Wood-Mizer®

from forest to final form

user manual

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

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

INDUSTRIAL PRODUCTS

Safety & Operation Manual

EG400EH30S **rev. A1.01**
(E430 Industrial)

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

Form #1209

Table of Contents Section-Page

Getting Service

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

General Contact Information

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

Office Hours:

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

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

Wood-Mizer will accept these methods of payment:

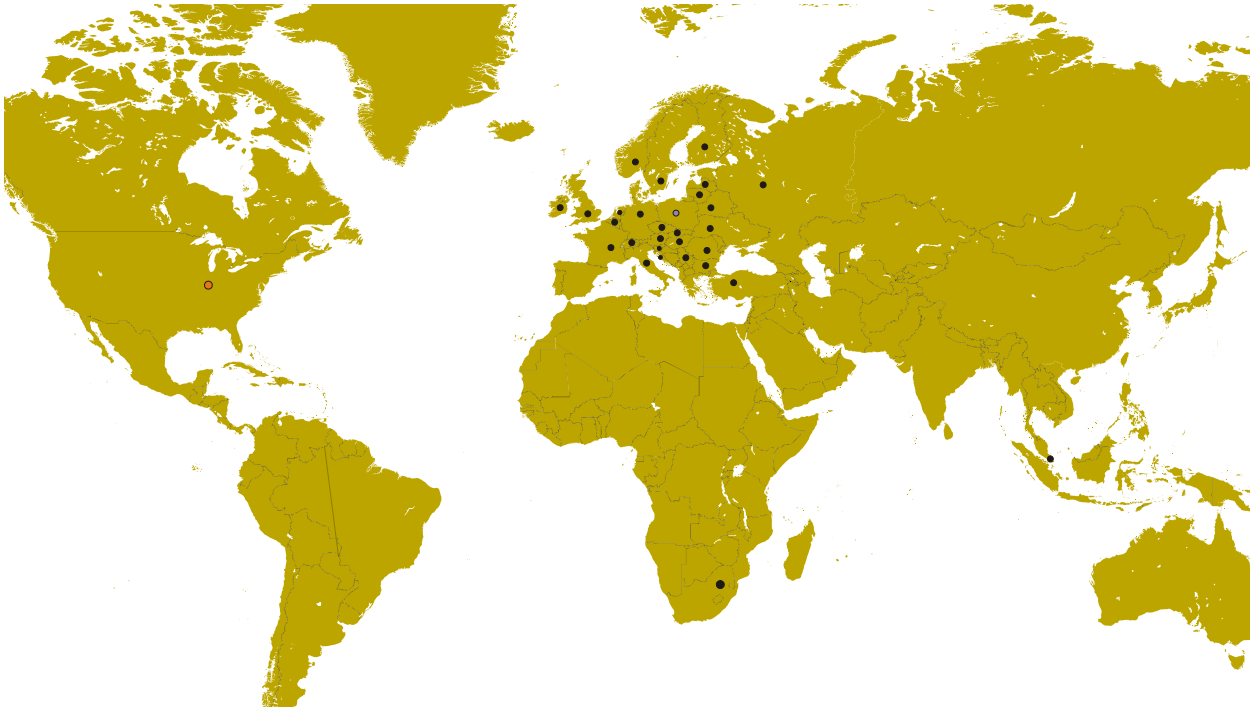
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

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

Technical data are subject to change without prior notice.

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

Branches & Authorized Sales CentersWood-Mizer Locations (North and South America)



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Branches & Authorized Sales Centers

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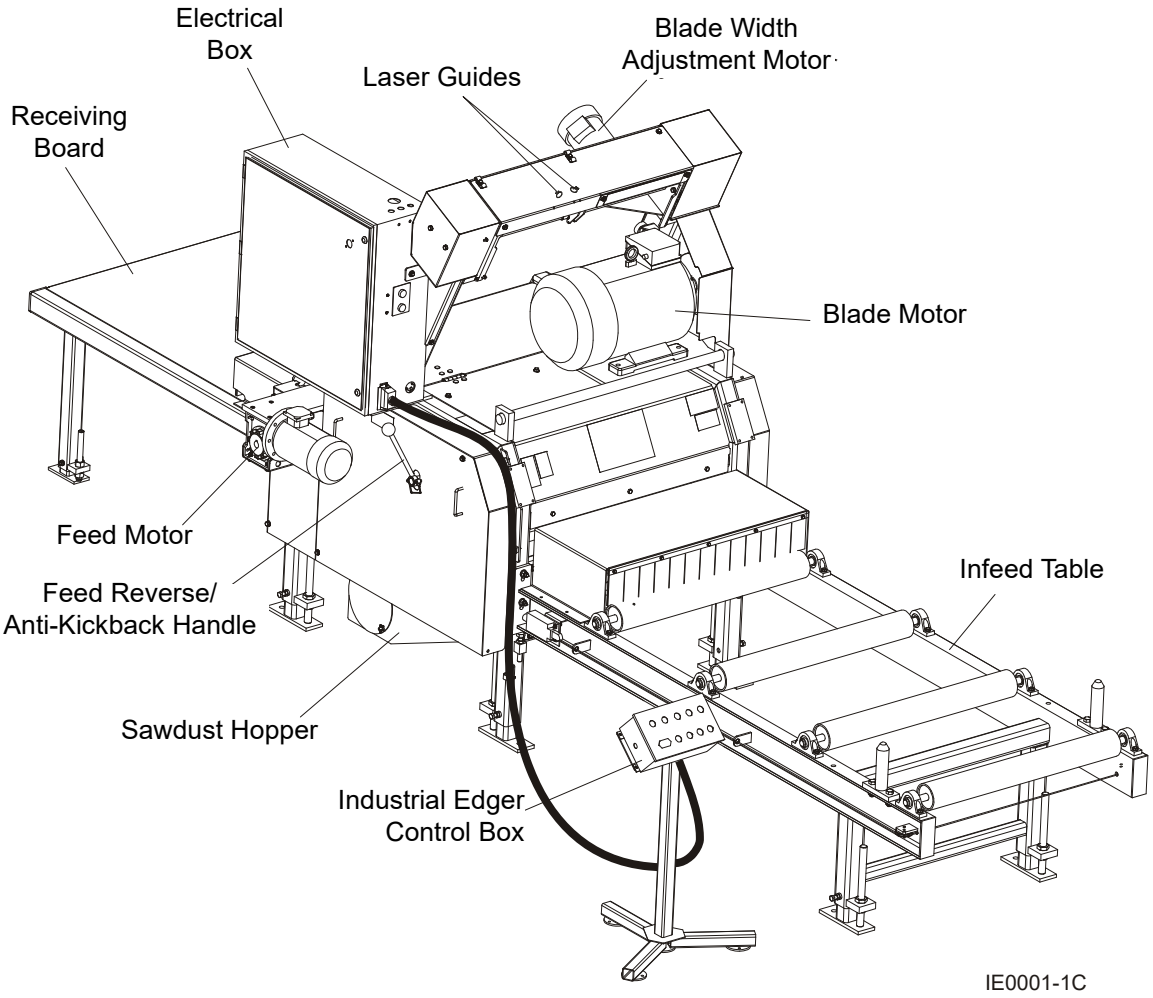
SECTION 1 INTRODUCTION

1.1 About this manual

This manual is to replace or to be used with all previous information received on the Wood-Mizer® * Industrial Edger. All future mailings will be an addition to or a revision of individual sections of this manual as we obtain new information.

The information and instructions given in this manual do not amend or extend the limited warranties for the equipment given at the time of purchase.



**Wood-Mizer® is a registered trademark of Wood-Mizer Products, Inc.

The EG400 Edger is intended for sawing wood only. See Section Specifications for log size capacities of the machine. The machine must not be used for any other purposes such as cutting ice, metal or any other materials.

Using the machine correctly, you will obtain a high degree of accuracy and efficiency.

The Edger should be operated only by an adult (over 18 year old) who has read and understood the entire operator's manual. The Edger is not intended for use by or around children.

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

1.2 Customer and Equipment Identification

Each Wood-Mizer Edger has its own serial number. In addition, when you pick up your edger, you will receive a customer number. These two numbers will help expedite our service to you. Please locate them now and write them below so you have quick, easy access to them.

See figure 1-1 Identification plate is described below.

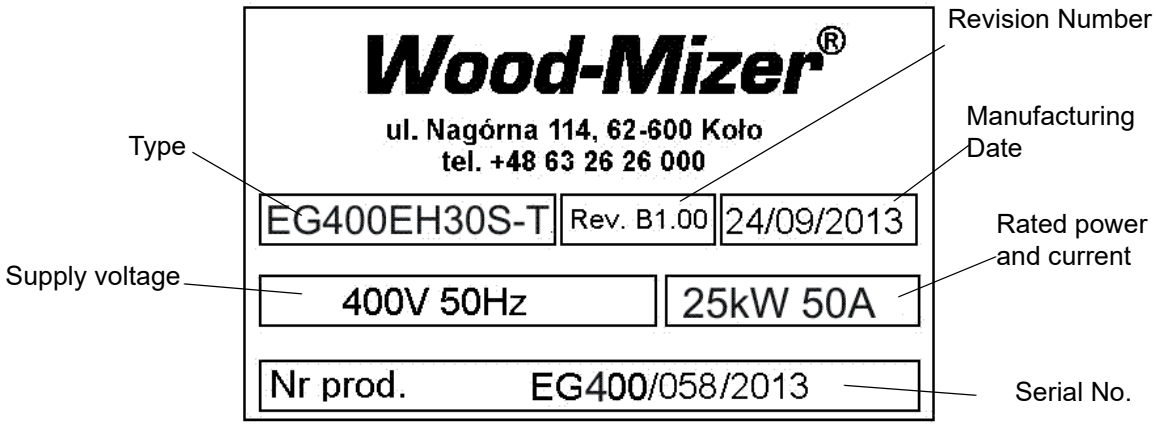
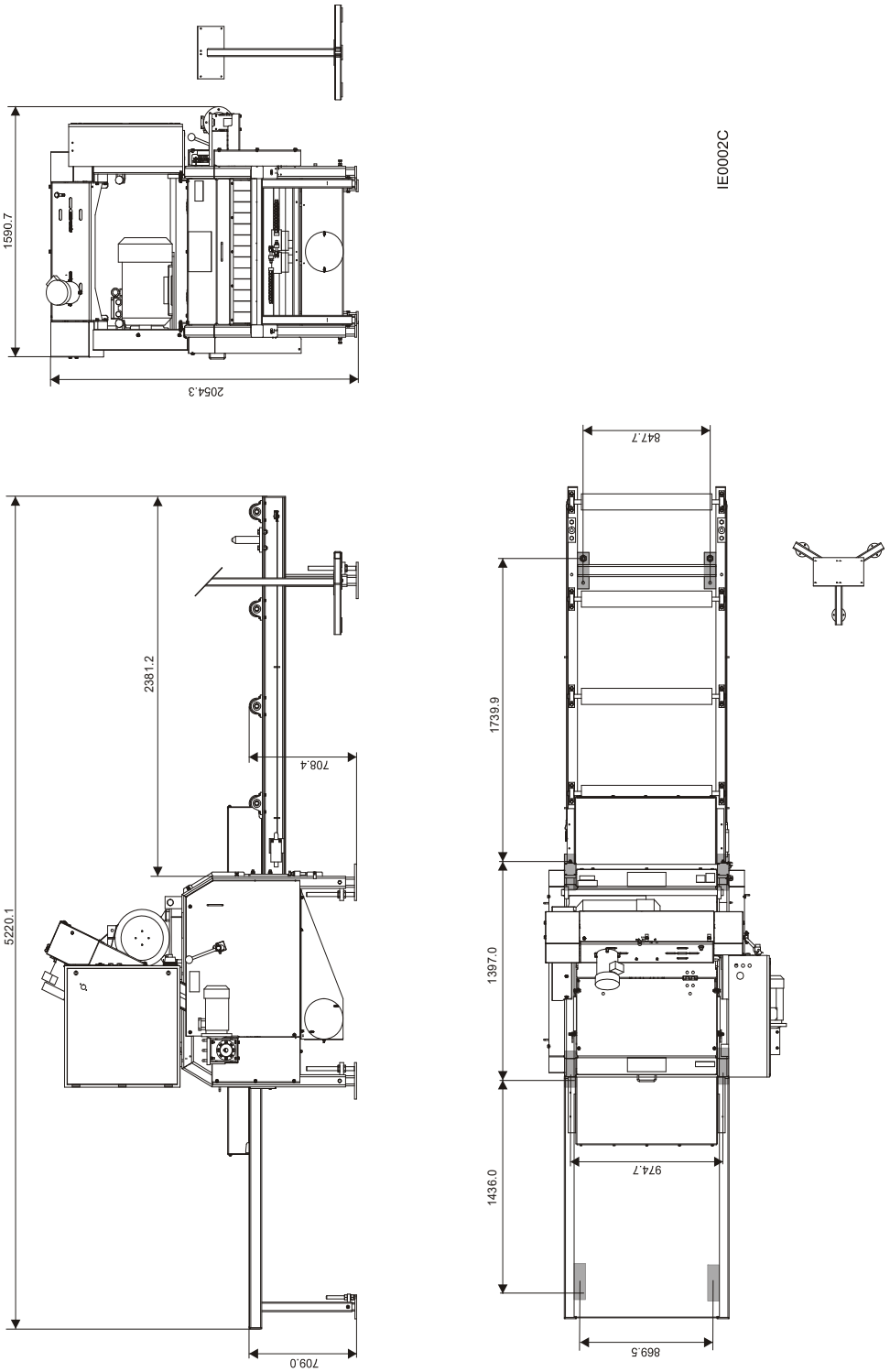


FIG. 1-1

1.3 Dimensions



INDUSTRIAL EDGER DIMENSIONS

1.4 Specifications

Model: EG400 Rev. A1.00

Machine Dimensions:

Length: 5220.1 mm
Width: 1590.6 mm
Height: 2077.6 mm
Infeed Table Height: 711.2 - 914.4 mm (Adjustable)
Infeed Table Length: 2381.2 mm
Weight: 1750 kg

Material Dimensions:

Maximum Feed Width: 914.4 mm
Maximum Board Width Cut: 711.2 mm
Minimum Board Width Cut: 76.2 mm
Maximum Board Thickness: 101.6 mm
Minimum Board Thickness: 25.4 mm

Electrical Installation Requirements:

230/400V 50Hz 3Ph: 100 Amp

Blade System:

Diameter: 406.4 mm
Bore: 18.9 mm
Teeth: 14
Kerf: 9/32"
Blade RPM (No Load): 2320
Width Adjustment Motor Horsepower: 1/2
Width Adjustment Motor RPM: 1725

Feed System:

Minimum Feed Speed (4" material): 30 m/min
Maximum Feed Speed (1" material): 55 m/min
Feed Motor Horsepower: 2.2 kW
Feed Motor RPM: 1380

Blade Motor: 1455

Power: 30 HP (22.3 kW)
RPM (No Load): 1455
Motor Shaft Diameter: 48 mm
Motor Pulley Diameter: 230 mm
Drive Pulley Diameter: 150 mm
Drive Belt: 35VX900

Work Conditions:

Temperature: 5° -40° C (indoor use only)

Noise Level:

87,4dB(A)

INDUSTRIAL EDGER SPECIFICATIONS

SECTION 2 SAFETY

2.1 Safety Symbols

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

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

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

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

IMPORTANT! indicates vital information.

NOTE: gives helpful information.

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

2.2 Safety Instructions

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

OBSERVE SAFETY INSTRUCTIONS

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

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

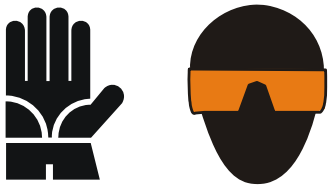
Only persons who have read and understood the entire operator's manual should operate the Edger. The Edger is not intended for use by or around children.

IMPORTANT! It is always 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 Edger. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the Edger.

WEAR SAFETY CLOTHING

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

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



WARNING! Always wear protective gloves (compatible with EN 388, Category III) and protective apron (compatible with EN ISO 13688:2013-12, kategorie I) when operating the machine.

WARNING! Always wear ear, respiration, hand and foot protection when operating or servicing the edger.

KEEP EDGER AND AREA AROUND EDGER CLEAN

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

DISPOSE OF SAWING BY-PRODUCTS PROPERLY

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

CAUTION! The Edger's work-stand should be equipped with a 4

kg or bigger dry powder extinguisher.

CHECK EDGER BEFORE OPERATION

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

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

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

WARNING! Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.

Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to do so may result in serious injury.

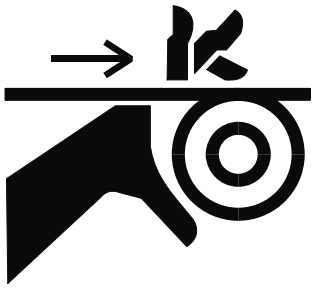
KEEP PERSONS AWAY

DANGER! Keep all persons out of the path of moving equipment and boards when operating the Edger. Failure to do so may result in serious injury.

KEEP HANDS AWAY

DANGER! Moving parts can crush and cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating or towing. Failure to do so may result in serious injury.

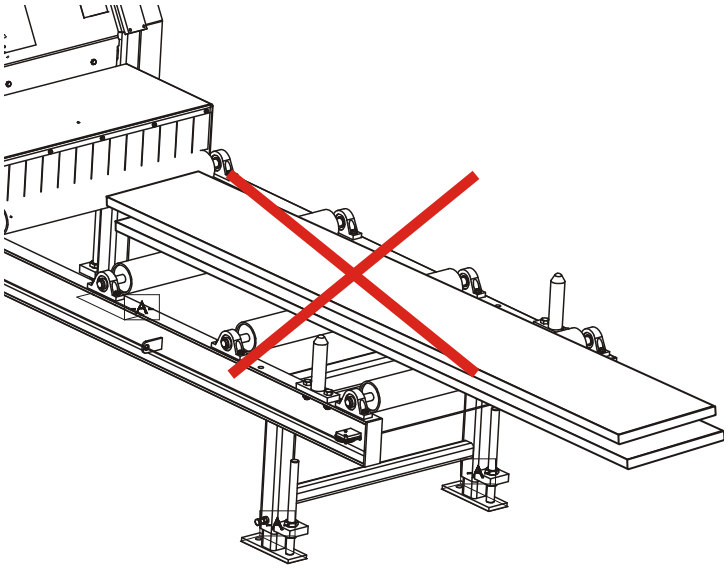
DANGER! Always stay a safe distance from rotating parts and make sure that loose clothing or long hair does not engage rotating parts resulting in possible injury.



WARNING! Always shut off the engine and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

WARNING! Kickback hazard. Stay clear of area during operation. Follow all anti-kickback service and safety rules. Failure to do so may result in serious injury.

WARNING! Never try to cut two or more boards at once.



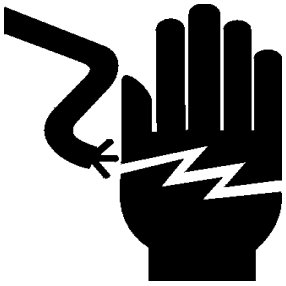
WARNING! In case of a rive belt break, wait until all rotating parts are completely stop Failure to do so may result in serious injury or death.

USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND MAINTENANCE

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

DANGER! Hazardous voltage inside the electric disconnect box, starter box, 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 Edger operation.

DANGER! Operator can not for any reason perform any laser maintenance or repair work.



WARNING! Consider all electrical circuits energized and dangerous.

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

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

DANGER! Lockout procedures must be used during:

Changing or adjusting blades
Unjamming operations
Cleaning
Mechanical repair
Electrical maintenance
Retrieval of tools/parts from work area.

Activities where guards or electrical panel guard is open or removed

Maintenance hazards include:
Blade contact
Pinch points
Kickbacks
Missiles (thrown blades/wood chips)
Electrical

Failure to lockout may result in:
Cut
Crush
Blindness
Puncture
Serious injury or death
Amputation
Burn
Shock
Electrocution

To control maintenance procedures:
Lockout procedures must be followed (see ANSI Standard Z244.1-1982 and OSHA regulation 1910.147).
Never rely on machine stop control for maintenance safety (emergency stops, on/off buttons, interlocks).
Do not reach into moving blades or feed systems. Allow all coasting parts to come to a complete stop.
Electrical power supply and air supply must both be locked out.
Where established lockout procedures cannot by used (electrical troubleshooting or mechanical dynamic troubleshooting), alternative effective protective techniques shall be employed which may require special skills and planning.
Always follow safe operation practices in the workplace.

Keep safety labels in good condition.

IMPORTANT! Always be sure that all safety warning decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact Wood-Mizer Customer Service or your local distributor to order new decal.

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

Safety Labels Description

See table 2-1 Pictogram decals used to warn and inform the user about danger.

TABLE. 2-1

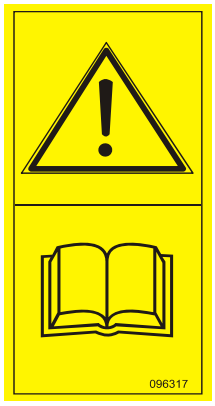
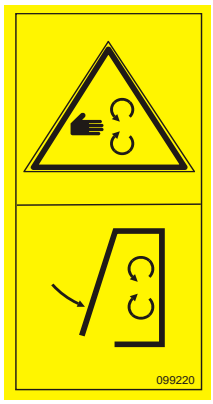
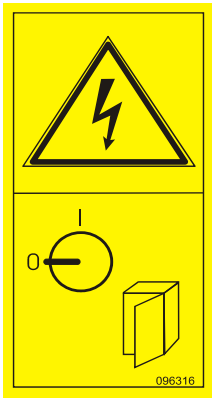
Decal View	Decal No.	Description
	096317	CAUTION! Read thoroughly the operator's manual before operating the edger. Observe instructions and safety rules when operating.
	099220	Close all guards and covers before starting the sawmill.
	096316	Do not open or close the electric box when the switch **is not** in the "0" position.

TABLE. 2-1

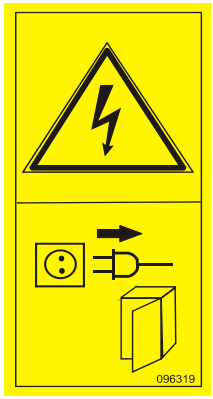
	096319	Always disengage the power supply cord before opening the electric box.
	S12004G	Always wear safety goggles when operating the edger.
	S12005G	Always wear protective ear muffs when operating the edger.
	501465	CAUTION! Always wear safety boots when operating the edger!

TABLE. 2-1

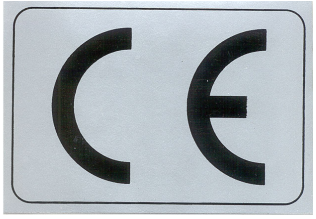
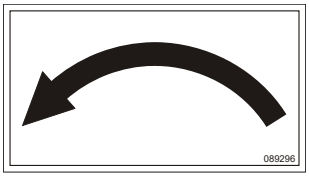
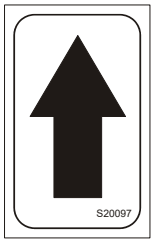
	510080	Always wear protective gloves when operating the edger!
	539211	Always wear protective apron when operating the edger!
	501467	Lubrication point
	099504	Visible and/or invisible laser radiation. Avoid eye or skin exposure to direct or scattered radiation.
	P85070	CE safety certification

TABLE. 2-1

	089296	Rotation direction
	S20097	Motor rotation direction.

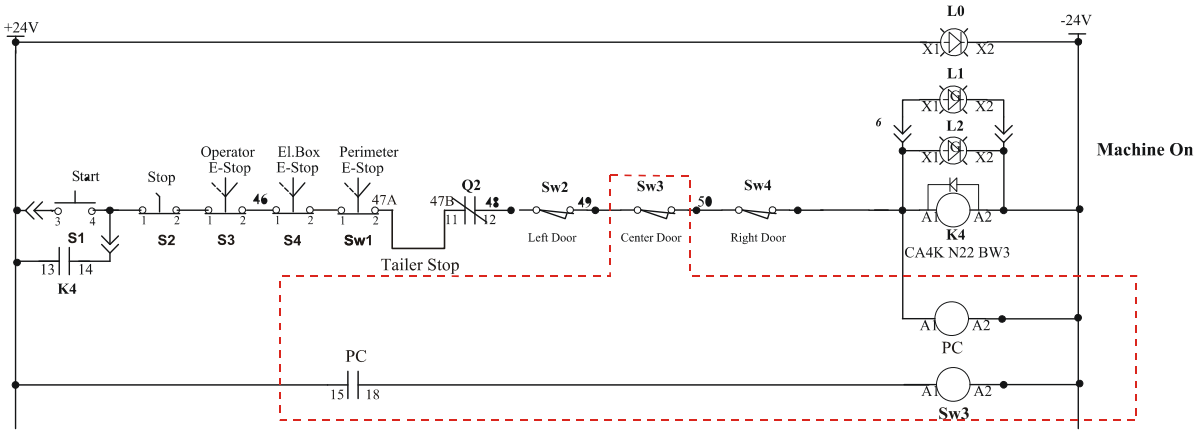
2.3 Safety Devices Inspection

EG400 - Safety devices inspection

Safety devices on the EG400 machine:

- E-STOP button on the control box (Operator E-STOP),
- E-STOP button on the electric box (EL-Box E-STOP),
- safety switch under the middle cover (Sw3),
- safety switch under the right cover (Sw4),
- safety switch under the left cover (Sw2),
- string switch (Sw1).

Location of safety devices on the electric diagram:



Safety devices checked daily:

- E-STOP button on the control box (Operator E-STOP),
- E-STOP button on the electric box (EL-Box E-STOP),
- string switch (Sw1).

Safety devices checked during maintenance:

- safety switch under the middle cover (Sw3),
- safety switch under the right cover (Sw4),
- safety switch under the left cover (Sw2),

1. **E-STOP button control procedure - control box**

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait a while after turning on the motor and push the E-STOP button on the control box,

- The controls should be turned off and the main motor should by stopped,

- Press the System Start button when the E-STOP is pressed,

- The controls should not be turned on.

- Press the Blades Start button when the E-STOP is pressed,

- The main motor should not be started,

- Release the E-STOP button,

- The controls and the main motor should be turned on.

2. **E-STOP button control procedure - electric box**

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait a while after turning on the motor and push the E-STOP button on the electric box,

- The controls should be turned off and the main motor should by stopped,

- Press the System Start button when the E-STOP is pressed,

- The controls should not be turned on.

- Press the Blades Start button when the E-STOP is pressed,

- The main motor should not be started,

- Release the E-STOP button,

- The controls and the main motor should be turned on.

3. **String switch control procedure - Sw1**

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait a while after turning on the motor and pull the red string of the string switch,

- The controls should be turned off and the main motor should by stopped,

- Press the System Start button when the E-STOP is pressed,

- The controls should not be turned on.

- Press the Blades Start button when the E-STOP is pressed,

- The main motor should not be started,

- Press the button on the string switch,

- The controls and the main motor should be turned on.

4. **Checking the safety switch under the left cover - Sw2.**

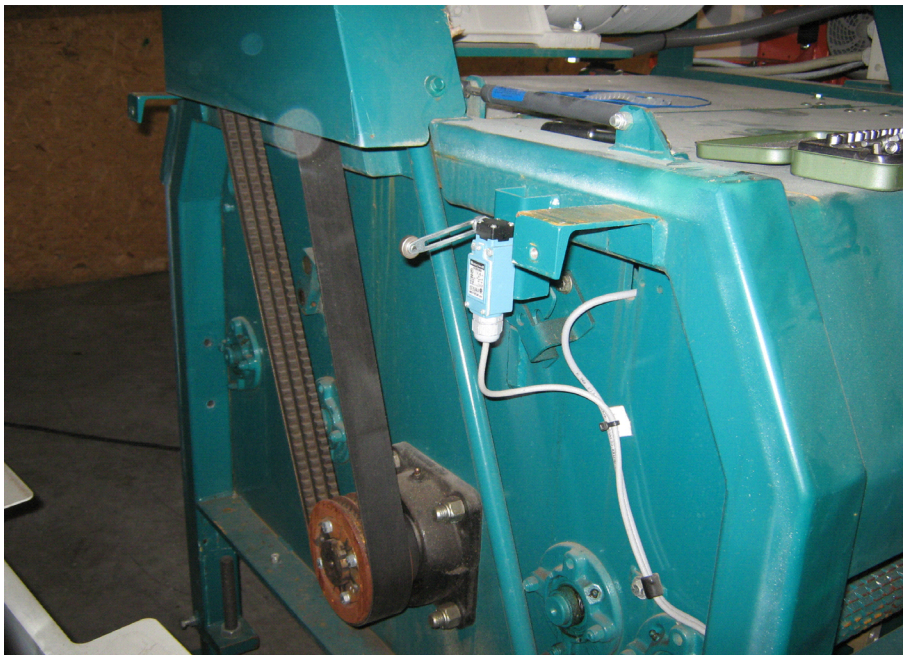
- Remove the bolts mounting the cover,

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait until the main motor starts and then open the cover,



- The controls should be turned off and the main motor should by stopped,

- When the cover is open, press the System Start button,

- The controls should not be turned on.

- Press the Blades Start button when the cover is open,

- The main motor should not be started,

- Mount the cover,

- The controls and the main motor should remain turned off.

5. **Checking the safety switch under the right cover - Sw4.**

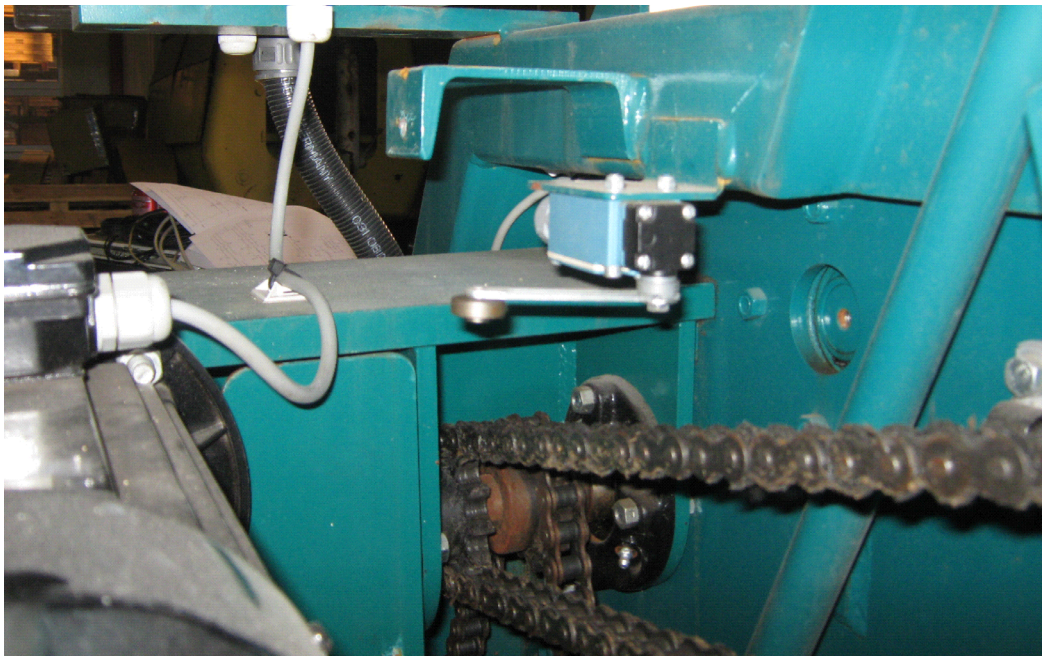
- Remove the bolts mounting the cover,

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait until the main motor starts and then open the cover,



- The controls should be turned off and the main motor should by stopped,

- When the cover is open, press the System Start button,

- The controls should not be turned on.

- Press the Blades Start button when the cover is open,

- The main motor should not be started,

- Mount the cover,

- The controls and the main motor should remain turned off.

6. **Checking the safety switch under the middle cover - Sw3.**

- Remove the bolts mounting the cover,

- Turn on the power supply,

- Turn on the controls by pressing the Machine Start button,

- Turn on the main motor by pressing the Blades Start button,

- Wait until the main motor starts and then open the cover,

- The cover should remain locked,

- Stop the motor by pressing the Blades Stop button and turn off the controls by pressing the Machine Stop button,

- Open the cover,

- Try to turn on the controls by pressing the Machine Start button and try to start the motor by pressing the Blades Start button,

- The controls and the blade motor should remain turned off.

- Close the cover,

- The controls and the blade motor should remain turned off.

SECTION 3 SETUP & OPERATION

3.1 Setup

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. Setting the phases correctly will ensure correct rotation directions of all machine motors.

IMPORTANT! Before starting to use the edger the following conditions have to be met:

- Set up the edger on firm and level ground.
- The edger can be operated with a sawdust extraction system only.
- The edger can be operated indoor only.
- The edger can be operated in temperature range from -15° C to 40° C only.
- Illuminance at operator's position must be 300lx. *
- Have a qualified electrician install the power supply. The power supply must meet the specifications given in the table below.

3-Phase Volts	Fused Disconnect	Suggested Wire Size
400 VAC	80 A	10 mm^2

TABELA 3-1

IMPORTANT! It is required that a 30mA Ground Fault Interrupter (GFI) be used (type B).

* The light source can not cause stroboscopic effect.

- The edger's operator position (two persons) is shown below

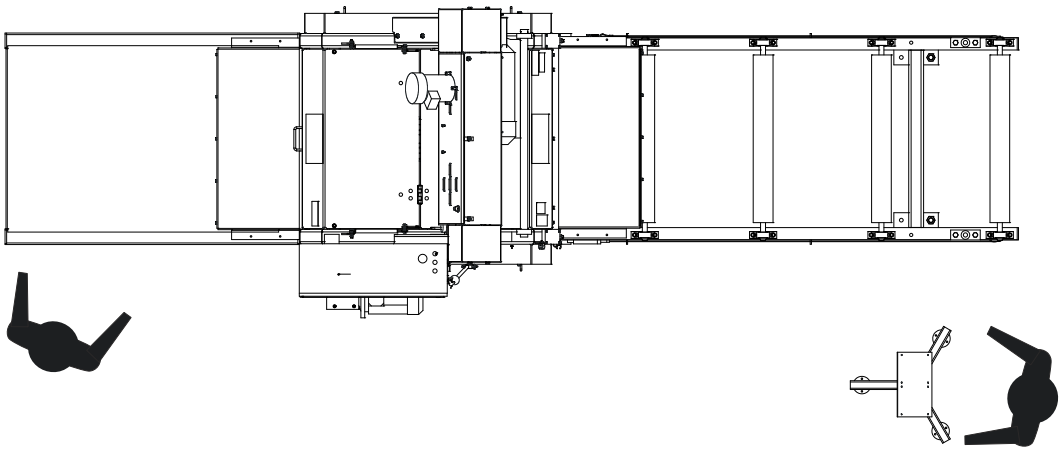


FIG. 3-1

Use a forklift or other appropriate equipment to move the edger. The forklift must be rated for at least 2000kg (4409lb.).

WARNING! Use extreme care and proper equipment to lift and move the edger. Lift the machine from under the front or rear of the base only, never from sides or upper carriage. Failure to do so may result in serious personal injury and/or machine damage

See figure 3-2.

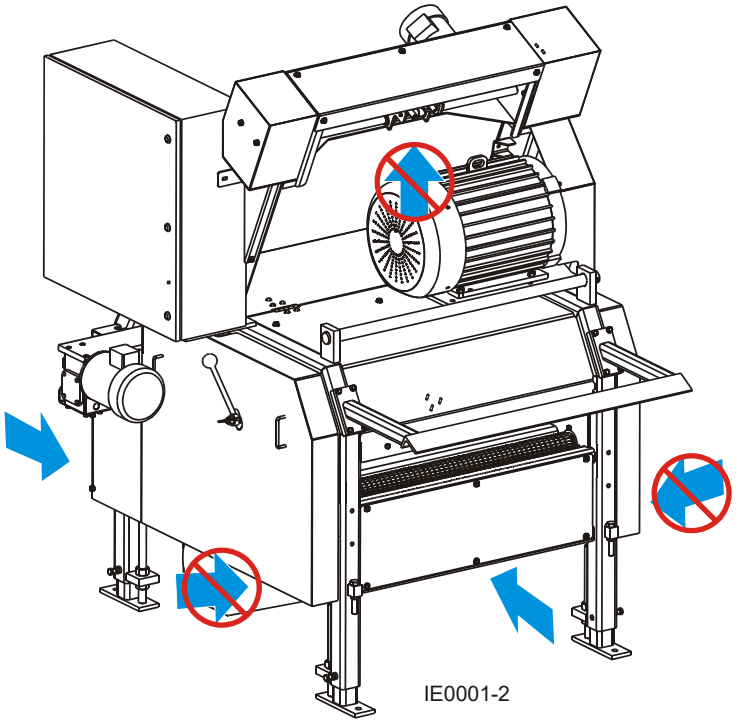


FIG. 3-2

Place the edger on a concrete foundation strong enough to support the weight of the machine. Allow for room around the edger to feed and remove boards. Secure the edger to the foundation with anchor bolts.

See figure 3-3. Adjust four legs of the edger so the infeed height is appropriate for your application. Loosen the locking bolt and turn the adjustment nut counterclockwise to raise

the edger, clockwise to lower the edger. Retighten the locking bolt.

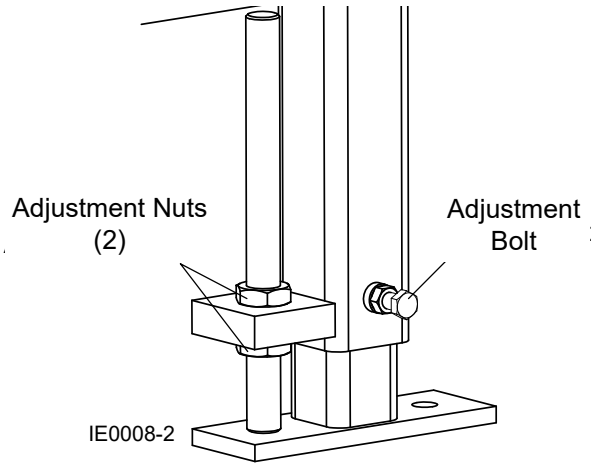


FIG. 3-3

See figure 3-4. Assemble the infeed table to the front of the edger with the bolts provided. Use the height adjustment bolt and nut to support the infeed table properly before securing the infeed table to the edger on both sides.

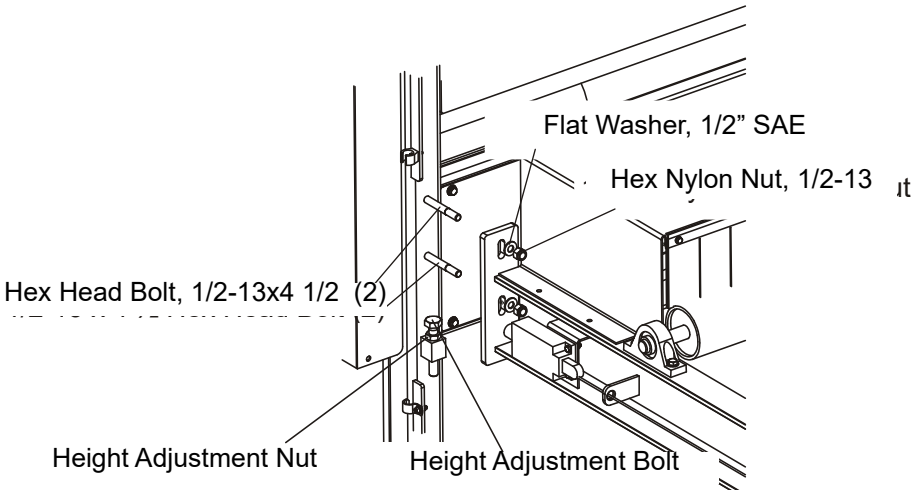


FIG. 3-4

Adjust the infeed table height in the same manner as the edger legs so the table is aligned with the infeed rollers of the edger. **NOTE:** Make sure the infeed table rollers are leveled with the edger lower infeed drive rollers before starting cutting.

3.2 Electrical Installation

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 disconnect box, starter box, 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 Edger operation.

IMPORTANT! Once a half year perform inspection of the electrical equipment by a qualified electrician.

Perform the following steps prior to operating the Edger to make the required electrical connections:

1. Unlock and open the electrical box on the Edger.

2. Locate the main disconnector in the upper right corner inside the electrical box. Route the power supply cable through the upper hole in the electrical box and above the disconnector. Connect the power supply wire to the main disconnector as shown

   See figure 3-5. Connect the power supply wire to the main disconnector in the electrical

box.

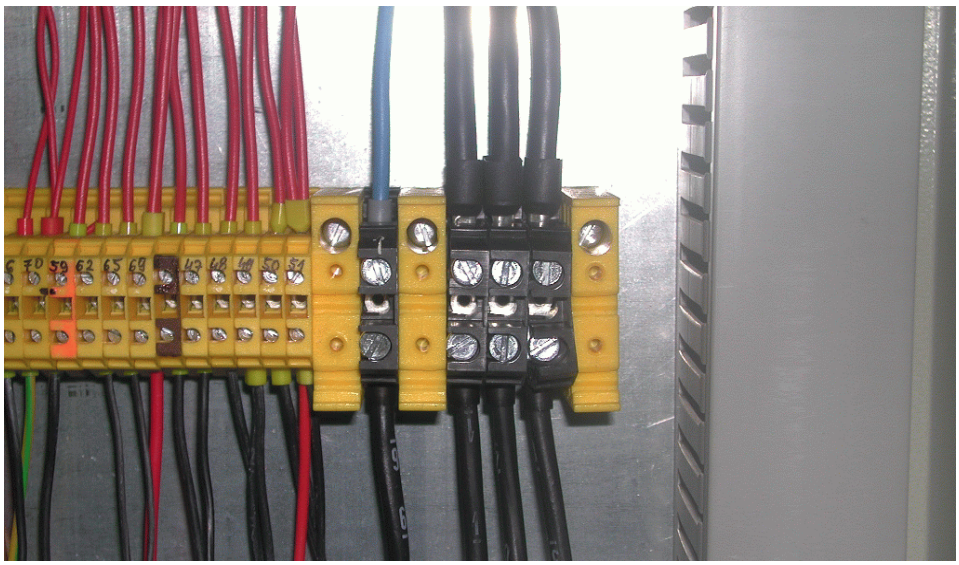


FIG. 3-5

3. Close electrical box and lock with keys.

4. Setup the Edger control box next to the Edger. Make sure that the place where the control box is located is safe and comfortable to operate the Edger. Connect the control box cable to the electrical box.

See figure 3-6. Connect the Edger control box to the electrical box.

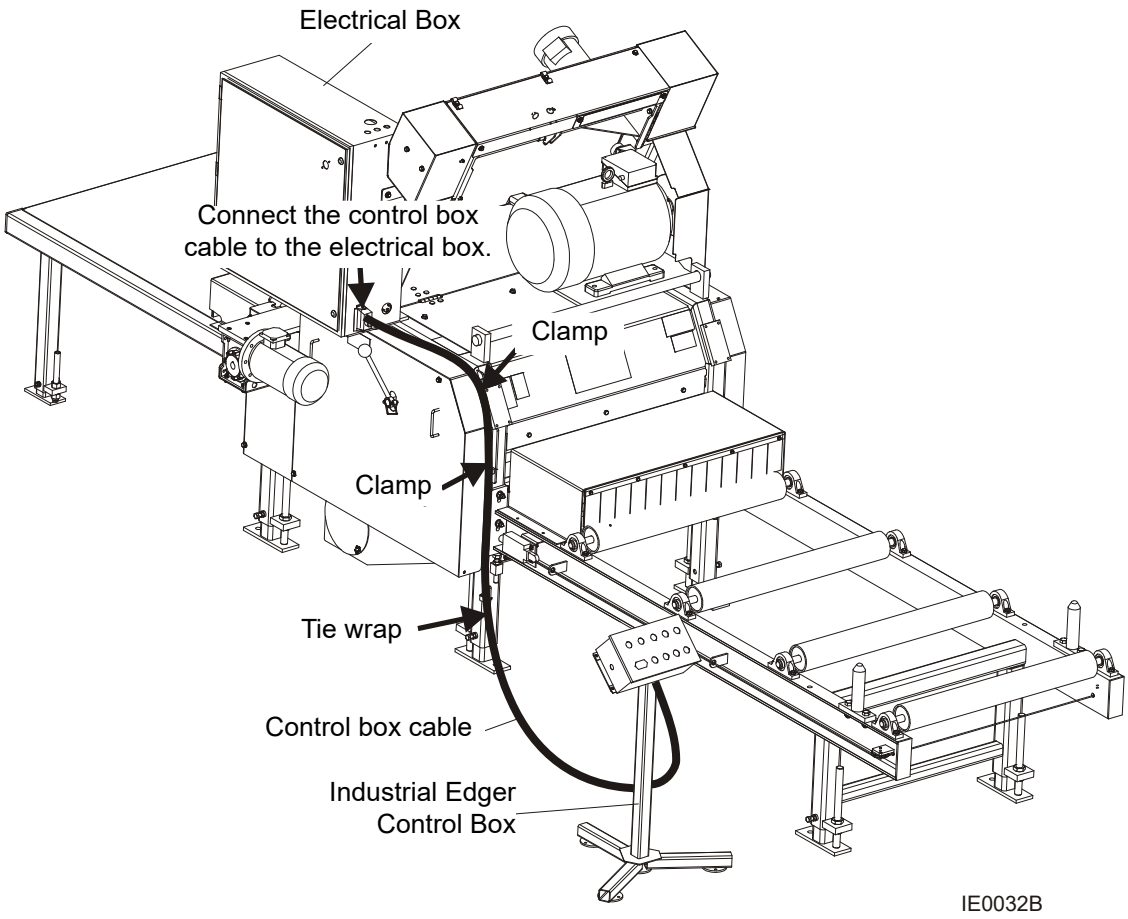


FIG. 3-6

5. Secure the control box cable with three cable clamps (3) installed to the Edger frame. Make sure that the drive side removable guard can be accessed easily if necessary.

6. Connect the existing safety switch cable from the electrical box to the safety switch located on the left side of the infeed table frame. Secure the cable with tie wraps to the control box cable.

See figure 3-7.

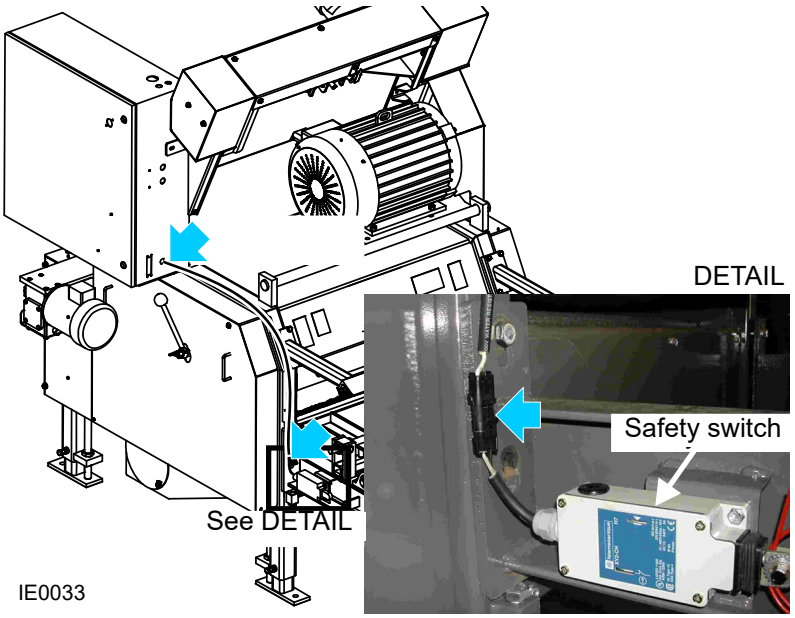


FIG. 3-7

WARNING! Always shut off the engine and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

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

3.3 Pre-Operation Check

Prior to operating the Edger; always perform these basic checks:

1. Make sure the Edger is level. Secure the edger to the ground. A concrete foundation and 16mm anchored bolts are recommended.

   CAUTION! Make sure the edger is level before operation. Failure to do so can and will affect machine operation and wear life.

2. Make sure the tables are level with the rest of the Edger. A 16mm anchored bolts are necessary to secure legs to the foundation.

3. Make sure the motor drive belt is tensioned properly. *See Section 4.3* for more information.

   WARNING! Do not for any reason adjust the engine drive belts with the engine running. Failure to do so may result in serious injury.

4. Be sure the anti-kickback fingers are in proper working condition.

   See Figure 3-8.

   WARNING! Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.

   Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to

do so may result in serious injury.

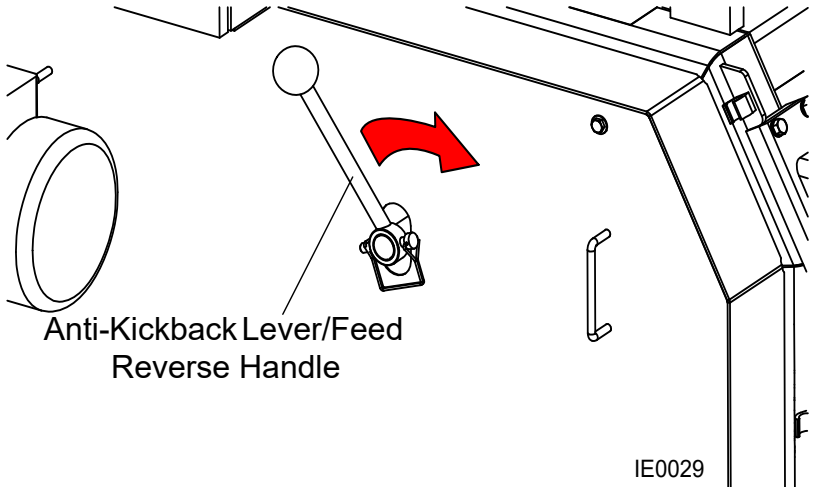


FIG. 3-8

NOTE: The feed reverse handle/anti-kickback lever lifts the anti-kickback fingers, shuts down the blades and reverses the infeed movement. Release the lever and restart the blades by pressing the START BLADES button on the control box to continue cutting.

5. Be sure all guards and covers are in place and secured.

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

6. Also be aware that the blades are spinning whenever the motor is ON. Always turn off the motor to stop the blade whenever the Edger is not in use and ensure that all parts have stopped moving before removing any covers or guards.

WARNING! Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

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

An Emergency Stop is located on the front panel of the Edger control box. Press the Emergency Stop to shut down the motor. Before operating the Edger again, turn the E-Stop switch clockwise and release.

The Edger is also equipped with one more Emergency Stop switch located on the infeed table. The switch is activated by pulling the red rope installed around the infeed table frame. Pull the rope to shut down the motor. Restart the Edger using the buttons and switches on the control box when necessary.

3.4 Starting and stopping the machine

DANGER! Make sure all guards and covers are in place and secured before operating the Edger. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure.

DANGER! Always be sure all persons are away from the edger before starting the motor. Failure to do so may result in serious injury.

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

1. If necessary, replace the machine E-Stop button by turning it clockwise until it pops out.

See figure 3-1. The main control panel has switches to start and stop edger functions.

FIG. 3-1

2. To turn the edger power on, push the green MACHIN START button on the control box.

   NOTE: The covers and electric box must be closed before the edger can be started.

3. Turn the laser guide on by turning the laser switch to the ON position.

4. Adjust the position of the blade by pushing the left or right blue (POSITION) buttons on the control box until the lasers indicate the desired position.

5. Push the BLADES-START button to start the edger blades.

6. Push the FEED-START button to start the edger feed system. **NOTE:** The edger feed system will not start unless the blades have been started first.

   The switches on the main control panel can be used to shutdown the edger.

1. Push the MACHINE-E-STOP button in an emergency to stop the feed and blades. This button must be released by turning clockwise before the edger can be restarted.

   Pull out the emergency red wire around the infeed table whenever it is necessary to shut down the Edger.

2. Push the FEED-STOP or BLADE-STOP buttons to stop the corresponding functions without shutting down the machine.

3. Turn the LASERS switch to OFF to turn off the laser guides.

3.5 Edging Lumber

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

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

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

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

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

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

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

1. Start the machine and turn the lasers on as described in *Section 3.4 Starting and stopping the machine*.

2. Place the board on the infeed table. Use the provided pivot posts to assist loading if necessary.

   See Figure 3-1.

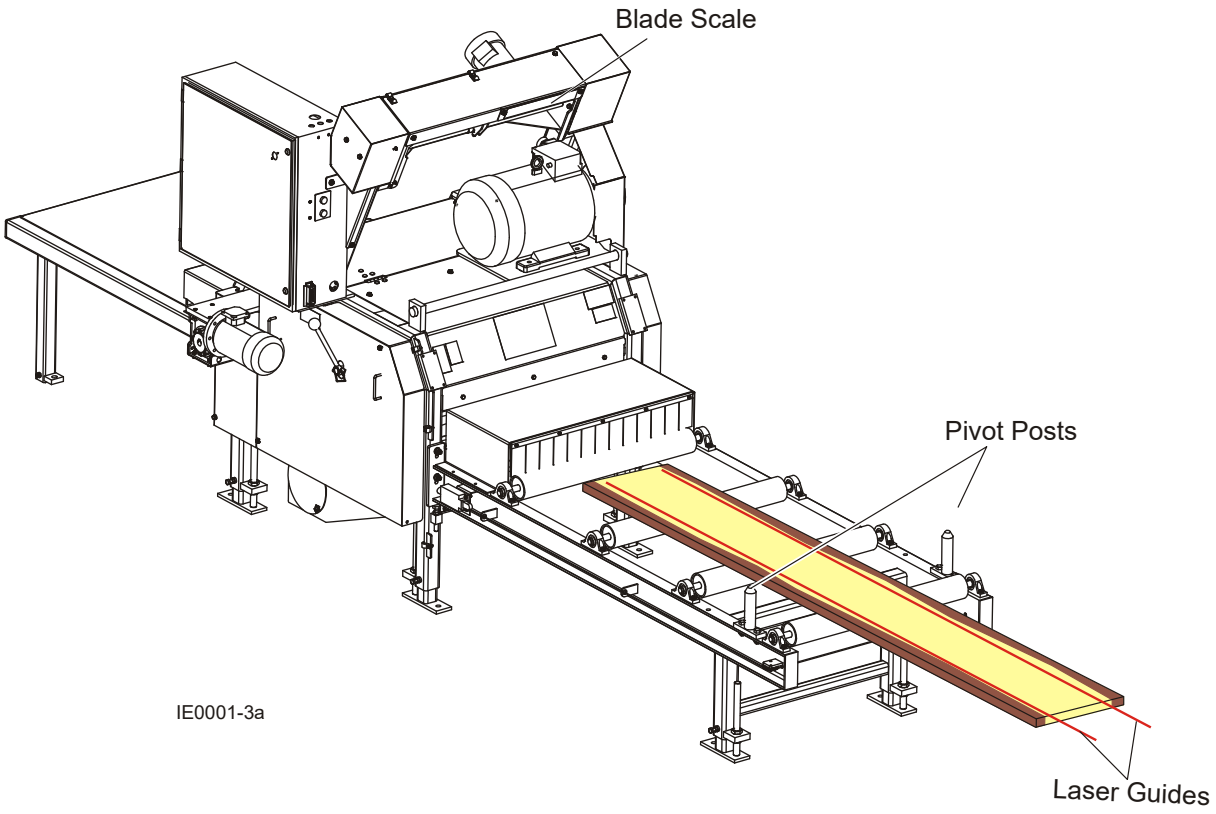


FIG. 3-1

3. Place the board in the approximate center of the table.

4. Use the blade adjustment button on the control panel to move the blades as desired. Use the scale at the top of the edger to determine the width of cut. Again, the lasers show the path of the blades.

5. Start the blade motors and the feed motor. Push the board into the edger until the feed system takes the board.

6. Repeat the above procedures for all boards to be edged.

7. Shutdown the machine when done edging.

3.6 Setworks Operation

Setworks option allows the operator to quickly and easily set the distance between the blades by selecting one of the board width values programmed at the factory. Each value can be modified and saved by the operator. The figure in the first line on the display indicates the current distance between the blades. The operator can at any time change the distance between the blades "manually", using the blue blade adjustment buttons. Pressing either of the blade adjustment buttons disables Setworks and enables manual adjustment of the blades. Selecting the board width memory again will activate the Setworks and the distance between the blades will be automatically adjusted.

NOTE: During cutting operation, the distance between the blades cannot be changed either manuallyt or automatically.

BOARD WIDTH PROGRAMMING

Six board width dimensions can be programmed using the six MEM buttons located on the Setworks control panel (MEM1 through MEM6). They can be modified with the UP or DOWN arrow buttons. For example, in order to reprogram the MEM1 dimension, first press the MEM1 button and hold it for about 3 seconds. Then use the UP or DOWN arrows to scroll to the desired setting (pressing the arrow button once changes the dimension by 1 mm; to scroll faster, hold the arrow button for about 2.5 seconds). To store the new setting and exit the settings menu, press and hold the memory button for 3 seconds. Once the button is released, the Setworks will automatically set the blades as desired.

NOTE: If more than one dimension was reprogrammed, there is no need to save each dimension separately. Pressing any of the memory buttons for 3 seconds stores all reprogrammed dimensions.

NOTE: The operator cannot program the board width dimensions beyond the maximum and minimum board width limits set at the factory. These limits cannot be changed by the operator.

See figure 3-2. The picture below shows the Setworks control panel.

FIG. 3-2

BYPASS MODE

After pressing the BYPASS button, the machine works in manual mode (without the Setworks option). The distance between the blades is set "manually", using the blue blade adjustment buttons (blade movement is continuous as long as the button is engaged).

CAUTION! The blade adjustment buttons must be released before the blades reach their travel limits. Damage to the chain and the gear may result.

SETWORKS RESETTING AND ANALOG SENSOR ADJUSTMENT

1. Turn the power supply off using main disconnector located on the electric box.

2. Press simultaneously the MEM1, MEM2, MEM3 buttons and hold them. Turn on the power supply and wait until "System Reset" message will appear on the display.

3. Measure distance from the inside edge of the first blade's tooth to the inside edge of the

other blade's tooth and compare it with the dimension shown on the display (see the figure below). If the two dimensions are different, loosen the analog sensor mounting screws and move the sensor to the left or to the right until the displayed value is the same as the actual distance between the blades.

NOTE: The desired board width can only be obtained if the displayed distance is the same as the actual one.

See figure 3-3.

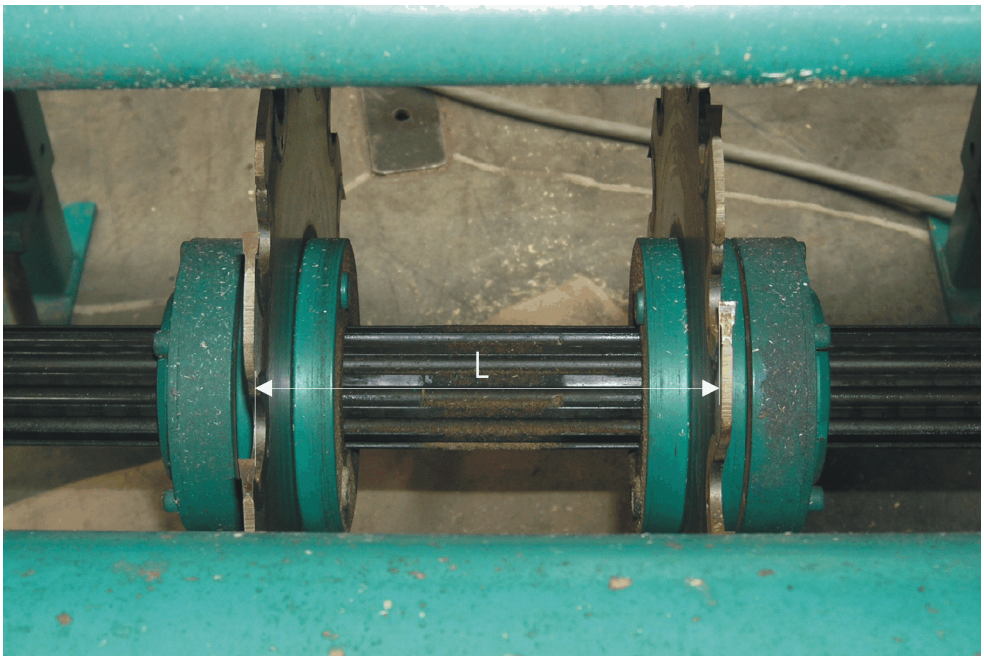


FIG. 3-3

See figure 3-4.

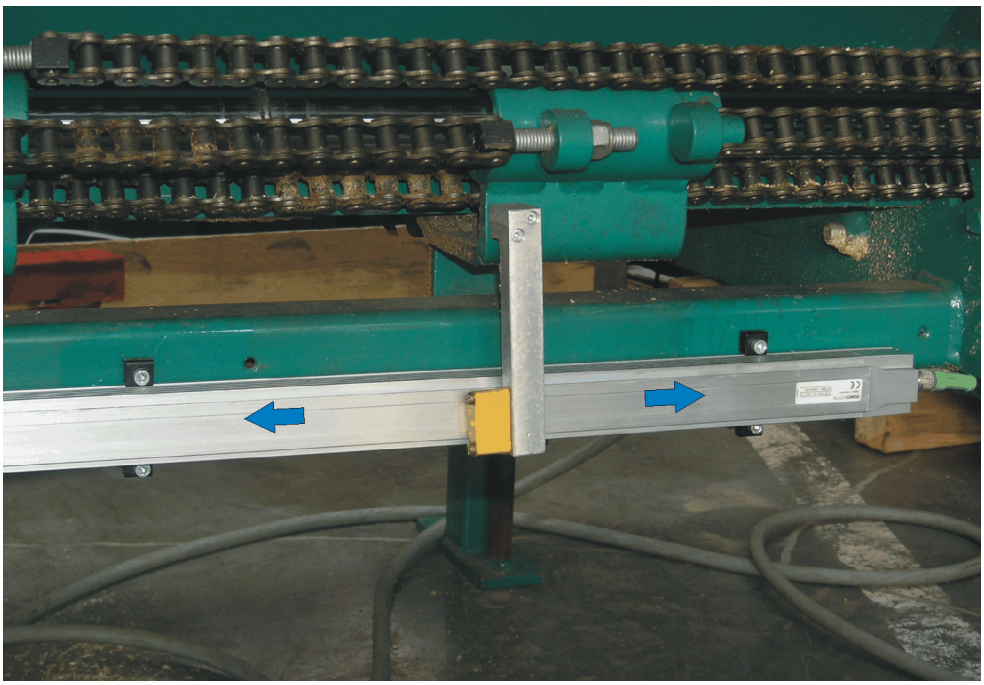


FIG. 3-4

ENTERING THE SERVICE MODE

1. Turn the power supply off using main disconnector located on the electric box.

2. Press simultaneously the MEM4, MEM5, MEM6 and down arrow buttons and hold them. Turn on the power supply and wait until "Service Mode" message will appear on the display.

SECTION 4 MAINTENANCE

Refer to the motor manufacturer's manual for maintenance intervals and procedures regarding the power supply unless otherwise instructed in this manual. Follow the manufacturer's recommendations for dusty conditions.

IMPORTANT! This manual only provides information about additional procedures or procedures to be performed at different time intervals than found in the manufacturer's manuals. Refer to the manufacturer's manual for complete maintenance instructions.

4.1 Replacing the blade teeth

DANGER! Always shut off the engine and allow all moving parts to come to a complete stop before removing any guards or covers. Failure to do so may result in serious injury.

See figure 4-1. Replace the blades teeth as necessary. Dull blades teeth will cause the motor to work harder and will result in decreased cut quality and accuracy. Blades teeth life will vary depending on maintenance of machine, operator, species of wood being sawn, and condition of wood being sawn. To remove the blades teeth perform the following steps:

- Unbolt and open the rear top blade guard. Make sure the guard is secure properly.

- Lift upper idle roller with a rod. To do so, insert the rod into the slot on the right side of the upper idle corner. Make sure the roller rests safely before starting the blade teeth replacement procedure.

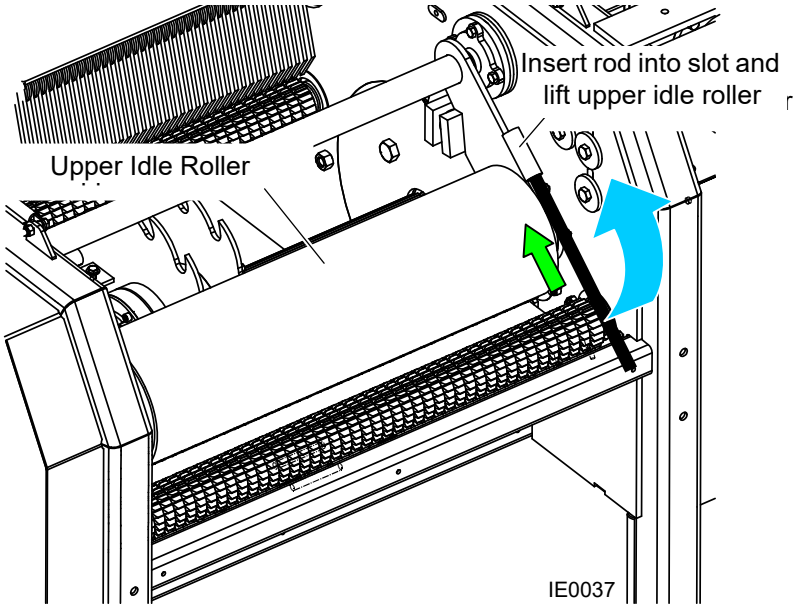


FIG. 4-1

- Put the blade teeth replacement tool to the blade tooth to be removed. Secure the replacement tool with the locking pin so that the longer end of the locking pin comes

both trough the lower hole in the replacement tool and the hole in the blade tooth.

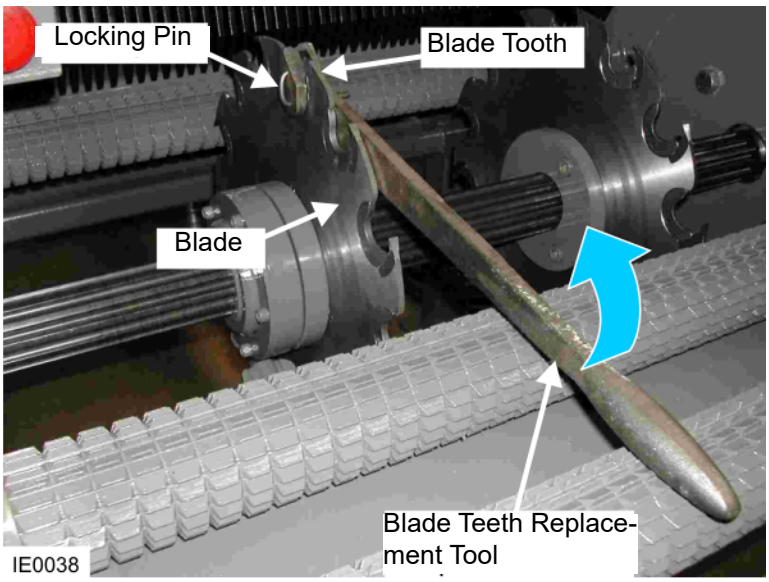


FIG. 4-2

- Remove the blade tooth by moving the replacement tool handle upwards.

To replace the blade tooth perform the following steps:

- Install the new blade tooth to the blade teeth replacement tool. Secure the blade tooth to the replacement tool with the locking pin.
- Put the replacement tool to the blade where the blade tooth is to be installed.
- Move the replacement tool downwards to install the new blade tooth in place.
- Remove the locking pin from the replacement tool when done. Remove the replacement tool from the blade.
- Repeat the procedure with the remaining blade teeth.
- Use the rod to lower the idle roller when done.
- Close the rear top blade guard. Secure the guard with the existing bolts.

4.2 Changing the Blades

1. Replace the blades if necessary. **NOTE:** It may be necessary to replace the blades only due to their damage. The blades are equipped with replaceable cutting teeth. *See Section 4.1* to replace the blade teeth.

   DANGER! Before changing the saws, make sure the blades have come to a complete stop and the motor is shut off completely. Failure to do so may result in serious injury.

   WARNING! Always wear eye, glove and foot protection when handling saw blades.

2. Unbolt and open the rear top blade guard.

3. Use a supporting strap to keep the shaft in place before removing the blade door assembly on the left side of the edger.

   See figure 4-3.

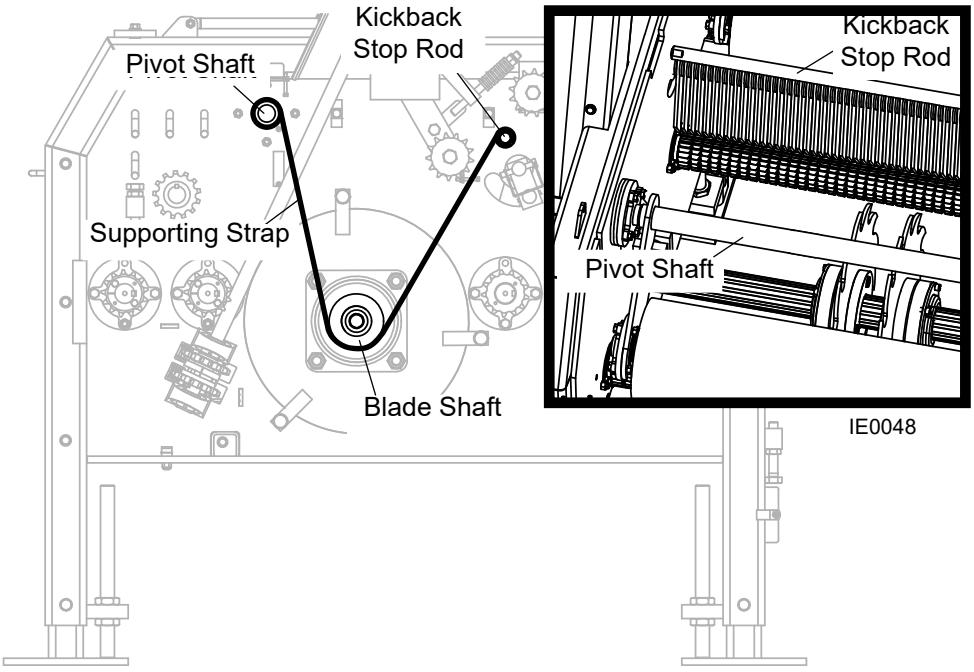


FIG. 4-3

4. Remove the locking nuts securing the right and left blade pushers to the blade. Unhitch the blade pushers from the blade.

5. Remove the feed drive side removable guard from the Edger.

6. Remove the blade door assembly from the Edger. To remove, first unbolt the blade door assembly. Loosen the retaining bolt and remove the four mounting nuts on the bearing. Pry the blade door assembly from the Edger and remove the door.

   See figure 4-4.

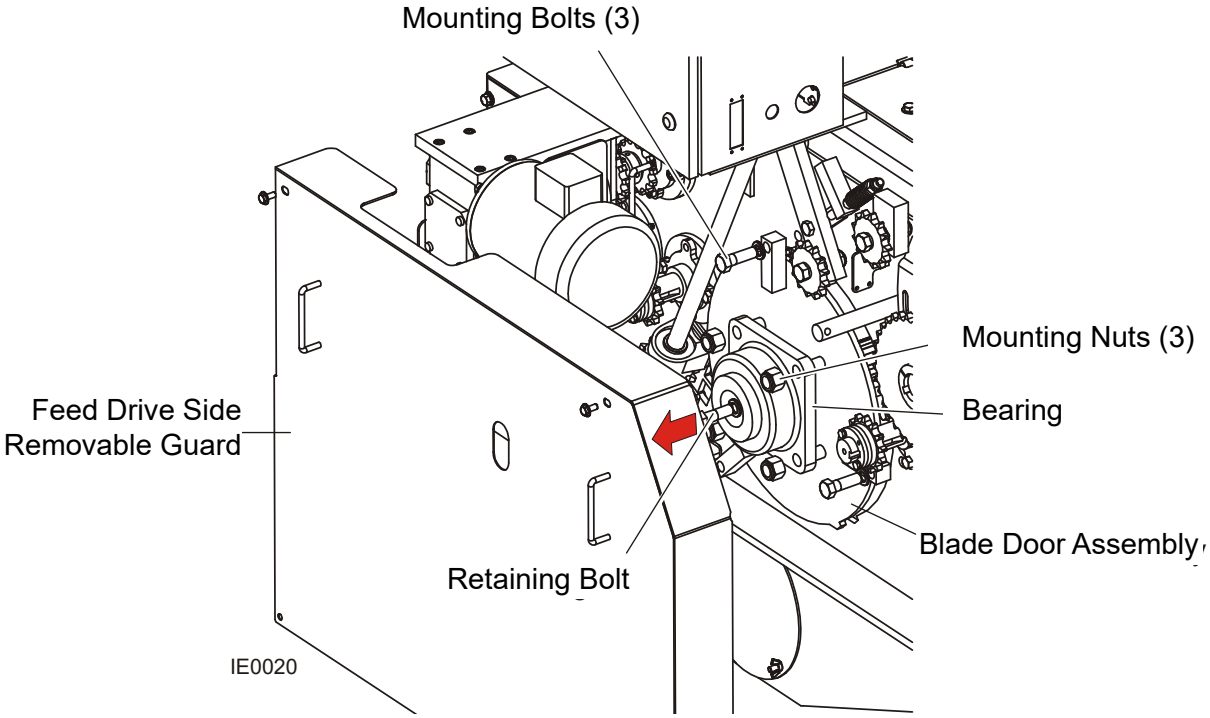


FIG. 4-4

7. Next, remove the blades from the shaft. Make sure the right and left blade pushers are unhitched from the blades and lowered.

8. Slide the blades out through the blade door hole. **NOTE:** It can be necessary to raise the shaft 2-3 inches to allow the blades to pass the blade pushers.

   See figure 4-5.

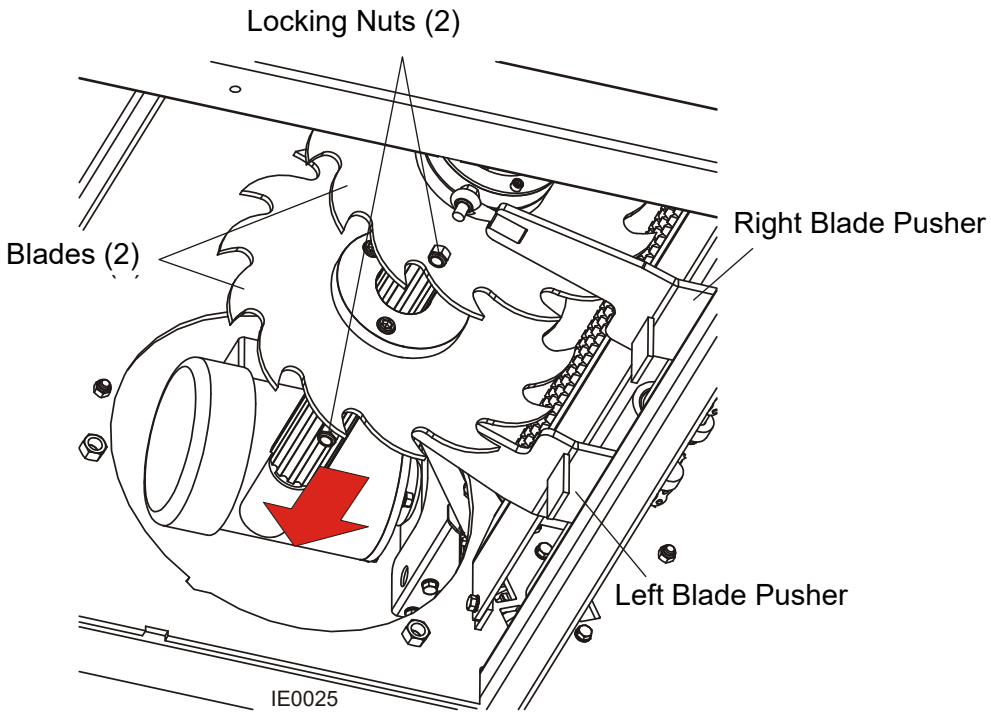


FIG. 4-5

9. Install new blades to shaft and position them next to the right and left blade pushers. Hitch the right and left blade pushers to the blades. Reinstall the blade locking nuts.

10. Reinstall the blade door assembly and secure in place with the mounting bolts.

11. Reinstall the blade bearing and retaining bolt. Secure the bearing in place with the existing mounting nuts.

12. Remove the supporting strap.

13. Close and secure the rear, top blade guard.

4.3 Tensioning the Belts

DANGER! Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Failure to do so may result in serious injury.

WARNING! Do not for any reason adjust the engine drive belts with the machine running. Failure to do so may result in serious injury.

NOTE! Never apply belt dressing as this will damage the belt and cause early failure.

8 **1.** Check the drive belt for wear every 8 hours of operation and more frequently during the first 24-48 hours of operation. Tension or replace as necessary. Tension should be 1/2" deflection with 9 lbs of force for new belts or 1/2" deflection with 6 lbs of force for used belts.

See figure 4-6. To tension the drive belt:

- Unbolt and open the blade drive side removable guard.
- Loosen the motor mounting nut securing the adjustment nut.
- Use the adjustment bolt as shown below to move the motor mount up or down until the belt is properly tensioned.

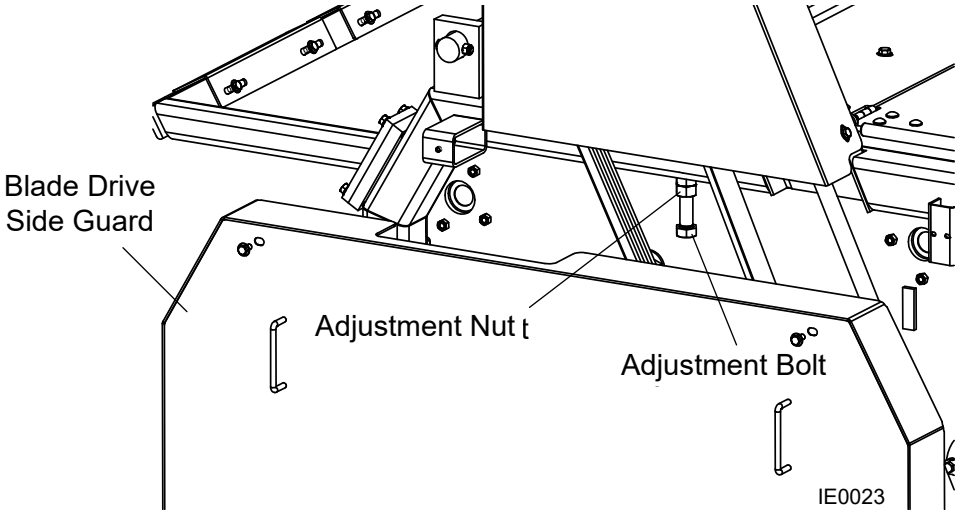


FIG. 4-6

NOTE! Do not over tighten the drive belt as it can cause premature belt and/or bearing failure.

NOTE! Do not under-tighten the drive belt as it can cause one or all of the following damages: slippage of the belt on the drive pulley, binding or fetching up of the saws while in the cut, damage or bending of saws.

- Retighten the motor mounting nuts when done.
- Close and secure the blade drive side removable guard.

2. Check the laser light box timing belt for wear every 8 hours of operation. Tension or replace if necessary. The belt tensioner should be adjusted closely enough to remove any belt slack. Do not overtighten.

See figure 4-7. To tension the laser light box belt:

- Locate the adjustment pulley in the laser light box. Loosen the mounting nut securing the adjustment pulley.
- Push the adjustment pulley up or down until the belt is tensioned as needed.

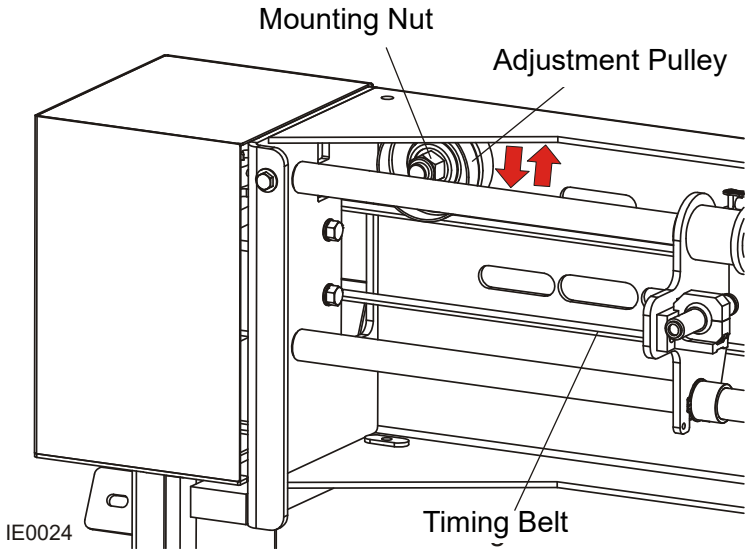


FIG. 4-7

- Retighten the adjustment nut to secure the adjustment pulley when done.

4.4 Tensioning the chains

IMPORTANT: It is necessary to tension the outfeed drive chain first before tensioning the infeed drive chain.

See figure 4-8. Refert to the following diagram for chains routing instructions.

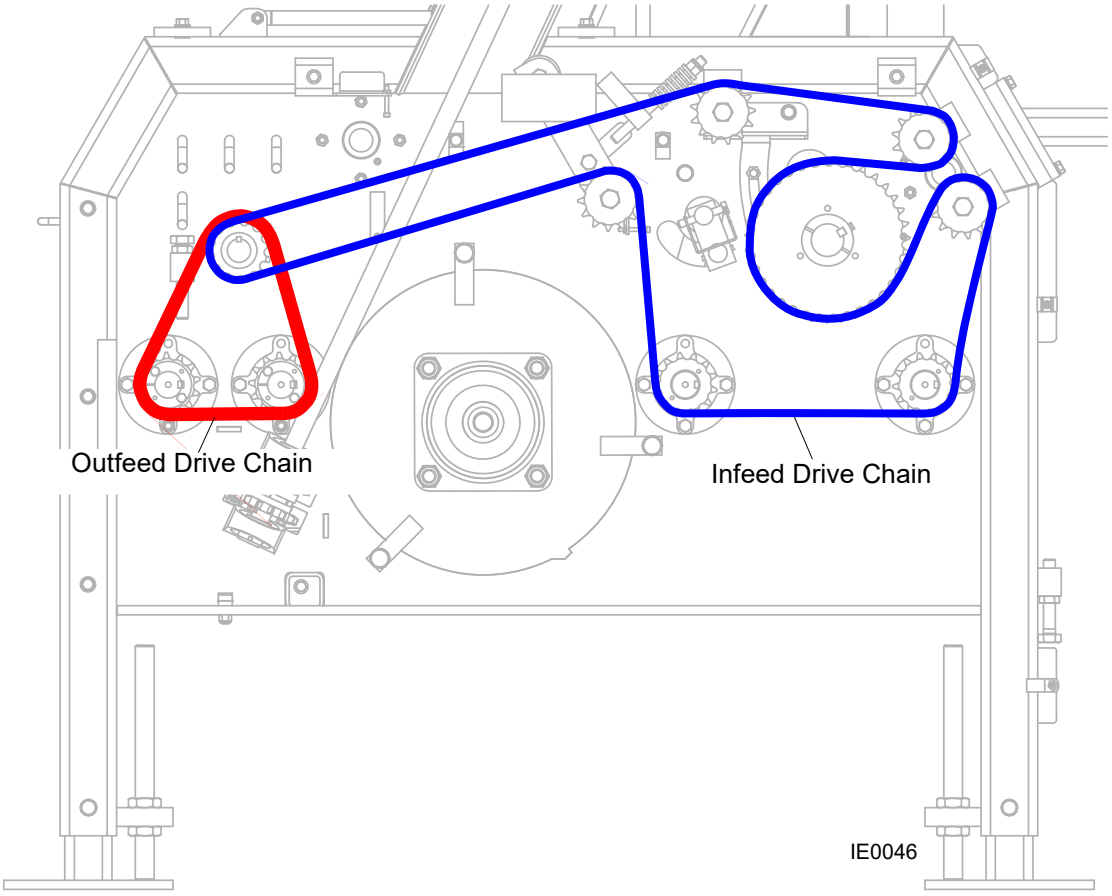


FIG. 4-8

See figure 4-9. To tension the outfeed drive chain:

- Unbolt and open the feed side fixed guard.
- Loosen the four bolts securing the edger feed drive assembly to the edger frame.
- Rotate the adjustment bolt below the edger feed drive assembly clockwise/counter-clockwise until the outfeed drive chain is tensioned as needed. The outfeed chain total deflection should not exceed 1/4" in the center of the chain between the sprockets.

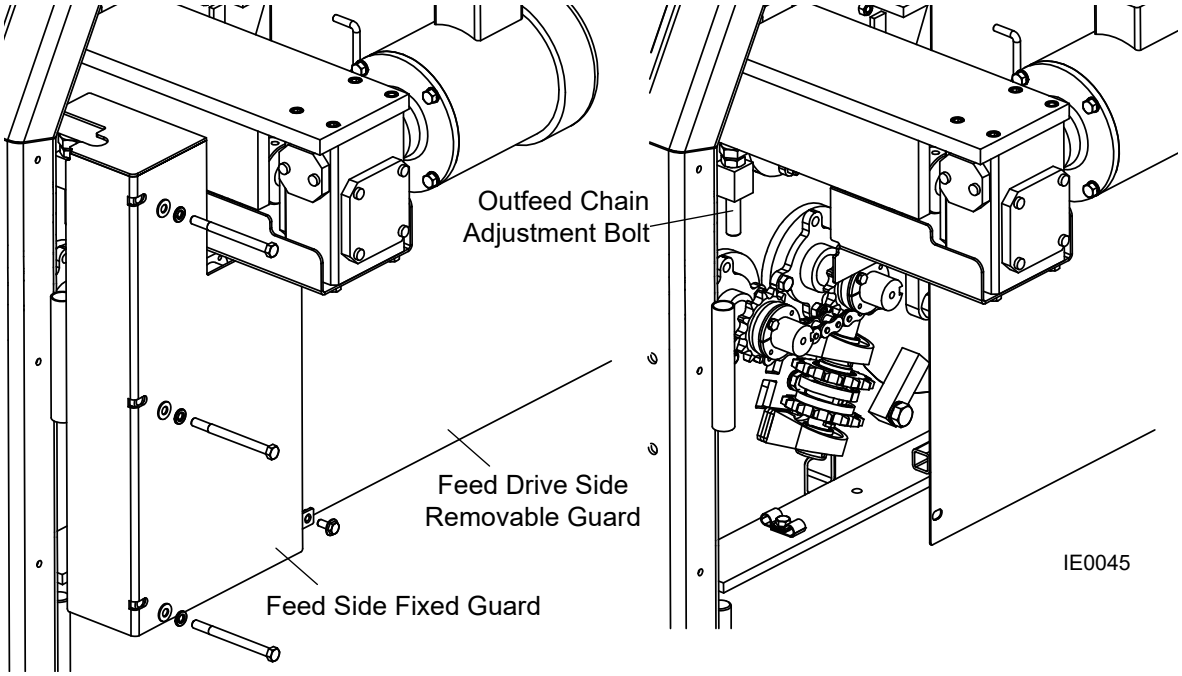


FIG. 4-9

- Tighten the four bolts mounting the edger feed drive assembly to the edger frame.
- Close and secure the feed side fixed guard.

See figure 4-10. To tension the infeed drive chain, unbolt and open the feed drive side removable guard.

- Use the adjustment nut on the drive chain tensioner until the drive chain is tensioned as needed. The total deflection of the spring should be from 3/8" to 1/2".

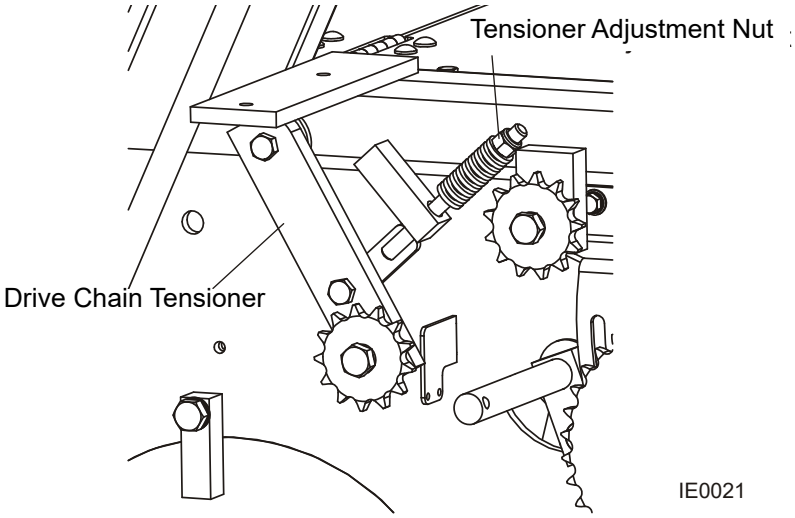


FIG. 4-10

- Close and secure the feed drive side removable guard when done.

40

Check the laser drive chains for tension every 40 hours of operation. Tension as necessary. Remove the chain slack but do not overtighten. The properly adjusted chain should have 1/4" to 3/8" vertical deflection when applying 6 to 8 pounds of force.

See figure 4-11. To tension the laser drive chain, use two adjustment nuts at the rear of each laser assembly until the chain is tensioned as needed.

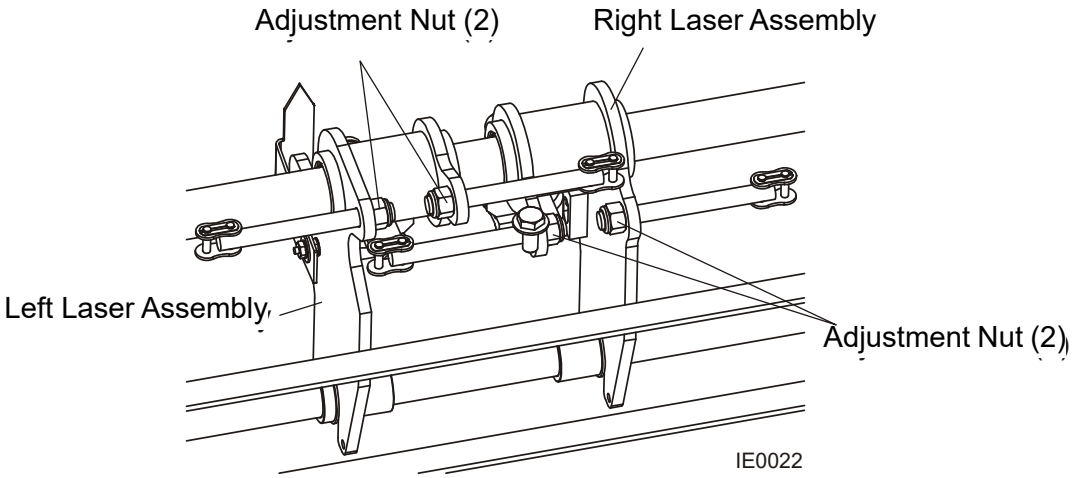


FIG. 4-11

4.5 Checking the rollers

8 **1.** Check the feed rollers every 8 hours of operation. Remove any dirt or debris from the rollers. Make sure they spin freely, without much play.

4.6 Lubrication

8 **1.** Use a soft cloth to clean any debris from the blade drive shaft and every 8 hours of operation.

200 **2.** Lubricate the blade shaft bearings every 200 hours of operation with one to two pumps of lithium-based grease such as Shell Alvania No. 3. 3. Do not overgrease.

200 **3.** Lubricate the roller bearings every 200 hours of operation with a high-quality lithium-based grease such as Shell Alvania No. 3. 3

4.7 Feed Rate

See Table 4-1. The feed rate can be adjusted. There are three possible feed rates depending on the board thickness. The factory setting is shown below.

Actual Board Thickness	Average Feed Rate (ft./min.)
up to 1.5"	165
1.5"-4"	115
4"	100

TABLE 4-1

The feed rate can be readjusted by changing the position of two proximity switches located under the feed drive side removable guard.

See figure 4-12. To change the position of the proximity switch, remove the anti-kickback lever and feed drive side removable guard from the edger.

- Loosen the nuts securing the proximity switches to the mount bracket.

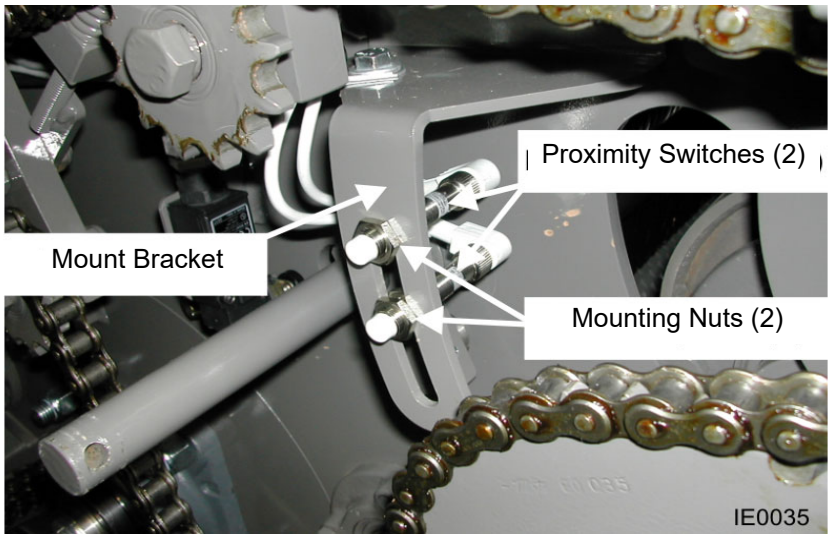


FIG. 4-12

- Move the proximity switches to a desired position.
- Tighten the nuts on the proximity switches and secure in place.
- Reinstall the feed drive side removable guard and anti-kickback lever to the edger.

4.8 Maintaining and sharpening anti-kickback fingers

This machine has the potential for kick-backs. Kick-backs can cause the board to be suddenly and uncontrollably hurled towards the operator. Such action can result in severe injury or death.

During working with frozen boards or with boards that have protruding knots, the chance of kickbacks is increased.

The infeed opening of the Industrial Edger is equipped with anti-kickback fingers to help prevent kickback from occurrng. To maintain the safety of your Edger, periodically inspect the machine to ensure all anti-kickback fingers are intact and undamaged and have a sharp point. Missing or damaged parts can affect the safety of the machine operator or bystanders and should be replaced immediately. Dulled parts should be re-ground with a hand grinder or replaced.

DANGER! Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.

Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to do so may result in serious injury.

4.9 Laser guide alignment

WARNING! Always shut off the engine and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

WARNING! Visible and/or invisible laser radiation. Avoid eye or skin exposure to direct or scattered radiation.

WARNING! No exchange with a different type of laser is permitted, and no additional optical equipment shall be used.

DANGER! Operator can not for any reason perform any laser maintenance or repair work. Repair shall only be carried out by the laser manufacturer or authorised persons.

1. Open the blade housing cover to access the edger blades.

2. Run a straight edge from the front of the edger frame to the back. Put the straight edge next to the blade and make sure it is parallel to the blade.

See figure 4-13.

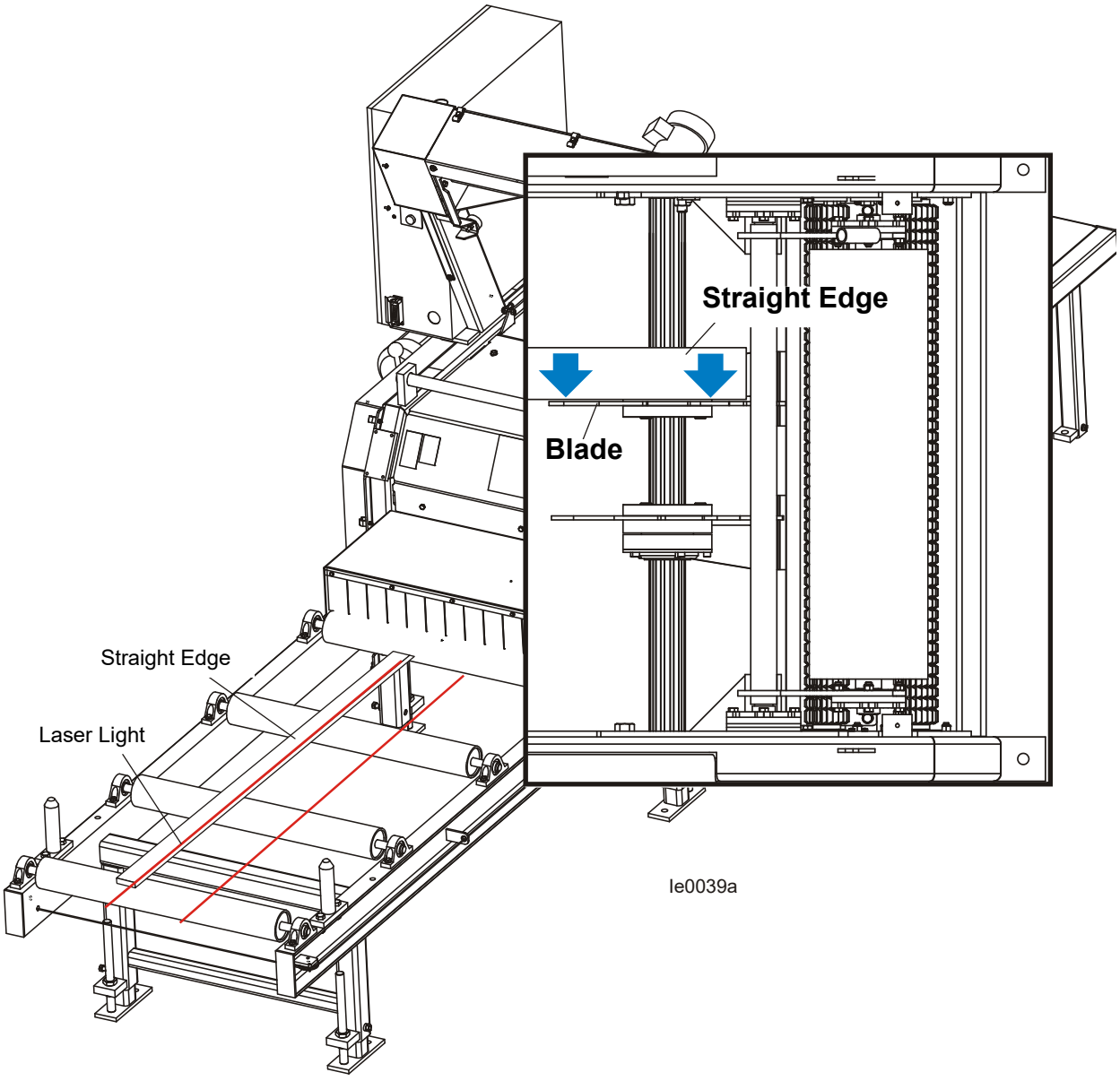


FIG 4-13

3. Turn on the edger and check the position of the laser lights on the straight edge. Adjust the laser guides if necessary. Read below for laser adjustment procedures.

4. To move the laser up or down, loosen the nut on the slotted screw securing the laser to the guide assembly.

5. Move the rear part of the laser guide assembly up or down to put the laser light closer or further away from the edger main frame.

See figure 4-14.

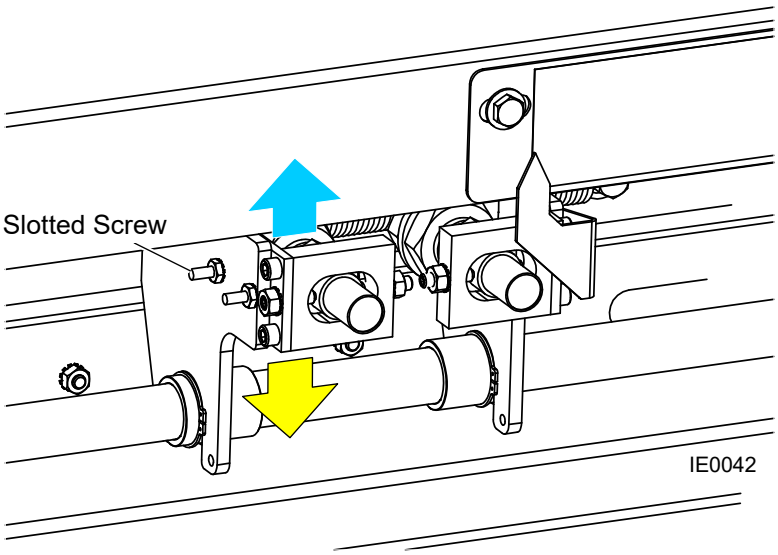


FIG 4-14

6. Make sure the laser light lays down on the fence scale.

7. Tighten the nut on the slotted screw when finished.

8. To move the laser light right or left, loosen two screws located on both sides of the laser guide. Tighten the left set screw to move the laser guide to the left side; tighten the right set screw to move the laser guide to the right side.

See figure 4-15.

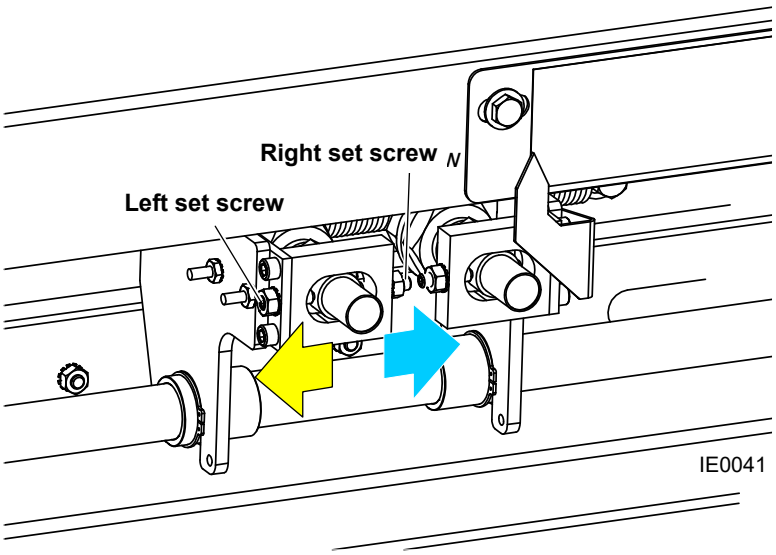


FIG 4-15

9. Check if the laser light is parallel to the straight edge.

10. Secure both set screws in place when finished.

11. To move the laser light when slanted, use the laser guide adjustment nut on the laser guide assembly. Turn the adjustment nut clockwise to move the laser light as shown below and check the laser light position. Turn the adjustment nut counterclockwise to move the laser light to the opposite directions as shown below and check the laser light position.. Make sure the laser light is parallel to the straight edge.

See figure 4-16.

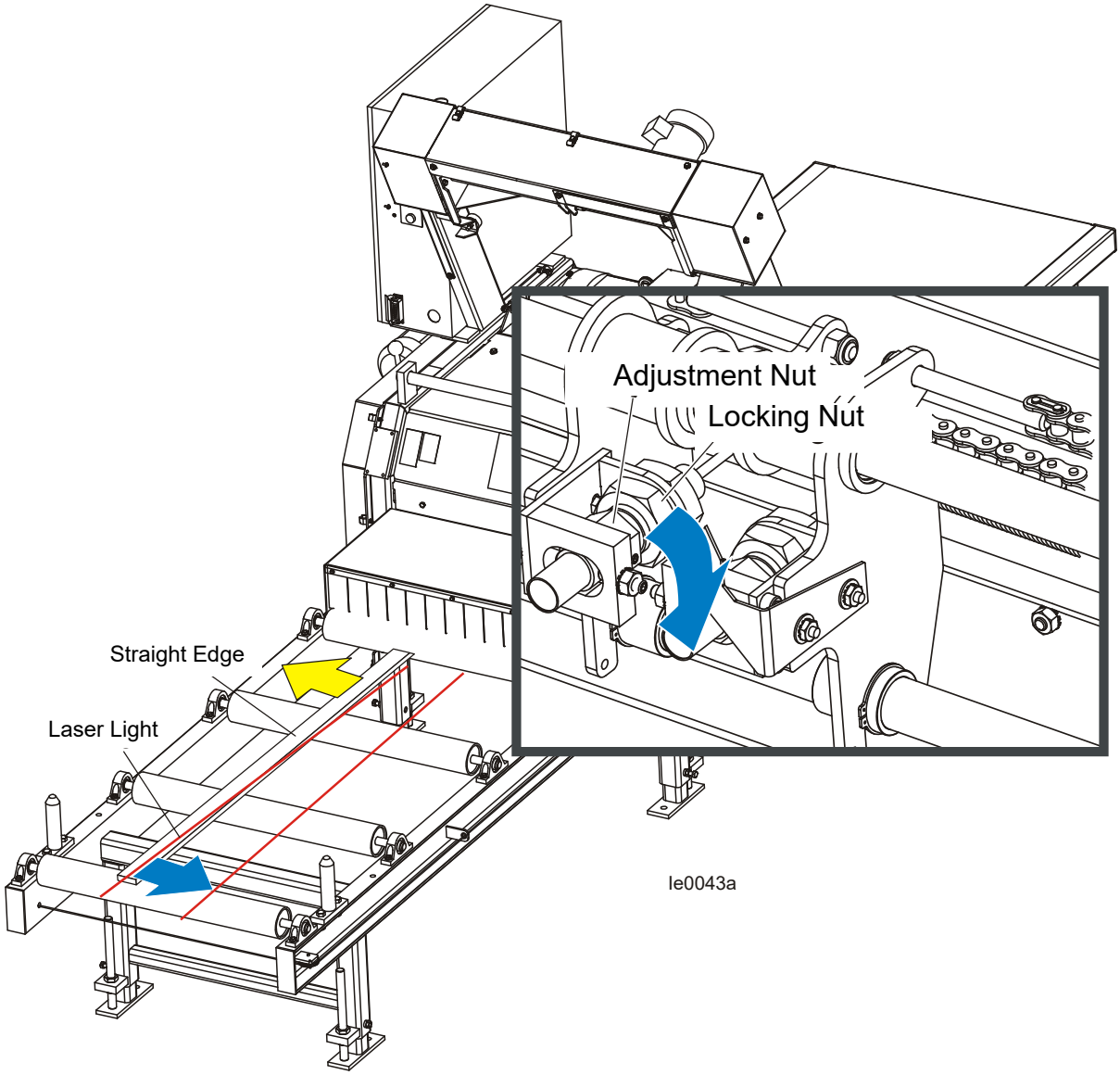


FIG 4-16

12. Repeat the steps above to align the other laser guide assembly if necessary.

SECTION 5 REPLACEMENT PARTS

5.1 How To Use The Parts List

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

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

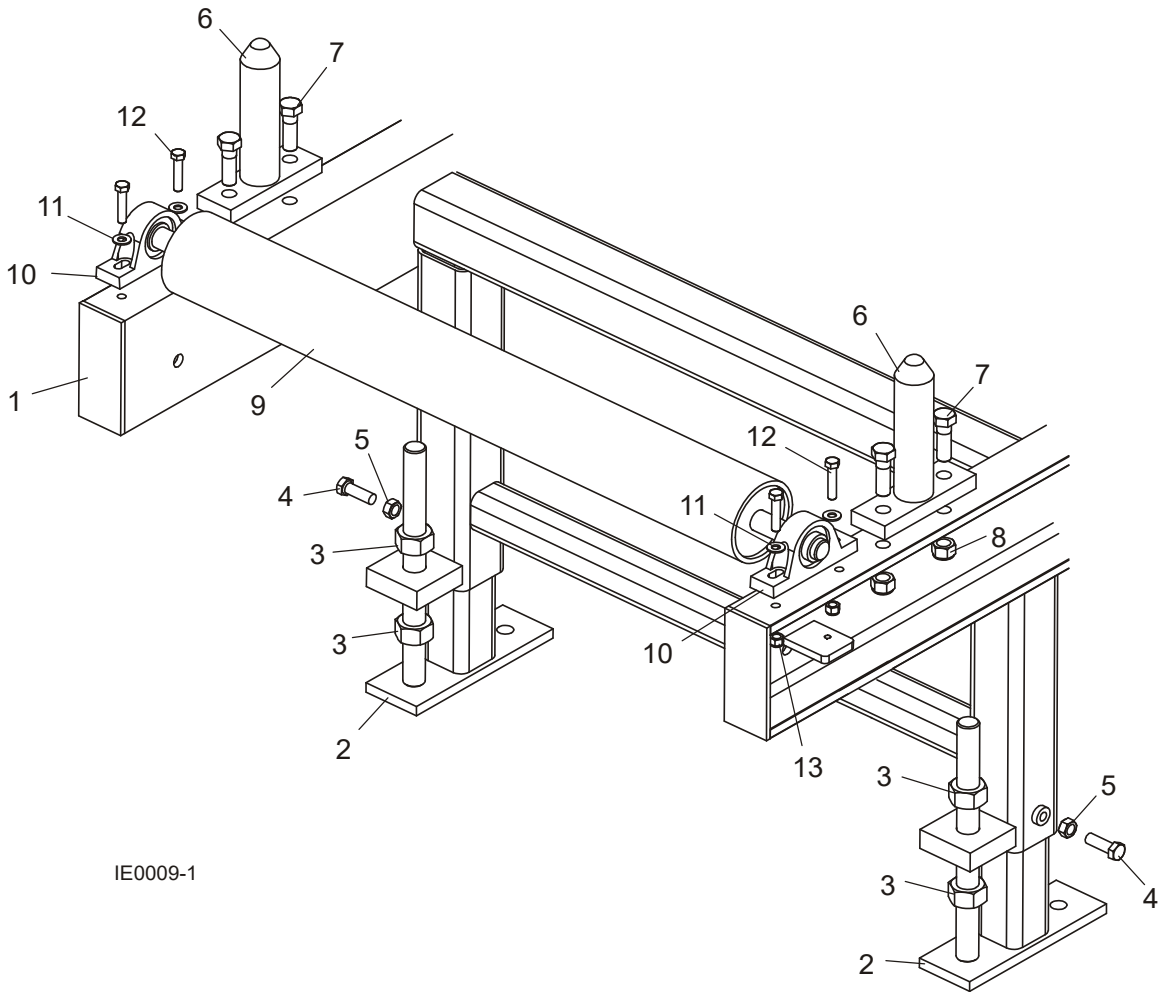
5.2 Sample Assembly

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SAMPLE ASSEMBLY, COMPLETE (Includes All Indented Parts Below)	A01111	1	
1	Sample Part	F02222-22	1	
2	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
	Sample Part (Indicates Part Is Only Available With A03333)	S04444-4	1	◆
3	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
	Sample Part (Indicates Part Is Only Available With K05555)	M06666	2	◆
4	Sample Part	F07777-77	1	

To Order Parts:

From the continental U.S., call ***1-800-448-7881*** to order parts. Have your customer number, VIN, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.

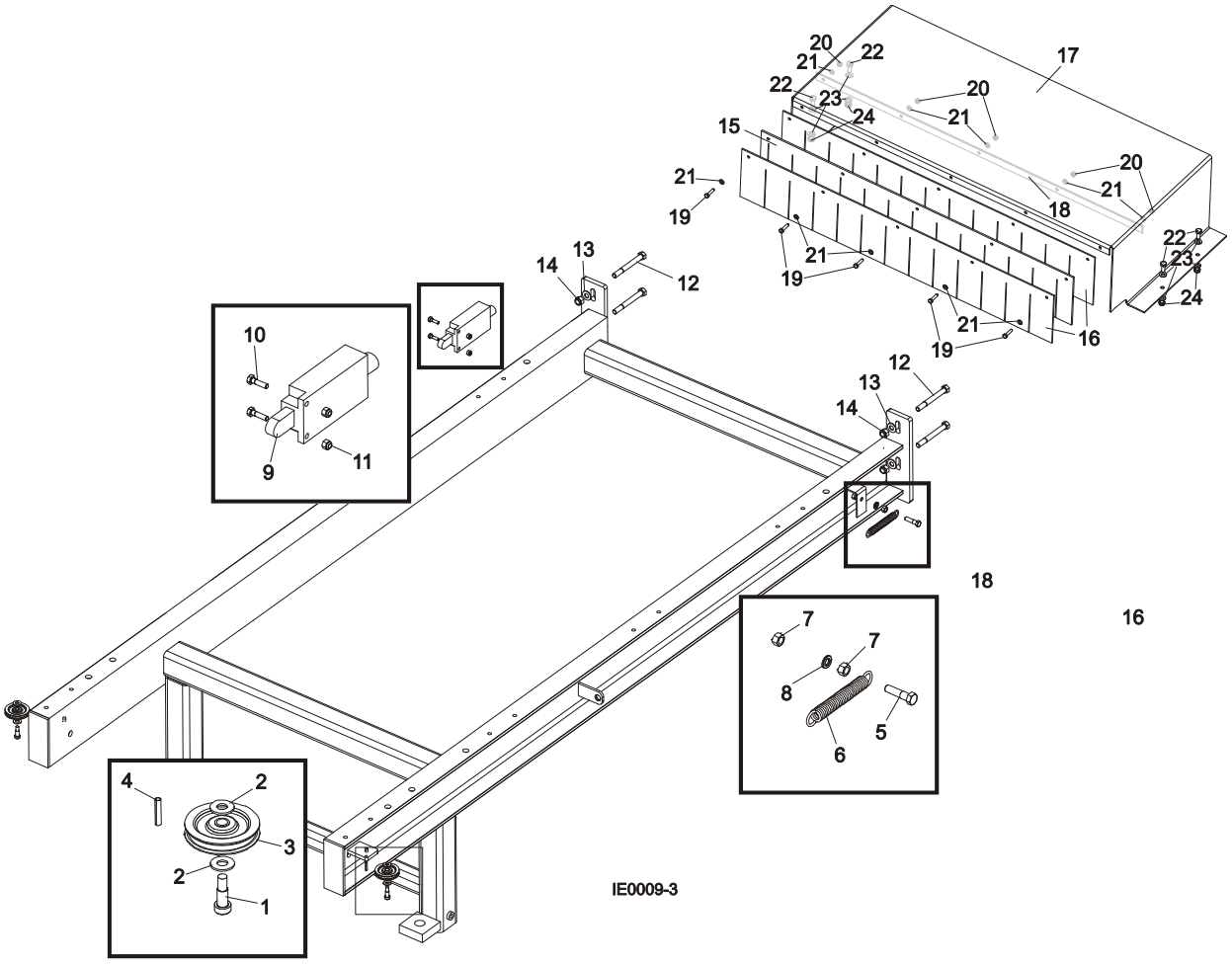
5.3 Infeed Table Rollers & Legs



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**FRAME WELDMENT, INFEED**	*039133*	1	
	FOOT ASSEMBLY, EDGER	*039143*	2	
2	Foot Weldment, Edger	*039115*	2	
3	Nut, 1-14 Hex Jam Zinc	*F05010-118*	4	
4	**BOLT, 1/2-13X1 1/2 HEX HEAD GR5**	*F05008-33*	2	
5	**NUT, 1/2-13 FREE HEX, ZINC**	*F05010-35*	2	
6	**SHAFT WELDMENT, BOARD PIVOT**	*039118*	2	
7	**BOLT, 5/8-11X2 HEX HD GR2, ZINC**	*F05009-2*	4	
8	**NUT, 5/8-11 NYLON LOCK**	*F05010-34*	4	
	ROLLER ASSEMBLY, INFEED	*039140*	1	
9	Roller Weldment, Infeed	*039122*	4	

10	Bearing, 1 Pillow Block SS Lock	*039141*	8	
11	Bolt, 3/8-16X1 1/2 Hex Head Gr5, Zinc	*F05007-78*	16	
12	Washer, 3/8 Flat	*F05011-3*	16	
13	Nut, 3/8-16 Swaged	*F05010-25*	16	

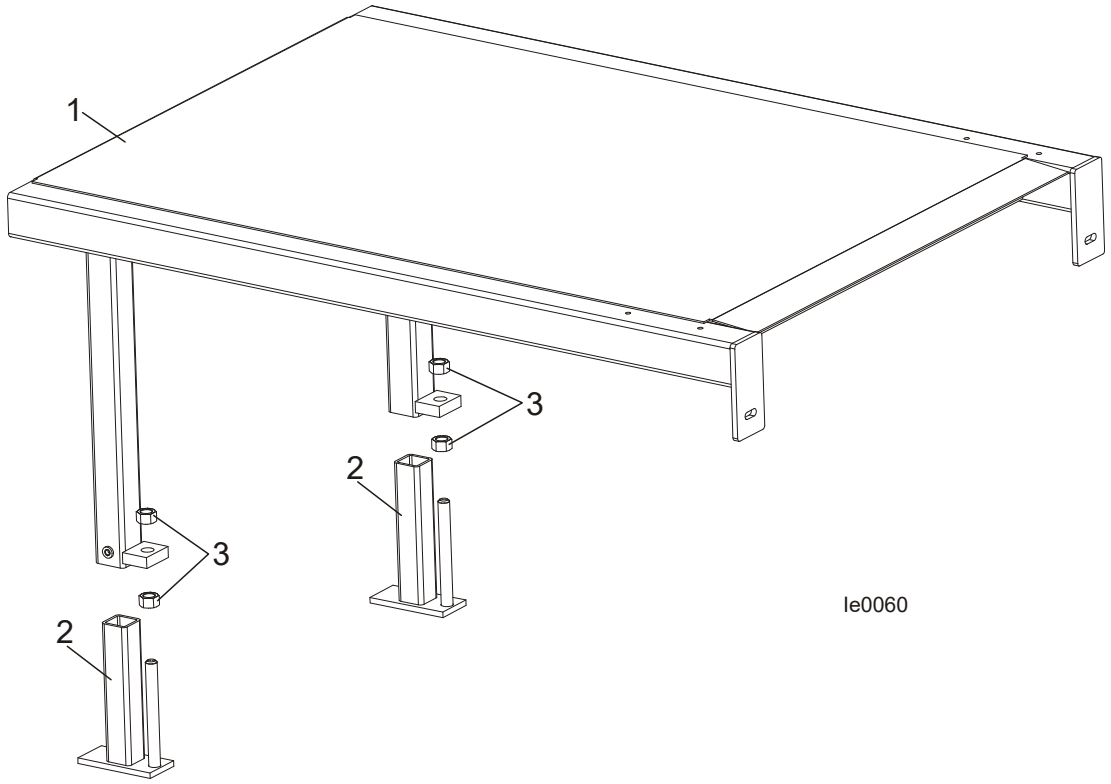
5.4 Infeed Table



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BOLT, 3/8 X 5/8 SHOULDER, ZINC	F05007-79	2	
2	WASHER, 3/8 FLAT	F05011-3	4	
3	PULLEY, 2 1/2 NYLON	P07996	2	
4	PIN, 3/16 X 1 ZINC ROLL	F05012-11	2	
5	BOLT, 3/8-16X1 1/2 HH GR5, ZNC	F05007-78	1	
6	SPRING, 3/4 X 2 7/8 X 12 GA	015479	1	
7	NUT, 3/8-16 HEX	F05010-1	2	
8	WASHER, 3/8 SPLIT	F05011-4	1	
9	SWITCH ASSEMBLY, PERIMETER SAFETY	090994	1	
10	BOLT, 1/4-20 X 1 HEX HEAD GR5	F05005-101	2	
11	NUT, 1/4 NYLON	F05010-69	2	
12	BOLT, 1/2-13 X 4 1/2 GR5 HEX HEAD	F05008-35	4	
13	WASHER, 1/2 SAE FLAT	F05011-2	4	
14	NUT, 1/2-13 NYLON HEX LOCK	F05010-8	4	

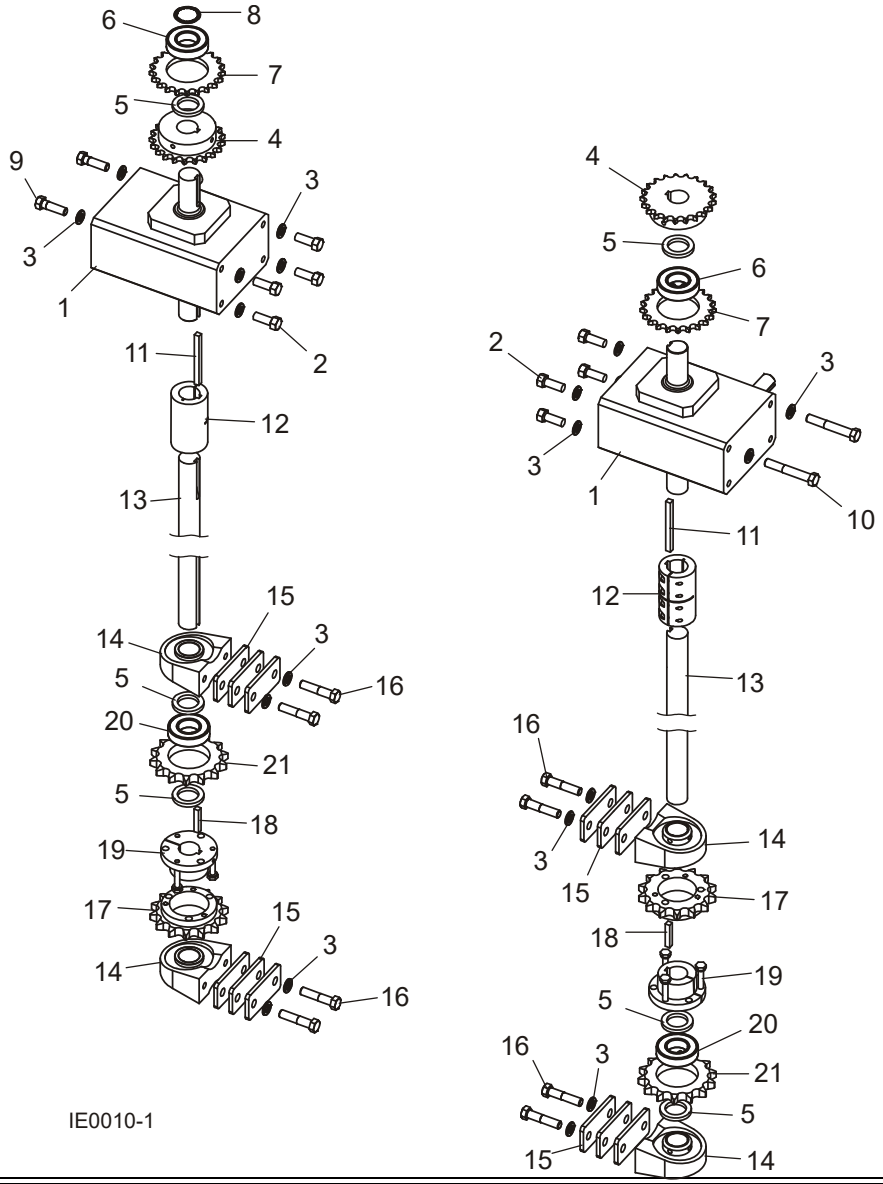
	FRONT COVER-COMPLETE	*095176*	1	-
	REAR COVER-COMPLETE	*095460*	-	1
15	EDGER BOARDS INSERT THERMOPLASTIC CURTAIN 1	*094871*	1	1
16	EDGER BOARDS INSERT THERMOPLASTIC CURTAIN 2	*094872*	2	2
17	FRONT COVER	*095177-1*	1	-
	REAR COVER	*095461-1*	-	1
18	EDGER CURTAIN MOUNTING STRIP	*095178-1*	1	1
19	BOLT, M6X25MM,HEX HEAD,GR 8.8,ZINC	*F81001-3*	5	5
20	NUT, M6, HEXAGON,FREE, GRADE 5(8.8)ZINC	*F81031-1*	5	5
21	WASHER, M6, FLAT,ZINC	*F81053-1*	10	10
22	BOLT, M8x20mm,HH,GR 8.8,FULL THRD,ZINC	*F81002-1*	4	4
23	WASHER, 8.4 FLAT,ZINC	*F81054-1*	8	8
24	NUT,M8-8-B,HEX,NYLON LOCK ZINC	*F81032-2*	4	4

5.5 Outfeed Table



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**TABLE, EG400S OUTFEED**	095452-1	1	
2	**FOOT, EG400S OUTFEED TABLE**	095458-1	2	
3	**NUT, M20-8 HEX HEAD ZINC**	F81037-1	4	

5.6 Blade and Laser Drives

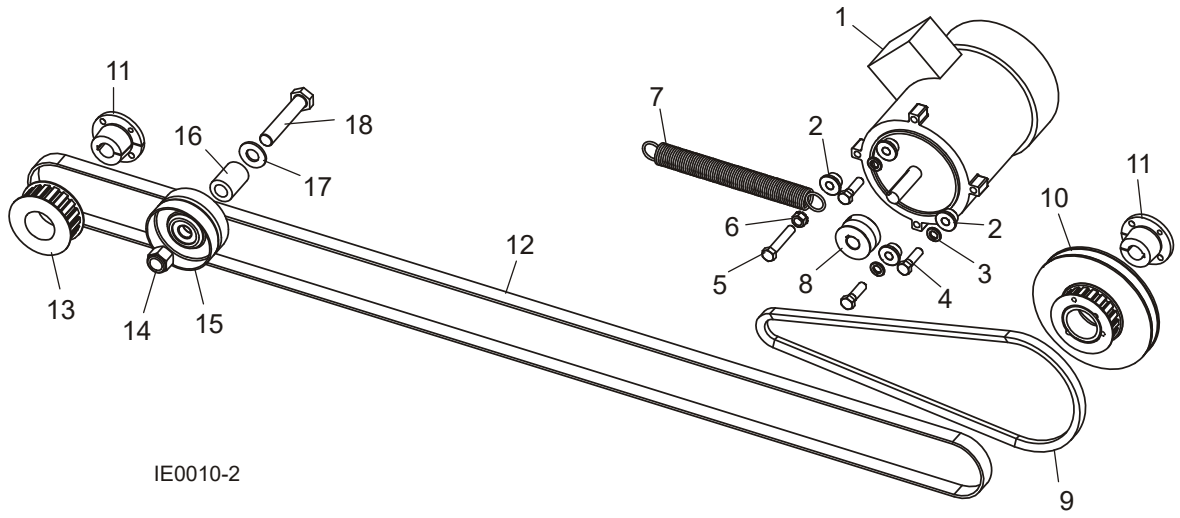


IE0010-1

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**GEARBOX, IO60-60:1-RL**	*039203*	2	
2	**BOLT, 3/8-16X1 HEX HEAD**	*F05007-7*	8	
3	**WASHER, 3/8 SPLIT**	*F05011-4*	20	
4	**SPROCKET, 40B21 X 1**	*039197*	2	
5	**SPACER, 1 1/64 ID X1 1/2 OD X 3/16**	*039250*	6	
	SPROCKET ASSEMBLY, 4021 IDLER	*039201*	2	
6	Bearing, R16 Sealed	*042360*	2	
7	Sprocket, 40A21 Bored	*039199*	2	

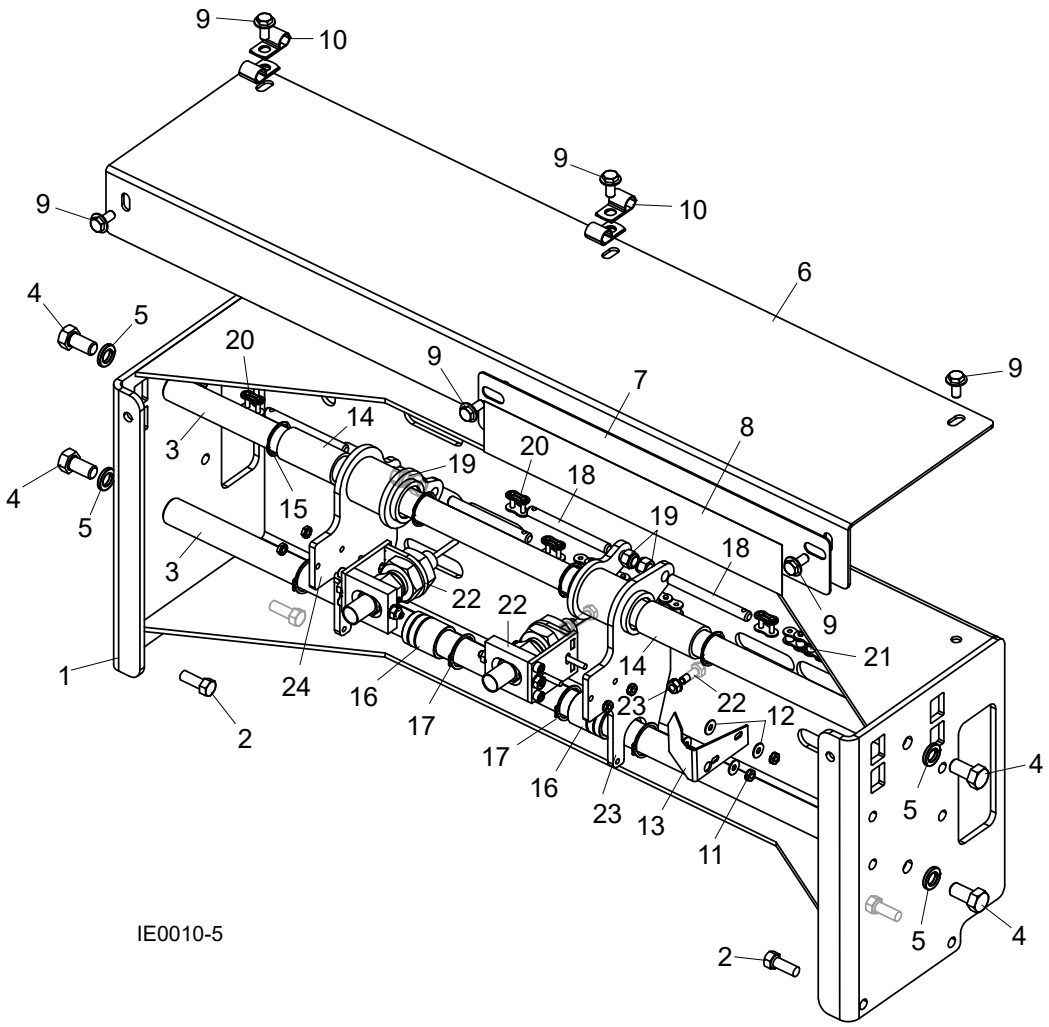
8	**RING, 1 DIA PUSH NUT 5115-100**	*F04254-40*	1	
9	**BOLT, 3/8-16X 1 1/4 HEX HEAD GR5**	*F05007-123*	2	
10	**BOLT, 3/8-16 X 2 1/2 HEX HEAD GR5**	*F05007-125*	2	
11	**KEY, 1/4 X 1 11/16**	*S04124*	4	
12	**COUPLER, 1 IN CLAMP STYLE**	*039193*	2	
13	**SHAFT, BLADE DRIVE**	*039208*	2	
14	**BEARING, MTBS-216**	*039204*	4	
15	**PLATE, BEARING RISER**	*039205*	12	
16	**BOLT, 3/8-16 UNF-2A X 1-3/4 GR5**	*F05007-119*	8	
17	**SPROCKET, H60SH14**	*039195*	2	
18	**KEY, 1/4SQ X 1 3/8**	*017832*	2	
19	**BUSHING, SH X 1**	*039202*	2	
	SPROCKET ASSEMBLY, 6014 IDLER	*039200*	2	
20	Bearing, R16 Sealed	*042360*	2	
21	Sprocket, 60A14 Bored	*039198*	2	

5.7 Laser Drive Motor



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	MOTOR, LINCOLN 1/2HP 1725RPM	039274	1	
2	BOSS, MOTOR MOUNT	039182	4	
3	WASHER, 3/8 SPLIT	F05011-4	3	
4	BOLT, 3/8-16 X 1 HEX HEAD GR5	F05007-87	3	
5	BOLT, 3/8-16 X 2 HEX HEAD FT	F05007-16	1	
6	NUT, 3/8-16 KEPS	F05010-19	1	
7	SPRING, 1 OD X .105 X 9 EXT.	039303	1	
8	SHEAVE, 1 3/4 FEED MOTOR	015135	1	
9	BELT, 4L390	039276	1	
10	SPROCKET/SHEAVE ASSEMBLY, BLADE IN/OUT	039326	1	
11	BUSHING, H 3/4	039323	2	
12	BELT, TIMING 1/2 PITCH 200 T 3/4 WIDE	039320	1	
13	SPROCKET, TIMING 1/2 PITCH 18T 1 WIDE	039321	1	
14	NUT, 5/8-18 NYLON ZINC LOCK	F05010-71	1	
15	PULLEY, 3-1/4 OD IDLER	041701	1	
16	TUBE, SPACER 41/64 X 1 1/8 X 1 17/32	039348	1	
17	WASHER, 5/8 SAE FLAT	F05011-5	1	
18	BOLT, 5/8-18 X 3 1/4 HEX HEAD GR 5	F05009-98	1	

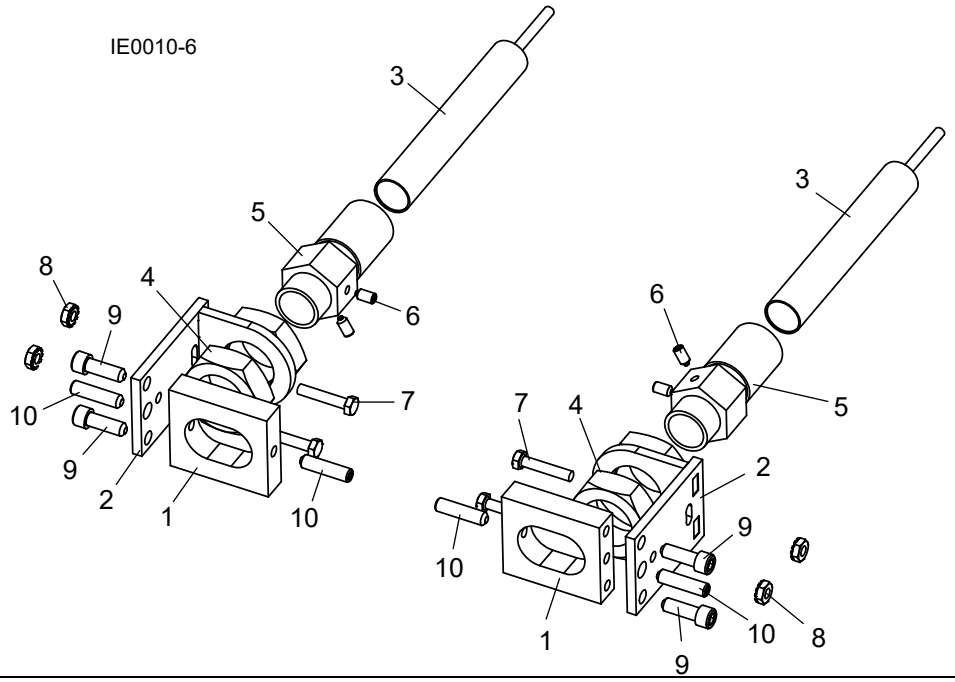
5.8 Laser Guides Housing



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BOX WELDMENT, LASER GUIDE	039185	1	
2	BOLT, 3/8-16 X 1 HEX HEAD	F05007-7	4	
3	ROD, LASER SLIDE	039206	2	
4	BOLT, 1/2-13X1 HEX HEAD	F05008-50	4	
5	WASHER, 1/2 SPLIT LOCK	F05011-9	4	
6	COVER WELDMENT, LASER BOX TOP	039360	1	
7	PLATE, BLADE SCALE MOUNT	039361	1	
8	DECAL, BLADE SCALE (4-28)	039356	1	
9	BOLT, 5/16-18 X 3/4 HEX HEAD W/WASHER	F05006-101	6	
10	CLAMP, 1/2 EMT COATED	P07584	4	
11	NUT, #10-24 KEPS	F05010-14	2	

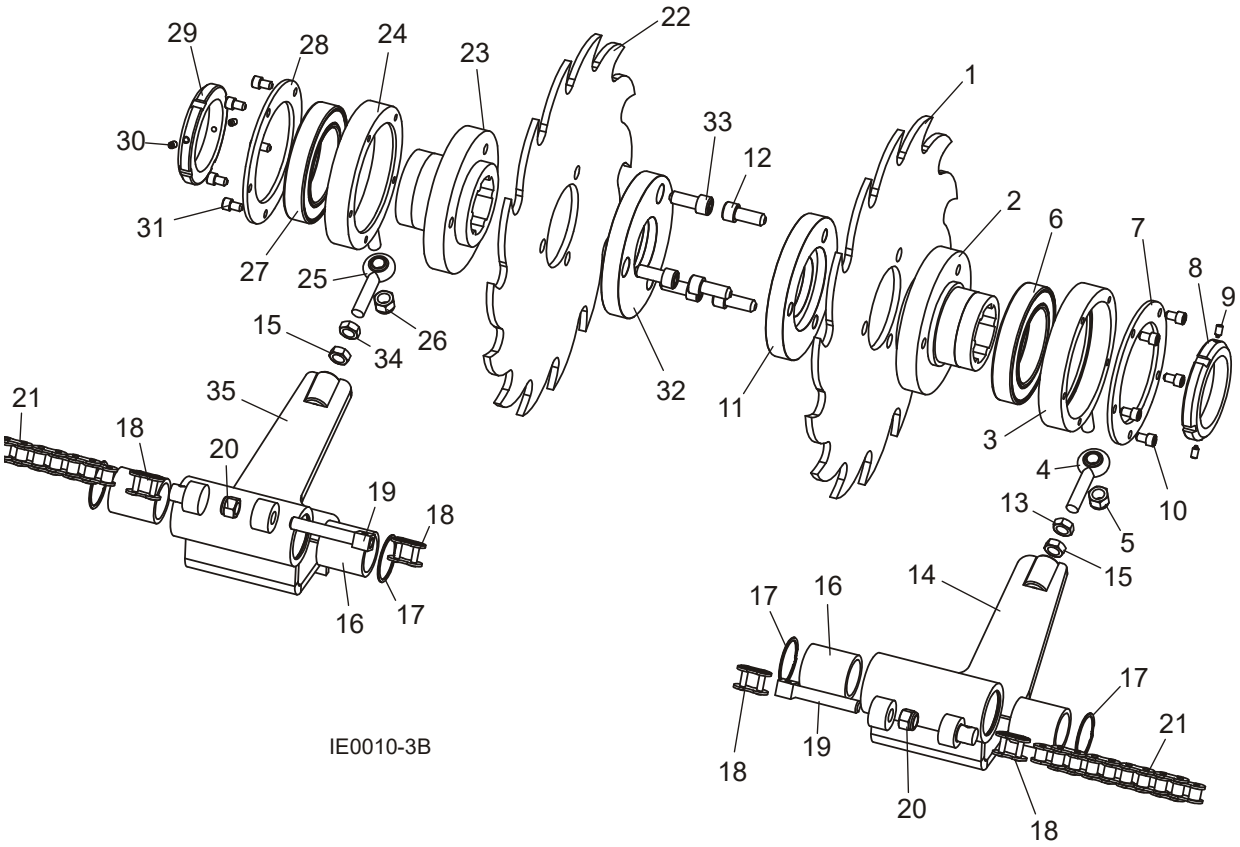
12	WASHER, #10 SAE FLAT	F05011-18	4	
13	POINTER, BLADE SCALE	039359	1	
14	BUSHING, 1 X 1 1/4 X 2 1/2 BRONZE	039254	2	
15	RING, 1 1/4 SPIRAL RETAINING	F04254-42	4	
16	BUSHING, 1 X 1 1/4 X 1 1/2 W/GROOVES	039253	2	
17	RING, 1 1/4 EXTERNAL 5100-125	F04254-43	4	
18	ROD, 40 CHAIN TENSIONER	039192	4	
19	NUT, 3/8-16 HEX NYLON LOCK	F05010-10	4	
20	LINK, #40 MASTER	P04200	4	
21	CHAIN, #40 X 83 1/2	039333	2	
22	LASER ASSEMBLY, EG400 (See Section 5.9)			
23	GUIDE WELDMENT, LASER LEFT	039183	1	
24	GUIDE WELDMENT, LASER RIGHT	039184	1	

5.9 Laser Guides



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	LASER ASSEMBLY, EG400	*039376*	2	
1	Block, Laser Adjust	*039375*	2	
2	Mount Weldment, EG400 Laser	*039374*	2	
3	Laser, 60 Deg, 15MW Line	*039377*	2	
4	Nut, 1-14 Hex Jam ZC	*F05010-118*	2	
5	Sleeve, Laser Mount	*039371*	2	
6	Screw, #10-32 x 3/8 Socket Head Set, Nylon	*F05004-208*	4	
7	Bolt, #10-24 x 1 Unslotted Hex Head	*F05004-156*	4	
8	Nut, #10-24 Keps	*F05010-14*	4	
9	Screw, 1/4-20 x 3/4 BO Socket Head	*F05005-26*	4	
10	Screw, 1/4-20x3/4 SH CP Nyl Lock	*F05005-94*	4	
	LASER, CUTTING POINTER - GREEN (OPTIONAL)	500634	1	
	LASER, Z5M18B-F-532-IG90 LINEAR (GREEN BEAM)	501025	2	

5.10 Blades Assembly



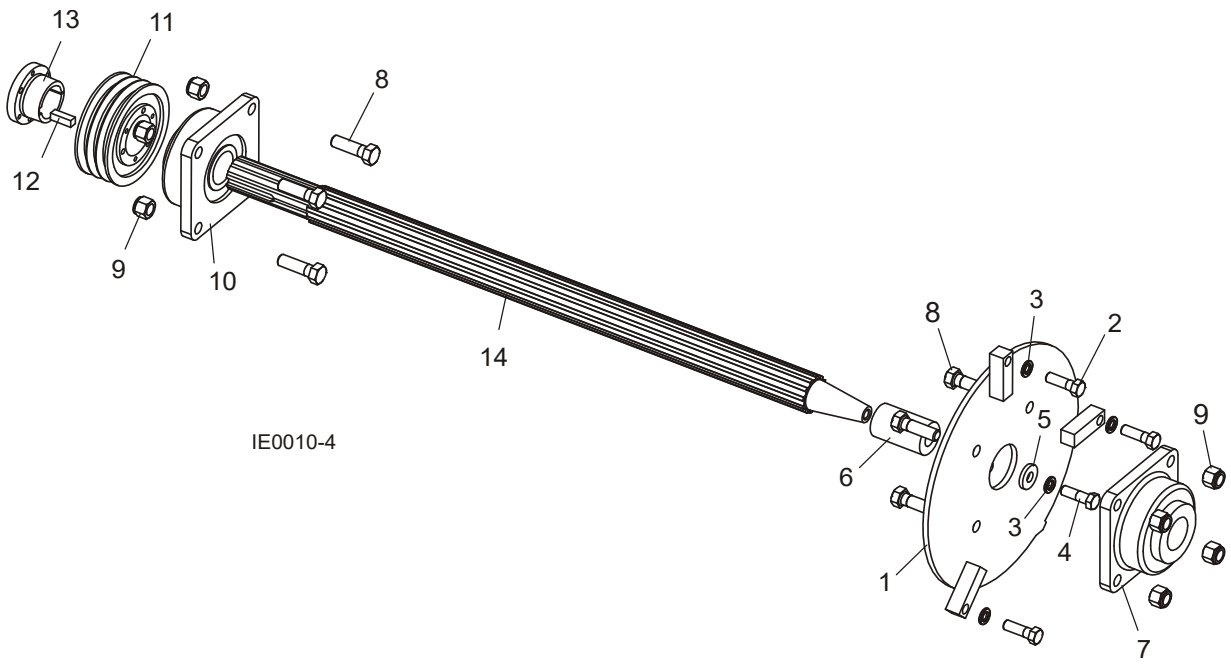
IE0010-3B

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	COLLAR ASSEMBLY, BLADE	*039327* [1]	1	
1	Blade, 16" Dia. x 14 Tooth Edger	*039234*	1	
	Blade, 16" Dia. x 14 Tooth Edger w/Carbide Tip Inserts	*039234-CT*	1	
	Shank, Edger Blade Insert	*048337*	14	
	Insert, High Speed Steel Edger Blade Tooth	*048338*	14	
	Insert, Carbide Tip Edger Blade Tooth	*048339*	14	
2	Collar, Industrial Edger Blade	*039127*	1	
3	Collar Weldment, Bearing	*039235*	1	
4	Rod End, 1/2" Male	*P09137*	1	
5	Nut, 1/2-13 Nylon Hex Lock	*F05010-8*	1	
6	Bearing, 6016-2RS	*039233*	1	
7	Plate, Bearing Retaining	*039012*	1	
	Nut Assembly, Arbor w/Set Screws	*036650*	1	
8	Nut, AN16	039129	1	◆
9	Screw, 1/4-20 x 1/2" Nylon Tip Set	*F05005-166*	2	

10	Bolt, 5/16-18 x 1/2" Socket Head	*F05006-39*	5	
11	Ring, Industrial Edger Blade Lock	*039128*	1	
12	Bolt, 1/2-13 x 1 1/4" Socket Head	*F05008-38*	3	
13	Nut, 1/2-20 Hex Jam	*F05010-16*	1	
14	**PUSHER WELDMENT, LEFT BLADE**	*039237*	1	
15	**NUT, 1/2-20 HEX JAM**	*F05010-16*	2	
16	**BUSHING, 1 7/8" OD X 1 1/2" ID X 2" BRONZE**	*039251*	4	
17	**RING, 1 7/8" SPIRAL RETAINING**	*F04254-41*	4	
18	**LINK, #60 CL**	*042398*	4	
19	**ROD ASSEMBLY, CHAIN TENSIONER**	*039191*	2	
20	**NUT, 1/2-13 NYLON HEX LOCK**	*F05010-8*	2	
	CHAIN, #60 X 84 3/4"	*039370*	2	
21	**COLLAR ASSEMBLY, BLADE**	*039239* [1]	1	
22	Blade, 16" Dia. x 14 Tooth Edger	*039234*	1	
	Blade, 16" Dia. x 14 Tooth Edger w/Carbide Tip Inserts	*039234-CT*	1	
	Shank, Edger Blade Insert	*048337*	14	
	Insert, High Speed Steel Edger Blade Tooth	*048338*	14	
	Insert, Carbide Tip Edger Blade Tooth	*048339*	14	
23	Collar, Industrial Edger Blade	*039127*	1	
24	Collar Weldment, Bearing	*039235*	1	
25	Rod End, 1/2" Male	*P09137*	1	
26	Nut, 1/2-13 Nylon Hex Lock	*F05010-8*	1	
27	Bearing, 6016-2RS	*039233*	1	
28	Plate, Bearing Retaining	*039012*	1	
	Nut Assembly, Arbor w/Set Screws	*036650*	1	
29	Nut, AN16	039129	1	◆
30	Screw, 1/4-20 x 1/2" Nylon Tip Set	*F05005-166*	2	
31	Bolt, 5/16-18 x 1/2" Socket Head	*F05006-39*	5	
32	Ring, Industrial Edger Blade Lock	*039128*	1	
33	Bolt, 1/2-13 x 1 1/4" Socket Head	*F05008-38*	3	
34	Nut, 1/2-20 Hex Jam	*F05010-16*	1	
35	**PUSHER WELDMENT, RIGHT BLADE**	*039236*	1	
	WRENCH, EDGER BLADE INSERT	*048336* [1]	1	

[1] Insert Wrench 048336 sold separately required to remove/install blade inserts.

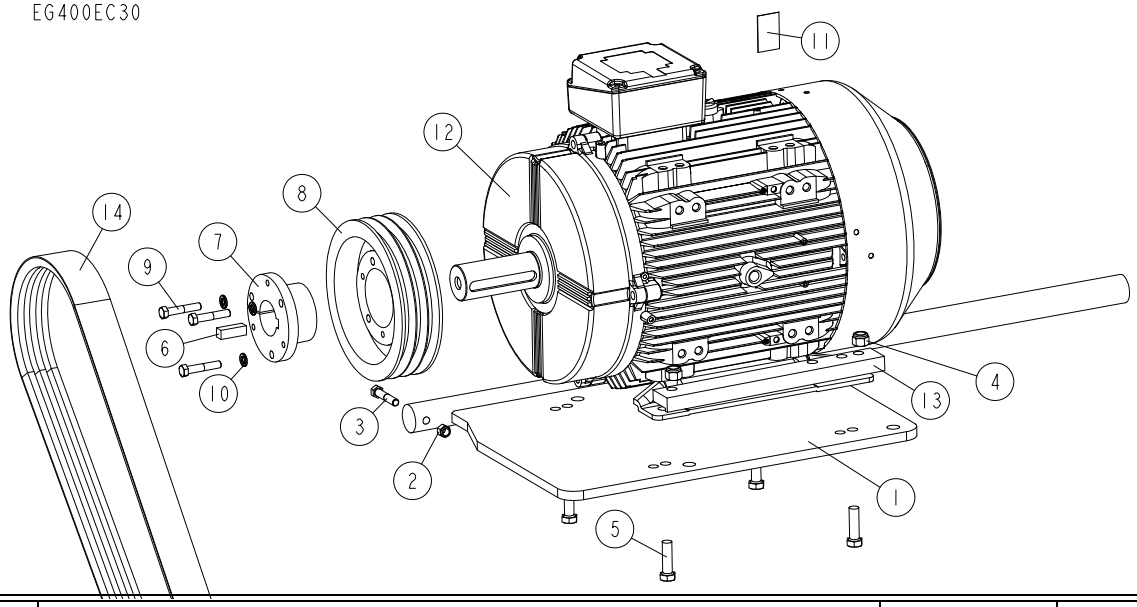
5.11 Blades Shaft



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	DOOR WELDMENT, BLADE	*039338*	1	
2	BOLT, 5/8-11 X 2 1/2 GR5 HEX HEAD	*F05009-20*	3	
3	WASHER, 5/8 SPLIT ZINC LOCK	*F05011-27*	4	
4	BOLT, 5/8-18 X 2 HEX HEAD FT	*F05009-15*	1	
5	WASHER, 21/32 X 1 5/8 X 1/4 THICK	*034685*	1	
6	CUP, BLADE DRIVE SHAFT	*039001*	1	
7	BEARING, F-U335D	*039150*	1	
8	BOLT, 3/4-10 X 2 1/2 HEX HEAD GR5	*F05009-44*	8	
9	NUT, 3/4-10 NYLOCK	*F05010-103*	8	
10	BEARING, FE-U335D	*039151*	1	
11	SHEAVE, 35V670	*094703*	1	
12	KEY, 1/2 SQ X 1 1/2	*033738*	1	
13	BUSHING, SK X 2 3/16	*094704*	1	
14	SHAFT, 2 7/16 DIA.	*039002*	1	

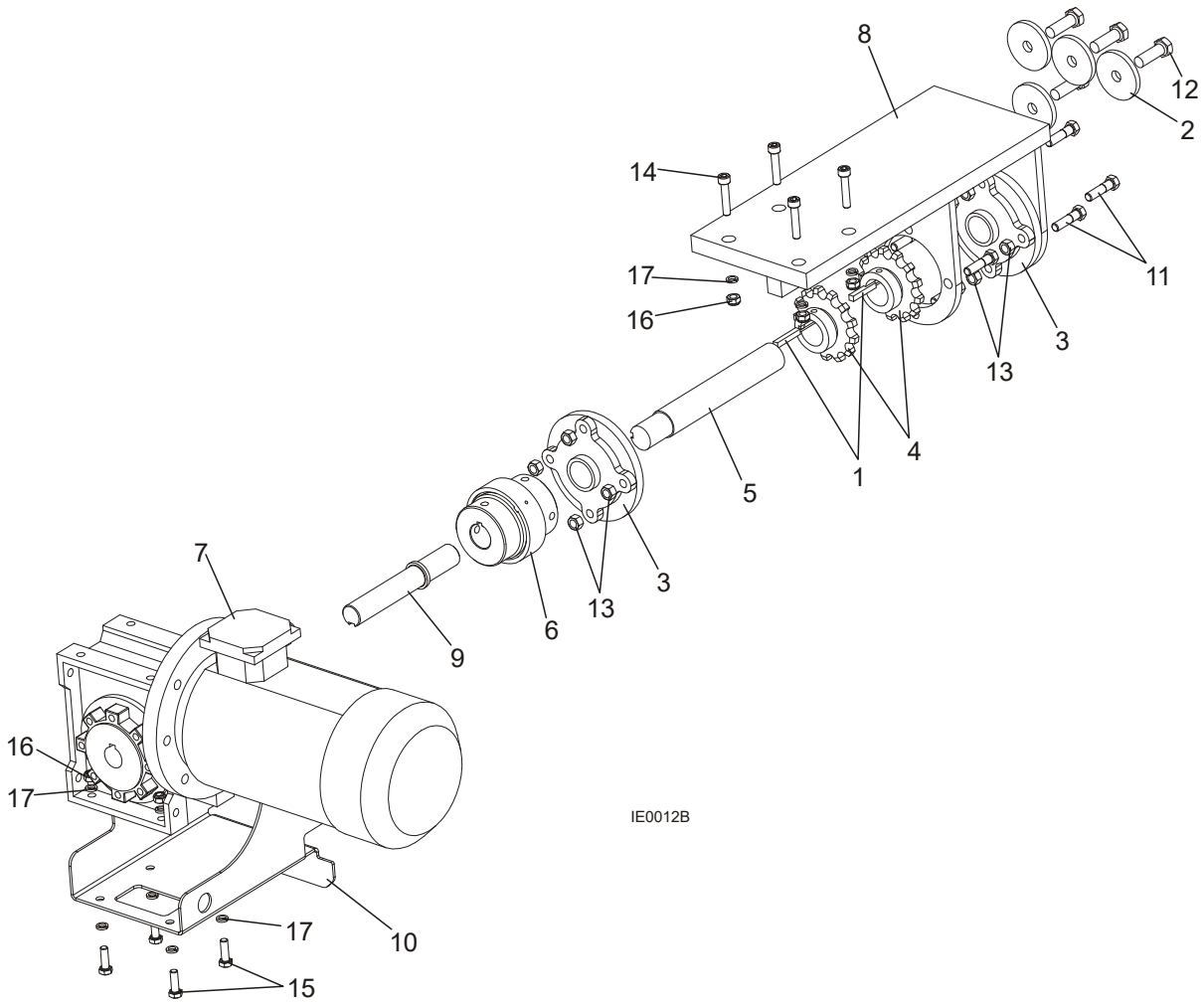
5.12 Blades Motor Assembly

EG400EC30_001
EG400EC30



REF	DESCRIPTION (u indicates parts available in assemblies only)	PART #	QTY	
	MOTOR ASSEMBLY, INDUSTRIAL EDGER	039265	1	
1	MOUNT WELDMENT, MOTOR	094705-1	1	
2	NUT, 3/8-16 HEX NYLON LOCK	F05010-10	1	
3	BOLT, 3/8-16 X 2" HEX HEAD GRADE 5	F05007-124	4	
4	NUT, 1/2-13 NYLON HEX LOCK	F05010-8	4	
5	BOLT, 1/2-13 X 1 3/4" HEX HEAD FULL THRE	F05008-88	1	
6	Key, 1/2 Sq x 1 1/2	033738	1	
7	BUSHING, SG180 MOTOR (FOR 505313-S PULLE	092644	1	
8	SHEAVE, EG400	094702	1	
9	BOLT, 3/8-16 X 2" HEX HEAD	F05007-72	1	
10	WASHER, 3/8" SPLIT LOCK	F05011-4	3	
11	DECAL, MOTOR DIRECTION	S20097	3	
12	MOTOR, TAMEL 22KW WP-DA180L B3 400/690V; 50Hz, 4P	557148	1	
13	**PLATE, MILLED MOTOR**	557138-1	1	
14	**BELT, 3 X 5V X 900**	039270	1	

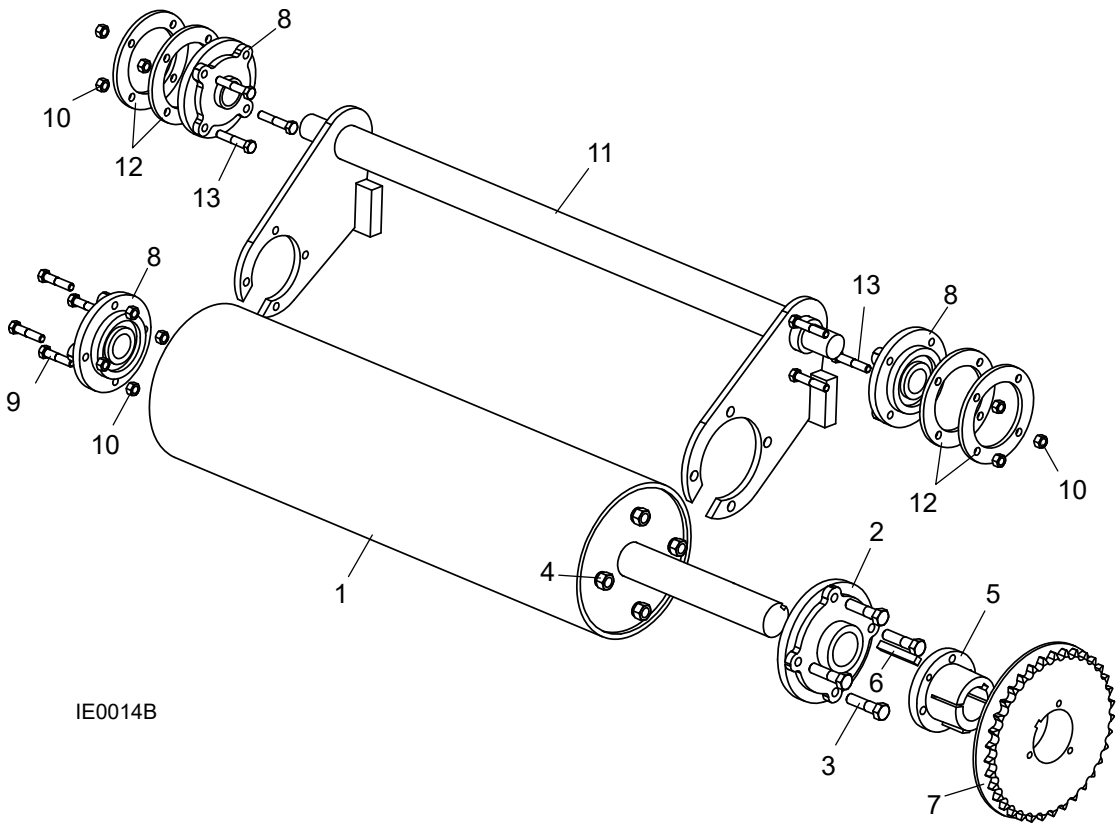
5.13 Feed Drive Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	DRIVE ASSEMBLY, EDGER FEED	095417	1	
1	Key, 1/4 Square x 1 1/2 Long	028080	2	
2	Washer, Drive Side Bearing	033909	4	
3	Bearing, VFCS-320	039152	2	
4	Sprocket, H6013 x 1.25 Bore Keyed	039155	2	
5	Shaft, Edger Power Feed	039214	1	
6	Coupling, 10R x 1 x 1-1/8 Power Feed	042655	1	
7	Motor, SKHR90x-4 Feed Drive	095400	1	
8	Mount Weldment, Board Drive	095416-1	1	
9	Shaft, Edger Power Feed	095418-1	1	
10	Guard, Board Feed	095419-1	1	

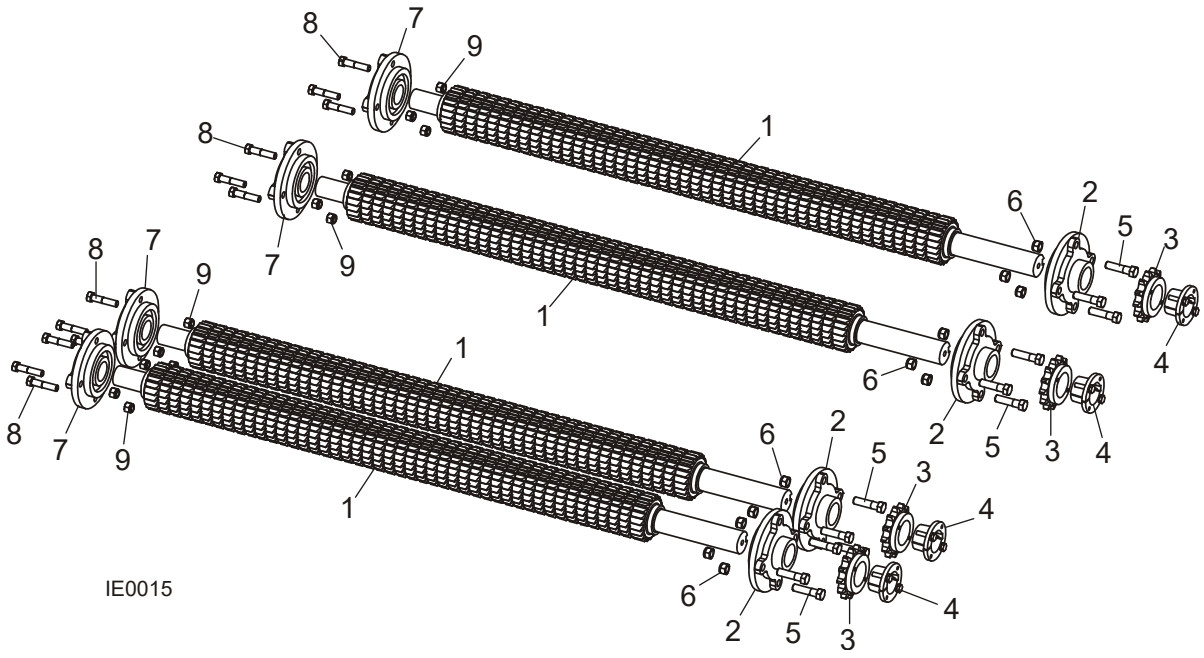
11	Bolt, 3/8-16 x 1 1/2 Hex Head Gr5	F05007-78	8	
12	Bolt, 1/2-13 x 1 1/2 Hex Head Gr5	F05008-33	4	
13	Nut, 3/8-16 Swaged	F05010-25	8	
14	SCREW, M8X40-8.8 HEX SOCKET HEAD CAP ZINC	F81002-29	4	
15	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
16	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	8	
17	WASHER 8,2 SPLIT LOCK ZINC	F81054-4	12	

5.14 Upper Driven Roller



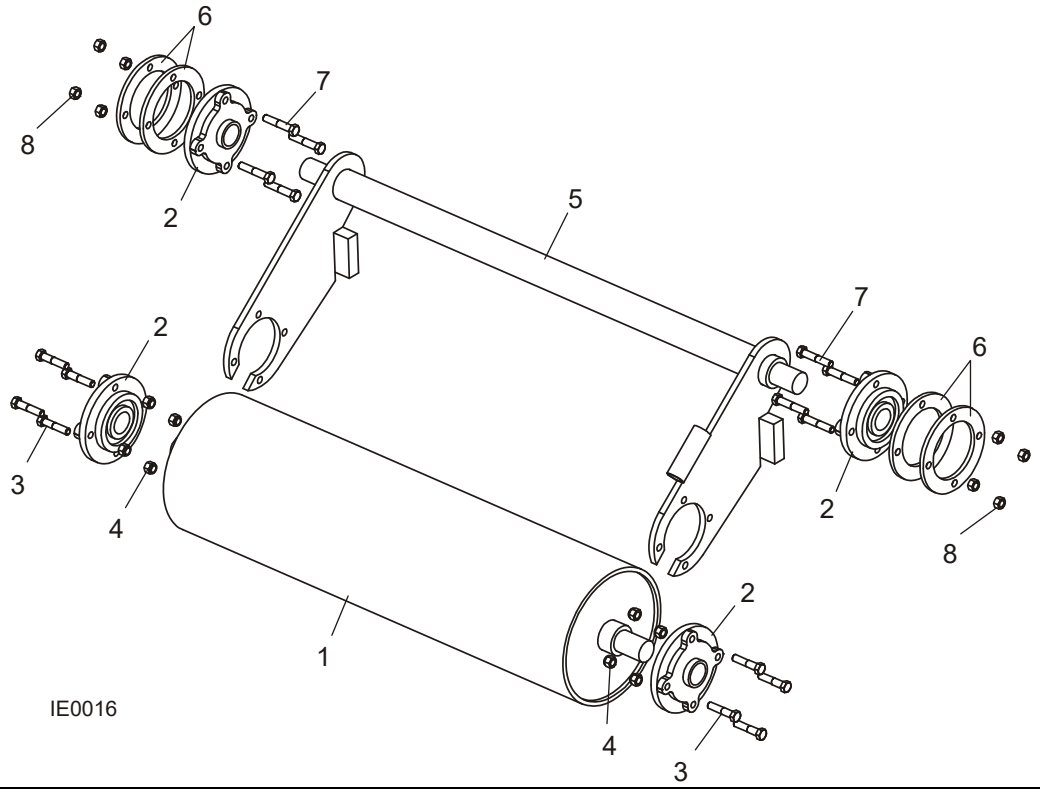
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, UPPER DRIVEN	*039258*	1	
1	Roller Weldment, Infeed Holddown	*039086*	1	
2	Bearing, VFCS-328	*039154*	1	
3	Bolt, 1/2-13 x 2 Hex Head	*F05008-76*	4	
4	Nut, 1/2-13 Nylon Hex Lock	*F05010-8*	4	
5	Bushing, Q1 x 1 3/4	*039260*	1	
6	Key, 3/8 Sq x 2 1/2	*039380*	1	
7	Sprocket Wldmt, Feed Drive 60Q35	*036484*	1	
8	Bearing, VFCS-320	*039152*	3	
9	Bolt, 3/8-16 UNF-2A x 1-3/4 Gr5	*F05007-119*	4	
10	Nut, 3/8-16 Swaged Lock	*F05010-25*	10	
11	Pivot Weldment, Driven Holddown	*039111*	1	
12	Spacer, Bearing	*039007*	4	
13	Bolt, 3/8-16 x 2 Hex Head Gr5	*F05007-124*	6	

5.15 Lower Drive Rollers



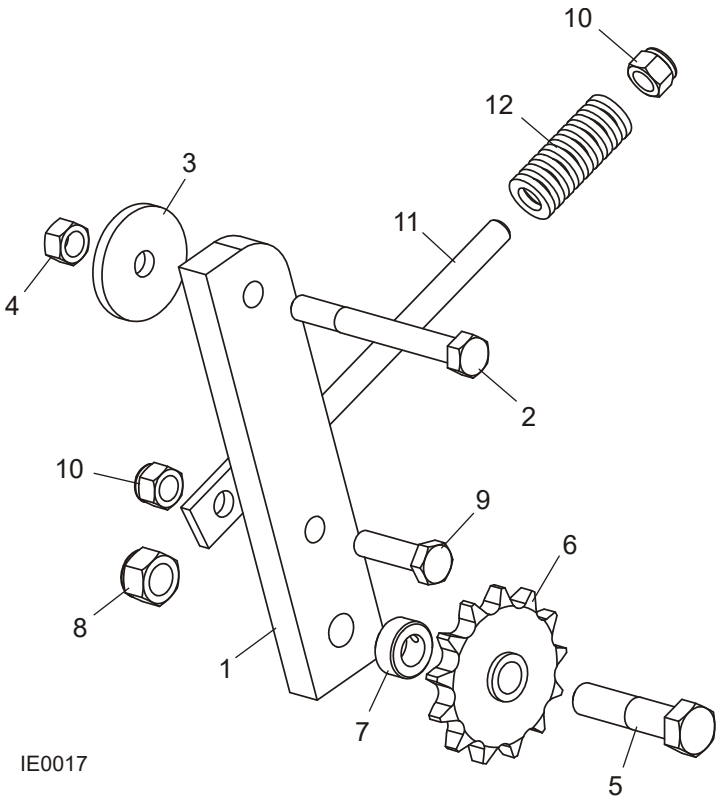
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, LOWER DRIVE	*039255*	4	
1	Shaft, Lower Drive	*039169*	4	
2	Bearing, VFCS-323	*039153*	4	
3	Sprocket, 60H13	*039256*	4	
4	Bushing, QT x 1 7/16	*P12962*	4	
5	Bolt, 7/16-14 x 1 3/4 G8 Hex Head	*F05009-60*	12	
6	Nut, 7/16-14 Nylon Lock	*F05010-135*	12	
7	Bearing, 1 1/4, 4 Bolt Flange	*039152*	4	
8	Bolt, 3/8-16 UNF-2A x 1-3/4 Gr5	*F05007-119*	12	
9	Nut, 3/8-16 Hex Nylon Lock	*F05010-10*	12	

5.16 Upper Idle Roller



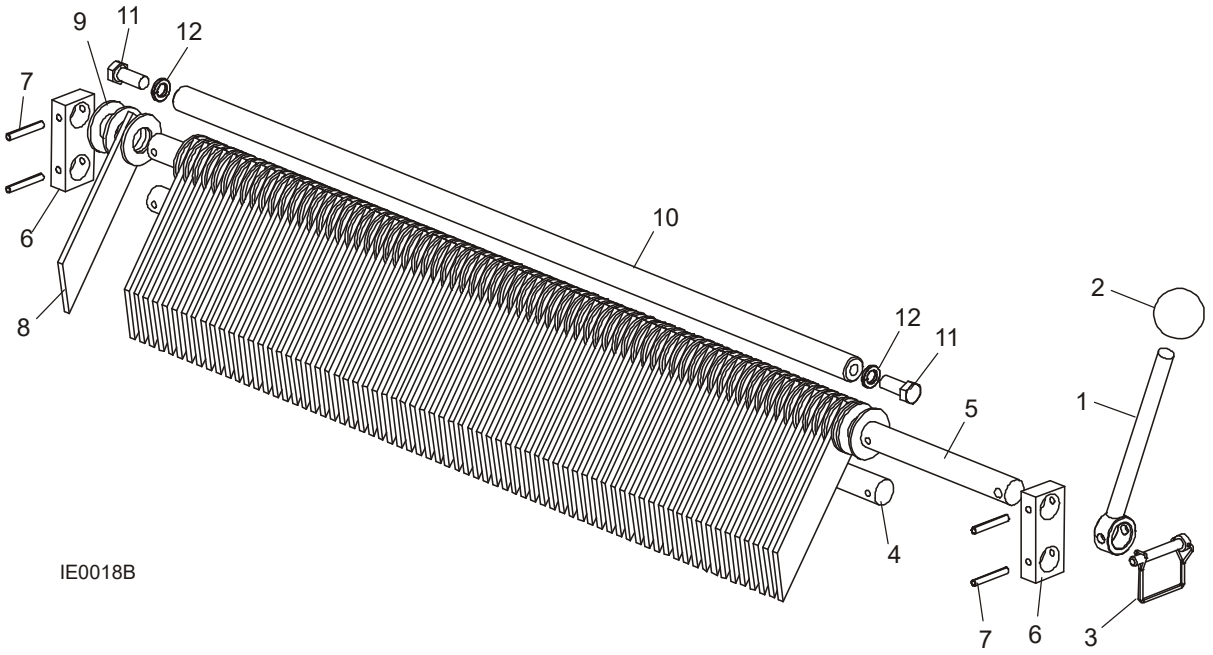
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, UPPER IDLE	039257	1	
1	Roller Weldment, Idle Holddown	039109	1	
2	Bearing, VFCS-320	039152	4	
3	Bolt, 3/8-16UNF-2A x 1-3/4 Gr5	F05007-119	8	
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	8	
5	Pivot Weldment, Idle Holddown	039110	1	
6	Spacer, Bearing	039007	4	
7	Bolt, 3/8-16x2 Hex Head Gr5	F05007-124	8	
8	Nut, 3/8-16 Swaged	F05010-25	8	

5.17 Tensioner Assembly



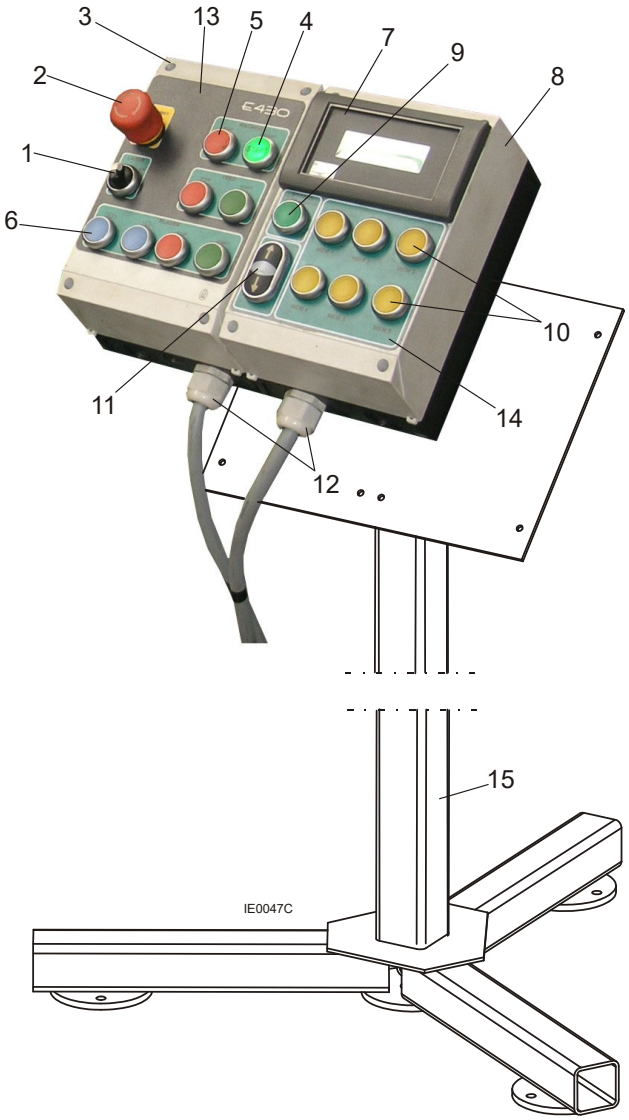
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TENSIONER ASSEMBLY, INDUSTRIAL EDGER	*039262*	1	
1	Block, Idler Pivot	*039097*	1	
2	Bolt, 1/2-13 x 4 1/2 Hex Head Gr5	*F05008-35*	1	
3	Washer, Drive Side Bearing	*033909*	1	
4	Nut, 1/2-13 Swaged Hex 2-way Lock	*F05010-3*	1	
5	Bolt, 5/8-11 x 2 3/4 Hex Head	*F05009-21*	1	
6	Sprocket, 60BB13H x 5/8 Idler	*034224*	1	
7	Collar, 5/8 ID Lock	*P05035*	1	
8	Nut, 5/8-11 Nylon Lock	*F05010-34*	1	
9	Bolt, 1/2-13 x 1 3/4 Hex Head Gr5 Zinc	*F05008-88*	1	
10	Nut, 1/2-13 Nylon Hex Lock	*F05010-8*	2	
11	Tensioner Weldment, Drive Chain	*039116*	1	
12	Spring, EH100 x 250	*039263*	1	

5.18 Kickback Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	KICKBACK ASSEMBLY, INDUSTRIAL EDGER	*039261*	1	
1	Handle Weldment, Kickback Lift	*039213*	1	
2	Knob, 5/8-18 Ball	*P04211*	1	
3	Pin, 3/8 x 2 1/4" SQ Wire Lock	*014151*	1	
4	Shaft, Kickback Upper	*039073*	1	
5	Shaft, Kickback Lower	*039074*	1	
6	Block, Kickback Link	*039106*	2	
7	Pin, 1/4 x 1 3/4" Roll	*F05012-53*	4	
8	Finger, 1/4" Kickback	*038238*	70	
9	Washer, 1" ID SAE Flat	*F05011-28*	145	
10	Rod, Kickback Stop	*039387*	1	
11	Bolt, 1/2-13x1 1/4" Hex Head Grade 5	*F05008-37*	2	
12	Washer, 1/2" Split Lock	*F05011-9*	2	

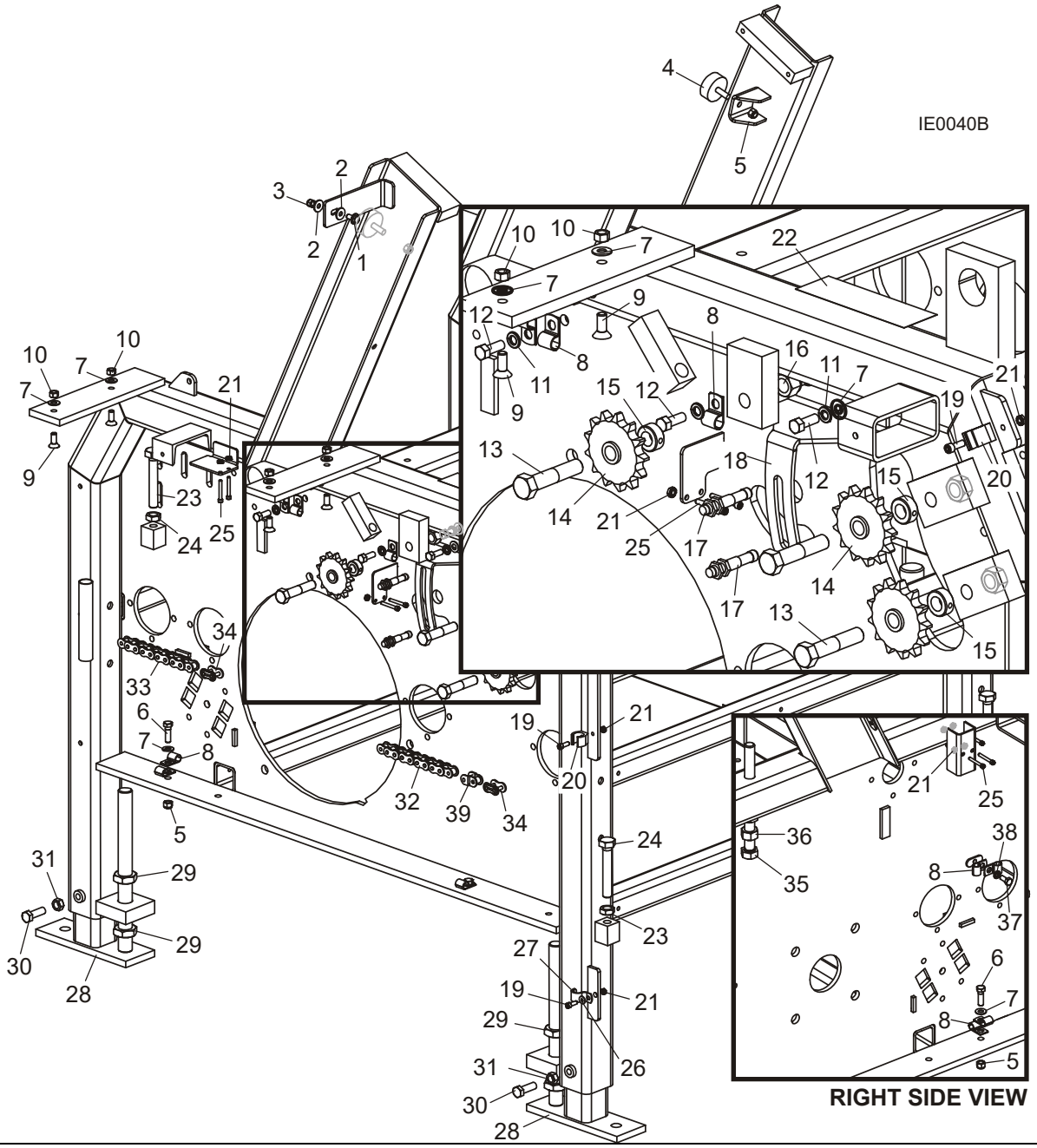
5.19 Operator Control Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	CONTROL BOX ASSEMBLY, EG400	094815	1	
1	BUTTON, M22-WKV	-	1	
2	BUTTON, M22-PVT	-	1	
3	HOUSING, M22-I12	095007	1	
4	BUTTON, M22-D-G	-	3	
5	BUTTON, M22-D-R	-	3	
6	BUTTON, M22-D-B	-	2	
	ELEMENT, M22-KC10 CONTACT	094314	6	

	SETWORK, INDUSTRIAL EDGER	095380	1	
7	DISPLAY, DIRECT OP-440	088142	1	
8	HOUSING, M22-I12	095007	1	
9	CLOSER, SWITCH M22 DLR-G	095373	1	
	ELEMENT, M22-KC10 CONTACT	094314	1	
	ELEMENT, M22 LEDC-G LED	095374	1	
10	CLOSER, SWITCH M22 DL-Y	095372	6	
	ELEMENT, M22-KC10 CONTACT	094314	6	
	ELEMENT, M22-LEDC-W LED	094999	6	
11	BUTTON, M22-DD-S-X7/X7	090917	1	
	ELEMENT, M22-KC10 CONTACT	094314	2	
12	GLAND, Pg 21 CABLE	F81096-3	2	
13	**DECAL, INDUSTRIAL EDGER CONTROL BOX**	094816	1	
14	**DECAL, EG400 SETWORK**	095375	1	
15	**STAND, EG400 CONTROL BOX**	095406-1	1	

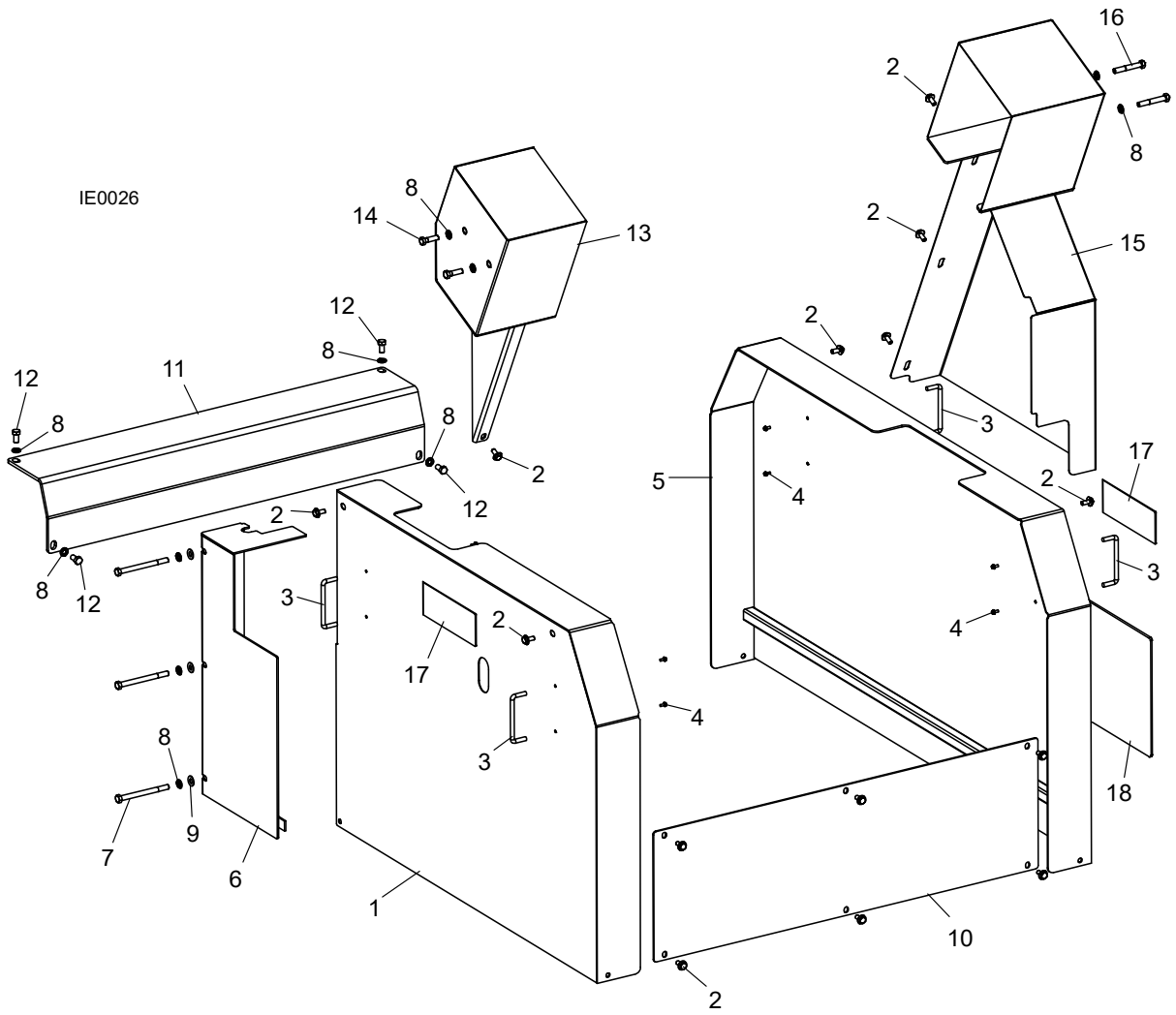
5.20 Frame Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BOLT, 5/16-18 X 3/4 HEX HEAD W/WASHER	F05006-101	1	
2	WASHER, 5/16 STANDARD FLAT	F05011-16	2	
3	NUT, 5/16-18 NYLON LOCK	F05010-58	1	
4	BUMPER, TABLE	034175	2	

5	NUT, 3/8-16 HEX NYLON LOCK	F05010-10	4	
6	BOLT, 3/8-16 X 1 1/4 HEX HEAD GR2	F05007-2	2	
7	WASHER, 3/8 FLAT	F05011-3	8	
8	CLAMP, 1/2 EMT COATED	P07584	9	
9	SCREW, 3/8-16 X 1 ZINC AND BAKE FS	F05007-64	4	
10	NUT, 3/8-16 SWAGED	F05010-25	4	
11	WASHER, 3/8 SPLIT	F05011-4	4	
12	BOLT, 3/8-16X1 HEX HEAD	F05007-7	4	
13	BOLT, 5/8-11 X 3 GR 2 ZINC	F05009-32	3	
14	SPROCKET, 60BB13H X 5/8 IDLER	034224	3	
15	COLLAR, 5/8 ID LOCK	P05035	3	
16	NUT, 5/8-11 NYLON LOCK	F05010-34	3	
17	SENSOR, IND PROX M12 PNP NS EX	051439	2	
18	PLATE, PROX MOUNT	039313	1	
19	SCREW, 1/4-20 X 3/4 BO SOCKET HEAH CAP	F05005-26	3	
20	BRACKET, 1/2 FLEX MOUNTING	039379	2	
21	NUT, #10-24 KEPS	F05010-14	11	
22	PLATE, SERIAL IDENTIFICATION	S20038	1	
23	BOLT, 5/8-11 X 4 HEX HEAD FULL THREAD GR5	F05009-31	3	
24	NUT, 5/8-11 HEX JAM	F05010-82	3	
25	BOLT, #10-24 X 1 1/2 SOCKET HEAD BO	F05004-51	8	
26	WASHER, #10 SAE FLAT	F05011-18	1	
27	CLAMP, 1/2 EMT	P05088	1	
	FOOT ASSEMBLY, EDGER	039143	4	
28	Foot Weldment, Edger	039115	4	
29	Nut, 1-14 Hex Jam ZC	F05010-118	8	
30	BOLT, 1/2-13 X 1 1/2 HEX HEAD GR5	F05008-33	4	
31	NUT, 1/2-13 FREE HEX, ZINC	F05010-35	4	
32	CHAIN, #60 X 135 3/4	039369	1	
33	CHAIN, #60 X 32 1/4	039368	1	
34	LINK, #60 CL	042398	2	
35	BOLT, 3/4-10 X 9 FT HEX HEAD	F05013-13	1	
36	NUT, 3/4-10 FREE HEX ZN	F05010-7	1	
37	BOLT, 5/16-18 X 3/4 HEX HEAD GR2	F05006-5	1	
38	WASHER, 5/16 SPLIT LOCK	F05011-13	1	
39	LINK, #60 HALF	036686	1	
	SENSOR, IND PROX M12 PNP NS EX	051439	4	

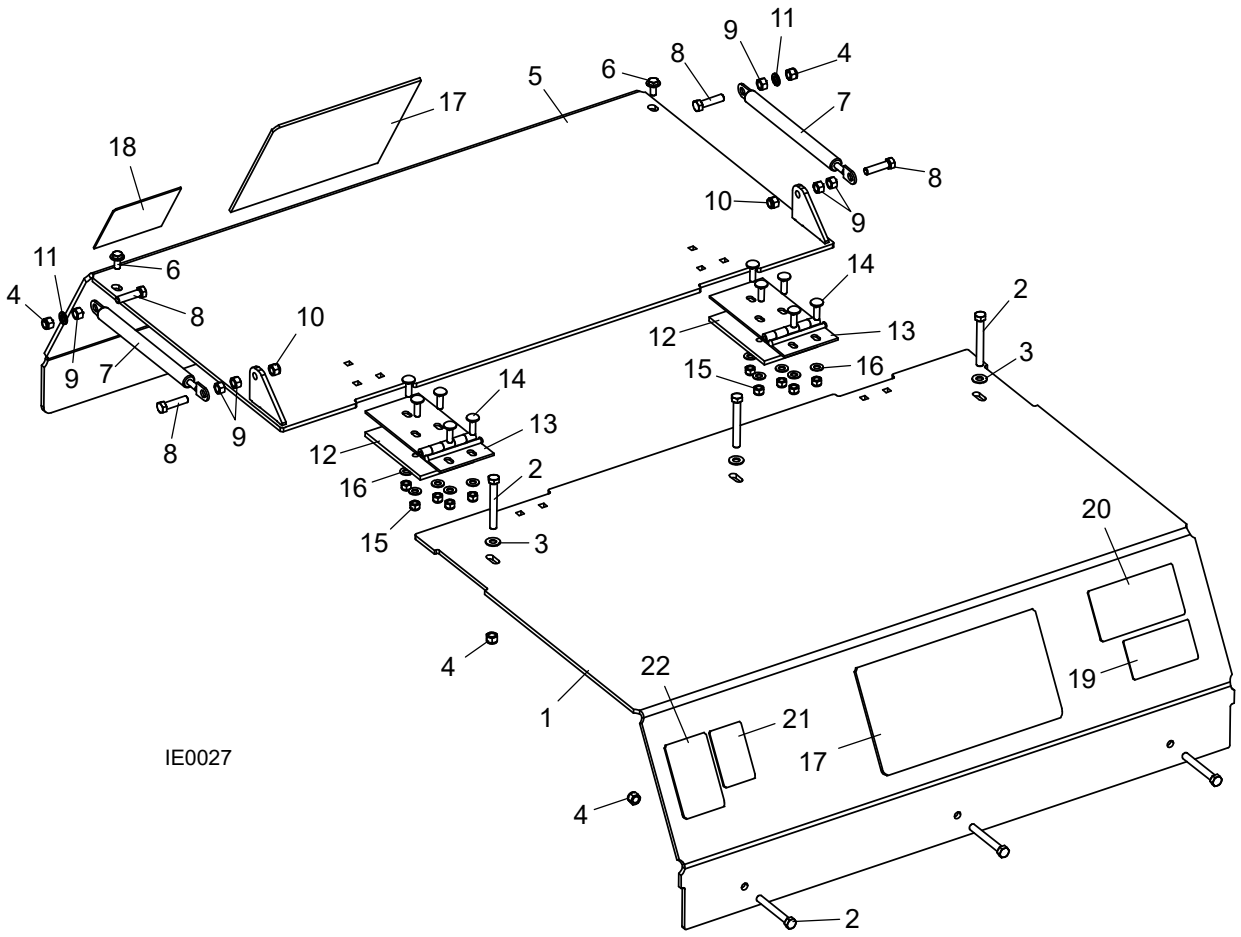
5.21 Housing Covers & Control Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	GUARD, FEED DRIVE SIDE REMOVABLE	039220	1	
2	BOLT, 5/16-18 X 3/4 HEX HEAD W/WASHER	F05006-101	13	
3	HANDLE, 4 W/BOLT	P08065	4	
4	SCREW, #8-32 X 3/8 SELF TAP	F05015-8	8	
5	GUARD WELDMENT, BLADE DRIVE SIDE	039219	1	
6	GUARD WELDMENT, FEED SIDE FIXED	039248	1	
7	BOLT, 3/8-16X4 1/2 HEX HEAD GR2	F05007-35	3	
8	WASHER, 3/8 SPLIT	F05011-4	11	
9	WASHER, 3/8 FLAT	F05011-3	3	
10	GUARD, LOWER FRONT	039296	1	
11	PLATE, DRIVE GUARD	039210	1	

12	BOLT, 3/8-16 X 3/4 HEX HEAD GR2	F05007-27	4	
13	GUARD WELDMENT. ELEC BOX SIDE TOP	039228	1	
14	BOLT, 3/8-16 X 1 1/4 HEX HEAD GR5	F05007-123	2	
15	GUARD WELDMENT, MOTOR SHEAVE	039229	1	
16	BOLT, 3/8-16 X 2 1/2 HEX HEAD GR5	F05007-125	2	
17	DECAL, MOVING PARTS DANGER	033254	2	
18	DECAL, INDUSTRIAL EDGER LOGO	094991-2	1	

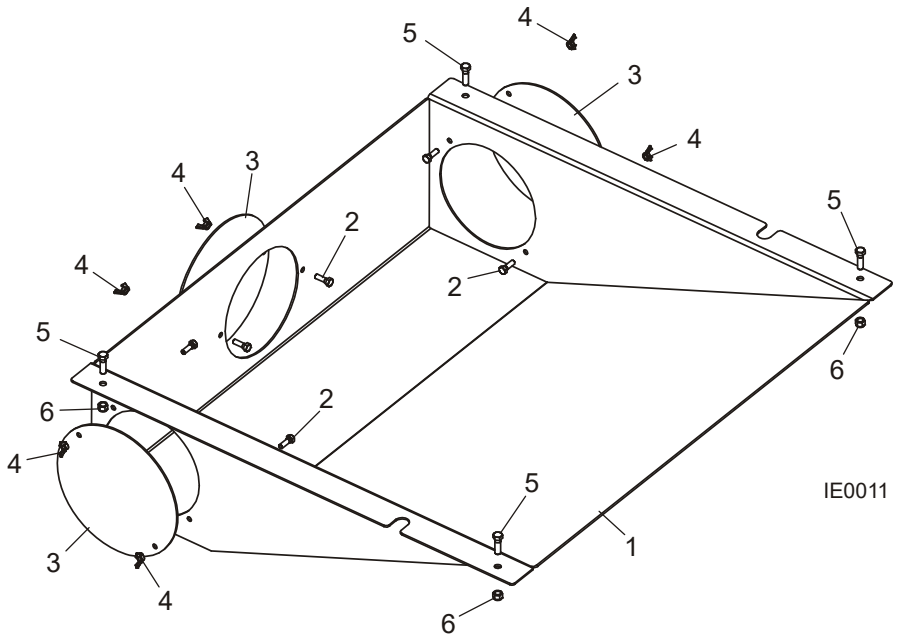
5.22 Top Blade Guard Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	GUARD ASSEMBLY, TOP BLADE	*039273*	1	
1	Plate, Top Front Cover	*039020*	1	
2	Bolt, 3/8-16 x 3 Hex Head Full Thread	*F05007-1*	6	
3	Washer, 3/8 Flat	*F05011-3*	3	
4	Nut, 3/8-16 Hex Nylon Lock	*F05010-10*	8	
5	Guard Weldment, Rear Blade	*039272*	1	
6	Bolt, 5/16-18 x 3/4 Hex Head W/Washer	*F05006-101*	2	
7	Spring, Perimeter Fence Gas	*P22309*	2	
8	Bolt, 3/8-16 x 1 1/2 Hex Head Full Thread	*F05007-17*	4	
9	Nut, 3/8-16 Hex	*F05010-1*	6	
10	Nut, 3/8-16 Swaged	*F05010-25*	2	
11	Washer, 3/8 Split	*F05011-4*	2	
12	Plate, Hinge Stiffener	*039314*	2	

13	Hinge, 2 x 5.5 x 3.5 x .125, w/Slots	*038136*	2	
14	Bolt, 5/16-18 x 1 Carriage	*F05006-9*	10	
15	Nut, 5/16-18 Nylon Lock	*F05010-58*	10	
16	Washer, 5/16 SAE Flat	*F05011-17*	10	
17	Decal, Logo EG400 Blade Door	*039383*	2	
18	Decal, Moving Parts Danger	*033254*	1	
19	Decal, Kickback Hazard Warning	*038134*	1	
20	Decal, Read Manual Warning	*016402*	1	
21	Decal, Eye/Ear Protection Warning	*S11753*	1	
22	Decal, Blade Hazard Danger	*038176*	1	

5.23 Chute Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	CHUTE ASSEMBLY, INDUSTRIAL EDGER	*039290*	1	
1	Hopper Weldment, Industrial Edger	*039289*	1	
2	Bolt, 5/16-18 x 1 Hex Head Gr2	*F05006-1*	6	
3	Cover, Hopper Hole	*039288*	3	
4	Nut, 5/16-18 Wing	*F05010-23*	6	
5	Bolt, 3/8-16 x 1 1/4 Hex Head Gr5	*F05007-123*	4	
6	Nut, 3/8-16 Hex Nylon Lock	*F05010-10*	4	

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Symbol Diagram

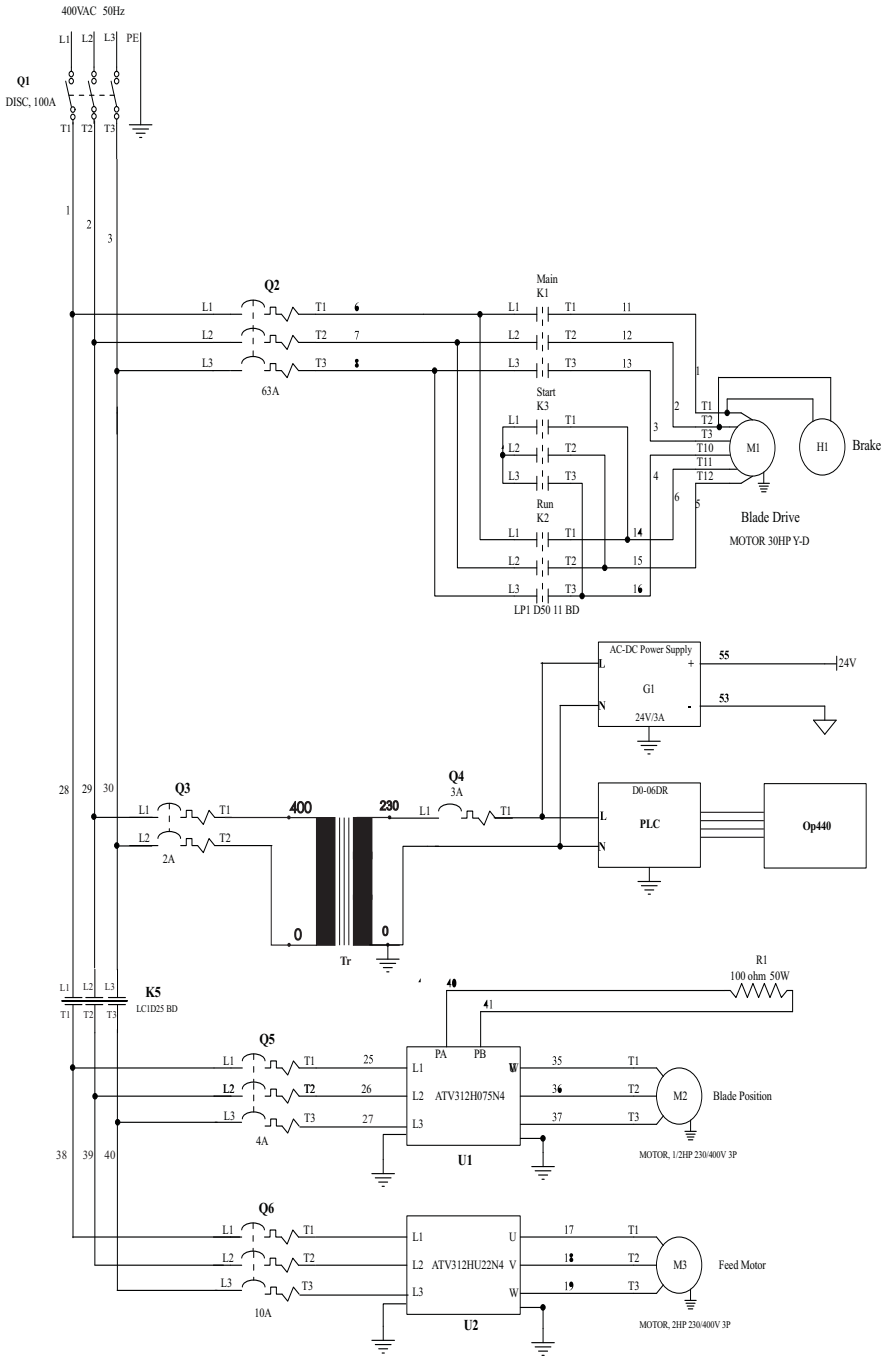


FIG. 6-1 SYMBOL DIAGRAM

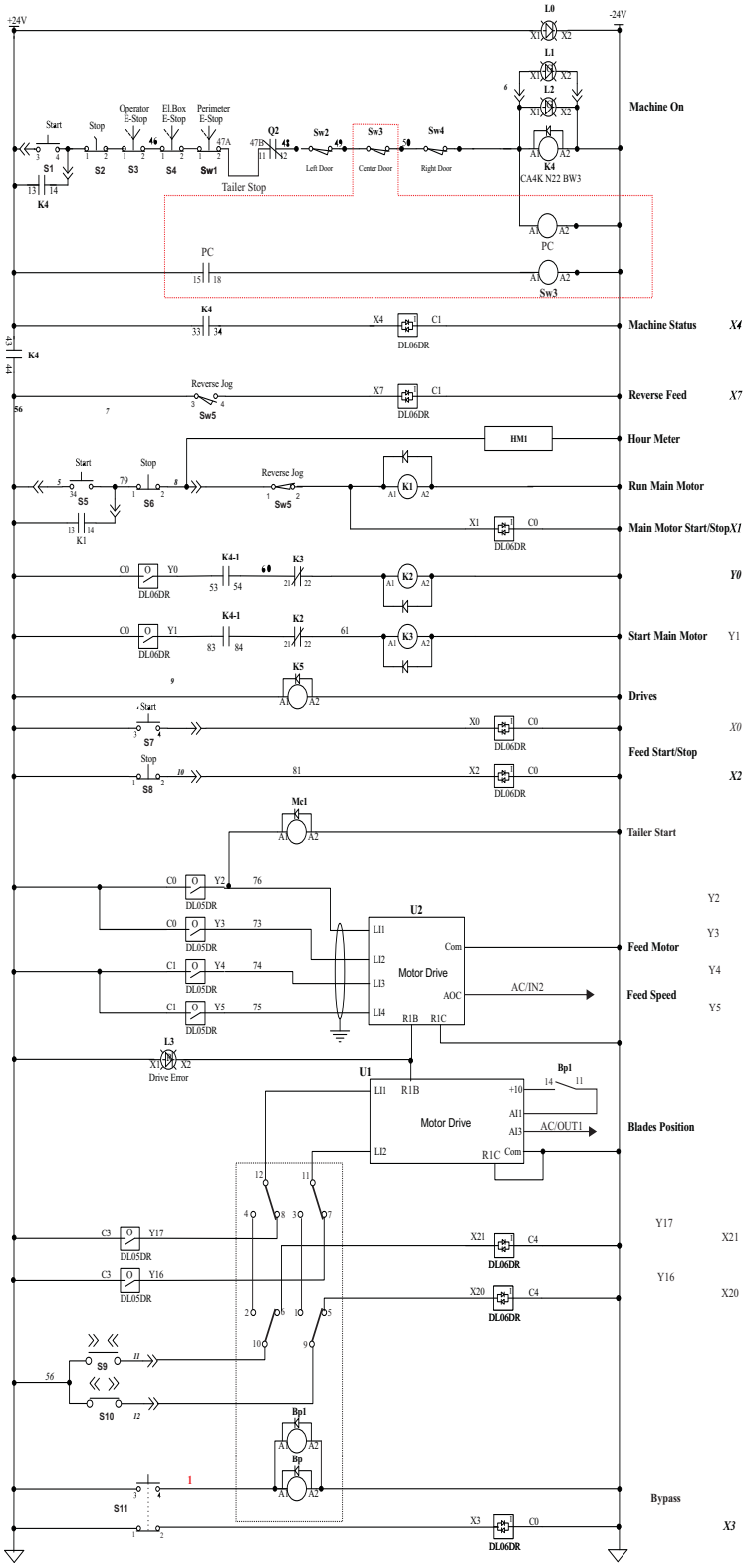


FIG. 6-2 SYM BOL DIAGRAM

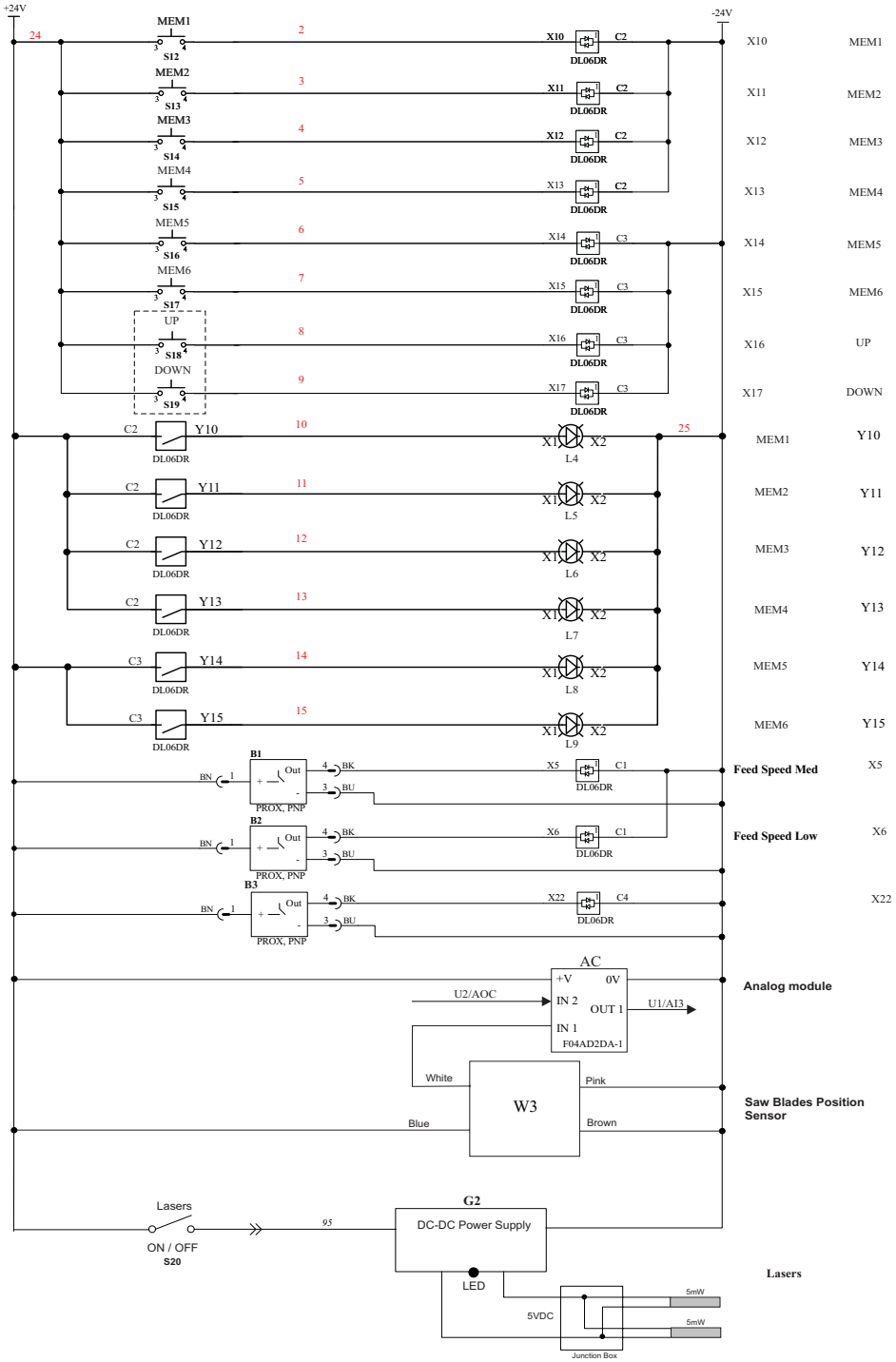


FIG. 6-3 SYMBOL DIAGRAM

6.2 Electrical Component List

Component	Manufacturer Part No.	Manufacturer	Wood-Mizer Part No.	Description
Alarm	26924	Schneider	092624	Auxiliary, Contact OF
G1	ABL7RE2403	Schneider	092485	Power supply ABL7RE2403
K1, K2	LC1D50BD	Schneider	093898	Contactor, LC1D50BD
K3, K5	LC1D25BD	Schneider	093899	Contactor, LC1D25BD
K4	CA4KN31BW3	Schneider	092479	Contactor, CA4KN31BW3
Q1	28908	Schneider	501017	Switch, ABB OT100F3
Q2	24356	Schneider	092482	Circuit breaker, C60N 3P 63A
Q3	24331	Schneider	510259	Circuit breaker, C60N 2P 2A
Q4		Schneider	504386	Circuit breaker, C60N 1P 3A
Q5		Schneider	094799	Circuit breaker, C60N 3P 10A
Q6		Schneider	084317	Circuit breaker, C60N 3P 10A
PLC		Automation Direct	051680	PLC Controller, DO-06DR
R1	795-0448	Allied	051323	Resistor, 50W 100 Ohm
U1	ATV31H075N4	Schneider	093902	Altivar, ATV312H075N4
U2	ATV31HU22N4	Schneider	095470	Altivar, ATV312HU22N4
S4		Schneider	502315	Emergency Stop, XB7 NS8444
Bp	55.34.9.024.0050	Finder	088828	Relay
Bp1	55.34.9.024.0050	Finder		Relay, 40.52.9.024
PC	55.34.9.024.0050	Finder	091688	Time Relay, FINDER 80.61.0.240.0000
Mc1				Contactor, LP1K1210BD
Tr		NORATEL	094739	Transformer, SU120C-400230
HM1		KUBLER	095479	Hour meter SH17 10-30VDC
W3		BALLUFF	095962	Analog sensor, BTL6-E500-M0400-PF-S115
M1+H1		SIEMENS	093897	Motor, 1LG4186-4AA60-Z G26+C01
SW3		SCHMERSAL	095831	Electromagnetic interlocking, AZM170
B1, B2, B3		BALLUFF	093172	Inductive sensor, BES M12MI-PSC40B-S04G
M2		Lincoln	039274	Blade and laser guide motor, SRF4S05TCN61
M3		Besel	095400	Motoreducer, SKhR90x-4M/XC63-7S/162
LASERS		CEMAR ELECTRO		Laser guide CL815WC
S1+L1		MOELLER		Button, illuminated M22-DL-G-X1
S2		MOELLER		Switch M22-D-R
S3		MOELLER		Emergency stop M22-PVT
SW1		SCHNEIDER ELECTRIC	090994	Cable-operated button XY2CH13250
SW2		Giovenzana	086469	Safety switch, FA139 Z11
SW4		Giovenzana	086469	Safety switch, FA139 Z11
SW5		Giovenzana	086469	Safety switch, FA139 Z11
L0		MOELLER		Control Light, white M22-L-W
L1		MOELLER		Control Light, green M22-L-G

L2		MOELLER		Control Light, green M22-L-G
S5		MOELLER		Button, M22-D-G
S6		MOELLER		Button, M22-D-R
S7		MOELLER		Button, M22-D-G
S8		MOELLER		Button, M22-D-R
L3		MOELLER		Control Lamp, red M22-L-R
S9		MOELLER		Button, M22-D-B
S10		MOELLER		Button, M22-D-B
S11		MOELLER	095373	Button, M22-DLR-G
S12-S17 + L4-L9		MOELLER	095372	Button, illuminated M22-DL-Y
S19/S19		MOELLER	090917	Button, M22-DDL-S-X7/X7
S20		MOELLER		Switch, 2-position M22-WRLK-W

6.3 Component Layout Diagrams

Control Cabinet/Laser Interface

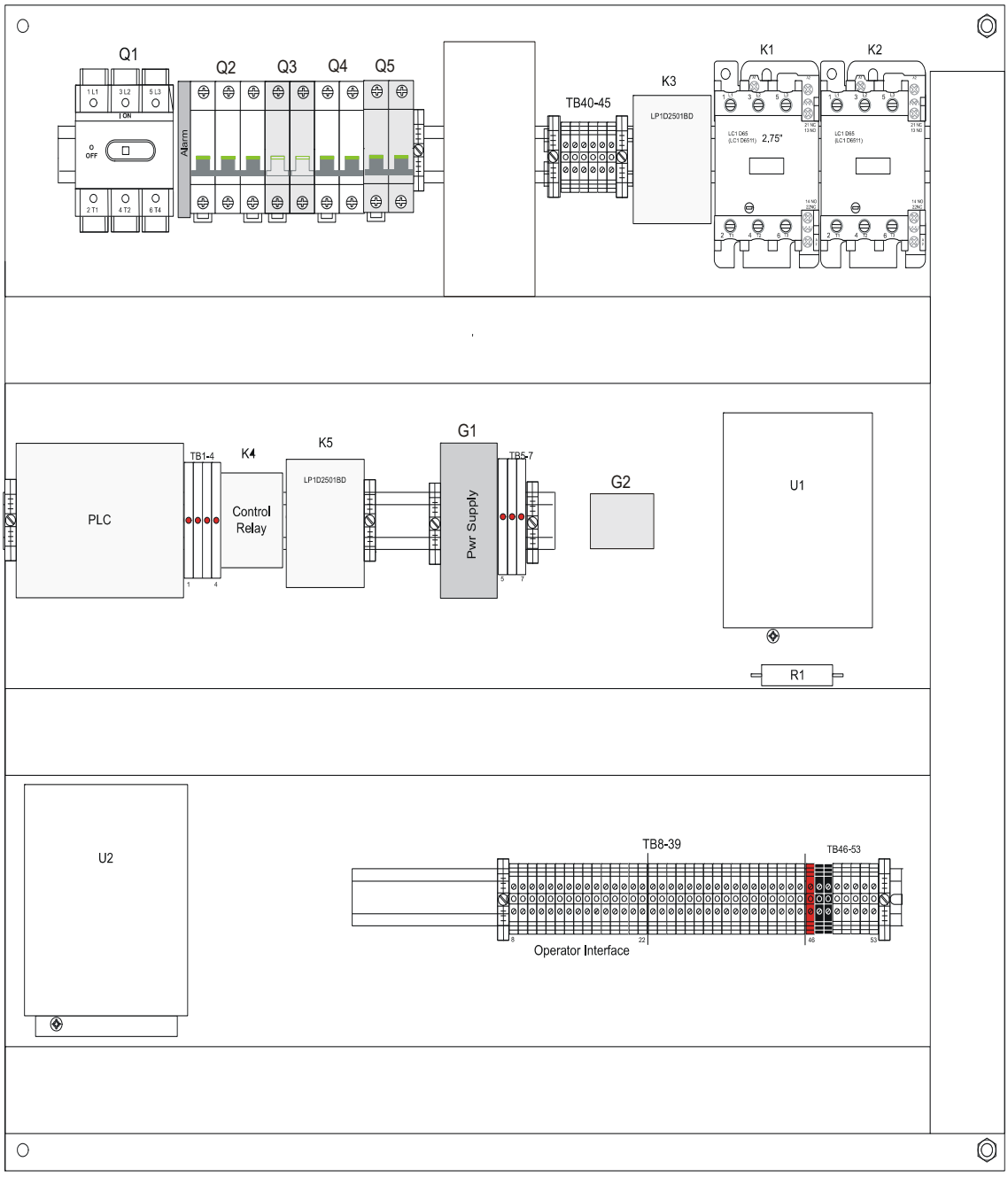


FIG. 6-4

Operator Interface

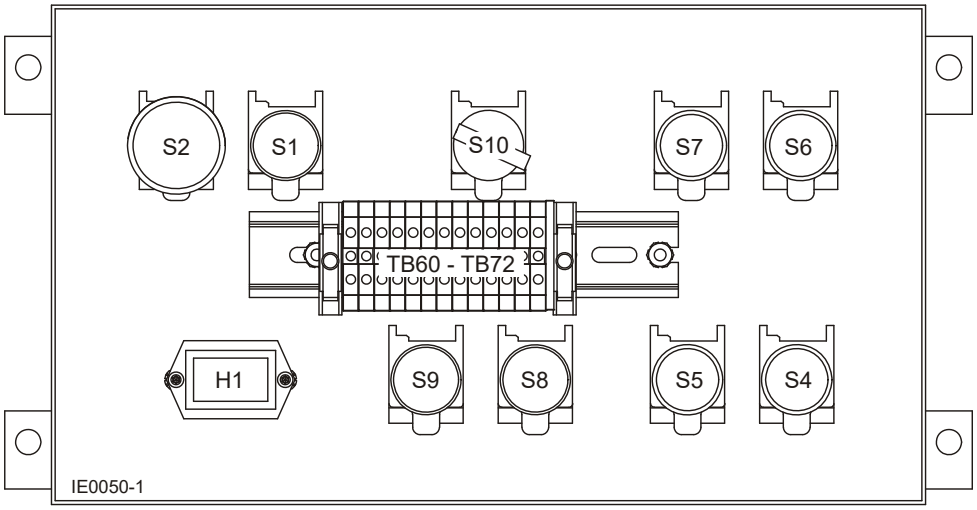


FIG. 6-5

SECTION 7 MOTOR BRAKE

7.1 Motor Brake Maintenance

Maintenance intervals

Service brakes	■ after 4000 hours of operation at the latest or every six months

TABLE 7-1.

IMPORTANT! Brakes with defective armature plates, cheese head screws, springs or flanges must be replaced completely.

Please observe the following for inspections and maintenance operations:

- Remove impurities through oil and grease using brake cleaning agents, if necessary, replace brake after finding out the cause of the contamination. Dirt deposits in the air gap between stator and armature plate impair the function of the brake and must be removed.
- After replacing the rotor, the original braking torque will not be reached until the run−in operation of the friction surfaces has been completed. After replacing the rotor, run−in armature plates and flanges have an increased initial rate of wear.

Checking the rotor thickness

DANGER! The motor must not be running when checking the rotor thickness.

- Remove the motor cover and seal ring (if mounted).
- Measure the rotor thickness with a caliper gauge. On brakes with friction plates, observe edging on outer diameter of friction plate.
- Compare measured rotor thickness with minimally permissible rotor thickness. *See Table 7-2.*.
- Replace the complete rotor if necessary.

Check the air gap

- Measure the air gap "$s_{Lü}$" between armature plate and rotor using a feeler gauge (see chapter 3.3).
- Compare the measured air gap to the maximum permissible air gap "$s_{Lümax.}$" (see table below).

- If necessary, adjust the air gap to "sLürated".

Brake type	sLürated +0.1mm -0.05mm	sLümax Service brake	Max. adjustment permissible wear	Rotor thickness		Excess of the adjuster nut $h_{Emax.}$ [mm]
				min. 1) [mm]	max. [mm]	
INTORQ BFK458-25	0,4 mm (1/64”)	1,0 mm (3/64”)	4,0 mm (5/32”)	12 mm (15/32”)	16 mm (5/8”)	17 mm (43/64”)

TABLE 7-2.

SECTION 8 LASER INFORMATION

SEMICON SP. Z O. O., 43/43a, Zwolenska Str., 04-761 Warsaw, Poland
T +48 22 615 73 71, +48 22 615 64 31, F +48 22 615 73 75, info@semicon.com.pl
PRODUCTION BUSINESS UNIT, 71a Ezopa Str., 04-805 Warsaw, T +48 22 825 24 64

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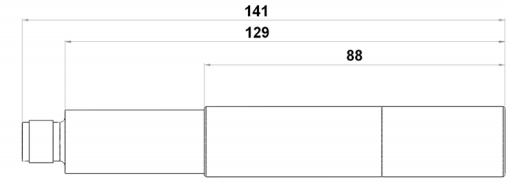
LP-520L-10

Industrial hermetic focusable laser line generator with rectilinearity correction.

Laser for industrial applications.



Technical data:

- Safety Class 2M from EN 60825-1:2014;
- Wavelength λ=520nm;
- Average Output Power 10mW;
- Operating Voltage 9V÷28VDC;
- Operating Current <100mA;
- Optics: aspherical acrylic lens F=8mm; NA=0,28; rod lens ϕ5;
- Line generating angle ~90^{o} ;
- Possibility to adjust the focus from few cm to several meters (external focus mechanism);
- Dimensions Φ20 x 130;
- International Protection Rating IP65;
- Aluminium housing (black anodized);
- Chromed brass mounting M18 x 1;
- Operating temperature: 0 do +60°C;
- Storage temperature: -40 do +85°C;
- Laser diode electrically isolated from housing;
- M12 plug, 4-pin M12 x 1;
- Pin configuration:
  - 1: voltage supply (+)
  - 3: voltage supply (-)

OPTIONS:

- different optical power, wavelength, line generating angle, gaussian or uniform line optics,

- modulation.

RAIFFEISEN BANK POLSKA S.A.
PLN 96 1750 0009 0000 0000 0272 8238, EUR 15 1750 0009 0000 0000 0272 8338
USD 55 1750 0009 0000 0000 0272 8297, CHF 90 1750 0009 0000 0000 0272 8346
NIP PL5260303208, D&B 422320739

Annex B (informative)

Safe working practice

General information:

All edger's operators have to be:

a) trained in edger operation and adjustment;

b) advised of factors which have an effect on noise level, e.g.:

proper blade choise;

optimum blade speed;

edger maintenance;

c) informed about dustiness factors, e.g.:

type of edging material;

dust chute efficiency (near the dust source);

hoods/barriers/chutes proper adjustment;

switching the dust installation on before using edger.

Important:

d) Floor around the edger must be level, in good condition and free of debris;

e) Proper top or spot-lighting;

f) Material for edging and edged boards should be next to operator's position.

Operator has to:

g) use safety equipment, if necessary:

1) ear protection - lower the risk of hearing loss;

2) respiration protection - lower the risk of harmful dust inhalation;

3) gloves for blade handling (blades should be carried in special brackets if it is possible);

4) overall, e.g. chain mail or leather overall;

h) stop the edger if started unintentionally;

i) notify about all edger's damage, including covers or blades damages, as soon as noticed

j) make allowance for safety procedures during cleaning, maintenance, sawdust and dust

removal to avoid fire hazard;

k) observe manufacturer’s manual for operating, adjusting and reapiring the blades;

l) do not exceed the max. rotational speed, marked on blades;

m) use only properly sharpened blades;

n) cause all spacers and spindle rings have to be in accordance with manufacturer’s guidelines

o) do not remove sawdust and other objects from the machine if edger is running;

p) check if covers and other safety devices, necessary for edger’s work, are in places, operational and in good condition.

EC declaration of conformity

according to EC Machinery Directive 2006/42/EC, Annex II, 1.A

Manufacturer:

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

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

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

We, the undersigned herewith declare, that:

Designation of the machine:	**Industrial Edger**
TYPE:	EG400EH30S-T
No. of manufacturer:	……..

Is in conformity with the following EC directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2014/30/EU
And is in conformity with the following Harmonized Standards:	PN-EN ISO 12100:2012; PN-EN 1870-4:2012; PN-EN ISO 14120:2016-03; PN-EN 349+A1:2010; PN-EN ISO 13849-1:2016-02; PN-EN 60204-1:2010; PN-EN ISO 13857:2010;
Notified Body according to annex IV:	INSTYTUT TECHNOLOGII DREWNA Centrum Certyfikacji Wyrobów Przemysłu Drzewnego ul. Winiarska 1, 60-654 Poznań
Notification No:	1583
EC type-examination certificate no.:	0427/2015
Responsible for Technical Documentation:	Tomasz Agaciński / Engineering Manager Wood-Mizer Industries Sp. z o.o. 62-600 Koło, Nagórna 114, Poland Tel. +48 63 26 26 000
Place/Date/Authorized Signature:	Koło, 09.04.2015
Title:	Engineering Manager