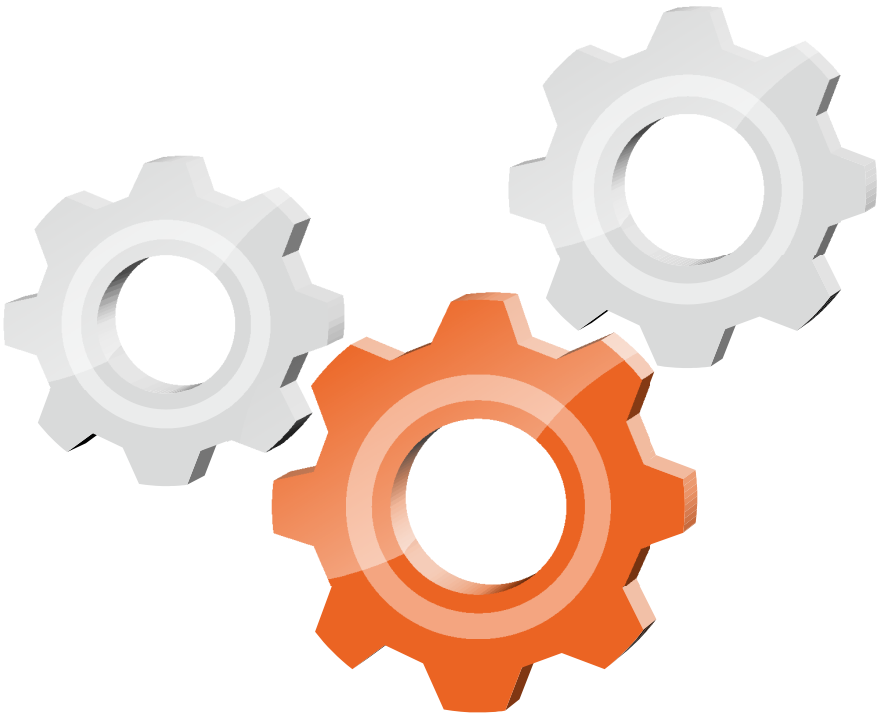
Wood-Mizer®

from forest to final form



user manual

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

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

www.wood-mizer.eu

Wood-Mizer®

Safety, Installation, Operation and Maintenance

LT15WA E15	**rev. A1.00**
LT15WA G25	**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 #2535

Table of Contents Section-Page

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

SECTION 1 LT15WA SAFETY INSTRUCTIONS

1.1 Safety Symbols

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

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

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

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

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

Before operating the LT15WA sawmill, read the operator's manual and all additional manuals provided with the machine. Observe all safety instructions included in these manuals!

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

IMPORTANT! It is always owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership, operation and transport of your LT15WA sawmill. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the sawmill.

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

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

- Blade Handling,
- Sawmill Setup,
- Sawmill Operation,
- Sawmill Maintenance.

1.2 Blade Handling

DANGER! Always disengage the blade and shut off the sawmill motor before changing the blade. Failure to do so will result in serious injury.

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

1.3 Sawmill Setup

WARNING! Do not set up the sawmill on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the sawmill or dig out areas for the legs to keep the machine level. Setting up the sawmill on an incline could cause it to tip over, resulting in serious personal injury.

WARNING! Keep all persons away from area while loading and unloading the sawmill. Failure to do so may result in serious injury or death.

1.4 Sawmill Operation

IMPORTANT! The sawmill is intended for sawing wood only. *See Section Cutting Capacity* **for log size capacities of the machine.**

IMPORTANT! The operator of the sawmill should get adequate training in the operation and adjustment of the machine.

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

DANGER! Be sure the blade housing is in place and secured.

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

DANGER! Keep all persons out of the path of moving equipment and logs when operating the sawmill and/or loading and turning logs. Failure to do so may result in serious injury.

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

DANGER! Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine or motor. Failure to do so may result in serious injury.

WARNING! Always wear eye, ear, respiration and foot protection as well as safety clothing when operating or servicing the machine. Failure to do so may result in serious injury.

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

WARNING! Always make sure the log is clamped securely (against the side supports) before sawing. Failure to do so may result in serious injury or death.

WARNING! Use ONLY water or alcohol solution with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so may result in serious injury or death.

CAUTION! Be sure the log clamps are all the way down before loading a log onto the bed. Failure to do so may result in machine damage.

CAUTION! Before loading a log, be sure the cutting head is moved far enough forward so the log does not hit it. Failure to do so may result in machine damage.

CAUTION! Do not try to force the saw head beyond its upper and lower travel limits. Damage to the up/down system may result.

CAUTION! Be sure to stop the blade before returning the saw head. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

CAUTION! If optional loading ramps are used to load a log onto the sawmill bed, remove them from the brackets on the bed frame before sawing. The saw head may hit the ramp stops when adjusted for low cuts and get damaged.

CAUTION! Never clean the blade or blade wheels with a brush or a scraper during sawmill operation.

CAUTION! Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.

CAUTION! The blade should be replaced every two hours of sawmill operation.

CAUTION! Always wear gloves when handling the blade. Never grab the blade with bare hands!

CAUTION! If the blade breaks during sawmill operation, push the EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing covers.

CAUTION! The sawmill's work-stand should be equipped with a 4 kg or bigger dry powder extinguisher.

1.5 Sawmill Maintenance

CAUTION! The up/down screw bellows should completely cover the screw. If either of the bellows is damaged, replace it immediately. Before installing the new bellows, clean the up/down screw and nut thoroughly with extraction naphtha and then grease them.

CAUTION! Reinstall the track wiper so that it lightly touches the track bar. If the wiper presses too firmly against the rail, it can cause the forward/reverse movement to bind.

CAUTION! Never use grease on the mast track as it will collect sawdust.

1.6 Safety Instructions

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

Observe Safety Instructions

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

Also read all additional manuals that you received with the machine (such as: motor manual, optional equipment manuals) and observe safety instructions included in these manuals.

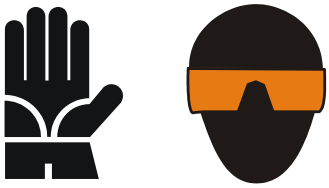
IMPORTANT! Only adult persons who have read and understood the entire operator's manual should operate the sawmill. The sawmill is not intended for use by or around children.

IMPORTANT! It is always owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer sawmill. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the sawmill. All Wood-Mizer sawmill owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.

Wear Safety Clothing

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

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



WARNING! Always wear eye, ear, respiration and foot protection as well as safety clothing when operating or servicing the sawmill.

Keep Sawmill and Area Around Sawmill Clean

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

Dispose of Sawing By-Products Properly

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

Check Sawmill Before Operation

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

Keep Persons Away

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

DANGER! Always be sure all persons are out of the path of the blade before starting the motor. Failure to do so will result in serious injury.

WARNING! Allow blade to come to a complete stop before opening the blade housing cover. Failure to do so will result in serious injury.

Keep Hands Away

DANGER! Always shut off the blade motor before changing the blade. Failure to do so may result in serious injury.

DANGER! Engine components can become very hot during operation. Avoid contact with any part of a hot engine. Contact with hot engine components can cause serious burns. Therefore, never touch or perform service functions on a hot engine. Allow the engine to cool sufficiently before beginning any service function.

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

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

WARNING! Use extreme caution when spinning the blade wheels by hand. Make sure your hands are clear of the blade and wheel spokes before spinning. Failure to do so may result in serious injury.

Use Proper Maintenance Procedures

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

DANGER! Hazardous voltage inside the electric disconnect box, starter box, and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during sawmill operation.

WARNING! Consider all electrical circuits energized and dangerous.

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

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

WARNING! Remove the blade before performing any service to the motor or sawmill. Failure to do so may result in serious injury.

DANGER! Never clean the blade or blade wheels with a brush or a scraper during sawmill operation.

CAUTION! Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.

Keep Safety Labels In Good Condition

IMPORTANT! Always be sure that all safety decals placed on the machine are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Jeśli zatem nalepka jest uszkodzona, to należy natychmiast wymienić ją na nową. Contact your local distributor, or call your Customer Service Representative to order more decals.

IMPORTANT! When replacing any component having a safety decal affixed, be sure to place an identical safety decal on the new component.

See table 1-1. See the table below for descriptions of the pictographic warning and informational decals placed on the LT15WA Series sawmills.

TABLE 1-1

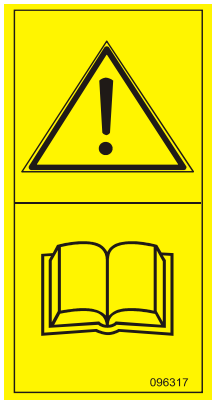
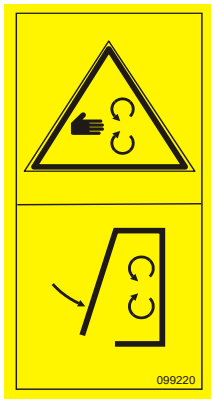
Decal View	Decal No.	Description
	096317	CAUTION! Read thoroughly the operator's manual before operating the sawmill. Observe all safety instructions and rules when operating the machine.
	099220	CAUTION! Close all guards and covers before starting the machine.

TABLE 1-1

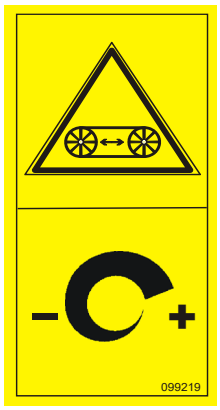
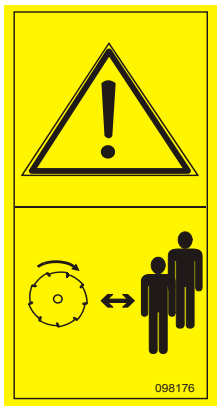
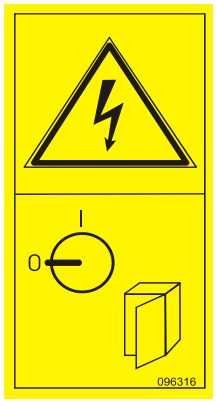
	099219	Blade tension. Turning the bolt clockwise will increase the blade tension, and turning the bolt counterclockwise will decrease the tension.
	099221	CAUTION! Keep all persons away from the machine during sawmill operation.
	098176	CAUTION! Keep away from the debarker blade!
	096316	CAUTION! Do not open or close the electric box when the switch is not in the ”0” position.

TABLE 1-1

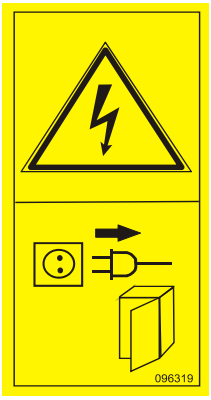
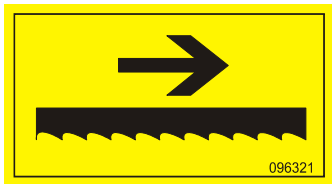
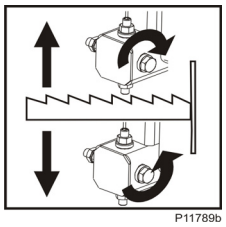
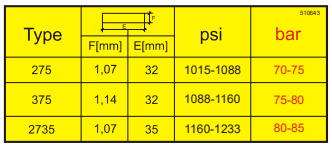
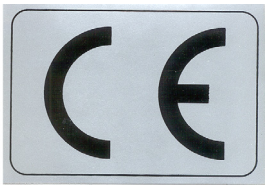
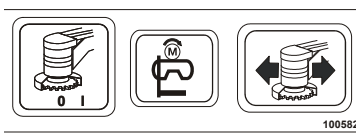
	096319	CAUTION! Disconnect power supply before opening the box.
	096321	Blade movement direction
	S12004G	CAUTION! Always wear safety goggles when operating the sawmill!
	S12005G	CAUTION! Always wear protective ear muffs when operating the sawmill!
	501465	CAUTION! Always wear safety boots when operating the sawmill!

TABLE 1-1

	501467	Lubrication point
 P11789b	P11789	Tracking the blade on the blade wheels
	510643	Setting the blade tension indicator
	P85070	CE certification marking
	099401	Russian safety certification
	S20097F	2925 r.p.m. - motor revolutions direction
a b c 	100582	a. Debarker On/Off (option) B. Starting motor c. Debarker In/Out (option)

1.7 Belt Sizes

See table 1-2. Belt sizes for the LT15WA sawmill are shown below.

Description	Belt Size	PART #
Motor Drive Belt E15	2BX81	014819-2
Blade Pulley Belts	B57 [1]	P04185-3

TABLE 1-2

[1] To insure proper blade tracking, use Goodyear, Dayco Super II, or Browning belts only.

1.8 Blade Sizes

The motor size of your sawmill and the type of wood you saw should determine which blade you choose for optimum performance.

See the ***Blade Handbook*** for blade hook angle, tooth height and tooth set specifications.

The LT15WA sawmill can be equipped with a 35 mm or 38 mm wide blade. LT15WA sawmill is equipped with a blade with a length of 4.47 m.

1.9 Cutting Capacity

See table 1-3. The log size capacities of the LT15WA sawmill are listed below.

	Maximum Log Diameter	Maximum Length [1]
LT15WA S2	90 cm	3.5 m
LT15WA S3	90 cm	5.4 m
LT15WA S4	90 cm	7.3 m
LT15WA M2	90 cm	5.2 m
LT15WA M3	90 cm	7.9 m
LT15WA M4	90 cm	10.6 m

TABLE 1-3

[1] Each additional bed frame segment adds approximately 195 cm to length capacity.

See table 1-4. The performance capacity of the LT15WA sawmill is listed below.

Sawmill Model	Cutting Rate
LT15WA E15	3.3 m/min.

TABLE 1-4

1.10 Engine/Motor Specifications

See table 1-5. See the table below for specifications of the engine used on the LT15WA AC sawmills.

Engine/Motor Type	Manufacturer	Model Number	Other Data
Electric Motor 11 kW	Indukta, Poland	PSg-132S-2_H132	3 x 400V, 50 Hz

TABLE 1-5

See table 1-6. Specifications of power supply for the LT15WA SAWMILL

3-Phase Volts	Circuit Breaker	Recommended Wire Size
400 VAC	32 A	4 mm^2 Maximum length: 15 m

TABLE 1-6

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

1.11 Sawdust Exhaust System Specifications

See table 1-7. The specifications of sawdust exhaust system that should be used with the sawmill are listed below[1].

Maximum Capacity	1200 m^3/h
Collector Inlet Diameters (in front of fan)	100 mm
Electric Motor Horsepower:	1,5 kW
Number of Sacks for Waste	1 pcs
Total Capacity of Sacks	0.25 m^3
Pressure drop	1,5 kPa (0.22 psi) [1]
Weight	110 kg
Conveying Speed When 10 m Long Hose Is Used	20 m/s

TABLE 1-7

[1] The pressure drop between the inlet of the capture device and the connection to the CADES should not exceed 1.5 kPa (for the nominal air flow rate). If the pressure drop exceeds 1.5 kPa the machine might not be compatible withconventional CADES.

IMPORTANT! The sawdust extractor hoses must be grounded or made with materials not accumulating electrostatic charge.

CAUTION! Always turn on the dust extractor before starting the machine.

1. External chip and dust extraction equipment with fixed installations are dealt with in EN12779:2016-04.

IMPORTANT! The total value of hand-arm vibration the operator may be exposed to does not exceed 2.5 m/s^2. The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0.5 m/s^2.

1.12 Overall Dimensions

See Figure 1-1. The overall dimensions of the LT15WA sawmill are shown below.

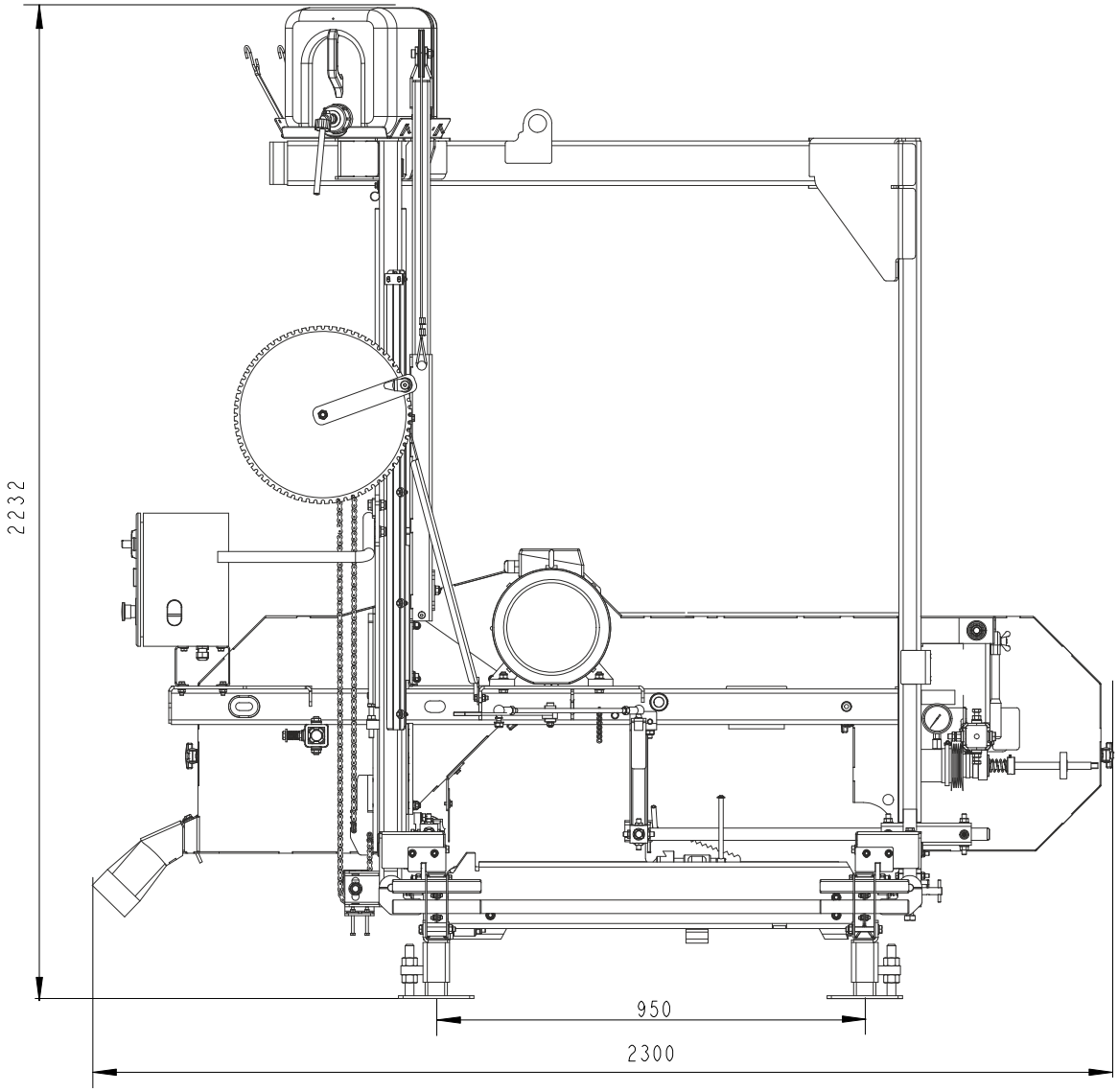


FIG. 1-1

See Figure 1-2. The overall dimensions of the LT15WA sawmills with M type frames are shown below.

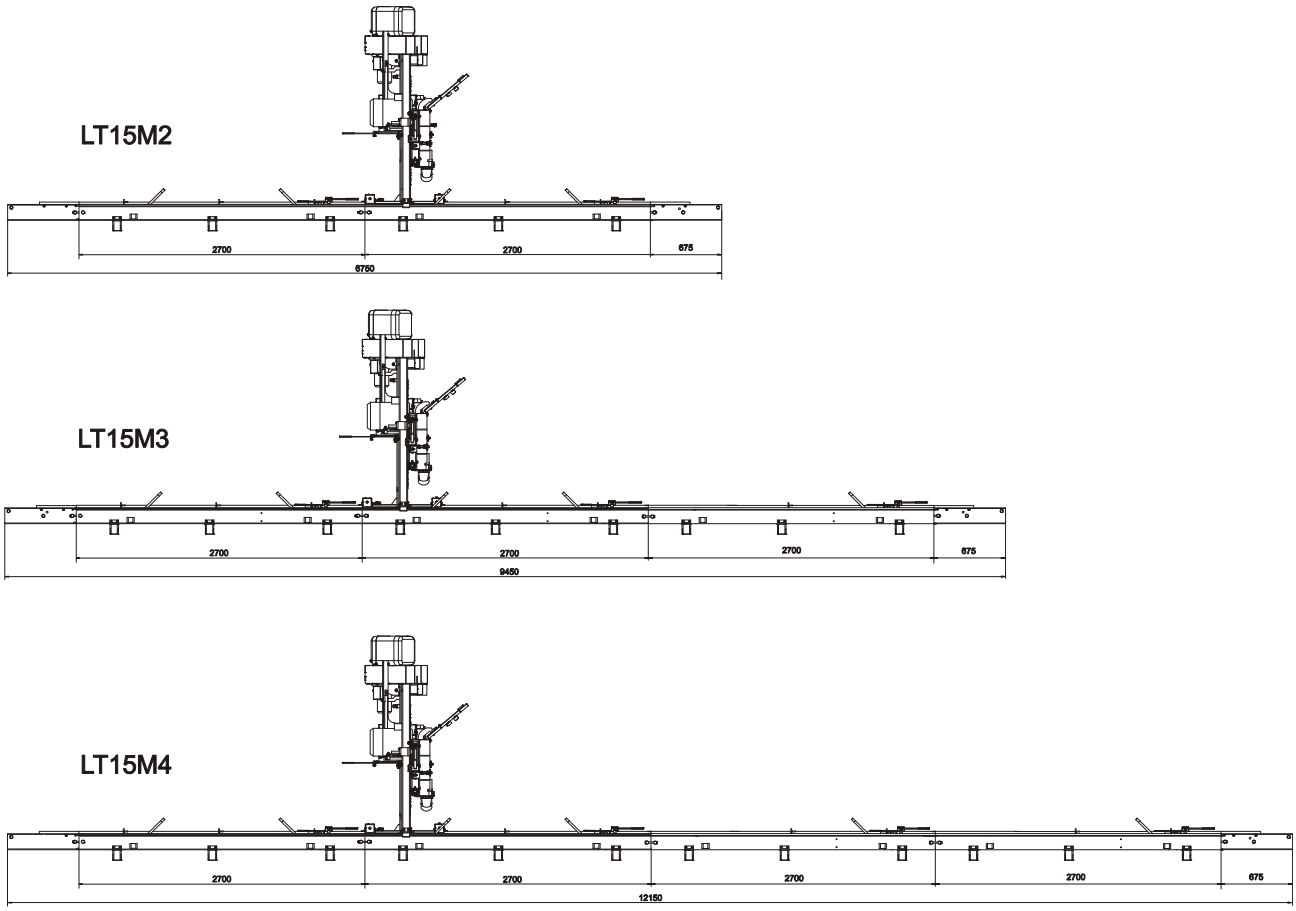


FIG. 1-2

See Figure 1-3. The overall dimensions of the LT15WA sawmills with S type frames are shown below.

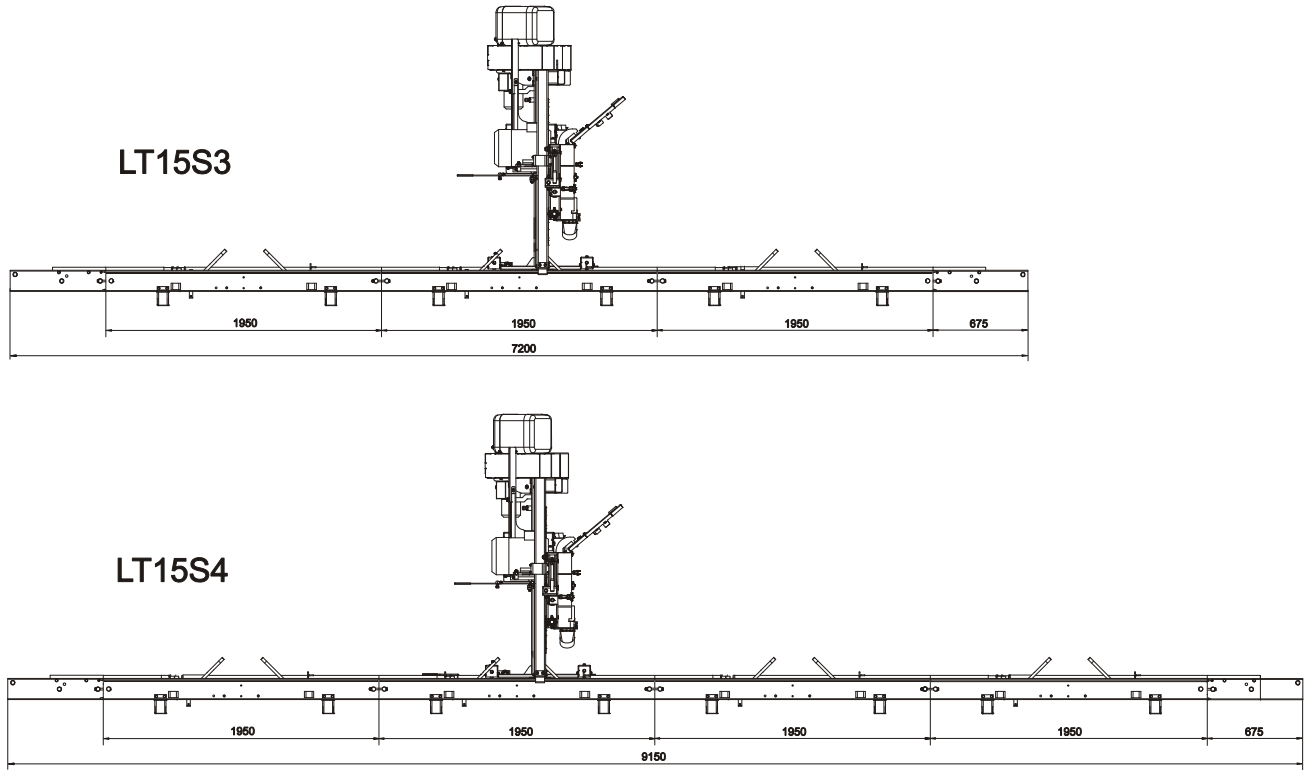


FIG. 1-3

See Figure 1-4. The legs layout of the LT15WA sawmills with S type frames is shown below.

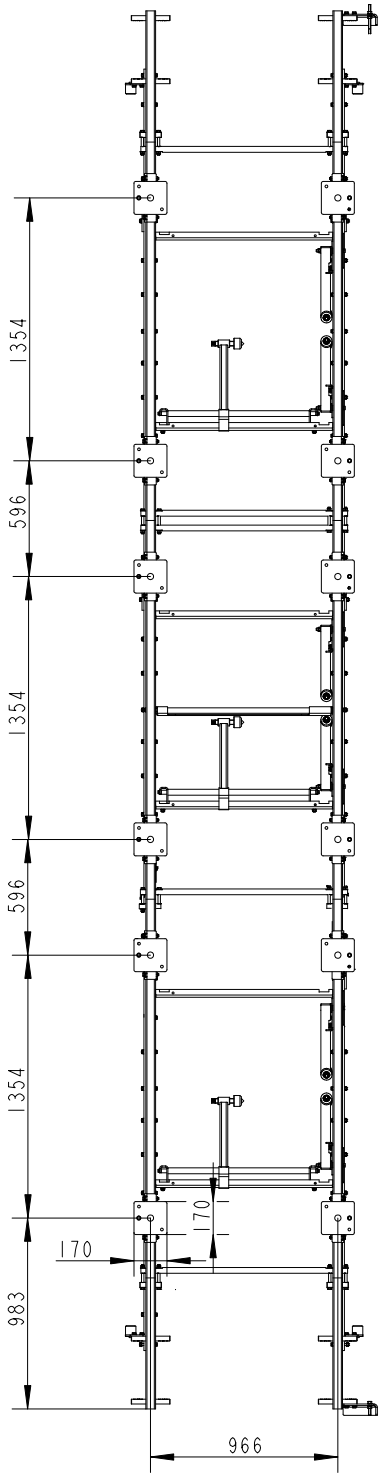


FIG. 1-4

See Figure 1-5. See the figure below for the operator's work-place.

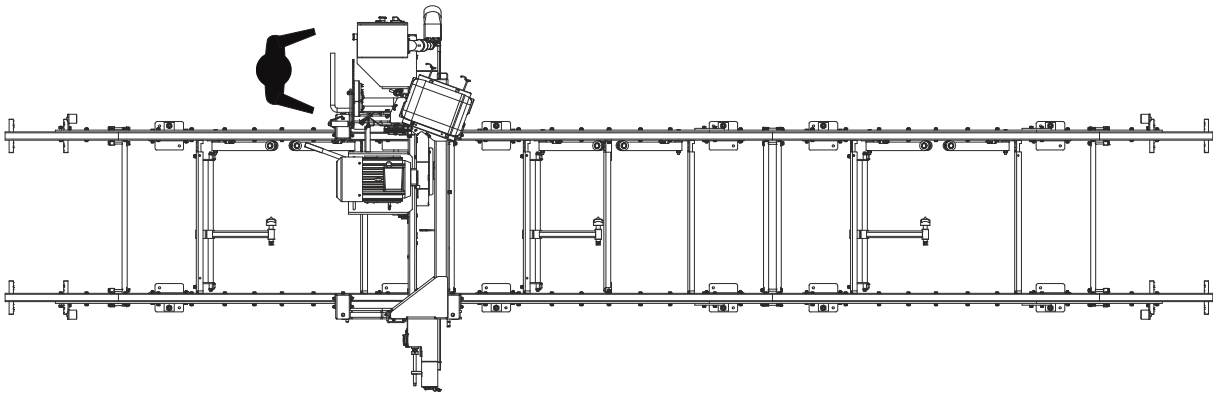


FIG. 1-5

1.13 Components

The major components of the LT15WA sawmill are shown below.

See Figure 1-6.

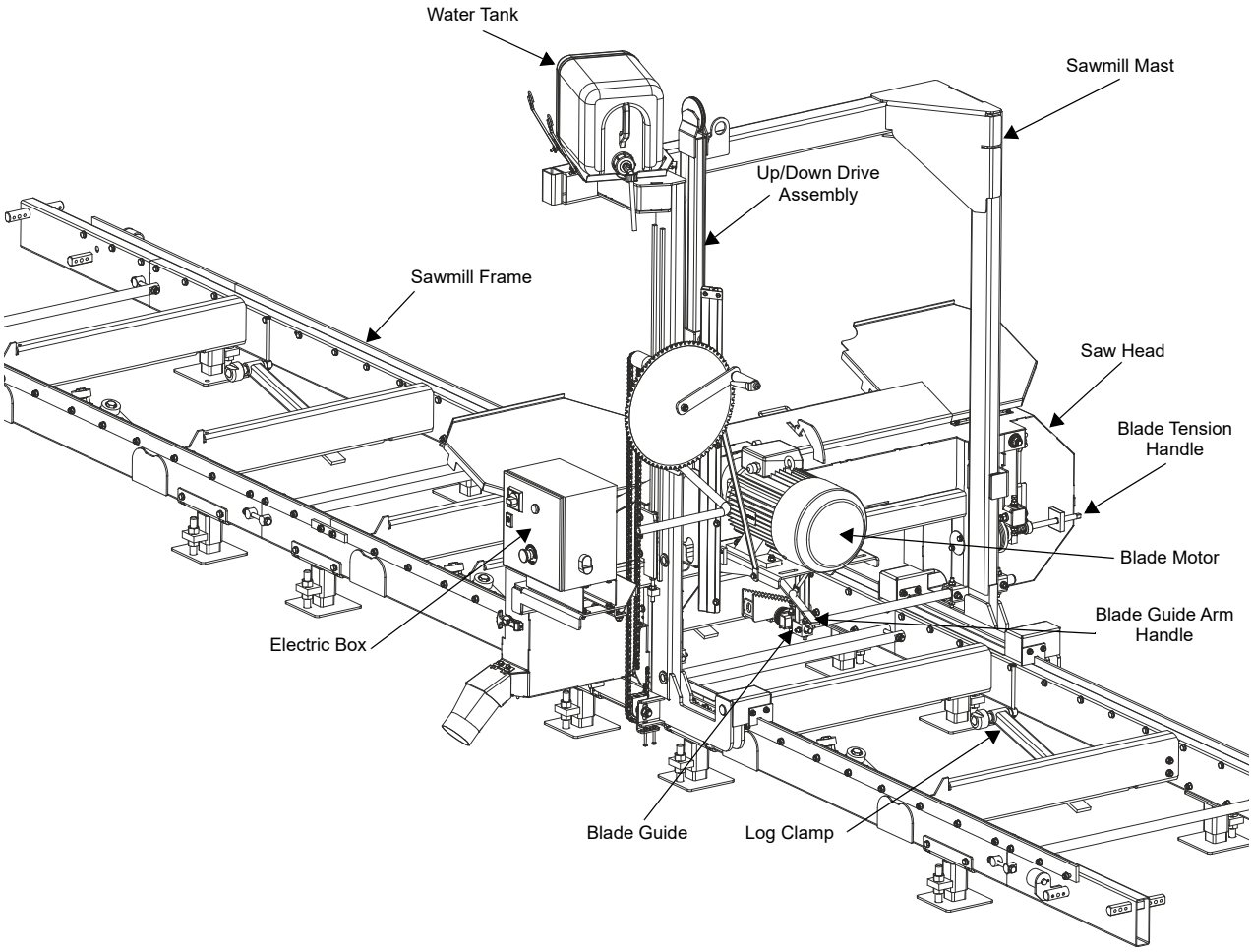


FIG. 1-6

SECTION 2 SAWMILL ASSEMBLY LT15WA

Scan to see the assembly video.

2.1 Mounting Parts of LT15WA Sawmills with Electric Motors

2.1.1 Parts specifications

Table 1:

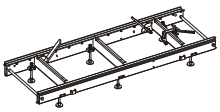
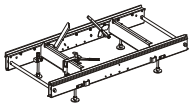
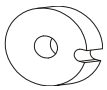
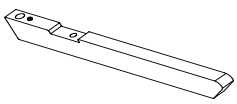
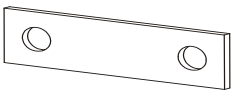
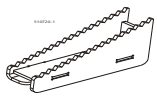
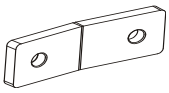
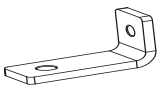
Fig.	Wood-Mizer No.	Description	Qty. LT15 M3	Qty. LT15 S2	QTY LT15 S3	QTY LT15 S4
					LT15 S3	**LT15 S4**
	550830-AC	LT15 Saw-mill Saw Head	**1**	**1**	**1**	**1**
	094697	LT15 Bed Section, Complete (2.75 m)	**3**	**--**	**--**	**--**
	094514	LT15 Bed Section, Complete (1.95 m)	**--**	**2**	**3**	**4**
	085981-1	Thick Spacer Washer	**6**	**4**	**6**	**8**
	085982-1	Log Side Support, Complete	**6**	**4**	**6**	**8**
	085994-1	Bed Leg Mounting Washer, Painted	**18**	**8**	**12**	**16**
	086035-1	Leveling Wedge, Painted	**1**	**1**	**1**	**1**
	086171-1	Side Bracket	**2**	**2**	**2**	**2**
	086172-1	Bottom Bracket	**1**	**1**	**1**	**1**

Table 1:

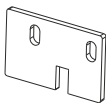
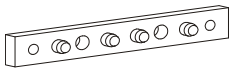
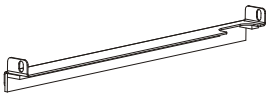
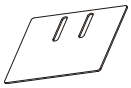
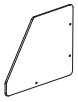
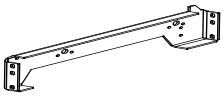
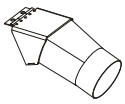
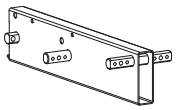
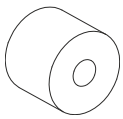
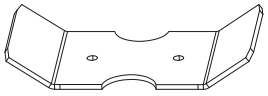
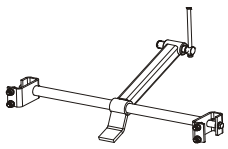
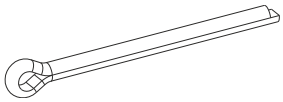
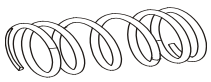
	531670	Track Wiper	**2**	**2**	**2**	**2**
	086659-1	Frame Mounting Strap, Zinc-plated	**4**	**3**	**4**	**6**
	086745	Middle Track Cover with Felt Wiper	**1**	**1**	**1**	**1**
	092378-1	Bracket, Blade Guide Roller Guard	**--**	**--**	**--**	**--**
	092379-1	Blade Guide Roller Guard	**--**	**--**	**--**	**--**
	093859	Plate, PC Guard	**1**	**1**	**1**	**1**
	094250-1	Track Rail, Zinc-plated (Short)	**2**	**2**	**2**	**2**
	095490-1	Auxiliary Bed Rail	**1**	**1**	**1**	**1**
	100903-1	Sawdust Chute	**1**	**1**	**1**	**1**
	500844-1	Bed Exten-sion Tube	**2**	**2**	**2**	**2**
	501414-1	Plate	**4**	**4**	**4**	**4**
	P12165	Bushing, Rubber	**4**	**4**	**4**	**4**
	506287-1	Plate, Bed Section Connector	**12**	**8**	**12**	**16**

Table 1:

	507565	Log Clamp	**3**	**2**	**3**	**4**
	086182-1	Mount Weldment	**4**	**4**	**4**	**4**
	F81043-2	Pin				
	538799-1 (LT15S3) 538935-1 (LT15M2)	Track Rail	**3**	**2**	**3**	**4**
	LTBGAT	Tool, Blade Guide Alignment	**--**	**--**		**--**
Vertical Mast Lock Assembly						
	086743-1	Zinc-plated Pin	**2**	**2**	**2**	**2**
	F81045-1	Roll Pin 6x50	**2**	**2**	**2**	**2**
	F81044-21	Roll Pin 3x20	**2**	**2**	**2**	**2**
	087301	Compres-sion Spring 18x37x1.8	**2**	**2**	**2**	**2**
	F81043-2	Pin, S-Zn-4x25 Cotter	**2**	**2**	**2**	**2**
	F81058-1	Washer, 17	**2**	**2**	**2**	**2**

2.1.2 Specifications of Fasteners

Table 2:

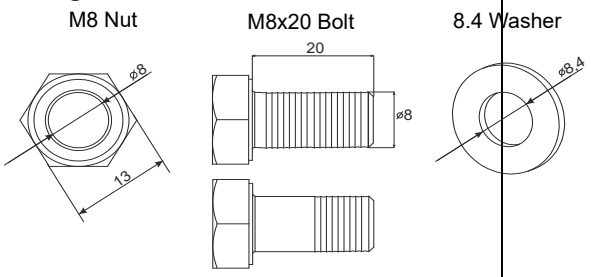
Wood-Mizer No.	Description	Qty. LT15 M3	Qty. LT15 S2	QTY LT15 S3	QTY LT15 S4
				LT15 S3	LT15 S4
Designations of fasteners: 					
014972	Washer, 33/64 x1 3/4" x 1/32 Nylon	6	4	6	8
100076-1	Bolt, M10-20 Special	6	6	6	8
F81000-7	Bolt, M5x25	2	2	2	2
F81001-15	Bolt, M6x16-8.8	12	8	12	16
F81001-7	Bolt, M6x12	--	--	2	--
F81002-20	Bolt, M8x16-8.8-B Hex Head Full Thread Zinc	--	--	2	--
F81002-4	M8x20 Bolt	10	10	10	10
F81002-5	Bolt, M8x25-8.8-B Hex Head Full Thread Zinc	3	3	3	3
F81002-6	Bolt, M8x12	--	--	--	--
F81003-1	Bolt, M10x20-5.8 Hex Head Full Thread Zinc	2	2	2	--
F81003-11	Bolt, M10x25-8.8	8	8	8	12
F81003-15	Bolt, M10x75	47	27	34	43
F81003-2	Bolt, M10x30 5.8	4	4	4	4
F81003-2	Bolt, M10x30 8.8	--	--	--	12
F81003-66	Bolt, M10x90	1	1	1	1
F81004-12	Bolt, M12-55-8.8	--	--	--	--
F81004-35	Bolt, M12x140	6	6	6	8
F81004-36	Bolt, M12x130	--	--	6	--
F81004-38	Bolt, M12x120	12	8	12	16
F81030-2	Nut, M5	2	2	2	2

Table 2:

F81031-2	Nut, M6-8-B	12	8	12	16
F81032-2	M8 Nut	3	3	3	3
F81033-1	Nut, M10 Hex Nylon Lock	82	50	57	75
F81033-3	Nut, M10	6	4	6	8
F81034-2	Nut, M12 Hex Nylon Lock	22	16	20	26
F81053-1	6.4 Washer	--	--	24	--
F81053-11	Washer, 6.5 Special Flat	--	--	6	--
F81054-1	Washer, 8.4	16	16	16	16
F81054-4	Washer, 8.4	--	--	--	--
F81055-1	Washer, 10.5	150	101	101	126
F81055-2	Washer, 10.2 Split Lock	12	12	12	16
F81056-1	Washer, 13	38	30	36	46
F81082-1	Tie wrap	2	2	2	2
Outrigger Leg Kit (Option)					
F81003-58	Bolt, M10x120	36	16	24	32
F81007-1	Bolt, M20x240	18	8	12	16
F81037-1	Nut, M20-8 Hex Zinc	18	8	12	16
F81059-2	Washer, 21	18	8	12	16

2.1.3 Tools Necessary for Assembling the Sawmill

Table 3:

Required tools	
Flat Wrench #8	1 pcs
Flat Wrench #10	2 pcs
Flat Wrench #13	2 pcs
Flat Wrench #17	2 pcs
Flat Wrench #19	2 pcs
Ratchet Wrench #30	1 pcs
Hammer	1 pcs
Allen Wrench #4	1 pcs
Allen Wrench #5	1 pcs

2.2 Unpacking the Sawmill

IMPORTANT! The machine can be lifted using the forklift only. The forklift must be rated for at least 2000kg (4409lb.) and minimum lift forks length must be 2m.

See figure 2-1.

FIG. 2-1

1. Cut the bands holding the components together.
2. Remove the parts arranged inside the bed section.
3. Using a forklift truck or a winch with lifting capacity of minimum 500 kg, carefully lift the saw head and set it aside. Attach the winch hook to the bracket on the saw head.

WARNING! When removing the saw head, use extreme care and keep all persons at a safe distance. Failure to do so may result in serious injury or death.

See figure 2-2.

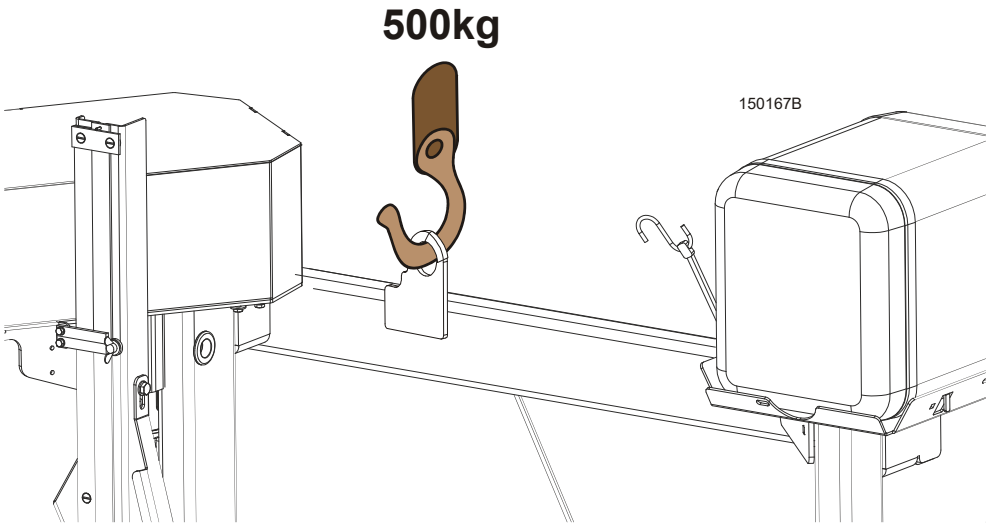


FIG. 2-2

2.3 Bed Frame Assembly

IMPORTANT! With all screw joints without split lock washer or lock nylon nut, use the “LOCTITE 243” (blue), of average durability, for screw joints.

IMPORTANT! Bolt and screw sizes and part numbers are listed in Replacement Parts Manual. Form #791.

1. Mount preliminarily the track rail as shown in Figure 2-3. Do not tighten the nuts.

See figure 2-3.

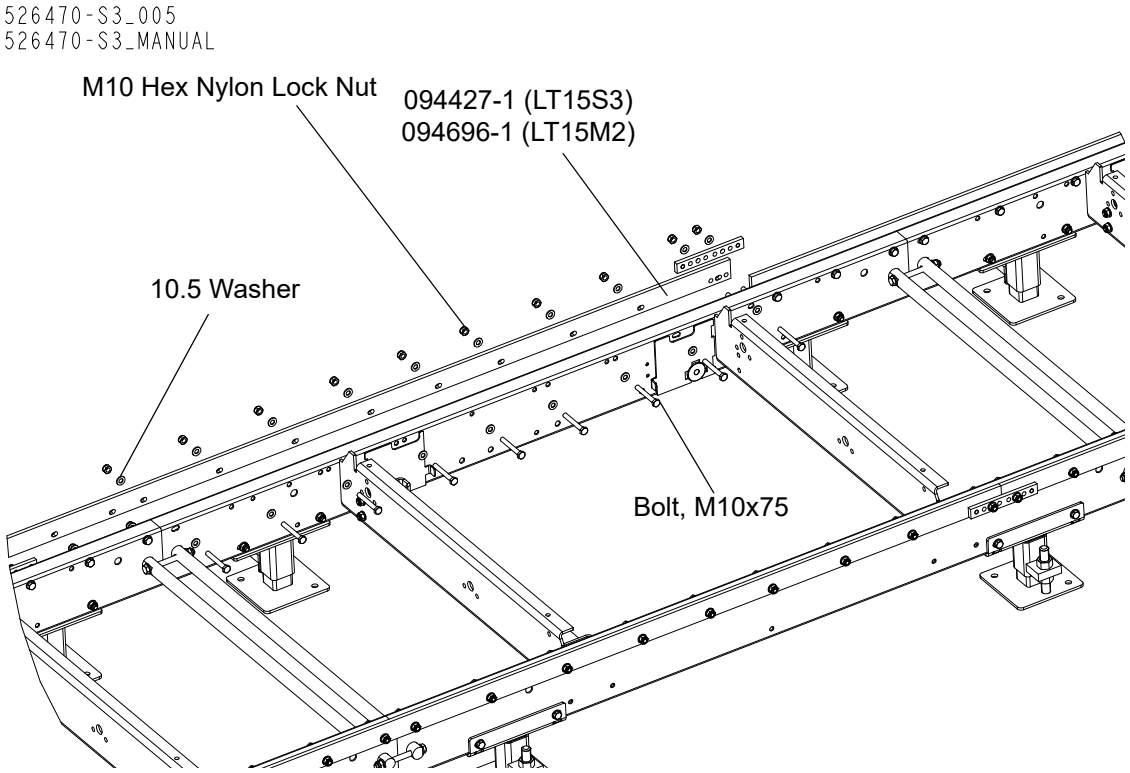


FIG. 2-3

2. Outrigger legs - Mount four (or six) support brackets (A) to each bed section with two M10x75 hexagon head bolts (B) and lock nuts (C). Make sure the nut on the bracket faces up. Thread legs (D) into each bracket and secure them with nuts (E).

See figure 2-4.

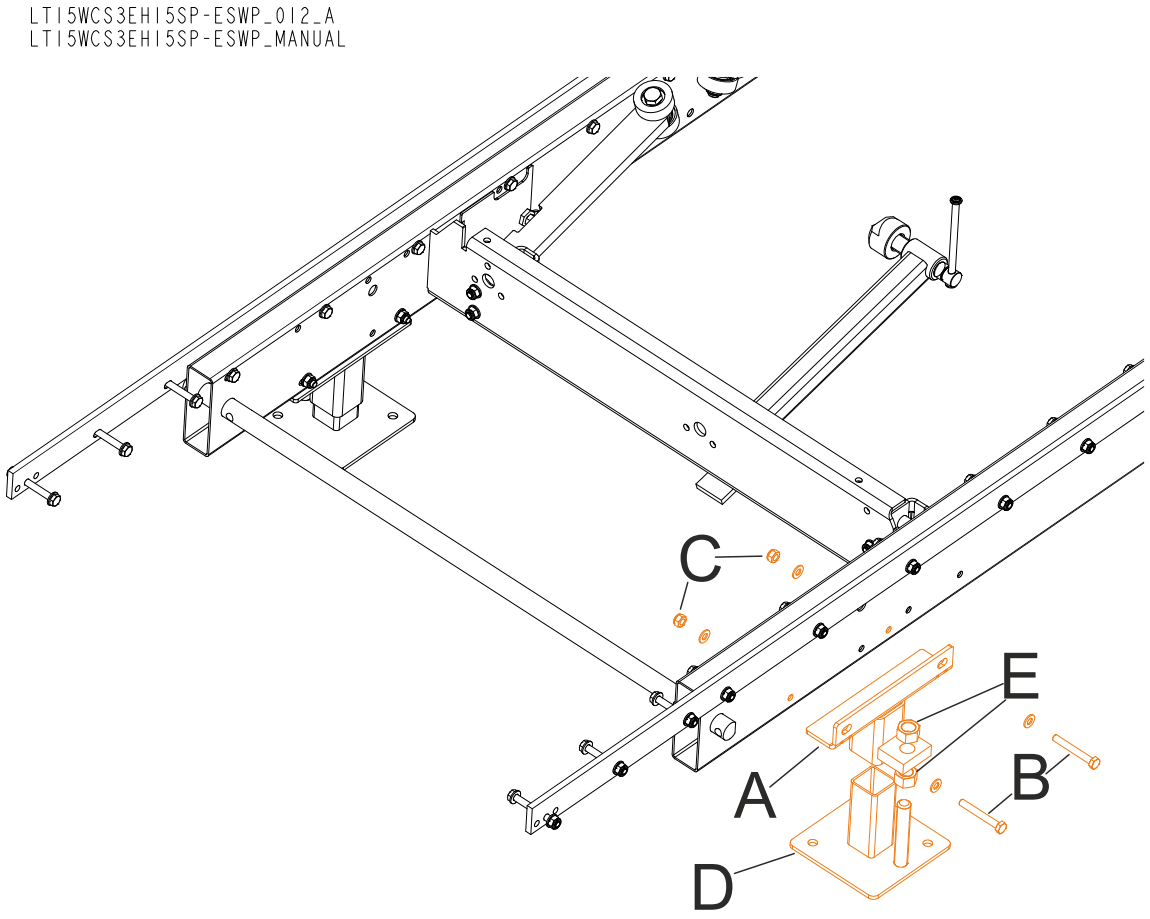


FIG. 2-4

3. Lay the frame sections end-to-end so the track portion of each section is on the same side. Slide the sections together and secure with four hex head bolts and nylon lock nuts.

See figure 2-5.

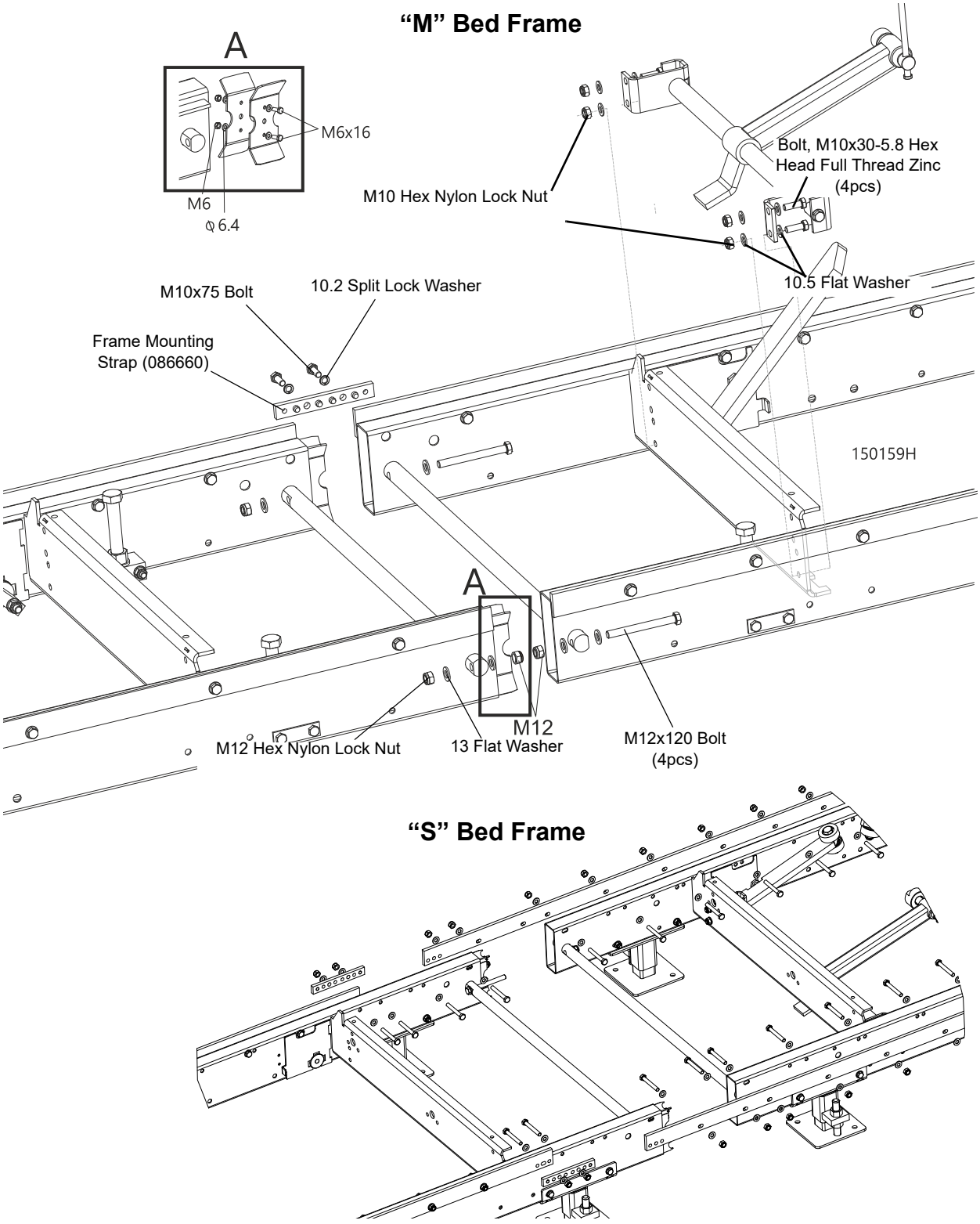


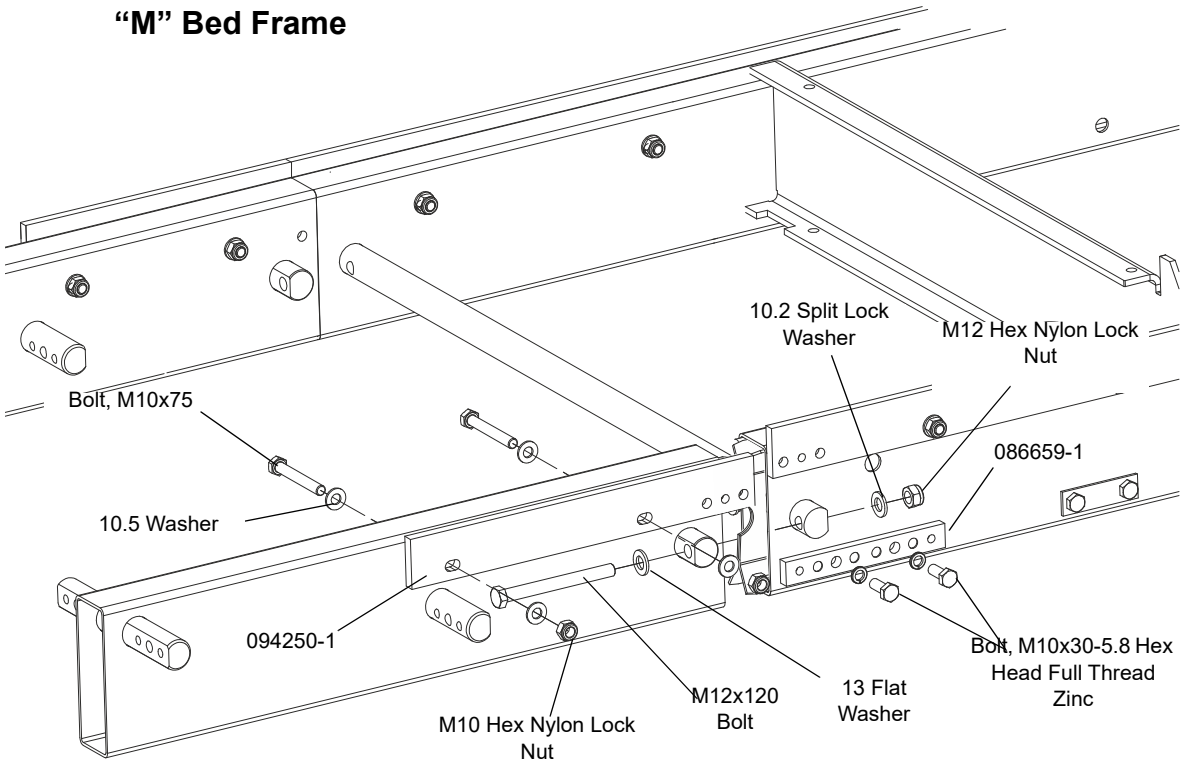
FIG. 2-5

4. Fasten the track rails together using the frame mounting straps, on the outside of the frame (see the figure above). Secure each strap to the track rail with two hex head bolts. Tighten the track rail mounting nuts.

5. Mount a bed extension to the front and the rear ends of the bed frame.

See figure 2-6.

“M” Bed Frame



“S” Bed Frame

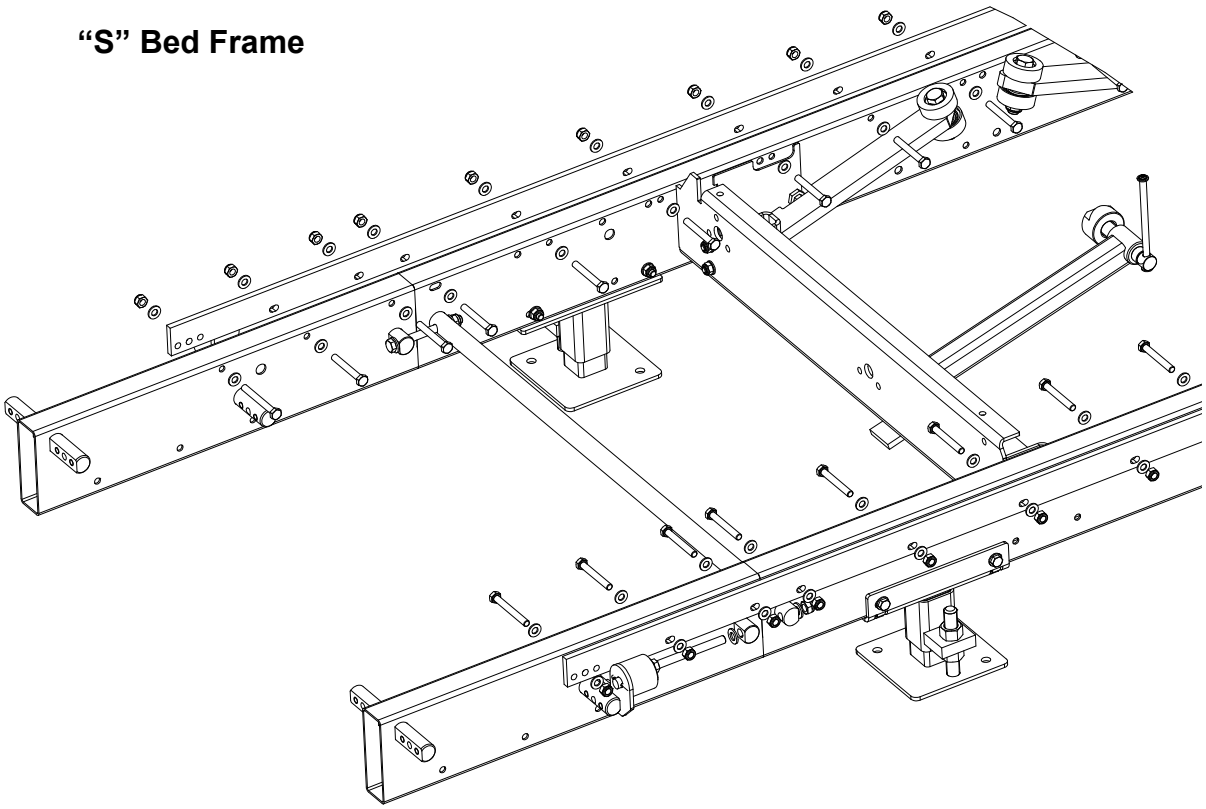


FIG. 2-6

6. Assemble a log clamp to a bed rail on each bed section using the existing hex head bolts and nylon lock nuts.

7. Install the log side supports as shown in Figure 2-7. Tighten the nuts so that the side supports can be moved with little resistance. Adjust side support, *See Section 5.11*.

   See figure 2-7.

LT15WCS3EHI5SP-ESWP_021
LT15WCS3EHI5SP-ESWP_MANUAL

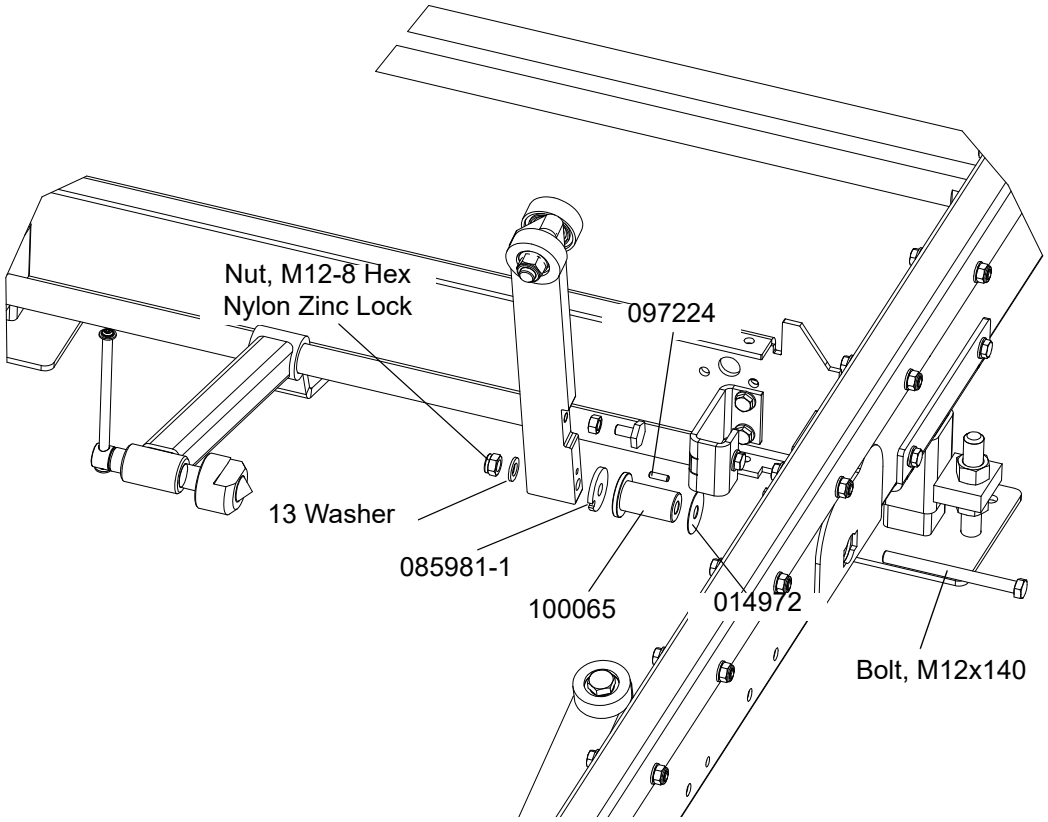


FIG. 2-7

2.3.1 Possibility of sawmill bed and service bed section connection.

1. Possibility of S and M-type sawmill bed (manufactured before 1st of September 2020) and S and M type versatile bed sections connection.

   See figure 2-8.

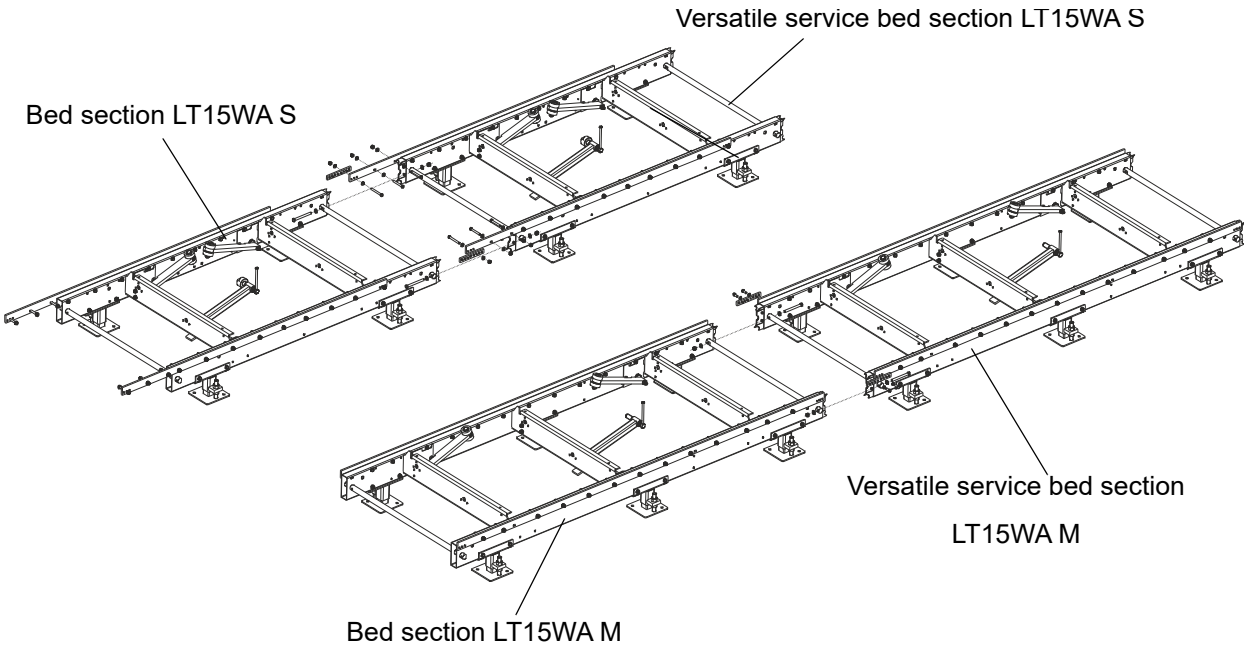


FIG. 2-8

2.4 Saw Head Assembly

1. Position the saw head at the end of the bed frame assembly. Carefully slide the saw head rollers onto the bed frame track. Keep the saw head square to the bed to avoid jamming the track rollers.

WARNING! When setting the saw head on the bed frame, use extreme care and keep all persons at a safe distance. Failure to do so may result in serious injury or death.

CAUTION! When setting the saw head on the bed frame, remove the bolt locking the saw head during transportation.

See figure 2-9.

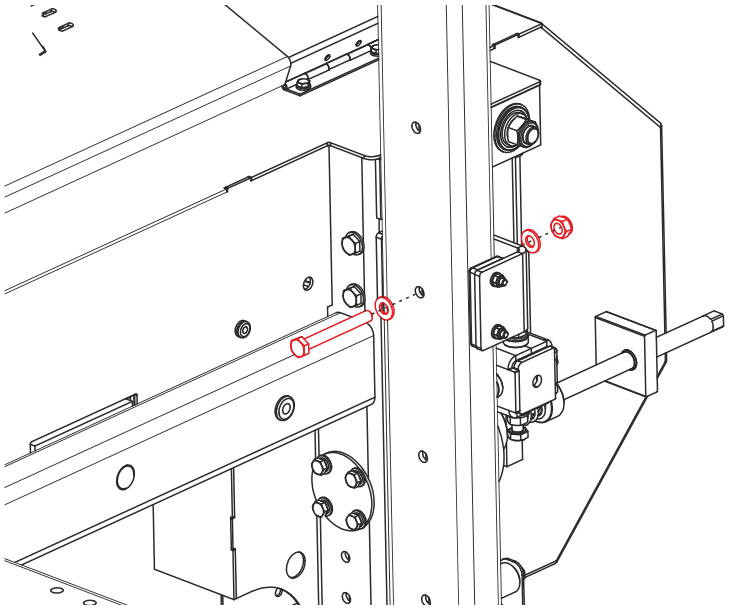


FIG. 2-9

2. Position the middle track cover between the two track roller housings so the opening in the cover is positioned over the feed rope pulleys. Secure with two hex head bolts and lock washers.

3. Install a track wiper with a felt strip to each track roller housing using a 8.4 flat washer and M8x12hex head bolt.

See figure 2-10.

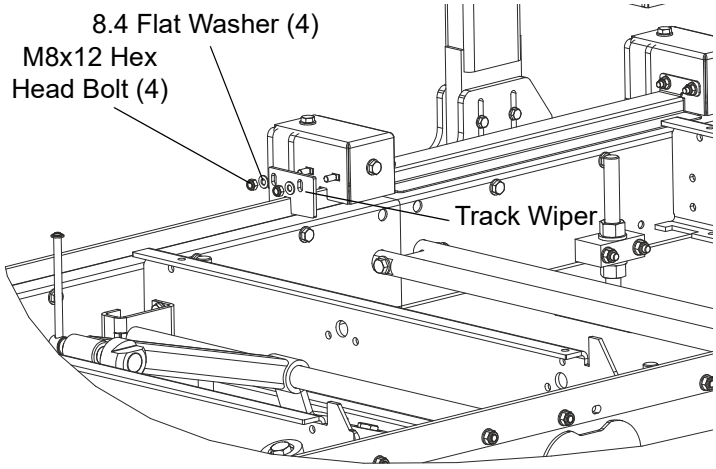


FIG. 2-10

NOTE: Before installing the middle track cover and the remaining felt wipers, soak the felt strips with lubricating fluid (e.g. Mineral Oil).

4. Assemble mast safety pins.

See figure 2-11.

LT15WCS3EH15SP-ESWP_016
LT15WCS3EH15SP-ESWP_MANUAL

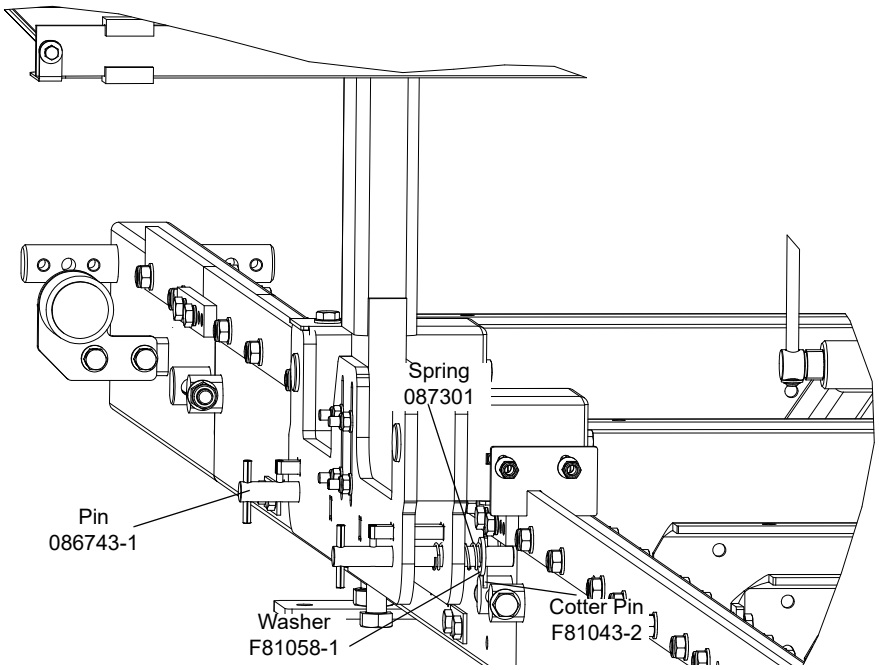


FIG. 2-11

5. Install the blade guides.

See figure 2-12.

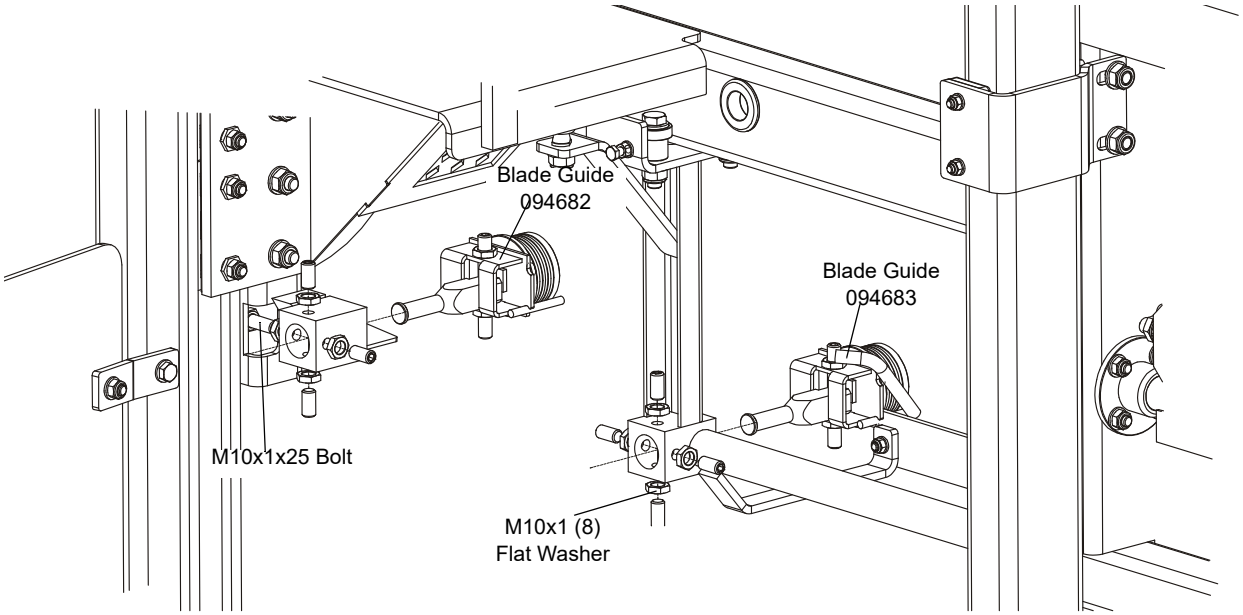


FIG. 2-12

2.5 Auxiliary Bed Rail

To install the auxiliary bed rail to a bed frame section, use the set of mounting holes provided between the two bed rails. Remove the existing bolt and lock nut that secures the track at this position. Use three hex head bolts and lock nuts to secure the bed rail to the bed section. Replace the track mounting bolt and lock nut.

See figure 2-13.

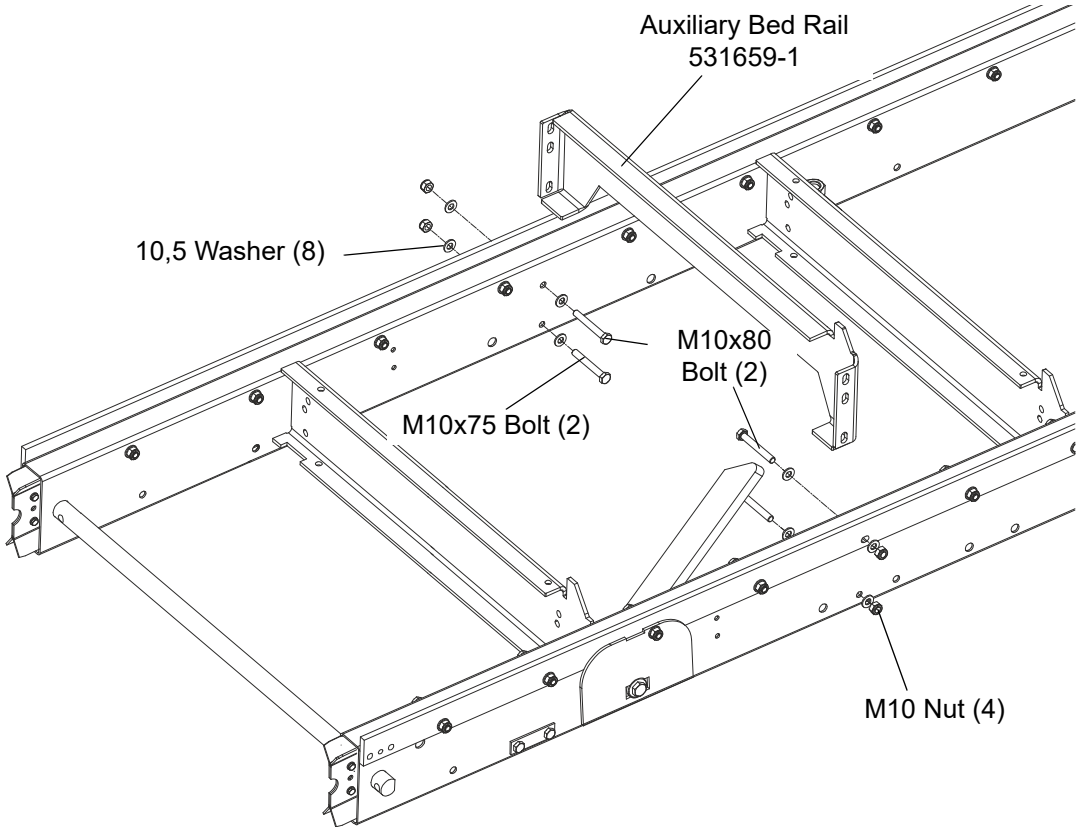


FIG. 2-13

SECTION 3 SETUP & OPERATION

3.1 Sawmill Setup

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

- Set up the machine on firm and level ground. Level the sawmill. Secure the sawmill to the ground to prevent it from moving during operation. A concrete foundation (rated to support 31T/m^2 at each sawmill foot position) and 16mm anchored bolts are recommended.

- The sawmill must not be operated indoors without a sawdust exhaust system connected and started.

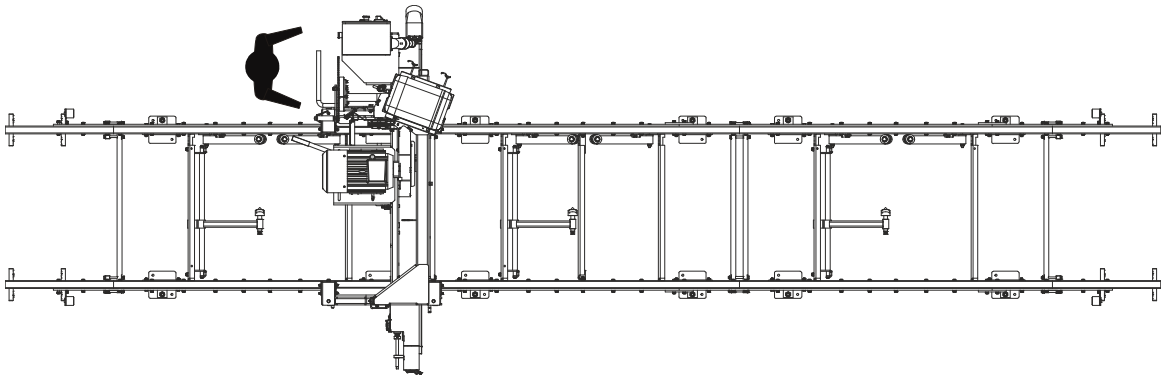
- AC sawmills must not be used outdoors when it is raining or snowing. In such a case, they must be used and stored under roof or indoors.

- It is not allowed to use the sawmill with gas engine indoor. When using this sawmill type outdoor it is allowed to work without sawdust collection system connected. We recommend to setup sawmill in the way that operator position be down the wind. It will separate the operator from sawdust and engine exhaust gases

- The sawmill can be operated in temperature range from -15^{o} C to 40^{o} C only.

- Illuminance at operator's position must be 300lx.

- The sawmill's operator position is shown below.



- Have a qualified electrician install the power supply (according to EN 60204 Standard). The power supply must meet the specifications given in the table below.

See table 3-1.

3-Phase Volts	Circuit Breaker	Suggested Wire Size
400 VAC	32 A	4 mm^2 Maximum length: 15 m

TABLE 3-1

IMPORTANT! When starting the machine for the first time, check that main motor rotation direction is as indicated by the arrow located on the motor body. If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of all sawmill motors.

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

The LT15WA sawmills are only partially aligned at the factory. Some assemblies need to be aligned by the user before first usage of the sawmill.

Assemblies aligned at the factory:

- Blade drive belt tension;
- Engine r.p.m. (DC sawmills only);
- Blade wheels (in vertical and horizontal planes).
- Blade guide arm - *See Section 5.5*;
- Blade guides
- Blade height scale - *See Section 5.12*;
- Stop bolt

The following setup procedure should be performed whenever the sawmill is moved or reassembled. If sawing problems occur and misalignment is suspected, for complete alignment instructions.

1. Adjust the frame legs so the sawmill appears level. If sawmill is on soft ground, use shims under the legs if necessary.

2. Run a string from the front bed rail to the rear bed rail near control box. Place identical spacers between string and the front and rear bed rails. Measure the distance between string and the other bed rails. Adjust the frame legs until all bed rails measure the same distance from the string.

3. Loosen the auxiliary bed rail bolts and adjust the rail so it is the same distance from the string as the main bed rails. Retighten the bolts.

See figure 3-1.

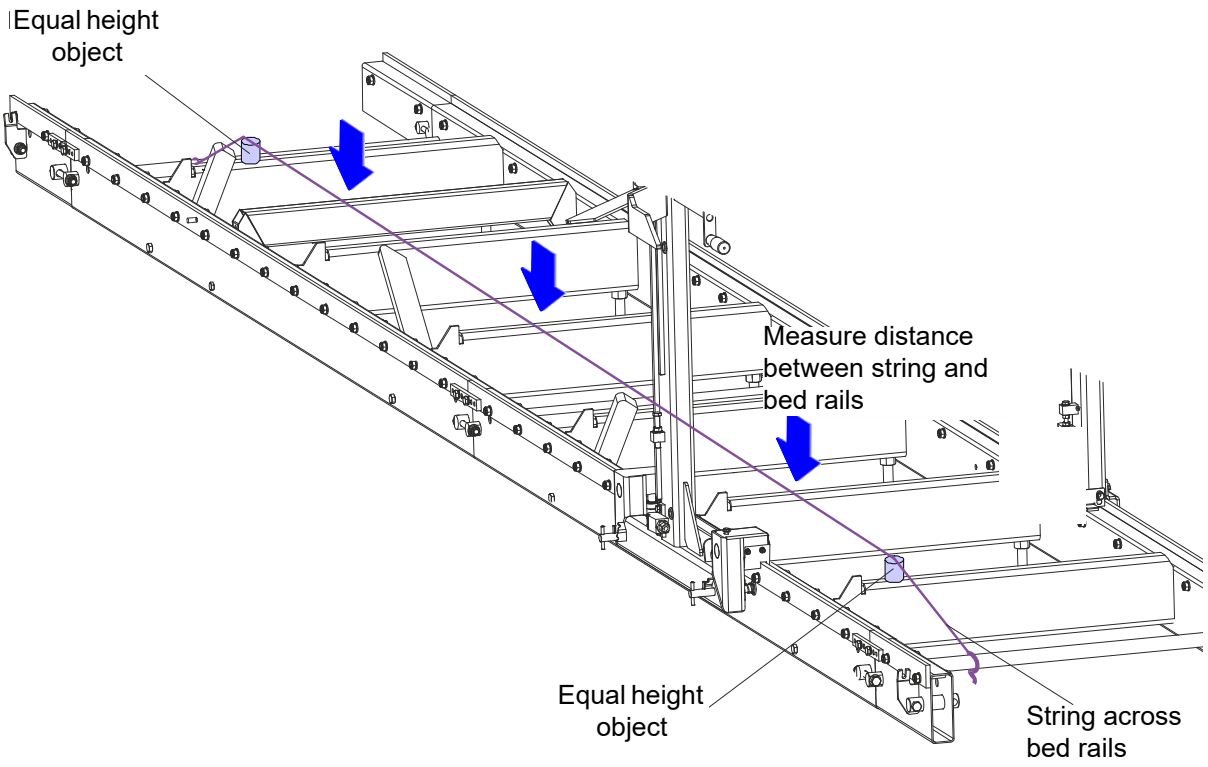


FIG. 3-1

4. Repeat the bed rail adjustment with the string at the other side of the sawmill frame.

5. Install a blade (*See Section 3.2* through *Section 3.4*) and move the saw head until the blade is positioned over the front bed rail.

6. The blade guide rollers should not touch and deflect the blade and the blade guide arm should be adjusted all the way out, away from the other blade guide.

7. Measure the distance from the bed rail to the bottom of the blade near the inside (fixed) blade guide.

8. Measure the distance from the bed rail to the bottom of the blade near the outside (movable) blade guide.

See figure 3-2. When the blade is parallel to bed, it will measure the same distance from the bed rail at the inside and outside of the saw head. If not, adjust the saw head tilt. To do this, loosen the four mounting bolts (A) and use the saw head adjustment nut (B).

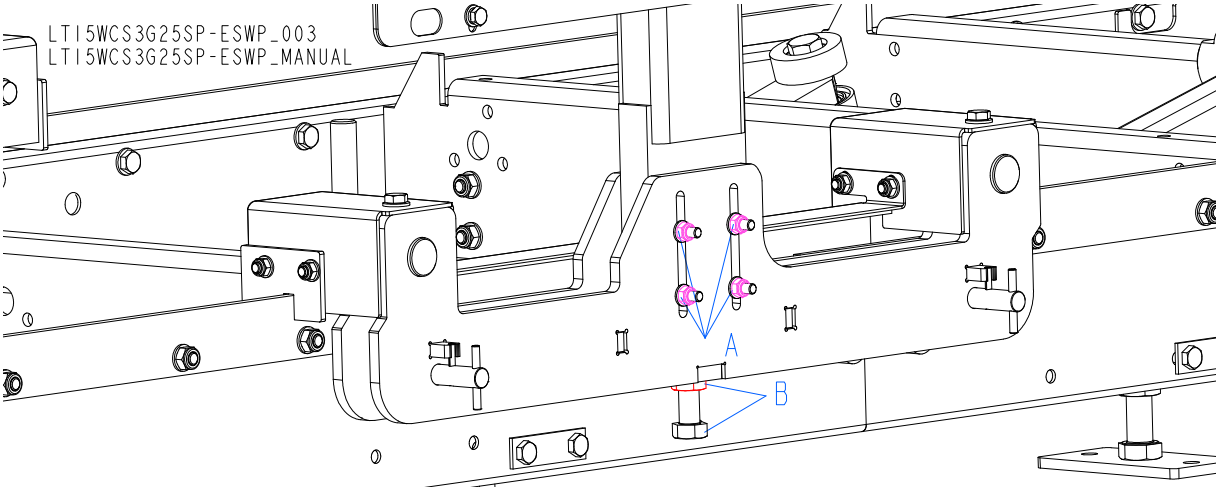


FIG. 3-2

9. Make sure the entire face of each slide pad makes contact with the mast. Use the adjustment nuts shown below to adjust the slide pads if necessary.

See figure 3-3.

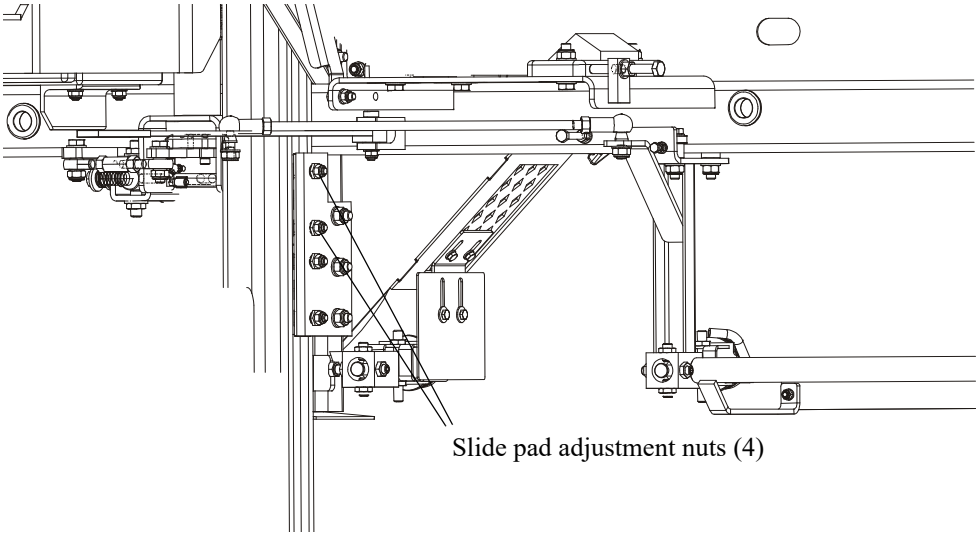


FIG. 3-3

10. Check if the blade is parallel to the bed rails. To do this, use the blade guide alignment tool.

- Attach the tool to the blade near the outer blade guide (next to idle blade wheel). Be sure the tool does not rest on a tooth or burr and is lying flat on the blade.

See figure 3-4.

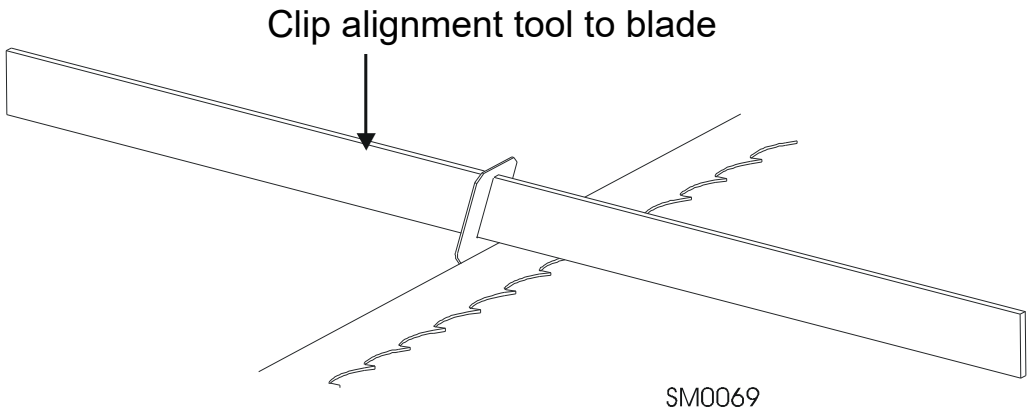


FIG. 3-4

- Move the saw head so the front end of the tool is positioned over the first bed rail. Measure the distance from the bottom of the tool to the top surface of the bed rail.
- Move the saw head so the front end of the tool is positioned over the bed rail. Again measure the distance from the bottom of the tool to the bed rail.
- If the two measurements differ by more than 1/16” (1.5 mm), adjust the vertical tilt of the idle-side blade wheel. *See See figure 3-5.*
- Remove the tool from the blade and reattach it near the inner blade guide. Measure from the tool to the bed rail at both ends of the tool. If the measurements at the front and rear ends of the tool differ by more than 1/16” (1.5 mm), adjust the vertical tilt of the drive-side blade wheel. *See See figure 3-6.*

See figure 3-5. To tilt the idle-side blade wheel up, loosen the bottom adjustment screw 1/2 turn. Loosen the nut on the top adjustment screw and tighten the top adjustment screw. Then tighten the upper and lower nut.

To tilt the wheel down, loosen the top adjustment screw 1/2 turn. Loosen the nut on the bottom adjustment screw and tighten the bottom adjustment screw. Tighten the upper and lower nut.

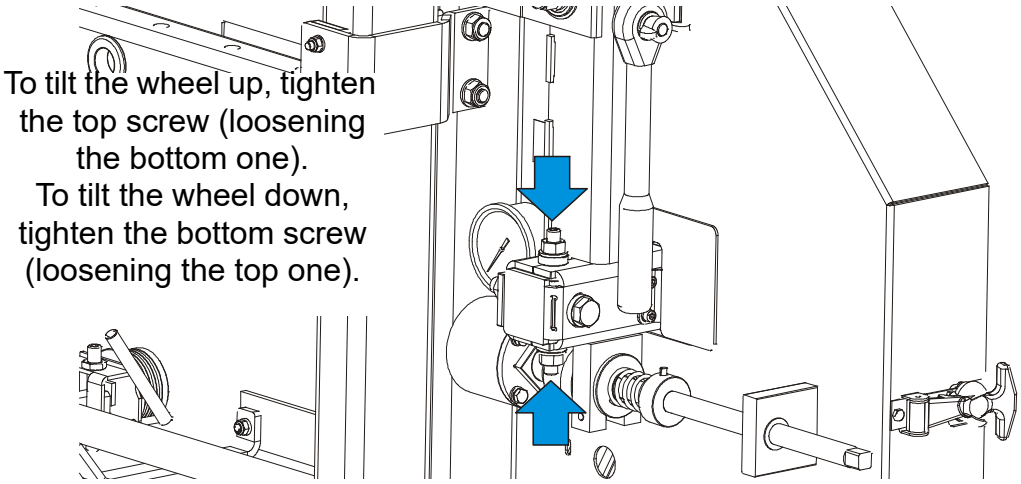


FIG. 3-5

See figure 3-6. Use screws shown below to adjust vertical tilt of the drive-side blade wheel. To tilt the drive-side blade wheel down, loosen the top adjustment screw. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the drive-side blade wheel up, loosen the bottom adjustment screw. Loosen the jam nut on

the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

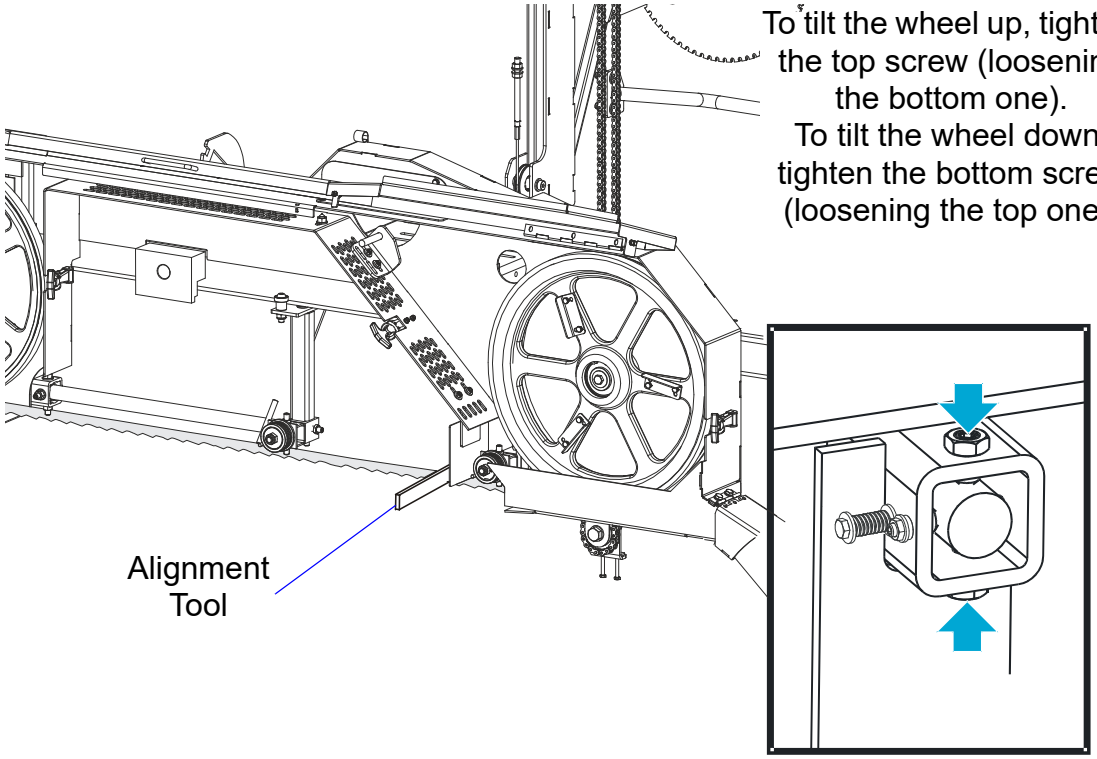


FIG. 3-6

- Recheck the vertical alignment of each blade wheel. Readjust if necessary.

11. Adjust the spacing between each blade guide roller flange and the back of the blade. *See Section 5.9*

12. Adjust the horizontal angle of the blade guides. *See Section 5.10*

13. Adjust the blade deflection (*See Section 5.7*) and vertical angle of the blade guides (*See Section 5.8*).

HINT: It is best to preliminarily set the blade deflection so that is 3 - 4 mm, then adjust the blade guides in vertical plane and make the final adjustments to the blade deflection. The proper blade deflection is 6mm. After adjusting the blade deflection, recheck the vertical alignment of the blade guides and adjust if necessary.

14. Install the blade height scale. To do that, first measure the distance from the bottom edge on a down-set set tooth of the blade to the top of the bed rail. Then stick the blade height scale on the mounting bracket so that it indicates the true distance from the blade to the bed. Adjust the scale if necessary. *See Section 5.12*.

15. Bolt the blade guide guard, so that its bottom edge is about 5mm above blade.

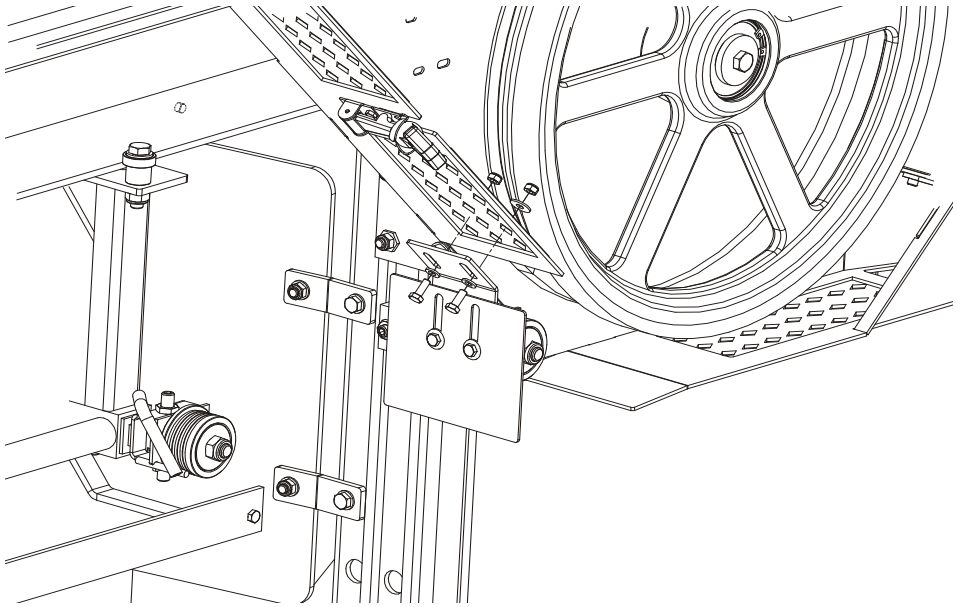
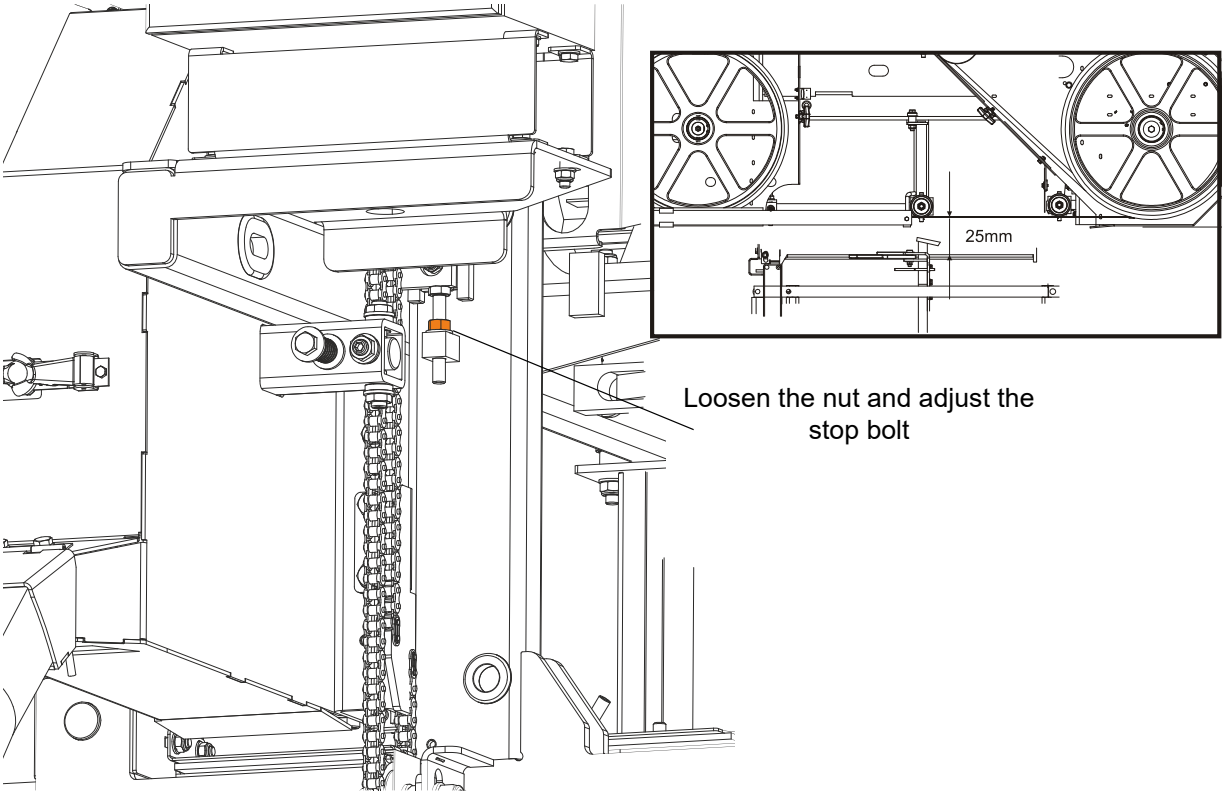


FIG. 3-7

See figure 3-8. Losen the nut and adjust the stop bolt that the saw head stops moving at its lower travel limit - at the height of 25 mm above the bed.



3.2 Replacing The Blade

DANGER! Always disengage the blade and shut off the sawmill motor before changing the blade. Disconnect the power supply using the main switch. Failure to do so will result in serious injury.

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

Adjust the blade guide arm all the way open.

Open the blade housing cover. Turn the blade tension handle to release the blade tension until the blade is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

Install a new blade on the blade wheels. When installing the blade, make sure the teeth are pointing the correct direction. The teeth located between the blade guide assemblies should be pointing toward the sawdust chute.

Position 1 1/4” wide blades on the wheels so the gullet is 3 mm out from the front edge of the wheel. Position 1 1/2” wide blades on the wheels so the gullet is 4.5mm out from the front edge of the wheel.

Close the blade housing cover.

Next, turn the tension handle until the blade is tensioned correctly.

3.3 Tensioning The Blade

See figure 3-9. Tension the blade by turning the tensioner handle clockwise until the tension gauge indicates the recommended tension. Check the blade tension occasionally when adjusting the cant control or while cutting. As the blade and belts heat up and stretch, the blade tension will change. Also, ambient temperature changes can cause tension to change.

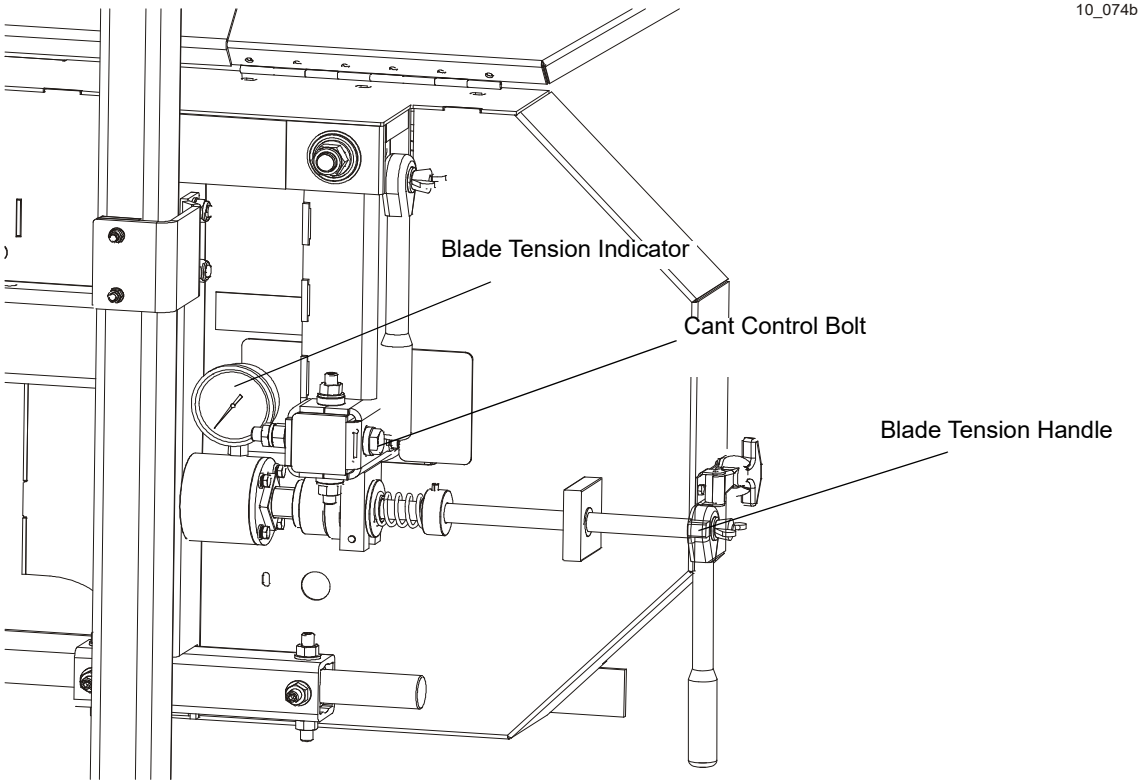


FIG. 3-9

See table 3-2. The recommended tension for different blades is shown below.

Blade Type	Blade Dimensions		Tension range	
	Width	Height	PSI	Bar
275	1.07	32	1015-1088	70-75
375	1.14	32	1088-1160	75-80
2735	1.07	35	1160-1233	80-85

TABLE 3-2

CAUTION! Release the blade tension when the sawmill is not in use (e.g.: at the end of the shift). It should be also an information on the sawmill, that the blade should be tensioned before starting.

3.4 Tracking The Blade

1. Make sure the blade housing cover is closed and all persons are clean of the blade.

2. Start the motor for a moment until the blade positions itself on the wheels.

   WARNING! Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

3. Turn off the motor and check the position of the blade on the blade wheels.

   See figure 3-10. Position 1 1/4” wide blades on the wheels so the gullet is 3.0 mm (± 0,75 mm) out from the front edge of the wheel.

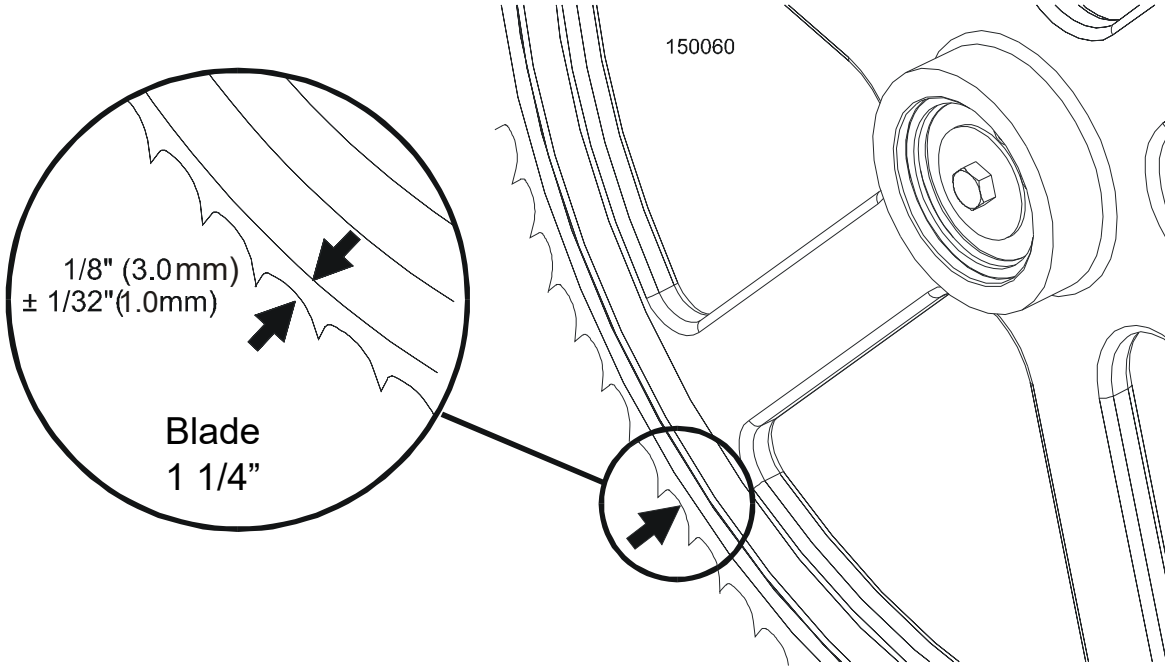


FIG. 3-10

See figure 3-11. To adjust where the blade travels on the blade wheels, use cant control bolt.

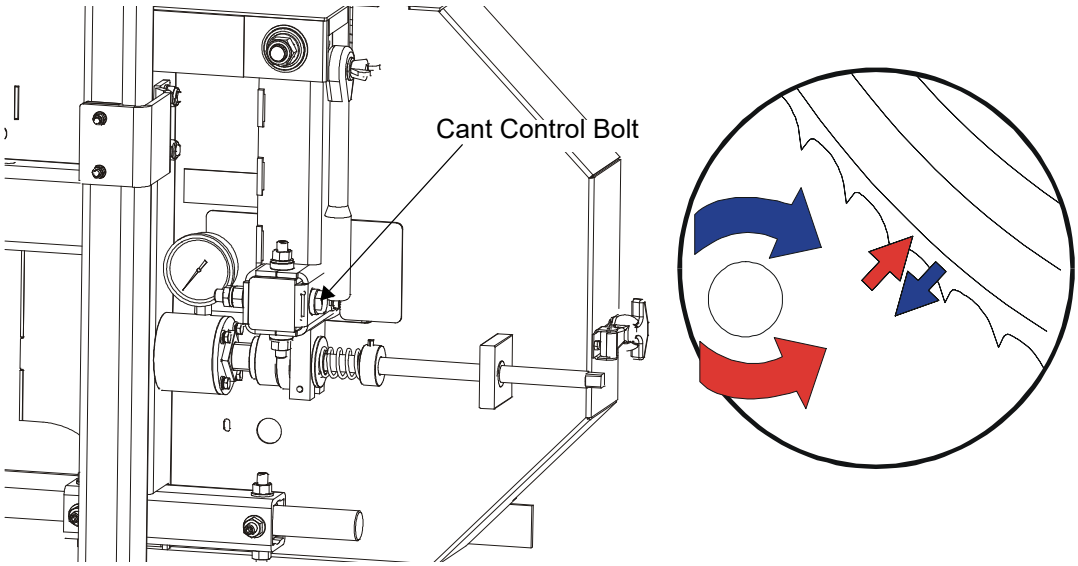


FIG. 3-11

If the blade is too far out, back the blade onto the wheel by turning the cant control bolt counterclockwise. If the bade is too far in, turn the cant control bolt clockwise until the gullet of the blade is the correct distance from the front edge of the wheel.

4. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.

5. Close the blade housing cover.

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

IMPORTANT! After aligning the blade on the wheels, always double-check the blade guide spacing and location. (*See Section 5* for more information.)

3.5 Starting the Engine/Motor

See the appropriate manual supplied with your specific motor configuration for starting and operating instructions.

IMPORTANT! When starting the machine for the first time, check that main motor rotation direction is as indicated by the arrow located on the motor body. If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket. Setting the phases in the phase inverter correctly will ensure correct rotation directions of all sawmill motors.

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

DANGER! Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine or motor. Failure to do so may result in serious injury.

WARNING! Always wear eye, ear, respiration and foot protection as well as safety clothing when operating or servicing the machine. Failure to do so may result in serious injury.

3.6 Loading, Turning and Clamping Logs

To load a log:

1. Move the saw head to the front end of the frame.

CAUTION! Before loading a log, be sure the cutting head is moved far enough forward so the log does not hit it. Failure to do so may result in machine damage.

2. Adjust the log clamps all the way down and move them toward the loading side of the sawmill frame.

CAUTION! Be sure the log clamps are all the way down before loading a log onto bed. Failure to do so may result in machine damage.

3. Raise the side supports on the sawmill bed to prevent the log from falling off the side of the bed.

4. Position the log at the foot of the ramps.

5. Use a cant hook to roll the log up the ramps and onto the sawmill bed. Position the log against the side supports.

6. Remove the log ramps and set aside.

CAUTION! If optional loading ramps are used to load a log onto the sawmill bed, remove them from the brackets on the bed frame before sawing. The saw head may hit the ramp stops when adjusted for low cuts and get damaged.

If your sawmill is not equipped with the loading ramps, use other log loading equipment to load the log onto the sawmill bed. You can also use boards to do this.

To turn logs:

1. Use a cant hook to spin the log against the side supports until it is turned the way you want it for the first cut.

To clamp a log:

1. Position the clamps against the log, far enough down they are below your cuts on a given side of the log. Using the clamp handle, move the log firmly against the side supports.

See figure 3-12.

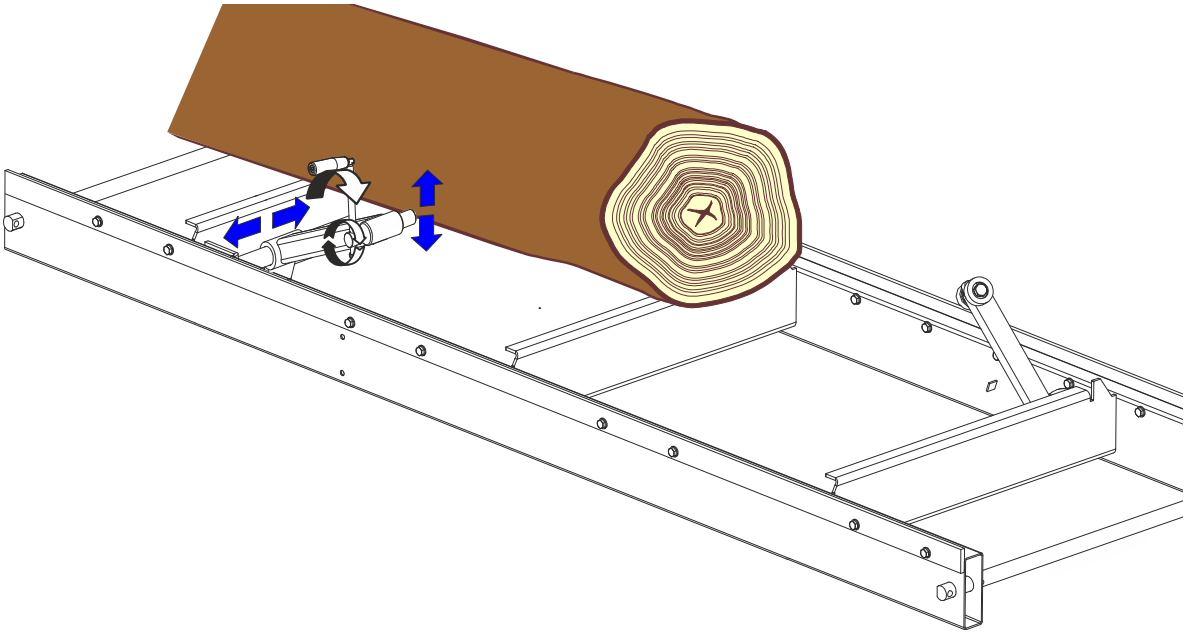


FIG. 3-12

2. Be sure to leave crank in the bottom position to avoid damage to the blade.

See figure 3-13.

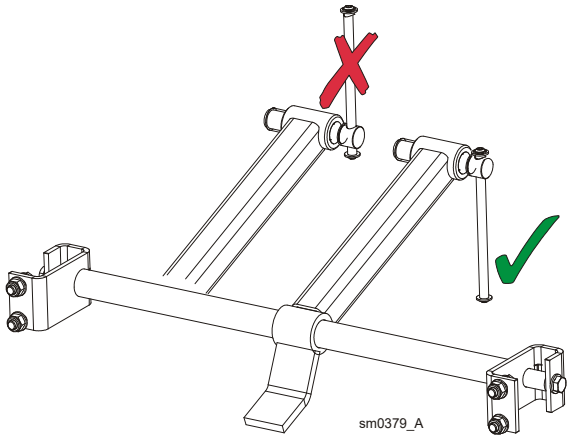


FIG. 3-13

3. Make sure the side supports are positioned low enough for the blade to pass over them. If they are not, back the clamps off slightly and push the side supports down until they are positioned below the height of your last on a given side of the log.

To level a log:

Use the optional wedge to raise either end of a tapered log, if desired. Shim one end of the log until the heart of the log measures the same distance from the bed rails at each end of the log.

See figure 3-14. .

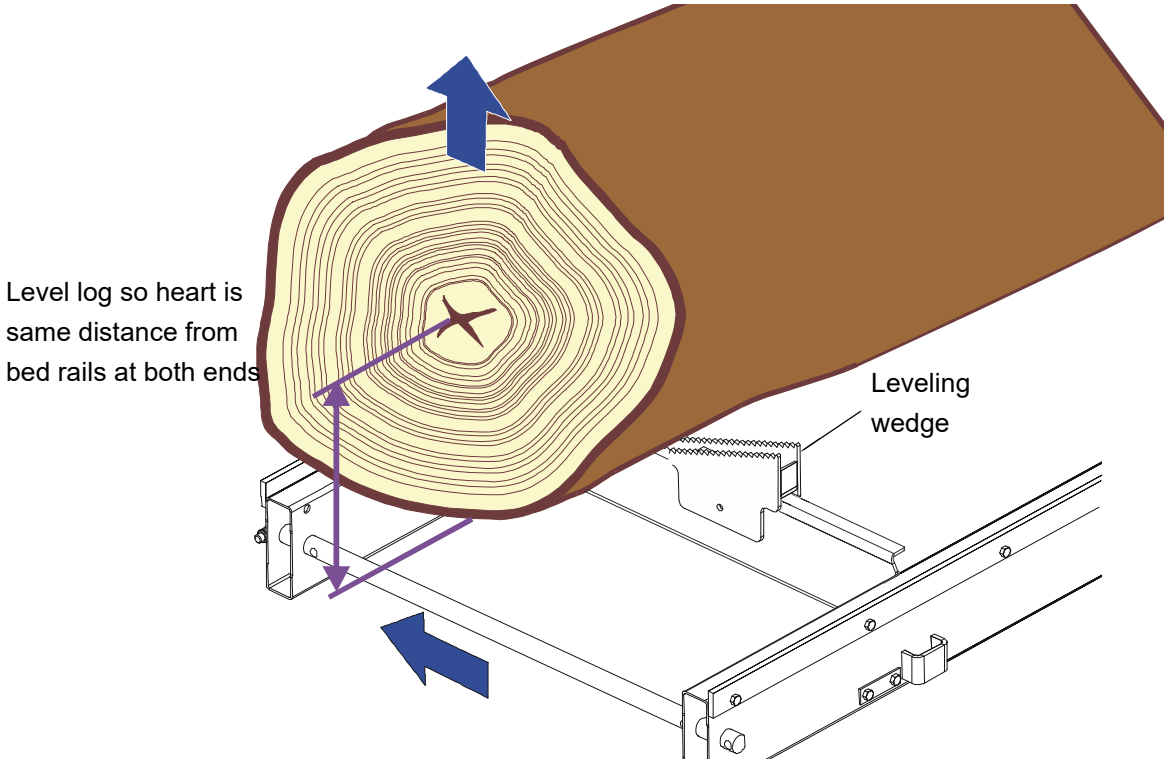


FIG. 3-14

Optional manual toe board. If adjustment is necessary, mount the crank in the toe board fixture at the end of a log to be raised. Turn the crank clockwise to raise the end of the log. Raise the appropriate end of the log until the distance from the heart of the log to the bed rail is equal on both sides

See figure 3-15. .

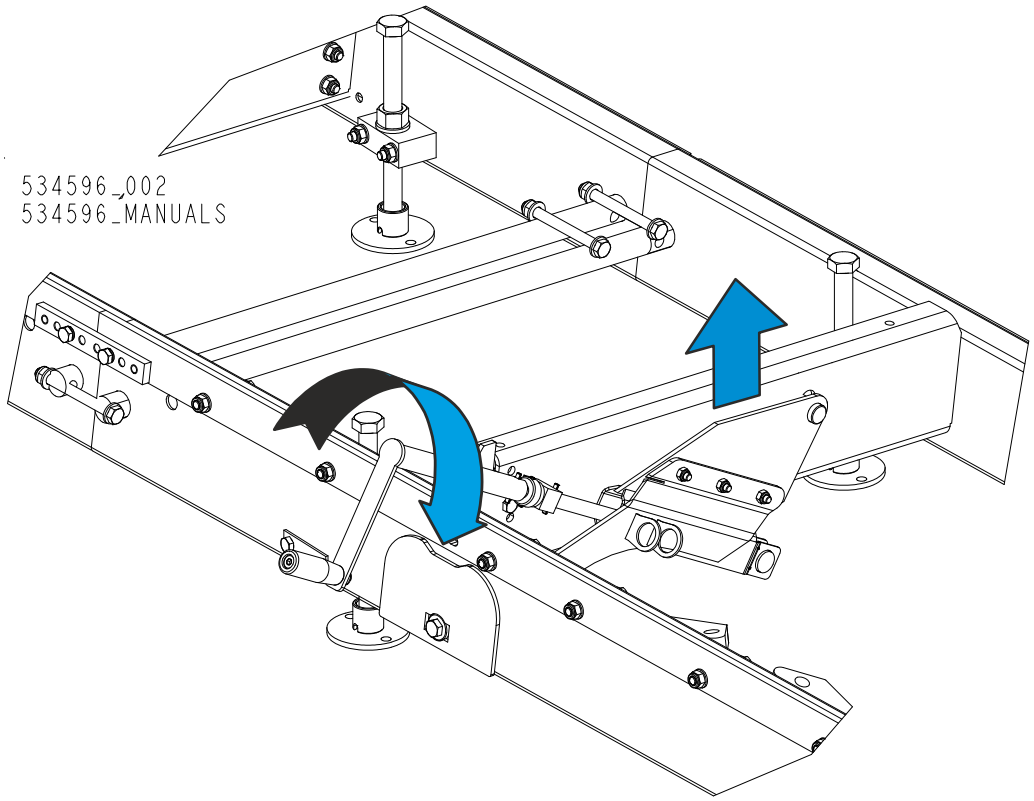


FIG. 3-15

3.7 Up/Down Operation

1. Install a blade, if needed, and check for correct tension (*See Section 3.3*).

   Set the saw head to the desired height (the blade height scale shows the height of the blade above bed rails).

See figure 3-16. Use the Up/Down Crank Handle to raise or lower the saw head.

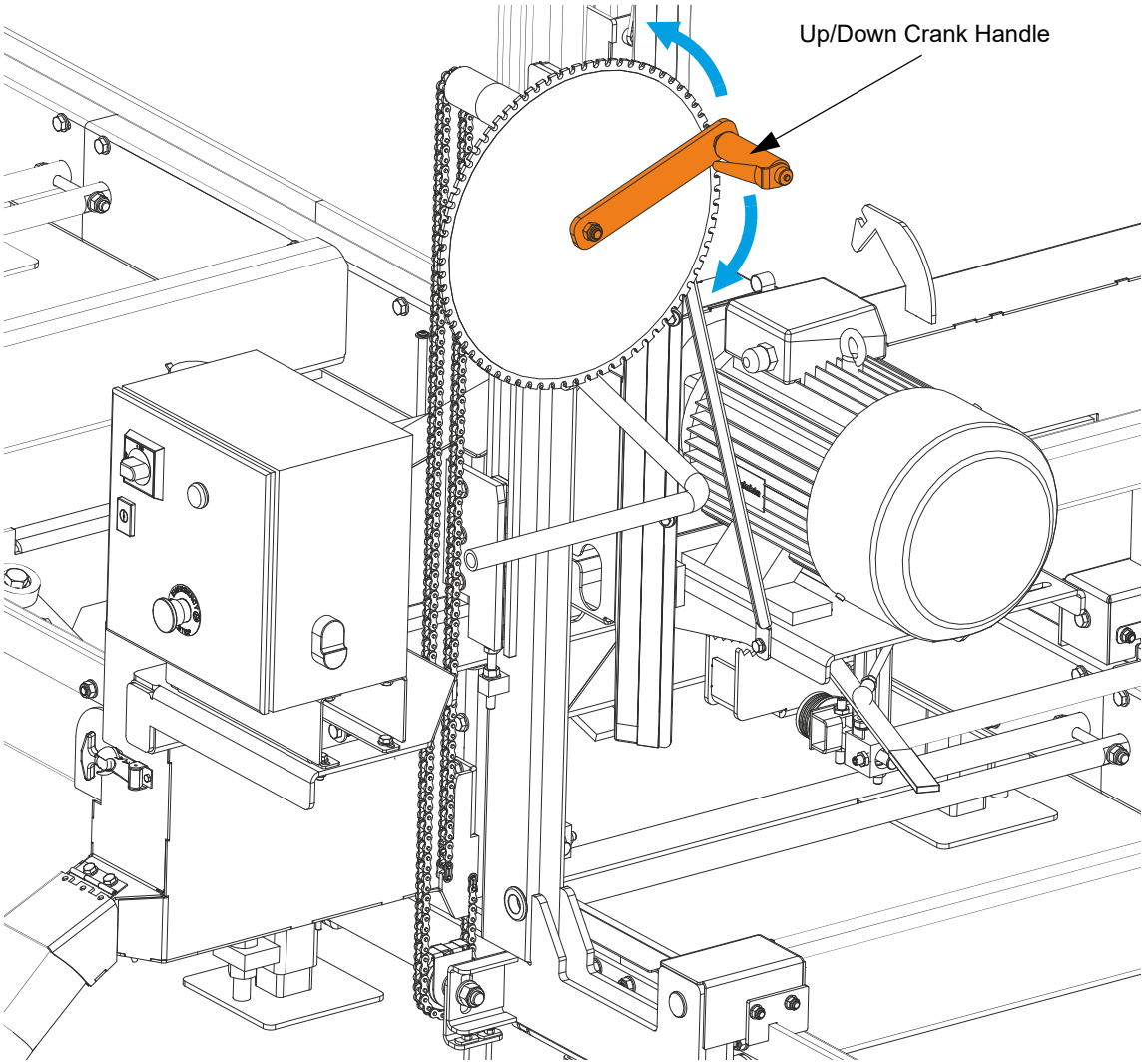


FIG. 3-16

CAUTION! DO NOT try to force the saw head above the 68 cm mark or below the 2.54 cm mark. Damage to the up/down system may result.

3.8 Blade Guide Arm Operation

1. The outer blade guide should be properly positioned before starting to cut the log. It should be adjusted to clear the widest section of the log by less than 25 mm.

2. To adjust the outer blade guide use the blade guide arm handle shown below. Move the blade guide arm handle right to move the arm out. Move the blade guide arm handle down to move the arm in.

See figure 3-17.

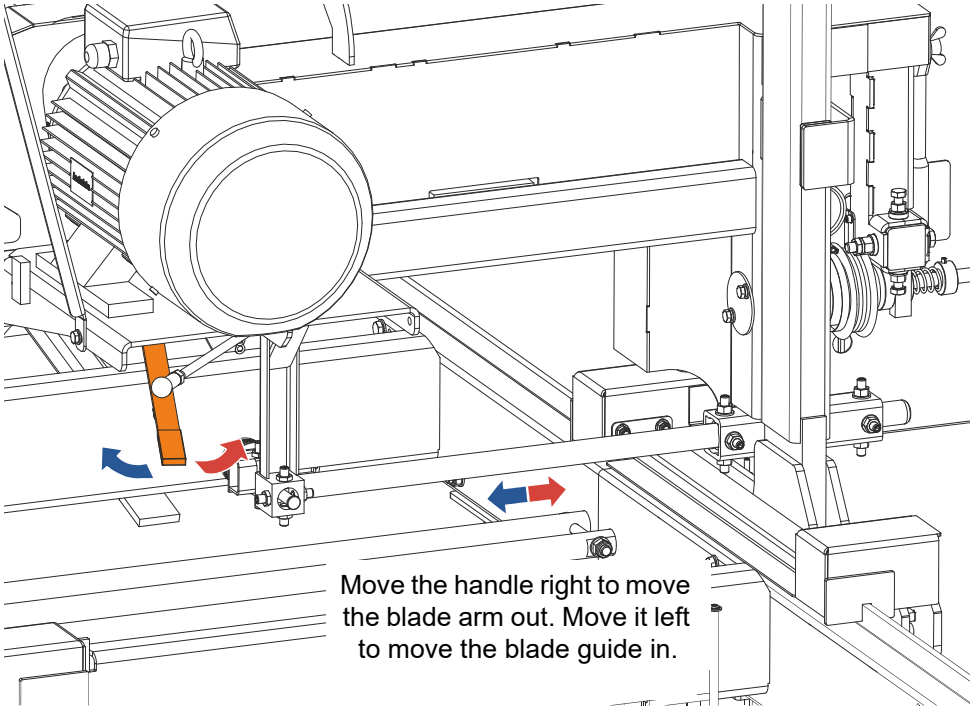


FIG. 3-17

3.9 Blade Drive Operation

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

Be sure the blade housing cover is closed and secured before starting the engine or motor. Use the rubber latches to fasten the blade housing cover shut. If the blade housing cover is not closed and secured, the safety switch located on it interrupts the ignition circuit and the motor/engine cannot be started. If during sawmill operation the cover will be opened, the engine/motor will be stopped.

For Sawmills with the Electric Motor

1. Clear any loose objects from the area of the blade, motor, and drive belt.
2. Make sure the clamps and side supports are positioned low enough for the blade to pass over them. Make sure the log is clamped securely.
3. Start the motor as instructed in the motor manual.

See figure 3-18. To engage the blade, perform the following steps:

- Turn the main switch on the electrical box to the ON position,

- Press the START button on the electrical box to start the motor.

- Press the STOP button on the electrical box to stop the motor after cutting.

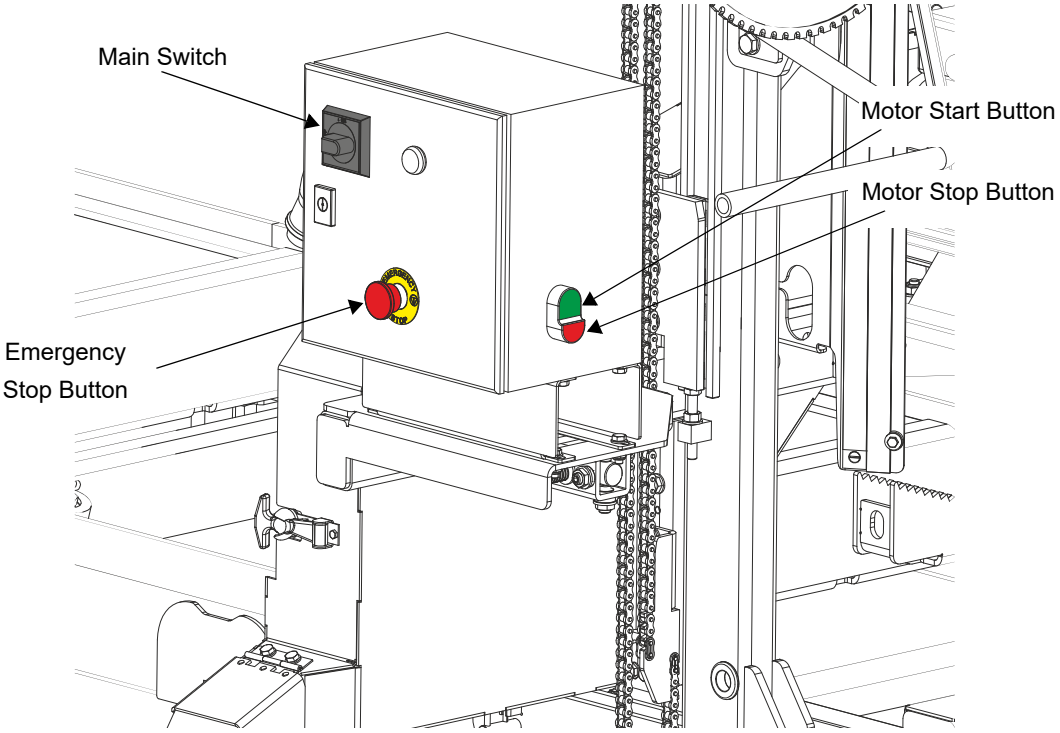


FIG. 3-18

CAUTION! If at any time you need to immediately stop the blade motor, press the emergency stop button located on the electric box.

3.10 Feed Operation

To move the saw head forward or backward, use handle bracket located on the mast.

See figure 3-19.

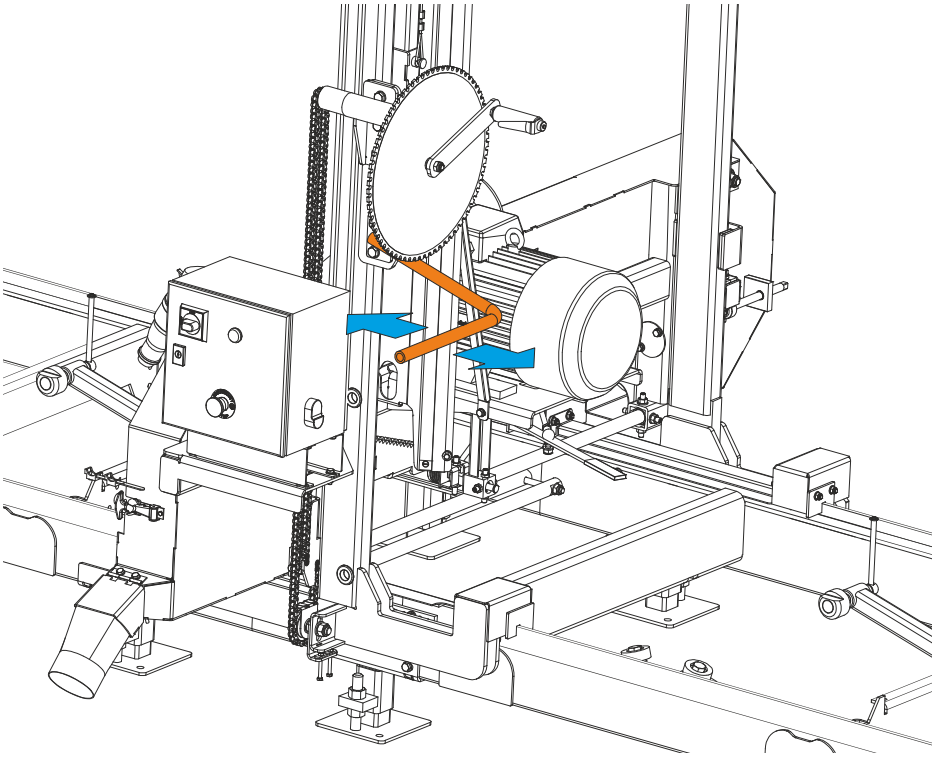


FIG. 3-19

HINT: To get a straight cut in the first part of the board, feed the blade into the log at a slow speed. This stops the blade from flexing and dipping up or down. Use a slow speed until the whole width of the blade has entered the cut. Then increase the feed rate as desired. Maximum feed rate varies with width and hardness of the wood. Over-feeding results in blade and drive belt wear and also produces a wavy cut.

CAUTION! Be sure to stop the blade before returning the saw head. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

HINT: Try to stop the blade while the heel of the blade is still in the log. Then bring the saw head back without adjusting the blade up. This lets you keep the blade at the current height setting so you can make the next blade height adjustment more quickly.

3.11 Cutting The Log

The following steps guide you through normal operation of the Wood-Mizer sawmill.

1. Once the log is placed where you want it and clamp firmly, position the blade close to the end of the log.
2. Use the blade height scale to determine where to make your first cut. (*See Section 3.13*) Set the blade to the desired height with the up/down buttons. Make sure that the blade will clear all side supports and clamps. Adjust the outer blade guide properly (See Section 3.8)
3. Make sure all covers and guards are in place and secured. Start the motor.

4. Start the water lube if necessary to prevent sap building on the blade (*See Section 3.14*).

5. Feed the blade into the log slowly *(See Section 3.10)*. Once the blade completely enters the log, increase the feed rate as desired. Always try to cut at the fastest speed you can while keeping an accurate cut. Cutting too slowly will waste blade life and lower production.

6. As you get to the end of the log, slow down the feed rate. When the teeth exit the end of the log, release the emergency stop button on the control box. Remove the slab that you have just cut from the log.

7. Use the feed crank to return the cutting head to the front of the mill. Always disengage the blade before returning the saw head for the next cut.

8. Repeat until the first side of the log is cut as desired. Set aside the usable flitches (boards with bark on one or both sides). You can edge them on the mill later.

9. Remove the leveling wedge if it was used. Release the clamps and turn the log 90 or 180 degrees. Make sure the flat side of the log is placed against the side supports if the log was turned 90 degrees. If the log was turned 180 degrees, its flat side should rest on the bed rails. If the log was turned 90 degrees and it is necessary to level it on the bed, follow the leveling instructions described in Section 3.6.

10. Repeat the steps used to cut the first side of the log until the log is square. Then cut boards from the cant.

    Example: Remember that the blade cuts a 1/16 - 1/8” (1.6 - 3.2mm) wide kerf. If you want 1” (25 mm) thick boards, lower the saw head 1 1/16 - 1 1/8” (27 - 29 mm) for each board.

3.12 Edging

The following steps guide you through edging boards on the Wood-Mizer sawmill.

1. Raise the side supports to 1/2 the height of the boards that need to be edged.

2. Stack these boards on edges against the side supports.

3. Clamp the boards against the side supports halfway up the board height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other boards or without having to pull them from the middle of the stack.)

4. Adjust the blade height to edge a few of the widest boards.

5. Loosen the clamps and turn the edged boards over to edge the other side.

6. Repeat steps 2-4.

7. Loosen the clamps and remove the boards that have good clean edges on both sides. Clamp the remaining boards and repeat steps 2-5.

3.13 Blade Height Scale

See figure 3-20. The blade height scale is mounted on the vertical mast. It includes:

- a blade height indicator,
- a centimeter scale (or quarter inch scale),

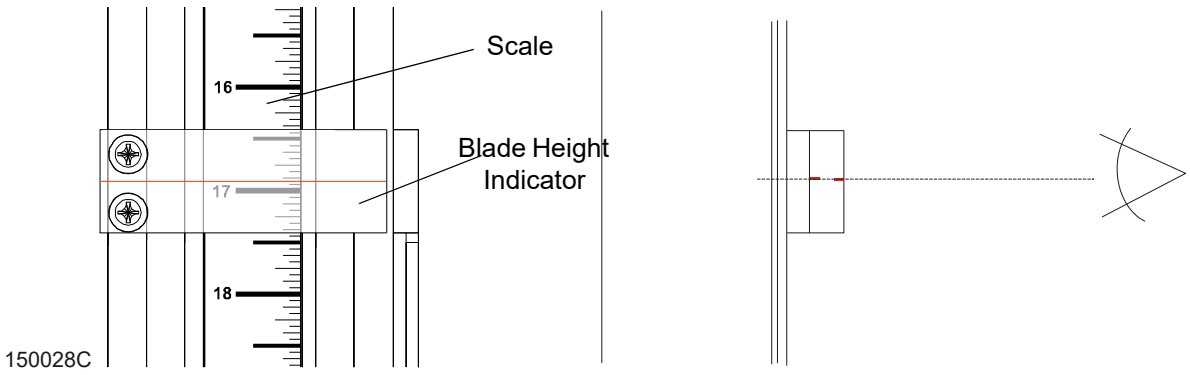


FIG. 3-20

Blade Height Indicator

The blade height indicator has two horizontal, red lines on both sides. Readings should be taken with eyes level with the indicator, when the two red lines are in line. This will allow to avoid the parallax error (different scale readings depending on the angle of vision).

Scale

The horizontal red line on the blade height indicator shows how many centimeters the bottom of the blade is above the bed of the mill. If you know the height of your blade at each cut, you can determine the thickness of lumber you are sawing.

Example: You want to cut 1” (25 mm) random width boards from a log. Position the blade for the first cut. Move the saw head to an even measurement on the scale. Make a trim cut. Return the saw head for the second cut and lower it 29mm below the original measurement (the extra 3 mm allows for saw kerf and shrinkage of the lumber).

The yellow area on the scale identifies where the blade could encounter a side support or log clamp. Check that these items are below the blade level.

The Quarter Scale

See table 3-3. The quarter scales contains four sets of marks. Each set represents a specific lumber thickness. Saw kerf and shrinkage allowance are included. Actual board thickness will vary slightly depending on blade thickness and tooth set.

To choose which scale to use, determine what finished thickness you want to end up with. The Grade Hardwood Quarter Scale provides thicker finished boards usually required by commercial buyers. The Standard Quarter Scale allows for kerf and shrinkage of finished boards suitable for most custom applications. Always check with your customer before you saw to determine what actual finished thickness is required.

Standard Quarter Scale	
Scale	**Actual Board Thickness**
4/4	1" (25 mm)
5/4	32 mm (1 1/4")
6/4	38 mm (1 1/2")
8/4	2" (51 mm)

Grade Hardwood Quarter Scale	
Scale	**Actual Board Thickness**
4/4	29 mm (1 1/8")
5/4	35 mm (1 3/8")
6/4	41 mm (1 5/8")
8/4	54 mm (2 1/8")

TABLE 3-3

To use the quarter scale, look at the blade height indicator. **Example:** You want to cut 1" (25 mm) random width boards from a log. Position the blade for the first cut. Adjust the quarter scale so a 4/4 mark is aligned with the red line on the indicator. Make a trim cut. Return the carriage for the second cut. Now, instead of having to measure down 1 1/8" (29 mm) on the inch scale, you can simply lower the blade so the indicator is aligned with the next 4/4 mark on the quarter scale. Turn the log 90 degrees and repeat.

3.14 Water Lube Operation

The Water Lube System keeps the blade clean. Water flows from a 5-gallon (18.9 liter) bottle through a hose to the blade guide where the blade enters the log. A valve in the bottle cap controls the amount of water flow.

See figure 3-21. Open the valve on the water bottle to start water flow to the blade. A stream of water flows only when the blade is engaged.

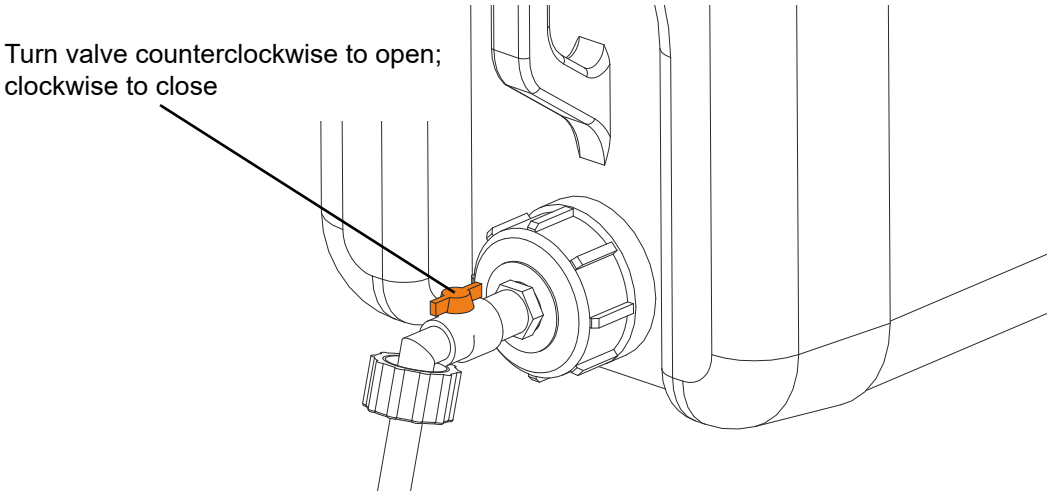


FIG. 3-21

Use just enough water to keep the blade clean. This saves water, and lowers the risk of staining the boards with water. Usual flow will be 1-2 gallons (3.8-7.6 liters) per hour. A squirt of liquid dishwashing detergent in the water bottle will help clean the blade when cutting wood with a high sap content. Not all types of wood require the use of the Water Lube System.

WARNING! Use ONLY water with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so may result in serious injury or death.

Before removing the blade, engage the clutch/brake lever (sawmills with the gasoline engine only). Let the blade spin with water running on it for about 15 seconds. This will clean the blade of sap buildup. Wipe the blade dry with a rag before storing or sharpening.

If you are sawing in freezing temperatures, remove the water lube bottle from the sawmill when done sawing and store it in a warm place. Blow any remaining water from the water lube hose. To do this, disconnect the water lube hose from the water bottle and start the main motor for about 10 seconds.

3.15 Transporting the Sawmill

The assembled sawmill can be transported in an appropriately equipped pickup truck.

1. Adjust the saw head up just far enough so it will clear the sides of your truck bed when loaded. Do not adjust the saw head so high that the sawmill will tip easily while being loaded.

2. Move the saw head to one end of the frame. Engage the travel lock pin to prevent the saw head from moving. Pull the pin and rotate and release so the roll pin seats in the locking position notch.

   See figure 3-22.

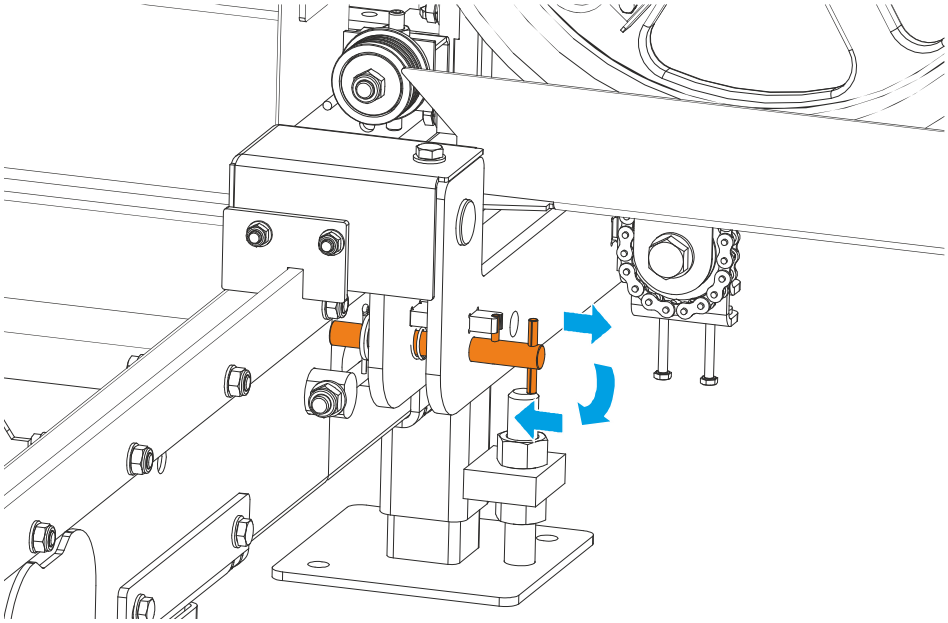


FIG. 3-22

3. Remove the leg assemblies or adjust them above the bottom of the bed frames.

4. Position the bed of the truck at the end of the frame opposite the saw head.

5. While two people lift the end of the frame without the saw head, back the truck under the sawmill until the end of the frame is resting firmly on the bed of the truck.

6. With a person positioned on either side of the saw head, disengage the travel lock pin. Push the saw head up the bed frame and engage the travel lock pin in the end of the frame in the truck bed.

7. Use two people to lift the end of the mill still on the ground and slide the sawmill into the truck bed.

   WARNING! Keep all persons away from the saw head while loading and unloading the sawmill. Failure to do so may result in serious injury or death.

8. Secure the sawmill to the truck bed to prevent the sawmill from shifting while it is being transported.

SECTION 4 MAINTENANCE

This section lists the maintenance procedures that need to be performed on LT15WA sawmills.

CAUTION! Always disconnect and lock out power supply before performing any maintenance work, cleaning or servicing the sawmill. Failure to do so may result in serious injury.

This section lists the maintenance procedures that need to be performed. The Short Maintenance Schedule lists procedures that need to be performed every 4, 8 or 25 hours. The Maintenance Log lists procedures that need to be performed every 50, 100, 200 or 1000 hours. Keep track of the machine maintenance by filling in the machine hours and the date you perform each procedure.

0 **This symbol** identifies the interval (hours of operation) which each maintenance procedure should be performed.

This section lists only part of the maintenance procedures that need to be performed on LT15WA sawmills. Be sure to refer to option and engine manuals for ot her maintenance procedures.

4.1 Wear Life

See table 4-1. This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. This information is provided so that you may plan ahead in ordering replacement parts. This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. Due to many variables which exist during sawmill operation actual part life may vary significantly.

Part Description	Estimated Life
Blade Wheel Belts (B57)	500 hours
Blade Guide Rollers	1000 hours
Drive Belt	1250 hours

TABLE 4-1

4.2 Sawdust Removal

Remove sawdust from the blade wheel housing and sawdust chute at every blade change.

4.3 Carriage Track & Rollers

See figure 4-1.

8 1. Clean the track rails to remove any sawdust and sap buildup every eight hours of operation.

2. Remove sawdust from the track roller housings and track rail with felt strip cover (B). To do this, remove the bolts (A) and brush any sawdust buildup. Soak the felt wiper with Dexron III

transmission fluid, 10W30 motor oil or 3-in-1 turbine oil every 25 hours of operation.

25

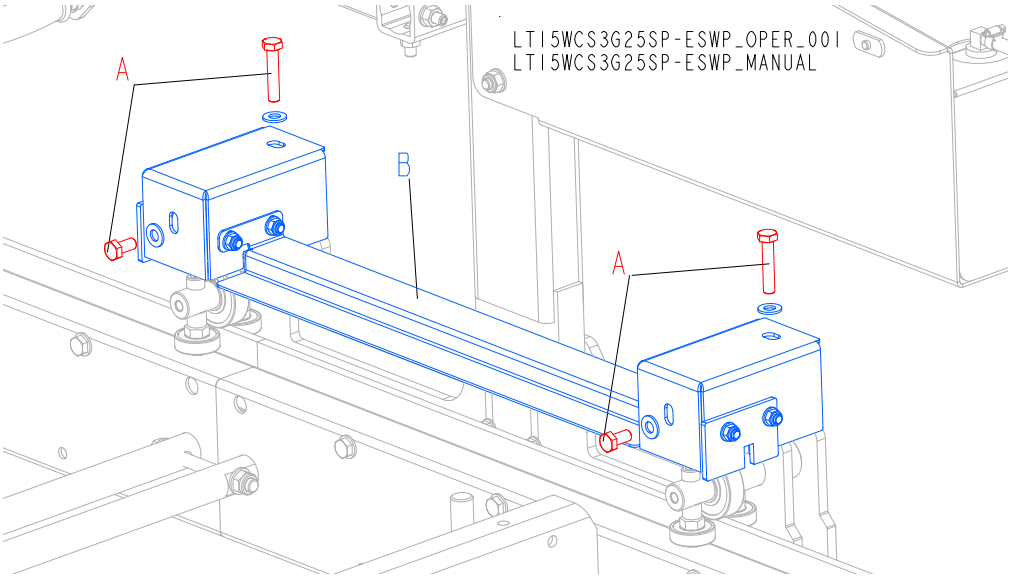


FIG. 4-1

4.4 Vertical Mast Rails

50

Clean and lubricate the vertical mast rails every 50 hours of operation. Clean with solvent and remove any rust with a light-grade sand paper. Lubricate the mast with motor oil or automatic transmission fluid (e.g. Dextron II or III).

CAUTION! Never use grease on the mast rails as it will collect sawdust.

4.5 Miscellaneous Lubrication

1. Lubricate the tensioner screw with a rolling bearing grease (e.g. ŁT4S or Shell Extreme Pressure Grease) as needed.

See figure 4-2.

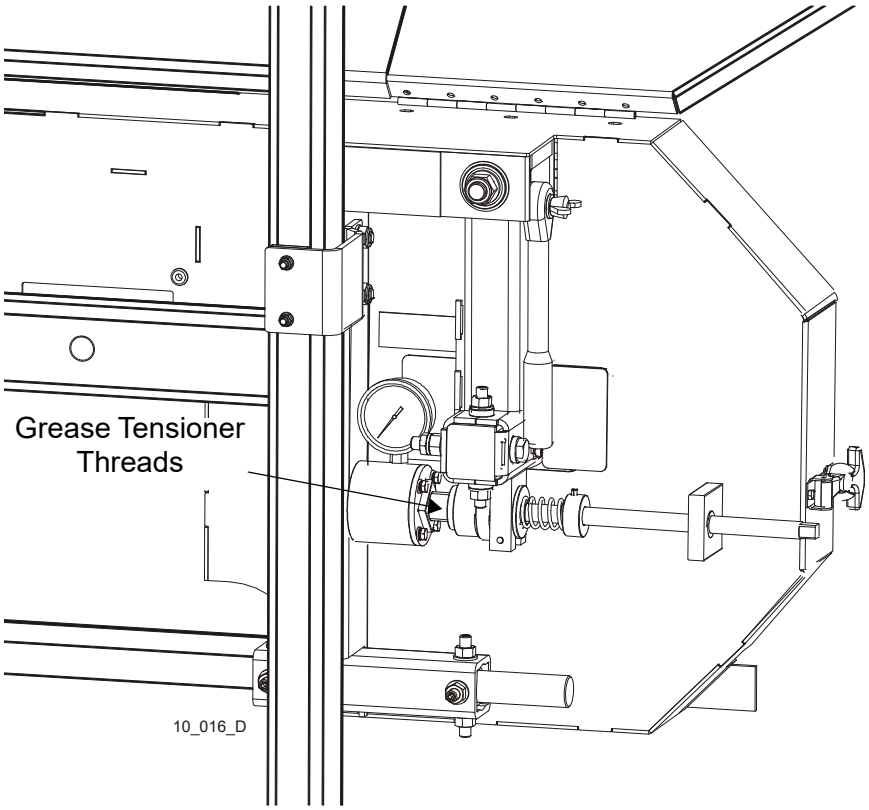


FIG. 4-2

4.6 Blade Wheel Belts

1. Check the blade wheel belts for wear. Replace belts if necessary. Rotating the belts every 50 hours will increase the belt life. Use only B57 belts manufactured by Goodyear or Browning.

50

2. Periodically check all belts for wear. Replace any damaged or worn belts as needed.

4.7 Up/Down and Feed System

CAUTION! Always secure the cutting head with a chain or brace before adjusting the up/down chain. The cutting head may fall, causing severe injury or death.

1. Adjust the up/down chain tension as needed. Measure chain tension, with the saw head all the way to the top of the vertical mast. Secure the saw head with a chain at the top or shim it underneath. Find the chain adjusting bolt at bottom part of the mast. Loosen the nut on the bolt and move the sprocket down until there is about 1” (2.5cm) total deflection in the center of the chain with a 5 lb. (2.3kg) deflection force.

See figure 4-3.

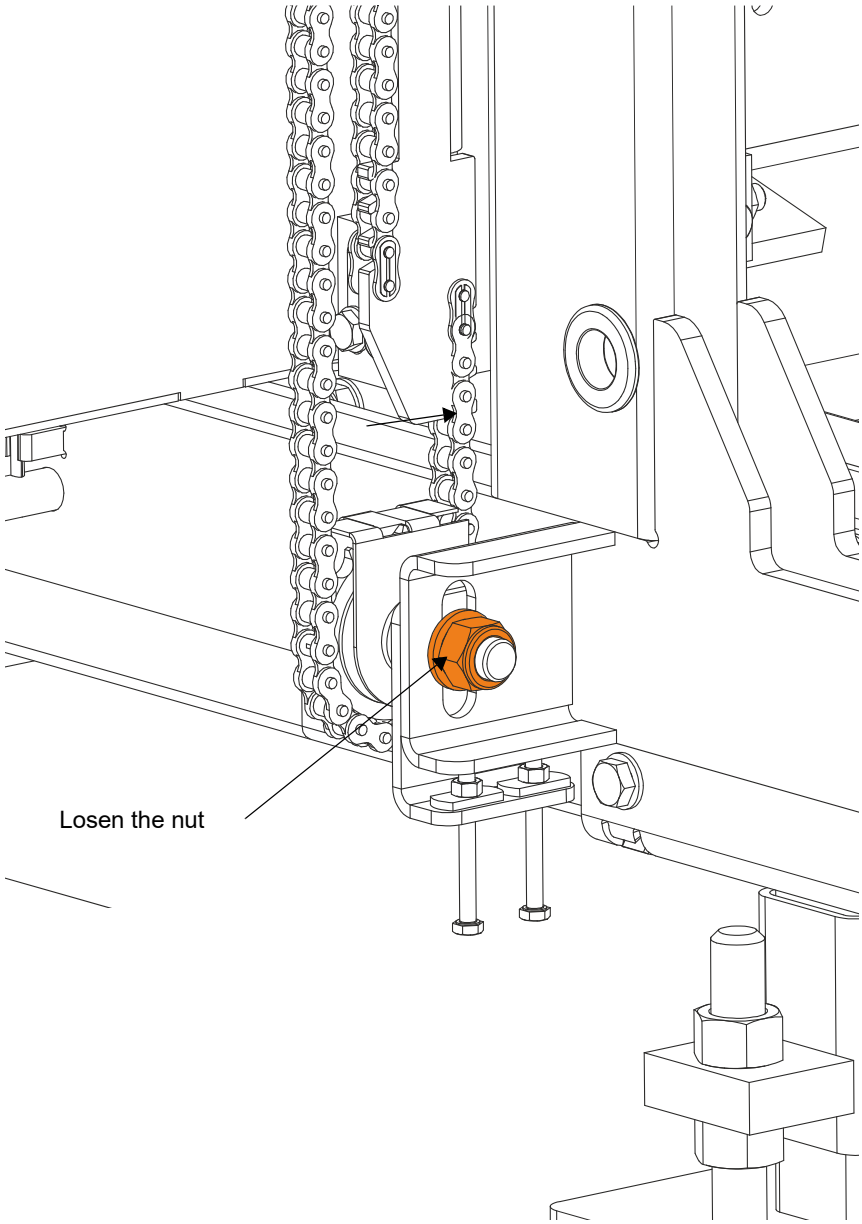


FIG. 4-3

4.8 Miscellaneous Maintenance

50

1. Check the drive belt tension after the first 20 hours and every 50 hours thereafter. See Section 6.13 for drive belt adjustment instructions.

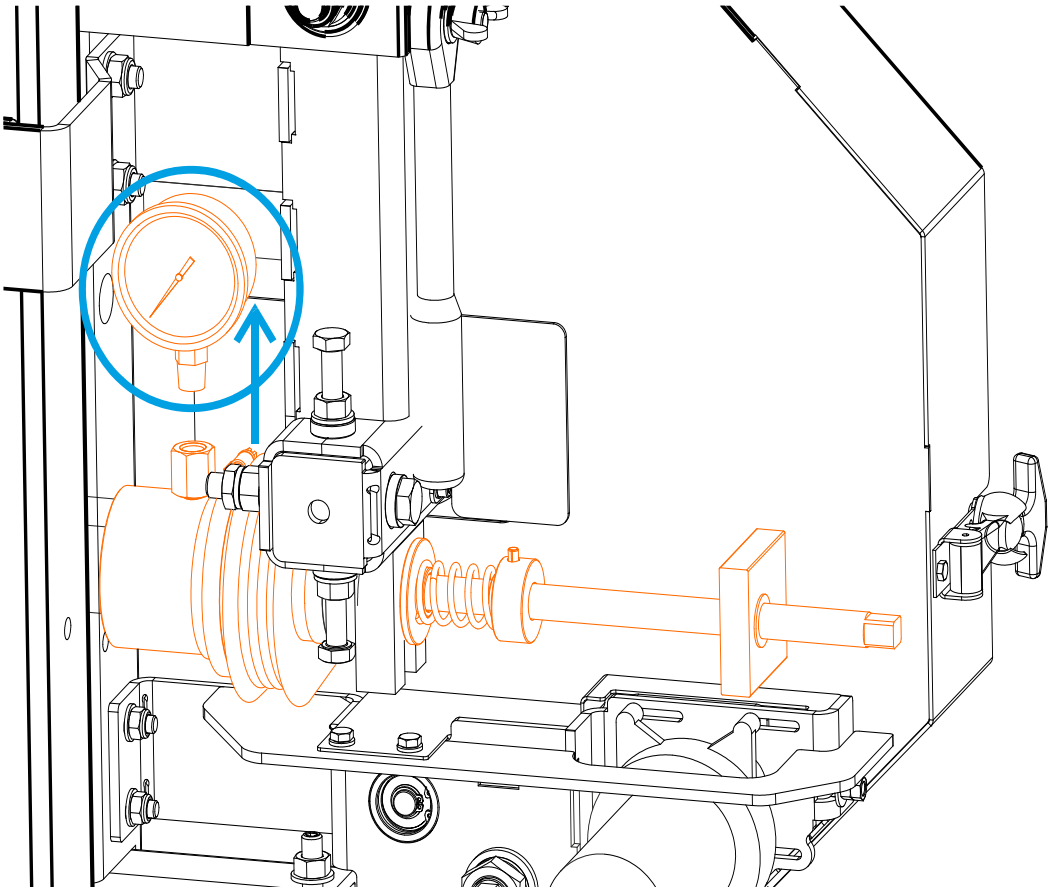
2. Check the mill alignment every setup. (See Section 6, Alignment).

3. Make sure all safety warning decals are readable. Remove sawdust and dirt. Replace any damaged or unreadable decals immediately. Order decals from your Customer Service Representative.

4.9 Filling Blade Tensioner Cylinder with Oil

1. Loosen the blade tensioner completely.

2. Unscrew the oil pressure gauge.

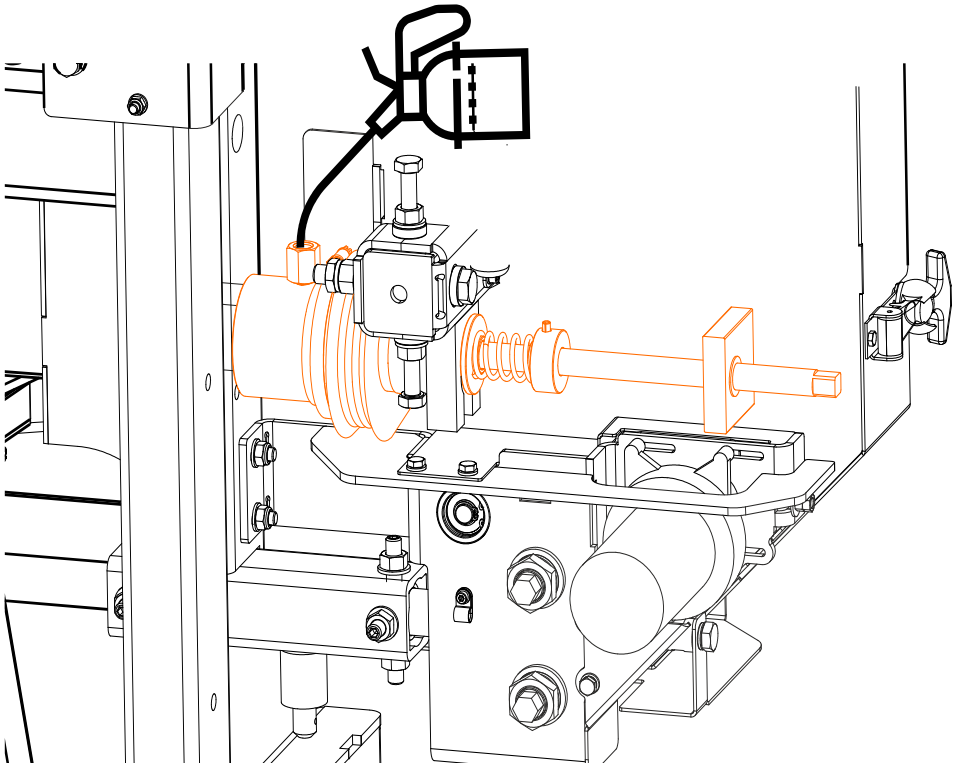


3. Using an oiler equipped with a tube / hose, top up the oil level until the oil flows out of the cylinder.

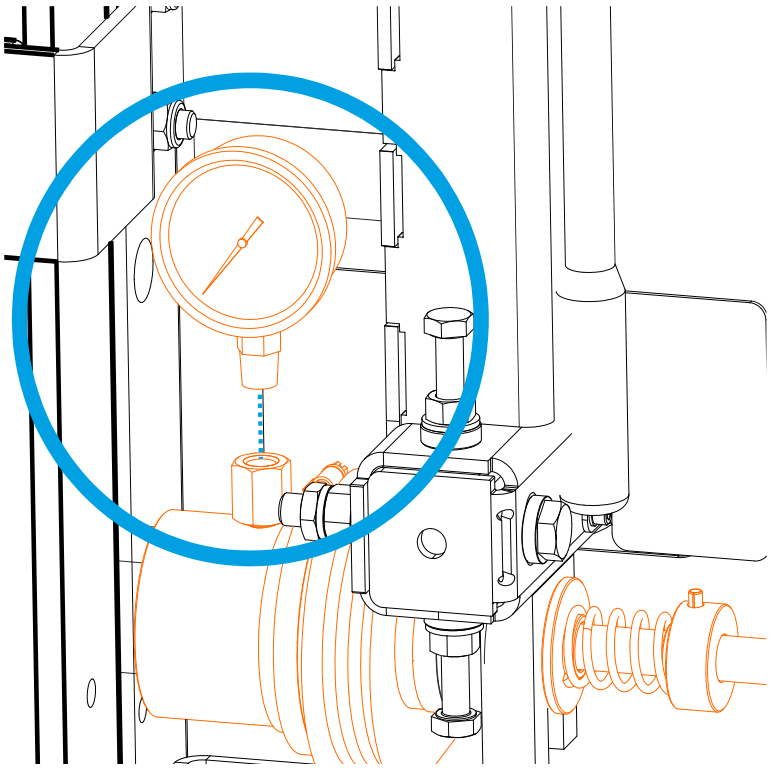
IMPORTANT! The cylinder needs to be filled with MOBIL DTE 10 Excel 32 Hydraulic Oil (#WM part number: **P12825**).

IMPORTANT! When topping up the oil level, make sure that the end of the oiler tube / hose is at the bottom of the cylinder.

4. Wait 5 minutes. If the oil level does not lower, move on to the next step. If the oil level lowers, top up the oil level until the oil flows out of the cylinder.



5. Seal the oil pressure gauge with Teflon tape and screw it back.



4.10 LT15WA AC Safety Devices Inspection (Only CE Version)

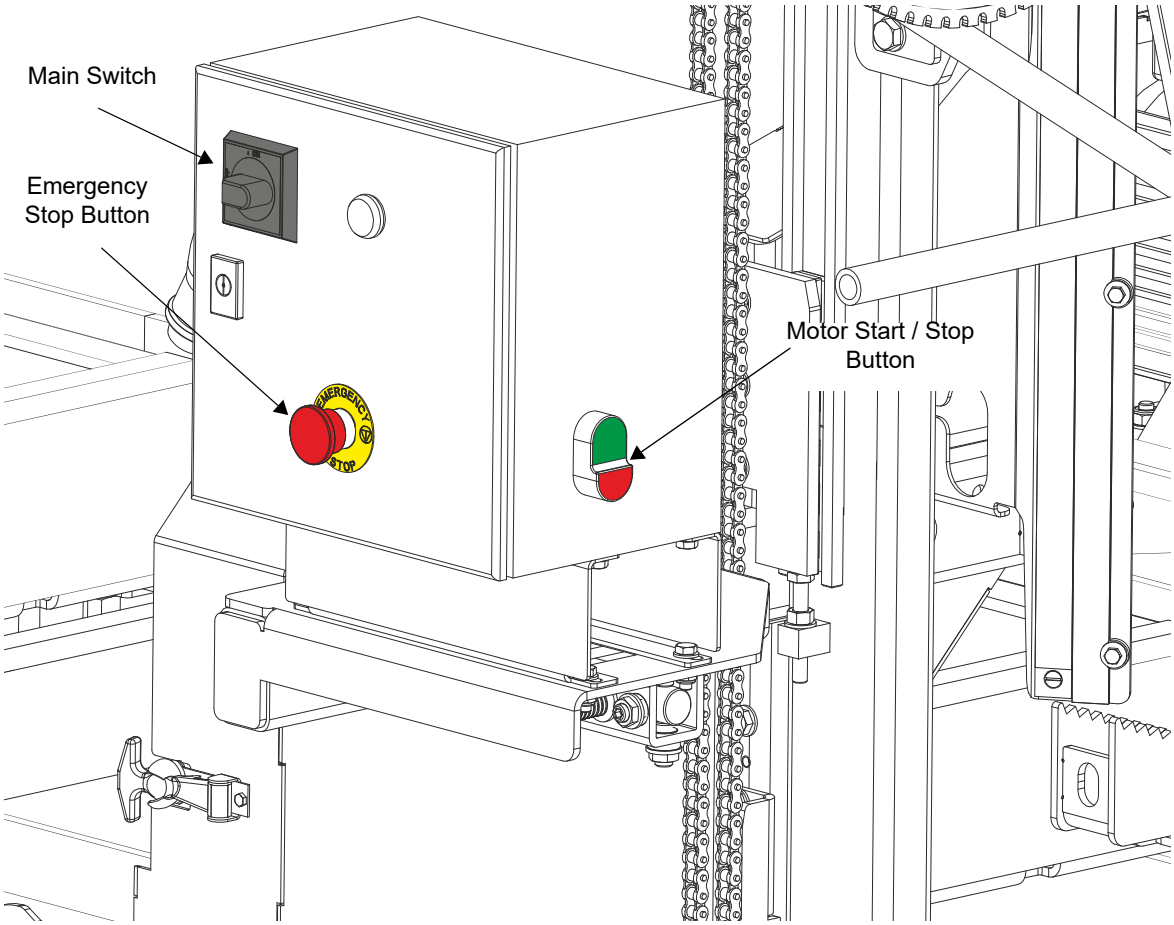
LT15WA AC - Safety devices inspection

Safety devices on the LT15WA AC sawmill which must be checked before every shift:

- E-STOP button and its circuit inspection
- Green safety button inspection
- Circuit inspection with the E-STOP button pressed
- Blade cover safety switch and its circuit inspection

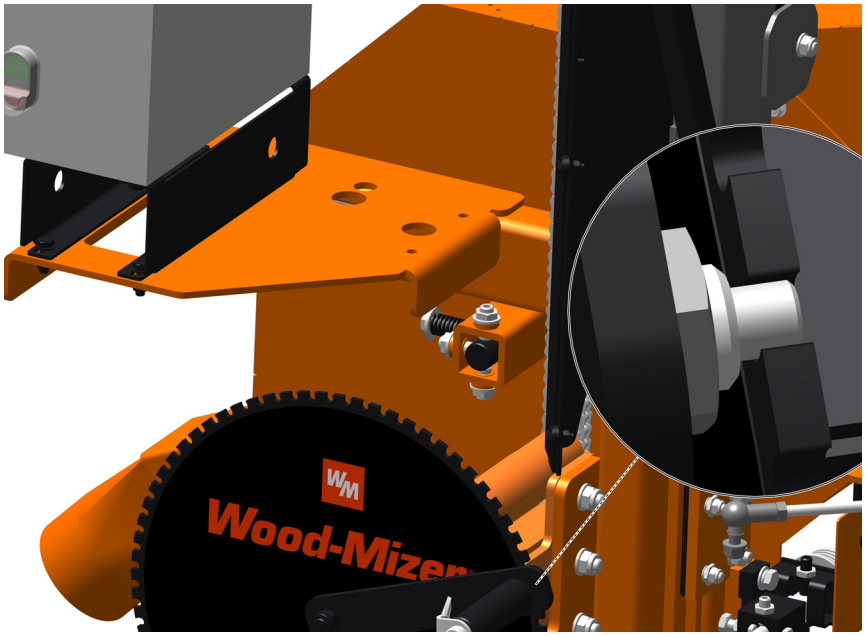
1 E-STOP button and its circuit inspection

- Press and hold the green safety button;
- Turn on the main engine;
- Press the E-STOP button located on the left side of the control box. The engine should be stopped. Pressing the START button should not start the motor until the E-STOP button is released.

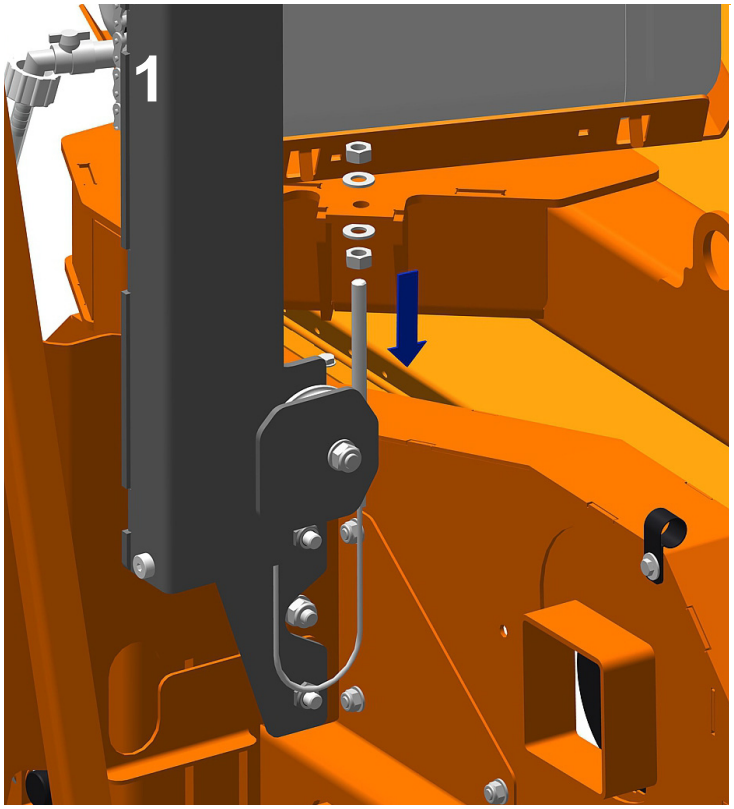


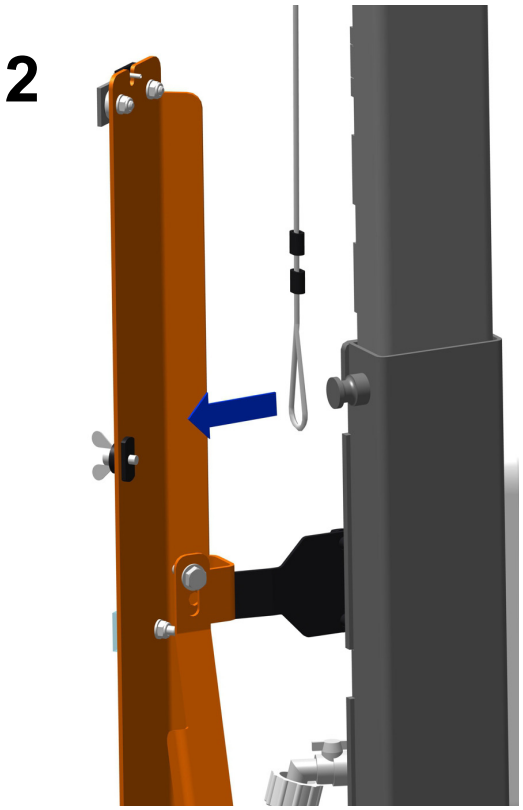
4.11 Replacing gas struts for Lift Assist.

1. Raise the head to the highest position and secure it against falling as shown in the diagram below.

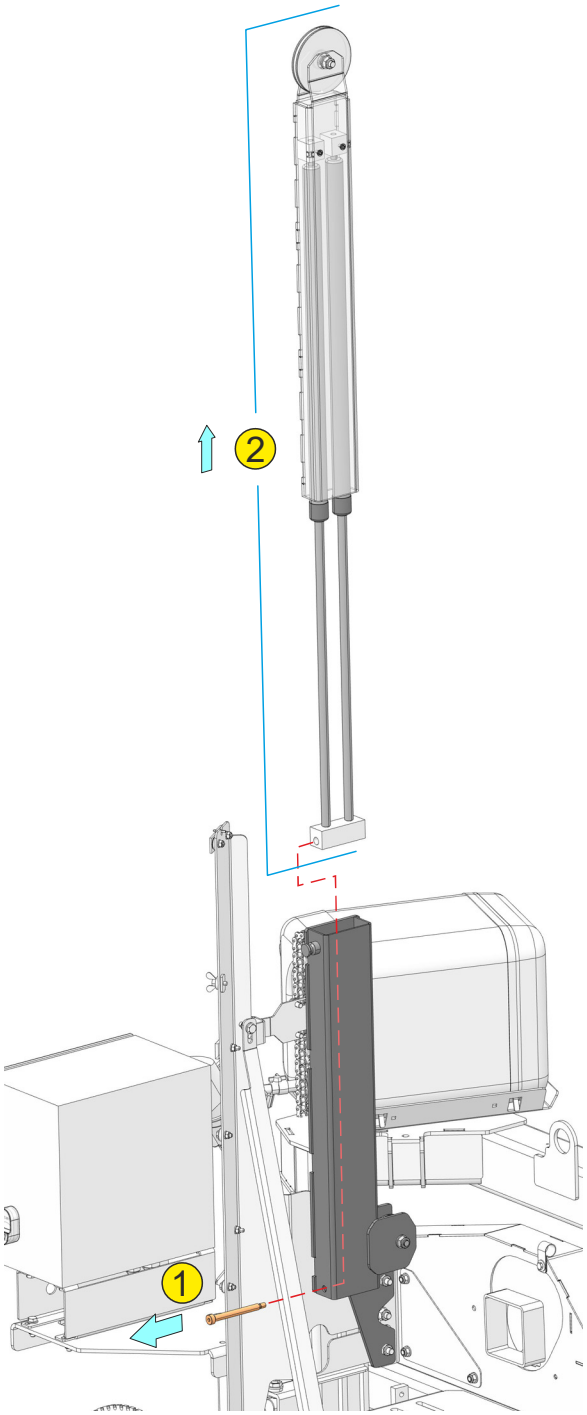


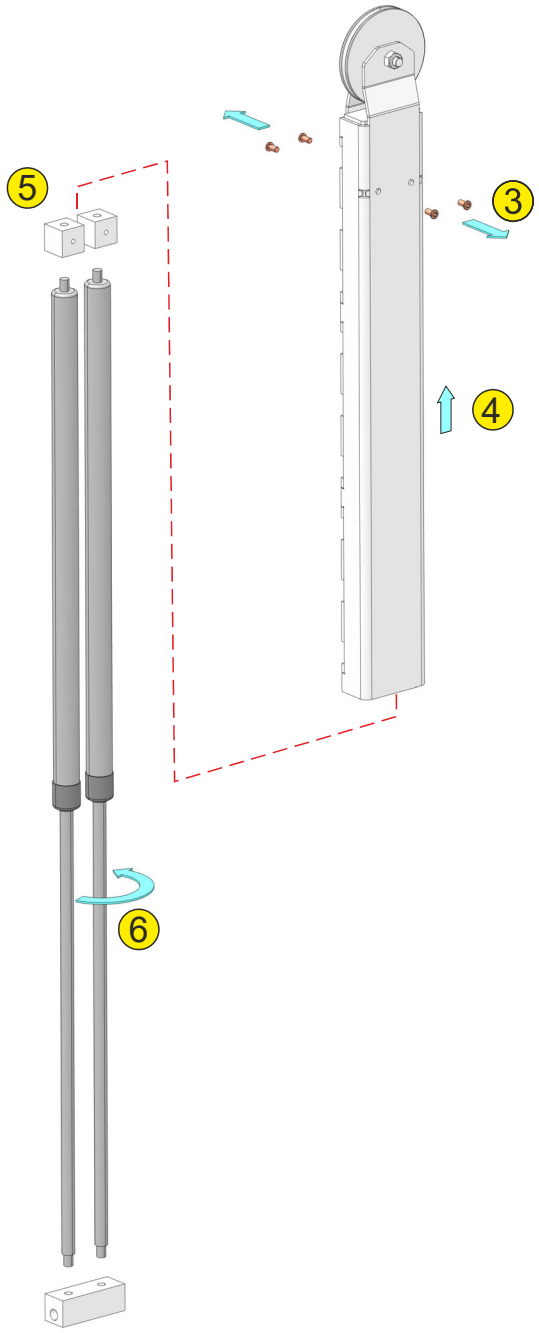
2. Unscrew the Up/Down shift cable (1). Remove the cable from the attachment point (2) and from the top pulley of the Lift Assist.





3. Unscrew the screw (1), remove the upper cover along with the gas springs (2). Unscrew 4 screws (3). Slide out the gas spring cover (4), unscrew the spring mounting blocks (5), unscrew the gas spring mount (6). Replace the spring and reassemble everything in reverse order.





SECTION 5 SAWMILL ALIGNMENT

5.1 Pre-Alignment Procedures

Periodically check the sawmill alignment and adjust if necessary. This chapter explains how to align the entire sawmill. Care should be taken in performing these steps. Sawmill alignment determines the accuracy and squareness of your cuts.

The sawmill alignment steps are:

1. Prepare the sawmill for alignment,
2. Adjust the blade parallel to the bed rails,
3. Adjust the blade guide arm parallel to the saw head brace,
4. Align blade guides to the blade,
5. Adjust side supports square to the bed,
6. Final adjustments.

To insure accurate alignment, the sawmill frame must be level and a blade properly installed.

See Section 3 Setup & Operation for setup information.

5.2 Pre-Installation Procedure

Before performing the following alignment procedures, setup the mill on firm, level ground. String the bed and adjust the legs so the frame is level.

5.3 Blade Installation and Alignment

Install a blade and apply the appropriate tension as shown in (*See Section 3.3*.)

1. Close the blade housing cover and make sure all persons are clear of the open side of the saw head.
2. Start the motor for a moment.
3. ***Gas Engine Only:*** Pull lightly on the clutch handle, rotating the blade until the blade positions itself on the wheels.

WARNING! Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

4. Turn off the motor, open the blade housing cover, remove the key from the key switch (or turn off the power supply using the switch on the electric box) and check the position of the blade on the blade wheels.

5. ***Gas Engine Only:*** Release the clutch handle to stop the blade. Turn off the engine, remove the key and check the position of the blade on the blade wheels.

   Check the vertical alignment of the idle-side blade wheel. The gullet of the blade should ride the same distance from the front edge of the wheel at the top and bottom of the wheel. If it does not, loosen and tighten the appropriate adjustment screws on the wheel shaft.

   See figure 5-1. The blade wheels should be adjusted so that the gullet of 1 1/4" blades ride 1/8” (3 mm) out from the front edge of the wheels (±1/26 [1 mm]). The gullet of 1 1/2" blades should ride 3/16" (4.5 mm) from the front edge of the wheels (±1/26 [1 mm]). *Do not let the teeth ride on the wheels.*

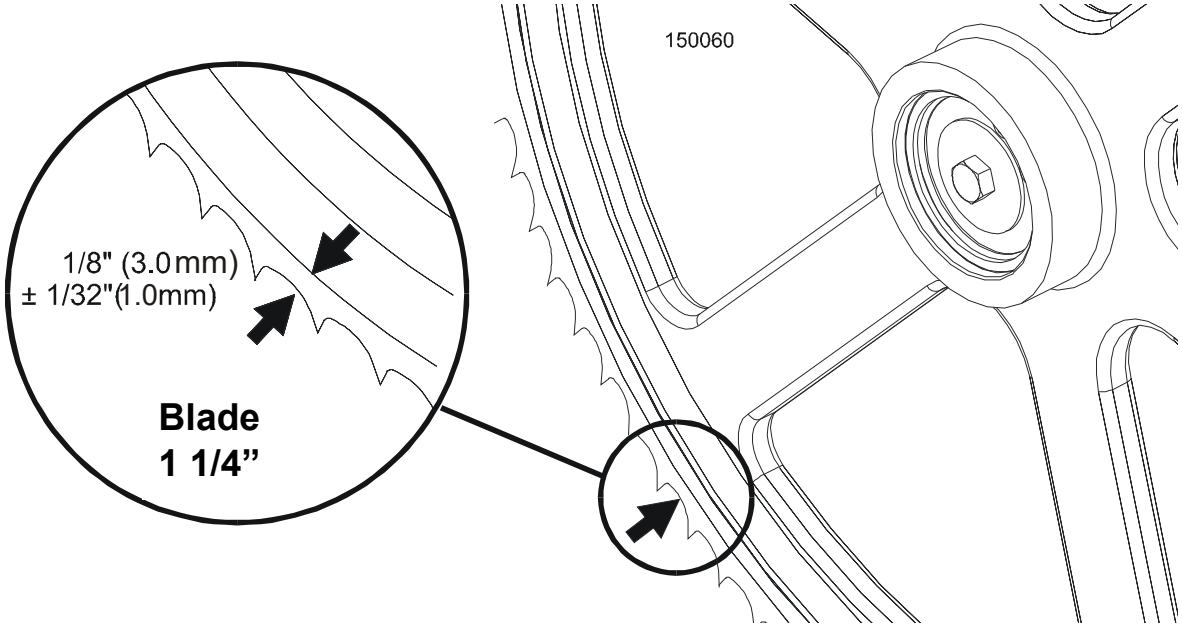


FIG. 5-1

   To adjust where the blade travels on the idle-side and drive-side blade wheel see section below.

5.4 Blade Wheel Alignment

The blade wheels must be square to the sawmill bed and parallel to each other in the vertical and horizontal planes. If the blade wheels are tilted up or down, the blade will not be properly adjusted in relation to the sawmill bed and sawn wood. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels.

Use the blade guide alignment tool to check the vertical alignment of each blade wheel.

1. Attach the tool to the blade near the inner blade guide. Be sure the tool does not rest on a tooth or burr and is lying flat on the table.

See figure 5-2.

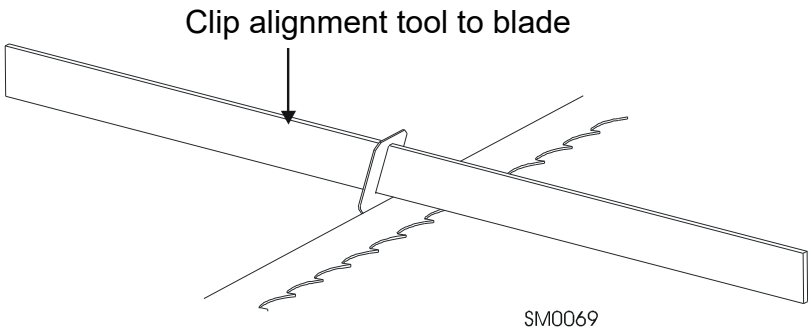


FIG. 5-2

2. Move the saw head so the front end of the tool is positioned over the first bed rail. Measure the distance from the bottom of the tool to the top surface of the bed rail.

3. Move the saw head so the front end of the tool is positioned over the bed rail. Again measure the distance from the bottom of the tool to the bed rail.

4. If the two measurements differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the drive-side blade wheel.

See figure 5-3. Use the screws shown below to adjust the drive blade wheel vertically. To tilt the wheel down, loosen the top adjustment screw a half turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel up, loosen the bottom adjustment screw a half turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

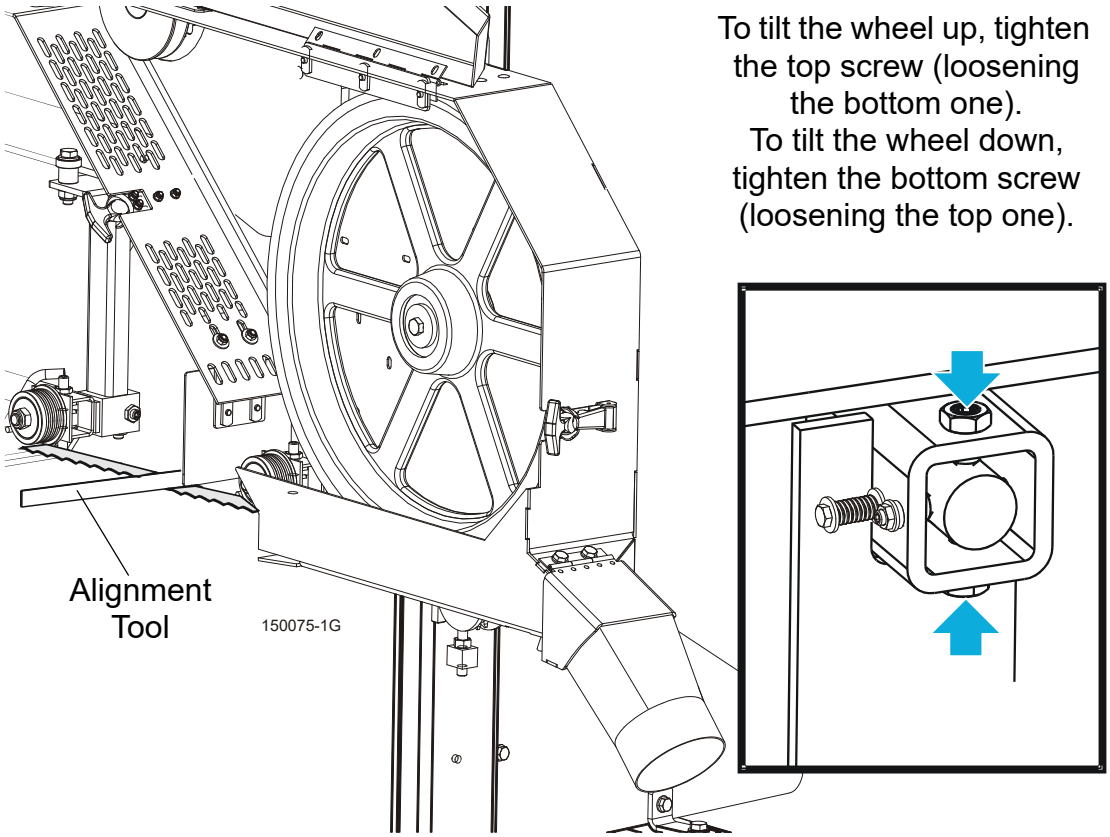


FIG. 5-3

5. Recheck the vertical tilt of the drive-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the bedrail (± 1/16" [1.5 mm]).

6. Remove the tool from the blade and reattach it near the outer blade guide assembly.

7. Measure from the tool to the bed rail at both ends of the tool. If the measurements at the front and rear ends of the tool differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the idle-side blade wheel.

   See figure 5-4. To tilt the idle-side blade wheel up, loosen the lower nut and adjustment screw 1/2 turn, loosen the nut on the upper adjustment screw and tighten the upper screw. Then tighten the upper and lower nut.

   To tilt the idle-side wheel down, loosen the upper adjustment screw 1/2 turn, loosen the nut on the lower adjustment screw and tighten the lower screw. Tighten the upper and lower nut.

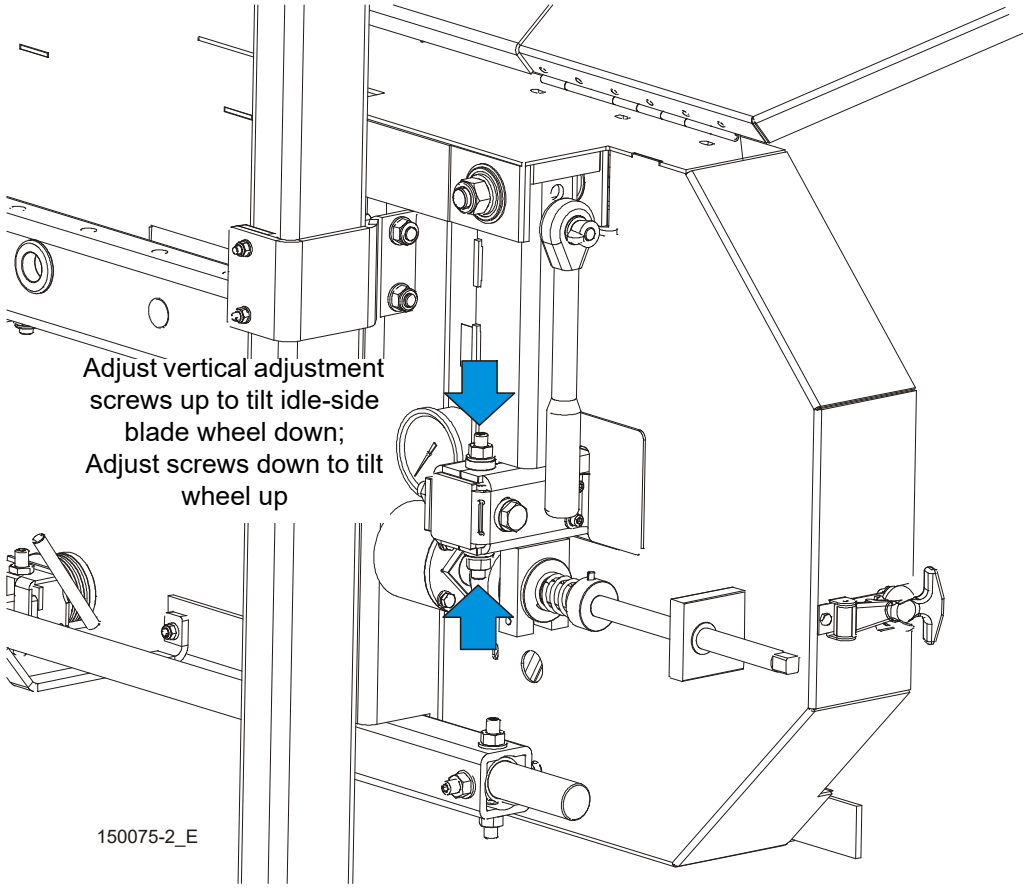


FIG. 5-4

8. Recheck the vertical tilt of the idle-side blade wheel. If it is still incorrect, repeat the adjustment procedure.

9. Check the position of the blade on the idle-side blade wheel.

See figure 5-5. The horizontal tilt of the blade wheel should be adjusted so that the gullet of an 1-1/4" blade is 1/8" (3 mm) out from the front edge of the wheel (±1/32 [0.75 mm]).

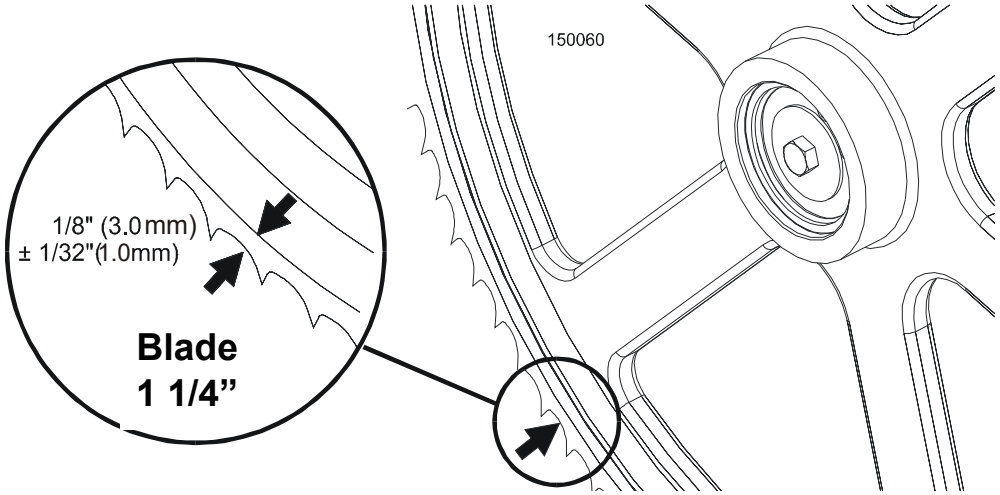


FIG. 5-5

See figure 5-6. Use the cant control adjustment to adjust the idle-side blade wheel. If the blade is too far forward on the wheel, turn the cant control counterclockwise. If it is too far back on the wheel, turn the cant control clockwise.

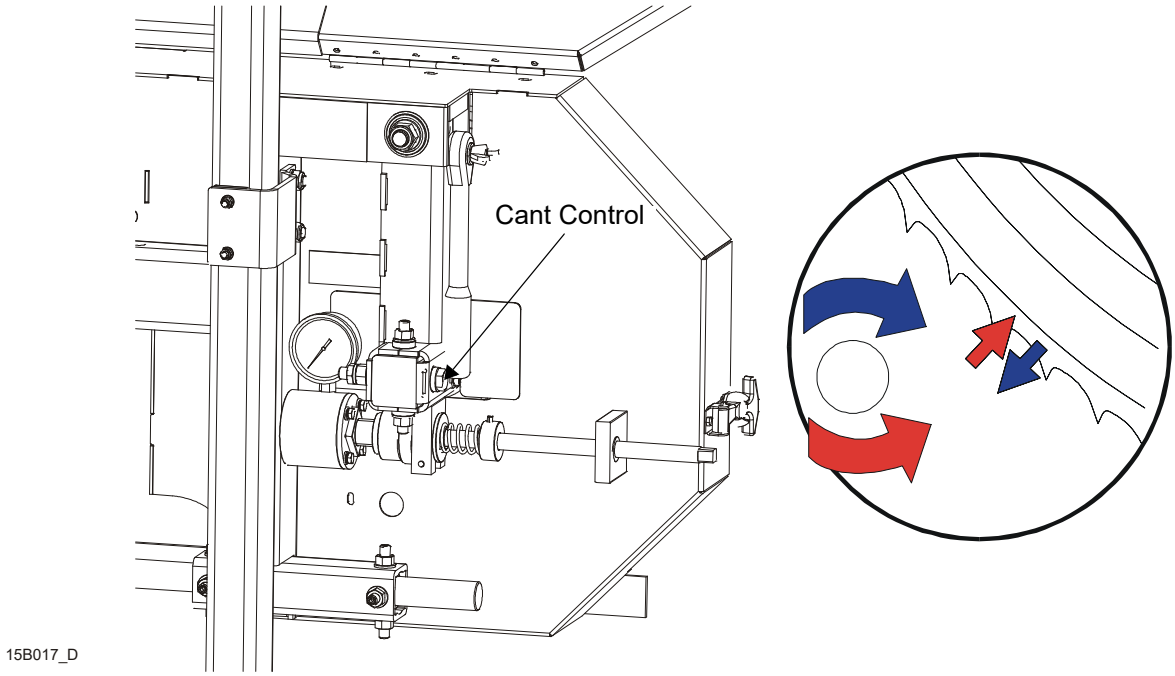


FIG. 5-6

10. Check the position of the blade on the drive-side blade wheel. The blade should be positioned on this wheel as described for the idle blade wheel. If not, adjust the drive wheel horizontally.

See figure 5-7. Use the adjustment screw shown below to adjust the drive-side blade wheel horizontally. First, loosen the nut on this screw. Loosen adjustment screw to move blade out on wheel. Tighten adjustment screw to move blade in on wheel. Be sure to tighten the nut after

adjustment.

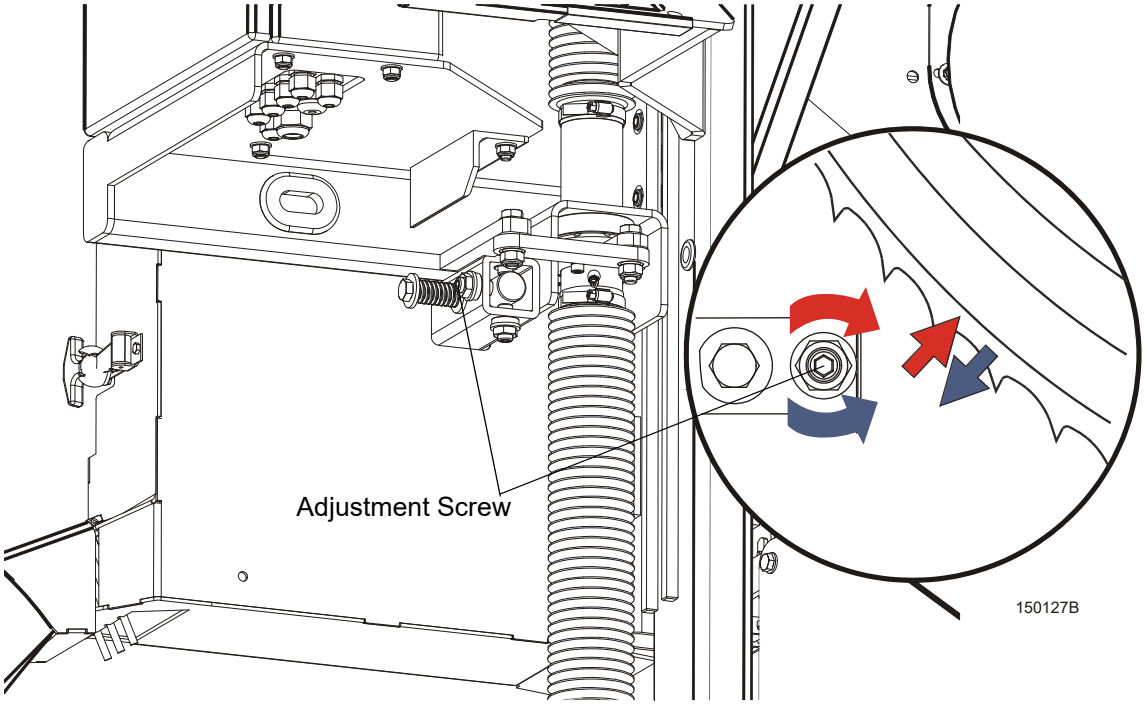


FIG. 5-7

NOTE: It is not necessary to align the spring bolt (bolt M10x75 [WM# F81003-15] + spring + washer) shown in the figure above. When replacing the bolt or spring just screw in the bolt maximally.

5.5 Blade Guide Arm Alignment

Before aligning the blade guide arm, track the blade on the blade wheels as described in *See Section 3.4*. Move the cutting head so the blade is positioned over the first bed rail. Level the blade to the bed rails shown in *See Section* . Adjust the blade guide rollers so they do not touch the blade.

Vertical Alignment

1. Adjust the blade guide arm all the way out away from the other blade guide (maximum distance between the guide rollers).

See figure 5-8.

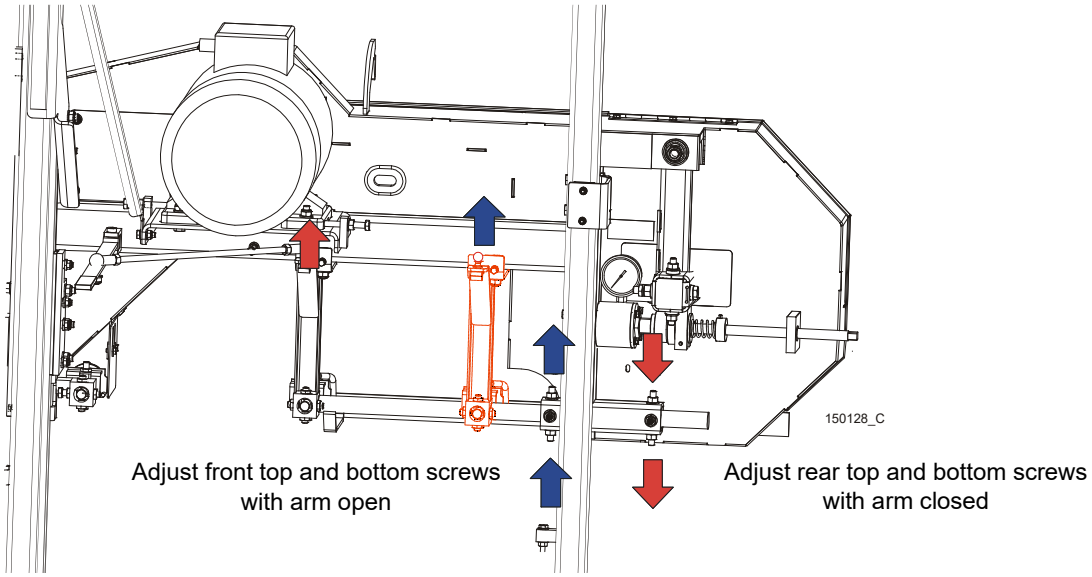


FIG. 5-8

2. Use the arm adjustment screws, marked with blue arrows in the figure above, to adjust the arm up until the slide pad touches the saw head brace tube. Tighten the jam nuts.

3. Adjust the blade guide arm in all the way toward the other blade guide (minimum distance between the guide rollers).

4. Use the arm adjustment screws, marked with red arrows in the figure above, to adjust the arm up until the slide pad touches the saw head brace tube. Tighten the jam nuts.

   NOTE: When adjusting the blade guide arm screws, be careful not to damage their threads or deform the arm guide bushing. Operate the blade guide arm handle to ensure the arm moves easily left and right when the handle is moved.

Horizontal Alignment

See figure 5-9.

1. With the blade guide arm still all the way in toward the other blade guide, tighten all the side screws until they touch the arm. Back the screws off 1/4 turn and tighten the jam nuts.

2. Sight across the horizontal saw head brace to view the blade guide arm. Adjust all side screws on the blade guide arm housing so the arm is parallel to the saw head brace.

3. To move the blade guide end of the arm toward the front of the sawmill, loosen jam nuts on the front inside screw and the rear outside screw. Turn the screws counterclockwise one full turn and tighten the jam nuts. Loosen the jam nuts on the front outside screw and the rear inside screw. Turn the screws clockwise until they touch the arm, back off 1/4” turn, and tighten the jam nuts.

4. To move the blade guide end of the arm toward the rear of the sawmill, loosen jam nuts on the front outside screw and the rear inside screw. Turn the screws counterclockwise one full turn and tighten the jam nuts. Loosen the jam nuts on the front inside screw and the rear outside screw. Turn the screws clockwise until they touch the arm, back off 1/4” turn, and tighten the jam nuts.

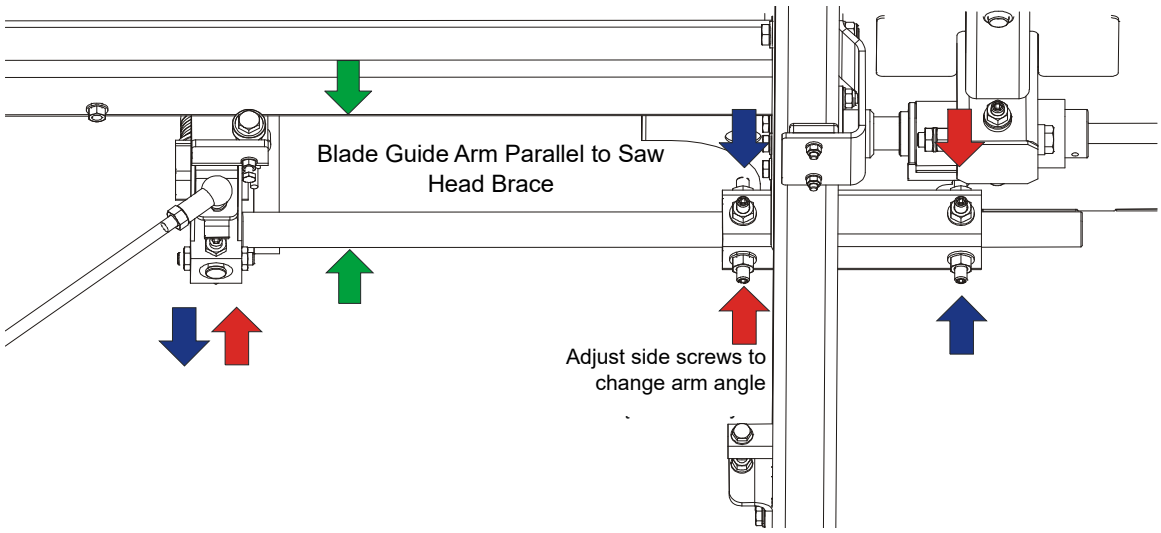


FIG. 5-9

5.6 Aligning The Blade Guides

Each Wood-Mizer sawmill has two blade guide assemblies that help the blade maintain a straight cut. The two blade guide assemblies are positioned on the saw head to guide the blade on each side of the material being cut.

One blade guide assembly is mounted in a stationary position on the drive side of the saw head. This assembly is referred to as the "inner" blade guide assembly.

The other blade guide assembly is mounted on the idle side of the saw head. It is referred to as the "outer" assembly and is adjustable for various widths of materials to be processed.

Blade guide alignment includes four steps:

- Blade Deflection
- Blade Guide Vertical Tilt
- Blade Guide Flange Spacing
- Blade Guide Horizontal Tilt

Perform the blade guide alignment after you have aligned the blade on the wheels and adjusted the blade and blade guide arm parallel to the bed rails. After blade guide alignment, check the scale indicator to make sure it is adjusted properly.

5.7 Blade Deflection

Perform the following steps to achieve proper blade deflection with the blade guides:

1. Raise the saw head until the blade is 15" (375 mm) above a bed rail. Measure the actual distance with a tape from the top of the rail to the bottom of the blade.

   See figure 5-10.

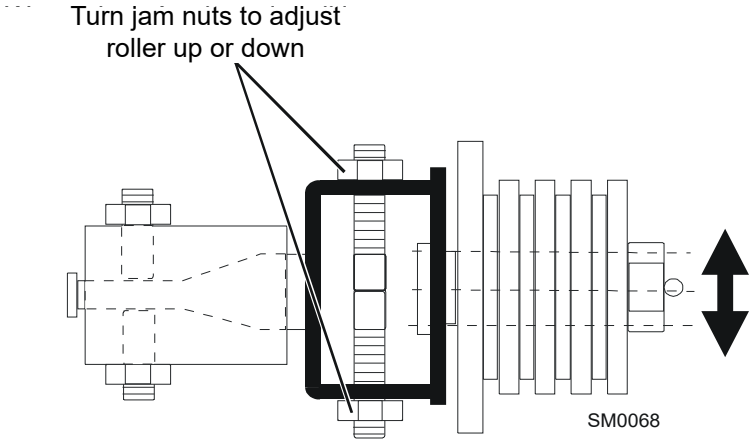


FIG. 5-10

2. Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down 6 mm.

3. Repeat for the other blade guide.

   NOTE: Be sure the blade guard clears the blade on both guide assemblies. The guard on the outer guide assembly should be checked with the arm all the way in and all the way out.

5.8 Blade Guide Vertical Adjustment

Check that the blade guides does not tilt the blade up or down. A Blade Guide Alignment Tool is provided to help you measure the vertical tilt of the blade.

1. Open the adjustable blade guide arm 1/2" (15 mm) from full open.

2. Attach the alignment tool to the blade. Position the tool close to a blade guide roller. Be sure the tool does not rest on a tooth or burr and is lying flat on the blade.

See figure 5-11.

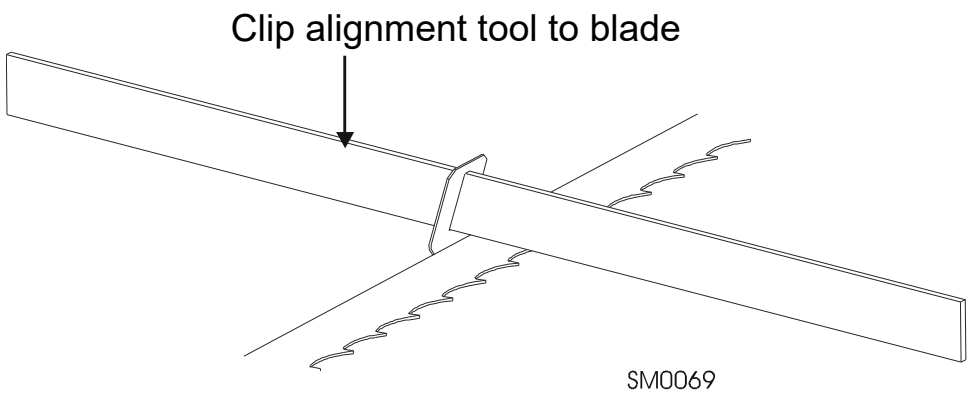


FIG. 5-11

3. Measure the distance from the bottom of the tool to the bed rail.
4. Move the saw head so that the front end of the tool is positioned above the bed rail.
5. Again measure the distance from the bottom of the tool to the bed rail.
6. The two measurements should be the same. If they are not, loosen one side set screw of the guide assembly and adjust the blade guide in the vertical plane using the screws shown in Figure 6-12.

See figure 5-12.

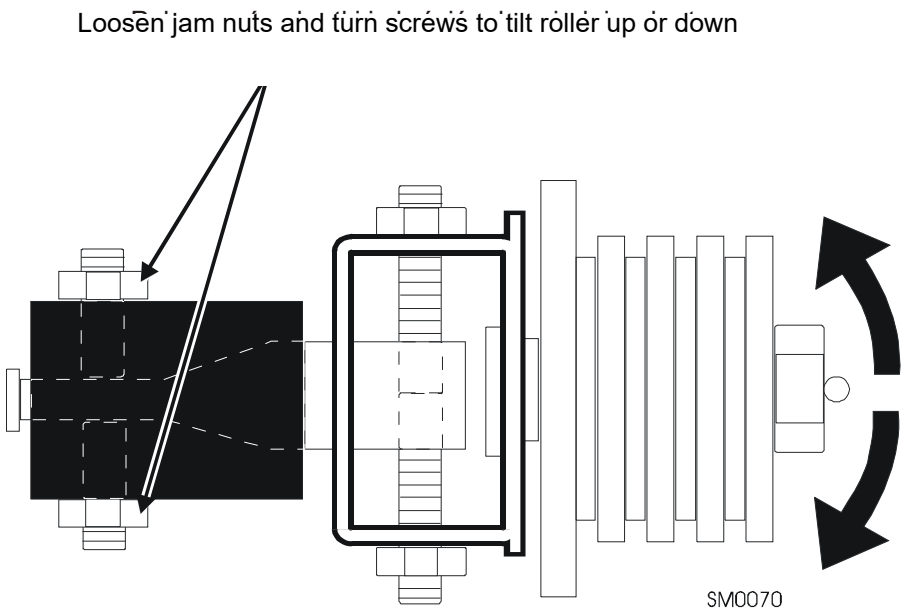


FIG. 5-12

7. Move the saw head forward so the back end of the tool is over the bed rail. Measure the distance between the tool and the bed rail.

8. This measurement should equal the two earlier measurements. If it is not the same, adjust the blade guide using the screws shown in the figure above.

9. Move the tool close to the other blade guide and repeat the previous steps.

   NOTE: If any adjustments to blade guide tilt were made, make sure the blade deflection is correct (6 mm).

   NOTE: After adjusting the blade guide spacing, start the blade drive for a moment. Then stop the blade and check again if the blade guides are properly positioned.

5.9 Blade Guide Spacing

HINT: When adjusting blade guide spacing, loosen the top set screw and one side set screw only. This will ensure horizontal and vertical adjustments to the blade guide tilt are maintained when the set screws are retightened.

1. Adjust the inner blade guide so the blade guide flange is approximately 1/16" - 1/8" (1.5 - 3.0 mm) from the back of the blade.

2. Loosen one side and one top set screw shown. Tap the blade guide forward or backward until properly positioned.

   See figure 5-13.

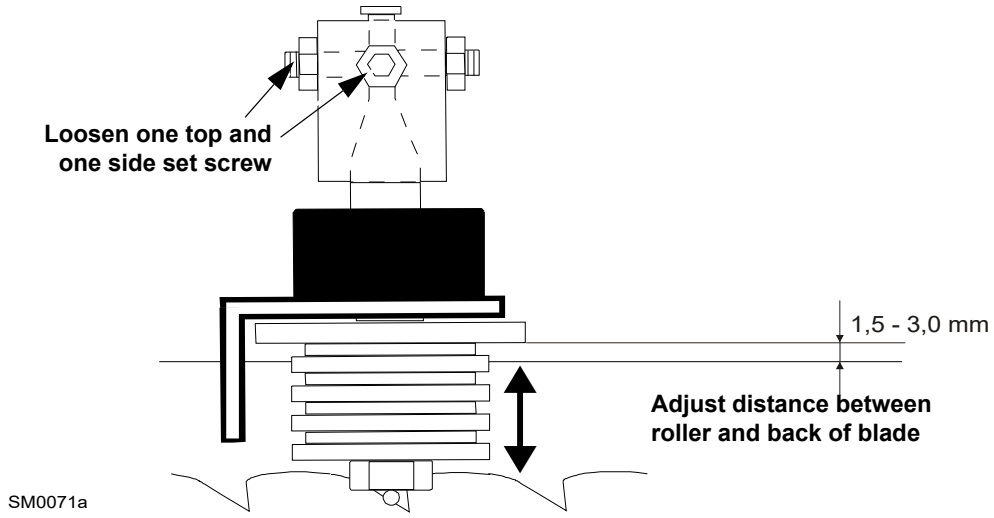


FIG. 5-13

3. Tighten the set screws.

4. Adjust the outer blade guide in the same way.

   NOTE: After adjusting the blade guide spacing, start the blade drive for a moment. Then stop the blade and check again if the blade guides are properly positioned.

5.10 Horizontal Tilt Adjustment

1. Adjust the blade guide arm half way in.

   See figure 5-14.

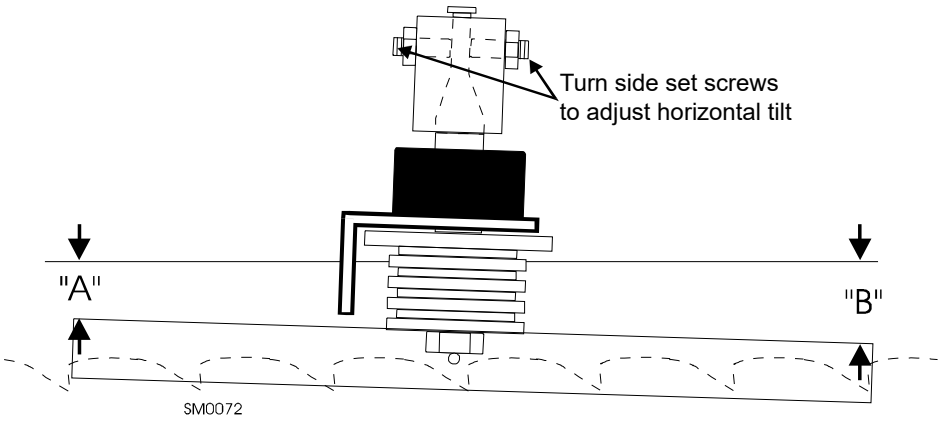


FIG. 5-14

2. Place the Blade Guide Alignment Tool against the face of a blade guide roller and center it on theroller as shown above.

3. Measure the distance between the back edge of the blade and the ruler at the end closest to the inner blade guide ("B").

4. Measure between the back edge of the blade and the other end of the tool ("A").

5. The blade guide roller should be parallel to the blade (A=B) or slightly tilted in the horizontal plane asshown in Figure 6-14 (A=B-6 mm). If this condition is not met, adjust the roller in the horizontal plane using the side set screws on the blade guide (see figure above).

6. Repeat the above steps for the inner blade guide.

   NOTE: Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade.**See Blade Handbook, Form #600.**

5.11 Side supports

Logs and boards are clamped against the side supports when sawing. The side supports must be square to the bed to ensure square lumber.

Perform the following steps:

1. Place a flat board across the bed rails.

See figure 5-15.

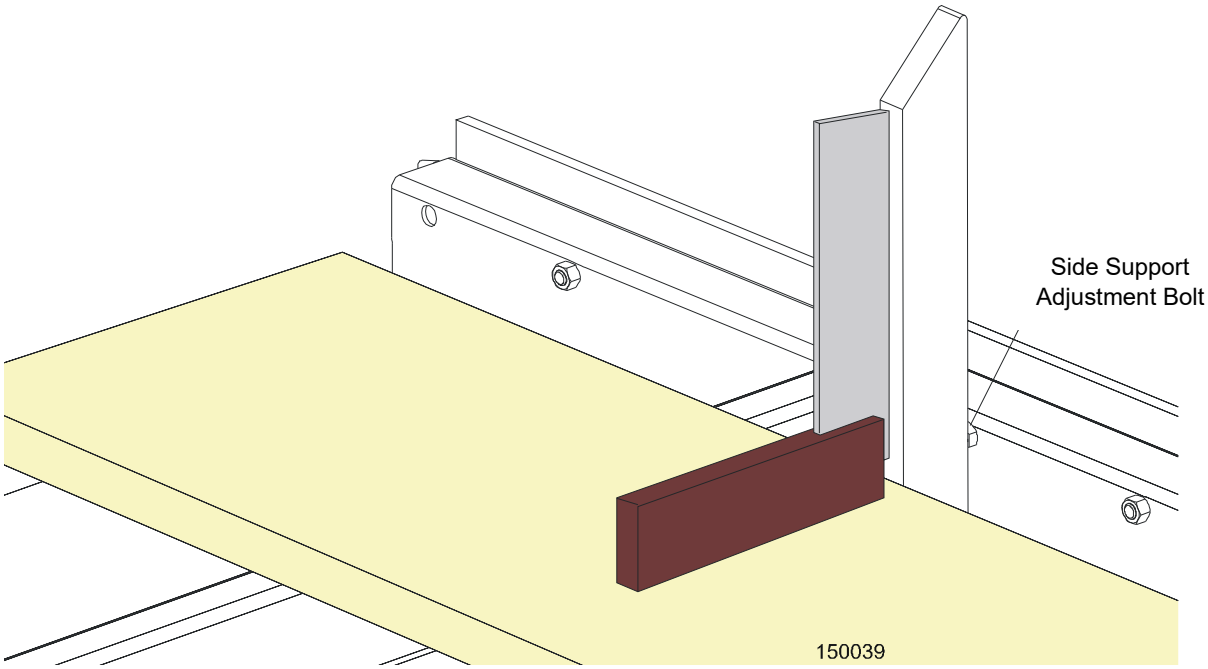


FIG. 5-15

2. Swing a side support up so that it is vertical.
3. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.
4. Check the angle of each support with a square on the board.
5. The side support should be 90° to the bed rails. If it does not, use the adjustment bolt shown on the figure 6.15 to adjust the side support. Turn the adjustment bolt counterclockwise to tilt the top of the side support forward.
6. Repeat for the remaining side supports.

5.12 Blade Height Scale Adjustment

After the entire sawmill has been aligned and all adjustments made, check that the blade height scale indicates the true distance from the blade to the bed rails..

See figure 5-16.

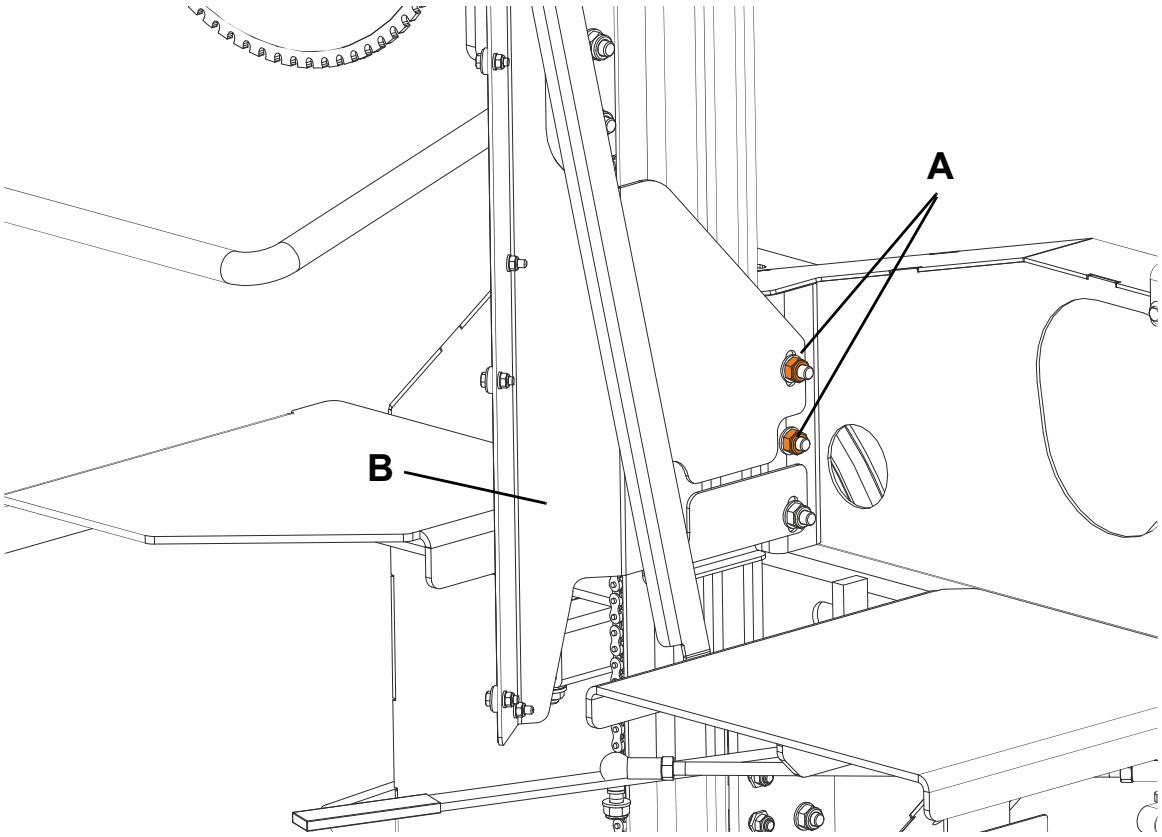


FIG. 5-16

1. Move the saw head so the blade is positioned directly above one of the bed rails. Measure from the bottom edge on a down-set tooth of the blade to the top of the bed rail (or stainless steel bed rail cover).

2. Loosen the nuts on the scale mounting bolts shown in the figure above (A) and move the scale bracket (B) until the scale indicator is aligned with the correct mark on the scale. Retighten the nuts on the scale mounting bolts.

   For example, if the measurement from blade to bed rail was 14 3/4" (375 mm), make sure the indicator reads 14 3/4" (375 mm) on the scale.

5.13 Motor Drive Belt Adjustment

See figure 5-17. Loosen the motor mounting bolts. Using the adjustment bolts shown below, adjust the drive belt until it has 7/16" (11 mm) deflection with a 16 lbs (7.2 kG) deflection force - in the case

of E15 motor. Retighten the engine mounting bolts.

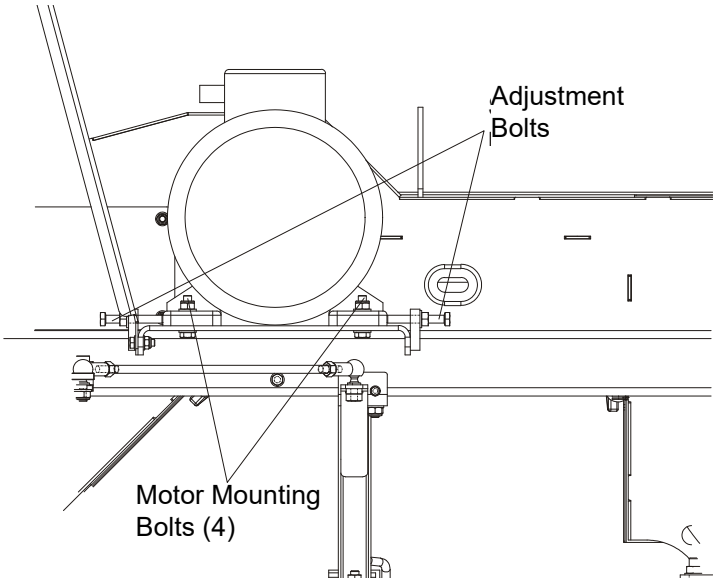


FIG. 5-17

5.14 Track Roller Distance Adjustment

Using the screw (1), adjust the distance between the track roller (2) and the track rail (3) so that the mast can move freely. The distance should be about 0.5 mm.

See figure 5-18.

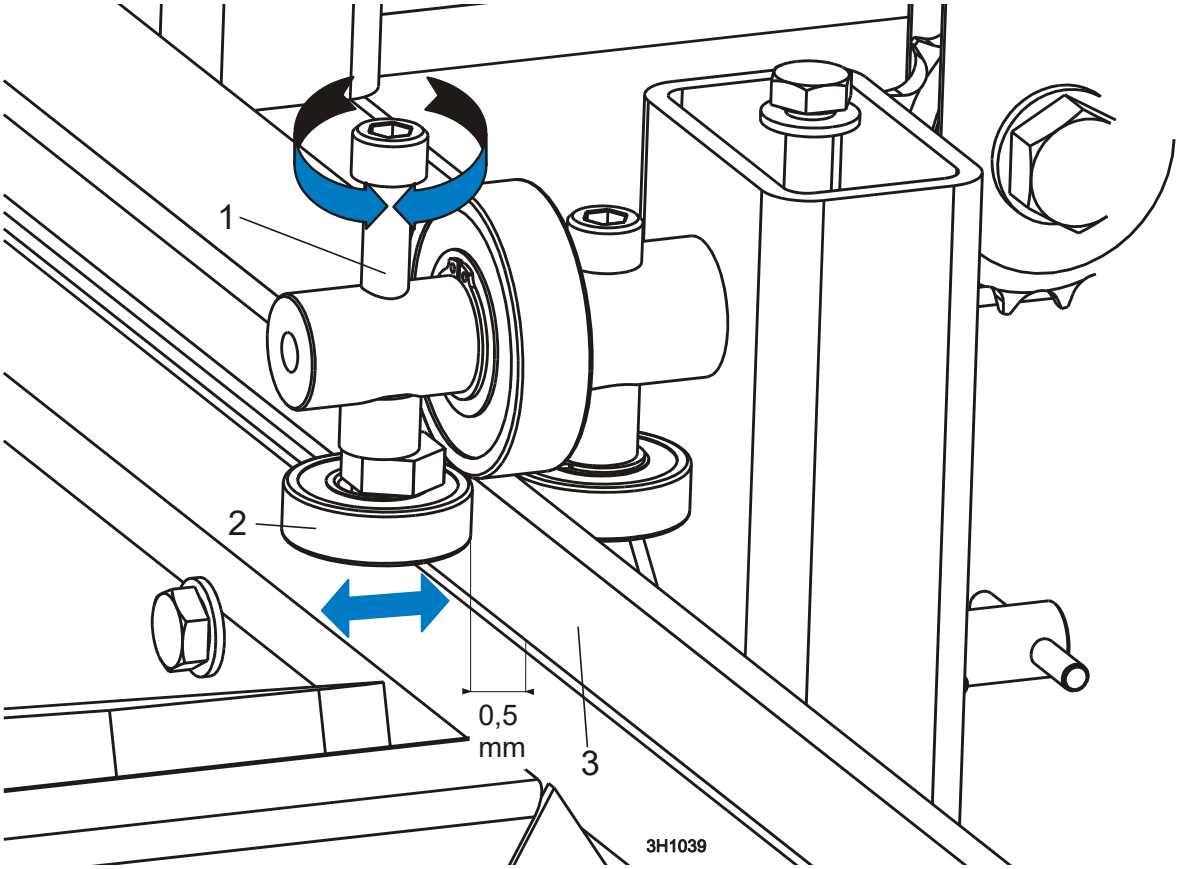


FIG. 5-18

Wood-Mizer
from forest to final form

EC declaration of conformity

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

Manufacturer:

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

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

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

We, the undersigned herewith declare, that:

Designation of the machine:	**SAWMILL**
Model:	LT15
TYPE:	……
Serial Number:	……..…
VIN Number:	……
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 1807-2:2013-08 PN-EN ISO 13849-1:2016-02 PN-EN 60204-1:2018-12
Notified Body according to annex IV:	Sieć Badawcza Łukasiewicz Krakowski Instytut Technologiczny Zakopiańska 73 30-418 Kraków
Notification No.:	1455
EC type-examination certificate no.	1455-MD-016/24
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, 10.04.2024
Title:	Engineering Manager

Wood-Mizer
from forest to final form

EC declaration of conformity

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

Manufacturer:

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

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Model:	LT15
TYPE:	……
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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, 10.04.2024
Title:	Engineering Manager