



Timberly[®]

Toothsetter/Guage

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

BT100

rev. D.01



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

Form #220_en

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SECTION 1 OVERVIEW

1.1 Toothsetter/Gauge (LTTSG) Introduction

There are two steps to maintaining blades used on the Timbery sawmill. They should ALWAYS be followed in this order:

1. Blade Sharpening
2. Toothsetting

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

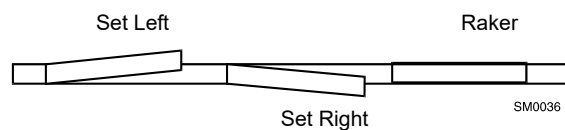


FIG. 1-1

See Figure 1-2. As the blade is sharpened, the tip of the tooth recedes and the set becomes smaller. Correct setting is one of the most important factors in the cutting ability of a blade. Check used blades regularly to see if they need resetting.

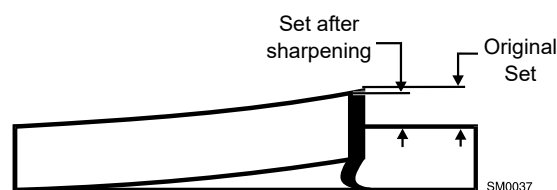


FIG. 1-2

The Toothsetter/Gauge (LTTSG) provided in the Blade Maintenance Package allows you to accurately and evenly set the teeth of a bandsaw blade. The spring-loaded clamping mechanism lets you position a tooth in front of the Gauge and clamp it in place. You can then measure the set. The tooth is bent by clamping the blade further. This chapter describes proper setup and operation of the toothsetter.

1.2 Deburring The Blade

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

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

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

SECTION 2 SETUP

Mount the toothsetter to the stand. Use the mounting holes found in the base plate of the setting fixture. Use the provided bolts (inserting the bolts down through the top of the mounting plate), wing nuts and washers. Setup the toothsetter so that there is at least 32" (81.0 cm) to the rear and to either side of the tool. This allows enough room for the blade supports.

See Figure 2-1. The main components of the toothsetter are shown below. These parts will be discussed in the following instructions.

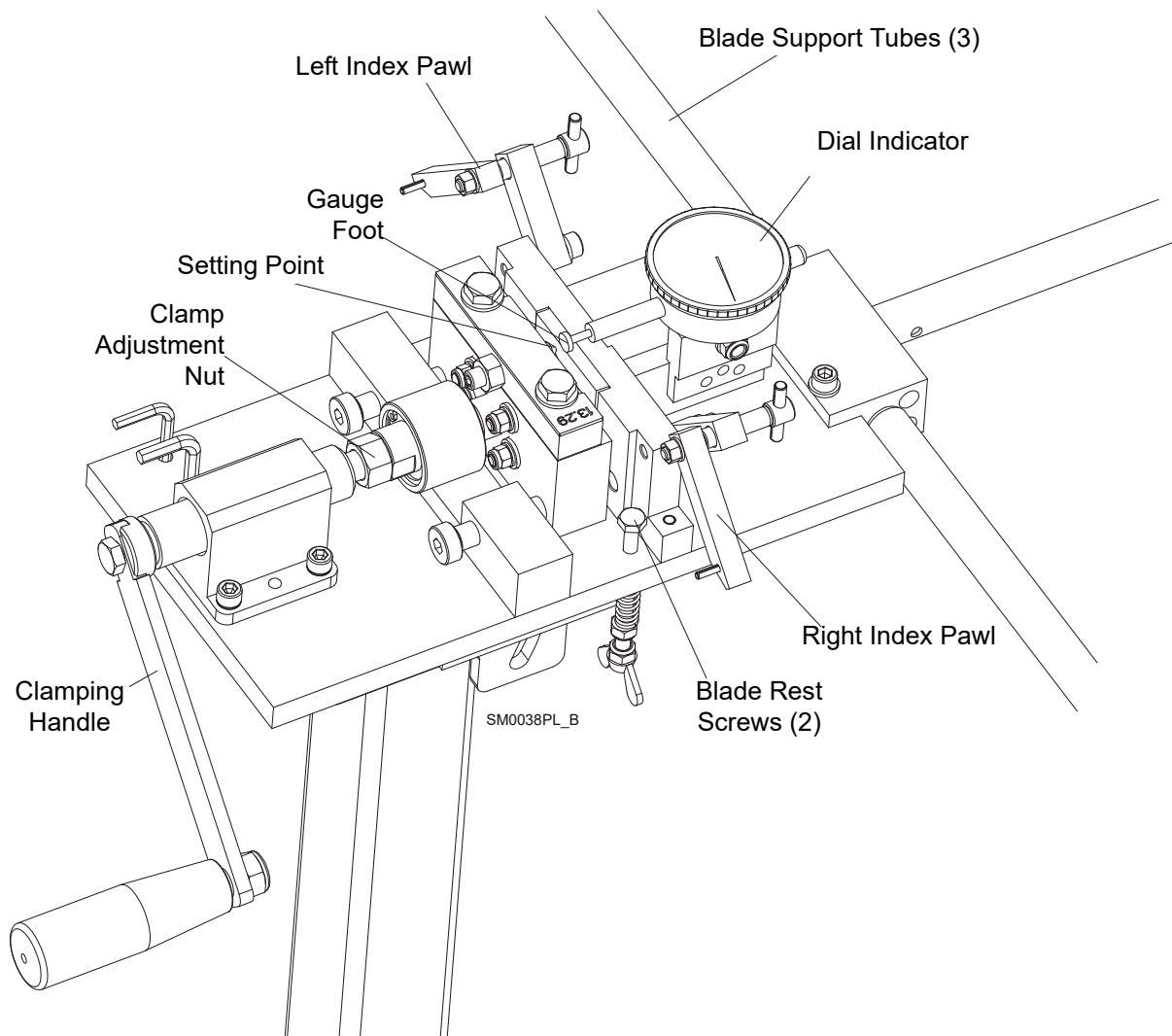


FIG. 2-1

2.1 Blade Support Installation

Attach the three blade support arms to the threaded mounting bar at the rear of the tooth-setter.

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

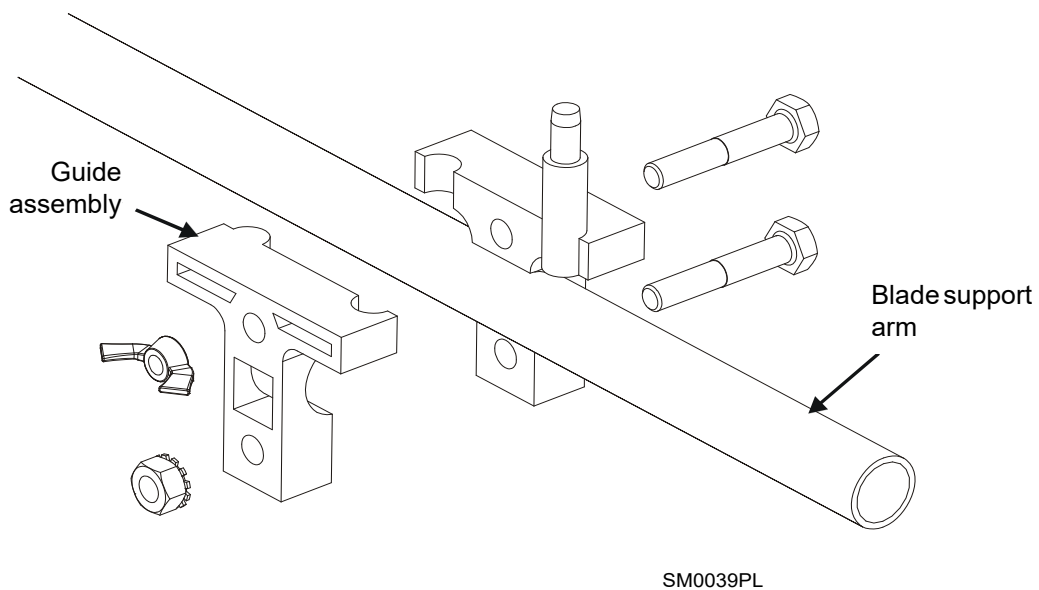


FIG. 2-2

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

2.2 Dial Indicator Setup

See Figure 2-3.

1. **Back the setting point out of the way.** Insert the hex key in the end of the setting contact point shaft and turn counterclockwise until the setting contact point is behind the front edge of the moving clamping plate.
2. **Adjust the Dial Indicator.** Clamp the gauge pin between the clamping plates. The pin should be touching the center of the gauge foot.

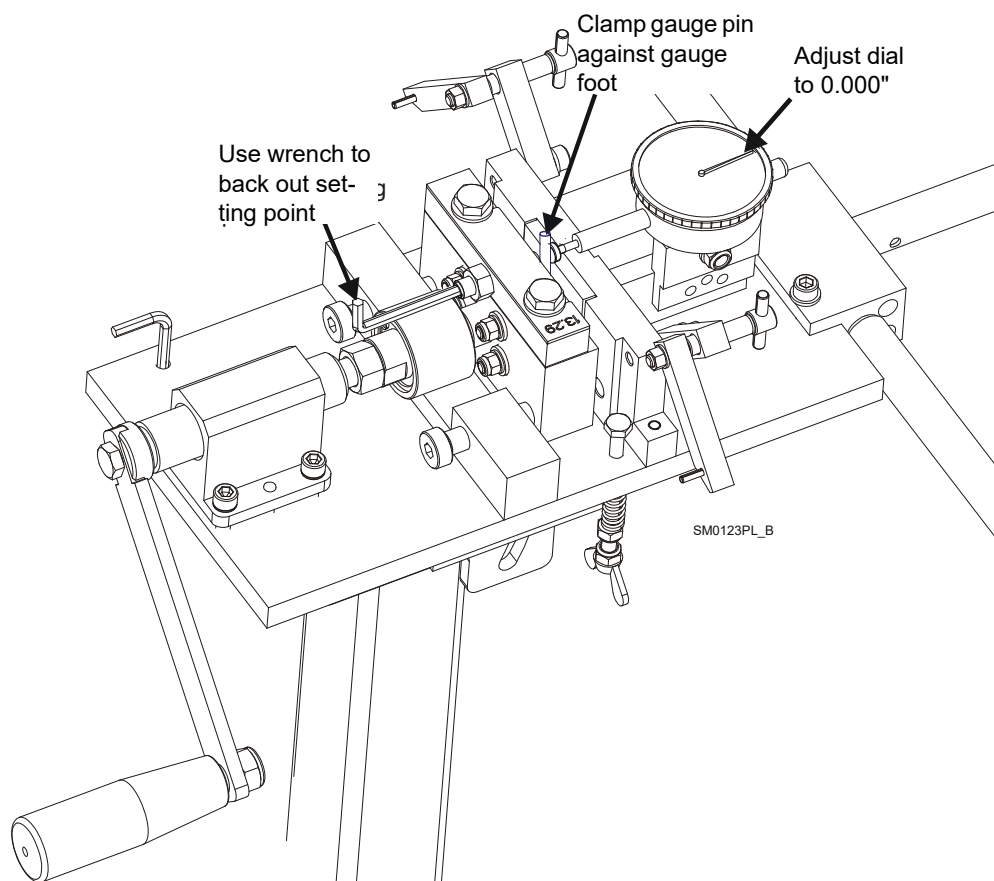


FIG. 2-3

The dial indicator should read 0. If the dial indicator does not show 0, loosen the dial lock on the upper right side of the dial indicator. Rotate the dial indicator to 0 and retighten the dial lock.

Now, remove the gauge pin from the toothsetter clamp. The dial indicator should now read between $-.001$ and $-.005$.

See **Figure 2-4**. If the dial indicator does not read between $-.001$ and $-.005$ with nothing clamped, you will need to adjust the indicator mounting block:

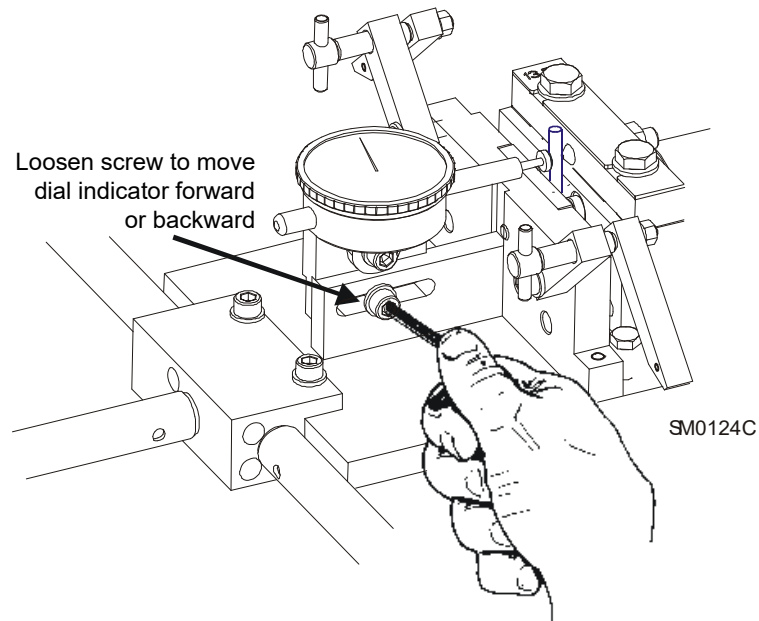


FIG. 2-4

3. Reclamp the gauge pin centered on the gauge foot.
4. Loosen the screw at the bottom of the indicator mounting block. Move the indicator assembly back until the gauge foot does not touch the gauge pin.
5. Move the indicator assembly forward so the gauge foot touches the gauge pin and the gauge needle moves $.001 - .005$. Retighten the mounting block screw. Make sure the mounting block remains flat against the toothsetter base plate.
6. Rotate the dial face until the gauge reads zero.
7. Unclamp the gauge pin. The indicator should now read $-.001$ to $-.005$. If not, repeat steps 3 - 6.

SECTION 3 OPERATION & MAINTENANCE

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

Sharpening removes metal from the face of the tooth. This eventually reduces the set to a point where the blade will not cut very well. Set should not vary more than $(\pm)0.001$ from one tooth to the next.

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

Note: Refer to the *Tru•Sharp™ Blade Handbook* for recommended set specifications for your sawing application.

3.1 Blade Installation

1. **Clean the blade and deburr before putting it in the toothsetter.** Otherwise, sap buildup on the blade or tooth will give false set readings. Metal burrs created by sharpening also will cause false readings.
2. **Mount the blade in the toothsetter.** Place blade between the clamping plates and on the three guide assemblies.

NOTE: You will need to move both the left and right index pawl assemblies down and out of the way. These will be adjusted later.

3. **Set the clamping assembly to hold the blade.** The clamp is set at the factory to lock the blade firmly as the handle throws over. If the handle is difficult to push forward or throws over before locking the blade, adjust the clamp nut.

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Operation & Maintenance

Toothsetter Adjustments

See **Figure 3-1**. Loosen the clamp adjustment nut. Turn the clamp nut and set the distance between the clamp plates. After the clamp is adjusted properly, tighten the clamp adjustment nut.

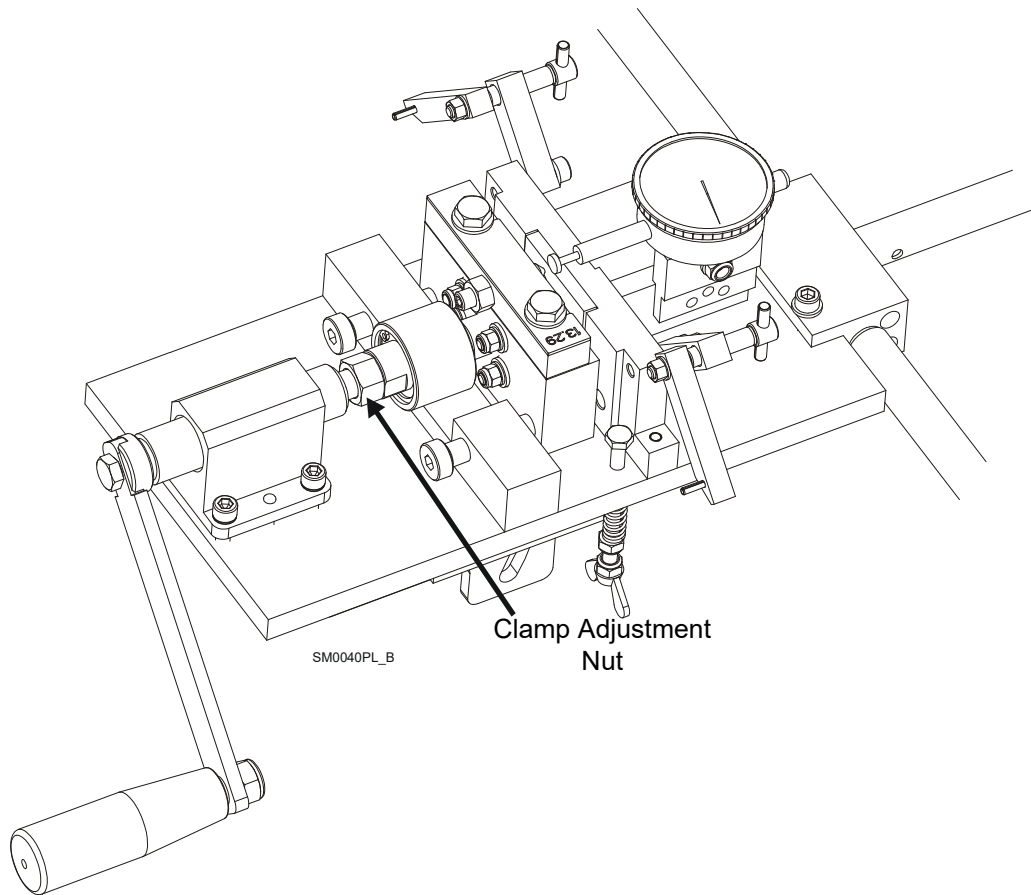


FIG. 3-1

3.2 Toothsetter Adjustments

See Figure 3-2.

1. **Adjust the blade rest screws.** Rest the blade evenly on the two blade rest bolts on each side of the clamp. Adjust the rest screws until the gullet of the blade lies just above the top of the clamp plates. (Deburring will remove burrs from the back side of the teeth, but may not remove burrs from the gullet area. Keeping the gullet out of the clamp assembly helps to assure accurate readings.)

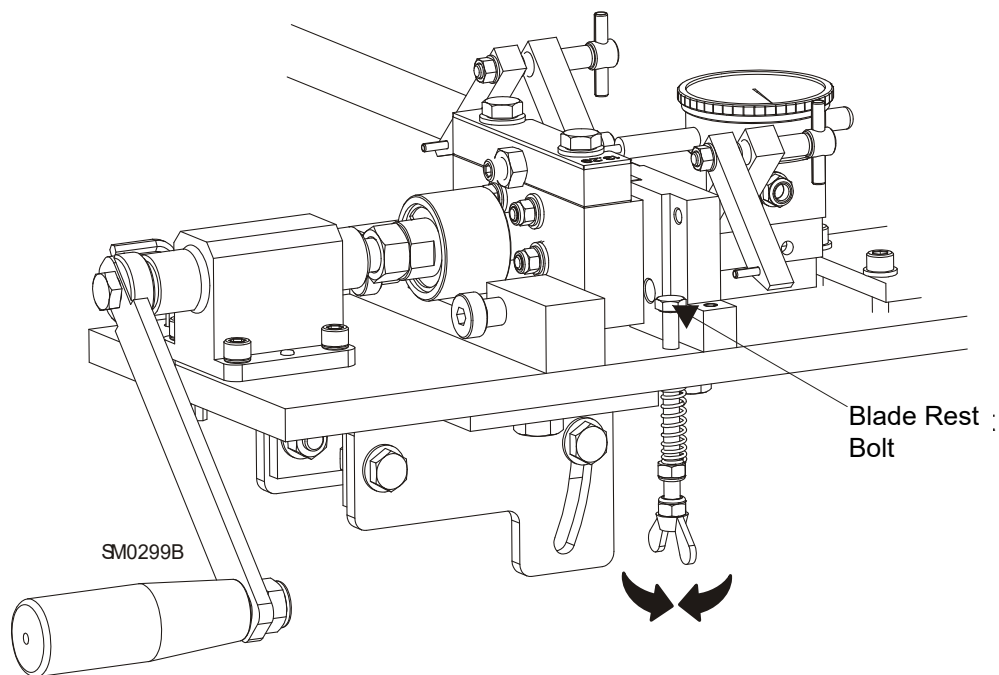


FIG. 3-2

2. **Make final adjustments to blade support arms and guide assemblies.** Adjust to assure the blade travels smoothly. Blade should rest on rear guide, but should not touch the bottom of either side guide assembly.
3. **Adjust the setting contact point.** Position the blade so the gauge foot is in between two teeth. Use the hex key to bring the setting contact point towards the gauge foot until the dial indicator reads 15-20 thousandths.

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Operation & Maintenance

Toothsetter Adjustments

- 4. Position the blade.** Turn the blade to bring a weld into the clamping/setting assembly. Use the weld as a reference point for starting and stopping. Start with the first tooth to the right (See NOTE) of the weld that has been set back toward the dial indicator.

NOTE: The toothsetter sets and measures the teeth which are set away from the operator and towards the dial indicator. To measure teeth set in the opposite direction, invert the blade and insert it in the toothsetter.

See Figure 3-3. Position that tooth in front of the gauge foot so the its edge is aligned with the center of the setting point.

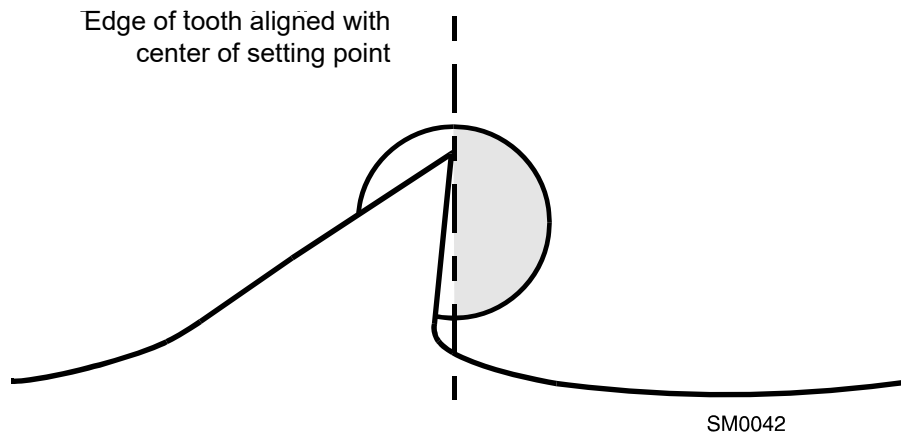


FIG. 3-3

5. The index pawls are factory-set for *Tru•Sharp*™ blades with 7/8" tooth spacing. Check the right (or left if the blade is inverted) side index pawl is firmly against the tooth two teeth to the right (or left) of the one being set. To adjust, loosen the index pawl screw with the hex key provided and move the pawl tight against the tooth. Retighten the screw.

3.3 Setting Point Adjustment

If you are setting a blade with a **10.30** or **13.29** profile, install an appropriate washer spacer to the moving blade clamp assembly before beginning the setting operation (see the figures below). It is not necessary to use a washer spacer when blades with 9.29 profiles are set. Each toothsetter is equipped with two washer spacers for adjusting the setting point: a washer marked "10.30" (part No. 094312) and a washer marked "13.29" (part No. 094313). Use the "10.30" washer for standard, 10.30 blade profiles and the "13.29" washer for 13.29 blade profiles. The "10.30" washers are factory-installed in the

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Setting Point Adjustment

machine.

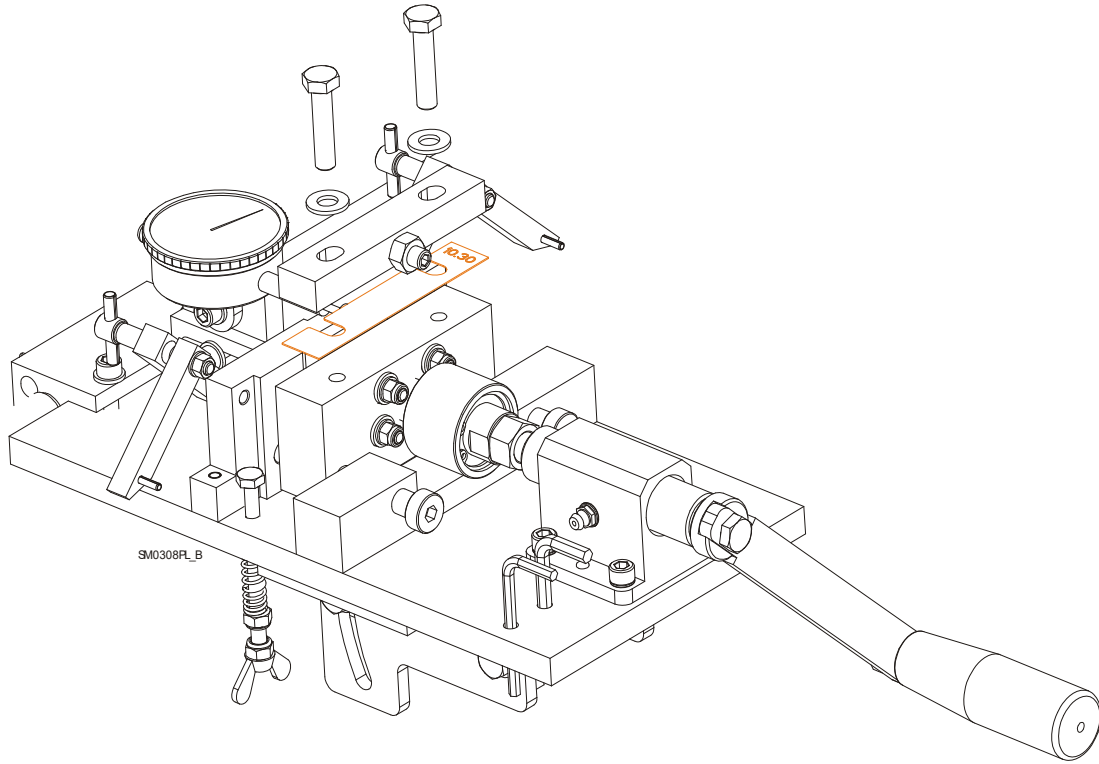


FIG. 3-4

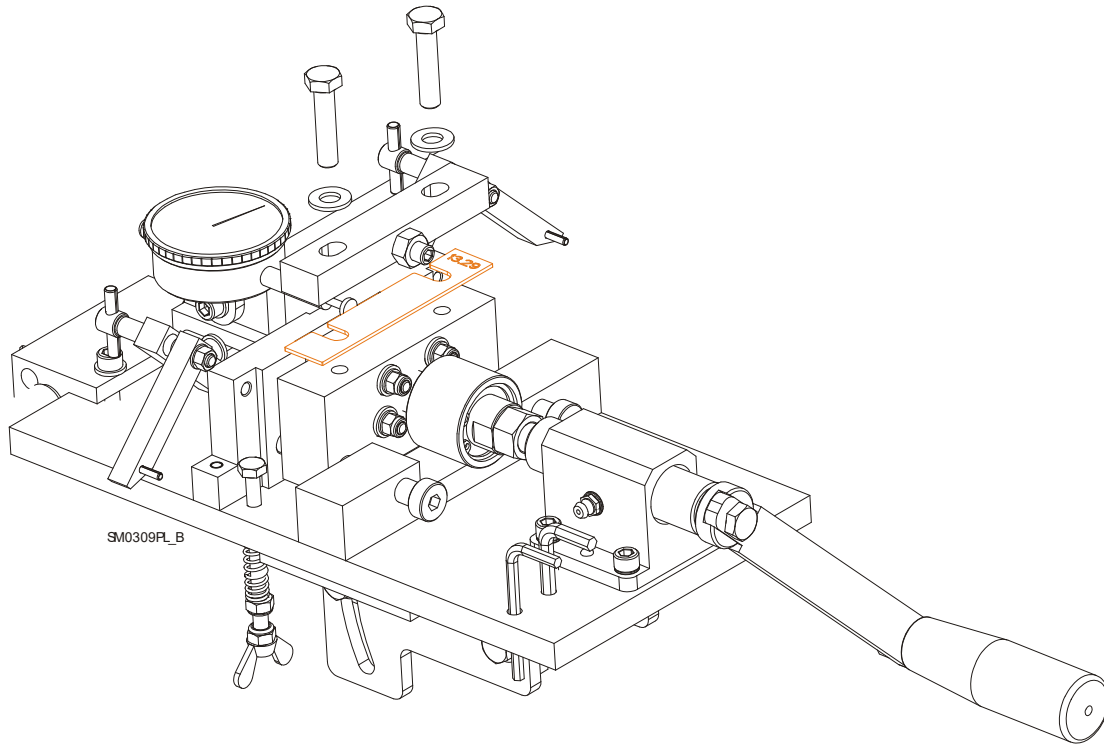


FIG. 3-5

3.4 Toothsetter Operation

1. **Set the blade.** Measure set by clamping the blade between the back clamping plate and the spring-loaded pins on the front clamping plate. Remember set should not vary more than (\pm)0.001 from one tooth to the next.

To add set, clamp in further on the blade. This brings the setting contact point against the tooth. The amount you will need to bend the tooth forward to get the desired set will vary. Recheck set and adjust as needed.

NOTE: If the clamp locks before you have added enough set, adjust the setting contact point in. **DO NOT** adjust the clamp nut.

To decrease set, bend the tooth back with the slot in the correction tool provided. Recheck set and adjust as needed.

Slide the blade to the right (or left) until the third tooth from the one just set comes in front

of the gauge foot. Push this tooth firmly against the index pawl. Check set by lightly pushing the handle until the spring-loaded pins in the clamping assembly push the blade against the back plate. Read the dial indicator. Adjust set as necessary (see above). Check every third tooth until you reach the weld.

2. **Set the opposite side of blade.** Remove the blade and invert it. Put the blade back in the toothsetter with the teeth pointing to the left. Repeat the above steps to set the teeth using the left side index pawl assembly. The amount that you must bend the teeth to end up with the same set as the first side of the blade probably will differ.
3. **Remove the blade.** Take the blade out of the toothsetter. Be sure the blade is turned to the correct side before putting it on the sawmill.

3.5 Toothsetter Maintenance

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

SECTION 4 REPLACEMENT PARTS

4.1 How To Use The Parts List

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

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

4.2 Sample Assembly				
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	Sample Assembly, Complete (Includes All Indented Parts Below)	A01111	1	
4	Sample Part	F02222-22	1	
	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
5	Sample Part (◆ Indicates Part Is Only Available With A03333)	S04444-4	1	◆
	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
6	Sample Part (◆ Indicates Part Is Only Available With K05555)	M06666	2	◆
7	Sample Part	F07777-77	1	

To Order Parts:

- From Europe call our European Headquarters and Manufacturing Facility in Kolo, Poland at **+48-63-2626047**. From other international locations, contact the Timbery distributor in your area for parts.

4 Replacement Parts

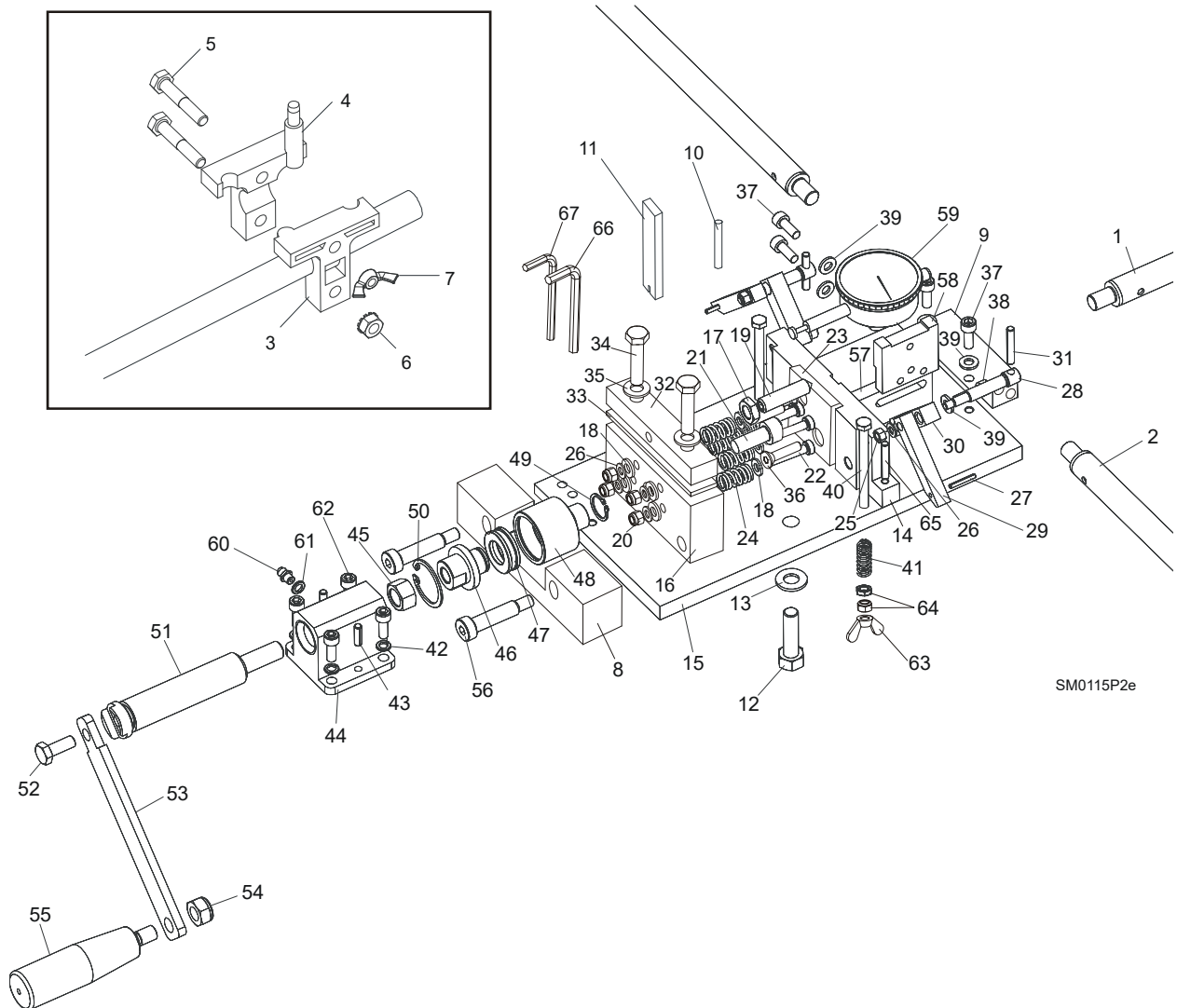
4.3 Toothsetter, Complete

4.3 Toothsetter, Complete



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART NUMBER	QTY.	
	Toothsetter, Complete	BMT100 / BT100		
	Toothsetter, Complete	087557	1	
1	Toothsetter Assembly, Boxed, w/o Stand & Arms	087765	1	
2	Arm Assembly, Blade Support	087766	1	
3	Stand Assembly, Toothsetter	087767	1	

4.4 Toothsetter Parts List



SM0115P2e

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART NUMBER	QTY.
	Arm Assembly, Blade Support	087766	1
	Blade Support Assembly, Replacement	A10617	1
1	Tube, Blade Support Long	087519-1	1
2	Tube, Blade Support Short	087670-1	2
3	Guide WO/Post, Blade Support	S10612	3
4	Guide W/Post, Blade Support	S10611	3
5	Bolt, 1/4-20 X 1 1/2" Hex Head Grade 2	F05005-5	6
6	Nut, 1/4-20 Self-Locking	F05010-9	3
7	Nut, 1/4-20 Wing	F05010-13	3
	TOOTHSETTER ASSEMBLY, BOXED	087765	1
	TOOTHSETTER ASSEMBLY	087502	1
8	Bracket, moving clamp	096863-1	1
9	Bracket, Blade Support Tube	092914-1	1

4

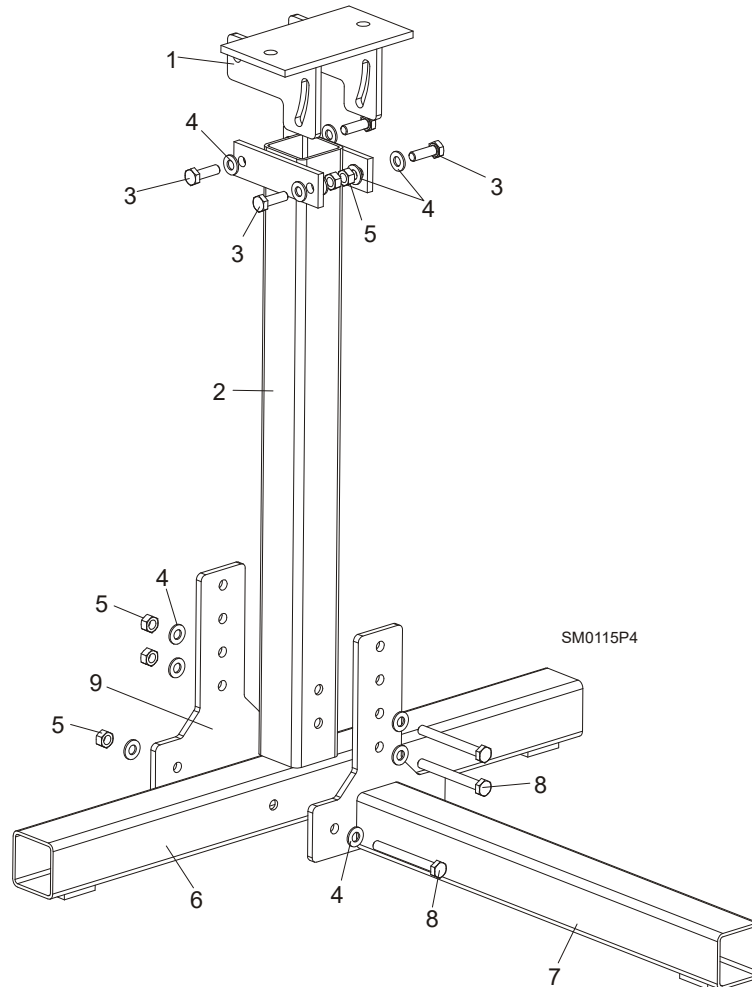
Replacement Parts

Toothsetter Parts List

10	Pin, Toothsetter Alignment	F05012-60	1	
11	Tool, Set Correction	087862-1	1	
12	Bolt, M10 x 35 8.8 Hex Head Full Thread Zinc	F81003-17	2	
13	Washer, 10.5 Flat Zinc	F81055-1	4	
14	Plate, Toothsetter Fixed Clamp Zinc	087503-1	1	
15	Base Weldment	087504-1	1	
16	Plate, Moving Clamp	096862-1	1	
17	Nut, M8 Hexagon, Grade 5.8 Free Zinc	F81032-1	1	
18	Washer, 6.4 Flat Zinc	F81053-1	8	
19	Screw, M8x40-45H Hex Socket Head	F81002-52	1	
20	Nut, M5-8 DIN985 Zinc	F81030-2	2	
21	Screw, M10 x 25 8.8 Hex Socket Head Cap	F81003-32	1	
22	Bolt, 6/M5x25 12.9 ISO7379 Shoulder	F81001-19	4	
23	Plate, Clamp Wear	087463	1	
24	Spring, 1/2" x 1" Red Die	004750	4	
25	Nut, M5-8 Hex Zinc	F81030-1	2	
26	Washer, 5.3 Flat	F81052-1	6	
27	Pin, 3 x 20 Roll Zinc	F81044-5	2	
	Bolt, Complete Special	087513	2	
28	Shaft, Pawl Adjustment	087512-1	2	
29	Block, Pawl Adjustment	087509-1	2	
30	Pawl, Index	087510-1	2	
31	Pin, 5 x 26 Roll Zinc	F81044-2	2	
32	Block, Moving Blade Clamp Upper Zinc-plated	092912-1	1	
33	Washer, Zinc-plated Spacer "10.30" Profile Washer, Zinc-plated Spacer "13.29" Profile	094312 094313	1 1	
34	Bolt, M8x35 -8.8 Hex Head Full Thread Zinc	F81002-13	2	
35	Washer, 8.4 Flat Zinc	F81054-1	2	
36	Screw, M6x20-10.9 Fe/Zn5 DIN-7991	F81001-17	2	
37	Screw, M6 x 16 8.8 Hex Socket Head Cap Zinc	F81001-21	2	
38	Screw, M6 x 20 8.8 Hex Socket Head Cap Zinc	F81001-22	6	
39	Washer, 6.4 Flat Zinc	F81053-1	4	
40	Bolt, M6x80-8.8 Hex Head Full Thread Zinc	F81001-61	2	
41	Spring, LC-045E-12	P04734	2	
	Clamp Assembly, Toothsetter	087438		
42	Washer, Z 6.1 Split lock Zinc	F81053-3	4	
43	Pin, 5 x 16 Roll Zinc	F81044-3	2	
44	Bushing, Toothsetter	087442-1	1	
45	Nut, M12 x 1.25-8 Hex Zinc	F81034-8	1	
46	Bushing, Zinc Toothsetter	087440-1	1	
47	Bearing, 51103 FLT Thrust Ball	086675	1	
48	Housing, Toothsetter Bearing	087439-1	1	
49	Ring, 17 Interior Retaining	F81090-21	1	
50	Ring, 32W Interior Retaining	F81090-5	1	
51	Bolt, Threaded Push Pull	087441-1	1	
52	Bolt, M8x20-5.8 Hex Head Full Thread Zinc	F81002-1	1	
	Handle Assembly, Toothsetter Clamp			

53	Bar, Toothsetter Grip	087443-1	1	
54	Nut, M10-8-B Hex Nylon Zinc Lock	F81033-1	1	
55	Grip, Toothsetter Hand	086338	1	
56	Bolt, 10/M8 x 40 12.9 ISO7379 Shoulder	F81003-83	2	
57	Block, Lower Toothsetter Gauge Mount	087515-1	1	
58	Block, Upper Toothsetter Gauge Mount	087516-1	1	
59	Gauge Dial, Indicator	087843	1	
60	Fitting, M6 Grease	086280	1	
61	Washer, Z 6.1 Spli Lock Zinc	F81053-3	1	
62	Screw, M6 x 16 8.8 Hex Socket Head Cap Zinc	F81001-21	4	
63	Nut, M6 Wing Zinc	F81032-3	2	
64	Nut, M6-8-B Hex Nylon Zinc Lock	F81031-2	2	
65	Pin, 5x26 Roll Zinc	F81044-2	2	
66	Wrench, 5mm Hex	092915	1	
67	Wrench, 4mm Hex Zinc-plated	093368	1	
	Tool, Set Correction, Zinc-plated	087862-1	1	
	Wrench, 13MM Open Ended/Box Zinc-plated	093369	1	

4.5 Toothsetter Stand Assembly



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART NUMBER	QTY.
	TOOTHSETTER STAND ASSEMBLY, COMPLETE	087767	1
	Toothsetter Stand Assembly	087555	1
1	Base Weldment, Toothsetter	087534-1	1
2	Leg Weldment, Base	087535-1	1
3	Bolt, M8 x 25-8.8-B Hex Head Full Thread Zinc	F81002-5	4
4	Washer, 8.4 Flat Zinc	F81054-1	16
5	Nut, M8-8-B Hex Zinc	F81032-1	8
6	Stand Weldment, Toothsetter Long	087507-1	1
7	Stand Weldment, Toothsetter Short	087554-1	1
8	Bolt, M8 x 75 8.8 Hex Head Zinc	F81002-91	4
9	Mounting Plate Toothsetter Stand	087694-1	1
10	Bolt, M10X35-8.8 Hex Head Full Thread Zinc	F81003-17	2
11	Nut, M10-8-B Hex Nylon Zinc Lock	F81033-1	2
12	Washer, 10.5 Flat Zinc	F81055-1	4

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

Manufacturer:

Timberly Sp. z o.o.
112 Nagórna; 62-600 Koło, Poland

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: **TOOTHSETTER**

Type: BT100

No. of manufacturer:

Is in conformity with the following EC directives: EC Machinery Directive 2006/42/EC

And is in conformity with the following Harmonized Standards: PN-EN ISO 12100:2012

Responsible for Technical Documentation: Radosław Adamkiewicz / Product Manager
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Place / Date / Authorized Signature: Koło, 01.03.2018 *Radosław Adamkiewicz*

Title: Product Manager