



## user manual

Instrukcja obsługi | Руководство пользователя  
Manuel de l'Utilisateur | Betriebsanweisung  
Bruksanvisning | Manual del Usuario  
Betjeningsvejledning | Gebruikershandleiding  
Käyttöohjeet | Manual de utilizare | Bruksanvisning  
Manuale d'uso | Příručka uživatele | Navodila  
za uporabo

Retain for future use  
Zachować do przyszłego użytku  
Сохраните для последующего  
использования  
A conserver pour une utilisation future  
Für zukünftige Benutzung aufbewahren  
Behold for senere bruk  
Säilytä nämä käyttöohjeet tulevaa tarvetta marten  
Opbevar manualen til fremtidig brug  
Bewaren voor gebruik in de toekomst  
Conservare il presente manuale a l'uso futuro  
Păstrați acest manual pentru utilizare viitoare  
Conservar para futuras consultas  
Behall för framtida användning  
Uchovejte pro další použití  
Hranite za prihodnjo uporabo



# Horizontal Resaw HR500

## Safety, Operation, Maintenance & Parts Manual

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HR500E11S	rev. B4.00
(HR1-6E11S)	rev. B4.00
HR500E15S	rev. B4.00
(HR1-6E15S)	rev.B4.00

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**Safety is our #1 concern!** Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

*Form #1006*

**This is the original language  
for the manual.**

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## Getting Service

Wood-Mizer is committed to providing you with the latest technology, best quality and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we're meeting current wood-processing demands. Your comments and suggestions are welcome.

### *General Contact Information*

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Koło, Nagórna 114 St, Poland at **+48-63-2626000**. From the continental U.S., call our U.S. Headquarter 8180 West 10th St. Indianapolis, IN 46214, toll-free at **1-800-525-8100**. Ask to speak with a Customer Service Representative. Please have your machine identification number and your customer number ready when you call. The Service Representative can help you with questions about the operation and maintenance of your machine. He also can schedule you for a service call.

### **Office Hours:**

<b>Country</b>	<b>Monday - Friday</b>	<b>Saturday</b>	<b>Sunday</b>
Poland	7 a.m.- 3 p.m.	Closed	Closed
US	8 a.m.- 5 p.m.	8 a.m.- 12 p.m	Closed

Please have your vehicle identification number and your customer number ready when you call.

Wood-Mizer will accept these methods of payment:

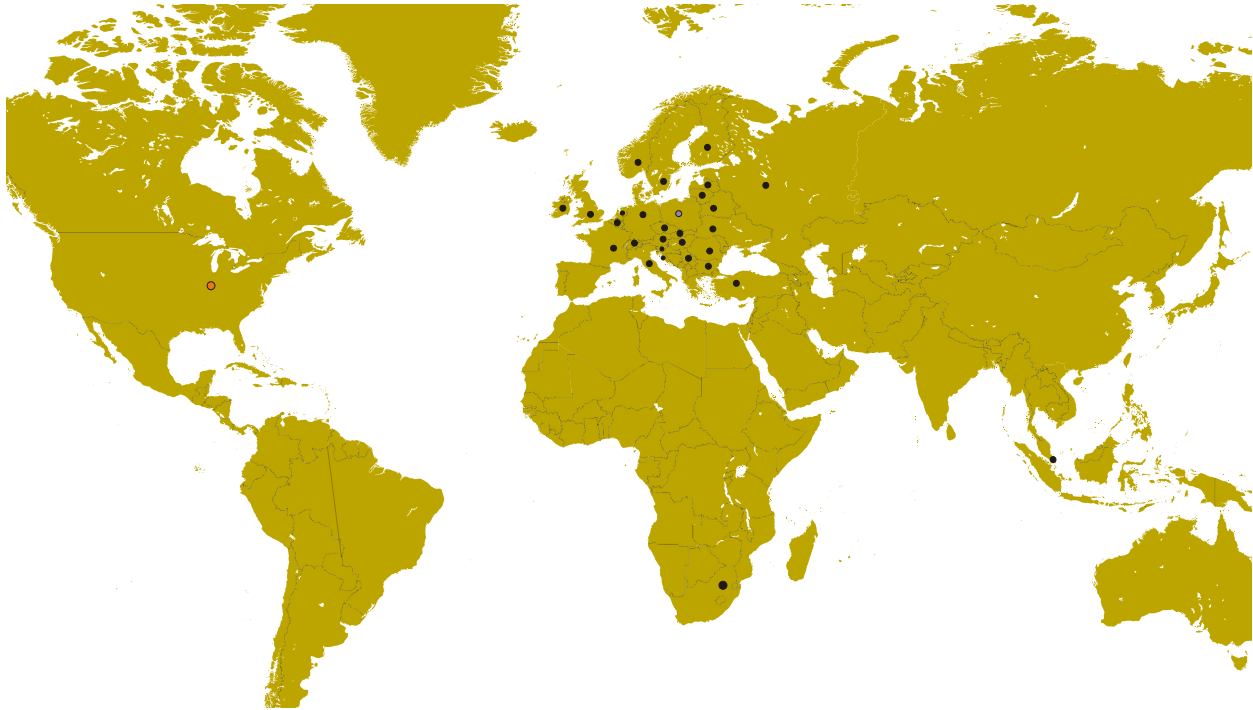
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)



Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

Technical data are subject to change without prior notice.

Actual product may differ from product images. Some illustrations show machines with optional equipment.

**Branches & Authorized Sales Centers Wood-Mizer Locations (North and South America)**



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## Branches & Authorized Sales Centers

For a complete list of dealers, visit [www.woodmizer.com](http://www.woodmizer.com)

## SECTION 1 SAFETY

### 1.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions.



**DANGER!** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING!** suggests a potentially hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION!** refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury or damage to equipment.



**IMPORTANT!** indicates vital information.

**NOTE:** gives helpful information.



Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

## 1.2 Safety Instructions



**IMPORTANT!** The Resaw is intended for sawing wood only. The resaw must not be used for other purposes such as cutting ice, metal or any other materials. [See Section 5.2](#) for log size capacities of the machine.

**IMPORTANT!** The operator of the resaw should get adequate training in the operation and adjustment of the machine.

**NOTE:** ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding only equipment damage appear where applicable throughout the manual.

### *Observe Safety Instructions*



**IMPORTANT!** Read the entire Operator's Manual before operating the resaw. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

Only adult persons who have read and understood the entire operator's manual should operate the resaw. The resaw is not intended for use by or around children.

**IMPORTANT!** It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer resaw. All Wood-Mizer resaw owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.

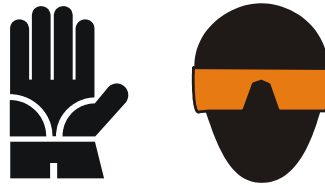


### Wear Safety Clothing



**WARNING!** Secure all loose clothing and jewelry before operating the resaw. Failure to do so may result in serious injury or death.

**WARNING!** Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or changing a blade. Failure to do so may result in serious injury.



**WARNING!** Always wear eye, ear, respiration, and foot protection when operating or servicing the resaw.



### Keep Resaw And Area Around Resaw Clean



**DANGER!** Maintain a clean and clear path for all necessary movement around the resaw and lumber stacking areas. Failure to do so will result in serious injury.

### Dispose Of Sawing By-Products Properly



**IMPORTANT!** Always properly dispose of all sawing by-products, including sawdust and other debris.

### Check Resaw Before Operation




**DANGER!** Make sure all guards and covers are in place and secured before operating the resaw. Failure to do so may result in serious injury.







### **Keep Persons Away**

 **DANGER!** Keep all persons out of the path of moving equipment and lumber when operating the resaw. Failure to do so will result in serious injury.

**DANGER!** Always be sure all persons are out of the path of the blade before starting the motor. Failure to do so will result in serious injury.

 **WARNING!** Allow blade to come to a complete stop before opening the blade housing cover. Failure to do so will result in serious injury.

### **Keep Hands Away**

 **DANGER!** Always shut off the blade motor before changing the blade. Failure to do so will result in serious injury.

**DANGER!** Motor components can become very hot during operation. Avoid contact with any part of a hot motor. Contact with hot motor components can cause serious burns. Therefore, never touch or perform service functions on a hot motor. Allow the motor to cool sufficiently before beginning any service function.

**DANGER!** Always keep hands away from moving bandsaw blade. Failure to do so will result in serious injury.

**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.



**WARNING!** Use extreme caution when spinning the blade wheels by hand. Make sure hands are clear of blade and wheel spokes before spinning. Failure to do so may result in serious injury.

### **Use Proper Maintenance Procedures**



**DANGER!** Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.

**DANGER!** Hazardous voltage inside the electric boxes and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during resaw operation.



**WARNING!** Consider all electrical circuits energized and dangerous.

**WARNING!** Disconnect and lock out power supply before servicing the resaw! Failure to do so may result in serious injury.

**WARNING!** Never assume or take the word of another person that the power is off; check it out and lock it out.

**WARNING!** Do not wear rings, watches, or other jewelry while working around an open electrical circuit.

**WARNING!** Remove the blade before performing any service to the motor or resaw. Failure to do so may result in serious injury.

**DANGER!** Never clean the blade or blade wheels using the hand-held brush or scraper whilst the resaw blade is in motion.

**CAUTION!** Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.

**CAUTION!** Always wear gloves when handling the blade. Never grab the blade with bare hands!

**CAUTION!** If the blade breaks during resaw operation, push the EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing cover.

**CAUTION!** The resaw's work-stand should be equipped with a 4 kg or bigger dry powder extinguisher.

### ***Keep Safety Labels In Good Condition***

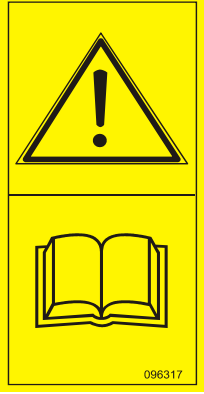

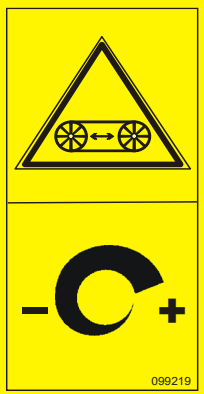


**IMPORTANT!** Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order more decals.

**IMPORTANT!** If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed.

See Table 1-1. Pictogram decals used to warn and inform the user about danger in the resaw.




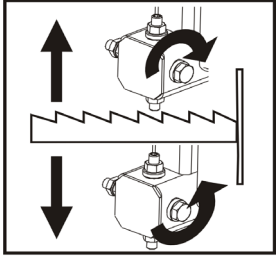
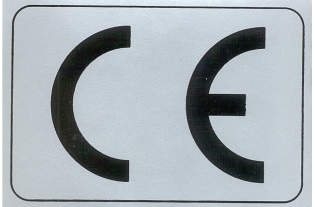
TABLE 1-1

Decal View	W-M No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the machine. Observe all safety instructions and rules when operating the resaw.
	099220	CAUTION! Close all guards and covers before starting the machine.
	099219	Blade tension. Turning the bolt clockwise will increase the blade tension and turning the bolt counterclockwise will decrease the tension.

**TABLE 1-1**

	<p>099221</p>	<p>CAUTION! Keep all persons a safe distance away from work area when operating the machine.</p>
	<p>099222</p>	<p>CAUTION! Sawdust outlet. Protect eyes!</p>
	<p>096321</p>	<p>Blade movement direction</p>
	<p>S12004G</p>	<p>CAUTION! Always wear safety goggles when operating the resaw!</p>
	<p>S12005G</p>	<p>CAUTION! Always wear protective ear muffs when operating the resaw!</p>

TABLE 1-1

	501465	CAUTION! Always wear safety boots when operating the resaw.
	512107	CAUTION! Always wear safety gloves when operating the resaw.
	501467	Lubrication Point
	P11789	Aligning the blade on the wheels
	P85070	CE sign

**TABLE 1-1**



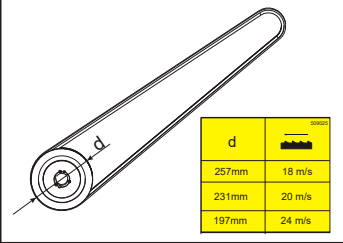




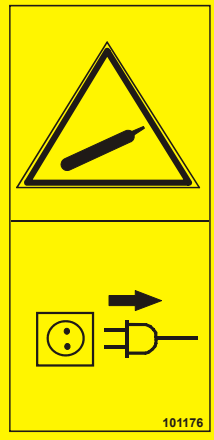

	<p>099401</p>	<p>Russian safety certification sign</p>																											
	<p>S20097</p>	<p>Motor rotation direction</p>																											
 <table border="1" data-bbox="443 1059 576 1178"> <thead> <tr> <th>d</th> <th>Linear speed</th> </tr> </thead> <tbody> <tr> <td>257mm</td> <td>18 m/s</td> </tr> <tr> <td>231mm</td> <td>20 m/s</td> </tr> <tr> <td>197mm</td> <td>24 m/s</td> </tr> </tbody> </table>	d	Linear speed	257mm	18 m/s	231mm	20 m/s	197mm	24 m/s	<p>509025</p>	<p>Blade drive wheel diameter-blade linear speed</p>																			
d	Linear speed																												
257mm	18 m/s																												
231mm	20 m/s																												
197mm	24 m/s																												
	<p>505346</p>	<p>TVS Tensioner Valve Handle Positions</p>																											
<table border="1" data-bbox="244 1453 587 1637"> <thead> <tr> <th rowspan="2">Type</th> <th colspan="2">  </th> <th rowspan="2">psi</th> <th rowspan="2">bar</th> </tr> <tr> <th>F[mm]</th> <th>E[mm]</th> </tr> </thead> <tbody> <tr> <td>275</td> <td>1,07</td> <td>32</td> <td>830-850</td> <td>57-59</td> </tr> <tr> <td>375 376</td> <td>1,14</td> <td>32 38</td> <td>745-765</td> <td>51-53</td> </tr> <tr> <td>2735</td> <td>1,07</td> <td>35</td> <td>805-825</td> <td>55-57</td> </tr> <tr> <td>576 476</td> <td>1,27 1,40</td> <td>38</td> <td>715-735</td> <td>49-51</td> </tr> </tbody> </table>	Type			psi	bar	F[mm]	E[mm]	275	1,07	32	830-850	57-59	375 376	1,14	32 38	745-765	51-53	2735	1,07	35	805-825	55-57	576 476	1,27 1,40	38	715-735	49-51	<p>505348</p>	<p>Blade Tension Values</p>
Type						psi	bar																						
	F[mm]	E[mm]																											
275	1,07	32	830-850	57-59																									
375 376	1,14	32 38	745-765	51-53																									
2735	1,07	35	805-825	55-57																									
576 476	1,27 1,40	38	715-735	49-51																									

TABLE 1-1

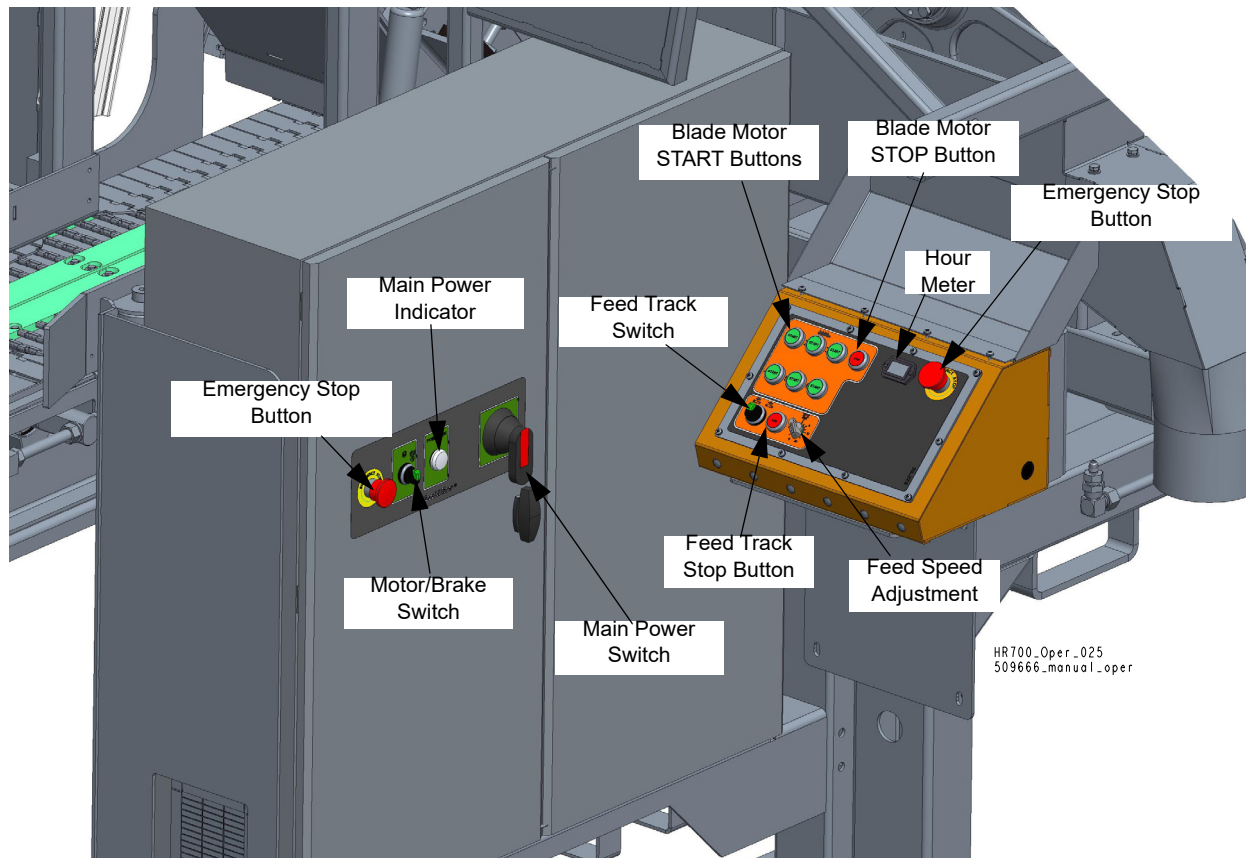
 <p>101176</p>	101176	CAUTION! Compressed air in the system even after electric power disconnection
 <p><b>6 bar</b> <b>0.6 MPa</b></p> <p>513181</p>	513181	Pressure value of the pneumatic system



## SECTION 2 OPERATION

### 2.1 Control Overview


See **Figure 2-1**. The control panel includes switches to start and stop the feed track and the saw head.




**FIG. 2-1 CONTROL PANEL AND MAIN ELECTRIC BOX**

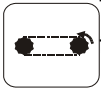
#### Control Panel

##### 1. Blade Drive

To start the blade motor, turn the key switch to the  position. Then press the START button. Each saw head is started with separate START button. To stop the blade motors, press the STOP switch.

 **CAUTION!** Wait five (5) seconds between the start of each saw head motor to avoid high peak demand currents.

##### 2. Feed Track



To start spinning the feed track forward or backward, turn the switch left or right. To stop the feed track, press the STOP button

### 3. Feed Track Speed Adjustment



The feed track speed switch controls the speed at which the feed track moves. Turn the switch clockwise to increase the speed, counterclockwise to reduce the speed.

### 4. Emergency Stop

Push the emergency stop button to stop the blades and the track feed motor. Turn the emergency stop clockwise to release the stop. The resaw will not restart until the emergency stop is released.



### 5. Hour Meter

Records work hours of the machine.

#### Main Electric Box

#### 1. Key Switch

The key switch has three positions:

- "0" position - all electrical circuits are off,
-  position - all electrical circuits are on,
-  position - releases the motor disk brake; the blade and the track feed motors are off.

#### 2. Emergency Stop

Push the emergency stop button to stop the blades and the track feed motor. Turn the emergency stop clockwise to release the stop. The resaw will not restart until the emergency stop is released.

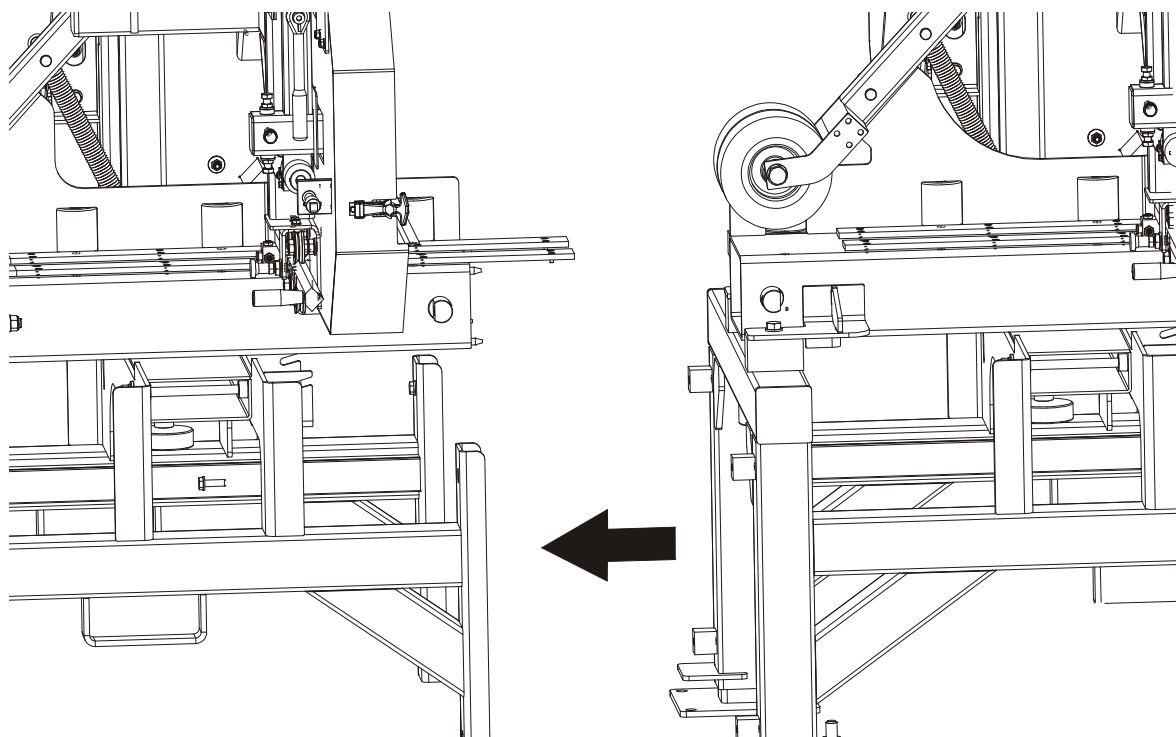
#### 3. Main Power Switch

Disconnects power from all electric circuits of the machine.

## 2.2 Resaw Setup

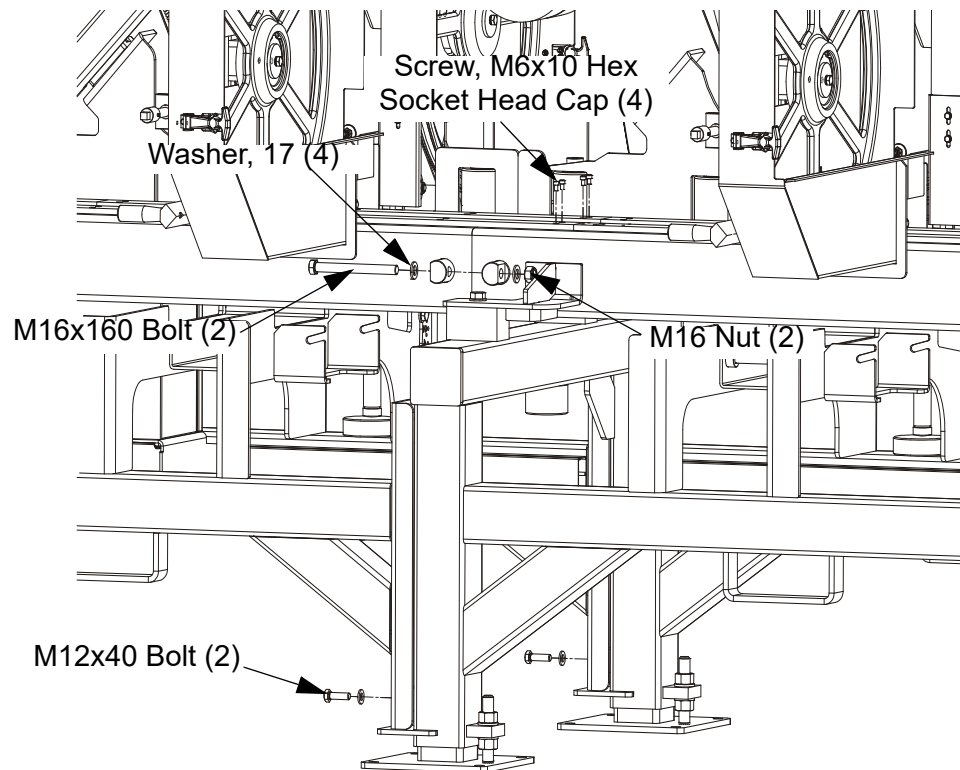
The Horizontal Resaw is delivered to the customer place in modules. The HR modules must be mounted together.

See **Figure 2-2**. Attach the base to the additional module (or modules).



**FIG. 2-2**

See **Figure 2-3**. Using the appropriate bolts, washers and nuts, mount the base and the additional module (modules) together.



**FIG. 2-3**

See Figure 2-4. Mount the feed chain drive module.

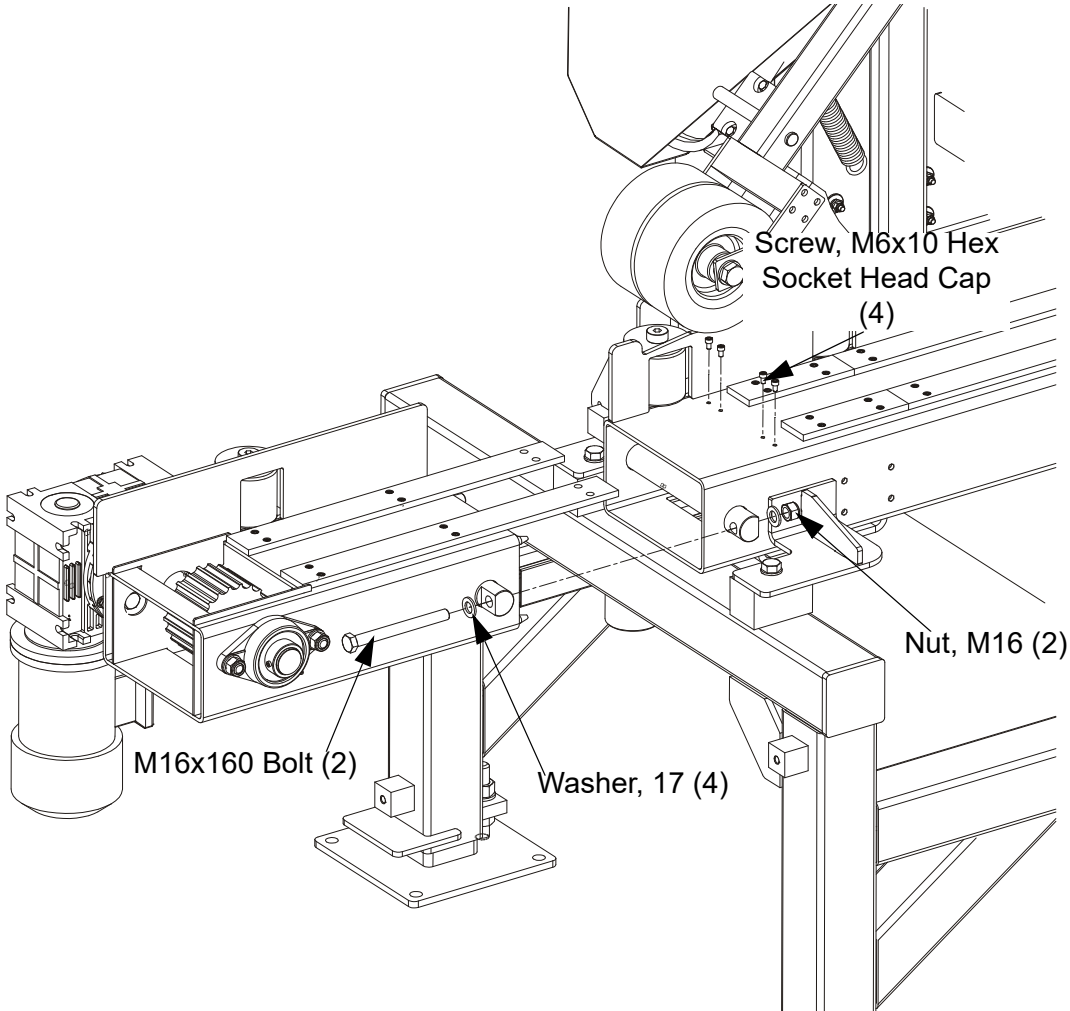


FIG. 2-4

See Figure 2-5. Mount the feed chain and apply proper tension. [See Section 4.8](#)

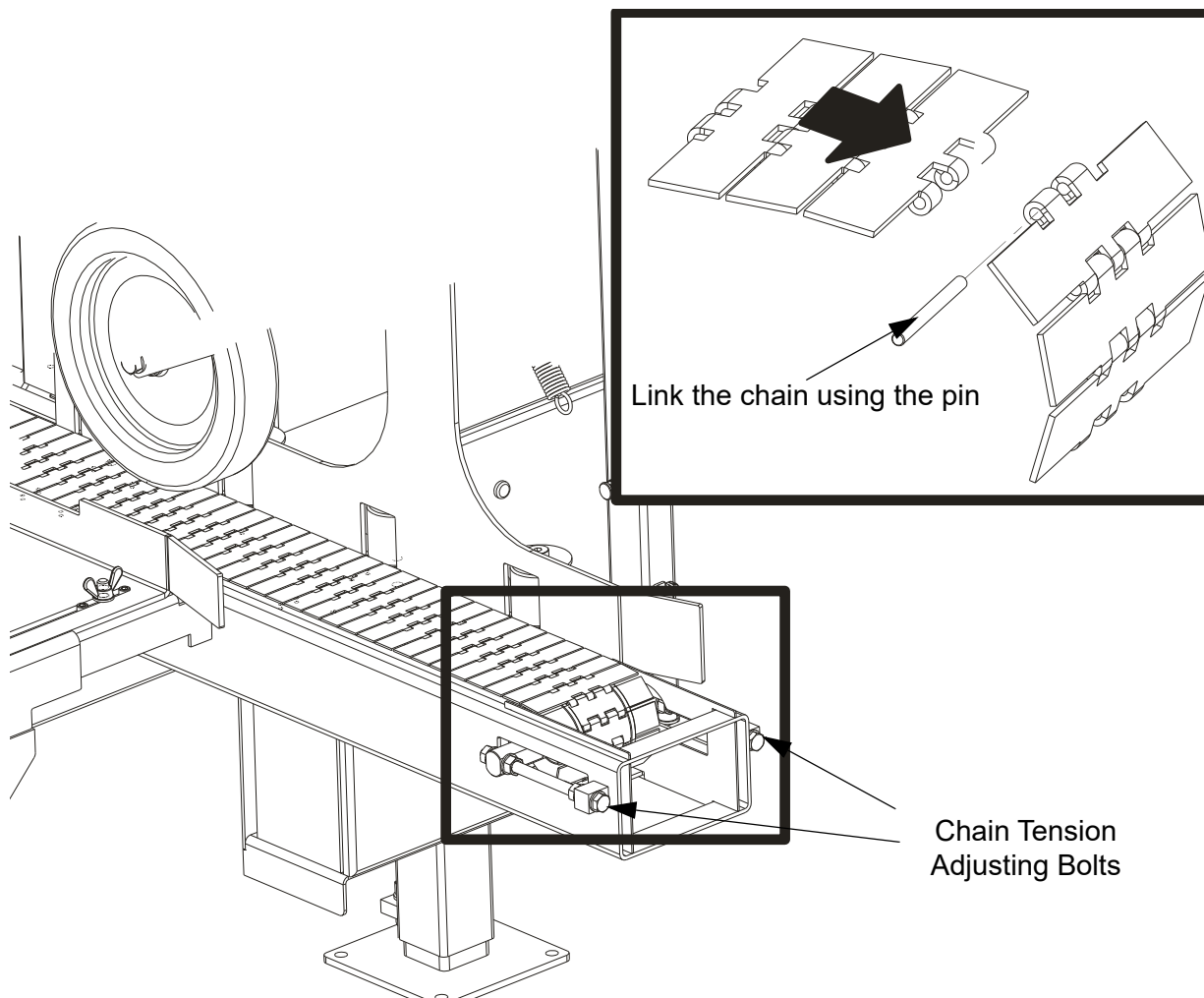


FIG. 2-5



**IMPORTANT!** Before starting to use any HR resaw equipped with return tables, move the control panel and the rear e-stop to the locations shown in the figures 2-6 to 2-11 (depending on the resaw configuration).



**IMPORTANT!** Before starting to use the resaw, you have to meet the following conditions:

- Set up the resaw on firm and level ground. Secure the saw to the ground to prevent moving during operation. A concrete foundation or pads and anchored bolts are recommended.
- The resaw can be operated with the sawdust collection system only.
- The resaw can be operated under roof only.

- The resaw can be operated in temperature range from -15° C to 40° C (5°F to 104°F) only.
- The illumination at the operator's position should be at least 300lx<sup>1</sup>.
- Have a qualified electrician install the power supply (according to EN 60204 Standard). The power supply must meet the specifications given in the table below.



**DANGER!** It is recommended that a 30mA Ground Fault Interrupter (GFI) be used.

Depending on the number of saw heads, you should use different circuit breakers and power cord cross sections. See the tables below for the required connection specifications.

See Table 2-1.

<i>Type</i>	<i>Power Supply Voltage</i>	<i>Nominal Power</i>	<i>Preffered overcurrent protection Nominal Load</i>	<i>Preffered size of wires for Power supply mm<sup>2</sup></i>	<i>Preffered size of wires for Power supply AWG</i>
HR500EB15-4	230V/50Hz	45,5kW	160A	35 mm <sup>2</sup>	2
HR500EC15-1	460V/60Hz	14kW	25A	4 mm <sup>2</sup>	11
HR500EC15-2	460V/60Hz	27kW	40A	6 mm <sup>2</sup>	9
HR500EC15-3	460V/60Hz	39kW	63A	10 mm <sup>2</sup>	7
HR500EC15-4	460V/60Hz	52kW	90A	16 mm <sup>2</sup>	5
HR500EC15-5	460V/60Hz	64,5kW	120A	25 mm <sup>2</sup>	3
HR500EC15-6	460V/60Hz	77kW	140A	35 mm <sup>2</sup>	2
HR500EH11S-1	400V/50Hz	9kW	16A	2,5 mm <sup>2</sup>	13
HR500EH15(S)-1	400V/50Hz	12,5kW	25A	4 mm <sup>2</sup>	11
HR500EH15(S)-2	400V/50Hz	23,5kW	40A	6 mm <sup>2</sup>	9
HR500EH15(S)-3	400V/50Hz	34,5kW	63A	10 mm <sup>2</sup>	7
HR500EH15(S)-4	400V/50Hz	45,5kW	90A	16 mm <sup>2</sup>	5
HR500EH15(S)-5	400V/50Hz	56,5kW	120A	25 mm <sup>2</sup>	3
HR500EH15(S)-6	400V/50Hz	67,5kW	140A	35 mm <sup>2</sup>	2

1. The light source can not cause stroboscopic effect.

### Electrical Requirements (US Version Only)



**DANGER!** Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.



**CAUTION!** The resaw motors and the transformer are prewired for 480 V, 60 Hz power supplies. If you plan to use a 480 V, 60 Hz mill with another type of power supply, you will need to rewire the motor to avoid damage to the machine.

The electrical requirements for the resaw are listed below. **IMPORTANT!** The resaw is wired for use with a 480 volt power supply. To operate the resaw with 240V or 380-415V power supplies, a transformer is required. Refer to the table below:

See Table 2-2.

Conversion From/To	240 to 480 volts			380-415 to 480 volts		
	No. of Heads	2	4	6	2	4
Mfg. Part No.	EE30T3118H	EE45T3065H	EE75T3065H	EE30T2611H	EE45T2611H	EE75T2611H
AWMV Part No.	069712	069711	068057	069616	068054	068055

TABLE 2-2

See Table 2-3. The machine FLA required for the resaw is listed below.

Motor HP	Power Supply			Machine FLA/# of Heads		
	Volts	PH	Hz	2	4	6
25	240 <sup>1</sup>	3	50/60	125	188	313
	380-415 <sup>1</sup>	3	50	75	113	188
	480	3	60	50	95	140

TABLE 2-3

<sup>1</sup> Transformer Required. FLAs include a transformer.



- All possible HR resaw and return tables configurations, operator's positions and E-STOP locations are shown in the figures below.

See Figure 2-6. Layout of the MRTHR6-M resaw (6-head HR for 1.5-3.6m (4.9- 11.8 ft) logs)

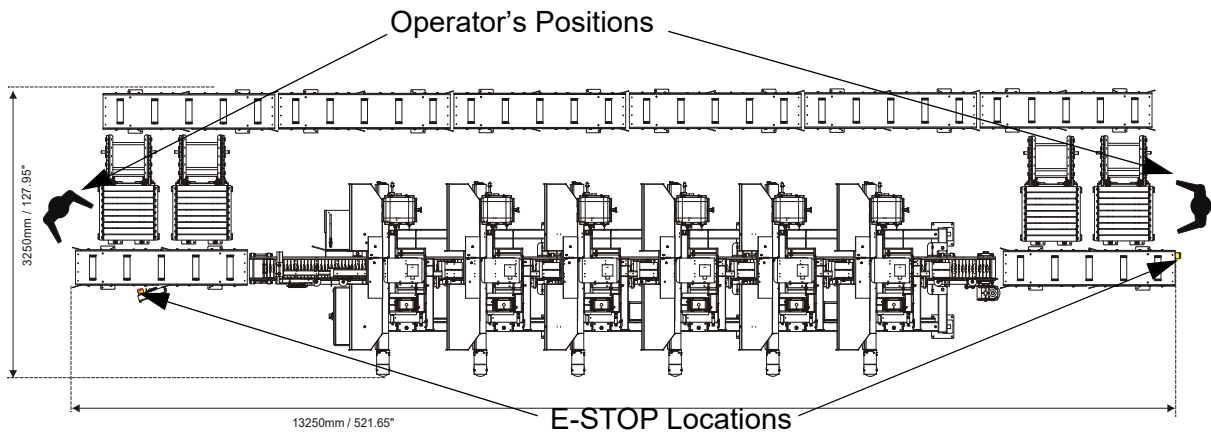


FIG. 2-6

See Figure 2-7. Layout of the MRTHR6-S resaw (6-head HR for logs <1.5m ( 4.9 ft ))

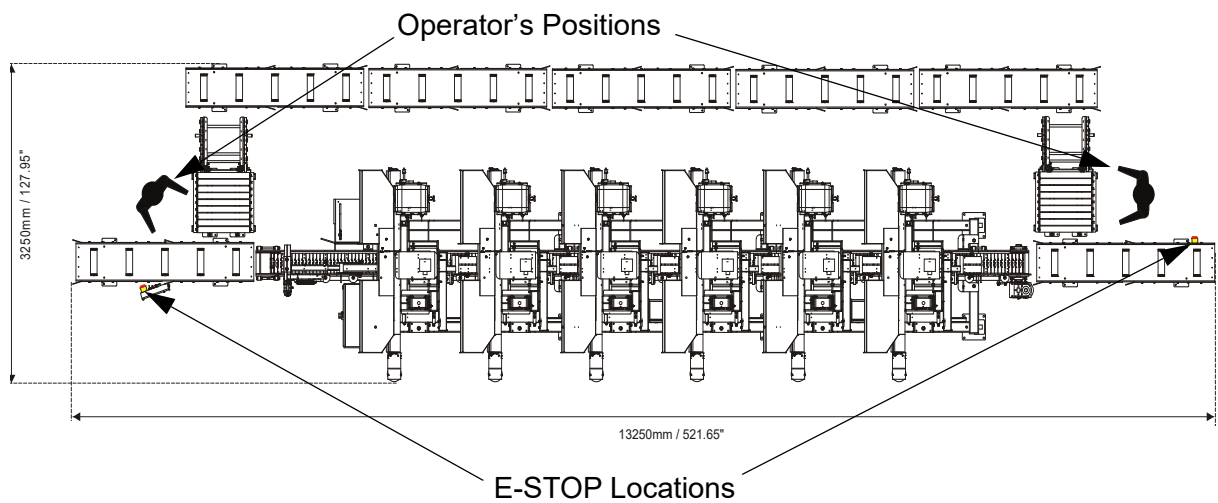


FIG. 2-7

See Figure 2-8. Layout of the MRTHR4-M resaw (4-head HR for 1.5-3.6m (4.9- 11.8 ft) logs)

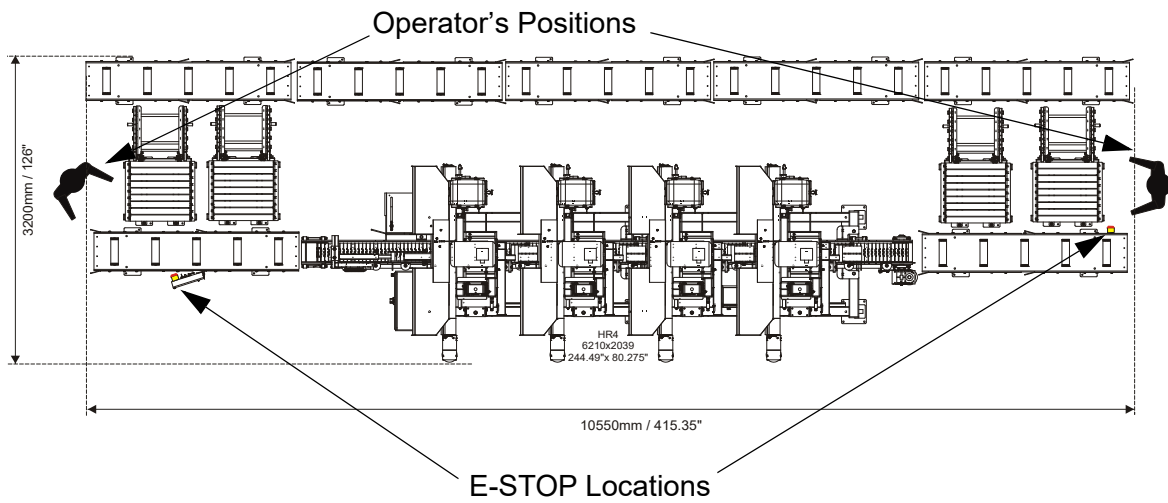


FIG. 2-8

See Figure 2-9. Layout of the MRTHR4-S resaw (4-head HR for logs <1.5m (4.9 ft))

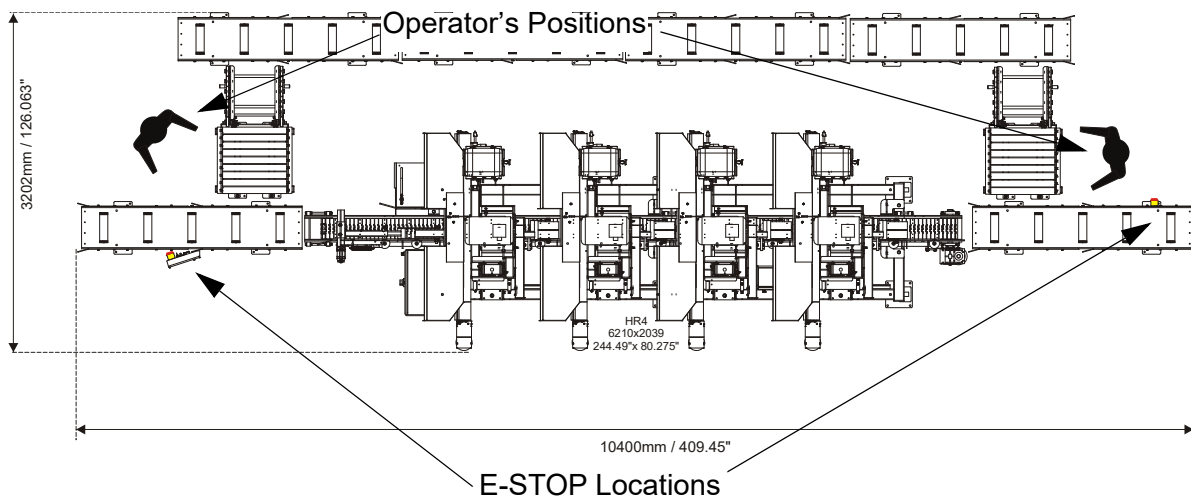


FIG. 2-9

See Figure 2-10. Layout of the MRTHR2-M resaw (2-head HR for 1.5-3.6m (4.9- 11.8 ft) logs)

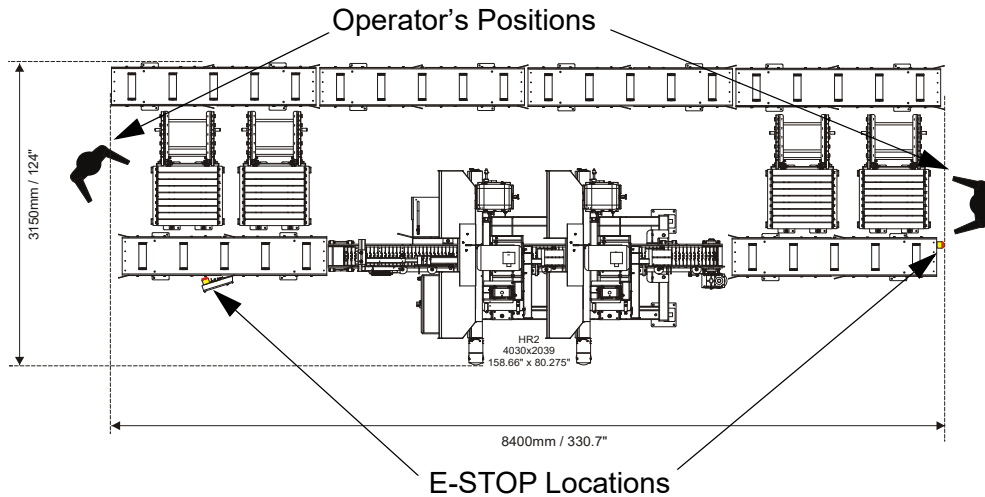


FIG. 2-10

See Figure 2-11. Layout of the MRTHR2-S resaw (2-head HR for logs <1.5m (4.9 ft ))

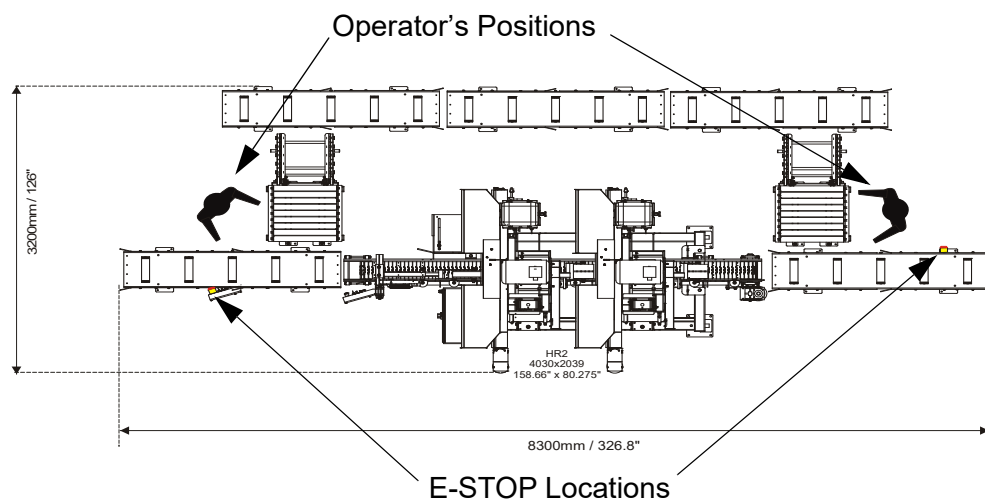


FIG. 2-11



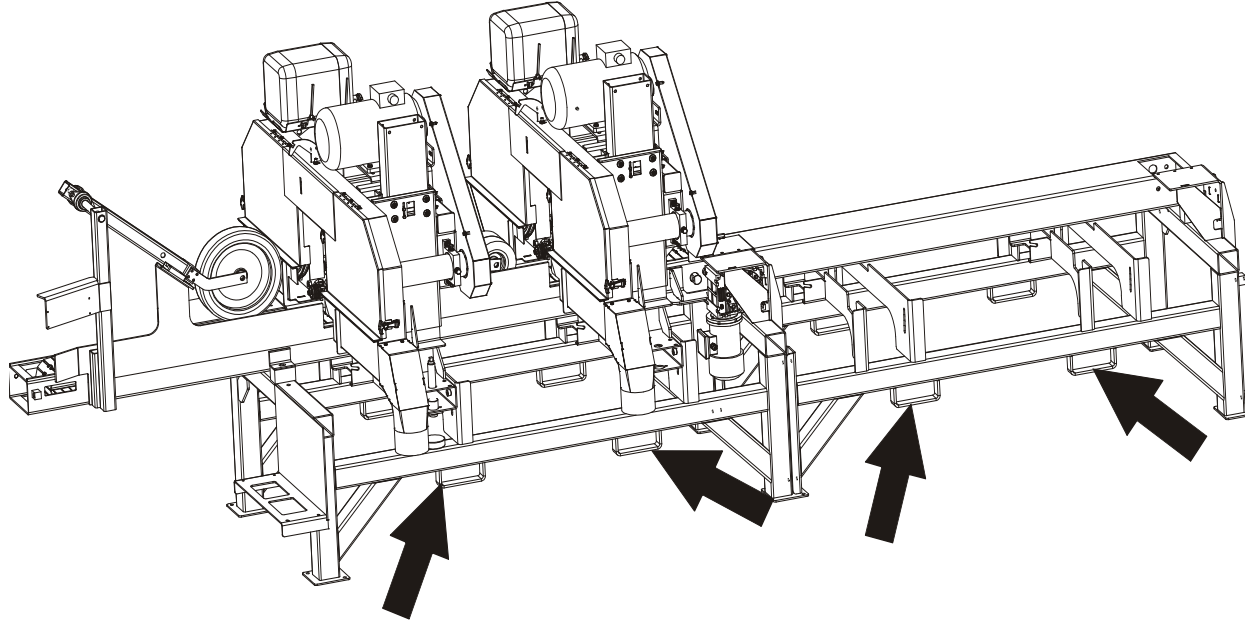
**IMPORTANT!** When starting the machine for the first time, check that the main motor rotation direction is as indicated by the arrow located on the motor body (fan guard). If the rotation direction is incorrect, invert the phases in the phase inverter located in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of all resaw motors.

# 2

## Operation


### *Electrical Requirements (US Version Only)*


- The resaw can be lifted using a forklift only. The forklift must be rated for at least 2000kg (4410 lb). The resaw is equipped with forklift pockets. Insert the forks into the pockets shown in the figure below.



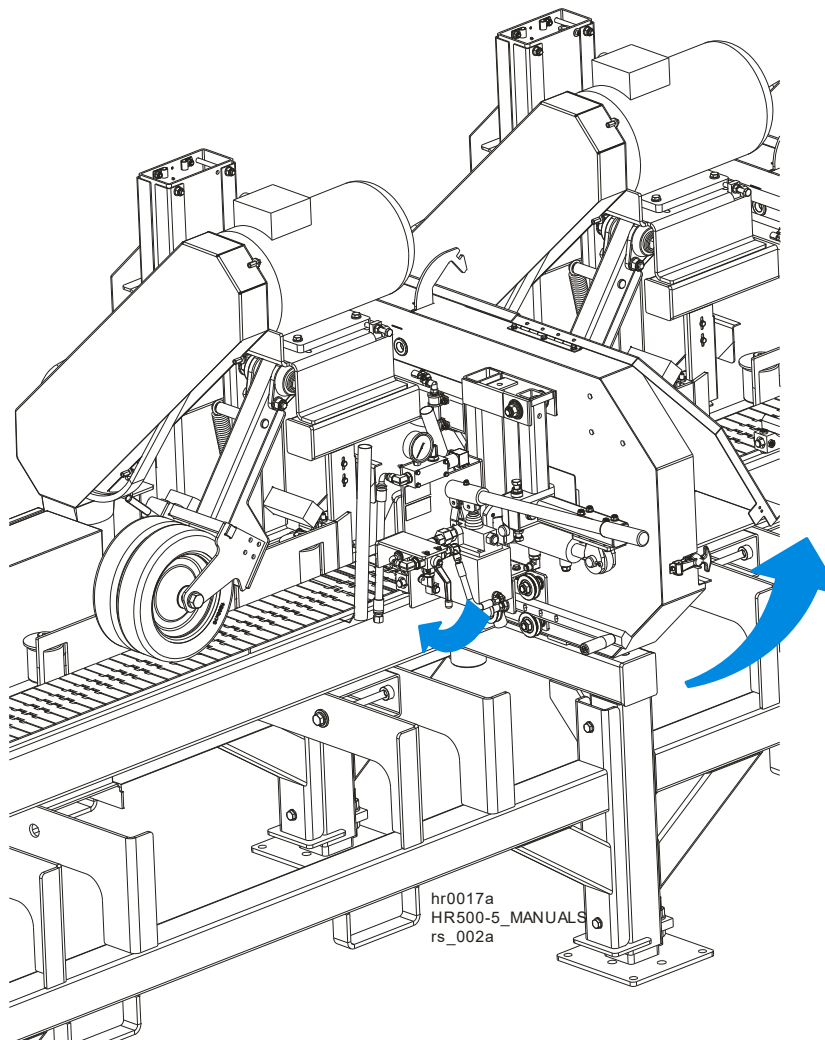
**FIG. 2-11**

## 2.3 Replacing The Blade

 **DANGER!** Always shut off the resaw motor before changing the blade. Failure to do so may result in serious injury.

 **WARNING!** Always wear gloves and eye protection whenever handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from work area when changing blades. Failure to do so may result in serious injury.

Raise the blade housing cover. Turn the blade tension valve handle to the “0” position to release the blade tension until the wheel is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.



Install a new blade around the two blade wheels so that the teeth located between the blade guide assemblies point to the drive side of the machine. Make sure the teeth are pointing the correct

direction.

Position 1 1/4" wide blades on the wheels so the gullet is 3.0 mm (0.12"), ( $\pm$  1.0 mm (0.04")) out from the front edge of the wheel.

Close the blade housing cover.

Next, tension the blade as described in the following instructions.

## 2.4 Using the Blade Tensioner Pump

See Figure 2-12. Place the provided handle in the blade tensioner socket and secure with a screw. Set the tensioner valve to the "1" position. Move the tensioner handle up and down to tension the blade. Depending on the installed blade type, tension the blade to the value shown on the decal located below the blade tension valve. The values "F" and "E" are: blade thickness and blade width. Check the blade tension occasionally when adjusting the cant control or while cutting and adjust if necessary. As the blade and belts heat up and stretch, the blade tension will change. Also, ambient temperature changes can cause tension to change. To release the blade tension, set the tensioner valve to the "0" position.

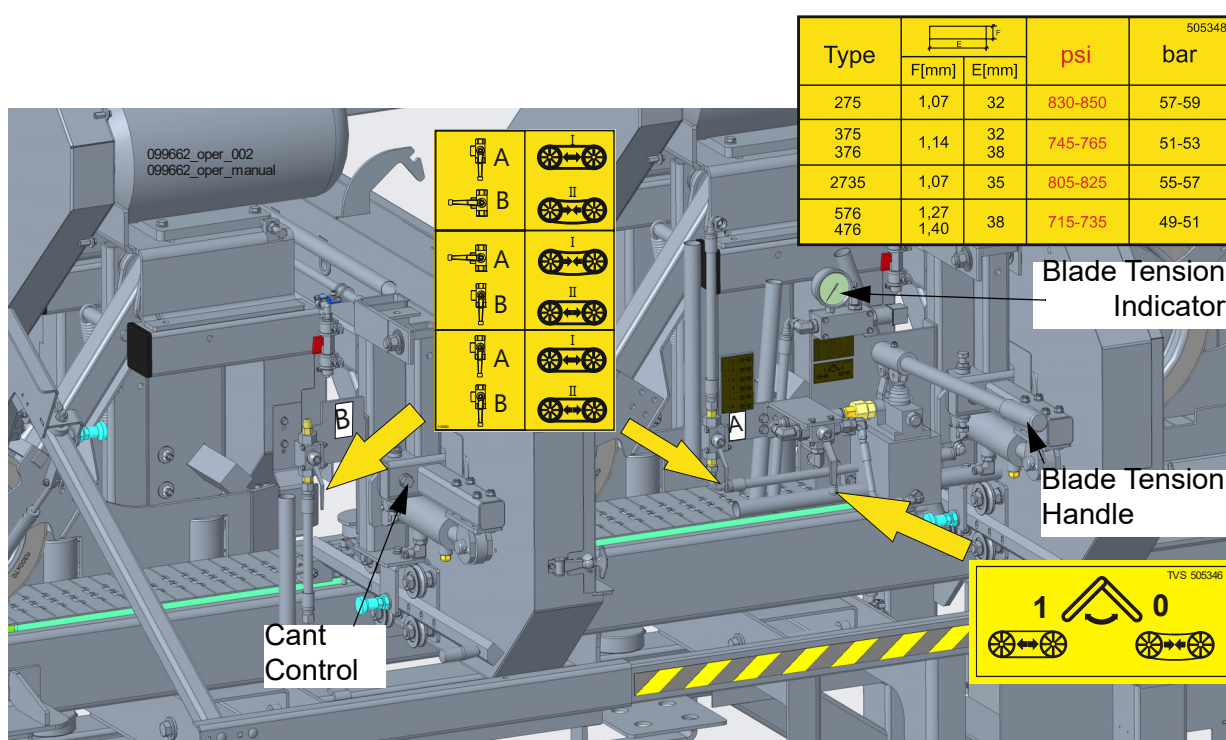


FIG. 2-12



**CAUTION!** Release the blade tension when the resaw is not in use.

## 2.5 Tensioning the Blade (Optional Equipment)

See **Figure 2-13**. Place the provided handle ("D") in the blade tensioner socket and secure it with the bolt.

The decal "E" in the figure below shows how the saw head valves should be set to tension either blade.

1. To tension the blade on the **first saw head** of the module:
  - Open the main valve ("C") by moving its lever all the way to the left;
  - Open the valve of the first saw head ("A") by turning its lever all the way to the right;
  - Turn the lever of the second head valve ("B") all the way to the left to close this valve;
  - Move the lever "D" up and down to tension the blade. [See Section 2.4](#)
2. To tension the blade on the **second saw head** of the module:
  - Open the main valve ("C") by moving its lever all the way to the left;
  - Close the valve of the first saw head ("A") by turning its lever all the way to the left;
  - Turn the lever of the second head valve ("B") all the way to the right to open this valve;
  - Move the lever "D" up and down to tension the blade.
3. To tension the blades on **both saw heads** of the module:
  - Open the main valve ("C") by turning its lever all the way to the left;
  - Move the lever of the first head valve ("A") all the way to the right to open this valve;
  - Open the valve of the second saw head ("B") by turning its lever all the way to the right;



- Move the lever "D" up and down to tension the blade.

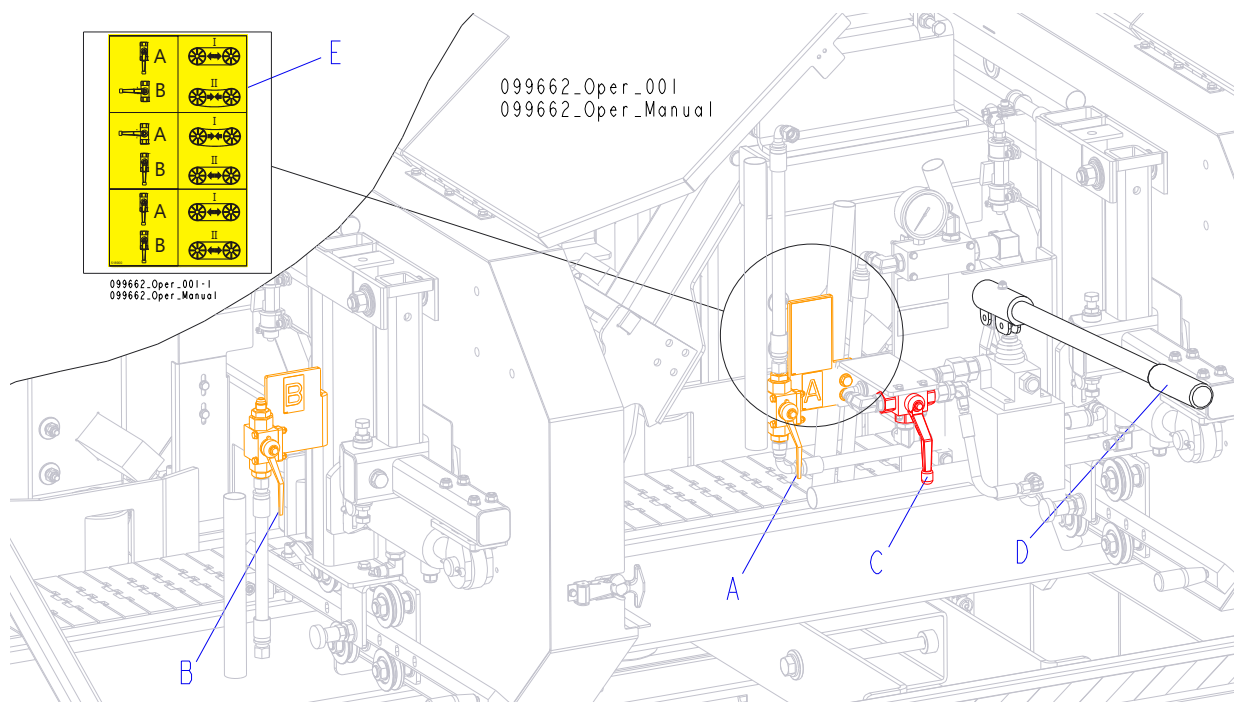


FIG. 2-13



**CAUTION!** Release the blade tension after you have finished sawing. Before restarting the motor, tension the blade again.

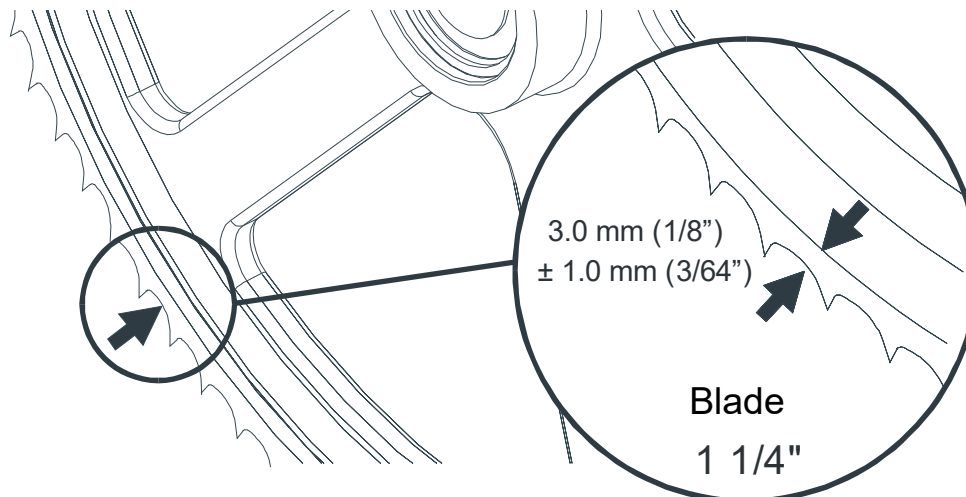
## 2.6 Tracking The Blade

1. Open the blade housing cover.
2. Turn the key switch to the "H" position.



3. Manually spin one of the blade wheels until the blade positions itself on the blade wheels.
4. Check that the blade is properly positioned on the blade wheels.

**See Figure 2-14.** 1 1/4" wide blades should be placed on the blade wheels so that the gullet is 3.0 mm (0.12") ± 1.0 mm (0.04") out from the front edge of the wheel.



**FIG. 2-14**

5. Use the cant adjustment bolt, shown in **Figure 2-12**, to adjust where the blade travels on the blade wheels.

To move the blade out on the blade wheel, turn the cant adjustment bolt clockwise. To move the blade in on the blade wheel, turn the bolt counterclockwise.

6. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.
7. Close the blade housing cover.



**CAUTION!** Make sure all guards and covers are in place and secured before operating or towing the resaw. Failure to do so may result in serious injury. Be sure the blade housing cover is in place and secured.

**NOTE:** After aligning the blade on the wheels, always check the blade guide spacing and location.

## 2.7 Saw Head Height Adjustment

You can raise or lower each individual saw head to determine the thickness of the finished stock. The saw heads should be adjusted so that the last blade the material passes through is closest to the feed track.

**Example:** You want to cut cants into 12.5 mm (0.5") pallet material. Assuming your resaw has six cutting heads, you will need to adjust each head in 14.0 mm (0.55") increments up from the feed track. This will allow 1.5 mm (0.06") kerf for each blade.

**See Figure 2-15.** The sixth saw head (the last one the material will pass through) should be adjusted to 12.5 mm (0.5") above the feed track. The fifth head should be adjusted to 26.5 mm (1.04") above the track, the fourth head to 40.5 mm (1.6"), etc....

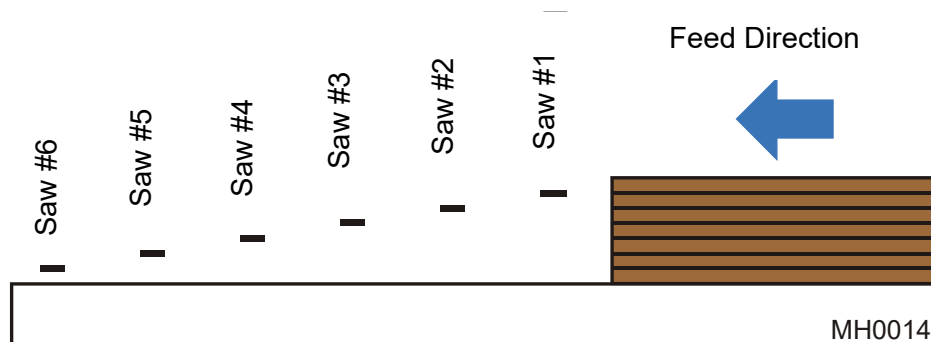


FIG. 2-15

1. Install a blade if needed and check for correct blade tension. ([See Section 2.4](#))
2. Set the saw head at the desired height. (The blade height scale shows the height of the blade above the feed track.)

See Figure 2-16. To raise or lower the saw head, use the acme screw as shown in the figure. Turn the screw clockwise to raise the saw head; counterclockwise to lower the saw head.

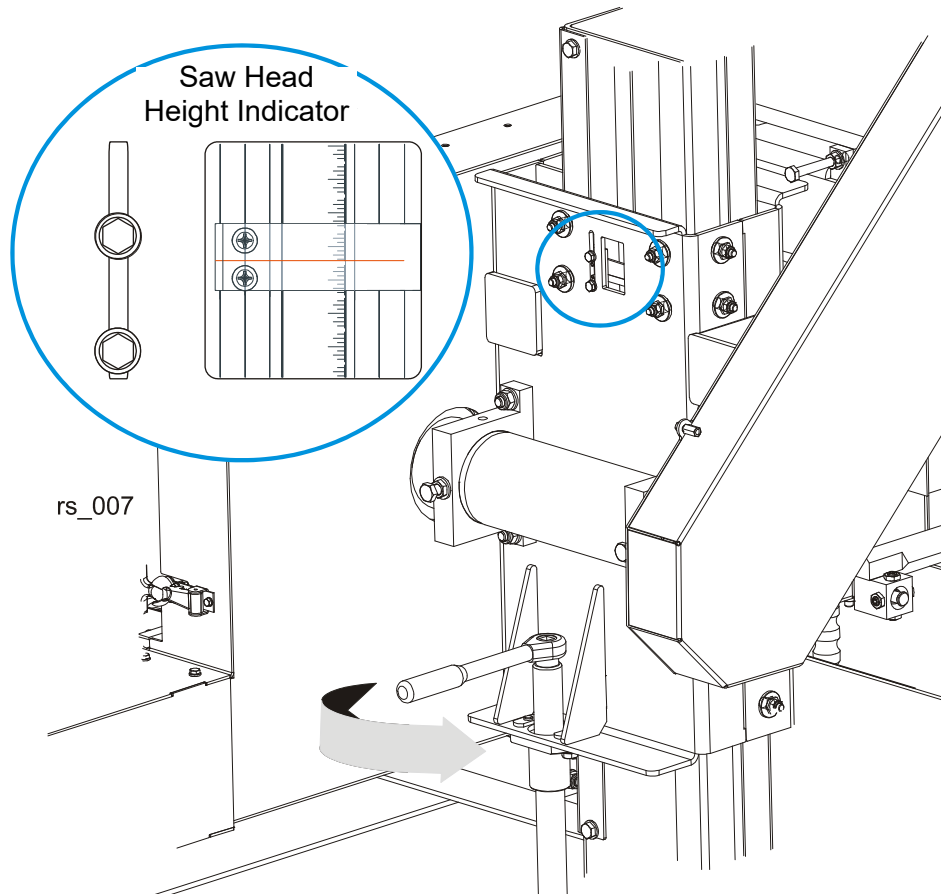


FIG. 2-16

**NOTE:** When adjusting the saw head height lower than 20mm, adjust the blade guide arm so that it does not touch the feed chain.

See Figure 2-17.

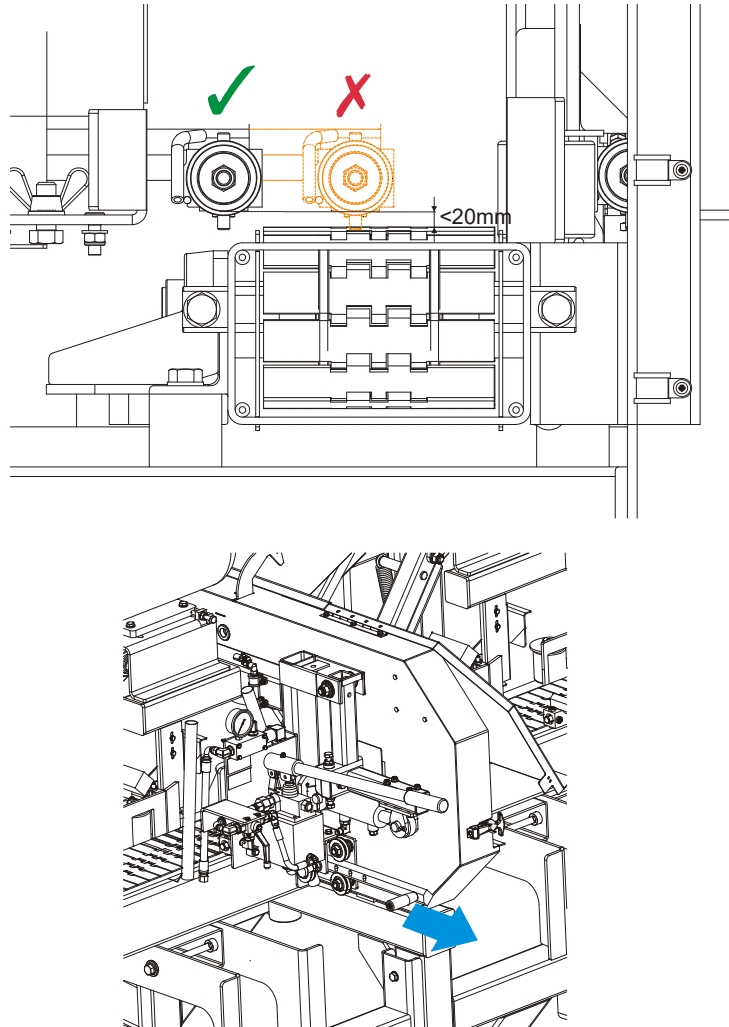
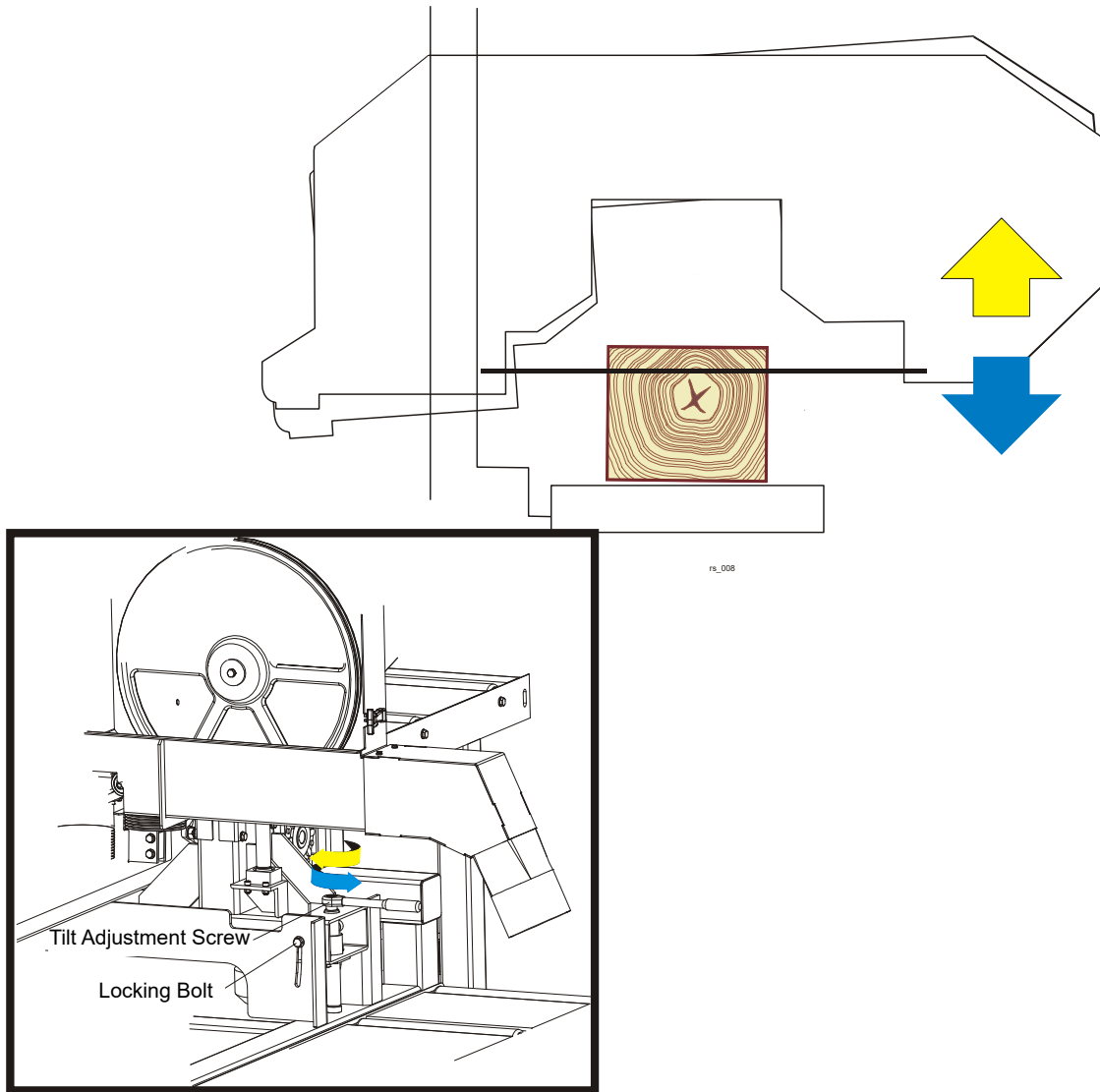


FIG. 2-17

## 2.8 Tilt

See Figure 2-18. The saw head may be tilted to produce siding. Loosen the locking bolt. Turn the tilt adjustment screw clockwise to tilt the saw head upward or counterclockwise to tilt the saw head downward.



**FIG. 2-18**

**NOTE:** The saw head can be set at an angle of 0° to 8°.

## 2.9 Guide Fence Adjustment

See Figure 2-19. Loosen the wing nuts. Move the guide fence to the desired cant width.

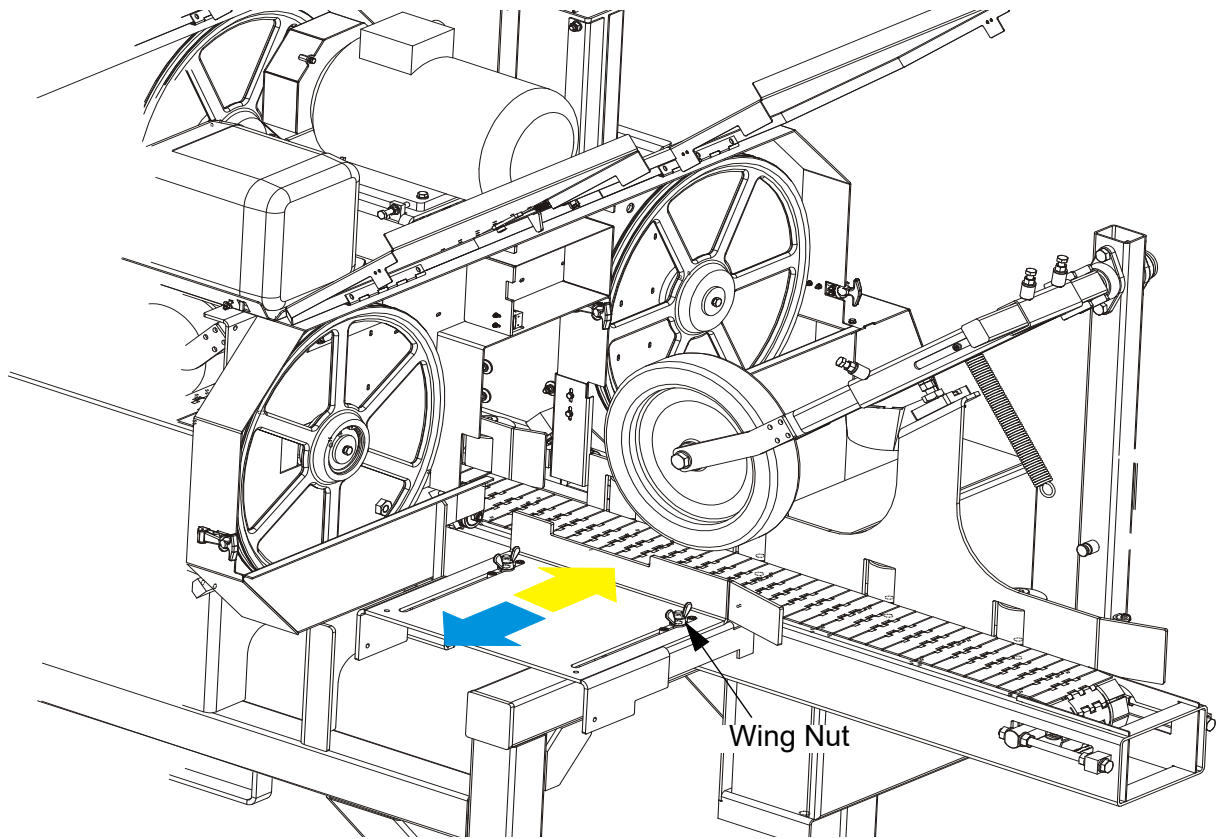


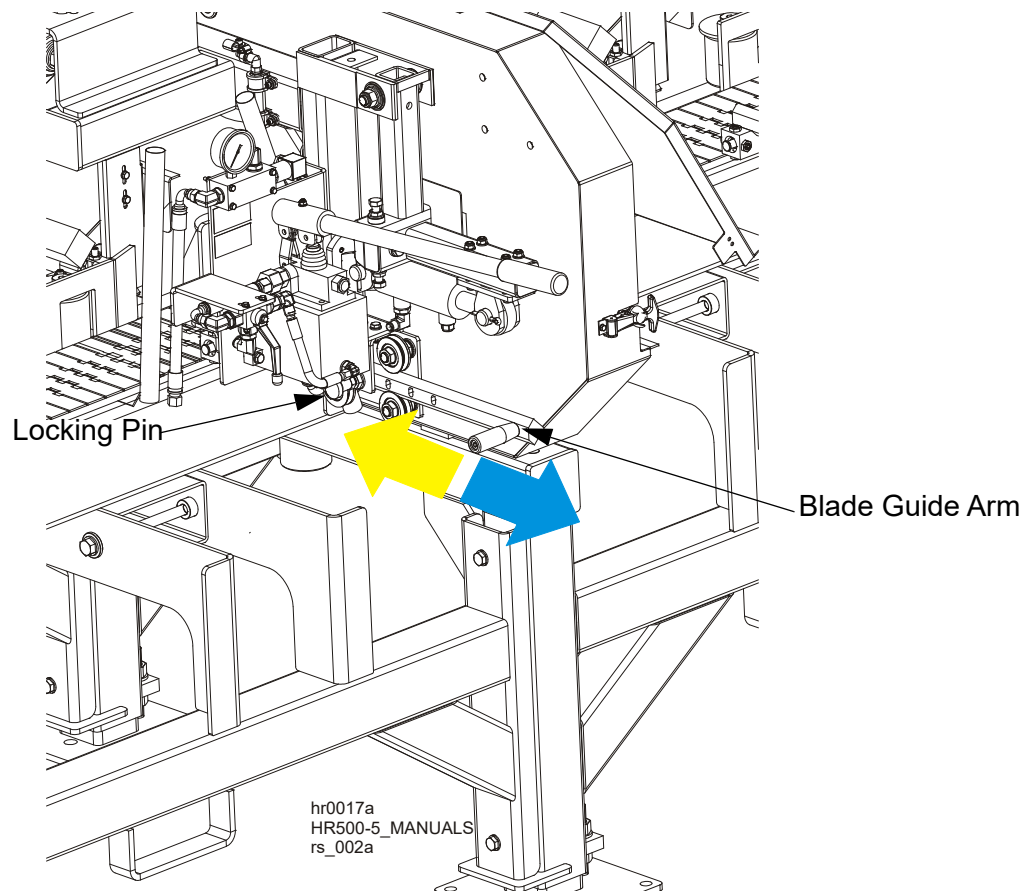
FIG. 2-19

## 2.10 Blade Guide Arm Adjustment

The outside blade guide arm can be adjusted in or out depending on the width of the material to be cut. The arm should be adjusted about 25 mm (1") wider than the material to be cut.

**Example:** If the material to be cut is 150 mm (5.9") wide, adjust the blade guide arm so the area between the blade guides is 175 mm (6.9") wide.


**See Figure 2-20.** To move the blade guide arm, unlock the locking pin and slide the arm in or out. Lock the locking pin.



**FIG. 2-20**




## 2.11 Machine Start

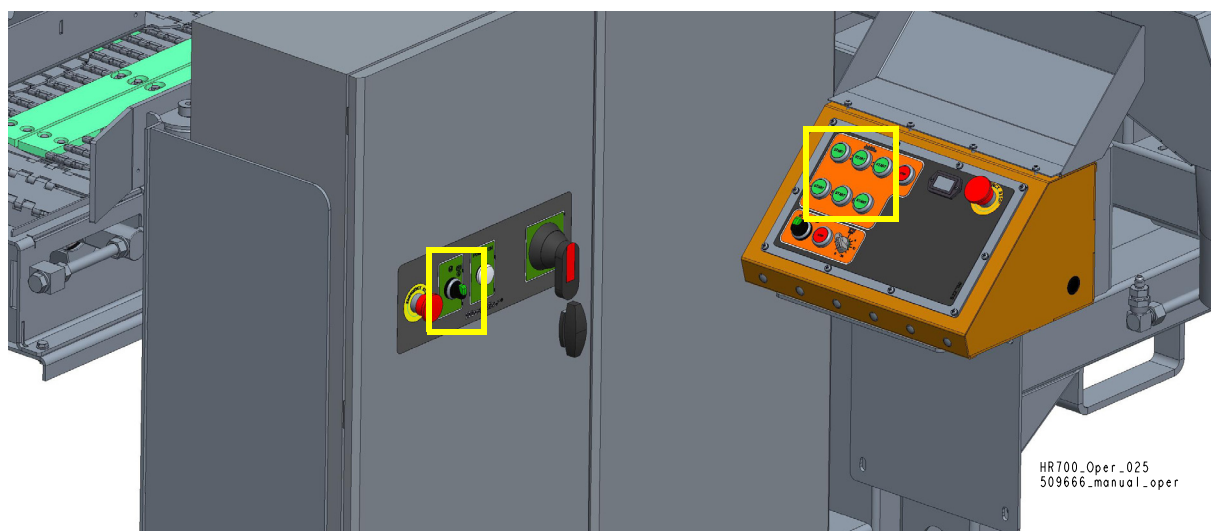
 **DANGER!** Before starting the resaw, perform these steps to avoid injury and/or damage to the equipment:

- Close the blade housing cover and replace any guards removed for service.
- Check the feed track and remove all loose objects such as tools, wood, etc.
- Check that the blade is properly tensioned.
- Make sure all persons are at a safe distance from the machine.
- Check that the emergency stops are released.


**NOTE:** The resaw will not start if either of the emergency stops is on.

Before starting the saw heads, check that the main power switch servicing the resaw is on.

**See Figure 2-21.** Start the blade motors. To do this, turn the key switch to the  position. Then press the START button. Each saw head is started with separate START button. The motors should start and the blades should start spinning.



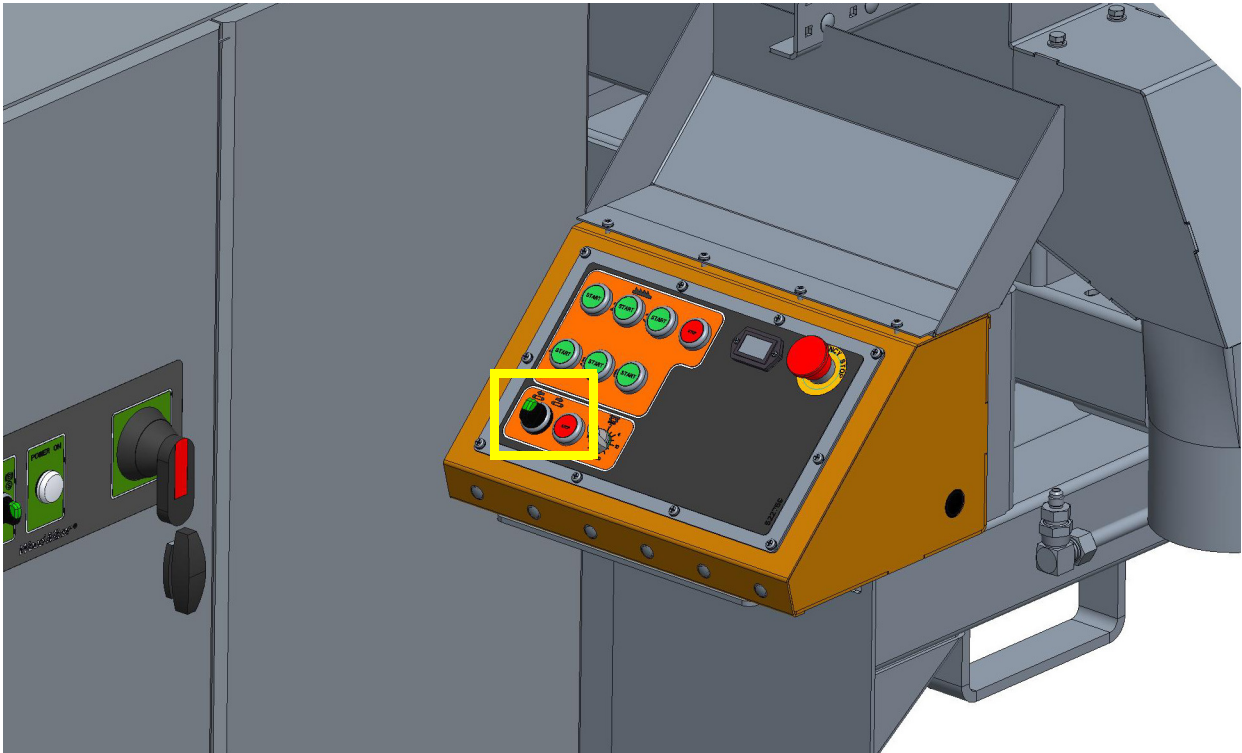
**FIG. 2-21**

 **CAUTION!** Wait five (5) seconds between the start of each saw head motor to avoid high peak demand currents.

To stop the blade motors, press the STOP button shown in the figure above. The blade motor also may be stopped by pushing either of the emergency stop buttons.

If either of the emergency stops has been used to stop the blade motor, rotate the switch clockwise before restarting the saw head. The saw head cannot be restarted until the emergency stop button is released.

**See Figure 2-22.** After the saw head has been successfully started, the feed track can be started. To start the track feed, turn left the Track switch shown in Figure 2-5.

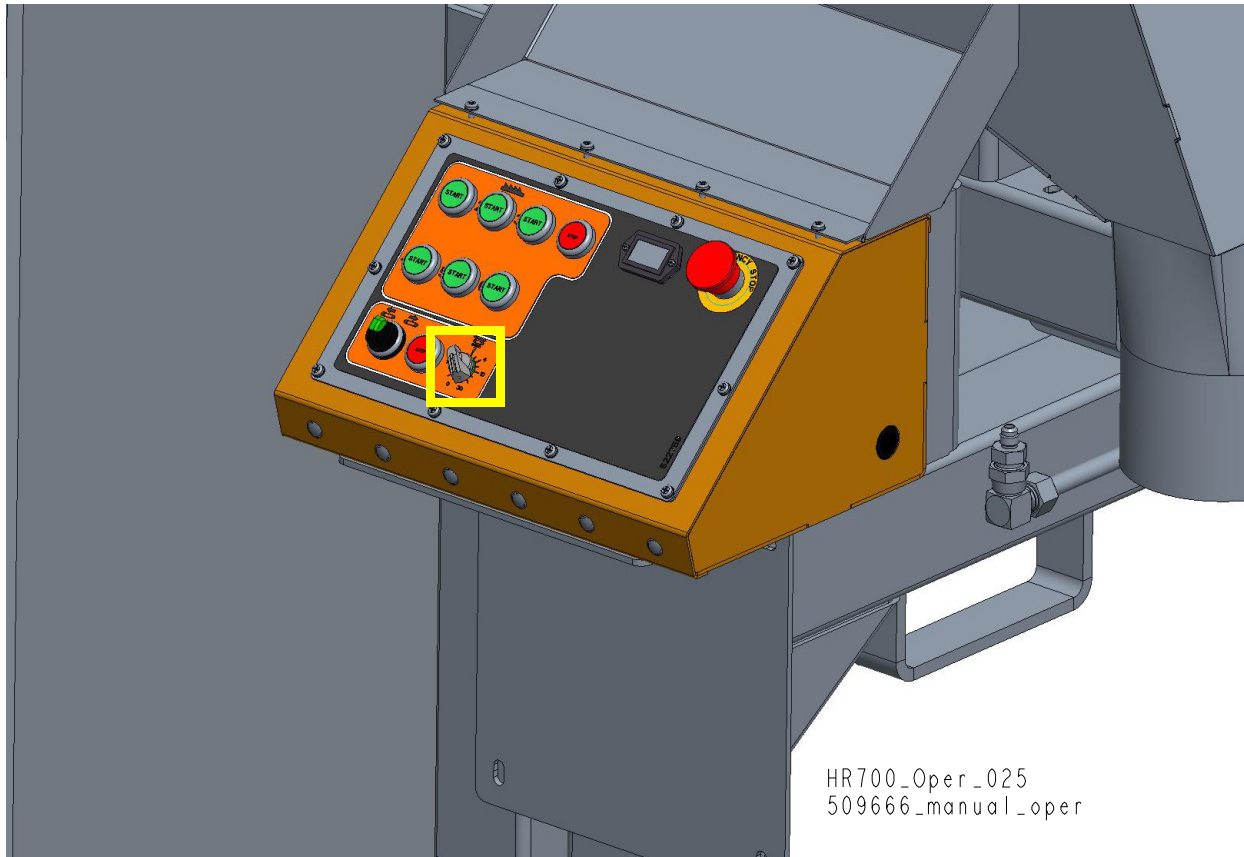


**FIG. 2-22**

The feed track can be stopped either by pressing the STOP button or one of the emergency stop buttons. The emergency stop will also stop the blade motor.

**NOTE:** The feed track cannot be started if the blade motor is not started.

**See Figure 2-23.** The speed at which the feed track moves is adjustable. The feed track speed switch, located on the control panel, allows the operator to adjust the feed rate from 0 to ca. 25 m (82 ft) per minute.



**FIG. 2-23**

Turn the switch clockwise to increase the feed rate, counterclockwise to slow the feed rate down.

**Factors that will determine what feed rate you can use include:**

- Number of saw heads.
- Width of material to be cut. 200mm (7.9") wide material will require a slower feed rate than 100mm (3.9") wide material.
- Hardness of material to be cut. Some woods that are seasoned or naturally very hard will require slower feed rates.
- Sharpness of blades. Dull or improperly sharpened blades will require slower feed rates than sharp and properly maintained blades.
- Off-bearing capability. Your ability to feed end-to-end will also determine what feed rate you

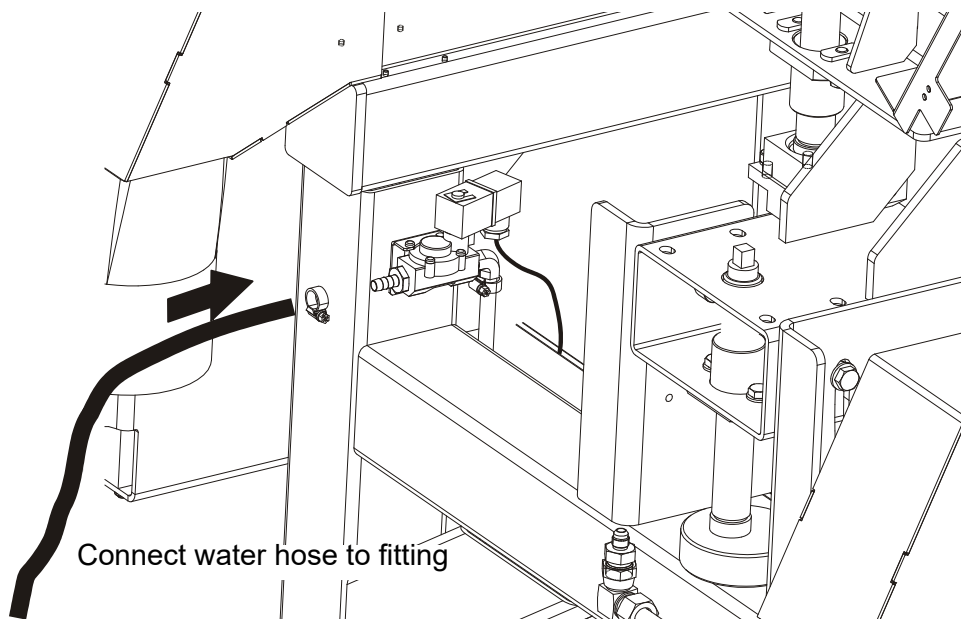
can use.

## 2.12 Water Lube Operation

### *Standard Lube System (Supplied from a Water Supply Network)*

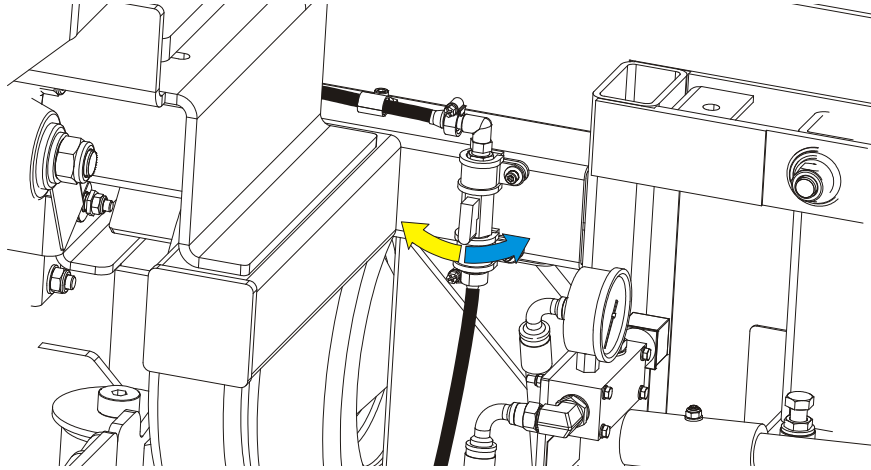
The Water Lube System keeps the blade clean. It is supplied from a water-pipe network (minimum pressure 0.35bar [0,05MPa], maximum 6bar [0.6MPa]). Water flows through a hose, a solenoid and a manual valve to the blade guide where the blade enters the log. The manual valve located on each saw head controls the amount of water flow.

See **Figure 2-24**. Connect the water hose to the lube system fitting shown below.



**FIG. 2-24**

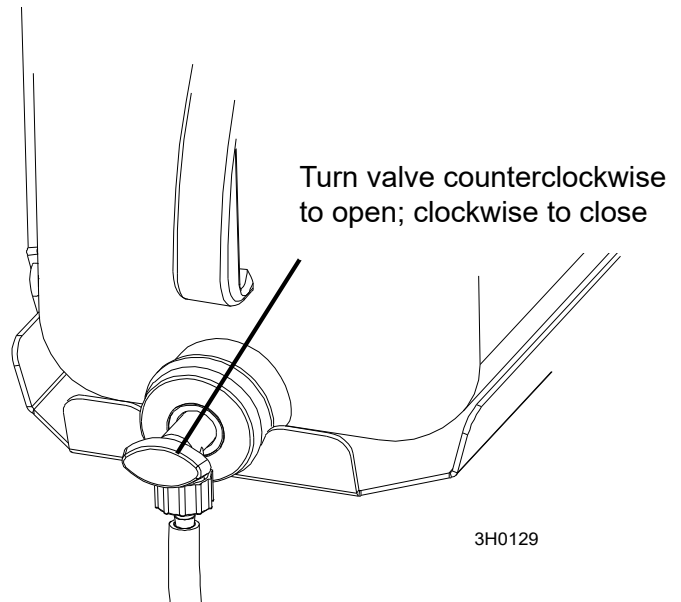
See Figure 2-25. Use the manual valve on each saw head to adjust the amount of water flow.



**FIG. 2-25**

### Optional Lube System (Supplied from Water Tanks)

See **Figure 2-26**. The Water Lube System keeps the blade clean. Water flows from a 5-gallon (18.9 liter) bottle through a hose to the blade guide where the blade enters the log. A valve in the bottle cap controls the amount of water flow.



**FIG. 2-26**

Not all types of wood require the use of the Water Lube System. When it is needed, use just enough water to keep the blade clean. This saves water, and lowers the risk of staining the boards with water. Usual flow will be 1-2 gallons (3.8-7.6 liters) per hour (on average, the bottle content is sufficient for 4-hour-long cutting). A squirt of liquid dishwashing detergent in the water bottle will help clean the blade when cutting wood with a high sap content. Before you start cutting, check the water level in the bottle.



**WARNING!** Use **ONLY** water with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so may result in serious injury or death.

Before removing the blade, start the blade motor with the **START** button. Let the blade spin with water running on it for about 15 seconds. This will clean the blade of sap buildup. Wipe the blade dry with a rag before storing or sharpening.

If you are sawing in freezing temperatures, remove the water lube bottle from the resaw when done sawing and store it in a warm place. Blow any remaining water from the water lube hose.

## 2.13 Operation Procedure

1. Install a blade if necessary.



**WARNING!** Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or changing a blade. Failure to do so may result in serious injury.

2. Close the blade housing cover.
3. Tension the blade - [See Section 2.4.](#)
4. Spin the blade wheel by hand.



**WARNING!** Use extreme caution when spinning the blade wheel by hand. Make sure your hands are clear of the blade and the wheel spokes before spinning. Failure to do so may result in serious injury.

5. Check alignment of the blade on the blade wheels and blade guides. Adjust as necessary.
6. Raise or lower the saw heads to the desired setting.



**DANGER!** Make sure all guards and covers are in place and secured before operating the resaw. Failure to do so may result in serious injury.

7. Start the blade motor.
8. Perform pre-start check (rotation direction of the blade motors).
9. Using the feed track speed switch, set the feed rate as desired.



**DANGER!** Always be sure all persons are out of the path of the blade before starting the motor. Failure to do so will result in serious injury.



**WARNING!** Always wear eye, ear, respiration and foot protection when operating or servicing your resaw.

10. Place the test material on the feed track and start the feed track.



**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.

11. Shut off the blade and feed track. Measure the finished material and adjust the saw heads up or down as necessary. Repeat with the test material until the desired finished dimension is obtained.
12. Restart the blade and feed track.
13. Place material on the infeed table. Return unfinished material to be re-fed into the resaw, i.e. place it on the return table.
14. Monitor the blade tension as the operation continues. Adjust the blade tension if required.
15. If material jam occurs, stop the blade motors and feed track.



**WARNING!** Allow the blade to come to a complete stop before servicing. Failure to do so will result in serious injury.

16. After the operation is complete, shut off the blade motors and feed track.
17. Release the blade tension if done sawing for the day.



**CAUTION!** Remove tension from the blade when the resaw is not in use.



## **SECTION 3 MULTISETWORKS OPERATION (OPTIONAL EQUIPMENT)**

### **3.1 General Information**

A new Multisetwork has been designed to automatically set the saw heads at any required height. It can be mounted on HR500 and HR700 resaw.

Saw head height is measured continuously and its accuracy depends on condition of the up/down system and feed track.

Multisetwork includes programmable PLC controller, incremental encoder, programmable control panel, motor breakers, frequency converters and limit switches.

### **3.2 Functions**

Multisetwork can work in two modes:

- **MANUAL** – each saw head can be set by the operator separately, kerf is not included.
- **X-BOARD** – the saw heads are set automatically according to pre-selected board thickness values - first saw head is set on the highest calculated height, the last saw head is set on the lowest calculated height. Blade kerf loss is included.
- The values can be displayed in metric or imperial (decimal or fractional) units of measure.
- There are two languages of the menu: Polish and English,
- Diagnostic mode.
- Tuning mode.

### 3.3 Start-up

After starting the controller, the initial welcome screen will appear:

See Figure 3-1.

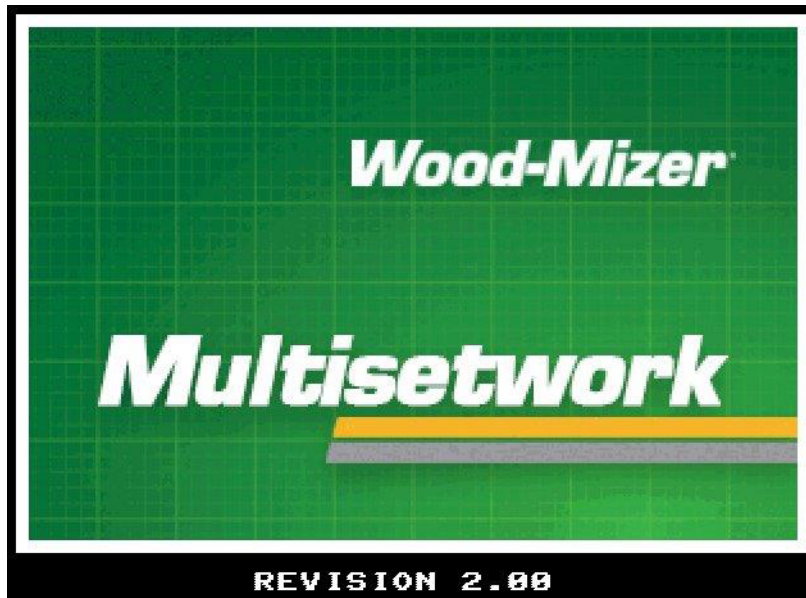


FIG. 3-1

#### 3.3.1 Calibration

After few seconds the CALIBRATION screen is displayed:

See Figure 3-2.

The image shows a digital display screen titled "CALIBRATION" in a red header. Below the header, there are six input fields arranged in a 3x2 grid. Each field is labeled with a head number (Head 1 through Head 6) and contains the text "123 mm". At the bottom center of the screen is a large teal button labeled "ACCEPT".

CALIBRATION	
Head 1	Head 2
123 mm	123 mm
Head 3	Head 4
123 mm	123 mm
Head 5	Head 6
123 mm	123 mm
ACCEPT	

FIG. 3-2

Depending on the number of saw heads, the appropriate number of fields to enter values will appear.

Measure the height of each saw head and enter these values in the fields. Then press ACCEPT button. After accepting the entered values, the Choose mode screen will appear.

### 3.4 Manual Mode

See Figure 3-3.

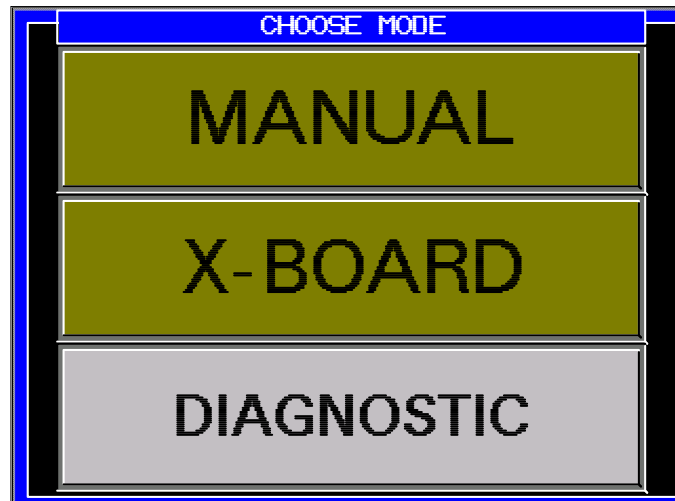


FIG. 3-3

After choosing the MANUAL mode in the main window, the screen shown below will be displayed:

See Figure 3-4.

Manual			
HEAD 1		HEAD 2	
REAL	TARGET	REAL	TARGET
123.1 mm	123.1 mm	123.1 mm	123.1 mm
HEAD 3		HEAD 4	
REAL	TARGET	REAL	TARGET
123.1 mm	123.1 mm	123.1 mm	123.1 mm
HEAD 5		HEAD 6	
REAL	TARGET	REAL	TARGET
123.1 mm	123.1 mm	123.1 mm	123.1 mm

At the bottom of the screen, there are two buttons: "BACK" and "<< SET >>".

FIG. 3-4

On this screen the current blade height value for each saw head and the target height values are displayed.

Press BACK button to move to the main window.

After pressing SET button, all saw heads will be moved to their preset target heights.

To change any target values, press on this value the TARGET window. Next, enter the required height value and confirm by pressing ENTER button.

Additionally saw head heights can be changed manually by operator. To do this, press the REAL window and use arrows to change saw head height with minimal speed:

See Figure 3-5.

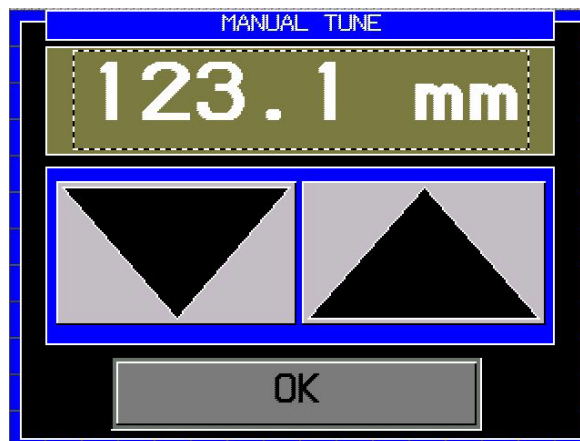


FIG. 3-5

Press OK button to back to MANUAL MODE screen.

Screen with imperial fractional unit of measure is shown below:

See Figure 3-6.

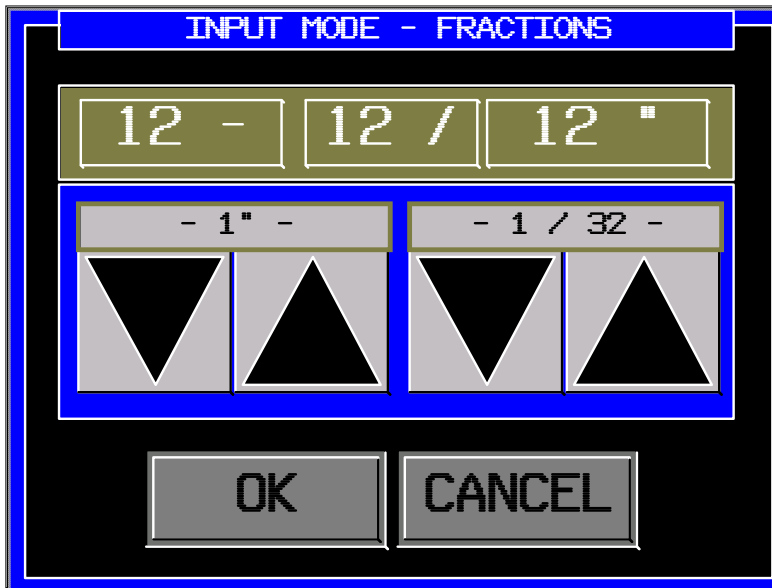


FIG. 3-6

Press OK to confirm entered value.

When positioning is started, the blinking POSITIONING button will appear instead of SET button.

See Figure 3-7.

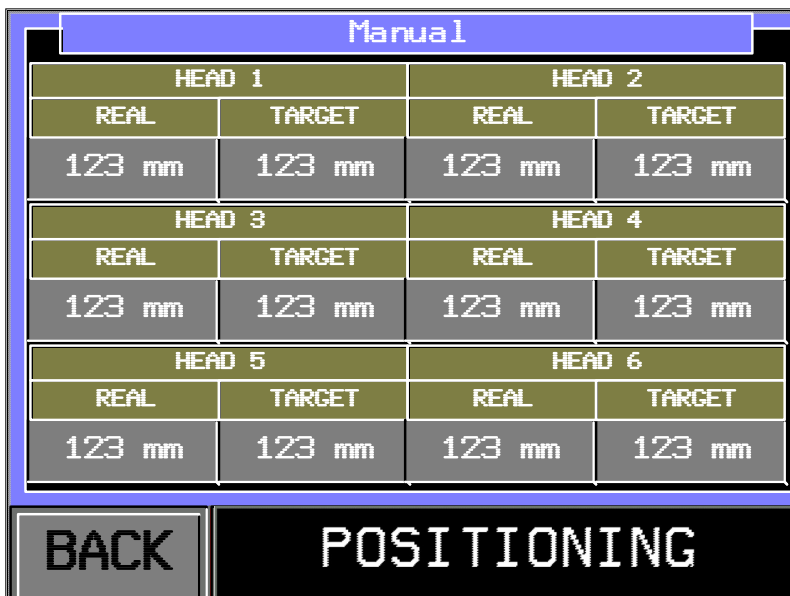


FIG. 3-7

### 3.5 X-Board Mode

It is necessary to set the correct kerf value to allow the X-Board mode to work properly. Kerf value can be set in Diagnostic menu ([See Section 3.6.3](#)).

See Figure 3-8.

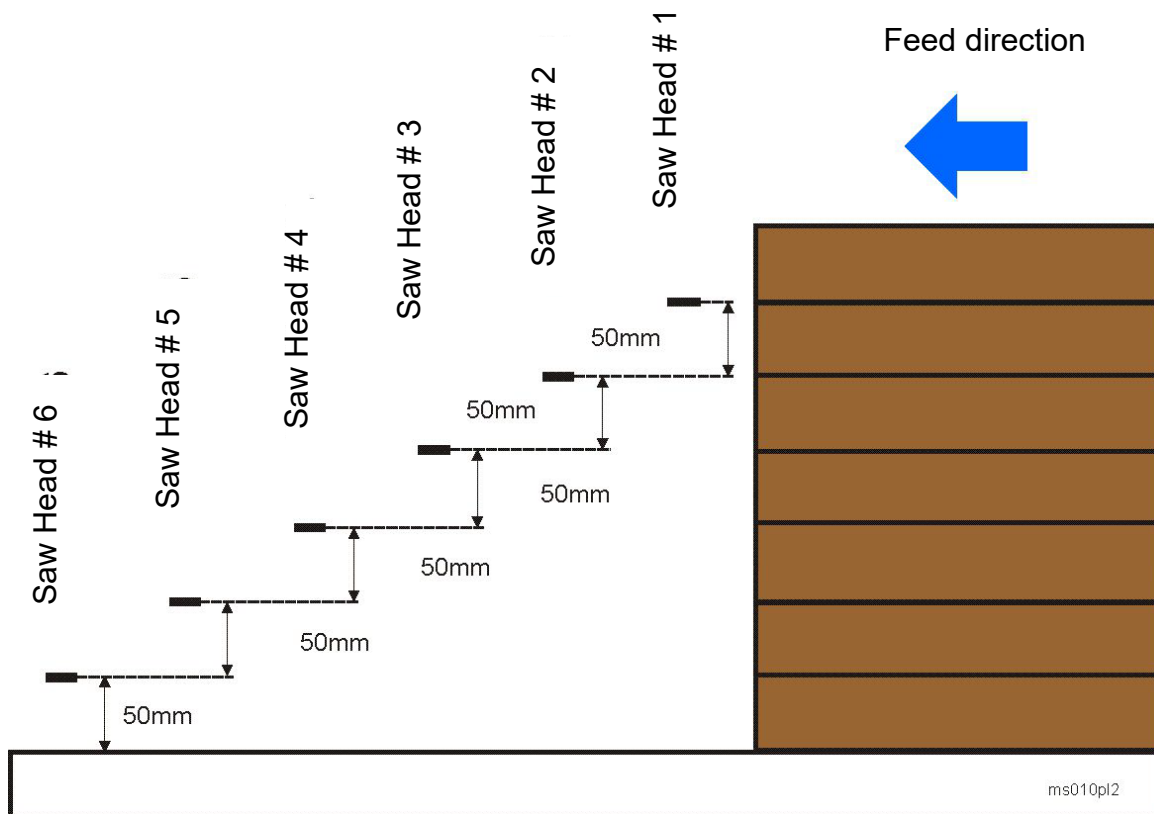


FIG. 3-8

After choosing the X-Board menu, depending on chosen units of measure, the following screen will be displayed:

See Figure 3-9.

X-BOARD			
BOARD 1	50 mm	310 mm	HEAD 1
BOARD 2	50 mm	258 mm	HEAD 2
BOARD 3	50 mm	206 mm	HEAD 3
BOARD 4	50 mm	154 mm	HEAD 4
BOARD 5	50 mm	102 mm	HEAD 5
BOARD 6	50 mm	50 mm	HEAD 6

BACK      POSITIONING

FIG. 3-9

The X-Board screen includes a list of all saw head heights and board thickness values preset for each saw head.

To move to the main window (Choose Mode screen), press the BACK button.

After pressing SET button, each saw head will automatically be set at the calculated height.

To change any board thickness value, press on this value, enter the desired value and press ENTER. The entered board thickness value will automatically be copied to all dimensions above this value.

If the imperial fractional unit of measure was selected, the screen shown below will appear:



See Figure 3-10.

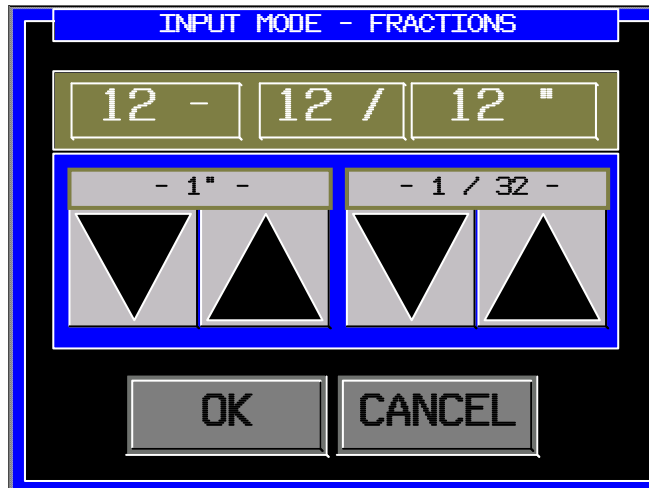


FIG. 3-10

In this case, press OK button to confirm the entered value.

When positioning is started, the blinking POSITIONING button will appear instead of SET button.

First saw head is set at the highest calculated height, last active saw head is set on the lowest calculated height.

As it is in Manual Mode, saw head heights can be changed manually by the operator. To do this, press the REAL window and use arrows to change saw head height with minimal speed:

See Figure 3-11.

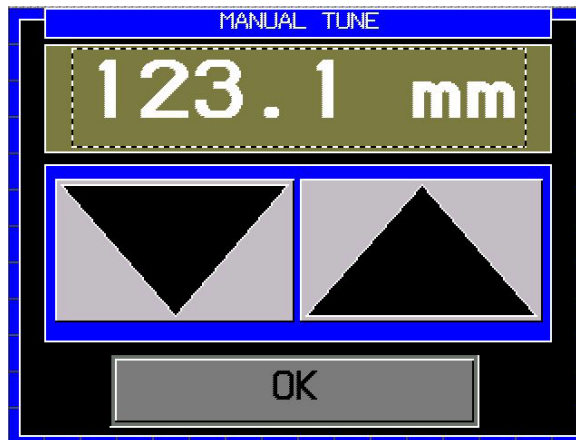


FIG. 3-11

When saw heads are set, press OK button to move to X-Board mode screen.

### 3.6 Diagnostic

Press DIAGNOSTIC button on the Choose mode screen:

See Figure 3-12.

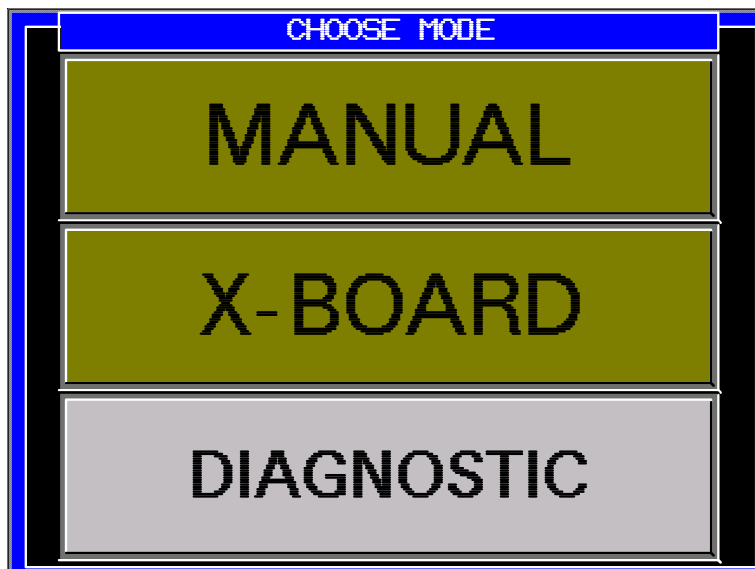


FIG. 3-12

The following screen will be displayed:

See Figure 3-13.



FIG. 3-13

Units of measure and language can be set on the DIAGNOSTIC screen. Also controller calibration can be made by pressing calibration button.

See Figure 3-14.



FIG. 3-14

### 3.6.2 Calibration

After pressing CALIBRATION button, following screen will be displayed.

See Figure 3-15.



FIG. 3-15

Check, if values of each saw head height are the same with real saw heads height read on the scale located on each saw head mast. If any of these values is incorrect, press this value, enter the correct value and confirm.

### 3.6.3 Diagnostic I/O

After pressing DIAGNOSTIC I/O button, the following screen will be displayed:

See Figure 3-16.

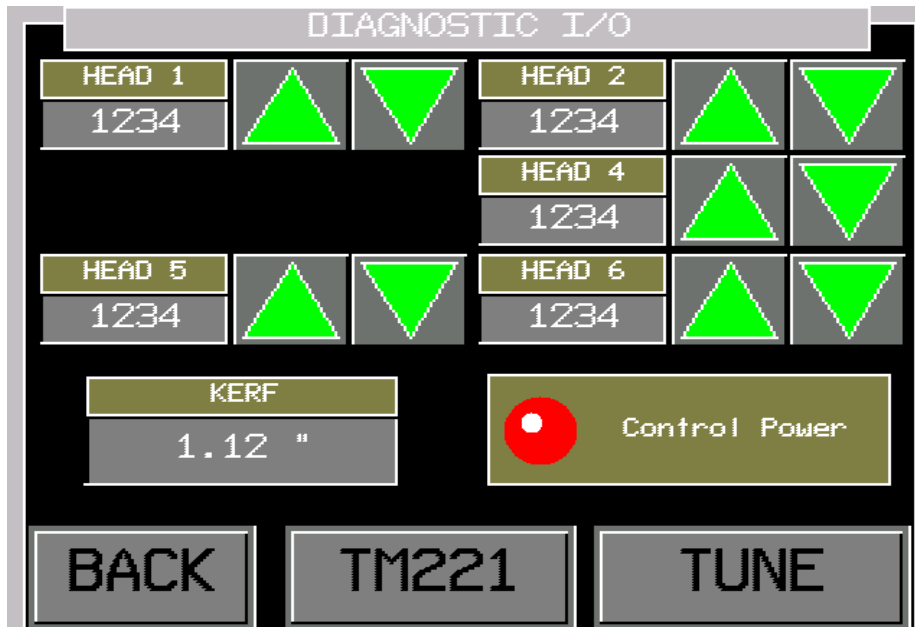


FIG. 3-16

The values in each HEAD window represent the current numbers of encoder revolutions. Use arrows to manually control the up/down system.

- Kerf. Press KERF window to enter the kerf value. Next confirm by pressing ENTER button. The correct kerf value for Wood-Mizer blades is 2.
- Control Power LED, shows the condition of the machine main control circuit.

See Figure 3-17.

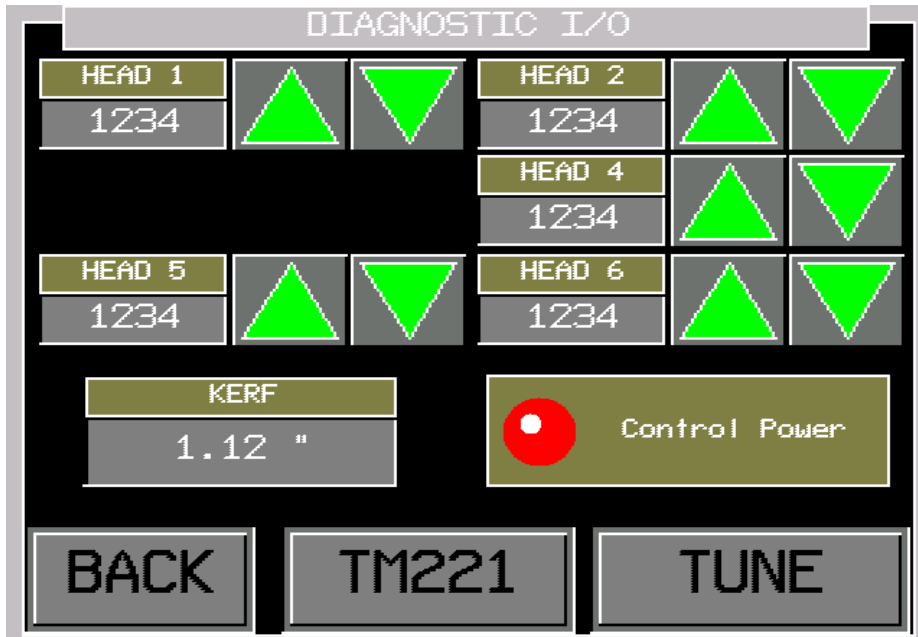


FIG. 3-17

- TM221 button is used to move to CAN, MODBUS TCP diagnostic screen:

See Figure 3-18.

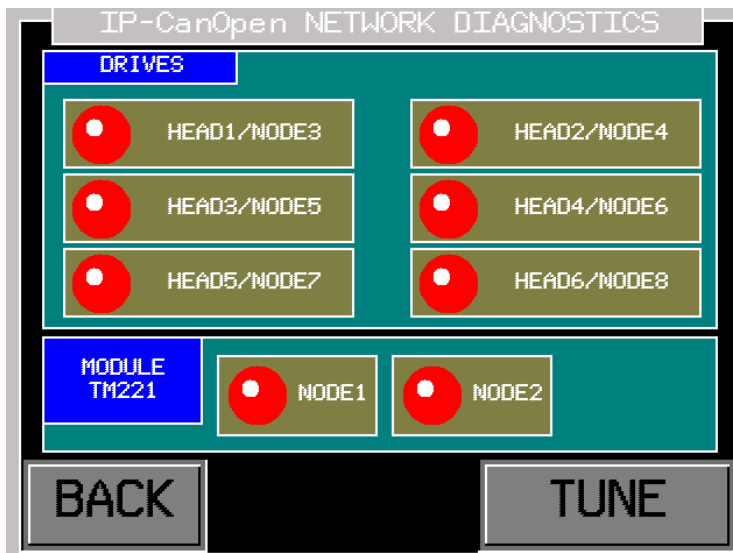


FIG. 3-18

In the DRIVES section, LEDs show the communication status with each drive. Green - communication is ok, Red - there is no communication.

TM221 module shows the communication status with NODE1, NODE2 modules. These modules are active only when machine is equipped with 3, 4, 5 or 6 saw heads. When there is only one or two saw heads, control lights will be red - there will be no communication with modules.

Press the window with saw head number/mode to move to the extended drive status. The following window will appear:

See Figure 3-19. Drives values may vary.

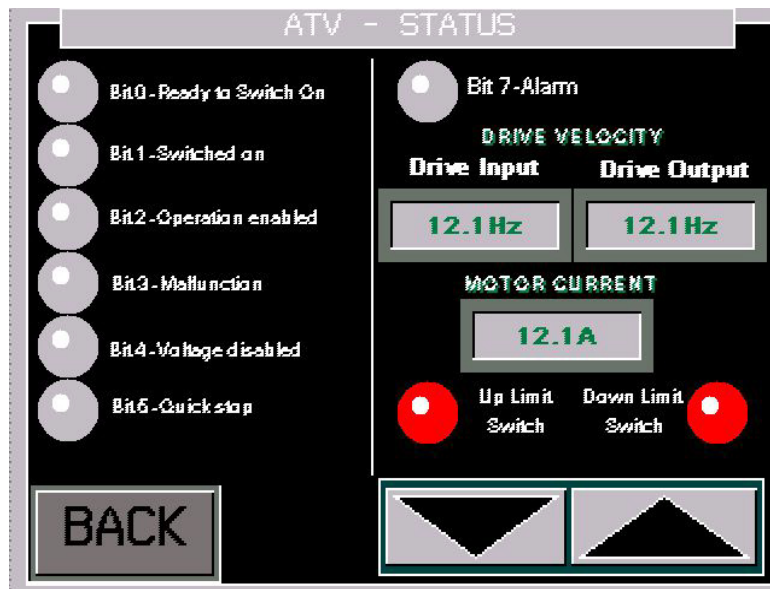


FIG. 3-19

Point Bit0-Bit7 – drive register status

Drive velocity – Input – Entered speed (Hz).

Drive velocity – Output – Motor speed (Hz).

Motor current – nominal value for 400/460V should be ~ 1,5A.

Up and down limit switches – conditions of up and down limit switches.

Green – limit switch is released, Red – limit switch is active.

Use arrows to move the saw head up and down with minimal speed.



### 3.6.4 Tuning

**Caution!** – All changes have to be agreed with Wood-Mizer Customer Service! These parameters influence up/down operation.

If there are problems with saw head positioning, change parameters. These changes influence saw head movement.

Choose Tuning on the DIAGNOSTIC/TUNE menu:

See Figure 3-20.



FIG. 3-20

The screen below will appear:

See Figure 3-21. Values displayed by the controller may vary.

TUNE	
MIN DISTANCE - DOWN	MIN DISTANCE - UP
12 pulses	12 pulses
MIN FREQUENCY - DOWN	MIN FREQUENCY - UP
12.1 Hz	12.1 Hz
MAX DISTANCE - DOWN	MAX DISTANCE - UP
123 pulses	123 pulses
MAX FREQUENCY - DOWN	MAX FREQUENCY - UP
12.1 Hz	12.1 Hz
JOG FREQUENCY	TOLERANCE
1.1 Hz	1 pulses
BACK	Back to default values

FIG. 3-21

### 3.7 Errors

- After choosing the X-BOARD mode, the following message may occur:

See Figure 3-22.



FIG. 3-22

Enter the DIAGNOSTIC I/O mode. Check if number of saw heads displayed on the screen and mounted on the machine are the same:

See Figure 3-23.



FIG. 3-23

When one saw head (e.g. saw head no 3) is missing, the diagnostic screen looks like shown below:

See Figure 3-24.

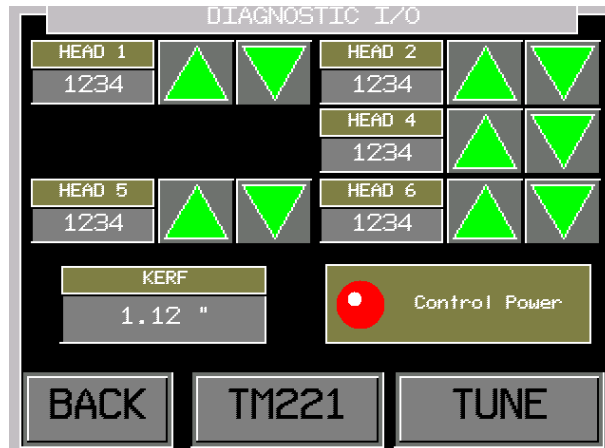


FIG. 3-24

Make sure if COF error is displayed on the drive controller after opening electric box.

CAN\_R LED should be steady on, I/O and CAN\_E LED should blinks red:

See Figure 3-25.



FIG. 3-25

If so, check connection between drive and cantap (patchcord with RJ45 terminals). When two or more saw heads are missing, check connection between cantaps and PLC controller. Next turn off and turn on the power to restart the connection. Connection condition can be also check on the Diagnostic screen by pushing TM221 button:

See Figure 3-26.

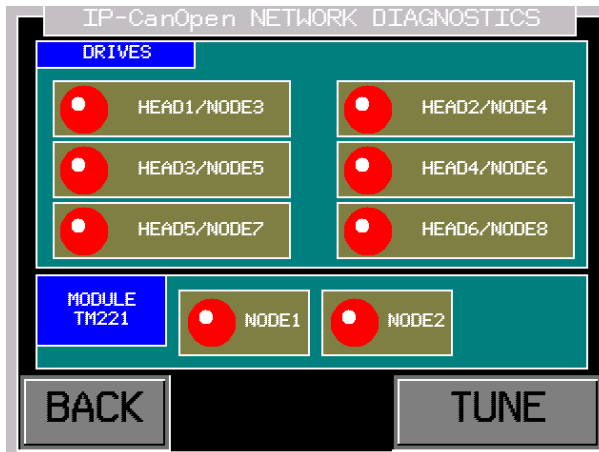


FIG. 3-26

In the DRIVES section, LEDs show the communication status with each drive. Green - communication is ok, Red - no communication.

TM221 section show the communication status with NODE1, NODE2 modules. These modules are active only when machine is equipped with 3, 4, 5 or 6 saw heads. When there is only one or two saw heads, control lights will be red - there will be no communication with NODE1, NODE2 modules. If there is no connection between controller and NODE1, NODE2 module(s), on the TM221 module ERR LED will turn on:

See Figure 3-27.

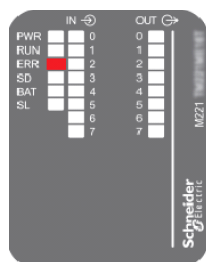


FIG. 3-27

**3.7.5 Impulses are not counted.**

See Figure 3-28.



**FIG. 3-28**

This error may be caused by damage of: encoder, clutch between encoder and motoreducer, wire connecting encoder and connectors or wires connecting PLC controller inputs and power supply with connectors.

First remove encoder cover and check if encoder clutch is tightened and is not damaged.

Next, check the encoder connection to PLC controller or TM221 module (encoders of the saw head number 1 and 2 are connecting with PLC 1.0 controller; encoders of the saw head number 3 and 4 are connecting with PLC 2.0 controller; encoders of the saw head number 5 and 6 are connecting with PLC 3.0 controller).

Controller/Module	Encoder/Saw Head	Inputs
PLC 1.0	Encoder 1/Saw Head 1	I0 and I1
PLC 1.0	Encoder 2/Saw Head 2	I4 and I5
PLC 2.0	Encoder 3/Saw Head 3	I0 and I1
PLC 2.0	Encoder 4/Saw Head 4	I6 and I7
PLC 3.0	Encoder 5/Saw Head 5	I0 and I1
PLC 3.0	Encoder 6/Saw Head 6	I6 and I7

**TABLE 3-1**

Next choose the Diagnostic Mode:

See Figure 3-29.

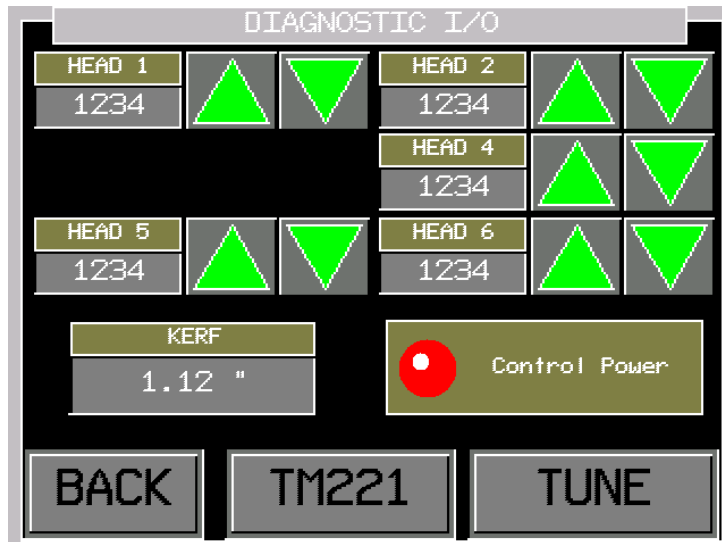


FIG. 3-29

Use arrow buttons to move the saw head up or down and watch LED of the encoder input.

See Figure 3-30.

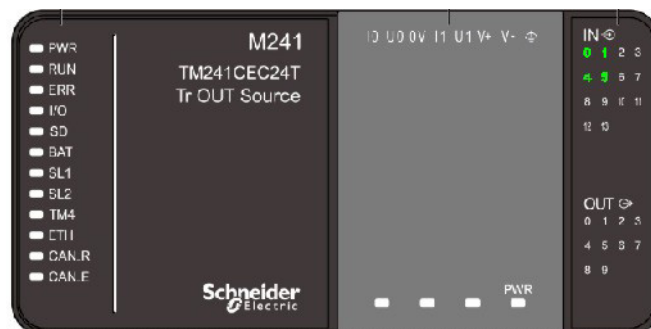


FIG. 3-30

See Figure 3-31.

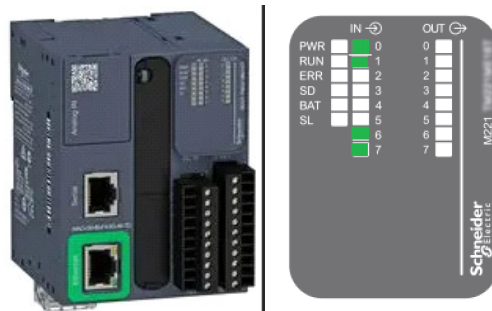


FIG. 3-31

LED should blink during the saw head movement. If LEDs of the encoder don't blink or only one of them blinks, check encoder power supply and damage of the connecting wires.

Voltage on the connectors between brown and blue wire should be ~24VDC.

### 3.7.6 Incorrect up/down movement direction

See Figure 3-32.

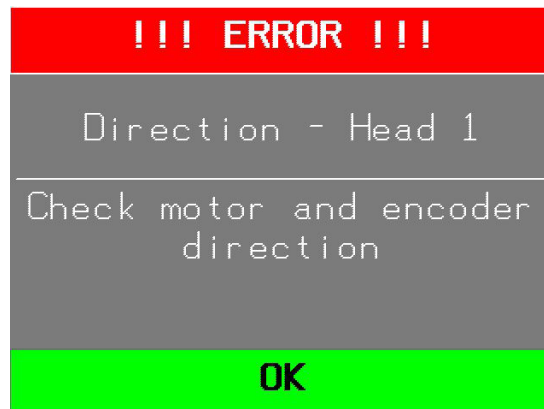


FIG. 3-32

This error may be caused by improper connection of the encoder or up/down motor. Enter the Diagnostic mode. Check if saw head is moving up when you press the UP arrow button and down when you press the DOWN arrow button.

If not, invert the phases on the motor or on the up/down motor contactors.

If the saw head movement is still incorrect, change places of the wires on the PLC controller (or PLC



module) input - black and white wires.

### 3.7.7 Limit Switches

See Figure 3-33.

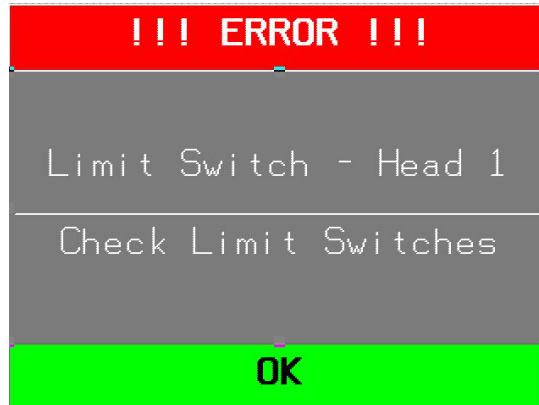


FIG. 3-33

Possible error cause:

- Saw head run on the up/down limit switch
- limit switch or wire between limit switch and connector is damaged
- wire between connector and inputs LI4 or LI5 of the drive are damaged.

When saw head run on the limit switch, it can move in the opposite direction.

Press the window with saw head number/mode to move to the extended drive status.

See Figure 3-34.

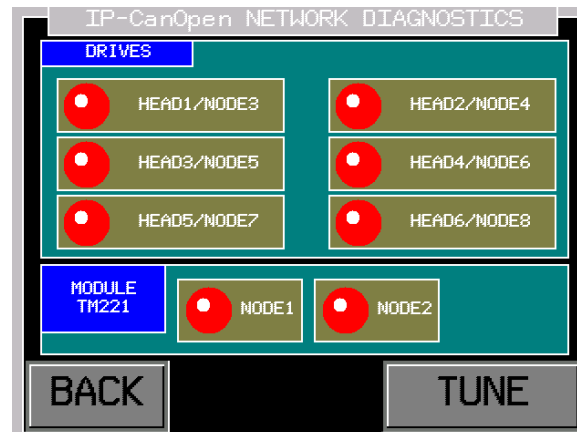


FIG. 3-7

The following window will appear:

See Figure 3-35.

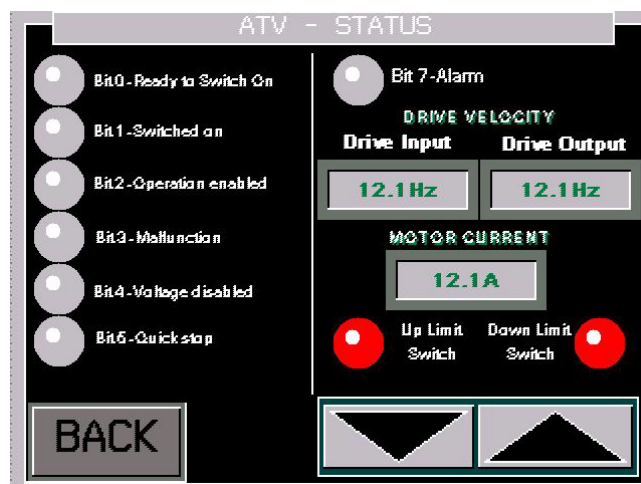


FIG. 3-8

The status of a limit switch can be checked on the diagnostic screen for CanOpen devices, after selecting one of the saw heads from NODE 3 to NODE 8.

Green – limit switch is released, Red – limit switch on (is active)

If the saw head is not on the limit switch and limit switch LED is on, check the limit switch and next check connections between limit switch and drive.

### 3.7.8 Positioning error

See Figure 3-36.



FIG. 3-9

Saw head run too slow or too far.

It is connected with saw head movement parameters on the TUNING screen:

See Figure 3-37.

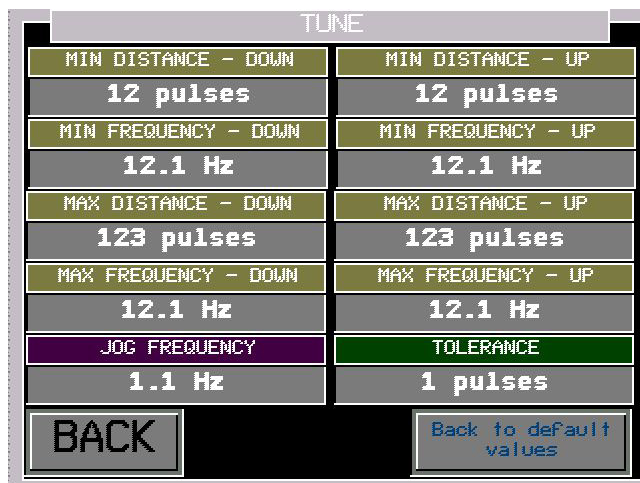


FIG. 3-10

First push BACK TO DEFAULT VALUES button, to set the factory set, default positioning parameters.

If error occurs once more, please contact with Wood-Mizer Customer Service.

**Caution!** – All changes have to be agreed with Wood-Mizer Customer Service! These parameters influence up/down operation.

## SECTION 4 MAINTENANCE

This section lists the maintenance procedures that need to be performed.



**This symbol** identifies the interval (hours of operation) at which each maintenance procedure should be performed.

Be sure to refer to the motor manual for maintenance procedures concerning the blade motor.

### 4.1 Wear Life

**See Table 4-1.** This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. Due to the many variables which exist during resaw operation, actual part life may vary significantly. This information is provided so that you may plan ahead in ordering replacement parts.

Part Description	Estimated Life
B57 Blade Wheel Belts	500 hours
Blade Guide Rollers	1000 hours
Drive Belt	1250 hours

**TABLE 4-1**

### 4.2 Blade Guides

1. Check the rollers for performance and wear every blade change. Make sure the rollers are clean and spinning freely. If not, rebuild them. Replace any rollers which have worn smooth or have become cone shaped. See the Parts manual for blade guide rebuild kits and complete roller assemblies.

### 4.3 Sawdust Removal

1. Remove the excess sawdust from the blade wheel housing and sawdust chute every blade change.

### 4.4 Vertical Mast



Clean the vertical mast angles, wipe them dry and lubricate with a WD40 oil every 50 hours of operation.



**CAUTION!** Never use grease on the mast angles as it will collect sawdust.

## 4.5 Miscellaneous Lubrication

1. Apply a thin film of a lithium grease to the blade guide arm to help prevent it from rusting.

50

2. Lubricate the feed track chain with an easily penetrating oil such as WD-40.

50



**CAUTION!** Never apply grease to the feed track chain. It causes sawdust buildup in chain links.

3. Make sure all safety warning decals are readable. Remove sawdust and dirt. Replace any damaged or unreadable decals immediately. Order decals from your Customer Service Representative.

4. Lubricate the acme screws (screws for saw head tilting and raising or lowering) with a lithium grease every 50 hours of operation.

50

5. Every 200 hours of machine operation, check the oil level and the condition of the drive-side wheel shaft seals. To check the oil level, unscrew the oil drain plug (marked with E in Figure 4-1). The oil level should be at the lower edge of the oil drain hole.

200

6. Every 8000 hours or 3 years of operation, replace the oil in the drive-side blade wheel shaft. To drain the oil, loosen the adjustment bolts (A, B, C). Unscrew the breather plug (D). Then remove the oil drain plug (E). Turn the shaft so that the oil drain hole is at the bottom of the shaft. After draining the used oil, reinstall the oil drain plug and turn the shaft to its original position. Tighten the adjustment bolts. Pour about 200 ml of a synthetic oil (e.g. Mobil SHS 624) through the breather hole. The oil must meet the specifications given in the ISO 12925-1 CKB Standard. Screw in the breather plug. Check the oil level - see Step 5.

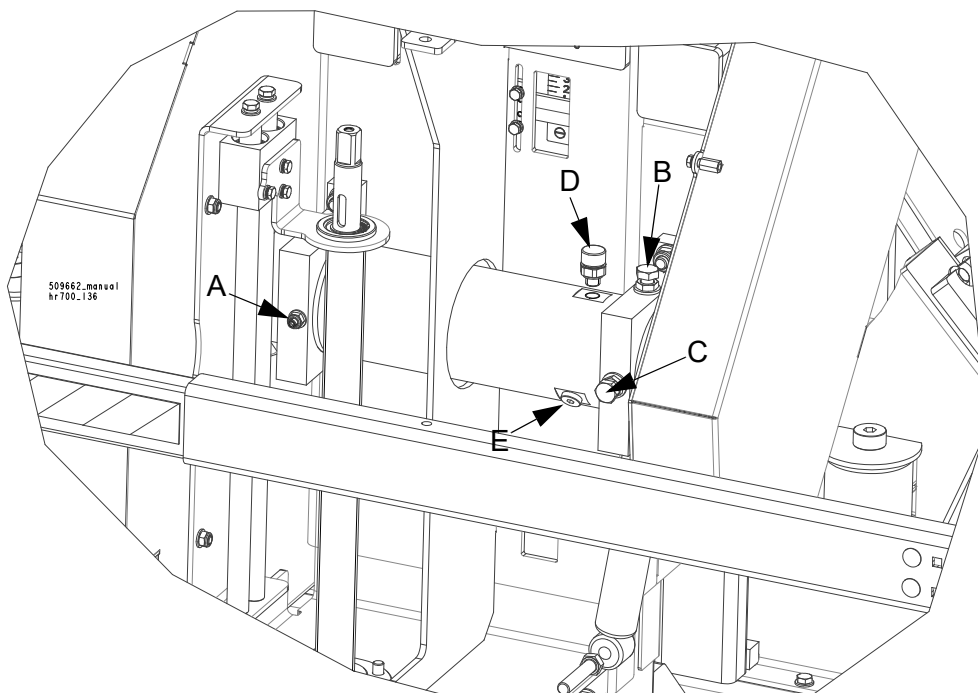


FIG. 4-1

## 4.6 Belts

1. Check the blade wheel belts for wear every 50 hours of operation. Replace as needed.
2. Periodically check all belts for wear. Replace any damaged or worn belts as needed.

## 4.7 Drive Belt Adjustment

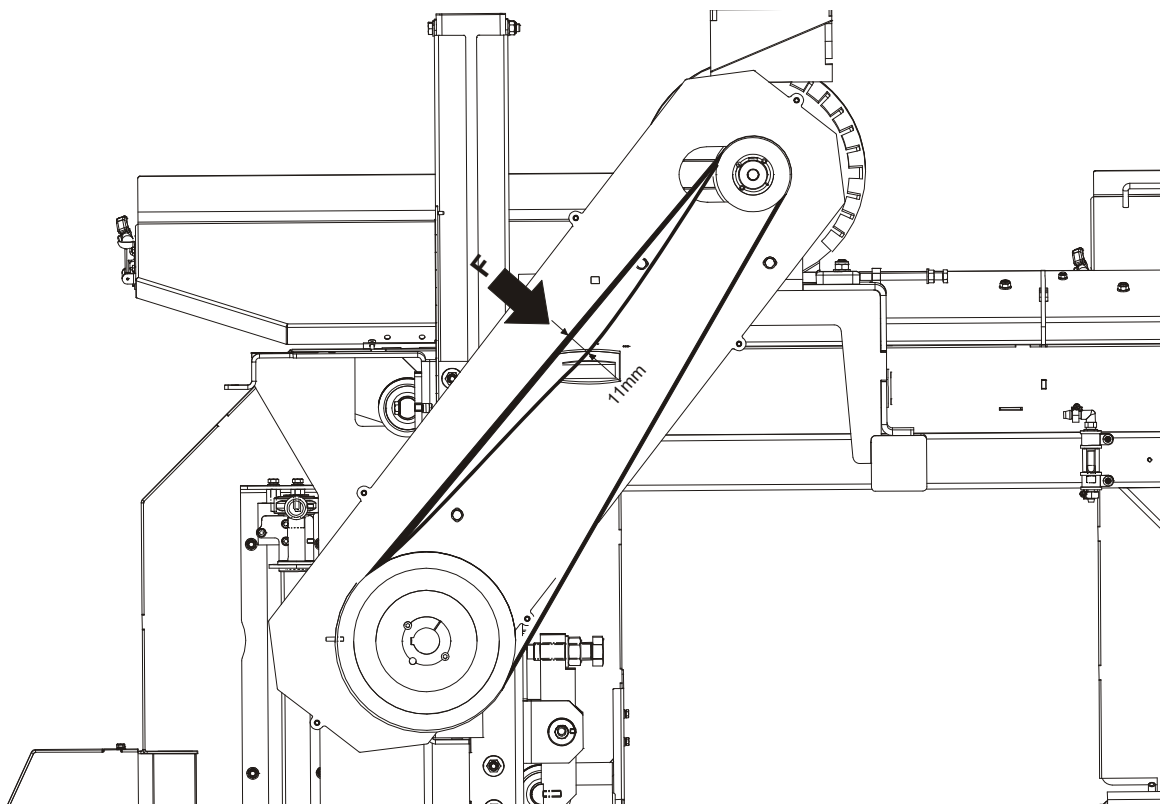


**WARNING!** Do not for any reason adjust the drive belt with the motor running. Doing so may result in serious injury.

See **Table 4-2**. Check the drive belt tension after the first 20 hours, and every 50 hours thereafter. See the table below for drive belt tension specifications for your resaw.

Motor	Belt Tension
E11, E15	7/16" (11mm) deflection with 16 lbs. (7.2 KG) of deflection force

**TABLE 4-2**



**FIG. 4-2**

To adjust the drive belt tension:

1. Remove the drive belt guard.
2. Loosen the four motor mounting bolts (see Figure 3-3).
3. Loosen one of the adjustment bolts, shown in Figure 3-3, and turn the other until the belt has proper deflection. (To increase the belt tension, you must loosen the right bolt and appropriately turn the left one.) **NOTE:** Be sure to adjust the bolts evenly so the motor remains in alignment.
4. Tighten the four motor mounting bolts.

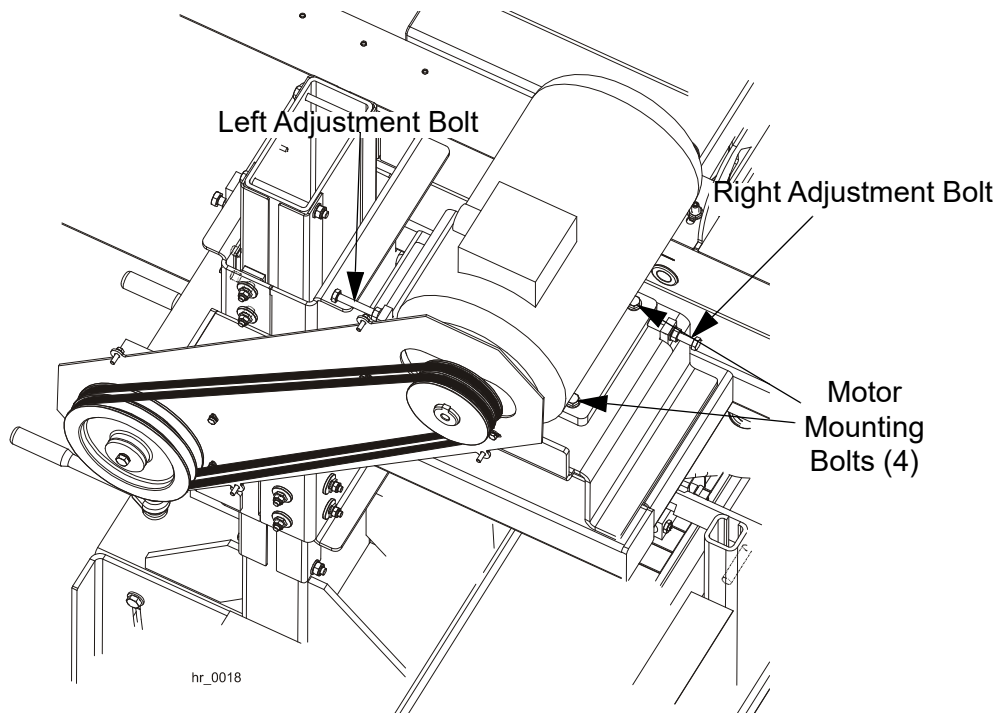


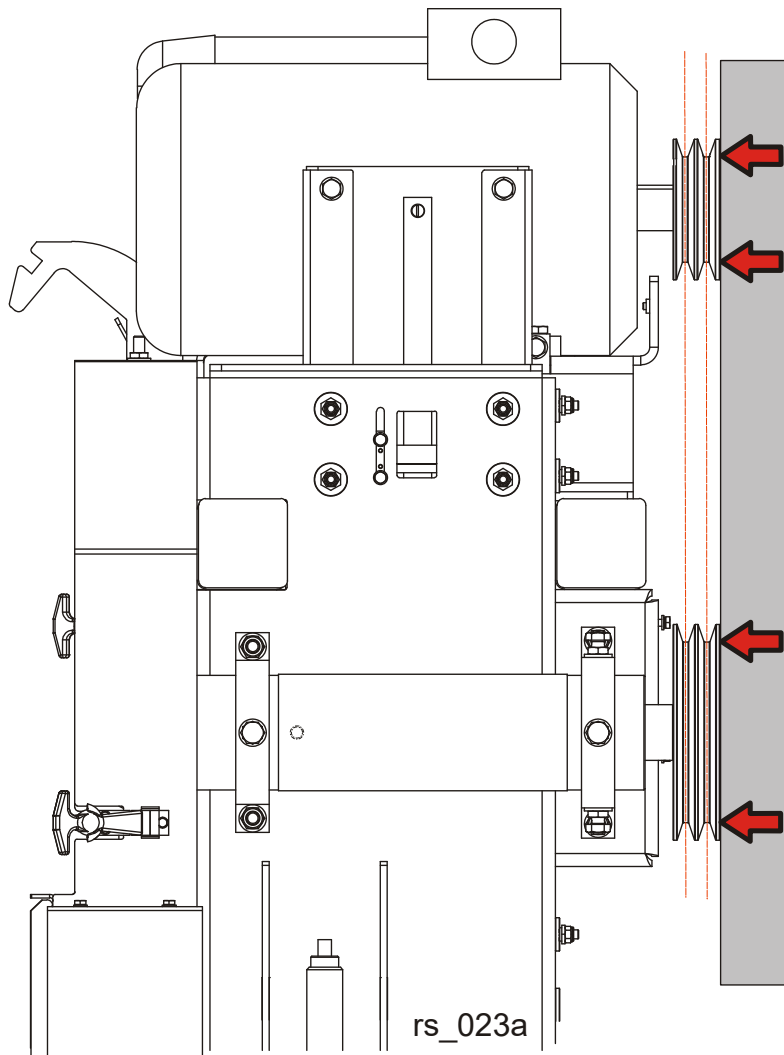
FIG. 4-3



Periodically check the belt for wear. Replace if damaged or worn.

**See Figure 4-4.** Keep the motor and drive pulleys aligned to prevent premature belt wear. Attach a straight lath to the front surfaces of the motor and the wheel drive pulleys. It should touch the pulleys on the entire length. To align the motor pulley and the drive pulley, loosen the set screw (or taper lock bushing set screw) in the motor pulley groove and slide the motor pulley on the shaft until it is in line with the drive pulley. After performing the alignment, make sure the drive belt tension has not been

changed.



**FIG. 4-5**



## 4.8 Feed Track Chain Tension

See Figure 4-6. If necessary, use the adjustment bolts shown below to adjust the feed track chain tension. **NOTE:** The bolts must be adjusted evenly.

See Figure 4-7.

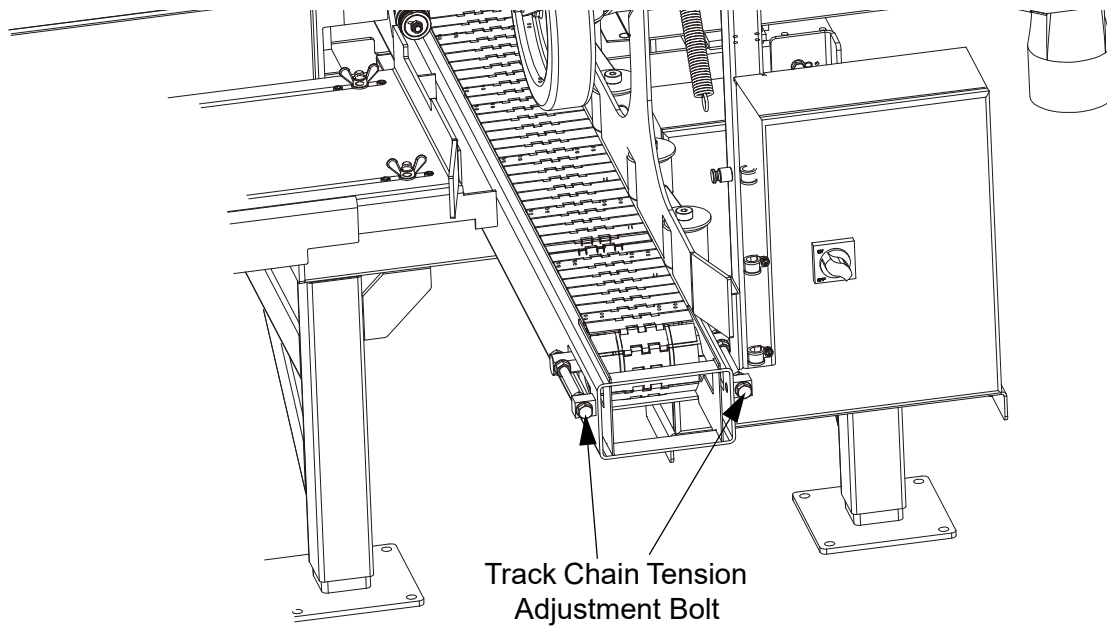


FIG. 4-8

## 4.9 Up/Down System

1. Lubricate the two acme screws, shown below, with a lithium grease every fifty hours of operation, but at least once a week.

50

See Figure 4-9.

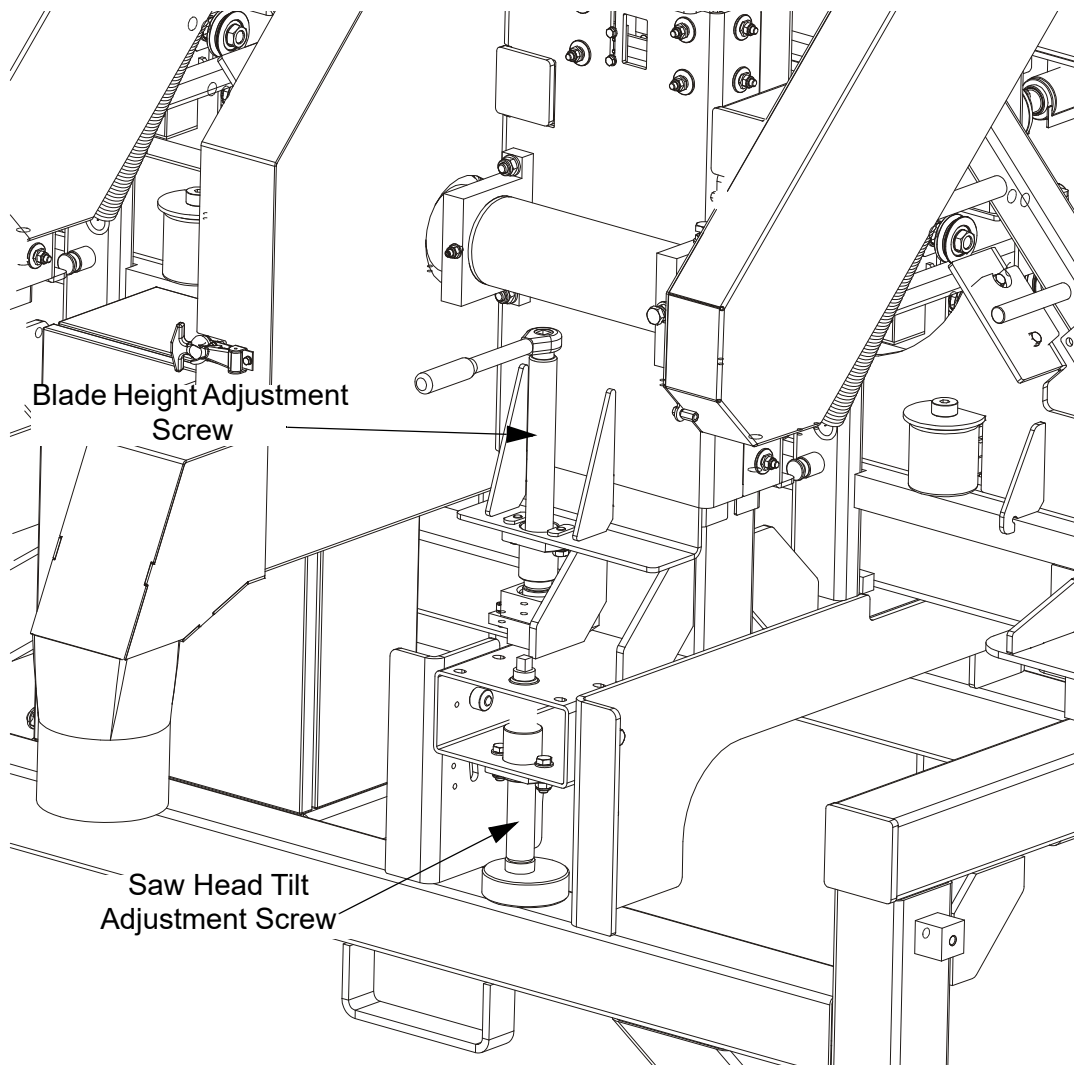


FIG. 4-10

## 4.10 Safety Devices Inspection

### *HR Safety Devices Inspection*

Before beginning a shift, the following safety devices of the HR resaw should always be checked:

- E-STOP button circuit - control box
- E-STOP button circuit - frame
- Safety switch circuit - 1-6 saw heads
- Motor brake and its circuit

#### 1. Control box and main electric box E-STOP circuit inspection

- Start the main motor;
- Push the E-STOP button located on the control box. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.
- Push the E-STOP button located on the main control box. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.

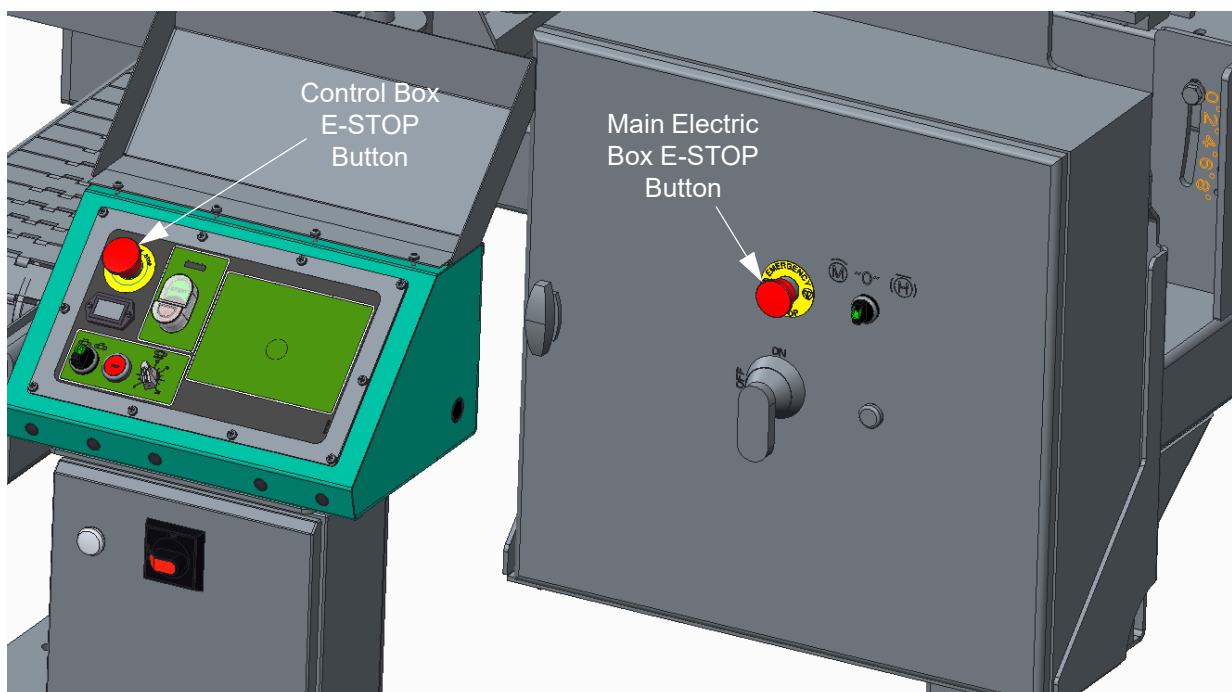


FIG. 4-11

## 2. Frame E-STOP circuit inspection

- Start the main motor;
- Push the E-STOP button located on the machine frame. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.

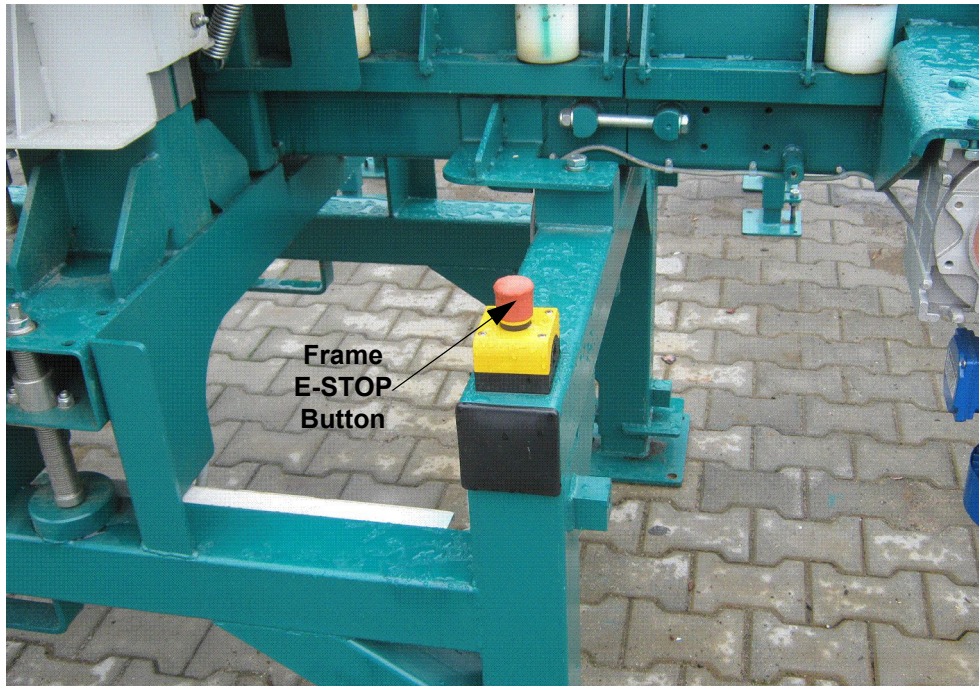


FIG. 4-12

## 3. Safety switch circuit inspection - 1 - 6 saw heads

- Start the main motors;
- Open the blade housing cover No.1;
- The main motor of the saw head No.1 should stop;
- Try to start the motor of the saw head No.1 using the START button. The motor cannot be started.
- Close the blade housing cover No.1;
- The motor should remain turned off.



- Repeat the above steps for all remaining saw heads.

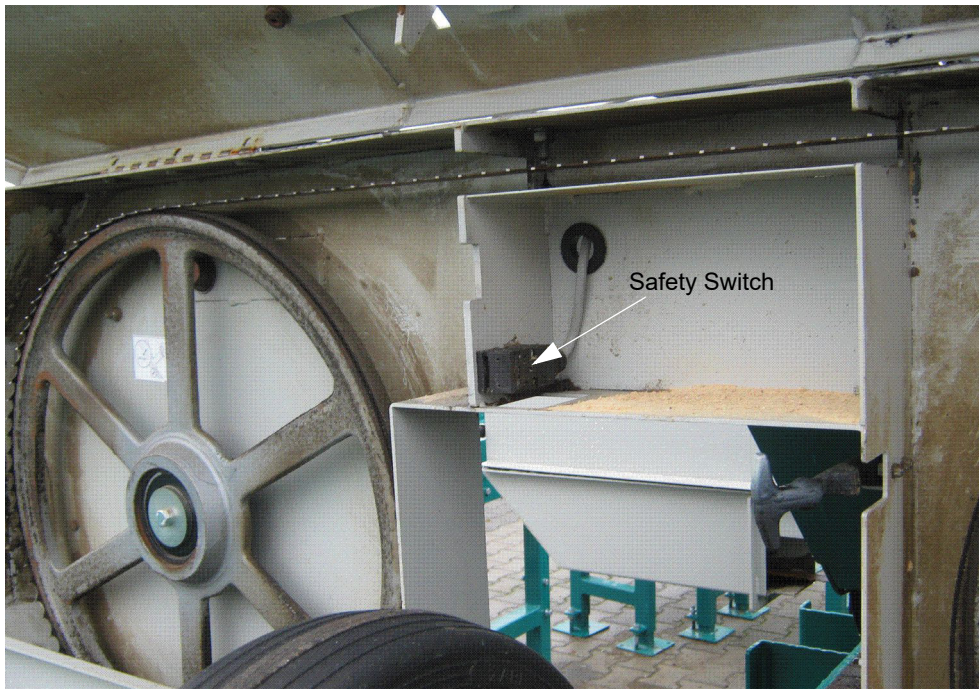


FIG. 4-13

#### 6. Main motor brakes and their circuits

- Start the main motor of the saw head No.1. Then stop the motor by pushing the STOP button. Measure the braking time.
- Start the main motor of the saw head No.1. Then turn the key switch to the "0" position to stop the motor. Measure the braking time.
- Start the main motor of the saw head No.1. Then stop the motor by turning the key switch to the "H" position. Measure the braking time.
- Repeat the above steps for all remaining saw heads.

The motor braking time should be shorter than 10 seconds. If it is longer, adjust or replace the brake linings. (See the motor manual.)

### ***Optional Return Table Safety Devices Inspection***

Before beginning a shift, the following safety devices of the Return Table should always be checked:

- E-STOP button circuit - control box
- E-STOP button circuit - frame

#### **1. E-STOP button circuit - control box**

- Start the main motor;
- Push the E-STOP button located on the control box. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.

#### **2. E-STOP button circuit - frame**

- Start the main motor;
- Push the E-STOP button located on the frame. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.

## SECTION 5 ALIGNMENT

### 5.1 Alignment Procedures

The Wood-Mizer resaw is factory aligned. This section includes instructions on how to realign the resaw completely. Be scrupulous when performing all alignment steps as resaw alignment determines the accuracy of your cuts. The alignment procedure should be performed approximately every 1500 hours of operation.

#### **Routine Alignment Procedure:**

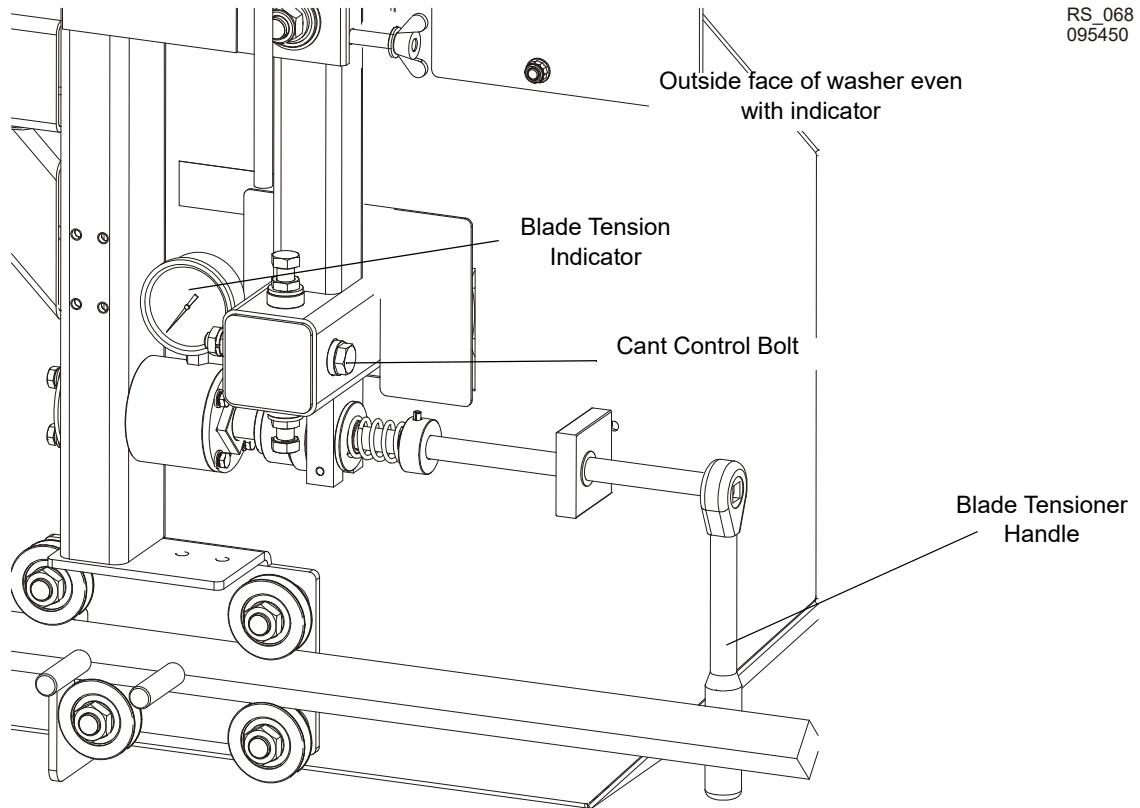
1. Install and track the blade ([See Section 5.2](#)).
2. Check and adjust the vertical alignment of the blade guide arm ([See Section 5.5](#)).
3. Check and adjust the horizontal alignment of the blade guide arm ([See Section 4.6](#)).
4. Check and adjust the vertical angle of the blade guides ([See Section 5.9](#)).
5. Check and adjust the horizontal angle of the blade guides ([See Section 4.11](#)).
6. Check and adjust the spacing between the blade guide flanges and the back of the blade ([See Section 5.10](#)).
7. Check that the blade height scale accurately displays the actual distance from the bottom of the blade to the feed track and adjust if necessary ([See Section 4.13](#)).

#### **Complete Alignment Procedure:**

Perform all steps in this section to completely realign the resaw.

## 5.2 Blade Installation And Tracking

See Figure 5-1. Install a blade and apply the proper tension as shown below. [See Section 2.4](#)



**FIG. 5-1**



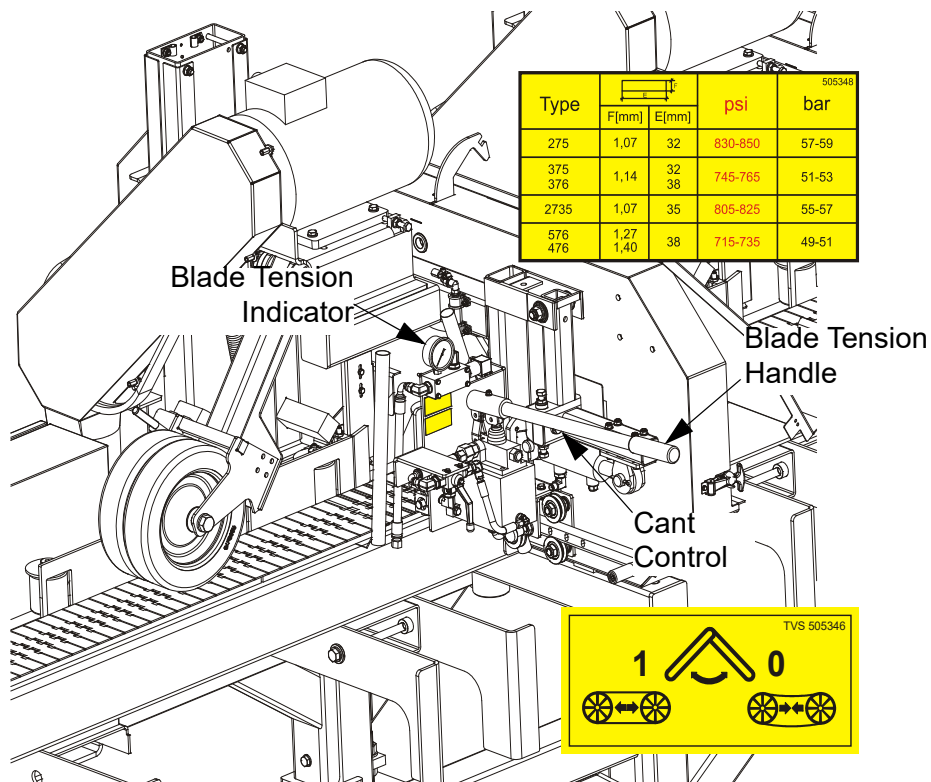


FIG. 5-1

1. Turn the key switch to the "H" position.



2. Open the blade housing cover.
3. Manually spin one of the blade wheels until the blade positions itself on the wheels.

**See Figure 5-2.** The blade wheels should be adjusted so that the gullet of 1 1/4" blades rides 3.0 mm (0.12") out from the front edge of the wheels ( $\pm 1.0$  mm [0.04"]). The gullet of 1 1/2" blades should ride 4.5 mm (0.18") from the front edge of the wheels ( $\pm 1.0$  mm [0.04"]). Do not let the teeth

ride on the belt.

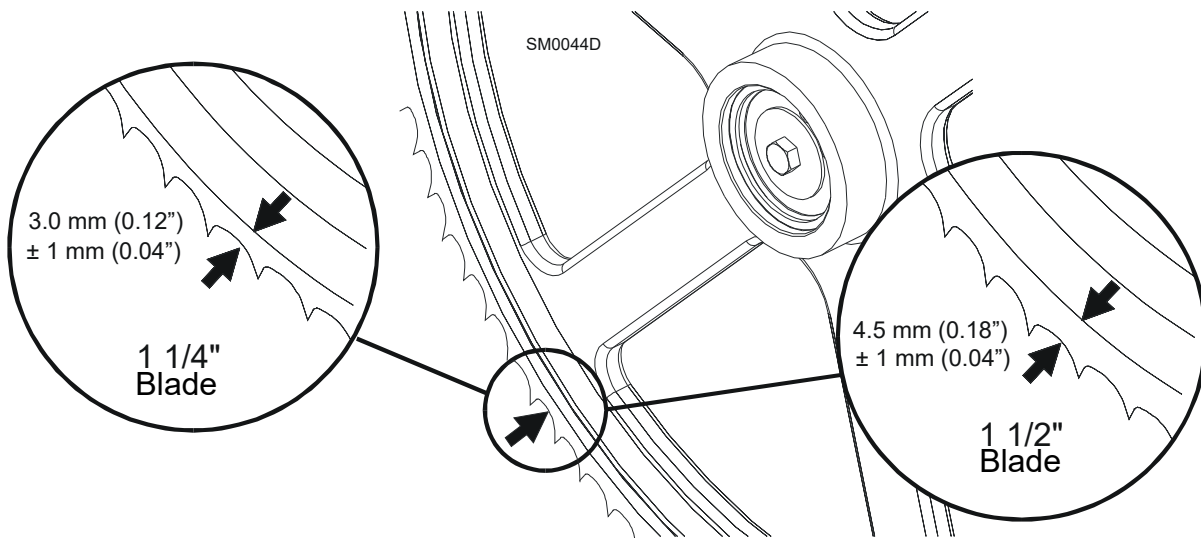


FIG. 5-2

To adjust where the blade travels on the idle-side blade wheel, use the cant control shown in **Figure 5-7**.

To move the blade out on the blade wheel, turn the cant adjustment bolt clockwise. To move the blade in on the blade wheel, turn the bolt counterclockwise.

Some adjustment in blade tension may be needed to compensate for adjustments made with the cant control.

Adjustment with the cant control is usually all that is required to track the blade properly on both blade wheels. The drive-side blade wheel will usually not have to be adjusted. If necessary, the drive-side wheel can be adjusted as follows:

Locate the nuts and the clamping screws on the drive-side of the cutting head. If the blade is too far forward on the wheel, turn the screw located on the inside of the head counterclockwise and turn the screw located on the outside of the head clockwise. Make sure to tighten the nuts against the shaft housing when adjustment is complete.

### 5.3 Blade Wheel Alignment

The blade wheels should be adjusted so they are level in the vertical and horizontal planes. If the blade wheels are tilted up or down, the blade will want to travel in the tilted direction. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels.

1. Use the blade guide alignment tool to check the vertical alignment of each blade wheel. Attach the tool to the blade near the inner blade guide mount. Be sure the tool does not rest on a tooth or burr, and is lying flat against the blade.

See Figure 5-3.

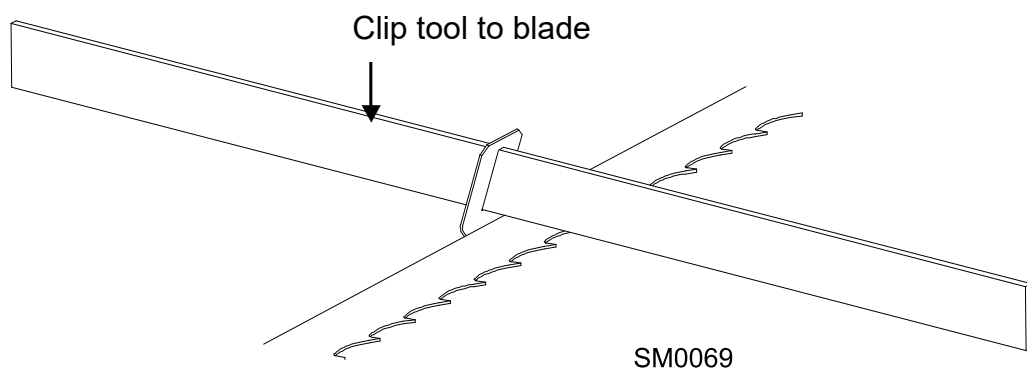


FIG. 5-3

2. Measure from the bottom of the tool to the top of the feed track.
3. If the two measurements differ by more than ( $\pm 1.0$  mm (0.04")), adjust the vertical tilt of the drive-side blade wheel.

See **Figure 5-4**. Use the vertical adjustment screws (marked with the blue and yellow arrows in the figure below) to adjust the drive-side blade wheel. Before adjusting the wheel, loosen the drive belt using the adjustment bolts marked with the orange arrows in the figure. Loosen the jam nut and the hex socket head screw marked with the red arrow in the figure and adjust the wheel with the vertical adjustment screws. To tilt the wheel down, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts. To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts. Tension the drive belt properly ([See Section 3.8](#)).

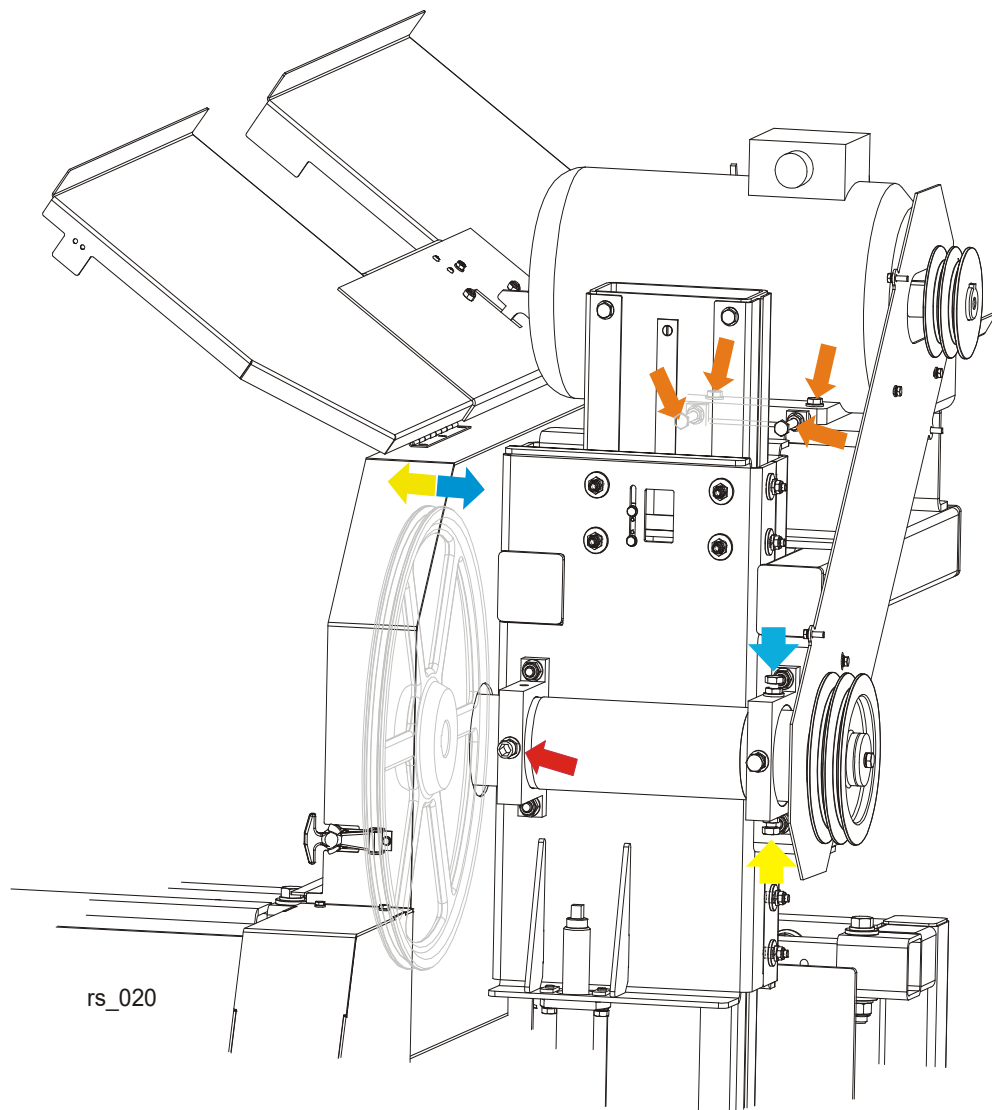
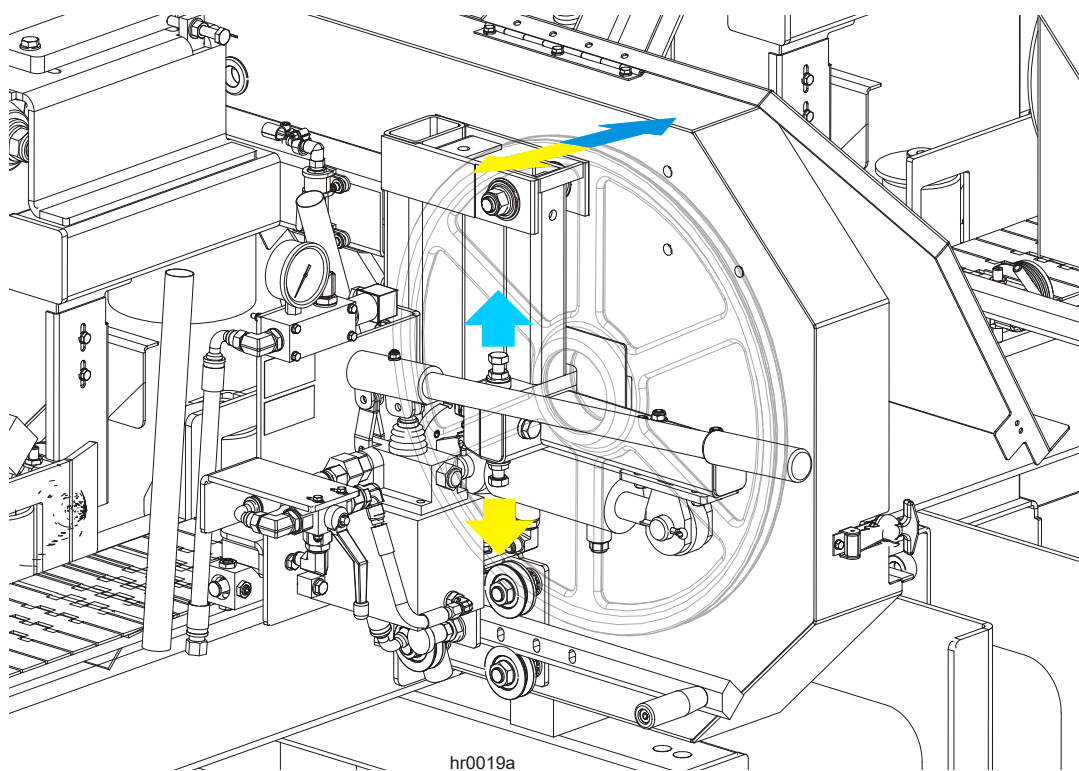


FIG. 5-4

4. Recheck the vertical tilt of the drive-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the feed track ( $\pm 1.0$  mm (0.04")).
5. Remove the tool from the blade and reattach it near the outer blade guide assembly.
6. Measure from the tool to the feed track at both ends of the tool. If the measurements at the front and rear ends of the tool differ more than ( $\pm 1.0$  mm (0.04")), adjust the vertical tilt of the idle-side blade wheel.

**See Figure 5-5.** Use the vertical adjustment screws to adjust the idle-side blade wheel. To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel down, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

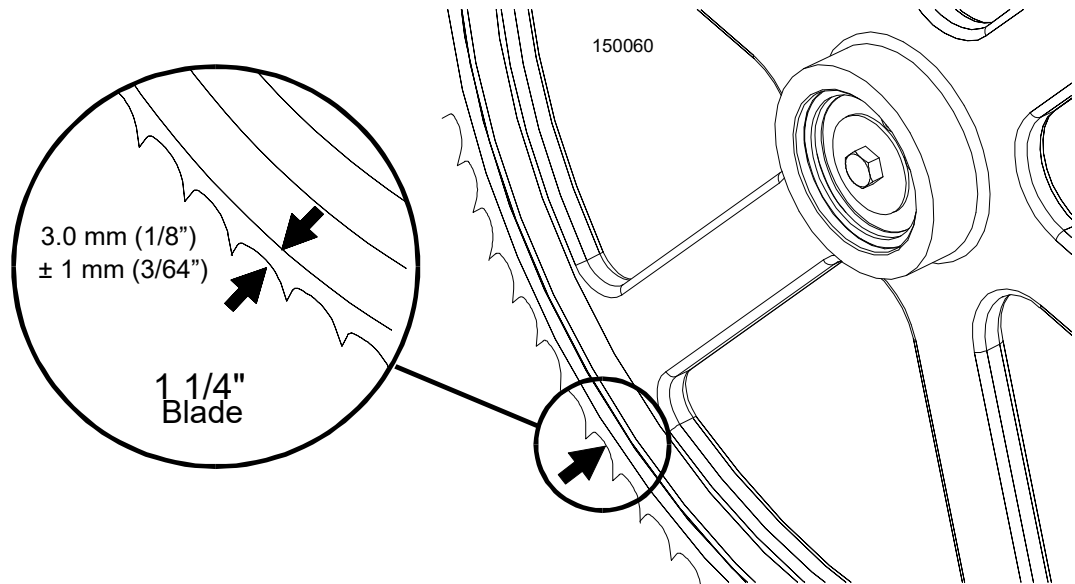


**FIG. 5-5**

7. Recheck the vertical tilt of the idle-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the feed track.

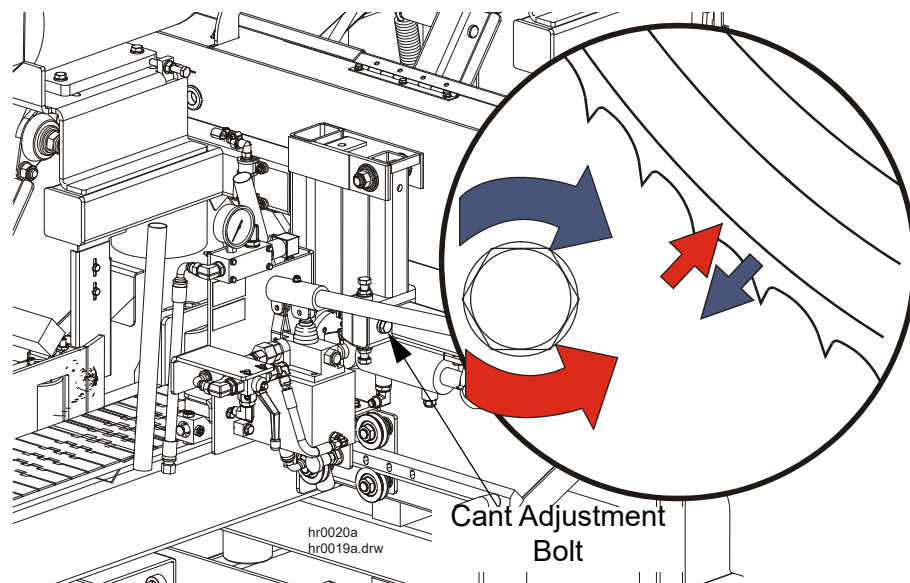
8. Check the position of the blade on the idle-side blade wheel.

See **Figure 5-6**. The horizontal tilt of the blade wheel should be adjusted so that the gullet of an 1-1/4" blade is 3.0 mm out from the front edge of the wheel ( $\pm 1.0$  mm (0.04")).



**FIG. 5-6**

See **Figure 5-7**. Use the cant control adjustment to adjust the idle-side blade wheel. If the blade is too far forward on the wheel, turn the cant control counterclockwise. If it is too far back on the wheel, turn the cant control clockwise.



**FIG. 5-7**

9. Check the position of the blade on the drive-side blade wheel. The blade should be positioned on the wheel as described for the idle-side blade wheel. Adjust the drive-side blade wheel if necessary.

**See Figure 5-8.** Use the horizontal adjustment screws (marked with the blue and yellow arrows in the figure below) to adjust the drive-side blade wheel. Before adjusting the wheel, loosen the drive belt using the adjustment bolts marked with the orange arrows in the figure.

To move the blade back on the wheel, loosen the right adjustment screw one quarter turn. Loosen the jam nut on the left adjustment screw and tighten the screw. Tighten the left and right jam nuts.

To move the blade out on the wheel, loosen the left adjustment screw one quarter turn. Loosen the jam nut on the right adjustment screw and tighten the screw. Tighten the left and right jam nuts. When the adjustment is complete, tension the drive belt properly ([See Section 3.8](#)).

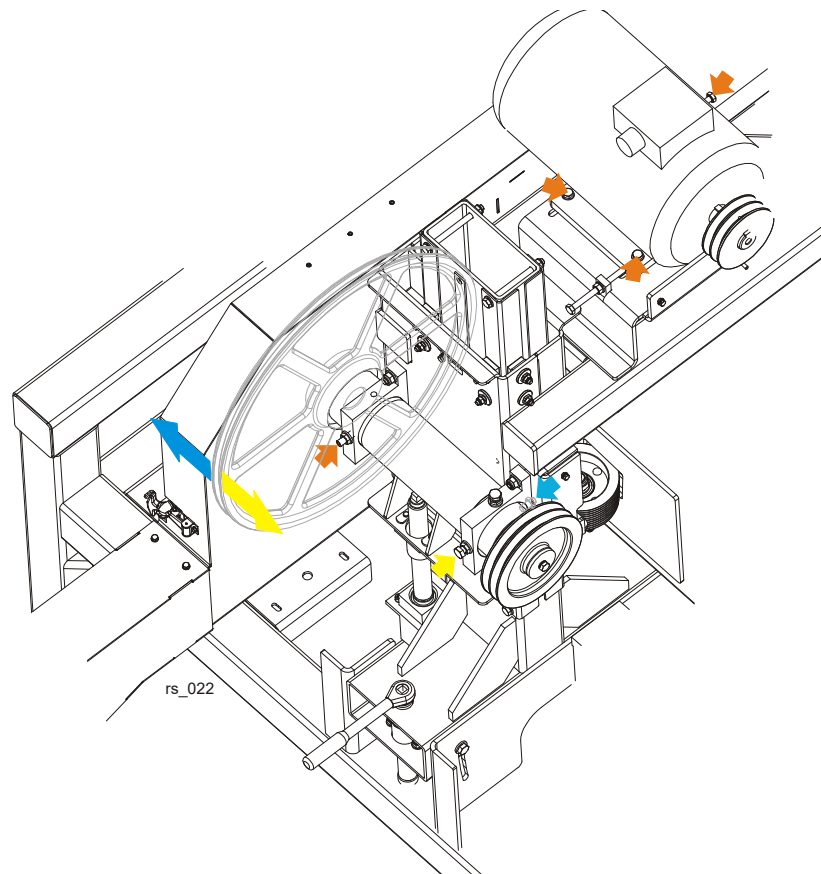


FIG. 5-8

## 5.4 Saw Head Adjustment

See **Figure 5-9**. The saw head should be set perpendicularly to the vertical mast. Using the two sets of adjustment screws in the mast slide pads, you can adjust the saw head in relation to the mast. To raise or lower the outside of the saw head, loosen the locking nuts on either of the sets of screws. Then turn the adjustment nuts clockwise to raise the outside of the saw head or counterclockwise to lower the outside of the saw head. **NOTE:** Be sure to adjust the nuts evenly so the slide pad is parallel to the mast tube. If further adjustment is needed and one set of the nuts has been fully adjusted, use the other set of nuts.

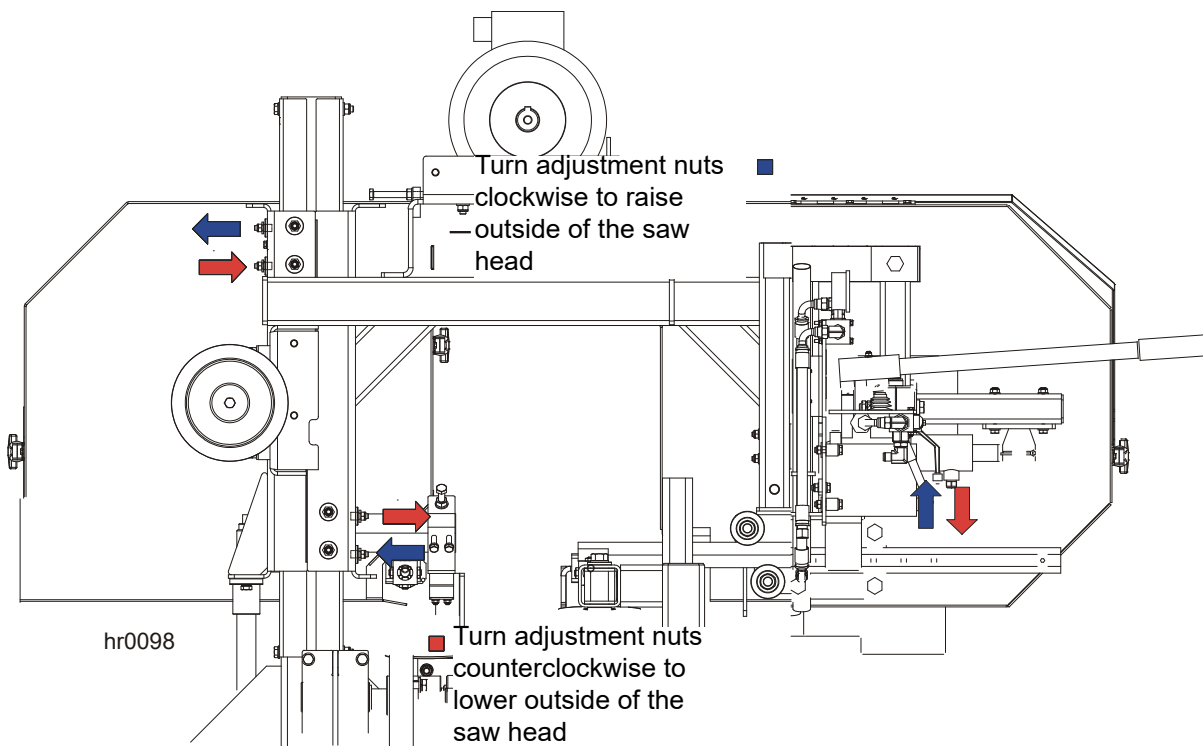


FIG. 5-9



## 5.5 Blade Guide Arm Vertical Adjustment

1. Adjust the blade guide arm out to within 1/2" (15 mm) of full open.
2. Measure the distance from the top surface of the feed track to the arm.

See Figure 5-10.

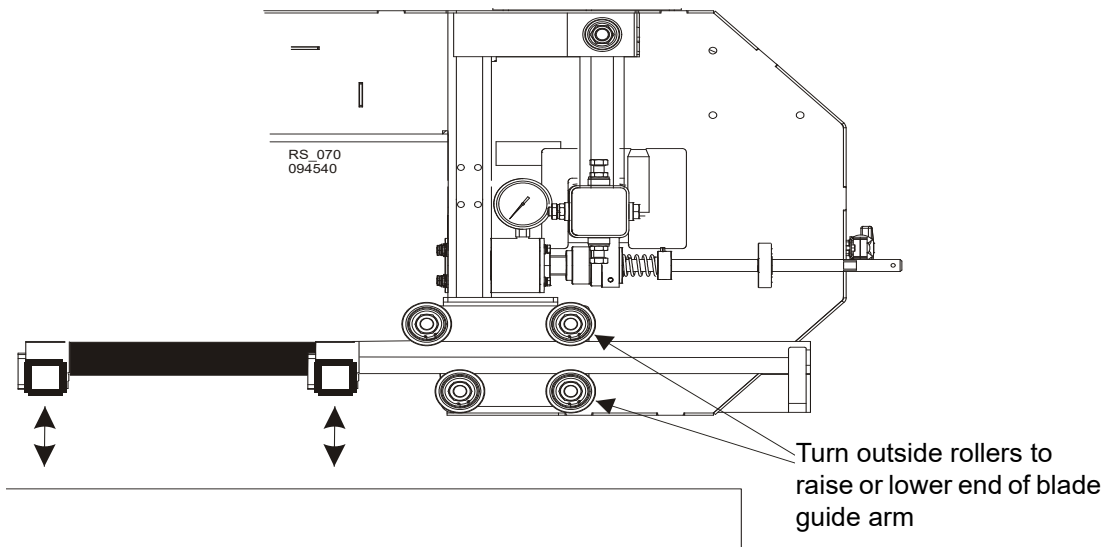


FIG. 5-10

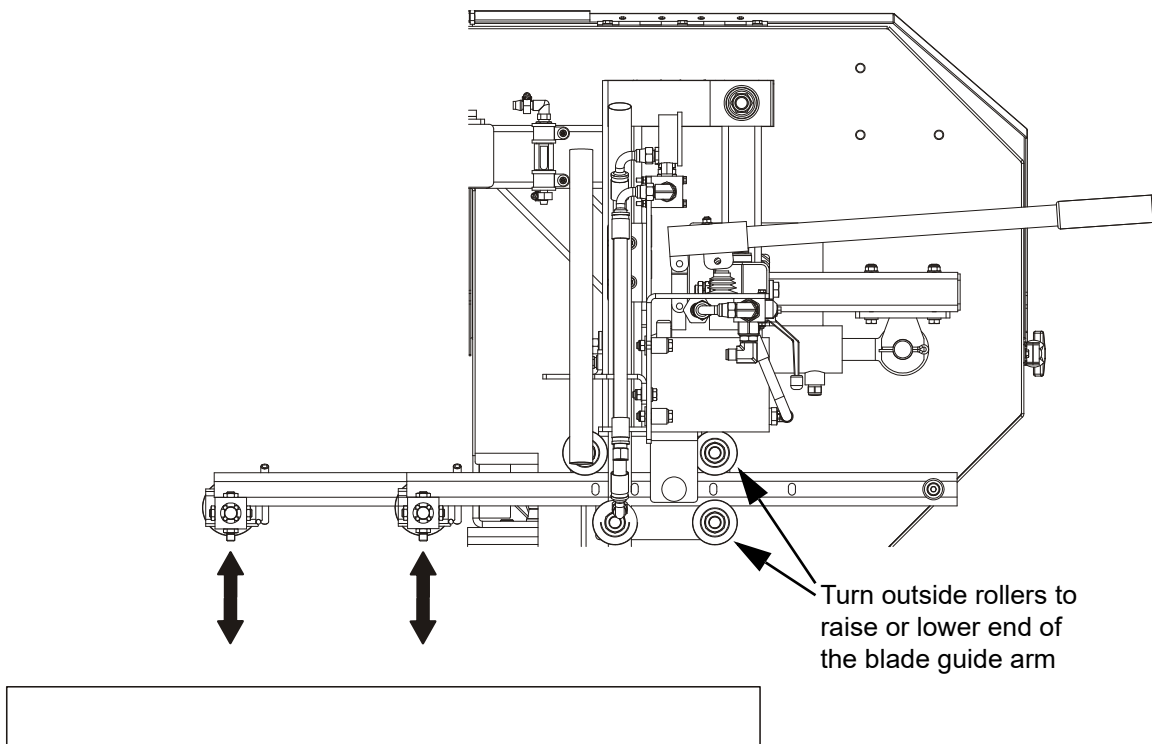


FIG. 5-10

3. Adjust the blade guide arm in to within 1/2" (15 mm) of full closed. Measure again the distance between the arm and the feed track.
4. Adjust the arm so that the measurement from the top of the track feed to the arm in the closed position is the same as the measurement from the top of the track feed to the arm in the open position.

If the arm is too low in the closed position, loosen the lower outside roller and tighten the upper outside roller. (See Step 5.)

If the arm is too high in the closed position, loosen the upper outside roller and tighten the lower outside roller. (See Step 5.)

5. The rollers are mounted on cam bolts that raise or lower the arm when turned.

To adjust the rollers, locate the cam bolt inside the housing and turn until the arm is lowered or raised as needed. Recheck the arm in both, open and closed positions. Repeat adjustments until the arm is the same distance from the track feed in the open and closed position.

6. The blade guide arm should be snug, but not too tight, in the rollers. You should be able to move it in and out with firm hand pressure. There should be no side-to-side play.

## 5.6 Blade Guide Arm Horizontal Adjustment

1. Put the blade guide assembly back in the arm (if you took it out). Put the assembly back so that the flanged collar on the roller is about 3.0 mm (0.04") from the back of the blade when the arm is 15 mm (0.6") from full open.
2. Close the throat to within 15 mm (0.6") from fully closed. Check to see that the flange is the same distance from the back of the blade.

See Figure 5-11.

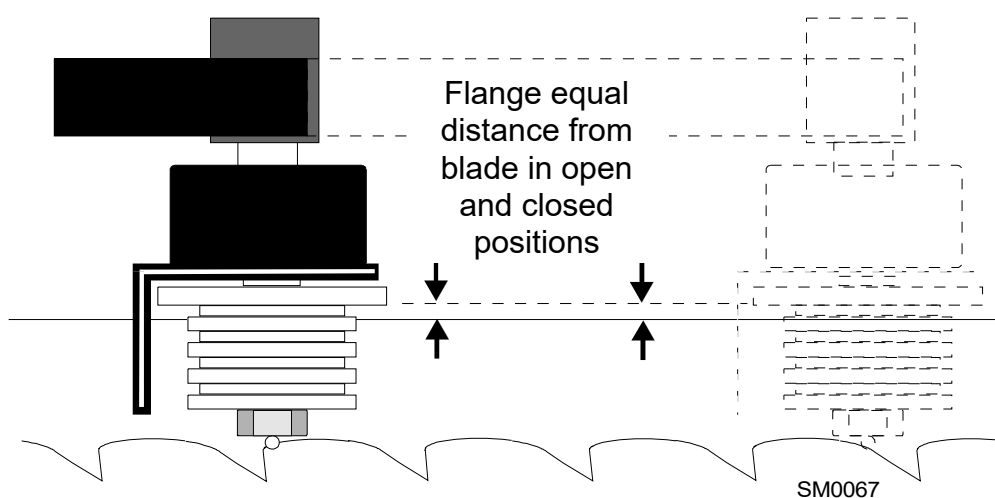


FIG. 5-11

3. If adjustment is needed, the guide rollers can be adjusted in or out on the threaded mounts to open or close the gap.

See Figure 5-12.

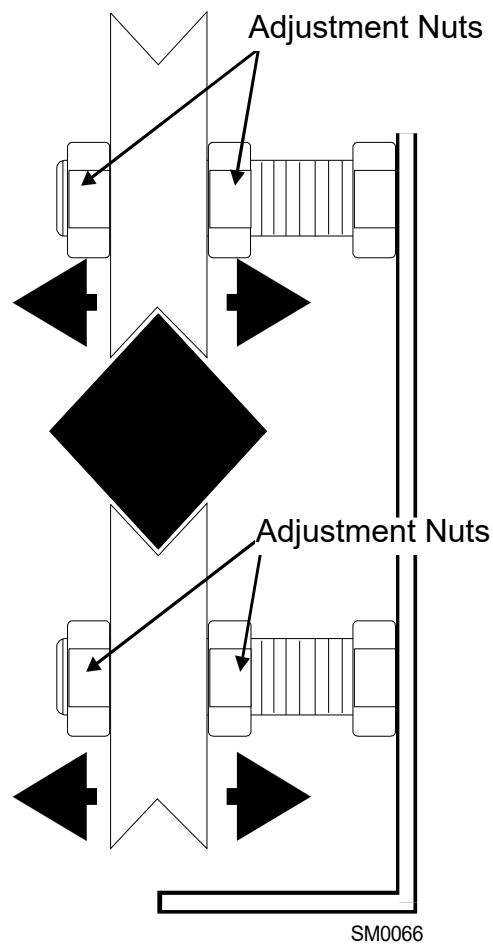


FIG. 5-12

4. Adjusting the outside two rollers inward will cause the flange to move away from the blade.
5. Adjusting the two outside rollers outward will cause the flange to move toward the blade.
6. Adjust until the roller flange is the same distance from the back of the blade in the open and closed position.

## 5.7 Aligning the Blade Guides

Each Wood-Mizer resaw has two blade guide assemblies that help the blade maintain a straight cut. The two blade guide assemblies are positioned on the cutting head to guide the blade on each side of the material being cut.

One blade guide assembly is mounted in a stationary position on the drive side of the cutting head. This assembly is referred to as the "inner" blade guide assembly.

The other blade guide assembly is mounted on the idle side of the cutting head. It is referred to as the "outer" assembly and is adjustable for various widths of materials to be processed.

Blade guide alignment includes four steps:

- Blade Deflection,
- Blade Guide Vertical Tilt,
- Blade Guide Flange Spacing,
- Blade Guide Horizontal Tilt.

Perform the blade guide alignment after you have aligned the blade on the wheels. After blade guide alignment, check the scale indicator to make sure it is adjusted properly ([See Section 4.13](#)).

**NOTE:** During blade guide alignment, remove the blade guide adjusting screws and apply lubricating oil such as 10W30 or Dexron III to each screw. This will prevent the screws and threaded holes from corroding and makes screw adjustments easier.

## 5.8 Blade Deflection

Perform the following steps to achieve proper blade deflection with the blade guides.

1. Raise the saw head until the blade is 200 mm (7.9") above the feed track. Measure the actual distance with a tape from the top of the track to the bottom of the blade.
2. Install the blade guides. Make sure the two set screws shown are threaded into the blade guide shaft until they touch each other.

See Figure 5-13.

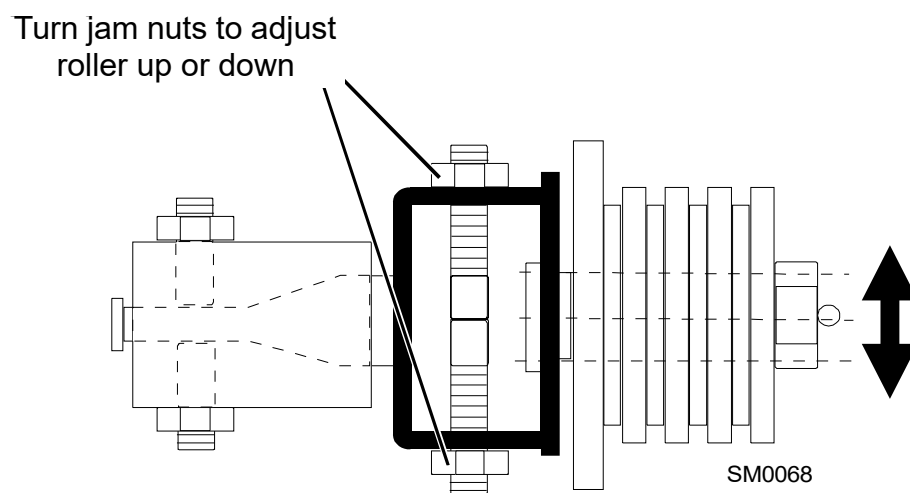


FIG. 5-13

3. Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down 6.0 mm (0.24").
4. Repeat for the other blade guide.

**NOTE:** Be sure that the blade guide touches the blade in both guide assemblies. The outer blade guide should be checked with the arm all the way in and all the way out.

## 5.9 Blade Guide Vertical Tilt Adjustment

Check that the blade guide does not tilt the blade up or down. A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

1. Open the blade guide arm 15 mm (0.6") from full open.
2. Clamp the alignment tool on the blade. Position the tool close to a blade guide roller. Be sure the tool does not rest on a tooth or burr, and is lying flat on the blade.

See Figure 5-14.

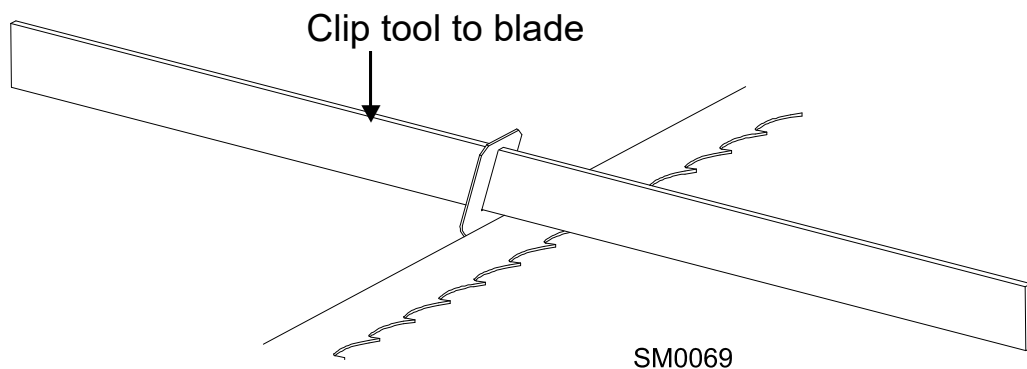


FIG. 5-14

3. Measure the distance from the bottom of the tool to the feed track chain at the center of the tool and then at the front end of the tool.
4. The two distances should be equal. If they differ, adjust the vertical tilt of the blade guide using the adjustment screws shown in the figure below.

**See Figure 5-15.** Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten the top screw. To tilt the roller down, loosen the top

screw and tighten the bottom screw. Tighten the jam nuts and recheck the tilt of the blade.

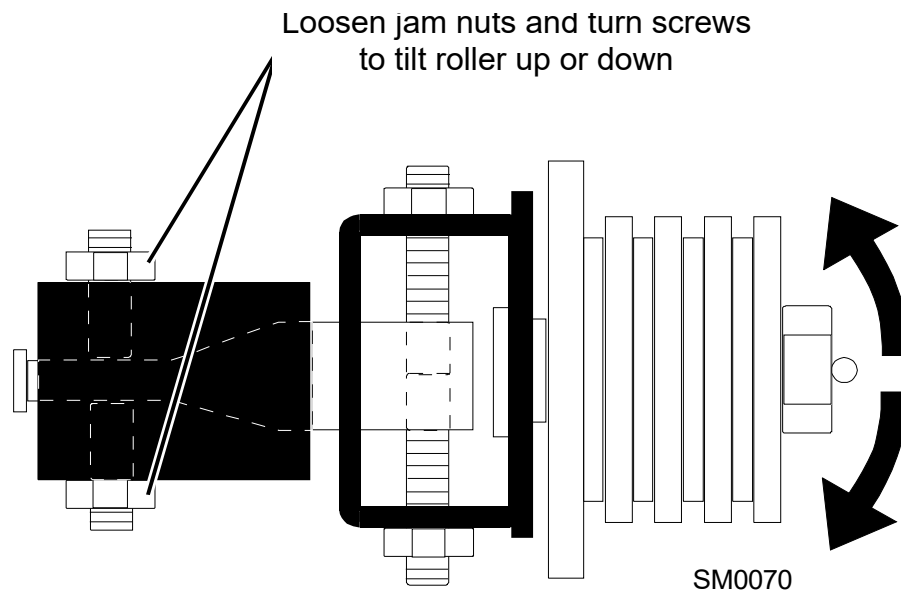


FIG. 5-15

5. Measure the distance from the bottom of the tool to the top of the feed track chain at the rear end of the tool. If the measurement does not equal the other two measurements taken, readjust the vertical tilt of the blade guide.
6. Move the blade guide alignment tool close to the other blade guide and repeat the above steps. Adjust the vertical tilt of this guide if necessary.

**NOTE:** If major adjustments to blade guide tilt were made, measure the distance between the blade and the feed track chain again to ensure the correct 6.0 mm (0.24") blade guide deflection. Adjust if necessary.



## 5.10 Blade Guide Spacing

**HINT:** When adjusting the blade guide spacing, loosen the top set screw and one side set screw only. This will ensure horizontal and vertical tilt adjustments are maintained when the set screws are retightened.

1. Adjust the inner blade guide so the blade guide flange is approximately 1.5 – 3.0 mm (0.06 - 0.12") from the back of the blade.
2. Loosen one side and one top set screw shown. Tap the blade guide forward or backward until properly positioned.

See Figure 5-16.

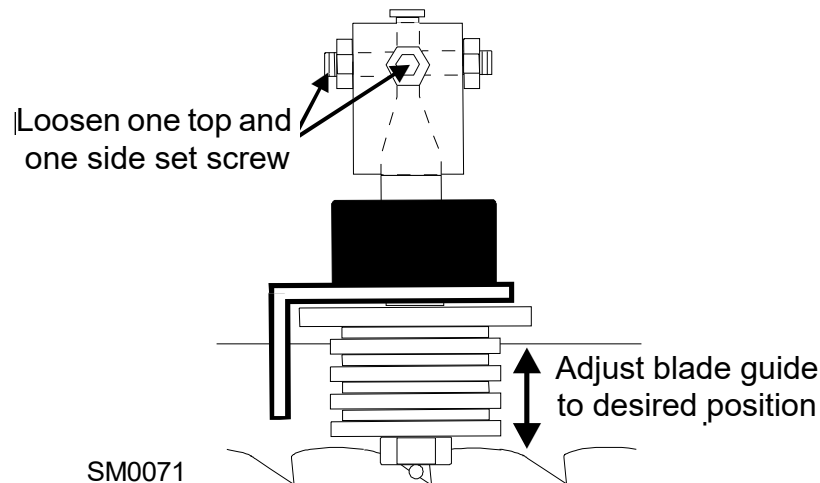


FIG. 5-16

3. Retighten the two set screws.
4. Adjust the outer blade guide in the same way so the blade guide flange is approximately 1.5 – 3.0 mm (0.06 - 0.12") from the back of the blade.

## 5.11 Blade Guide Horizontal Tilt Adjustment

1. Finally, both blade guides must be tilted horizontally. Adjust the blade guide arm halfway in.

See Figure 5-17.

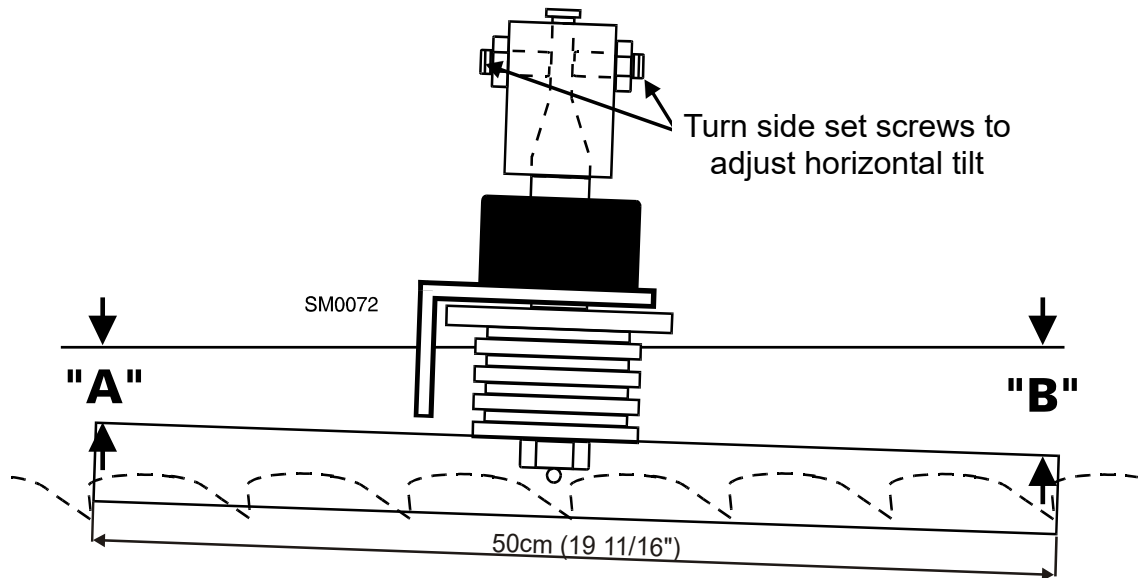


FIG. 5-17

2. Place the Blade Guide Alignment Tool against the face of the outer blade guide roller.
3. Center the tool on the roller and measure between the back edge of the blade and the ruler at the end closest to the inner blade guide ("B").
4. Measure between the back edge of the blade and the other end of the ruler ("A").
5. The roller should be tilted slightly to the left ( $A = B - 6.0 \text{ mm [0.24"]}$ ).
6. Use the side set screws to adjust the horizontal tilt of the roller.
7. Repeat steps 3-7 for the inner blade guide roller.

**NOTE:** Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. See the Wood-Mizer® Blade Handbook, Form #600.

## 5.12 Blade Height Scale Adjustment

After the entire resaw has been aligned and all adjustments have been made, check that the blade height scale indicates the true distance from the blade to the feed track chain.

1. Measure from the bottom edge on a down-set tooth of the blade to the top of the feed track chain.

See Figure 5-18.

2. View the blade height scale with eyes level with the indicator.

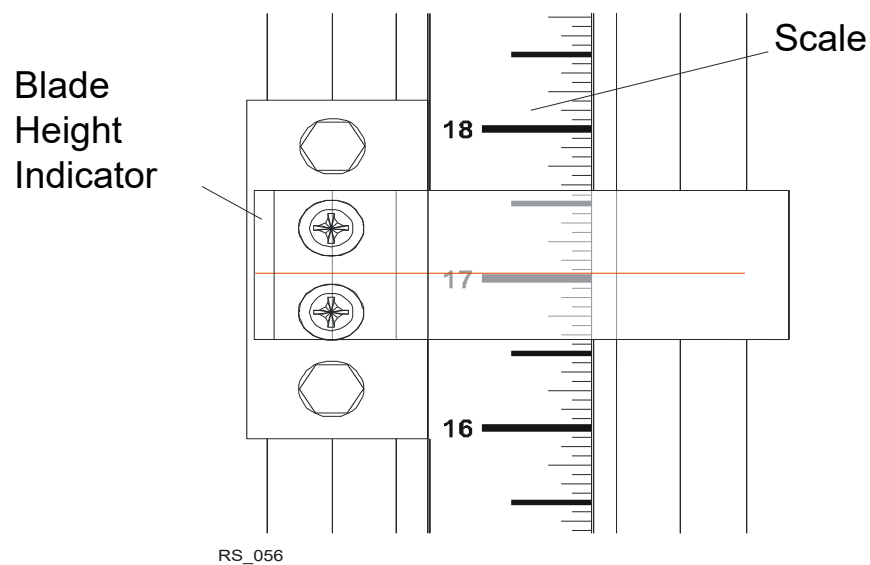


FIG. 5-18

3. Loosen the indicator bracket mounting bolts and adjust the bracket until the indicator is aligned with the correct mark on the scale. Retighten the bracket mounting bolts.

For example, if the measurement from the blade to the feed track chain is 100 mm (3.9"), make sure the indicator reads 100 mm (3.9") on the scale.

### 5.13 Optional Return Table Conveyor Belt Tension Adjustment

See Figure 5-19.

1. Loosen the bolts (A)
2. Using adjustment nuts (B) adjust tension of the belt. Adjusting must be done evenly.
3. Tighten the bolts (A).

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525284\_MANUAL

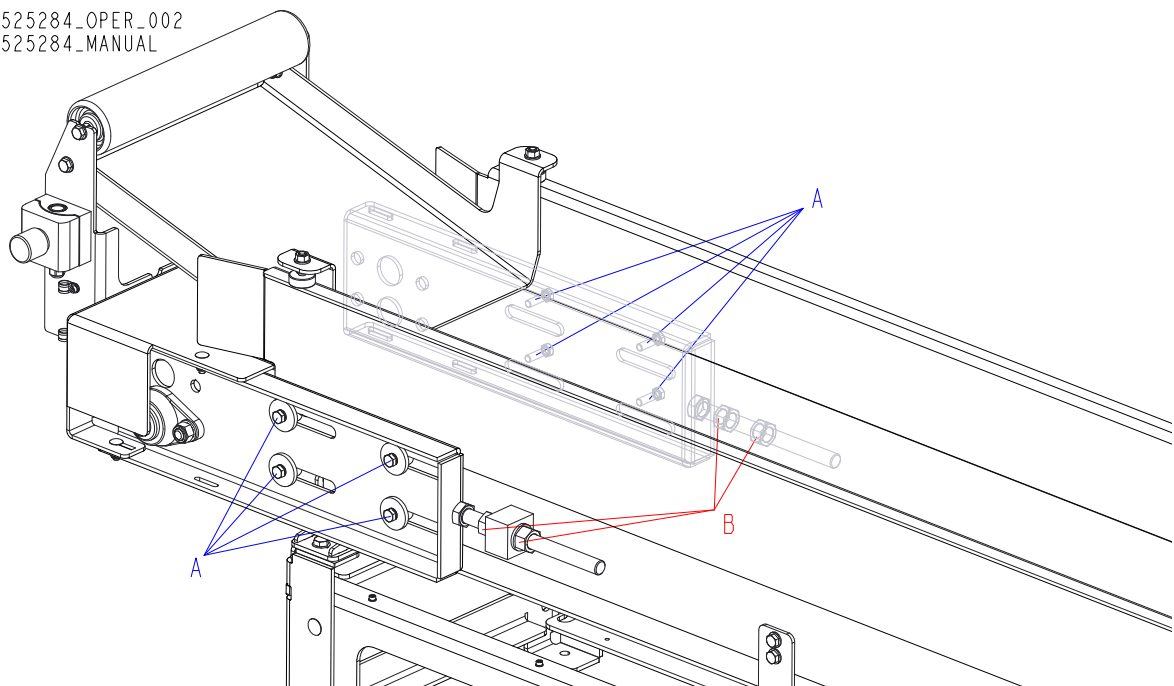


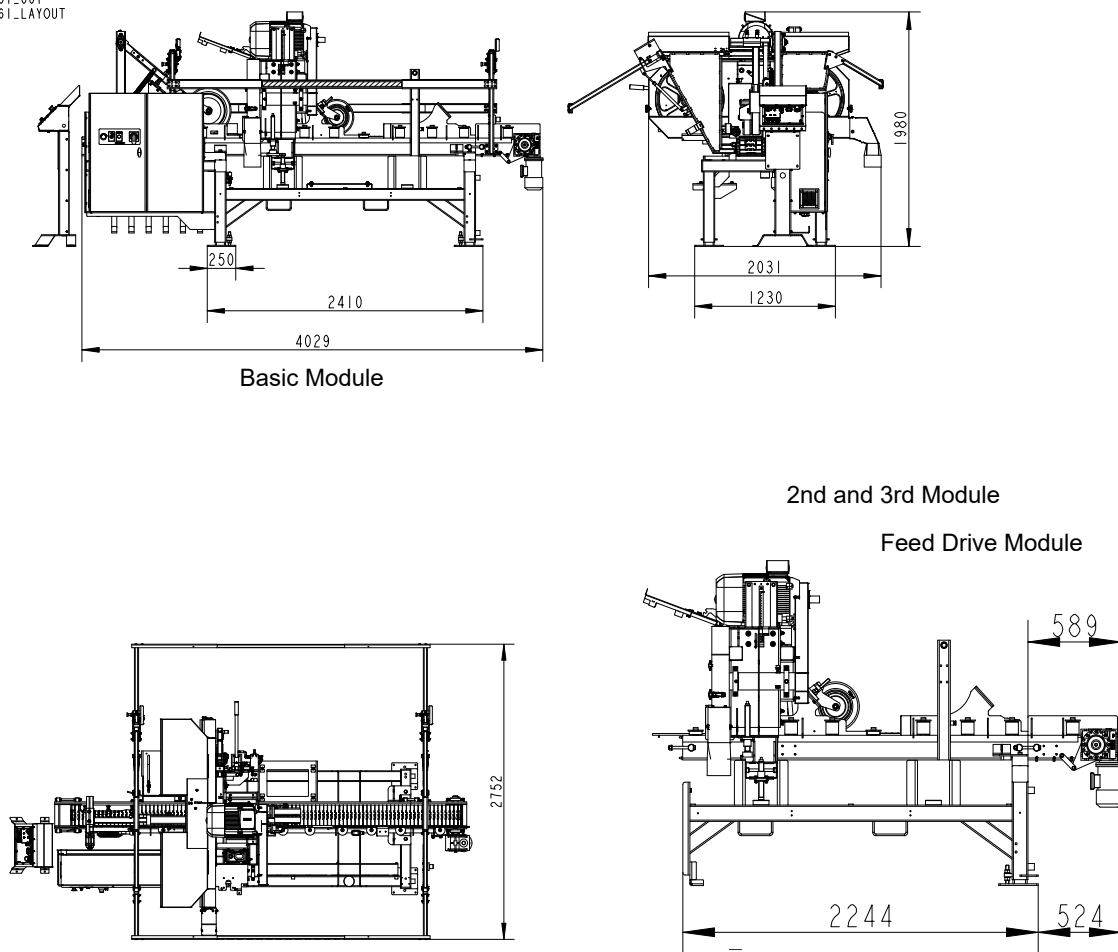
FIG. 5-19

## SECTION 6 SPECIFICATIONS

### 6.1 Overall Dimensions

See **Figure 6-1**. The major dimensions of the resaw are shown below (all dimensions are in millimeters).

HR500-1\_099661\_001  
HR500-1\_099661\_LAYOUT



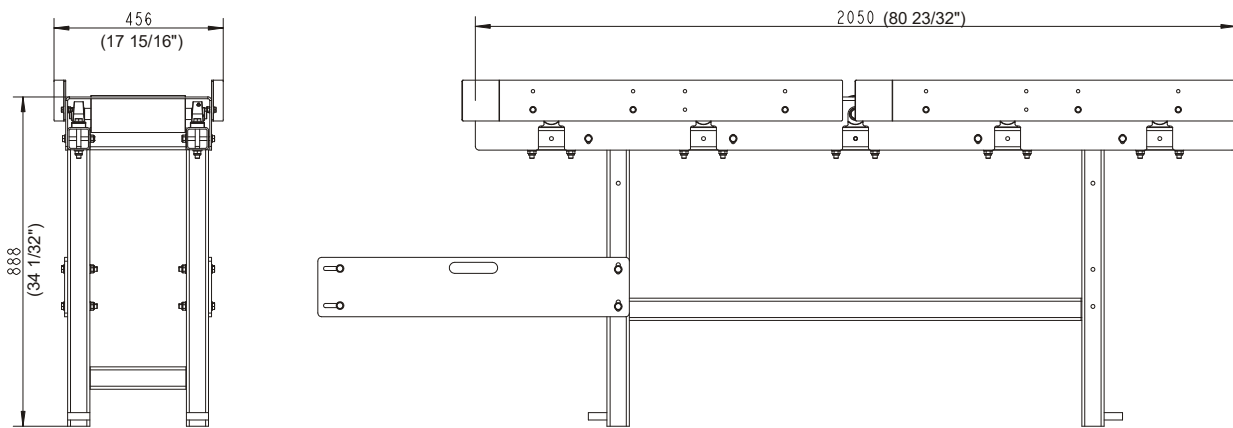
**FIG. 6-1**

See **Table 6-1**. The overall dimensions of the resaw are listed in the table below.<sup>1</sup>

<b>Weight</b>	1552 kg (3422 lb) (base 2-head module) 1290 kg (2844 lb) (2-head extension)
<b>Height</b>	1900 mm (74.8")
<b>Width</b>	2050 mm (80.7")
<b>Length</b>	First Module: 3510 mm (138.2") Second and Third Module: 2250mm (88.6")

**TABLE 6-1**

See **Figure 6-2**. The major dimensions of the Idle Roller Table (SLPIRT) are shown below.



**FIG. 6-2**

1. For overall dimensions of the HR500 Resaw equipped with optional MGR handling system, see the MGR Handling System manual - form#742.

See Figure 6-3. See the figure below for the major dimensions of the Cross Roller Table (SLPCRT).

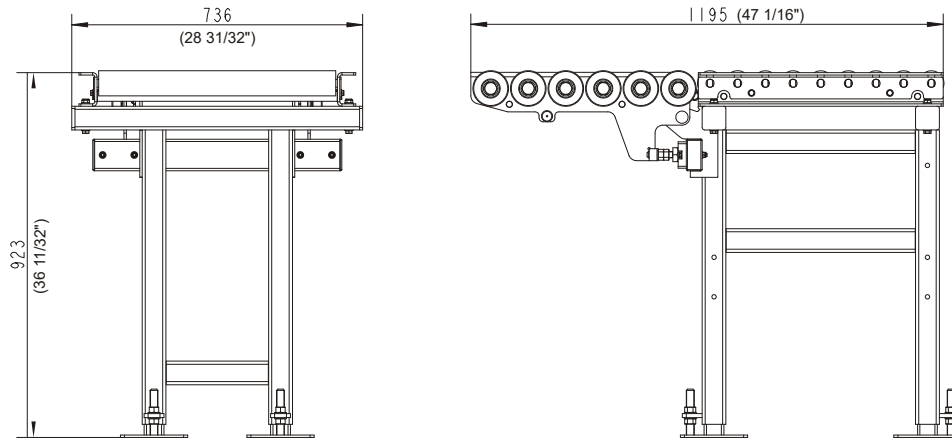


FIG. 6-3

See Figure 6-4. See the figure below for the major dimensions of the HR500/700 -1, -2 RETURN TABLE.

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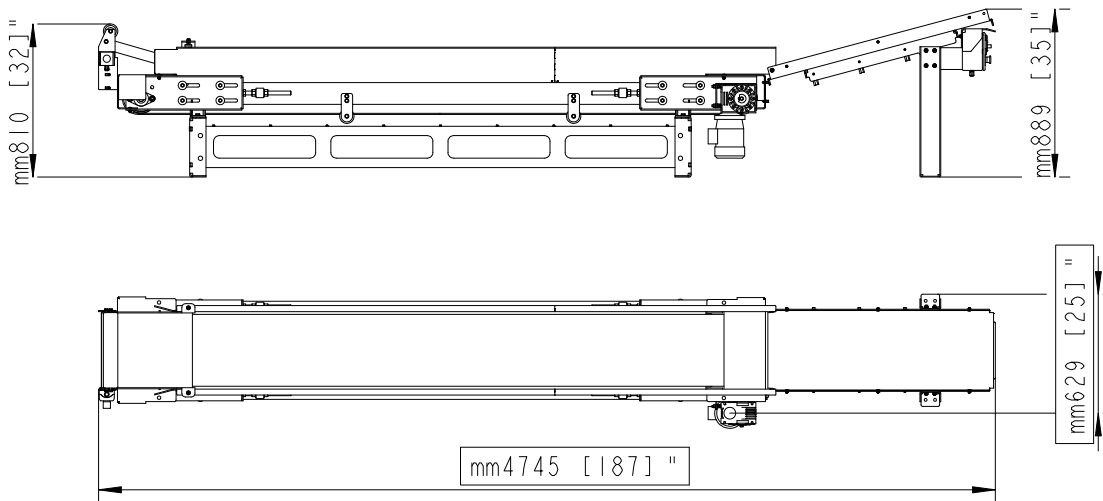
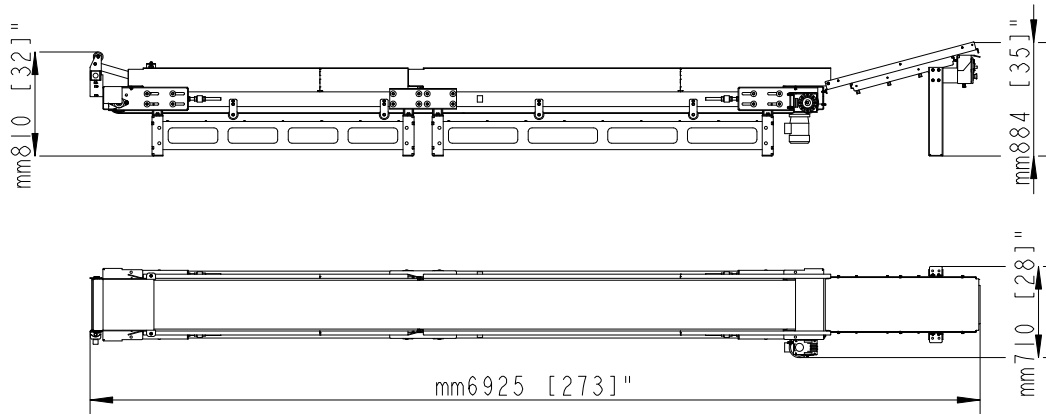


FIG. 6-4 HR500/700 -1, -2 RETURN TABLE

See **Figure 6-5**. See the figure below for the major dimensions of the HR500/700 -3, -4 RETURN TABLE.

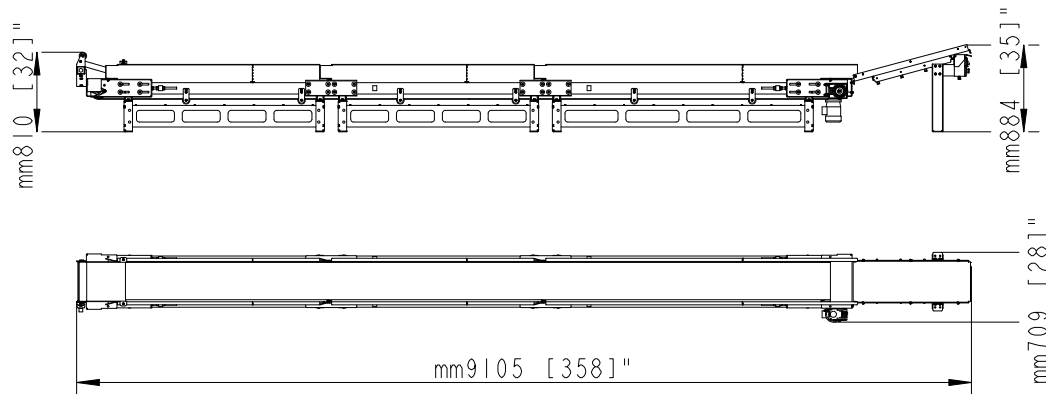
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525285\_MANUAL



**FIG. 6-5** HR500/700 -3, -4 RETURN TABLE

See **Figure 6-6**. See the figure below for the major dimensions of the HR500/700 -5, -6 RETURN TABLE.

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525286\_MANUAL



**FIG. 6-6** HR500/700 -5, 6 RETURN TABLE



See Figure 6-7. The figure below shows locations of the resaw legs.

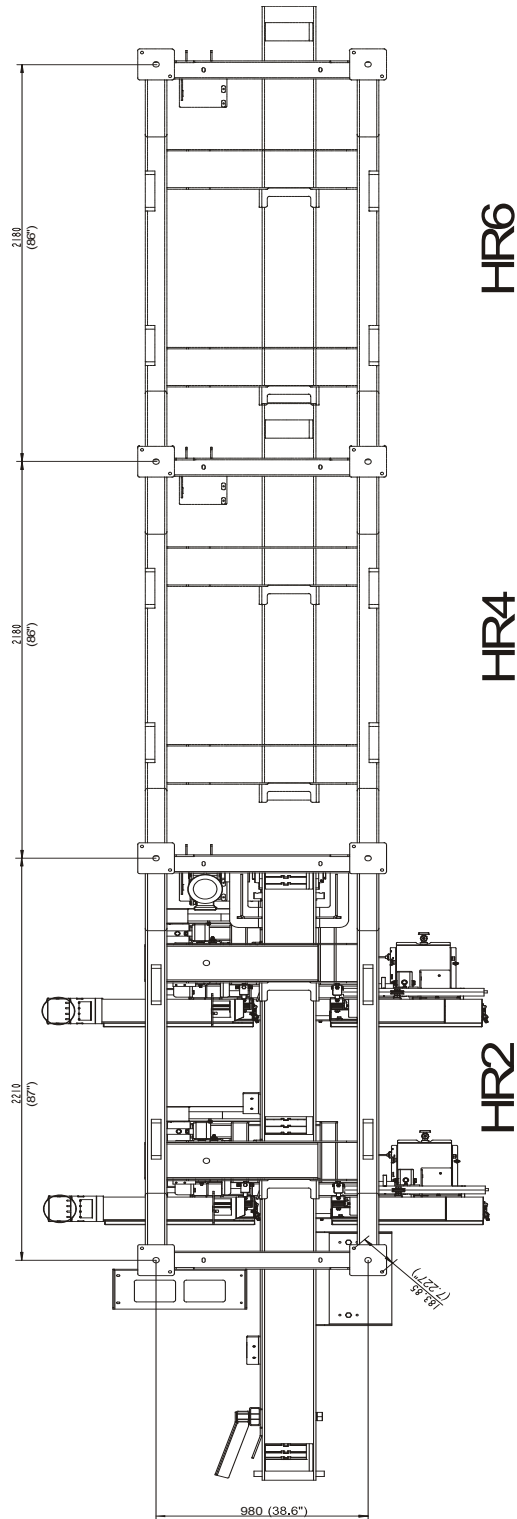


FIG. 6-7

## 6.2 Cutting Capacity

See Table 6-2. The material size and performance capacities of the resaw are given below.

<b>Cutting Length</b>	0.9 - 3.6 m (3-11.8 ft)
<b>Material Height</b>	10-400 mm (0.4 - 16")
<b>Material Height (with optional rollers)</b>	0-150 mm (0-11.8")
<b>Material Width</b>	75-280 mm (3-11")
<b>Feed Speed</b>	0-25m (0- 82ft)/min
<b>Minimum Cutting Height</b>	4 mm (0.16")
<b>Maximum Cutting Height (manual up/down system)</b>	200 mm (7.9")
<b>Maximum Cutting Height (auto- matic up/down system)</b>	180 mm (7.1")
<b>Distance Between Saw Blades</b>	1090 mm (42 29/32")

**TABLE 6-2**

See Table 6-3. Wood-Mizer TRU•SHARP™ offers three types of blades to provide efficient sawing. The type of wood you saw should determine which blade you choose for optimum performance.

Motor Size	Recommended Blade Type <sup>1</sup>		
	Softwood	Medium Hardwood	Frozen Timber or Dense Hardwood
<b>5 HP - 15 HP</b>	.042 x 7/8 x 1 1/4"	.042 x 7/8 x 1 1/4"	.045 x 7/8 x 1 1/4" F1

<sup>1</sup> HR500 resaw is working with a blade with a length of 4.01 m.

### 6.3 Return Table Motor Specifications

See Table 6-4. See the table below for blade motor specifications for your return table model.

Motor Type	Manufacturer	WM#	Model	Power	Other Specifications
Electric	BESEL	099070	MR-80/42/1,1-1 400/V6	1.1kW	400V/60Hz; 2.5 Amp; 1400 r.p.m.

**TABLE 6-4**

### 6.4 Blade Motor Specifications

See Table 6-5. See the table below for blade motor specifications for your resaw model.

Motor Type	Manufacturer	Model	Power	Other Specifications
E15 Electric	Siemens	1LE1003-1CB69 -0AA4-Z	11kW	460V/60Hz; 23 Amp; 1450 r.p.m.

**TABLE 6-5**

### 6.5 Noise Level

See Table 6-6. The noise levels of the resaw are listed below<sup>12</sup>.

	Noise level
<b>HR2E11/15S</b>	L <sub>EX8</sub> = 94,0 dB (A) (cant loading) L <sub>EX8</sub> = 94,0 dB (A) (cant receiving)
<b>HR3E11/15S</b>	L <sub>EX8</sub> = 96,7 dB (A) (cant loading) L <sub>EX8</sub> = 86,2 dB (A) (cant receiving)
<b>HR4E11/15S</b>	L <sub>EX8</sub> = 96,7 dB (A) (cant loading) L <sub>EX8</sub> = 92,9 dB (A) (cant receiving)

**TABLE 6-6**

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard. The noise exposure level given above concerns an 8-hour work day.
2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission levels and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. The factors affecting a current level of noise exposure during work are inter alia room characteristics and characteristics of other noise sources, e.g. number of machines and machining operations nearby. Also, the permissible exposure level value may vary depending on country. This information enables the machine's user to better identify hazards and a risk.

## 6.6 V-Belt Sizes

See Table 6-7. Belt sizes for the resaw are shown.

Belt Description	Belt Size	Wood-Mizer Part No.
Drive Belt (E15)	2XPB	557191
Blade Wheel Belt	B72.5	017922

TABLE 6-7

## 6.7 Dust Extractor Specifications

See Table 6-8. Specifications of the dust extractors used on the resaw for each saw head are listed below<sup>1</sup>.

Airflow	1200 m <sup>3</sup> /h 3937ft <sup>3</sup> /h
Inlet diameter	150 mm (5.9")
Motor power	1,5 kW
Number of sacks	1 pcs
Sack capacity	0,25 m <sup>3</sup> (8.8 ft) <sup>3</sup>
Weight	110 kg (242.5 lb)
Recommended conveying air velocity in the duct	20 m/s 65.6 ft/s

TABLE 6-8

The pressure drop between the inlet of the capture device and the connection to the CADES should be maximum 1,5 kPa (for the nominal air flow rate). If the pressure drop exceeds 1.5 kPa, the machine might not be compatible with conventional CADES.



**IMPORTANT!** The dust extractor hoses must be grounded or made with materials not accumulating electrostatic charge.



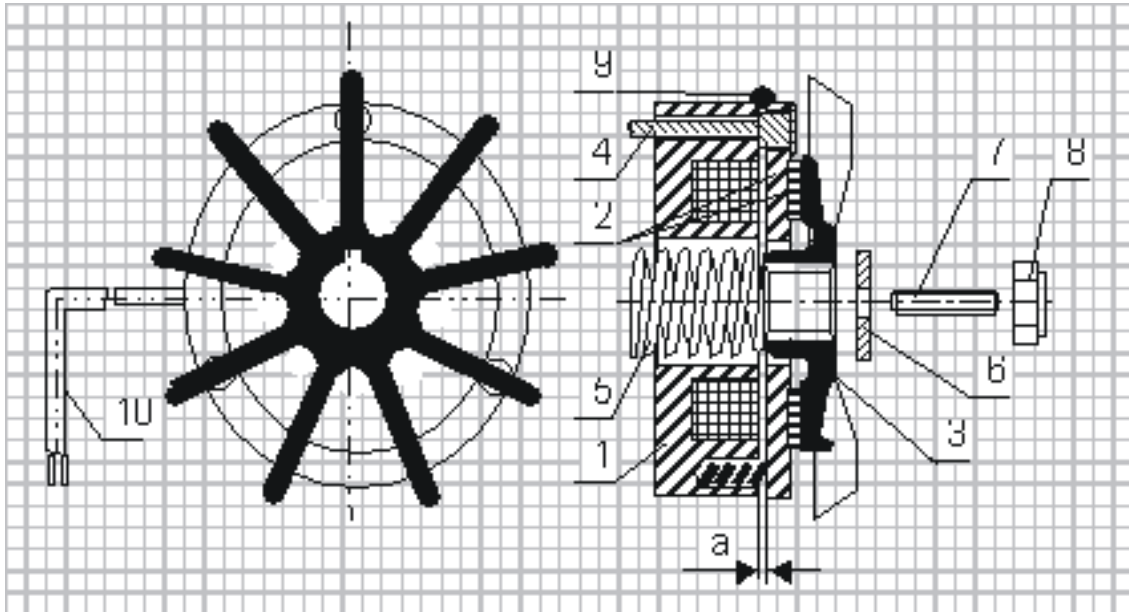
**CAUTION!** Always turn on the dust extractor before starting the machine.



**IMPORTANT!** The total value of hand-arm vibration the operator may be exposed to does not exceed 2.5 m/s<sup>2</sup>. The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0.5 m/s<sup>2</sup>.

1. External chip and dust extraction equipment with fixed installations are dealt with in EN 12779:2016-04.

## SECTION 7 DC ELECTROMAGNETIC BRAKE (CE ONLY), SIEMENS MOTORS



- 1 - Electromagnet,
- 2 - Armature complete with brake linings,
- 3 - Fan,
- 4 - Retaining bolt
- 5 - Central spring,
- 6 - Special washer,
- 7 - Set screw,
- 8 - Self-locking nut,
- 9 - Sealing ring,
- 10 - Output cable.

### 7.1 Design and principle of operation

The DC electromagnetic brake type H consists of 3 main subassemblies:

- electromagnet (1),
- armature complete (2)
- cast iron fan (3).

**Electromagnet (1) energised:** The DC voltage from the motor applied via the rectifying circuit causes the attraction of the armature (2) releasing the brake and thus the fan (3) is free to rotate.

**Electromagnet (1) de-energised:** The electromagnet stops to attract the armature (2) and spring

presses the armature with brake linings (2) against the fan and the brake is thus applied.

## 7.2 Service

During normal operation and at the routine inspections verify the air gap and check if all screws are tight. In case when any symptoms of inefficient braking are observed, then use the self-locking nut (8) to re-adjust the air gap to the value corresponding to Table 1.

Such readjustment may be repeated until the brake linings are completely worn out. When this will occur, a complete armature with brake linings (2) must be replaced.

If the air gap of the brake is correctly adjusted and despite of it the brake does not operate properly (the brake fails to release), it may be caused by:

- the electromagnet (1): burned coil or defected output cable (10),
- rectifying circuit (installed in the electric motor terminal box).

The above mentioned subassemblies should be checked and defected part replaced.

**Table 1:**

TYPE	H-63	H-71	H-80	H-90	H-100	H-112	H-132	H-160
Nominal Gap „a”	0.2 ±0,05	<b>0.2</b> ±0,05	<b>0.2</b> ±0,05	<b>0.2</b> ±0,05	<b>0.2</b> ±0,1	<b>0.2</b> ±0,1	<b>0.2</b> ±0,1	<b>0.2</b> ±0,1

## EC declaration of conformity according to EC Machinery Directive 2006/42/EC

**Manufacturer:** Wood-Mizer Industries sp. z o.o.  
Nagórna 114, 62-600 Koło; Poland  
Tel. +48 63 26 26 000

This declaration of conformity is issued under the sole responsibility of the manufacturer.

Following machine in our delivered version complies with the appropriate essential safety and health requirements of the EC Machinery Directive 2006/42/EC based on its design and type, as brought into circulation by us. In case of alteration of the machine, not agreed by us, this declaration is no longer valid.

### We, the undersigned herewith declare, that:

Designation of the machine: **Horizontal Resaw**  
TYPE: HR500 series  
Models: HR500EH11S-1/6; HR500EH15S-1/6  
No. of manufacturer: .....

### Is in conformity with the following EC directives:

EC Machinery Directive 2006/42/EC  
EC Electromagnetic Compatibility Directive  
2014/30/EU

### And is in conformity with the following Harmonized Standards:

PN-EN 1807-2:2013-08  
PN-EN 60204-1:2010  
PN-EN ISO 13849-1:2016-02

Notified Body according to annex IV : INSTYTUT TECHNOLOGII DREWNA  
Centrum Certyfikacji Wyrobów Przemysłu Drzewnego  
ul. Winiarska 1, 60-654 Poznań

Notification No: 1583

EC type-examination certificate no.: 0612/2018

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Place/Date/Authorized Signature:

Koło, 06.04.2018



Title :

Engineering Manager