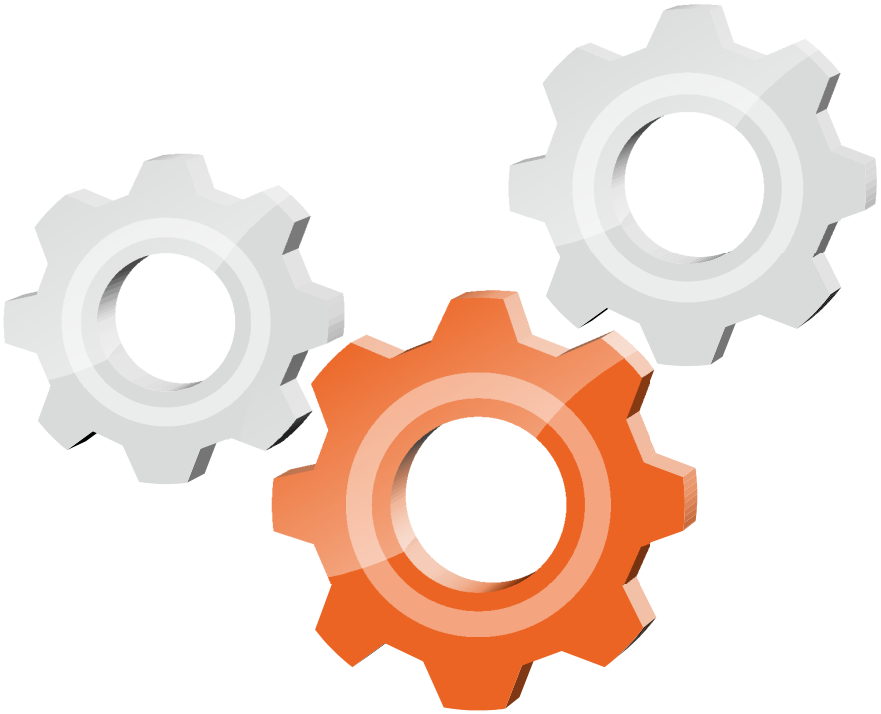
Wood-Mizer®

from forest to final form



user manual

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

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

www.wood-mizer.eu

Wood-Mizer®

Safety, Installation, Operation and Maintenance

LT15WC E15	**rev. A2.01**
LT15WC G25	**rev. A2.01**

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

Form #790

Table of Contents Section-Page

Table of Contents Section-Page

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

Getting Service

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

General Contact Information

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

Office Hours:

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

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

Wood-Mizer will accept these methods of payment:

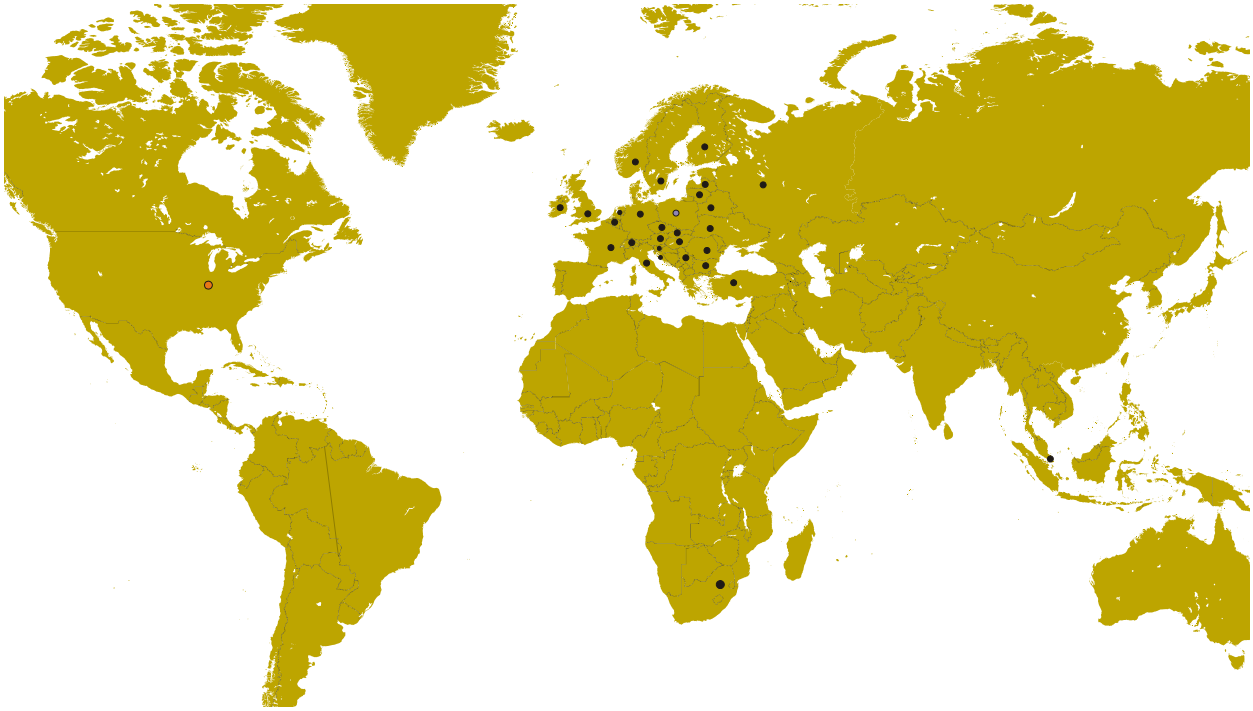
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

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

Technical data are subject to change without prior notice.

Actual product may differ from product images. Some illustrations show machines with optional equipment.

Branches & Authorized Sales CentersWood-Mizer Locations (North and South America)



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SECTION 1 SAFETY INSTRUCTIONS

1.1 Safety Symbols

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

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

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

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

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

Before operating the LT15WC sawmill, read the operator's manual and all additional manuals provided with the machine. Observe all safety instructions included in these manuals!

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

IMPORTANT! It is always owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership, operation and transport of your LT15WC sawmill. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the sawmill.

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

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

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

1.2 Blade Handling

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

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

1.3 Sawmill Setup

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

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

1.4 Sawmill Operation

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

1.5 Sawmill Maintenance

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

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

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

1.6 Safety Instructions

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

Observe Safety Instructions

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

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

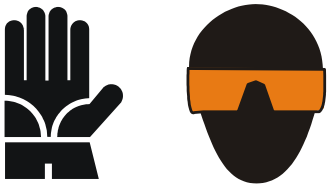
IMPORTANT! Only adult persons who have read and understood the entire operator's manual should operate the sawmill. The sawmill is not intended for use by or around children.

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

Wear Safety Clothing

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

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



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

Keep Sawmill and Area Around Sawmill Clean

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

Dispose of Sawing By-Products Properly

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

Check Sawmill Before Operation

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

Keep Persons Away

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

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

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

Keep Hands Away

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

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

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

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

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

Use Proper Maintenance Procedures

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

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

WARNING! Consider all electrical circuits energized and dangerous.

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

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

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

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

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

Keep Safety Labels In Good Condition

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

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

See table 1-1. See the table below for descriptions of the pictographic warning and informational decals placed on the LT15WC Series sawmills.

TABLE 1-1

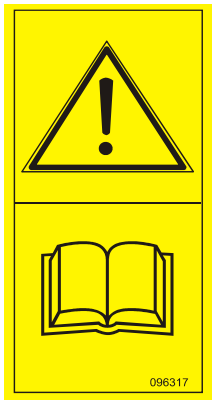
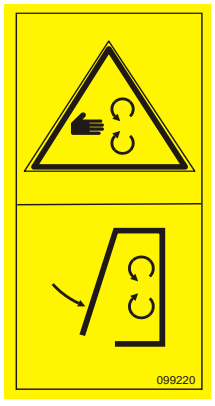
Decal View	Decal No.	Description
	096317	CAUTION! Read thoroughly the operator's manual before operating the sawmill. Observe all safety instructions and rules when operating the machine.
	099220	CAUTION! Close all guards and covers before starting the machine.

TABLE 1-1

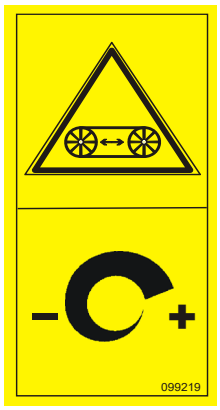
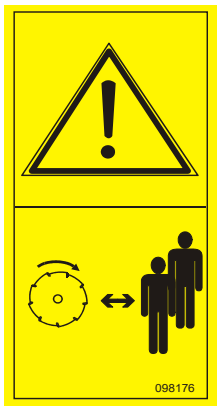
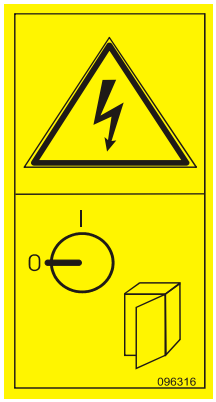
	099219	Blade tension. Turning the bolt clockwise will increase the blade tension, and turning the bolt counterclockwise will decrease the tension.
	099221	CAUTION! Keep all persons away from the machine during sawmill operation.
	098176	CAUTION! Keep away from the debarker blade!
	096316	CAUTION! Do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

TABLE 1-1

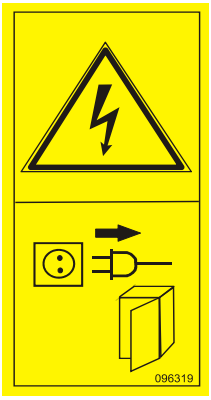
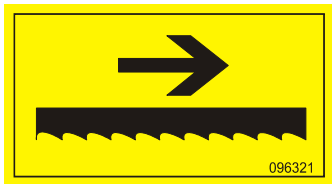
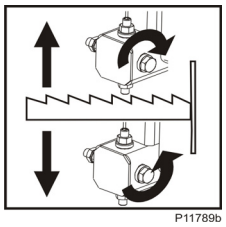
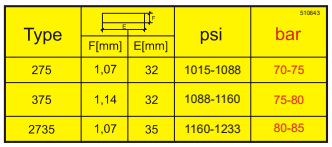
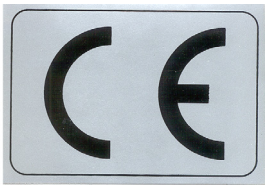
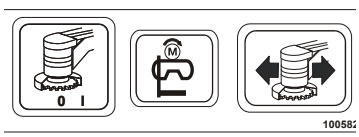
	096319	CAUTION! Disconnect power supply before opening the box.
	096321	Blade movement direction
	S12004G	CAUTION! Always wear safety goggles when operating the sawmill!
	S12005G	CAUTION! Always wear protective ear muffs when operating the sawmill!
	501465	CAUTION! Always wear safety boots when operating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

TABLE 1-1

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

1.7 Belt Sizes

See table 1-2. Belt sizes for the LT15WC sawmill are shown below.

Description	Belt Size	PART #
Motor Drive Belt E15	2BX81	014819-2
Up/Down Drive Belt	AVX-13x 1100La.	095306
Blade Pulley Belts	B57 [1]	P04185-3

TABLE 1-2

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

1.8 Blade Sizes

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

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

The LT15WC sawmill can be equipped with a 35 mm or 38 mm wide blade. LT15WC sawmill is equipped with a blade with a length of 4.47 m.

1.9 Cutting Capacity

See table 1-3. The log size capacities of the LT15WC sawmill are listed below.

	Maximum Log Diameter	Maximum Length [1]
LT15WC S2	90 cm	3.5 m
LT15WC S3	90 cm	5.4 m
LT15WC S4	90 cm	7.3 m
LT15WC M2	90 cm	5.2 m
LT15WC M3	90 cm	7.9 m
LT15WC M4	90 cm	10.6 m

TABLE 1-3

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

See table 1-4. The performance capacity of the LT15WC sawmill is listed below.

Sawmill Model	Cutting Rate
LT15WC E15, G25	3.3 m/min.

TABLE 1-4

1.10 Engine/Motor Specifications

See table 1-5. See the table below for specifications of the engine used on the LT15WC AC sawmills.

Engine/Motor Type	Manufacturer	Model Number	Other Data
Electric Motor 11 kW	Indukta, Poland	PSg-132S-2_H132	3 x 400V, 50 Hz
Up/Down Motor, 0.55 kW	Besel	SKh71X-4C2/HPS08	3x 230/400VAC, 50Hz
Power Feed Motor, 0.55 kW	Dutchi Motors, The Netherlands	DMA 80K4	230/400V, 50 Hz

TABLE 1-5

See table 1-6. See the table below for specifications of the engine used on the LT15WC DC sawmills.

Engine/Motor Type	Manufacturer	Model Number	Other Data
Engine G25	Kohler USA	CH730S	725 cm^3, 3600 r.p.m.
Up/Down Motor, 0.55 kW	Current Applications	---	12VDC,1550r.p.m.
Power Feed Motor, 0.37kW	Current Applications	4085-018	12V DC, 1550 r.p.m.

TABLE 1-6

See table 1-7. Specifications of power supply for the LT15WC SAWMILL

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

TABLE 1-7

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

1.11 Noise Level

See table 1-8. The average level of noise generated by the LT15WC sawmill is given in the table below[12].

Sawmill	Noise Level:
LT15WC E15	L_{aP} = 87 dB (A)
LT15WC G25	L_{aP} = 96 dB (A)

TABLE 1-8

1.12 Sawdust Exhaust System Specifications

See table 1-9. The specifications of sawdust exhaust system that should be used with the sawmill are listed below[3].

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

TABLE 1-9

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

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

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

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

---

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard The noise exposure level given above concerns an 8-hour work day. Value for associated uncertainty K=4dB.

2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. The factors affecting a current level of noise exposure during work are inter alia room characteristics and characteristics of other noise sources, e.g. number of machines and machining operations nearby. Also the permissible exposure level can vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.

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

1.13 Overall Dimensions

See Figure 1-1. The overall dimensions of the LT15WC sawmill are shown below.

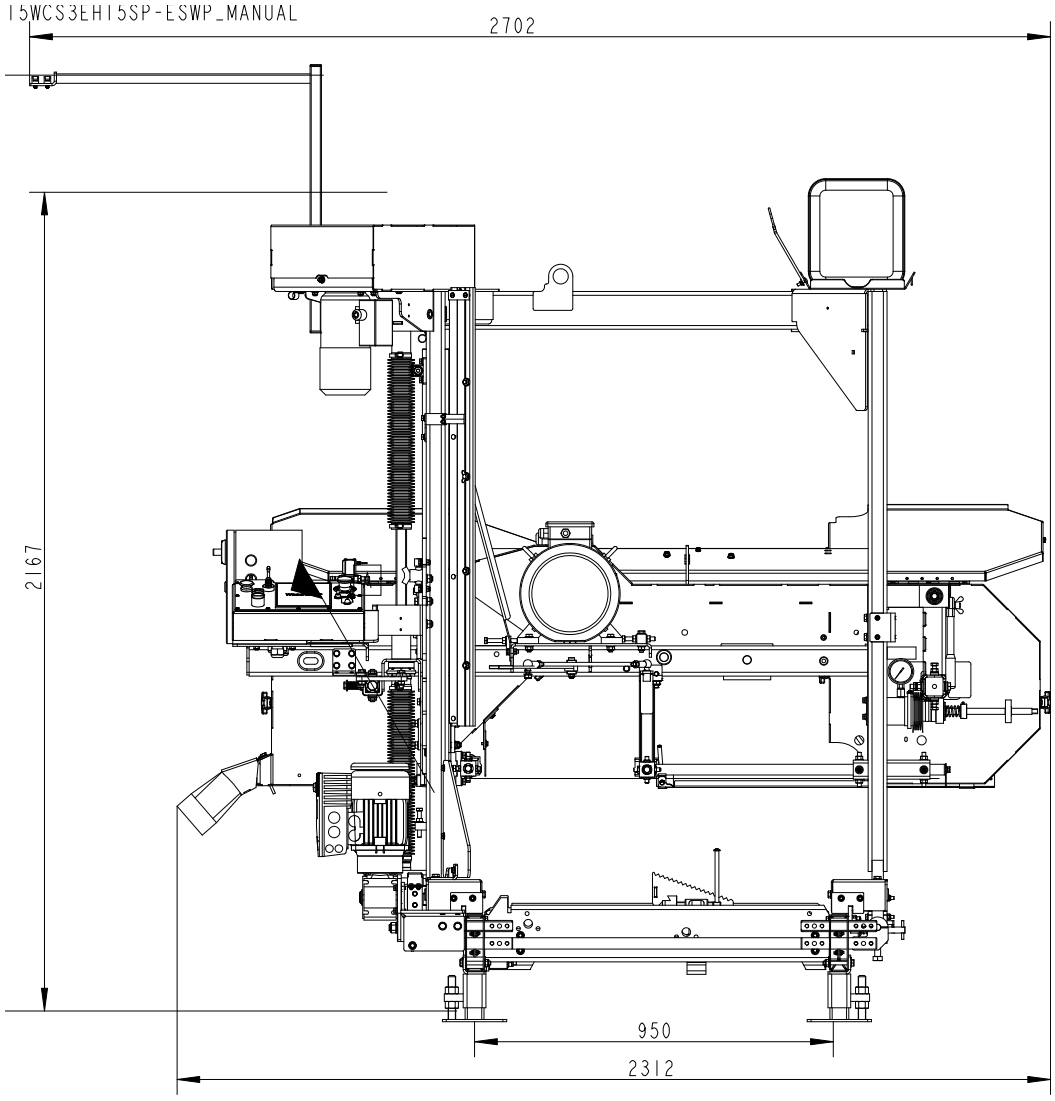


FIG. 1-1

See Figure 1-2. The overall dimensions of the LT15WC sawmills with M type frames are shown below.

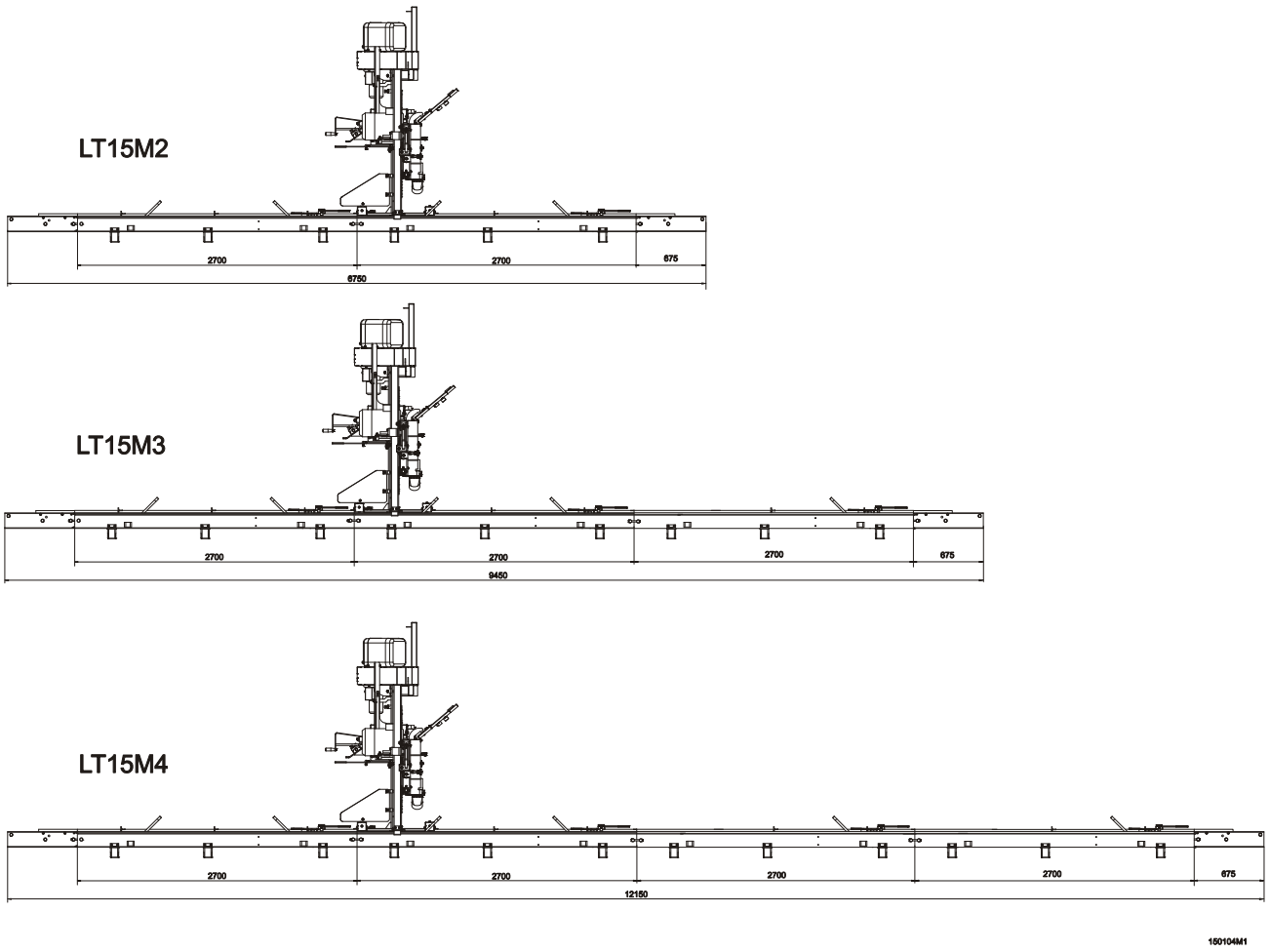


FIG. 1-2

See Figure 1-3. The overall dimensions of the LT15WC sawmills with S type frames are shown below.

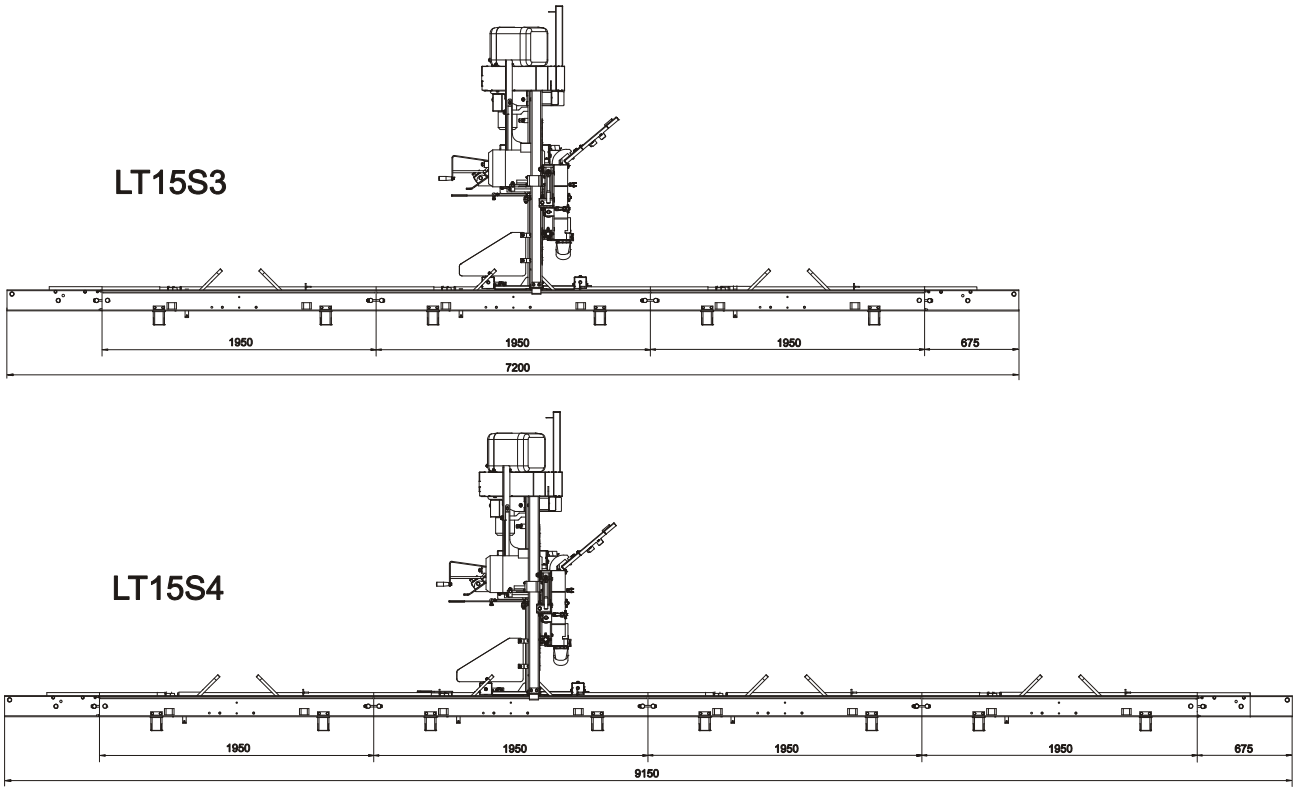


FIG. 1-3

See Figure 1-4. The legs layout of the LT15WC sawmills with S type frames is shown below.

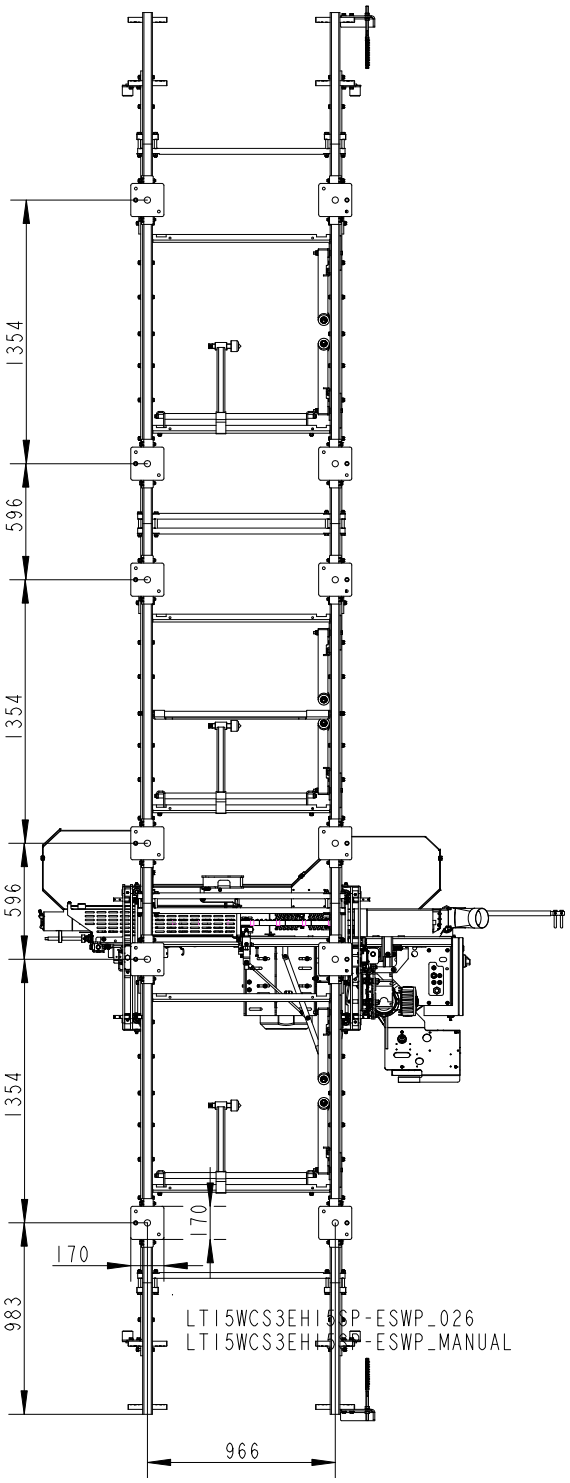


FIG. 1-4

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

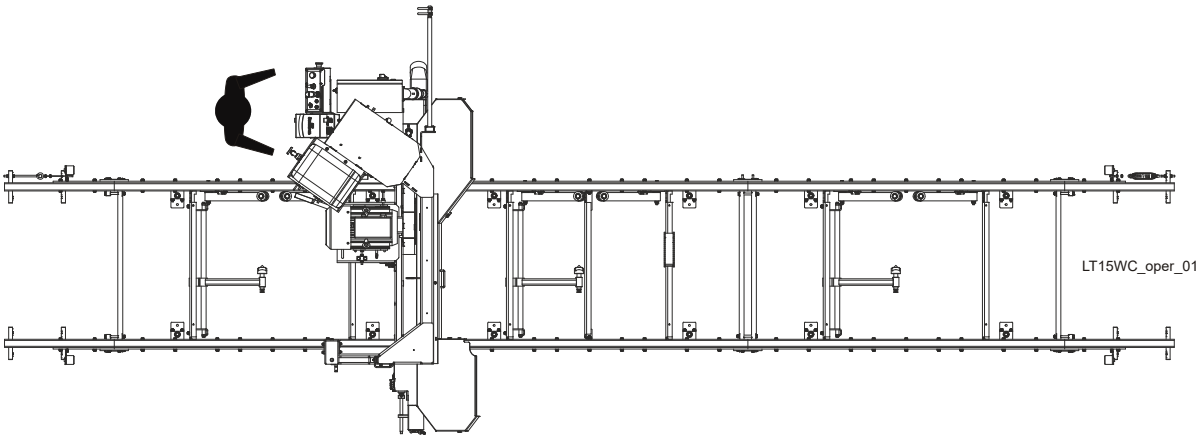


FIG. 1-5

1.14 Components

The major components of the LT15WC sawmill are shown below.

See Figure 1-6.

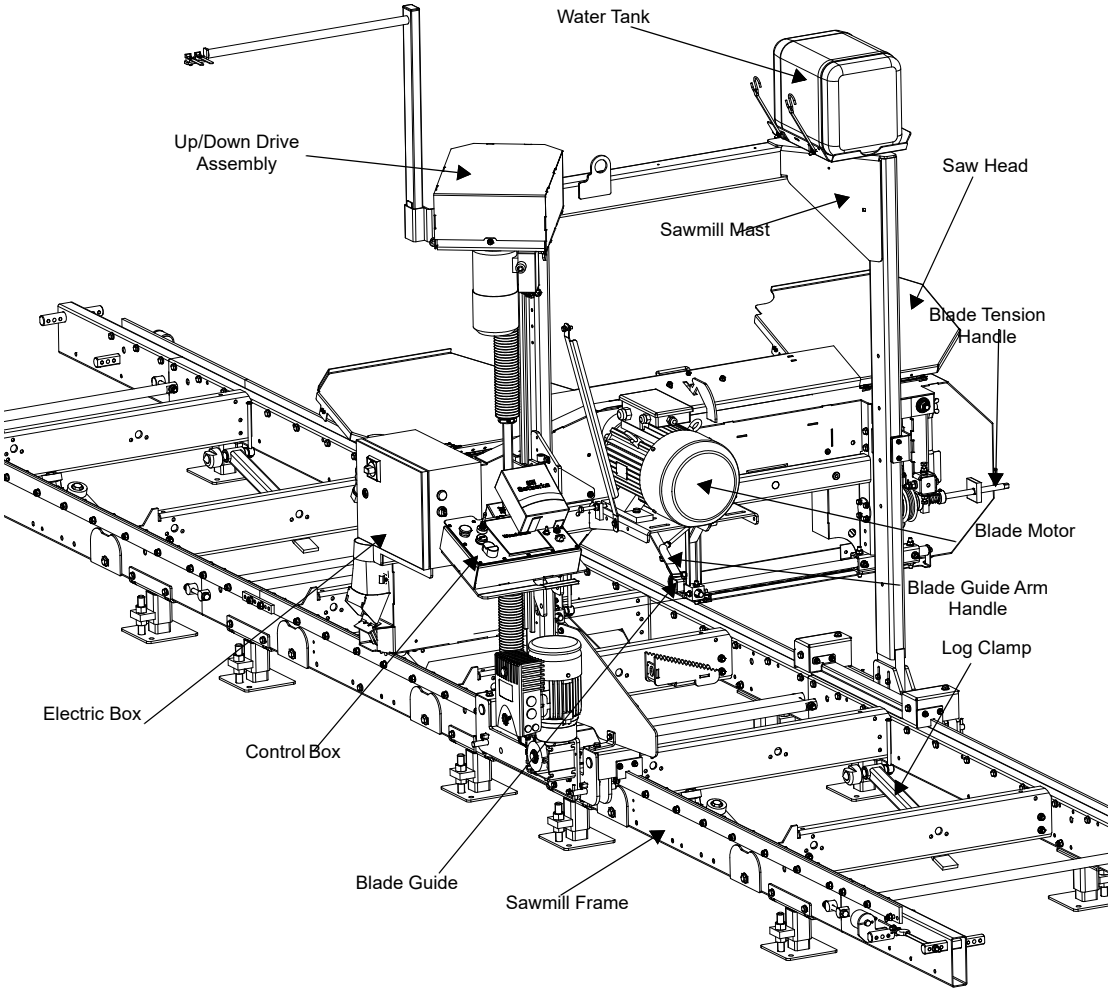


FIG. 1-6

SECTION 2 SAWMILL ASSEMBLY

Scan to see the assembly video.

2.1 Mounting Parts of LT15WC Sawmills with Electric Motors

2.1.1 Parts specifications

Table 1:

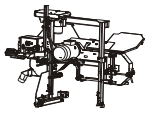
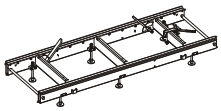
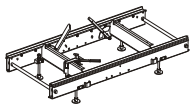
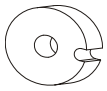
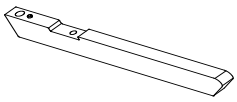
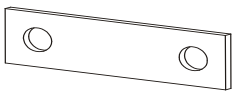
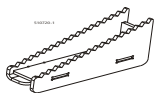
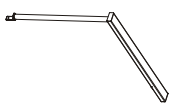
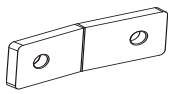
Fig.	Wood-Mizer No.	Description	Qty. LT15 M3	Qty. LT15 S2	QTY LT15 S3/S3-P		QTY LT15 S4/S4-P	
					LT15 S3	LT15 S3-P	LT15 S4	LT15 S4-P
	094132	LT15 Sawmill Saw Head	1	1	1	1	1	1
	094697	LT15 Bed Section, Complete (2.75 m)	3	--	--	--	--	--
	094514	LT15 Bed Section, Complete (1.95 m)	--	2	3	3	4	4
	085981-1	Thick Spacer Washer	6	4	6	6	8	8
	085982-1	Log Side Support, Complete	6	4	6	6	8	8
	085994-1	Bed Leg Mounting Washer, Painted	18	8	12	12	16	16
	086035-1	Leveling Wedge, Painted	1	1	1	1	1	1
	086132-1	Power Cord Bracket	1	1	1	1	1	1
	086171-1	Side Bracket	2	2	2	2	2	2

Table 1:

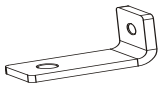
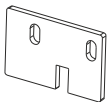
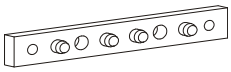
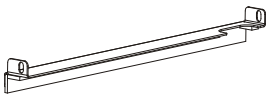
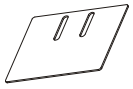
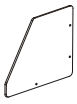
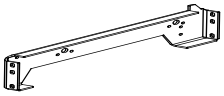
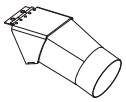
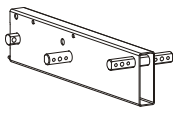
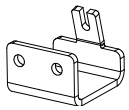
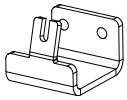
	086172-1	Bottom Bracket	**1**	**1**	**1**	**1**	**1**	**1**
	531670	Track Wiper	**2**	**2**	**2**	**2**	**2**	**2**
	086659-1	Frame Mounting Strap, Zinc-plated	**4**	**3**	**4**	**4**	**6**	**6**
	086745	Middle Track Cover with Felt Wiper	**1**	**1**	**1**	**--**	**1**	**--**
	092378-1	Bracket, Blade Guide Roller Guard	**--**	**--**	**--**	**--**	**--**	**1**
	092379-1	Blade Guide Roller Guard	**--**	**--**	**--**	**--**	**--**	**1**
	093859	Plate, PC Guard	**1**	**1**	**1**	**--**	**1**	**--**
	094250-1	Track Rail, Zinc-plated (Short)	**2**	**2**	**2**	**2**	**2**	**2**
	095490-1	Auxiliary Bed Rail	**1**	**1**	**1**	**1**	**1**	**1**
	100903-1	Sawdust Chute	**1**	**1**	**1**	**1**	**1**	**1**
	500844-1	Bed Extension Tube	**2**	**2**	**2**	**2**	**2**	**2**
	531672-1	Feed Rope, Mount Front Bracket	**1**	**1**	**1**	**--**	**1**	**--**
	531673-1	Feed Rope, Mount Rear Bracket	**1**	**1**	**1**	**--**	**1**	**--**

Table 1:

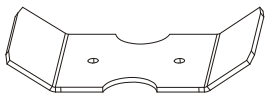
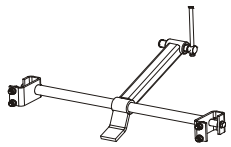
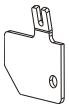
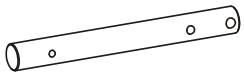
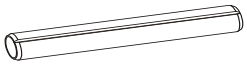
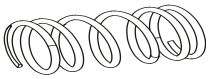
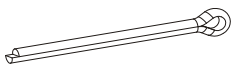
	506287-1	Plate, Bed Section Connector	**12**	**8**	**12**	**12**	**16**	**12**
	507565	Log Clamp	**3**	**2**	**3**	**3**	**4**	**4**
	508236-1	Bracket, Feed Cable Mount - Front	--	--	**1**	--	--	--
	508237-1	Bracket, Feed Cable Mount - Rear	--	--	**1**	--	--	--
	538799-1 (LT15S3) 538935-1 (LT15M2)	Track Rail	**3**	**2**	**3**	**3**	**4**	**4**
	LTBGAT	Tool, Blade Guide Alignment	--	--		--	--	--
	R02080	Rope	**11.4**	**7**	**9**	--	**12**	--
Vertical Mast Lock Assembly								
	086743-1	Zinc-plated Pin	**2**	**2**	**2**	--	**2**	--
	F81045-1	Roll Pin 6x50	**2**	**2**	**2**	--	**2**	--
	F81044-21	Roll Pin 3x20	**2**	**2**	**2**	--	**2**	--
	087301	Compres-sion Spring 18x37x1.8	**2**	**2**	**2**	--	**2**	--
	F81043-2	Pin, S-Zn-4x25 Cotter	**2**	**2**	**2**	**2**	**2**	**2**

Table 1:

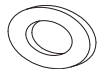
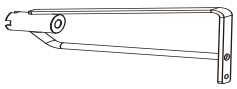
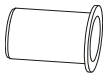
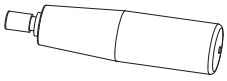
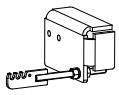
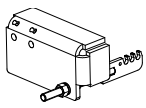
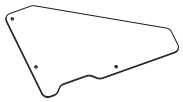
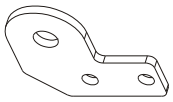
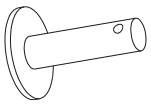
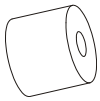
	F81058-1	Washer, 17	**2**	**2**	**2**	**--**	**2**	**--**
Manual Feed Assembly								
	538949-1	Power Feed Crank Handle	**1**	**1**	**1**	**--**	**1**	**--**
	094142	Bushing	**2**	**2**	**2**	**--**	**2**	**--**
	086338	Crank Handle Grip	**1**	**1**	**1**	**--**	**1**	**--**
	F81033-1	Hex Nylon Lock Nut M10	**1**	**1**	**1**	**--**	**1**	**--**
Power Feed Assembly								
	544323	Chain 7456 MM 587-link	**--**	**--**	**-1**	**1**	**--**	**--**
	544323-S3	Chain 7201 MM 567-link	**--**	**--**	**-1**	**1**	**--**	**--**
	550808	Chain 7010 MM 552-link (LT15WC-M2)	**--**	**--**	**--**	**--**	**--**	**--**
	550807	Chain 9411 MM 741-link	**--**	**--**	**--**	**--**	**1**	**1**
	544321	Chain Tensioner - right	**--**	**--**	**--**	**1**	**--**	**1**
	544320	Chain Tensioner - left	**--**	**--**	**--**	**1**	**--**	**1**
	500839	Middle Track Cover with Felt Wiper	**--**	**--**	**--**	**1**	**--**	**1**

Table 1:

	500726	Cover, LT15 Lower	--	--	--	1	--	1
	501414-1	Plate, Power Feed Support	--	--	--	2	--	2
	086182-1	Mount Weldment , Saw Head Stop	--	--	--	2	--	2
	P12165	Bushing, Rubber	--	--	--	2	--	2

2.1.2 Specifications of Fasteners

Table 2:

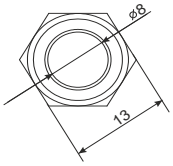
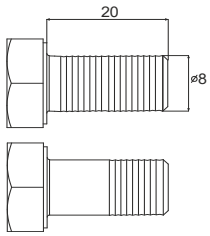
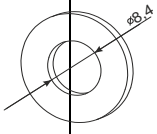
Wood-Mizer No.	Description	Qty. LT15 M3	Qty. LT15 S2	QTY LT15 S3		QTY LT15 S4	
				LT15 S3	LT15 S3-P	LT15 S4	LT15 S4-P
Designations of fasteners: M8 Nut  M8x20 Bolt  8.4 Washer 							
014972	Washer, 33/64 x1 3/4" x 1/32 Nylon	6	4	6	6	8	8
100076-1	Bolt, M10-20 Special	6	6	6	6	8	8
F81000-7	Bolt, M5x25	2	2	2	2	2	2
F81001-15	Bolt, M6x16-8.8	12	8	12	12	16	12
F81001-7	Bolt, M6x12	--	--	2	--	--	--
F81002-20	Bolt, M8x16-8.8-B Hex Head Full Thread Zinc	--	--	2	2	--	2
F81002-4	M8x20 Bolt	10	10	10	10	10	10
F81002-5	Bolt, M8x25-8.8-B Hex Head Full Thread Zinc	3	3	3	3	3	3
F81002-6	Bolt, M8x12	--	--	--	2	--	2

Table 2:

F81003-1	Bolt, M10x20-5.8 Hex Head Full Thread Zinc	2	2	2	2	--	--
F81003-11	Bolt, M10x25-8.8	8	8	8	8	12	12
F81003-15	Bolt, M10x75	47	27	34	34	43	43
F81003-2	Bolt, M10x30 5.8	4	4	4	4	4	4
F81003-2	Bolt, M10x30 8.8	--	--	--	4	12	4
F81003-66	Bolt, M10x90	1	1	1	1	1	1
F81004-12	Bolt, M12-55-8.8	--	--	--	--	--	--
F81004-35	Bolt, M12x140	6	6	6	6	8	8
F81004-36	Bolt, M12x130	--	--	6	--	--	--
F81004-38	Bolt, M12x120	12	8	12	12	16	16
F81030-2	Nut, M5	2	2	2	2	2	2
F81031-2	Nut, M6-8-B	12	8	12	14	16	14
F81032-2	M8 Nut	3	3	3	3	3	3
F81033-1	Nut, M10 Hex Nylon Lock	82	50	57	57	75	75
F81033-3	Nut, M10	6	4	6	10	8	12
F81034-2	Nut, M12 Hex Nylon Lock	22	16	20	20	26	26
F81053-1	6.4 Washer	--	--	24	--	--	--
F81053-11	Washer, 6.5 Special Flat	--	--	6	--	--	--
F81054-1	Washer, 8.4	16	16	16	16	16	16
F81054-4	Washer, 8.4	--	--	--	--	--	--
F81055-1	Washer, 10.5	150	101	101	106	126	131
F81055-2	Washer, 10.2 Split Lock	12	12	12	12	16	16
F81056-1	Washer, 13	38	30	36	36	46	46
F81082-1	Tie wrap	2	2	2	2	2	2
Outrigger Leg Kit (Option)							
F81003-58	Bolt, M10x120	36	16	24	24	32	32
F81007-1	Bolt, M20x240	18	8	12	12	16	16
F81037-1	Nut, M20-8 Hex Zinc	18	8	12	12	16	16
F81059-2	Washer, 21	18	8	12	12	16	16

2.1.3 Tools Necessary for Assembling the Sawmill

Table 3:

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

2.2 Unpacking the Sawmill

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

See figure 2-1.

FIG. 2-1

1. Cut the bands holding the components together.
2. Remove the parts arranged inside the bed section.

3. Using a forklift truck or a winch with lifting capacity of minimum 500 kg, carefully lift the saw head and set it aside. Attach the winch hook to the bracket on the saw head.

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

See figure 2-2.

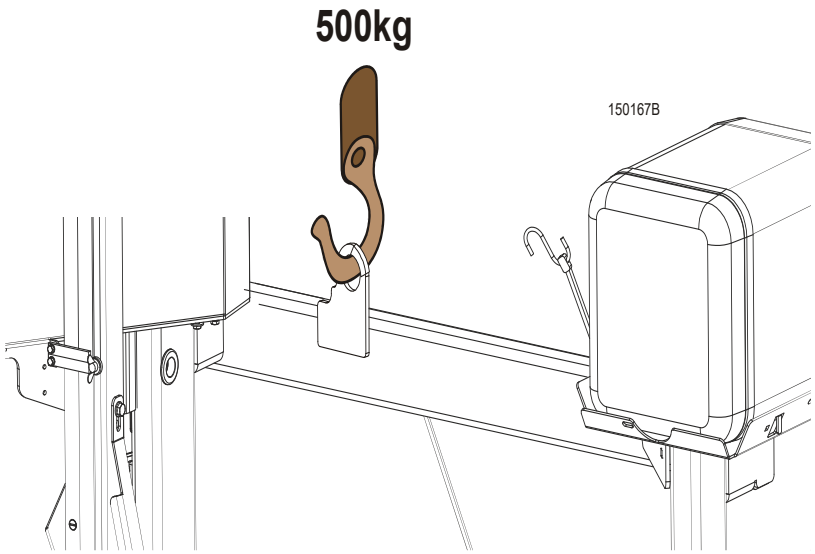


FIG. 2-2

2.3 Bed Frame Assembly

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

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

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

See figure 2-3.

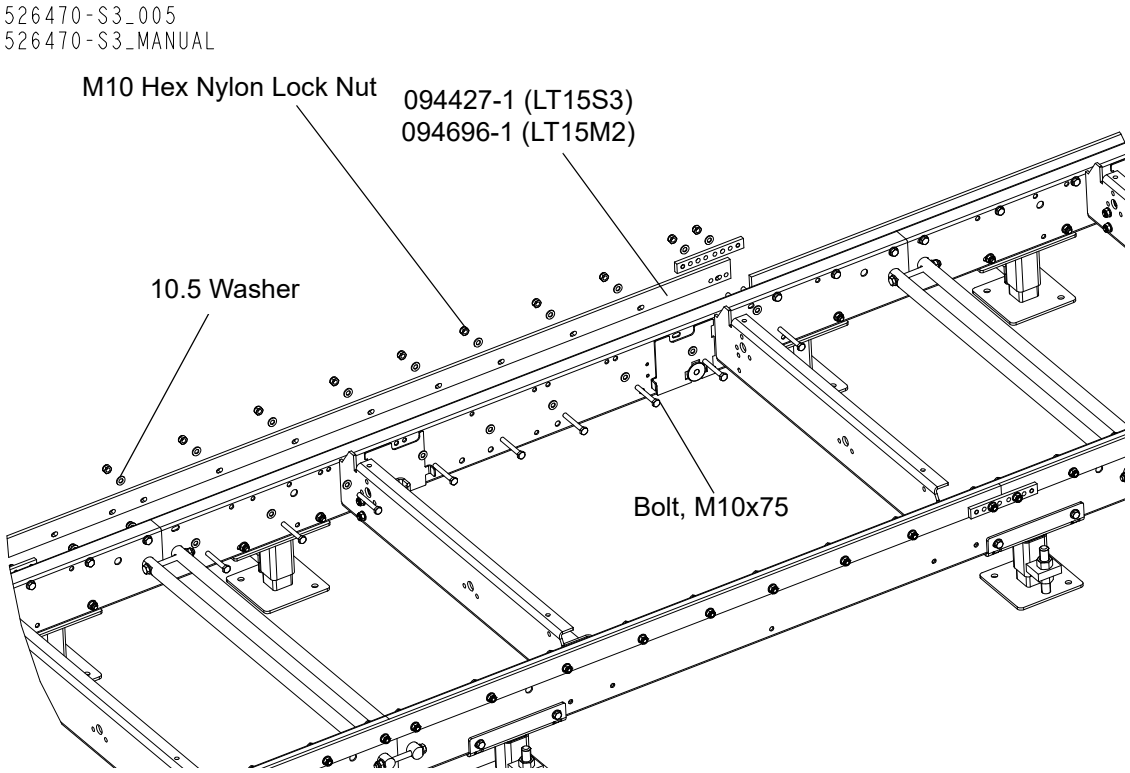


FIG. 2-3

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

See figure 2-4.

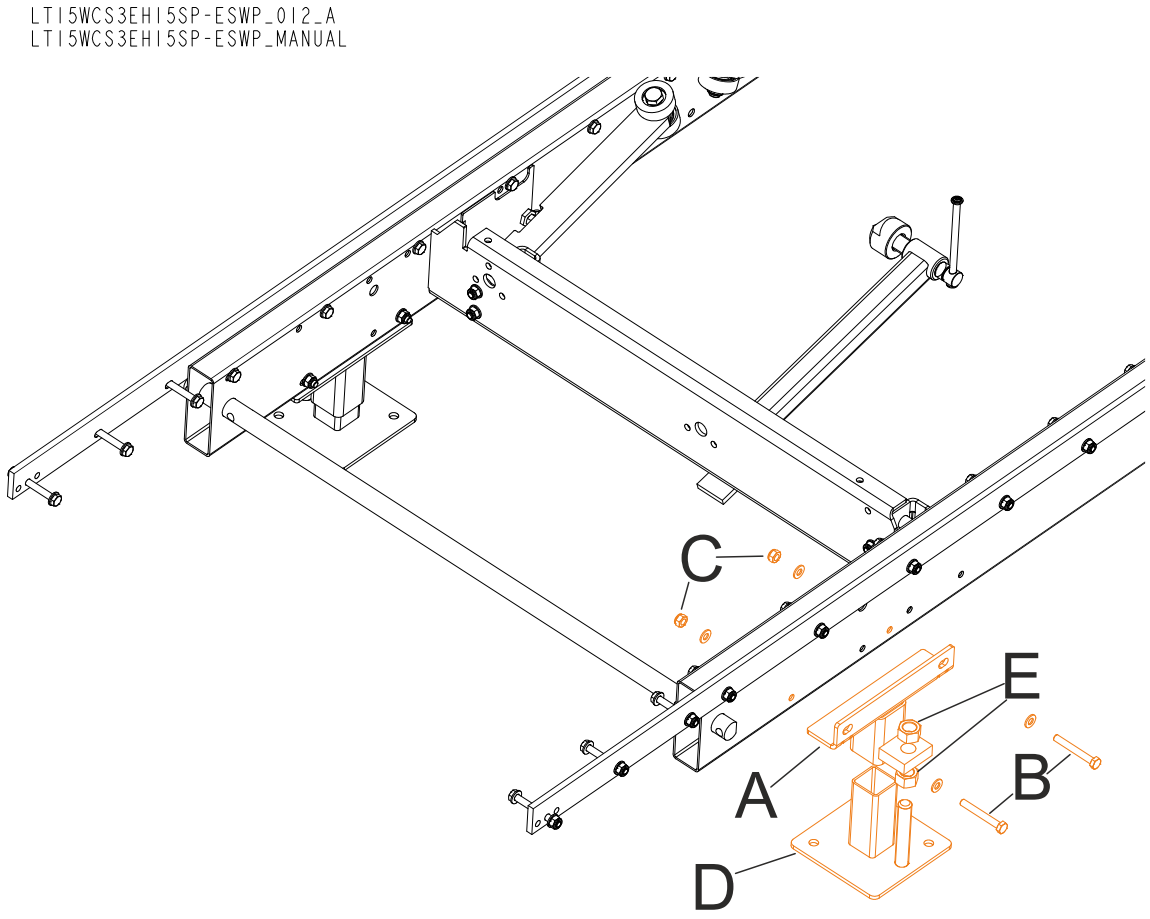


FIG. 2-4

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

See figure 2-5.

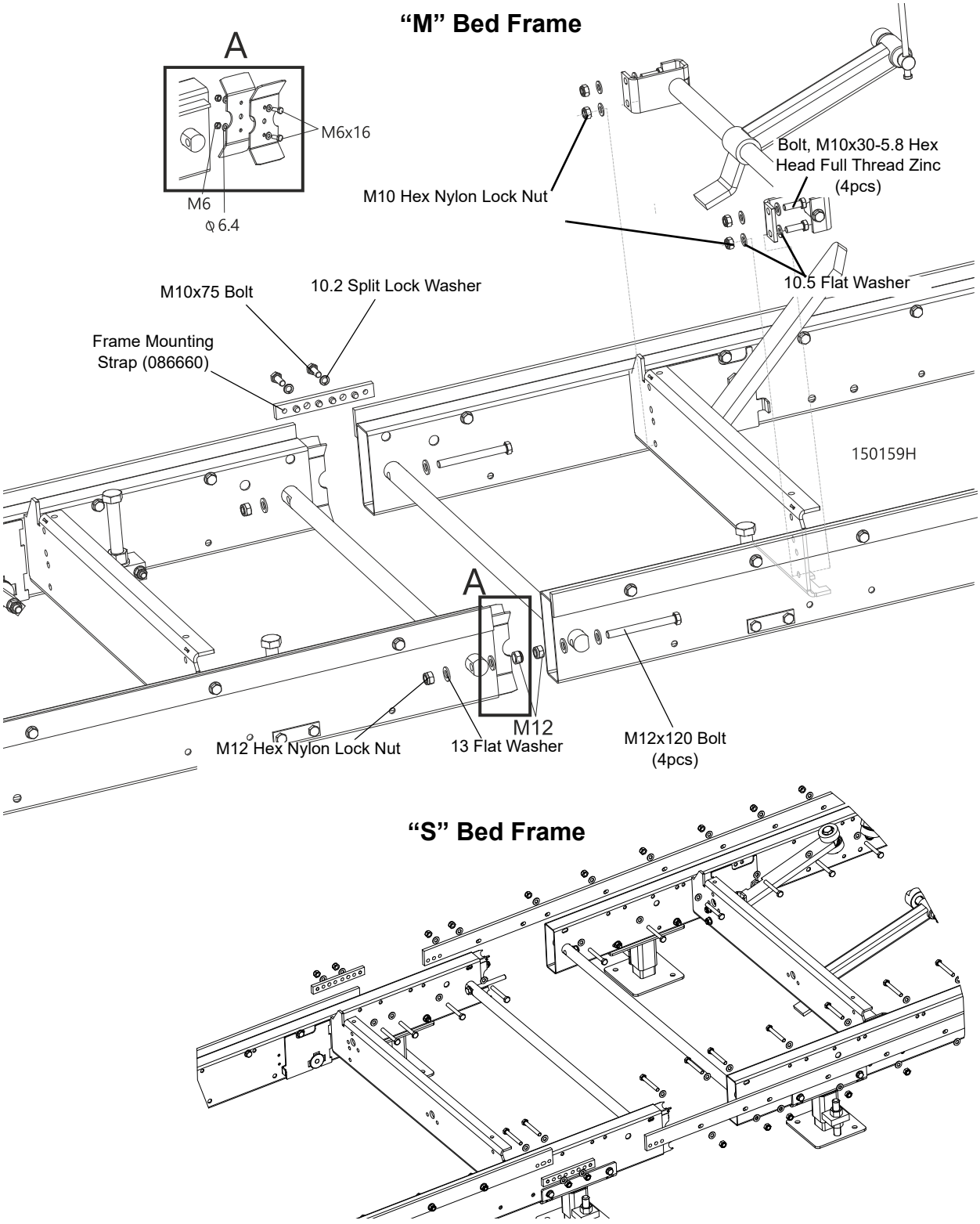


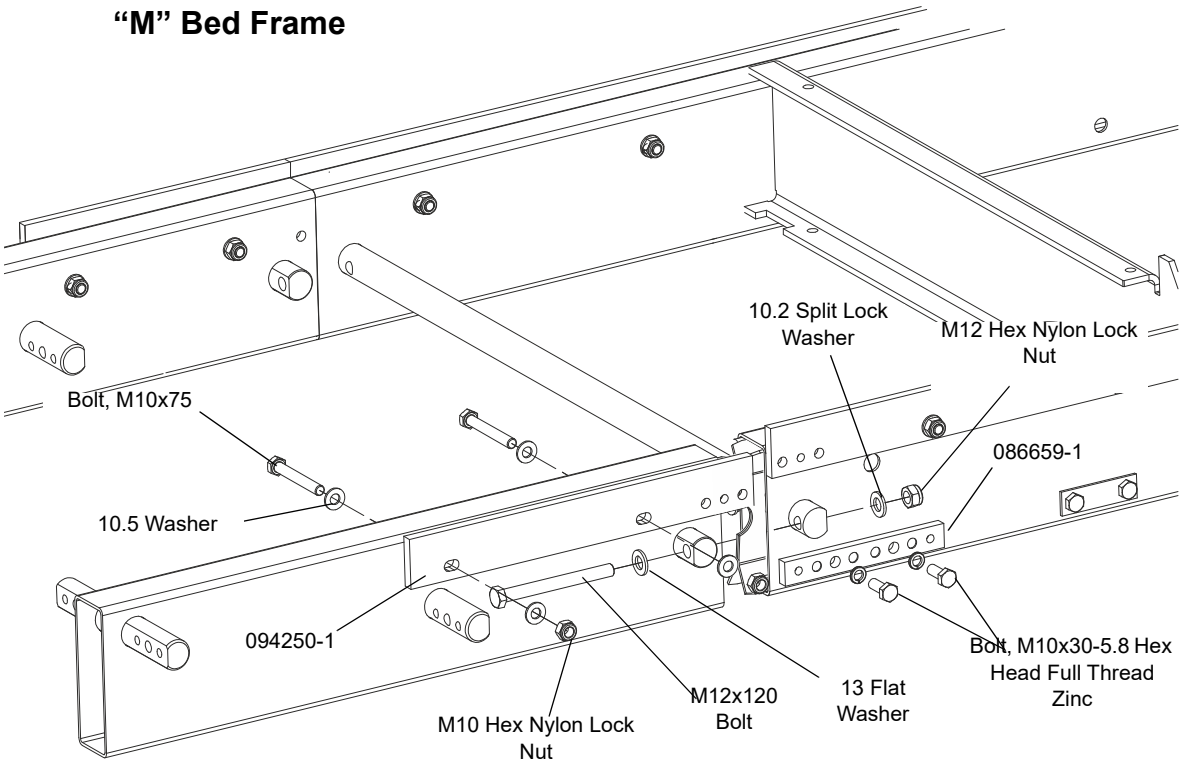
FIG. 2-5

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

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

See figure 2-6.

“M” Bed Frame



“S” Bed Frame

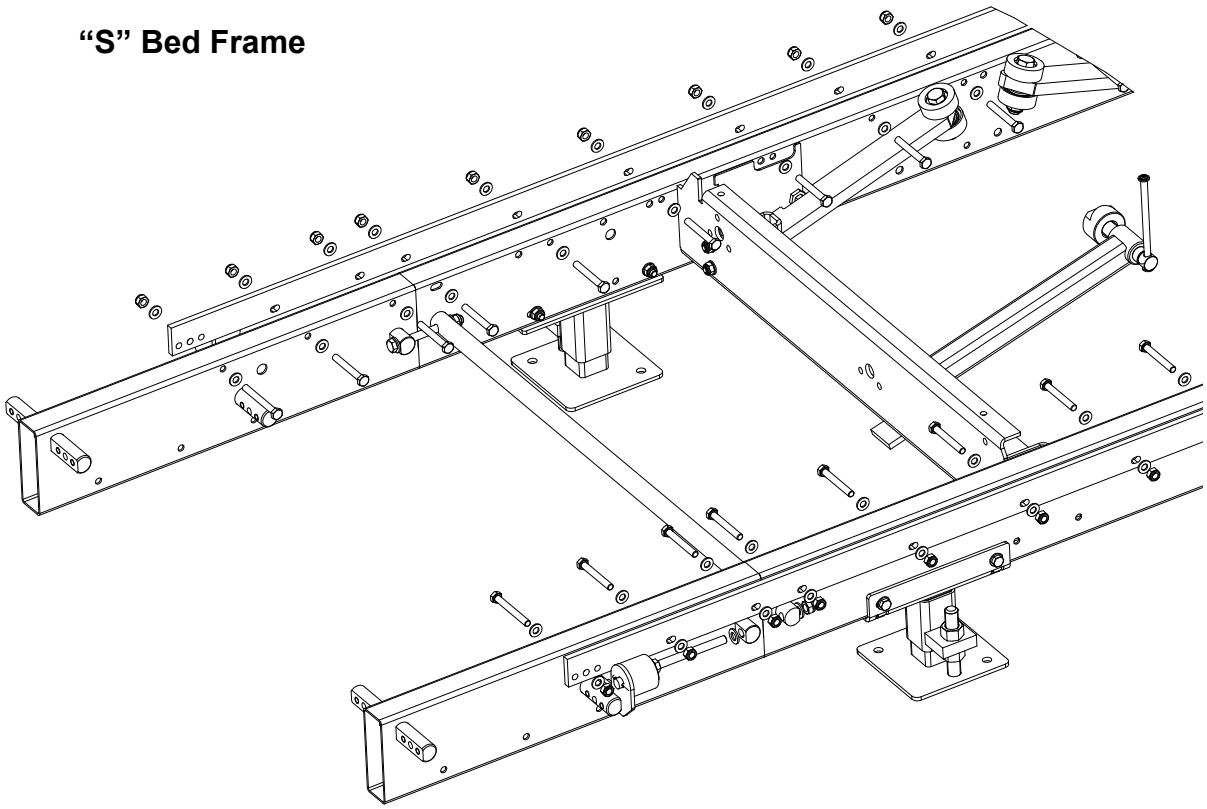


FIG. 2-6

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

7. Install the log side supports as shown in Figure 2-7. Tighten the nuts so that the side supports can be moved with little resistance. Adjust side support, *See Section 6.11*.

   See figure 2-7.

LT15WCS3EH15SP-ESWP_021
LT15WCS3EH15SP-ESWP_MANUAL

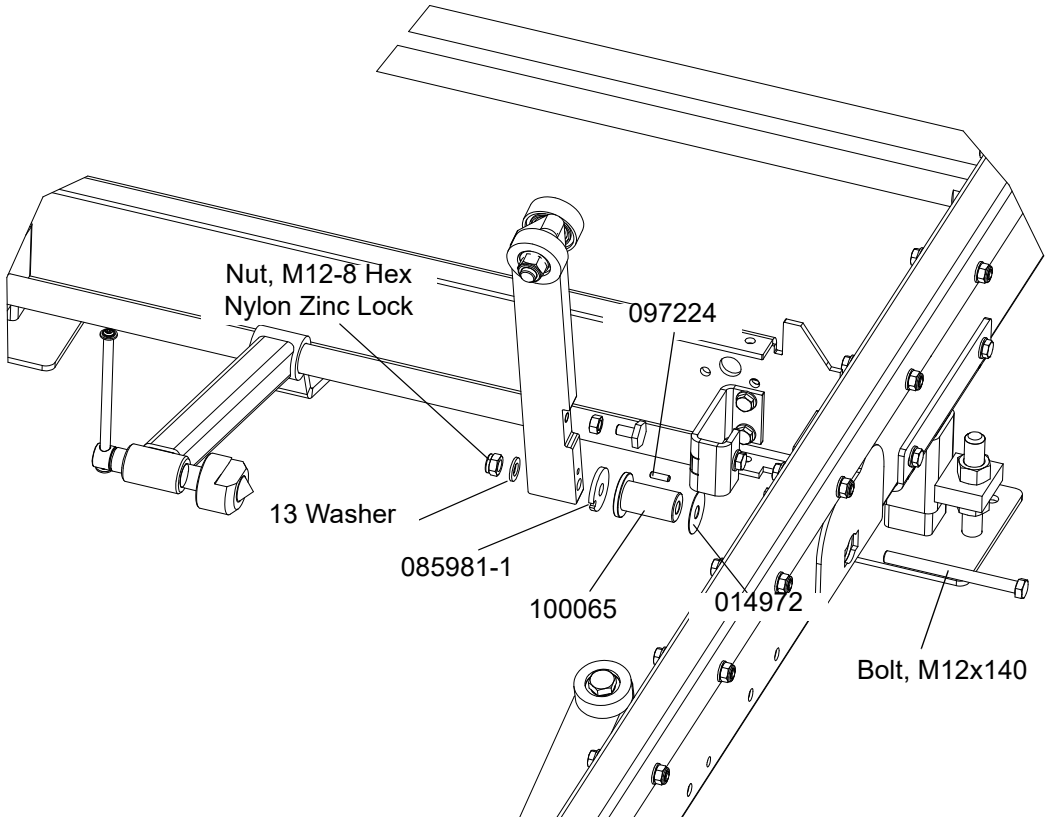


FIG. 2-7

2.3.1 Possibility of sawmill bed and service bed section connection.

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

   See figure 2-8.

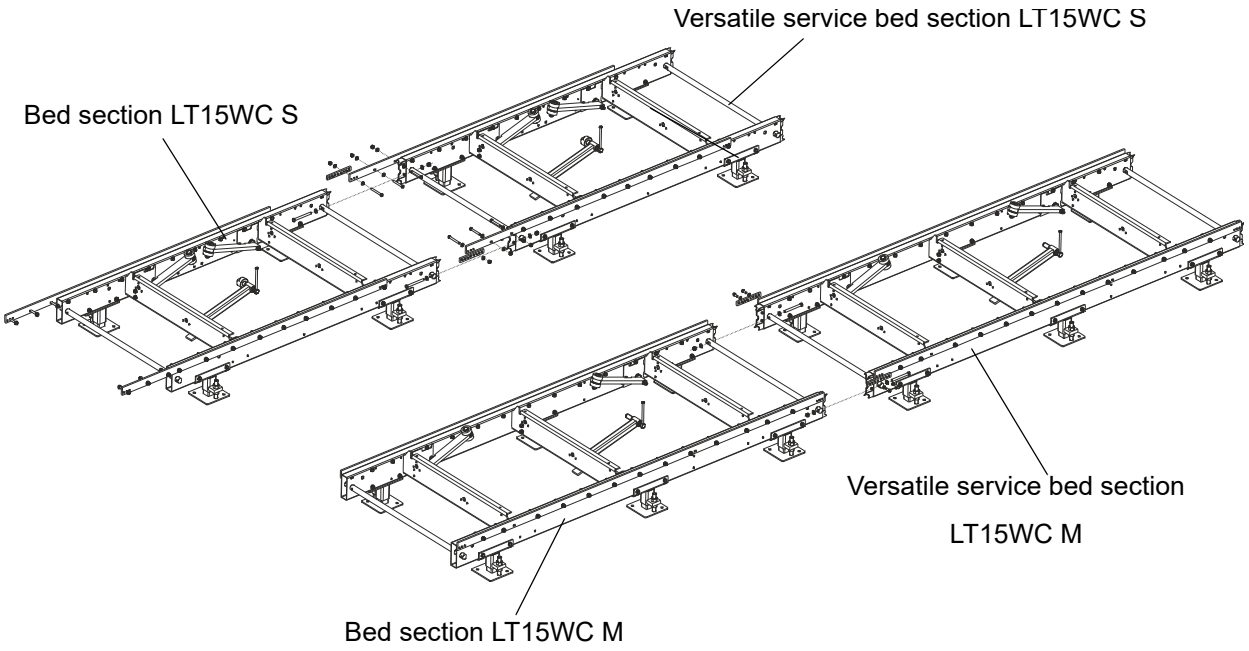


FIG. 2-8

2.4 Saw Head Assembly

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

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

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

See figure 2-9.

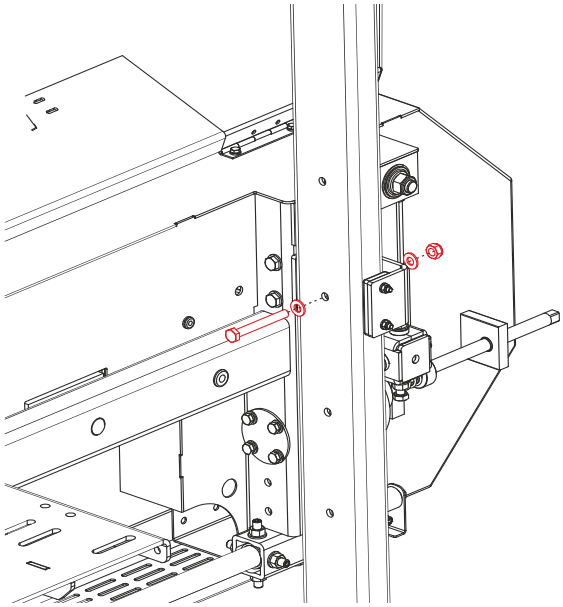


FIG. 2-9

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

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

See figure 2-10.

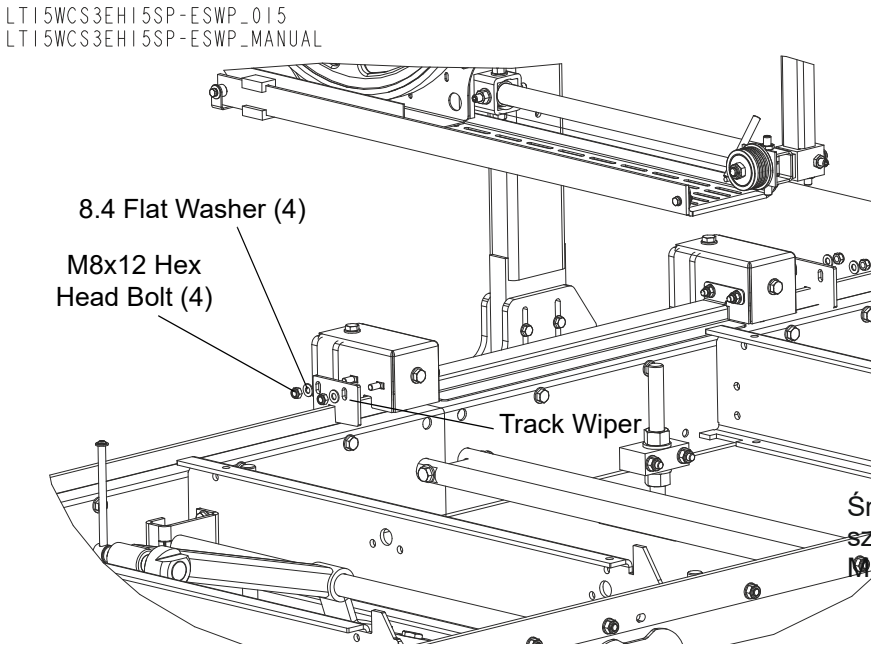


FIG. 2-10

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

4. Assemble mast safety pins.

See figure 2-11.

LTI5WCS3EHI5SP-ESWP_016
LTI5WCS3EHI5SP-ESWP_MANUAL

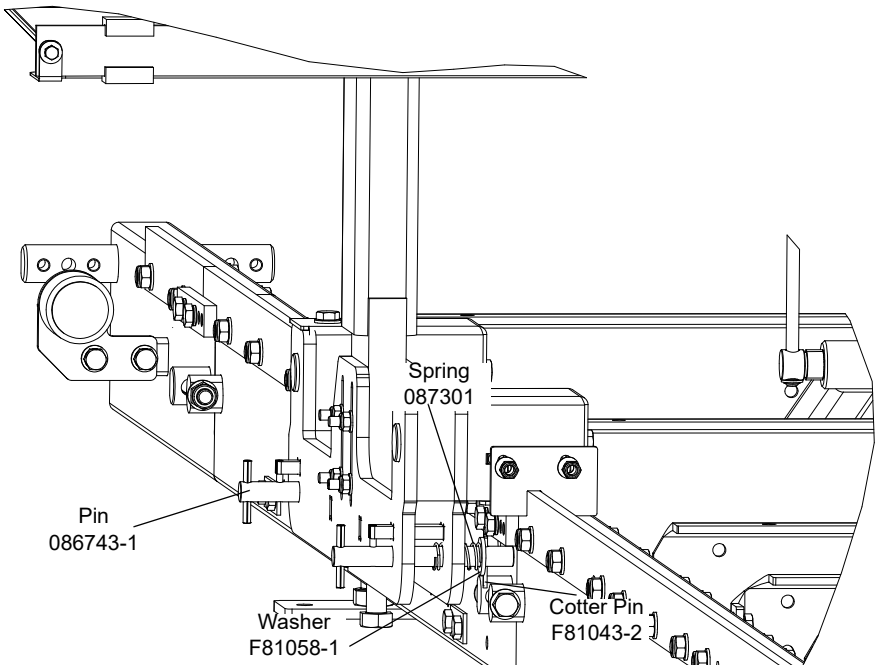


FIG. 2-11

5. Install the PC operator guard.

See figure 2-12.

LTI5WCS3EHI5SP-ESWP_017
LTI5WCS3EHI5SP-ESWP_MANUAL

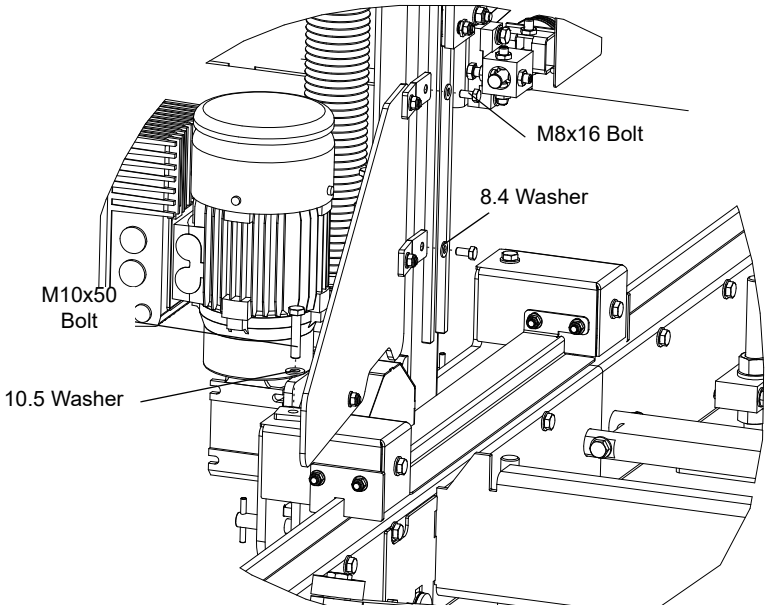


FIG. 2-12

6. Install the blade guides.

See figure 2-13.

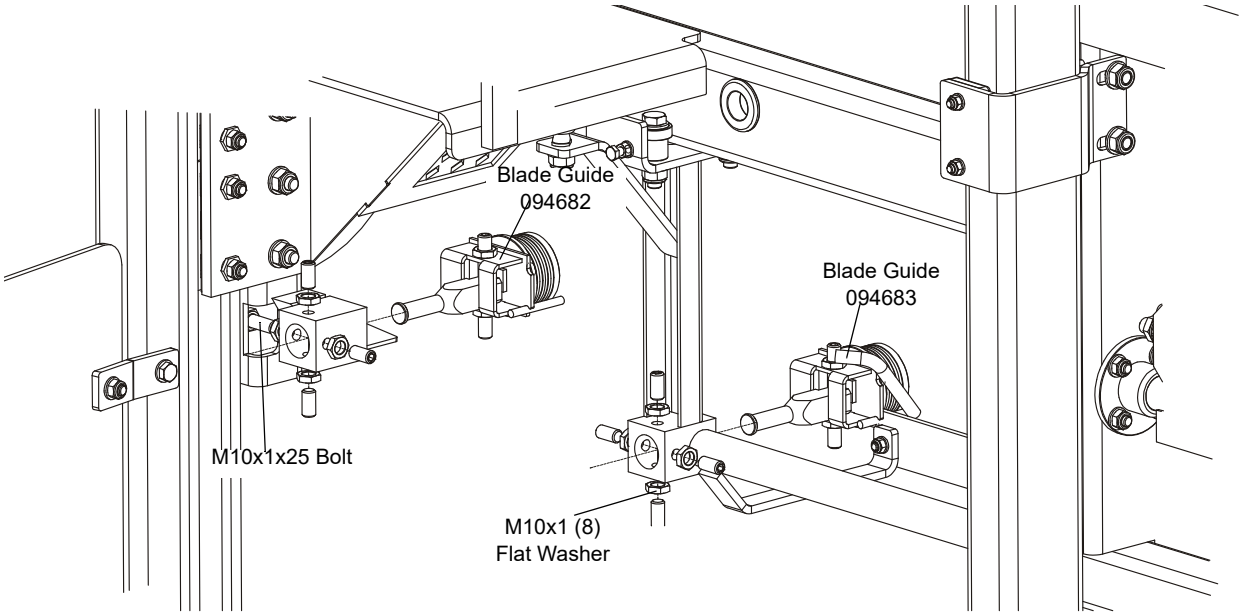


FIG. 2-13

7. Turn the power feed motor from the travel position to the work position. The motor should be positioned as shown in the figure below. Tighten the motor mounting screws.

See figure 2-14.

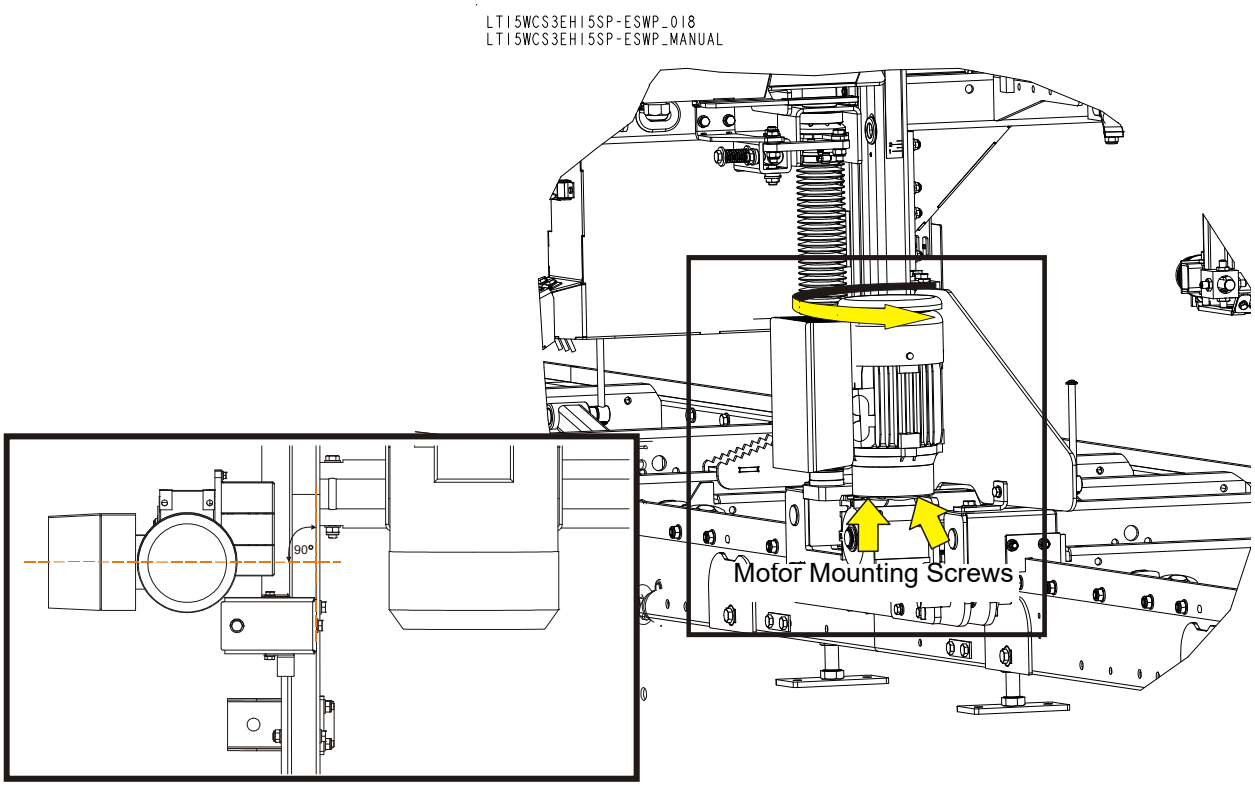


FIG. 2-14

8. Install the power cord bracket.

See figure 2-15.

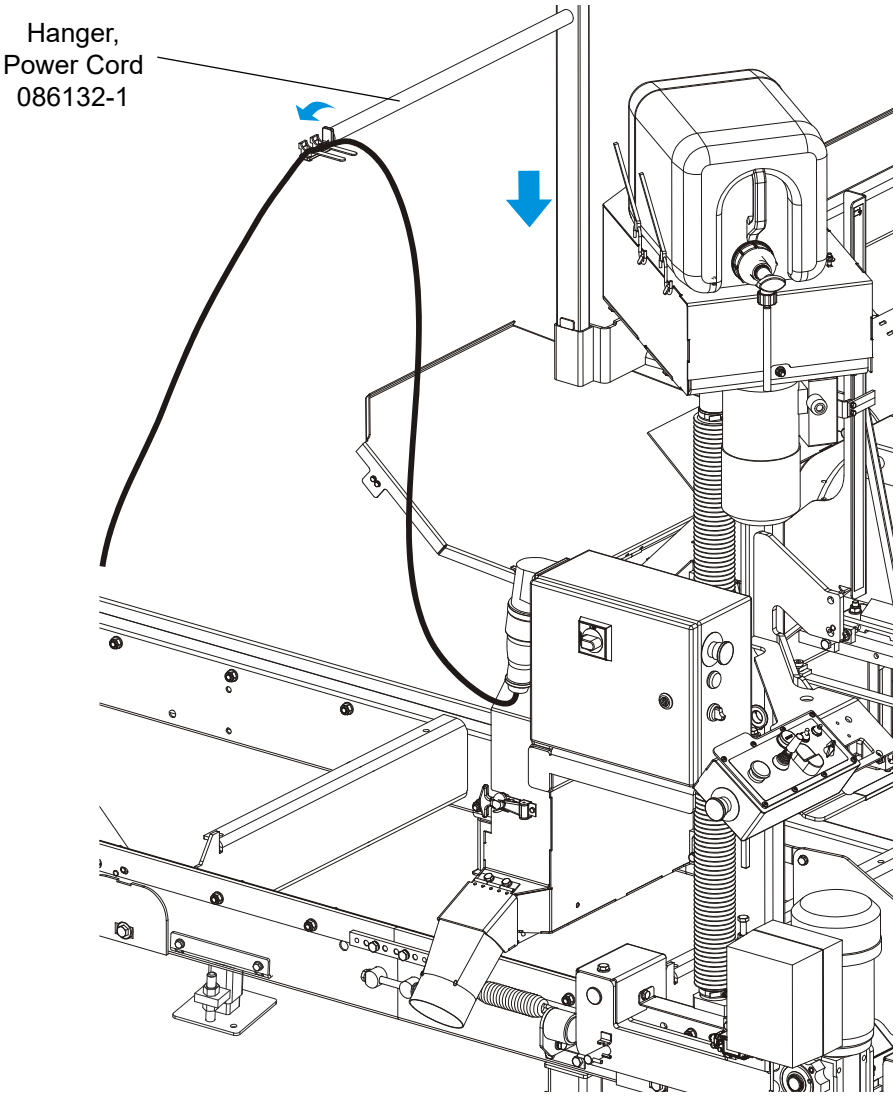


FIG. 2-15

9. Adjust the cam engaging the limit switch as well as the saw head stop bolt, *See Section* , step 3-8.

2.5 Manual Feed Rope Assembly

1. Install a feed rope mounting bracket at each end of the bed assembly using a M10x30 hex head bolts and washers. Either bracket should be angled toward the end of the frame at which it is mounted as shown below.

See figure 2-16.

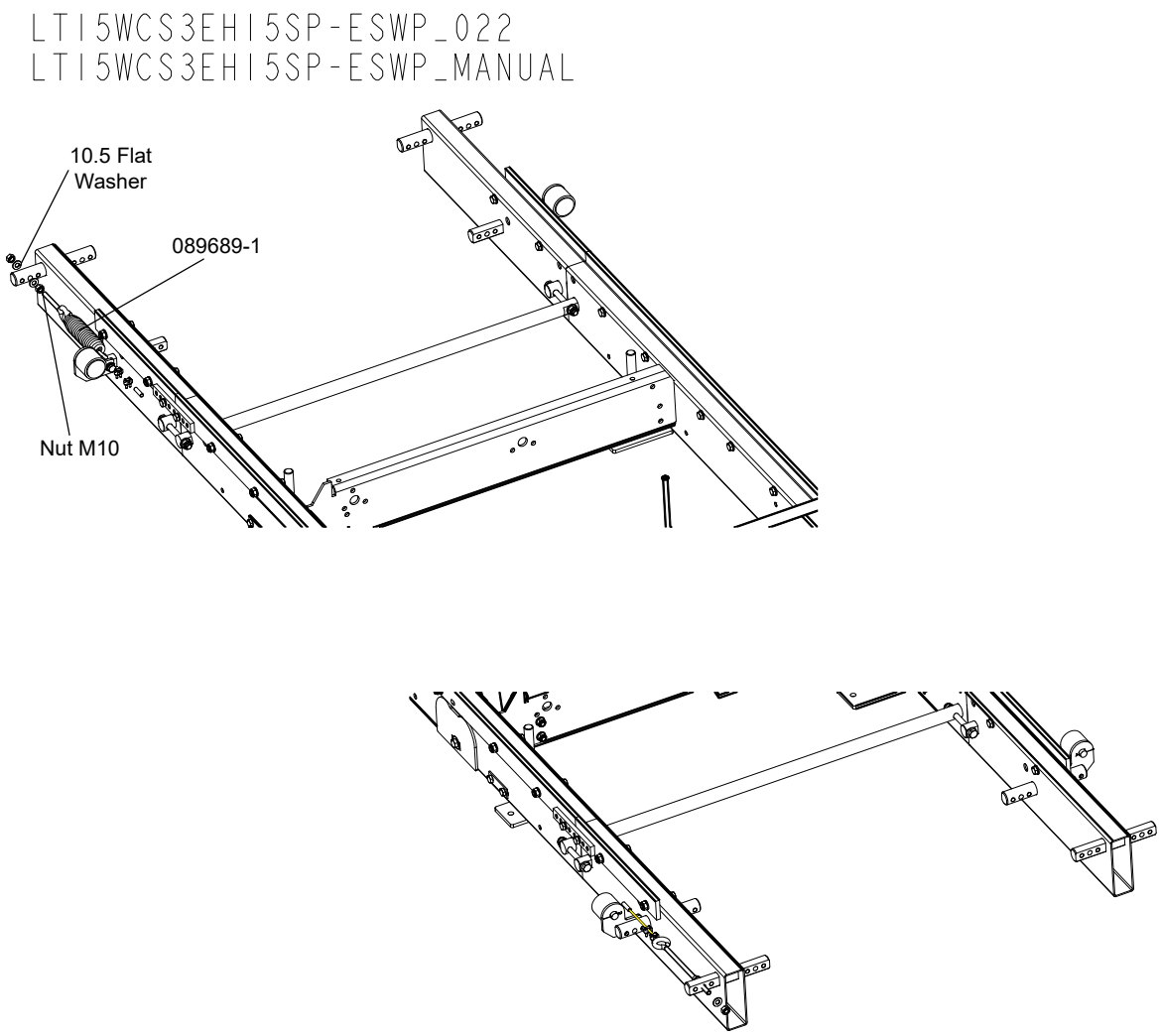


FIG. 2-16

2. Tie a knot in one end of the feed rope. Slip the knotted end of the rope into the front rope mount bracket. Route the rope between the saw head and main bed frame tube.

See figure 2-17.

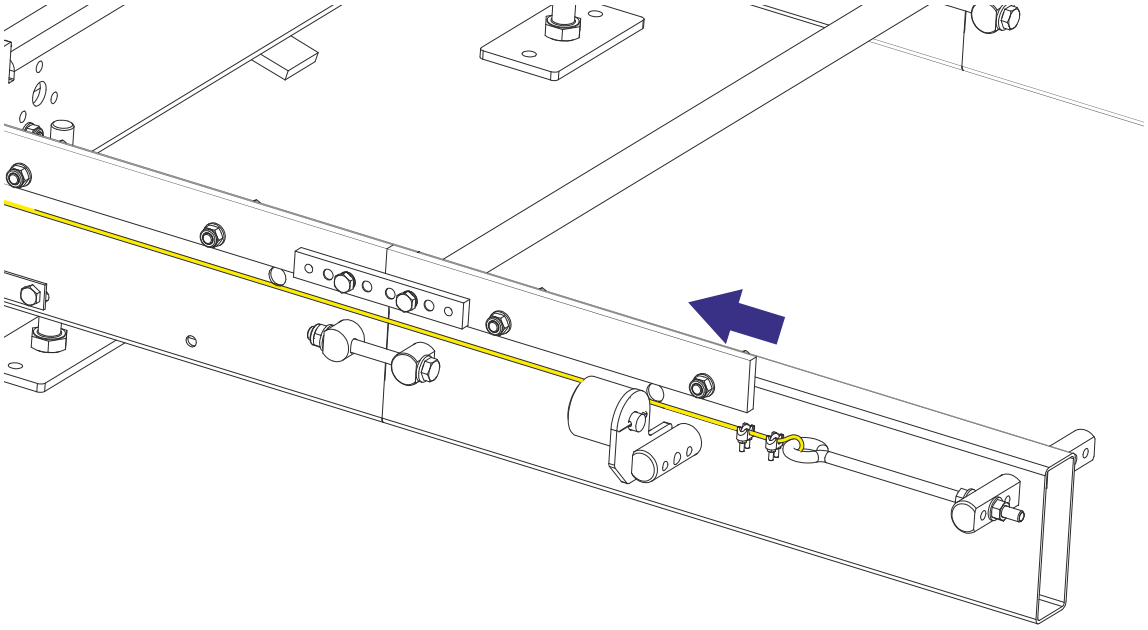


FIG. 2-17

3. Loop the rope around the inner groove of the lower v-groove roller and route to the feed crank spool.

See figure 2-18.

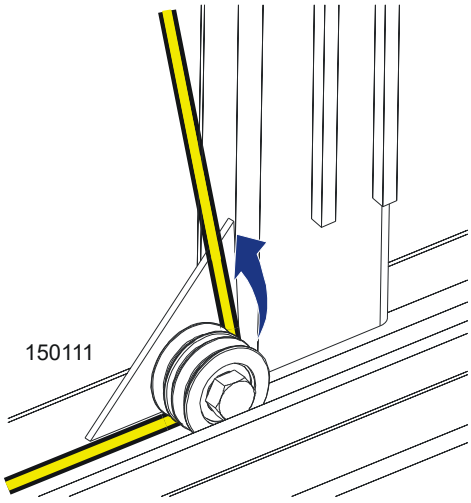


FIG. 2-18

4. Loop the rope around the feed crank spool three times and route back down to the outer v-groove roller.

See figure 2-19.

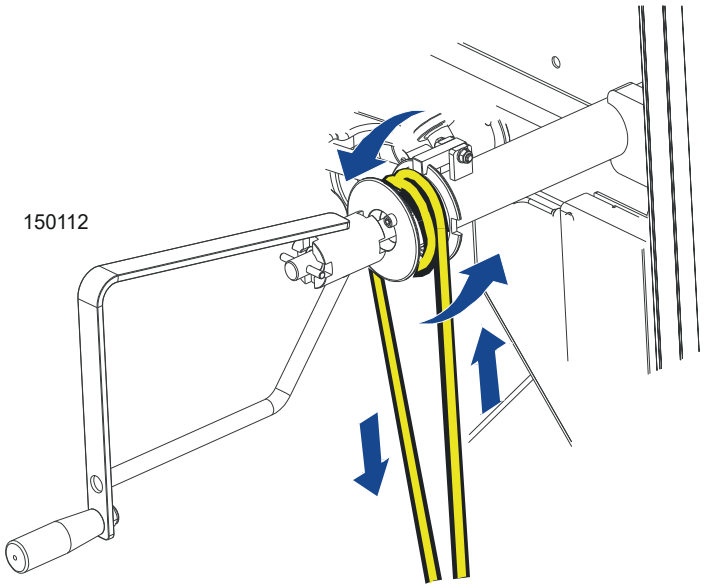


FIG. 2-19

5. Route the rope around the outer groove of the v-groove roller.

See figure 2-20.

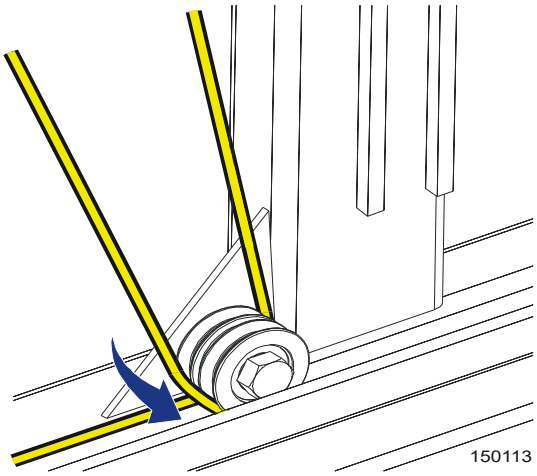


FIG. 2-20

6. Route the rope to the rear mounting bracket. Tie a knot in the end of the rope and insert into the rear mounting bracket. Position the knot in the rope so when installed to the rear bracket, the rope is tight.

See figure 2-21.

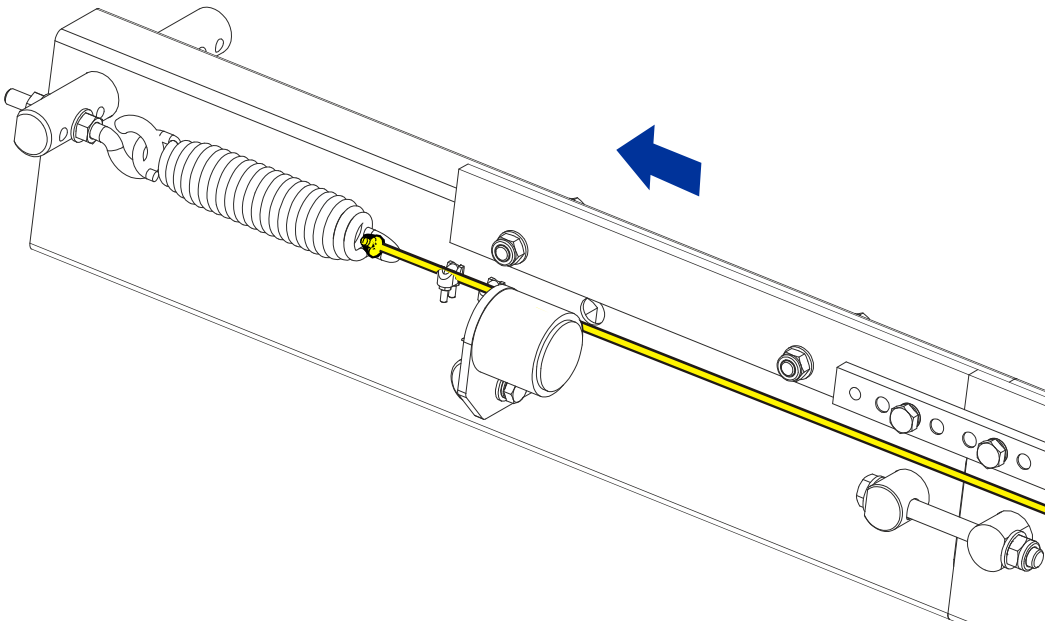
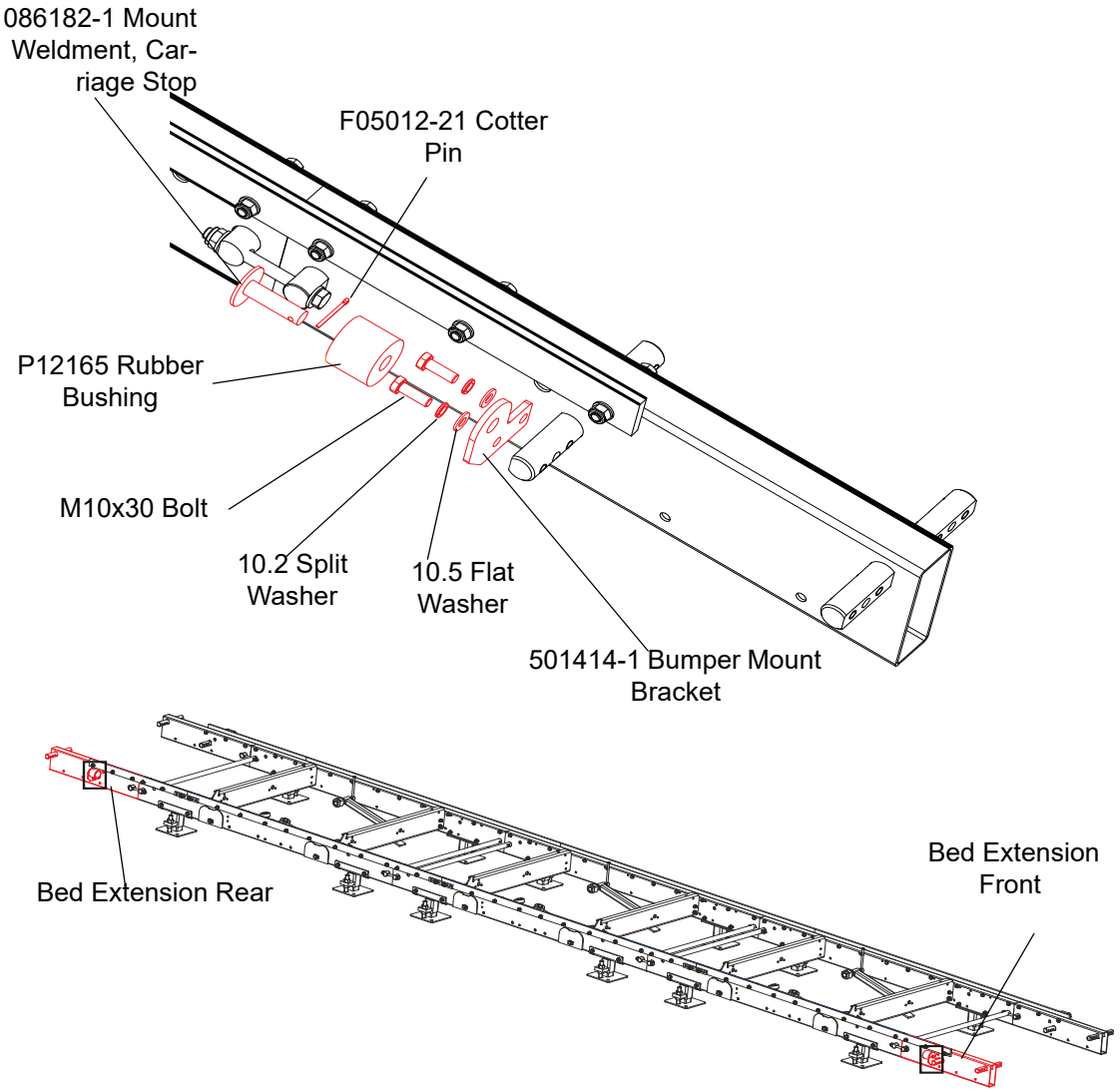


FIG. 2-21

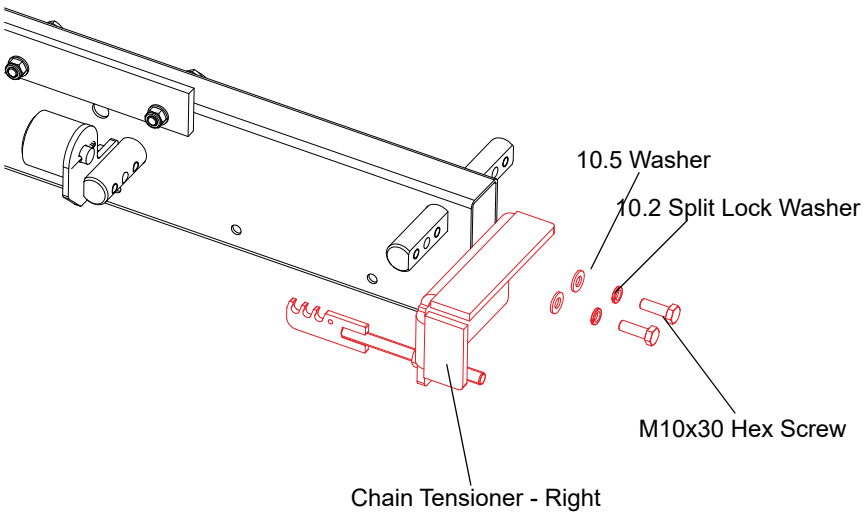
2.6 Power Feed Chain Assembly

1. Before installation of the chain, make sure the power feed motor is properly positioned in relation to the gear box, as shown in the figure below. If not, turn the motor until it is in the operation position. Secure the motor to the gear box with the mounting screws.

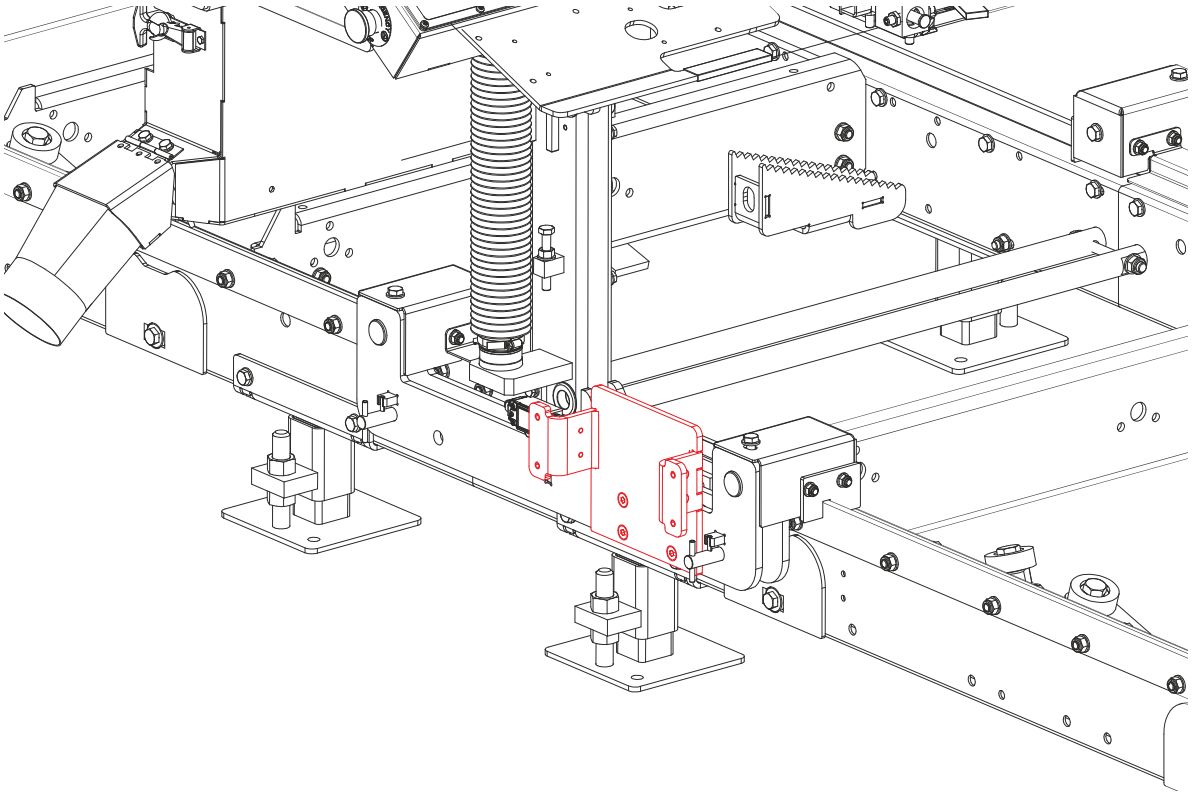
   Mount rubber bumpers with brackets to the bed extensions - See figure below.



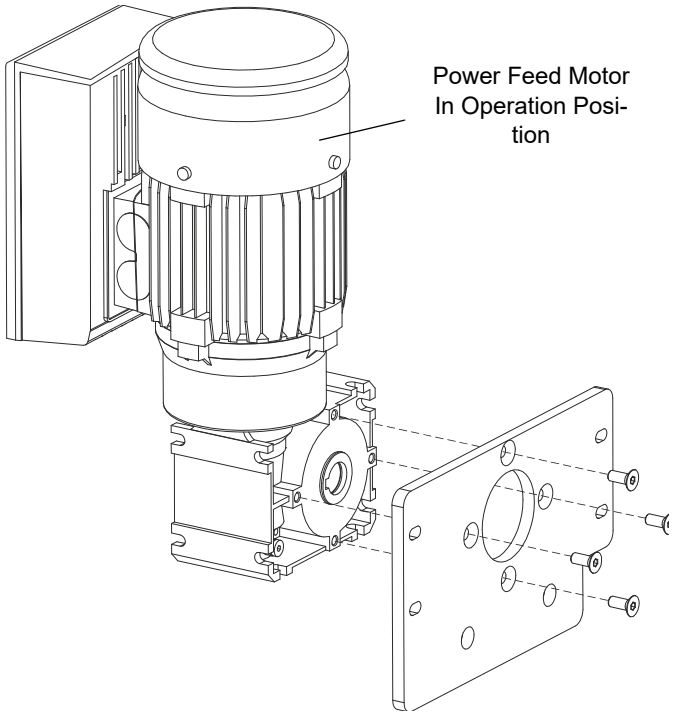
2. Screw 544321 and 544320 elements to the bed frame as shown in the picture.



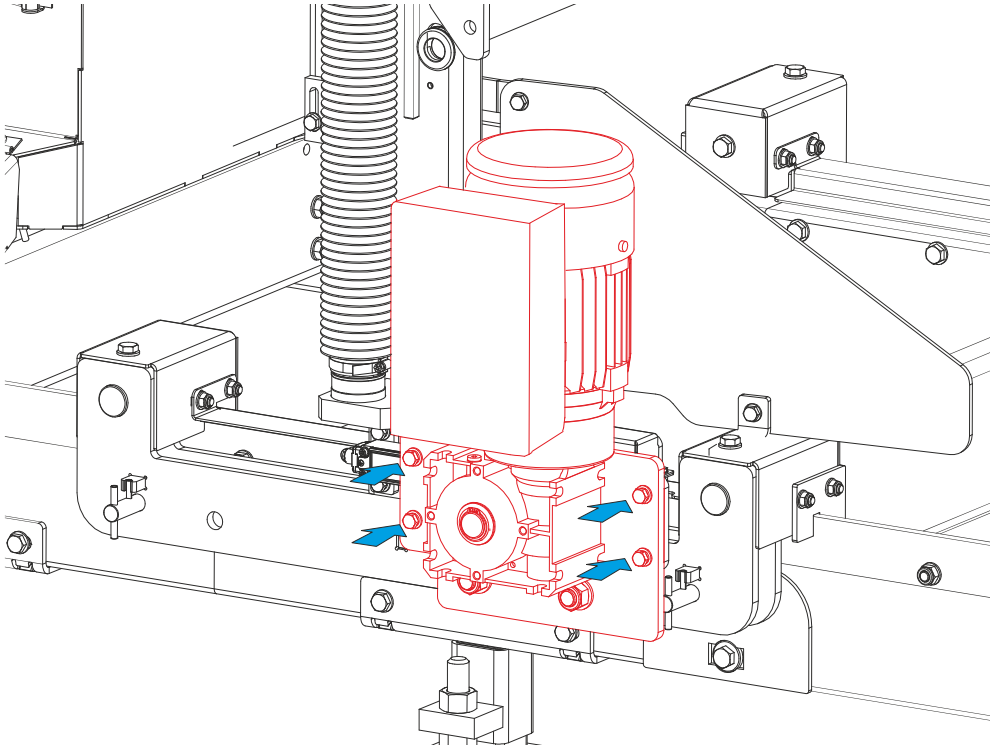
3. Screw the mounting bracket (544313-1) to the bed frame with F81002-141 screws and 556625-1 spacer sleeves.



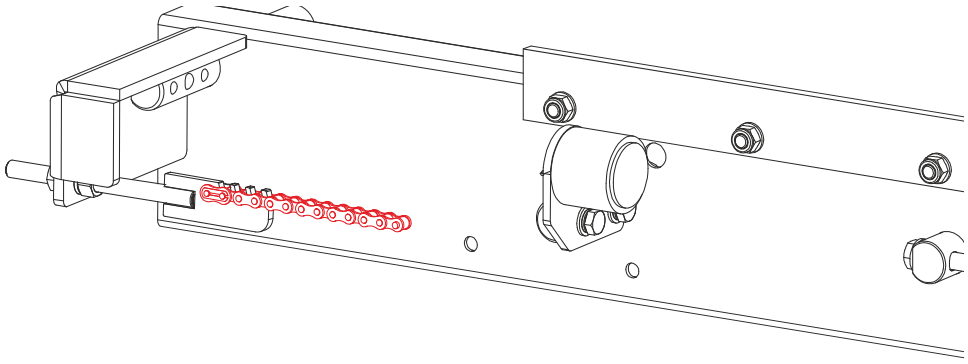
4. Screw 550433-1 plate to the motor.



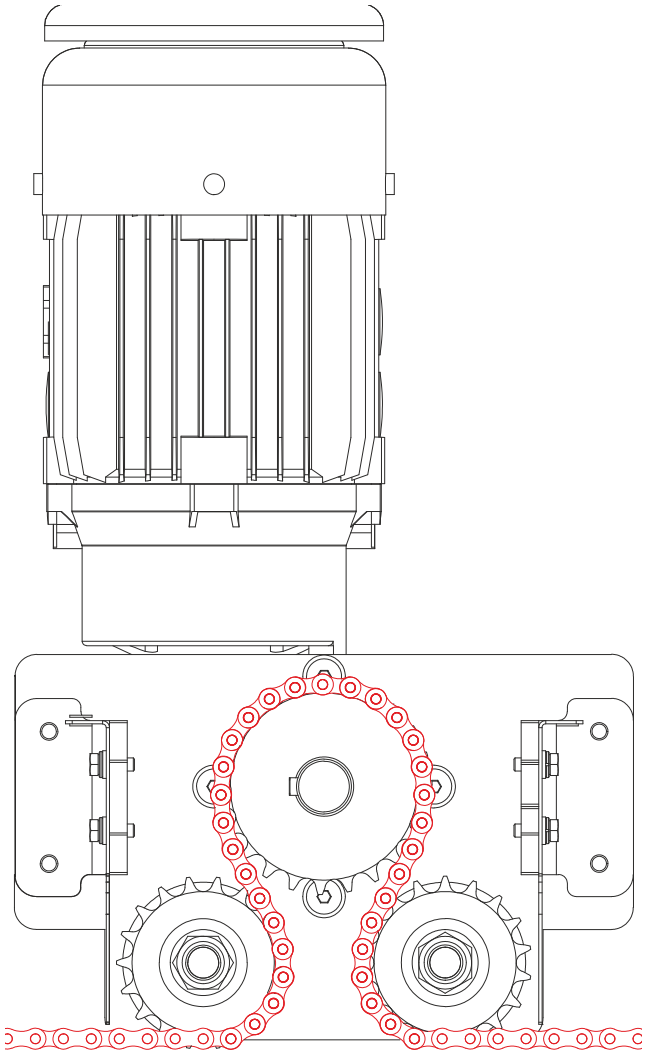
5. Screw the complete assembly to the bed frame with F81002-5 bolts as shown in the figure below.



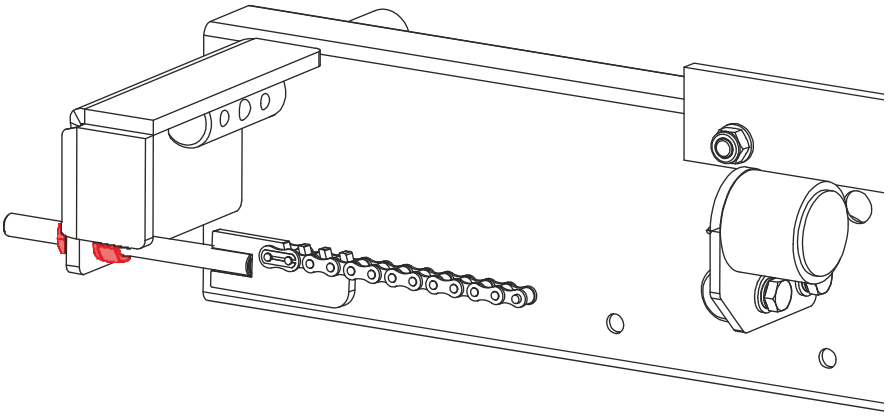
6. Attach the chain at the end of the bed frame as shown in the picture



7. Pass the chain through the sprockets as shown in the figure and attach the chain at the other end of the bed frame.



8. Tighten the chain at both ends with the nuts.



2.7 Auxiliary Bed Rail

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

See figure 2-22.

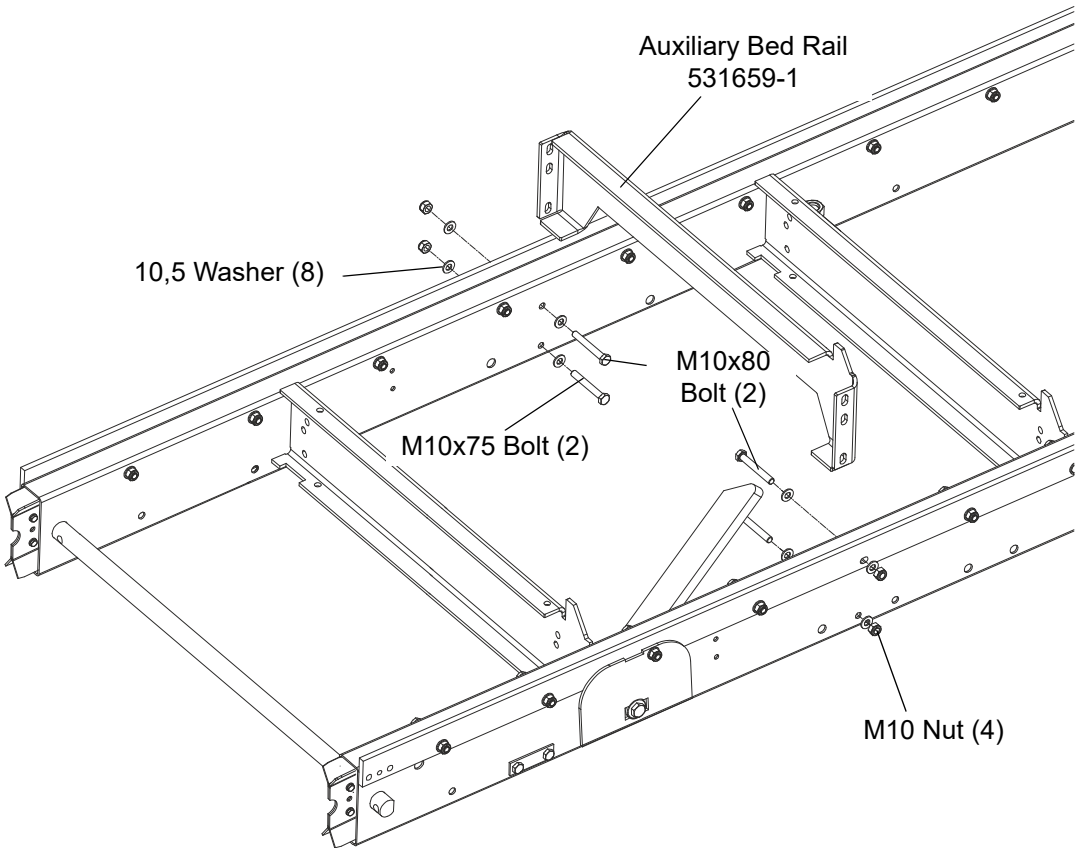
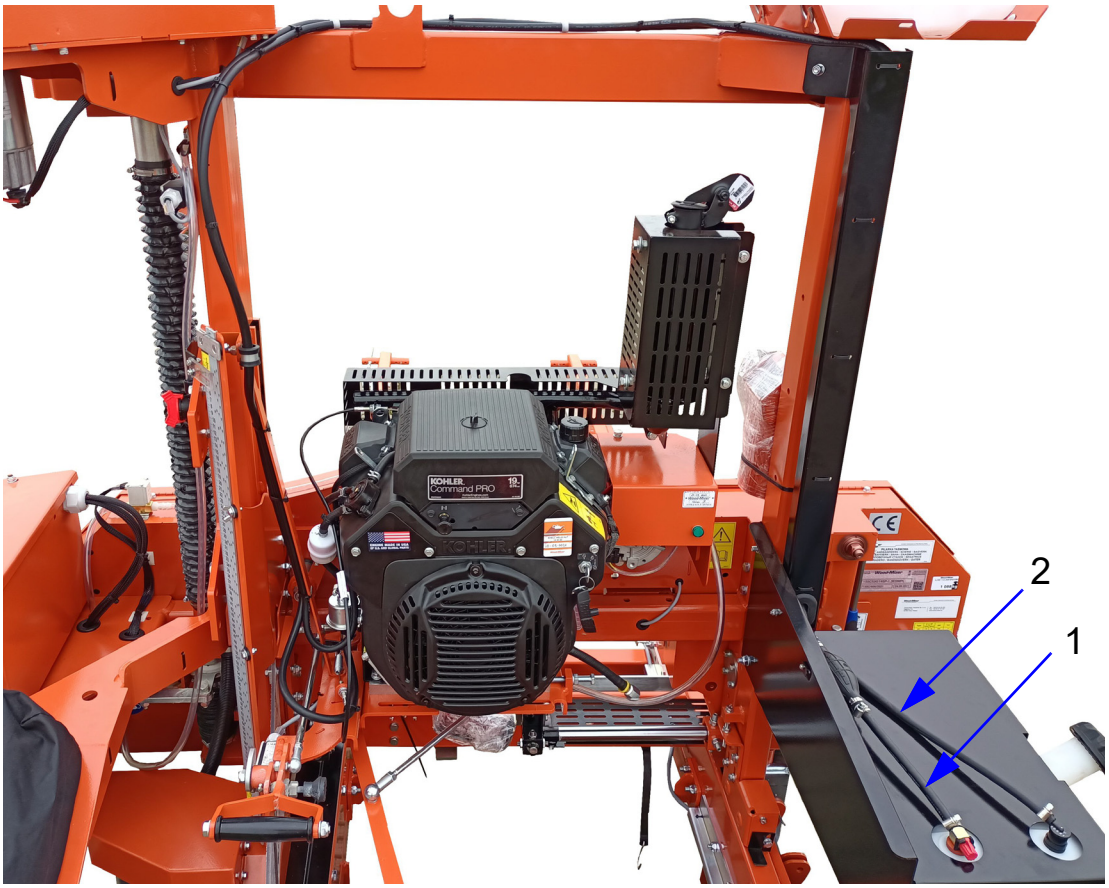


FIG. 2-22

2.8 Installation of the Fuel Hoses

The fuel hoses should be placed on the sawmill mast as shown in the photos below.



SECTION 3 SETUP & OPERATION

3.1 Sawmill Setup

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

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

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

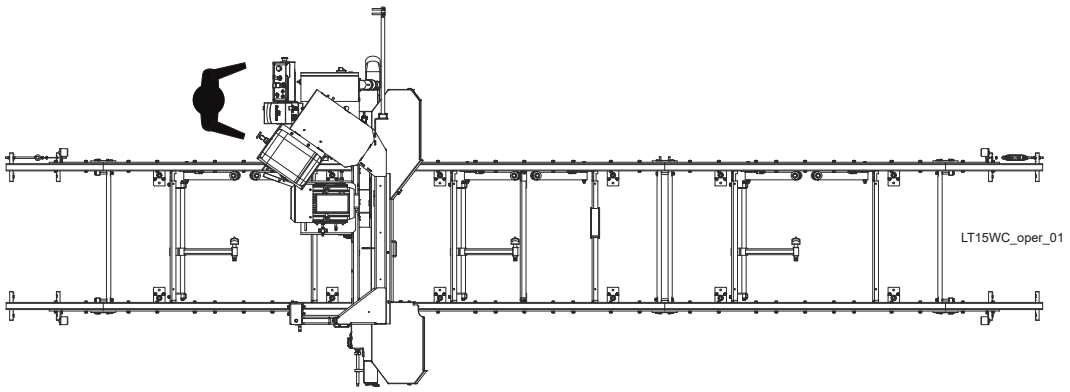
- AC sawmills must not be used outdoors when it is raining or snowing. In such a case, they must be used and stored under roof or indoors.

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

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

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

- The sawmill's operator position is shown below.



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

See table 3-1.

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

TABLE 3-1

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

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

The LT15WC sawmills are only partially aligned at the factory. Some assemblies need to be aligned by the user before first usage of the sawmill.

Assemblies aligned at the factory:

- Blade drive belt tension;
- Engine r.p.m. (DC sawmills only);
- Blade wheels (in vertical and horizontal planes).
- Blade guide arm - *See Section 6.5*;
- Blade guides - *See Section 6.6*;
- Blade height scale - *See Section 6.12*;
- Cam engaging the limit switch and/or stop bolt - *See figure 3-8.*

The following setup procedure should be performed whenever the sawmill is moved or reassembled. If sawing problems occur and misalignment is suspected, *See Section ROZDZIAŁ 6* for complete alignment instructions.

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

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

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

See figure 3-1.

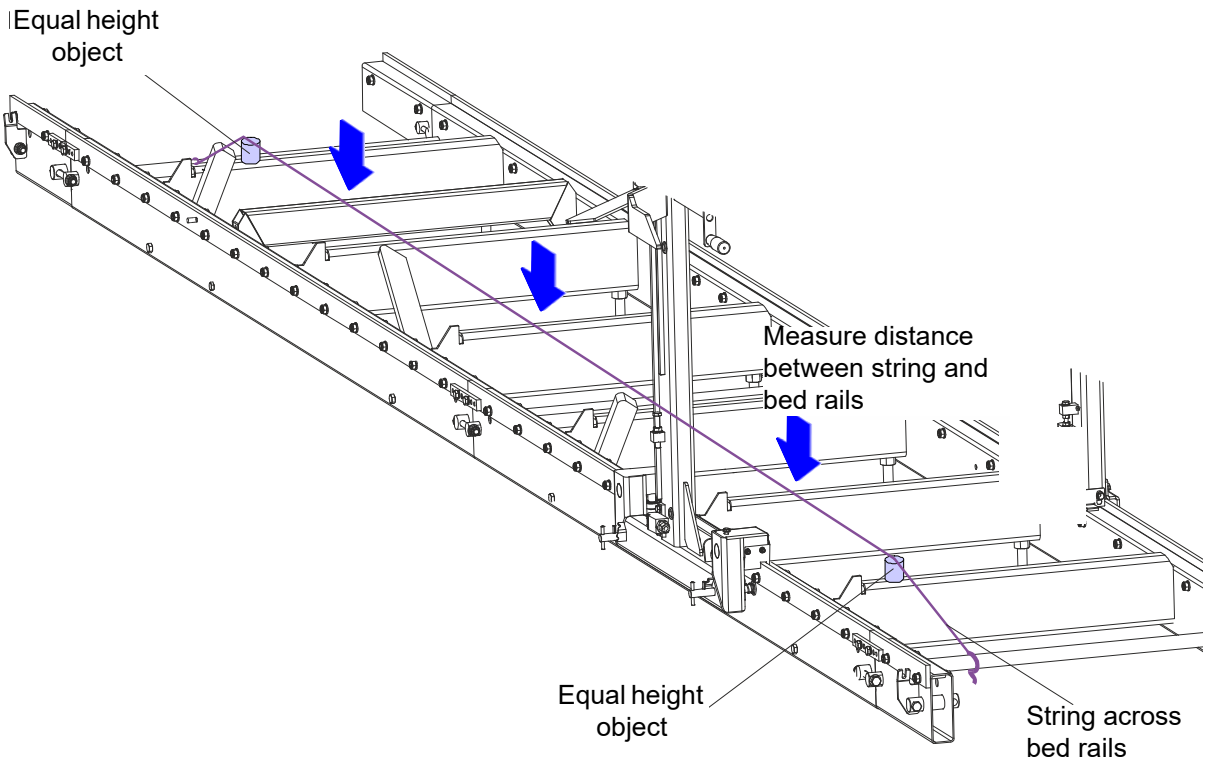


FIG. 3-1

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

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

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

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

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

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

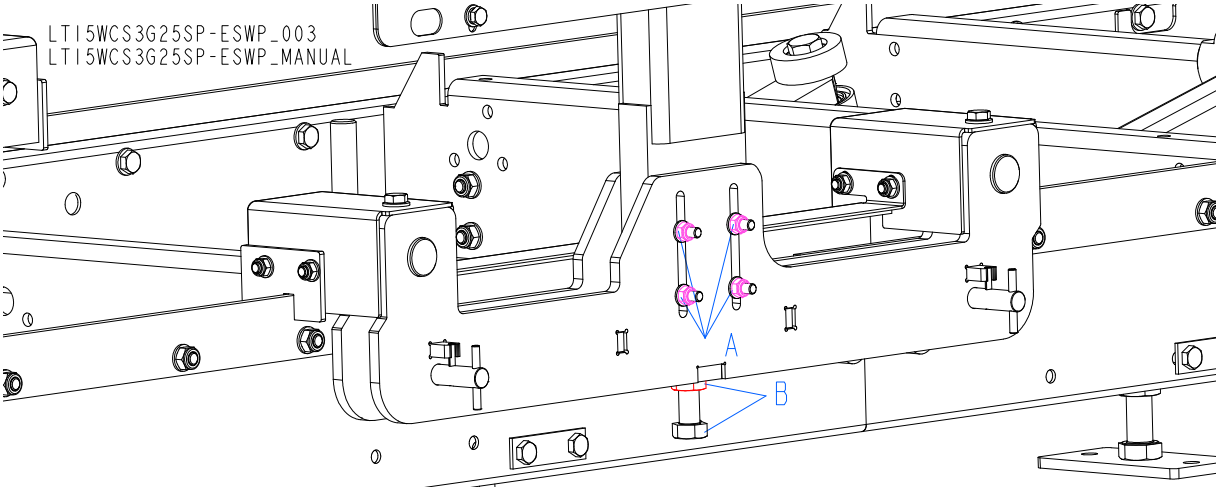


FIG. 3-2

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

See figure 3-3.

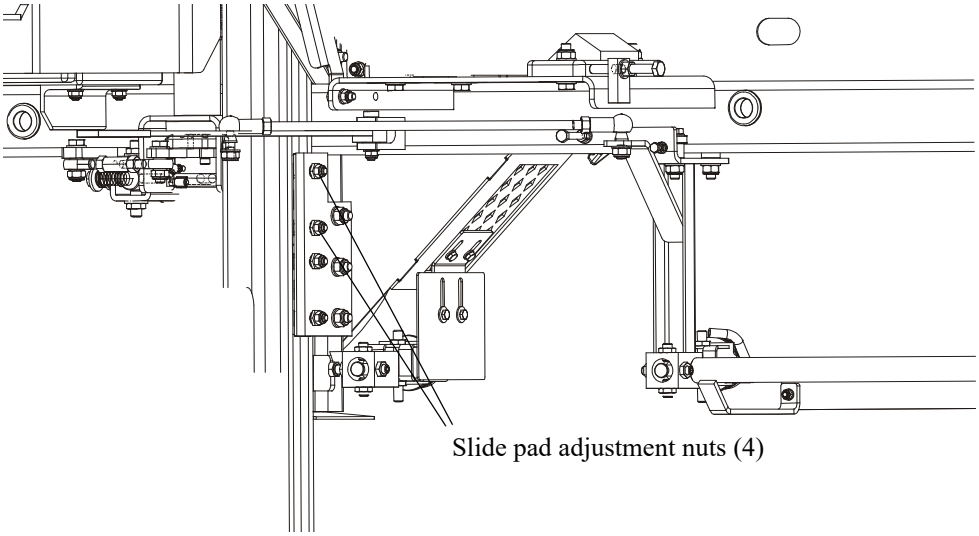


FIG. 3-3

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

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

See figure 3-4.

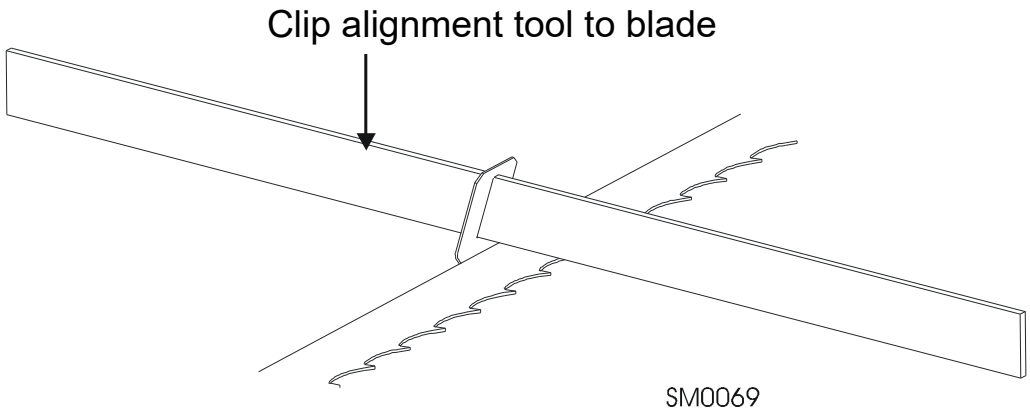


FIG. 3-4

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

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

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

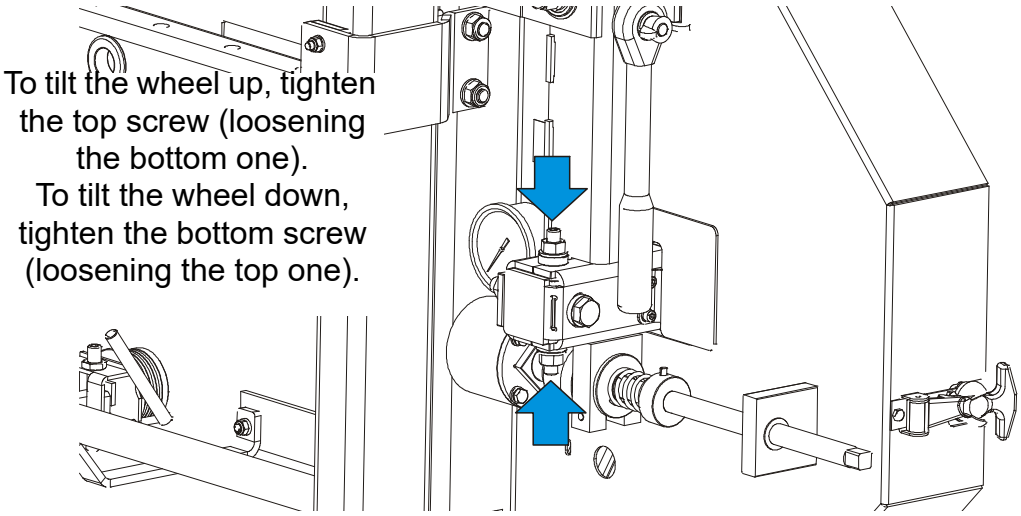


FIG. 3-5

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

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

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

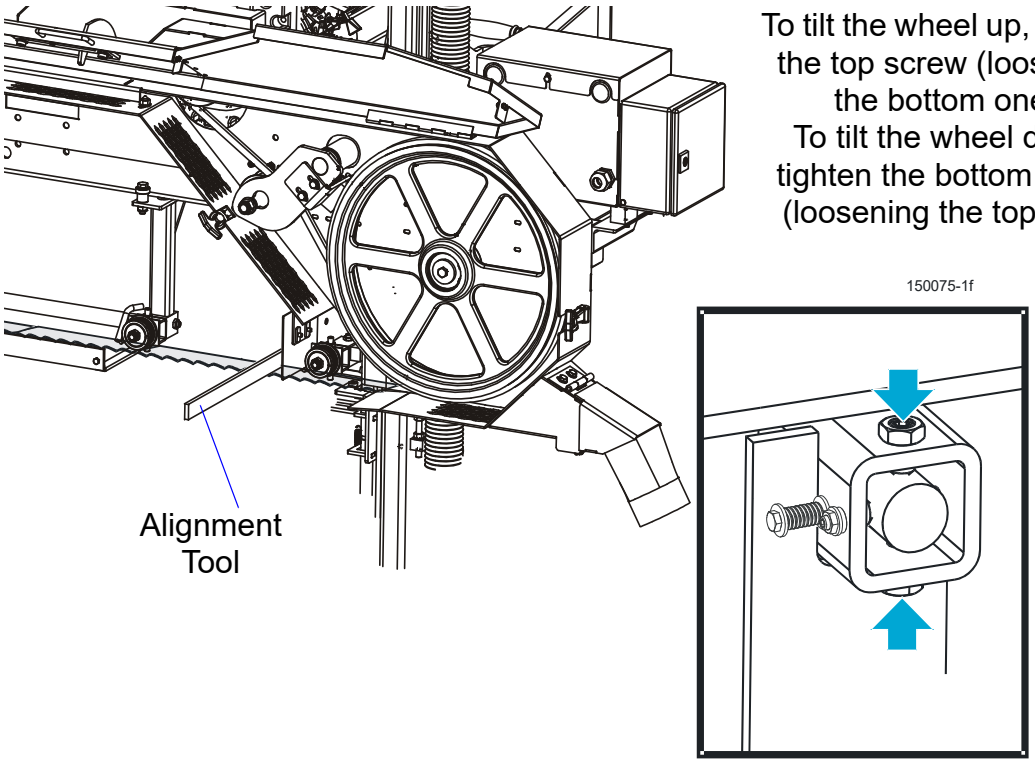


FIG. 3-6

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

11. Adjust the spacing between each blade guide roller flange and the back of the blade. *See Section 6.9*

12. Adjust the horizontal angle of the blade guides. *See Section 6.10*

13. Adjust the blade deflection (*See Section 6.7*) and vertical angle of the blade guides (*See Section 6.8*).

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

14. Install the blade height scale. To do that, first measure the distance from the bottom edge on a down-set set tooth of the blade to the top of the bed rail. Then stick the blade height scale on the mounting bracket so that it indicates the true distance from the blade to the bed. Adjust the scale if necessary. *See Section 6.12*.

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

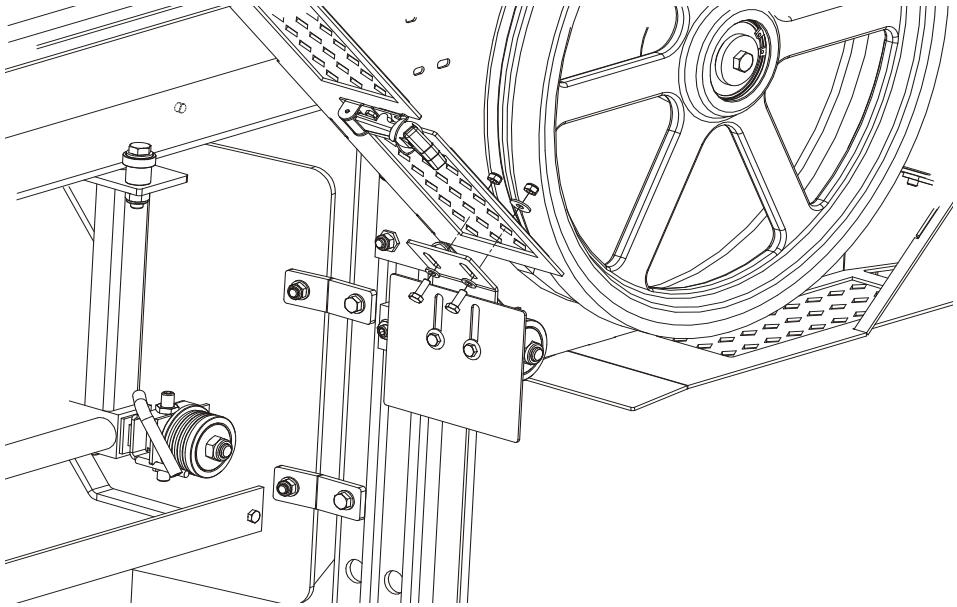
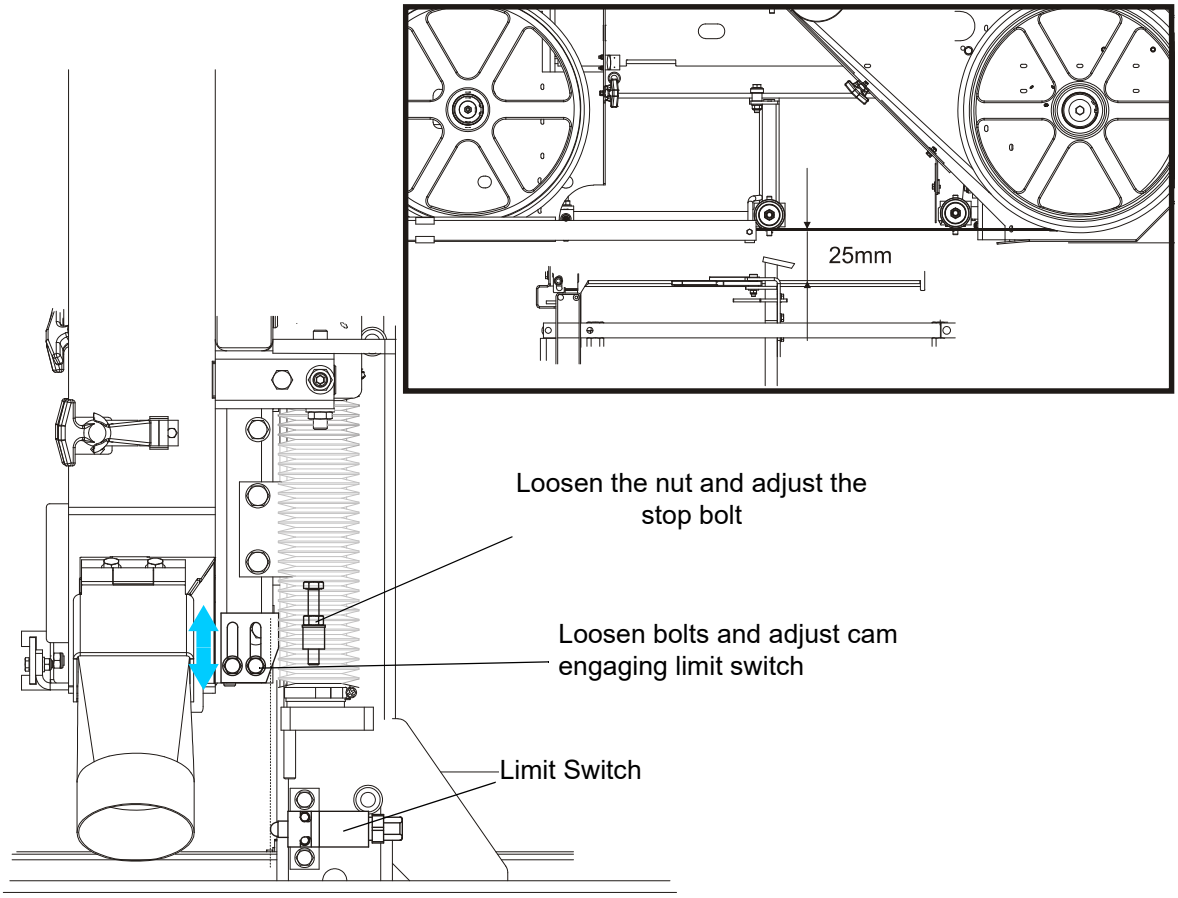


FIG. 3-7

See figure 3-8. Adjust the cam engaging the limit switch as well as the saw head stop bolt so that the saw head stops moving at its lower travel limit - at the height of 25 mm above the bed.

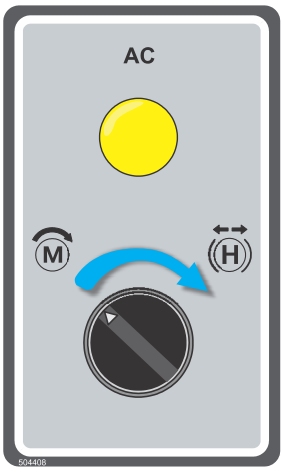


3.2 Replacing The Blade

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

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

IMPORTANT! Turn the knob to the left to manually release the motor brake. Spin the blade wheels after installing the new blade to make sure the blade is installed correctly.



Adjust the blade guide arm all the way open.

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

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

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

Close the blade housing cover.

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

3.3 Tensioning The Blade

See figure 3-9. Tension the blade by turning the tensioner handle clockwise until the tension gauge indicates the recommended tension. Check the blade tension occasionally when adjusting

the cant control or while cutting. As the blade and belts heat up and stretch, the blade tension will change. Also, ambient temperature changes can cause tension to change.

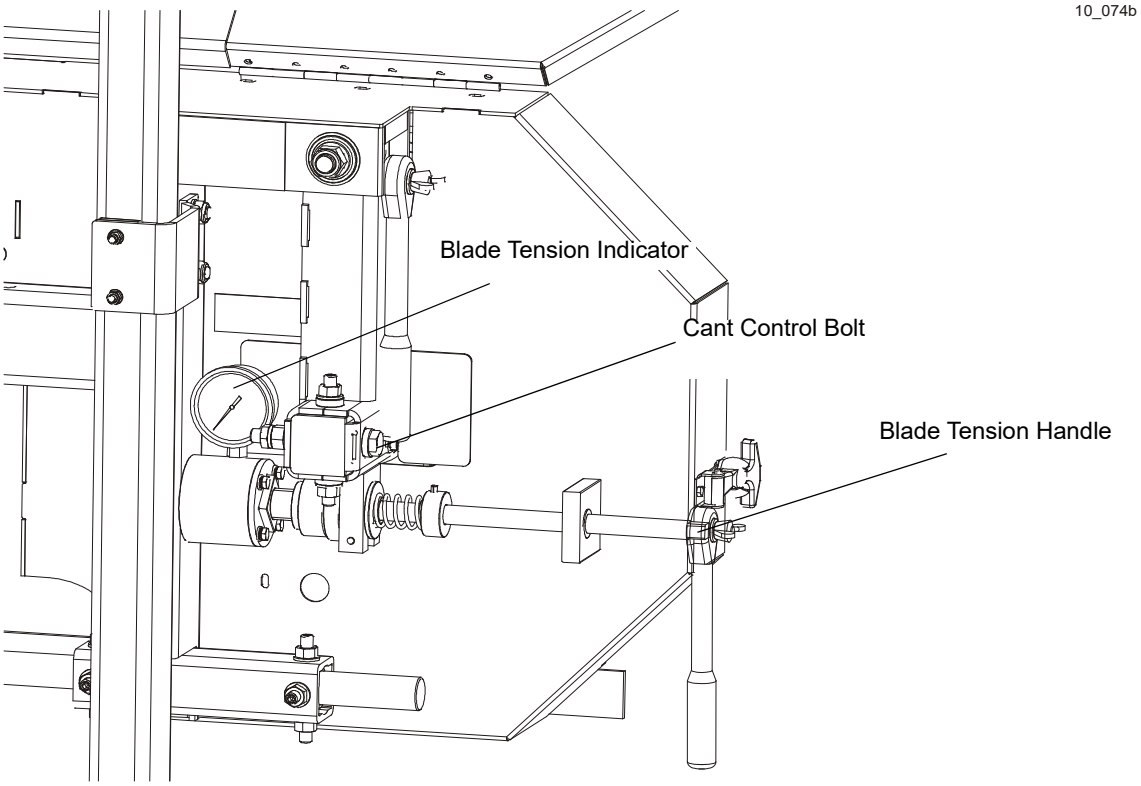


FIG. 3-9

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

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

TABLE 3-2

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

3.4 Tracking The Blade

1. Make sure the blade housing cover is closed and all persons are clean of the blade.
2. Start the motor for a moment until the blade positions itself on the wheels.

WARNING! Do not spin the blade wheels by hand. Spinning the

blade wheels by hand may result in serious injury.

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

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

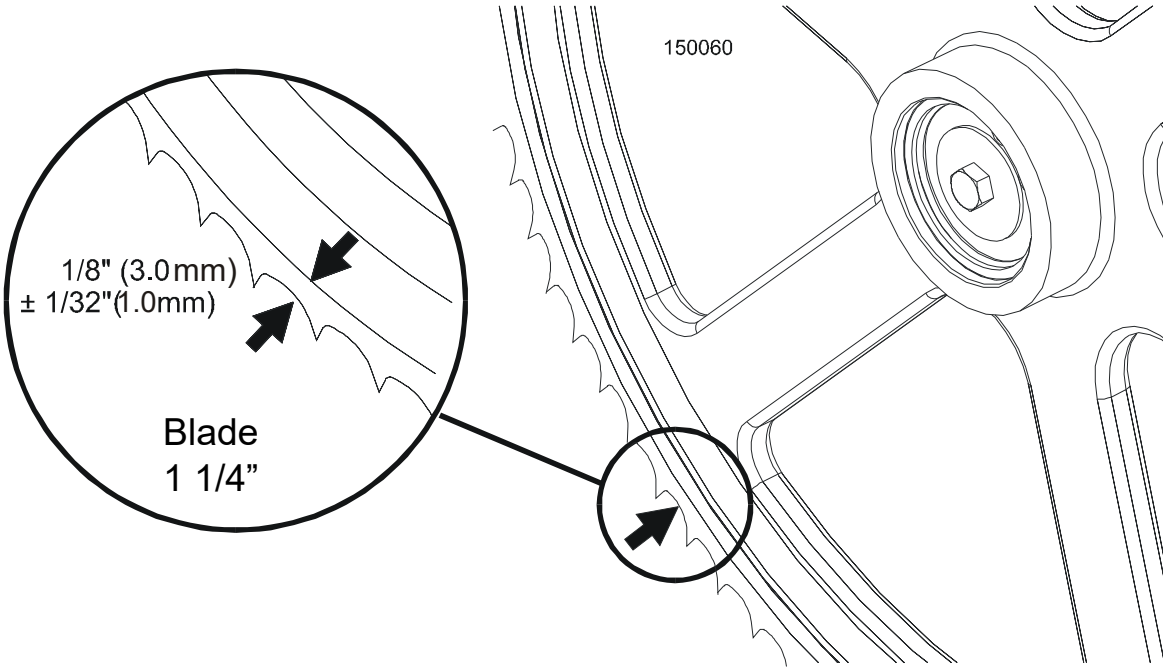


FIG. 3-10

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

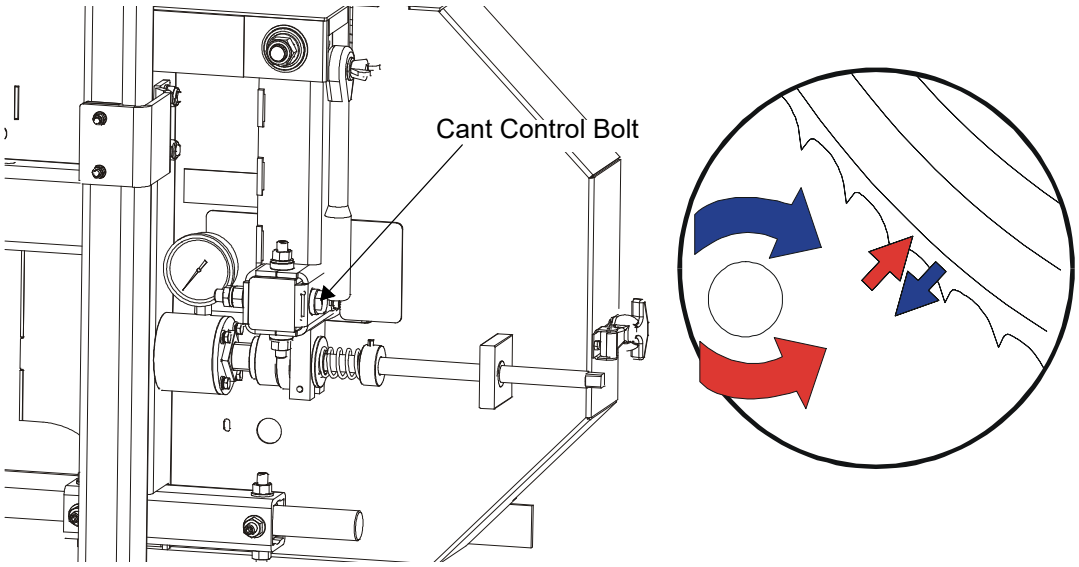


FIG. 3-11

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

from the front edge of the wheel.

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

5. Close the blade housing cover.

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

IMPORTANT! After aligning the blade on the wheels, always double-check the blade guide spacing and location. (*See Section 6* for more information.)

3.5 Starting the Engine/Motor

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

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

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

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

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

3.6 Loading, Turning and Clamping Logs

To load a log:

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

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

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

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

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

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

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

6. Remove the log ramps and set aside.

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

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

To turn logs:

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

To clamp a log:

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

See figure 3-12.

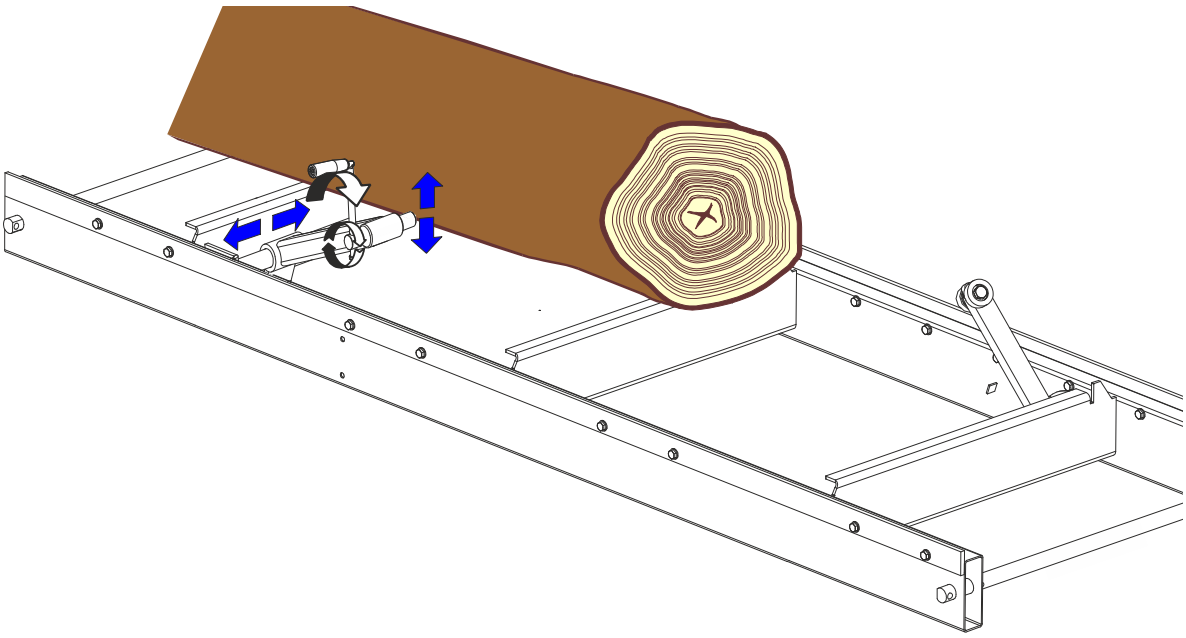


FIG. 3-12

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

   See figure 3-13.

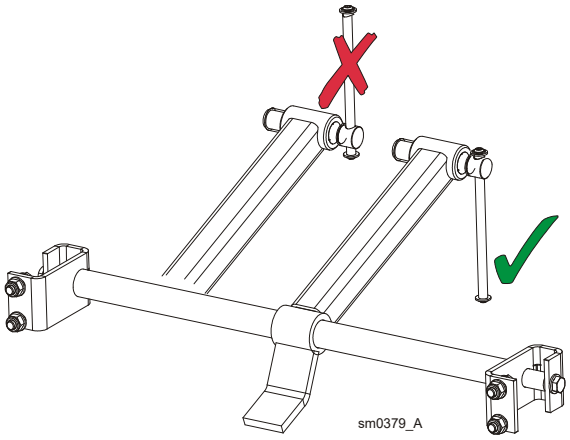


FIG. 3-13

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

To level a log:

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

See figure 3-14. .

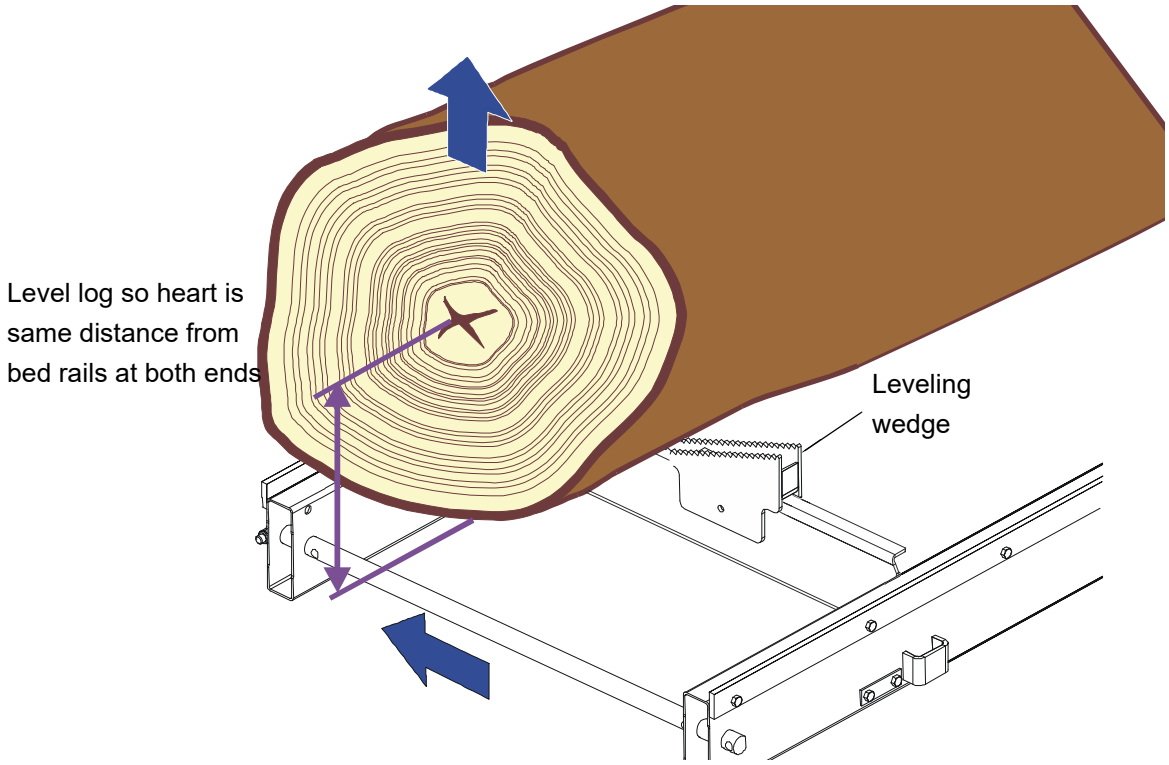


FIG. 3-14

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

See figure 3-15. .

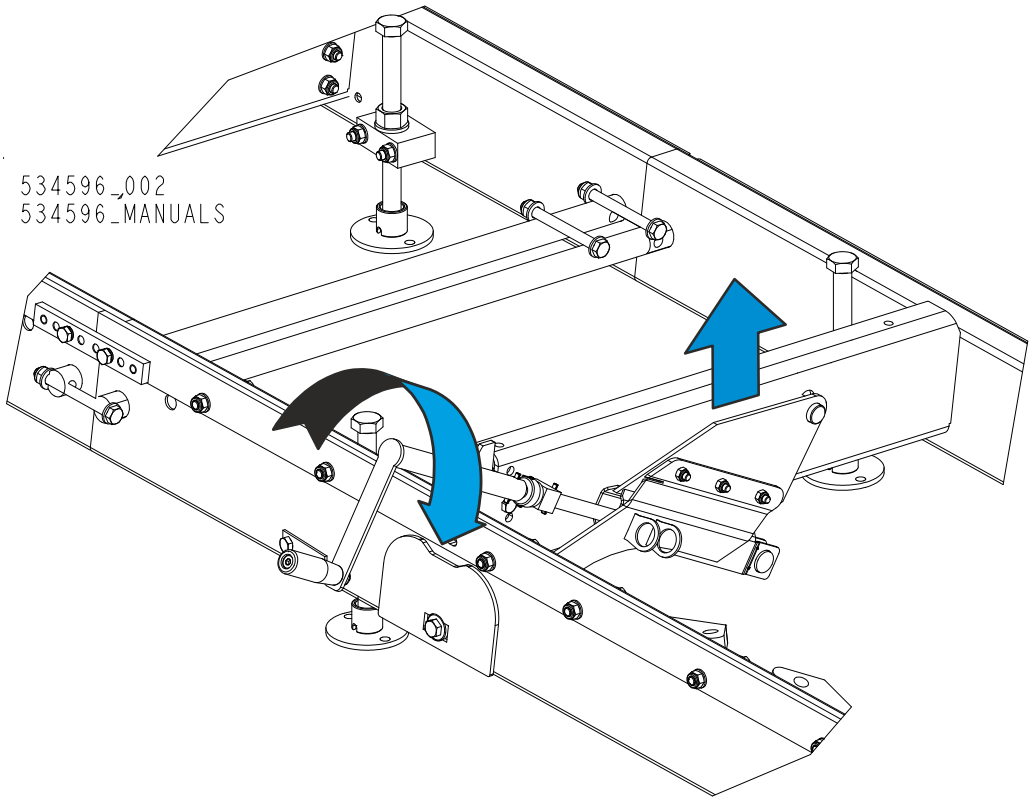


FIG. 3-15

3.7 Up/Down Operation

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

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

See figure 3-16. Use the up/down button (on the control panel) shown below to raise or lower the saw head.

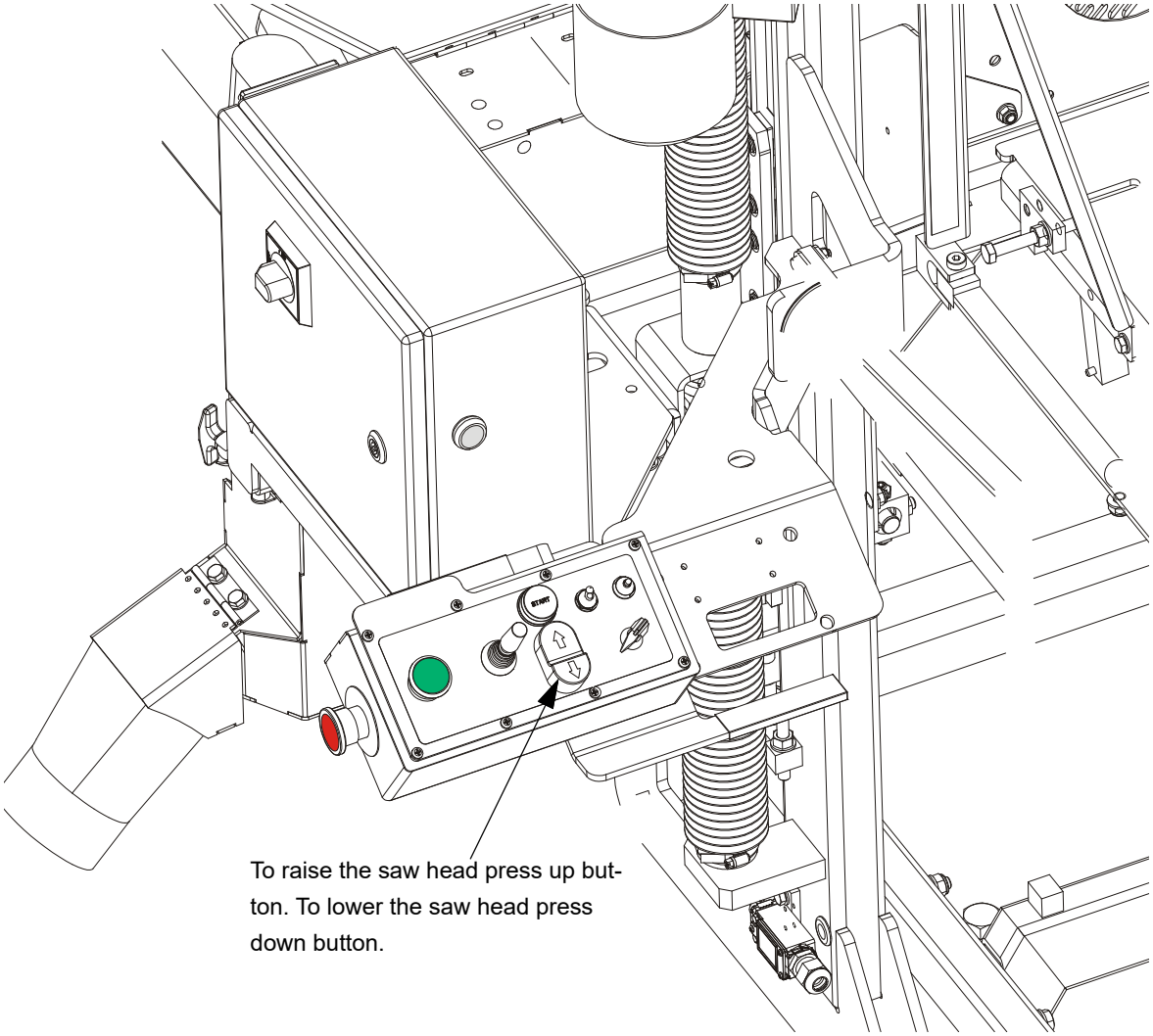


FIG. 3-16

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

3.8 Blade Guide Arm Operation

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

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

See figure 3-17.

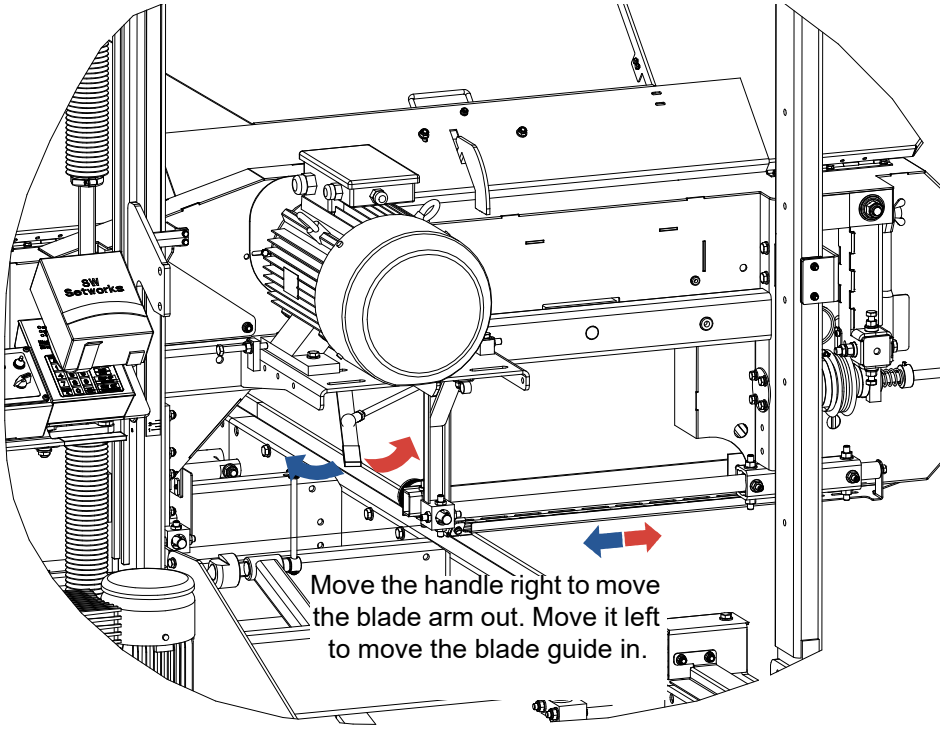


FIG. 3-17

3.9 Blade Drive Operation

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

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

For Sawmills with the Electric Motor

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

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

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

- Press AND HOLD the green safety button on the control box.

NOTE: Keep the safety button pressed all the time the blade is driven. If the safety button is released, the motor stops and it needs to be restarted.

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

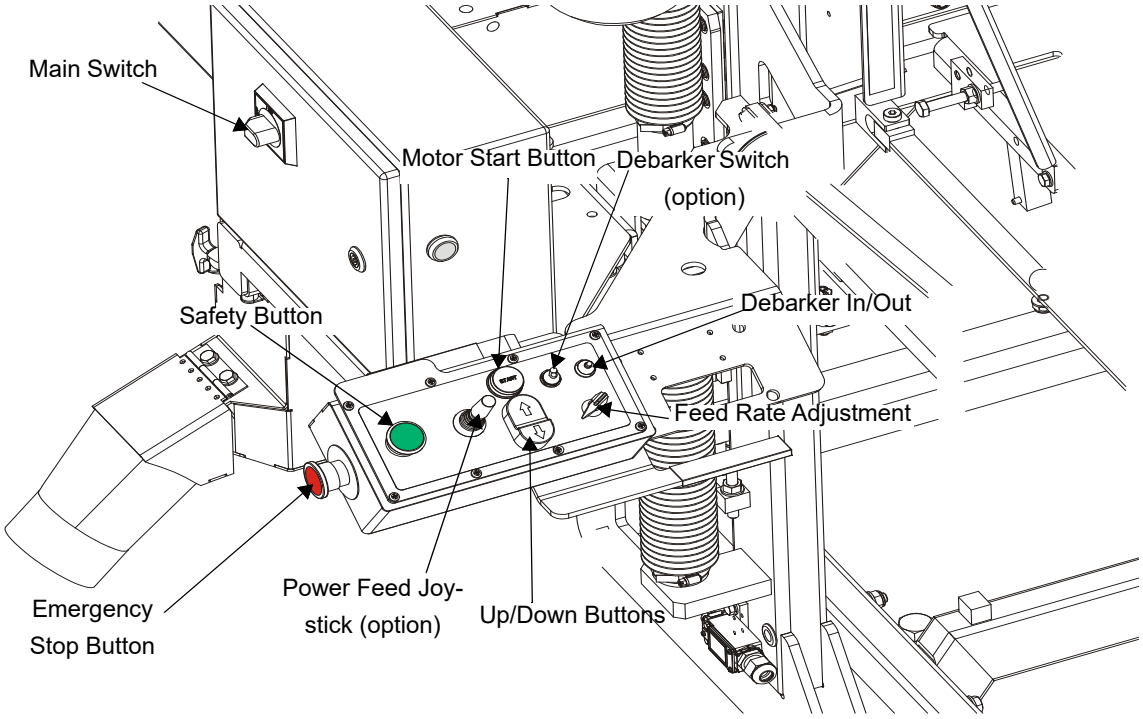


FIG. 3-18

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

Gas Engine Only

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

See figure 3-19. The tensioner handle is located next to the engine. To engage the blade, push the clutch handle forward.

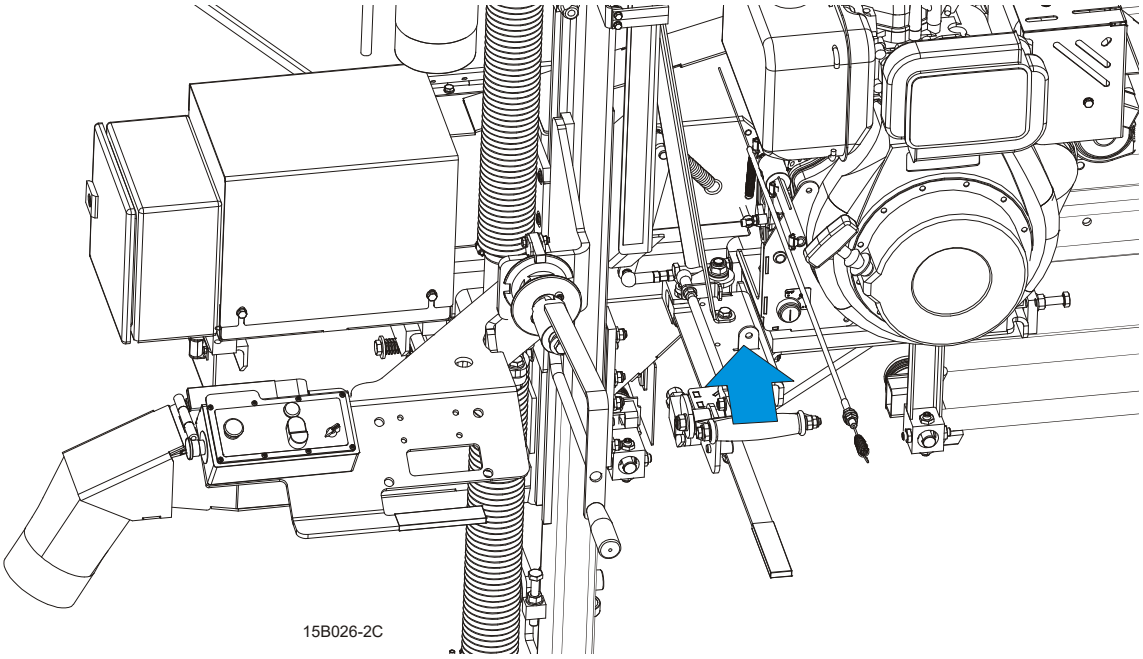


FIG. 3-19

4. To engage the blade, press the safety switch with your left hand and hold it down. Then push the tensioner handle forward until it locks in upper position. This engages the drive mechanism and increases the engine speed to full throttle. Keep the safety switch pressed all the time the tensioner is engaged and the blade is driven in order to prevent the sawmill operator from getting to the path of the blade. If the safety switch is released the engine stops and it needs to be restarted.

5. To disengage the blade, pull the tensioner handle. This disengages the drive belt and returns the engine to idle.

3.10 Feed Operation

3.10.1 Standard Manual Feed System

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

1. To move the saw head forward, push the crank handle in to engage the screw heads and rotate the feed crank clockwise.

See figure 3-20.

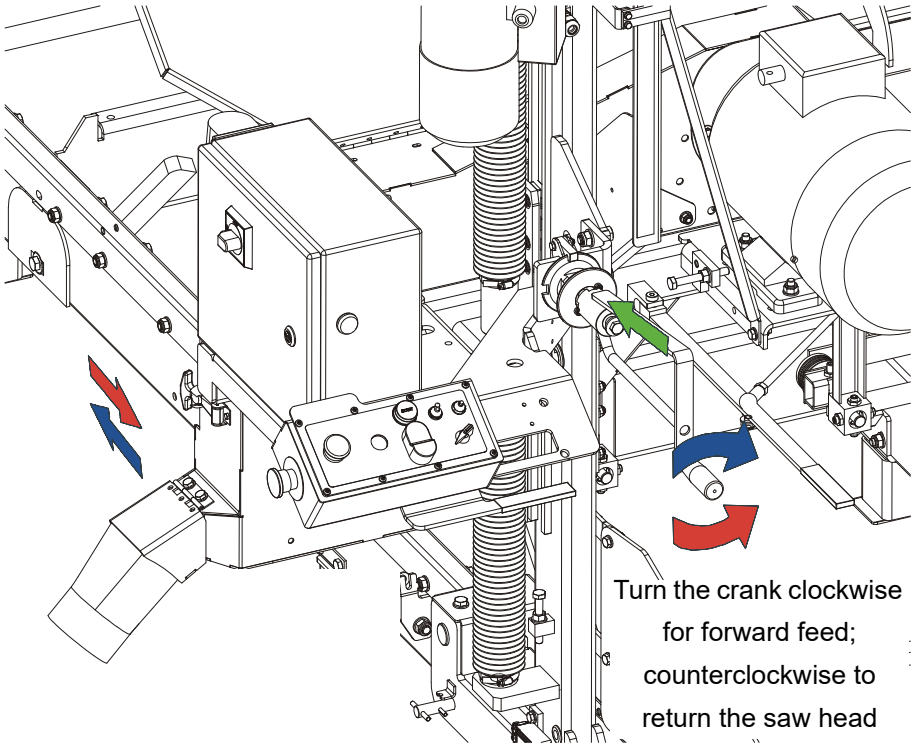


FIG. 3-20

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

2. To move the cutting head backward, rotate the feed crank counterclockwise, or pull the saw head back. Always disengage the blade before returning the cutting head and raise the head slightly to make sure the blade clears the log.

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

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

HINT: You can also move the cutting head by hand, using the brackets on the control box. When the manual feed is used it is not necessary to install the feed crank, rope, v-groove rollers and rope mounting brackets.

3.10.2 Optional Electric Feed System

The power feed system includes an electric motor with gear which moves the saw head using a steel strand. The speed at which the saw head travels forward is adjusted by the feed rate switch.

See figure 3-21.

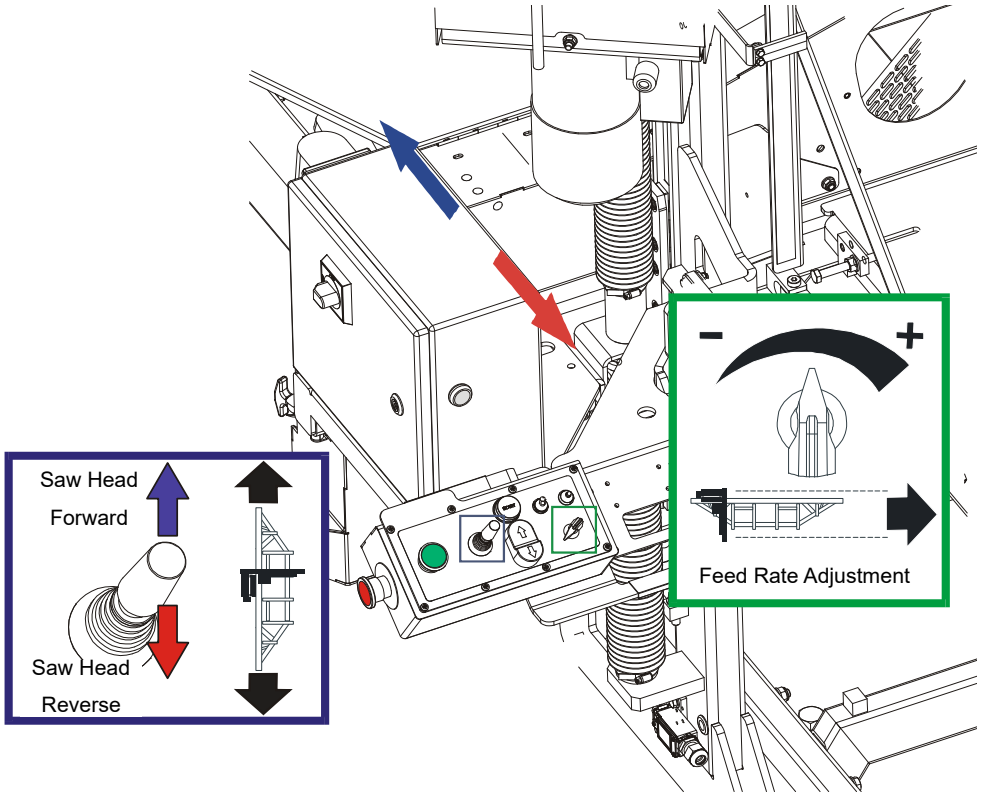
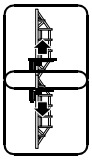


FIG. 3-21

Saw Head Feed Rate

The saw head feed rate switch controls the speed at which the saw head travels forward. Turn the switch clockwise to increase speed. Turn it counterclockwise to reduce speed. Reverse feed speed is constant.

Saw Head Forward and Reverse



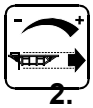
The saw head forward/reverse switch controls the direction in which the saw head travels. Turn the switch upward to move the saw head forward. Turn the switch down to move the saw head backward.

NOTE: Always disengage the blade before returning the saw head and raise the saw head slightly to make sure the blade clears the log.

Feed Rate

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

1. Stop the saw head at the end of the cut by turning the saw head feed rate switch counterclockwise until the saw head stops moving.



2. Using the STOP button, disengage the blade. This will stop the blade. Remove the board from the log.

3.11 Cutting The Log

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

1. Once the log is placed where you want it and clamp firmly, position the blade close to the end of the log.
2. Use the blade height scale to determine where to make your first cut. (*See Section 3.13*) Set the blade to the desired height with the up/down buttons. Make sure that the blade will clear all side supports and clamps. Adjust the outer blade guide properly (See Section 3.8)
3. Make sure all covers and guards are in place and secured. Start the motor.
4. Start the water lube if necessary to prevent sap building on the blade (*See Section 3.14*).
5. Feed the blade into the log slowly (*See Section 3.10*). Once the blade completely enters the log, increase the feed rate as desired. Always try to cut at the fastest speed you can while keeping an accurate cut. Cutting too slowly will waste blade life and lower production.
6. As you get to the end of the log, slow down the feed rate. When the teeth exit the end of the log, release the emergency stop button on the control box. Remove the slab that you have just cut from the log.
7. Use the feed crank to return the cutting head to the front of the mill. Always disengage the blade before returning the saw head for the next cut.
8. Repeat until the first side of the log is cut as desired. Set aside the usable flitches (boards with bark on one or both sides). You can edge them on the mill later.
9. Remove the leveling wedge if it was used. Release the clamps and turn the log 90 or 180 degrees. Make sure the flat side of the log is placed against the side supports if the log was turned 90 degrees. If the log was turned 180 degrees, its flat side should rest on the bed rails. If the log was turned 90 degrees and it is necessary to level it on the bed, follow the leveling instructions described in Section 3.6.
10. Repeat the steps used to cut the first side of the log until the log is square. Then cut boards from the cant.

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

3.12 Edging

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

1. Raise the side supports to 1/2 the height of the boards that need to be edged.
2. Stack these boards on edges against the side supports.
3. Clamp the boards against the side supports halfway up the board height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other boards or without having to pull them from the middle of the stack.)
4. Adjust the blade height to edge a few of the widest boards.
5. Loosen the clamps and turn the edged boards over to edge the other side.
6. Repeat steps 2-4.
7. Loosen the clamps and remove the boards that have good clean edges on both sides. Clamp the remaining boards and repeat steps 2-5.

3.13 Blade Height Scale

See figure 3-22. The blade height scale is mounted on the vertical mast. It includes:

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

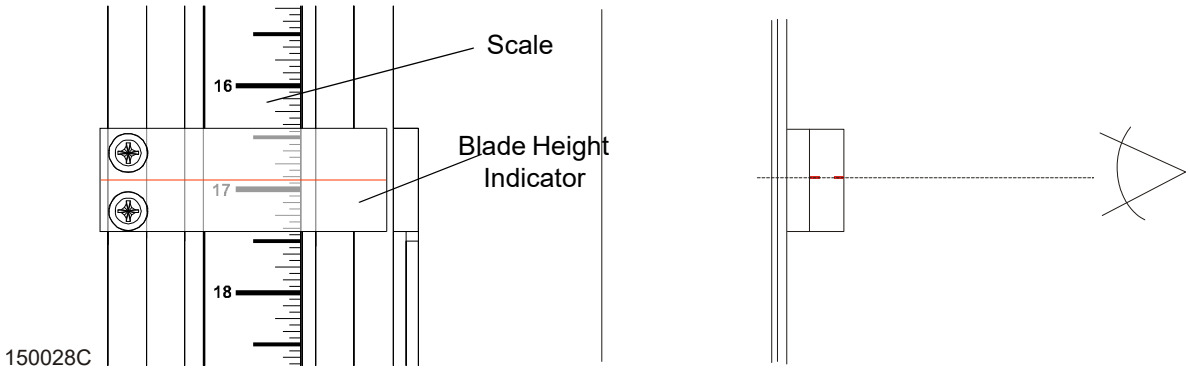


FIG. 3-22

Blade Height Indicator

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

Scale

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

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

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

The Quarter Scale

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

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

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

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

TABLE 3-3

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

3.14 Water Lube Operation

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

See figure 3-23. Open the valve on the water bottle to start water flow to the blade. A stream of water flows only when the blade is engaged.

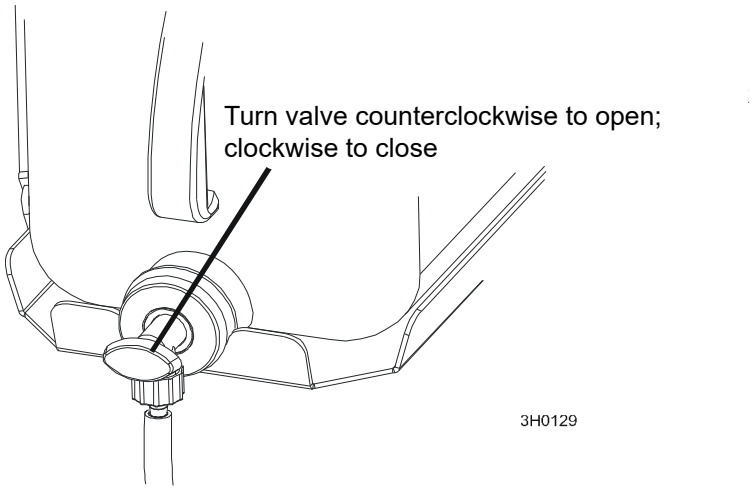


FIG. 3-23

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

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

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

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

3.15 Transporting the Sawmill

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

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

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

   See figure 3-24.

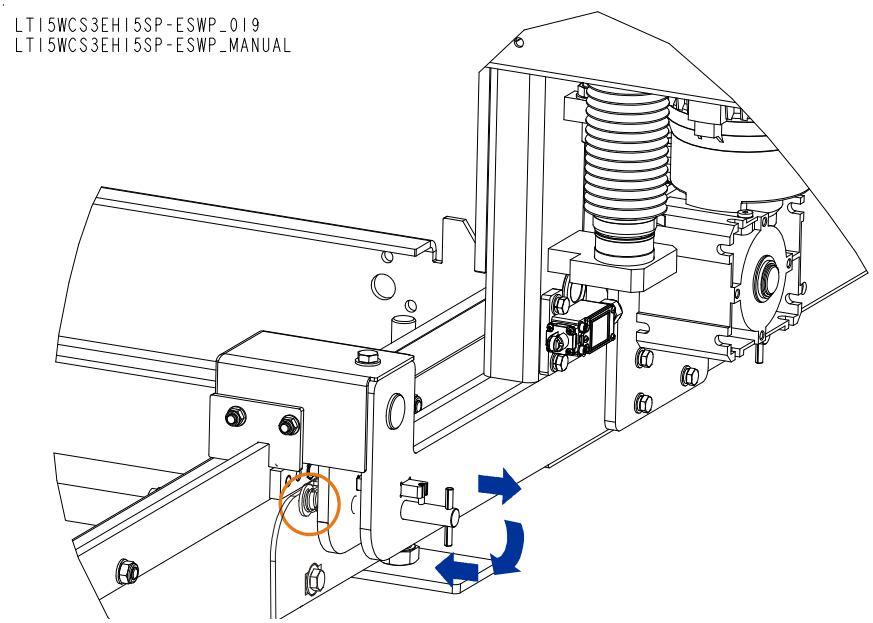


FIG. 3-24

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

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

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

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

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

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

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

Wood-Mizer LT15WCSC/LX100/LX450 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 4.2**
Remove excess sawdust from blade wheel housings and sawdust chute	**SEE SECTION 4.2**
EVERY 8 HOURS OF OPERATION	
Clean and lubricate track	**SEE SECTION 4.3**
Remove sawdust from track roller housings	**SEE SECTION 4.3**

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		50 HRS	100 HRS	150 HRS	200 HRS	250 HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		550 HRS	600 HRS	650 HRS	700 HRS	750 HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		1050 HRS	1100 HRS	1150 HRS	1200 HRS	1250 HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		1550 HRS	1600 HRS	1650 HRS	1700 HRS	1750 HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		2050 HRS	2100 HRS	2150 HRS	2200 HRS	2250 HRS	2300 HRS	2350 HRS	2400 HRS	2450 HRS	2500 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

WOOD-MIZER LX50/LT15WCSC/LX100/LX450 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REFERENCE	TOTAL HOURS OF OPERATION *FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE.* *A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.*									
		2550 HRS	2600 HRS	2650 HRS	2700 HRS	2750 HRS	2800 HRS	2850 HRS	2900 HRS	2950 HRS	3000 HRS
Clean & lubricate mast	See Section 4.1										
Check blade wheel belts for wear.	See Section 4.2										
Lubricate blade tensioner screw.	See Section 4.2										

SECTION 4 MAINTENANCE

This section lists the maintenance procedures that need to be performed on LT15WC sawmills.

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

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

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

This section lists only part of the maintenance procedures that need to be performed on LT15WC sawmills. Be sure to refer to option and engine manuals for other maintenance procedures.

4.1 Wear Life

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

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

TABLE 4-1

4.2 Sawdust Removal

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

4.3 Carriage Track & Rollers

See figure 4-1.

1. 8 Clean the track rails to remove any sawdust and sap buildup every eight hours of operation.
2. Remove sawdust from the track roller housings and track rail with felt strip cover (B). To do this, remove the bolts (A) and brush any sawdust buildup. Soak the felt wiper with Dexron III

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

25

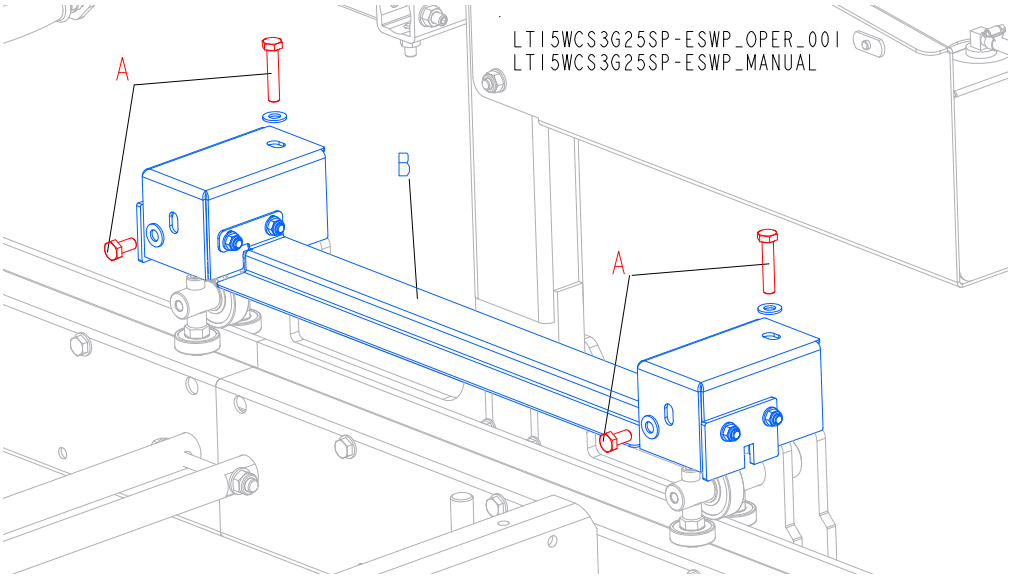


FIG. 4-1

4.4 Vertical Mast Rails

50

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

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

4.5 Miscellaneous Lubrication

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

See figure 4-2.

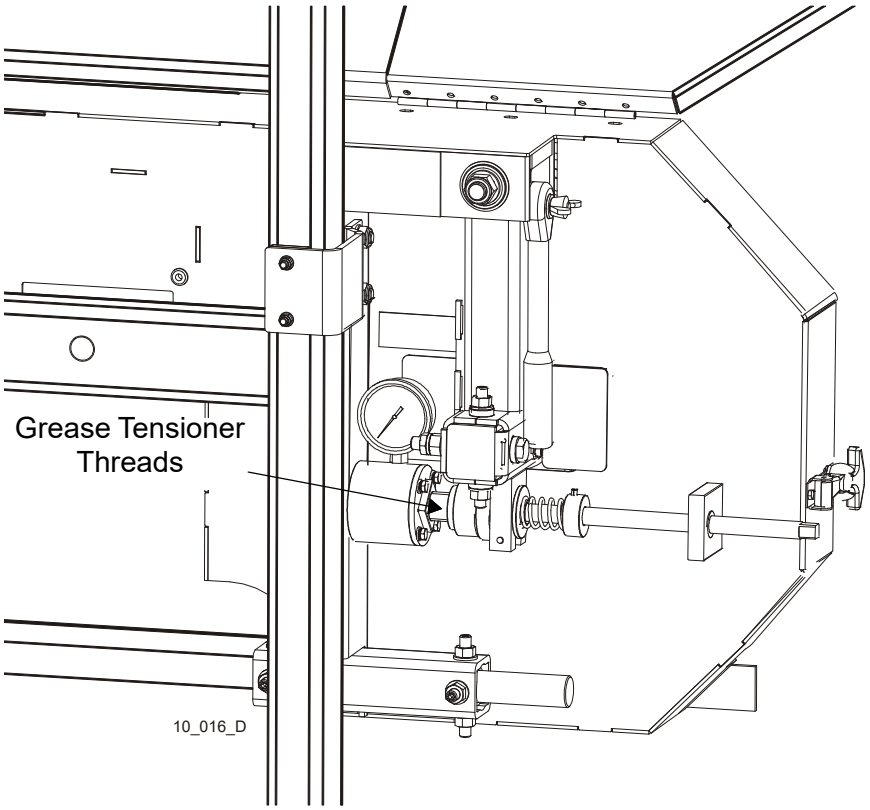


FIG. 4-2

4.6 Blade Wheel Belts

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

50

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

4.7 Brake Pads Adjustment (Gas / Diesel Sawmills Only)

200

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

Adjust the brake pads if the blade does not stop quickly, unusual sounds occur when the brake is applied, or a sudden change is noticed in the clutch/brake lever position when the clutch is disengaged.

WARNING! Do not for any reason adjust the brake pads with the engine running. Doing so may result in serious injury.

Open the blade housing cover.

See Figure 4-1. Loosen the locking bolts shown below. Adjust the brake pads so the blade stops no later than 10 seconds after disengaging. The brake pads should enter the grooves in the drive pulley when the brake is applied. If they are not, it can lead to their premature wear.

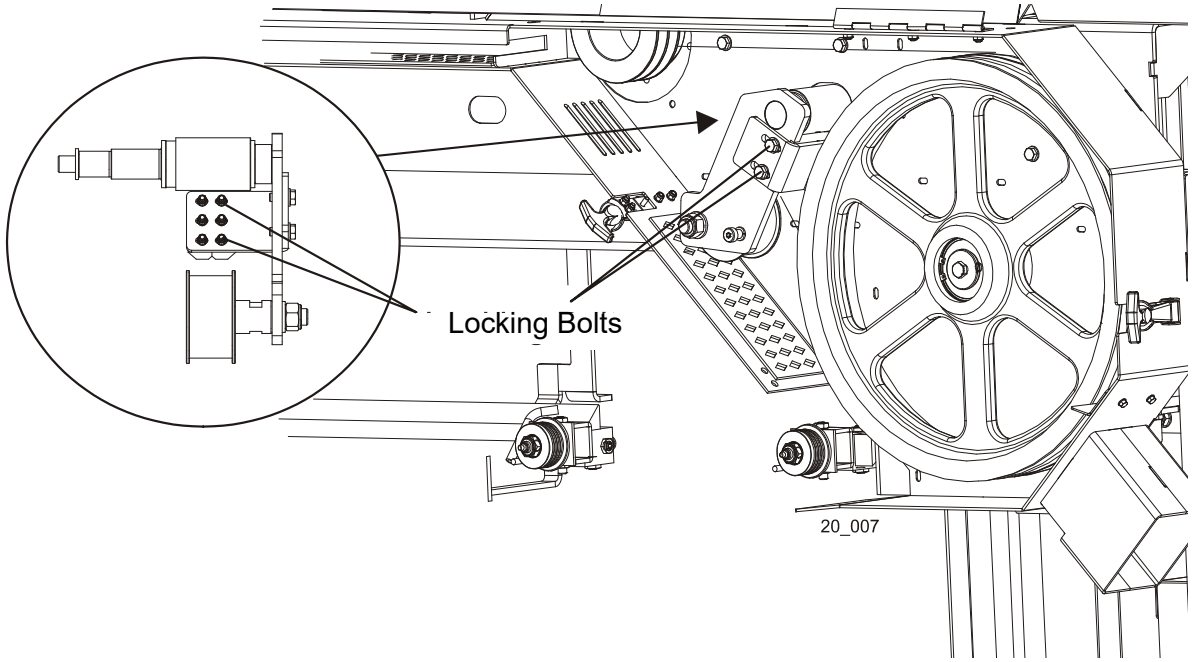


FIG. 4-1

4.8 Up/Down and Feed System

CAUTION! Do not over-tension the chain. Over-tensioning the chain may lead to early failure of the gear reducer.

1. Remove any sawdust buildup from the up/down screw bellows, the up/down screw nut, the upper and lower limit switches and the lower bearing housing.

See figure 4-3.

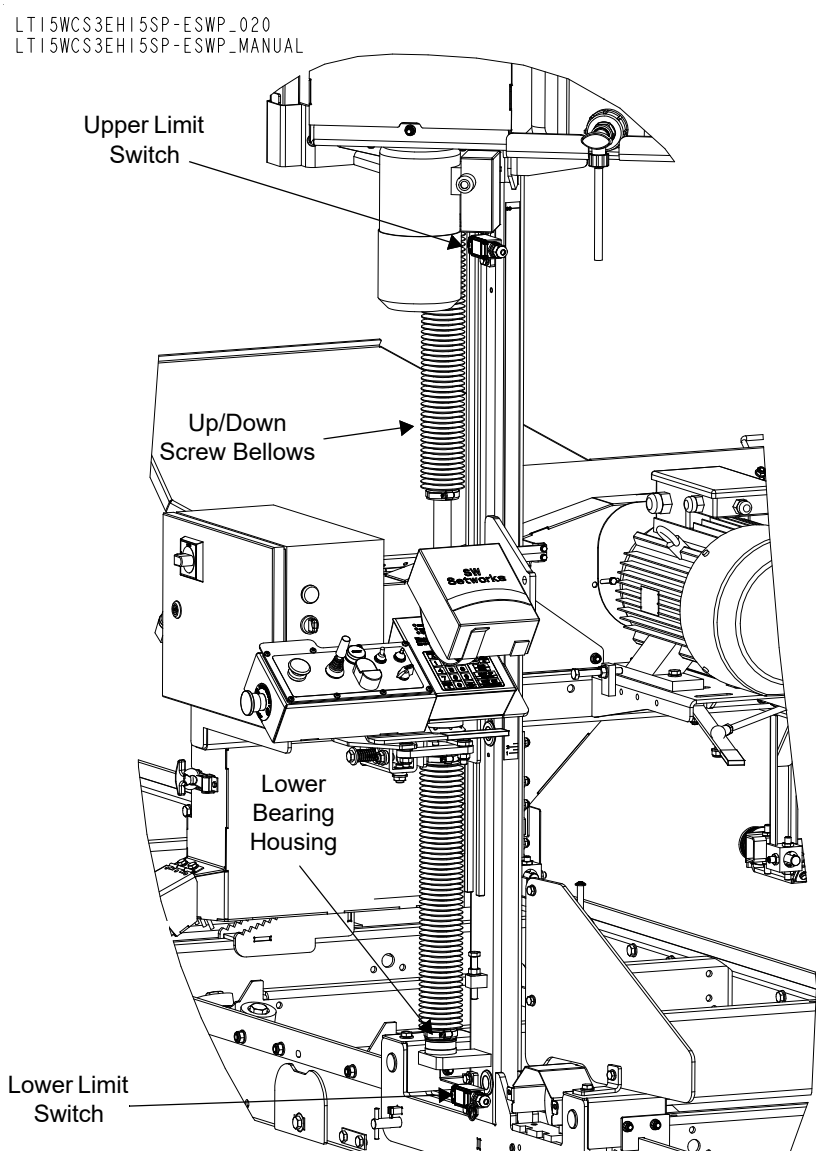


FIG. 4-1

2. Lubricate the up/down acme screw with a rolling bearing lubricant (e.g. ŁT4S or Shell Extreme Pressure Grease) every six months. Apply the lubricant to the grease fitting in the nut housing. Lubrication may be required sooner if environmental conditions require it. If the lubricant appears to have dispersed or is dry or crusted, reduce the maintenance interval.

The up/down screw bellows should completely cover the screw. If either of the bellows is damaged, replace it immediately. Before installing the new bellows, clean the up/down screw and nut thoroughly with extraction naphtha. The acme screw nut (Part No. 094243) should be replaced if the end play is larger than 1.25 mm.

3. Check the up/down belt tension after the first 20 hours of operation and every 100 hours thereafter.

100

See figure 4-4. Unbolt the up/down top guard. Loosen the motor mounting bolts. Use the adjustment bolt shown below to adjust the belt tension. Retighten the engine mounting bolts. Reinstall the cover.

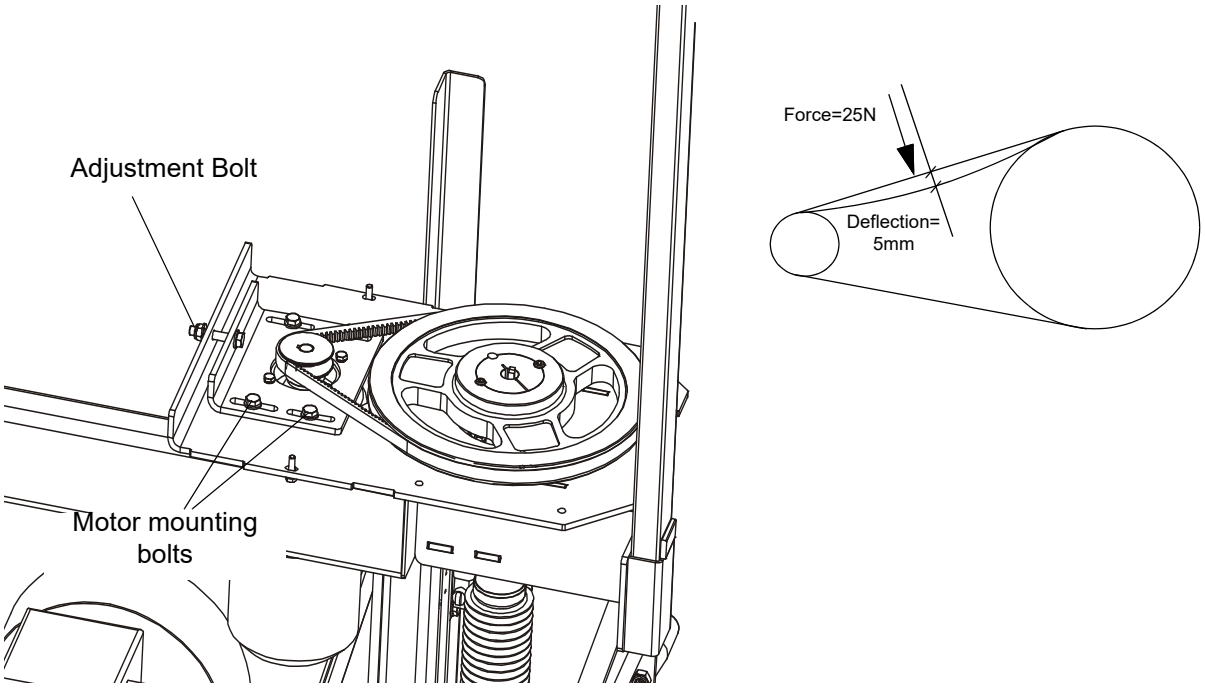


FIG. 4-2

4. Every 200 hours of operation check and adjust if necessary the up/down motor brake air gap.

200

See figure 4-5.

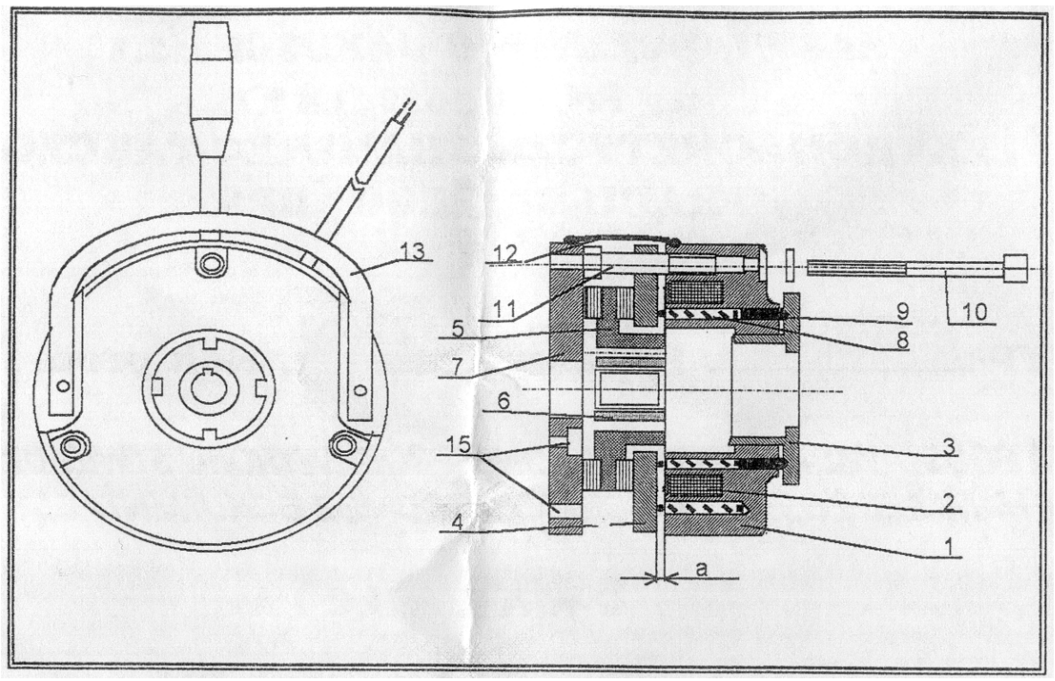


FIG. 4-3

1. Electromagnet body
2. Coil
3. Nut
4. Armature
5. Brake disk
6. Gear wheel
7. Mounting disk
8. Spring
9. Thrust pin
10. Mounting bolt
11. Adjustment bolt
12. Brake casing
13. Manual release lever
14. Locking element
15. Mounting holes

AIR GAP ADJUSTMENT

The air gap ,,a" grows gradually larger in consequence of wear of brake disc lining (5). The niminal value of the air gap a nom " may be restored by screwing in the adjusting bolts (11) into the body (1). Prior to adjustment, slacken mounting bolts (10) and then set the nominal value of air gap using the feeler gauge inserted between armature and body and screwing in the adjusting bolts (11). Tighten the mounting bolts (10) and secure the position by screwing out the adjusting bolts as far as they go.

Table 4-1

TYPE	HPS08
a nom.	0,2 ± 0,05
a max.	0.5

MAINTENANCE

The brakes do not require special maintenance procedures, however during regular intervals of time depending on intensity of brake operation, perform inspections and regulation of air gap "a". When the brake disk reaches maximum wear, replace it with a new one.
While replacing the brake disk, take care that the friction surface of the disk, armature and elements cooperating with the friction linings are free from grease and oil. Remove all dirt accumulated from the brake interior. If in spite of correct mounting and proper regulation, the brake does not operate, failure is due to: electromagnet - burnt coil, damaged supply cable, rectifier system (installed in the motor terminal box or control cabinet of the machine), electrical connections - check for correctness and quality of connections, damaged elements - replace them with new ones.

4.9 Miscellaneous Maintenance

50

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

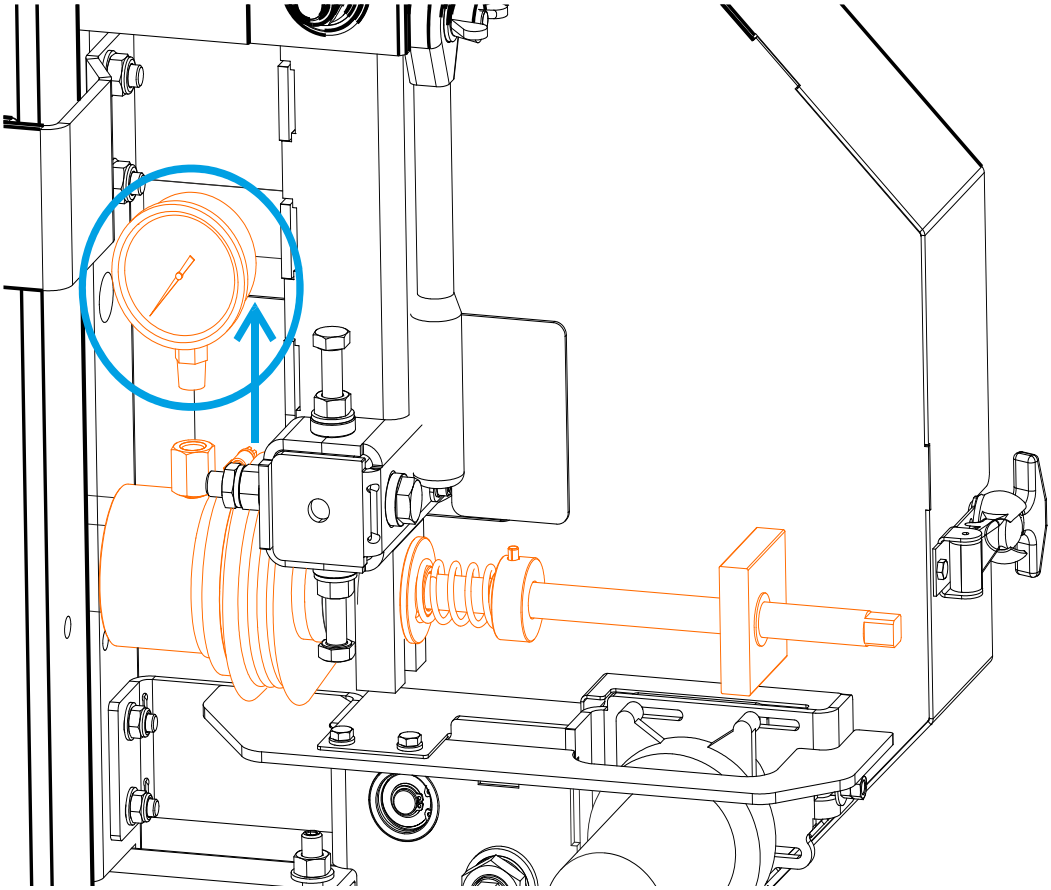
2. Check the mill alignment every setup. (See Section 6, Alignment).

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

4.10 Filling Blade Tensioner Cylinder with Oil

1. Loosen the blade tensioner completely.

2. Unscrew the oil pressure gauge.



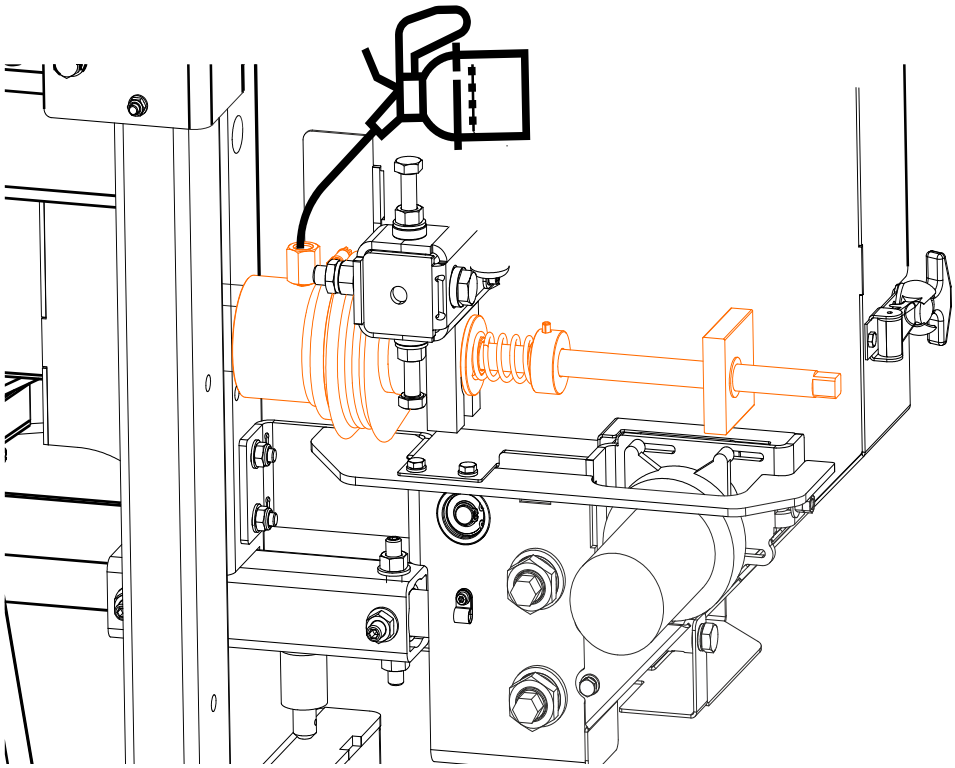
3. Using an oiler equipped with a tube / hose, top up the oil level until the oil flows out of the cylinder.

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

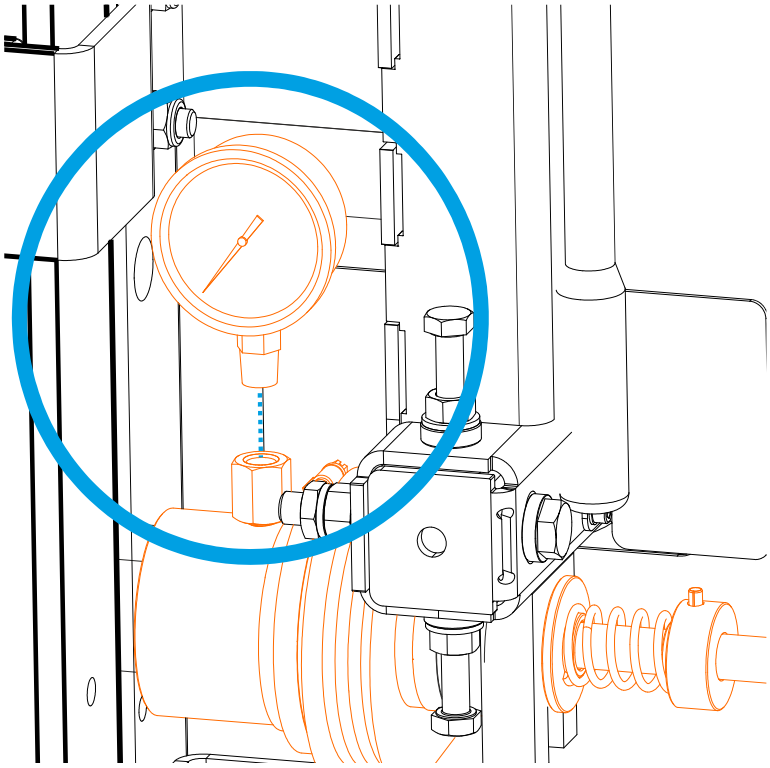
IMPORTANT! When topping up the oil level, make sure that the end

of the oiler tube / hose is at the bottom of the cylinder.

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



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



4.11 LT15WC AC Safety Devices Inspection (Only CE Version)

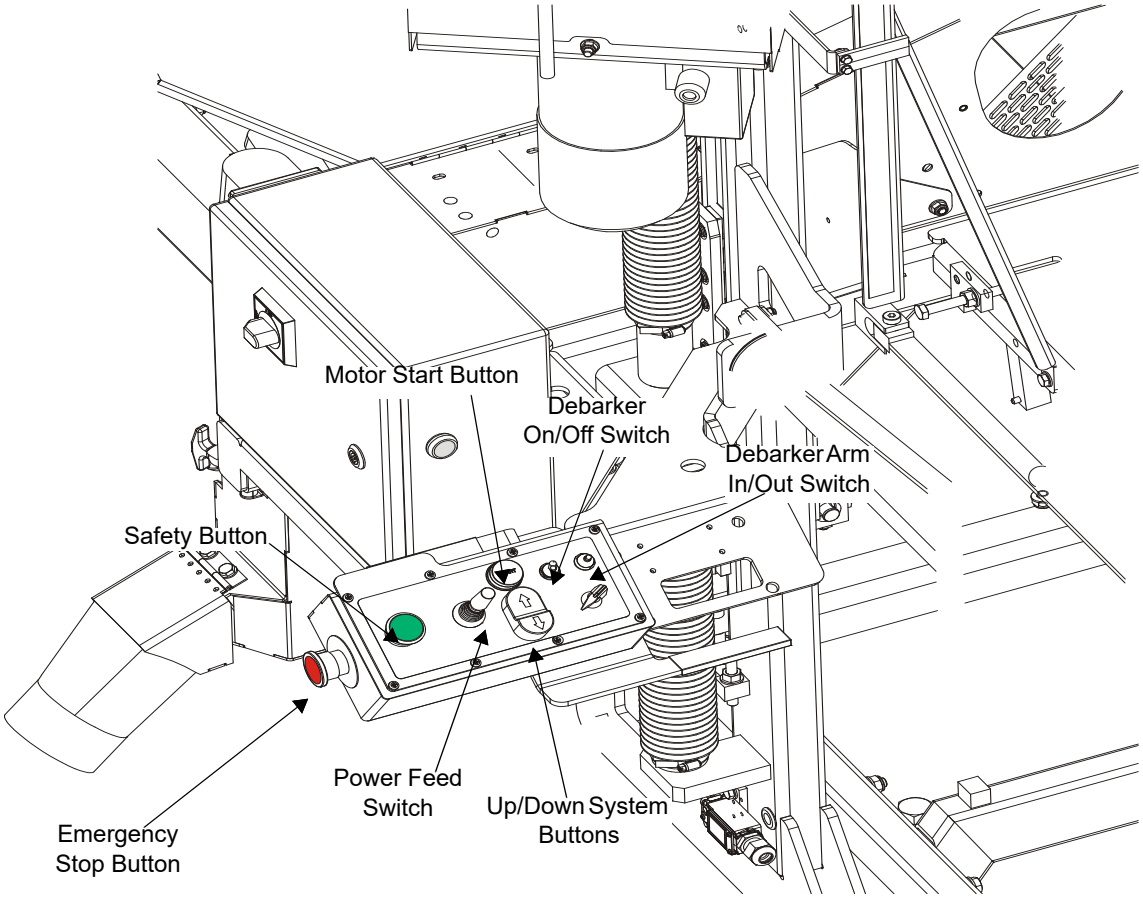
LT15WC AC - Safety devices inspection

Safety devices on the LT15WC AC sawmill which must be checked before every shift:

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

1 E-STOP button and its circuit inspection

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



2 Green safety button inspection

- Be sure the E-STOP button is released;
- Press and hold the green safety button;
- Turn on the blade motor. The motor should be started;
- Release the green safety button; The blade motor should be stopped.
- Try to start the motor without pressing the safety button. The blade motor should remain stopped.
- Press and hold the green safety button; The blade motor should remain stopped.

3 Inspection of the control circuits with E-STOP button pressed

- Press and hold the green safety button;
- Turn on the main engine;
- Press the E-STOP button located on the left side of the control box. The blade motor should be stopped.

- With E-STOP button pressed try to move the saw head up and down (using the switch and Setworks button and forward/backward using the power feed switch. Both systems should not start.
- With E-STOP button pressed, try to start the debarker blade motor and move the debarker arm in and out. The debarker should not start to work.

4 Blade cover safety switch and its circuit inspection

- Press and hold the green safety button;
- Turn on the main engine;
- Open the blade housing cover.
- The motor should stop;
- Try to start the engine; The engine should remain stopped.
- Close the blade housing cover;
- The blade motor remain stopped until it is restarted with the START button.

4.12 LT15WC DC Safety Devices Inspection (Only CE Version)

LT15WC DC - Safety devices inspection

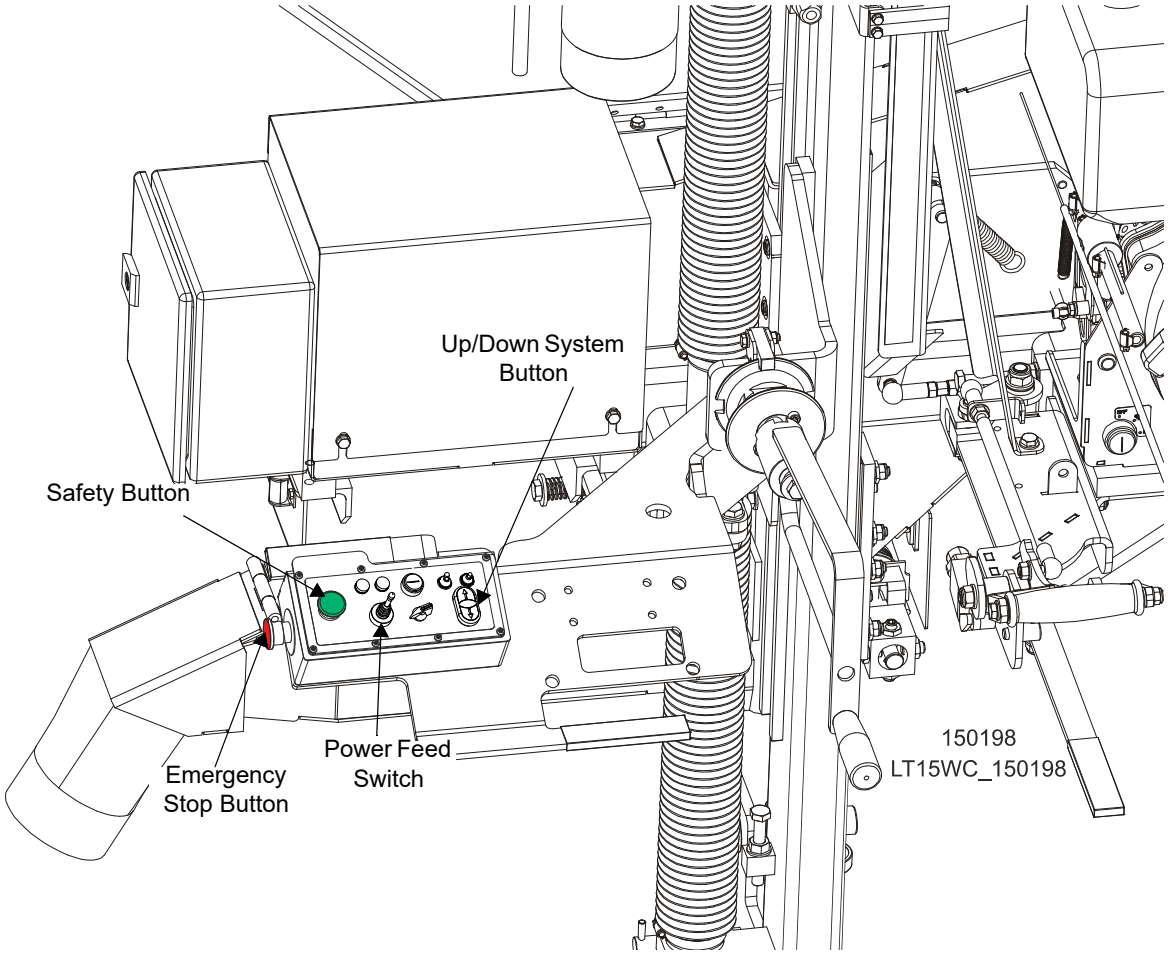
Safety devices on the LT15WC DC sawmill which must be checked before every shift:

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

1 E-STOP button and its circuit inspection

- Start the engine according to your engine option manual;
- Press and hold the green safety button;
- Push the tensioner handle forward to engage the blade;
- Press the E-STOP button located on the left side of the control box. The engine should stop.

Restarting the engine should not be possible until the E-STOP button is released.



2 Green safety button inspection

- Be sure the E-STOP button is released;
- Start the engine according to your engine option manual;
- Press and hold the green safety button;
- Push the tensioner handle forward to engage the blade;
- Release the safety button; The engine should stop.
- Press and hold the green safety button; The engine should remain stopped.

3 Inspection of the control circuits with E-STOP button pressed

- Start the engine according to your engine option manual;
- Press and hold the green safety button;
- Push the tensioner handle forward to engage the blade;
- Press the E-STOP button located on the left side of the control box. The engine should stop.

- With the E-STOP button pressed, try to move the saw head up and down (using the switch and the Setworks buttons) and forward/backward using the power feed switch. Both systems should not start.

4 Inspection of the tensioner handle safety switch

- Start the engine according to your engine option manual;
- Push the tensioner handle forward to engage the blade;
- The engine should stop.

5. Blade cover safety switch and its circuit inspection

- Start the engine according to your engine option manual;
- Press and hold the green safety button;
- Push the tensioner handle forward to engage the blade;
- Open the blade housing cover.
- The engine should stop;

SECTION 5 TROUBLESHOOTING GUIDE

5.1 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 Wheels	Cant adjustment is incorrect.	Readjust (See Section 3.4).
	Flat/worn belts.	Replace B-57 belts
Blade Guide Rollers Do Not Spin While Cutting	Frozen bearings	Replace bearings
	Worn bearings	Replace bearings
Drive Belts Wear Prematurely or Jump	Engine/motor and drive pulleys out of alignment	Align pulleys

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. Repeat cuts, keeping the heart in the middle of the cant, and making it your last cut.
	Tooth set problem.	Resharpen and reset the blade.
	Bed rails misaligned.	Realign sawmill.
Height Adjustment Jumps or Stutters When Moving Up or Down	Mast needs lubrication.	Lubricate mast track surface
	Mast slide pads are not adjusted properly (the entire surface of the pad should touch the mast).	Adjust the pads.
Lumber Is Not Square	Side supports not square to bed.	Adjust side support.
	Blade not parallel to bed rails.	Adjust bed rails parallel to blade.
	Sawdust or bark between cant and bed rails.	Remove particles.
	Tooth set problem.	Resharpen and reset the blade.
Sawdust Builds Up On Track	Excessive lubrication	Do not lubricate track with grease.
	Track is sticky.	Clean track with solvent and apply silicone spray.
Wavy Cuts	Excessive feed	Slow down 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 larger amount of water flow to the blade during cutting.
	Tooth set problem.	Resharpen and reset the blade.

SECTION 6 SAWMILL ALIGNMENT

6.1 Pre-Alignment Procedures

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

The sawmill alignment steps are:

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

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

See Section 3 Setup & Operation for setup information.

6.2 Pre-Installation Procedure

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

6.3 Blade Installation and Alignment

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

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

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

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

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

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

   See figure 6-1. The blade wheels should be adjusted so that the gullet of 1 1/4" blades ride 1/8” (3 mm) out from the front edge of the wheels (±1/26 [1 mm]). The gullet of 1 1/2" blades should ride 3/16" (4.5 mm) from the front edge of the wheels (±1/26 [1 mm]). *Do not let the teeth ride on the wheels.*

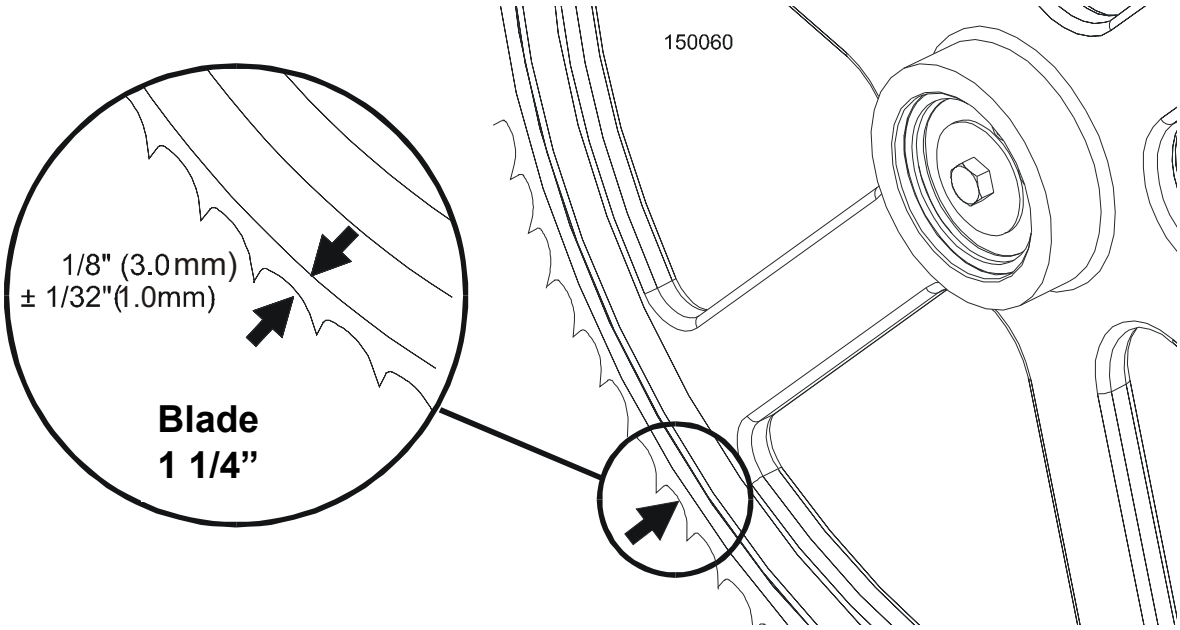


FIG. 6-1

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

6.4 Blade Wheel Alignment

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

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

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

See figure 6-2.

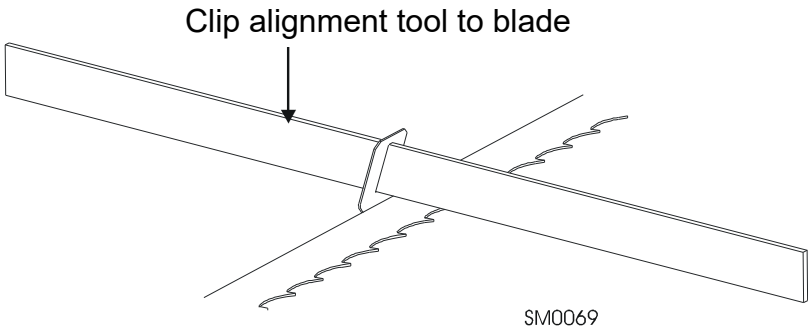


FIG. 6-2

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

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

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

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

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

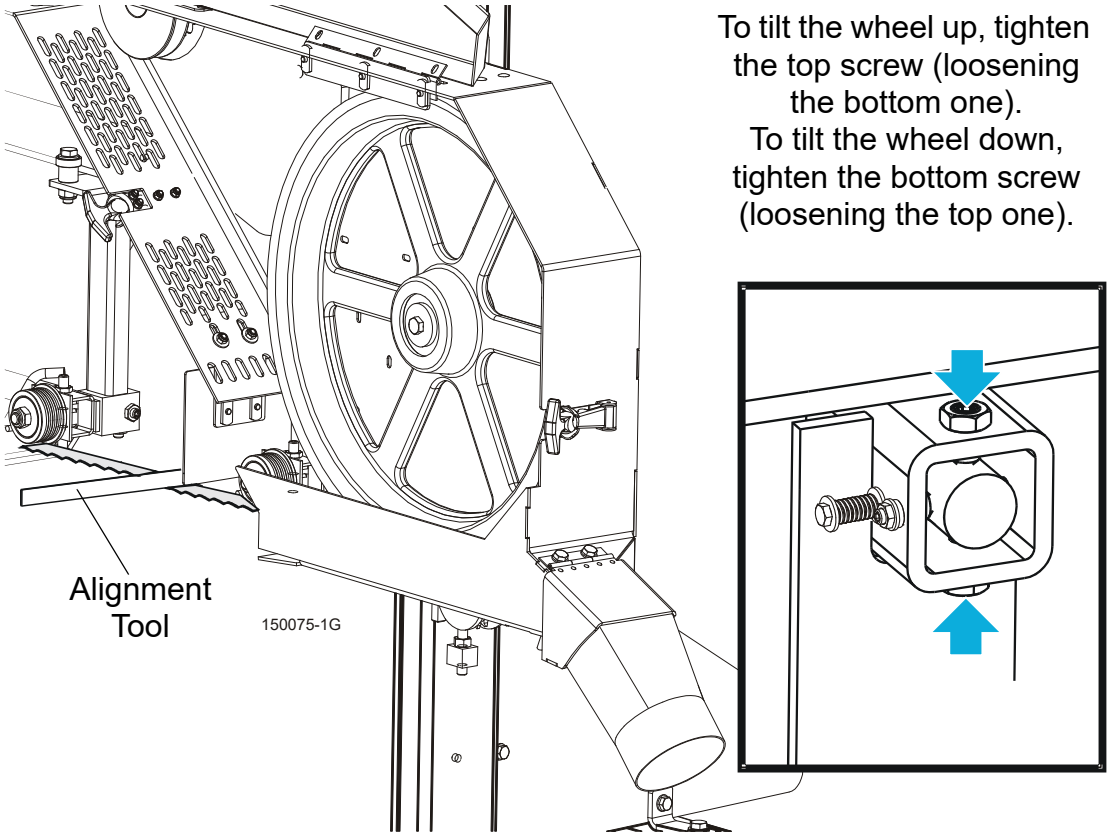


FIG. 6-3

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

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

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

   See figure 6-4. To tilt the idle-side blade wheel up, loosen the lower nut and adjustment screw 1/2 turn, loosen the nut on the upper adjustment screw and tighten the upper screw. Then tighten the upper and lower nut.

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

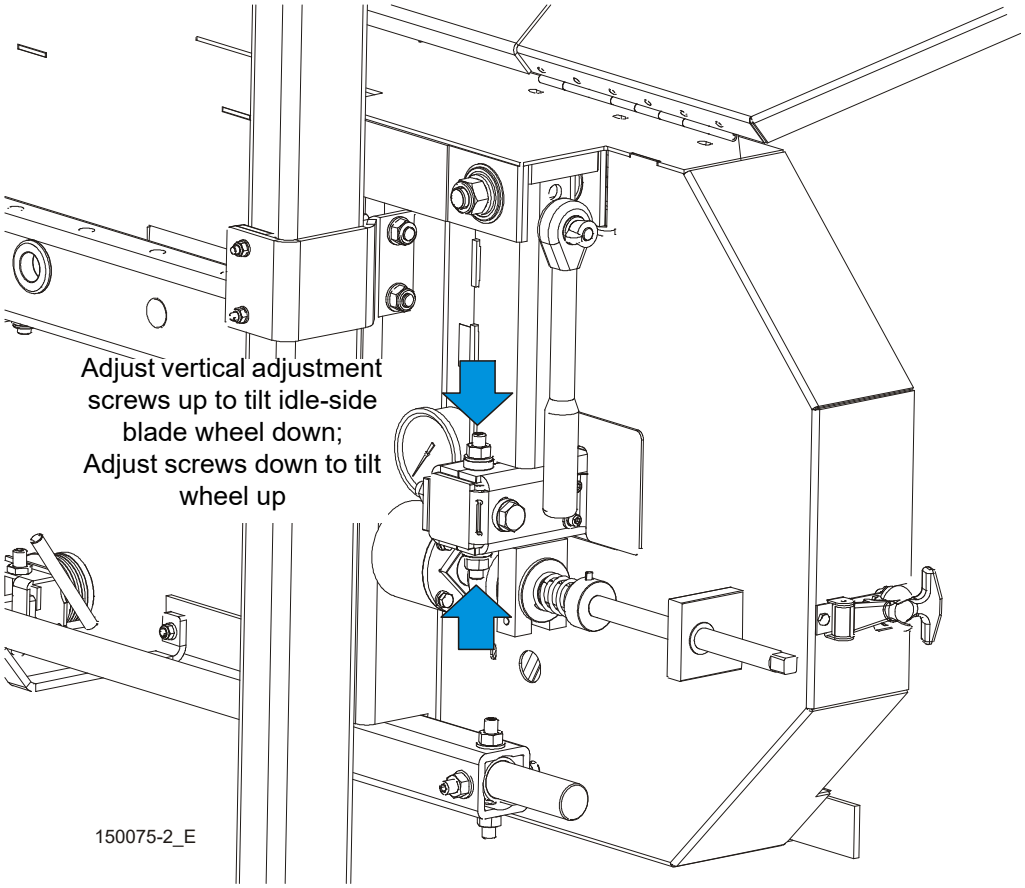


FIG. 6-4

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

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

See figure 6-5. The horizontal tilt of the blade wheel should be adjusted so that the gullet of an 1-1/4" blade is 1/8" (3 mm) out from the front edge of the wheel (±1/32 [0.75 mm]).

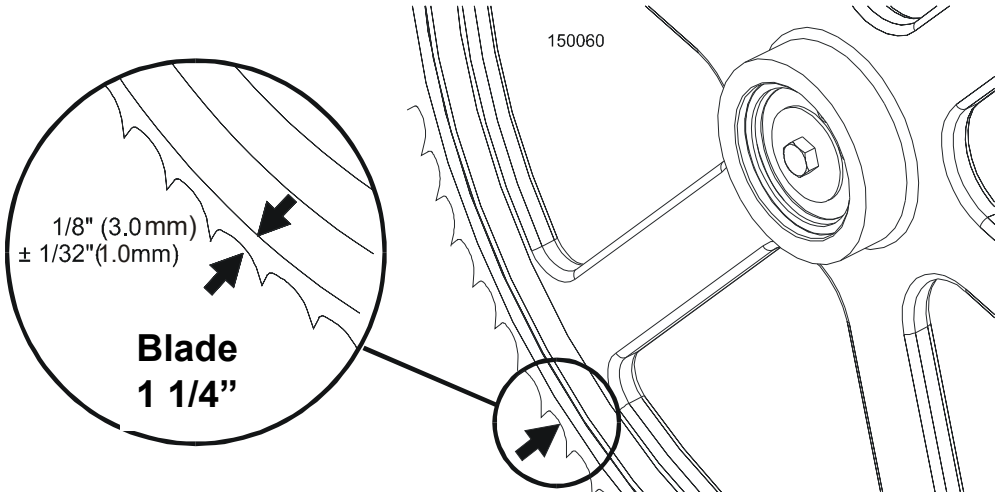


FIG. 6-5

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

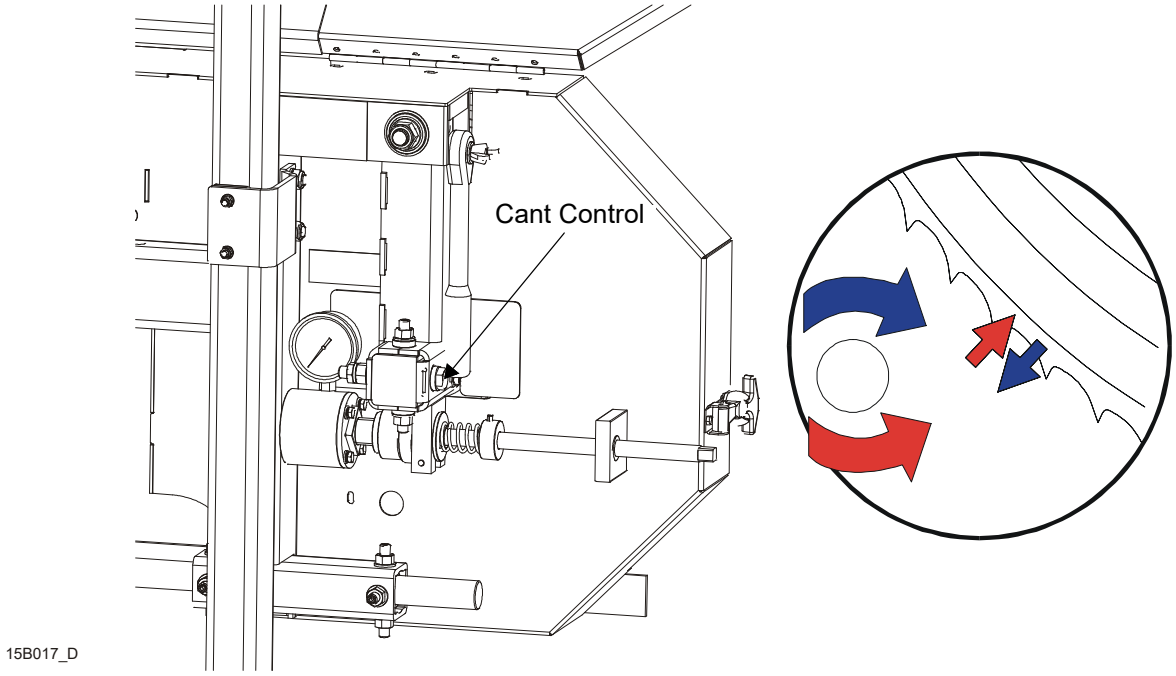


FIG. 6-6

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

See figure 6-7. Use the adjustment screw shown below to adjust the drive-side blade wheel horizontally. First, loosen the nut on this screw. Loosen adjustment screw to move blade out on wheel. Tighten adjustment screw to move blade in on wheel. Be sure to tighten the nut after

adjustment.

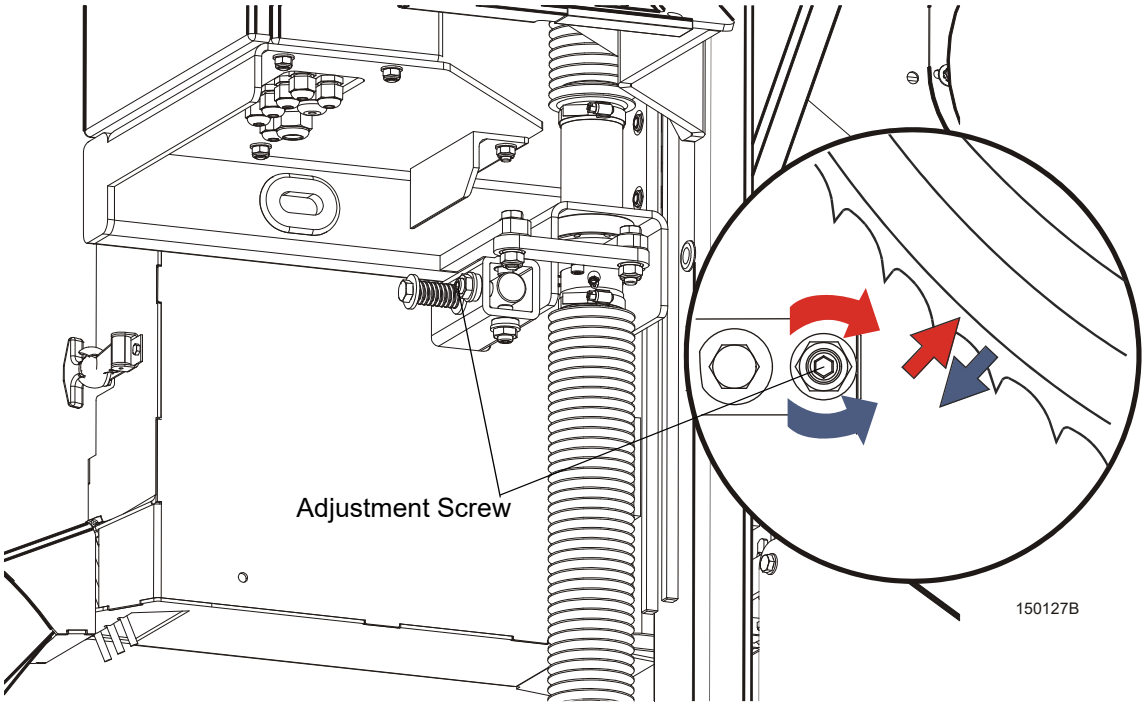


FIG. 6-7

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

6.5 Blade Guide Arm Alignment

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

Vertical Alignment

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

See figure 6-8.

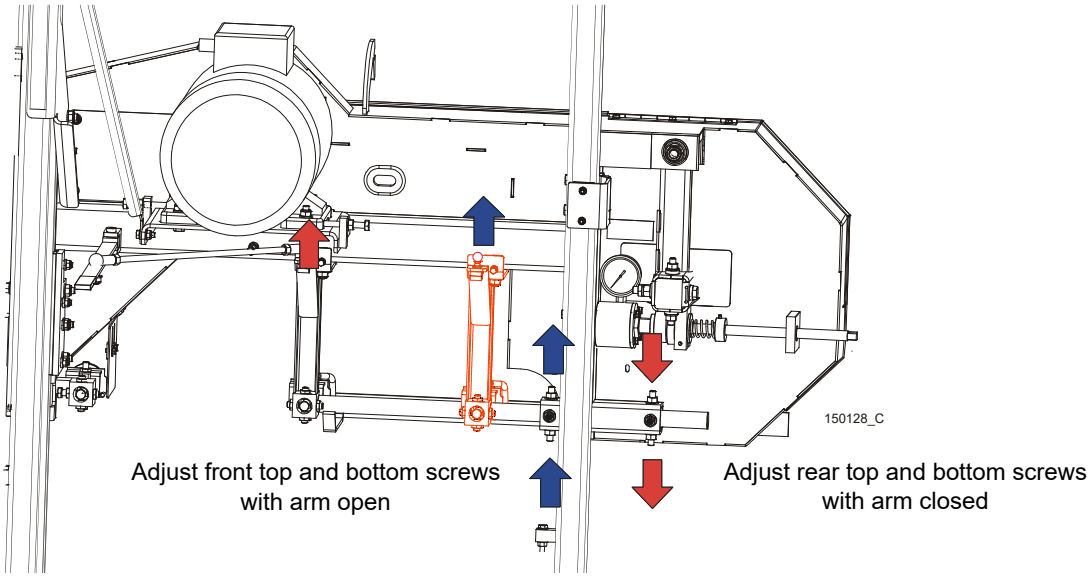


FIG. 6-8

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

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

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

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

Horizontal Alignment

See figure 6-9.

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

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

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

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

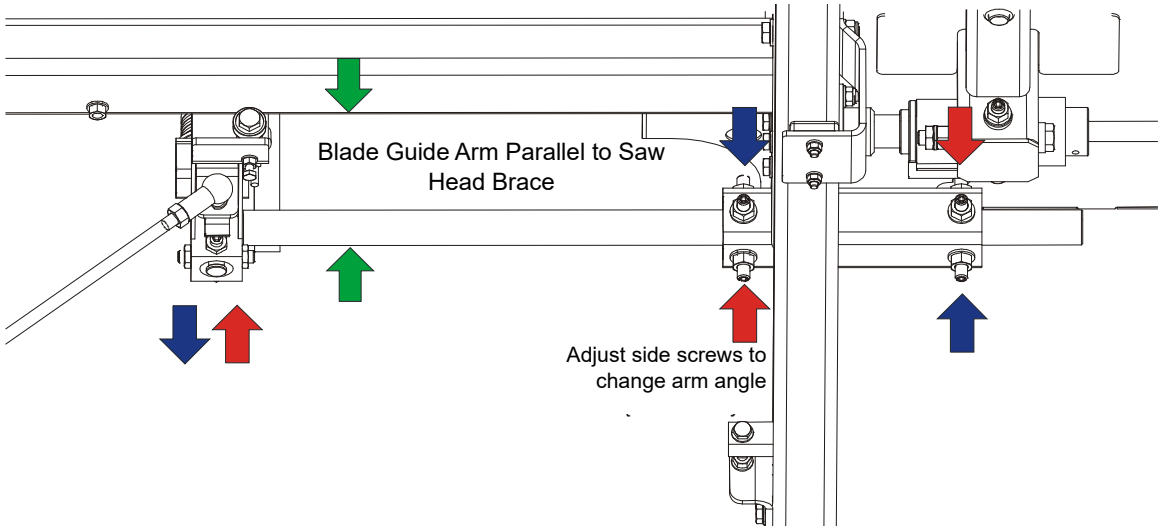


FIG. 6-9

6.6 Aligning The Blade Guides

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

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

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

Blade guide alignment includes four steps:

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

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

6.7 Blade Deflection

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

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

   See figure 6-10.

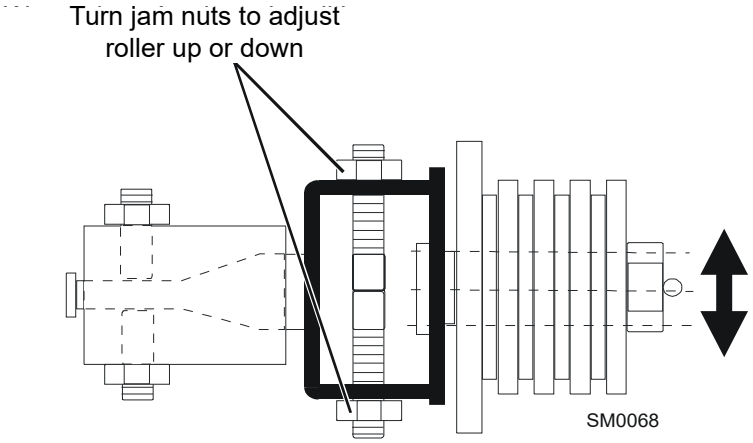


FIG. 6-10

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

3. Repeat for the other blade guide.

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

6.8 Blade Guide Vertical Adjustment

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

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

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

See figure 6-11.

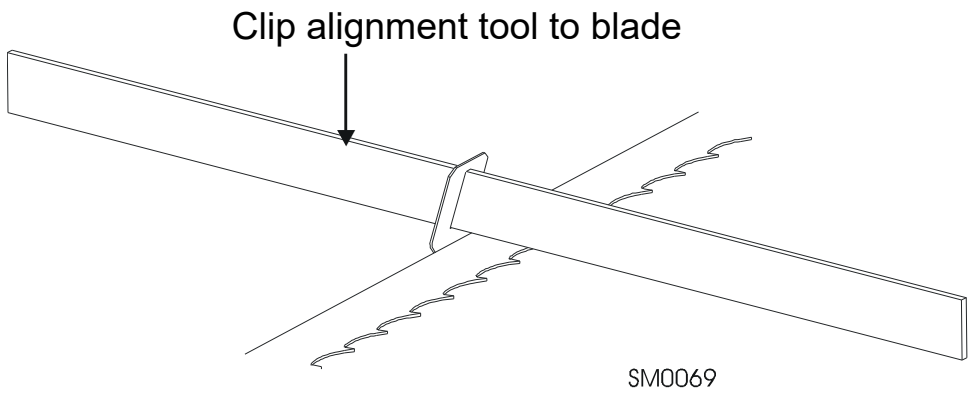


FIG. 6-11

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

See figure 6-12.

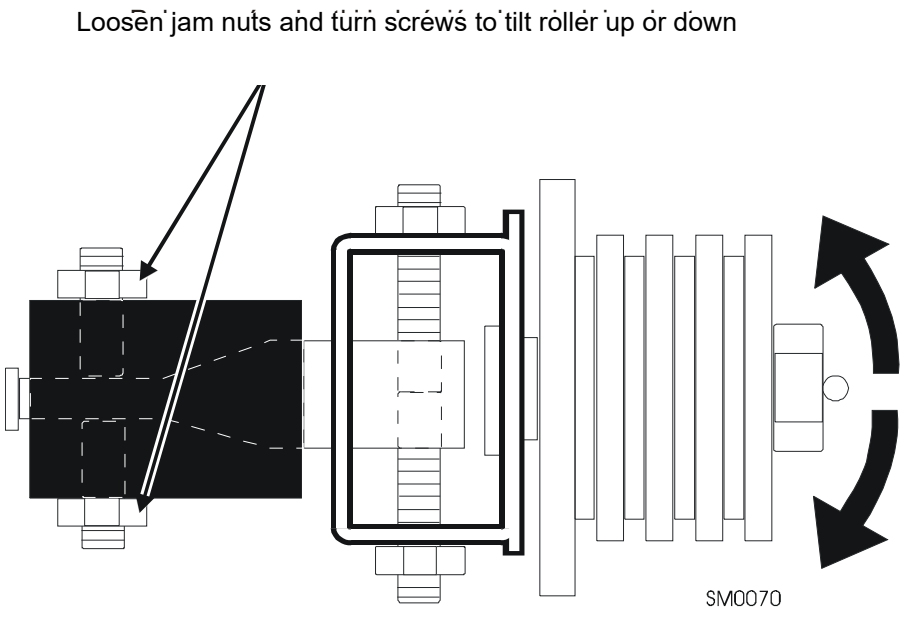


FIG. 6-12

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

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

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

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

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

6.9 Blade Guide Spacing

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

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

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

   See figure 6-13.

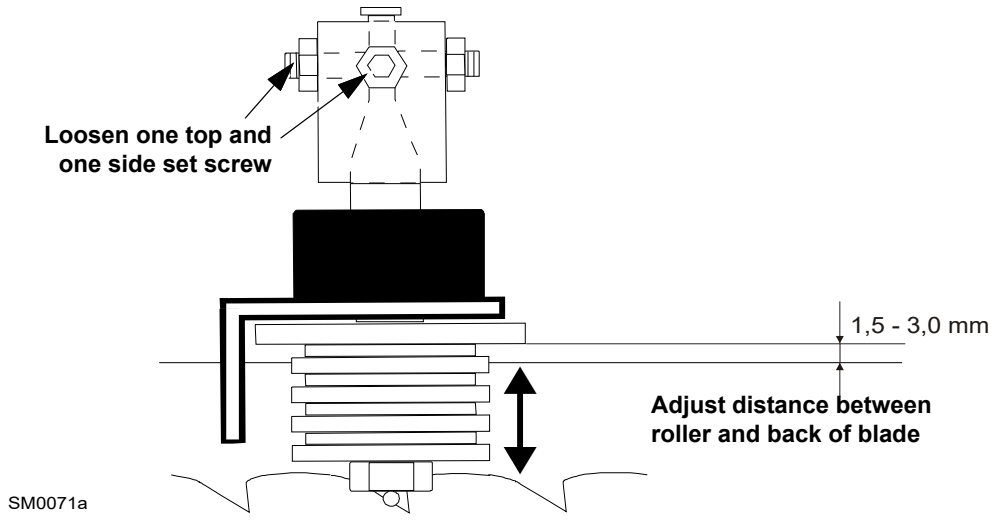


FIG. 6-13

3. Tighten the set screws.

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

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

6.10 Horizontal Tilt Adjustment

1. Adjust the blade guide arm half way in.

   See figure 6-14.

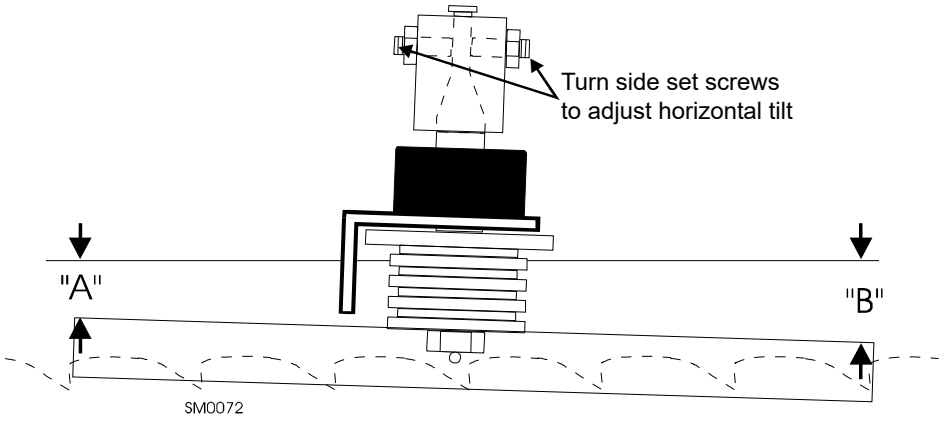


FIG. 6-14

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

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

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

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

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

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

6.11 Side supports

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

Perform the following steps:

1. Place a flat board across the bed rails.

See figure 6-15.

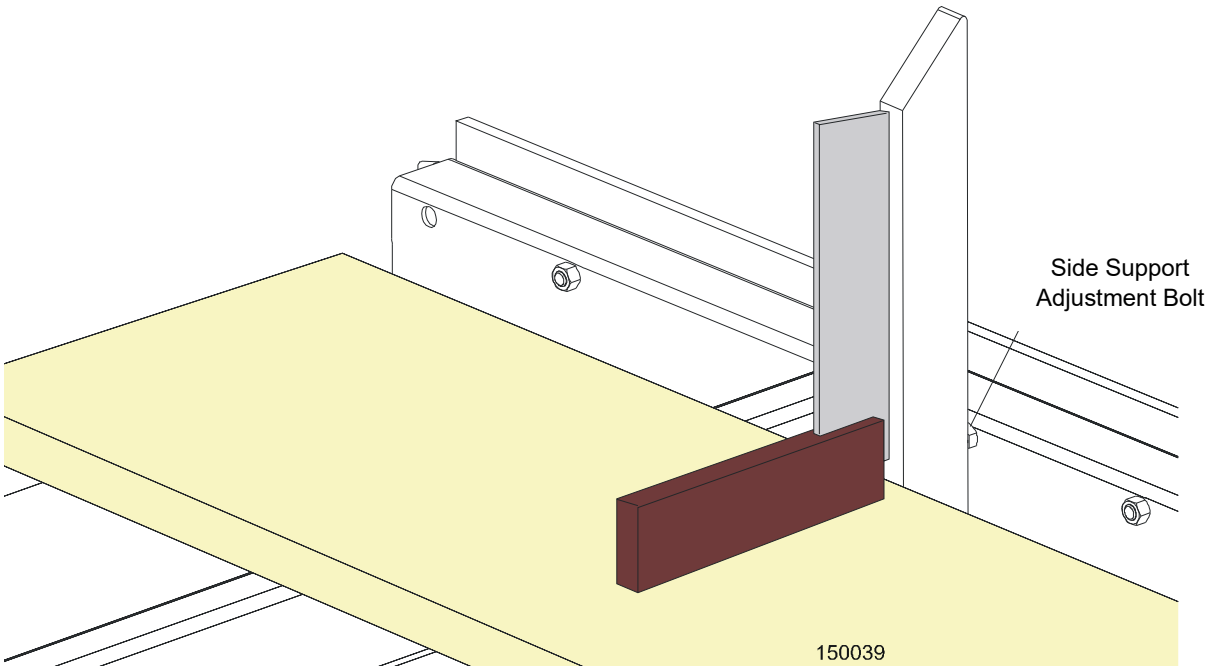


FIG. 6-15

2. Swing a side support up so that it is vertical.

3. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.

4. Check the angle of each support with a square on the board.

5. The side support should be 90° to the bed rails. If it does not, use the adjustment bolt shown on the figure 6.15 to adjust the side support. Turn the adjustment bolt counterclockwise to tilt the top of the side support forward.

6. Repeat for the remaining side supports.

6.12 Blade Height Scale Adjustment

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

See figure 6-16.

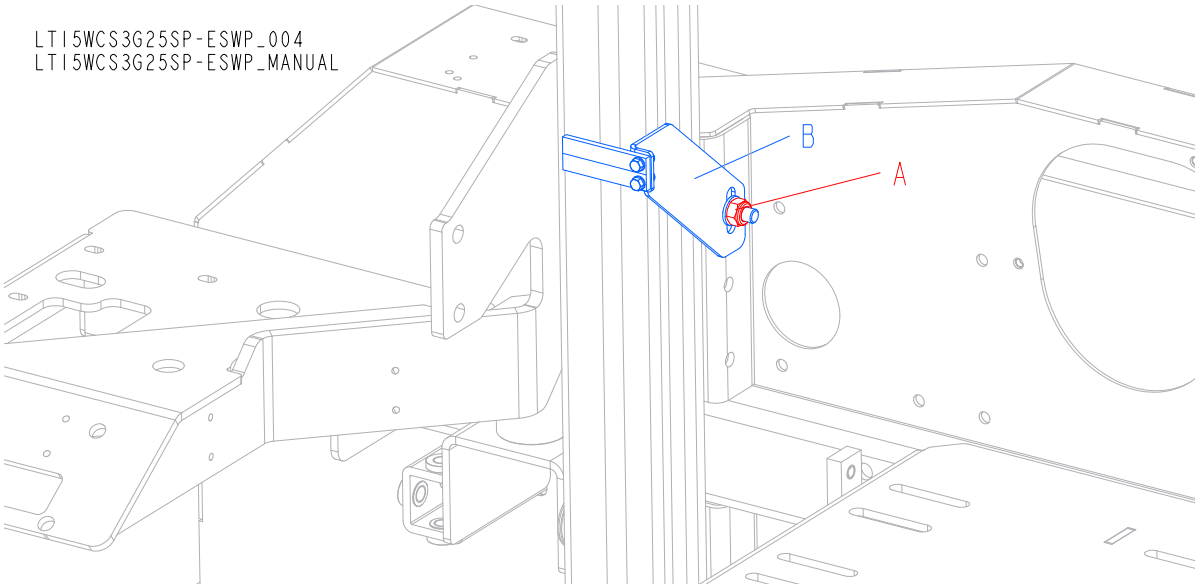


FIG. 6-16

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

2. Loosen the mounting bolt nut (A) of the scale bracket (B), adjust the bracket until the indicator is aligned with the correct mark on the scale. Retighten the bracket mounting bolt and nuts.

   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.

6.13 Motor Drive Belt Adjustment

See figure 6-17. Loosen the motor mounting bolts. Using the adjustment bolts shown below, adjust the drive belt until it has 7/16" (11 mm) deflection with a 16 lbs (7.2 kG) deflection force - in the case

of E15 motor. Retighten the engine mounting bolts.

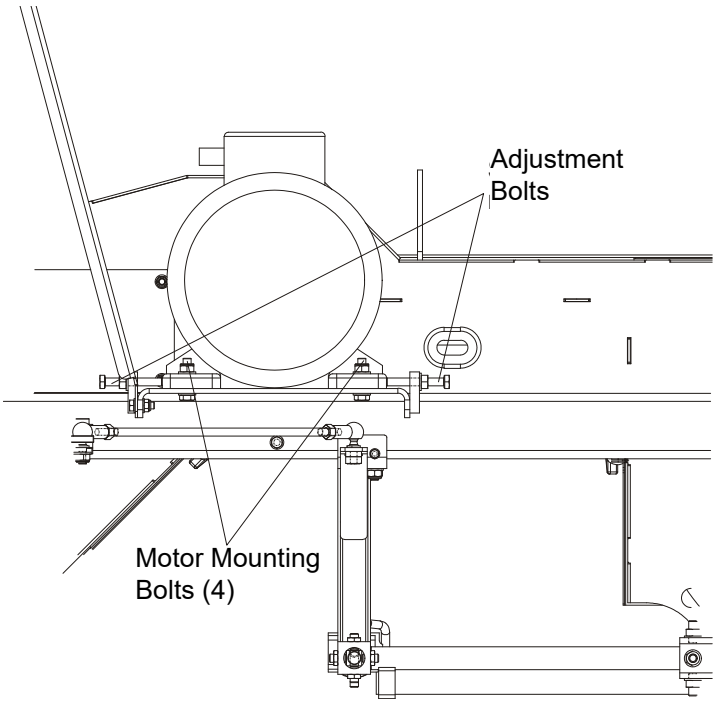


FIG. 6-17

6.14 Track Roller Distance Adjustment

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

See figure 6-18.

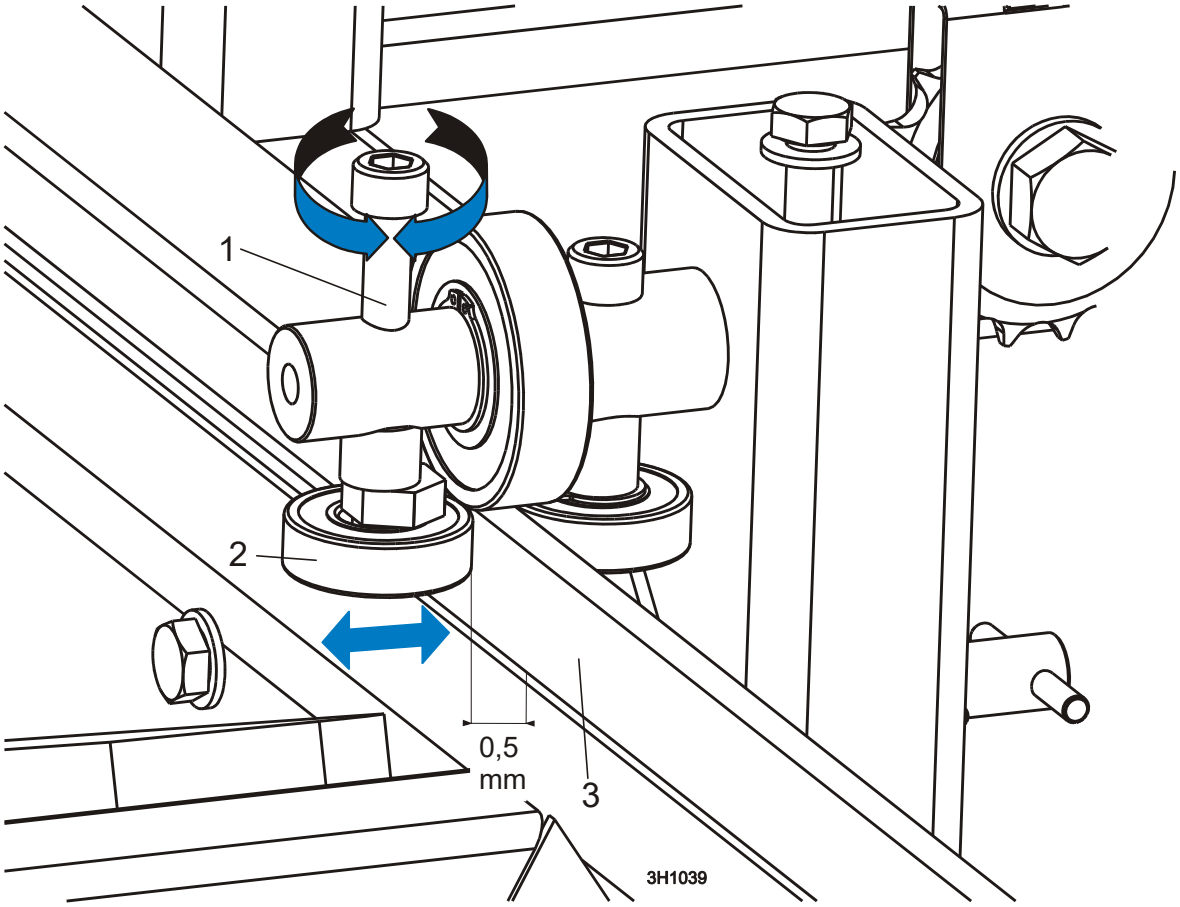


FIG. 6-18

SECTION 7 MOTOR BRAKE

7.1 Motor Brake Maintenance

Maintenance intervals

Service brakes	■ after 4000 hours of operation at the latest or every six months

TABLE 7-1.

IMPORTANT! Brakes with defective armature plates, cheese head screws, springs or flanges must be replaced completely.

Please observe the following for inspections and maintenance operations:

- Remove impurities through oil and grease using brake cleaning agents, if necessary, replace brake after finding out the cause of the contamination. Dirt deposits in the air gap between stator and armature plate impair the function of the brake and must be removed.
- After replacing the rotor, the original braking torque will not be reached until the run−in operation of the friction surfaces has been completed. After replacing the rotor, run−in armature plates and flanges have an increased initial rate of wear.

Checking the rotor thickness

DANGER! The motor must not be running when checking the rotor thickness.

- Remove the motor cover and seal ring (if mounted).
- Measure the rotor thickness with a caliper gauge. On brakes with friction plates, observe edging on outer diameter of friction plate.
- Compare measured rotor thickness with minimally permissible rotor thickness. *See Table 7-2.*.
- Replace the complete rotor if necessary.

Check the air gap

- Measure the air gap "$s_{Lü}$" between armature plate and rotor using a feeler gauge (see chapter 3.3).
- Compare the measured air gap to the maximum permissible air gap "$s_{Lümax.}$" (see table below).

- If necessary, adjust the air gap to "$s_{Lürated}$".

Brake type	sLürated +0.1mm -0.05mm	sLümax Service brake	Max. adjustment permissible wear	Rotor thickness		Excess of the adjuster nut $h_{Emax.}$ [mm]
				min. [1] [mm]	max. [mm]	
INTORQ BFK458-25	0,4 mm (1/64”)	1,0 mm (3/64”)	4,0 mm (5/32”)	12 mm (15/32”)	16 mm (5/8”)	17 mm (43/64”)

TABLE 7-2.

EC declaration of conformity

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

Manufacturer:

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

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

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

We, the undersigned herewith declare, that:

Designation of the machine:	**SAWMILL**
Model:	LT15
TYPE:	……
Serial Number:	……..….
VIN Number:	……
Is in conformity with the following EC directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2014/30/EU
And is in conformity with the following Harmonized Standards:	PN-EN 1807-2:2013-08 PN-EN ISO 13849-1:2016-02 PN-EN 60204-1:2018-12
Notified Body according to annex IV:	Sieć Badawcza Łukasiewicz INSTYTUT TECHNOLOGII DREWNA Centrum Weryfikacji Wyrobów Przemysłu Drzewnego ul. Winiarska 1, 60-654 Poznań
Notification No.:	1583
EC type-examination certificate no.	0719/2019
Responsible for Technical Documentation:	Piotr Adamiec / Engineering Manager Wood-Mizer Industries Sp. z o.o. 62-600 Koło, Nagórna 114, Poland Tel. +48 63 26 26 000
Place/Date/Authorized Signature:	Koło, 19.09.2019 
Title:	Engineering Manager