

Wood-Mizer[®]

Safety, Setup, Operation & Parts Manual

Merry-Go-Round Option



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

Form #742

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SECTION 1 SAFETY

1.1 Safety Symbols

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



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



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



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



IMPORTANT! indicates vital information.

NOTE: gives helpful information.



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

1.2 Safety Instructions

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

OBSERVE SAFETY INSTRUCTIONS




IMPORTANT! Read the entire Operator's Manual before operating the Merry-Go-Round (MGR) handling system. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

Only persons who have read and understood the entire operator's manual should operate the Merry-Go-Round (MGR) handling system. The Merry-Go-Round (MGR) handling system is not intended for use by or around children.


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



 **IMPORTANT!** The Resaw with MGR Handling System is intended for sawing wood only. The resaw must not be used for other purposes such as cutting ice, metal or any other materials. See Section 6 “Specification” of the HR500/HR700 Resaw manual for log size capacities of the machine.

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


KEEP MERRY-GO-ROUND (MGR) HANDLING SYSTEM AND AREA AROUND MERRY-GO-ROUND (MGR) HANDLING SYSTEM CLEAN

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

CAUTIONS FOR MERRY-GO-ROUND (MGR) HANDLING SYSTEM SETUP


WARNING! Securely fasten the feet of the Merry-Go-Round (MGR) handling system to the floor before operating the machine. Failure to do so may result in serious injury or death.

CHECK MERRY-GO-ROUND (MGR) HANDLING SYSTEM BEFORE OPERATION

 **DANGER!** Make sure all guards and covers are in place and secured before operating the Merry-Go-Round (MGR) handling system. Failure to do so may result in serious injury.




KEEP PERSONS AWAY


 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating Merry-Go-Round

(MGR) handling system. Failure to do so may result in serious injury or death.

USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND MAINTENANCE


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



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

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

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

 **DANGER!** Never operate the electric box switches when the MGR handling system is running.

SECTION 2 OPERATION

2.1 Overview

See **Figure 2-1**. The Merry-Go-Round (MGR) handling system is designed to return unfinished cants to the feed end of the HR500/HR700 Resaw. The system consists of two transfer tables and a return track. The standard length of each transfer table is 3,3m (10.8 ft). As cants exit the Resaw they feed onto the kicker table.

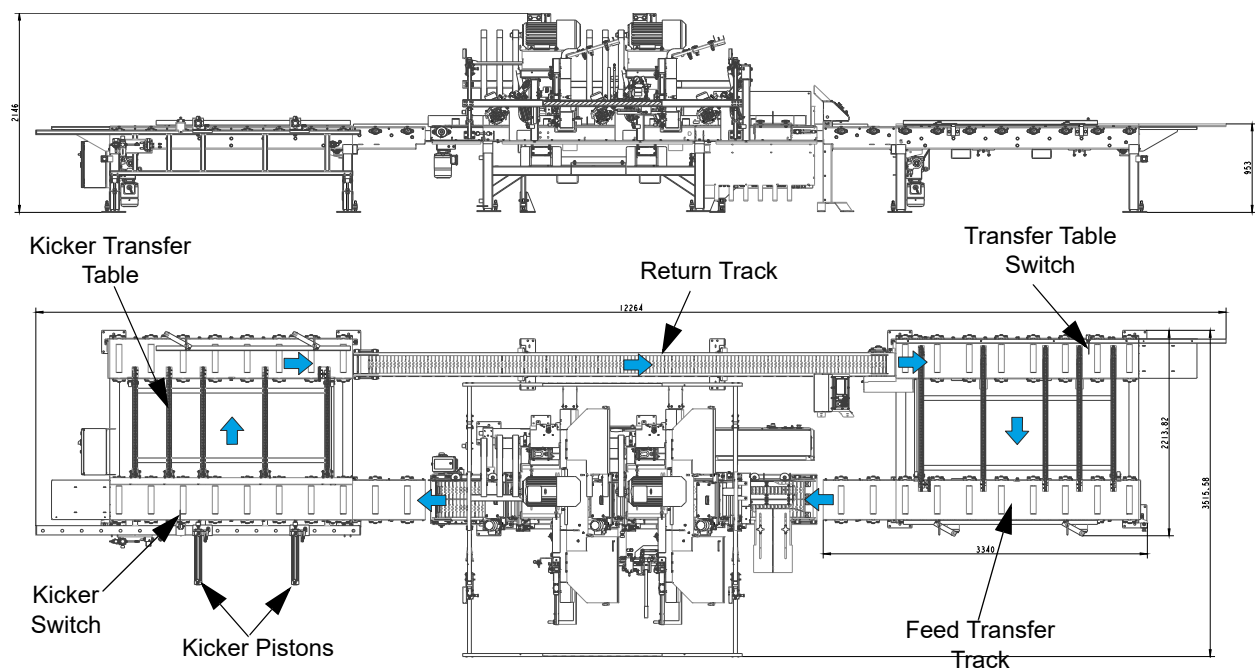


FIG. 2-1

The table is adjusted so that cants of a specific height engage the kicker switch. Finished material moves under the kicker switch and can be off-loaded. If a cant engages the kicker switch, two air-driven pistons "kick" the cant onto the transfer chains. The cant is then routed to the return track back to the transfer table at the feed end of the Resaw.

The cant activates a second switch which causes the transfer table to rise, transferring the cant from the return track to the feed table. Transfer chains then move the cant forward where it can then be reloaded onto the Resaw feed track.

2.2 Merry-Go-Round Setup

See Figure 2-2.

1. Each merry-go-round (MGR) table has leg adjustments to help align the tables parallel to the Resaw. Loosen the locking nut and turn the adjusting nut to raise or lower the leg. Sight down the table edge to determine if the table is aligned with the Resaw feed track. Re-tighten the locking bolt to maintain the adjustment.

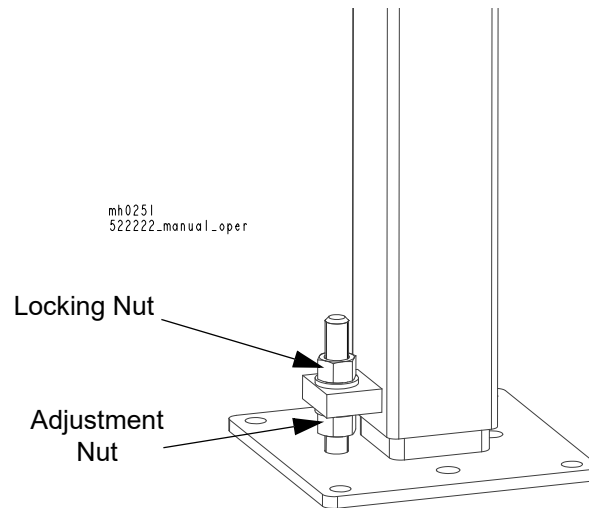


FIG. 2-2

See Figure 2-3.

2. Adjust the kicker table so that the desired height cant will contact the kicker switch. Loosen the locking nut and turn the adjustment nut to raise or lower the kicker table. Re-tighten the jam nut to maintain adjustment.

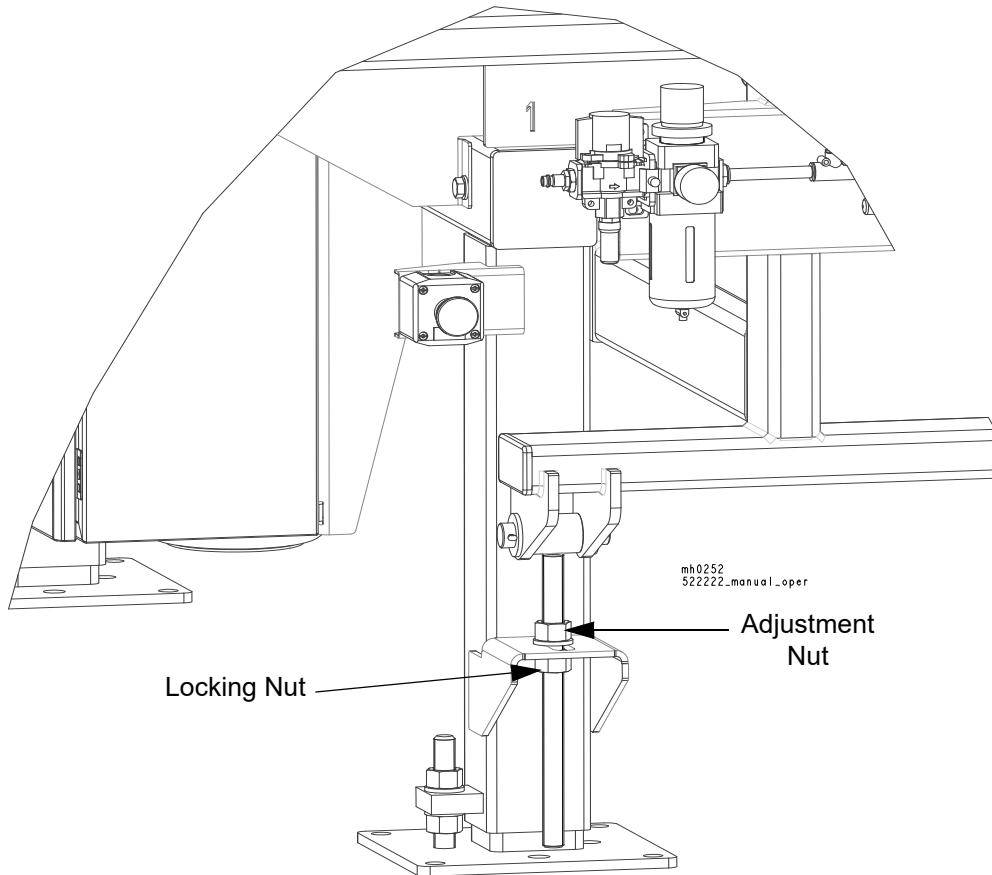


FIG. 2-3

1 Operation

Merry-Go-Round Setup

See Figure 2-4.

3. Adjust kickers to a position that both will contact the cant. Different length cants will require readjustment of the rear kicker.

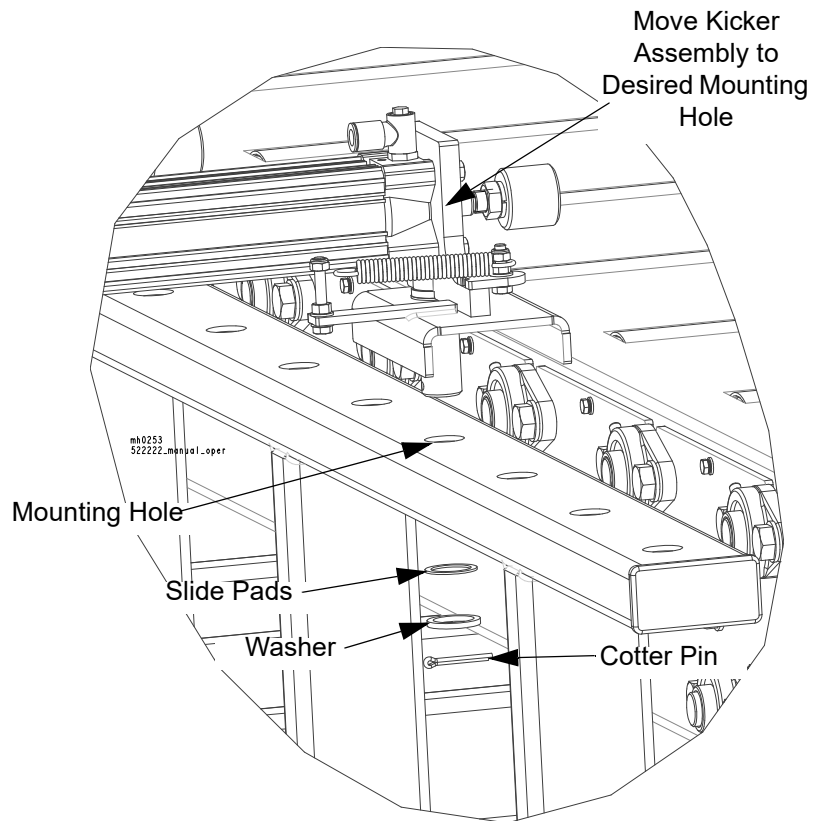


FIG. 2-4

See Figure 2-5.

4. Loosen the jam nuts and adjust the stop bolts on the return track fence so the fence opens to 6-7mm (1/4") more than the cant width to be cut. Re-tighten the jam nuts. Be sure the fence is parallel to the table.

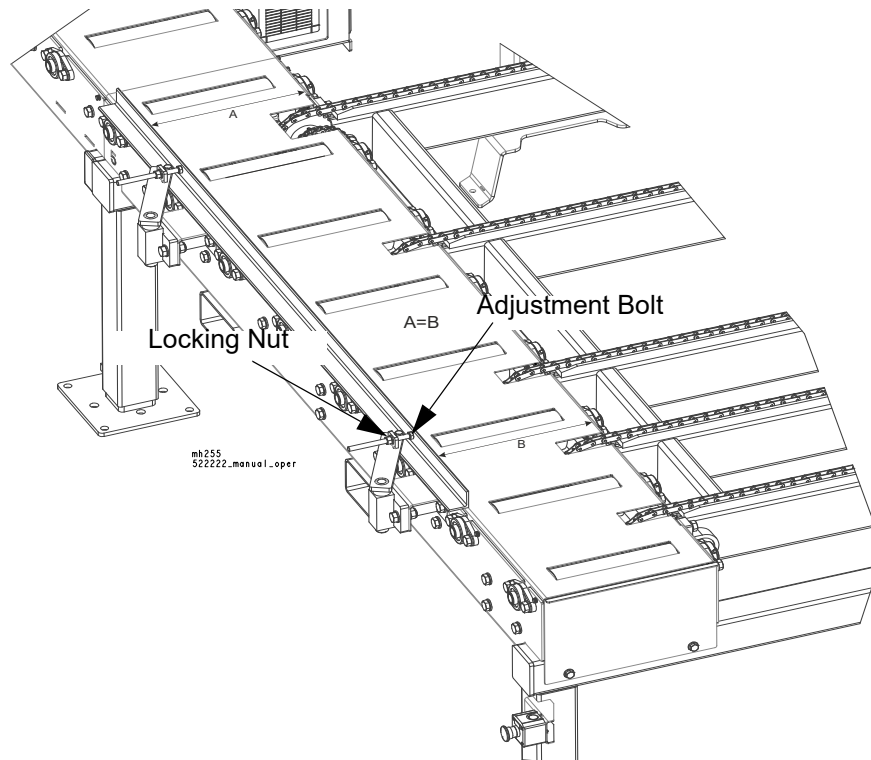


FIG. 2-5

1 Operation

Merry-Go-Round Setup

See Figure 2-6.

5. Adjust the transfer table air switch so that the end of the cant contacts the switch once it has completely moved from the return track to the transfer table.

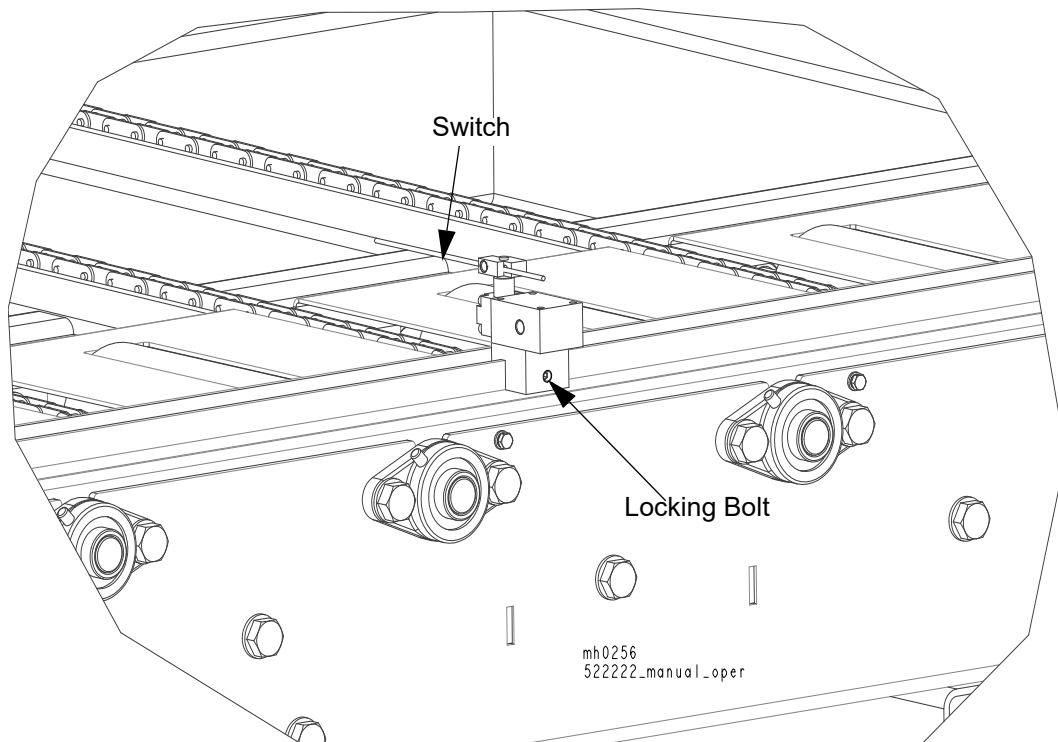


FIG. 2-6

2.3 Merry-Go-Round Air System

The MGR air system consists of two valve assemblies; one operates the kickers and one operates the transfer table. The kicker assembly also includes a solenoid valve and an air restriction valve to control the speed of the kickers. The kicker valves are factory set and should not be changed.

See Figure 2-7. The air supply connection is shown In the figure below, it is shown attached to the kicker valve assembly. To properly connect the air system:

1. Use a 1/2" NPT female fitting to connect the air line to the connection fitting.
2. Raise the shutoff valve handle on air valve assembly.
3. Turn regulator valves until the gauge indicates 0,6 MPa (87 PSI) Turning the valve clockwise raises the air pressure; counterclockwise lowers the air pressure.
4. Activate the kicker switch and check if the kicker pistons operate properly.

1 Operation
Merry-Go-Round Air System

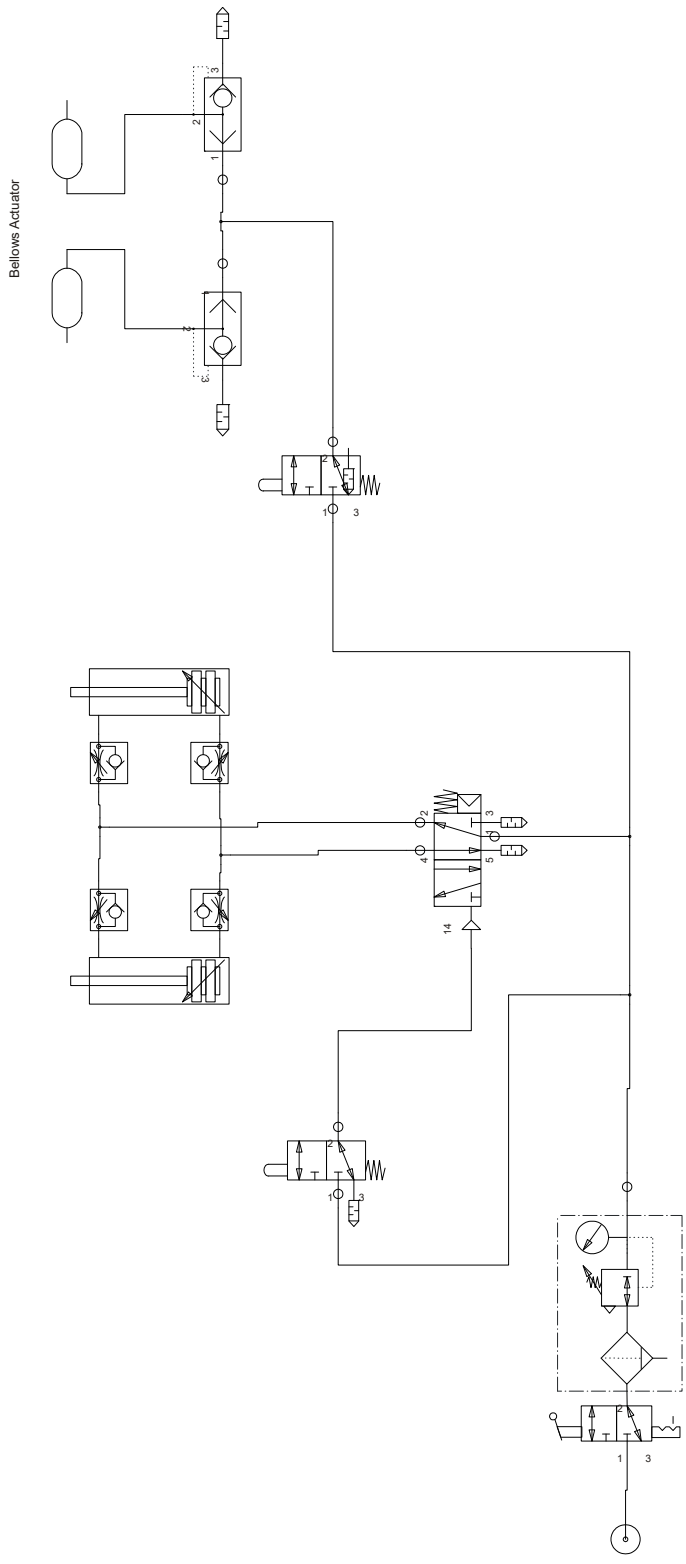
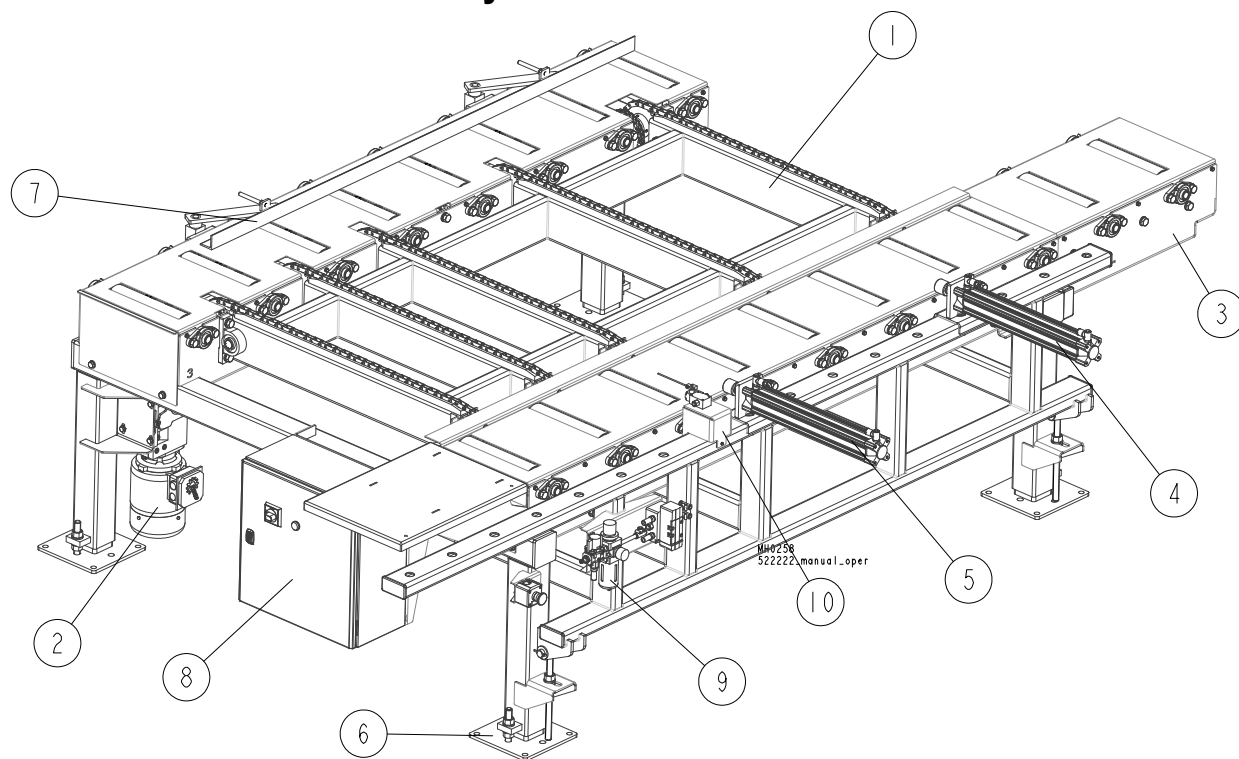


FIG. 2-7

ROZDZIAŁ 3 MERRY-GO-ROUND PARTS

3.1 Kicker Table Assembly



LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
-	STÓŁ WYJŚCIOWY - KPL.	522050	1
-	STELAŻ STOŁU WYJŚCIOWEGO	522040-1	1
-	ROLKA GŁADKA N101.6X300 SPAW/MAL	522089-1	15
-	WPUST PRYZMATYCZNY A8X7X32 PN-70/M-85005.	088564	18
-	KOŁO ŁANC. 18Z 08B/25 (T64991+T31038)CYNKOWANE	099671	18
-	ZESPÓŁ ŁOŻYSKOWY UCFL205, (COMPLEX).	089124	36
-	ROLKA NAPĘDOWA N101.6X300 SPAW/MAL	522036-1	1
-	OPRAWA ŁOŻYSKOWA UCP206	099254	2
1	PRZENOŚNIK POPRZECZNY	522092	1
2	MOTOREDUKTOR Z WAŁEM NAPĘD.	522103	1
-	WSPORNIK WAŁU POPRZECZNEGO	522065-1	2
-	WAŁ STOŁU POPRZECZNEGO	522096	1
-	KOŁO ŁAŃCUCHOWE 10B-1 Z29 N25 (T12946)	522055-1	6
-	ŁAŃCUCH STOŁU POPRZECZNEGO	522098	5
-	BOX, GEAR	P21507	1
-	KOŁO ŁAŃCUCHOWE 08B-1 Z18 N25.4 (T08230)	522054-1	1
-	OSŁONA GÓRNA - 1, KPL.	522067-1	1
-	PODKLADKA 17 FE/ZN5 PN-78/M-82008	F81058-1	185

3

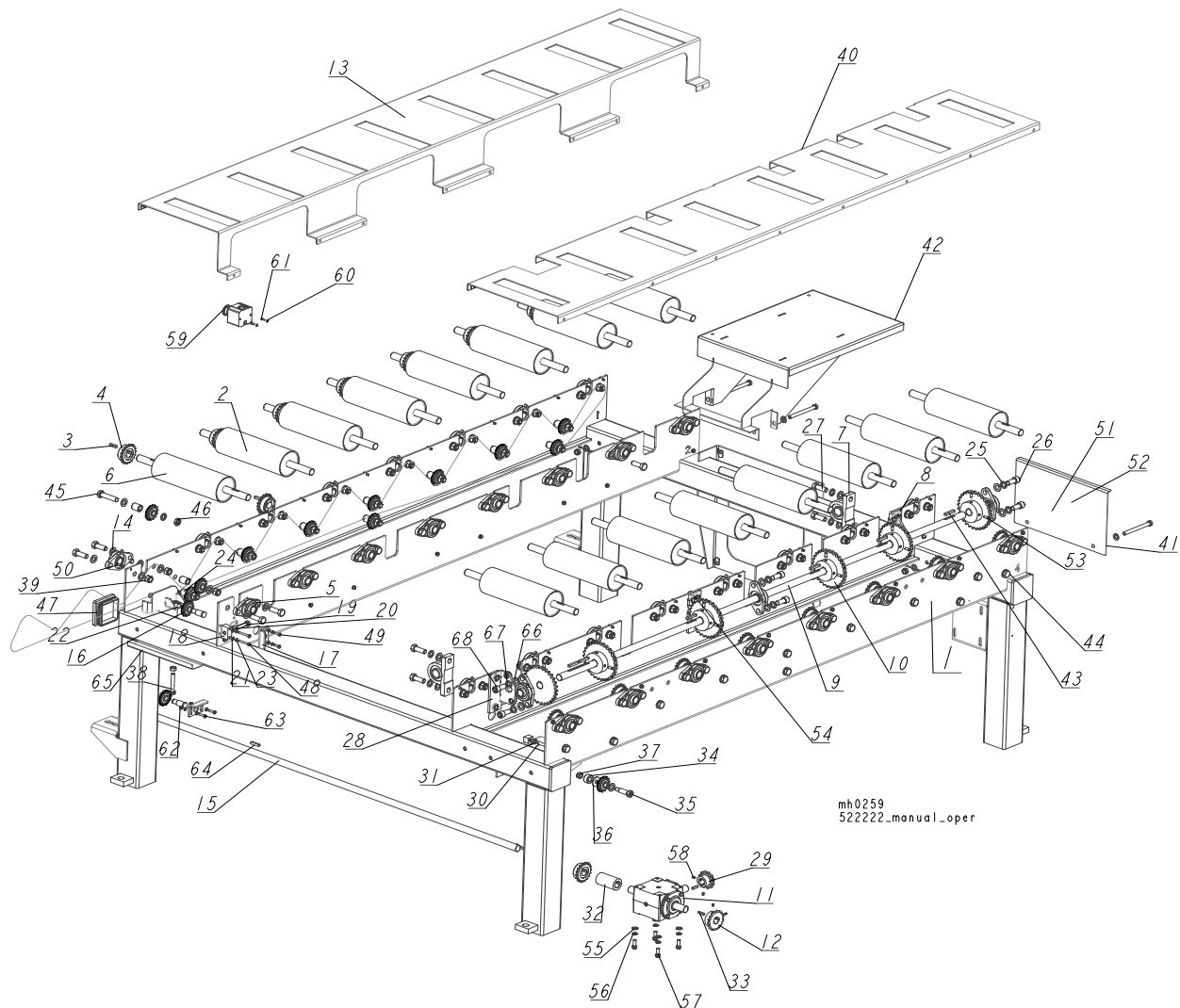
Merry-go-Round Parts

Kicker Table Assembly

LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
3	PRZEDŁUŻENIE STOŁU WYJŚCIOWEGO KARUZELI	522077	1
-	WAŁ PRZEKAZANIA NAPĘDU	522079-1	1
-	KOŁO LANCUCHOWE 08B Z=14	711991	25
-	UCHWYT NACIĄGU ŁAŃCUCHA ROLEK	522086-1	2
-	BLOK NACIĄGU	522087-1	1
-	SRUBA M12X55 8.8 FE/ZN5 PN-M/82101	F81004-43	1
-	NAKRETKA M12-8 FE/ZN5	F81034-1	2
-	PODKLADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	41
-	PIERŚCIEŃ OSADCZY SPRĘŻ. Z16, PN-81/M-85111	F81090-59	2
-	PODKLADKA SPREZYSTA Z 6.1	F81053-3	37
-	TULEJA 16.3/25-30 MAL	522076-1	22
-	PODKLADKA SPREZ.16,3 FE/ZN5 PN-M/82008	F81058-2	11
-	SRUBA IMB. M16X35-8.8 FE/ZN5 PN-M/82302	F81006-65	4
-	SRUBA M16X45-8.8-FE/ZN5 PN-M/82105.	F81006-46	70
-	WSPORNIK WAŁU STOŁU POPRZECZNEGO	522094-1	1
-	KOŁO ŁAŃCUCHOWE 10B-1 Z12 N25,4 (T08242)	522254-1	1
-	ŁAŃCUCH PRZEKAZANIA NAPĘDU - KRÓTKI	522093	1
-	ŁAŃCUCH PRZEKAZANIA NAPĘDU - KRÓTKI	522100	1
-	SRUBA M10X50-8.8-FE/ZN5 PN-M/82105.	F81003-4	1
4	ZBIJAK KOMPLETNY	522538	1
-	NAKRETKA ZWYKŁA M10 8 FE/ZN5 PN-86/M-82144	F81033-3	1
-	ŁĄCZNIK PRZEKŁADNI	522105-1	1
-	KEY, 1/4X1	S21486	3
-	TULEJA 16/32-16 CYNK	090804-1	1
-	SRUBA N16/M12X40 12.9 ISO 7379 "BOSSARD"	F81004-64	1
-	PODKL. POWIEKSZ. 13 FE/ZN5 PN-M/82030	F81056-14	1
-	NAKRETKA Z WKŁADKA POL. M12 8 FE/ZN5	F81034-2	5
-	SRUBA M12X75-8.8-FE/ZN5	F81004-10	1
-	NAKRETKA M16, SAMOKONTRUJĄCA, OCYNK.	F81036-2	85
5	ZBIJAK KOMPLETNY Z KRAŃCÓWKĄ	522539	1
-	OSŁONA GÓRNA - 2	522208-1	1
-	RAMIĘ STOŁU POPRZECZNEGO	522210-1	2
6	REGULOWANA PODSTAWA NOGI, MAŁOW.	099547-1	4
7	OGRANICZNIK SZEROKOŚCI STOŁU WYJŚCIOWEGO	523221	1
-	OSŁONA ZAMYKAJĄCA	522231-1	1
-	STÓŁ WYJŚCIOWY	522234-1	1
-	ŁAŃCUCH NAPĘDU ROLEK	522230	1
-	ŁAŃCUCH NAPĘDU GŁÓWNEGO	522228	1
-	WPUST PRYZMATYCZNY A8X7X50 PN-70/M-85005.	088563	6
-	SRUBA M16X80-8.8-FE/ZN5 PN-M/82105.	F81006-11	21
-	SRUBA M16X70 FE/ZN5 PN-85/PN-82101	F81006-16	1
-	NAKR. NISKA M16 FE/ZN5 8 PN-M/82153	F81036-4	1

LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
-	WKŁADKA KWADRATOWA 100X100 #199200	090694	4
-	SRUBA M6X45-8.8-FE/ZN5 PN-M/82101	F81001-6	2
-	SRUBA M6X20 8.8 FE/ZN5 PN-85/M-82105	F81001-2	2
-	SRUBA M6X16-8.8-FE/ZN5 PN-M/82105	F81001-15	33
-	PODKŁADKA OKR. 13-FE/ZN5 PN-78/M-82005	F81056-1	8
-	SRUBA M12X130-8.8 FE/ZN5 PN-85/M-82101	F81004-36	4
-	WKRET DOCISKOWY M8X16-33H PN-M/82314.	F81014-2	12
-	PODKŁADKA 25 FE/ZN5	F81061-3	4
-	SWORZEŃ 25X103.5	713112-1	2
-	ZAWLECZKA S-FE 5X40 PN-M/82001	F81043-31	4
-	PODKŁADKA 21 FE/ZN5 PN-78/M-82005	F81059-2	12
-	NAKRETKA M20-8- FE/ZN5 PN-86/M-82144	F81037-1	12
-	SRUBA M16X30-8.8-FE/ZN5 PN/M-82105	F81006-36	2
-	PODKŁADKA OKR. 10,5 FE/ZN5 PN-78/M-82005	F81055-1	4
-	PODKŁADKA SPREZYSTA Z 10.2 FE/ZN5 PN-77/M82008	F81055-2	4
-	BOLT, 3/8-16X1 HH	F05007-7	4
-	WKRET DOCISK. M6X8-33H-GEOMET PN/M-82315.	F81013-1	6
-	WYLACZNIK AWARYJNY XALK 174.	E22703-P	1
8	SKRZYŃKA EL. MR700-2	522544	1
-	PODKŁADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	2
-	WKRET M4X12-5.8-B-FE/ZN5 PN-M/82202.	F81011-43	2
-	NAKRETKA M6-8-B-FE/ZN5 PN-85/M-82175.	F81031-2	2
-	SRUBA M6X25 5.8 FE/ZN5 PN-85/M-82105	F81001-3	2
-	WPUST PRYZMATYCZNY A 8X7X40	503407	1
9	ZESPÓŁ PRZYGOTOWANIA POWIETRZA MGR	522838	1
-	CEOWNIK DYSTANSOWY	522834	1
10	ZESPÓŁ CZUJNIKA ZBIJAKÓW	523225	1

3.2 Kicker Table Assembly



LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
-	STÓŁ WYJŚCIOWY - KPL.	522050	1
1	STELAŻ STOŁU WYJŚCIOWEGO	522040-1	1
2	ROLKA GŁADKA N101.6X300 SPAW/MAL	522089-1	15
3	WPUST PRYZMATYCZNY A8X7X32 PN-70/M-85005.	088564	18
4	KOŁO LANC. 18Z 08B/25 (T64991+T31038)CYNKOWANE	099671	18
5	ZESPOL LOZYSKOWY UCFL205, (COMPLEX).	089124	36
6	ROLKA NAPĘDOWA N101.6X300 SPAW/MAL	522036-1	1
7	OPRAWA LOZYSKOWA UCP206	099254	2
8	WSPORNIK WAŁU POPRZECZNEGO	522065-1	2
9	WAŁ STOŁU POPRZECZNEGO	522096	1
10	KOŁO ŁAŃCUCHOWE 10B-1 Z29 N25 (T12946)	522055-1	6
11	BOX, GEAR	P21507	1

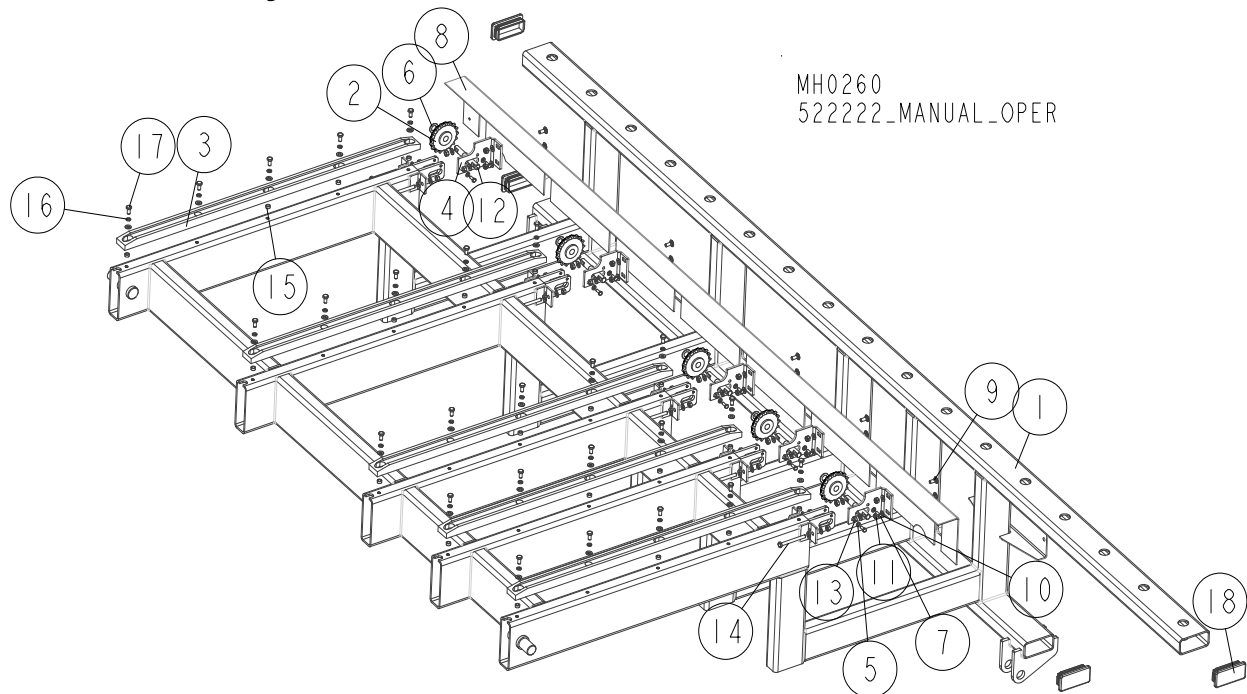
LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
12	KOŁO ŁAŃCUCHOWE 08B-1 Z18 N25.4 (T08230)	522054-1	1
13	OSŁONA GÓRNA - 1, KPL.	522067-1	1
14	PODKLADKA 17 FE/ZN5 PN-78/M-82008	F81058-1	185
15	WAŁ PRZEKAZANIA NAPĘDU	522079-1	1
16	KOŁO ŁAŃCUCHOWE 08B Z=14	711991	25
17	UCHWYT NACIĄGU ŁAŃCUCHA ROLEK	522086-1	2
18	BLOK NACIĄGU	522087-1	1
19	SRUBA M12X55 8.8 FE/ZN5 PN-M/82101	F81004-43	1
20	NAKRETKA M12-8 FE/ZN5	F81034-1	2
21	PODKLADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	41
22	PIERŚCIEŃ OSADCZY SPRĘŻ. Z16, PN-81/M-85111	F81090-59	2
23	PODKLADKA SPREZYSTA Z 6.1	F81053-3	37
24	TULEJA 16.3/25-30 MAL	522076-1	22
25	PODKLADKA SPREZ. 16,3 FE/ZN5 PN-M/82008	F81058-2	11
26	SRUBA IMB. M16X35-8.8 FE/ZN5 PN-M/82302	F81006-65	4
27	SRUBA M16X45-8.8-FE/ZN5 PN-M/82105.	F81006-46	70
28	WSPORNIK WAŁU STOŁU POPRZECZNEGO	522094-1	1
29	KOŁO ŁAŃCUCHOWE 10B-1 Z12 N25,4 (T08242)	522254-1	1
30	SRUBA M10X50-8.8-FE/ZN5 PN-M/82105.	F81003-4	1
31	NAKRETKA ZWYKLA M10 8 FE/ZN5 PN-86/M-82144	F81033-3	1
32	ŁĄCZNIK PRZEKŁADNI	522105-1	1
33	KEY, 1/4X1	S21486	3
34	TULEJA 16/32-16 CYNK	090804-1	1
35	SRUBA N16/M12X40 12.9 ISO 7379 "BOSSARD"	F81004-64	1
36	PODKL. POWIEKSZ. 13 FE/ZN5 PN-M/82030	F81056-14	1
37	NAKRETKA Z WKŁADKA POL. M12 8 FE/ZN5	F81034-2	5
38	SRUBA M12X75-8.8-FE/ZN5	F81004-10	1
39	NAKRETKA M16, SAMOKONTRUJACA, OCYNK.	F81036-2	85
40	OSŁONA GÓRNA - 2	522208-1	1
41	OSŁONA ZAMYKAJĄCA	522231-1	1
42	STÓŁ WYJŚCIOWY	522234-1	1
43	WPUST PRYZMATYCZNY A8X7X50 PN-70/M-85005.	088563	6
44	SRUBA M16X80-8.8-FE/ZN5 PN-M/82105.	F81006-11	21
45	SRUBA M16X70 FE/ZN5 PN-85/PN-82101	F81006-16	1
46	NAKR. NISKA M16 FE/ZN5 8 PN-M/82153	F81036-4	1
47	WKŁADKA KWADRATOWA 100X100 #199200	090694	4
48	SRUBA M6X45-8.8-FE/ZN5 PN-M/82101	F81001-6	2
49	SRUBA M6X20 8.8 FE/ZN5 PN-85/M-82105	F81001-2	2
50	SRUBA M6X16-8.8-FE/ZN5 PN-M/82105	F81001-15	33
51	PODKLADKA OKR. 13-FE/ZN5 PN-78/M-82005	F81056-1	8
52	SRUBA M12X130-8.8 FE/ZN5 PN-85/M-82101	F81004-36	4
53	WKRET DOCISKOWY M8X16-33H PN-M/82314.	F81014-2	12

3

Merry-go-Round Parts*Kicker Table Assembly*

LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość	
54	SRUBA M16X30-8.8-FE/ZN5 PN/M-82105	F81006-36	2	
55	PODKŁADKA OKR. 10,5 FE/ZN5 PN-78/M-82005	F81055-1	4	
56	PODKŁADKA SPREZYSTA Z 10.2 FE/ZN5 PN-77/M82008	F81055-2	4	
57	BOLT, 3/8-16X1 HH	F05007-7	4	
58	WKRET DOCISK. M6X8-33H-GEOMET PN/M-82315.	F81013-1	6	
59	WYLACZNIK AWARYJNY XALK 174.	E22703-P	1	
60	PODKŁADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	2	
61	WKRET M4X12-5.8-B-FE/ZN5 PN-M/82202.	F81011-43	2	
62	NAKRETKA M6-8-B-FE/ZN5 PN-85/M-82175.	F81031-2	2	
63	SRUBA M6X25 5.8 FE/ZN5 PN-85/M-82105	F81001-3	2	
64	WPUST PRYZMATYCZNY A 8X7X40	503407	1	
65	CEOWNIK DYSTANSOWY	522834	1	
66	PODKŁADKA 17 FE/ZN5 PN-78/M-82008	F81058-1	2	
67	PODKŁADKA SPREZ. 16,3 FE/ZN5 PN-M/82008	F81058-2	2	
68	SRUBA IMB. M16X35-8.8 FE/ZN5 PN-M/82302	F81006-65	2	

3.3 Assembly



LP.	OPIS (* wskazuje części dostępne jedynie w zespołach)	Nr części	Ilość
-	PRZENOŚNIK POPRZECZNY	522092	1
1	STELAŻ PRZENOŚNIKA POPRZECZNEGO	522053-1	1
2	KOŁO ŁAŃCUCHOWE 10B1 Z=17 (554567)	522046	5
3	PROWADNICA ŁAŃCUCHA STOŁU PORZECZNEGO	522244	5
4	BLACHA MONAŻOWA OSŁONY	522066-1	5
5	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	10
6	PODKŁADKA SR 1940 (16/27-2)	522062	10
7	SRUBA M6x16-8.8-Fe/Zn5 PN-M/82105	F81001-15	10
8	BLACHA OGRANICZNIKA WYSOKOŚCI	522068-1	1
9	SRUBA M8x20-8.8-Fe/Zn5 PN/M-82406.	F81002-11	10
10	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	65
11	Nut, M8-8-B Hex Nylon Zinc Lock	F81032-2	10
12	OŚ KOŁA ŁAŃCUCH. NAPINAJĄCEGO	522240-1	5
13	NAKRETKA M8-8-B-Fe/Zn5 PN/M-82144.	F81032-1	20
14	SRUBA M8X80-8.8-FE/ZN5 PN-85/M-82105	F81002-99	10
15	TULEJA 8.4/12.5-6 CYNK	504040-1	20
16	Podkładka sprężysta 8.2 Fe/Zn5 PN-M/82008	F81054-4	25
17	SRUBA M8x16-8.8-B-Fe/Zn5	F81002-20	25
18	WKŁADKA PROSTOK. 100x50x2-4 (199195)	522543	4

3

Merry-go-Round Parts

Assembly

3.4

3

Merry-go-Round Parts
