

## 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  
Behåll för framtida användning  
Uchovejte pro další použití  
Hranite za prihodnje uporabo



# **Wood-Mizer®**

## **Safety, Setup, Operation, Maintenance and Parts Manual**

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**MP100 E5S  
MP150 E5S**

**rev. A1.06  
rev. A1.05**

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

*March 2010*

*Form #908*

**This is the original language  
for the manual**

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## SECTION 1 INTRODUCTION

Thank you for choosing Wood-Mizer wood processing equipment!

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.

The present documentation contains information that should be used when preparing the machine for operation, working with it and when servicing or repairing it, as well.

### 1.1 Machine Description

The Wood-Mizer moulder is designed for planing, thickening and moulding lumber. The machine must not be used for other purposes.

The moulder is equipped with one horizontal cutter adapted for mounting planing knives as well as moulding knives.

Using the machine correctly, you will obtain a perfectly smooth surface and a high degree of accuracy.

The moulder should be operated only by an adult who has read and understood the entire operator's manual.

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

In case of moulders equipped with manual feed system, the moulding head should be moved by using the crank handle only to ensure operator safety and best accuracy. The operator must not try to push the moulding head by hand.

# 1

## INTRODUCTION

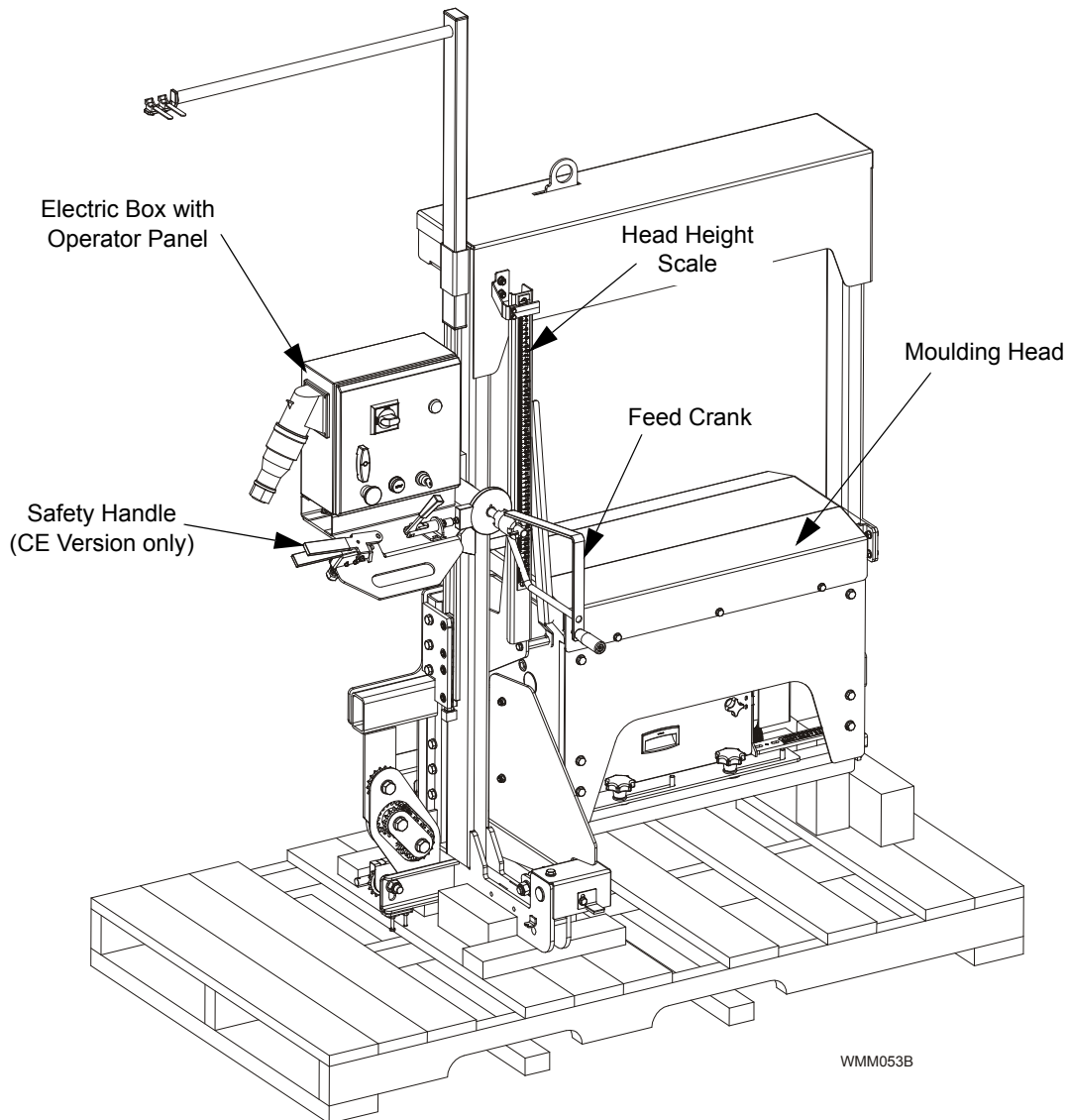
### Machine and Site Preparation

## 1.2 Machine and Site Preparation

The Wood-Mizer moulder is delivered on a pallet. Due to the weight, it has to be transported with auxiliary carrier equipment and in accordance with general safety rules.

The moulder must be installed in the work-place as instructed in the operator's manual. To ensure safe operation of the machine, the work-place dimensions should be 3 m x 10 m. If your machine is equipped with additional bed sections, prepare an appropriately larger work area. The work-place must be protected from rain and snow.

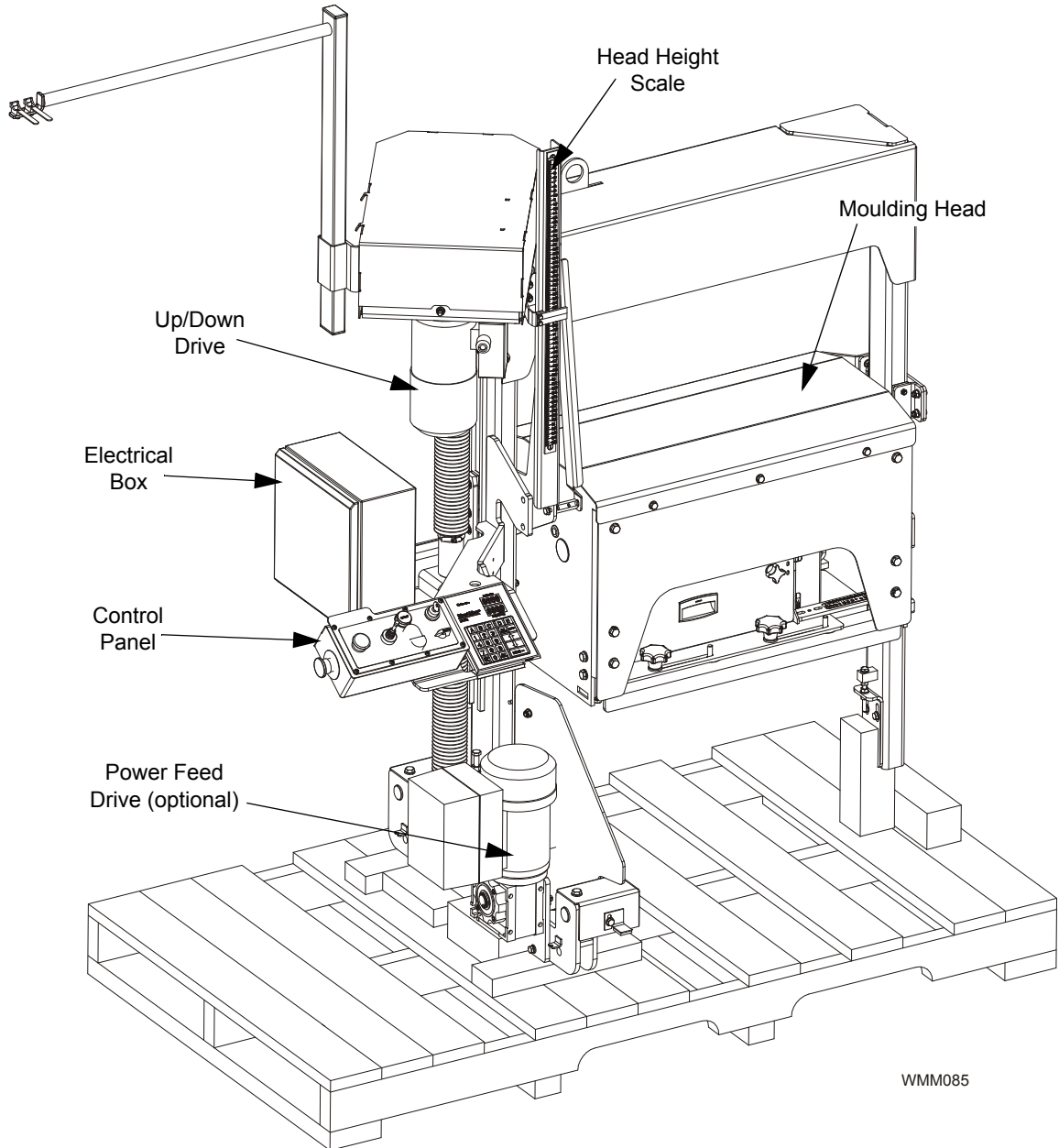
## 1.3 The major components of the moulder



WMM053B

**FIG. 1-0 MP100**





WMM085

FIG. 1-0 MP150

## 1.4 If You Need To Order Parts

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Kolo, Nagórna 114 St, Poland at **+48-63-2626000**. From the continental U.S., call us toll-free at **1-800-525-8100**. Please have the machine 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. In most cases, items will ship on the day they are ordered. Second Day and Next Day shipping are available at additional cost.

## 1.5 If You Need Service

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Kolo, Nagórna 114 St, Poland at **+48-63-2626000**. From the continental U.S., call us toll-free at **1-800-525-8100**. Ask to speak with a Customer Service Representative. Please have your 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 moulder. He can also schedule you for a service call.

### Office Hours:

Country	Monday - Friday	Saturday	Sunday
Poland	7 <sup>00</sup> -15 <sup>00</sup>	Closed	Closed
US	8 a.m.- 5 p.m.	8 a.m.- 5 p.m	Closed

## SECTION 2 SAFETY

### 2.1 Safety Symbols

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



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



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



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



**IMPORTANT!** indicates vital information.

**NOTE:** gives helpful information.



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

### 2.2 Safety Instructions

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

#### *Observe Safety Instructions*



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

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

Only persons who have read and understood the entire operator's manual should operate the moulder.

**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 machines. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the moulder.

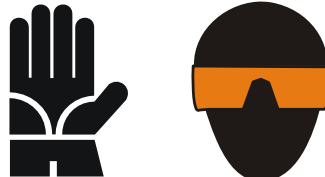


### Wear Safety Clothing



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

**WARNING!** Always wear gloves and eye protection. Failure to do so may result in serious injury.



**WARNING!** Always wear ear, respiration and foot protection.



### Keep Moulder And Area Around Clean



**DANGER!** Maintain a clean and clear path for all necessary movement around the moulder 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 Moulder Before Operation



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



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

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

### Keep Persons Away

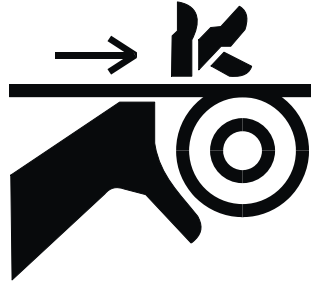


**DANGER!** Keep all persons at a safe distance of at least 3 meters from the machine when operating the moulder. Failure to do so will result in serious injury.

### Keep Hands Away

**DANGER!** Moving Parts Can Crush and Cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating. Failure to do so may result in serious injury.

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



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

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

**IMPORTANT!** The knives housing cover is equipped with a safety key switch. As soon as you open the cover, the motor will be turned off and all moving parts will stop spinning. The safety switch should always be in proper working condition.

### **Moulder Operation**

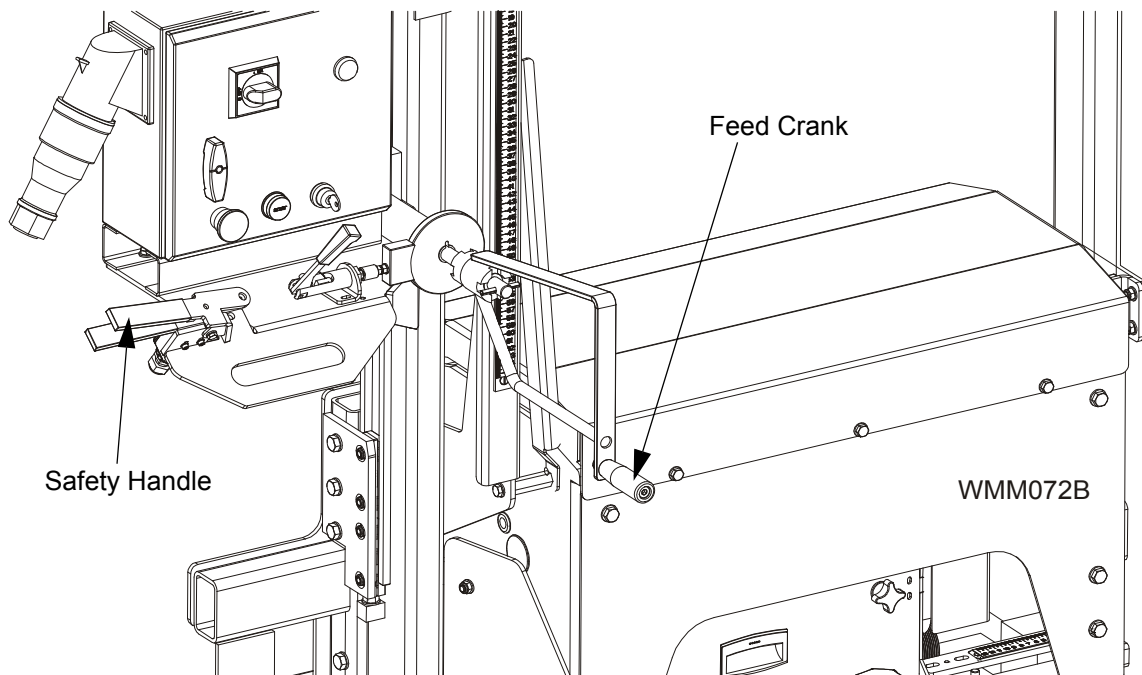


**CAUTION!** Always operate the moulder in good light conditions. The illumination at the operator position should be at least 300 lx. Never operate the moulder under the influence of alcohol or drugs.





**DANGER!** Always firmly hold the safety handle and the feed crank. Be aware that the moulding head can move towards you when you are working with hard wood or if the material is not secured properly. The planing head can be moved by using the crank only. Never push/pull


the planing head manually.



**FIG. 2-1**

 **WARNING!** Be sure that the cutting knives are firmly mounted before starting the motor.

 **IMPORTANT!** When starting the machine for the first time, make sure that the cutter rotation direction is as indicated by the arrow located on the side cover. If the rotation direction is incorrect, invert the phases in the phase inverter located in the power socket (UL Version, 3-phase). Setting the phases in the phase inverter correctly will ensure the correct cutter rotation direction.

 **DANGER!** To check the cutter rotation direction, look at the motor fan when the motor is starting or stopping through the inspection window shown below. Do not for any reason check the rotation direction by touching the cutter using any tool or a piece of wood. Doing so may result in serious injury or death.

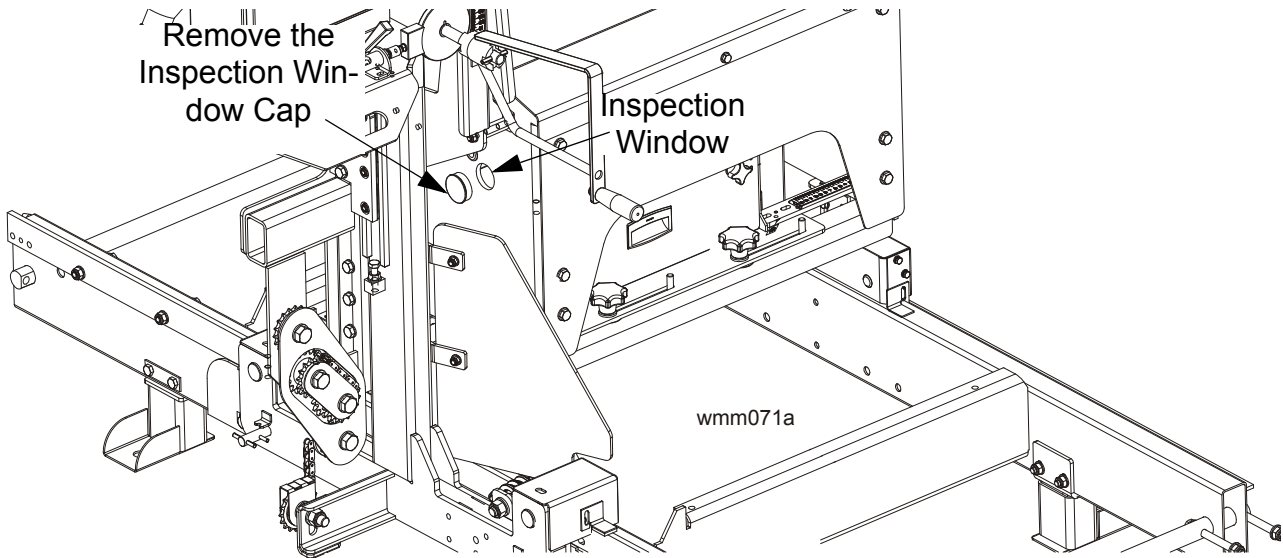



FIG. 2-2

 **DANGER!** It is allowed to mould/plane only in the direction shown below. Never try to mould/plane in the opposite direction (when you return the head).

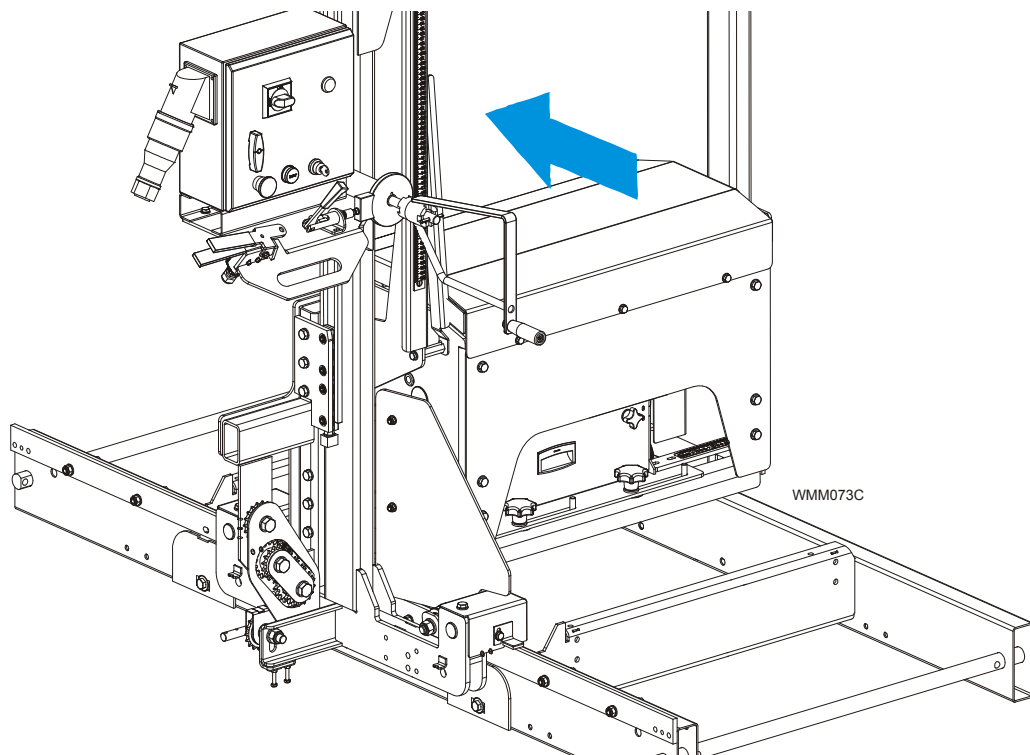


FIG. 2-3



## Use Proper Maintenance Procedures



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

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



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

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

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



**IMPORTANT!** The moulder is equipped with an emergency stop button. This button is used to immediately stop the motor in hazardous situations. The emergency stop button should always be in proper condition.

**IMPORTANT!** The machine must not be modified by the owner. Use only original spare parts.

## Keep Safety Labels In Good Condition



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

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




**Fire-Fighting**

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

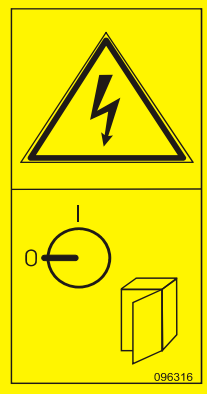
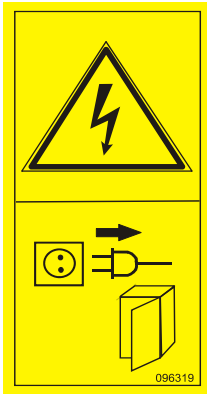


**Safety Labels Description**

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



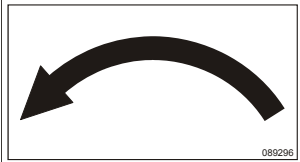
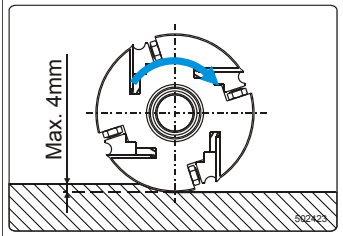

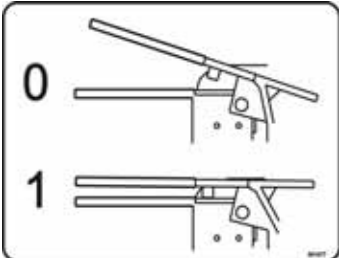

**TABELA 2-1**

Decals View	Decal No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the moulder. Observe all safety instructions and rules when operating the machine.
	099220	Close guards prior to operating the machine.
	099221	CAUTION! Keep all persons a safe distance away from work area when operating the machine.

**TABELA 2-1**

	<p>096316</p>	<p>Do not open or close the electric box when the switch is <b>not</b> in the “0” position.</p>
	<p>096319</p>	<p>Always disconnect the power cord before opening the electric box.</p>
	<p>S12004G</p>	<p>Always wear eye protection equipment when operating this machine.</p>
	<p>S12005G</p>	<p>Always wear ear protection equipment when operating this machine.</p>

**TABELA 2-1**

	<p>501465</p>	<p>Always wear safety boots when operating this machine.</p>
	<p>501467</p>	<p>Lubrication point</p>
	<p>089296</p>	<p>Rotation direction</p>
	<p>502423</p>	<p>Maximum moulding depth</p>
	<p>087649 502481</p>	<p>Warning stripe</p>
	<p>501477<sup>1</sup></p>	<p>Safety handle. The blade is stopped when the handle is released.</p>
	<p>P850701<sup>1</sup></p>	<p>CE certified machine</p>

<sup>1</sup> It does not concern the US version.

## SECTION 3 MOULDER ASSEMBLY

### 3.1 Mounting Parts of MP100/150 Moulders

#### 3.1.1 MP100 Parts Specifications

**Table 1:**

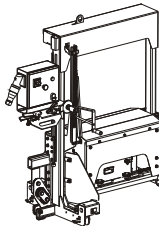
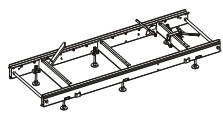
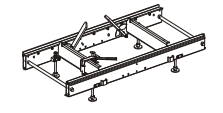
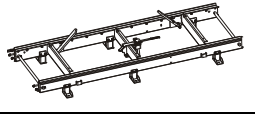
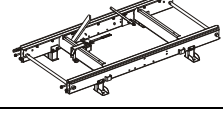


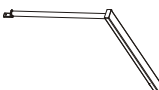

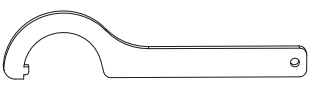

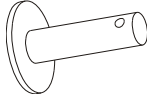
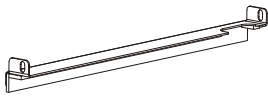




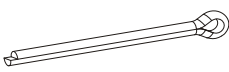


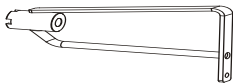
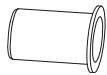
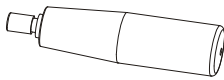

Fig.	Wood-Mizer Part No.	Description	Qty. MP100	Qty. MP100-UL
	501948	Moulder Head	1	1
	094697	LT15 Bed Section, Complete (2.7 m)	--	2
	094514	LT15 Bed Section, Complete (1.95 m)	3	--
	503516-S	MP100 Bed Section, Complete (2.7 m)	--	
	503515-S	MP100 Bed Section, Complete (1.95 m)		--
	086323	Left Track Wiper	2	2
	086322	Right Track Wiper	2	2
	086132-1	Power Cord Bracket	1	1
	501414-1	Plate, LT15 Power Feed Support	2	2
	502443	Wrench, bearing nut	1	1

Table 1:

	502848	Alignment tools set, ELBE RF 100120	1	1
	095919	Bottom bracket	2	2
	P12165	Bushing, Rubber	2	2
	086182-1	Mount Wdmt, Carriage Stop	2	2
	086745	Middle Track Cover with Felt Wiper	1	1
<b>Vertical Mast Lock Assembly</b>				
	086743-1	Zinc-plated Pin	2	2
	F81045-1	Roll Pin 6x50	3	3
	F81044-21	Roll Pin 3x20	2	2
	087301	Compression Spring 18x37x1.8	2	2
	F81043-2	Cotter Pin S-Zn 4x25	4	4
	F81058-1	Flat Washer 17	2	2
	502505-UL	Scale, Inch	-	1
	505886	Scale, Inch knives	-	1

**Table 1:**

	093369	Wrench, 13 mm open ENDED/BOX	-	1
<b>Manual Feed Assembly</b>				
	508238-1	Power Feed Crank Handle	1	1
	094142	Bushing	2	2
	086338	Crank Handle Grip	1	1
	F81033-1	M10 Hex Nylon Lock Nut	1	1

**3.1.2 MP150 Parts Specifications**

**Table 2:**

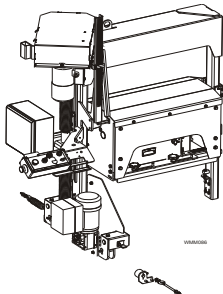
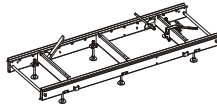
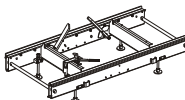
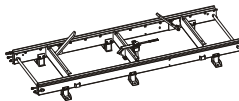
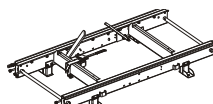
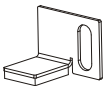

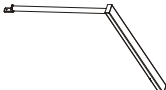
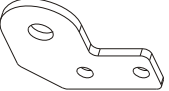
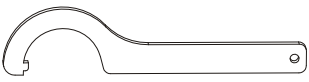

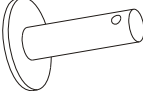
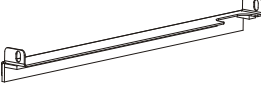
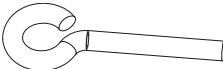

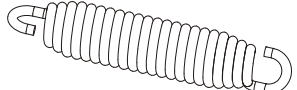
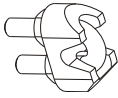








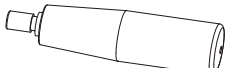

<b>Fig.</b>	<b>Wood-Mizer Part No.</b>	<b>Description</b>	<b>Qty. MP150</b>	<b>Qty. MP150-P</b>
	501965	Moulder Head	1	1
	094697	LT15 Bed Section, Complete (2.7 m)	--	2
	094514	LT15 Bed Section, Complete (1.95 m)	3	--
	503516-S	MP100 Bed Section, Complete (2.7 m)	--	
	503515-S	MP100 Bed Section, Complete (1.95 m)		--

Table 2:

	086323	Left Track Wiper	2	2
	086322	Right Track Wiper	2	2
	086132-1	Power Cord Bracket	1	1
	501414-1	Plate, LT15 Power Feed Support	1	1
	502443	Wrench, bearing nut	1	1
	502848	Alignment tools set, ELBE RF 100120	1	1
	095919	Bottom bracket	2	2
	P12165	Bushing, Rubber	2	2
	086182-1	Mount Wdmt, Carriage Stop	2	2
	086745	Middle Track Cover with Felt Wiper	1	1
	500848-1	Tensioner, Short	-	1
	500846-1	Tensioner	-	1
	089689	Spring, Press Roller	-	1

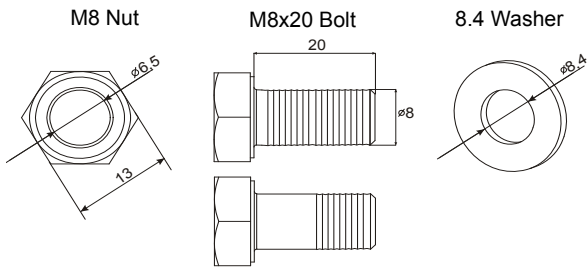


**Table 2:**

	091614	Clamp, Rope	-	4
<b>Vertical Mast Lock Assembly</b>				
	086743-1	Zinc-plated Pin	2	2
	F81045-1	Roll Pin 6x50	3	2
	F81044-21	Roll Pin 3x20	2	2
	087301	Compression Spring 18x37x1.8	2	2
	F81043-2	Cotter Pin S-Zn 4x25	4	4
	F81058-1	Flat Washer 17	2	2
<b>Manual Feed Assembly</b>				
	506427-1	Power Feed Crank Handle	1	-
	094142	Bushing	2	-
	086338	Crank Handle Grip	1	-
	F81033-1	M10 Hex Nylon Lock Nut	1	-

## 3.1.3 Specifications of Fasteners

Table 3:

Wood-Mizer No.	Description	Qty. MP100	Qty. MP100-UL	Qty. MP150	Qty. MP150-P
<b>Sample designations of fasteners:</b> 					
F81030-2	M5 Nut	2	2	2	2
F81000-7	M5x25 Bolt	2	2	2	2
F81054-1	8.4 Flat Washer	4	4	4	6
F81002-6	M8x12 Bolt	4	4	4	4
F81002-4	M8x20 Bolt	-	-	-	2
F81055-2	10.2 Split Lock Washer	-	-	-	4
F81033-3	M10 Nut	4	4	4	8
F81055-1	10.5 Flat Washer	-	-	-	4
F81054-4	8.2 Split Lock Washer	-	-	-	14
F81003-2	M10x30 Bolt	4	4	4	4
F81082-1	Band	2	2	2	2

## 3.1.4 Tools Necessary for Assembling the Moulder

Table 4:

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

## 3.2 Unpacking the Moulder

1. Cut the bands holding the components together.
2. Remove the parts arranged inside the bed section.
3. Attach the winch hook to the bracket on the head. Using a forklift truck or a winch with lifting capacity of at least 500 kg, carefully lift the head and set it aside.



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

See Figure 3-1.

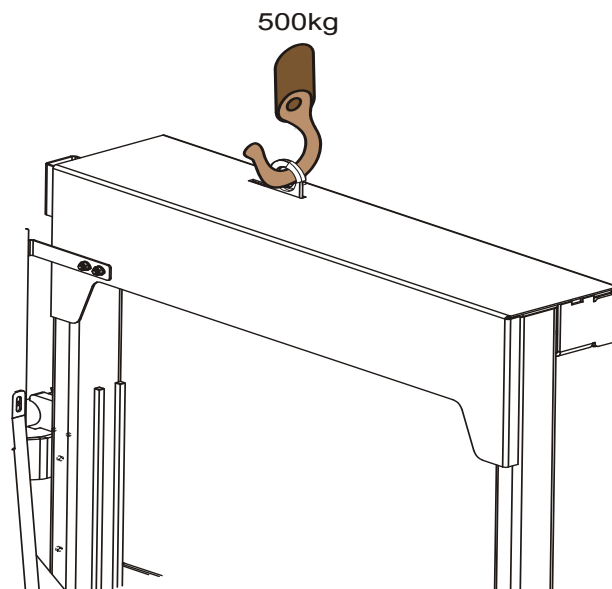


FIG. 3-1

## 3.3 Bed Frame Assembly



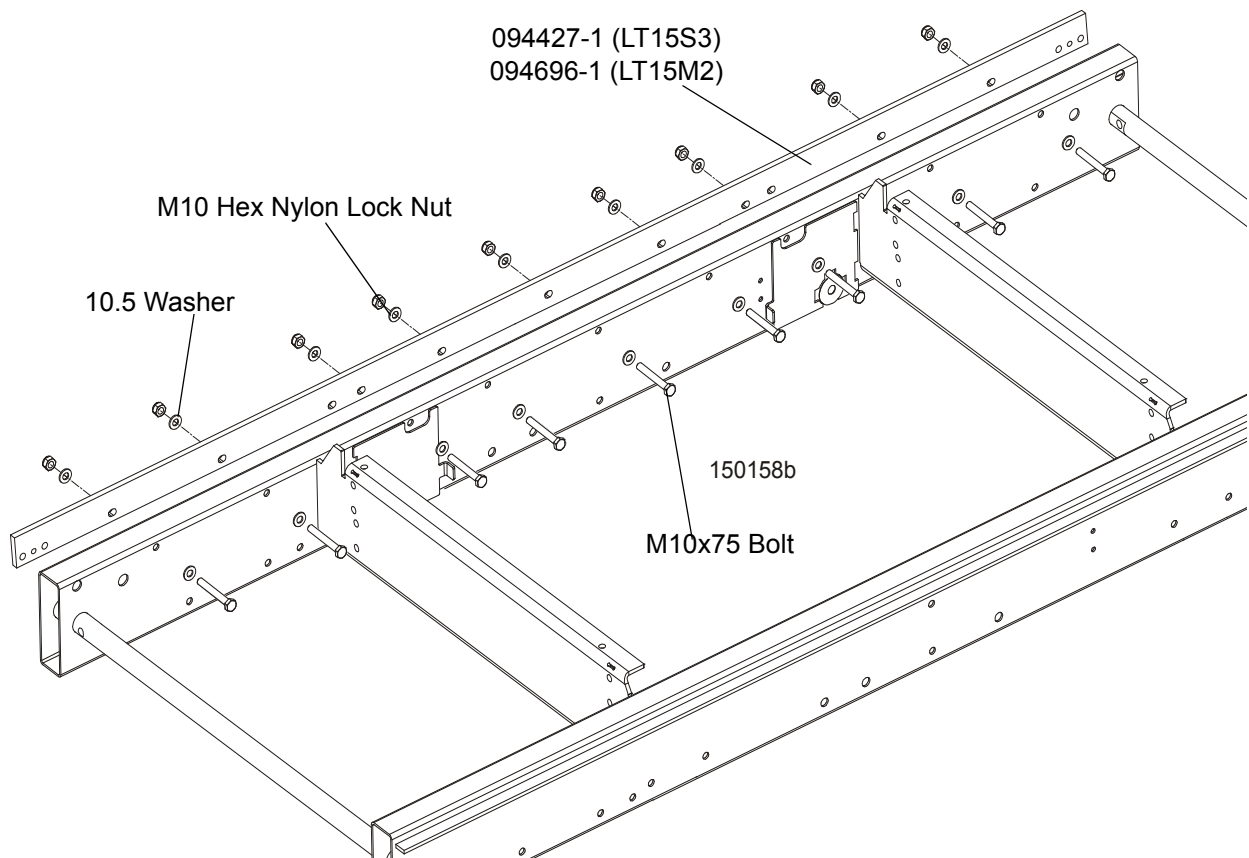
**IMPORTANT!** For all screw joints without a split lock washer or a nylon lock nut, use "LOCTITE 243" (blue, of average durability, for screw joints).

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

# 3 MOULDER ASSEMBLY

## Bed Frame Assembly

See Figure 3-2.



**FIG. 3-2**

2. Mount four (or six) legs to each bed section. Use two hex head bolts and lock nuts to secure each leg to the bed section.

See Figure 3-3.

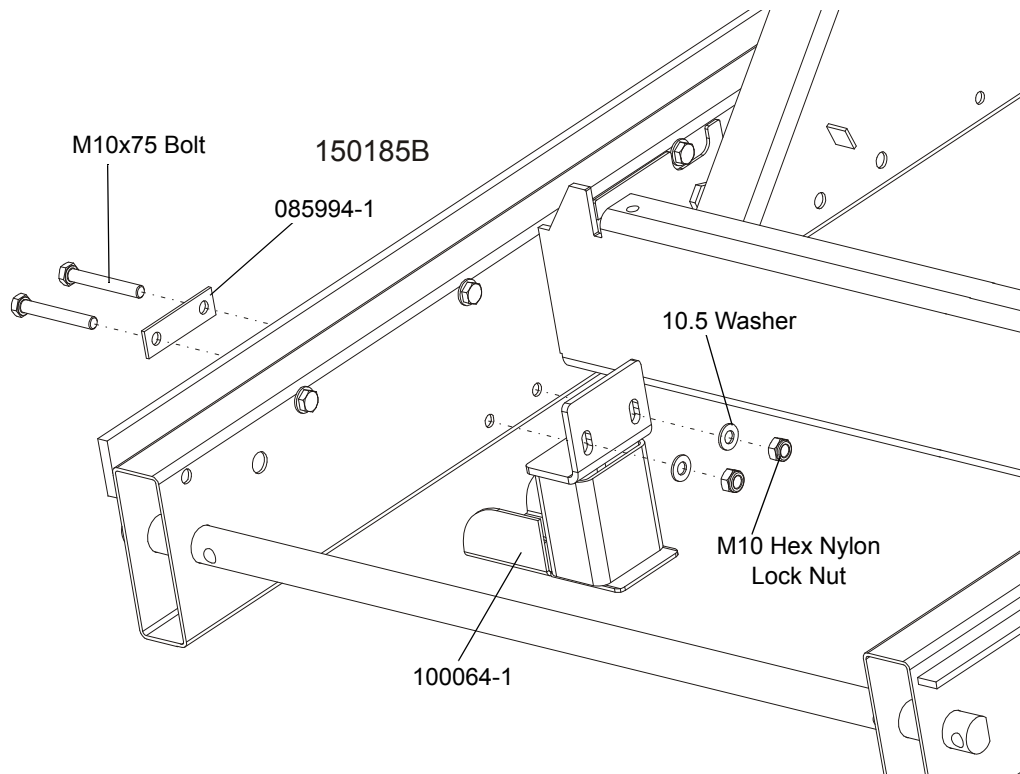


FIG. 3-3

- 3. Optional Legs Kit** - Mount four (or six) leg brackets to each bed section. Use two hex head bolts and lock nuts to secure each leg bracket to the bed section. Be sure the nut on the bracket faces up. Thread a leg into each bracket.

See Figure 3-4.

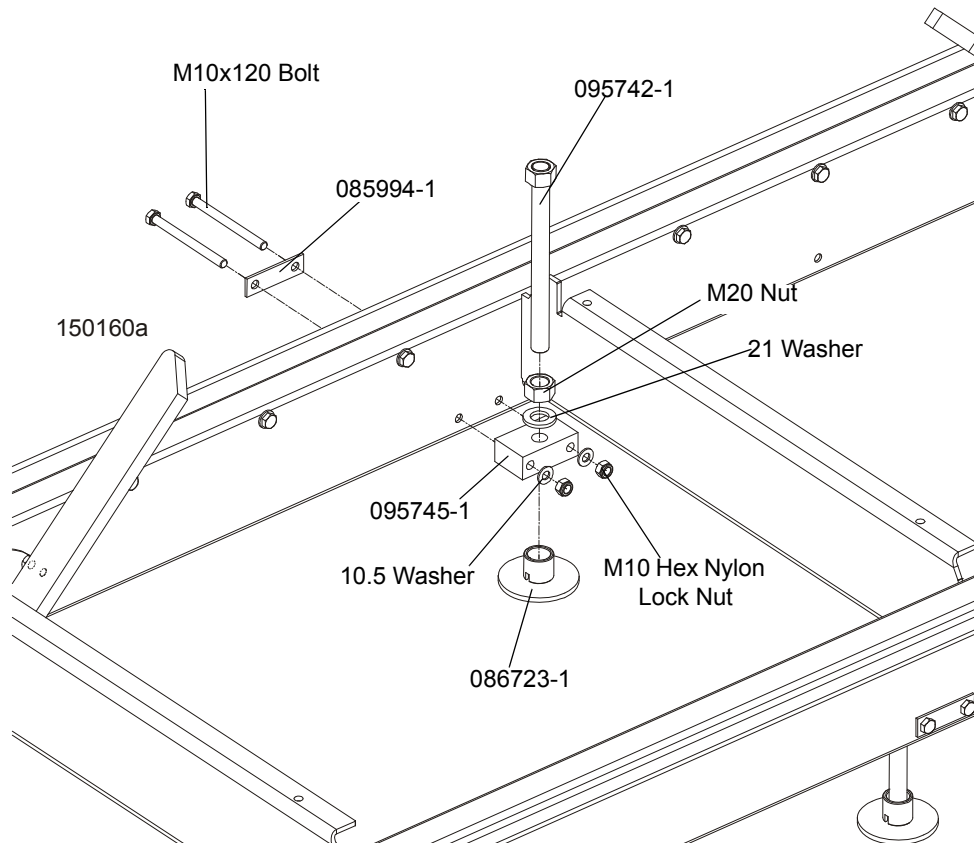
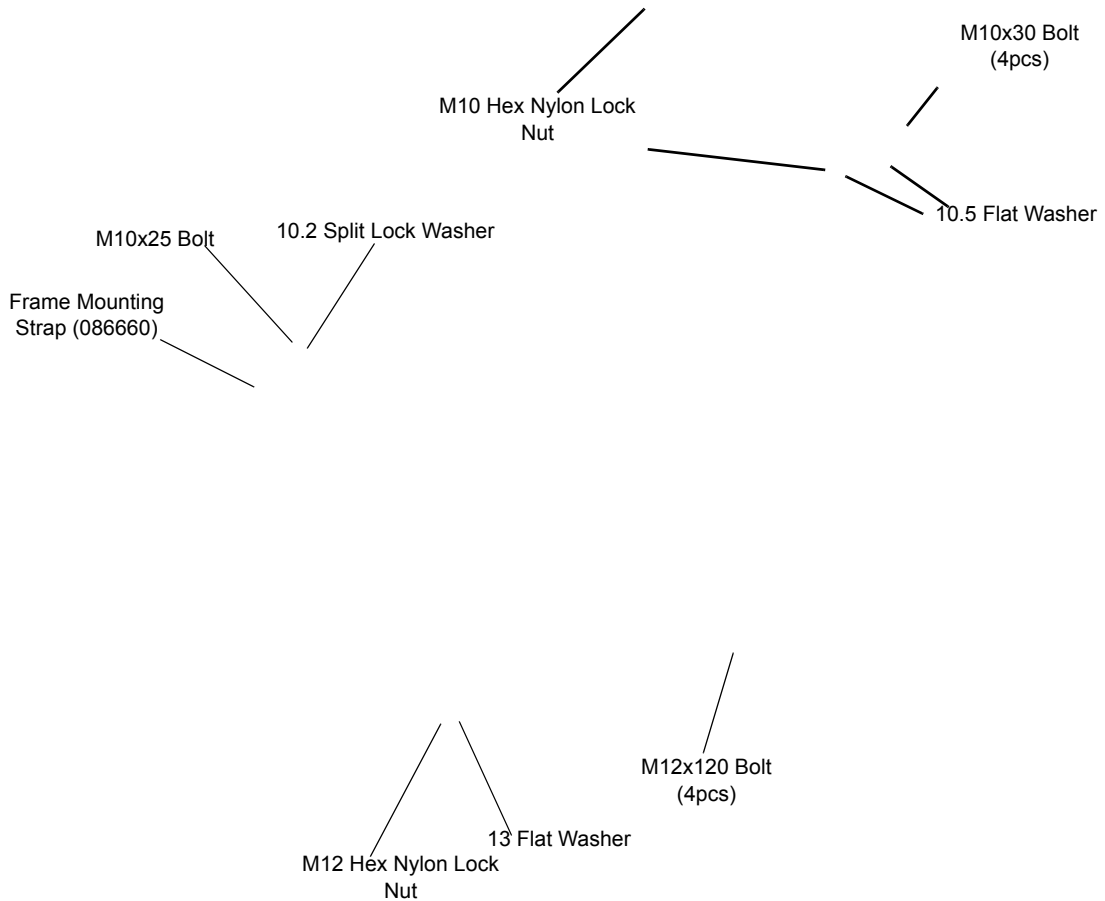


FIG. 3-4

4. 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 3-5.



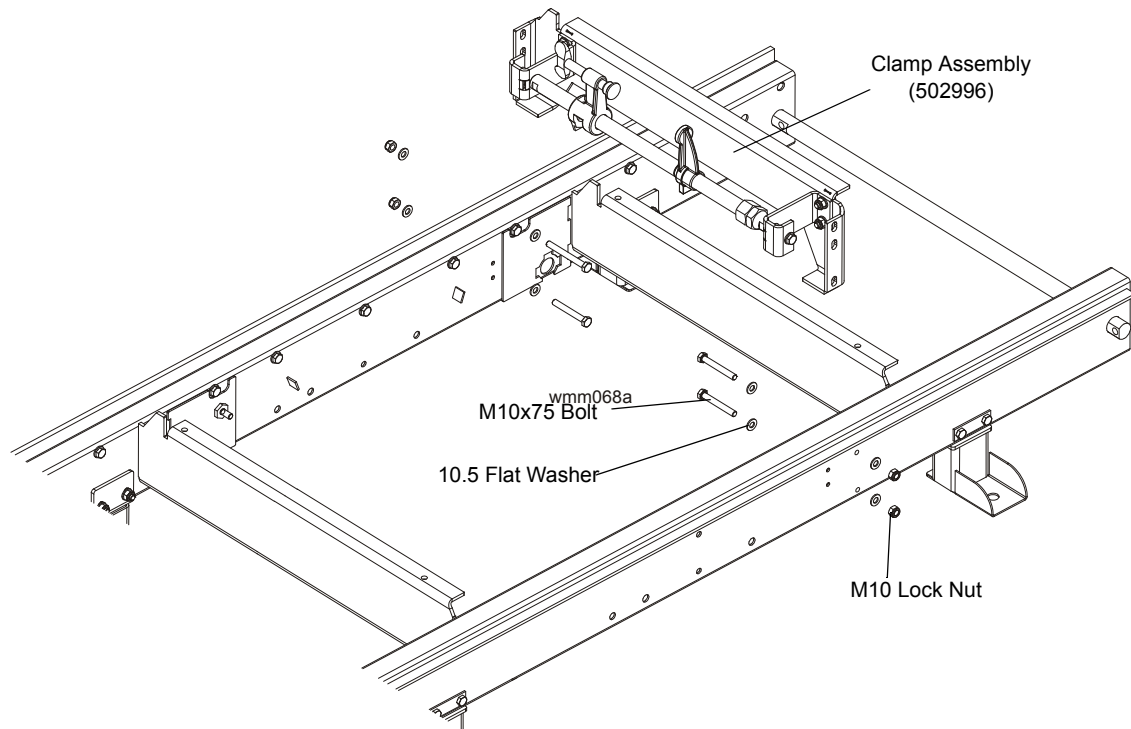
**FIG. 3-5**

5. 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.
6. Mount the optional log clamps (if equipped). The optional log clamp can be additionally equipped with second adjustable jaw (8.22 Log Clamp for LT15 Bed Frame, MP100 Option).

# 3 MOULDER ASSEMBLY

## Bed Frame Assembly

See Figure 3-6.



**FIG. 3-6**

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



See Figure 3-7.

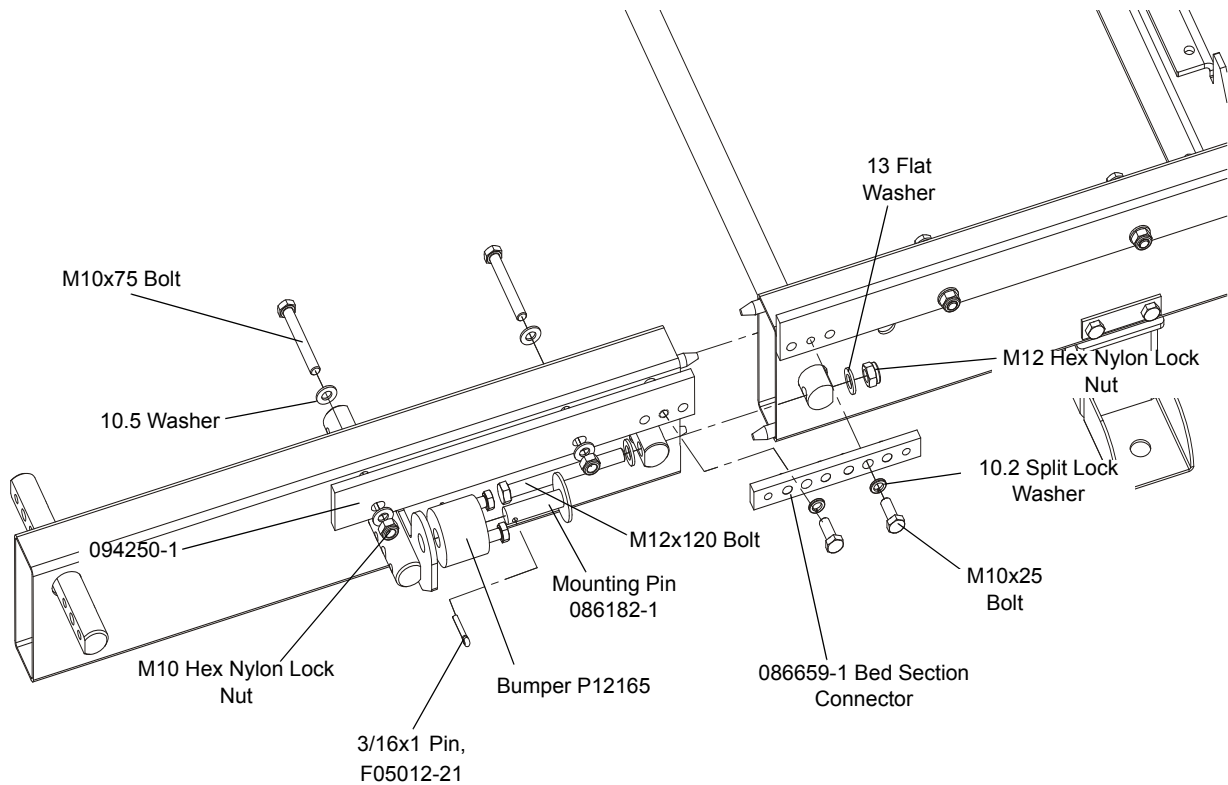


FIG. 3-7

8. Assemble a log clamp to a bed rail on each bed section using the existing hex head bolts and nylon lock nuts.
9. Install the log side supports as shown in the Figure 3-8. Tighten the nuts so that the side supports can be moved with little resistance. Adjust the side supports. [See Section 6.11 of the LT15 sawmill Operator's Manual.](#)

See Figure 3-8.

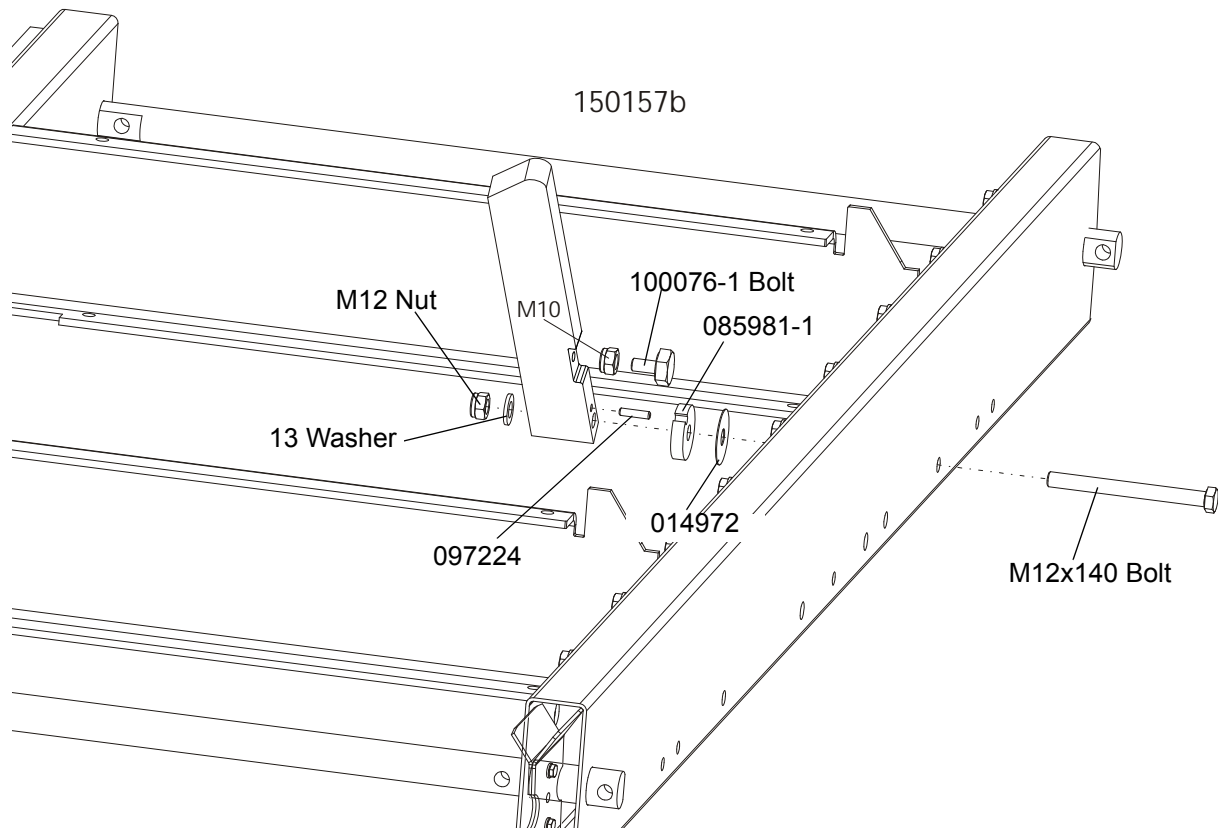


FIG. 3-8

### 3.4 Frame Leg Adjustment

1. Place a foot plate under each bed leg.
2. Using an appropriate wrench, adjust each leg so that the nut is approximately 25 mm (1") below the top of the bed tube.

See Figure 3-9.

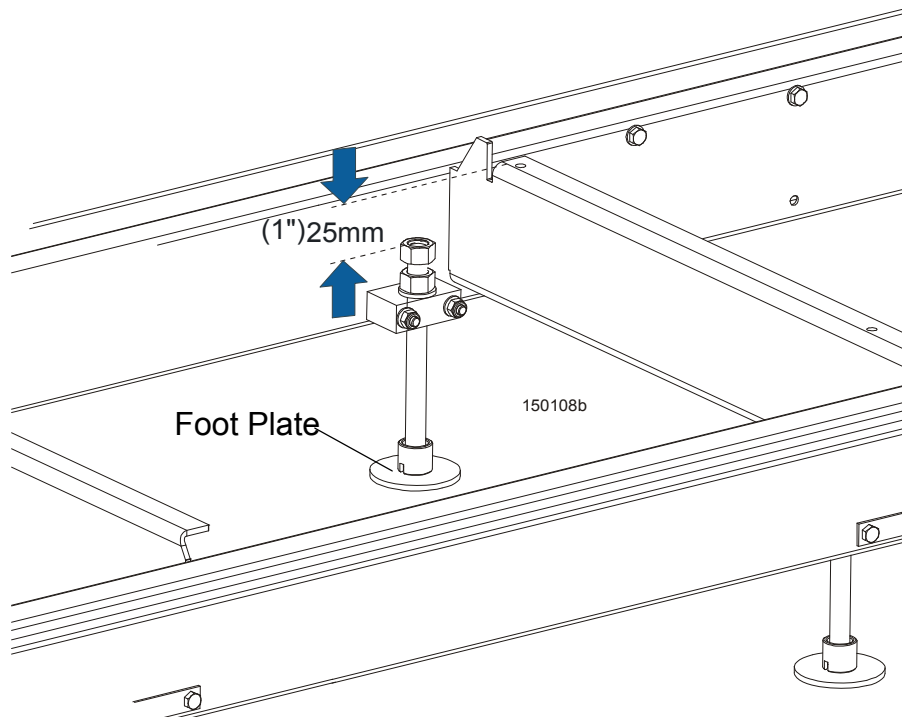


FIG. 3-9



**CAUTION!** The top of the leg should not be higher than the top surface of the bed rail.

### 3.5 Head Assembly

1. Position the head at the end of the bed frame assembly. Carefully slide the head rollers onto the bed frame track. Keep the head square to the bed to avoid putting the track rollers in a bind.



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

2. Install the middle track cover with a felt strip using a 6.4 flat washer and M6x12 hex head bolt.

# 3 MOULDER ASSEMBLY

## Head Assembly

See Figure 3-10. MP100 Moulder Mounted on the LT15 Bed Frame

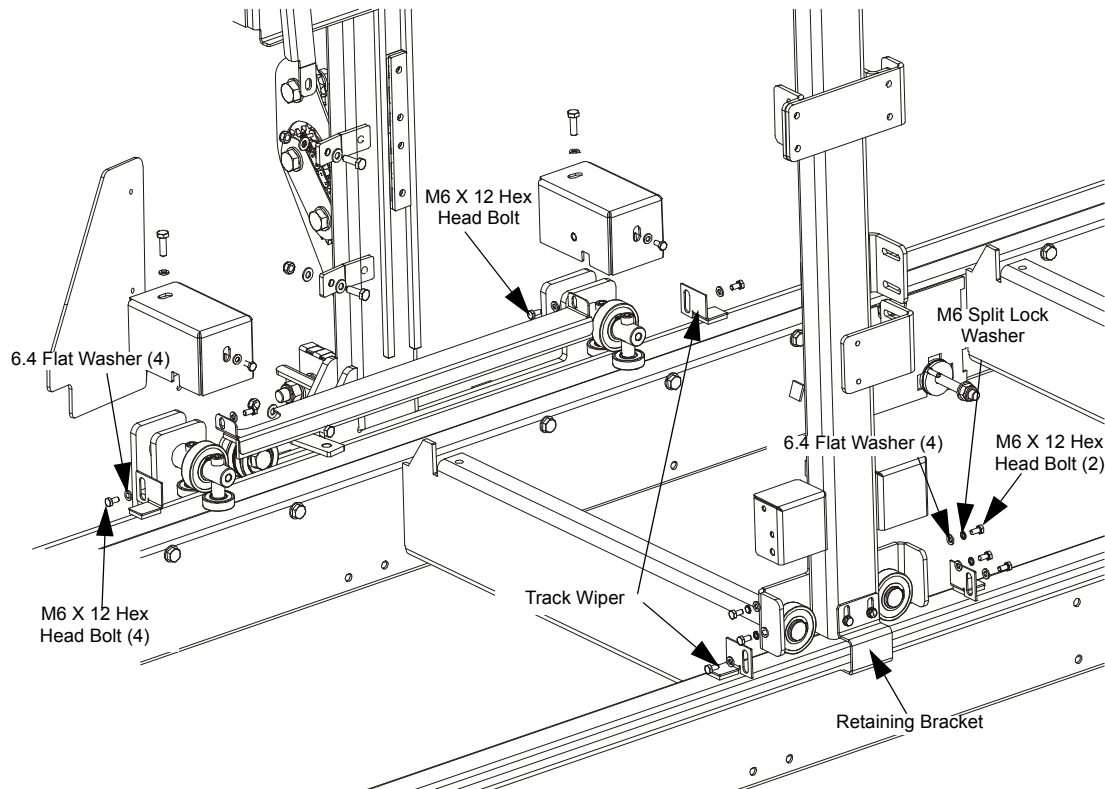


FIG. 3-10

See Figure 3-11. MP100 Moulder Mounted on the LT10 Bed Frame.

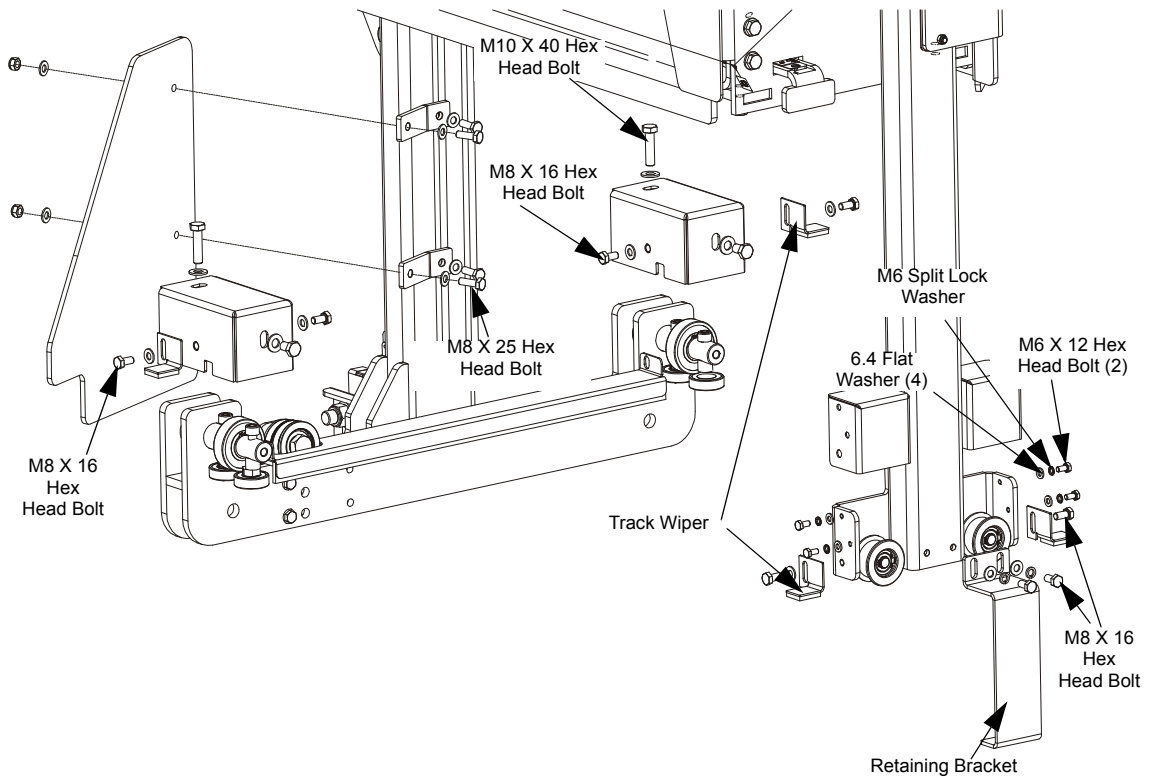


FIG. 3-11

3. Assemble the retaining bracket to the right side of the mast with two hex head bolts and flat washers.
4. Assemble the four track wipers to the left and right sides of the mast using the hex head bolt and flat washers.

**NOTE:** Before installing the felt wipers, soak the felt strips with lubricating fluid.

5. Install the PC operator guard.

6. Assemble the mast safety pins.

See Figure 3-12.

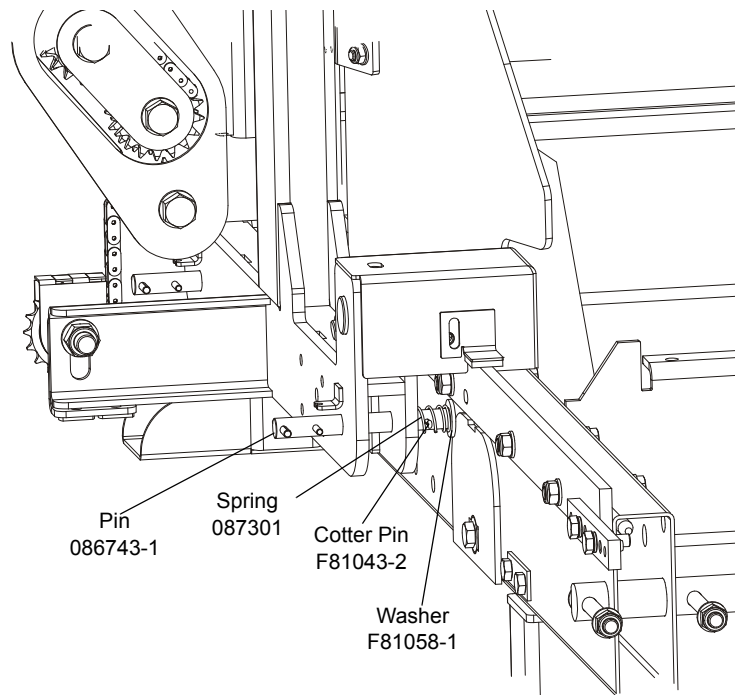


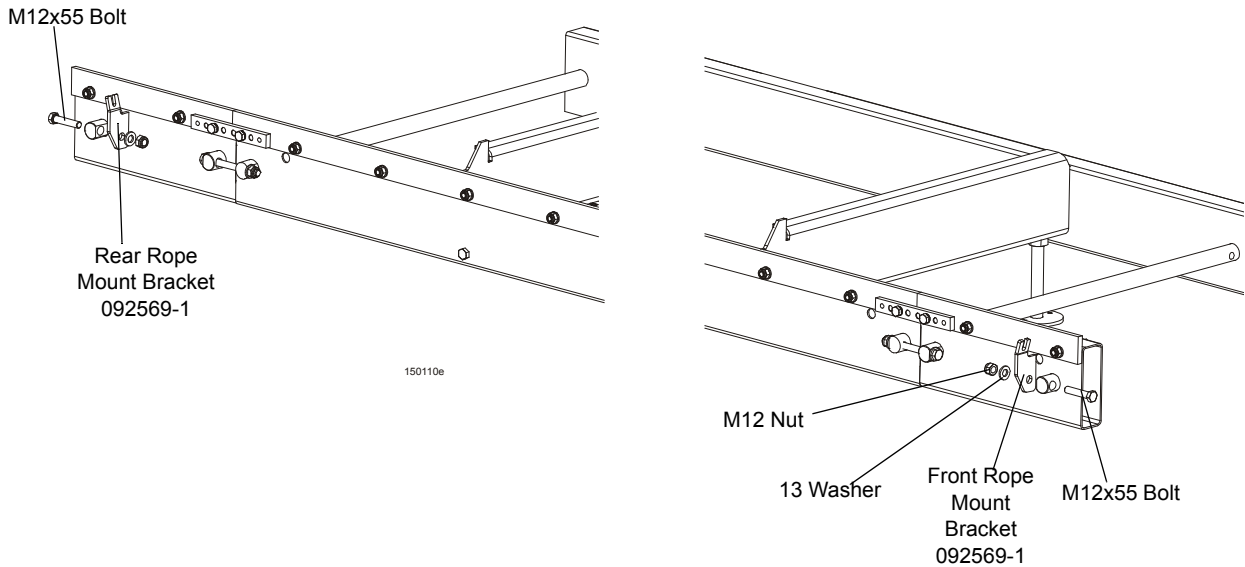
FIG. 3-12

7. Install the power cord bracket.

### 3.6 Manual Feed Rope Assembly

1. Install a feed rope mounting bracket at each end of the bed assembly using a M12x55 hex head bolt and a nylon lock nut. Either bracket should be angled toward the end of the frame at which it is mounted as shown below.

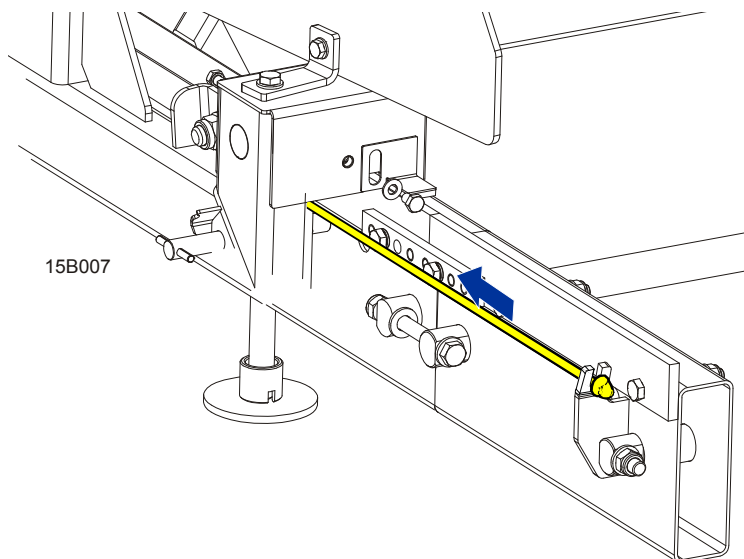
See Figure 3-13.



**FIG. 3-13**

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 head and the main bed frame tube.

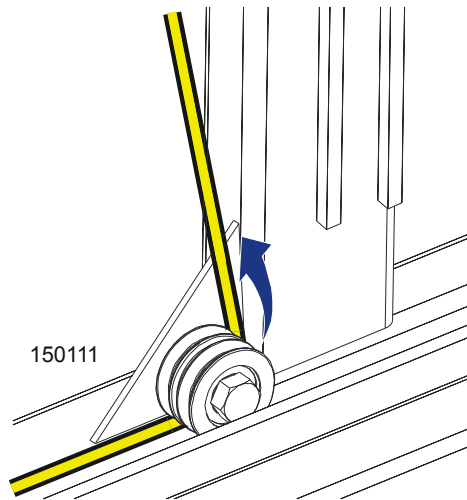
See Figure 3-14.



**FIG. 3-14**

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

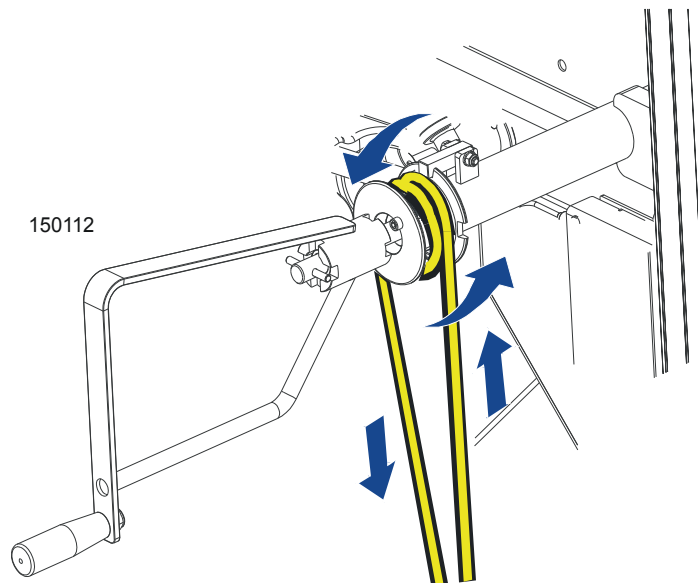
See Figure 3-15.



**FIG. 3-15**

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

See Figure 3-16.

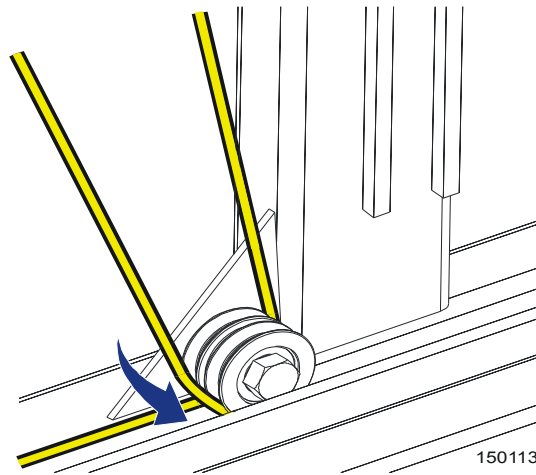


**FIG. 3-16**

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

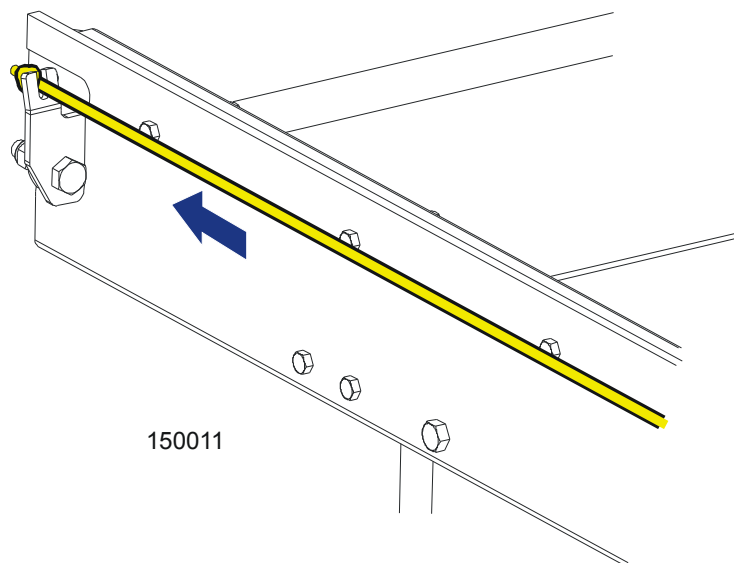


See Figure 3-17.



**FIG. 3-17**

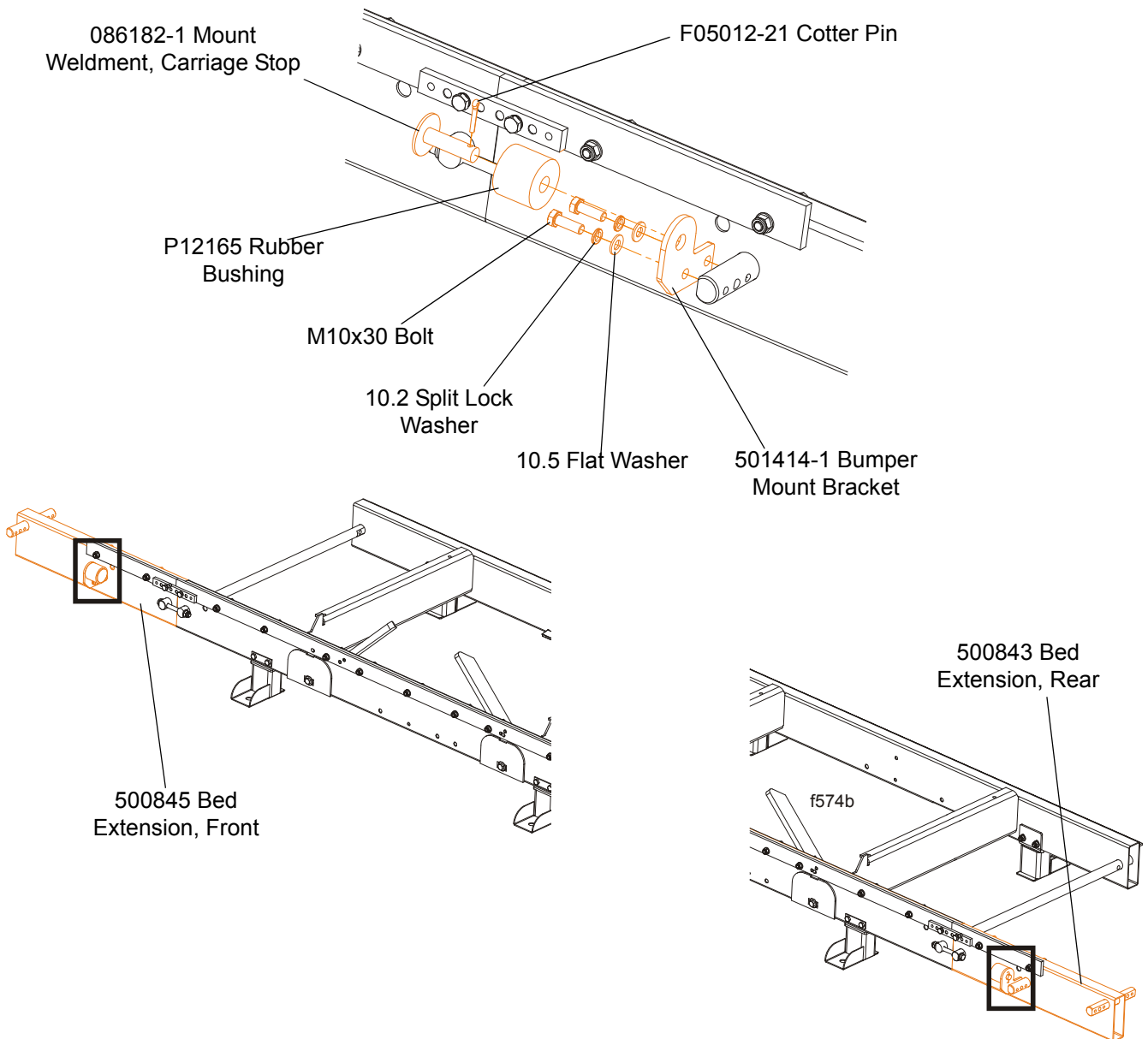
6. Route the rope to the rear mounting bracket. Tie a knot in the end of the rope and insert into the mounting bracket. Position the knot in the rope so when installed to the rear bracket, the rope is tight.



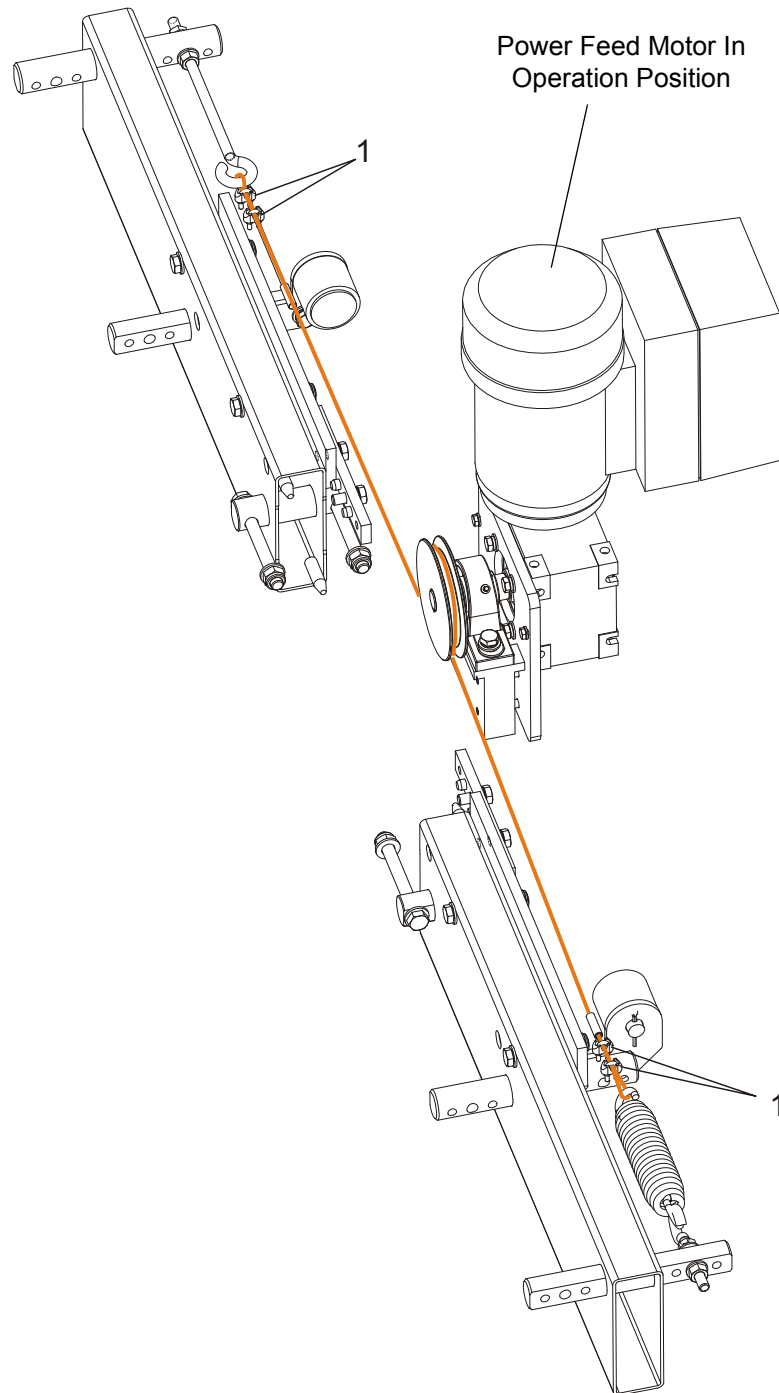
**FIG. 3-17**

### 3.7 Power Feed Rope Assembly

1. Before installation of the rope, 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.
2. Mount the rubber bumpers with brackets to the bed extensions - see the figure below.



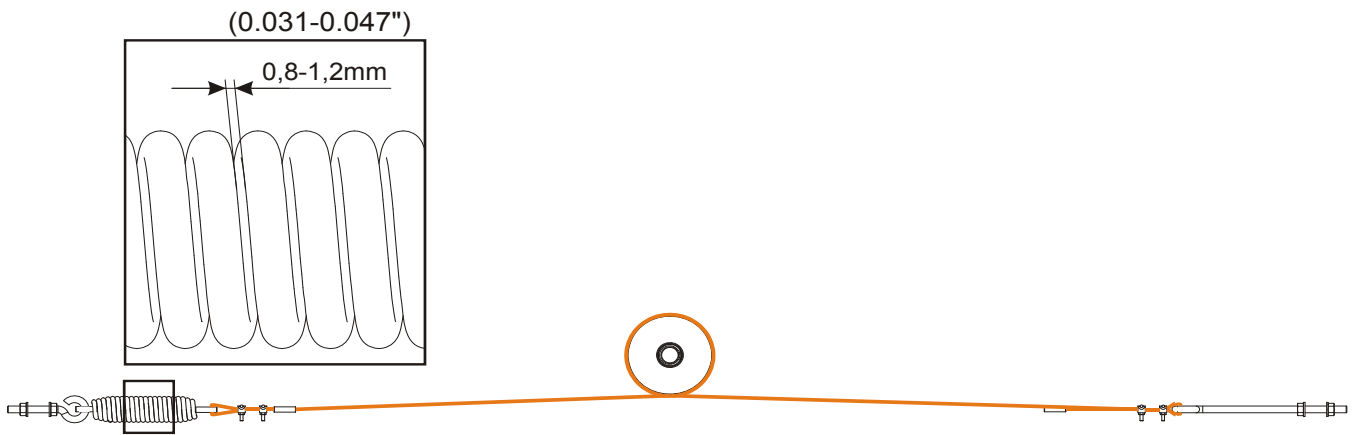
3. Prepare the rope for installation by placing steel caps on its ends.
4. Install the rope, route it around the pulley, as shown below, and secure with clamps (1).



# 3 MOULDER ASSEMBLY

## Power Feed Rope Assembly

5. Adjust the rope tension so that gaps between the spring coils are .8-1.2 mm (0.031- 0.047").



### 3.8 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 3-18.

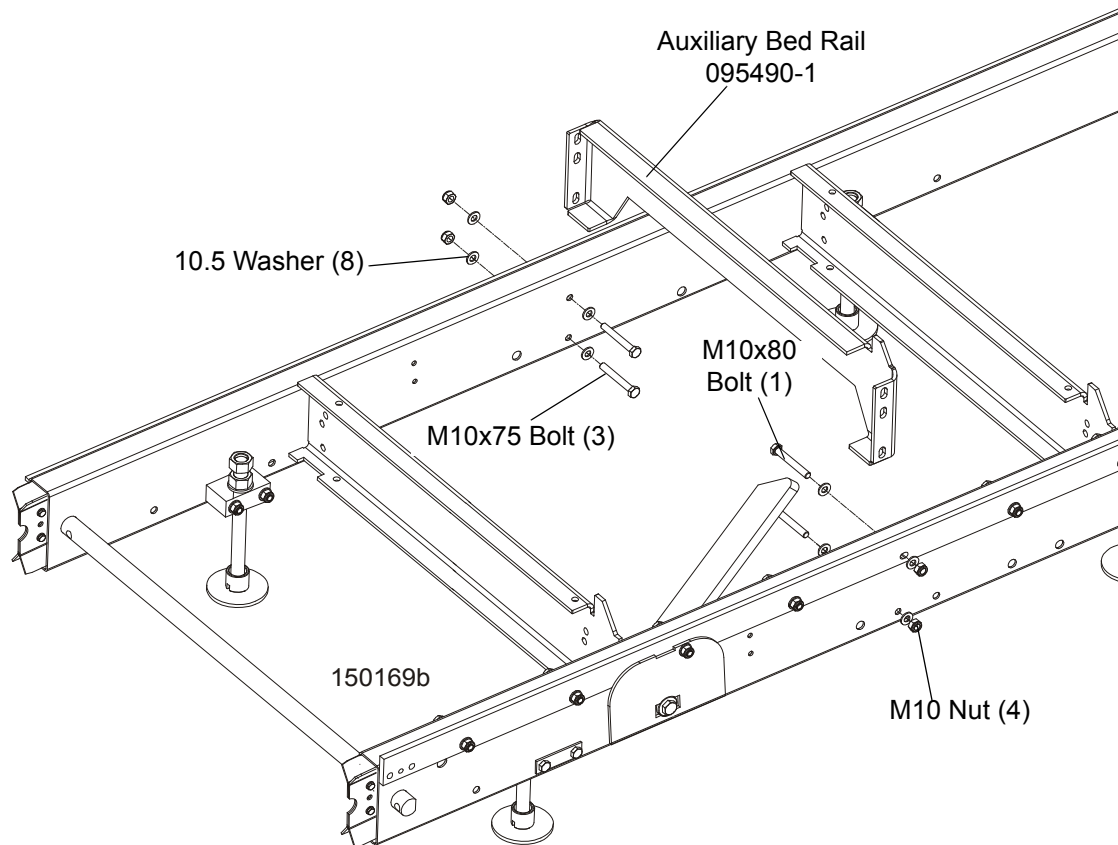


FIG. 3-18

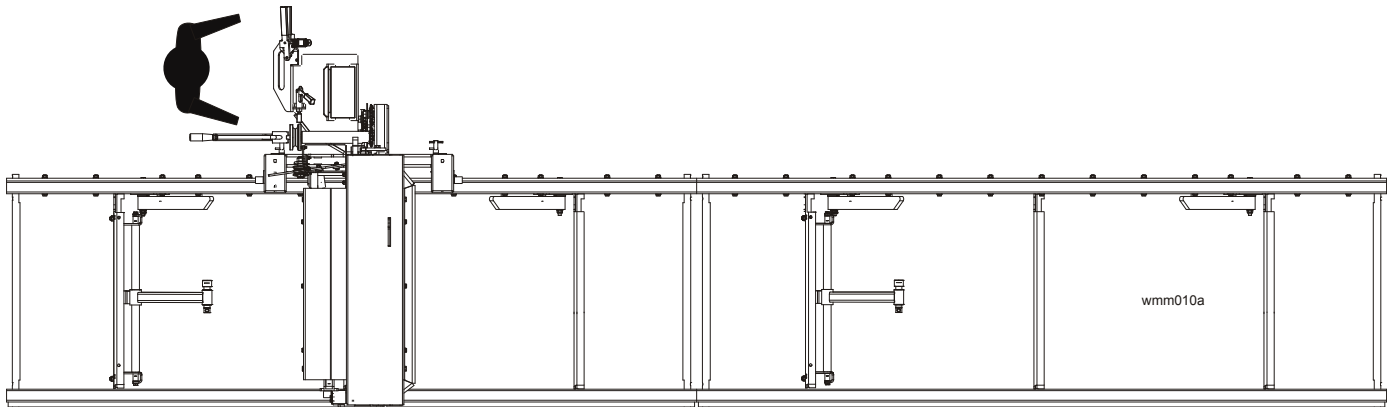
## SECTION 4 SETUP & OPERATION

### 4.1 Moulder Setup



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

- Set up the moulder on firm, level ground and level the moulder frame. Secure the moulder to the ground to prevent moving during operation. A concrete foundation or pads and anchored bolts are recommended.
- The moulder should be operated under roof only.
- The moulder should always be operated with the sawdust collection system.
- The moulder should be operated in temperature range from -15° C to 40° C (5°F to 104°F) only.
- The illumination at the operator's position should be at least 300lx<sup>1</sup>.
- The moulder 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.

Voltage	Fuse disconnect	Suggested Wire Size
3ph 400 VAC	10 A	13 AWG/2,5 mm <sup>2</sup> to 15m/49 ft length
3ph 230 VAC	20 A	13 AWG/2,5 mm <sup>2</sup> to 15m/ 49 ft length
3ph 460 VAC UL	15 A class J	11 AWG / 4mm <sup>2</sup>
1ph 230 VAC UL	70 A class J	7 AWG / 10mm <sup>2</sup>

**TABLE 4-1**

1. The light source can not cause stroboscopic effect.

**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 moulder motors.

**DANGER!** To check the cutter rotation direction, look at the motor fan when the motor is starting or stopping through the inspection window shown below. Do not for any reason check the rotation direction by touching the cutter using any tool or a piece of wood. Doing so may result in serious injury or death.

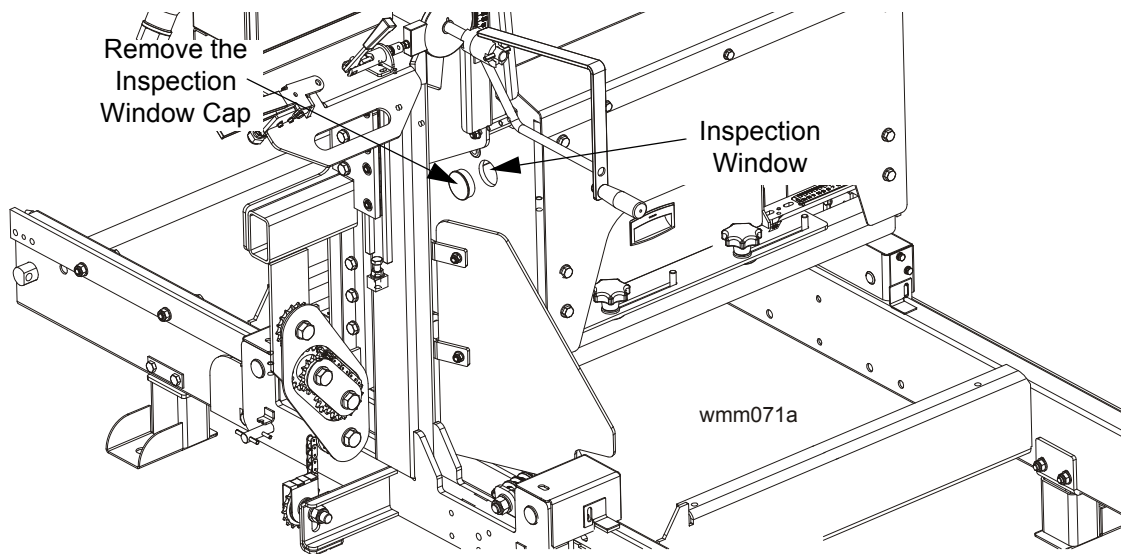


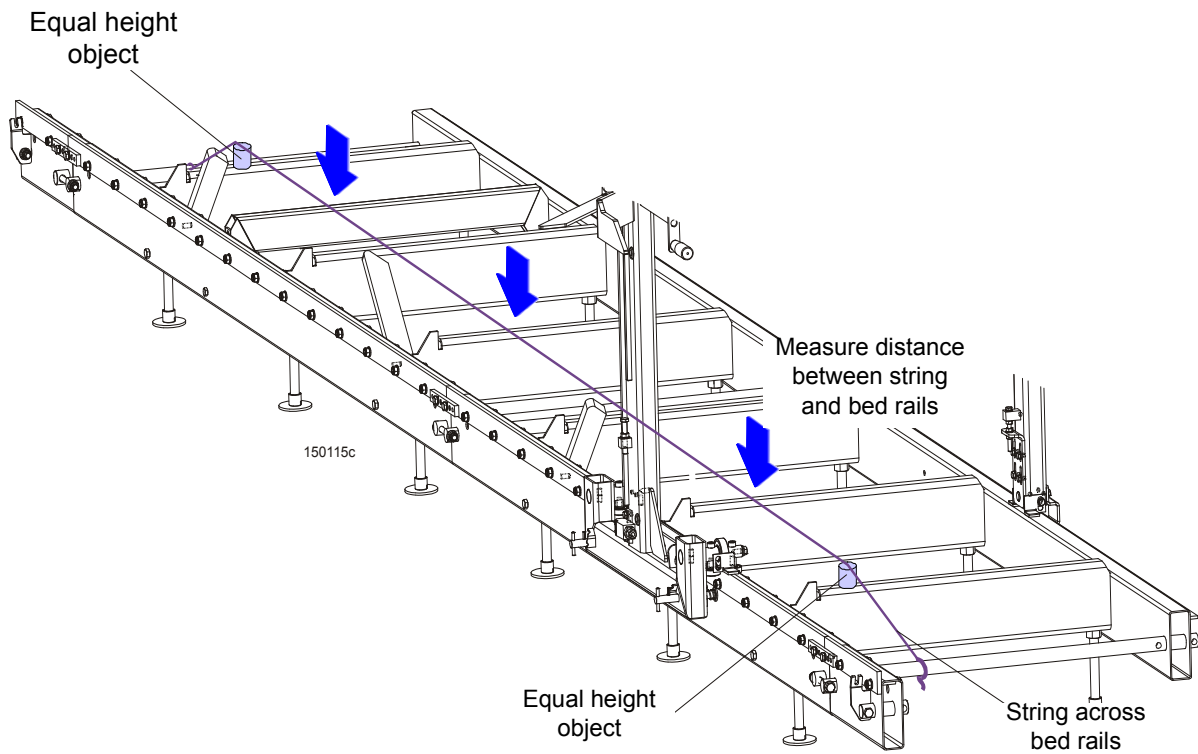
FIG. 4-0

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

The following setup procedure should be performed whenever the moulder 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 moulder appears level. If the moulder 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 the 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 4-1.



**FIG. 4-1**

4. Repeat the bed rail adjustment with the string at the other side of the moulder frame.
5. Move the head until it is positioned over the bed rail.
6. Measure the distance from the cutter to the bed rail in the places shown below. The dimensions A and B should be the same.



See Figure 4-2.

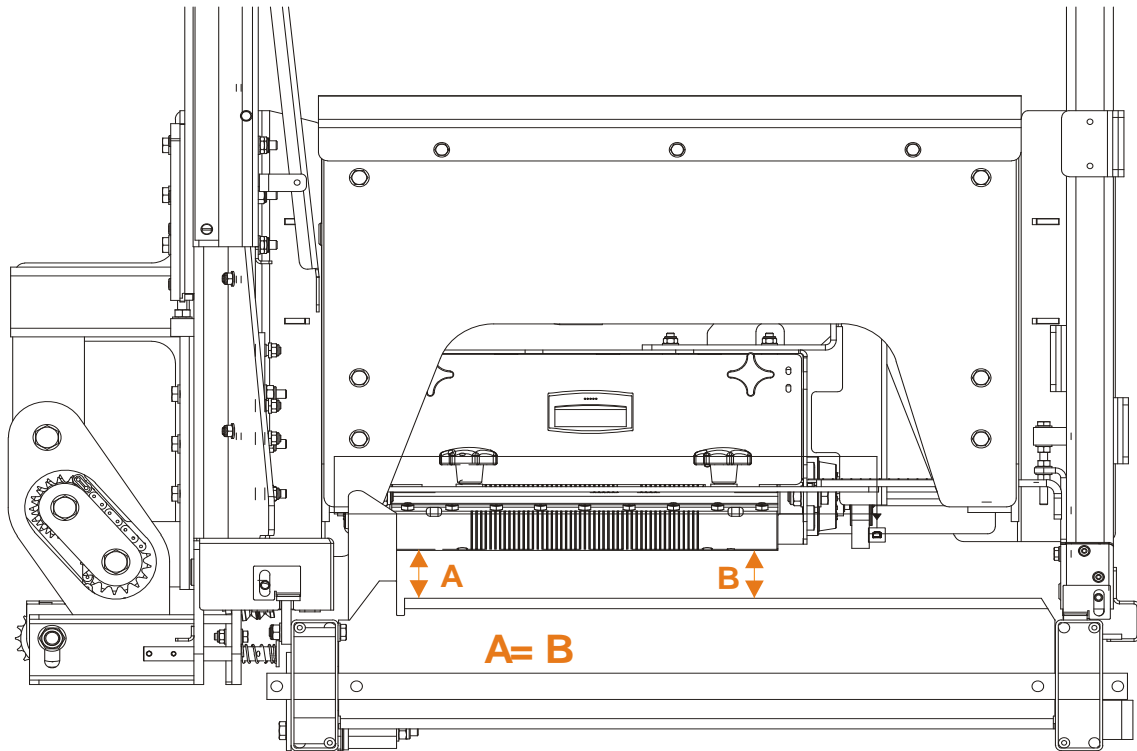
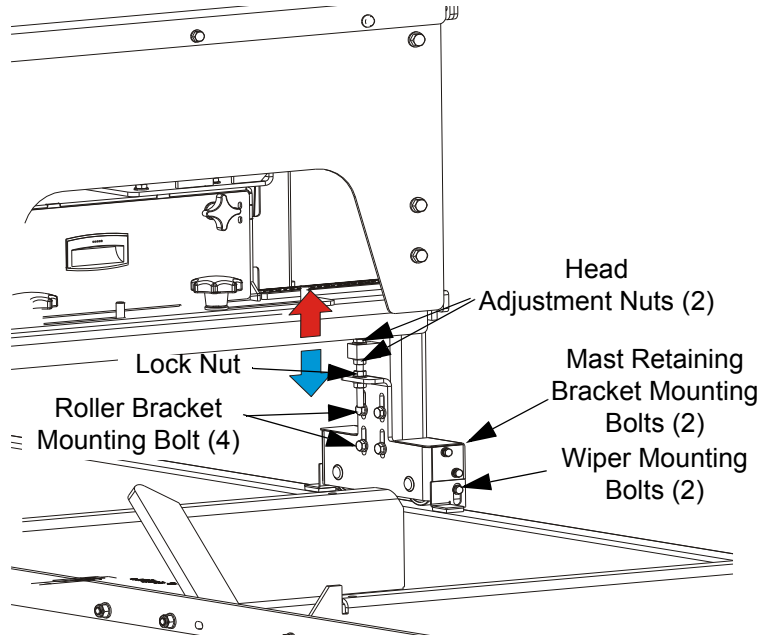


FIG. 4-2

7. If the dimensions A and B are not the same, adjust the head tilt as shown in the Figure 4-3.

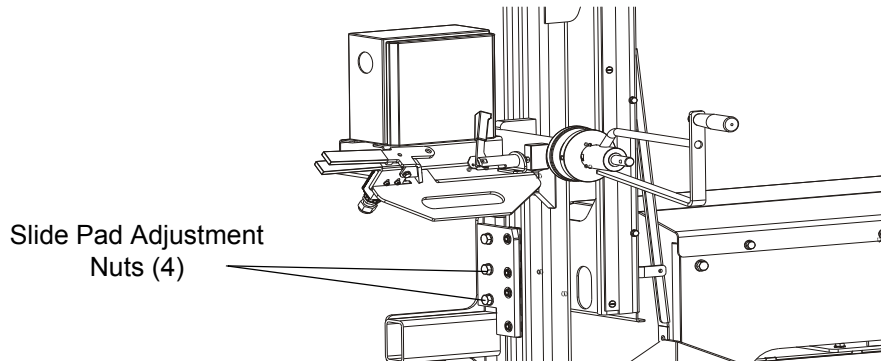
**See Figure 4-3.** To adjust the head tilt, loosen the four mounting bolts of the side roller bracket, the two wiper mounting bolts and the two mounting bolts of the mast retaining bracket. Use the head

adjustment nuts to move the outside of the head up or down.



**FIG. 4-3**

8. Make sure the entire face of each slide pad makes contact with the mast. Use the adjustment nuts on both sides of the mast to adjust the slide pads if necessary.



**FIG. 4-3**

## 4.2 Log Clamp Operation

### To Clamp Logs

1. Position the clamps against the log, far enough down, below level of working knives. Turn the clamp screws in so they move the log firmly against the side supports.

See Figure 4-4.

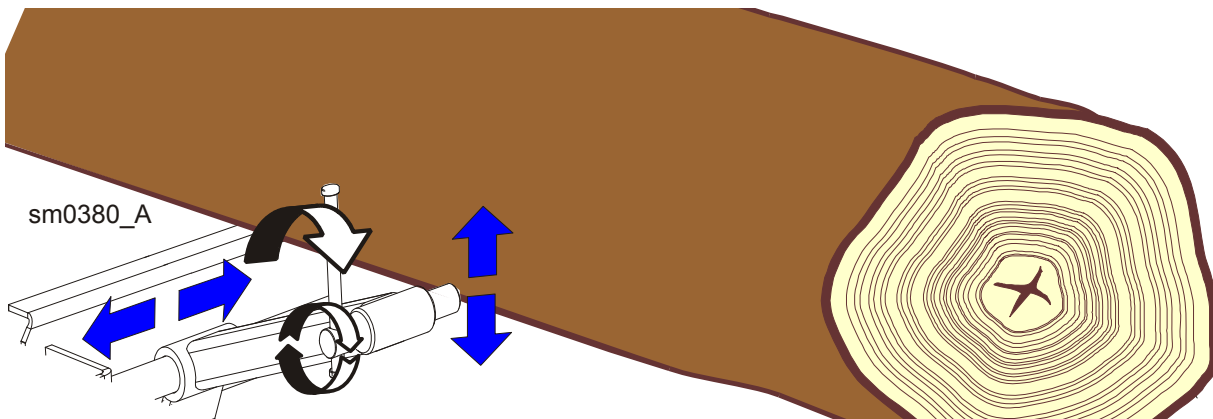


FIG. 4-4

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

See Figure 4-5.

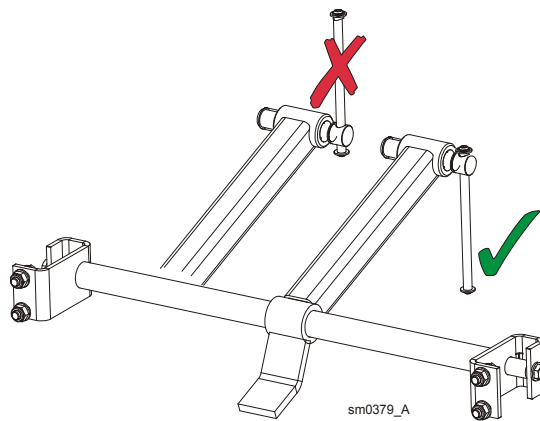


FIG. 4-5

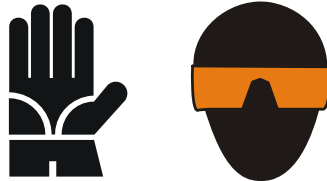
### 4.3 Mounting the Planing Knives



**WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before mounting/dismounting the knives.




**WARNING!** Always wear gloves and eye protection when mounting/dismounting the knives. The knives are very sharp. You can hurt yourself even when you touch any knife lightly.



**WARNING!** Before mounting the knives, make sure the knives, the mounting strip and the cutter sockets are immaculately clean. Any sawdust or resin inside the cutter may cause the knife to break. Damaged knives or mounting strip should be replaced immediately.



**IMPORTANT!** The knives must be mounted in pairs. It is possible to mount only two knives in opposite sockets, but we recommend that the knives be mounted in all four sockets.

1. Turn the key switch to  position to loosen the motor brake.
2. Remove the cutter cover.

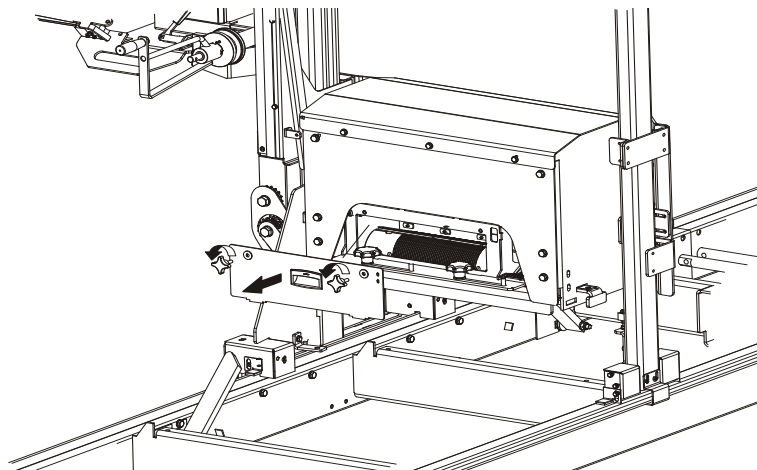
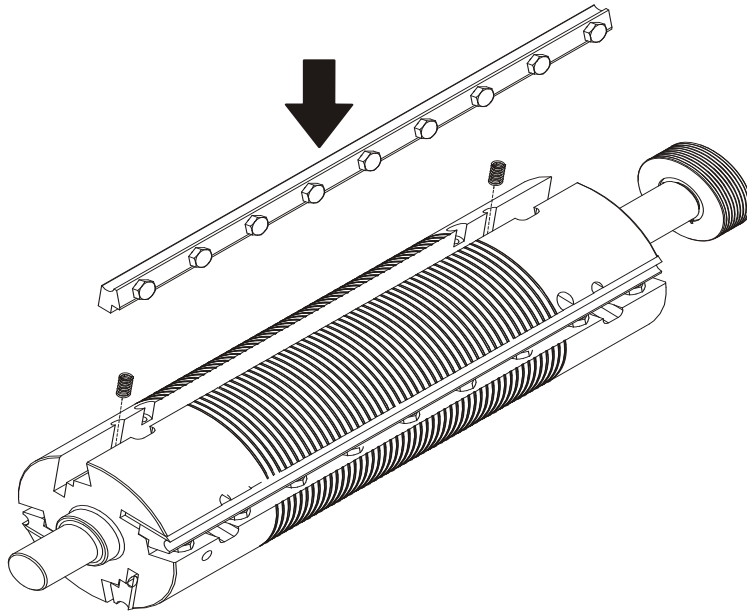


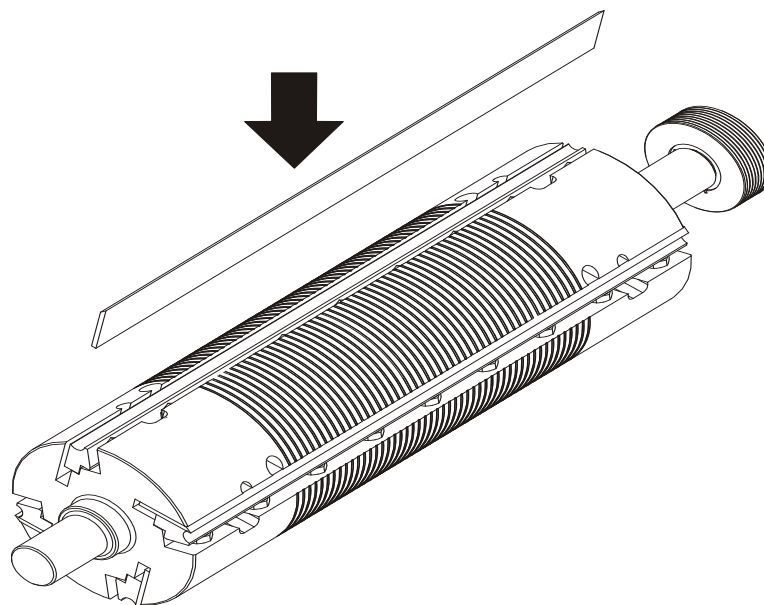
FIG. 4-5

3. Clean thoroughly any dust, chips and debris from the cutter socket, the mounting strip and the knives. Insert the springs in the holes shown below. Next, screw in all mounting strip bolts and place the strip in the socket as shown below.



**FIG. 4-5**

4. Carefully slide the knife into the socket as shown below.



**FIG. 4-5**

# 4

## SETUP & OPERATION

### Mounting the Planing Knives

5. Place one of the alignment tools over the knife, on the left side of the cutter. Place the other alignment tool on the right side of the cutter as shown below. Each knife socket is equipped with a spring that lifts the knife and make the adjustment easier.

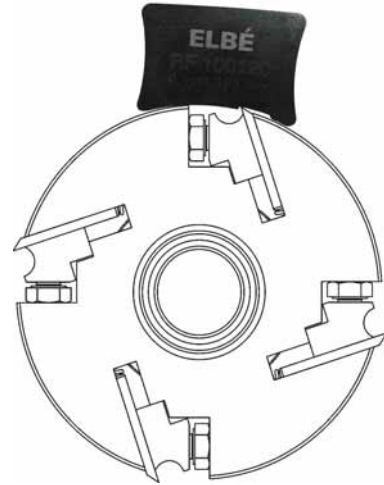





FIG. 4-5


6. Tighten all mounting strip bolts starting from middle of the cutter, to the outside.
7. Place the alignment tools over the remaining knives and repeat the adjustment procedure described above.

 **DANGER!** Make sure that all mounted knives are aligned identically. If they are not, it will cause vibrations of the cutter, resulting in personal injury.


 **DANGER!** Make sure that there are no tools left inside the cutter housing or on the frame.


 **DANGER!** Make sure that all knives mounting strips bolts are securely tightened.

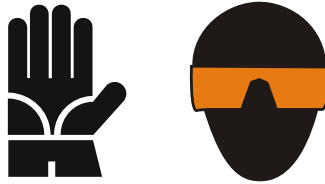
To remove the knife from the cutter, loosen the mounting strip bolts. Carefully remove the knife.


 **DANGER!** Be very careful when loosening the mounting strip bolts of the knives already mounted, because the spring can push out the knife rapidly, causing injury.


## 4.4 Mounting the Moulding Knives

 **WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before mounting/dismounting the knives.

 **WARNING!** Always wear gloves and eye protection when mounting/dismounting the knives. The knives are very sharp. You can hurt yourself even when you touch any knife lightly.



 **WARNING!** Before mounting the knives, make sure the knives, the mounting wedges and the cutter sockets are immaculately clean. Any sawdust or resin inside the cutter may cause the knife to break. Damaged knives or clamping wedges should be replaced immediately.

 **IMPORTANT!** The knives should be mounted symmetrically. They should be mounted in the same position on the cutter.

1. Remove the cutter cover.

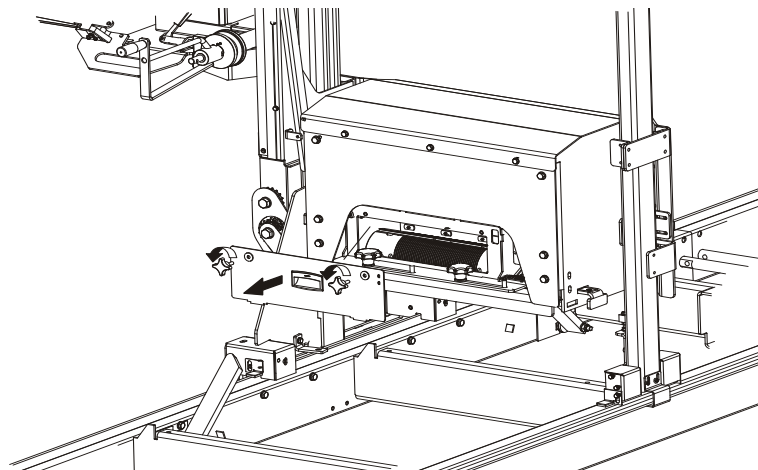
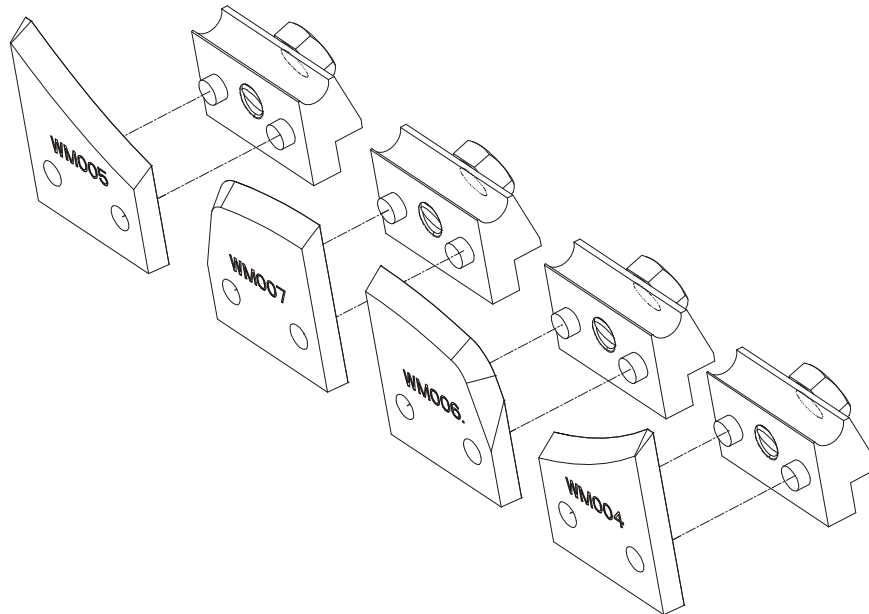


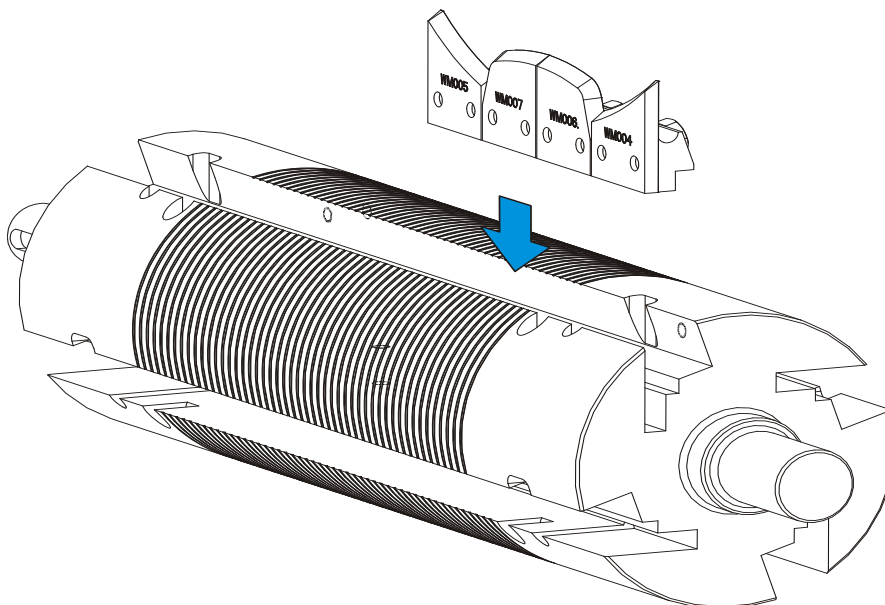
FIG. 4-5

**4****SETUP & OPERATION***Mounting the Moulding Knives*

2. Clean thoroughly any dust, chips and debris from the cutter socket, the clamping wedges and the knives. Remove the springs from the holes in the cutter. Screw in the bolts of the clamping wedges and assemble the knives to the clamping wedges as shown below.

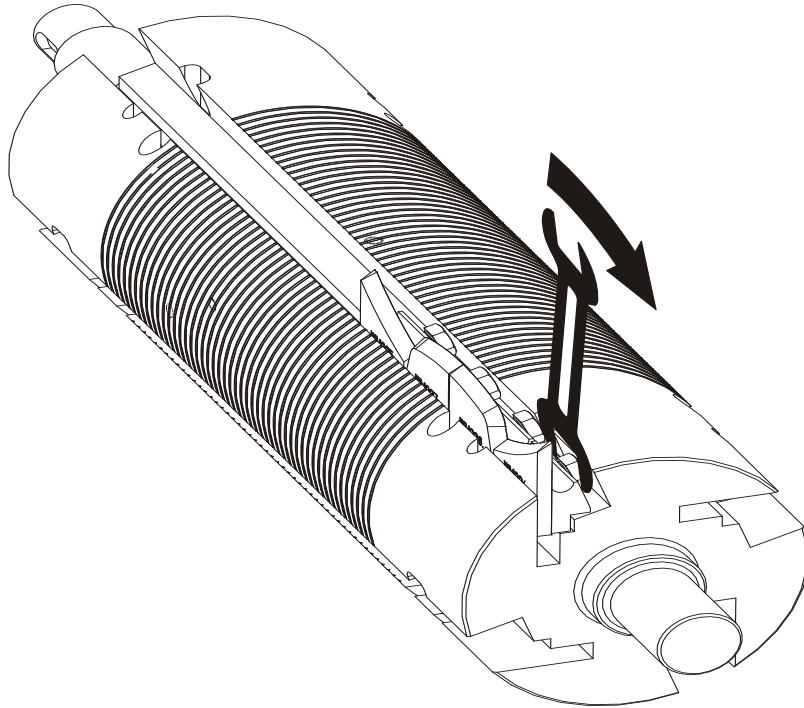
**FIG. 4-5**

3. Carefully insert the knives with the clamping wedges in the cutter socket as shown below.

**FIG. 4-5**

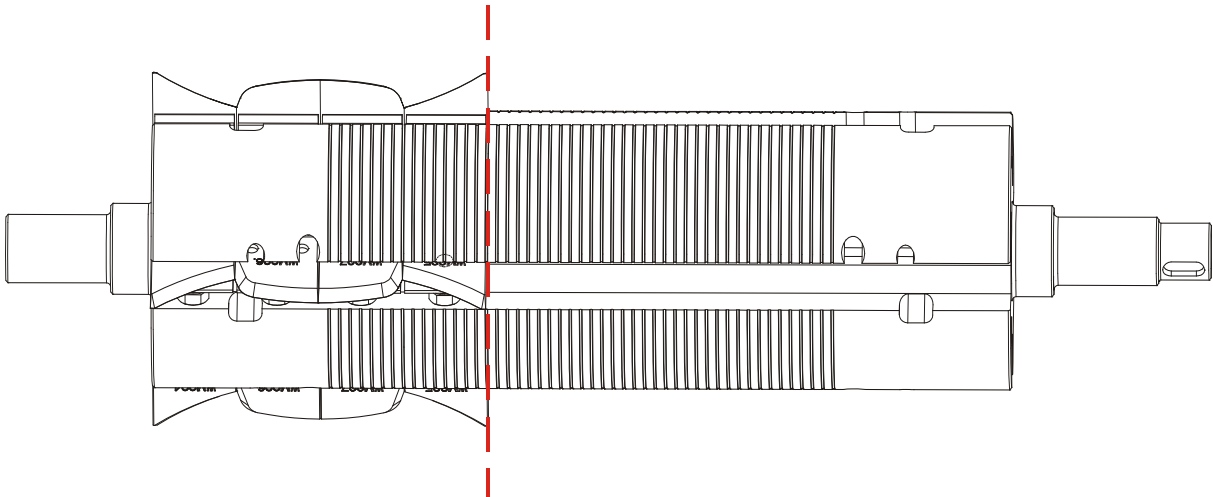


4. Tighten the bolts of the clamping wedges. Be sure that the knives are touching each other.





**FIG. 4-5**

5. Mount the three remaining sets of knives in the same way. Be sure that they are mounted exactly in the same position on the cutter - see the figure below.



**FIG. 4-5**

 **DANGER!** Make sure that all mounted knives are aligned identically. If they are not, it will cause vibrations of the cutter and may result in personal injury.

 **DANGER!** Make sure that there are no tools left inside the cutter

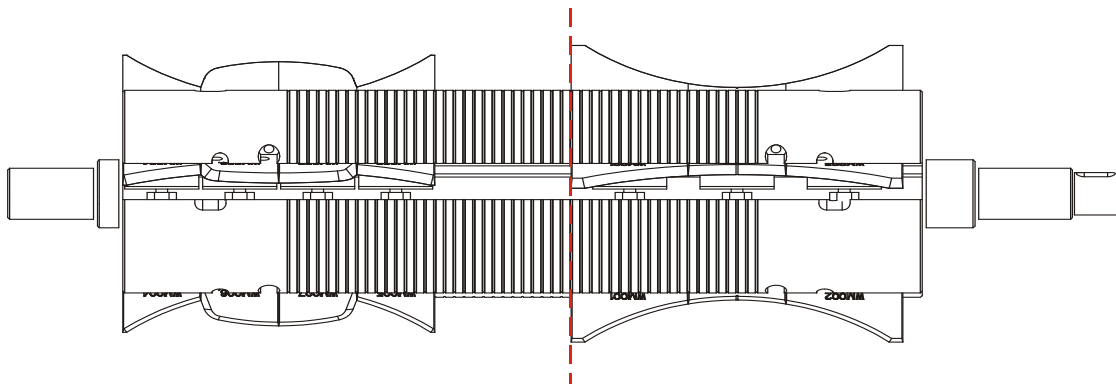
housing or on the frame.



**DANGER!** Make sure that all mounting strip bolts are securely tightened.

To remove the knives from the cutter, loosen the bolts of the clamping wedges. Carefully remove the knives.

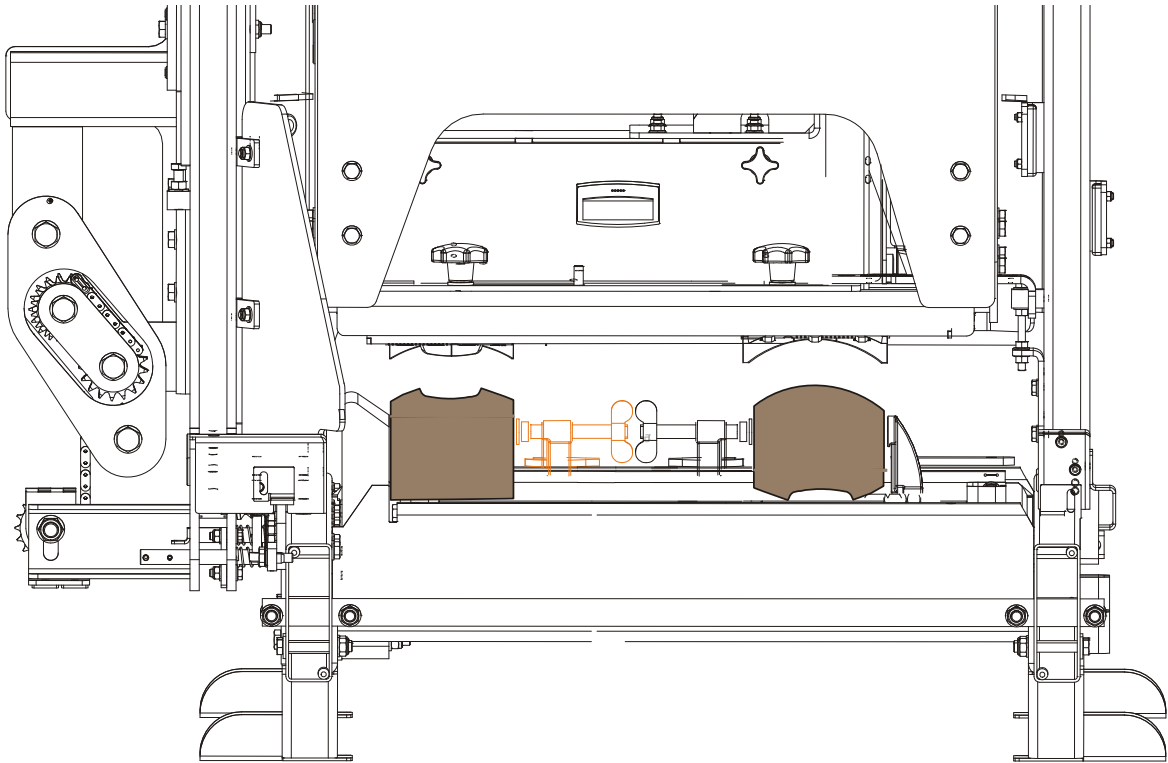
It is also possible to mount the second set of knives on the cutter. Mount all four knives of this set in the same way as the previous set. Be sure that they are mounted exactly in the same position on the cutter - see the figure below.



**FIG. 4-5**

Mounting two sets of knives with different profiles on the cutter is especially useful when the moulder/sawmill bed frame is equipped with additional clamp or clamps (see the figure below). Then it is possible to mould one side of the cant, rotate the cant by 180 degrees and place it in the optional

clamps to mould the other side using the second set of knives.



**FIG. 5**



**DANGER!** Never try to plan/mould two cants at the same time!

## 4.4 Moulder Operation, MP100

### 4.4.1 Control Overview

See Figure 4-2. The controls of the MP100 moulder are shown below:

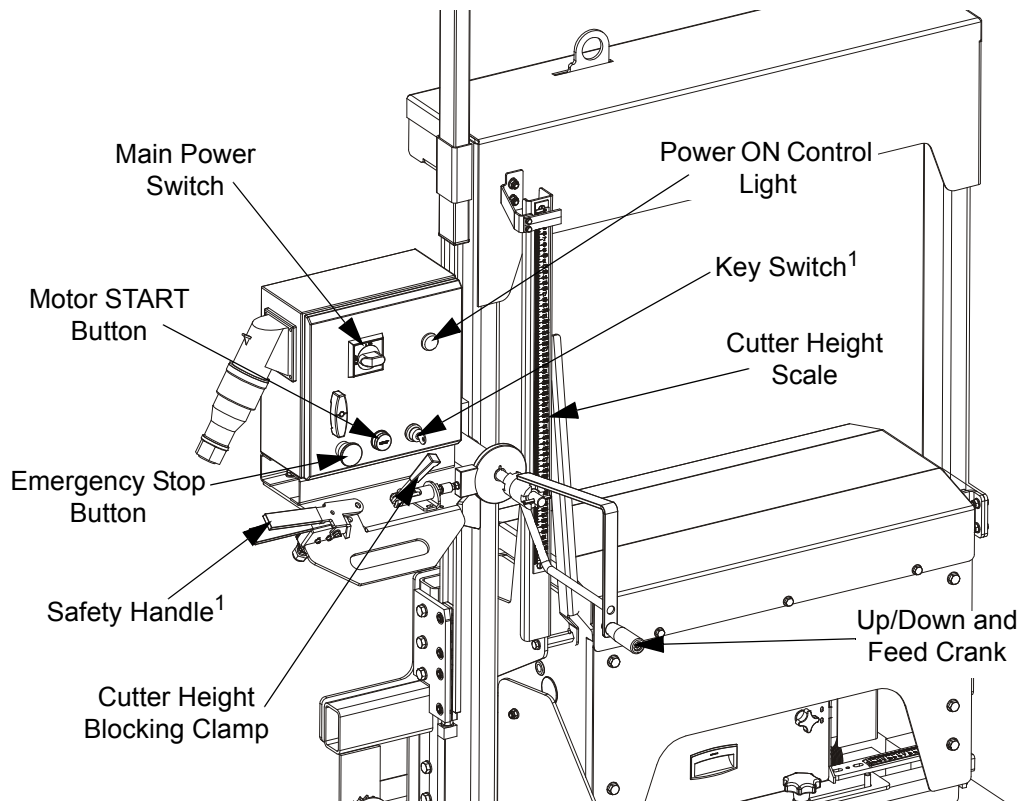




FIG. 4-2

#### 1. Key Switch<sup>1</sup>

The key switch has three positions:

- "0" position - all electrical circuits are off,
-  position - all electrical circuits are on,
-  position - releases the motor brake.

#### 2. Safety Handle<sup>1</sup>

Stops the cutter motor when released.

#### 3. Motor START Button

<sup>1</sup> It does not concern the US version.

Starts the cutter motor. The motor can be started only when the safety handle is being held.

**4. Main Disconnect Switch**

Disconnects power from all electrical circuits of the machine.

**5. Power ON Control Light**

Indicates the power supply.

**6. Emergency Stop**

Push the emergency stop button to stop the cutter motor. Turn the emergency stop clockwise to release the stop. The machine will not restart until the emergency stop is released.

**7. Cutter Height Scale**

Indicates the cutter height.

**8. Cutter Height Locking Handle**

After setting the cutter height, secure the head in this position using the locking handle. **IMPORTANT!** Never start planing/moulding without locking the head.

**9. Up/Down and Feed Crank**

Allows forward/backward and up/down movement of the cutter head. **IMPORTANT!** Never push or pull the cutter head manually (without using the crank handle).

### 4.4.3 Up/Down Operation

Set the cutter head at the desired height. The height scale shows the height of the cutter with the knives above the bed rails.

**IMPORTANT!** Remember that the maximum planing thickness can be 4 mm.

1. Pull back the crank handle to engage the locking pins for up/down operation.
2. Loosen the locking handle.
3. Turn the crank handle clockwise to raise the head or counterclockwise to lower the head.
4. Secure the head in the desired position using the locking handle.

See Figure 4-4.

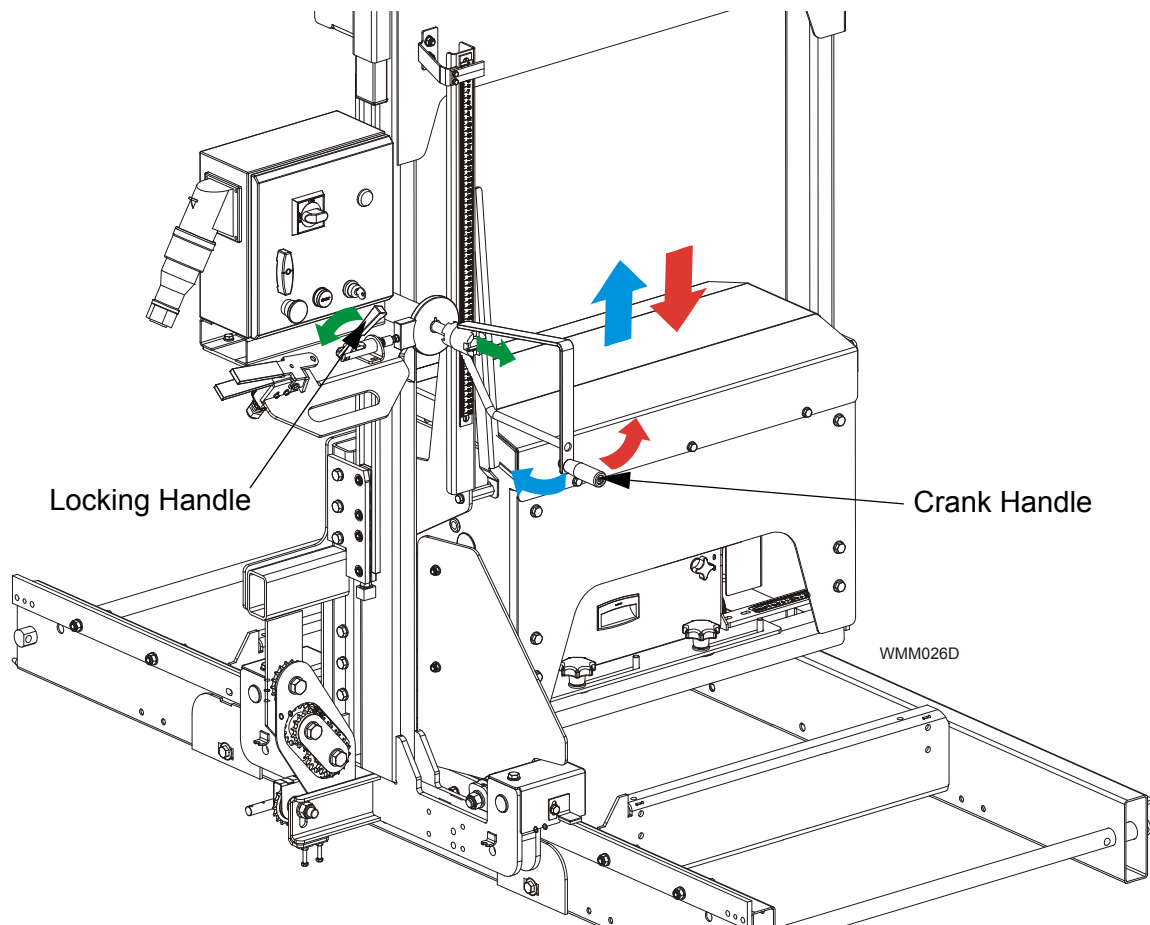


FIG. 4-4

**CAUTION!** DO NOT try to force the head above the 64,5 cm (25.4") mark or below the 5,5 cm (2.165") mark on the height scale. Damage to the up/down system may result.

#### 4.4.5 Feed Operation

1. Push the crank handle to engage the locking pins for feed operation.
2. Turn the crank handle clockwise to move the head forward or counterclockwise to move the head backward.

See Figure 4-6.

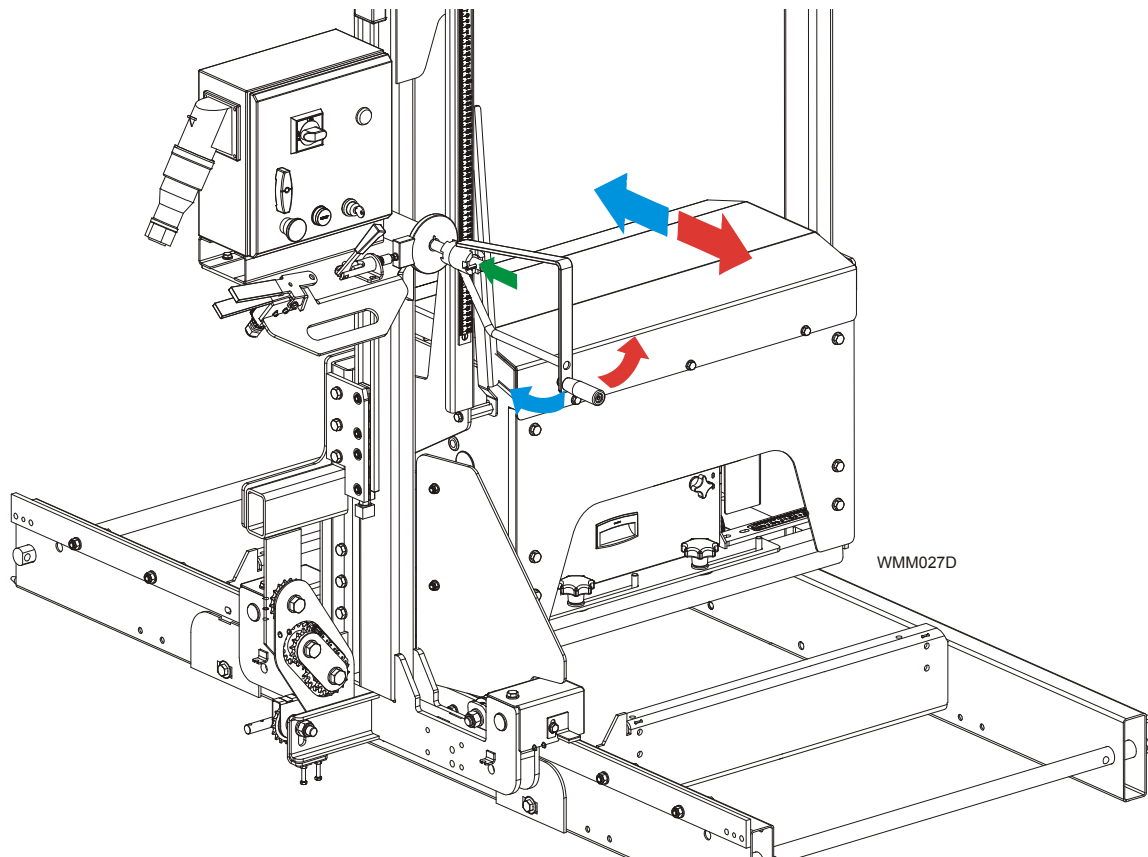


FIG. 4-6

**! DANGER!** Always firmly hold the safety handle and the feed crank handle. Be aware that the moulding head can move towards you when you are working with hard wood or if the material is not secured properly. The planing head can be moved by using the crank handle only. Never push or pull the planing head manually.

3. It is possible to adjust the cutter right or left. The maximum adjustment available is 110mm (4.33"). To slide the cutter, first loosen the locking knobs (4). Use the cutter scale to measure the distance from the initial position. (When the cutter is in the extreme left position, the cutter scale shows 0.) **IMPORTANT!** Always make sure that all locking knobs are firmly tightened before using the moulder.

See Figure 4-7.

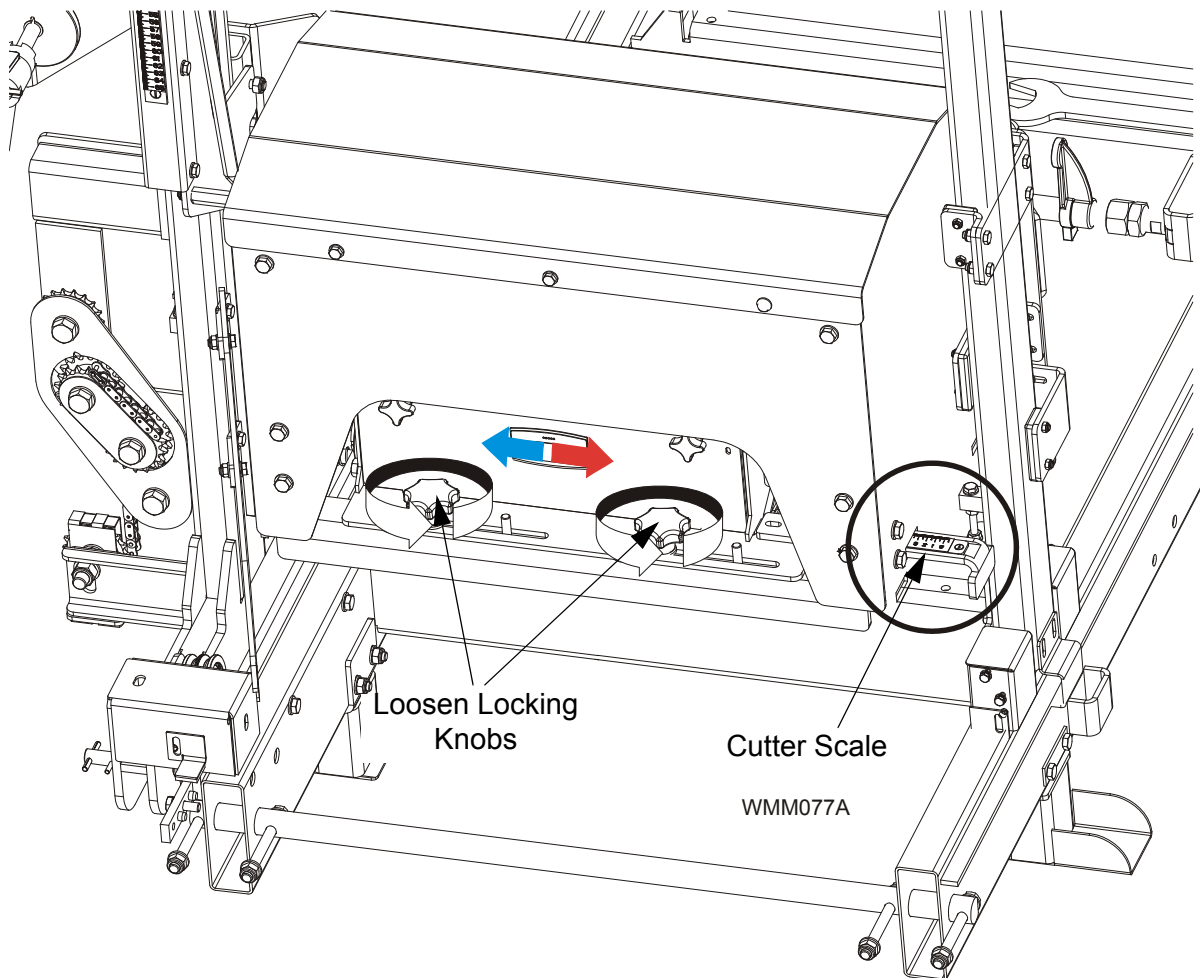


FIG. 4-7

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

- Cant dimensions
- Hardness of material to be planed/moulded. Some woods that are seasoned or naturally very hard will require slower feed rates.
- Sharpness of the knives. Dull or improperly sharpened knives will require slower feed rates than sharp and properly maintained knives.
- If you determine the pressure marks (small spots caused by wood debris around the edge of the knife) on the planed/moulded surface, it means that the feed rate is too high, the knives became dull or the dust extraction system is not sufficient.



## 4.5 Moulder Operation, MP150

### 4.5.1 Control Overview

See Figure 4-2. The controls of the MP150 moulder are shown below:

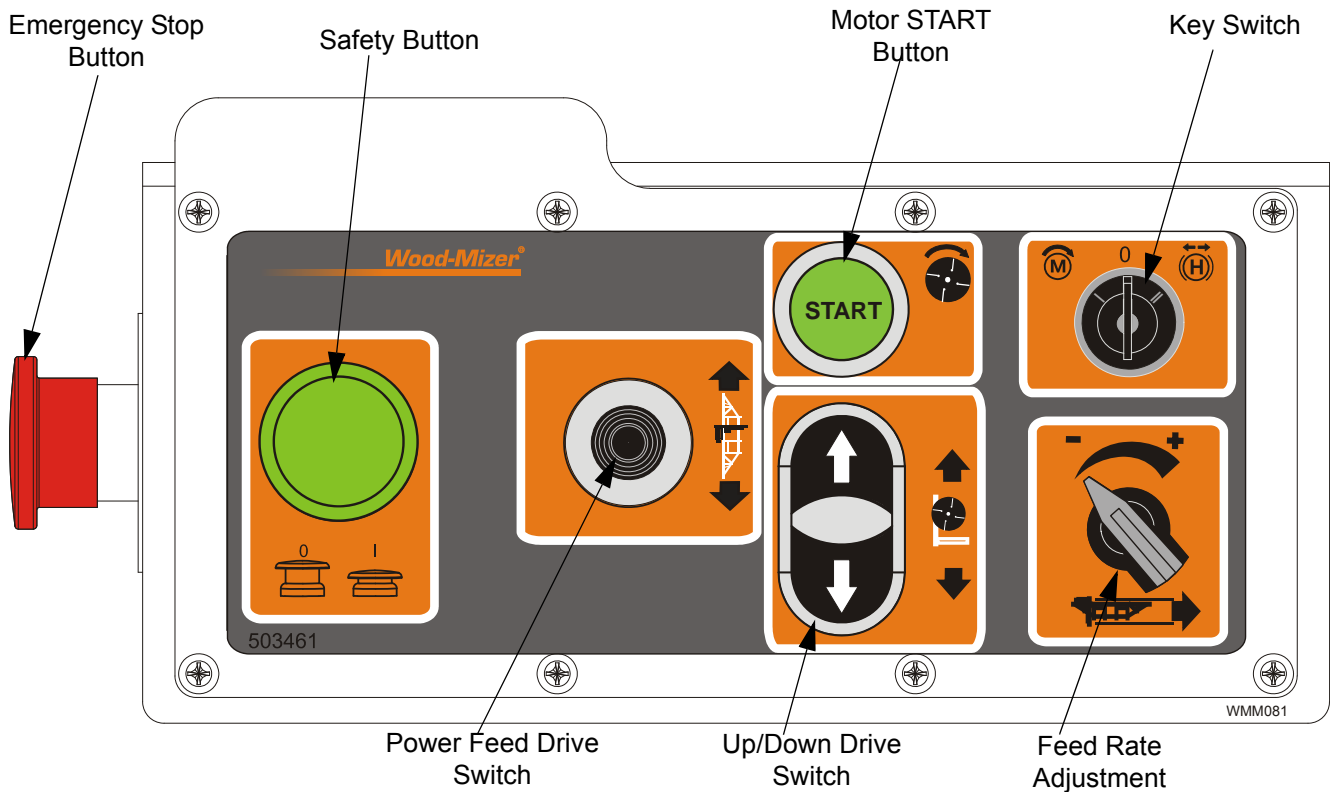




FIG. 4-2

#### 1. Key Switch

The key switch has three positions:

- "0" position - all electrical circuits are off,
-  position - all electrical circuits are on,
-  position - releases the motor brake.

#### 2. Safety Button

Stops the cutter motor when released.

#### 3. Motor START Button

Starts the cutter motor. The motor can be started only when the safety handle is being held.

**4. Power Feed Drive Switch**

The power feed switch controls the direction in which the moulder head travels. Push the switch upward to move the saw head forward. Push the switch down to move the saw head backward.

**5. Up/Down Drive Switch**

Starts the up/down drive and controls upward/downward movement of the moulder head.

**6. Feed Rate Adjustment**

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. The reverse feed speed is constant.

**7. Main Disconnect Switch**

Disconnects power from all electrical circuits of the machine.

**8. Power ON Control Light**

Indicates the power supply.

**9. Emergency Stop**

Push the emergency stop button to stop the cutter motor. Turn the emergency stop clockwise to release the stop. The machine will not restart until the emergency stop is released.


**10. Cutter Height Scale**

Indicates the cutter height.

### 4.5.3 Up/Down Operation

Set the cutter head at the desired height. The height scale shows the height of the cutter with the knives above the bed rails.

**IMPORTANT!** Remember that the maximum planing thickness can be 4 mm (0.157”).

1. Set the key in  position.
2. Push the up/down drive switch to set the head height.

See Figure 4-4.

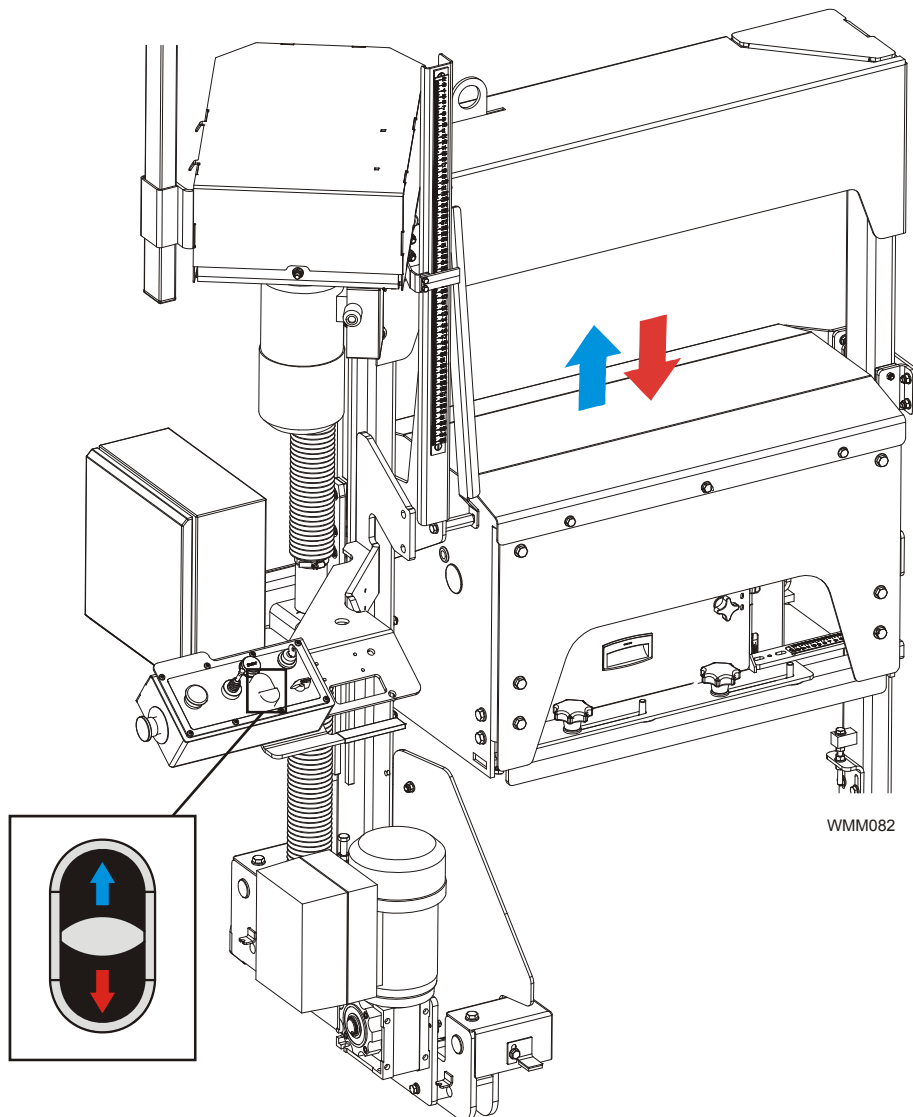



FIG. 4-4

**CAUTION!** DO NOT try to force the head above the 64,5 cm (25.4”) mark or below the 5,5 cm (2.165”) mark on the height scale. Damage to the up/down system may result.

### 4.5.5 Feed Operation

1. Set the key in  position.
2. Push the power feed switch to move the head forward or pull the switch to move the head backward.

See Figure 4-6.

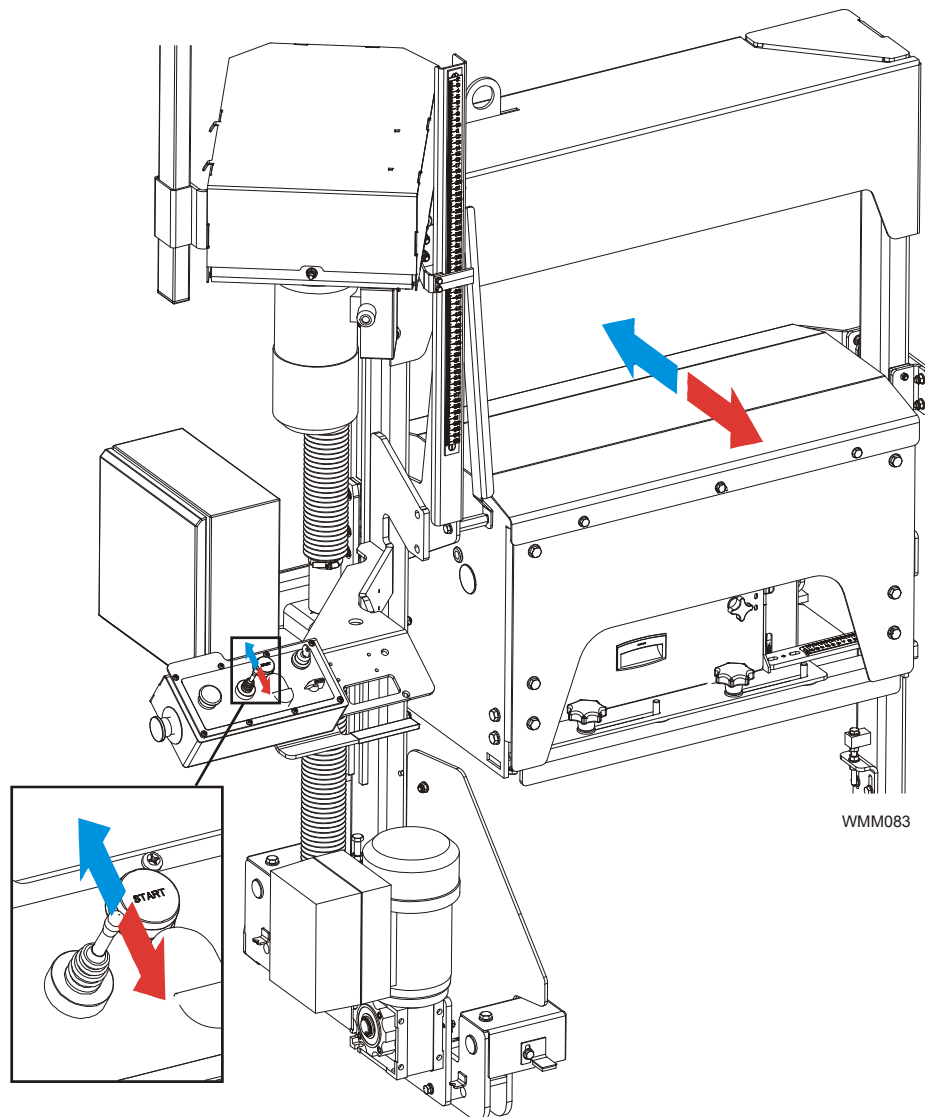


FIG. 4-6

3. It is possible to adjust the cutter right or left. The maximum adjustment available is 110mm (4.33"). To slide the cutter, first loosen the locking knobs (4). Use the cutter scale to measure the distance from the initial position. (When the cutter is in the extreme left position, the cutter scale shows 0.) **IMPORTANT!** Always make sure that all locking knobs are firmly tightened before using the moulder.

See Figure 4-7.

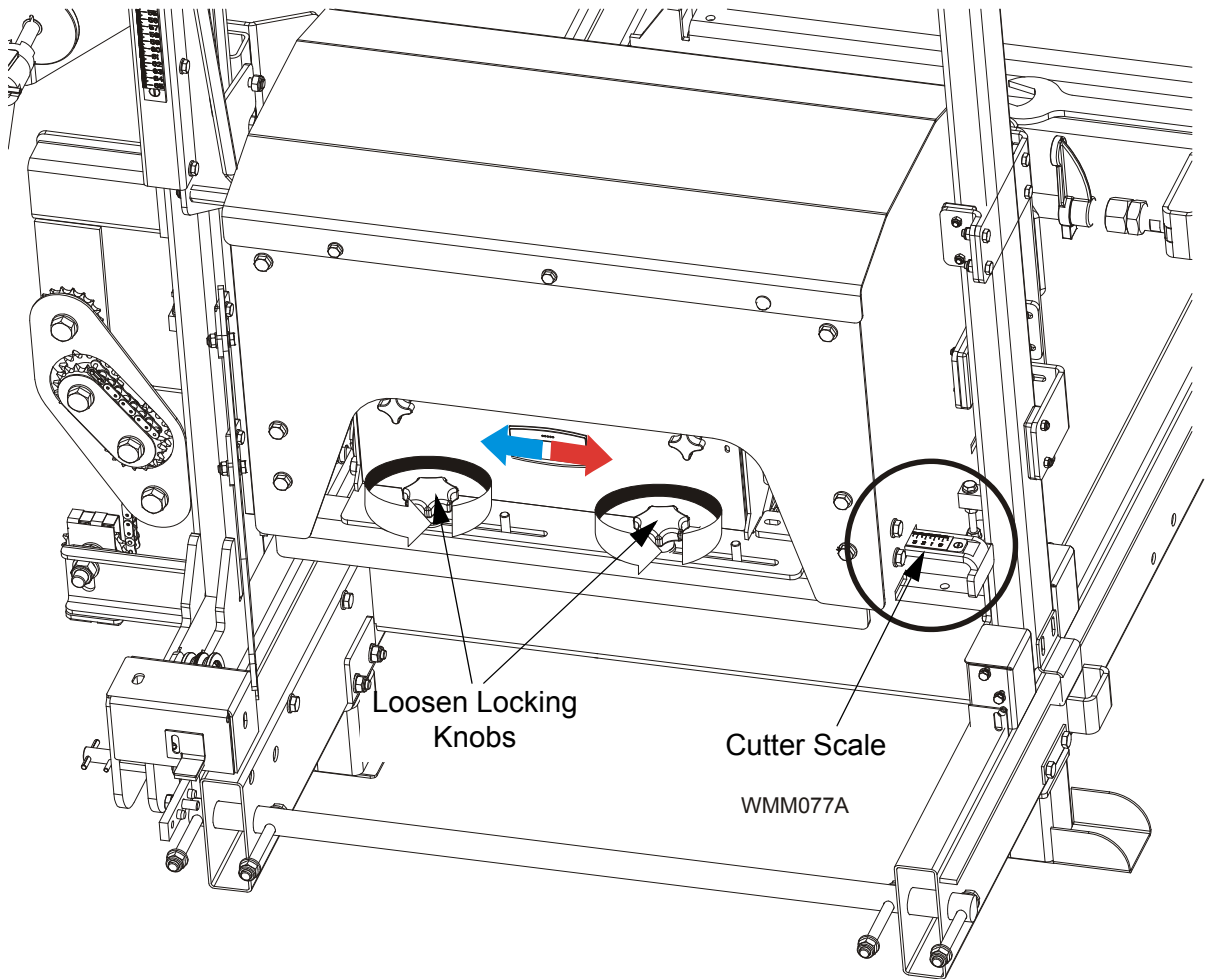


FIG. 4-7

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

- Cant dimensions
- Hardness of material to be planed/moulded. Some woods that are seasoned or naturally very hard will require slower feed rates.
- Sharpness of the knives. Dull or improperly sharpened knives will require slower feed rates than sharp and properly maintained knives.
- If you determine the pressure marks (small spots caused by wood debris around the edge of the knife) on the planed/moulded surface, it means that the feed rate is too high, the knives became dull or the dust extraction system is not sufficient.

## 4.6 Machine Start-Up (MP100)




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

- Close or mount any covers removed for service.
- Check that the wood to be planed/moulded is properly secured.
- Make sure that all persons are at a safe distance from the machine.
- Turn on the dust extraction system.
- Check if the emergency stop button is released.

**NOTE:** The machine will not start if the emergency stop is on.

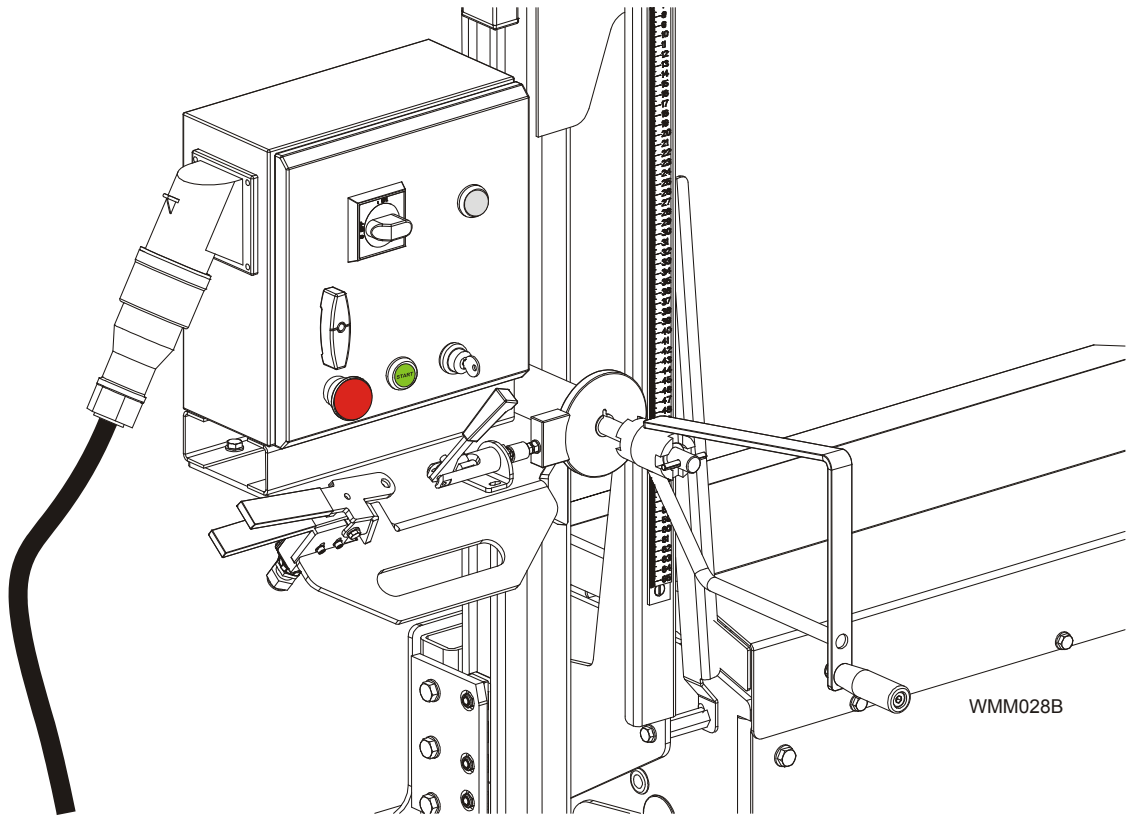
### To start moulding/planing:

1. Make sure that the head is secured at the desired height with the locking handle.
2. Turn the main switch on the electrical box to the ON position.
3. Press AND HOLD the safety handle. **NOTE:** If the safety handle is released, the cutter disengages and stops.<sup>1</sup>
4. Turn the key switch to  position.<sup>1</sup>

---

<sup>1</sup> It does not concern the US version.

5. Press the green START button on the electric box to start the motor.



**FIG. 4-8**

## 4.7 Machine Start-Up (MP150)



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

- Close or mount any covers removed for service.
- Check that the wood to be planed/moulded is properly secured.
- Make sure that all persons are at a safe distance from the machine.
- Turn on the dust extraction system.
- Check if the emergency stop button is released.

**NOTE:** The machine will not start if the emergency stop is on.

### To start moulding/planing:

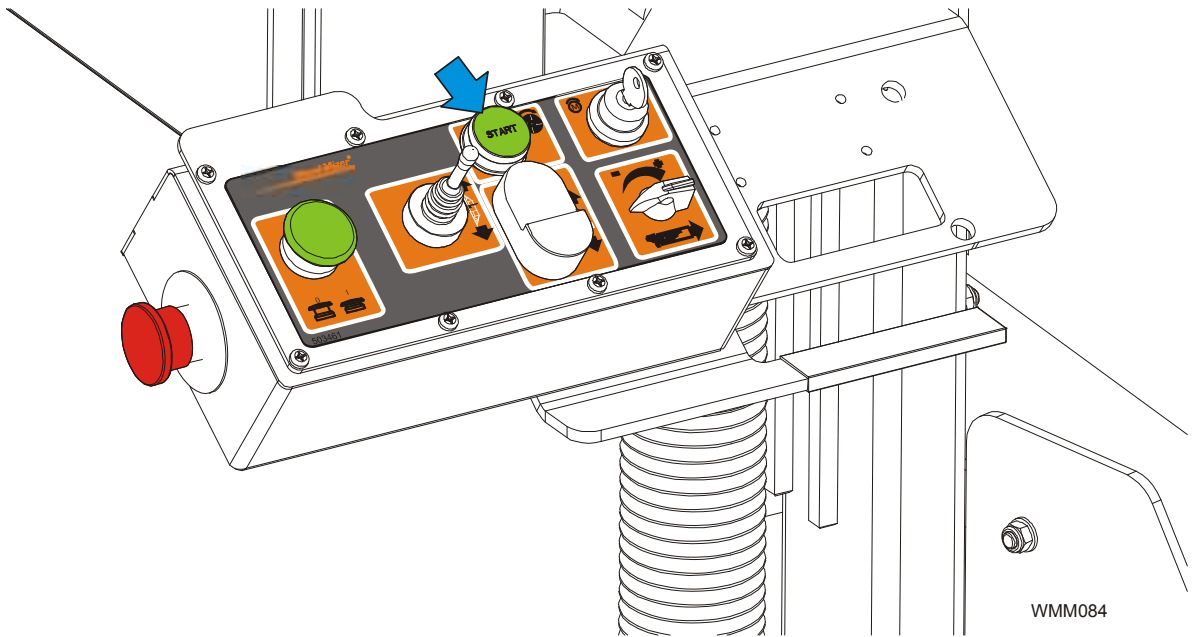
1. Set the head height as desired using the up/down buttons.
2. Turn the main switch on the electrical box to the ON position.
3. Press AND HOLD the safety button.

**NOTE:** If the safety button is released, the cutter disengages and stops.

4. Turn the key switch to  position.



5. Press the green START button on the electric box to start the motor.



**FIG. 4-8**

## 4.8 Track Roller Distance Adjustment

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

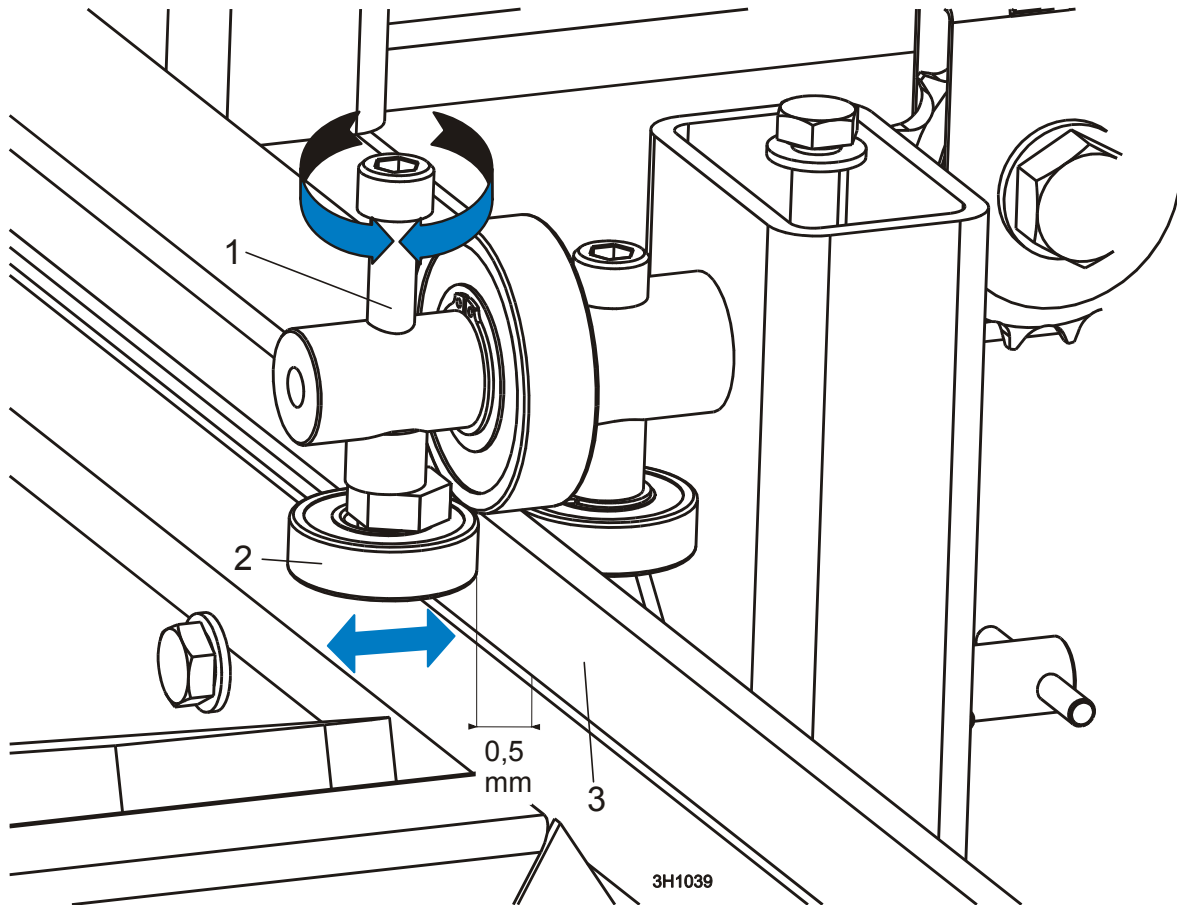
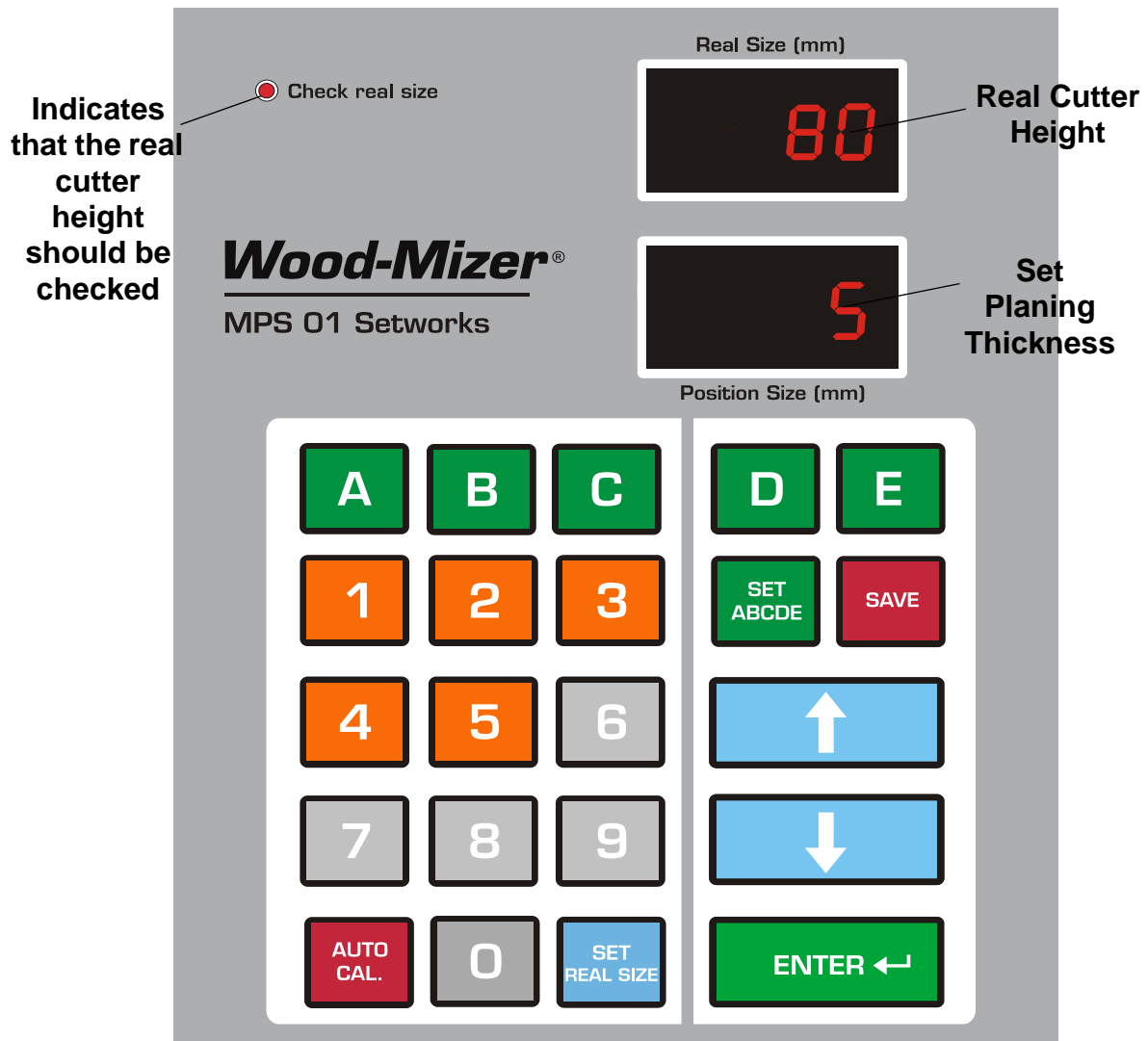


FIG. 4-9

## SECTION 5 NETWORKS OPERATION

### 5.1 Moulder Controller Panel

See Pic. 5-1.



PIC. 5-1

**Descriptions of the control panel buttons:**

A, B, C, D, E - planing/moulding thickness memory buttons.



SET ABCDE - used to set a planing/moulding thickness value under each memory button.



Save - saves parameters determined by the operator.



Cutter height manual setting buttons (up/down)



ENTER ← - enters a value into the Networks memory




Auto Mode – adjustment of the Networks automatic calibration parameters. Used for initial calibration and recalibration if a dimensional error occurs.

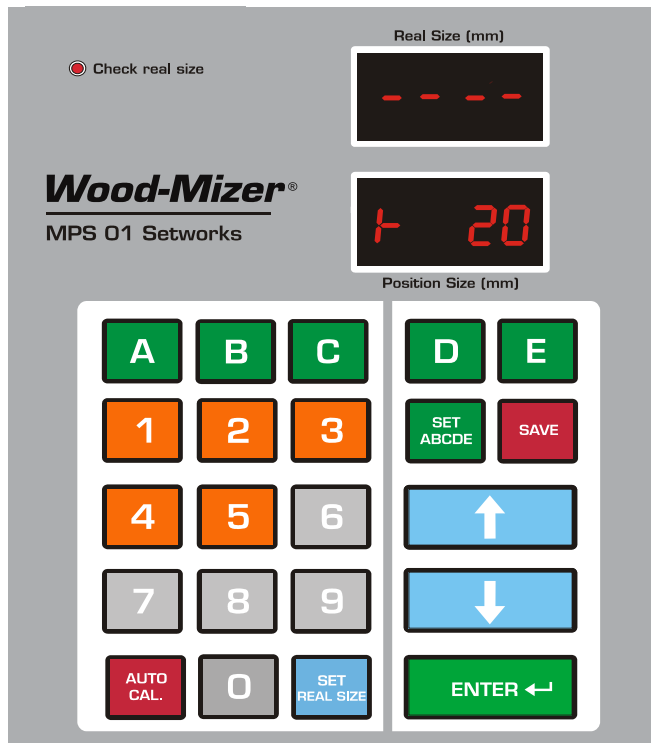


Set Real Size - used to set a real cutter height. The real cutter height should be set when the "Check real size" indicator light blinks.


**5.2 Start-up settings of the controller****1. Setting the input divider (entered only once, at the first start-up)**

- Switch on the controller by turning the main switch to the ON position.
- When the inscription "MPS-01" appears on the display, press and hold  until the divider value appears on the lower display.
- Enter the correct value of the divider (for the MP150 Moulder-Planner the divider value should be 20).

See Pic. 5-2.





PIC. 5-2

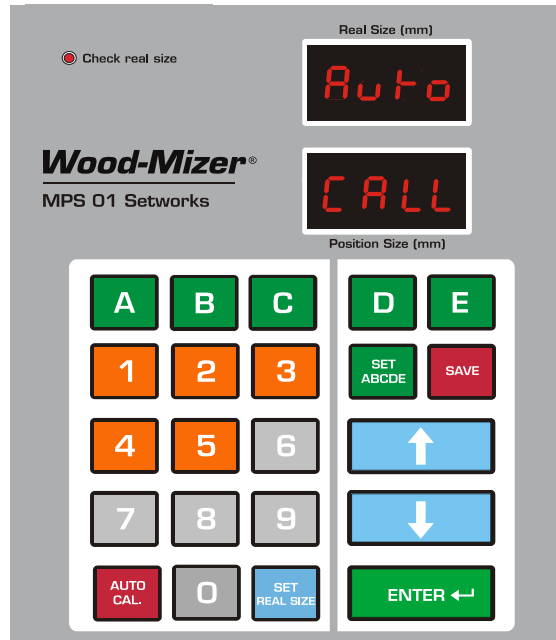
- Press  to save the entered divider value.

### 1. Auto-calibration


This function should be used in case of: replacement of any component of the cutter height setting system, motor or after lubrication of the up/down screw and other moving elements or when significant cutter height setting variances are observed.

- Switch on the moulder by turning the main switch to the ON position and wait until the inscription “MPS-01” disappears.
- Using  buttons, set the cutter at the height of 200 mm.
- Press and hold down . After a while - the message “Auto CALL” will appear on the displays. The controller is ready for auto-calibration.

See Pic. 5-3.



PIC. 5-3


- Press  again, the controller successively performs some movements of the cutter. After performing the last movement, the controller is ready for operation.

## 2. Real cutter height entering

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

- significant cutter height setting variances are observed;
- a sudden power disappearance occurs while the controller is setting the cutter height;
- any repairs to the up/down system were made.


To enter the real cutter height:

- Press and hold ,
- Move the cutter to an even measurement on the scale (e.g. to 250mm),
- Measure the distance between the bottom knife and the moulder bed and make sure that the scale


shows the same distance. If not, [See Section 4.1](#) for the alignment instructions.



- Enter the measured distance without a pause. For example: if you want to enter 250mm - press **2-5-0-0** without a pause. Confirm by pressing .

### 5.3 Memory Buttons (A, B, C, D, E)


After switching-on, the “MPS-01” inscription appears on the display, and the Setworks is ready for operation within a few seconds or after  is pressed.


The Setworks is designed to automatically lower the cutter (by 1mm / 0.039” - 5 mm / 0.197” ) below its current position. **IMPORTANT!** Remember that the maximum planing thickness can be 4 mm.

- To automatically lower the cutter, enter the required value (from 1mm / 0.039” - 5 mm / 0.197” ) using the keypad and press . The cutter will automatically be lowered by the entered value.

- You can also change the cutter position using  .

You can store up to five values using the memory buttons.

- To store the value, press and hold . The inscription “ABC” will appear on the upper display.

Press the memory button (A, B, C, D or E), enter the value and confirm by pressing .

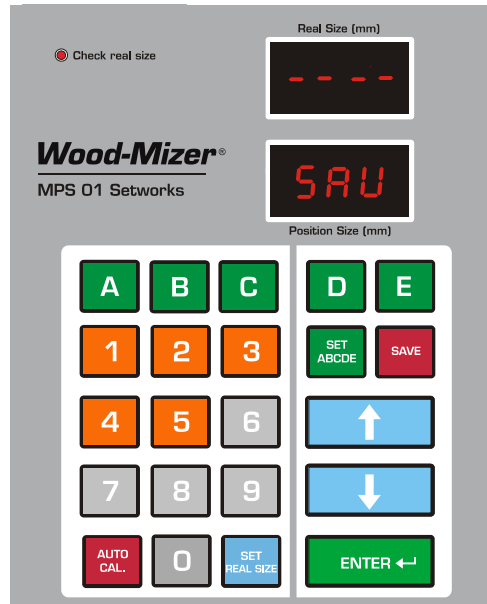
Perform the same procedure for other memory buttons.

# 5


## NETWORKS OPERATION



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

See Pic. 5-4.



PIC. 5-4

- To use any stored value, press the corresponding memory button and confirm by pressing . The cutter will move by the selected value.

**NOTE:** If the “Check real size” light starts blinking during normal operation of the Networks, press and hold the  button. Measure and enter the distance between the bottom knife and the moulder bed exact to 0.1 mm. For example: if you want to enter 250mm - press **2-5-0-0** without a pause and confirm by pressing .



## SECTION 6 MAINTENANCE

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



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

### 6.1 Wear Life

**See Table 6-1.** 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 machine 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
Drive Belt	1250 hours

TABLE 6-1

### 6.2 Sawdust Removal



Remove the excess sawdust and chips from the cutter housing using compressed air, and from the bed frame using a brush every eight hours of operation.

### 6.3 Head Track & Rollers

**See Figure 6-1.**



**1.** Clean the track rails to remove any sawdust and sap buildup every eight hours of operation.



**2.** Remove sawdust from the track roller housings. Remove the track roller housing covers and brush

any sawdust buildup from the housings.

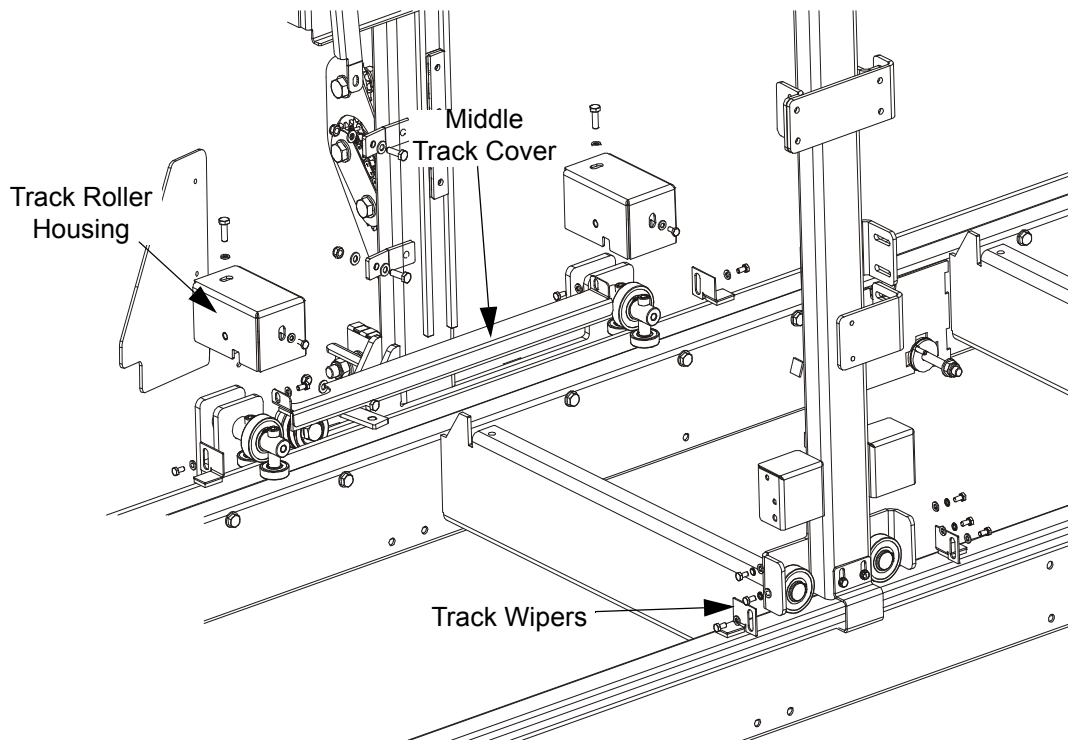


FIG. 6-1

## 6.4 Vertical Mast

- 50 Clean and lubricate the vertical mast in places where the head is travelling every 50 hours of operation. Clean with solvent and remove any rust with a light-grade sand paper or an emery cloth. Lubricate the mast with motor oil or automatic transmission fluid (ATF).



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

## 6.5 Miscellaneous Lubrication

- 50 1. Oil all chains with Dexron III ATF every fifty hours of operation.



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

## 6.6 Manual Up/Down System

1. Adjust the up/down chain tension as needed. Measure the chain tension with the head all the way to the top of the vertical mast. Secure the head with a chain at the top, or shim it underneath. Find the chain adjusting bolts at the bottom of the mast. Loosen the sprocket nut on the bolt and lock nuts and using the adjustment bolts move the sprocket down until there is about 1" (2.5 cm) deflection in the center of the chain with a 2,3 Kg (23 N) deflection force. The adjustment bolts must be adjusted evenly.



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

See Figure 6-2.

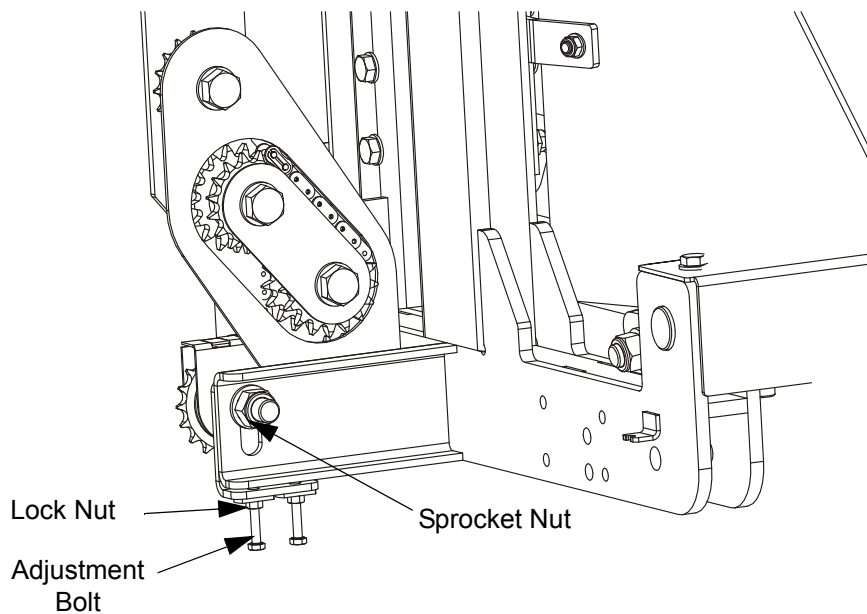


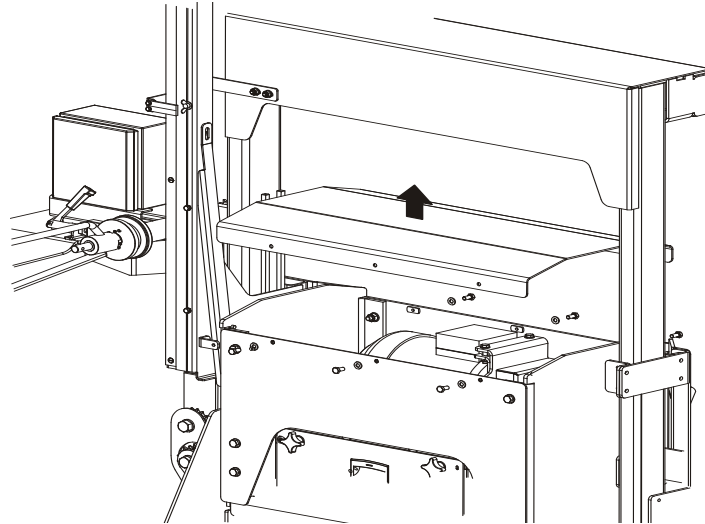
FIG. 6-2

## 6.7 Drive Belt Tension Adjustment

Check the cutter drive belt tension after the first 20 hours, and every 50 hours thereafter.

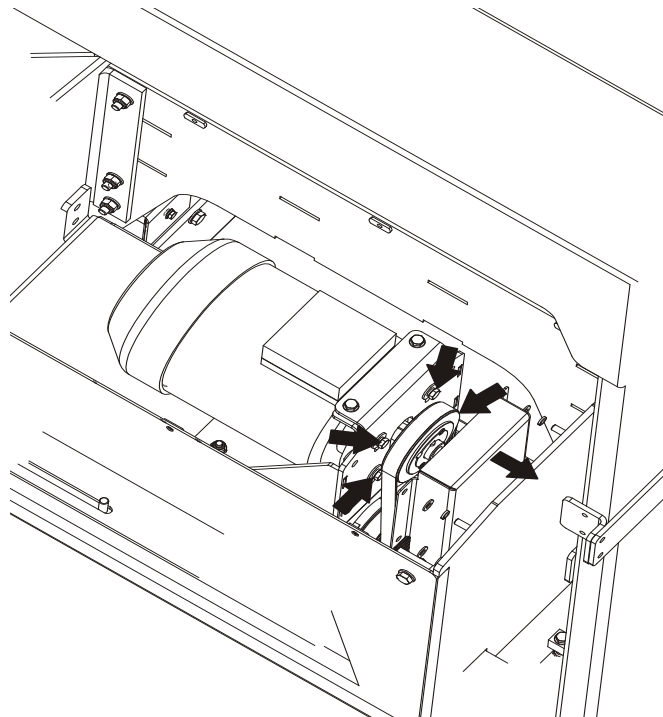
50

1. Remove the cutter upper cover.



**FIG. 6-2**

2. Remove the belt cover and loosen four motor mounting bolts.



**FIG. 6-2**

3. Keep the pulleys aligned to avoid premature belt and pulleys wear.

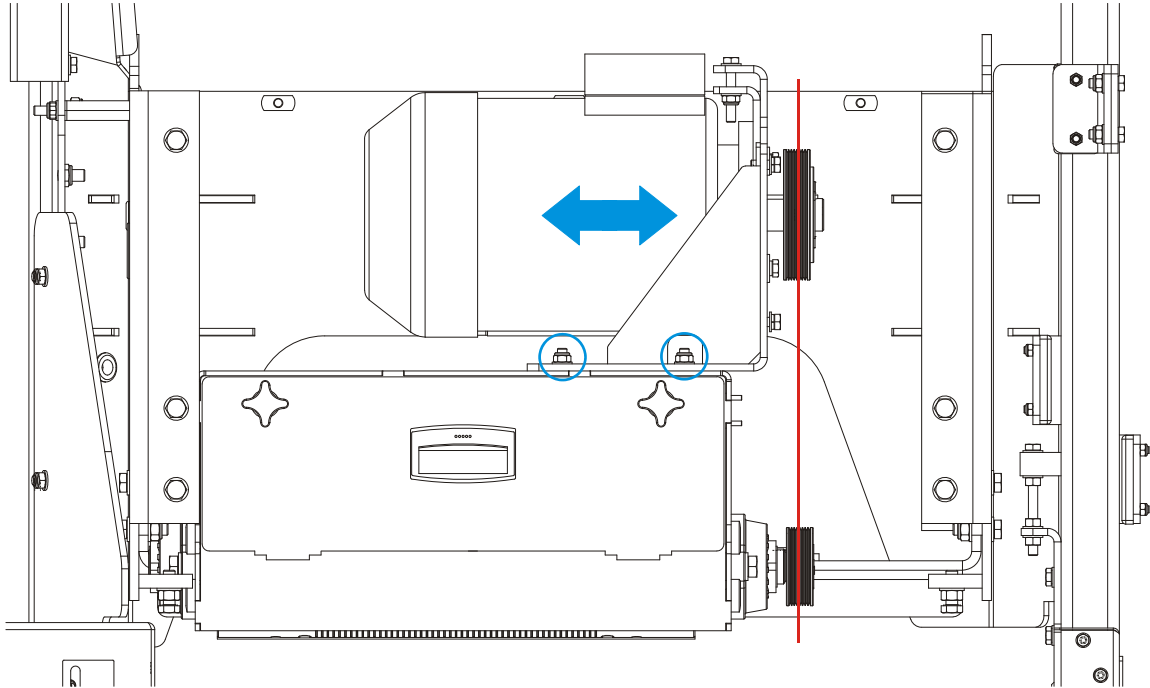


FIG. 6-2

- Using the adjustment bolts, move the motor mounting plate up to tension the drive belt or move it down to loosen the belt. Next, tighten the mounting bolts. The belt should be tightened so there is 10 mm (0.393") deflection with a 10 kg (98 N) deflection force.

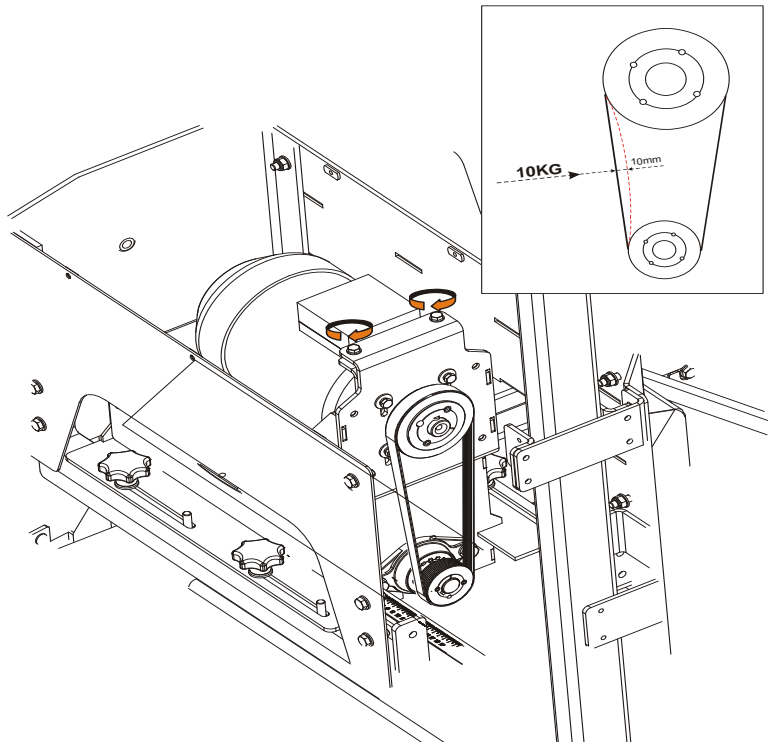


FIG. 6-2



**CAUTION!** After replacement of the motor drive belt, always adjust the belt tension as described above. Then turn on the motor for 5 minutes and check the belt tension again. If the belt deflection is greater than 10 mm (0.393"), adjust the belt tension again.

## 6.8 Cutter Bearings

When you discover cutter vibrations not caused by improper knife mounting, check the cutter bearings for wear. Replace if needed. The bearings do not require lubrication.

## 6.9 Long-Term Storage

If the machine is not used for a long period of time, do as follows:

- Disconnect the power cord.
- Perform all routine actions described above.
- Remove the knives with mounting strips or clamping wedges and store them well lubricated in above zero temperature.
- Loosen the motor belt tension.
- Spray a thin layer of anti-rust coating (such as P.D.R.P) onto the places not protected against rusting.
- Store the machine in a well ventilated room.

## 6.10 Electrical Up/Down System

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



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

See Figure 6-3.

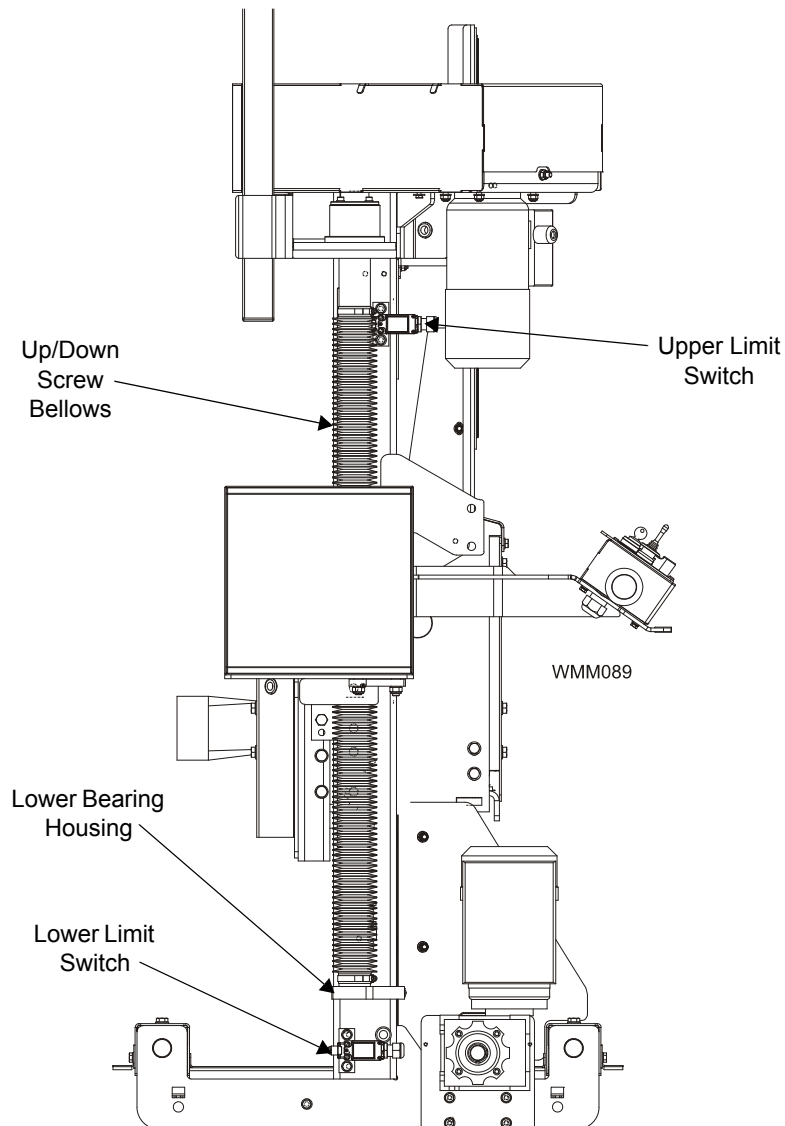


FIG. 6-4

2. Lubricate the up/down acme screw with a rolling bearing lubricant (e.g. LT4S 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 the 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 (0.0492").

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





See Figure 6-5. Unbolt the up/down top guard. Loosen the motor mounting bolts. Use the adjustment bolt shown below to adjust the belt tension. Tighten the motor mounting bolts. Replace the top guard.

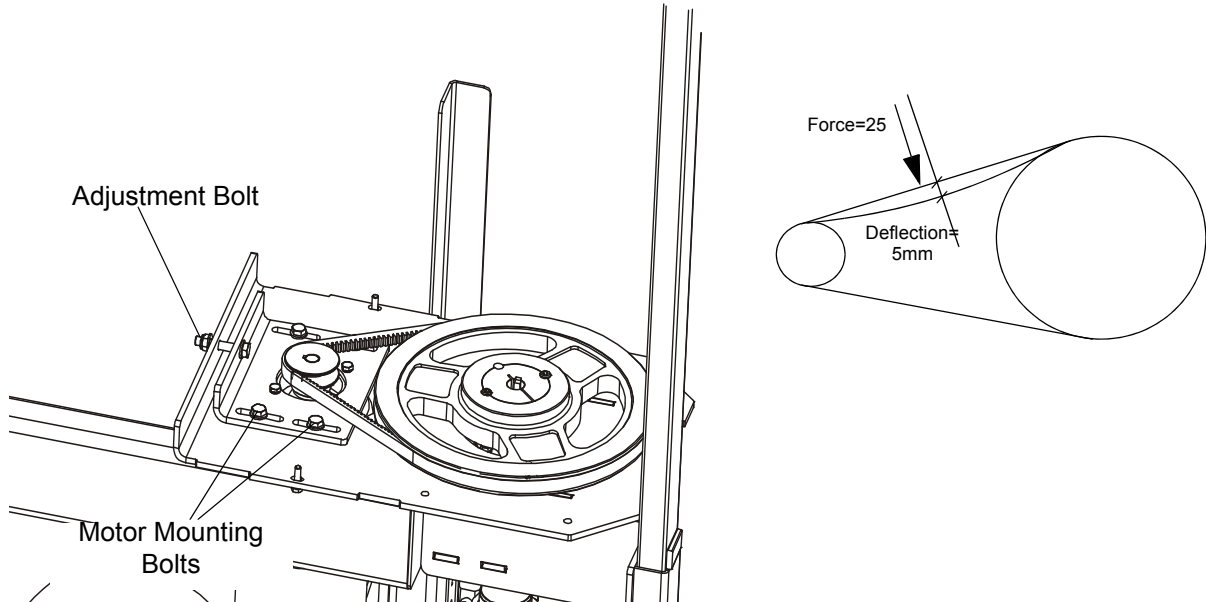


FIG. 6-6

4. Every 200 hours of operation check and adjust the up/down motor brake air gap if necessary.<sup>1</sup>

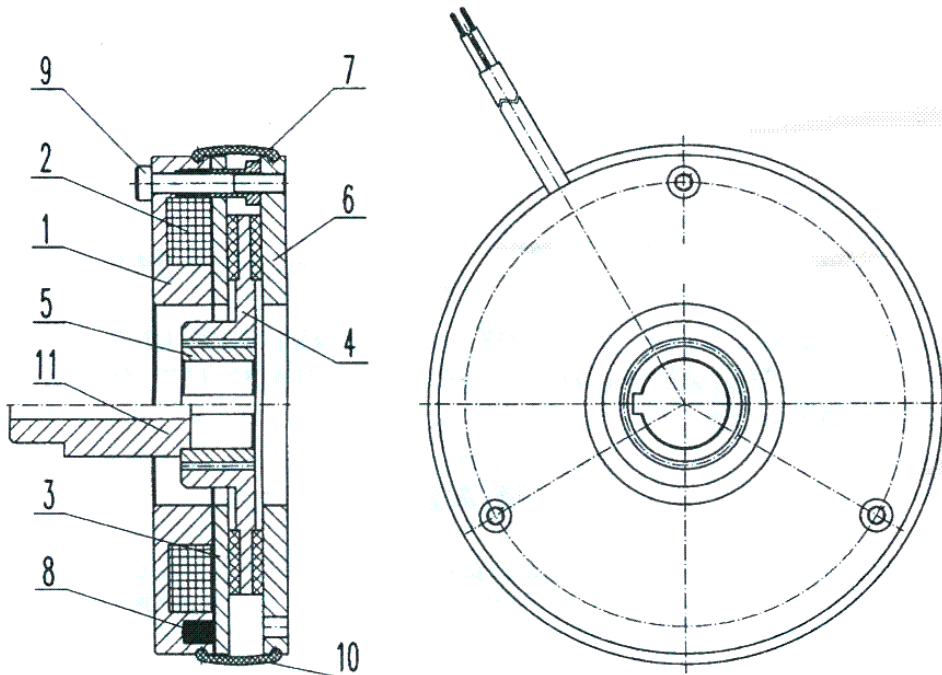


FIG. 6-7

1. It does not concern the US version.

1. Electromagnet body
2. Coil
3. Armature
4. Brake disk
5. Gear wheel
6. Mounting disk
7. Adjusting bolt
8. Spring
9. Mounting bolt
10. Brake casing
11. Tooled Bushing

### ADJUSTMENT OF AIR GAP

The air gap „a" grows gradually larger in consequence of wear of brake disc lining (4). The nominal value of the air gap „a nom " may be restored by screwing in the adjusting bolts (7). Prior to adjustment, slacken mounting bolts (9) and then set the nominal value of air gap using the feeler gauge inserted between armature (3) and body and screwing in the adjusting bolts (7). Tighten the mounting (9) and secure the position by screwing out the adjusting bolts as far as they go.

**Table 5:**

TYPE	HPS08
a nom.	0,2 ± 0,05
a max.	0,5

### BRAKE 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.

## 6.11 Safety Devices Inspection

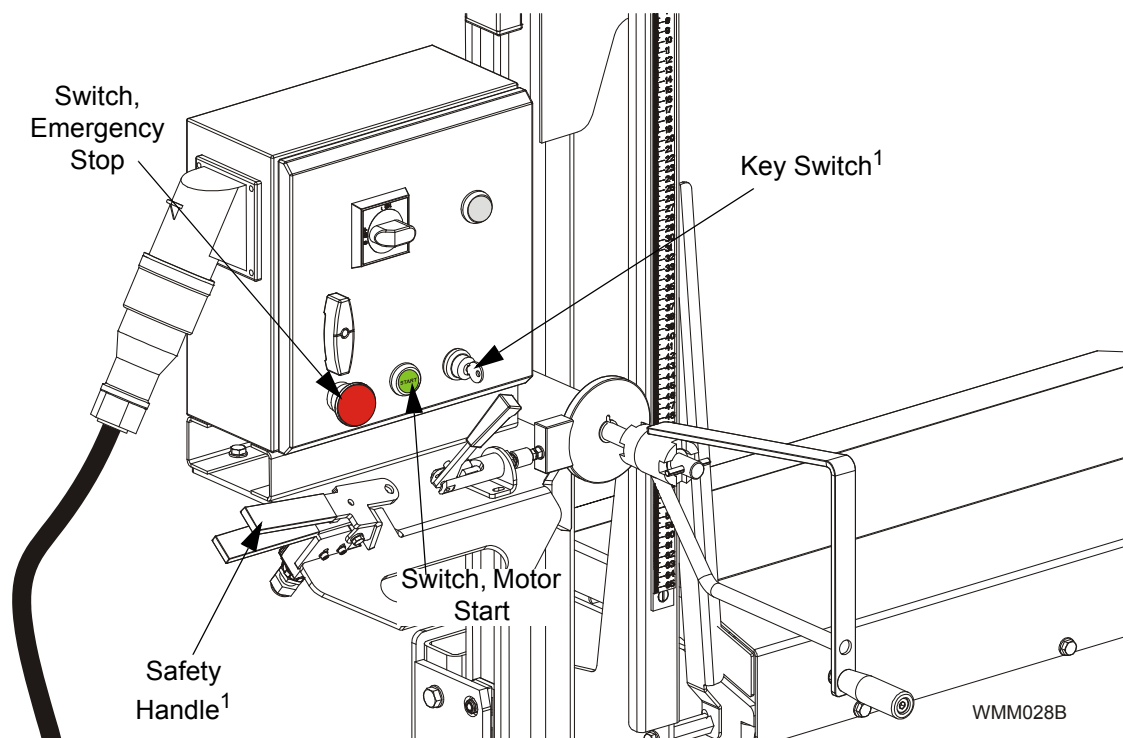
### *MP100E5S Moulder – Safety Devices Inspection*

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

- E-STOP button and its circuit inspection
- Safety handle and its circuit inspection<sup>1</sup>
- Cutter cover safety switch and its circuit inspection.

#### 1. E-STOP button and its circuit inspection

- Turn the key switch to the “M” position;<sup>1</sup>
- Press and hold the safety handle;<sup>1</sup>
- The START button should illuminate green;
- Press the START button to start the motor. The motor should start.
- Press the E-STOP button located on the control box. The motor should be stopped. Pressing the START button should not start the motor until the E-STOP button is released and the START button is pressed.



1. It does not concern the US version.

## 2. Safety handle and its circuit inspection

- Turn the key switch to the “M” position;<sup>1</sup>
- Be sure the E-STOP button is released;<sup>1</sup>
- Press and hold the safety handle;
- The START button should illuminate green;
- Press the START button to start the motor. The motor should start.
- Release the safety handle. The motor should be stopped.<sup>1</sup>
- Press the START button. The motor should remain stopped.
- Press and hold the safety handle. The START button should illuminate green, but the motor should remain stopped.<sup>1</sup>

## 3. Cutter cover safety switch and its circuit inspection

- Turn the key switch to the “M” position;
- Be sure the E-STOP button is released;
- Press and hold the safety handle;<sup>1</sup>
- Turn on the motor;
- Open the cutter housing cover;
- The motor should be stopped;
- Try to start the motor. The motor should remain stopped;
- Close the cutter housing cover;
- The motor should remain stopped until it is restarted with the START button.

## 4. Cutter motor brake inspection

- Turn the key switch to the “M” position;<sup>1</sup>
- Be sure the E-STOP button is released;
- Press and hold the safety handle;<sup>1</sup>
- Turn on the motor;

---

1. It does not concern the US version.

- Release the safety handle. Measure the cutter braking time. It should be shorter than 10 seconds;<sup>1</sup>
- Start the motor again;
- Turn the key switch to the “0” position. Measure the cutter braking time. It should be shorter than 10 seconds;
- Start the motor again;
- Turn the key switch to the “H” position. Measure the cutter braking time. It should be shorter than 10 seconds.

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1. It doesn't concern US version.

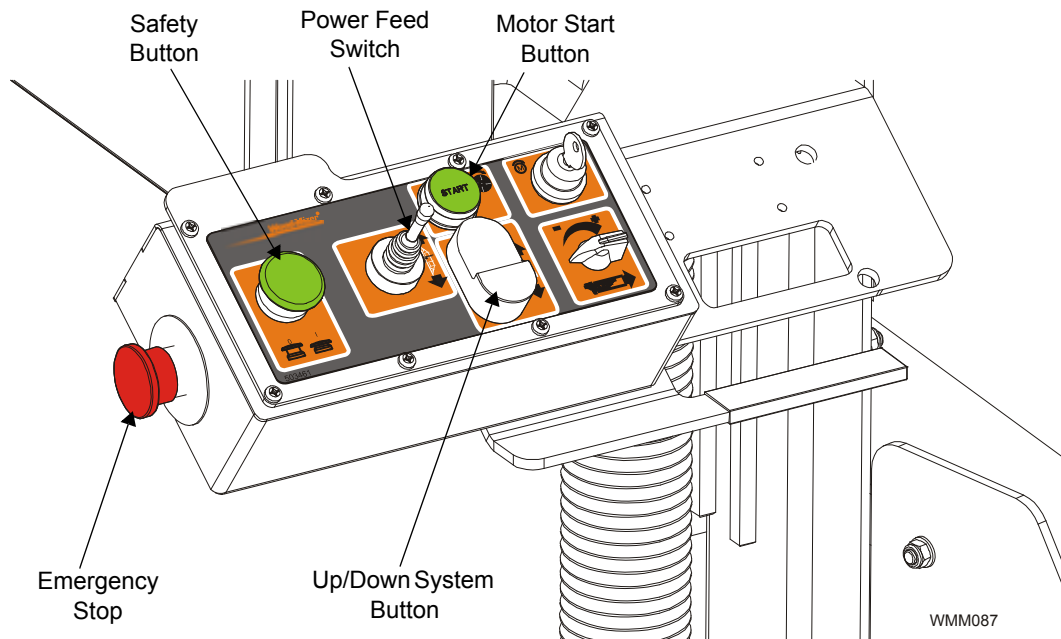
### MP150E5S Moulder – Safety Devices Inspection

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

- E-STOP button and its circuit inspection
- Green safety button inspection
- Inspection of the control circuits with the E-STOP button pressed
- Cutter 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 cutter motor;
- Press the E-STOP button located on the left side of the control box. The cutter motor 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 moulder motor. The motor should be started.
- Release the safety button. The moulder motor should be stopped.

- Try to start the motor without pressing the safety button. The moulder motor should remain stopped.
- Press and hold the green safety button. The moulder motor should remain stopped.

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

- Press and hold the green safety button;
- Turn on the moulder motor;
- Press the E-STOP button located on the left side of the control box. The moulder motor should be stopped.
- With the E-STOP button pressed, try to move the moulder head up and down using the up/down system button and forward/backward using the power feed switch. Both systems should not start.

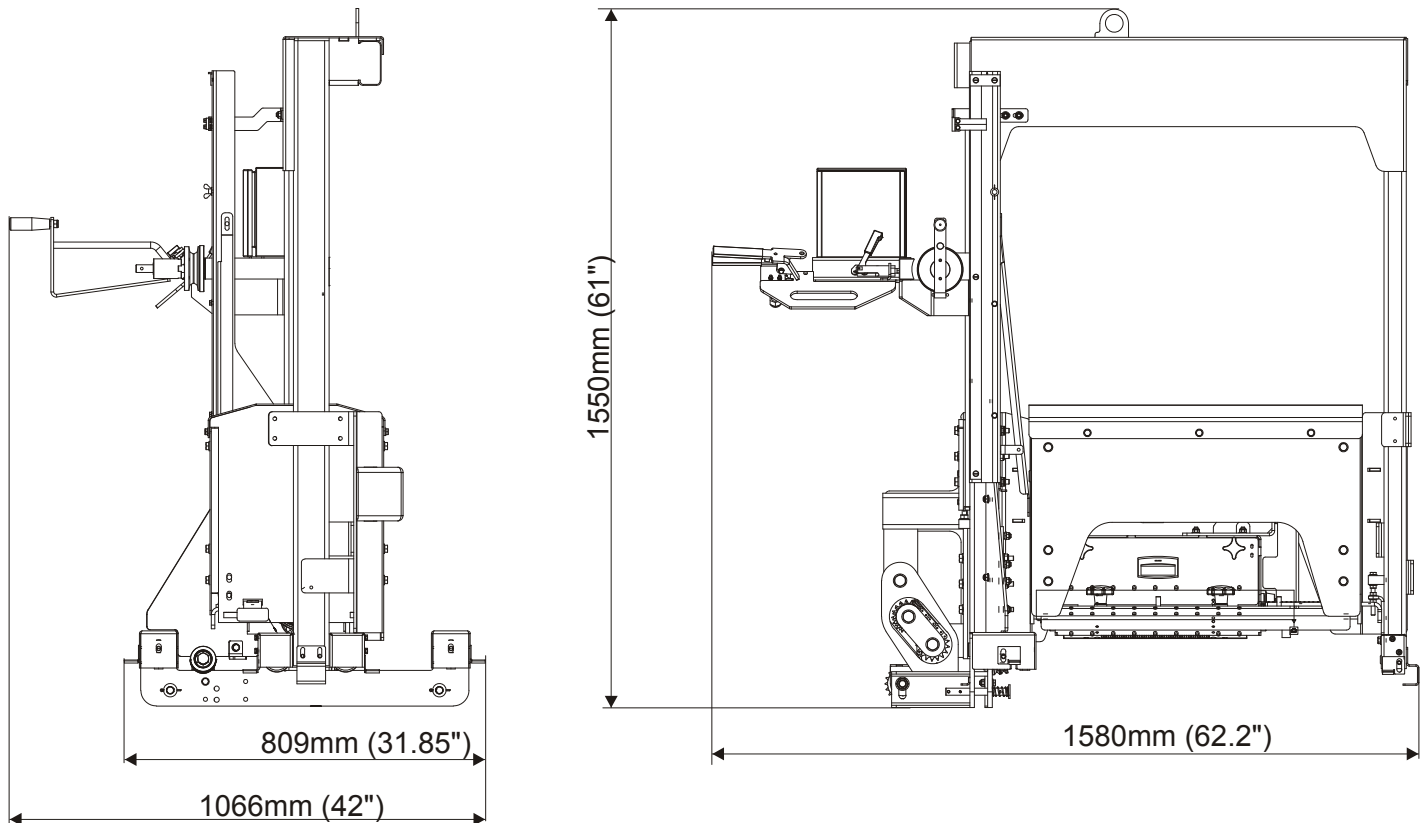
### **4. Cutter housing cover safety switch and its circuit inspection**

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

## SECTION 7 SPECIFICATIONS

### 7.1 Overall Dimensions

See Figure 7-1. The major dimensions of the MP100 moulder are shown below (all dimensions are in millimeters).



**FIG. 7-1 MP100**

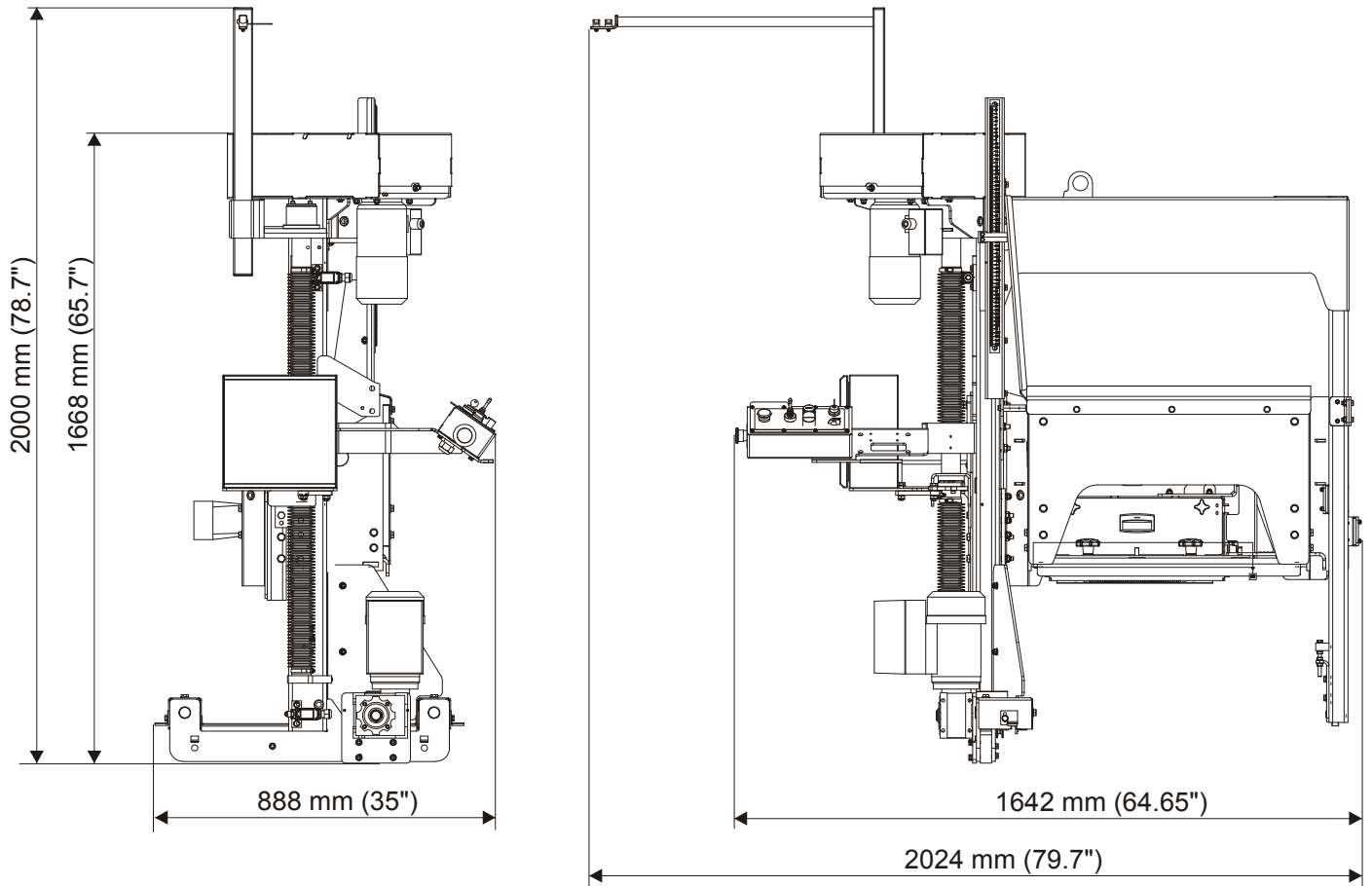
See Table 7-1. The MP100 moulder mast with head dimensions and weight are listed below.

Moulder Type	MP100
Weight	350 kg (772 lb)
Height	1550 mm (61")
Width	1580 mm (62.2")
Length	1066 mm (42")

**TABLE 7-1**



See Figure 7-2. The major dimensions of the MP150 moulder are shown below (all dimensions are in millimeters).



**FIG. 7-2 MP150**

See Table 7-2. The MP150 moulder mast with head dimensions and weight are listed below.

Moulder Type	MP150
Weight	360 kg (793 lb)
Height	2000 mm (78.7")
Width	2024 mm (79.7")
Length	888 mm (35")

**TABLE 7-2**

## 7.2 Moulder Specifications

See Table 7-3. See the table below for the Wood-Mizer moulder nomenclature.

	Voltage
MP100EA5-1 USA	1 ph 230V UL
MP100EB5-1	3 ph 230V
MP100EB5S-1	3 ph 230V CE
MP100EC5-1	3 ph 460V
MP100EC5-1 USA	3 ph 460V UL
MP100EH5S-1	3 ph 400V CE

TABLE 7-3

See Table 7-4. See the table below for the Wood-Mizer main moulder motor specifications.

	Motor Specifications	Motor Specifications	Motor Specifications, USA	Motor Specifications, USA
Motor Type	E5 Electric Motor	E5 Electric Motor	E5 Electric Motor	E7.5 Electric Motor
Manufacturer	Indukta, Poland	Siemens	Siemens	Leeson
Voltage	230/400V 50Hz	230/400V 50Hz	460V 60Hz	230V 60Hz
Maximum Current	14.2/8.2 A	13.6/7.9 A	7.9 A	36 A
Motor RPM	2885 RPM	2880 RPM	3480 RPM	3600 RPM
Rated Output	4kW (5.4HP)	4kW (5.4HP)	4.4kW (6.0HP)	5.6kW (7.5HP)
Manufacturer Part #	PSKg 100L-2 HM	1LA9106-2LA92-Z L2T+D31	1LA9106-2LA92-Z L2T+D31	C213K34FK1B
WM Part #	500627	500627-UL	500627-UL	053790

TABLE 7-4

See Table 7-5. The power options available for the moulder are listed below.

Engine/Motor Type	WM No.	Manufacturer	Model No.	Specifications
Up/Down Motor 0.55kW	503457	Besel	SKh71X-6C2/H2SP	3x 230/400VAC, 50Hz 1000 RPM
Power Feed Motor 0.55kW	083694	Dutchi Motors, Holland	DMA 80K4	230/400V, 50 Hz

TABLE 7-5

See Table 7-6. The noise level of the MP100/150 moulder is given below.<sup>1 2</sup>

	Equivalent Noise Level Under Load
MP100/150 Moulder Equipped With E5 Electric Motor	$L_{AeqTe} = 98 \text{ dB (A)}$

**TABLE 7-6**

See Table 7-7. See the table below for planing/moulding material specifications.

Minimum Cant Height	60 mm (2.362")
Maximum Cant Height	600 mm (23.62")
Maximum Cant Width <sup>1</sup>	520 mm (20.47")

**TABLE 7-7**

<sup>1</sup> Using horizontal adjustment

See Table 7-8. Other specifications of the moulder are listed below.

Cutter Specifications	
Number of Knife Sockets	4
Cutter Diameter	122 mm (4.8")
Cutter Width	410 mm (16.14")
Cutter Horizontal Adjustment	110 mm (4.33")
Cutter Rotations	4890 rpm
Specifications of Knives	
Straight Knife Height "A"	27-35 mm (1.063 - 1.378")
Straight Knife Thickness "B"	2-3 mm (0.079 - 0.118")
Straight Knife Protrusion "C"	1.1 mm (0.043")
Pattern Knife Thickness "B"	3-5 mm (0.118-0.197")
Pattern Knife Max Protrusion "C"	depends on the knife thickness (see table 7-9)

**TABLE 7-8**

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard.
2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission levels and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. The factors affecting a current level of noise exposure during work are inter alia room characteristics and characteristics of other noise sources, e.g. number of machines and machining operations nearby. Also, the permissible exposure level value may vary depending on country. This information enables the machine's user to better identify hazards and a risk.

# 7 SPECIFICATIONS

## Moulder Specifications

See Table 7-9. A relation between the pattern knife protrusion and the thickness is shown below.

Pattern Knife Thickness	Pattern Knife Max. Protrusion <sup>1</sup>
3 mm	13 mm (0.512")
4 mm	21 mm (0.827")
5 mm	29 mm (1.142")

TABLE 7-9

<sup>1</sup> According to EN 847-1:2005 European Standard

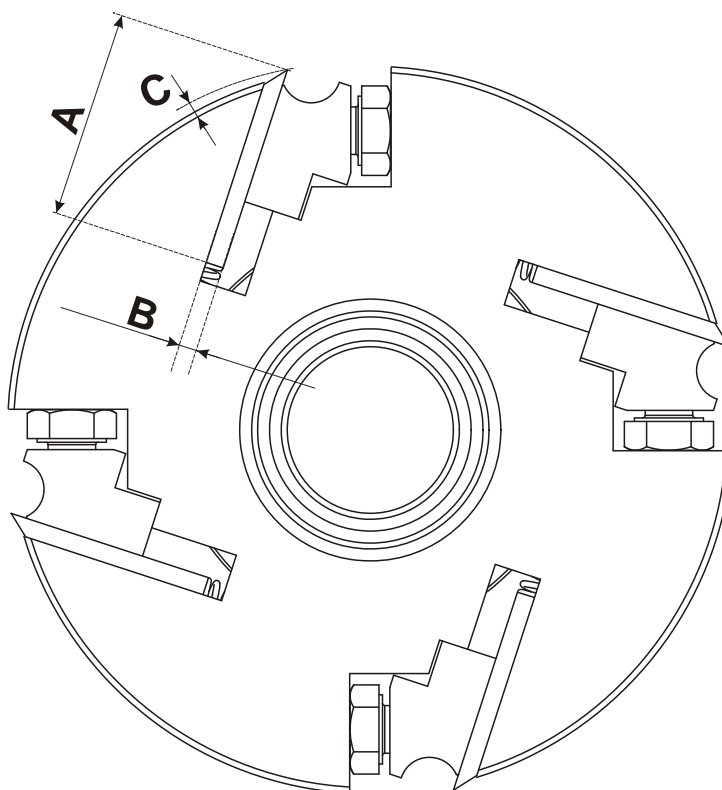
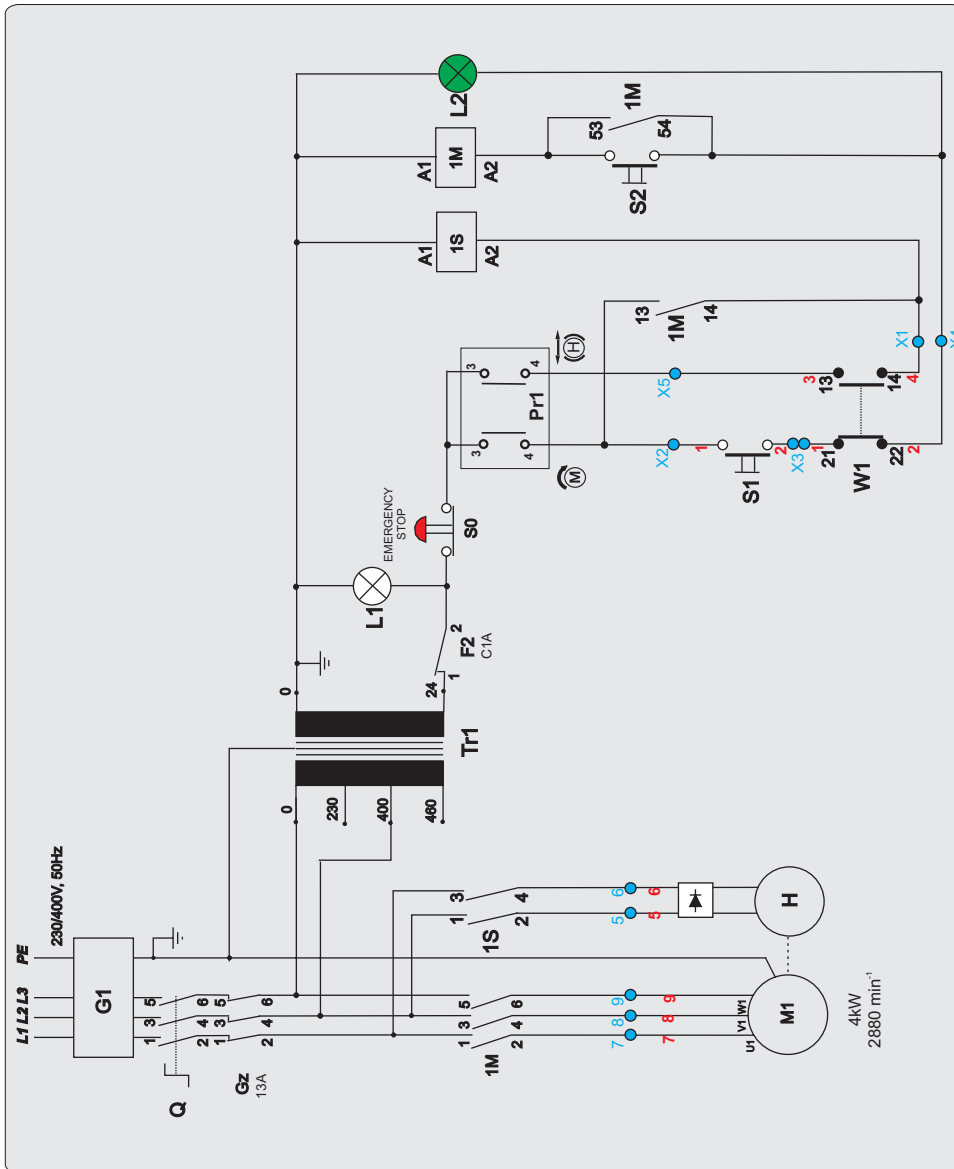


FIG. 7-2

### 7.3 Electrical Diagram, MP100EH5S



Wood - Mizer Industries sp.z.o.o. ul.Nagólna 114 62-600 Kolo , Poland			
Rysował KK	Data 01/03/2010	Sprawdził	
Produkt Heblarka MP100E5S		Numer rys. <b>500629</b>	
Nazwa Schemat elektryczny		Wersja <b>A</b>	

**FIG. 7-2**

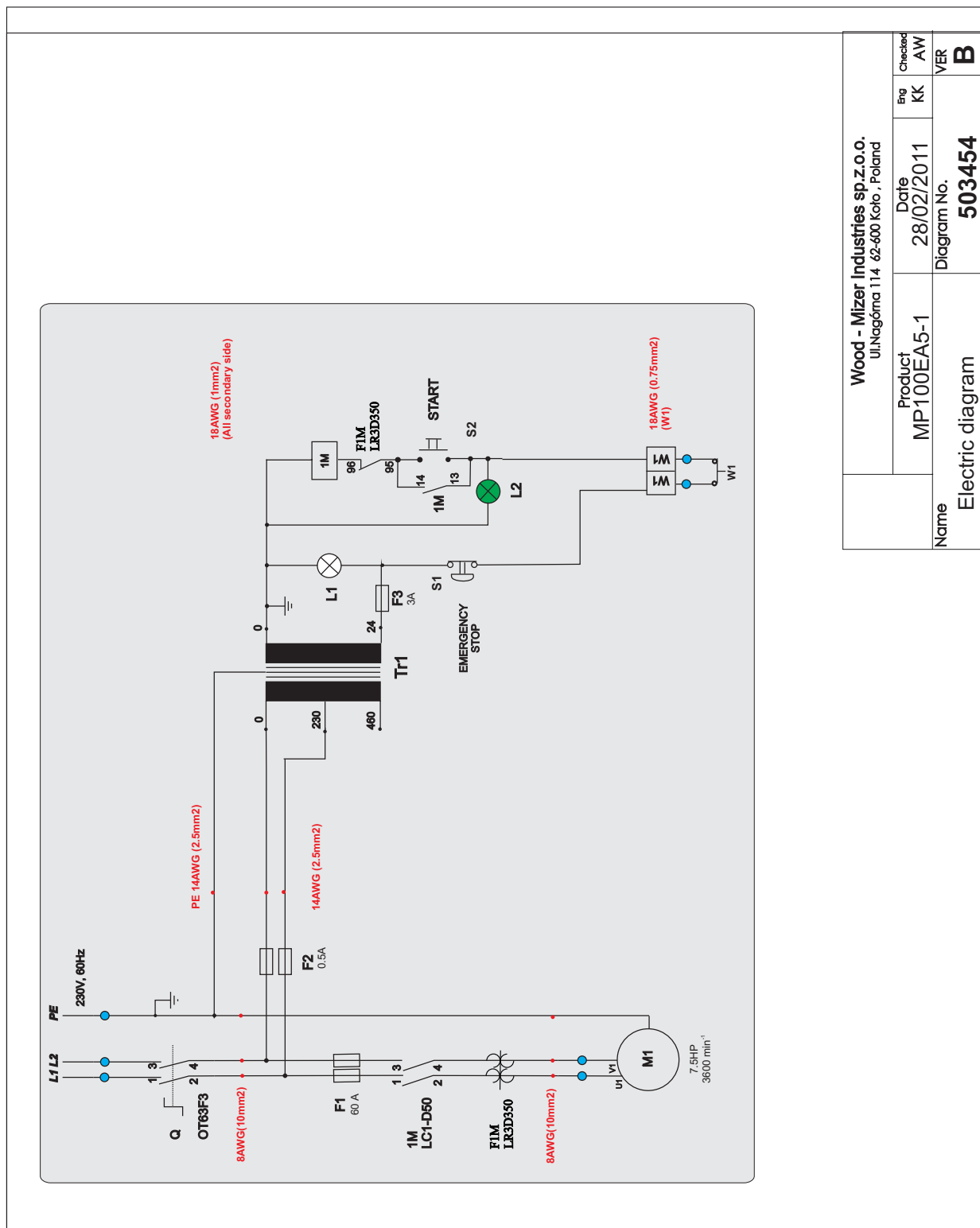
# 7 SPECIFICATIONS

*Electrical Component List, MP100EH5S*

## 7.4 Electrical Component List, MP100EH5S

Symbol	Description	Wood-Mizer Part No.	Manufacturer
1M	CONTACTOR, GMC 12 + AUXILIARY CONTACT AU-1	501022	LG
1S	CONTACTOR, GMC 6M 1a	500623	LG
Gz	SWITCH, MMS-32S 13A MOTOR DISCONNECT	501028	LG
Q	SWITCH, ABB 0T16F3	503541	ABB
TR	TRANSFORMER, SU78A-230400/24	094487	NORATEL
F2	BREAKER, BKN 1P C1A CIRCUIT	501029	LG
L1	LIGHT, M22 LED WHITE CONTROL	090448	MOELLER
S0	BUTTON, XB7 ES542 EMERGENCY STOP	502315	SCHNEIDER ELECTRIC
S1	SWITCH, GLCB01C LIMIT	100910	HONEYWELL
S2	SWITCH, M22 GREEN START	094315	MOELLER
Pr1	SWITCH, M22 3-POSITION KEY	091361	MOELLER
W1	SWITCH, AZ17-11ZRK SAFETY	094232	SCHMERSAL

## 7.5 Electrical Diagram, US Version



Wood - Mizer Industries sp.z.o.o. Ul.Nagóma 114 62-600 Koto , Poland			
Product	Date	Eng	Checked
MP100EA5-1	28/02/2011	KK	AW
Name	Diagram No.	VER	
Electric diagram	503454	B	

**FIG. 7-2 MP100EA5\_230V\_UL**

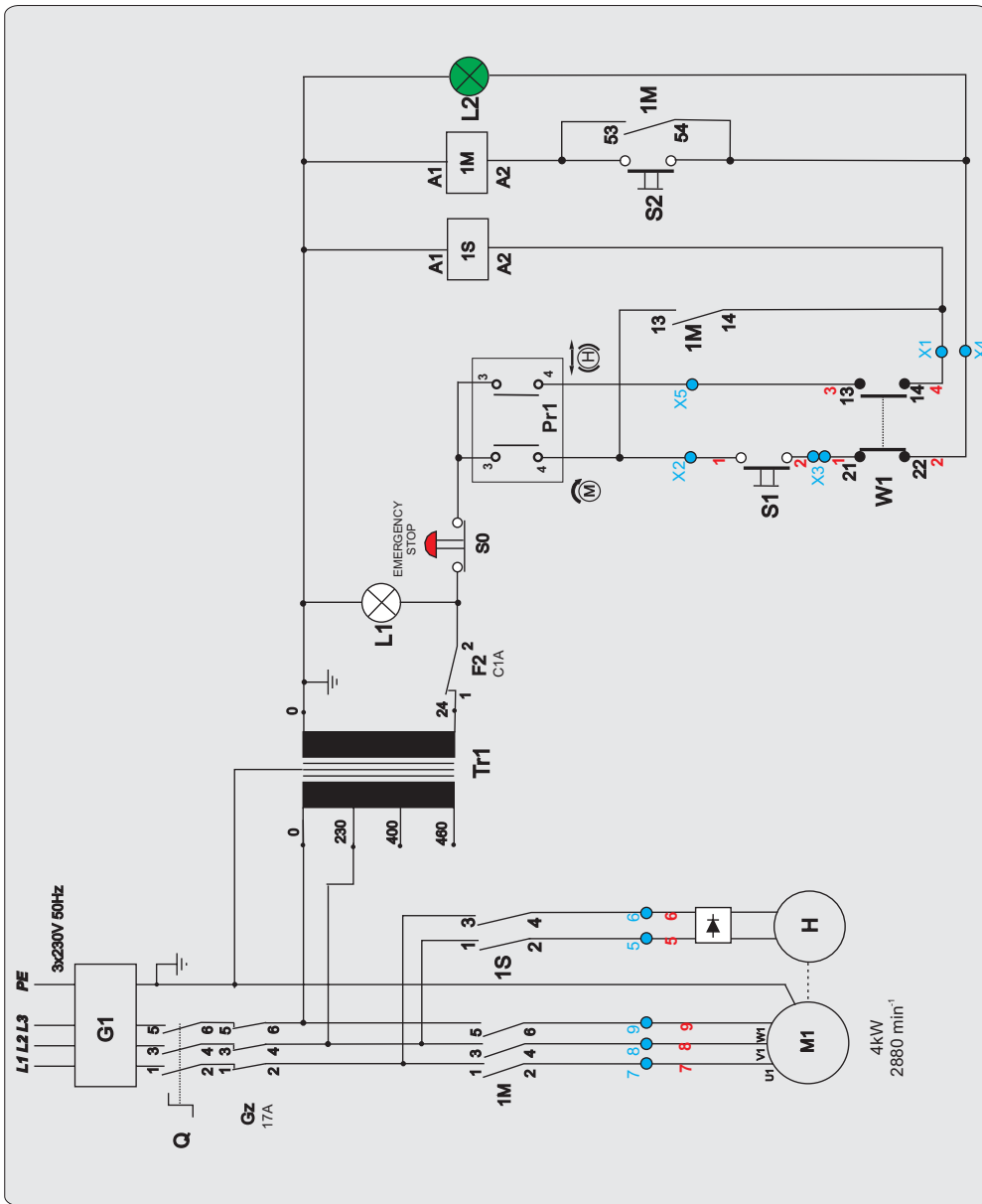
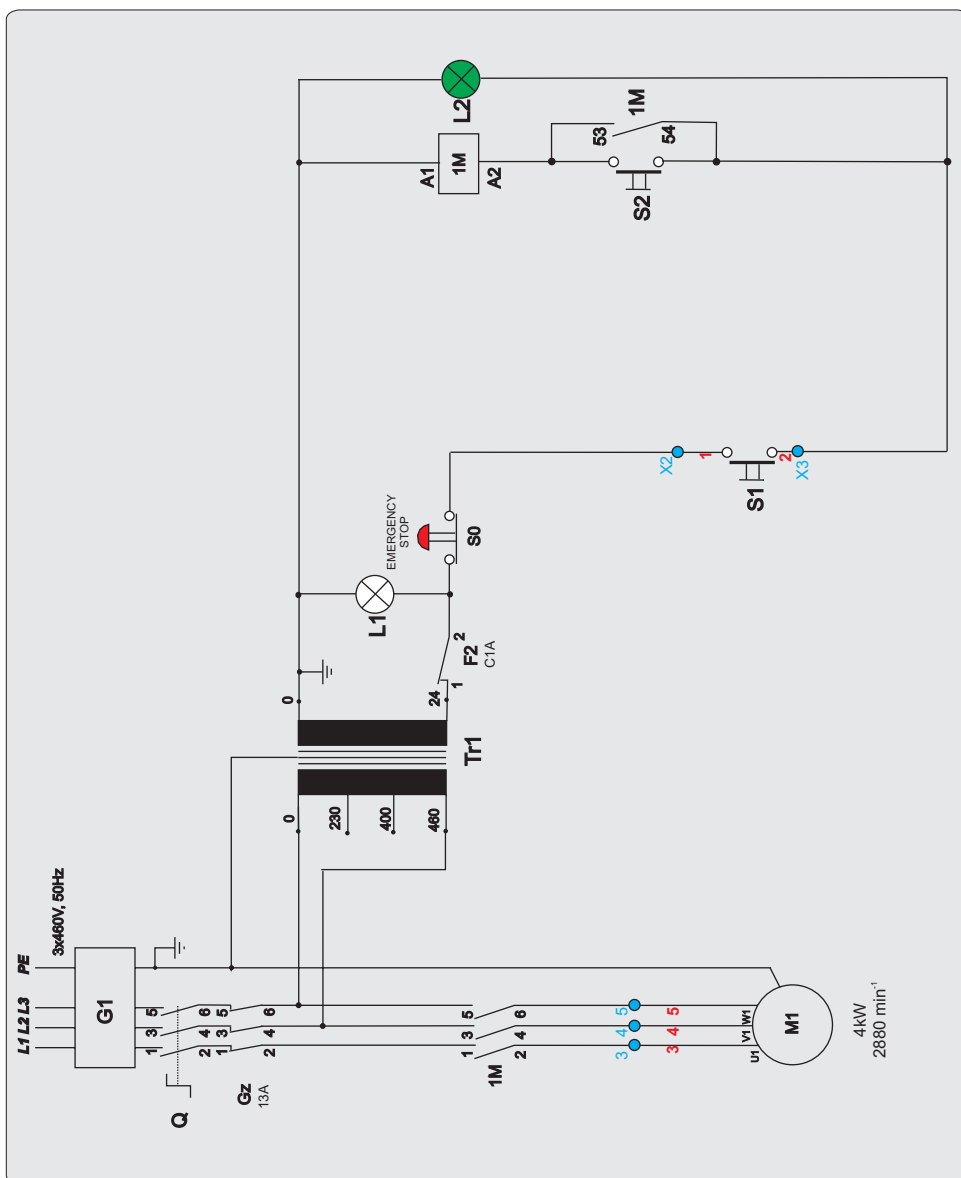


FIG. 7-2 MP100EB5\_3X230V

Wood - Mizer Industries sp.z.o.o. Ul.Niegóma 114 62-600 Koto , Poland			
Produkt	Data	Rysował	Sprawdził
Heblarka MP100EB5S-1	18/11/2010	KK	KK
Nazwa	Numer rys.	Wersja	
Schemat elektryczny	500629-2	A	





Wood - Mizer Industries sp.z.o.o. Ul.Nagórna 114 62-600 Kofo., Poland			
Nazwa	Produkt	Data	Rysował Sprawdził
Schemat elektryczny	Heblarka MP100EC5-1	11/01/2011	KK
	Numer rys.	Wersja	
	<b>500629-4</b>	<b>A</b>	

**FIG. 7-2 MP100EC5\_460V\_UL**

## 7.6 Electrical Component Lists

### *UL Version, 230V, 1 Phase*

Symbol	Description	Manufacturer	Wood-Mizer Part No.
Q	Main Switch ABB 0T63F3	ABB	503466
F1	Fuses Bussmann TCF60RN, 60A class J cube fuse	TCF60RN	069708
F1H	Fuse Holder, Bussmann TCFH60N	TCFH60N	053717
F2	Fuse 0.5A	KLDR.500	E31338
F2H	Fuse Holder	LPSC002ID	052512
F3	Circuit Breaker 3A	SCHNEIDER	504386
1M	Contactor LC1-D50AB7	SCHNEIDER ELECTRIC	502686
F1M	Thermal Relay LR3D350	SCHNEIDER ELECTRIC	502687
M1	Motor LEESON C213K34FK1B Motor, 7.5HP 1ph 230V 3600rpm	LEESON	053790
TR1	Transformer SU78A-230400460/24	NORATEL	094487
L1	Control Light, M22 LED White	MOELLER	090448
S1	Emergency Stop Button, XB7 ES542	SCHNEIDER ELECTRIC	502315
S2+L2	M22, Green Start Button + Control Light	MOELLER	094315
W1	Safety Switch AZ17-11ZRK	SCHMERSAL	094232

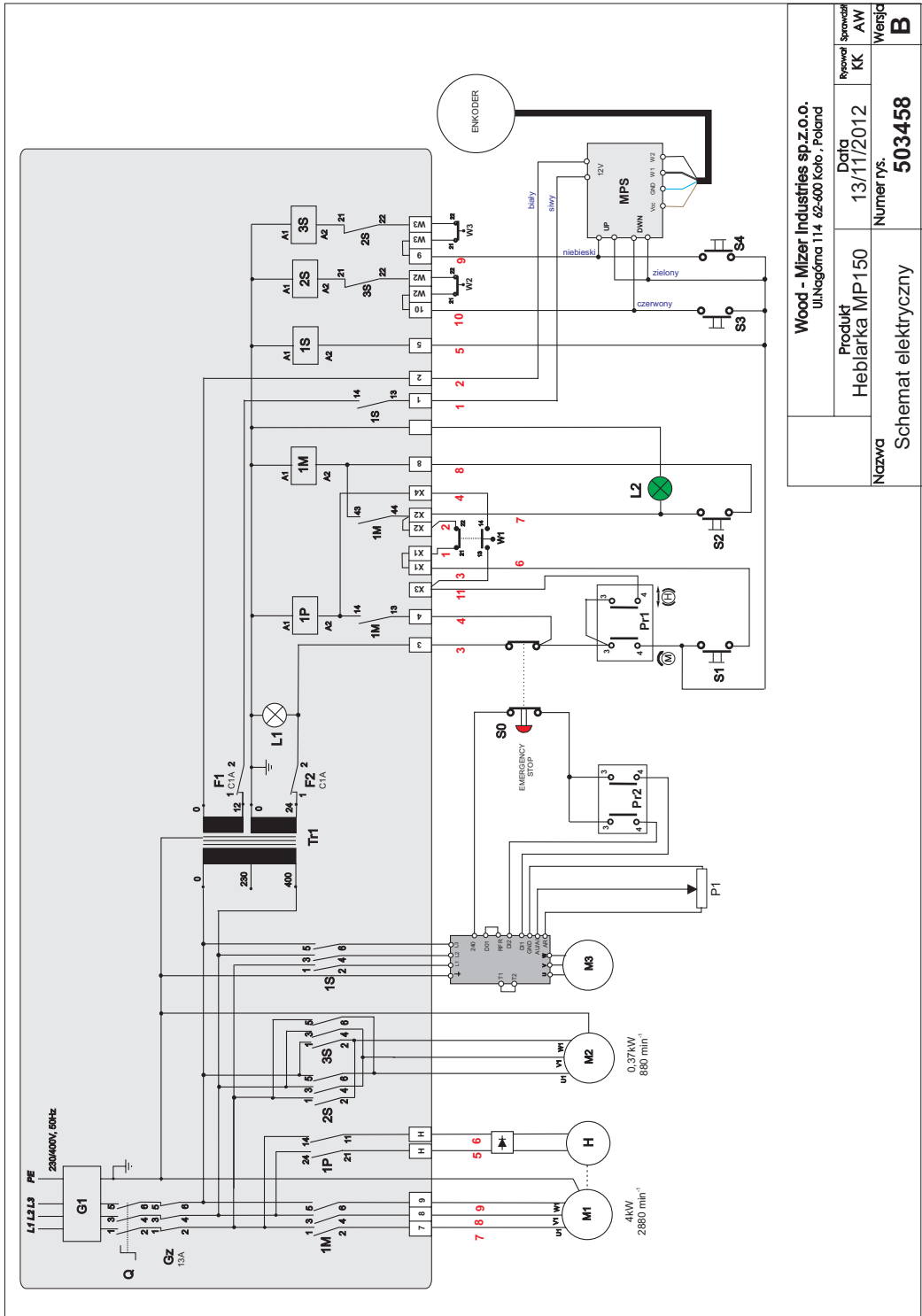
### *CE Version, 230V, 3 Phase*

Symbol	Description	Manufacturer	Wood-Mizer Part No.
1M	CONTACTOR, GMC 18 + AUXILIARY CONTACT AU-1	LG	501033
1S	CONTACTOR, GMC 6M 1a	LG	500623
Gz	SWITCH, MMS-32S 17A MOTOR DISCONNECT	LG	501031
Q	SWITCH, ABB 0T16F3	ABB	503541
TR	TRANSFORMER, SU78A-230400/24	NORATEL	094487
F2	BREAKER, BKN 1P C1A CIRCUIT	LG	501029
L1	LIGHT, M22 LED WHITE CONTROL	MOELLER	090448
S0	BUTTON, XB7 ES542 EMERGENCY STOP	SCHNEIDER ELECTRIC	502315
S1	SWITCH, GLCB01C LIMIT	HONEYWELL	100910
S2	SWITCH, M22 GREEN START	MOELLER	094315
Pr1	SWITCH, M22 3-POSITION KEY	MOELLER	091361
W1	SWITCH, AZ17-11ZRK SAFETY	SCHMERSAL	094232

**UL Version, 460V, 3 Phase**

Symbol	Description	Manufacturer	Wood-Mizer Part No.
Q	Main Switch ABB 0T16F3	ABB	503541
F1	Fuse 20A	CCMR020	052691
F1H	Fuse Holder	LPSC003ID	052380
F2	Fuse 0.5A	KLDR.500	E31338
F2H	Fuse Holder	LPSC002ID	052512
F3	Fuse 1A	SCHNEIDER	084454
1M	Contactor LC1-D18	SCHNEIDER ELECTRIC	084306
F1M	Thermal Relay LRD-14	SCHNEIDER ELECTRIC	092480
M1	Motor (without brake) 1LA9106-2LA12-Z L2T+D31	SIEMENS	500627-UL
TR1	Transformer SU78A-230400460/24	NORATEL	094487
L1	Control Light, M22 LED White	MOELLER	090448
S1	Emergency Stop Button XB7 ES542	SCHNEIDER ELECTRIC	502315
S2+L2	M22, Green Start Button + Control Light	MOELLER	094315
W1	Safety Switch AZ17-11ZRK	SCHMERSAL	094232

**7.7 Electrical Diagram, MP150EH5S**



Wood - Mizer Industries sp.z.o.o. ul. Niegóma 114, 62-600 Koło, Poland	
Produkt	Heblarka MP150
Data	13/11/2012
Przebieg Sprzedaży	KK AW
Nazwa	Schemat elektryczny
Numer rys.	503458
Wersja	B

## 7.8 Electrical Component List, MP150EH5S

Symbol	Description	Wood-Mizer Part No.	Manufacturer
1M	CONTACTOR, GMC 12	501022	LG
1M (53, 54)	SWITCH, AU-1 AUXILIARY	501027	LG
1S	CONTACTOR, GMC 6M 1a	500623	LG
2S, 3S	CONTACTOR, GMC 6M 1b	501021	LG
Gz	SWITCH, MMS-32S 13A MOTOR DISCONNECT	501028	LG
Q	SWITCH, ABB 0T16E3	089801	ABB
TR	TRANSFORMER, SU84B-4004601224	096917	NORATEL
F2, F3	BREAKER, BKN 1P C1A CIRCUIT	501029	LG
L1	LIGHT, M22 LED WHITE CONTROL	090448	MOELLER
S0	BUTTON, XB4 BS542 EMERGENCY STOP	086556	SCHNEIDER ELECTRIC
S1	SWITCH, M22-DP-G	094328	MOELLER
S2	SWITCH, M22 GREEN START	094315	MOELLER
S3, S4	SWITCH, M22-DDL-S-X7/X7	090917	MOELLER
Pr1	SWITCH, M22 3-POSITION KEY	091361	MOELLER
Pr2	SWITCH XD4PA22	087815	SCHNEIDER ELECTRIC
W1	SWITCH, AZ17-11ZRK SAFETY	094232	SCHMERSAL
P1	POTENCJOMETR 1K	E20519	CLAROSTAT
W2, W3	SWITCH, GLCB01C LIMIT	100910	HONEYWELL

## 7.9 Sawdust Extractor Specifications

See Table 7-10. See the table below for specifications of a dust extractor for the moulder.

<b>Airflow</b>	1200 m <sup>3</sup> /h 3937ft <sup>3</sup> /h
<b>Inlet diameter</b>	100 mm (3.937")
<b>Motor power</b>	1,5 kW
<b>Number of sacks</b>	2 pcs
<b>Sack capacity</b>	0.82 ft <sup>3</sup> /0.25 m <sup>3</sup>
<b>Weight</b>	110 kg (242.5 lb)
<b>Recommended conveying air velocity in the duct</b>	20 m/s (65.62 ft/s)

**TABLE 7-10**

## SECTION 8 PARTS

### 8.1 How To Use The Parts List

- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77. The diamond (◆) indicates M06666 is not available except in subassembly K05555.

<b>8.1 Sample Assembly</b>				
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>SAMPLE ASSEMBLY, COMPLETE</b> (Includes All Indented Parts Below)	A01111	1	
1	Sample Part	F02222-22	1	
2	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
	Sample Part (Indicates Part Is Only Available With A03333)	S04444-4	1	◆
3	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
	Sample Part (Indicates Part Is Only Available With K05555)	M06666	2	◆
4	Sample Part	F07777-77	1	

#### To Order Parts:

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Kolo, 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**. Have your customer number, VIN, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.

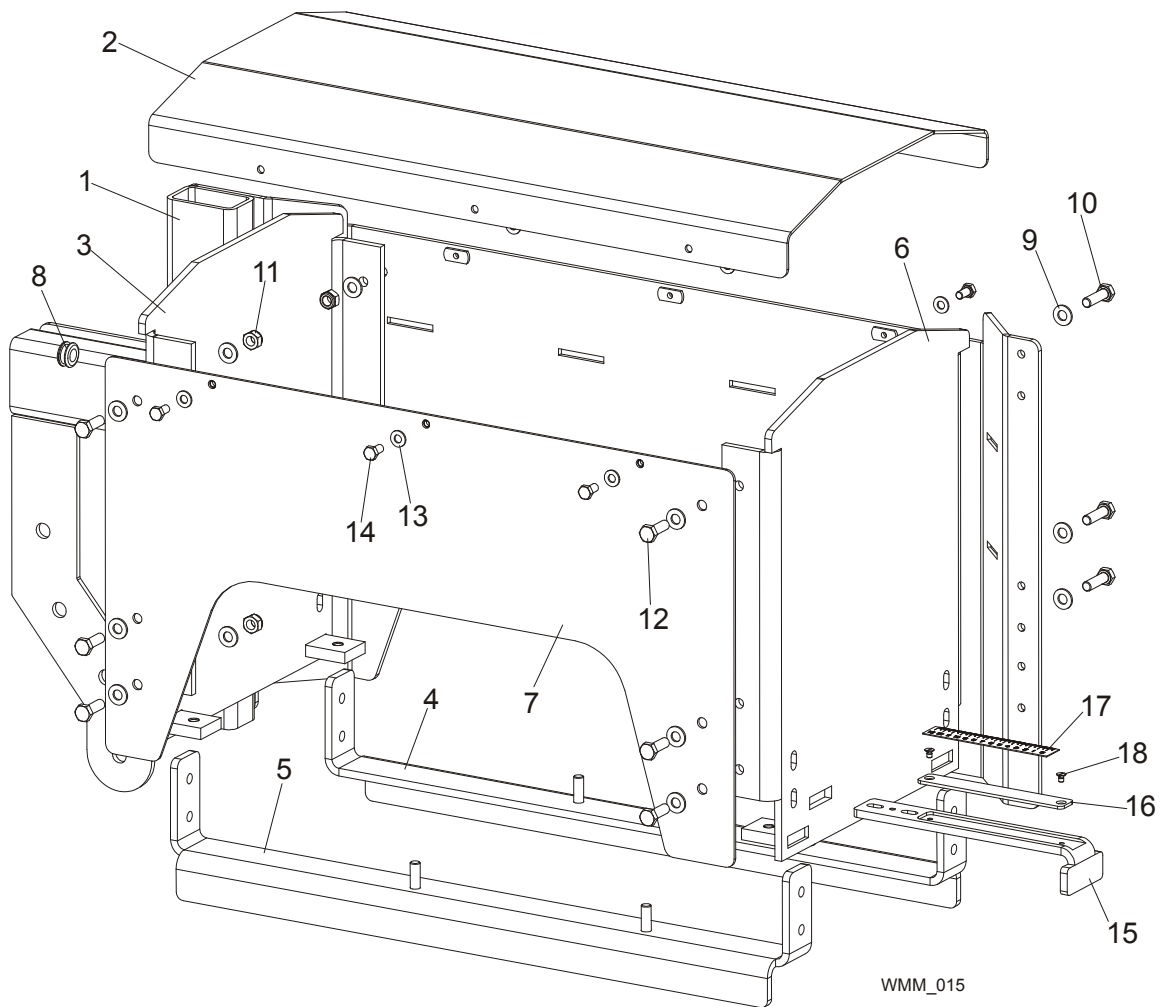
#### Office Hours:

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



**CAUTION!** It is strongly recommended that only original spare parts be used.

## 8.2 Moulder Head Housing



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>HOUSING, MOULDER HEAD COMPLETE</b>	501880	1
1	CUTTER HEIGHT ASSEMBLY	501897-1	1
2	COVER, MOULDER HOUSING UPPER	501882-1	1
3	COVER, MOULDER HOUSING LEFT	501895-1	1
4	BRACKET, MOULDER ANGLE RIGHT	501951-1	1
5	BRACKET, MOULDER ANGLE LEFT	501952-1	1
6	COVER, MOULDER HOUSING RIGHT	501896-1	1
7	COVER, MOULDER HOUSING REAR	501905-1	1
8	GROMMET, 20/13 RUBBER	086188	1
9	WASHER, 10.5 FLAT ZINC	F81055-1	24
10	BOLT, M10X35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	6
11	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	12
12	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	F81003-2	6
13	WASHER, 8.4 FLAT ZINC	F81054-1	6
14	BOLT, M8x16 -8.8-B-Fe/Zn5 PN-85/M-82105	F81002-20	6
	SCALE, CUTTER SHAFT COMPLETE	502352	1
15	STRAND, CUTTER	501949-1	1



## PARTS

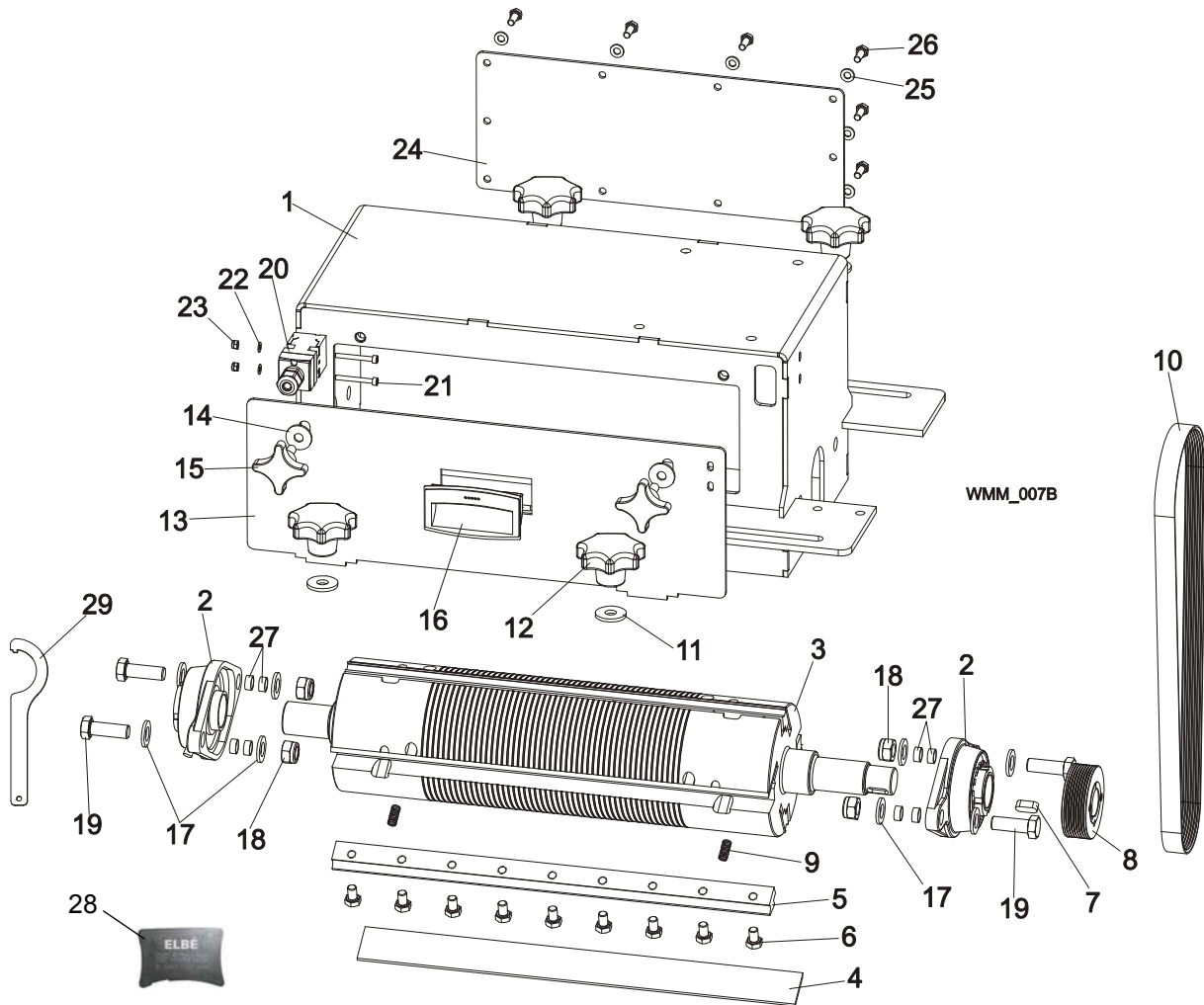
### *Moulder Head Housing*

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	SCALE, METRIC HORIZONTAL COMPLETE	501203	1	
16	BAR, SCALE COMPLETE	501205	1	
17	DECAL, 0-20 METRIC SCALE COMPLETE	501206	1	
	DECAL, INCH SCALE COMPLETE	505886	1	
18	SCREW, M5x8-5.8-B ZINC	F81001-00	2	



### 8.3 Moulder Cutter



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CUTTER, MOULDER COMPLETE</b>	501960	1
1	HOUSING, MOULDER CUTTER	501890-1	1
2	HOUSING, MSFT 1035K BEARING + H2307 BUSHING	500948	2
	SHAFT, CUTTER COMPLETE	500949	1
3	SHAFT, CUTTER ZINC	500950-1	1
4	KNIFE, HSS 410X35X3 STRAIGHT	501199	4
	CLAMP, CUTTER COMPLETE	500951	4
5	CLAMP, CUTTER ZINC	500952-1	1
6	BOLT, M8X10MM, HH FULL THREAD	F81002-47	9
7	KEY, A8X7X20 PARALLEL	099059	1
8	PULLEY, PYB 67X8J TAPER SPLIT	500922	1
9	SPRING, 18x6x1	501200	8
10	BELT, 8PJ955	501185	1
11	WASHER, 10.5 ZINC FLAT SPECIAL	F81055-6	4
12	KNOB, SR1580-63-M10-3 (462081-MOSS)	501189	4
13	PLATE, CUTTER	501904-1	1

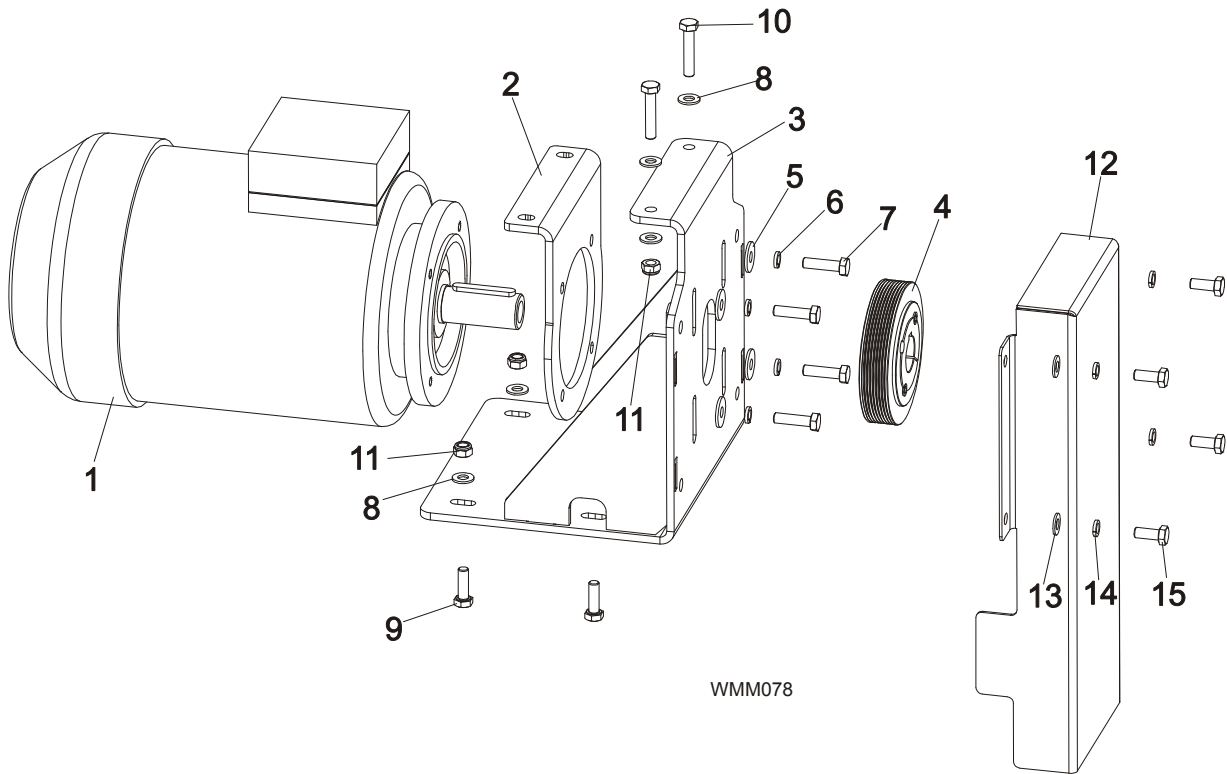


# PARTS

## Moulder Cutter

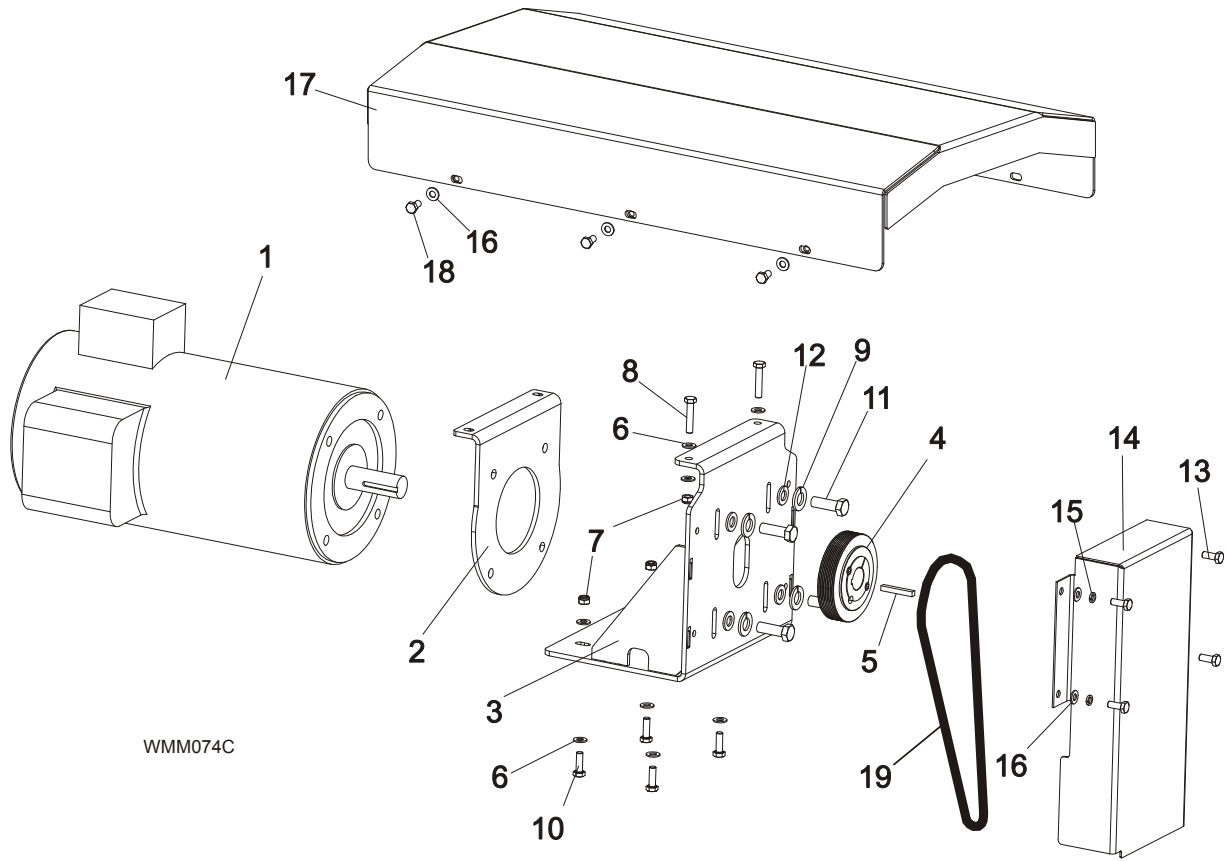
14	WASHER, 8.5 ZINC FLAT SPECIAL	F81054-11	2	
15	KNOB, SR50/M8x25 (466406 MOSS)	500973	2	
16	HANDLE, EPR.90-PF-C1(261051-C1)	100012	1	
17	WASHER, 13 FLAT ZINC	F81056-1	8	
18	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	4	
19	BOLT, M12 X 35-8.8-FE/ZN5 HEX HEAD FULL	F81004-24	4	
20	SWITCH, AZ17-11ZRK SAFETY	094232	1	
21	SCREW, M4x35-8.8 HEX SOCKET HEAD CAP ZINC	F81011-34	2	
22	WASHER 4,3 FE/ZN5 PN-M/82005	F81051-2	2	
23	NUT M4-B FE/ZN5 PN-M/82175	F81029-1	2	
24	PLATE, MOULDER HOUSING	501994-1	1	
25	WASHER, 6.4 FLAT ZINC	F81053-1	10	
26	BOLT, M6 x 16 8.8 Fe/Zn5 PN-M/82105	F81001-15	10	
27	BUSHING 12/14/6	502889-1	8	
28	<b>ALIGNMENT TOOLS SET, ELBE RF100120</b>	502848	1	
29	<b>WRENCH, BEARING NUT, DIAMETER 53MM</b>	502443	1	

## 8.4 Motor Assembly, CE



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOTOR, 1LA9106-2LA12 W/HOLDER COMPLETE</b>	500954	1
1	MOTOR, PSKg 100 L-2 HM, n=2930RPM, N=4kW.	500627	1
2	BRACKET, MOTOR PTD	500955-1	1
3	BRACKET, MOTOR PTD	500956-1	1
4	PULLEY, PYB112X8J TAPER SPLIT	500923	1
5	WASHER, 8.5 ZINC FLAT SPECIAL	F81054-11	4
6	WASHER 8,2 ZINC	F81054-4	4
7	BOLT M8X30-8.8	F81002-7	4
8	WASHER, 8.4 FLAT ZINC	F81054-1	12
9	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
10	BOLT, M8x40-8.8-B HEX HEAD FULL THREAD ZINC	F81002-15	2
11	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	6
12	<b>COVER, BELT DRIVE</b>	501186-1	1
13	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	4
14	<b>WASHER 8,2 ZINC</b>	F81054-4	4
15	<b>BOLT, M8x20-8.8-B HEX HEAD FULL THREAD</b>	F81002-4	4

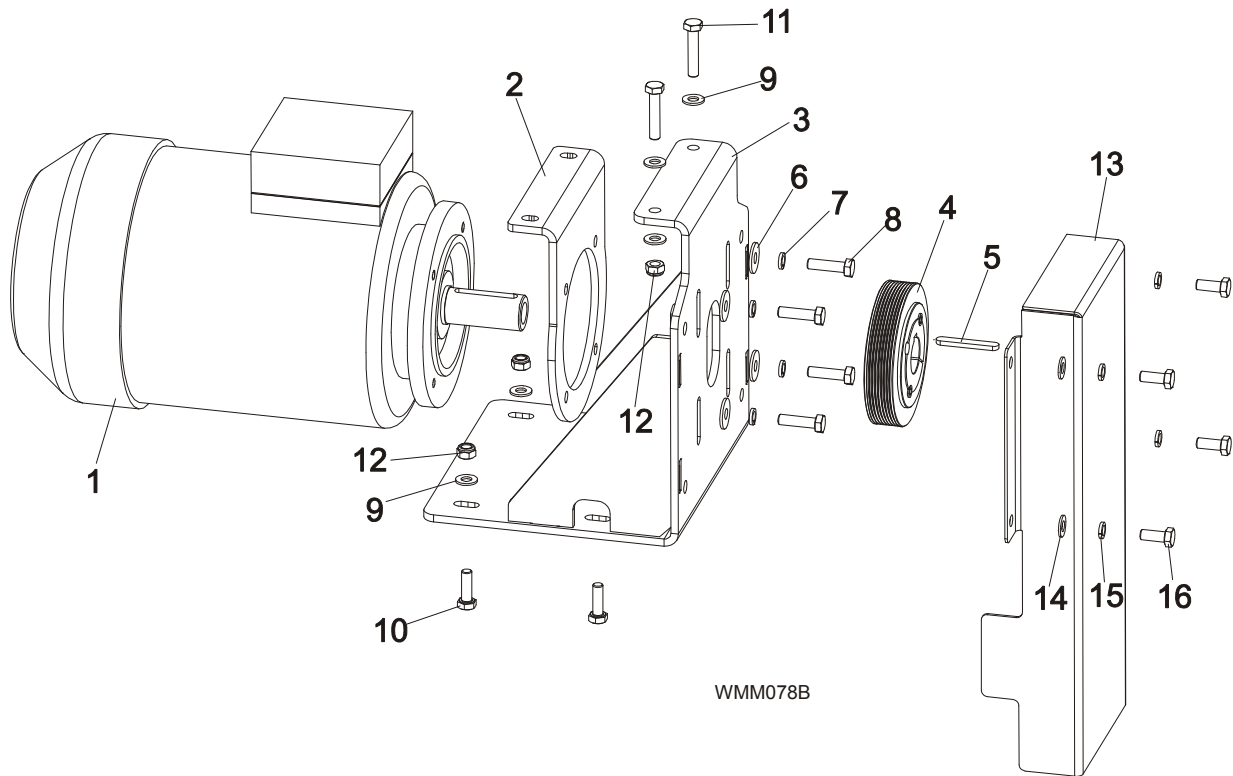
**8.5 US Version Components (1 phase, 230V)**



WMM074C

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOTOR, 1-PHASE W/HOLDER COMPLETE</b>	500954-UL	1
1	MOTOR, 7.5HP 1-PHASE 230V 3600RPM 60HZ	053790	1
2	BRACKER, MOTOR MOUNT, VER. UL	503755-1	1
3	BRACKER, MOTOR MOUNT, VER. ULL	503753-1	1
4	PULLEY PYB112X8J 1 1/8" TAPER SPLIT	503752	1
5	KEY 6,35 X 6,36 X 40	092601	1
6	WASHER, 8.4 FLAT,ZINC	F81054-1	12
7	NUT,M8-8-B,HEX,NYLON LOCK ZINC	F81032-2	4
8	BOLT, 8MM X 1.25 X 40MM HH ZINC	F81002-15	2
9	WASHER,16.3 SPLIT LOCK ZINC	F81058-2	4
10	BOLT,M8X25-8.8-B HEX HEAD FULL THRE	F81002-5	4
11	BOLT, 1/2-13X1 1/2 HH GR5	F05008-33	4
12	WASHER, M12 , FLAT, ZINC	F81056-1	4
13	<b>BOLT, M8X20MM, HEX HEAD,GR 5.8 ZINC</b>	F81002-4	4
14	<b>COVER, BELT DRIVE - UL</b>	503756-1	1
15	<b>WASHER 8,2 ZINC</b>	F81054-4	4
16	<b>WASHER, 8.4 FLAT,ZINC</b>	F81054-1	5
17	<b>COVER, MOULDER HOUSING UPPER</b>	505603-1	1
18	<b>BOLT, M8x16 -8.8-B-Fe/Zn5 PN-85/M-82105</b>	F81002-20	6
19	<b>BELT, PJ920/360J</b>	505615	1

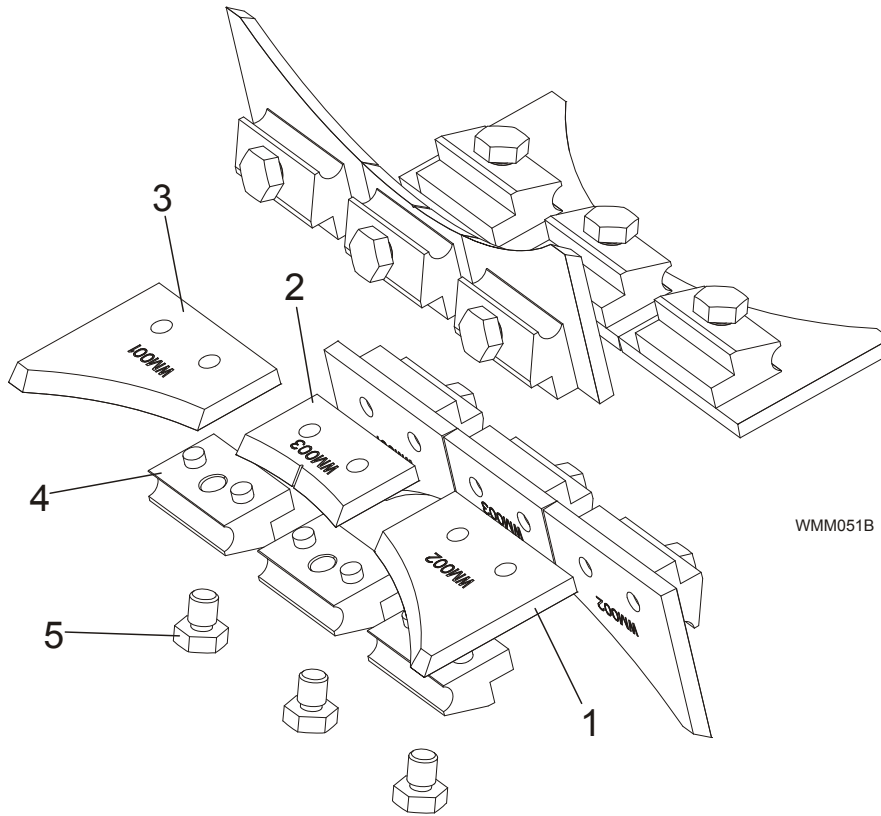
**8.6 US Version Components (3 phase, 460V)**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOTOR, MP100 MOULDER W/HOLDER COMPLETE</b>	500954-4	1
1	MOTOR 1LA9106-2LA92-Z L2T+D31 3-PHASE	500627-UL	1
2	BRACKET, MOTOR PTD	500955-1	1
3	BRACKET, MOTOR PTD	500956-1	1
4	PULLEY, PYB112X8J TAPER SPLIT	500923	1
5	KEY 6,35 X 6,36 X 40	092601	1
6	WASHER, 8.5 ZINC FLAT SPECIAL	F81054-11	4
7	WASHER 8,2 ZINC	F81054-4	4
8	BOLT M8X30-8.8	F81002-7	4
9	WASHER, 8.4 FLAT ZINC	F81054-1	12
10	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
11	BOLT, M8x40-8.8-B HEX HEAD FULL THREAD ZINC	F81002-15	2
12	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	6
13	<b>COVER, BELT DRIVE</b>	501186-1	1
14	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	4
15	<b>WASHER 8,2 ZINC</b>	F81054-4	4
16	<b>BOLT, M8x20-8.8-B HEX HEAD FULL THREAD</b>	F81002-4	4

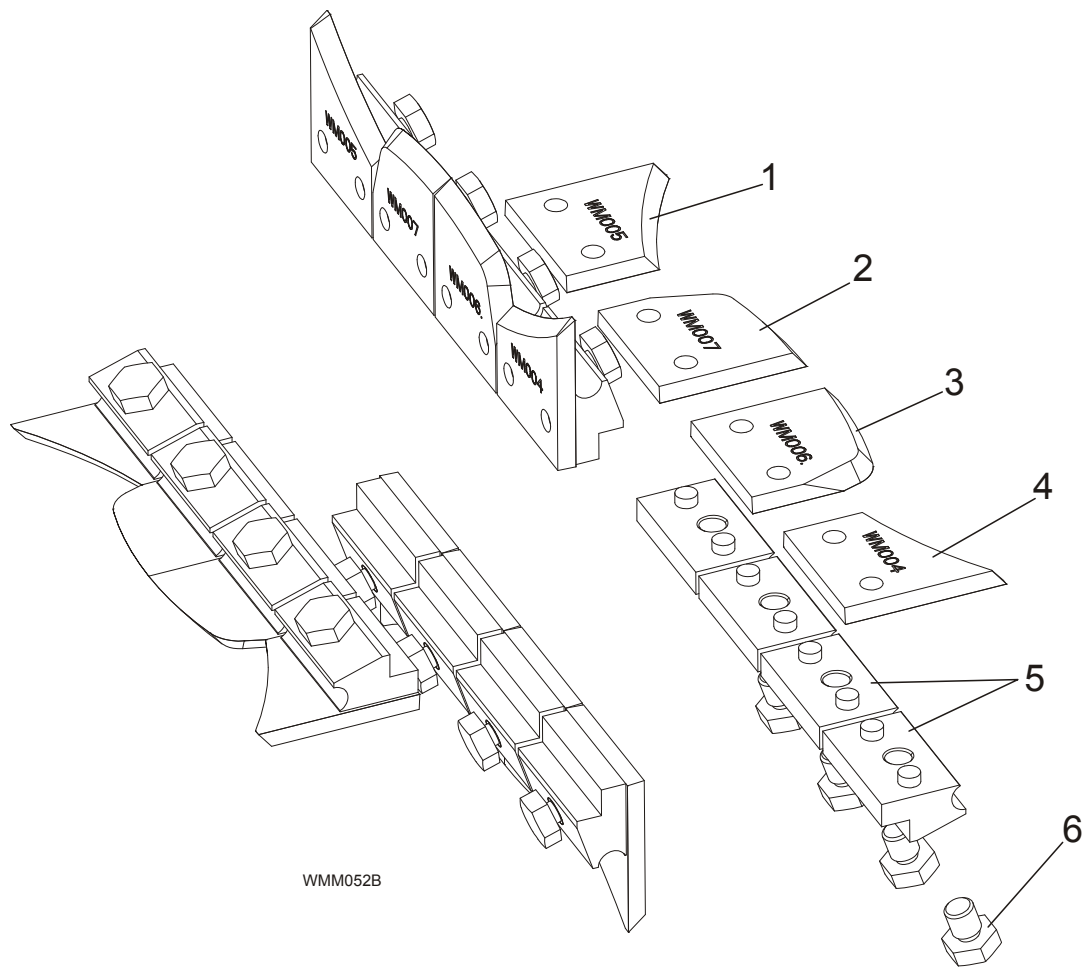
**8.7 Moulding Knives**

**8.7.1 No. 1 Moulding Knives Kit**

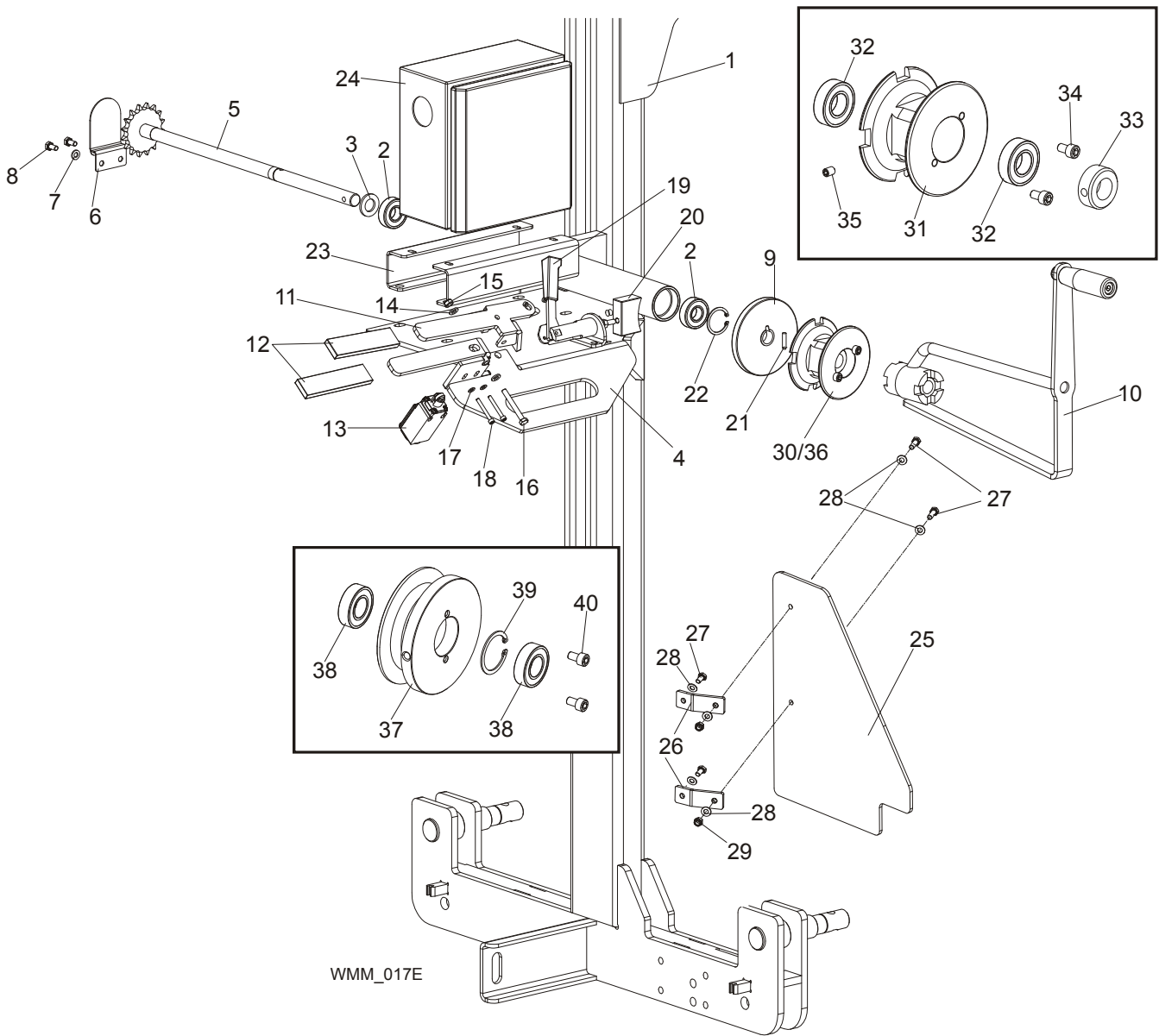


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>KIT, MOULDING KNIVES FOR PROFILE NO. 1</b>	503093-S	1
	MOULDING KNIVES KIT FOR PROFILE NO. 1	501222	4
1	MOULDING KNIFE WM002	501227	1
2	MOULDING KNIFE WM003	501228	1
3	MOULDING KNIFE WM001	501226	1
	CLAMPING WEDGE, COMPLETE	501175	3
4	BODY, CLAMPING WEDGE OF THE MAOULDING KNIFE	501176-1	1
5	BOLT, M8x12mm, HH FULL THREAD,GR8.8,ZINC	F81002-6	1

**8.7.2 No. 2 Moulding Knives Kit**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>KIT, MOULDING KNIVES FOR PROFILE 2</b>	503094-S	1
	MOULDING KNIVES KIT FOR PROFILE 2	501223	4
1	MOULDING KNIFE WM005	501230	1
2	MOULDING KNIFE WM007	501232	1
3	MOULDING KNIFE WM006	501231	1
4	MOULDING KNIFE WM004	501229	1
	CLAMPING WEDGE, COMPLETE	501175	4
5	BODY, CLAMPING WEDGE OF THE MAOULDING KNIFE	501176-1	1
6	BOLT, M8x12mm, HH FULL THREAD,GR8.8,ZINC	F81002-6	1

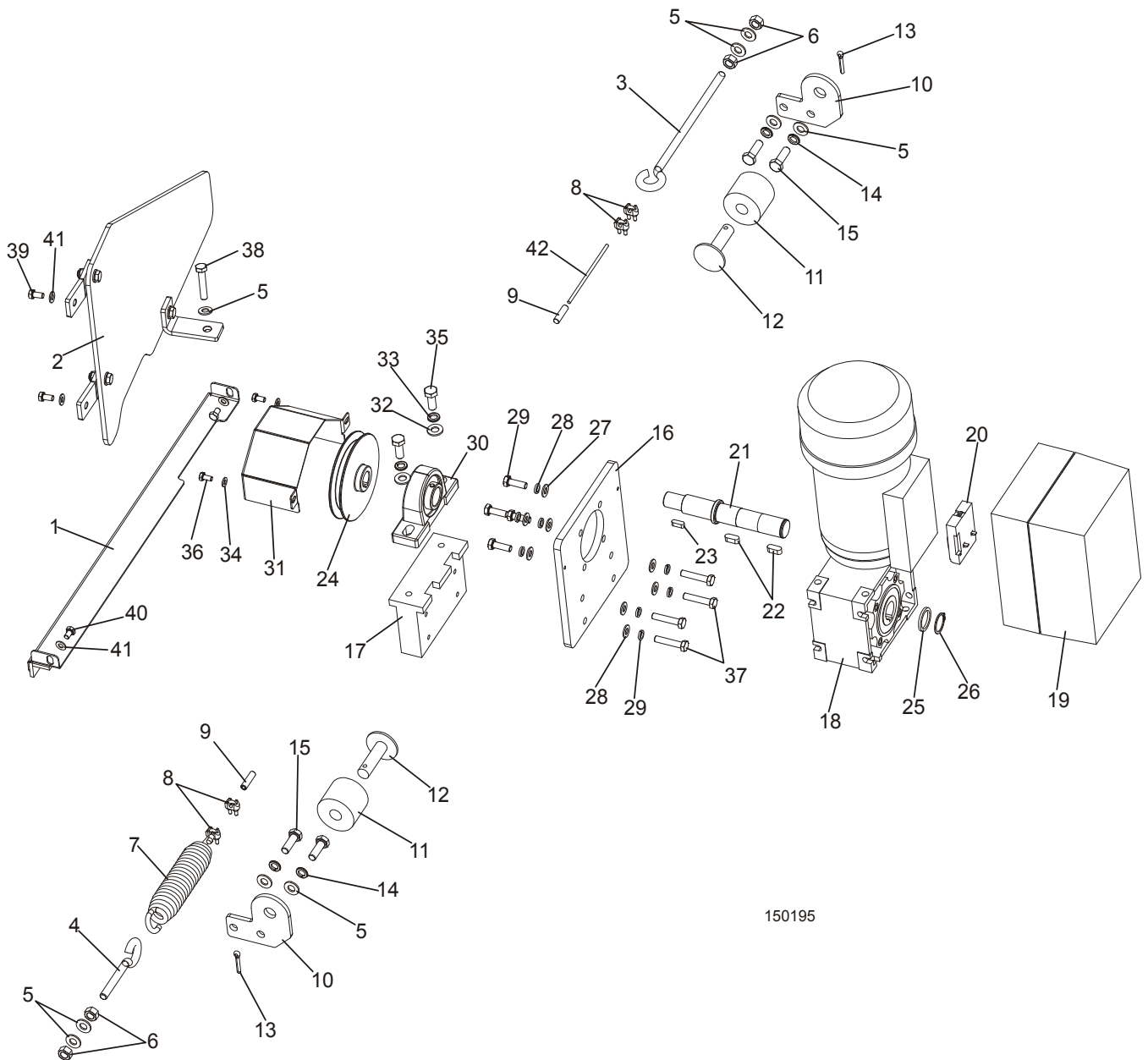
**8.8 Up/Down Crank Assembly & Electrical Box, MP100**


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>MAST, MOULDER</b>	501947-1	1	
1	MAST, MOULDER METRIC	501946	1	◆
2	BEARING, 6203-2RS	086114	2	
3	WASHER, 17 FLAT ZINC	F81058-1	1	
4	BRACKET, ELECTRICAL BOX	501961	1	
5	SHAFT W/SPROCKET LT10	501996	1	
6	GUARD, UPPER LT10 SAW HEAD SPROCKET	092567-1	1	
7	WASHER, 6.4 FLAT ZINC	F81053-1	2	
8	BOLT, M6X12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	2	
9	WHEEL, MOLUDER DRIVE BLOCK	501957-1	1	



10	<b>FEED CRANK ASSEMBLY LT10/MP100/HR110</b>	<b>508239</b>	<b>1</b>	
	CRANK, WELDMENT LT15, PTD	508238-1	1	
	KNOB, PLASTIC CRANK HANDLE	086338	1	
	BUSHING, GFM 1719-25	094142	2	
	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	1	
11	<b>HANDLE, BLADE ENGAGEMENT WLDMT/PTD</b>	097221-1 <sup>1</sup>	1	
12	<b>COVER, RRWA-91626-110 GRIP</b>	086875	2	
13	<b>SWITCH, GLCB01C LIMIT</b>	100910	1	
14	<b>WASHER, 6.4 FLAT ZINC</b>	F81053-1	2	
15	<b>NUT, M6-8-B HEX NYLON ZINC LOCK</b>	F81031-2	1	
16	<b>BOLT, M6x50-8.8 ZINC</b>	F81001-62	1	
17	<b>WASHER 4,3 FE/ZN5 PN-M/82005</b>	F81051-2	2	
18	<b>SCREW, M4x35-8.8 HEX SOCKET HEAD CAP ZINC</b>	F81011-34	2	
19	<b>HANDLE, LOCKING</b>	501962	1	
20	<b>BLOCK, UP/DOWN MOULDER</b>	501964	1	
21	<b>PIN, 4M6X22 DIN6325 HRC60 ROLL ZINC</b>	F81048-82	1	
22	<b>RING, 32W RETAINING</b>	F81090-37	1	
23	<b>BRACKET, MOULDER BOX</b>	505604-1	2	
24	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 400V CE</b>	500629	1	
	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 230V CE</b>	500629-2	1	
	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 460V</b>	500629-4	1	
	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 230V</b>	500629-5	1	
	<b>GUARD, MOULDER COMPLETE</b>	501958	1	
25	PLATE, MOULDER GUARD	502536	1	
26	BRACKET, MOULDER GUARD	502517-1	2	
27	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
28	WASHER, 8.4 FLAT,ZINC	F81054-1	6	
29	NUT, M8-8-B,HEX,NYLON LOCK ZINC	F81032-2	2	
30	<b>PULLEY, MP100 MANUAL FEED COMPLETE</b>	502527	1	
31	PULLEY, LT15 FEED ROPE	086117	1	
32	BEARING, 6003 DDUCM NSK	086116	2	
33	RING, 17 Fe/Zn5 ADJUSTING	F81039-1	1	
34	SCREW, M6x10 8.8 HEX SOCKET HEAD CAP ZINC	F81001-12	2	
35	SCREW, M6X8	F81013-1	1	
36	<b>PULLEY, MP100 POWER FEED COMPLETE</b>	502879	1	
37	PULLEY, FEED ROPE ZINC	501956-1	1	
38	BEARING, 6003 DDUCM NSK	086116	2	
39	RING, W35 RETAINING	F81090-37	1	
40	SCREW, M6x10 8.8 HEX SOCKET HEAD CAP ZINC	F81001-12	2	

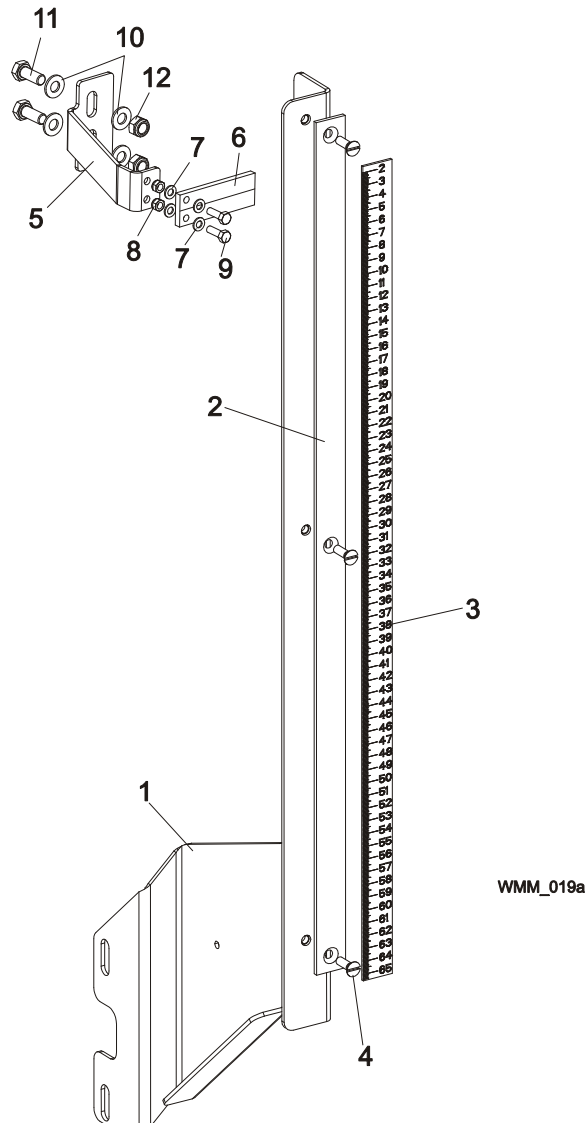
<sup>1</sup> CE Version only.

**8.9 Power Feed System, MP100**


150195

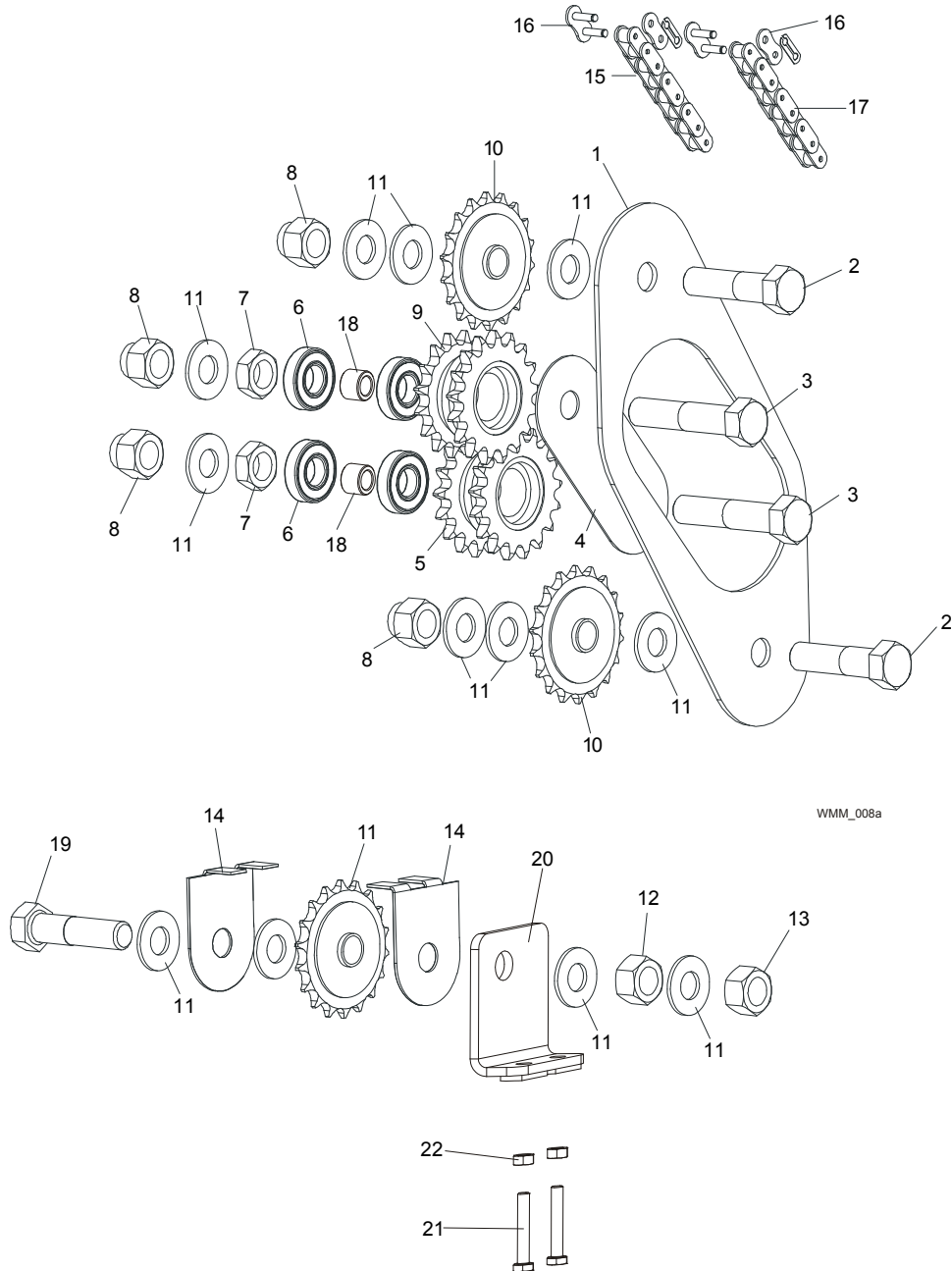
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>POWER FEED ASSEMBLY, LT15AC</b>	500860	1
1	COVER, LT15 TRACK W/FELT STRIP	500839	1
2	COVER, LT15 LOWER (REPLACES PART NO. 501958)	500727	1
3	TENSIONER, ZINC-PLATED	500846-1	1
4	TENSIONER, SHORT ZINC-PLATED	500848-1	1
5	WASHER, 10.5 FLAT ZINC	F81055-1	9
6	NUT, M10-8-B-FE	F81033-3	4
7	SPRING, PRESS ROLLER ZINC-PLATED	089689-1	1
8	CLAMP, LT20 STRING	091614	4
9	POINTER, STEEL CABLE	501417-1	2
10	PLATE, LT15 POWER FEED SUPPORT	501414-1	2

11	BUSHING, 11/16x2 1/8x1 3/4 RUBBER	P12165	2	
12	MOUNT WELDMENT, CARRIAGE STOP PTD	086182-1	2	
13	PIN, 4x25 COTTER	F81043-2	2	
14	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	4	
15	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4	
	POWER FEED DRIVE ASSEMBLY, LT15AC	500859	1	
16	PLATE, MOTOREDUCER MOUNTING	501269-1	1	
17	CUBE, MOUNTING	501271-1	1	
18	MOTOREDUCER, GCM050 U25 P80B14 B380K4	500617	1	
	REDUCER FOR MOTOREDUCER 501008 , 500617.	083689	1	
	MOTOR FOR MOTOREDUCER 500617	083694	1	
19	CONVERTER, FREQUENCY	500618	1	
20	MODULE, STANDARD I/O TYPE E82ZAFSC001	500619	1	
21	SHAFT, LT15 MOTOREDUCER OUTPUT	500862	1	
22	KEY, A8X7X20	099059	2	
23	KEY, A6X6X18	089404	1	
24	PULLEY, LT15 POWER FEED ROPE	500864-1	1	
25	WASHER	500863-1	1	
26	RING, 25Z OUTSIDE RETAINING	F81090-22	1	
27	WASHER, 8.4 FLAT ZINC	F81054-1	8	
28	WASHER, 8.2 SPLIT ZINC	F81054-4	8	
29	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
30	BEARING ASSY, UCP205CX	088468	1	
31	COVER, FRONT	500861-1	1	
32	WASHER, 10.5 FLAT ZINC	F81055-1	2	
33	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	2	
34	WASHER, 6.4 FLAT ZINC	F81053-1	2	
35	BOLT, M10X25-8.8 ZINC	F81003-11	2	
36	BOLT, M6x12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	2	
37	BOLT, M8X40-8.8 ZINC	F81002-15	4	
38	BOLT, M10X35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	1	
39	BOLT M8x16 -8.8-B-Fe/Zn5 PN-85/M-82105	F81002-20	2	
40	BOLT, M8X12MM, HH FULL THREAD,GR8.8,ZINC	F81002-6	2	
41	WASHER, 8.4 FLAT ZINC	F81054-1	4	
42	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=5450MM</b>	R80663-2S	1	
	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=7400MM</b>	R80663-3S	1	
	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=9350MM</b>	R80663-4S	1	
	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=6950MM</b>	R80663-2M	1	
	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=9650MM</b>	R80663-3M	1	
	<b>CABLE, STEEL ZINC-PLATED <math>\Phi</math>4 L=12350MM</b>	R80663-4M	1	

**8.10 Scale & Height Indicator**


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>SCALE, UP/DOWN MOULDER COMPLETE</b>	502509	1
1	BRACKET, MOULDER SCALE	502508-1	1
2	BAR, SCALE FLAT	502506	1
3	SCALE, MOULDER HEIGHT	502505	1
4	SCREW, M6x20- 4.8-B ZINC	F81001-31	3
	<b>INDICATOR, MOULDER COMPLETE</b>	501999	1
5	BRACKET, MOULDER INDICATOR	501998-1	1
6	INDICATOR, BLADE HEIGHT SCALE	094821	1
7	WASHER, 5.3 FLAT ZINC	F81052-1	4
8	NUT, M5-8 DIN 985 ZINC-PLATED	F81030-2	2
9	BOLT, M5X16-8.8 HEX HEAD FULL THREAD ZINC5	F81000-20	2
10	WASHER, 8.4 FLAT ZINC	F81054-1	4
11	BOLT, M8x20-8.8-B HEX HEAD FULL THREAD	F81002-4	2
12	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2

## 8.11 Up/Down Drive Sprocket Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	GUARD, UP/DOWN CHAIN INTERNAL	014907-1	1
2	BOLT, M16X65-8.8-B HEX HEAD FULL THREAD ZINC	F81006-1	2
3	BOLT, M16X80 8.8-B HEX HEAD FULL THREAD ZINC	F81006-11	2
4	PLATE, UP/DOWN DRIVE SPROCKET MOUNT PTD	087104-1	1
5	SPROCKET DUAL 17/17 PTD	086812-1	1
6	BEARING, R-10	P04156	4
7	NUT, M16 HEX THIN ZINC	F81036-4	2
8	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
9	SPROCKET DUAL 16/17 PTD	086813-1	1
10	SPROCKET, 17T G1#40-41 5/8" ID	P04333	3



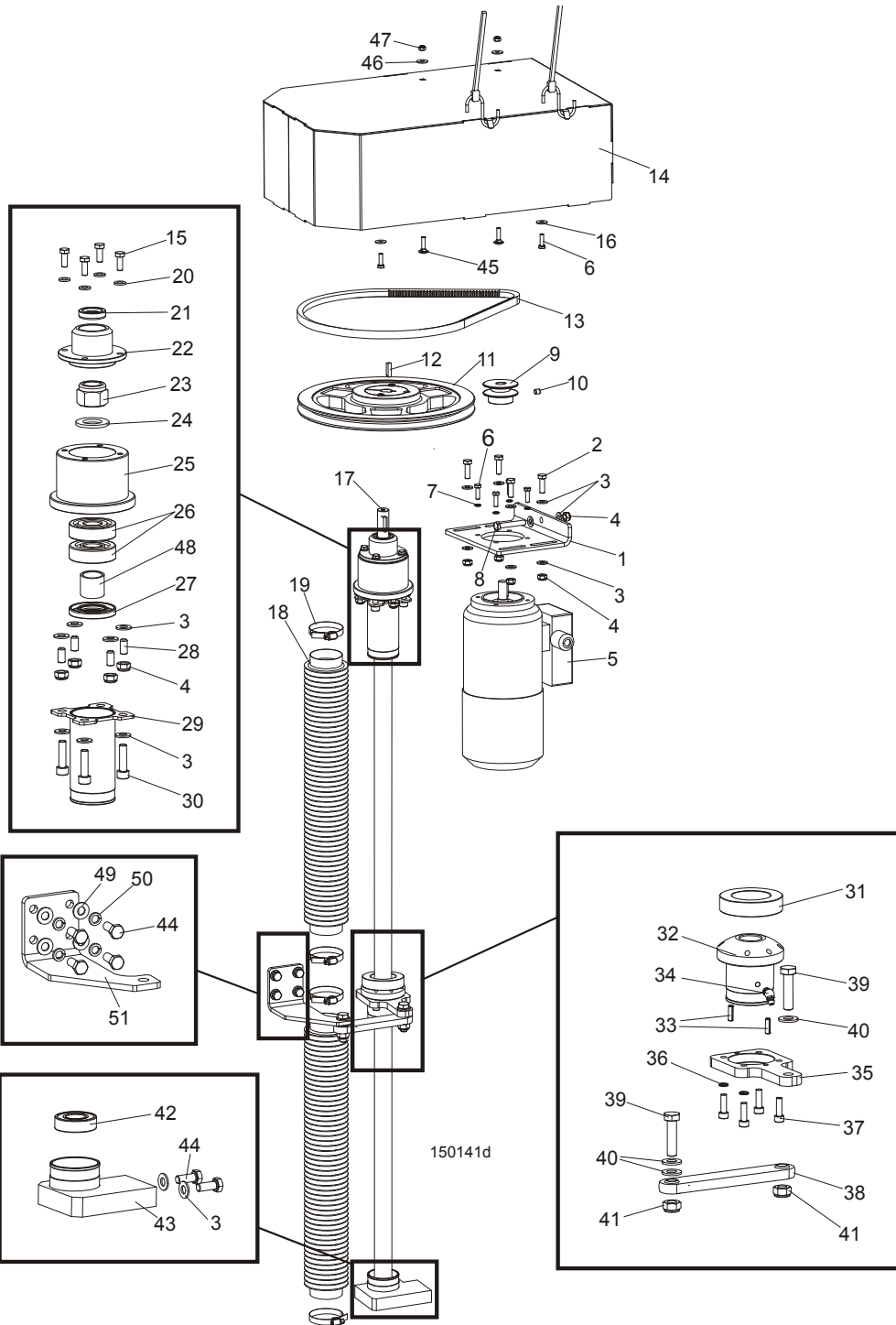
## PARTS

### *Up/Down Drive Sprocket Assembly*

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11	WASHER 17 FLAT ZINC	F81058-1	12	
12	NUT M16-5.8 HEX ZINC	F81036-1	1	
13	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1	
14	GUARD,LT10 UP/DOWN CHAIN SPROCKET	092566-1	2	
15	CHAIN, #40 X 111 1/2"	014831	1	
16	LINK, #40 MASTER	P04200	2	
17	CHAIN, #40 X 15 1/2"	P12496	1	
18	BUSHING - ZINC	095938-1	2	
19	BOLT, M16x80 8.8-B- Fe/Zn5 HEX HEAD FULL	F81006-11	1	
20	BRACKET, TIGHTENING	502525-1	1	
21	BOLT, M6X40MM,HEX HEAD,FULL THRD,ZINC	F81001-5	2	
22	NUT, M6, HEXAGON,FREE, GRADE 5(8.8)ZINC	F81031-1	2	

## 8.12 Up/Down Drive Assembly, MP150

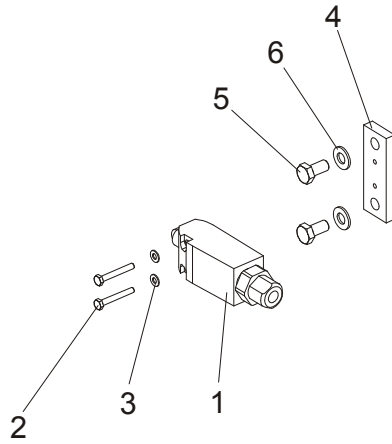


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>UP/DOWN DRIVE COMPLETE, MP150</b>	503463	1
1	Plate, Drive Belt Tension	094162-1	1
2	Bolt, M8x25-8.8-B Hex Head Full Thread Zinc	F81002-5	4
3	Washer, 8.4 Flat Zinc	F81054-1	22
4	Nut, M8-8-B Hex Nylon Zinc Lock	F81032-2	9
5	Motor, SKh71X-6C2/H2SP	503457	1
6	Bolt, M6x20-8.8 Hex Head Full Thread Zinc	F81001-2	8

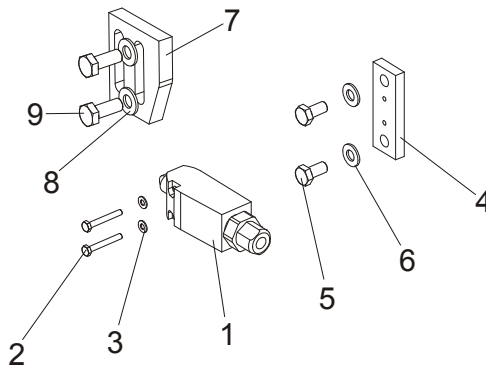
7	Washer, Z 6.1 Split Lock Zinc	F81053-3	4	
8	Bolt, M8x50-8.8 Hex Head Full Thread Zinc	F81002-19	1	
9	Pulley, Up/Down Motor	094160-1	1	
10	Screw, M8x8-33H Hex Socket Set Flat Point Zinc	F81014-1	1	
11	Pulley, SPA 280/1 w/18 Split Taper Bushing	094157	1	
12	Key, AB 6x6x23 Parallel	089191	1	
13	V-belt, AVX-13x1100 La	095306	1	
14	Cover, Up/Down System MP150 Complete High	504287	1	
	Strap, 24 in rubber with hooks	P11258	2	
15	SCREW, M6x16, HEX SOCKET HEAD CAP	F81001-21	4	
16	Washer, 6.4 Flat Zinc	F81053-1	4	
17	Screw, Tr 28x5 Acme	094144	1	
18	Bellows, 50/700 Protective	094208	2	
19	Clamp, 40-60mm	F81095-4	4	
20	Washer, 6.4 Flat Zinc	F81053-1	4	
21	Ring, A018x30x7 Sealing	094159	1	
22	Cover, Up/Down Bearing Housing	094165-1	1	
23	Nut, M20x1.5-8-A2 ISO10512 Self-locking	F81037-5	1	
24	Washer, 21 Flat Zinc	F81059-2	1	
25	Housing, Up/Down Bearings	094164-1	1	
26	Bearing, 7304B -UO CX	094256	2	
27	Ring, A28x52x7 Sealing	094155	1	
28	Screw, M8x16-33H Hex Socket Set Flat Point	F81014-2	4	
29	Bracket, Upper Bellows Mount Zinc-plated	094221-1	2	
30	Screw, M8x30-8.8 Hex Socket Head Cap Zinc	F81002-31	4	
31	Washer, DIN6319-42-C Spherical Seat	093864-1	1	
	Up/Down Nut Assembly	094150	1	
32	NUT, TR28 X 5 ACME SCREW	505315	1	
33	Pin, 5x16 Roll Zinc	F81044-3	2	
34	Fitting, M6 "B" Type PN-M/86003 Grease	094213	1	
35	Plate, Nut Housing Seat	094242-1	1	
36	Washer, Z 6.1 Split Lock Zinc	F81053-3	4	
37	Screw, M6x20-8.8 Hex Socket Head Cap Zinc	F81001-22	4	
38	Link, SBPL 10104 Pivotal	097700	1	
39	Bolt, M10x40-8.8 Hex Head Full Thread Zinc	F81003-16	2	
40	Washer, 10.5 Flat Zinc	F81055-1	2	
41	Nut, M10-8-B Hex Nylon Zinc Lock	F81033-1	2	
42	Bearing, 6004 2RS-CX Rolling	093868	1	
43	Seat, Lower Bearing	093866-1	1	
44	Bolt, M8x20-8.8-B Hex Head Full Thread Zinc	F81002-4	2	
45	Bolt, M6x25-8.8 Mushroom Head Square Neck Zinc	F81001-20	2	
46	Washer, 6.5 Special Flat Zinc	F81053-11	2	
47	Nut, M6-8-B Hex Nylon Zinc Lock	F81031-2	2	
48	Spacer, LT15 Drive Bearing	094156-1	1	



### 8.13 Up/Down Limit Switches

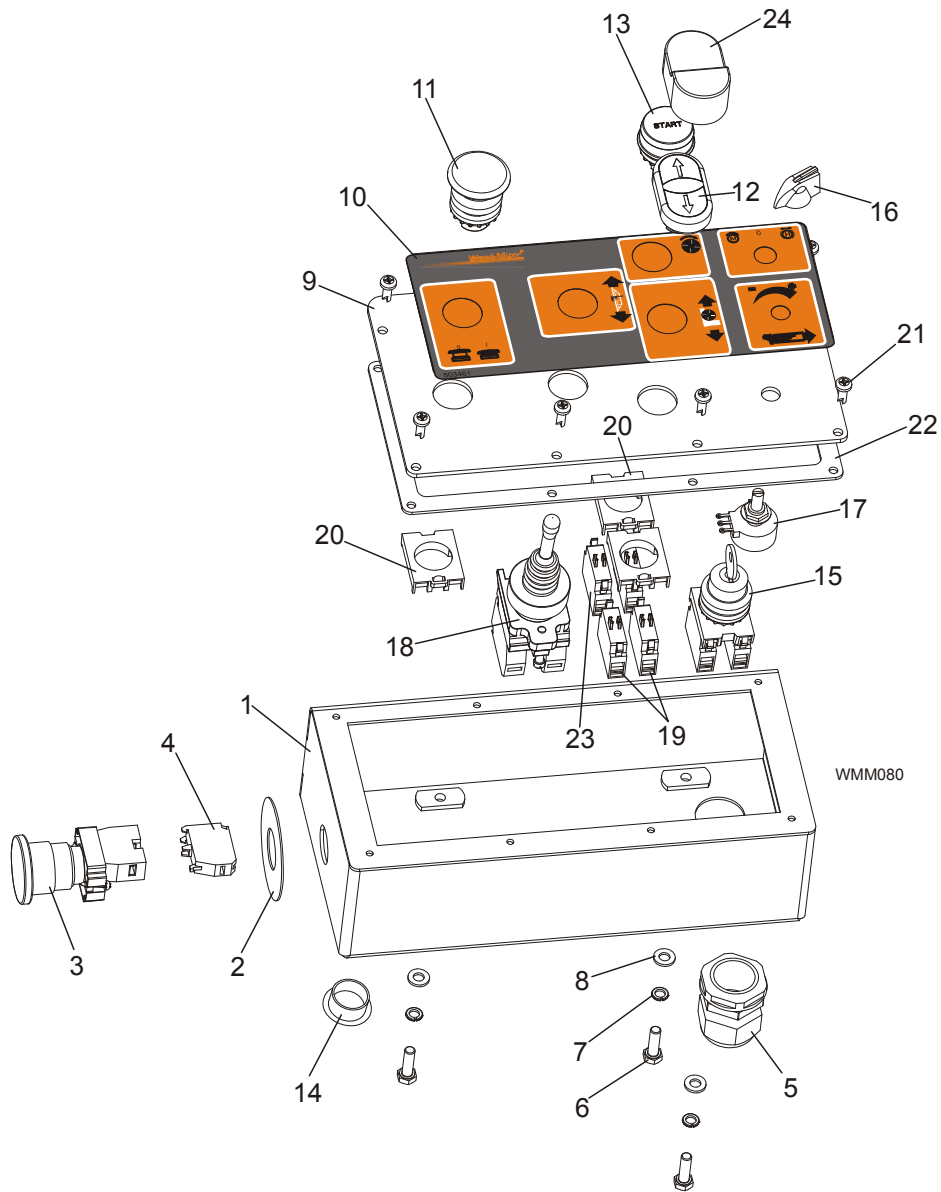


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REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>EVN2000C LIMIT SWITCH W/MOUNT PLATE</b>	094227	2
1	Switch, GLCB01C Limit	100910	1
2	Bolt, M4x30 8.8 Hex Socket Head Zinc	F81000-85	2
3	Washer, 4.3 Flat Zinc	F81051-2	2
4	Plate, Limit Switch Mount	094228-1	1
5	Bolt, M8x16-8.8-B Hex Head Full Thread Zinc	F81002-20	2
6	Washer, 10.5 Flat Zinc	F81055-1	2
7	<b>BRACKET, LIMIT SWITCH</b>	094229-1	1
8	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	2
9	<b>BOLT, M8X20MM, HEX HEAD,GR 5.8 ZINC</b>	F81002-4	2

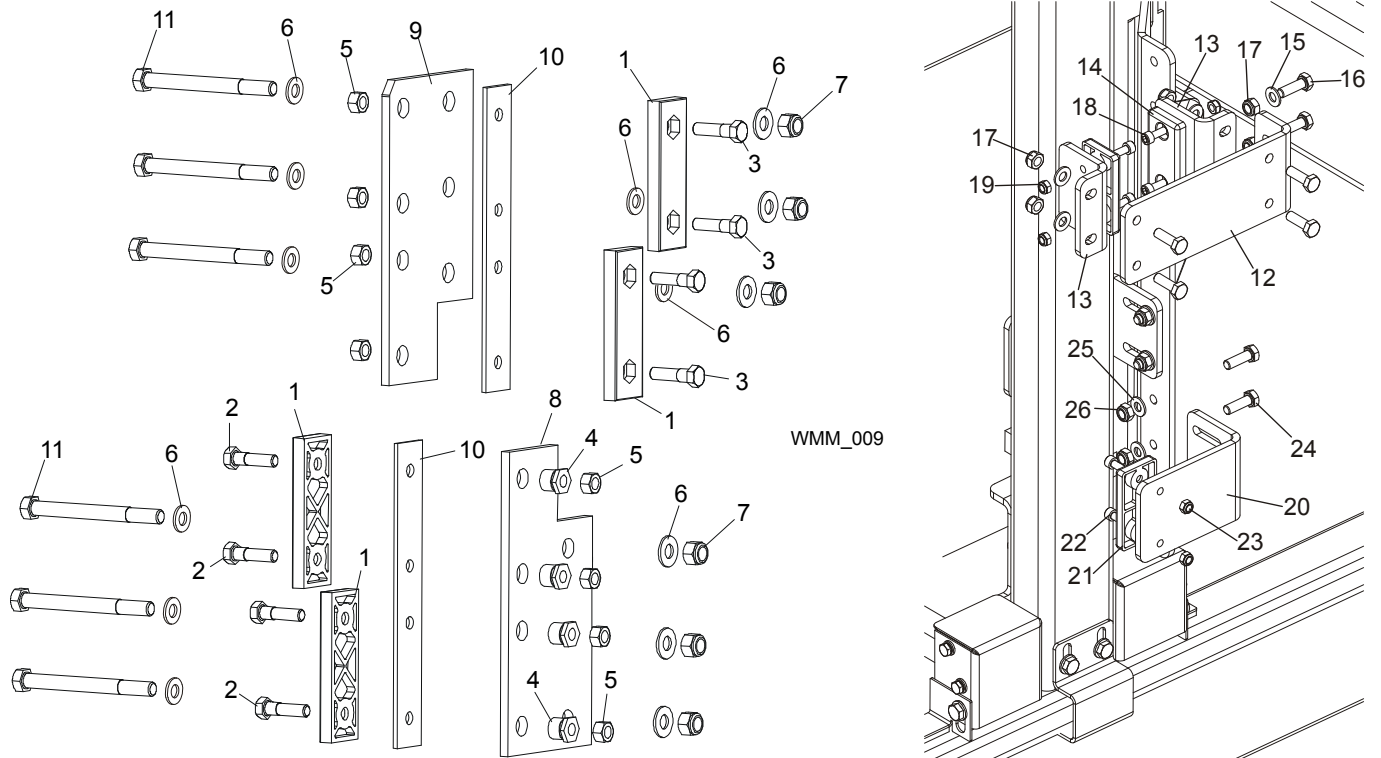
**8.14 Control Box, MP150**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CONTROL BOX, MP150 MOULDER COMPLETE</b>	503459	1
1	CONTROL BOX, MP150	501275-1	1
2	WASHER, EMERGENCY STOP SWITCH	086561	1
3	SWITCH EMERGENCY XB4 BS542	086556	1
4	CONTACT, ZB2-BE102	086810	1
5	GLAND, Pg 21 CABLE	F81096-3	1
6	BOLT, M6x20-8.8 HEX HEAD FULL THREAD ZINC	F81001-2	3
7	WASHER, Z6.1 SPLIT LOCK ZINC	F81053-3	3
8	WASHER, 6.4 FLAT ZINC	F81053-1	3
9	PANEL, MP150 CONTROL BOX FRONT	503462-1	1
10	DECAL, MP150 CONTROL BOX PANEL	503461	1
11	BUTTON, M22 MOMENTARY MUSHROOM GREEN	094328	1

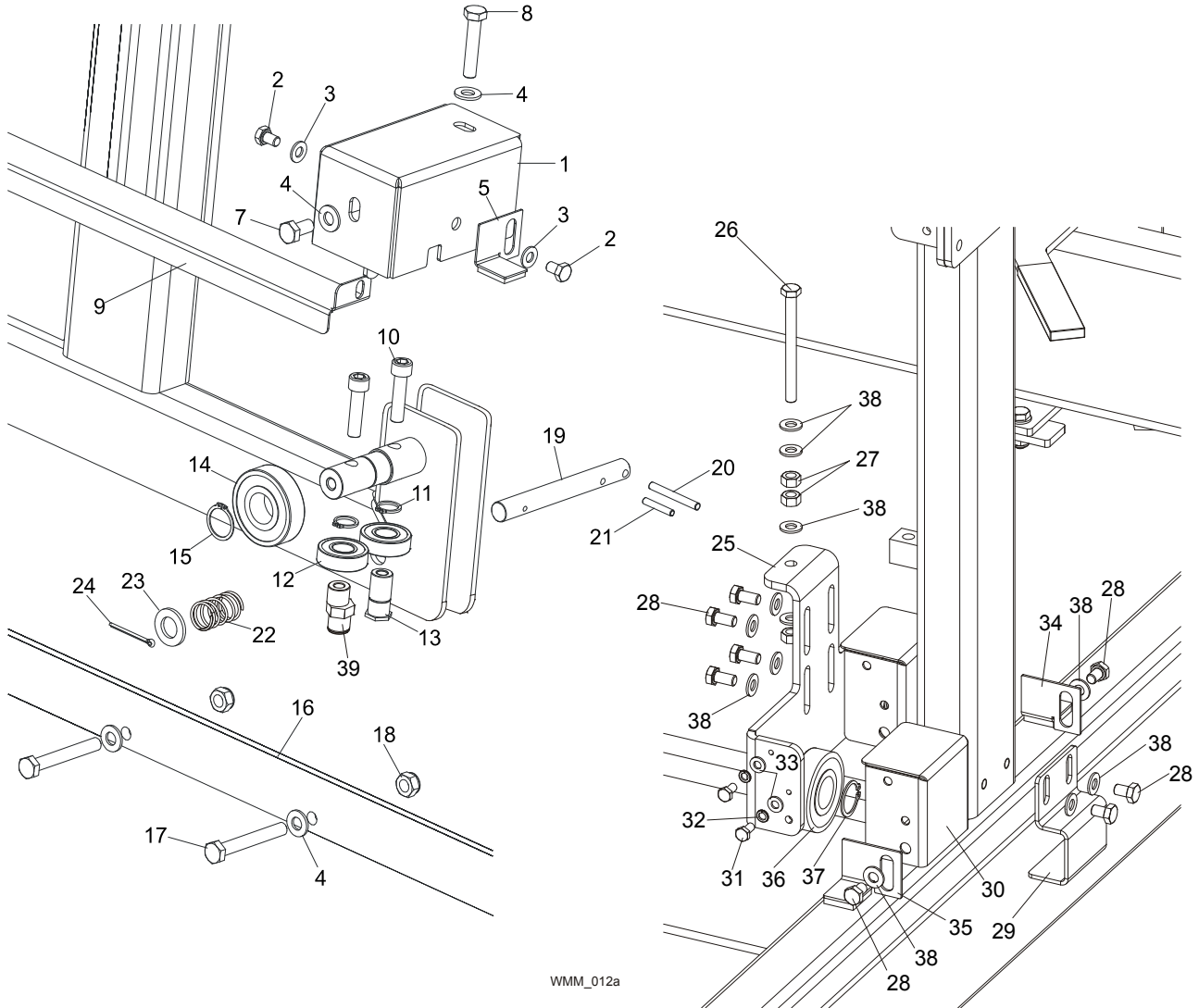
12	BUTTON, M22-DD-S-X7/X7	090917	1	
13	BUTTON, GREEN ILLUMINATED START	094315	1	
14	CAP, 22.2 HOLE	093544	1	
15	SWITCH, M22 3-POSITION KEY	091361	1	
16	KNOB, SPEED CONTROL	P06257	1	
17	POTENTIOMETER, 1K	E20519	1	
18	JOYSTICK, XD4PA22	087815	1	
19	ELEMENT, M22-K10 CONTACT	091362	3	
20	CONNECTOR, M22-A	100905	8	
21	BOLT, #10-24 x 1/2 PH PAN HD, TYPE 23	F05015-17	1	
22	GASKET, LT15 CONTROL BOX	501279	1	
23	LED ELEMENT, M22 LED-G	501004	1	
24	MEMBRANE, M22-T-DD	090462	1	
	<b>BOX, MOULDER ELECTRICAL MP150 400V</b>	503458	1	

**8.15 Slide Pads**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	PADS, UP/DOWN SLIDE	M04096	4
2	BOLT, M8X35 -8.8 HEX HEAD FULL THREAD ZINC	F81002-13	4
3	BOLT, M8X20MM, HEX HEAD,GR 5.8 ZINC	F81002-4	4
4	NUT, LT10 SLIDE PAD ADJUSTMENT ZINC-PLATED	086683-1	4
5	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	8
6	WASHER, 10.5 FLAT ZINC	F81055-1	12
7	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8
8	PLATE, LT10 SLIDE PAD MOUNT	086682-1	1
9	PLATE, SAW HEAD UPPER GUIDE PAINTED	094139-1	1
10	PLATE, SLIDE PAD SPACER PAINTED	094140-1	2
11	BOLT, M10X115-8.8 HEX HEAD ZINC	F81003-19	6
	<b>PAD, SLIDE UPPER</b>	502503	1
12	BRACKET, SLIDE PAD UPPER	501902-1	1
13	BRACKET, SLIDE PAD	501903-1	2
14	PAD, IDLE SIDE SLIDE	P13576	2
15	WASHER, 8,4 FLAT ZINC	F81054-1	10
16	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	6
17	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	6
18	SCREW, M6x16, HEX SOCKET HEAD CAP	F81001-21	4
19	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	4

	<b>PAD, SLIDE LOWER</b>	502504	2	
<b>20</b>	BRACKET, SLIDE PAD LOWER	501991-1	1	
<b>21</b>	PAD, IDLE SIDE SLIDE	P13576	1	
<b>22</b>	SCREW, M6x16, HEX SOCKET HEAD CAP	F81001-21	2	
<b>23</b>	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
<b>24</b>	<b>BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC</b>	F81002-5	4	
<b>25</b>	<b>WASHER, 8,4 FLAT ZINC</b>	F81054-1	4	
<b>26</b>	<b>NUT, M8-8-B HEX NYLON ZINC LOCK</b>	F81032-2	4	

**8.16 Track Rail, Rollers & Travel Pins**


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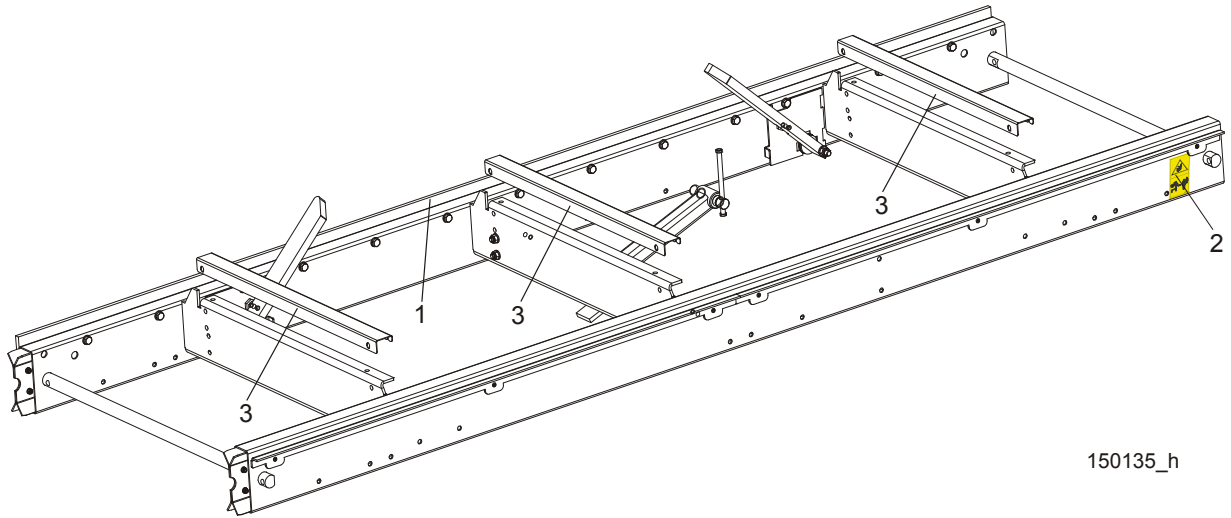
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	HOUSING, TRACK ROLLER PAINTED	086739-1	2
2	BOLT, M8X12-8.8 HEX HEAD FULL THREAD ZINC	F81002-6	4
3	WASHER, 8.4 FLAT ZINC	F81054-1	4
4	WASHER, 10.5 FLAT ZINC	F81055-1	4
5	PLATE, RIGHT TRACK WIPER	086322	2
6	PLATE, LEFT TRACK WIPER	086323	2
7	BOLT, M10 X 20 5.8 HEX HEAD FULL THREAD ZINC	F81003-1	2
8	BOLT, M10X50-8.8 HEX HEAD FULL THREAD ZINC	F81003-4	2
9	COVER, MIDDLE TRACK	086745	1
10	SCREW, M10X40 HEX SOCKET HEAD CAP ZINC	F81003-22	4
11	RING, Z 17 OUTSIDE RETAINING	F81090-21	4
12	BEARING, 6203-2RS ROLLING	086114	4

13	SHAFT, SIDE BEARING MOUNT ZINC-PLATED	086645-1	2	
14	BEARING, 6305-2RS CX	085706	2	
15	RING, 25Z OUTSIDE RETAINING	F81090-22	2	
16	RAIL, LT15 1950 (LT15S3) TRACK ZINC-PLATED	094427-1	3	
	RAIL, LT15 2700 (LT15M2) TRACK ZINC-PLATED	094696-1	2	
17	BOLT, M10X75-8.8 HEX HEAD ZINC	F81003-15	9/13 <sup>1</sup>	
18	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	9/13 <sup>2</sup>	
19	PIN, TRAVEL LOCK ZINC-PLATED	086743-1	2	
20	PIN, 6X50 ROLL ZINC	F81045-1	2	
21	PIN, 5 X 30 ROLL ZINC	F81044-21	2	
22	SPRING, 18X37X1.8 COMPRESSION ZINC-PLATED	087301	2	
23	WASHER, 17 FLAT ZINC	F81058-1	2	
24	PIN, 4 X 25 COTTER ZINC	F81043-2	2	
	ROLLER, IDLE SIDE COMPLETE	503081-S	1	
25	BRACKET WELDMENT, IDLE SIDE ROLLER PAINTED	501782-1	1	
26	BOLT, M8X90-8.8 HEX HEAD FULL THREAD ZINC	F81002-16	1	
27	NUT, M8-8-B HEX ZINC	F81032-1	3	
28	BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC	F81002-20	8	
29	GUIDE, LT15 MAST IDLE SIDE PAINTED	503768-1	1	
30	COVER, ROLLER	501783-1	2	
31	BOLT, M6x12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	4	
32	WASHER, Z6.1 SPLIT LOCK ZINC	F81053-3	4	
33	WASHER, 6.4 FLAT ZINC	F81053-1	4	
34	PLATE, RIGHT TRACK WIPER	086322	1	
35	PLATE, LEFT TRACK WIPER	086323	1	
36	BEARING, 6305-2RS CX	085706	2	
37	RING, 25Z OUTSIDE RETAINING	F81090-22	2	
38	WASHER, 8.4 FLAT ZINC	F81054-1	12	
39	SHAFT, OUTER ECCENTRIC E=3,3-ZINC	098898-1	2	

<sup>1</sup> Number of bolts for one bed section.

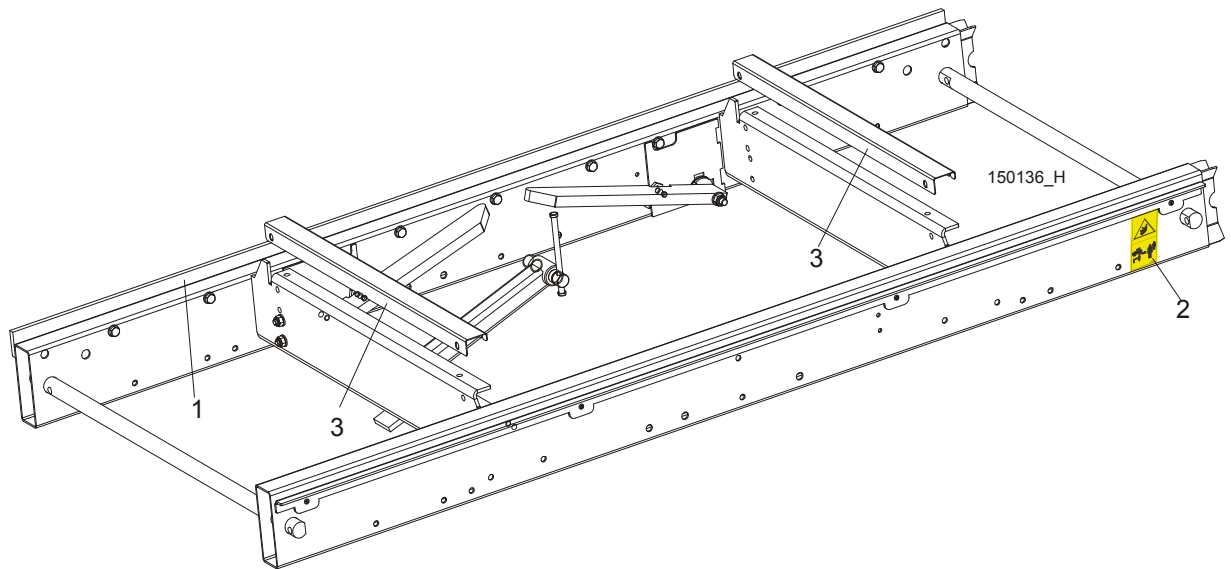
<sup>2</sup> Number of nuts for one bed section.

**8.17 "M" Type Frame Bed Section**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>LT15 BED SECTION ASSEMBLY - LONG</b>	<b>094697</b>		
1	Bar, LT15 2700 Track, Zinc-plated	094696-1	1	
2	DECAL, KEEP AWAY DANGER, PICTOGRAM	099221	1	

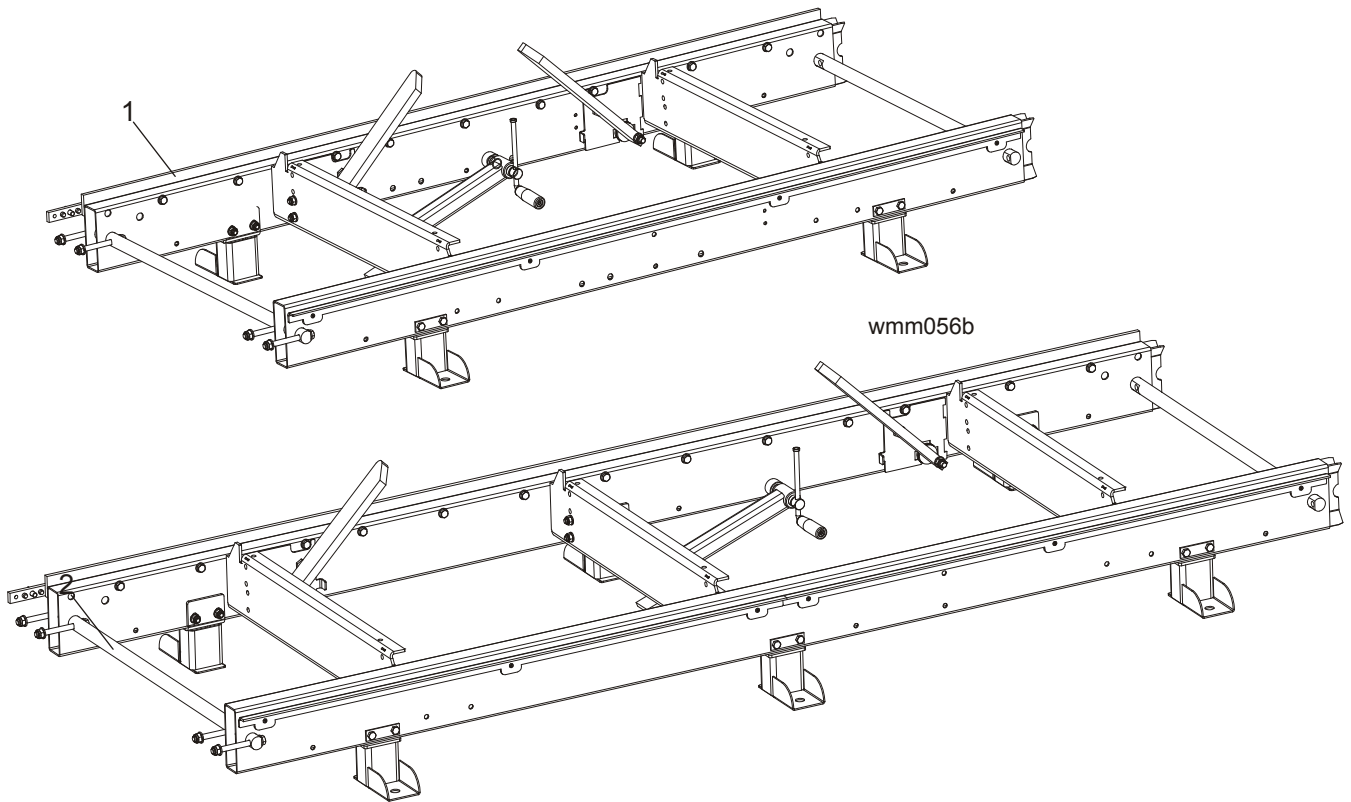
**8.18 "S" Type Frame Bed Section**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>LT15 BED SECTION ASSEMBLY - SHORT</b>	<b>094514</b>		
1	Bar, LT15 1950 Track, Zinc-plated	094427-1	1	
2	DECAL, KEEP AWAY DANGER, PICTOGRAM	099221	1	

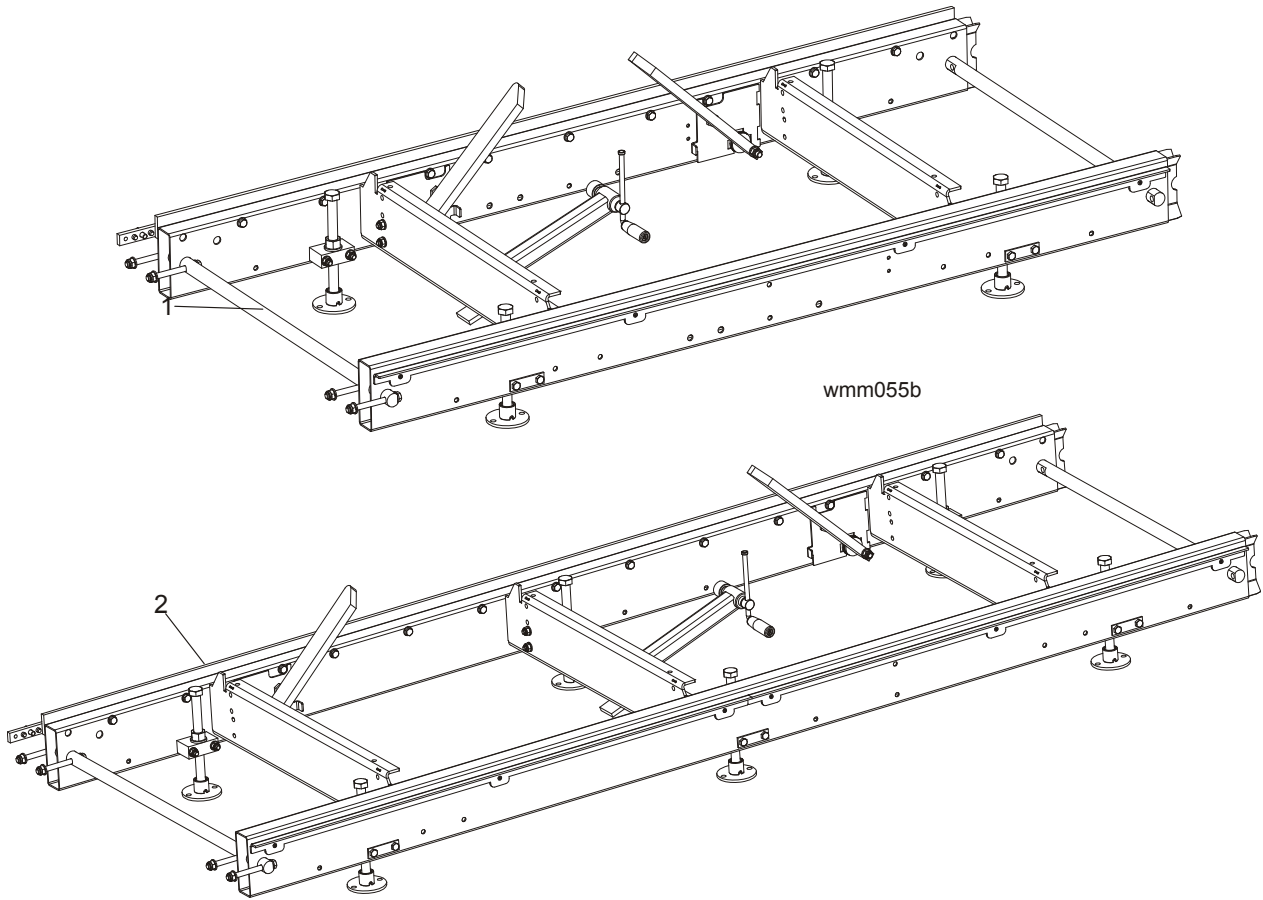


**8.19 Additional Bed Frame Section with Stationary Legs**



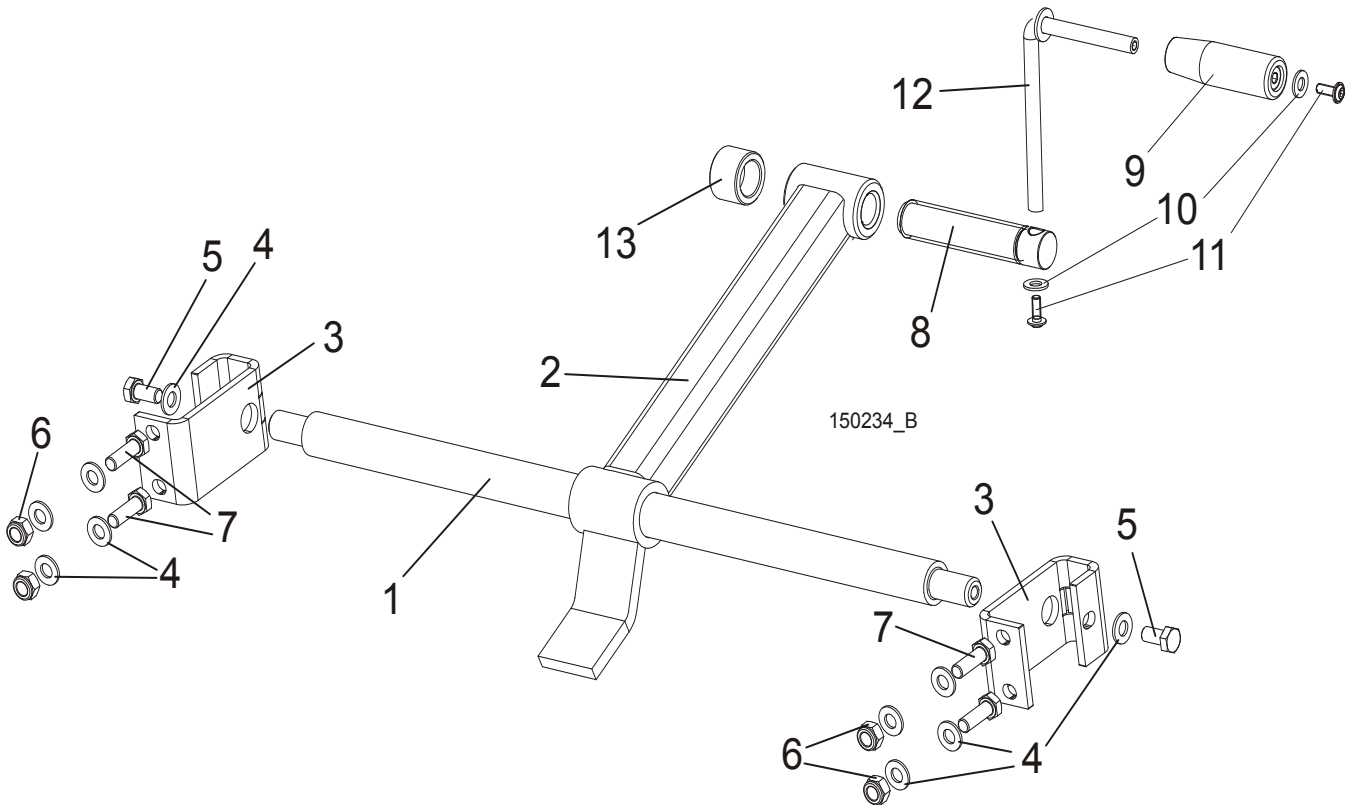
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BED SECTION, LT15 1950 MP100 W/STATIONARY LEGS COMPLETE	503515-S	1	
2	BED SECTION, LT15 2700 MP100 W/STATIONARY LEGS COMPLETE	503516-S	1	

**8.20 Additional Bed Frame Section with Outrigger Legs**



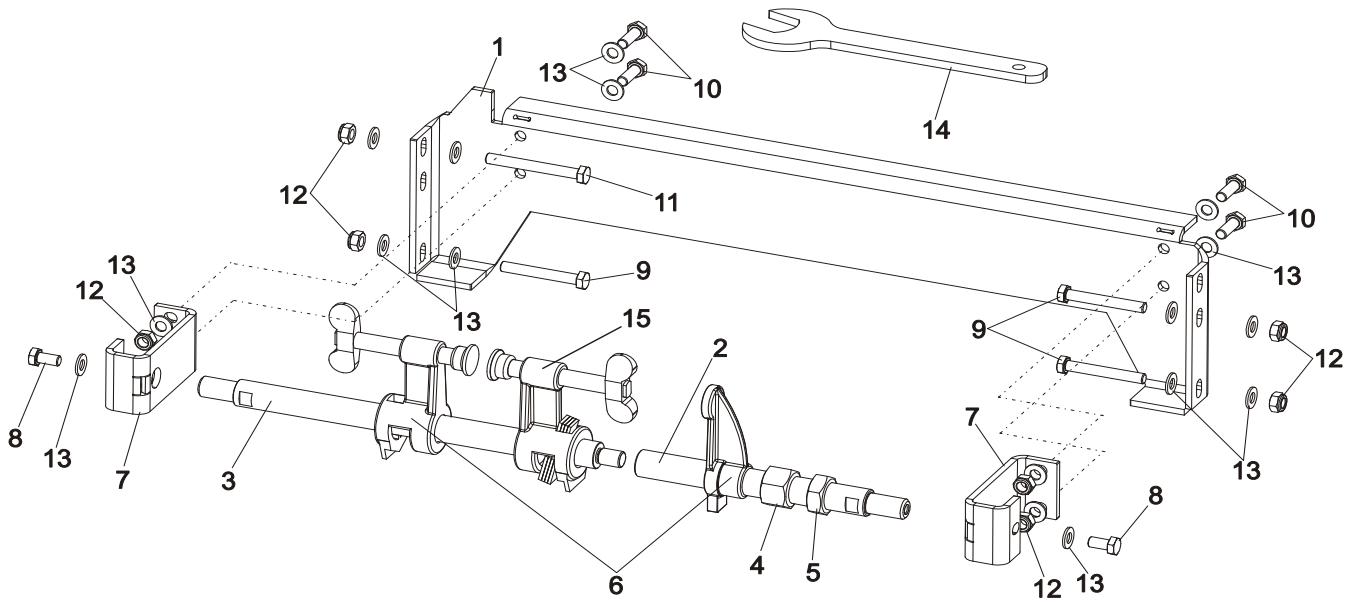
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BED SECTION, LT15 1950 MP100 W/OUTRIGGER LEGS COMPLETE	503513-S	1	
2	BED SECTION, LT15 2700 MP100 W/OUTRIGGER LEGS COMPLETE	503514-S	1	

## 8.21 Log Clamp Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>LOG CLAMP ASSEMBLY, LT10/15 COMPLETE</b>	<b>507565</b>	<b>2</b>
1	ROD MAIN CLAMP	500343-1	1
2	CLAMP ARM	507566-1	1
3	BRACKET, LOG CLAMP MOUNT ZINC	506535-1	2
4	WASHER, 10.5 FLAT ZINC	F81055-1	10
5	BOLT, M10x20MM,HEX HEAD,GR 5.8 ZINC	F81003-1	2
6	NUT,M10-8-B NYLON HEX ZINC LOCK	F81033-1	4
7	BOLT,M10X30-5.8 HEX HEAD FULL THREA	F81003-2	4
	<b>CLAMP BOLT COMPLETE</b>	<b>507563</b>	<b>1</b>
8	CLAMP BOLT	507463	1
9	KNOB, PLASTIC CRANK HANDLE	086338	1
10	WASHER, 8.4 FLAT ZINC	F81054-1	2
11	BOLT, M6x16 BN 11252 "BOSSARD"	F81001-24	2
12	CRANK CLAMP BOLT WELDED/PAINTED	510210-1	1
13	<b>BUMPER CLAMP BOLT</b>	<b>507775<sup>1</sup></b>	<b>1</b>

<sup>1</sup> Option for MP100/150

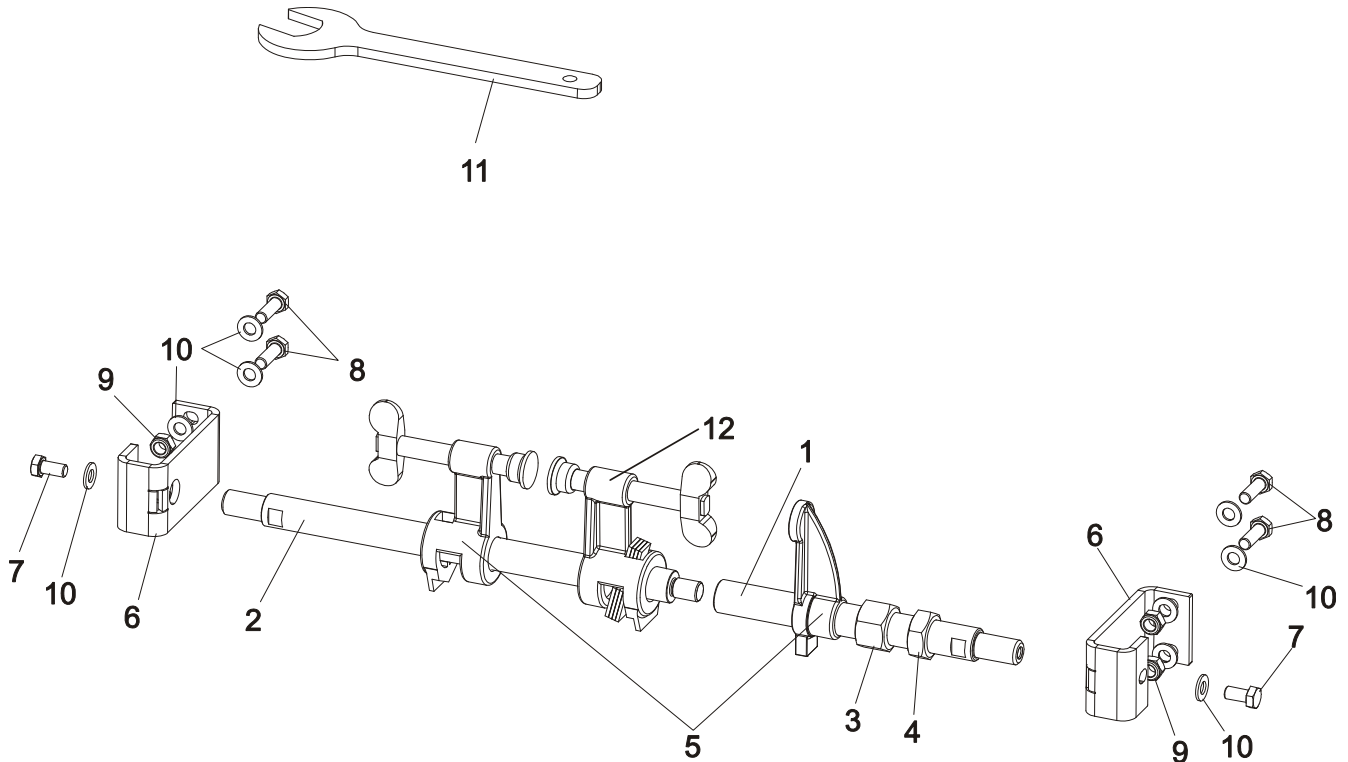
**8.22 Log Clamp for LT15 Bed Frame, MP100 Option**


WMM054

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>LOG CLAMP ASSEMBLY, MP100/LT15 OPTION</b>	505142-S <sup>1</sup>	1
1	BED RAIL, MP100 MIDDLE ADDITIONAL	502987-1	1
2	ROD, SCR ZINC-PLATED	502988-1	1
3	ROD, SMOOTH	502989-1	1
4	NUT, G 3/4	502991-1	1
5	NUT, G 3/4 THIN	502992-1	1
6	JAWS, LOG CLAMP COMPLETE	502993	1
7	BRACKET, LOG CLAMP MOUNT ZINC	502994-1	2
8	BOLT, M10X20MM HEX HEAD, GR 5.8 ZINC	F81003-1	2
9	BOLT, M10X75-8.8-FE/ZN5 PN-M/82101	F81003-15	3
10	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4
	BOLT, M10x75-8.8 HEX HEAD FULL THREAD ZINC	F81003-15	4
11	BOLT, M10X90-8.8-B HEX HEAD ZINC	F81003-66	1
12	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8
13	WASHER, 10.5 FLAT ZINC	F81055-1	18
14	WRENCH, 36 FLAT ZINC-PLATED	502995-1	1
15	CLAMP JAW, MOVABLE, ADDITIONAL	504422	1

<sup>1</sup> We recommend to mount 2 clamps at least on the moulder bed frame.

### 8.23 Log Clamp for LT10 Bed Frame, MP100 Option

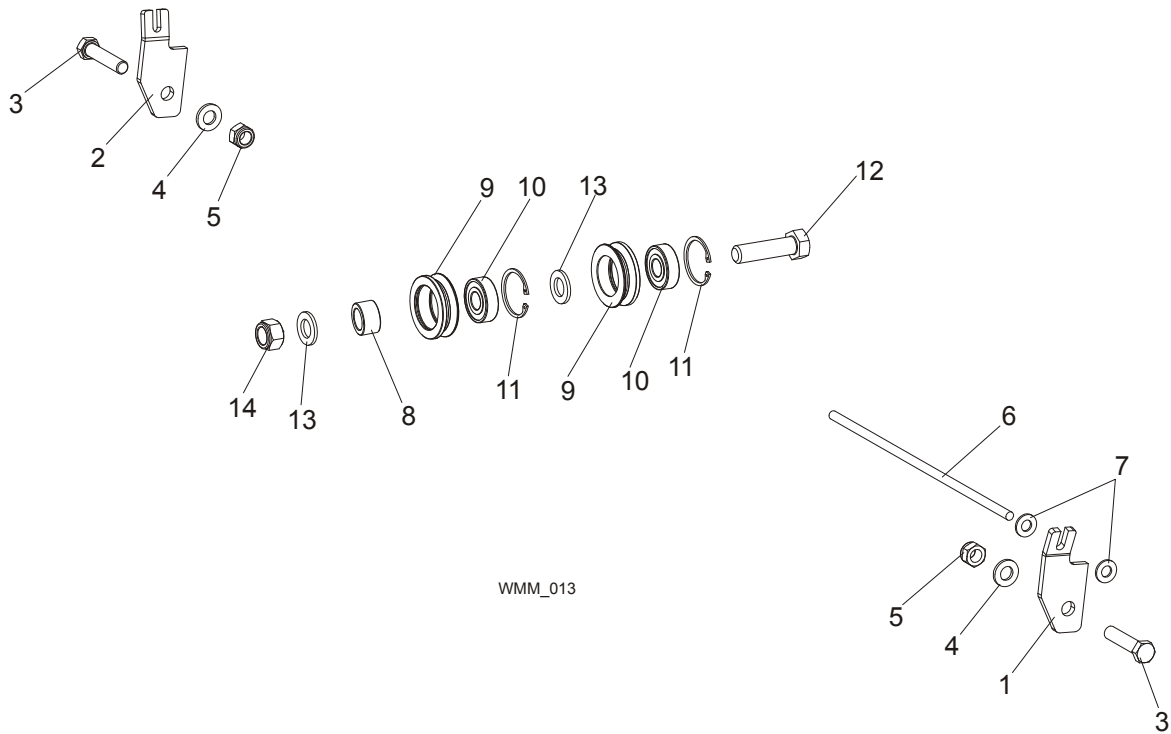


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REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>LOG CLAMP ASSEMBLY, MP100 OPTION</b>	505141-S <sup>1</sup>	1
1	ROD, SCR ZINC-PLATED	502988-1	1
2	ROD, SMOOTH	502989-1	1
3	NUT, G 3/4	502991-1	1
4	NUT, G 3/4 THIN	502992-1	1
5	JAWS, LOG CLAMP COMPLETE	502993	1
6	BRACKET, LOG CLAMP MOUNT ZINC	502994-1	2
7	BOLT, M10X20MM HEX HEAD, GR 5.8 ZINC	F81003-1	2
8	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4
9	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
10	WASHER, 10.5 FLAT ZINC	F81055-1	10
11	WRENCH, 36 FLAT ZINC-PLATED	502995-1	1
12	CLAMP JAW, MOVABLE, ADDITIONAL	504422	1

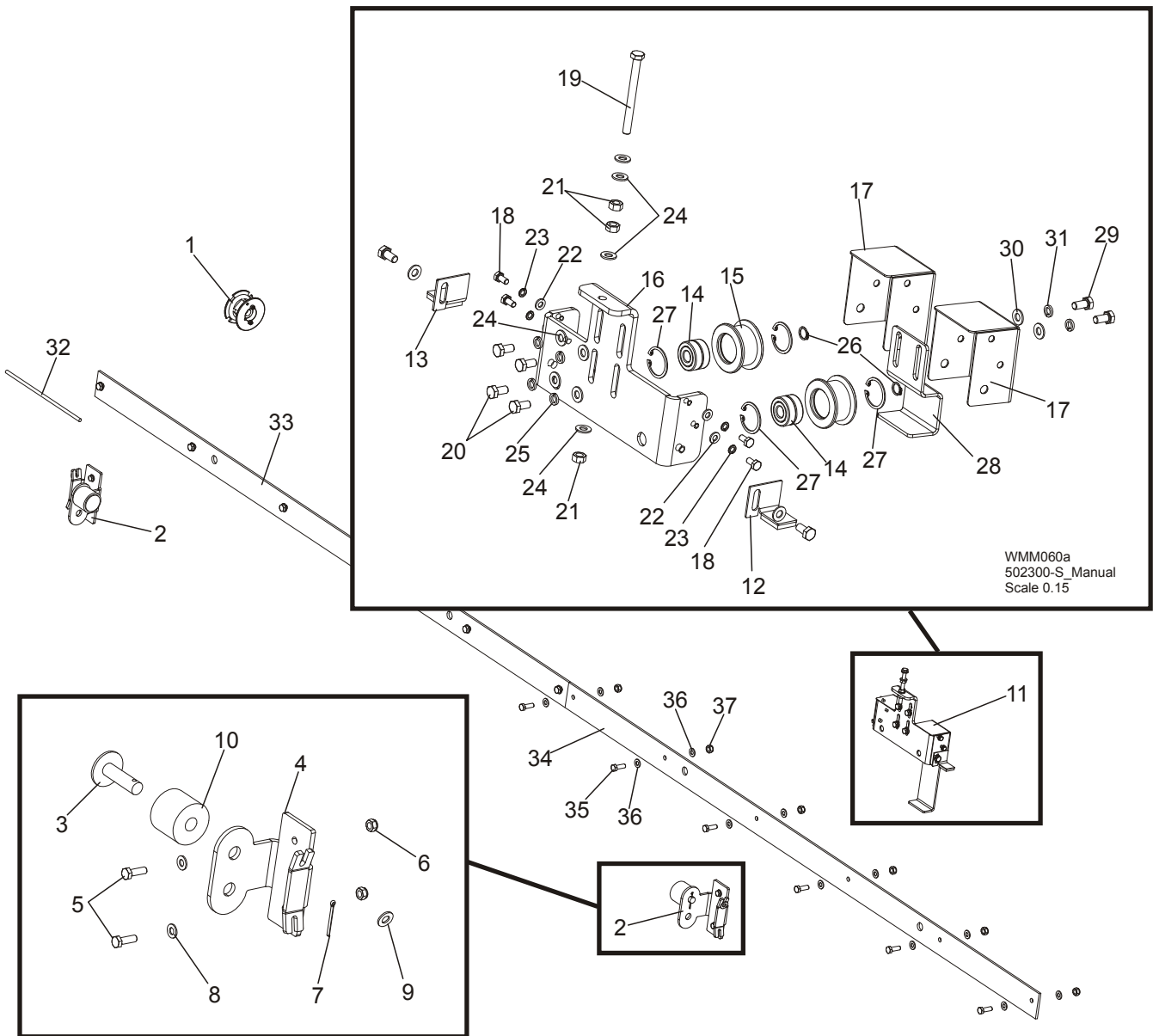
<sup>1</sup> We recommend to mount 2 clamps at least on the moulder bed frame.

**8.24 Feed Rope, V-groove Rollers & Brackets**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	BRACKET, LT15 ROPE MOUNT FRONT PAINTED	092569-1	1
2	BRACKET, LT15 ROPE MOUNT REAR PAINTED	092570-1	1
3	BOLT, M12X55-8.8 HEX HEAD ZINC	F81004-12	2
4	WASHER, 13 FLAT ZINC	F81056-1	2
5	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	2
6	ROPE, 5/16" DIA. BRAIDED POLYESTER	R02080	1
	CABLE, STEEL ZINC-PLATED	R80663	1
7	WASHER, 10.5 FLAT ZINC	F81055-1	2
8	ROPE ROLLER GUIDE SYSTEM COMPLETE	501415-1	1
	SUPPORT, ROPE ROLLER GUIDE SYSTEM	093855	2
9	SPACER, N25XN16.5X60 BEARING	093856-1	1
10	BEARING, 6203 2RS 5/8 CX	095087	1
11	RING, W40 INSIDE RETAINING	F81090-3	1
12	BOLT, M16X70 8.8 HEX HEAD FULL THREAD ZINC	F81006-16	1
13	WASHER, 17 FLAT ZINC	F81058-1	2
14	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1

**8.25 MP100 on the LT10 Bed Frame Mounting Kit**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOUNTING KIT, MP100 ON THE LT10 BED FRAME</b>	503200-S	1
1	PULLEY, MP100 MANUAL FEED COMPLETE	502527	1
2	KIT, BUMPERS AND ROPE BRACKETS	503006	1
3	MOUNT WELDMENT, CARRIAGE STOP PTD	086182-1	2
4	GUIDE, MAST	503002-1	2
5	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
6	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
7	PIN, S-ZN, 4 X 25 COTTER	F81043-2	2
8	WASHER, 8.4 FLAT ZINC	F81054-1	8
9	WASHER, 10.5 FLAT ZINC	F81055-1	2
10	BUSHING, 11/16x2 1/8x1 3/4 RUBBER	P12165	2



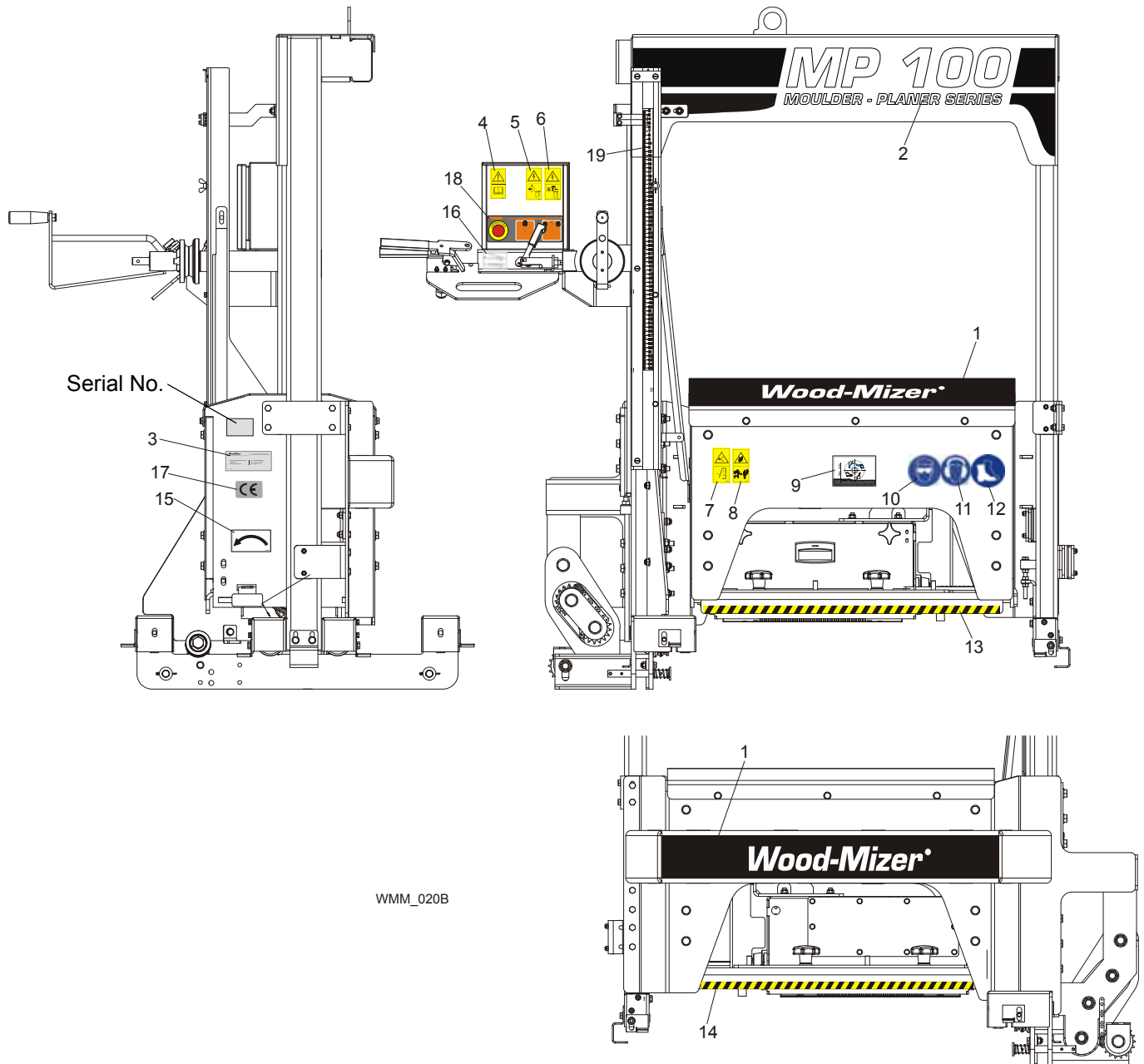
# PARTS

## MP100 on the LT10 Bed Frame Mounting Kit

11	KIT, TRACK ROLLERS AND GUIDE, LT10	503197	1	
12	PLATE, RIGHT TRACK WIPER	086322	1	
13	PLATE, LEFT TRACK WIPER	086323	1	
	KIT, MAST ROLLERS AND GUIDE	503000	1	
14	BEARING, 6201 2RS	089060	4	
15	WHEEL, MAST GUIDE - LT10 IDLE SIDE	097187	2	
16	BRACKET, TRACK ROLLERS	502998-1	1	
17	GUARD, ROLLER	503003-1	2	
18	BOLT, M6X12MM HEX HEAD ZINC	F81001-7	4	
19	BOLT, 8MM X 1.25 X 90MM HH FT ZINC	F81002-16	1	
20	BOLT, M8X16 -8.8-B-FE/ZN5 PN-85/M-82105	F81002-20	4	
21	NUT, M8 HEXAGON, GRADE 5.8 FREE ZINC	F81032-1	3	
22	WASHER, 6.4 FLAT ZINC	F81053-1	4	
23	WASHER, Z6.1 SPLIT LOCK ZINC	F81053-3	4	
24	WASHER, 8.4 FLAT ZINC	F81054-1	8	
25	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4	
26	RING, Z12 OUTSIDE RETAINING	F81090-14	2	
27	RING, W32 INTERIOR RETAINING	F81090-5	4	
28	GUIDE, MAST	503768-1	1	
29	BOLT M8x16 -8.8-B-Fe/Zn5 PN-85/M-82105	F81002-20	4	
30	WASHER, 8.4 FLAT ZINC	F81054-1	4	
31	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
	<b>MOUNTING KIT, 2 BED SECTIONS, LT10</b>	503199-S	1	
	<b>MOUNTING KIT, 3 BED SECTIONS, LT10</b>	503201-S	1	
	<b>MOUNTING KIT, 4 BED SECTIONS, LT10</b>	503202-S	1	
32	ROPE, 5/16 DIA, SOLID BRAIDED POLYESTER	R02080	1	
33	STRIP, SAFETY W/FASTENERS	503198	2/3/4	
34	STRIP, SAFETY	502997-1	1	
35	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	F81003-2	6	
36	WASHER, 10.5 FLAT ZINC	F81055-1	12	
37	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	6	



## 8.26 Moulder Decals



WMM\_020B

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>KIT, MP100 MOULDER DECALS</b>	502583	1
	<b>KIT, MP150 MOULDER DECALS</b>	505536	1
1	DECAL, WOOD-MIZER MOULDER	502581	2
2	DECAL, MP100 MOULDER TYPE	502582	1
	DECAL, MP150 MOULDER TYPE	505515	1
3	DECAL, EUROPEAN HEADQUARTERS ADDRESS	015841	1
	DECAL, WMP HEADQUARTERS ADDRESS	505761 <sup>1</sup>	1
4	DECAL, READ OPERATOR'S MANUAL (PICTOGRAM)	096317	1
5	DECAL, HIGH VOLTAGE INSIDE THE ELECTRIC BOX (PICTOGRAM)	096316	1



# PARTS

## Moulder Decals

6	DECAL, REMOVE THE PLUG BEFORE OPENING THE BOX (PICTOGRAM)	096319	1	
7	DECAL, SAWMILL COVERS CAUTION	099220	1	
8	DECAL, KEEP AWAY DANGER, PICTOGRAM	099221	1	
9	DECAL, MAXIMUM MOULDING DEPTH	502423	1	
10	DECAL, EYE PROTECTION WARNING (PICTOGRAM)	S12004G	1	
11	DECAL, EAR PROTECTION WARNING (PICTOGRAM)	S12005G	1	
12	DECAL, USE SAFETY BOOTS (PICTOGRAM)	501465	1	
13	DECAL, WARNING STRIPE (BLACK&YELLOW)	087649	1	
14	DECAL, WARNING STRIPE (BLACK&YELLOW)	502481	1	
15	DECAL, MOTOR ROTATION DIRECTION	089296	1	
16	DECAL, SAFETY HANDLE	501477	1	
17	DECAL, CE CERTIFIED SAWMILL, SMALL	P85070 <sup>2</sup>	1	
18	<b>DECAL, MOULDER CONTROL BOX</b>	502320	1	
	<b>DECAL, MOULDER CONTROL BOX - USA Version</b>	502320-UL	1	
19	<b>DECAL, MOULDER HEIGHT</b>	502505	1	

<sup>1</sup> US Version only.

<sup>2</sup> CE Version only.

## EC declaration of conformity according to EC Machinery Directive 2006/42/EC

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:

**Log Moulder**

TYPE:

MP100EH5S-1, MP150EH5S-1

No. of manufacturer:

.....

Applicable EC Directives:

EC Machinery Directive 2006/42/EC  
EC Low-Voltage Directive 2006/95/EC  
EC Electromagnetic Compatibility Directive  
2004/108/EC

Used harmonized standards:

EN861; EN 60204-1; EN 60256; EN ISO  
14121-1

Responsible for Technical Documentation:

Roman Frontczak / R&D Director

Date/Authorized Signature:

29. 03.2010



Title :

R&D Director