

Dual Toothsetter

Safety, Operation, Maintenance & Parts Manual

BMT200
BMT250

Rev. A2.00
Rev. A2.00



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

Form #1792

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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®¹ 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.

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

Getting Service

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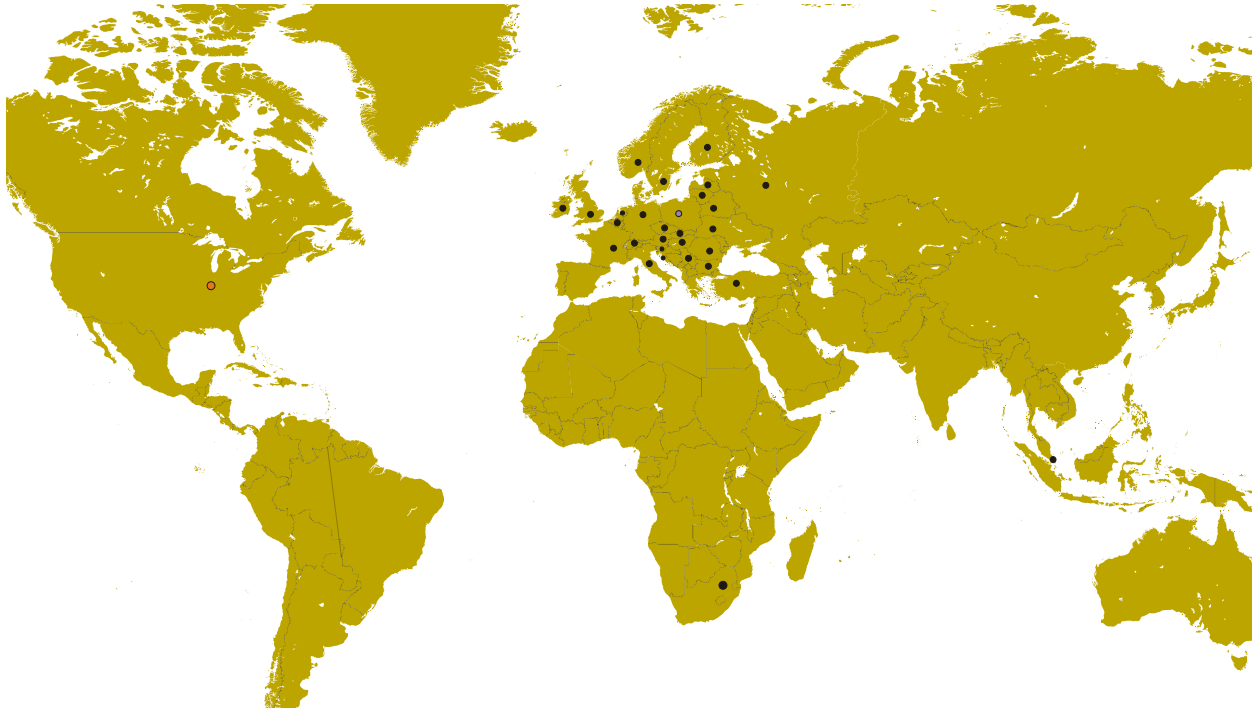
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Technical data are subject to change without prior notice.

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

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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:

- Electrical Safety
- Blade Handling
- Machine Operation

Electrical Safety (Optional Auto Feed Only)



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 can cause shock, burns, or death. SHUT OFF & LOCK OUT POWER before performing service in any area of this machine. DO NOT restore power until all access panels are replaced and secured.



WARNING! Always turn off and disconnect power at control console AND at main supply circuit breaker before

performing any service to the machine.

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.




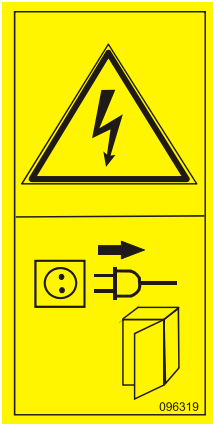
WARNING! The illumination at the operator's position should be at least 300 lux. The light source can not cause stroboscopic effect.

WARNING! If at any time you need to immediately stop the machine, press the Emergency Stop (E-Stop) button. Before operating the machine again, turn the E-Stop button clockwise to release. The machine will not start until the

E-Stop button is released.

Dual Toothsetter Decals

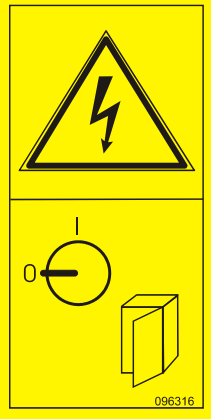



See Table 2-1. The Dual Toothsetter decals are shown below.

| Decal | Part Number | Description |
|---|-------------|---|
|  | S12004G | Always wear safety goggles when operating the equipment! |
|  | S12005G | Always wear protective ear muffs when operating the equipment! |
|  | 501465 | Always wear safety boots when operating the equipment! |
|  | 096319 | Always disconnect the power cord before opening the electric box! |

2

General Information

Safety

| | | |
|---|--------|---|
|  | 096316 | Do not open or close the electric box when the switch is not in the "0" position! |
|  | 509255 | Hand injury hazard |
|  | P85070 | CE Certified Machine (Small) |
|  | 053583 | Dual Setter Operation Direction |

2.2 Component ID

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

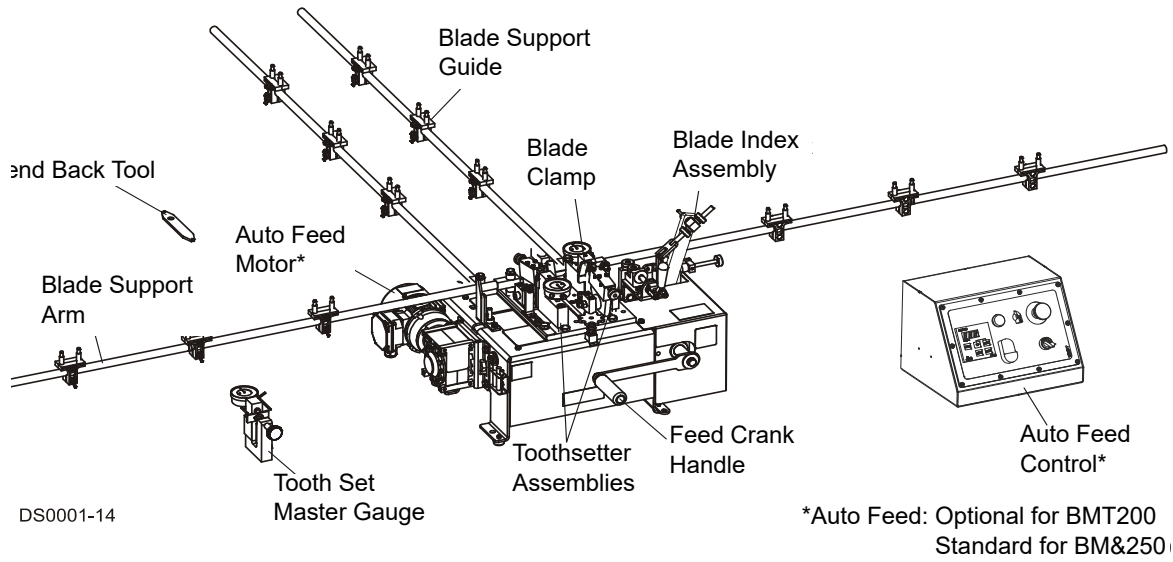


FIG. 2-1

2.3 Dimensions and Specifications

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

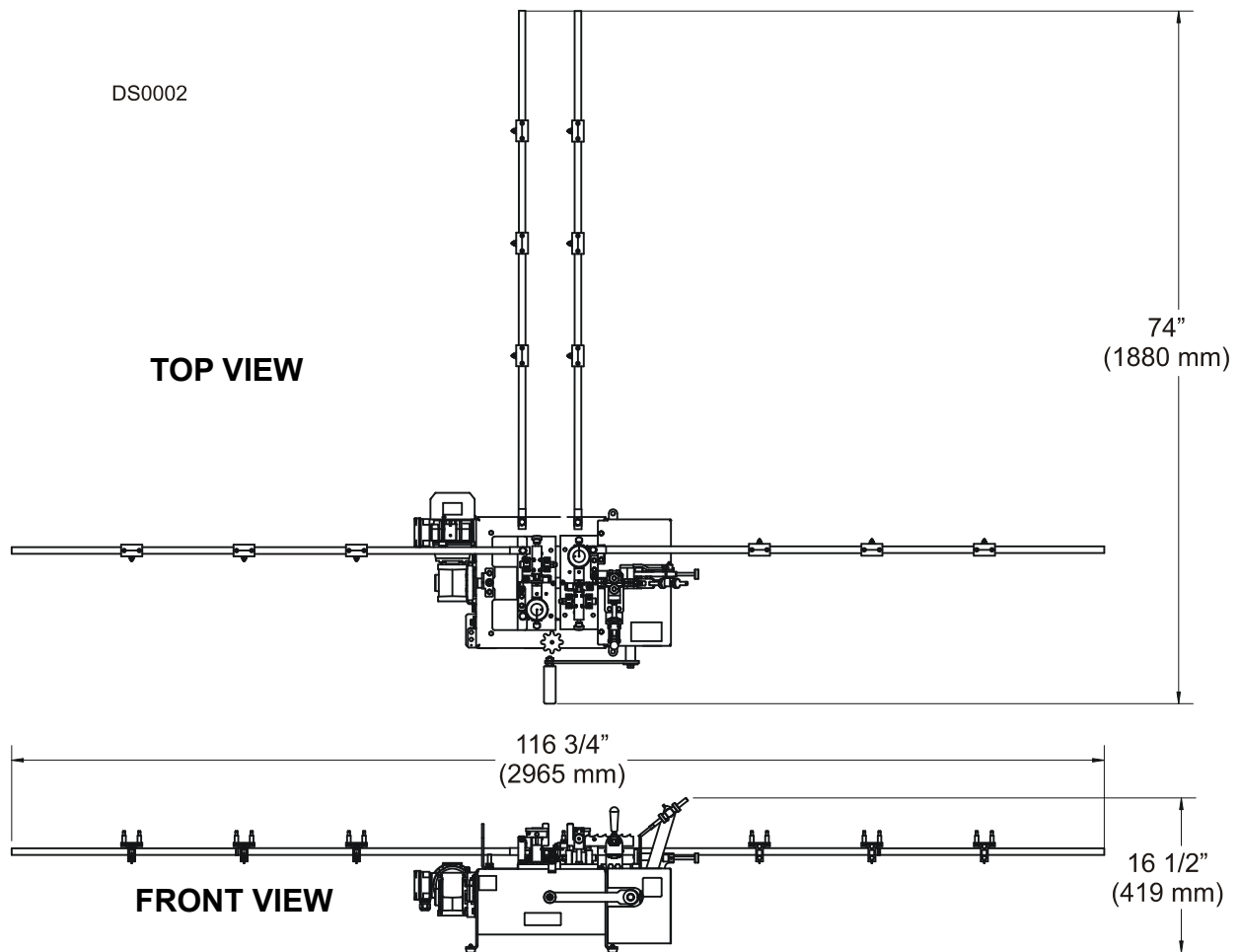


FIG. 2-2

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

| | Length | Width | Height | Weight |
|---------------|---------------|--------------------|------------------|--------------------|
| BMT200 | 74" (1880 mm) | 116 3/4" (2965 mm) | 16 1/2" (419 mm) | 90 lbs. (41 kg) |
| BMT250 | 74" (1880 mm) | 116 3/4" (2965 mm) | 16 1/2" (419 mm) | 105 lbs. (47.5 kg) |

See Table 2-3. The Dual Toothsetter models are listed below.

| Model | Voltage Code ¹ | Electrical Standard Code ² | Electrical Package | Description |
|---------------|---------------------------|---------------------------------------|--------------------|--|
| BMT200 | --- | --- | --- | Dual Toothsetter w/Manual Crank |
| BMT250 | M | U | EP | Automatic Dual Toothsetter (1 x 110V 60Hz) |
| BMT250 | A | S | EP | Automatic Dual Toothsetter (1 x 230V 50Hz) |

¹ M - 1 x 110V; A - 1 x 230V.

² U - UL (60Hz); S - CE (50Hz).

See Table 2-4. The motor specifications are listed below.

| Motor | Manufacturer | Model | Rated Output | Rated Current | Rated Speed |
|-----------------|-----------------------|------------|-------------------|--------------------------------|-------------|
| Electric | Besel S.A., Poland | SKh 63-4A2 | 0.16 HP (0.12 kW) | 0.80A at 230V 0.45A at 400V | 1380 RPM |

See Table 2-5. The noise level of the operating BMT250 Dual Toothsetter is listed below.¹

| Model | Noise Level |
|---------------|-------------|
| BMT250 | dB (A) |

See Table 2-6. The maximum electrical loads are listed below.

| Model | Maximum Load |
|-------------------------------------|--------------|
| BMT250 (1 x 110V AC 60Hz) | 6.8 Amps |
| BMT250 (1 x 220V AC 50/60Hz) | 3.95 Amps |



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

1. The figures quoted are emission levels and are not necessarily safe working levels. Although there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. Also, the permissible exposure level value may vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazards and risk.

SECTION 3 SETUP & OPERATION

3.1 Assembly

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.

The unit will rest on the rubber feet on the bottom of the machine. If desired, the unit can be bolted to the table through the holes provided in the bottom of the base frame.

Blade Support Arms

NOTE: The blade support arms supplied with the setter are capable of supporting most blades up to 1 1/2" wide. An upgrade kit is available to increase the support arm capability to support heavier blades ([See Section 6.1](#)).

See Figure 3-1. There are arm mounting locations at the right side, left side and rear of the machine. Install two spacer bushings and one arm mount block at each location. Secure each block with a provided 10mm lock washer and M10-1.5 x 80 hex head bolt.

NOTE: If setting very wide blades, you may need to exclude one or both of the spacers from each location to ensure the blade is positioned properly in the clamp. If installing the optional arm kit for heavier blades, replace the arm mounting blocks with the extension arms. Install the long extension arms to the left and right positions and the short arm to the rear position.

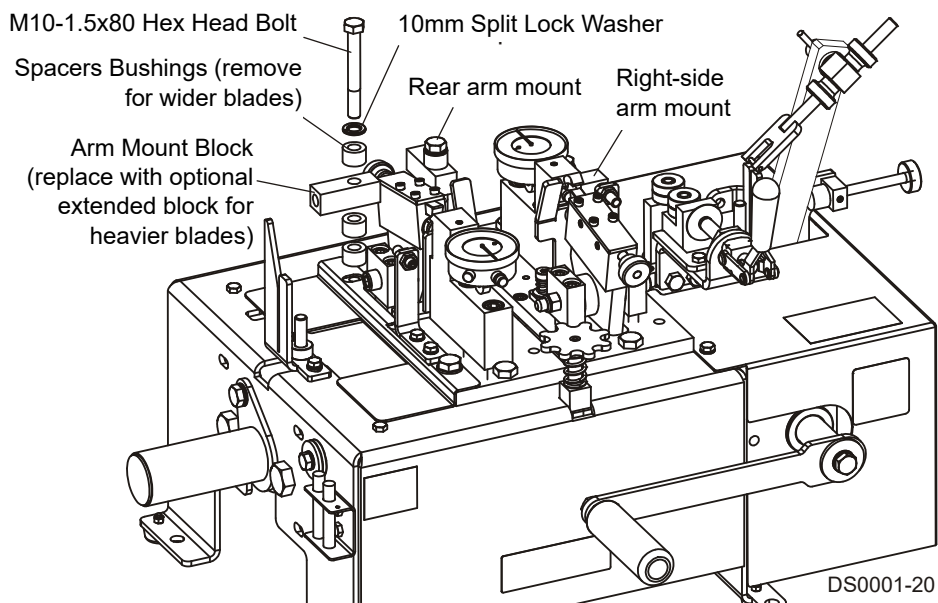


FIG. 3-1

See Figure 3-2. Thread a blade support tube into the threaded holes in the three mounting blocks. Assemble a blade support extension tube to each blade support tube.

NOTE: If installing the optional arm kit for heavier blades, assemble the blade support extension tubes to the extended mounting arms.

Install at least one blade support guide to each support tube with two 1/4-20 x 1 1/2" hex head bolts, flat washers, self-locking nut and wing nut. The position of the guides will be adjusted later. Three guide assemblies are provided for each arm so you can setup for different blade lengths without having to adjust the guide assembly.

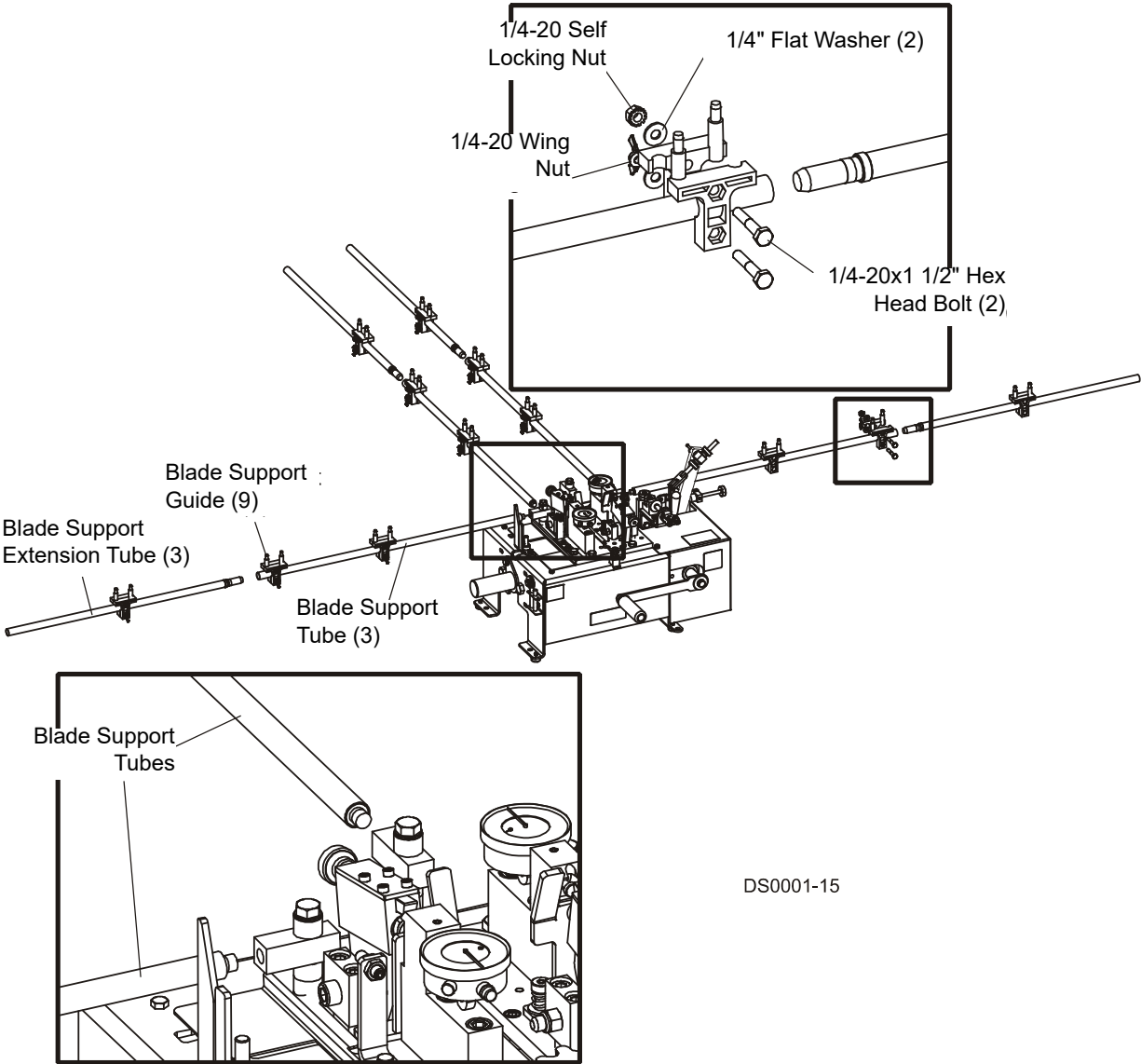


FIG. 3-2

3

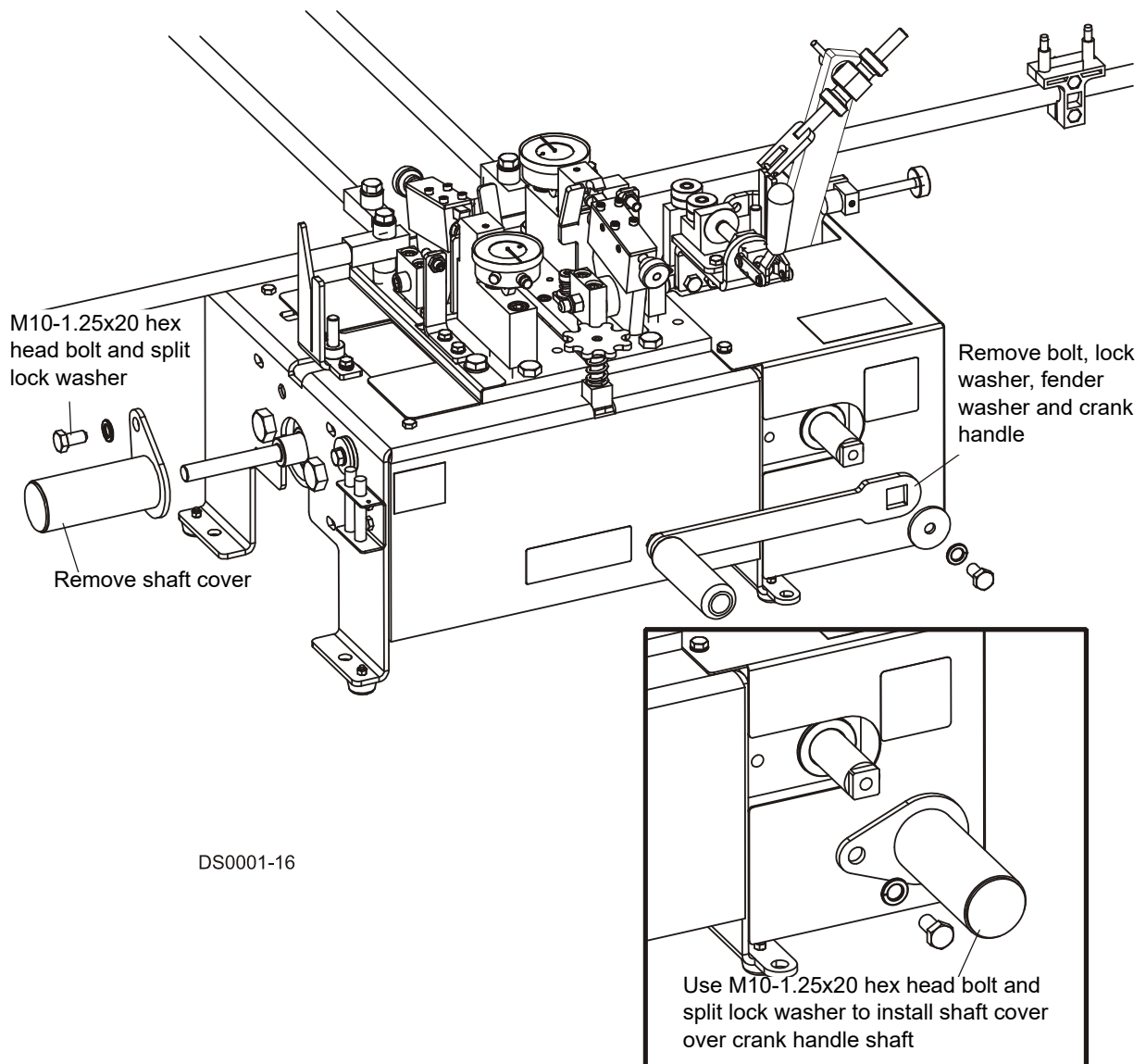
Setup & Operation

Assembly

Auto Feed Installation (Optional)

The Auto Feed Option includes an electric motor and control to automate the setting process.

See Figure 3-3. Before installing the Auto Feed, remove the manual feed crank handle. Disassemble the bolt, lock washer and fender washer to remove the handle. Remove the M10-1.25 x 20 hex head bolt, split lock washer and the shaft cover mounted to the left side of the setter assembly. Use the existing M10-1.25 x 20 hex head bolt and split lock washer to reinstall the shaft cover over the manual feed shaft.



DS0001-16

FIG. 3-3

See Figure 3-4. Install the motor mount plate to the feed motor with six M5-.8 x 10 hex head bolts and #10 split lock washers.

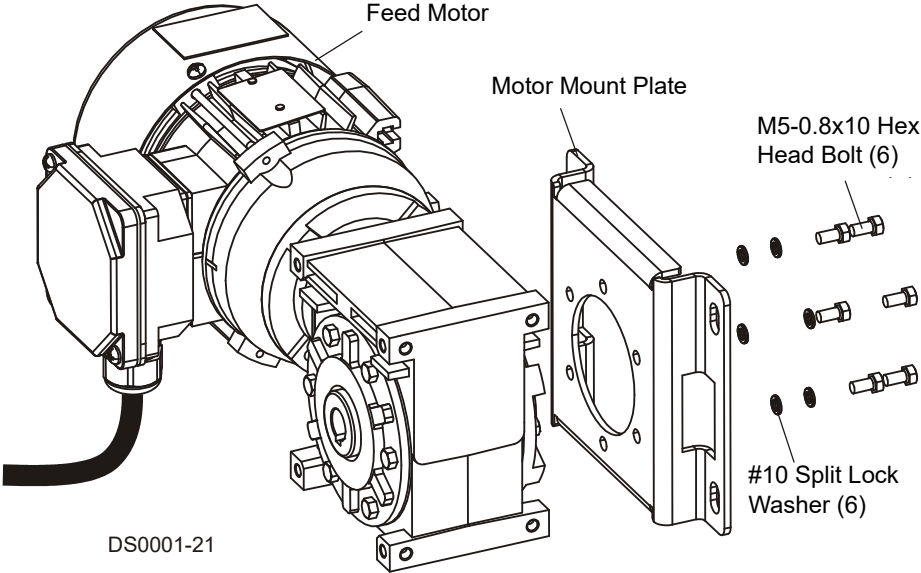


FIG. 3-4

See Figure 3-5. Install two 5 x 5 x 25mm round end keys to the feed shaft and slide the motor with the mount plate onto the feed shaft. Secure the motor to the setter base with eight M8 flat washers, four M8-1.25 x 20 hex head bolts and four M8 hex nylon nuts.

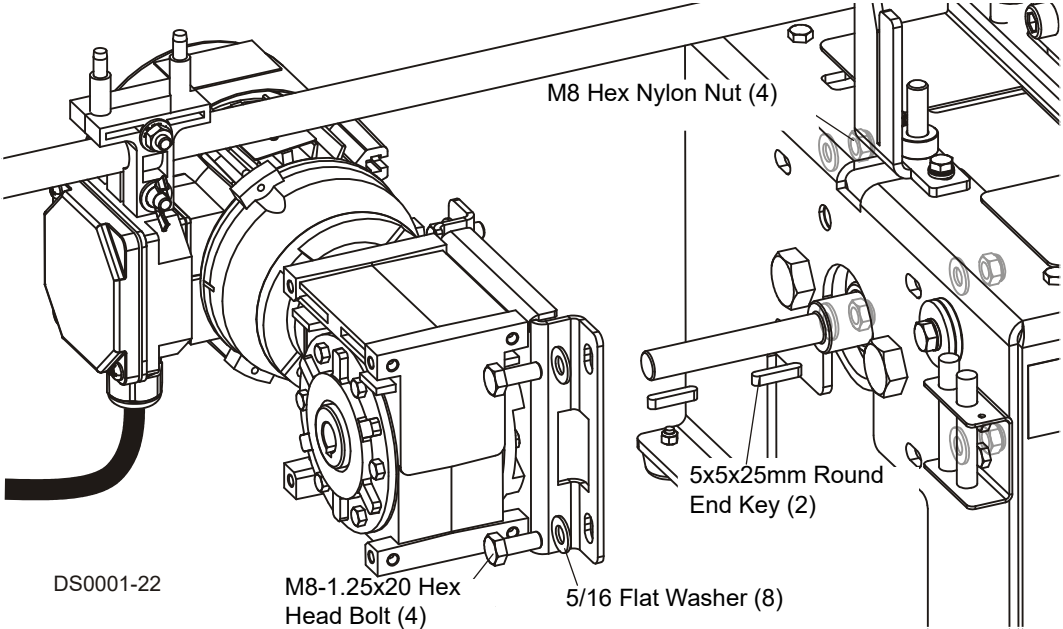


FIG. 3-5

3

Setup & Operation

Assembly

See Figure 3-6. Set the Auto Feed control box near the setter at a convenient operating location. Secure the motor harness with wire ties as necessary.

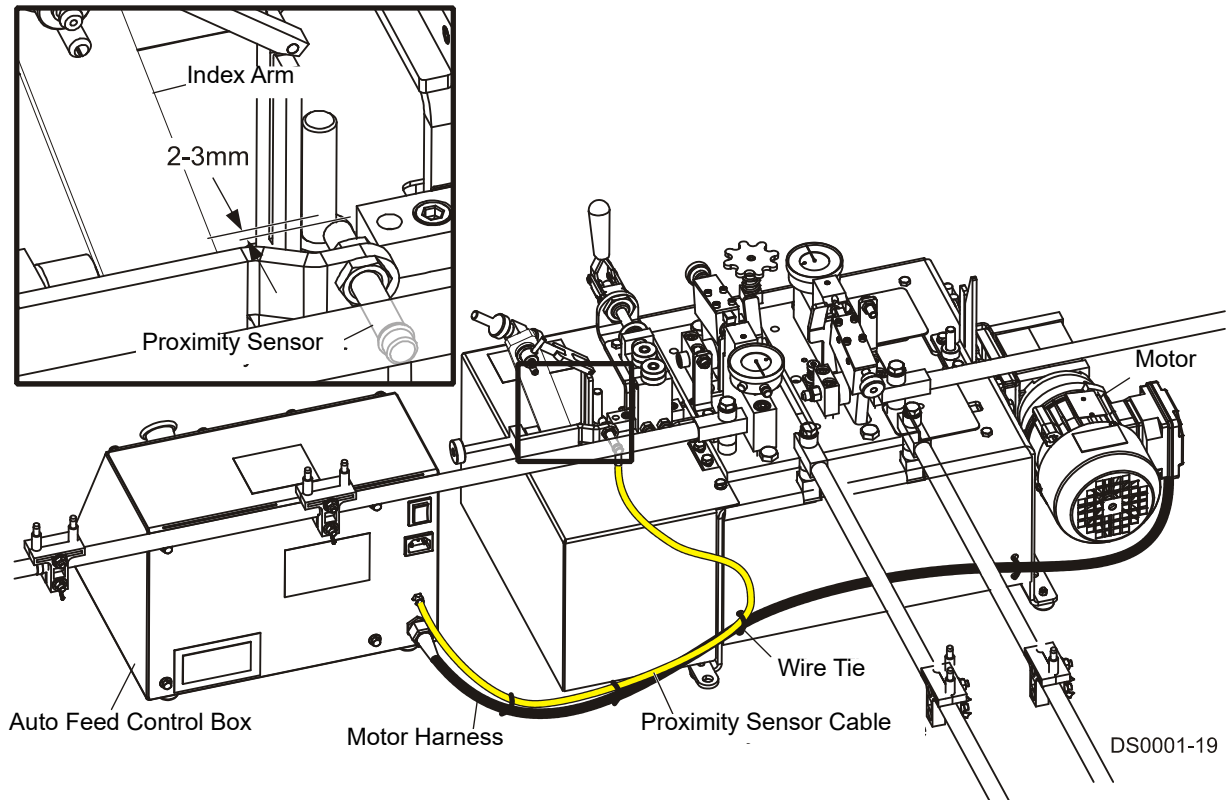


FIG. 3-6

Install the proximity sensor to the stop plate next to the setter index assembly. Make sure the proximity sensor is approximately 2-3 millimeters from the index arm. Connect the proximity sensor cable from the control box to the proximity sensor. Secure the cable to the motor harness as necessary.

Plug the power cord from the control box into a grounded receptacle. **NOTE:** The control is equipped with an auto-voltage detect feature. Simply use an appropriate adaptor plug or modify the power cord to match your receptacle.



DANGER! For the user's safety, the power cord on this product has a grounded plug. This power cord should only be used with correctly grounded (3-hole) receptacles to avoid electrical shock.

3.2 Operation

Blade Installation/Setup

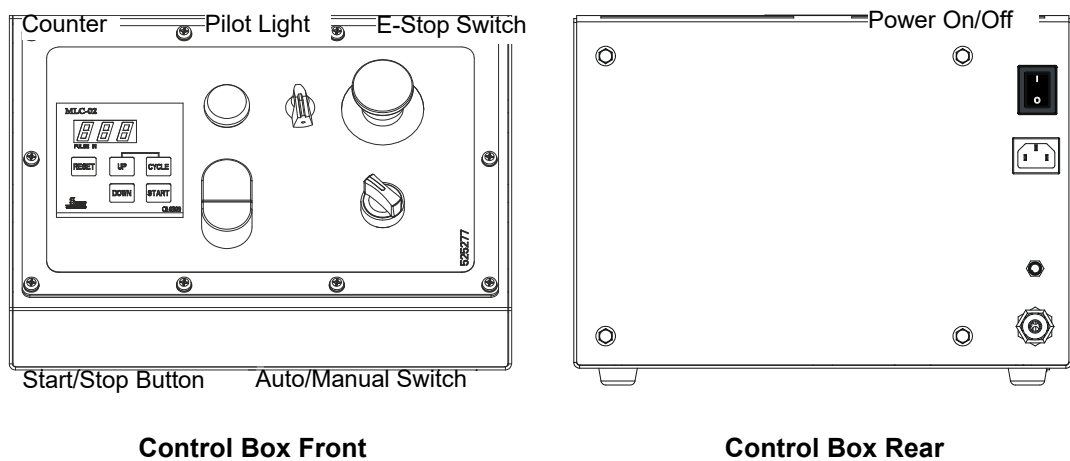


WARNING! Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or changing a blade. Failure to do so may result in serious injury.

WARNING! 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.

See Figure 3-7. AUTO FEED option only: Toggle the power ON/OFF switch on the back of the control box to the ON (I) position. Be sure the AUTO/MANUAL switch is in the MANUAL position.



DS0005

FIG. 3-7



WARNING! If at any time you need to immediately stop the machine, press the Emergency Stop (E-Stop) button. Before operating the machine again, turn the E-Stop button clockwise to release. The machine will not start until the E-Stop button is released.

3

Setup & Operation

Operation

See Figure 3-8. Pull the blade clamp lever open and flip the index arm up. Turn the feed handle counterclockwise (or push and hold the Auto Feed option START - JOG button) to advance the setter until the setter assemblies open.



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.

Loop the blade over the setter and position between the posts of the blade support guides. Place the blade between the clamp rollers and between the setter blocks, resting on the blade height adjustment pins.

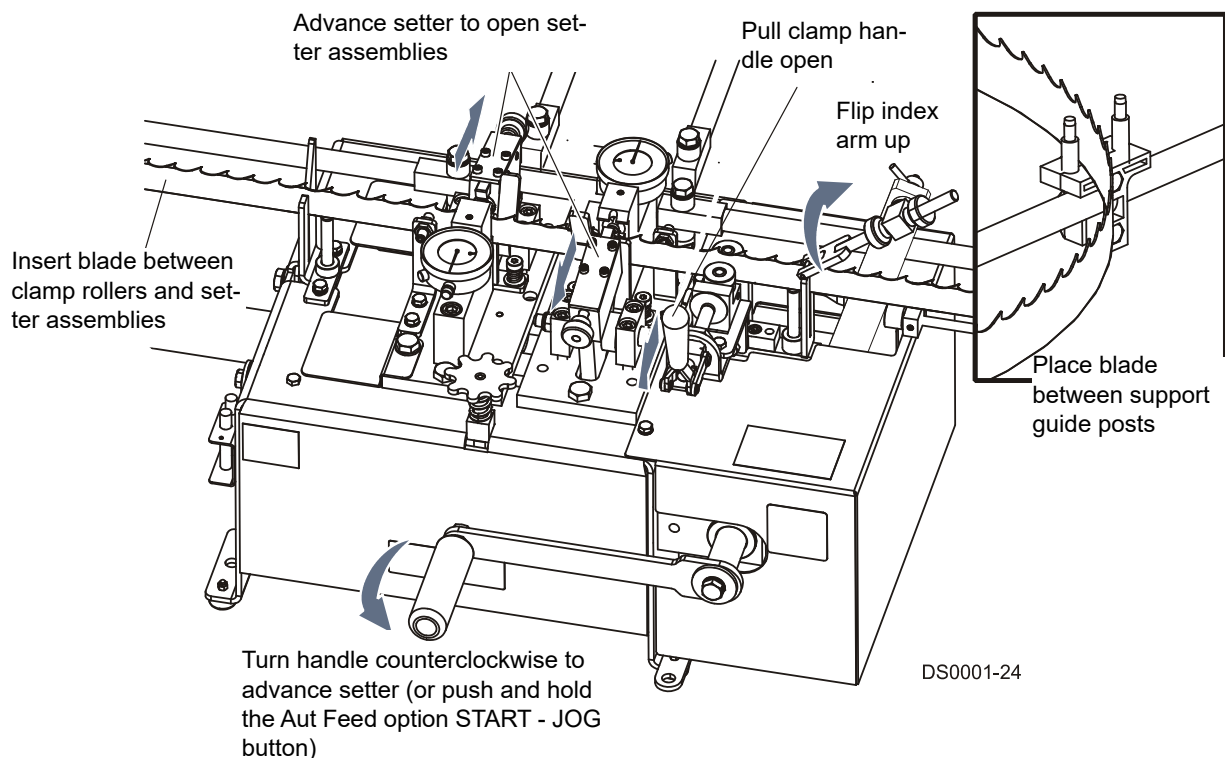


FIG. 3-8

See Figure 3-9. Loosen the wing nut on each blade support guide and adjust so the blade is positioned between the support posts. Tilt the guide slightly forward in the direction the blade travels and retighten the wing nut.

Make sure the blade support does not lift the blade. The blade should sit flat on the blade height adjustment pins. Bend the support arm down slightly if necessary to prevent it from lifting the blade.

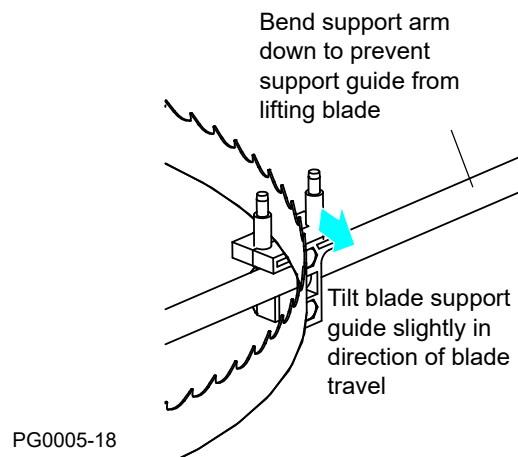


FIG. 3-9

3

Setup & Operation

Operation

See **Figure 3-10**. Adjust the blade height adjustment pins so the gullet of the blade is positioned approximately 1/16" below each setter clamp plate. Push the clamp handle closed and flip the index arm down onto the blade.

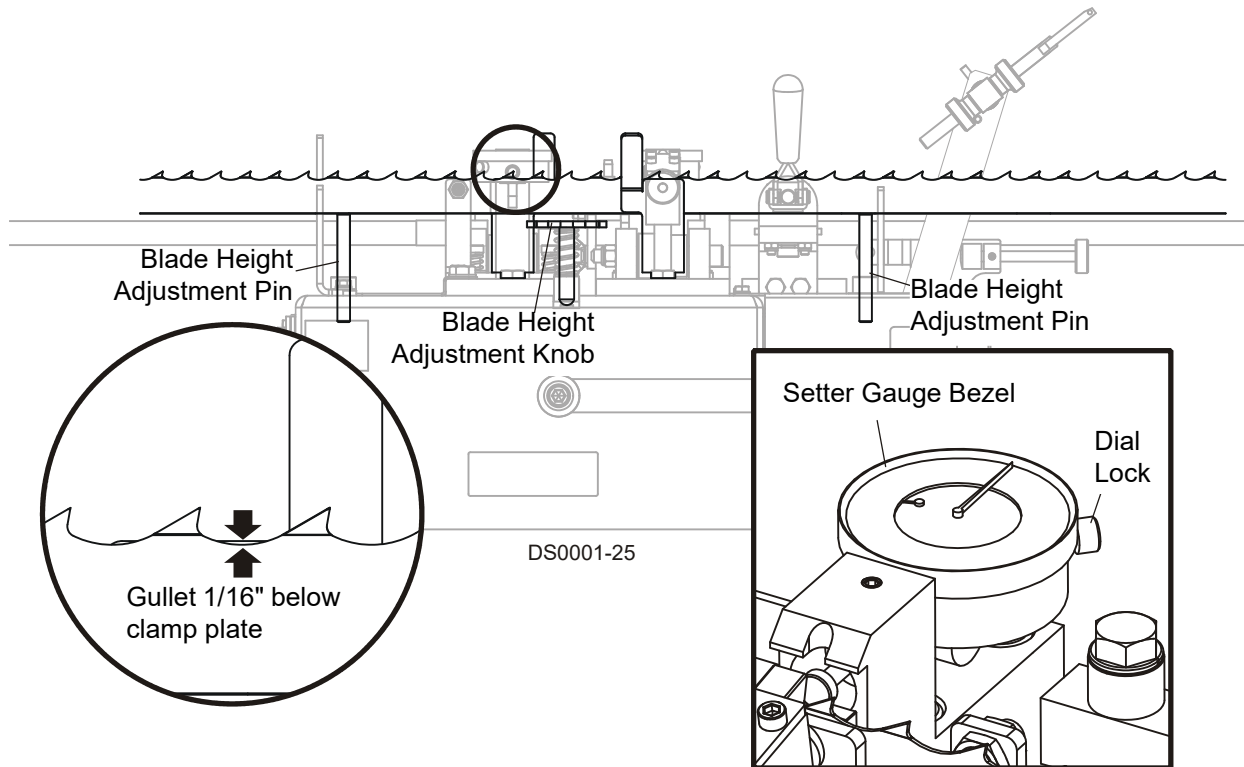


FIG. 3-10

Turn the feed handle counterclockwise (or push and hold the AUTO FEED option START - JOG button) to advance the setter until the index arm pushes the blade forward. Stop the setter before the setter assemblies start to close.

Pull the clamp handle open and lift the index arm. Adjust the blade in the setter until a tooth set toward the rear of the setter is positioned in front of the right setter block. Lower the index arm and push the blade to the right until a tooth is snug against the index pin.

See Figure 3-11. Check the position of the rear-set tooth in relation to the right setter block. The tooth should be centered with the block. Turn the adjustment knobs on the index arm if necessary so that rear-set tooth is centered with the setter block. Push the clamp handle closed.

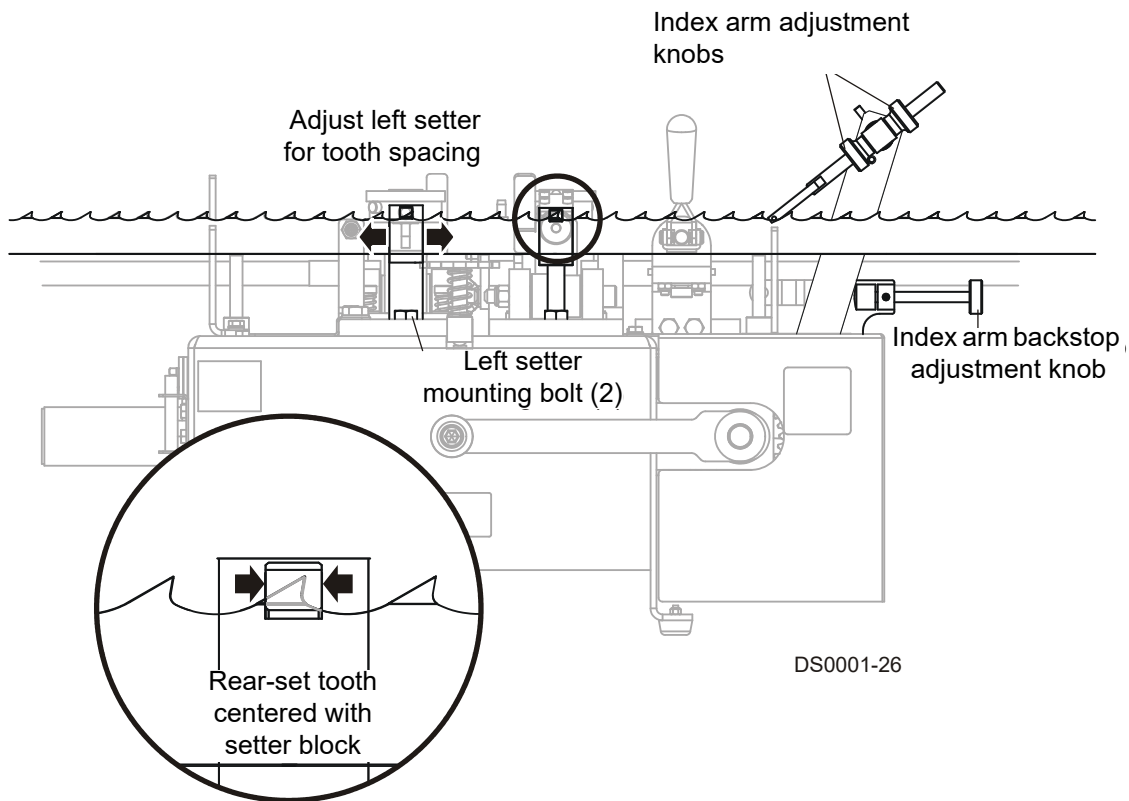


FIG. 3-11

Continue advancing the setter until the index arm retracts and just starts to move forward. The index arm should move three teeth from the one previously indexed. Turn the backstop adjustment knob in to increase the index return travel or out to decrease travel.

NOTE: The setter is factory-set for blades with 7/8" tooth spacing. Once a rear-set tooth is indexed in front of the right setter block, a forward-set tooth should be positioned in front of the left setter block. To adjust the setter for different tooth spacing, loosen the left setter mounting bolts and slide the assembly to position the setter block behind a forward-set tooth. Retighten the mounting bolts.

See **Figure 3-12**. Continue advancing the setter to index the blade to the next set of teeth. Stop the setter when the setter assemblies are completely closed. Turn the setter block adjustment knobs until the blocks just contact the blade teeth. Advance the setter to open the setter assemblies and turn the setter block adjustment knobs a few more turns.

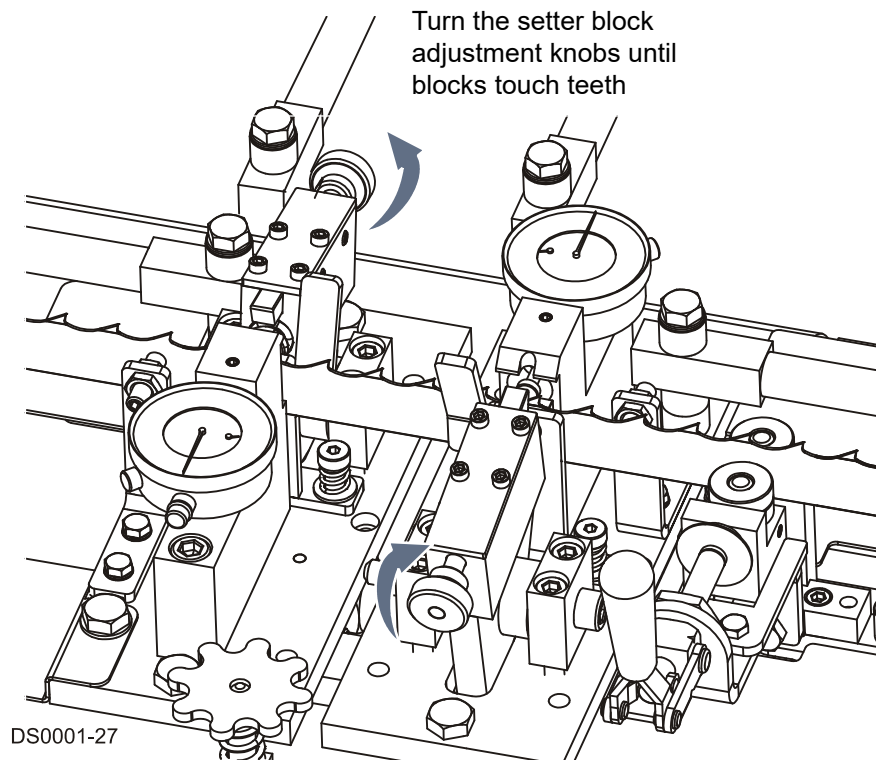


FIG. 3-12

Advance the setter to index the blade to the next set of teeth. Continue advancing the setter until the setter blocks bend the teeth and indexes to the next set of teeth. Use the supplied gauge to measure the set of both the rear-set and forward-set teeth. ([See Section 3.3](#) for more information on toothsetter calibration.)

If a tooth is bent too far, use the supplied set correction tool to bend the tooth back. Adjust the appropriate setter block adjustment knob to increase or decrease how far the teeth are bent.

Repeat the steps above until the desired amount of set is achieved in both the rear-set and forward-set teeth.

Manual Feed Operation



WARNING! Always wear eye protection when operating the setter. Failure to do so may result in serious injury.

Turn the feed handle clockwise to advance the setter until the setter assemblies open. Pull the clamp handle open and rotate the blade around the setter until the blade weld is positioned to the left of the left setter assembly. Position the blade against the index arm pin with a rear-set tooth aligned with the right setter block.

Push the clamp handle closed. Turn the feed handle counterclockwise to set teeth. Continue setting teeth around the blade until the weld is reached. Advance the setter to open the setter assemblies.

Flip the index arm up and pull the clamp open to remove the blade.

3

Setup & Operation Operation

Auto Feed Operation

Push the START - JOG button to advance the setter until the setter assemblies open. Pull the clamp handle open and position the blade against the index arm pin with a rear-set tooth aligned with the right setter block.

NOTE: Most blades manufactured by Wood-Mizer are made so the set pattern across the weld is consistent with the rest of the blade. When this is the case, you can start setting teeth anywhere on the blade and the Auto Feed will automatically stop when the counter reaches the tooth total entered. If the set pattern across the weld is not consistent, start the blade with the weld to the left of the left side setting clamp and end the cycle when the weld gets to the right of the right setting clamp. To prevent resetting the teeth in the opposite direction, count the number of teeth between the two clamp blocks, subtract the number from the total quantity of teeth on the blade, and enter the result in the setter tooth counter. Use the provided bend back tool (023774) to set the teeth that are between the setter clamps.

Push the clamp handle closed. Enter the appropriate number of teeth on the counter. Push the lower buttons to adjust the counter setting.

See Table 3-1. The quantity of teeth on any particular blade depends on the length and tooth spacing of the blade. Common blade tooth quantities are provided below.

| | | Tooth Spacing | | |
|--------------|------|---------------|--------|--------|
| | | 0.656" | 0.875" | 1.125" |
| Blade Length | 144" | 220 | 165 | 128 |
| | 158" | 241 | 180 | 140 |
| | 178" | 272 | 203 | 200 |
| | 184" | 280 | 210 | 163 |
| | 205" | 312 | 234 | 182 |
| | | No. of Teeth | | |

TABLE 3-1

See Figure 3-13. Use the bottom buttons to set the counter to the desired tooth count.

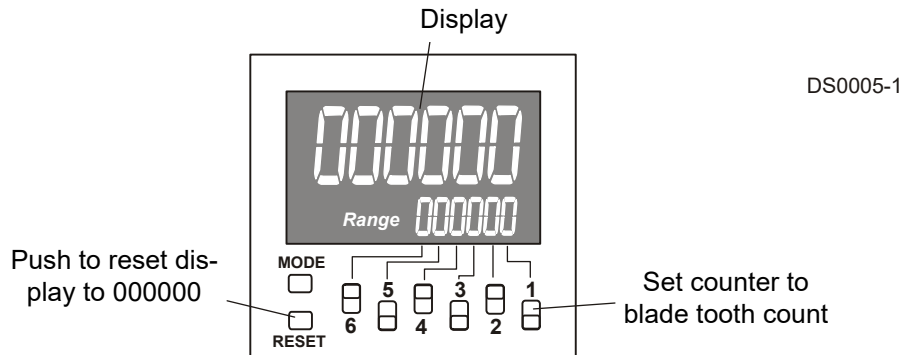


FIG. 3-13

Place the AUTO/MANUAL switch in the AUTO position. Push the START - JOG button to start setting the blade. The display value will increase as the blade passes through and the setter will stop when the display matches the counter value.

IMPORTANT: When setting Wood-Mizer blades with a raker-style pattern (one tooth bent left, one bent right and a straight tooth) the counter display should increment in multiples of three. If the counter does not increment in multiples of three before the setters activate, adjust the setter.

Push the RESET button on the counter to reset the display to zero. Flip the index arm up and pull the clamp open to remove the blade. When done setting blades, toggle the power ON/OFF switch on the back of the control box to the OFF (O) position.

3.3 Dual Setter Calibration



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.

Tooth Set Master Gauge Calibration

See Figure 3-14. 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 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.

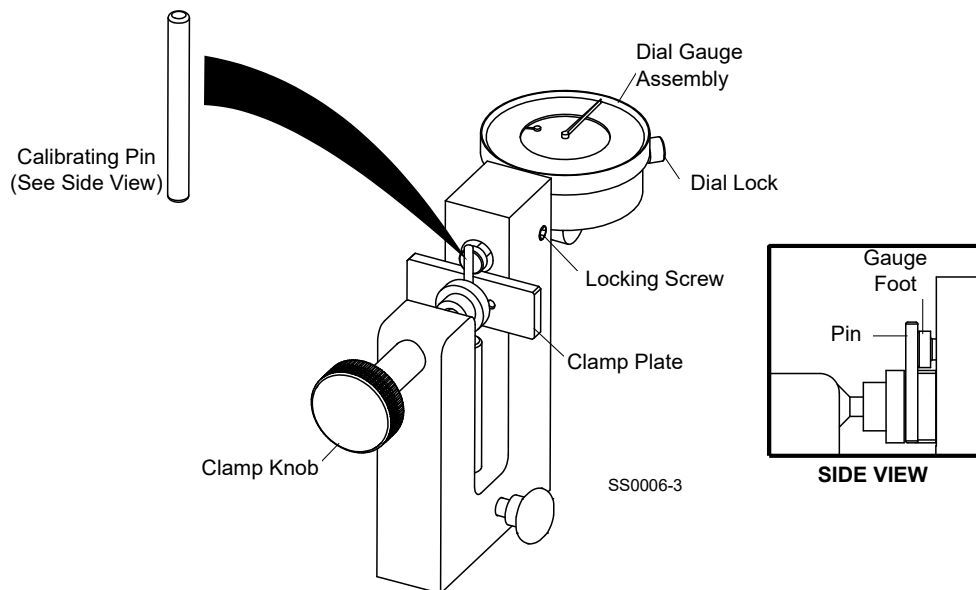


FIG. 3-14

Dual Setter Calibration

See Figure 3-15. Pull the blade clamp lever open and flip the index arm up. Turn the feed handle counterclockwise (or push and hold the Auto Feed option START - JOG button) to advance the setter until the setter assemblies open.

Loop the blade over the setter and position between the posts of the blade support guides. Place the blade between the clamp rollers and between the setter blocks, resting on the blade height adjustment pins.

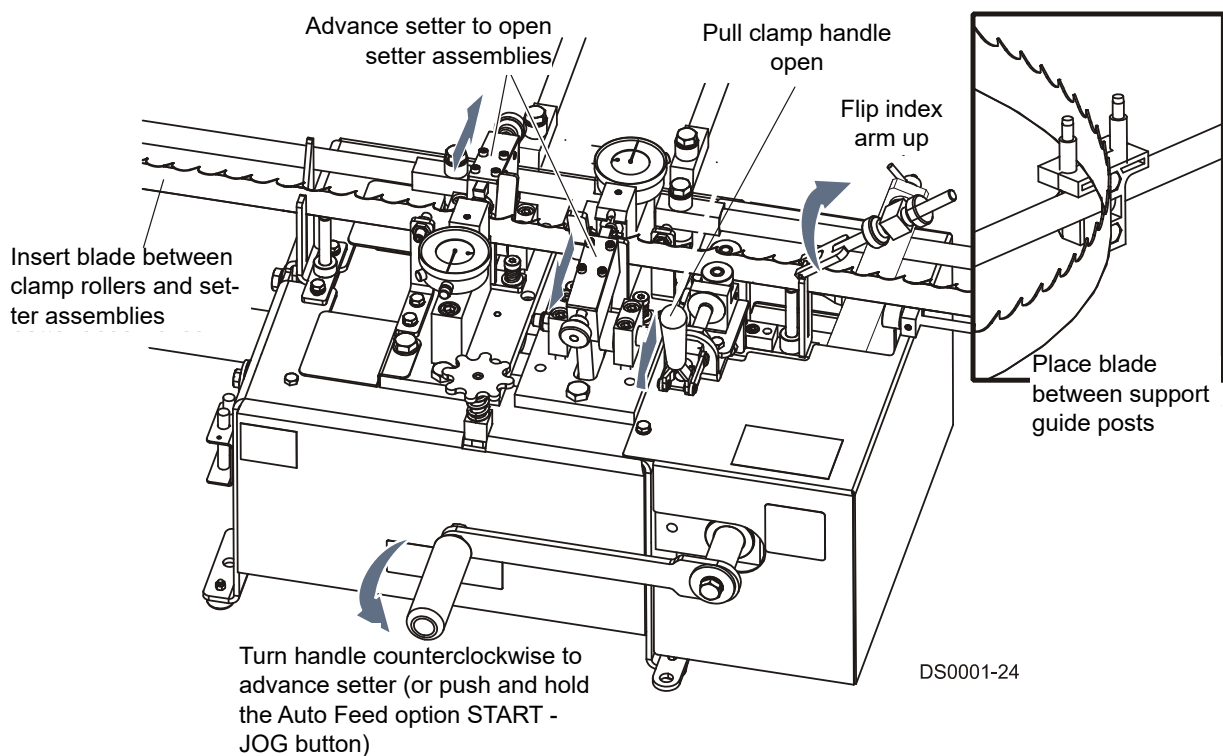


FIG. 3-15

See Figure 3-16. 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.

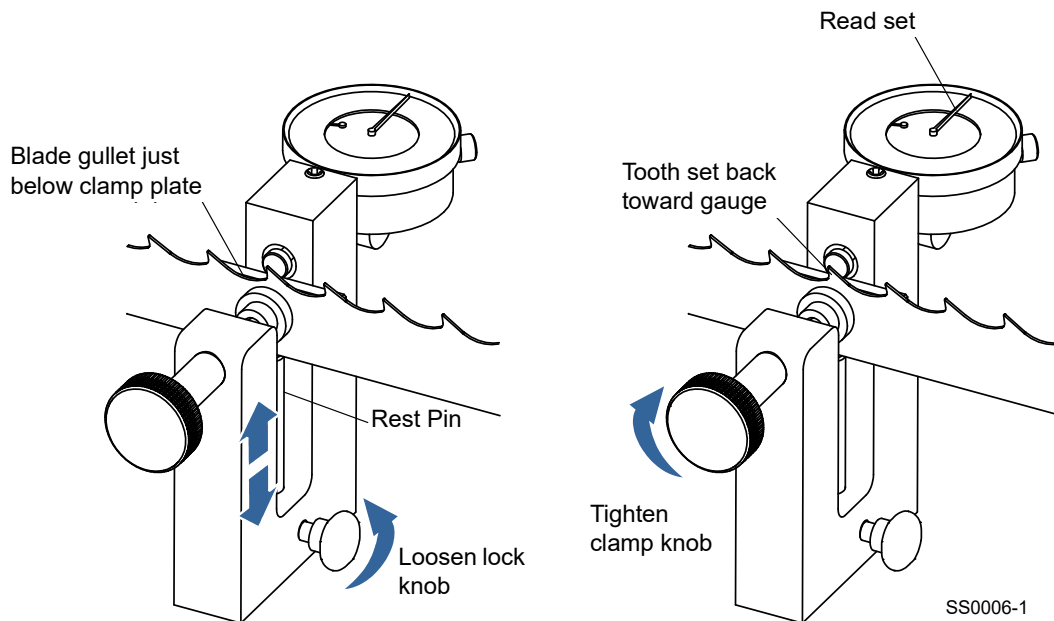


FIG. 3-16

Slide the set master gauge assembly through the blade until a tooth set back toward the gauge is positioned in front of the dial plunger. 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 and mark the measured tooth with a marker.

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 -- blades with other tooth spacing may require a different tooth count) to the left set in the opposite direction and place the set master gauge around the blade to measure tooth set. 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.

NOTE: The setter is factory-set for blades with 7/8" tooth spacing. Once a rear-set tooth is indexed in front of the right setter block, a forward-set tooth should be positioned in front of the left setter block. To adjust the setter for different tooth spacing, loosen the left setter mounting bolts and slide the assembly to position the setter block behind a forward-set tooth. Retighten the mounting bolts.

See Figure 3-17. Position the blade so that the teeth measured with the set master gauge are located in the left and right setter assemblies. Adjust the blade height adjustment pins so the gullet of the blade is positioned approximately 1/16" below each setter clamp plate.

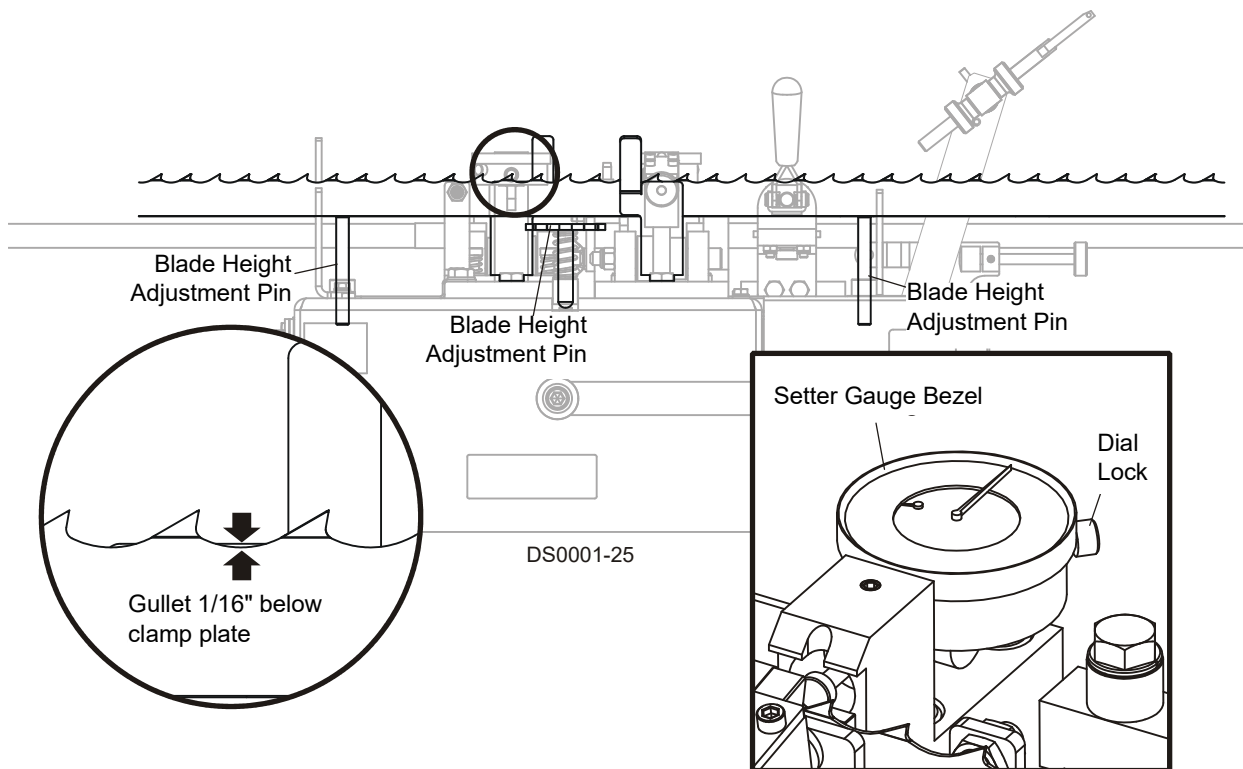


FIG. 3-17

Turn the feed handle counterclockwise (or push and hold the AUTO FEED option START - JOG button) to advance the setter until the setter assemblies start to close. Stop the setter when the setter assemblies are closed but the setter pushers do not contact the blade teeth.

Read the left and right setter gauge set measurements. Unlock the dial lock and adjust the setter gauge bezels to read the tooth set measurements taken previously with the set master gauge.

SECTION 4 MAINTENANCE



WARNING! Always turn off and disconnect power at control console AND at main supply circuit breaker before performing any service to the machine.

4.1 Routine Maintenance Schedule

See Figure 4-1. Maintenance items referenced in the instructions below.

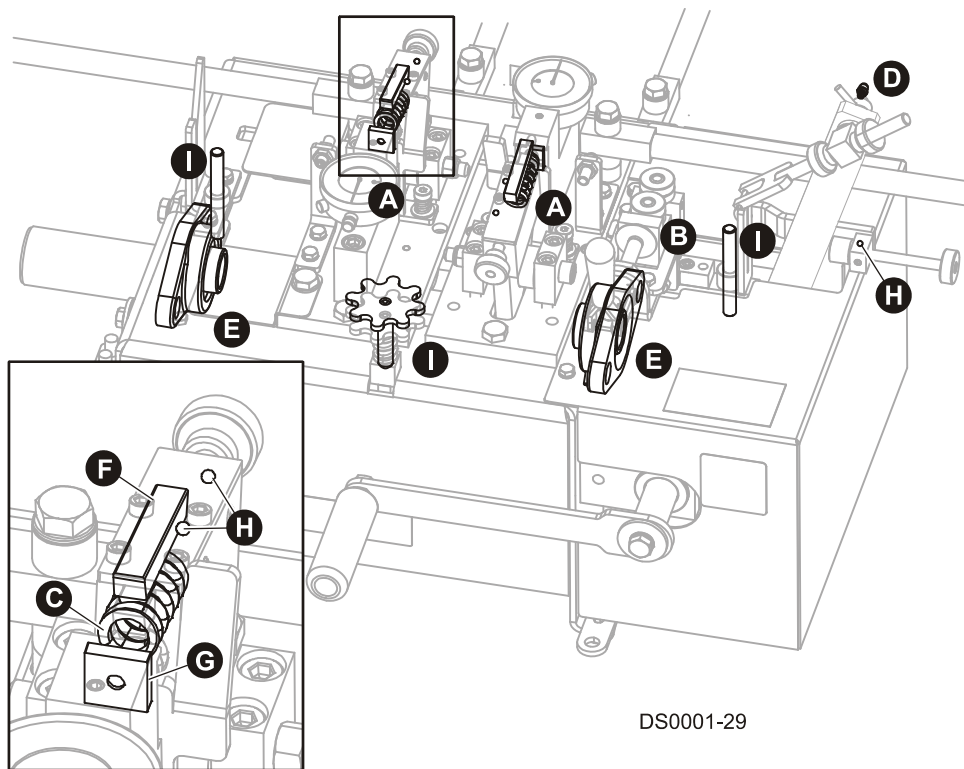


FIG. 4-1

Every 2 Weeks

Use compressed air to clean any debris from the setter assemblies (A) and blade clamp (B).

Apply NLGI No. 2 grade lithium grease to the ends of the die spring (C) of each setter assembly.

Every 3 Months

Lubricate the index arm pivot (D) and the feed shaft bearings (E). Apply NLGI No. 2 grade lithium grease to the grease fittings.

Check the setter blocks (F) and clamp pads (G) for wear. If the top edge of the clamp pad is worn, remove the mounting screw and rotate the pad 90° and replace the screw. When all four sides are worn, replace the pad. If the setter block is worn, regrind the block to 22° or replace.

Check adjustment knob tensions. The setter block and index arm backstop adjustment screws are secured with set screw/nylon ball mechanisms (H). These should be adjusted so the adjustment screws are held snugly, but still turn freely.

Check the blade height adjustment pins and knob (I) for wear and replace as necessary.

Clamp Adjustment

The clamp assembly is installed and properly adjusted at the factory. If it is necessary, use the adjustment set screw to readjust the clamp assembly as shown below.

See Figure 4-2. The right end of the clamp mounting block should be 1/16" above the blade support plate.

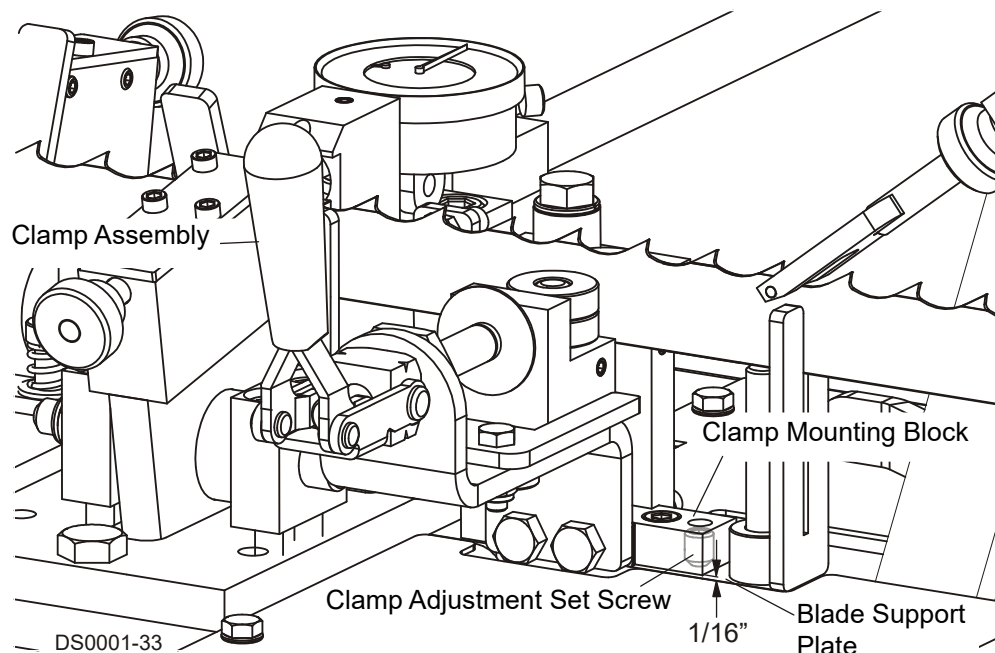


FIG. 4-2

Gauge Assembly Adjustment

The gauge assemblies are installed and properly adjusted at the factory. If it is necessary, use the gauge strip to adjust the gauge assemblies as described below.

Pull the blade clamp lever open and flip the index arm up. Turn the feed handle counterclockwise (or push and hold the Auto Feed option START - JOG button) to advance the setter until the setter assemblies open.

Install the gauge strip in the setter assembly. Turn the feed handle counterclockwise (or push and hold the AUTO FEED option START - JOG button) to advance the setter until the setter assemblies start to close. Stop the setter when the setter assemblies are closed but the setter pusher does not contact the gauge strip. Make sure the gauge strip spacers are aligned with the gauge foot.

See Figure 4-3.

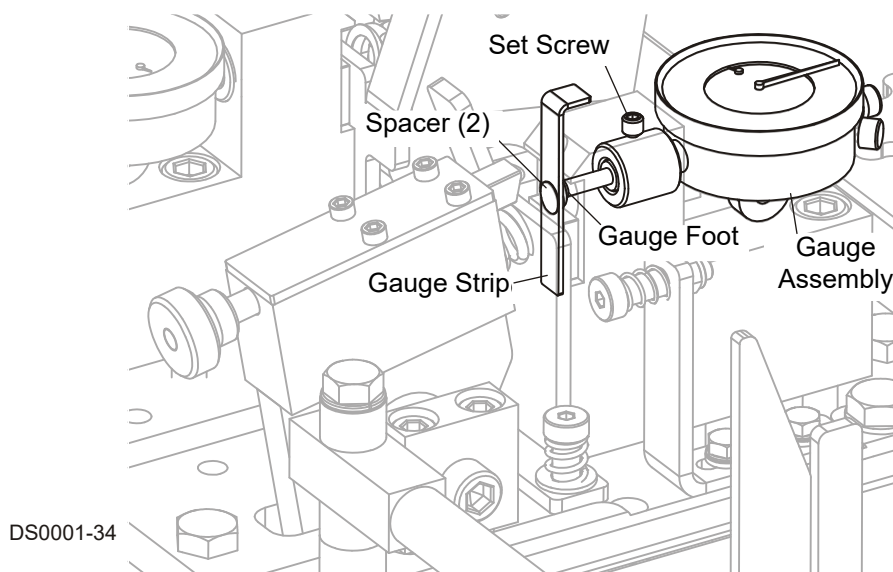


FIG. 4-3

Loosen the set screw securing the gauge assembly to the setter assembly and pull the gauge assembly slightly out to remove any pressure on the gauge foot. Unlock the dial lock, adjust the setter gauge bezels to $-.003$ and lock the dial lock. Reinstall the gauge assembly to the setter assembly so that the gauge foot touches the gauge strip spacer and the gauge needle reads 0. Tighten the set screw to secure the gauge assembly in place. Repeat the procedure for the other gauge assembly, if necessary. Install the blade to the toothsetter and perform the calibration procedure to make sure the gauge assemblies are adjusted properly ([See Section 3.3 Dual Setter Calibration](#)).

4.2 Safety Devices Inspection

Auto Feed Option Only: Check the Emergency Stop (E-Stop) button for proper operation every shift.

See Figure 4-4. The Emergency Stop (E-Stop) and START buttons as shown below.

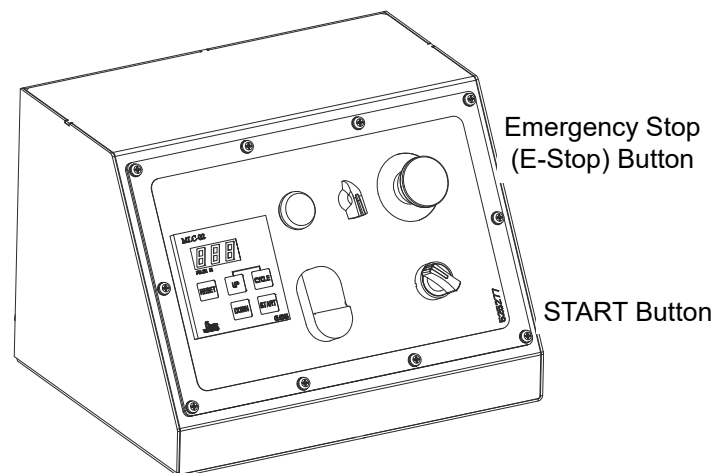


FIG. 4-4

To check the E-Stop button, toggle the power ON/OFF switch on the back of the control box to the ON (I) position. Press and hold the Start button to start the machine. Press the E-Stop button to shut down the machine. Before operating the machine again, turn the E-Stop button clockwise to release. **NOTE:** The machine will not start until the E-Stop button is released.

SECTION 5 STANDARD OPERATING PROCEDURE



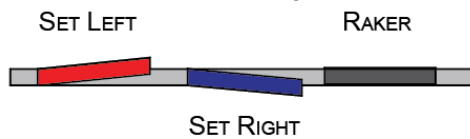
5.1 Setter alignment: BMT200/250

Wood-Mizer®

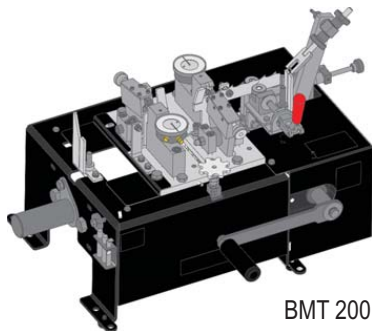
STANDARD OPERATING PROCEDURE

SETTER ALIGNMENT: BMT200/250

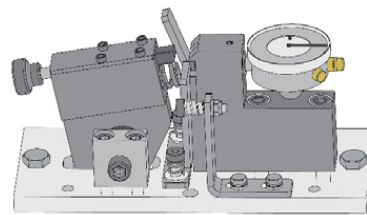
The blades supplied by Wood-Mizer have a raker-style set in the teeth. If you look at a blade from the top, you will see that the teeth are set (or bent out) in a repeating sequence; left, right, and straight. The teeth that are set left and right do the cutting. The straight teeth (rakers) clear the cut of sawdust. The setting process creates the clearance needed for the body of the blade to be able to slide through the timber without dragging.



Correctly setting the blade is one of the most important factors in the cutting ability of a blade. Check used blades regularly to see if they need resetting.



BMT 200



Setter Assembly

1. Open the blade clamp handle (figure 1.1) and flip the index arm up (figure 1.2).

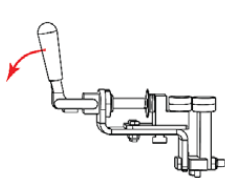


Figure 1.1

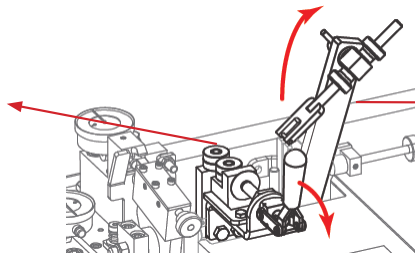
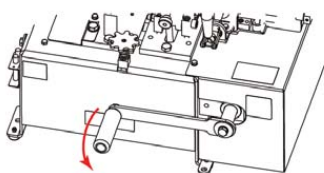
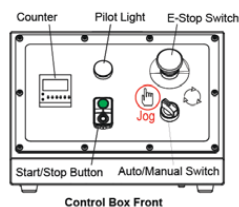


Figure 1.2

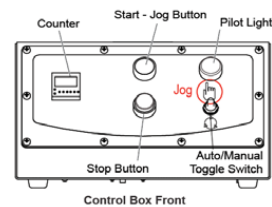
2. Advance the setter until the setter assemblies are open; Turn the feed handle counterclockwise (for the manual setter) or push and hold the Auto Feed option START - JOG button (for the automatic setter).



Manual



AC



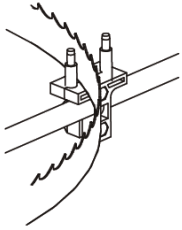
DC

Wood-Mizer®

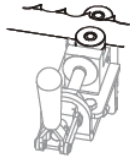
STANDARD OPERATING PROCEDURE

SETTER ALIGNMENT: BMT200/250

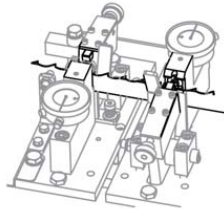
3. To insert blade, loop the blade over the setter and position it between the posts of the blade support guides. Place the blade between the clamp rollers and between the setter blocks, resting on the blade height adjustment pins.



Blade Support Guide



Clamp Rollers

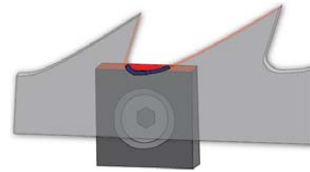
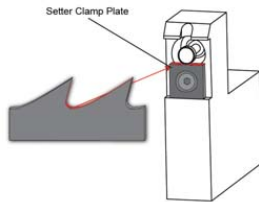


Setter Blocks

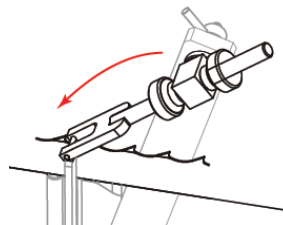
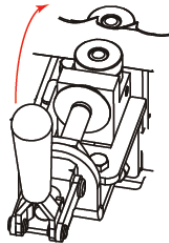


Blade Height Pin

3. Adjust the blade height adjustment pins so the gullet of the tooth is positioned approximately flush with each setter clamp plate.



4. Close the clamp handle and flip the index arm down onto the blade. Turn the feed handle counterclockwise (for the manual setter), or push and hold the Auto Feed option START - JOG button (for the automatic setter) to advance the setter until the index arm pushes the blade forward. Stop the setter before the setter assemblies start to close.



5. Pull the clamp handle open and lift the index arm. Adjust the blade until a tooth that is "set left" is positioned just right of center in relation to the set block (Figure 5.1). Close the Clamp handle.

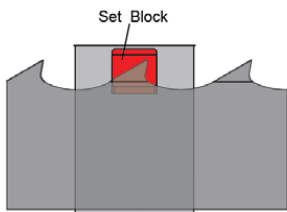
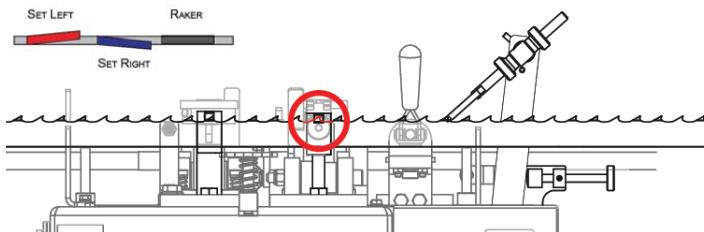


Figure 5.1



Wood-Mizer®

STANDARD OPERATING PROCEDURE

SETTER ALIGNMENT: BMT200/250

6. While holding the index arm so it does not push the blade forward, advance the setter until the index arm has advanced as far as it can go. Drop the index arm onto the blade and adjust the index arm (Figure 6.1) so it is tight in the gullet of the tooth.

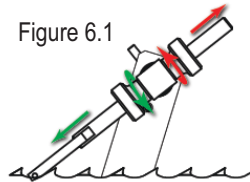
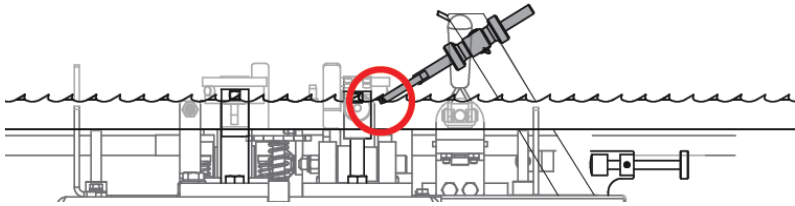


Figure 6.1

7. Jog the setter forward to ensure the next tooth is properly aligned with the setter block (Figure 7.1). If the tooth is slightly out of position, make small adjustments with the index arm until the teeth consistently line up with the setter block.

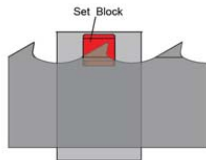


Figure 7.1

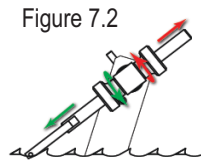
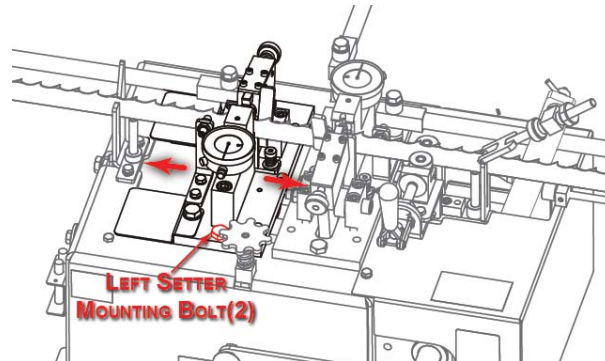
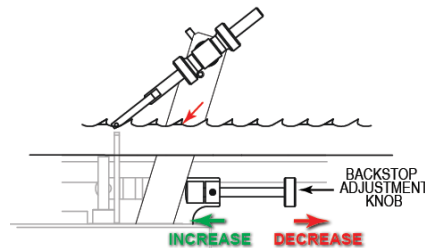


Figure 7.2

8. Adjust the left setter assembly to match the tooth spacing by loosening the two mounting bolts and sliding the assembly. Retighten the bolts when the "right set" tooth is aligned with the setter block.



9. Advance the setter to move the blade forward. The index arm should push forward three teeth from the previous one that was indexed. Adjust the amount the amount of teeth the index arm picks up before pushing the blade forward by adjusting the backstop. Turn the knob in to increase return travel, or turn the knob out to decrease travel.



Wood-Mizer®

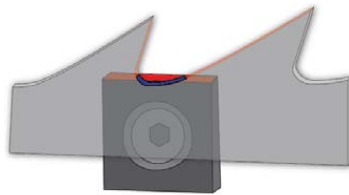
STANDARD OPERATING PROCEDURE

SETTER ALIGNMENT: BMT200/250

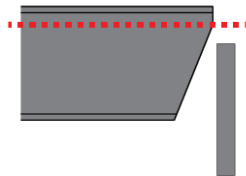
Warning: before attempting to set a blade, perform the Setter Calibration process to make sure that the gauge assemblies are adjusted properly.

The setter is properly aligned and ready for the Calibration Process when:

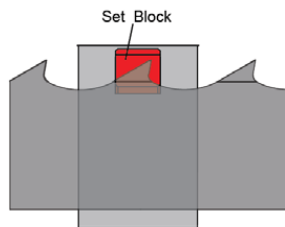
1. The gullet of the blade is flush with the setter clamp plate.



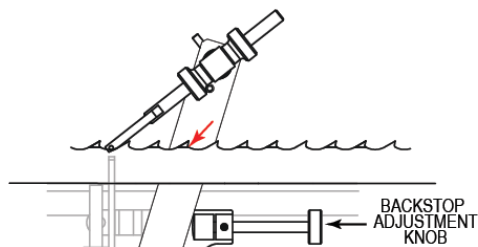
2. The top of the tooth is not above the flat edge of the pusher block.



3. The tooth of the blade is just right of center on the pusher block



4. The Index arm pushes the blade forward the correct amount of teeth.



5.2 Calibration: BMT 200/250



The Setter needs to be properly aligned before calibration. Refer to the Setter Alignment SOP

Calibrating the BMT 200/250 is an essential step to ensure correct and accurate setting of the Wood-Mizer blades. The cutting performance will be greatly increased with a blade that has been accurately set.

1. Pick an "inside" tooth that is to the left of the setter machine.



2. Measure the inside tooth with the master gauge and record the measurement. Bring the gullet of the blade flush with the clamp (Figure 2.1). Tighten the clamp onto the blade to get the measurement (Figure 2.2). Record the measurement and mark the tooth for reference.



Figure 2.1

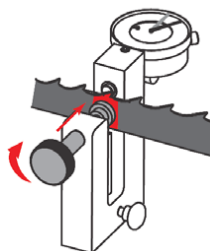
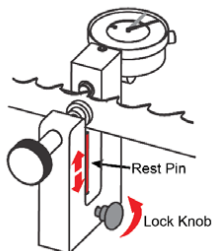
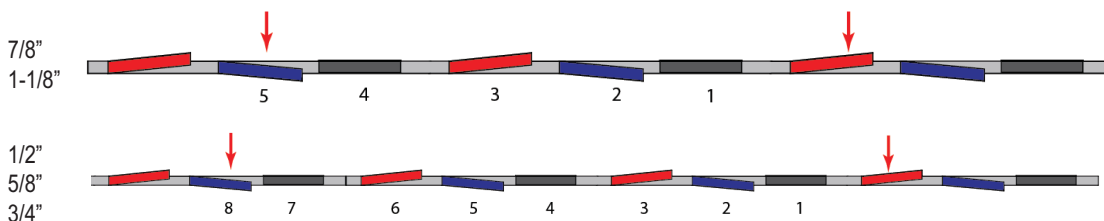


Figure 2.2

3. Before releasing the clamp, raise the rest pin to the bottom of the blade to create a reference for the blade height.



4. Count 5 teeth (for 7/8" & 1-1/8" tooth spacing) or 8 teeth (for 1/2", 5/8", & 3/4" tooth spacing) from the marked tooth and measure the "outside" tooth with the master gauge. Record the measurement.

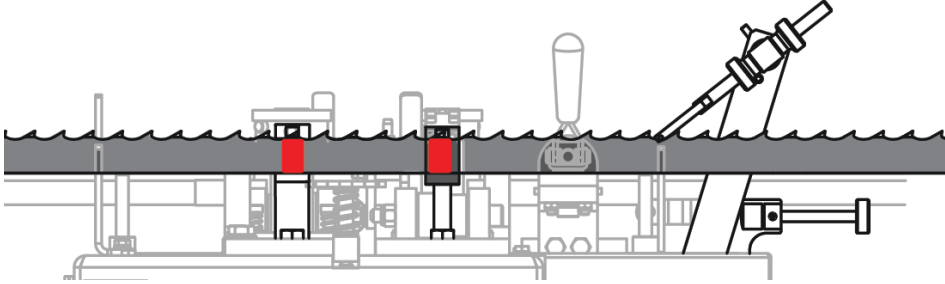


Wood-Mizer®

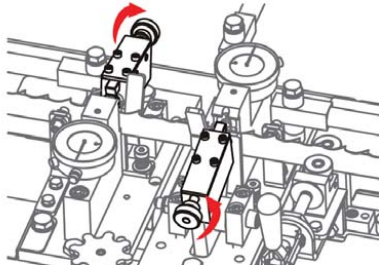
STANDARD OPERATING PROCEDURE

CALIBRATION: BMT 200/250

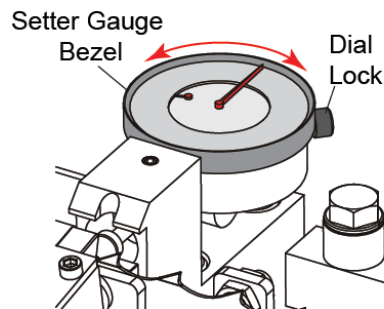
5. Bring the blade back to the setter machine and align the marked teeth with the setter assemblies. Clamp the blade.



6. Adjust the knobs on the setter assemblies to back off the setter blocks completely, the blocks will have to be pushed in manually because they are not spring loaded. Be sure the blocks are backed off far enough so they will not contact the blade when you advance the setter in the next step.



7. Advance the setter until the setter assemblies are closed. Unlock the dial lock and adjust the setter gauge bezels so the needle of the gauges show the same tooth set measurements taken previously with the set master gauge.



The gauges are now calibrated

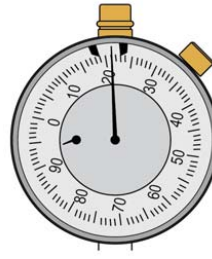
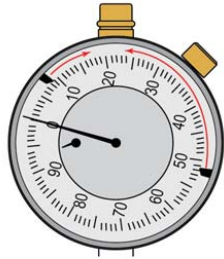
Wood-Mizer®

STANDARD OPERATING PROCEDURE

CALIBRATION: BMT 200/250

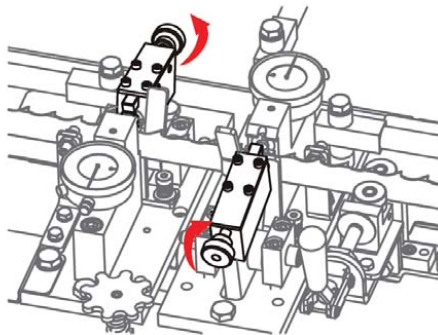
Once the setter is calibrated you can now accurately adjust the set of the blade.

Use the “tabs” on the gauges to bracket the desired set. Typical Deviation allowed is two thousandths.



Desired set: 21
(Tolerance 19 - 23)

To adjust the set of the blade to your desired set, adjust the knob on the setter assembly to bring the setter block in. Make small adjustments on both knobs while the setter is running. Watch the gauges while the setter starts working and the actual set measurement will be when the needle pauses for the second time and “hesitates”. Continue adjusting until the desired measurement is reached and the needle hesitates between the tabs.



TIP

With a properly aligned and calibrated setter, and assuming that both sides of the set only need a minor adjustment to achieve the desired set - it is quicker and easier to raise or lower the blade using the blade height adjustment knob.

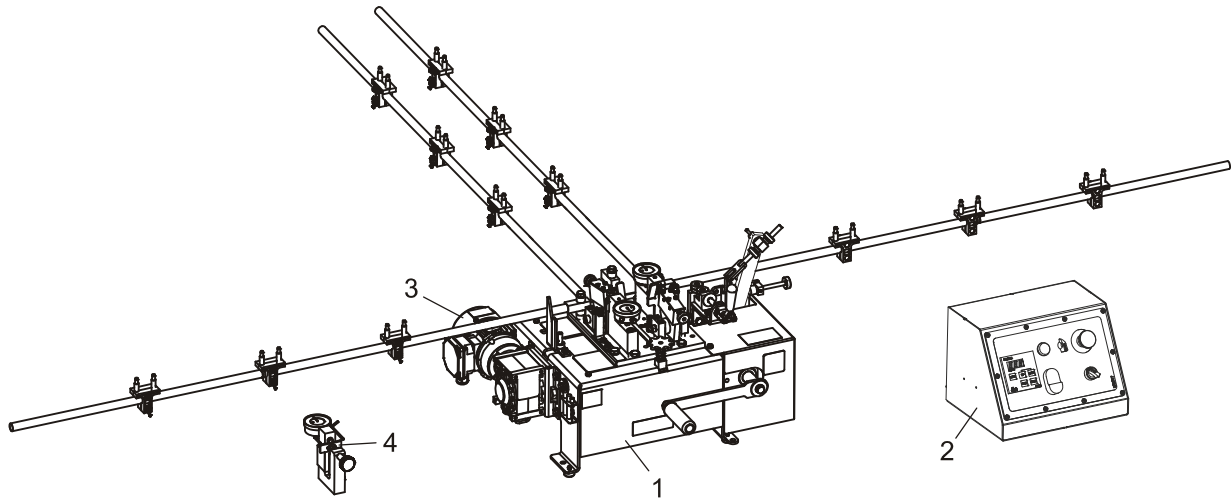
- Raising the blade will increase the set achieved.
- Lowering the blade will reduced the set achieved.

6

Replacement Parts Dual Toothsetter (Complete)

SECTION 6 REPLACEMENT PARTS

6.1 Dual Toothsetter (Complete)

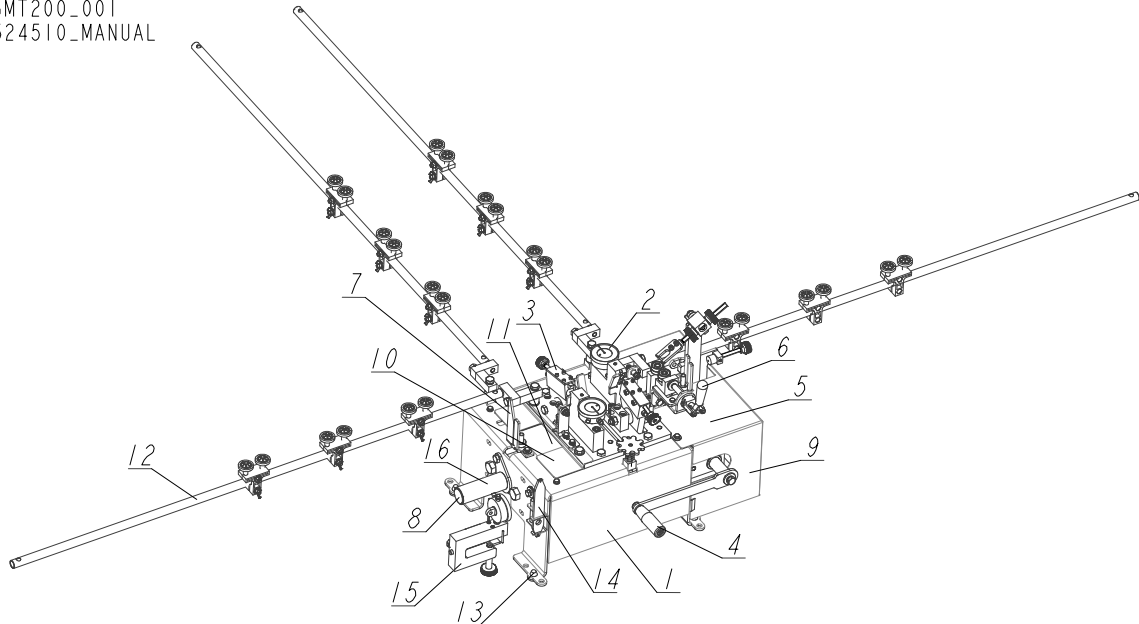


DS0001-35

| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|--------|-----|
| 1 | DUAL TOOTHSETTER PARTS (See Section 6.2) | 524510 | 1 |
| 2 | ELECTRIC BOX PARTS, OPTIONAL AUTOMATIC FEED (See Section 6.19) | 525267 | 1 |
| 3 | MOTOR PARTS, OPTIONAL AUTOMATIC FEED (See Section 6.16) | 525265 | |
| 4 | GAUGE ASSEMBLY, TOOTHSET See Section 6.15 | 060490 | 1 |

6.2 Dual Toothsetter Assembly

BMT200_001
524510_MANUAL



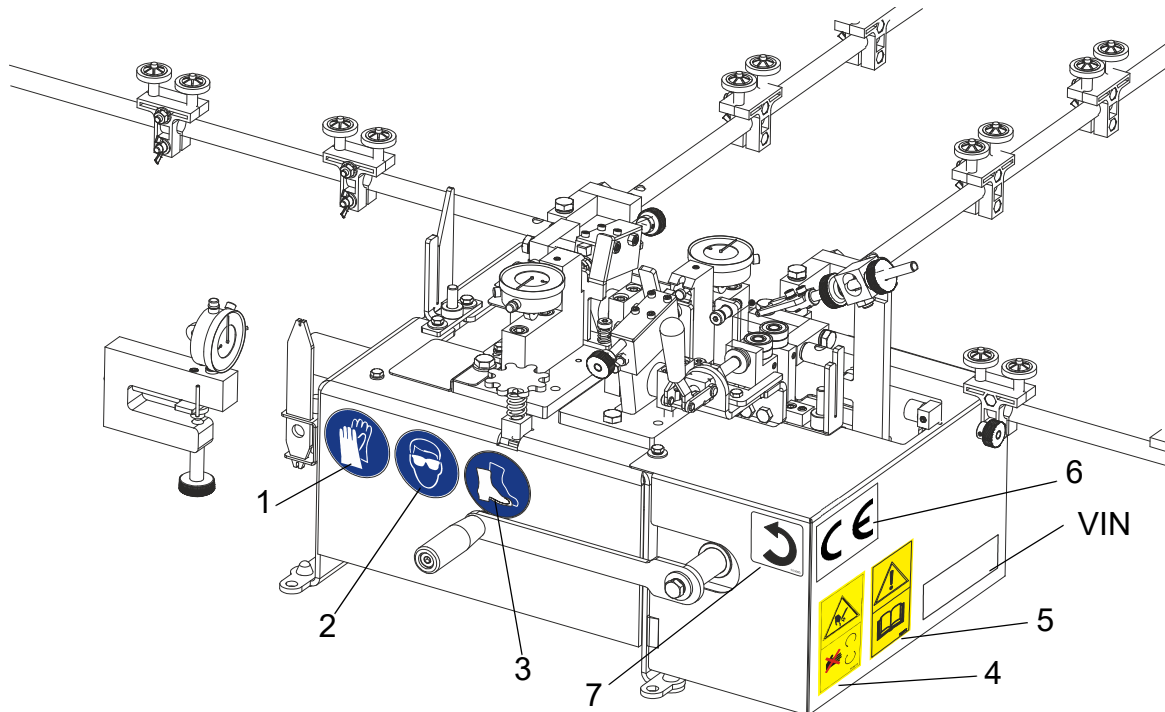
| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|---|--------|-----|
| | TOOTHSETTER ASSEMBLY, DUAL | 524510 | 1 |
| 1 | Base Housing Assembly (See Section 6.5) | | 1 |
| 2 | Dual Toothsetter Right Head (See Section 6.6) | 524535 | 1 |
| 3 | Dual Toothsetter Left Head (See Section 6.7) | 524536 | 1 |
| 4 | Index Shaft Assembly (See Section 6.8) | 524547 | 1 |
| 5 | Blase Height Adjuster Assembly (See Section 6.9) | 524558 | 1 |
| 6 | Blade Clamp & Guide (See Section 6.11) | 524564 | 1 |
| 7 | Outfeed Blade Guide (See Section 6.12) | 525245 | 1 |
| 8 | Drive Shaft Guard (See Section 6.5) | 525254 | 1 |
| 9 | Cover, Drive Shaft w/Crank Handle (See Section 6.5) | 525251 | 1 |
| 10 | Upper Cover (See Section 6.5) | 525259 | 1 |
| 11 | Lower Cover (See Section 6.5) | 525261 | 1 |
| 12 | Blade Support Arm (See Section 6.14) | 525263 | 4 |
| 13 | Foot, SR 1591 25.3x12.5 (See Section 6.5) | 515250 | 4 |
| 14 | Optional Tool Set (See Section 6.13) | 525275 | 1 |
| 15 | Gauge Assembly, Toothset (See Section 6.15) | 060490 | 1 |

6

Replacement Parts

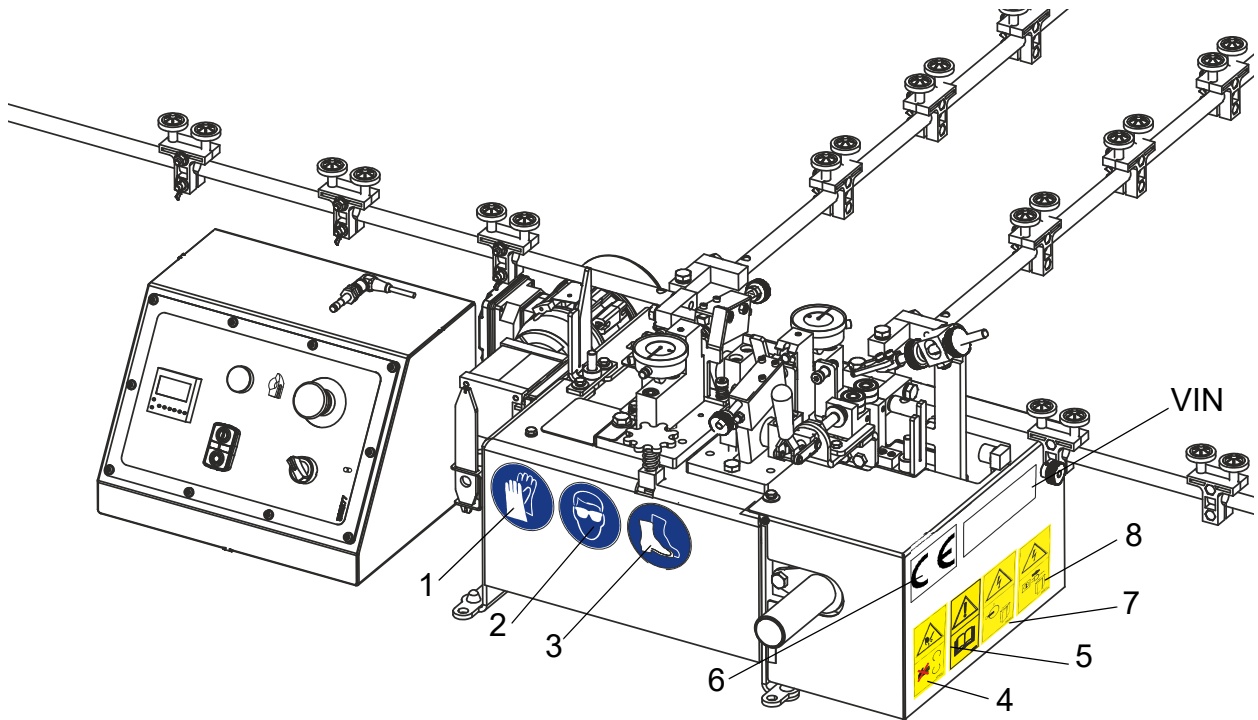
BMT200 Decals

6.3 BMT200 Decals



| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| | DECAL KIT, BMT200 | 525332 | 1 |
| 1 | DECAL, "USE PROTECTIVE GLOVES" (PICTOGRAM) | 512107 | 1 |
| 2 | DECAL, "USE SAFETY GOGGLES" (PICTOGRAM) | S12004G-1 | 1 |
| 3 | DECAL, "USE SAFETY BOOTS" (PICTOGRAM) | 501465 | 1 |
| 4 | DECAL, HAND INJURY HAZARD (PICTOGRAM) | 509255 | 1 |
| 5 | DECAL, READ OPERATOR'S MANUAL (PICTOGRAM) | 096317 | 1 |
| 6 | DECAL, CE CERTIFIED MACHINE (SMALL) | P85070 | 1 |
| 7 | DECAL, DUAL SETTER OPERATION DIRECTION | 053583 | 1 |
| | DECAL, VIN | | 1 |

6.4 BMT250 Decals



| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|---|
| | DECAL KIT, BMT250 | 526834 | 1 | ◆ |
| 1 | DECAL, "USE PROTECTIVE GLOVES" (PICTOGRAM) | 512107 | 1 | |
| 2 | DECAL, "USE SAFETY GOGGLES" (PICTOGRAM) | S12004G-1 | 1 | |
| 3 | DECAL, "USE SAFETY BOOTS" (PICTOGRAM) | 501465 | 1 | |
| 4 | DECAL, HAND INJURY HAZARD (PICTOGRAM) | 509255 | 1 | |
| 5 | DECAL, READ OPERATOR'S MANUAL (PICTOGRAM) | 096317 | 1 | |
| 6 | DECAL, CE CERTIFIED MACHINE (SMALL) | P85070 | 1 | |
| 7 | DECAL, HIGH VOLTAGE IN THE ELECTRIC BOX (PICTOGRAM) | 096316 | 1 | |
| 8 | DECAL, "REMOVE THE PLUG BEFORE OPENING THE ELECTRIC BOX" (PICTOGRAM) | 096319 | 1 | |
| | VIN | | 1 | |

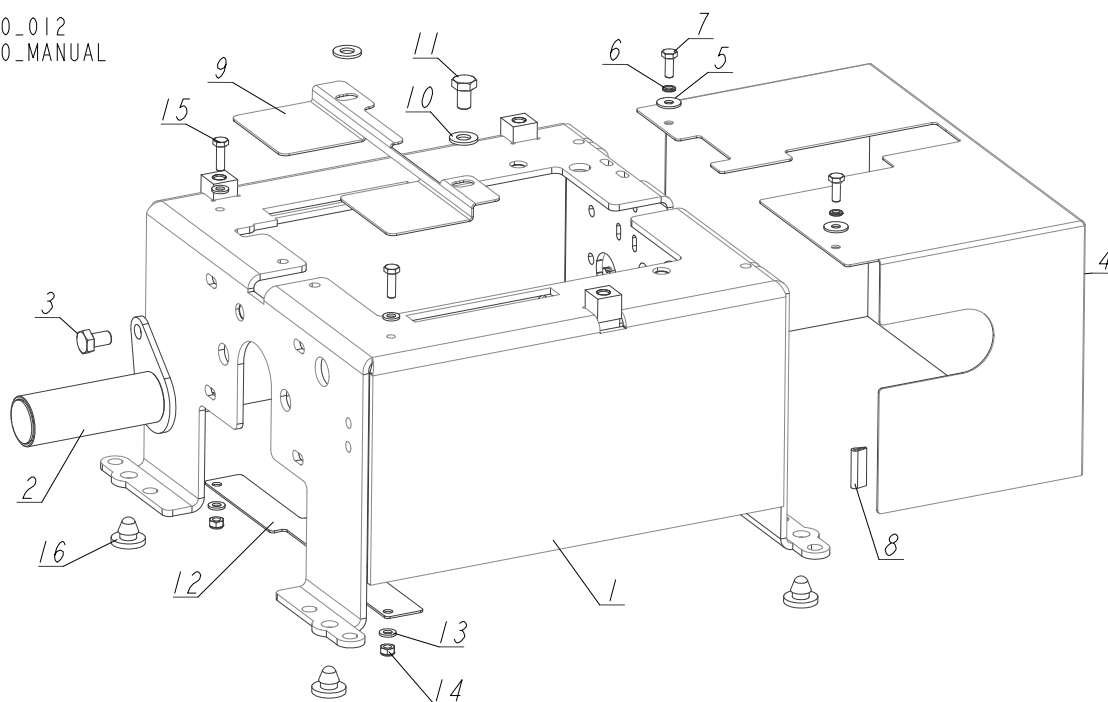
6

Replacement Parts

Base Housing Assembly

6.5 Base Housing Assembly

BMT200_012
524510_MANUAL



| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| - | TOOTHSETTER, BMT200-P DUAL | 524510 | 1 |
| 1 | BASE WELDMENT, DUAL TOOTHSETTER | 524511-1 | 1 |
| - | GUARD, DRIVE SHAFT - COMPLETE | 525254 | 1 |
| 2 | GUARD, DRIVE SHAFT ZINC-PLATED | 525255-1 | 1 |
| 3 | BOLT, M10X16-8.8 HEX HEAD FULL THREAD ZINC | F81003-13 | 1 |
| - | COVER, DRIVE SHAFT W/CRANK HANDLE - COMPLETE | 525251 | 1 |
| 4 | COVER, DRIVE SHAFT W/CRANK HANDLE | 525252-1 | 1 |
| 5 | WASHER, 6.5 SPECIAL FLAT ZINC | F81053-11 | 2 |
| 6 | WASHER, Z 6.1 SPLIT LOCK | F81053-3 | 2 |
| 7 | BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC | F81001-15 | 2 |
| 8 | COVER, L=30 EDGE PLASTIC | 525253 | 2 |
| - | COVER, UPPER - COMPLETE | 525259 | 1 |
| 9 | COVER, UPPER | 525260-1 | 1 |
| 10 | WASHER, 10.5 FLAT ZINC | F81055-1 | 2 |
| 11 | BOLT, M10X16-8.8 HEX HEAD FULL THREAD ZINC | F81003-13 | 1 |
| - | COVER, LOWER - COMPLETE | 525261 | 1 |

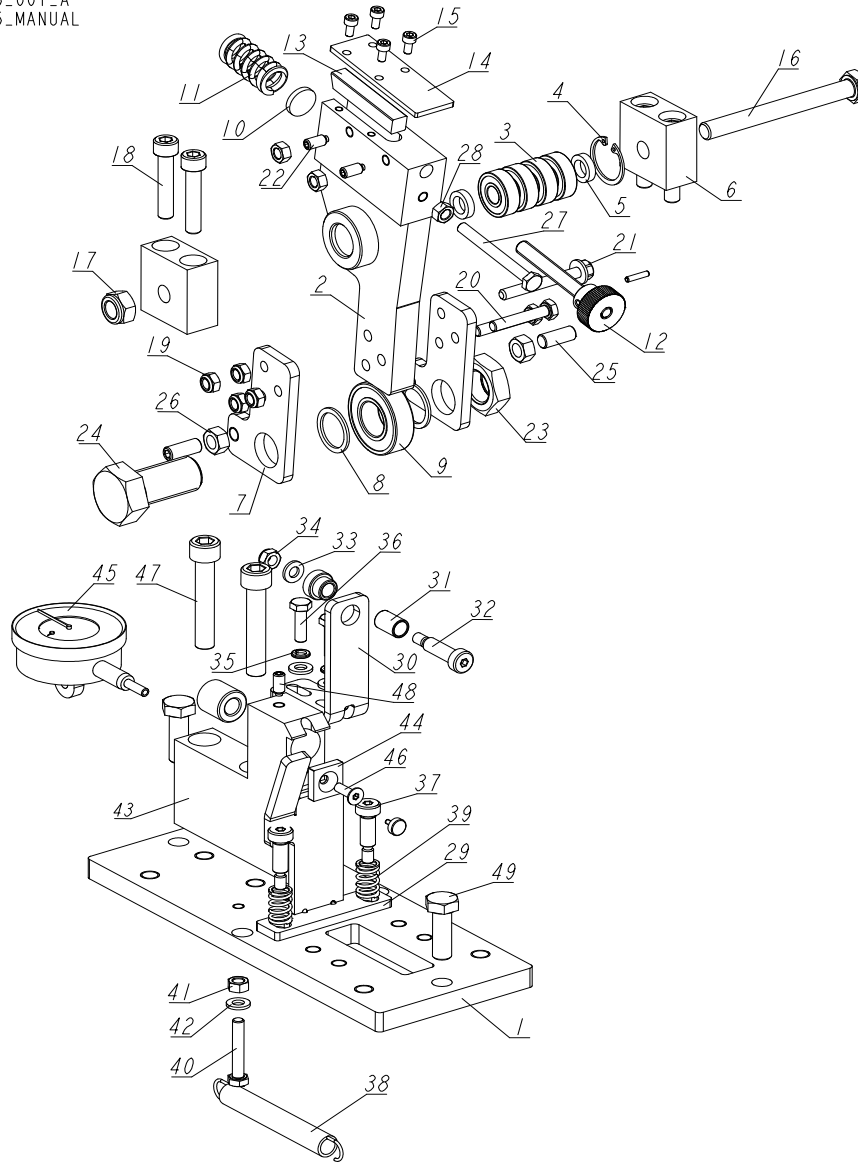
| REF. | DESCRIPTION (◆ Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|----------|-----|--|
| 12 | COVER, LOWER | 525262-1 | 1 | |
| 13 | WASHER, 6.4 FLAT ZINC | F81053-1 | 4 | |
| 14 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 2 | |
| 15 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 2 | |
| 16 | FOOT, SR 1591 25.3X12.5 (MOSS 34363) | 515250 | 4 | |

6

Replacement Parts Dual Toothsetter Right Head

6.6 Dual Toothsetter Right Head

524535_001_A
524535_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| - | HEAD, DUAL TOOTHSETTER RIGHT - COMPLETE | 524535 | 1 |
| 1 | PLATE, HEAD BASE ZINC-PLATED | 524516-1 | 1 |
| - | ARM, DUAL TOOTHSETTER - COMPLETE | 524520 | 1 |
| 2 | ARM, DUAL TOOTHSETTER ZINC-PLATED | 524521-1 | 1 |
| 3 | BEARING, 6000.2RSR | 087471 | 4 |
| 4 | RING, W26 INSIDE RETAINING | F81090-34 | 1 |
| 5 | BUSHING, 10.5X16X4SPACER, ZINC-PLATED | 525238-1 | 2 |
| 6 | BLOCK, ZINC-PLATED SUPPORT | 524528-1 | 2 |

Replacement Parts

Dual Toothsetter Right Head

6

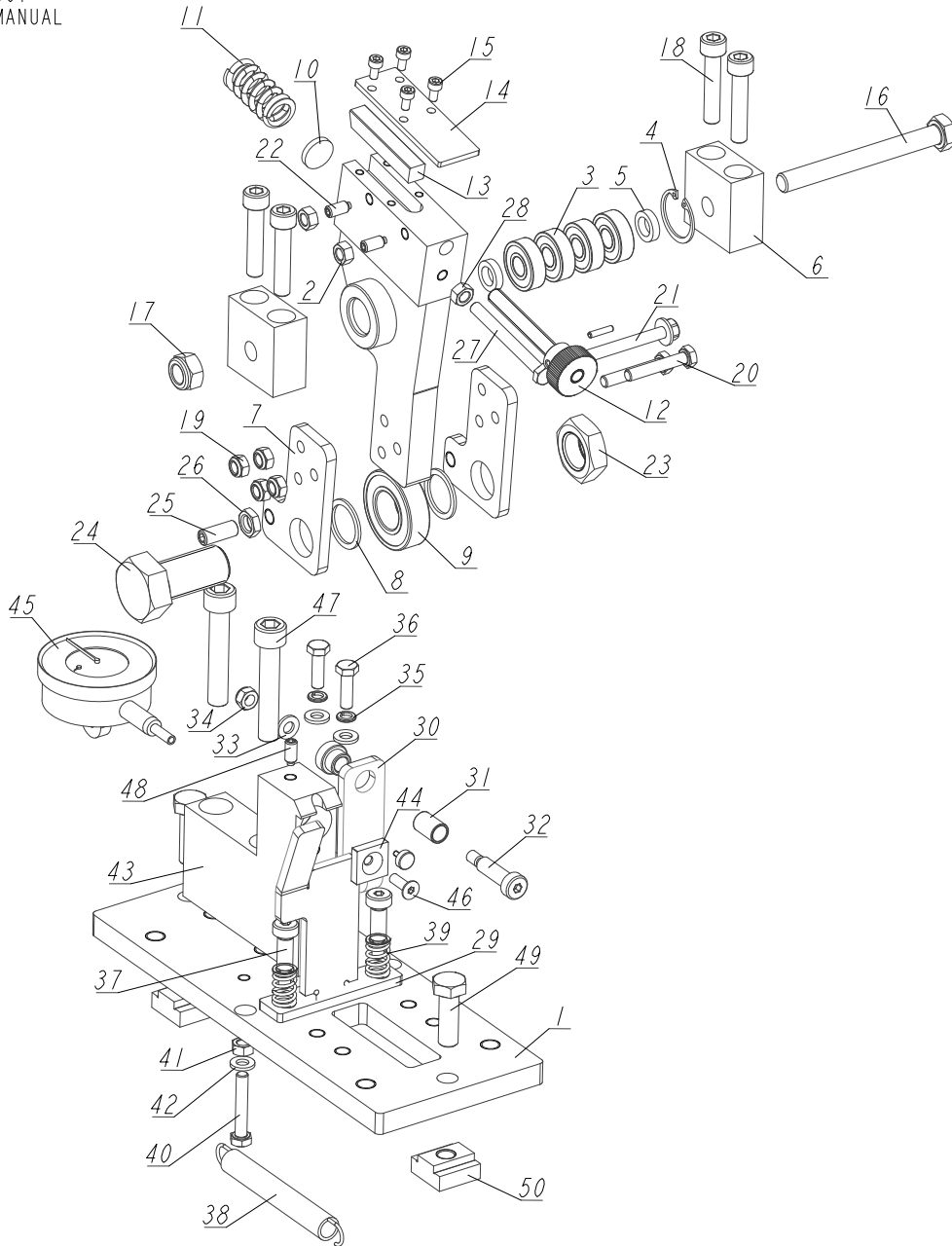
| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|------------|-----|
| 7 | PLATE, PUSHER ARM SIDE ZINC-PLATED | 524525-1 | 2 |
| 8 | WASHER, 20.5X26X1.5 ZINC-PLATED | 524526 | 2 |
| 9 | BEARING, 6004 2RS CX ROLLING | 093868 | 1 |
| 10 | PLATE, SPRING ZINC-PL. ADJUSTMENT | 524515-1 | 1 |
| 11 | SPRING, 3/4 OD X 1-1/2 L X .165X.125 WIRE DIE | 060499 | 1 |
| 12 | BOLT, PUSHER ADJUSTMENT | 524531 | 1 |
| 13 | PUSHER, SETTER | 060597 | 1 |
| 14 | PLATE, HEAD TOP ZINC-PLATED | 524527-1 | 1 |
| 15 | SCREW, M4X8 8.8 HEX SOCKET HEAD CAP ZINC | F81011-36 | 4 |
| 16 | BOLT, M10X95-8.8-B HEX HEAD ZINC | F81003-71 | 1 |
| 17 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 1 |
| 18 | SCREW, M8X40-8.8 HEX SOCKET HEAD CAP ZINC | F81002-29 | 4 |
| 19 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 4 |
| 20 | BOLT, M6X35-8.8 HEX HEAD ZINC | F81001-71 | 2 |
| 21 | BOLT, M6X50-8.8 FE/ZN5 DIN-6921 HEX FLANGE | F81001-35 | 1 |
| 22 | SCREW, GN 913.5-M6-12-KU STAINLESS STEEL SET (ELESA+GAN-TER) | F81001-78 | 2 |
| 23 | NUT, M20 ISO 4035 THIN ZINC | F81037-9 | 1 |
| 24 | BOLT, M20X40-8.8 HEX HEAD FULL THREAD ZINC | F81007-11 | 1 |
| 25 | SCREW, M8X20-45H GEOMET DIN913 SOCKET SET | F81002-103 | 2 |
| 26 | NUT, M8-8-B HEX ZINC | F81032-1 | 2 |
| 27 | BOLT, M6X60-8.8 HEX HEAD FULL THREAD ZINC | F81001-9 | 1 |
| 28 | NUT, M6 8 HEX ZINC | F81031-1 | 3 |
| 29 | CLAMP WELDMENT, HEAD ZINC-PLATED | 524517-1 | 1 |
| - | GUIDE ASSEMBLY, BLADE | 524537 | 1 |
| 30 | BRACKET, BLADE GUIDE ZINC-PLATED | 524530-1 | 1 |
| 31 | SPRING, .75 LTH COMPRESSION | P32011 | 1 |
| 32 | BOLT, 8/M6X25-12.9 ISO 7379 SHOULDER | F81001-47 | 1 |
| 33 | WASHER, 6.4 FLAT ZINC | F81053-1 | 3 |
| 34 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 1 |
| 35 | WASHER, Z 6.1 SPLIT LOCK ZINC | F81053-3 | 2 |
| 36 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 2 |
| 37 | BOLT, 8/M6X20-12.9 ISO 7379 SHOULDER | F81001-25 | 2 |
| 38 | SPRING, #LE-063E-8MW | P08848 | 1 |
| 39 | SPRING, .48 OD X 3/4 L X .063 WIRE COMPRESSION | 060539 | 2 |
| 40 | BOLT, M6X35-8.8 HEX HEAD ZINC | F81001-71 | 1 |
| 41 | NUT, M6 8 HEX ZINC | F81031-1 | 1 |
| 42 | WASHER, 6.4 FLAT ZINC | F81053-1 | 1 |
| - | GAUGE ASSEMBLY, TOOTH SET | 524539 | 1 |
| 43 | BRACKET, GAUGE MOUNT ZINC-PLATED | 524540-1 | 1 |
| 44 | INSERT, SETTER CLAMPING STL (METRIC) | 066609 | 1 |
| 45 | GAUGE ASSEMBLY, TOOTH SET | 061771 | 1 |
| 46 | SCREW, M5X16-8.8 DIN7991 FLAT SOCKET HEAD CAP ZINC | F81000-47 | 1 |

6**Replacement Parts***Dual Toothsetter Right Head*

| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| 47 | SCREW, M10X55-8.8 HEX SOCKET HEAD CAP ZINC | F81003-55 | 2 | |
| 48 | SCREW, GN 913.5-M6-12-KU (ELESA+GANter) STAINLESS STEEL SET | F81001-78 | 1 | |
| 49 | BOLT, DIN933-M10X30-8.8-A2E HEX HEAD | F81003-111 | 2 | |

6.7 Dual Toothsetter Left Head

524536_001
524536_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|----------|-----|
| - | HEAD, DUAL TOOTHSETTER LEFT - COMPLETE | 524536 | 1 |
| 1 | PLATE, HEAD BASE ZINC-PLATED. | 524516-1 | 1 |
| - | ARM, DUAL TOOTHSETTER - COMPLETE | 524520 | 1 |

6

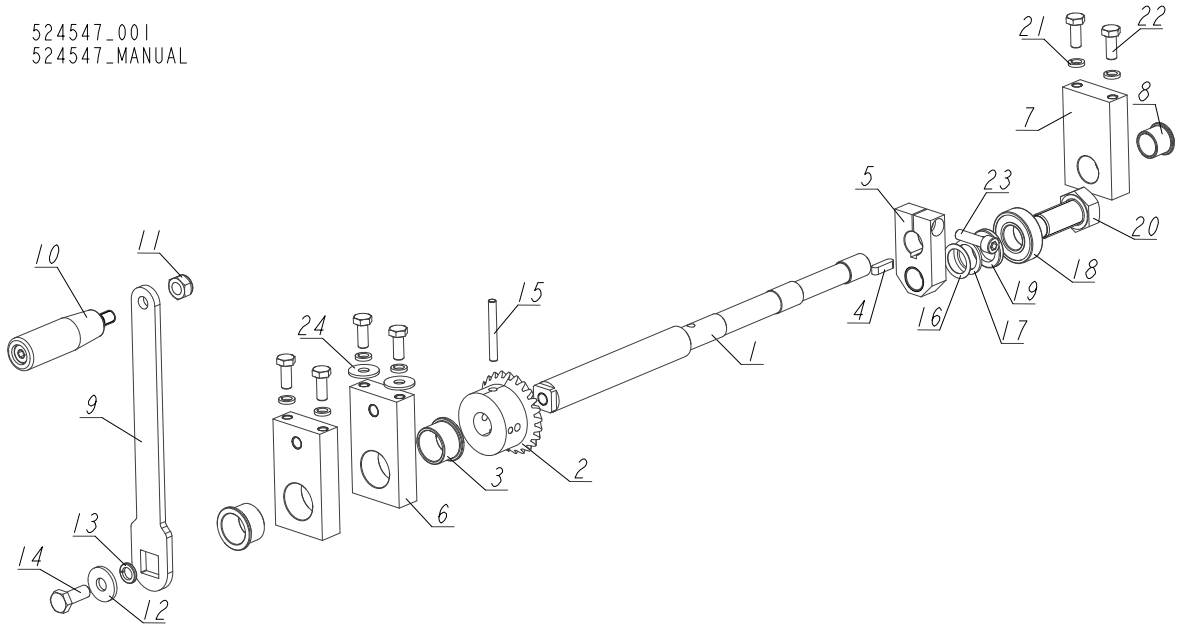
Replacement Parts*Dual Toothsetter Left Head*

| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| 2 | ARM, DUAL TOOTHSETTER ZINC-PLATED | 524521-1 | 1 | |
| 3 | BEARING, 6000.2RSR | 087471 | 4 | |
| 4 | RING, W26 INSIDE RETAINING | F81090-34 | 1 | |
| 5 | BUSHING, 10.5X16X4SPACER, ZINC-PLATED | 525238-1 | 2 | |
| 6 | BLOCK, ZINC-PLATED SUPPORT | 524528-1 | 2 | |
| 7 | PLATE, PUSHER ARM SIDE ZINC-PLATED | 524525-1 | 2 | |
| 8 | WASHER, 20.5X26X1.5 ZINC-PLATED | 524526-1 | 2 | |
| 9 | BEARING, 6004 2RS CX ROLLING | 093868 | 1 | |
| 10 | PLATE, SPRING ADJUSTMENT ZINC-PLATED | 524515-1 | 1 | |
| 11 | SPRING, 3/4 OD X 1-1/2 L X .165X.125 WIRE DIE | 060499 | 1 | |
| 12 | BOLT, PUSHER ADJUSTMENT | 524531 | 1 | |
| 13 | PUSHER, SETTER | 060597 | 1 | |
| 14 | PLATE, HEAD TOP ZINC-PLATED | 524527-1 | 1 | |
| 15 | SCREW, M4X8 8.8 HEX SOCKET HEAD CAP ZINC | F81011-36 | 4 | |
| 16 | BOLT, M10X95-8.8-B HEX HEAD ZINC | F81003-71 | 1 | |
| 17 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 1 | |
| 18 | SCREW, M8X40-8.8 HEX SOCKET HEAD CAP ZINC | F81002-29 | 4 | |
| 19 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 4 | |
| 20 | BOLT, M6X35-8.8 HEX HEAD ZINC | F81001-71 | 2 | |
| 21 | BOLT, M6X50-8.8 FE/ZN5 DIN-6921 HEX FLANGE | F81001-35 | 1 | |
| 22 | SCREW, GN 913.5-M6-12-KU STAINLESS STEEL SET (ELESA+GANTER) | F81001-78 | 2 | |
| 23 | NUT, M20 ISO 4035 THIN ZINC | F81037-9 | 1 | |
| 24 | BOLT, M20X40-8.8 HEX HEAD FULL THREAD ZINC | F81007-11 | 1 | |
| 25 | SCREW, M8X20-45H GEOMET DIN913 SOCKET SET | F81002-103 | 2 | |
| 26 | NUT, M8-04-FE/ZN ISO4035 HEX THIN | F81032-8 | 2 | |
| 27 | BOLT, M6X60-8.8 HEX HEAD FULL THREAD ZINC | F81001-9 | 1 | |
| 28 | NUT, M6 8 HEX ZINC | F81031-1 | 3 | |
| 29 | CLAMP WELDMENT, HEAD ZINC-PLATED | 524517-1 | 1 | |
| - | GUIDE ASSEMBLY, BLADE | 524537 | 1 | |
| 30 | BRACKET, BLADE GUIDE ZINC-PLATED | 524530-1 | 1 | |
| 31 | SPRING, .75 LTH COMPRESSION | P32011 | 1 | |
| 32 | BOLT, 8/M6X25-12.9 ISO 7379 SHOULDER | F81001-47 | 1 | |
| 33 | WASHER, 6.4 FLAT ZINC | F81053-1 | 3 | |
| 34 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 1 | |
| 35 | WASHER, Z 6.1 SPLIT LOCK ZINC | F81053-3 | 2 | |
| 36 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 2 | |
| 37 | BOLT, 8/M6X20-12.9 ISO 7379 SHOULDER | F81001-25 | 2 | |
| 38 | SPRING, #LE-063E-8MW | P08848 | 1 | |
| 39 | SPRING, .48 OD X 3/4 L X .063 WIRE COMPRESSION | 060539 | 2 | |
| 40 | BOLT, M6X35-8.8 HEX HEAD ZINC | F81001-71 | 1 | |
| 41 | NUT, M6 8 HEX ZINC | F81031-1 | 1 | |
| 42 | WASHER, 6.4 FLAT ZINC | F81053-1 | 1 | |

| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| - | GAUGE ASSEMBLY, TOOTH SET | 524539 | 1 | |
| 43 | BRACKET, GAUGE MOUNT ZINC-PLATED | 524540-1 | 1 | |
| 44 | INSERT, SETTER CLAMPING STL (METRIC) | 066609 | 1 | |
| 45 | GAUGE ASSEMBLY, TOOTHSETTER | 061771 | 1 | |
| 46 | SCREW, M5X16-8.8 DIN7991 FLAT SOCKET HEAD CAP ZINC | F81000-47 | 1 | |
| 47 | SCREW, M10X55-8.8 HEX SOCKET HEAD CAP ZINC | F81003-55 | 2 | |
| 48 | SCREW, GN 913.5-M6-12-KU STAINLESS STEEL SET (ELESA+GAN-TER) | F81001-78 | 1 | |
| 49 | BOLT, DIN933-M10X30-8.8-A2E HEX HEAD | F81003-111 | 2 | |
| 50 | T-NUT, M10 ZINC-PLATED SPECIAL | 524546-1 | 2 | |

6.8 Index Shaft Assembly

524547_001
524547_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| - | SHAFT, INDEX - COMPLETE | 524547 | 1 |
| 1 | SHAFT, INDEX ZINC-PLATED | 524548-1 | 1 |
| 2 | GEAR, 10 PITCH X 2.5 PITCH DIA X 3/4" BORE | 060565 | 1 |
| 3 | BUSHING, AMES B 25X30X25/35 FLANGED | 524555 | 2 |
| 4 | KEY, A 6X6X22 PARALLEL | 519161 | 1 |
| 5 | BLOCK, CAM ZINC-PLATED | 524549-1 | 1 |
| 6 | BLOCK, INDEX SHAFT ZINC-PLATED SUPPORT - RIGHT | 524550-1 | 2 |
| 7 | BLOCK, INDEX SHAFT ZINC-PLATED SUPPORT - LEFT | 524551-1 | 1 |
| 8 | BUSHING, AMES B 18X22X18/26 FLANGED | 524556 | 1 |
| - | CRANK HANDLE - COMPLETE | 524553 | 1 |
| 9 | ARM, CRANK HANDLE ZINC-PLATED | 524554-1 | 1 |
| 10 | KNOB, L=85 M10, RO11-M10 PLASTC CRANK HANDLE | 086338 | 1 |
| 11 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 1 |
| 12 | WASHER, 10.5 SPECIAL FLAT ZINC | F81055-6 | 1 |
| 13 | WASHER, Z 10.2 SPLIT LOCK ZINC | F81055-2 | 1 |
| 14 | BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC | F81003-11 | 1 |
| 15 | PIN, 6X50 ROLL ZINC | F81045-1 | 1 |
| 16 | WASHER, 20X28X0.5 ADJUSTMENT | 524552 | 1 |
| 17 | RING, 20.5X28X2 ZINC-PLATED SPACER | 524557-1 | 1 |

| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|--|
| 18 | BEARING, 6004 2RS CX ROLLING | 093868 | 1 | |
| 19 | WASHER, 20.5 SPLIT LOCK ZINC | F81059-1 | 1 | |
| 20 | BOLT, M20X40-8.8 HEX HEAD FULL THREAD ZINC | F81007-11 | 1 | |
| 21 | WASHER, 8.2 SPLIT LOCK ZINC | F81054-4 | 6 | |
| 22 | BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC | F81002-4 | 6 | |
| 23 | SCREW, M8X30-8.8 HEX SOCKET HEAD CAP ZINC | F81002-31 | 1 | |
| 24 | WASHER, ISO 7093-1-8-200 HV-A2E | F81054-11 | 2 | |

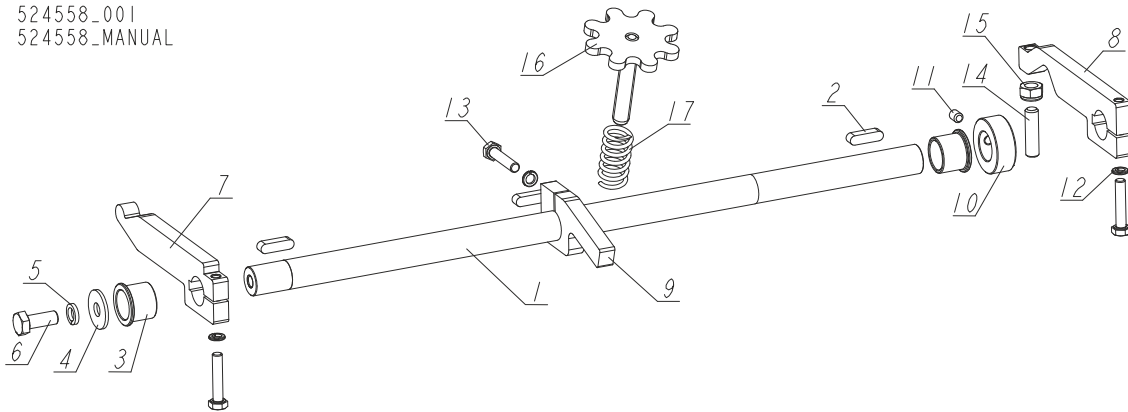
6

Replacement Parts

Blade Height Adjuster Assembly

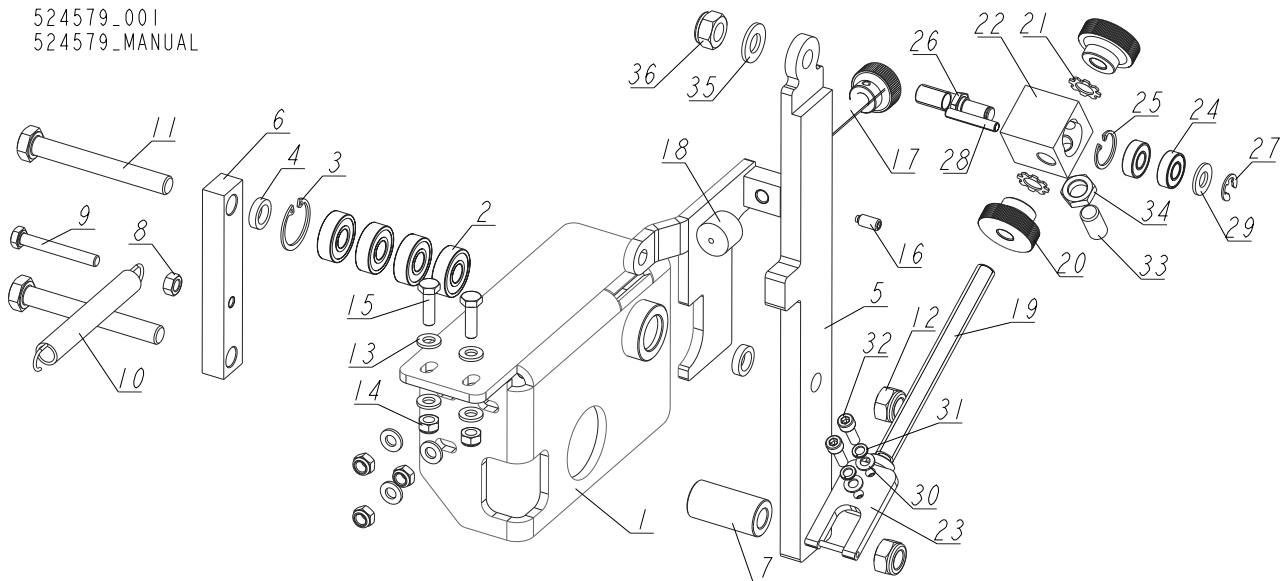
6.9 Blade Height Adjuster Assembly

524558_001
524558_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|------------|-----|
| - | ADJUSTER ASSEMBLY, BLADE HEIGHT | 524558 | 1 |
| 1 | SHAFT, BLADE HEIGHT ADJUSTER ZINC-PLATED | 524559-1 | 1 |
| 2 | KEY, A 6X6X22 PARALLEL | 519161 | 3 |
| 3 | BUSHING, AMES B 18X22X18/26 FLANGED | 524556 | 2 |
| 4 | WASHER, ISO 7093-1-8-200 HV-A2E | F81054-11 | 1 |
| 5 | WASHER, 8.2 SPLIT LOCK ZINC | F81054-4 | 1 |
| 6 | BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC | F81002-4 | 1 |
| 7 | ARM, BLADE HEIGHT ZINC-PLATED | 524562-1 | 1 |
| 8 | ARM, BLADE HEIGHT ZINC-PLATED ADJUSTABLE | 524560-1 | 1 |
| 9 | ARM, ZINC-PLATED ADJUSTER | 524561-1 | 1 |
| 10 | COLLAR, 18 ZINC-PLATED | 524563-1 | 1 |
| 11 | SCREW, M6X10-45H HEX SOCKET ZINC SET W/FLAT POINT | F81001-26 | 1 |
| 12 | WASHER, Z 6.1 SPLIT LOCK ZINC | F81053-3 | 3 |
| 13 | BOLT, M6X30-8.8 HEX HEAD FULL THREAD ZINC | F81001-8 | 3 |
| 14 | SCREW, M8X30-45H GEOMET HEX SOCKET SET W/FLAT POINT | F81002-104 | 1 |
| 15 | NUT, M8-8-B HEX NYLON ZINC LOCK | F81032-2 | 1 |
| 16 | ADJUSTER WELDMENT, M10 BLADE HEIGHT ZINC-PLATED | 525313-1 | 1 |
| 17 | SPRING, 18.29X38.1X2.44 STAINLESS STEEL (1217366-ESSENTRA) | 525315 | 1 |

6.10 Complete Blade Pusher (No. 524579)

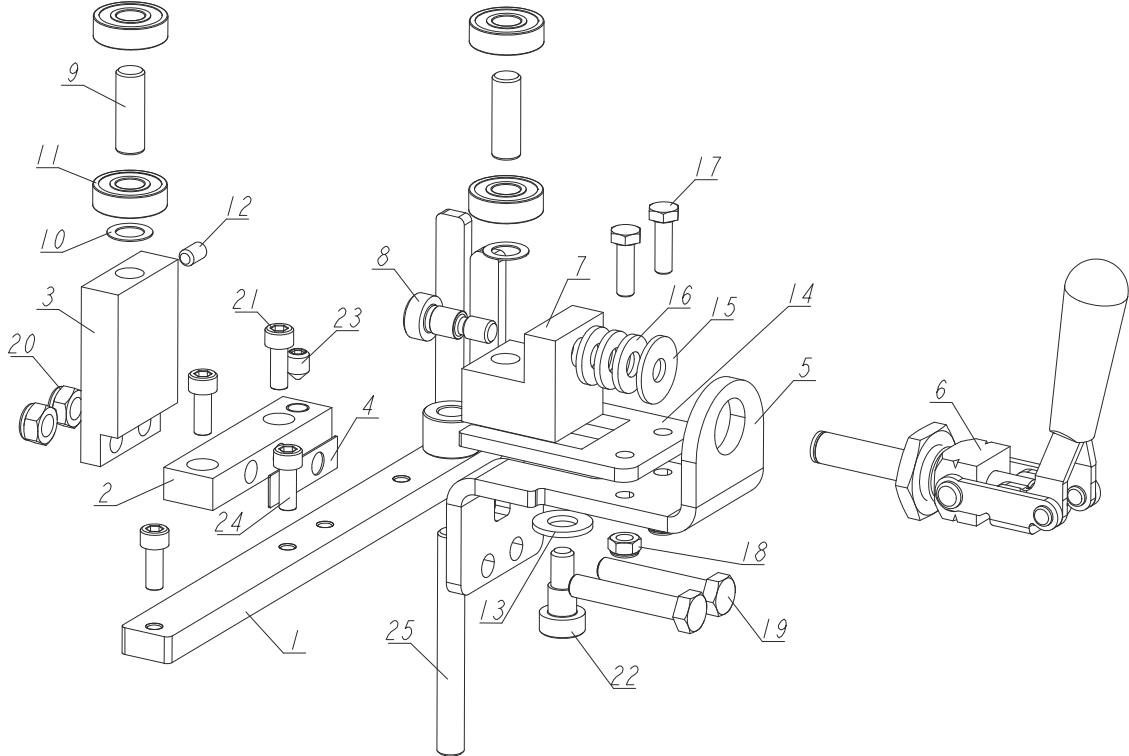


| REF. | DESCRIPTION (* indicates parts available in assemblies only) | PART # | QTY |
|------|--|-----------|-----|
| - | PUSHER, BLADE - COMPLETE | 524579 | 1 |
| 1 | MOUNT WELDMENT, BLADE PUSHER ZINC-PLATED | 524586-1 | 1 |
| 2 | BEARING, 6000 2RSR | 087471 | 4 |
| 3 | RING, W26 INSIDE RETAINING | F81090-34 | 1 |
| 4 | BUSHING, 10.5X16X4 ZINC-PLATED SPACER | 525238-1 | 2 |
| 5 | ARM, BLADE PUSHER ZINC-PLATED | 525240-1 | 1 |
| 6 | ROD, HARDENED DRIVE | 525239 | 1 |
| 7 | BUSHING, 10.5X19X40 ZINC-PLATED | 525237-1 | 1 |
| 8 | NUT, M6 8 HEX ZINC | F81031-1 | 1 |
| 9 | BOLT, M6X45-8.8 HEX HEAD ZINC | F81001-6 | 1 |
| 10 | SPRING, #LE-063E-8MW | P08848 | 1 |
| 11 | BOLT, M10X80-8.8 HEX HEAD ZINC | F81003-50 | 2 |
| 12 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 2 |
| 13 | WASHER, 6.4 FLAT ZINC | F81053-1 | 10 |
| 14 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 5 |
| 15 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 5 |
| 16 | SCREW, GN 913.5-M6-12-KU (ELESA+GANTER) STAINLESS STEEL SET | F81001-78 | 1 |
| 17 | BOLT, M8X1 L=89 BUMPER | 525241 | 1 |
| 18 | BUMPER, THREADED RUBBER 3/4 OD X 5/16-24 | 060529 | 1 |
| - | PAWL, PUSH - COMPLETE | 524580 | 1 |
| 19 | PAWL WELDMENT, M10X1 ZINC-PLATED | 524582-1 | 1 |
| 20 | NUT, M10X1 ZINC-PLATED ADJUSTMENT | 524585-1 | 2 |
| 21 | WASHER, 10.5 EXTERNAL TOOTH ZINC LOCK | F81055-3 | 2 |
| 22 | BLOCK, PUSH PAWL ZINC-PLATED | 524581-1 | 1 |
| 23 | PLATE, PUSH PAWL - COMPLETE | 524584 | 1 |
| 24 | BEARING, 619/8-2RS1 ROLLING (SKF) | 525250 | 2 |
| 25 | RING, W22 INSIDE RETAINING | F81090-67 | 1 |

| REF. | DESCRIPTION (* indicates parts available in assemblies only) | PART # | QTY | |
|------|--|-----------|-----|--|
| 26 | SHAFT, PUSH PAWL ZINC-PLATED | 525249-1 | 1 | |
| 27 | WASHER, 7 DIN6799/PN-85112 RETAINING | F81090-60 | 1 | |
| 28 | PIN, 5X30 ZINC-PLATED ROLL | F81044-21 | 1 | |
| 29 | WASHER, 8.4 FLAT ZINC | F81054-1 | 1 | |
| 30 | WASHER, 5.3 FLAT ZINC | F81052-1 | 2 | |
| 31 | WASHER, 5.1 SPLIT LOCK | F81052-2 | 2 | |
| 32 | SCREW, M5X16-8.8 HEX SOCKET HEAD CAP ZINC | F81000-25 | 2 | |
| 33 | SCREW, M10X1X20 DIN 913 STAINLESS STEEL SET | F81015-1 | 1 | |
| 34 | NUT, M10X1 DIN 439 THIN STAINLESS STEEL | F81033-7 | 1 | |
| 35 | WASHER, 10.5 FLAT ZINC | F81055-1 | 1 | |
| 36 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 1 | |

6.11 Blade Clamp & Guide

524564_001
524564_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| - | BLADE CLAMP & GUIDE - COMPLETE | 524564 | 1 |
| - | BAR WELDMENT, CLAMP BASE ZINC-PLATED | 524565-1 | 1 |
| 1 | BAR, CLAMP BASE | 524566 | 1 |
| - | CLAMP, BLADE - COMPLETE | 524578 | 1 |
| 2 | BLOCK, CLAMP ZINC-PLATED MOUNTING | 524571-1 | 1 |
| 3 | PLATE, CLAMP BEARING ZINC-PLATED | 524572-1 | 1 |
| 4 | WASHER, 45X12X0.7 ZINC-PLATED SPACER | 524573-1 | 1 |
| 5 | PLATE, CLAMP HANDLE ZINC-PLATED SUPPORT | 524576-1 | 1 |
| 6 | HANDLE, 38 M20 CLAMP (#493811-ESSENTIA) | 524569 | 1 |
| 7 | BLOCK, CLAMP BEARING ZINC-PLATED | 524575-1 | 1 |
| 8 | BOLT, 10/M8X12-12.9 BOSSARD SHOULDER | F81003-62 | 1 |
| 9 | PIN, 10M6X30 DIN 6325 HRC60 DOWEL | F81048-93 | 2 |
| 10 | WASHER, 10.1X16X0.5 SPACER | 524574 | 2 |
| 11 | BEARING, 6000.2RSR | 087471 | 4 |
| 12 | SCREW, M6X10-45H FE/ZN5 HEX SOCKET SET W/FLAT POINT | F81001-26 | 2 |

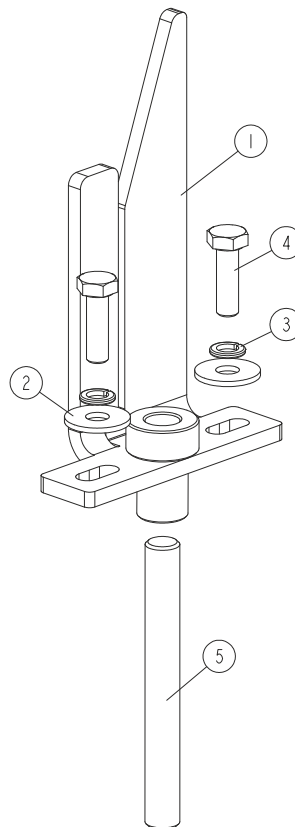
6

Replacement Parts*Blade Clamp & Guide*

| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| 13 | WASHER, 10.5 FLAT ZINC | F81055-1 | 1 | |
| 14 | PLATE, BEARING BLOCK GUIDE ZINC-PLATED | 524577-1 | 1 | |
| 15 | WASHER, ISO 7093-1-8-200 HV-A2E | F81054-11 | 1 | |
| 16 | WASHER, 3/8 X 13/16 X .093 RUBBER | 060531 | 3 | |
| 17 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 2 | |
| 18 | NUT, M6-8-B HEX NYLON ZINC LOCK | F81031-2 | 2 | |
| 19 | BOLT, M8X45-8.8 HEX HEAD ZINC | F81002-17 | 2 | |
| 20 | NUT, M8-8-B HEX NYLON ZINC LOCK | F81032-2 | 2 | |
| 21 | SCREW, M6X16 8.8 HEX SOCKET HEAD CAP ZINC | F81001-21 | 2 | |
| 22 | BOLT, M10X10 SH SHOULDER PLAIN | F05022-9 | 1 | |
| 23 | SCREW, M8X10-45H ZINC SET | F81002-46 | 1 | |
| 24 | SCREW, M6X16 8.8 HEX SOCKET HEAD CAP ZINC | F81001-21 | 2 | |
| 25 | PIN, 3/8 X 3-1/4 DOWEL | F05012-130 | 1 | |

6.12 Outfeed Blade Guide

525245_001
 525245_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| - | GUIDE, BLADE OUTFEED - COMPLETE | 525245 | 1 | |
| 1 | GUIDE WELDMENT, BLADE OUTFEED ZINC-PLATED | 525246-1 | 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 | |
| 5 | PIN, 3/8 X 3-1/4 DOWEL | F05012-130 | 1 | |

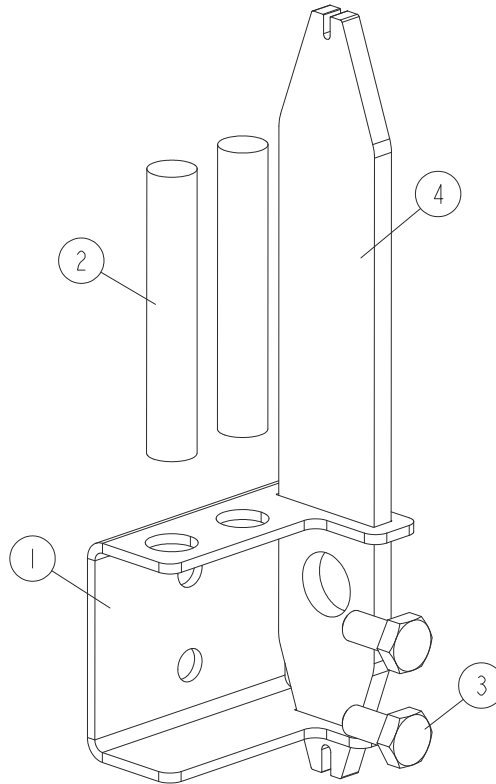
6

Replacement Parts

Optional Tool Set

6.13 Optional Tool Set

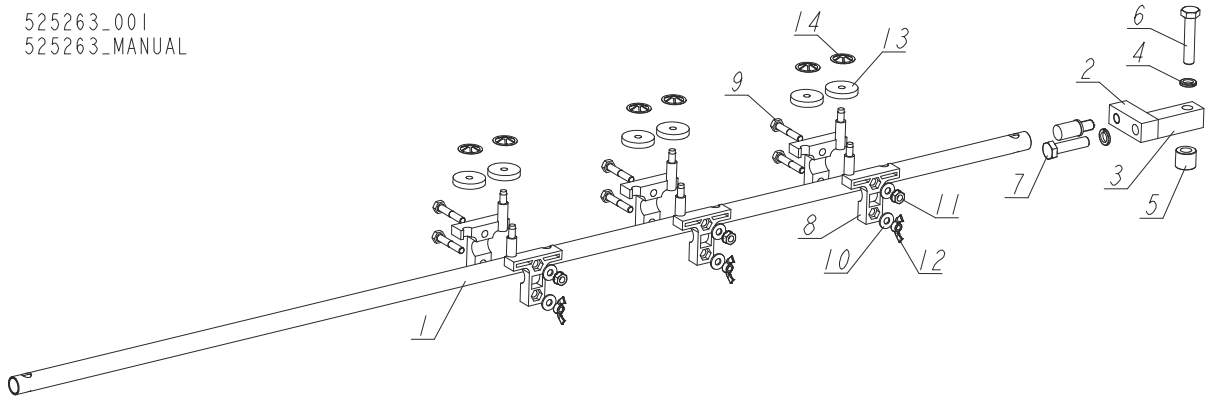
525275_001
525275_MANUAL



| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|------------|-----|--|
| - | TOOL SET, OPTIONAL - COMPLETE | 525275 | 1 | |
| 1 | BRACKET, TOOL SET ZINC-PLATED | 525274-1 | 1 | |
| 2 | PIN, DOWELL 3/8 X 2 1/4 HARDENED | F05012-106 | 2 | |
| 3 | BOLT, M6X12 8.8 HEX HEAD FULL THREAD ZINC | F81001-7 | 2 | |
| 4 | TOOL, BEND BACK | 023774 | 1 | |

6.14 Blade Support Arm

525263_001
525263_MANUAL

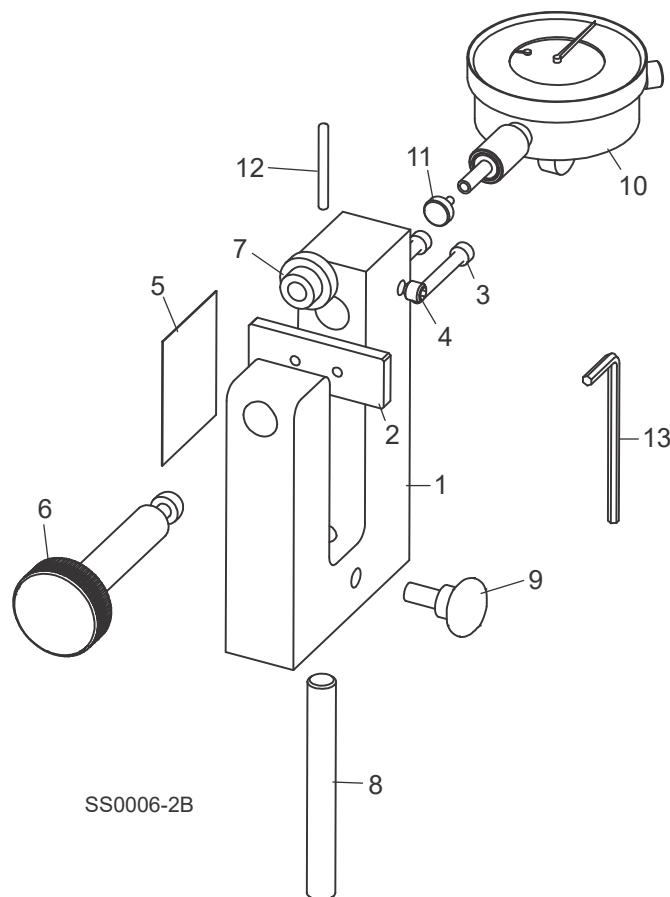


| REF. | DESCRIPTION (* Indicates Parts Available in Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|--|
| - | ARM, BLADE SUPPORT - COMPLETE | 525263 | 1 | |
| 1 | TUBE, BLADE SUPPORT ZINC-PLATED | 525320-1 | 1 | |
| 2 | BLOCK | 522462-1 | 1 | |
| 3 | BLOCK | 522461-1 | 1 | |
| 4 | WASHER, Z 10.2 SPLIT LOCK ZINC | F81055-2 | 2 | |
| 5 | BUSHING, 11/20-17 ZINC-PLATED | 094255-1 | 1 | |
| 6 | BOLT, M10X50-8.8 HEX HEAD FULL THREAD ZINC | F81003-4 | 1 | |
| 7 | BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC | F81003-16 | 1 | |
| - | SUPPORT, BLADE SINGLE | A30008 | 3 | |
| 8 | GUIDE, BLADE SUPPORT W/POST | S10611 | 2 | |
| 9 | BOLT, 1/4-20X1 1/2 HEX HEAD GRADE 2 | F05005-5 | 2 | |
| 10 | WASHER, 1/4 SAE FLAT | F05011-11 | 2 | |
| 11 | NUT, 1/4-20 KEPS | F05010-9 | 1 | |
| 12 | NUT, 1/4-20 WING | F05010-13 | 1 | |
| 13 | WHEEL, BLADE SUPPORT | S10539 | 6 | |
| 14 | NUT, 1/4 DIA PUSH | P10614 | 6 | |

6

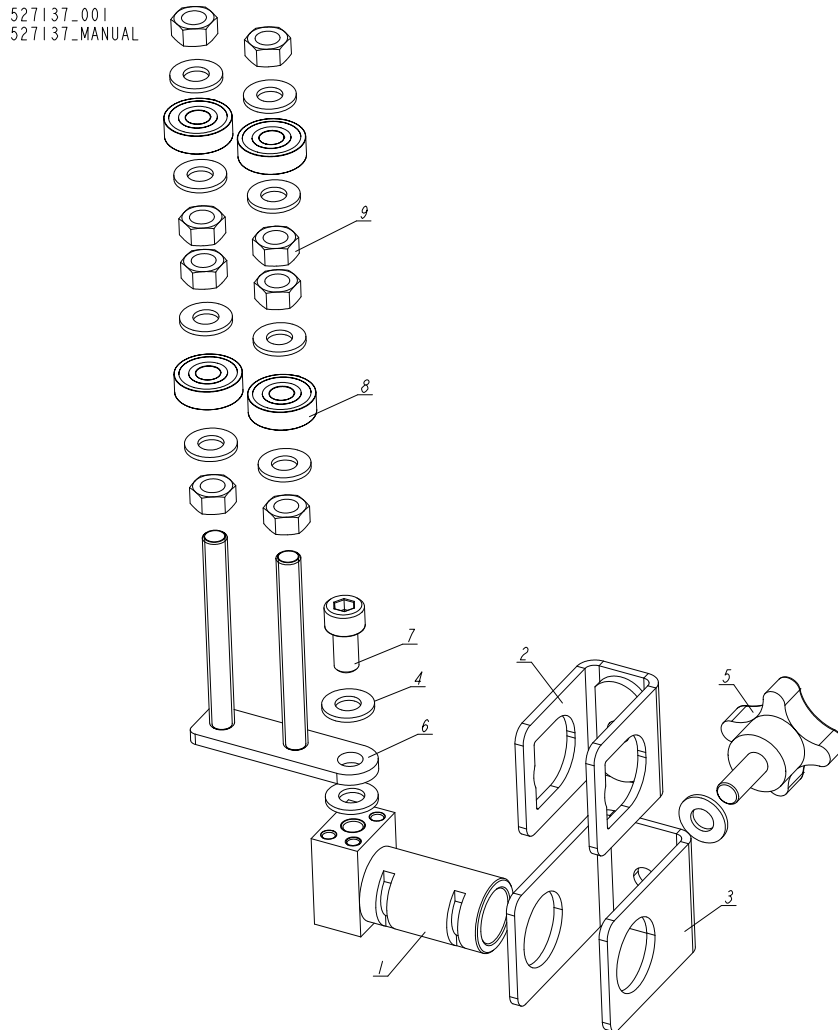
Replacement Parts Tooth Set Gauge Assembly

6.15 Tooth Set Gauge Assembly



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--|------------|-----|
| | GAUGE ASSEMBLY, TOOTH SET BOXED | 060490 | 1 |
| 1 | Block, Tooth Set Gauge | 060495 | 1 |
| 2 | Plate, Tooth Set Clamp | 060494 | 1 |
| 3 | Screw, #8-32 x 1 1/4" Socket Head | F05004-225 | 2 |
| 4 | Screw, 1/4-20 x 1/4" Cup Point Socket Set | F05005-131 | 1 |
| 5 | Decal, Blade Reorder (Small) | 060479 | 1 |
| 6 | Knob, 1/2-13 x 2 15/16" x 1 1/4" Steel | 060488 | 1 |
| 7 | Pad, 3/4" Dia. Steel Swivel | 060487 | 1 |
| 8 | Pin, 3/8" Dia. x 3 1/4" Dowel | F05012-130 | 1 |
| 9 | Knob, 1/4-20 x 1/2" 4-Lobe Plastic | 060489 | 1 |
| 10 | Gauge Assembly, Tooth Set | 060491 | 1 |
| 11 | Foot, Tooth Set Gauge | P04716-2 | 1 |
| 12 | Pin, 1/8" x 1 1/4" Dowel | F05012-132 | 1 |
| 13 | Wrench, 1/8" Hex | P06187 | 1 |

6.16 Side Blade Guide



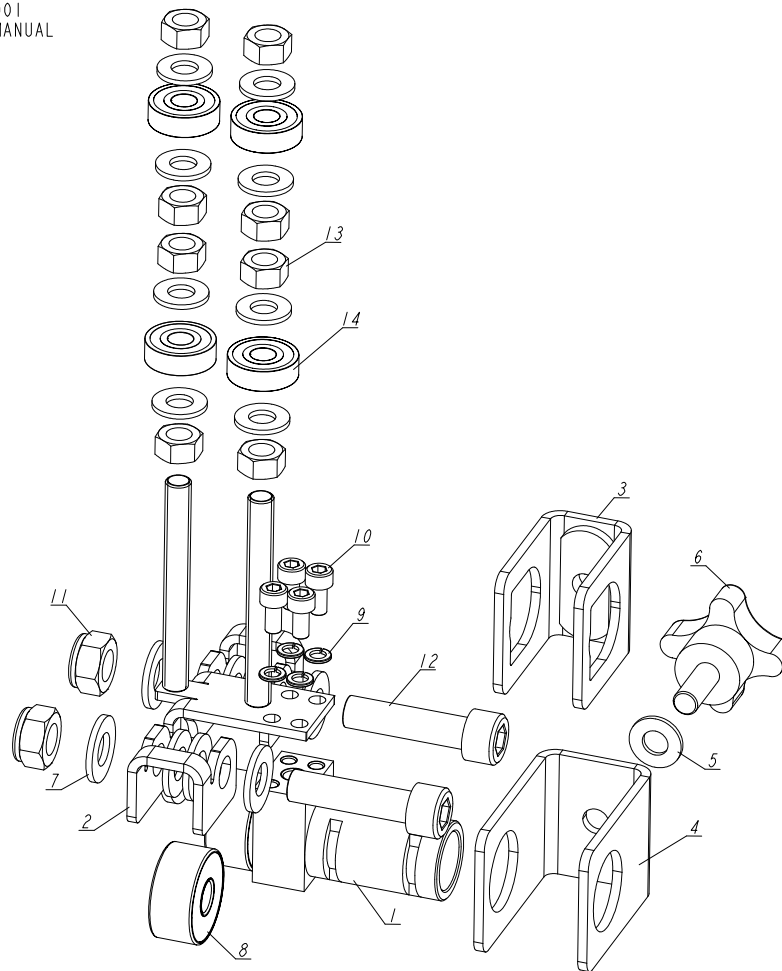
| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|--|
| - | GUIDE, SIDE BLADE - COMPLETE | 527137 | 1 | |
| 1 | BASE, BLADE GUIDE ZINC-PLATED | 525323-1 | 1 | |
| 2 | CHANNEL, CLAMPING ZINC-PLATED | 525328-1 | 1 | |
| 3 | CHANNEL, BLADE GUIDE ZINC-PLATED | 525330-1 | 1 | |
| 4 | WASHER, 8.4 FLAT ZINC | F81054-1 | 11 | |
| 5 | KNOB, SR.40/M8X20 STAR (462053 MOSS) | 500973 | 1 | |
| 6 | BRACKET, SIDE BLADE GUIDE ZINC-PLATED | 527138-1 | 1 | |
| 7 | SCREW, M8X16-8.8 HEX SOCKET HEAD CAP ZINC | F81002-39 | 1 | |
| 8 | BEARING, 608 2RS BALL | 086197 | 4 | |
| 9 | NUT, M8-8-B HEX ZINC | F81032-1 | 8 | |

6

Replacement Parts Rear Blade Guide

6.17 Rear Blade Guide

525322.001
525322.MANUAL



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--|-----------|-----|
| - | GUIDE, REAR BLADE - COMPLETE | 525322 | 1 |
| 1 | BASE, BLADE GUIDE ZINC-PLATED | 525323-1 | 1 |
| 2 | BRACKET, BLADE GUIDE ROLLER ZINC-PLATED | 525325-1 | 1 |
| 3 | CHANNEL, CLAMPING ZINC-PLATED | 525328-1 | 1 |
| 4 | CHANNEL, BLADE GUIDE ZINC-PLATED | 525330-1 | 1 |
| 5 | WASHER, 8.4 FLAT ZINC | F81054-1 | 9 |
| 6 | KNOB, SR.40/M8X20 STAR (462053 MOSS) | 500973 | 1 |
| 7 | WASHER, 10.5 FLAT ZINC | F81055-1 | 8 |
| 8 | BEARING, 62200-2RSR | 525324 | 2 |
| 9 | WASHER, 5.1 SPLIT LOCK | F81052-2 | 4 |
| 10 | SCREW, M5X10 DIN 912 A2-70 HEX SOCKET HEAD CAP STAINLESS STEEL | F81000-23 | 4 |

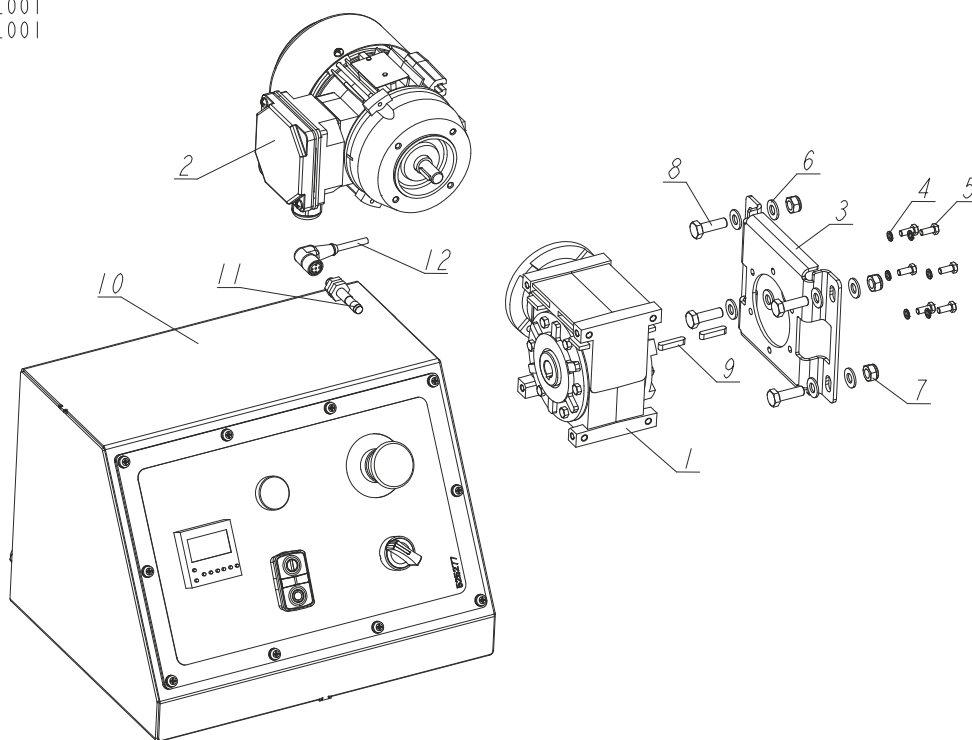
| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|--|
| 11 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 2 | |
| 12 | SCREW, M10X40-8.8 HEX SOCKET HEAD CAP ZINC | F81003-22 | 2 | |
| 13 | NUT, M8-8-B HEX ZINC | F81032-1 | 8 | |
| 14 | BEARING, 608 2RS BALL | 086197 | 4 | |

6

Replacement Parts BMT250 Toothsetter Drive

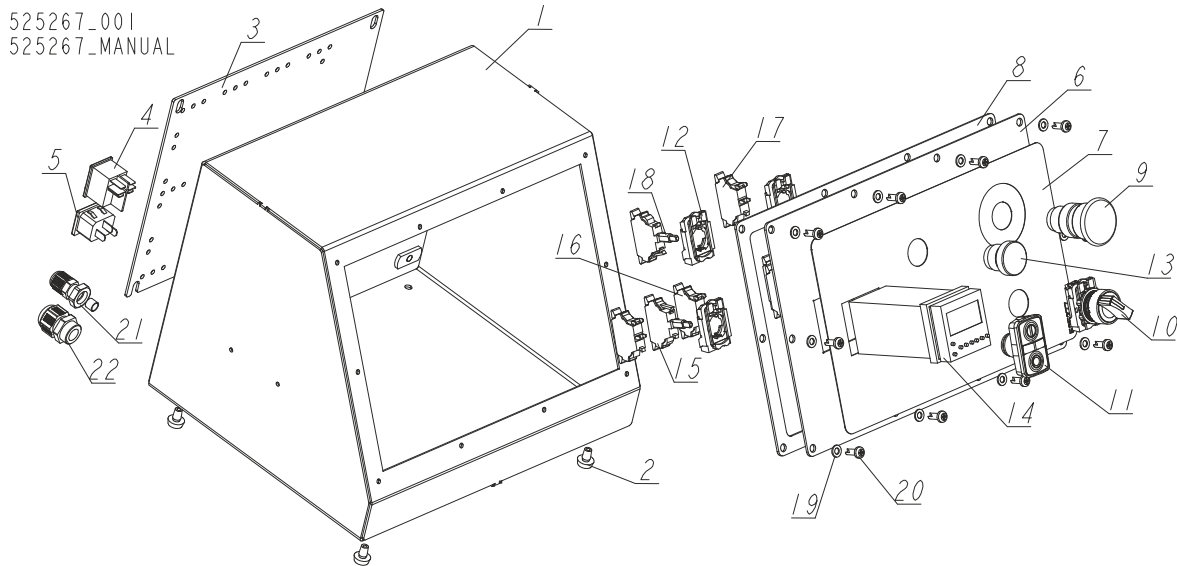
6.18 BMT250 Toothsetter Drive

525265_001
525265_001



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--|----------|-----|
| - | DRIVE, BMT250 120/230V TOOTHSETTER - COMPLETE | 525265 | 1 |
| 1 | MOTOREDUCER, MRA-03/39/0,12-1400/B8 | 508440 | 1 |
| 2 | MOTOR, SKH-63-4A2, 012 KW,1400, UL, CE | 508441 | 1 |
| 3 | PLATE, MOTOREDUCER ZINC-PLATED MOUNT | 525266-1 | 1 |
| 4 | WASHER, 5.1 SPLIT LOCK ZINC | F81052-2 | 6 |
| 5 | BOLT, M5X12 8.8 HEX HEAD FULL THREAD ZINC | F81000-5 | 6 |
| 6 | WASHER, 8.4 FLAT ZINC | F81054-1 | 8 |
| 7 | NUT, M8-8-B HEX NYLON ZINC LOCK | F81032-2 | 4 |
| 8 | BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC | F81002-5 | 4 |
| 9 | KEY, A5X5X25 PARALLEL | 089432 | 2 |
| 10 | BOX, AC120/230V CONTROL | 525267 | 1 |
| 11 | PROXIMITY SENSOR, 8MM PNP SHIELDED QD RSHP | 052291 | 1 |
| 12 | PROXIMITY CABLE, 8MM 2 M LENGTH, 90 DEGREE | 050063 | 1 |

6.19 Toothsetter Control Box



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--|----------|-----|
| - | BOX, AC120/230V TOOTHSETTER CONTROL | 525267 | 1 |
| 1 | BOX, BMT250 TOOTHSETTER CONTROL | 525268-1 | 1 |
| 2 | FOOT, SR1591 12X6 #50185 MOSS | 101279 | 4 |
| 3 | PLATE, CONTROL BOX ZINC-PLATED MOUNT | 525273-1 | 1 |
| 4 | SWITCH, I/O ROCKER | 060515 | 1 |
| 5 | RECEPTACLE, POWER ENTRY | 060216 | 1 |
| - | PANEL, AC120/230V AUTO FEED CONTROL | 525276 | 1 |
| 6 | PANEL, FRONT CONTROL | 525272-1 | 1 |
| 7 | DECAL, CONTROL BOX | 525277 | 1 |
| 8 | GASKET, CONTROL BOX | 525278 | 1 |
| 9 | PUSH BUTTON HEAD, E-STOP P-P ZB5 | 068942 | 1 |
| 10 | SWITCH, 1NO 2PMAINT SELECTOR ZB5 | 066690 | 1 |
| 11 | PUSH BUTTON, GRN/RED MARKED FLUSH | 068909 | 1 |
| 12 | SWITCH COLLAR, MOUNT ZB5 | 068951 | 3 |
| 13 | HEAD, ZB5 WHITE PILOT LIGHT | 068932 | 1 |
| 14 | COUNTER ASSY, AC DUAL TOOTH SETTER | 069686 | 1 |
| 15 | LIGHT MODULE, GREEN ZB5 | 068910 | 1 |
| 16 | CONTACT BLOCK, NO ZB5 | 068920 | 2 |
| 17 | CONTACT BLOCK, NCZB5 | 068921 | 3 |
| 18 | LIGHT MODULE, WHITE ZB5 | 068912 | 1 |
| 19 | WASHER, 5.3 FLAT ZINC | F81052-1 | 10 |

6**Replacement Parts**
Toothsetter Control Box

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY | |
|------|--|-----------|-----|--|
| 20 | BOLT, #10-24X1/2 PH | F05015-17 | 10 | |
| 21 | GLAND, DP 7/H CABLE | F81096-11 | 1 | |
| 22 | GLAND, PG11 CABLE | F81096-9 | 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: **Automatic Setter**

TYPE: BMT200

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 12100:2012
PN-EN ISO 13849-1:2016-02
PN-EN 60204-1:2018-12

Responsible for Technical Documentation:

Piotr Adamiec / 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, 01.03.2013



Title :

Engineering Manager

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
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We, the undersigned herewith declare, that:

Designation of the machine: **Automatic Setter**

TYPE: BMT250

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 12100:2012
PN-EN ISO 13849-1:2016-02
PN-EN 60204-1:2018-12

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