

## user manual

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

Retain for future use  
Zachować do przyszłego użytku  
Сохраните для последующего  
использования  
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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  
Behåll för framtida användning  
Uchovajte pro další použití  
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# **Wood-Mizer®**

**Safety, Setup, Operation, Maintenance  
& Parts Manual**

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**XC100 EH5S**

**rev. A1.00**

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

*Form #1027*

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

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## Getting Service

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

### *General Contact Information*

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### **Office Hours:**

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

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

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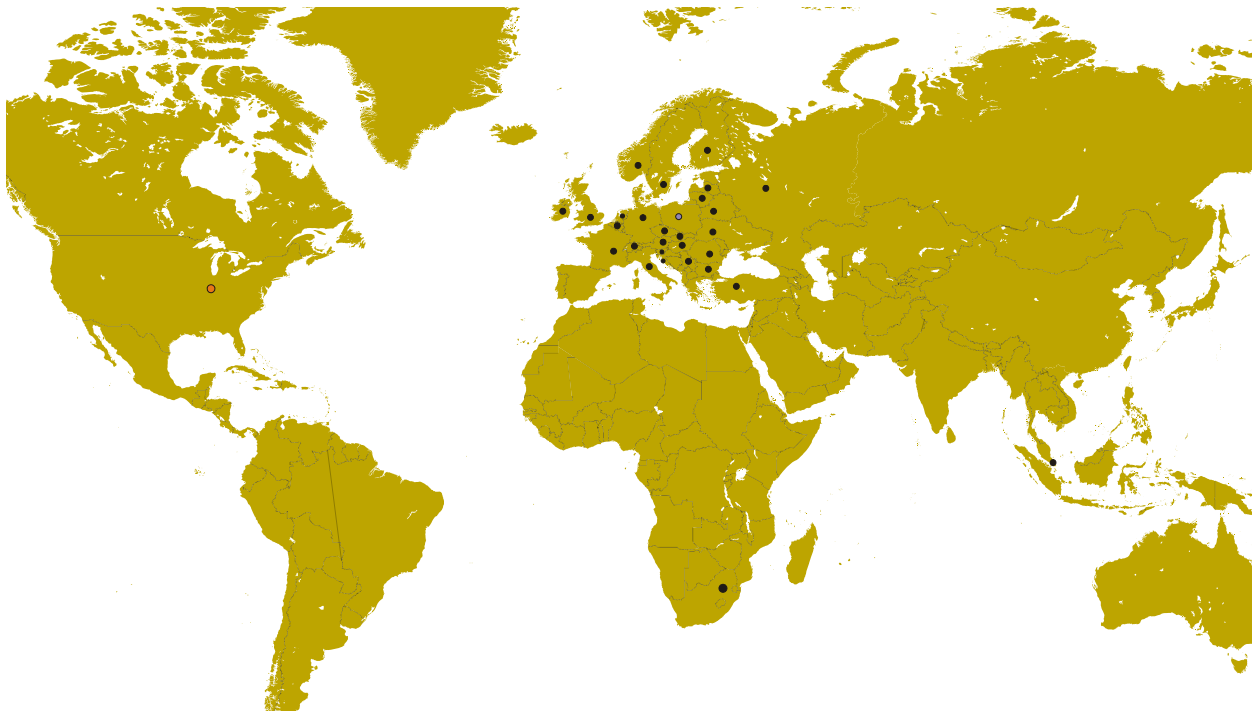
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Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

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

## SECTION 1 INTRODUCTION

Thank you for choosing Wood-Mizer wood processing equipment!

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

The present documentation contains information that should be used when preparing the machine for operation, working with it and when servicing or repairing it, as well.

### 1.1 Machine Description

The Wood-Mizer cross-cut sawing machine is designed for cross cutting of boards with dimensions listed in Section [5.2 XC100 Sawing Machine Specifications](#). The machine must not be used for other purposes!

Using the machine correctly, you will obtain a high degree of accuracy and ensure maximum personal safety.

The cross-cut sawing machine should be operated only by an adult who has read and understood the entire operator's manual.

The machine is built to be durable and easy to operate and maintain.

### 1.2 Machine and Site Preparation

Due to the weight, the cross-cut sawing machine has to be transported with auxiliary carrier equipment and in accordance with general safety rules.

To ensure safe operation of the machine, the work-place dimensions should be 3 m x 7 m. The work-place must be protected from precipitation.

### 1.3 Major Machine Components

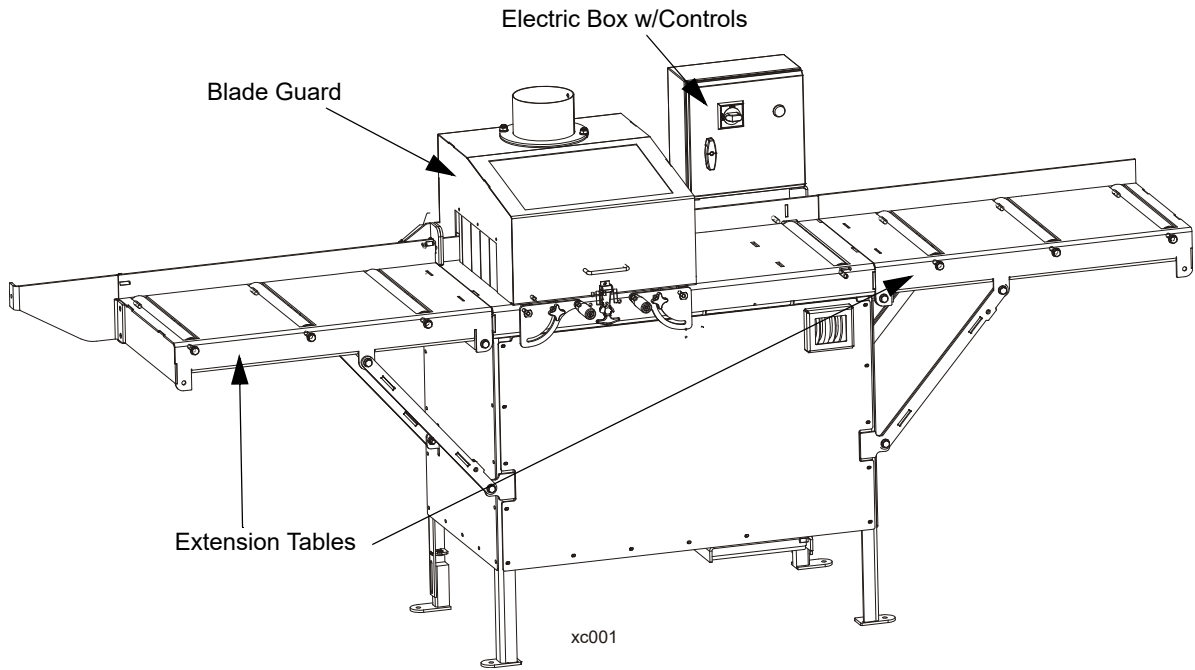




FIG. 1-1 XC100


## SECTION 2 SAFETY


### 2.1 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.

### 2.2 Safety Instructions

**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 cross-cut sawing machine. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with the 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 sawing machine.

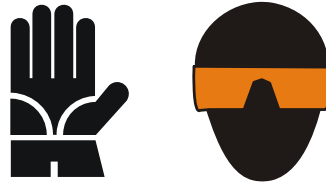
**IMPORTANT!** It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of the cross-cut sawing machine. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws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



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

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


**WARNING!** Always wear gloves and eye protection during operation. Failure to do so may result in serious injury.



**WARNING!** Always wear ear, respiration and foot protection when operating the machine.



### ***Keep The Sawing Machine And Area Around Clean***

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

### ***Dispose Of Sawing By-Products Properly***



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

### ***Check The Sawing Machine Before Operation***



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



**WARNING!** Always shut off the motor to stop the blade whenever the machine is not in use. Failure to do so may result in serious injury.

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

### ***Keep Persons Away***



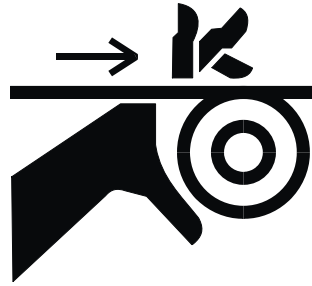
**DANGER!** Keep all persons at a safe distance of at least 3 meters from the machine when operating the cross-cut sawing machine. Failure to do so will result in serious injury.

### ***Keep Hands Away***

**DANGER!** Moving Parts Can Crush and Cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating. Failure to do so may result in serious injury.

**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, blade, 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!** Coastdown Required. Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

**DANGER!** Before changing the blade or performing any service to the machine, disconnect the power cord from the electric box.

**IMPORTANT!** The blade guard is equipped with a safety key switch. As soon as you open the cover, the motor will turn off and all moving parts will stop spinning. The safety switch should always be in proper working condition.

### **Sawing Machine Operation**



**CAUTION!** Always operate the sawing machine in good light conditions. The illumination at the operator's position should be at least 300 lx. Never operate the machine under the influence of alcohol or drugs.



**WARNING!** Make sure the blade guard is closed and secured before starting the motor.



**IMPORTANT!** When starting the sawing machine for the first time, check if the pulley rotation direction is as indicated by the arrow located at the pulley inspection window. If the direction is incorrect, invert the phases in the phase inverter located in the power socket (in the electric box). Setting the phases in the phase inverter correctly will ensure the correct blade rotation direction.



**DANGER!** Do not for any reason check the rotation direction by touching the blade with any tool. Doing so may result in serious injury or death.

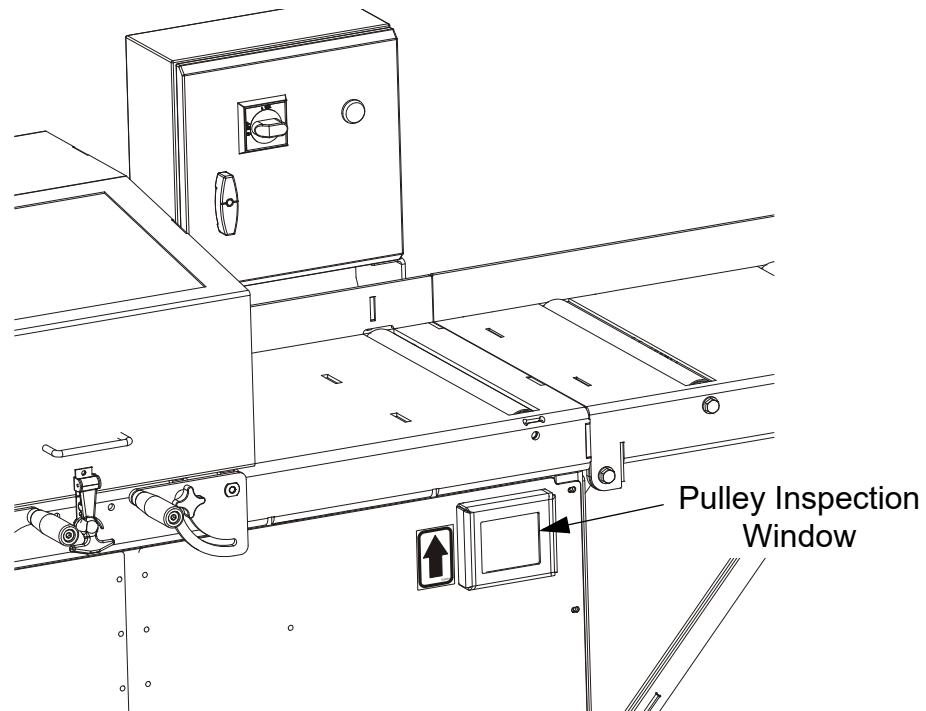




FIG. 2-1

### 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 machine operation.



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

**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.



**IMPORTANT!** The cross-cut sawing machine is equipped with an emergency stop button. This button is used to immediately stop the motor in hazardous situations. The emergency stop button should always be in proper condition.

**IMPORTANT!** The sawing machine must not be modified by the owner. Use only original spare parts.

### ***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.

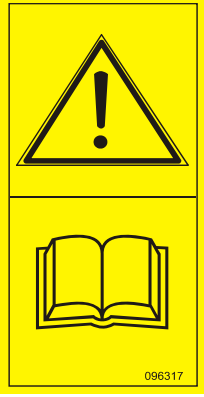


### ***Fire-Fighting***

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

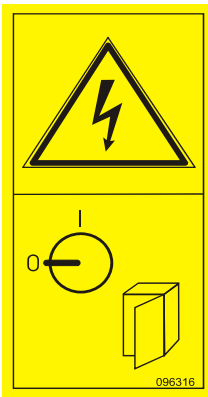
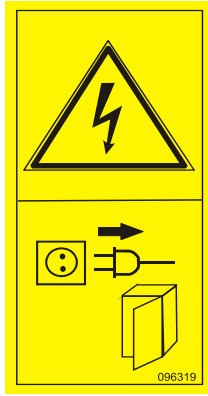


**Safety Labels Description (Included In Kit #514061)**

**See Table 2-1** See the table below for descriptions of the safety labels located on the cross-cut sawing machine.

**TABLE 2-1**

Label View	Label No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the cross-cut sawing machine. Observe all safety instructions and rules when operating the machine.
	099220	Close all guards and covers before starting the machine.
	099221	CAUTION! Keep all persons a safe distance away from work area when operating the machine.

**TABLE 2-1**

	<p>096316</p>	<p>Do not open or close the electric box when the switch is <b>not</b> in the “0” position.</p>
	<p>096319</p>	<p>Always disconnect the power cord before opening the electric box.</p>
	<p>509255</p>	<p>Keep hands away from all rotating components.</p>
	<p>S12004G</p>	<p>Always wear eye protection when operating this machine.</p>

**TABLE 2-1**



	<p>S12005G</p>	<p>Always wear ear protection when operating this machine.</p>
	<p>501465</p>	<p>Always wear safety boots when operating this machine.</p>
	<p>512107</p>	<p>Always wear protective gloves when operating this machine.</p>
	<p>501467</p>	<p>Lubrication point</p>
	<p>089296</p>	<p>Rotation direction</p>
	<p>P85070</p>	<p>CE certified machine</p>

TABLE 2-1

 <p><b>6 bar</b> <b>0.6 MPa</b> 513181</p>	513181	Pneumatic system pressure value
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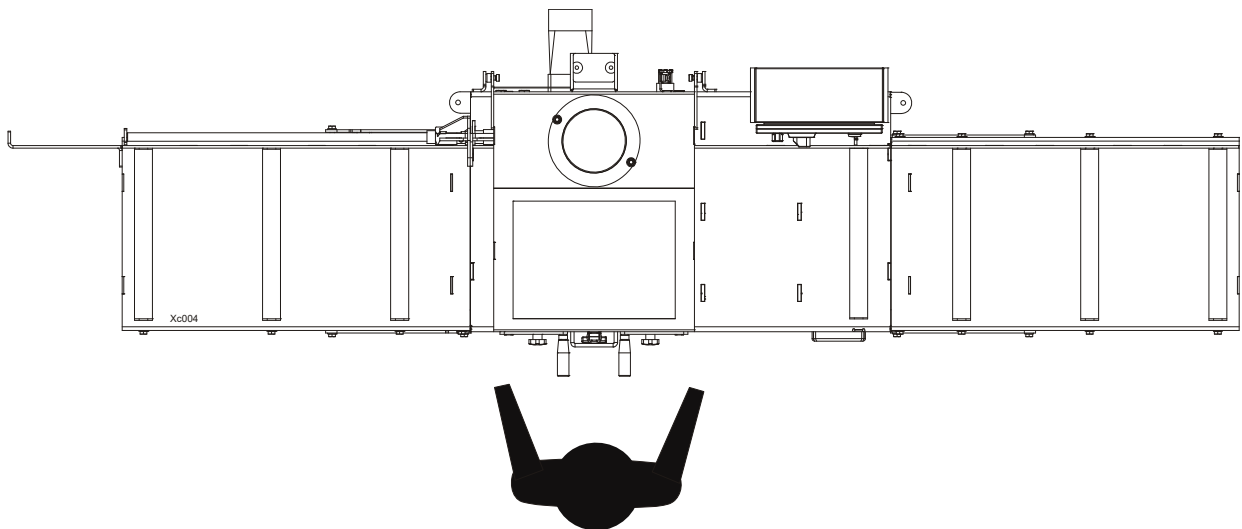
## SECTION 3 SETUP & OPERATION

### 3.1 Setup



**IMPORTANT!** Before starting to use the cross-cut sawing machine, you have to meet the following conditions:

- Set up your sawing machine on firm and level ground. Level the machine. Then secure the machine to the ground to prevent moving during operation. A concrete foundation with 16 mm diameter anchored bolts is recommended.
- The cross-cut sawing machine must not be operated indoors without a sawdust collection system connected and started.
- The machine should be used under a roof only.
- The machine should be operated in the temperature range of  $-15^{\circ}\text{C}$  to  $40^{\circ}\text{C}$  ( $5^{\circ}\text{F}$  to  $104^{\circ}\text{F}$ ) only.
- The illumination at the operator's position should be at least  $300\text{lx}^1$ .
- The operator's position is shown in the figure below.



---

1. The light source can not cause the stroboscopic effect.

See Table 3-1. 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.

3-phase V	Fuse Disconnect Switch	Recommended Cable Size
400 VAC	10 A	2.5 mm <sup>2</sup> to a length of 15 m

TABLE 3-1



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

## 3.2 XC100 Sawing Machine Operation

### 3.2.1 Control Overview

See Figure 3-1. The figure below shows all controls of the XC100 sawing machine that are located on the electric box.

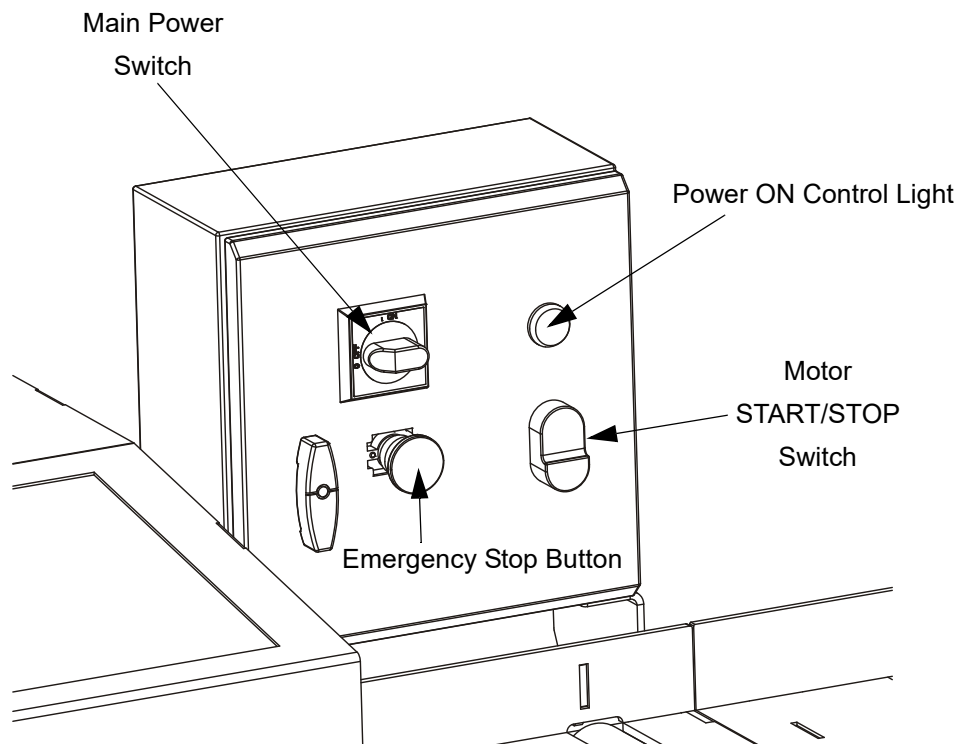


FIG. 3-1

#### 1. Motor START/STOP Switch

Starts and stops the blade motor. The motor will be started if the blade guard is closed.

#### 2. Main Power Switch

Disconnects power supply to all electrical circuits of the machine.

### 3. Power On Control Light

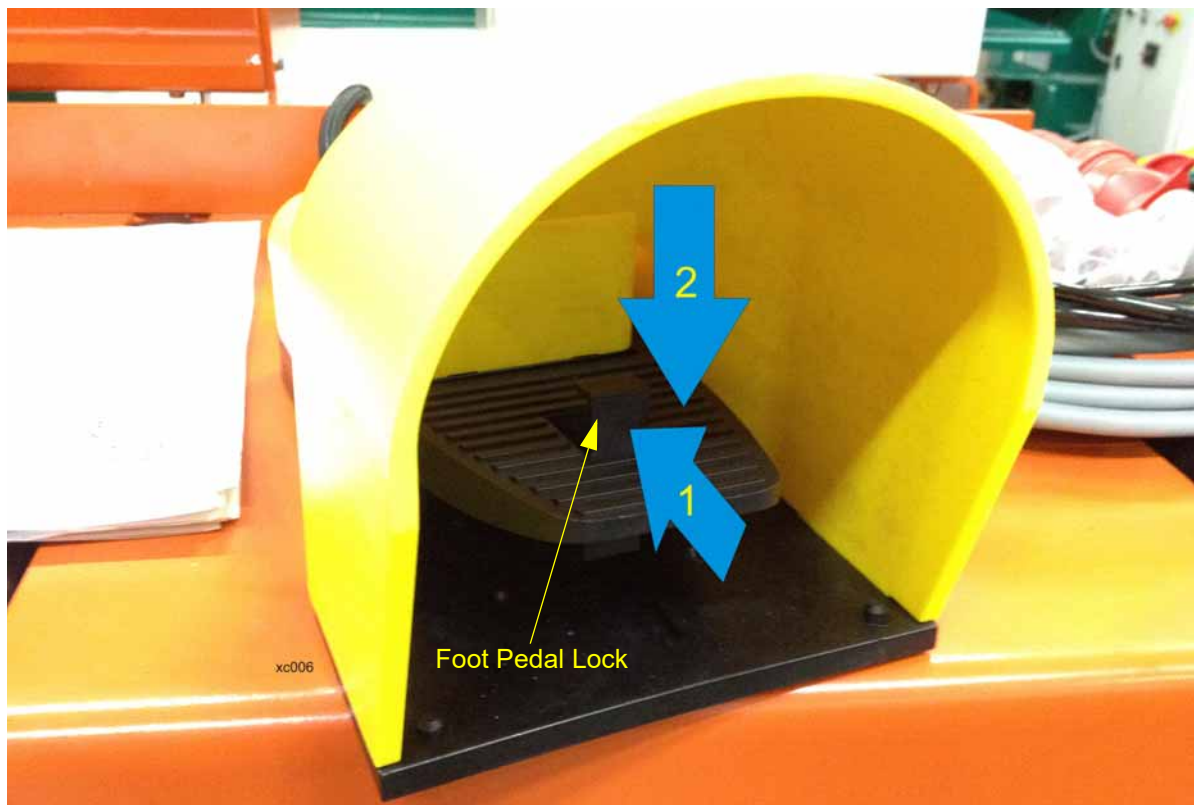
Indicates that the power supply is turned on.

### 4. Emergency Stop Button

In case of any danger or sawing machine malfunction, press the emergency stop button. Turn the emergency stop clockwise to release the stop. The machine will not restart until the emergency stop is released.

### 5. Foot Pedal

**See Figure 3-2.** To make a cut, insert your foot into the foot pedal guard releasing the foot pedal lock (pushing it forward) and press down the foot pedal.



**FIG. 3-2**

## 3.3 Machine Start-Up



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

- Connect the air supply.



- Close or mount all guards and covers.



**WARNING!** Before starting the motor, make sure the blade guard is closed and secured.

- Check if the material to be cut is of a proper size (see the section “Specifications” for the required material dimensions).
- Make sure that all persons are at a safe distance from the machine.
- Turn on the dust extraction system.
- Check if the emergency stop button is released.




**CAUTION!** The sawing machine will not start until the emergency stop button is released.

**To start cutting:**

1. Turn the main switch located on the electric box to the ON position.
2. Using the START button, start the blade motor.
3. Insert the material into the blade guard (from the right side). Using the scale on the guide bar, set the material to the desired dimension.
4. Press down the foot pedal to make the cut. As soon as the foot pedal is depressed, the hold-down unit will be activated and then the blade will raise to make the cut. When the cut is made, the blade will lower and the hold-down unit will be released.

## SECTION 4 MAINTENANCE

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

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



### 4.1 Wear Life

**See Table 4-1.** This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. Due to many variables which exist during machine 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
Drive Belts	1000 hours

*TABLE 4-1*

### 4.2 Sawdust Removal

-  1. Remove sawdust and wood chips from the inside of the upper blade guard and the lower blade guard every eight hours of operation. Use compressed air or a brush to do this.
-  2. Remove any sawdust and sap buildup from the rollers on the extension tables every eight hours of operation.

### 4.3 Miscellaneous Maintenance

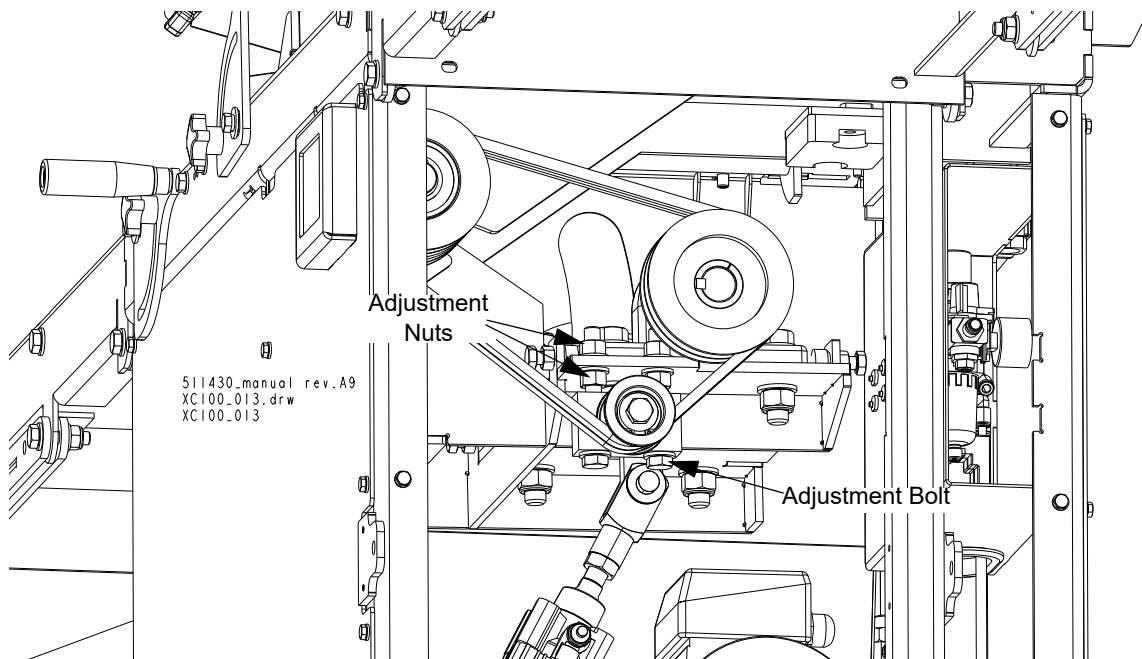
-  1. Apply grease to all lubrication points of the machine every 250 hours of operation.

## 4.4 Drive Belt Tension Adjustment

50

Check if the drive belts are tensioned properly - after the first 20 hours of operation, and every 50 hours thereafter.

1. First, check the reducer belts and adjust if necessary. To do this, loosen two of the four adjustment nuts. Use the remaining adjustment nuts to adjust both belts so there is 10 mm (0.393") deflection with a 3 kg (30N) deflection force.



**FIG. 4-1**

2. Next, check the blade motor drive belts and adjust if necessary. To do this, remove the side guard. Then loosen the four retaining nuts. Use the two adjustment bolts to adjust both belts so there is 10 mm

# 4

## MAINTENANCE

### Drive Belt Tension Adjustment

(0.393") deflection with a 3 kg (30N) deflection force.

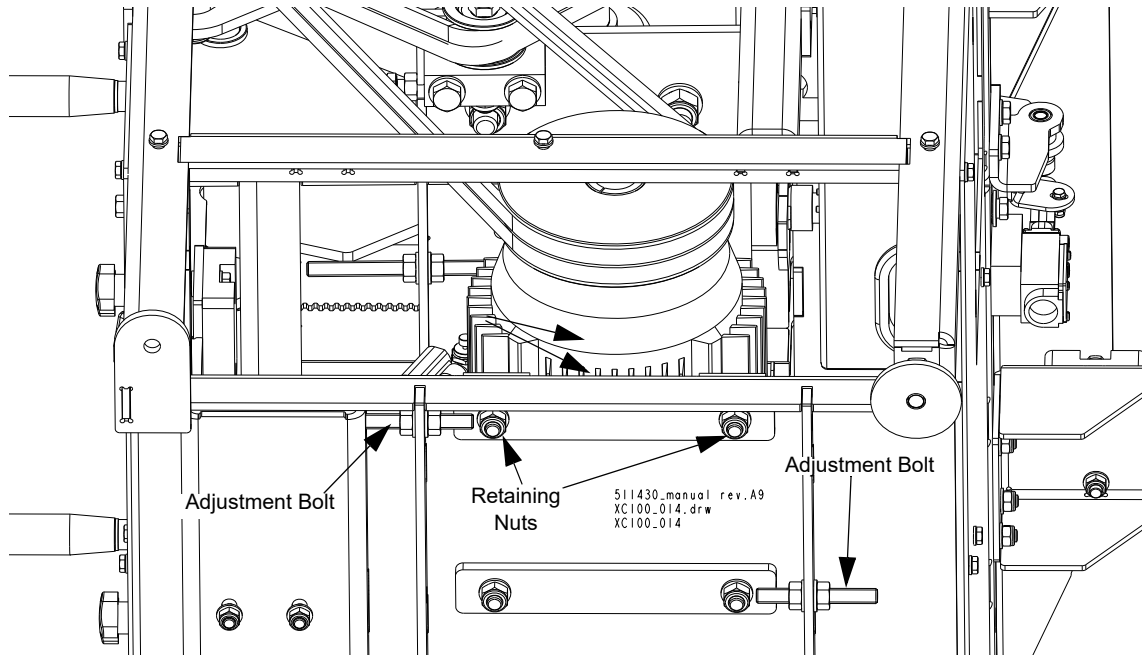


FIG. 4-2



**CAUTION!** After replacement of the drive belts, adjust their tensions as described above. Then start the motor for five minutes and check the tensions again.

If either of the reducer belts or motor belts is damaged, replace both reducer/motor belts as a pair.

### 4.5 Blade Replacement

If the blade is dulled or damaged, dismount it and replace with a new one (see the table 5-6 for the blade specifications). To do this, raise the blade guard, loosen the star knobs and open the door using the handle (see the figure below). Then, using the provided blade wrenches, remove the mounting nut simultaneously holding the bushing located on the shaft on the other side of the blade. Remove the blade from the shaft and install a new one. Tighten the mounting nut.

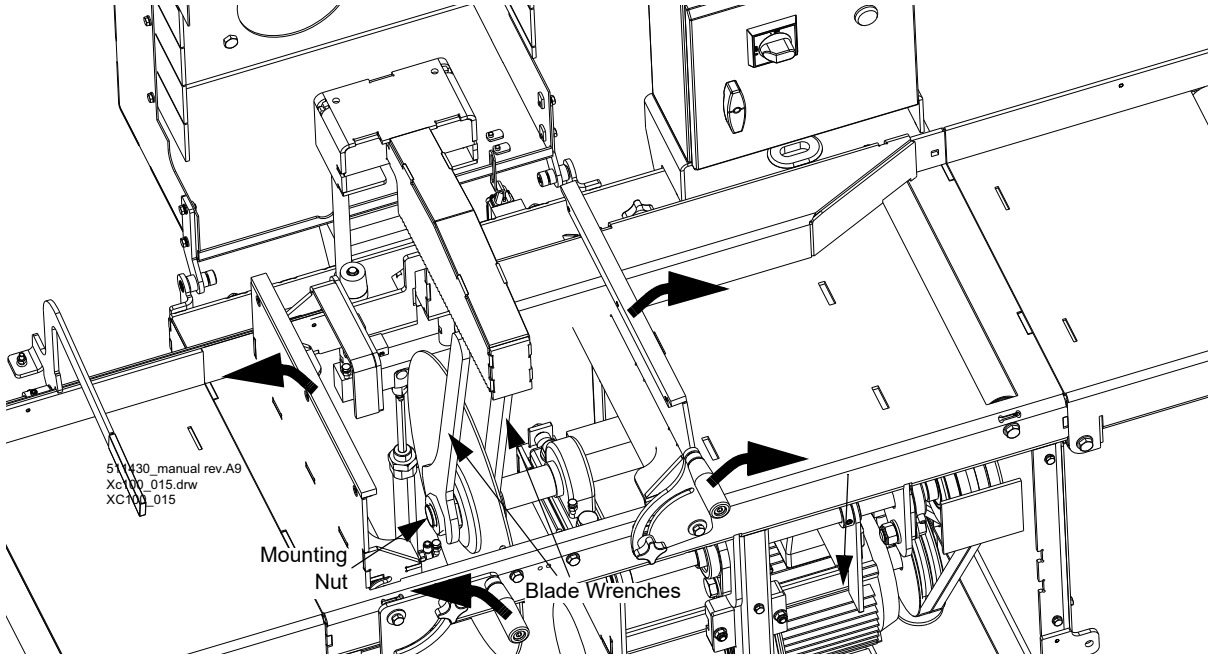


FIG. 4-3

## 4.6 Long-Term Storage

If the machine is not used for a long period of time, do as follows:

- Disconnect the power cord.
- Perform all maintenance procedures described in this section.
- Dismount the blade. Store the blade well lubricated at temperatures above 0°C.
- Loosen the motor drive belts.
- Spray a thin layer of a rust preventive (eg., P.D.R.P) onto all corrodible places.
- Store the machine in a well ventilated room.

## 4.7 Safety Devices Inspection

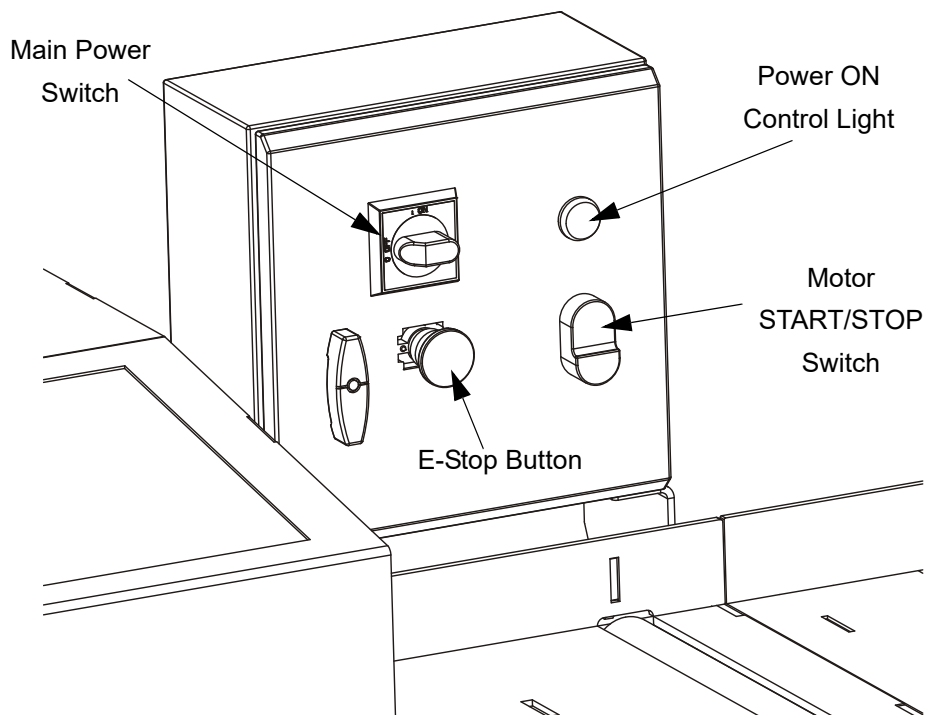
### *XC100E5S Cross-Cut Sawing Machine – Safety Devices Inspection*

The following safety devices of the sawing machine should be checked before each shift:

- Emergency stop button and its circuit,
- Safety switch, located on the blade guard, and its circuit.

#### 1. E-STOP button and its circuit inspection

- Turn the main switch located on the electric box to the ON position;
- The white power control light should come on;
- Press the START button. The blade motor should start.
- Push the emergency stop button located on the electric box. The blade motor should turn off. Pushing the START button should not start the motor until the E-STOP button is released and the START button is pressed again.



#### 3. Safety switch (on the blade guard) and its circuit inspection

- Turn the main switch located on the electric box to the ON position;

# 4

## MAINTENANCE

### *Safety Devices Inspection*

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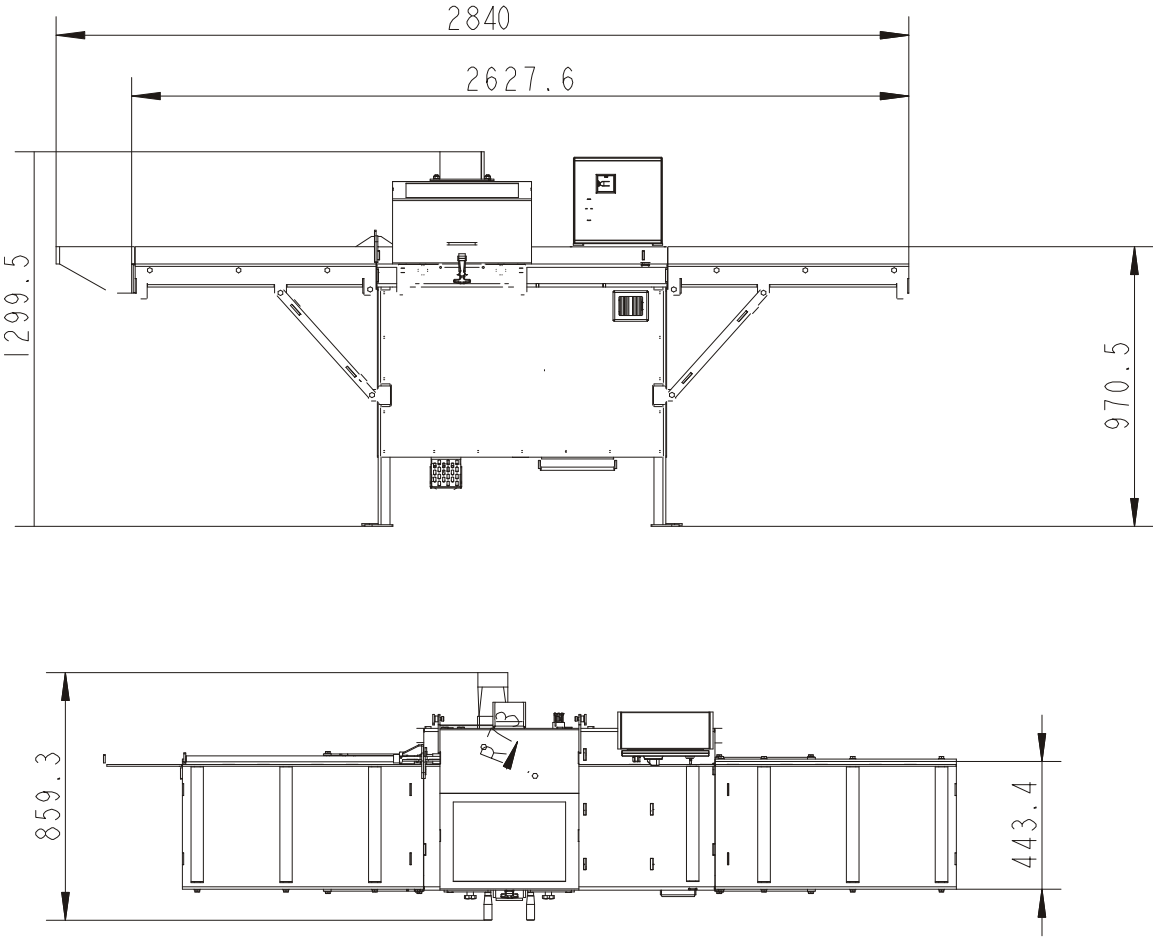
- The white power control light should come on;
- Press the START button. The blade motor should start.
- Open the blade guard;
- The blade motor should turn off;
- Check if the motor can be started. The motor should remain turned off.
- Close the blade guard;
- The motor should remain turned off until it is restarted by pressing the START button.



# SECTION 5 SPECIFICATIONS

## 5.1 Overall Dimensions

See Figure 5-1. The major dimensions of the XC100 cross-cut sawing machine are shown below (all dimensions are in millimeters).



xc002  
wymiar\_y\_gabaryt\_xc100.drw

FIG. 5-1 XC100

See Table 5-1. See the table below for overall dimensions and weight of the XC100 sawing machine.

Machine Type	XC100
Weight	360 kg
Height	1300 mm
Width	859 mm
Length	2840 mm

TABLE 5-1

## 5.2 XC100 Sawing Machine Specifications

See Table 5-2. The nomenclature of the Wood-Mizer cross-cut sawing machines is given in the table below.

	Voltage
XC100EH5S	3 ph 400V CE
XC100EH5	3 ph 400V

TABLE 5-2

See Table 5-3. See the table below for specifications of the XC100 sawing machine motor.

	Motor Specifications
Motor Type	E5 Electric Motor
Manufacturer	Indukta, Poland
Rated Voltage	400V 50Hz
Rated Current	8.9A
Rated Revolutions	1415 r.p.m.
Rated Power	4kW (5.4 HP)
International Protection Rating	IP55
Manufacturer Part No.	PSg 100L-4
Wood-Mizer Part No.	511482

TABLE 5-3

**See Table 5-4.** The level of noise generated by the XC100 cross-cut sawing machine is given below.<sup>1 2</sup>

<b>XC100 Sawing Machine equipped w/E5 electric motor</b>	<b>Noise Level</b> $L_{pA} = 81 \text{ dB (A)}$
--	--

**TABLE 5-4**

**See Table 5-5.** The material size capacities of the XC100 machine are listed below.

<b>Maximum board dimensions (height/width)</b>	60x200 mm
<b>Maximum cant/log dimension</b>	100 mm <sup>1</sup>
<b>Maximum log/board length</b>	1200 mm
<b>Minimum log/board length</b>	600 mm

**TABLE 5-5**

<sup>1</sup> It is possible to cut a 100x100mm material provided that the material is centered with the blade (to center the material, use an optional spacer - WM Part No. 514109).

**See Table 5-6.** See the table below for specifications of the circular blade used on your XC100 sawing machine.

<b>Blade Specifications</b>	
<b>Blade Diameter</b>	400mm
<b>Number of Teeth</b>	48
<b>Blade Type</b>	for cross cutting

**TABLE 5-6**

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

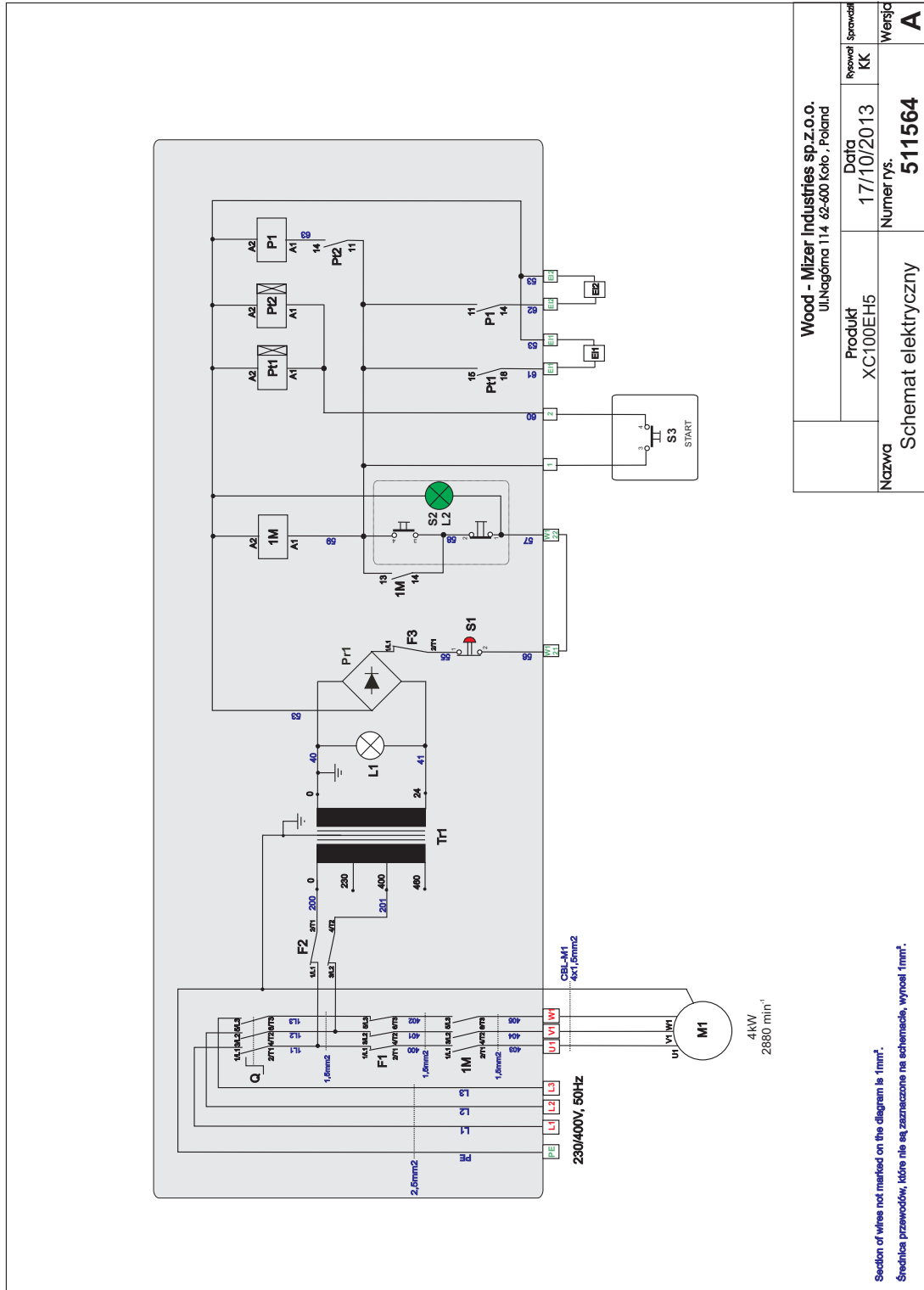
### 5.3 Compressed Air Supply

See Table 5-7. Required parameters of the compressed air supply are given in the table below.

Air Supply Parameters	Pressure	Purity Class According To ISO 8573-1:2001
XC100	at least 6 bar	3

**TABLE 5-7**

### 5.4 Electrical Diagram, XC100EH5S



**FIG. 5-1**

## 5.5 Electrical Components, XC100EH5S

Symbol	Description	Manufacturer	Wood-Mizer Part No.
Q	SWITCH, ABB OT16F3	ABB	503541
F1	BREAKER, Gz1 M14 MOTOR CIRCUIT	SCHNEIDER ELECTRIC	509148
F2	BREAKER, iC60N 2P 1A C CIRCUIT	SCHNEIDER ELECTRIC	093905
F3	BREAKER, iC60N 1P 2A C CIRCUIT	SCHNEIDER ELECTRIC	088278
1M	CONTACTOR, LC1D18 BD	SCHNEIDER ELECTRIC	092476
Pt1	RELAY, 80.61.0.240.2000 TIMER	FINDER	091688
Pt2	RELAY, 40.52.9.024.00.00 SOCKET, TYPE 40.95.05 RELAY MODULE, 86.20.0.024.0000 TIMER	FINDER	090515 090515-1 097612
P1	RELAY, 40.52.9.024.00.00 SOCKET, TYPE 40.95.05 RELAY	FINDER	090515 090515-1
TR	TRANSFORMER, SU78A-230400/24	NORATEL	094487
Pr1	RECTIFIER, KBPC 3508 BRIDGE		084318
L1	LIGHT, M22-L-W CONTROL	MOELLER	090448
S1	BUTTON, XB7 ES542 EMERGENCY STOP	SCHNEIDER ELECTRIC	502315
S2	SWITCH, M22 START/STOP DDL-GR-X1/X0/K11/230-W	MOELLER	090452
S3	SWITCH, IP7007 FOOT W/GUARD	GIOVENZANA	512118
W1	SWITCH, GSCA 01S2 SAFETY	HONEYWELL	088836
EL1, EL2	VALVE, SY5120-5Y0-0IF SOLENOID	SMC	510071

## 5.6 Sawdust Extractor Specifications

**See Table 5-8.** See the table below for specifications of a sawdust extractor that should be connected to your Wood-Mizer cross-cut sawing machine.

<b>Airflow</b>	1200 m <sup>3</sup> /h 3937ft <sup>3</sup> /h
<b>Inlet diameter</b>	100 mm (5.9")
<b>Motor power</b>	1.5 kW
<b>Number of sacks</b>	2
<b>Sack capacity</b>	0.25 m <sup>3</sup> (8.8 ft) <sup>3</sup>
<b>Weight</b>	110 kg (242.5 lb)
<b>Conveying speed when 10 m long hose is used</b>	20 m/s 65.6 ft/s

**TABLE 5-8**

## 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>Down-cutting cross-cut sawing machine</b>
Type:	XC100EH5S
No. of manufacturer:	.....
Applicable EC Directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2004/108/EC
Applicable Harmonized Standards:	PN-EN ISO 12100:2012 PN-EN 1807-5+A2:2013 PN-EN 13849-1:2008 PN-EN 60204-1:2010 PN-EN ISO 13857:2010
Notified Body:	INSTYTUT TECHNOLOGII DREWNA Centrum Certyfikacji Wytrobów Przemysłu Drzewnego ul. Winiarska 1, 60-654 Poznań
Notification No	1583
Responsible for:	EC type examination
EC type-examination certificate no.	380/2014
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:	07.04.2014 <b>Adam Kubiak</b>
Title:	R&D Manager