



10 Joinery

10.2 Biscuit Joiner

10.2.4 Machine Edge Miter Joint

Candidate Name: _____ Date/Time: _____

Evaluator Name: _____ Location: _____

Completed test successfully: Yes No (If no, reason:) _____

Pre-Operation Checklist

Level 1

PERFORMANCE STANDARD:

- ▶ Verifies stock is properly clamped (if required).
- ▶ Demonstrates proper holding of machine to prevent vertical or horizontal movement when engaging cutter head.
- ▶ Verifies dust collection operable/operating (if equipped).

Level 2

PERFORMANCE STANDARD:

- ▶ Checks cutter for cleanness and replaces if needed.
- ▶ Tests equipment for movement of cutter head (plunge and retraction into housing).
- ▶ Installs or adjusts fence.
- ▶ Adjusts machine for depth of cut appropriate to the biscuit size being used.
- ▶ Meets Level 1 performance standard.

Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
 - ▶ Clamps, biscuits, and glue are prepared for quick assembly.
 - ▶ Disengage from power source until everything is ready to begin cutting operation.
 - ▶ Operator cleans tool and work area after use.
 - ▶ Required OSHA approved personal protective equipment is worn.
 - ▶ Lock-out/Tag-out procedure is in place and followed.
 - ▶ Process is completed in a timely manner.
- Please use back side for additional notes

Operation Checklist

Level 1:	Performance standard:	
Given material properly prepared for machining, execute the joint between 2 mitered lengths to receive biscuits.	<input type="checkbox"/> Demonstrates ability to place cutter head ± 0.4 mm (1/64") [0.0156"] of location mark.	<input type="checkbox"/> Joins opposing parts within ± 0.4 mm (1/64") [0.0156"] of intended lateral position.
	<input type="checkbox"/> Uses layout rod or company standard to mark biscuit locations.	<input type="checkbox"/> Angle of joint of any two opposing parts is within 0.5° of intended position.
	<input type="checkbox"/> Makes a joint face which is flush $\pm 0.005"$.	<input type="checkbox"/> Maximum gap caused by biscuit machining is 0.001" in joint between opposing parts after assembly.

Level 2:	Performance standard:	
Given material properly prepared for machining, layout material for joints, set up machine, and execute the joint between a shelf and vertical face or divider to receive biscuits keeping the shelf flush with the front edge.	<input type="checkbox"/> Marks layout of the joint square to edge and within ± 0.4 mm (1/64") [0.0156"] of intended position.	<input type="checkbox"/> Adjusts machine fence and guides to proper angle setting if required.
	<input type="checkbox"/> Marks center points for the biscuits on shelf and vertical within ± 0.4 mm (1/64") [0.0156"] of intended position.	<input type="checkbox"/> Meets Level 1 performance standards.