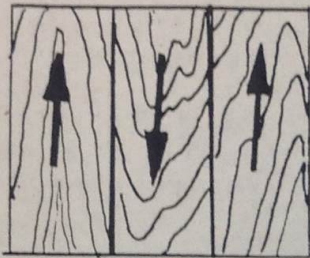


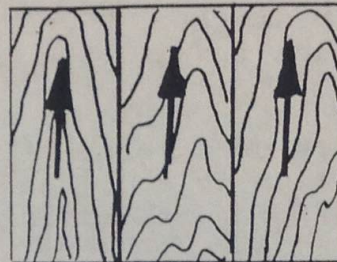
Gluing Up Stock - The I/O Method

One of the first things to remember is NEVER TRUST A GAUGE. You should square the fence, blade, and miter gauge each time you use the machine. To help eliminate problems when edge to edge gluing, we have developed what we call the I/O method of gluing. This is designed to compensate for any errors there may be in setting the jointer fence. The following steps should be followed carefully.

1. Place the boards with the grain running in the same direction if possible. This will help prevent chipping as it is run through the surfacer.

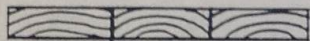


WRONG

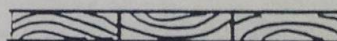


CORRECT

2. Alternate the end grain of the wood. This will help prevent warping of the stock. This way, each piece works against the adjoining piece when swelling.

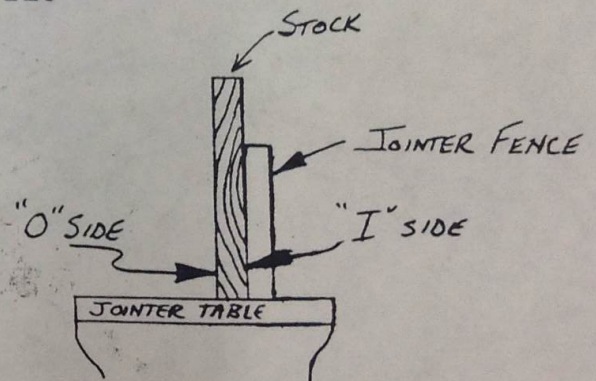
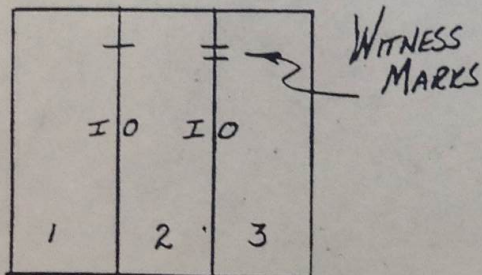


WRONG



CORRECT

3. After completing step 1 and 2, number each piece in sequence or place witness marks across each joint. On each set of adjoining edges, place an "I" on one edge, and "O" on the other. Repeat for each piece of wood.



4. Now take piece #1 and place the "I" to the inside touching the fence of the jointer and make one pass through the jointer. (Remember, the stock has already been jointed and ripped to a clean width). Now run the adjoining edge with the "O" to the outside of the fence. This assures you of obtaining a total angle of 180 degrees. Repeat the process on each edge of each piece.