

INCH-POUND

OO-J-571F
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SUPERSEDING
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FEDERAL SPECIFICATION
JOINTERS, WOODWORKING

The General Services Administration has authorized the use of this federal specification by all federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers motor driven woodworking jointers for hand-feed jointing, rabbeting, and chamfering of wood workplaces.

1.2 Classification.

1.2.1 Types, classes, and sizes. The jointers shall be of the following types, classes, and sizes, as specified (see 6.2.1):

Type I - Bench, cabinet, floor stand or pedestal mounted.

Class A - Direct drive.

Size 8 - 8-inch cutting width
Size 12 - 12-inch cutting width

Class B - V-belt drive.

Size 4 - 4-inch cutting width
Size 6 - 6-inch cutting width
Size 8 - 8-inch cutting width
Size 12 - 12-inch cutting width

Type II - Floor mounted.

Class A - Direct drive.

Size 12 - 12-inch cutting width
Size 16 - 16-inch cutting width
Size 20 - 20-inch cutting width
Size 24 - 24-inch cutting width
Size 30 - 30-inch cutting width

Comments, suggestions, or questions on this document should be addressed to DLA Troop Support – Industrial Hardware Division (ATTN: Code FHTE), 700 Robbins Avenue, Philadelphia, PA 19111-5096 or email trpsptspecspa@dla.mil. Since contact information can change, you may want to verify the currency of this address information using the ASSIST Online database at <https://assist.dla.mil>.

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Class B - V-belt drive.

- Size 12 - 12-inch cutting width
- Size 16 - 16-inch cutting width
- Size 20 - 20-inch cutting width
- Size 24 - 24-inch cutting width
- Size 30 - 30-inch cutting width

2. APPLICABLE DOCUMENTS

2.1 Government publications . The following documents, of the issues in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

Federal Standards:

- FED-S TD-H28 - Screw Thread Standards for Federal Services.
- FED-STD-376 - Preferred Metric Units for General Use by the Federal Government .

(Activities outside the Federal Government may obtain copies of Federal specifications, standards, and commercial item descriptions as outlined under General Information in the Index of Federal Specifications, Standards and Commercial Item Descriptions. The Index, which includes cumulative bimonthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402

(Single copies of this specification, and other Federal specifications and commercial item descriptions required by activities outside the Federal Government for bidding purposes are available without charge from General Services Administration Business Service Centers in Boston, MA; New York, NY; Philadelphia, PA; Washington, DC; Atlanta, GA; Chicago, IL; Kansas City, MO; Fort Worth, TX; Houston, TX; Denver, CO; San Francisco, CA; Los Angeles, CA; and Seattle, WA.

(Federal Government activities may obtain copies of Federal standardization documents as the Index of Federal Specifications, Standards and Commercial Item Descriptions from established distribution points in their agencies.)

Military Standards:

- MIL-STD-461 - Electromagnetic Emission and Susceptibility Requirements for the Control of Electromagnetic Interference.

(Copies of these documents are available online at <http://quicksearch.dla.mil/> or from the Standardization Document Order Desk, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094.)

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Federal Regulation:

OSHA 2206 - General Industry , OSHA Safety and Health Standards (29 CFR 1910).

(The Code of Federal Regulations (CFR) and the Federal Register (FR) are for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402. When indicated, reprints of certain regulations may be obtained from the Federal agency responsible for issuance thereof.)

2.2 Other publications . The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposals shall apply.

American National Standards Institute (ANSI) Standards:

ANSI 01.1 - Safety Requirements for Woodworking Machinery.
ANSI/NEMA MG- 1 - Motors and Generators .
ANSI/NEMA ICS-1 - Industrial Control and Systems .
ANSI/NFPA 79 - Electrical Standard for Industrial Machinery.

(Copies of these documents are available from the American National Standards Institute, ATTN: Sales Dept., 25 West 43rd Street, 4th Floor, New York, NY 10036 or <http://www.ansi.org> .)

ASTM International Standards:

ASTM D 3951 - Commercial Packaging, Standard Pratt ice for.

(Copies of these documents are available from <http://www.astm.org> or ASTM International, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein (except for associated detail specifications, specification sheets or MS standards), the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified in the contract or purchase order (see 6.2.1), a sample shall be subjected to first article inspection (see 4.4 and 6.3).

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3.2 Design. The jointer shall be new and one of the manufacturer's current models capable of operations in accordance with the requirements herein. The jointer shall include all components, parts, and features necessary to meet the performance requirements specified herein. All parts subject to wear, breakage, or distortion shall be accessible for adjustment, replacement, and repair.

3.2.1 Measurement systems. Unless otherwise specified, either the U.S. Customary System of Units (US) or the International System of Units (S1) shall be used in the design and construction of the jointer. When only one system of measurement is acceptable, the particular system required shall be as specified (see 6.2.1). In this specification, all measurements, dimensions, sizes, and capacities are given in US units. These measurements may be converted to S1 units through the use of the conversion factors and methods specified in FED-STD-376.

3.2.2 Energy efficiency. The jointer and its applicable components that directly consume energy in normal operation shall be designed and constructed for the energy efficiency as governed by the latest developments available within the industry.

3.2.3 Controls. All operating controls shall be located convenient to the operator at-real work station.

3.2.4 Safety and health requirements. Covers, guards, or other safety devices shall be provided for all parts of the jointer that present safety hazards. The safety devices shall not interfere with the operation of the jointer. The safety devices shall prevent unintentional contact with the guarded part, and shall be removable to facilitate inspection, maintenance, and repair of the parts. The jointer shall comply with ANSI Standard 01.1. All jointer parts, components, mechanisms, and assemblies furnished on the jointer, whether or not specifically required herein, shall comply with all of the requirements of OSHA 2206 that are applicable to the jointer itself. Additional safety and health requirements shall be as specified (see 6.2.1 and 6.4).

3.2.5 Asbestos restriction. Asbestos and materials containing asbestos shall not be used on or in the jointer.

3.2.6 Environmental protection. The jointer shall be so designed and constructed that, under the operating, service, transportation, and storage conditions described herein, the jointer shall not emit materials hazardous to the ecological system as prescribed by Federal, state, or local statutes in effect at the point of installation (see 6.4).

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3.2.7 Lubrication. Means shall be provided to ensure adequate lubrication for all moving parts. Recirculating lubrication systems shall include a filter which is cleanable or replaceable. Each lubrication reservoir shall have means for determining fluid level. All oil holes, grease fittings, and filler caps shall be accessible.

3.2.8 Interchangeability. To provide for replacement of worn parts, all parts shall be manufactured to definite dimensions and tolerances.

3.3 Construction. The jointer shall be constructed of parts which are new, without defects, and free of repairs. The structure shall be capable of withstanding all forces encountered during operation of the jointer to its maximum rating and capacity without permanent distortion.

3.3.1 Castings and forgings. All castings and forgings shall be free of scale and mismatching. No processes such as welding, peening, plugging, or filling with solder or paste shall be used for reclaiming any defective part.

3.3.2 Fastening devices. All screws, pins, bolts, and other fasteners shall be installed in a manner to prevent change of tightness. Fastening devices subject to removal or adjustment shall not be swaged, peened, staked, or otherwise permanently installed.

3.3.3 Surfaces. All surfaces shall be clean and free of sand, dirt, fins, sprues, flash, scale, flux, and other harmful or extraneous materials. All edges shall be either rounded or beveled unless sharpness is required to perform a necessary function. Except as otherwise specified herein, the condition and finish of all surfaces shall be in accordance with the manufacturer's commercial practice.

3.3.4 Painting. Unless otherwise specified (see 6.2. 1), the jointer shall be painted in accordance with the manufacturer's commercial practice.

3.3.5 Threads. All threaded parts used on the jointer and ice related attachments and accessories shall conform to FED-STD-H28 and the applicable "Detailed Standard" section referenced therein.

3.3.6 Gears. All gears shall be constructed of a material suitable for the intended purpose. All gears shall be machined and heat treated by a process that will impart the hardness, surface finish, and toughness that will enable the gear train to transmit full rated torque to the drive motor without gear damage, failure, or premature deterioration and wear.

3.3.7 Electromagnetic interference control. When specified (see 6.2.1), equipment furnished under this specification shall comply with MIL-STD-461. The equipment and subsystems class and the emission and susceptibility requirements shall be as specified.

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3.4 Components. Jointers covered herein shall consist essentially of a frame, front table, rear table, knife cylinder assembly, drive system, and such other components necessary to meet the requirements stated herein.

3.4.1 Frame. The frame shall be of such mass and shall have sufficient strength and rigidity to support the working parts of the jointer. The frame shall support and maintain alignment of the cylinder assembly and both tables to meet the performance requirements specified herein. The frame shall be constructed to provide both vertical and horizontal table adjustments.

3.4.2 Dust and chip collector. A compartment or other suitable means shall be provided for collection of dust and chips in the area of the knife cylinder assembly. Means shall be provided for connection to an exhaust system.

3.4.3 Floor stand, cabinet or pedestal. When specified (see 6.2.1), the frame of type I jointers shall be mounted on either a floor stand, a cabinet, or a pedestal as specified. The mount shall be rigidly constructed with provisions for securing to the floor or foundation.

3.4.4 Knife cylinder assembly. The knife cylinder assembly shall be supported by ball or roller bearings of a size, type, and class suitable for the application. Type I jointers shall have knife cylinders accommodating not less than three replaceable knives. Type II jointers shall have knife cylinders accommodating not less than four replaceable knives. The knives shall be of the straight type extending across the entire length of the cylinder. The knife cylinder and the replaceable knives shall have means for precisely locating and securely holding all knives to expose uniform cutting edges. Unless otherwise specified (see 6.2.1), the knives shall be manufactured from tool steel. When specified (see 6.2.1), the knife cylinder assembly shall be constructed to accommodate either spiral-type carbide blades extending around and across the entire cylinder length or multiple cutterheads (knife holders) that utilize replaceable and indexable carbide cutting tools not wider than 1 inch. The multiple cutterheads and knives, when required, shall be located in overlapping positions in a helical pattern around the cylinder assuring a uniform cut over the entire cylinder length. The replaceable knives in the multiple cutterheads shall have not less than four sides and, when dulled, can be repositioned or indexed to expose new cutting edges.

3.4.5 Knife cylinder drive mechanism. On class A jointers, the knife cylinder shall either be mounted directly on the motor shaft or shall be mounted on a shaft that is directly driven by the motor shaft. Class B jointers shall be driven by a V-belt mechanism capable of transmitting full-motor torque without slippage. Means shall be provided for adjusting belt tension. Unless otherwise specified (see 6.2.1), the drive mechanism shall drive the cylinder at the speed shown in table I.

3.4.6 Cylinder brake. Type II jointers shall have a manually actuated brake that stops rotation of the cylinder within a time period of 5 seconds. When specified (see 6.2.1), type II jointers shall have a brake which is automatically applied when the motor is de-energized. The automatically applied brake, when required, shall also be capable of stopping rotation of the cylinder within a time period of 5 seconds.

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3.4.7 Cylinder guards. The jointer shall have a guard that covers the cylinder on the working side of the fence and prevents the operator's hands from contacting the knives. The guard shall automatically adjust itself to cover the unused portion of the cylinder and shall remain in contact with the workpiece at all times. The jointer shall also have a guard that covers the section of the cylinder on the nonworking side of the fence. The guard shall cover the entire nonworking side of the cylinder, with the fence adjusted to any position within its range of adjustment.

3.4.8 Tables. The jointer shall have a front table that supports the workpiece before it enters the knife cylinder and a rear table that supports the workpiece as it leaves the cylinder. The front table shall be adjustable vertically to adjust the depth of cut, and the rear table shall be adjustable vertically so that it can be aligned with the height of the knives in the cylinder. Both tables shall be horizontally adjustable, a direction toward and away from the cylinder axis, to provide proper clearance to the knives, and to allow access to the knife cylinder for maintenance of the knife blades. When specified (see 6.2.1) the rear table of all jointers, except type I, class B, sizes 4 and 6, shall have provisions for accommodating the knife jointing and grinding attachment required in 3.4.10.

3.4.9 Fence. The jointer shall have a fence that guides the edge of the workpiece as it is hand-fed toward the cylinder. The fence dimensions shall conform to the requirements of table I. The fence shall be supported on either table, and shall extend past the cylinder and onto the other table. The fence support shall allow the fence position to be adjusted across the entire width of the tables. The fence support shall also allow the fence to be tilted from the 90° normal position to 45° to the right. Means shall be provided for securely locking the fence in any position across the width of the tables, and for locking the fence in any tilt position within the stated tilt range. The fence tilting mechanism shall have a scale graduated in increments not larger than 5° that indicates the angle to which the fence is tilted. The graduation shall have an accuracy within plus or minus 1°.

3.4.10 Grinding and jointing attachment. When specified (see 6.2.1), a knife blade grinding and jointing attachment shall be provided with each jointer except type I, class B, sizes 4 and 6. The attachment shall be easily attached to, and removed from, the rear table of the jointer. The attachment shall consist essentially of a head designed to accommodate both an electric motor driven grinding wheel and jointing stone, and a mechanism that allows the grinding wheel or jointing stone to be manually traversed across the entire length of the cylinder knives. The attachment shall also have means for precisely adjusting the wheel or stone in proper relationship to the knives, and a means for retaining the wheel or stone adjustment during the grinding or jointing operation.

3.4.11 Rabbeting attachment. All jointers having straight knife blades extending across the entire cylinder width shall have provisions for producing rabbet joints having a depth conforming to the requirements of table I. The rabbet joints may be produced either by features incorporated into the design of the basic machine structure, or by utilizing separate attachments that can be readily installed onto the basic machine structure.

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3.4.12 Electrical system. Unless otherwise specified (see 6.2.1), the electrical system shall conform to ANSI/NFPA 79. Each jointer shall draw all of its electrical power for a single 230/460-volt, 3-phase, 60-hertz (hz) circuit. Each jointer shall have a fused safety disconnect switch or circuit breaker. The jointer shall be initially wired for operation on 460 volts. An identified terminal for grounding the jointer when it is installed shall be mounted in or near the disconnect switch. The terminal shall be suitable for connecting the size grounding conductor specified in ANSI/NFPA 79 for the disconnect fuse rating.

3.4.12.1 Motors. Unless otherwise specified (see 6.2. 1), motors shall have ball or roller bearings, be totally enclosed, fan cooled, and conform to ANSI/NEMA MG-1.

3.4.12.2 Motor controls. The jointer shall be completely wired through the controls and ready for connection to the applicable power source. The control shall conform to ANSI/NEMA ICS-1 and shall have a type 1 enclosure with a magnetic starter and overload and undervoltage protection.

3.4.12.3 Solid-state components. Solid-state design shall be used throughout for electronic components.

3.5 Size and capacity. Unless otherwise specified (see 6.2.1), the size and capacities of the jointer shall be not less than the requirement specified in table I.

3.6 Performance requirements.

3.6.1 Material removal rate and accuracy. The jointer shall be capable of producing a flat, smooth surface on wood workpieces having a surface width equalling the knife cylinder assembly length. The jointer shall be capable of removing material from a wood workpiece being hand-fed at a safe even hand-feed rate, averaging 1 to 1-1/2 inches per second with a cutting depth of 1/16 inch at capacity width. The jointer shall be capable of producing joints within the cylinder length and of a depth conforming to the requirements of table I. The jointer shall be capable of producing square edge joints and angular edge joints through 45°. The jointer shall be capable of producing angular joints having an angular accuracy of plus or minus 1°, and flat jointed surfaces which will prevent the passage of light between contact surfaces.

3.7 Standard equipment. Unless otherwise specified (see 6.2.1), the following equipment shall be furnished with each jointer:

- (a) One set of hand tools normally furnished by the manufacturer.
- (b) One extra set of cylinder knives.

3.8 Marking on plates and charts. All words on plates and charts shall be in the English language. Characters shall be engraved, etched, embossed, or stamped in boldface on a contrasting background.

TABLE I. Sizes and capacities.

Characteristics	Type I						Type II									
	Class A			Class B			Class A					Class B				
	Size 8	Size 12	Size 4	Size 6	Size 8	Size 12	Size 12	Size 16	Size 20	Size 24	Size 30	Size 12	Size 16	Size 20	Size 24	Size 30
Cylinder																
Length, inches	8	12	4	6	8	12	12	16	20	24	30	12	16	20	24	30
Cutting circle diameter, inches	3	4	2	2-1/2	3	4	4	4	4	4	5	4	4	4	4	5
Speed, rpm, minimum	3600	3600	4200	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600
Rabbeting depth, inches	1/2	1/2	1/4	1/2	1/2	1/2	1/2	1/2	3/4	1/2	1/2	1/2	1/2	3/4	1/2	1/2
Length of worktables, combined, inches, minimum	60	70	27	42	60	74	96	96	96	96	96	96	96	96	96	96
Fence dimensions, inches	3x30	3x40	3x21	4x30	4x34	5x39	5x39	5x39	6x53	6x53	6x53	5x39	5x39	5x52	5x52	6c53
Motor horsepower																
Standard	1	3	1/3	1/2	1	3	3	5	5	5	7-1/2	3	5	5	5	7-1/2
optional	2	5	1/2	3/4, 1	1, 1/2	5	5, 7-1/2, 10	7-1/2, 10	7-1/2, 10	7-1/2, 10	10	5, 7-1/2, 10	7-1/2, 10	7-1/2, 10	7-1/2, 10	7-1/2, 10

Note: Jointers sizes and capacities shall be not less than the stated requirements of the size ordered nor greater than the requirements of the next larger size as shown in above table. When the largest size and capacity jointer shown in the above table is ordered, the size and capacity jointer offered shall not exceed the stated requirements by more than 10 percent. When a range is shown, the required performance is from the stated minimum or less to the stated maximum or greater.

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3.9 Nameplate. Unless otherwise specified (see 6.2. 1), a nameplate shall be securely attached to each jointer and contain the information listed below. If the jointer is a special model, the model designation shall include the model of the basic standard jointer and a suffix identified in the manufacturer's permanent records. The captions listed may be shortened or abbreviated, provided the entry for each caption is clear as to its identity.

- Nomenclature
- Manufacturer' s name
- Manufacturer' s model designation
- Manufacturer's serial number
- Power input (volts, total amps, phase, frequency)
- Contract Number or Order Number
- National Stock Number or Plant Equipment Code
- Date of manufacture

3.10 Technical data. When technical data (operating manuals, maintenance manuals , parts catalogs, prints, wiring diagrams, lubrication charts , and machine alignment and accuracy test results) is required, it shall be furnished in accordance with the requirements of DD Form 1423. All technical data furnished shall be written in the English language.

3.11 Workmanship. Workmanship of the jointer and accessories shall be of a quality equal to that of the manufacturer's commercial equipment of the type specified herein.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspections set forth in this specification shall become a part of the contractor' e overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4) .

4.3 First article inspection. When a first article inspection is required, it shall be applied to the first article submitted in accordance with 3.1. Unless otherwise specified (see 6.2.1), first article inspection shall consist of the examination in 4.5 and all tests in 4.6. Failure of the item to pass the first article examination or all tests shall be cause for rejection.

4.4 Quality conformance inspection. Quality conformance inspection shall be applied to each item prior to being offered for acceptance under the contract. Unless otherwise specified (see 6.2.1), quality conformance inspection shall consist of the examination in 4.5, the tests in 4.6, and the inspection in 4.7. Failure of the item to pass the examination, the tests, or the inspection shall be cause for rejection.

4.5 Examination. The jointer shall be visually examined to determine compliance with all requirements of this specification.

4.6 Tests.

4.6.1 Operational test. The jointer shall be operated at no load for not less than 30 minutes. Proper operation of all controls, motors, adjusting mechanisms, and accessories shall be verified during the trial period.

4.6.2 Performance tests. The jointer shall be subjected to the following tests. Failure to meet the requirements shall be cause for rejection.

4.6.3 Test workpiece. The type of hardwood used as a test workpiece shall be at the option of the supplier. The test workpiece dimensions shall be not less than 1 - inch thick, 30 inches in length, and of a width equal to the length of the knife cylinder assembly.

4.6.4 Surface jointer test. The test workpiece described in 4.6.3 shall be hand-fed using the entire knife cylinder length to produce a finished flat surface. A hand-fed rate averaging 1 to 1-1/2 inches per second, cutting to a depth of not less than one-sixteenth of an inch, shall be used for performing this test. Multiple passes may be made to produce the jointed surface.

4.6.5 Edge jointer test. Using the fence angle graduations, the fence shall be set at a 90° angle to the table top surface. Using the test workpiece used in 4.6.4, edge joints shall be produced on both edges, over the entire length of the workpiece. Each edge joint shall be produced in a single pass of the test workpiece. The jointed surfaces shall have an angle of 90° plus or minus 1° to the surface held against the fence.

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4.6.6 Flatness examination. The test workpiece produced in 4.6.5 shall be cut into two workpieces of equal length. By placing the edge joints, produced in 4.6.5 together, their surface fit shall be such that no light passage is visible. By positioning an edge joint produced in 4.6.5 lengthwise upon a surface joint produced in 4.6.5 lengthwise upon a surface joint produced in 4.6.4, their surface fit shall be such that no light passage is visible.

4.6.7 Bevel accuracy test. One edge of each workpiece produced in 4.6.6 shall be beveled with the fence adjusted to a 45° angle. The two beveled edges shall be placed together so that the test workpieces form a right angle. The included angle shall be 90° plus or minus 1°.

4.6.8 Rabbet accuracy test. Jointer having provisions for rabbeting shall perform the following test. The opposite edge of each test workpiece beveled in 4.6.7 shall be rabbeted 1/2-inch deep and 1/2-inch wide. The two rabbeted edges shall be placed together to form a right angle. The included angle shall be 90° plus or minus 1°.

4.6.9 Electromagnetic interference control tests. Equipment requiring electromagnetic interference control shall be tested for compliance with 3.3.7.

4.7 Packaging inspection. Packaging of each item shall be inspected to determine compliance with the requirements of section 5.

5. PACKAGING

5.1 Preservation, packing, and marking. Unless otherwise specified, preservation, packing, and marking shall be in accordance with ASTM D 3951.

6. NOTES

6.1 Intended use. Jointers covered by this specification are intended for hand-fed jointing, rabbeting, and chamfering in woodworking shops.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the Following:

- a. Title, number, and date of this specification.
- b. Type, class, and size required (see 1.2).
- c. First article, if required (see 3.1).
- d. If jointer is required to be configured in a specific measurement system (US or S1), state required system (see 3.2. 1).

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- e. Additional safety and health requirements, if required (see 3.2.4).
- f. Painting, if different (see 3.3.4).
- g. If electromagnetic interference control is required, specify the equipment and subsystem class and the emission (see 3.3. 7).
- h. Floor stand, cabinet or pedestal, if required (see 3.4.3).
- i. Type of knife blade material required, if different (see 3.4.4).
- j. Specify either spiral type knives or indexable helically patterned cutter heads and knives, if required (see 3.4.4 and 6.5).
- k. Cylinder speed, specify RPM, if different (see 3.4.5).
- l. Automatic brake for type II jointers, if required (see 3.4.6).
- m. Provisions for knife jointing and grinding attachment if required (see 3.4.8).
- n. Knife grinding and jointing attachment, when required (see 3.4.10).
- o. Electrical system and input power, if different (see 3.4.12).
- p. Motor enclosure, if different (see 3.4.12.1).
- q. Size and capacities, if different (see 3.5).
- r. Standard equipment, if different (see 3.7).
- s. Nameplate, if different (see 3.9).
- t. First article inspection, if different (see 4.3).
- u. Quality conformance inspection, if different (see 4.4).

6.2.2 Contract data requirements. Required technical data (operating manuals, parts lists, wiring diagrams, foundation and anchor bolt plans , and acceptance test reports) should be specified on DD Form 1423, Contract Data Requirements Lists, incorporated into the contract.

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6.3 First article. When first article inspection is required, the item to be tested should be the first item offered for acceptance under the contract. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, test, and approval of the first article.

6.4 Safety and health requirements. Paragraph 3.2.4 requires compliance only with those OSHA requirements that concern the jointer itself. It does not require compliance with those OSHA requirements that concern "the jointer in its operating environment" such as noise levels, radiation levels, electromagnetic emissions, noxious vapors, air contaminants, and heat. Since OSHA limits the total hazard level of these hazards in the environment (and does not limit the hazard level of individual jointer in the environment), the procuring activity is advised to analyze the existing hazard levels in the proposed operating environment, and specify additional requirement that will integrate the new jointer into its future operating environment. The jointer shall be equipped with all point-of-operation guarding normally furnished as standard on the manufacturer's commercial machine supplied to the commercial market. If specific point-of-operation guarding is required, the procuring activity should specify the exact configuration of the guard required, since the guard configuration is dependent on the size and configuration of the workpieces. The above and any other additional safety and health requirements should be specified in detail under 6.2. I(e).

6.5 Special knife blades and knife cylinder assemblies. Due to the relatively high cost of carbide, spiral, and helical knives and cylinders (see 3.4, 6.2.1[i], and 6.2.1[j]), procuring agencies are cautioned to carefully evaluate their requirements for these special cutters. The items should be required only for heavy duty use where the higher initial cost can be amortized by extended cutter life. In addition, requiring this special equipment might eliminate the commercial equipment of some potential supplies.

6.6 Subject term (key word) listing:

- Hand-feed
- Jointing
- Rabbeting
- Chamfering
- Direct drive
- V-belt drive
- Bench mount
- Floor mount

6.7 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

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Army – CR4
Navy - SH
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Preparing Activity:

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NOTE: The activities listed above were interested in this document as of the date of document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.dla.mil>.