

JOINTER

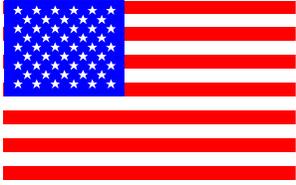
M a n u a l



Jointer User Manual • Contact Information

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Key Knife History

1986 - Bob Bayly and Tom Carpenter joined forces in Portland, OR to design and build a disposal knife for OSB plants. After a year of work, they chose to proceed with the development of a second concept upon the recommendation of Dudley Smith, who along with Bob's mother, Jane Bayly, were two of Key Knife's first financial supporters. The second concept marked the beginning of today's version of the Key Knife.

1987 - Bob and Tom hired Cecil Ostrander to build the first prototype of a chipper system utilizing steel knife stock "borrowed" from a friendly competitor. The first installation occurred at Mountain Fir Lumber of Dallas, OR in a Mobark chipper and ran for all of 30 seconds. Once they resolved the matters of hardness and radiuses, they hired their first employee, Norma Sherratt in June of 1988 and production got underway in Cecil's barn. The achievement of producing one box of knives/day was considered a great day. Only two machines could be operated at a time due to the lack of power to the shop and the grinder was in a lean-to heated by a wood stove where the coolant had to be defrosted every morning before start up.

1989 - The production shop was moved to a 3500 sq. ft. facility in Wilsonville, OR. During this time, the official name of the privately held organization was changed from Commercial Knife to Key Knife. \$30,000 in sales for a month was considered record setting at the time. A former saw shop owner and supporter; Herb Frelich became the first production manager and the Chip-n-Saw concept was introduced in 1990. Neil Doherty was hired as the first field rep in January of 1991 and the first CNC machine purchased in 1992.

1993 - The manufacturing and office relocated from Wilsonville to a 20,000 sq. ft. building in Tigard, OR and the first High Recovery system was developed. In 1994, the first Blohm (a computerized grinding machine) was purchased, revolutionizing the knife production process. Two additional CNC machines and another Blohm were purchased in 1995.

1998 - The company relocated again, moving from Tigard to a newly built 50,000 + sq. ft. facility in Tualatin, OR with room for additional expansion. A fourth Blohm and a fourth CNC have since been added along with the establishment of a machine shop center for further expansion into in-house product development. Likewise, in-house production of additional Key Knife system components is taking place on a calculated basis as part of the organization's overall strategic plan.

2004-Key Knife had a record sale year, with sales increasing 26% over 2003. To meet the growing demand for Key Knife products 3 more CNC machines were added. A new R & D test center nick named the Big Beaver, was added to help with the theory and design of the next generation Key Knife chipping systems. To continue the growth Key Knife has developed innovative products for the Pulp mill, Particleboard, and OSB industries. The demand for Key Knife products and services has taken the company to new parts of the world, such as South America and Asia.

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About this Manual

This manual has been designed to be a user-friendly reference guide for the use and operation of your Pro Honer 2. Included in the manual is information on the installation and operation of the Pro Honer 2, in addition information and management tools. It is our hope that this manual becomes a useable tool for you and your mill. As always, your local Key Knife representative is always available to answer any questions that you may have.

Safety

The Key Knife conversion is designed to provide safe and dependable service, if operated according to the instructions and intended use, in the chipping of wood material. Any other use could be dangerous and is not recommended.

Be sure to read the entire System Manual before installing the Key Knife system. Failure to do so could result in personal injury or equipment damage.

Key Knives are extremely sharp! When handling the knives, use extreme caution and wear safety gloves.

Observe all equipment shutdown, lockout, and safety procedures as recommended by the equipment manufacturers, as well as, your company policies and guidelines.

Key Knife Warranty Policy

Key Knife warrants that on the date of shipment to Buyer and for one year thereafter the Products will be free of defects in workmanship and material. If within one year from date of shipment of the Products, Buyer discovers that the Products are not as warranted above and promptly notifies Key Knife in writing thereof, Key Knife will, at Key Knife's option, repair or replace the item and any affected part of the Products, or refund the purchase price therefore. Buyer shall assume all responsibility and expense for removal and reinstallation in connection with the foregoing remedy. The same obligations and conditions shall extend to replacement items furnished by Key Knife here under. Buyer agrees to grant Key Knife access to the Products at all reasonable times in order for Key Knife to determine the existence of a claimed defect in the Products. Key Knife Product systems and accessories require installation by an Authorized Key Knife Representative. Installation by anyone other than an Authorized Key Knife Representative will void the terms of this warranty. This warranty does not cover defects due to misuse, abuse, improper or inadequate installation, storage, service, modification or repair of the products.

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↔ Component Identification

Pneumatic Motor

Designed to operate with 100-125psi air pressure. Air coupler *not* supplied.

Vertical Adjustment

Moves Jointing wheel, vertically to align the wheel to the Planer knives.

Off / Forward / Reverse Valve

During operation, the jointing wheel should rotate *Opposite* the rotation of the cutter head

Horizontal Adjustment

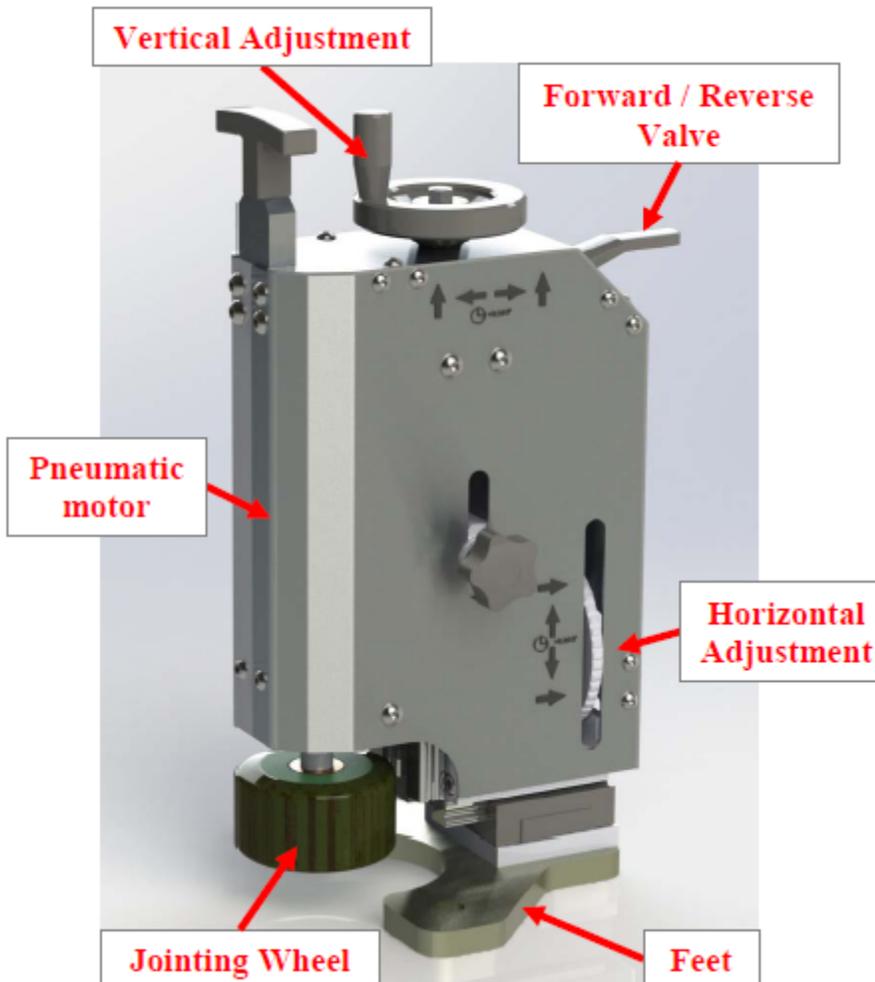
Used to adjust wheel into/away from Planer knives.

Jointing Wheel

CBN Wheel is made to the exact profile of the knife.

Feet

Rotary Jointer is bolted down through two feet for stability.



↔ Rotary Jointer Set up



Lockout the planer	Follow Lockout / Tagout procedures
Bolt the rotary jointer to the planer thru both feet	Center the jointer so that the horizontal linear bearing is centered on the planer head. A second hole may need to be added to the planer frame so that both feet can be bolted during operation
Attach an airline to the rotary jointer	Use a ½ air hose with a recommended air pressure of 100 – 125 PSI.
Joint the planer knives in the machine while the planer is locked out.	See the instructions that follow.
Remove the rotary jointer from the planer when jointing is done and before taking locks off the planer	
Store the rotary jointer in a cabinet to reduce dirt buildup on the grinding wheel.	For best results, clean the grinding wheel with brake cleaner regularly.

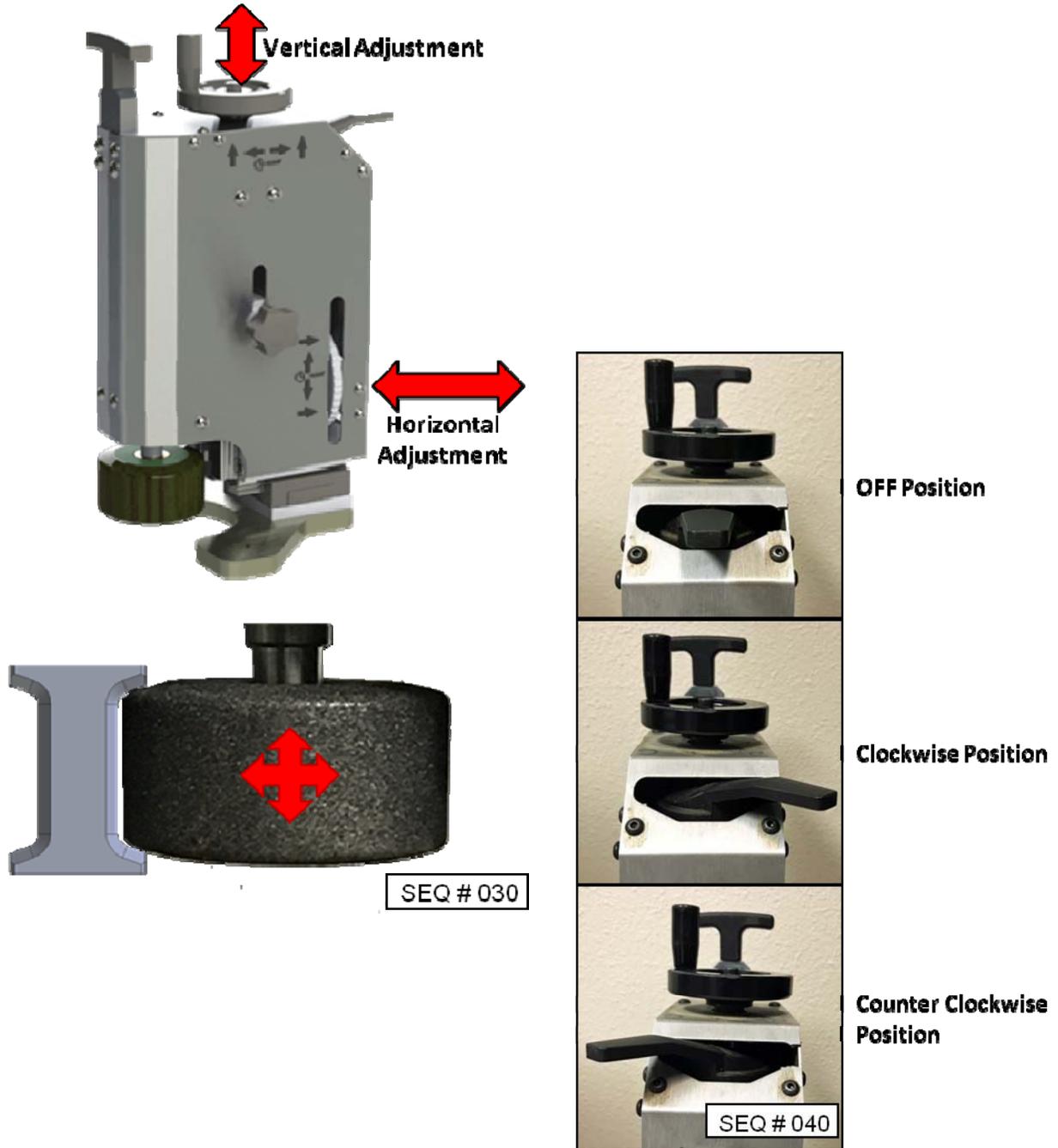
Jointer User Manual • Operation



SEQ #	Task Description	Additional Information
010	Bolt the rotary jointer to the table so that the jointing wheel is centered with the planer head.	Ensure the jointing wheel is parallel / plumb to the knives for an even joint line. Shim as required.
020	Attach the air hose to the rotary jointer (Air Coupler to be supplied by mill)	Use 1/2" air hose with 100 PSI - 125 PSI
030	Align the jointing wheel to the Planer Knives using the horizontal and vertical adjustments.	

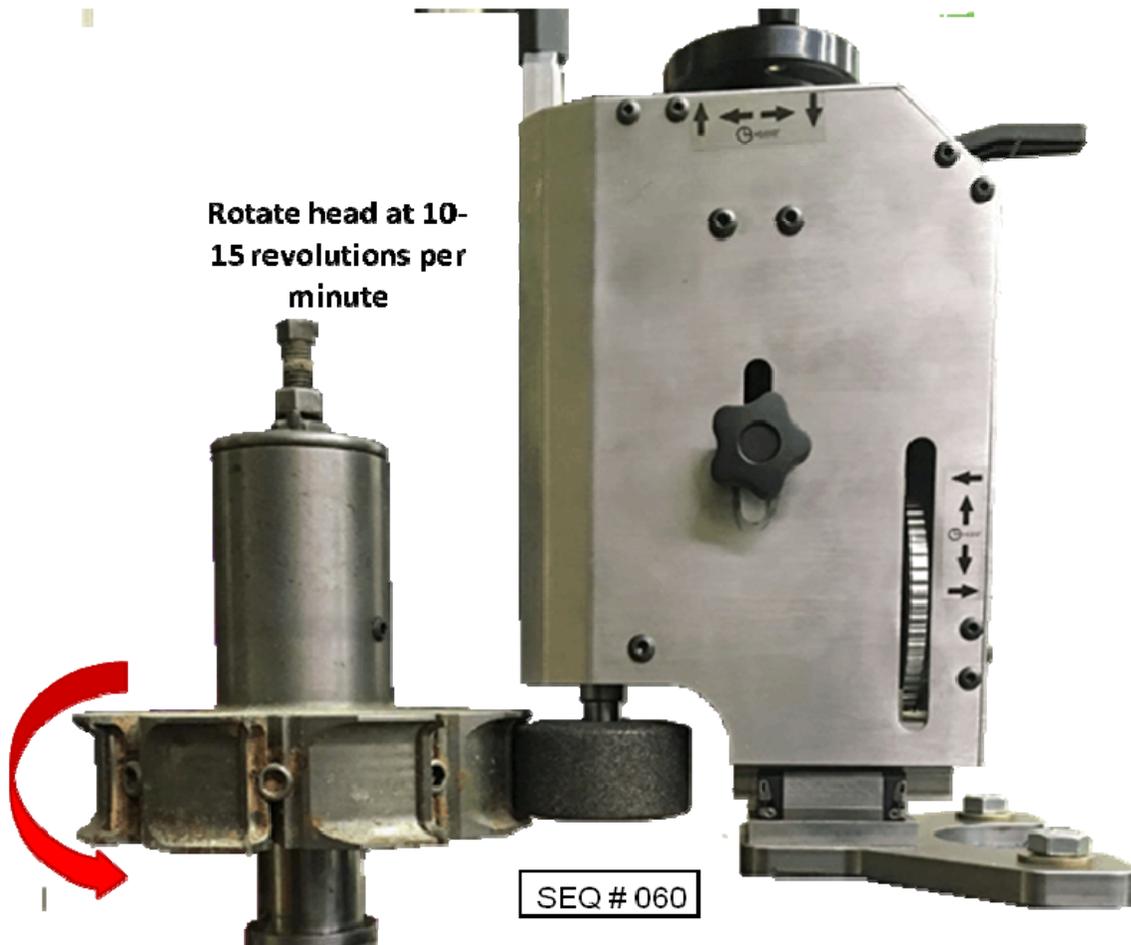
WARNING - Always wear protective gloves and eye protection while operating this machinery. Keep fingers away from the grinding wheel while in operation. Injury can occur if this machine is not operated in accordance with these instructions.

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SEQ #	Task Description	Additional Information
030	Align the jointing wheel to the Planer Knives using the horizontal and vertical adjustments.	
040	Back the wheel away from the knives and turn on the Jointer so that the wheel spins opposite normal head rotation (against the knives).	

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SEQ #	Task Description	Additional Information
050	Slowly move the wheel into the planer knives until a spark is created.	
060	Rotate the planer head in the normal rotation direction. Regularly check the knives until the proper joint is achieved.	Rotate head at 10 - 15 revolutions per minute.
070	Back the wheel away from the head and turn off the jointer.	
080	Clean the jointing wheel with brake cleaner - as required for proper operation.	

