



## 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

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. B1.00
(HR1-6E11S)	rev. B1.00
HR500E15S	rev. B1.00
(HR1-6E15S)	rev.B1.00

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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.

*September 2007*

*Form #1006*

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

*General Contact Information  
Branches & Authorized Sales Centers*

<b>SECTION 1</b>	<b>SAFETY</b>	<b>1-1</b>
1.1	Safety Symbols.....	1-1
1.2	Safety Instructions.....	1-2
	<i>Observe Safety Instructions</i>	
	<i>Wear Safety Clothing</i>	
	<i>Keep saw And Area Around saw Clean</i>	
	<i>Dispose Of Sawing By-Products Properly</i>	
	<i>Check saw Before Operation</i>	
	<i>Keep Persons Away</i>	
	<i>Keep Hands Away</i>	
	<i>Use Proper Maintenance Procedures</i>	
	<i>Keep Safety Labels In Good Condition</i>	
<b>SECTION 2</b>	<b>OPERATION</b>	<b>2-1</b>
2.1	Control Overview .....	2-1
2.2	Resaw Setup .....	2-3
	<i>Electrical Requirements (US Version Only)</i>	
2.3	Replacing The Blade .....	2-13
2.4	Tensioning The Blade.....	2-15
2.5	Tracking The Blade .....	2-16
2.6	Saw Head Height Adjustment .....	2-17
2.7	Tilt .....	2-20
2.8	Guide Fence Adjustment .....	2-21
2.9	Blade Guide Arm Adjustment.....	2-22
2.10	Machine Start.....	2-23
2.11	Water Lube Operation .....	2-27
	<i>Standard Lube System (Supplied from a Water Supply Network)</i>	
	<i>Optional Lube System (Supplied from Water Tanks)</i>	
2.12	Operation Procedure.....	2-30
<b>SECTION 3</b>	<b>MAINTENANCE</b>	<b>3-1</b>
3.1	Wear Life.....	3-1
3.2	Blade Guides .....	3-2
3.3	Sawdust Removal .....	3-2
3.4	Vertical Mast .....	3-2
3.5	Miscellaneous Lubrication .....	3-3
3.6	Belts .....	3-3
3.7	Drive Belt Adjustment.....	3-4
3.8	Feed Track Chain Tension.....	3-7



## Table of Contents

## Section-Page

3.9	Up/Down System.....	3-8
3.10	Safety Devices Inspection .....	3-9
<b>SECTION 4 ALIGNMENT</b>		<b>4-1</b>
4.1	Alignment Procedures .....	4-1
4.2	Blade Installation And Tracking .....	4-2
4.3	Blade Wheel Alignment .....	4-4
4.4	Saw Head Adjustment .....	4-9
4.5	Blade Guide Arm Vertical Adjustment .....	4-10
4.6	Blade Guide Arm Horizontal Adjustment.....	4-11
4.7	Aligning the Blade Guides .....	4-13
4.8	Blade Deflection.....	4-14
4.9	Blade Guide Vertical Tilt Adjustment.....	4-15
4.10	Blade Guide Spacing .....	4-17
4.11	Blade Guide Horizontal Tilt Adjustment .....	4-18
4.12	Blade Height Scale Adjustment.....	4-19
<b>SECTION 5 SPECIFICATIONS</b>		<b>5-1</b>
5.1	Overall Dimensions .....	5-1
5.2	Cutting Capacity .....	5-5
5.3	Blade Motor Specifications .....	5-6
5.4	Noise Level.....	5-6
5.5	V-Belt Sizes.....	5-7
5.6	Dust Extractor Specifications .....	5-7
<b>SECTION 6 ELECTRICAL INFORMATION</b>		<b>6-1</b>
6.1	Electrical Diagram, 507270 M1 (HR500_EH_EC_S-2/EH_EC-2) .....	6-2
6.2	Electrical Components, 507270-M1 .....	6-3
6.3	Electrical Diagram, 507270-M2 (HR500_EH_EC_S-4).....	6-4
5.7	Electrical Diagram, 507270-M2 (HR500_EH_EC-4).....	6-5
6.4	Electrical Components, 507270-M2.....	6-6
6.5	Electrical Diagram, 507270-M3 (HR500_EH_EC_S-6) .....	6-7
6.6	Electrical Diagram, 507270-M3 (HR500_EH_EC-6) .....	6-8
6.7	Electrical Components, 507270-M3 .....	6-9
6.8	Electrical Components, Power Supply Box (Part #507269) .....	6-10
6.9	Electrical Component List, HR 500 .....	6-11
6.10	Electrical Diagram, Control Box (Part No. 507170).....	6-12
6.11	Control Box Electrical Components .....	6-13
<b>SECTION 7 REPLACEMENT PARTS</b>		<b>7-1</b>
7.1	How To Use The Parts List .....	7-1
7.1	Sample Assembly .....	7-1

## Table of Contents

## Section-Page

7.2	Blade Guide Assembly, Idle Side.....	7-2
7.3	Blade Guide Assembly, Drive Side.....	7-3
7.4	Blade Guide Arm Assembly.....	7-5
7.5	Blade Wheel Assembly, Drive Side.....	7-6
7.6	Blade Wheel Assembly, Idle Side.....	7-7
7.7	Hydraulic Blade Tensioner Assembly.....	7-8
7.8	Middle Throat Screw.....	7-9
7.9	Water Bottle Assembly (Option).....	7-10
7.10	Blade Lube System.....	7-11
7.11	HR Saw Head Warning Decals.....	7-13
7.12	Blade Housing Cover.....	7-15
7.13	Saw Head Height Adjustment Screw.....	7-16
7.14	Mast Tilt Adjustment Screw.....	7-17
7.15	Vertical Mast Slide Pads.....	7-18
7.16	Motor Assembly.....	7-19
7.17	Feed Chain Drive & Tensioner.....	7-20
7.18	Hold-Down Roller Kit, HR500 1-6 - Standard.....	7-23
7.19	Hold-Down Rollers & Log Guide.....	7-24
7.20	101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6) - OPTIONAL.....	7-26
7.21	101.6 Front Hold-Down Roller - OPTIONAL.....	7-27
7.22	101.6 Rear Hold-Down Roller - OPTIONAL.....	7-28
7.23	101.6 Hold-Down Roller Kit - OPTIONAL.....	7-29
7.24	Adjustable Hold-Down Roller (Option).....	7-30
7.25	Main Module Base.....	7-31
7.26	Main Module Feed Track.....	7-33
7.27	Additional Module Base.....	7-34
7.28	Additional Module Feed Track.....	7-36
7.29	Idle Roller Table, SLPIRT.....	7-37
7.30	Cross Roller Table, SLPCRT.....	7-39
7.31	Hydraulic Blade Tensioner.....	7-41
7.32	Hydraulic Pump Assembly.....	7-43
7.33	Control Box.....	7-45
7.34	Up/Down Screw Drive Assembly (Option).....	7-47
<b>SECTION 8 DC ELECTROMAGNETIC BRAKE</b>		<b>8-1</b>
8.1	Design and Principle of Operation.....	8-1
8.2	Service.....	8-2

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### Office Hours:

Country	Monday - Friday	Saturday	Sunday
Poland	7 a.m.- 3 p.m.	Closed	Closed
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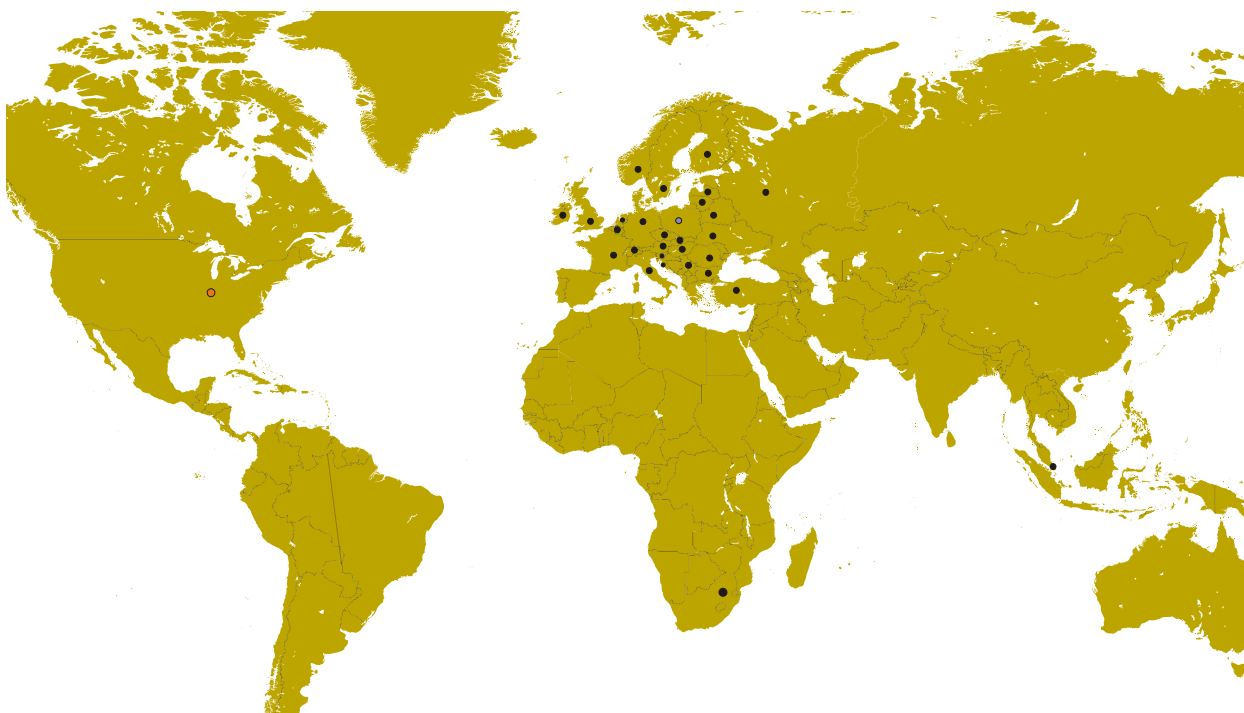
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## SECTION 1 SAFETY

### 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 saw is intended for sawing wood only. [See Section 5.2](#) for log size capacities of the machine.

**IMPORTANT!** The operator of the saw 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 saw. 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 saw. The saw 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 saw. All Wood-Mizer saw owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.



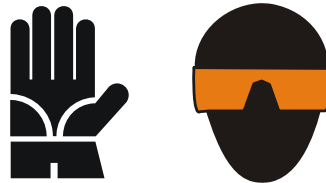


### ***Wear Safety Clothing***



**WARNING!** Secure all loose clothing and jewelry before operating the saw. 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 saw.



### ***Keep saw And Area Around saw Clean***



**DANGER!** Maintain a clean and clear path for all necessary movement around the saw 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.

# 1

## Safety

### *Check saw Before Operation*

---

#### **Check saw Before Operation**



**DANGER!** Make sure all guards and covers are in place and secured before operating the saw. 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 saw. 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 saw operation.



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

**WARNING!** Disconnect and lock out power supply before servicing the saw! 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 saw. 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 saw 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 saw operation, push the EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing cover.

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

**Keep Safety Labels In Good Condition**

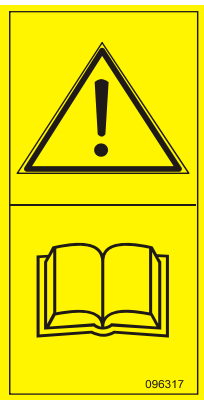


**IMPORTANT!** Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order more decals.

**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 saw.

**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 saw.

**1** Safety  
 Keep Safety Labels In Good Condition

**TABLE 1-1**

	<p>099220</p>	<p>CAUTION! Close all guards and covers before starting the machine.</p>
	<p>099219</p>	<p>Blade tension. Turning the bolt clockwise will increase the blade tension and turning the bolt counterclockwise will decrease the tension.</p>
	<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>

**TABLE 1-1**

	096321	Blade movement direction
	S12004G	CAUTION! Always wear safety goggles when operating the saw!
	S12005G	CAUTION! Always wear protective ear muffs when operating the saw!
	501465	CAUTION! Always wear safety boots when operating the saw
	501467	Lubrication Point

**1 Safety**  
*Keep Safety Labels In Good Condition*

**TABLE 1-1**

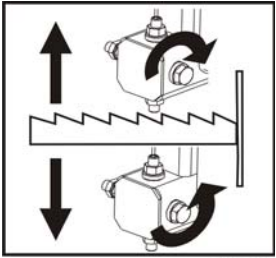



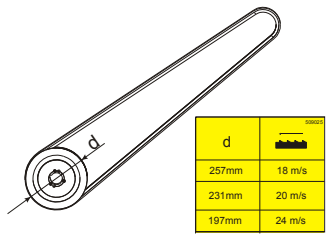




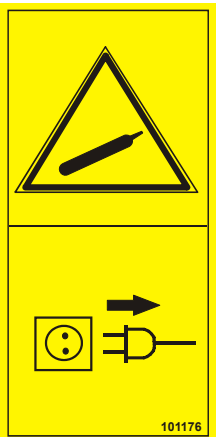
 <p>P11789b</p>	<p>P11789</p>	<p>Aligning the blade on the wheels</p>								
	<p>P85070</p>	<p>CE safety certification</p>								
	<p>099401</p>	<p>Russian safety certification</p>								
	<p>S20097</p>	<p>Motor rotation direction</p>								
 <table border="1" data-bbox="448 1704 576 1816"> <thead> <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									



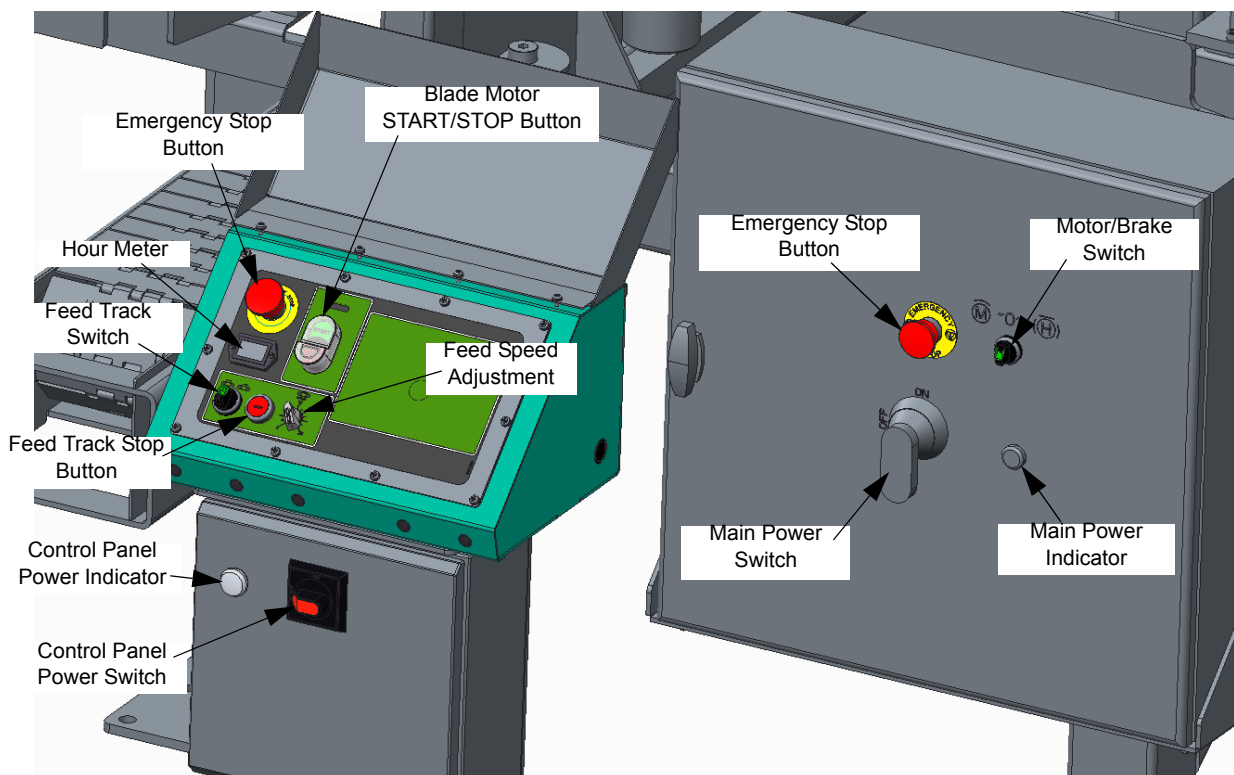
TABLE 1-1

	<p>505346</p>	<p>Tensioner Valve Handle Placement, TVS</p>																											
<table border="1"> <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>830-860</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	830-860	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	830-860	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>101176</p>	<p>CAUTION! Compressed air in the system even after electric power disconnection.</p>																											

## 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. To stop the blade motor, press the STOP switch.

##### 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.

### 6. Control Panel Power Switch



Turns on and off power to the control box.

### 7. Control Power Indicator

## 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.

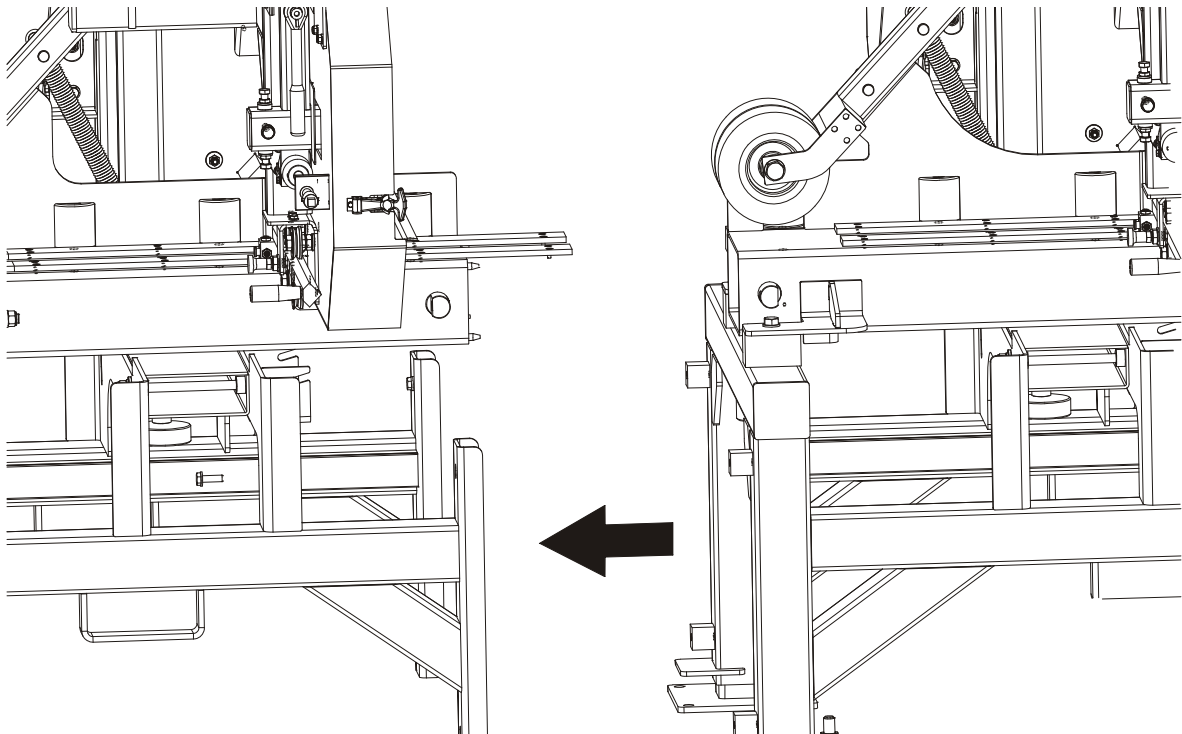
### 3. Main Power Switch

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.

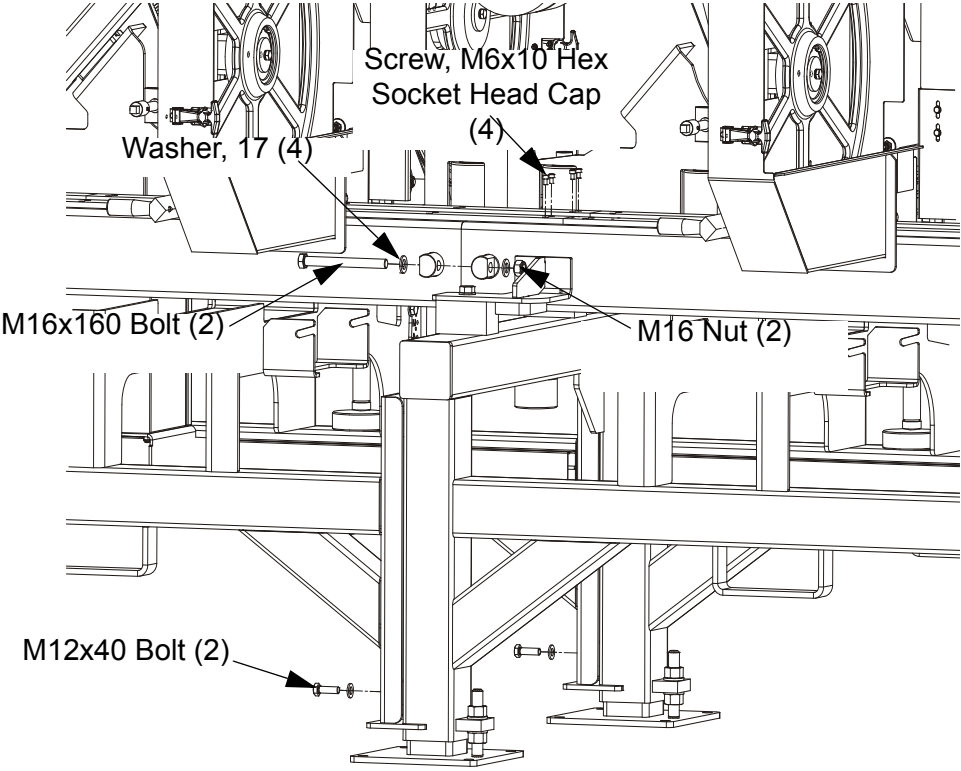


FIG. 2-3

## 2 Operation

Resaw Setup

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

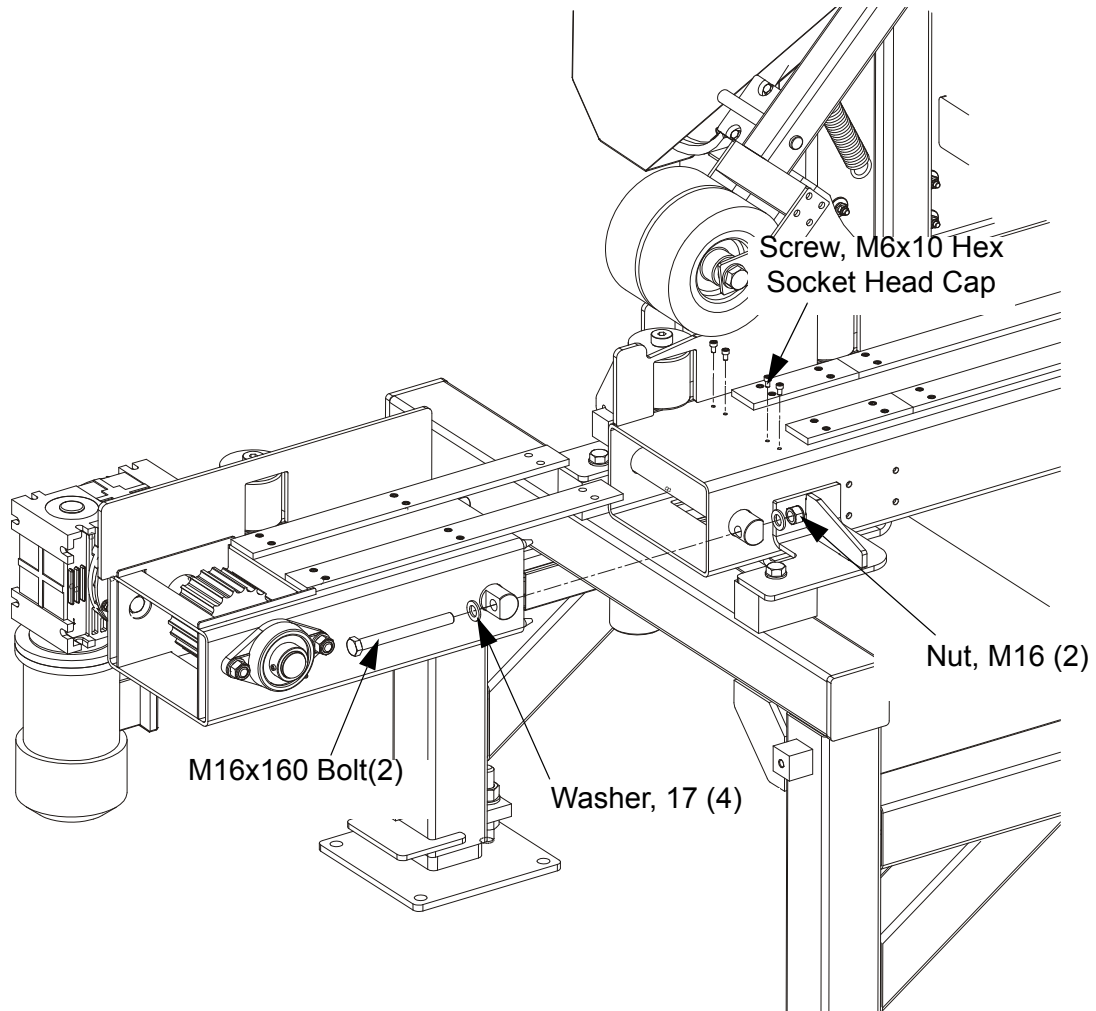


FIG. 2-4

See Figure 2-5. Mount the feed chain and apply proper tension. [See Section 3.8](#)

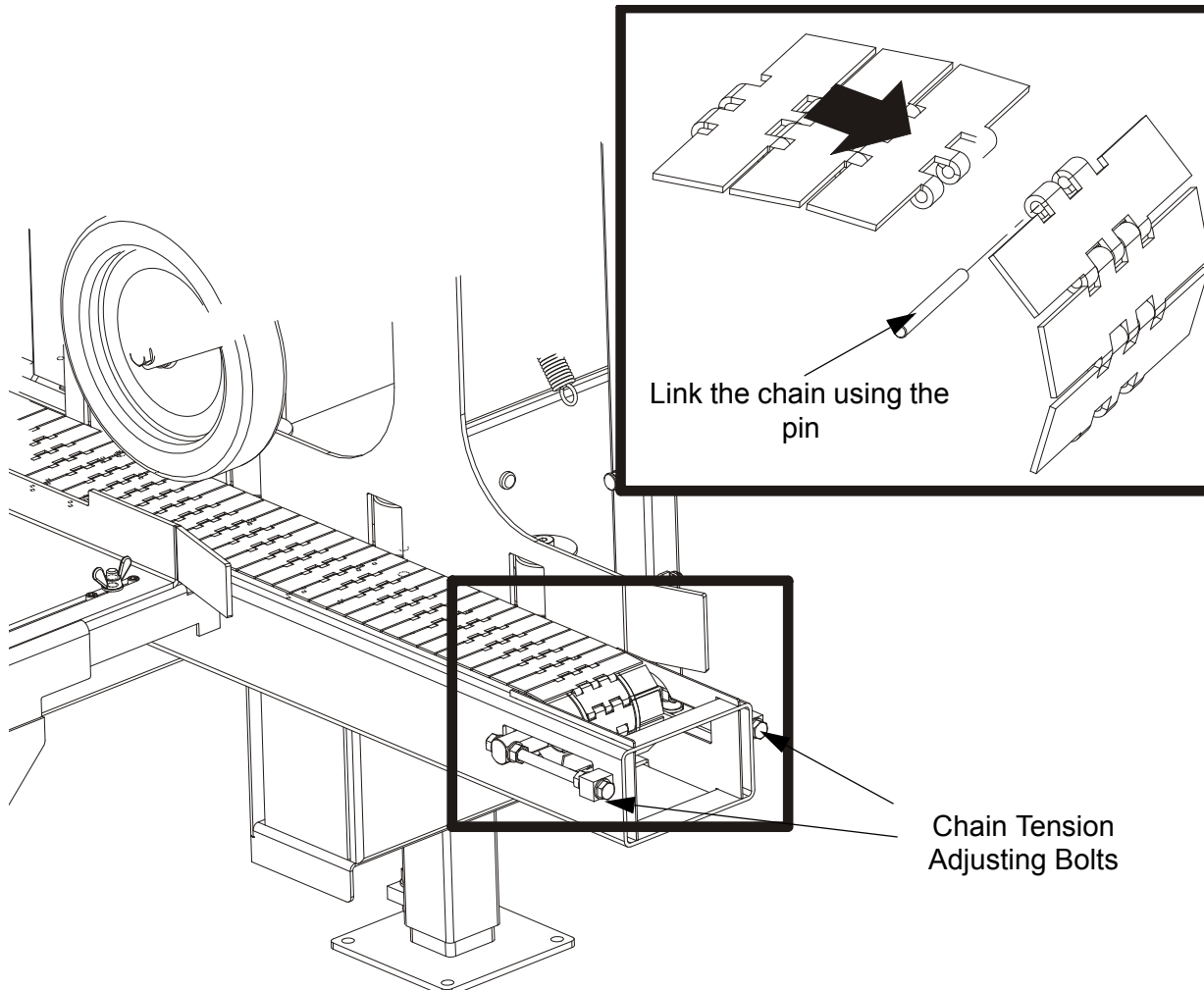


FIG. 2-5



**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.

## 2 Operation

### Electrical Requirements (US Version 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.

**See Table 2-1.** 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.

Number of saw heads	Total Power	Circuit Breaker [A]	Power Cord Cross Section [mm <sup>2</sup> ]
1	12,5kW at 230/400V 50Hz 14,4kW at 460V 60Hz	25	13 AWG/ 2,5
2	23,5kW at 230/400V 50Hz 27,1kW at 460V 60Hz	40	9 AWG/ 6
3	34,5kW at 230/400V 50Hz 39,6kW at 460V 60Hz	70	5 AWG/ 16
4	45,5kW at 230/400V 50Hz 52,3kW at 460V 60Hz	90	3 AWG/ 25
5	56,5kW at 230/400V 50Hz 65kW at 460V 60Hz	120	1 AWG/ 35
6	67,5kW at 230/400V 50Hz 77,6kW at 460V 60Hz	140	1 AWG/ 35


**TABLE 2-1**

### 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.

1. The light source can not cause stroboscopic effect.



 **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.

## 2 Operation

### Electrical Requirements (US Version Only)

- 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)

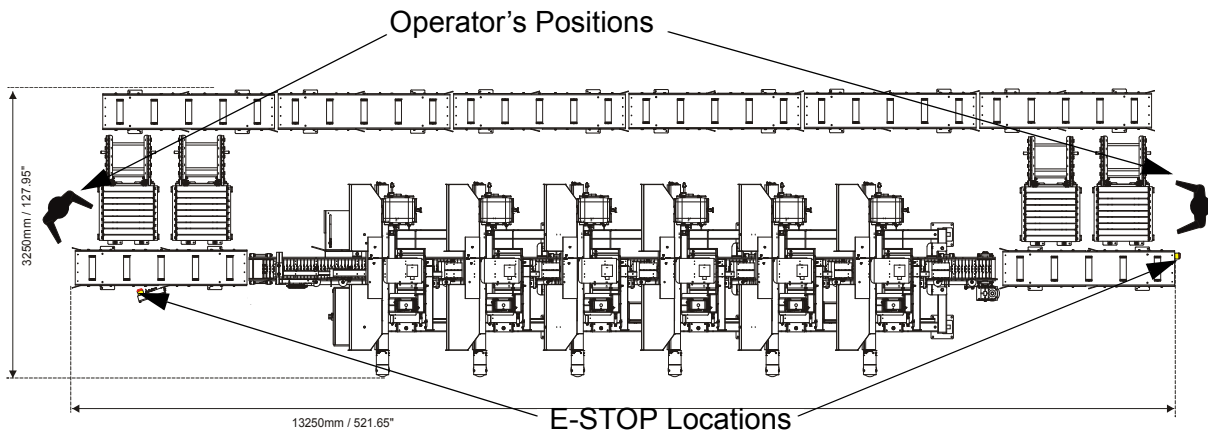


FIG. 2-6

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

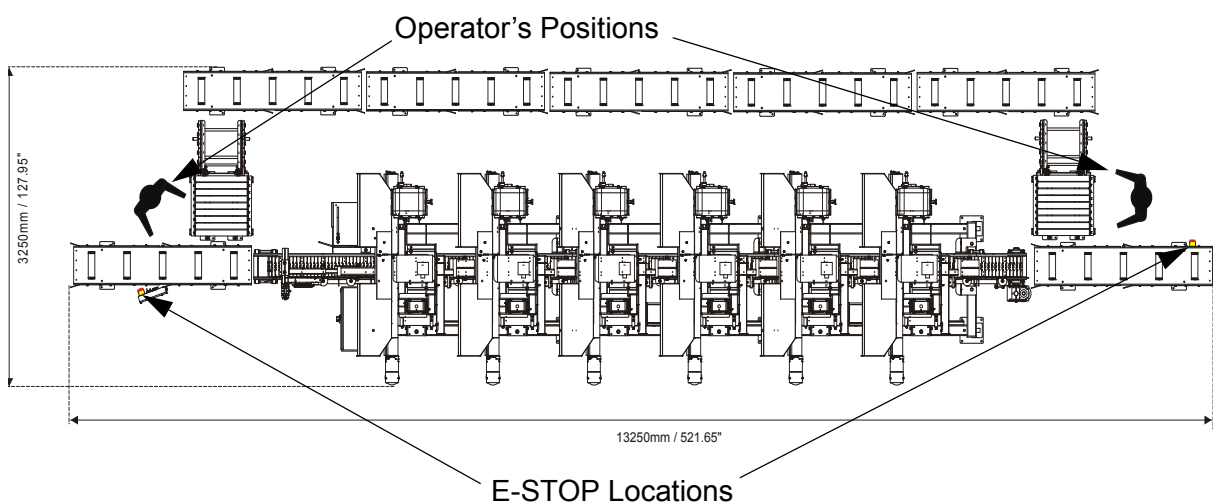
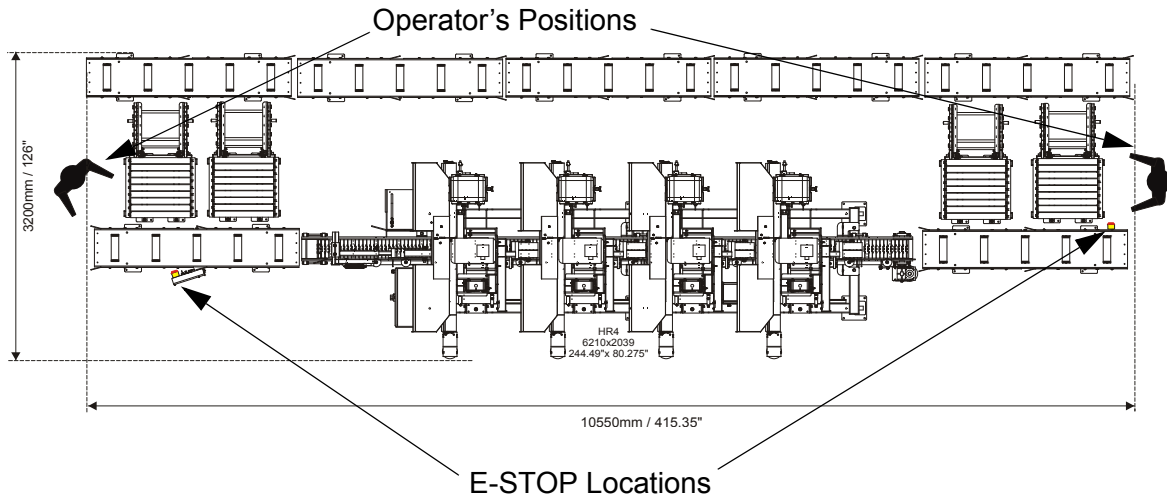


FIG. 2-7

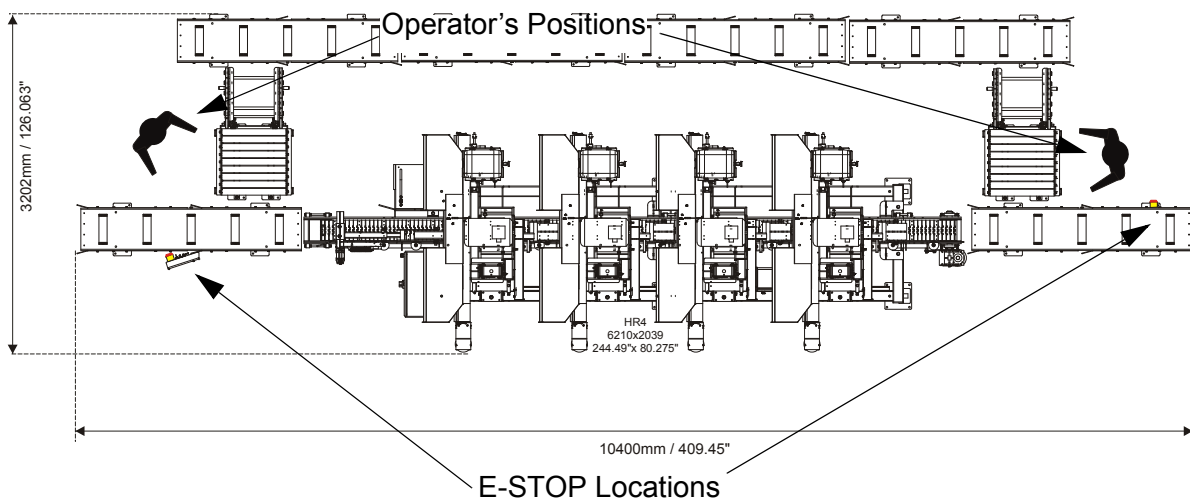
See Figure 2-8. Layout of the MRTHR4-M resaw (4-head HR for 1.5-3.6m (4.9- 11.8 ft)

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))

## 2 Operation

### Electrical Requirements (US Version Only)

logs)

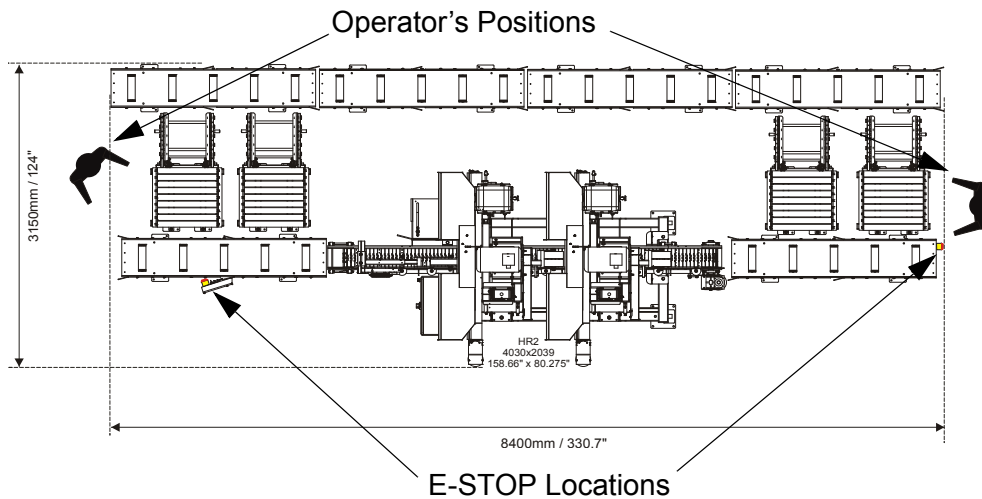


FIG. 2-10

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

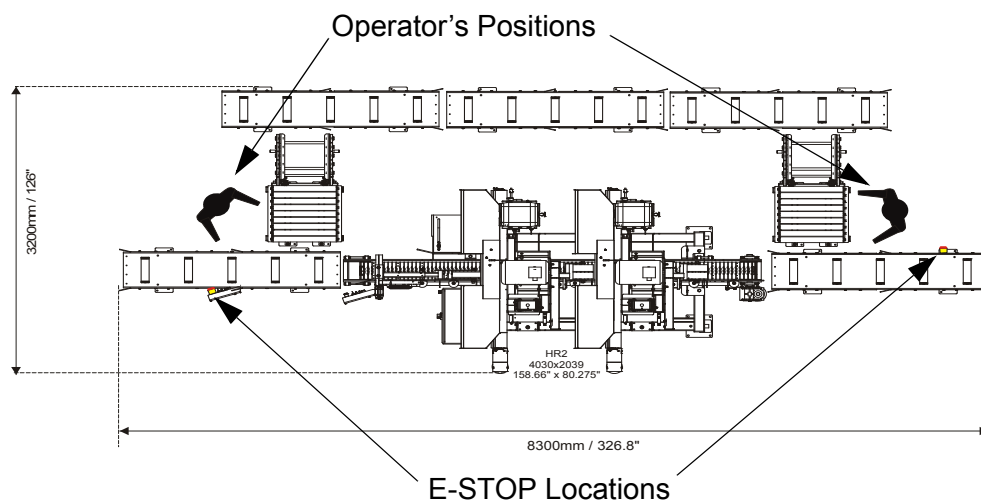
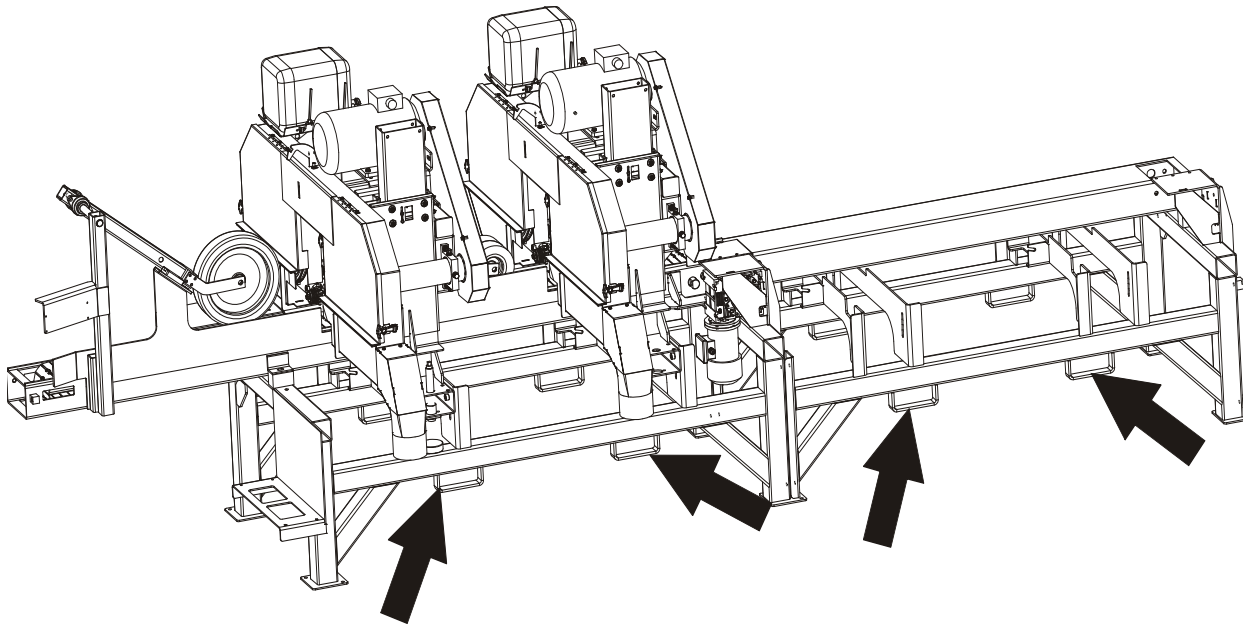


FIG. 2-11



**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.

- 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. 2-12**

## 2 Operation

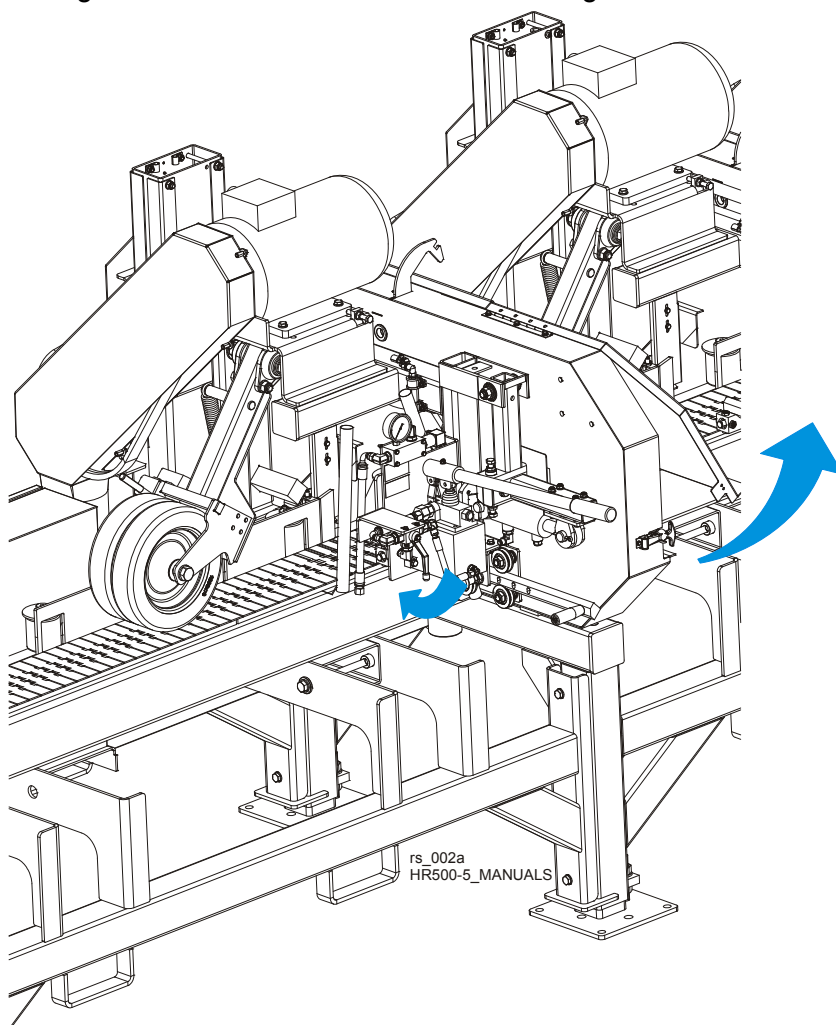
### Replacing The Blade

### 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 Tensioning The Blade

See Figure 2-13. 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.

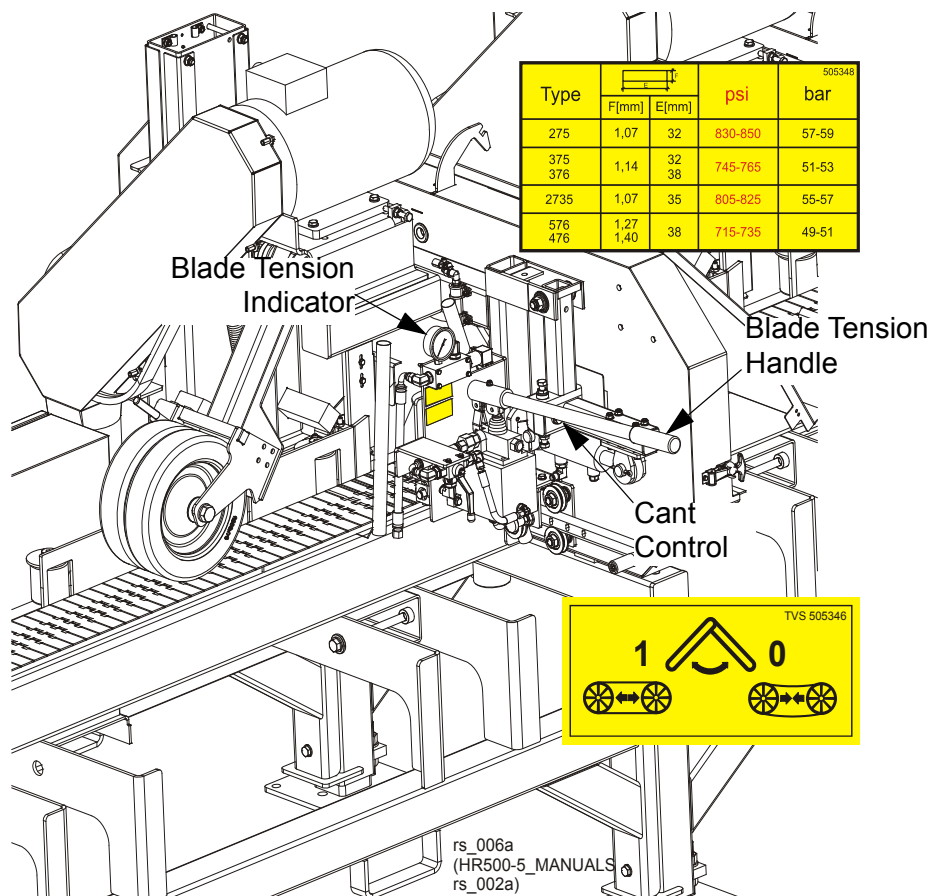


FIG. 2-13



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



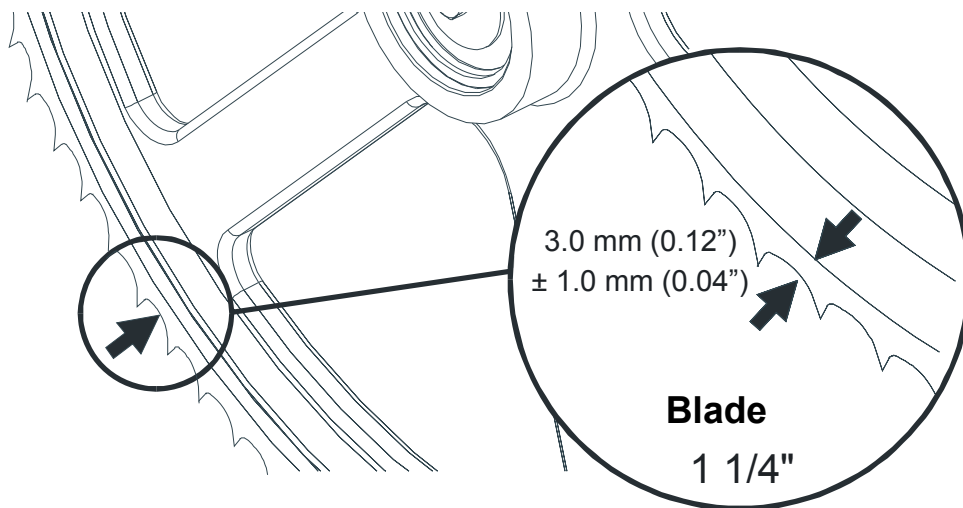
## 2.5 Tracking The Blade

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

(H)

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")  $\pm$  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 2-13**, 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.

## 2 Operation

### Saw Head Height Adjustment



**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.

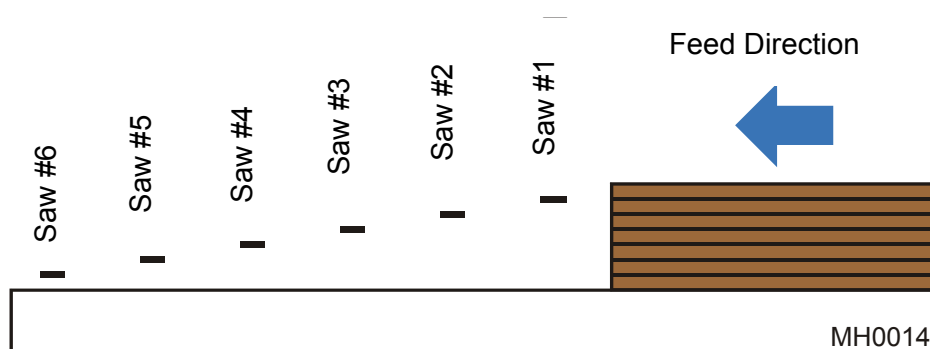
**NOTE:** After aligning the blade on the wheels, always check the blade guide spacing and location.

## 2.6 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.

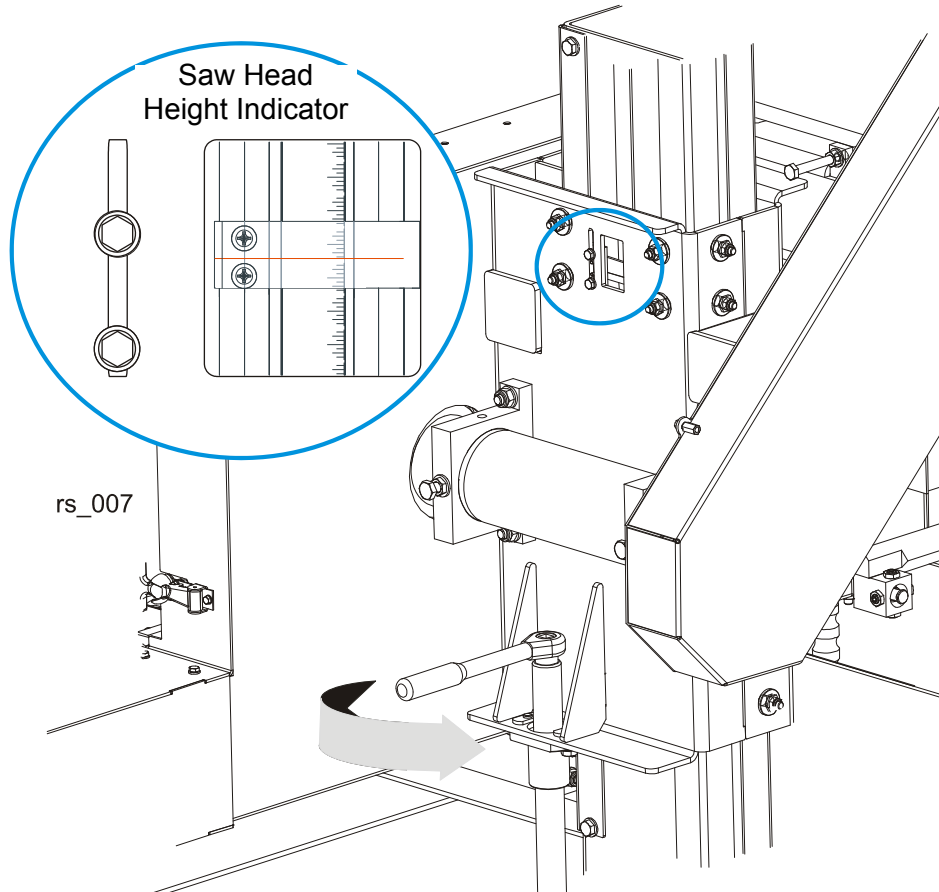


FIG. 2-16

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

## 2 Operation

### Saw Head Height Adjustment

See Figure 2-17.

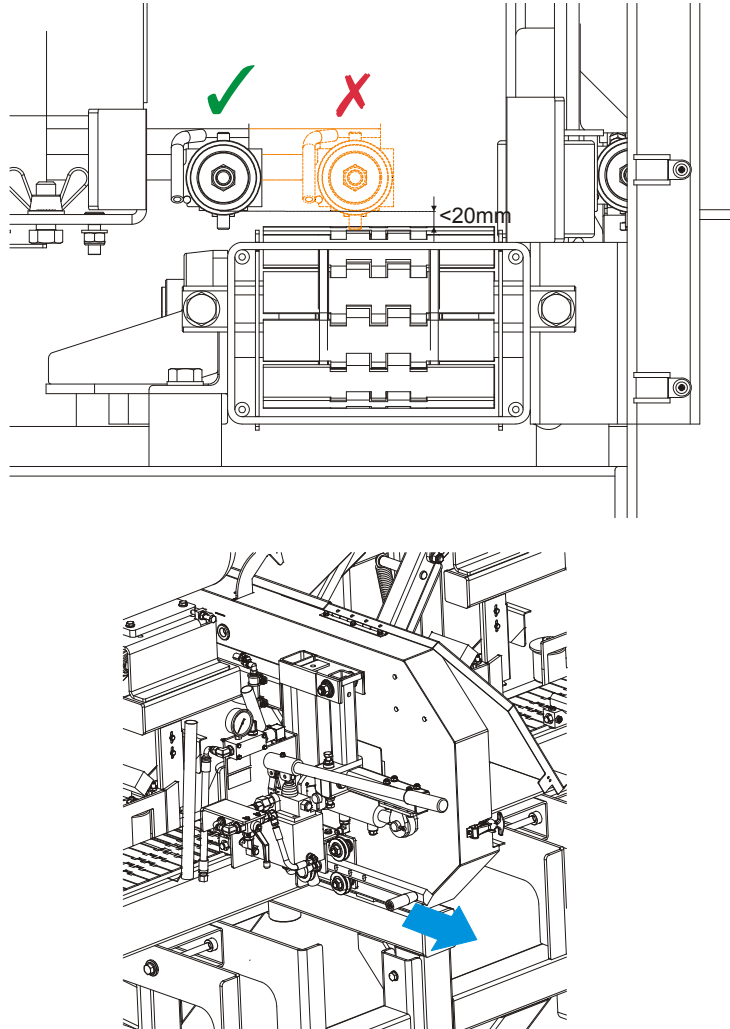


FIG. 2-17

## 2.7 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.

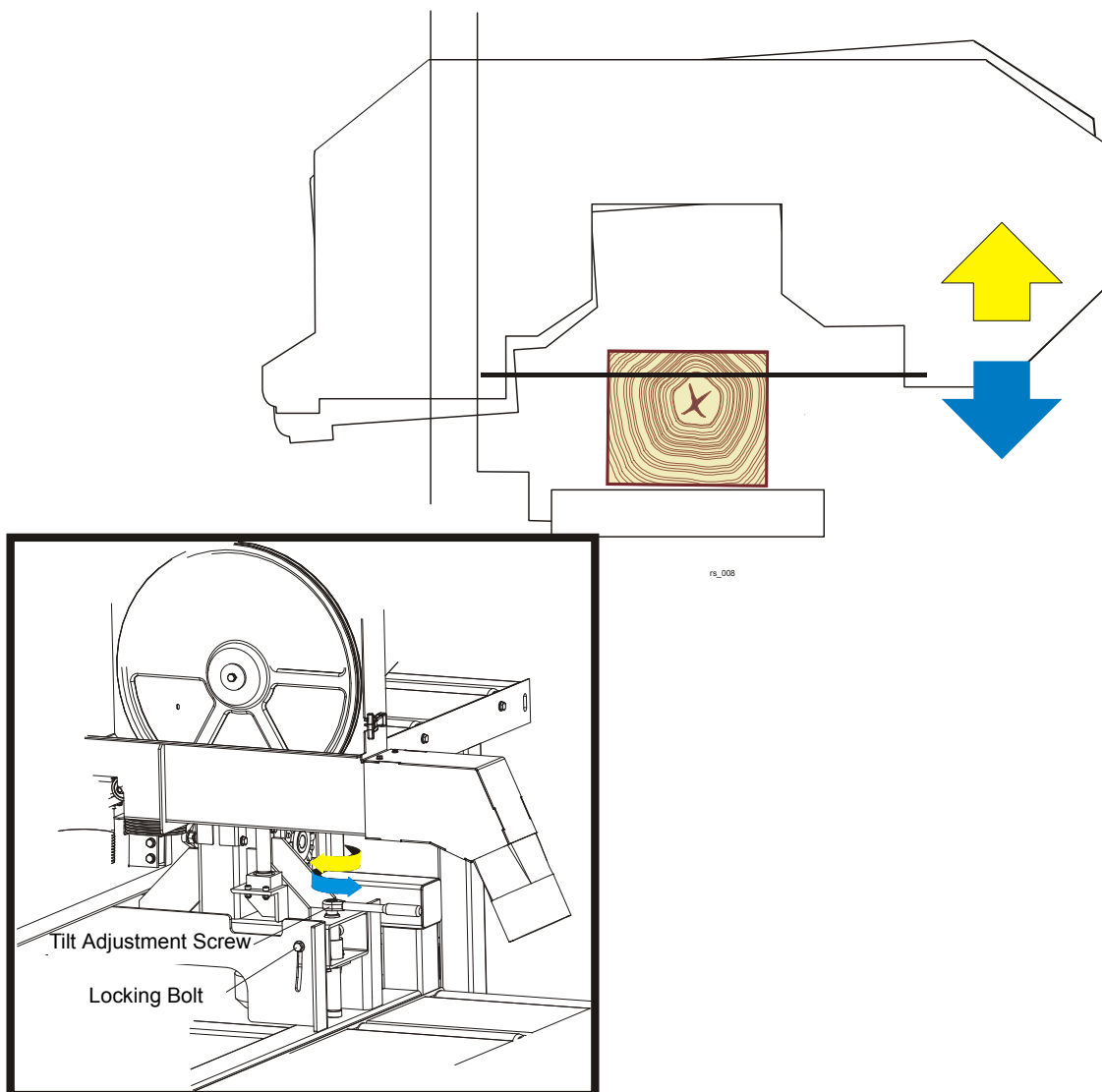


FIG. 2-18

**NOTE:** The saw head can be set at an angle of  $0^{\circ}$  to  $8^{\circ}$ .

## 2.8 Guide Fence Adjustment

Patrz rysunek 2-19. Loosen the wing nuts. Move the guide fence to the desired cant width.

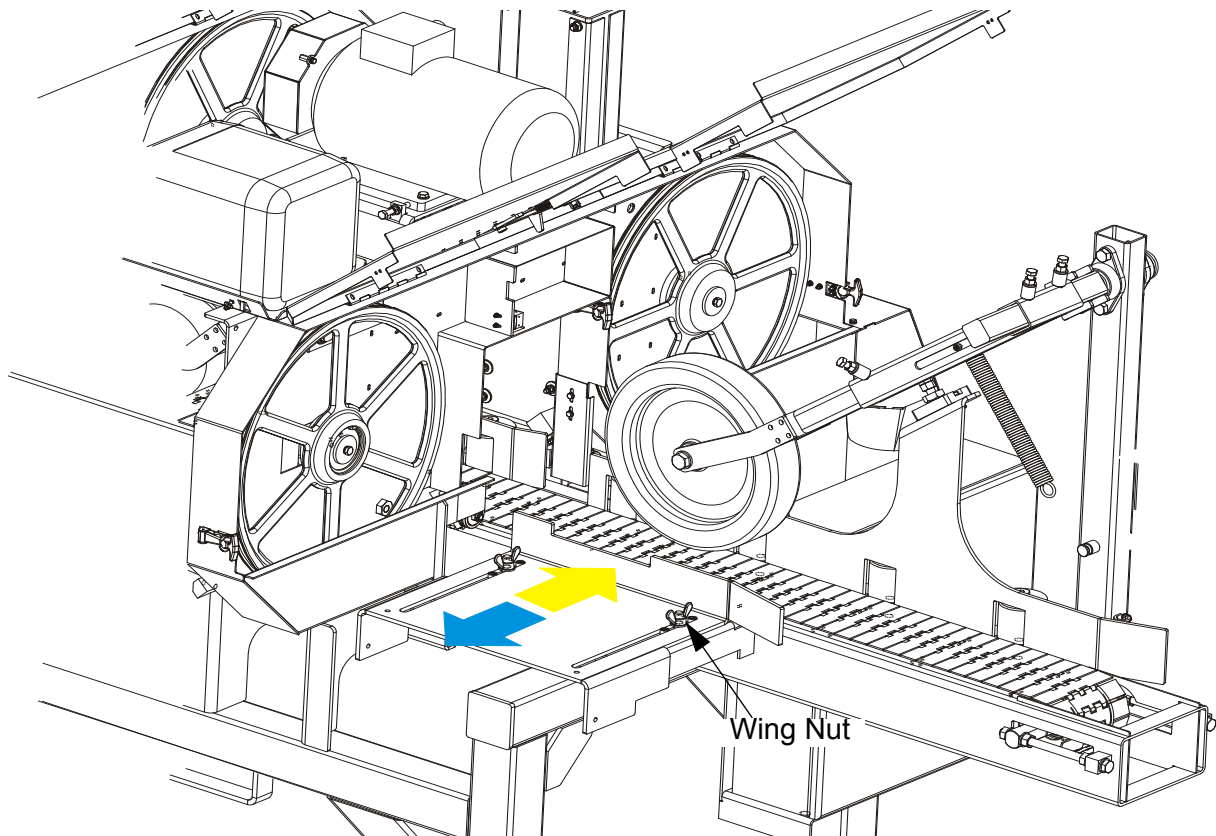


FIG. 2-19

## 2.9 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.

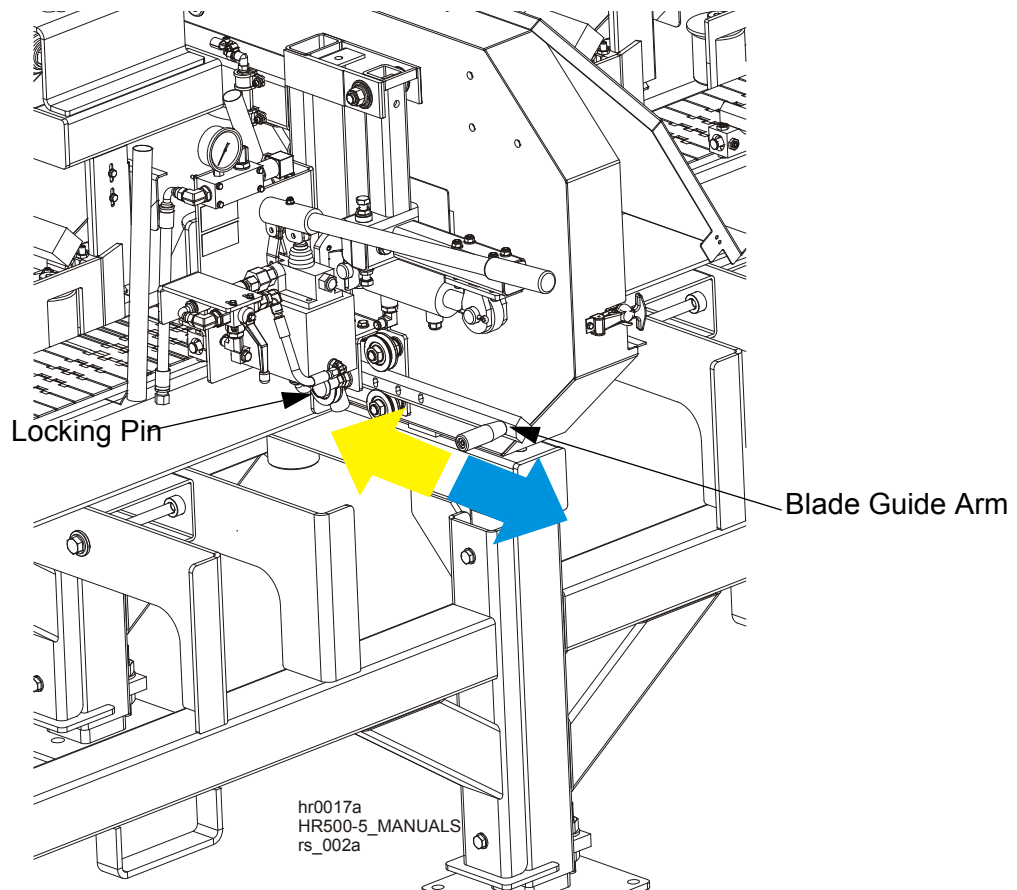



FIG. 2-20


### 2.10 Machine Start

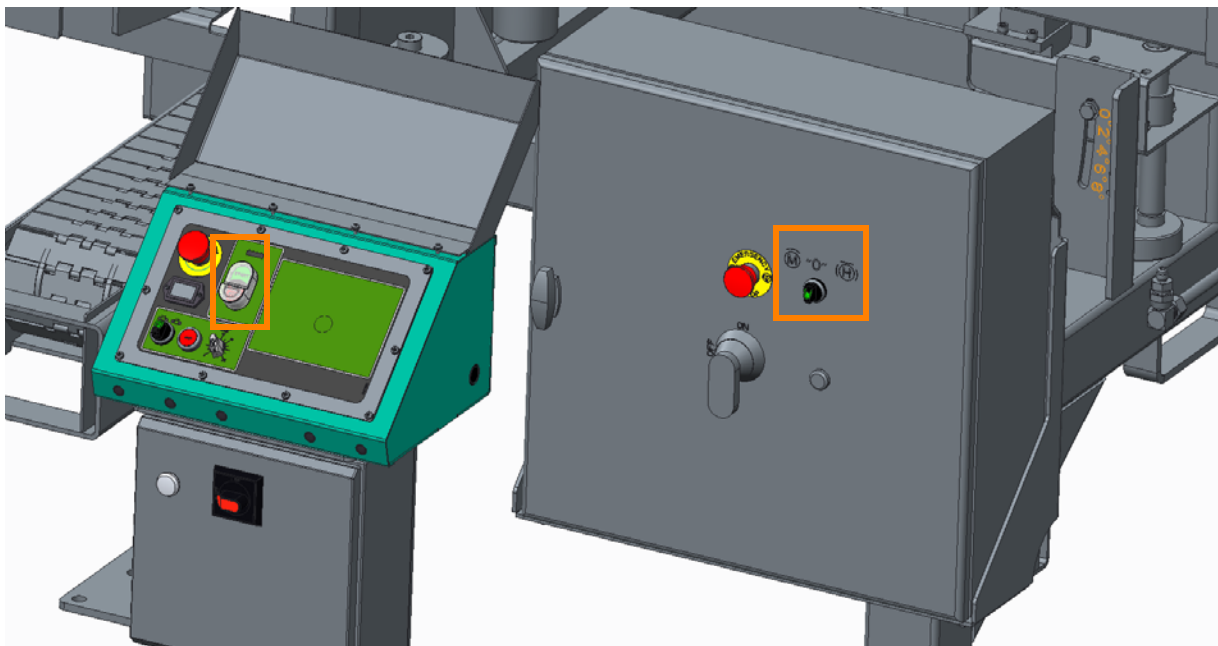
 **DANGER!** Before starting the resaw, perform these steps to avoid injury and/or damage to the equipment:

- 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 and then press the START button on the control panel (see the figure below). The motors should start and the blades should start spinning.



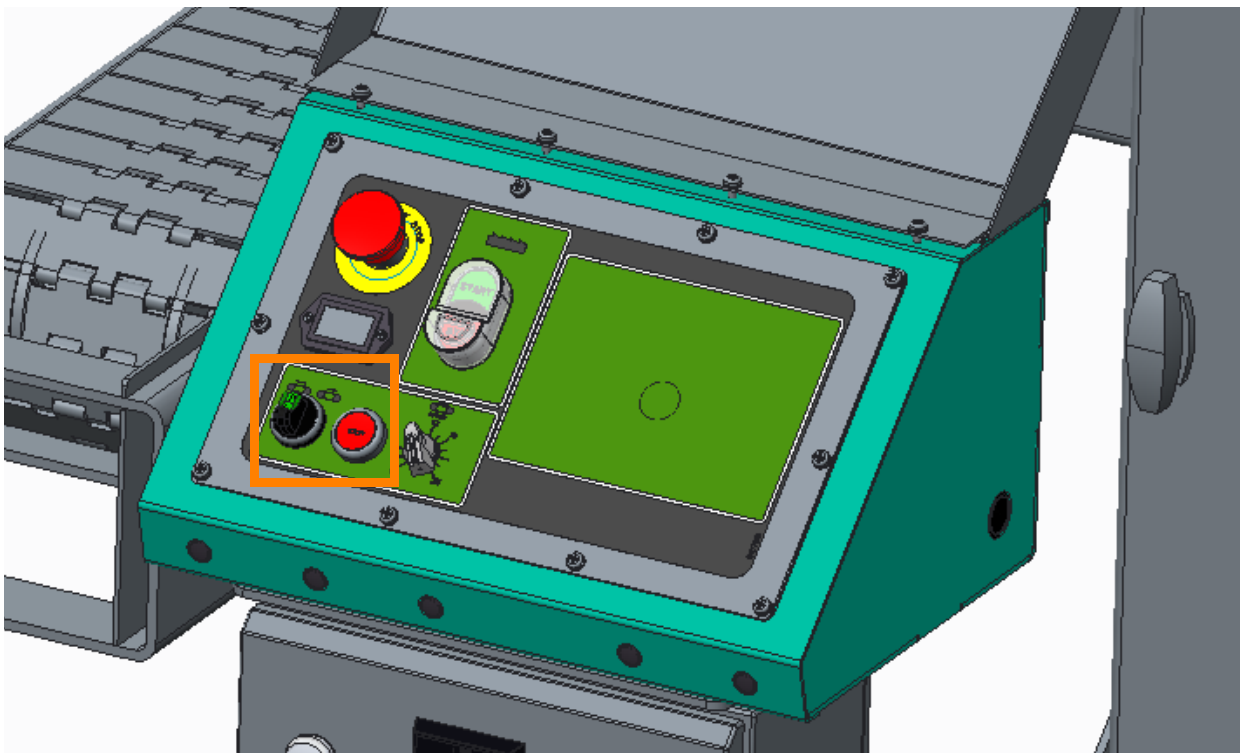
**FIG. 2-21**



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



**FIG. 2-22**

started. To start the track feed, turn left the Track switch shown in Figure 2-5.

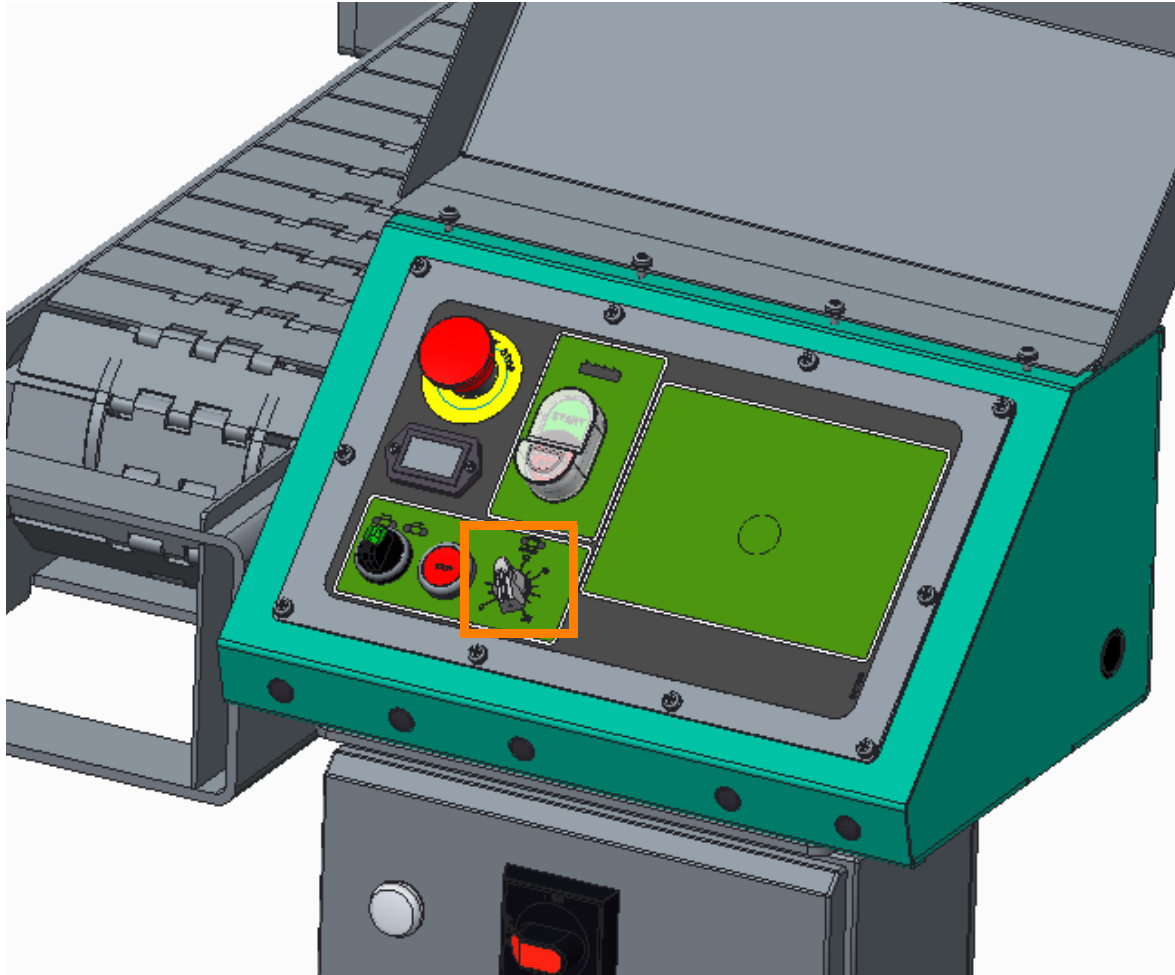
The feed track can be stopped either by pressing the STOP button or one of the emergency stop buttons. The emergency stop will also stop the blade motor.

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

## 2 Operation

### Machine Start

See Figure 2-23. The speed at which the feed track moves is adjustable. The feed track



**FIG. 2-23**

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.

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.

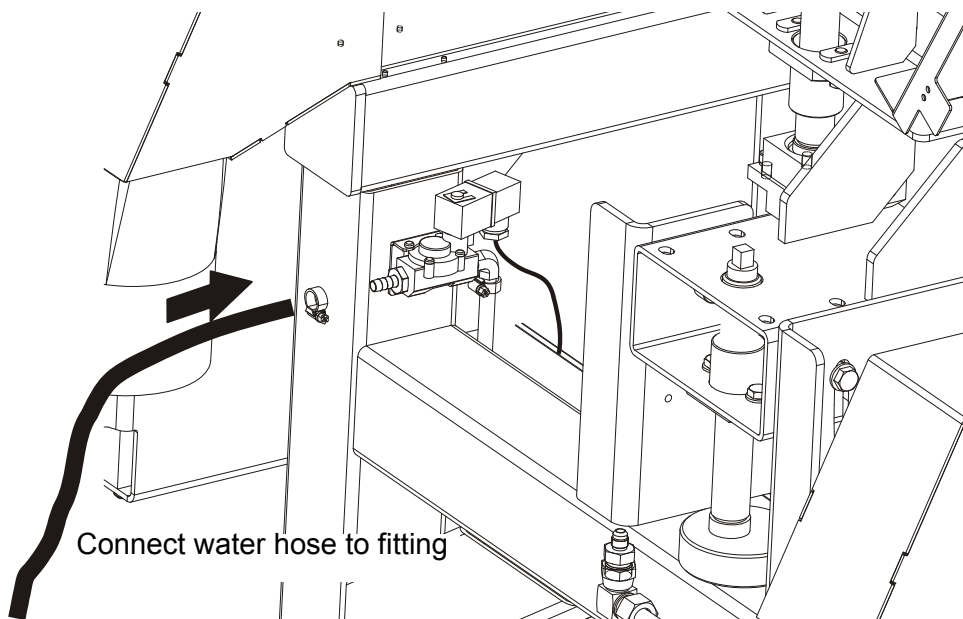
- Sharpness of blades. Dull or improperly sharpened blades will require slower feed rates than sharp and properly maintained blades.
- Off-bearing capability. Your ability to feed end-to-end will also determine what feed rate you can use.

## 2.11 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.

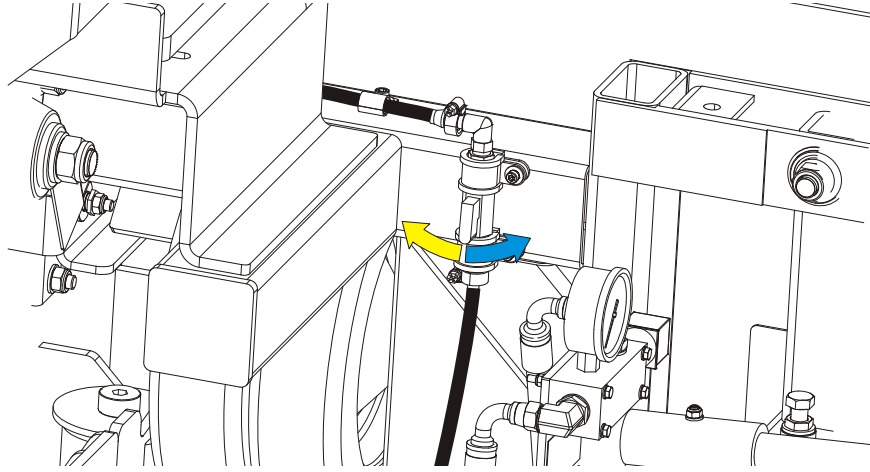
**See Figure 2-24.** Connect the water hose to the lube system fitting shown below.



**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**

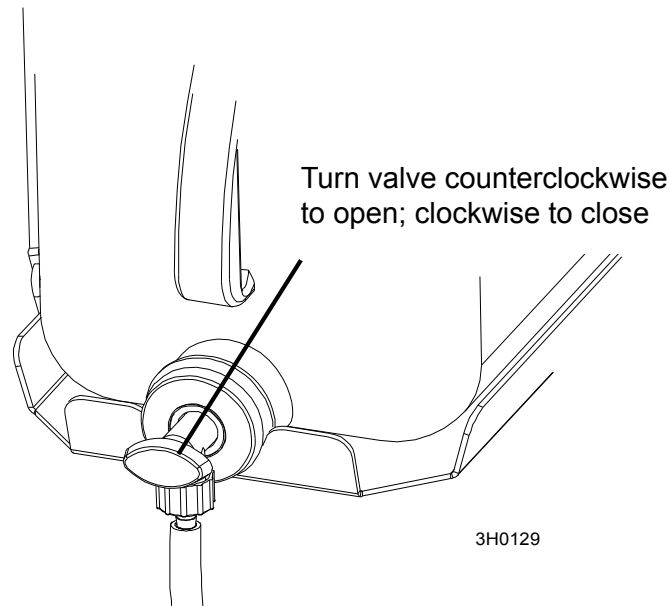
# 2

## Operation

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

#### 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.

## 2.12 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 as described in [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 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.

### 3.1 Wear Life

**See Table 3-1.** 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 3-1*

### 3.2 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.

### 3.3 Sawdust Removal

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

### 3.4 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.

### 3.5 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

### 3.6 Belts

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

### 3.7 Drive Belt Adjustment



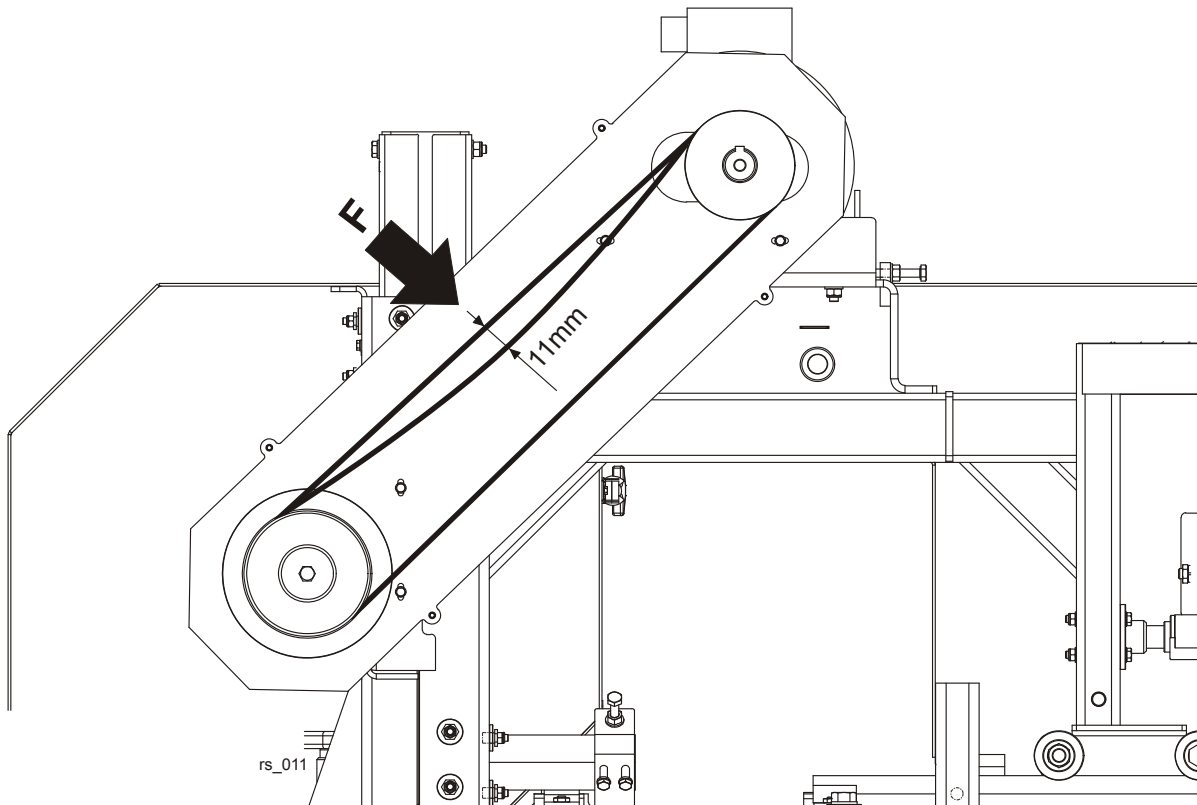
**WARNING!** Do not for any reason adjust the drive belt with the motor running. Doing so may result in serious injury.



See **Table 3-2**. 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 3-2**



**FIG. 3-1**

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.

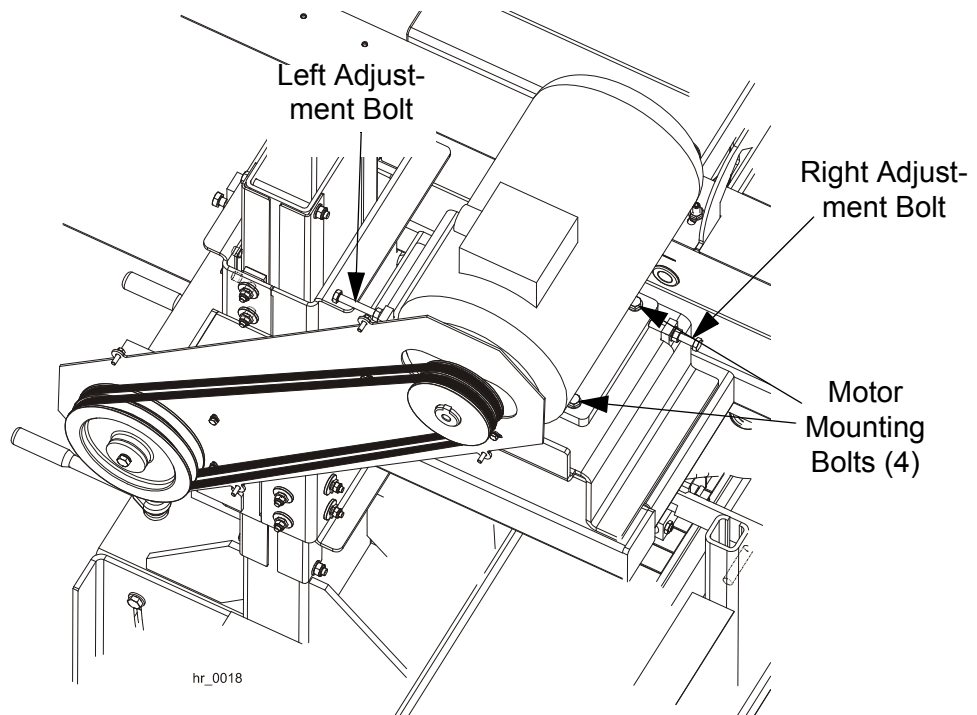


FIG. 3-2



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

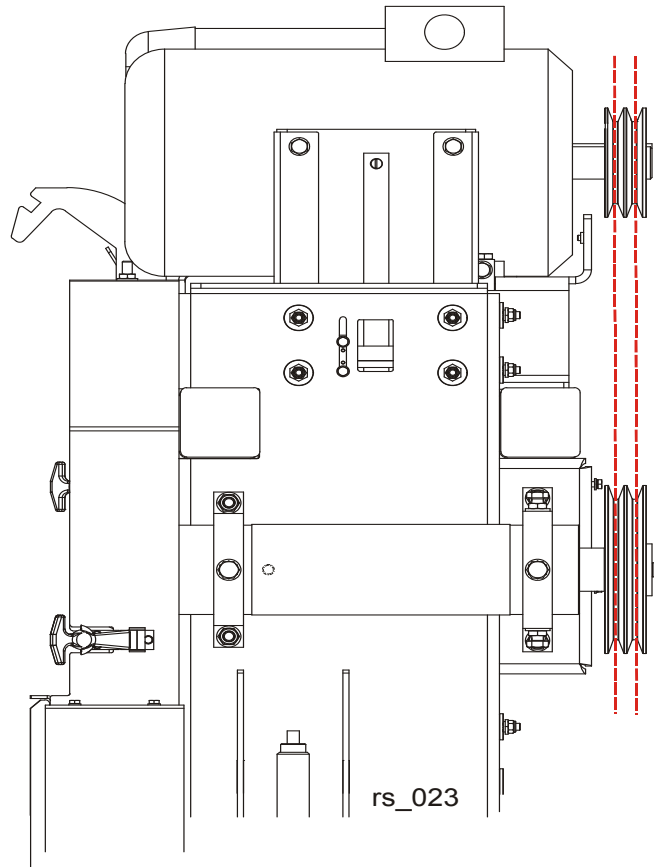
**See Figure 3-3.** Keep the motor and drive pulleys aligned to prevent premature belt wear. To align the motor pulley to the drive pulley, loosen the set screw in the motor pulley groove and slide the motor pulley on the shaft until it is in line with the drive pulley.

# 3

## MAINTENANCE

### *Drive Belt Adjustment*

After performing the alignment, make sure the drive belt tension has not been changed.



**FIG. 3-4**

### 3.8 Feed Track Chain Tension

See Figure 3-5. If necessary, use the adjustment bolts shown below to adjust the feed track chain tension. **NOTE:** The bolts must be adjusted evenly.

See Figure 3-6.

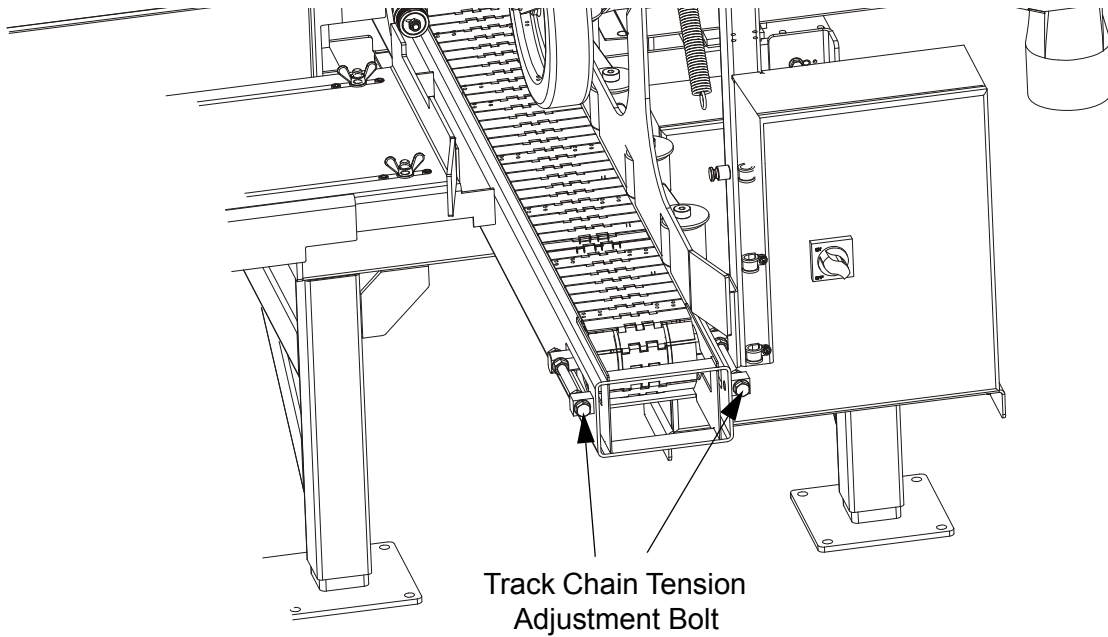


FIG. 3-7

### 3.9 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 3-8.

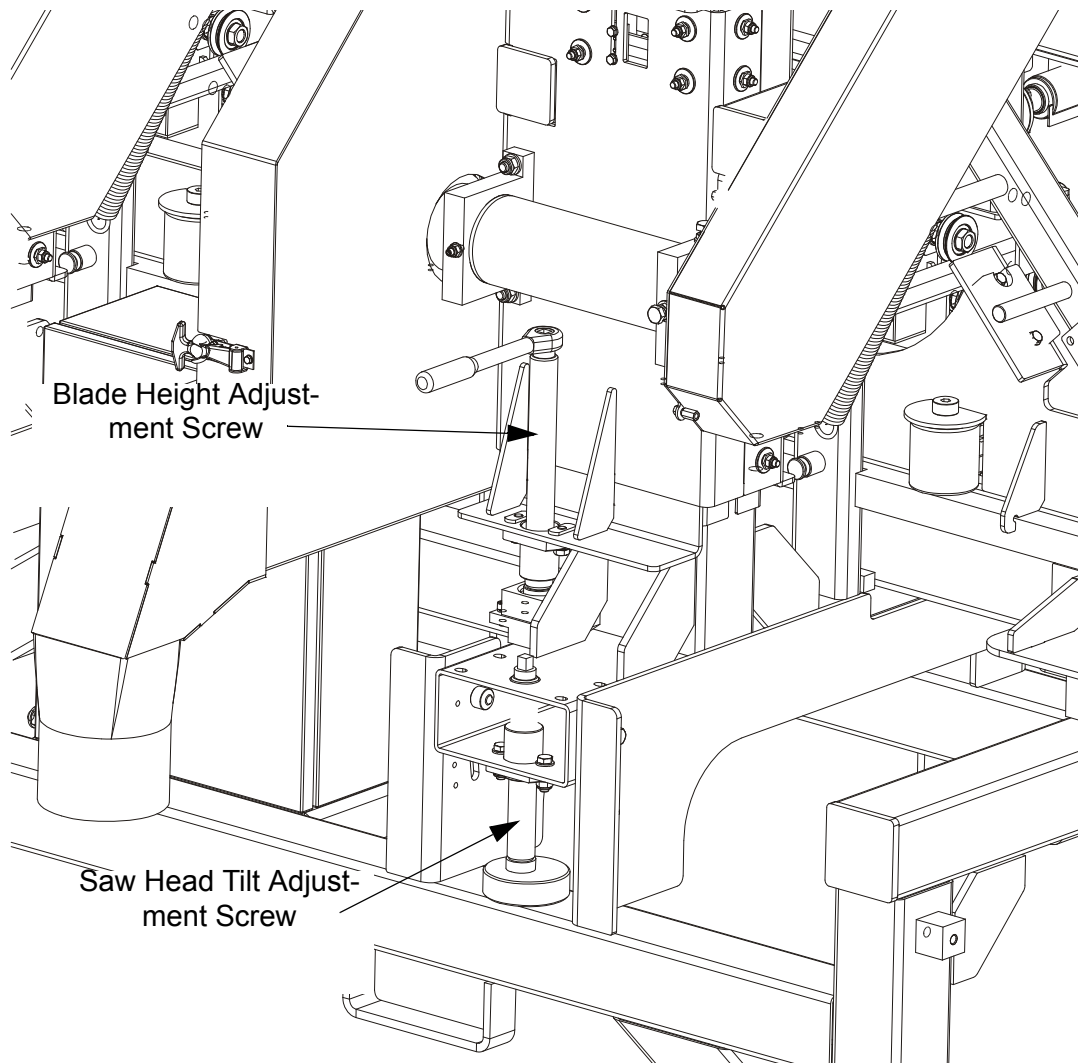


FIG. 3-9



### 3.10 Safety Devices Inspection

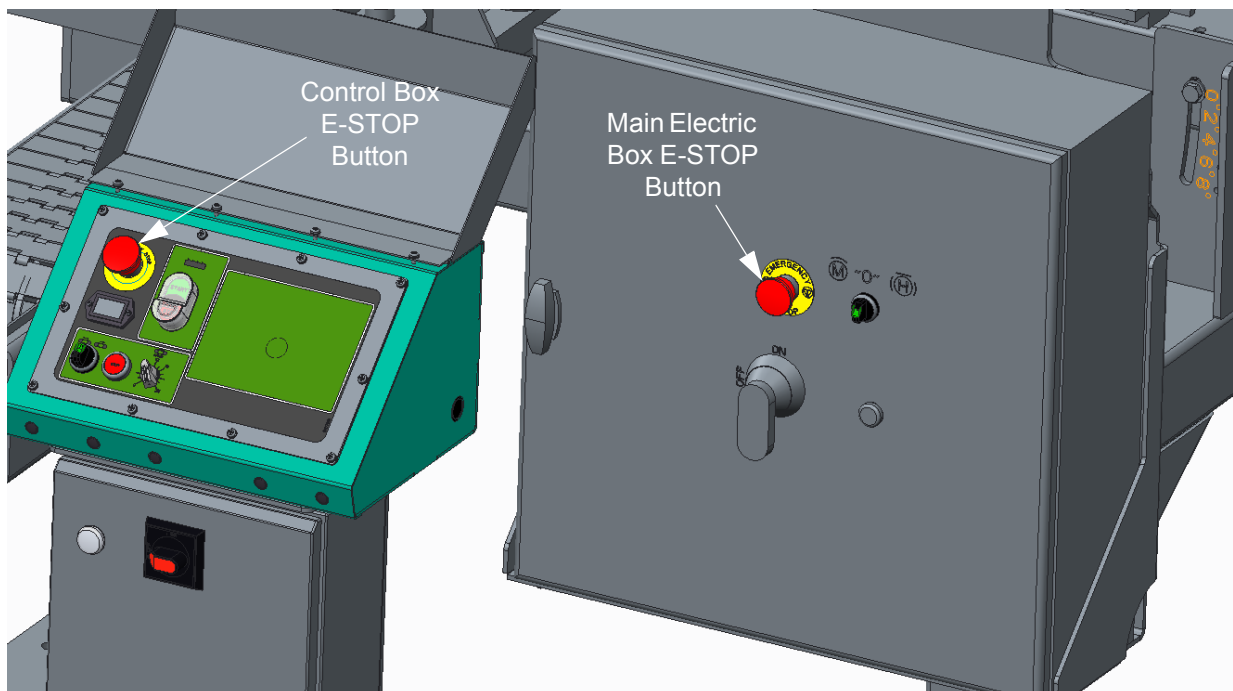
#### *HR Safety Devices Inspection*

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

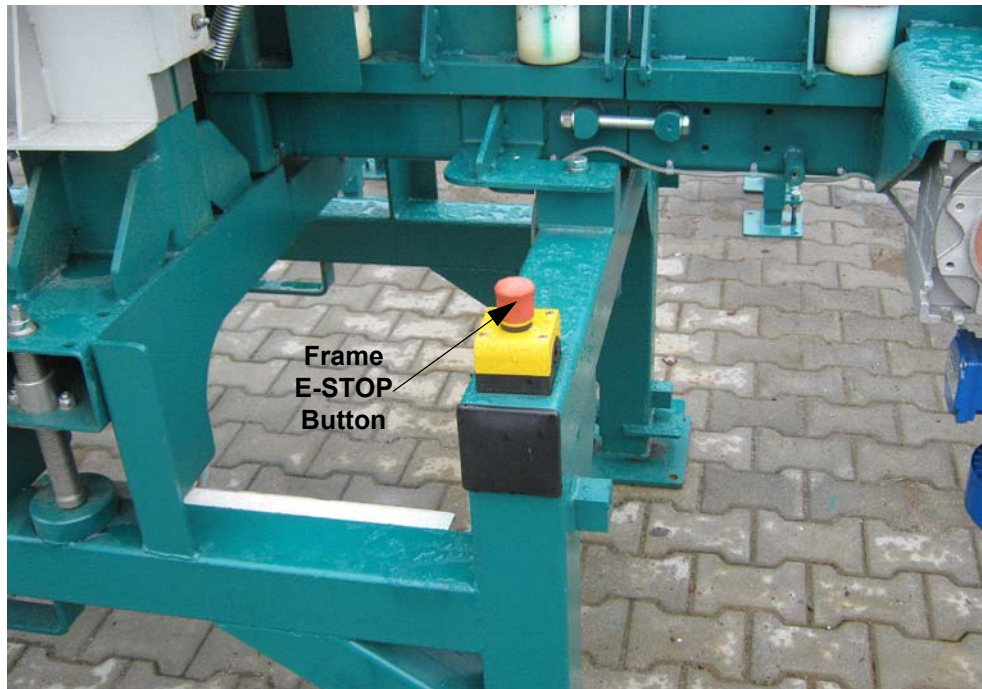
- Start the main motor;
- Push the E-STOP button located on the control box. The motor should stop. It should not be possible to restart the motor until the E-STOP is released.
- Push the E-STOP button located on the main control box. The motor should stop. It should not be possible to restart the motor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



**FIG. 3-10**

## 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. 3-11**

## 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.

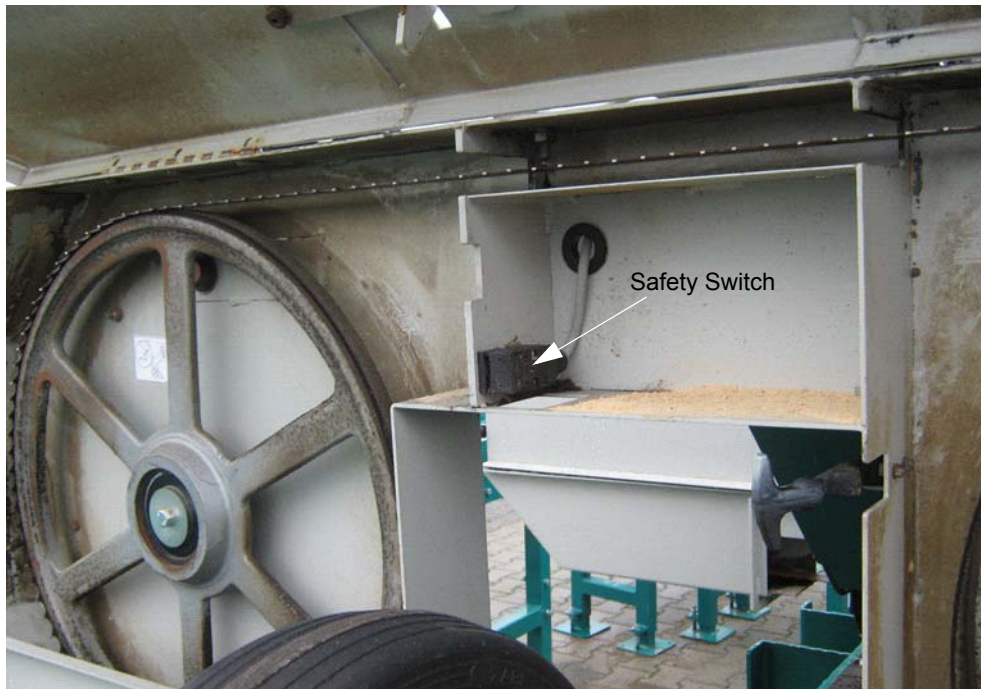


FIG. 3-12

#### 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.)

## SECTION 4 ALIGNMENT

### 4.1 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 4.2](#)).
2. Check and adjust the vertical alignment of the blade guide arm ([See Section 4.5](#)).
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 4.9](#)).
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 4.10](#)).
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.

## 4.2 Blade Installation And Tracking

See Figure 4-1. Install a blade and apply the proper tension as shown below. [See Section 2.4](#)

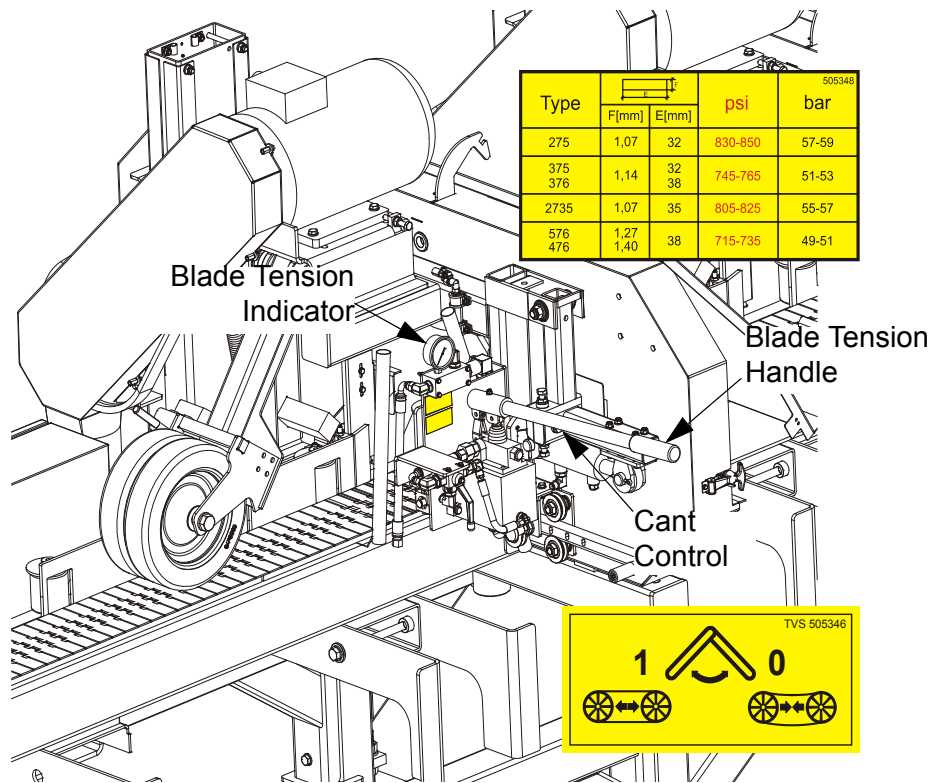


FIG. 4-1

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 4-2. 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

# 4

## Alignment

### Blade Installation And Tracking

[0.04"]). Do not let the teeth ride on the belt.

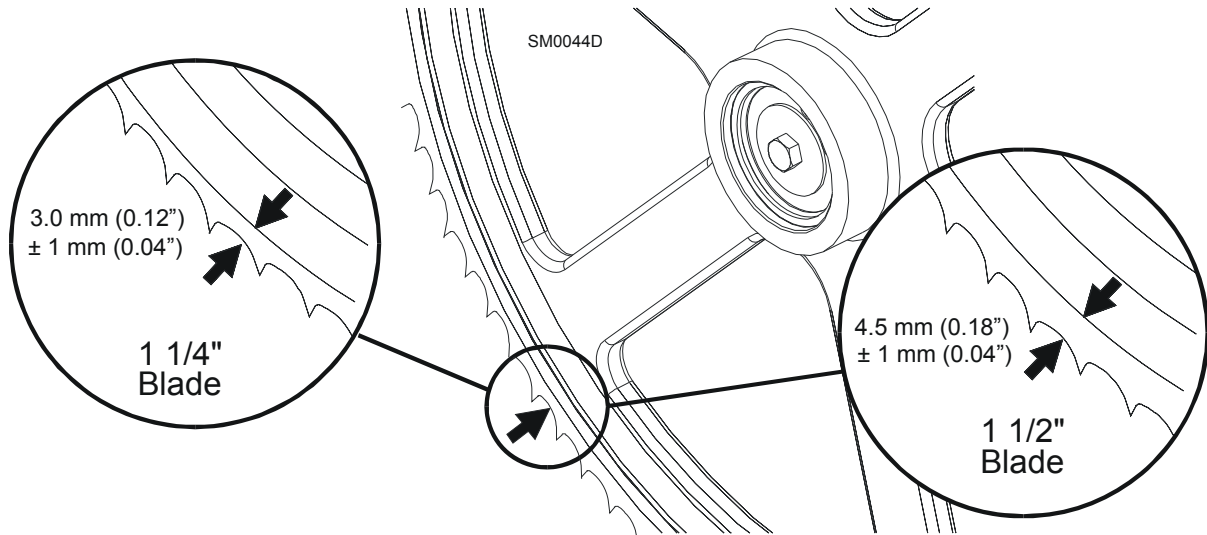


FIG. 4-2

To adjust where the blade travels on the idle-side blade wheel, use the cant control shown in **Figure 4-7**.

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.

### 4.3 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 4-3.

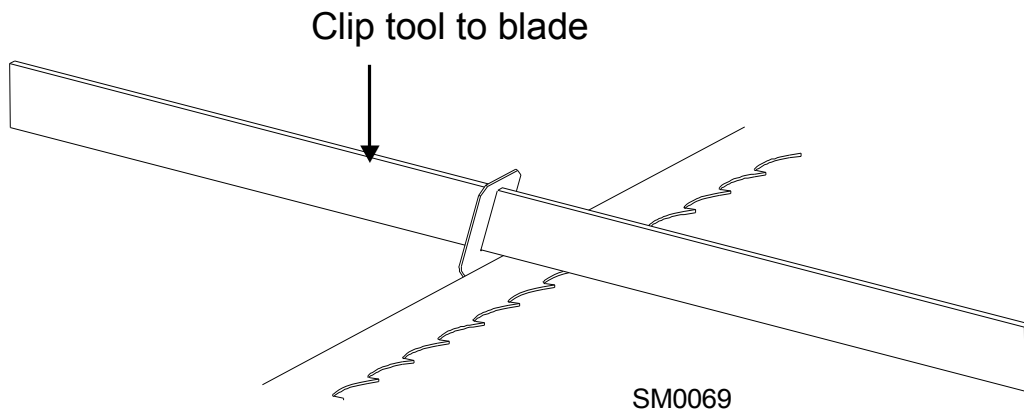


FIG. 4-3

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.



# 4

## Alignment

### Blade Wheel Alignment

**See Figure 4-4.** 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](#)).

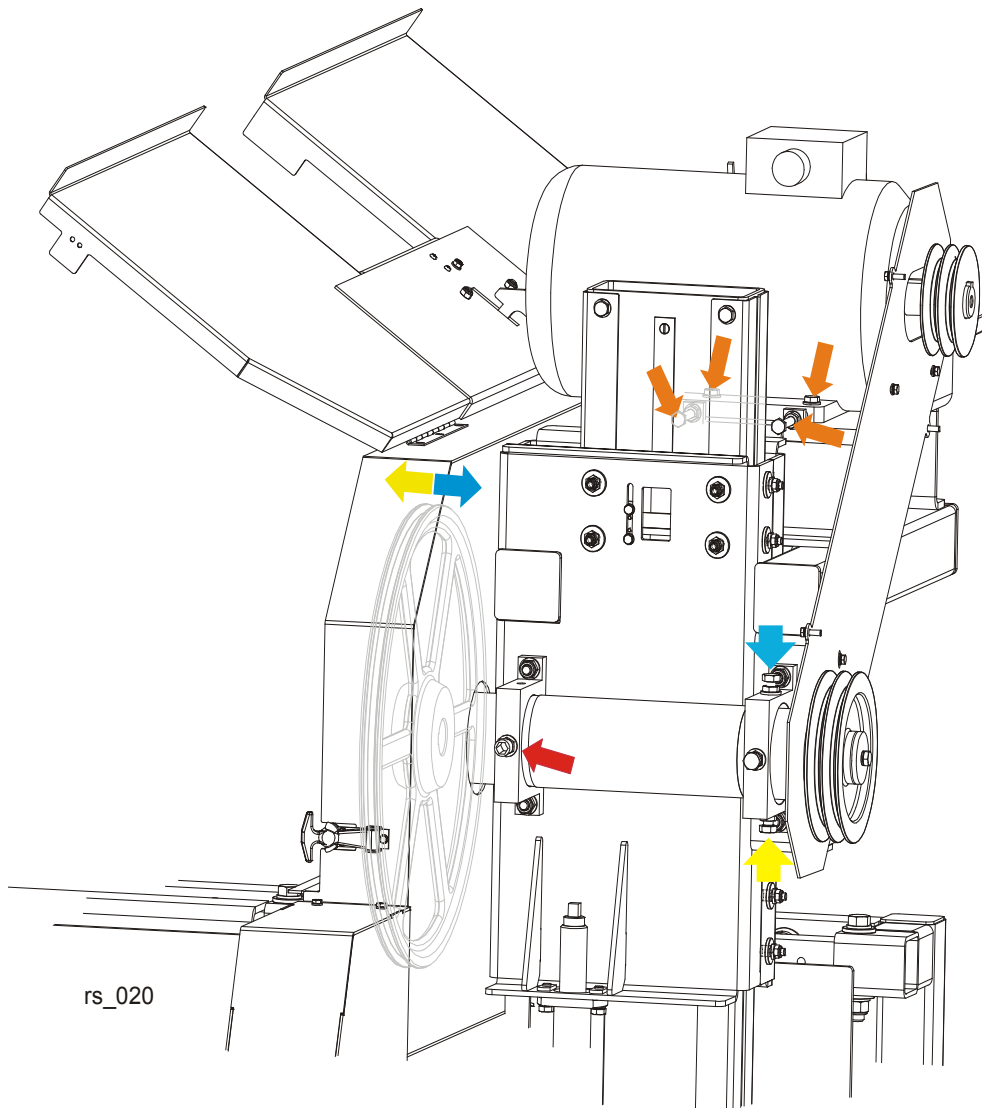


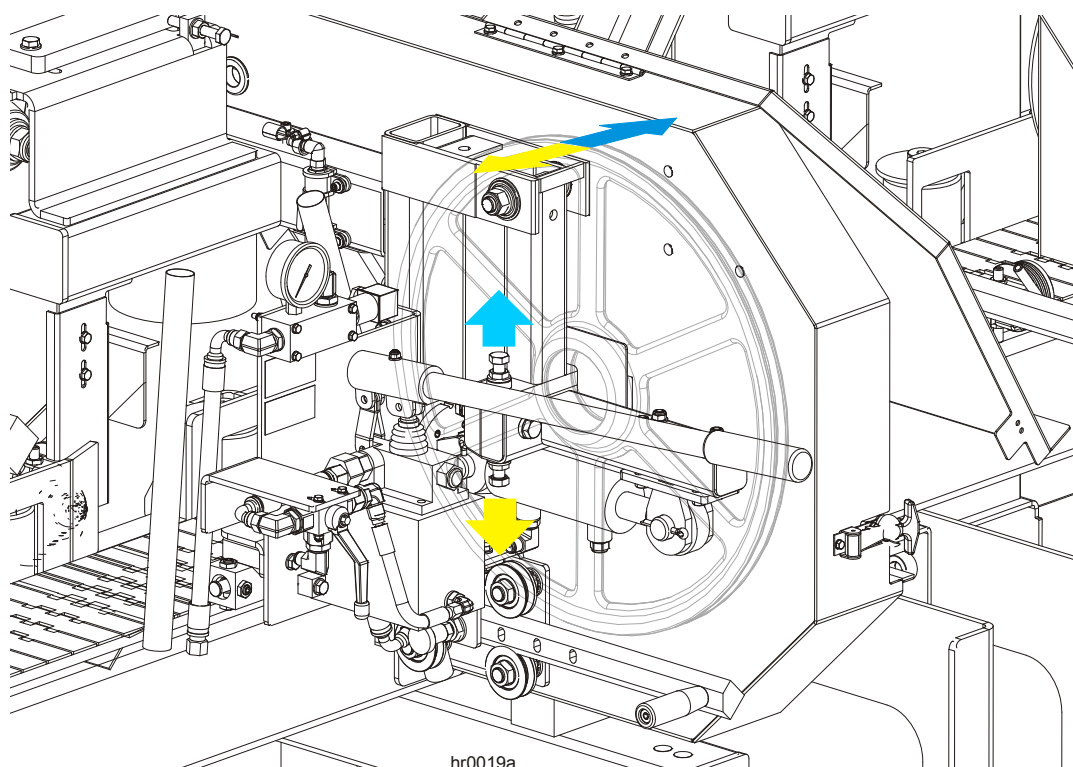
FIG. 4-4



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 4-5.** 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. 4-5**

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.

# 4

## Alignment

### Blade Wheel Alignment

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

See Figure 4-6. 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")).

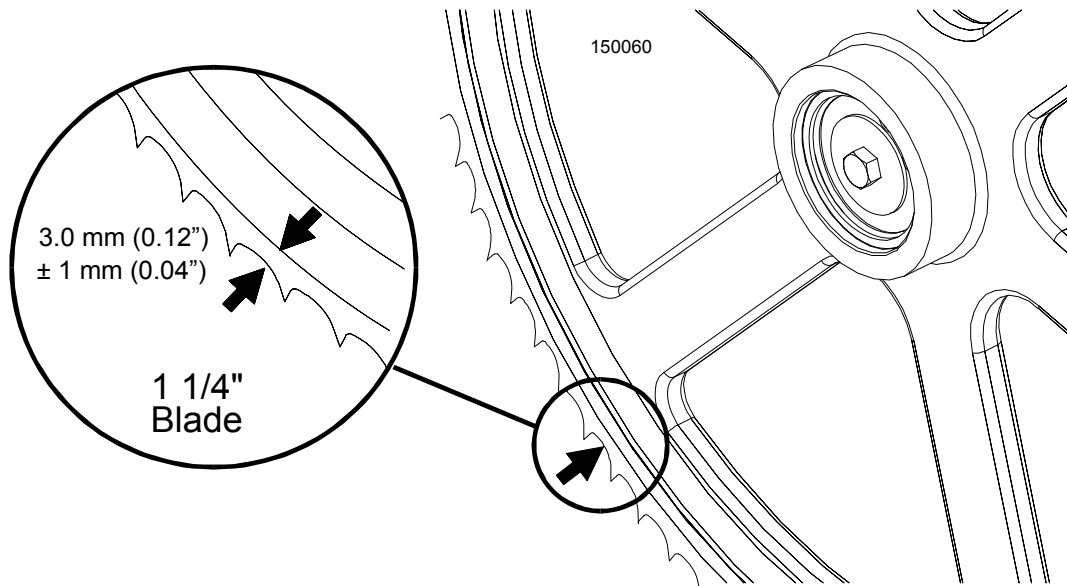


FIG. 4-6

See Figure 4-7. 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.

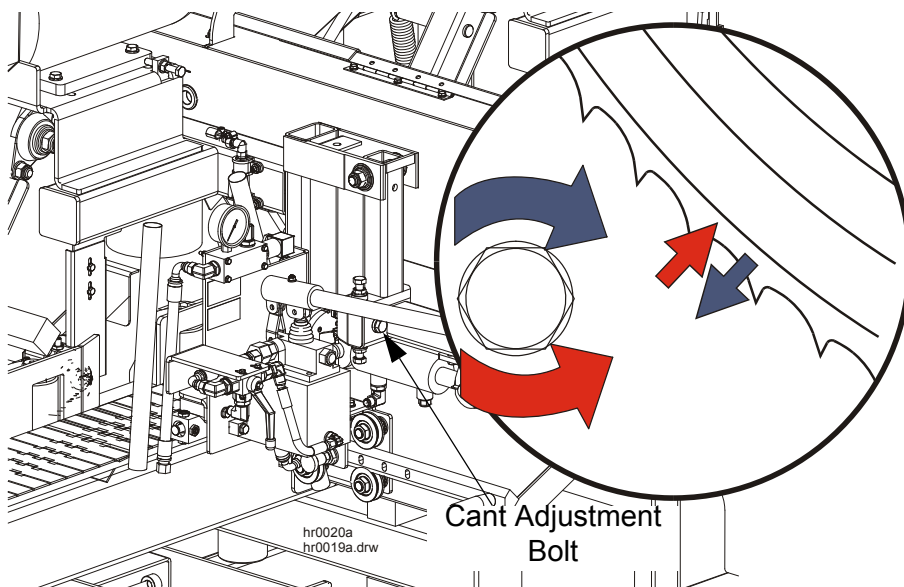


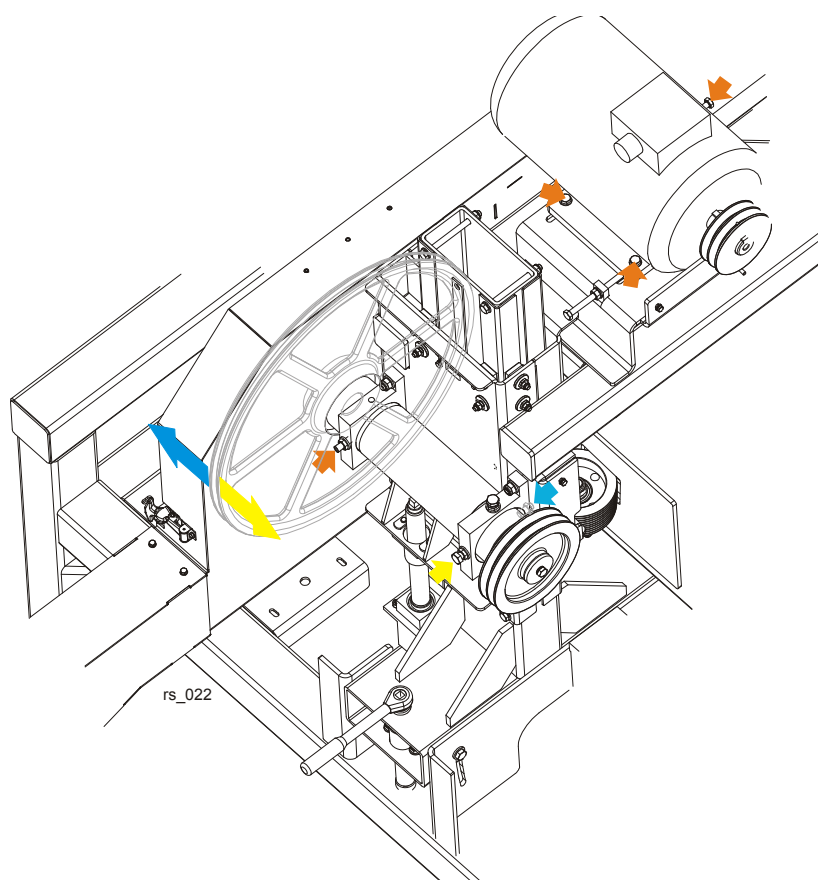
FIG. 4-7

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 4-8.** 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. 4-8**

# 4 Alignment

## Saw Head Adjustment

### 4.4 Saw Head Adjustment

See Figure 4-9. 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.

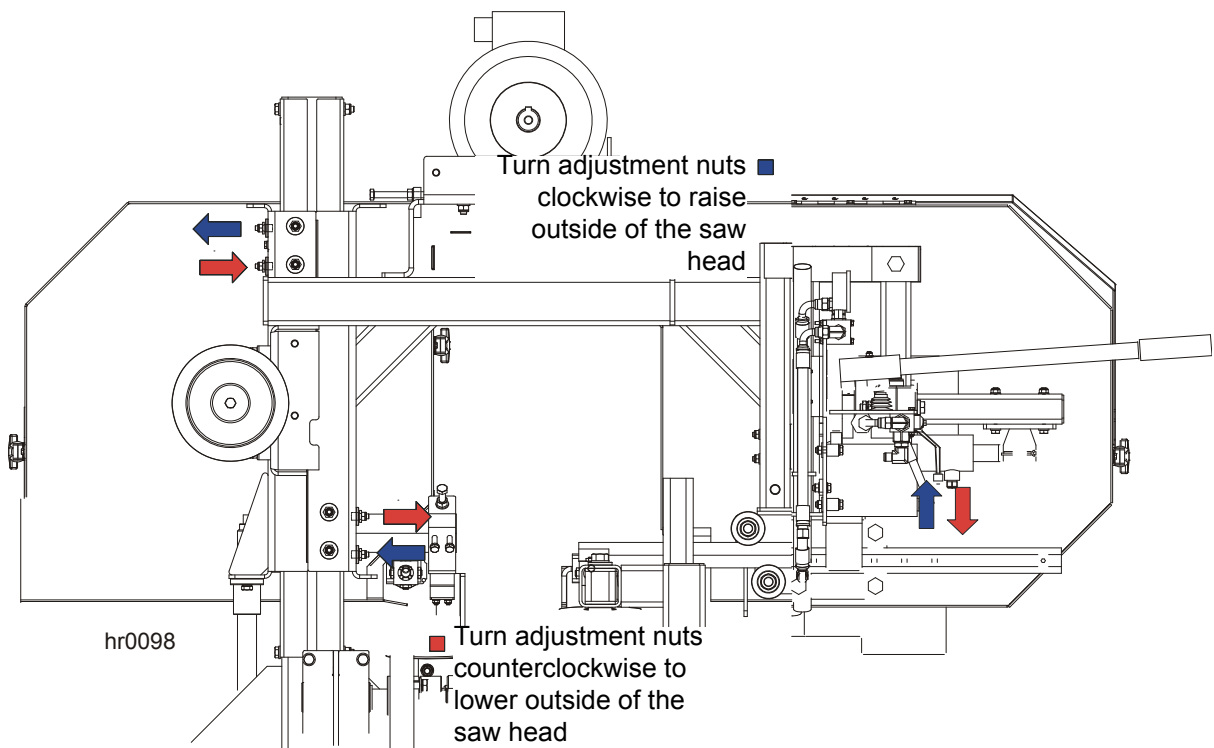


FIG. 4-9

## 4.5 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 4-10.

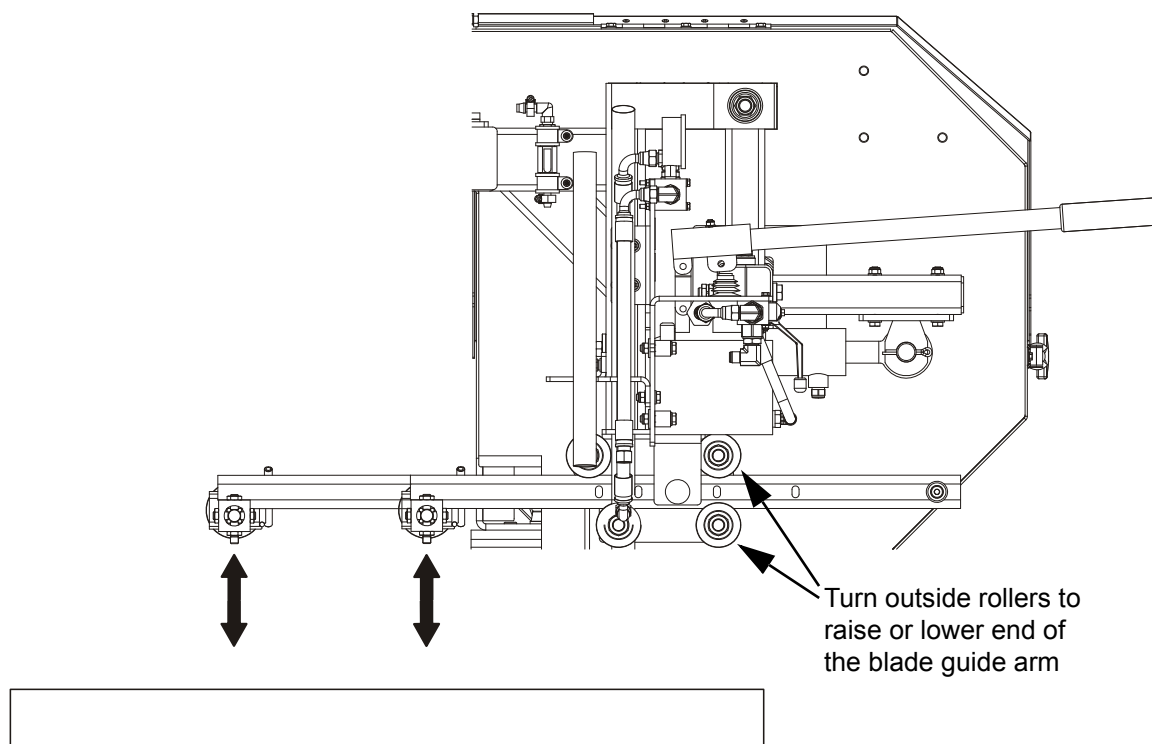


FIG. 4-10

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.

# 4

## Alignment

### Blade Guide Arm Horizontal Adjustment

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.

## 4.6 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 4-11.

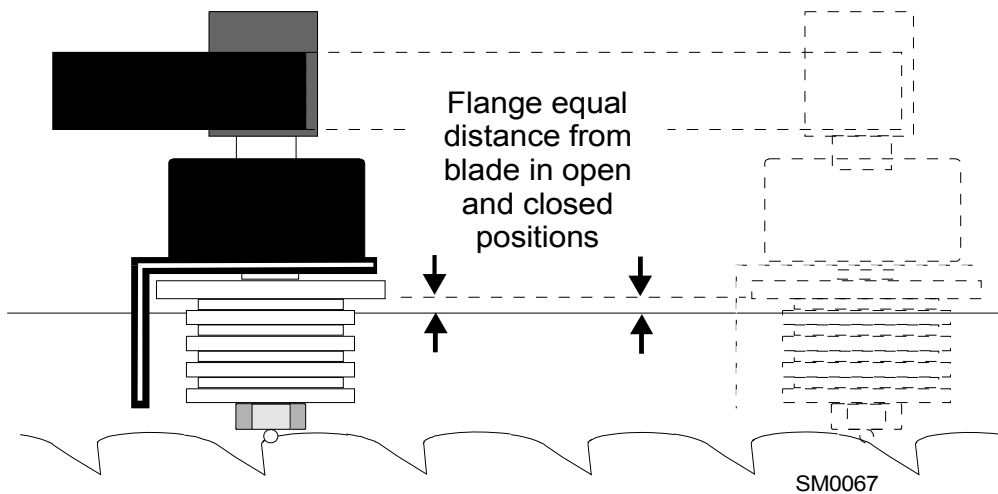
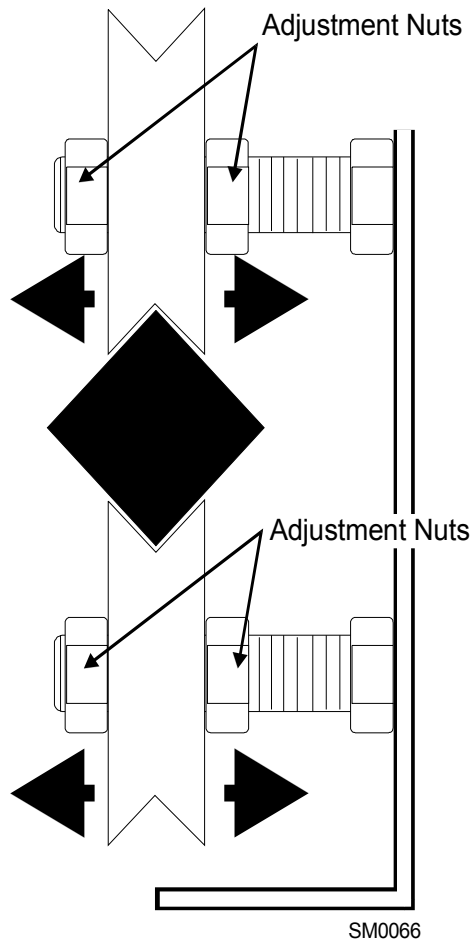


FIG. 4-11

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 4-12.



**FIG. 4-12**

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.

# 4

## Alignment

### *Aligning the Blade Guides*

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#### 4.7 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.



## 4.8 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 4-13.

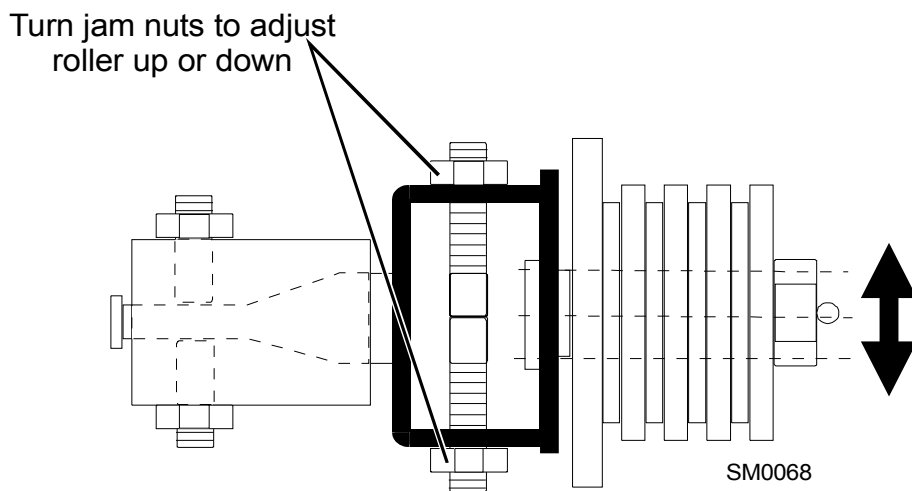


FIG. 4-13

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.

## 4.9 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 4-14.

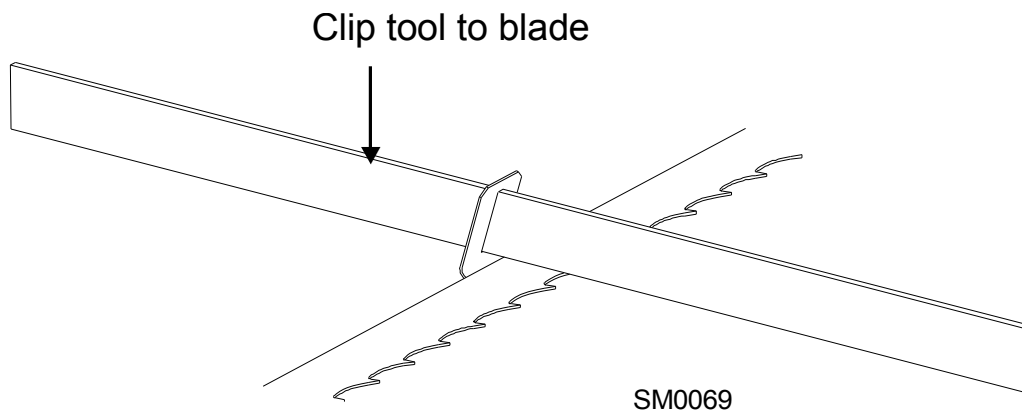


FIG. 4-14

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 4-15.** 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.

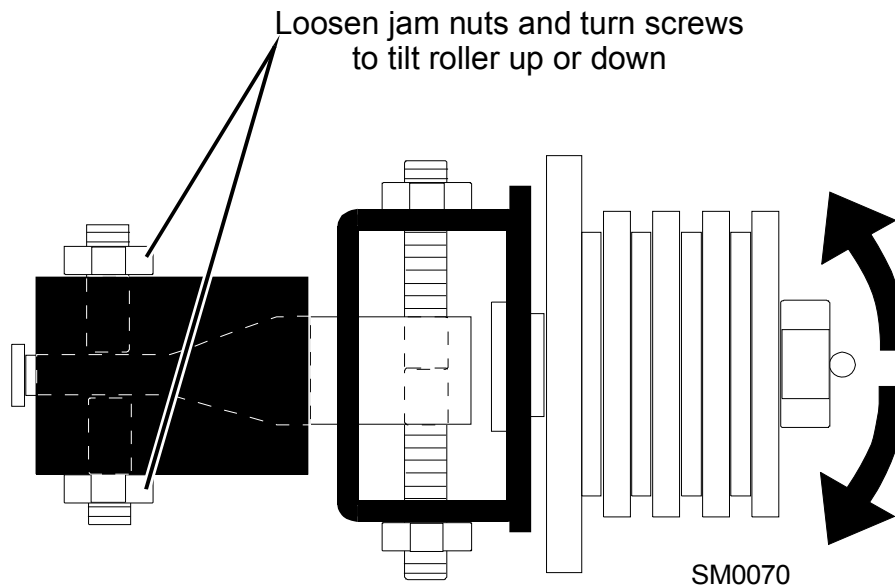


FIG. 4-15

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.

# 4

## Alignment

### Blade Guide Spacing

---

#### 4.10 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 4-16.

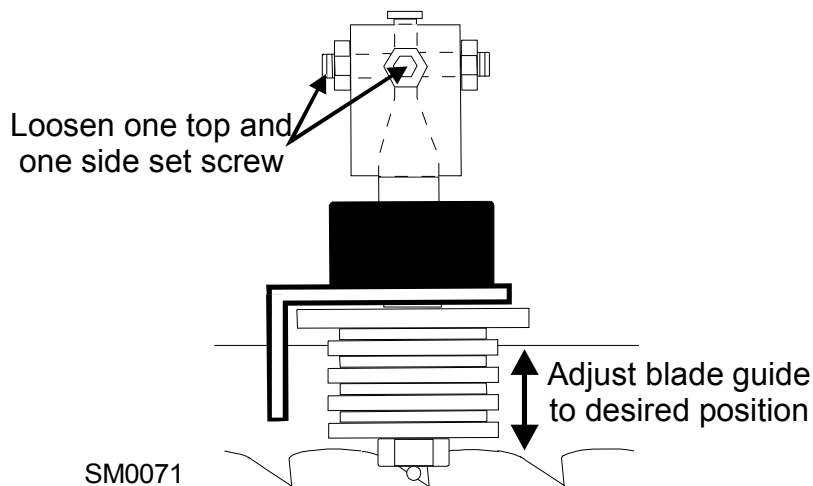


FIG. 4-16

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.

## 4.11 Blade Guide Horizontal Tilt Adjustment

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

See Figure 4-17.

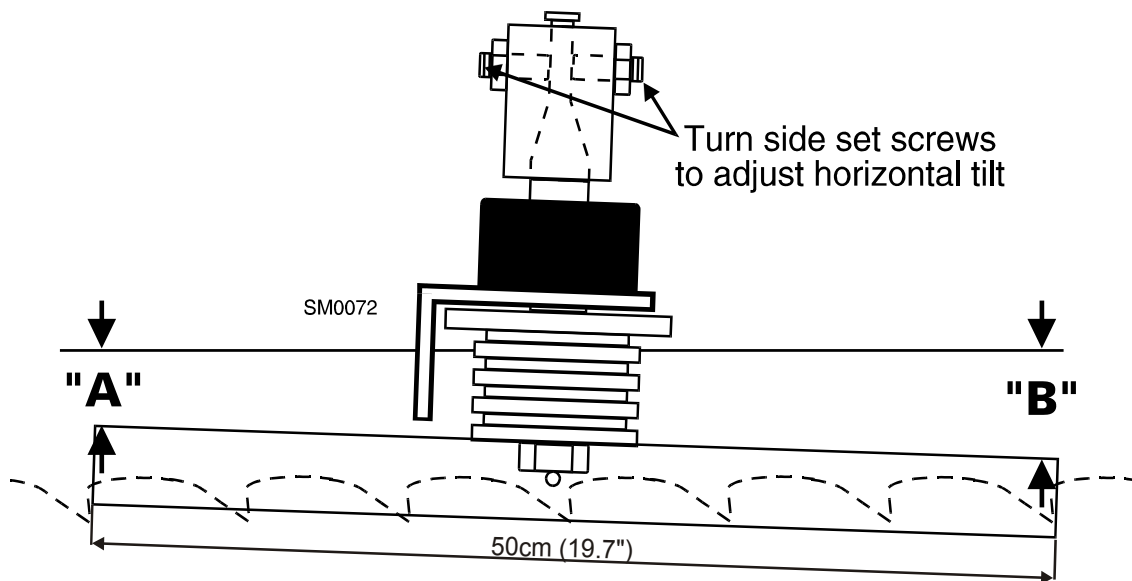


FIG. 4-17

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.

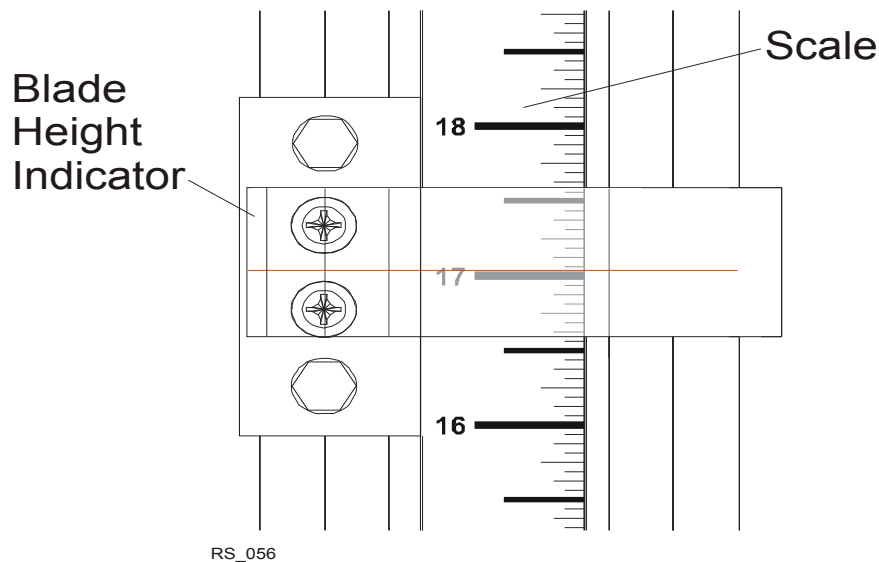
## 4.12 Blade Height Scale Adjustment

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 4-18.**

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



**FIG. 4-18**

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.

# SECTION 5 SPECIFICATIONS

## 5.1 Overall Dimensions

See Figure 5-1. The major dimensions of the resaw are shown below (all dimensions are in millimeters).

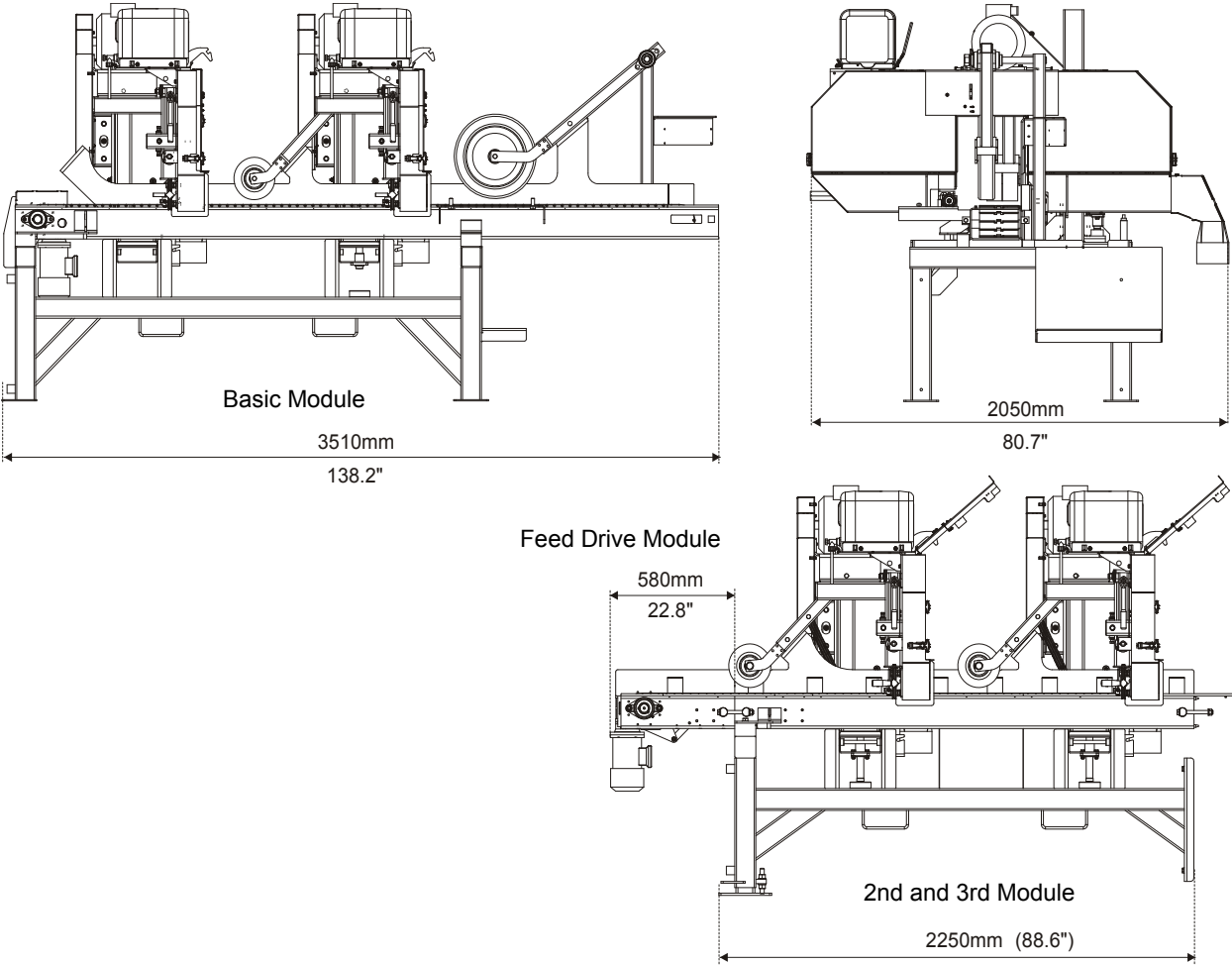


FIG. 5-1

## 5 Specifications

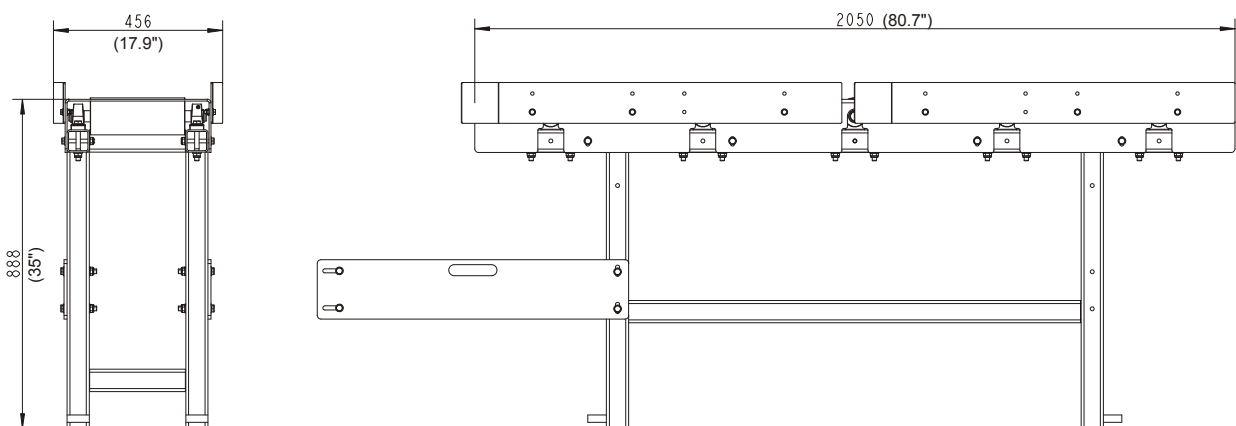
### Overall Dimensions

See Table 5-1. The overall dimensions of the resaw are listed in the table below.

<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 5-1**

See Figure 5-2. The major dimensions of the Idle Roller Table (SLPIRT) are shown below.



**FIG. 5-2**



See Figure 5-3. See the figure below for the major dimensions of the Cross Roller Table (SLPCRT).

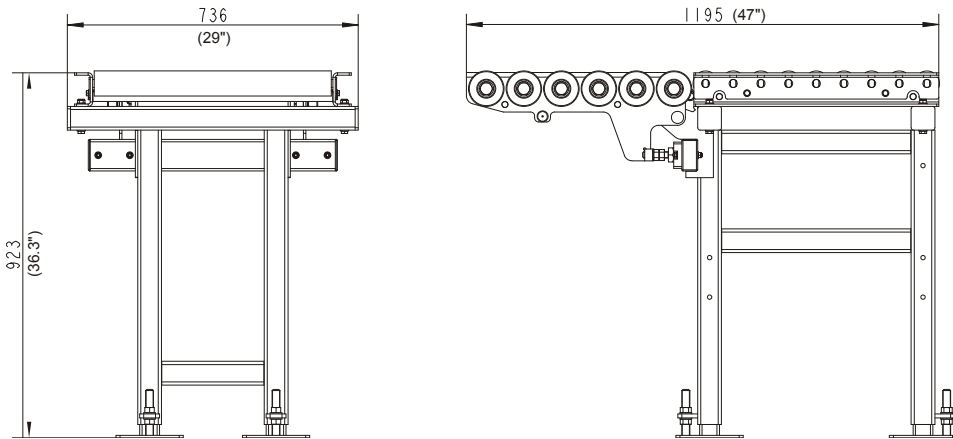


FIG. 5-3

**5** Specifications  
Overall Dimensions

See Figure 5-4. The figure below shows locations of the resaw legs.

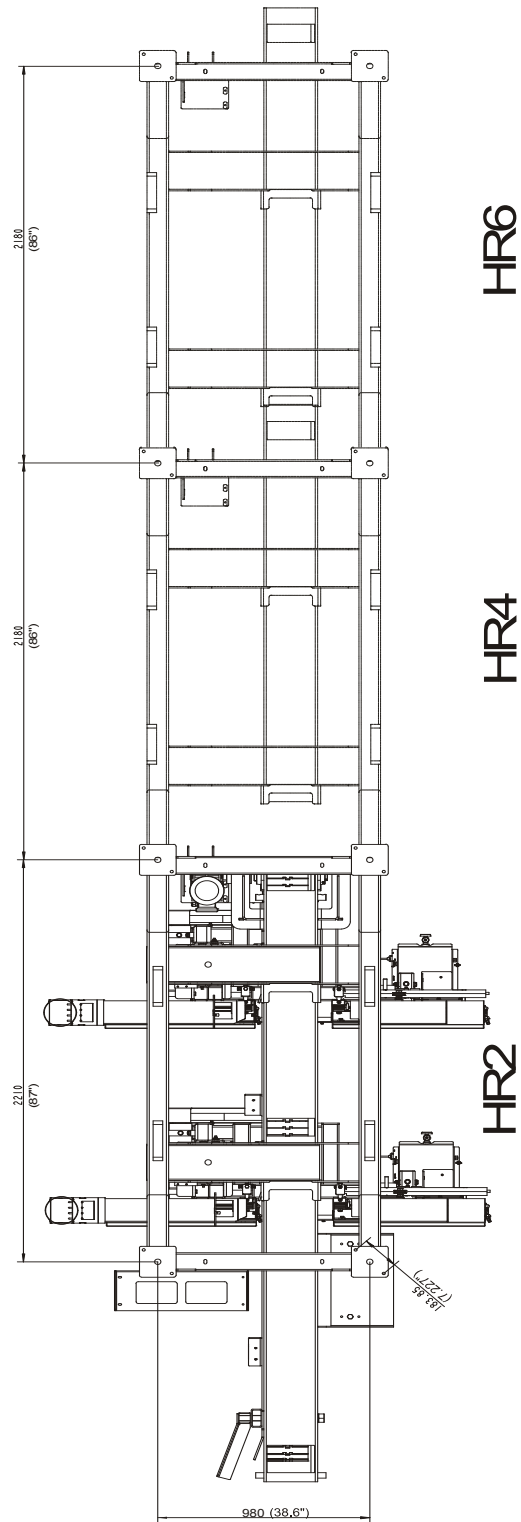


FIG. 5-4

## 5.2 Cutting Capacity

See Table 5-2. 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>	0-300 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 (automatic up/down system)</b>	180 mm (7.1")

**TABLE 5-2**

See Table 5-3. 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.

<b>Motor Size</b>	<b>Recommended Blade Type</b>		
	<b>Softwood</b>	<b>Medium Hardwood</b>	<b>Frozen Timber or Dense Hardwood</b>
<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

### 5.3 Blade Motor Specifications

See Table 5-4. See the table below for blade motor specifications for your resaw model.

Motor Type	Manufacturer	Model	Power	Other Specifications
E11 Electric	Indukta	Sg 132M-4- HM	7,5kW	400 V/50Hz; 15 Amp; 1450 r.p.m.
E15 Electric	Indukta	Pssg 132M-4A-HM	11kW	400 V/50Hz; 23 Amp; 1450 r.p.m.

TABLE 5-4

### 5.4 Noise Level

See Table 5-5. The noise levels of the resaw are listed below<sup>12</sup>.

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

TABLE 5-5

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.

## 5.5 V-Belt Sizes

See Table 5-6. Belt sizes for the resaw are shown.

Belt Description	Belt Size	Wood-Mizer Part No.
Drive Belt (E15)	2BX70	P04857-2
Blade Wheel Belt	B72.5	017922

TABLE 5-6

## 5.6 Dust Extractor Specifications

See Table 5-7. Specifications of the dust extractors used on the resaw for each saw head are listed below.

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 5-7



**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.

**6** Electrical Information

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**SECTION 6 ELECTRICAL INFORMATION**



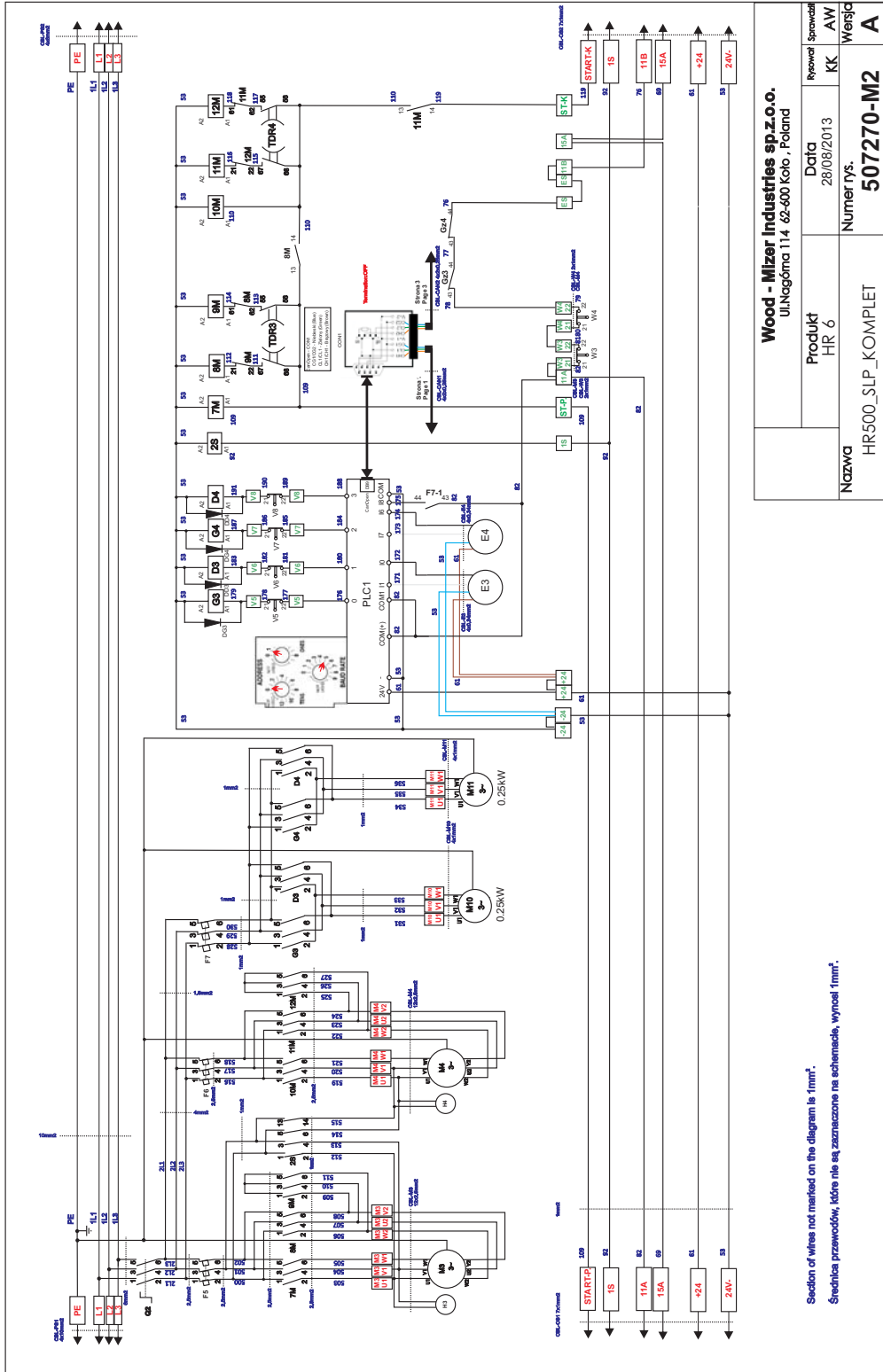
## 6.2 Electrical Components, 507270-M1

Ref.	Symbol	Description	Manufacturer	Wood-Mizer Part No.
1	Q	Switch, INTERPACT INS160 3P Disconnect	SCHNEIDER ELECTRIC	091552
2	F1, F2	Circuit Breaker, GV3ME40 Motor	SCHNEIDER ELECTRIC	090436
3	1M, 2M, 4M, 5M	Contact, LC1 D25 BD	SCHNEIDER ELECTRIC	093899
4	3M, 6M	Contact, LC1 D18BD	SCHNEIDER ELECTRIC	092476
5	1S, 4S	Contact, LC1 D09BD	SCHNEIDER ELECTRIC	092477
6	F3	Circuit Breaker, Gz1M14 Motor	SCHNEIDER ELECTRIC	510267
7	F4	Circuit Breaker, Gz1M108 Motor	SCHNEIDER ELECTRIC	083659
8	F4-1	Contact, Gz1-AN11 Auxiliary	SCHNEIDER ELECTRIC	091611
9	TDR1, TDR2	Relay, LAD S2 Time	SCHNEIDER ELECTRIC	084037
10	L1	Light, 1SFA619402L5415 White Control	ABB	509129
11	DRV1	Controller, ALTIVAR ATV312HU11N4 Speed	SCHNEIDER ELECTRIC	093488
12	PH	Switch, M22 3-position	MOELLER	091359
13		Block, M22-K01Contact	MOELLER	092684
14		Block, M22-K01Contact	MOELLER	092684
15		Block, M22-K10 Contact	MOELLER	091362
16	S5	Button, XB7 ES542P Emergency Stop	SCHNEIDER ELECTRIC	502315
17		Washer, ZBY9330 Emergency Stop Button	SCHNEIDER ELECTRIC	086561
18	G1, G2, D1, D2	Contact, LP1 K601 BD	SCHNEIDER ELECTRIC	506237
19	PLC	Controller, PLC MODICON TM238LFDC24DT	SCHNEIDER ELECTRIC	510290
20	DD1, DG1, D2, DG2	Diode, 1N4007	-	087497

**TABLE 6-1**

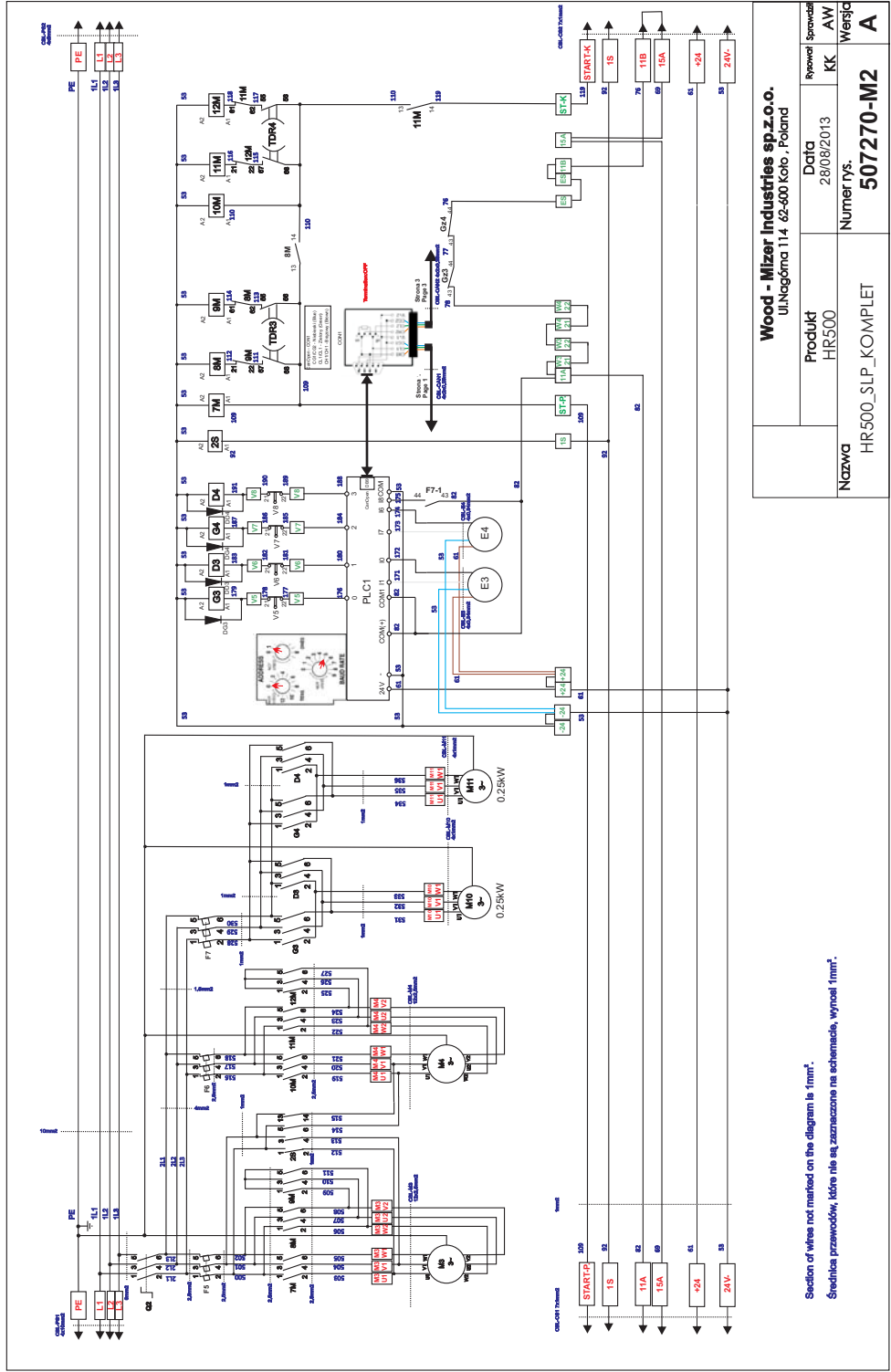


6.3 Electrical Diagram, 507270-M2 (HR500\_EH\_EC\_S-4)



RYS. 6-2

**5.7 Electrical Diagram, 507270-M2 (HR500\_EH\_EC-4)**



<b>Wood - Mizer Industries sp.z o.o.</b> ul. Nagomna 114, 82-900 Końce, Poland	
Produkt	HR500
Nazwa	HR500_SLP_KOMPLET
Data	28/08/2013
Przebieg Sprzedaży	KK
AW	Wersja
Numer rys.	<b>507270-M2</b>
	<b>A</b>

Section of wires not marked on the diagram is 1mm².  
 Srednica przewodów, które nie są zaznaczone na schemacie, wynosi 1mm².

**RYS. 5-5**

## 6.4 Electrical Components, 507270-M2

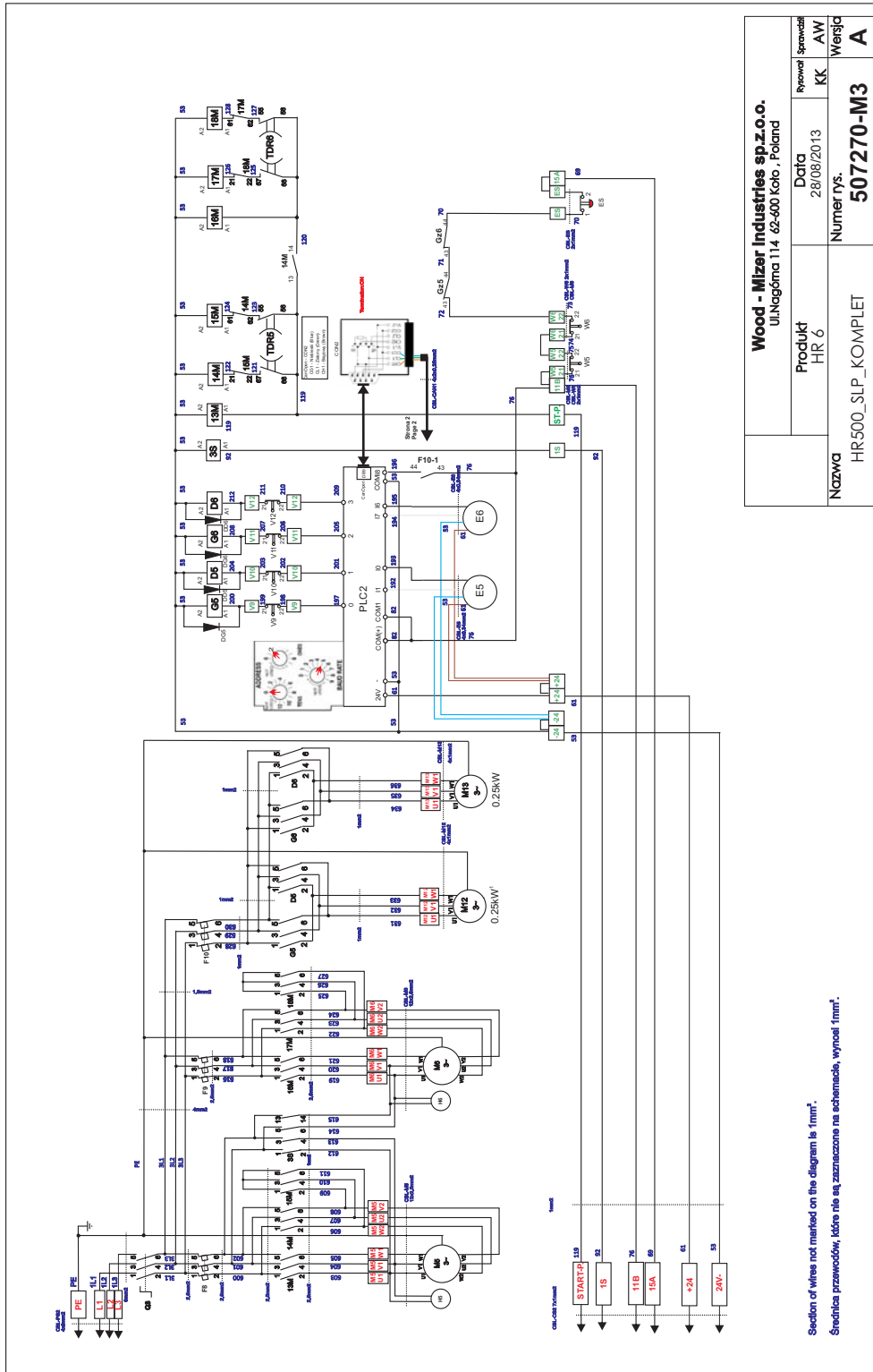
Symbol	Description	Manufacturer	Wood-Mizer Part No.
<b>Q2</b>	Switch, ABB OT40F3 Disconnect	ABB	502312
<b>F5, F6</b>	Circuit Breaker, GV3ME40 Motor	SCHNEIDER ELECTRIC	090436
<b>F7</b>	Circuit Breaker, Gz1M08 Motor	SCHNEIDER ELECTRIC	083659
<b>F7-1</b>	Contact, GZ1-AN11 Auxiliary	SCHNEIDER ELECTRIC	091611
<b>7M, 8M, 10M, 11M</b>	Contactor, LC1 D25 BD	SCHNEIDER ELECTRIC	093899
<b>9M, 12M</b>	Contactor, LC1 D18 BD	SCHNEIDER ELECTRIC	092476
<b>2S</b>	Contactor, LC1 D09 BD	SCHNEIDER ELECTRIC	092477
<b>TDR3, TDR4</b>	Relay, LAD S2 Time	SCHNEIDER ELECTRIC	084037
<b>G3, G4, D3, D4</b>	Contactor, LP1 K601 BD	SCHNEIDER ELECTRIC	506237
<b>PLC1</b>	Controller, PLC OTB1CODM9LP	SCHNEIDER ELECTRIC	510759
<b>CBL-CAN 1-HR500</b>	Cable, Canopen Connection (includes CON1 connector)	WMI	
<b>CON1</b>	Connector, Canopen SUB-D TSXCANKCDF90T Female	SCHNEIDER ELECTRIC	509153
<b>-</b>	Cable, ETHERLINE P CAT5e	LAPP KABEL	R80578-5

**TABLE 6-2**

# 6 Electrical Information

## Electrical Diagram, 507270-M3 (HR500\_EH\_EC\_S-6)

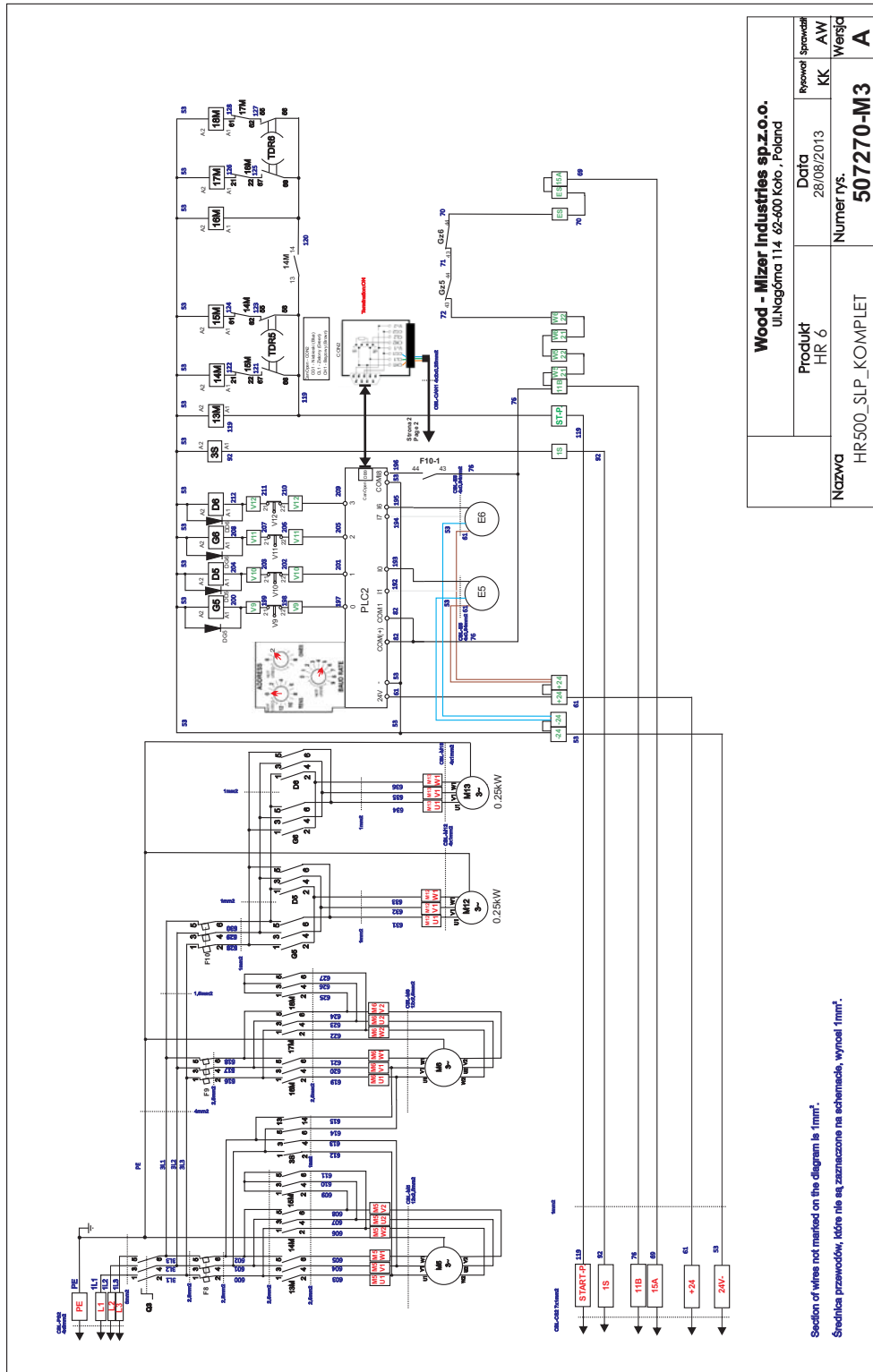
### 6.5 Electrical Diagram, 507270-M3 (HR500\_EH\_EC\_S-6)



<b>Wood - Mizer industries sp.z.o.o.</b> ul.Nagomska 114 62-600 Koto, Poland		Revised	Approved
Produkt	Data	KK	AW
HR 6	28/08/2013		
NAZWA	Numer rys.	Wersja	
HR500_SIP_KOMPLET	<b>507270-M3</b>	<b>A</b>	

RYS. 6-3

6.6 Electrical Diagram, 507270-M3 (HR500\_EH\_EC-6)



Wood - Mizer Industries sp.z.o.o. ul. Nagłomska 114 62-600 Koło, Poland		Wykonali KK	Sprawdził AW
Produkt HR 6	Data 28/08/2013	Numer rys. 507270-M3	
Nazwa HR500_SLP_KOMPLET		Wersja A	

Section of wires not marked on the diagram is 1mm<sup>2</sup>.  
Srednica przewodów, które nie są zaznaczone na schemacie, wynosi 1mm<sup>2</sup>.

## 6.7 Electrical Components, 507270-M3

Symbol	Description	Manufacturer	Wood-Mizer Part No.
<b>Q3</b>	Switch, ABB OT40F3 Disconnect	ABB	502312
<b>F8, F9</b>	Circuit Breaker, GV3ME40 Motor	SCHNEIDER ELECTRIC	090436
<b>F10</b>	Circuit Breaker, Gz1M08 Motor	SCHNEIDER ELECTRIC	083659
<b>F10-1</b>	Contact, GZ1-AN11 Auxiliary	SCHNEIDER ELECTRIC	091611
<b>13M, 14M, 16M, 17M</b>	Contact, LC1 D25 BD	SCHNEIDER ELECTRIC	093899
<b>15M, 18M</b>	Contact, LC1 D18 BD	SCHNEIDER ELECTRIC	092476
<b>3S</b>	Contact, LC1 D09 BD	SCHNEIDER ELECTRIC	092477
<b>TDR5, TDR6</b>	Relay, LAD S2 Time	SCHNEIDER ELECTRIC	084037
<b>G5, G6, D5, D6</b>	Contact, LP1 K601 BD	SCHNEIDER ELECTRIC	506237
<b>PLC2</b>	Controller, PLC OTB1CODM9LP	SCHNEIDER ELECTRIC	510759
<b>CBL-CAN2 -HR500</b>	Cable, CANOPEN Connection (includes CON2 connector)	WMI	
<b>CON2</b>	Connector, CANOPEN SUB-D TSXCANKCDF90T Female	SCHNEIDER ELECTRIC	509153
-	Cable, ETHERLINE P CAT5e	LAPP KABEL	R80578-5

**TABLE 6-3**

**6.8 Electrical Components, Power Supply Box (Part #507269)**

<b>Symbol</b>	<b>Description</b>	<b>Manufacturer</b>	<b>Wood-Mizer Part No.</b>
Q	Switch, ABB OT16E3 Disconnect	ABB	089801
F1	Circuit Breaker, iC60N 2P 2A C	SCHNEIDER ELECTRIC	510259
Ps1	Power Supply, ABL8RPS24050	SCHNEIDER ELECTRIC	089814
L1	Light, M22 LED24V White Control	MOELLER	090488

**TABLE 6-4**

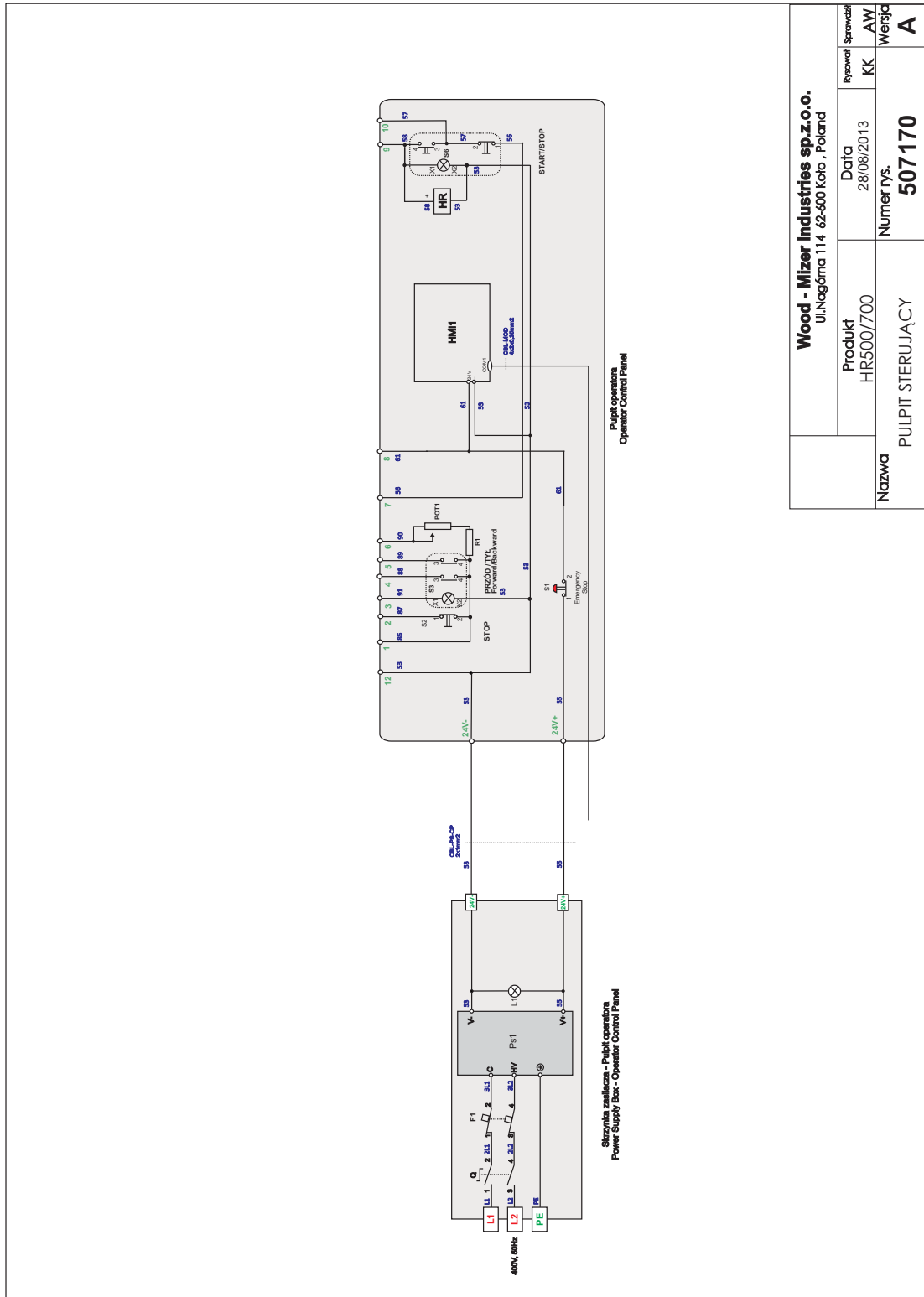
## 6.9 Electrical Component List, HR 500

Ref.	Symbol	Description	Manufacturer	Wood-Mizer Part No.
1	EL	VALVE, SCE238A002 24VDC SOLENOID	ASCO	510270
2	E1,E2	ENCODER, 48 IMP./REV.	SELBIT	510285
3	CBL-E1, CBL-E2	CABLE, 5 M 4-WIRE	BALLUFF	087652
4	V1,V2,V3, V4	SWITCH, FA138 Z11 LIMIT	GIOVENZANA	100931
5	E3,E4	ENCODER, 48 IMP./REV.	SELBIT	510285
6	CBL-E3, CBL-E4	CABLE, 5 M 4-WIRE	BALLUFF	087652
7	V5,V6,V7, V8	SWITCH, FA138 Z11 LIMIT	GIOVENZANA	100931
8	E5,E6	ENCODER, 48 IMP./REV.	SELBIT	510285
9	CBL-E5, CBL-E6	CABLE, 5 M 4-WIRE	BALLUFF	087652
10	V9,V10,V1 1,V12	SWITCH, FA138 Z11 LIMIT	GIOVENZANA	100931
11	ES	BUTTON, XALK 174 EMERGENCY STOP	SCHNEIDER ELECTRIC	E22703-P
12	B1	SWITCH, F4-T-I-M3-16 B PRESSURE	FOX	504830
13	W1,W2,W 3,W4,W5, W6	SWITCH, AZ17-11ZRK SAFETY	SCHMERSAL	094232
14		KEY, AZ17/170-B5 SAFETY SWITCH	SCHMERSAL	094422
15	M1(+H1) M2(+H2) M3(+H3) M4(+H4) M5(+H5) M6(+H6)	MOTOR, 11kW PSg132M-4A-HM (CE)  MOTOR, 11kW LE1002-1CB63-4AA4-Z N02 (NOT CE)	INDUKTA  SIEMENS	093219  094994
16	M7	MOTOR, SKh80X-4C1 IMB14/1-162 INDUCTION	BESEL	090104
17		MOTOREDUCER, MR-80/42/1.1-1400/K4/V6	KACPEREK	099070
18	M8,M9,M1 0,M11,M1 2,M13	MOTOREDUCER, MR-40/21/0.25-1400/WJ2/B7	BESEL	099699

**TABLE 6-5**



6.10 Electrical Diagram, Control Box (Part No. 507170)



<b>Wood - Mizer Industries sp.z.o.o.</b> Ul.Nagólna 114 62-600 Koło , Poland		Rysował	Sprawdził
Produkt	Data	KK	AW
HR500/700	28/08/2013		
Nazwa	Numer rys.	Wersja	
PULPIT STERUJĄCY	507170	A	

FIG. 6-5

## 6.11 Control Box Electrical Components

Symbol	Description	Manufacturer	Wood-Mizer Part No.
<b>CBL-HMI-HR 500</b>	CABLE, MODBUS	WMI	
-	CABLE, ETHERLINE P CAT5e	LAPP KABEL	R80578-5
	CONNECTOR, RJ45W (2 PIECES)	NINIGI	512113
<b>HMI1</b>	PANEL, HMISTU855 TOUCH	SCHNEIDER ELECTRIC	508978
<b>S6</b>	SWITCH, 24V START/STOP ILLUMINATED	MOELLER	090452
	BLOCK, M22-K10 CONTACT	MOELLER	091362
	BLOCK, M22-K01 CONTACT	MOELLER	092684
	ELEMENT, M22-LED-W LED	MOELLER	-
<b>S1</b>	BUTTON, XB4 BS542 EMERGENCY STOP	SCHNEIDER ELECTRIC	086556
	CONTACT, ZBE102	SCHNEIDER ELECTRIC	086810
<b>S3</b>	SWITCH, M22 3-POSITION ILLUMINATED	MOELLER	091359
	BLOCK, M22-K10 CONTACT	MOELLER	091362
	ADAPTER, M22-XC-Y CODING	MOELLER	092687
	ELEMENT, M22-LED-G LED	MOELLER	-
<b>S2</b>	BUTTON, M22 STOP	MOELLER	090926
	BLOCK, M22-K01 CONTACT	MOELLER	092684
<b>R1</b>	RESISTOR, 1k / 0,5W	-	096228
<b>POT1</b>	POTENTIOMETER, 5K 53C35K	HONEYWELL	504389
	KNOB, SPEED CONTROL	-	P06257
<b>HR</b>	METER, HOUR	HONEYWELL	093166

**TABLE 6-6**

## SECTION 7 REPLACEMENT PARTS

### 7.1 How To Use The Parts List

- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77. The diamond (◆) indicates M06666 is not available except in subassembly K05555.

7.1 Sample Assembly				
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>SAMPLE ASSEMBLY, COMPLETE (INCLUDES ALL INDENTED PARTS BELOW)</b>	<b>A01111</b>	1	
1	Sample Part	<b>F02222-22</b>	1	
2	Sample Subassembly (Includes All Indented Parts Below)	<b>A03333</b>	1	
	Sample Part (◆ Indicates Part Is Only Available With A03333)	<b>S04444-4</b>	1	◆
3	Sample Subassembly (Includes All Indented Parts Below)	<b>K05555</b>	1	
	Sample Part (◆ Indicates Part Is Only Available With K05555)	<b>M06666</b>	2	◆
4	Sample Part	<b>F07777-77</b>	1	

#### To Order Parts:

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Kolo, Nagórna 114 St, Poland at **+48-63-2626000** or **+48-3912-1319**. From the continental U.S., call at **1-800-448-7881**. Have your customer number, vehicle identification number, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.

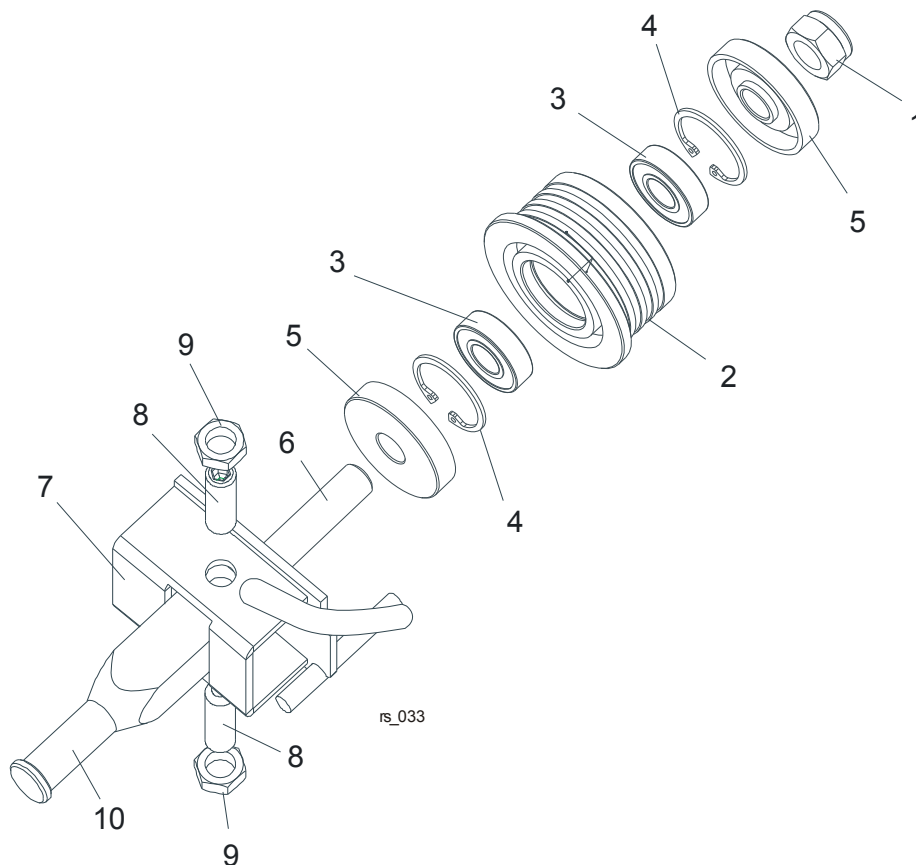


**CAUTION!** It is strongly recommended that only original spare parts be used.

# 7 REPLACEMENT PARTS

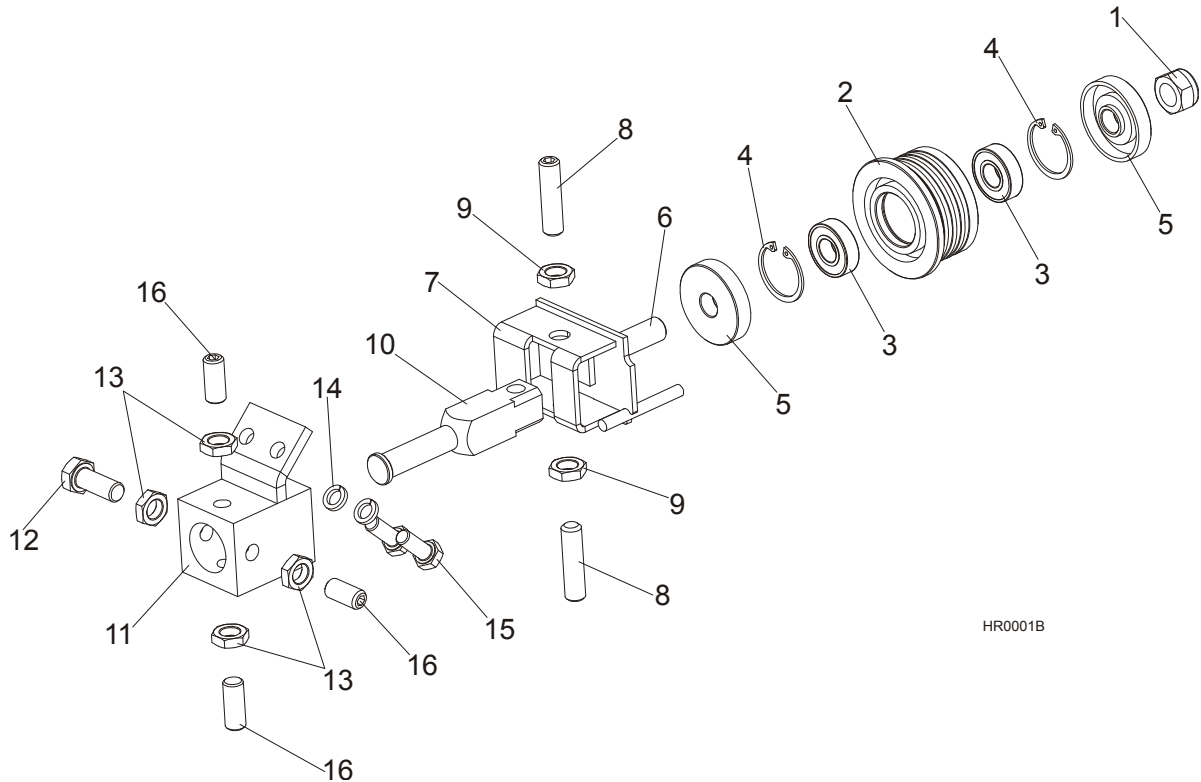
Blade Guide Assembly, Idle Side

## 7.2 Blade Guide Assembly, Idle Side



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.	
	<b>BLADE GUIDE ASSEMBLY, HR IDLE SIDE</b>	<b>500500</b>	1	
	ROLLER, HR BLADE GUIDE NARROW W/BEARINGS	500499	1	
1	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	1	◆
2	ROLLER, BLADE GUIDE NARROW	500098	1	◆
3	BEARING, 6001 2RSR NACHI	087893	2	
4	RING, W28 INSIDE RETAINING	F81090-9	2	
5	WASHER, ZINC-PLATED SPACER	087891-1	2	
6	SHAFT, BLADE GUIDE ROLLER ZINC-PLATED	087763-1	1	
7	BRACKET WELDMENT, IS BLADE GUIDE ZINC-PLATED	500497-1	1	
8	SCREW, M10X1X40 DIN913 STAINLESS STEEL SET	F81015-2	2	
9	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	2	
10	SHAFT, BLADE GUIDE MOUNT ZINC-PLATED	088255-1	1	

### 7.3 Blade Guide Assembly, Drive Side



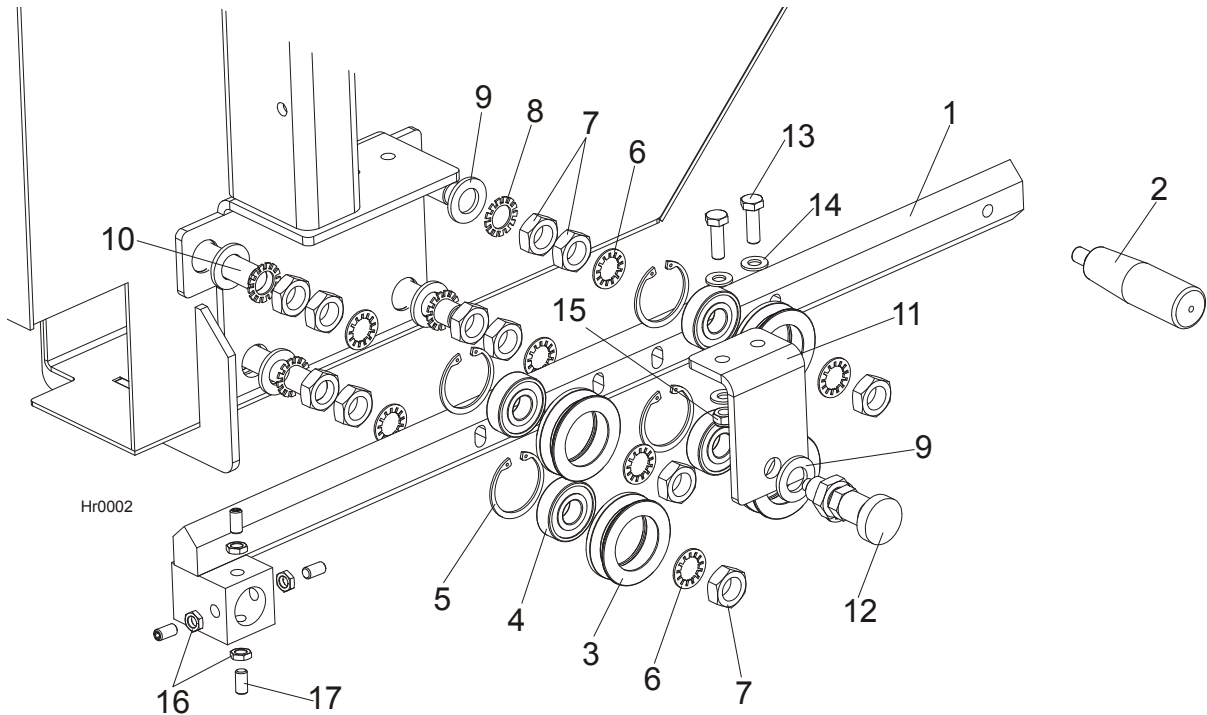
REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.	
	<b>BLADE GUIDE ASSEMBLY, HR DRIVE SIDE</b>	<b>500501</b>	1	
	ROLLER, HR BLADE GUIDE NARROW W/BEARINGS	500499	1	
1	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	1	
2	ROLLER, BLADE GUIDE NARROW	500098	1	◆
3	BEARING, 6001 2RSR NACHI	087893	2	
4	RING, W28 INSIDE RETAINING	F81090-9	2	
5	WASHER, ZINC-PLATED SPACER	087891-1	2	
6	SHAFT, BLADE GUIDE ROLLER ZINC-PLATED	087763-1	1	
7	BRACKET WELDMENT, DS BLADE GUIDE ZINC-PLATED	500498-1	1	
8	SCREW, M10X1X40 DIN913 STAINLESS STEEL SET	F81015-2	2	
9	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	2	
10	SHAFT, BLADE GUIDE MOUNT ZINC-PLATED	088255-1	1	
11	<b>BLOCK WELDMENT, BLADE GUIDE MOUNT ZINC-PLATED</b>	088292-1	1	
12	<b>BOLT, M10X1X25 DIN 933 STAINLESS STEEL</b>	F81003-28	1	
13	<b>NUT, M10X1-04-ST-A2 ISO 8675 THIN</b>	F81033-10	4	
14	<b>WASHER, 8.2 SPLIT LOCK ZINC</b>	F81054-4	2	
15	<b>BOLT, M8X20-8.8-B HEX HEAD FULL THREAD ZINC</b>	F81002-4	2	

**7****REPLACEMENT PARTS***Blade Guide Assembly, Drive Side*

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16	SCREW, M10X1X20 DIN913 STAINLESS STEEL SET	F81015-1	3	
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7.4 Blade Guide Arm Assembly

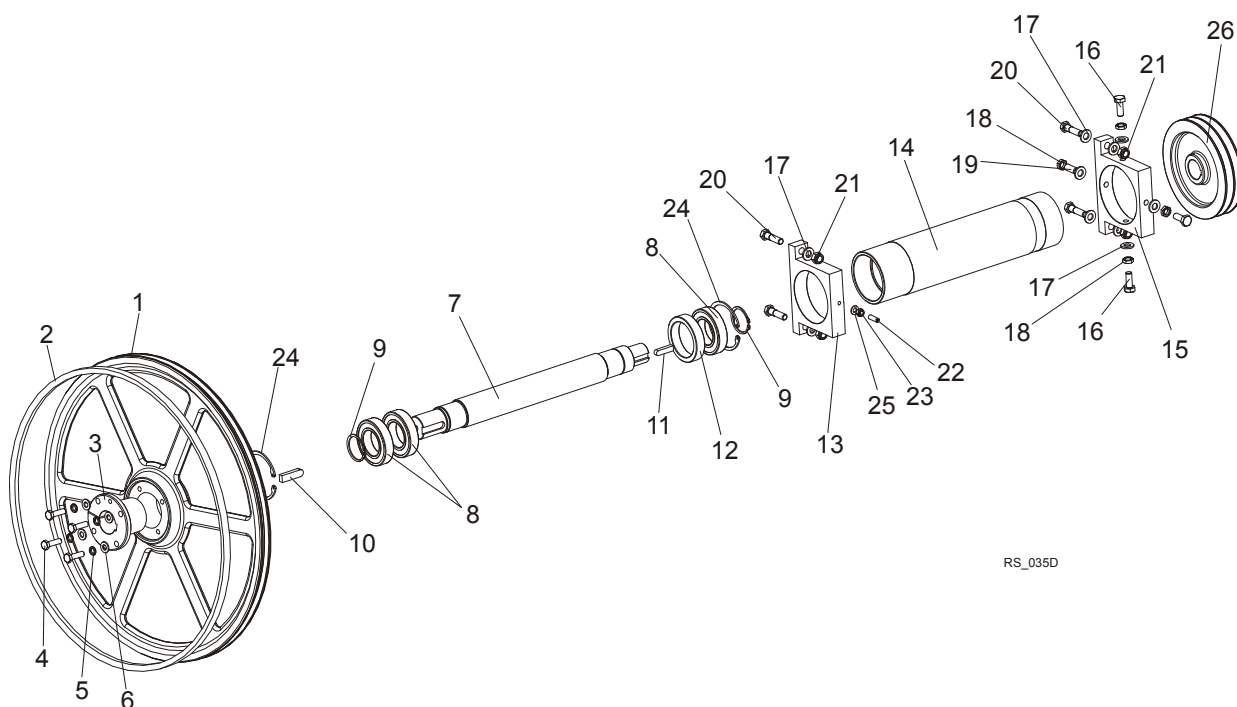


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	ARM, ADJUSTABLE ZINC-PLATED BLADE GUIDE	099075-1	1
2	HANDLE, PLASTIC	086338	1
	ROLLER ASSEMBLY, V-GROOVE W/BEARING	093855	4
3	ROLLER, V-GROOVE ZINC-PLATED	093856-1	1
4	BEARING, 6203 2RSP6-5/8 CX	095087	1
5	RING, W40 INSIDE RETAINING	F81090-3	1
6	WASHER, 5/8" INTERNAL STAR	F05011-25	8
7	NUT, 5/8"-18 HEX ZINC	F05010-11	12
8	WASHER, 5/8" EXTERNAL STAR	F05011-26	4
9	WASHER, 17 FLAT ZINC	F81058-1	5
10	BOLT WELDMENT, ECCENTRIC	086508-1	4
11	BRACKET, DETENT PIN MOUNT	099077-1	1
12	PIN, 45308DNW DETENT	089939	1
13	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
14	WASHER, 8.4 FLAT ZINC	F81054-1	4
15	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
16	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	4
17	SCREW, M10X1X20 DIN913 STAINLESS STEEL SET	F81015-1	4

# 7 REPLACEMENT PARTS

## Blade Wheel Assembly, Drive Side

### 7.5 Blade Wheel Assembly, Drive Side



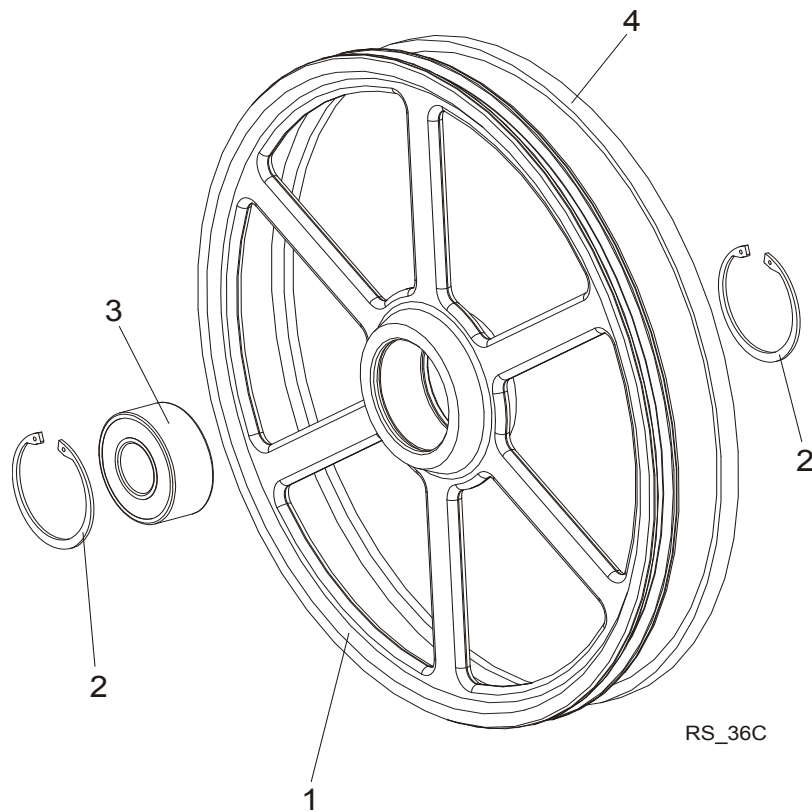
RS\_035D

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	WHEEL, RESAW BLADE DRIVE SIDE	500100-1	1	
2	V-BELT, B72.5	017922	1	
3	BUSHING, 45 SPLIT TAPER	500099	1	
4	BOLT, M10X35 8.8 HEX HEAD FULL THREAD	F81003-17	4	
5	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	4	
6	WASHER, 10.5 FLAT ZINC	F81055-1	4	
	<b>SHAFT ASSEMBLY, RESAW DRIVE-SIDE BLADE WHEEL</b>	093239	1	
7	Shaft, Resaw Drive-Side Blade Wheel	093238	1	
8	Bearing, 6210 2RSR	093237	3	
9	Ring, Z50 Outside Retaining	F81090-28	2	
10	Key, AB 14x9x50 Parallel	093266	1	
11	Key, AB 10x8x40 Parallel	091990	1	
12	Bushing, Main Shaft Spacer	094439	1	
13	Bracket, Drive Shaft Adjustment Zinc-Plated	093255-1	1	
14	Bushing, Drive Shaft Housing	093234-1	1	
15	Bracket, Drive Shaft Bushing Mount Zinc-Plated	094535-1	1	
16	Bolt, M12x1.25x30 DIN933 A2-70 Stainless Steel	F81004-44	3	
17	Washer, 13 Fe/Zn5 Flat Zinc	F81056-1	4	
18	Nut, M12x1.25 DIN439 Thin Stainless Steel	F81034-9	4	
19	Screw, M12x1.25x30 DIN913 Stainless Steel Set	F81016-1	1	
20	Bolt, M12x45-8.8 Hex Head Zinc	F81004-32	4	



21	Nut, M12-8 Hex Nylon Zinc Lock	F81034-2	4	
22	Screw, M8x25 A2-70 DIN 913 Stainless Steel Set	F81014-3	1	
23	Nut, M8-8-B Hex Nylon Zinc Lock	F81032-2	1	
24	Ring, W90 Inside Retaining	F81090-29	2	
25	Washer, 8.4 Flat Zinc	F81054-1	1	
26	<b>PULLEY, SPB <math>\Phi</math>224X2/<math>\Phi</math>38 (F02312+T31124)</b>	500177	1	
	<b>PULLEY, SPB <math>\Phi</math>190X2/<math>\Phi</math>38 (F02347+T31124)</b>	500569	1	

## 7.6 Blade Wheel Assembly, Idle Side

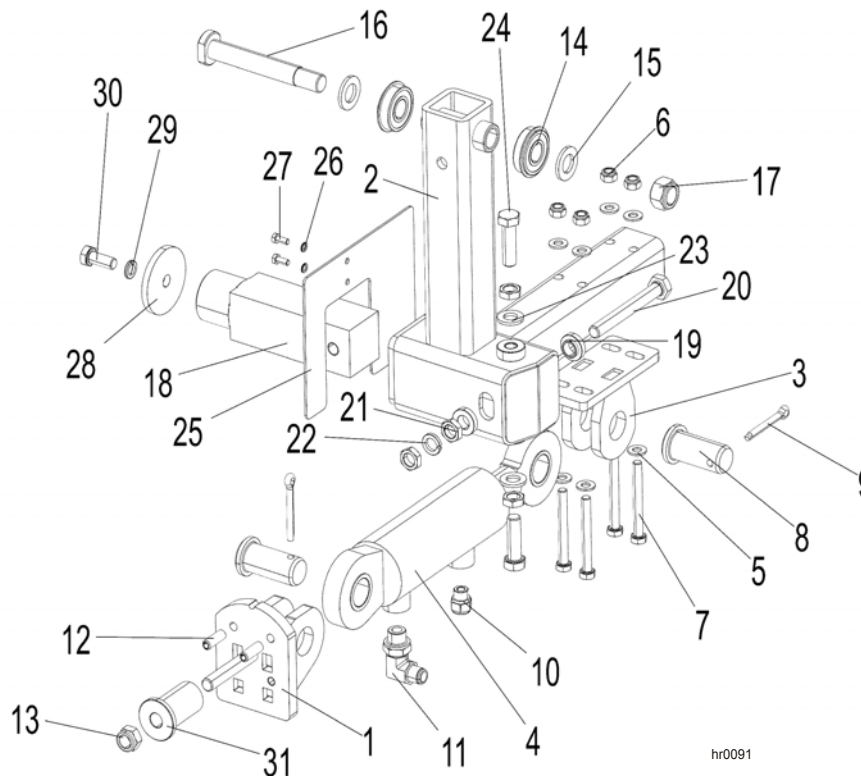


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>WHEEL, IDLE-SIDE BLADE - COMPLETE</b>	<b>088764</b>	1	
1	Wheel, Idle-Side Blade	090810	1	
2	Ring, W100 Inside Retaining	F81090-10	2	
3	Bearing, 3309B.2RSR.TVH FAG	086428	1	
4	<b>V-BELT, B72.5</b>	017922	1	

# 7 REPLACEMENT PARTS

## Hydraulic Blade Tensioner Assembly

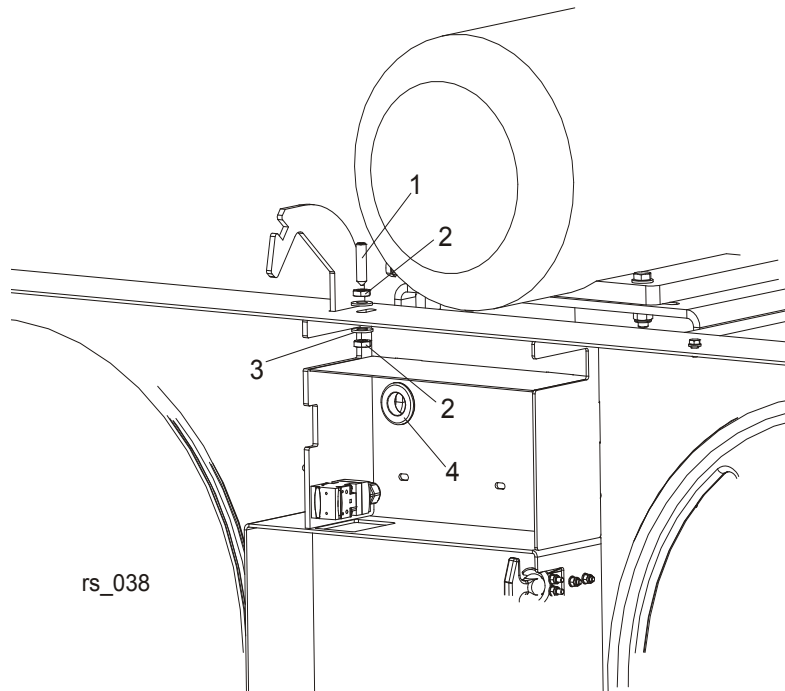
### 7.7 Hydraulic Blade Tensioner Assembly



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART#	QTY.
	<b>HR/SHS HYDRAULIC BLADE TENSIONER - COMPLETE</b>	<b>506750</b>	<b>1</b>
1	BRACKET, PISTON CYLINDER MOUNT	506751-1	1
2	ARM WELDMENT, TVS IDLE BLADE WHEEL (RIGHT-SIDE SAW HEAD)	504817-1	1
3	BRACKET, PISTON CYLINDER UPPER MOUNT	504819-1	1
4	CYLINDER, SJ2F-16-50/28/70 PISTON	504812	1
5	WASHER, 8.4 FLAT ZINC	F81054-1	8
6	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4
7	BOLT, M8x70-8.8 HEX HEAD ZINC	F81002-71	4
8	PIN	504824-1	2
9	PIN, S-Zn-6.3x45 COTTER	F81045-2	2
10	SILENCER, TYPE 2901-14-17	090794	1
11	FITTING, 90\$ - 3/8 BSP - 9/16 JIC ELBOW	096335	1
12	PIN, 8x26 ROLL ZINC	F81046-4	2
13	NUT, M12 8 HEX NYLON ZINC LOCK	F81034-2	1
14	BEARING, 6203-2RS NR. W/SNAP RING	086395	2
15	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
16	BOLT, ARM BEARING MOUNT	086404	1
17	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1
18	SHAFT, IDLE-SIDE BLADE WHEEL	088474	1
19	WASHER, FLANGED ZINC-PLATED	086769-1	2
20	BOLT, M12x1.25x100-8.8 HEX HEAD FULL THREAD ZINC	F81004-41	1

21	NUT, M12X1.25-8 THIN ZINC	F81034-5	4	
22	WASHER, Z12.2 SPLIT LOCK ZINC	F81056-2	1	
23	WASHER, 13 FLAT ZINC	F81056-1	2	
24	BOLT, M12x1.25x40-8.8 HEX HEAD FULL THREAD ZINC	F81004-42	2	
25	GUARD, IDLE BLADE WHEEL ARM	088442-1	1	
26	WASHER, 5.1 SPLIT LOCK ZINC	F81052-2	2	
27	BOLT, M5X12 5.8 HEX HEAD FULL THREAD ZINC	F81000-5	2	
28	WASHER, IDLE BLADE WHEEL RETAINING	088957-1	1	
29	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	1	
30	BOLT, M10X25 8.8 HEX HEAD FULL THREAD	F81003-31	1	
31	BUSHING, 28.5 TO 13 REDUCER ZINC-PLATED	508708-1	1	

**7.8 Middle Throat Screw**

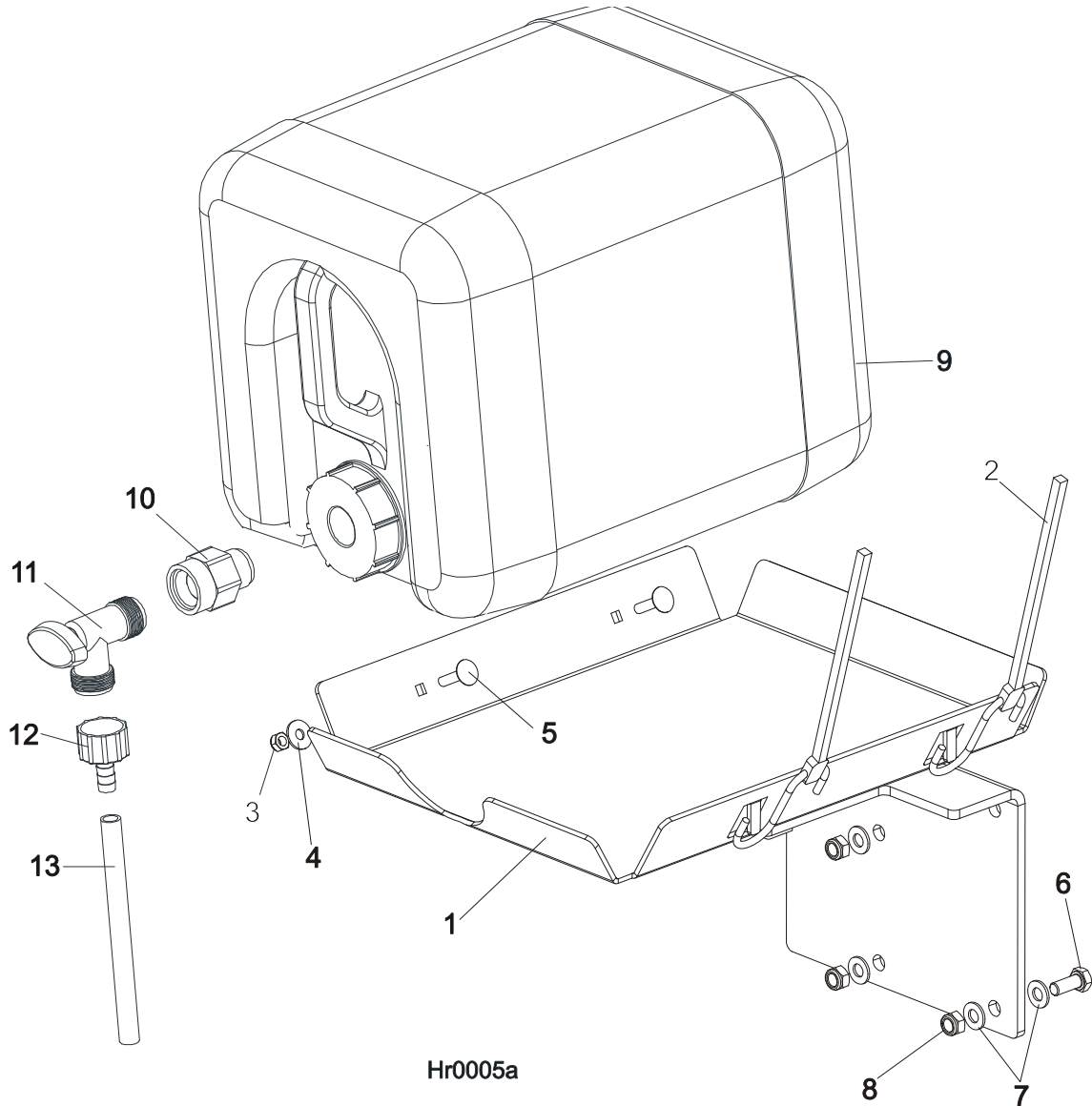


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	SCREW, M10X40-45H HEX SOCKET SET CONE POINT ZINC	F81003-61	1	
2	NUT, M10-8-B HEX ZINC	F81033-6	2	
3	WASHER, 10.5 FLAT ZINC	F81055-1	2	
4	GROMMET, 22 MM DIA. RUBBER	087400	1	

# 7 REPLACEMENT PARTS

## Water Bottle Assembly (Option)

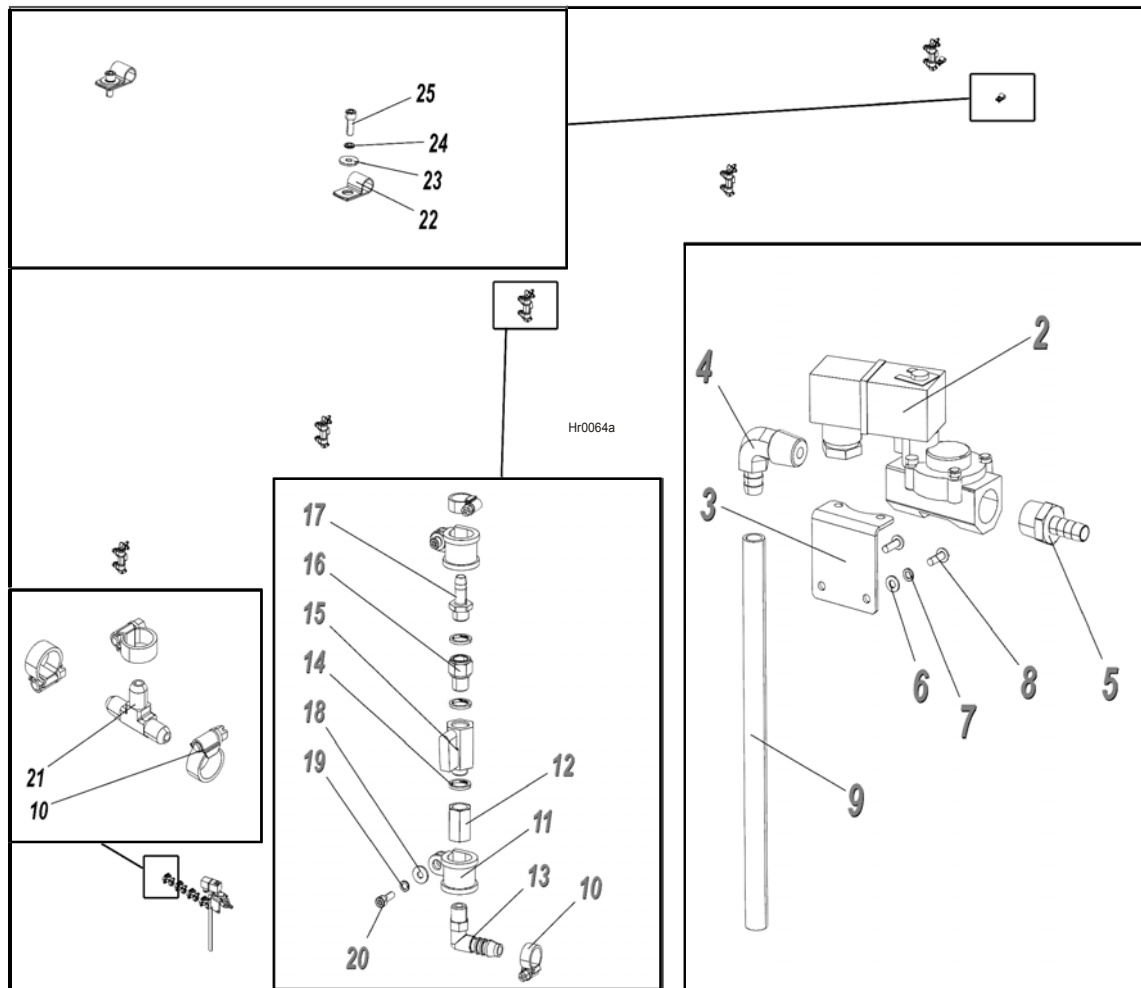
### 7.9 Water Bottle Assembly (Option)



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>BOTTLE KIT, WATER LUBE - COMPLETE</b>	091036	1
1	Tray Weldment, Water Bottle	091033-1	1
2	Strap, 20" Rubber w/Hook	P11668	2
3	Nut, M6-8-B Hex Nylon Zinc Lock	F81031-2	2
4	Washer, 6.5 Special Flat Zinc	F81053-11	2
5	Bolt, M6x25-8.8 Mushroom Head Square Neck Zinc	F81001-20	2
6	Bolt, M8x20-5.8 Hex Head Full Thread Zinc	F81002-1	3
7	Washer, 8.4 Flat Zinc	F81054-1	6
8	Nut, M8-8-B Hex Nylon Zinc Lock	F81032-2	3
9	Bottle, 5-Gallon Water	014637	1
10	Fitting, 3/4FPT x 3/4MPT	014636	1

11	Valve, 3/4 NPT Elbow 3/4 Male Outlet PCV	014100	1	
12	Reducer, 5/8 NPT/3/8 Barb Water Lube	014113	1	
13	Tubing, Water Lube	R01885	2.1 m	

### 7.10 Blade Lube System



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.
	<b>KIT, HR500 BLADE LUBE SYSTEM - 1 HEAD</b>	502688-1	1 / 0 / 0 / 0 / 0 / 0
	<b>KIT, HR500 BLADE LUBE SYSTEM - 2 HEADS</b>	502688-2	0 / 1 / 0 / 0 / 0 / 0
	<b>KIT, HR500 BLADE LUBE SYSTEM - 3 HEADS</b>	502688-3	0 / 0 / 1 / 0 / 0 / 0
	<b>KIT, HR500 BLADE LUBE SYSTEM - 4 HEADS</b>	502688-4	0 / 0 / 0 / 1 / 0 / 0
	<b>KIT, HR500 BLADE LUBE SYSTEM - 5 HEADS</b>	502688-5	0 / 0 / 0 / 0 / 1 / 0
	<b>KIT, HR500 BLADE LUBE SYSTEM - 6 HEADS</b>	502688-6	0 / 0 / 0 / 0 / 0 / 1
<b>1</b>	<b>VALVE, BLADE LUBE SYSTEM SOLENOID - COMPLETE</b>	<b>509702</b>	<b>1 / 1 / 1 / 1 / 1 / 1</b>
<b>2</b>	VALVE, ASCO SCE238A002 24V DC SOLENOID	510270	1
<b>3</b>	BRACKET, SOLENOID VALVE ZINC-PLATED	092870-1	1
<b>4</b>	FITTING, 1/2"NPT-3/8" BARB ELBOW	P12707	1

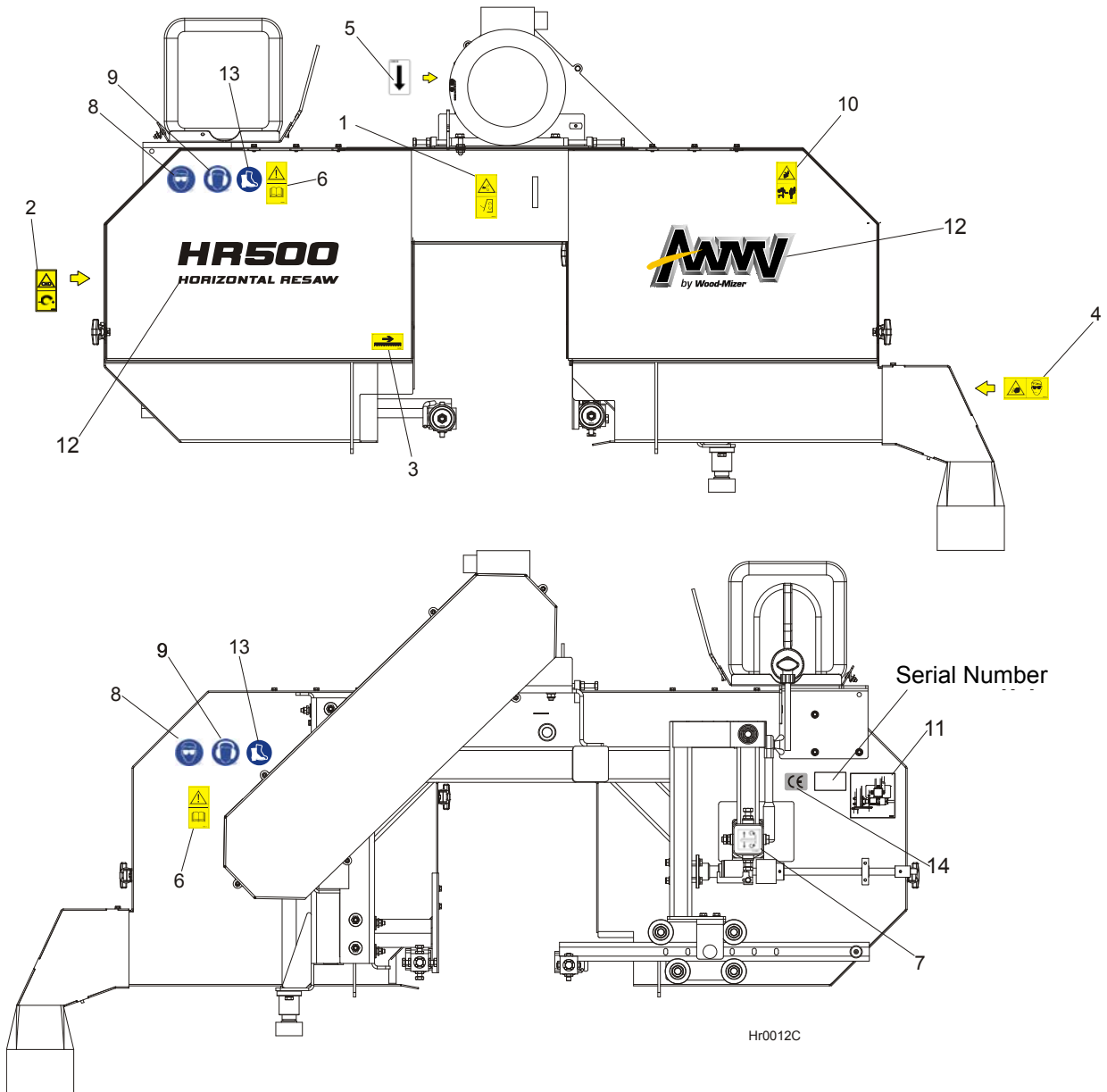
# 7

## REPLACEMENT PARTS

### Blade Lube System

5	FITTING, 1/2" HOSE	092356	1	
6	WASHER, 4.3 FLAT ZINC	F81051-2	2	
7	WASHER, Z 4.1 SPLIT LOCK ZINC	F81051-1	2	
8	SCREW, M4X12-5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-43	2	
9	TUBING, 3/8" - 1 HEAD	509704	1 / 0 / 0 / 0 / 0 / 0	
	TUBING, 3/8" - 2 HEADS	509705	0 / 1 / 0 / 0 / 0 / 0	
	TUBING, 3/8" - 3 HEADS	509706	0 / 0 / 1 / 0 / 0 / 0	
	TUBING, 3/8" - 4 HEADS	509707	0 / 0 / 0 / 1 / 0 / 0	
	TUBING, 3/8" - 5 HEADS	509708	0 / 0 / 0 / 0 / 1 / 0	
	TUBING, 3/8" - 6 HEADS	509709	0 / 0 / 0 / 0 / 0 / 1	
10	CLAMP, 12-20MM DIA. HOSE	F81080-3	3 / 8 / 13 / 18 / 23 / 28	
11	CLAMP, RSGU 1.20/20 W1 METAL-RUBBER	F81087-2	2 / 4 / 6 / 8 / 10 / 12	
12	SLEEVE, G1/4W/G1/4W 1823300001	090808	1 / 2 / 3 / 4 / 5 / 6	
13	FITTING, WES 10/R 1/4 ELBOW	088379	1 / 2 / 3 / 4 / 5 / 6	
14	SEAL, G1/4 866-014-000-0	090809	3 / 6 / 9 / 12 / 15 / 18	
15	VALVE, FP60.KIT 28 G1/4	088380	1 / 2 / 3 / 4 / 5 / 6	
16	ADAPTER, 2521 1/4-1/4 (CAMOZZI)	097704	1 / 2 / 3 / 4 / 5 / 6	
17	BUSHING, GT13/09 NR 13539	092783	1 / 2 / 3 / 4 / 5 / 6	
18	WASHER, 5.5 SPECIAL FLAT ZINC	F81052-3	2 / 4 / 6 / 8 / 10 / 12	
19	WASHER, 5.1 SPLIT LOCK	F81052-2	2 / 4 / 6 / 8 / 10 / 12	
20	SCREW, M5X16-8.8 HEX SOCKET HEAD CAP ZINC-PL.	F81000-25	2 / 4 / 6 / 8 / 10 / 12	
21	FITTING, 3/8 BARB TEE	015485	0 / 1 / 2 / 3 / 4 / 5	
22	CLAMP, 1/2" EMT COATED	P07584	2 / 0 / 2 / 0 / 2 / 0	
23	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	2 / 0 / 2 / 0 / 2 / 0	
24	WASHER, Z 6.1 SPLIT LOCK	F81053-3	2 / 0 / 2 / 0 / 2 / 0	
25	SCREW, M6X16 8.8 HEX SOCKET HEAD CAP ZINC	F81001-21	2 / 0 / 2 / 0 / 2 / 0	

7.11 HR Saw Head Warning Decals



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>DECAL KIT FOR HR1</b>	099821	1
1	DECAL, SAWMILL COVERS CAUTION	099220	1
2	DECAL, BLADE TENSION (PICTOGRAM)	099219	1
3	DECAL, BLADE MOVEMENT DIRECTION (PICTOGRAM)	096321	1
4	DECAL, SAWDUST CHUTE WARNING (PICTOGRAM)	099222	1
5	DECAL, MOTOR ROTATION DIRECTION	S20097	1
6	DECAL, READ THE OPERATOR'S MANUAL (PICTOGRAM)	096317	2
7	DECAL, BLADE ALIGNMENT	P11789	1
8	DECAL, EYE PROTECTION WARNING (PICTOGRAM)	S12004G	2

## 7

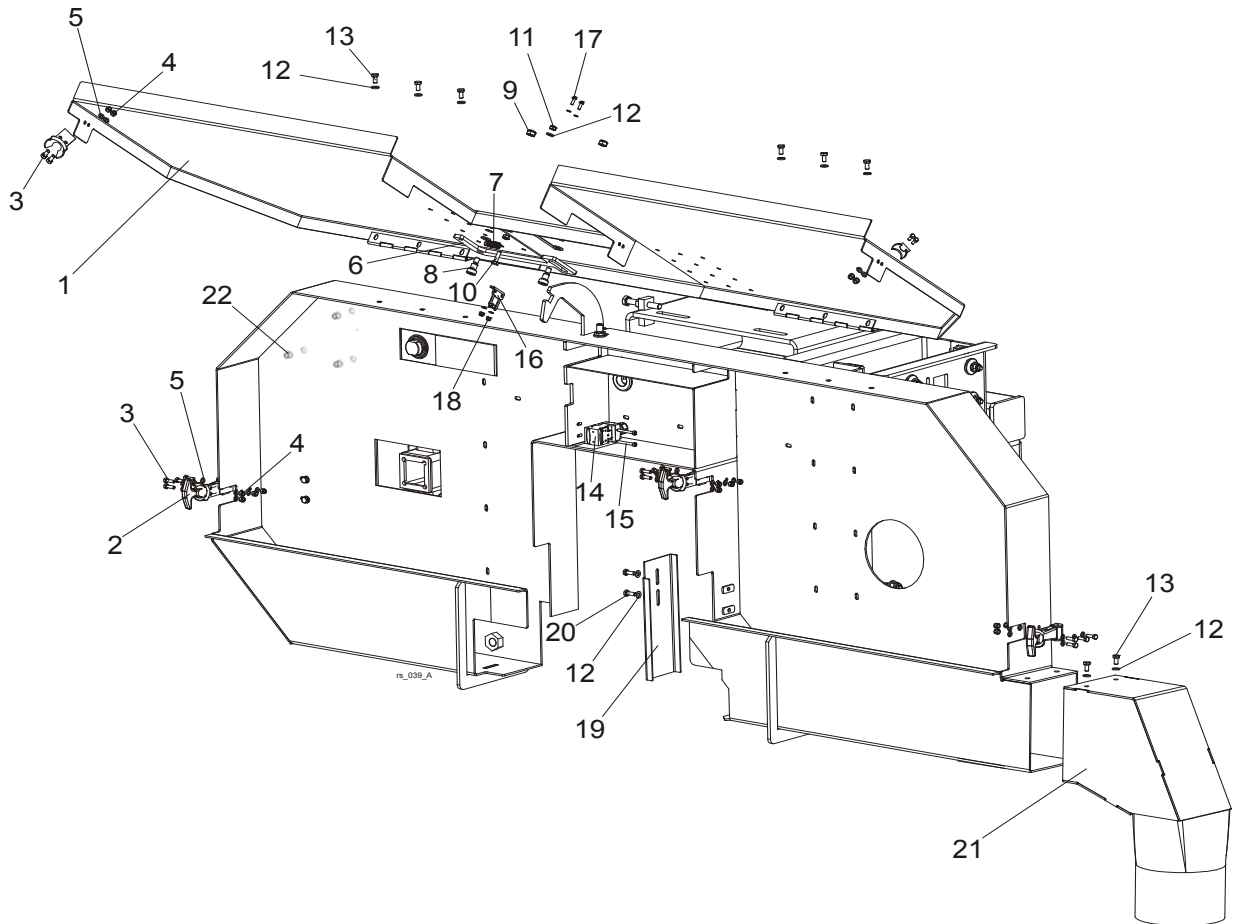
## REPLACEMENT PARTS

### HR Saw Head Warning Decals

9	DECAL, EAR PROTECTION WARNING (PICTOGRAM)	S12005G	2	
10	DECAL, KEEP A SAFE DISTANCE AWAY (PICTOGRAM)	099221	1	
11	DECAL, BLADE TENSION INDICATOR ADJUSTMENT (PICTOGRAM)	092597	1	
12	DECAL KIT, "HR" MACHINE NAME	099585	1	
13	DECAL, USE SAFETY BOOTS (PICTOGRAM)	501465	2	
14	DECAL, CE CERTIFIED SAWMILL (SMALL)	P85070	1	
	<b>DECAL KIT FOR HR2</b>	099822	1	
	DECAL KIT FOR HR1	099821	2	
	<b>DECAL KIT FOR HR3</b>	099823	1	
	DECAL KIT FOR HR1	099821	3	
	<b>DECAL KIT FOR HR4</b>	099824	1	
	DECAL KIT FOR HR1	099821	4	
	<b>DECAL KIT FOR HR5</b>	099825	1	
	DECAL KIT FOR HR1	099821	5	
	<b>DECAL KIT FOR HR6</b>	099826	1	
	DECAL KIT FOR HR1	099821	6	



## 7.12 Blade Housing Cover



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.
1	COVER WELDMENT, RESAW BLADE HOUSING	093251-1	1
2	LATCH, FLEXIBLE DRAW	014829	3
3	BOLT, M5X16-5.8 HEX HEAD FULL THREAD ZINC	F81000-51	12
4	NUT, M5-8-FE/ZN5 DIN 985	F81030-2	12
5	WASHER, 5.3 FLAT ZINC	F81052-1	24
6	PAWL, LOCKING	090643-1	1
7	SPRING, 1.6X12X38 EXTENSION	092208	1
8	BOLT, 10/M8X12-12.9 ISO-7379 SHOULDER	F81003-62	2
9	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
10	BOLT, M6X20-8.8 HEX HEAD FULL THREAD ZINC	F81001-2	1
11	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2
12	WASHER, 6.4 FLAT ZINC	F81053-1	12
13	BOLT, M6X12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	8
14	SWITCH, AZ17-11ZRK SAFETY	094232	1
15	SCREW, M4X35 -8.8 HEX SOCKET HEAD CAP ZINC	F81011-34	2
16	KEY, AZ17/170-B5 SAFETY SWITCH	094422	1
17	SCREW, M4X12-5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-43	2

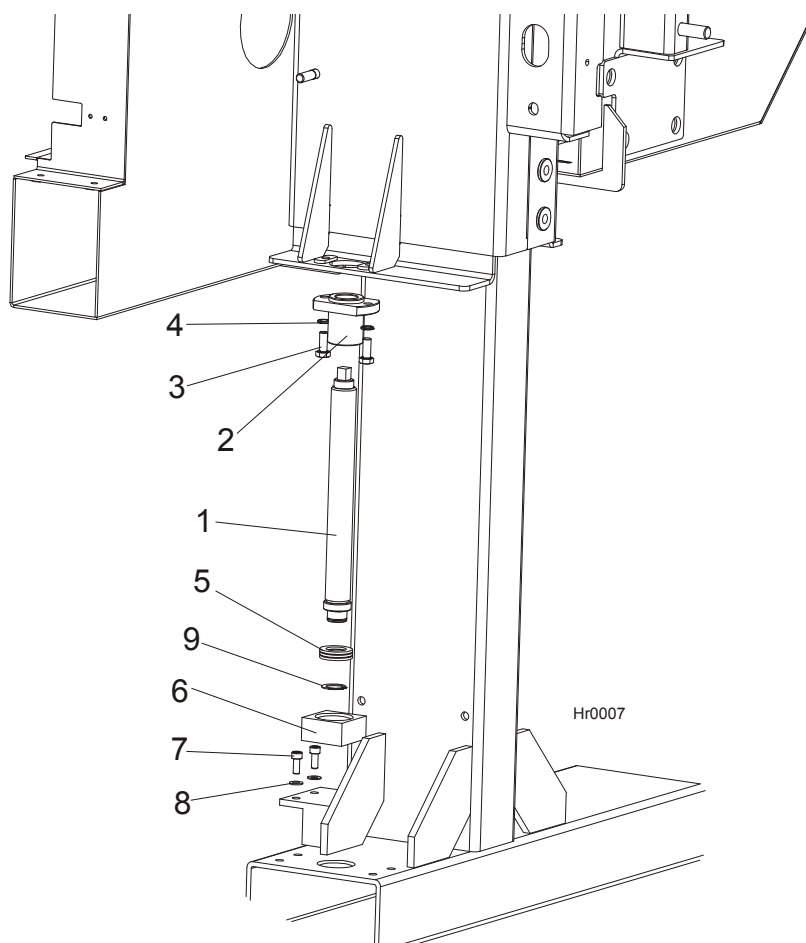
# 7

## REPLACEMENT PARTS

### Saw Head Height Adjustment Screw

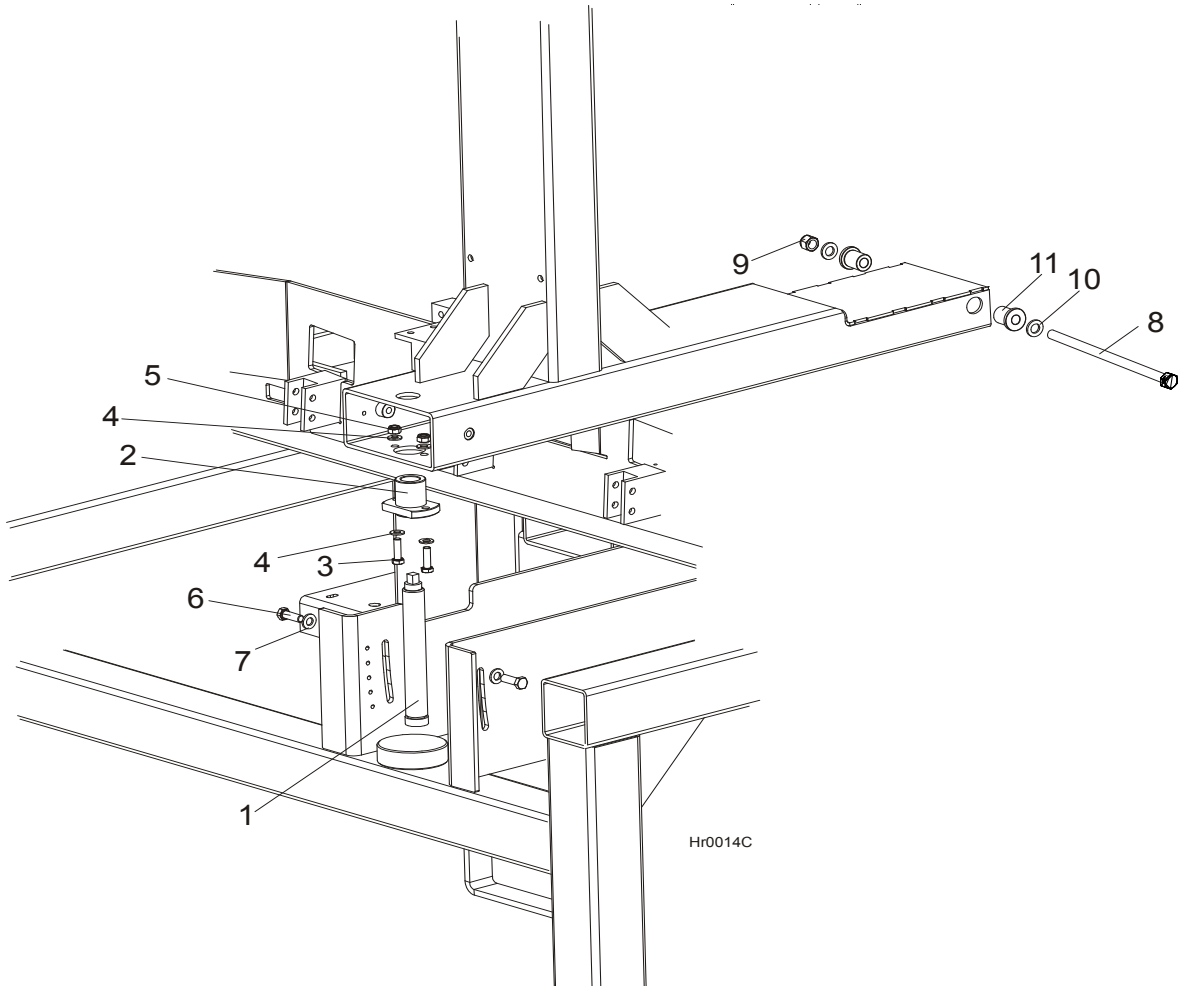
18	NUT, M4-B HEX NYLON ZINC LOCK	F81029-1	2	
19	GUARD, BLADE GUIDE ROLLER	094737-1	1	
20	BOLT, M6X16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	2	
21	CHUTE, RESAW SAWDUST	094059-1	1	
22	PLUG, SR1086-9.5	096846	3	

### 7.13 Saw Head Height Adjustment Screw



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	SCREW, ACME ZINC-PLATED (SAW HEAD HEIGHT ADJUSTMENT)	093263-1	1	
2	NUT, ACME SCREW FLANGED ZINC-PLATED	093264-1	1	
3	BOLT, M10X25 8.8 HEX HEAD FULL THREAD	F81003-31	2	
4	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	2	
5	BEARING, 51105 THRUST	088033	1	
6	BLOCK, ACME SCREW REST ZINC-PLATED	093265-1	1	
7	SCREW, M8X20-8.8 HEX SOCKET SET CAP ZINC	F81002-30	2	
8	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
9	RING, 25Z OUTSIDE RETAINING	F81090-22	1	

**7.14 Mast Tilt Adjustment Screw**

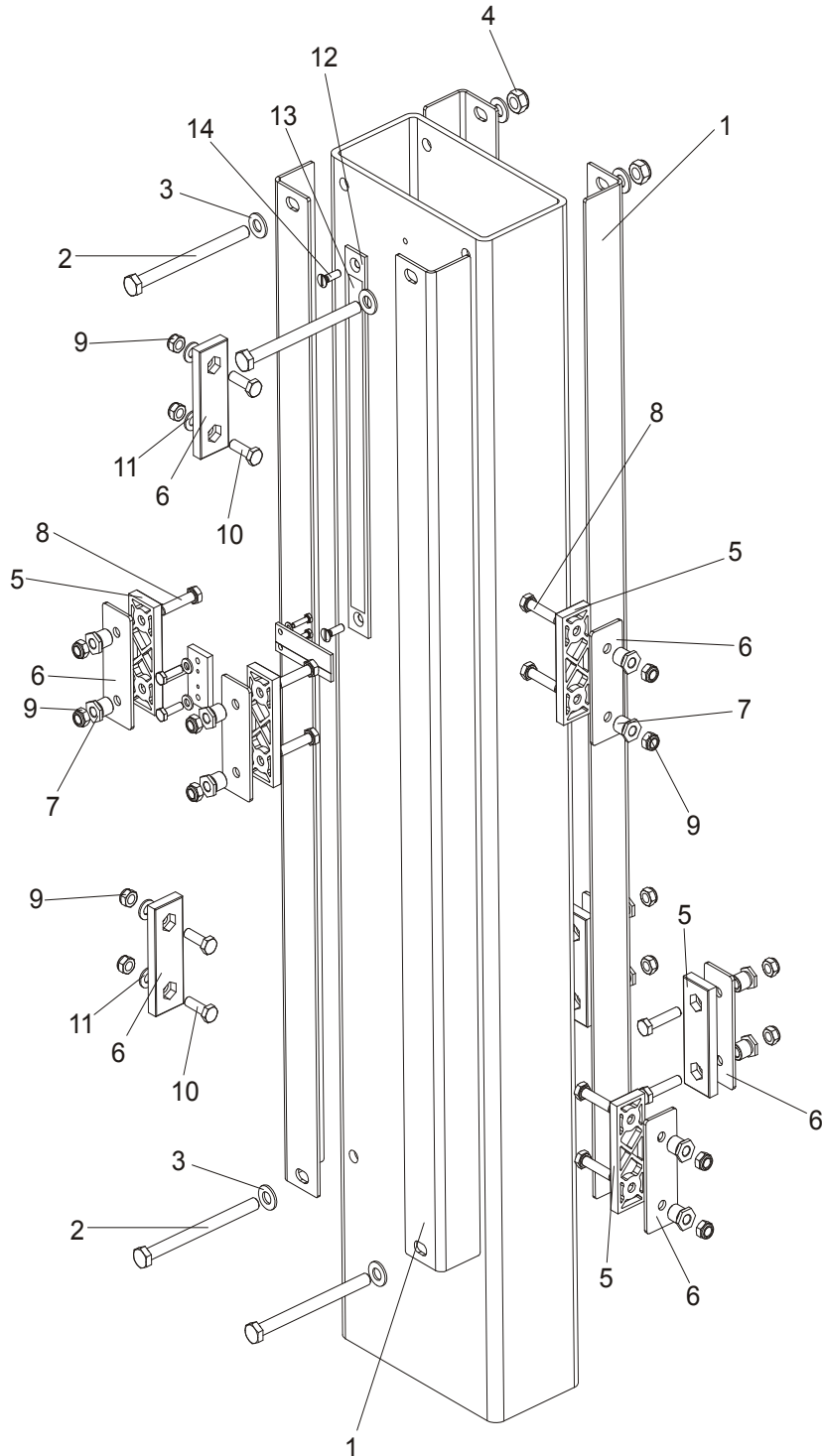


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	SCREW, MAST TILT ADJUSTMENT ACME	093509-1	1
2	NUT, ACME SCREW FLANGED ZINC-PLATED	093264-1	1
3	BOLT, M10X35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2
4	WASHER, 10.5 FLAT ZINC	F81055-1	4
5	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2
6	BOLT, M12X35-8.8 HEX HEAD FULL THREAD ZINC	F81004-24	2
7	WASHER, 13 FLAT ZINC	F81056-1	2
8	BOLT, ISO 4014 M16X260-8.8-A2E HEX HEAD	F81006-47	1
9	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
10	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
11	BUSHING, MOUNTING	093507	2

# 7 REPLACEMENT PARTS

## Vertical Mast Slide Pads

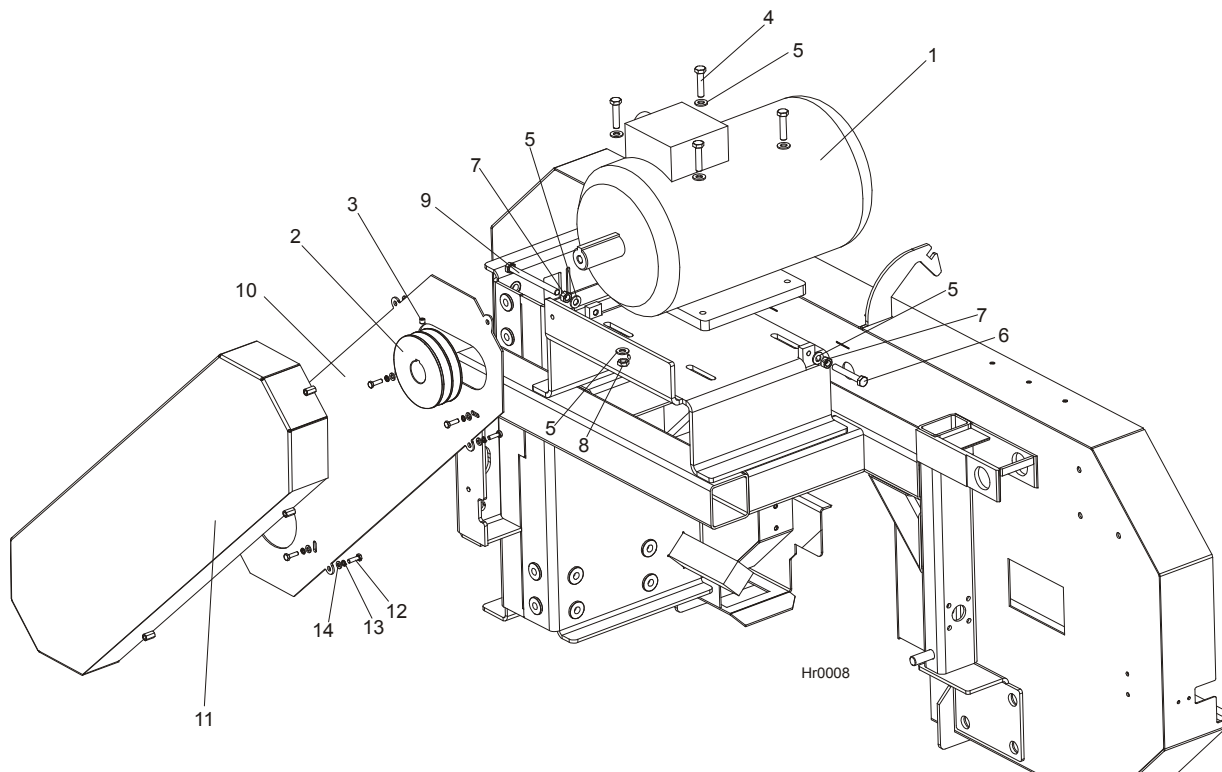
### 7.15 Vertical Mast Slide Pads



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	ANGLE, VERTICAL MAST TUBE	093890	4
2	BOLT, M10X125-8.8 HEX HEAD ZINC	F81003-18	4
3	WASHER, 10.5 FLAT ZINC	F81055-1	8

4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
5	PAD, DELRIN UP/DOWN SLIDE	M04096	8	
6	PLATE, SLIDE PAD MOUNTING	093246-1	6	
7	NUT, SLIDE PAD ADJUSTMENT ZINC-PLATED	086683-1	12	
8	BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC	F81002-13	12	
9	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	16	
10	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
11	WASHER, 8.4 FLAT ZINC	F81054-1	4	
	SCALE, RESAW BLADE HEIGHT-COMLETE	094820	1	
12	Bar, Resaw Blade Height Scale	094818	1	
13	Scale, 0-30 cm Resaw Metric	094819	1	
14	SCREW, M5X12- 5.8-B SLOTTED COUNTERSUNK HEAD ZINC	F81000-15	2	

### 7.16 Motor Assembly



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	MOTOR, 7.5kW Sg132M-4B - HM	094996	1
	MOTOR, 11kW Sg132M-4PC - HM	093219	1
2	PULLEY, SPB $\Phi 100X2/\Phi 38$ (F02312+T31079)	500176 <sup>1</sup>	1
	PULLEY, SPB $\Phi 125X2/\Phi 38$ (F02320+F31109)	500570 <sup>2</sup>	1
3	SCREW, M8X8-33H HEX SOCKET FLAT POINT ZINC SET	F81014-1	1
4	BOLT, M10X45-8.8 HEX HEAD FULL THREAD ZINC	F81003-3	4
5	WASHER, 10.5 FLAT ZINC	F81055-1	10
6	BOLT, M10X70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	1

# 7

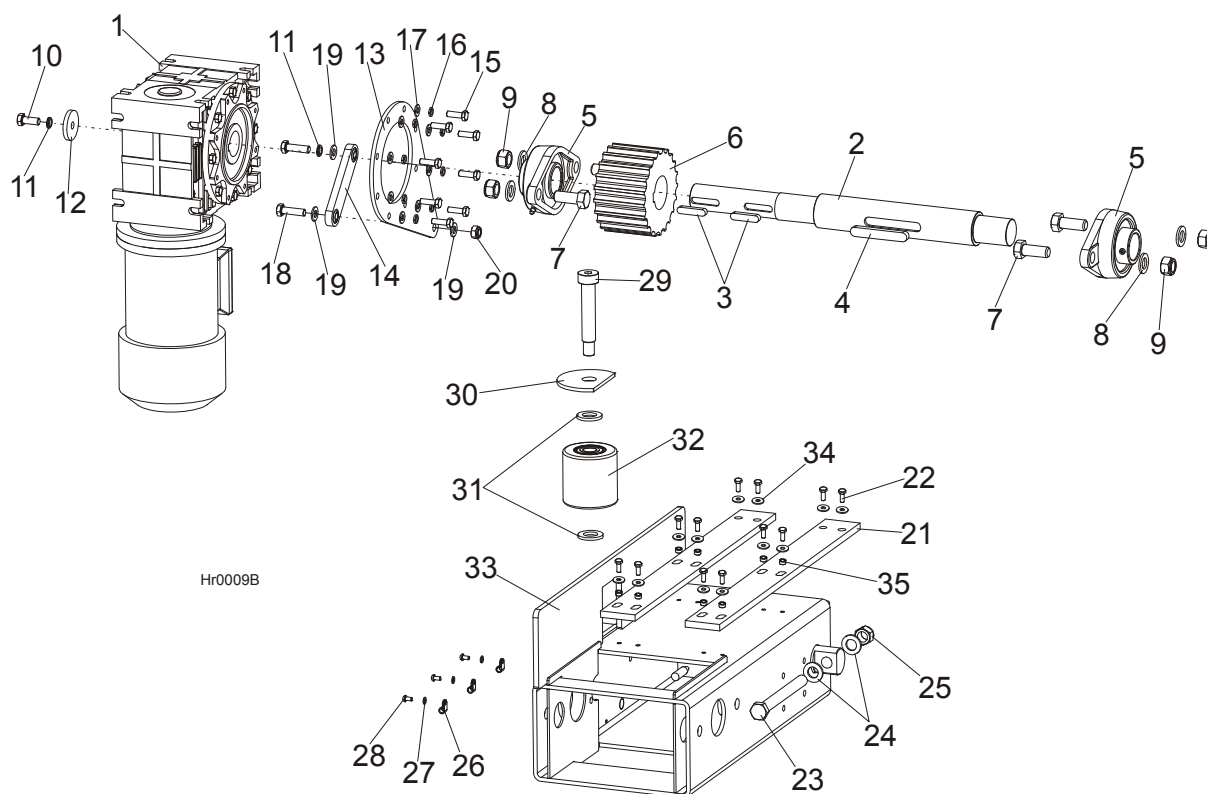
## REPLACEMENT PARTS Feed Chain Drive & Tensioner

7	NUT, M10-8-B HEX ZINC	F81033-3	2	
8	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
9	BOLT, M10X120 8.8 HEX HEAD FULL THREAD ZINC	F81003-47	1	
10	COVER, DRIVE BELT GUARD PAINTED	093259-1	1	
11	GUARD WELDMENT, RESAW DRIVE BELT PAINTED	093262-1	1	
12	BOLT, M6X20-8.8 HEX HEAD FULL THREAD ZINC	F81001-2	10	
13	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	10	
14	WASHER, 6.4 FLAT ZINC	F81053-1	10	
	BELT, 2BXF71 MOTOR DRIVE	036163	1	
	BELT, 2BX70 11kW MOTOR DRIVE (E15)	P04857-2	1	

<sup>1</sup> Pulley #500176 with pulley # 500177 and belt # 036163 are standard equipment and allow the user to reach a blade linear speed of 20.5 m/s. To reach a blade linear speed of 24.2 m/s, use pulley # 500569 with belt # P04857-2 instead of pulley #500177.

<sup>2</sup> Pulley #500570 with pulley #500569 allow the user to reach a blade linear speed of 30.3 m/s. Use drive belt #P04857-2.

### 7.17 Feed Chain Drive & Tensioner



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>DRIVE ASSEMBLY, HR FEED CHAIN</b>	099377	1	
	DRIVE ASSEMBLY, HR PLATE LINK CHAIN	099069	1	
1	MOTOREDUCER, MR-80/42/1.1-1400/K4/V6	099070	1	
	MOTOR, 1.1kW 1400 r.p.m.	086530	1	
2	SHAFT, HR CHAIN DRIVE ZINC-PLATED	099335-1	1	
3	KEY, A10x8x45 PARALLEL	091312	2	
4	KEY, A14X9X90 PARALLEL	099424	1	

# REPLACEMENT PARTS

*Feed Chain Drive & Tensioner*

# 7

5	BEARING, UCFL208 W/HOUSING	099423	2	
6	SPROCKET, KZN800/21-40 A=80,B=40	099079	1	
7	BOLT, M16x40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4	
8	WASHER, 17 FLAT ZINC	F81058-1	4	
9	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4	
10	BOLT, M10x25-8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1	
11	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	2	
12	WASHER, LT15 DRIVE WHEEL ZINC-PLATED	086286-1	1	
13	PLATE, RA80 MOTOREDUCER SUPPORT	099425-1	1	
14	LINK, SBPL 10104 PIVOTAL	097700	1	
15	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	8	
16	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	8	
17	WASHER, 8.4 FLAT ZINC	F81054-1	8	
18	BOLT, M10x35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2	
19	WASHER, 10.5 FLAT ZINC	F81055-1	2	
20	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	1	
21	PAD, FEED TRACK (MEDIUM)	099376	2	
22	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	12	
23	BOLT, M16x160-8.8 HEX HEAD ZINC	F81006-20	2	
24	WASHER, 17 FLAT ZINC	F81058-1	4	
25	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2	
26	CLAMP, RSGU 1.10/12 W1 METAL & RUBBER	086861	3	
27	WASHER, 5.3 FLAT ZINC	F81052-1	3	
28	SCREW, H M5x10 8.8 CROSS RECESSED PAN HEAD ZINC	F81000-13	3	
29	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30 <sup>1</sup>	1	
30	PLATE, GUIDE ROLLER COVER ZINC-PLATED	099441-1 <sup>1</sup>	1	
31	WASHER, 21 FLAT ZINC	F81059-2 <sup>1</sup>	2	
32	ROLLER, R-80-80 (ZABI) GUIDE	099429 <sup>1</sup>	1	
33	MOUNT WELDMENT, HR CHAIN DRIVE	099378-1	1	
34	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	12	
35	BUSHING, 6.2X10X5 SPACER ZINC-PLATED	503674-1	8	

<sup>1</sup> The quantities of rollers and their mounting hardware are: HR1/2 - 12 pcs, HR3/4 - 20 pcs, HR5/6 - 28 pcs.

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>DRIVE ASSEMBLY, HR FEED CHAIN</b>	099377	1	
	DRIVE ASSEMBLY, HR PLATE LINK CHAIN	099069	1	
1	MOTOREDUCER, MR-80/42/1.1-1400/K4/V6	099070	1	
2	SHAFT, HR CHAIN DRIVE ZINC-PLATED	099335-1	1	
3	KEY, A10x8x45 PARALLEL	091312	2	
4	KEY, A14X9X90 PARALLEL	099424	1	
5	BEARING, UCFL208 W/HOUSING	099423	2	
6	SPROCKET, KZN800/21-40 A=80, B=40	099079	1	
7	BOLT, M16x40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4	
8	WASHER, 17 FLAT ZINC	F81058-1	4	
9	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4	
10	BOLT, M10x25-8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1	
11	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	2	

## 7

## REPLACEMENT PARTS

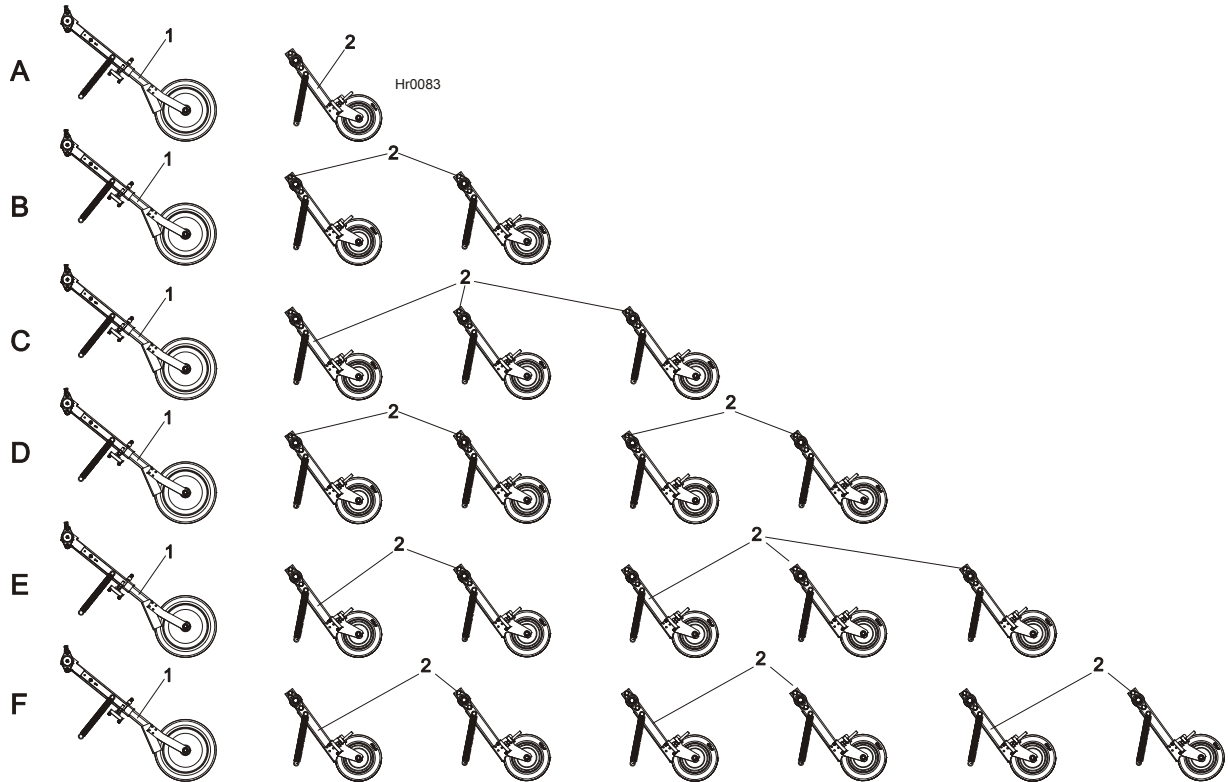
### Feed Chain Drive & Tensioner

12	WASHER, LT15 DRIVE WHEEL ZINC-PLATED	086286-1	1	
13	PLATE, RA80 MOTOREDUCER SUPPORT	099425-1	1	
14	LINK, SBPL 10104 PIVOTAL	097700	1	
15	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	8	
16	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	8	
17	WASHER, 8.4 FLAT ZINC	F81054-1	8	
18	BOLT, M10x35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2	
19	WASHER, 10.5 FLAT ZINC	F81055-1	2	
20	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	1	
21	PAD, FEED TRACK (MEDIUM)	099376	2	
22	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	12	
23	BOLT, M16x160-8.8 HEX HEAD ZINC	F81006-20	2	
24	WASHER, 17 FLAT ZINC	F81058-1	4	
25	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2	
26	CLAMP, RSGU 1.10/12 W1 METAL & RUBBER	086861	3	
27	WASHER, 5.3 FLAT ZINC	F81052-1	3	
28	SCREW, H M5x10 8.8 CROSS RECESSED PAN HEAD ZINC	F81000-13	3	
29	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30 <sup>1</sup>	1	
30	PLATE, GUIDE ROLLER COVER ZINC-PLATED	099441-1 <sup>1</sup>	1	
31	WASHER, 21 FLAT ZINC	F81059-2 <sup>1</sup>	2	
32	ROLLER, R-80-80 (ZABI) GUIDE	099429 <sup>1</sup>	1	
33	MOUNT WELDMENT, HR CHAIN DRIVE	099378-1	1	
34	WASHER, 6.5 FLAT ZINC	F81053-11	12	
35	BUSHING, 6.2X10X5 SPACER ZINC-PLATED	503674-1	8	

<sup>1</sup> The quantities of rollers and their mounting hardware are: HR1/2 - 12 pcs, HR3/4 - 20 pcs, HR5/6 - 28 pcs.



7.18 Hold-Down Roller Kit, HR500 1-6 - Standard

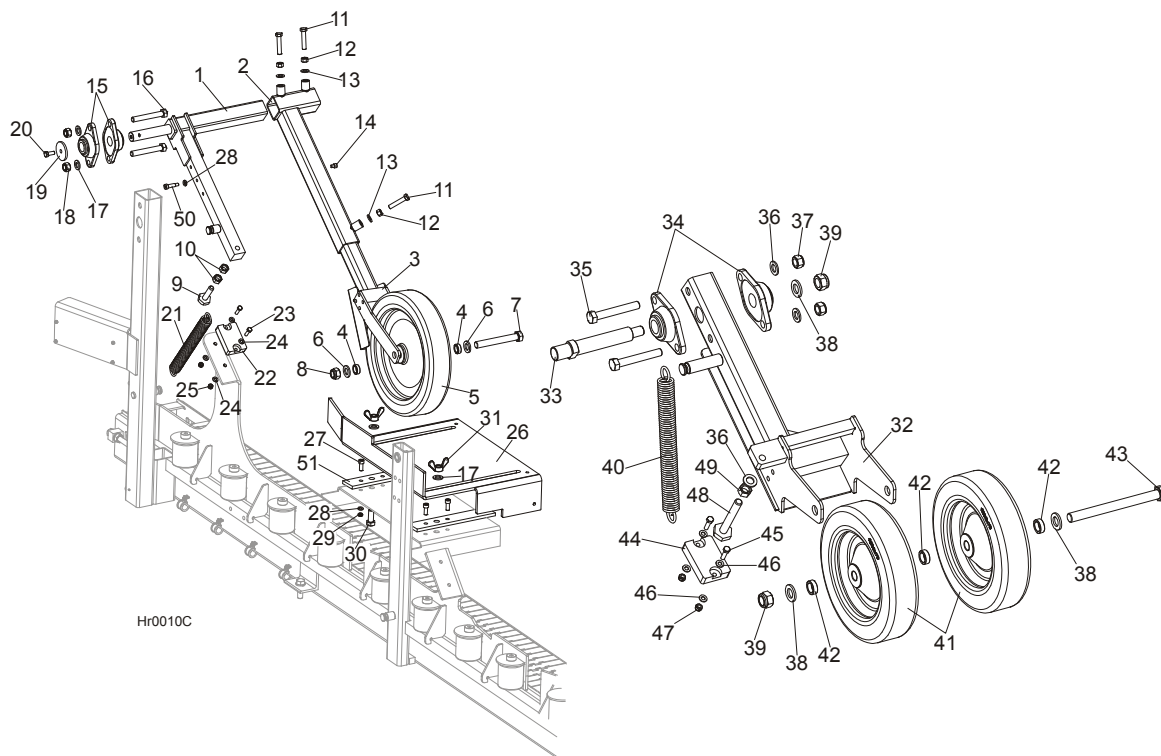


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
A	<b>ROLLER KIT, HR500-1 STANDARD HOLD-DOWN</b>	<b>506296</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	1
B	<b>ROLLER KIT, HR500-2 STANDARD HOLD-DOWN</b>	<b>506297</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	2
C	<b>ROLLER KIT, HR500-3 STANDARD HOLD-DOWN</b>	<b>506298</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	3
D	<b>ROLLER KIT, HR500-4 STANDARD HOLD-DOWN</b>	<b>506299</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	4
E	<b>ROLLER KIT, HR500-5 STANDARD HOLD-DOWN</b>	<b>506300</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	5
F	<b>ROLLER KIT, HR500-6 STANDARD HOLD-DOWN</b>	<b>506301</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	6

# 7 REPLACEMENT PARTS

## Hold-Down Rollers & Log Guide

### 7.19 Hold-Down Rollers & Log Guide



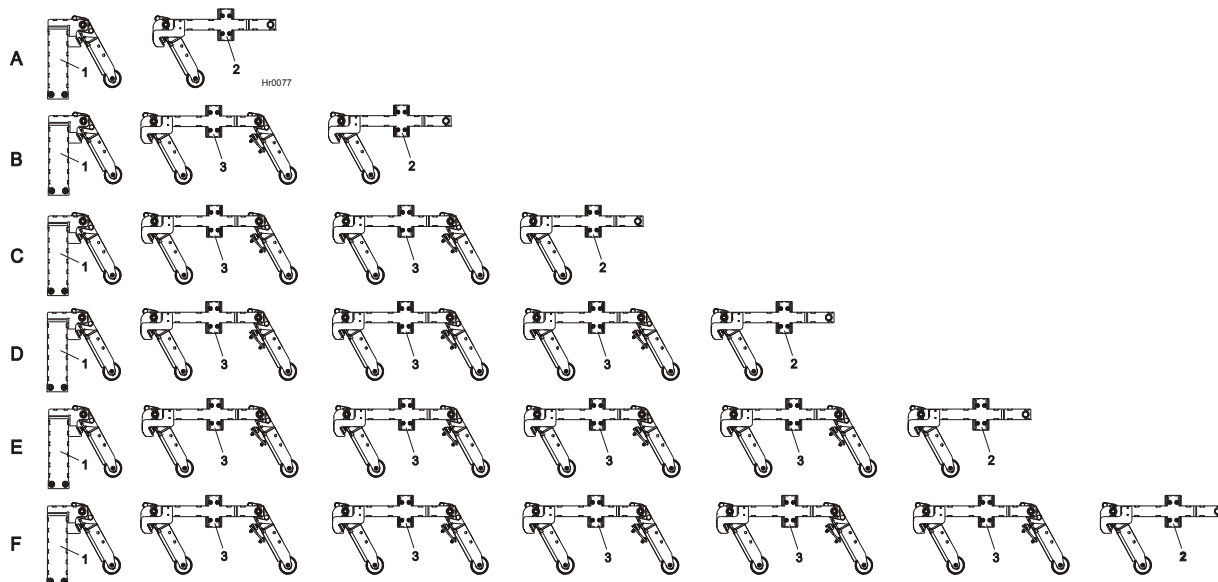
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>ROLLER, 400 COMPLETE HOLD-DOWN</b>	099347	1
1	ARM, 400 HOLD-DOWN ROLLER PIVOT	099369-1	1
2	ARM, SHR-F HOLD-DOWN ROLLER OUTSIDE	094960-1	1
3	ARM, 400 HOLD-DOWN ROLLER INSIDE	099348-1	1
4	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	2
5	WHEEL,400 W/6304 BEARINGS	099334	1
6	WASHER, 21 FLAT ZINC	F81059-2	2
7	BOLT, M20x150 8.8 ISO 4017 ZINC-PLATED	F81007-3	1
8	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	1
	M16 BED RAIL ADJUSTMENT BOLT & 2 NUTS	093710	1
9	BOLT, M16 BED RAIL ADJUSTMENT	086809	1
10	NUT, M16-5-B HEX	F81036-5	2
11	BOLT, M12x60-8.8 HEX HEAD FULL THREAD ZINC	F81004-51	3
12	NUT, M12-8-B HEX ZINC	F81034-1	3
13	WASHER, 13 FLAT ZINC	F81056-1	3
14	SCREW, M8x10-8.8 HEX SOCKET HEAD CAP ZINC	F81002-32	1
15	BEARING, UCFL 206 CX BALL	090851	2
16	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2
17	WASHER, 17 FLAT ZINC	F81058-1	4
18	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
19	WASHER, IDLE BLADE WHEEL RETAINING ZINC-PLATED	086286-1	1
20	BOLT, M10x25-8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1

21	<b>SPRING, FI 4,5X FI 35X303</b>	091863	1	
22	<b>BUMPER, GRENE 70 3201 0010. SHR RUBBER</b>	094969	1	
23	<b>BOLT, M8X30-5.8 HEX HEAD FULL THREAD ZINC</b>	F81002-2	2	
24	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	4	
25	<b>NUT, M8-8-B HEX NYLON ZINC LOCK</b>	F81032-2	2	
26	<b>GUIDE, LOG (FOR STANDARD ROLLERS)</b>	099442-1	1	
	<b>GUIDE, LOG (FOR OPTIONAL ROLLERS - <a href="#">See Section 7.20</a>)</b>	508129-1	1	
27	<b>SCREW, M10X40 8.8 HEX SOCKET HEAD CAP ZINC</b>	F81003-22	4	
28	<b>WASHER, 10.5 FLAT ZINC</b>	F81055-1	5	
29	<b>NUT, M10-8-B HEX NYLON ZINC LOCK</b>	F81033-1	4	
30	<b>BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC</b>	F81006-13	2	
31	<b>NUT, M16 WING ZINC</b>	F81036-3	2	
	<b>ROLLER, 300 COMPLETE DUAL HOLD-DOWN</b>	100344	1	
32	ARM, 300 HOLD-DOWN ROLLER	100345-1	1	
33	PIN, 300 ROLLER PIVOT ZINC-PLATED	100477-1	1	
34	BEARING, UCFL 206 CX BALL	090851	2	
35	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2	
36	WASHER, 17 FLAT ZINC	F81058-1	3	
37	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2	
38	WASHER, 21 FLAT ZINC	F81059-2	3	
39	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	2	
40	SPRING, FI 4.5X FI 35X303	091863	1	
41	WHEEL, 300x70 METAL & RUBBER	100349	2	
42	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	3	
43	BOLT, M20X220-8.8 HEX HEAD ZINC	F81007-4	1	
44	BUMPER, GRENE 70 3201 0010. SHR RUBBER	094969	1	
45	BOLT, M8x30-5.8 HEX HEAD FULL THREAD ZINC	F81002-2	2	
46	WASHER, 8.4 FLAT ZINC	F81054-1	4	
47	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2	
48	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC	100426-1	1	
49	NUT, M16-5.8 HEX ZINC	F81036-1	1	
50	<b>BOLT, 12/M10X35 12.9 ISO7379 SHOULDER</b>	F81003-48	1	
51	<b>WASHER, LOG GUIDE SLIDE</b>	099478	2	

# 7 REPLACEMENT PARTS

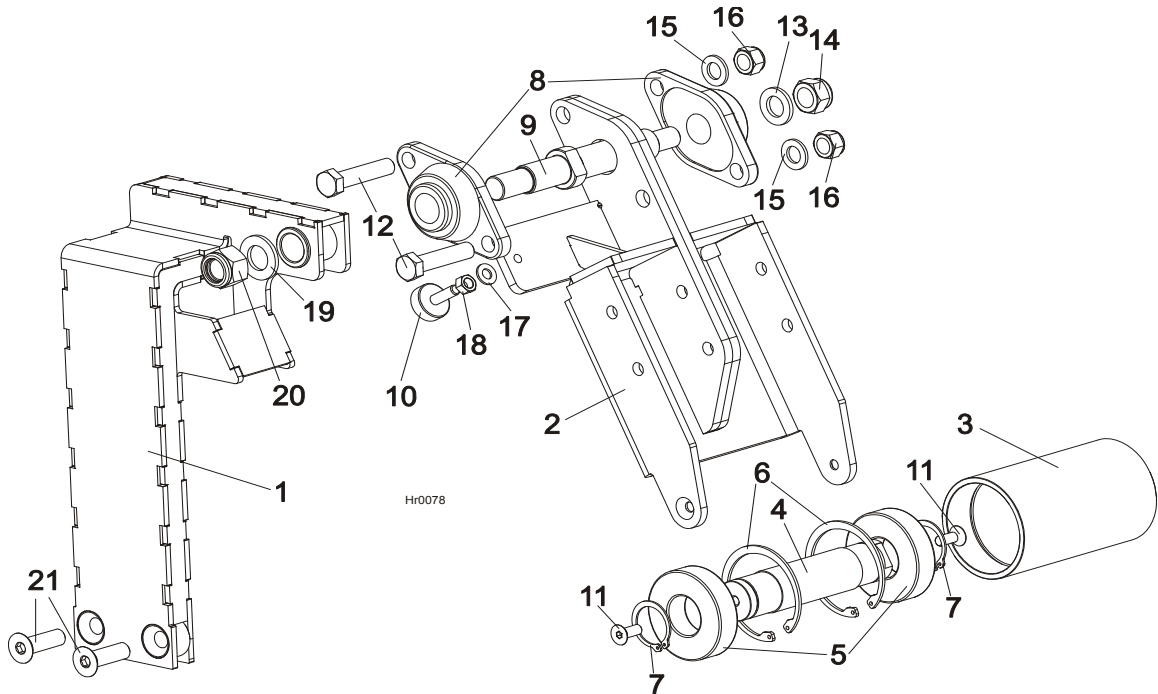
## 101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6 ) - OPTIONAL

### 7.20 101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6 ) - OPTIONAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
<b>A</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-1</b>	<b>504954</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
<b>B</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-2</b>	<b>504955</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	1
<b>C</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-3</b>	<b>504956</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	2
<b>D</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-4</b>	<b>504957</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	3
<b>E</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-5</b>	<b>504958</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	4
<b>F</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-6</b>	<b>504959</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	5

7.21 101.6 Front Hold-Down Roller - OPTIONAL

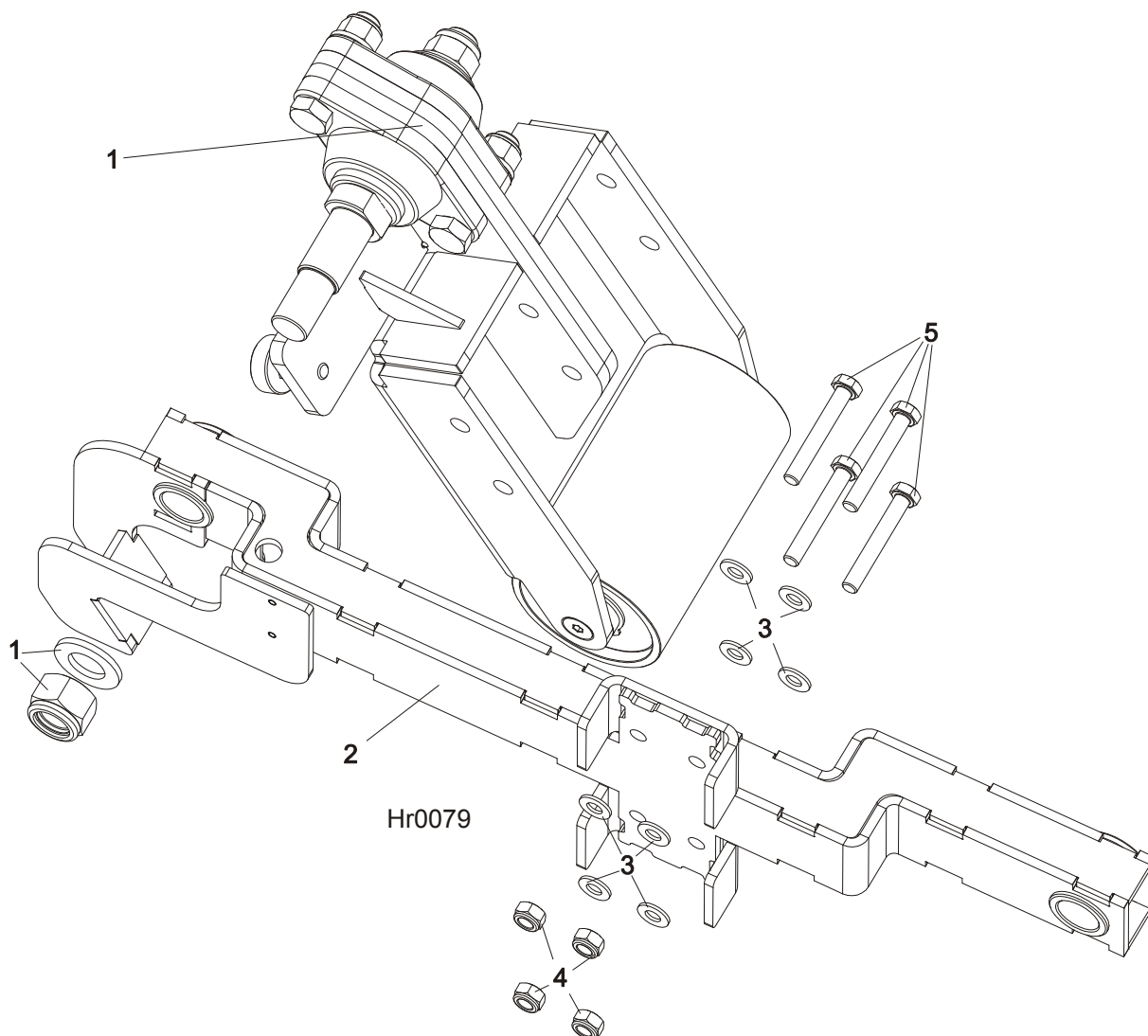


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN</b>	<b>504951</b>	<b>1</b>
1	MOUNT WLDMT, 101.6 FRONT HOLD-DOWN ROLLER	504944-1	1
	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE	504933	1
2	BRACKET, 101.6 HOLD-DOWN ROLLER MOUNTING	504927-1	1
	ROLLER, 101.6 X 170 COMPLETE HOLD-DOWN	504930	1
3	TUBE, HOLD-DOWN ROLLER ZINC-PLATED	504931-1	1
4	SHAFT, HOLD-DOWN ROLLER ZINC-PLATED	504932-1	1
5	BEARING, 6308 2RS CX	504268	2
6	RING, W90 INSIDE RETAINING	F81090-29	2
7	RING, Z40 OUTSIDE RETAINING	F81090-33	2
8	BEARING, UCFL 206 CX-WM1000 W/HOUSING	090851	2
9	SHAFT, 101.6 ROLLER MOUNTING BRACKET ZINC-PL	504938-1	1
10	FOOT, M10 ADJUSTABLE BASE	092839	1
11	BOLT, M10x25 -10.9- Fe/Zn5 DIN 7991	F81003-82	2
12	BOLT, M16x70 -8.8 HEX HEAD ZINC	F81006-16	2
13	WASHER, 21 FLAT ZINC	F81059-2	1
14	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	1
15	WASHER, 17 FLAT ZINC	F81058-1	2
16	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
17	WASHER, 10.5 FLAT ZINC	F81055-1	1
18	NUT, M10-8-B HEX ZINC	F81033-3	1
19	WASHER, 25 FLAT ZINC	F81061-3	1
20	NUT, M24-8-A HEX NYLON ZINC LOCK	F81039-8	1
21	BOLT, M16x50-10.9 DIN7991,BN1422 ZINC-PLATED	F81006-42	2

# 7 REPLACEMENT PARTS

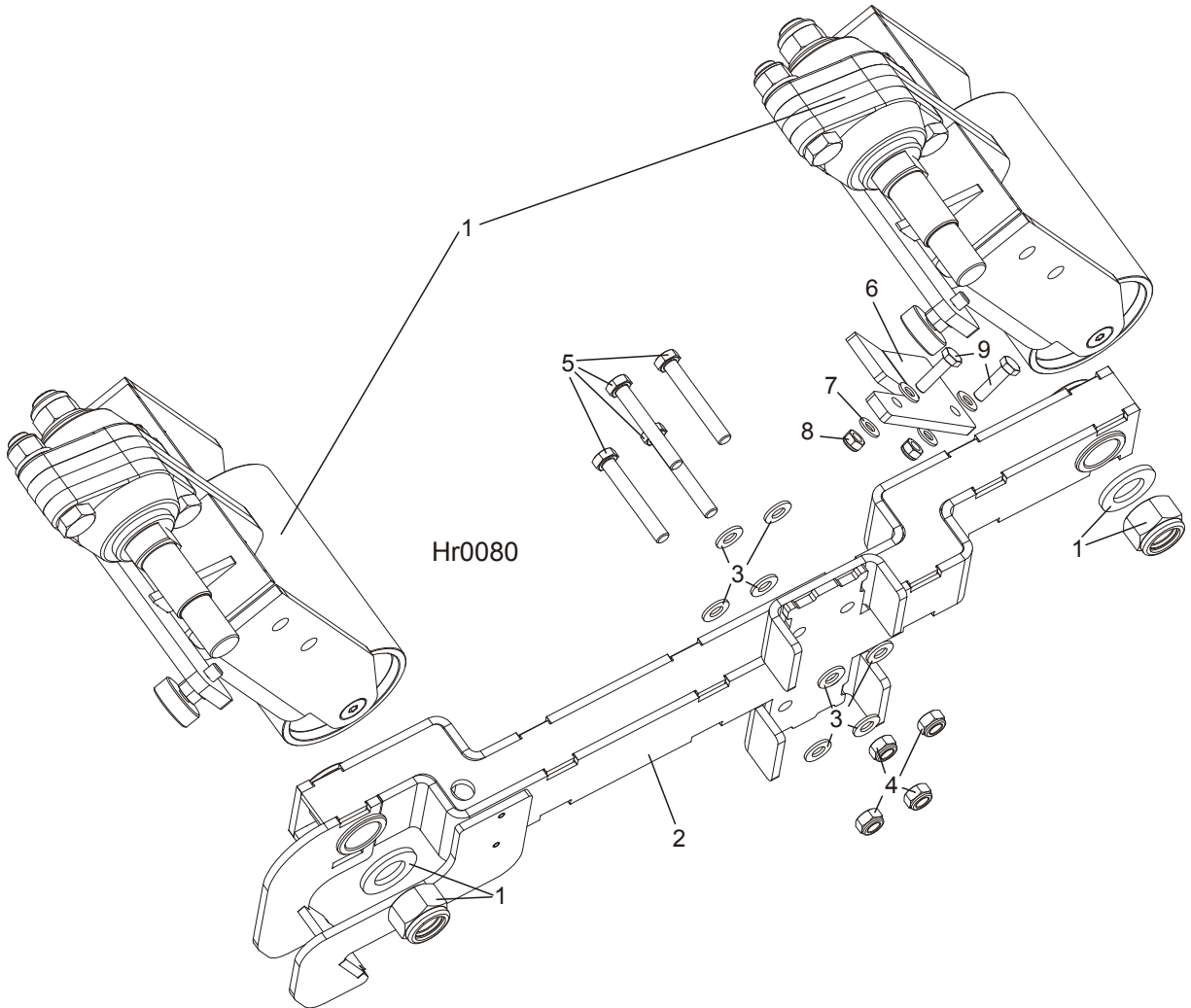
## 101.6 Rear Hold-Down Roller - OPTIONAL

### 7.22 101.6 Rear Hold-Down Roller - OPTIONAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>ROLLER, 101.6 REAR HOLD-DOWN - COMPLETE</b>	<b>504960</b>	<b>1</b>	
1	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE <a href="#">See Section 7.21</a>	504933	1	
2	MOUNT WELDMENT, 101.6 HOLD-DOWN ROLLER	504934-1	1	
3	WASHER, 10.5 FLAT ZINC	F81055-1	8	
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
5	BOLT, M10x70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	4	

7.23 101.6 Hold-Down Roller Kit - OPTIONAL

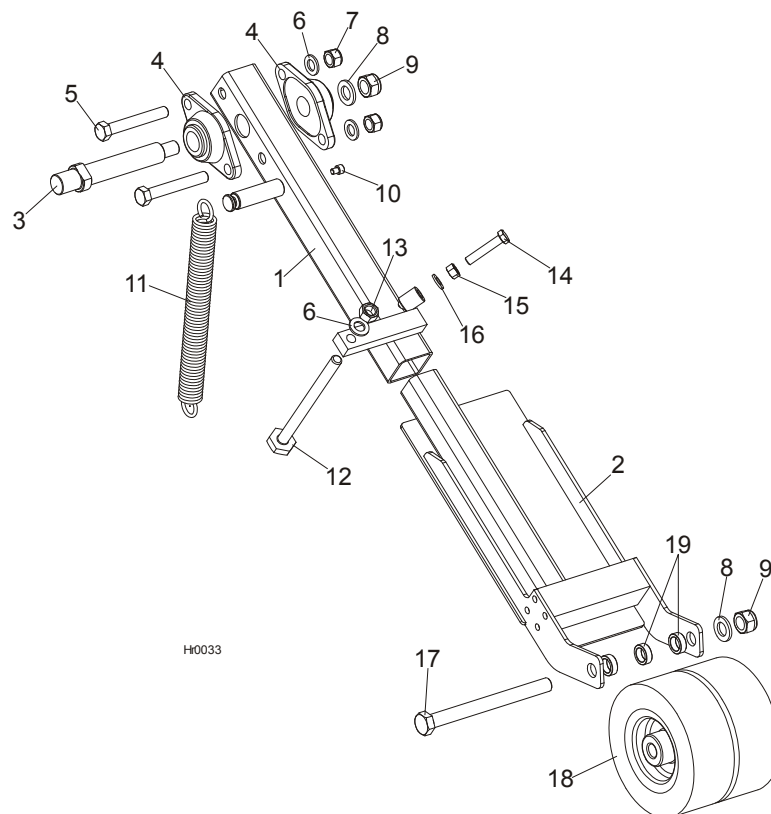


REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.
	<b>ROLLER KIT, 101.6 COMPLETE</b>	<b>504926</b>	<b>1</b>
1	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE <a href="#">See Section 7.21</a>	504933	2
2	MOUNT WELDMENT, 101.6 HOLD-DOWN ROLLER	504934-1	1
3	WASHER, 10.5 FLAT ZINC	F81055-1	8
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
5	BOLT, M10x70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	4
6	PLATE, FOOT ADDITIONAL STOP	504942-1	1
7	WASHER, 8.4 FLAT ZINC	F81054-1	4
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
9	BOLT, M8x30-8.8-B HEX HEAD FULL THREAD ZINC	F81002-7	2

# 7 REPLACEMENT PARTS

## Adjustable Hold-Down Roller (Option)

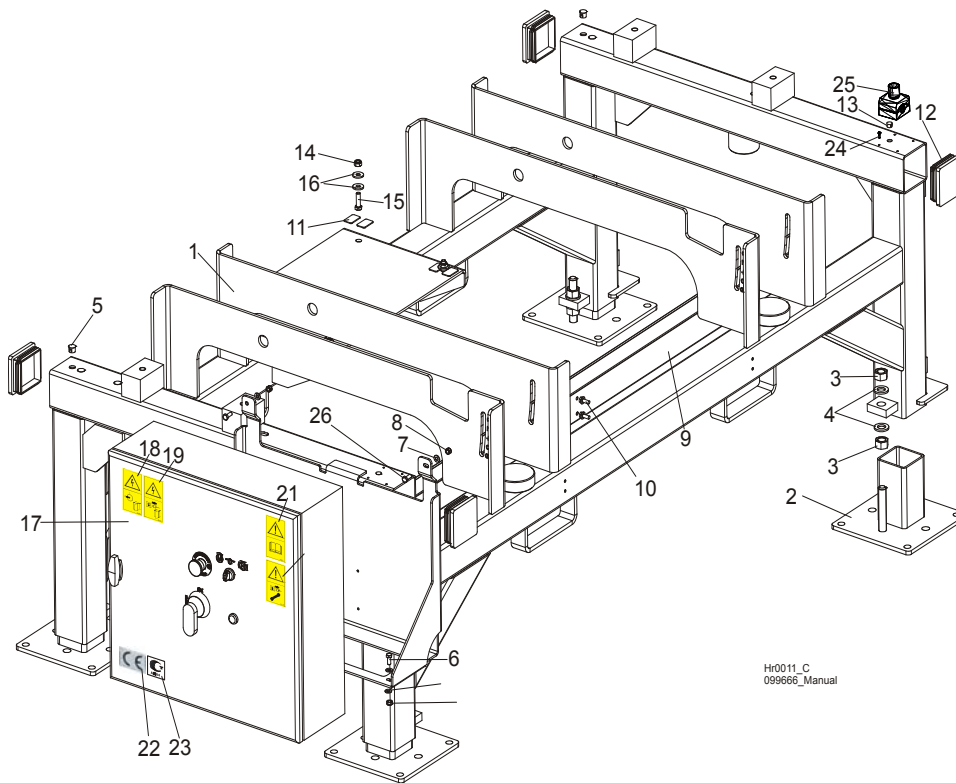
### 7.24 Adjustable Hold-Down Roller (Option)



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>ROLLER, HR ADJUSTABLE HOLD-DOWN</b>	<b>100758</b>	<b>1</b>
1	ARM, 200 ADJUSTABLE HOLD-DOWN ROLLER	100587-1	1
2	ARM, 200 HOLD-DOWN ROLLER OUTRIGGER	100592-1	1
3	PIN, 300 ROLLER PIVOT ZINC-PLATED	100477-1	1
4	BEARING, UCFL 206 CX BALL	090851	2
5	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2
6	WASHER, 17 FLAT ZINC	F81058-1	3
7	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
8	WASHER, 21 FLAT ZINC	F81059-2	2
9	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	2
10	SCREW, M8x10-8.8 HEX SOCKET HEAD CAP ZINC	F81002-32	1
11	SPRING, FI 4.5X FI 35X303	091863	1
12	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC	100591-1	1
13	NUT, M16-5.8 HEX ZINC	F81036-1	1
14	BOLT, M12x60-8.8 HEX HEAD FULL THREAD ZINC	F81004-51	1
15	NUT, M12-8-B HEX ZINC	F81034-1	1
16	WASHER, 13 FLAT ZINC	F81056-1	1
17	BOLT, M20X220-8.8 HEX HEAD ZINC	F81007-4	1
18	WHEEL, D=200mm 60NN METAL & RUBBER	099160	2
19	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	3



**7.25 Main Module Base**



Hr0011\_C  
099666\_Manual

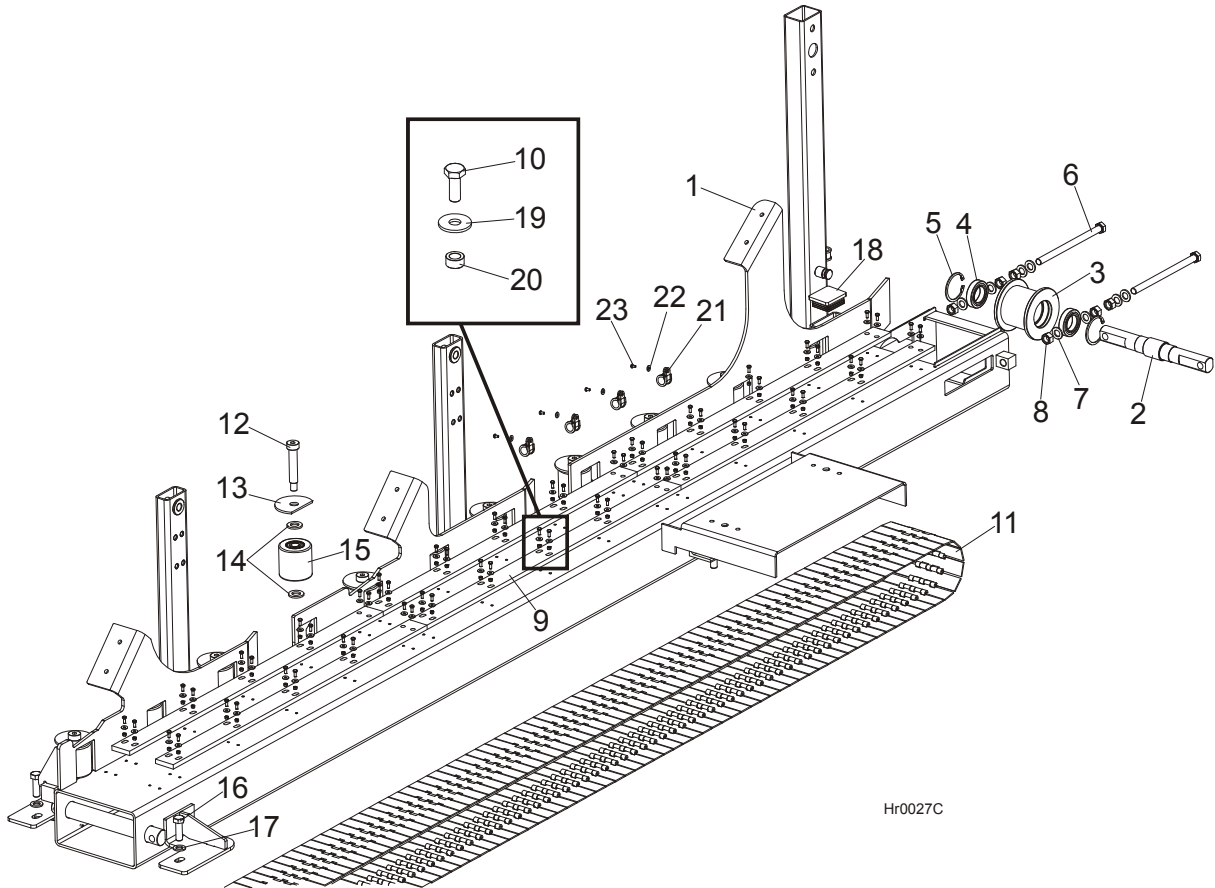
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>BASE, HR MAIN MODULE - COMPLETE</b>	<b>099023</b>	<b>1</b>
1	FRAME, HR MAIN MODULE BASE	099024-1	1
2	FOOT, LEG ADJUSTABLE	099547-1	4
3	NUT, M20-8 HEX ZINC	F81037-1	8
4	WASHER, 21 FLAT ZINC	F81059-2	8
5	BOX, HR ELECTRIC - MAIN MODULE	507270-M1	1
6	BOLT, M8x20-8.8-B HEX HEAD FULL THREAD ZINC	F81002-4	4
7	WASHER, 8.4 FLAT ZINC	F81054-1	8
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
9	DUCT, LH60x40x2000HD CABLE	099374	1
10	BOLT, M6x12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	20
11	WASHER, 6.4 FLAT ZINC	F81053-1	20
12	CAP, 100x100 SQUARE	090694	4
13	CAP, DP 812 HEJMAN 12.7 DIA. HOLE	086773	2
14	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
15	BOLT, M10x35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	4
16	WASHER, 10.5 SPECIAL FLAT ZINC	F81055-6	4
17	<b>DECAL, HAZARDOUS VOLTAGE INSIDE THE ELECTRIC BOX (PICTOGRAM)</b>	<b>096316</b>	<b>1</b>
18	<b>DECAL, REMOVE THE PLUG BEFORE OPENING THE ELECTRIC BOX (PICTOGRAM)</b>	<b>096319</b>	<b>1</b>
19	<b>DECAL, DISCONNECT POWER SUPPLY BEFORE SERVICING (PICTOGRAM)</b>	<b>098177</b>	<b>1</b>
20	<b>DECAL, READ THE OPERATOR'S MANUAL (PICTOGRAM)</b>	<b>096317</b>	<b>1</b>
21	<b>DECAL, CE CERTIFIED MACHINE (SMALL)</b>	<b>P85070</b>	<b>1</b>

**7****REPLACEMENT PARTS***Main Module Base*

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22	DECAL, GOST CERTIFIED MACHINE	099401	1	
23	SCREW, M4X16 5,8-B CROSS RECESSED PAN HEAD ZINC	F81011-42	4	
24	SWITCH, M22-PV/KC02/IY SAFETY	094726	1	

**7.26 Main Module Feed Track**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>MAIN MODULE FEED TRACK - COMPLETE</b>	<b>099039</b>	<b>1</b>	
1	TRACK, HR2 MAIN MODULE FEED	099040-1	1	
	PULLEY, CHAIN TENSION - COMPLETE	099340	1	
2	SHAFT, CHAIN TENSION PULLEY ZINC-PLATED	099337-1	1	
3	PULLEY, CHAIN TENSION ZINC-PLATED	099336-1	1	
4	BEARING, 6008 2RS FLT	086259	2	
5	RING, W68 INSIDE RETAINING	F81090-16	2	
6	BOLT, M16X240-8.8-A2 FULL THREAD	F81006-29	2	
7	WASHER, 17 FLAT ZINC	F81058-1	8	
8	NUT, M16-5.8 HEX ZINC	F81036-1	6	
9	PAD, RESAW FEED TRACK	092080	6	
10	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	60	
11	CHAIN, ACCATE S802K750 204-LINK	099080	1	
	CHAIN, ACCATE S802K750 116-LINK	099344 <sup>1</sup>	1/2	
12	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30	11	
13	COVER, SIDE ROLLER ZINC-PLATED	099441-1	11	
14	WASHER, 21 FLAT ZINC	F81059-2	22	
15	ROLLER, R-80-80 (ZABI) SIDE	099429	11	

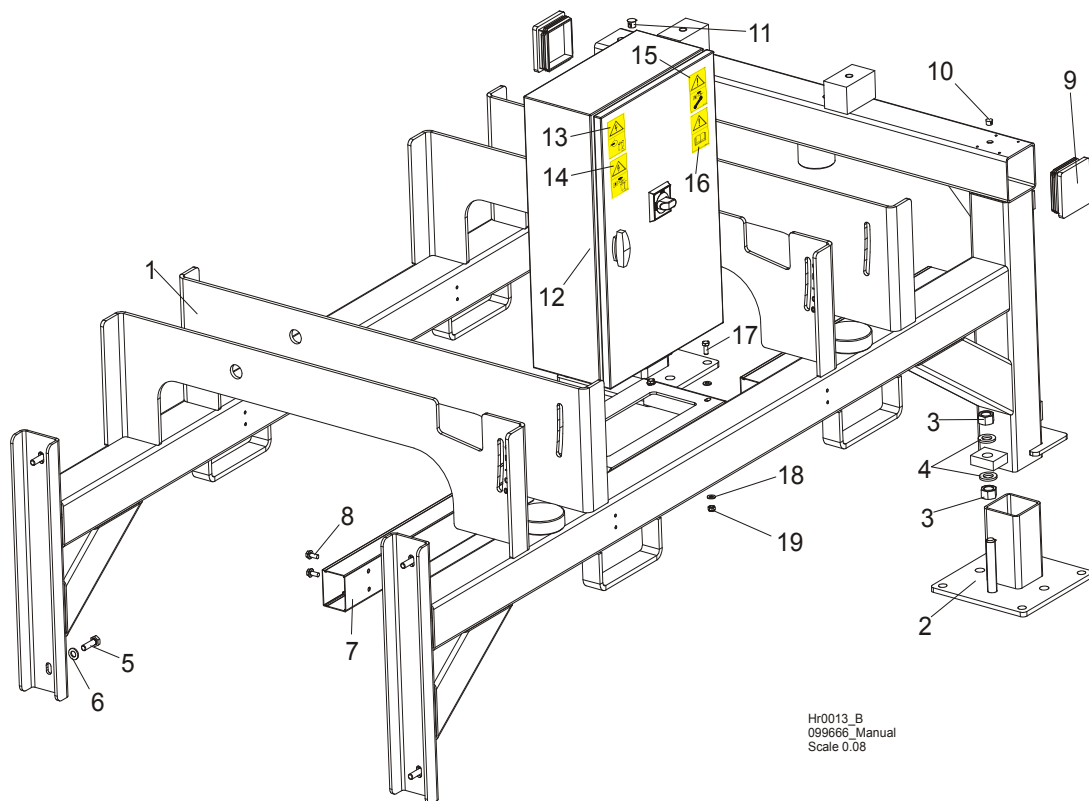
# 7 REPLACEMENT PARTS

## Additional Module Base

16	BOLT, M16x50-8.8 HEX HEAD FULL THREAD ZINC	F81006-7	4	
17	WASHER, 17 FLAT ZINC	F81058-1	4	
18	CAP, HR FRAME	089644	1	
19	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	60	
20	BUSHING, 6.2X10X5 ZINC-PLATED SPACER	503674-1	48	
21	CLAMP, RSGU 1.20/20 W1 METAL & RUBBER	F81087-2	7	
22	WASHER, 5.5 SPECIAL FLAT ZINC	F81052-3	7	
23	SCREW, H M5x10 8.8 CROSS RECESSED PAN HEAD ZINC	F81000-13	7	

<sup>1</sup> Used only on HR3/4 (1 pcs) and on HR5/6 (2 pcs) as the 099080 chain extension.

### 7.27 Additional Module Base



Hr0013\_B  
099666\_Manual  
Scale 0.08

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>COMPLETE ADDITIONAL MODULE BASE</b>	099031 <sup>1</sup>	1/2	
1	FRAME, ADDITIONAL MODULE BASE	099032-1	1	
2	FOOT, ADJUSTABLE LEG	099547-1	2	
3	NUT, M20-8 HEX ZINC	F81037-1	4	
4	WASHER, 21 FLAT ZINC	F81059-2	4	
5	BOLT, M12x40-8.8 HEX HEAD FULL THREAD ZINC	F81004-4	4	
6	BOLT, M8x20-8.8-B HEX HEAD FULL THREAD ZINC	F81002-4	4	
7	WASHER, 8.4 FLAT ZINC	F81054-1	8	
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4	
9	DUCT, LH60x40x2000HD CABLE	099374	1	

10	BOLT, M6x12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	16	
11	WASHER, 6.4 FLAT ZINC	F81053-1	16	
12	CAP, 100x100 SQUARE	090694	2	
13	WASHER, 13 FLAT ZINC	F81056-1	4	
14	<b>BOX, HR ELECTRIC - ADDITIONAL MODULE</b>	507270-M2 <sup>2</sup>	1	
	<b>BOX, HR ELECTRIC - ADDITIONAL MODULE</b>	507270-M3 <sup>3</sup>	1	
15	<b>DECAL, HAZARDOUS VOLTAGE INSIDE THE ELECTRIC BOX (PICTOGRAM)</b>	096316	1	
16	<b>DECAL, REMOVE THE PLUG BEFORE OPENING THE ELECTRIC BOX (PICTOGRAM)</b>	096319	1	
17	<b>DECAL, DISCONNECT POWER SUPPLY BEFORE SERVICING (PICTOGRAM)</b>	098177	1	
18	<b>DECAL, READ THE OPERATOR'S MANUAL (PICTOGRAM)</b>	096317	1	

<sup>1</sup> Used on HR3/4 - 1 pcs and on HR5/6 - 2 pcs.

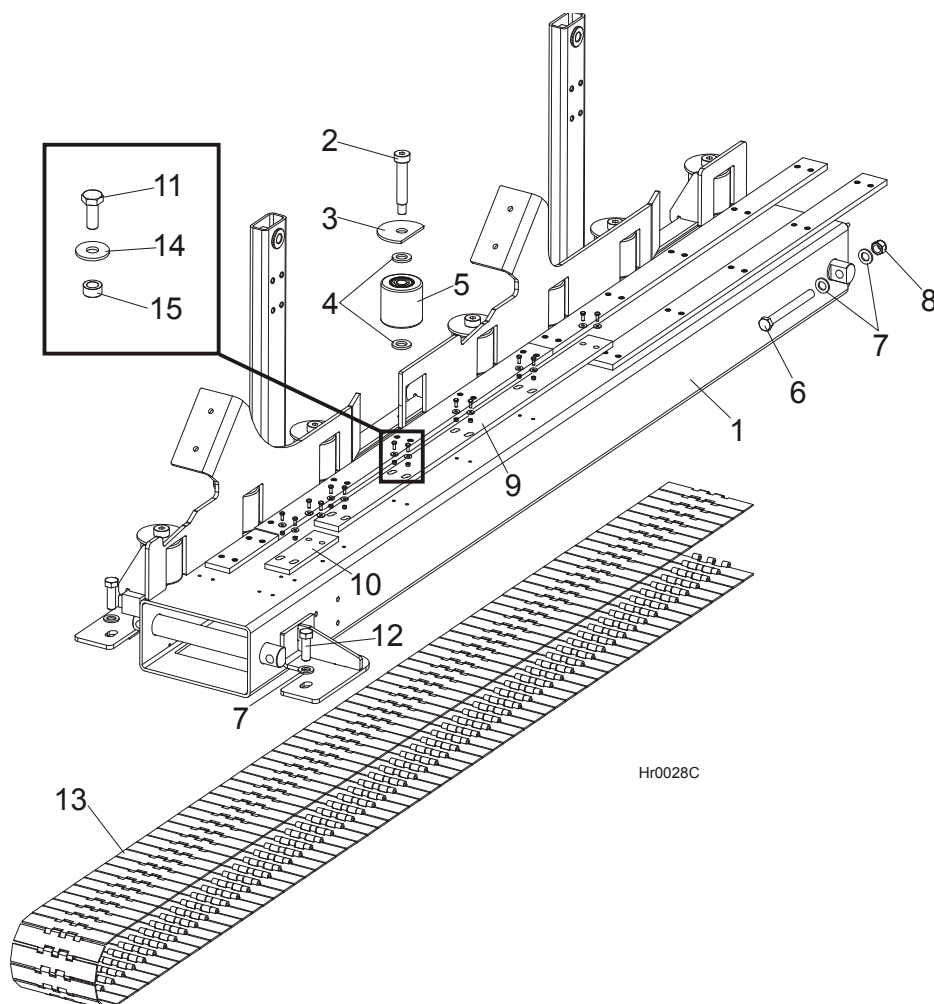
<sup>2</sup> Belongs to: 099663, 099664, 099665 and 099666 (one piece on each machine).

<sup>3</sup> Used along with 507270-M2 on 099665 and 099666 (one piece on each machine).

# 7 REPLACEMENT PARTS

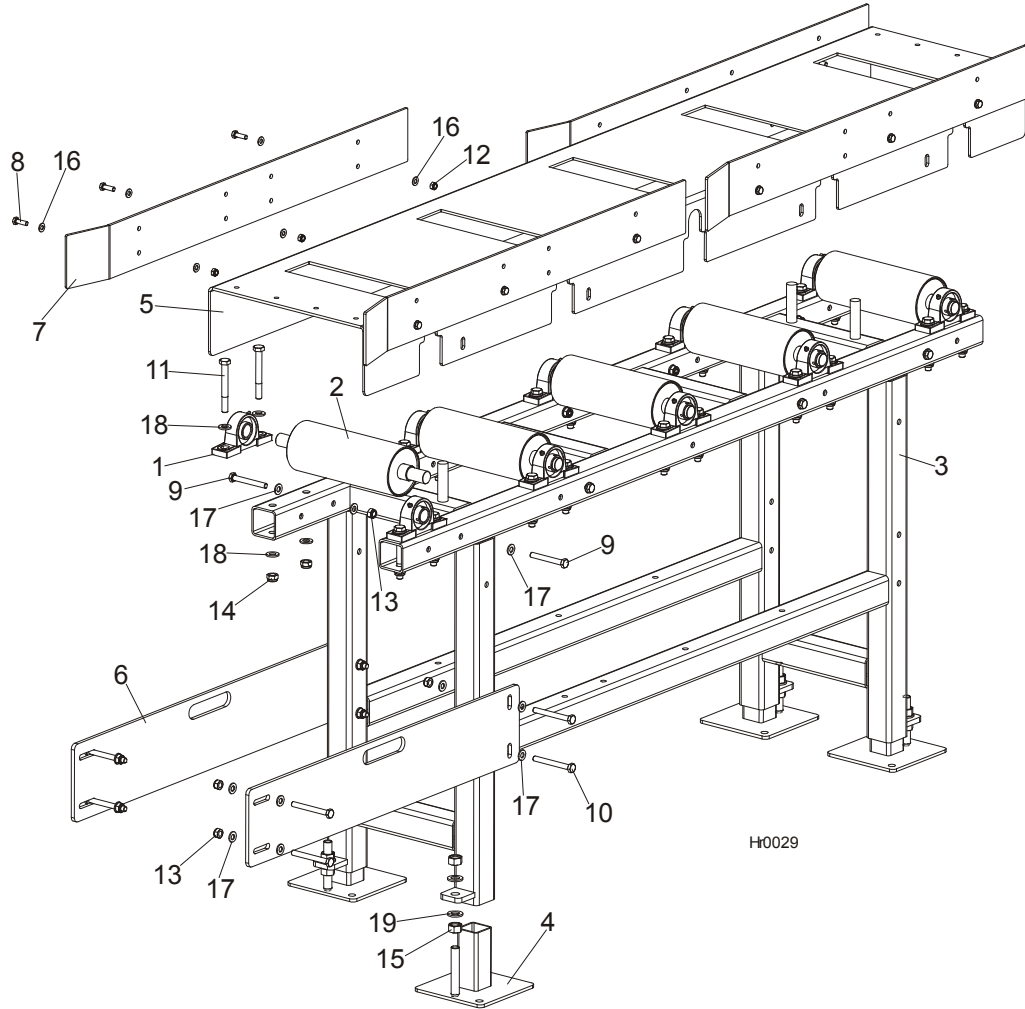
## Additional Module Feed Track

### 7.28 Additional Module Feed Track



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>ADDITIONAL MODULE FEED TRACK - COMPLETE</b>	099440	1
1	TRACK, HR2 FEED	099372-1	1
2	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30	8
3	COVER, SIDE ROLLER ZINC-PLATED	099441-1	8
4	WASHER, 21 FLAT ZINC	F81059-2	16
5	ROLLER, R-80-80 (ZABI) SIDE	099429	8
6	BOLT, M16x160-8.8 HEX HEAD ZINC	F81006-20	2
7	WASHER, 17 FLAT ZINC	F81058-1	6
8	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
9	PAD, RESAW FEED TRACK	092080	4
10	PAD, FEED TRACK SHORT	099430	2
11	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	48
12	BOLT, M16x50-8.8 HEX HEAD FULL THREAD ZINC	F81006-7	2
13	CHAIN, ACCATE 116-LINK	099344	1
14	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	48
15	BUSHING, 6.2X10X5 ZINC-PLATED SPACER	503674-1	36

**7.29 Idle Roller Table, SLPIRT**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>HR IDLE ROLLER TABLE</b>	<b>SLPIRT</b>	<b>1</b>
	IDLE RETURN TABLE - COMPLETE	099659	1
1	BEARING, UCP 205 CX W/HOUSING	088468	10
2	ROLLER, SVS FEED	098140-1	5
3	FRAME, SVS INFEED & OUTFEED TABLE	099168-1	1
4	FOOT ASSEMBLY, TABLE LEG	099281-1	4
5	PLATE, RETURN TABLE TOP	099686-1	1
6	PLATE, RETURN TABLE CONNECTION	099687-1	2
7	PLATE, GUIDE	099688-1	4
8	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	12
9	BOLT, M10x80-8.8 HEX HEAD ZINC	F81003-50	9
10	BOLT, M10x90 -8.8-B HEX HEAD ZINC	F81003-66	8
11	BOLT, M12x100-8.8 HEX HEAD ZINC	F81004-3	20

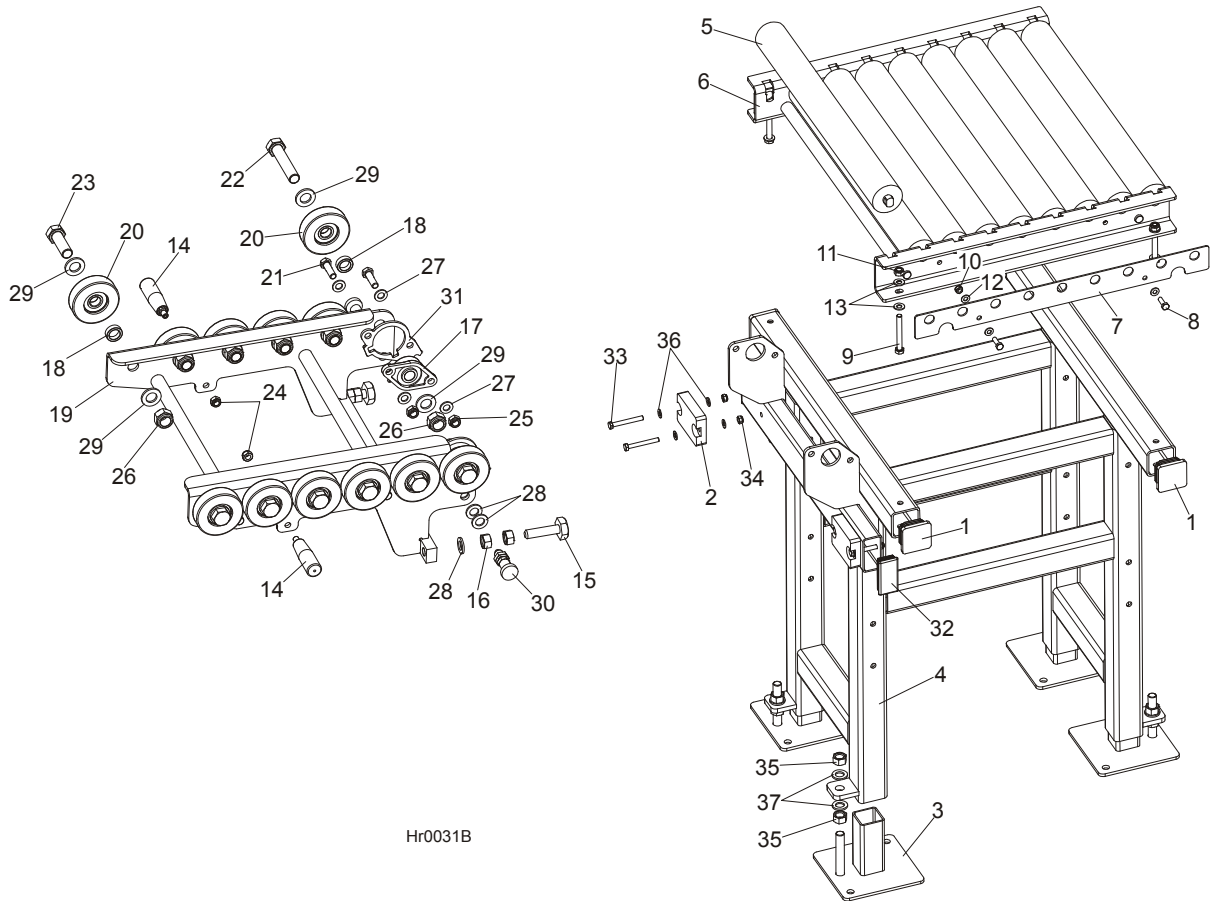
**7****REPLACEMENT PARTS***Idle Roller Table, SLPIRT*

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<b>12</b>	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	12	
<b>13</b>	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	17	
<b>14</b>	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	20	
<b>15</b>	NUT, M16-5.8 HEX ZINC	F81036-1	8	
<b>16</b>	WASHER, 8.4 FLAT ZINC	F81054-1	23	
<b>17</b>	WASHER, 10.5 FLAT ZINC	F81055-1	34	
<b>18</b>	WASHER, 13 FLAT ZINC	F81056-1	40	
<b>19</b>	WASHER, 17 FLAT ZINC	F81058-1	8	



**7.30 Cross Roller Table, SLPCRT**



Hr0031B

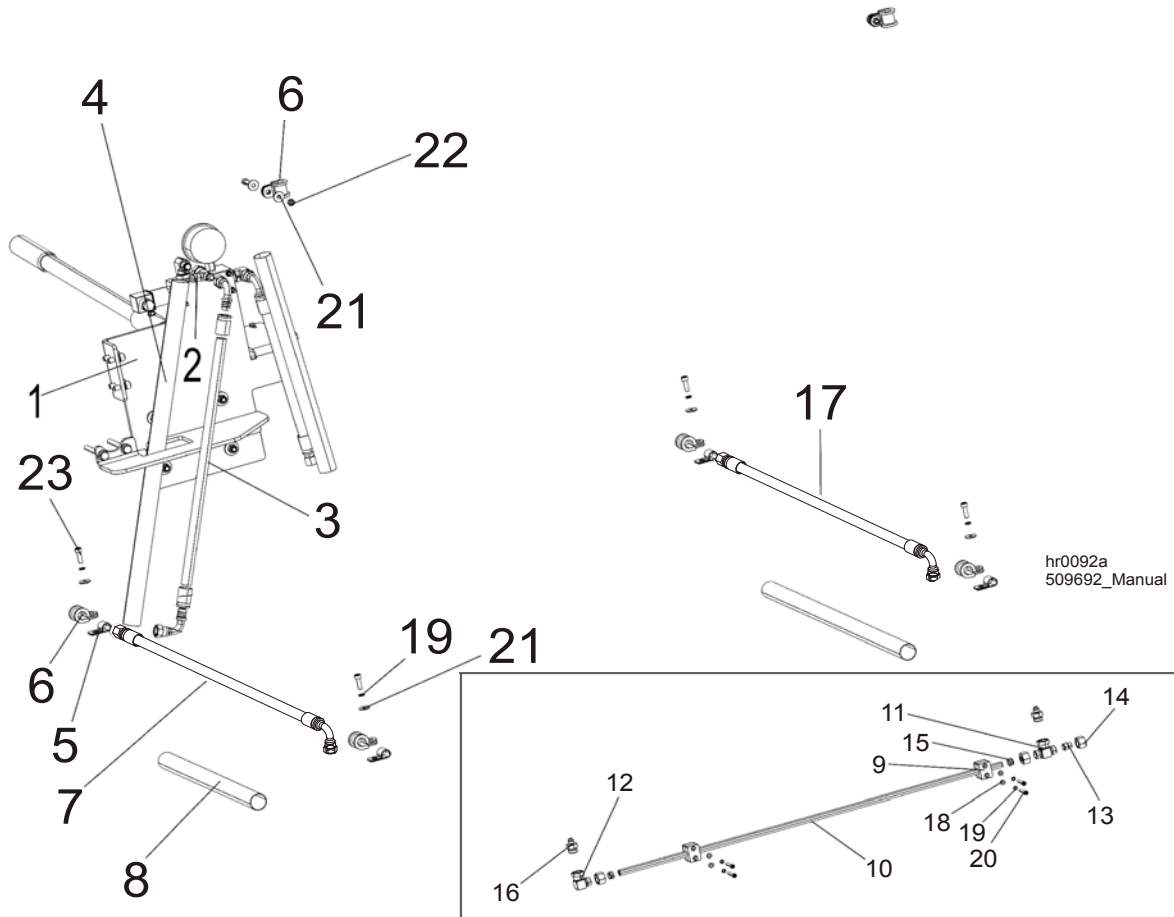
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>HR CROSS ROLLER TABLE</b>	<b>SLPCRT</b>	<b>1</b>
	COMPLETE CROSS RETURN TABLE	099648	1
1	CAP, 1540 DIA. OUTRIGGER LEG	089710	4
2	BUMPER, GRENE 70 3201 0010. SHR RUBBER	094969	2
3	FOOT ASSEMBLY, TABLE LEG	099281-1	4
4	FRAME WELDMENT, CROSS RETURN TABLE	099652-1	1
	TOP, 63.5X600 CROSS RETURN TABLE - COMPLETE	099656	1
5	ROLLER, 63.5/20X600/608/626 s=14 (EE15)	089044-1	9
6	BRACKET, 63.5X600 ROLLER MOUNTING	099649-1	1
7	PLATE, 63.5/20X600 ROLLER CLAMP	099650-1	2
8	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
9	BOLT, M10x80 -8.8 HEX HEAD ZINC	F81003-50	4
10	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
11	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
12	WASHER, 8.4 FLAT ZINC	F81054-1	8
13	WASHER, 10.5 FLAT ZINC	F81055-1	8

## 7

**REPLACEMENT PARTS***Cross Roller Table, SLPCRT*

	ARM, OPENED W/RP-90 ROLLERS - COMPLETE	099679	1	
14	KNOB, PLASTIC CRANK HANDLE	086338	2	
	M16 BOLTS +2 NUTS	093710	2	
15	NUT, M16-5-B HEX	F81036-5	1	
16	BOLT, M16 BED RAIL ADJUSTMENT	086809	2	
17	BEARING, UCFL204 (COMPLEX) W/HOUSING	500060	2	
18	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	12	
19	ARM WELDMENT, OPENED	099680-1	1	
20	ROLLER, RP-90. 6304 POLYURETHANE	099689	12	
21	BOLT, M12x40-8.8 HEX HEAD ZINC	F81004-1	4	
22	BOLT, M20X100-8.8 HEX HEAD ZINC	F81007-6	2	
23	BOLT, M20X60-8.8 HEX HEAD ZINC	F81007-7	10	
24	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2	
25	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	4	
26	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	12	
27	WASHER, 13 FLAT ZINC	F81056-1	8	
28	WASHER, 17 FLAT ZINC	F81058-1	8	
29	WASHER, 21 FLAT ZINC	F81059-2	24	
30	PIN, 45308DNW DETENT	089939	2	
31	PLATE, OPENED ARM LOCK	503336-1	2	
32	CAP, 80x40 TUBE	099692	2	
33	BOLT, M8x65 8.8 HEX HEAD FULL THREAD ZINC	F81002-9	4	
34	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4	
35	NUT, M16-5.8 HEX ZINC	F81036-1	8	
36	WASHER, 8.4 FLAT ZINC	F81054-1	8	
37	WASHER, 17 FLAT ZINC	F81058-1	8	

**7.31 Hydraulic Blade Tensioner**



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE</b>	<b>509691</b>	<b>1</b>
	HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700	506733	1
	HOSE, PHD 2T3/8x0.43 90W9/16UNF-90W9/16UNF HYDRAULIC	506737	1
	GUARD, OBLIQUE HOSE	508714	1
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE</b>	<b>509692</b>	<b>1</b>
1	HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700	506733 <sup>1</sup>	1
2	FEETING, BBA UNF 9/16" TEE W/NUT	509687	1
3	HOSE, PHD 2T3/8x0.43 90W9/16UNF-90W9/16UNF HYDRAULIC	506737	1
4	GUARD, OBLIQUE HOSE	508714	2
5	CLAMP, 1/2" EMT COATED	P07584	4
6	CLAMP, RSGU 1.15/20 METAL & RUBBER	509701	6
7	HOSE, PHD 2T3/8x2.85 90W9/16UNF-W9/16UNF HYDRAULIC	509718	1
8	GUARD, VERTICAL HOSE	508713	1
9	BLOCK, DN15 APP-L-15 PIPE BRACKET	509720	2
10	PIPE, L=1050.	509699	1
11	FITTING, XEVT 15 L 22x1.5 TEE W/NUT	509688	1
12	FITTING, XE VW 15 L 22x1.5 ELBOW W/NUT	509689	1

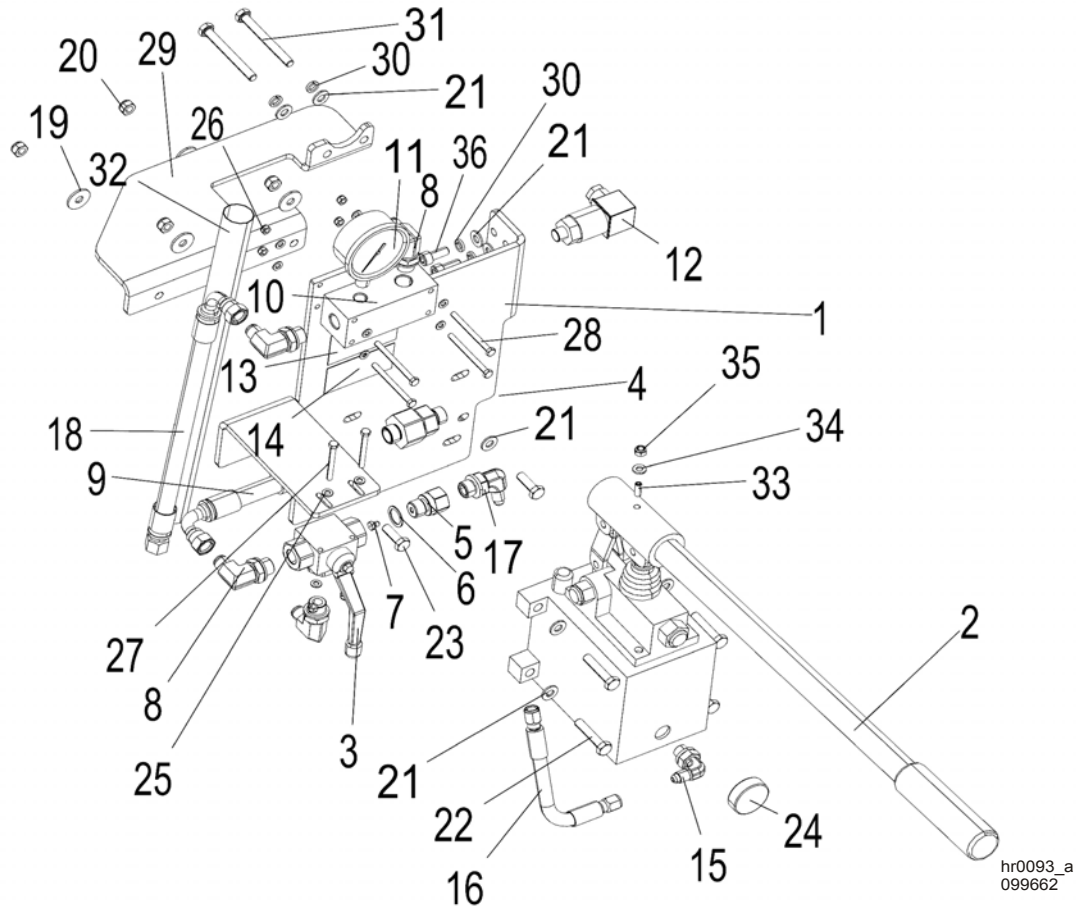
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**REPLACEMENT PARTS***Hydraulic Blade Tensioner*

13	CAP, DKL 22x1.5 15 L.	509698	1	
14	NUT, M 15 L M22x1.5	509690	3	
15	SLEEVE, DPR 15 L. PIPE CLINCH	509697	2	
16	FITTING, 9/16"-18 UNF - M22x1.5 ZINC-PLATED REDUCER	510446-1	2	
17	HOSE, PHD 2T3/8x2.85 90W9/16UNF-W9/16UNF HYDRAULIC	509719	1	
18	WASHER, 6.4 FLAT ZINC	F81053-1	4	
19	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	8	
20	SCREW, M6x35 8.8 HEX SOCKET HEAD CAP ZINC	F81001-23	4	
21	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	8	
22	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
23	SCREW, M6x20 8.8 HEX SOCKET HEAD CAP ZINC	F81001-22	6	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-3 - COMPLETE</b>	<b>509693</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE	509691	1	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	1	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-4 - COMPLETE</b>	<b>509694</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	2	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-5 - COMPLETE</b>	<b>509695</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE	509691	1	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	2	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-6 - COMPLETE</b>	<b>509696</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	3	

<sup>1</sup> [See Section 7.32](#)

**7.32 Hydraulic Pump Assembly**



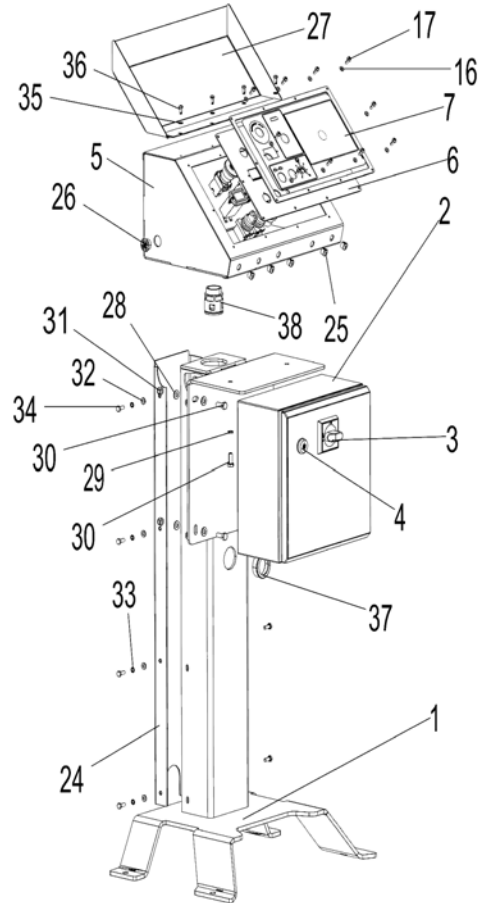
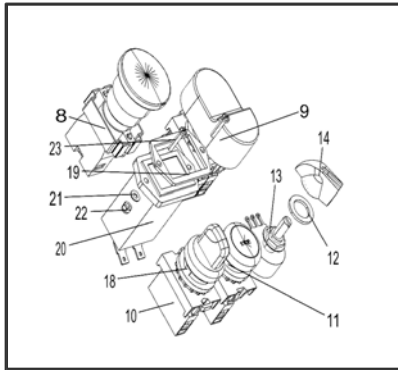
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700</b>	<b>506733</b>	<b>1</b>
1	PLATE, MOUNTING	506734-1	1
2	PUMP, PMS12/TNK1 W/ONE-LITER TANK	092789	1
3	VALVE, RSAP3 VO2L G3/8" 3-WAY BALL	504803	1
4	VALVE, RHV12LREDA3C (HVR NW10MLED) CHECK	094559	1
	FITTING, G 3/8 W/NOZZLE	096849	1
5	FITTING, G3/8 ZINC-PLATED SPECIAL	096850-1	1
6	WASHER, 16 COPPER	F81058-3	1
7	NOZZLE, D092-O 1MM DIA. PROPANE&BUTANE	091007	1
8	FITTING, 90\$ - 3/8 BSP - 9/16 JIC ELBOW	096335	4
9	HYDRAULIC HOSE, 3/8' W/DKJ 90 DN10 9/16 UNF/DKOL DN10 M18x1.5 END FITTINGS	504831	1
10	BLOCK, MOUNTING	504829-1	1
11	GAUGE, 200 BAR (3000PSI) PRESSURE	505176	1
12	SWITCH, F4-T-1-M3-16 BAR PRESSURE	504830	1
13	DECAL, PRESSURE VALUE SETTING	505348	1
14	DECAL, TVS BLADE TENSIONER HANDLE POSITION	505346	1

## 7

**REPLACEMENT PARTS***Hydraulic Pump Assembly*

15	FITTING, CA-204410-3 (W90HROKO4HJ) G1/4-JIC37.7/16-20 ELBOW	094562	1	
16	HOSE, 1/4 (0.19m) HYDRAULIC	505174	1	
17	FITTING, CA-204411-3 (W90HROKO6HJ04) G3/8-JIC37.7/16-20 ELBOW	094563	1	
18	HOSE, PHD 2T3/8x0.27 90W9/16UNF-W9/16UNF HYDRAULIC	506736	1	
19	WASHER, ISO 7093-1-8-200 HV-A2E	F81054-11	4	
20	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	6	
21	WASHER, 8.4 FLAT ZINC	F81054-1	14	
22	BOLT, M8X40-8.8 HEX HEAD FULL THREAD ZINC	F81002-15	4	
23	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2	
24	MAGNET, MW 38x12/N38 NEODYMIUM	500022	1	
25	WASHER, 5.3 FLAT ZINC	F81052-1	12	
26	NUT, M5-8-FE/ZN5 DIN985	F81030-2	6	
27	BOLT, M5x45 DIN933-A2-70 STAINLESS STEEL	F81000-22	2	
28	BOLT, M5X60 8.8 HEX HEAD ZINC	F81000-36	4	
29	BRACKET, SUPPORT	506732-1	1	
30	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	6	
31	BOLT, M8x75-8.8 HEX HEAD ZINC	F81002-91	2	
32	GUARD, VERTICAL HOSE	508713	1	
33	LATCH, GN 615.3-M6-KN BALL THREADED	096874	1	
34	WASHER, 6.4 FLAT ZINC	F81053-1	1	
35	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1	
36	SCREW, M8x20-8.8 HEX SOCKET HEAD CAP ZINC	F81002-30	4	

7.33 Control Box



Hr0094

REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY.
	<b>BOX, HR500/700 CONTROL - COMPLETE</b>	<b>507170</b>	<b>1</b>
1	PEDESTAL, CONTROL BOX	505555-1	1
	<b>BOX, TVS ELECTRIC</b>	<b>507269</b>	<b>1</b>
2	BOX WELDMENT, SAREL S83002/300x300x150	092627	1
3	KNOB, OHB S2A1 AB SWITCH	502312-1	1
4	LIGHT, 1SFA619402L5415 WHITE CONTROL	509129	1
5	BOX WELDMENT, TVS CONTROL	510061-1	1
	<b>PANEL ASSEMBLY, HR500/700 CONTROL BOX FRONT</b>	<b>511804</b>	<b>1</b>
6	PANEL, HR500/700 CONTROL BOX FRONT	511803-1	1
7	DECAL, HR500/700 CONTROL BOX	510765	1
8	BUTTON, EMERGENCY STOP	086556	1
9	SWITCH, 24V ILLUMINATED MOELLER START/STOP	090452	1
10	SWITCH, 3-POSITION MOELLER GREEN	091359	1
11	SWITCH, M22 RED PUSHBUTTON	090926	1
12	WASHER, 1/2X3/4X1/16 NYLON	P05251-1	1
13	POTENTIOMETER, 5K 53C35K	504389	1
14	KNOB, SPEED CONTROL	P06257	1

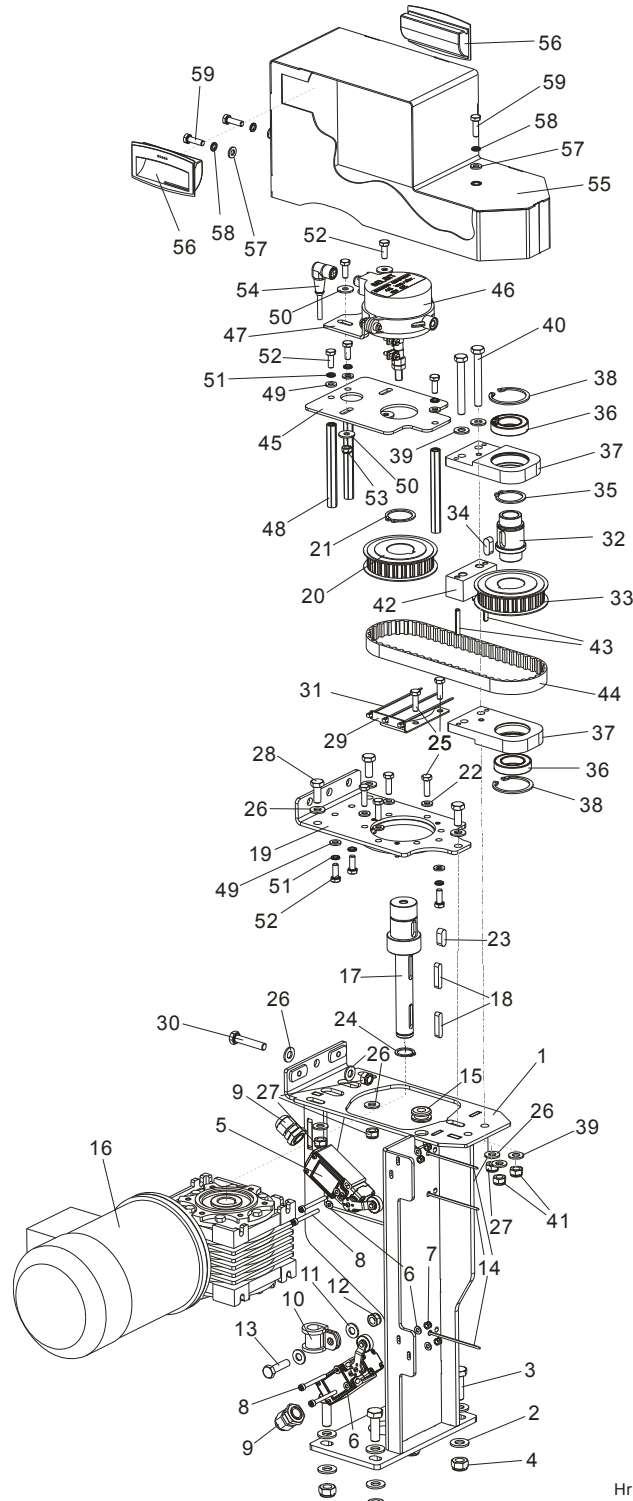
## 7

**REPLACEMENT PARTS***Control Box*

15	GASKET, CONTROL BOX	097132	1	
16	WASHER, 5.3 FLAT ZINC	F81052-1	10	
17	BOLT, #10-24X1/2 PH PAN HEAD, TYPE 23	F05015-17	10	
18	ADAPTOR, M22-XC-Y CODING	092687	2	
19	GASKET, HOUR METER	093346	1	
20	METER, (HOBBS-HONEYWELL) HOUR	093166	1	
21	WASHER, 3.2 FLAT ZINC	F81050-2	2	
22	NUT, M3-6 HEX NYLON ZINC LOCK	F81028-2	2	
23	SCREW, M3x16 5.8-B CROSS RECESSED PAN HEAD ZINC	F81028-3	2	
24	PLATE, WM1000 REAR CONTROL BOX PEDESTAL	504499-1	1	
25	CAP, HEYMAN DP-812 12.7 HOLE	086773	5	
26	CAP, SR1086 22.2 HOLE	093544	2	
27	COVER, CONTROL BOX - COMPLETE	097135-1	1	
28	WASHER, 8.4 FLAT ZINC	F81054-1	10	
29	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
30	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	6	
31	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4	
32	WASHER, 6.4 FLAT ZINC	F81053-1	8	
33	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	8	
34	BOLT, M6x16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	8	
35	WASHER, 5.3 FLAT ZINC	F81052-1	4	
36	BOLT, #10-24X1/2 PH PAN HEAD, TYPE 23	F05015-17	4	
37	BUSH, MOSS 44.5mm 465901 SNAP-FIT	R80670-3	1	
38	GLAND, KCLICK-GP29 RILL 29 CONDUIT	086576	1	



**7.34 Up/Down Screw Drive Assembly (Option)**



Hr009c

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	MULTISETWORK, HR500-1	511796	1
	MULTISETWORK, HR500-2	511797	1
	MULTISETWORK, HR500-3	511798	1

## 7

**REPLACEMENT PARTS***Up/Down Screw Drive Assembly (Option)*

	<b>MULTISETWORK, HR500-4</b>	<b>511799</b>	<b>1</b>	
	<b>MULTISETWORK, HR500-5</b>	<b>511800</b>	<b>1</b>	
	<b>MULTISETWORK, HR500-6</b>	<b>511801</b>	<b>1</b>	
	SCREEN, HMISTU855 TOUCH	508978	1	
	<b>DRIVE ASSEMBLY, HR500 UP/DOWN SCREW</b>	<b>099042</b>	<b>1</b>	
	<b>MOUNT WELDMENT, HR500 UP/DOWN SCREW DRIVE - COMPLETE</b>	<b>511792</b>	<b>1</b>	
1	MOUNT WELDMENT, HR500 UP/DOWN SCREW DRIVE	099043-1	1	
2	WASHER, 10.5 FLAT ZINC	F81055-1	8	
3	BOLT, M10x30 5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4	
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
5	SWITCH, GLCB01A1B LIMIT	100931	2	
6	WASHER, 4.3 FLAT ZINC	F81051-2	8	
7	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	4	
8	SCREW, M4x40 8.8 HEX SOCKET HEAD CAP ZINC	F81011-37	4	
9	GLAND, DP9/H CABLE	F81096-2	2	
10	CLIP, RSGU 1.15/20 PIPE RETAINING	509701	1	
11	WASHER, 8.4 FLAT ZINC	F81054-1	2	
12	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	1	
13	BOLT, M8X30 8.8 HEX HEAD FULL THREAD ZINC	F81002-7	1	
14	TIE WRAP, TK 9/3	F81082-4	3	
15	GROMMET, 3/8" ID RUBBER	025248	1	
	<b>MOTOREDUCER, UP/DOWN DRIVE - COMPLETE</b>	<b>099057</b>	<b>1</b>	
16	MOTOREDUCER, MR-40/21/0.25-1400/WJ2/B7, B8 BOX	099699	1	
17	SHAFT, MR-40 GEAR BOX OUTPUT	099056	1	
18	KEY, A6x6x30 PARALLEL	094245	2	
19	PLATE, MR-40 MOTOREDUCER MOUNTING	509723-1	1	
20	PULLEY, T10/24-2F W/30 HOLE	099066	1	
21	RING, 30Z OUTSIDE RETAINING	F81090-23	1	
22	WASHER, 6.4 FLAT ZINC	F81053-1	4	
23	KEY, A8x7x20 PARALLEL	099059	1	
24	RING, SEG Z 019 OUTSIDE RETAINING	F81090-20	1	
25	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	6	
26	WASHER, 8.4 FLAT ZINC	F81054-1	8	
27	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4	
28	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	3	
29	PLATE, ENCODER CABLE MOUNT	511794	1	
30	BOLT, M8X40-8.8 HEX HEAD FULL THREAD ZINC	F81002-15	1	
31	TIE WRAP, TK 9/3	F81082-4	3	
	<b>DRIVE PULLEY ASSEMBLY, UP/DOWN SCREW</b>	<b>099058</b>	<b>1</b>	
32	BUSHING, UP/DOWN SCREW DRIVE ZINC-PLATED	099044-1	1	
33	PULLEY, T10/24-2F W/30 HOLE	099066	1	
34	KEY, A8x7x20 PARALLEL	099059	1	
35	RING, 30Z OUTSIDE RETAINING	F81090-23	1	
36	BEARING, 61905 2RS (COMPLEX)	099037	2	
37	PLATE, BEARING HOUSING	512494-1	2	
38	RING, SEG W042 INSIDE RETAINING	F81090-19	2	

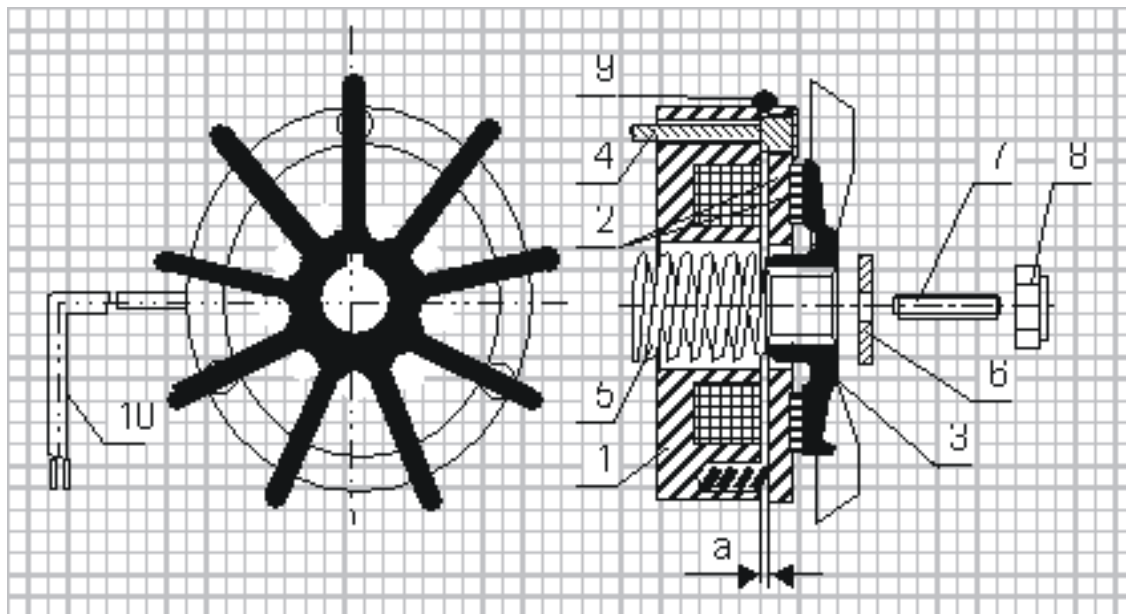
## REPLACEMENT PARTS

*Up/Down Screw Drive Assembly (Option)*

7

39	WASHER, 8.4 FLAT ZINC	F81054-1	4	
40	BOLT, M8X65 8.8 HEX HEAD FULL THREAD ZINC	F81002-9	2	
41	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2	
42	BLOCK, SPACER	512496-1	1	
43	PIN, 5x30 ROLL ZINC	F81044-21	2	
44	BELT, PU 16 T10 560	099061	1	
	<b>ENCODER ASSEMBLY, HR500</b>	<b>509722</b>	<b>1</b>	
45	PLATE, ENCODER MOUNT	509721-1	1	
46	ENCODER, 48 IMP./TURN 12V DC INCREMENTAL	510285	1	
47	BRACKET, ENCODER	507372-1	1	
48	SLEEVE, M6x100- BN3319, (BOSSARD) SPACING	F81031-10	3	
49	WASHER, 6.4 FLAT ZINC	F81053-1	6	
50	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	4	
51	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	6	
52	BOLT, M6x16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	8	
53	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
54	CABLE, 5m SAFETY SWITCH	087652	1	
	<b>GUARD, UP/DOWN DRIVE - COMPLETE</b>	<b>511793</b>	<b>1</b>	
55	GUARD, HR500 UP/DOWN DRIVE	099062-1	1	
56	HANDLE, EPR.90-PF-C1(261051-C1) SNAP-IN FLUSH PULL	100012	2	
57	WASHER, 6.4 FLAT ZINC	F81053-1	3	
58	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	3	
59	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	3	

## SECTION 8 DC ELECTROMAGNETIC BRAKE



- 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.

### 8.1 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.

## 8.2 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

We herewith declare,

Wood-Mizer Industries sp. z o.o.  
114 Nagorna street, 62-600 Kolo; Poland.

That the following described machine in our delivered version complies with the appropriate basic 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.

Designation of the machine:	<b>Horizontal Resaw</b>
TYPE:	HR
Models:	HR500EH11S-1/6; HR500EH15S-1/6
No. of manufacturer:	.....
Applicable EC Directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2004/108/EC
Applicable Harmonized Standards:	PN-EN 1807-2:2013 PN-EN 60204-1:2010 PN-EN 13849-1:2008
Notified Body according to annex IV :	TUV SUD Product Service GmbH Gottlieb-Daimler Strasse 7 70794 Filderstadt
Notification No	0123
Responsible for:	EC type examination
EC type-examination certificate no.	M8A100755286015
Date of CE marked affixed	2010-07-20
Responsible for Technical Documentation:	Adam Kubiak / R&D Manager  Wood-Mizer Industries Sp. z o.o. 62-600 Koło, ul. Nagórna 114 Tel. +48 63 26 26 000
Date/Authorized Signature:	23.09.2010 <b>Adam Kubiak</b>
Title :	R&D Manager