

Transfer Deck

Safety, Operation, Maintenance & Parts Manual

TD1

rev. A1.00 - A4.00



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

Form #1062

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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

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 transfer deck. 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 persons who have read and understood the entire operator's manual should operate the transfer deck. The transfer deck 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, operation of your Wood-Mizer products. All Wood-Mizer product owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.



KEEP TRANSFER DECK AND AREA AROUND TRANSFER DECK CLEAN




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

CAUTIONS FOR TRANSFER DECK SETUP


WARNING! Securely fasten the feet of the transfer deck to the floor before operating the machine. Failure to do so may result in serious injury or death.

CHECK TRANSFER DECK BEFORE OPERATION

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



KEEP PERSONS AWAY

 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating transfer deck. Failure to do so may result in serious injury or death.

USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND MAINTENANCE



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.



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.

SECTION 2 GENERAL INFORMATION

2.1 Transfer Deck Components

The Transfer Deck (TD1) enables to change the direction of material flow. The transfer deck is also equipped with the kicker system allowing you to separate boards and cants. The following instructions will guide you in installation, operation, and alignment of the Transfer Deck.

 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating transfer deck. Failure to do so may result in serious injury or death.

See Figure 2-1. The main components of the Transfer Deck are shown below.

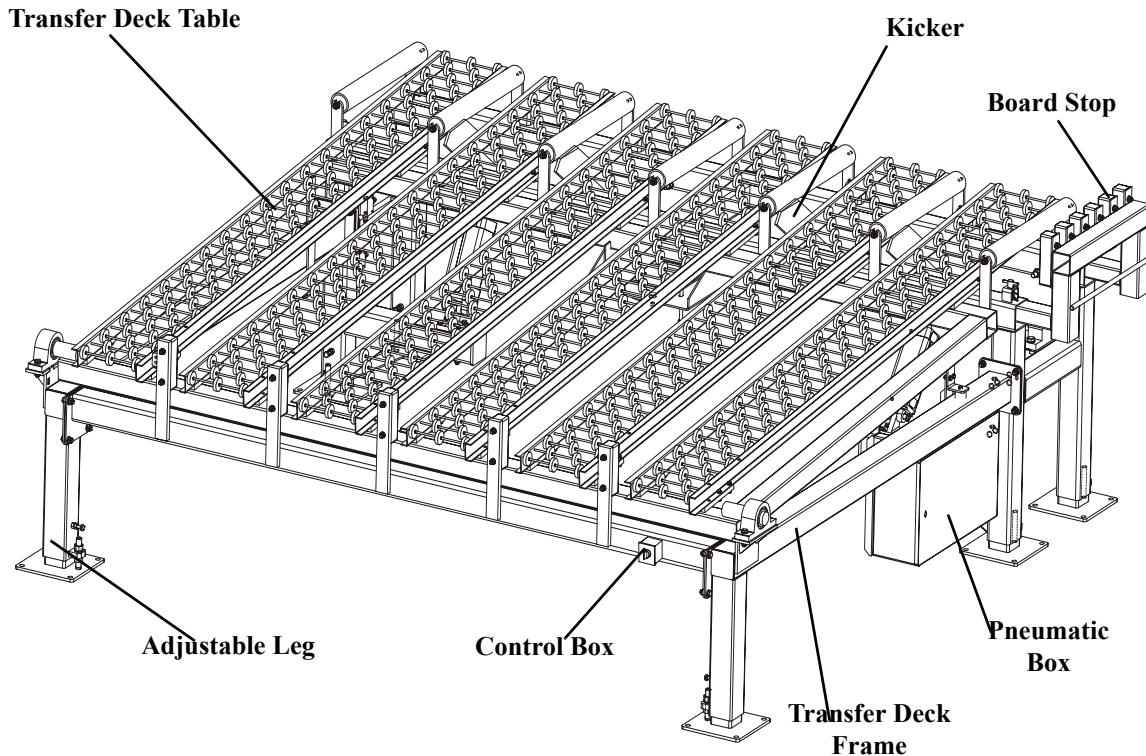


FIG. 2-1

SECTION 3 PNEUMATIC CONTROL BOX

3.1 Technical Data

See Table 3-1.

Duty Cycle	Continuous operation
Weight	17 kg
Working Medium	Compressed air
Maximum Pressure	0,9 MPa
Working Pressure	0,6 MPa
Filter Porosity	40 μ m
Temperature	0°C do +50°C
Supply Voltage For Solenoid Valves	24 V DC +/- 10%

TABLE 3-1

3.2 Connecting The Control Box

When delivered, the control box is completely assembled and tested for air tightness and electrical connection.

Perform the following steps to get the control box ready for work:

- connect compressed air to the ball valve,
- connect the control box to the pneumatic system,
- connect the control system to the terminal block,
- open the ball valve and set the working pressure to .6 MPa,
- fill the lubricator with oil (insert the end of the lubricator hose into a container with oil, push the red button, fill the lubricator up to the line marked on it and release the red button).

3.3 Maintenance

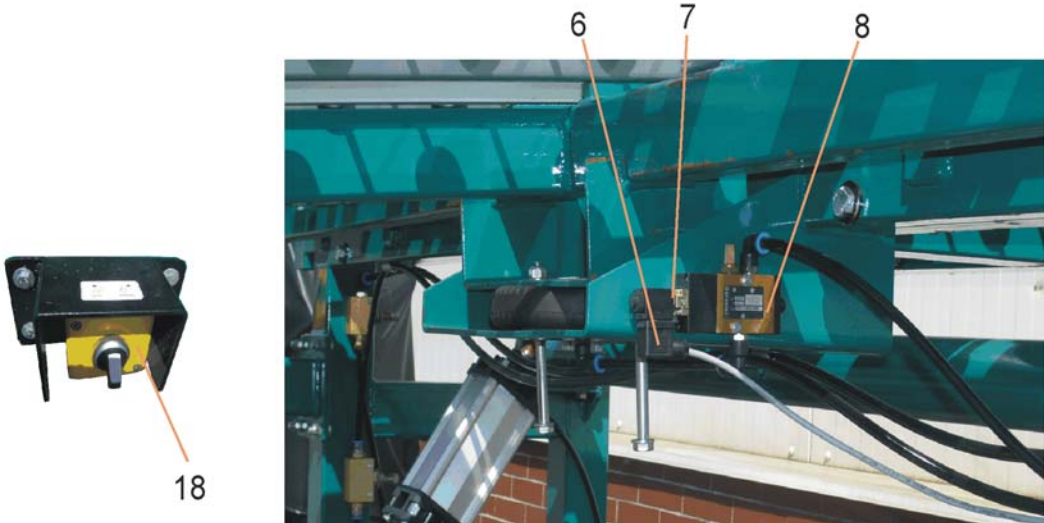
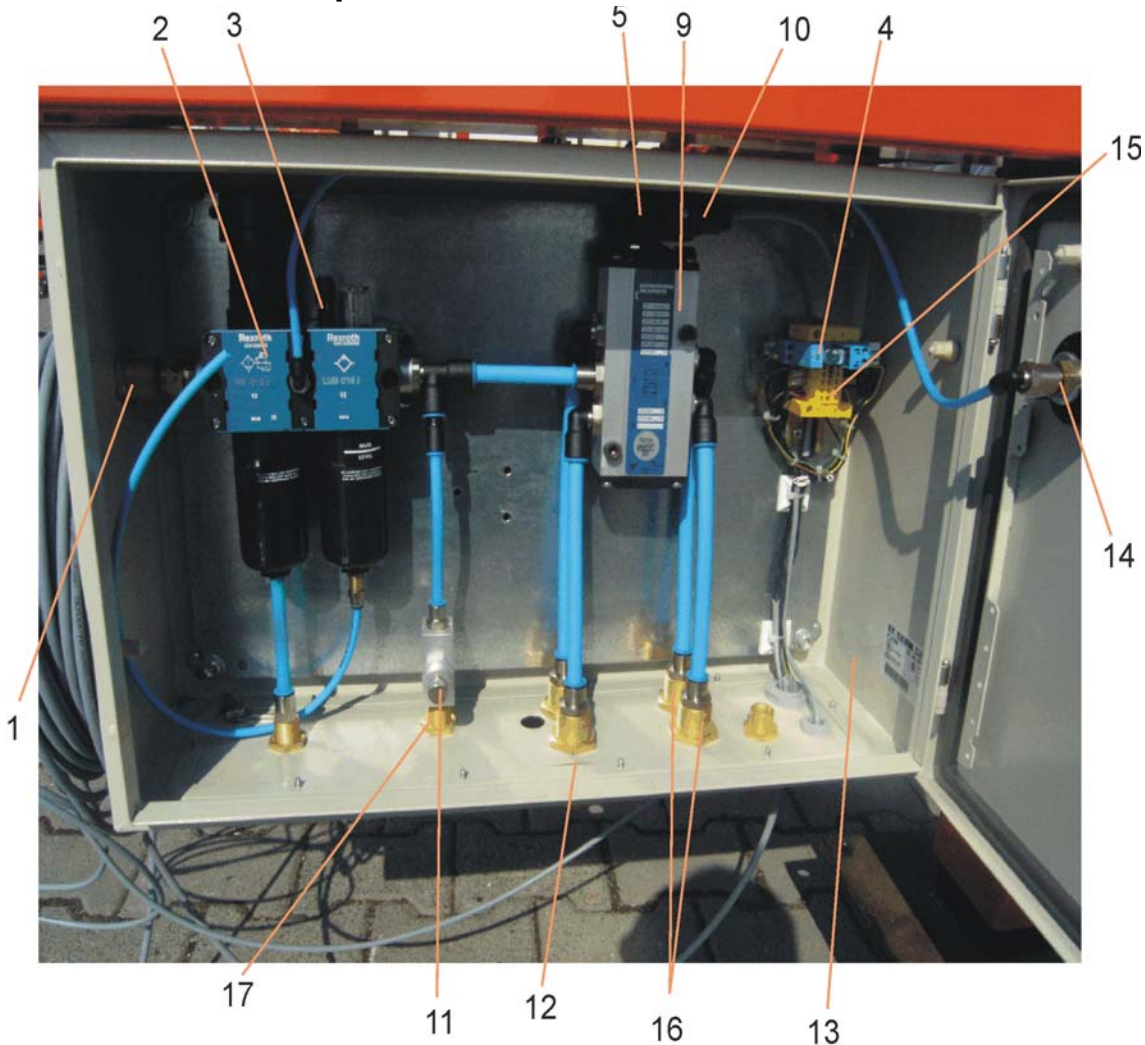
Follow the following instructions to ensure proper control box functioning:

- Check the lubricator oli level every month. Add oil as necessary.
- Always check the working pressure after connecting the control box. If necessary, adjust it with the knob on the filter regulator.
- Every month make sure the filter cartridge is clean. Replace the cartridge if it is very dirty.

3.4 Quickly-Wearing Components

- **Filter Cartridge**

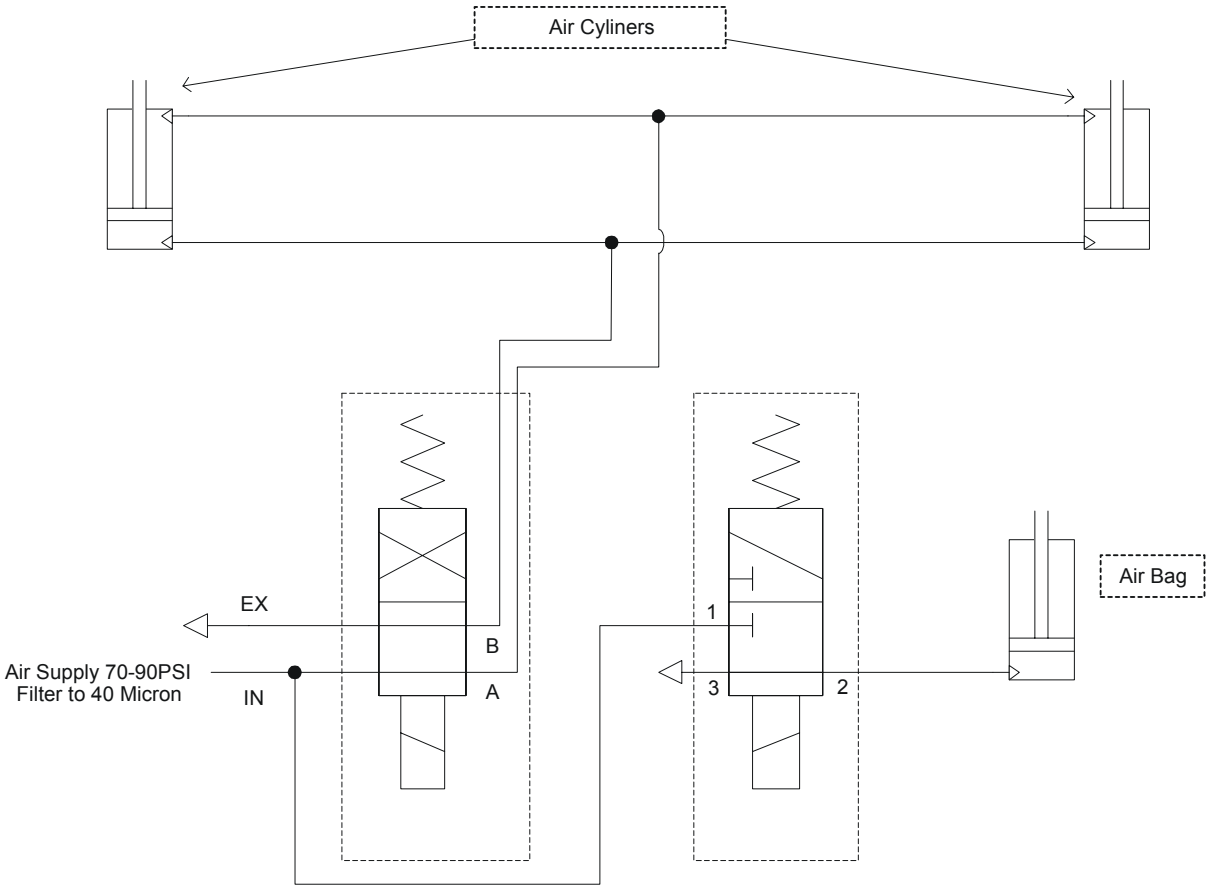
3.5 Control Box Components



- 1 - Ball Valve,
- 2 - Air Service Assembly,
- 3 - Lubricator,
- 4 - Time Relay,
- 5 - Coil, 24V DC,
- 6 - Electrical Connector,
- 7 - Mechanical Pressure Switch,
- 8 - Solenoid Valve, 3/2 G1/4" 24V DC Monostable,
- 9 - Solenoid Valve, 5/2 G1/2" 24V DC Monostable,
- 10 - Connector,
- 11 - Choke Valve,
- 12 - Silencer,
- 13 - Metal Box,
- 14 - Pressure Gauge (located on the box door),
- 15 - Terminal Block,
- 16 - Fitting For Air Cylinder Manifolds,
- 17 - Fitting For Air Bag.
- 18- Control Console (WM# 095006)

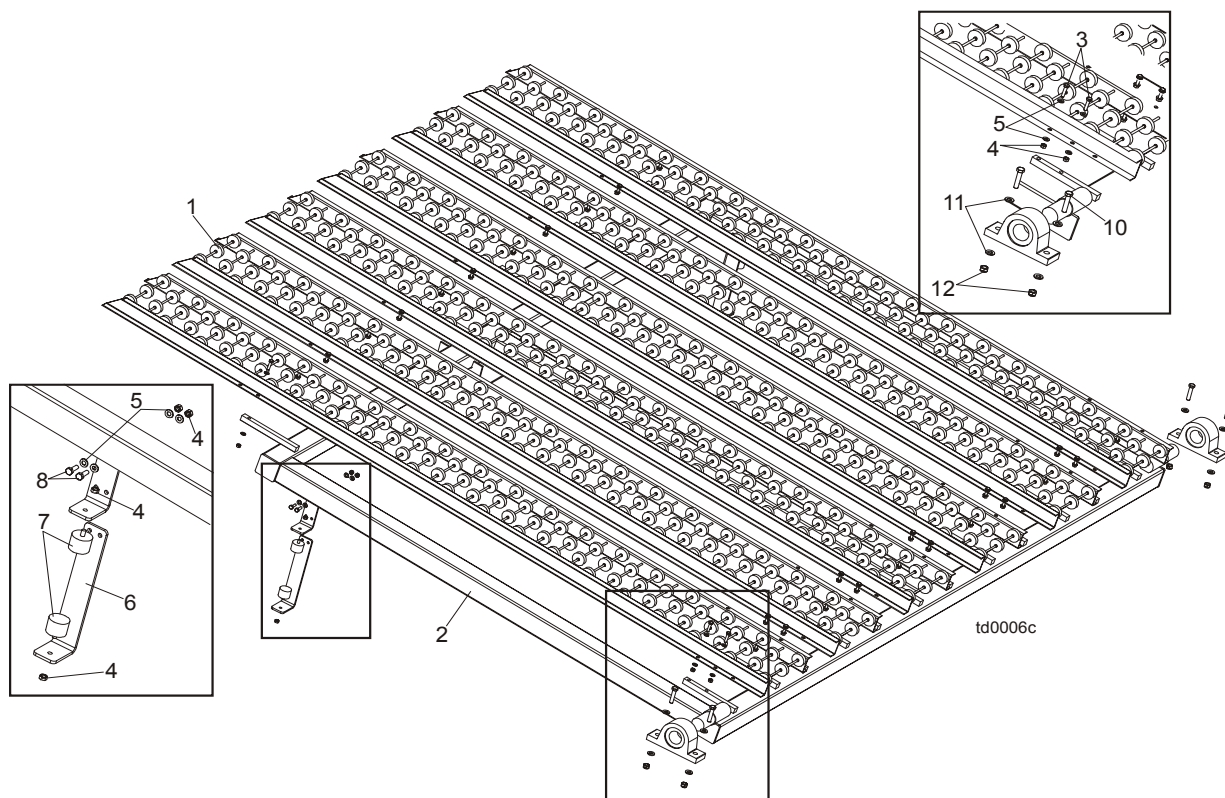
3.6 Pneumatics Diagram

The transfer deck air system is shown below.



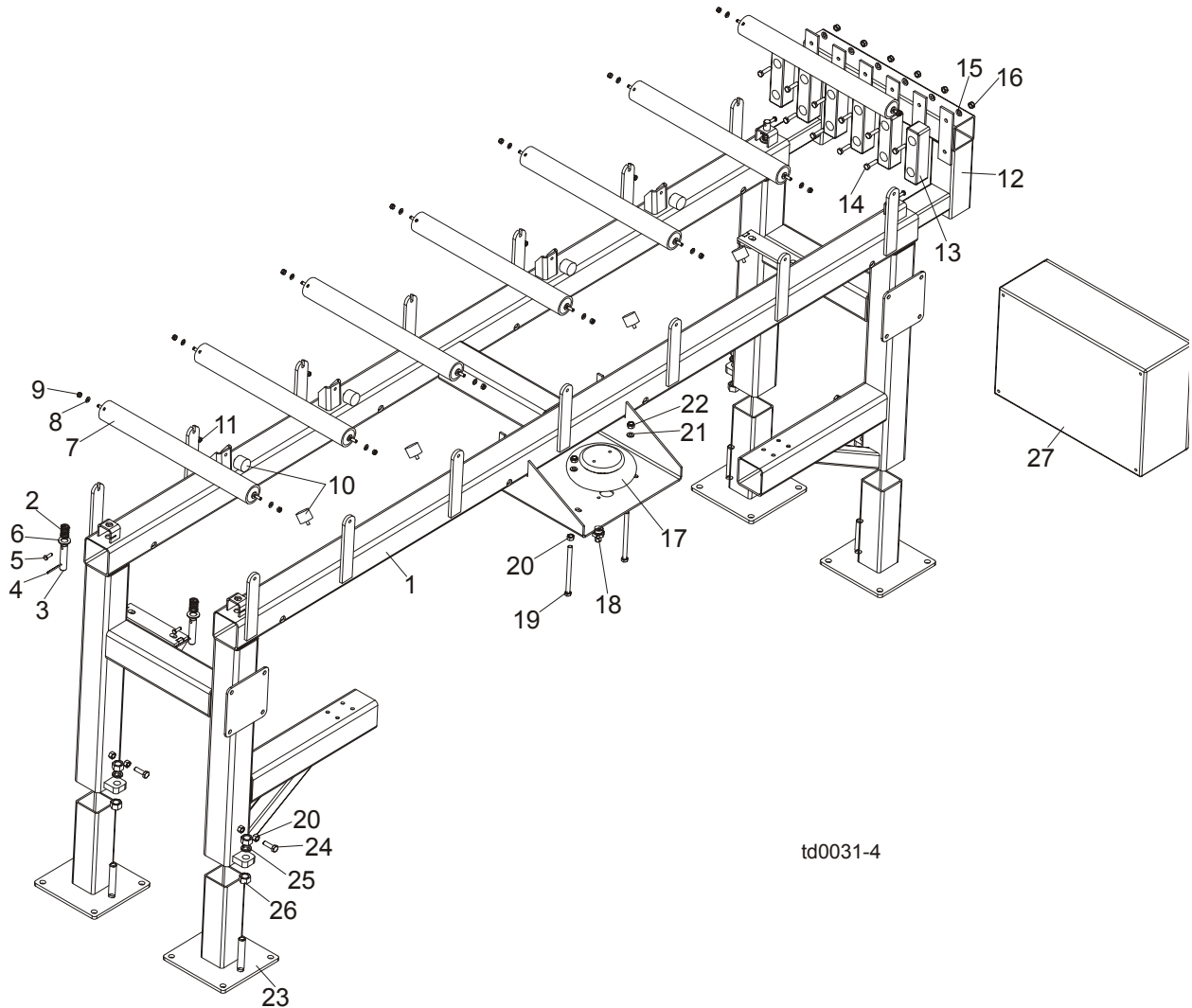
SECTION 4 REPLACEMENT PARTS

4.1 Table Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	TABLE ASSEMBLY, TRANSFER DECK	089760	1
1	Conveyor, Roller	034150	6
2	Tube Weldment, Transfer Deck Table	089721-1	1
3	Bolt, M8x35 -8.8 Hex Head Full Thread Zinc	F81002-13	36
4	Nut, M8-8-B Zinc Hex	F81032-1	44
5	Washer, 8.4 Zinc Flat	F81054-1	80
6	PLATE, LOWER TABLE STOP	089778	2
7	BUMPER, MET-GUM RUBBER	089728	4
8	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
9	BEARING, UCP 210 CX	089041	2
10	BOLT, M12x55-8.8 HEX HEAD ZINC	F81004-12	4
11	WASHER, 13 ZINC FLAT	F81056-1	8
12	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	4

4.2 Board Stop/Air Bag Assembly



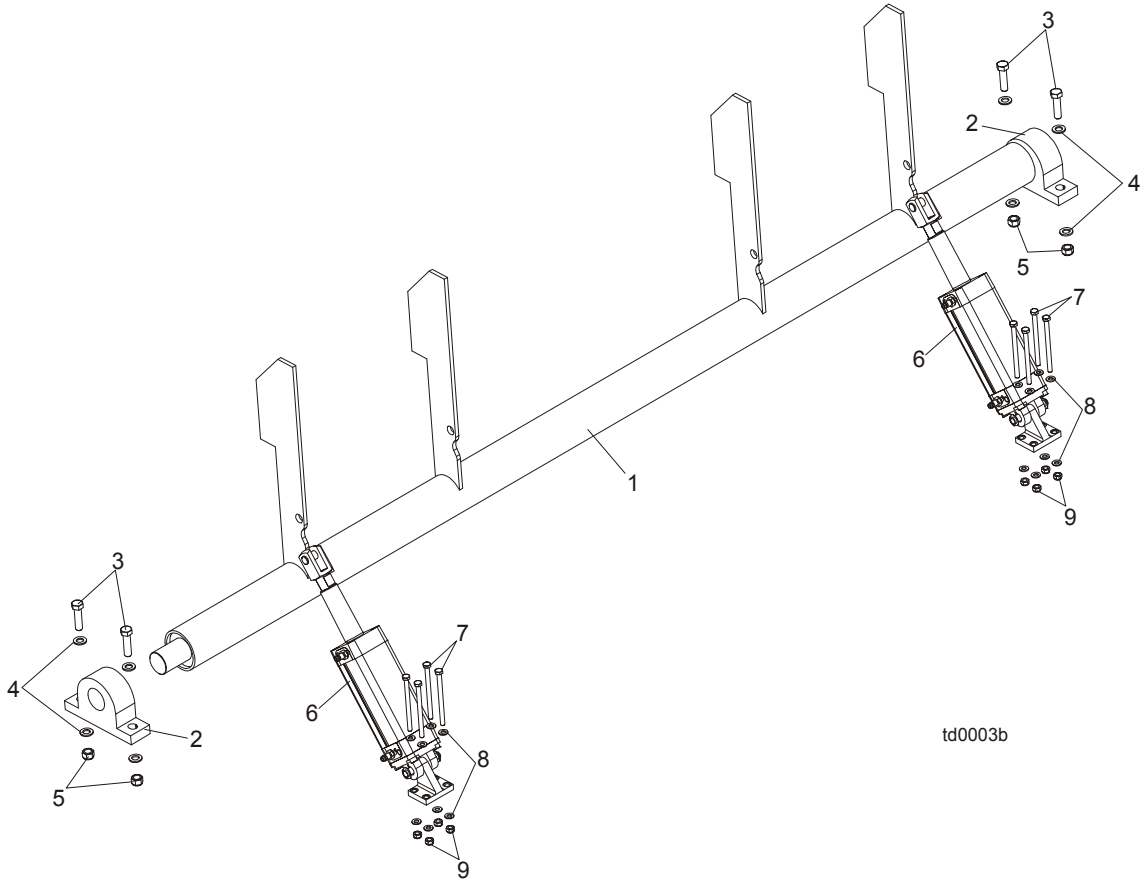
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	FRAME WELDMENT, ROLLER	089725-1	1
2	Spring, 21D.x38x2 Zinc-Plated	087040	4
3	Pin, Outrigger Pull Zinc-Plated	087012-1	4
4	Pin, 4x50 Roll Zinc	F81044-6	4
5	Pin, 8x65 Roll Zinc	F81046-1	4
6	Washer, 20.5 Split Lock Zinc	F81059-1	4
7	ROLLER, 76,L=600,L1=663 W/M12 THREADED ROD	095160	7
8	WASHER, 13 FLAT ZINC	F81056-1	14
9	NUT, M12-8-B HEX NYLON ZINC LOCK	F81034-2	14

4

Replacement Parts*Board Stop/Air Bag Assembly*

10	BUMPER, MET-GUM RUBBER	089728	8	
11	NUT, M8-8-B HEX ZINC	F81032-1	8	
12	STOP WELDMENT, BOARD	089746-1	1	
13	BUMPER, #054B RUBBER	089717	6	
14	BOLT, M10x40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	12	
15	WASHER, 10.5 FLAT ZINC	F81055-1	12	
16	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	12	
17	BAG, 192 308 100 0 AIR	088576	1	
18	FITTING, G1/4XG3/4	088572	1	
19	BOLT, M12x170-8.8 HEX HEAD ZINC	F81004-7	2	
20	NUT, M12-8-B HEX ZINC	F81034-1	6	
21	WASHER, 10.5 FLAT ZINC	F81055-1	2	
22	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	2	
23	LEG WELDMENT, TD BASE	089766-1	4	
24	BOLT, M12x40-8.8 HEX HEAD FULL THREAD ZINC	F81004-4	4	
25	WASHER, 20.5 SPLIT LOCK ZINC	F81059-1	4	
26	NUT, M20-8 HEX ZINC	F81037-1	8	
27	CONTROL BOX, TRANSFER DECK	091532	1	
	PNEUMATIC COMPONENTS (EXCEPT CONTROL BOX)	091353	1	

4.3 Kicker & Air Cylinder

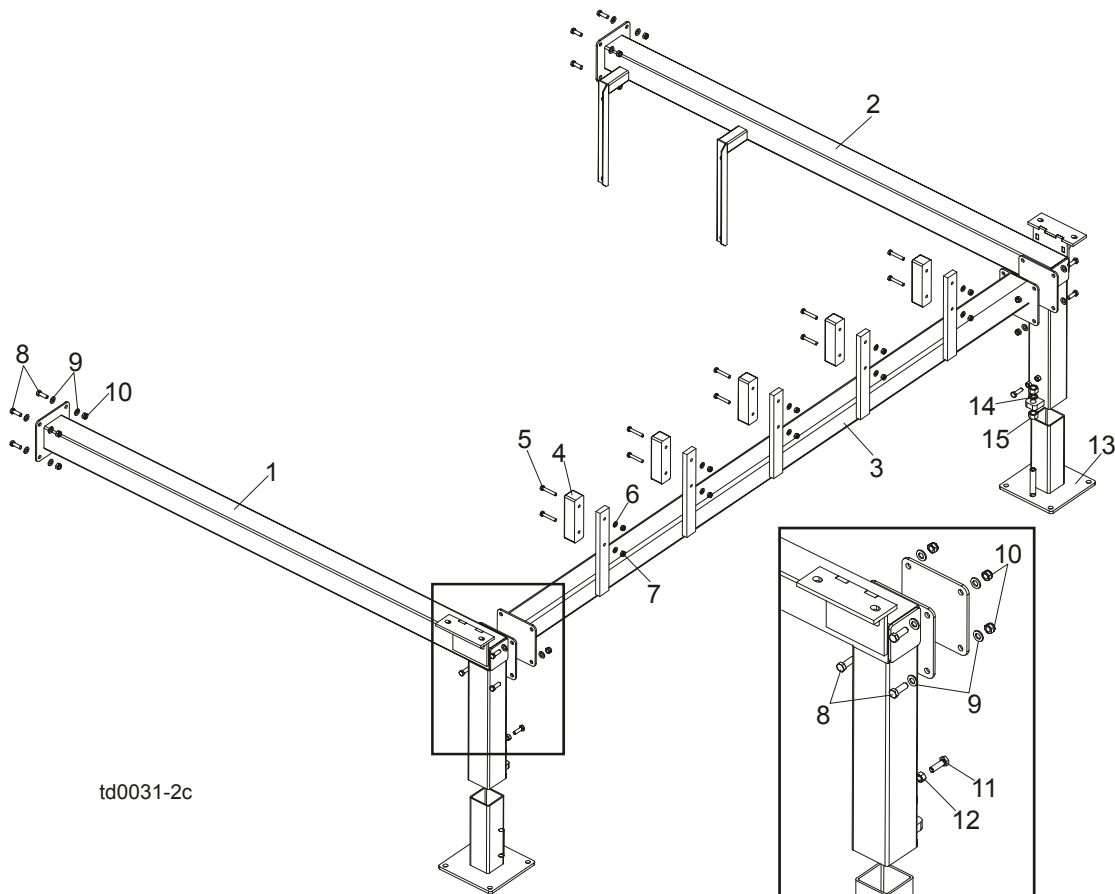


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	TUBE WELDMENT, KICKER	089737-1	1
2	BEARING, UCP211 CX PILLOW BLOCK	089738	2
3	BOLT, M16x60 8.8 HEX HEAD FULL THREAD ZINC	F81006-12	4
4	WASHER, 17 FLAT ZINC	F81058-1	8
5	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
6	CYLINDER, AIR	091497	2
7	BOLT, M10x140-8.8 HEX HEAD ZINC	F81003-5	8
8	WASHER, 10.5 FLAT ZINC	F81055-1	16
9	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8

4 Replacement Parts

Lower Frame

4.4 Lower Frame



td0031-2c

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	TUBE WELDMENT, FRAME LEFT SIDE	089753-1	1
2	TUBE WELDMENT, FRAME RIGHT SIDE	089749-1	1
3	TUBE WELDMENT, FRAME CROSS	089715	1
4	BUMPER, #054B RUBBER	089717	5
5	BOLT, M10x60-8.8 HEX HEAD ZINC	F81003-10	10
6	WASHER, 10.5 FLAT ZINC	F81055-1	10
7	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	10
8	BOLT, M12X35-8.8 HEX HEAD FULL THREAD ZINC	F81004-24	16
9	WASHER, 13 FLAT ZINC	F81056-1	32
10	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	16
11	BOLT, M12X40-8.8 HEX HEAD FULL THREAD ZINC	F81004-4	2
12	NUT, M12-8-B HEX ZINC	F81034-1	2
13	LEG WELDMENT, TD BASE	089766-1	2
14	WASHER, 20.5 SPLIT LOCK ZINC	F81059-1	2
15	NUT, M20-8 HEX ZINC	F81037-1	4

SECTION 5 ELECTRICAL INFORMATION

5.1 Electrical Symbol Diagram

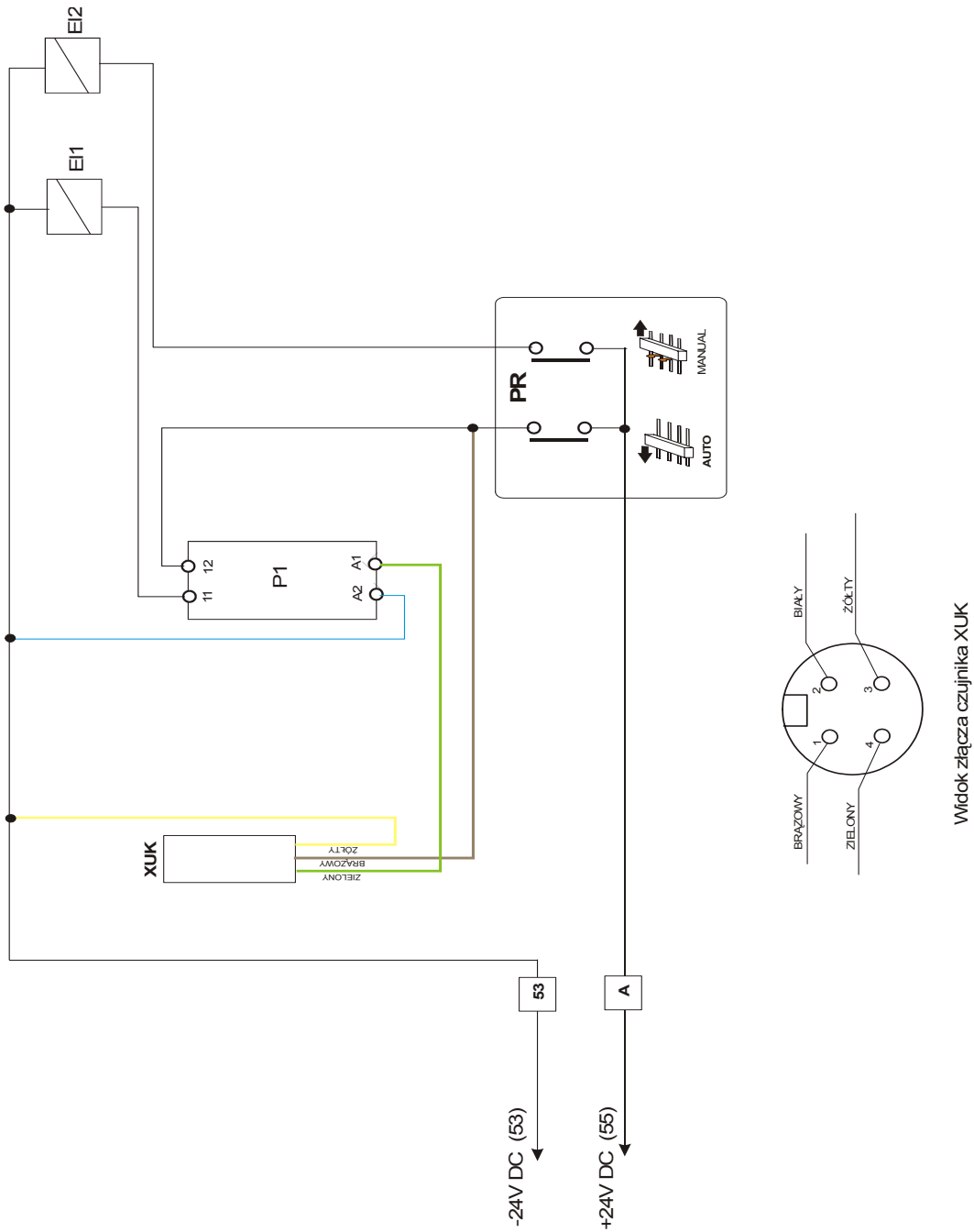


FIG. 5-1

4 Electrical Information

Electrical Component List

5.2 Electrical Component List

Component	Manufacturer	Wood-Mizer Part No.	Description
PR			Switch, Operation Mode
XUK		093169	Sensor, Photo Transmitter
P1		090515	Relay, Auxiliary
E11			Valve, Air Bag Solenoid
E12			Solenoid Valve, Air Cylinders

TABELA 5-1