Wood-Mizer

from forest to final form

user manual

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

LX100 **rev. A1.00**

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

October 2015

Form #801

This is the original language for the manual

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Getting Service

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

General Contact Information

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

Office Hours:

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

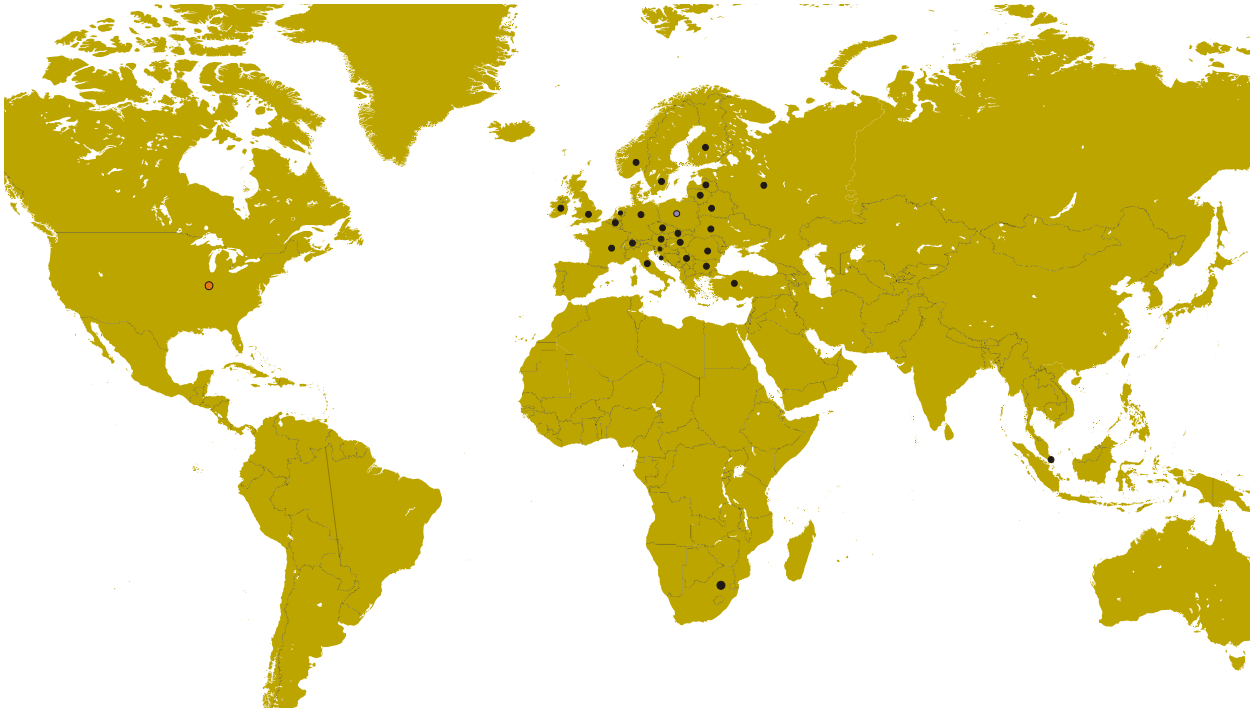
Please have your vehicle identification number and your customer number ready when you call.

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.

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



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Sawmill and Customer Identification

Each Wood-Mizer LX100 sawmill is identified with a revision and VIN numbers. See the table below for VIN description.

LX100	S3	EH11	S	-P
Base Model	Bed Section Numbers	Engine/Motor Configuration	CE Version	Power Feed Option

Revision Number	A1.	00
	Major Revision Code	Minor Revision Code

MODEL & REVISION NUMBERS DESCRIPTION

Company Identification Number 456=Wood-Mizer Indiana	Weight Class: A=Under 1361 kg, B=1361-1814 kg, C=1814-2268 kg, D=2269-3000kg	Product No.: 1=LT10/15, 2=LT20 Series, 4=LT40 Series, 7=LT70 Series	Length of the trailer: 20=20' (6 m), 24=24' (7 m), 35=35' (11 m)	Number of axes on the trailer	Check Digit Add all the number and divide by 11	Year of manufacture: J=2011, K=2012, L=2013, M=2014, N=2015, O=2016	State of manufacturei: N=Indiana, P=Poland	Month of Manufacturei: A=January, B=February, C=March, etc.	Revision Level	Sequence Number Ranging from 000-999	End of 17-Digit VIN	Revision Level (Repeated)	Two-Digit Minor Revision Level
456	**A**	**5**	**24**	**1**	**X**	**H**	**P**	**A**	**F9**	**017**		**F9**	**.01**

V.I.N. DESCRIPTION

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

Customer No.	Model Type	VIN No.	Revision No.

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

SECTION 1 SAFETY & GENERAL INFORMATION

1.1 Safety Symbols

This symbol calls your attention to instructions concerning your personal safety. Be sure to observe and follow this instructions.

DANGER! indcates an imminently hazardous situations 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 situation 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.

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

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

IMPORTANT! It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your LX100 Wood-Mizer sawmills. All Wood-Mizer mill owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the mill.

Always properly dispose of all sawing by-products, including sawdust and other debris, coolant, oil, 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 engine before changing the blade. Failure to do so will result in serious injury.

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

1.3 Sawmill Setup

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

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

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

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

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

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

WARNING! Always make sure log is clamped securely before sawing. Failure to do so may result in serious injury or death.

WARNING! Use ONLY water or alcohol solution with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the bade, 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 he 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 when returning the carriage. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

CAUTION! The saw head will hit the spring-loaded ramp stops when adjusted for low cuts. Remove the loading ramps before sawing to prevent damage to the saw head and or blade guide arm.

CAUTION! Never clean the blade or the 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! 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 EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing cover.

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 th wiper presses too firmly against the bar, it can cause the power feed to bind.

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

1.6 Safety Instructions

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

Observe Safety Instructions

IMPORTANT! Read th 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 any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings and cautions.

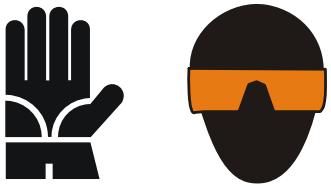
IMPORTANT! Only adult persons who have read and understood the entire operator's manual should operate th sawmill. The sawmill is not intended for use by or around children.

IMPORTANT! It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer sawmill. All Wood-Mizer sawmill owners are encouraged to becom thoroughly familiar with these applicable laws and cmply 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 resut in serious injury.



WARNING! Always wear eye, ear, respiration and foot protection 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 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 will result in serious injury.

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

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

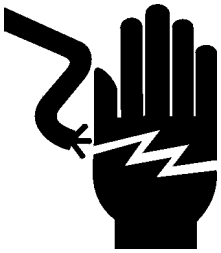
DANGER! Always be aware off and take proper protective measuresagainst rotating shafts, pulleys, fans etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.

WARNING! Use extreme caution when spinning the blade wheels by hand. Make sure hands are clear of 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 boxes and at the motor can cause shock, burns or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during sawmill operation.



WARNING! Consider all electricial circuits energized and dangerous.

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

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

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

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 using hand-held brush or scraper while the sawmill blade is in motion.

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 are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distibutor or call your Customer Service Representative to order more decals.

IMPORTANT! If replacinga component which has a safety decal affixed to it, make sure the newcomponent also has the safety decal affixed.

See Table 1-1. Pictogram decals used to warn and inform the user about danger in the LX100.

TABLE 1-1

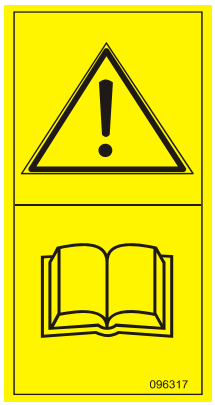
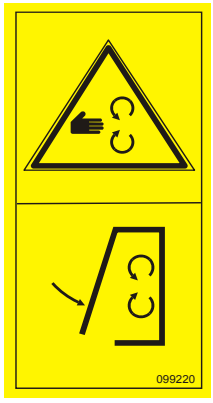
Decal View	W-M No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the machine. Observe all safety instructions and rules when operating the sawmill.
	099220	CAUTION! Close all guards and covers before starting the machine.

TABLE 1-1

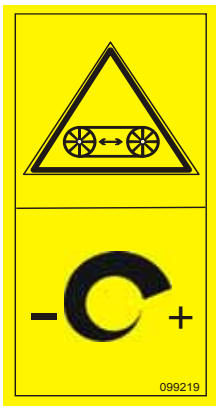
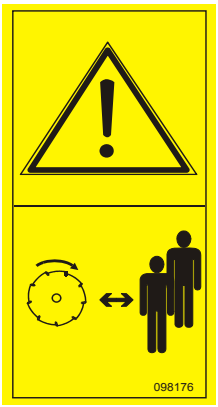
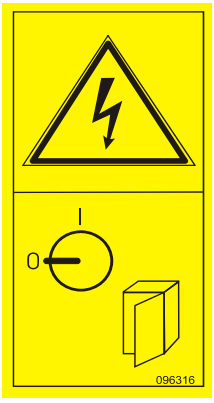
	099219	Blade tension. Turning the bolt clockwise will increase the blade tension and turning the bolt counterclockwise will decrease the tension.
	099221	CAUTION! Keep all persons a safe distance away from work area when operating the machine.
	098176	CAUTION! Keep away from debarker blade!
	096316	CAUTION! Do not open or close the electric box when the switch **is not** in the “0” position.

TABLE 1-1

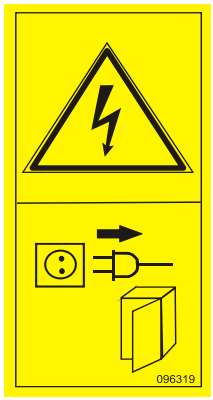
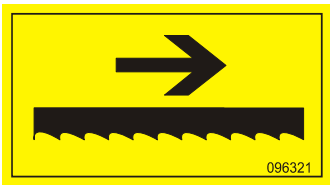
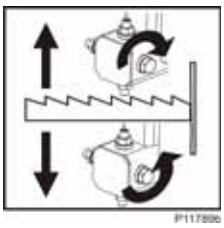
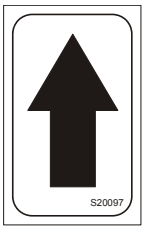
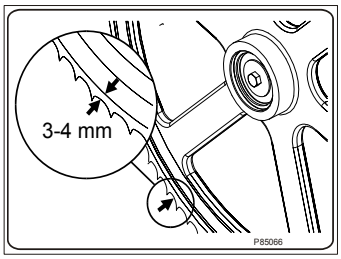
	096319	CAUTION! Disconnect power supply before opening the box.
	096321	Blade movement direction.
	S12004G	CAUTION! Always wear safety goggles when operating the sawmill!
	S12005G	CAUTION! Always wear protective ear muffs when operating the sawmill!
	501465	CAUTION! Always wear safety boots when operating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

TABLE 1-1

	501467	Lubrication Point.
	P11789	Aligning the blade on wheels.
	P85070	CE safety certification.
	099401	Russian safety certification.
	S20097	Motor rotation direction
	P85066	Blade positioning

1.7 Belt Sizes

See Table 1-2. Belt sizes for the LX100 are shown below.

Description	Belt size	Wood-Mizer Part #
Motor Drive Belt E11, E15	2BXB81	014819-2
Blade Pulley Belts	B57 [1]	P04185-2

TABLE 1-2

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

1.8 Blade Sizes

See Table 1-3. Wood-Mizer TRU•SHARP™ offers three types of blades to provide efficient sawing for all models of sawmills. The engine/motor size of your sawmill and type of wood you saw should determine which blade you choose for optimum performance.

Engine/Motor Size	Recommended Blade For Sawing [1]:		
	Softwood	**Hardwood**	**Frozen or hard-to-Cut Wood**
5 - 15 hp	B275IH1030 B275IH741030	B375IH929	B375IH929 [2]
16 hp or more	B376IH1030 B376IH741030	B275IH1030 B275IH741030 B376IH1030 B376IH741030 [3]	B375IH929[2]
Electric motor	B376IH1030 B376IH741030	B275IH1030 B275IH741030 B376IH1030 B376IH741030[3]	B375IH929[2]

TABLE 1-3

[1] LX100 sawmill is equipped with a blade with a length of 4.01 m.
[2] TRU•SHARP™ "F" blades use a 9/29 (9° hook angle and 29° back angle) and are designed to cut frozen and/or extremely dense, hard-to-cut wood. Standard TRU•SHARP™ blades use a 10/30 profile 10/30.
[3] Customer may choose preferred blade.

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

1.9 Cutting Capacity

See Table 1-4. The log size capacities of the LX100 sawmills are listed below.

	Max. Diameter	Max. Length
LX100 S2 [1]	70 cm	3,6 m
LX100 S3	70 cm	5,58 m
LX100 M2 [2]	70 cm	5,4 m
LX100 M3	70 cm	8,1 m

TABLE 1-4

[1] Each additional S type bed frame segment adds approximately 185 cm to length capacity.
[2] Each additional M type bed frame segment adds approximately 275 cm to length capacity.

See Table 1-5. The performance capacity of the LX100 sawmill is listed below. Peak cutting rates are measured in 12” (30 cm) wide red oak and represent the capability of the sawmill only. Rates based on using Tru-Sharp 1 1/4” x 0,042.

Model	Cutting Rate
LX100 E11, G18, G25, D10	3.3 m/min.

TABLE 1-5

1.10 Engine/Motor Specifications

See Table 1-6. The power options available for the LX100 sawmills are listed below.

Engine/Motor Type	Manufacturer	Model No.	Specifications
7.5 kW Motor	Siemens, Germany	1LE1002 1CA13-4AA4-Z F01+F12	3 x 400V, 50 Hz
Electric Motor E15	Indukta, Poland	PSg-132 S2 - HM	3 x 400V, 50 Hz
Up/Down Motor 0.55kW	Besel	SKh71X-4C2/HPS08	3x 230/400VAC, 50Hz
Power Feed Motor 0.55kW	Dutchi Motors, Holland	DMA 80K4	230/400V, 50 Hz

TABLE 1-6

See Table 1-7. See the table below for power supply specifications for the LX100 sawmills.

3-Phase V	Switch, Fuse	Recommended wire section
400 VAC	16 A	2,5 mm^2 to 15 m length

TABLE 1-7

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

1.11 Noise Level

See Table 1-8. The average level of noise is given in the table below[12].

Sawmill	Noise Level
LX100E11	L_{EX8} = 81,9 dB (A)

TABLE 1-8

1.12 Weights

See Table 1-9. The average level of noise is given in the table below.

Sawmill	Weight
LX100S3EH15S	746 kg
LX100S3EH15S with Debarker	797 kg

TABLE 1-9

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 uncerta. Wartość poprawki środowiskowej K=4dB.

2. The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. 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.

1.13 Dust Extractor Specifications

See Table 1-10. Specifications of the dust extractors used on the resaw for each saw head are listed below. [1]. .

Airflow	1200 m^3/h
Inlet diameter	100 mm
Motor power	1,5 kW
Number of sacks	1 pcs
Sack capacity	0.25 mp
Pressure drop	1,5 kPa (0.22 psi) [1]
Weight	110 kg
Recommended conveying air velocity in the duct	20 m/s

TABLE 1-10

[1] The pressure drop between the inlet of the capture device and the connection to the CADES should be maximum 1,5 kPa (for the nominal air flow rate). If the pressure drop exceeds 1,5 KPa, the machine might not be compatible with conventional CADES.

IMPORTANT! The dust 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 men square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0,5 m/s^2.

1. External chi and dust extraction equipment with fixed installations are dealt with in EN 12779:2004+A1:2009.

1.14 Overall Dimensions

See Figure 1-1. The verall dimensions of the LX100 sawmills with S type frames are shown below.

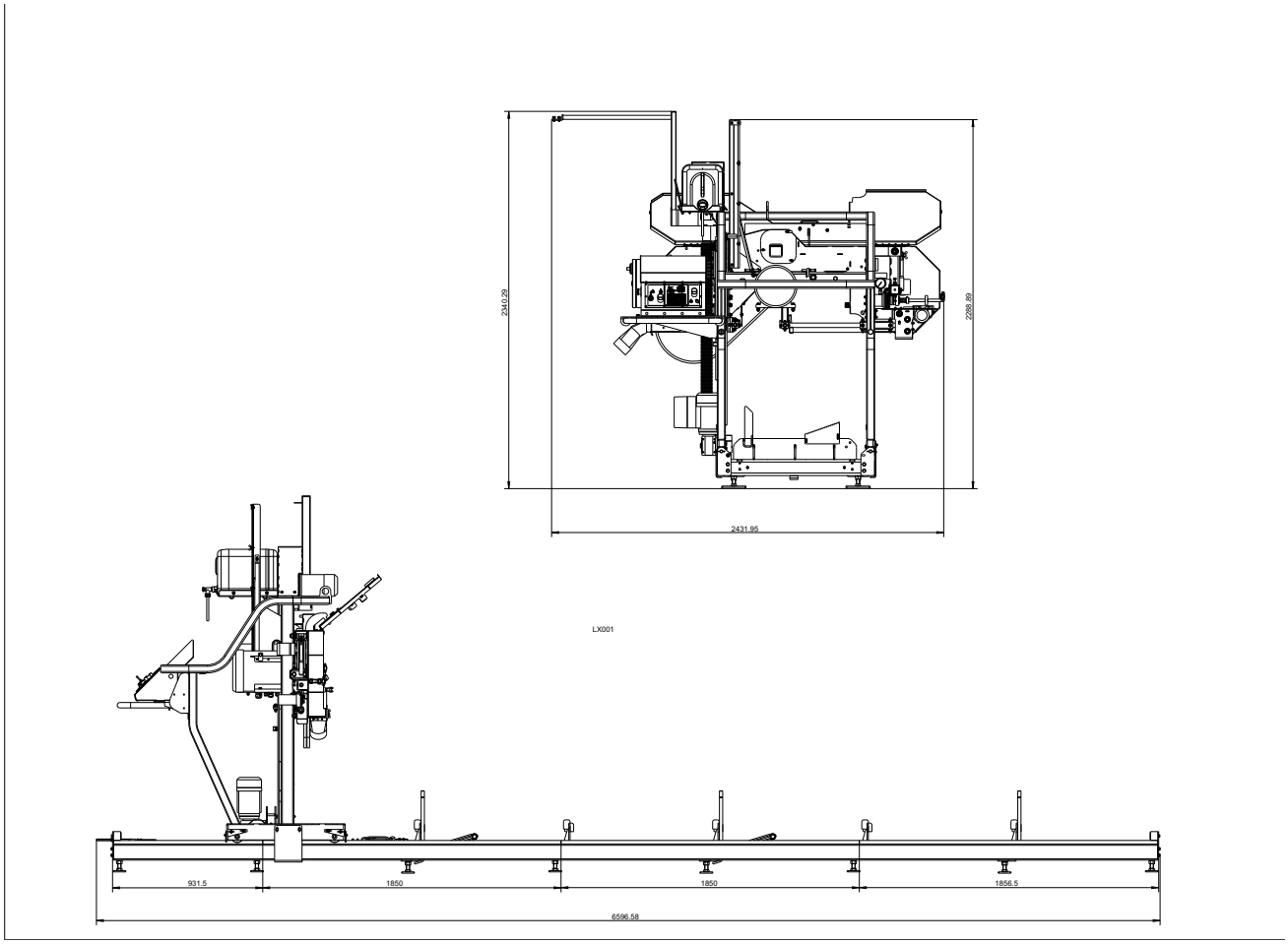


FIG. 1-1

See Figure 1-2. The sawmill operator's position is shown below.

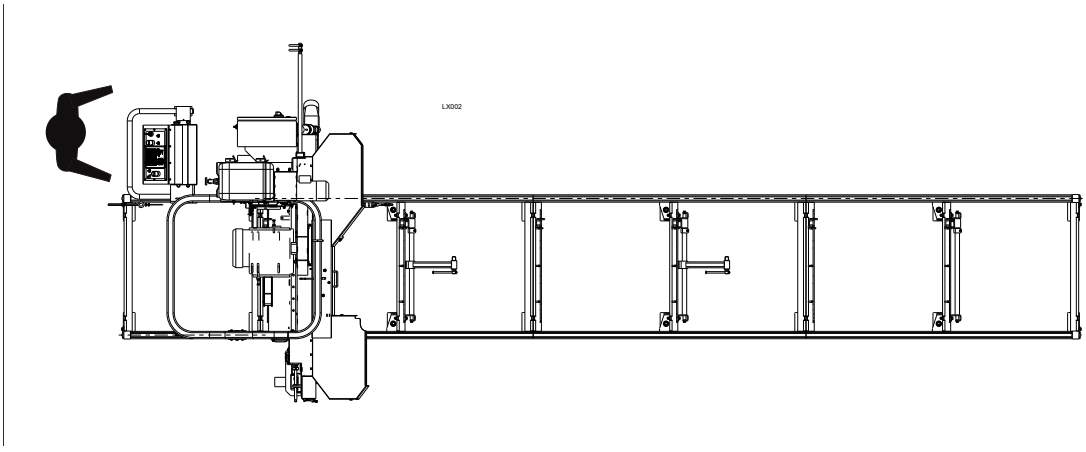


FIG. 1-2

1.15 Components

See Figure 1-3. The major components of the Wood-Mizer LX100 are shown below.

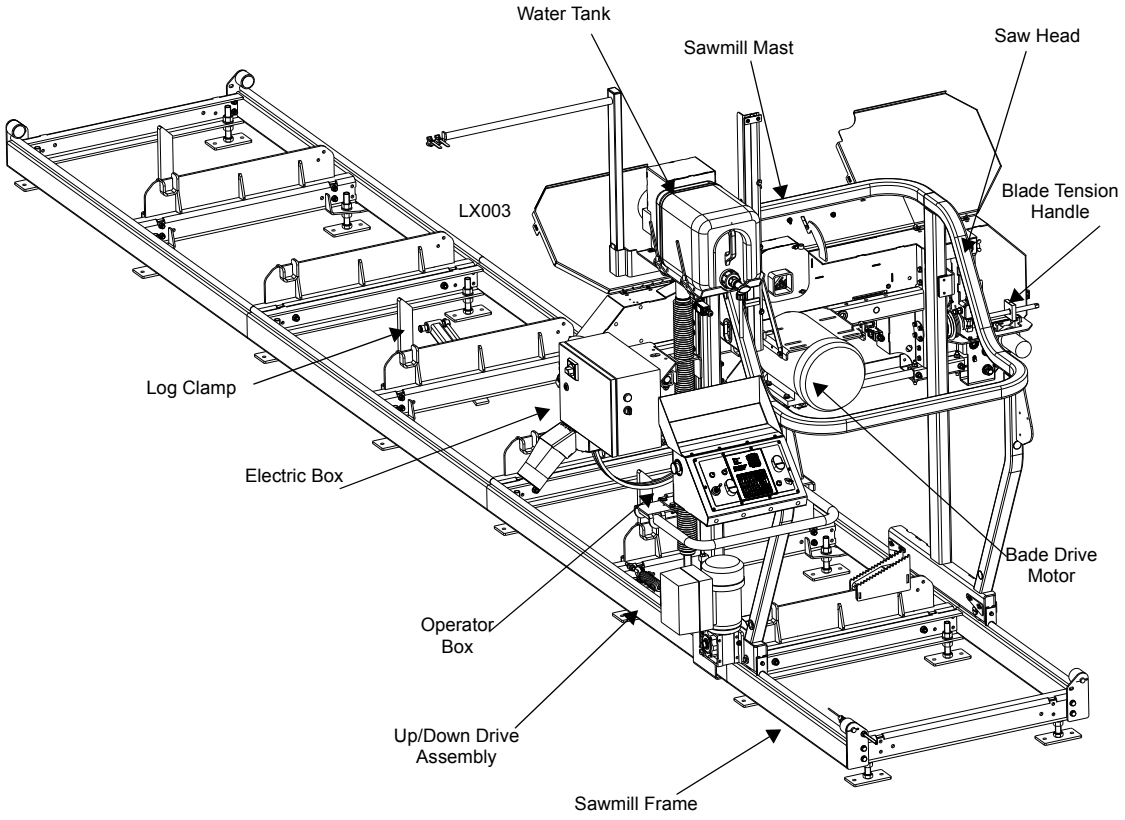


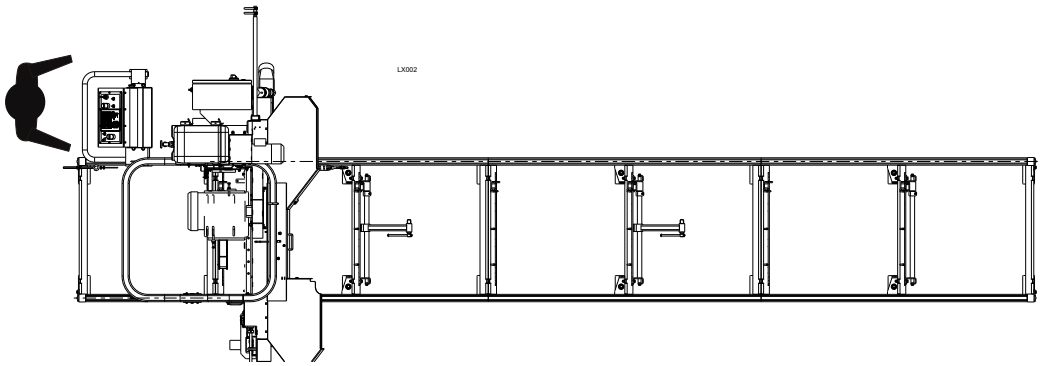
FIG. 1-3

SECTION 2 SETUP & OPERATION

2.1 Sawmill Setup

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

- Set up the sawmill on firm, level ground and level the sawmill. Secure the sawmill to the ground to prevent moving during operation. A concrete foundation or pads (rated to support 31 T/m^2 at each sawmill foot position) an 16 mm anchored bolts are recommended.
- Under roof, the sawmill should always be operated with the sawdust collection system.
- AC sawmills can't be operated outdoor when it is raining/snowing and in case of rain or snow the sawmill must be stored under roof or indoor.
- The sawmill can be operated in temperature range from -15^o C to 40^o C only.
- The illumination at the operator's should be at last 300lx.
- The sawmill operator's 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 2-1.

3-phase Volts	Fuse disconnect	Suggested Wire Size
400 VAC	16 A	2,5 mm^2 To length of 15 m

TABLE 2-1

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 (fan guard). 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 sawmills motors.

WARNING! In case of a 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 LX100 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 alignment - *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 2-8.*

The following setup procedure should be performed whenever the sawmill is moved or reassembled. If sawing problems occur and misalignment is suspected, *See SECTION 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 the operator's side of the frame. Place identical spacers between the 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 2-1.

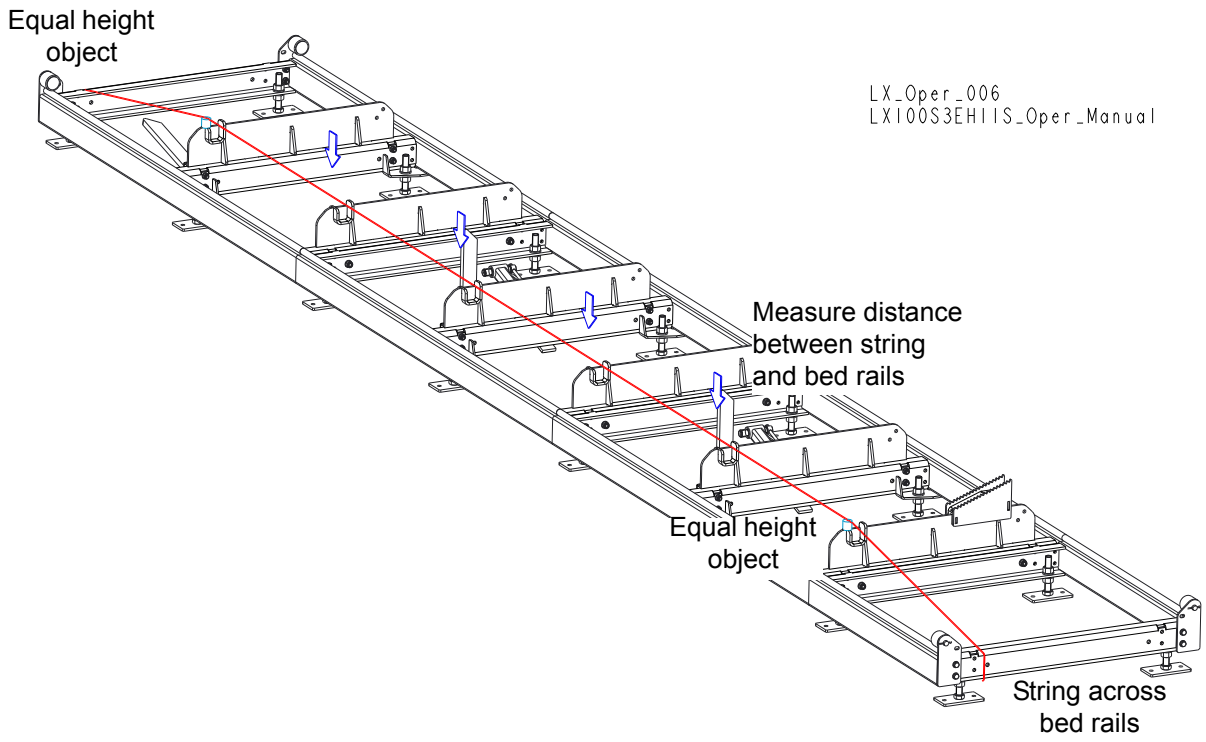


FIG. 2-1

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

5. Install a blade (*See Section 2.2* through *Section 2.4*) and move the saw head until the blade is positioned over the front bed rail.

6. The lade 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 2-2. 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. First, loosen two roller bolts (A), two scraper mounting bolts (B) and two mast retaining bracket bolts (C). To adjust the

saw head tilt, use eight mounting bolts (D) located on the roller bracket.

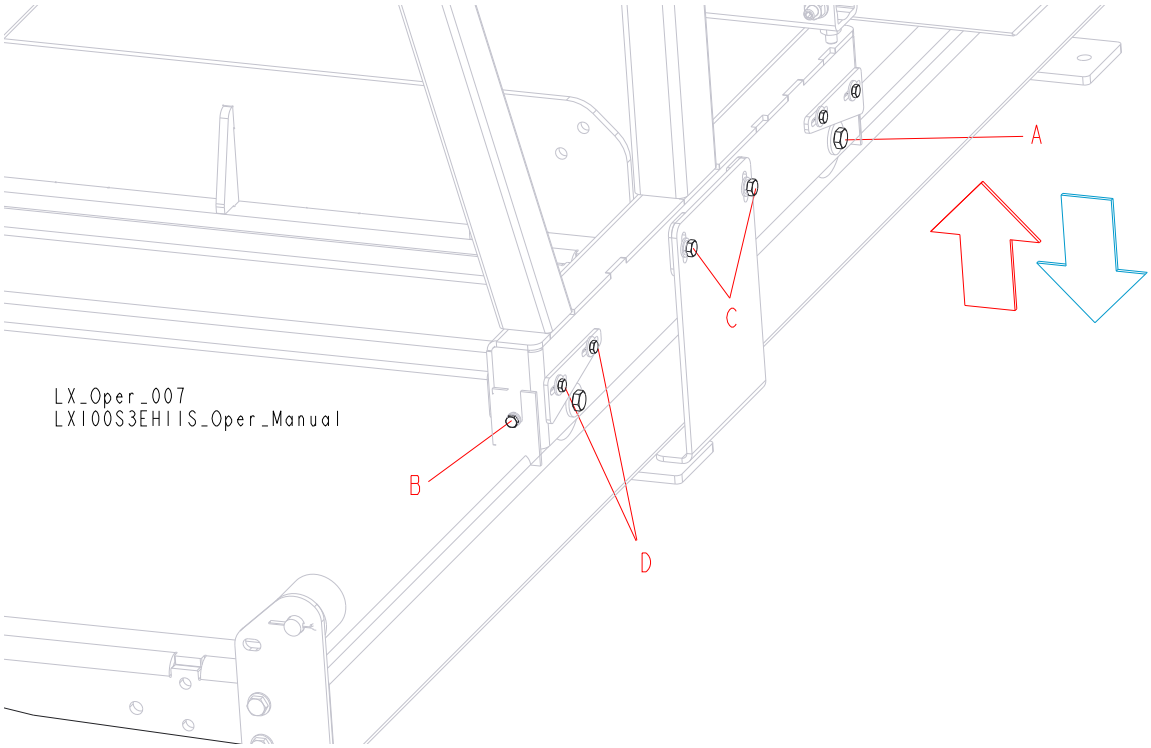


FIG. 2-2

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 2-3.

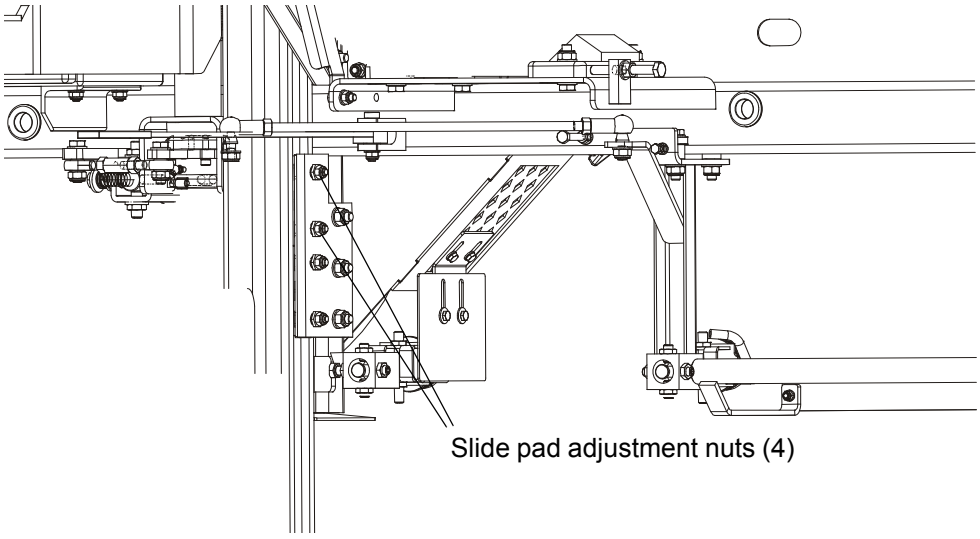


FIG. 2-3

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 2-4.

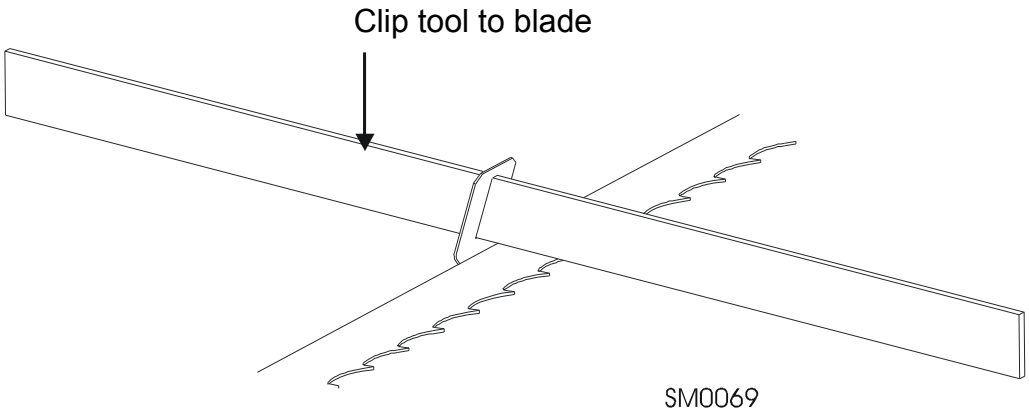


FIG. 2-4

- 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 rear 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 1,5 mm, adjust the vertical tilt of the idle-side blade wheel. *See Figure 2-5.*
- Remove the tool from the blade and reattach it near the inner blade guide. Measure the distance 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 1,5 mm, adjust the vertical tilt of the drive-side blade wheel. *See Figure 2-6.*

See Figure 2-5. 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. Tighten the top and bottom nuts.

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

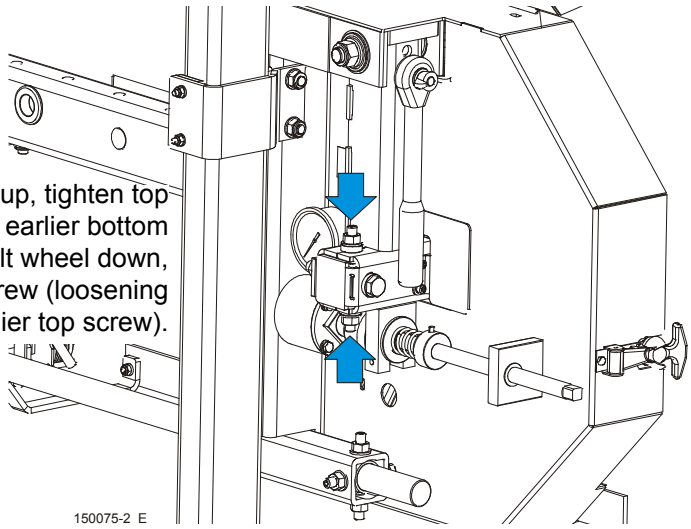


FIG. 2-5

See Figure 2-6. To tilt the drive-side blade wheel down, loosen the top adjustment screw, loosen the nut on the bottom adjustment screw and tighten the bottom screw. Tighten the top and bottom nuts.

To tilt the wheel up, loosen the bottom adjustment screw, loosen the nut on the top adjustment screw and tighten the top screw. Tighten the top and bottom nuts.

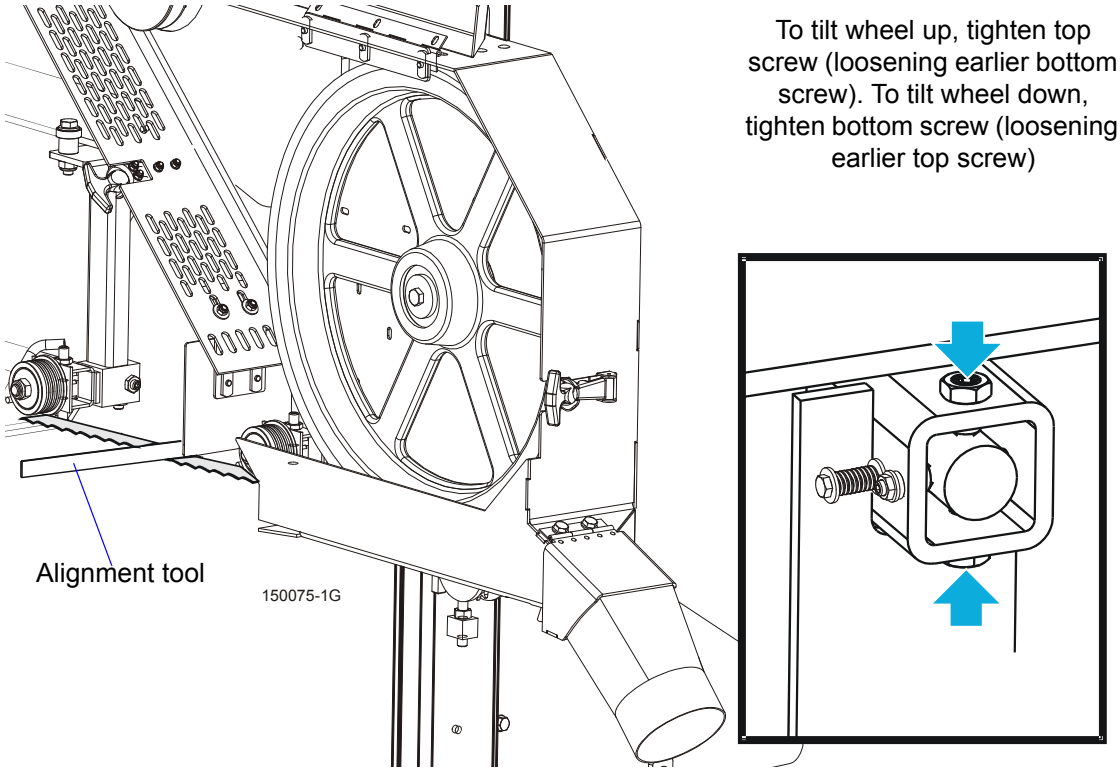


FIG. 2-6

- 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 the 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, than adjust the blade guides in the 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 o 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 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 the blade.

See Figure 2-7.

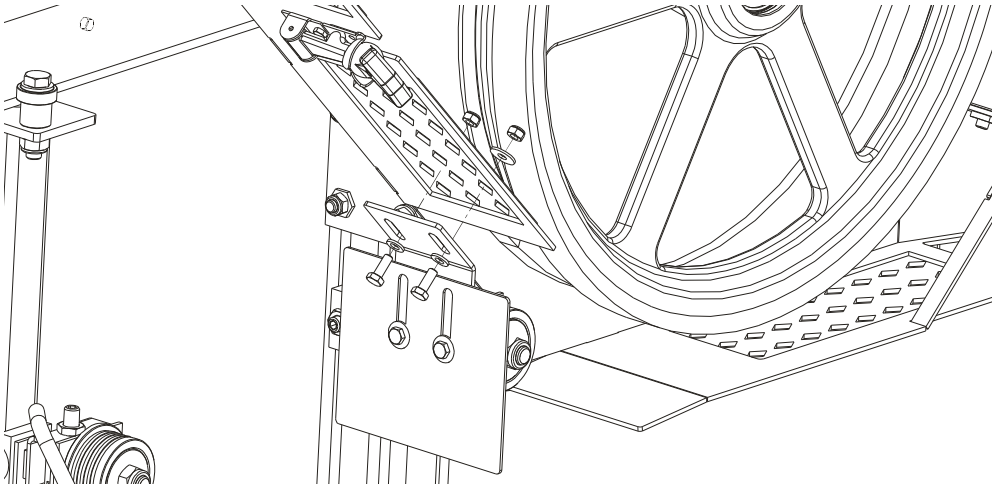


FIG. 2-7

See Figure 2-8. Adjust the cam (A) engaging the limit switch (B) as well as the saw head stop bolt (C) so that the saw head stops moving at its lower travel limit - at the height of 25 mm above the

bed.

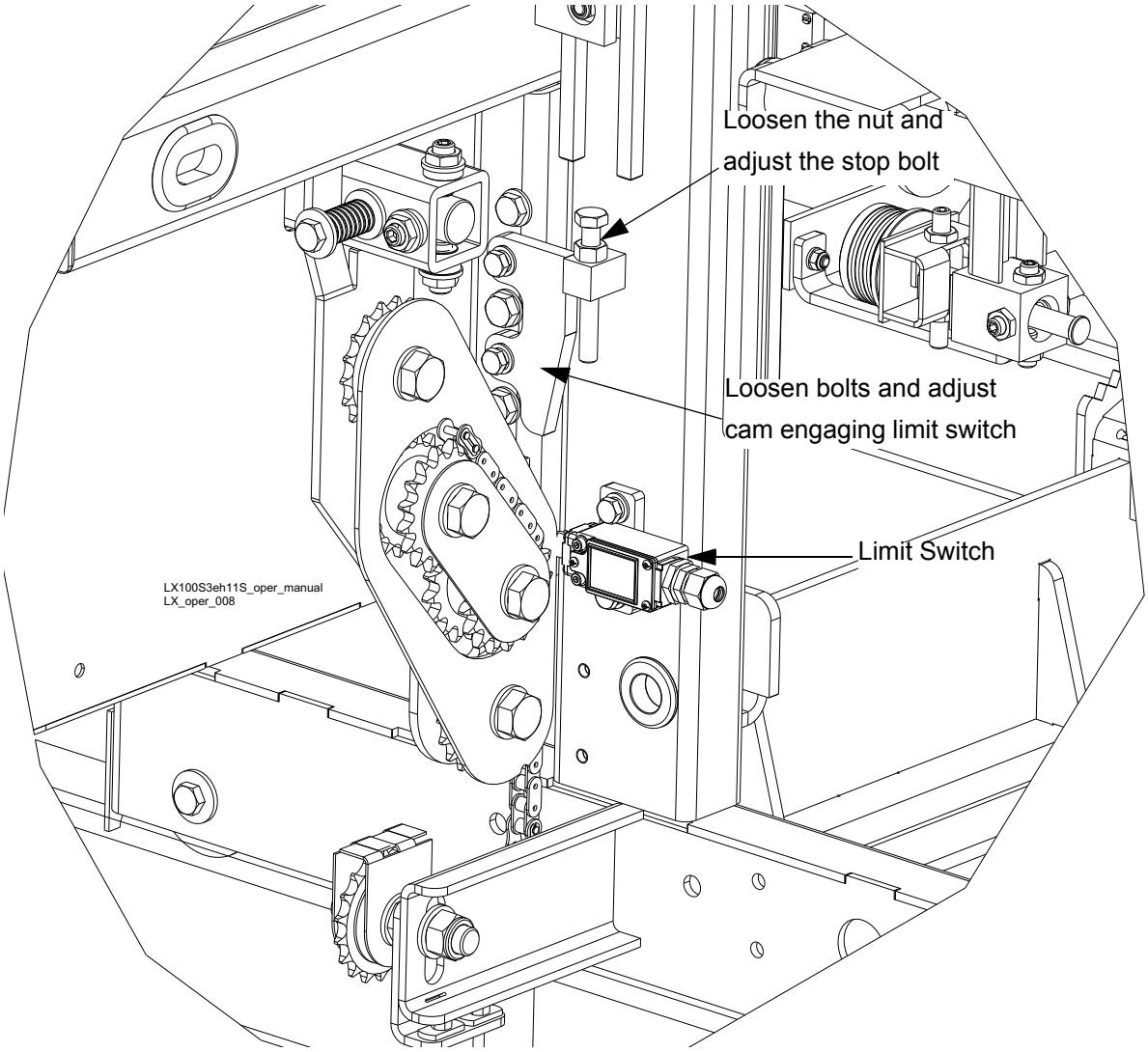


FIG. 2-8

2.2 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. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, uncoiling, carrying or changing a blade. Failure to do so may result in serious injury.

Adjust the blade guide arm all the way open.

Open the blade housing cover. Turn the blade tension handle to release the blade tension until the wheel 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 4,5 mm out from the front edge of the wheel.

Close the bed housing cover.

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

2.3 Tensioning The Blade

See Figure 2-9. 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.

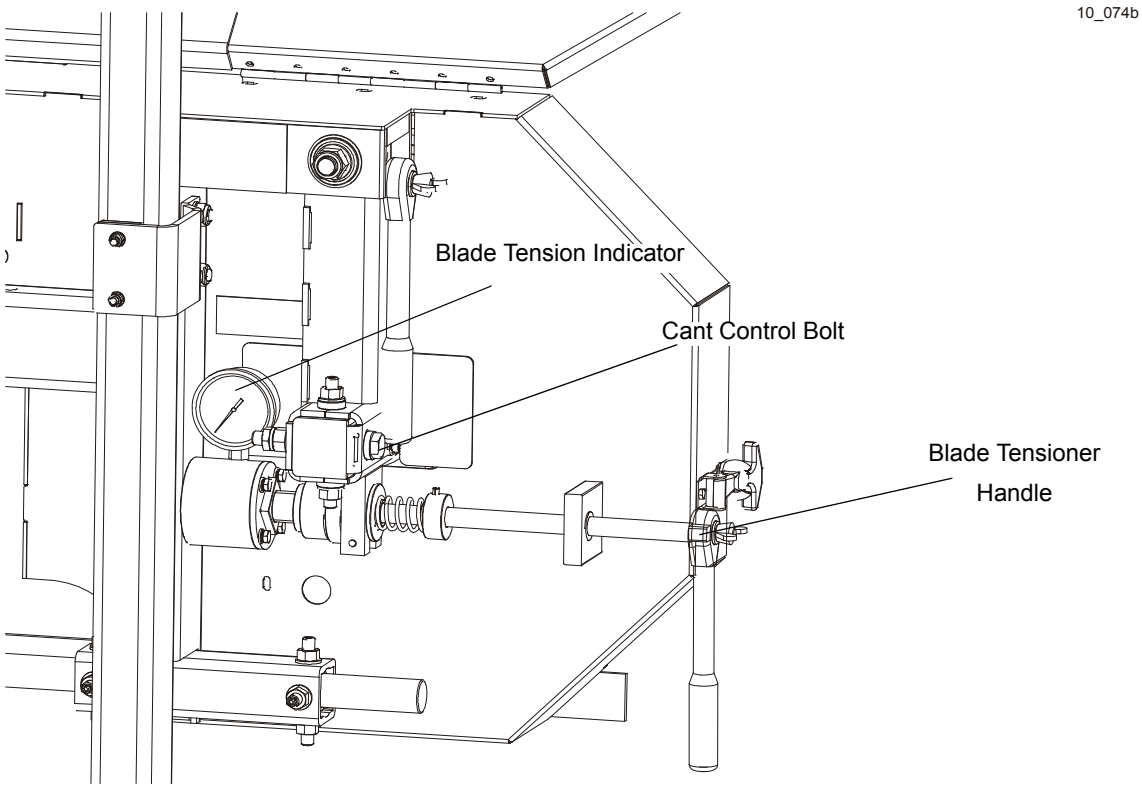


FIG. 2-9

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

Blade Type	Blade Dimensions		Tension range	
	Width (mm)	Height (mm)	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 2-2

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

2.4 Tracking The Blade

1. Make sure the blade housing cover is closed and all persons are clear 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 engine and check the position of the blade on the blade wheels.

See Figure 2-10. Position 1 1/4” wide blades so the gullet is 3,0 mm out from the edge of the blade wheel (± 0,75 mm).

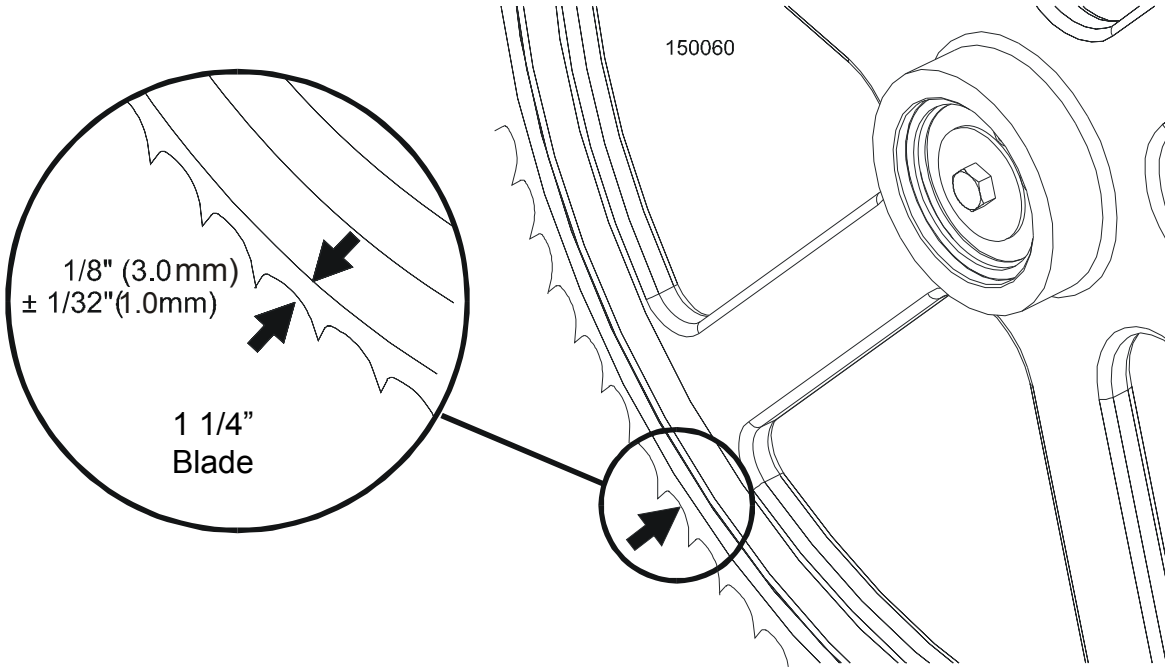


FIG. 2-10

See Figure 2-11. To adjust where the blade travels on the blade wheels, use cant control bolt.

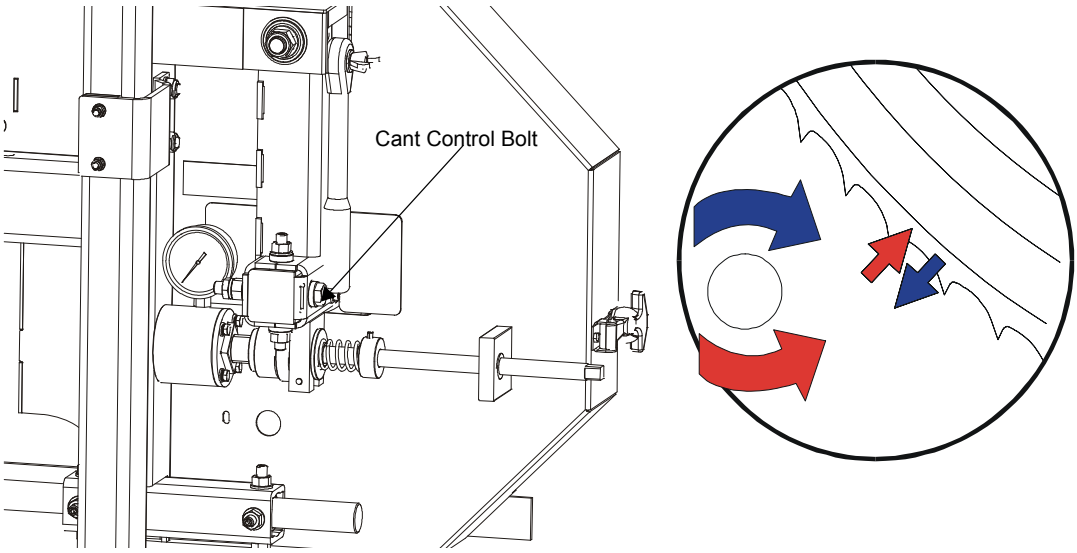


FIG. 2-11

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

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/closed 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).

2.5 Starting The 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 (fan guard). If the rotation direction is incorrect, invert the phases in the phase inverter located 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 operation 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 will result in serious injury.

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

2.6 Loading, Turning And Clamping Logs

To load logs:

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

CAUTION! Before loading a log, be sure the saw 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 the 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! The saw head will hit the spring-loaded ramp stops when adjusted for low cuts. Remove the loading ramps before sawing to prevent damage to the saw head and/or blade guide arm.

If you did not purchase the optional loading ramps, use boards for ramps or use log loading equipment to load the log on the sawmill bed.

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 logs:

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

See Figure 2-12.

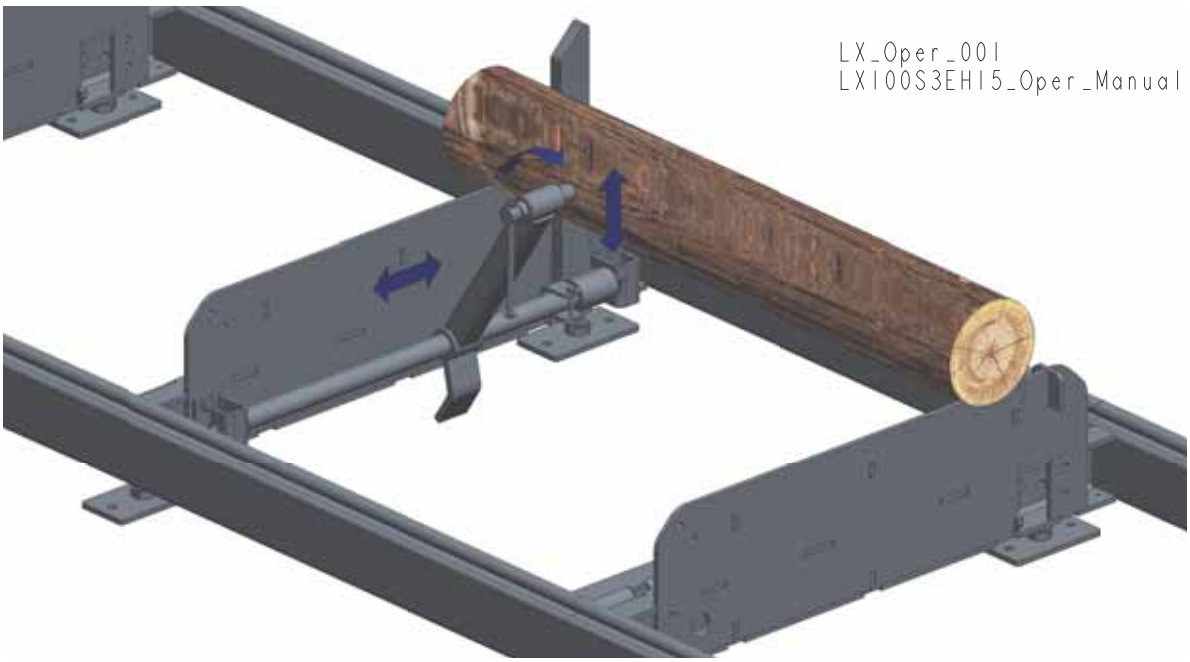


FIG. 2-12

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

See Figure 2-13.

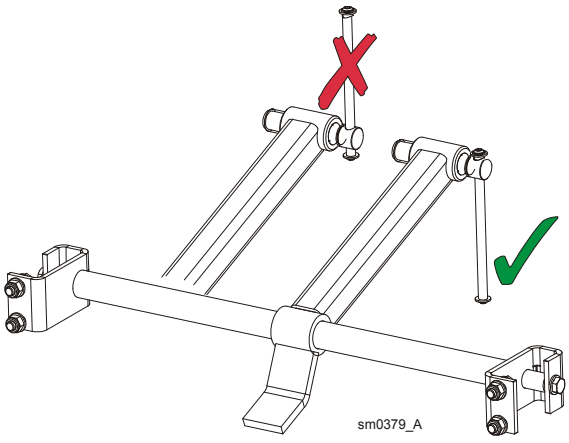


FIG. 2-13

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

To level a tapered log:

Use shims or 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 2-14.

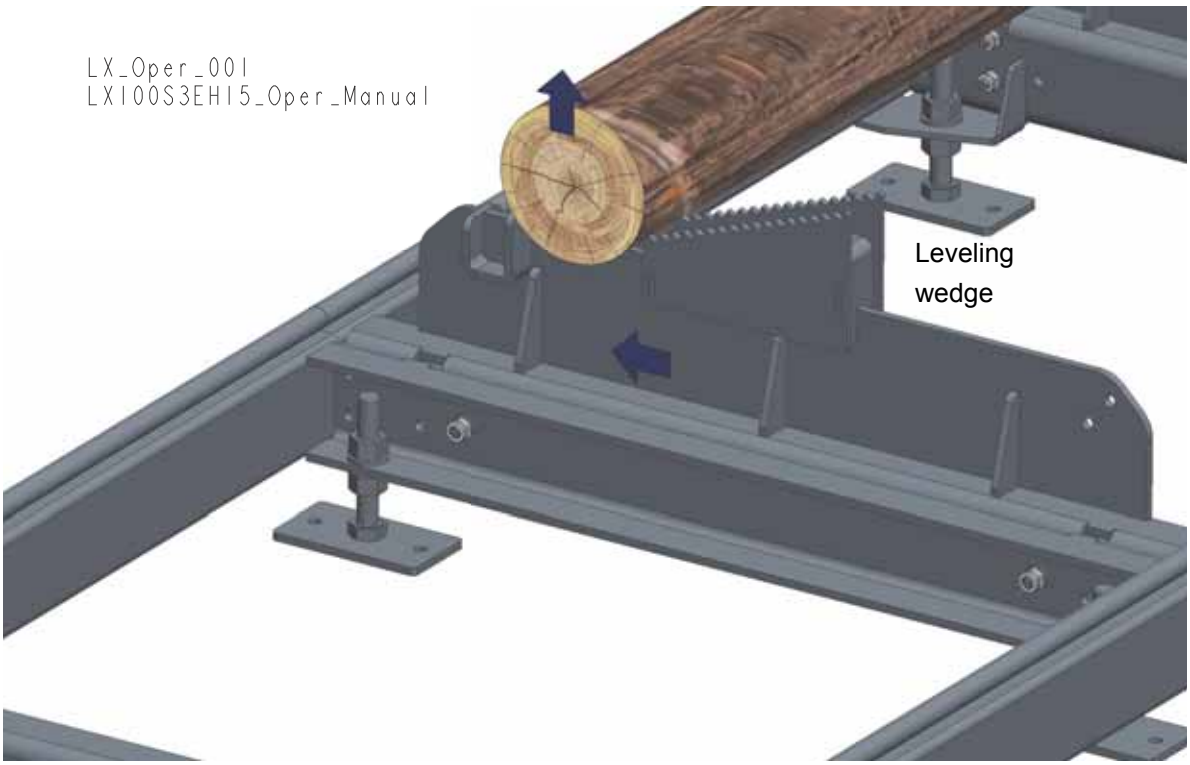


FIG. 2-14

2.7 Up/Down Operation

1. Install a blade, if needed, and check for correct blade tension (*See Section 2.3*).

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

Use the up/down button shown below to raise or lower the cutting head.

See Figure 2-15. LX100E15 .

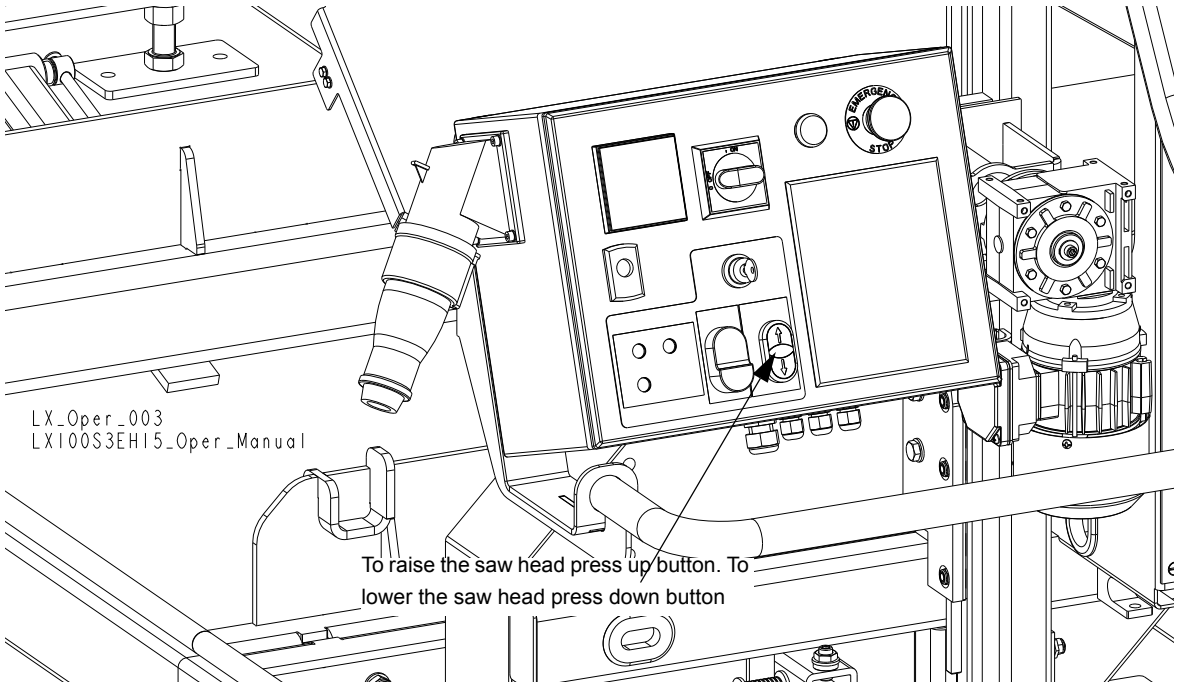


FIG. 2-15

See Figure 2-16. LX100E11S .

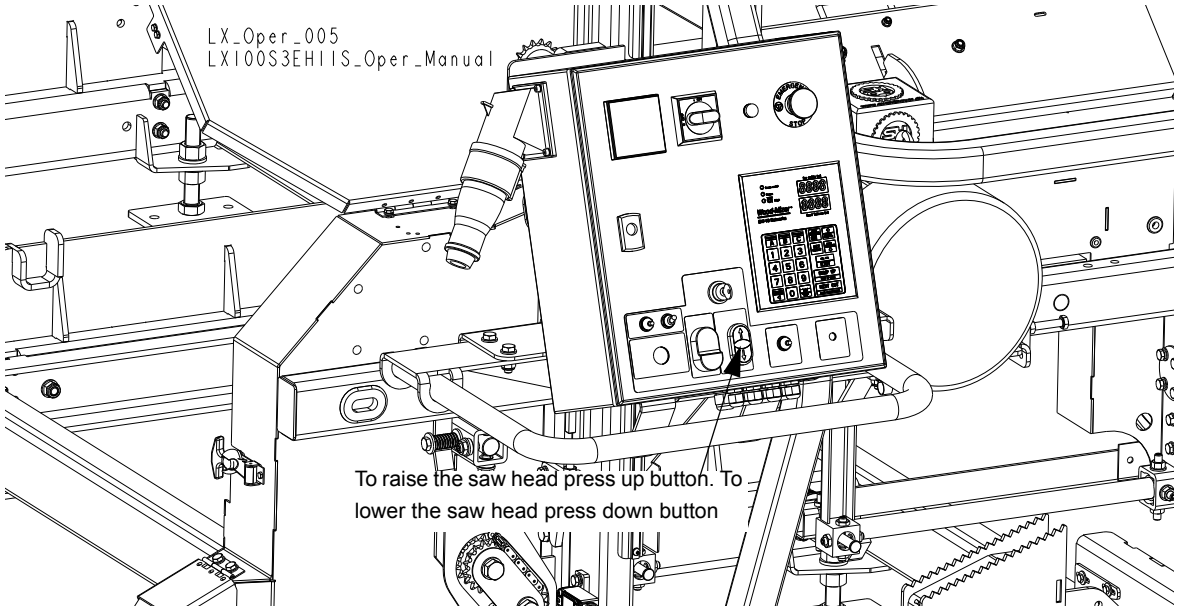


FIG. 2-16

CAUTION! DO NOT try to force the saw head above the 27” (68 cm) mark or below the 1” (2,54 cm). Failure to do so may result in damage to the up/down system.

2.8 Blade Guide Arm Operation

1. Look down the length of the log to see its maximum width. The outer blade guide roller should be adjusted to clear the widest section of the log by less than 1” (25,4mm).

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 handle left to move the arm in.

   See Figure 2-17.

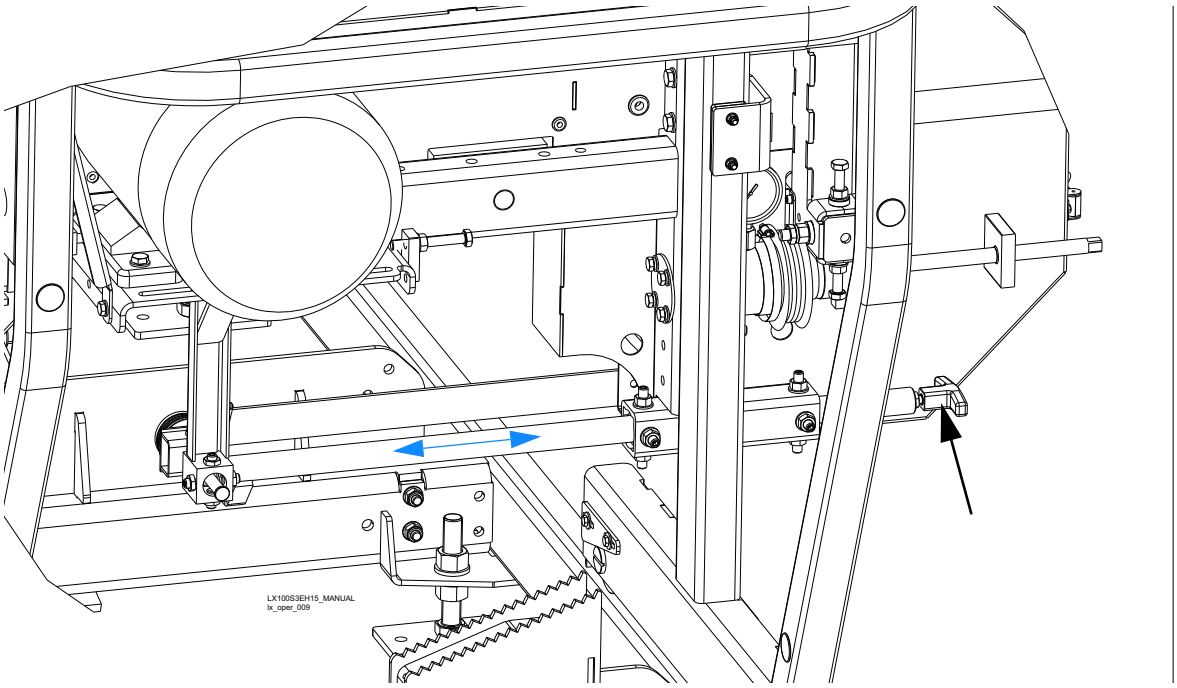


FIG. 2-17

2.9 Blade Drive Operation

DANGER! Make sure all guards and covers are in place an secured/closed. 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 the cover is open during the mill operation, the engine/motor will be stopped.

Electric motors 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 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 2-18. 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.

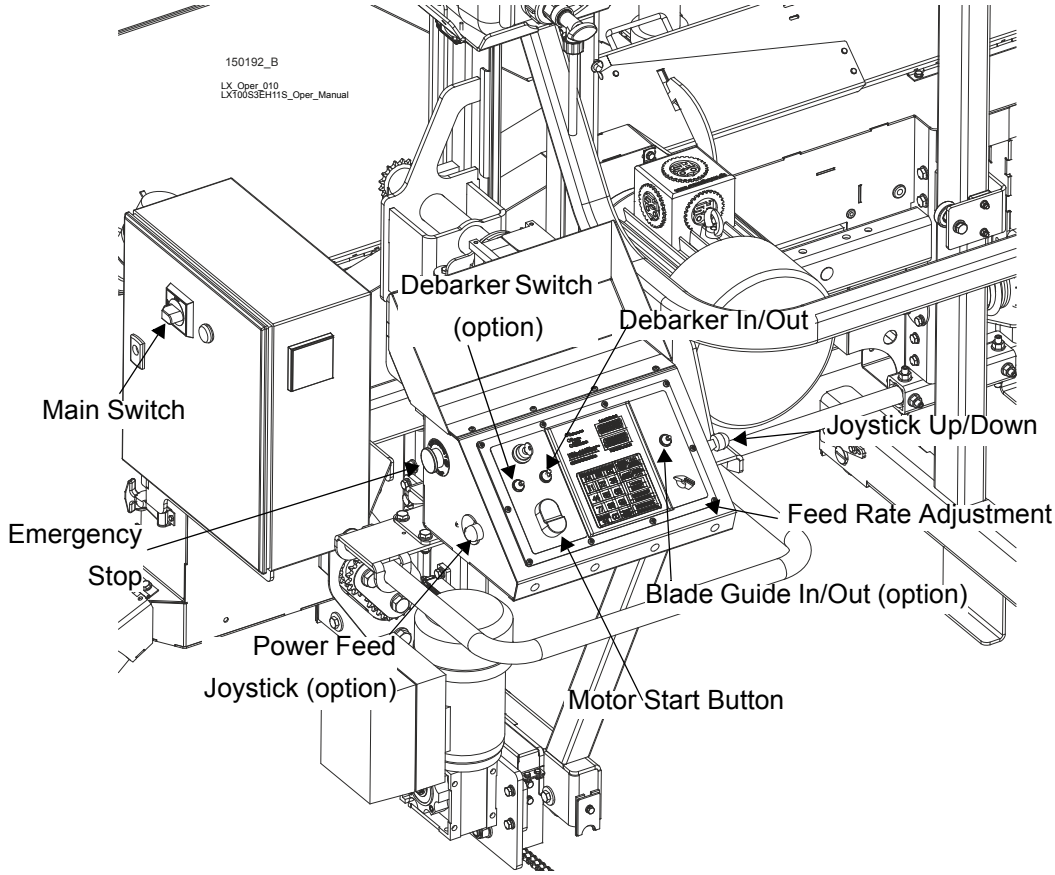


FIG. 2-18

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

2.10 Feed Operation

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

CAUTION! Be sure to stop the blade when returning the cutting 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 on 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 lade 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.

2.10.1 Optional power 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 2-19.

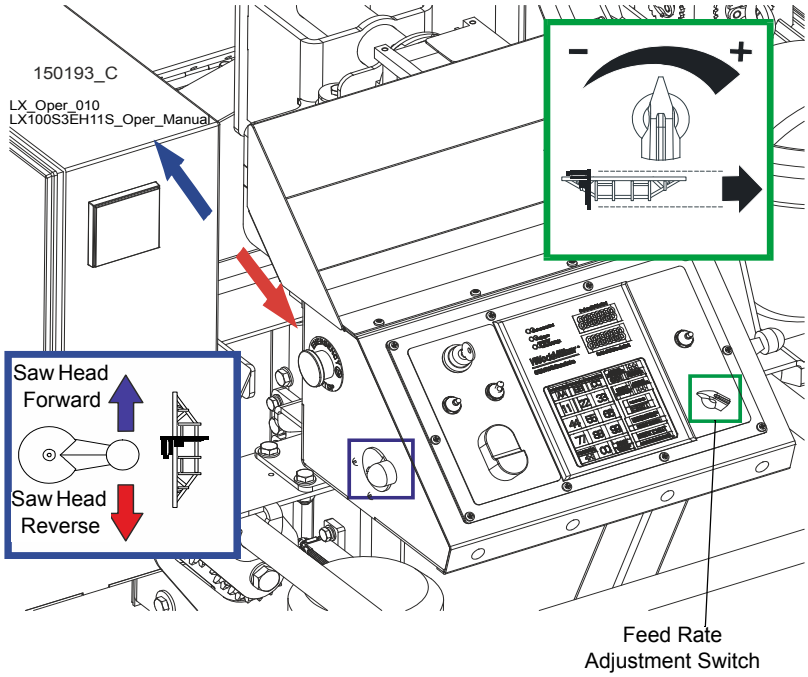
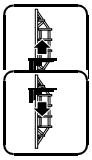


FIG. 2-19

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 power feed 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 saw head 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 harness 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.

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

2.11 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 clamped firmly, position the blade close to the end of the log.

2. Use the blade height scale to determine where to make your first cut (*See Section 2.13*). The blade height scale will help you to do this. 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 to clear the widest section of the log by moving the blade guide arm handle (*See Section 2.8*).

3. Make sure all covers and guards are in place and secured. Start the engine.

4. Start the water lube if necessary to prevent sap building on the blade (*See Section 2.14*).

5. Feed the blade into the log slowly *(See Section 2.10).* Once the log 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 lie 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 safety button on the control box. Remove the slab that you have just cut from the log.

7. Use the feed crank to return the saw head to the front of the mill. Alway disengage the blade before returning the cutting 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 on the log is placed flat against side supports if turned 90 degrees. Make sure it is placed on bed rails if turned 180 degrees. If the log was turned 90 degrees and you are using the wedge to compensate for taper in the log, use the wedge again to adjust the heart of the log parallel with the bed.

10. Repeat the steps used to cut the first side of the log until the log is square. Cut boards from the remaining cant by adjusting the blade height for the thickness of boards that you want.

Example: Remember that the blade cuts a 1/16 - 1/8” (1,6 - 3,2 mm) wide kerf. If you want 1” (25 mm) thick boards, lower the saw head 1 1/16 - 1 1/8” (27-29 mm) for each board.

2.12 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 flitches or the boards that need to be edged.
2. Stack the flitches on edge against the side supports.
3. Clamp flitches against the side supports halfway up the flitch height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other flitches or without having to pull them from the middle of the stack.)
4. Adjust the blade height to edge a few of the widest boards.
5. Loosen the 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 flitches and repeat steps 2-5.

2.13 Blade Height Scale

See Figure 2-20. The blade height scale is mounted on the vertical mast. It includes:

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

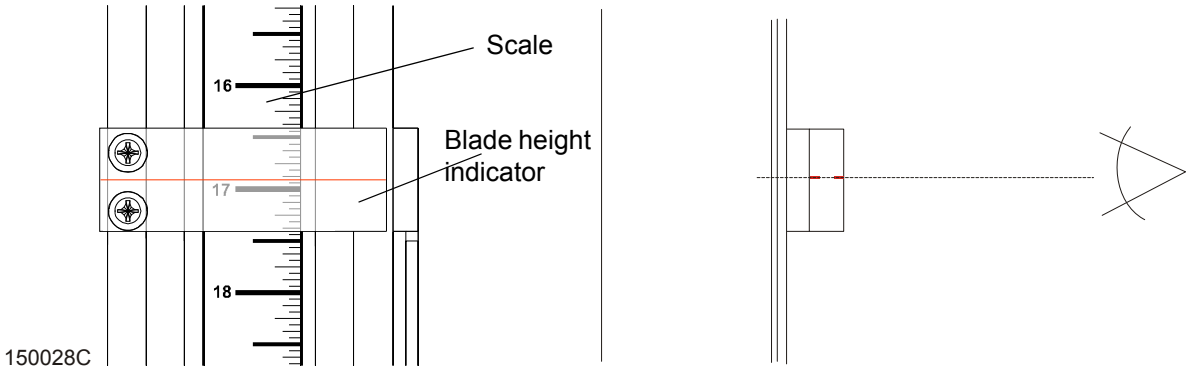


FIG. 2-20

Blade Height Indicator

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

The 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 25mm 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 29 mm below the original measurement. (the extra 3 mm allows for saw kerf ad 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 2-3. The quarter scale contains four sets of marks. Each set represents a specific lumber thickness. Saw kerf and shrinkage allowance are included, but actual board thickness will vary slightly depending on blade thickness and tooth set.

To choose which scale to use, determine what finished thickness you want to end up with. The Grade Hardwood 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	25 mm (1")
5/4	32 mm (1 1/4")
6/4	38 mm (1 1/2")
8/4	51 mm (2")

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 2-3

To use the quarter scale, look at the blade height indicator. **Example:** You want to cut 1” (25 mm) (4/4) random width boards from a log. Position the blade for the first cut. Make a trim cut. Return the saw head 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 log 90 degrees ad repeat.

2.14 Water Lube Operation

See Figure 2-21. Open the valve on the water bottle to start the water flow. A stream of water flows to the blade only when the main motor is turned on.

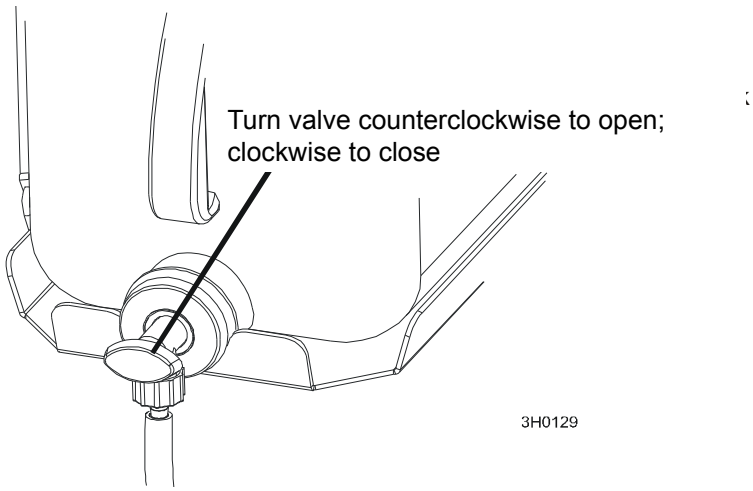


FIG. 2-21

Use just enough water to keep the blade clean. This saves water and lowers the risk of staining the boards with water. Usual flow will be 1-2 gallons (3,8 - 7,6 liters) per hour. A squirt of liquid dishwashing detergent in the water bottle will help clean the blade when cutting wood with a high sap content.

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 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.

2.15 Transporting The Sawmill

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

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

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

See Figure 2-22.

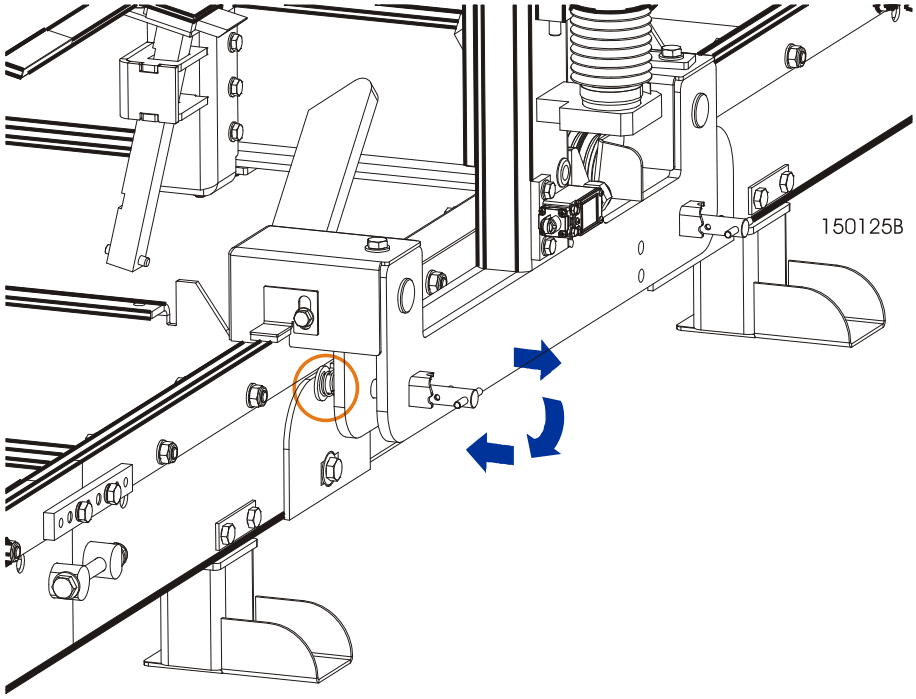


FIG. 2-22

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

4. Position the bed of th truck at the end of the frame opposite the cutting 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 cutting 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 out of the path of 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 LT15 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	
Clean And Lubricate Track	**SEE SECTION 4.3**
Remove Sawdust From Upper Cam Housings	**SEE SECTION 4.3**

WOOD-MIZER LT15 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	25O HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

WOOD-MIZER LT15 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	75O HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

WOOD-MIZER LT15 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	125O HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

WOOD-MIZER LT15 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	175O HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

WOOD-MIZER LT15 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	225O HRS	2300 HRS	2350 HRS	2400 HRS	2450 HRS	2500 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

WOOD-MIZER LT15 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	275O HRS	2800 HRS	2850 HRS	2900 HRS	2950 HRS	3000 HRS
Clean & lube mast	See Section 4.4										
Rotate drive/idle blade wheel belts/Check for wear	See Section 4.6										
Lubricate blade tensioner screw	See Section 4.5										

SECTION 3 MAINTENANCE

This section lists the maintenance procedures that need to be performed on LX100 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

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) at which each maintenance procedure should be performed.

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

3.1 Wear Life

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

Part Description	Estimated Life
B57 Blade Wheel Belts	500 hours
Blade Guide Rollers	1000 hours
Drive Belt	1250 hours
Power Feed System Steel Cable	500 hours

TABLE 3-1

3.2 Sawdust Removal

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

3.3 Carriage Track & Rollers

See Figure 3-1.

8 **1.** Clean the track bar to remove any sawdust and sap buildup every eight hours of operation. (A)

2. Make sure the scrapers fit firmly against the rail. If not, loosen the mounting bolts (B) to adjust the scrapers.

50 **3.** Every 50 hours of operation remove the power feed drive wheel cover (optional equipment) and

remove any sawdust from the wheel and cover. (C)

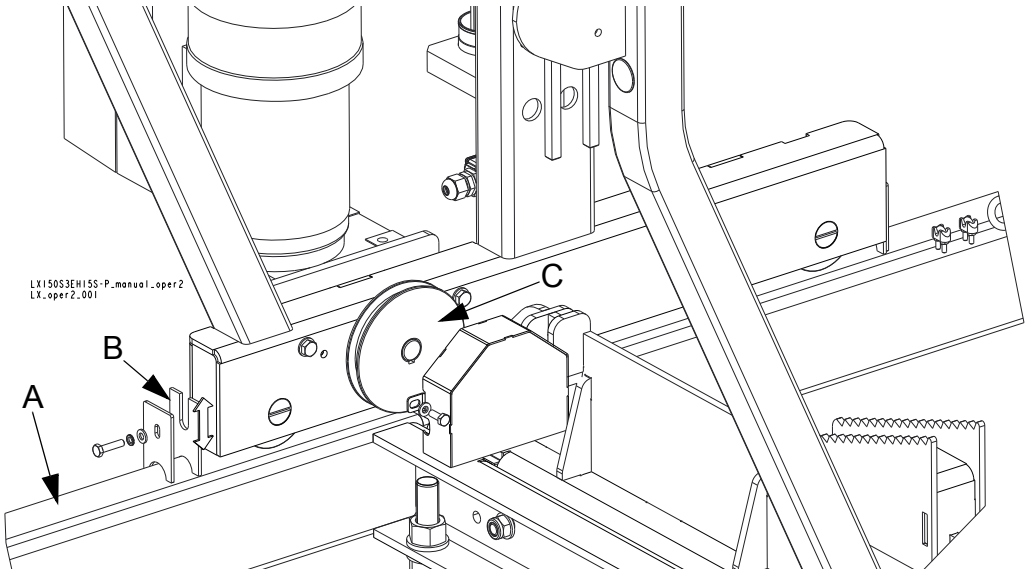


FIG. 3-1

3.4 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 Dextron III).

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

3.5 Miscellaneous Lubrication

1. 50 Check tensioner screw bellows condition every 200 hours of operation (A) and if needed, lubricate the tensioner screw with a rolling bearing grease (e.g. ŁT4S or Shell Extreme Pressure Grease).

See Figure 3-2.

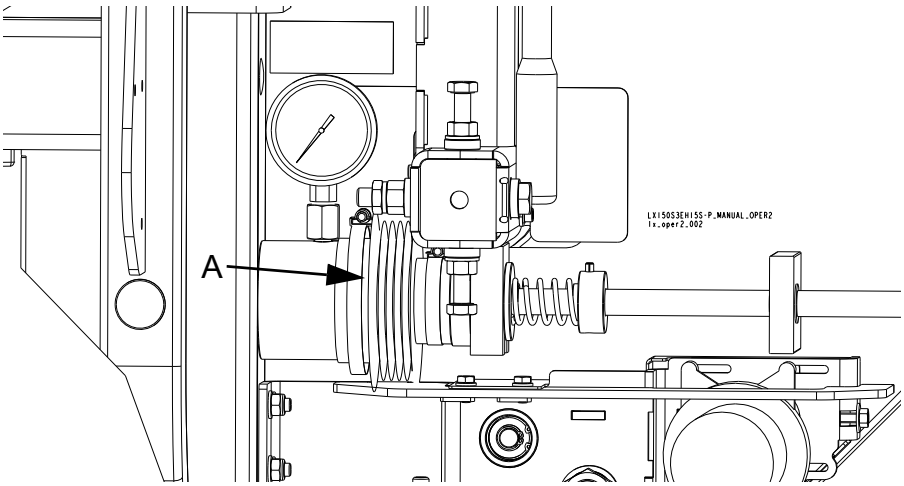


FIG. 3-2

3.6 Blade Wheel Belts

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

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

3.7 Up/Down And Feed System

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 3-3.

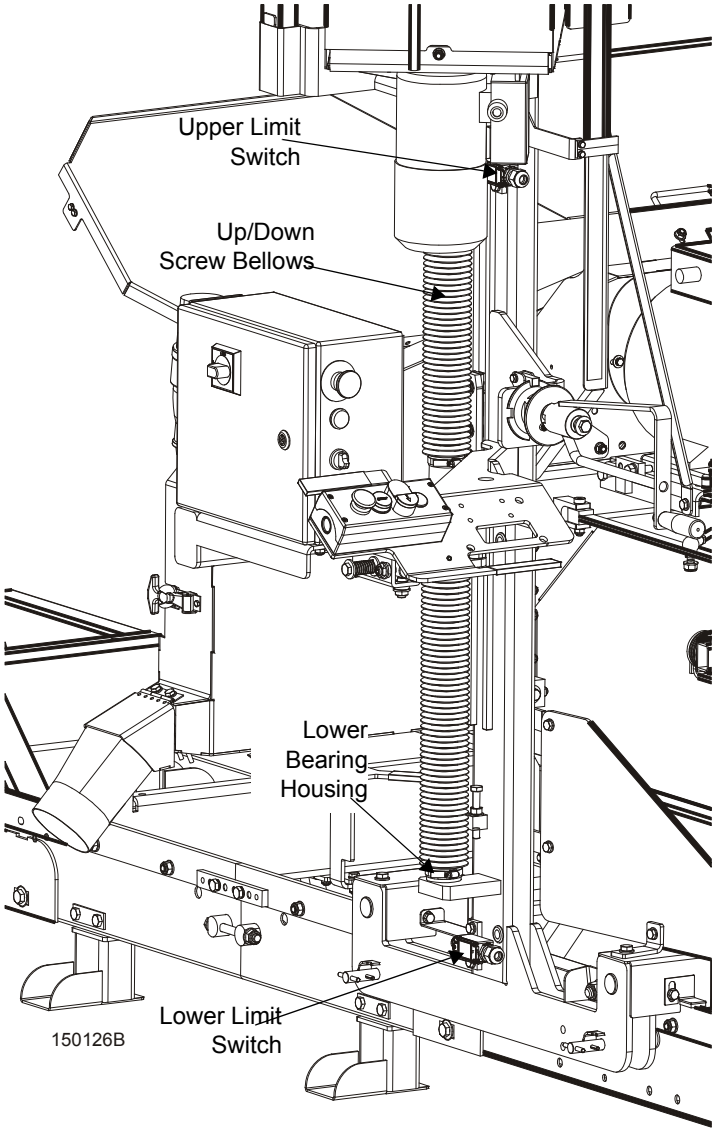


FIG. 3-3

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 throughly with extraction naphtha. The acme screw nut (Part No. 505315) should be replaced if the end play is larger than 1,25 mm.

3.8 Miscellaneous Maintenance

50

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

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

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

500

4. Check the power feed system steel cable every 50 hours, replace it every 500 hours.

3.9 Safety Devices Inspection (CE version only)

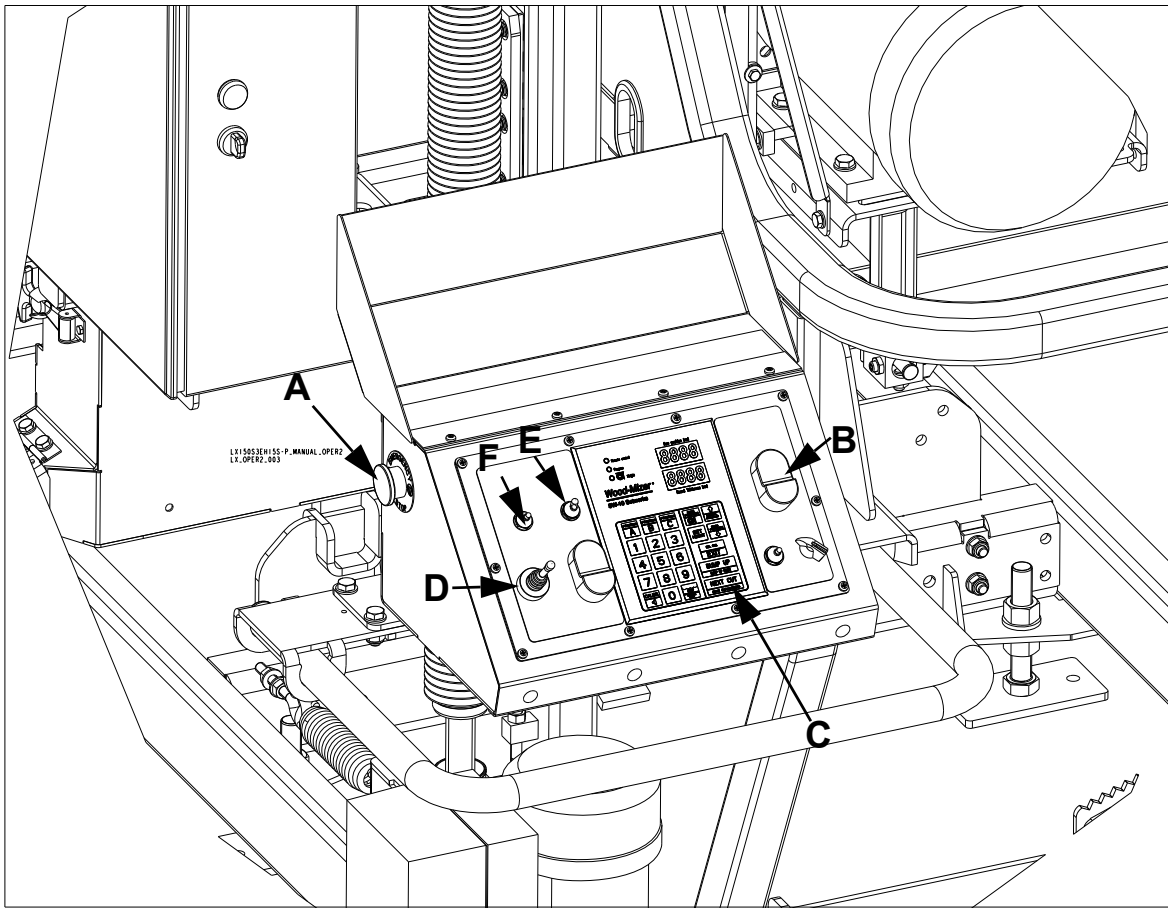
LX100 AC – Safety Devices Inspection

Safety devices on the LX100AC sawmill which must be checked before every shift:

- E-STOP button and its circuit inspection
- Inspection of the control circuits with the E-STOP button pressed
- Blade cover safety switch and its circuit inspection.
- Up/down limit switches inspection

1. E-STOP button and its circuit inspection (A)

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



2. Inspection of the control circuits with the E-STOP button pressed (A)

- Turn on the blade motor;
- 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 (B) and Setworks button (C)) and forward/backward using the power feed switch (D). Both systems should not start.
- With the E-STOP button pressed, try to start the debarker blade motor (E) and move the debarker arm (F) in and out. The debarker should not work.

4. Blade cover safety switch and its circuit inspection.

- Turn on the blade motor;
- Open the blade housing cover;
- The blade motor should be stopped;
- Try to start the motor. The blade motor should remain stopped;

- Close the blade housing cover;
- The blade motor should remain stopped until it is restarted with the START button.

SECTION 4 TROUBLESHOOTING GUIDE

4.1 Sawing Problems

PROBLEM	*CAUSE*	*SOLUTION*
Blades Dull Quickly	Dirty logs	Clean or debark logs, especially on entry side of the cut
	When grinding teeth, heating too much and causing teeth to soften	Grind just enough metal to restore sharpness to the teeth. Use water/coolant while sharpening blade.
	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Sharpener Manual).
Blades Break Prematurely	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edge of wheels.	Change blade wheel belts (B-57).
	Poor sharpening techniques	See Sharpener Manual.
	Tension too tight	Tension blade to recommended specifications.
Blade Does Not Track Right on 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. Take a board off the top. Turn the log 180 degrees. Take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut.
	Set in teeth	Resharpen and reset blade.
	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 pads.
Lumber Is Not Square	Vertical side supports not square to bed	Adjust side supports.
	Blade not parallel to bed rails	Adjust bed rails parallel to blade.
	Sawdust or bark between cant and bed rails	Remove particles.
	Tooth set problems	Resharpen and reset 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	Remove sap. Use larger amount of water flow to the blade during cutting.
	Tooth set problem	Resharpen and reset blade.

SECTION 5 MOTOR BRAKE

5.1 Maintenance/repair

Wear of spring − applied brakes

INTORQ spring − applied brakes are wear−resistant and designed for long maintenance intervals. The friction lining and the mechanical brake components are subject to function−related wear. For safe and trouble−free operation, the brake must be checked and readjusted at regular intervals, and, if necessary, be replaced. The following table describes different causes of wear and their effects on the components of the spring−applied brake. For calculating the service life of rotor and brake and determining the maintenance intervals to be observed, the relevant factors of influence must be quantified. The most important factors are the friction work, initial speed of braking and the operating frequency. If several of the causes of wear indicated for the friction lining occur in an application at the same time, the influencing factors must be added for calculating the wear.

Inspections

To ensure safe and trouble−free operation, spring−applied brakes must be checked and maintained at regular intervals. Servicing can be made easier if good accessability of the brakes is provided in the plant. This must be considered when installing the drives in the plant. Primarily, the necessary maintenance intervals for industrial brakes result from the load during operation. When calculating the maintenance interval, all causes for wear must be taken into account.If the brakes are not maintained, failures, production outages or plant damages may be the result. Thus, a maintenance concept adapted to the operating conditions and loads of the brake must be developed for every application. The maintenance intervals and maintenance work listed in the following table must be scheduled for the spring−applied INTORQ brake.

Maintenance intervals

Service brakes	■ according to service life calculation ■ otherwise every six months ■ after 4000 operating hours at the latest

TABLE 5-1.

5.2 Maintenance

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 12-2*
- Replace the complete rotor if necessary.

Check 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 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 12-2

Wood-Mizer
from forest to final form

EC declaration of conformity

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

We herewith declare,

Wood-Mizer Industries Sp. z o.o.
114 Nagorna street, 62-600 Kolo; Poland.

That the following described machine in our delivered version complies with the appropriate basic 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.

Designation of the machine:	**SAWMILL**
Model:	LX100
TYPE:	……
No. of manufacturer:	……
Applicable EC Directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2004/108/EC
Applicable Harmonized Standards:	PN-EN ISO 12100:2012 PN-EN 1807-2:2013-08 PN-EN 953+A1:2009 PN-EN 349+A1:2010 PN-EN ISO 13849-1:2008 PN-EN 60204-1:2010 PN-EN ISO 13857:2010
Notified Body according to annex IV :	INSTYTUT TECHNOLOGII DREWNA Centrum Weryfikacji Wyrobów Przemysłu Drzewnego ul. Winiarska 1, 60-654 Poznań
Notification No	1583
Responsible for:	EC type examination
EC type-examination certificate no.	0483/2016
Responsible for Technical Documentation:	Adam Kubiak / R&D Manager Wood-Mizer Industries Sp. z o.o. 62-600 Koło, ul. Nagórna 114, Poland Tel. +48 63 26 26 000
Place/Date/Authorized Signature:	Koło, 22.02.2016 Adam Kubiak
Title:	R&D Manager