

# **Wood-Mizer<sup>®</sup> Toothsetter**

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

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**BMT 150-1**

**Rev. A1.00**

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

*Form # 150*

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

### 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:

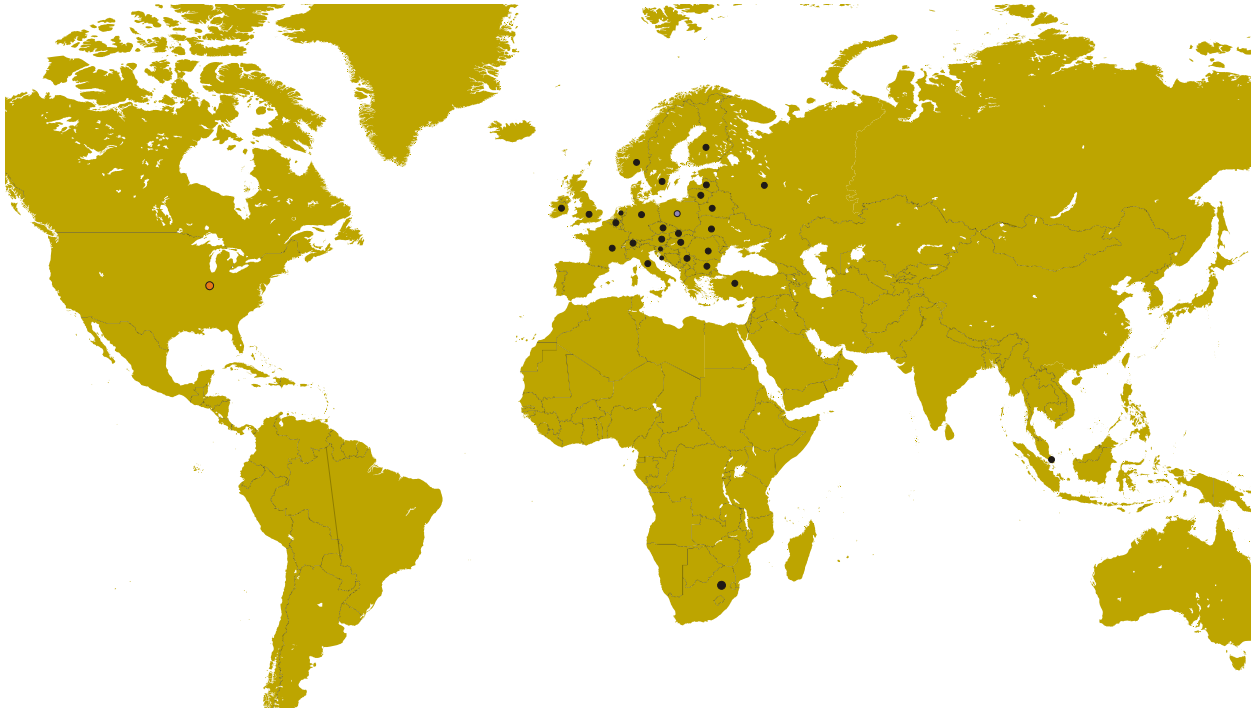
- Visa, Mastercard, or Discover
- COD
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Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

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## 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®<sup>1</sup> equipment. 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.

This equipment is designed to work with Wood-Mizer blades only.



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

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



## SECTION 2 GENERAL INFORMATION

### 2.1 Safety



This symbol calls your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions. This symbol accompanies a signal word. The word **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 to persons or equipment. Read all safety instructions before operating this equipment and observe all safety warnings!

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

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

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

- Blade Handling
- Machine Operation

#### Blade Handling



**WARNING!** Always wear gloves and eye protection when handling bandsaw blades. Keep all persons away from area when coiling or carrying a blade.

**WARNING!** Before installing the blade, inspect it for damage and cracks. Always handle the blade with extreme care. Use suitable carrier equipment for transporting the blades.

#### Machine Operation



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

**DANGER!** Keep all persons away from moving parts when operating this machine. Failure to do so will result in serious injury.

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



**WARNING!** Always wear eye protection when operating this machine. Failure to do so may result in serious injury.




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

**WARNING!** The toothsetter should be operated only by adults who have read and understood the entire operator's manuals.

**WARNING!** The illumination at the operator's position should be at least 300 lux. The light source can not cause stroboscopic effect.

**Toothsetter Decals**

See Table 2-1. The Toothsetter decals are shown below.

Decal	Part Number	Description
	<p>069680</p>	<p><b>WARNING!</b> Secure all loose clothing and jewelry before operating this machine. Failure to do so may result in serious injury or death.</p> <p><b>WARNING!</b> Always wear gloves and eye protection when handling bandsaw blades.</p> <p><b>WARNING!</b> Read the entire Operator's Manual before operating the equipment. Take notice of all safety warnings throughout this manual and those posted on the equipment. Keep this manual with this equipment at all times, regardless of ownership.</p>
	<p>069685</p>	<p><b>WARNING!</b> Read the entire Operator's Manual before operating the equipment. Take notice of all safety warnings throughout this manual and those posted on the equipment. Keep this manual with this equipment at all times, regardless of ownership.</p>
	<p>P85070</p>	<p>CE Safety Certification</p>

# 2

## General Information

### Safety

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**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.

## 2.2 Component ID

See Figure 2-1. Major components of the toothsetter are shown below:

1. Feed/Setter Handle,
2. Index Slide,
3. Blade Rest Pins,
4. Blade Support Arms,
5. Toothset Gauge,
6. Front Clamp,
7. Blade Height Adjustment Knob,
8. Toothset Adjusters.

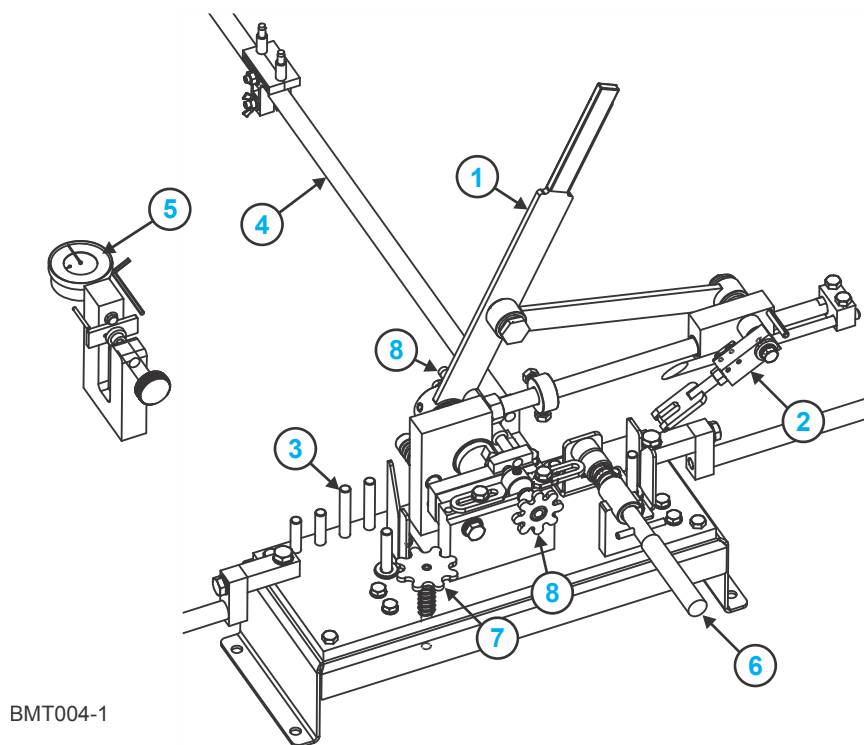


FIG. 2-1

### 2.3 Dimensions and Specifications

See Figure 2-2. Dimensions of the Dual Setter are shown below.

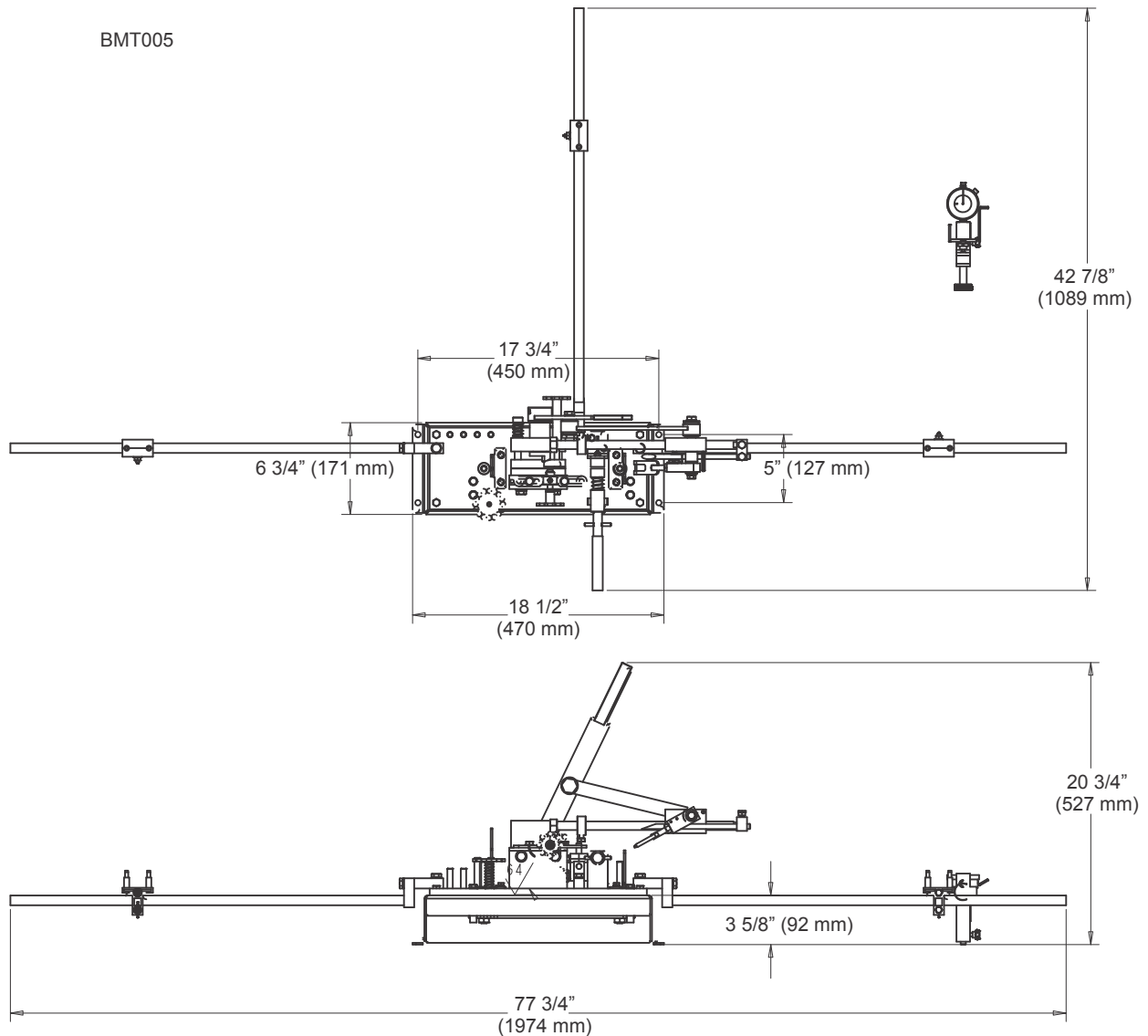


FIG. 2-2

See Table 2-2. The overall dimensions and weight are listed below.

	Length	Width	Height	Weight
<b>BMT150-1</b>	42 7/8" (1089 mm)	77 3/4" (1974 mm)	20 3/4" (527 mm)	lbs. ( kg)

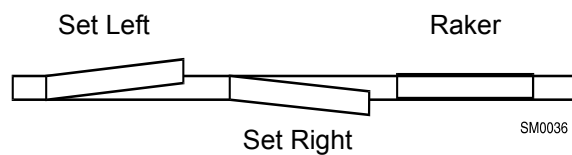
## SECTION 3 OVERVIEW

### 3.1 Toothsetter Introduction

There are four steps to maintaining blades used on the Wood-Mizer sawmill. They should ALWAYS be followed in this order:

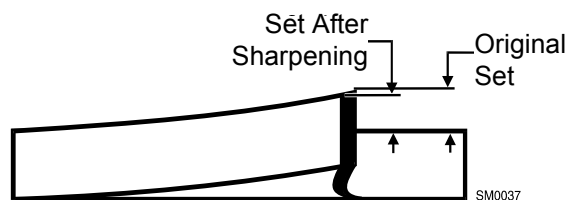
1. Blade Cleaning
2. Sharpening
3. Deburring
4. Toothsetting

**See Figure 3-1.** The blades supplied by Wood-Mizer have a raker-style set in the teeth. If you look at a blade from the top, you will see that the teeth are set (or bent out) in a repeating sequence; straight, left and right. The teeth that are set left and right do the cutting. The straight teeth (rakers) clear the cut of sawdust.



**FIG. 3-1**

**See Figure 3-2.** As the blade is sharpened, the tip of the tooth recedes and the set becomes smaller. Correct setting is one of the most important factors in the cutting ability of a blade. Check used blades regularly to see if they need resetting.



**FIG. 3-2**

### **3.2 Deburring The Blade**

Sharpening leaves tiny metal burrs on the back side of the teeth. New blades also have burrs. These burrs **MUST** be removed before the set is checked. If they are not removed, they may cause the toothsetter to give false readings.

To remove burrs, take the blade from the Sharpener. Invert it, so that the inside of the blade is facing out. Drag a stick of hardwood across the blade in the opposite direction that the teeth cut. (Use the weld in the blade as a reference point for starting and stopping.)

Cutting with the blade also removes burrs. If the blade you are about to set has been used after sharpening, you will not need to deburr it. Clean the blade before removing from the mill by running the Water Lube Option for 15 seconds. Remove the blade and wipe dry with a rag to prevent rusting.



## SECTION 4 SETUP

### 4.1 Toothsetter Mount

Place the setter on a table or workbench sturdy enough to support the weight of the machine. Be sure there is enough room on either side of the setter to allow for the blade to travel. If desired, the unit can be bolted to the table through the holes provided in the bottom of the base frame.

### 4.2 Blade Support Installation

Install the threaded blade arm mounting blocks (1) to the toothsetter. Attach the three blade support arms (2) to the mounting blocks.

See Figure 4-1.

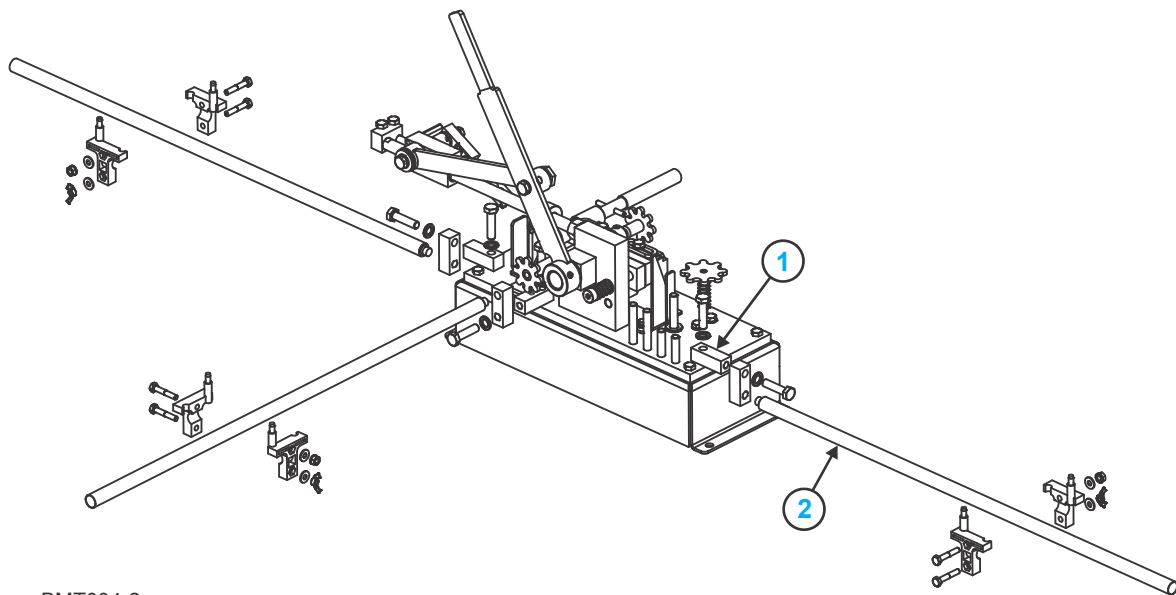


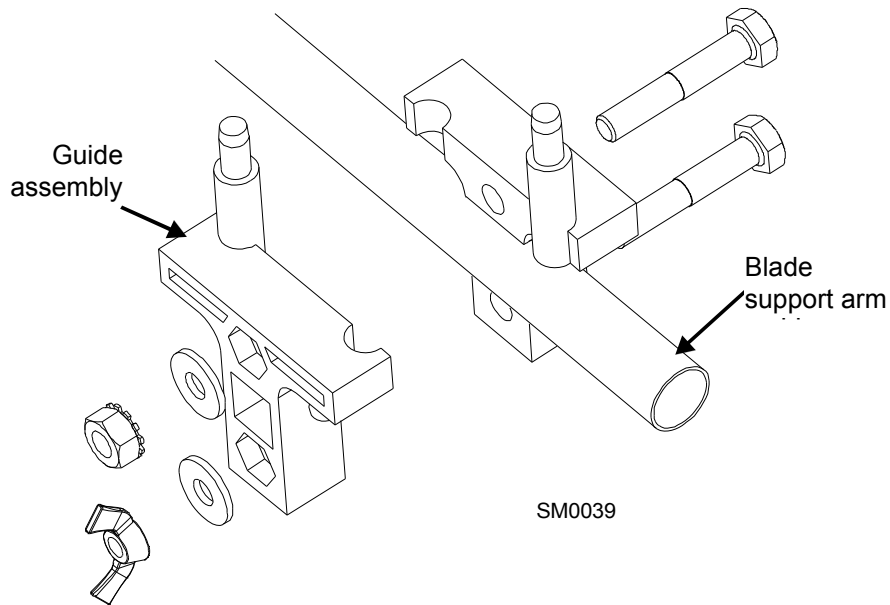
FIG. 4-1 BMT150-1

# 4

## Setup

### Blade Support Installation

**See Figure 4-2.** Assemble a blade support guide onto the end of each blade support arm. Bolt from the hexed side of the guide assembly. Tighten the top bolts with the self-locking nuts. Tighten the bottom bolts with the wing nuts.



**FIG. 4-2**

The guides should be about 1" (2.5 cm) from the ends of the right and rear tubes and about 2.5" (6.0 cm) from the end of the left tube. Final adjustments will be made later.

### 4.3 Gauge Calibration

The tooth set gauge accurately measures the set of any blade tooth. The gauge needs to be assembled and calibrated before use.

**See Figure 4-3.** Insert the dial gauge assembly into the hole in the block housing. Clamp the calibrating pin in position at the center of the dial gauge foot. Push the gauge assembly forward until the foot just touches the pin and dial needle moves .005 to .010. Tighten the locking screw with the provided hex wrench (do not over-tighten). Loosen the dial lock on the gauge and rotate the dial face until the needle reads zero. Tighten the dial lock.

Unclamp the calibrating pin from the set master gauge clamp by turning the clamp knob counterclockwise. With the pin not clamped, the set master gauge needle should read between -.005 and -.010. If not, reclamp the pin, loosen the locking screw and move the set master gauge assembly back so the foot does not contact the pin. Repeat the steps above until the dial needle reads zero with the calibrating pin clamped and between -.005 and -.010 without the pin clamped. This ensures the dial foot extends beyond the clamp plate a slight amount and will read zero when the foot is aligned with the clamp plate.

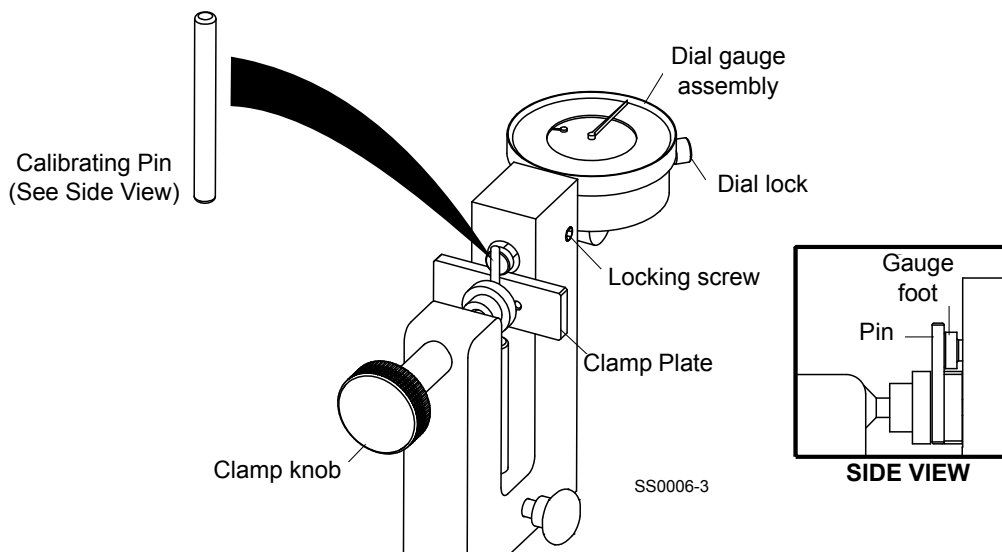


FIG. 4-3

## SECTION 5 OPERATION



**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.

Once the toothsetter alignments have been checked and adjustments have been made, you are ready to measure and set blades.

Sharpening removes metal from the face of the tooth. This eventually reduces the set to a point where the blade will not cut very well. Set should not vary more than  $(\pm)0.002$  from one tooth to the next and  $(\pm)0.002$  from one side of the blade to the other side.

The following steps will take you through operation of the toothsetter.


**Note:** Refer to the [Wood-Mizer® Blade Handbook](#) for recommended set specifications for your sawing application.

### 5.1 Blade Installation

1. **Clean the blade and deburr before putting it in the toothsetter.** Otherwise, sap buildup on the blade or tooth will give false set readings. Metal burrs created by sharpening also will cause false readings.

**Mount the blade in the toothsetter.** Place blade between the clamping plates and on the three guide assemblies.

## 5.2 Toothsetter Adjustment and Operation

 **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.

See Figure 5-1.

1. **Mount the blade in the toothsetter.** Pull the blade clamp handle (1) open and flip the index arm (2) up. Place the blade between the clamping plates and on the three guide assemblies. Release the blade clamp handle (1) to secure the blade in place.

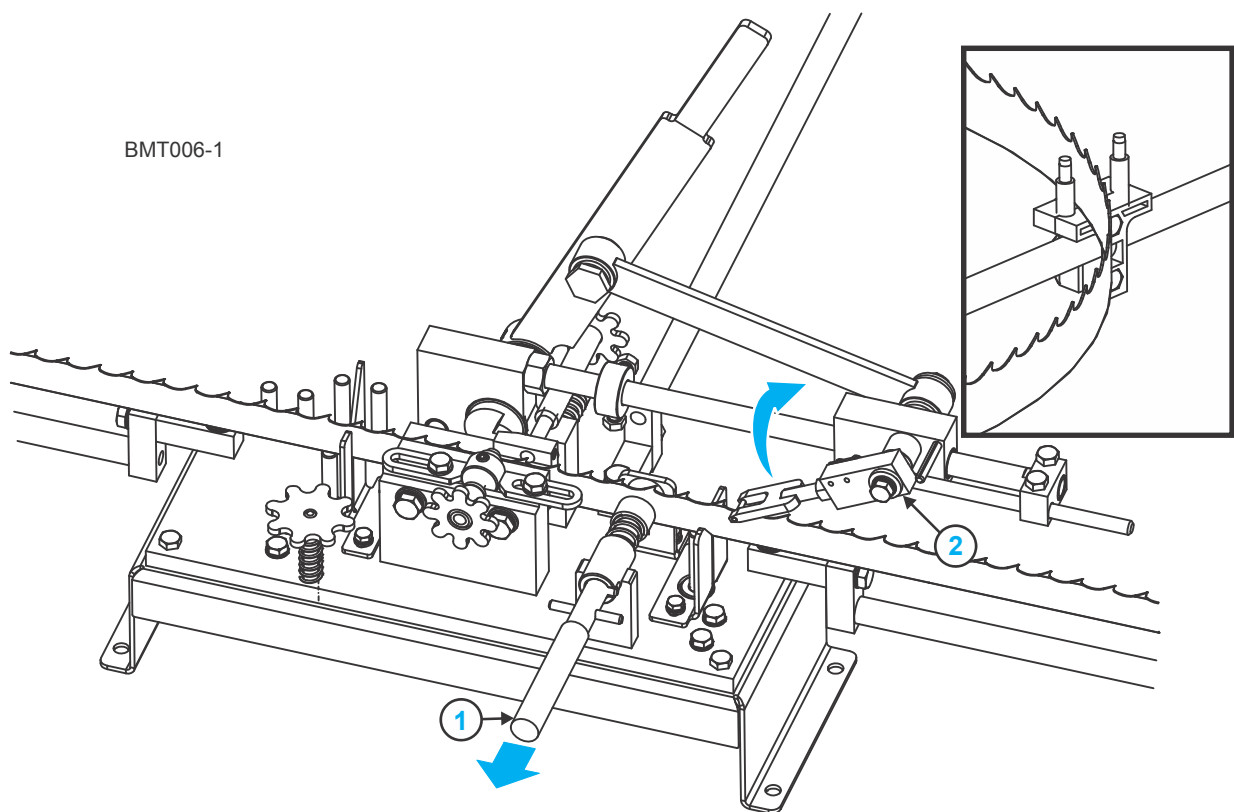


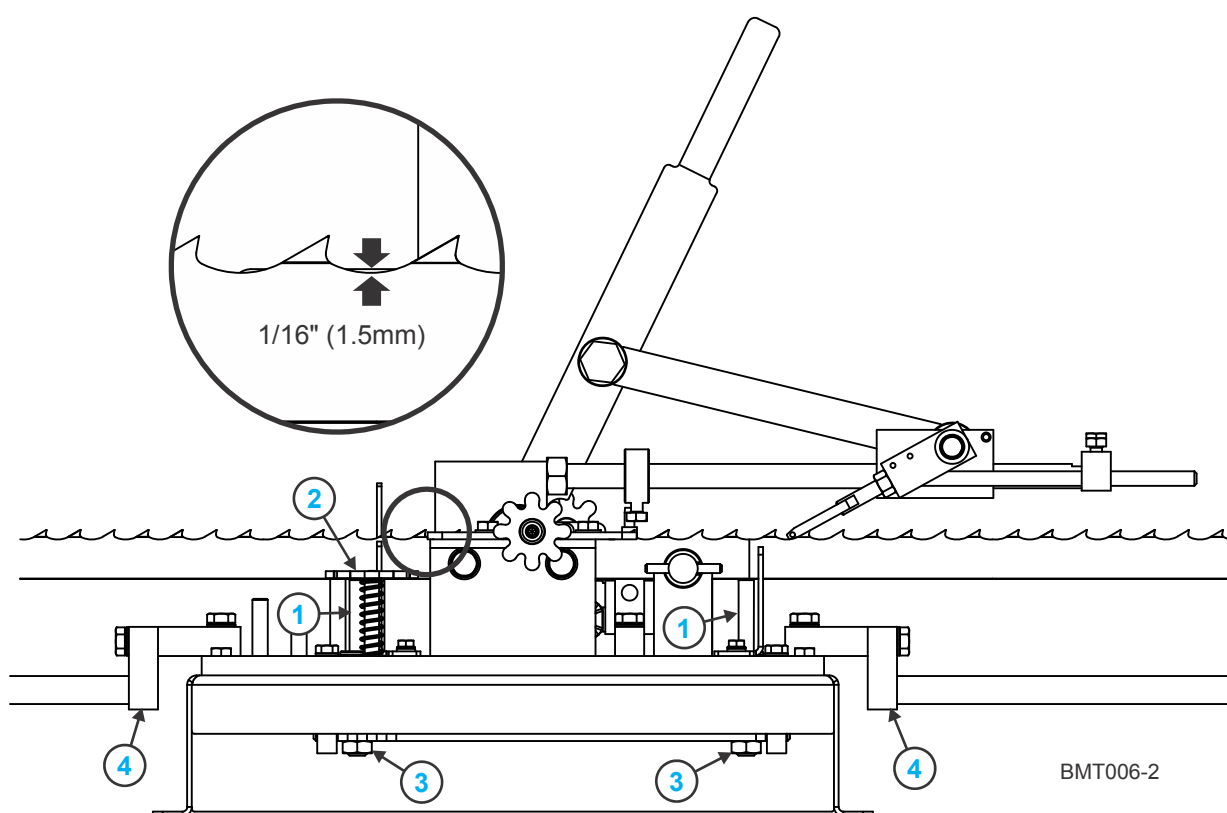
FIG. 5-1

## 5 Operation

### Toothsetter Adjustment and Operation

See Figure 5-2.

2. **Adjust the blade rest pins.** Rest the blade evenly on the two blade rest pins (1) on each side of the clamp. Use the blade height adjustment knob (2) to adjust the rest pins until the gullet of the blade lies just below the top of the clamp plates (approximately 1/16" (1.5mm) below setter clamp plate). (Deburring will remove burrs from the back side of the teeth, but may not remove burrs from the gullet area.) **NOTE:** Make sure the blade is level. If necessary, use one of the rest pin adjustment nuts (3) to raise or lower one of the blade rest pins to level the blade.



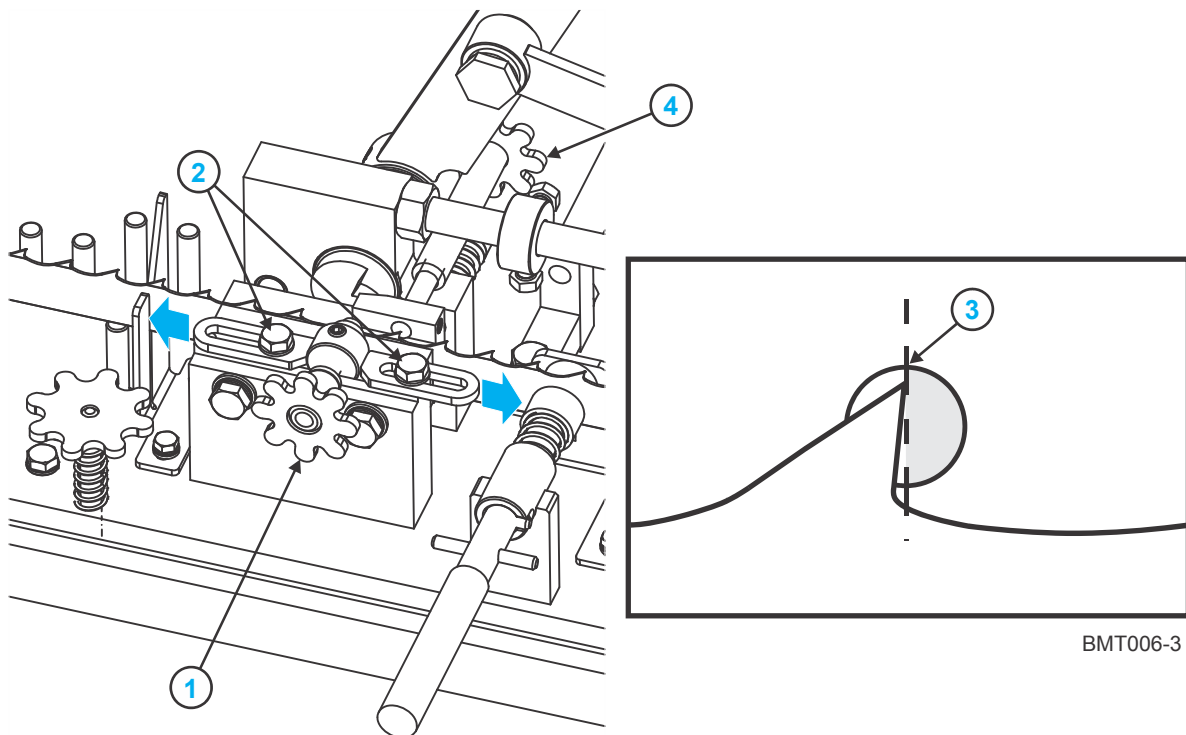
BMT006-2

FIG. 5-2

3. **Make final adjustments to blade support arms and guide assemblies.** Adjust to assure the blade travels smoothly. Pivot the blade arm mount blocks (4) as necessary to make sure the blade support arms are properly adjusted. Blade should rest on rear guide, but should not touch the bottom of either side guide assembly.

4. **Position the blade.** Turn the blade to bring a weld into the clamping/setting assembly. Use the weld as a reference point for starting and stopping. Start with the first tooth to the right of the weld that has been set back away from the operator.

**See Figure 5-3.** Position the teeth in front of the setter adjusters so their edges are aligned with the center of the setting point (3). **NOTE:** The setter is factory-set for Wood-Mizer® Industrial blades with 7/8" tooth spacing. Once a rear-set tooth is indexed in front of the right setter adjuster, a forward-set tooth should be positioned in front of the left setter adjuster. To adjust the setter for different tooth spacing, loosen the two mount bolts (2) securing the left setter adjuster (1) to the blade clamp and slide the adjuster to position the setter adjuster behind a forward-set tooth and aligned with center of the setting point (3). Retighten the mounting bolts.



BMT006-3

**FIG. 5-3**

**NOTE:** Use the setter adjuster knobs (1 and 4) to increase or decrease the forward-set and rear-set tooth settings as necessary.

## 5 Operation

### Toothsetter Adjustment and Operation

5. The index arm is factory-set for Wood-Mizer® Industrial blades with 7/8" tooth spacing. Move the setter handle (1) all the way to the left to set the blade teeth and move the blade. Check the index arm is firmly against the tooth. To make small adjustments, loosen the index arm nut (3) and move the arm tight against the tooth. If necessary, adjust the locking collar (4) to stop the setter handle movement. To adjust the locking collar, loosen the two bolts on the locking collar and move the locking collar as necessary. Retighten the bolts.

See Figure 5-4.

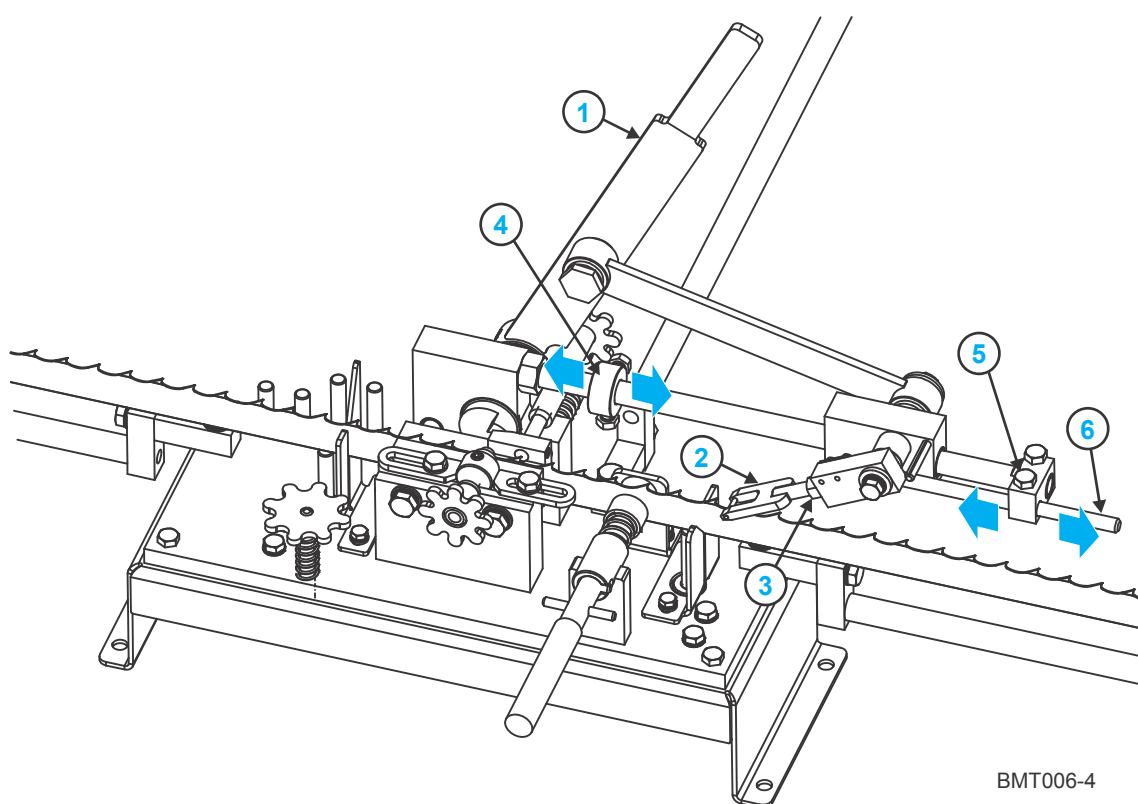


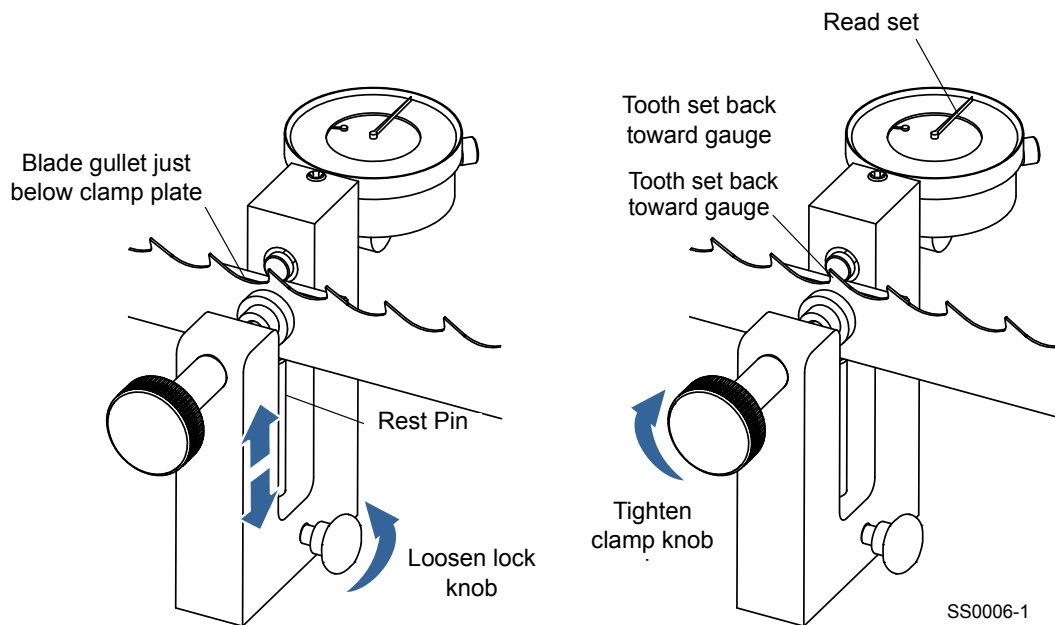
FIG. 5-4

Check if the index arm pushes the correct number of teeth. If necessary, loosen the adjustment bolt (5) and adjust the index lift rod (6) so the index arm pushes the blade to the next two teeth to be set. Retighten the adjustment bolt to secure the index lift rod in place.



- 6. Check the tooth set.** Move the setter handle all the way to the right to open the clamp. Disengage the blade clamp and mark the two teeth to be checked with a marker. Then move the blade to check the tooth set.

**See Figure 5-5.** Place the set master gauge around the blade to measure tooth set. Turn the lock knob counterclockwise to loosen and adjust the blade height rest pin up or down. Adjust so when the blade rests on the pin, the gullet of the blade is just below the clamp plate. Retighten the lock knob.



**FIG. 5-5**

Slide the set master gauge assembly through the blade and clamp on the right marked tooth. Turn the clamp knob clockwise to securely clamp the blade and read the set measurement displayed by the set master gauge. Note the tooth set measurement.

Loosen the clamp knob and remove the set master gauge assembly from the blade. Rotate the set master gauge to the other side of the blade to measure tooth set in the opposite direction. Find the sixth tooth (for blades with 7/8" tooth spacing) to the left set in the opposite direction and place the set master gauge around the blade to measure tooth set (blades with other tooth spacing may require a different tooth count). Note the tooth set measurement and mark the measured tooth with a marker. Loosen the clamp knob and remove the set master gauge assembly from the blade.



## **SECTION 6 MAINTENANCE**

### **6.1 Toothsetter Maintenance**

- Keep the toothsetter clean.
- Keep all moving parts lubricated with a light penetrating oil.
- Remove the clamping assembly occasionally and clean any debris that may have collected between the clamping plates.

## SECTION 7 REPLACEMENT PARTS

### 7.1 How To Use The Parts List

- Use the index above to locate the assembly that contains the part you need.
- 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.

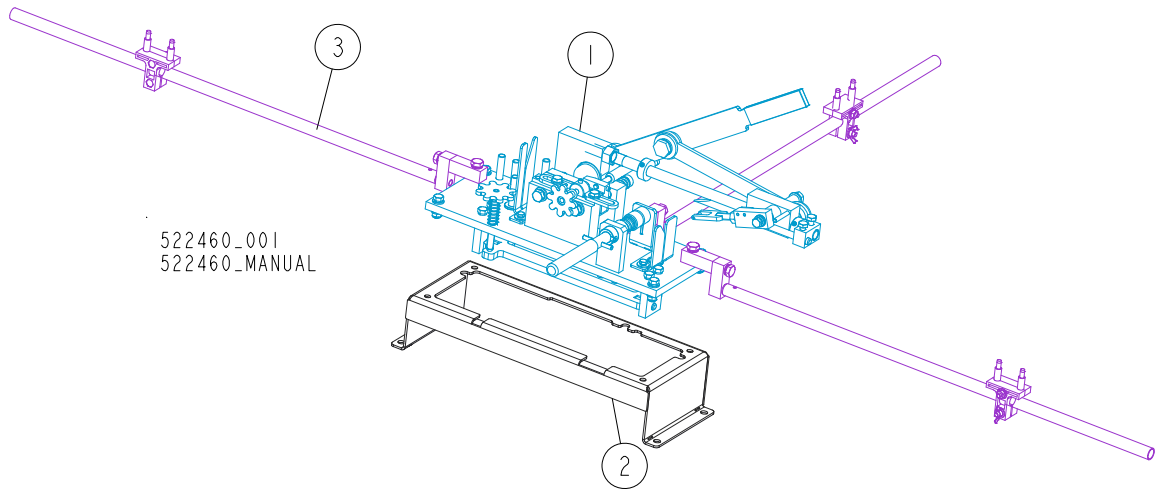
See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77.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

<b>7.2 Sample Assembly</b>				
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	Sample Assembly, Complete (Includes All Indented Parts Below)	A01111	1	
<b>7</b>	Sample Part	F02222-22	1	
	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
<b>8</b>	Sample Part (◆ Indicates Part Is Only Available With A03333)	S04444-4	1	◆
	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
<b>9</b>	Sample Part (◆ Indicates Part Is Only Available With K05555)	M06666	2	◆
<b>10</b>	Sample Part	F07777-77	1	



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

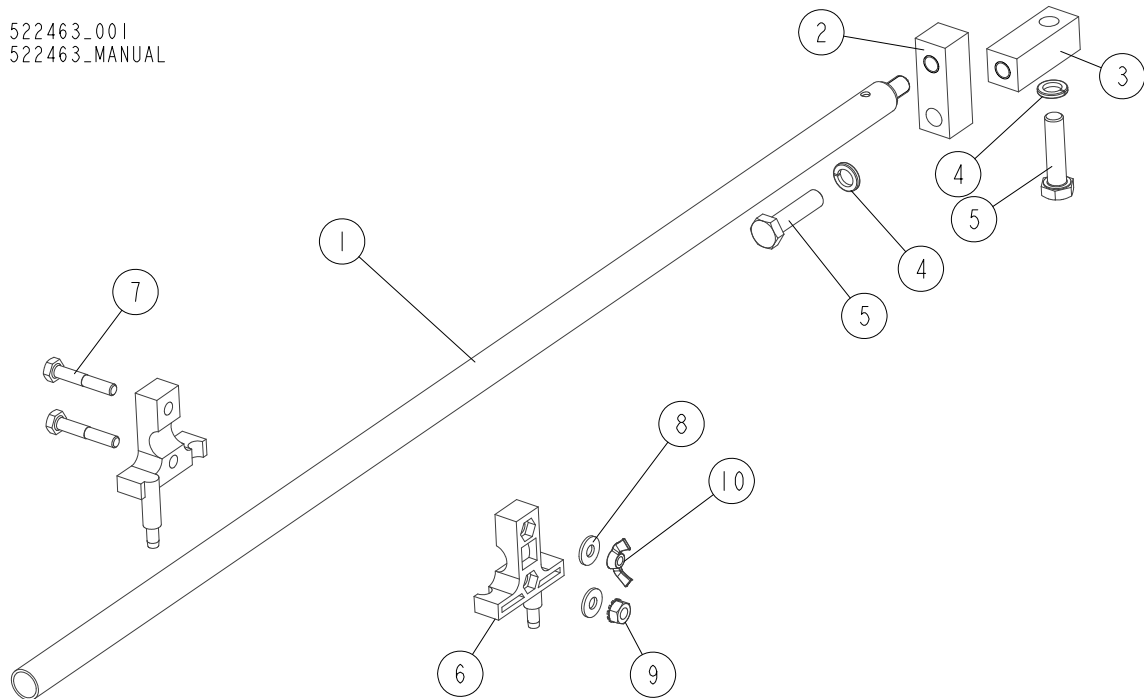
**7.3 Toothsetter**



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY	
	<b>TOOTHSETTER, BMT150-1</b>	<b>522460</b>	<b>1</b>	
<b>1</b>	TOOTHSETTER WITHOUT BASE & BLADE SUPPORT ARMS <a href="#">See Section 7.5</a>	522380	1	
<b>2</b>	BASE WELDMENT, TOOTHSETTER	522459-1	1	
<b>3</b>	ARM, BLADE SUPPORT - COMPLETE <a href="#">See Section 7.4</a>	522463	3	
	Gauge, Assy, Toothset	060490	1	

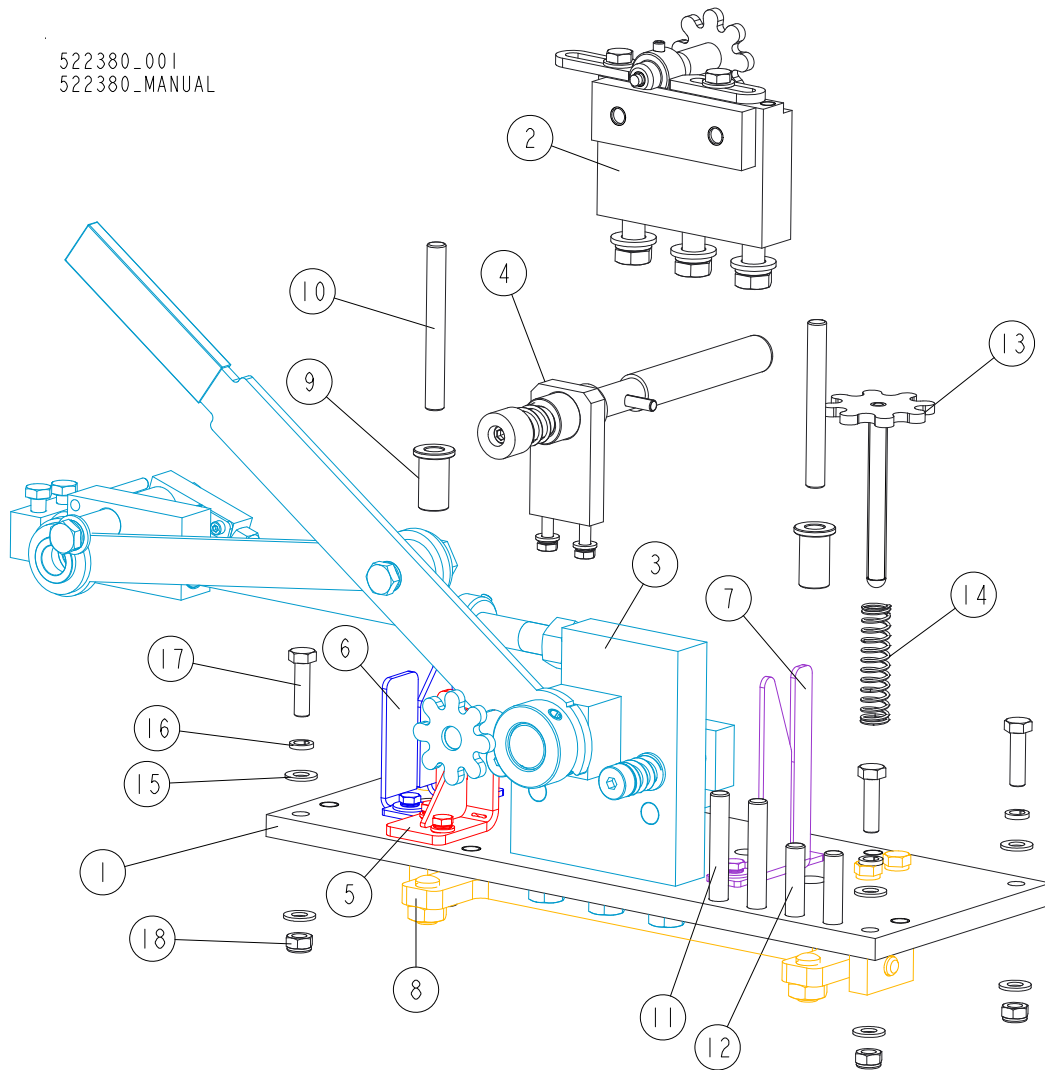
## 7.4 Blade Support Arm

522463\_001  
522463\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>ARM, BLADE SUPPORT - COMPLETE</b>	<b>522463</b>	<b>1</b>
1	TUBE WELDMENT, SHORT BLADE SUPPORT	087670-1	1
2	BLOCK	522462-1	1
3	BLOCK	522461-1	1
4	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	2
5	BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	2
	<b>SUPPORT, BLADE SINGLE</b>	<b>A30008</b>	<b>1</b>
6	GUIDE, BLADE SUPPORT W/ POST	S10611	2
7	BOLT, 1/4-20X1 1/2 HEX HEAD GRADE2	F05005-5	2
8	WASHER, 1/4 SAE FLAT	F05011-11	2
9	NUT, 1/4-20 KEPS	F05010-9	1
10	NUT, 1/4-20 WING	F05010-13	1

## 7.5 Toothsetter Without Base & Blade Support Arms

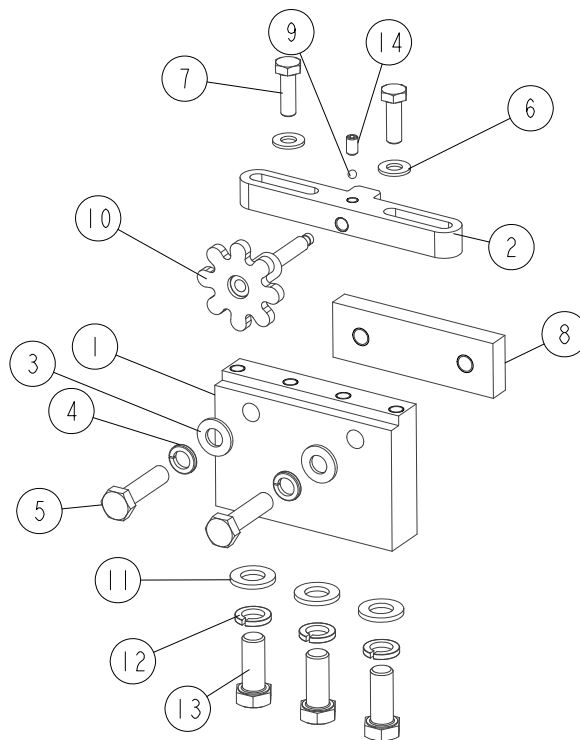


REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>TOOTHSETTER WITHOUT BASE &amp; BLADE SUPPORT ARMS</b>	<b>522380</b>	<b>1</b>
1	PLATE, BASE	522376-1	1
2	FRONT CLAMP ASSEMBLY <a href="#">See Section 7.6</a>	522375	1
3	CLAMP ASSEMBLY <a href="#">See Section 7.7</a>	522385	1
4	RIGHT FRONT CLAMP ASSEMBLY <a href="#">See Section 7.8</a>	522418	1
5	REAR CLAMP ASSEMBLY <a href="#">See Section 7.9</a>	522445	1
6	INFEED BLADE GUIDE <a href="#">See Section 7.10</a>	522420	1
7	OUTFEED BLADE GUIDE <a href="#">See Section 7.11</a>	522447	1
8	BLADE ADJUSTER ASSEMBLY <a href="#">See Section 7.12</a>	522453	1
9	BUSHING 10/16-32 FLANGE 22-3	522451-1	2
10	PIN, 10M6X90 DIN 6325 HRC60 DOWEL	F81048-90	2
11	PIN, 10M5X70 DIN 6325 HRC60 DOWEL	F81048-91	2
12	PIN, 10M6X50 DIN 6325 HRC60 DOWEL	F81048-92	2
13	ADJUSTER WELDMENT	522455-1	1
14	SPRING, .60ODX2-1/2X.098 WIRE	066816	1

REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY	
15	WASHER, 8.4 FLAT ZINC	F81054-1	8	
16	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4	
17	BOLT, M8X30-5.8-B HEX HEAD FULL THREAD ZINC	F81002-2	4	
18	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4	

## 7.6 Front Clamp Assembly

522375\_001\_A  
522375\_MANUAL

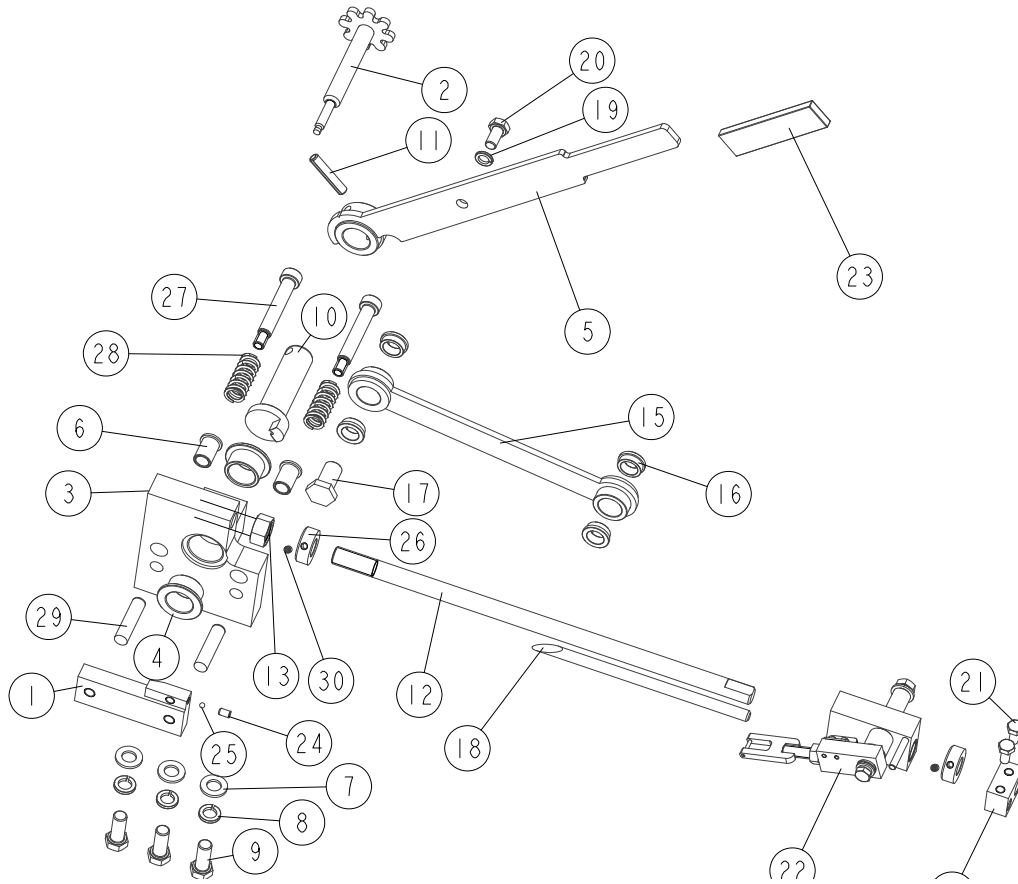


REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
-	<b>CLAMP ASSEMBLY, FRONT</b>	<b>522375</b>	<b>1</b>
1	BLOCK, FRONT CLAMP	522365-1	1
2	ADJUSTER WELDMENT, SETTER SCREW	522372-1	1
3	WASHER, 10.5 FLAT ZINC	F81055-1	2
4	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	2
5	BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	2
6	WASHER, 8.4 FLAT ZINC	F81054-1	2
7	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
8	BLOCK, FRONT CLAMP - FRONT	522366	1
9	BALL, N4.5 NYLON 6/6	522371	1
10	KNOB WELDMENT, SET ADJUSTER SHORT	522373	1
11	WASHER, 13 FLAT ZINC	F81056-1	3
12	WASHER, Z12.2 SPLIT LOCK ZINC	F81056-2	3
13	BOLT, M12X30 8.8 HEX HEAD FULL THREAD ZINC	F81004-22	3
14	SCREW, M6X10-45H HEX SOCKET ZINC SET W/FLAT POINT	F81001-26	1



## 7.7 Rear Clamp Assembly

522385\_001\_A  
522385\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>CLAMP ASSEMBLY</b>	<b>522385</b>	<b>1</b>
1	BLOCK, BACK CLAMPING	522381	1
2	ADJUSTER ASSEMBLY, SETTER LONG	522374	1
3	BLOCK WELDMENT, BACK CLAMP	522390-1	1
4	BUSHING 25/32-19 FLANGE 42-3, BRONZE	522384	2
5	ARM WELDMENT, INDEXER	522393-1	1
6	BUSHING 12/16-25 FLANGE 20-2, BRONZE	522383	2
7	WASHER, 13 FLAT ZINC	F81056-1	3
8	WASHER, Z12.2 SPLIT LOCK ZINC	F81056-2	3
9	BOLT, M12X30 8.8 HEX HEAD FULL THREAD ZINC	F81004-22	3
10	SHAFT, RAMP	522382	1
11	PIN, 8X45 ROLL ZINC	F81046-6	1
12	SHAFT, N16 INDEX GUIDE	522386-1	1
13	NUT, M16-8 HEX ZINC	F81036-1	1
14	BLOCK, INDEX	522389-1	1
-	<b>ARM ASSEMBLY, SETTER LINK</b>	<b>522400</b>	<b>1</b>
15	ARM WELDMENT, LINK	522396-1	1
16	BUSHING, 16/22-9 FLANGE 25-3 BRONZE	522399	4
17	SHAFT, PIVOT	522402-1	1
18	ROD, N10 INDEX LIFT	522401-1	1

## 7

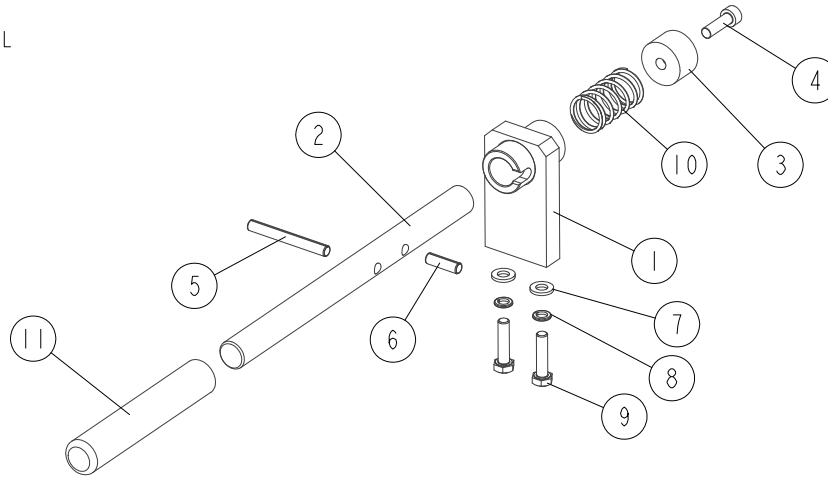
**Replacement Parts***Rear Clamp Assembly*

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REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY	
19	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	1	
20	BOLT, M10X20-5.8 HEX HEAD FULL THREAD ZINC	F81003-1	1	
21	BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC	F81002-20	2	
22	INDEX SLIDE ASSEMBLY	522410	1	
23	SLEEVE, VINYL GUARD	086875	1	
24	SCREW, M6X10-45H HEX SOCKET ZINC SET W/FLAT POINT	F81001-26	1	
25	BALL, N4.5 NYLON 6/6	522371	1	
26	RING, 16 PN-72/M-85101 RETAINING	522457-1	2	
27	BOLT, 12/M10X65 12.9 ISO7379 SHOULDER	F81003-112	2	
28	SPRING, .72ODX1-3/4LX.105 WIRE	066859	2	
29	PIN, 12M6X50 DIN6325 HRC60 DOWEL	F81048-83	2	
30	SCREW, M6X8-33H-GEOMET HEX SOCKET SET W/CONE POINT	F81013-1	2	

## 7.8 Right Front Clamp Assembly

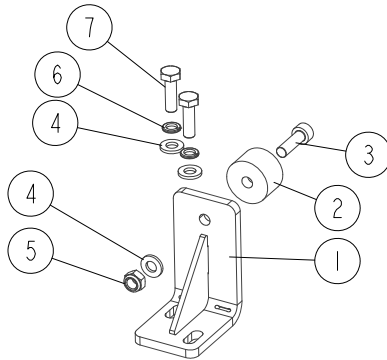
522418\_001  
 522418\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>CLAMP ASSEMBLY, RIGHT FRONT</b>	<b>522418</b>	<b>1</b>
1	CLAMP WELDMENT, BLADE	522415-1	1
2	SHAFT, BLADE CLAMP	522417-1	1
3	PAD, 1' DIA. WEAR	522416	1
4	SCREW, M6X20 8.8 HEX SOCKET HEAD CAP ZINC	F81001-22	1
5	PIN, 6X50 ROLL ZINC	F81045-1	1
6	PIN, 6X20 ROLL ZINC	F81045-6	1
7	WASHER, 6.4 FLAT ZINC	F81053-1	2
8	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	2
9	BOLT, M6X25 5.8 HEX HEAD FULL THREAD ZINC	F81001-3	2
10	SPRING, .85ODX.1-1/2LX.075 WIRE	066858	1
11	GRIP, SR1525 TYPE 7 HAND (# FCWA-0159-110)	522444	1

## 7.9 Rear Clamp Assembly

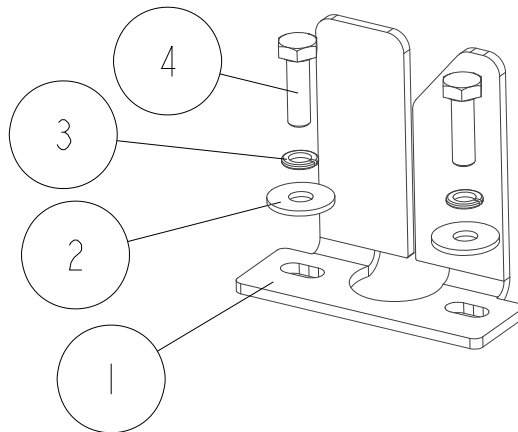
522445\_001  
522445\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>CLAMP ASSEMBLY, REAR</b>	<b>522445</b>	<b>1</b>
1	BRACKET WELDMENT	522443-1	1
2	PAD, 1" DIA. WEAR	522416	1
3	SCREW, M6X20 8.8 HEX SOCKET HEAD CAP ZINC	F81001-22	1
4	WASHER, 6.4 FLAT ZINC	F81053-1	3
5	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1
6	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	2
7	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	2

## 7.10 Infeed Blade Guide

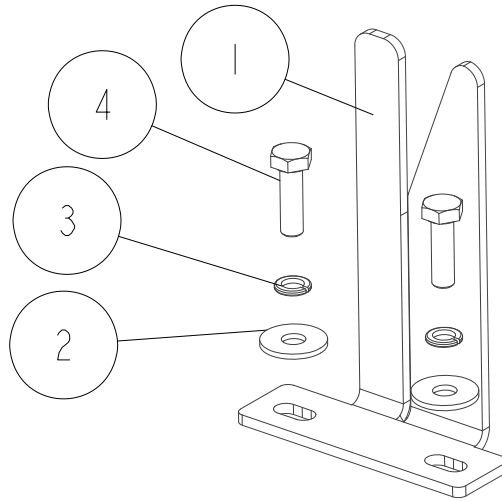
522420\_001  
 522420\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>PLATE ASSEMBLY, INFEED GUIDE</b>	<b>522420</b>	<b>1</b>
1	PLATE, INFEED GUIDE	522419-1	1
2	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	2
3	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	2
4	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	2

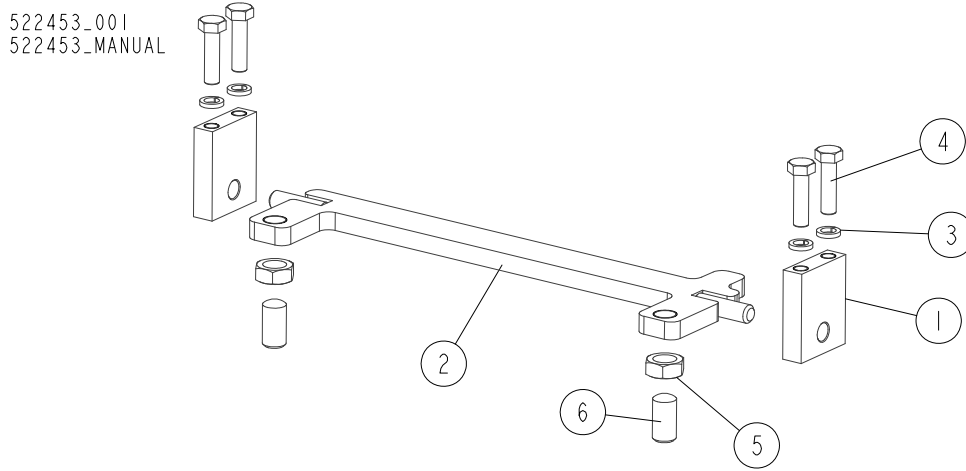
**7.11 Outfeed Blade Guide**

522447\_001  
 522447\_MANUAL



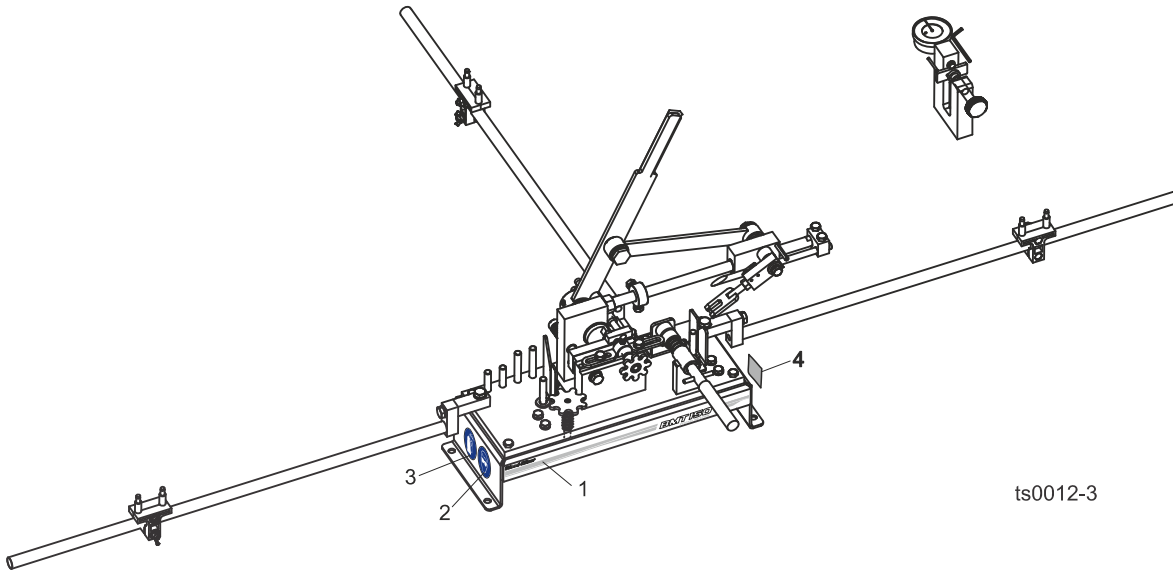
REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>PLATE ASSEMBLY, OUTFEED GUIDE</b>	<b>522447</b>	<b>1</b>
1	PLATE, OUTFEED GUIDE	522446-1	1
2	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	2
3	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	2
4	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	2

## 7.12 Blade Adjuster Assembly



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>ADJUSTER ASSEMBLY, BLADE</b>	<b>522453</b>	<b>1</b>
1	BLOCK, ADJUSTER MOUNT	522452-1	2
2	ADJUSTER WELDMENT, BLADE	522450-1	1
3	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4
4	BOLT, M8X30-5.8-B HEX HEAD FULL THREAD ZINC	F81002-2	4
5	NUT, 1/2-20 HEX JAM	F05010-16	2
6	SCREW, 1/2-20X1 SOCKET HEAD OVAL POINT, B/O	F05008-65	2

**7.13 Decals**



ts0012-3

REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>DECAL KIT, BMT150</b>	527689	1
1	DECAL, BMT150 TOOTHSETTER LOGO	527688	1
2	DECAL, EYE PROTECTION WARNING - SMALL	S12004G-1	1
3	DECAL, WEAR PROTECTIVE GLOVES	512107	1
4	DECAL, CE CERTIFIED SAWMILL	P85070	1



## EC declaration of conformity according to EC Machinery Directive 2006/42/EC

**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: **Dual Manual Setter**  
TYPE: BMT150  
No. of manufacturer: .....

### Is in conformity with the following EC directives:

EC Machinery Directive 2006/42/EC

### And is in conformity with the following Harmonized Standards:

PN-EN ISO 12100:2012  
PN-EN ISO 14120:2016-03  
PN-EN 349+A1:2010  
PN-EN ISO 13857:2010

Responsible for Technical Documentation: Tomasz Agaciński / Engineering Manager  
Wood-Mizer Industries Sp. z o.o.  
62-600 Koło, Nagórna 114, Poland  
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Place/Date/Authorized Signature:

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