

# Operations & Parts Manual



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## JB21P

### LINE BORING MACHINE

Please ensure you have your serial number available when contacting us for parts or service.

Cantek America Inc. | 1.888.982.2683 | **Parts:** [sales@cantekamerica.com](mailto:sales@cantekamerica.com) | **Service:** [service@cantekamerica.com](mailto:service@cantekamerica.com)

# WARRANTY

If any part is proved to be defective within ONE YEAR from the date of purchase then the manufacturer or distributor shall repair or replace the part provided and the defective part is returned immediately to the manufacturer or distributor. The manufacturer or distributor shall have no obligation to repair or replace those parts failing due to operator carelessness, misuse or any cause such as parts failing due to poor lubrication, inadequate cleaning, improper operation environment, improper utilities or operational error.

# ADDITIONAL SAFETY RULES

- 1) Always wear eye protection when operating any machine.
- 2) Before starting up, recheck to make certain all holding screws are tight.
- 3) Always stop motor and disconnect the power source, before making adjustments of any kind.
- 4) Be sure all guards are in place before operating equipment. The hood should always be DOWN, covering cutter-head when motor is on. Never attempt to override the interlocking hood switch.
- 5) Read the operators manual thoroughly and familiarize yourself with the machine before attempting to operate.
- 6) Keep children away – All visitors should keep a safe distance.
- 7) Don't force-feed boring head. Allow the boring machine to apply the proper feed rate.
- 8) Use sound lumber. No loose knots, and as few tight knots as possible.

# SAFETY INSTURCTIONS

- 1. ALWAYS KEEP THE GUARDS IN PLACE, and in working order.**
- 2. REMOVE ADJUSTING KEYS AND WRENCHES.** From the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- 3. KEEP THE WORKING AREA CLEAN.** Cluttered areas and benches invite accidents.
- 4. DON'T USE IN A DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep the work area well lit.
- 5. MAKE THE WORKSHOP KID-PROOF** with padlocks, master switches, or by removing starter keys.
- 6. DON'T FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
- 7. USE THE RIGHT TOOL.** Don't force the tool or attachment to do a job for which it was not designed.
- 8. WEAR PROPER APPAREL.** Don't wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 9. ALWAYS USE SAFETY GLASSES.** Also use a face or dust mask if the operation is dusty. Everyday glasses only have impact-resistant lenses. They are not safety glasses.
- 10. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate the tool.
- 11. DON'T OVER-REACH.** Keep proper footing and balance at all times.
- 12. MAINTAIN TOOLS WITHCARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 13. DISCONNECT POWER FROM TOOLS** before servicing. When changing accessories, such as blades, bits, cutters, etc.
- 14. REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the off position before you plug it in.
- 15. USE RECOMMENDED ACCESSORIES.** Consult the equipment manufacturer's manual for recommended accessories. The use of improper accessories may cause injury.
- 16. NEVER STAND ON THE TOOL.** Serious injury could occur if the tool is tipped, or if the cutting tool is unintentionally contacted.
- 17. CHECK DAMAGED PARTS.** Before further use of the tool, damaged parts should be carefully checked to determine that they will operate properly and perform their intended function. Check for alignment, binding or breakage of moving parts, or any other conditions which may effect operations.
- 18. DIRECTION OF FEED.** Only feed work into a blade or cutter against the blade's rotation direction.
- 19. NEVER LEAVE THE TOOL UNATTENDED WHILE IT'S RUNNING.** Don't leave the tool until it comes to a complete stop.
- 20. KNOW YOUR POWER TOOL.** Read both the assembly and operation manual, and get acquainted with maintenance and lubrication procedures. Never use accessories or attachments not recommended by the manufacturer, as it may result in injury. Learn application and limitations, as well as specific potential hazards peculiar to this tool.

# UNPACKING AND CLEANING

Remove the machine from the wood box and ensure that all parts are present and free from damage. If any parts are missing or damaged, contact your local distributor immediately. Do not attempt to assemble or operate the machine without all parts present and in working order.

Remove the rust preventative oil that coats the machine with a cloth soaked in kerosene. Do not use gasoline or lacquer thinner as this can damage the painted parts of the machine.

# BOX INVENTORY



1) Open End Wrench 8x10



2) Open End Wrench 11x13



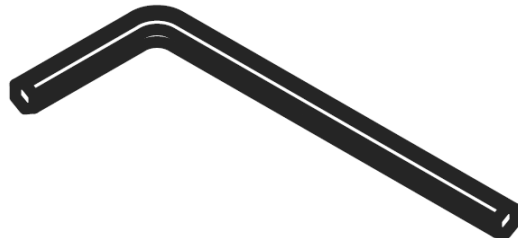
3) Open End Wrench 17x19



4) Hex Wrench Set (1.5 to 6mm)



5) Set Screw M5 x 5



6) Hex Wrench Set (2.5mm)



6) Adjustable Extension Fence

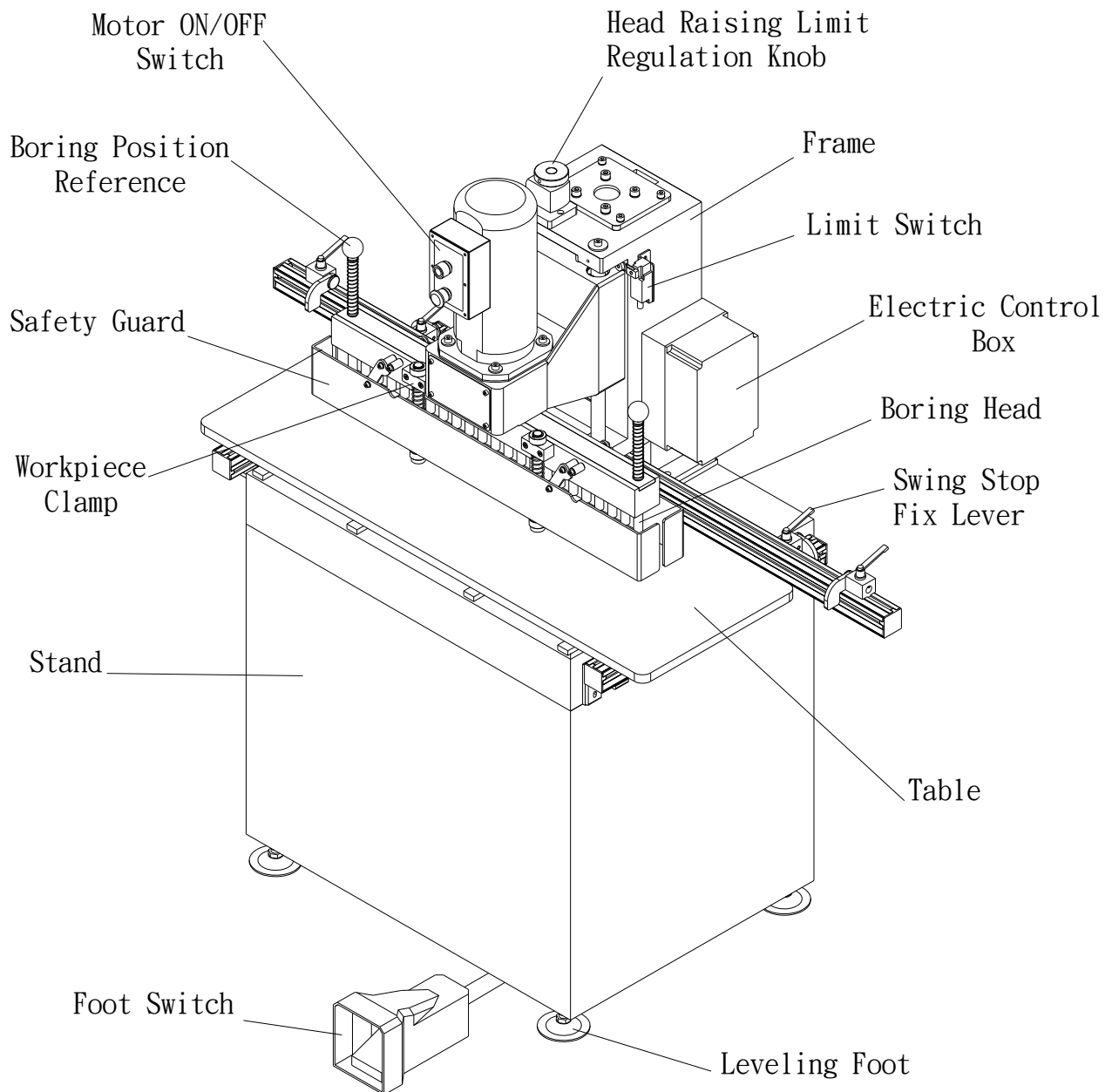


# Specifications

MODEL	<b>CANJB2IP</b>
Operation	Pneumatic
No. of Spindle Drill Head	21 Pcs (Left10+ Right11)
Distance Between Spindle Centers	32 mm
Thred	φ10 mm
Amps / Cycle / RPM	20.8 / 10.4 A / 60Hz / 3400 RPM
Motor	1 HP, Single Phase, 115V / 230V
Table Area	1100mm(L) x 400mm(W) ( 43-5/16" x 15-3/4" )
Table Height from Floor	847 mm (33-1/16")
Max. Boring Depth From Edge	205mm(8inch)
Max. Depth of Stroke	85mm ( 3" )
Max. Distance from Boring Bit to Longitudinal Fence	8" (205 mm)
Back Fence	74 3/4" (1,900 mm)
Back Fence Stops	2 pcs
Cross Fence Stops	2 pcs
Air Requirement	5kg / cm2 (70PSI)
Overall dimensions(D x W x H)	1900*780*1480mm (75inch x 30-3 / 4inch x 58-1 / 4inch)
N.W./G.W.	175 / 250kgs ( 385 / 550 lbs)
Packing Dimensions	1080*865*1750mm

All specifications, dimensions and design characteristics are subject to change without prior notice.



# MACHINE OUTLOOK







# UNPACKING AND INSTALLING MACHINE

1. Apply wrench to loosen the screws that tighten the machine bottom to the pallet. Do not lift the machine from the table.

	<div data-bbox="699 533 1380 656"> <b>WARNING</b></div> <div data-bbox="699 678 1380 965"><ol style="list-style-type: none"><li>1. This machine is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine-get help.</li><li>2. DO NOT lift the machine from the table.</li></ol></div>
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2. Once the machine is placed on the work site, it is necessary to make machine leveling adjustment. Wrench to turn the leveling adjustment screws until a proper leveling is obtained. Then, tighten the nuts securely.

	<div data-bbox="810 1417 1177 1485"> <b>WARNING</b></div> <div data-bbox="675 1529 1265 1821"><p>Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes insure compliance by checking with a qualified electrician!!</p></div>
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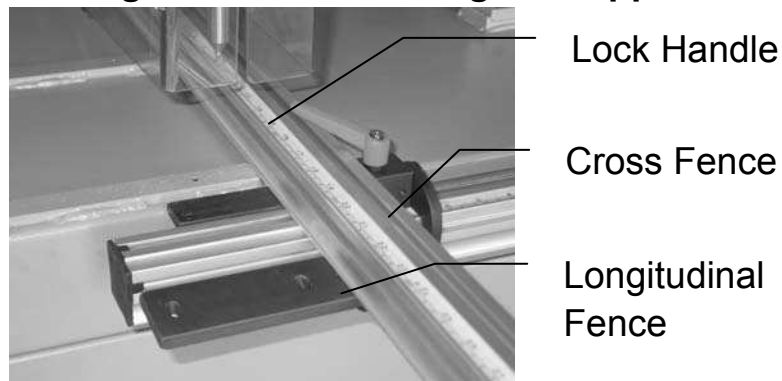
# UNPACKING AND INSTALLING MACHINE

## 1. MOUNTING TABLE

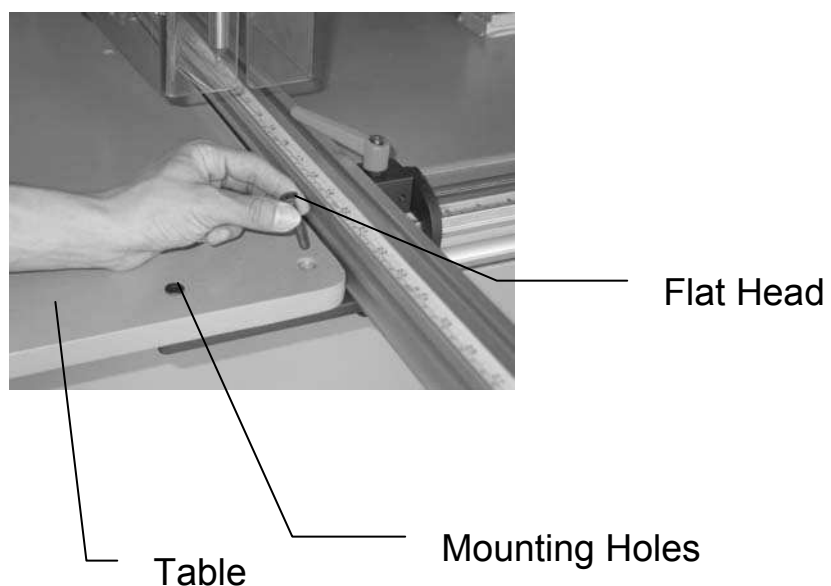
The table and the longitudinal fence have been dismantled from the machine for reducing packing volume.

When installing the machine, you need to mount the table and the longitudinal fence according to following procedures.

Fit the longitudinal fence on the position as picture shown. Align the matching piece under the longitudinal fence with the nut in the slot of cross fence. Tighten the longitudinal fence using the supplied lock handle.

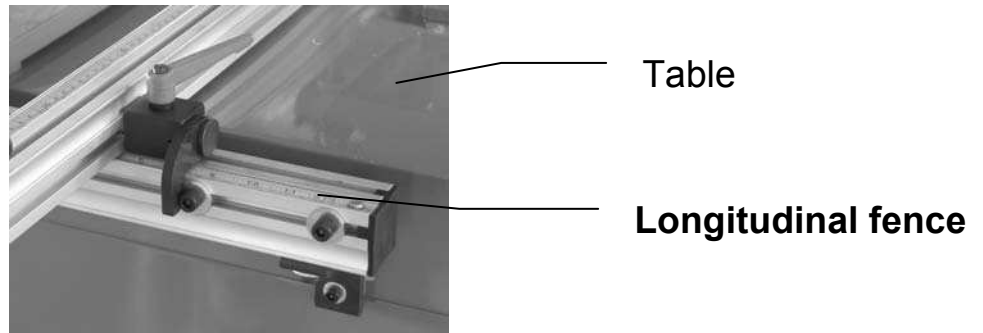


2. Place the table on the machine stand. Align four holes on the table with the four holes on the machine stand. Tighten the table securely by using 4 flat head screws with washers.



# UNPACKING AND INSTALLING MACHINE

The picture shows will be assembled table and longitudinal fence.



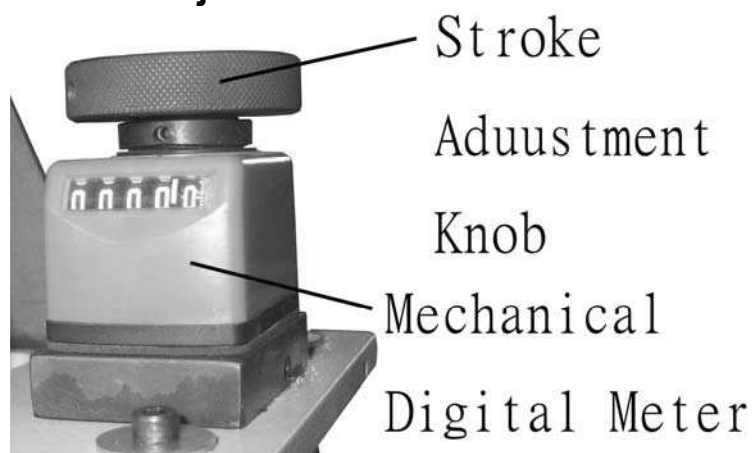
## SETTING UP THE MACHINE

### 1. ADJUSTING DOWNFEED STROKE:

The down-feed stroke of boring unit is adjusted by turning the stroke adjustment knob, located on top of the machine column.

Stroke adjustment amount is accurately read on the mechanical digital meter.

A stroke indication scale, attached on the left side of the machine column, is used for reference for adjustment amount.



# SETTING UP THE MACHINE

## 1. UPPER AND LOWER LIMIT SCREW:

open end wrench to loosen the nut. Adjust depth by turning the handwheel. Once position is properly adjusted, tighten fix nut securely.

## 2. MOTOR ON/OFF SWITCH:

When the ON button is pressed, the boring head does not rotate until the head is released from limit switch. When the green lamp lights on, it means the motor starts running. Press Off emergency stop button for turning off boring motor and the ON (green) lamp does light on. The OFF button.



# SETTING UP THE MACHINE

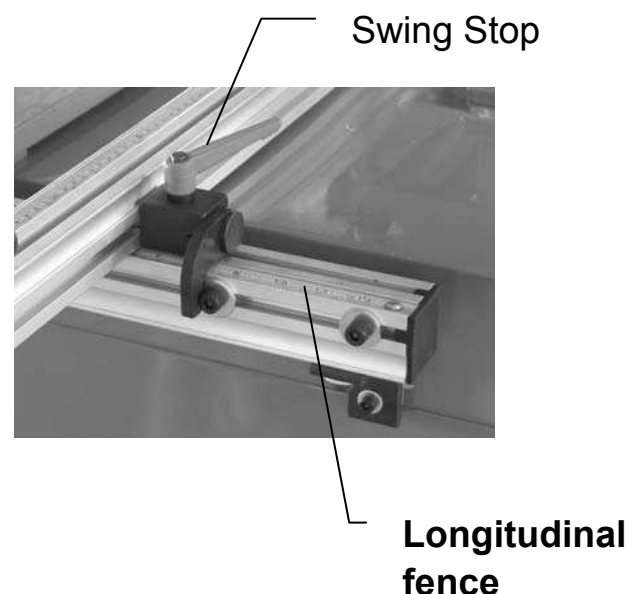
## 1. SAFETY GUARD:

The safety guard is used for avoiding chips splashing during operation. In addition, it also prevents the operator's hands from touching the boring bits when changing workpieces. The safety guard features automatic positioning. When mounting or removing the boring bits, always remember to remove the safety guard and turn power off.

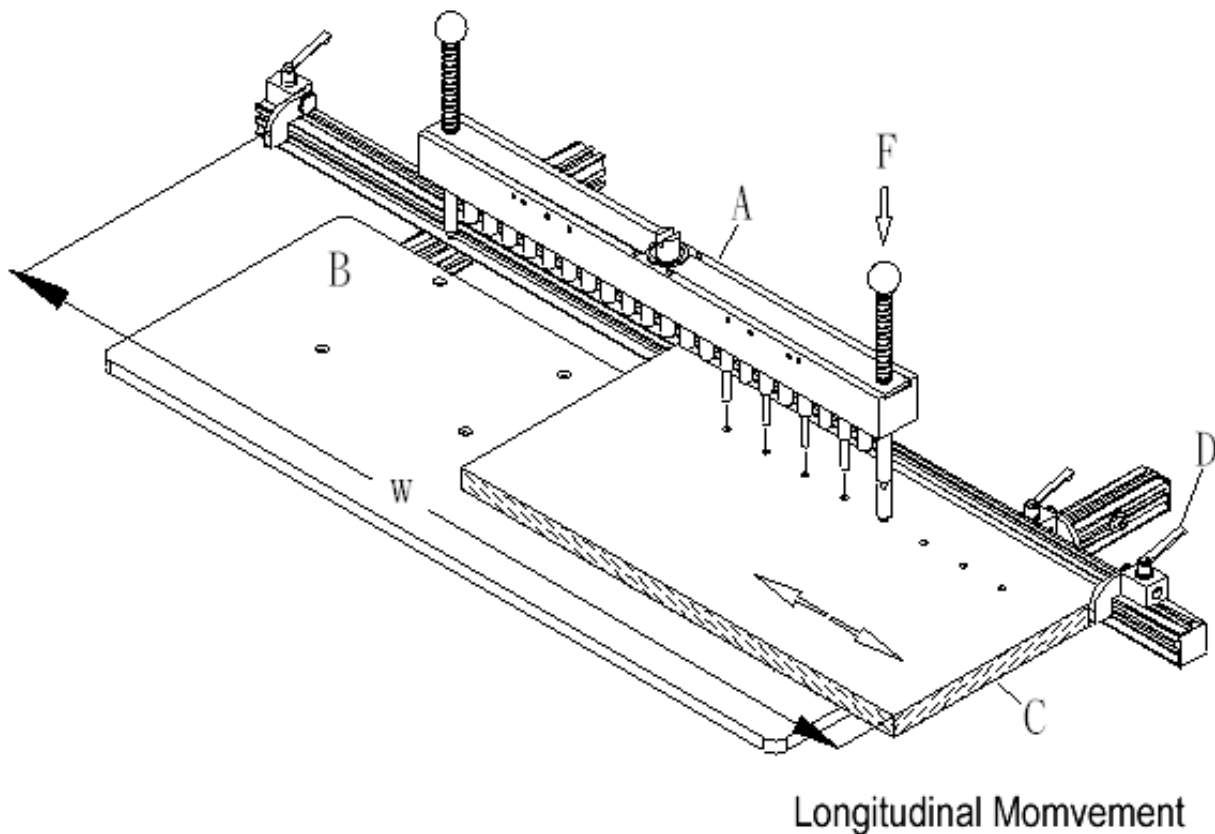


## 2. SWING STOPS ON LONGITUDINAL FENCE:

It is used to fix the workpieces length, which can be swiveled up or mounted to the other side. To do this, apply a hexagonal wrench to loosen the shaft and the stop for mounting to the other side.



# OPERATION INSTRUCTION



**Line boring head (A).** Boring operation is performed downward.

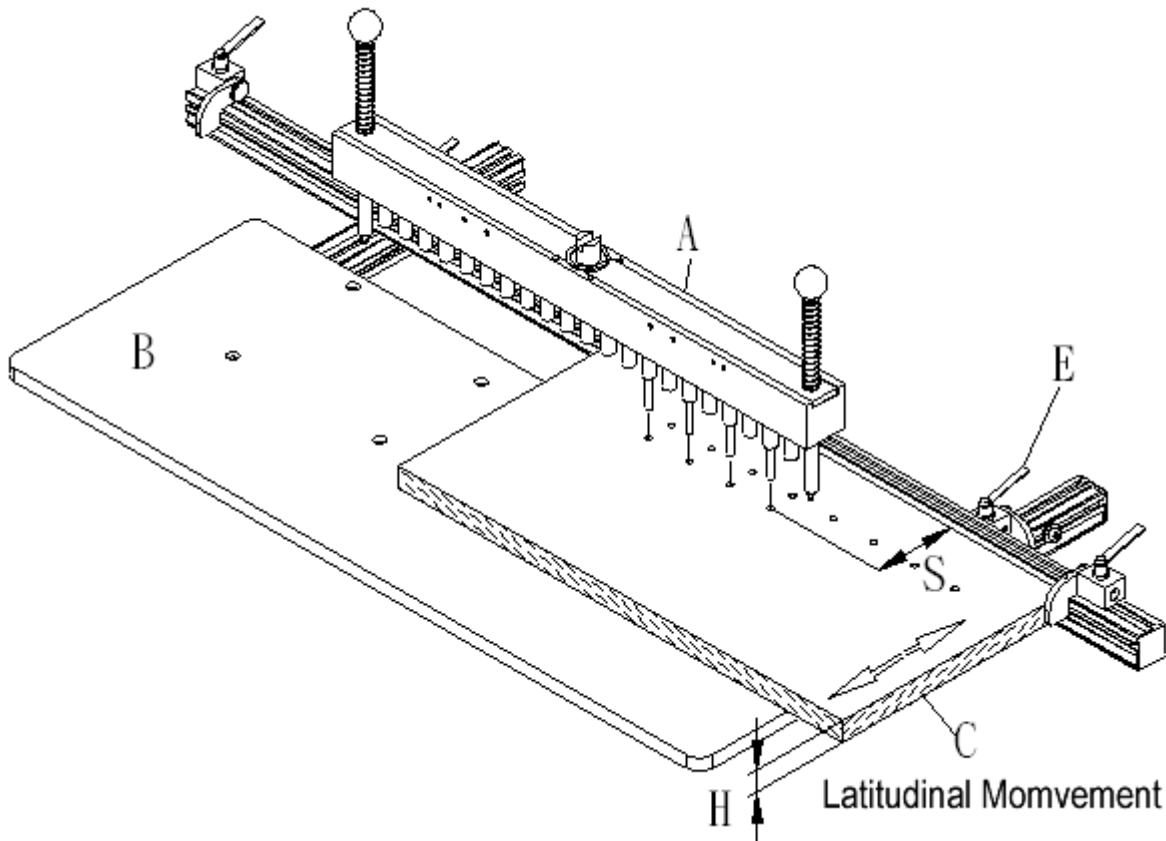
**Width stop (D).** The operator may adjust it according to workpiece width. Maximum distance of W is 70" (2,035 mm.)

**Positioning pin (F),** used for reference of boring position.

**Table (B).**

**Workpiece (C).**

# OPERATION INSTRUCTION



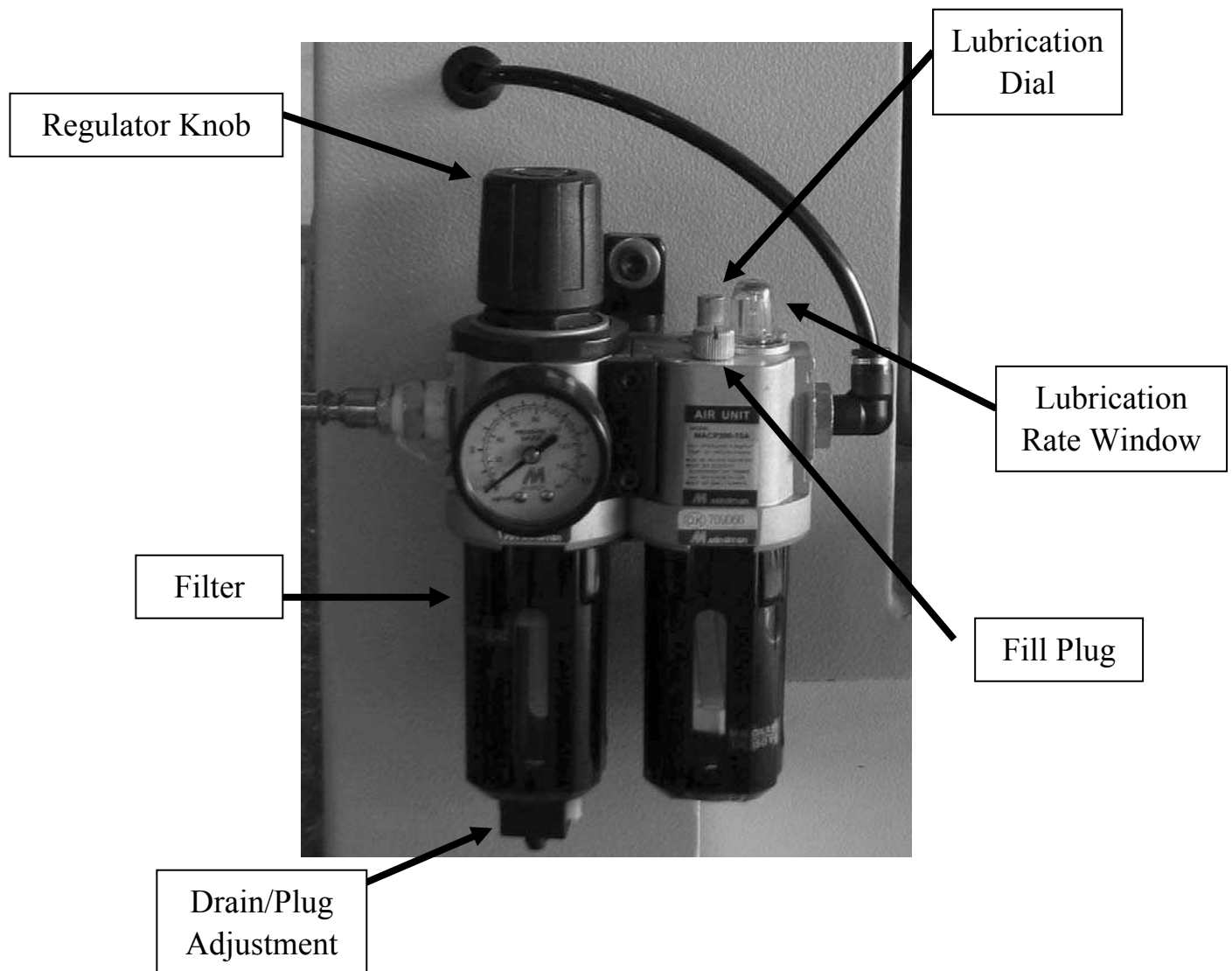
**Boring depth control level (E)**, which can be adjusted in forward and backward direction.

**Distance (S)** between the boring bits and scale rail. There are two different sizes on various models.

**Workpiece thickness (H).**

# AIR SYSTEM MAINTENANCE

The air supply unit features a regulator, a filter, and a lubricator. Each of these components must be setup properly before operation the machine.





# MACNINE MAINTENANCE Lubrication

- (1) Always keep a proper oil amount in the filter/regulator/lubricator combination unit.
- (2) Lubricate the line boring head by using a grease gun.
- (3) Replace manual spring: Use the top limit screw to fix the boring unit. Loosen screw (A) by using a hexagonal wrench. Pull the “shaft” upward until the spring can be removed. Replace with a new spring. Push down the shaft. Use a hexagonal wrench to tighten screw.



## ORDERING GUIDE FOR REPLACEMENT PARTS

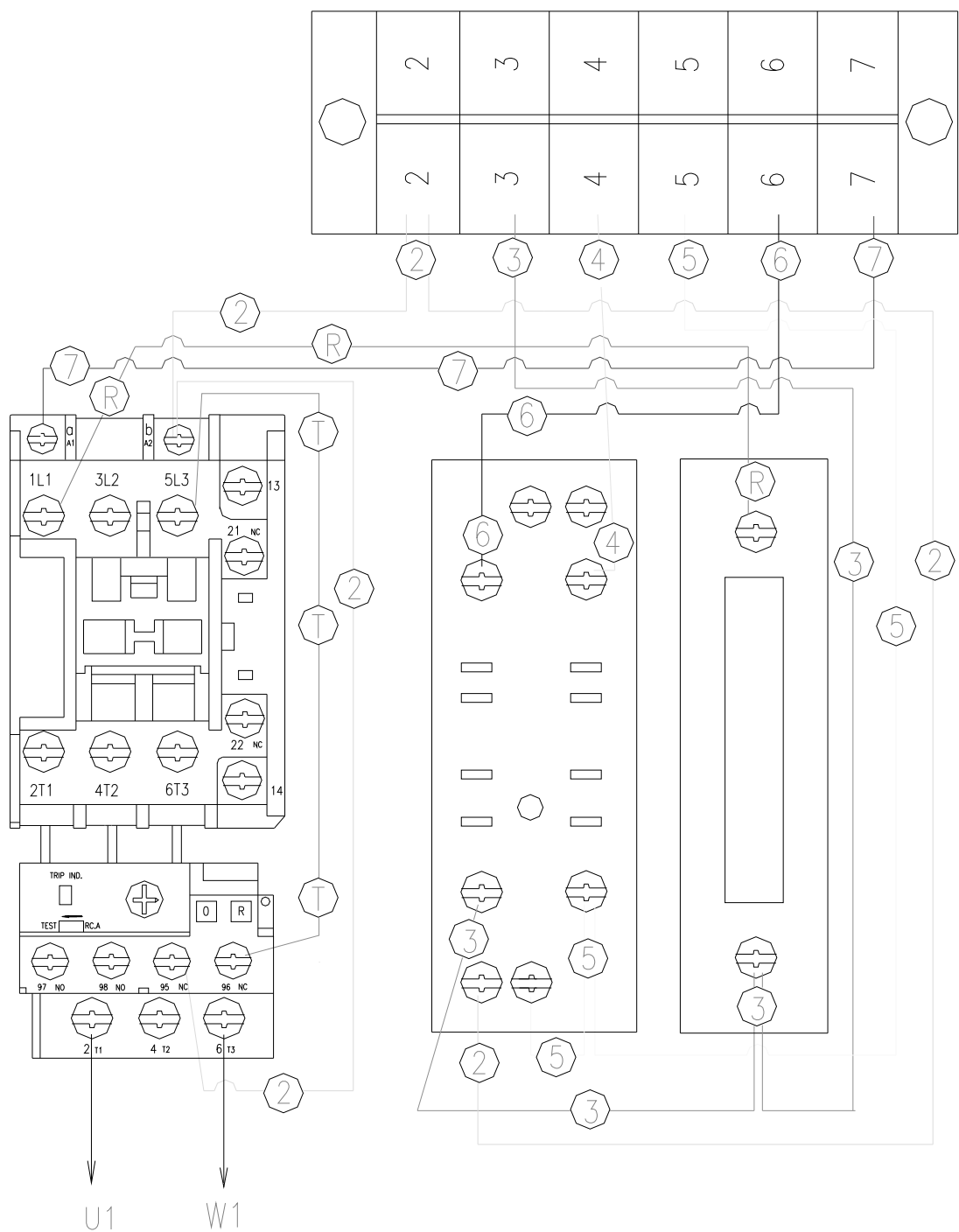
All the replacement parts for this can be ordered from your local distributor or directly from the manufacturer. If your desired replacement parts are not stocked by your local distributor, quote the details of your desired parts to your local distributor and the part details will be passed on to the manufacturer. Parts list is provided in this operation manual. Always provide the following information when order any parts.

1. Machine model number
2. Your desired part number.
3. Part description
4. Required quantity
5. If possible, offer a picture of the desired parts

# ELECTRIC WIRING DIAGRAM

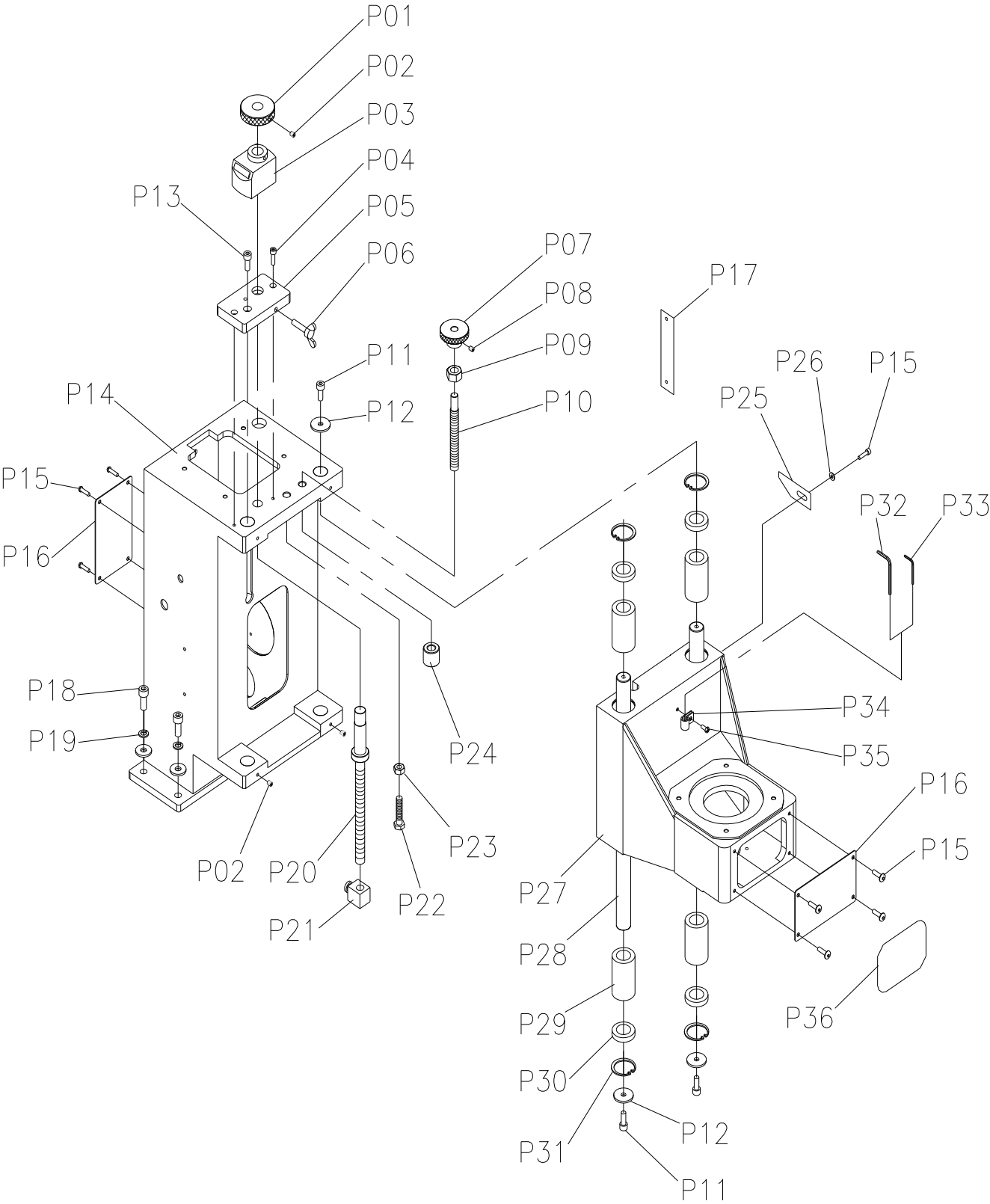


# 230Volt Wiring Diagram



# PARTS LIST

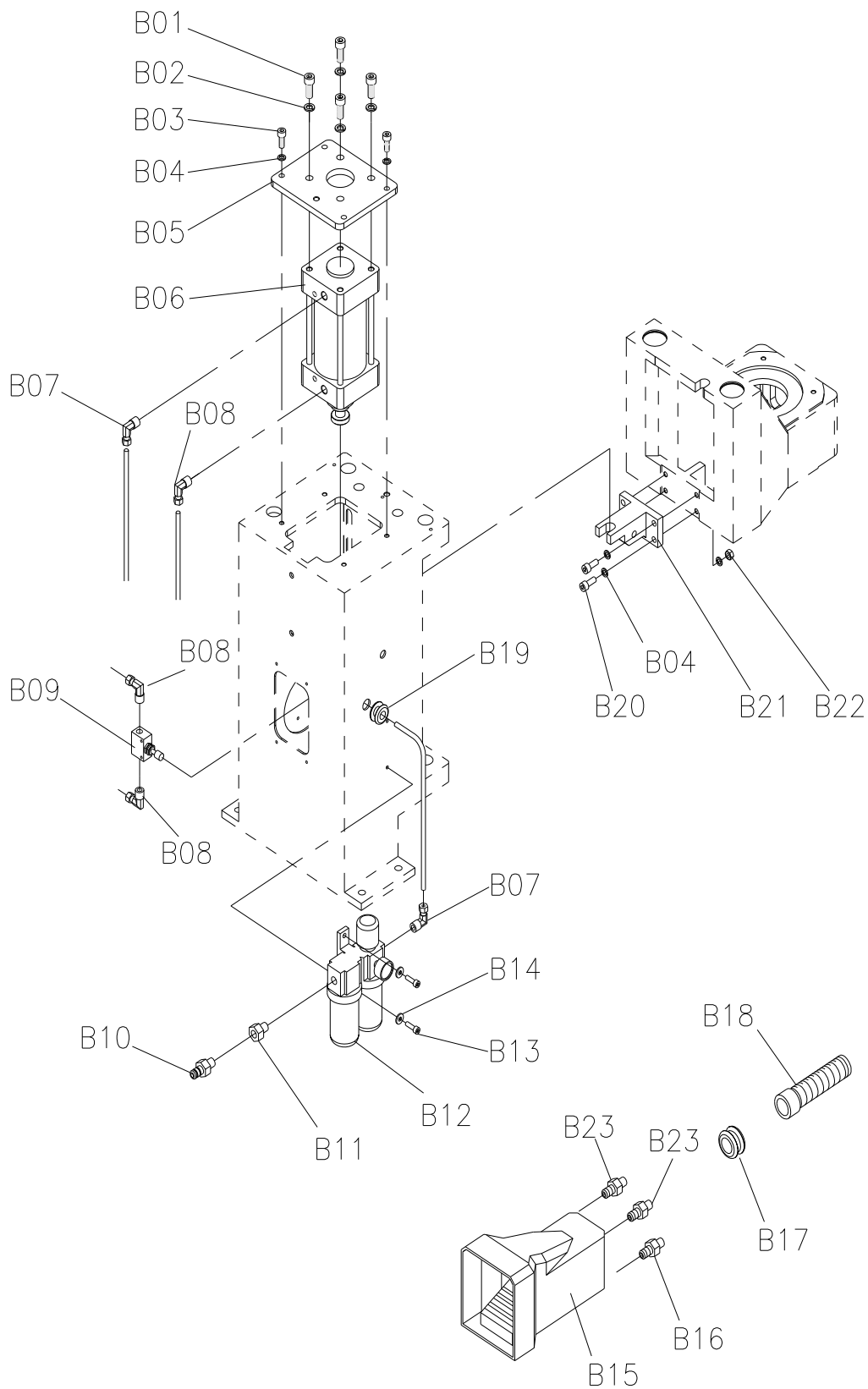
**MACHINE FRAME: JB-2IP ( P )**



**MODEL : JB-2IP (P)**

<b>REF</b>	<b>Parts NO.</b>	<b>DESCRIPTION</b>	<b>QTY</b>
P01	JB21-01049	Hand Knob	1
P02	SCA6*10	Set screw M6*10	5
P03	DA0914-2.0-E-O	Counter	1
P04	SC6*20	Cap screw M6*20	2
P05	JB21-01045	Fix board	1
P06	SQ6*35	Wing screw M6*35	1
P07	JB21-01011	Hand Knob	1
P08	SCA6*5	Set screw M6*5	1
P09	SA14	Hex nut M14	1
P10	JB21-01014	Hand knob screw	1
P11	SC8*16	Cap screw M8*16	3
P12	SD8*34*3-1	Flat wsasher M8*34*3-1	3
P13	SC8*20	Cap screw M8*20	1
P14	JB21-01003	Machine frame	1
P15	SC5*10	Cap screw M5*10	9
P16	JB21-01009	Cover	1
P17	150-105201	Scale 0->10	1
P18	SC10*30	Cap screw M10*30	4
P19	SDI10	Lock washer M10	4
P20	JB21-01047	Depth adjustment rod	1
P21	JB21-01046	Depth stop	1
P22	SB10*50	Hex bolt M10*50	1
P23	SA10*17	Hex nut M10*17	1
P24	JB21-01019	Anti-bump pad	1
P25	JB21-01015	Scale index	1
P26	SD5*12*1-1	Flat wsasher M5*12*1	1
P27	JB21-01008	Motor base	1
P28	JB21-01007	Elevation shaft	2
P29	JBLM25UU	Cylindrical bearing LM-25GUU	4
P30	JTTOD01411KC-0	Seal 25*40*7*2	4
P31	SR40	Int retaining ring 40MM	4
P32	JPSS006A	Fix bracket HC-2	1
P33	JBHS205-01	Hexagonal wrench	1
P34	KSS HC-2	Hexagonal wrench (ball end)	1
P35	SE5*12	Phlp hd scr M5*12	1
P36	CANTEK-002	Cantek logo	1

**MACHINE FRAME: JB-2IP ( B )**

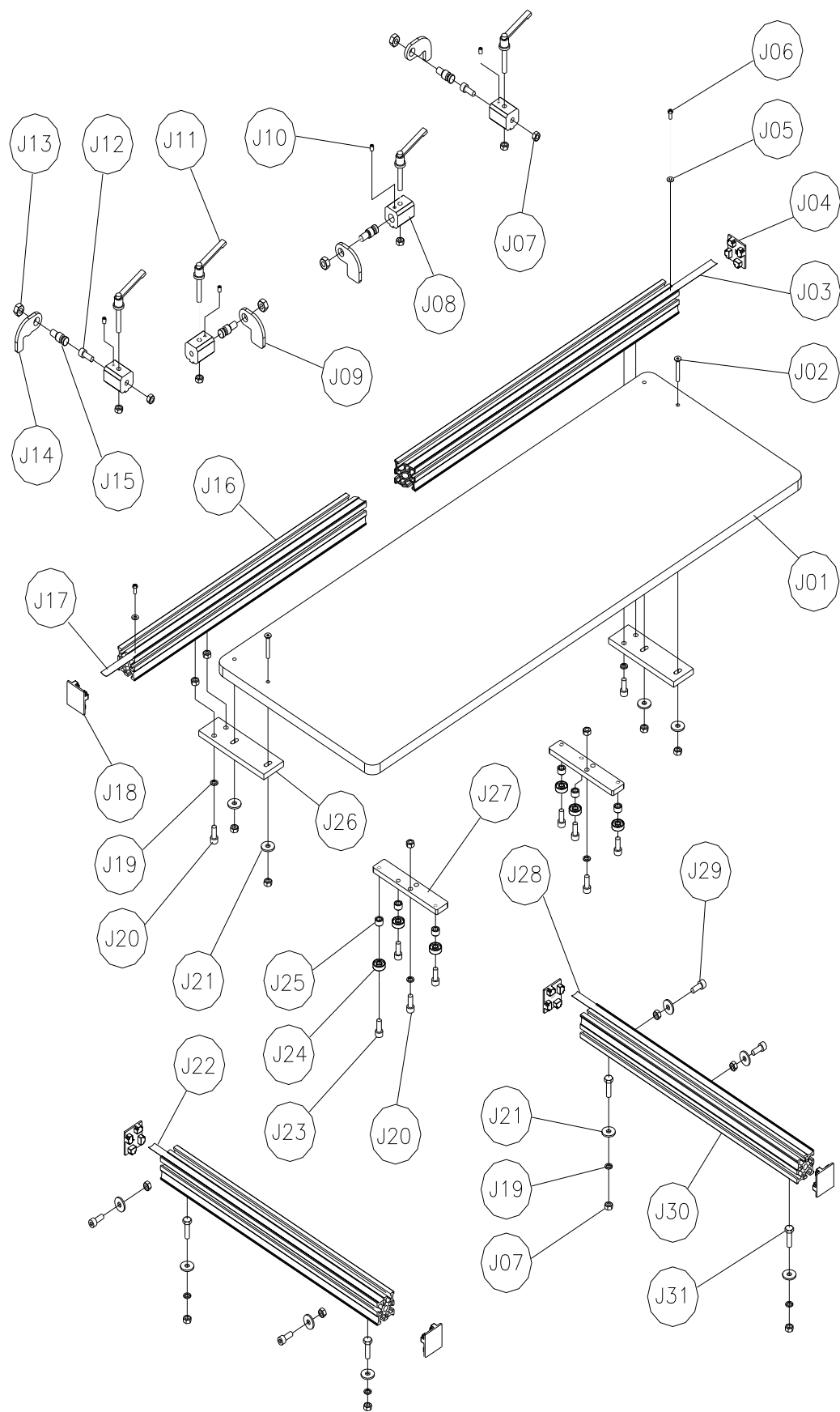


**MODEL : JB-2IP (B)**

REF	Parts NO.	DESCRIPTION	QTY
B01	SC10*35	Cap screw M10*35	4
B02	SD10*28*3-1	Flat washer M10*28*3	4
B03	SC8*20	Cap screw M8*20	4
B04	SDI8	Lock washer M8	12
B05	JBP21-01016	Air cylinder fix plate	1
B06	JBP21-02017	Air cylinder 80*85	1
B07	JNL03P008H	Male elbow connector PT-3/8"*φ8	2
B08	JNL03P006H	Male elbow connector PT-3/8"*φ6	3
B09	JVKA03	Speed regulation valve 3/8	1
B10	JIBS030218PUSA	Connector 3/8* 1/4 /18 thread	1
B11	CM-1/4-S	Quick connector 1/4	1
B12	JKL03BC	Air supply unit macp300-10A	1
B13	SC6*16	Cap screw M6*16	2
B14	SD6*16*2-1	Flat washer M6*16*2	2
B15	J4F210-08G	Foot switch	1
B16	JNS02P006H	Male connector PT-1/4"*φ6	1
B17	JMV-25	Rubber sleeve	1
B18	NGN-17B-50-1	PU TUBE 1/2"*2500mm	1
B19	JMV-10	Rubber sleeve	1
B20	SC8*40	Cap screw M8*40	4
B21	JB21-02010	Synchronized bracket	1
B22	SA8*13	Hex nut M8	4
B23	JNS02P008H	Male connector PT-1/4"*φ8	2



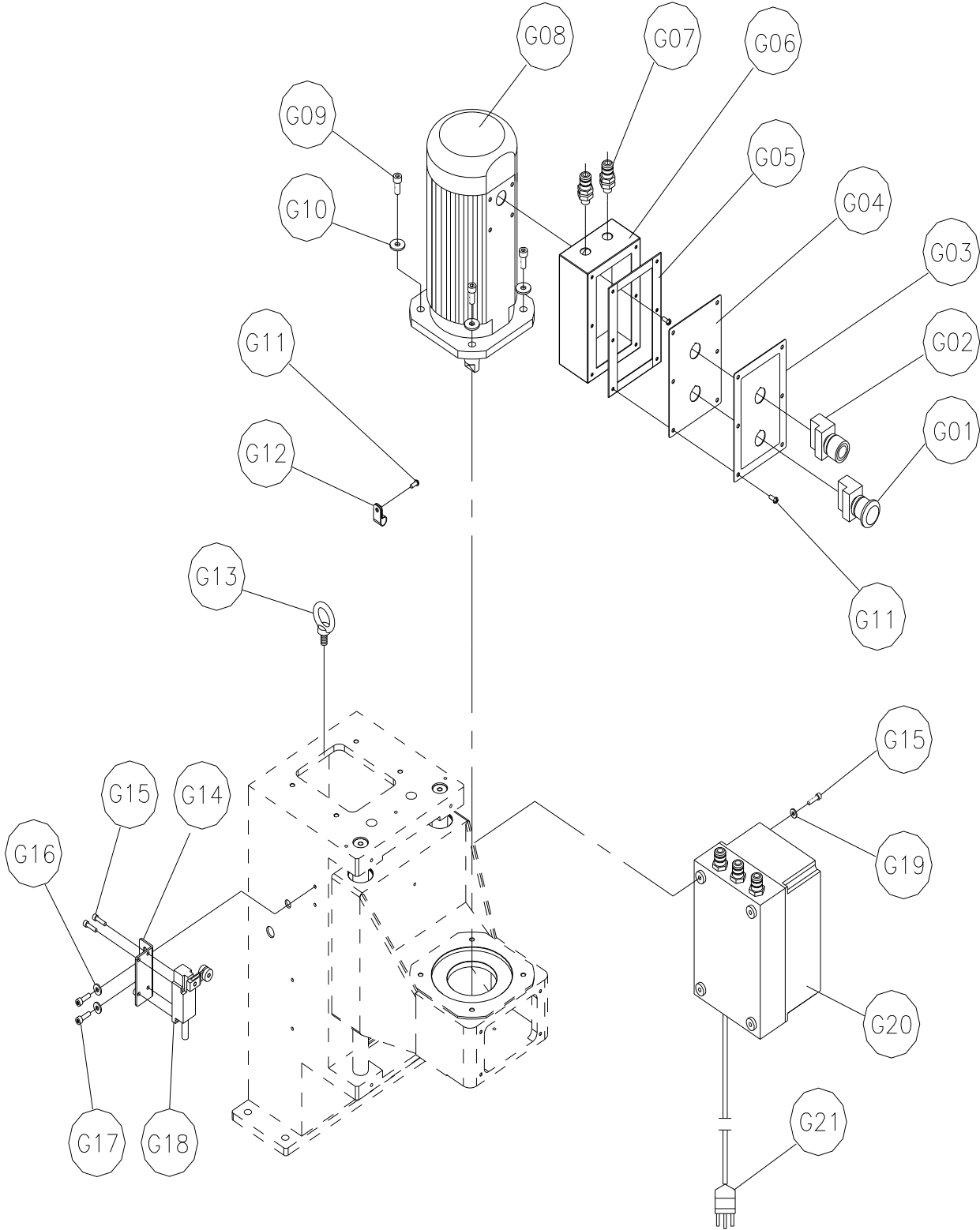
MACHINE FRAME: JB-2IP ( J )



**MODEL : JB-2IP (J)**

REF	Parts NO.	DESCRIPTION	QTY
J01	JB21-01006B	Talbe	1
J02	SCC8*35	Flat socket head screw M8*35	4
J03	JBARCOTOOLSJP	Scale	1
J04	JB21-03008	Plug-R	3
J05	SD5*12*1	Flat washer M5*12*1	4
J06	SE5*12	Phlp hd scr M5*12	4
J07	SA8*13	Hex nut M8	22
J08	JB21-03002A	Fix block	4
J09	JB21-03003-1	Left & Right Fix block	2
J10	SCA6*5	Set screw M6*5	4
J11	PH063KBOM840	Handle	4
J12	SC8*16	Cap screw M8*16	2
J13	SAA10*1.5	Self-locking nut M10*1.5P	4
J14	JB21-03004-1	Cross positioning plate	2
J15	JB21-03023	Cross positioning shaft	4
J16	JB21-03017	Aluminum rail	1
J17	JBARCOTOOLSJP	Scale	1
J18	JB21-03009	Plug-L	3
J19	SDI8	Lock washer M8	12
J20	SC8*20	Cap screw M8*20	8
J21	SD8*18*2-1	Flat washer M8*18*2	12
J22	JBARCOTOOLSJP	Scale	1
J23	SC8*25	Cap screw M8*25	6
J24	JBCIC608ZZ	Ball bearing	6
J25	JB21-03019	Washer	6
J26	JB21-03021	Fix plate	2
J27	JB21-03016	Rail	2
J28	JBARCOTOOLSJP	Scale	1
J29	SC8*12	Cap screw M8*12	4
J30	JB21-03016	Aluminum rail	2
J31	SB8*25	Hex bolt M8*25	4

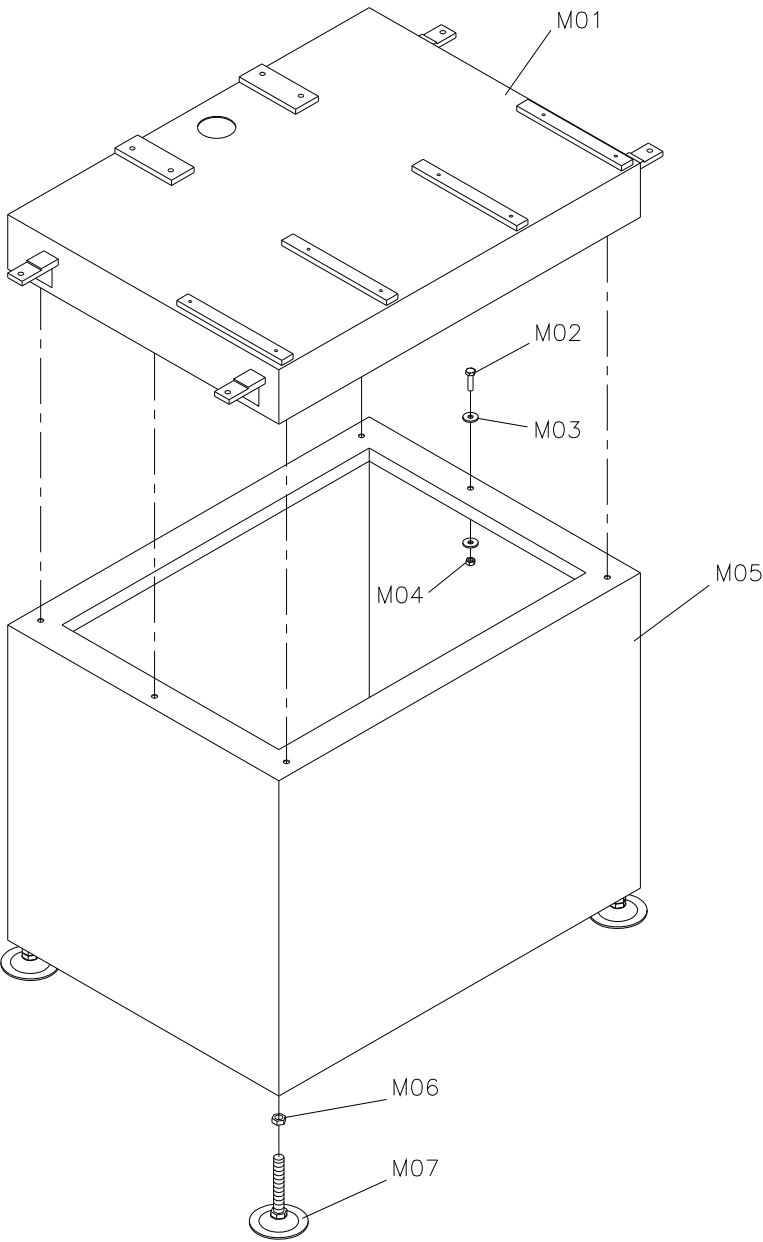
**MACHINE FRAME: JB-2IP ( G )**



**MODEL : JB-2IP (G)**

<b>REF</b>	<b>Parts NO.</b>	<b>DESCRIPTION</b>	<b>QTY</b>
G01	AP-R2PNL4221B	Push button	1
G02	AP-R2PIF221A	Illuminated push button 22/220V	1
G03	JB21-01041B	Panel label	1
G04	JB21-01032	Switch box panel	1
G05		Sponge rod	1
G06	JB21-01031	Switch box	1
G07	PGB-11-10B-1	Cable Tie Clamp 11-10B	6
G08		Motor 2HP, 60Hz/230Volt	1
G09	SC8*30	Cap screw M8*30	4
G10	SD8*18*2-1	Flat washer M8*18*2	4
G11	SE5*12	Phlp hd scr M5*12	11
G12	ACC-3-1	Cable clamps	1
G13	SI10*1.5	Wing nut M10	1
G14	JB21-01018	Limit fix plate	1
G15	SC5*10	Cap screw M5*10	8
G16	SD6*16*2-1	Flat washer M6*16*2	2
G17	SC6*16	Cap screw M6*16	2
G18	AZ-8104	Limit switch	1
G19	SD5*12*1-1	Flat washer M5*12*1	4
G20	JB21X09001	Control Box	1
G21	JPLUG262-002	Wire with plug	1

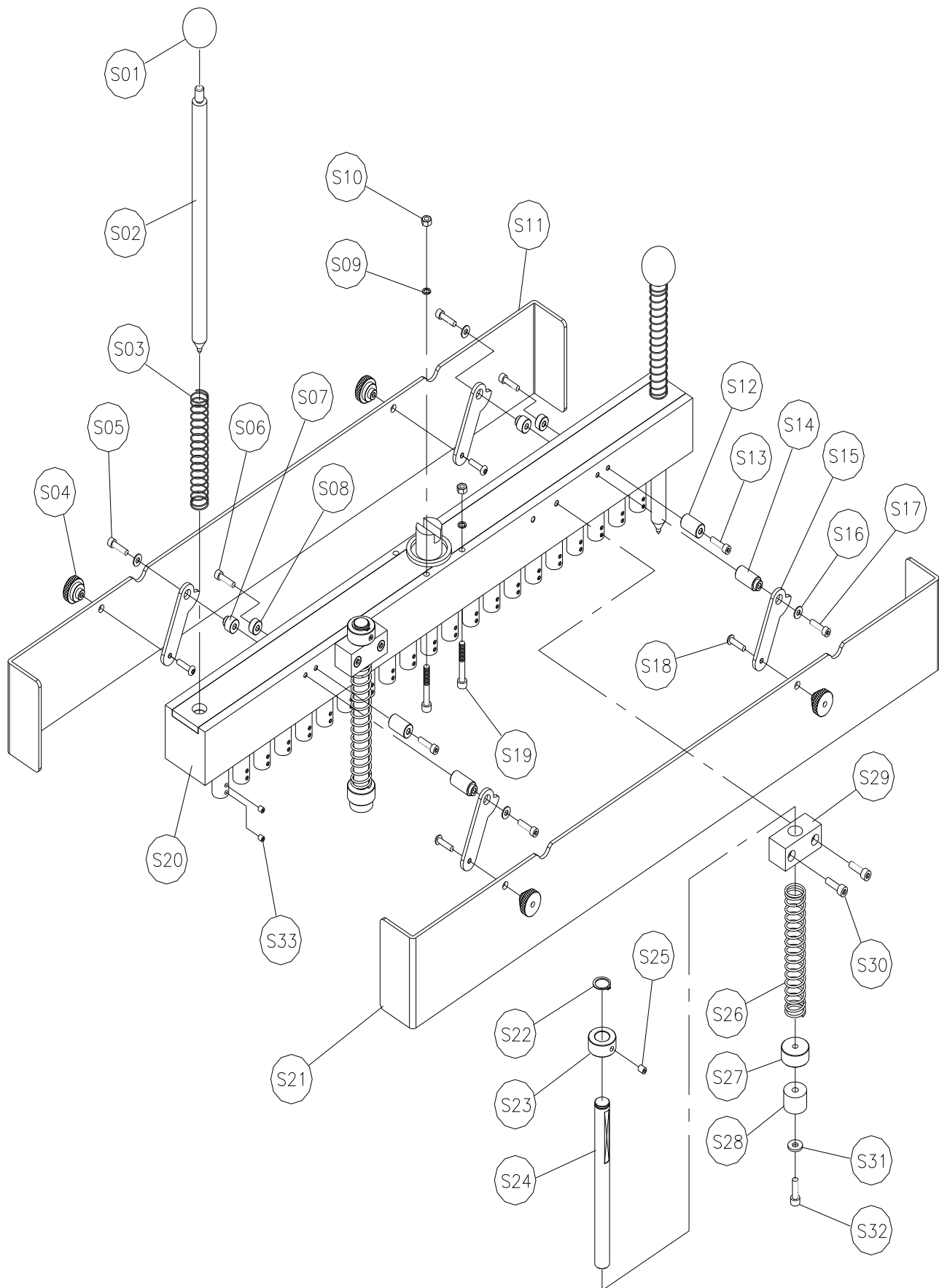
MACHINE FRAME: JB-21(M)



## MODEL: JB-2IP (M)

REF	Parts No.	DESCRIPTION	Q'TY
M01	JB21-01001	Table	1
M02	SB8*16	Hex. Bolt M8*16	6
M03	SD8*18*2-1	Flat washer M8*18*2	12
M04	SA8*13	Hex nut M8	6
M05	JB21-01042	Stand	1
M06	SA5/8	Hex nut M5/8	4
M07	SPA5/8	Adjusting foot 5/8"	4

## MACHINE FRAME: JB-2IP ( S )



**MODEL : JB-2IP (S)**

REF	Parts NO.	DESCRIPTION	QTY
S01	JBBP3203	Black knob M22*3/8	2
S02	JB21-05002	Positioning rod	2
S03	JB21-05016	Positioning spring	2
S04	JB21-05018	Fix knob	4
S05	SC5*25	Cap screw M5*25	2
S06	SC5*16	Cap screw M5*16	2
S07	JB21-05007	Rear bushing	2
S08	JB21-05009	Rear fix bushing	2
S09	SDI6	Lock washer M6	4
S10	SA6	Hex nut M6	4
S11	JB21-05013A	Back transparent guard	1
S12	JB21-05008A	Front bushinhg	2
S13	SC5*35	Cap screw M5*35	2
S14	JB21-05006A	Front bushinhg	2
S15	JB21-05011A	Guard connection plate	4
S16	SD5*12*1-1	Flat washer M5*12*1	4
S17	SC5*50	Cap screw M5*50	2
S18	SCB5*20	Round socket head screw M5*20	4
S19	SC6*70	Cap screw M6*70	4
S20	JB21-05001B	Ling boring head	1
S21	JB21-05012A	Front transparent guard	1
S22	SS16	Snap ring	2
S23	JB21-05004	Clamping akjustment collar	2
S24	JB21-05003A	Clamp rod	2
S25	SCA6*5	Set screw M6*5	2
S26	JB21-05017	Clamping spring	2
S27	JB21-05005	Clamping collar	2
S28	JD65-1380	Rust prevention pad	2
S29	JB21-05014	Clamping block	2
S30	SC6*30	Cap screw M6*30	4
S31	SD6*16*2-1	Flat washer M6*16*2	2
S32	SC6*20	Cap screw M6*20	2
S33	SCA5*5	Set screw M5*5	42