

Wood-Mizer[®] Sawmill

Safety, Setup, Operation & Maintenance Manual

LT25
LT25L

rev. C5.00
rev. C5.00



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

February 1998

Form #602

This manual is to replace or to be used with all previous information received on the Wood-Mizer®* sawmill. All future mailings will be an addition to or a revision of individual sections of this manual as we obtain new information.

The information and instructions given in this manual do not amend or extend the limited warranties for the equipment given at the time of purchase.

If You Need To Order Parts...

From Europe call our European Headquarters and Manufacturing Facility in Kolo, Poland at **+48-63-2610233** or **+48-3912-1319**. From the continental U.S., call our toll-free Parts hotline at **1-800-448-7881**. Please have the vehicle identification number and your customer number ready when you call. Wood-Mizer will accept these methods of payment:

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

Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order. In most cases, items will ship on the day they are ordered. Second Day and Next Day shipping are available at additional cost.

If You Need Service...

From Europe call our European Headquarters and Manufacturing Facility in Kolo, Poland at **+48-63-2610233** or **+48-3912-1319**. From the continental U.S., call us toll-free at **1-800-525-8100**. Ask to speak with a Customer Service Representative. Please have your vehicle identification number and your customer number ready when you call. The Service Representative can help you with questions about alignment of your mill, blade sharpening, or cutting a particular species of wood. He also can schedule you for a service call.

Office Hours: All times are Eastern Standard Time. Please remember that Indiana does not go on Daylight Savings Time in the summer.

Country	Monday - Friday	Saturday	Sunday
U.S., Indiana	8 a.m. to 5 p.m.	8 a.m. to 4 p.m.	Closed
Poland	8 a.m. to 4:30 p.m.	8 a.m. to 1 p.m.	Closed

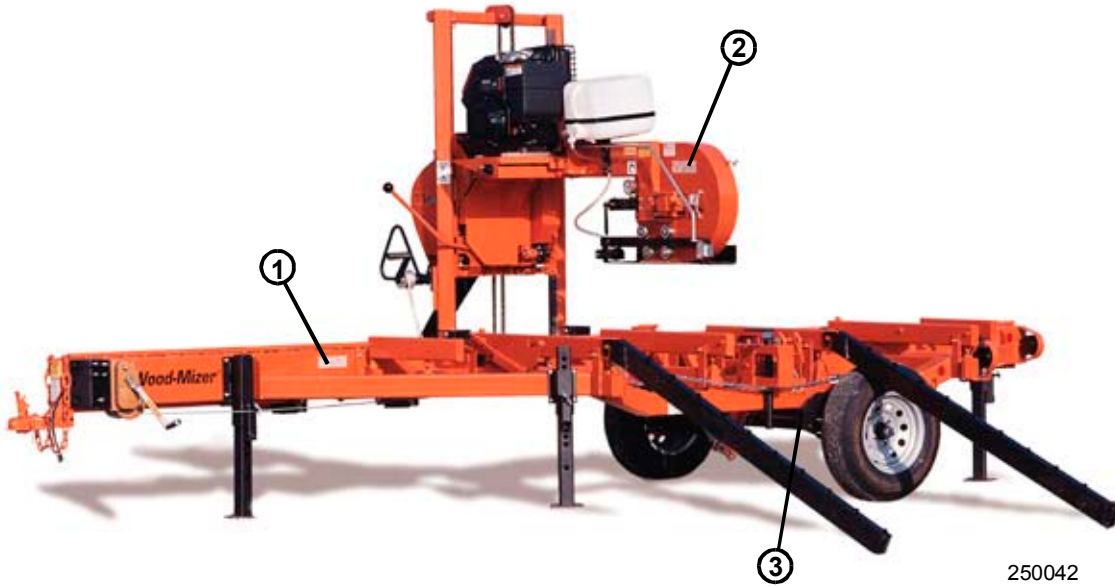


IMPORTANT! Read the entire Operator's Manual before operating the sawmill. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

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

Sawmill and Customer Identification

Each Wood-Mizer sawmill has a 17-digit Vehicle Identification Number (VIN). See the figure below for VIN locations. See the chart for VIN description.



250042

V.I.N. LOCATIONS.

Company Identification Number 456=Wood-Mizer Indiana	Weight Class; A=Under 3,000 lbs B=3,001-4,000 lbs C=4,001-5000 lbs	Product No.; 2=LT20/25, 3=LT30/40, 4=LT30HD/40HD, 5=LT30/40 Super, 6=LT30HD/40HD Super	Length of the Trailer; 20=20 Ft., 24=24', 35=35'	Number of axles on the trailer	Check Digit Add all the number and divide by 11	Year of Manufacture; S=1995, T=1996, U=1997, V=1998, W=1999, X=2000	State of Manufacture N=Indiana, P=Poland	Month of Manufacture A=January, B=February, C=March, etc...	Revision Level	Sequence Number Ranging from 000-999	End of 17-Digit VIN	Revision Level (Repeated)	Two-Digit Minor Revision Level
456	A	5	24	1	X	S	N	A	F9	017		F9	.01

V.I.N. DESCRIPTION

Each sawmill is also identified with a model number which includes the base model and the engine/motor configuration. See the figure for a description of the model number.

LT25
Basic Sawmill I.D.

G11
Engine/Motor
Configuration

MODEL NUMBER DESCRIPTION.

When you pick up your mill, you will receive a customer number. Both the VIN and your customer number expedite our service to you. Please write these numbers below so you have quick, easy access to them.

Customer No.	Model No.	V.I.N.	Revision

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SECTION 1 SAFETY & GENERAL INFORMATION



This symbol calls your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions. This symbol accompanies a signal word. The word **DANGER** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. **WARNING** suggests a potentially hazardous situation which, if not avoided, could result in death or serious injury. **CAUTION** refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury to persons or equipment. Read all safety instructions before operating this equipment and observe all safety warnings!



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.

Read and observe all safety instructions before operating this equipment! Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

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

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

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

1.1 Blade Handling



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



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

1.2 Sawmill Setup



WARNING! Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

WARNING! Failure to put front outrigger down before moving cutting head from the rest position may result in serious injury.

WARNING! Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

WARNING! Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

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



CAUTION! Changes in temperature could cause increased pressure in the blade tensioner and loss of fluid from the gauge. Release the blade tension when the mill is not in use to avoid damage to the tensioner.

1.3 Sawmill Operation



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.

Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

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

DANGER! Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.

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

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

DANGER! Keep all persons out of the path of returning boards. Failure to do so will result in serious injury.



WARNING! Always disengage the clutch/brake mechanism whenever the sawmill is not cutting. Failure to do so may result in serious injury.

WARNING! Always wear eye, ear, respiration, and foot protection when operating the sawmill. 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 log is clamped securely before sawing. Failure to do so may result in serious injury or death.

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.



CAUTION! Be sure the pivot rails, turning arm, clamp, and toe boards are below bed level before loading a log onto the bed. Failure to do so may result in machine damage or cause misalignment.

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! Do not use the blade guide arm knob to move the carriage head forward and backward. Damage to the blade guide arm may result.

CAUTION! Be sure to stop the blade when returning the carriage. 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.

1.4 Sawmill Maintenance



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

WARNING! Always secure the cutting head with a chain or a brace before adjusting the mast pads. The cutting head may fall, causing severe injury or death.



CAUTION! Do not over-grease the blade guide bearings. Over-greasing will push the seals out of the bearings causing premature failure.

CAUTION! Reinstall the track wiper so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.

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

CAUTION! Do not use chain lube. It causes sawdust buildup in chain links.

CAUTION! Due to variations in the vertical mast, the pad spacing may vary throughout the travel of the saw head. Check the pad spacing at the top and bottom ends of the mast only. Pads adjusted too tight will cause premature up/down motor failure.

CAUTION! It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

1.5 Belt Sizes

See Table 1-1. Belt sizes for the LT25 are shown.

Description	Belt Size	Wood-Mizer Part #
Engine Drive Belt (G15)	2BX72	P09555-2
Blade Pulley Belts	B57 ¹	P04185

TABLE 1-1

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

1 Safety & General Information

Blade Sizes

1.6 Blade Sizes

See Table 1-2. Wood-Mizer TRU•SHARP™ offers three types of blades to provide efficient sawing for all models of sawmills. The engine/motor size of your sawmill and the type of wood you saw should determine which blade you choose for optimum performance.

	Softwood	Medium Hardwood	Frozen Timber or Dense Hardwood
5-15HP Gas	.042 x 1 1/4" x 10°	.035 x 1 1/4" x 10°	.042 x 1 1/4" x 10°
7.4-11kW (10-15HP) Electric 16-24HP Gas 30HP Diesel	.045 x 1 1/2" x 10° or .045 x 1 1/4" x 10° ¹	.042 x 1 1/4" x 10°	.045 x 1 1/4" x 9° ²
15-18.5kW (20-25HP) Electric 40HP Diesel	.045 x 1 1/2" x 10° or .045 x 1 1/4" x 10° ¹	.045 x 1 1/2" x 10° or .045 x 1 1/4" x 10° ¹	.045 x 1 1/4" x 9° ²

TABLE 1-2

¹ Customer may choose preferred blade.

² TRU•SHARP™ 9° blades use a 9/29 profile (9° hook angle and 29° back angle) and are designed to cut frozen and/or extremely dense, hard-to-cut wood. Standard TRU•SHARP™ blades use a 10/30 profile.

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

1.7 Cutting Capacity

See Table 1-3. The log size capacities of the LT25 sawmill are listed below.

	Max. Diameter ¹	Max. Length ¹
LT25	32" (81 cm)	16' 8" (5.1 m)
LT25L	32" (81 cm)	21' (6.4 m)

TABLE 1-3

¹ Maximum log capacity for a basic mill is 4400 lbs. (1996 Kg).

See Table 1-4. The performance capacity of the LT25 sawmill is listed below. Peak cutting rates are measured in 12" (30 cm) wide red oak and represent the capability of the sawmill only. Rates based on using Tru-Sharp 1 1/4" x .042 blades.

Model	Cutting Rate
LT25/25L G15	17 ft./min. (5.2 m/min.)

TABLE 1-4

1 Safety & General Information

Engine/Motor Specifications

1.8 Engine/Motor Specifications

See Table 1-5. The power options available for the LT25 sawmill are listed below.

Engine/Motor Type ¹	Manufacturer	Model No.	Power	Other Specifications
15HP Gasoline	Kohler	PA44501	15KM	---
11HP Electric	Tamel SA, Poland	Sg 112M-2PE	7,5kW	14,7 A, 2950 RPM

TABLE 1-5

1

See Table 1-6. LT25The noise levels of the Wood-Mizer sawmills are listed below.

	Idle	Engaged
Sawmill Equipped With Gas Engine	95 dB (A)	98 dB (A)
Sawmill Equipped With Electric Motor	79 dB (A)	93 dB (A)

TABLE 1-6

1.9 Overall Dimensions

See Table 1-7. The overall dimensions of the Wood-Mizer sawmills are listed below.

Model	Length ¹	Width ²	With (Operating Position with Loading Arms)	Height ³	Weight	Weight w/Trailer
LT25 G15 w/Trailer	21' 11" (6.7 m)	6' 6" (2 m)	11' 5" (3.5 m)	7' 8" (2.4 m)	2051 lbs. (923 kg)	2373 lbs. (1068 kg)
LT25L G15	26' 2" (8 m)	6' 6" (2 m)	11' 5" (3.5 m)	7' 8" (2.4 m)	2251 lbs. (1013 kg)	2573 lbs. (1158 kg)

TABLE 1-7

¹ Length from hitch to chain bracket.

² Width from fender to fender.

³ Height from ground to mast. Placing head in maximum position will add to total height.

1.10 Chains

See Table 1-8. The load capacity of the chains is listed below.

	Load Capacity According to ISO Nr 08A-1
Up/Down Chain	1780N

TABLE 1-8

1 Safety & General Information

Components

1.11 Components

See **Figure 1-1**. The major components of the Wood-Mizer LT25 are shown below.

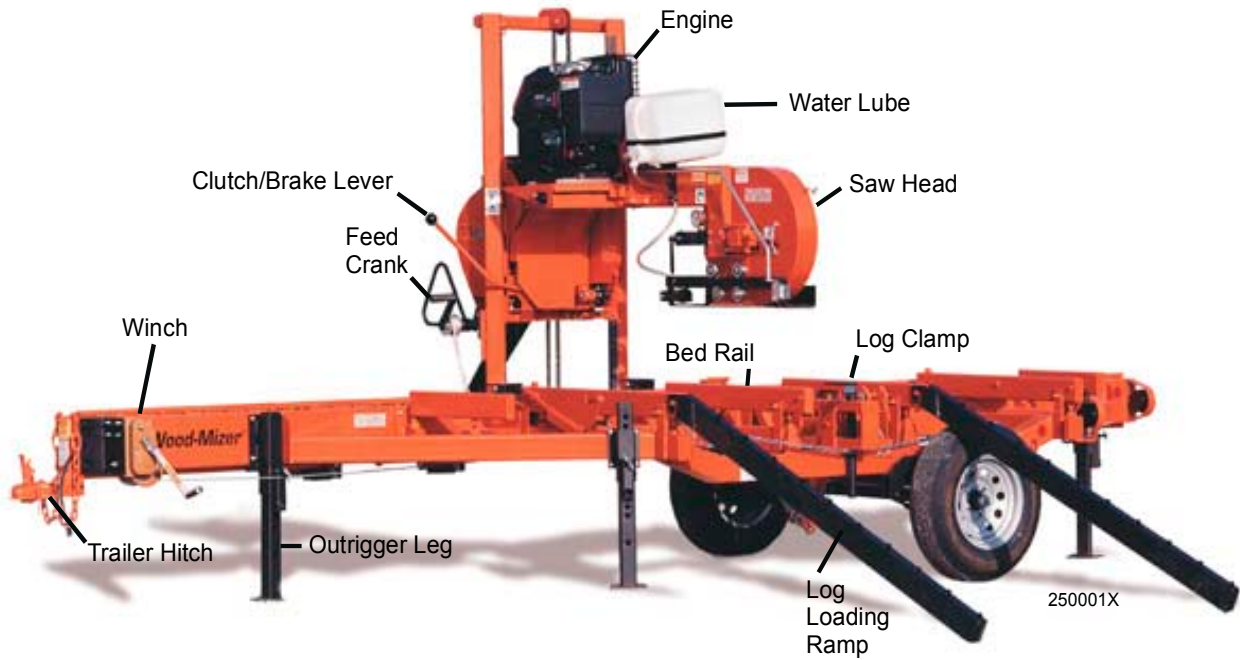


FIG. 1-1

SECTION 2 SETUP & OPERATION

2.1 Stationary Sawmill Setup

See Figure 2-1. Set up the mill on firm footing and level by eye. Fasten the mill to the floor to prevent any creep after prolonged use. A cement pad with 5/8" diameter anchor bolts is recommended. The cement pad should be rated to support 6350 lbs./sq.ft. at each sawmill foot position.

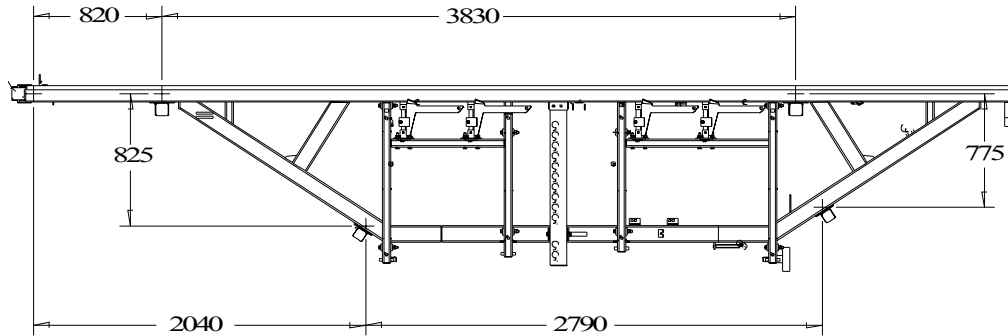
NOTE: Make sure the unit is level before securing. It IS possible to twist the mill frame by jacking one foot higher than the others.



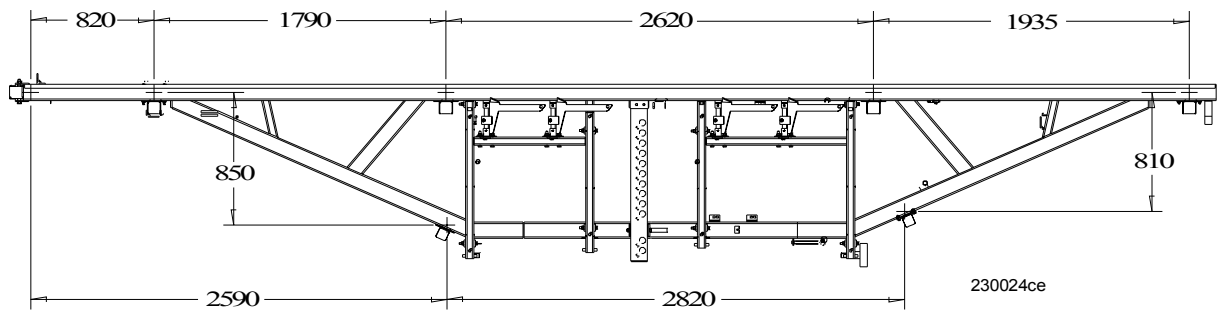
WARNING! Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

2 Setup & Operation

Stationary Sawmill Setup



LT25/LT30 Stationary Metric Dimensions*



LT25/LT40 Stationary Metric Dimensions*

*All dimensions in millimetres

FIG. 2-1

1. Unhook the carriage safety chain, located at the bottom of the vertical mast.
2. Use the up/down crank to raise the cutting head from the carriage rest pin. Swing the rest pin down below bed level.
3. Use the feed handle to move the cutting head toward the front end of the mill. Raise the two side supports that will prevent a log from falling off the side of the mill when loaded.

See Figure 2-2.

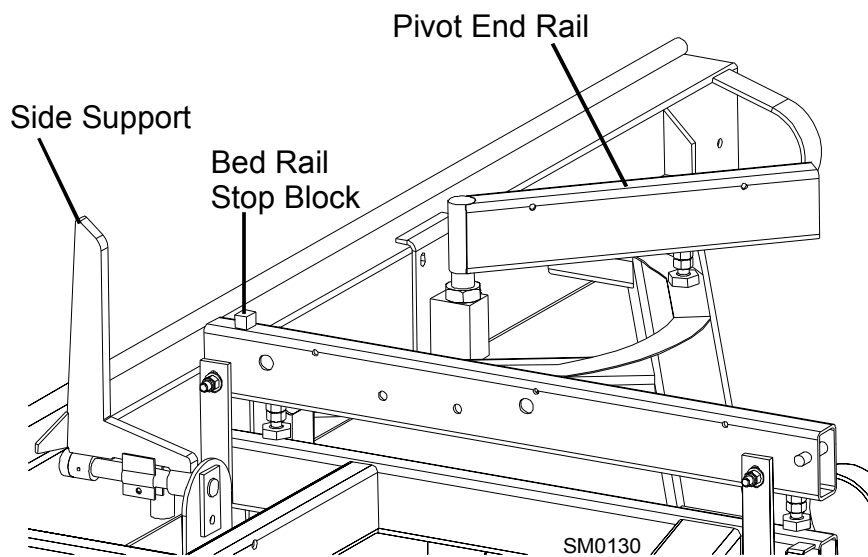


FIG. 2-2

2.2 Portable Sawmill Setup



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

WARNING! Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

WARNING! Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

1. Unhitch the mill from the vehicle.
2. Lower and set the front three outriggers. Lift the weight from the locking pin using the jack handle. Pull the locking pin to release the outrigger and lower the outrigger as necessary. Secure with the locking pin.

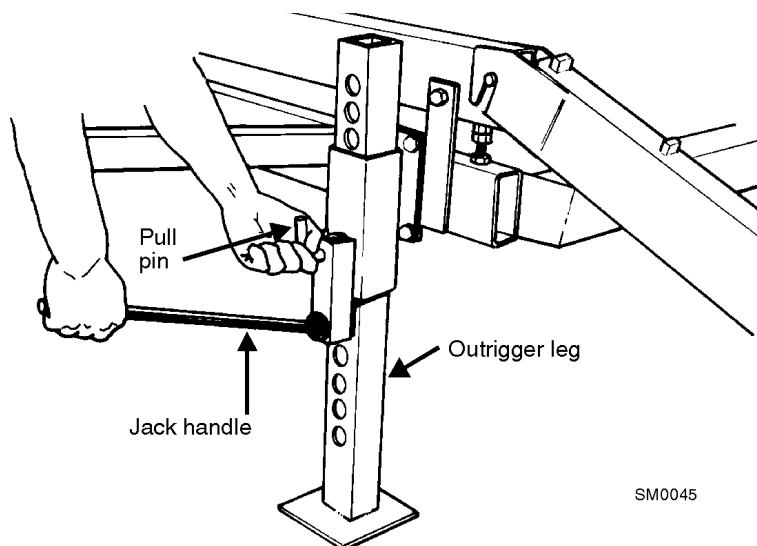


FIG. 2-2. OUTRIGGER ADJUSTMENT.

3. Unhook the carriage safety chain, located at the bottom of the vertical mast.
4. Use the up/down crank to raise the cutting head from the carriage rest pin. Swing the rest pin down below bed level.



WARNING! Failure to put front outrigger down before moving cutting head from the rest position may result in serious injury.

2 Setup & Operation

Portable Sawmill Setup

5. Remove the fenders by lifting them out of the slots.



CAUTION! To prevent fender damage, remove fenders before operating sawmill or loading logs.

6. Use the feed handle to move the cutting head toward the front end of the mill. Lower and set the remaining rear outriggers.
7. Level the sawmill by adjusting the outriggers to raise or lower each end of the sawmill. Adjust all outriggers evenly to avoid twisting the mill frame by jacking one outrigger higher than the others.

Raise the two side supports to prevent the log from falling off the side of the mill when loaded.

See Figure 2-3.

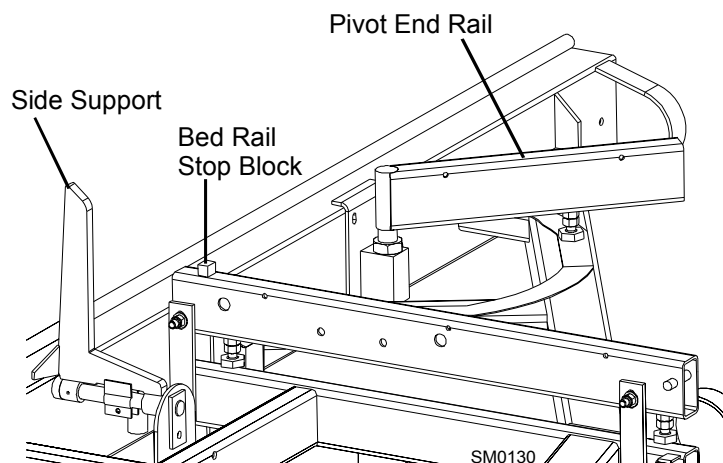


FIG. 2-3

2.3 Middle Track Cover

Before operating the sawmill do as follows:

1. Clean the upper and lower rails to remove any sawdust and rust preventives.
2. Unbolt and remove the middle track cover from its storage position.
3. Soak the felt wiper with Dexron III transmission fluid, 10W30 motor oil or 3-in-1 turbine oil.
4. Install the middle track cover so it fits against the rail and secure with two thumb screws.

See Figure 2-4.

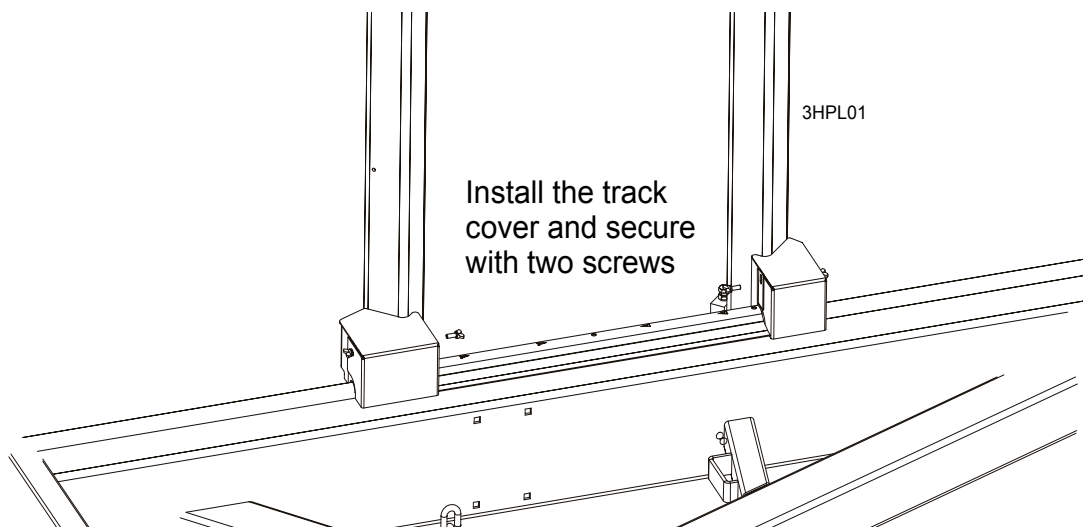


FIG. 2-4



CAUTION! Install the track cover so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.

2.4 Replacing The Blade



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



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.

Remove the two main blade housing covers that cover the blade wheels. Lower the hinged middle blade housing cover. Turn the blade tension handle to release the blade tension until the wheel is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

When installing a blade, make sure the teeth are pointing the correct direction. The teeth should be pointing toward the operator side of the mill when you are looking at the blade below the blade guides. Install the blade so it is lying around the wheels.

Position 1 1/4" wide blades on the wheels so the gullet is 1/8" (3.0 mm) out from the edge of the wheel. Position 1 1/2" wide blades on the wheels so the gullet is 3/16" (4.5 mm) out from the edge of the wheel.

Close the middle blade housing cover.

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

2.5 Tensioning The Blade

See Figure 2-5. Tension the blade by turning the hydraulic tensioning handle clockwise until the tension gauge indicates the recommended tension.

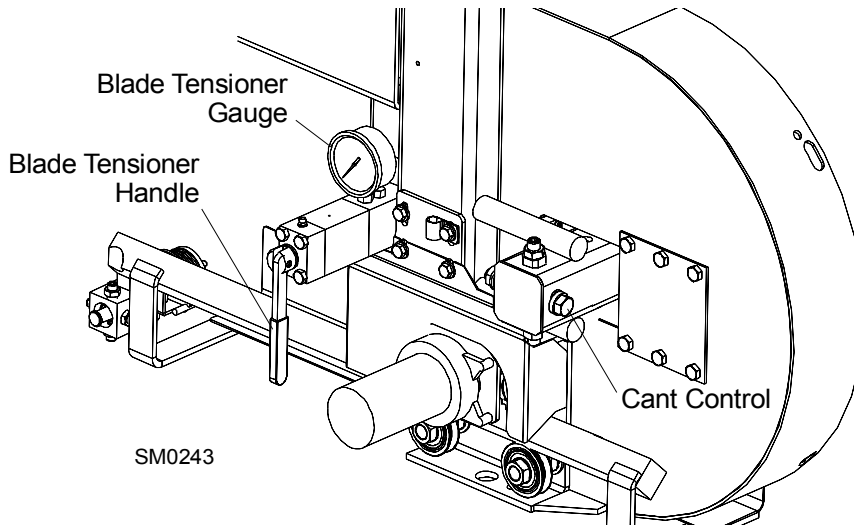


FIG. 2-5

See Table 2-1. The recommended tension for different blades is shown below.

Blade Type	Acceptable Range	Ideal Tension
.035" x 7/8" x 1 1/4"	1800 - 2100 psi	2000 psi
.042" x 7/8" x 1 1/4"	2100 - 2400 psi	2300 psi
.045" x 7/8" x 1 1/2"	2100 - 2400 psi	2300 psi

TABLE 2-1

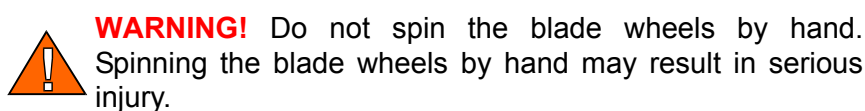
The tension gauge should be checked occasionally when adjusting the cant control or while cutting. Ambient temperature changes will cause tension to change. Adjust the tension handle as necessary to maintain the recommended tension level.



CAUTION! Changes in temperature could cause increased pressure in the blade tensioner and loss of fluid from the gauge. Release the blade tension when the mill is not in use to avoid damage to the tensioner.

2.6 Tracking The Blade

1. Make sure the middle blade housing cover is closed and all persons are clear of the open side of the saw head.
2. Start the engine.
3. Pull lightly on the clutch handle, rotating the blade until the blade positions itself on the wheels.



4. 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.

See Figure 2-6. Position 1 1/4" wide blades so the gullet is 1/8" (3.0 mm) out from the edge of the blade wheel ($\pm 1/16$ [1.5 mm]). Position 1 1/2" blades so the gullet is 3/16" (4.5 mm) out from the edge of the blade wheel ($\pm 1/16$ [1.5 mm]).

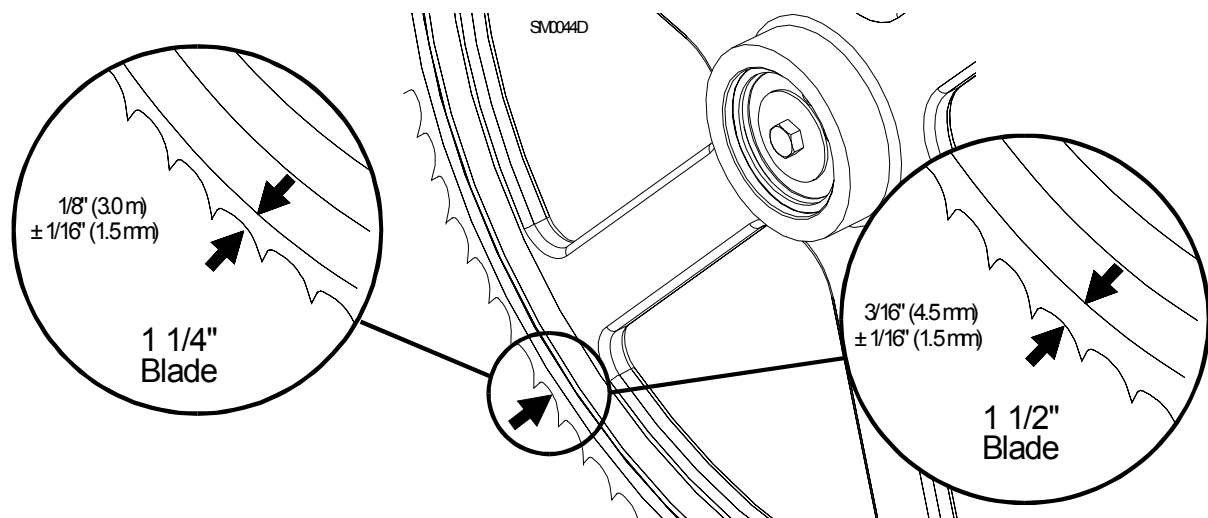


FIG. 2-6

5. To adjust where the blade travels on the blade wheels, use the cant control shown in Figure 2-5.

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

6. Retension the blade to the recommended tension to compensate for any adjustments you have made in the cant control.
7. Replace the blade housing covers.



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. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

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

2.7 Starting The Engine

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



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. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

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 will result in serious injury.



WARNING! Always wear eye, ear, respiration, and foot protection when operating the sawmill. Failure to do so may result in serious injury.

2.8 Loading, Turning, And Clamping Logs



CAUTION! Be sure the pivot rails, turning arm, clamp, and toe boards are below bed level before loading a log onto the bed. Failure to do so may result in machine damage or cause misalignment.

To Load Logs

1. Place the loading ramps on the two bed rails that will support the length of the log. **NOTE:** The loading ramps cannot be fastened securely to the bed rail located directly above the tire. Do not use this rail.
2. Position the log at the foot of the ramps.
3. Remove the winch cable from the log turner (if applicable) and route the cable over the top of the log. Wrap the cable around and underneath the log. Hook the cable to the third hole in the log clamp bracket. See *Winch Operation Manual*.
4. Crank the winch to begin rolling the log up the ramps and onto the sawmill bed. Keep the log centered on the ramps as it rolls up.
5. Once the log is on the sawmill bed, place the log clamp in the clamp bracket. This will stop the log from rolling back off the side of the mill when you remove the winch cable.

NOTE: Logs also may be loaded onto the mill with a tractor or other equipment specifically designed for that purpose.

To Turn Logs

1. Use cant hooks or the optional log turner to rotate the log on the sawmill bed. See *Log Turner Manual*.
2. Spin the log against the side supports until it is turned the way you want it for the first cut. If you want to turn the log more, do the following steps.
3. Raise the turner arm to get a new bite on the log.
4. Disengage the clamp.
5. The log can be turned now. Repeat steps 4 through 7 until the log is turned as desired.

To Clamp Logs

1. Position the log clamp in the bracket in the hole closest to the log.
2. Move the clamp down far enough so that it is below your first few cuts. Pivot the clamp so that it moves the log firmly against the side supports. Lock the clamp in position with the locking chain.

See Figure 2-7.

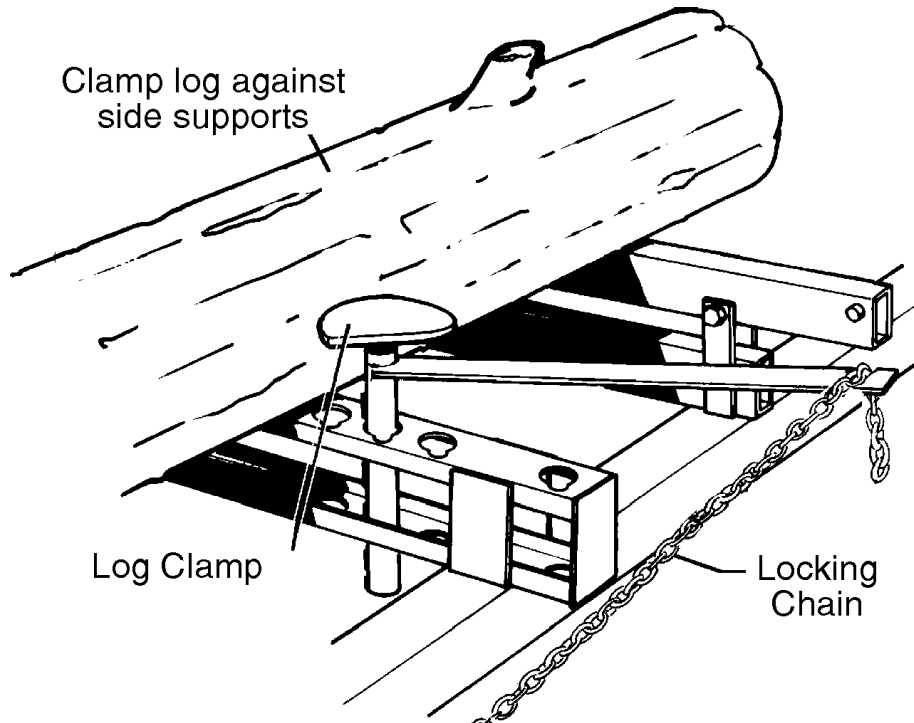


FIG. 2-7

3. Make sure the side supports are positioned low enough for the blade to pass over them. If they are not, back the clamp off slightly and push the side supports down until they are positioned below the level of your first few cuts.
4. Use the optional toe boards to level the log if desired. See the manual supplied with the manual toe boards for details concerning toe board operation.

To Level A Tapered Log

Use the optional toe boards to raise either end of a tapered log, if desired. See the Toe Board Option Manual for operating instructions.

2.9 Up/Down Operation

1. Install a blade, if needed, and check for correct blade tension. ([See Section 2.5](#)).
2. Set the cutting head to the desired height. (The blade height scale shows the height of the blade above the bed rails.)

See **Figure 2-8**. Use the up/down crank to raise or lower the cutting head.

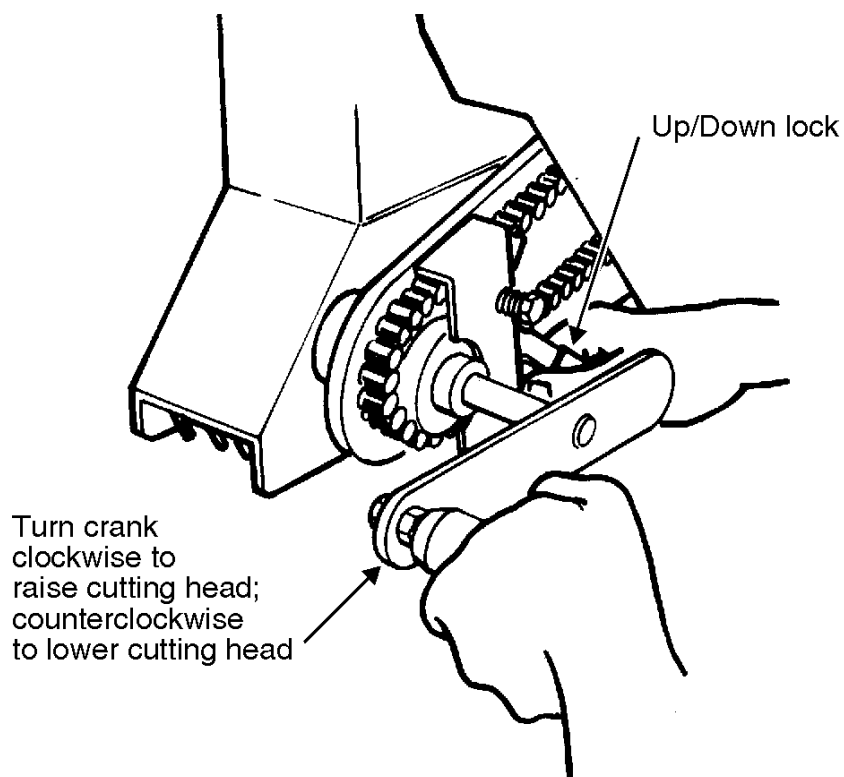


FIG. 2-8

3. To raise the cutting head, turn the up/down crank clockwise until the desired blade height is reached.
4. To lower the cutting head, lift the up/down lock. Turn the up/down crank counterclockwise as desired. Lower the lock until it seats firmly between the teeth of the up/down sprocket.



CAUTION! DO NOT try to force the carriage above the 35" (88 cm) mark or below the 1" (2.54 cm) mark. Damage to the up/down system may result.

2.10 Blade Guide Arm Operation

1. Look down the length of the log to see its maximum width. The outer blade guide should be adjusted to clear the widest section of the log by less than 1" (25.4 mm).
2. Use the blade guide arm knob to adjust the outer blade guide as necessary. Pull the blade guide arm knob out away from the mill to move the arm in. Push it in toward the mill to move the arm out.

See Figure 2-9.

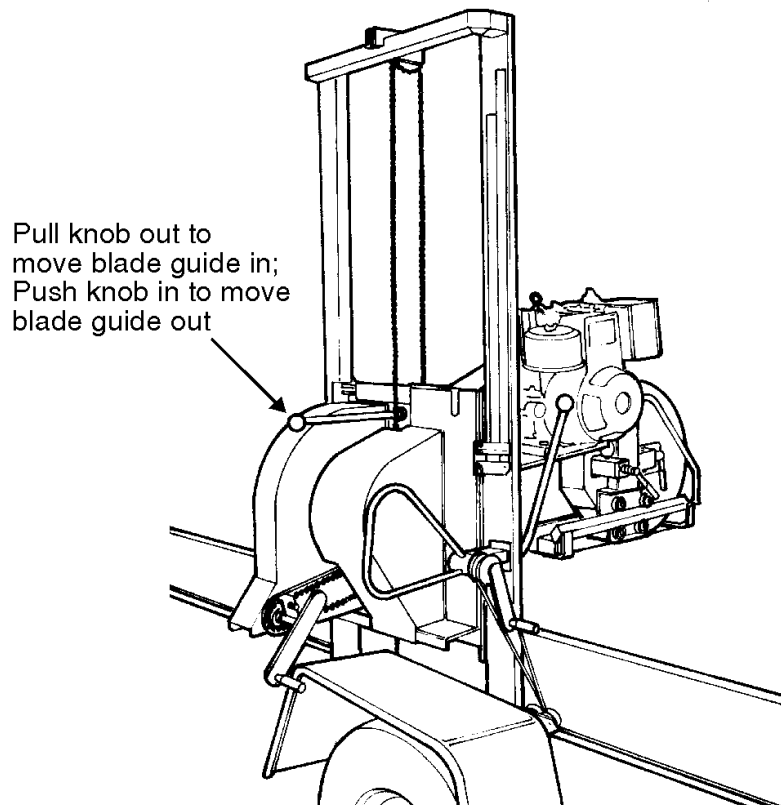



FIG. 2-9

2.11 Clutch/Brake Operation

1. Clear any loose objects from the area of the blade, motor, and drive belt.
2. Make sure the clamp and side supports are adjusted below the level of your first few cuts.
3. Start the engine or motor as instructed in the engine manual.

 **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. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

Be sure the blade housing and pulley covers are in place and secure before starting the engine or motor. Use the safety retainer pin and cable to fasten blade housing covers.

See **Figure 2-10**. The clutch/brake lever is located next to the engine.

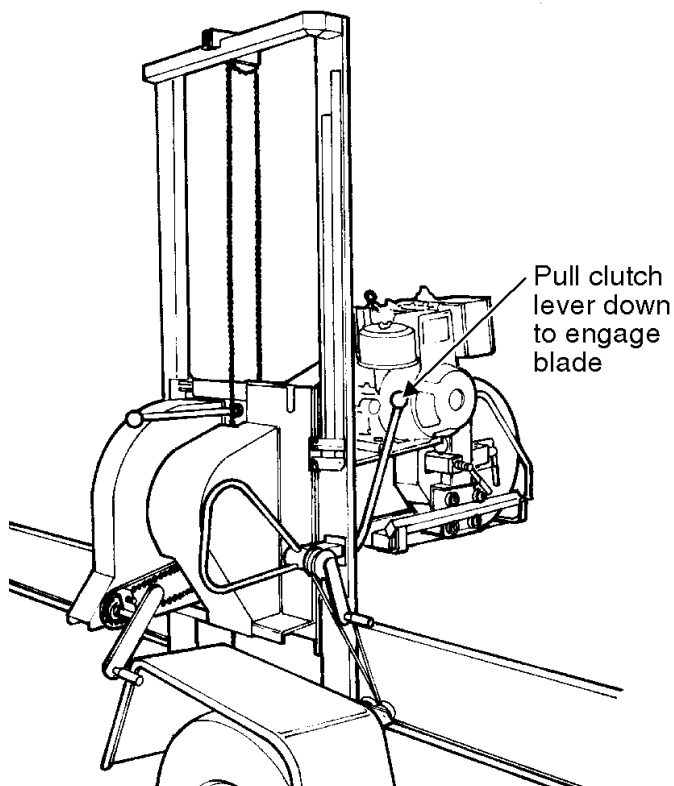


FIG. 2-10

4. To engage the blade, pull the lever down until it locks in the down position. This engages the drive mechanism, releases the blade brake, and increases the engine speed to full throttle.

To disengage the blade, raise the clutch/brake lever to the up position. This disengages the drive belt, engages the blade brake, and returns the engine to idle.

2.12 Feed Operation

The feed system includes a hand crank to move the carriage forward or backward. The speed at which the carriage travels forward depends on how fast you turn the feed crank.

The height of the feed crank is adjustable. There are two sets of mounting holes, one higher and one lower. To change the height of the feed crank, unbolt the crank assembly from the carriage and reinstall to the desired set of mounting holes.

See Figure 2-11.

1. To move the carriage forward, rotate the feed crank clockwise.

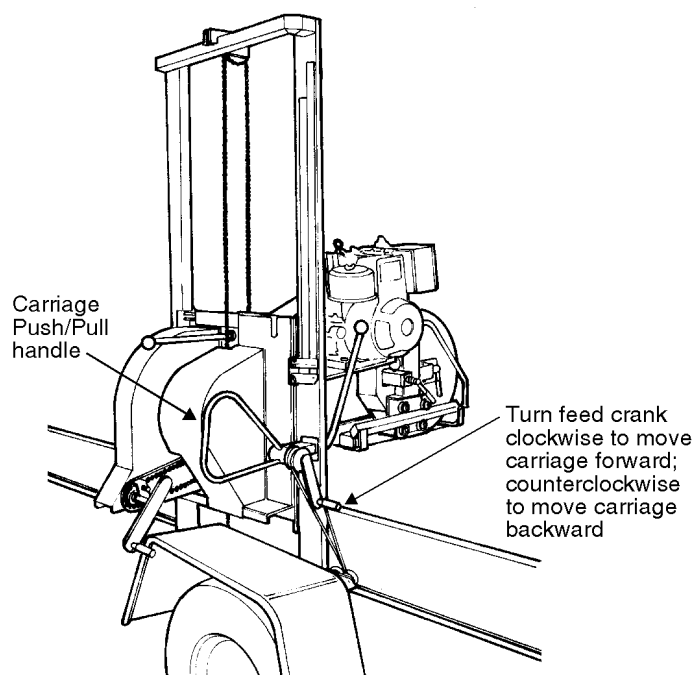


FIG. 2-11

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 engine and blade wear, and also produces a wavy cut.

2. To move the carriage backward, rotate the feed crank counterclockwise, or use the carriage push/pull handle. Always disengage the blade before returning the carriage and raise the carriage slightly to make sure the blade clears the log.



CAUTION! Be sure to stop the blade when returning the carriage. 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! Do not use the blade guide arm knob to move the carriage head forward and backward. Damage to the blade guide arm may result.

3. Make sure that the blade does not catch on the end of the log. Raise the carriage slightly to make sure the blade clears the log when returned. **HINT:** Try to stop the blade while the heel of the blade is still on the log. Then bring the carriage 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.



DANGER! Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.

2.13 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 clamped 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 2.15](#)). The blade height scale will help you to do this. Set the blade to the desired height with the up/down crank. Make sure that the blade will clear all side supports and the clamp. Adjust the outer blade guide to clear the widest section of the log by moving the blade guide arm knob.
3. Make sure all covers and guards are in place. Start the engine. Engage the clutch/brake lever to start the blade spinning.
4. Start the water lube if necessary to prevent sap buildup on the blade. [See Section 2.16](#).
5. Feed the blade into the log slowly ([See Section 2.12](#)). 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, turn the feed rate all the way down and disengage the clutch/brake lever. Remove the slab that you have just cut from the log.
7. Use the feed crank or the carriage push/pull handle to return the carriage to the front of the mill. Always disengage the blade before returning the carriage 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. Lower the toe boards, if they were used. Remove the clamp and turn the log 90 or 180 degrees. Make sure the flat on the log is placed flat against side supports if turned 90 degrees. Make sure it is placed on bed rails if turned 180 degrees. If the log was turned 90 degrees and you are using toe boards to compensate for taper in the log, raise the front or rear toe board again on the second side of the log until the heart is parallel with the bed.
10. Repeat the steps used to cut the first side of the log until the log is square. Cut boards from the remaining cant by adjusting the blade height for the thickness of boards that you want.

Example: Remember that the blade cuts a 1/16 - 1/8" (1.6-3.2 mm) wide kerf. If you want 1" (25.4 mm) thick boards, lower the carriage 1 1/16 - 1 1/8" (27-28.6 mm) for each board.

2.14 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 flitches, or the boards that need to be edged.
2. Stack the flitches on edge against the side supports.
3. Clamp the flitches against the side supports halfway up the flitch 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 flitches 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 clamp and turn the edged boards over to edge the other side.
6. Repeat steps 2-4.
7. Loosen the clamp and remove the boards that have good clean edges on both sides. Clamp the remaining flitches and repeat steps 2-5.

2.15 Blade Height Scale

See Figure 2-12. The blade height scale is attached to the carriage head frame. It includes:

- two blade height indicators
- an inch scale
- a quarter scale

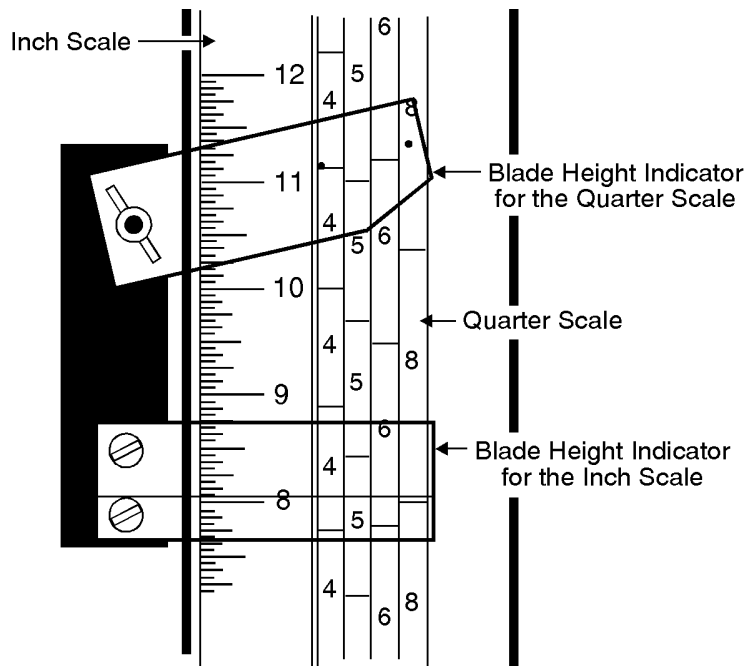


FIG. 2-12

The two indicators are plastic markers that move up and down with the cutting head. The lower indicator is used to read the inch scale, and the upper indicator is used to read the quarter scale.

The Inch Scale

The horizontal red line on the blade height indicator shows how many inches 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 carriage to an even measurement on the inch scale. Make a trim cut. Return the carriage for the second cut and lower it 1 1/8" (29 mm) below the original measurement. (The extra 1/8" (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 before sawing

The Quarter Scale

See Table 2-2. The quarter scale has four sets of marks. Each set represents a specific lumber thickness. Saw kerf and shrinkage allowance are included, but actual board thickness will vary slightly depending on blade thickness and tooth set.

An optional Grade Hardwood Quarter Scale is also available. 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		Grade Hardwood Quarter Scale	
Scale	Actual Board Thickness	Scale	Actual Board Thickness
4/4	1" (25 mm)	4/4	1 1/8" (29 mm)
5/4	1 1/4" (32 mm)	5/4	1 3/8" (35 mm)
6/4	1 1/2" (38 mm)	6/4	1 5/8" (41 mm)
8/4	2" (51 mm)	8/4	2 1/8" (54 mm)

TABLE 2-2

To use the quarter scale, look at the upper blade height indicator. It has two red dots. Loosen the wing nut and angle the indicator until one of the red dots is on the nearest mark of the desired lumber thickness scale.

When you return the carriage for a second cut, you can lower the carriage to the next mark on the lumber thickness scale you chose, without having to measure on the inch scale.

Example: You want to cut 1" (25 mm) (4/4) random width boards from a log. Position the blade for the first cut. Loosen the wing nut on the left end of the indicator. Move the indicator until one of the red dots is on the nearest 4/4 mark. 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.

2.16 Water Lube Operation

See **Figure 2-13**. 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.

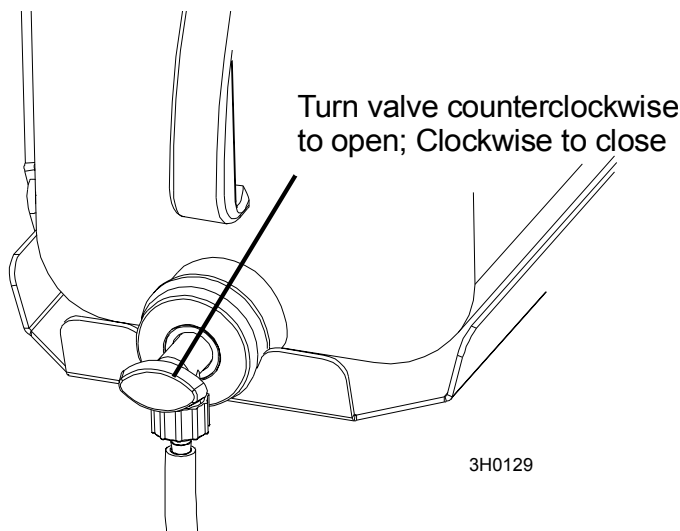


FIG. 2-13

Not all types of wood require the use of the Water Lube System. When it is needed, 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.



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. 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.

2.17 Preparing The Sawmill For Towing

The Wood-Mizer trailer package makes transporting your sawmill easy and convenient. To get your sawmill ready for towing, follow these instructions.

1. Move the saw carriage to the front end of the sawmill. Raise the rear outriggers.
2. Move the carriage forward to the travel position over the rear bed rail.
3. Position the hole in the saw head over the travel rest pin.
4. Lower the saw head until it is seated firmly on the rest pin.

See Figure 2-14.

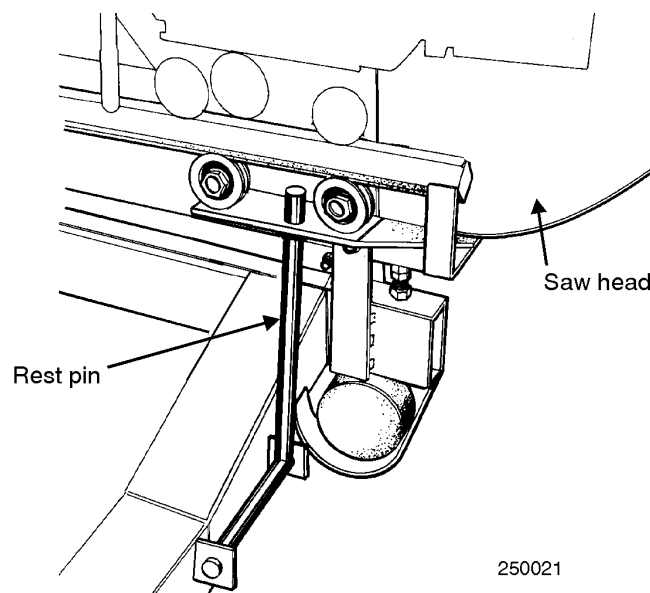


FIG. 2-14

5. Continue lowering the head 3/4" (19mm) until it contacts the stop blocks on the mast rails.



CAUTION! It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

6. If necessary, adjust the two stops located at the bottom of the mast so the saw head contacts them after it is lowered 3/4" (19mm) past where it contacts the rest pin.

See Figure 2-15.

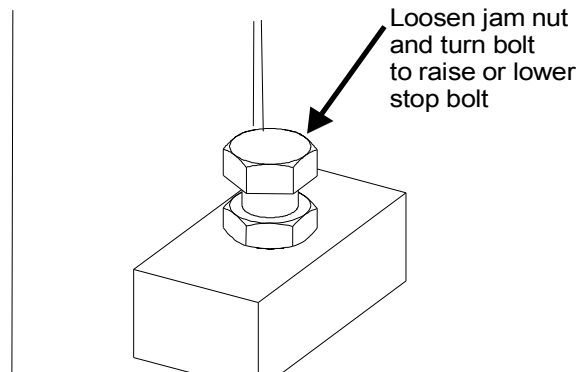


FIG. 2-15

7. Engage the clutch/brake lever. This keeps the drive belt tight and the motor from bouncing while traveling. Be sure to disengage the clutch/brake handle after reaching the destination to avoid deformation of the drive belt.

8. Hook the carriage safety chain located at the bottom of the carriage to the bracket at the bottom of the mast.

See Figure 2-16.

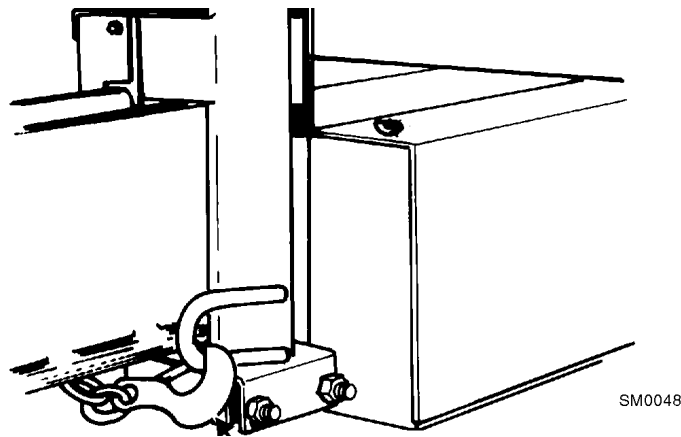


FIG. 2-16

9. Store the loading ramps on the bed rails. Secure to the bed with the two retaining brackets.



CAUTION! Check to be sure the saw head safety chain is secured before towing the sawmill. Failure to properly secure the saw head can result in severe machine damage. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

10. Remove all loose objects from the bed of the mill. Store the outrigger jack handle in the bracket provided on the rear/loading-side outrigger guide. Reel in the winch cable. Remove the winch handle.
11. Place both fenders in the slots located behind the trailer tires and secure with retaining pins. Raise all but the very front outrigger.

See the trailer operator's manual for specific information regarding hitch operation and towing the sawmill.

2.18 Manual Toe Board

In many cutting operations, particularly cutting for grade, it is desirable to cut tapered logs parallel to the heart of the log. The optional toe boards allow the operator to lift either end of a log to parallel the heart to the path of the blade.

1. When a log is loaded and ready for the first cut, measure from the bed rail or auxiliary support to the heart of the log.

See Figure 2-17.

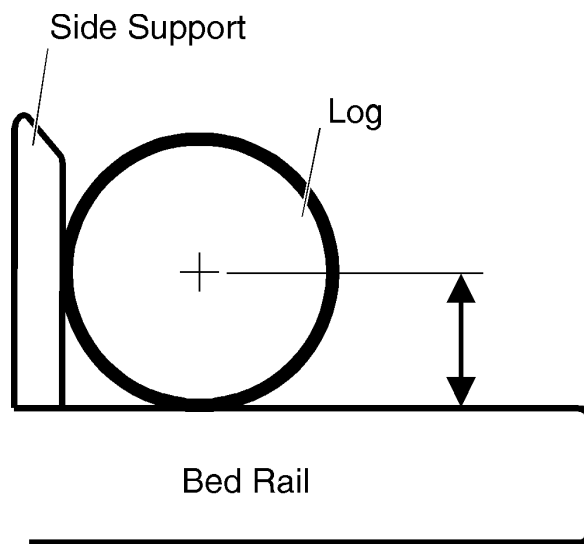


FIG. 2-17

2. Measure at the other end of the log and compare distances. The distance from the bed to the heart on one end of the log should be within 1/2" (12.5 mm) of the measurement from the bed to the heart on the other end of the log.
3. If adjustment is necessary, place the crank handle on the toe board at the end of log to be raised. Turn the handle clockwise to raise the end of the log. Raise about half the difference measured as the other end of the log will typically lower as the end being raised goes up. Remeasure both ends of the log from the bed rails and adjust toe board as necessary until both ends measure the same distance from the bed rails.

See Figure 2-18.

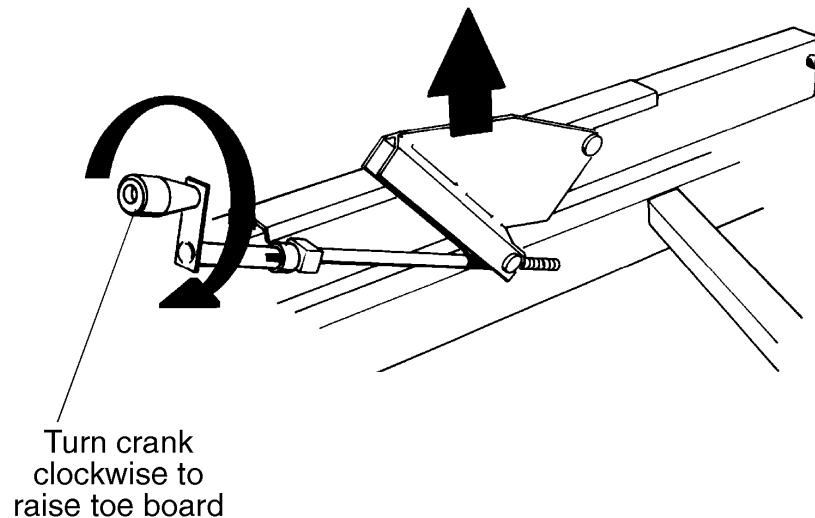


FIG. 2-18

4. Remove the toe board crank handle. Clamp the log against the side supports and make the desired number of cuts. When the log is rotated 180 degrees, lower the toe board so that the flat portion of the log now lies flat on the bed rails. This will result in the two opposite sides of the log cut parallel to the heart.



CAUTION! Be sure the pivot rails, turning arm, clamp, and toe boards are below bed level before loading a log onto the bed. Failure to do so may result in machine damage or cause misalignment.

5. Repeat these steps to square the remaining two sides of the log. If you do not have the toe board option, you can achieve the same results by shimming one end of the log so that the blade cuts parallel to the log's heart.



CAUTION! The maximum load capacity of individual toe boards is 1000 kg. Exceeding this limit may result in serious injury.



CAUTION! During sawing, one end of the log being

levelled must rest on the sawmill bed.



CAUTION! While levelling, never place your hands under the log.



CAUTION! Always be sure the toe boards are lowered all the way before loading a log onto the bed.

SECTION 3 MAINTENANCE

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

The Short Interval 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 machine maintenance by filling in the machine hours and the date you perform each procedure.



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

Be sure to refer to option and engine manuals for other maintenance procedures.

3.1 Wear Life

See Table 3-1. This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. Due to the many variables which exist during sawmill operation, actual part life may vary significantly. This information is provided so that you may plan ahead in ordering replacement parts.

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

TABLE 3-1

3.2 Blade Guides

1. Check the rollers for performance and wear every blade change. Make sure the rollers are clean and spinning freely. If not, rebuild them. Replace any rollers which have worn smooth or have become cone shaped. See The LT25 Parts manual for blade guide rebuild kits and complete roller assemblies.

See Figure 3-1.

2. Make sure the blade screw in the top center of the C-frame is 1/16" (1.5 mm) below the bottom of the blade. If not, loosen the nut and adjust the screw as necessary. Check the screw every blade change. Failing to maintain this adjustment will lead to early blade breakage.

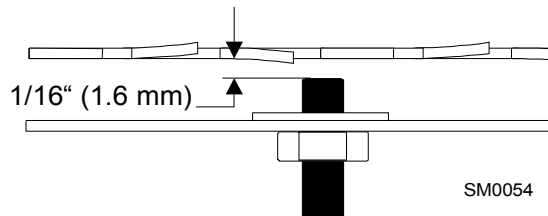


FIG. 3-1

3.3 Sawdust Removal

1. Remove the excess sawdust from the blade wheel housings and sawdust chute every blade change.

3.4 Carriage Track, Wiper & Scrapers

See Figure 3-2.

1. Clean the upper and lower track rails to remove any sawdust and sap buildup every eight hours of operation. Lubricate the lower track rail by wiping it with Dexron III ATF.
2. Remove sawdust from the upper cam housings. Loosen the thumb screws on the upper cam housing covers and open. Brush any sawdust buildup from the housings.
3. Check the track scrapers as needed. Make sure the scrapers fit firmly against the rail. If a track scraper needs to be adjusted, loosen the thumb screw, push the scraper downward until it fits firmly against the rail, and retighten the thumb screw.

Clean and lubricate the upper track wiper every twenty-five hours of operation. Unbolt the wiper, remove it from the sawmill, and remove any sawdust buildup. Soak the felt wiper with Dexron III transmission fluid, 10W30 motor oil or 3-in-1 turbine oil.

CAUTION! Reinstall the track wiper so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the power feed to bind.

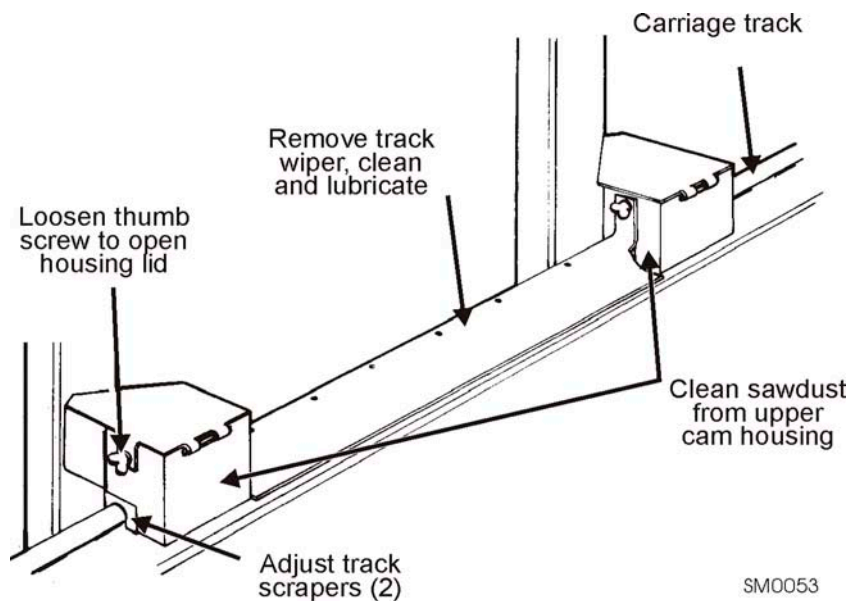


FIG. 3-2

3.5 Vertical Mast Rails



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 or emery cloth. Lubricate the mast with motor oil or automatic transmission fluid (ATF).



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

3.6 Miscellaneous

1. Apply a thin film of a NLGI No. 2 grade lithium grease to the blade guide arm every fifty hours of operation to help prevent it from rusting.
2. Lubricate the log turner (if equipped) with a NLGI No. 2 grade lithium grease every fifty hours of operation. Lubricate the turner pivot pins with WD-40 or a dry lube.
3. Grease the side supports with a NLGI No. 2 grade lithium grease every fifty hours of operation.
4. Oil all chains with Dexron III ATF every fifty hours of operation.



CAUTION! Do not use chain lube. It causes sawdust buildup in chain links.

5. Check the mill alignment every setup. See Section 5, Alignment.
6. 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.

3.7 Blade Tensioner

1. Lubricate the chrome rods of the tensioner system with a heavy duty teflon spray lubricant, such as Gunk L508, every fifty hours of operation.
2. Lubricate the tensioner screw handle with a NLGI No. 2 grade lithium grease as needed.

50

See Figure 3-3.

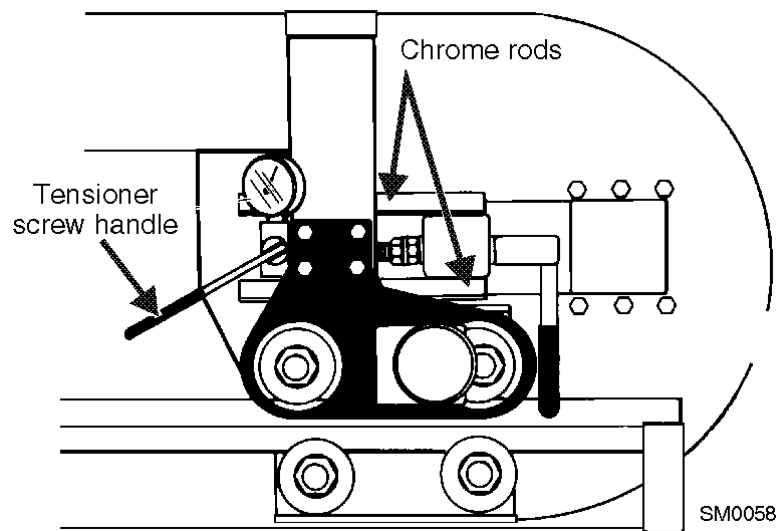


FIG. 3-3

3. Add an Automatic Transmission Fluid (ATF) such as Dexron III ATF to the hydraulic blade tensioner as needed.

See Figure 3-4. To add enough fluid to completely fill the tensioner block:

- Remove the tensioner handle and ball. Remove the sawmill blade housing covers, blade and idle-side blade wheel.
- Push the idle-side shaft housing all the way in to collapse the rear tensioner piston and fully extend the front piston. The front piston should reach the threaded area of the piston guide.

NOTE: If the hydraulic fluid level is extremely low, collapsing the rear piston may not fully extend the front piston. If it does not, finish the fill procedure in its entirety and repeat. The first pass should add enough fluid to allow the front piston to fully extend. The second pass should add enough fluid to completely fill the block.

- Locate the fill plug behind the tension gauge. Clean any dirt and debris from the plug area. Use a 7/16" wrench to remove the plug, making sure to keep the plug o-ring with the plug.
- Manually extend the rear piston (the front piston should remain extended).
- Use a small funnel or cup to completely fill the block with hydraulic fluid. When full, place the fill plug in the fill plug hole and thread 1-2 turns. Manually push the rear piston all the way in to allow excess oil and air to bleed from system through the plug. Tighten the plug all the way.
- Reinstall the idle-side blade wheel, blade and blade housing covers. Reinstall the tensioner ball and handle.

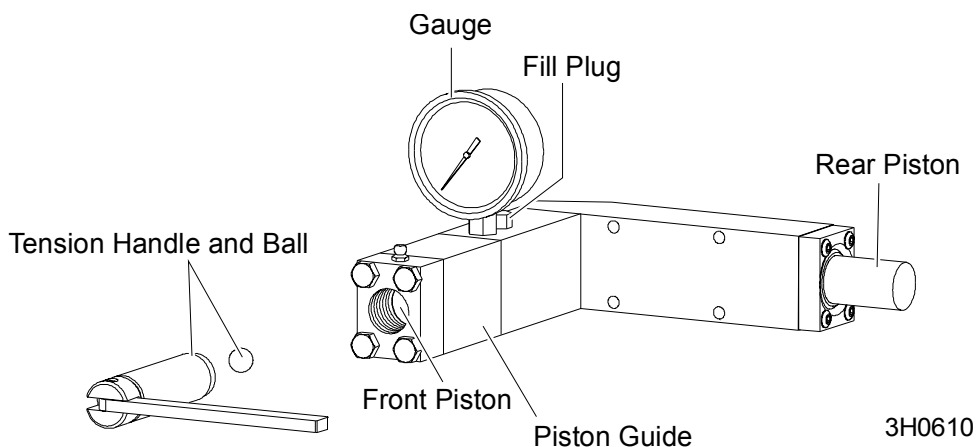


FIG. 3-4

3.8 Blade Wheel Belts

1. Rotate the blade wheel belts and check them for wear. Rotating the belts every 50 hours will give you longer belt life. Replace belts as necessary. Use only B57 belts manufactured by Goodyear or Browning.
2. Periodically check all belts for wear. Replace any damaged or worn belts as needed.

50

3.9 Brake Strap Adjustment

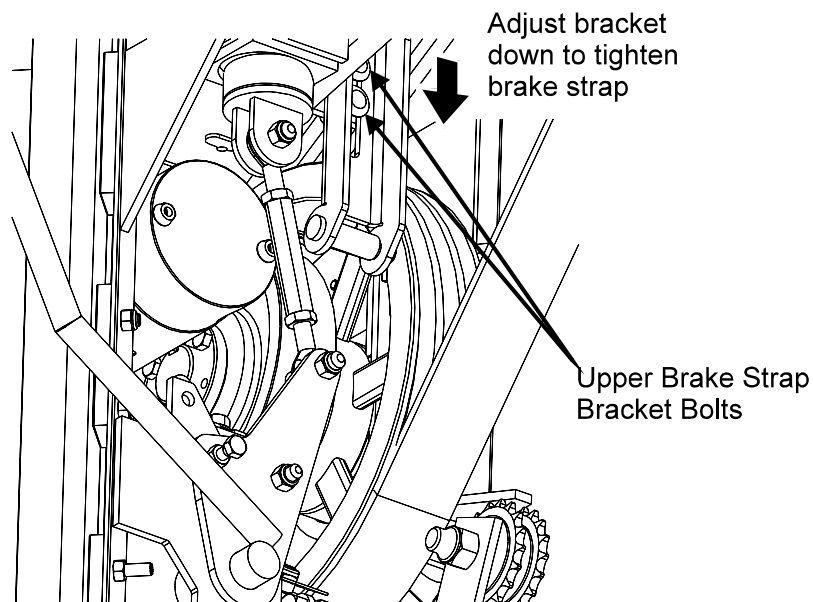
200

Check the brake strap for wear every 200 hours of operation. Replace if damaged or worn.

Also check and adjust the brake strap if the blade does not stop quickly, unusual sounds occur when the brake is applied, or a sudden change is noticed in the clutch handle position when the clutch is disengaged.

To access the brake strap, remove the belt cover located underneath the engine. Engage the clutch/brake lever.

See Figure 3-5. Loosen the two nuts on the upper brake strap bracket. Slide the bracket and brake strap down until snug. Retighten the bolts. Replace the belt cover.

**FIG. 3-5**

3.10 Drive Belt Adjustment



WARNING! Do not for any reason adjust the engine drive belts or belt support bracket with the engine running. Doing so may result in serious injury.



See Table 3-2. Check the drive belt tension after the first 20 hours, and every 50 hours thereafter. See the table below for drive belt tension specifications for your model sawmill.

Engine/Motor	Belt Tension
G15	7/16" (11mm) deflection with 8 lbs. of deflection force

TABLE 3-2

1. Remove the two belt covers located underneath the engine.
2. Loosen the drive belt turnbuckle jam nuts. Turn the turnbuckle counterclockwise (as viewed from the top) to tighten the belt, clockwise to loosen the belt.

See Figure 3-6.

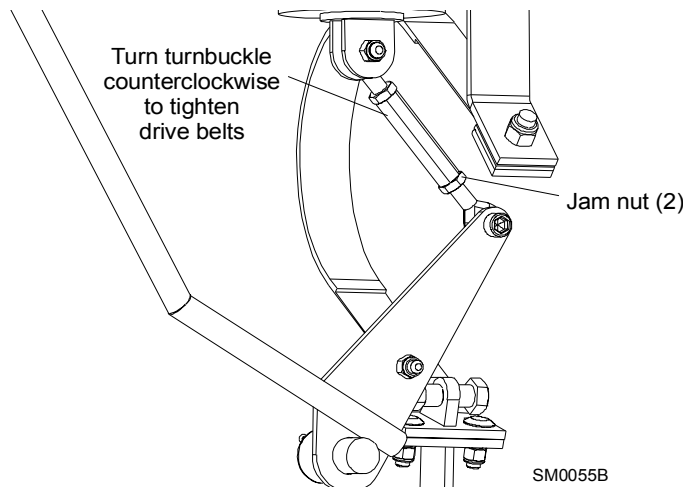


FIG. 3-6

3. After tensioning the drive belt, check throttle cable tension and adjust if necessary. The throttle cable should be tensioned just enough so that the engine revs as soon as the clutch/brake handle is engaged. The throttle linkage should NOT affect engine RPM while the clutch/brake handle is disengaged. **NOTE:** A properly adjusted throttle will extend the cable spring 1/4" to 3/8" (6.4 - 9.5 mm) when running and have a slight amount of slack in the cable when idling. Always be sure to check the drive belt support after adjusting drive belt tension.

3

Maintenance

Drive Belt Adjustment

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

AR

AR

Adjust the drive belt support as needed. The drive belt support is designed to extend belt life. The bracket should be adjusted to NOT touch the drive belt when the clutch handle is engaged (down position), AND to hold the drive belt away from the engine pulley when the clutch handle is disengaged (up position).

See Figure 3-7. To adjust the drive belt support:

1. Make sure the motor is not running. Loosen the adjustment bolts.
2. Position the bracket so that the prong is close to, but does not touch, the drive belt with the clutch handle engaged.
3. Retighten the adjustment bolts 25-27 pound feet (34-37 newton meters).

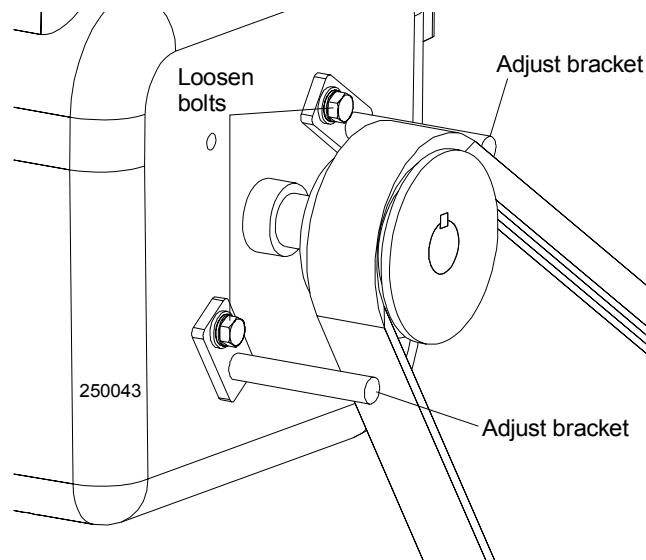


FIG. 3-7

3.11 Drive Bearing

500

Refill the fluid in the drive-side cylinder bearing housing every 500 hours of operation. Remove the top and bottom oil plugs. Pour an Automatic Transmission Fluid (ATF) such as UNIVIS J26 or Dexron III ATF into the top hole until it begins to flow from the bottom hole. Reinstall the square oil plug to the bottom hole and the vented oil plug to the top hole.

See Figure 3-8.

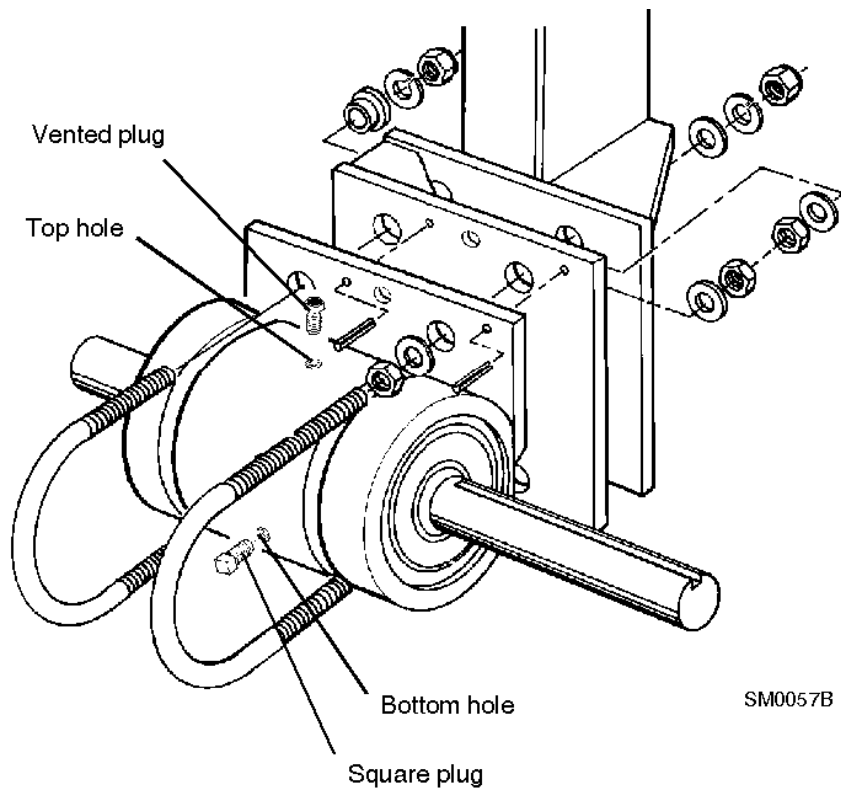


FIG. 3-8

3.12 Up/Down System

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



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

See Figure 3-9.

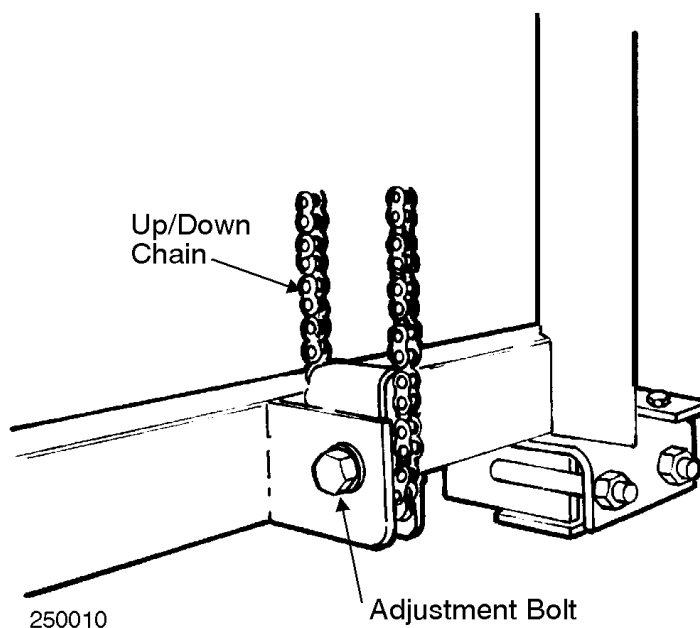


FIG. 3-9

3.13 Feed Rope

Adjust the feed rope as needed. Measure the feed rope tension with the saw head all the way toward the front of the mill. The middle of the rope should have 6-8" deflection. To tighten, pull on the feed rope adjustment handle.

See Figure 3-10.

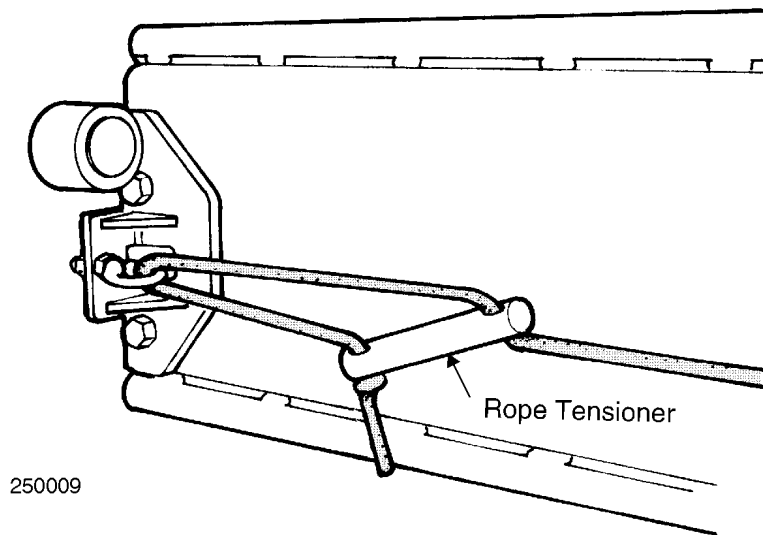


FIG. 3-10

LT25 SHORT INTERVAL MAINTENANCE SCHEDULE

(Check engine and option manuals for additional maintenance procedures)

PROCEDURE	MANUAL REFERENCE
EVERY BLADE CHANGE	
Check Blade Guide Roller Performance	See Section 3.2
Remove Excess Sawdust From Blade Wheel Housings And Sawdust Chute	See Section 3.3
Check Blade Screw	See Section 3.2
EVERY 8 HOURS	
Clean And Lubricate Track	See Section 3.4
Remove Sawdust From Upper Cam Housings	See Section 3.4
Clean Sawdust From Battery Box Lid & Track Cover	See Section 3.3
EVERY 25 HOURS	
Clean And Lubricate Upper Track Wiper	See Section 3.4

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION																		
		50 HRS	100 HRS	150 HRS	200 HRS	250 HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS									
Clean & lube mast rails	See Section 3.5																			
Grease pivot points and bearings/Oil chains	See Section 3.6																			
Check belt tensions	See Section 3.10																			
Check brake strap tension	See Section 3.9																			
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8																			
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13																			
Lubricate blade tensioner handle and rods	See Section 3.7																			
Replace cylinder drive bearing fluid	See Section 3.11																			

*FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION																		
		550 HRS	600 HRS	650 HRS	700 HRS	750 HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS									
Clean & lube mast rails	See Section 3.5																			
Grease pivot points and bearings/Oil chains	See Section 3.6																			
Check belt tensions	See Section 3.10																			
Check brake strap tension	See Section 3.9																			
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8																			
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13																			
Lubricate blade tensioner handle and rods	See Section 3.7																			
Replace cylinder drive bearing fluid	See Section 3.11																			

*FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION													
		1050 HRS	1100 HRS	1150 HRS	1200 HRS	1250 HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS				
Clean & lube mast rails	See Section 3.5														
Grease pivot points and bearings/Oil chains	See Section 3.6														
Check belt tensions	See Section 3.10														
Check brake strap tension	See Section 3.9														
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8														
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13														
Lubricate blade tensioner handle and rods	See Section 3.7														
Replace cylinder drive bearing fluid	See Section 3.11														

*FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION																			
		1550 HRS	1600 HRS	1650 HRS	1700 HRS	1750 HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS										
Clean & lube mast rails	See Section 3.5																				
Grease pivot points and bearings/Oil chains	See Section 3.6																				
Check belt tensions	See Section 3.10																				
Check brake strap tension	See Section 3.9																				
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8																				
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13																				
Lubricate blade tensioner handle and rods	See Section 3.7																				
Replace cylinder drive bearing fluid	See Section 3.11																				

*FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION																				
		2050 HRS	2100 HRS	2150 HRS	2200 HRS	2250 HRS	2300 HRS	2350 HRS	2400 HRS	2450 HRS	2500 HRS											
Clean & lube mast rails	See Section 3.5																					
Grease pivot points and bearings/Oil chains	See Section 3.6																					
Check belt tensions	See Section 3.10																					
Check brake strap tension	See Section 3.9																					
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8																					
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13																					
Lubricate blade tensioner handle and rods	See Section 3.7																					
Replace cylinder drive bearing fluid	See Section 3.11																					

*FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*

WOOD-MIZER LT25 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION																			
		2550 HRS	2600 HRS	2650 HRS	2700 HRS	2750 HRS	2800 HRS	2850 HRS	2900 HRS	2950 HRS	3000 HRS										
Clean & lube mast rails	See Section 3.5																				
Grease pivot points and bearings/Oil chains	See Section 3.6																				
Check belt tensions	See Section 3.10																				
Check brake strap tension	See Section 3.9																				
Rotate drive/idle blade wheel belts/Check for wear	See Section 3.8																				
Check feed rope & up/down chain tensions	See Section 3.13 See Section 3.13																				
Lubricate blade tensioner handle and rods	See Section 3.7																				
Replace cylinder drive bearing fluid	See Section 3.11																				

**FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.
A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.**

SECTION 4 TROUBLESHOOTING GUIDE

4.1 Sawing Problems

PROBLEM	CAUSE	SOLUTION
Blades Dull Quickly	Dirty logs	Clean or debark logs, especially on entry side of the cut
	When grinding teeth, heating too much and causing teeth to soften	Grind just enough metal to restore sharpness to the teeth. Use water/coolant while sharpening blade
	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Sharpener Manual)
Blades Break Prematurely	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edge of wheels	Change blade wheel belts (B-57)
	Poor sharpening techniques	See Sharpener Manual
	Tension too tight	Tension blade to recommended specifications
Blade Does Not Track Right on Drive Wheel	Cant adjustment is incorrect	Readjust
	Flat/worn belts	Replace B-57 belts
Blade Guides Do Not Spin While Cutting	Frozen bearings	Replace bearings
	Stiff bearings	Grease bearings
Blade Does Not Stop Immediately After Disengaging	Brake strap too loose	Adjust brake strap
Drive Belts Come Off Pulleys When Disengaging Blade	Brake strap too loose	Adjust brake strap
	Brake drum misaligned	Realign on drive shaft
	Brake strap tightened with one edge too loose and one edge too tight	Adjust brake strap
Drive Belts Wear Prematurely or Jump	Engine/motor and drive pulleys out of alignment	Align pulleys See Section 4.2 Engine/Motor and Drive Pulleys Alignment.

4

Troubleshooting Guide

Sawing Problems

PROBLEM	CAUSE	SOLUTION
Boards Thick Or Thin On Ends Or Middle Of Board.	Stress in log which causes log to not lay flat on the bed.	After log has been squared, take equal cuts off opposing sides. Take a board off the top. Turn the log 180 degrees. Take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut.
	Set in teeth.	Resharpen and reset blade.
Height Adjustment Jumps or Stutters When Moving Up or Down.	Bed rails misaligned.	Realign sawmill.
	Mast needs lubrication.	Lubricate mast track surface.
	Up/down chain improperly adjusted.	Adjust up/down chain.
	Vertical wear pads are too tight.	Adjust pads.
Lumber Is Not Square	Drive belt(s) loose.	Adjust belts.
	Vertical side supports not square to bed	Adjust side supports.
	Blade not parallel to bed rails	Adjust bed rails parallel to blade.
Sawdust Builds Up On Track	Sawdust or bark between cant and bed rails	Remove particles
	Tooth set problems	Resharpen and reset blade
	Excessive oiling	Do not oil track
Wavy Cuts	Track wipers worn	Adjust wipers to firmly contact track
	Track is sticky	Clean track with solvent and apply silicone spray
	Excessive feed	Slow feed rate
	Improperly sharpened blade (This will be the problem 99% of the time!)	Resharpen blade (See Sharpener Manual - read entire manual!)
	Blade guides improperly adjusted	Adjust blade guides.
	Sap buildup on blade	Use Water Lube.
	Tooth set problem	Resharpen and reset blade

4.2 Engine/Motor and Drive Pulleys Alignment

1. Install the drive belt.
2. Use a straight edge to align the engine/motor pulley to the drive pulley. Also check that the engine pulley is within 1/8" square with the drive pulley. Loosen the engine mounting bolts and rotate the engine if necessary.
3. Check front-to-back movement of the engine does not exceed 1/4". Tighten the motor mount U-bolts if necessary.
4. Engage the clutch handle and adjust the drive belt tension to 7/16" deflection with 10 lb. of force.
5. Recheck the pulley alignment and engine squareness with the clutch handle engaged. Adjust if necessary.
6. Adjust the drive belt support to 1/4" ($\pm 1/32$) from the belt while engaged.

SECTION 5 SAWMILL ALIGNMENT

5.1 Pre-Alignment Procedures

The Wood-Mizer sawmill is factory aligned. Two alignment procedures are available to realign the sawmill if necessary. The Routine Alignment instructions should be performed as necessary to solve sawing problems not related to blade performance. The Complete Alignment procedure should be performed approximately every 1500 hours of operation (sooner if you regularly transport the sawmill over rough terrain).

Routine Alignment Procedure:

1. Install and track the blade ([See Section 5.3](#)).
2. Check the angle of the blade in relation to the bed rails and adjust the lower track rollers if necessary ([See Section 5.17](#)).
3. Check and adjust the vertical alignment of the blade guide arm ([See Section 5.7](#)).
4. Check and adjust the horizontal alignment of the blade guide arm ([See Section 5.8](#)).
5. Check and adjust the vertical angle of the blade guides ([See Section 5.11](#)).
6. Check and adjust the horizontal angle of the blade guides ([See Section 5.13](#)).
7. Check and adjust the spacing between the blade guide flanges and the back of the blade ([See Section 5.12](#)).
8. Check and adjust the horizontal angle of the side supports ([See Section 5.14](#)).
9. Check and adjust the vertical angle of the side supports ([See Section 5.15](#)).
10. Check that the blade height scale accurately displays the actual distance from the bottom of the blade to the bed rails and adjust if necessary ([See Section 5.18](#)).

Complete Alignment Procedure:

Perform all steps in this section to completely realign the sawmill.

5.2 Frame Setup

Stationary sawmills should be setup on firm, level ground before proceeding with alignment. Shim the feet so the weight of the sawmill is evenly supported.

Portable sawmills should also be setup on firm, level ground:

LT25: Adjust the two middle outriggers on the main frame tube down just enough to lift weight from the trailer tire.

LT25: Adjust the two end outriggers on the main frame tube down just enough to lift weight from the trailer tire.

All Portable Sawmills: Adjust the two outer outriggers down just so they touch the ground but do not bear weight.

[See SECTION 2 Setup & Operation](#) for additional setup information.

5.3 Blade Installation And Alignment

See **Figure 5-1**. Install a blade and apply the appropriate tension ([See Section 2.4](#)). Blade tension is adjusted with the tension handle shown.

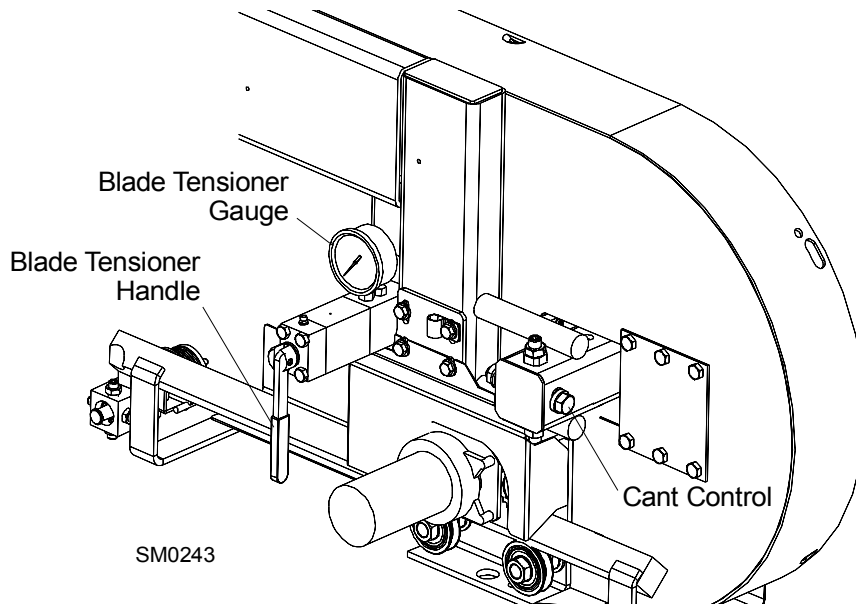


FIG. 5-1

1. Raise the middle blade housing cover and make sure all persons are clear of the open side of the saw head.
2. Start the engine.
3. 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. 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.

5 Sawmill Alignment

Blade Installation And Alignment

See **Figure 5-2**. 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 ($\pm 1/16$ [1.5 mm]). The gullet of 1 1/2" blades should ride 3/16" (4.5 mm) from the front edge of the wheels ($\pm 1/16$ [1.5 mm]). Do not let the teeth ride on the wheels.

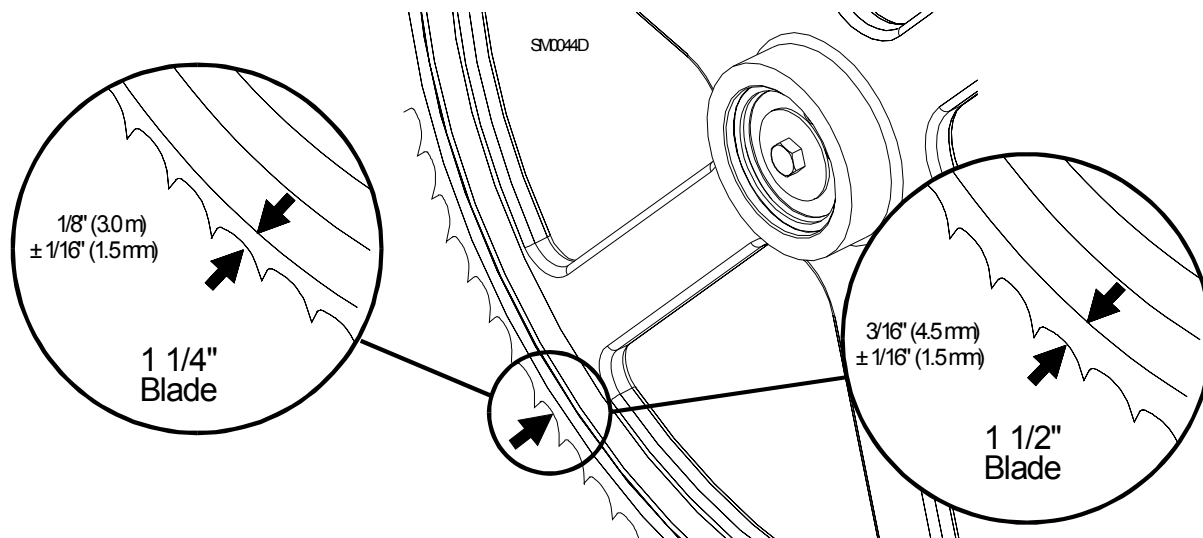


FIG. 5-2

To adjust where the blade travels on the idle-side blade wheel, use the cant control shown in **Figure 5-1**.

If the blade is too far forward on the wheels, turn the cant control counterclockwise. If it is too far back on the wheels, turn the cant control clockwise.

Some adjustment in blade tension may be needed to compensate for adjustments made with the cant control.

5.4 Saw Head Slide Pad Adjustment

There are eight nylon pads positioned between the saw head frame and vertical mast. The spacing of the pads is factory set and rarely needs adjusting. To check the pad spacing, perform the following steps.

NOTE: The pads on the engine side of the mast are referred to as the "inner" pads. The pads on the control side of the mast are referred to as the "outer" pads.

NOTE: Shims are often used around the clamping bolts, between the C-frame support bracket and the mast v-brace. The shims align the v-brace to the mast so that the entire face of each slide pad makes contact with the mast. Be sure to keep these shims in place when performing the following adjustment.

See Figure 5-3.

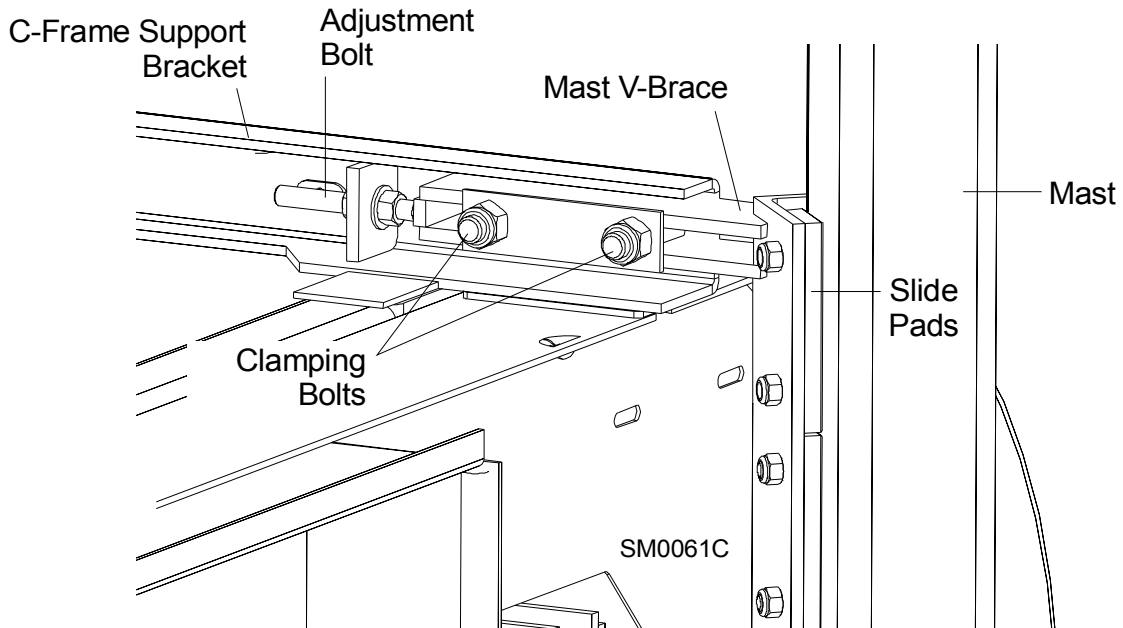


FIG. 5-3

5 Sawmill Alignment

Saw Head Slide Pad Adjustment

1. Raise the saw head to the top of the vertical mast and secure the saw head with a chain at the top, or shim it underneath. Check the top set of four pads. The outer two pads should be touching the mast rails. There should be a small gap (just wide enough to slide a business card through) between one of the inner pads and the mast rail.



WARNING! Always secure the cutting head with a chain or a brace before adjusting the mast pads. The cutting head may fall, causing severe injury or death.

2. To adjust the spacing of the upper set of pads, lower the saw head until you can access the upper slide pad adjustment bolts.
3. Loosen the upper locking bolts and turn the adjusting bolt as necessary to provide the pad spacing described in Step 1.
4. Lower the saw head to the bottom of the vertical mast. Check the bottom set of four pads.

There should be a small gap between one of the outer pads and the mast rail. The gap should be just wide enough to slide a business card through. The inner two pads should be touching the mast rails. To adjust the spacing of the lower set of pads, raise the saw head until you can access the lower slide pad adjustment bolts.

5. Loosen the lower locking bolts and turn the adjusting bolt as necessary to provide the pad spacing described in Step 4.



CAUTION! Due to variations in the vertical mast, the pad spacing may vary throughout the travel of the saw head. Check the pad spacing at the top and bottom ends of the mast only. Pads adjusted too tight will cause premature up/down motor failure.

5.5 Adjusting The Lower Track Rollers

See Figure 5-4. Making these adjustments correctly will give you square cuts and accurate dimensions across the width of your boards.

1. Using the feed crank, move the saw carriage so that the blade is positioned over the front pivot end rail.
2. Check the lower roller on the bottom track rail. Make sure that the bottom rollers touch the bottom rail but remain loose enough that you can turn them with your finger. Use the vertical bolts to adjust the bottom track rollers.
3. Check the inside lower rollers. Both inside rollers should touch the rail so that you cannot spin them by hand. If the rollers are not adjusted evenly and you can spin either one, adjust the horizontal nuts until the roller cannot be spun by hand. Check the other roller and adjust if necessary. Adjust both inside rollers until each evenly supports the carriage and you cannot spin either by hand.
4. Move the carriage forward until the blade is positioned over the rear pivot end rail. Repeat steps 2 & 3 until all lower rollers are adjusted properly at the front and rear of the sawmill.

5 Sawmill Alignment

Adjusting The Lower Track Rollers

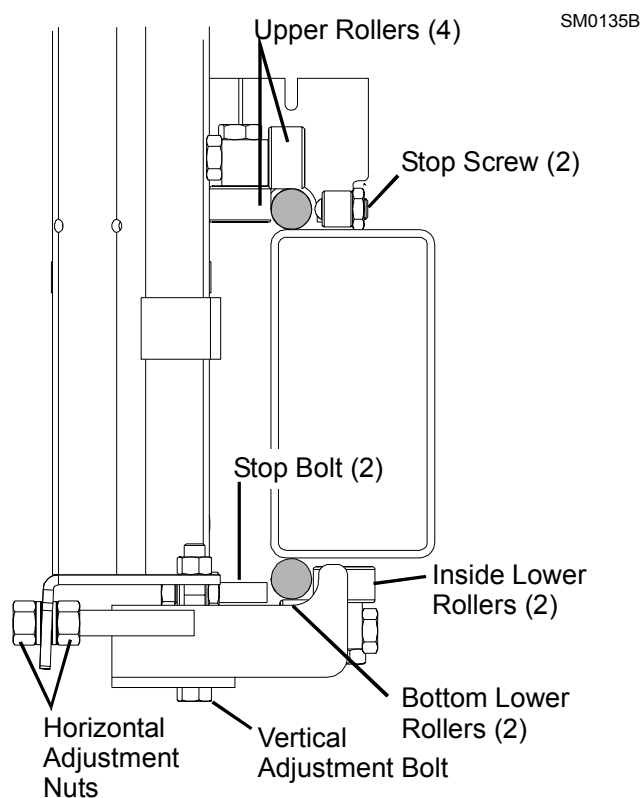


FIG. 5-4

5. Remove the blade guides, or adjust them so that they do not touch the blade.
6. Open the adjustable blade guide arm to within 1/2" (15 mm) of full open.
7. Move the carriage back to the front pivot end rail. Raise the cutting head until the bottom of the blade is 17" (400 mm) above the outside of the pivot rail support by actual measurement with a tape or ruler.

See Figure 5-5.

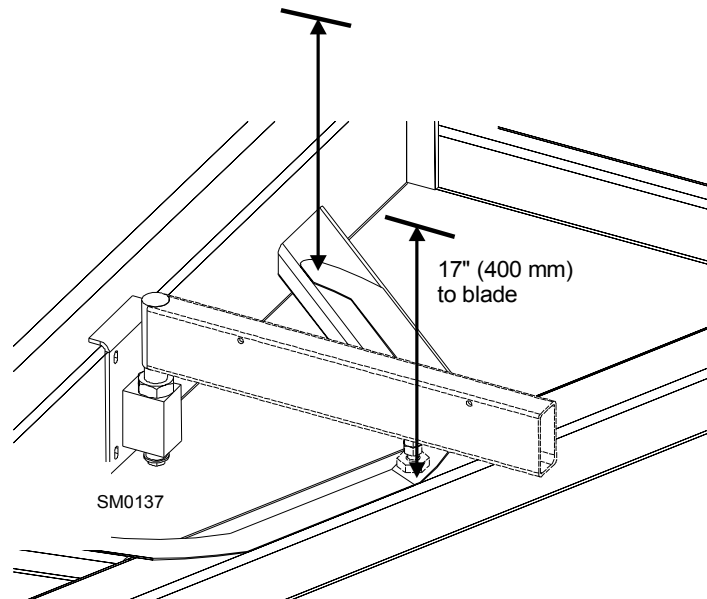


FIG. 5-5

8. Move the carriage forward to check the distance to the blade at the inside of the pivot rail support. All measurements should be equal within $1/32"$ (0.8 mm).
9. Turn the horizontal adjustment nuts evenly to adjust the inner lower rollers to tilt the saw head until the blade is parallel ($+1/32"$ [0.8 mm] -0) to the pivot rail support on the outside.

NOTE: Adjustments of the lower track rollers change the angle between the cutting head and sawmill bed rails. Only small adjustments of the lower track rollers should ever be needed.

10. After the lower track rollers are adjusted properly, adjust the upper and lower stop screws. Tighten each screw until it just touches the rail. Then, back the screw off $1/2$ turn. The gap will be approximately $1/32"$ (0.8mm).



CAUTION! It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

5.6 Adjusting Bed Rails To The Blade

1. Install the log clamp at its lowest setting in a hole where the clamp is positioned 10" from the clamp stop (fourth hole from stop).
2. Move the saw head until the blade is centered over the clamp.
3. Raise the saw head until the blade measures 14 1/2" (360 mm) from the top of the clamp. Use a rule to determine the actual distance of the blade to the clamp.

See Figure 5-6.

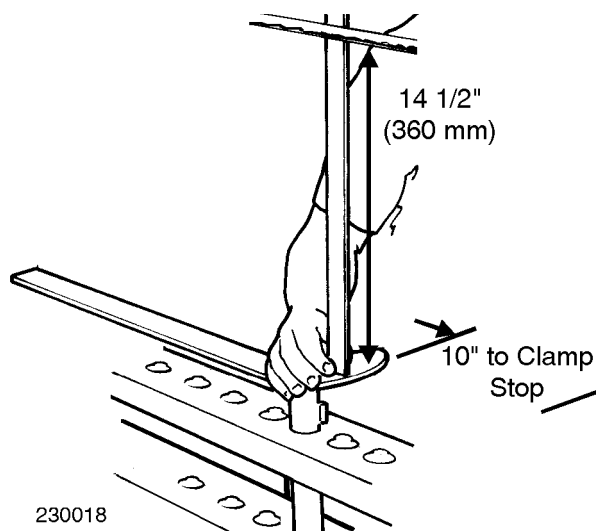


FIG. 5-6

4. Adjust the front pivot rail 90° to the main bed tube.
5. Move the saw head to center the blade over the front pivot bed rail.
6. Measure the distance from the top of the pivot rail to the bottom of the blade. Make this measurement at each end of the pivot rail.
7. The two measurements should be 15" (375 mm) (+1/32 [0.8 mm] -0).
8. Loosen the locking set screws and turn the inner height adjustment nut to adjust the height of the inner end of the pivot rail.

See Figure 5-7.

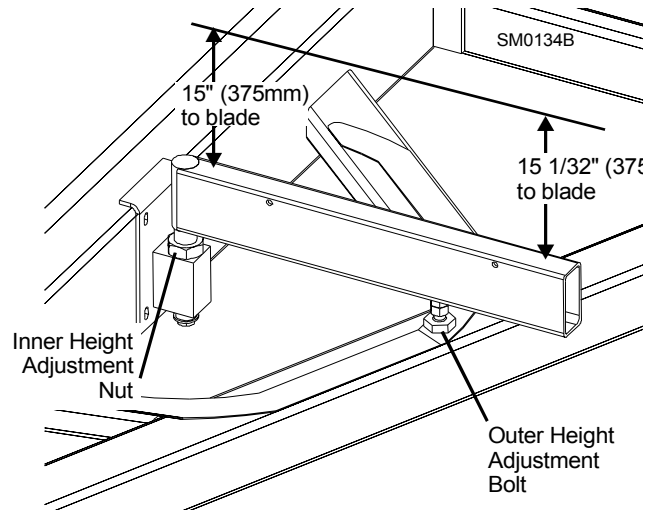


FIG. 5-7

9. Loosen the jam nut and turn the outer adjustment bolt to adjust the height of the outer end of the pivot rail.
10. Move the saw head so the blade is positioned over the center of the front main bed rail.
11. Measure the distance between the bottom of the blade and the bed rail at each end of the bed rail. The bed rail should measure 15" (375 mm) (+1/32 [0.8 mm] -0) from the blade at each end of the rail.

5 Sawmill Alignment

Adjusting Bed Rails To The Blade

See Figure 5-8.

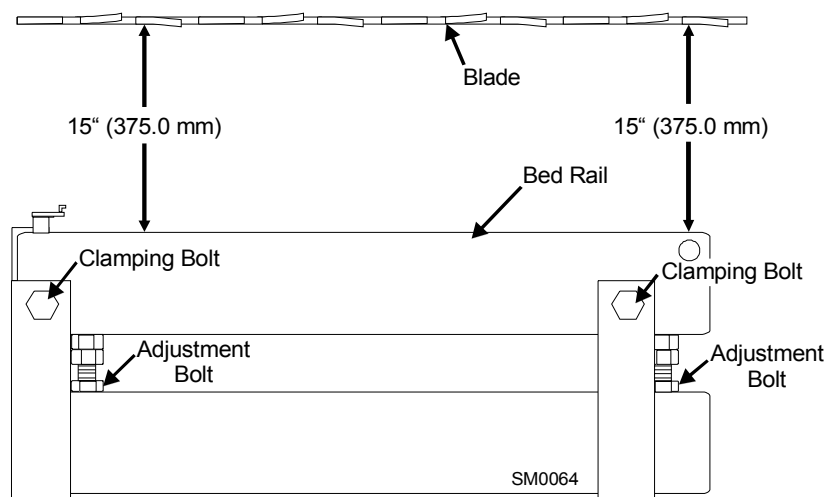


FIG. 5-8

12. Loosen the bed rail clamping bolts and turn the adjustment bolts to move the bed rails to the blade if necessary.
13. Retighten the clamping bolts and adjustment bolts.
14. Without adjusting the saw head height, check the three remaining main bed rails and the rear pivot rail. Adjust them so that all measure the same distance from the blade at both ends of the bed rail.

5.7 Blade Guide Arm Vertical Adjustment

1. Move the saw head so that the blade guide arm is directly over a bed rail.
2. Adjust the blade guide arm out to within 1/2" (15 mm) of full open.
3. Measure from the top of the bed rail to the arm.

See Figure 5-9.

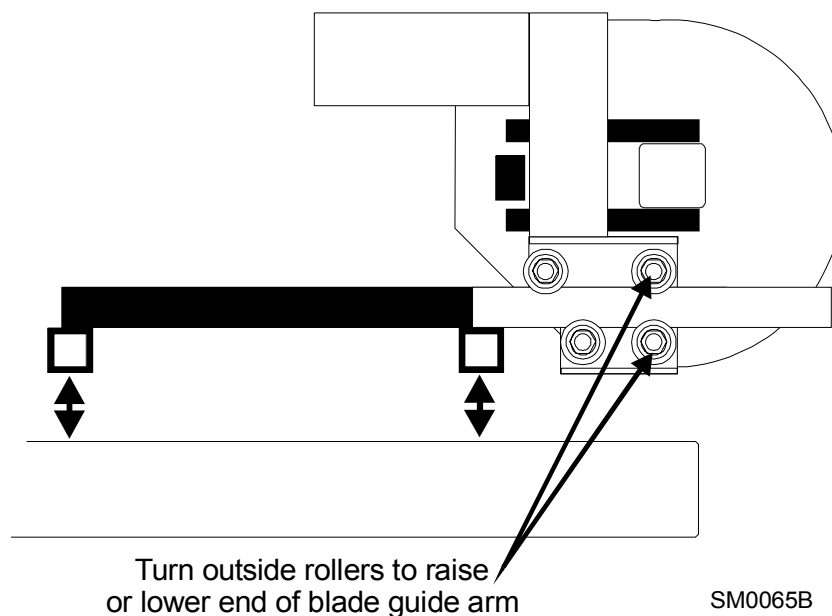


FIG. 5-9

4. Adjust the blade guide arm in to within 1/2" (15 mm) of full closed. Measure again from the top of the bed rail to the arm.
5. Adjust the arm so that the measurement from the top of the bed rail to the arm in the closed position is the same as the measurement from the top of the bed rail to the arm in the open position.

If the arm is too low in the closed position, loosen the lower outside roller and tighten the upper outside roller (See Step 6.)

If the arm is too high in the closed position, loosen the upper outside roller and tighten the lower outside roller (See Step 6.)

6. The rollers are mounted on cam bolts that raise or lower the arm when turned.

To adjust the rollers, locate the cam bolt head inside the housing and turn until the arm is lowered or raised as needed. Recheck the arm in both the open and closed positions. Repeat adjustments until the arm is the same distance from the bed rail in the open and closed position.

7. The blade guide arm should be snug, but not too tight, in the rollers. You should be able to move it in and out with firm hand pressure. There should be no side-to-side play.

5.8 Blade Guide Arm Horizontal Adjustment

1. Put the blade guide assembly back in the arm (if you took it out). Put the assembly back so that the flanged collar on the roller is about 1/8" (3.0 mm) from the back of the blade when the throat is 1/2" (15 mm) from full open.
2. Close the throat to within 1/2" (15 mm) from fully closed. Check to see that the flange is the same distance from the back of the blade.

See Figure 5-10.

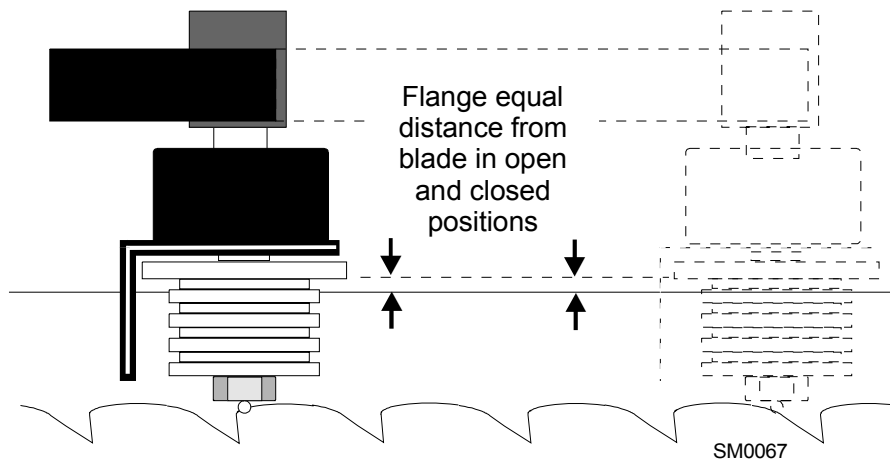


FIG. 5-10

5 Sawmill Alignment

Blade Guide Arm Horizontal Adjustment

3. If adjustment is needed, the guide rollers can be adjusted in or out on the threaded mounts to open or close the gap.

See Figure 5-11.

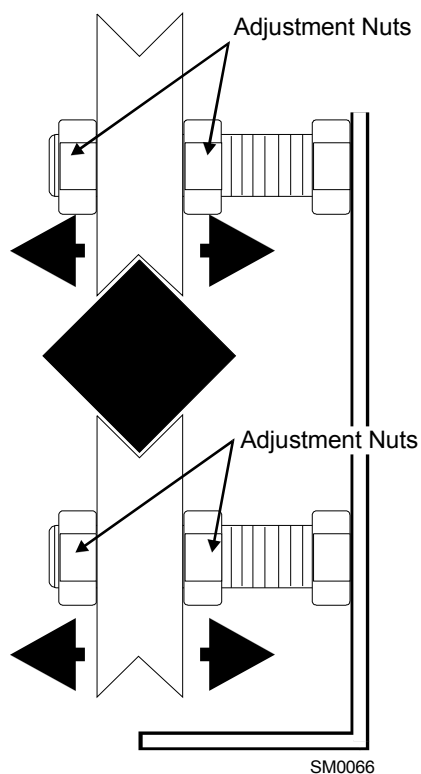


FIG. 5-11

4. Adjusting the outside two rollers (furthest from the arm motor) inward will cause the flange to move away from the blade.
5. Adjusting the two outside rollers outward will cause the flange to move toward the blade.
6. Adjust until the roller flange is the same distance from the back of the blade in the open and closed position.

5.9 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 ([See Section 5.18](#)).

NOTE: During blade guide alignment, remove the blade guide adjusting screws and apply a lubricating oil such as 10W30 or Dexron III to each screw. This will prevent the screws and threaded holes from corroding and make screw adjustments easier.

5.10 Blade Deflection

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

1. Raise the carriage 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.
2. Install the blade guides. Make sure the two set screws shown are threaded into the blade guide shaft until they touch each other.

See Figure 5-12.

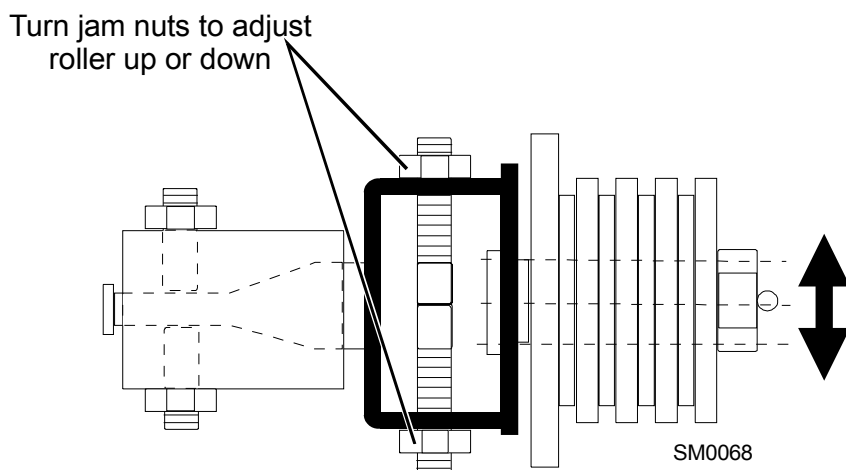


FIG. 5-12

3. Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down 1/4" (6.5 mm).
4. Repeat for the other blade guide.

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

5.11 Blade Guide Vertical Tilt Adjustment

Check that the blade guide does not tilt the blade up or down. A Blade Guide Alignment Tool (BGAT) 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. Clamp the alignment tool on 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 5-13.

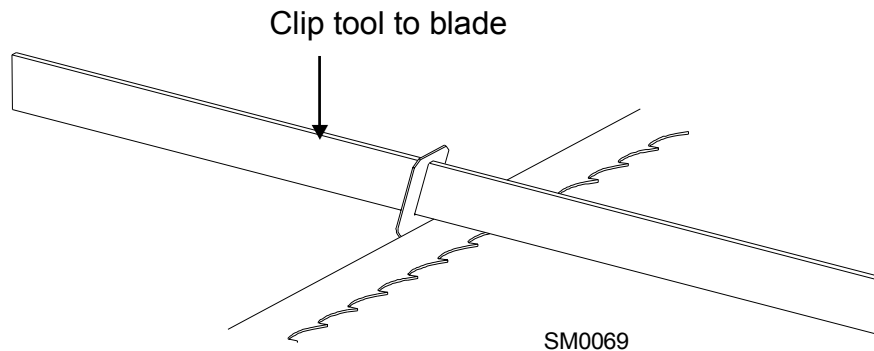


FIG. 5-13

3. Measure the distance from the bed rail to the bottom of the tool.

NOTE: If the sawmill is equipped with stainless steel bed rail covers, be sure to measure from the blade guide alignment tool to the top surface of the cover rather than the bed rail tube.

4. Move the carriage so that the front end of the tool is positioned above the bed rail.
5. Measure the distance from the bed rail to the bottom edge of the tool.
6. Loosen one set screw at the side of the blade guide assembly.
7. Use the set screws shown to tilt the blade guide until the measurement from the bed rail to the tool equals the first measurement taken at the center of the tool.

5 Sawmill Alignment

Blade Guide Vertical Tilt Adjustment

See Figure 5-14.

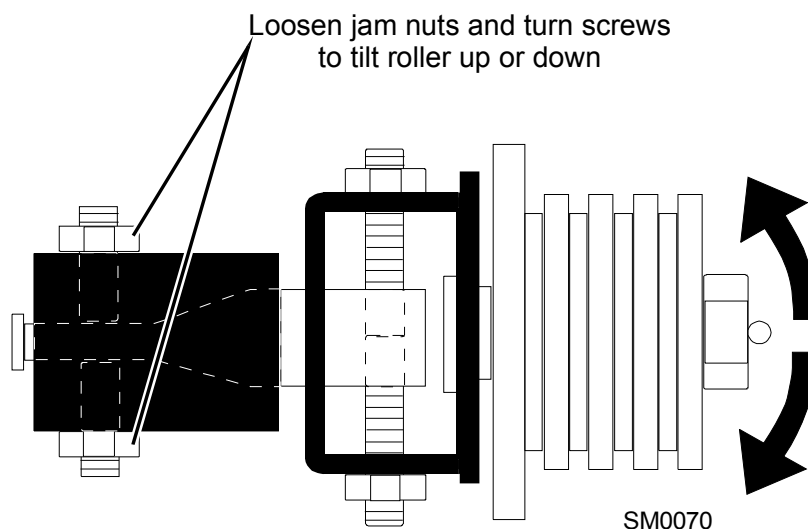


FIG. 5-14

8. Move the carriage forward so the back end of the tool is over the bed rail.
9. Use the set screws shown to adjust the blade guide tilt until the measurement from the bed rail to the tool equals the other two measurements taken.
10. Move the tool close to the other blade guide and repeat the previous steps.

NOTE: If major adjustments to blade guide tilt were made, measure the distance between the blade and the bed rails again to ensure the correct 1/4" (6.5 mm) blade guide deflection. Adjust if necessary.

5.12 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 tilt adjustments 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 5-15.

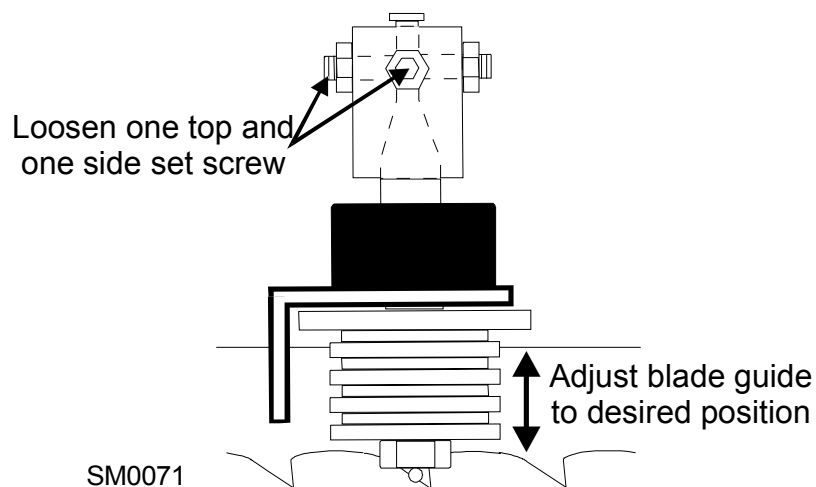


FIG. 5-15

3. Retighten the two set screws.
4. Adjust the outer blade guide in the same way so the blade guide flange is approximately 1/16"-1/8" (1.5-3.0 mm) from the back of the blade.

5.13 Horizontal Tilt Adjustment

1. Finally, both blade guides must be tilted horizontally. Adjust the blade guide arm halfway in.

See Figure 5-16.

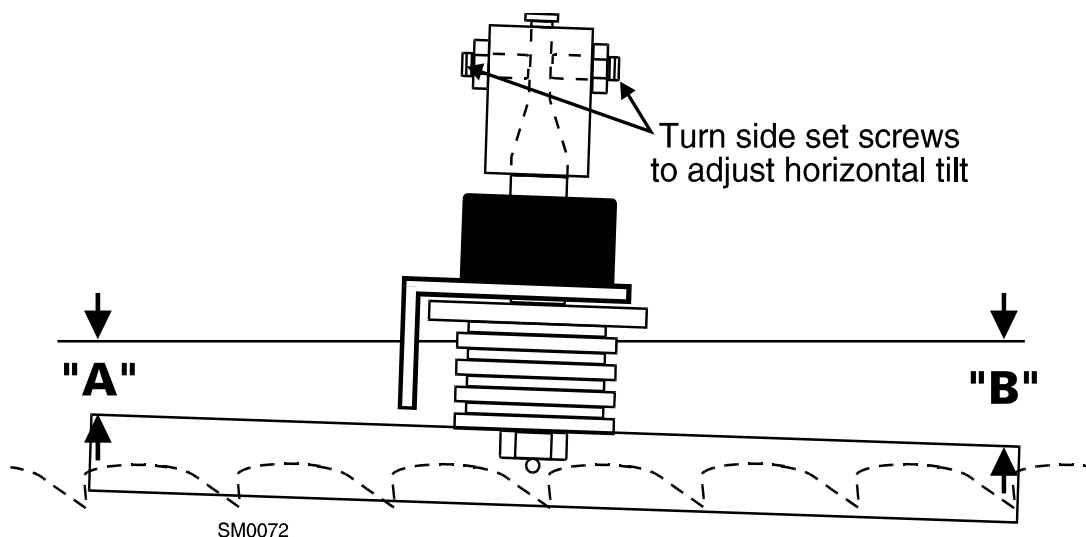


FIG. 5-16

2. Place the Blade Guide Alignment Tool against the face of the outer blade guide roller.
3. Center the tool on the roller and measure 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 ruler ("A").
5. The roller should be parallel to the blade ($A=B$) or tilted slightly to the left ($A=B-1.4$ " [6 mm]).
6. Use the side set screws to adjust the horizontal tilt of the roller.
7. Repeat steps 3-7 for the inner blade guide roller.

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

5.14 Horizontal Adjustment of 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.

1. Swing the side support down.
2. Measure between the face of the support and the main bed tube. Make measurements at both ends of the side support to make sure that it is parallel to the rail.

See Figure 5-17.

3. Use the two lower bolts to adjust the side support so $B=A$ or $+1/32"$ (0.8 mm).
4. Repeat for remaining side supports.

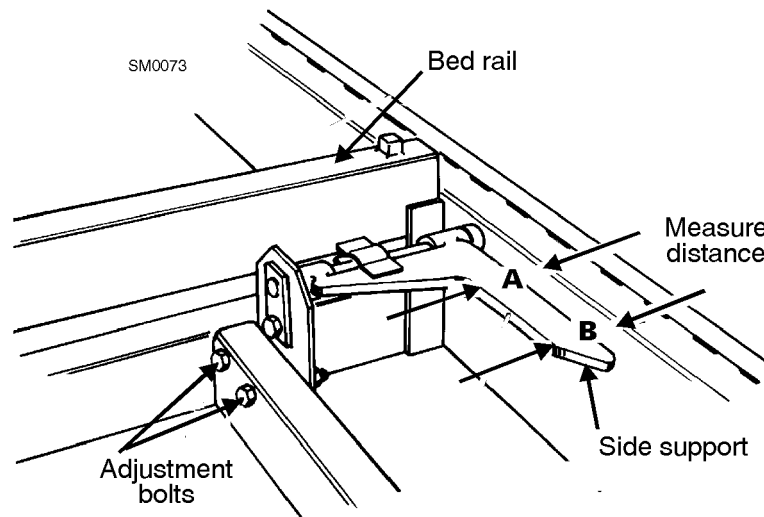


FIG. 5-17

5.15 Vertical Adjustment of Side Supports

1. Place a flat board across the bed rails.
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.

See Figure 5-18.

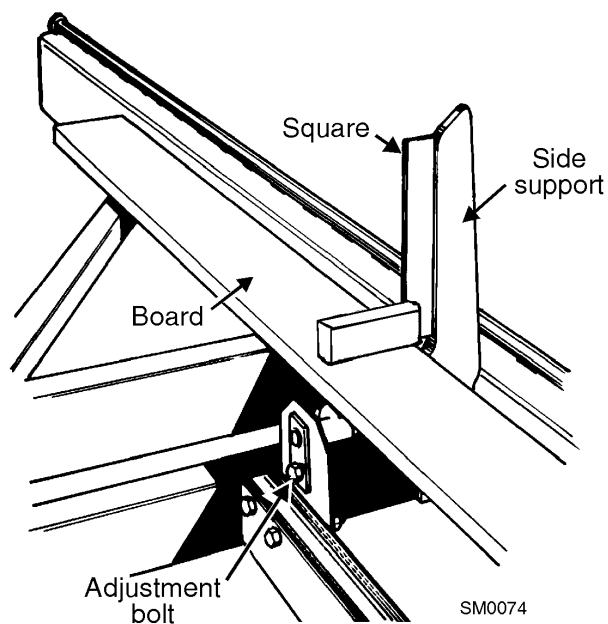


FIG. 5-18

4. Check the angle of each support with a square on the board.
5. The side support should be 90° to the bed rails or leaning forward 1/32" (0.8 mm). Loosen the top adjustment bolt, adjust the side support, and retighten the bolt.
6. Repeat for the remaining side supports.

5.16 Clamp Stop/Stop Bolt Adjustment

1. Once the side supports are aligned, pivot them down to their horizontal position.
2. Tie a string across the face of the side supports.

See Figure 5-19.

3. Loosen the clamp stop bolts and adjust the clamp stop until it touches the string. Loosen the jam nut and adjust the bolt on the middle-rear bed rail until it touches the string.

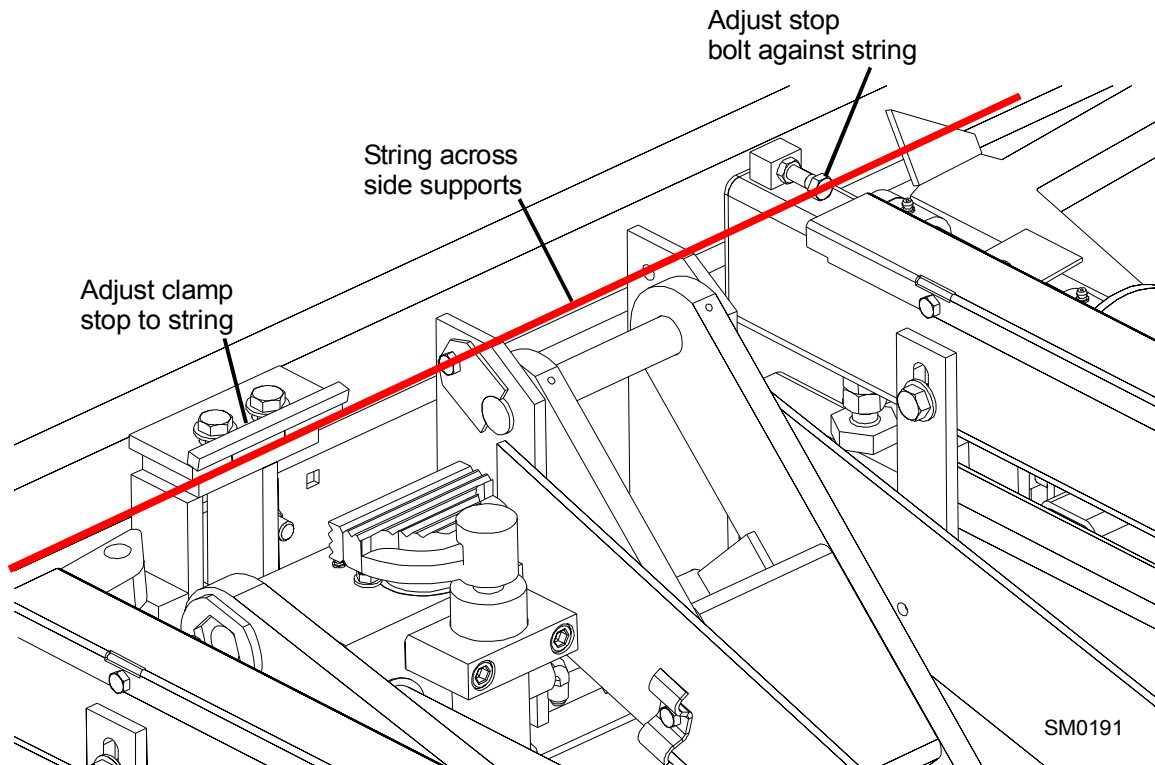


FIG. 5-19

5.17 Saw Head Tilt

As the blade enters a wide log or cant, the outside of the saw head will drop down slightly. To compensate for the drop, use the lower track roller horizontal bolts to raise the outside of the saw head 1/16" (1.5 mm).

1. Move the saw head so the blade is positioned 14 3/4" (375 mm) above a bed rail.
2. Adjust the lower track roller horizontal nuts until the blade measures 14 13/16" (376.5 mm) from the bed rail near the outer blade guide.

See Figure 5-20.

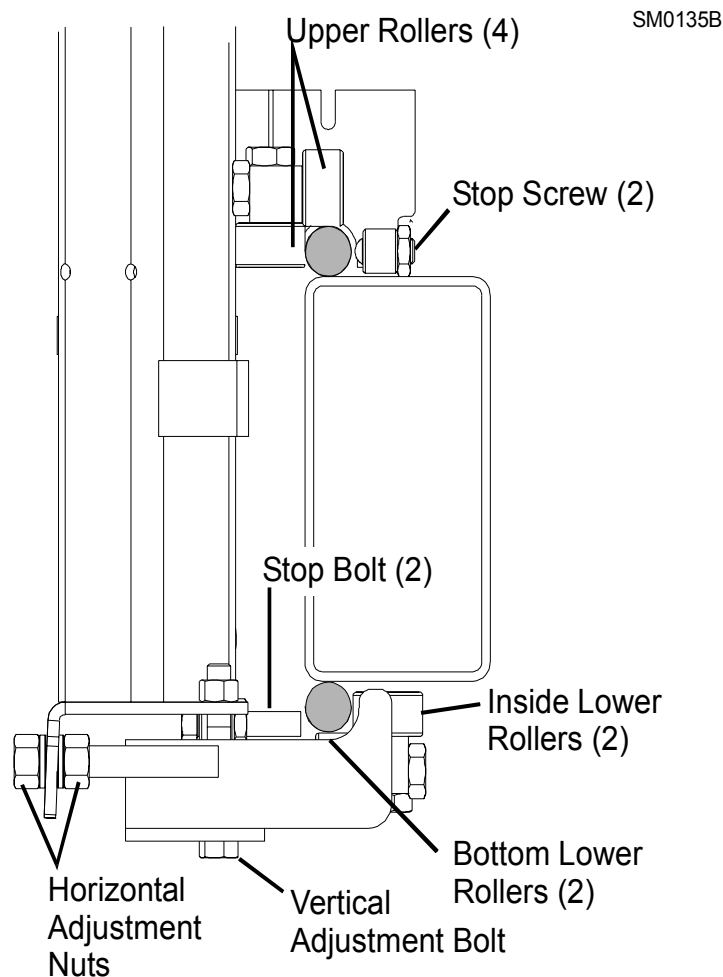


FIG. 5-20

5.18 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.

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 sleeve if applicable).

See Figure 5-21.

2. View the blade height scale with eyes level with the indicator.

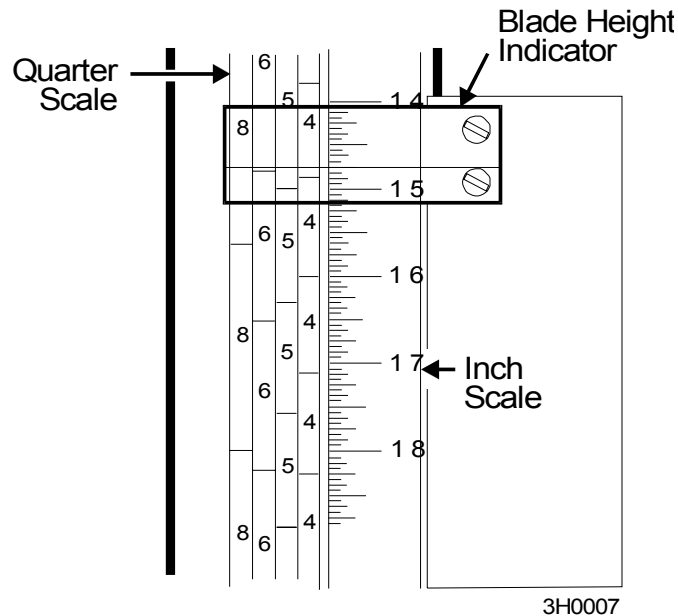


FIG. 5-21

3. Loosen the indicator bracket mounting bolts and adjust the bracket until the indicator is aligned with the correct mark on the scale (+0 -1/32 [0.8 mm]). Retighten the bracket mounting nut.

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.