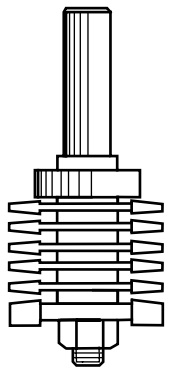
THE NEW CARBIDE-TIPPED FINGER JOINTER

Amana Tool®



Tool No.55392

AM-40-90 rev.10/99

DEAR WOODWORKER

CONGRATULATIONS,
You have just acquired a quality tool, which will serve you faithfully for years. With this tool you will be able to perform first class glued joints, like those made by the leading furniture manufacturers and by the most experienced craftsmen.

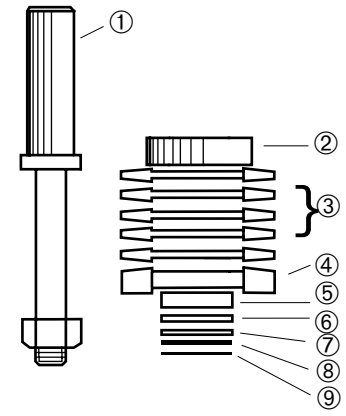
The new Amana Finger Jointer is an assembly of high-quality carbide-tipped finger slot cutters, which together with the abutting edge cutter creates a profile, extending the glue line threefold, thus strengthening the joint significantly. The appropriate assembly is chosen according the the wood thickness.

The minimum thickness is 11mm (7/16"), requiring the one-finger assembly. The maximum thickness, 36mm (1-3/8"), is implemented with the five-finger assembly.

The Amana Finger Jointer fits into any portable or stationary router whose collet is appropriate to the arbor shank. The standard arbor shank is 1/2".

The Finger Jointer is suitable for all kinds of glued joints, which are applied mainly for furniture, board edging etc.

SUPPLIED PARTS



All above components are assembled on the arbor, except the 0.1mm shims ⑧ and 0.05mm shims (10), and one 3.6mm spacer ⑥, which are placed separately in the blue styrofoam package.

TECHNICAL DATA

① **ARBOR WITH NUT** (1 piece) Part No.47620
Shank 1/2"; Spindle Ø 5/16";
Thread 5/16 NF.

② **BALL BEARING** (1 piece) Part No.47708
Ø 28mm; Bore 8.0mm; Width 9.0mm.

③ **FINGER SLOT-CUTTER** (5 pieces)
Part No.55394 Ø 39.1mm; Bore 8.0mm;
Kerf 1.8-3.3mm.

④ **ABUTTING-EDGE CUTTER** (1 piece)
Part No.55396 Ø 39.4mm; Bore 8.0mm;
Kerf 5.0-6.5mm.

⑤ **SPACER** 6MM (1 piece) Part No.55368
Ø 16mm; Bore 8.0mm.

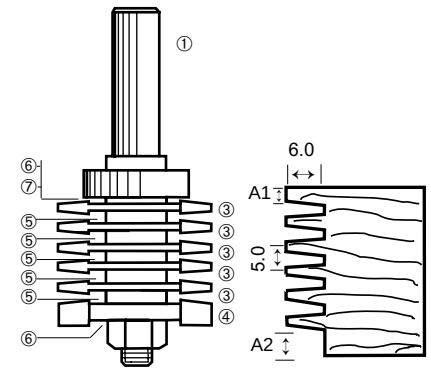
⑥ **SPACER** 3.6mm (7 pieces) Part No.55367
Ø 16mm; Bore 8.0mm.

⑦ **WASHER** (2 pieces) Part No. 55402
Ø 16mm; Bore 8.0mm; Thickness 1mm.

⑧ **SHIM** 0.5mm (1 piece) Part No. 55404
Ø 16mm; Bore 8.0mm.

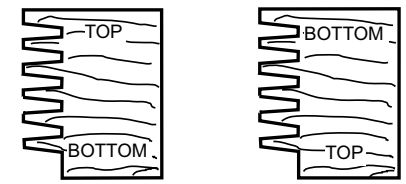
⑨ **SHIM** 0.5mm (10 pieces) Part No.55356
Ø 16mm; Bore 8.0mm.
(or 10 pcs. .10 shims Part No. 55357)

ASSEMBLED JOINTER



As the diameter of the cutter ③ is slightly larger than the diameter of the cutter ④ a space of 0.2mm is created in the joint for the absorption of the surplus glue.

FIRST CUT COUNTERCUT



PERFORMING THE JOINT

Choose the appropriate assembly according to the wood thickness, as shown in overleaf.

The cutters should be assembled to match the spindle rotation and should be square to one another to ease stress on the tool.

Perform a trial cut on a piece of scrap material which has exactly the same thickness as the true piece. Make sure that A1 is equal to A2 (see opposite drawing).

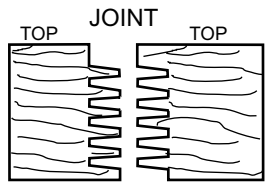
Cut the performed scrap into two pieces and invert one piece against the other.

Check if their faces are perfectly aligned. If so, you are ready for the true cut. If not, adjust the height of the tool by raising or lowering the router.

After having performed the first cut, the countercut is now carried out by inverting the wood.

Check again on a piece of scrap, if the faces are aligned and correct the tool's height, if necessary.

If especially tight joints are required, merely add the 0.1mm shims to the 3.6mm spacers. Tightness should also be checked after regrinding, using shims to correct as needed.



ASSEMBLIES

The appropriate assembly is chosen according to the wood's thickness as shown in the following diagrams.

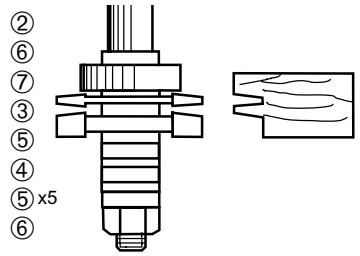
If the thickness of the wood allows use of two different assemblies, the assembly with more fingers should be chosen.

For example: Wood thickness of 21mm allows use of the two-finger assembly (MIN.) or the three-finger assembly (MAX). In this case choose the three-finger assembly, as the glue line is extended by the third finger slot cutter.

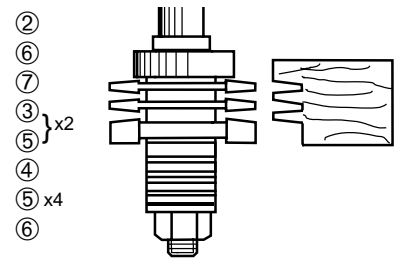
ASSEMBLY SEQUENCE LEGEND

② Ball Bearing
③ Finger Slot Cutter
④ Abutting-Edge Cutter
⑤ Spacer 6mm
⑥ Washer
⑦ Shim 0.5mm
⑧ Shim 0.1mm

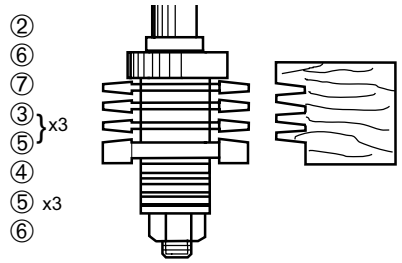
ONE-FINGER **WOOD THICKNESS**
Assembly Minimum 11mm (7/16")
Sequence Maximum 16mm (5/8")



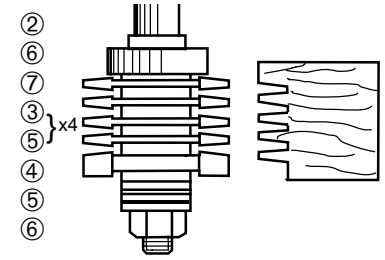
TWO-FINGER **WOOD THICKNESS**
Assembly Minimum 16mm (5/8")
Sequence Maximum 21mm (13/16")



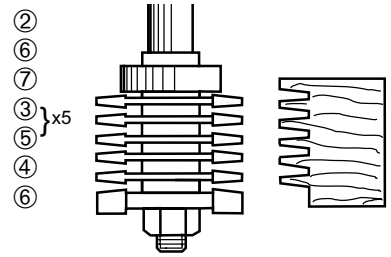
THREE-FINGER **WOOD THICKNESS**
Assembly Minimum 21mm (13/16")
Sequence Maximum 26mm (1")



FOUR-FINGER **WOOD THICKNESS**
Assembly Minimum 26mm (1")
Sequence Maximum 31mm (1-13/16")



FIVE-FINGER **WOOD THICKNESS**
Assembly Minimum 31mm (1-3/16")
Sequence Maximum 36mm (1-3/8")



Warning

Carbide cutting tips may chip or fragment during use. Always use machine guards and wear proper eye protection while operating routers and machinery. Keep hands clear of cutting area Collet integrity and usage is extremely important to safety and longer tool life. Please refer to your Owner's Manual and the Amana Catalog for further information. Grinding of this product will produce dust of potentially hazardous ingredients! Use adequate ventilation and read Material Safety Data Sheets.

GUARANTEE

This Finger Jointer
is guaranteed against any defects
in either workmanship
or material except if it has been
abused or has been
damaged due to
improper maintenance.

Amana Tool®