



03

Milling

3.1 Jointer

3.1.1 Face Jointing

Candidate Name: _____ Date/Time: _____

Evaluator Name: _____ Location: _____

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

Pre-Operation Checklist

Level 1

PERFORMANCE STANDARD:

- ▶ Verifies tool is properly guarded.
- ▶ Demonstrates knowledge of and proper use of all machine specific controls.
- ▶ Verifies in-feed and out-feed tables are free of debris prior to machining.
- ▶ Ensures dust collection operable/operating.

Level 2

PERFORMANCE STANDARD:

- ▶ Inspects knives for wear or defects.
- ▶ Installs and/or properly adjusts guard.
- ▶ Verifies and/or properly adjusts fence 90° to in-feed/out-feed tables.
- ▶ Verifies out-feed table is set to manufacturer's specification.
- ▶ Sets depth of cut appropriately.
- ▶ Verifies tables are clean and polished to facilitate smooth material movement.
- ▶ Meets Level 1 performance standard.

Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
 - ▶ Safe hand position and/or push blocks are used when appropriate.
 - ▶ Appropriate stance is utilized for optimum balance and part control.
 - ▶ Stock is fed in smooth, continuous motion past cutter head.
 - ▶ Grain direction as well as bow/warp are correctly identified and appropriately considered for feed.
 - ▶ Out-feed table is appropriately utilized for purposes of facing/straightening.
 - ▶ Stock is supported at out-feed.
 - ▶ Machine and work area are cleaned after operation.
 - ▶ 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 rough sawn, unjointed material 900-1200 mm (3-4') long and a width of 100-150 mm (4-6"), a target thickness, and machine set up and ready to cut, face joint material.	<input type="checkbox"/> Face deviation does not exceed ±0.4 mm (1/64") [0.0156"] per foot from a flat plane.	<input type="checkbox"/> Board exhibits minimal tear out.
	<input type="checkbox"/> Face jointed thickness allows for final processing to target thickness.	<input type="checkbox"/> Board is free of snipe.
	<input type="checkbox"/> Machined surface exhibits a uniform smoothness between 15-25 knife cuts per inch (KCPI).	<input type="checkbox"/> No burn or hesitation marks are visible on surface being machined.
		<input type="checkbox"/> Face is marked to indicate jointed surface.

Level 2:	Performance standard:	
Given rough sawn, unjointed material at least twice the length of out-feed table and a width of 100-150 mm (4-6"), a minimum target thickness, set up and adjust machine, face joint material.	<input type="checkbox"/> Meets Level 1 performance standard.	