

Wood-Mizer[®]
Sharpener and Setter
Safety, Operation, Parts
& Maintenance Manual

BMST50

Rev. A1.00



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

Form #2056

Table of Contents

Section-Page

General Contact Information

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

SECTION 1	INTRODUCTION	1-1
1.1	About this manual.....	1-1
1.2	Safety.....	1-2
	<i>Blade handling safety</i>	
	<i>Machine operation safety</i>	
	<i>Decal meaning</i>	
1.3	Machine Start.....	1-5
	DANGER! <i>It is recommended that a 30mA Ground Fault Interrupter (GFI) be used.</i>	
1.4	Major Components.....	1-7
1.5	Dimensions and Specifications.....	1-10
SECTION 2	SET UP	2-1
2.1	Items required but NOT included.....	2-1
2.2	Items included.....	2-2
2.3	Install the lubrication pump.....	2-3
2.4	Mount the base unit.....	2-4
2.5	Install the drain pipe.....	2-4
2.6	Install the operators handles.....	2-5
2.7	Mount the blade supports.....	2-5
2.8	Install grinding wheel.....	2-7
2.9	Power cord.....	2-7
2.10	Calibrate the set gauge.....	2-8
SECTION 3	OPERATION	3-1
3.1	Blade introduction.....	3-1
3.2	Rejecting blades.....	3-2
3.3	Install the grinding wheel.....	3-2
3.4	Blade installation.....	3-2
3.5	Sharpening.....	3-3
3.6	Blade Sharpening Tips.....	3-8
3.7	Deburr the blade after sharpening.....	3-8
3.8	Setting the blade.....	3-9
3.9	Checking the set.....	3-10
3.10	Quick check of the set.....	3-11

Table of Contents

Section-Page

SECTION 4	MAINTENANCE	4-1
4.1	Maintaining your Sharpener & Setter.....	4-1
4.2	Grinding wheel replacement.....	4-1
4.3	Grinding Oil.....	4-2
4.4	Periodic maintenance.....	4-2
4.5	Adjusting the grinding angle	4-3
SECTION 5	REPLACEMENT PARTS	5-1
5.1	How To Use The Parts List	5-1
5.2	Sample Assembly	5-1
5.3	Base Assembly	5-2
5.4	Sharp/Set Block Assemblies	5-5
5.5	Motor Mount Assembly	5-7
5.6	Electric Box w/Pump.....	5-9
5.7	Electric Box w/Pump (USA).....	5-10
5.8	Lube System	5-11
	INDEX	I

Getting Service

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

General Contact Information

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

Office Hours:

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

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

Wood-Mizer will accept these methods of payment:

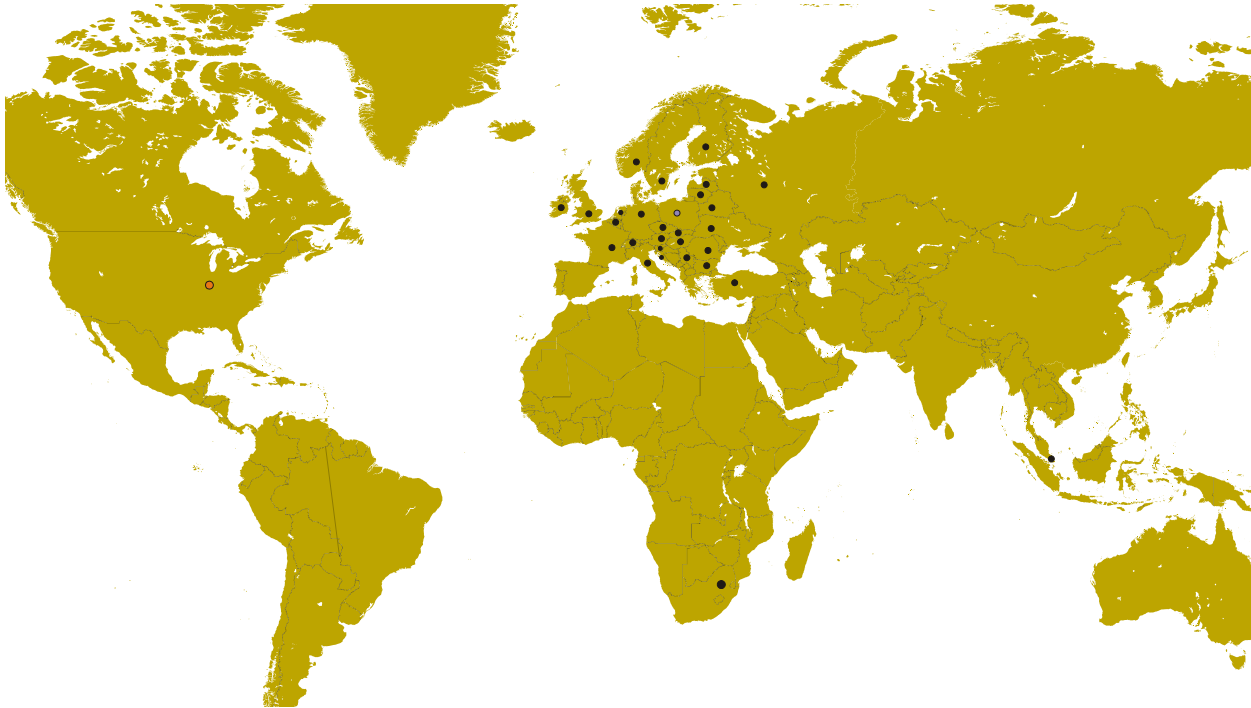
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

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

Technical data are subject to change without prior notice.

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

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



EUROPE		UNITED STATES
<p>European Headquarters Wood-Mizer Industries Sp. z o.o. Nagórna 114, 62-600 Kolo, Poland Tel.: +48-63-26-26-000 Fax: +48-63-27-22-327 www.woodmizer.eu</p>		<p>World Headquarters Wood-Mizer LLC 8180 West 10th Street Indianapolis, Indiana 46214-2400, USA Tel.: +1-317-271-1542 Fax: +1-317-273-1011 www.woodmizer.com</p>
<p>BELARUS MOST-GRUPP Siemashko 15, k.3 Minsk 2200116 Tel.: +375-17-270-90-08 Fax: +375-17-270-90-08 GSM: +375-29-649-90-80 e-mail: most-by@mail.ru</p>	<p>SWITZERLAND Stefan Wespi Maschinen u. Geräte Spezialarbeiten GmbH Eichstraße 4 6353 Weggis Tel.: +41-(0)41 - 3900312 GSM: +41-(0)79 - 9643594 info@mobilsaegen.ch</p>	<p>RUSSIA Dariusz Mikołajewski OOO WOOD-MIZER INDUSTRIES 141031, Moscow Reg., Mytishenski raj., pos. Veshki, Zavodskaja str., 3B Tel.Fax: +7(495) 788-72-35 Tel.Fax: +7(495) 641-51-60 e-mail: dariuszm@woodmizer-moscow.ru</p>
<p>BULGARIA Kalin Simeonov Ecotechproduct 38 Star Lozenski pat str. Sofia 1186 Tel.: +359-2-462-7035 Tel.: +359-2-963-1656 Tel./Fax : +359-2-979-1710 Kalin Simeonov GSM: +3592-963-2559 e-mail: office@ecotechproduct.com</p>	<p>HUNGARY Wiktor Turoczy Wood-Mizer Hungary K.F.T. Szonyi Ut 67., 2921 Komárom Tel./Fax: +36-34-346-255 e-mail: woodmizer@woodmizer.hu</p>	<p>RUSSIA Far East Wladimir Glazaczew "WM Service" Krasnorechenskaya Str.111 680006 Khabarovsk Tel./Fax: +7-914-541-1183 e-mail: wms-khv@mail.ru</p>

<p>CROATIA Krešimir Pregernik Pregimex d.o.o. S. Batušićeva 31, 10090 Zagreb Tel./Fax: +3851-38-94-668 Krešimir Pregernik GSM: +3851-98-207-106 e-mail: Kresimir.Pregernik@gmail.com</p>	<p>ITALY Pasquale Felice Wood-Mizer Italia Srl Cda. Capoiaccio SN 86012 Cercemaggiore Campobasso Tel./Fax: +39-0874-798-357 GSM: +39-333-281-03-79 e-mail: wmitaliasrl@gmail.com</p>	<p>SERBIA Dragan Markov Wood-Mizer Balkan d.o.o. Svetosavska GA 3/3; P. Fah 25 23 300 Kikinda Tel./Fax: +381-230-25-754 Tel./Fax: +381-230-23-567 GSM: +381-63-568-658 e-mail: office@woodmizer.co.yu</p>
<p>CZECH REPUBLIC Miroslaw Greill Wood-Mizer CZ s.r.o. Osvaldova 91 339 01 Klatovy-Luby Tel./Fax: +420-376-312-220 Fax: +420-376-319-011 Miroslaw Greill GSM: +420-723-580-799 e-mail: greill@woodmizer.cz</p>		<p>SLOVAKIA Wiktor Turoczy Wood-Mizer Danubia s.r.o. Hadovce 5, 94501 Komárno Tel.: +421-35-77-40-316 Fax: +421-35-7740-326 GSM: +421-905-930-972 e-mail: woodmizer@woodmizer.sk</p>
<p>CZECH REPUBLIC Lubomir Kudlik Wood-Mizer Moravia Sovadinova 6 69002 Breclav Tel./Fax: +420-519-322-443 Lubomir Kudlik GSM: +420-602-734-792 e-mail: info@wood-mizer.net</p>	<p>LATVIA Vilmars Jansons OBERTS Ltd Gaujas str. 32/2 LV-2167 Marupe, Rigas Raj. Tel.: +371-7-810-666 Fax: +371-7-810-655 Vilmars Jansons GSM: +371-92-06-966 Andris Orols GSM: +371-28-33-07-90 e-mail: andris@oberts.lv</p>	<p>TURKEY Er-Ka Ahsap Profil Kerestecilik San. ve Tic. Ltd. Sti. Adana Keresteciler Sitesi 191 sk No.41 ADANA Tel.: +90-322-346-15-86 Fax: +90-322-345-17-07 GSM: +90-533-363-18-44 e-mail: info@erkaahsap.com.tr</p>
<p>FINLAND Howard Blackbourn Oy Falkberg Jordbruk Ab Falkintie 220 25610 Ylonkyla Tel.: +358-2732-2253 Fax: +358-2732-2263 Howard Blackbourn GSM: +358-440-424-339 e-mail: falkberg@woodmizer.fi</p>	<p>LITHUANIA Andrius Zuzevicius UAB Singlis Savanoriu pr. 187, 2053 Vilnius Tel.: +370-5-2-32-22-44 Fax: +370-5-2-64-84-15 GSM: +370-620-28-645 e-mail: andrius.z@singlis.lt</p> <p>Dmitrij Gaiduk GSM: +370-69-84-51-91 e-mail: dmitrijus.g@singlis.lt</p>	<p>UKRAINE Ivan Vinnicki MOST UKRAINA bul. Myru 3, Bajkivtsi Ternoplskyj r-j Ternopolska oblast 47711 Ukraine Tel/Fax: +38 (0352) 52 37 74 GSM: +38 (067) 352 54 34 GSM: +38 (067) 674 50 68 E-mail: most-ukraina@ukr.net</p>
<p>FRANCE Tizoc Chavez Wood-Mizer France 556 chemin des Embouffus, ZAC des Basses Echarrieres 38440 SAINT JEAN DE BOURNAY Tel: +33-4 74 84 84 44 GSM: +33-607 52 02 82 Mail: tchavez@woodmizer.fr</p>	<p>NORWAY Odd Edvoll Wood-Mizer Nordic AS Vardelia 17, 2020 Skedsmokorset Tel.: +47-63-87-49-89 Fax: +47-63-87-37-66 GSM: +47-930-42-335 e-mail: odd.edvoll@woodmizer.no</p> <p>e-mail: firmapost@woodmizer.no</p>	<p>UNITED KINGDOM & IRELAND Wood-Mizer UK Hopfield Barn Kenward Road, Yalding Kent ME18 6JP, UK Tel.: +44-1622-813-201 Fax: +44-1622-815-534 e-mail: info@woodmizer.co.uk</p>
<p>SLOVENIA Jan Fale FAMTEH d.o.o. Gacnikova pot 2, 2390 Ravne na Koroskem Tel.: +386-2-62-04-232 Fax: +386-2-62-04-231 Jan Fale GSM: +386-2-62-04-230 e-mail: jan.fale@famteh.si</p> <p>Matjaz Kolar Tel.: +386-2-62-04-232 GSM: +386-31-775-999 e-mail: matjaz.kolar@famteh.si</p>		

<p>GERMANY Klaus Longmuss Wood-Mizer Sägewerke GmbH Dorfstraße 5, 29485 Schletau Tel.: +49-5883-9880-10 Fax: +49-5883-9880-20 e-mail: info@woodmizer.de</p> <p>Klaus Longmuss Tel.: +49-5883-9880-12 GSM: +49-17-298-55-892 e-mail: KLongmuss@woodmizer.de</p>	<p>Subagent: SWEDEN Kjell Larsson Mekwood AB Slingan 14, 812 41 Gästrike-Hammarby Tel.: +46-290-515-65 Kjell Larsson GSM: +46-706-797-965 e-mail: kjell.larsson@mekwood.se</p>	<p>IRELAND Wood-Mizer Ireland Stephen Brennan Cum Lahardane Ballina County Mayo Tel: +353 96 51345</p> <p>E-mail: brennanmill@ericom.net</p>
<p>Subagents: DENMARK Brian Jensen Amborgvej 9, 7330 Brande- Fasterholt Tel.: +45-971-88-265 Fax: +45-971-88-266</p> <p>Brian Jensen GSM: +45-23-49-5828 e-mail: Fasterholt-Savvaerk@Mail.Tele.dk</p>	<p>ROMANIA Adrian Echert SC WOOD-MIZER RO SRL TRANSILVANIEI Nr. 5 Sibiu, Cisnadia 555300 Tel./Fax: : +40-369-405-433 GSM: +40-745-707-323 e-mail: aechert@woodmizer.ro</p>	<p>Regional Manager - Asia Wood-Mizer Asia Pte Ltd. James Wong Tel: +65 81216910 Fax: +65 6283 8636 WWW: www.woodmizerasia.com E-mail: jwong@woodmizerasia.com</p>
<p>Netherlands Chris Dragt Lange Brink 77d, 7317 BD Apeldoorn Tel.: +31-55312-1833 Fax: +31-55312-2042 e-mail: Info@dragtbosbouw.nl</p>	<p>Subagent: ROMANIA M. Echert S.C. Echert Comprod s.r.l Str. Schitului Nr. 6, Apt.7 etajul-1 725 70 Vatra Dornei, Romania Tel./Fax: +40-230-374-235 Tel. : +40-740-35-35-74</p>	<p>Regional Manager - Africa Wood-Mizer Africa Jean-Jacques Oelofse UNIT 3, LEADER PARK, NO: 20 CHARIOT ROAD STORMILL, EXT 5, Roodepoort, Johannesburg Tel: +27 011 473 1313 Fax: +27 011 473 2005 Jean-Jacques Oelofse E-mail: jjoelofse@woodmizerafrika.com Jean-Jacques Oelofse Skype: jean.jacques.pierre.oelofse</p>

USA World Headquarters

Serving North & South America, Oceania, East Asia

Wood-Mizer LLC
 8180 West 10th Street
 Indianapolis, IN 46214

Phone: 317.271.1542 or 800.553.0182
 Customer Service: 800.525.8100
 Fax: 317.273.1011
 Email: infocenter@woodmizer.com

Canadian Headquarters

Serving Canada

Wood-Mizer Canada
 396 County Road 36, Unit B
 Lindsay, ON K9V 4R3

Phone: 705.878.5255 or 877.357.3373
 Fax: 705.878.5355
 Email: ContactCanada@woodmizer.com

Brazil Headquarters

Serving Brazil

Wood-Mizer do Brasil
 Rua Dom Pedro 1, No: 205 Bairro: Sao Jose
 Ivoti/RS CEP:93.900-000

Tel: +55 51 9894-6461/ +55 21 8030-3338/ +55 51
 3563-4784
 Email: info@woodmizer.com.br

Europe Headquarters

Serving Europe, Africa, West Asia

Wood-Mizer Industries Sp z o.o.
 Nagorna 114
 62-600 Kolo, Poland

Phone: +48.63.26.26.000
 Fax: +48.63.27.22.327

Branches & Authorized Sales Centers

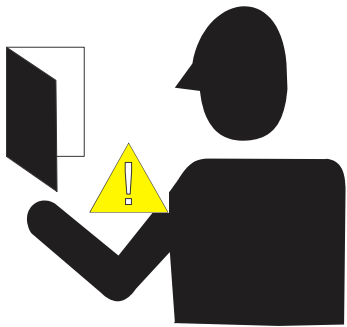
For a complete list of dealers, visit www.woodmizer.com

SECTION 1 INTRODUCTION

1.1 About this manual

Congratulations on your purchase of a Wood-Mizer Sharpener & Setter! When properly maintained and operated, your Sharpener & Setter should give you many years of dependable service.

This manual does not cover every possible operation and safety issues that may occur while using this equipment. This manual covers some of the basic safety procedures relating to sawblade maintenance but common sense should take precedence over this manual. Operators should follow safety procedures at all times.



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.

CAUTION! Read this entire 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.

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

1.2 Safety

The triangle symbol calls your attention to instructions concerning your personal safety.

Read and follow these instructions!



DANGER INDICATES AN IMMINENTLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, WILL RESULT IN SERIOUS INJURY OR DEATH.



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



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

NOTE: Informs people of important installation, operation, or maintenance information that is not hazard related.

Read and observe all safety instructions before operating this equipment!

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.

Blade handling safety



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 safety



DANGER MAKE SURE ALL GUARDS AND COVERS ARE IN PLACE AND SECURED BEFORE OPERATING THIS MACHINE. 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.

1 Introduction

Safety



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.

WARNING! This machine 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 may not cause stroboscopic effect.

Decal meaning

TABLE 1-0

Decals View	Description
	<p>096317 Carefully read the operator's manual before operating the machine. Observe all safety instructions and rules when operating.</p>
	<p>096316 Opening of the electric box is possible only when the switch is in the "0" position.</p>

TABLE 1-0

	<p>096321 Blade movement direction</p>
	<p>S12004G Always wear eye protection equipment when operating this machine.</p>
	<p>S12005G Always wear ear protection equipment when operating this machine.</p>
	<p>512107 Always wear safety gloves when operating this machine.</p>

1.3 Machine Start



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

- Fasten the sharpener to a table top using the mounting holes located in the foot plates.
- The sharpener can be operated in well ventilated room only.
- The machine can be operated under roof only.
- The sharpener can be operated only in temperature range from 5° C to 40° C (41 - 104° F), at the humidity of up to 80%.
- The oil for cooling the grinding wheel must meet the specifications shown below. Water or other liquids must not be used.
- The position of the sharpener's operator is shown below.
- The illumination at the operator's position should be at least 300lx¹.

See **Table 1-1**. The table below lists the coolant specifications.

Oil Type	Manufacturer	Freezing Point	Flash Point	Autoignition Point
ACP-1E ¹	Orlen	-20 ° C -4 F	Above 140 ° C 284 F	250 ° C 482F

TABLE 1-1

¹ Waste oil must be disposed of in compliance with applicable state and local regulations.

1. The light source can not cause stroboscopic effect.

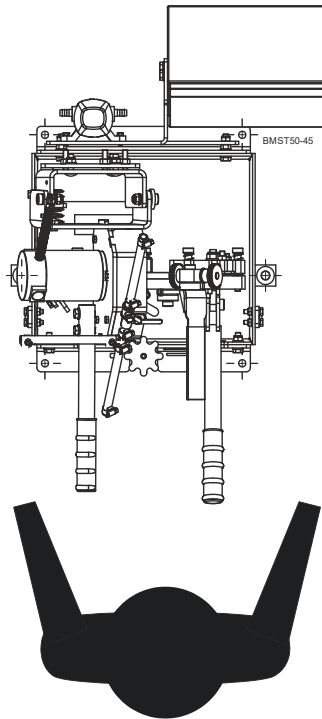


FIG. 1-1 OPERATOR'S POSITION

- Have a qualified electrician make the power supply. The power supply must meet the specifications given below.

Voltage	Fuse [A]	Suggested Wire Size
230 VAC	2A	1.5 mm ² at least 16AWG at least

TABLE 1-1

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

1

Introduction

Major Components

1.4 Major Components

This Sharpener & Setter should only be used with a 1" to 1-1/2" blades with a 7/8" tooth spacing. The figure below shows the major components of the Sharpener & Setter. These terms will be used throughout this manual to refer to these major components. [See Fig. 1-2](#)

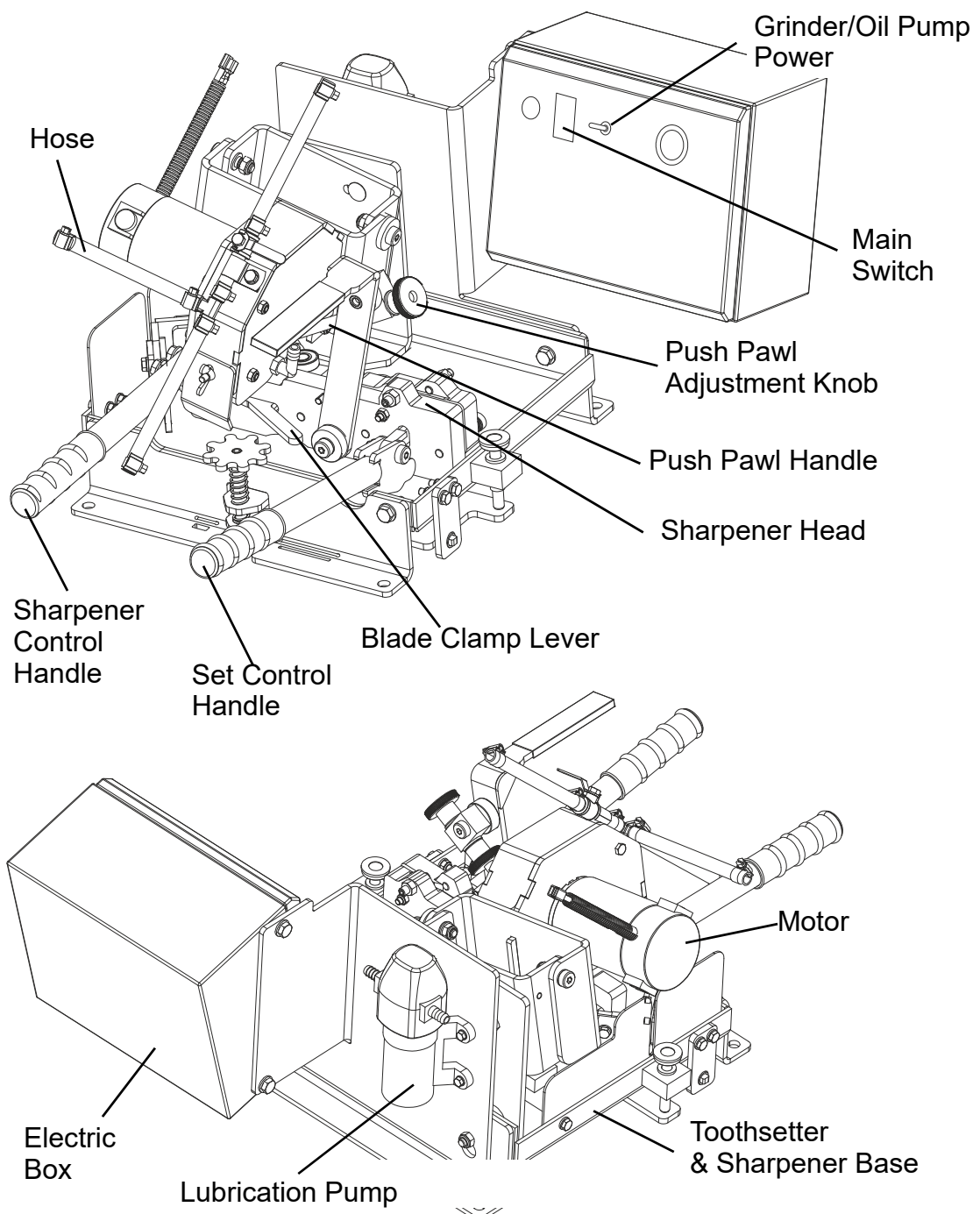


FIG. 1-2

1

Introduction

Major Components

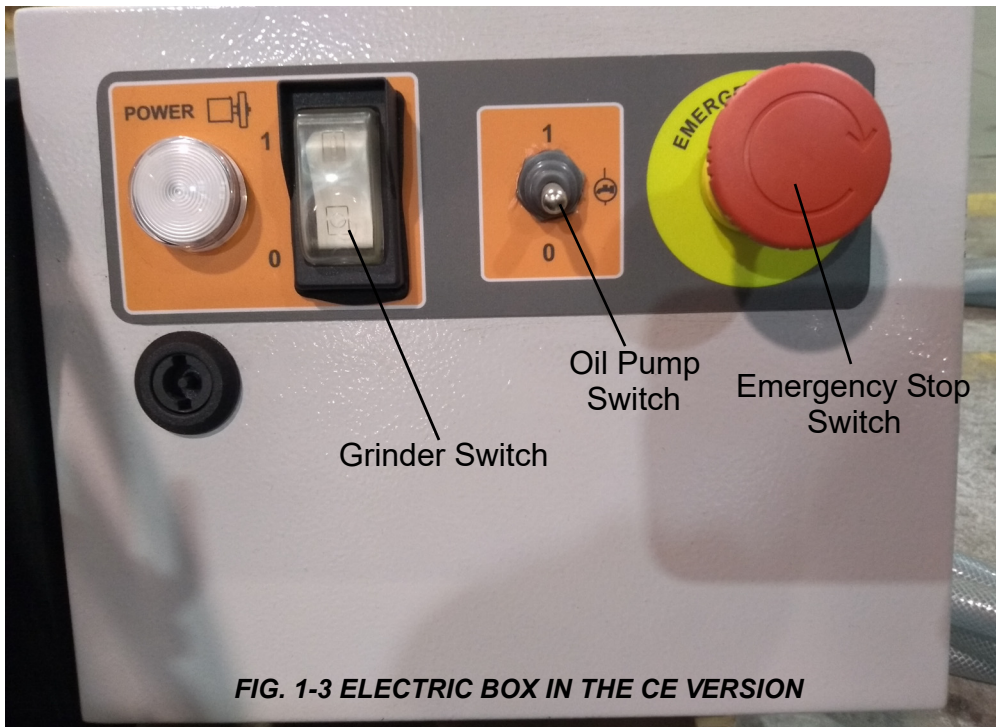


FIG. 1-3 ELECTRIC BOX IN THE CE VERSION

1.5 Dimensions and Specifications

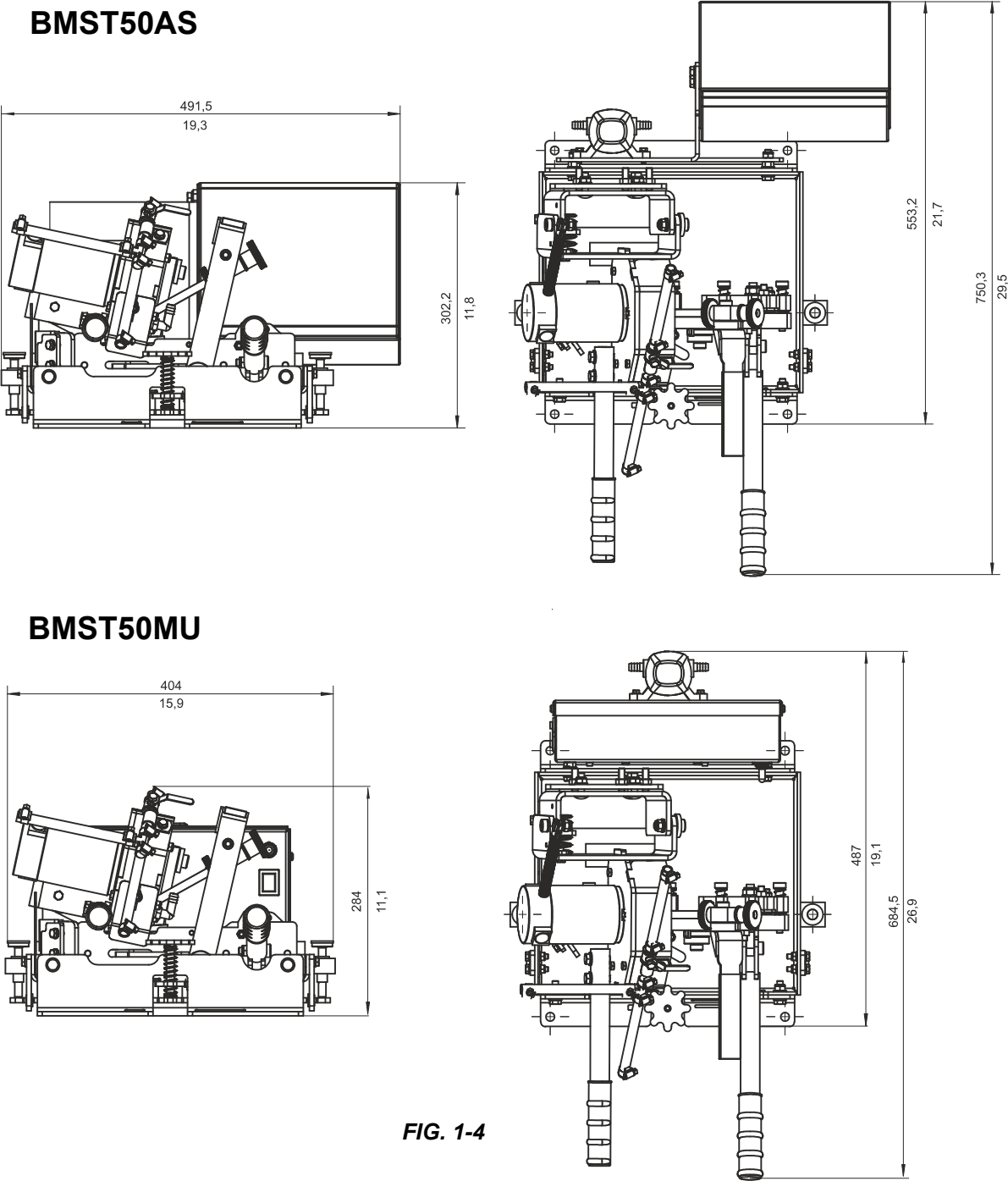


FIG. 1-4

1

Introduction

Dimensions and Specifications

Grinding Motor:	1/7 th HP
Grinding Wheel:	5" CBN
Blade Capacity:	1-1/4" and 1-1/2" with 7/8 Pitch
Operation:	Manual
Production Capacity:	Individual
Power:	100-240V AC, 50/60 Hz
Weight:	50 kg.

SECTION 2 SET UP

2.1 Items required but NOT included

- Table
- Mounting screws
- Oil Bucket
- Sharpening Oil (Grinding oil CE-150)
- 5 inch grinding wheel

Tools:

- Drill
- Drill bits/hole saw up to 2 in (50mm)
- #2 Phillips screwdriver

You will need a sturdy table top on level surface on which to mount the Sharpener & Setter base unit and the blade supports. The table must be large enough to hold a saw blade (a 4x8 ft (1200x 2400mm) sheet works well). The illustration to the right shows approximate locations of the equipment's footprint on the 4x8 ft (1200x2400mm) table. [Fig. 2-1](#)

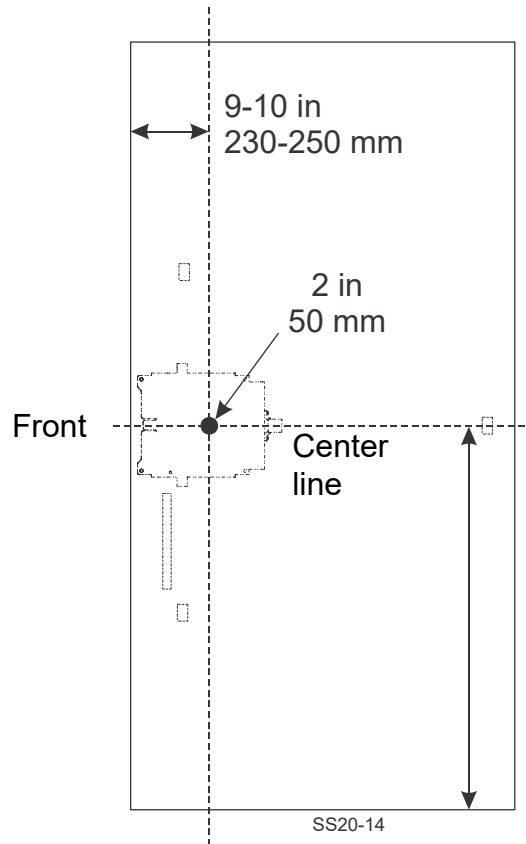


FIG. 2-1

Dimensions for drilling mounting holes are shown in [Bottom View Fig. 2-2](#).

A standard 5-gallon (or 20 l) bucket placed directly under the table can be used for oil recirculation. The drain pipe should not extend so close to the bottom of the bucket that it inhibits drainage.

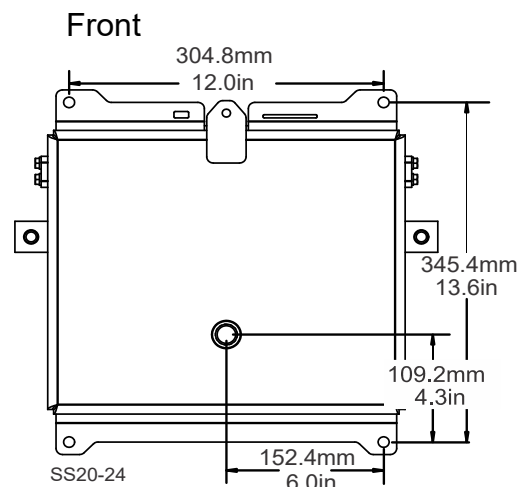


FIG. 2-2 BOTTOM VIEW

2.2 Items included

[See Fig. 2-3](#)

1. 033491 Pump Assembly with F81000-51 Screws (4 pcs):
2. F81080-1 Hose Clamp (1 pc):
3. R01885 Tubing (122 cm included to be cut to length as needed)
4. 516192 Magnet, Filter (1 pc)
5. 524766 Drain Pipe
6. 524760-1 Sharpener Tilt Gauge
7. 524761-1 Blade Guard
8. 524757 Blade Support Assemblies (4 pcs)
9. 060490 Set Gauge

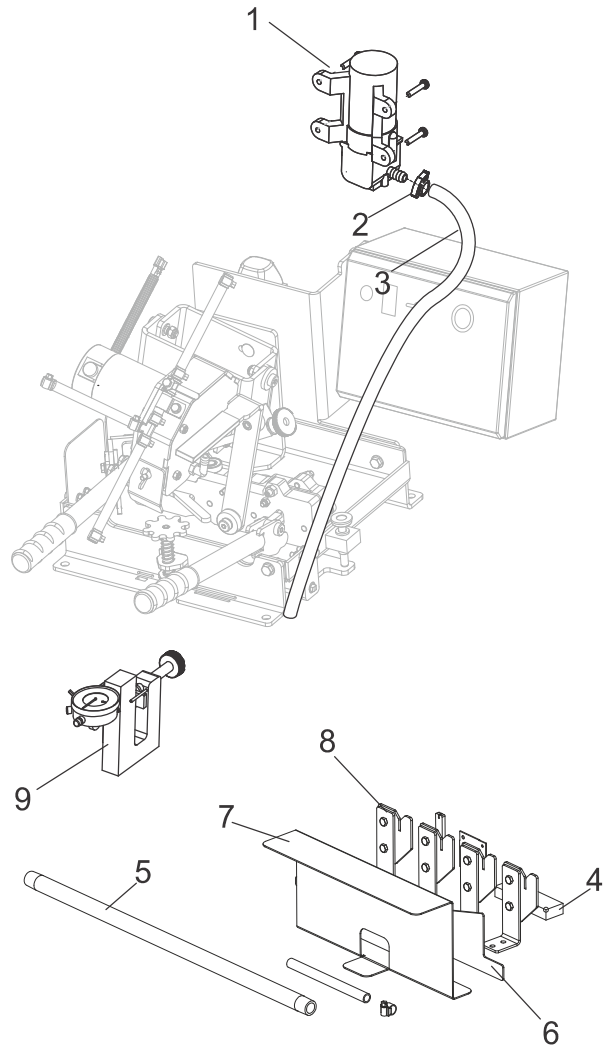


FIG. 2-3

2.3 Install the lubrication pump

Use a Phillips head screwdriver to install the pump on the rear of the electrical panel with the 4 screws provided.

Slide the hose clamps over the lube hose. Leave enough room that the hose can seat itself all the ways on the pump fittings

Push the lube hose onto the pump fittings on both sides of the pump. Secure the hoses on the fittings using the hose clamps provided. You may need pliers for this.

Ensure that the hoses are well seated and secure on the fittings. [See Fig. 2-4](#)

Route the supply hose into the oil bucket. With a cutting tool, cut the supply hose to slightly above the bottom of the bucket.

Connect the two power wires extending from the bottom center of the electrical box to the mating wires on the pump.

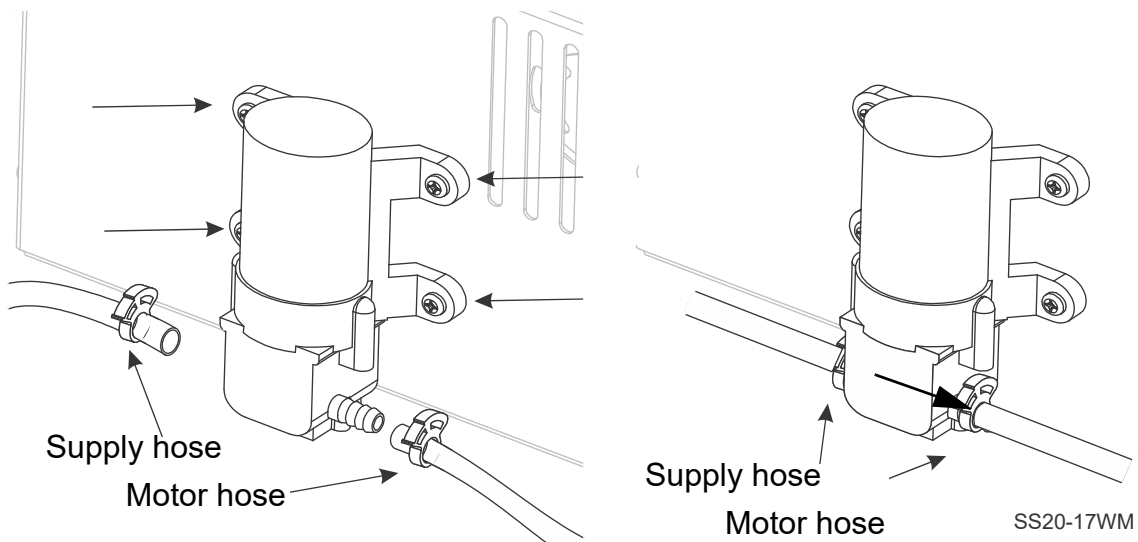


FIG. 2-4

2

Set up

Mount the base unit

2.4 Mount the base unit

The table will need a 2 inch (50 mm) hole to allow for an oil drain pipe to extend through it into a bucket placed under the machine. An optional 1 inch (25 mm) hole could be also drilled for the oil supply hose, if desired. Location of the the drain hole is not precise; it may go where the operator feels most comfortable.

Align the base unit so that the drain fitting sets into the hole in the table you have provided. When the unit is aligned with the table, bolt the base unit to the table with screws you provide. [See Fig. 2-5](#)

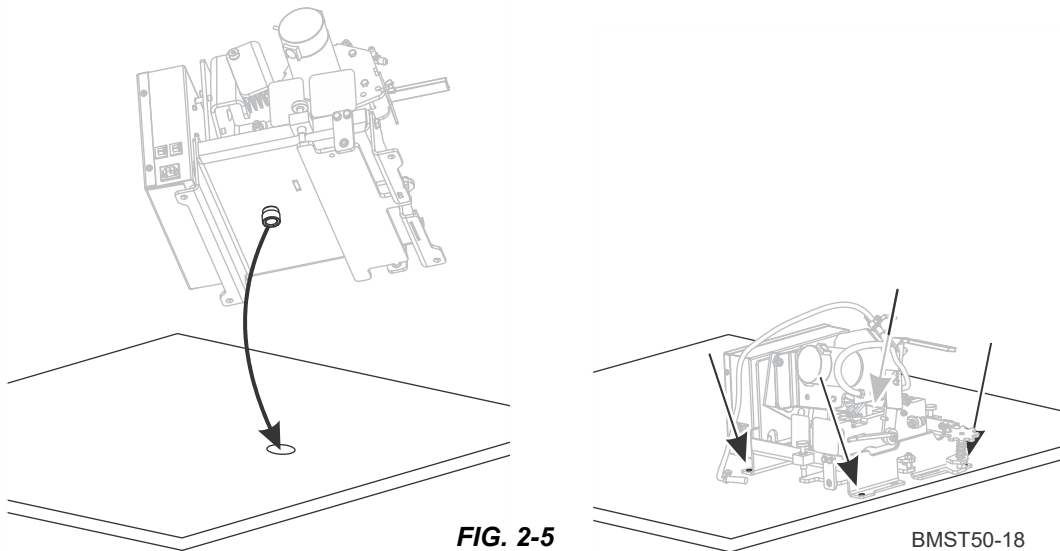


FIG. 2-5

BMST50-18

2.5 Install the drain pipe

Place the discharge end of the drain pipe into the oil bucket first. Simply screw in the threaded pipe into the drain fitting at the bottom of the pan.

Place the filter magnet into the bottom of the oil bucket near the drain output.

[See Fig. 2-6](#)

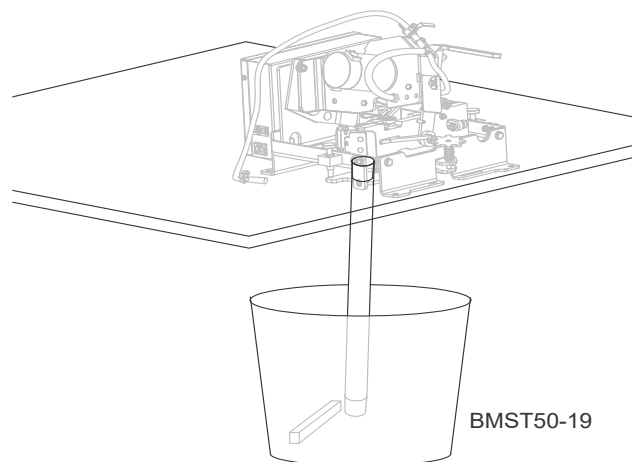


FIG. 2-6

BMST50-19

2.6 Install the operators handles

For the set handle, rotate the handle from the shipping position to the forward position.
[See Fig. 2-7](#)

For the sharpener handle, place the nuts and bolt of the handle in the position shown in [Fig. 2-7](#). Two washers and the nuts go on the inside of the sharpener housing. Tighten both nuts.

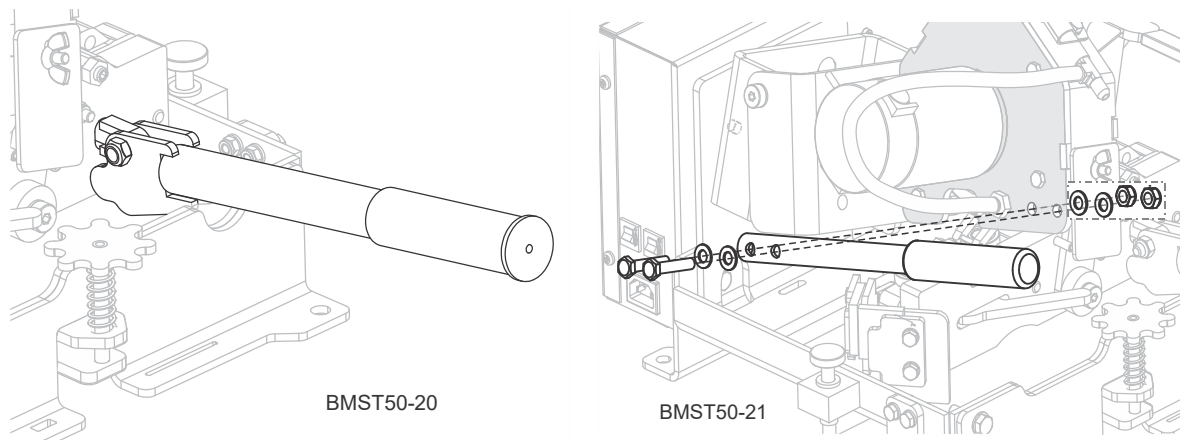
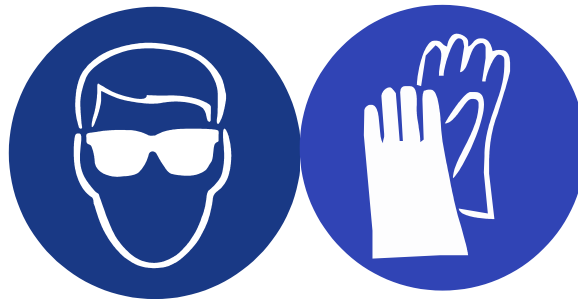


FIG. 2-7

2.7 Mount the blade supports

Place the first blade guide on the table in line with the back side of sharpener. Locate it near the outside edge of the table. Orient the groove so the blade slides through parallel to the sharpener. See step 1 in [Fig. 2-8](#). Fasten the blade guide to the table with your own screws



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.

2

Set up

Mount the blade supports

Install a blade in the sharpener and rear guide so that the blade forms an oval shape. See step 2 in [Fig. 2-8](#). Adjust the height of the rear guide so the bottom of the blade is approximately level with the blade's bottom in the sharpener.

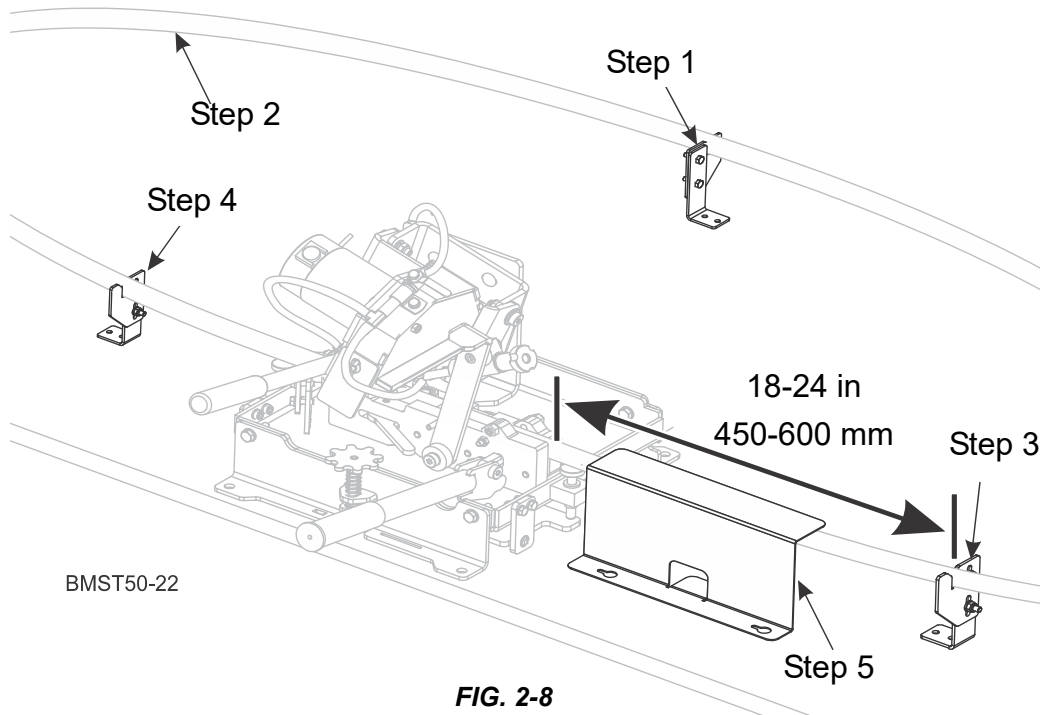


FIG. 2-8

Place a second guide to the right side of the base unit, approximately 18 – 24 inches (450 – 600mm) away **along the curvature of the blade**. Orient the groove so the blade will slide through with minimal pressure against the sides. Adjust the height of the blade guide groove so that the blade does not touch the bottom of the groove. [See Fig. 2-9 Side supports](#). Fasten the blade guide to the table with your own screws. See step 3 in [Fig. 2-8](#).

Repeat on left side. See step 4 in [Fig. 2-8](#).

Install the blade guard on the table to the right of the base unit. The blade guard helps prevent inadvertent operator contact with the blade teeth during operation. Make sure that it is far enough away from the blade that it does not touch at any point. See step 5 in [Fig. 2-8](#). Fasten the blade guide to the table with your own screws.

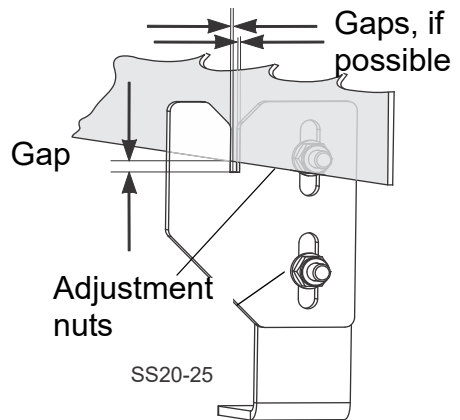
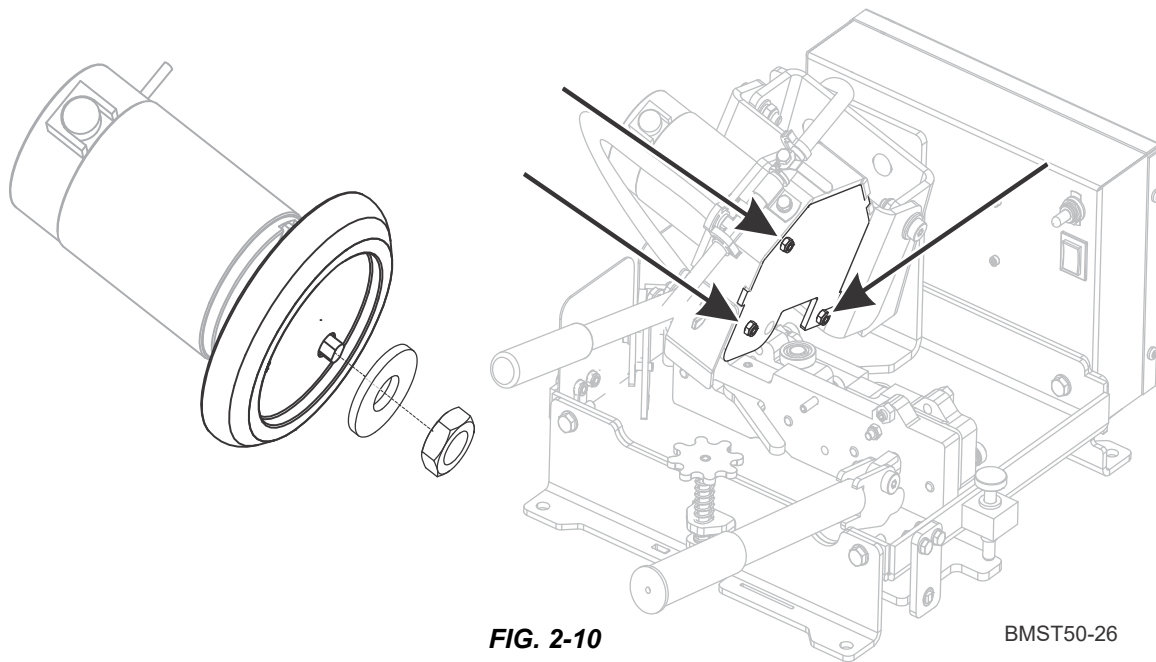


FIG. 2-9 SIDE SUPPORTS

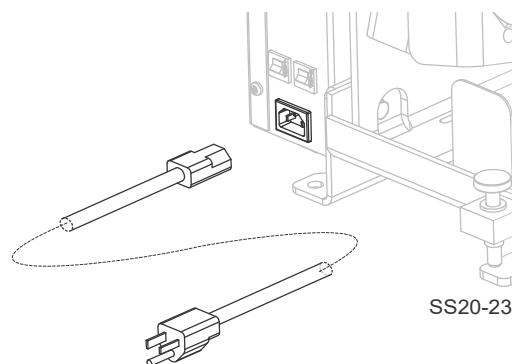
2.8 Install grinding wheel

Loosen the three nuts on the grinder motor housing and remove the housing plate. Loosen the nut on the grinder motor shaft and remove the washer. Place the wheel on the shaft under the washer, then tighten the motor shaft nut. Reinstall the housing plate. [See Fig. 2-10.](#)



2.9 Power cord

Insert the power cord into the power receptacle on the lower left side of the electrical panel. The cord is keyed so that it will fit in only one orientation. Plug the other end into a standard grounded outlet. [See Fig. 2-11](#)



2.10 Calibrate the set gauge

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

Refer to [Fig. 2-12](#). 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. (See SIDE VIEW.) 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 0.00 . Tighten the dial lock.

Unclamp the calibrating pin from the set gauge clamp by turning the clamp knob counter-clockwise. With the pin not clamped, the set gauge needle should read between $-.005$ and $-.010$. If not, reclamp the pin, loosen the locking screw and move the set 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 small amount and will read zero when the foot is aligned with the clamp plate.

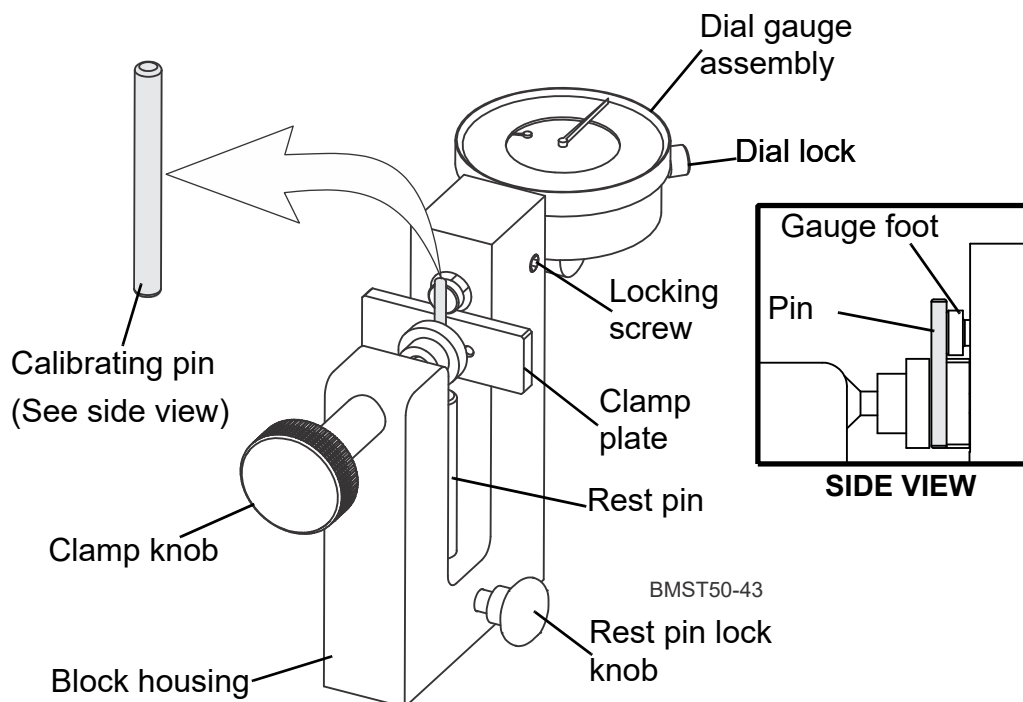
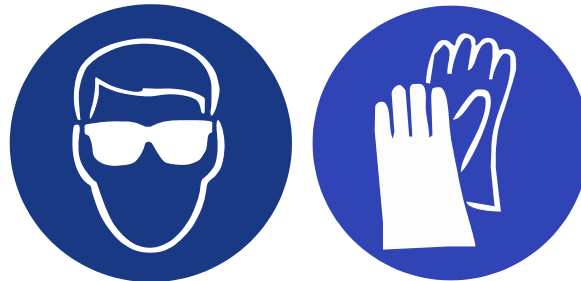


FIG. 2-12

SECTION 3 OPERATION



3.1 Blade introduction



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.

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. [See fig. 3-1](#)

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. [See fig. 3-1](#)

The Wood-Mizer Sharpener & Setter allows you to sharpen, then evenly set the teeth of a bandsaw blade. The clamping mechanism lets you position a tooth in front of the grinding wheel and sharpen it to the correct profile. You can then measure the set. The tooth is bent by clamping the blade in the setter clamp. This chapter describes proper operation of the Wood-Mizer Sharpener & Setter.

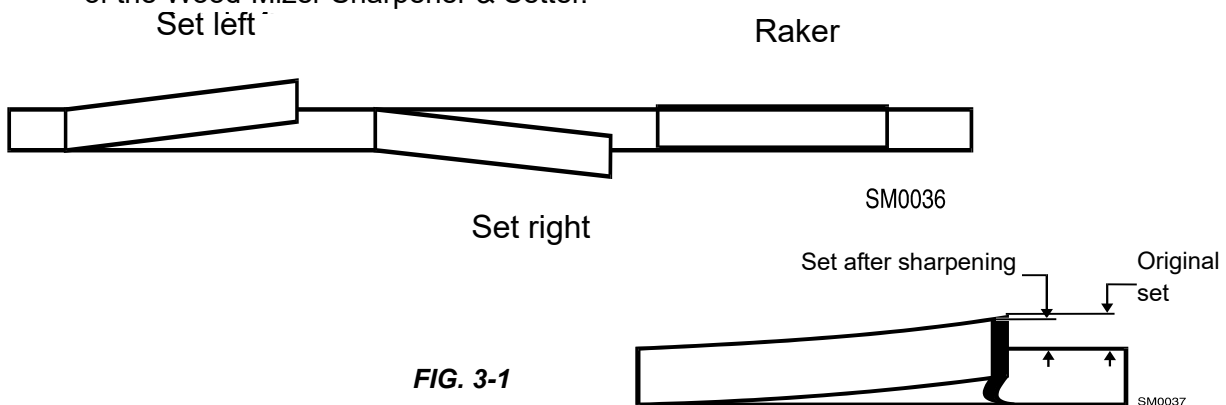


FIG. 3-1

3.2 Rejecting blades

Sometimes blades cannot be resharpened. Reasons to reject blades for resharpening include:

- the blade is coil set (the blade is over-stressed and will fold on itself),
- the blade is missing 2 or 3 teeth or more in a row,
- the blade band has been twisted,
- the blade band is too low for the grinder (the blade has been sharpened too many times/too much material has already been ground from the blade),
- the blade has no set on one of its sides
- severe rust is present,
- or the blade has tooth spacing uncommon to Wood-Mizer blades (i.e., a competitor's blade).

3.3 Install the grinding wheel

For grinding wheel set up, [See Section 2.8](#).

3.4 Blade installation



CAUTION! Before you resharpen the blade, check it for cracks. Most cracks occur across the band of the blade at the lowest point of the gullet. If you find any cracks, **do not resharpen the blade.**

To reduce the risk of premature blade fatigue from hairline cracks, it is important to thoroughly clean the gullet of cracks during resharpening. It may be necessary to lightly grind the blade twice to thoroughly clear the gullet cracks.

1. Clean the blade **before** putting it in the Sharpener & Setter. Clean the blade **on the mill** by opening the water lube over the moving blade for at least 15 seconds. Sap buildup on the blade or tooth may not allow full sharpening.



WARNING! Use ONLY water or windshield washer fluid with the water lube accessory. **Never use flammable fuels or liquids** such as diesel fuel. If the flammable solvents are necessary to clean the blade, remove it from the mill and clean with a rag. Failure to do so can damage the equipment and may result in serious injury or death.

2. Mount the blade in the Sharpener & Setter. Open the blade clamp and place blade between the clamping plates with the blade's bottom edge on the blade support posts. Adjust the height of the rear guide so the bottom of the blade is approximately level with the blade's bottom edge in the sharpener. [See fig. 3-4](#).

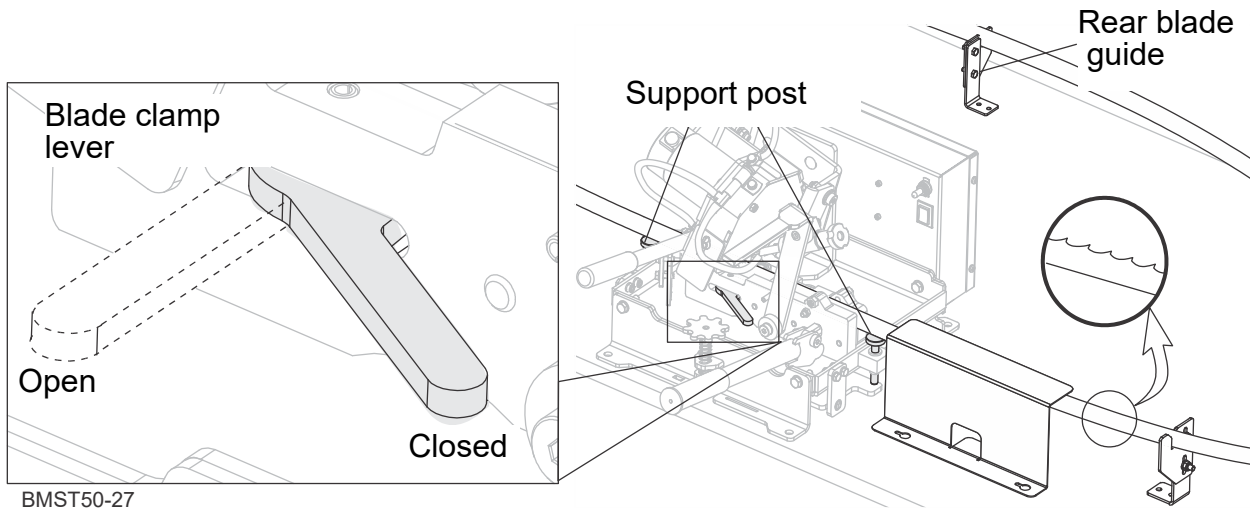


FIG. 3-2

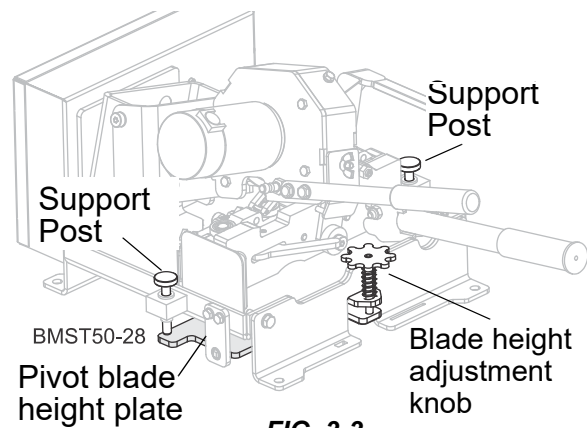
With (2) 10mm wrenches, adjust the height of the two side blade guides so that the blade does not touch the bottom of the groove in the guide, leaving a gap of about 3/8 inch (10mm) below the bottom of the blade. Only the rear guide should have the blade touching the bottom edge. [See fig. 2-9 Side supports](#)



CAUTION: The blade guide must not interfere with the blade height adjustment in the sharpener. Incorrect sharpening will result.

3.5 Sharpening

NOTE: Always sharpen the blade before adjusting the set. As the blade is sharpened, the tip of the tooth recedes and the set becomes smaller. [See fig. 3-1](#).



3

Operation Sharpening

1. **Open the blade clamp and adjust the blade in the left-right orientation.** Raise or lower the blade so the bottom of the gullet is level with the clamp or slightly above. Lower the grinding wheel to align the blade in the gullet of the blade tooth. [See fig. 3-4 and 3-5.](#) Close the blade clamp lever to hold the blade accurately in place.

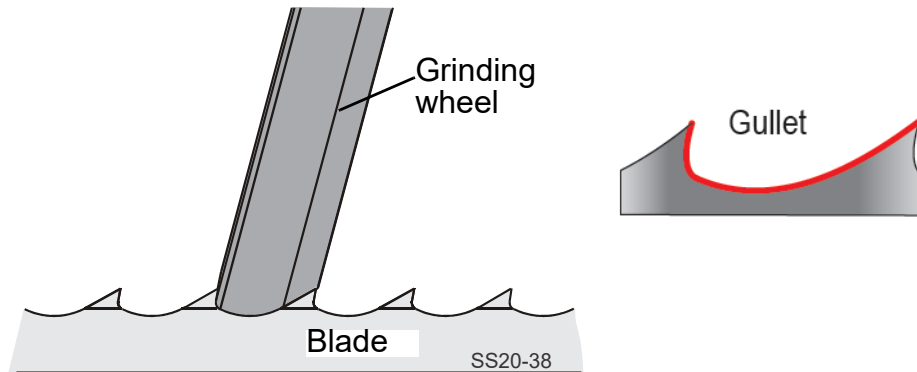


FIG. 3-4

2. **Adjust the blade height for sharpening.** The blade should rest equally on the blade height posts. Use the blade height adjustment knob to raise or lower the posts. The posts can be adjusted in unison by the knob. Fully lower the sharpener head to align the blade with the grinding wheel.
3. **Recheck the blade in the left-right orientation.** Lower the grinding wheel to align the blade in the gullet of the blade tooth. [See fig. 3-4.](#) Close the blade clamp lever to hold the blade accurately in place. [See fig. 3-2.](#)

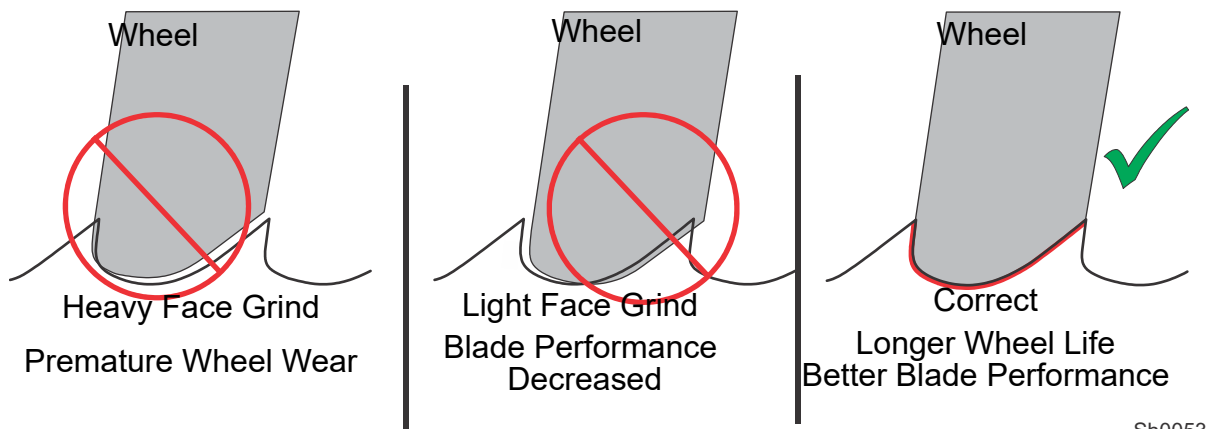
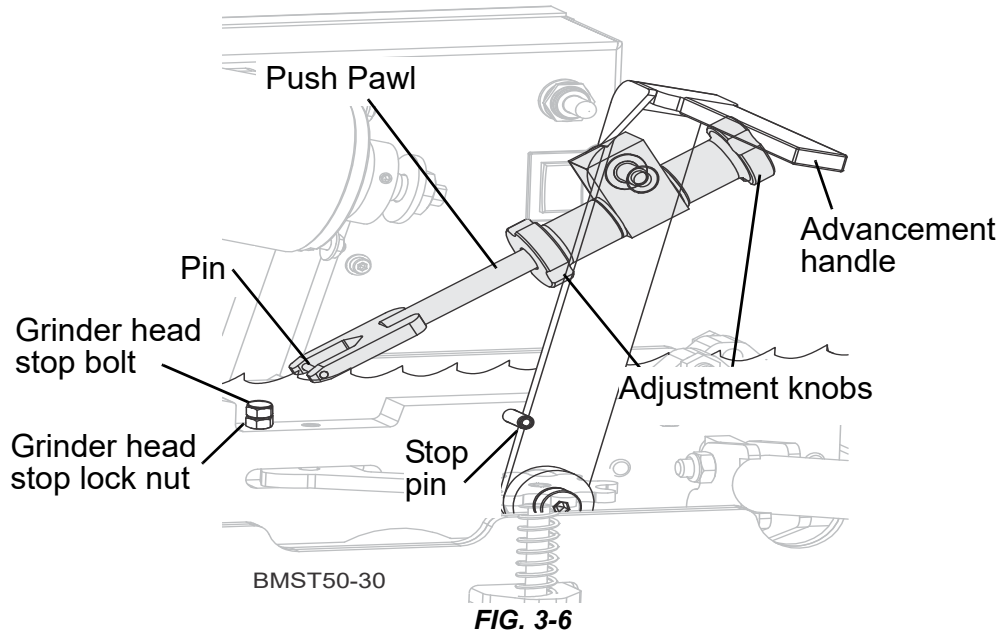


FIG. 3-5

Sh0053

4. **Set the advancement.** With the blade clamped in the sharpening position, loosen the push pawl adjustment knobs. [See fig. 3-6](#).



- Place the push pawl pin into the gullet of the tooth just before the tooth to be ground with the advancement handle against the stop pin. [See fig. 3-6](#). The advancement handle and pin should rest solidly, but not pushing the tooth. Make sure that the fork holding the pin remains perpendicular to the blade. [See fig. 3-7](#).

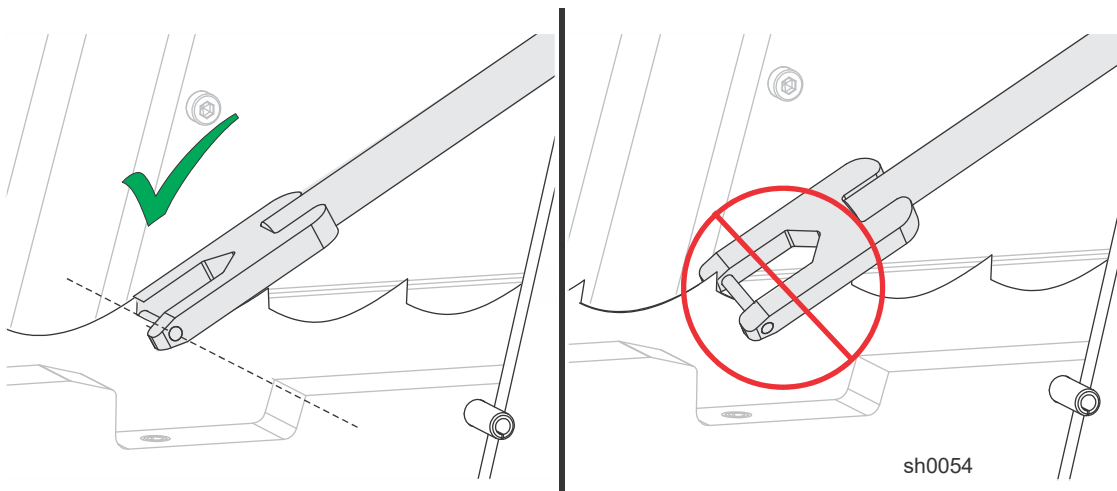


FIG. 3-7

3

Operation

Sharpening

- Tighten the adjustment knobs to hold the push pawl pin in this position. Advance one tooth by moving the push pawl handle left and right. [See fig. 3-8](#) . Recheck the position with the grinding wheel. [See fig. 3-4](#) .

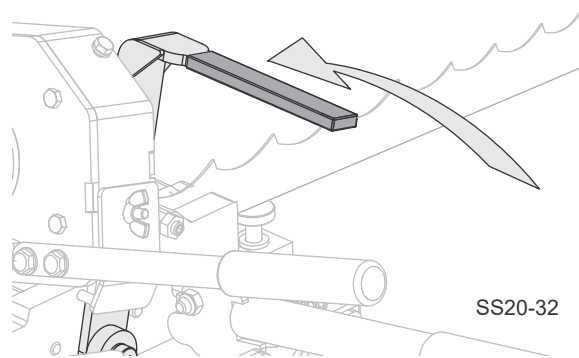
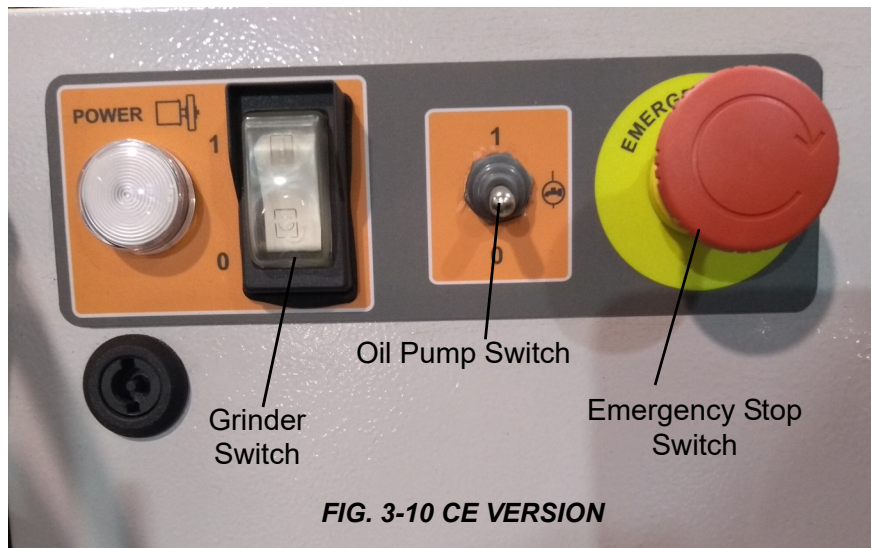
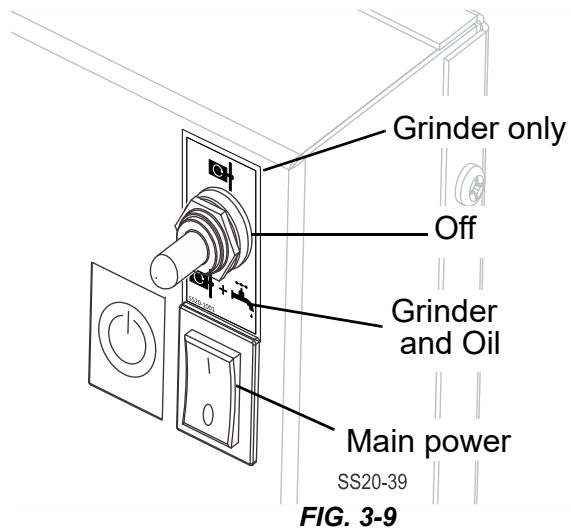


FIG. 3-8

Recheck alignment. Grind at least three teeth without oil to sample the positions for left set, right set and raker teeth. Excessive burning on the tip is a sure sign that the wheel is starting the grind at the tip of the tooth, as opposed to the full "plunge" profile grind. Recheck the alignment, and make any new adjustments. Repeat the adjustments until no more adjustment is necessary.



When the position and advancement are correct, turn on the oil lubrication and grind each tooth. [See fig. 3-9](#) .

3.6 Blade Sharpening Tips

Before removing a blade from the saw-mill, clean the blade by running the waterlube on the blade for 15 seconds. This will remove most of the sap buildup that would otherwise have to be scraped off when it dries. Wipe with a clean dry rag.

Make sure the flow of oil through the assembly is strong.

Sharpen the blade when it first shows signs of dullness. If the blade is extremely dull, due to hitting a rock or some form of foreign matter, sharpen the blade twice lightly, instead of trying to remove too much in one grind. Grinding too much material at once may cause the

circuit breaker in the control box to trip. If this happens, wait 15 seconds. Then turn it on (push circuit breaker down). [See fig. 3-11](#).

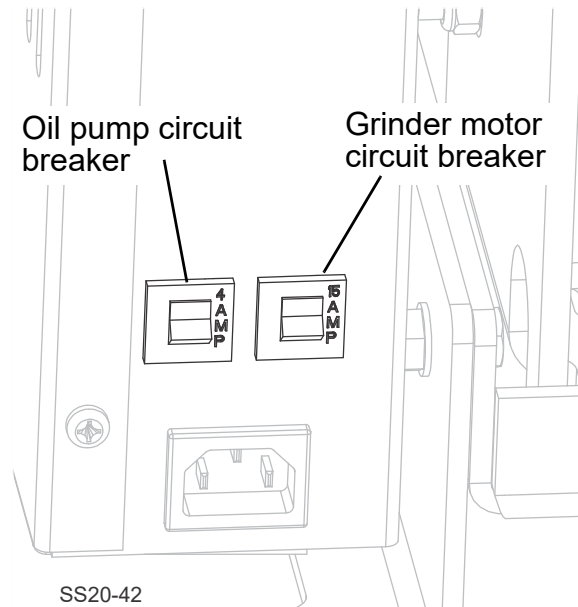


FIG. 3-11

3.7 Deburr the blade after sharpening

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 toothset gauge to give false readings.

To remove burrs, drag a stick of hardwood across the blade *in the opposite direction* that the teeth cut. Repeat on the other face of the blade. (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, but clean the blade before removing from the mill by running the water lube for 15 seconds. Remove the blade and wipe dry with a rag to prevent rusting.

3.8 Setting the blade

Tools needed:

- 4mm hex wrench
- 13mm open end wrench

Adjust the blade in the Sharpener & Setter in the same manner as you would do for sharpening ([See 3.5 Sharpening](#)), aligning the blade on the set screws. [See fig. 3-12](#).

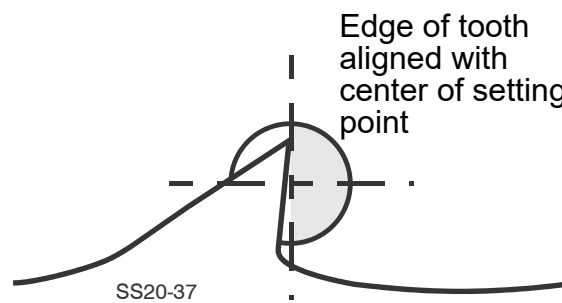


FIG. 3-12

Advance the blade until there is a left set tooth aligned with the left set screw as shown in [See fig. 3-12](#) and [See fig. 3-13](#). A right set tooth should also align on the right set screw.

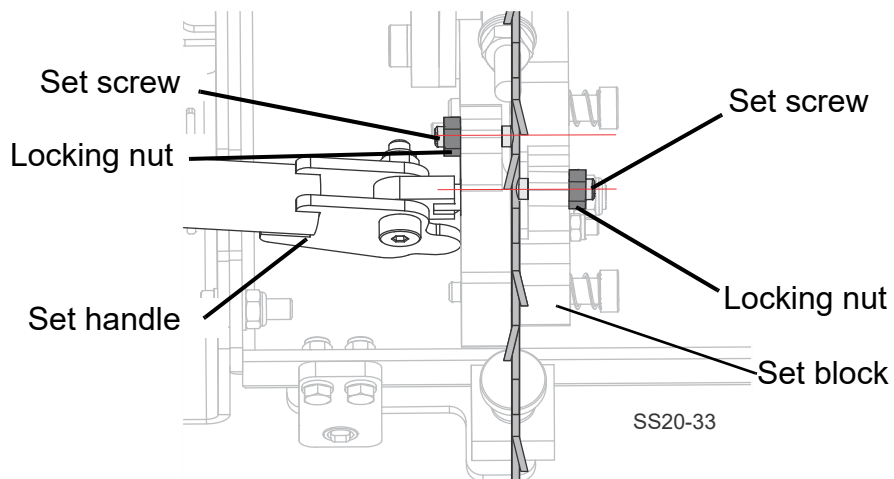


FIG. 3-13

Adjust the desired depth of the set on both left and right with a 4mm hex wrench. When the depth is set, tighten the locking nut with a 13mm open end wrench.

When left and right tooth settings are at the desired set, lower the set handle until the set block is tight against the blade. Advance the blade **three** teeth and repeat until the entire

blade is set.

3.9 Checking the set

1. Use a marker to mark two adjacent teeth to be checked; set the marked teeth.
2. Unclamp the blade and move it to a position where you can check the tooth set.
3. Place the set gauge around the blade to measure tooth set. Adjust the blade height position in the gauge by turning the lock knob counterclockwise to loosen and adjust the rest pin up or down. Adjust it such that when the blade rests on the rest pin, **the gullet of the blade is flush to the clamp plate**. Retighten the lock knob.

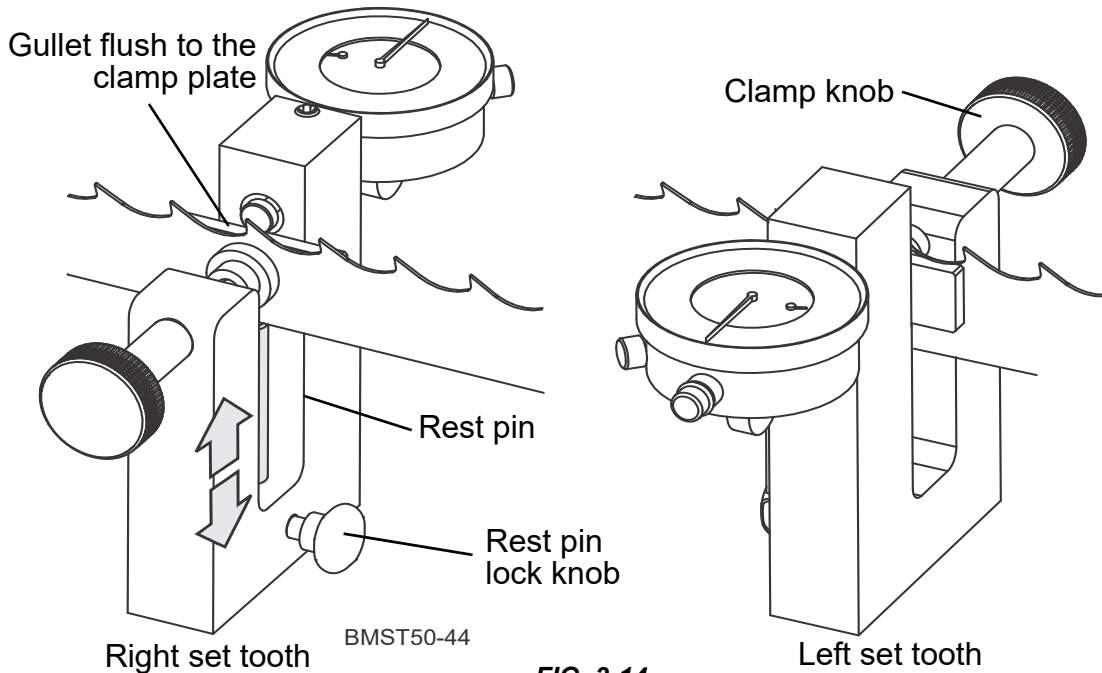


FIG. 3-14

4. Slide the set gauge assembly over 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 gauge. **Note the tooth set measurement.** Loosen the clamp knob and remove the set gauge assembly from the blade.
5. Rotate the set gauge 180 degrees to measure tooth set in the opposite direction. Note the tooth set measurement.
6. Loosen the clamp knob and remove the set gauge assembly from the blade.

7. Readjust the set block set screws, if necessary. Repeat this check process until the noted measurements are acceptable.

3.10 Quick check of the set

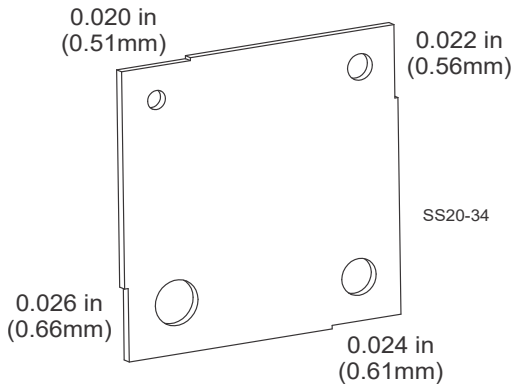


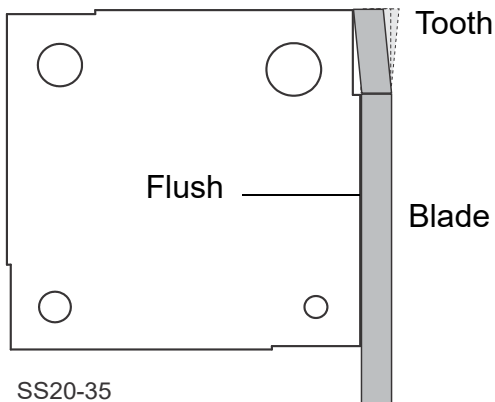
FIG. 3-15

For a quick check of the set gauge, use the SS20-331 set gauge included with your BMST50.

1. Use the set gauge. The set gauge has four standard set markings. Smallest to largest are:

- 0.020 in (0.51mm)
- 0.022 in (0.56mm)
- 0.024 in (0.61mm)
- 0.026 in (0.66mm)

They are denoted on the gauge by the small-to-large holes next to the appropriate corner. [See fig. 3-15](#).



4. FIG. 3-16

2. Place the gauge flush to the blade. The set is correct when the tip of the tooth makes contact with the appropriate depth mark. [See fig. 3-16](#).

3. If the set is not correct, it can be manually changed by using the set correction tool 004754. Place the tooth tip into the tool slot and bend the tooth until it reaches the proper set. [See fig. 3-17](#).

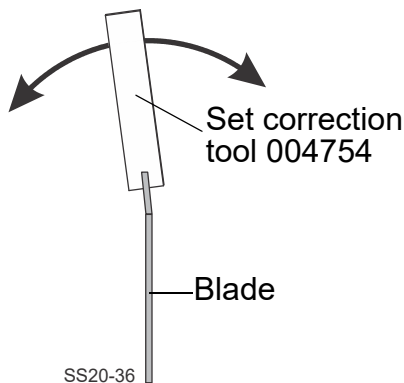


FIG. 3-17

SECTION 4 MAINTENANCE

4.1 Maintaining your Sharpener & Setter

Proper maintenance of your Sharpener & Setter will result in years of good blade sharpening and setting. Maintenance is simple and easy. Keep the machine clean.

4.2 Grinding wheel replacement

Check the grinding wheel often and change as necessary.

The grinding wheel should be in good condition. Replace if worn, the edges look shiny, and/or the wheel is "burning" the blades.

1. To replace, shut down and lock out all power to the machine.
2. Remove the grinding wheel cover.
3. Remove the grinding wheel nut, washer plate and grinding wheel.
4. Install the new grinding wheel. Reinstall the washer plate and nut.
5. Reinstall the grinding wheel cover. [See fig. 4-1](#).

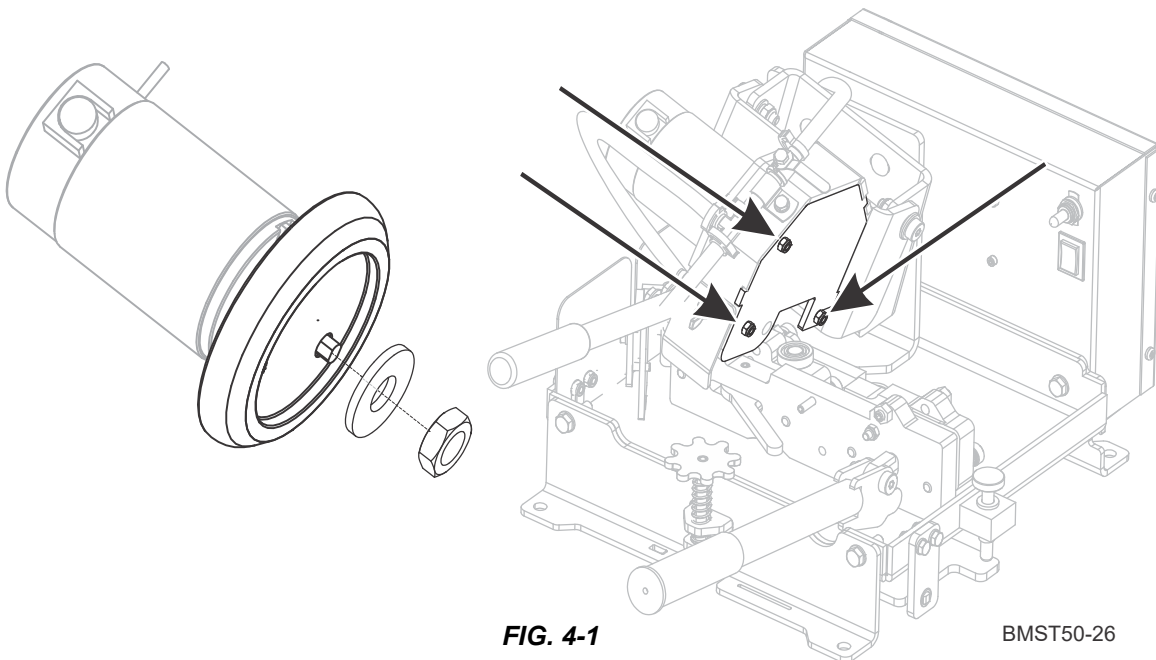


FIG. 4-1

BMST50-26

4.3 Grinding Oil

Use a grinding oil CE-150. You can order a 5 gallon bucket of this oil with part # 010740.

Periodically check the oil level and refill with oil as necessary.

Clean the metal shavings from the magnetic filters after every use.

4.4 Periodic maintenance

Daily (8 Operating hours):

- Wipe the Sharpener & Setter dry, remove the blade, lower the head, and unplug the machine after each day's use.
- Keep clean of dirt, rust, and metal filings.
- Check the blade clamp regularly and clean out any buildup that might cause it to not clamp the blade firmly.



Weekly (40 Operating hours):

- Clean sediment from the oil pan and filter magnets as needed.
- Keep the oil at such a level that the pump intake hose is completely covered with the oil.
- Replace the oil completely every six months. Dispose of worn-out oil in compliance with applicable regulations.

Monthly (160 Operating hours):

- Check motor and indexer brushes.
- Check plugs and switches.

4.5 Adjusting the grinding angle

The Sharpener & Setter is set at the factory to the proper cutting angle. If, for any reason, the angle becomes misaligned, it can be reset using the angle gauge plate SS20-999 provided. [See fig. 4-2](#).

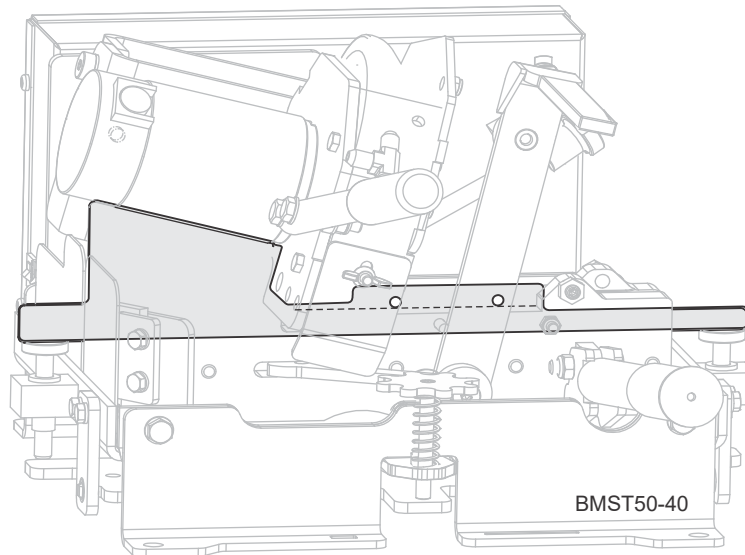


FIG. 4-2

1. Place the angle gauge in the blade slot.
2. Press the angle gauge flat against the main block.
3. With the blade height adjustment knob in front, raise the angle gauge until the reference holes just clear the main block.
4. Lower the grinder to the lowest position, touching the main block.
5. Fit the angle gauge in until it makes contact with the motor and motor housing. [See fig. 4-2](#)

6. If the motor and hosing does not align properly, then loosen the two upper carriage bolt nuts where the motor housing bracket attaches to the base. [See fig. 4-3](#).

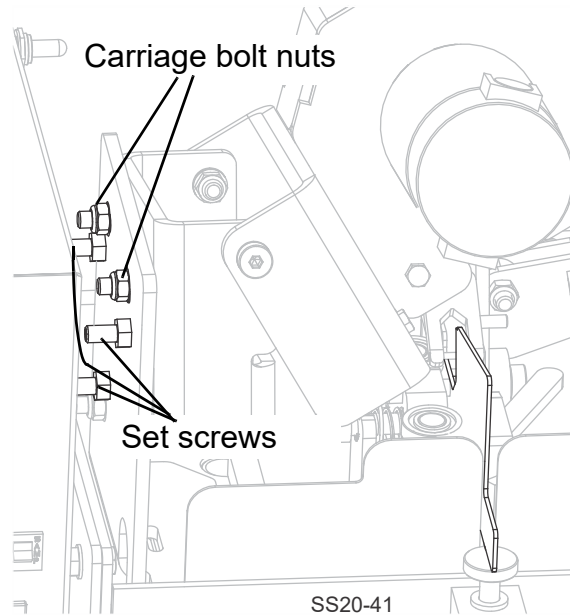


FIG. 4-3

7. Pivot motor housing until it aligns with the angle gauge.
8. If adjustments front-to-back are needed, the set screws may be adjusted by loosening the lock nut and finger-tightening them into the proper position. Re-tighten the lock nuts.
9. Re-check the alignment and repeat this procedure as necessary.

SECTION 5 REPLACEMENT PARTS

5.1 How To Use The Parts List

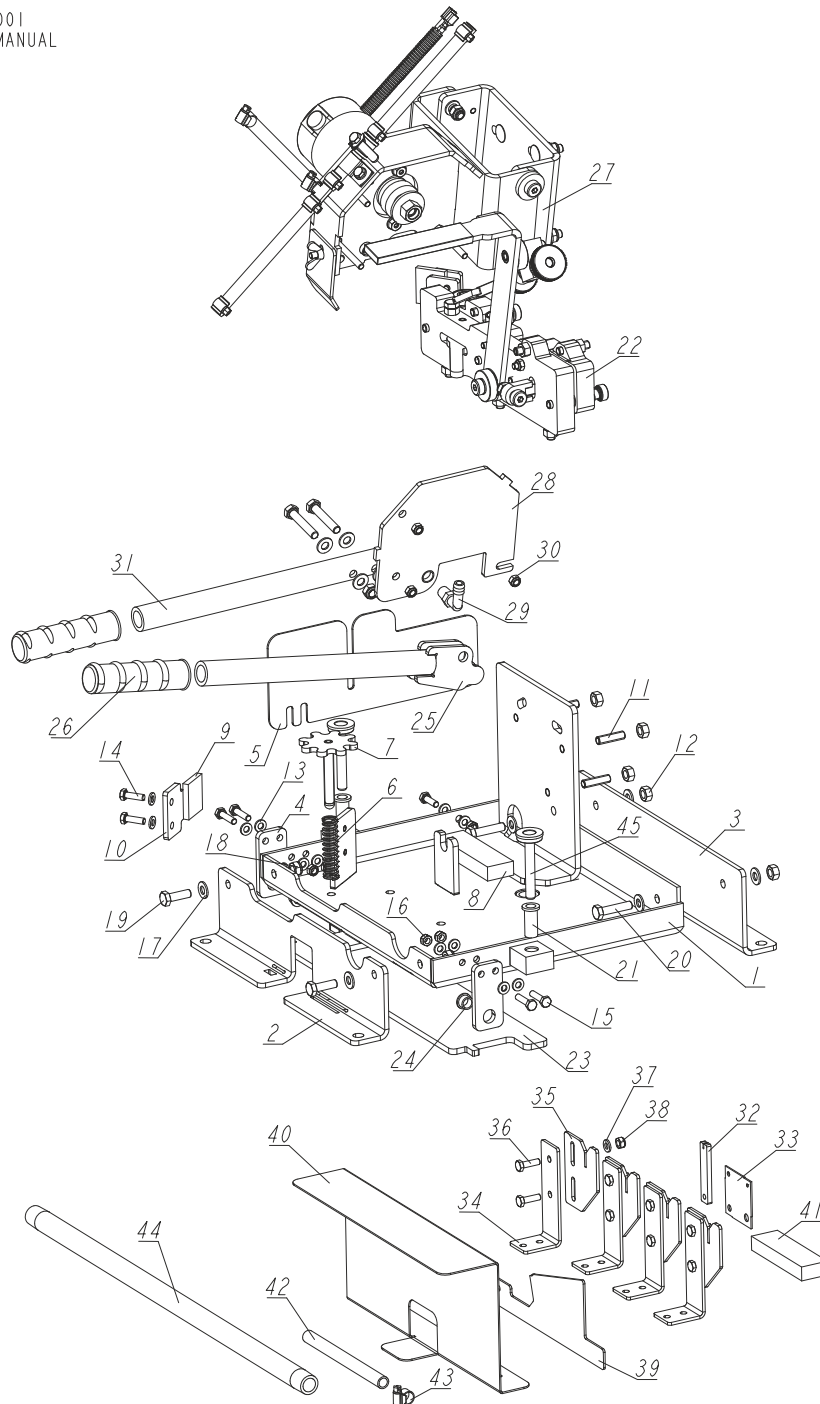
- Use the index above to locate the assembly that contains the part you need.
- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subas-sembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. Subassembly K05555 includes parts M06666 and F07777-77.

5.2 Sample Assembly			
REF.	DESCRIPTION	PART #	QTY
	Sample Assembly, Complete (Includes All Indented Parts Below)	A01111	1
1	Sample Part	F02222-22	1
	Sample Subassembly (Includes All Indented Parts Below)	A03333	1
2	Sample Part	S04444-4	1
	Sample Subassembly (Includes All Indented Parts Below)	K05555	1
3	Sample Part	M06666	2
4	Sample Part	F07777-77	1

5.3 Base Assembly

524736_001
524736_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY	
-	BMST50PL SHARPENER & SETTER	524736	1	
-	BASE ASSEMBLY	524598	1	
1	BASE	524596-1	1	

5

REPLACEMENT PARTS

Base Assembly

REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY	
2	GUARD, FRONT	524597-1	1	
3	GUARD, REAR	524599-1	1	
4	PLATE, PIVOT SUPPORT	524600-1	2	
5	PLATE, SHARPENER GUARD	524601-1	1	
6	SPRING, .60ODX2-1/2X.098 WIRE	066816	1	
7	KNOB, HEIGHT ADJUSTMENT	524604-1	1	
8	MAGNET, 100X30X15 SHARPENER OIL FILTER	516192	1	
9	SWEEPER, OIL	524605	1	
10	RETAINER, SWEEPER	524602-1	1	
11	SCREW, M8X30 DIN 913 A2-70 STAINLESS STEEL SET	F81014-8	3	
12	NUT, M8-8-B HEX ZINC	F81032-1	5	
13	WASHER, 6.4 FLAT ZINC	F81053-1	12	
14	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	3	
15	BOLT, M6X25-8.8 HEX HJEAD FULL THREAD ZINC	F81001-3	4	
16	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	5	
17	WASHER, 8.4 FLAT ZINC	F81054-1	8	
18	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2	
19	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2	
20	BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC	F81002-13	2	
21	BUSHING, 3/8 ID X 1/2 OD X 1-1/4	SS20-921	2	
22	ASSEMBLY, SHARP/SET BLOCK	524618	1	
23	PLATE, BLADE HEIGHT ADJUSTMENT	524737-1	1	
24	BUSHING, 10MMIDX13MMODX8MM	SS20-923	2	
-	HANDLE, SETTER - COMPLETE	526219	1	
25	HANDLE, SETTER	524740-1	1	
26	GRIP, HANDLE (ESSENTRA PART NO. 10126)	524767	1	
27	MOUNT ASSEMBLY, SHARPENER MOTOR	524746	1	
	MOUNT ASSEMBLY, SHARPENER MOTOR CE	528492	1	
28	GUARD, GRINDING WHEEL	524750-1	1	
29	BARB, 3/8 IN HOSE X 1/4 ML NPT ELB	P04730	1	
30	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	3	
31	HANDLE ASSEMBLY, SHARPENER	524753	1	
-	ITEMS PROVIDED WITH THE MACHINE	524762	1	
32	TOOL, SET CORRECTION	524755	1	
33	TOOL, QUICK SET CHECK	524756	1	
-	SUPPORT ASSEMBLY, BLADE	524757	4	
34	BASE, BLADE STAND	524758-1	1	
35	PLATE, BLADE STAND	524759-1	1	
36	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	2	
37	WASHER, 6.4 FLAT ZINC	F81053-1	2	
38	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
39	GAUGE, ANGLE	524760-1	1	

REPLACEMENT PARTS

Base Assembly

5

REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY	
40	GUARD, BLADE	524761-1	1	
41	MAGNET, 100X30X15 SHARPENER OIL FILTER	516192	1	
42	HOSE, WATER LUBE STOCK	R01885	1	
43	CLAMP 8-12	F81080-1	1	
44	PIPE, DRAIN	524763	1	
45	PIN, BLADE HEIGHT ADJUSTMENT	524754	2	

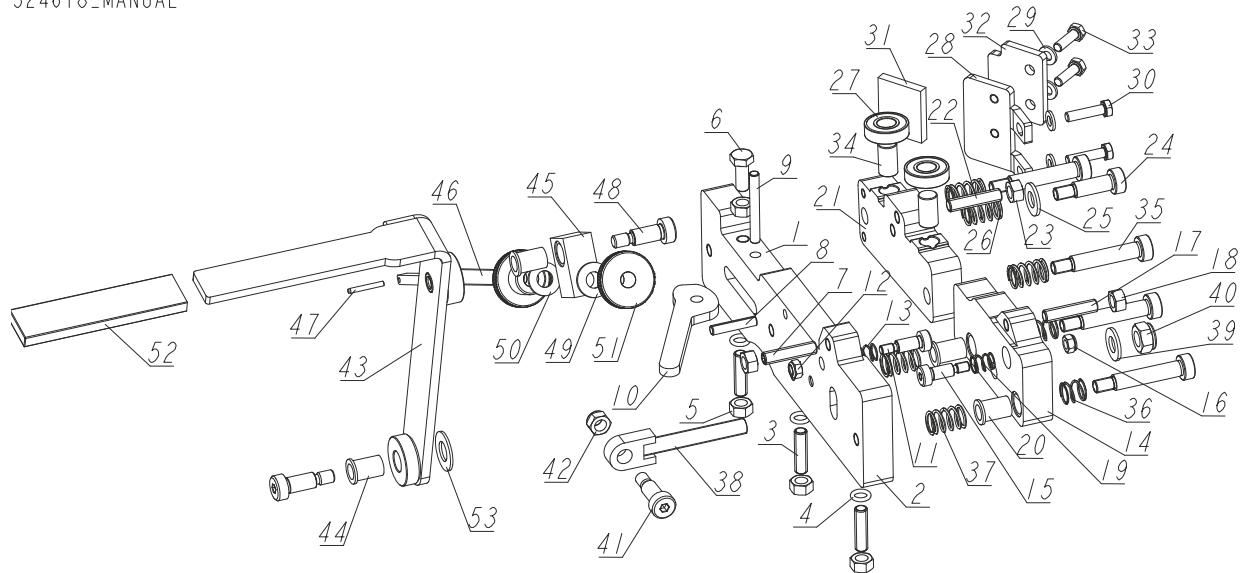
5

REPLACEMENT PARTS

Sharp/Set Block Assemblies

5.4 Sharp/Set Block Assemblies

524618_001
524618_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
-	ASSEMBLY, SHARP/SET BLOCK	524618	1
1	BLOCK ASSEMBLY, MAIN	524609	1
2	PLATE, MAIN	524607-1	1
3	SCREW, M8X30 DIN 913 A2-70 STAINLESS STEEL SET	F81014-8	3
4	O-RING, OR 8X2.5 CX	524608	3
5	NUT, M8-8-B HEX ZINC	F81032-1	5
6	BOLT, M8X20-8.8 HEX HEAD FULL THREAD ZINC	F81002-1	1
7	SCREW, M8X35 DIN 913 A2-70 STAINLESS STEEL SET	F81014-9	1
8	PIN, 6X30 ROLL ZINC	F81045-7	1
9	PIN, 6X50 ROLL ZINC	F81045-1	1
10	LEVER, BLADE CLAMP	524610-1	1
11	BOLT, 8/M6X16-12.9 ISO 7379 SHOULDER	F81001-70	1
12	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1
13	SPRING, 10.67MMOD X 12.7MM LX.89MM WIRE	SS20-937	1
-	CLAMP ASSEMBLY, SETTER	524612	1
14	PLATE, SETTER	524611-1	1
15	BOLT, 8/M6X16-12.9 ISO 7379 SHOULDER	F81001-70	1
16	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1
17	SCREW, M8X35 DIN 913 A2-70 STAINLESS STEEL SET	F81014-9	1

REPLACEMENT PARTS

Sharp/Set Block Assemblies

5

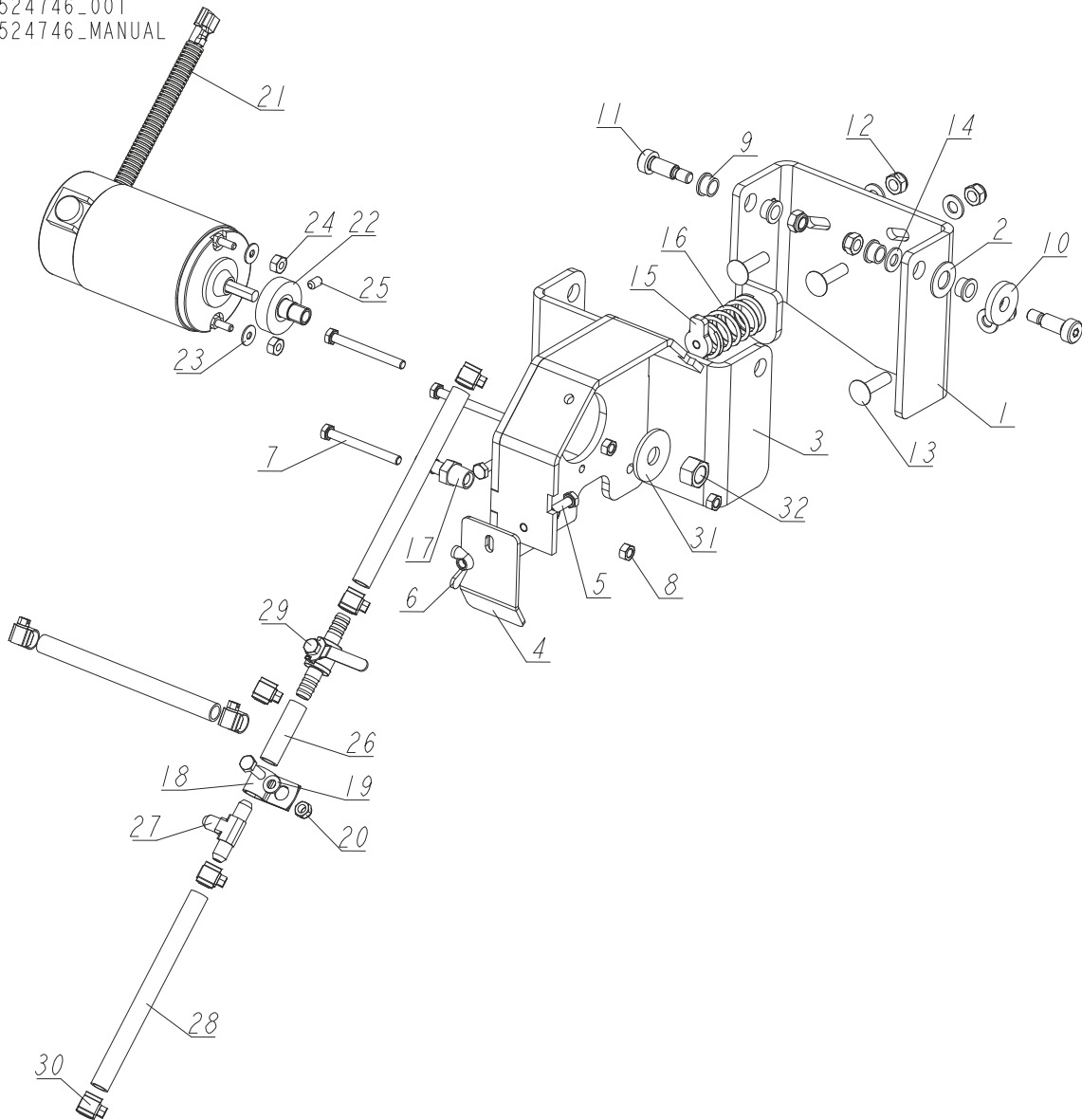
REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
18	NUT, M8-8-B HEX ZINC	F81032-1	1
19	SPRING, 10.67MMOD X 12.7MM LX.89MM WIRE	SS20-937	1
20	BUSHING, 10MMIDX13MMODX20MM	SS20-922	2
-	PLATE, SHARPENER	524615	1
21	PLATE, SHARPENER CLAMP	524614-1	1
22	SCREW, M8X35 DIN 913 A2-70 STAINLESS STEEL SET	F81014-9	1
23	NUT, M8-8-B HEX ZINC	F81032-1	1
24	BOLT, 10/M8X25 12.9 ISO7379 SHOULDER	F81003-77	1
25	WASHER, 10.5 FLAT ZINC	F81055-1	1
26	SPRING, 14MMODX24MMLX1.6MM WIRE	SS20-936	1
27	BEARING, 6001 2RSR (FAG, SKF)	087893	2
28	PLATE, SWEEPER RETAINER REAR	524617-1	1
29	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	4
30	ŚRUBA M6X25-8.8 FE/ZN5 PN-85/M-82105	F81001-3	2
31	SWEEPER, OIL	524605	1
32	RETAINER, SWEEPER	524602-1	1
33	ŚRUBA M6X20 8.8 FE/ZN5 PN-85/M-82105	F81001-2	2
34	SHAFT, SHARPENER PLATE	524616	2
35	BOLT, 10/M8X45 12.9 ISO7379 SHOULDER	F81003-126	4
36	SPRING, 13.7MMODX12.7MMLX1MM WIRE	SS20-943	2
37	SPRING, 14MMODX24MMLX1.6MM WIRE	SS20-936	4
38	WELDMENT, ROD END	524621-1	1
39	WASHER, 10.5 FLAT ZINC	F81055-1	1
40	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	1
41	BOLT, 10/M8X20-12.9 BOSSARD SHOULDER	F81003-99	1
42	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	1
-	PUSH PAWL ASSEMBLY	524735	1
43	HANDLE, PUSH PAWL	524628-1	1
44	BUSHING, 10MMIDX13MMODX20MM	SS20-922	2
45	BLOCK, PUSH PAWL	524624-1	1
46	FORK, PUSH PAWL	524622-1	1
47	PIN, 3M6X24 DIN6325 HRC60 DOWEL	F81048-9	1
48	BOLT, 10/M8X20-12.9 BOSSARD SHOULDER	F81003-99	2
49	WASHER, BELLEVILLE .4IDX.875ODX.075H	F05011-139	1
50	WASHER, 10.5 FLAT ZINC	F81055-1	1
51	NUT, DIN466-M10 GANTER-GRIFF PUSH PAWL ADJUSTMENT	087375	2
52	SLEEVE, VINYL GUARD	086875	1
53	WASHER, THRUST BUSHING	SS20-983	1

5 REPLACEMENT PARTS

Motor Mount Assembly

5.5 Motor Mount Assembly

524746_001
524746_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
-	MOUNT ASSEMBLY, SHARPENER MOTOR	524746	1
-	MOUNT ASSEMBLY, SHARPENER MOTOR CE	528492	1
1	PLATE, SHARPENER	524741-1	1
2	WASHER, THRUST BUSHING	SS20-983	1
3	MOUNT WELDMENT, MOTOR	524745-1	1

REPLACEMENT PARTS

Motor Mount Assembly

5

REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
4	PLATE, GUARD	524747-1	1
5	BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC	F81001-2	3
6	NUT, M6 FE/ZN5 PN-M/82439 WING	F81032-3	1
7	BOLT, M6X60-8.8 HEX HEAD FULL THREAD ZINC	F81001-9	3
8	NUT, M6 8 HEX ZINC	F81031-1	3
9	BUSHING, 10MMIDX13MMODX8MM	SS20-923	4
10	WASHER, 10.5/30-5	505156-1	1
11	BOLT, 10/M8X20-12.9 BOSSARD SHOULDER	F81003-99	2
12	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	5
13	BOLT, M8X30-8.8 CARRIAGE ZINC (DIN 603)	F81002-69	3
14	WASHER, 8.4 FLAT ZINC	F81054-1	4
15	CLAMP, SPRING HOLD DOWN	524748-1	1
16	SPRING, 1.1ODX2LX.112 WIRE	SS20-938	1
17	FITTING, 3/8 BARB 1/4NPT MALE	P04682	1
18	CLAMP, 1/2EMT COATED	P07584	1
19	WASHER, 6.4 FLAT ZINC	F81053-1	1
20	NUT, A M6-8-B HEX NYLON ZINC LOCK	F81031-2	1
-	ASSY, MOTOR 12VDC	SS20-952	1
-	ASSY, MOTOR 12VDC/3700RPM/1/7HP CE	528491	1
21	ASSY, MOTOR AND CABLE	SS20-984	1
	MOTOR, 12VDC CURRENT APPLICATION, 3700RPM, 1/7H CE	528485	1
22	ADAPTOR, WHEEL 12V MOTOR	SS20-917	1
23	WASHER, #10 SAE FLAT	F05011-18	2
24	NUT, #10-32 HEX	F05010-27	2
25	SCREW, M6-1 X 10 SH CUP PT SET	F05020-16	1
26	HOSE, WATER LUBE STOCK	524749	1
27	FITTING 3/8 TEE BARB	015485	1
28	HOSE, WATER LUBE STOCK	R01885	3
29	VALVE, 1/4TURN BALL 3/8 HOSE BARBS	065635	1
30	CLAMP, 8-12	F81080-1	7
31	WASHER, 13 SPECIAL FLAT ZINC	F81056-14	1
32	NUT, M12-8-B HEX ZINC	F81034-1	1
	GRINDING WHEEL, CBN 10/30, BORAZON COATED	030381-1	1

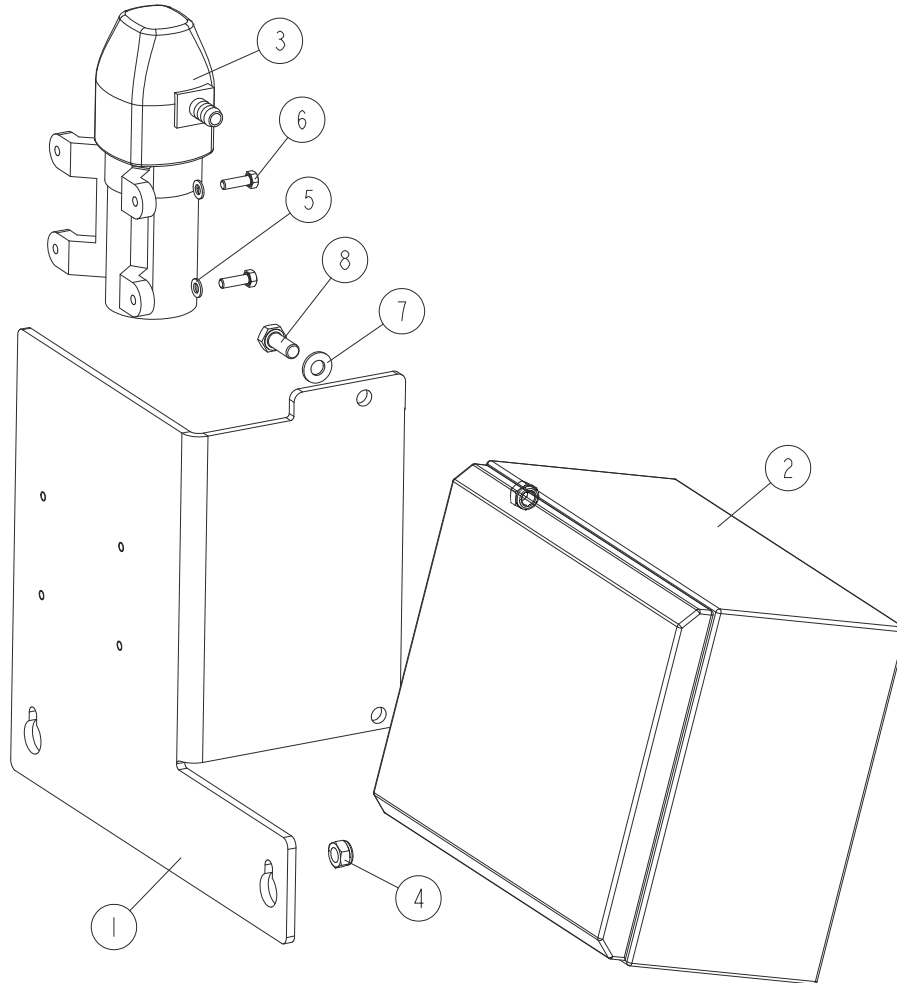
5

REPLACEMENT PARTS

Electric Box w/Pump

5.6 Electric Box w/Pump

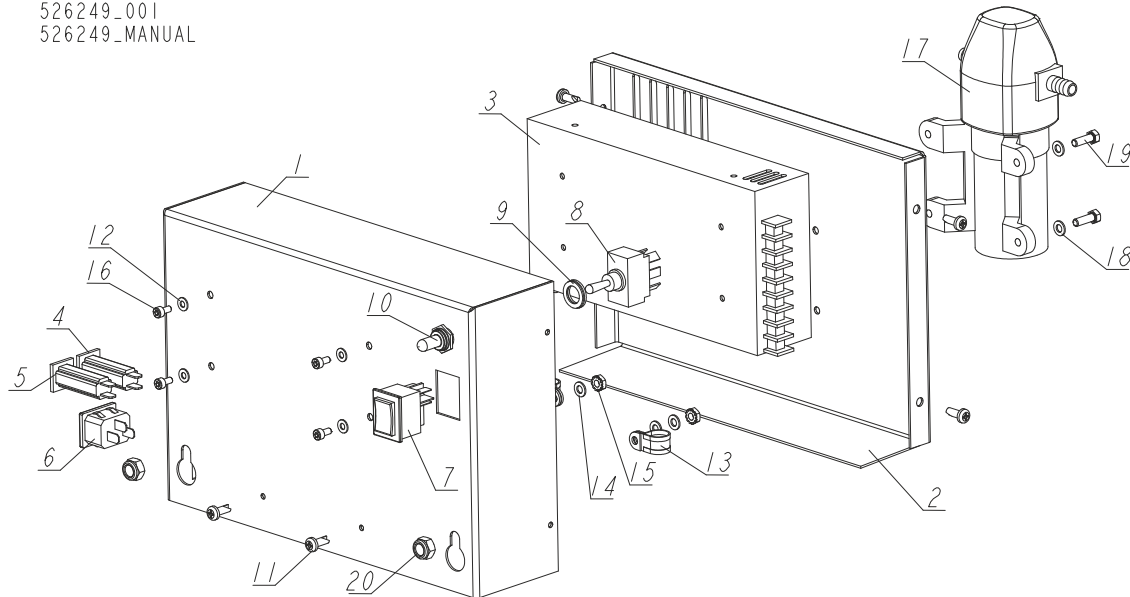
526248_001
526248_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
-	ELECTRIC BOX W/LUBE PUMP	526248	1
1	BRACKET, MOUNT	518726-1	1
2	BOX, BMST50 ELECTRIC	517368	1
	DECAL, BMST50 ELECTRIC BOX	533521	1
3	PUMP, 12V FEED	033491	1
4	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
5	WASHER, 5.3 FLAT ZINC	F81052-1	4
6	BOLT, M5X16-8.8 HEX HEAD FULL THREAD ZINC	F81000-51	4
7	WASHER, 8.4 FLAT ZINC	F81054-1	2
8	BOLT, M8X20-8.8 HEX HEAD FULL THREAD ZINC	F81002-1	2

5.7 Electric Box w/Pump (USA)

526249_001
526249_MANUAL

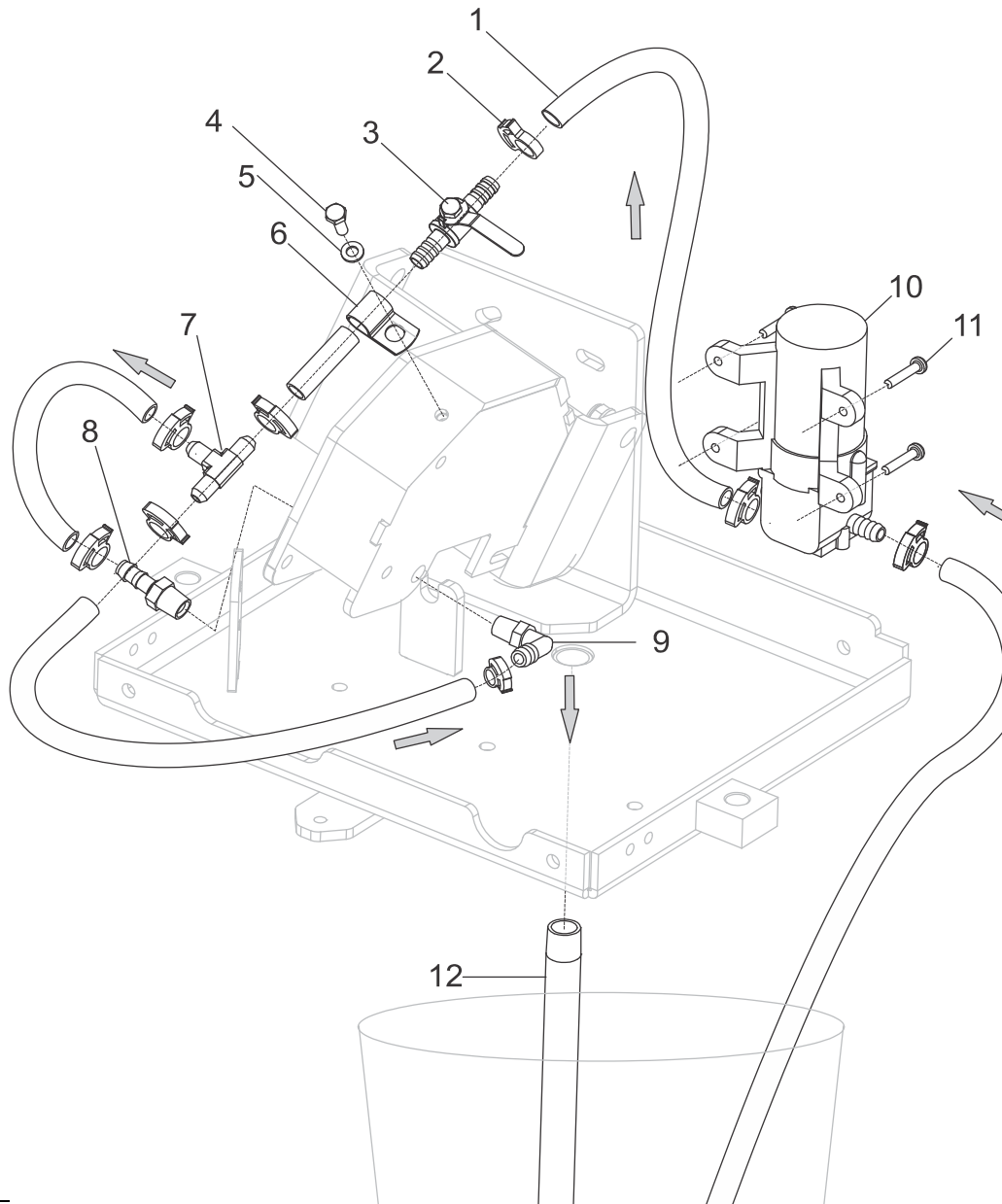


REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
-	ZELECTRIC BOX W/PUMP (USA)	526249	1
-	BOX, ELECTRIC (USA)	524766	1
1	BOX WELDMENT, ELECTRIC (USA)	524765-1	1
2	COVER, ELECTRIC BOX (USA)	524764-1	1
3	POWER SUPPLY, 12VDC 320W CHASSIS-MOUNT	053592	1
4	BREAKER, 4A PANEL MOUNT	068334	1
5	BREAKER, 15 AMP PANEL MOUNT	E10698	1
6	RECEPTACLE, POWER ENTRY	060216	1
7	SWITCH, I/O ROCKER	060515	1
8	SWITCH, DPDT ON/OFF/ON 15A TOGGLE	024588	1
9	WASHER, 1/2X3/4X1/16 NYLON	P05251-1	1
10	BOOT, SWITCH SEALING	024589	1
11	BOLT, #10-24X1/2 PH	F05015-17	6
12	PODKLADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	4
13	CLAMP, RSGU 1.10/12W1 METAL & RUBBER	086861	2
14	WASHER, 5.3 FLAT ZINC	F81052-1	3
15	NUT, #10-24 KEPS	F05010-14	2
16	SCREW, M4X8 8.8 HEX SOCKET HEAD CAP ZINC	F81011-36	4
17	PUMP, 12V FEED	033491	1
18	WASHER, 5.3 FLAT ZINC	F81052-1	4
19	BOLT, M5X16-8.8 HEX HEAD FULL THREAD ZINC	F81000-51	4
20	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2

5 REPLACEMENT PARTS

Lube System

5.8 Lube System



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
1	Tubing, Lube ¹	R01885	247 cm
2	Hose Clamp, Single Snap Grip	F81080-1	8
3	Valve, 1/4 Turn Ball 3/8 Hose Barbs	065635	1
4	Bolt, M6 x20-8.8 Hex Head Full Thread Zinc	F81001-2	1
5	Washer, 6.4 Flat Zinc	F81053-1	1
6	Clamp, 1/2EMT Coated	P07584	1
7	Fitting, 3/8 Barb Tee	015485	1
8	Fitting, 3/8Barb 1/4NPT Male, Nylon	P04682	1

REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only)	PART #	QTY
9	Barb, 3/8IN. Hose X 1/4 NPT NylElbow	P04730	1
10	Pump, 12VDC Feed	033491	1
	Fitting, 12VDC Feed Pump ²	074750	1
11	Bolt, M5x16-5.8 Hex Head Full Thread Zinc	F81000-51	4
12	Pipe, Drain	524766	1
13	Magnet, Filter	516192	1

¹ Tubing is cut to length and assembled at the factory.

Oil not included. It must be purchased separately by ordering 010740 Oil, 19l #Grindeze 150C w/Label.

² Fitting comes with the pump, but can be ordered separately.

INDEX

B

blade supports
 adjustment 2-6
 blade installation 3-2
 location 2-6
 mounting 2-5

C

CAUTION! 1-2

D

DANGER 1-2

deburr 3-8

G

grinding wheel
 replace 4-1
 set up 2-7
 wear 4-1

M

magnes
 zespół podstawy 5-2

magnet
 drain 2-4

major components 1-7

N

NOTE 1-2

O

oil 2-1
 bucket location 2-4
 checking 4-2
 flow 3-8

olej
 numer części 5-12

P

pump
 installation 2-3

S

safety
 blade handling 1-2
 decal meaning 1-3
 operation 1-2

service information
 branch locations 1-v
 general contact info 1-iv

set 3-1
 checking 3-10
 how to 3-8

setup
 site preparation 1-6

sharpening 3-3
 blade advancement 3-5
 tips 3-8

switches 3-7

W

WARNING! 1-2
