



INSTALL CLAMP on spindle housing but don't screw cutter tightly on spindle until table is in position



PLACE TABLE in position, but do not bolt in place. Then tighten cutter block on the nose of the spindle

of the planer table, the Unimat motor is swung downward and a headstock-raising block (provided with the planer) is inserted between headstock and lathe bed to increase spindle height by $25/32$ in.

The SL Model Unimat has a two-hole headstock-clamping bolt that permits the head to be anchored to the bed either with or without a raising block. Older models have a short, one-hole clamping bolt that cannot be used with a raising block, so it will be necessary to replace this with a longer bolt (for about \$2).

The cutter is a steel block measuring approximately $5/8 \times 1 \times 1 7/8$ in. that screws onto the Unimat spindle nose. The ends of this block have "differential" bevels flanking the cutting edges. Keenness can be restored by honing, but extensive re-sharpening would require more precise grinding.

The guide fence is a 7-in. strip of angle steel secured by two-hex-head capscrews passing through slots that permit lateral adjustment over a range of about $1/2$ in. It also can be adjusted to position narrow work at different points on the cutter for uniform edge wear.

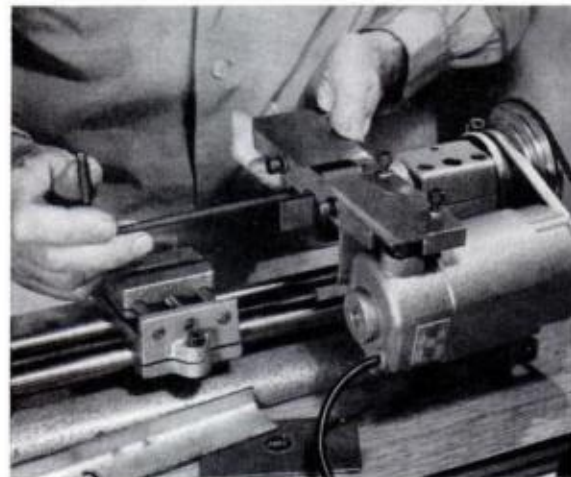
The mounting clamp is a split-ring arrangement that slips over the Unimat spindle housing and over which, in turn, slides the round opening in the side of the table body. The clamp shoulder engaging the table-body opening is eccentric with respect to the spindle-housing hole.

Two capscrews passing through curved slots in the table side engage holes in the clamp. If these, and the clamp screw, are loosened, the table can be elevated by holding it horizontal with one hand and turning the split-ring clamp counterclockwise (facing threaded end of spindle).

The guard plate is simply a rectangular metal plate held by two capscrews over the open side of the table body to protect the operator's fingers and also help direct chips downward.

During your first attempt to install the planer on the Unimat, you might be inclined to think that somebody goofed in shaping the parts. But after a little practice, setting-up takes just a few minutes.

My first attempts to screw the cutter block on the spindle (after the table had been firmly clamped to the spindle housing) resulted in jamming the spindle nose in the cutter hole—with the prospect of damaging threads when trying to loosen



TIGHTEN THE TWO CAPSCREWS holding planer table to the spindle-housing clamp, using wrench provided