

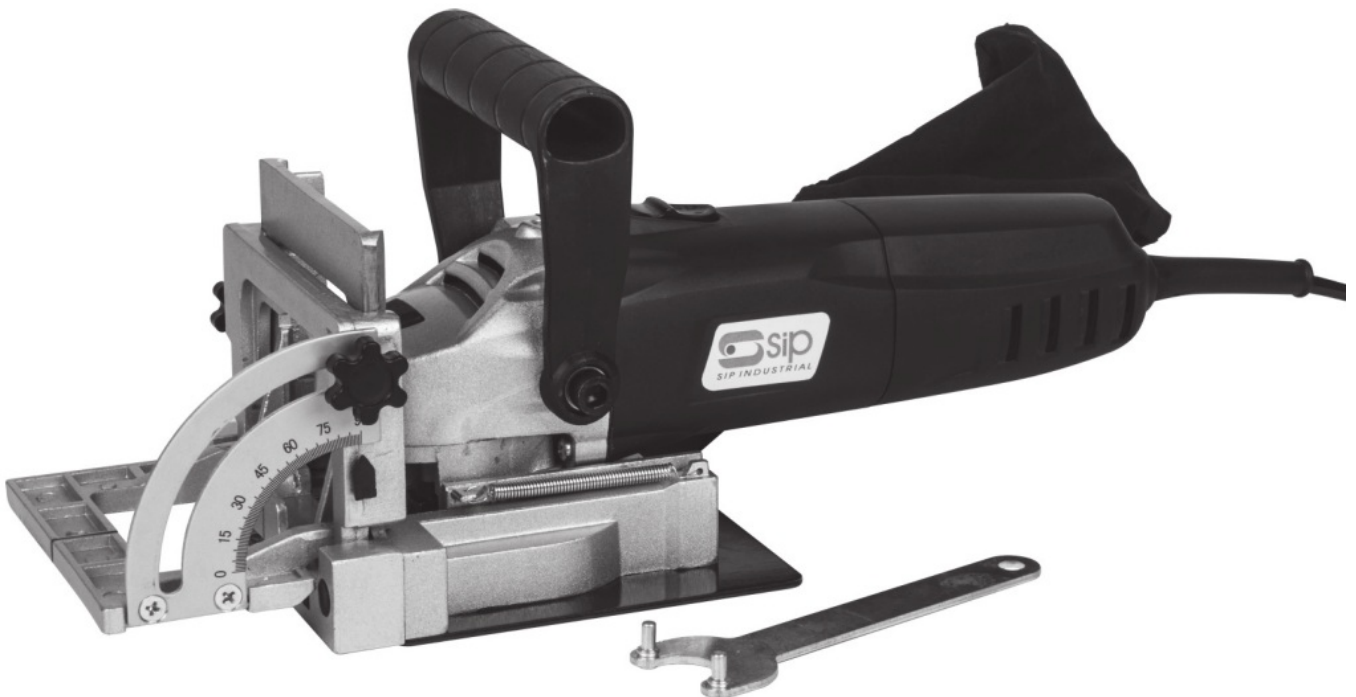


## **sip 07904 Biscuit Jointer User Manual**

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**07904 Biscuit Jointer  
User Manual**



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## 07904 Biscuit Jointer

Please read and fully understand the instructions in this manual before operation. Keep this manual safe for future reference.

## SAFETY SYMBOLS USED THROUGHOUT THIS MANUAL



**Danger / Caution:** Indicates a risk of personal injury and/or the possibility of damage.



**Warning:** Risk of electrical injury or damage!



**Note:** Supplementary Information.

## SAFETY INSTRUCTIONS



**IMPORTANT:** Please read the following instructions carefully, failure to do so could lead to serious personal injury and/or damage to the biscuit jointer.

When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock, and personal injury. Read all these instructions before operating the biscuit jointer and save this user manual for future reference.

SIP recommends that this biscuit jointer should not be modified or used for any application other than that for which it was designed; A biscuit jointer is a tool used to join two pieces of wood (or wood-derived product) together, using a small circular blade (cutter) to cut a crescent-shaped hole in the opposite edges of two pieces of wood or wood composite.

If you are unsure of its relative applications do not hesitate to contact us and we will be more than happy to advise you.

**KNOW YOUR BISCUIT JOINTER:** Read and understand the owner's manual and labels affixed to the biscuit jointer. Learn its applications and limitations, as well as the potential hazards specific to this biscuit jointer.

**KEEP WORK AREA CLEAN AND WELL LIT:** Cluttered work benches and dark areas invite accidents. Floors must not be slippery due to oil, water or sawdust etc. **DO NOT USE THE BISCUIT JOINTER IN DANGEROUS ENVIRONMENTS:** Do not use the biscuit jointer in damp or wet locations, or expose it to rain. Do not use in environments with a potentially explosive atmosphere.

**KEEP CHILDREN AND UNTRAINED PERSONNEL AWAY FROM THE WORK AREA:** All visitors should be kept at a safe distance from the work area.

**STORE TOOLS SAFELY WHEN THEY ARE NOT IN USE:** The biscuit jointer should be stored in a dry, locked cupboard wherever possible and out of the reach of children.

**WEAR THE CORRECT CLOTHING:** Do not wear loose clothing, 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. Roll long sleeves up above the elbow.

**USE SAFETY GOGGLES AND EAR PROTECTION:** Wear CE-approved safety goggles at all times, normal spectacles only have impact-resistant lenses, they are NOT safety glasses. A face or dust mask should be worn if the operation is dusty and ear protectors (plugs or muffs) should be worn, particularly during extended periods of operation.

**PROTECT YOURSELF FROM ELECTRIC SHOCK:** When working with power tools, avoid contact with any earthed items (e.g. pipes, radiators, hobs, refrigerators, etc.). It is advisable wherever possible to use an RCD (residual current device) at the mains socket.

**STAY ALERT:** Always watch what you are doing and use common sense. Do not operate a power tool when you are tired or under the influence of alcohol or drugs. **DISCONNECT THE BISCUIT JOINTER FROM THE MAINS SUPPLY:** When not in use, before servicing, and when changing accessories such as cutters, etc.

**AVOID UNINTENTIONAL STARTING:** Make sure the switch is in the OFF position before connecting the tool to the main supply.

**NEVER LEAVE THE BISCUIT JOINTER RUNNING / CONNECTED WHILST UNATTENDED:** Turn off the biscuit jointer and disconnect it from the main supply between jobs. Do not leave the biscuit jointer until it comes to a complete stop.

**DO NOT ABUSE THE MAINS LEAD:** Never carry the biscuit jointer by the mains lead or pull it to remove the plug from the mains socket. Keep the mains lead away from heat, oil, and sharp edges. If the mains lead is damaged, it must be replaced by the manufacturer or its service agent, or a similarly qualified person in order to avoid unwanted hazards.

**CHECK FOR DAMAGED PARTS:** Before every use of the biscuit jointer, a guard or other part that is damaged should be carefully checked to determine that it will operate correctly and perform its intended function. Check for alignment of moving parts, free running of moving parts, breakage of parts, and any other conditions that may affect its operation. A guard or other part that is damaged should be correctly repaired or replaced by an authorized service center unless otherwise indicated in this instruction manual. Have defective switches replaced by an authorized service agent? Do not attempt to operate the tool if the switch does not turn it on and off.

**KEEP ALL GUARDS IN PLACE:** And in full working order.

**MAINTAIN TOOLS WITH CARE:** Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories. All extension cables must be checked at regular intervals and replaced if damaged.

**USE ONLY RECOMMENDED ACCESSORIES:** Consult this user manual for recommended accessories. Follow the instructions that accompany the accessories. The use of improper accessories may cause hazards and will invalidate any warranty you may have.

**REMOVE ADJUSTING KEYS AND WRENCHES:** Form a habit of checking to see that keys and adjusting wrenches etc. are removed from the biscuit jointer before every use.

**DO NOT OVERREACH:** Keep proper footing and balance at all times.

**USE THE RIGHT TOOL:** Do not use the biscuit jointer or an attachment to do a job for which it was not designed.

**DO NOT FORCE THE BISCUIT JOINTER:** It will do the job better and more safely at the rate which it was designed.

**DO NOT OPERATE THE BISCUIT JOINTER IN EXPLOSIVE ATMOSPHERES:** Do not use the biscuit jointer in the presence of flammable liquids, gases, dust or other combustible sources. The biscuit jointer may create sparks that can ignite the dust or fumes.

**DO NOT EXPOSE THE BISCUIT JOINTER TO RAIN OR USE IT IN WET CONDITIONS:** Water entering the biscuit jointer will greatly increase the risk of electric shock.

**WARNING:** The dust generated by certain wood or wood-derived products can be dangerous to the operator, as well as anyone in the area. Always operate the biscuit jointer in well-ventilated areas and provide dust removal where possible.

- Use only the cutters specified for this biscuit jointer.
- Before each use; Ensure that the cutter is fully secure.
- For your safety; remove the chippings and work debris etc. from inside the extraction port and bag before each operation.

- Make sure that all keys and wrenches are removed before switching on the biscuit jointer.
- Keep hands out of the path of the cutter.
- Make sure the cutter is clear of the workpiece before the switch is turned on.
- Allow the biscuit jointer to run up to full speed before starting a cut.
- Stop the operation immediately if you notice anything abnormal.
- Wait for the cutter to stop completely and remove it from the mains supply before servicing or adjusting the biscuit jointer.
- Be alert at all times, especially during repetitive, monotonous operations. Don't be lulled into a false sense of security; Cutters are extremely unforgiving.
- Use of improper accessories may cause damage to the biscuit jointer and surrounding area as well as increase the risk of injury.
- Do not modify the biscuit jointer to do tasks other than those intended.
- Maintain a steady grip, avoid awkward positions, and do not allow your hand to be in direct line of the cut.
- Make sure the cutter is installed so that it rotates in the correct direction.
- Make sure there are no nails or foreign objects in the part of the workpiece to be joined.
- Only use cutters for which the maximum permissible speed is not lower than the maximum spindle speed of the biscuit jointer and which are suitable for the material to be cut.
- Understand the operating environment; Before each use, the operator should assess, understand, and where possible reduce the specific risks and dangers associated with the operating environment. Bystanders should also be made aware of any risks associated with the operating environment.
- Always ensure that the base plate is correctly fitted; The base plate protects the operator from broken disc cutter fragments and unintentional contact with the disc cutter.
- Never start the biscuit jointer with the cutter touching the workpiece.



When using the biscuit jointer always ensure the operator as well as those in the area wear ear protection.



When using the biscuit jointer always ensure the operator as well as those in the area wear eye protection.



Some wood and wood composites have the potential to be highly toxic; always wear a face mask when operating a biscuit jointer.



**Caution:** The warnings and cautions mentioned in this user manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors that cannot be built into this product but must be applied.

## CONTENTS AND ACCESSORIES

- Biscuit Jointer.
- Blow Moulded Case.
- Cutter Wrench.
- Dust Collection Bag.

- Instruction Manual.



**Note:** If any parts are missing, contact your distributor for the missing parts to be replaced.

## GUARANTEE

This SIP biscuit jointer is covered by 12-month parts and labor warranty covering failure due to manufacturers' defects. This does not cover failure due to misuse or operating the biscuit jointer outside the scope of this manual – any claims deemed to be outside the scope of the warranty may be subject to charges including, but not limited to parts, labor, and carriage costs.

Consumable items such as fuses, cutters, and motor brushes are not covered by the warranty.

In the unlikely event of warranty claims, contact your distributor as soon as possible.

**Note:** Proof of purchase will be required before any warranty can be honored.

## TECHNICAL SPECIFICATIONS

Part number	7904
Input voltage	230V-240V ~ 50hz
Motor	900 Watts
No Load Speed	11,000 r/min
Cutter Size	Ø 100 x 22 x 4 mm
Angle Adjustment	0° – 90°
Max. Height Adjustment	35mm
Protection	IPX0
Vibration**	2.695 m/s <sup>2</sup>
Sound Pressure (LpA)*	87 dB(A)
Sound Power (LwA)*	98 dB(A)
Net Weight	3.2 Kg

\* 3 dB(A) uncertainty.

\*\* 1.5m/s<sup>2</sup> Uncertainty.

A-weighted sound power level calculated in accordance with EN ISO 3744.

A-weighted sound pressure level determined in accordance with EN ISO 11203.

## ELECTRICAL CONNECTION



This biscuit jointer is double insulated; This means the operator is separated from the tool's electrical system by two complete sets of electrical insulation.

This biscuit jointer is fitted with a standard UK-type 230V ~ plug. Before using the tool inspect the cable and plug to ensure that neither is damaged. If any damage is visible have the tool inspected/repared by a suitably qualified person. If it is necessary to replace the plug a heavy-duty impact-resistant plug would be preferable.

**The wires for the plug are colored in the following way:**

Blue	Neutral
Brown	Live

As the colors of the wires may not correspond with the markings in your plug, proceed as follows:

- The wire which is colored blue must be connected to the terminal marked with N or colored black (or blue).
- The wire which is colored brown must be connected to the terminal, which is marked L or colored red (or brown).
- Always secure the wires in the plug terminal carefully and tightly. Secure the cable in the cord grip carefully.



**Warning:** Never connect live or neutral wires to the earth terminal of the plug. Only fit an approved plug with the correct rated fuse. If in doubt consult a qualified electrician.



**Note:** Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original.

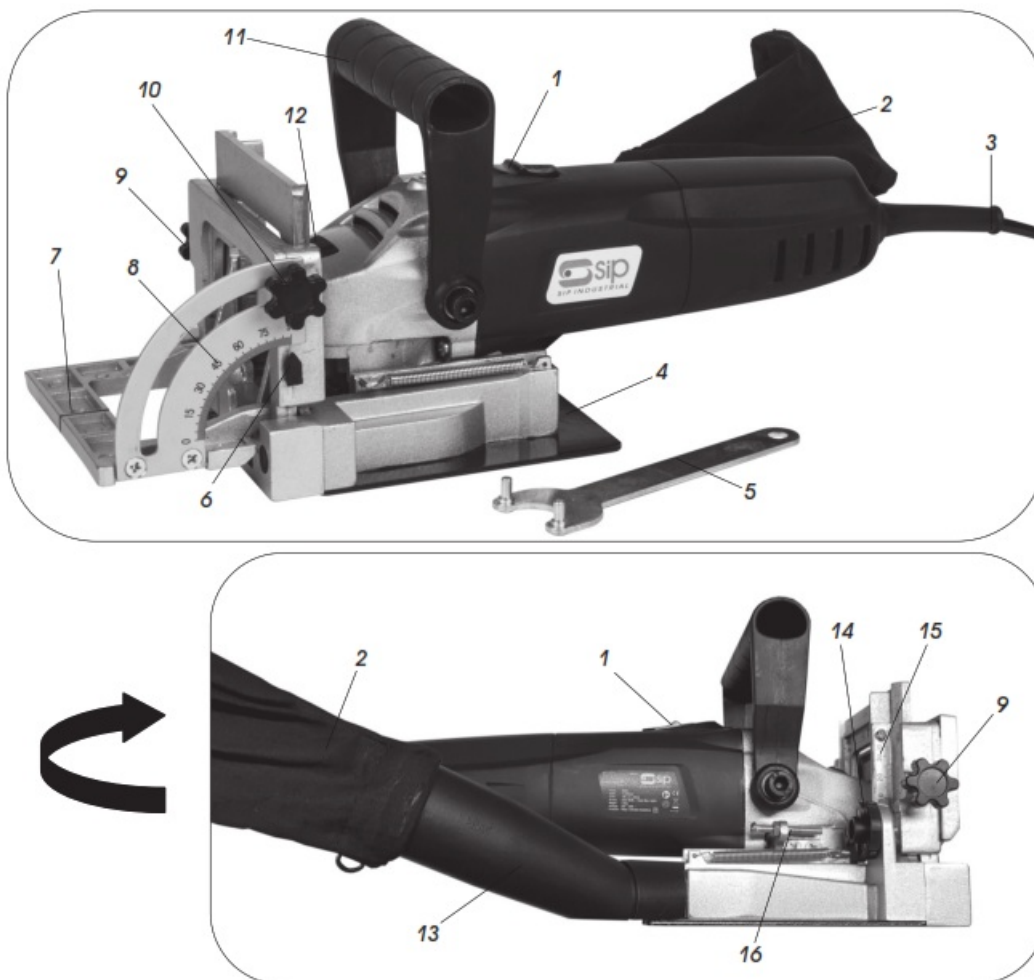


**Note:** If an extension lead is required in order to reach the mains supply; ensure that this is rated for the correct voltage and fuse rating.



**Note:** The cross-section of the extension lead should be checked so that it is of sufficient size so as to reduce the chances of voltage drops.

## **GETTING TO KNOW YOUR BISCUIT JOINTER**

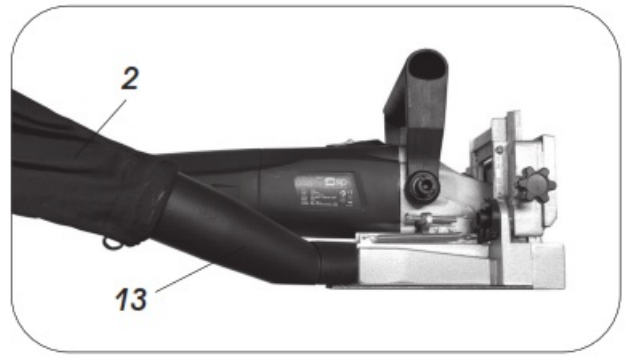
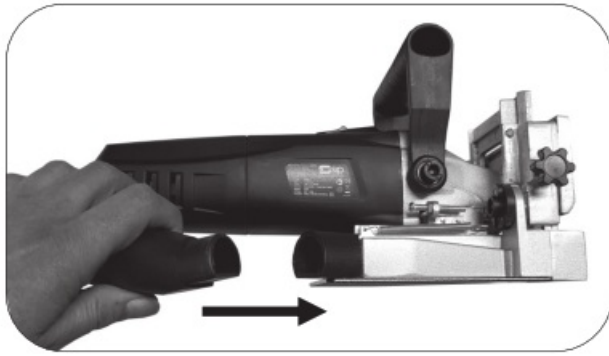


Ref. No.	Description	Ref. No.	Description
1	On/Off Switch	9	Height Adjust Lock / Release
2	Dust Collection Bag	10	Angle Adjust Lock / Release
3	Mains Lead	11	Auxiliary Handle
4	Base Plate	12	Spindle Lock
5	Cutter Wrench	13	Dust Extraction Adaptor (40mm)
6	Angle Pointer	14	Plunge Depth Selector
7	Centre Line	15	Height Scale
8	Angle Scale	16	Plunge Depth Adjuster

## ASSEMBLY INSTRUCTIONS

### FITTING THE DUST COLLECTION BAG

- There is very little assembly required to use the biscuit jointer – Just the dust extraction adaptor (13) / bag (2) needs to be fitted.



**Note:** The collection bag can be removed from the extraction adaptor to allow connection to a 40mm external extraction system.

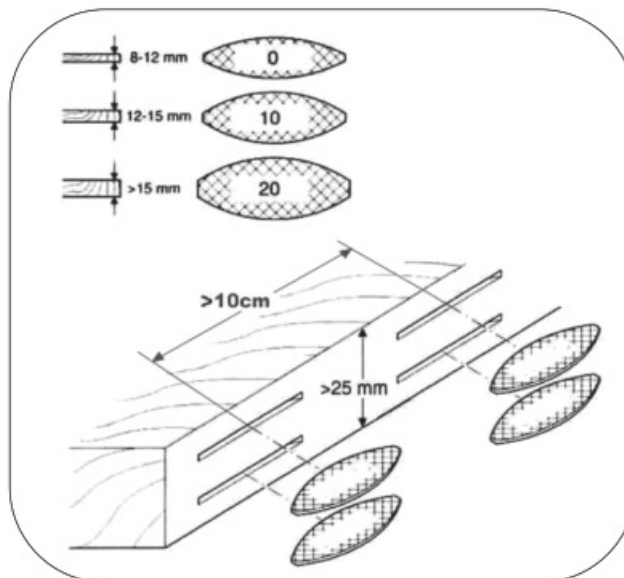


**Note:** Always ensure that the bag is emptied regularly.

## OPERATING INSTRUCTIONS



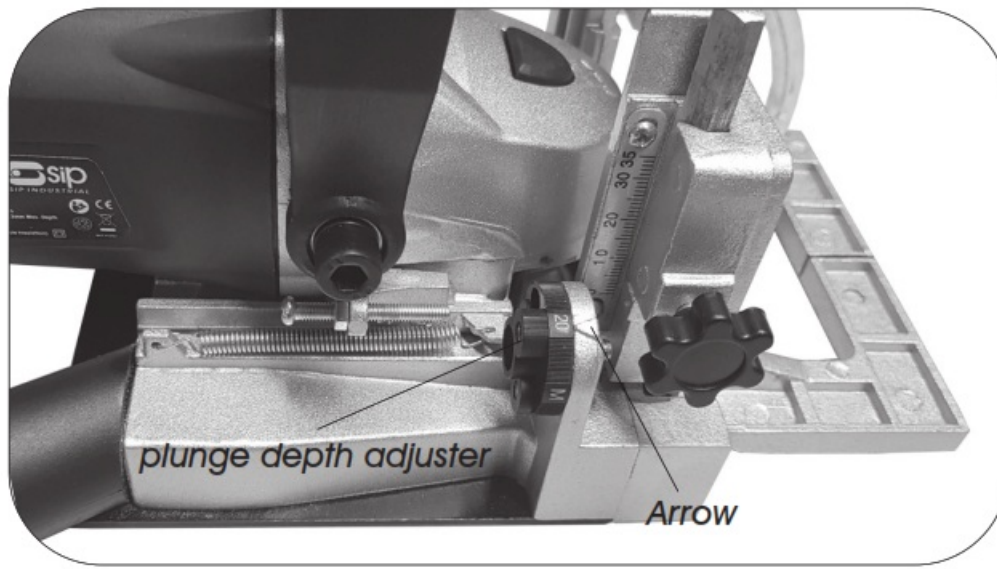
**Note:** Always use the largest possible biscuit; For materials over 25 mm (1") thick, use 2 lines of biscuits. The distance between two lines should be at least 10 cm.



## SETTING THE PLUNGE DEPTH

- The plunge depth should be set to suit the size of the biscuit being used; The numbers on the plunge depth selector (14) coincide with the most common sizes of biscuits.
- To select the plunge depth, align the appropriate number on the plunge depth selector with the arrow on the tool's housing (see below).



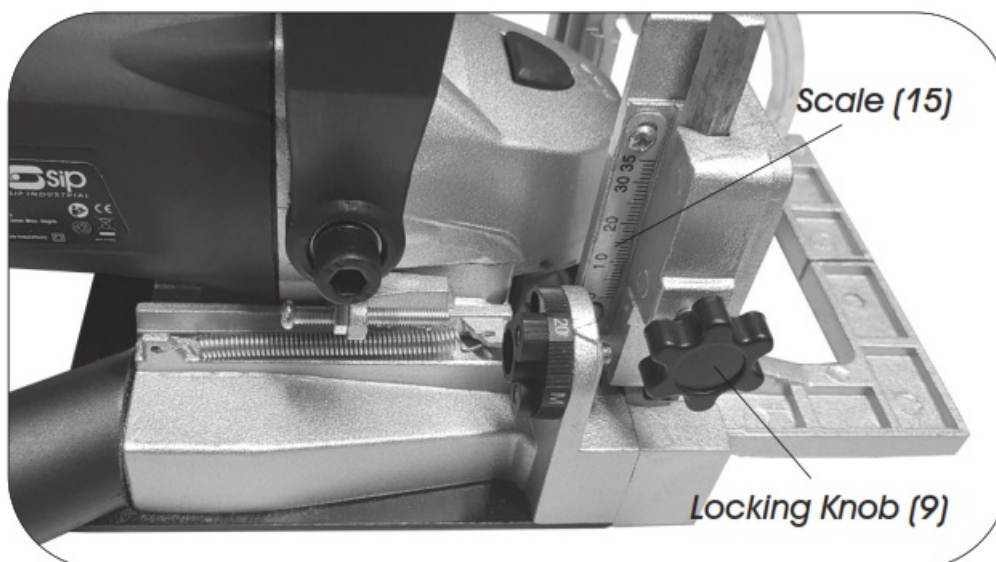


## SETTING THE HEIGHT

The adjustable fence provides a sturdy, precise reference surface to determine the point at which the slots for the biscuit will be cut. The indicated distance on the height scale (15) is the distance from the center of the cutter to the underside of the fence when the fence is set at 90°.

**To set the vertical position of the fence:**

- loosen the Height Adjust Lock / Release (9).
- Using the fence height scale (15) adjust the fence height to the required position and secure by retightening the locking knob (9).



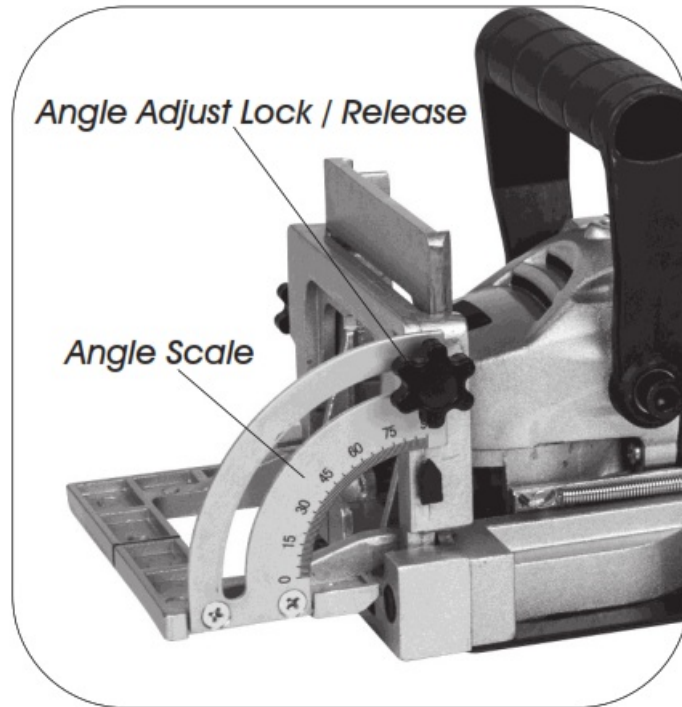
## SETTING THE ANGLE

This biscuit jointer is capable of cutting angled slots at angles between 0° and 90° which are used when strong joints are required at miter joints etc.

**To set the required angle:**

- loosen the angle and adjust the lock/release (10).
- Set the required angle using the angle scale (8) and pointer (6) and secure by retightening the angle adjust /

lock (10).



## OPERATING THE BISCUIT JOINTER

### To switch on:

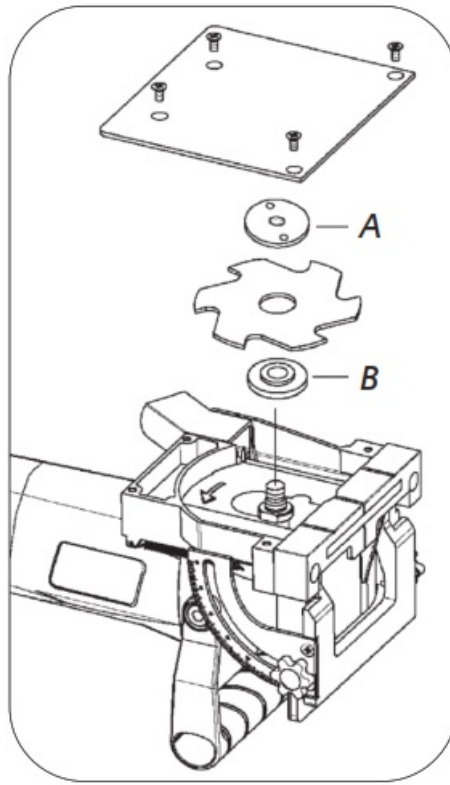
- Slide the On/Off button (1) forwards and let it engage; The biscuit jointer will now run continuously until you switch it off.
- To switch it off, simply press the rear part of the button (1) it returns automatically back into the "Off" position.



## MAINTENANCE

**Caution:** Always ensure that the biscuit jointer is turned off and that the plug is removed from the supply socket before carrying out any adjustments or maintenance.

## REPLACING THE CUTTER



- Loosen the baseplate screws and remove the baseplate (11).
- Press the spindle lock (5) and keep it pressed; At the same time insert the cutter wrench (14) into flange A and loosen the router disc by turning the flange anticlockwise.
- Remove the cutter.
- Insert the new cutter and reassemble the appliance by reversing the above steps.  
Ensure that the flange (A) is tightened firmly so that the cutter is fully secure.



**Note:** Ensure that the cutter is fitted in the correct direction.

- Refit the baseplate (11) and secure it with the screws.



**Note:** Ensure that the flange and the flange nut (A & B) are correctly fitted.

## ADJUSTING THE PLUNGE DEPTH

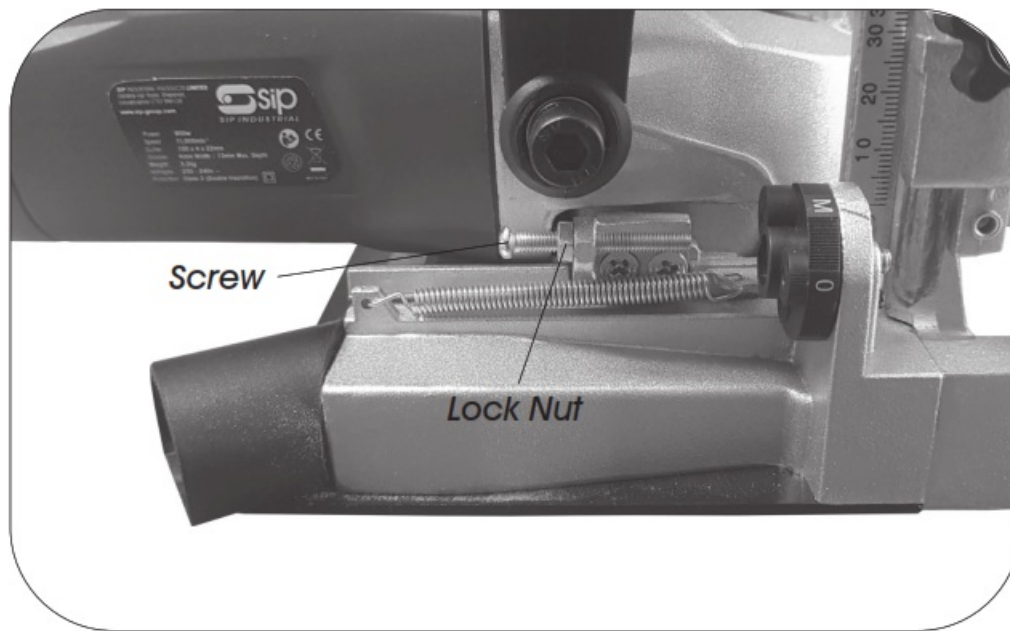
Plunge the Jointer and measure the depth of the plunge; If this does not match the depth for the selected biscuit, reset the position of the lock nut to either increase or decrease the plunge depth as required.

### To make this adjustment:

- Loosen the lock nut.
- Turn the fine-adjusting screw anti-clockwise to increase the plunge depth and clockwise to decrease the plunge depth.
- Re-tighten the lock nut.

Always check the depth of the cut by first making test cuts in a scrap piece of material. As the width and thickness

of the biscuits may vary slightly it may be necessary to select a biscuit to fit the slot or moisten the biscuits slightly to achieve a tight fit where required.



### ADJUSTING THE ANGLE POINTER

Over time the angle pointer may need to be adjusted so that it reads the correct angle.

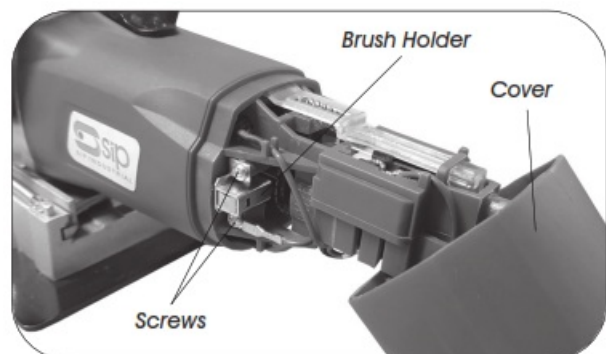
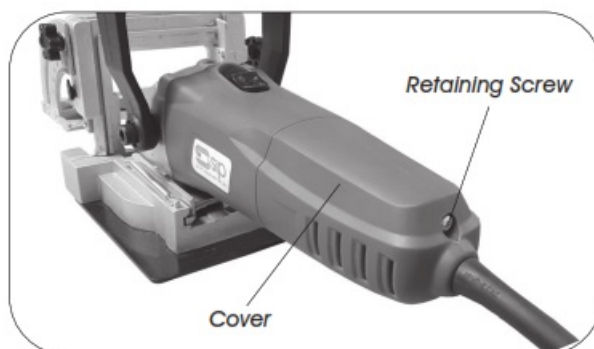
- Use a square, protractor, etc. set against the fence so that you know the exact angle that the fence is set to.
- Check the angle pointer (6) against the angle scale (8); Adjust the pointer (6) to suit.

### REPLACING THE CARBON BRUSHES

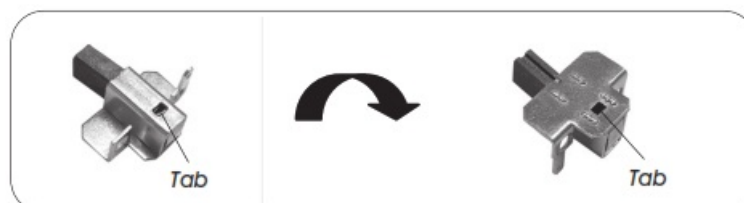


**Warning:** Ensure that the biscuit jointer is turned off and removed from the power supply before checking or changing the carbon brushes.

- Loosen and remove the screw from the outer cover (below, left).

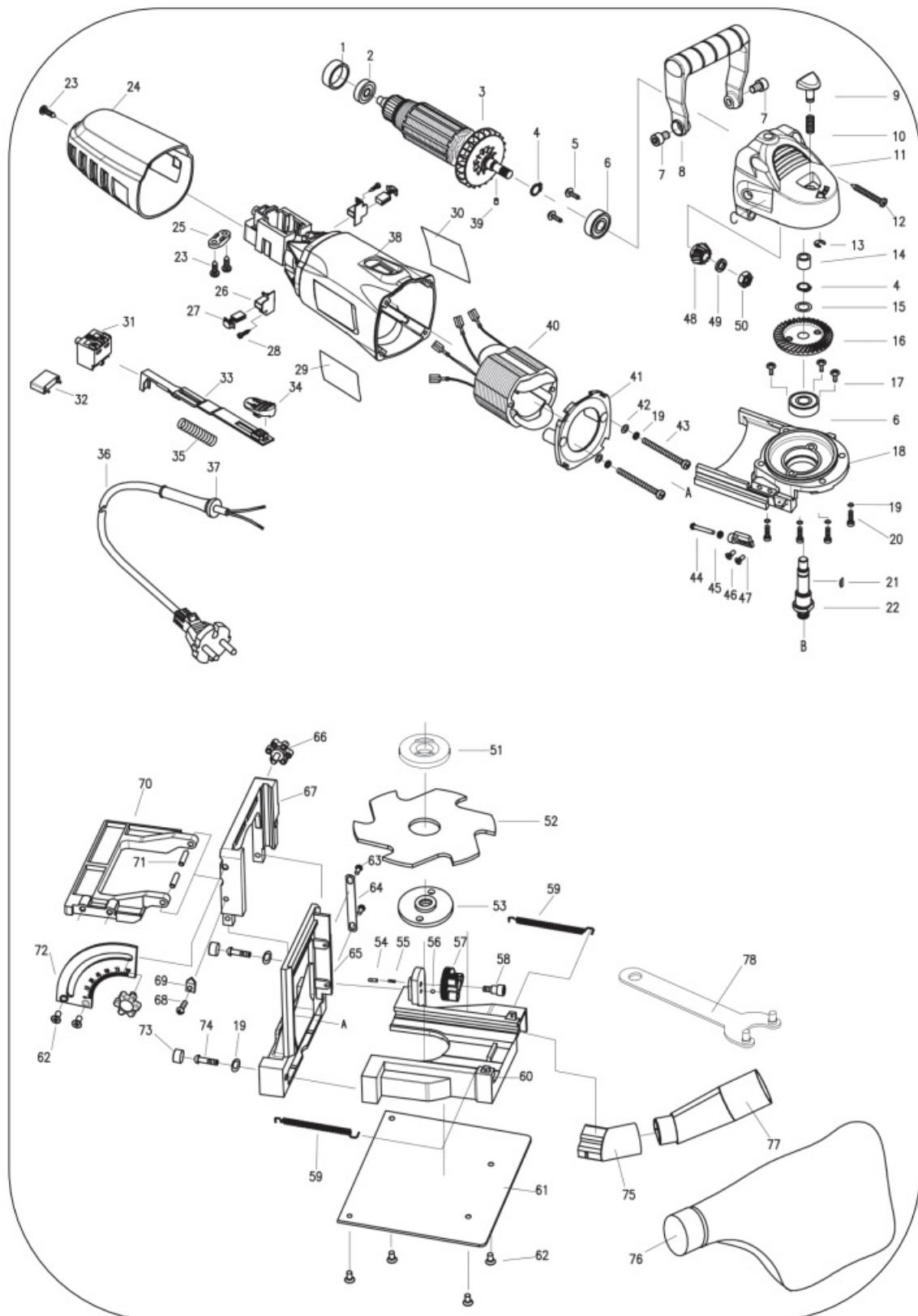


- Slide the cover back until the carbon brush holders are visible (above, right).
- Loosen and remove the brush holder screws and wire from the brush holder.
- Press the tabs on the top and bottom of the brush holder and slide the brush from the holder.



- Slide the new brush into the holder ensuring that the channel on the brush lines up and that the tabs 'click' back into place.
- Follow these instructions, in reverse to refit the brush holder, etc.

## EXPLODED DRAWING



## PARTS LIST

Ref. No	Description	Specifications	Qty.	SIP Part No.
1	Bearing Seat	Rubber	1	WD01-01300
2	Bearing	607Z	1	WD01-01301
3	Armature		1	WD01-01302
4	Circlip	Ø10	2	WD01-01303
5	Special Screw	M5X8	2	WD01-01304
6	Bearing	6000Z	2	WD01-01305
7	Screw	M8X12	2	WD01-01306
8	Front Handle	PA6	1	WD01-01307
9	Spindle Lock	PC+45#	1	WD01-01308
10	Spring	65Mn	1	WD01-01309
11	Gearbox	ADC12	1	WD01-01310
12	Self Tapping Screw	ST4.2X22	4	WD01-01311
13	Circlip	Ø5	1	WD01-01312
14	Bush	Ø12 X Ø8 X 10	1	WD01-01313
15	Spring Washer	10mm	1	WD01-01314
16	Gear	40Cr	1	WD01-01315
17	Special Screw	M4X8	3	WD01-01316
18	Front Cap	ADC12	1	WD01-01317
19	Spring Washer	4mm	6	WD01-01318
20	Screw	M4X14	4	WD01-01319
21	Woodruff Key	3X3.7X10	1	WD01-01320
22	Spindle	45#	1	WD01-01321
23	Self Tapping Screw	ST4.2X13	3	WD01-01322
24	Rear Cover	PA6GF30	1	WD01-01323
25	Mains Lead Clamp	PA6GF30	1	WD01-01324
26	Brush Holder	Q235	2	WD01-01325
27	Carbon Brush		1	WD01-01326
28	Self Tapping Screw	ST2.9X8	2	WD01-01327
29	Label		1	WD01-01328
30	Label		1	WD01-01329

31	Switch	10(10)A,125~,5E4	1	WD01-01330
32	Capacitor	0.22μf	1	WD01-01331
33	Switch Drawbar	PA6GF30	1	WD01-01332
34	Switch Button	PC	1	WD01-01333
35	Spring	65Mn	1	WD01-01334
36	Mains Lead		1	WD01-01335
37	Mains Lead Protector	PVC	1	WD01-01336
38	Main Housing	PA6GF30	1	WD01-01337
39	Roller	Ø3X4.9	1	WD01-01338
40	Stator		1	WD01-01339
41	Fan Guide	PA6GF30	2	WD01-01340
42	Washer	Ø4	2	WD01-01341
43	Screw	M4X58	1	WD01-01342
44	Screw	M4X30	1	WD01-01343
45	Nut	M4	2	WD01-01344
46	Screw	M4X8	1	WD01-01345
47	Depth Base Block	ADC12	1	WD01-01346
48	Pinion	20CrMnTi	1	WD01-01347
49	Spring Washer	Ø8	1	WD01-01348
50	Nut	M8	1	WD01-01349
51	Flange	45#	1	WD01-01350
52	Cutter (blade)	Ø100mm	1	WD01-01351
53	Flange Nut	45#	1	WD01-01352
54	Screw	M4	1	WD01-01353
55	Spring		1	WD01-01354
56	Steel Ball	Ø3mm	1	WD01-01355
57	Plunge Depth Selector	ABS	1	WD01-01356
58	Screw	M5X12	2	WD01-01357
59	Spring		1	WD01-01358
60	Slide Plate	ADC12	1	WD01-01359

61	Base Plate	Q235	6	WD01-01360
62	Screw	M4X6	2	WD01-01361
63	Screw	M3X6	1	WD01-01362
64	Depth Scale	0.5mm	1	WD01-01363
65	Support Stand Board	ADC12	2	WD01-01364
66	Thumbscrew	PA6+45	1	WD01-01365
67	Angle Fence	ADC12	1	WD01-01366
68	Screw	M4X14	1	WD01-01367
69	Angle Pointer	ABS	1	WD01-01368
70	Pivot Bracket	ADC12	2	WD01-01369
71	Dowel	45	1	WD01-01370
72	Angle Scale		2	WD01-01371
73	Cap	EVA	2	WD01-01372
74	Screw	M4X16	1	WD01-01373
75	Dust Collector Port	ABS	1	WD01-01374
76	Dust Bag	ABS+fabric	1	WD01-01375
77	Dust Collection Adaptor	ABS	1	WD01-01376
78	Cutter Wrench	Q235	1	WD01-01377

## DECLARATION OF CONFORMITY

Declaration of Conformity

We

SIP (Industrial Products) Ltd

Gelders Hall Road

Shepshed

Loughborough

Leicestershire

LE12 9NH

England

As the manufacturer's authorized representative within the EC declare that the  
Biscuit Jointer – SIP Part No. 07904

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC 2014/30/EU 2011/65/EU As Amended By (EU) 2015/863	Machinery Directive EMC Directive RoHS Directive
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And the relevant harmonised standard(s), including,  
EN 55014-1:2006+A1+A2  
EN 55014-1:2017  
EN 55014-2:2015  
EN 61000-3-2:2014  
EN 61000-3-3:2013  
EN 60745-1:2009+A11  
EN60745-2-19:2009+A1



Signed: .....

Mr. P. Ippaso – Director – SIP (Industrial Products) Ltd

Date: 18/09/2019.



Please dispose of the packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip, and place it into the appropriate recycling bin.



Never dispose of electrical equipment or batteries in your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognized re-cycling agent. This will allow the recycling of raw materials and help protect the environment.

**FOR HELP OR ADVICE ON THIS PRODUCT PLEASE CONTACT YOUR DISTRIBUTOR,  
OR SIP DIRECTLY ON:**

**TEL: 01509 500400**

**EMAIL: [sales@sip-group.com](mailto:sales@sip-group.com) or [technical@sip-group.com](mailto:technical@sip-group.com)**

**[www.sip-group.com](http://www.sip-group.com)**

**Ref: 180919 07904V2**

## Documents / Resources



[sip 07904 Biscuit Jointer](#) [pdf] User Manual  
07904 Biscuit Jointer, 07904, Biscuit Jointer, Jointer

## References

- [Group Publishing](#)
- [SIP Industrial Products Ltd Official Website - SIP Industrial Products Ltd Official Website](#)
- [Circular saw - Wikipedia](#)
- [Engineered wood - Wikipedia](#)
- [Joinery - Wikipedia](#)