

Squaring a Board

The following procedure should be followed each time a board is taken from rough stock to S4S-Surfaced on 4 Sides. Do not square boards individually, but run them all at the same time for consistency.

1. Cut stock to rough length using the **Miter Saw** or a **Hand Saw**. Rough length should be a couple inches longer than required. Rough pieces should never be less than **18 inches** (or the spacing of the feed rollers on your planer).
2. Use the **jointer** to surface the **concave face** of the stock. Remove material until most of the rough mill marks have been removed from the face. **Do not** joint both sides of the board, because the faces will not be parallel.
3. Head to the **planer**. Measure the thickness of your stock and set the planer to the **thickness of the board minus 1/16"**. Example: 1" board- set planer for 15/16". Proceed to take off 1/16" (one turn of the adjustment wheel) for each cut, while flipping the board **end over end** to remove material from both sides, until the stock is the desired thickness. ***After 1/8-3/16" is removed, it's a good idea to sticker your wood and let it acclimate for 24 hours.***
4. Head back to the **jointer**, and joint the concave **edge** until the rough mill marks are removed. You now have a straight edge to use at the table saw.
5. At the table saw, set the fence to the finished **width** of the board. Rip the board to the desired width. Be sure that the board is pressed against the fence at all times.
6. Congratulations, you've squared a board. Now, get to work and finish your project.

Special note: Check to make sure that the jointer fence and the table saw blade are square to the table.

Concave Face

