

# Wood-Mizer®

*from forest to final form*



## user manual

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

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**Wood-Mizer®**

**Edger**

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

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**EG350EH15S, EG350EH22S rev. A2.01**

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

*Form #350*

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## Getting Service

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

### *General Contact Information*

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

### **Office Hours:**

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

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

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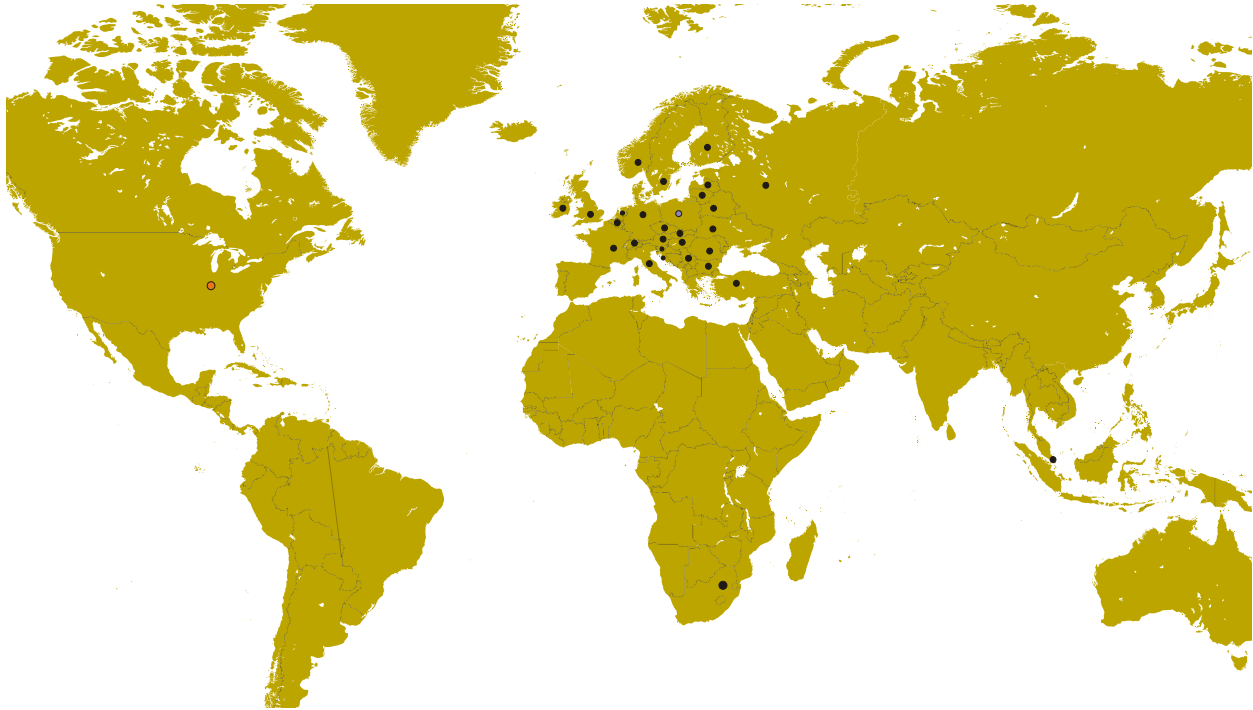
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Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

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## SECTION 1 SERVICING THE EDGER

### 1.1 General Information

This documentation includes information on preparing the edger for operation and operating, servicing and repairing the machine.

The EG350 Edger is designed for sawing wood only (see the "Specifications" section in this manual for maximum wood dimensions). The machine must not be used for other purposes, such as cutting ice, metal or other materials.

Using the machine correctly you will achieve high degree of accuracy and rate of efficiency.

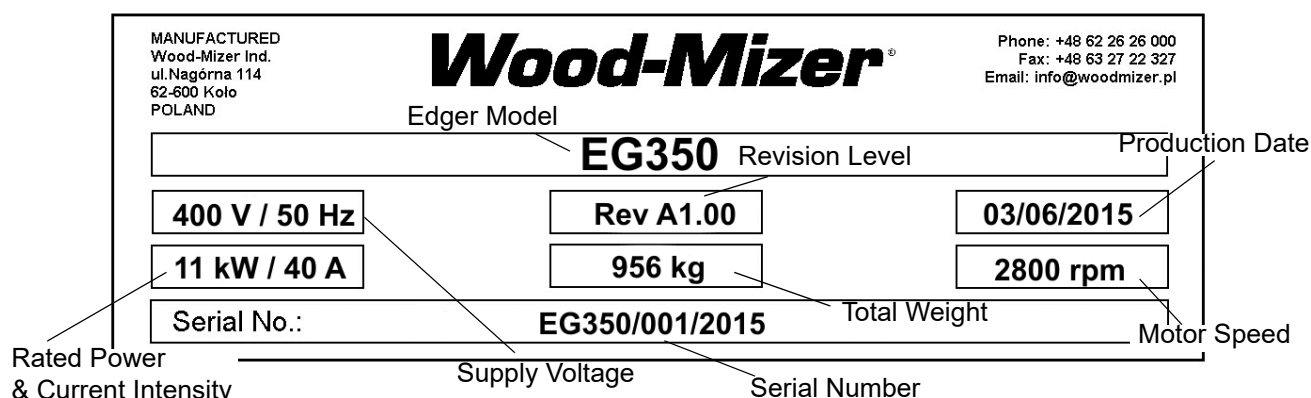
The edger should be operated only by an adult (a person who have attained the age of 18 years) who have read and understood the entire operator's manual. The edger is not intended for use by or around children.

The machine is built to be durable and easy to operate and maintain.

### 1.2 Customer and Edger Identification

Each Wood-Mizer edger has a serial number. In addition, when you pick up your edger, you will receive a customer number. These two numbers will help expedite our service to you. Please locate them now and write them below so you have quick and easy access to them.

**See Figure 1-1** The figure below shows an exemplary identification plate of the EG350 Edger.



**FIG. 1-1**

# 1

## Servicing the Edger

### Customer and Edger Identification

See Figure 1-2 See the figure below for location of the serial number.

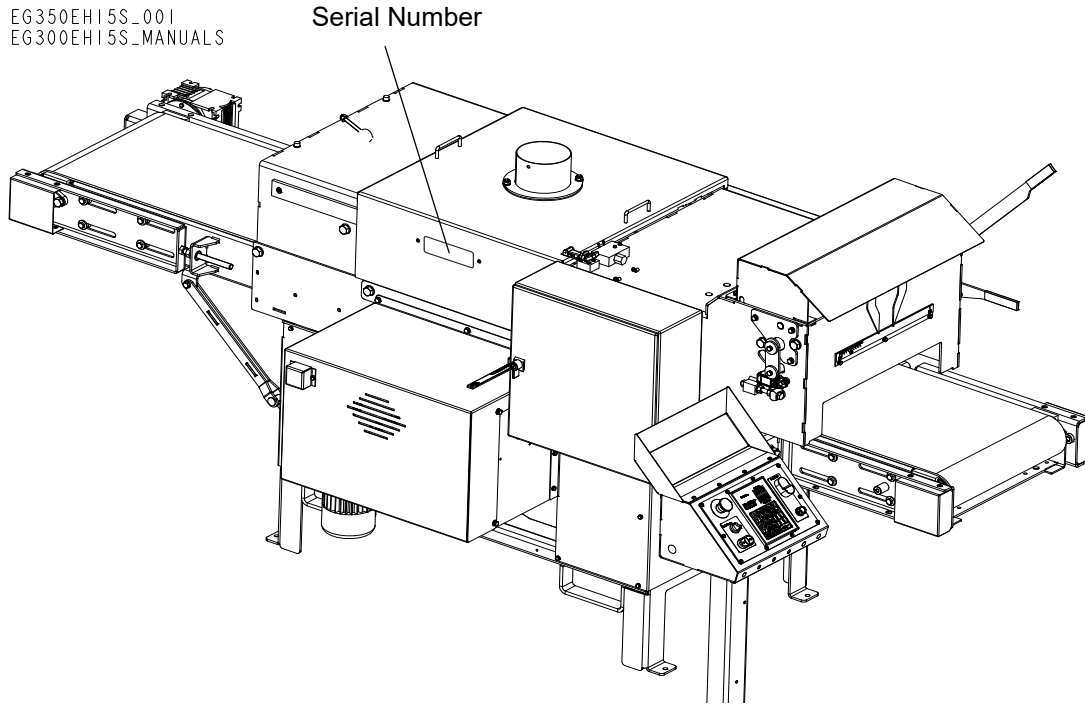
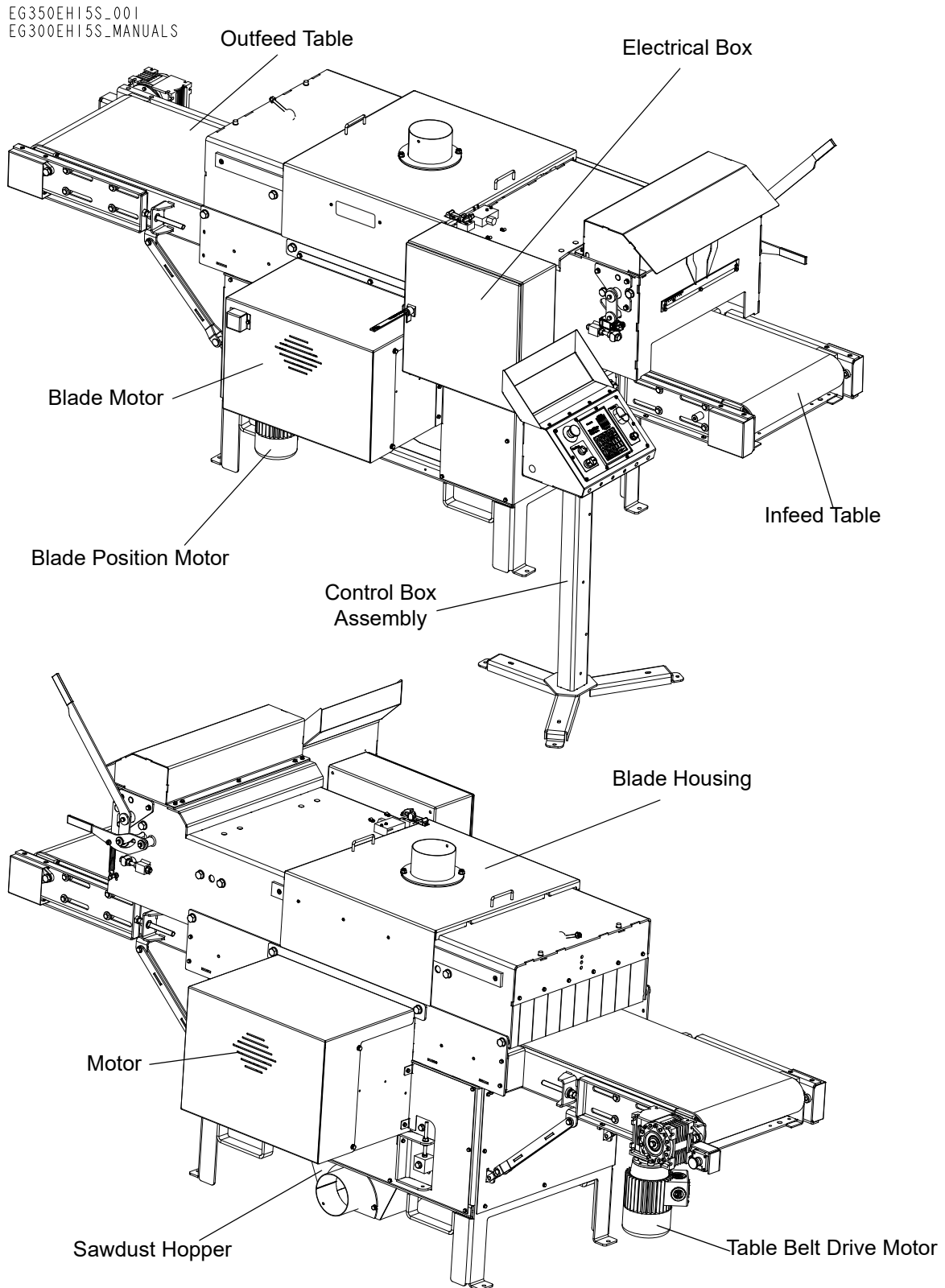


FIG. 1-2

### 1.3 Edger Components

See Figure 1-3 The major components of the EG350 Edger are shown below.





**FIG. 1-3 EG350**


## SECTION 2 SAFETY


### 2.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal 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 or damage to equipment.

 **IMPORTANT!** indicates vital information.


**NOTE:** gives helpful information.

 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.

### 2.2 Safety Instructions

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

#### *Observe Safety Instructions*

 **IMPORTANT!** Read the entire Operator's Manual before operating the edger. 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 any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

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

**IMPORTANT!** It is always the 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 edger. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the edger.

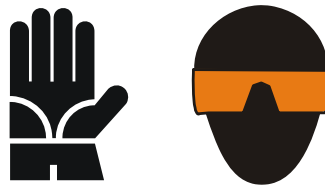


### **Wear Safety Clothing**



**WARNING!** Secure all loose clothing and jewelry before operating the machine. 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 protective gloves (compatible with EN 388, Category III) and protective apron (compatible with EN ISO 13688:2013-12, kategorie I) when operating the machine.

**WARNING!** Always wear ear, respiration, hand and foot protection when operating or servicing the edger.



### Keep Edger and Area Around Clean



**DANGER!** Maintain a clean and clear path for all necessary movement around the edger 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.

**CAUTION!** The work-stand of the edger should be equipped with a 4 kg or bigger dry powder extinguisher.

### Check Edger Before Operation



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



**WARNING!** Always shut off the motor to stop the blade whenever the edger is not in use. Failure to do so may result in serious injury.

**WARNING!** Do not for any reason adjust the motor drive belts with the motor running. Doing so may result in serious injury.

**WARNING!** Always ensure that there are sharp points on the anti-kickback fingers before each use of the edger.

Be sure the anti-kickback fingers are free from obstruction and are in a downward position with the lever released. Failure to do so may result in serious injury.

### **Keep Persons Away**



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

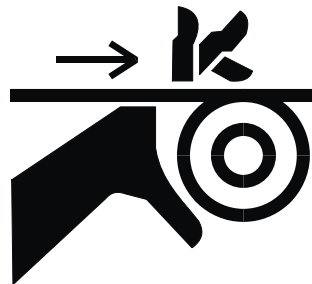
### **Keep Hands Away**



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

**DANGER!** Moving Parts Can Crush and Cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating or towing. 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!** Coastdown Required. Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

**WARNING!** Kickback hazard. Stay clear of area during operation. Follow all anti-kickback service and safety rules. Failure to do so may result in serious injury.



**DANGER!** Before changing the blades or performing any service to the machine, disconnect the power cord from the electric box.

**IMPORTANT!** The blade housing and drive assembly covers are equipped with safety key switches. As soon as you open the cover, the motor will get turned off and all moving parts will stop spinning. The safety switches should always be in proper working condition.

**IMPORTANT!** The blade setting system is equipped with two limit switches.

### *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 boxes 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 machine operation.



**WARNING!** Consider all electrical circuits energized and dangerous.

**WARNING!** Disconnect and lock out power supply before servicing! Failure to do so may result in serious injury.



**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.



**IMPORTANT!** The EG350 Edger is equipped with two emergency stop buttons - one at the front, the other at the rear of the machine. They are used to immediately stop the motor and/or edger operation in hazardous situations. The emergency stop buttons should always be in proper condition.



**WARNING!** Visible and/or invisible laser radiation. Avoid eye or skin exposure to direct or scattered radiation.



**WARNING!** Do not replace the factory-installed laser sight with any different laser sight, or mount any additional laser devices.



**DANGER!** The operator must not for any reason perform any service or repairs to the laser sight. All necessary repairs to this equipment must be done by the manufacturer or an authorized person only.

### ***Keep Safety Labels in Good Condition***



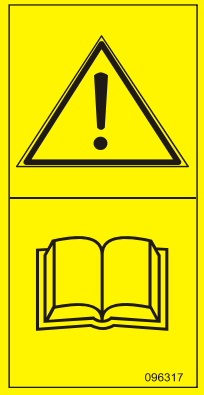

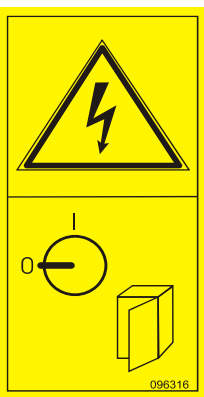
**IMPORTANT!** Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order new decals.

**IMPORTANT!** If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed.

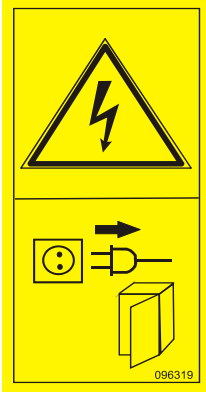



**Safety Labels Description**

See Table 2-1 See table below for safety labels description.






**TABLE 2-1**

Label View	Label Number	Description
	096317	CAUTION! Read thoroughly the manual before operating the edger. Observe all safety instructions and rules when operating the machine.
	099220	Close all guards and covers before starting the machine.
	096316	Do not open the electric box when the switch <b>is not</b> in the "0" position.

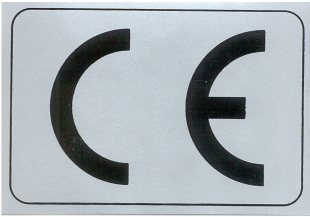
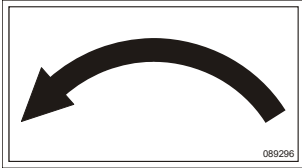
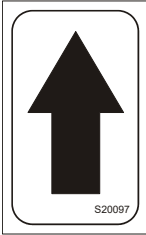
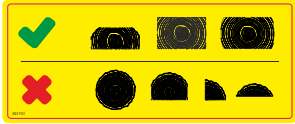
**TABLE 2-1**

	<p>096319</p>	<p>Always disconnect the power cord before opening the electric box.</p>
	<p>099540</p>	<p>CAUTION! Toothed gear - keep persons away!</p>
	<p>S12004G</p>	<p>Always wear safety goggles when operating the machine!</p>
	<p>S12005G</p>	<p>Always wear protective ear muffs when operating the edger!</p>

**TABLE 2-1**

	<p>501465</p>	<p>Always wear safety boots when operating this machine.</p>
	<p>510080</p>	<p>Always wear protective gloves when operating the edger!</p>
	<p>539211</p>	<p>Always wear protective apron when operating the edger!</p>
	<p>501467</p>	<p>Lubrication point</p>
	<p>099504</p>	<p>Visible and/or invisible laser radiation. Avoid eye or skin exposure to direct or scattered radiation.</p>

**TABLE 2-1**

	<p>P85070</p>	<p>CE certified machine</p>
	<p>089296</p>	<p>Revolutions direction</p>
	<p>S20097</p>	<p>Motor revolutions direction</p>
	<p>551701</p>	<p>Allowable and non-allowable shapes of sawn material</p>

## SECTION 3 OPERATION

### 3.1 Pre-Operation Check

Before operating the edger, always perform the following basic checks:

1. Make sure the machine is level. Then secure the edger legs to the floor. To do this, prepare a concrete foundation and use 12 mm diameter anchor bolts.



**CAUTION!** Always make sure the edger is level prior to operating. Failure to level the machine will affect machine operation and wear life.

2. Make sure the tables are level with the rest of the edger.
3. Be sure the anti-kickback fingers are in proper working condition.



**WARNING!** Always make sure that there is a sharp point on the anti-kickback fingers before each use of the edger.

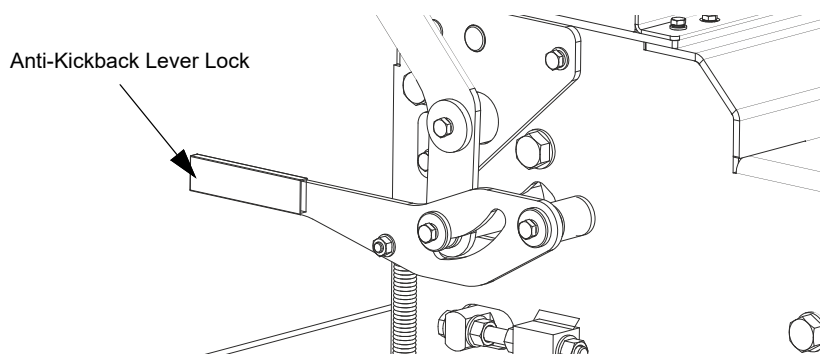
Be sure the anti-kickback fingers are free from obstruction and are in a downward position with the lever released. Failure to do so may result in serious injury.



**WARNING!** If the drive belt breaks, wait until all moving parts stop. Failure to do so may result in serious injury or death.



**WARNING!** Make sure the anti-kickback lever lock is in the operation position so that the anti-kickback fingers cannot be raised with the anti-kickback lever. This position is shown in the figure below.



**FIG. 3-1**

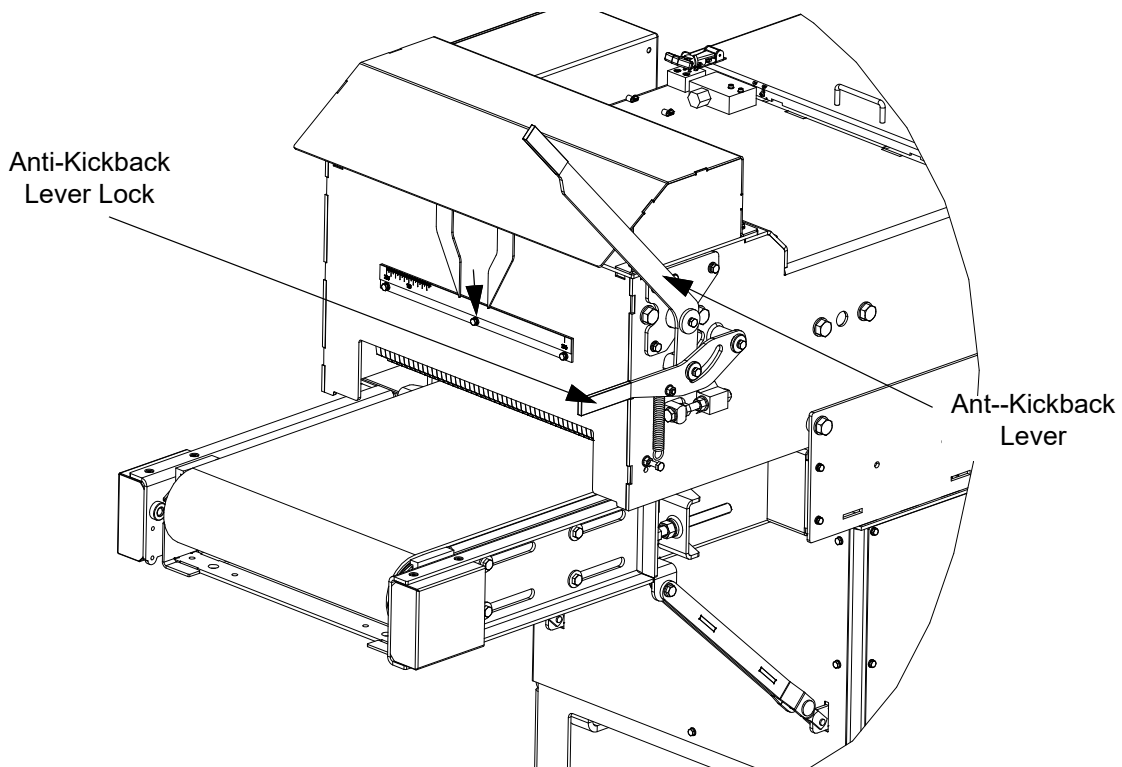




FIG. 3-2


4. Be sure all guards and covers are in place and secured.

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

5. Also be aware that the blades are spinning whenever the motor is started. You should always turn off the motor to stop the blade whenever the edger is not in use and ensure that all parts have stopped moving before removing any covers or guards.

 **WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

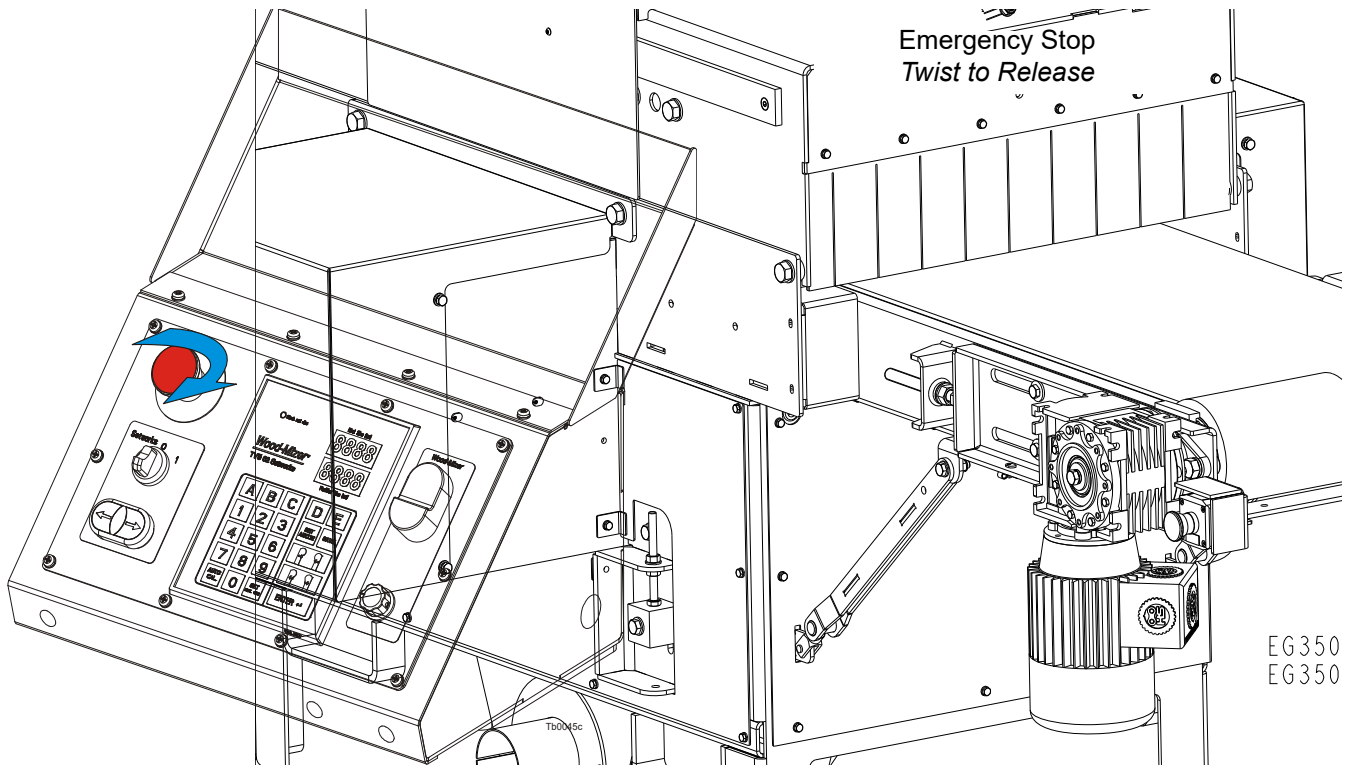
**WARNING!** Always shut off the motor to stop the blade whenever the edger is not in use. Failure to do so may result in serious injury.

 **IMPORTANT!** If at any time you need to immediately stop the motor and/or operation of the edger, press either emergency stop button of

# 3 Operation

## Pre-Operation Check

the machine.



**FIG. 3-3 EG350 E-STOP BUTTON LOCATION**



## 3.2 Control Overview

### EG350 Control Panel

See **Figure 3-4**. The following controls are located on the EG350 control panel: START/STOP switch, Networks, feed rate knob, Networks switch, emergency stop button and additional buttons for setting the moving blade.

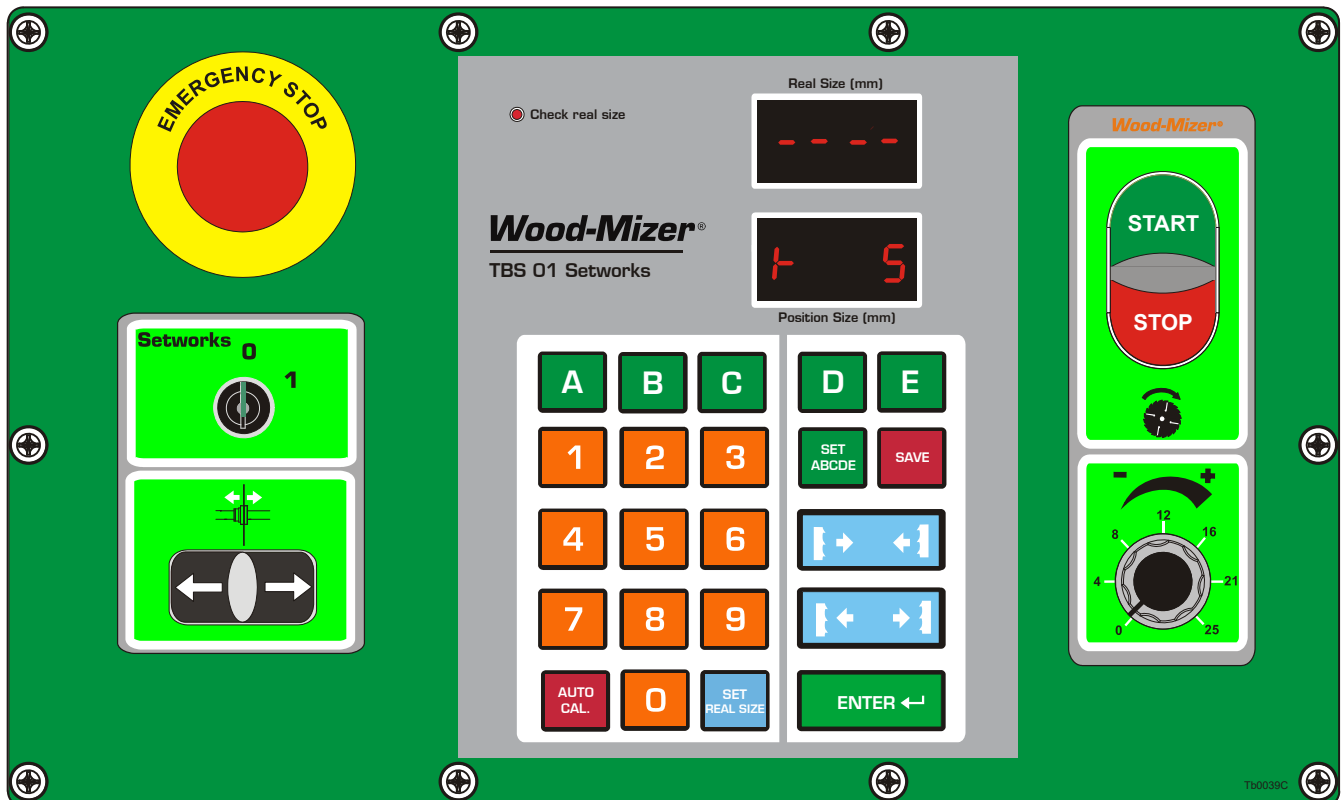


FIG. 3-5 EG350 CONTROL PANEL

#### 1. Blade Drive



To start the blade motor, press the START button. To stop the blade drive, press the STOP button.

#### 2. Feed Rate Adjustment



The feed rate knob controls the speed at which the table belt moves. To increase this speed, turn the knob right. To reduce the speed, turn the knob left.

#### 3. Edger Networks

This controller allows the operator to automatically set the desired cutting width (distance between the blades). [See SECTION 4 SETWORKS OPERATION.](#)

#### 4. Emergency Stop Button

Push the emergency stop button to stop the blade and feed motors. Turn the emergency stop clockwise to release the stop. The machine will not restart until the emergency stop is released.

### 3.3 Edger Setup



**IMPORTANT!** Before starting to use the edger, you have to meet the following conditions:

- Set up the machine on firm and level ground.
- When your EG350 edger is used indoors, it must be operated with a sawdust exhaust system connected.
- The EG350 edger must not be used outdoors when it is raining/snowing. In such a case, the machine must be placed under a roof or indoors.
- The machine should work in temperatures of  $-15^{\circ}\text{C}$  to  $40^{\circ}\text{C}$  ( $5^{\circ}\text{F}$  to  $104^{\circ}\text{F}$ ) only.
- The light intensity in the operator's work-place must be 300 lux<sup>1</sup>.
- The work-places for two operators of the edger are shown in the figure below.

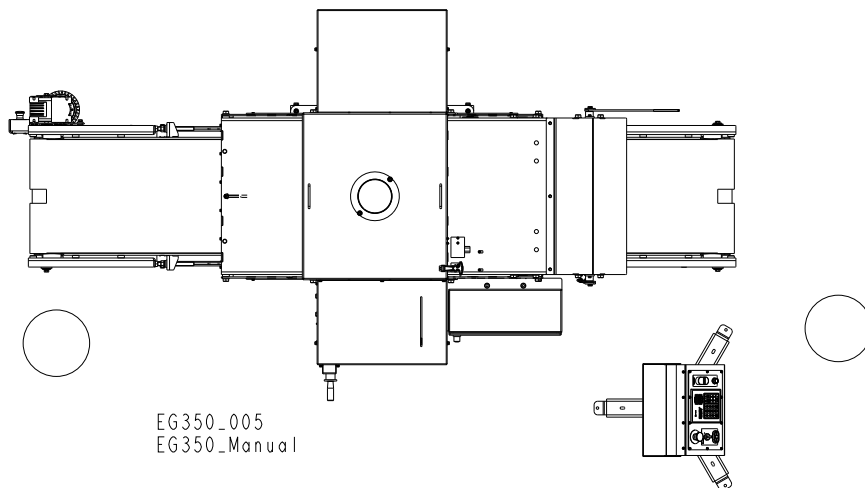



FIG. 3-6


<sup>1</sup> The light source cannot cause the stroboscopic effect.


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

3 Phases V	Fused Disconnect Switch	Recommended Wire Size
400 VAC	40 A	4 mm <sup>2</sup> , maximum length: 15 m

**TABLE 3-1**

 **IMPORTANT!** It is recommended that the electrical system be equipped with a 30mA Ground Fault Interrupter.

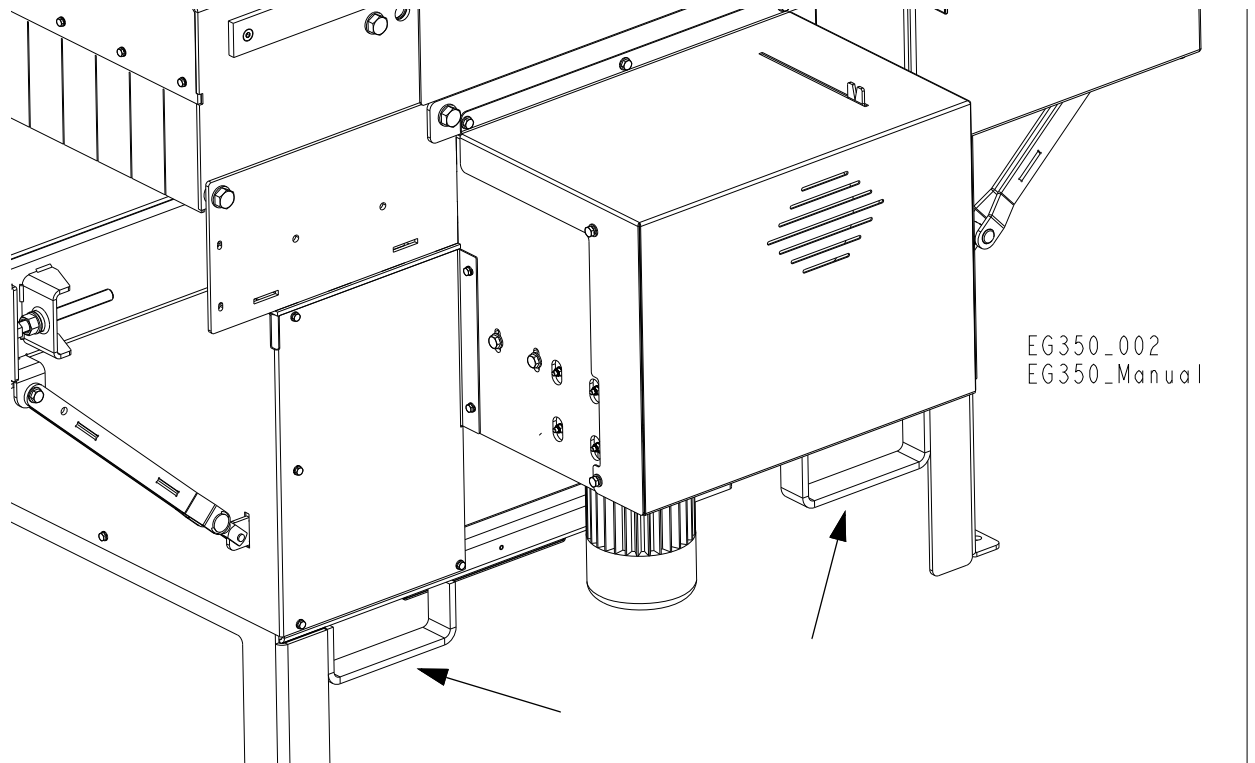
 **IMPORTANT!** When starting the machine for the first time, check that the blade rotation direction is as indicated by the arrow located on the blade housing. If the rotation direction is incorrect, invert the phases in the phase inverter located in the power socket (electric box). Setting the phases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

 **IMPORTANT!** When starting the machine for the first time, let it run without any load for 1-2 hours so that the drive components of the infeed and outfeed tables break in.

# 3


## Operation Edger Setup

- The EG350 Edger can be lifted using a forklift only. The forklift must be rated for at least 2000kg (4409 lb). To lift the machine, first remove the sawdust hopper. Then insert the forks into the forklift pockets shown in the figure below.



**FIG. 3-7**

### 3.4 Edger Start-Up

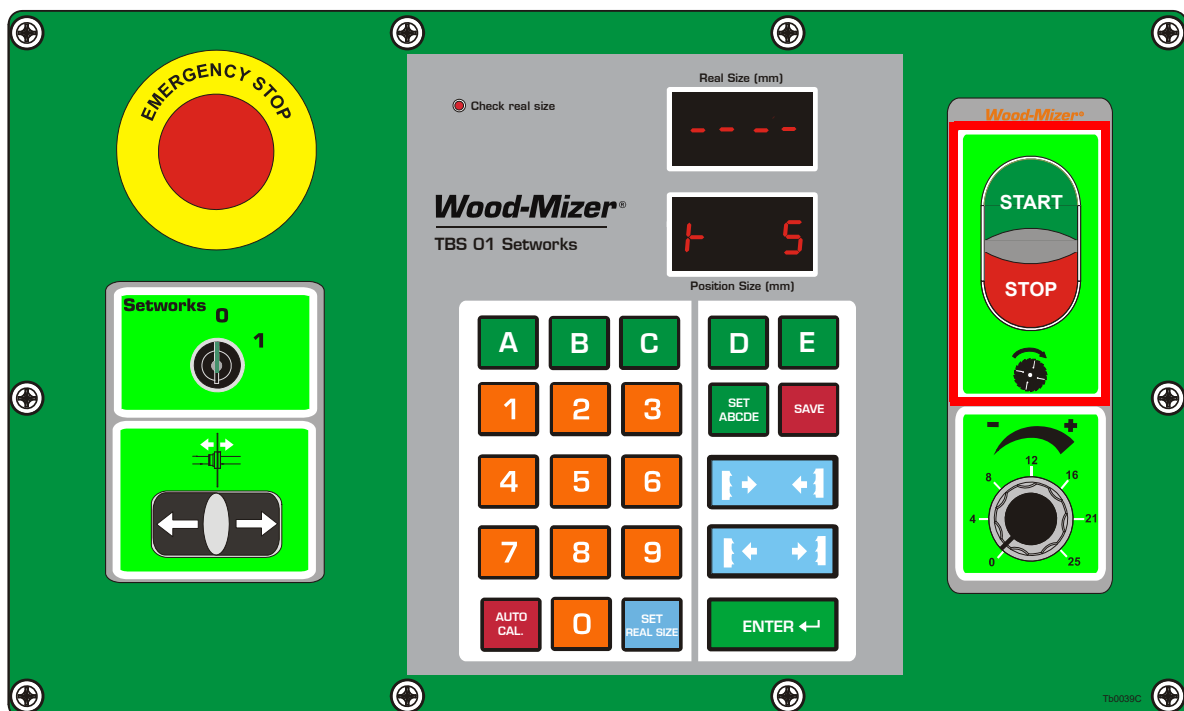
 **DANGER!** Before starting the machine, perform these steps to avoid injury and/or damage to the equipment:

- Close the blade housing and replace any guards removed for service.
- Make sure there are not any loose objects (such as tools, wood, etc.) on the infeed table.
- Make sure all persons are away from the machine.
- Check that the emergency stop buttons are released.

**NOTE:** The machine cannot be started if either of the emergency stops is not released.

Before starting the blades, check that the main power switch on the electric box is on.

**See Figure 3-8.** Start the blade motors. To do this, push the START button on the control panel (see the figure below). The blade motors and the feed belt should start.



**FIG. 3-9 EG350 CONTROL PANEL**

To stop the blade motors, push the STOP button shown in the figure above. The blade motors can also be stopped by pushing either of the emergency stop buttons.

**See Figure 3-10.** The feed rate knob, located on the control panel, allows the operator to adjust the speed at which the feed belt moves (from 0 to about 25 m/min).

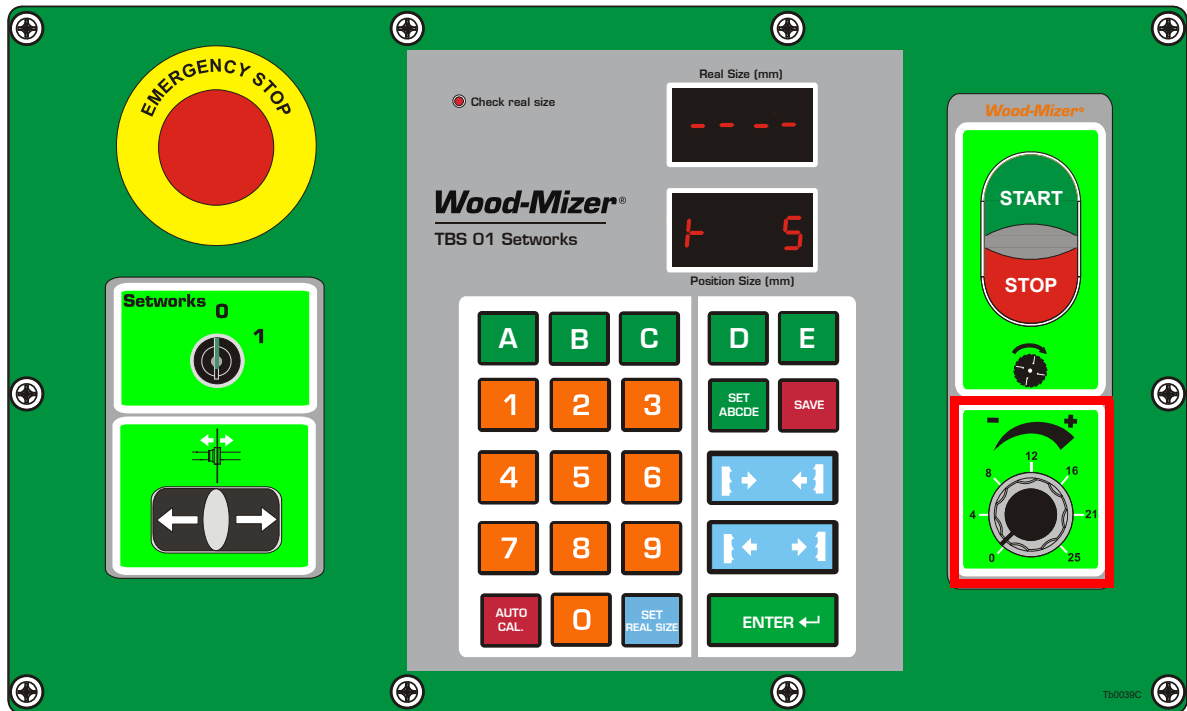


FIG. 3-11 EG350

Turn the knob clockwise to increase the feed rate or counterclockwise to slow the feed rate down.

### Factors that will determine what feed rate you can use include:

- Material thickness.
- Material hardness. Some woods that are seasoned or naturally very hard will require slower feed rates.
- Sharpness of the blades. Dull or improperly sharpened blades will require slower feed rates than sharp and properly maintained blades.
- Off-bearing capability. Your ability to feed will also determine what feed rate you can use.

## 3.5 Edging Operation



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

**DANGER!** Keep all persons out of the path of moving equipment and boards when operating the edger or loading boards. Failure to do so may result in serious injury.

**DANGER!** MOVING PARTS CAN CRUSH AND CUT. Keep hands clear. Make sure all guards and covers are in place and secured before operating or towing. Failure to do so may result in serious injury.

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



**WARNING!** Always shut off the motor to stop the blades whenever the edger is not in use. Failure to do so may result in serious injury.

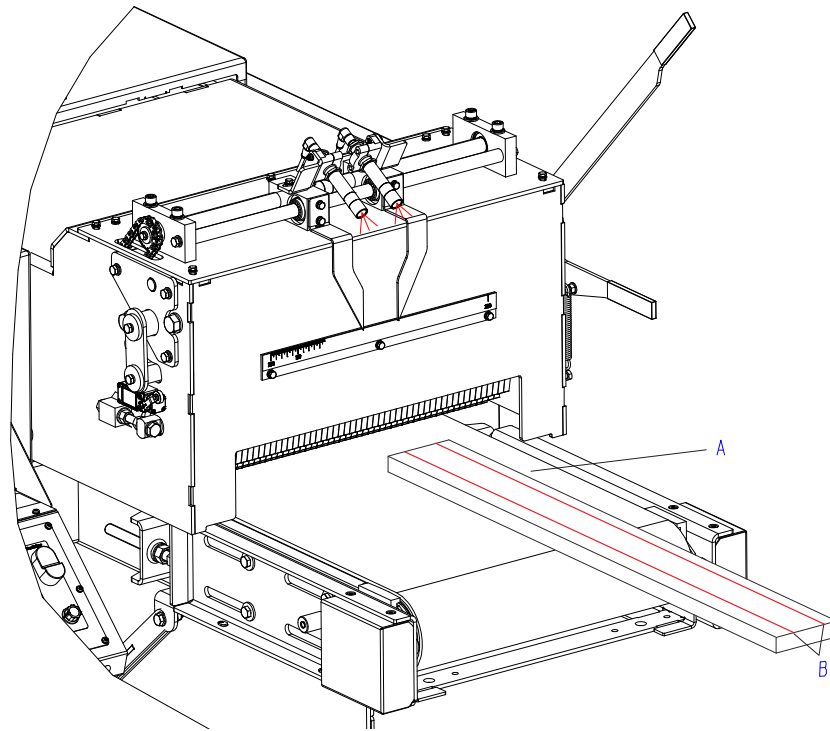
**WARNING!** Always wear eye, ear, respiration and foot protection as well as protective clothing when operating the edger. Failure to do so may result in serious injury.

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

After performing the pre-operation inspection, you are ready to begin edging lumber.

1. Start the machine.

2. Place the board on the infeed table (A).



**FIG. 3-12**

3. Set the distance between the blades. To do this, use the cutting width scale located on the front plate of the press roller housing, or enter the desired cutting width value into the Setworks controller. The laser sight will show where the blades will travel through the board ("B") [See Section 4.1 Edger Controller Panel](#) for instructions for using the Setworks.
4. Start the blade motors and the belt drive motor. Set the desired feed rate. Push the board into the edger until the feed system takes the board.



**IMPORTANT!** If at any time you need to immediately stop the motor and/or edger operation, press either of the emergency stop buttons.

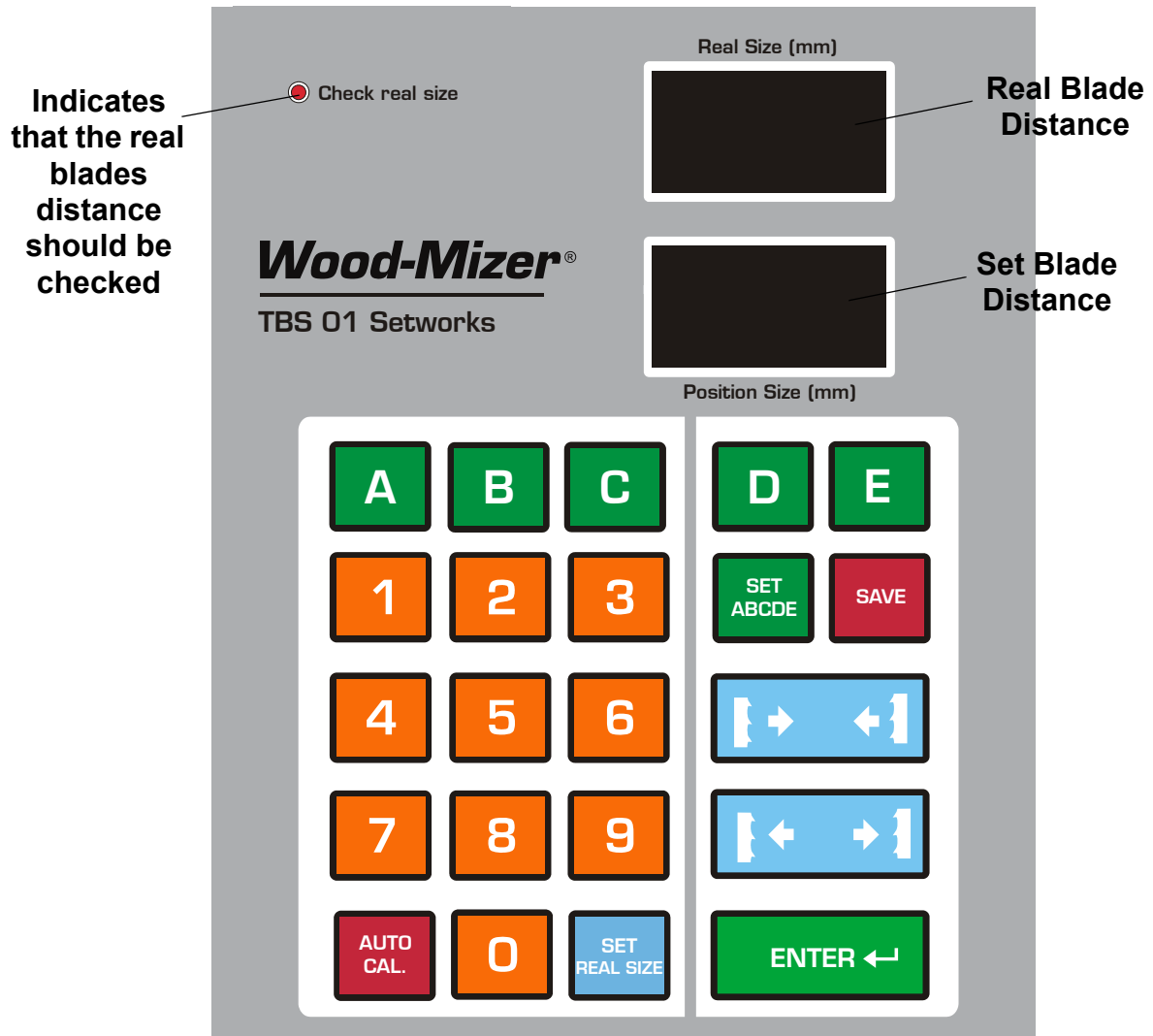
5. Repeat the above procedure for all boards that will be edged.
6. Shut down the machine when done edging.



## SECTION 4 NETWORKS OPERATION

### 4.1 Edger Controller Panel

See Pic. 4-1.



PIC. 4-1

**Descriptions of the control panel buttons:**

A, B, C, D, E - cutting width memory buttons



SET ABCDE - used to set a cutting width value under each memory button.



Save - saves parameters determined by the operator.



Buttons for manual cutting width setting (blades in/out)



ENTER ← - enters a value into the controller memory.



Auto Mode – Adjustment of the Networks automatic calibration parameters. Used for the initial calibration and re-calibration if a dimensional error occurs.




Set Real Size - used to set the real distance between the blades. This setting should be made when the “Check real size” indicator light is blinking.

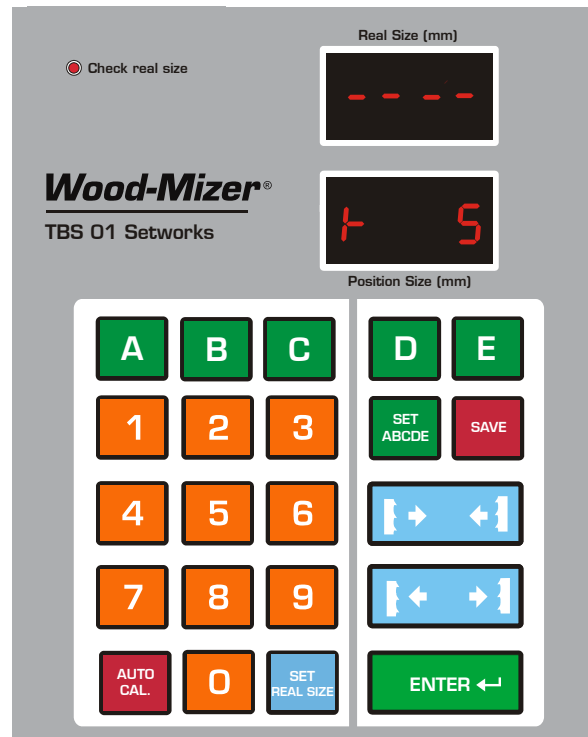
**IMPORTANT!** Do not use too much force or any hard object to press the buttons. The controller is not water-resistant.

## 4.2 Start-Up Settings of the Controller


### 1. Setting the input divider (entered only once, at the first start-up)

- Switch on the controller by turning the main switch to the ON position.
- When "TBS-01" appears on the display, press and hold  until the divider value appears on the lower right display.
- Enter the correct value of the divider (for the Edger the divider value should be **5**).

See Pic. 4-2.





PIC. 4-2

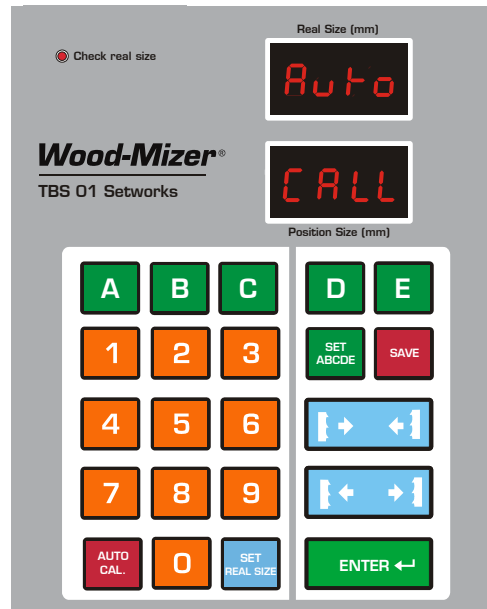
- Press  to save the entered divider value.

## 2. Automatic Calibration



This function should be used in case of: replacement of any component of the cutting width setting system, the motor or after lubrication of the chains and other moving elements as well as when significant cutting inaccuracies occur.

- Switch on the edger by turning the main switch to the ON position and wait until "TBS-01" disappears.
- Using  buttons, set the distance between the blades to 180 mm (7.07").
- Press and hold . After a while - "Auto CALL" will appear on the displays. The controller is ready for auto-calibration.

See Pic. 4-3.



PIC. 4-3


- Press  again - the controller will perform some movements of the blades in turn. After performing the last movement, measure and enter the real distance between the saw heads using the keypad. Confirm by pressing .
- The end of the function will be signalled and the controller will return to the normal mode of operation.



### 3. Entering the real blade distance

To ensure that the upper display shows the correct distance between the blades, it is necessary to enter the real distance. It must be done prior to the first start-up and also when:


- significant cutting inaccuracies occur;
- a sudden power disappearance occurred when the controller was setting the blade distance;
- any repairs to the blade drive system were made.


To enter the real blade distance:


- Press and hold .

- Using the scale, set the maximum distance between the blades (e.g. 250mm (9.842")).
- Press and hold .
- Measure the distance between the blades and make sure the measured distance is the same as read on the scale. If not, [See Section 5.6](#) for scale alignment instructions.
- Enter the blade distance without any pauses. Confirm by pressing .




### 4.3 Blade Distance Memory Buttons (A, B, C, D, E)

After turning on, the TBS-01 inscription appears on the display, and the Networks is ready for operation within a few seconds or after pressing .

- To set any blade distance, enter this value using the keypad and press . The blades will automatically move to the preset distance.

- You can also change the blade distance manually using .

You can store up to 5 blade distance values using the memory buttons.

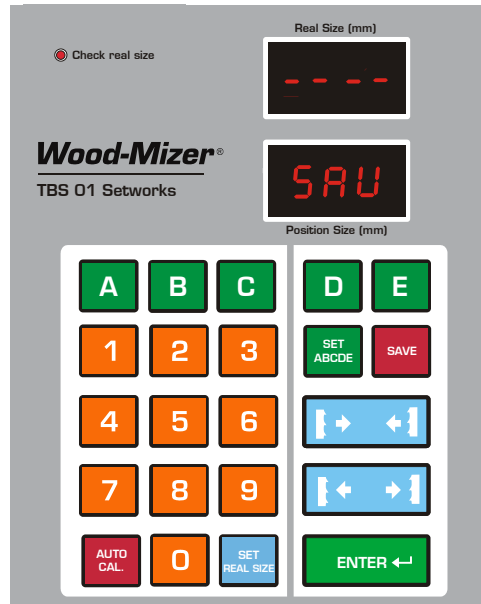
- To store any blade distance value using one of the memory buttons, press and hold . "ABC" will appear on the upper display. Press any memory button (A, B, C, D or E), enter the desired blade distance value and confirm by pressing . Perform the same procedure for other memory buttons. Press  to exit this function.

# 4


## NETWORKS OPERATION



### Blade Distance Memory Buttons (A, B, C, D, E)

See Pic. 4-4.





PIC. 4-4

- To use any stored blade distance value, press the corresponding memory button and confirm by pressing . The blades will automatically move to the preset distance.

**NOTE:** If during normal operation the “Check real size” light starts blinking, press and hold . Measure and enter the distance between the blades with accuracy to 0.1 mm (0.00394”). For example: if you want to enter 102mm - press **1-0-2-0** without any pauses and confirm by pressing .

### 4.4 Networks Malfunction


PROBLEM	CAUSE	SOLUTION
<p><b>Networks does not work.</b></p> <p>When performing a program, the controller disengages the drive mechanism and the display shows:</p>  <p>The top display shows '000' and is labeled 'Saw position (mm)'. The bottom display shows 'ErP' and is labeled 'Board Thickness (mm)'.</p>	<p>Magnet sensor improperly adjusted</p>	<p>Adjust the magnet sensor as shown in the figures 4-5 and 4-6. Calibrate the controller - <a href="#">See Automatic Calibration.</a></p>
<p>When performing the auto-calibration, the controller disengages the drive mechanism and the display shows:</p>  <p>The top display shows 'Auto' and is labeled 'Saw position (mm)'. The bottom display shows 'ErP' and is labeled 'Board Thickness (mm)'.</p>		<p>Enter the real distance between the blades. <a href="#">See Entering the real blade distance</a></p>
<p><b>Networks calculates dimensions incorrectly.</b></p>	<p>Improper input parameters</p>	<p>Check the input divider. (<a href="#">See Setting the input divider (entered only once, at the first start-up)</a> and <a href="#">See Entering the real blade distance</a>).</p> <ul style="list-style-type: none"> <li>- Perform the auto-calibration procedure. <a href="#">See Automatic Calibration.</a></li> </ul>
<p><b>The blades do not stop after reaching the preset distance, but continue their movement until the limit switch is activated.</b></p>	<p>Controller not calibrated</p>	<p>Check the input divider. Perform the auto-calibration procedure.</p>
<p><b>Networks stops.</b></p>	<p>Improper signal of the blade distance sensor.</p>	<ul style="list-style-type: none"> <li>- Check the connections between the sensor and the controller.</li> <li>- Check if the sensor or the magnetic strip is not loose.</li> <li>- Check if the connections to the blade setting system contactors are correct and not loose.</li> </ul>
<p><b>During manual blade movement, the upper display shows a negative value.</b></p>	<p>Networks not calibrated</p>	<p>Perform the auto-calibration procedure.</p>


# 4

## NETWORKS OPERATION

### *Setworks Malfunction*

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When pressing  during normal operation or when attempting to save the

program (using  button), the upper display shows horizontal dashes.

The blade distance limit would be exceeded if the requested movement of the blades was performed.

Try to enter a lower blade distance value.



## SECTION 5 MAINTENANCE & ALIGNMENT



**WARNING!** Before performing service near moving parts such as blades, pulleys, motors, belts and chains, set the main switch in the "0" position and disconnect the power cord.



**WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.



**WARNING!** Visible and/or invisible laser radiation. Avoid eye or skin exposure to direct or scattered radiation.



**DANGER!** The operator must not for any reason perform any service or repairs to the laser sight.



**WARNING!** Do not replace the factory-installed laser sight with any different laser sight, or mount any additional laser devices.

### 5.1 Replacing the Blades

Replace the blades as necessary. Dull blades will cause the motors to work harder and will result in decreased cut quality and accuracy. Blade life will vary depending on maintenance of the machine, the operator use as well as species and condition of wood being sawn.



**DANGER!** Before changing the blades, make sure the blade mounting arbors have come to a complete stop and the motor is shut off completely. Turn the main switch to the "0" position and disconnect the power cord. Failing to do so can cause serious injury.



**WARNING!** Always wear eye, glove and foot protection when handling the blades.

1. Move the blades all the way out (to the maximum cutting width).

See Figure 5-1

2. Turn off the blade motors and wait until the solenoid interlock (A) is inactive. Then set the main switch in the "0" position and disconnect the power cord.

## 5 Maintenance & Alignment

### Replacing the Blades

3. Move the blade housing (B) to access the blades.

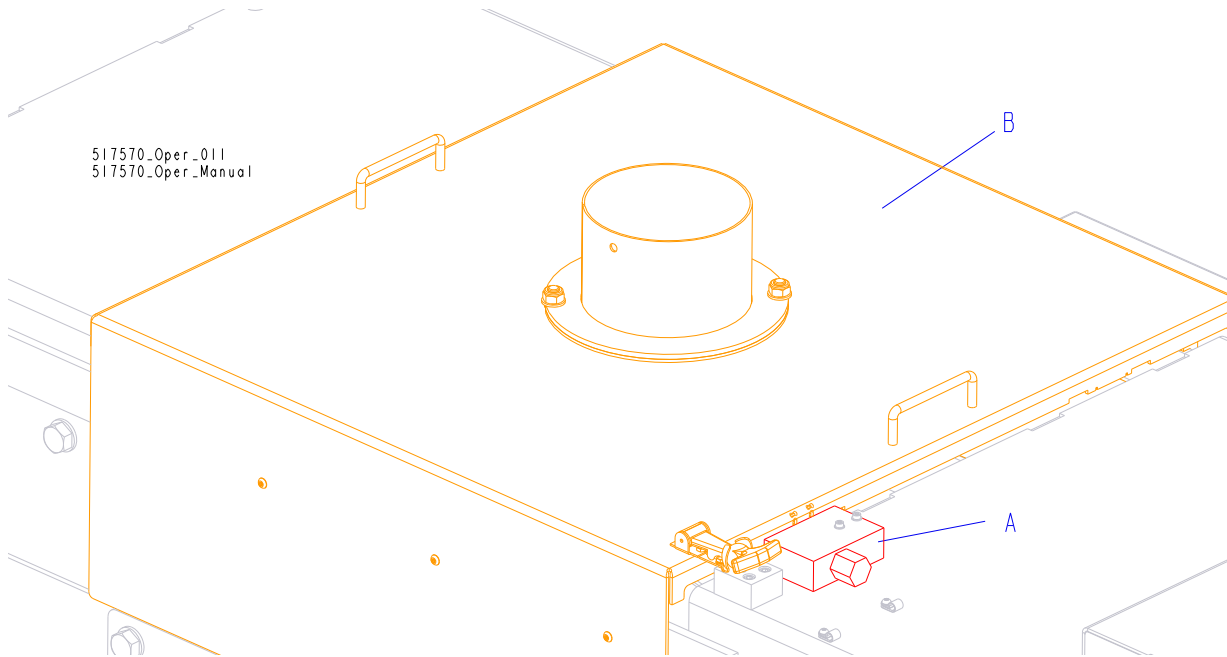


FIG. 5-1

See Figure 5-2

4. Place the provided wrench (A) on the blade clamping flange (B) to keep it in place so that you can remove the screws C.

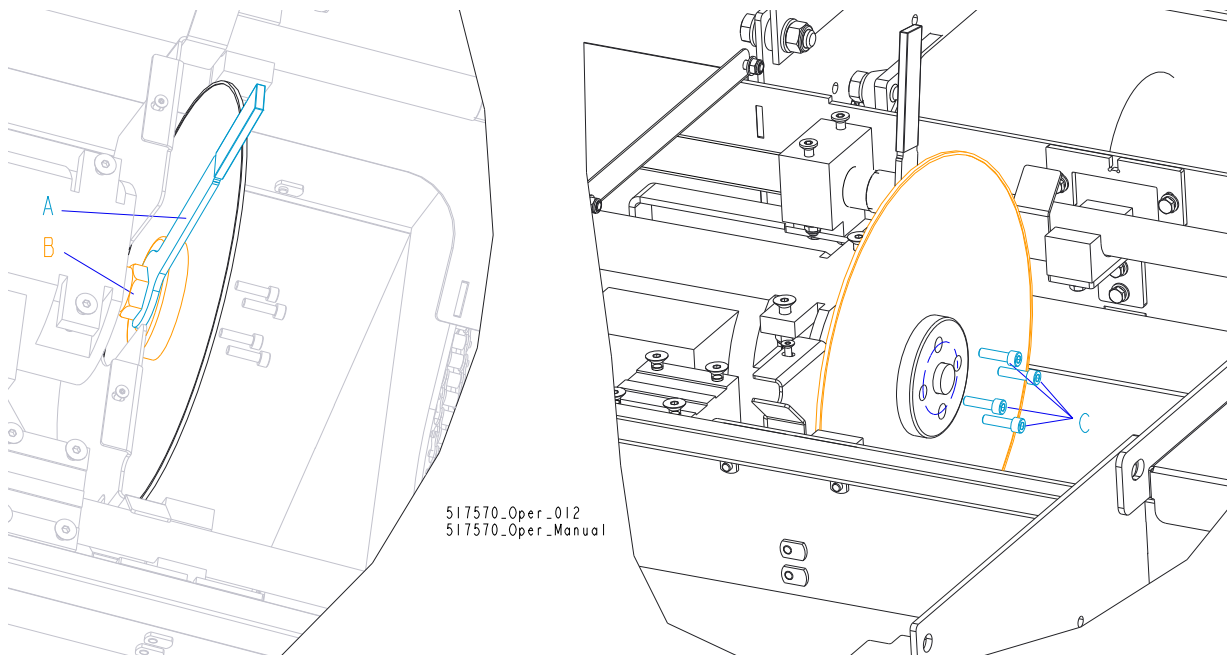



FIG. 5-2

5. Replace the circular blades.


6. Secure the new blades with the screws and close the blade housing.

## 5.2 Tensioning the Chains

 **DANGER!** Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Failure to do so may result in serious injury.

Before tensioning the chains, make sure the motor is turned off and the main switch is in the "0" position. Disconnect the power cord. Failure to do so may result in serious injury.

### 5.2.1 Table Drive Chain

 Check the table drive chain tension every 40 hours of operation. Adjust the chain if necessary. The chain should have approximately 15 mm of slack.

See Figure 5-3

- To adjust the table drive chain tension:

1. Unbolt and remove the front guard shown below.

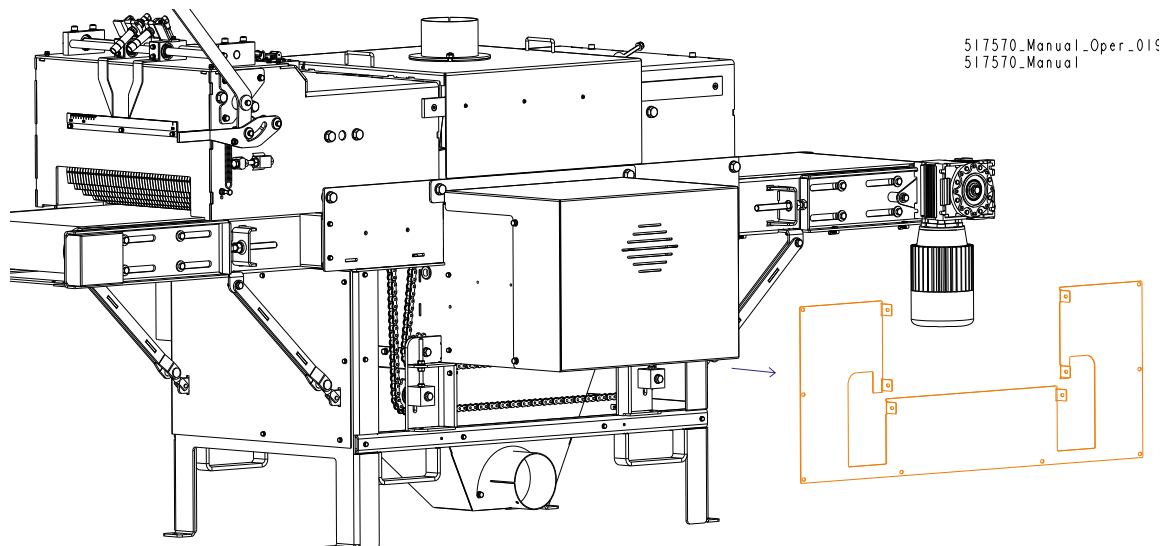


FIG. 5-3

See Figure 5-4

2. Loosen the mounting bolt (A) of the chain tensioner block (B). To do this, loosen the nut (C).
3. Using the nuts D, move the chain tensioner blocks (B) so that the chain has 15 mm of slack in the place marked with the arrow in the figure.

- Reinstall the front guard.

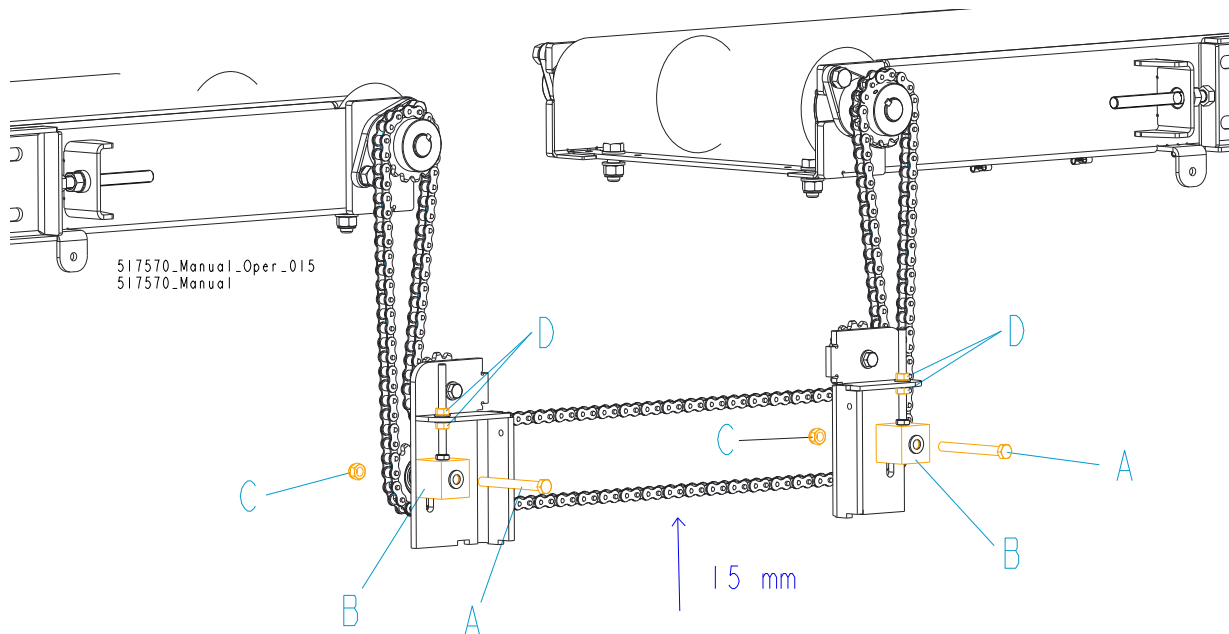


FIG. 5-4

### 5.2.2 Blade and Laser Setting Chains

**NOTE:** After adjusting the blade setting drive chain, always check the laser setting chain tension and adjust if necessary.

100 Check that the blade setting chain and laser setting chain are tensioned properly every 100 hours of operation. Adjust the chains if necessary. These chains should have approximately 15 mm of slack.

**NOTE:** Chain tension affects cutting accuracy.

### 5.2.3 Tensioning the Blade Setting Drive Chain

See Figure 5-5

To adjust the blade setting chain tension:

- Loosen the bolts A - see the figure below.
- After loosening these bolts, the blade setting drive chain will be tensioned automatically.

3. Tighten the bolts A.

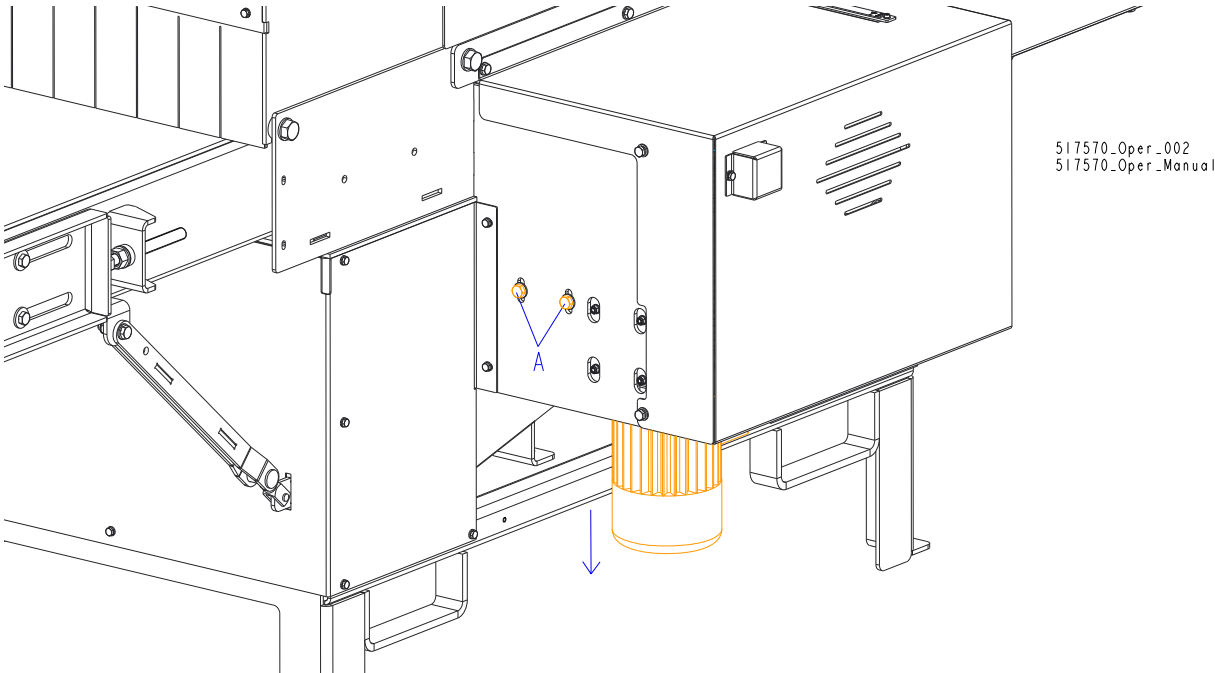


FIG. 5-5

5.2.4 Tensioning the Laser Setting Drive Chain

See Figure 5-6

1. Disassemble the infeed table arms (A) by removing the clip and the pin from the fork (B).

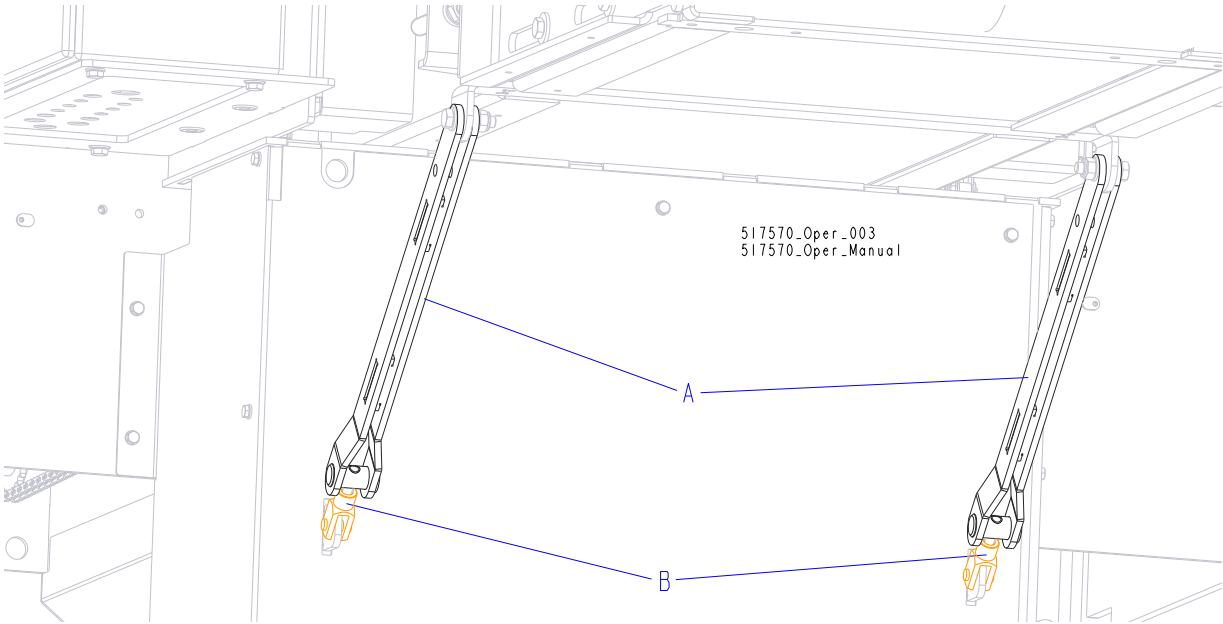
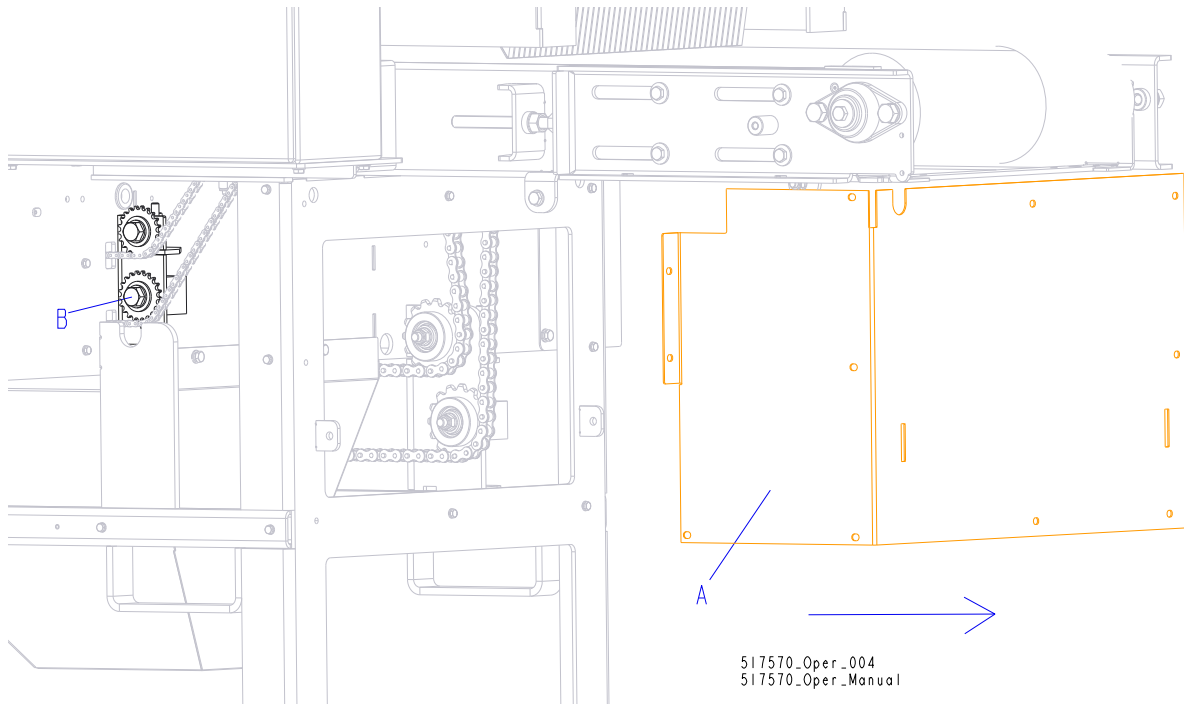


FIG. 5-6

See Figure 5-7

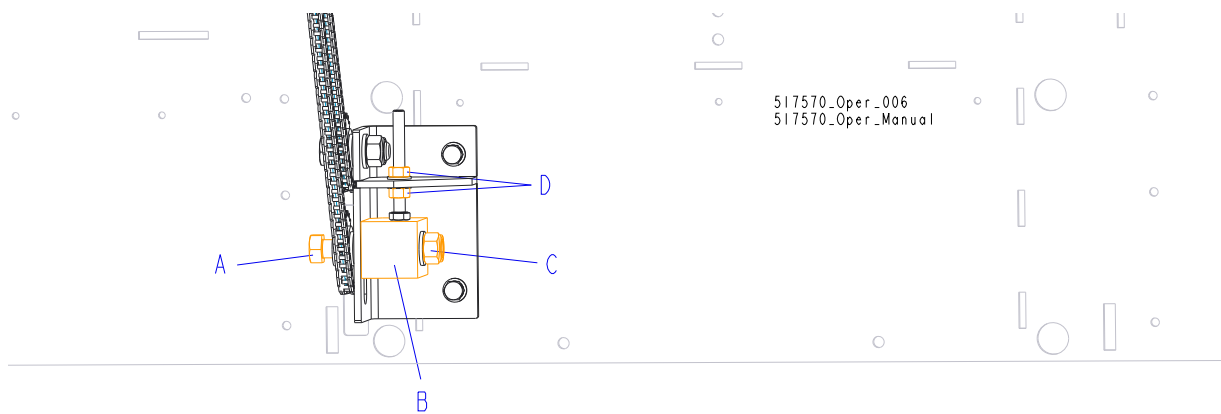
- Unbolt and remove the right guard (A) to access the laser chain tension assembly (B).



**FIG. 5-7**

- Loosen the mounting bolt (A) of the chain tensioner block (B) by loosening the nut C. Then using the nuts D, move the tensioner block (B) so that the chain has 15 mm of slack.

See Figure 5-8



**FIG. 5-8**

See Figure 5-9

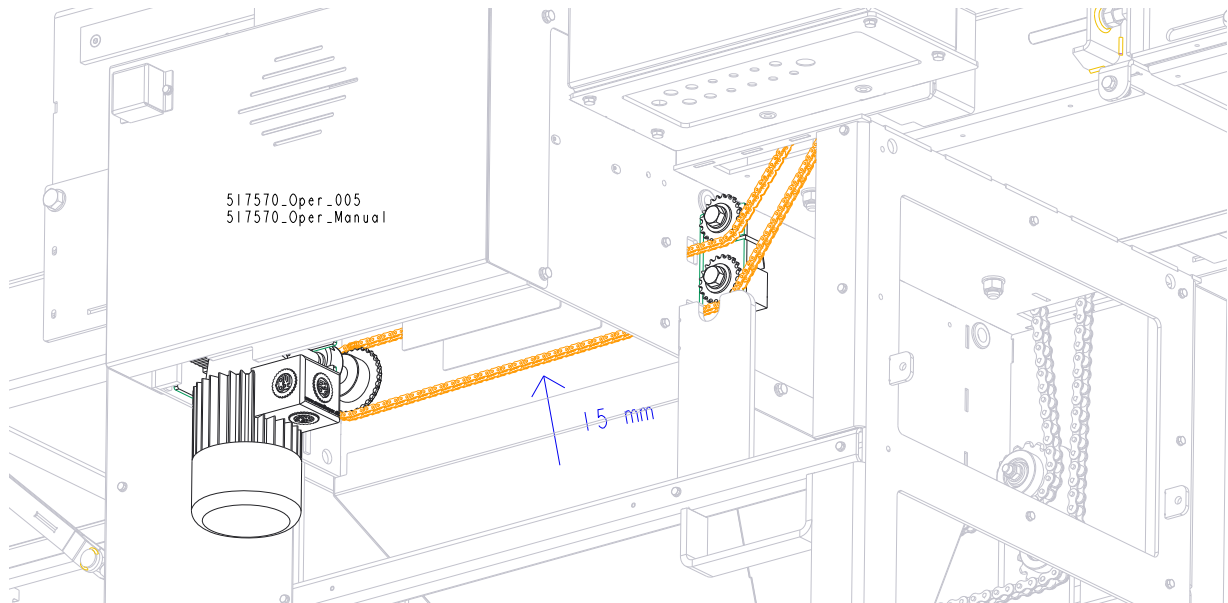


FIG. 5-9

4. Reinstall the right guard and the infeed table arms.

### 5.3 Checking the Rollers and Table Belt

1. Check the press rollers every 8 hours of operation. Remove any dirt or debris from them. Make sure the rollers spin freely, without much play. If necessary, replace the rollers with the springs.
2. Check the table belt every 8 hours of operation. Clean any debris from the belt.

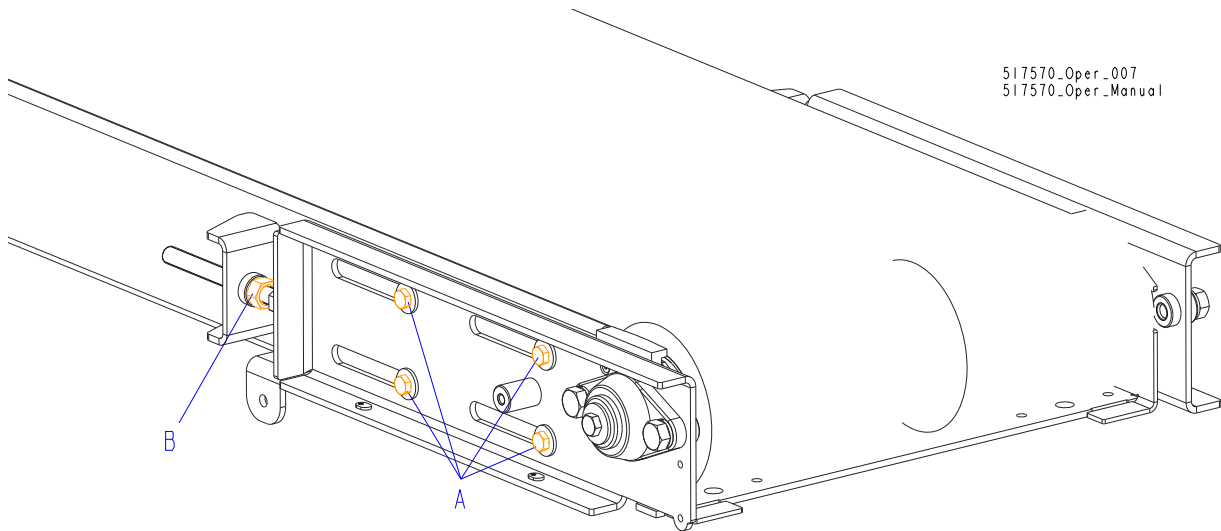
### 5.4 Tensioning the Table Belt

See Figure 5-10

- To adjust the table belt tension:

1. Loosen the bolts A on both sides of the table.

2. Use the nut B to tension the table belt evenly on both sides.

**FIG. 5-10**

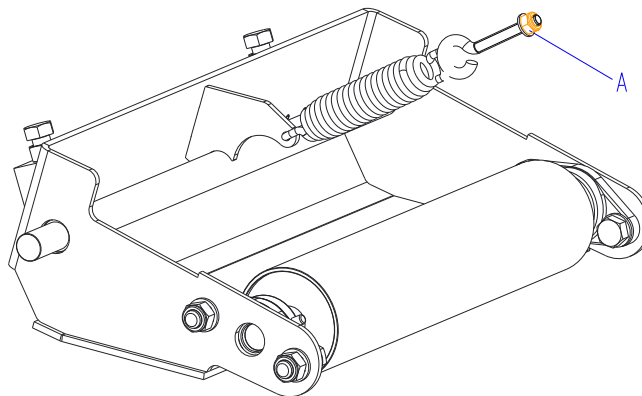
3. Tighten the bolts A.

## 5.5 Adjusting the Press Rollers

See Figure 5-11

- To adjust the press roller (the force of holding down the material), use the nut A in the figure below.

517570\_Oper\_008  
517570\_Oper\_Manual

**FIG. 5-11**



## 5.6 Laser Sight Adjustment

See Figure 5-12

- If the laser sights indicate different cutting width than read on the cutting width scales, perform the following steps:

1. Remove the laser sight guard.

517570\_Oper\_009a  
517570\_Oper\_Manual

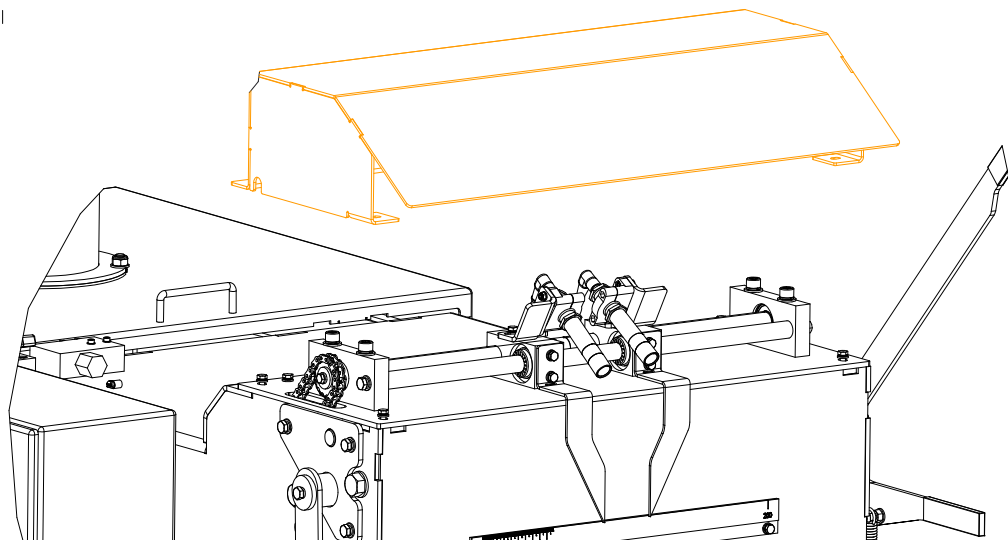


FIG. 5-12

See Figure 5-13

2. Adjust the laser sights. To do this, loosen the bolts A and move the laser mounting bracket (B) left or right.

3. Tighten the laser sight mounting bolts (A).

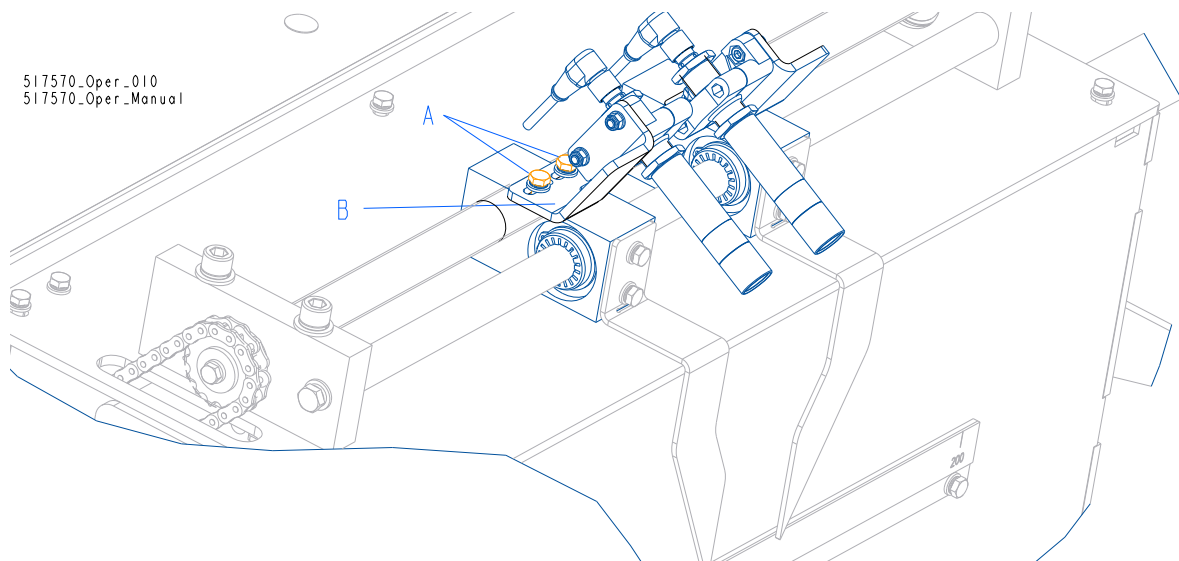


FIG. 5-13

4. Reinstall the laser sight guard.

## 5.7 Lubrication

1. Remove any debris from the blade drive shaft every 8 hours of operation. Use a soft cloth to apply a dry graphite daily to ensure resistance-free motion and to prevent surface corrosion.
2. Lubricate the blade shaft bearings and the bearings of feed rollers every 200 hours of operation with a lithium grease such as Shell Alvania No. 3. Do not overgrease.
3. Lubricate the anti-kickback lever bearings every 200 hours of operation with a high-quality lithium-based grease such as Shell Alvania No. 3.

## 5.8 Maintaining the Anti-Kickback Fingers

This machine has the potential for kickbacks. Kickbacks can cause the board to be suddenly and uncontrollably hurled towards the operator. Such action can result in severe injury or death.

If you are working with frozen boards or with boards that have protruding knots, the chance of kickbacks is increased.

The EG350 edger is equipped with anti-kickback fingers to help prevent kickback from occurring. To maintain the safety of your edger, periodically inspect the machine to ensure all anti-kickback fingers are intact and undamaged and have a sharp point. Missing or damaged parts can affect the safety of the

machine operator or bystanders and should be replaced immediately. Do not sharp the anti-kickback fingers! If they are dulled, replace them with new ones.

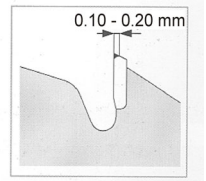


**DANGER!** Always ensure that there is a sharp point on the anti-kickback fingers before each use of the edger.

Be sure the anti-kickback fingers are free from obstruction and are in their downward position. Failure to do so may result in serious injury.

## 5.9 Blade Sharpening

The blade teeth should be sharpened as soon as their dullness, measured as shown in the figure on the right, is .10 -.20 mm (0.0039 - 0.0078").

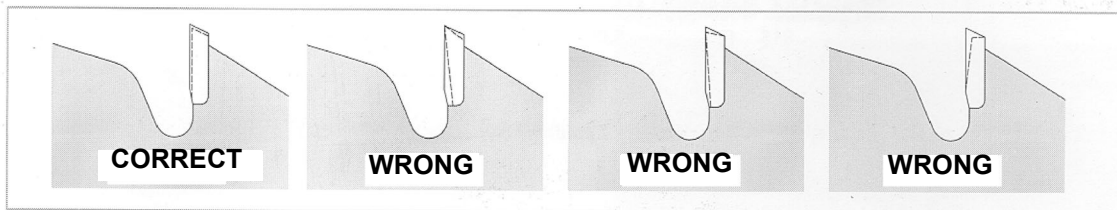
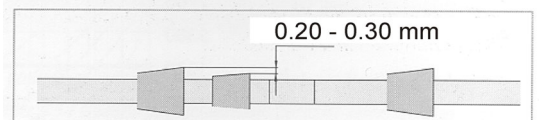


Use diamond grinding wheels for sharpening the blades. Apply intensive cooling during sharpening to prevent overheating and structural changes in the cemented carbide tips.

**Blades with hard tips (GLOTECH series) must be intensively cooled with water during sharpening. Failure to do so will result in cracks in the tips.**

In Multix type blades the carbide tips should be .4 - .6 mm (0.0157 - 0.0236") wider than the carbides in the wiper slots. (See the figure below.) If this difference is not kept, it will result in disk overheating and – in extreme case – in cracks in the blade gullets. The carbide plates in the wiper slots remove sawdust and splinters from the kerf. They also cause sawdust to be blown away.

When sharpening, maintain the proper tooth geometry as indicated in the figure below.



## 5.10 Using the Blades

The surfaces of spacers should be clean and flat against one another. The blade should not rotate on the shaft during sharpening as it will lead to its damage.

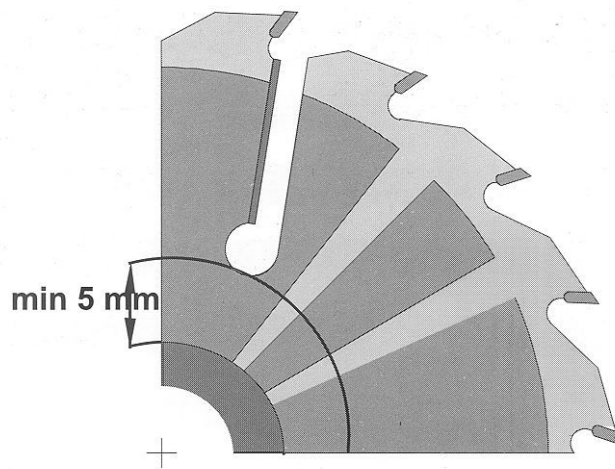
**Do not set teeth with cemented carbide tips!**

Do not make any modifications to the blade teeth!

Do not operate the machine if either of the blades is dull. Using dull blades causes stronger cutting resistance, decreased cut accuracy and may result in blade burning and even cracks in the gullets and the wiper slots.

**Do not exceed the maximum blade rotation speed recommended for a given type of material!**

When using Multix type blades, keep at least 5 mm (0.197") spacing between the bottom of the wiper slot and the spacer outer diameter.



To remove any sawdust buildup from the blade disk, preferably use a solution of hot water and soda or another cleaner.

Any blades which are not used for a longer period of time should be properly maintained.

The blades should be used in accordance with safety rules and their application and on machines in good operating condition and equipped with suitable safety guards.

## 5.11 Safety Devices Inspection (Only CE<sup>1</sup> Version)

### EG350 Edger – Safety Devices Inspection

See Figure 5-14

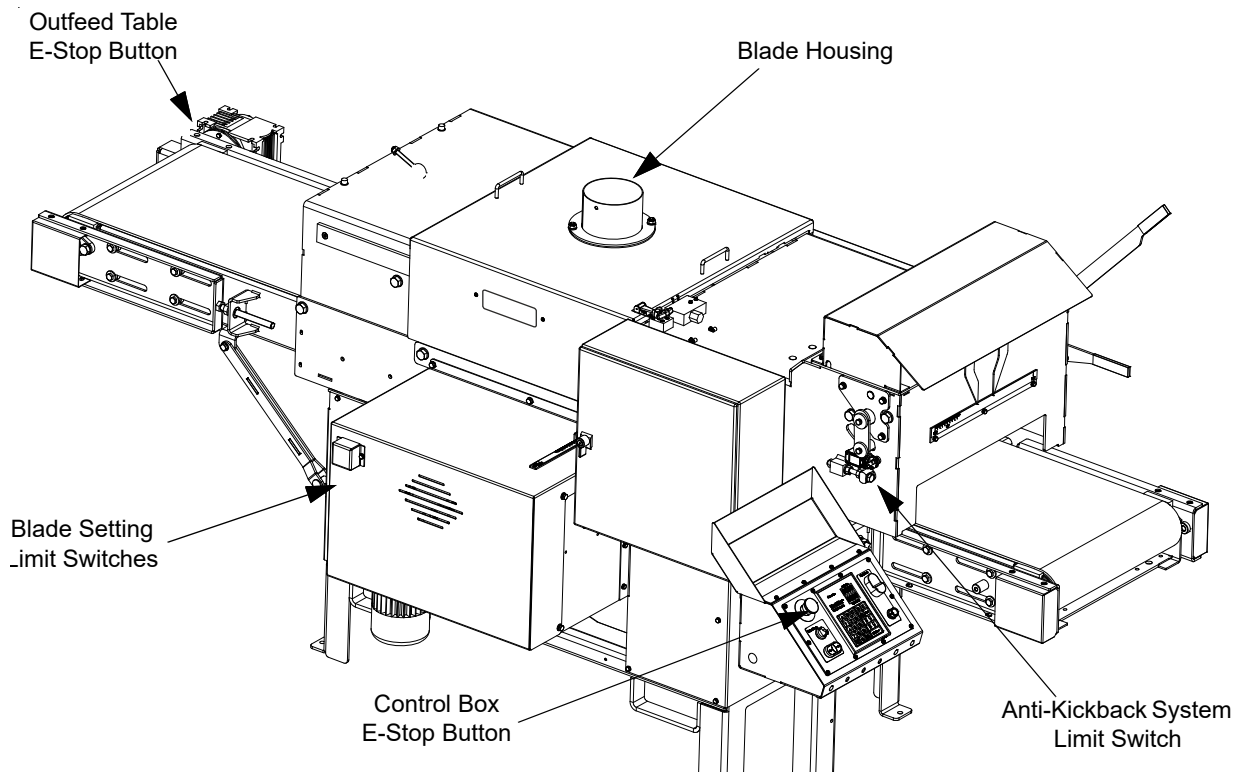


FIG. 5-14

Before beginning a shift, inspect the following safety devices of the EG350 edger:

- E-STOP button circuit - control box,
- E-STOP button circuit - outfeed table,
- solenoid interlock circuit - blade housing,
- minimum blade distance limit switch,
- maximum blade distance limit switch,
- circuit of the anti-kickback system limit switch (2 persons).

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1. Marking of products sold within European Economic Area

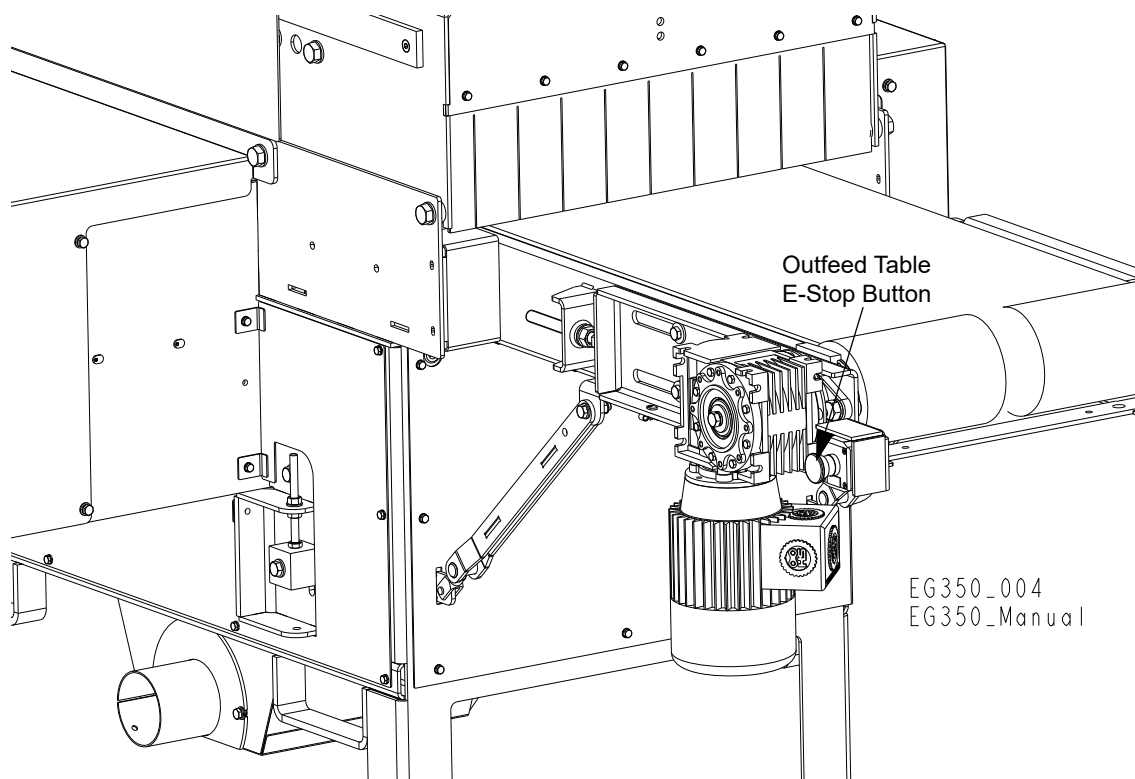
### 1. Inspection of the Control Box E-STOP Circuit

- Start the main motor;
- Push the E-Stop button on the control box. The motor should stop. It should not be possible to restart the motor until the E-STOP button is released.

### 2. Inspection of the Outfeed Table E-STOP Circuit

See Figure 5-15

- Start the main motor;
- Push the E-STOP button located on the outfeed table. The motor should stop. It should not be possible to restart the motor until the E-STOP button is released.



**FIG. 5-15**

### 3. Inspection of the Solenoid Interlock Circuit (Blade Housing)

See Figure 5-16

- Start the main motor;
- Open the blade housing;

- The main motor should stop;
- Try to start the motor using the START button. It should not be possible to start the motor.
- Close the blade housing;
- The motor should remain turned off.

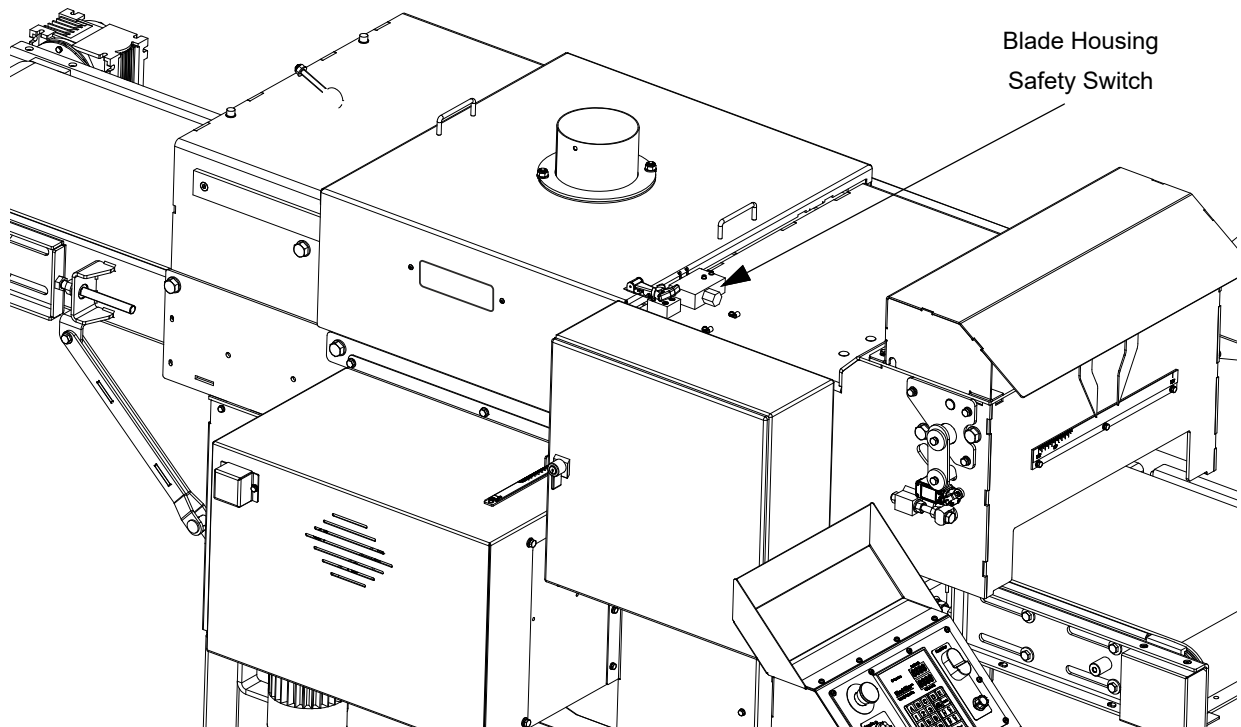


FIG. 5-16

#### 4. Maximum Blade Distance Limit Switch

- Press and hold the LEFT ARROW button on the control box until the blades stop moving out.
- Repeat the above step using the key located on the Setworks controller.

#### 5. Minimum Blade Distance Limit Switch

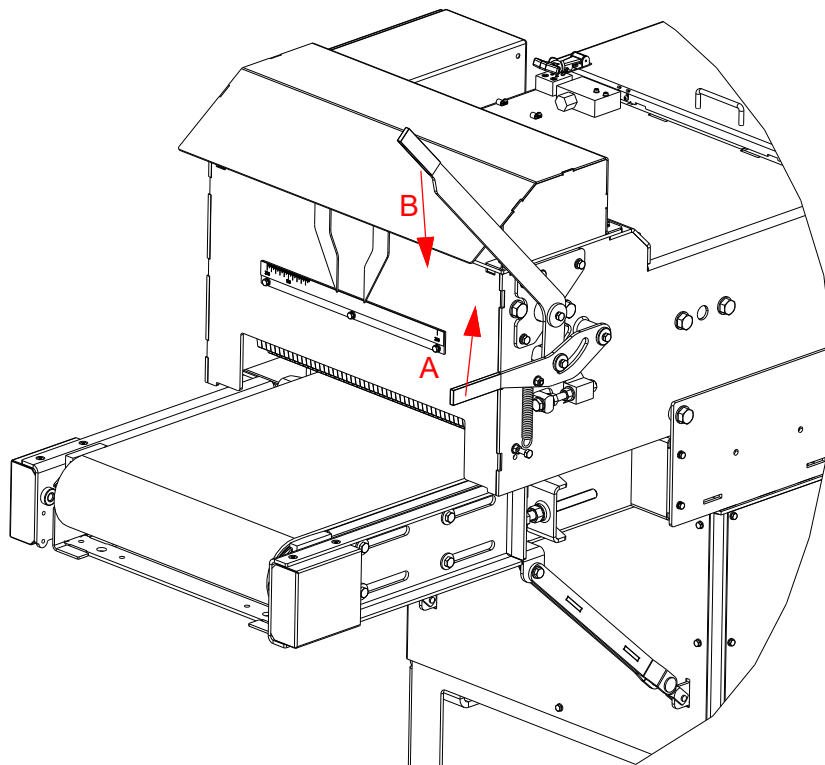
- Press and hold the RIGHT ARROW button on the control box until the blades stop moving in.
- Repeat the above step using the key located on the Setworks controller.

**6. Anti-Kickback System Limit Switch - Circuit Inspection (2 Persons)**

See Figure 5-17

- Start the main motor;
- Push up the anti-kickback lever lock (A);
- Raise the anti-kickback fingers by pushing the anti-kickback lever (B) down;

EG350EH15S\_003  
EG300EH15S\_MANUALS



**FIG. 5-17**

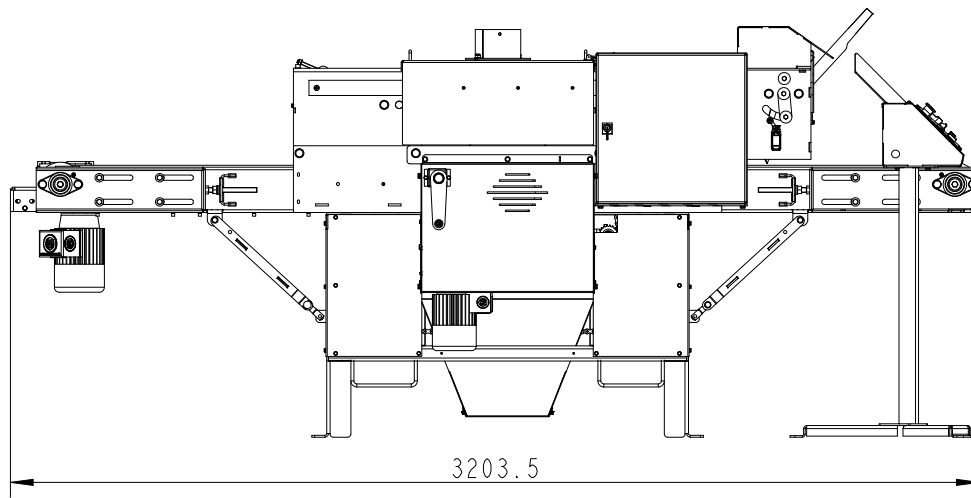
- The main motor should stop;
- With the anti-kickback fingers in the up position, try to start the motor using the START button. It should not be possible to start the motor.
- Lower the anti-kickback fingers to their working position.



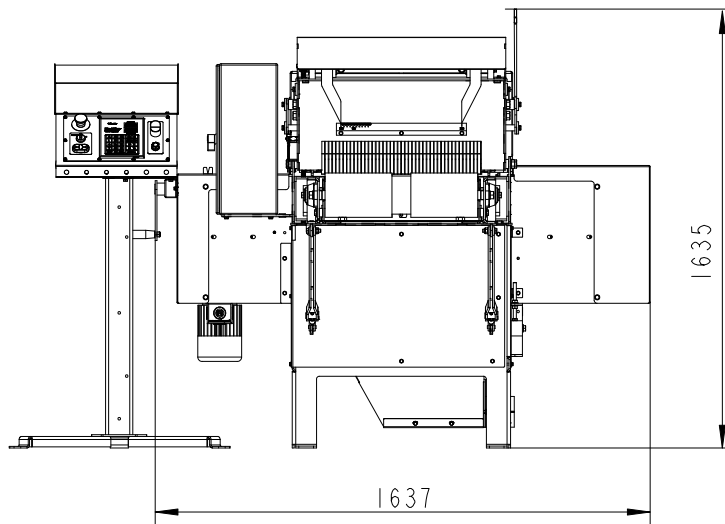
## SECTION 6 SPECIFICATIONS

### 6.1 EG350 Edger Overall Dimensions

See **Figure 6-1** The major dimensions of the EG350 edger are shown below (all dimensions are in millimeters).



EG350\_006  
EG350\_Manual



**FIG. 6-1**

See Table 6-1 The overall dimensions of the EG350 edger are listed in the table below.

<b>Weight</b>	956 kg
<b>Height</b>	1358 mm
<b>Width</b>	1605 mm
<b>Length</b>	3205 mm

## 6.2 EG350 Edger Specifications

See Table 6-2 See the table below for technical data on the EG350 edger.

	<b>Motor Specifications</b>	<b>Motor Specifications</b>
<b>Motor Type</b>	<b>E7</b> Electric Motor	<b>E10</b> Electric Motor
<b>Manufacturer</b>	Komel, Poland	Siemens, Germany
<b>Voltage</b>	400V, 460V	400V, 460V
<b>Maximum Current</b>	10 A	17 A
<b>Maximum Revolutions per Minute</b>	2865 r.p.m. at 50Hz	2880 r.p.m. at 50Hz
<b>Rated Power</b>	5.2kW (7HP) at 50Hz	8kW (11HP) at 50Hz
<b>Manufacturer Part No.</b>	SPg 75-2E	SBC 93 B/2

See Table 6-3 The level of noise generated by the EG350 edger is given below.<sup>1 23</sup>

	<b>Noise Level</b>
<b>EG350 Edger Equipped with E20 Motor</b>	$L_{pA}$ 94,6 dB (A) infeed
	$L_{pA}$ 93,3 dB (A) outfeed
	$L_{WA}$ 109,2 dB (A)

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard. Value for associated uncertainty  $K=4dB$ .

2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission levels and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. The factors affecting a current level of noise exposure during work are inter alia room characteristics and characteristics of other noise sources, e.g. number of machines and machining operations nearby. Also, the permissible exposure level value may vary depending on country. This information enables the machine's user to better identify hazards and a risk.

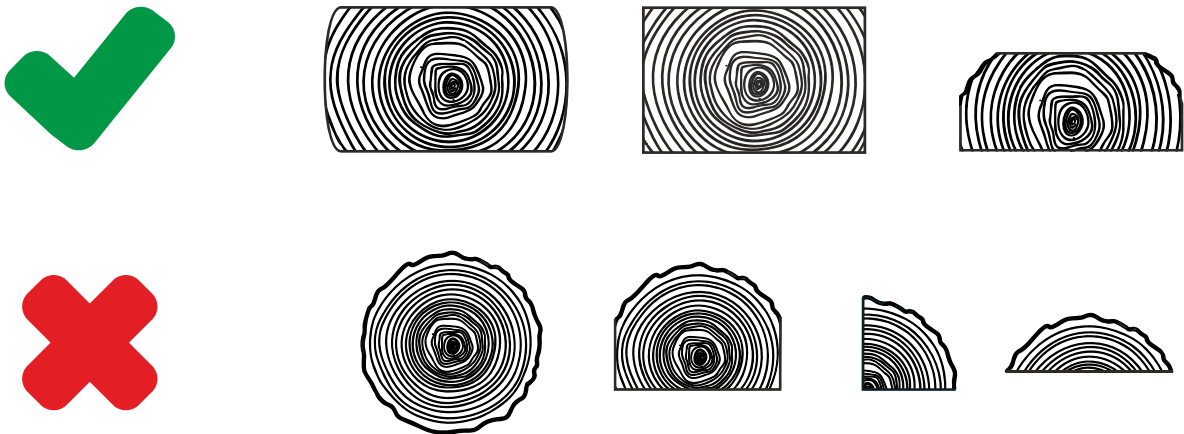
3. The total value of hand-arm vibration the operator may be exposed to does not exceed  $2.5 \text{ m/s}^2$ . The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed  $0.5 \text{ m/s}^2$ .

See Table 6-4 Other specifications of the EG350 edger are given below.

<b>Number of Blades</b>	2
<b>Blade Diameter</b>	400 mm
<b>Rotational Speed</b>	2800 r.p.m.
<b>Cutting Speed</b>	0 - 20 m/min
<b>Minimum Board Length</b>	1100 mm
<b>Minimum Board Thickness</b>	15 mm
<b>Maximum Board Thickness</b>	100 mm
<b>Minimum Cutting Width</b>	60 mm
<b>Maximum Cutting Width</b>	400 mm
<b>Maximum Material Width</b>	500 mm

**TABLE 6-4**

See Figure 6-2 Allowable and non-allowable shapes of sawn material



**FIG. 6-2**

### 6.3 Sawdust Exhaust System Specifications

See **Table 6-5** See the table below for specifications of a sawdust exhaust system that can be used with the EG350 edger<sup>1</sup>.

<b>Airflow</b>	1200 m <sup>3</sup> /h
<b>Inlet Diameter</b>	150 mm
<b>Motor Power</b>	1.5 kW
<b>Number of Sacks</b>	2 pcs
<b>Sack Capacity</b>	0.25 m <sup>3</sup>
<b>Pressure Drop</b>	1.5 kPa (0.22 psi) <sup>1</sup>
<b>Weight</b>	110 kg
<b>Recommended Conveying Air Velocity in the Duct</b>	20 m/s

<sup>1</sup> 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 with conventional CADES.

**TABLE 6-5**



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



**CAUTION!** Always connect and turn on the sawdust exhaust system before starting the machine.

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

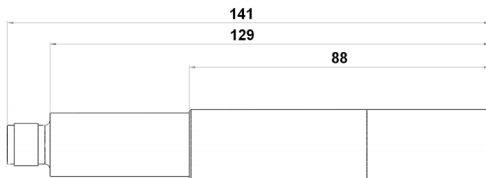
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## SECTION 7 LASER INFORMATION

## LP-520L-10

Industrial hermetic focusable laser line generator with rectilinearity correction.

Laser for industrial applications.



### Technical data:

- Safety Class 2M from EN 60825-1:2014;
- Wavelength  $\lambda=520\text{nm}$ ;
- Average Output Power 10mW;
- Operating Voltage 9V  $\div$  28VDC;
- Operating Current <100mA;
- Optics: aspherical acrylic lens F=8mm; NA=0,28; rod lens  $\phi 5$ ;
- Line generating angle  $\sim 90^\circ$  ;
- Possibility to adjust the focus from few cm to several meters (external focus mechanism);
- Dimensions  $\phi 20 \times 130$ ;
- International Protection Rating IP65;
- Aluminium housing (black anodized);
- Chromed brass mounting M18 x 1;
- Operating temperature: 0 do +60°C;
- Storage temperature: -40 do +85°C;
- Laser diode electrically isolated from housing;
- M12 plug, 4-pin M12 x 1;
- Pin configuration:
  - 1: voltage supply (+)
  - 3: voltage supply (-)



### OPTIONS:

- different optical power, wavelength, line generating angle, gaussian or uniform line optics,
- modulation.



RAIFFEISEN BANK POLSKA S.A.  
 PLN 96 1750 0009 0000 0000 0272 8238, EUR 15 1750 0009 0000 0000 0272 8338  
 USD 55 1750 0009 0000 0000 0272 8297, CHF 90 1750 0009 0000 0000 0272 8346  
 NIP PL5260303208, D&B 422320739

## 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: **Edger**  
TYPE: EG350EH15S  
No. of manufacturer: .....

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

EC Machinery Directive 2006/42/EC  
EC Electromagnetic Compatibility Directive  
2014/30/EU

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

PN-EN 1870-4:2012;

Notified Body according to annex IV : INSTYTUT TECHNOLOGII DREWNA  
Centrum Certyfikacji Wyrobów Przemysłu Drzewnego  
ul. Winiarska 1, 60-654 Poznań

Notification No: 1583

EC type-examination certificate no.: 0463/2015

Responsible for Technical Documentation: Piotr Adamiec / Engineering Manager  
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Place/Date/Authorized Signature: Koło, 17.07.2015 

Title: Engineering Manager