

## JET JWP-15DX & JWP-15HH, 15" Planers

The ability to create accurately dimensioned wood with parallel faces is crucial to virtually any woodworking task. Producing an ultra smooth, tear out free surface at the same time is a welcomed bonus. The JET JWP-15DX and JWP-15HH have been designed to handle these tasks with the accuracy, durability and repeatability you want. Robust construction, a powerful motor, a rock solid table and a user-friendly knife changing system gives these planers the durability and value you need.



The JET JWP-15DX is designed to be accurate, easy to use, durable and economical.

Built around a fully enclosed, welded steel base cabinet, the JET JWP-15DX and JWP-15HH use several precisely machined iron castings to insure durability and precise, repeatable operation. A heavy-duty caster system built into the base makes moving the 517-lb JET JWP-15DX around the shop easy. A foot-operated brake locks the casters to keep it stationary during use.



Motor power is delivered through a gang of three v-belts running in precisely machined pulleys.

Should lifting be necessary, four pull-out rods are built into the cast iron base. These rods provide safe lifting points for straps or forklift arms.

A powerful 3HP, (continuous duty rating) 1PH, 230V TEFC (totally enclosed fan cooled) motor is mounted within the base cabinet. Power is transmitted to the fixed cast iron cutterhead housing by three v-belts that turn precision-machined pulleys. A full-length belt cover is easily removed for maintenance by spinning off a pair of finger-operated knobs. The motor is operated and protected by a true magnetic switch mounted on the head assembly within easy reach.

### Quick-Change Knife System

The JWP-15DX features 3 knives and our "Quick change knife system". The knives each have 2 cutting edges so that they can be flipped when one side becomes damaged or dull. The savings in time and money this feature brings is obvious, but there is more.

An important feature of the JET JWP-15DX is how easily the knives are changed and set. A specially designed mounting and alignment system eliminates one of the most frustrating aspects of using many planers - changing and aligning its knives.

When a knife becomes dull or damaged all one has to do is remove the 8 retaining screws and carefully remove it. The cutterhead has two precisely machined and located pins in each knife seat that mate exactly with two precisely machined and located slots in the knife. When changing or flipping a knife simply place it over the pins on the cutterhead seat, replace and tighten the 8 screws and it is automatically aligned and ready for use. No further adjustment is required.



Our Quick-change knife system makes this once frustrating task quick, simple and automatically accurate. We include a pair of magnetic tools - shown here removing a knife retainer plate - that helps prevent nicked fingers!

## JWP-15HH with the Helical Cutterhead



Our helical head with its spiral rows of carbide inserts creates ultra smooth surfaces yet has an exceptionally long cutter life.

While designing the JET JWP-15HH we developed a criteria for a unique cutterhead that would insure the unmatched performance and reliability. That design specification meant the choice was very simple - a helical cutterhead with carbide inserts.

The JET JWP-15HH cutterhead is so effective because its 68 carbide inserts are arranged in four spiral-shaped rows. The inserts have a 4" radius ground into them and are mounted so they approach the wood at a 14-degree angle. That creates a true shear cut that eliminates much of the impact and the resulting fiber disturbance common with other cutterhead designs. Also contributing to this excellent surface finish is the profile of the space between the rows of carbide inserts. These areas are specially designed to carry chips away from the cutting area and eject them before they cause any problems for your work surface.

This helical cutterhead cuts so efficiently that it makes surprisingly little noise when cutting wood. In fact, it is so quiet, that new users often think that the JET JWP-15HH is not cutting wood at all! That is until they see the freshly planed surface emerge from the other side.

The helical cutterhead inserts are precisely machined from solid high-grade carbide, each with four identical cutting edges. If an edge goes dull or is damaged, you simply index it to the next cutting edge! Each insert has a marking at one edge that makes indexing all or any number of them the same way very easy.

Because the inserts and the seats into which they fit are so precisely machined, there is no adjustment or “fitting” necessary. Indexing or replacing an insert takes just seconds. Simply loosen the T25 Torx screw (wrench included), turn the insert to its new position and tighten the screw.

The durability of the carbide combined with the low impact, shear cutting action means they have an extremely long life that substantially exceeds that of straight blades. The potential life span of these carbide inserts means that many wood workers may go years before having to index them. Should a hidden piece of metal be encountered and actually damage a few of the carbide inserts only those need to be indexed or replaced. Just in case you accidentally plane a metal object, we include a package of ten spare inserts and a wrench with the JET JWP-15HH.



The carbide cutters on the helical head each have four individual edges. Should one edge go dull the inserts can be indexed four times, each producing a totally new edge.

## Feed & Rollers



Dual feed rates allow quick dimensioning of the wood and then slowing the material speed for highly refined finish cuts.

The JET JWP-15DX and JWP-15HH have two material feed rates –20 FPM (Feet Per Minute) used primarily for rough dimensioning and 16 FPM to increase the cuts-per-inch to create a silky-smooth surface. A push/pull knob shifts between the feed rates on the fly. The rollers are driven by a gear and chain drive with an automatic chain tensioner, housed in a cast iron case. The gear section runs in an industrial style oil bath for maximum control over long-term wear.

For the ultimate in dependability, we designed a serrated steel infeed roller and a smooth steel outfeed roller. Both rollers and the chip breaker are precisely set at the factory but have user accessible adjustments that make it easy to keep these planers perfectly tuned in years to come. We also included infeed and outfeed roller spring tension adjusters that are accessible without having to disassemble the cutterhead housing covers. The operators’ manual included has a full set of illustrated instructions for making these adjustments.

To enhance operator safety, we added a row of closely spaced anti kickback fingers. These steel fingers are gravity operated and require no adjustment. They automatically engage the wood as it enters the cutterhead and help prevent it from being kicked out.



The all-metal adjustable feed rollers, anti-kickback fingers and adjustable chip breaker make this an exceptionally safe and user-friendly planer.

While the JET JWP-15DX and JWP-15HH are capable of 3/16"-deep cuts on most stock widths, a limiter plate at the center of the cutterhead that limits full-width cuts to 1/8" or less. Controlling full-width cut depth avoids applying excessive strain to the machine but also prevents damaging the wood. Deep cuts are far more likely to produce chipping and tearout because of the extraordinary stress applied to the wood fibers.

## Dust Collection



The 4"-diameter dust port is angled to the side to prevent the dust collector hose from interfering with the wood as it exits the planer.

exits.

The efficiency of the JET JWP-15DX and JWP-15HH means they are capable of generating large quantities of dust and chips that must be evacuated to maintain performance at the cutterhead. We recommend a 500-600CFM (cubic feet per minute minimum) dust collector to handle the flow of chips properly.

A specially designed dust hood comes with the JET JWP-15DX that creates a short, direct path for the debris directly from the cutterhead. The hood terminates with a 4"-diameter port that is angled to the side so the dust collector hose does not interfere with the stock as it

The JET JWP-15HH actually takes this a step further. The helical nature of the cutter head actually ejects debris at an angle, directly toward the exit of the angled dust hood.

## Table and Adjustment

The cast iron table surface is 20"-long by 15"-wide and precision ground for precise planing. Each corner of the table loops around a 2"-diameter, precision ground steel post and is locked onto a lead screw within the post that controls the up and down movement. The lead screws are driven by a single chain through a gear drive. A large 6"-



Cutting depth adjustments are made using the large cast iron handwheel (left) which also has a spinner handle built in to make large changes go quickly. A large knob at either end of the table (right) locks the height setting for precise, clean cuts.

diameter cast iron handwheel with spinner handle drives the height adjustment mechanism. Each full revolution of the handwheel produces just over 1/16" of change to make the ultra fine adjustments necessary to hit a specific thickness easy to achieve. Though unlikely, the lead screws can be adjusted individually should the table ever get out of alignment.



Adjustable height rollers in the primary table (left) make moving rough stock through the machine easier. The large roller extension tables (right) increase the overall table support to 48" long!



The table is locked in place by a knob at each end that locks the table to the lead screw at that end. The locking handles can be moved to either side of the JET JWP-15DX and JWP-15HH to make them more easily accessible if one side has limited access in your

situation.

A pair of rollers set into the primary table surface below the cutterhead help maintain smooth movement of rough stock through the JET JWP-15DX and JWP-15HH. The above table height of the rollers is easily adjustable.

We also include a pair of 14"-long by 15 1/2"-wide roller extension tables that increase the overall table surface to 48" in length. The extension tables mount to the primary table with bolts but have set screws below each of them that allow precise alignment of the rollers to the primary table. This is a far more efficient system than trying to shim the extension tables to bring them into alignment with the primary table surface.

Note: The JWP-15HH planer comes with solid cast iron extension tables in place of the roller versions supplied with the JWP-15DX. The cast iron extension tables mount identically to the roller versions.

## Top Rollers

To make moving the stock from one side of the JET JWP-15DX and JWP-15HH to the other for repeat cuts easier we added a pair of material rollers to the cutterhead housing. The iron rollers put the often-heavy stock at a comfortable 43 1/2" above the floor.

If you are considering adding the power, accuracy and durability of a stationary planer to your shop, the value-packed JET JWP-15DX and JET JWP-15HH should be at the top of your must see list!



The heavy duty material rollers on top make returning heavy stock for the next cut easier and safer.