mode that will automatically turn screen **OFF** after 10 minutes of inactivity. Press any button on DRO or adjust infeed table height to wake screen.*

Setting Outfeed Table Height

The outfeed table height MUST be level with the indexable inserts when they are at top-dead-center. If the outfeed table is set too low, the workpiece will be tapered from front to back. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

Items Needed	Qty
Straightedge 48"	1
Open-End Wrenches 13mm	2
Hex Wrench 8mm	1

To set outfeed table height:

1. DISCONNECT MACHINE FROM POWER!

2. Move cutterhead guard out of the way or remove it, then remove belt guard and move fence all the way back.

3. Place a straightedge on outfeed table so it extends over cutterhead, and rotate cutterhead pulley until one of the indexable inserts is at top-dead-center (TDC), as shown in **Figure 68**.

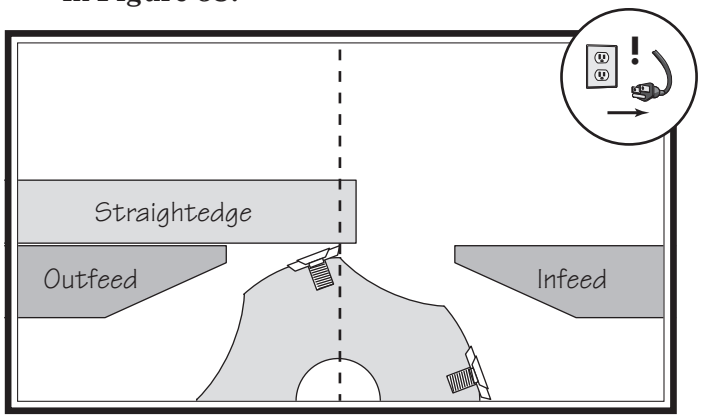


Figure 68. Cutterhead insert at top-dead-center.

4. When correctly set, indexable insert will just touch straightedge when insert is at its highest point of rotation (see **Figure 68**).

   — If outfeed table is correctly set, no adjustments are necessary.

   — If insert lifts straightedge off table, or insert is below straightedge, loosen outfeed table lock screw and outfeed table positive stop bolts and jam nuts, then adjust outfeed table height.

   Tip: *Some advanced woodworkers have found that they can virtually eliminate snipe by setting outfeed table in the following manner: Repeat **Steps 1–4** using a freshly exposed insert, then lower outfeed table slightly so insert lifts straightedge off table. Place a ruler next to straightedge and rotate cutterhead, watching how far indexable insert pulls straightedge. Adjust outfeed table and recheck until straightedge only moves 5/32".*

5. Tighten outfeed table lock screw, lock outfeed table positive stop bolts, and re-install cutterhead guard and belt guard.

6. Verify proper operation of cutterhead guard by pulling cutterhead guard back and letting it go. It should spring back over cutterhead and contact fence without dragging across outfeed table.

   — If cutterhead guard *does not* spring back over cutterhead and contact fence, or it drags across outfeed table, then it must be adjusted (see **Checking/Adjusting Cutterhead Guard** on **Page 51**).

⚠WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

Checking/Adjusting Cutterhead Guard

⚠WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

The cutterhead guard is designed to reduce the risk of accidental contact with hands or fingers with the spinning cutterhead. When properly installed and functioning correctly, the guard automatically rotates clear of the cutterhead during the cutting operation and then springs back over the cutterhead as soon as the operation is complete.

In order to function as intended, the guard must be installed as low as possible over the infeed table without actually touching it (approximately 5/16" above infeed table), and it must have enough spring tension at the mounting shaft to quickly reposition itself against the fence after it is rotated away from the cutterhead and released. Before performing rabbeting operations, adjust guard height to just clear outfeed table.

Items Needed	Qty
Hex Wrench 6mm	1
Leather Work Gloves	1 Pr.

To check/adjust cutterhead guard:

1. DISCONNECT MACHINE FROM POWER!

2. Set fence to 90° and move it all the way back, then pull cutterhead guard (see **Figure 69**) and let it go.

   — If cutterhead guard springs back over cutterhead, contacts fence, and *does not* drag across infeed table, then it is properly adjusted.

   — If cutterhead guard *does not* spring back over cutterhead, *does not* contact fence, or drags across infeed table, then proceed to **Step 3**.

3. Loosen cap screw on shaft lock (see **Figure 69**), then move guard so it is resting against fence and 5/16" above infeed table.

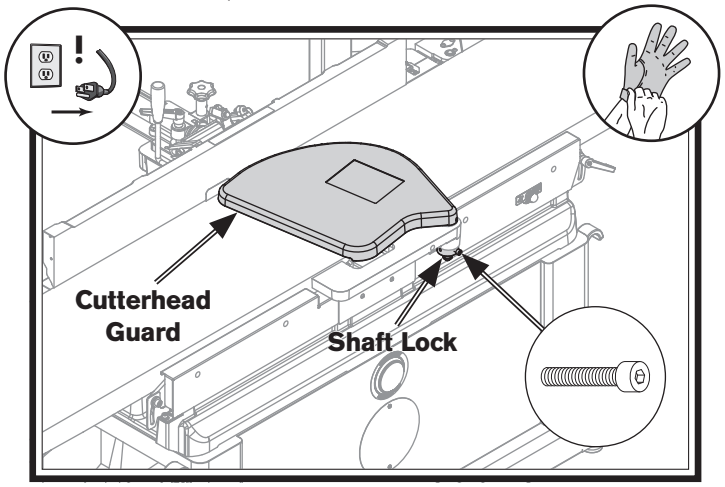


Figure 69. Cutterhead guard components.

4. Position guard height as low as possible without dragging on tables/rabbeting ledge (approximately 5/16" above outfeed table), rotate shaft lock counterclockwise to pre-load spring, then tighten shaft lock cap screw to secure.

5. Repeat **Step 2** and, if necessary, repeat **Steps 3–4** until cutterhead guard is properly adjusted.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45˚, 90˚, and 135˚.

Tools Needed	Qty
Square 90˚	1
Sliding Bevel or Miter Square	1
Open-End Wrenches 10, 13mm	1 Ea.

Setting 90˚ Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock handle (see **Figure 70**).

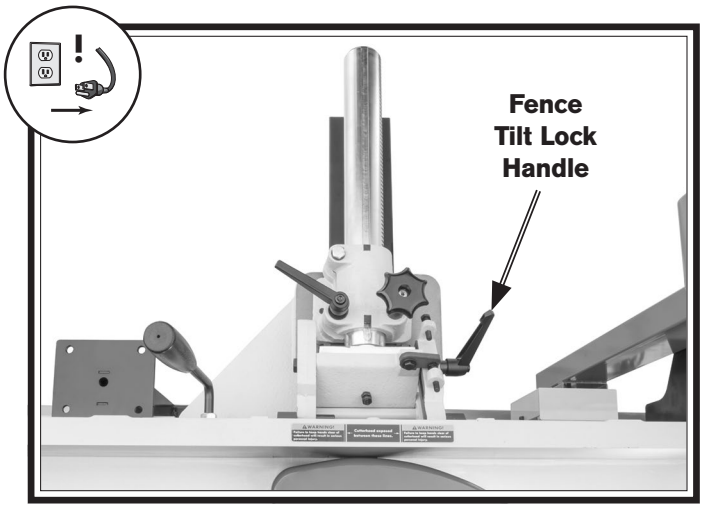


Figure 70. Location of fence tilt lock handle.

3. Using a 90˚ square, adjust fence to 90˚ position (see **Figure 71**), then tighten fence tilt lock handle.

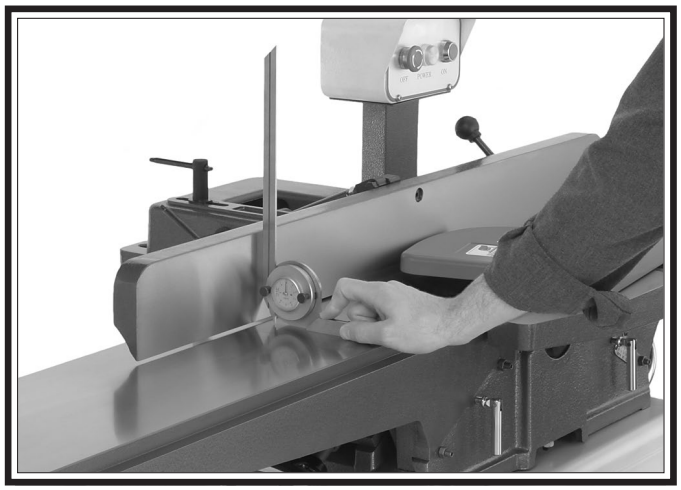


Figure 71. Example of adjusting fence to 90˚.

4. Flip swing stop into position (see **Figure 72**).

5. Loosen jam nut on 90˚ stop bolt, as shown in **Figure 72**.

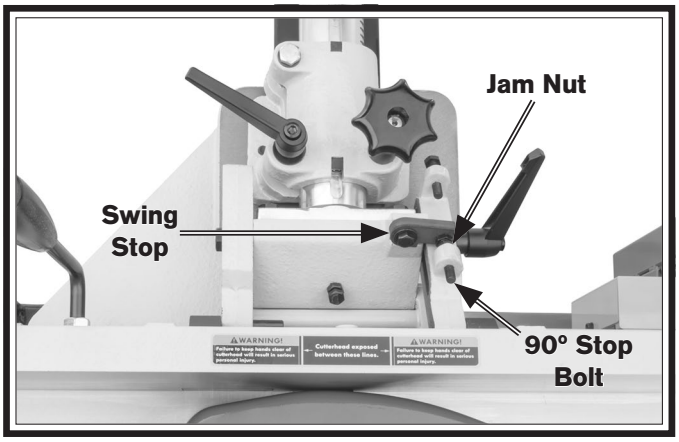


Figure 72. 90˚ fence stop engaged.

6. Adjust 90˚ stop bolt until it makes contact with swing stop, then tighten jam nut loosened in **Step 5**.

Setting 45˚ Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock handle (see **Figure 70**).

3. Using a sliding bevel or miter square, adjust fence to 45˚ position (see **Figure 73**), then tighten fence tilt lock handle.

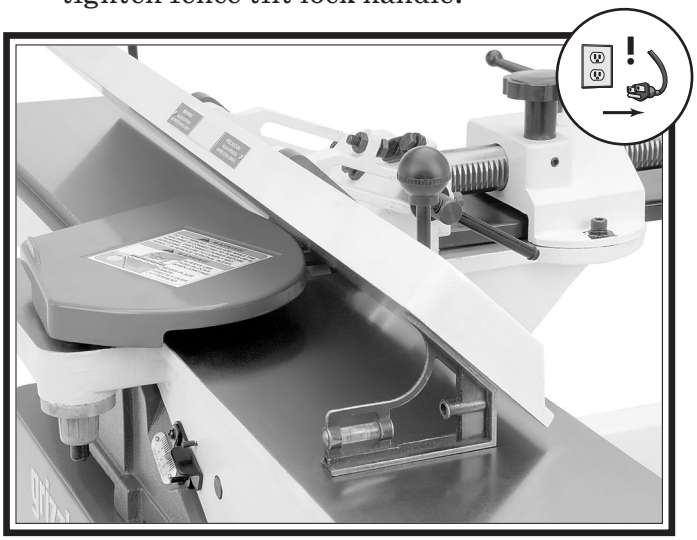


Figure 73. Example of adjusting fence to 45˚.

4. Flip swing stop into position (see **Figure 74**).

5. Loosen jam nut on 45˚ stop bolt, as shown in **Figure 74**.

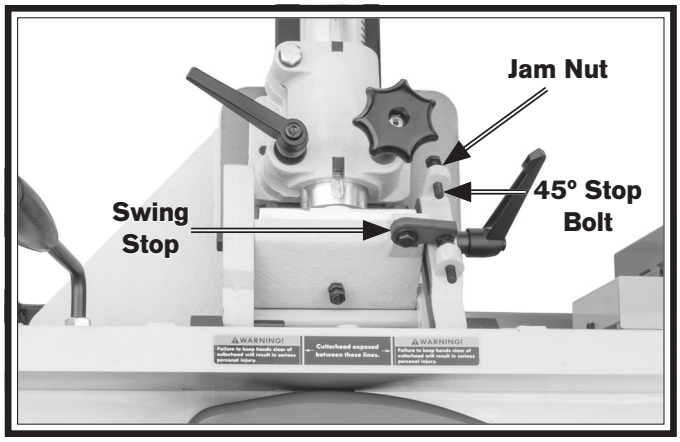


Figure 74. Location of 45˚ fence stop components.

6. Adjust 45˚ stop bolt until it makes contact with swing stop, then tighten jam nut loosened in **Step 5**.

Setting 135˚ Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock handle, as shown in **Figure 70** on **Page 52**.

3. Using a sliding bevel or miter square, adjust fence to 135˚ position (see **Figure 75**), then tighten fence tilt lock handle.

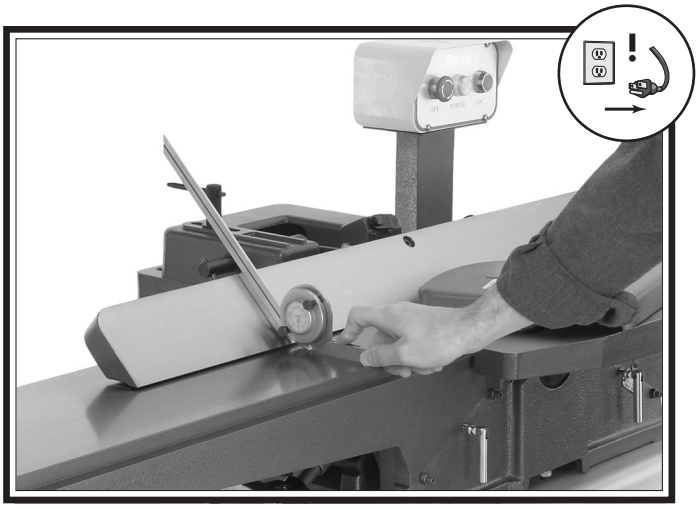


Figure 75. Example of adjusting fence to 135˚.

4. Loosen jam nut on 135˚ fence stop bolt (see **Figure 76**).

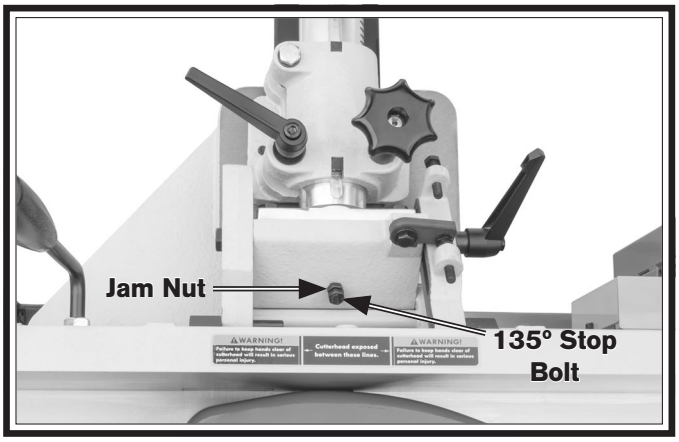


Figure 76. Location of 135˚ fence stop components.

5. Adjust 135˚ stop bolt until it makes contact with fence, then tighten jam nut loosened in **Step 4**.

Replacing/Tensioning V-Belt

To ensure optimum power transmission from the motor to the cutterhead, the belt must be in good condition (free from cracks, fraying, and wear) and properly tensioned.

Items Needed	Qty
Replacement V-Belt (PSB1131214)	1
Open-End Wrench 17/19mm	1
Phillips Head Screwdriver #2	1

Replacing V-Belt

1. DISCONNECT MACHINE FROM POWER!

2. Remove rear access panel and belt guard.

3. Loosen adjustment nuts on tension rod (see **Figure 77)** to raise motor.

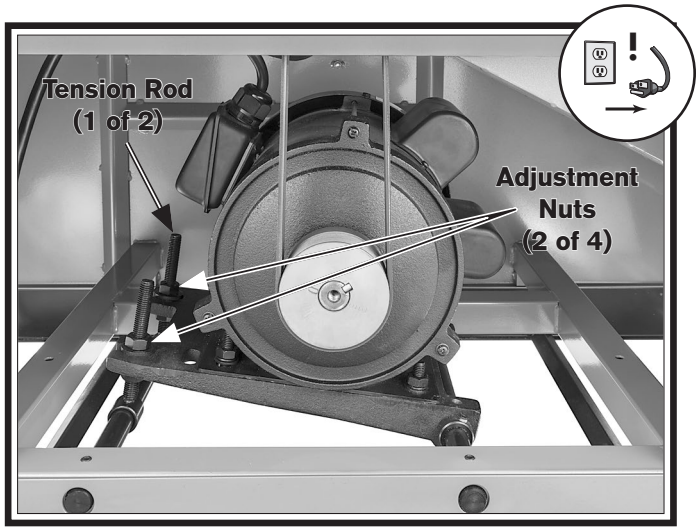


Figure 77. V-belt tension adjustment components.

4. Slide belt off motor and cutterhead pulleys, and replace with a new one.

5. Proceed to **Step 3** of **Tensioning V-Belt**.

Tensioning V-Belt

1. DISCONNECT MACHINE FROM POWER!

2. Remove rear access panel and belt guard.

3. Tighten tension rod adjustment nuts so there is approximately ½" deflection when belt is pushed with moderate pressure, as shown in **Figure 78**.

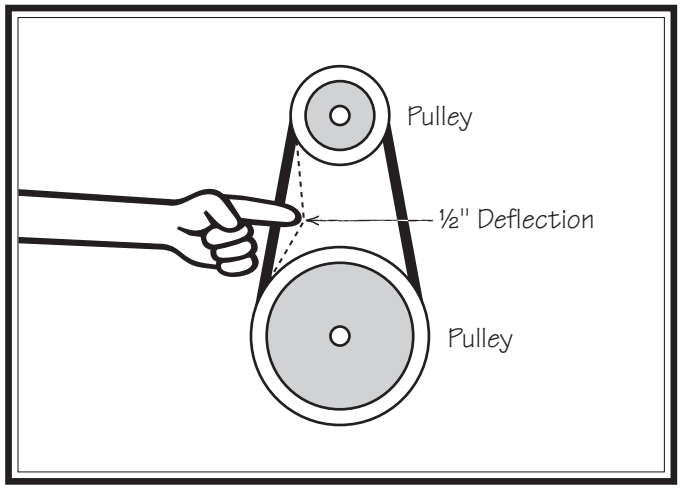


Figure 78. Checking V-belt tension.

4. Install rear access panel and belt guard.

Aligning Pulleys

The pulleys should be parallel to each other and in the same plane (coplanar) for optimum performance.

Tools Needed	Qty
Straightedge 48"	1
Open-End Wrench 17/19mm	1
Phillips Head Screwdriver #2	1
Hex Wrenches 3, 8mm	1 Ea.

To align pulleys:

1. DISCONNECT MACHINE FROM POWER!

2. Remove rear access cover and belt guard, then loosen (2) cap screws behind fence and remove fence assembly (see **Figure 79**).

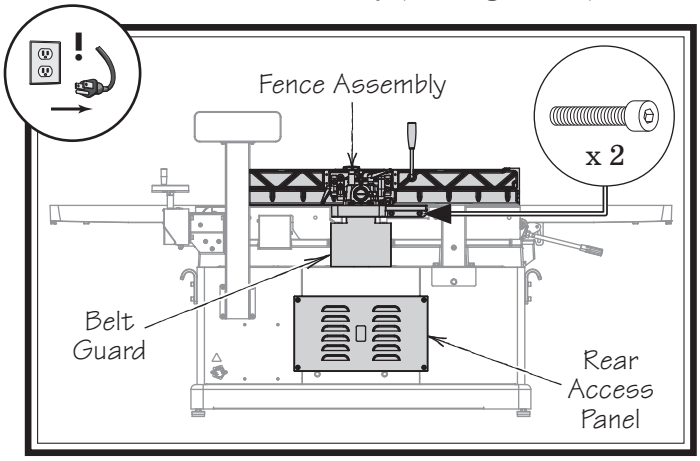


Figure 79. Location of fence assembly fasteners.

3. Place a straightedge against both pulleys (see **Figure 80**) and check to make sure they are aligned and that V-belt is straight up and down (see **Figure 81**).

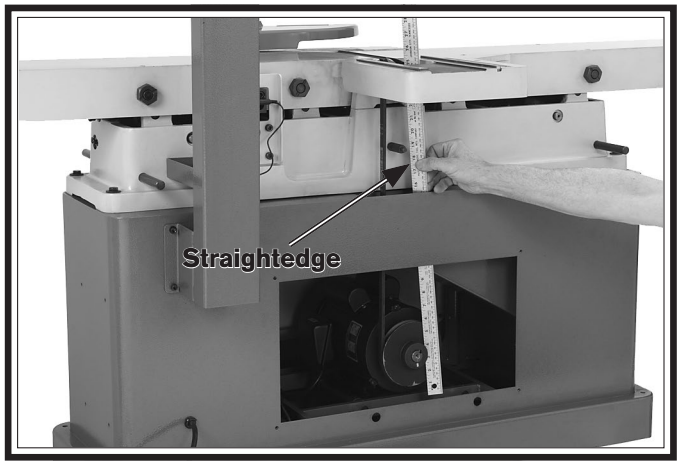


Figure 80. Example of checking belt alignment.

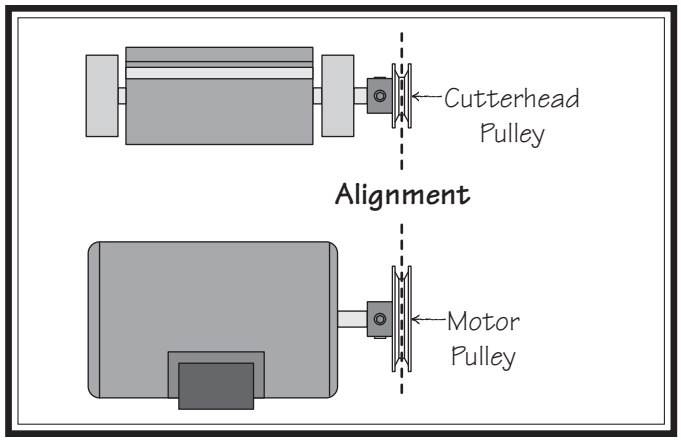


Figure 81. Example of V-belt aligned with pulleys.

— If pulleys *are* aligned, go to **Step 7**.

— If pulleys *are not* aligned, go to **Step 4**.

4. Loosen motor mount adjustment nuts shown in **Figure 82**.

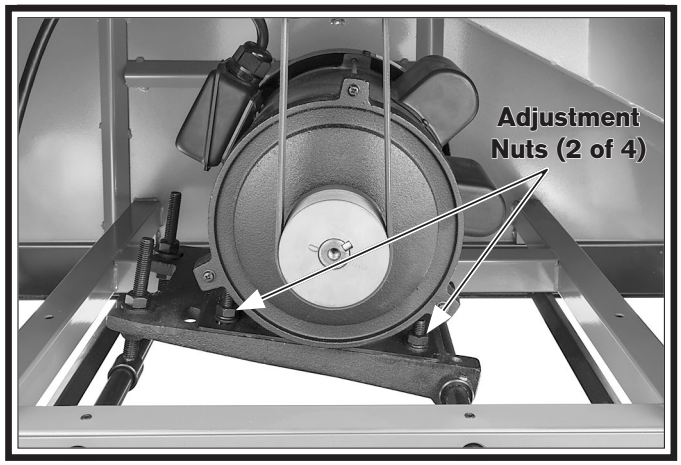


Figure 82. Motor mount adjustment nuts.

5. Shift motor horizontally as needed to align motor pulley with cutterhead pulley.

6. Tighten motor mount adjustment nuts. V-belt should be parallel and aligned as shown in **Figure 81**.

7. Install fence assembly, rear access panel, and belt guard.

If you need replacement parts, or if you are unsure how to do any of the solutions given here, feel free to call us at (360) 734-1540.

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker trips immediately after startup.	1. EMERGENCY STOP button depressed.	1. Rotate EMERGENCY STOP button head to reset.
	2. Knee Stop button is engaged.	2. Cycle machine power to reset Knee Stop button.
	3. Power supply circuit breaker tripped or fuse blown.	3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.
	4. Thermal overload relay has tripped.	4. Reset relay.
	5. Blown machine fuse (SB1132).	5. Replace fuse/ensure no shorts.
	6. Incorrect power supply voltage or circuit size.	6. Ensure correct power supply voltage and circuit size.
	7. Plug/receptacle at fault/wired incorrectly (SB1132).	7. Test for good contacts; correct wiring **(Page 61)**.
	8. Motor wires connected incorrectly.	8. Correct motor wiring connections **(Page 59)**.
	9. Centrifugal switch needs adjustment/contact points dirty (SB1131).	9. Adjust centrifugal switch/clean contact points.
	10. Wiring broken, disconnected, or corroded.	10. Fix broken wires or disconnected/corroded connections **(Page 59)**.
	11. Motor or motor bearings at fault.	11. Replace motor.
Machine stalls or is underpowered.	1. Motor wires connected incorrectly.	1. Correct motor wiring connections **(Page 59)**.
	2. Plug/receptacle at fault/wired incorrectly.	2. Test for good contacts/correct wiring **(Page 59)**.
	3. Motor overheated.	3. Clean motor, let cool, and reduce workload.
	4. Centrifugal switch needs adjustment/contact points dirty (SB1131).	4. Adjust centrifugal switch/clean contact points.
	5. Motor or motor bearings at fault.	5. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose.	1. Replace damaged or missing bolts/nuts or tighten if loose.
	2. Motor mount loose/broken.	2. Tighten/replace.
	3. Motor fan rubbing on fan cover.	3. Fix/replace fan cover; replace loose/damaged fan.
	4. Centrifugal switch needs adjustment.	4. Adjust switch.
	5. Motor bearings at fault.	5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Machine operates in reverse (SB1132).	1. Power connections wired out of phase.	1. Correct phase polarity **(Page 17)**.
Digital readout does not work/ display is incorrect.	1. Wiring broken, disconnected, or corroded.	1. Fix broken wires or disconnected/corroded connections **(Page 59)**.

Symptom	Possible Cause	Possible Solution
Machine stalls or is underpowered (Operations).	1. Workpiece material unsuitable for machine. 2. Feed rate/cutting speed too fast. 3. Machine undersized for task. 4. Belt slipping/pulleys misaligned. 5. Pulley/sprocket slipping on shaft.	1. Only cut wood/ensure moisture content is below 20% **(Page 32)**. 2. Decrease feed rate/cutting speed. 3. Use correct/sharp inserts **(Page 48)**. Reduce feed rate or depth of cut **(Page 38)**. 4. Clean/tension/replace belt **(Page 54)**; ensure pulleys are aligned **(Page 55)**. 5. Tighten/replace loose pulley/shaft.
Machine has vibration or noisy operation (Operations).	1. Stand feet not adjusted properly. 2. V-belt worn, loose, pulleys misaligned or belt slapping cover. 3. Insert(s) are at fault. 4. Pulley loose. 5. Cutterhead bearings at fault.	1. Adjust stand feet to stabilize machine **(Page 24)**. 2. Inspect/replace belt **(Page 54)**. Realign pulleys if necessary **(Page 55)**. 3. Replace/rotate insert(s) **(Page 48)**. 4. Secure pulley on shaft. 5. Replace bearing(s)/realign cutterhead.
Table is hard to adjust.	1. Table lock engaged/partially engaged. 2. Table stop blocking movement.	1. Completely loosen table lock. 2. Loosen/reset table positive stop **(Page 49)**.
Excessive snipe (gouge in end of board that is uneven with rest of cut); back of workpiece is concave.	1. Outfeed table set too low. 2. Operator pushing down on trailing end (infeed side) of workpiece as it leaves cutterhead.	1. Align outfeed table with cutterhead inserts at top dead center **(Page 50)**. 2. Focus most of the workpiece pressure against outfeed table while cutting.
Workpiece stops in middle of cut; front of workpiece is concave.	1. Outfeed table set too high.	1. Align outfeed table with cutterhead inserts at top dead center **(Page 50)**.
Workpiece chipping, tear-out, indentations, or overall rough cuts.	1. Workpiece rough or has loose knots/surface flaws; not suitable for jointing. 2. Not feeding workpiece to cut "with" the grain. 3. Dull/nicked/chipped insert(s). 4. Feeding workpiece too fast. 5. Excessive depth of cut. 6. Lack of proper dust collection or clogged dust port.	1. Inspect workpiece **(Page 32)**. Use smooth stock without loose knots/surface flaws. 2. Flip workpiece 180° before feeding again. 3. Rotate/replace insert(s) **(Page 48)**. 4. Reduce feed rate. 5. Reduce depth of cut **(Page 38)**. 6. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector.

Symptom	Possible Cause	Possible Solution
Fuzzy grain left in workpiece.	1. Wood has high moisture content. 2. Dull insert(s).	1. Ensure wood moisture content is less than 20% **(Page 32)**. Allow to dry if necessary. 2. Replace/rotate insert(s) **(Page 48)**.
Long lines or ridges that run along the length of the board.	1. Nicked or chipped insert(s). 2. Insert(s) not at even heights in cutterhead.	1. Replace/rotate insert(s) **(Page 48)**. 2. Remove insert(s), clean bottom of insert/cutterhead mounting pocket and re-install **(Page 48)**.
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	1. Feeding workpiece too fast. 2. Insert(s) not at even heights in cutterhead.	1. Reduce feed rate. 2. Remove insert(s), clean bottom of insert/cutterhead mounting pocket and re-install **(Page 48)**.
Glossy surface; scorching or burn marks on workpiece.	1. Dull insert(s). 2. Feed rate too slow.	1. Replace/rotate insert(s) **(Page 48)**. 2. Increase feed rate.
Workpiece is concave or convex along its length after jointing.	1. Workpiece not held with even pressure against outfeed table during cut. 2. Workpiece too uneven at start of operation. 3. Tables not parallel with cutterhead and each other.	1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut. 2. Take partial cuts to remove extreme high spots before doing a full pass. 3. Check/adjust table parallelism **(Page 44)**.
Workpiece edges not square; tapered cut produced.	1. Fence not square to table(s); fence tilt unlocked. 2. Insert(s) not at even heights in cutterhead. 3. Warped infeed or outfeed table.	1. Square fence to table(s) **(Page 52)**; lock fence. 2. Remove insert(s), clean bottom of insert/cutterhead mounting pocket and re-install **(Page 48)**. 3. Regrind/replace table.

Electrical Safety Instructions

These pages are accurate at the time of printing. In the constant effort to improve, however, we may make changes to the electrical systems of future machines. Study this section carefully. If you see differences between your machine and what is shown in this section, call Technical Support at (360) 734-1540 for assistance BEFORE making any changes to the wiring on your machine.

Shock Hazard: It is extremely dangerous to perform electrical or wiring tasks while the machine is connected to the power source. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. For your own safety, disconnect machine from the power source before servicing electrical components or performing any wiring tasks!

Wire Connections: All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

Modifications: Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

Motor Wiring: The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

Circuit Requirements: Connecting the machine to an improperly sized circuit will greatly increase the risk of fire. To minimize this risk, only connect the machine to a power circuit that meets the minimum requirements given in this manual.

Capacitors/Inverters: Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

Wire/Component Damage: Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

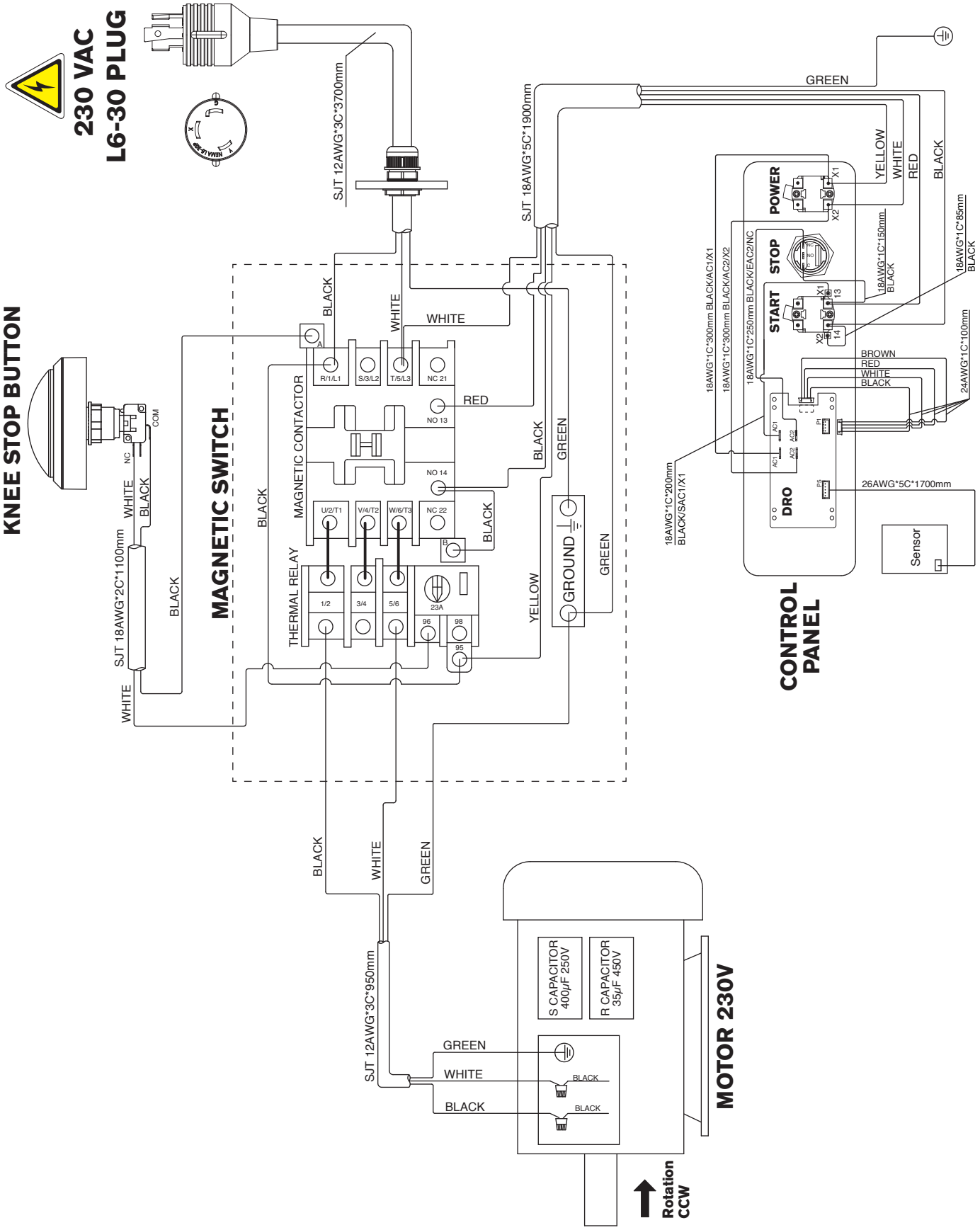
Experiencing Difficulties: If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-1540.

WIRING DIAGRAM COLOR KEY

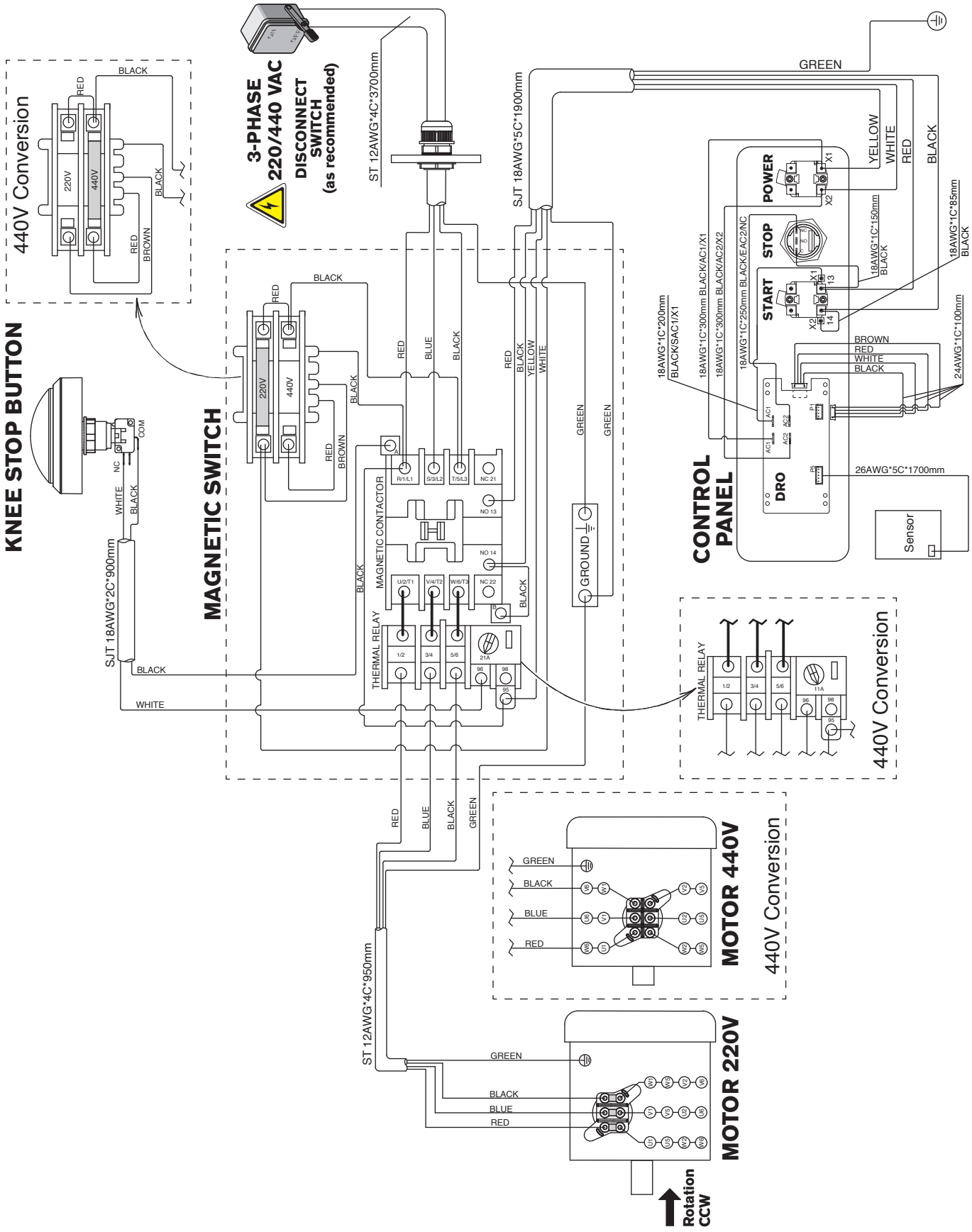
BLACK (Bk)	BLUE WHITE (Bw)	RED (Rd)	PINK (Pk)	WHITE (Wt)
BLUE (Bl)	GREEN (Gn)	LIGHT BLUE (Lb)	PURPLE (Pu)	YELLOW GREEN (Yg)
BROWN (Br)	GRAY (Gy)	ORANGE (Or)	TURQUOISE (Tu)	YELLOW (Yl)

NOTICE: **The photos and diagrams included in this section are best viewed in color. You can see them in color at www.southbendtools.com.**

SB1131 Wiring Diagram



SB1132 Wiring Diagram



Electrical Components

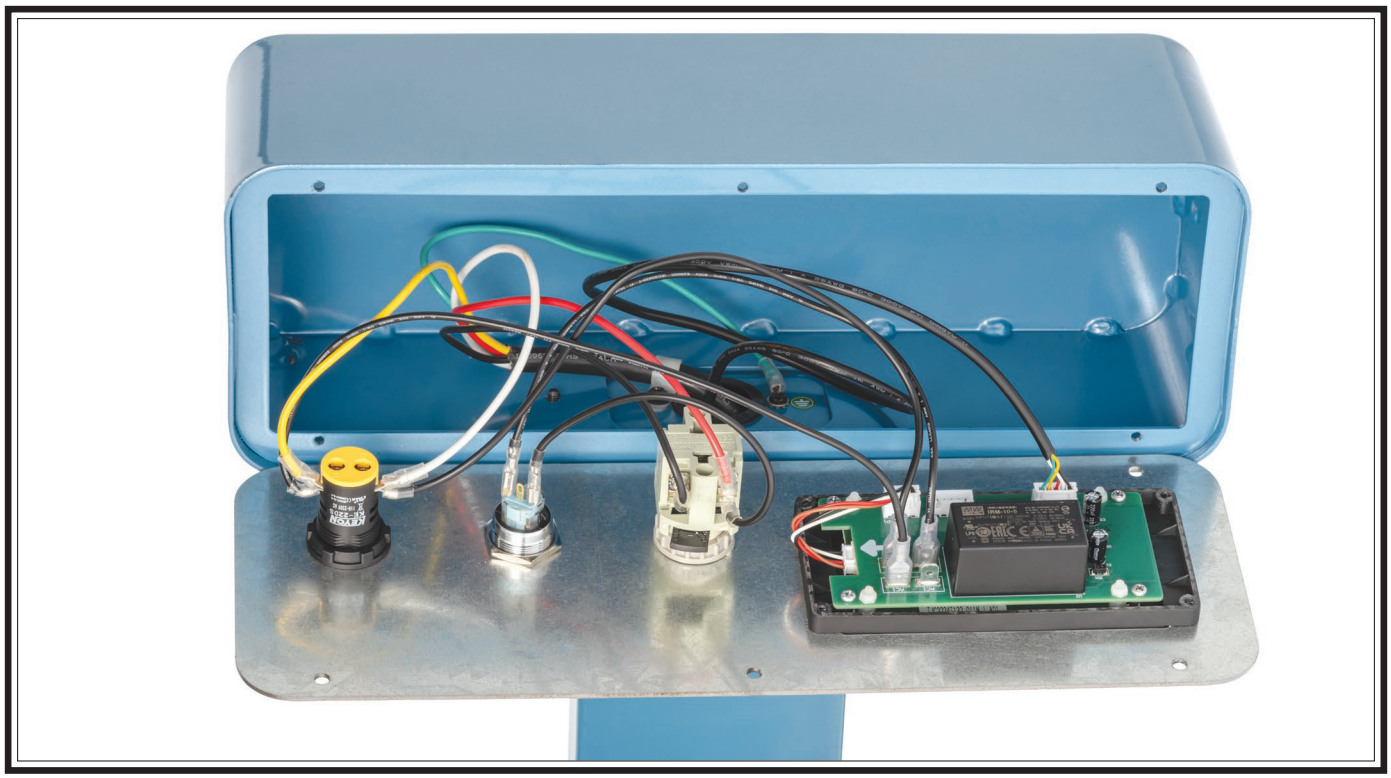


Figure 83. Control panel wiring.

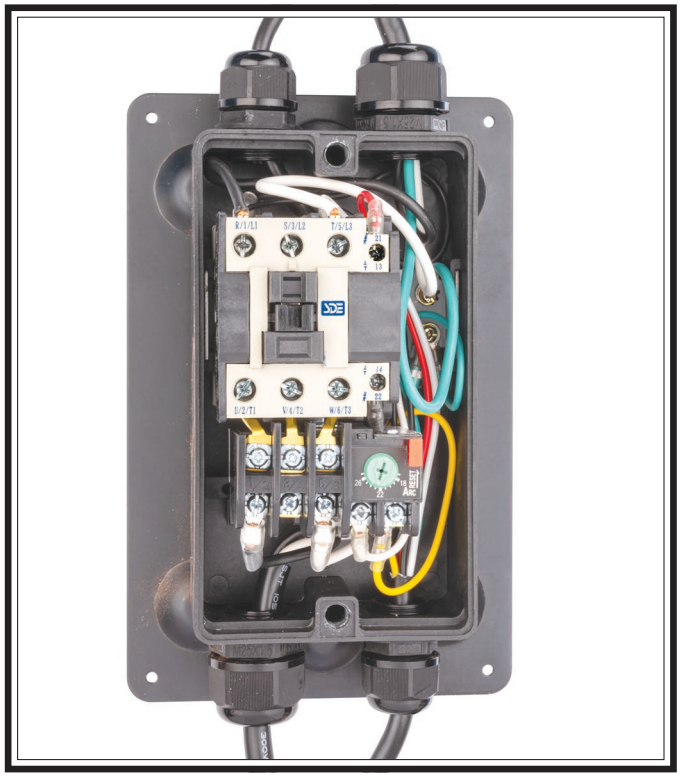


Figure 84. Magnetic switch wiring (SB1131).

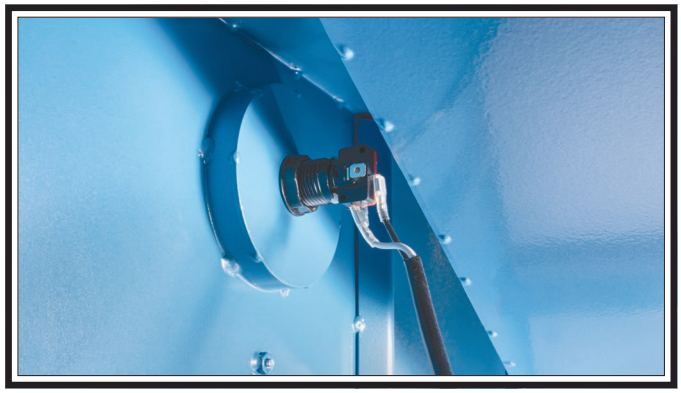


Figure 85. Knee stop wiring.

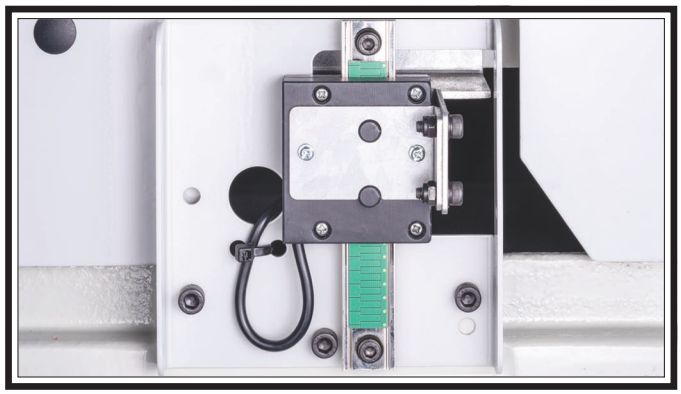
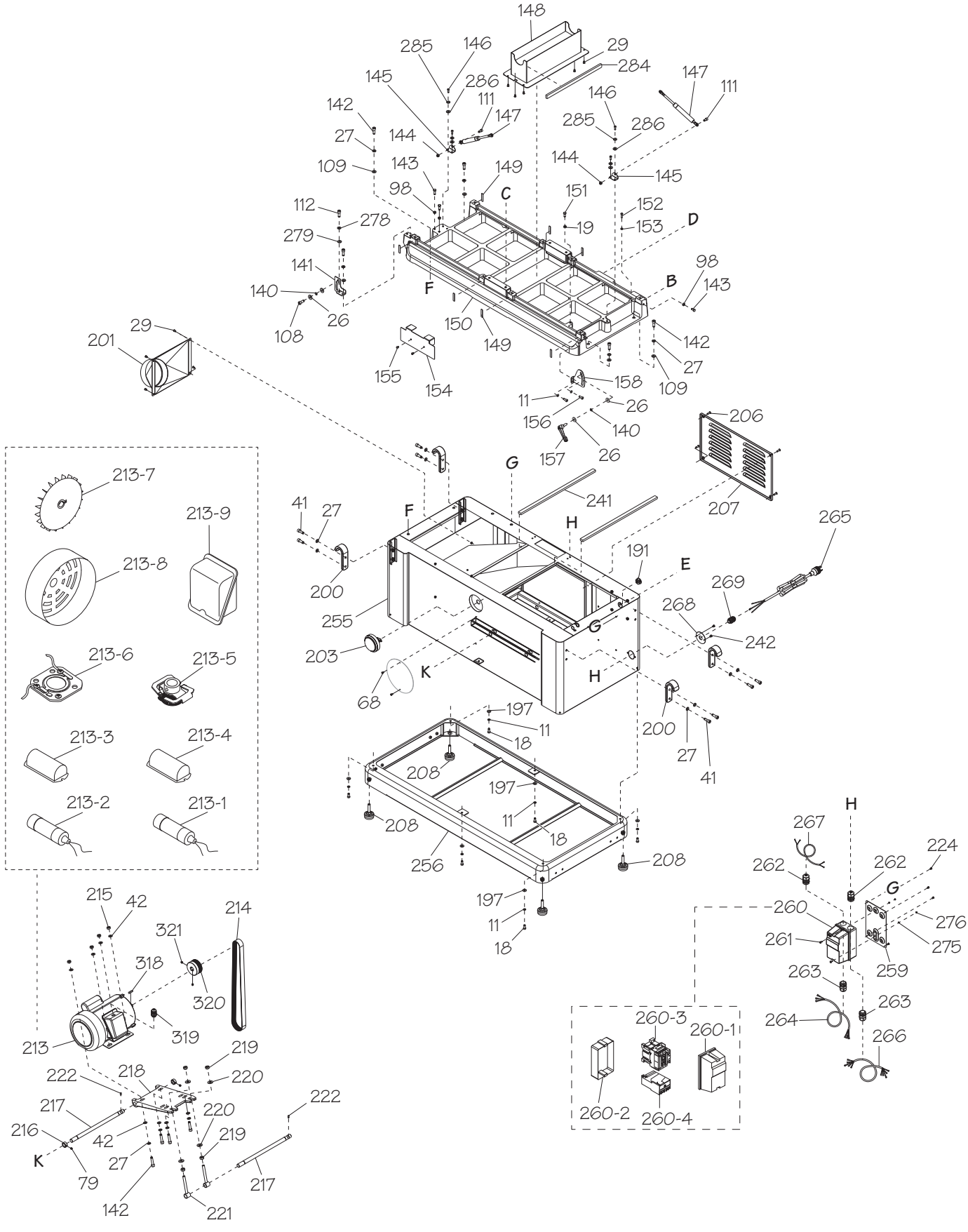


Figure 86. DRO sensor.

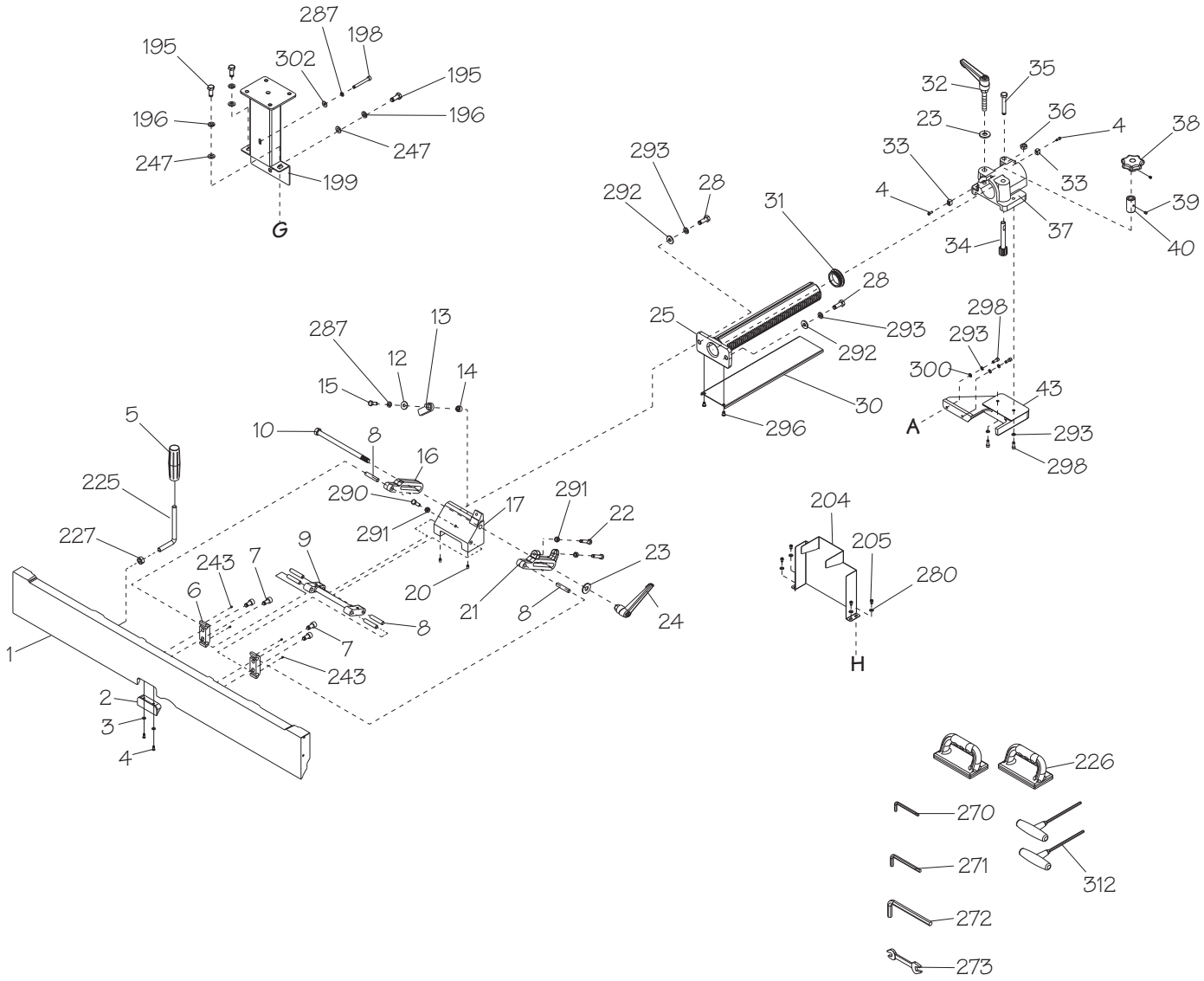
SB1131 Motor & Base



SB1131 Motor & Base Parts List

REF	PART #	DESCRIPTION
11	PSB1131011	LOCK WASHER 8MM
18	PSB1131018	HEX BOLT M8-1.25 X 20
19	PSB1131019	HEX NUT M8-1.25
26	PSB1131026	FLAT WASHER 10 X 25 X 3MM
27	PSB1131027	LOCK WASHER 10MM
29	PSB1131029	HEX BOLT M6-1 X 10
41	PSB1131041	CAP SCREW M10-1.5 X 30
42	PSB1131042	FLAT WASHER 10MM
68	PSB1131068	PHLP HD SCR M5-.8 X 10
79	PSB1131079	SET SCREW M8-1.25 X 8
98	PSB1131098	HEX NUT M8-1.25
108	PSB1131108	CAP SCREW M10-1.5 X 25
109	PSB1131109	FLAT WASHER 10MM
111	PSB1131111	CAP SCREW M8-1.25 X 20
112	PSB1131112	CAP SCREW M8-1.25 X 20
140	PSB1131140	WAVY WASHER 10MM
141	PSB1131141	LOCK PLATE, LEFT
142	PSB1131142	CAP SCREW M10-1.5 X 40
143	PSB1131143	HEX BOLT M8-1.25 X 25
144	PSB1131144	LOCK NUT M8-1.25
145	PSB1131145	BRACKET
146	PSB1131146	CAP SCREW M6-1 X 16
147	PSB1131147	STRUT 245L X 22W X 50MM TRAVEL
148	PSB1131148	CUTTERHEAD SHROUD
149	PSB1131149	CUSHION STRIP 40 X 10 X 2
150	PSB1131150	TABLE BASE
151	PSB1131151	HEX BOLT M8-1.25 X 30
152	PSB1131152	HEX BOLT M6-1 X 30
153	PSB1131153	HEX NUT M6-1
154	PSB1131154	FRONT COVER
155	PSB1131155	HEX BOLT M6-1 X 20
156	PSB1131156	CAP SCREW M8-1.25 X 18
157	PSB1131157	ADJUSTABLE HANDLE M10-1.5 X 20
158	PSB1131158	LOCK PLATE, RIGHT
191	PSB1131191	CABLE PROTECTOR
197	PSB1131197	FLAT WASHER 8MM
200	PSB1131200	LIFTING HOOK
201	PSB1131201	DUST PORT 6"
203	PSB1131203	KNEE STOP BUTTON 100MM
206	PSB1131206	FLAT HD SCR M6-1 X 20
207	PSB1131207	COVER
208	PSB1131208	FOOT
213	PSB1131213	MOTOR 5HP 230V 1-PH
213-1	PSB1131213-1	S CAPACITOR 400M 250V 1-3/4 X 3-1/2
213-2	PSB1131213-2	R CAPACITOR 35M 450V 2 X 3-1/2
213-3	PSB1131213-3	S CAPACITOR COVER
213-4	PSB1131213-4	R CAPACITOR COVER
213-5	PSB1131213-5	CENT SWITCH 3/4 60HZ
213-6	PSB1131213-6	CONTACT PLATE
213-7	PSB1131213-7	FAN
213-8	PSB1131213-8	FAN COVER
213-9	PSB1131213-9	JUNCTION BOX
214	PSB1131214	V-BELT M28 470J-12
215	PSB1131215	HEX NUT M10-1.5
216	PSB1131216	COLLAR 19.05 X 28 X 13MM
217	PSB1131217	MOTOR SUPPORT SHAFT
218	PSB1131218	MOTOR PLATE
219	PSB1131219	HEX NUT M12-1.75
220	PSB1131220	FLAT WASHER 13 X 28 X 3MM
221	PSB1131221	BELT TENSION SHAFT
222	PSB1131222	SET SCREW M6-1 X 12
224	PSB1131224	HEX BOLT M5-.8 X 10
241	PSB1131241	FOAM PAD 450 X 20 X 10MM
242	PSB1131242	PHLP HD SCR M6-1 X 10
255	PSB1131255	CABINET
256	PSB1131256	BASE
259	PSB1131259	MAGNETIC SWITCH PLATE
260	PSB1131260	MAGNETIC SWITCH
260-1	PSB1131260-1	MAG SWITCH COVER
260-2	PSB1131260-2	MAG SWITCH BASE
260-3	PSB1131260-3	CONTACTOR
260-4	PSB1131260-4	OVERLOAD RELAY
261	PSB1131261	PHLP HD SCR M4-.7 X 12
262	PSB1131262	STRAIN RELIEF M25-1.5
263	PSB1131263	STRAIN RELIEF M25-1.5
264	PSB1131264	MOTOR CORD 12G 3W 37"
265	PSB1131265	POWER CORD 12G 3W 146" L6-30
266	PSB1131266	DRO HEADSTOCK CORD 18G 5W 75"
267	PSB1131267	EMERGENCY STOP CORD 18G 2W 43"
268	PSB1131268	MOUNTING PLATE
269	PSB1131269	STRAIN RELIEF M20-1.5
275	PSB1131275	LOCK WASHER 4MM
276	PSB1131276	HEX NUT M4-.7
278	PSB1131278	LOCK WASHER 8MM
279	PSB1131279	FLAT WASHER 8MM
284	PSB1131284	CUTTERHEAD SHROUD GUARD
285	PSB1131285	LOCK WASHER 6MM
286	PSB1131286	FLAT WASHER 6MM
318	PSB1131318	KEY 6 X 6 X 40 RE
319	PSB1131319	STRAIN RELIEF M25-1.5
320	PSB1131320	MOTOR PULLEY
321	PSB1131321	SET SCREW M8-1.25 X 25

SB1131 Fence

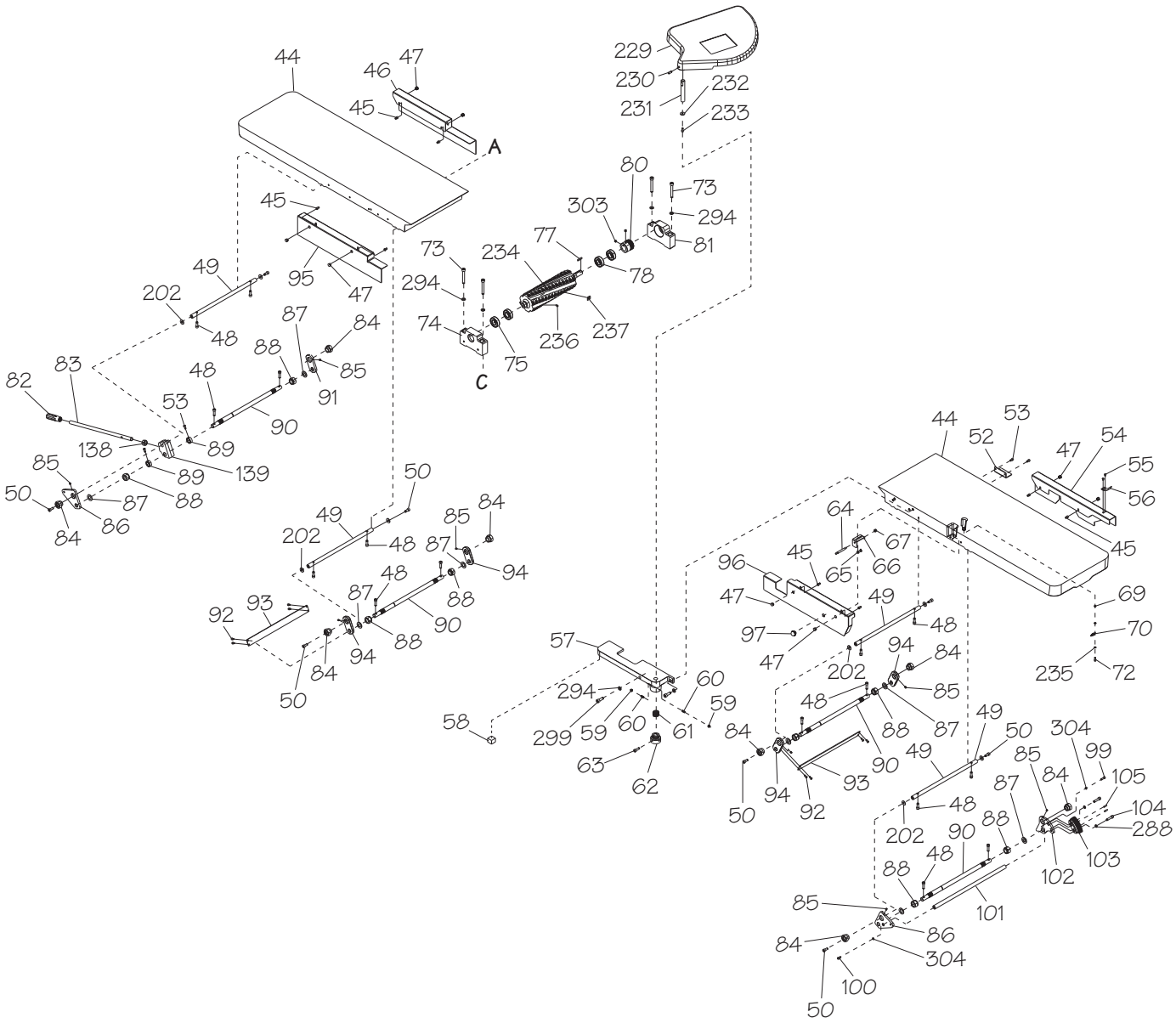


SB1131 Fence Parts List

REF	PART #	DESCRIPTION
1	PSB1131001	FENCE
2	PSB1131002	BLOCK
3	PSB1131003	FLAT WASHER 4MM
4	PSB1131004	CAP SCREW M4-.7 X 12
5	PSB1131005	HANDLE M12-1.75
6	PSB1131006	FENCE TILT SUPPORT BLOCK
7	PSB1131007	CAP SCREW M10-1.5 X 20
8	PSB1131008	SHAFT
9	PSB1131009	FENCE TILT BRACKET
10	PSB1131010	HEX BOLT M12-1.75 X 205
12	PSB1131012	FENDER WASHER 8MM
13	PSB1131013	FENCE TILT STOP BLOCK
14	PSB1131014	BUSHING 8.1 X 15.95 X 10.15MM
15	PSB1131015	HEX BOLT M8-1.25 X 25
16	PSB1131016	FENCE TILT GUIDE, LEFT
17	PSB1131017	FENCE BRACKET
20	PSB1131020	SET SCREW M6-1 X 10
21	PSB1131021	FENCE TILT GUIDE, RIGHT
22	PSB1131022	HEX BOLT M8-1.25 X 40
23	PSB1131023	FLAT WASHER 13.5 X 32 X 3MM
24	PSB1131024	FENCE TILT HANDLE
25	PSB1131025	FENCE RACK
28	PSB1131028	HEX BOLT M10-1.5 X 30
30	PSB1131030	FENCE SUPPORT BASE
31	PSB1131031	FENCE ENDCAP
32	PSB1131032	FENCE LOCK HANDLE M12-1.75 X 69
33	PSB1131033	GUIDE KEY
34	PSB1131034	GEAR SHAFT 10T
35	PSB1131035	HEX BOLT M10-1.5 X 65
36	PSB1131036	HEX NUT M10-1.5
37	PSB1131037	FENCE GUIDE BLOCK

REF	PART #	DESCRIPTION
38	PSB1131038	KNOB
39	PSB1131039	SET SCREW M6-1 X 6
40	PSB1131040	BUSHING 12.8 X 25 X 45MM
43	PSB1131043	FENCE BRACKET
195	PSB1131195	HEX BOLT M12-1.75 X 30
196	PSB1131196	LOCK WASHER 12MM
198	PSB1131198	CAP SCREW M8-1.25 X 70
199	PSB1131199	BRACKET
204	PSB1131204	BELT GUARD
205	PSB1131205	PHLP HD SCR M6-1 X 10
225	PSB1131225	FENCE HANDLE
226	PSB1131226	PUSH BLOCK
227	PSB1131227	HEX NUT M12-1.75
243	PSB1131243	SET SCREW M5-.8 X 5
247	PSB1131247	FLAT WASHER 12MM
270	PSB1131270	HEX WRENCH 5MM
271	PSB1131271	HEX WRENCH 6MM
272	PSB1131272	HEX WRENCH 8MM
273	PSB1131273	WRENCH 17 X 19MM OPEN-ENDS
280	PSB1131280	FLAT WASHER 6MM
287	PSB1131287	LOCK WASHER 8MM
290	PSB1131290	HEX BOLT M8-1.25 X 20
291	PSB1131291	HEX NUT M8-1.25
292	PSB1131292	FLAT WASHER 10 X 25 X 3MM
293	PSB1131293	LOCK WASHER 10MM
296	PSB1131296	HEX BOLT M6-1 X 10
298	PSB1131298	CAP SCREW M10-1.5 X 30
300	PSB1131300	FLAT WASHER 10MM
302	PSB1131302	FLAT WASHER 8MM
312	PSB1131312	T-HANDLE TORX DRIVER T-25

SB1131 Table

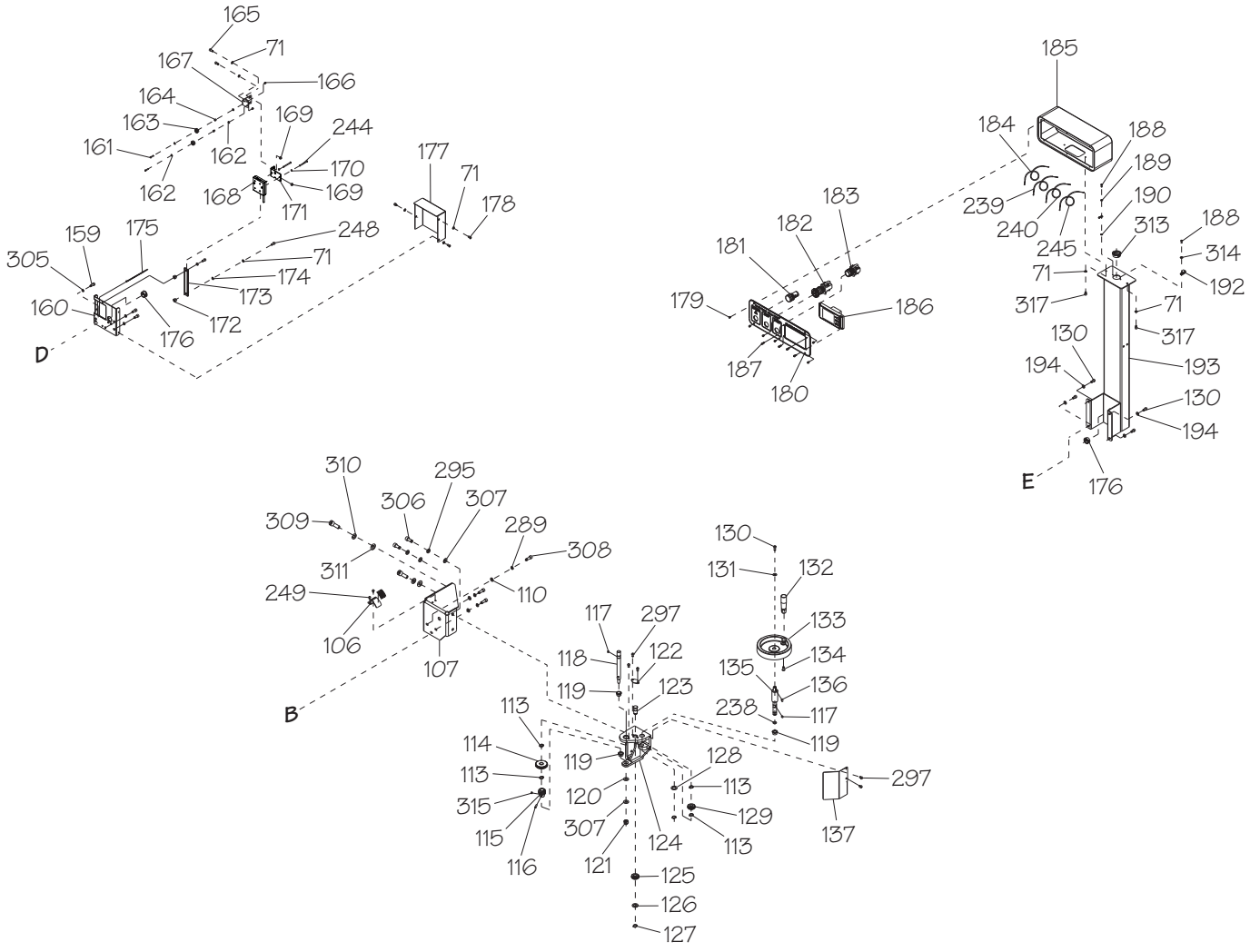


SB1131 Table Parts List

REF	PART #	DESCRIPTION
44	PSB1131044	TABLE
45	PSB1131045	CAP SCREW M6-1 X 10
46	PSB1131046	REAR TABLE COVER, LEFT
47	PSB1131047	PLASTIC PLUG
48	PSB1131048	CAP SCREW M8-1.25 X 30
49	PSB1131049	TILT SHAFT
50	PSB1131050	CAP SCREW M8-1.25 X 20
52	PSB1131052	BLADE GUARD BRACKET
53	PSB1131053	CAP SCREW M6-1 X 12
54	PSB1131054	REAR TABLE COVER, RIGHT
55	PSB1131055	PHLP HD SCR M5-.8 X 8
56	PSB1131056	POINTER
57	PSB1131057	RABBETING TABLE
58	PSB1131058	FOAM PAD 30 X 30 X 22MM
59	PSB1131059	HEX NUT 1/4-20
60	PSB1131060	SET SCREW 1/4-20 X 3/4
61	PSB1131061	TORSION SPRING 0.1 X 1.18 X 2.16MM
62	PSB1131062	PIVOT BUSHING 0.75 X 1.96 X 1.69MM
63	PSB1131063	CAP SCREW M8-1.25 X 25
64	PSB1131064	SHAFT
65	PSB1131065	SHOULDER SCREW M5-.8 X 5, M6 X 3.3
66	PSB1131066	POSITION PLATE
67	PSB1131067	LOCK NUT 1/4-20
69	PSB1131069	HEX NUT M5-.8
70	PSB1131070	EXTENSION SPRING 0.6MM X 7.6 X 53
72	PSB1131072	CAP SCREW M5-.8 X 15
73	PSB1131073	CAP SCREW M10-1.5 X 75
74	PSB1131074	HOUSING, FRONT
75	PSB1131075	BALL BEARING 6204-2NSE
77	PSB1131077	KEY 8 X 8 X 40 RE
78	PSB1131078	BALL BEARING 6206-2NSE
80	PSB1131080	CUTTERHEAD PULLEY
81	PSB1131081	HOUSING, REAR
82	PSB1131082	FIXED HANDLE
83	PSB1131083	SHAFT
84	PSB1131084	BUSHING
85	PSB1131085	SET SCREW M6-1 X 8

REF	PART #	DESCRIPTION
86	PSB1131086	BUSHING PLATE
87	PSB1131087	FLAT WASHER 18 X 32 X 2MM
88	PSB1131088	LOCK NUT M20-1.5
89	PSB1131089	COLLAR 20.2 X 32 X 12.7MM
90	PSB1131090	TILT BRACKET SHAFT
91	PSB1131091	BUSHING PLATE, LEFT
92	PSB1131092	CAP SCREW M5-.8 X 10
93	PSB1131093	FIXED PLATE
94	PSB1131094	BUSHING PLATE
95	PSB1131095	FRONT TABLE COVER, LEFT
96	PSB1131096	FRONT TABLE COVER, RIGHT
97	PSB1131097	BALL KNOB 1/4"-20
99	PSB1131099	CAP SCREW M6-1 X 20
100	PSB1131100	HEX BOLT M6-1 X 16
101	PSB1131101	SHAFT
102	PSB1131102	BUSHING PLATE, REAR
103	PSB1131103	RACK
104	PSB1131104	CAP SCREW M8-1.25 X 35
105	PSB1131105	PIN 5 X 20
138	PSB1131138	HEX NUT M16-2
139	PSB1131139	DEPTH BRACKET
202	PSB1131202	FENDER WASHER 8MM
229	PSB1131229	BLADE GUARD
230	PSB1131230	SET SCREW M8-1.25 X 12
231	PSB1131231	SHAFT 124 X 18MM
232	PSB1131232	FENDER WASHER 6.2 X 22 X 3MM
233	PSB1131233	CAP SCREW M6-1 X 15
234	PSB1131234	16" HELICAL CUTTERHEAD
235	PSB1131235	FLAT WASHER 5MM
236	PSB1131236	FLAT HD TORX SCR #10-32 X 1/2
237	PSB1131237	INSERT 15 X 15 X 2.5MM R98.5
288	PSB1131288	LOCK WASHER 8MM
294	PSB1131294	LOCK WASHER 10MM
299	PSB1131299	CAP SCREW M10-1.5 X 30
303	PSB1131303	SET SCREW M8-1.25 X 8
304	PSB1131304	LOCK WASHER 6MM

SB1131 Controls

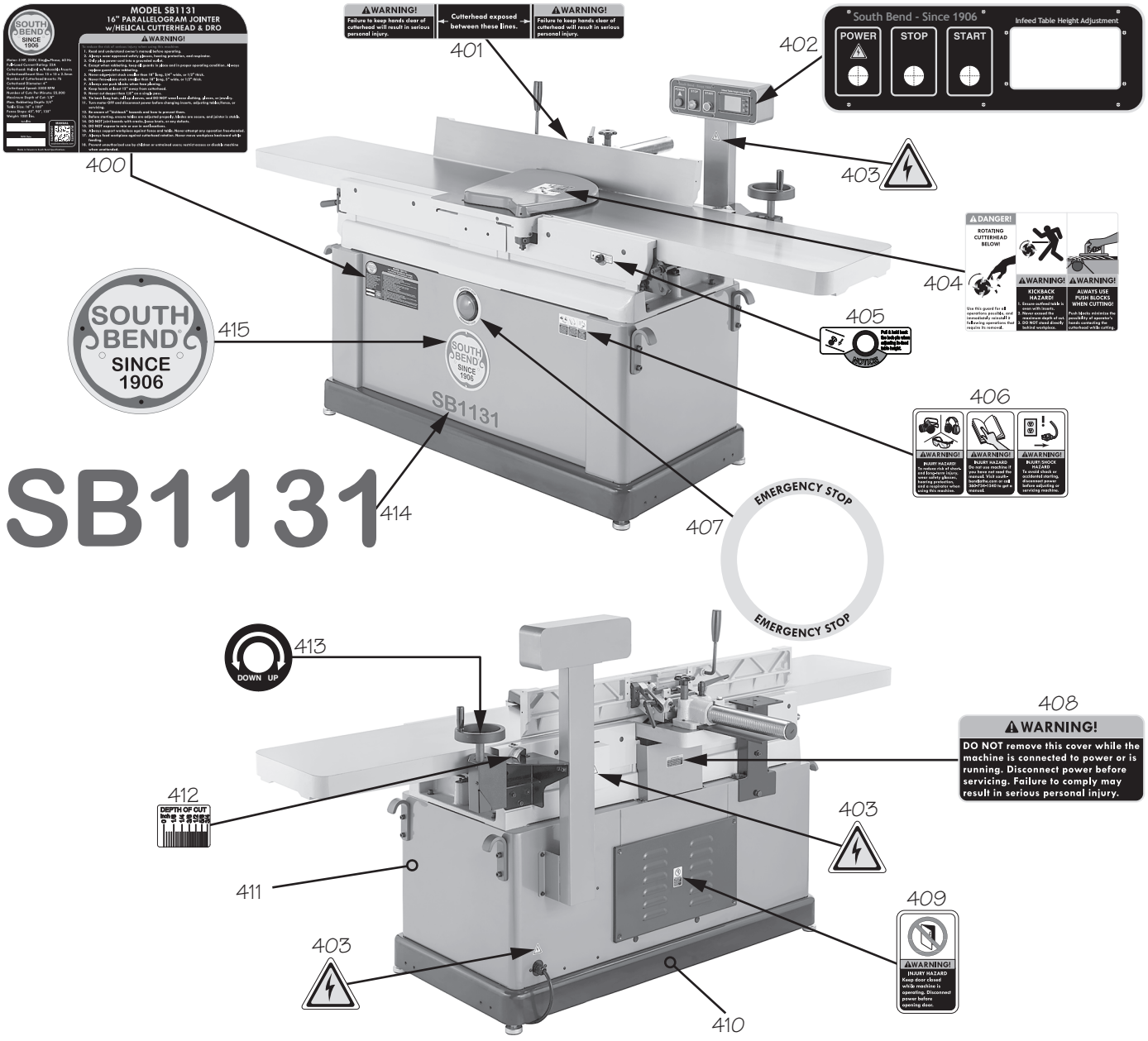


SB1131 Controls Parts List

REF	PART #	DESCRIPTION
71	PSB1131071	FLAT WASHER 5MM
106	PSB1131106	SCALE BRACKET
107	PSB1131107	DEPTH-OF-CUT BRACKET
110	PSB1131110	FLAT WASHER 8MM
113	PSB1131113	EXT RETAINING RING 15MM
114	PSB1131114	GEAR 50T
115	PSB1131115	WORM SHAFT
116	PSB1131116	ROLL PIN 5 X 20
117	PSB1131117	KEY 5 X 5 X 8 RE
118	PSB1131118	SHAFT
119	PSB1131119	FLANGED BUSHING
120	PSB1131120	FLAT WASHER 10 X 22 X 0.8MM
121	PSB1131121	LOCK NUT M10-1.5
122	PSB1131122	PLATE
123	PSB1131123	LOCK SHAFT 18 X 35MM
124	PSB1131124	LEADSCREW SUPPORT BRACKET
125	PSB1131125	GEAR 30T
126	PSB1131126	FLAT WASHER 12MM
127	PSB1131127	EXT RETAINING RING 12MM
128	PSB1131128	FLAT WASHER 15.5 X 25 X 2.5MM
129	PSB1131129	GEAR 30T
130	PSB1131130	CAP SCREW M6-1 X 12
131	PSB1131131	FLAT WASHER 6.4 X 16 X 1MM
132	PSB1131132	FOLDING HANDLE M6-1 X 20, 85.5
133	PSB1131133	HANDWHEEL M11.5
134	PSB1131134	HEX BOLT M6-1 X 16
135	PSB1131135	DEPTH SHAFT
136	PSB1131136	KEY 4 X 4 X 16 RE
137	PSB1131137	SUPPORT BRACKET COVER
159	PSB1131159	CAP SCREW M6-1 X 16
160	PSB1131160	DRO PLATE
161	PSB1131161	PHLP HD SCR M3-.5 X 15
162	PSB1131162	FLAT WASHER 3MM
163	PSB1131163	BALL BEARING 606ZZ
164	PSB1131164	BEARING BUSHING 3.1 X 6.5 X 5.8MM
165	PSB1131165	CAP SCREW M5-.8 X 12
166	PSB1131166	LOCK NUT M3-.5
167	PSB1131167	BEARING BRACKET
168	PSB1131168	DRO SENSOR W/CORD
169	PSB1131169	LOCK NUT M5-.8
170	PSB1131170	LOCK WASHER 3MM
171	PSB1131171	FIXED BOARD
172	PSB1131172	FLANGED BUSHING

REF	PART #	DESCRIPTION
173	PSB1131173	MAGNETIC SCALE
174	PSB1131174	FLAT WASHER 5MM
175	PSB1131175	CABLE TIE
176	PSB1131176	CABLE PROTECTOR
177	PSB1131177	COVER
178	PSB1131178	CAP SCREW M5-.8 X 6
179	PSB1131179	HEX BOLT M4-.7 X 6
180	PSB1131180	CONTROL PANEL FACE PLATE
181	PSB1131181	LED KEYON 115/230V WHITE 22MM
182	PSB1131182	STOP BUTTON RUIERLI RED 22MM
183	PSB1131183	START BUTTON YK A600 22MM
184	PSB1131184	LED CORD 18G 1W 6"
185	PSB1131185	SWITCH BOX
186	PSB1131186	DRO ASSEMBLY
187	PSB1131187	TAP SCREW M4 X 10
188	PSB1131188	PHLP HD SCR M4-.7 X 8
189	PSB1131189	FLAT WASHER 4MM
190	PSB1131190	EXT TOOTH WASHER 4MM
192	PSB1131192	WIRE CLIP
193	PSB1131193	CONTROL PANEL COLUMN
194	PSB1131194	FLAT WASHER 6MM
238	PSB1131238	O-RING 10.8 X 0.18 P11
239	PSB1131239	STOP BUTTON CORD 18G 1W 12"
240	PSB1131240	START BUTTON CORD 18G 1W 10"
244	PSB1131244	PHLP HD SCR M3-.5 X 20
245	PSB1131245	DRO CORD 18G 1W 12"
248	PSB1131248	CAP SCREW M5-.8 X 15
249	PSB1131249	HEX BOLT M5-.8 X 8
289	PSB1131289	LOCK WASHER 8MM
295	PSB1131295	LOCK WASHER 10MM
297	PSB1131297	HEX BOLT M6-1 X 10
305	PSB1131305	LOCK WASHER 6MM
306	PSB1131306	CAP SCREW M10-1.5 X 25
307	PSB1131307	FLAT WASHER 10MM
308	PSB1131308	CAP SCREW M8-1.25 X 20
309	PSB1131309	CAP SCREW M8-1.25 X 20
310	PSB1131310	LOCK WASHER 8MM
311	PSB1131311	FLAT WASHER 8MM
313	PSB1131313	CABLE PROTECTOR
314	PSB1131314	FLAT WASHER 4MM
315	PSB1131315	SET SCREW M6-1 X 6
317	PSB1131317	CAP SCREW M5-.8 X 10

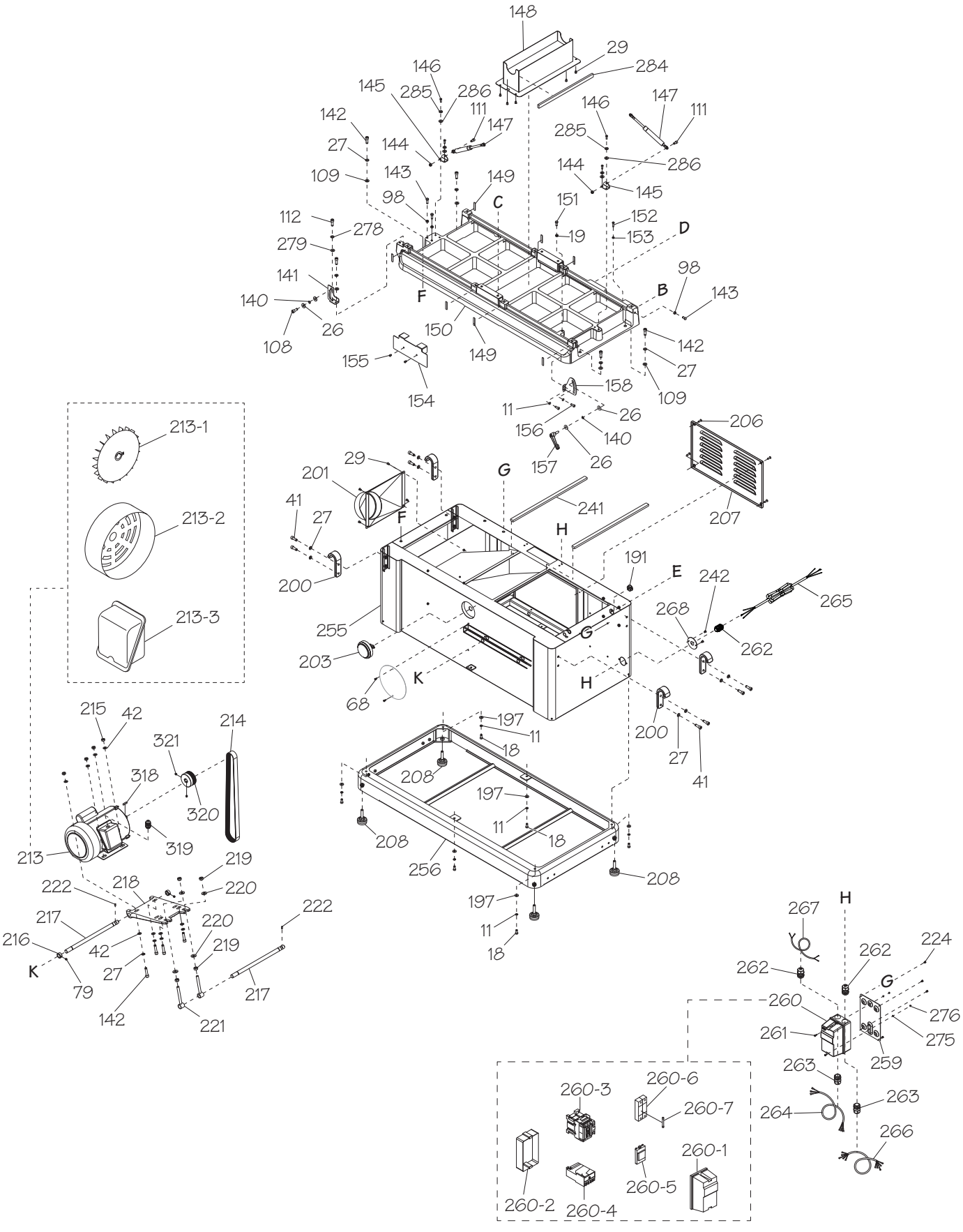
SB1131 Labels & Cosmetics



REF	PART #	DESCRIPTION
400	PSB1131400	MACHINE ID LABEL
401	PSB1131401	FENCE/CUTTERHEAD LABEL
402	PSB1131402	CONTROL PANEL LABEL
403	PSB1131403	ELECTRICITY LABEL
404	PSB1131404	CUTTERHEAD GUARD LABEL
405	PSB1131405	KNOB NOTICE LABEL
406	PSB1131406	COMBO WARNING LABEL
407	PSB1131407	EMERGENCY STOP RING LABEL

REF	PART #	DESCRIPTION
408	PSB1131408	DO NOT OPEN COVER LABEL
409	PSB1131409	DO NOT OPEN PANEL LABEL
410	PSB1131410	TOUCH-UP PAINT, SB DARK BLUE
411	PSB1131411	TOUCH-UP PAINT, SB LIGHT BLUE
412	PSB1131412	DEPTH OF CUT LABEL
413	PSB1131413	HANDWHEEL LABEL
414	PSB1131414	MODEL NUMBER LABEL
415	PSB1131415	SOUTH BEND NAMEPLATE 203MM

SB1132 Motor & Base

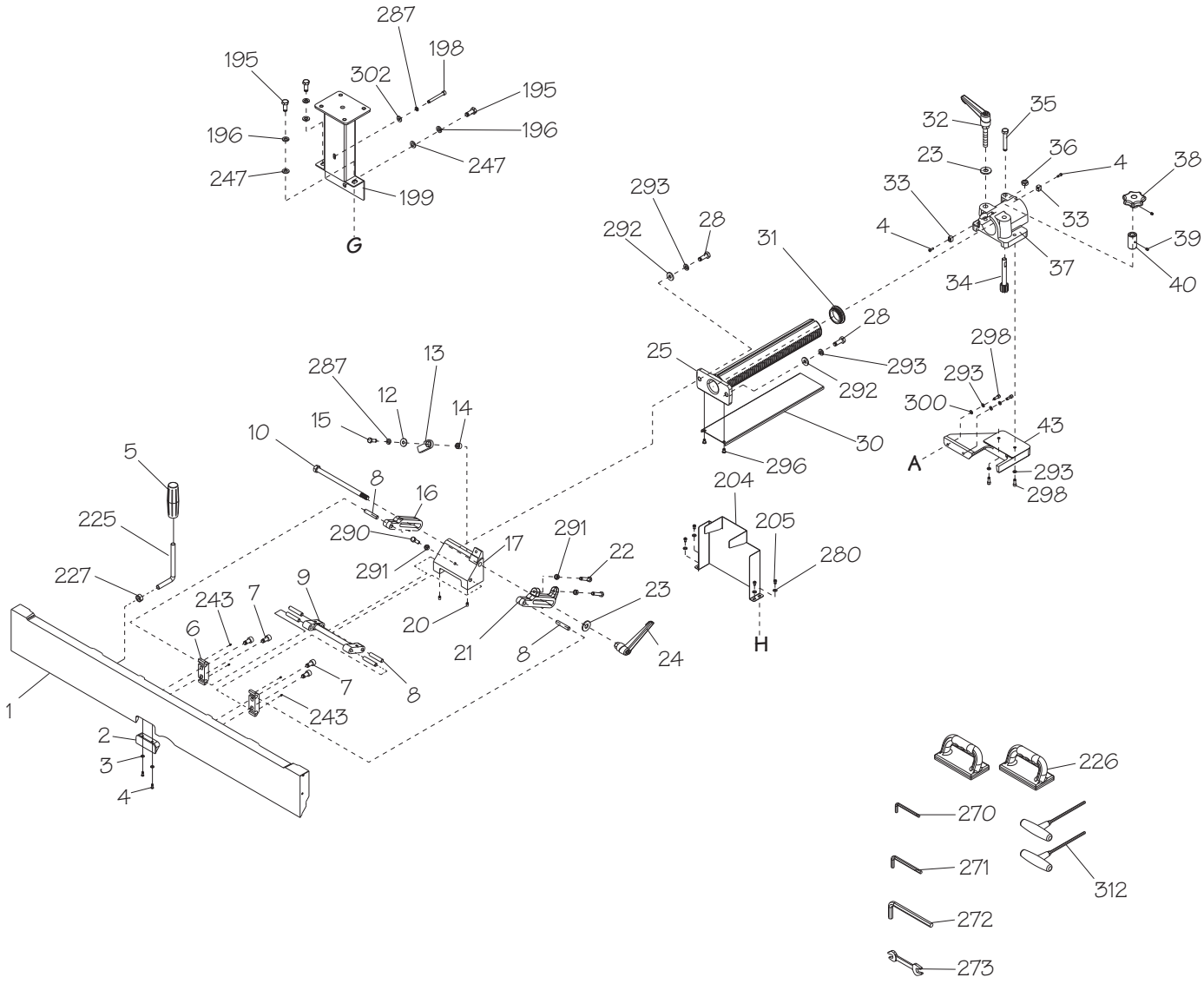


SB1132 Motor & Base Parts List

REF	PART #	DESCRIPTION
11	PSB1132011	LOCK WASHER 8MM
18	PSB1132018	HEX BOLT M8-1.25 X 20
19	PSB1132019	HEX NUT M8-1.25
26	PSB1132026	FLAT WASHER 10 X 25 X 3MM
27	PSB1132027	LOCK WASHER 10MM
29	PSB1132029	HEX BOLT M6-1 X 10
41	PSB1132041	CAP SCREW M10-1.5 X 30
42	PSB1132042	FLAT WASHER 10MM
68	PSB1132068	PHLP HD SCR M5-.8 X 10
79	PSB1132079	SET SCREW M8-1.25 X 8
98	PSB1132098	HEX NUT M8-1.25
108	PSB1132108	CAP SCREW M10-1.5 X 25
109	PSB1132109	FLAT WASHER 10MM
111	PSB1132111	CAP SCREW M8-1.25 X 20
112	PSB1132112	CAP SCREW M8-1.25 X 20
140	PSB1132140	WAVY WASHER 10MM
141	PSB1132141	LOCK PLATE, LEFT
142	PSB1132142	CAP SCREW M10-1.5 X 40
143	PSB1132143	HEX BOLT M8-1.25 X 25
144	PSB1132144	LOCK NUT M8-1.25
145	PSB1132145	BRACKET
146	PSB1132146	CAP SCREW M6-1 X 16
147	PSB1132147	STRUT 245L X 22W X 50MM TRAVEL
148	PSB1132148	CUTTERHEAD SHROUD
149	PSB1132149	CUSHION STRIP 40 X 10 X 2
150	PSB1132150	TABLE BASE
151	PSB1132151	HEX BOLT M8-1.25 X 30
152	PSB1132152	HEX BOLT M6-1 X 30
153	PSB1132153	HEX NUT M6-1
154	PSB1132154	FRONT COVER
155	PSB1132155	HEX BOLT M6-1 X 20
156	PSB1132156	CAP SCREW M8-1.25 X 18
157	PSB1132157	ADJUSTABLE HANDLE M10-1.5 X 20
158	PSB1132158	LOCK PLATE, RIGHT
191	PSB1132191	CABLE PROTECTOR
197	PSB1132197	FLAT WASHER 8MM
200	PSB1132200	LIFTING HOOK
201	PSB1132201	DUST PORT 6"
203	PSB1132203	KNEE STOP BUTTON 100MM
206	PSB1132206	FLAT HD SCR M6-1 X 20
207	PSB1132207	COVER
208	PSB1132208	FOOT
213	PSB1132213	MOTOR 7.5HP 220/440V 3-PH
213-1	PSB1132213-1	FAN

REF	PART #	DESCRIPTION
213-2	PSB1132213-2	FAN COVER
213-3	PSB1132213-3	JUNCTION BOX
214	PSB1132214	V-BELT M28 470J-12
215	PSB1132215	HEX NUT M10-1.5
216	PSB1132216	COLLAR 19.05ID X 28OD X 13H
217	PSB1132217	MOTOR SUPPORT SHAFT
218	PSB1132218	MOTOR PLATE
219	PSB1132219	HEX NUT M12-1.75
220	PSB1132220	FLAT WASHER 13 X 28 X 3MM
221	PSB1132221	BELT TENSION SHAFT
222	PSB1132222	SET SCREW M6-1 X 12
224	PSB1132224	HEX BOLT M5-.8 X 10
241	PSB1132241	FOAM PAD 450 X 20 X 10MM
242	PSB1132242	PHLP HD SCR M6-1 X 10
255	PSB1132255	CABINET
256	PSB1132256	BASE
259	PSB1132259	MAGNETIC SWITCH PLATE
260	PSB1132260	MAGNETIC SWITCH
260-1	PSB1132260-1	MAG SWITCH COVER SDE MPE25.30
260-2	PSB1132260-2	MAG SWITCH BASE SDE MP25.30
260-3	PSB1132260-3	CONTACTOR SDE MA-18
260-4	PSB1132260-4	OVERLOAD RELAY SDE RA-30
260-5	PSB1132260-5	TRANSFORMER 20VA 220/440V
260-6	PSB1132260-6	FUSE BLOCK FS-012B
260-7	PSB1132260-7	FUSE 2A X 30MM
261	PSB1132261	PHLP HD SCR M4-.7 X 12
262	PSB1132262	STRAIN RELIEF M25-1.5
263	PSB1132263	STRAIN RELIEF M25-1.5
264	PSB1132264	MOTOR CORD 12G 4W 37"
265	PSB1132265	POWER CORD 12G 4W 146"
266	PSB1132266	DRO HEADSTOCK CORD 18G 5W 75"
267	PSB1132267	EMERGENCY STOP CORD 18G 2W 43"
268	PSB1132268	MOUNTING PLATE
275	PSB1132275	LOCK WASHER 4MM
276	PSB1132276	HEX NUT M4-.7
278	PSB1132278	LOCK WASHER 8MM
279	PSB1132279	FLAT WASHER 8MM
284	PSB1132284	CUTTERHEAD SHROUD GUARD
285	PSB1132285	LOCK WASHER 6.5MM
286	PSB1132286	FLAT WASHER 6MM
318	PSB1132318	KEY 6 X 6 X 40 RE
319	PSB1132319	STRAIN RELIEF M25-1.5
320	PSB1132320	MOTOR PULLEY
321	PSB1132321	SET SCREW M8-1.25 X 25

SB1132 Fence

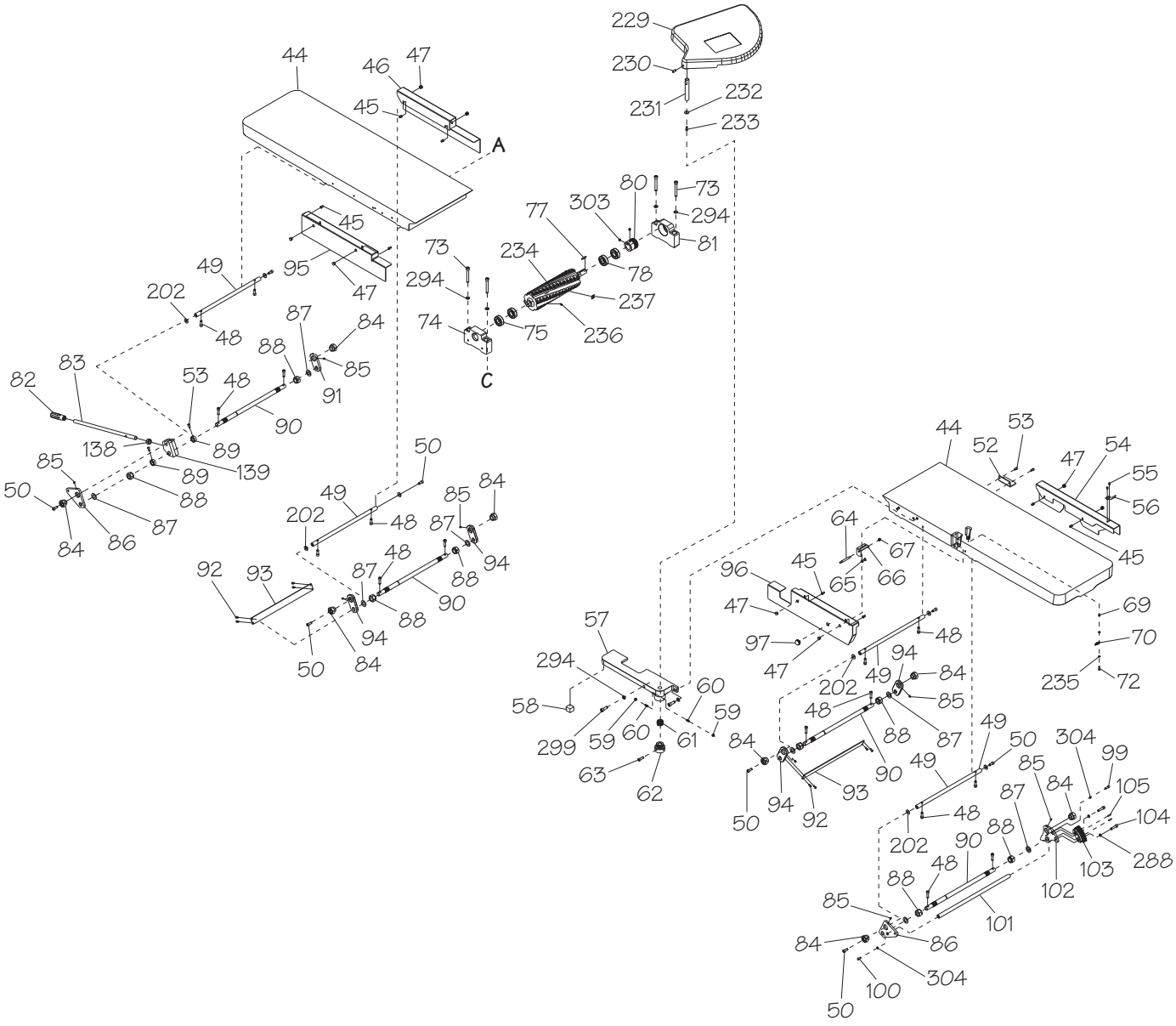


SB1132 Fence Parts List

REF	PART #	DESCRIPTION
1	PSB1132001	FENCE
2	PSB1132002	BLOCK
3	PSB1132003	FLAT WASHER 4MM
4	PSB1132004	CAP SCREW M4-.7 X 12
5	PSB1132005	HANDLE M12-1.75
6	PSB1132006	FENCE TILT SUPPORT BLOCK
7	PSB1132007	CAP SCREW M10-1.5 X 20
8	PSB1132008	SHAFT
9	PSB1132009	FENCE TILT BRACKET
10	PSB1132010	HEX BOLT M12-1.75 X 205
12	PSB1132012	FENDER WASHER 8MM
13	PSB1132013	FENCE TILT STOP BLOCK
14	PSB1132014	BUSHING 8.1 X 15.95 X 10.15MM
15	PSB1132015	HEX BOLT M8-1.25 X 25
16	PSB1132016	FENCE TILT GUIDE, LEFT
17	PSB1132017	FENCE BRACKET
20	PSB1132020	SET SCREW M6-1 X 10
21	PSB1132021	FENCE TILT GUIDE, RIGHT
22	PSB1132022	HEX BOLT M8-1.25 X 40
23	PSB1132023	FLAT WASHER 13.5 X 32 X 3MM
24	PSB1132024	FENCE TILT HANDLE
25	PSB1132025	FENCE RACK
28	PSB1132028	HEX BOLT M10-1.5 X 30
30	PSB1132030	FENCE SUPPORT BASE
31	PSB1132031	FENCE ENDCAP
32	PSB1132032	FENCE LOCK HANDLE M12-1.75 X 69
33	PSB1132033	GUIDE KEY
34	PSB1132034	GEAR SHAFT 10T
35	PSB1132035	HEX BOLT M10-1.5 X 65
36	PSB1132036	HEX NUT M10-1.5
37	PSB1132037	FENCE GUIDE BLOCK

REF	PART #	DESCRIPTION
38	PSB1132038	KNOB
39	PSB1132039	SET SCREW M6-1 X 6
40	PSB1132040	BUSHING 12.8 X 25 X 45MM
43	PSB1132043	FENCE BRACKET
195	PSB1132195	HEX BOLT M12-1.75 X 30
196	PSB1132196	LOCK WASHER 12MM
198	PSB1132198	CAP SCREW M8-1.25 X 70
199	PSB1132199	BRACKET
204	PSB1132204	BELT GUARD
205	PSB1132205	PHLP HD SCR M6-1 X 10
225	PSB1132225	FENCE HANDLE
226	PSB1132226	PUSH BLOCK
227	PSB1132227	HEX NUT M12-1.75
243	PSB1132243	SET SCREW M5-.8 X 5
247	PSB1132247	FLAT WASHER 12MM
270	PSB1132270	HEX WRENCH 5MM
271	PSB1132271	HEX WRENCH 6MM
272	PSB1132272	HEX WRENCH 8MM
273	PSB1132273	WRENCH 17 X 19MM OPEN-ENDS
280	PSB1132280	FLAT WASHER 6MM
287	PSB1132287	LOCK WASHER 8MM
290	PSB1132290	HEX BOLT M8-1.25 X 20
291	PSB1132291	HEX NUT M8-1.25
292	PSB1132292	FLAT WASHER 10 X 25 X 3MM
293	PSB1132293	LOCK WASHER 10MM
296	PSB1132296	HEX BOLT M6-1 X 10
298	PSB1132298	CAP SCREW M10-1.5 X 30
300	PSB1132300	FLAT WASHER 10MM
302	PSB1132302	FLAT WASHER 8MM
312	PSB1132312	T-HANDLE TORX DRIVER T-25

SB1132 Table

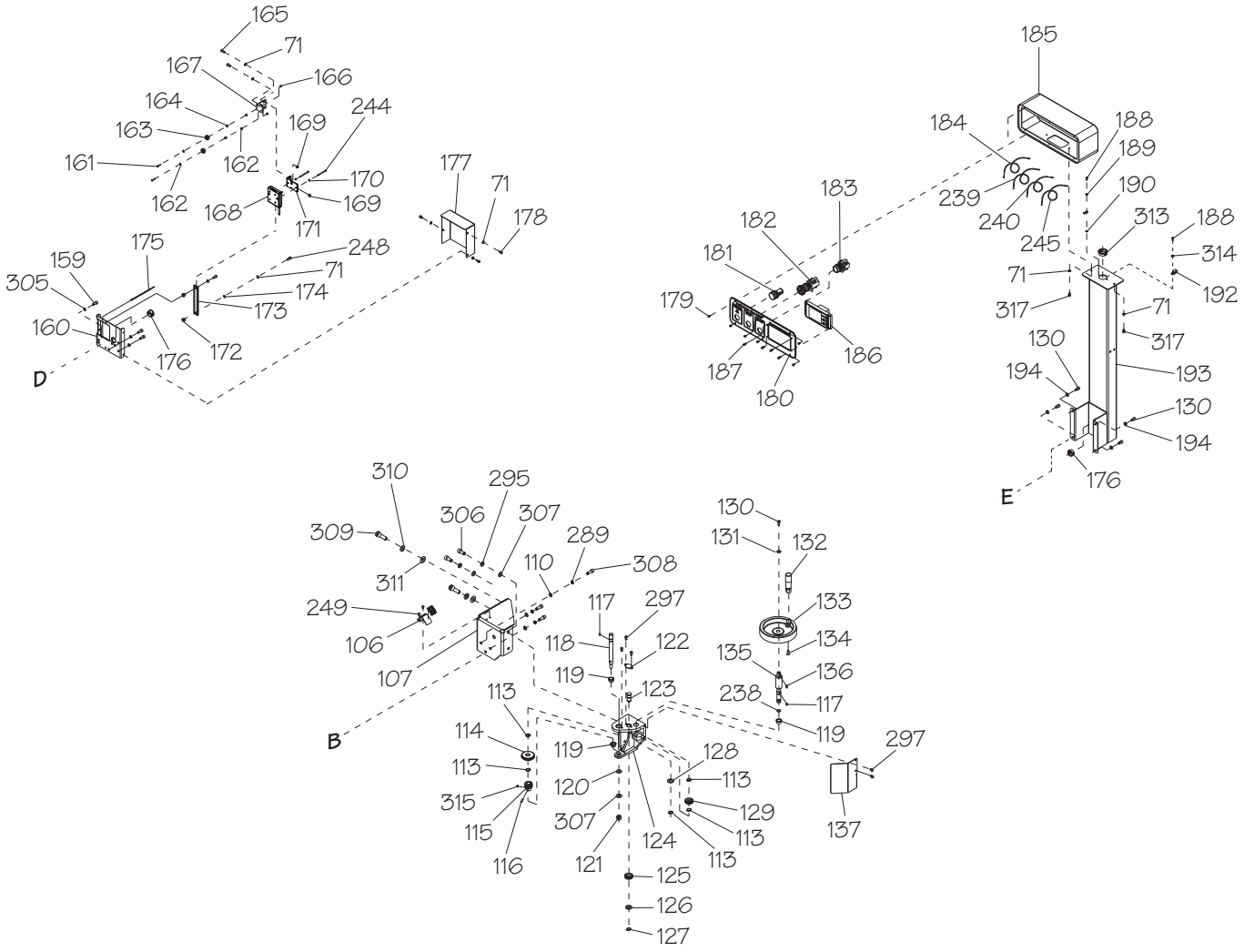


SB1132 Table Parts List

REF	PART #	DESCRIPTION
44	PSB1132044	TABLE
45	PSB1132045	CAP SCREW M6-1 X 10
46	PSB1132046	REAR TABLE COVER, LEFT
47	PSB1132047	PLASTIC PLUG
48	PSB1132048	CAP SCREW M8-1.25 X 30
49	PSB1132049	TILT SHAFT
50	PSB1132050	CAP SCREW M8-1.25 X 20
52	PSB1132052	BLADE GUARD BRACKET
53	PSB1132053	CAP SCREW M6-1 X 12
54	PSB1132054	REAR TABLE COVER, RIGHT
55	PSB1132055	PHLP HD SCR M5-.8 X 8
56	PSB1132056	POINTER
57	PSB1132057	FENCE LINK
58	PSB1132058	FOAM PAD 30 X 30 X 22MM
59	PSB1132059	HEX NUT 1/4-20
60	PSB1132060	SET SCREW 1/4-20 X 3/4
61	PSB1132061	TORSION SPRING
62	PSB1132062	PIVOT BUSHING
63	PSB1132063	CAP SCREW M8-1.25 X 25
64	PSB1132064	SHAFT
65	PSB1132065	SHOULDER SCREW M5-.8 X 5, M6 X 3.3
66	PSB1132066	POSITION PLATE
67	PSB1132067	LOCK NUT 1/4-20
69	PSB1132069	HEX NUT M5-.8
70	PSB1132070	EXTENSION SPRING .6MM X 7.6 X 53
72	PSB1132072	CAP SCREW M5-.8 X 15
73	PSB1132073	CAP SCREW M10-1.5 X 75
74	PSB1132074	HOUSING, FRONT
75	PSB1132075	BALL BEARING 6204-2NSE
77	PSB1132077	KEY 8 X 8 X 40 RE
78	PSB1132078	BALL BEARING 6206-2NSE
80	PSB1132080	CUTTERHEAD PULLEY
81	PSB1132081	HOUSING, REAR
82	PSB1132082	FIXED HANDLE
83	PSB1132083	SHAFT
84	PSB1132084	BUSHING
85	PSB1132085	SET SCREW M6-1 X 8

REF	PART #	DESCRIPTION
86	PSB1132086	BUSHING PLATE
87	PSB1132087	FLAT WASHER 18 X 32 X 2MM
88	PSB1132088	LOCK NUT M20-1.5
89	PSB1132089	COLLAR 20.2 X 32 X 12.7MM
90	PSB1132090	TILT BRACKET SHAFT
91	PSB1132091	BUSHING PLATE, LEFT
92	PSB1132092	CAP SCREW M5-.8 X 10
93	PSB1132093	FIXED PLATE
94	PSB1132094	BUSHING PLATE
95	PSB1132095	FRONT TABLE COVER, LEFT
96	PSB1132096	FRONT TABLE COVER, RIGHT
97	PSB1132097	BALL KNOB 1/4"-20
99	PSB1132099	CAP SCREW M6-1 X 20
100	PSB1132100	HEX BOLT M6-1 X 16
101	PSB1132101	SHAFT
102	PSB1132102	BUSHING PLATE, REAR
103	PSB1132103	RACK
104	PSB1132104	CAP SCREW M8-1.25 X 35
105	PSB1132105	PIN 5 X 20
138	PSB1132138	HEX NUT M16-2
139	PSB1132139	DEPTH BRACKET
202	PSB1132202	FLAT WASHER 8.5MM
229	PSB1132229	BLADE GUARD
230	PSB1132230	SET SCREW M8-1.25 X 12
231	PSB1132231	SHAFT 124 X 18MM
232	PSB1132232	FENDER WASHER 6.2 X 22 X 3MM
233	PSB1132233	CAP SCREW M6-1 X 15
234	PSB1132234	16" HELICAL CUTTERHEAD
235	PSB1132235	FLAT WASHER 5MM
236	PSB1132236	FLAT HD TORX SCR #10-32 X 1/2
237	PSB1132237	INSERT 15 X 15 X 2.5MM R98.5
288	PSB1132288	LOCK WASHER 8MM
294	PSB1132294	LOCK WASHER 10MM
299	PSB1132299	CAP SCREW M10-1.5 X 30
303	PSB1132303	SET SCREW M8-1.25 X 8
304	PSB1132304	LOCK WASHER 6MM

SB1132 Controls

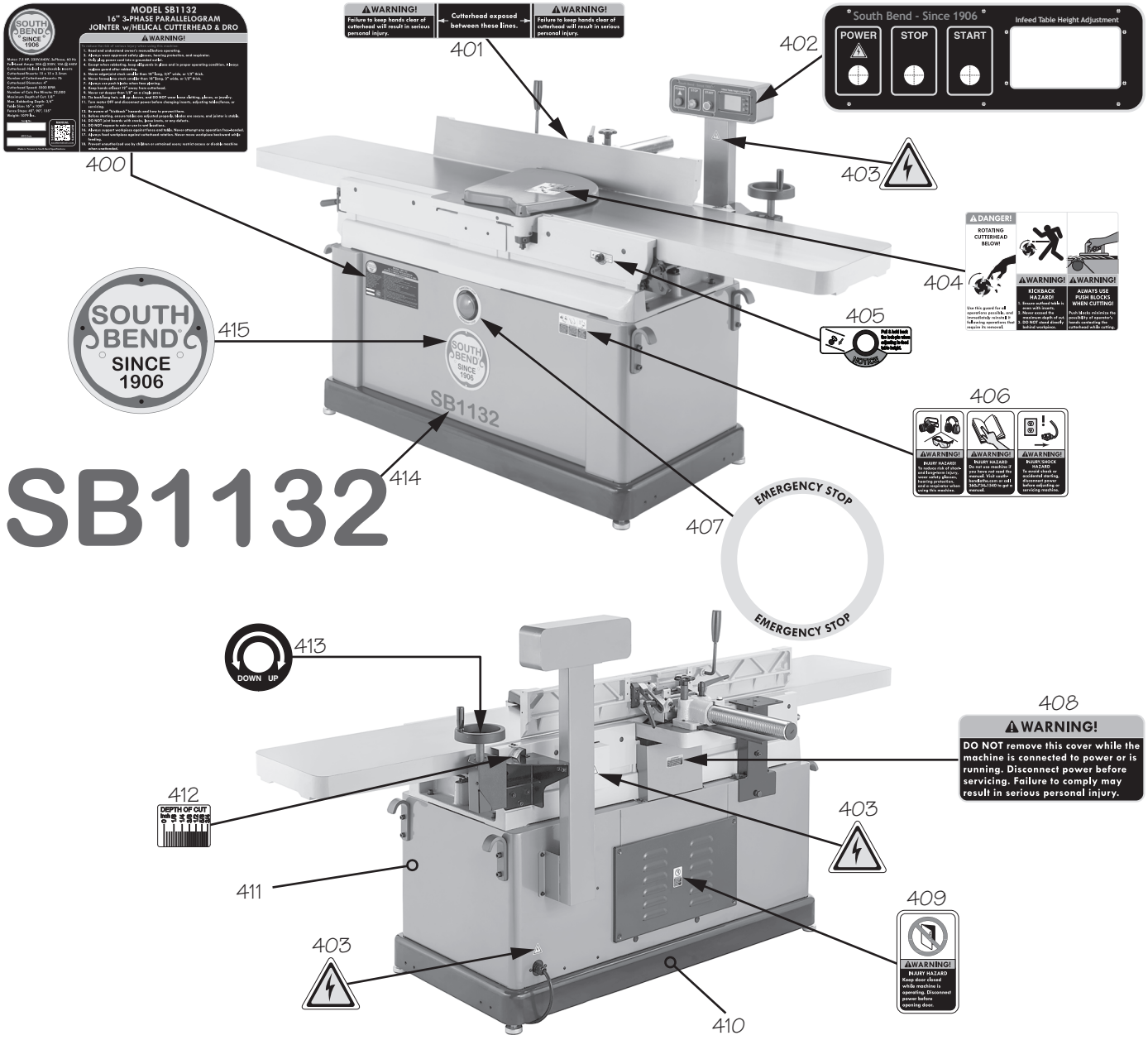


SB1132 Controls Parts List

REF	PART #	DESCRIPTION
71	PSB1132071	FLAT WASHER 5MM
106	PSB1132106	SCALE BRACKET
107	PSB1132107	DEPTH-OF-CUT BRACKET
110	PSB1132110	FLAT WASHER 8MM
113	PSB1132113	EXT RETAINING RING 15MM
114	PSB1132114	GEAR 50T
115	PSB1132115	WORM SHAFT 31.5 X 21.5
116	PSB1132116	SPRING PIN 5 X 20
117	PSB1132117	KEY 5 X 5 X 8 RE
118	PSB1132118	SHAFT
119	PSB1132119	FLANGED BUSHING
120	PSB1132120	FLAT WASHER 10 X 22 X 0.8MM
121	PSB1132121	LOCK NUT M10-1.5
122	PSB1132122	PLATE
123	PSB1132123	LOCK SHAFT 18 X 35
124	PSB1132124	LEADSCREW SUPPORT BRACKET
125	PSB1132125	GEAR 30T
126	PSB1132126	FLAT WASHER 12MM
127	PSB1132127	EXT RETAINING RING 12MM
128	PSB1132128	FLAT WASHER 15.5 X 25 X 2.5MM
129	PSB1132129	GEAR 30T
130	PSB1132130	CAP SCREW M6-1 X 12
131	PSB1132131	FLAT WASHER 6.4 X 16 X 1MM
132	PSB1132132	FOLDING HANDLE M6-1 X 20, 85.5
133	PSB1132133	HANDWHEEL M11.5
134	PSB1132134	HEX BOLT M6-1 X 16
135	PSB1132135	DEPTH SHAFT
136	PSB1132136	KEY 4 X 4 X 16 RE
137	PSB1132137	SUPPORT BRACKET COVER
159	PSB1132159	CAP SCREW M6-1 X 16
160	PSB1132160	DRO PLATE
161	PSB1132161	PHLP HD SCR M3-.5 X 15
162	PSB1132162	FLAT WASHER 3MM
163	PSB1132163	BALL BEARING 606ZZ
164	PSB1132164	BEARING BUSHING 3.1 X 6.5 X 5.8MM
165	PSB1132165	CAP SCREW M5-.8 X 12
166	PSB1132166	LOCK NUT M3-.5
167	PSB1132167	BEARING BRACKET
168	PSB1132168	DRO SENSOR W/CORD
169	PSB1132169	LOCK NUT M5-.8
170	PSB1132170	LOCK WASHER 3MM
171	PSB1132171	FIXED BOARD
172	PSB1132172	FLANGED BUSHING

REF	PART #	DESCRIPTION
173	PSB1132173	MAGNETIC SCALE
174	PSB1132174	FLAT WASHER 5MM
175	PSB1132175	CABLE TIE
176	PSB1132176	CABLE PROTECTOR
177	PSB1132177	COVER
178	PSB1132178	CAP SCREW M5-.8 X 6
179	PSB1132179	HEX BOLT M4-.7 X 6
180	PSB1132180	CONTROL PANEL FACE PLATE
181	PSB1132181	LED KEYON 115/230V WHITE
182	PSB1132182	STOP BUTTON 0AV RED
183	PSB1132183	START BUTTON YK A600
184	PSB1132184	LED CORD 18G 1W 6"
185	PSB1132185	SWITCH BOX
186	PSB1132186	CONTROL PANEL ASSEMBLY
187	PSB1132187	TAP SCREW M4 X 10
188	PSB1132188	PHLP HD SCR M4-.7 X 8
189	PSB1132189	FLAT WASHER 4MM
190	PSB1132190	EXT TOOTH WASHER 4MM
192	PSB1132192	WIRE CLIP
193	PSB1132193	CONTROL PANEL COLUMN
194	PSB1132194	FLAT WASHER 6MM
238	PSB1132238	O-RING 10.8 X 0.18 P11
239	PSB1132239	STOP BUTTON CORD 18G 1W 12"
240	PSB1132240	START BUTTON CORD 18G 1W 10"
244	PSB1132244	PHLP HD SCREW M3-.5 X 20
245	PSB1132245	DRO CORD 18G 1W 12"
248	PSB1132248	CAP SCREW M5-.8 X 15
249	PSB1132249	HEX BOLT M5-.8 X 8
289	PSB1132289	LOCK WASHER 8MM
295	PSB1132295	LOCK WASHER 10MM
297	PSB1132297	HEX BOLT M6-1 X 10
305	PSB1132305	LOCK WASHER 6MM
306	PSB1132306	CAP SCREW M10-1.5 X 25
307	PSB1132307	FLAT WASHER 10MM
308	PSB1132308	CAP SCREW M8-1.25 X 20
309	PSB1132309	CAP SCREW M8-1.25 X 20
310	PSB1132310	LOCK WASHER 8MM
311	PSB1132311	FLAT WASHER 8MM
313	PSB1132313	CABLE PROTECTOR
314	PSB1132314	FLAT WASHER 4MM
315	PSB1132315	SET SCREW M6-1 X 6
317	PSB1132317	CAP SCREW M5-.8 X 10

SB1132 Labels & Cosmetics



SB1132

REF	PART #	DESCRIPTION
400	PSB1132400	MACHINE ID LABEL
401	PSB1132401	FENCE/CUTTERHEAD LABEL
402	PSB1132402	CONTROL PANEL LABEL
403	PSB1132403	ELECTRICITY LABEL
404	PSB1132404	CUTTERHEAD GUARD LABEL
405	PSB1132405	KNOB NOTICE LABEL
406	PSB1132406	COMBO WARNING LABEL
407	PSB1132407	EMERGENCY STOP RING LABEL

REF	PART #	DESCRIPTION
408	PSB1132408	DO NOT OPEN COVER LABEL
409	PSB1132409	DO NOT OPEN PANEL LABEL
410	PSB1132410	TOUCH-UP PAINT, SB DARK BLUE
411	PSB1132411	TOUCH-UP PAINT, SB LIGHT BLUE
412	PSB1132412	DEPTH OF CUT LABEL
413	PSB1132413	HANDWHEEL LABEL
414	PSB1132414	MODEL NUMBER LABEL
415	PSB1132415	SOUTH BEND NAMEPLATE 203MM

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