

biscuit size to suit most applications. After selecting the biscuit size, set the depth adjustment knob to the corresponding size (see Controls section). Also, be sure the fine depth adjustment is correctly set by first testing in a scrap piece. This is extremely important as you do not want to discover during glue-up that your biscuit slots are not quite deep enough.

2. BISCUIT LOCATION AND LAYOUT

Generally, biscuits may be spaced and located at your discretion. For edge joints, a good rule of thumb is to space biscuits every 6-10 inches on center. It is further recommended that biscuits be placed so that the centerline of the end biscuits is 2-3 inches from the end of the workpiece. When joining face frames or picture frames where the workpiece is narrow, you may have to choose the smaller biscuit sizes to keep from "breaking out" on the end of the joint. Breaking out should be avoided if possible, but if not you can assemble the joint and trim off the exposed biscuit tip after the glue sets (see Figure 13). When working with material up to 1" thick, we advise to use a single biscuit located in the approximate center of the material thickness. If thicker stock is to be joined, you may choose to use 2 biscuits across the thickness for greater strength (see Figure 14). Biscuit locations should be marked by first positioning the mating pieces exactly as they are to be assembled. Next, make a mark at 90° to the joint interface across both pieces at the desired biscuit locations (see Figure 15). See Application section for more specific information on joint layout. The marks you make will then be aligned with one of the center registration marks on the tool, again, depending upon your specific application.

3. MAKING THE CUT

Prior to making any cut, be sure that all fence adjustments are set and lock knobs are tight. Also, be sure you have selected the proper depth setting. Clamp your workpiece firmly and align the plate joiner's center registration mark with your layout mark. Turn on the tool and let the blade come up to full speed (approximately 1 second). Grasping the switch handle and auxiliary handle and positioning the fence firmly and squarely against the workpiece, plunge the blade until it bottoms against the stop. Continuing to hold the tool squarely and firmly, allow the return spring to retract the blade from the work and then release the switch to shut the tool off. It will take some practice to obtain a "feel" for the tool to produce accurate joints, so practicing in scrap wood first is advisable.

4. JOINT ASSEMBLY

After your joints are cut, you may wish to trial fit everything together before gluing. When you are satisfied with your joints, evenly spread any good quality woodworking glue in each slot as well as on the mating flat surfaces of your joint. Place biscuits in the slots, assemble the joint and clamp until dry. For a biscuit joint to be most effective, it is important that the biscuits themselves be in contact with the glue. This is because the biscuits absorb the moisture in the glue and expand to form a tight joint.

Applications

1. EDGE TO EDGE JOINTS (See Figure 16)

This is the simplest to make and most common joint for the plate joiner. Follow the steps below to produce this joint.

- Prepare the workpieces and lay them on a work surface exactly as they are to be assembled.
- Spacing biscuits 2-3" in from the ends and 6-10" apart, layout the biscuit centers.
- Set up the plate joiner by first selecting the proper depth setting. Set the fence to 90°. Set the height adjustment to position the biscuit in the approximate center of the stock thickness.
- Clamp the workpiece and position the tool so that the center indicator mark lines up with the first layout mark (see Figure 17). Turn on the tool and make the plunge cut. Retract the tool and release the trigger to turn the tool off. Repeat for each layout mark.
- Glue, assemble and clamp the joint.
- For stock thicker than 1", you may wish to use double biscuits at each location. Set the height adjustment to allow at least 3/16" of stock between the biscuit and the edge of the work surface. Make all cuts at this fence setting before readjusting the fence for the lower cuts. Again, there should be at least 3/16" of stock between the biscuit and the outside wall and between the biscuits themselves (see Figure 18).

2. FRAME JOINTS (See Figure 19)

Frame joints are an ideal application for biscuit joinery. With the plate joiner you can create a very strong, precise joint that is much faster to make than a dowel or mortise and tenon joint. Figure 19 shows two types of frame joints. Follow the steps outlined below.

- Arrange the workpieces on a flat work surface exactly as they are to be assembled.
- Select the proper biscuit size based on the length of the joint. (If the frame pieces are too narrow for a #0 biscuit, you will have to allow the biscuit tip to protrude slightly and then trim it off after the joint is dry (see Figure 13).
- Lay out the biscuit locations.
- Set up the tool by selecting the depth that corresponds to the chosen biscuit size. Lock the fence at 90° and adjust the fence height to center the biscuit on the stock thickness.
- Clamp the workpiece and position the Plate Joiner to make the first cut (see Figure 20).
- Turn on the tool and make the plunge cut.
- Repeat for each layout mark.
- Glue, assemble and clamp the frame.

3. CORNER JOINTS (See Figure 21)

Corner joints are another common and excellent application for biscuit joinery. Follow the procedure below.

- Arrange the workpieces exactly as they are to be joined.
- Select the biscuit size and layout the biscuit locations.
- Set up the tool by selecting the proper depth setting, adjusting the fence to center on the stock thickness and setting the angle to 90°.
- For this joint, you will make cuts into the edge of one workpiece and the face of another. The edge cut is performed the same as for edge to edge joints. The face cut is made by clamping the workpiece and aligning the tool as shown in Figure 22. Turn the tool on, make the plunge cut and repeat for each layout mark.
- Glue, assemble and clamp the joint.

4. OFFSET JOINTS (See Figure 23)

You may wish to have a deliberate offset between two workpieces. This is easily accomplished with your plate joiner by performing the following steps.

- Arrange the workpieces as they are to be assembled and layout the biscuit locations.
- Set up the tool by selecting the proper biscuit size and adjusting the fence angle to 90°. Select the workpiece that will be set back and adjust the fence height to center the cut within the thickness of that piece.
- Clamp the workpiece, align the tool and make the plunge cut.
- Next, adjust the fence up by an amount equal to the desired offset. Use the scale and pointer located on the right side of the tool under the fence lock knob.
- Clamp the second workpiece, align the tool and make the plunge cut.
- Glue, assemble and clamp the joint.

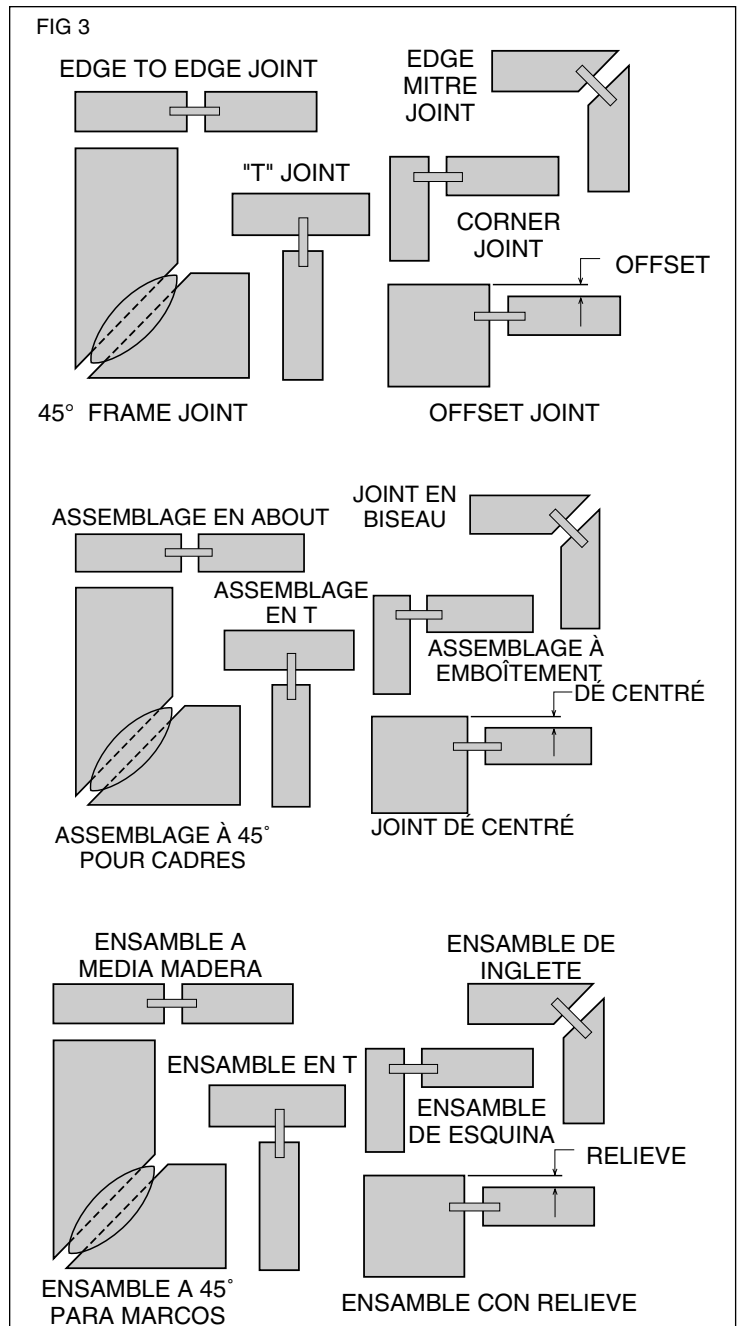


FIG 4

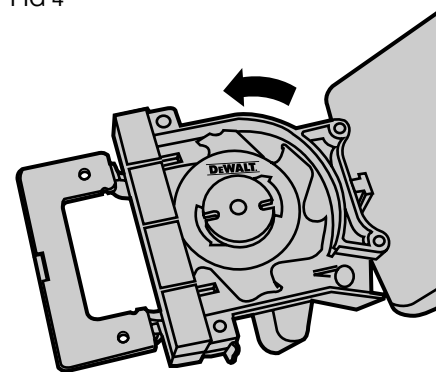


FIG 5

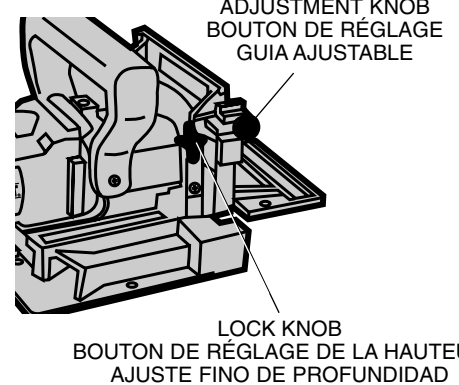


FIG 6

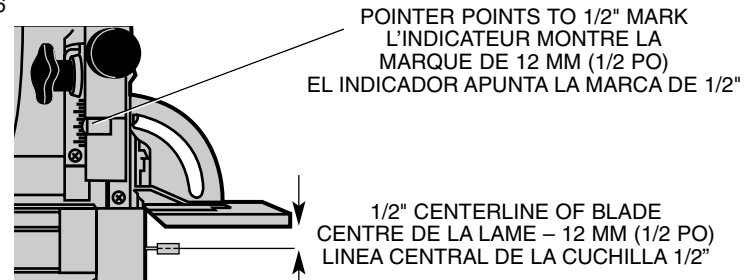


FIG 7

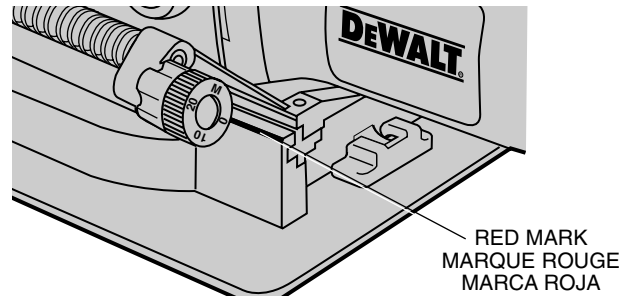


FIG 8

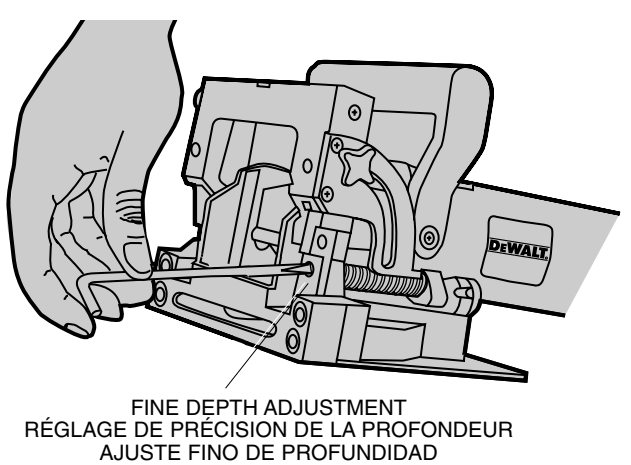


FIG 9

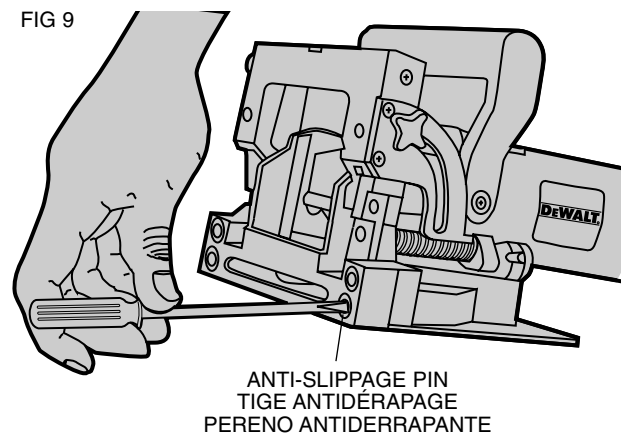


FIG. 10

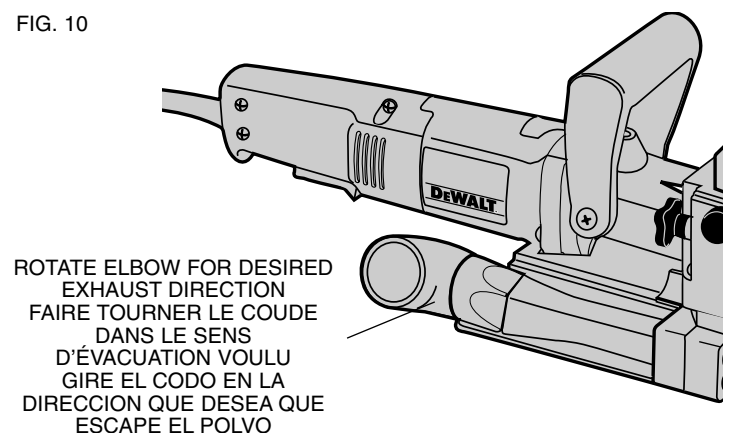
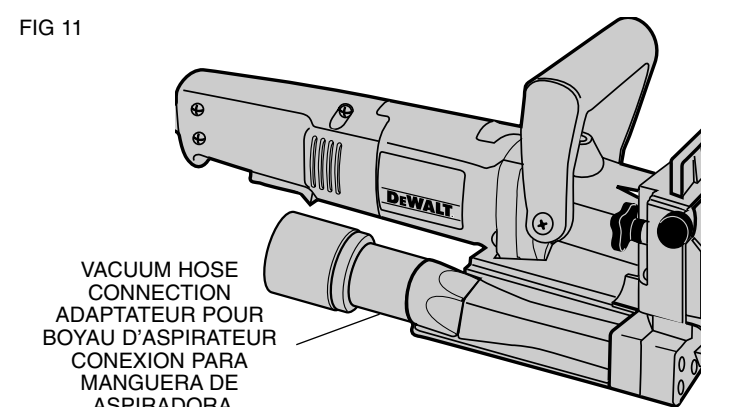
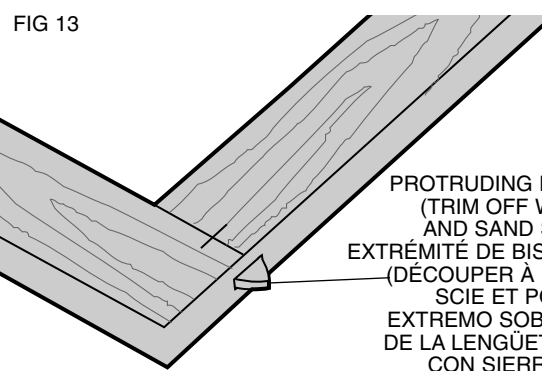
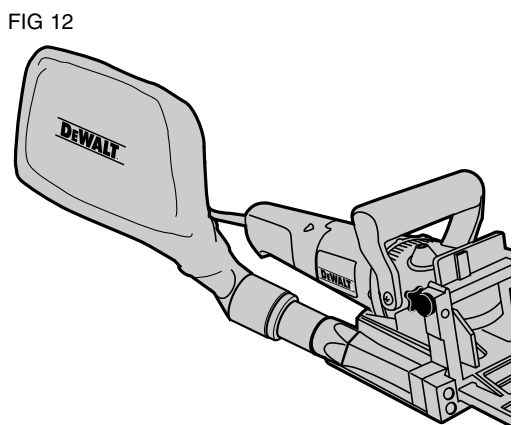
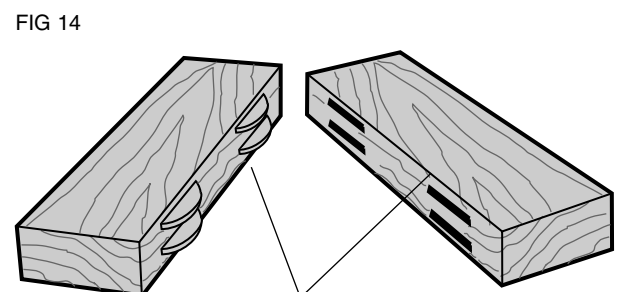


FIG 11





PROTRUDING BISCUIT END
(TRIM OFF WITH SAW
AND SAND SMOOTH)
EXTRÉMITÉ DE BISCUIT SAILLANTE
(DÉCOUPER À L'AIDE D'UNE
SCIE ET PONCER.)
EXTREMO SOBRESALIENTE
DE LA LENGÜETA (RECORTE
CON SIERRA Y LIJE)



1" OR GREATER STOCK THICKNESS
PIÈCES DE PLUS DE 25 MM (1 PO) D'ÉPAISSEUR
MADERA DE 25MM (1") DE ESPESOR O MAYOR

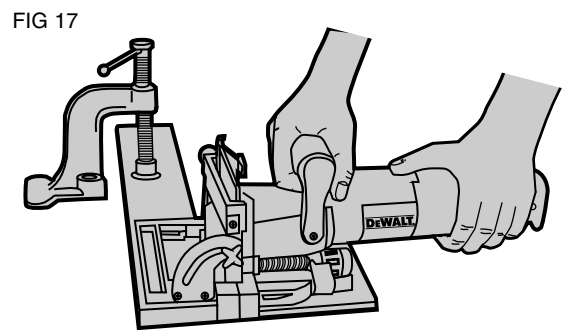
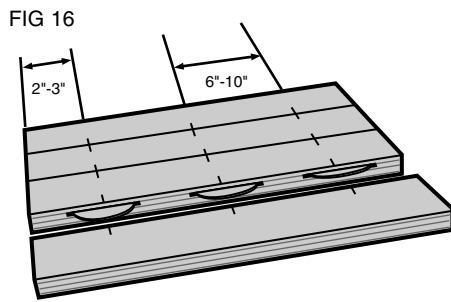
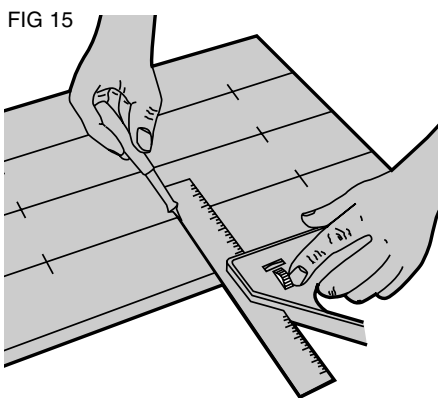
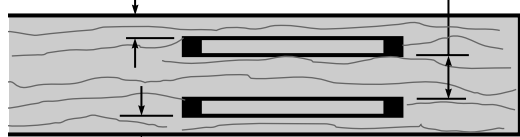


FIG 18
3/16" (5 MM) MINIMUM
MINIMUM DE 5 MM (3/16 PO)
4,7 MM (3/16") MINIMO

3/16" (5 MM) MINIMUM
MINIMUM DE 5 MM (3/16 PO)
4,7 MM (3/16") MINIMO



3/16" MINIMUM
MINIMUM DE 5 MM (3/16 PO)
4,7 MM (3/16") MINIMO

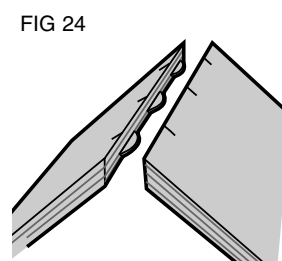
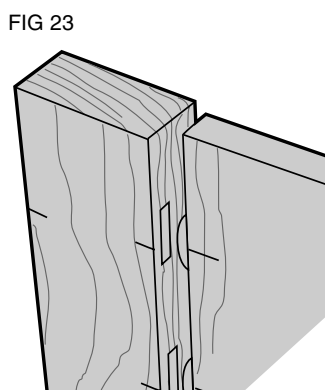
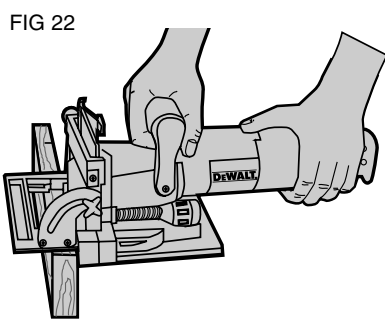
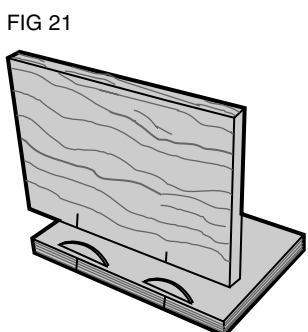
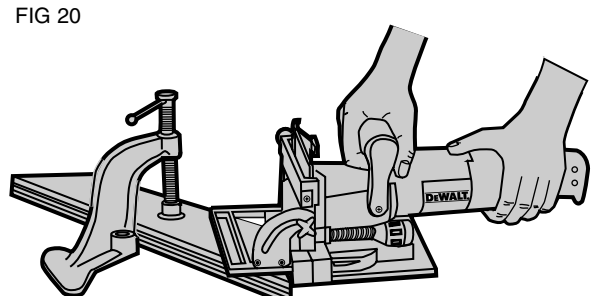
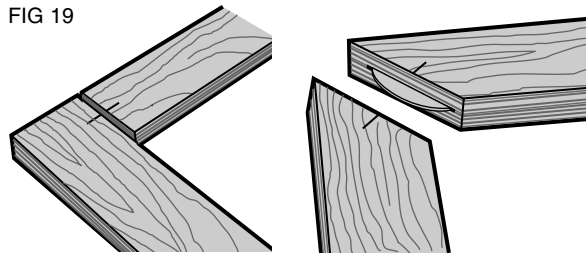
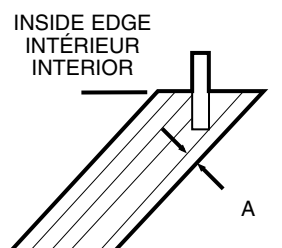


FIG 25 POSITION BISCUIT CLOSER
TO INSIDE EDGE TO INCREASE DIMEN-
SION "A"
PLACER LE BISCUIT VERS
L'INTÉRIEUR DE FAÇON À
AUGMENTER LA DIMENSION «A».
COLOQUE LA LENGÜETA CERCA AL
BORDE INTERIOR PARA AUMENTAR LA
DIMENSION "A"



5. EDGE MITER JOINTS (See Figure 24)

Edge miters are most commonly used in box structures or for making multisided pedestals where you would like to hide the end grain. Once again, biscuit joinery is an outstanding method to use both for added strength as well as ease of assembly. Follow the steps below to assemble a 90° joint.

- Position the workpieces as they are to be assembled and layout biscuit locations on the outside of the joint.
- Set up tool by first setting fence angle to 90°. Make the fence adjustment such that the biscuit is located toward the inside of the joint where the material is thicker, then select the biscuit size so that the blade does not protrude through the outside wall when the cut is made (see Figure 25).
- Clamp the workpiece and align the tool as shown in column in Figure 26.
- Turn on the tool and make the plunge cut.
- Glue, assemble and clamp the joint.
- For joints other than 90° see outside registration column Figure 27 for proper fence angle setting.

The above method will produce a joint where the outside surfaces of the joint are aligned. If you wish to produce a joint where the inside surfaces are aligned, use the following procedures for a 90° joint.

- Position workpieces as they are to be assembled.
- Layout biscuit locations on the inside of the angle.
- Set up tool by setting fence angle to 45°. Set vertical fence adjustment so that the biscuit is located toward the inside of the joint where material is thicker. Select biscuit size so that the blade does not protrude through the outside face of the material.
- Clamp the workpiece and align the tool as shown in Figure 28.
- Make the plunge cut and repeat for all biscuit locations.
- Glue, assemble and clamp the joint.
- For joints other than 90° see inside registration column in Figure 27 for proper fence angle setting.

6. T-JOINTS (Figure 29)

Biscuit joining is a viable alternative to dadoing when making a T-joint. T-joints are most commonly used when attaching shelves to the sides of a case. The method described below will work if your shelf material is at least 5/8" thick.

- Place the workpieces on a work surface exactly as you will be assembling them in the form of an upside down "T." Mark lightly along the joint where the top of the shelf is to end up (see Figure 30). Mark biscuit locations at the joint interface on the shelf piece only.
- Lay the shelf down on the mating workpiece. Clamp the two workpieces together and to the work surface in this position (see Figure 31).
- Set up the tool by selecting the proper biscuit size and setting the adjustable fence angle at 0°.
- Using the bottom registration surface, align the tool with the biscuit location marks and make a vertical and a horizontal plunge cut for each biscuit location as shown in Figure 32.
- Glue, assemble and clamp the joint.

Accessories

Recommended accessories for use with your tool are available at extra cost from your local dealer or authorized service center. If you need assistance in locating any accessory for your tool, please contact your local dealer or authorized service center.

CAUTION: The use of any other accessory not recommended for use with this tool could be hazardous.

Motor Brushes

DeWALT uses an advanced brush system which automatically stops the drill when the brushes wear out. This prevents serious damage to the motor.

Repairs

To assure product SAFETY and RELIABILITY, repairs, maintenance and adjustment (including brush inspection and replacement) should be performed by authorized service centers or other qualified service organizations, always using identical replacement parts.

Three Year Limited Warranty

DeWALT will repair, without charge, any defects due to faulty materials or workmanship for three years from the date of purchase. This warranty does not cover part failure due to normal wear or tool abuse. For further detail of warranty coverage and warranty repair information, visit www.dewalt.com or call 1-800-4-DEWALT (1-800-433-9258). This warranty does not apply to accessories or damage caused where repairs have been made or attempted by others. This warranty gives you specific legal rights and you may have other rights which vary in certain states or provinces.

In addition to the warranty, DeWALT tools are covered by our:

1 YEAR FREE SERVICE

DeWALT will maintain the tool and replace worn parts caused by normal use, for free, any time during the first year after purchase.

90 DAY MONEY BACK GUARANTEE

If you are not completely satisfied with the performance of your DeWALT Power Tool, Laser, or Nailer for any reason, you can return it within 90 days from the date of purchase with a receipt for a full refund – no questions asked.

RECONDITIONED PRODUCT: Reconditioned product is covered under the 1 Year Free Service Warranty. The 90 Day Money Back Guarantee and the Three Year Limited Warranty do not apply to reconditioned product.

FREE WARNING LABEL REPLACEMENT: If your warning labels (Fig. 33) become illegible or are missing, call 1-800-4-DEWALT for a free replacement.

FIG 26 REVERSE 45° BEVEL: ALLOWS OUTSIDE
REGISTRATION ON MITER JOINTS.
(NOTE: THE TOOL IS REGISTERED
AGAINST THE OUTSIDE SURFACE.)
BISEAU INVERSÉ DE 45° : SURFACE DE CONTACT
EXTÉRIÈRE SUR LES JOINTS EN BISEAU.
(NOTE : L'OUTIL REPOSE SUR LA SURFACE
EXTÉRIÈRE.)
BISEL INVERTIDO A 45° : PERMITE REGISTRO
EXTERIOR EN ENSAMBLES ANGULARES.
(NOTA: LA HERRAMIENTA SE REGISTRA CONTRA
LA SUPERFICIE EXTERNA.)

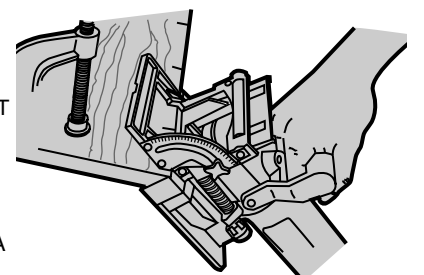
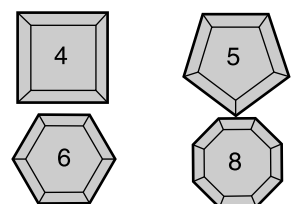
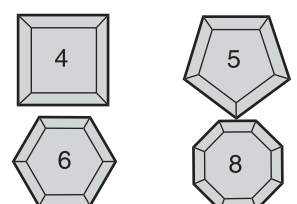


FIG 27

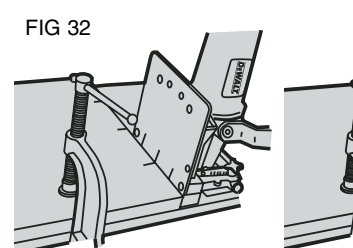
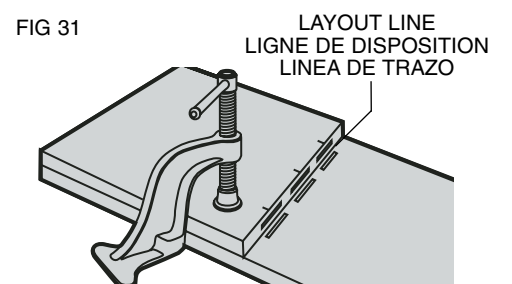
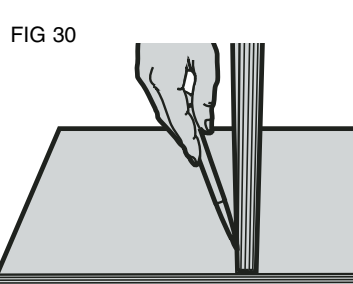
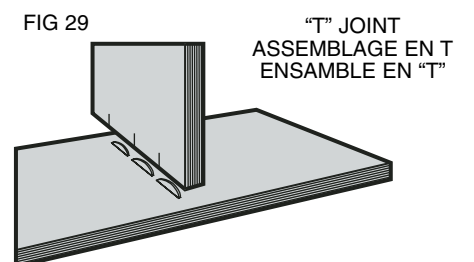
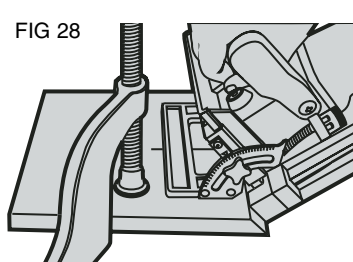
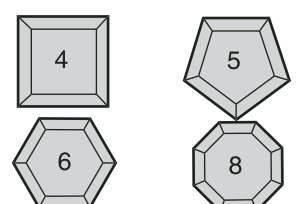
# OF SIDES	JOINT ANGLE	FENCE ANGLE SETTING	
		OUTSIDE REGISTRATION	INSIDE REGISTRATION
4	90°	90°	45°
5	108°	81°	54°
6	120°	75°	60°
8	135°	67.5°	67.5°



# DE CÔTÉS	ANGLE COMMUN	LE CADRE D'ANGLE DE CLÔTURE	
		POUR DE L'EXTÉRIEUR	POUR L'INTÉRIEUR
4	90°	90°	45°
5	108°	81°	54°
6	120°	75°	60°
8	135°	67.5°	67.5°



# DE LADOS	ÁNGULO CONJUNTO	CERQUE LA COLOCACIÓN DEL ÁNGULO	
		MATRIZ EXTERIOR	MATRIZ INTERIOR
4	90°	90°	45°
5	108°	81°	54°
6	120°	75°	60°
8	135°	67.5°	67.5°



DW682 PLATE JOINER
SER.

⚠ DANGER KEEP HANDS AWAY FROM BLADE.

⚠ WARNING AVERTISSEMENT

FOR SAFE OPERATION, READ INSTRUCTION MANUAL. ALWAYS USE PROPER EYE AND RESPIRATORY PROTECTION. CHECK GUARD OPERATION BEFORE USE. WHEN SERVICING, USE ONLY IDENTICAL REPLACEMENT PARTS. DOUBLE INSULATED. A TITLE PREVENTS. LIRE LE GUIDE. DEWALT INDUSTRIAL TOOL CO. BATHURGE, MD 20814 U.S.A. FOR SERVICE INFORMATION, CALL 1-800-4-DEWALT www.DEWALT.com

6. ENSAMBLES EN 'T' (figura 29)

Los ensambles de lengüeta son una alternativa viable para ranurar cuando se quiera hacer un ensamble en 'T'. Los ensambles en 'T' se utilizan comúnmente para añadir una repisa a los lados de un cajón. El método descrito a continuación funcionará si el material para su repisa tiene por lo menos 16 mm (5/8") de espesor.

- Coloque la piezas sobre una superficie exactamente en la manera en que las ensamblará en forma de una 'T' invertida. Marque ligeramente a lo largo de la unión en el lugar en que termina la repisa (observe la figura 30). Marque la localización de las lengüetas únicamente en la pieza que quedará como repisa.
- Coloque la repisa sobre la pieza con que se unirá. Prese las dos piezas juntas a la superficie de trabajo en la posición que se muestra en la figura 31.
- Ajuste la herramienta seleccionando el tamaño de lengüeta adecuado y ajustando el ángulo de la guía a 0°.
- Utilice la superficie de registro inferior, centre la herramienta a las marcas de localización de las ranuras y haga un corte vertical y horizontal para cada una, como se observa en la figura 32.
- Añada el pegamento, ensamble y prese la unión.

Accesorios

Dispone usted de los accesorios para su herramienta por un cargo adicional con su distribuidor local autorizado. Si necesita ayuda para encontrar cualquier accesorio, por favor comuníquese con el distribuidor o centro de servicio autorizado de su localidad.

⚠ **PRECAUCION:** El empleo de cualquier otro accesorio no recomendado para usarse con esta herramienta puede ser peligroso.

Carbones del motor

DeWALT utiliza un avanzado sistema de carbones que detienen automáticamente su ensambladora cuando se han desgastado. Esto le evita daños severos al motor.

Reparaciones

Para garantizar la SEGURIDAD y la CONFIABILIDAD, deberán hacerse reparaciones, mantenimiento y ajustes de esta herramienta en los centros autorizados de servicio DeWALT u otras organizaciones autorizadas. Estas organizaciones prestan servicio a las herramientas DeWALT y emplean siempre refacciones legítimas DeWALT.

Póliza de Garantía

IDENTIFICACIÓN DEL PRODUCTO:

Sello o firma del Distribuidor.

Nombre del producto: _____ Mod./Cat.: _____

Marca: _____ Núm. de serie: _____

(Datos para ser llenados por el distribuidor)

Fecha de compra y/o entrega del producto: _____

Nombre y domicilio del distribuidor donde se adquirió el producto:

Este producto está garantizado por un año a partir de la fecha de entrega, contra cualquier defecto en su funcionamiento, así como en materiales y mano de obra empleados para su fabricación. Nuestra garantía incluye la reparación o reposición del producto y/o componentes sin cargo alguno para el cliente, incluyendo mano de obra, así como los gastos de transportación razonablemente erogados derivados del cumplimiento de este certificado.

Para hacer efectiva esta garantía deberá presentar su herramienta y esta póliza sellada por el establecimiento comercial donde se adquirió el producto, de no contar con ésta, bastará la factura de compra.

EXCEPCIONES.

Esta garantía no será válida en los siguientes casos:

- Cuando el producto se hubiese utilizado en condiciones distintas a las normales;
- Cuando el producto no hubiese sido operado de acuerdo con el instructivo de uso que se acompaña;
- Cuando el producto hubiese sido alterado o reparado por personas distintas a las enlistadas al final de este certificado.

Anexo encontrará una relación de sucursales de servicio de fábrica, centros de servicio autorizados y franquiciados en la República Mexicana, donde podrá hacer efectiva su garantía y adquirir partes, refacciones y accesorios originales.

PARA REPARACIÓN Y SERVICIO DE SUS HERRAMIENTAS ELÉCTRICAS, FAVOR DE DIRIGIRSE AL CENTRO DE SERVICIO MÁS CERCANO

CULIACAN, SIN

Av. Nicolás Bravo #1063 Sur - Col. Industrial Bravo (667) 7 12 42 11

GUADALAJARA, JAL

Av. La Paz #1779 - Col. Americana Sector Juárez (33) 3825 6978

MEXICO, D.F.

Eje Central Lázaro Cárdenas No. 18
Local D, Col. Obrera (55) 5588 9377

MERIDA, YUC

Calle 63 #459-A - Col. Centro (999) 928 5038

MONTERREY, N.L.

Av. Francisco I. Madero No.831 - Col. Centro (81) 8375 2313

PUEBLA, PUE

17 Norte #205 - Col. Centro (222) 246 3714

QUERETARO, QRO

Av. Madero 139 Pte. - Col. Centro (442) 214 1660

SAN LUIS POTOSI, SLP

Av. Universidad 1525 - Col. San Luis (444) 814 2383

TORREON, COAH

Blvd. Independencia, 96 Pte. - Col. Centro (871) 716 5265

VERACRUZ, VER

Prolongación Díaz Mirón #4280 - Col. Remes (229) 921 7016

VILLAHERMOSA, TAB

Constitución 516-A - Col. Centro (993) 312 5111

PARA OTRAS LOCALIDADES LLAME AL: (55) 5326 7100

Garantía limitada por tres años

DeWALT reparará, sin cargo, cualquier falla que surja de defectos en el material o la fabricación del producto, por hasta tres años a contar de la fecha de compra. Esta garantía no cubre fallas de las piezas causadas por su desgaste normal o abuso a la herramienta. Para mayores detalles sobre la cobertura de la garantía e información acerca de reparaciones realizadas bajo garantía, visítenos en www.dewalt.com o diríjase al centro de servicio más cercano. Esta garantía no aplica a accesorios o a daños causados por reparaciones realizadas o intentadas por terceros. Esta garantía le otorga derechos legales específicos, además de los cuales puede tener otros dependiendo del estado o provincia en que se encuentre.

Además de la garantía, las herramientas DeWALT están cubiertas por:

1 AÑO DE SERVICIO GRATUITO

DeWALT mantendrá la herramienta y reemplazará las piezas gastadas por su uso normal, sin cobro, en cualquier momento durante un año a contar de la fecha de compra.

GARANTÍA DE REEMBOLSO DE SU DINERO POR 90 DÍAS

Si no está completamente satisfecho con el desempeño de su máquina herramienta, láser o clavadora DeWALT, cualquiera sea el motivo, podrá devolverlo hasta 90 días de la fecha de compra con su recibo y obtener el reembolso completo de su dinero – sin necesidad de responder a ninguna pregunta.

PRODUCTO REACONDICIONADO: Los productos reacondicionados están cubiertos bajo la Garantía de 1 Año de Servicio Gratuito. La Garantía de 90 Días de Reembolso de su Dinero y la Garantía Limitada de Tres Años no aplican a productos reacondicionados.

REEMPLAZO DE LAS ETIQUETAS DE ADVERTENCIA GRATUITO: Si sus etiquetas de advertencia (Fig. 33) se tornan ilegibles o se pierden, llame al 1-800-4-DeWALT para que se las reemplacen sin cost.

Especificaciones (DW682)

Tensión de alimentación	120 V CA/CD
Potencia nominal:	624 W
Frecuencia de operación:	60 Hz
Consumo de corriente:	6,5 A

IMPORTADO: DeWALT S.A. DE C.V.
BOSQUES DE CIDROS ACCESO RADIATAS NO. 42
COL. BOSQUES DE LAS LOMAS.
05120 MÉXICO, D.F.
TEL. 326-7100

Para servicio y ventas consulte
"HERRAMIENTAS ELÉCTRICAS"
en la sección amarilla.

