



## user manual

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

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Conservare il presente manuale a l'uso futuro  
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Hranite za prihodnje uporabo



# **Wood-Mizer®**

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

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**LT70S MH**  
**LT70M MH**

**rev. E9.00**  
**rev. E9.00**

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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 #1063*

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

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

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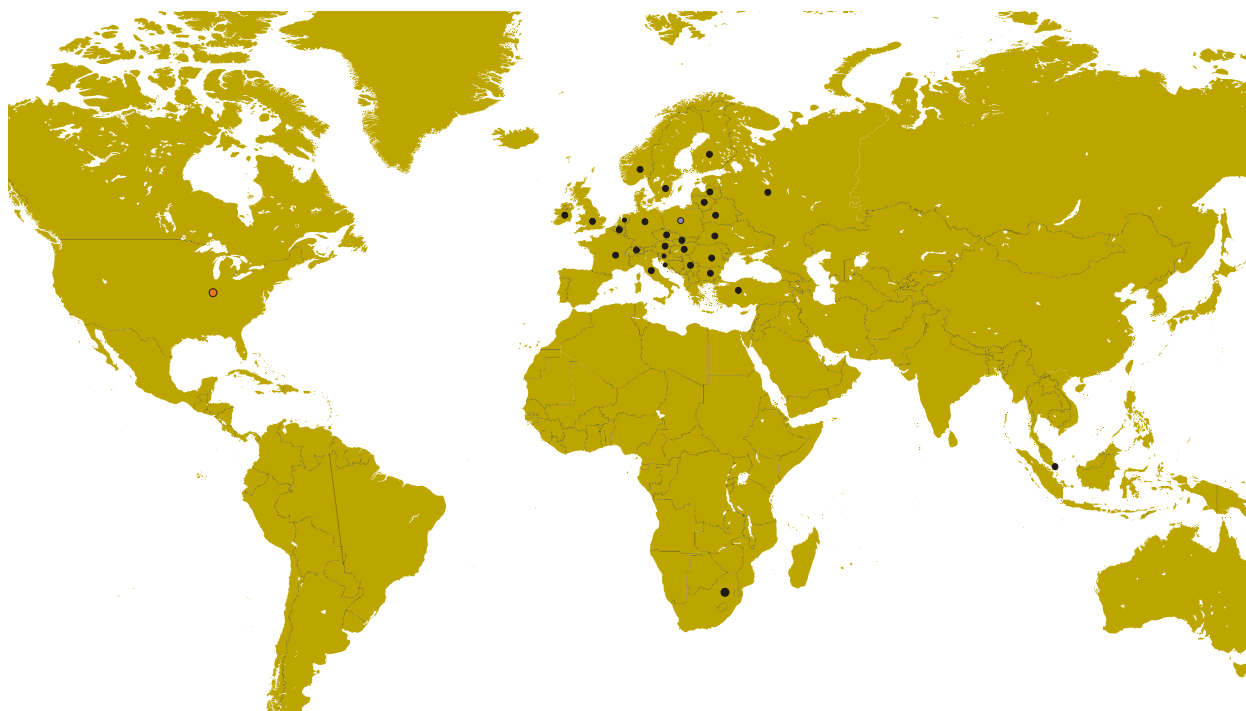
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For a complete list of dealers, visit [www.woodmizer.com](http://www.woodmizer.com)

## Sawmill and Customer Identification

Each Wood-Mizer sawmill has a 17-digit Vehicle Identification Number (VIN). See the figure below for VIN locations. See the chart for VIN description.

Company Identification Number 456=Wood-Mizer Indiana	Weight Class; A=Under 1300 kg B=1300 - 1800kg C=1800-2200 kg D=2200kg-3000kg	Product No.; 1=LT15, 2=LT20, 4=LT40 Series, 7=LT70 Series	Length of the Trailer; 20=20 Ft., 24=24', 35=35'	Number of axles on the trailer	Check Digit Add all the number and divide by 11	Year of Manufacture; G=2009, H=2010, J=2011, K=2012, L=2013, M=2014	State of Manufacture N=Indiana, P=Poland	Month of Manufacture A=January, B=February, C=March, etc...	Revision Level	Sequence Number Ranging from 000-999	End of 17-Digit VIN	Revision Level (Repeated)	Two-Digit Minor Revision Level
<b>456</b>	<b>A</b>	<b>7</b>	<b>24</b>	<b>1</b>	<b>X</b>	<b>J</b>	<b>N</b>	<b>A</b>	<b>F9</b>	<b>017</b>		<b>F9</b>	<b>.01</b>

V.I.N. DESCRIPTION



V.I.N. LOCATIONS

Each sawmill is also identified with a model number which includes the base model and the engine/motor configuration. See the figure for a description of the model number.

**LT70**  
Basic Sawmill I.D.

**E25**  
Engine/Motor  
Configuration

***MODEL NUMBER DESCRIPTION.***

When you pick up your mill, you will receive a customer number. Both the VIN and your customer number expedite our service to you. Please write these numbers below so you have quick, easy access to them.

Customer No.	Model No.	V.I.N.	Revision

## SECTION 1 SAFETY & GENERAL INFORMATION

### 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.



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.

Read and observe all safety instructions before operating this equipment! Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

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

Always properly dispose of all sawing by-products, including sawdust and other debris, coolant, oil, fuel, oil filters and fuel filters.

Safety instructions are listed in this section by the following operations:

- Blade Handling
- Sawmill Setup
- Sawmill Operation
- Sawmill Maintenance

## 1.2 Blade Handling



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



**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!** Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

### 1.3 Sawmill Setup



**WARNING!** Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

**WARNING!** Failure to put front outrigger down before moving cutting head from the rest position may result in serious injury.

**WARNING!** Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

**WARNING!** Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

**WARNING!** Do not set up the mill on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the mill or dig out areas for outrigger legs to keep mill level. Setting up the mill on an incline could cause it to tip over, resulting in serious personal injury.



**CAUTION!** Changes in temperature could cause increased pressure in the blade tensioner and loss of fluid from the gauge. Release the blade tension when the mill is not in use to avoid damage to the tensioner.

## 1.4 Sawmill Operation



**IMPORTANT!** The sawmill is intended for sawing wood only. [See Section 1.9](#) for log size capacities of the machine. The sawmill must not be used for other purposes such as cutting ice, metal or any other materials.

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



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

Be sure the blade housing and pulley covers are closed.

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

**DANGER!** Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.

**DANGER!** Keep all persons out of the path of moving equipment and logs when operating sawmill or loading and turning logs. Failure to do so will result in serious injury.

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

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

**DANGER!** Keep all persons out of the path of returning boards. Failure to do so will result in serious injury.



**WARNING!** Always disengage the clutch/brake mechanism whenever the sawmill is not cutting. Failure to do so may result in serious injury.

**WARNING!** Always wear eye, ear, respiration, and foot protection when operating the sawmill. Failure to do so may result in serious injury.



**WARNING!** Secure all loose clothing and jewelry before operat-

ing the sawmill. Failure to do so may result in serious injury or death.

**WARNING!** Always make sure log is clamped securely before sawing. Failure to do so may result in serious injury or death.

**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.



**CAUTION!** Be sure the pivot rails, turning arm, clamp, and toe boards are below bed level before loading a log onto the bed. Failure to do so may result in machine damage or cause misalignment.

**CAUTION!** Before loading a log, be sure the cutting head is moved far enough forward so the log does not hit it. Failure to do so may result in machine damage.

**CAUTION!** Be careful when manually lowering the log loader. Do not drop the loader onto the ground or perform any action which might break the velocity fuse valves on the loader cylinders. These valves control hydraulic flow and are necessary to prevent the loading arm from collapsing during use.

**CAUTION!** Do not try to force the saw head beyond its upper and lower travel limits. Damage to the up/down system may result.

**CAUTION!** Be sure to stop the blade when returning the carriage. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

**CAUTION!** The saw head will hit the spring-loaded ramp stops when adjusted for low cuts. Remove the loading ramps before sawing to prevent damage to the saw head and/or blade guide arm.



**CAUTION!** Never clean the blade or the blade wheels with a brush or a scraper during sawmill operation.

**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 sawmill operation, push the EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing cover.



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

## 1.5 Sawmill Maintenance



**WARNING!** Always secure the cutting head with a chain or a brace before adjusting the up/down chain. The cutting head may fall, causing severe injury or death.

**CAUTION!** Reinstall the track wiper so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.

**CAUTION!** Do not use chain lube. It causes sawdust buildup in chain links.

**CAUTION!** It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

## 1.6 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 sawmill. 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 sawmill. The sawmill 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 sawmill. All Wood-Mizer sawmill 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 sawmill. Failure to do so may result in serious injury or death.

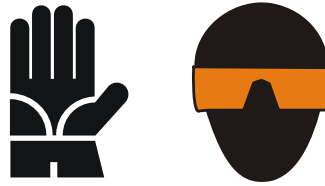
**WARNING!** Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or changing a blade. Failure to do so may result in serious injury.

# 1

## Safety & General Information

*Keep sawmill And Area Around sawmill Clean*

---



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



*Keep sawmill And Area Around sawmill Clean*



**DANGER!** Maintain a clean and clear path for all necessary movement around the sawmill 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 sawmill Before Operation*



**DANGER!** Make sure all guards and covers are in place and secured before operating the sawmill. 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 sawmill. Failure to do so will result in seri-

ous 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 sawmill operation.



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

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

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

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



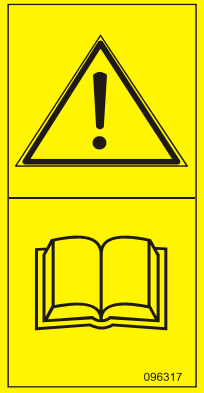


**IMPORTANT!** Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order more decals.

**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 LT70.


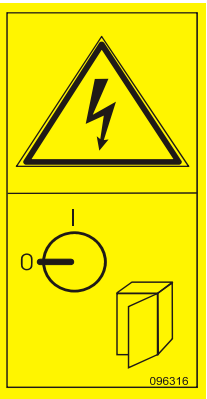
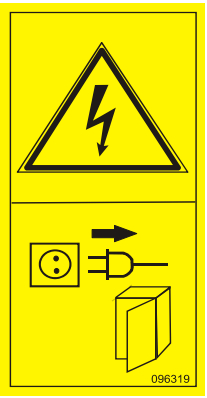
**TABLE 1-1**

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 sawmill.
	099220	CAUTION! 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.

# 1 Safety & General Information



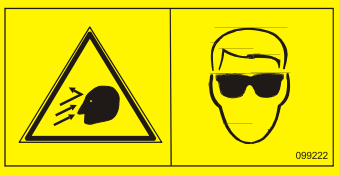
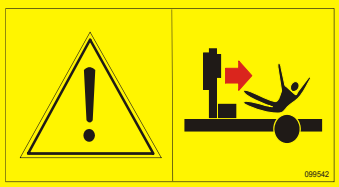
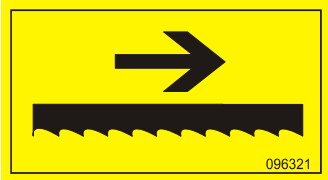
Keep Safety Labels In Good Condition

TABLE 1-1

	<p>098176</p>	<p>CAUTION! Keep away from debarker blade!</p>
	<p>096316</p>	<p>CAUTION! Do not open or close the electric box when the switch is not in the "0" position.</p>
	<p>096319</p>	<p>CAUTION! Disconnect power supply before opening the box.</p>



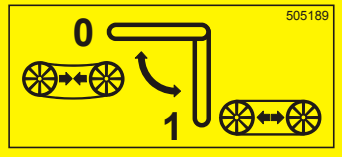







**TABLE 1-1**

 <p style="text-align: right; font-size: small;">085977B</p>	<p>085977B</p>	<p>No lift the machine grasping by the element!</p>
 <p style="text-align: right; font-size: small;">086099</p>	<p>086099</p>	<p>CAUTION! Keep away - hot parts!</p>
 <p style="text-align: right; font-size: small;">099222</p>	<p>099222</p>	<p>CAUTION! Sawdust outlet. Protect eyes!</p>
 <p style="text-align: right; font-size: small;">099542</p>	<p>099542</p>	<p>CAUTION! Trailer.</p>
 <p style="text-align: right; font-size: small;">096321</p>	<p>096321</p>	<p>Blade movement direction</p>

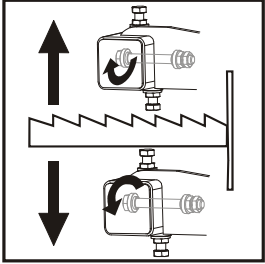



# 1 Safety & General Information

Keep Safety Labels In Good Condition

TABLE 1-1

	505189	Lever of tensioner's ball valve																																					
<table border="1" data-bbox="280 551 558 745"> <thead> <tr> <th rowspan="2">Type</th> <th colspan="2">  </th> <th rowspan="2">psi</th> <th rowspan="2">MPa</th> </tr> <tr> <th>F(mm)</th> <th>E(mm)</th> </tr> </thead> <tbody> <tr> <td>276</td> <td>1,07</td> <td>38</td> <td>60-62</td> <td>0,41-0,43</td> </tr> <tr> <td>376</td> <td>1,14</td> <td>38</td> <td>60-62</td> <td>0,41-0,43</td> </tr> <tr> <td>2735</td> <td>1,07</td> <td>35</td> <td>65</td> <td>0,45</td> </tr> <tr> <td>3735</td> <td>1,14</td> <td>35</td> <td>65</td> <td>0,45</td> </tr> <tr> <td>576</td> <td>1,27</td> <td>38</td> <td>65-70</td> <td>0,45-0,48</td> </tr> <tr> <td>476</td> <td>1,4</td> <td>38</td> <td>65-70</td> <td>0,45-0,48</td> </tr> </tbody> </table>	Type			psi	MPa	F(mm)	E(mm)	276	1,07	38	60-62	0,41-0,43	376	1,14	38	60-62	0,41-0,43	2735	1,07	35	65	0,45	3735	1,14	35	65	0,45	576	1,27	38	65-70	0,45-0,48	476	1,4	38	65-70	0,45-0,48	518439	Blade Tension Values
Type						psi	MPa																																
	F(mm)	E(mm)																																					
276	1,07	38	60-62	0,41-0,43																																			
376	1,14	38	60-62	0,41-0,43																																			
2735	1,07	35	65	0,45																																			
3735	1,14	35	65	0,45																																			
576	1,27	38	65-70	0,45-0,48																																			
476	1,4	38	65-70	0,45-0,48																																			
	S12004G	CAUTION! Always wear safety goggles when operating the sawmill!																																					
	S12005G	CAUTION! Always wear protective ear muffs when operating the sawmill!																																					
	501465	CAUTION! Always wear safety boots when operating the sawmill																																					
	501467	Lubrication Point																																					

**TABLE 1-1**

 <p>P11789-70</p>	<p>P11789-70</p>	<p>Aligning the blade on the wheels</p>
	<p>P85070</p>	<p>CE safety certification</p>
 <p>099401</p>	<p>099401</p>	<p>Russian safety certification</p>
 <p>2930 RPM</p> <p>S20097E</p>	<p>S20097E</p>	<p>2930 RPM - Motor rotation direction</p>

## 1.7 Belt Sizes

See Table 1-2. Belt sizes are shown below.

Description	Belt Size	Wood-Mizer Part #
Motor Drive Belt ( E25 )	3B/HB 2462La	089464
Up/Down Drive Belt (AC mills)	HA-670	091328
Blade Pulley Belts	B72.5 <sup>1</sup>	017922

**TABLE 1-2**

<sup>1</sup> To insure proper blade tracking, use Goodyear, Dayco Super II, or Browning belts only.

## 1.8 Blade Sizes

See **Table 1-3**. Wood-Mizer TRU•SHARP™ offers three types of blades to provide efficient sawing for all models of sawmills. The engine/motor size of your sawmill and the type of wood you saw should determine which blade you choose for optimum performance. <sup>1</sup>

	Softwood	Medium Hardwood	Frozen Timber or Dense Hardwood
5-15HP Gas	B275IH1030 B275IH741030	B375IH929	B375IH929 <sup>1</sup>
7.4-11kW (10-15HP) Electric 16-25HP Gas 33HP Diesel	B376IH1030 B376IH741030	B275IH1030 B275IH741030 B376IH1030 B376IH741030 <sup>2</sup>	B375IH929 <sup>1</sup>
15-18.5kW (20-25HP) Electric 42HP Diesel	B376IH1030 B376IH741030	B275IH1030 B275IH741030 B376IH1030 B376IH741030 <sup>2</sup>	B375IH929 <sup>1</sup>

**TABLE 1-3**

<sup>1</sup> TRU•SHARP™ “F” blades use a 9/29 profile (9° hook angle and 29° back angle) and are designed to cut frozen and/or extremely dense, hard-to-cut wood. Standard TRU•SHARP™ blades use a 10/30 profile.

<sup>2</sup> Customer may choose preferred blade.

See *The Blade Handbook* for blade hook angle, tooth height, and tooth set specifications.

1.LT70 Sawmill is equipped with a blade with a length of 4.67 m.

## 1.9 Cutting Capacity

See Table 1-4. The LT70A can accept logs as listed below.

	LT70A	LT70A	LT70AL
<b>Maximum Log Diameter</b>	36,6" ( 93 cm )	36,6" ( 93 cm )	36,6" ( 93 cm )
<b>Maximum Log Length <sup>1</sup></b>	15'-11" ( 4.8 m )	20'-2" ( 6.1 m )	27'-6" ( 8.4m )
<b>Maximum Log Weight <sup>2</sup></b>	4400 lbs. ( 1996 kg)	4400 lbs. (1996 kg)	6614 lbs. (3000 kg)

**TABLE 1-4**

<sup>1</sup> If your sawmill is equipped with a bed extension option, add the length of this extension to the sawmill length capacity (e.g. for BX12 add 12').

<sup>2</sup> Sawmills equipped with bed extensions can accept heavier logs if the weight is distributed so neither the sawmill or extension is loaded beyond the 4400 lbs. (1996 Kg) limit. Loading logs heavier than 4400 lbs. (1996 Kg) on a sawmill equipped with a bed extension requires auxiliary log handling equipment.

## 1.10 Engine/Motor Specifications

See Table 1-5. Engine/motor type specifications for the LT70 are shown below.

Engine/Motor Type	Manufacturer	Model No.	Power	Other Specifications
25HP Electric Motor <sup>1</sup>	Siemens, Germany	1LA7166-2AA60Z	18,5kW	33,8 A, 2930 RPM

TABLE 1-6

<sup>1</sup> The electric motors supplied on Wood-Mizer sawmills carry a rating assigned by the motor manufacturer for the continuous duty operation of the motor, potentially, 24 hours per day, day after day. This rating is useful in sizing motors for use in applications like blowers for heating and ventilation that are never cycled off except for system maintenance.

See Table 1-7. See the table below for power supply specifications for the LT70 sawmill

	3-Phase Volts	Fused Disconnect Switch	Recommended Wire Size
15kW (EA20)	400 VAC	32 A	6 mm <sup>2</sup> up to 15 m of length
18,5kW (EA25)	400 VAC	40 A	6 mm <sup>2</sup> up to 15 m of length
Hydraulic (+4kW)	400 VAC	+10A	+1,5 mm <sup>2</sup> up to 15 m of length

TABLE 1-7



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

See Table 1-8. The other motors used in sawmills LT70AH are listed below.

Model	Manufacturer	Voltage	Rated output	WM Part No
Power Feed Motor	Besel, Polska	3x230/400V	1380 RPM - 1,1kW	090104
Up/Down Motor	Leeson, USA	3x230/400V	1390 RPM -1,1kW	086530
Blade Guide Arm Motor	Motor Products Owosso, USA	12V	60 RPM - 17W	P09698-1

TABLE 1-8

## 1.11 Noise Level

See Table 1-9. The average noise level is given in the table below<sup>12</sup>.

Sawmill	Noise Level $L_{EX8}$
LT70 E15 AH	87,1 dB (A)
LT70 E20 AH	87,1 dB (A)
LT70 D42 DH	87,5 dB (A)

TABLE. 1-9

- 
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. Value for associated uncertainty  $K=4\text{dB}$ .
  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.



## 1.12 Overall Dimensions

See **Table 1-10**. The overall dimensions of the LT70 sawmills with M and S frame are listed below.

Model	Length <sup>1</sup>	Width <sup>2</sup>	Width (Operating Position with Loading Arms)	Height <sup>3</sup>	Weight	Weight w/Trailer
<b>LT70S</b>	21' 11" (6.7 m)	6' 6" (2 m)	8' 2" (2.5 m)	7' 8" (2.4 m)	3291 lbs. (1481 kg)	3716 lbs. (1672 kg)
<b>LT70M</b>	26' 2" (8 m)	6' 6" (2 m)	8' 2" (2.5 m)	7' 8" (2.4 m)	3491 lbs. (1571 kg)	3916 lbs. (1762 kg)

**TABLE 1-10**

<sup>1</sup> Length from hitch to chain bracket.

<sup>2</sup> Width from fender to fender.

<sup>3</sup> Height from ground to mast. Placing head in maximum position will add to total height.

### 1.13 Chains

See Table 1-11. The load capacity of the chains is listed below.

	Load Capacity According to ISO Nr 08A-1
Up/Down Chain	45400N

*TABLE 1-11*

## 1.14 Dust Extractor Specifications

See Table 1-12. Specifications of the dust extractors used on the resaw for each saw head are listed below.<sup>1</sup>

Airflow	1200 m <sup>3</sup> /h 3937ft <sup>3</sup> /h
Inlet diameter	100 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)
Pressure drop	1,5 kPa (0.22 psi) <sup>1</sup>
Recommended conveying air velocity in the duct	20 m/s 65.6 ft/s

**TABLE 1-12**

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



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



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



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

1. External chip and dust extraction equipment with fixed installations are dealt with in EN 12779:2004+A1:2009

## **1.15 Components**

See **Figure 1-1**. The major components of the Wood-Mizer LT70 Series are shown below.

1.16 Hydraulic Blade Tensioner Schematic

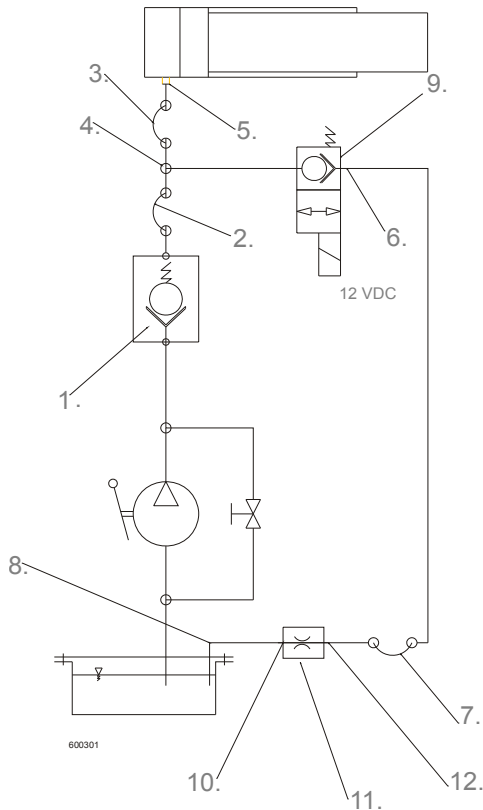


FIG. 1-2 HYDRAULIC SCHEMATIC.

## 1.17 Hydraulic Blade Tensioner Components

ID	Description
1	Non-return Valve HVR NW10MLED
2	Hose DN-12
3	Hose DN-12
4	T-Pipe DT RNW10HL
5	Connector VRNW10HL
6	Elbow W90HROKO6HJ04
7	Hose 1/4"
8	Elbow W90HROK04HJ
9	Valve ECP 20/22B2
10	Connector 4-4F642E DM XS
11	Throttle Valve VSG522.100000
12	Connector 4-4F42ED MXS

**TABLE 1-13**

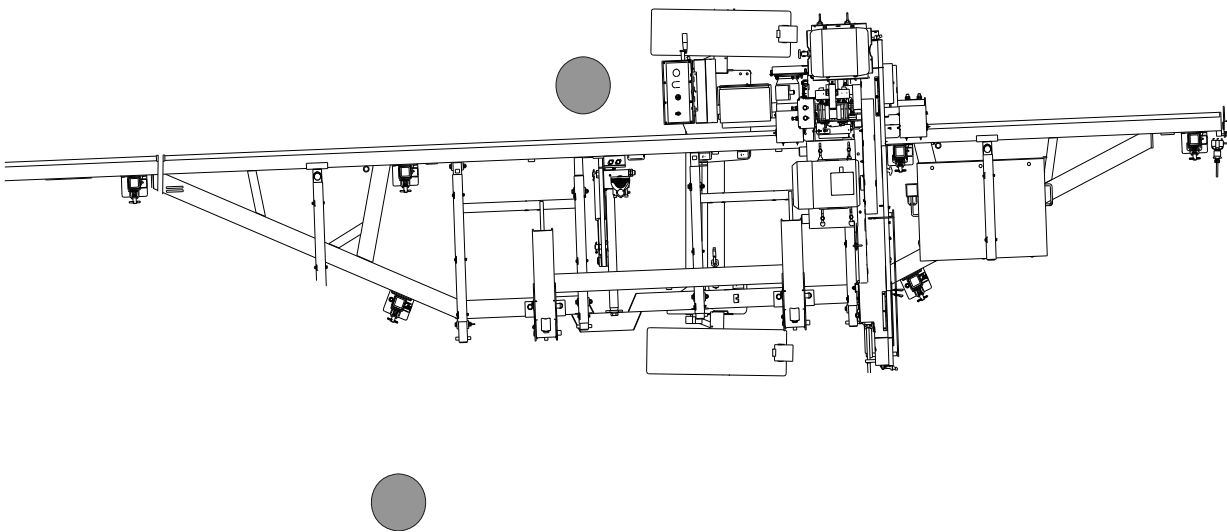
## SECTION 2 SETUP & OPERATION

### 2.1 Sawmill Setup



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

- Set up the sawmill on firm, level ground and level the sawmill. Secure the sawmill to the ground to prevent moving during operation. A concrete foundation or pads (rated to support 31 T/m<sup>2</sup> at each sawmill foot position) and 16mm anchored bolts are recommended.
- It is not allowed to use the sawmill indoor. When using this sawmill type outdoor it is allowed to work without sawdust collection system connected. We recommend to setup sawmill in the way that operator position be down the wind. It will separate the operator from sawdust and engine exhaust gases
- The sawmill can be operated in temperature range from -15° C to 40° C only.
- Illuminance at operator's position must be 300lx.
- The sawmill operator's position is shown below.



- 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 Volts	Fuse disconnect	Suggested Wire Size
400 VAC	40 A	6 mm <sup>2</sup> up to 15 m long

**TABLE 2-0**



**IMPORTANT!** When starting the machine for the first time, check that

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 in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of all sawmill motors. **CAUTION!** Press the emergency button located on the control box to stop the blade and the track feed motor. Turn the emergency stop clockwise to release the stop. The sawmill not restart until the emergency stop is not released.

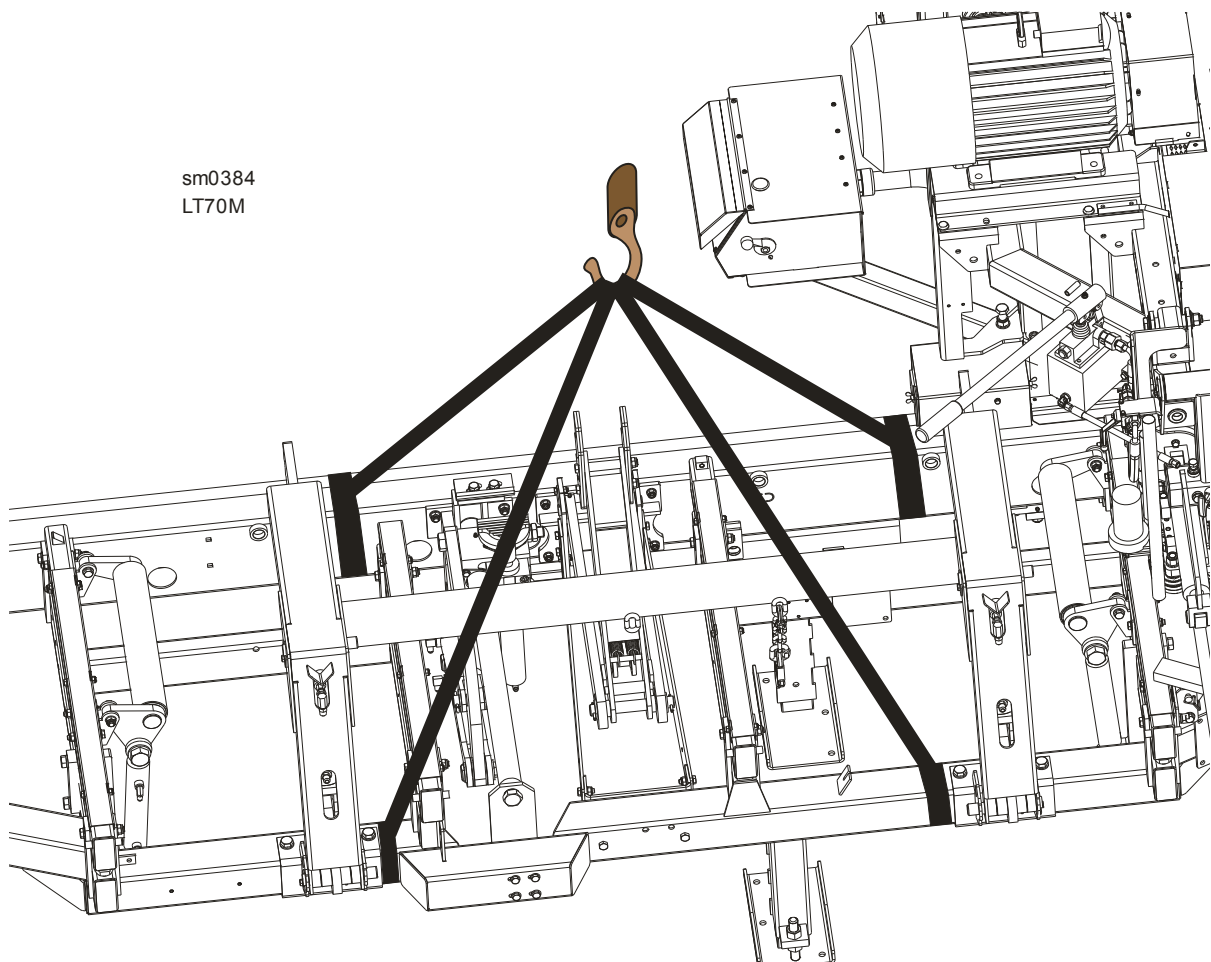


**WARNING!** In case of a blade or drive belt brake, wait until all rotating parts are completely stop. Failure to do so may result in serious injury

- Tie the belts in the places shown on the picture below. The sawmill can be lifted using a forklift, a winch or a crane. The belts and the lifting equipment must be rated for at least 3000kg (6600 lb).



**WARNING!** When lifting the sawmill, use extreme caution and keep all persons at a safe distance. Failure to do so may result in serious injury or death.






## 2.2 Stationary Sawmill Setup

**See Figure 2-1.** Set up the mill on firm footing and level by eye. Fasten the mill to the floor to prevent any creep after prolonged use. A cement pad with 5/8" (16 mm) diameter anchor bolts is recommended. The cement pad should be rated to support 6350 lbs./sq.ft. (31 T/m<sup>2</sup>) at each sawmill foot position.

**NOTE:** Make sure the unit is level before securing. It is possible to twist the mill frame by jacking one foot higher than the others.

Level the sawmill by adjusting the feet to raise or lower each end of the sawmill. Adjust all feet evenly to avoid twisting the mill frame by jacking one feet higher than the others.

 **WARNING!** Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

See Figure 2-2.

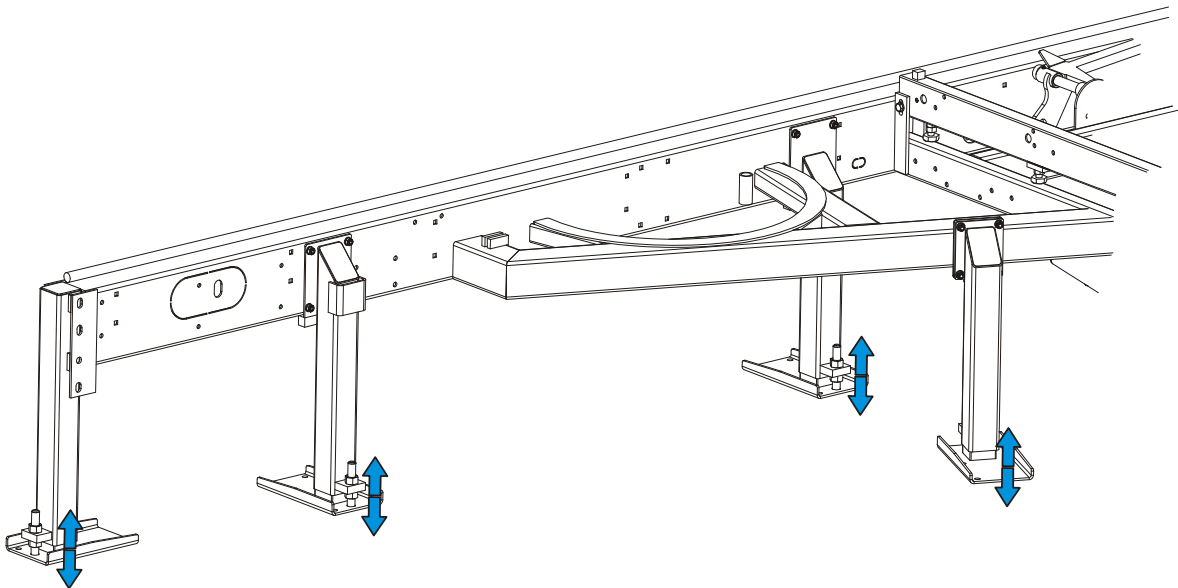

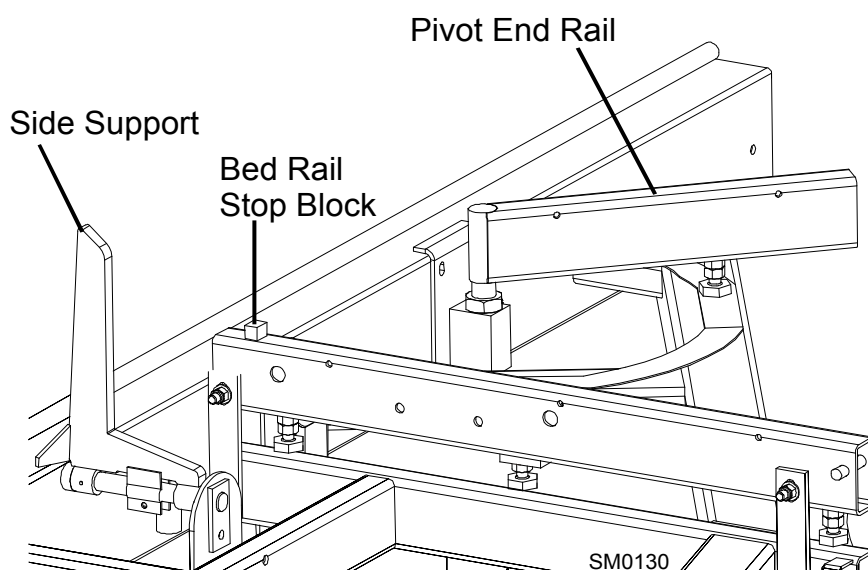


FIG. 2-2

1. Unhook the carriage safety chain, located at the bottom of the vertical mast.
2. Turn the key switch on the control panel to the accessory position. Use the up/down switch on the control panel to raise the cutting head from the carriage rest pin. Remove the locking pin and swing the rest pin down below bed level.
3. Use the  to move the cutting head toward the front end of the mill. Raise the two side supports that will prevent a log from falling off the side of the mill when loaded.

See Figure 2-3.



**FIG. 2-3**

### 2.2.1 Sawmills with cable guide

See Figure 2-2. The figure below shows setup of the sawmill, the control box and the cable guide columns.

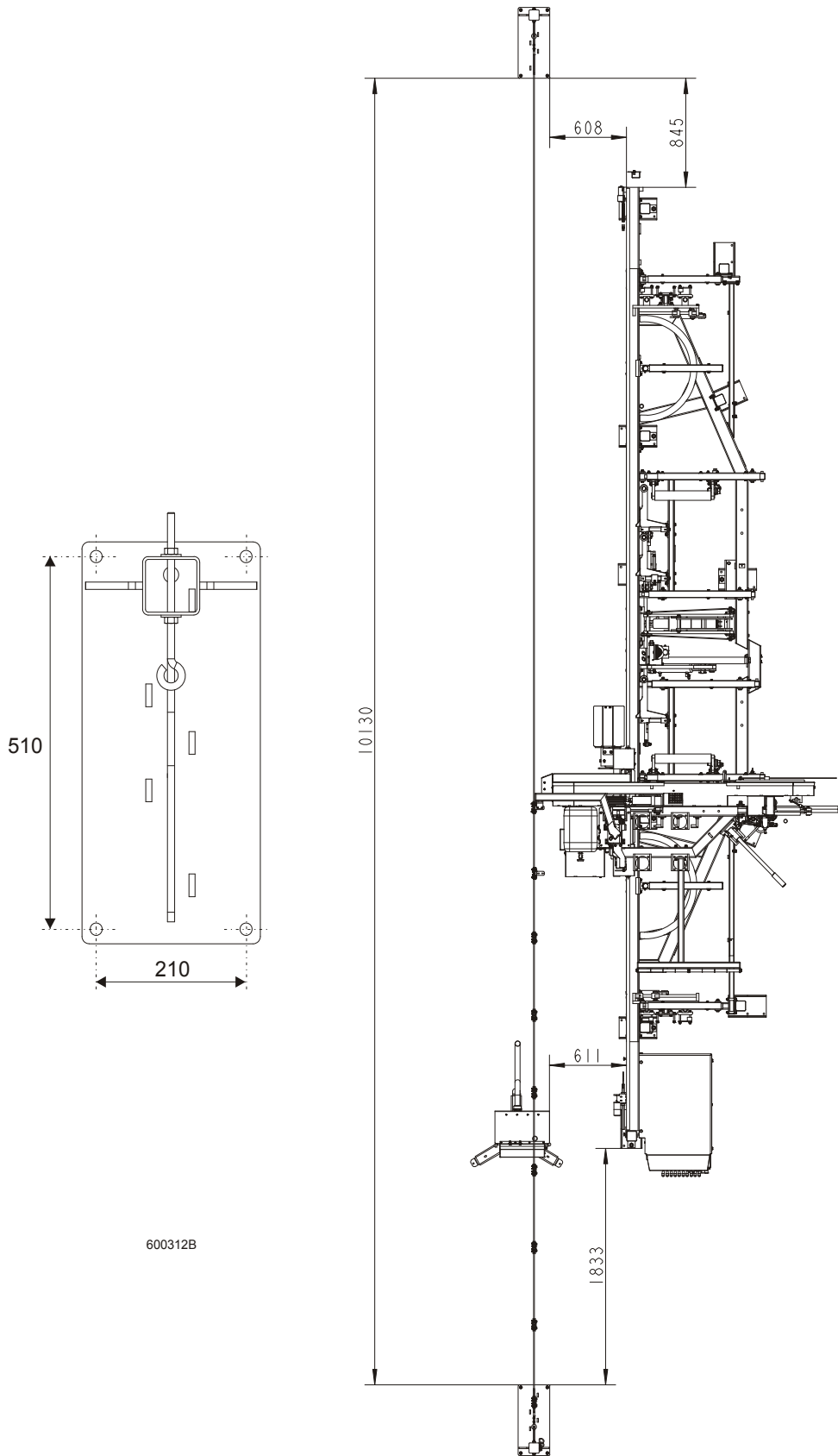
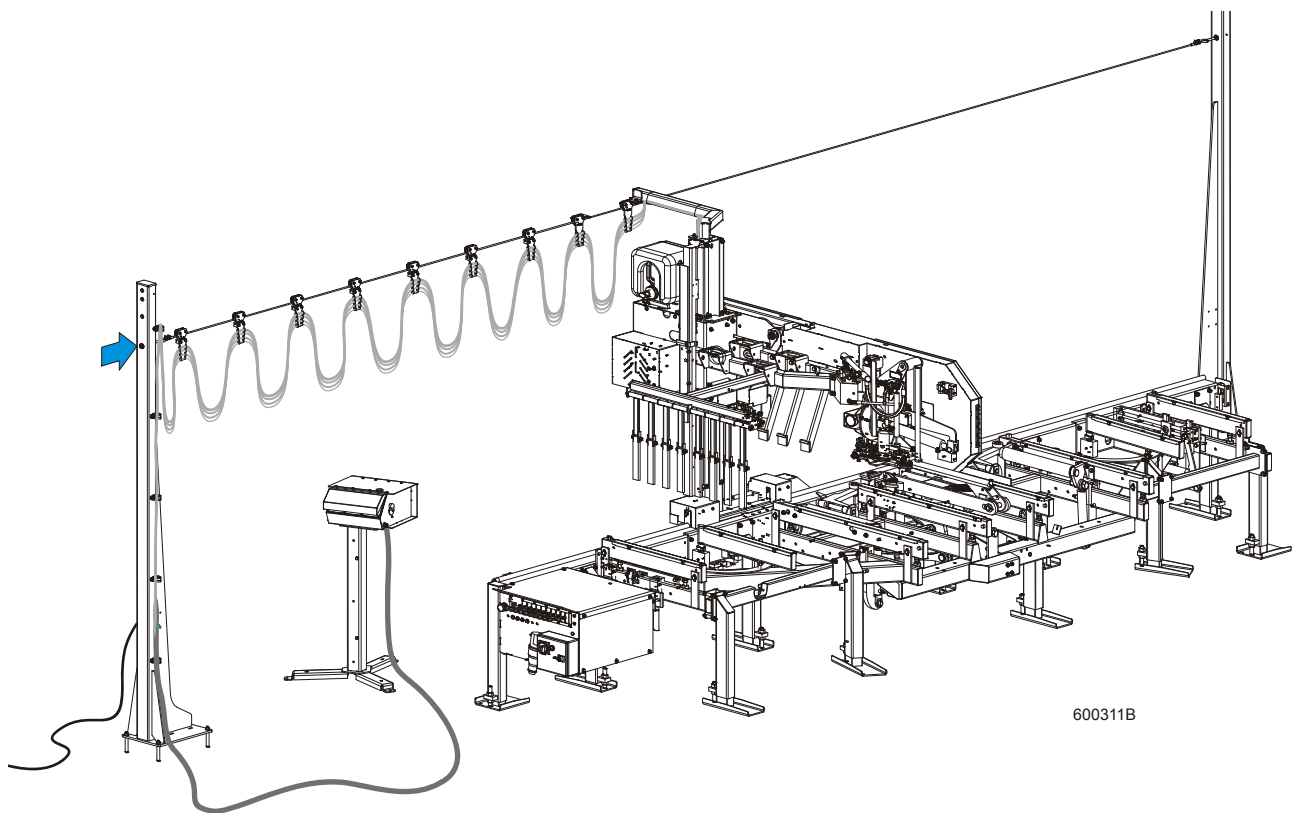


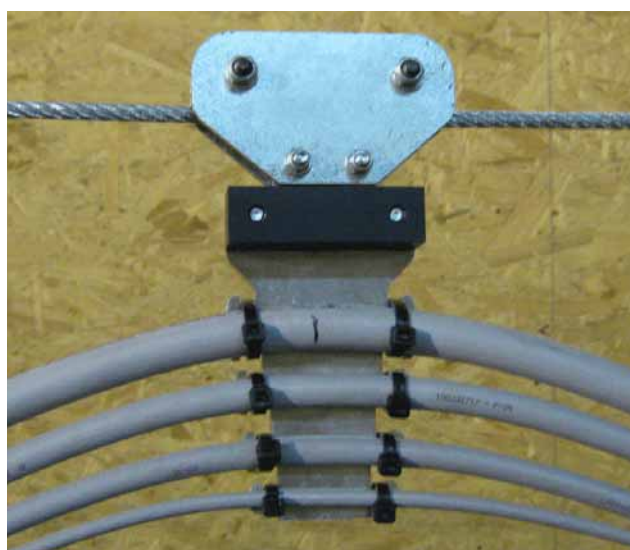
FIG. 2-2 LT70MRC

See Figure 2-3. The electrical wires should be installed on the cable guide as shown below.



**FIG. 2-3**

See Figure 2-4. The figure below shows how the electrical wires should be installed on the roller hangers.



**FIG. 2-4**

**CAUTION!** Be sure the larger diameter cables are mounted to the upper brackets of the roller hangers, and the smaller diameter cables are mounted to the lower brackets of the hangers.

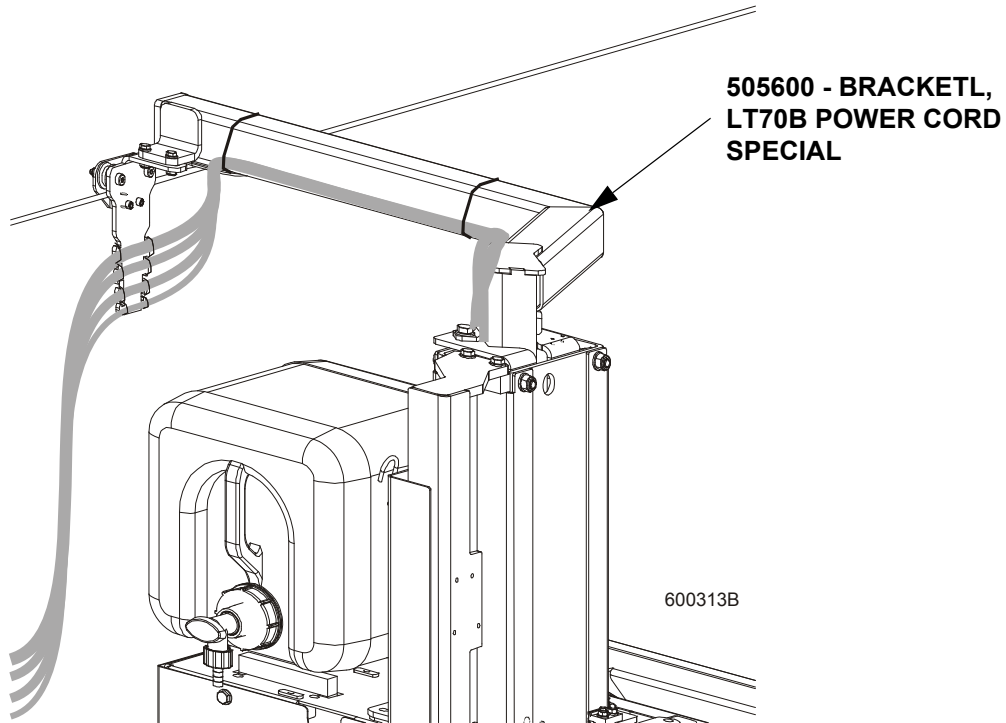


FIG. 2-4

### 2.3 Portable Sawmill Setup



**WARNING!** Do not set up the mill on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the mill or dig out areas for outrigger legs to keep mill level. Setting up the mill on an incline could cause it to tip over, resulting in serious personal injury.

**WARNING!** Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

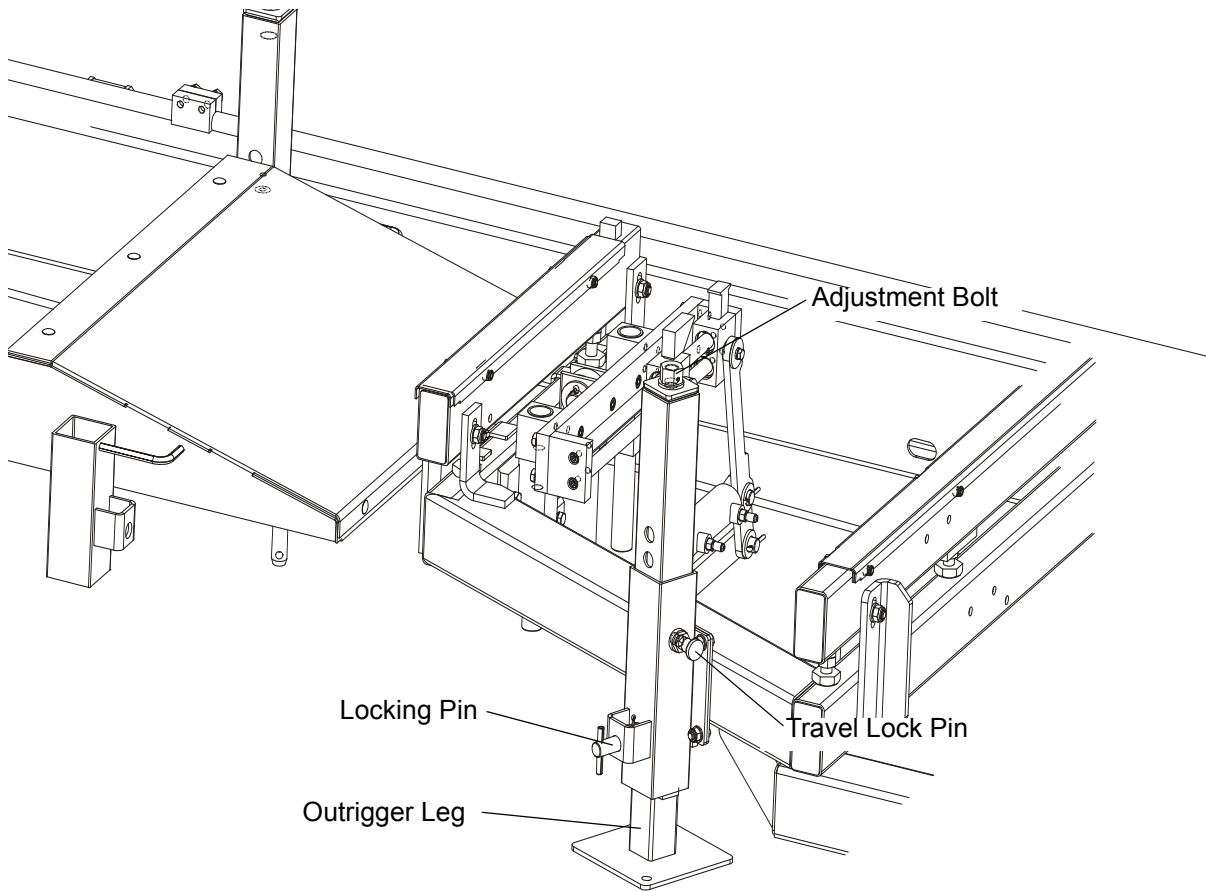
**WARNING!** Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

1. Unhitch the mill from the vehicle.
2. Lower and set the front outriggers. To lower the leg, first place a 19 socket wrench on the outrigger adjustment bolt and turn the bolt until the outrigger movable part reaches its highest position. Next pull the locking pin out of the outrigger hole. When the outrigger contacts the ground, release the pin. Then place a 19 socket wrench on the outrigger adjustment bolt and turn the bolt until the locking pin enters the nearest outrigger hole.



**WARNING!** Put front outrigger down before moving cutting head from the rest position. Failure to do so may result in serious injury.

See Figure 2-5.



**FIG. 2-5. OUTRIGGER ADJUSTMENT.**



**CAUTION!** If setup sawmill on a boggy terrain (such as deep mud or sand) place the board or metal plate under each outrigger leg to prevent it from sinking.

3. Dismount the saw head protection belt and raise the saw head.
4. Unhook the carriage safety chain, located at the bottom of the vertical mast.

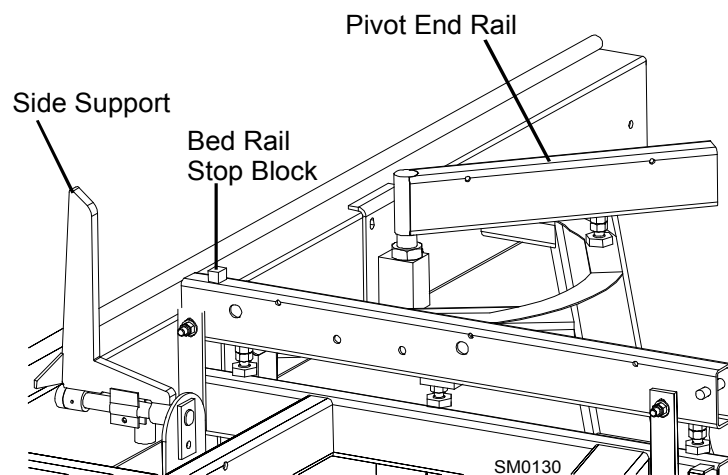


**CAUTION!** To prevent fender damage, remove fenders before operating sawmill or loading logs.

5. Use the to move the cutting head toward the front end of the mill. Lower and set the remaining rear outriggers.
6. Level the sawmill by adjusting the outriggers to raise or lower each end of the sawmill. Adjust all outriggers evenly to avoid twisting the mill frame by jacking one outrigger higher than the others.

Raise the two side supports to prevent the log from falling off the side of the mill when loaded.

See Figure 2-6.



**FIG. 2-6**

## 2.4 Middle Track Cover

Before operating the sawmill do as follows:

1. Clean the upper and lower rails to remove any sawdust and rust preventives.
2. Unbolt and remove the middle track cover from its storage position.
3. Soak the felt wiper with Dexron III transmission fluid, 10W30 motor oil or 3-in-1 turbine oil.
4. Install the middle track cover so it fits against the rail and secure with two thumb screws.



See Figure 2-7.

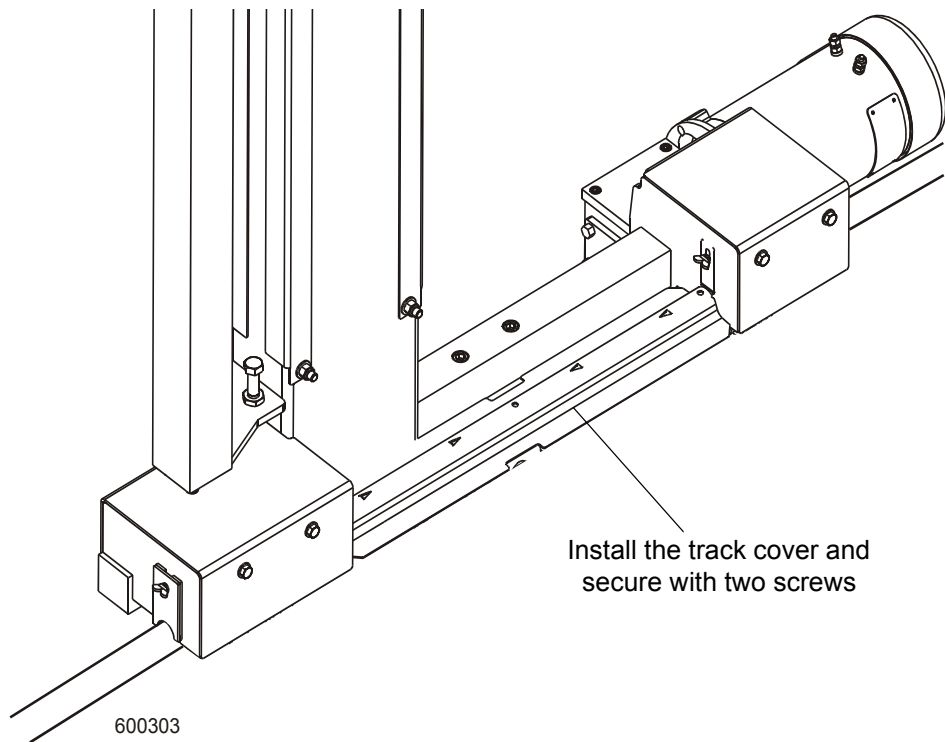


FIG. 2-7

**CAUTION!** Install the track cover so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.

## 2.5 Replacing The Blade

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

**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.

Adjust the blade guide arm all the way open.

Open the two blade housing covers that cover the blade wheels. blade tension. [See Section 2.6](#) until the wheel is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

When installing a blade, make sure the teeth are pointing the correct direction. The teeth should be pointing toward the operator side of the mill when you are looking at the blade below the blade guides. Install the blade so it is lying around the wheels.



**CAUTION!** Be careful when placing the blade between the blade guide inserts. If the blade hits one of the inserts hard enough, it could damage the insert.

Position 1 1/4" wide blades on the wheels so the gullet is 1/8" (3.0 mm) out from the edge of the wheel. Position 1 1/2" wide blades on the wheels so the gullet is 3/16" (4.5 mm) out from the edge of the wheel.

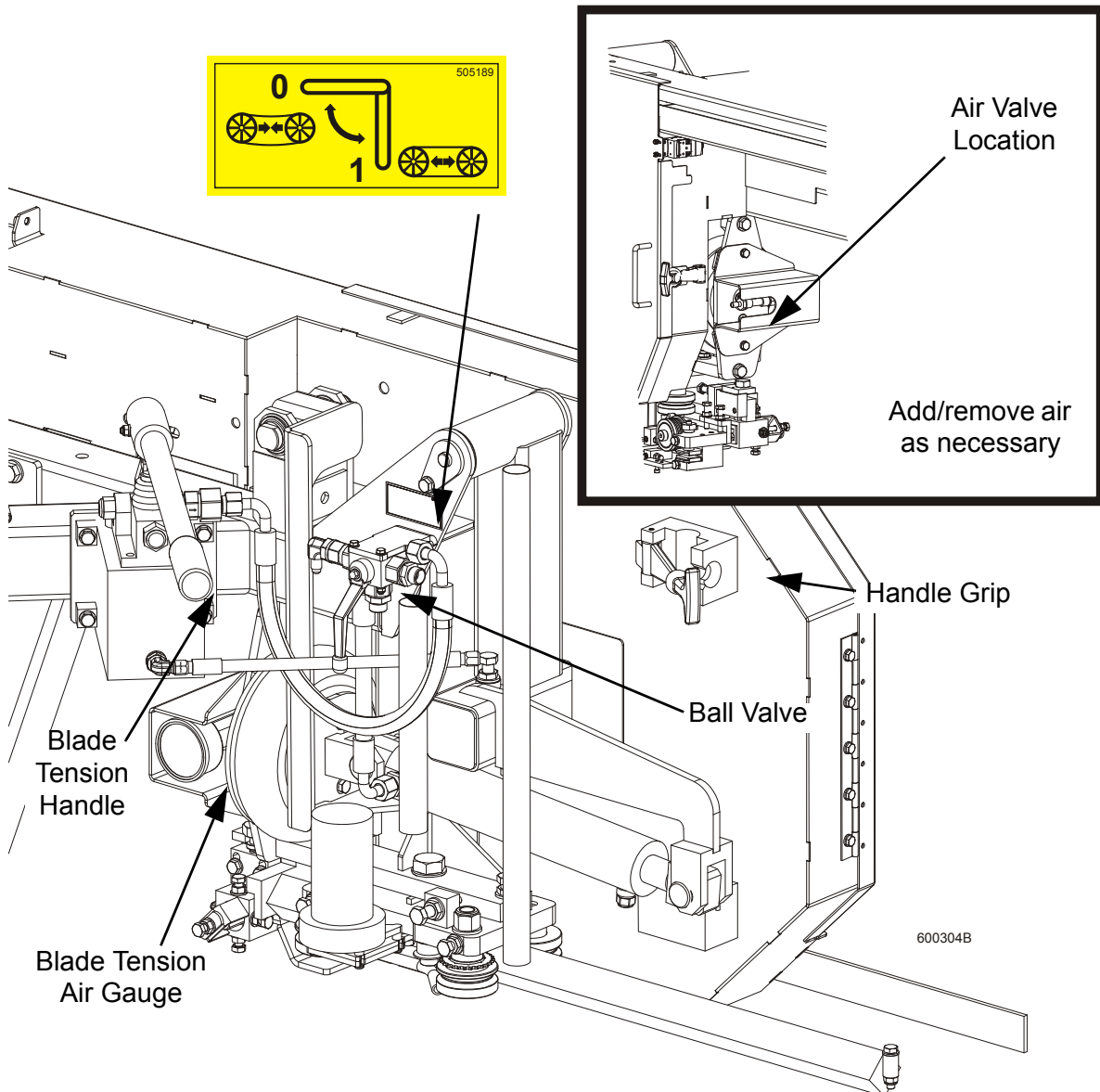
Close the blade housing covers.

Next, tension the blade correctly.

## 2.6 Tensioning The Blade

Before tensioning the blade, check the air pressure gauge to see that the air tension system is properly charged. The gauge should read 44 PSI, i.e. 0.3 MPa (yellow colour) with the blade tension completely released. To add air pressure attach an air pump to the air valve. To release air, push in the valve stem.

See Figure 2-8.



**FIG. 2-8**

To tension the blade use the tension handle, when the ball valve handle is in “1” working position. To release, shift the ball valve handle in “0” losing position. The blade tension handle should be placed in the handle grip when not use.

See Table 2-1. The recommended tension for different blades is shown below.

Blade Type	Blade Dimensions		Tension range	
	Thickness (mm)	Width (mm)	PSI	MPa
2735	1,07	35	60-62	0,41-0,43
3735	1,14	35	65	0,45
276	1,07	38	60-62	0,41-0,43
376	1,14	38	62-65	0,43-0,45
576	1,27	38	65-70	0,45-0,48
476	1,4	38	65-70	0,45-0,48

TABLE 2-1

The tension gauge should be checked occasionally when adjusting the cant control or while cutting. Ambient temperature changes will cause tension to change. Adjust the tension handle as necessary to maintain the recommended tension level.



**CAUTION!** Release the blade tension when the mill is not in use (for example at the end of a shift). Tension the blade again before starting the motor.

## 2.7 Tracking The Blade

1. Turn the key switch to #2 position.
2. Manually spin one of the blade wheels until the blade positions itself on the blade wheels.
3. Check that if the blade is properly positioned on the blade wheels.

See Figure 2-9. Position 1 1/4" wide blades so the gullet is 1/8" (3.0 mm) out from the edge of the blade wheel ( $\pm 1/16$  [1.5 mm]). Position 1 1/2" blades so the gullet is 3/16" (4.5 mm) out from the edge of the blade wheel ( $\pm 1/16$  [1.5 mm]).

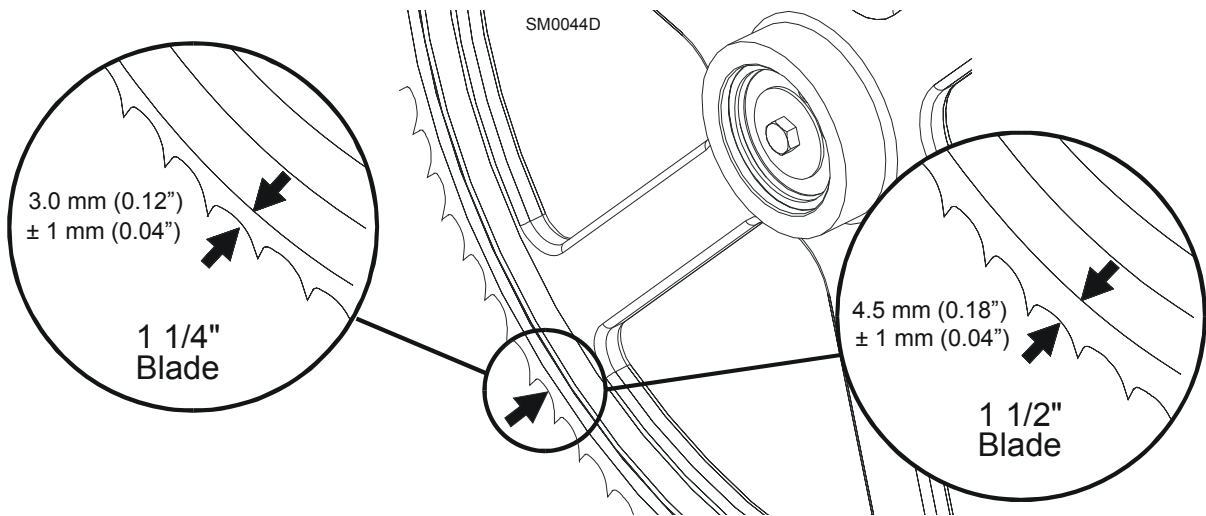


FIG. 2-9

4. Use the cant adjustment bolt to adjust where the blade travels on the blade wheels.

See Figure 2-10.

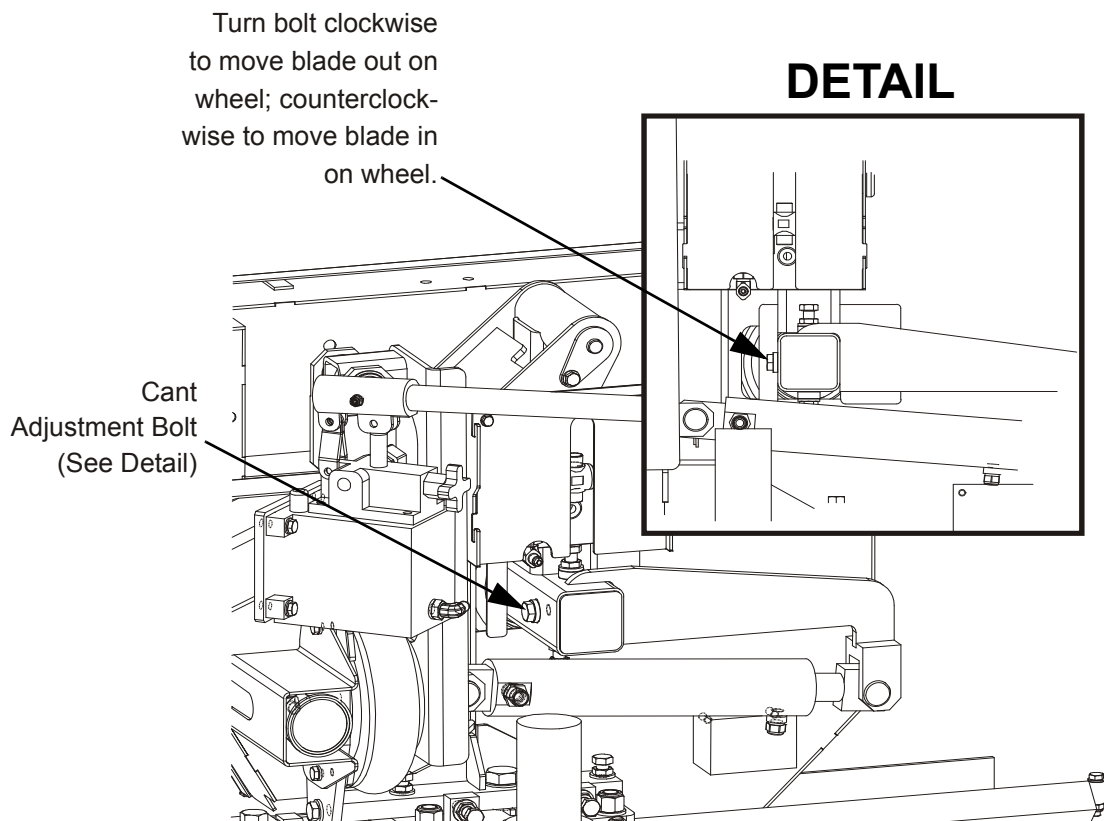


FIG. 2-10

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.

## 2 Setup & Operation

### Starting The Engine

---

**NOTE:** Slight adjustments of the side bolts on the outer blade wheel are usually all that is necessary to track the blade properly. See Section 7.4 for complete blade wheel alignment instructions.

5. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.
6. Spin the blade wheel by hand.
7. Check again the position of the blade on the blade wheels. Repeat Steps 5 and 6 as necessary until the blade tracks on the blade wheels properly.
8. Turn the key switch to #0 position
9. Be sure to close the blade housing and pulley covers when the adjustment is complete.



**DANGER!** Make sure all guards and covers are in place and secured before operating or towing the sawmill. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are closed (i.e. the safety switches located on them are engaged).



**IMPORTANT!** After aligning the blade on the wheels, always double-check the blade guide spacing and location. ([See Section 5](#) for more information.)

## 2.8 Starting The Engine

See the appropriate manual supplied with your specific engine/motor configuration for starting and operating instructions.



**DANGER!** Make sure all guards and covers are in place and secured before operating or towing the sawmill. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

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




**WARNING!** Always wear eye, ear, respiration, and foot protection when operating the sawmill. Failure to do so may result in serious injury.

**DANGER!** Check the sawmill wiring every year. Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician.

**WARNING!** Hazardous voltage inside the electric box is dangerous. Turn the main switch to the OFF (“0”) position and lock out power supply before opening the box door!

**WARNING!** The door of the electric box can be opened only when the main switch is in the “0” position. The door is closed when the switch is in the “1” position. Serious damage to the box may result while opening the door when the main switch is in the “1” position.

10. **CAUTION!**  at any time you need to immediately stop the blade motor, press the emergency stop button on the control box., turning arm and toe boards or cause misalignment

### To Load Logs (non-hydraulic sawmill)

1. Place the loading ramps on the two bed rails that will support the length of the log. **NOTE:** The loading ramps cannot be fastened securely to the bed rail located directly above the tire. Do not use this rail.
2. Position the log at the foot of the ramps.
3. Remove the winch cable from the log turner (if applicable) and route the cable over the top of the log. Wrap the cable around and underneath the log. Hook the cable to the third hole in the log clamp bracket. See *Winch Operation Manual*.
4. Crank the winch to begin rolling the log up the ramps and onto the sawmill bed. Keep the log centered on the ramps as it rolls up.
5. Once the log is on the sawmill bed, place the log clamp in the clamp bracket. This will stop the log from rolling back off the side of the mill when you remove the winch cable.

6.

### To Turn Logs (non-hydraulic sawmill)

1. Use cant hooks or the optional log turner to rotate the log on the sawmill bed. See *Log Turner Manual*.
2. Spin the log against the side supports until it is turned the way you want it for the first cut. If you want to turn the log more, do the following steps.
3. Raise the turner arm to get a new bite on the log.
4. Disengage the clamp.
5. The log can be turned now. Repeat steps 4 through 7 until the log is turned as desired.

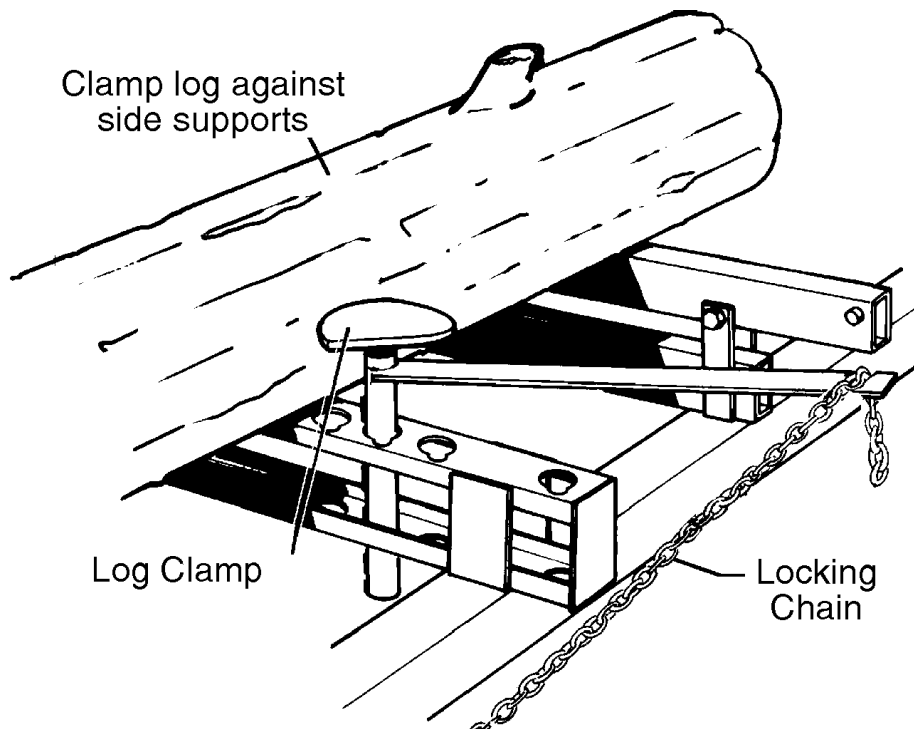
6.

### To Clamp Logs (non-hydraulic sawmill)

1. Position the log clamp in the bracket in the hole closest to the log.

2. Move the clamp down far enough so that it is below your first few cuts. Pivot the clamp so that it moves the log firmly against the side supports. Lock the clamp in position with the locking chain.

See Figure 2-11.



**FIG. 2-11**

3. Make sure the side supports are positioned low enough for the blade to pass over them. If they are not, back the clamp off slightly and push the side supports down until they are positioned below the level of your first few cuts.
4. Use the optional toe boards to level the log if desired. See the manual supplied with the manual toe boards for details concerning toe board operation.

### **To Level A Tapered Log (non-hydraulic sawmill)**

Use the optional toe boards to raise either end of a tapered log, if desired. See the Toe Board Option Manual for operating instructions.



## 2.9 Up/Down Operation

This section describes operation of the up/down system with the standard controls. See the operation section of the Accuset manual for operation of the up/down system using these options.

1. Install a blade, if needed, and check for correct blade tension. ([See Section 2.6](#)).
2. Set the cutting head to the desired height. (The blade height scale shows the height of the blade above the bed rails.)

See Figure 2-12. .

**CAUTION!** DO NOT try to force the carriage above the 35" (88 cm) mark or below the 1" (2.54 cm) mark. Damage to the up/down system may result.

## 2.10 Blade Guide Arm Operation

1. Look down the length of the log to see its maximum width. The outer blade guide should be adjusted to clear the widest section of the log by less than 1" (25.4 mm).

**See Figure 2-13.**

## 2.11 Feed Operation

See Figure 2-14.

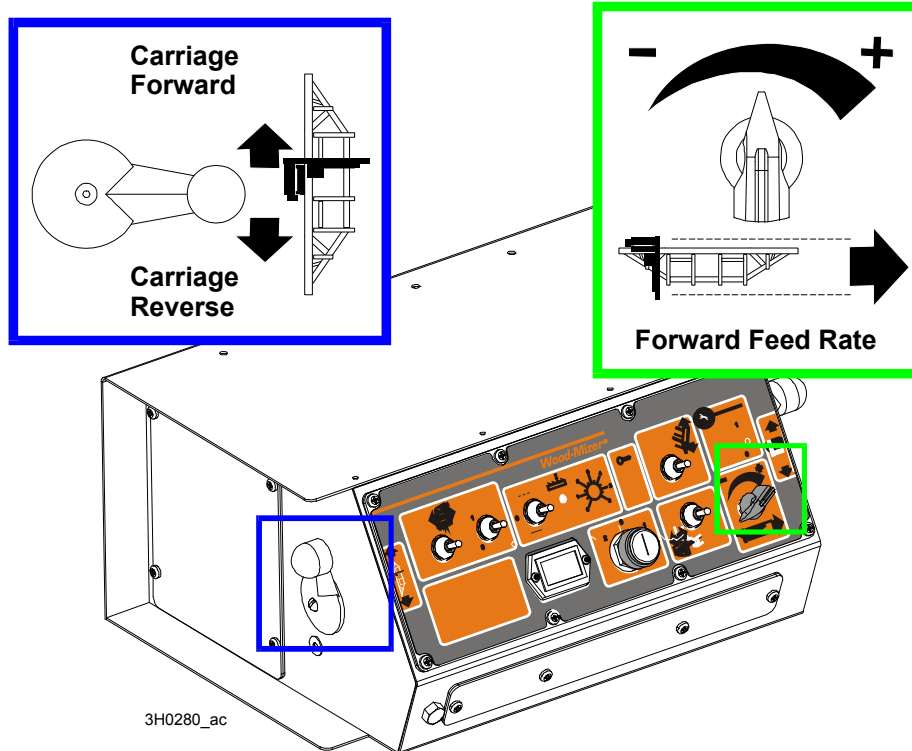


FIG. 2-14

1. To move the carriage forward, push the drum switch handle forward and turn the feed rate switch clockwise.



**HINT:** To get a straight cut in the first part of the board, feed the blade into the log at a slow speed. This stops the blade from flexing and dipping up or down. Turn the carriage feed rate switch to a slow speed until the whole width of the blade has entered the cut. Then use the carriage feed rate switch to increase the feed rate as desired. Maximum feed rate varies with width and hardness of the wood. Over-feeding results in engine and blade wear, and also produces a wavy cut.



2. Stop the carriage at the end of the cut by turning the carriage feed rate switch counterclockwise until the carriage stops moving. Disengage the blade switch down to stop the blade and drop the engine to idle. Remove the board from the top of the log. **Always disengage the blade before returning the carriage for the next cut.**



**CAUTION!** Be sure to stop the blade when returning the carriage. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

3. Make sure that the blade does not catch on the end of the log. Raise the carriage slightly to make sure the blade clears the log when returned.

4. Return the carriage to the front of the mill by pushing the drum switch handle down. The power feed motor will bypass the carriage feed rate switch and the carriage will automatically return at the fastest speed available.

**HINT:** Try to stop the blade while the heel of the blade is still on the log. Then bring the carriage back without adjusting the blade up. This lets you keep the blade at the current height setting so you can make the next blade height adjustment more quickly.



**DANGER!** Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.

## 2.12 Cutting The Log

The following steps guide you through normal operation of the Wood-Mizer sawmill.

1. Once the log is placed where you want it and clamped firmly(#1)
2. Use the blade height scale to determine where to make your first cut ([See Section 2.14](#)). The blade height scale will help you to do this. Set the blade to the desired height with the up/down. Make sure that the blade will clear all side supports and the clamp. Adjust the outer blade guide to clear the widest section of the log by moving the blade guide
3. Make sure all covers and guards are in place. Start the engine.
4. Start the water lube if necessary to prevent sap buildup on the blade. [See Section 2.15](#).
5. Feed the blade into the log slowly ([See Section 2.11](#)). Once the blade completely enters the log, increase the feed rate as desired. Always try to cut at the fastest speed you can while keeping an accurate cut. Cutting too slowly will waste blade life and lower production!
6. As you get to the end of the log, slow down the feed rate. When the teeth exit the end of the log, turn the feed rate all the way down and turn the blade switch to "0" position. Remove the slab that you have just cut from the log.
7. Use the to return the carriage to the front of the mill. Always disengage the blade before returning the carriage for the next cut.
8. Repeat until the first side of the log is cut as desired. Set aside the usable fitches (boards with bark on one or both sides). You can edge them on the mill later.

9. Lower the toe boards, if they were used. the log 90 or 180 degrees. Make sure the flat on the log is placed flat against side supports if turned 90 degrees. Make sure it is placed on bed rails if turned 180 degrees. If the log was turned 90 degrees and you are using toe boards to compensate for taper in the log, raise the front or rear toe board again on the second side of the log until the heart is parallel with the bed.
10. Repeat the steps used to cut the first side of the log until the log is square. Cut boards from the remaining cant by adjusting the blade height for the thickness of boards that you want.

**Example:** Remember that the blade cuts a 1/16 - 1/8" (1.6-3.2 mm) wide kerf. If you want 1" (25.4 mm) thick boards, lower the carriage 1 1/16 - 1 1/8" (27-28.6 mm) for each board.

### 2.13 Edging

The following steps guide you through edging boards on the Wood-Mizer sawmill.

1. Raise the side supports to 1/2 the height of the flitches, or the boards that need to be edged.
2. Stack the flitches on edge against the side supports.
3. Clamp the flitches against the side supports halfway up the flitch height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other flitches or without having to pull them from the middle of the stack).
4. Adjust the blade height to edge a few of the widest boards.
5. Loosen the clamp and turn the edged boards over to edge the other side.
6. Repeat steps 2-4.
7. Loosen the clamp and remove the boards that have good clean edges on both sides. Clamp the remaining flitches and repeat steps 2-5.

### 2.14 Blade Height Scale

See **Figure 2-15**. The blade height scale is attached to the carriage head frame. It includes:

- blade height indicator
- an inch scale
- a quarter scale

#### Blade Height Indicator

The blade height indicator has two horizontal, red lines on both sides. Readings should be taken with eyes level with the indicator, when the two red lines are in line. This will allow to avoid the parallax error (different scale readings depending on the angle of vision).

## The Inch Scale

The horizontal red line on the blade height indicator shows how many inches the bottom of the blade is above the bed of the mill. If you know the height of your blade at each cut, you can determine the thickness of lumber you are sawing.

**Example:** You want to cut 1" (25 mm) random width boards from a log. Position the blade for the first cut. Move the carriage to an even measurement on the inch scale. Make a trim cut. Return the carriage for the second cut and lower it 1 1/8" (29 mm) below the original measurement. (The extra 1/8" (3 mm) allows for saw kerf and shrinkage of the lumber.)

The yellow area on the scale identifies where the blade could encounter a side support or log clamp. Check that these items are below the blade level before sawing.

## The Quarter Scale

**See Table 2-2.** four sets of marks. Each set represents a specific lumber thickness. Saw kerf and shrinkage allowance are included, but actual board thickness will vary slightly depending on blade thickness and tooth set.

To choose which scale to use, determine what finished thickness you want to end up with. The Grade Hardwood Quarter Scale provides thicker finished boards usually required by commercial buyers. The Standard Quarter Scale allows for kerf and shrinkage of finished boards suitable for most custom applications. Always check with your customer before you saw to determine what actual finished thickness is required.

Standard Quarter Scale		Grade Hardwood Quarter Scale	
Scale	Actual Board Thickness	Scale	Actual Board Thickness
4/4	1" (25 mm)	4/4	1 1/8" (29 mm)
5/4	1 1/4" (32 mm)	5/4	1 3/8" (35 mm)
6/4	1 1/2" (38 mm)	6/4	1 5/8" (41 mm)
8/4	2" (51 mm)	8/4	2 1/8" (54 mm)

TABLE 2-2

To use the quarter scale, look at the blade height indicator.**Example:** You want to cut 1" (25 mm) (4/4) random width boards from a log. Position the blade for the first cut. Make a trim cut. Return the carriage for the second cut. Now, instead of having to measure down 1 1/8" (29 mm) on the inch scale, you can simply lower the blade so the indicator is aligned with the next 4/4 mark on the quarter scale. Turn the log 90 degrees and repeat.

## 2.15 Water Lube Operation

**See Figure 2-16.** 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.

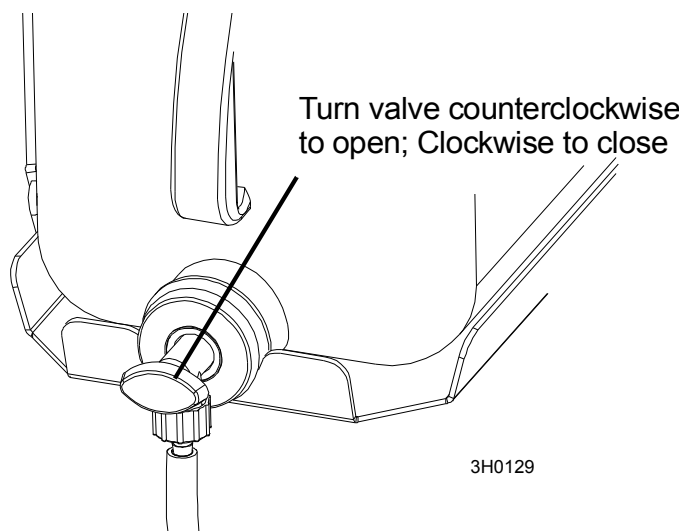



FIG. 2-16

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. A squirt of liquid dishwashing detergent in the water bottle will help clean the blade when cutting wood with a high sap content.

 **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, engage the clutch/brake lever. 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 sawmill when done sawing and store it in a warm place. Blow any remaining water from the water lube hose.

**NOTE:** If your sawmill is equipped with LubeMizer System, please refer to LubeMizer Operation Manual.

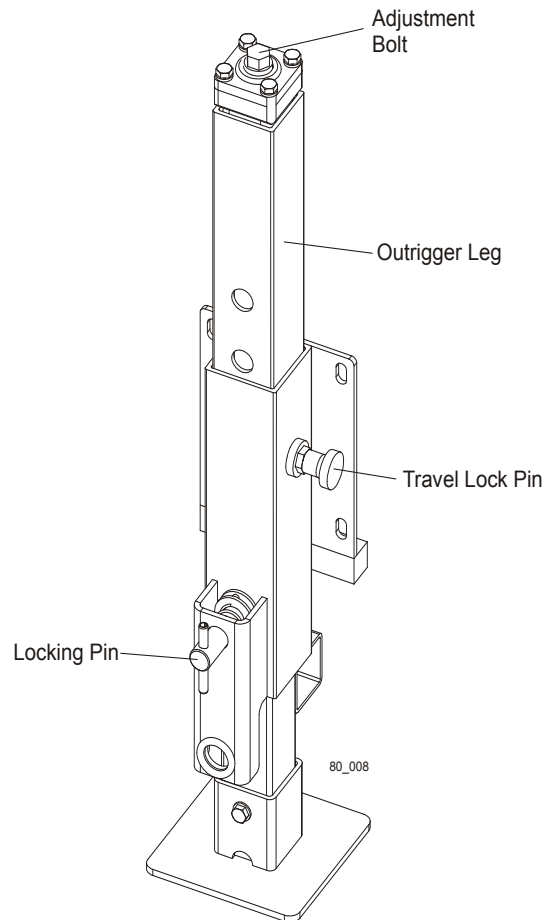
## 2.16 Preparing The Sawmill For Towing

The Wood-Mizer trailer package makes transporting your sawmill easy and convenient. To get your sawmill ready for towing, follow these instructions.

1. Move the saw carriage to the front end of the sawmill. Raise the rear outriggers.



See Figure 2-17. Secure outrigger with both Locking Pin and Travel Lock Pin.



**FIG. 2-17. ADJUSTABLE OUTRIGGER.**



**CAUTION!** Be sure the outrigger base is adjusted properly before securing in travel position with the lock pin.

2. Move the carriage forward to the travel position over the rear bed rail. Position the hole in the saw head over the travel rest pin.
3. Move the rest pin to its travel position. Secure the rest pin using locking pin.

See Figure 2-18.



**FIG. 2-18**

4. Lower the saw head until it contacts the stop blocks on the mast rails. Secure the saw head with saw head protection belt.

See Figure 2-19.

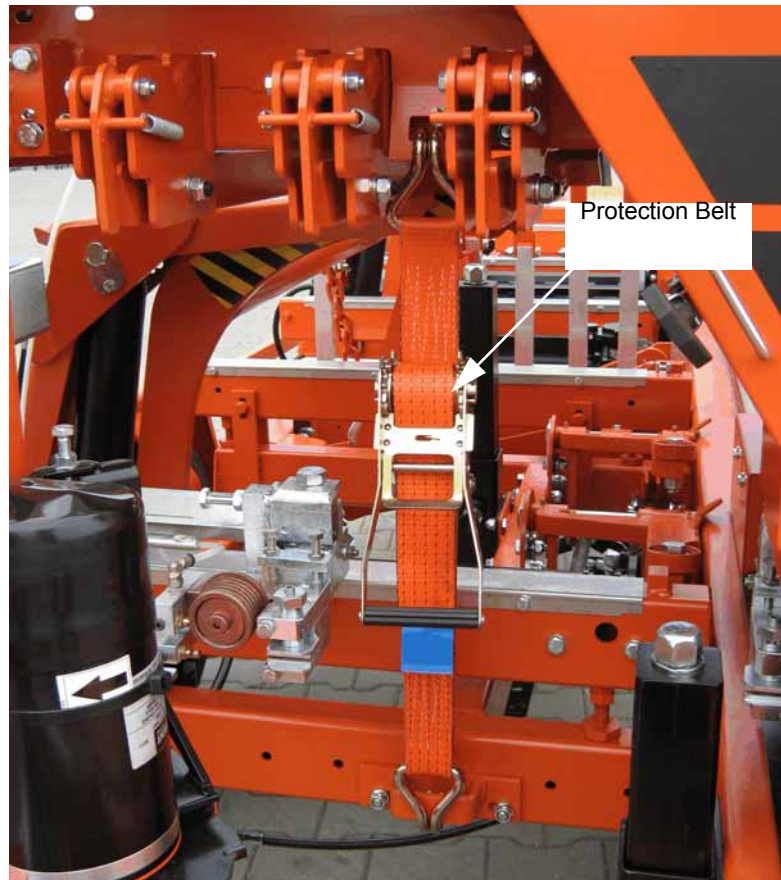


FIG. 2-19



**CAUTION!** It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

5. If necessary, adjust the two stops located at the bottom of the mast so the saw head contacts them after it is lowered 3/4" (19mm) past where it contacts the rest pin.

See Figure 2-20.

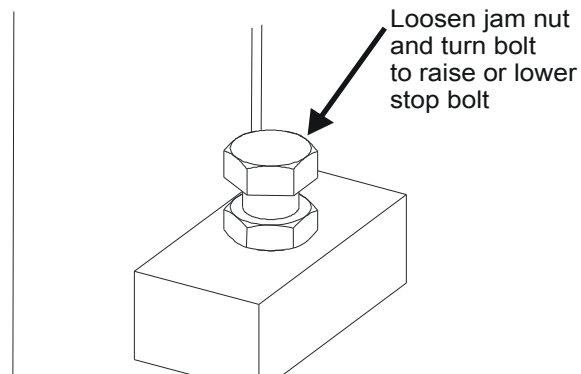


FIG. 2-20

6.

- Hook the carriage safety chain located at the bottom of the carriage to the bracket at the bottom of the mast.

See Figure 2-21.

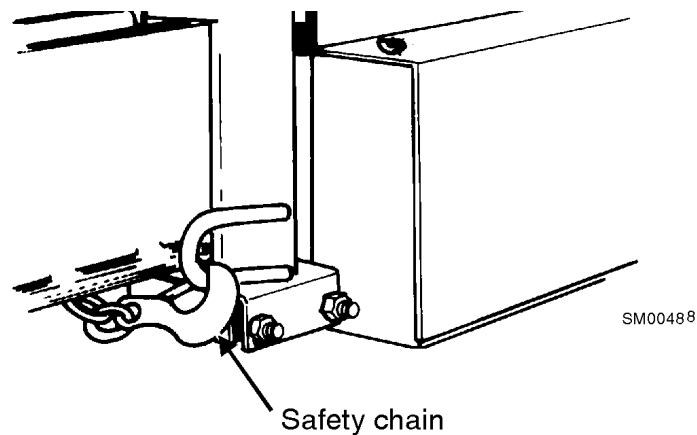


FIG. 2-21



**CAUTION!** Check to be sure the saw head safety chain is secured before towing the sawmill. Failure to properly secure the saw head can result in severe machine damage. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

- Remove all loose objects from the bed of the mill.
- Place both fenders in the slots located behind the trailer tires and secure with retaining pins. Raise all but the very front outrigger.

See the trailer operator's manual for specific information regarding hitch operation and towing the

sawmill.

## SECTION 3 MAINTENANCE

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



**WARNING!** Disconnect and lock out power supply before servicing, cleaning and doing maintenance to the saw! Failure to do so may result in serious injury.

The Short Interval Maintenance Schedule lists procedures that need to be performed every 4, 8 or 25 hours. The Maintenance Log lists procedures that need to be performed every 50, 100, 200, or 1000 hours. Keep track of machine maintenance by filling in the machine hours and the date you perform each procedure.



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

Be sure to refer to option and engine manuals for other maintenance procedures.

### 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 sawmill 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
Blade Wheel Belt B72.5 <sup>1</sup>	500 hours
Up/Down Motor	2000 hours
Up/Down Drum Switch	1000 hours
Blade Guide Rollers	1000 hours
Power Feed Drum Switch	1200 hours
Drive Belt	1250 hours
Power Feed Motor	1500 hours
Up/Down Belt	2000 hours

**TABLE 3-1**

<sup>1</sup> To insure proper blade tracking, use Goodyear, Dayco Super II, or Browning belts only.

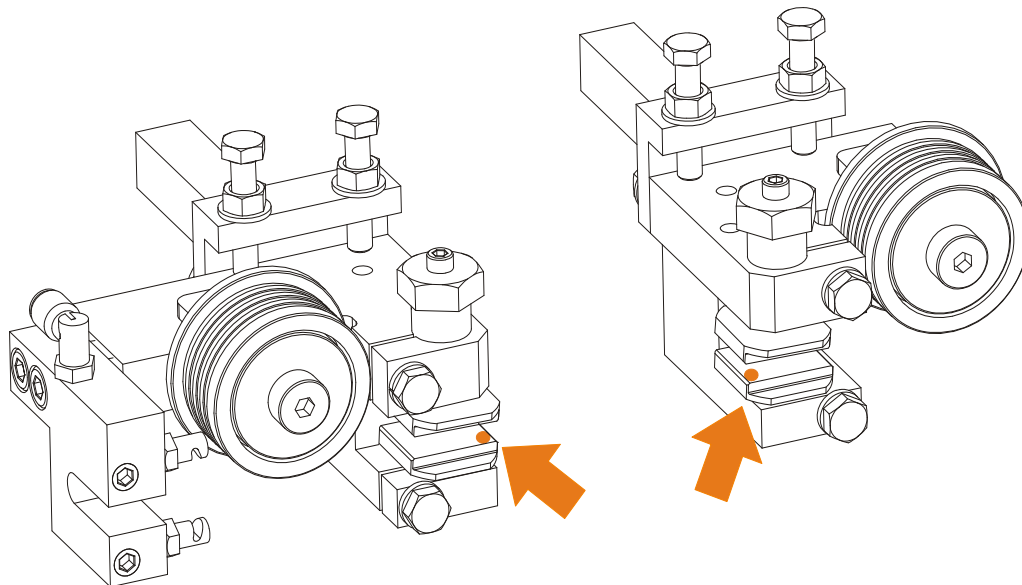
## 3.2 Blade Guides

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.

### Steel Guide Blocks

2. Inspect the blocks at every blade change for damage or wear.

As the blocks wear, the front inside corner will wear more than the body of the block. When the corner wears far enough, sawing performance will be affected even if the body of the block is adjusted properly to the blade. At this point, the block should be replaced. If you have access to the appropriate equipment, you can grind or mill the blocks to a new flat surface and reuse them. It is recommended you develop a routine schedule for replacing the blade guide blocks based on your sawing conditions and experience.



RYS. 3-0

3. Check the inserts are properly spaced from the bottom of the blade every 25 hours of operation. As the rollers wear, the gap between the blade and inserts will become larger. Use the provided shim or a feeler gauge to check the inserts are adjusted 0,3-0,5 mm from the blade.

25

**See Figure 3-1.** To adjust the disks up, loosen the bottom guide disk mounting bolt and clamp bolt. Use the provided adjustment tool. to raise bottom disk Retighten the bottom disk mounting bolt and clamp bolt. [See Section: Blade Disk Adjustment](#)



**IMPORTANT!** The disks should be parallel to the blade. Check the space between the disks and the blade at each side of the disks to insure it is parallel. Use the appropriate adjustment bolt to tilt the disks

mounting plate so the insert is parallel to the blade.

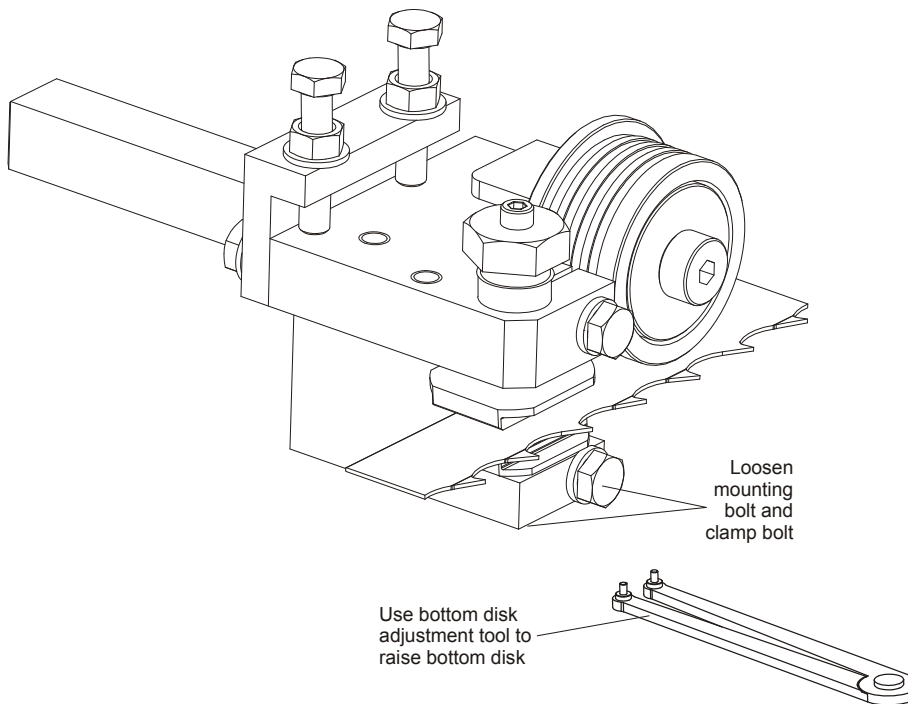


FIG. 3-1



Inspect the blade guide assemblies for proper alignment every time you change the blade. [See Section: Blade Guides](#) for blade guide adjustment instructions.



**WARNING!** Blade guide alignment is essential for optimal cutting performance, blade life and safety. Failure to check and maintain proper blade guide alignment will result in stress cracks forming in the blade. These cracks will lead to premature blade breakage. If the blade breaks during operation and the blade has multiple stress cracks, the blade could shatter into several pieces and escape from the protective guards of the sawmill. Small blade pieces projected into the area around the sawmill creates a safety hazard for the operator and any bystanders surrounding the mill.



**WARNING!** DO NOT use blades with stress cracks. Blades with stress cracks can shatter causing bodily injury and/or machine damage.

Preventing sap buildup on the blade is critical when using the high-performance blade guide system. If the wood you are sawing leaves sap buildup using plain water in the blade lube system, use Wood-Mizer lube additive (Part No. 033439).

#### Throat Bolt

Make sure the blade bolt in the top center of the C-frame is 1.5 mm (1/16") away from the blade. If not, loosen the nut and adjust the bolt as necessary. Check the bolt every blade change. Failing to maintain this adjustment will lead to early blade breakage.



See Figure 3-2.

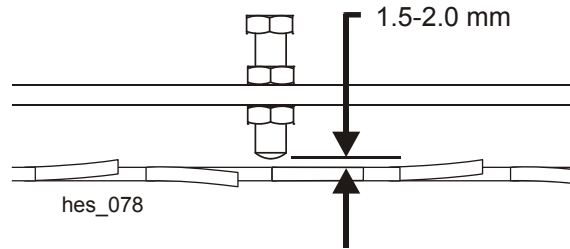


FIG. 3-2

### 3.3 Sawdust Removal

1. Remove the excess sawdust from the blade wheel housings and sawdust chute every blade change.
- 8 2. Remove all sawdust and debris from around the velocity fuse valves every 8 hours of operation. The valves are located at the bottom of the log loader cylinders. Remove sawdust buildup from the track rail cover.

### 3.4 Carriage Track, Wiper & Scrapers

Properly maintaining the sawmill carriage track is critical in preventing corrosion that can cause pitting and scaling on the rail surfaces. Pitted and scaled surfaces can, in turn, cause rough cuts or jerky power feed movement

See Figure 3-3.

- 8 1. Clean track rails to remove any sawdust and sap buildup every eight hours of operation.

Use a light-grade sandpaper or emery cloth to sand off any rust or other adhering particles from the rails.



**CAUTION!** Keep track rails free of rust. Formation of rust on the track rail in the areas where the cam bearings roll can cause rapid deterioration of the track rail's surface.

Lubricate the rails by wiping them with Dexron III ATF transmission fluid, 10W30 motor oil, or 3-in-1 turbine oil. Oil lubrication will help protect the rails from corrosive elements such as acid rain and/or moisture from nearby bodies of saltwater (if applicable). This lubrication is essential to maintain the integrity of the track rails and track rollers and to achieve long service life.

- 25 2. Remove sawdust from the track roller housings and lubricate the felt track wiper every twenty-five hours of operation.

Remove the track roller housing covers and brush any sawdust buildup from the housings.

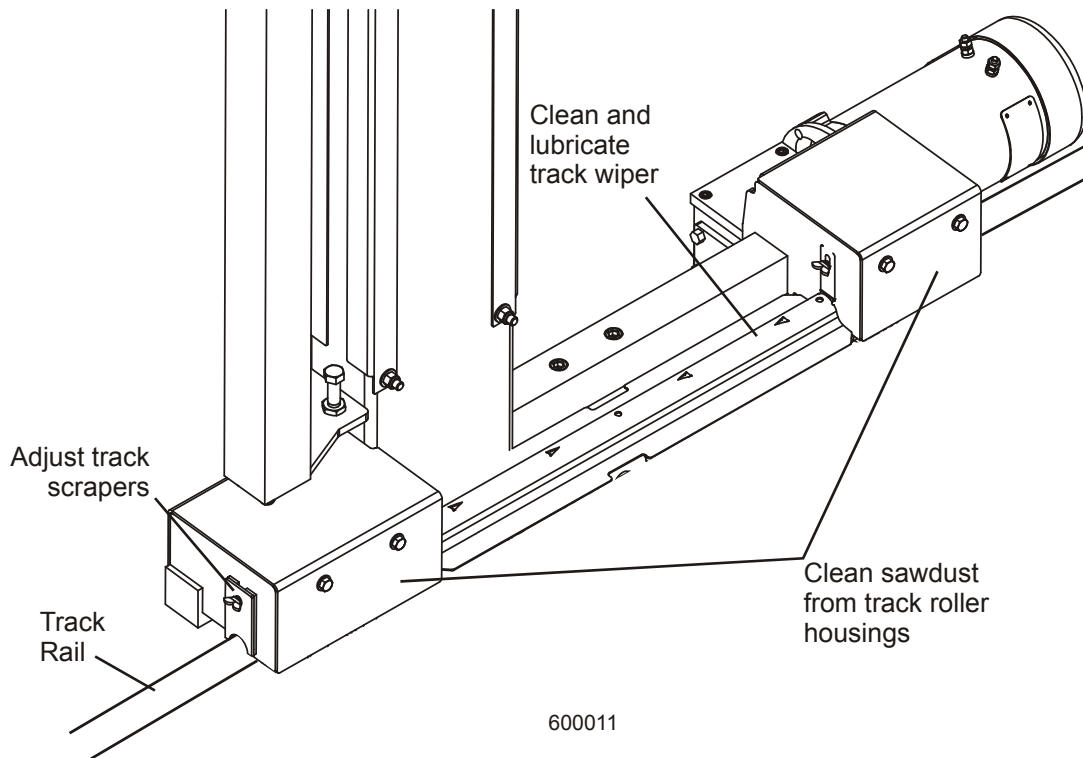
3. Check the track scrapers as needed. Make sure the scrapers fit firmly against the rail. If a track scraper needs to be adjusted, loosen the thumb screw, push the scraper downward until it fits firmly

against the rail, and retighten the thumb screw.

Clean and lubricate the upper track wiper every twenty-five hours of operation. Unbolt the wiper, remove it from the sawmill, and remove any sawdust buildup. Soak the felt wiper with Dexron III transmission fluid, 10W30 motor oil or 3-in-1 turbine oil.


25

**CAUTION!** Reinstall the track wiper so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.



**FIG. 3-3**


### 3.5 Vertical Mast Rails

 Clean and lubricate the vertical mast rails every 50 hours of operation. Clean with solvent and remove any rust with a light-grade sand paper or emery cloth. Lubricate the mast with motor oil or automatic transmission fluid (ATF).




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


### 3.6 Miscellaneous


 1. Oil all chains with Dexron III ATF every fifty hours of operation.



**CAUTION!** Do not use chain lube. It causes sawdust buildup in chain links.

 2. Apply a thin film of a NLGI No. 2 grade lithium grease to the blade guide arm every fifty hours of operation to help prevent it from rusting.

 3. Adjust the blade guide arm drive chain as necessary. To adjust the chain, loosen the blade guide arm motor mounting plate bolts and slide the motor to take slack out of the chain

 4. Grease the clamp mechanism, loading arms and side supports with a NLGI No. 2 grade lithium grease every fifty hours of operation.

5. Check the mill alignment every setup. See Section 5, Alignment of Sawmill Operators Manual.


6. 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.

7.

### 3.7 Drive Belt Adjustment



**DANGER!** Never adjust the drive belts while the engine is running. Failure to do so may result in serious injury.

 Periodically check the drive belt for wear. Replace any damaged or worn belts as needed.

**See Figure 3-4.** Adjust proper drive belt tension using the bolt located between the drive side wheel covers. To tighten drive belt turn the bolt clockwise. To loosen drive belt turn the bolt counter clock-

# 3 Maintenance

## Drive Belt Adjustment

wise.

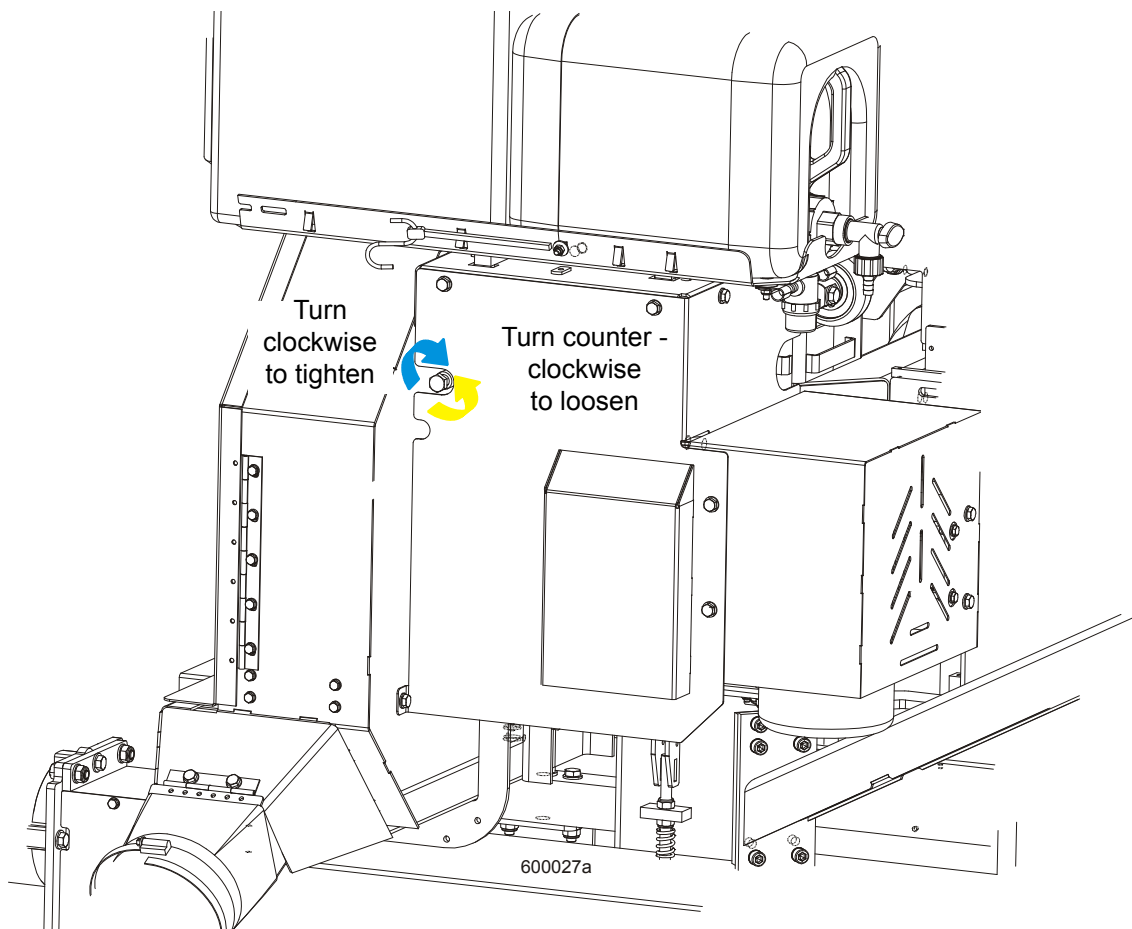


FIG. 3-4

### 3.8 Up/Down System

750

Adjust the up/down chain tension as needed. Measure chain tension with the head all the way to the top of the vertical mast. Find the chain adjusting bolt at the bottom of the mast. Use the adjustment nut to adjust the bolt until the center of the chain can be deflected 3/4" (1.9cm) with a 5 lb. (2.3 KG) deflection force.



**CAUTION!** Do not over-tension the chain. Over-tensioning the chain may lead to early failure of the gear reducer.

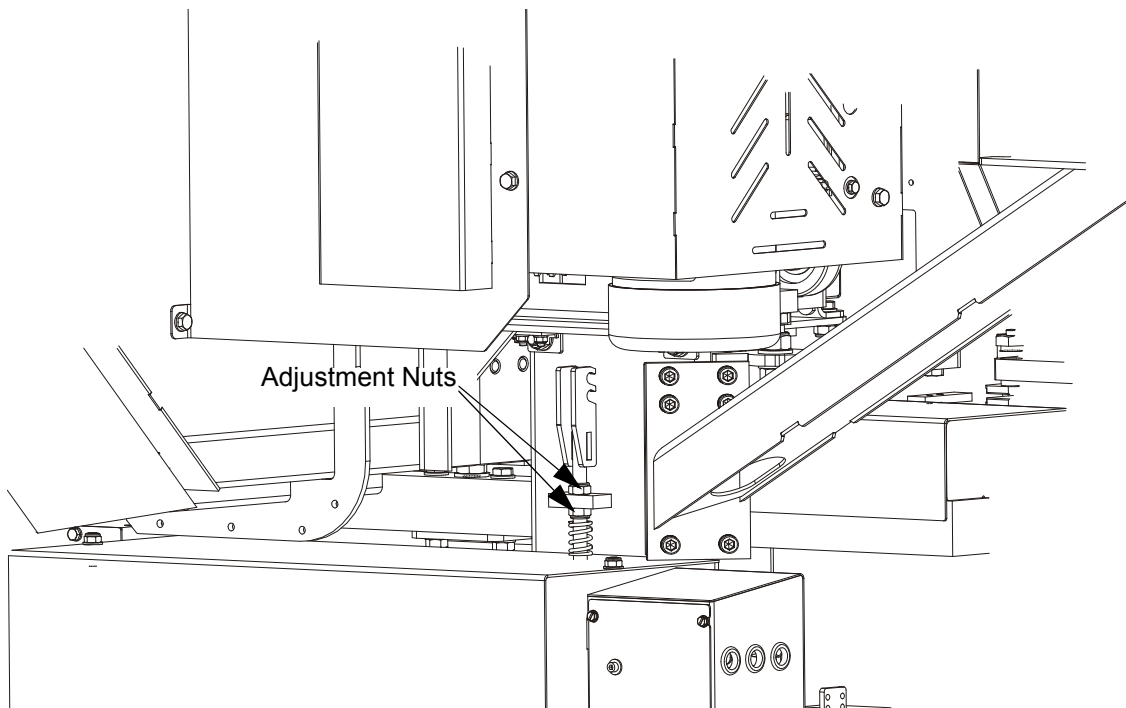


FIG. 3-4

1. Adjust the motor belt tension as needed. To do this, loosen the motor mounting bolts and turn adjustment bolts clockwise or counterclockwise evenly, until the belt is properly tensioned. Tighten the motor mounting bolts.

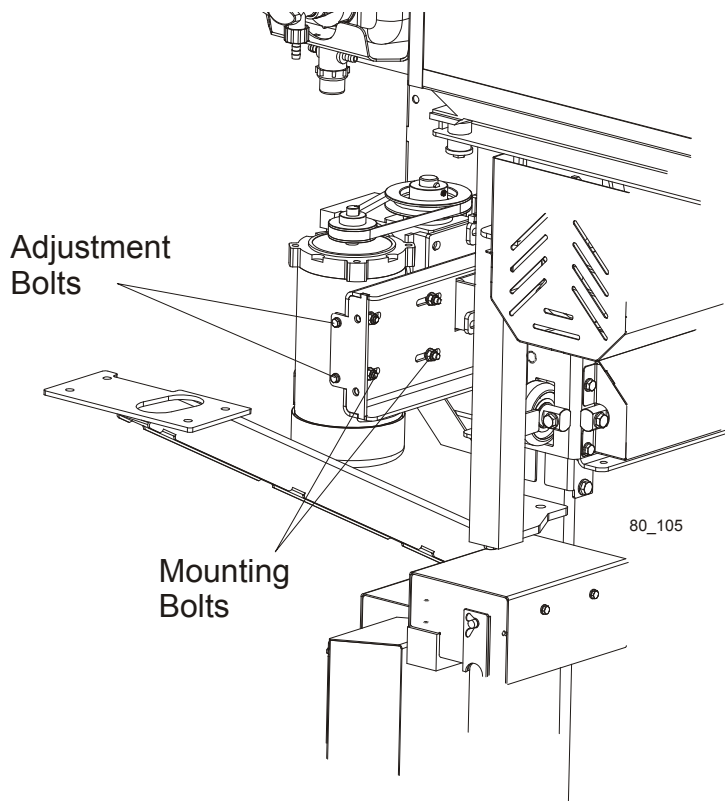


FIG. 3-4



Periodically check the belt for wear. Replace any damaged or worn belts as needed.

2. When oil leaks from the gear reducer please contact Customer Service.

### 3.9 Power Feed

1. Adjust the power feed chain as needed. Measure the power feed chain tension with the saw head all the way toward the front of the mill. Use the two lock nuts at the rear of the mill to tighten or loosen the power feed chain. Adjust the chain until it measures 7 to 8 inches (17.8 to 20.3 cm) from the top of the top rail at its lowest point.



**CAUTION!** Do not overtighten the feed chain. Damage to the power feed motor may result.

See Figure 3-5.

- 2.

### 3.10 Hydraulic System (Sawmill with Hydraulic Only)

50

1. Check the hydraulic fluid level every fifty hours of operation. Add fluid as necessary. The level in the hydraulic pump should be 3/4" (19mm) from the top with all cylinders collapsed.

If humidity is a problem or the mill is used outside in humid weather, drain and replace two quarts (.95 liters) of fluid every six months. This will drain any accumulated water and help prevent pump failure due to water ingestion. It also will prevent excessive fluid wear and allow the fluid to maintain its hot end performance. If humidity is not a problem, drain and replace one gallon (3.8 liters) of fluid every year to prevent fluid wear.

**See Figure 3-6.** If you are operating in temperatures -20° to 100° F (-29° to 38° C), use an all-weather hydraulic fluid such as Exxon Univis J26. For alternate fluids and/or other temperature ranges, refer to the chart below. Operating above the recommended temperature range of a fluid could result in excessive pump wear. Operating below the recommended temperature range could result in reduced hydraulic cylinder speed.

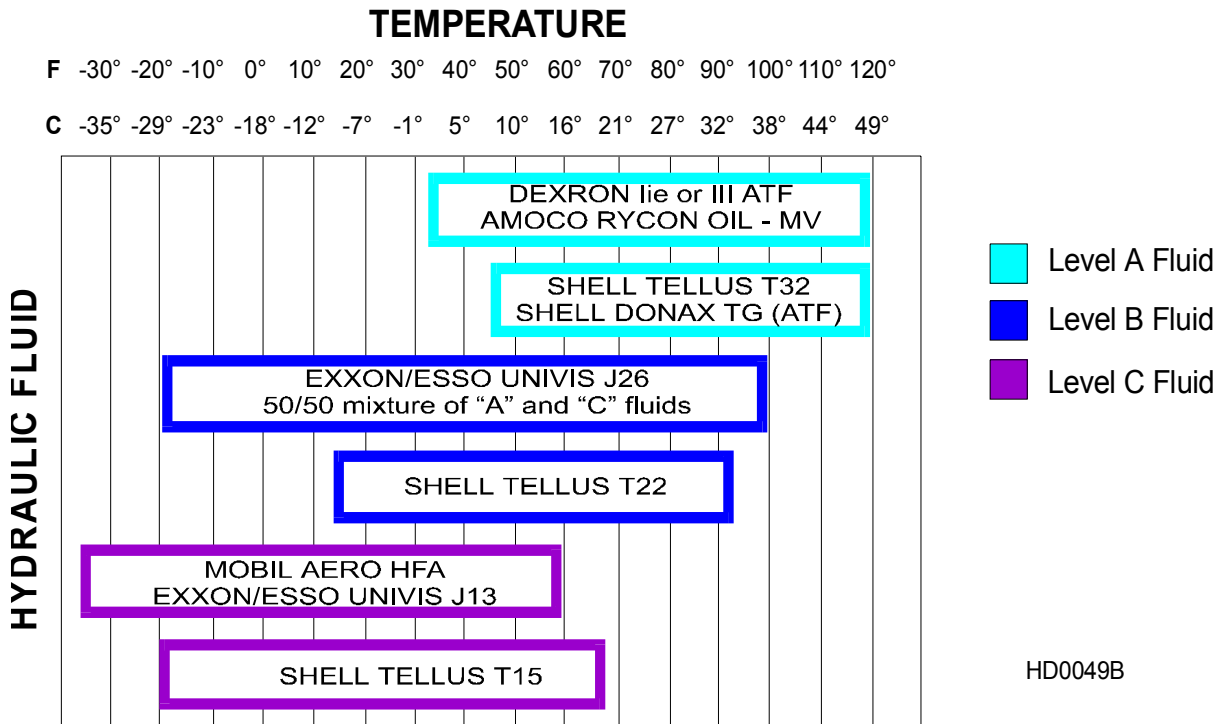


FIG. 3-6

500

Replace the hydraulic system cartridge filter every 500 hours of operation.

Periodically check all hydraulic lines and fitting as needed. Replace as necessary.

### 3.11 Safety Devices Inspection

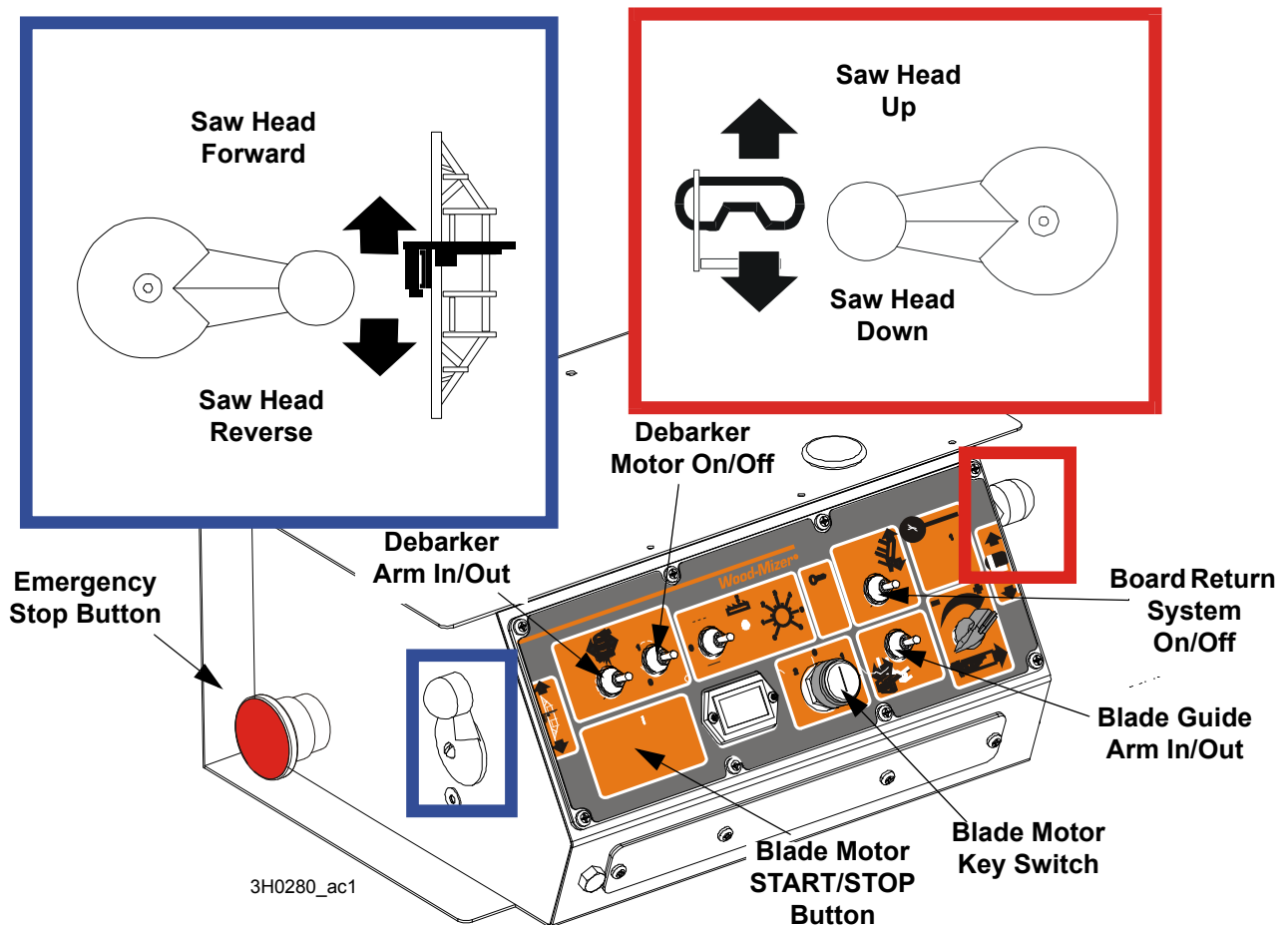
#### *LT70 AC – Safety Devices Inspection*

Safety devices on the LT70AC machine which must be checked before every shift:

- E-STOP button and its circuit inspection
- Inspection of the control circuits with the E-STOP button pressed
- Blade cover safety switch #1 and its circuit inspection
- Blade cover safety switch #2 and its circuit inspection
- Motor brake and its circuit inspection

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

- Turn on the blade motor;
- Press the E-STOP button located on the left side of the control box. The blade motor should be stopped. Pressing the START button should not start the motor until the E-STOP button is released.





## **2. Inspection of the control circuits with the E-STOP button pressed**

- Turn on the blade motor;
- Press the E-STOP button located on the left side of the control box. The blade motor should be stopped.
- With E-STOP button pressed, try to move the saw head up and down using the switch and the Setworks buttons and forward/backward using the power feed switch. Both systems should not start.
- With E-STOP button pressed, try to start the debarker blade motor and move the debarker arm in and out. The debarker should not work.
- With E-STOP button pressed, try to move the blade guide arm in and out. The blade guide arm should not work.
- With E-STOP button pressed, try to start the board return system. The board return system should not work.

## **3. Blade cover safety switch #1 and its circuit inspection.**

- Turn on the blade motor;
- Open the blade housing cover #1;
- The blade motor should be stopped;
- Try to start the motor. The blade motor should remain stopped;
- Close the blade housing cover #1;
- The blade motor should remain stopped until it is restarted with the START button.

## **4. Blade cover safety switch #2 and its circuit inspection.**

- Turn on the blade motor;
- Open the blade housing cover #2;
- The blade motor should be stopped;
- Try to start the motor. The blade motor should remain stopped;
- Close the blade housing cover #2;
- The blade motor should remain stopped until it is restarted with the START button.

## **5. Motor brake and its circuit inspection**

- Turn on the blade motor. Stop the motor using the STOP button. Measure the braking time.
- Turn on the blade motor. Stop the motor by switching the key to the “0” position. Measure the braking time.
- Turn on the blade motor. Stop the motor by switching the key to the “2” position. Measure the braking time.

- The braking time should always be shorter than 10 seconds. If the braking time is longer, it is necessary to adjust or replace the motor disk brake. See your motor option manual.

# MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

## DAILY MAINTENANCE PROCEDURES

Lubricate Blade Guide Rollers	<a href="#">See Section 5.2</a>	Daily - Every 4 Hours	DAILY MAINTENANCE PROCEDURES									
Check Blade Screw	<a href="#">See Section 5.2</a>	Daily - Every Blade Change										
Check Blade Guide Roller Performance	<a href="#">See Section 5.2</a>	Daily - Every Blade Change										
Remove Excess Sawdust From Blade Wheel Housings And Sawdust Chute	<a href="#">See Section 5.3</a>	Daily - Every Blade Change										
Clean Sawdust From Hydraulic Loader Fuses, Battery Box Lid & Track Cover	<a href="#">See Section 5.3</a>	Daily - Every 8 Hours										
Clean And Lubricate Track	<a href="#">See Section 5.4</a>	Daily - Every 8 Hours										
Remove Sawdust From Upper Track Roller Housings	<a href="#">See Section 5.4</a>	Bi-Weekly - Every 25 Hours										
Clean And Lubricate Upper Track Wiper	<a href="#">See Section 5.4</a>	Bi-Weekly - Every 25 Hours										
PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.										
		50 HRS	100 HRS	150 HRS	200 HRS	250 HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS	
Clean & lube mast rails	<a href="#">See Section 5.5</a>											
Lubricate drum switches	<a href="#">See Section 5.5</a>											
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>											
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>											
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>											
Check brake strap tension	<a href="#">See Section 5.8</a>											
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>											
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>											
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>											
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>											
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>											
Check hydraulic fluid level	<a href="#">See Section 5.10</a>											
Replace hydraulic system filter	<a href="#">See Section 5.10</a>											
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>											
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>											

# MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		550 HRS	600 HRS	650 HRS	700 HRS	750 HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS
Clean & lube mast rails	<a href="#">See Section 5.5</a>										
Lubricate drum switches	<a href="#">See Section 5.5</a>										
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>										
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>										
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>										
Check brake strap tension	<a href="#">See Section 5.8</a>										
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>										
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>										
Check hydraulic fluid level	<a href="#">See Section 5.10</a>										
Replace hydraulic system filter	<a href="#">See Section 5.10</a>										
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>										

# MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1050 HRS	1100 HRS	1150 HRS	1200 HRS	1250 HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS
Clean & lube mast rails	<a href="#">See Section 5.5</a>										
Lubricate drum switches	<a href="#">See Section 5.5</a>										
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>										
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>										
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>										
Check brake strap tension	<a href="#">See Section 5.8</a>										
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>										
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>										
Check hydraulic fluid level	<a href="#">See Section 5.10</a>										
Replace hydraulic system filter	<a href="#">See Section 5.10</a>										
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>										

# MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1550 HRS	1600 HRS	1650 HRS	1700 HRS	1750 HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS
Clean & lube mast rails	<a href="#">See Section 5.5</a>										
Lubricate drum switches	<a href="#">See Section 5.5</a>										
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>										
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>										
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>										
Check brake strap tension	<a href="#">See Section 5.8</a>										
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>										
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>										
Check hydraulic fluid level	<a href="#">See Section 5.10</a>										
Replace hydraulic system filter	<a href="#">See Section 5.10</a>										
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>										

# MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2050 HRS	2100 HRS	2150 HRS	2200 HRS	2250 HRS	2300 HRS	2350 HRS	2400 HRS	2450 HRS	2500 HRS
Clean & lube mast rails	<a href="#">See Section 5.5</a>										
Lubricate drum switches	<a href="#">See Section 5.5</a>										
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>										
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>										
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>										
Check brake strap tension	<a href="#">See Section 5.8</a>										
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>										
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>										
Check hydraulic fluid level	<a href="#">See Section 5.10</a>										
Replace hydraulic system filter	<a href="#">See Section 5.10</a>										
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>										

# MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2550 HRS	2600 HRS	2650 HRS	2700 HRS	2750 HRS	2800 HRS	2850 HRS	2900 HRS	2950 HRS	3000 HRS
Clean & lube mast rails	<a href="#">See Section 5.5</a>										
Lubricate drum switches	<a href="#">See Section 5.5</a>										
Grease pivot points and bearings/Oil chains	<a href="#">See Section 5.6</a>										
Lubricate blade tensioner screwhandle and rods	<a href="#">See Section 5.6</a> <a href="#">See Section 5.8</a>										
Rotate drive/idle blade wheel belts/Check for wear	<a href="#">See Section 5.9</a>										
Check brake strap tension	<a href="#">See Section 5.8</a>										
Check belt tensions	<a href="#">See Section 5.9</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Replace cylinder drive bearing fluid	<a href="#">See Section 5.13</a>										
Check feed & up/down chain tensions	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Check up/down & power feed gear box fluid levels	<a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Inspect hydraulic lines & fittings	<a href="#">See Section 5.10</a>										
Check hydraulic fluid level	<a href="#">See Section 5.10</a>										
Replace hydraulic system filter	<a href="#">See Section 5.10</a>										
Inspect hydraulic pump, power feed and up/down motor brushes	<a href="#">See Section 5.10</a> <a href="#">See Section 5.11</a> <a href="#">See Section 5.12</a>										
Grease up/down shaft bearing	<a href="#">See Section 5.11</a>										



## SECTION 4 TROUBLESHOOTING GUIDE

### 4.1 Sawing Problems

<b>PROBLEM</b>	<b>CAUSE</b>	<b>SOLUTION</b>
<b>Blades Dull Quickly</b>	Dirty logs	Clean or debark logs, especially on entry side of the cut
	When grinding teeth, heating too much and causing teeth to soften	Grind just enough metal to restore sharpness to the teeth. Use water/coolant while sharpening blade
	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Sharpener Manual)
<b>Blades Break Prematurely</b>	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edge of wheels	Change blade wheel belts (B-57)
	Poor sharpening techniques	See Sharpener Manual
	Tension too tight	Tension blade to recommended specifications
<b>Blade Does Not Track Right on Drive Wheel</b>	Cant adjustment is incorrect	Readjust
	Flat/worn belts	Replace B-57 belts
<b>Blade Guides Do Not Spin While Cutting</b>	Frozen bearings	Replace bearings
	Stiff bearings	Grease bearings
<b>Drive Belts Wear Prematurely or Jump</b>	Engine/motor and drive pulleys out of alignment	Align pulleys <a href="#">See Section 4.2 Engine/Motor and Drive Pulleys Alignment.</a>

<b>PROBLEM</b>	<b>CAUSE</b>	<b>SOLUTION</b>
<b>Boards Thick Or Thin On Ends Or Middle Of Board.</b>	Stress in log which causes log to not lay flat on the bed.	After log has been squared, take equal cuts off opposing sides. Take a board off the top. Turn the log 180 degrees. Take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut.
	Set in teeth.	Resharpen and reset blade.
	Bed rails misaligned.	Realign sawmill.
<b>Height Adjustment Jumps or Stutters When Moving Up or Down.</b>	Mast needs lubrication.	Lubricate mast track surface.
	Up/down chain improperly adjusted.	Adjust up/down chain.
	Drive belt(s) loose.	Adjust belts.
<b>Lumber Is Not Square</b>	Vertical side supports not square to bed	Adjust side supports.
	Blade not parallel to bed rails	Adjust bed rails parallel to blade.
	Sawdust or bark between cant and bed rails	Remove particles
<b>Sawdust Builds Up On Track</b>	Tooth set problems	Resharpen and reset blade
	Excessive oiling	Do not oil track
	Track wipers worn	Adjust wipers to firmly contact track
	Track is sticky	Clean track with solvent and apply silicone spray
<b>Wavy Cuts</b>	Excessive feed	Slow feed rate
	Improperly sharpened blade (This will be the problem 99% of the time!)	Resharpen blade (See Sharpener Manual - read entire manual!)
	Blade guides improperly adjusted	Adjust blade guides.
	Sap buildup on blade	Use Water Lube.
	Tooth set problem	Resharpen and reset blade

## 4.2 Engine/Motor and Drive Pulleys Alignment

1. Install the drive belt.
2. Use a straight edge to align the engine/motor pulley to the drive pulley. Also check that the engine pulley is within 1/8" square with the drive pulley. Loosen the engine mounting bolts and rotate the engine if necessary.
3. Check front-to-back movement of the engine does not exceed 1/4". Tighten the motor mount U-bolts if necessary.
4. Engage the clutch handle and adjust the drive belt tension to 7/16" deflection with 10 lb. of force.
5. Recheck the pulley alignment and engine squareness with the clutch handle engaged. Adjust if necessary.
6. Adjust the drive belt support to 1/4" ( $\pm 1/32$ ) from the belt while engaged.

## 4.3 Power Feed Preliminary Test

This test will determine if the problem is a mechanical or electrical.

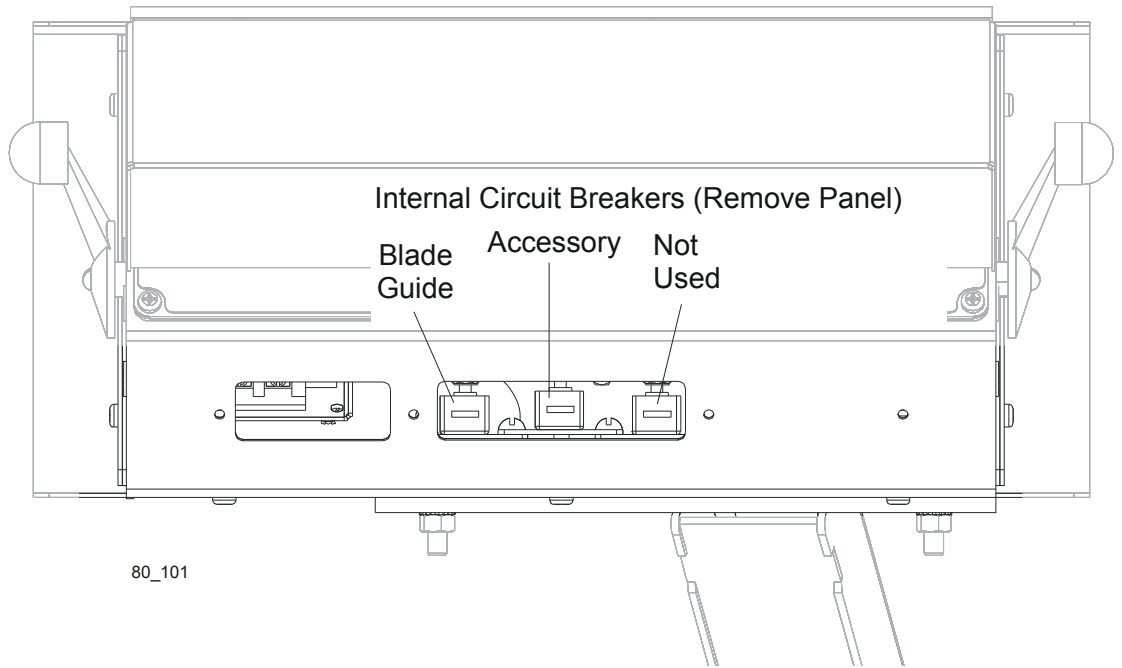
1. Remove the drive belt from the power feed drive pulley.
2. Turn the key switch to the ACC position. Put the carriage forward/reverse switch into the forward position and turn the feed rate dial through all speeds. If the power feed motor runs properly at all speeds, the problem is a mechanical one instead of an electrical one.

## 4.4 Circuit Breaker Operation

Sawmill controls are equipped with manual reset circuit breakers to protect the electrical circuits.

**See Figure 4-1.** The blade guide and accessory are located inside the control box. Remove the circuit breaker panel from the control box to access the internal breakers.

**NOTE:** If the breaker is still hot, you may not be able to reset it immediately. Allow the breaker to cool for a few minutes before attempting to reset.



**FIG. 4-1**

## SECTION 5 SAWMILL ALIGNMENT

The Wood-Mizer sawmill is factory aligned. Two alignment procedures are available to realign the sawmill if necessary. The Routine Alignment instructions should be performed as necessary to solve sawing problems not related to blade performance. The Complete Alignment procedure should be performed approximately every 1500 hours of operation (sooner if you regularly transport the sawmill over rough terrain).

### 5.1 Routine Alignment Procedure:

#### *Blade Installation*

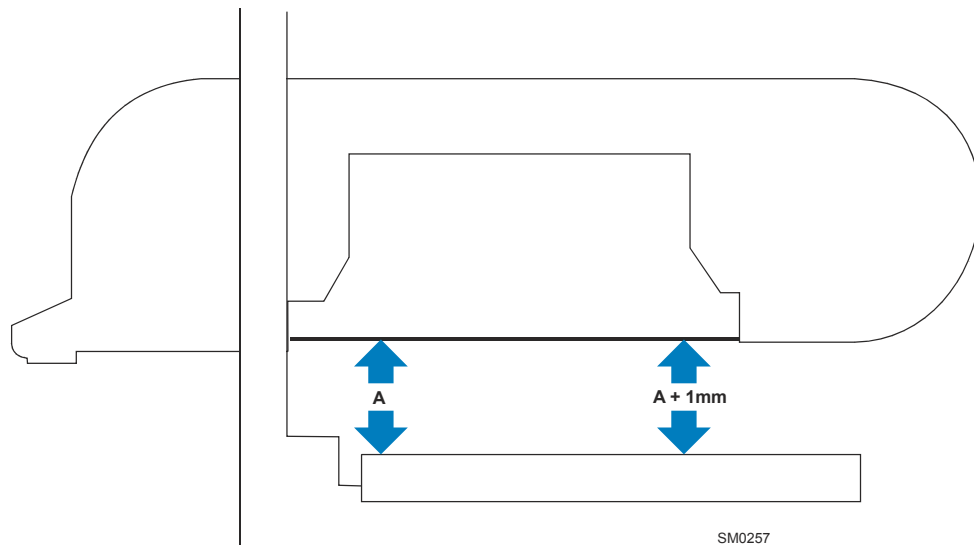
1. Remove the blade and check the blade wheel. Remove any sawdust buildup from the surface of the wheels.
2. Install a clean blade and apply the appropriate tension ([See Section 2.6](#)).
3. Check the blade guide inserts and drive side deflector plate are properly adjusted ([See Section 3.2](#)).
4. Adjust the idle-side cant control to track the blade ([See Section 2.7](#)).
5. Close the blade housing covers and make sure all persons are clear of the saw head.
6. Turn the key switch to #2 position.
7. Manually spin one of the blade wheels until the blade positions itself on the blade wheels.

**Saw Head Tilt**

As the blade enters a wide log or cant, the outside of the saw head will drop down slightly. To compensate for the drop, the saw head is adjusted 1/26" (1 mm) higher at the outside.

1. Move the saw carriage so the blade is positioned over a bed rail. Adjust the blade guide arm to 1/2" (15 mm) from full open.
2. Raise the saw head so the bottom of the blade measures 14 3/4" (375 mm) from the top surface of the bed rail near the inner blade guide assembly.

See Figure 5-1.



**FIG. 5-1**

3. Measure from the blade to the bed rail near the outer blade guide assembly. This measurement should be 1/26" (1 mm) higher than the inner measurement or 14 13/16" (376mm).

**See Figure 5-2.** To adjust the saw head tilt, use the bolts located at the bottom of the saw head mast. Loosen the three sets of four retaining plate bolts. To raise the outside of the saw head, back the stop bolts out, then tighten the adjustment bolts. To lower the outside of the saw head, loosen the adjustment bolts and tighten the stop bolts. Recheck the measurement from the blade to the bed rails and adjust the stop bolts and adjustment bolts until the outside of the saw head is 1/26" (1mm) higher than the inside. Retighten the retaining plate bolts.

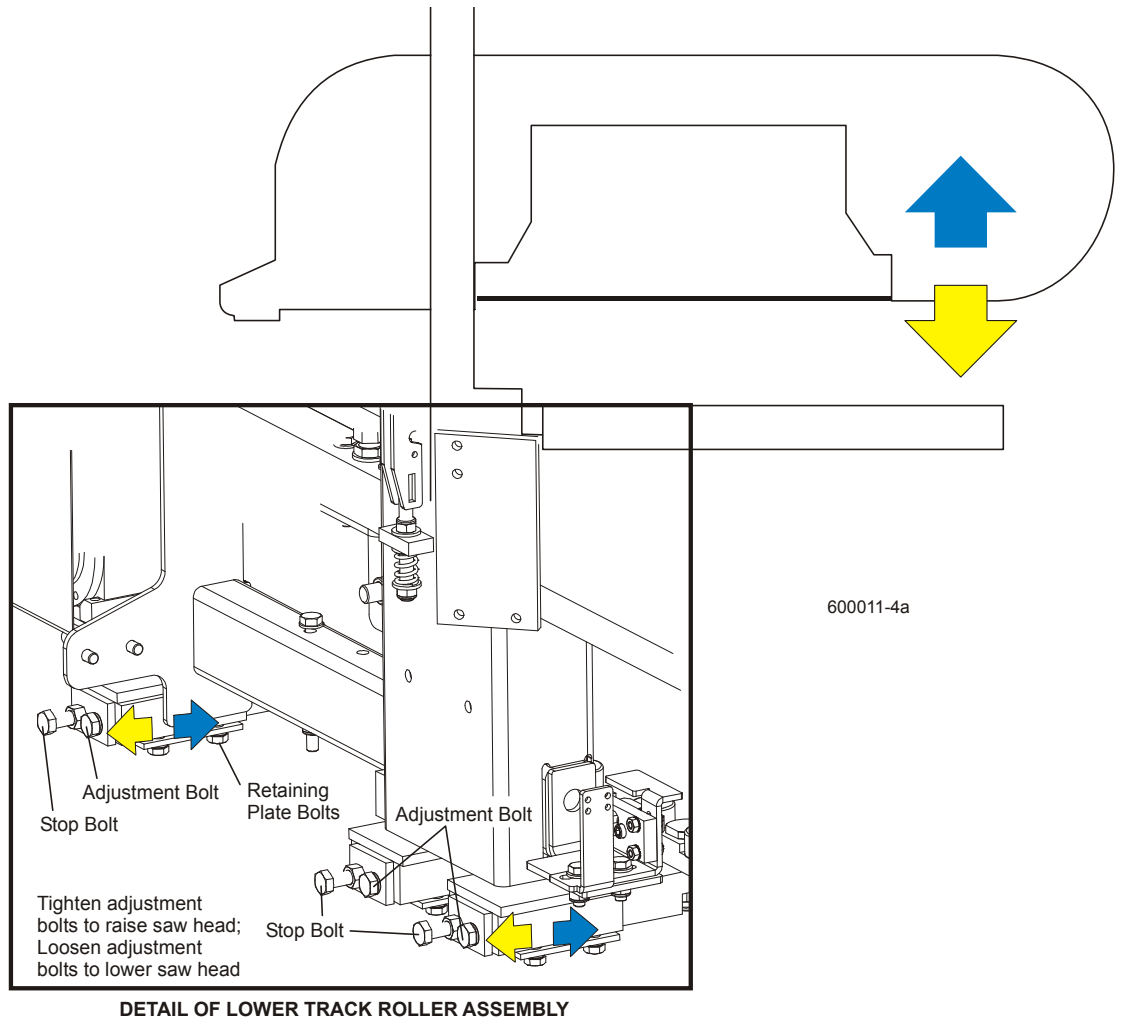


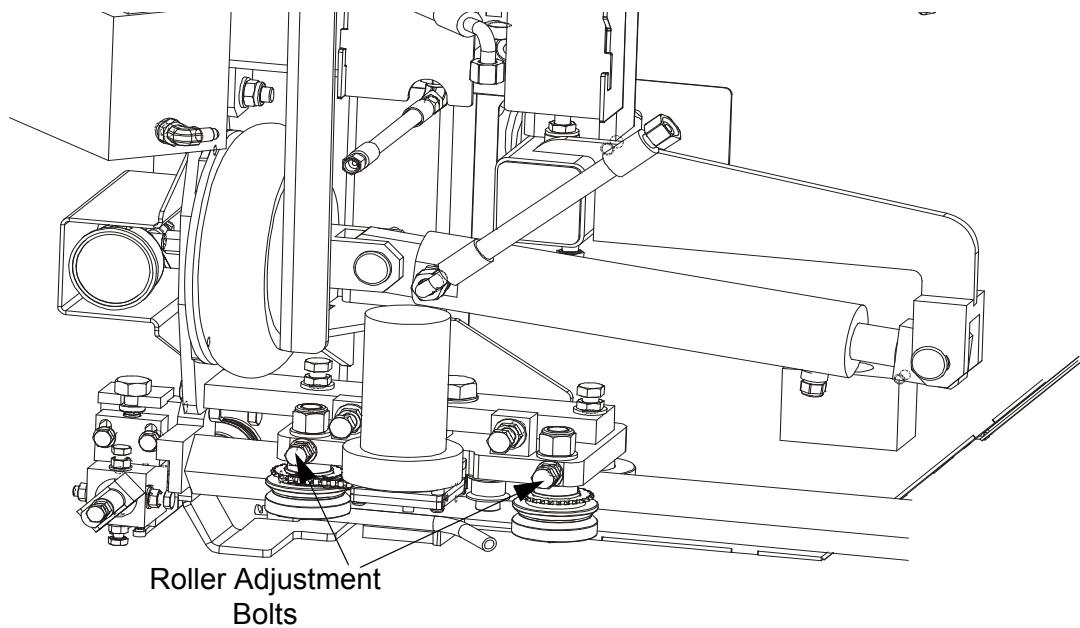
FIG. 5-2

**Blade Guide Arm Alignment**

The blade guide arm moves the outer blade guide in and out. If the arm becomes loose, the blade guide will not guide the blade properly, causing inaccurate cuts. A loose blade guide arm can also cause blade vibration.

1. Adjust the blade guide arm in to 1/2" (15 mm) from fully closed.
2. Manually try to move the arm up and down. If you can move the arm by hand, you will need to tighten the arm rollers.

**See Figure 5-3.** Loosen the jam nuts and turn the adjustment bolts in to tighten the blade guide arm rollers. Retighten the jam nuts.

**FIG. 5-3**

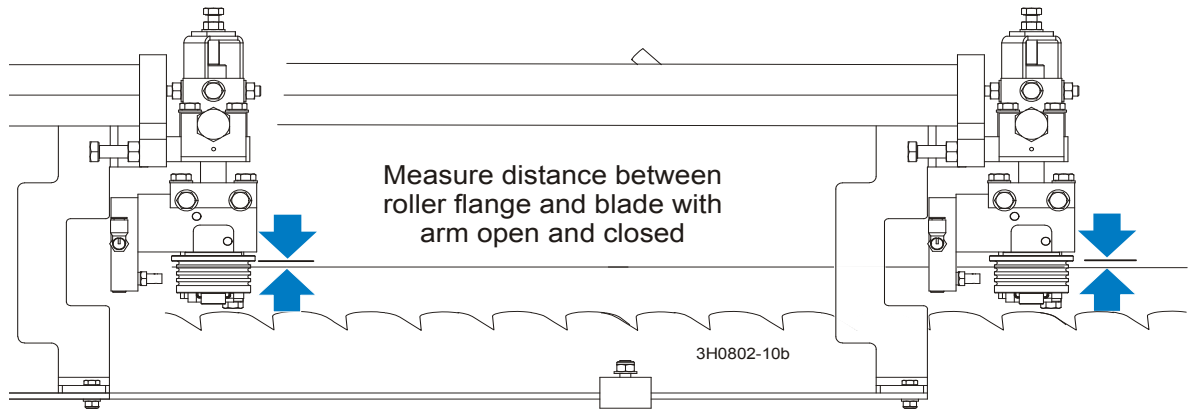


After tightening the blade guide arm rollers, check that the arm is aligned properly.

**Blade Guides**

3. With the arm adjusted 1/2" (15 mm) from fully closed, measure the distance between the blade guide roller flange and the back of the blade. If the sawmill is equipped with optional all-ceramic guides, measure from the back of the blade to the back roller.

See Figure 5-4.

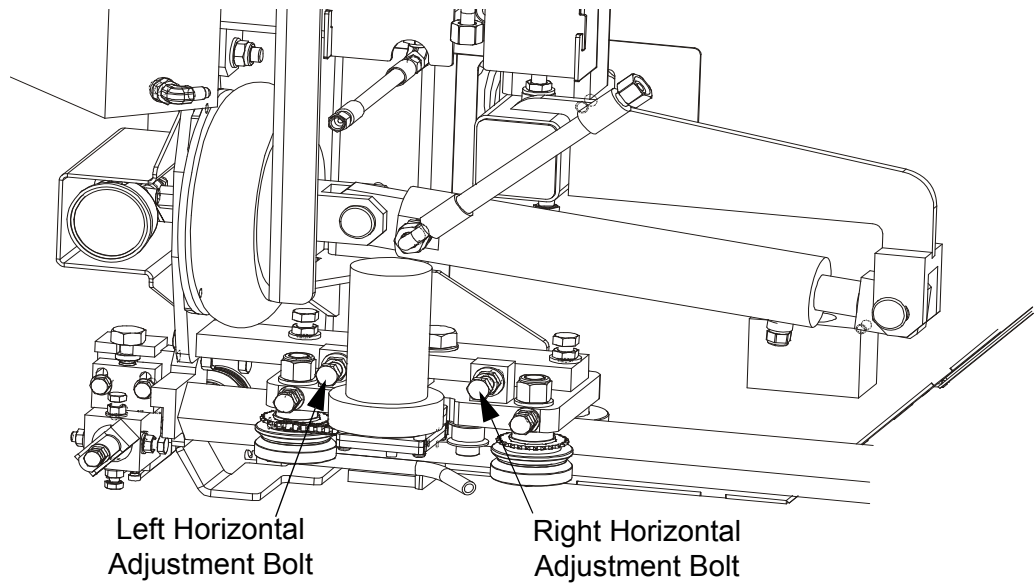


**FIG. 5-4**

4. Adjust the blade guide arm to 1/2" (15 mm) from fully open and remeasure the distance from the roller flange to the back of the blade. The two measurements should be the same. If not, adjust the outer rollers in or out to tilt the arm horizontally.

**See Figure 5-5.** Loosen the horizontal adjustment bolt jam nuts. To tilt the arm in toward the blade, loosen the right bolt and tighten the left bolt. To tilt the arm out away from the blade, loosen the left bolt

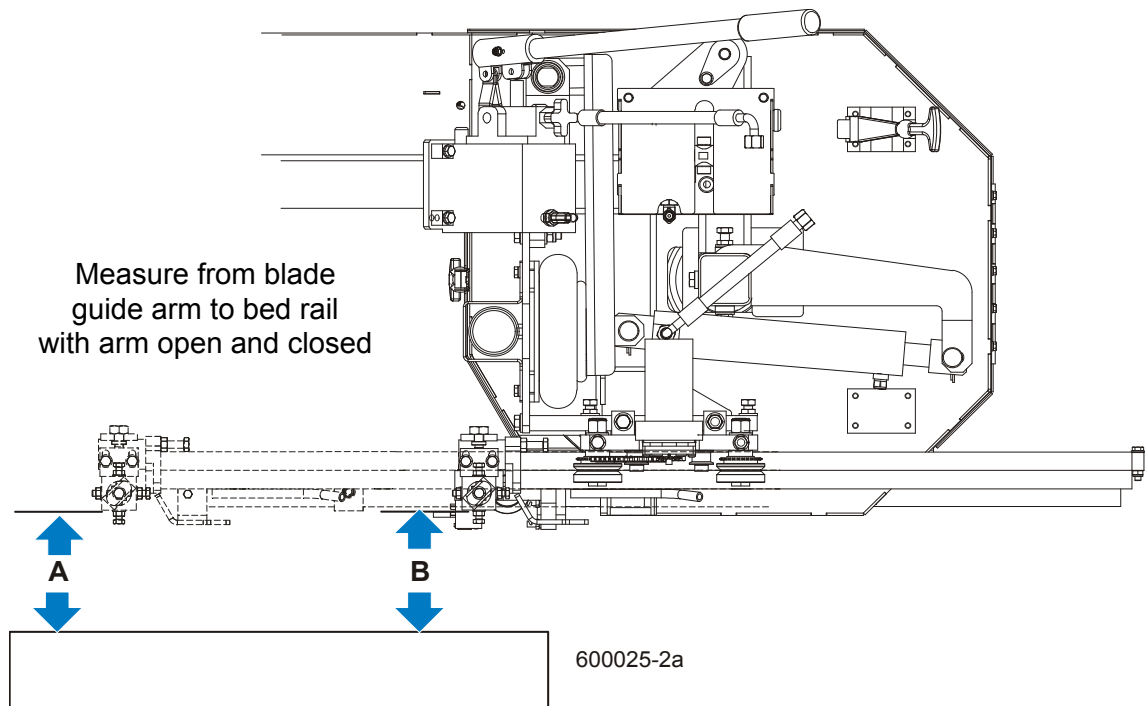
and tighten the right bolt. Retighten the jam nuts and recheck the blade guide arm horizontal tilt.



**FIG. 5-5**

5. Now check the vertical tilt of the blade guide arm. Move the saw carriage so the blade guide arm is positioned over a bed rail.
6. With the arm 1/2" (15 mm) from fully closed, raise or lower the saw head until the bottom of the blade guide block is 15" (375 mm) from the top of the bed rail.

See Figure 5-6.



**FIG. 5-6**

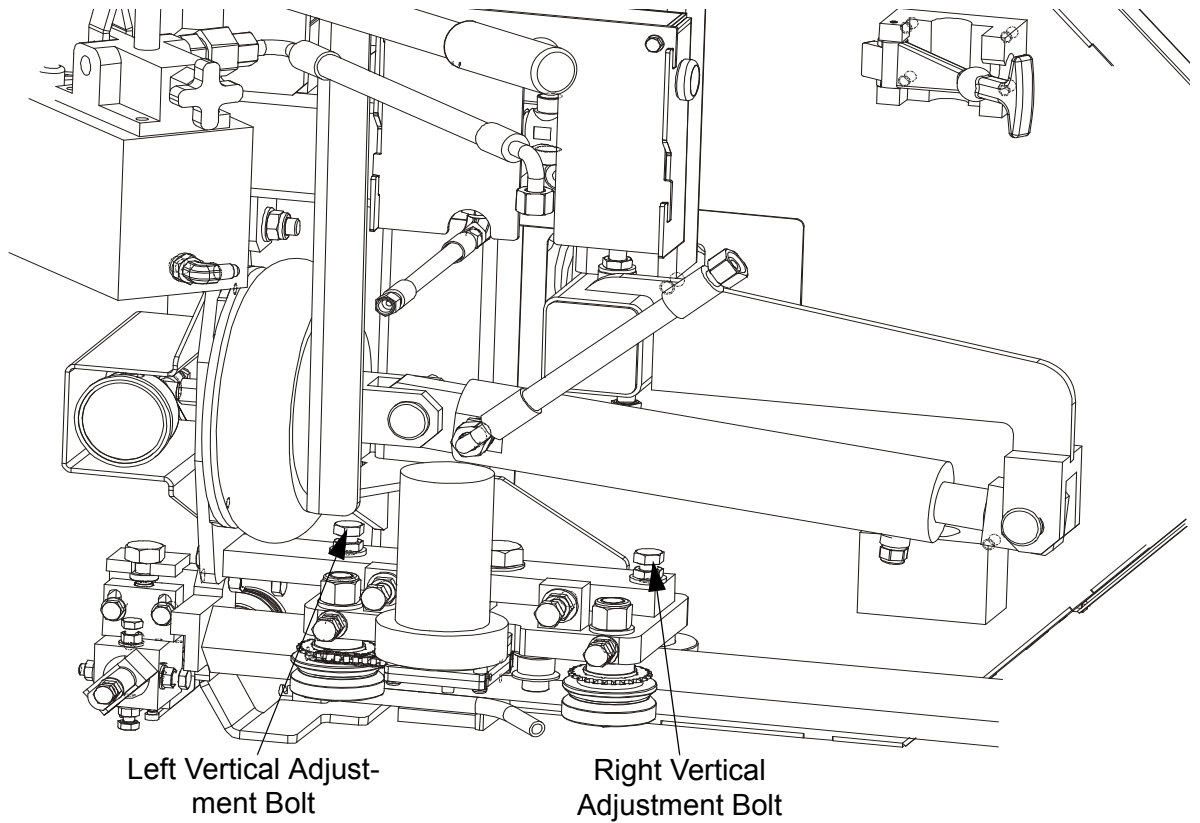
- Adjust the blade guide arm to 1/2" (15 mm) from fully open. Measure the distance from the bottom of the blade guide mounting block to the bed rail. This measurement should be 15" (375 mm) or slightly higher because the saw head is tilted up 1/26" (1 mm) on the outside ([See Saw Head Tilt](#)). If the blade guide is closer to the bed rail or more than 1/26" (1mm) higher with the arm open, adjust blade guide arm vertically.

**See Figure 5-7.** Loosen the vertical adjustment bolt jam nuts. To tilt the blade guide arm down, loosen the right bolt and tighten the left bolt. To tilt the blade guide arm up, loosen the left bolt and tighten the

# 5 Sawmill Alignment

*Routine Alignment Procedure:*

right bolt. Retighten the jam nuts and recheck the blade guide arm vertical tilt.



**FIG. 5-7**

### Blade Guide Vertical Tilt Alignment

The blade guides should be adjusted properly in the vertical plane. If the blade guides are tilted vertically, the blade will try to travel in the tilted direction.

A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

1. Open the adjustable blade guide arm 1/2" (15 mm) from full open.
2. Clip the alignment tool on the blade. Position the tool close to the outer blade guide assembly. Be sure the tool does not rest on a tooth or burr, and is lying flat against the bottom of the blade.

See Figure 5-8.

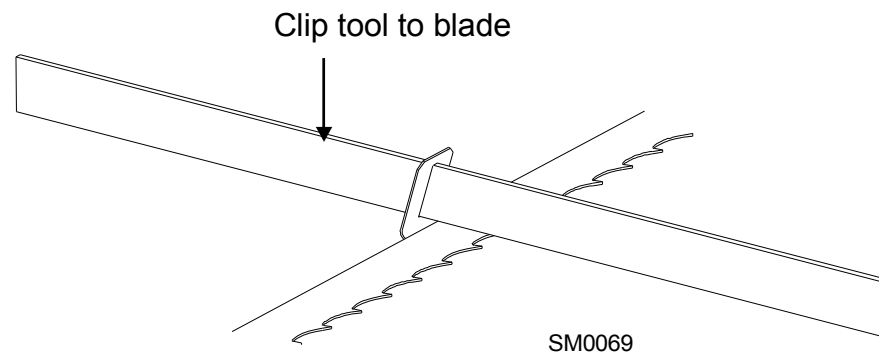


FIG. 5-8

3. Move the carriage so that the front end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
4. Move the carriage so that the back end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
5. If the measurement from the tool to the bed rail is not equal within 1/26" (1mm), adjust the vertical tilt of the outer blade guide roller.

See Figure 5-9. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten top screw. To tilt the roller down, loosen the top screw and

## 5 Sawmill Alignment

### Routine Alignment Procedure:

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

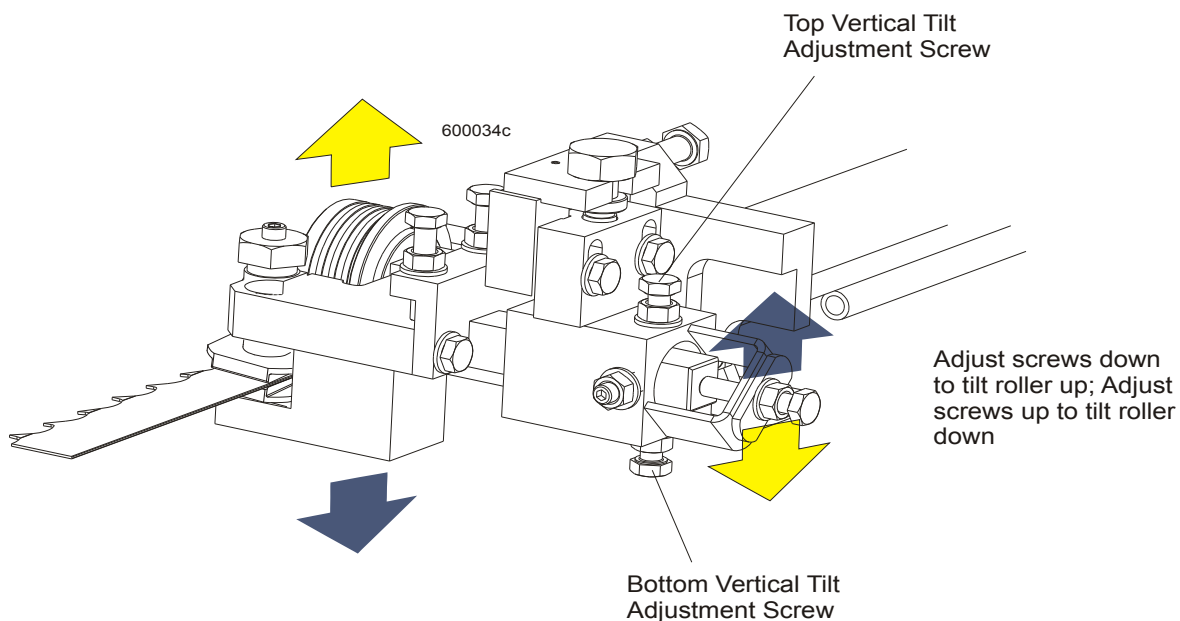


FIG. 5-9

Move the blade guide alignment tool close to the inner blade guide roller assembly and repeat the above steps. Adjust the vertical tilt of the inner blade guide if necessary. **Blade Guide Horizontal Tilt Adjustment**

If the blade guides are tilted in the wrong direction horizontally, the back of the blade may contact the flange as the roller is spinning down, causing it to push the blade away from the guide roller.

1. Remove the blade guide alignment tool from the blade and adjust the blade guide arm halfway in.
2. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

See Figure 5-10.

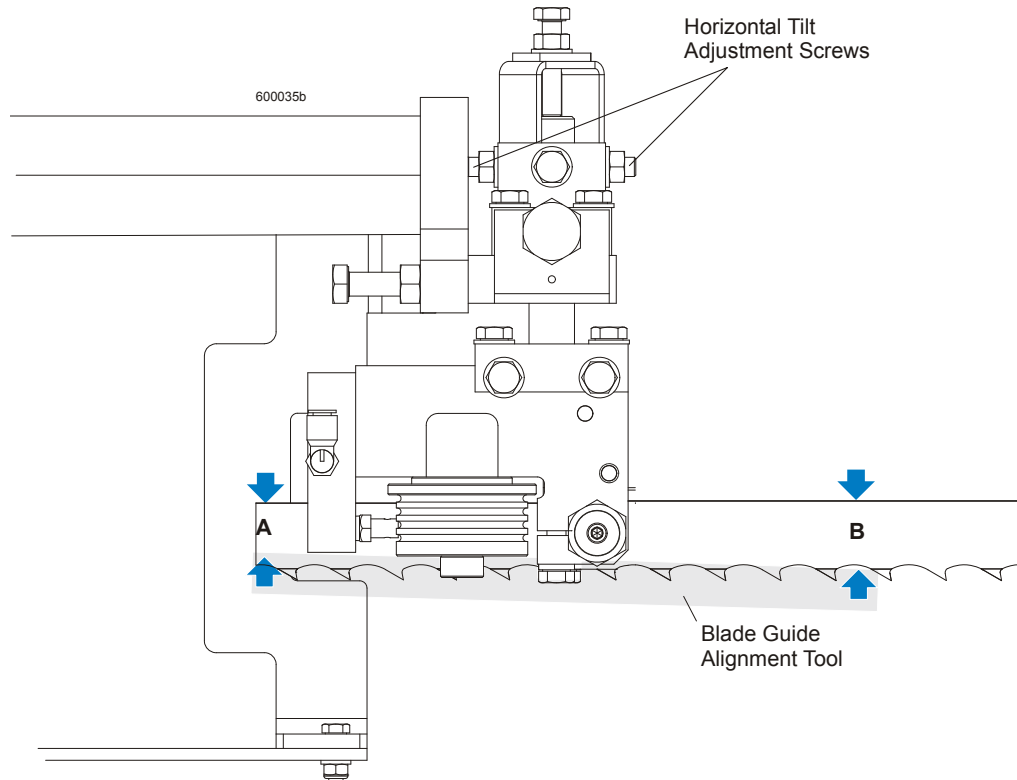


FIG. 5-10

3. Measure between the back edge of the blade and the tool 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 tool ("A").

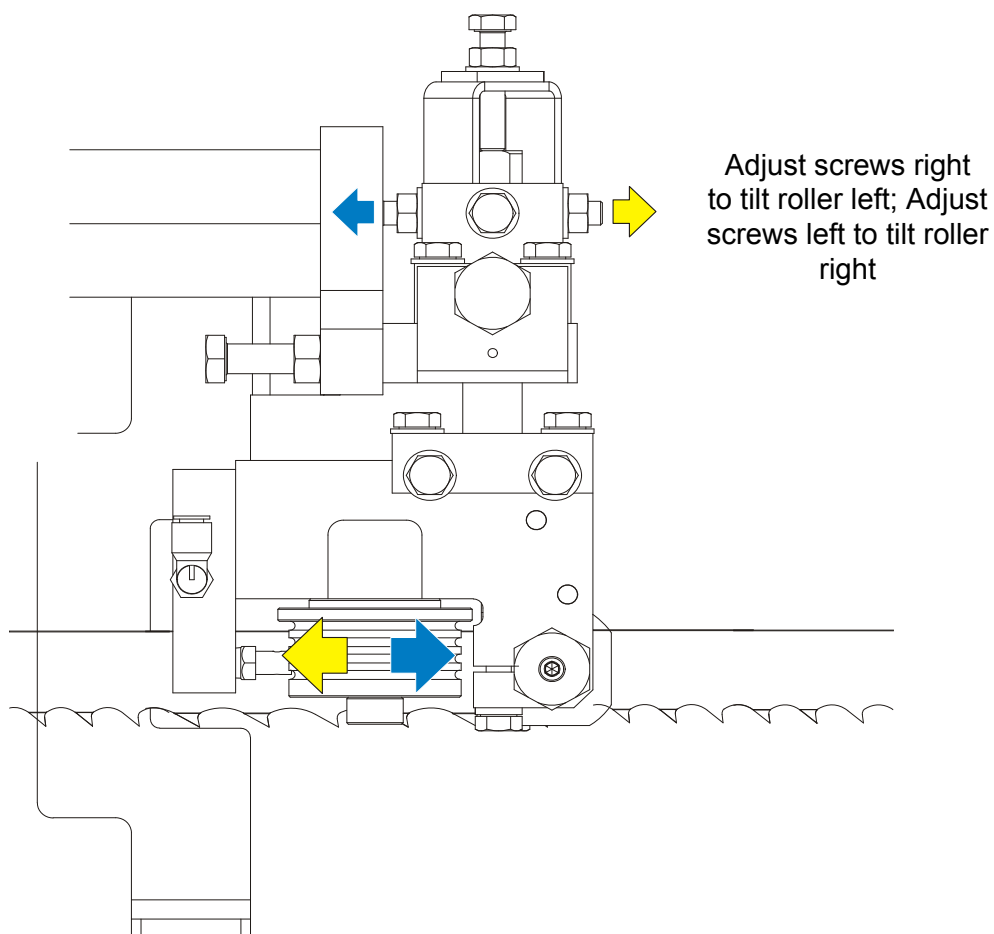
The roller should be tilted slightly to the left ('A'  $1/8$ " [3 mm] less than 'B'  $\pm 1/8$ " [3 mm]).

**See Figure 5-11.** Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the

## 5 Sawmill Alignment

### *Routine Alignment Procedure:*

right screw. Tighten the jam nuts and recheck the tilt of the blade.



**FIG. 5-11**

5. Repeat the above steps for the inner blade guide roller assembly.

**NOTE:** Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. [See Blade Handbook, Form #600.](#)



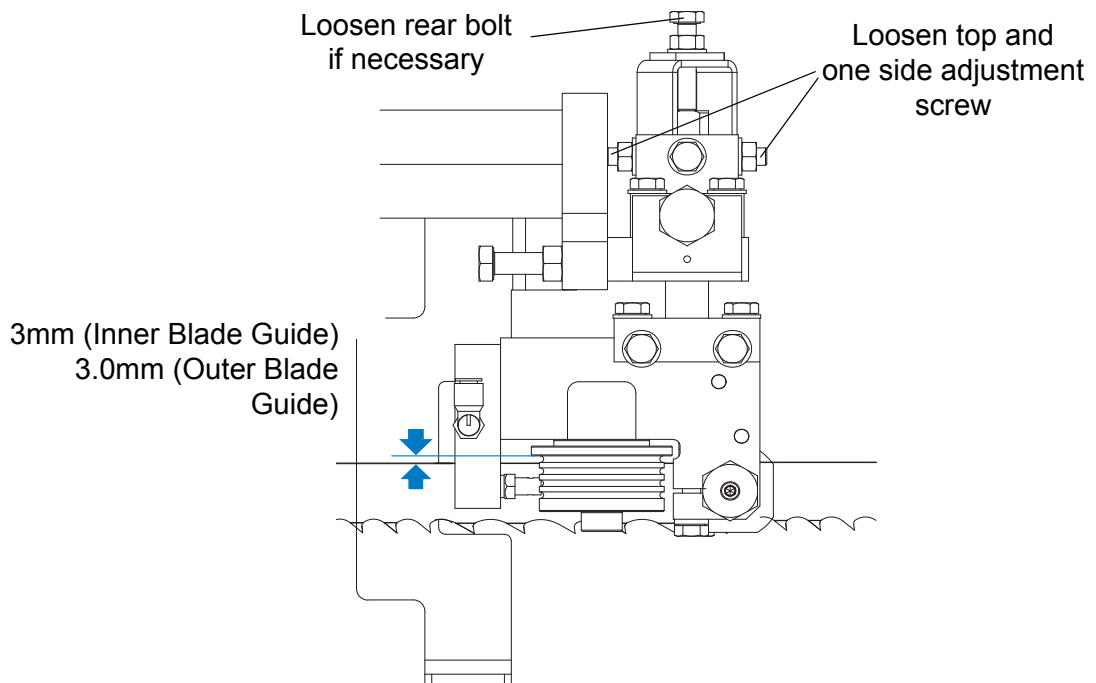
**Blade Guide Flange Spacing**

Each blade guide must be adjusted so the roller flange is the correct distance from the back edge of the blade. If the flange is too close to or too far from the blade, the sawmill will not cut accurately.

**HINT:** When adjusting 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 adjustment screws are retightened.

1. Measure the distance between the flange on the inner blade guide roller to the back edge of the blade. This distance should measure 3 mm. Adjust the roller back or forward if necessary.

**See Figure 5-12.** Loosen the top and one side screw shown and rear adjusting bolt if necessary. Tap the blade guide forward or backward until properly positioned. Retighten the screws and jam nuts.



**FIG. 5-12**

2. Measure the distance between the flange on the outer blade guide roller to the back edge of the blade. This distance should measure 3.0 mm. Adjust the roller back or forward if necessary.

## 5.2 Horizontal Adjustment of Side Supports

Logs and boards are clamped against the side supports when sawing. The side supports must be square to the bed to ensure square lumber.

1. Swing the side support down.
2. Measure between the face of the support and the main bed tube. Make measurements at both ends of the side support to make sure that it is parallel to the rail.

See Figure 5-13.

3. Use the two lower bolts to adjust the side support so  $B=A$ .
4. Repeat for remaining side supports.

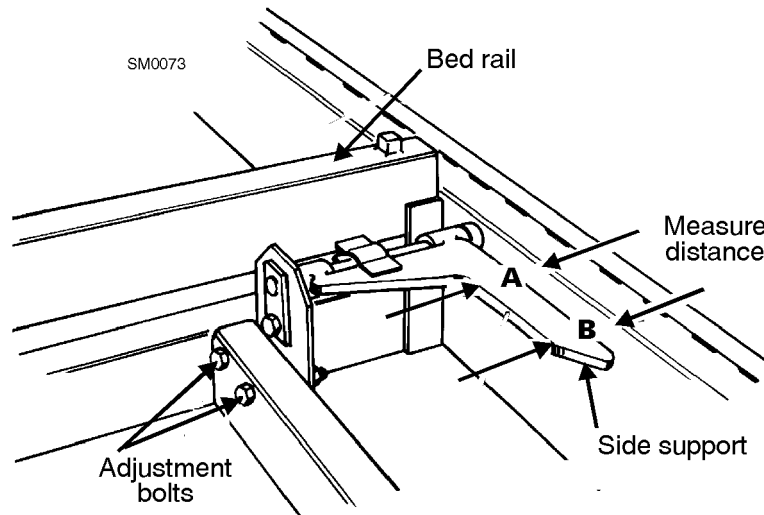


FIG. 5-13

### 5.3 Vertical Adjustment of Side Supports

1. Place a flat board across the bed rails.
2. Swing a side support up so that it is vertical.
3. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.

See Figure 5-14.

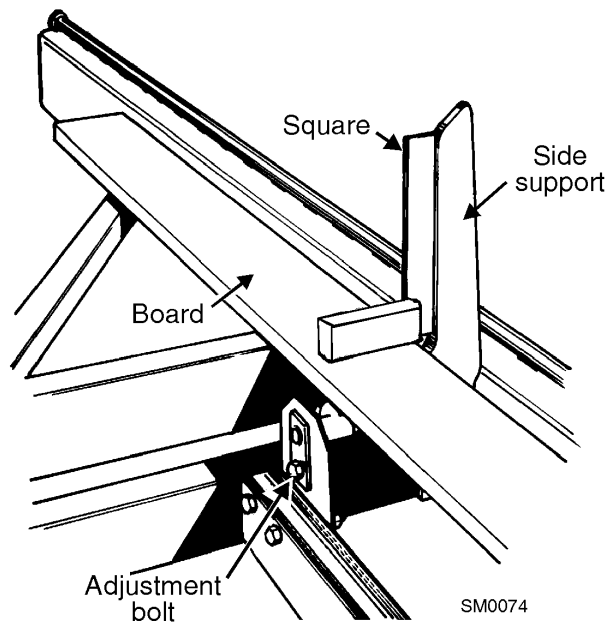


FIG. 5-14

4. Check the angle of each support with a square on the board.
5. The side support should be 90° to the bed rails. Loosen the top adjustment bolt, adjust the side support, and retighten the bolt.
6. Repeat for the remaining side supports.

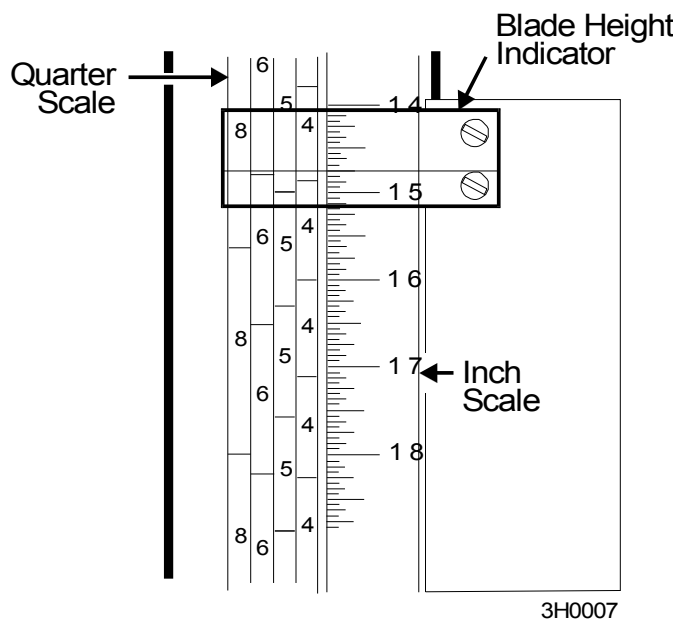
**Blade Height Scale Adjustment**

After the entire sawmill has been aligned and all adjustments made, check that the blade height scale indicates the true distance from the blade to the bed rails.

1. Move the saw head so the blade is positioned directly above one of the bed rails. Measure from the bottom edge on a down-set tooth of the blade to the top of the bed rail, near the inner blade guide assembly.
2. View the blade height scale with eyes level with the indicator. The scale should indicate the actual distance from the blade to the bed rail. Adjust the indicator if necessary.

**See Figure 5-15.** 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 nuts.

For example, if the measurement from the down-set tooth of the blade to the bed rail was 14 3/4" (375 mm), make sure the indicator reads 14 3/4" (375 mm) on the scale.

**FIG. 5-15**

## 5.4 Complete Alignment Procedure

### Frame Setup

Before performing the following alignment procedures, setup the mill on firm, level ground.

If your sawmill is stationary, with no trailer axle, lower the feet so the weight of the sawmill is evenly supported.

If your sawmill has a trailer axle and adjustable outriggers, adjust the outriggers as follows:

**LT70S DH:** Adjust the two end outriggers on the main frame tube down just enough to lift weight from the trailer tire.

**LT70M DH:** Adjust the front and third outriggers on the main frame tube down just enough to lift weight from the trailer tire.

**LT70L DH:** Adjust front outriggers on the main frame tube down just enough to lift weight from the trailer tires.

**All Portable Sawmills:** Adjust the outer outriggers down just so they touch the ground but do not bear weight.

[See SECTION 3](#) for additional setup information.

### Blade Installation

1. Remove the blade and replace the blade wheel belts. New blade wheel belts are required to perform the complete alignment procedure.
2. Blow sawdust off of the blade guide assemblies. Remove sawdust from the blade housings. Scrape any sawdust buildup from the blade wheel rims.
3. Remove the blade guide assemblies and the blade.

**NOTE:** To remove the blade guide assemblies and maintain the tilt adjustments, only loosen one side screw and the top screw. Leaving the other side screw and bottom screw in position will insure you will return the rollers to their original tilt adjustment.

4. Adjust the outer blade guide arm in or out until the outer blade guide is approximately 24" ( 61 cm ) from the inner blade guide.
5. Install a new blade and apply the appropriate tension ([See Section 2.6](#)).
6. Close the blade housing covers and make sure all persons are clear of the saw head.

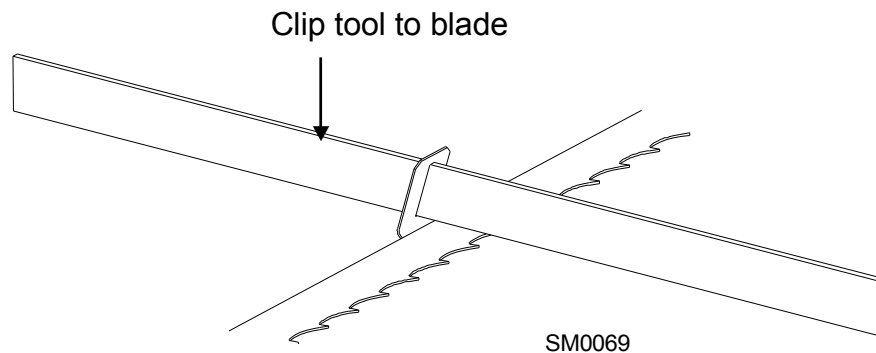
7. Turn the key switch to #2 position.
8. Manually spin one of the blade wheels until the blade positions itself on the blade wheels.

### **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 bottom of the blade.

**See Figure 5-16.**

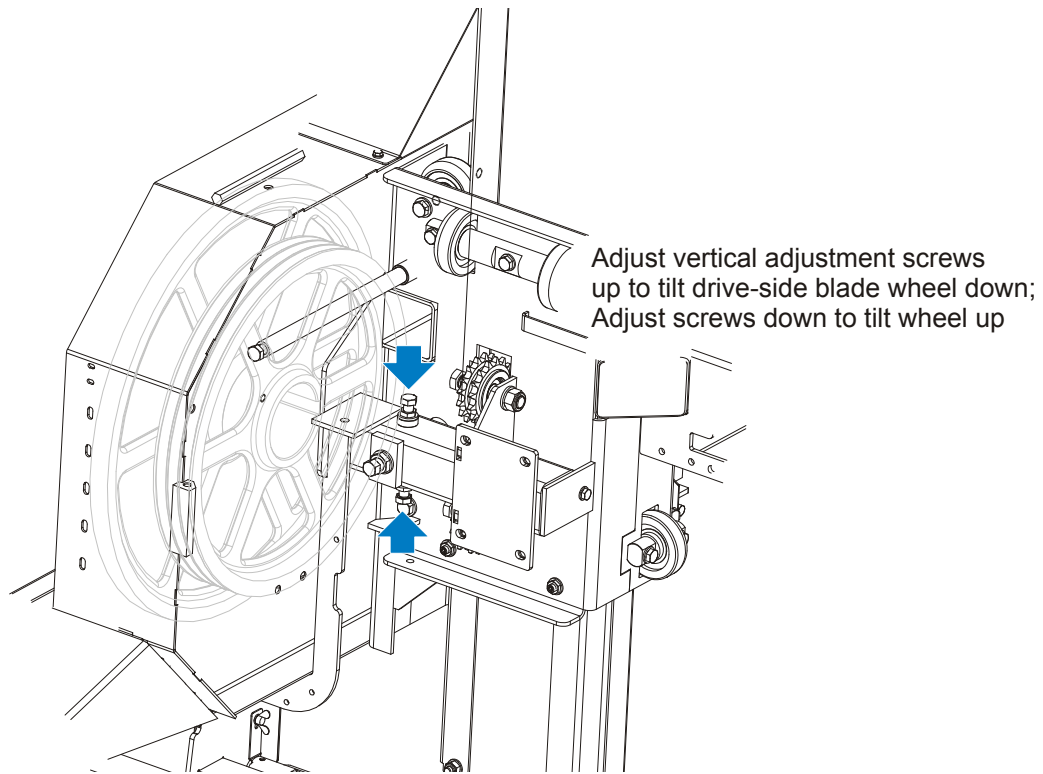


**FIG. 5-16**

2. Move the saw carriage so the front end of the tool is positioned over the first bed rail. Measure from the bottom of the tool to the top surface of the bed rail.
3. Move the saw carriage so the rear of the tool is positioned over the bed rail. Again, measure from the bottom of the tool to the bed rail.
4. If the two measurements differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the drive-side blade wheel.

**See Figure 5-17.** Use the vertical adjustment screws to adjust the drive-side blade wheel. 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.

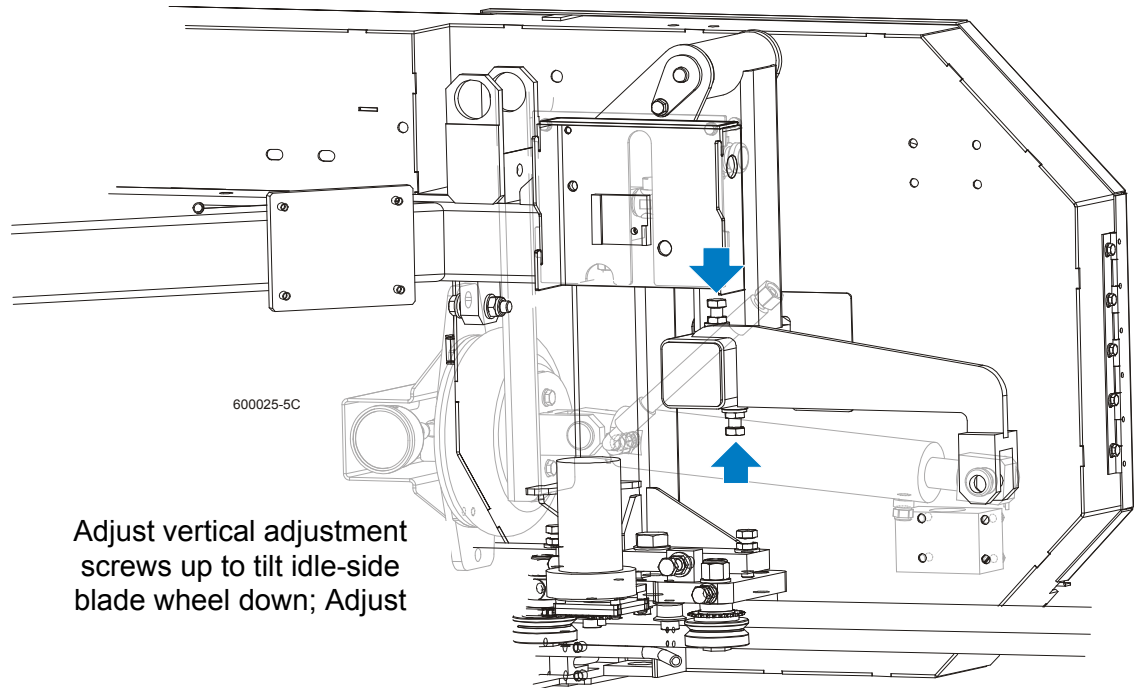


**FIG. 5-17**

5. 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 bed rail (within 1/16" [1.5 mm]).
6. Remove the tool from the blade and reattach it near the outer blade guide assembly.
7. Measure from the tool to the bed rail at both ends of the tool. If the measurements at the front and rear ends of the tool differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the idle-side blade wheel.

**See Figure 5-18.** Use the vertical adjustment screws to adjust the idle-side blade wheel. To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

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



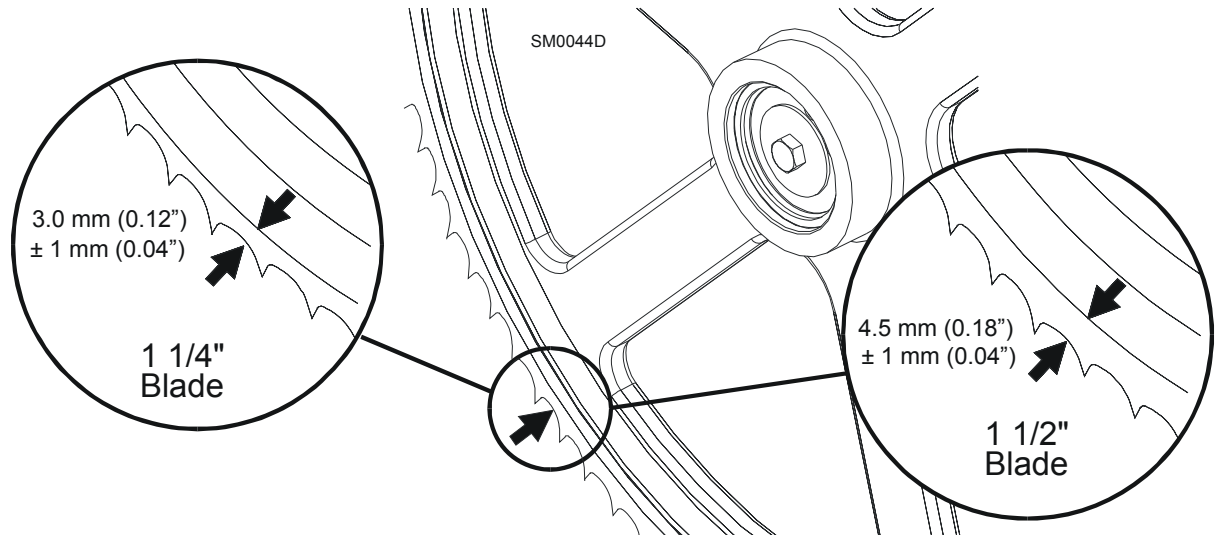
**FIG. 5-18**

8. 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 bed rail (within 1/16" [1.5 mm]).



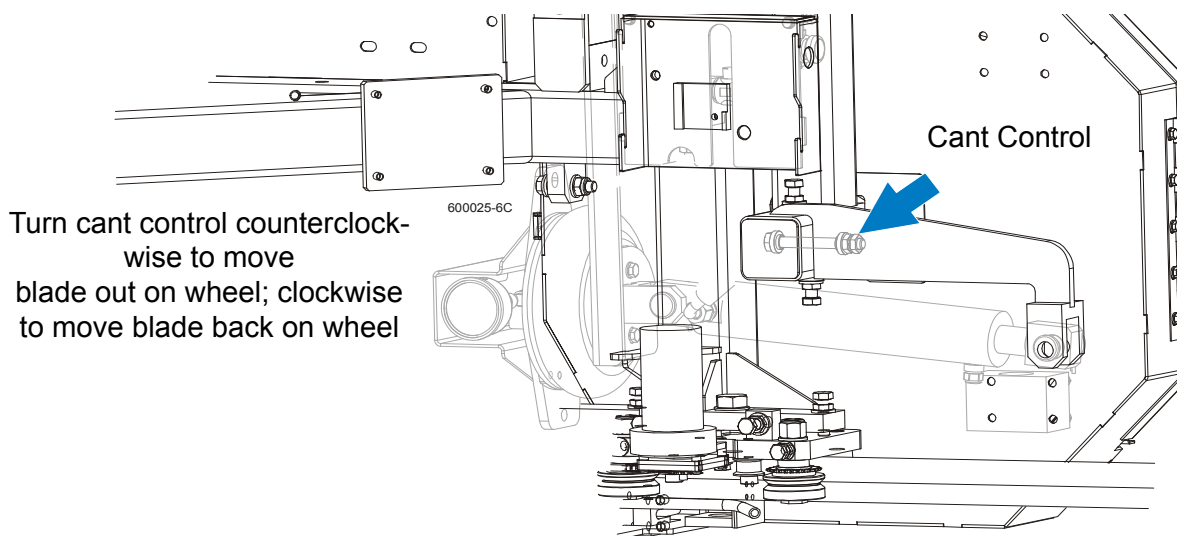
9. Check the position of the blade on the idle-side blade wheel.

**See Figure 5-19.** The horizontal tilt of the blade wheel should be adjusted so that the gullet of a 1-1/4" blade is 1/8" (3 mm) out from the front edge of the wheel ( $\pm 1/26$  [1mm]). The gullet of a 1-1/2" blade should be 3/16" (4.5 mm) out from the front edge of the wheel ( $\pm 1/26$  [1 mm]). Do not let the teeth ride on the wheels.



**FIG. 5-19**

**See Figure 5-20.** 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 clockwise. If it is too far back on the wheel, turn the cant control counterclockwise.



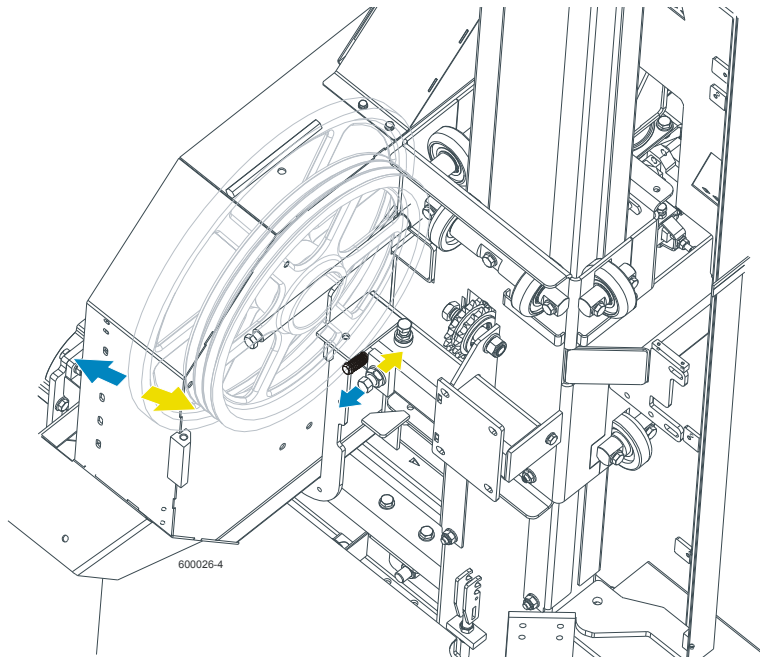
**FIG. 5-20**

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

**See Figure 5-21.** Use the horizontal adjustment screw to adjust the drive-side blade wheel. To move the

blade back on the wheel, loosen the jam nut on the adjustment screw and tighten the screw. Tighten the jam nut.

To move the blade out on the wheel, loosen the jam nut on the adjustment screw and loosen the screw. Tighten the jam nut.



Loosen adjustment bolt to move blade out on wheel; Tighten adjustment bolt to move blade in on wheel

**FIG. 5-21**

### ***Bed Rail Adjustment***

1. Open the adjustable blade guide arm to within 1/2" (15 mm) of full open.
2. Move the carriage back to the front pivot bed rail. Raise the cutting head until the bottom of the blade is 17" (400 mm) above the outside of the pivot bed rail support by actual measurement with a tape or ruler.

See Figure 5-22.

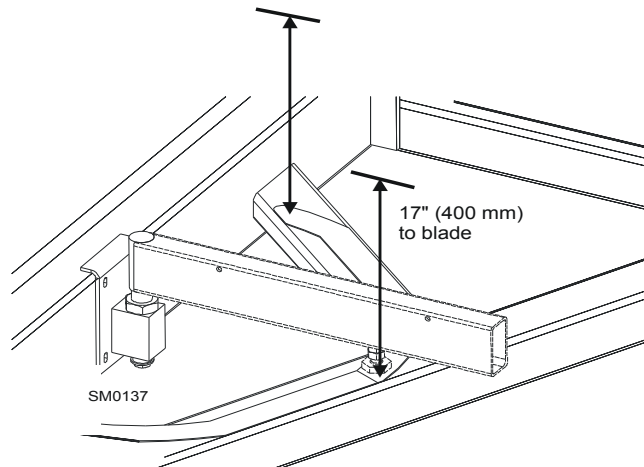


FIG. 5-22

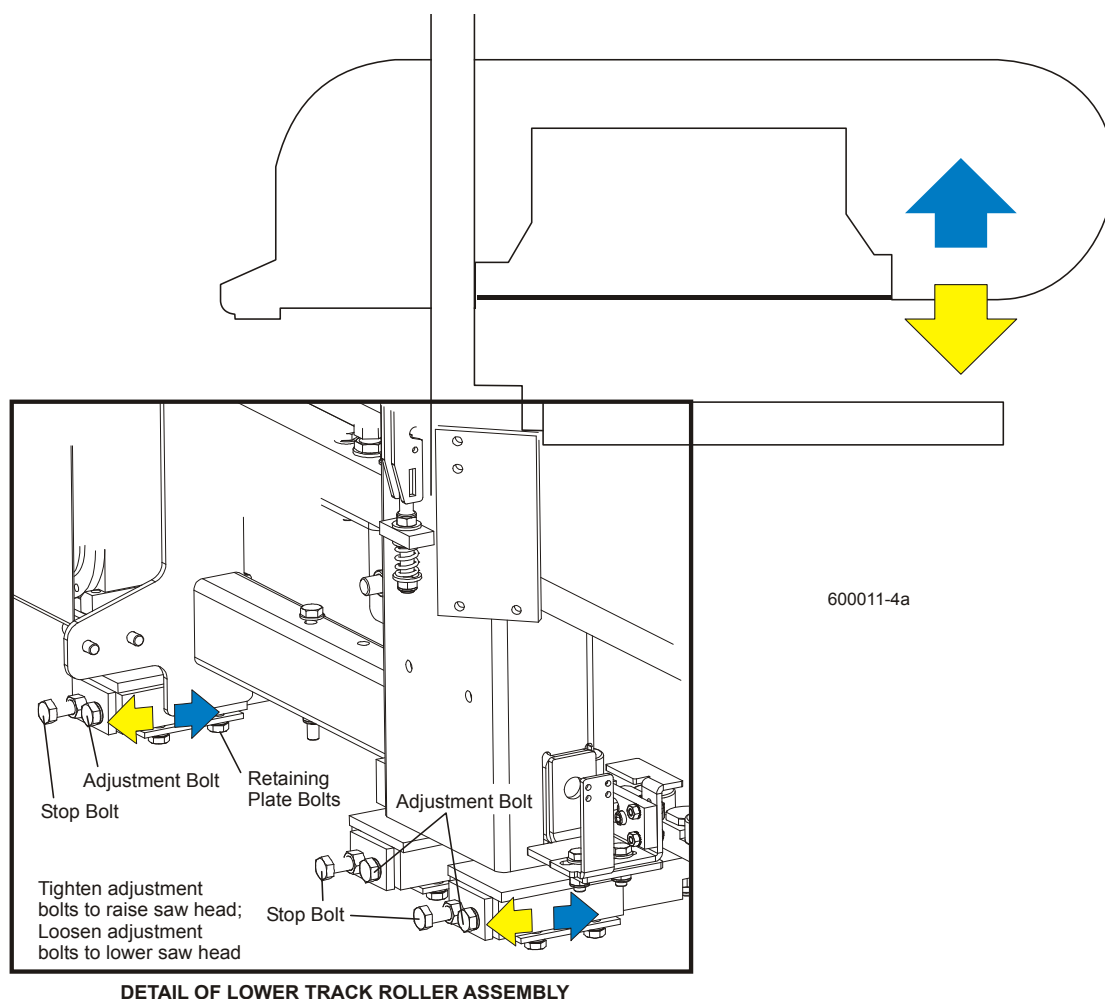
3. Move the carriage forward to check the distance to the blade at the inside of the pivot bed rail support. All measurements should be equal.

**See Figure 5-23.** To adjust the saw head tilt, use the bolts located at the bottom of the saw head mast. Loosen the three sets of four retaining plate bolts. To raise the outside of the saw head, back the stop bolts out, then tighten the adjustment bolts. To lower the outside of the saw head, loosen the adjustment bolts and tighten the stop bolts. Recheck the saw head tilt and readjust the bolts as necessary.

## 5 Sawmill Alignment

### Complete Alignment Procedure

Retighten the retaining plate bolts.

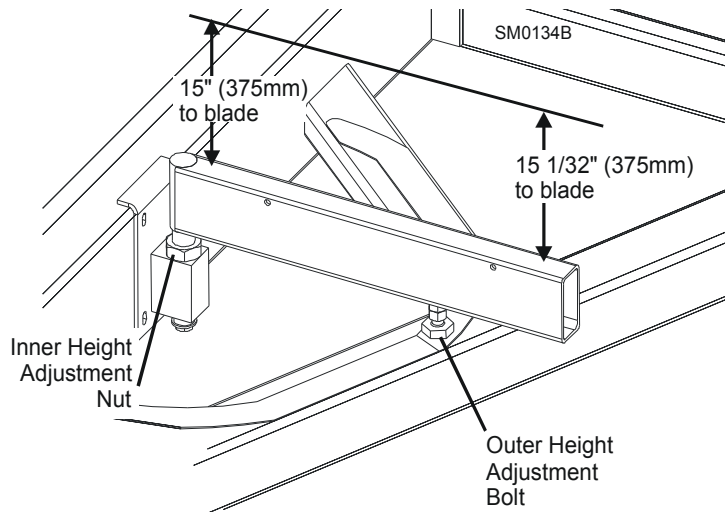


**FIG. 5-23**

4. Move the clamp so it is 10" from the clamp stop. Adjust the clamp down to its lowest position. Move the saw head forward until it is positioned over the clamp. Raise the saw head until the blade measures 15 5/16" (385 mm) from the clamp at its lowest position.
5. Adjust the front pivot rail 90° to the main bed tube.
6. Move the saw head to center the blade over the front pivot bed rail.

7. Measure the distance from the top of the pivot rail to the bottom of the blade. Make this measurement at each end of the pivot rail.
8. The two measurements should be 15" (375 mm).

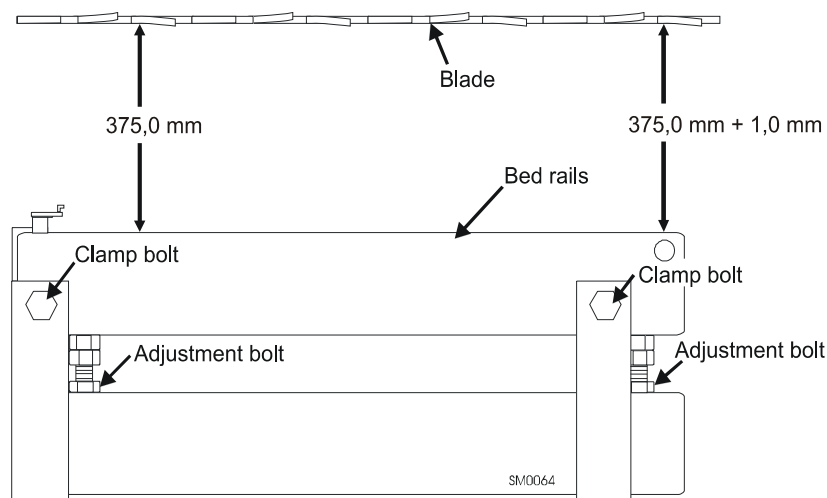
**See Figure 5-24.** Loosen the locking set screws and turn the inner height adjustment nut to adjust the height of the inner end of the pivot rail. Loosen the jam nut and turn the outer adjustment bolt to adjust the height of the outer end of the pivot rail.



**FIG. 5-24**

9. Move the saw head so the blade is positioned over the center of the front main bed rail.
10. Measure the distance between the bottom of the blade and the bed rail at each end of the bed rail. The bed rail should measure 15" (375 mm) from the blade to the bed rail (+1mm at the outer side).

See **Figure 5-25**. Loosen the bed rail clamping bolts and turn the adjustment bolts to move the bed rails to the blade if necessary. Retighten the clamping bolts and adjustment bolt jam nuts.



**FIG. 5-25**

11. Without adjusting the saw head height, check the three remaining main bed rails and the rear pivot rail. Adjust them so that all measure the same distance from the blade at both ends of the bed rail.

### Blade Guide Installation

Each Wood-Mizer sawmill has two blade guide assemblies that help the blade maintain a straight cut. The two blade guide assemblies are positioned on the saw 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 saw 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 saw head. It is referred to as the "outer" assembly and is adjustable for various widths of materials to be processed.

**NOTE:** Before installing the blade guide assemblies, remove the blade guide adjusting screws and apply a lubricating oil such as 10W30 or Dex-ron III to each screw. This will prevent the screws and threaded holes from corroding and make screw adjustments easier.

1. Inspect the guide disks and repair or replace as necessary. Remove the blade from the sawmill.

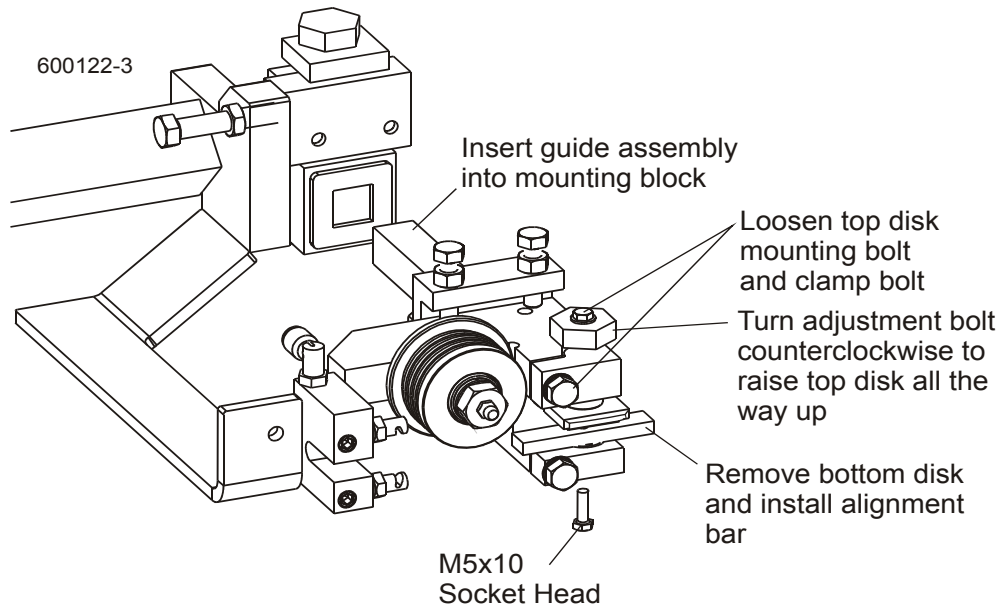


FIG. 5-25

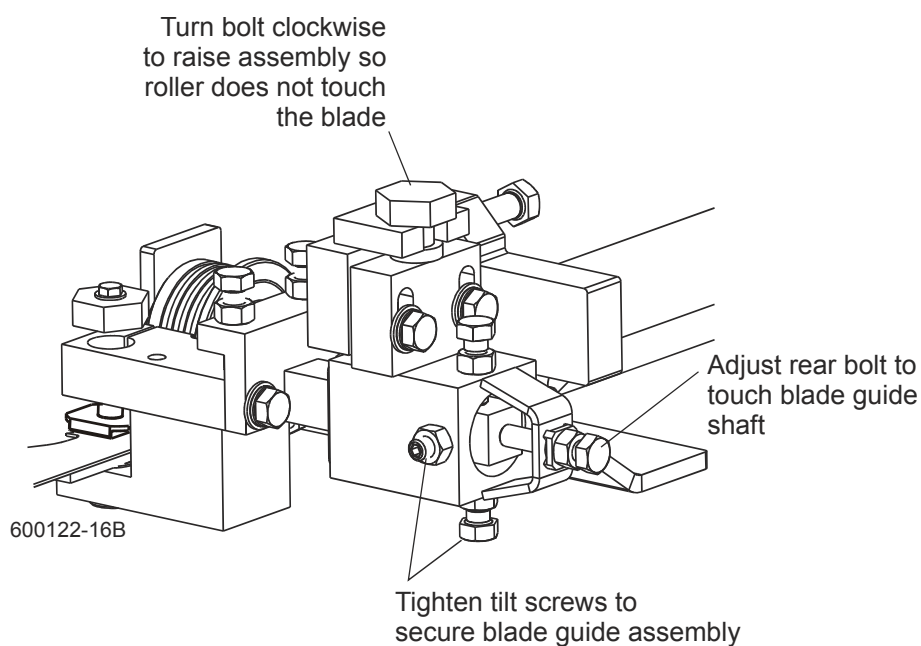
2. Loosen the top disk clamp bolt and mounting bolt. Turn the adjustment bolt counterclockwise to raise the top disk all the way up. Remove the bottom guide disk from each blade guide assembly and install the provided alignment bar.
3. Install each blade guide assembly to the mounting blocks and push all the way back. Install, tension and track a new blade. Adjust the outer blade guide assembly so the roller flange is 1/8" from the back of the blade. Adjust the inner blade guide assembly so the roller flange is 1/16" from the blade.

See Figure 5-26.

Tighten the two previously-loosened tilt adjustment screws to secure the blade guide assembly. Turn the top adjustment bolt clockwise to raise the blade guide assembly so it does not touch the blade.

**NOTE:** Before adjusting the top bolt, unload pressure on the bolt by turning 1/2 turn in the opposite direction it was last adjusted.

With the roller flange positioned properly from the back of the blade, adjust the rear bolt so it touches the end of the blade guide mounting shaft.



**FIG. 5-26**

### **Blade Guide Arm Alignment**

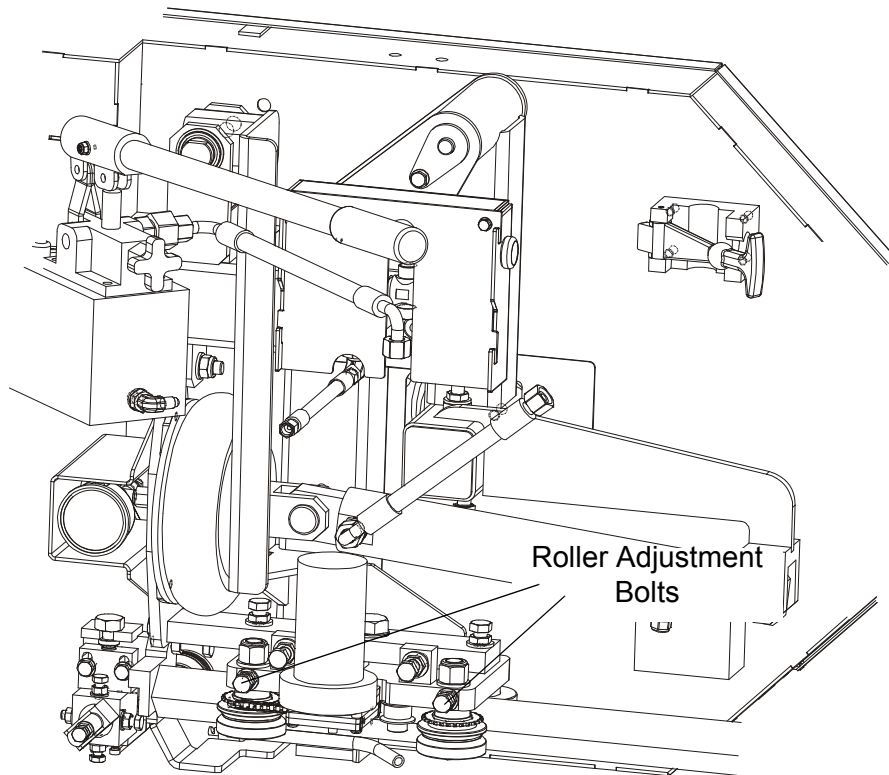
The blade guide arm moves the outer blade guide in and out. If the arm becomes loose, the blade guide will not deflect the blade properly, causing inaccurate cuts. A loose blade guide arm can also cause blade vibration.

1. Adjust the blade guide arm in to 1/2" (15 mm) from fully closed.
2. Manually try to move the arm up and down. If you can move the arm by hand, you will need to tighten the arm rollers.

**See Figure 5-27.** Loosen the jam nuts and turn the adjustment bolts in to tighten the blade guide arm



rollers. Retighten the jam nuts.



**FIG. 5-27**

## 5 Sawmill Alignment

### Complete Alignment Procedure

After tightening the blade guide arm rollers, check that the arm is aligned properly.

3. With the arm adjusted 1/2" (15 mm) from fully closed, measure the distance between the rear blade guide roller and the back of the blade.

See Figure 5-28.

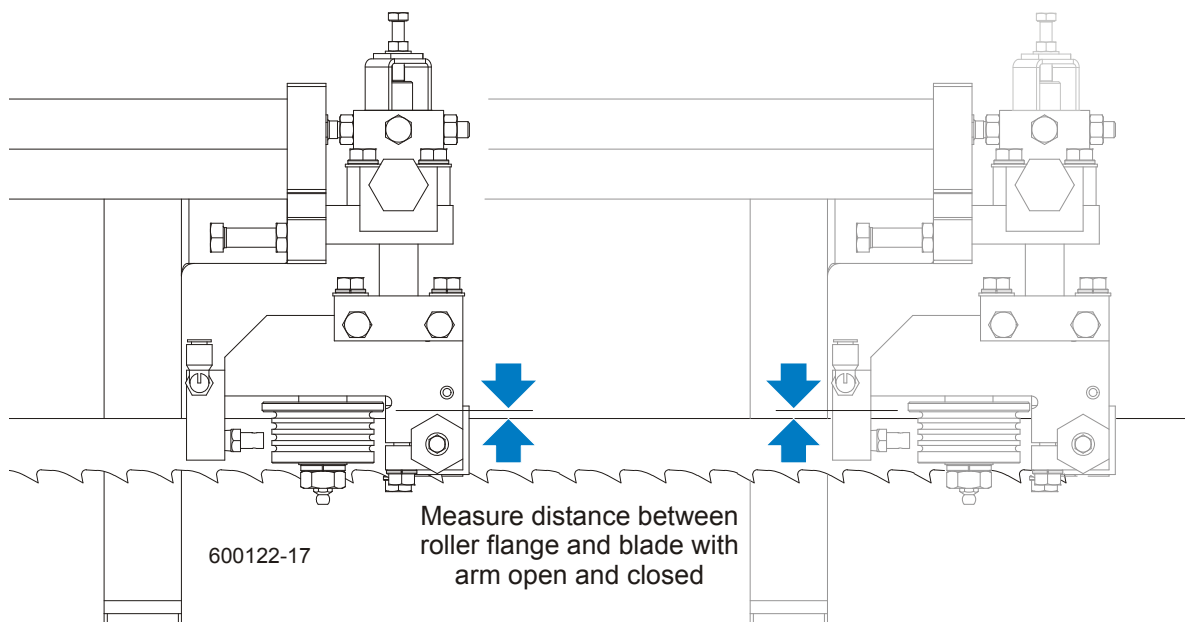
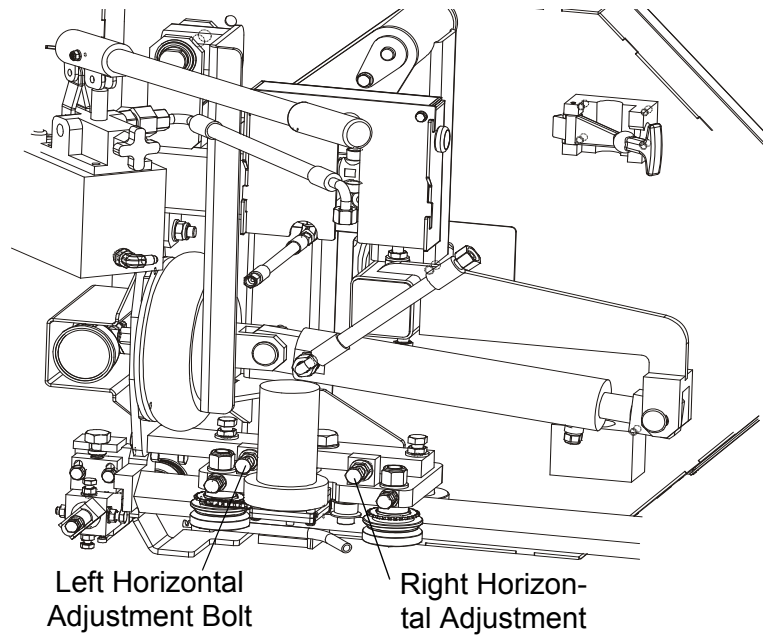


FIG. 5-28

4. Adjust the blade guide arm to 1/2" (15 mm) from fully open and remeasure the distance from the roller flange to the back of the blade. The two measurements should be the same. If not, adjust the outer rollers in or out to tilt the arm horizontally.

See **Figure 5-29**. Loosen the horizontal adjustment bolt jam nuts. To tilt the arm in toward the blade, loosen the right bolt and tighten the left bolt. To tilt the arm out away from the blade, loosen the left bolt and tighten the right bolt. Retighten the jam nuts and recheck the blade guide arm horizontal tilt.



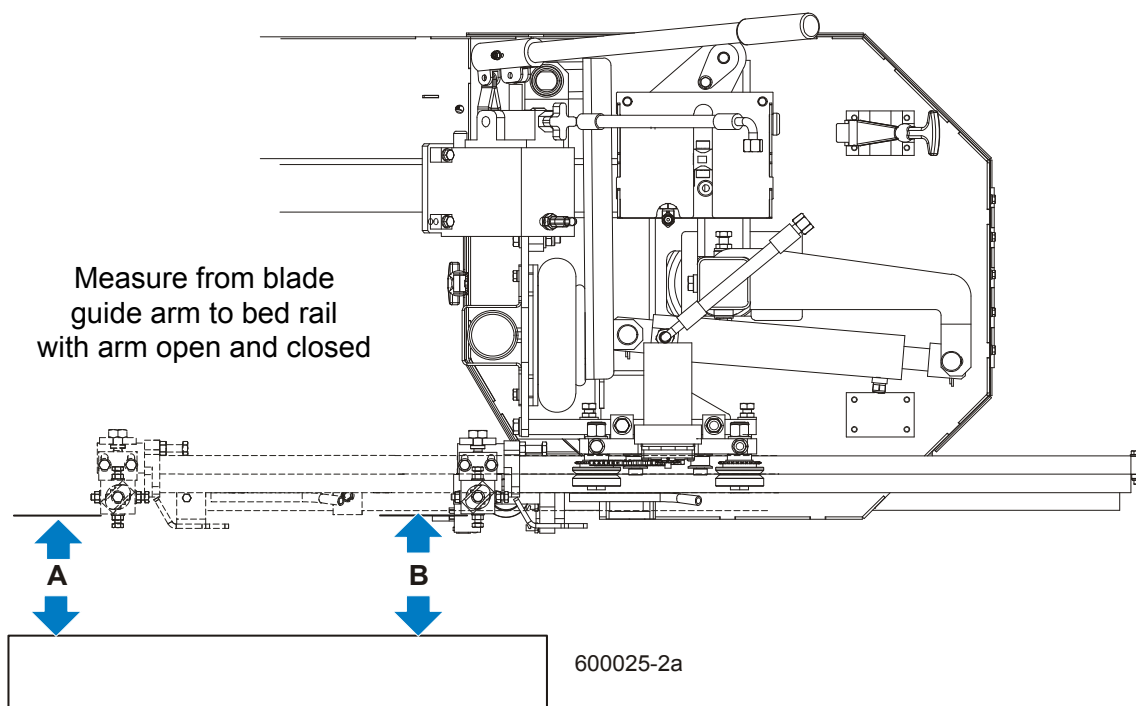
**FIG. 5-29**

5. Now check the vertical tilt of the blade guide arm. Move the saw carriage so the blade guide arm is positioned over a bed rail.
6. With the arm 1/2" (15 mm) from fully closed, raise or lower the saw head until the bottom of the blade guide block is 15" (375 mm) from the top of the bed rail.

## 5 Sawmill Alignment

### Complete Alignment Procedure

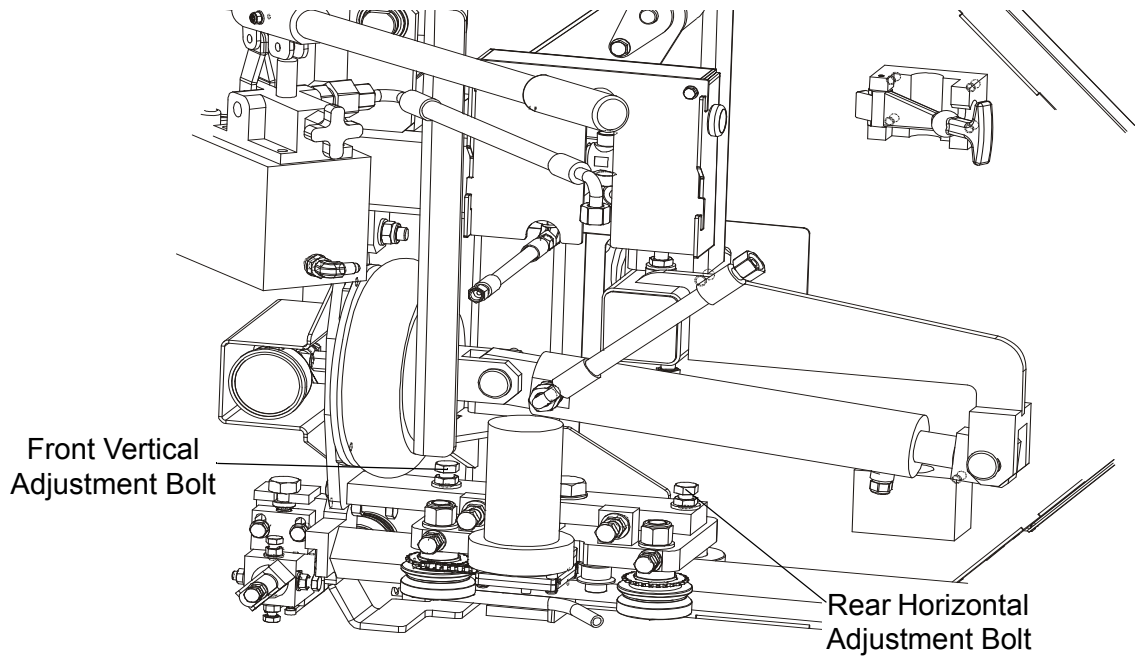
See **Figure 5-30**. Adjust the blade guide arm to 1/2" (15 mm) from fully open. Measure the distance from the bottom of the blade guide mounting block to the bed rail. This measurement should be 15" (376 mm). If the measurements are not the same, adjust the blade guide arm vertically.



**FIG. 5-30**

See **Figure 5-31**. Loosen the vertical adjustment bolt jam nuts. To tilt the blade guide arm down, loosen the rear bolt and tighten the front bolt. To tilt the blade guide arm up, loosen the front bolt and tighten the

rear bolt. Retighten the jam nuts and recheck the blade guide arm vertical tilt.



**FIG. 5-31**

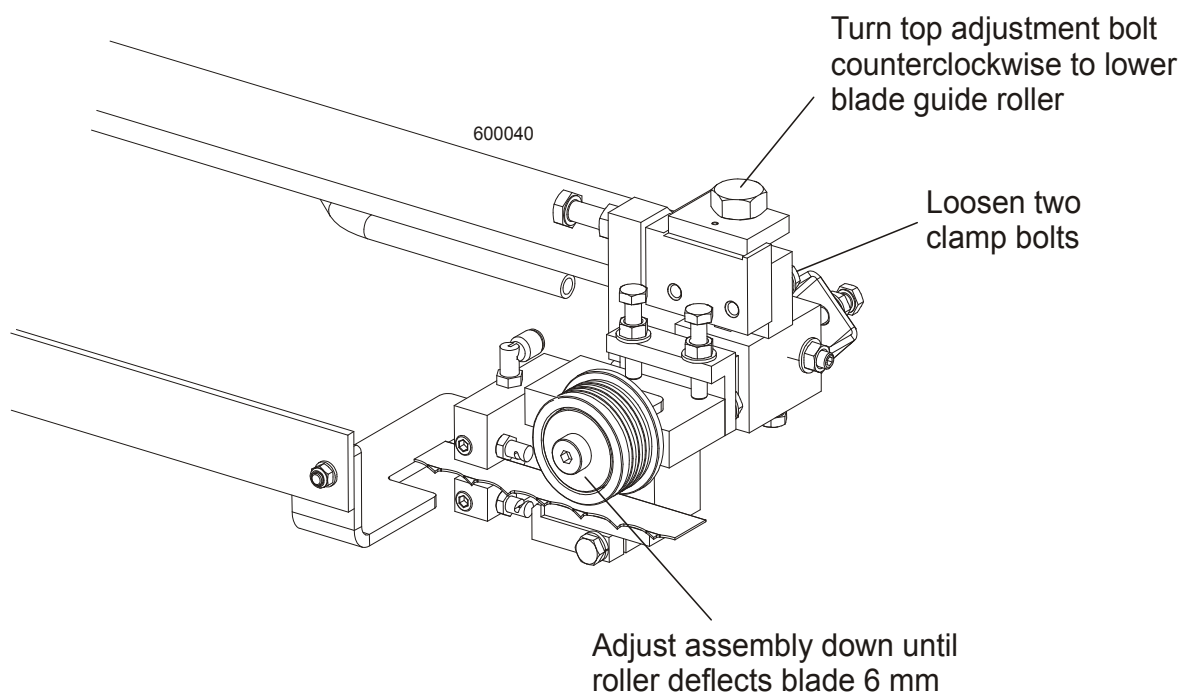
**Blade Guide Deflection**

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

1. Raise the carriage until the blade is 375 mm above a bed rail. Measure the actual distance with a tape from the top of the rail to the bottom of the blade.

**See Figure 5-32.**

Loosen the clamp bolts. Turn the top adjustment bolt counterclockwise to lower the assembly until the blade guide roller deflects the blade down until the bottom of the blade measures 369 mm from the bed rail. Tighten the clamp bolts.



**FIG. 5-32**

2. Repeat for the other blade guide.

### Blade Guide Vertical Tilt Alignment

The blade guides should be adjusted properly in the vertical plane. If the blade guides are tilted vertically, the blade will try to travel in the tilted direction.

A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

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

See Figure 5-33.

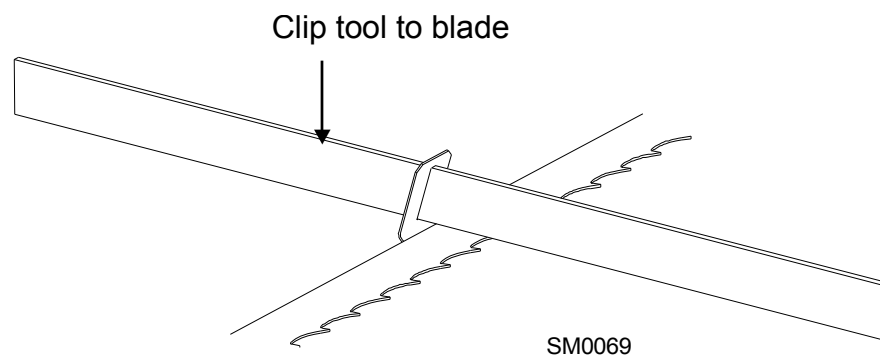


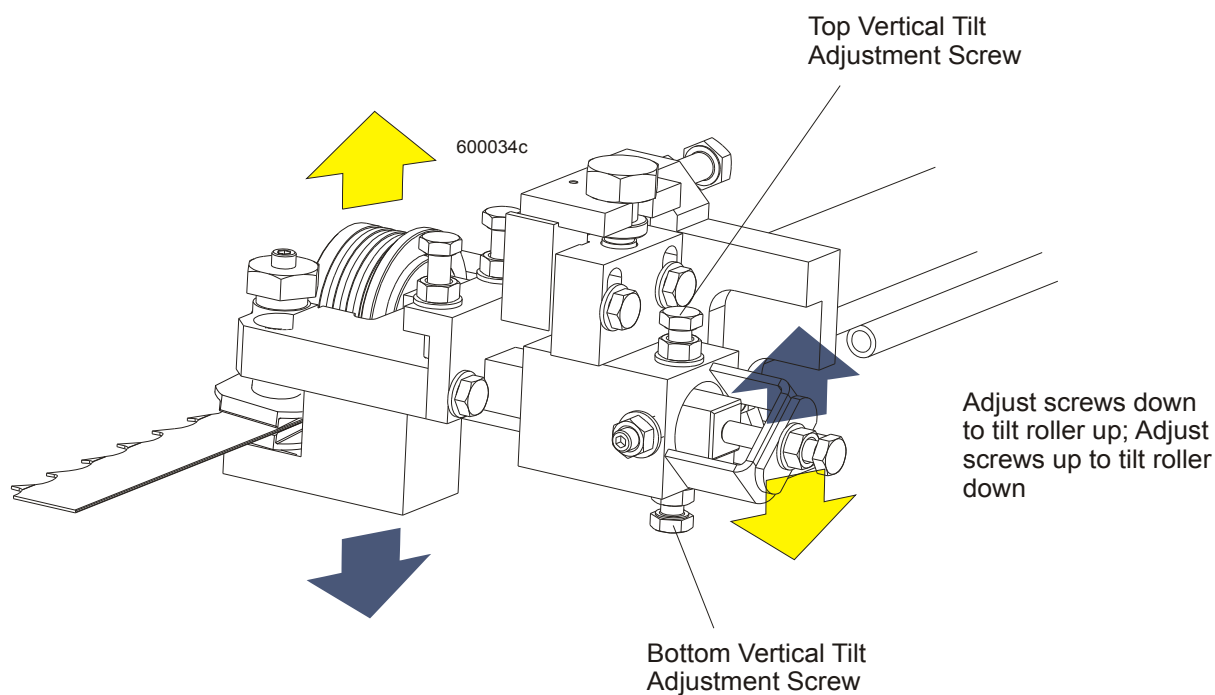
FIG. 5-33

3. Move the carriage so that the front end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
4. Move the carriage so that the back end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
5. If the measurement from the tool to the bed rail is not equal, adjust the vertical tilt of the outer blade guide roller.

## 5 Sawmill Alignment

### Complete Alignment Procedure

See Figure 5-34. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the



**FIG. 5-34**

roller up, loosen the bottom screw and tighten 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.

6. Move the blade guide alignment tool close to the inner blade guide roller assembly and repeat the above steps. Adjust the vertical tilt of the inner blade guide if necessary.

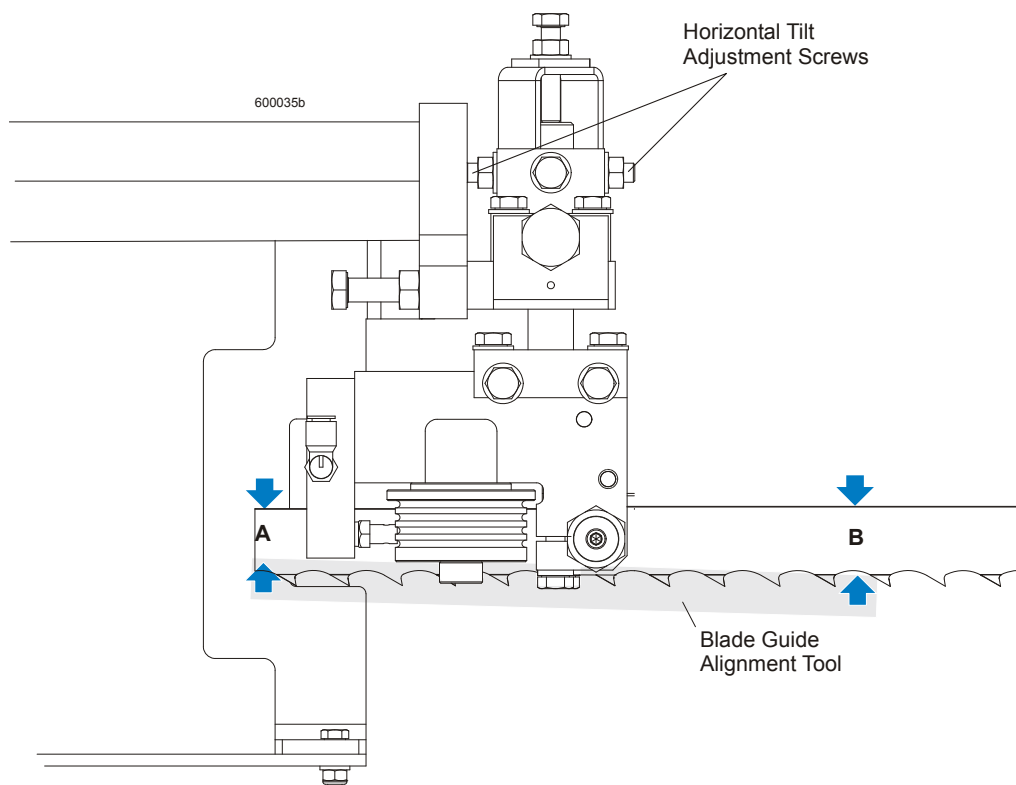


**Blade Guide Horizontal Tilt Adjustment**

If the blade guides are tilted in the wrong direction horizontally, the back of the blade may contact the flange as the roller is spinning down, causing it to push the blade away from the guide roller.

1. Remove the blade guide alignment tool from the blade and adjust the blade guide arm halfway in.
2. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

See Figure 5-35.

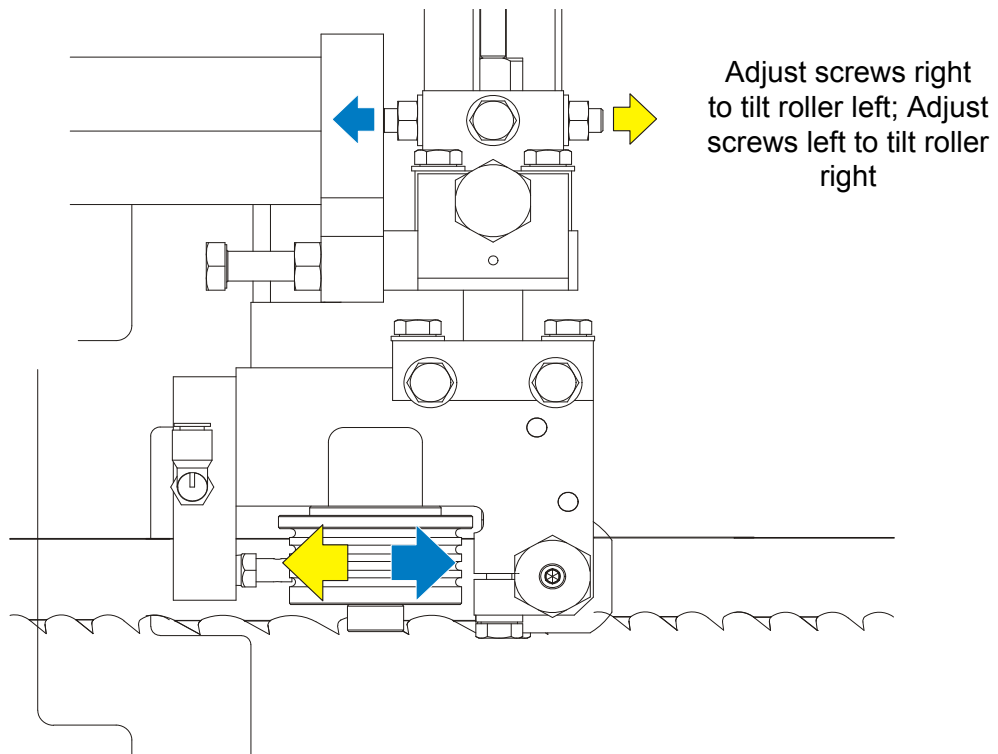


**FIG. 5-35**

3. Measure between the back edge of the blade and the tool 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 tool ("A").

The roller should be tilted slightly to the left ('A' 1/8" [3 mm] less than 'B' ±1/8" [3 mm]).

**See Figure 5-36.** Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the right screw. Tighten the jam nuts and recheck the tilt of the blade.



**FIG. 5-36**

5. Repeat the above steps for the inner blade guide roller assembly.

**NOTE:** Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. [See Blade Handbook, Form #600.](#)

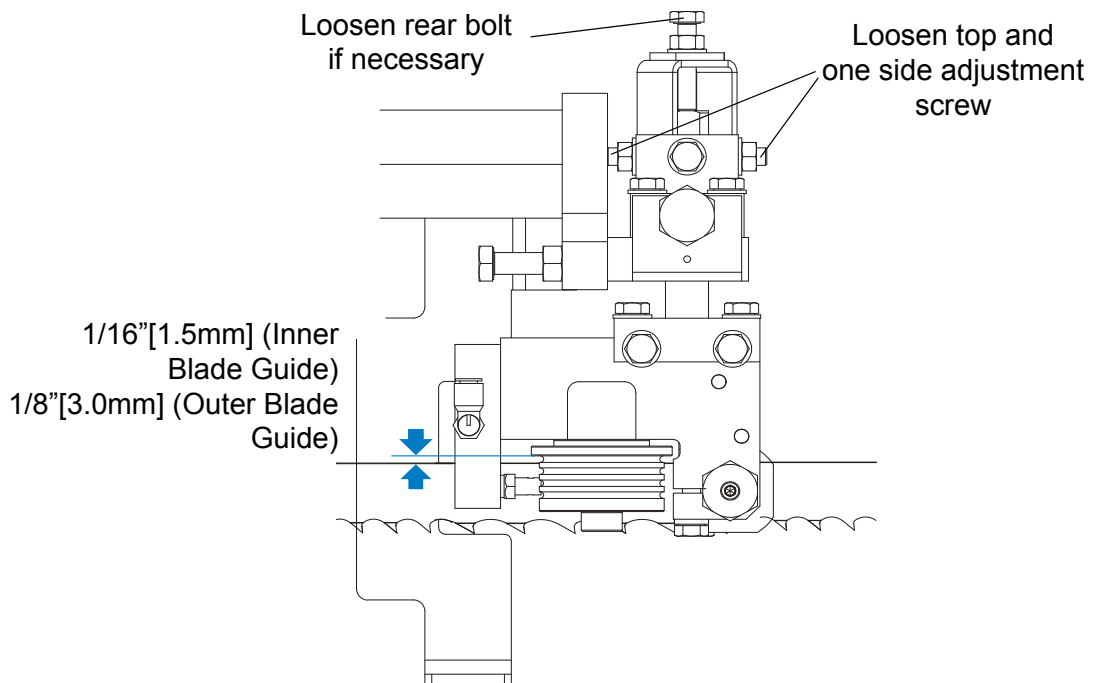
### Blade Guide Flange Spacing

Each blade guide must be adjusted so the roller flange is the correct distance from the back edge of the blade. If the flange is too close to or too far from the blade, the sawmill will not cut accurately.

**HINT:** When adjusting 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 adjustment screws are retightened.

1. Measure the distance between the flange on the inner blade guide roller to the back edge of the blade. This distance should measure 1/16" (1.5 mm). Adjust the roller back or forward if necessary.

**See Figure 5-37.** Loosen the top and one side screw shown and rear adjusting bolt if necessary. Tap the blade guide forward or backward until properly positioned. Retighten the screws and jam nuts.



**FIG. 5-37**

2. Measure the distance between the flange on the outer blade guide roller to the back edge of the blade. This distance should measure 1/8" (3.0 mm). Adjust the roller back or forward if necessary.
3. Check the blade guide disks and drive side deflector plate are properly adjusted ([See Section 5.2](#)).

### Blade Guide Level

Perform the following adjustments to make sure the blade guide assembly is parallel to the blade.

1. Loosen the alignment bar mounting bolt. Use the provided bottom disk adjustment tool to adjust the alignment bar up so the bar is close to, but not touching the bottom of the blade. Retighten the alignment bar mounting bolt

# 5 Sawmill Alignment

## Complete Alignment Procedure

2. Check that the gap from the alignment bar to the blade is the same along entire length of the bar. Shine a flashlight behind the blade guide assembly to help you see the gap between the bar and the blade. To adjust, loosen the rear clamp bolts, but leave snug. Determine which outer bolt to use to tilt the blade guide assembly as desired. Loosen the jam nut and turn the bolt until the alignment bar is parallel to the blade. Retighten the jam nut and clamp bolts. Repeat for the second blade guide assembly.

See Figure 5-38.

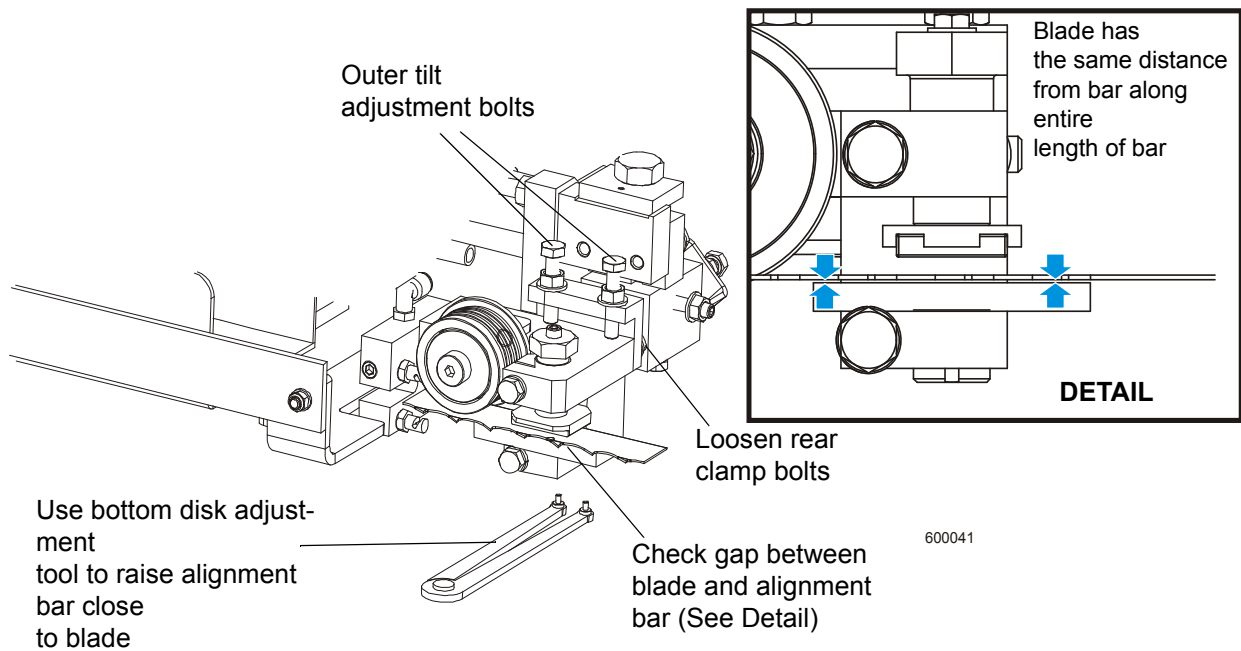


FIG. 5-38

### Blade Disk Adjustment

1. Remove the blade and remove the alignment bars from the blade guide assemblies. Install new or reconditioned bottom guide disks to both blade guide assemblies (leave mounting bolts loose). Use the provided bottom disk adjustment tool to lower the bottom disk all the way down. Install, tension and track the blade.

See Figure 5-39.

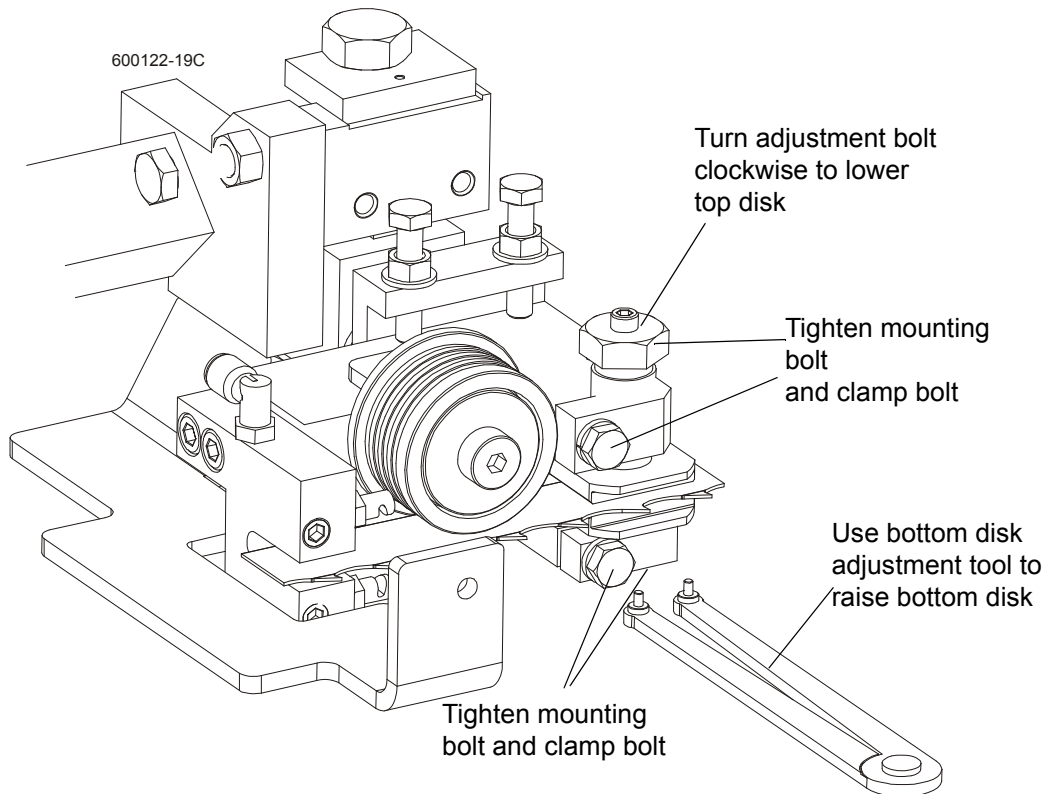


FIG. 5-39

2. Use the bottom disk adjustment tool to raise the bottom disk to 0.3-0.5 mm from the blade. Use the provided shim to set the distance from the disk to the blade. Tighten the bottom disk mounting bolt and clamp bolt.
3. Turn the top disk adjustment bolt clockwise to lower the top disk to 0.3-0.5 from the blade (using the shim as a guide). Tighten the top disk mounting bolt and clamp bolt.
4. After tightening the clamp bolt, recheck the distance from the top disk to the blade and readjust if necessary.

## Horizontal Adjustment of Side Supports

Logs and boards are clamped against the side supports when sawing. The sides supports must be square to the bed to ensure square lumber.

1. Swing the side support down.
2. Measure between the face of the support and the main bed tube. Make measurements at both ends of the side support to make sure that it is parallel to the rail.

See Figure 5-40.

3. Use the two lower bolts to adjust the side support so  $B=A$ .
4. Repeat for remaining side supports.

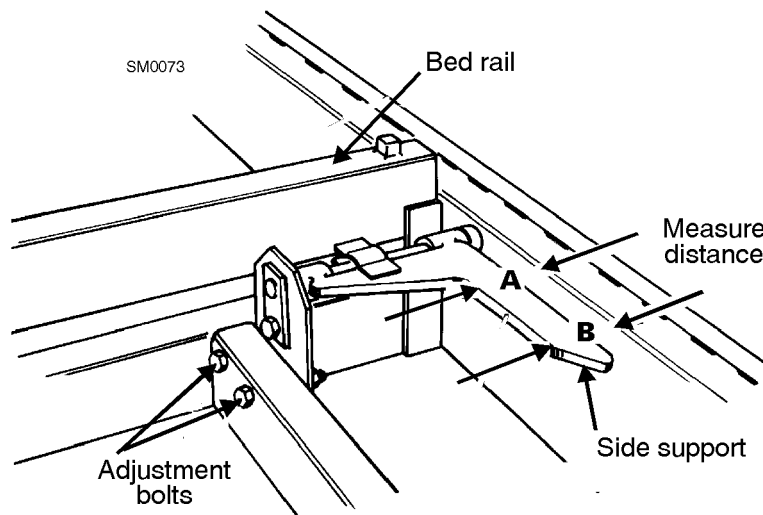


FIG. 5-40

*Vertical Adjustment of Side Supports*

1. Place a flat board across the bed rails.
2. Swing a side support up so that it is vertical.
3. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.

See Figure 5-41.

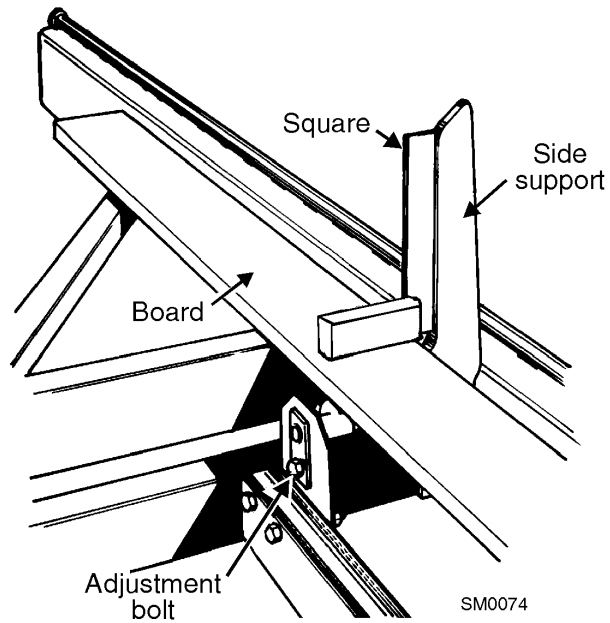


FIG. 5-41

4. Check the angle of each support with a square on the board.
5. The side support should be 90° to the bed rails. Loosen the top adjustment bolt, adjust the side support, and retighten the bolt.
6. Repeat for the remaining side supports.

***Clamp Stop/Stop Bolt Adjustment***

1. Once the side supports are aligned, pivot them down to their horizontal position.
2. Tie a string across the face of the side supports.

Loosen the clamp stop bolts and adjust the clamp stop until it touches the string.



### Saw Head Tilt

As the blade enters a wide log or cant, the outside of the saw head will drop down slightly. To compensate for the drop, the saw head is adjusted 1/16" (1.5 mm) higher at the outside.

1. Move the saw carriage so the blade is positioned over a bed rail. Adjust the blade guide arm to 1/2" (15 mm) from full open. The saw head should still be adjusted so the blade is 14 3/4" (375 mm) above the bed rails.

See Figure 5-42.

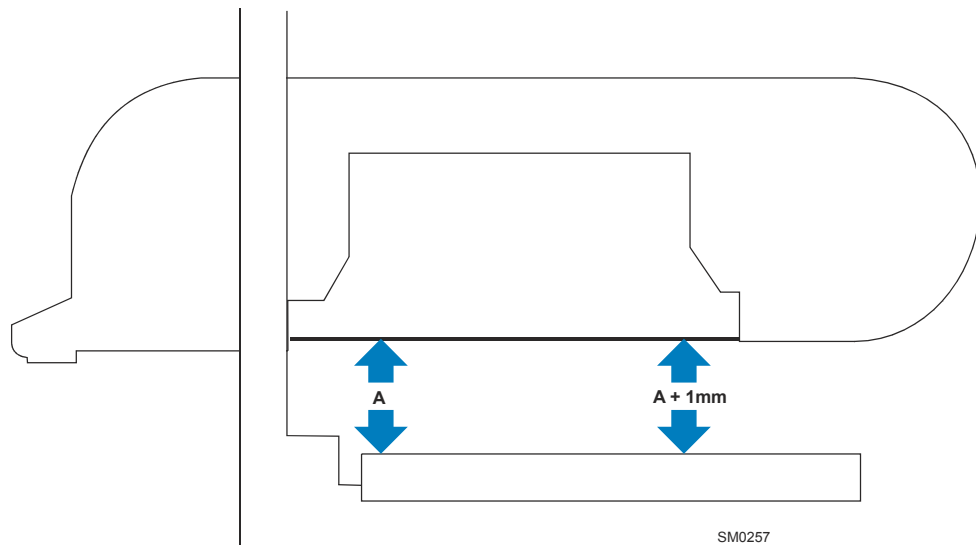


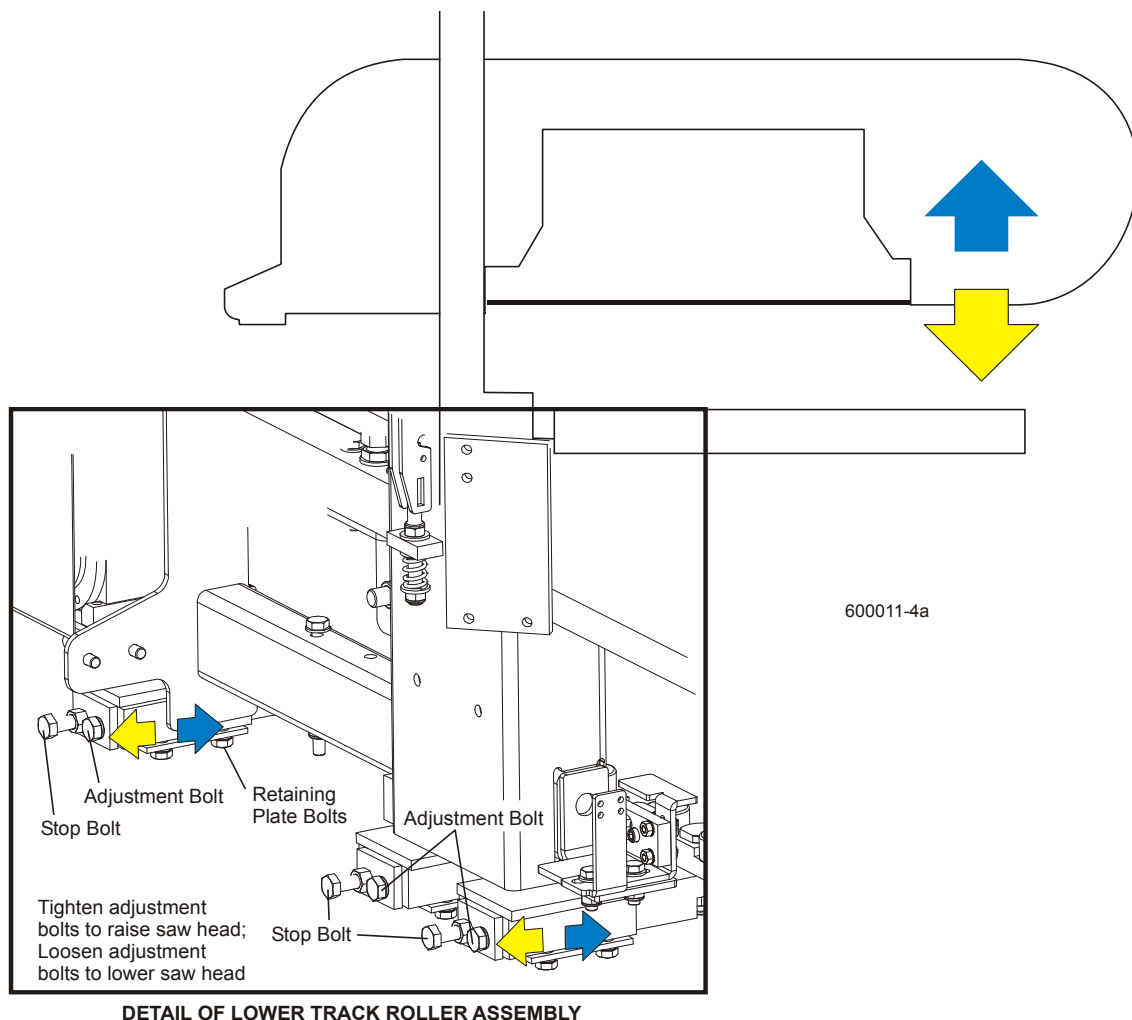
FIG. 5-42

2. Measure from the blade to the bed rail near the outer blade guide assembly. This measurement should be 1/16" (1.5 mm) higher than the inner measurement.

# 5 Sawmill Alignment

## Complete Alignment Procedure

See **Figure 5-43**. To adjust the saw head tilt, use the bolts located at the bottom of the saw head mast. Loosen the three sets of four retaining plate bolts. To raise the outside of the saw head, back the stop bolts out, then tighten the adjustment bolts. To lower the outside of the saw head, loosen the adjustment bolts and tighten the stop bolts. Recheck the measurement from the blade to the bed rails and adjust the stop bolts and adjustment bolts until the outside of the saw head is 1/16" higher than the inside. Retighten the retaining plate bolts.



**FIG. 5-43**



## EC declaration of conformity according to EC Machinery Directive 2006/42/EC Annex II, 1.A

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>SAWMILL</b>
TYPE:	LT70
Model:	.....
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 1807-2:2013-08 PN-EN ISO 13849-1:2008 PN-EN 60204-1:2010 PN-EN ISO 13857:2010 PN-EN ISO 4413:2011
Notified Body according to annex IV :	PZ.LSV; Pruf- und Zertifizierungsstelle des Spitzenverbandes der landwirtschaftlichen Sozialversicherung
Notification No	2157
Responsible for:	EC type examination
EC type-examination certificate no.	LSV-EG-2015/104
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
Place/Date/Authorized Signature:	Koło, 04.02.2015 <b>Adam Kubiak</b>
Title:	R&D Manager