Wood-Mizer

from forest to final form

user manual

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

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

www.wood-mizer.eu

Wood-Mizer®

Safety, Setup, Operation, Maintenance and Parts Manual

MP100 E11-R **rev. A1.02**

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

Form #909

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, thicknessing 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.

1.2 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

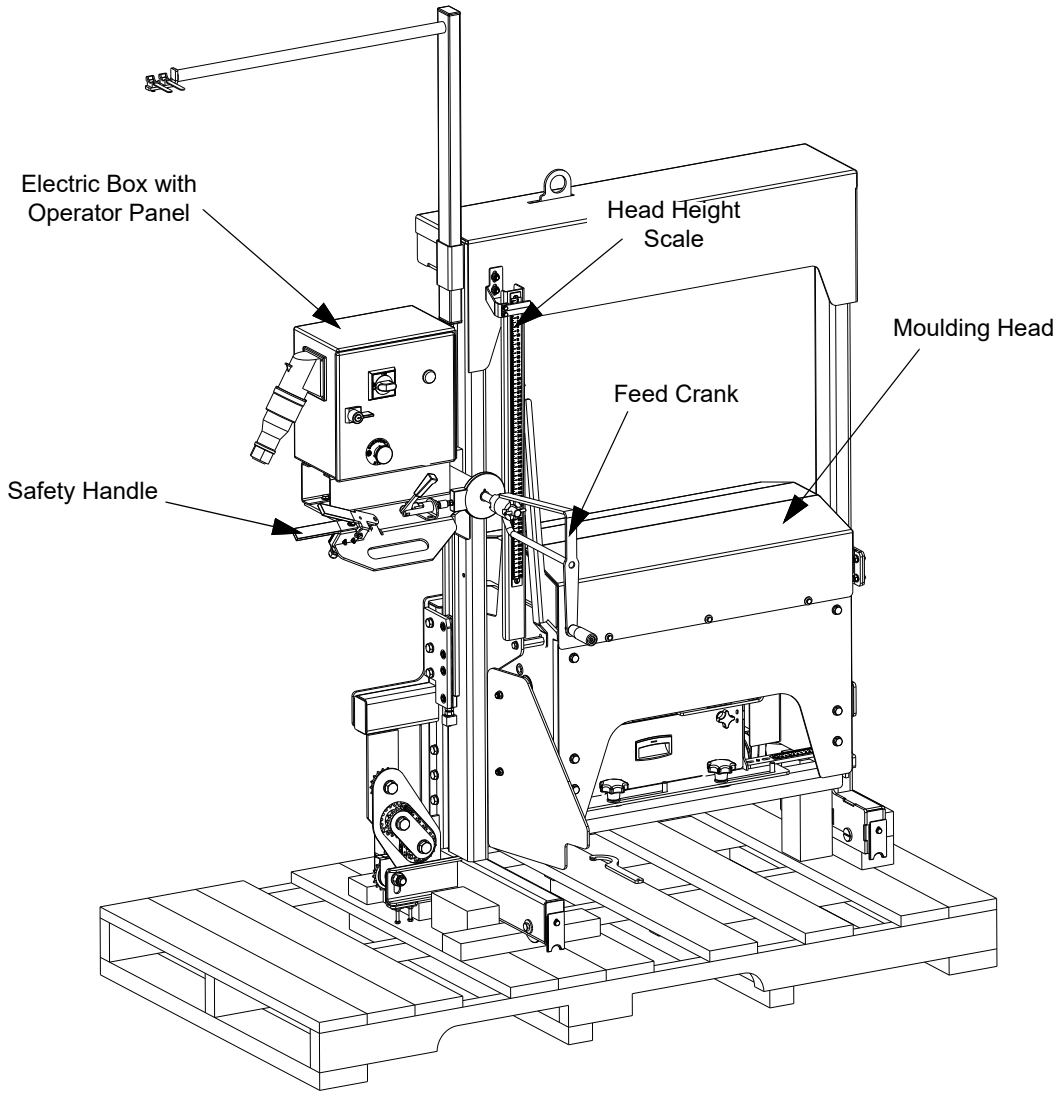


FIG. 1-0 MP100-R

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^{00}-15^{00}	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.

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

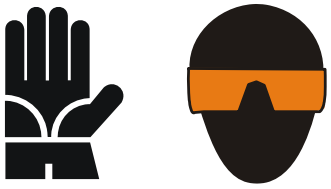
Only adult persons who have read and understood the entire operator's manual should operate the resaw. The resaw is not intended for use by or around children.

IMPORTANT! It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer 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

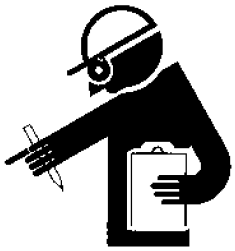
DANGER! Maintain a clean and clear path for all necessary movement around the moulder and lumber stacking areas. Failure to do so will result in serious injury.

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.

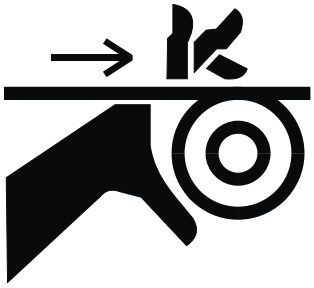
Keep Persons Away

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.

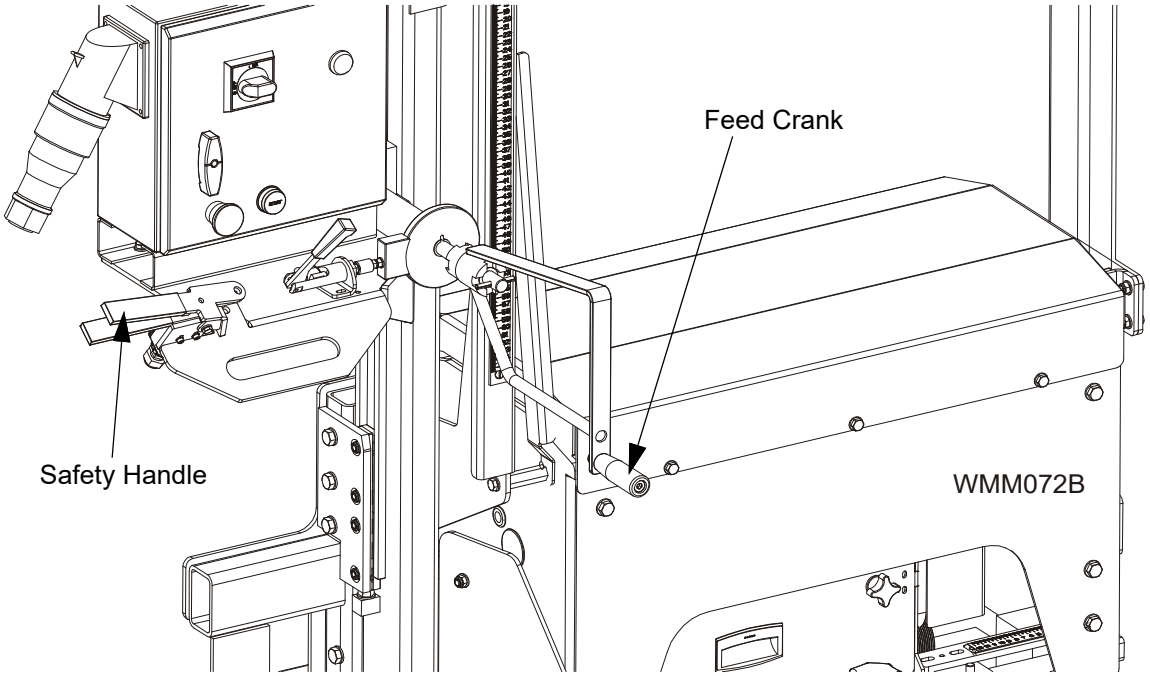


FIG. 2-1

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.

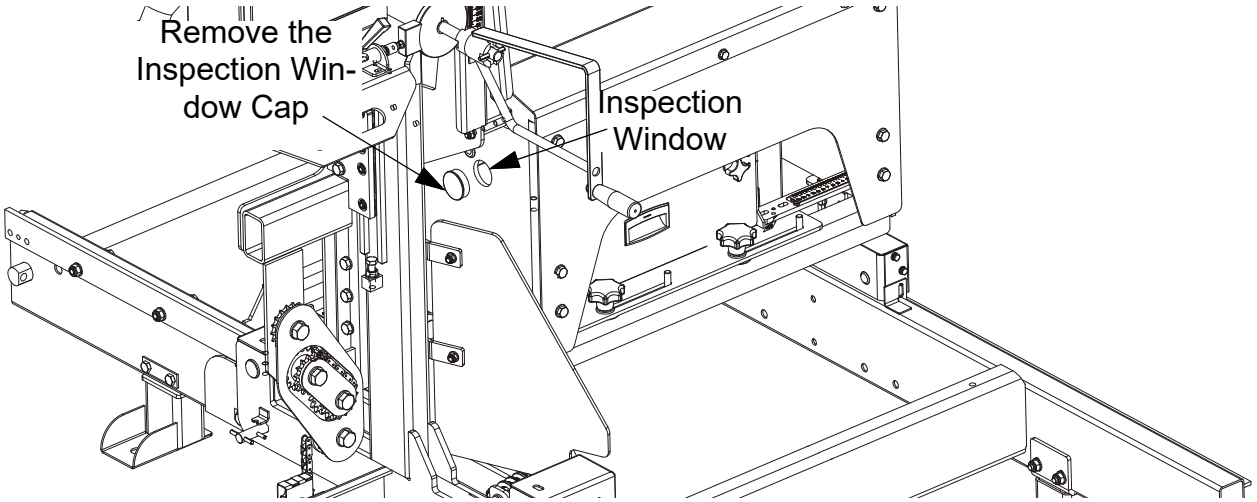


FIG. 2-2

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).

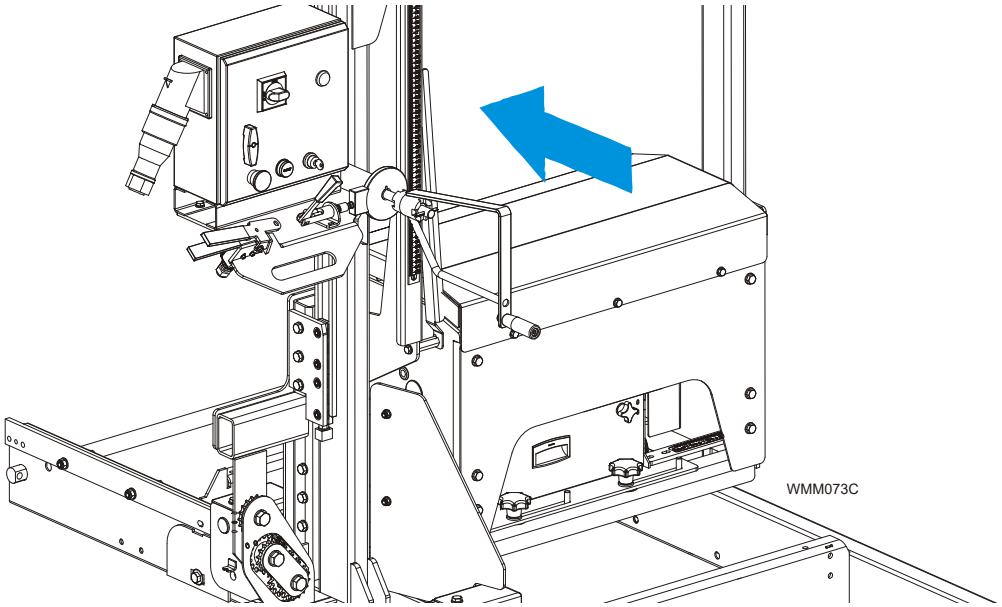
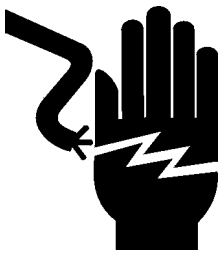


FIG. 2-3

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

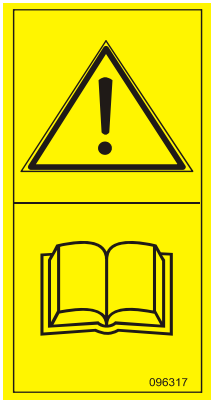
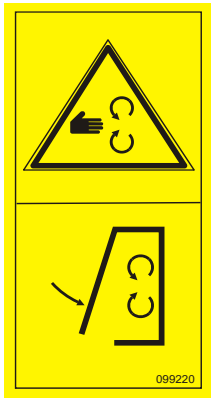
Decals View	Decal No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the moulder. Observe all safety instructions and rules when operating the machine.
	099220	Close guards prior to operating the machine.
	099221	CAUTION! Keep all persons a safe distance away from work area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

TABELA 2-1

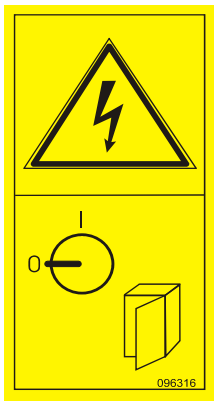
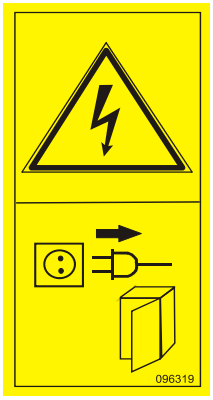
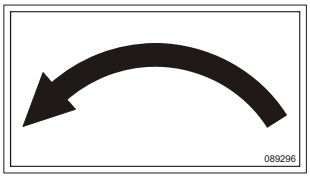
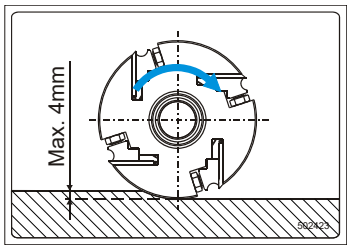
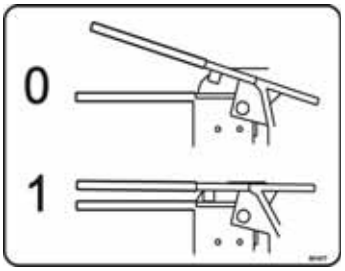
	096316	Do not open or close the electric box when the switch **is not** in the “0” position.
	096319	Always disconnect the power cord before opening the electric box.
	S12004G	Always wear eye protection equipment when operating this machine.
	S12005G	Always wear ear protection equipment when operating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

TABELA 2-1

	501465	Always wear safety boots when operating this machine.
	501467	Lubrication point
	089296	Rotation direction
	502423	Maximum moulding depth
	087649 502481	Warning stripe
	501477	Safety handle. The blade is stopped when the handle is released.
	P85070[1]	CE certified machine

SECTION 3 MOULDER ASSEMBLY

3.1 Mounting Parts of MP100 Moulders

3.1.1 MP100 Parts Specifications

Table 1:

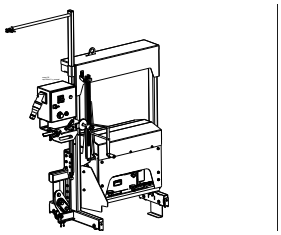
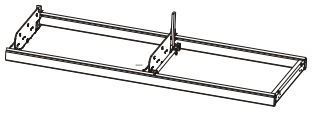
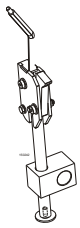
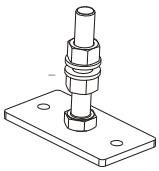
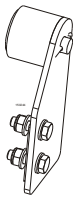
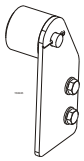
Fig.	Wood-Mizer Part No.	Description	Qty. MP100
	515625-R 514048-3	Moulder Head	1
	514972	LT15 Bed Section, Complete (2.75 m) with Side Support	3
	514955	Log Clamp	3
	514997	Log Side Support, Complete	14
	515062	Bumper, Right	2
	515063	Bumper, Left	2

Table 1:

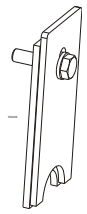
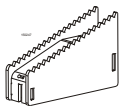
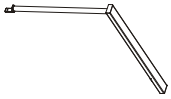
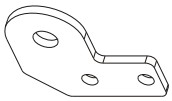
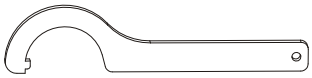
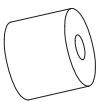
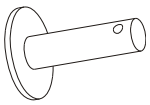
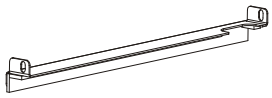
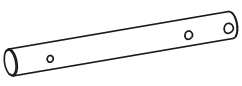
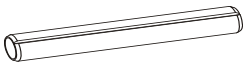
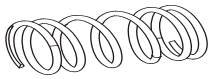
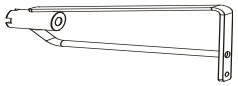
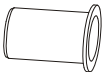
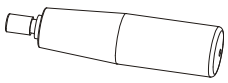
	515518	Scraper, Left, Right	4
	515413-1	Wedge	1
	515518	Track Wiper	4
	086132-1	Power Cord Bracket	1
	501414-1	Plate, LT15 Power Feed Support	2
	502443	Wrench, Bearing Nut	1
	502848	Alignment Tools Set, ELBE RF 100120	1
	095919	Bottom Bracket	2
	P12165	Bushing, Rubber	2
	086182-1	Mount Wdmt, Carriage Stop	2
	086745	Middle Track Cover with Felt Wiper	1
Vertical Mast Lock Assembly			
	086743-1	Zinc-plated Pin	2

Table 1:

	F81045-1	Roll Pin 6x50	3
	F81044-21	Roll Pin 3x20	2
	087301	Compression Spring 18x37x1.8	2
	F81043-2	Cotter Pin S-Zn 4x25	4
	F81058-1	Flat Washer 17	2
	502505-UL	Scale, Inch	-
	505886	Scale, Inch Knife	-
	093369	Wrench, 13 mm Open Ended/Box	-
Manual Feed Assembly			
	508238-1	Power Feed Crank Handle	1
	094142	Bushing	2
	086338	Crank Handle Grip	1
	F81033-1	M10 Hex Nylon Lock Nut	1

3.1.2 Tools Necessary for Assembling the Moulder

Table 2:

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.

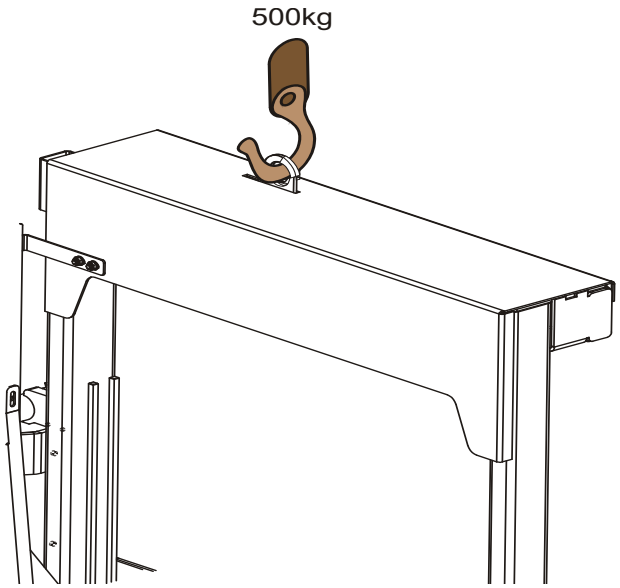


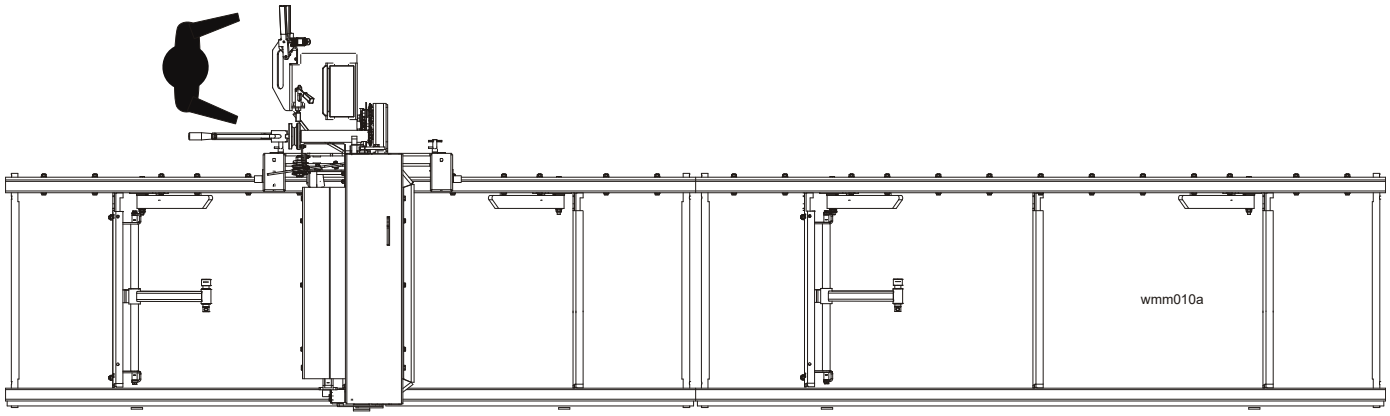
FIG. 3-1

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 not be operated outdoors when it is raining/snowing and in case of rain/snow, the machine must be stored under roof or indoors.
- 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[1].
- 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^2 to 15m/49 ft length
3ph 230 VAC	20 A	13 AWG/2,5 mm^2 to 15m/ 49 ft length
3ph 460 VAC UL	15 A class J	11 AWG / 4mm^2
1ph 230 VAC UL	70 A class J	7 AWG / 10mm^2

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.

WARNING! In case of drive belt breakage, wait until all rotating parts are completely stopped. Failure to do so may result in serious injury.

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.

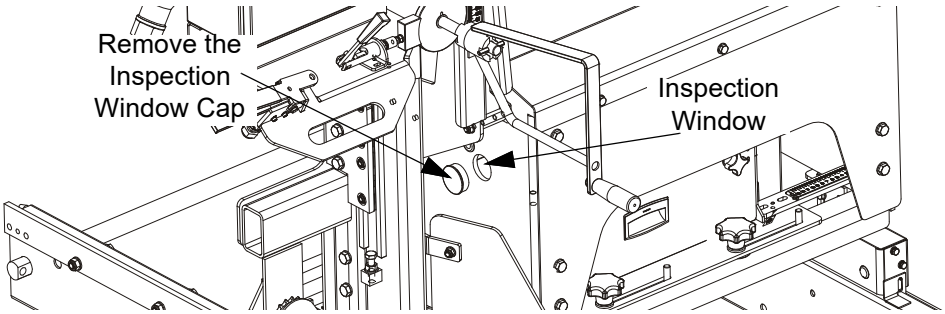


FIG. 4-1

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 *6.1* 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 4-2.

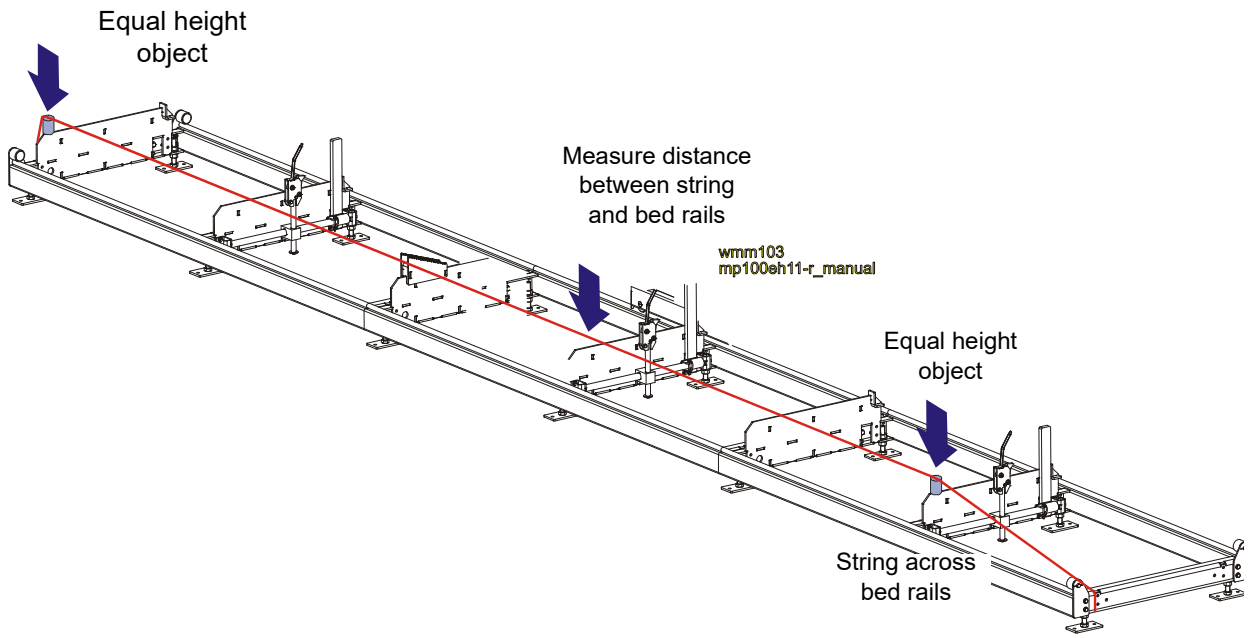


FIG. 4-2

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 4-3.

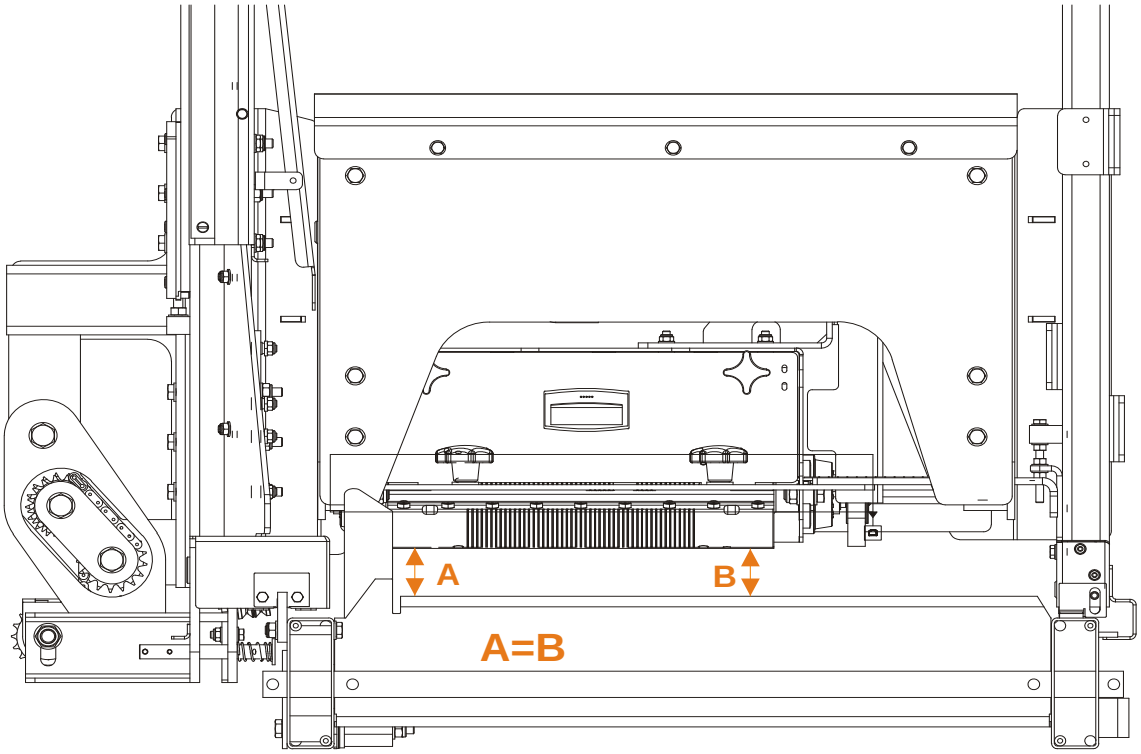


FIG. 4-3

7. If the dimensions A and B are not the same, adjust the head tilt as shown in the Figure 4-5.

See Figure 4-4. 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.

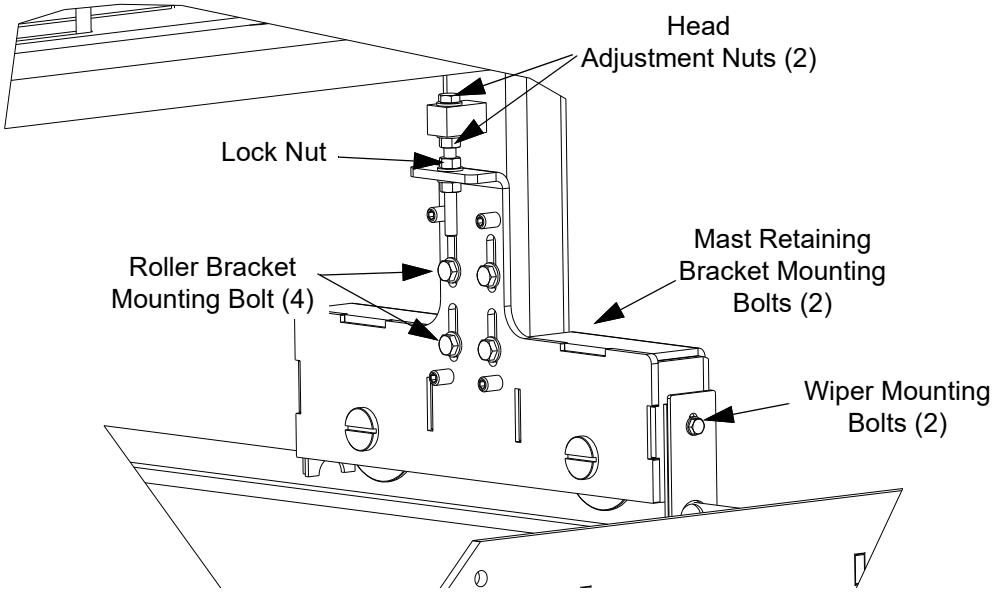


FIG. 4-4

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.

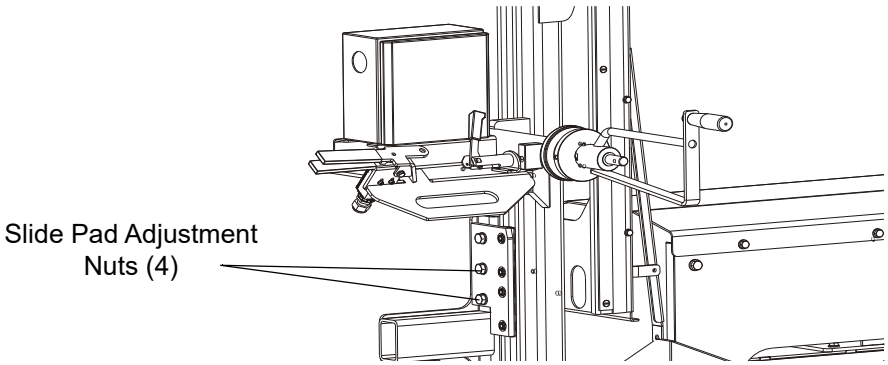


FIG. 4-5

4.2 Log Clamp Operation

To Clamp Logs

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

See Figure 4-6.

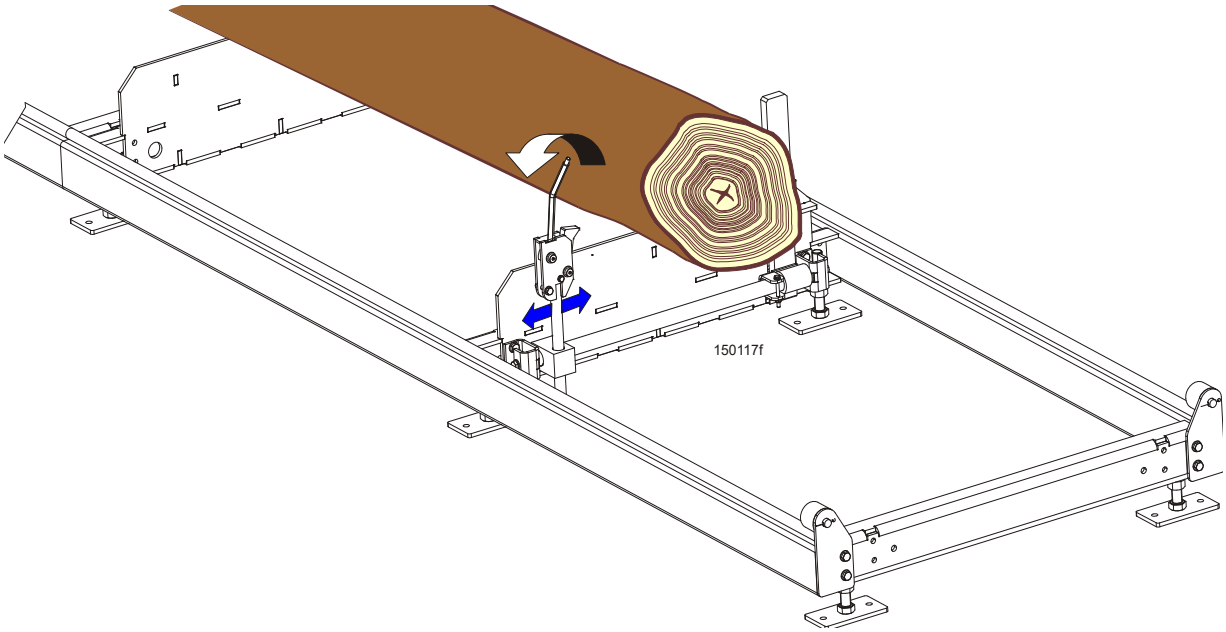


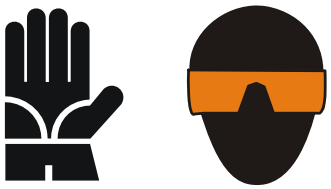
FIG. 4-6

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

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.

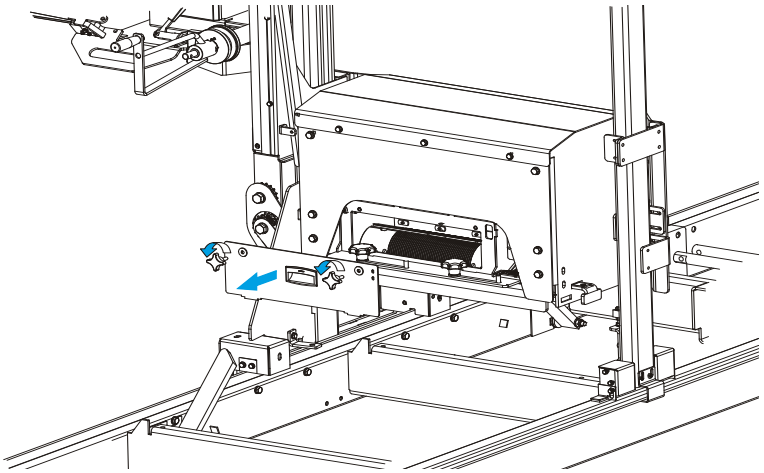


FIG. 4-7

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.

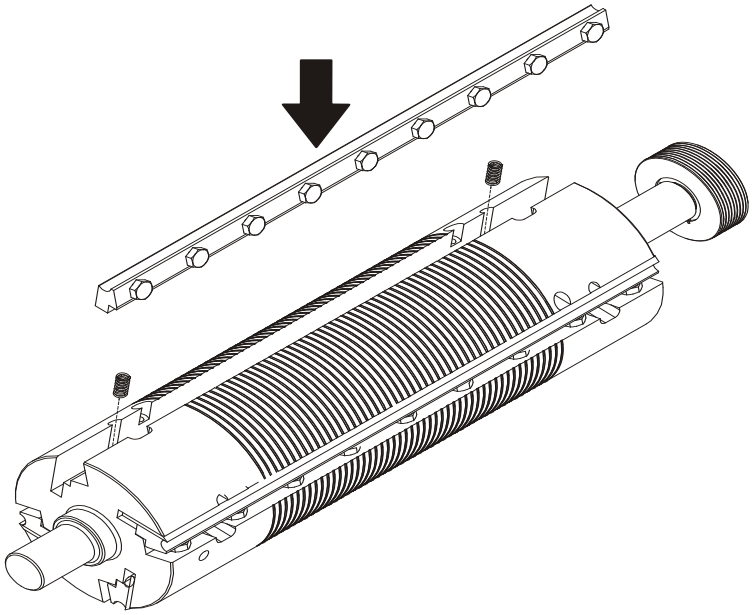


FIG. 4-8

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

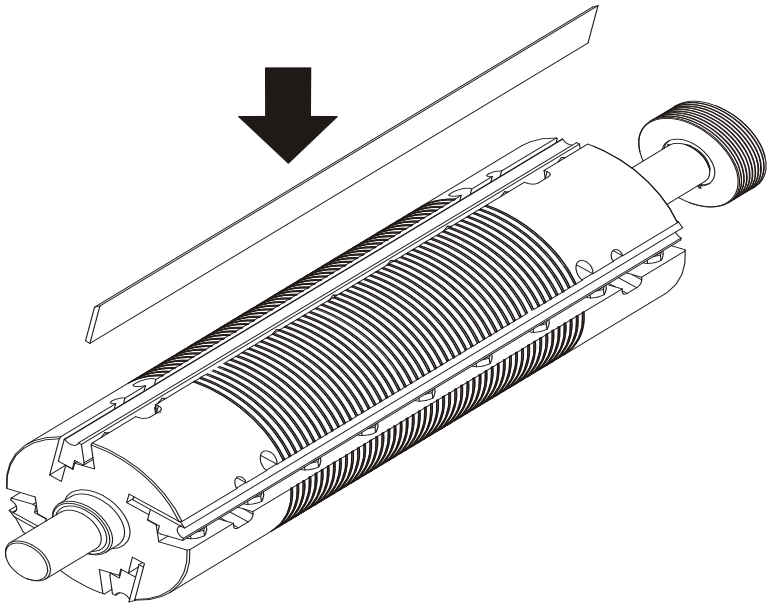


FIG. 4-9

5. Place the magnetic gauge on both end of the cutter shaft, over one of the knives. Gauge magnetic feet should adhere to the shaft. Set the desired knife height on the scale. Tighten the scale adjustment bolt. Loosen all mounting strip bolts. Magnets should pull up the knife to the desired height.

See Figure 4-10.

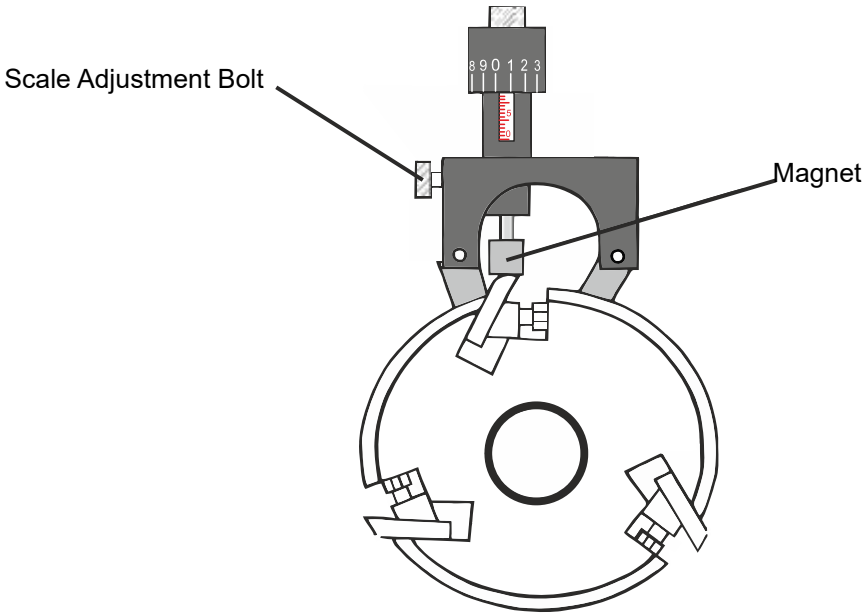


FIG. 4-10

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.

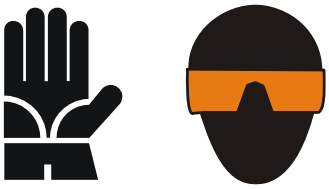
To remove the knife from the cutter, loosen the mounting strip bolts. Carefully remove the knife.

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.

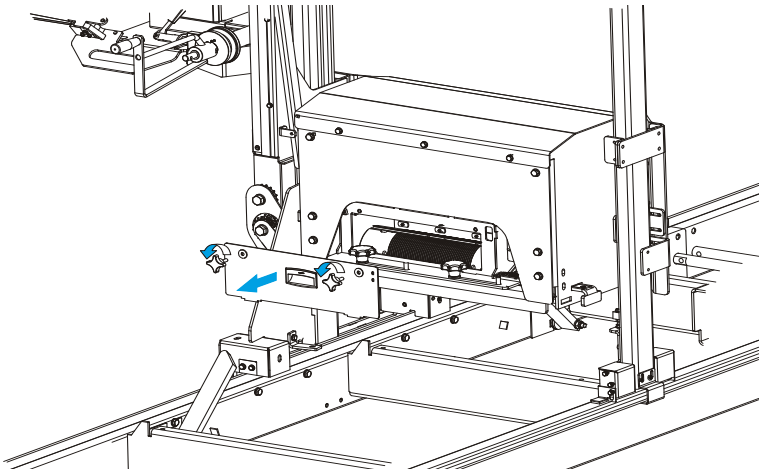


FIG. 4-11

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.

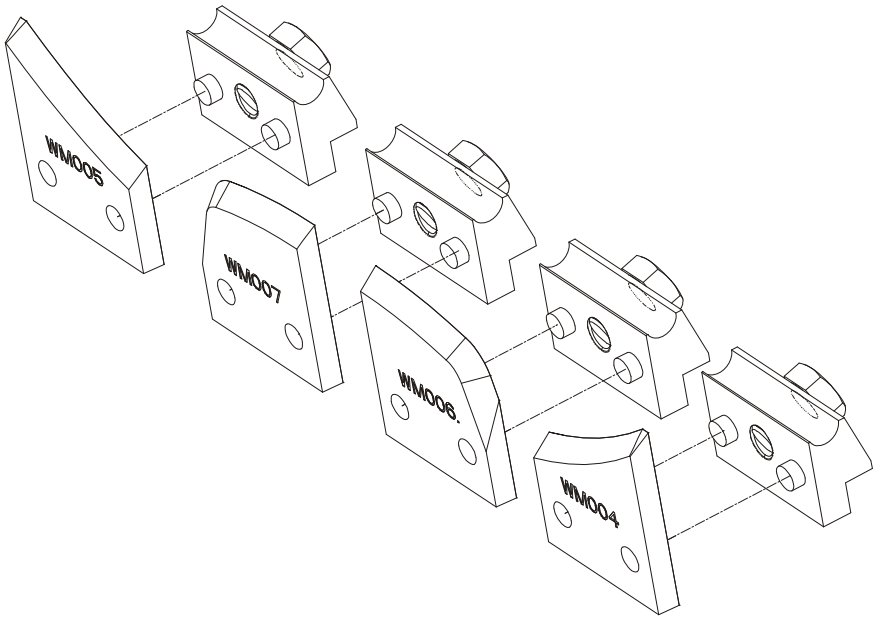


FIG. 4-12

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

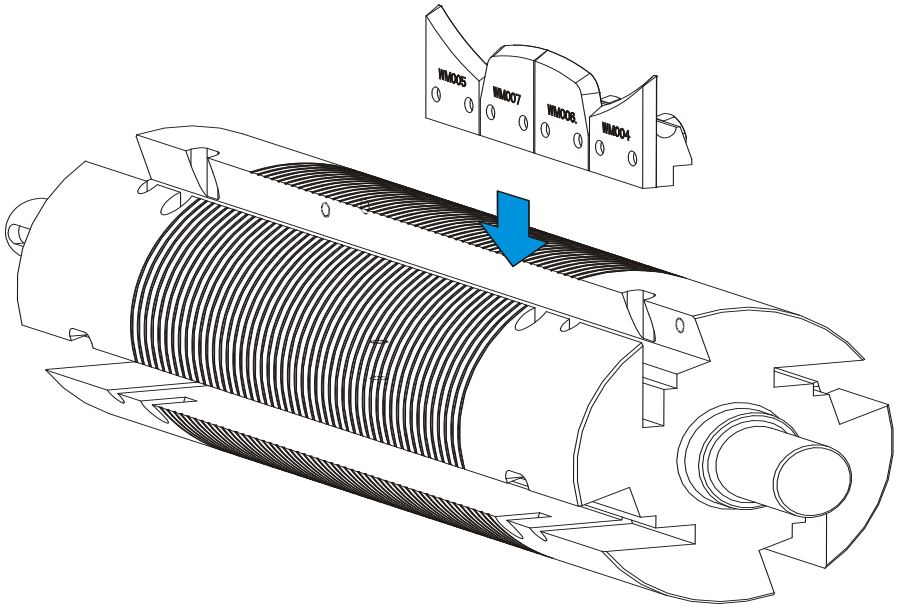


FIG. 4-13

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

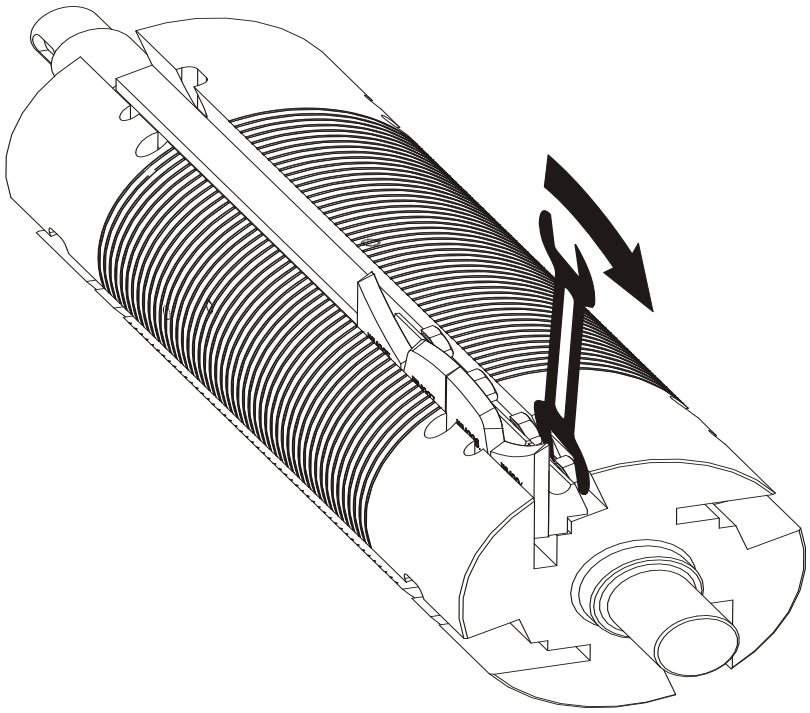


FIG. 4-14

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.

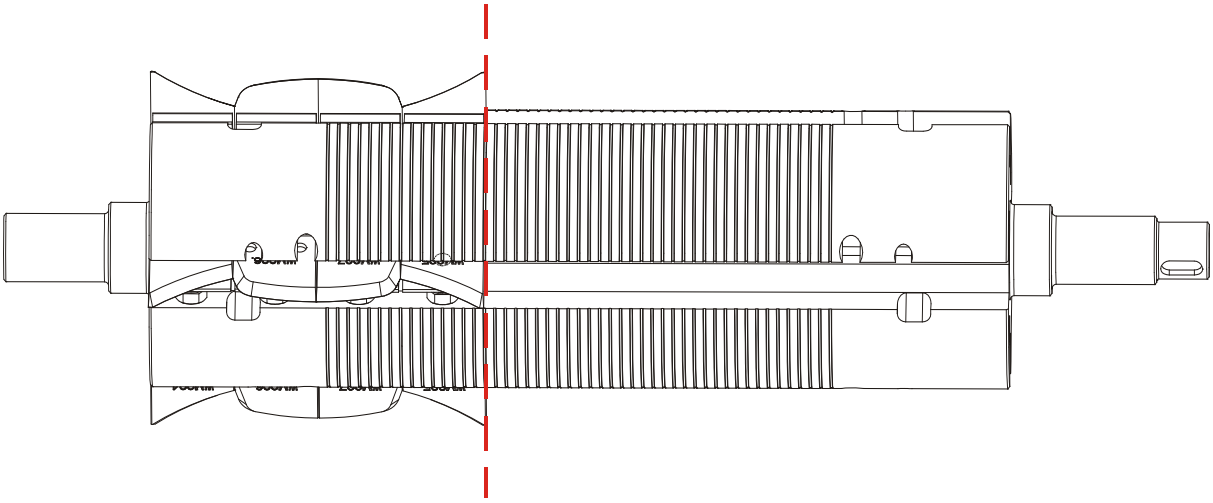


FIG. 4-15

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.

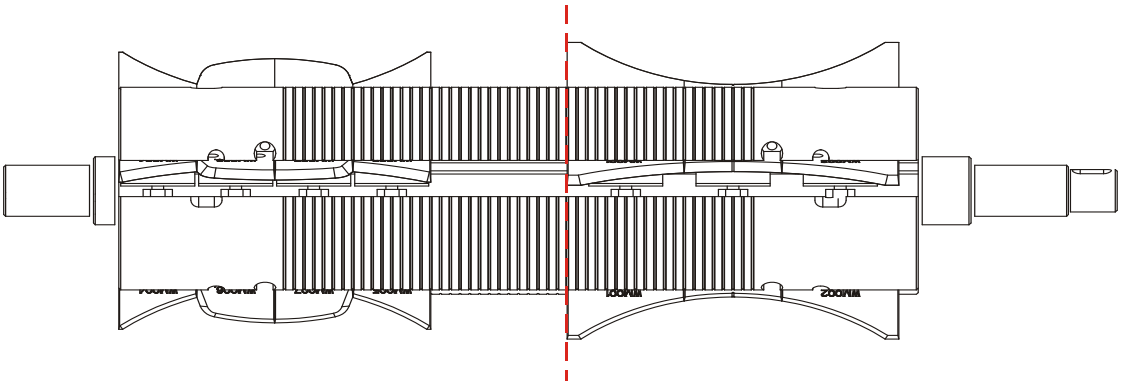


FIG. 4-16

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.

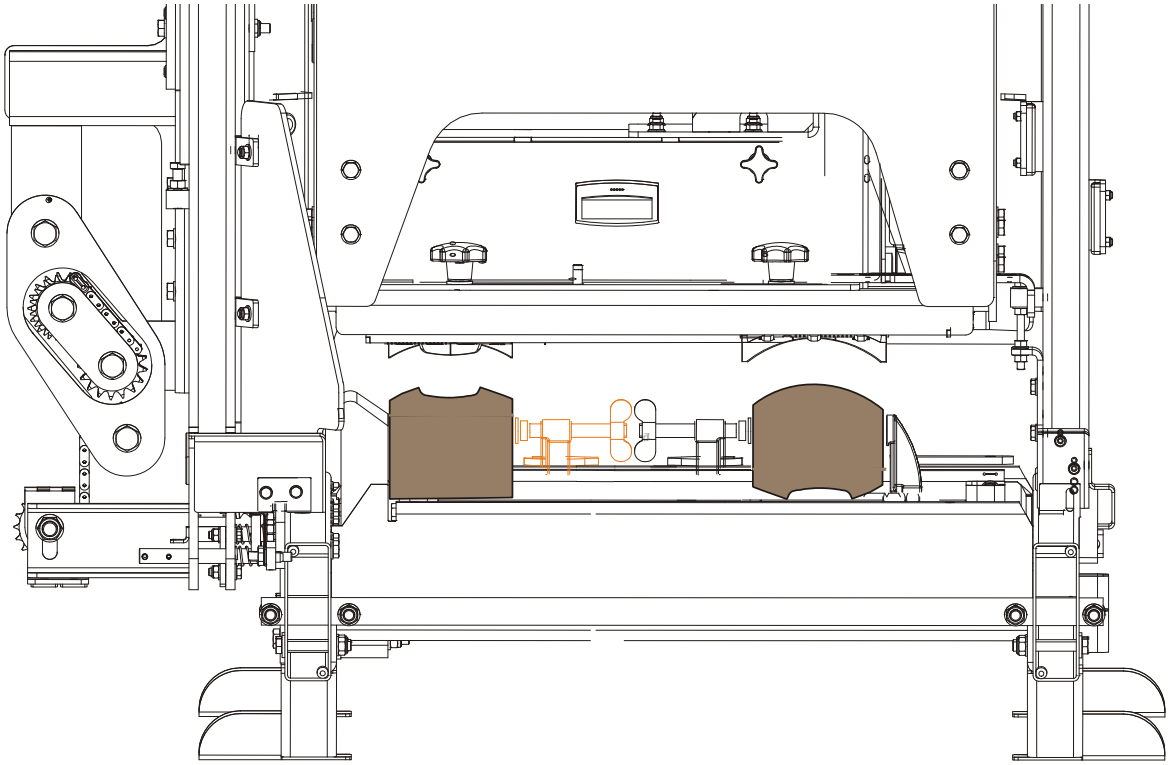


FIG. 4-17

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

4.5 Moulder Operation, MP100

4.5.1 Control Overview

See Figure 4-18. The controls of the MP100 moulder are shown below:

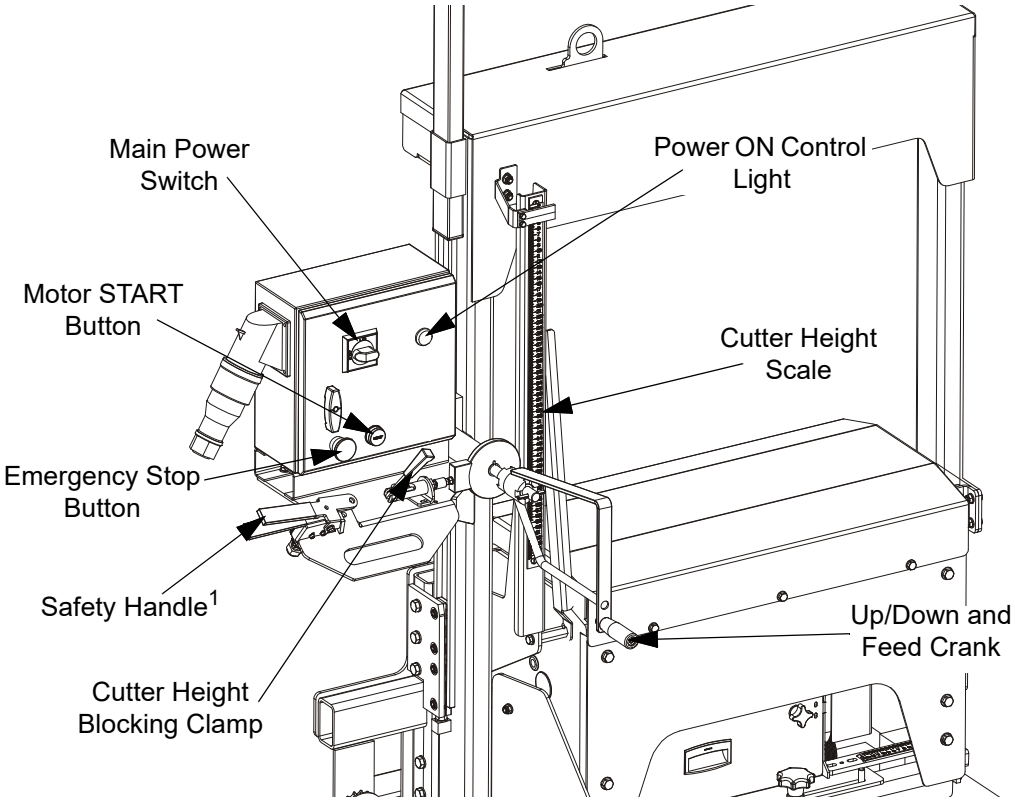


FIG. 4-18

1. **Safety Handle**[1]

   Stops the cutter motor when released.

2. **Motor START Button**

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

3. **Main Disconnect Switch**

   Disconnects power from all electrical circuits of the machine.

4. **Power ON Control Light**

   Indicates the power supply.

5. **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.

6. Cutter Height Scale

Indicates the cutter height.

7. 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.

8. 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).

4.5.19 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 4-19.

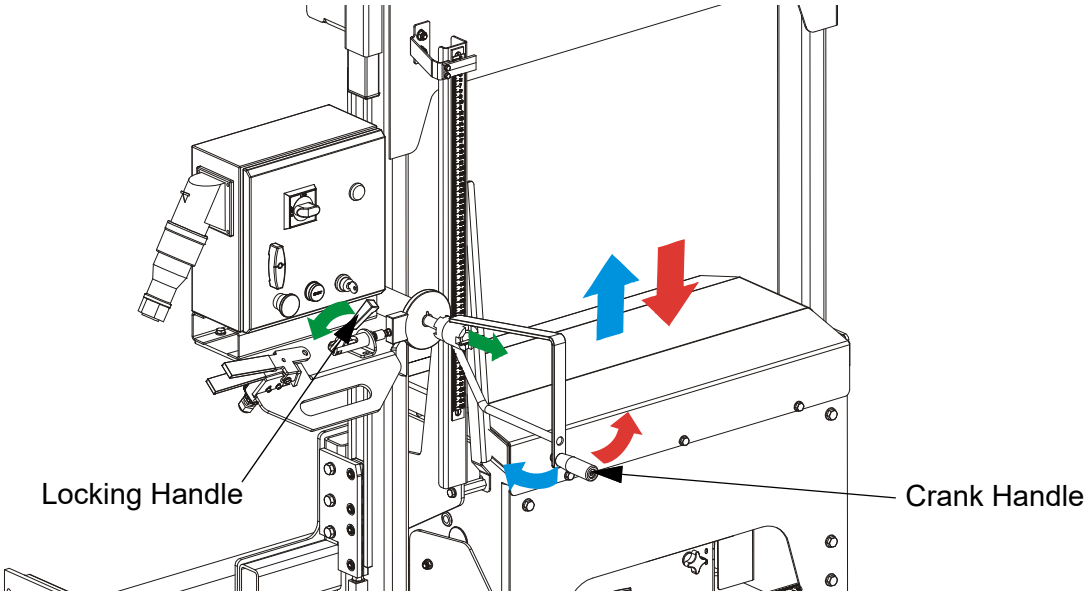


FIG. 4-19

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.

4.5.20 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 4-20.

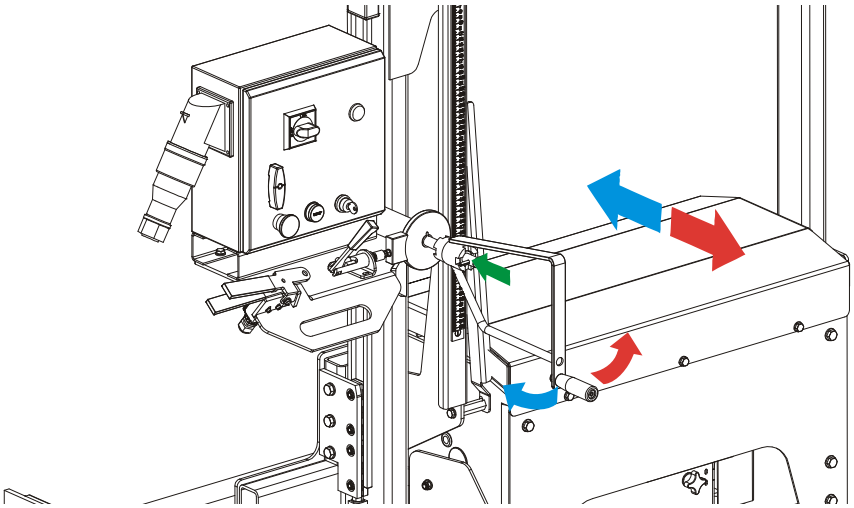


FIG. 4-20

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 4-21.

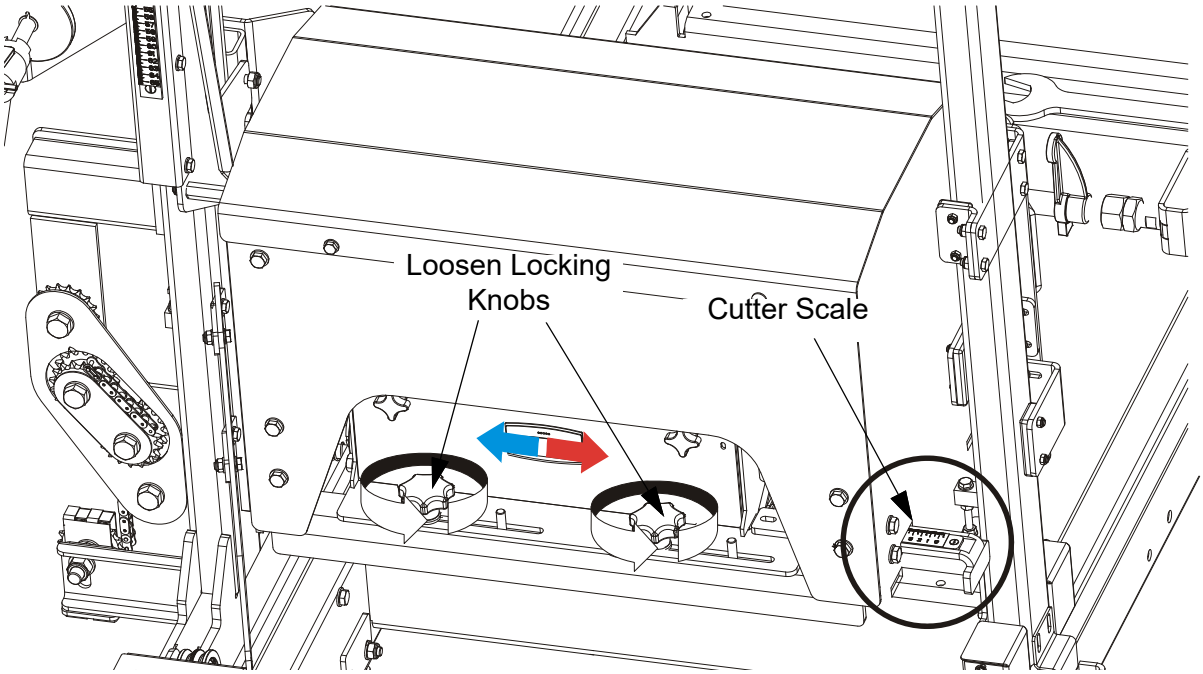


FIG. 4-21

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.[1]
4. Turn the key switch to  position.[1]

1 It does not concern the US version.

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

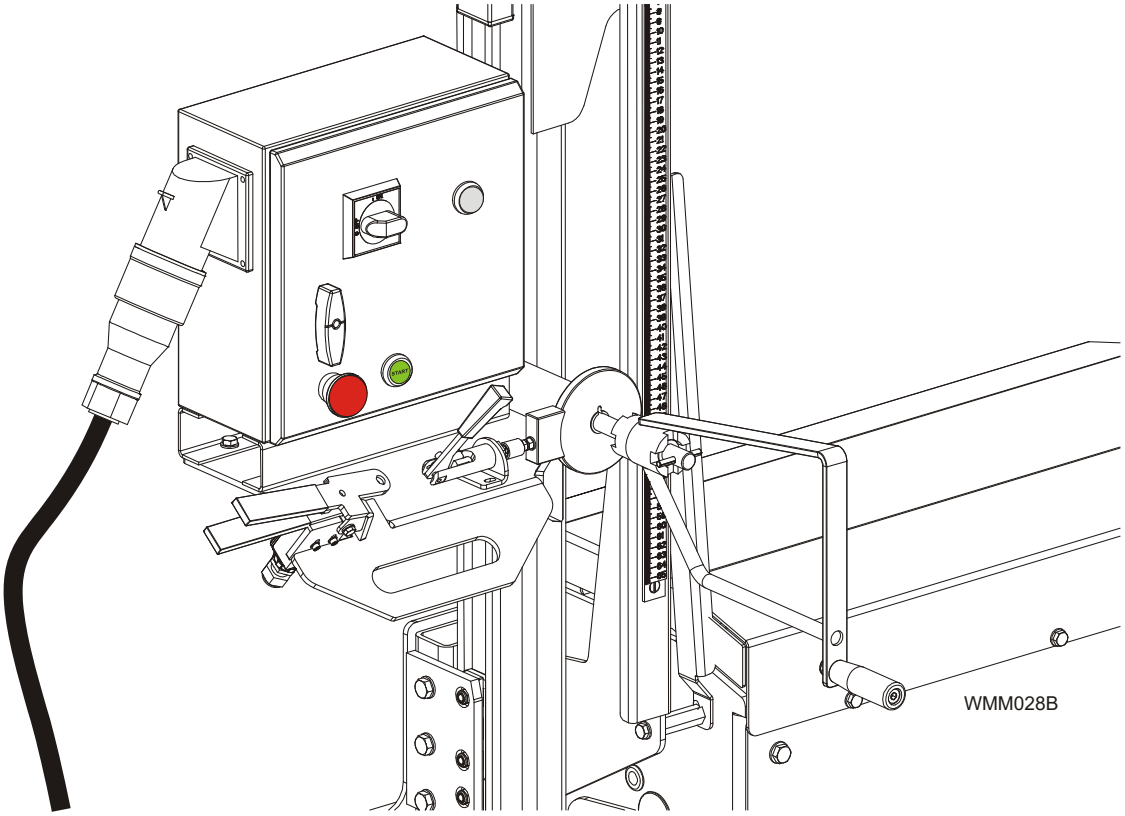
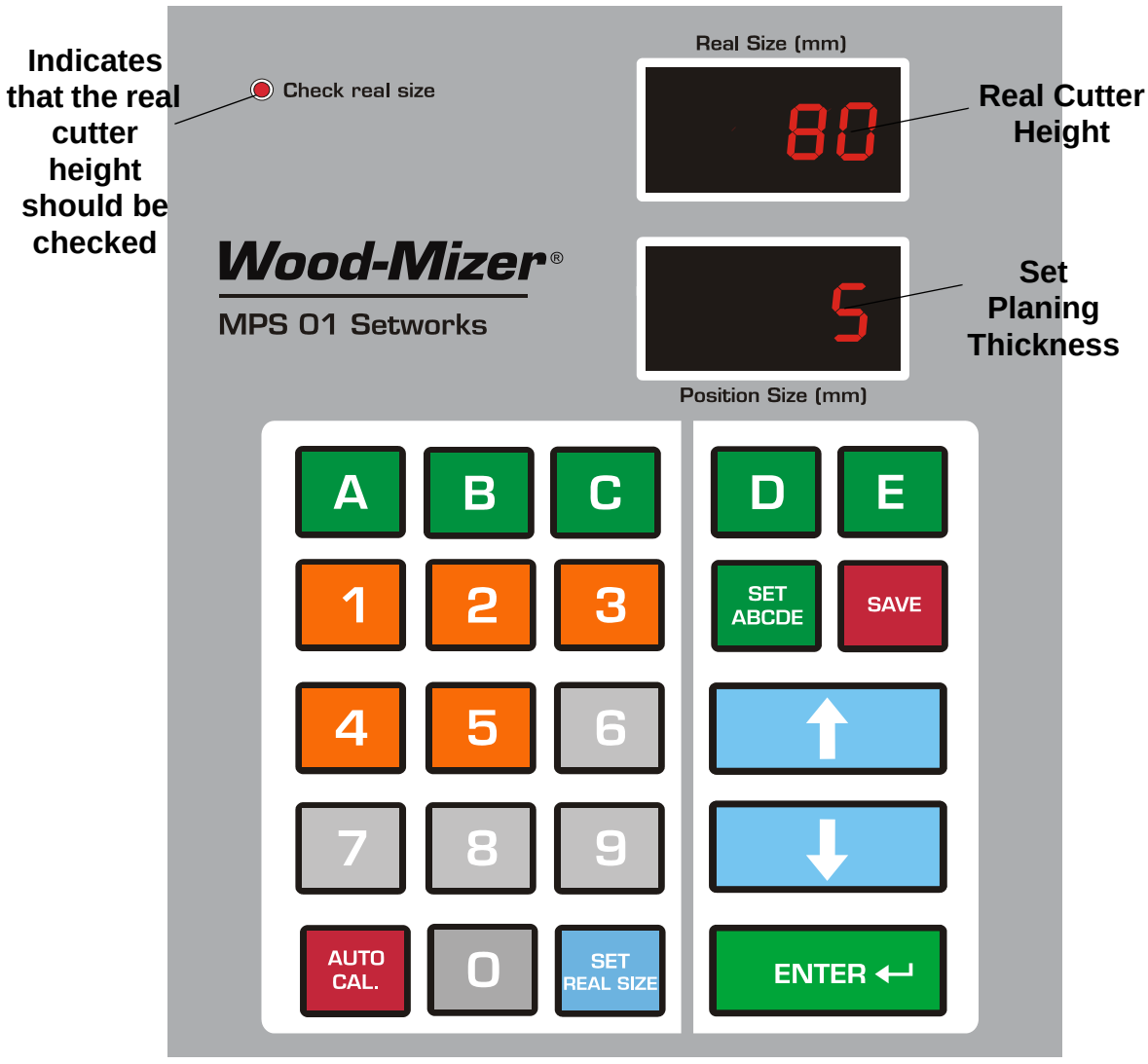


FIG. 4-22

SECTION 5 SETWORKS 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 Setworks memory

Auto Mode – adjustment of the Setworks 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.

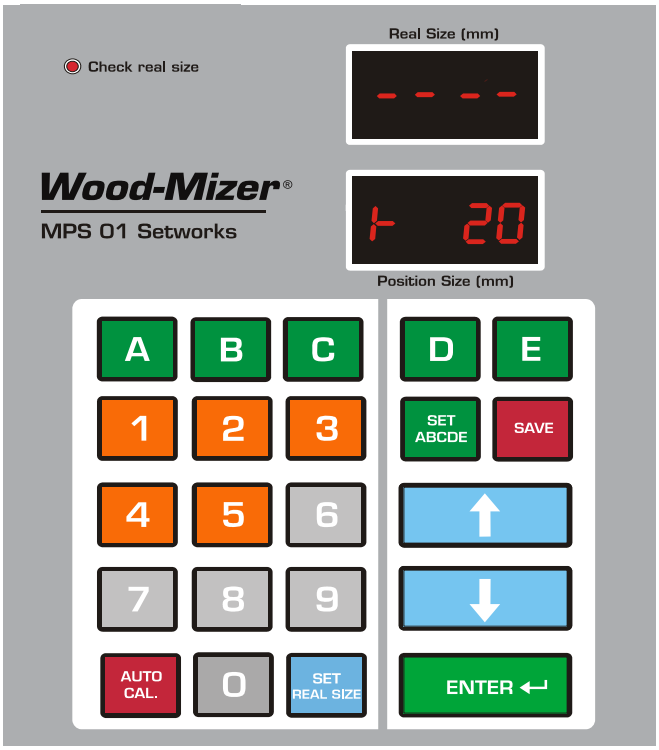
5.2 Start-up settings of the controller

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

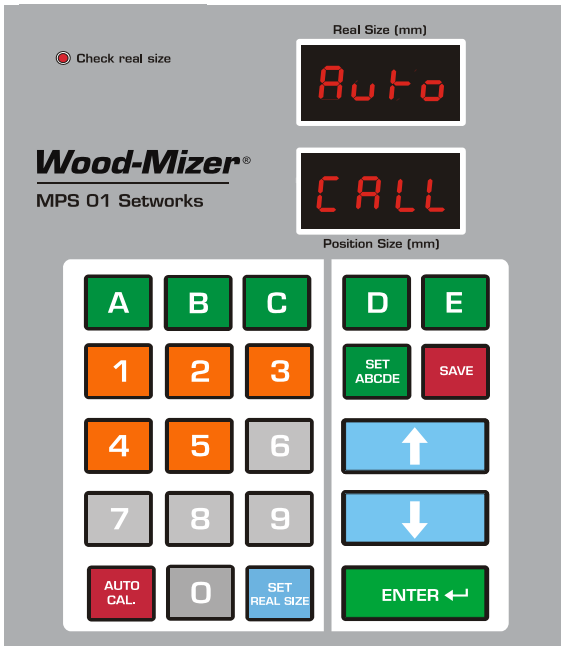
- Press SAVE to save the entered divider value.

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 AUTO CAL. . 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 AUTO CAL. 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 SET REAL SIZE,
- 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 SAVE.

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 ENTER ↵ 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.

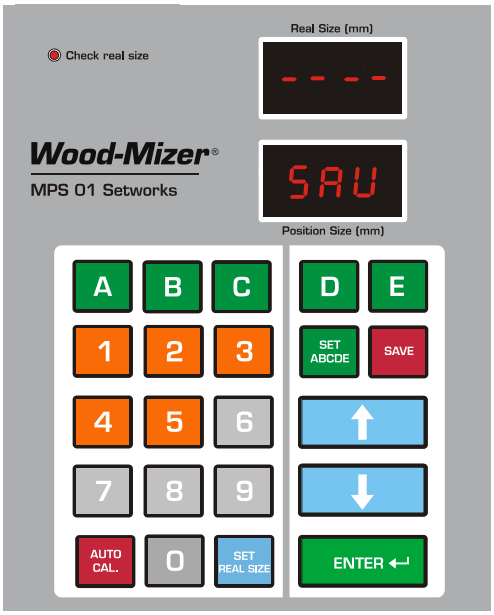
- To automatically lower the cutter, enter the required value (from 1mm / 0.039” - 5 mm / 0.197”) using the keypad and press ENTER ↵. The cutter will automatically be lowered by the entered value.

- 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 SET ABCDE. 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 SAVE. Perform the same procedure for other memory buttons.

See Pic. 5-4.



PIC. 5-4

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

NOTE: If the "Check real size" light starts blinking during normal operation of the Setworks, press and hold the SET REAL SIZE 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 SAVE.

SECTION 6 MAINTENANCE

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

0 **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

8 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.

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

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.

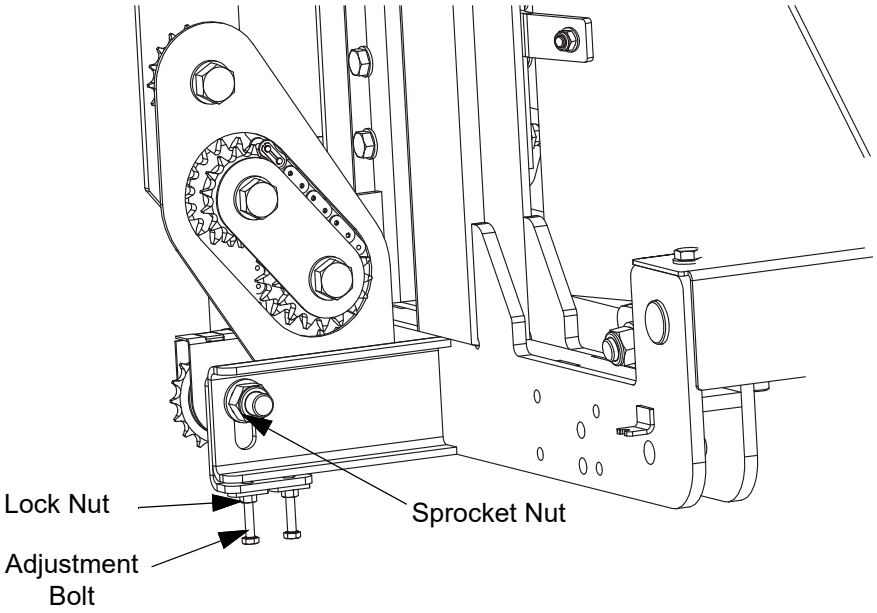


FIG. 6-2

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.

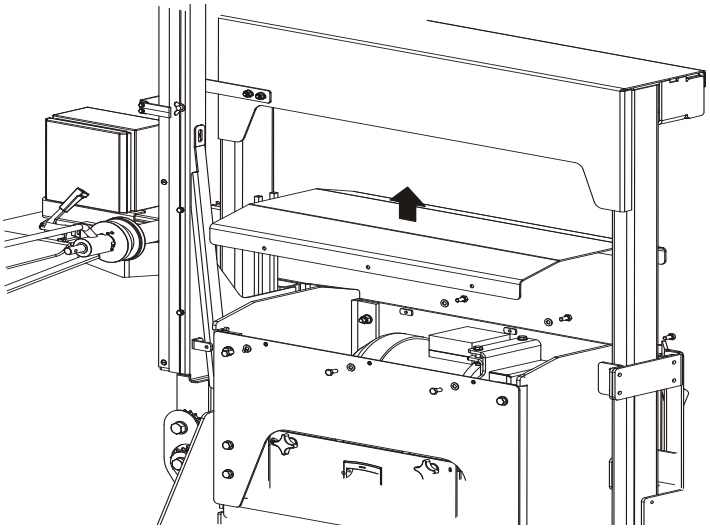


FIG. 6-2

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

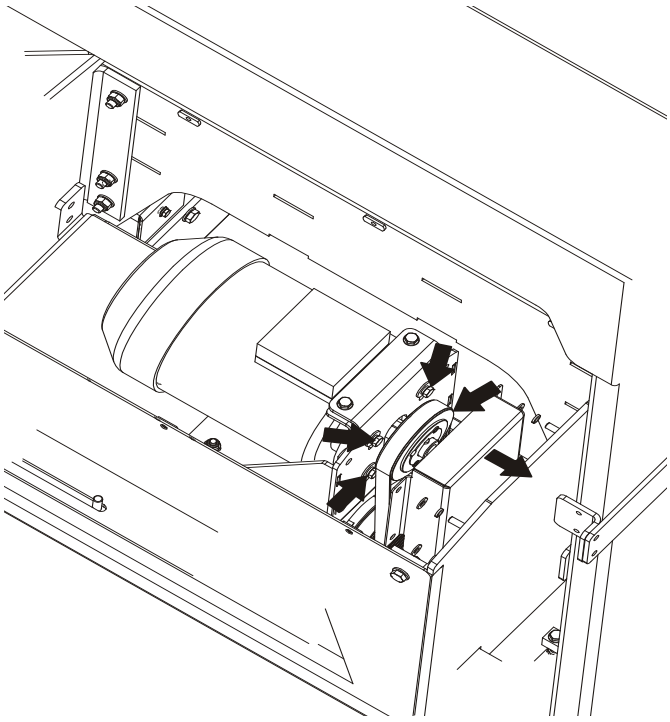


FIG. 6-2

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

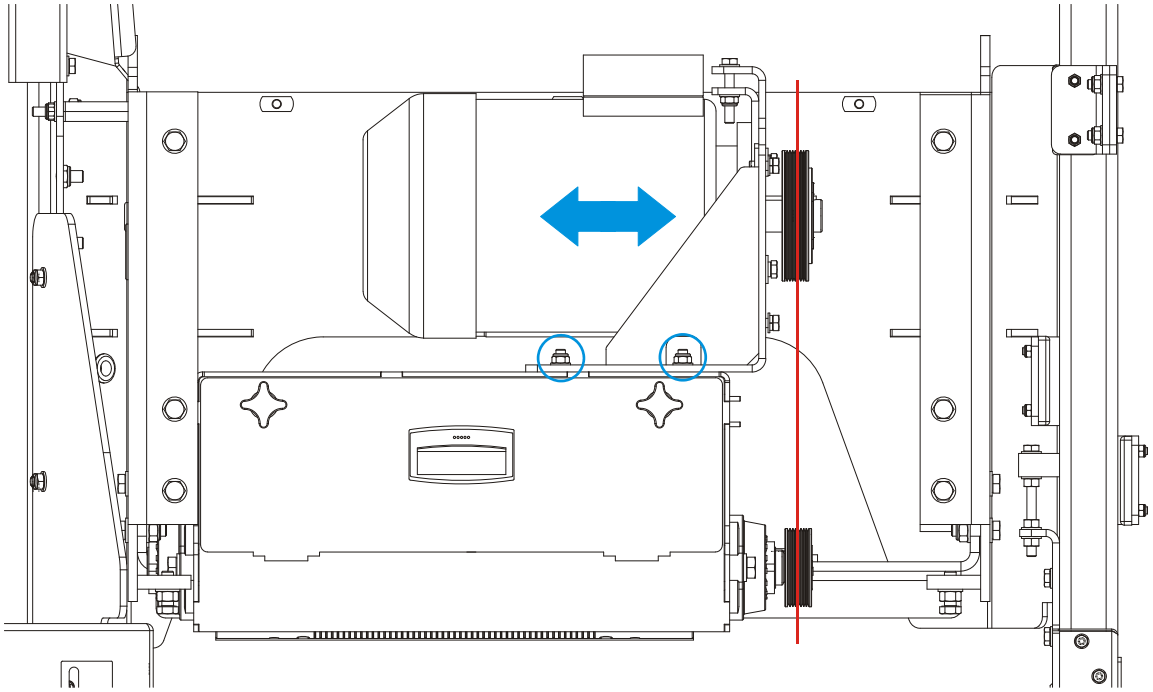


FIG. 6-2

4. 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 kgf (98 N) deflection force.

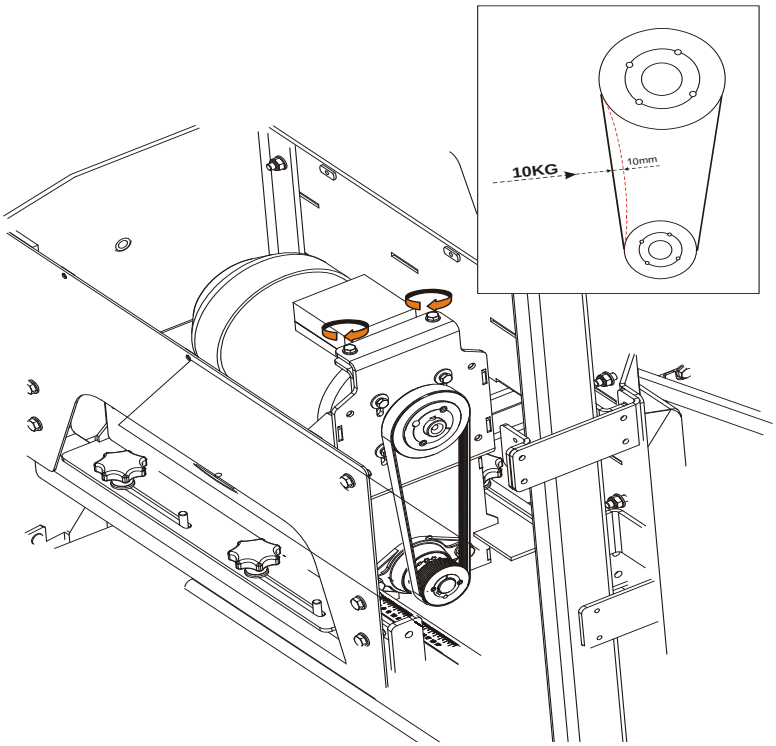


FIG. 6-2

CAUTION! After replacement of the motor drive belt, always adjust the belt tension as desribed 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 Safety Devices Inspection

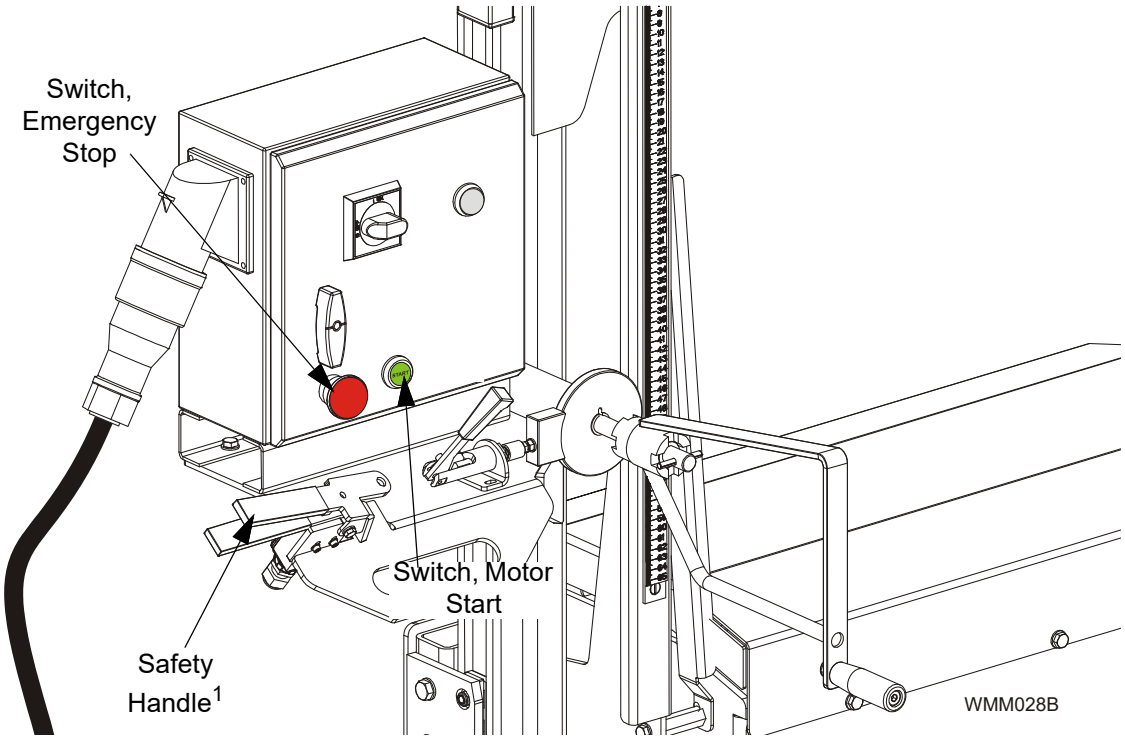
MP100E11-R Moulder – Safety Devices Inspection

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[1]
- Cutter cover safety switch and its circuit inspection.

1. E-STOP button and its circuit inspection

- Press and hold the safety handle;[1]
- 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

- Be sure the E-STOP button is released;[1]
- 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.[1]
- 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.[1]

3. Cutter cover safety switch and its circuit inspection

- Be sure the E-STOP button is released;
- Press and hold the safety handle;[1]
- 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

- Be sure the E-STOP button is released;
- Press and hold the safety handle;[1]
- Turn on the motor;
- Release the safety handle. Measure the cutter braking time. It should be shorter than 10 seconds.[1]

1. It doesn't concern US version.

SECTION 7 SPECIFICATIONS

7.1 Overall Dimensions

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

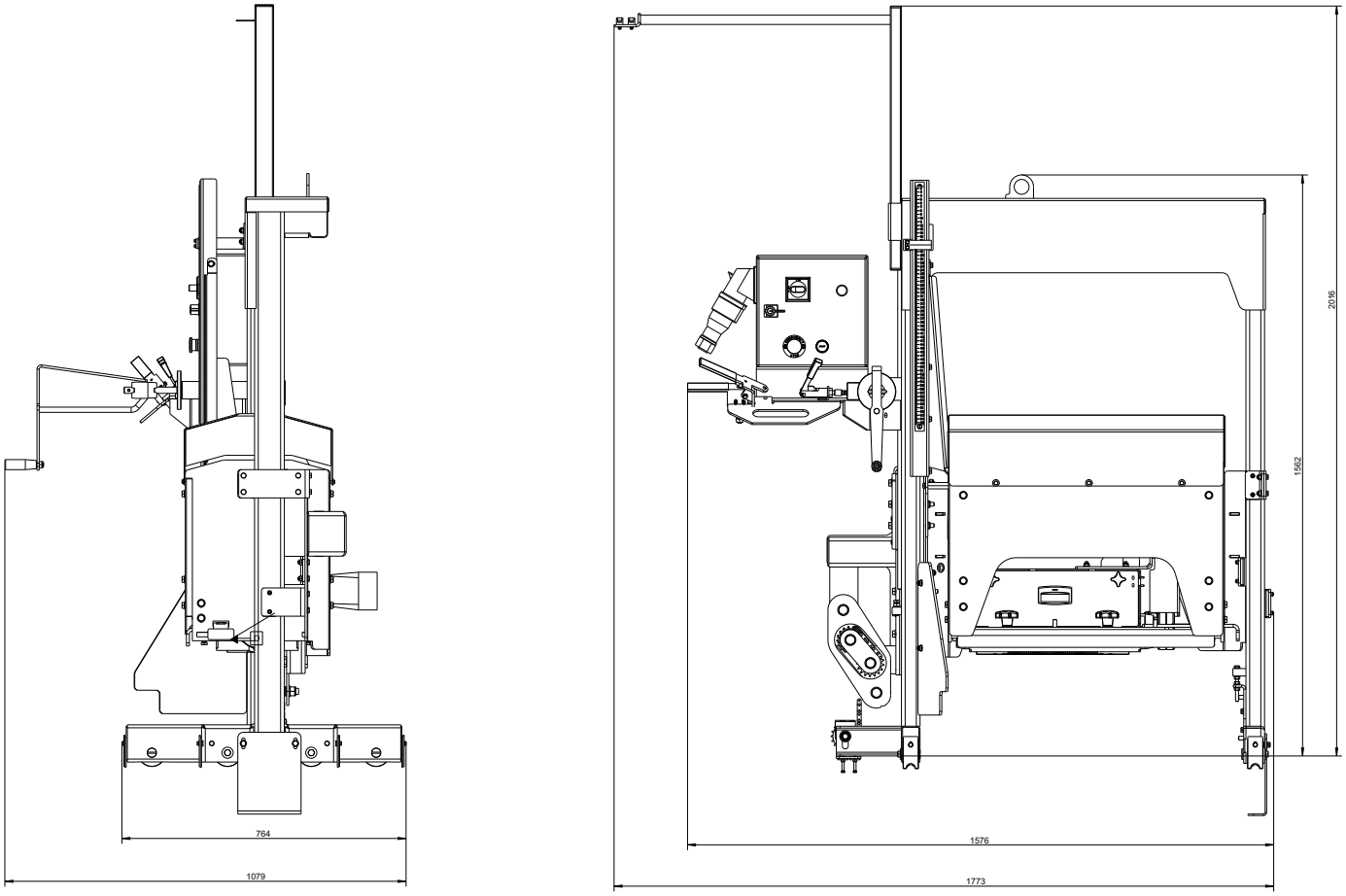


FIG. 7-1 MP100

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

Moulder Type	MP100-R
Weight	350 kg
Height	1562 mm
Width	1576 mm
Length	1079 mm

TABLE 7-1

7.2 Moulder Specifications

See Table 7-2. See the table below for the Wood-Mizer moulder nomenclature.

	Voltage
MP100EH11-R	**3 ph 400V**

TABLE 7-2

See Table 7-3. See the table below for the Wood-Mizer moulder main motor specifications.

	Motor Specifications
Motor Type	**E11** Electric Motor
Manufacturer	Indukta, Poland
Voltage	400V 50Hz
Maximum Current	16 A
Motor RPM	2885 RPM
Rated Output	7,5kW (11HP)
Manufacturer Part #	3SKG-112 B5 IE3
WM Part #	592796

TABLE 7-3

See Table 7-4. The noise level of the MP100 moulder is given below.[1 2 3]

	Equivalent Noise Level Under Load
MP100 Moulder	L_{pA} = 87dB (A)

TABLE 7-4

See Table 7-5. 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 [1]	520 mm (20.47”)

TABLE 7-5

[1] Using horizontal adjustment

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard. Value for associated uncertainty K=4dB.
2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission 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.
3. **IMPORTANT!** The total value of hand-arm vibration the operator may be exposed to does not exceed 2.5 m/s^2. The highest root mean square value of weighted acceleration to which the whole operator’s body is subjected does not exceed 0.5 m/s^2.

See Table 7-6. 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 7-7)

TABLE 7-6

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

Pattern Knife Thickness	Pattern Knife Max. Protrusion [1]
3 mm	13 mm (0.512”)
4 mm	21 mm (0.827”)
5 mm	29 mm (1.142”)

TABLE 7-7

[1] According to EN 847-1:2005 European Standard

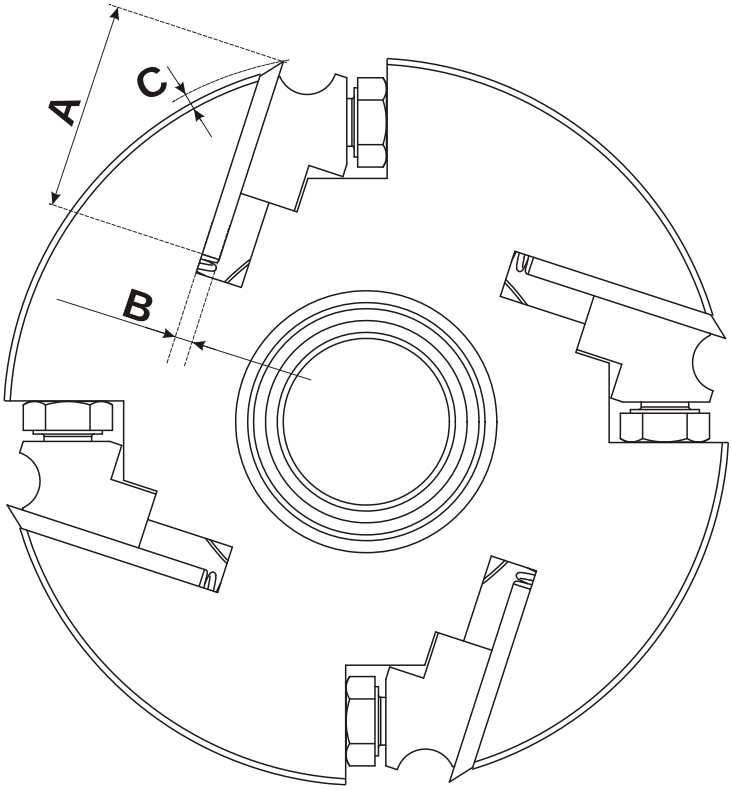


FIG. 7-1

7.3 Dust Extractor Specifications

See Table 7-8. Specifications of the dust extractors used on the for each saw head are listed below.[1]

Airflow	1200 m^3/h 3937ft^3/h
Inlet diameter	100 mm (5.9”)
Motor power	1,5 kW
Number of sacks	1 pcs
Sack capacity	0,25 m^3 $(8.8\ ft)^3$
Weight	110 kg (242.5 lb)
Pressure drop	1,5 kPa (0.22 psi) [1]
Recommended conveying air velocity in the duct	20 m/s 65.6 ft/s

TABLE 7-8

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

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

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

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

1. External chip and dust extraction equipment with fixed installations are dealt with in EN 12779:2016-04

SECTION 8 MOTOR BRAKE

8.1 Motor Brake Maintenance

Maintenance intervals

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

TABLE 8-1.

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

Please observe the following for inspections and maintenance operations:

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

Checking the rotor thickness

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

- Remove the motor cover and seal ring (if mounted).
- Measure the rotor thickness with a caliper gauge. On brakes with friction plates, observe edging on outer diameter of friction plate.
- Compare measured rotor thickness with minimally permissible rotor thickness. *See Table 8-2.*.
- Replace the complete rotor if necessary.

Check the air gap

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

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

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

TABLE 8-2.

SECTION 9 REPLACEMENT PARTS

9.1 How to use the parts list

- Use the index above to locate the assembly that contains the part you need.
- 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.

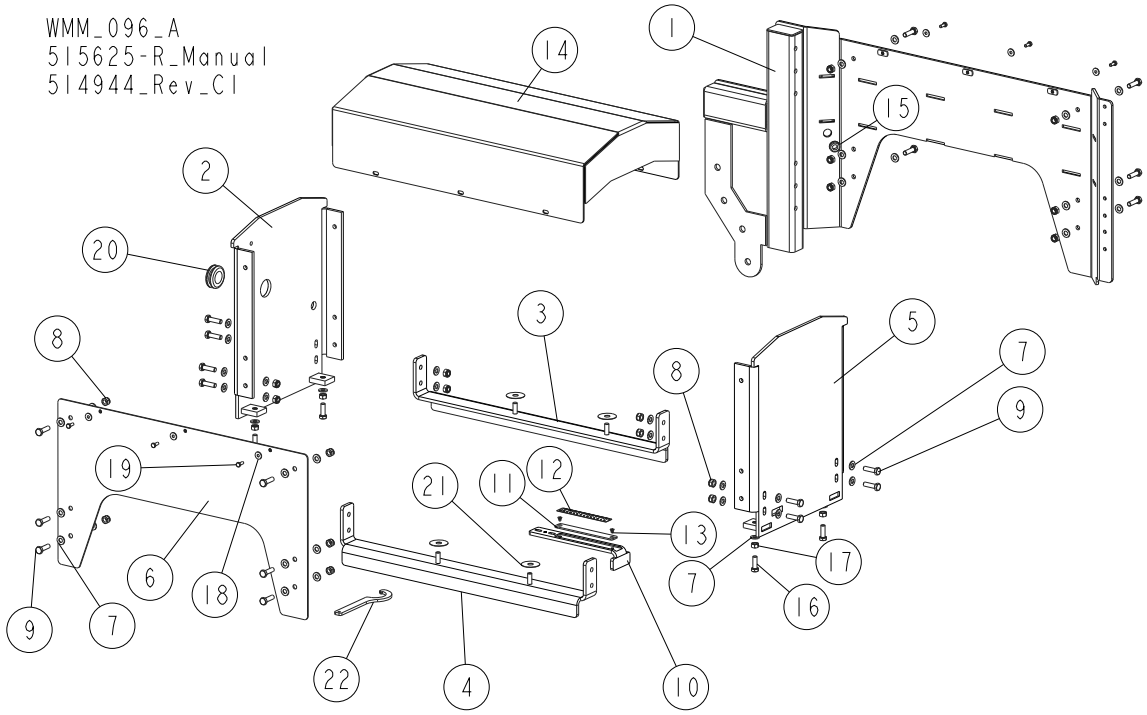
See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77.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

9.2 Sample Assembly

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	Sample Assembly, Complete (Includes All Indented Parts Below)	A01111	1	
5	Sample Part	F02222-22	1	
	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
6	Sample Part (◆ Indicates Part Is Only Available With A03333)	S04444-4	1	◆
	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
7	Sample Part (◆ Indicates Part Is Only Available With K05555)	M06666	2	◆
8	Sample Part	F07777-77	1	

NOTE: It is recommended that only original replacement parts be used.

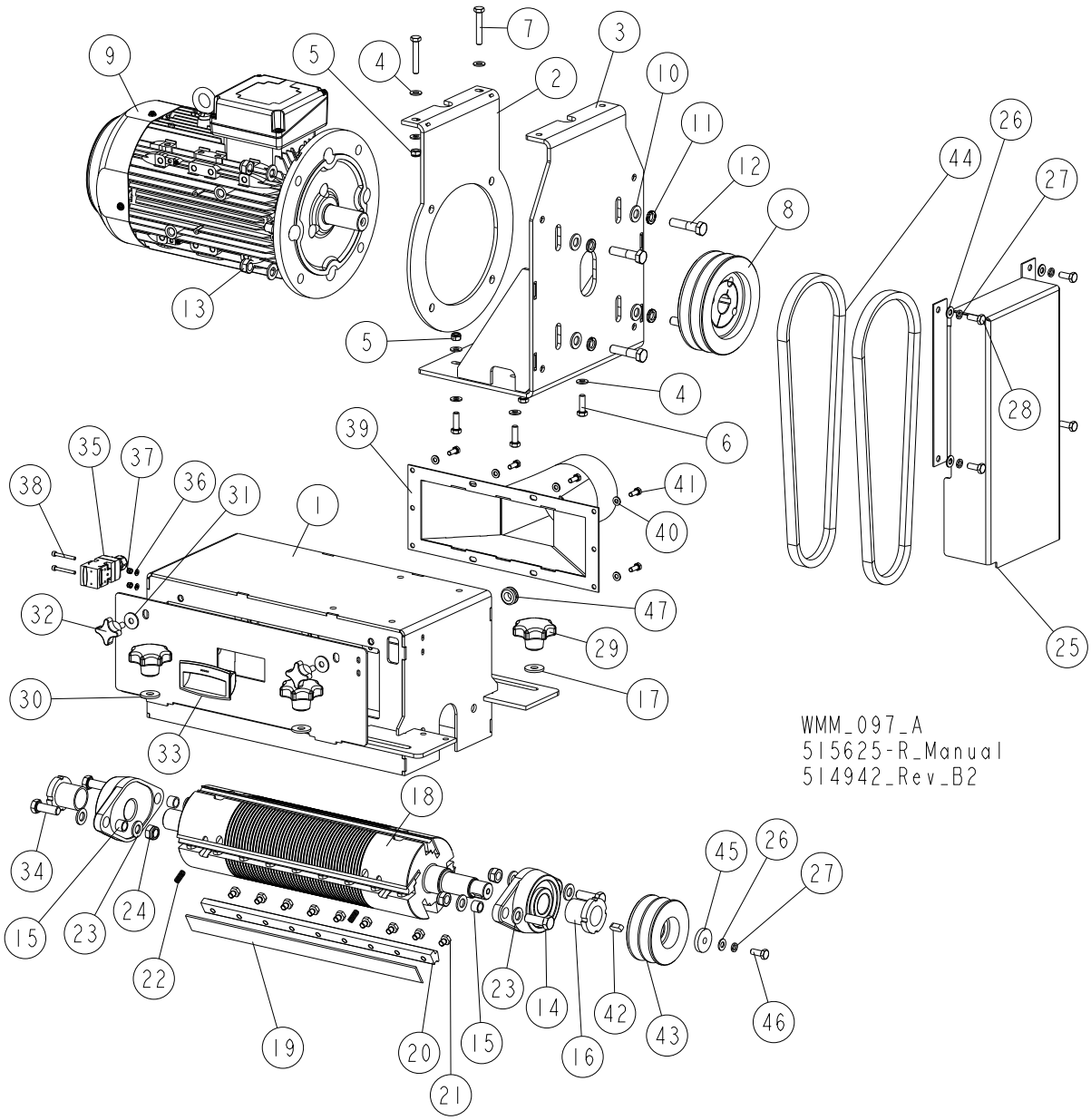
9.3 Moulder Head w/Housing



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	COMPLETE MOULDER HEAD	**514944**	**1**	
1	CUTTER HEIGHT ASSEMBLY	501897-1	1	
2	PLATE, MOULDER HEAD HOUSING - LEFT	501895-1	1	
3	ANGLE, RIGHT	501951-1	1	
4	ANGLE, LEFT	501952-1	1	
5	PLATE, MOULDER HEAD HOUSING - RIGHT	501896-1	1	
6	PLATE, MOULDER HEAD HOUSING - REAR	501905-1	1	
7	WASHER, 10.5 FLAT ZINC	F81055-1	44	
8	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	20	
9	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	20	
	SCALE, CUTTER SETTING - COMPLETE	**502352**	**1**	
10	BRACKET, SCALE	501949-1	1	
	SCALE, METRIC HORIZONTAL - COMPLETE	**501203**	**1**	
11	PLATE, METRIC HORIZONTAL SCALE	501205	1	
12	DECAL, METRIC SCALE 0-20	501206	1	
13	SCREW, M5X8-5.8-B SLOTTED COUNTERSUNK HEAD ZINC	F81000-33	2	
14	COVER, MP100 - R HEAD HOUSING	514943-1	1	
15	GROMMET, 22mm I.D. RUBBER	087400	1	
16	BOLT, M10X30 5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4	
17	NUT, M10 8 HEX ZINC	F81033-3	4	
18	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	6	
19	BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	6	
20	GROMMET, 30X42X8 RUBBER	509717	1	
21	WASHER, 33/64x1 3/4x1/32 NYLON	014972	4	
22	WRENCH, N53 BEARING NUT	502443	1	

REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	CLAMP, 1/2" EMT COATED	010748	1	
	SCREW, M5x10 DIN912 A2-70 HEX SOCKET HEAD CAP STAINLESS STEEL	F81000-23	1	
	WASHER, 5.3 FLAT ZINC	F81052-1	2	
	WASHER, 5.1 SPLIT LOCK ZINC	F81052-2	1	

9.4 Moulder Head

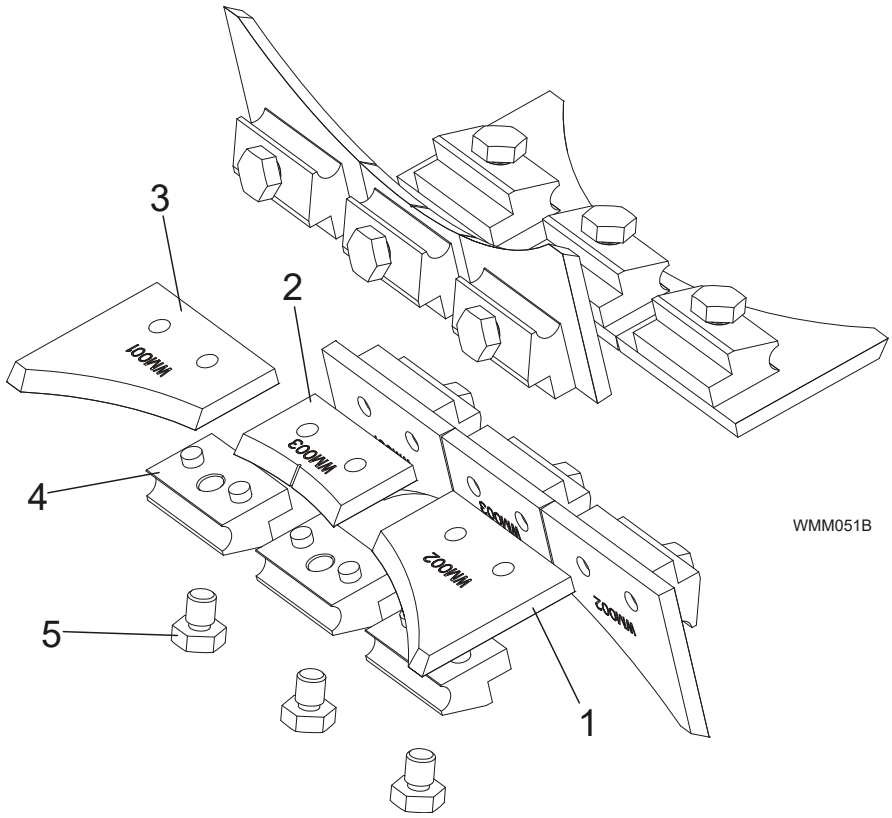


REF	DESCRIPTION (u indicates parts available in assemblies only)	PART #	QTY	
-	**HEAD, MOULDER - COMPLETE**	514942	1	
1	HOUSING, MOULDER CUTTER	501890-1	1	
-	MOTOR, 7.5 KW W/BRACKET - COMPLETE	514941	1	
2	PLATE, 7.5 kW MOTOR MOUNT	514586-1	1	
3	BRACKET, 7.5 kW MOTOR	514945-1	1	
4	WASHER, 8.4 FLAT ZINC	F81054-1	12	
5	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	6	
6	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD Z	F81002-5	4	
7	BOLT, M8X50-8.8 HEX HEAD FULL THREAD ZIN	F81002-19	2	
8	PULLEY, B-2 N140(F02326+T31105)	515618-1	1	
9	MOTOR, 7.5 KW 3SKG112M_B5_IE3 ELECTRIC	592796	1	
10	WASHER, 13 FLAT ZINC	F81056-1	8	
11	WASHER, Z12.2 SPLIT LOCK ZINC	F81056-2	4	

REF	DESCRIPTION (u indicates parts available in assemblies only)	PART #	QTY	
12	BOLT, M12X50 8.8 HEX HEAD ZINC	F81004-74	4	
13	NUT, M12 8 HEX NYLON ZINC LOCK	F81034-2	4	
-	BEARING UNIT, FYTJ 507 (SKF) W/BUSHINGS	513046	2	
14	BEARING UNIT, FYTJ 35K SKF	513045	1	
15	BUSHING ,R14 11.9X16.8X11 ECOMID 6" SKF	513047	2	
16	SLEEVE ADAPTER, H 2307 SKF	513386	1	
17	WASHER, 10.5 SPECIAL FLAT ZINC	F81055-6	4	
-	SHAFT, CUTTER COMPLETE	500949	1	
18	CUTTER, ZINC-PLATED	500950-1	1	
19	KNIFE FOR MOLDER (HSS 410X35X3)	501199	4	
-	CLAMP, STRAIGHT KNIFE	500951	4	
20	CLAMP, CUTTER ZINC-PLATED	500952-1	1	
21	BOLT, M8X10-9.8-FE/ZN5 BN-70/1601-01	F81002-47	9	
22	SPRING, 18X6X1	501200	8	
23	WASHER, 13 FLAT ZINC	F81056-1	8	
24	NUT, M12 8 HEX NYLON ZINC LOCK	F81034-2	4	
25	GUARD, DRIVE BELT.	592795-1	1	
26	WASHER, 8.4 FLAT ZINC	F81054-1	5	
27	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	5	
28	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZIN	F81002-4	4	
29	KNOB, SR1580-63-M10-3(462081-MOSS)	501189	4	
30	PLATE, COVER	501904-1	1	
31	WASHER, ISO 7093-1-8-200 HV-A2E.	F81054-11	2	
32	KNOB, 50/M8X25 (466406 MOSS)	500973	2	
33	HANDLE, EPR.90-PF-C1(261051-C1) SNAP-IN	100012	1	
34	BOLT, M12X35 8.8 HEX HEAD FULL THREAD ZI	F81004-24	4	
35	SWITCH, AZ17-11ZRK SAFETY	094232	1	
36	WASHER, 4.3 FLAT ZINC	F81051-2	2	
37	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	2	
38	SCREW, M4X35 8.8 HEX SOCKET HEAD CAP ZIN	F81011-34	2	
39	PLATE, MOULDER HOUSING	530175-1	1	
40	WASHER, 6.4 FLAT ZINC	F81053-1	9	
41	BOLT, M6X16 8.8 HEX HEAD FULL THREAD ZIN	F81001-15	9	
42	KEY, A8X7X20 PARALLEL	099059	1	
43	PULLEY, 2B N90/N25	515617-1	1	
44	V-BELT, B LP=990	593230	2	
45	WASHER, IDLE SIDE WHEEL RETAINING	093854-1	1	
46	BOLT, M8X20-8.8 HEX HEAD FULL THREAD ZIN	F81002-1	1	
47	**GROMMET, 20/13 RUBBER**	086188	1	

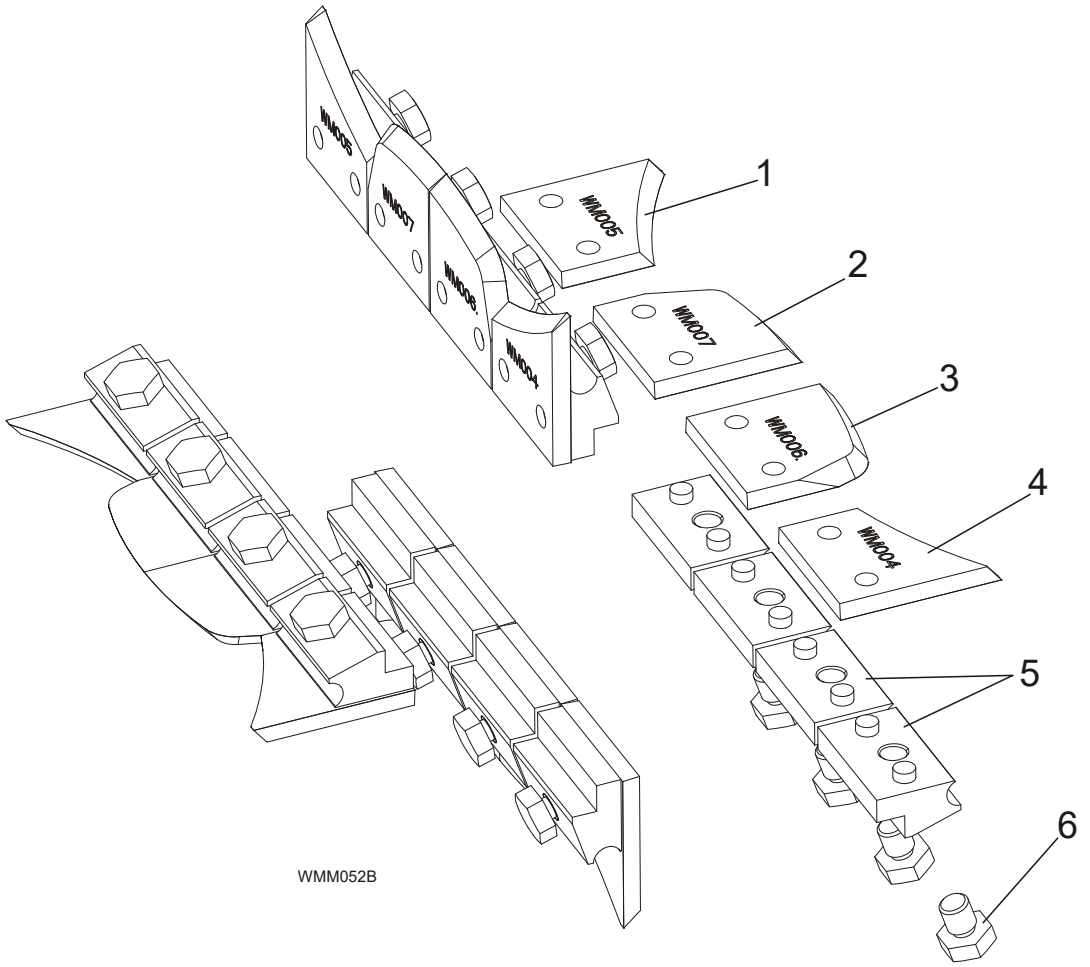
9.5 Moulding Knives

9.5.1 Knife Set for Profile No. 1



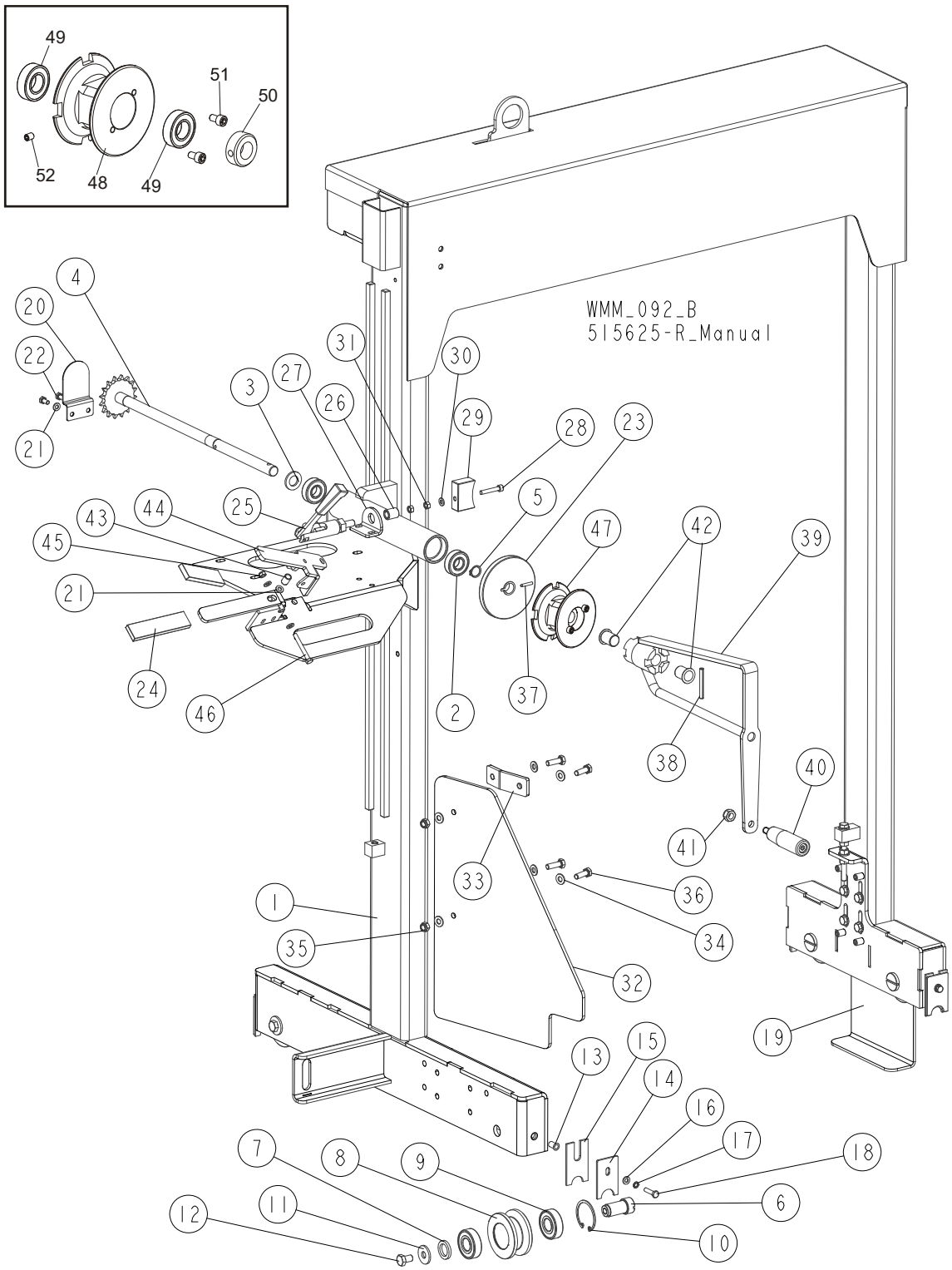
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	KNIFE SET (PROFILE NO. 1)	503093-S	1	
	KNIFE SET FOR PROFILE NO. 1	501222	4	
1	KNIFE, WM002 PROFILING	501227	1	
2	KNIFE, WM003 PROFILING	501228	1	
3	KNIFE, WM001 PROFILING	501226	1	
	WEDGE, PROFILING KNIFE CLAMPING - COMPLETE	501175	3	
4	WEDGE, PROFILING KNIFE CLAMPING	501176-1	1	
5	BOLT, M8x12-8.8 HEX HEAD FULL THREAD ZINC	F81002-6	1	

9.5.2 Knife Set for Profile No. 2



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	KNIFE SET (PROFILE NO. 2)	503094-S	1	
	KNIFE SET FOR PROFILE NO. 2	501223	4	
1	KNIFE, WM005 PROFILING	501230	1	
2	KNIFE, WM007 PROFILING	501232	1	
3	KNIFE, WM006 PROFILING	501231	1	
4	KNIFE, WM004 PROFILING	501229	1	
	WEDGE, PROFILING KNIFE CLAMPING - COMPLETE	501175	4	
5	WEDGE, PROFILING KNIFE CLAMPING	501176-1	1	
6	BOLT, M8x12-8.8 HEX HEAD FULL THREAD ZINC	F81002-6	1	

9.6 Moulder Mast

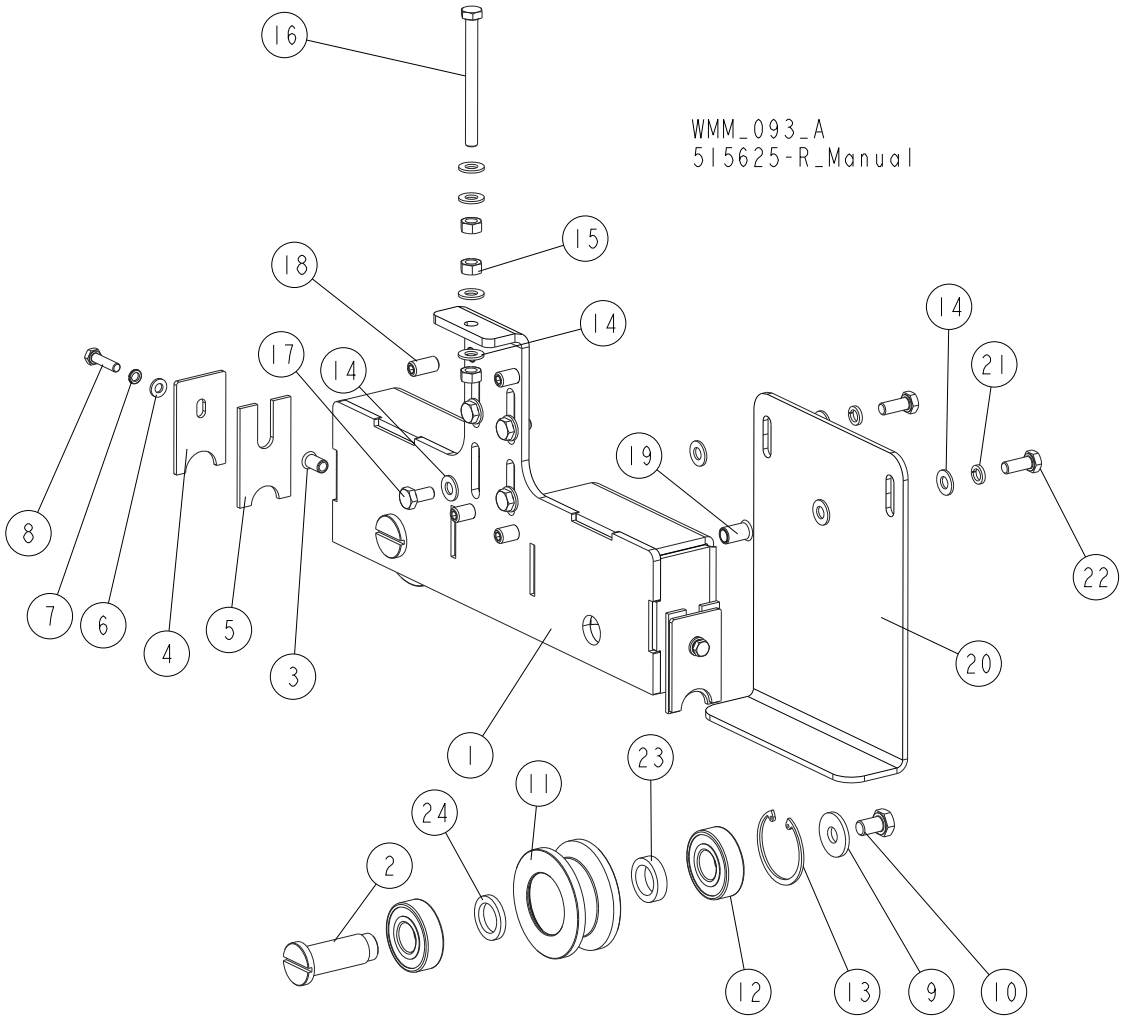


REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	MAST, MP100EH11-R MOULDER - COMPLETE	**515580**	**1**	
	MAST, MP100EH11-R MOULDER	**515579-1**	**1**	

REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
1	MAST WELDMENT, MP100EH11-R MOULDER	515578	1	
2	BEARING, 6203-2RS ROLLING	086114	2	
3	WASHER, 17 SPLIT LOCK ZINC	F81058-1	1	
4	SHAFT W/SPROCKET, LT15 WELDED	086183	1	
5	RING, 17Z OUITSIDE RETAINING	F81090-21	1	
6	PIN, FIXED TRACK ROLLER	515018	2	
7	WASHER, 20.5X30-4 ZINC-PLATED	515021-1	2	
	ROLLER ASSEMBLY, TRACK	**515015**	**2**	
8	ROLLER, TRACK	514889	1	
9	BEARING, 6204 2RS CX ROLLING	088447	2	
10	RING, W 47 INSIDE RETAINING	089653	1	
11	WASHER, 11/30-3 ZINC-PLATED	088787-1	2	
12	BOLT, M10X16-8.8 HEX HEAD FULL THREAD ZINC	F81003-13	2	
13	NUT, M6 1.5-4.0 STAINLESS STEEL RIVET	F81031-9	2	
	COMPLETE SCRAPER	**517611**	**2**	
14	PLATE, SCRAPER CLAMPING	517610-1	1	
15	SCRAPER	517609	1	
16	WASHER, 6.4 FLAT ZINC	F81053-1	1	
17	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	1	
18	BOLT,M6X25 5.8 HEX HEAD FULL THREAD ZINC	F81001-3	1	
19	ROLLER ASSEMBLY, TRACK *See Section 9.7*	515615	1	
20	GUARD, LT15 SAW HEAD UPPER SPROCKET	092567	1	
21	WASHER, 6.4 FLAT ZINC	F81053-1	5	
22	BOLT, M6X12 8.8 HEX HEAD FULL THREAD ZINC	F81001-7	2	
23	WHEEL, HEAD UP/DOWN LOCK	501957-1	1	
24	GRIP, REWA 91626SLEEVE	086875	2	
	HANDLE ASSEMBLY, UP/DOWN LOCK	**502502**	**1**	
25	HANDLE, LOCKING	090273	1	
26	BUSHING, CLAMPING	502501	1	
27	BRACKET, LOCKING HANDLE	502497	1	
28	SCREW, M6X35 8.8 HEX SOCKET HEAD CAP ZINC	F81001-23	1	
29	BLOCK, UP/DOWN LOCK	501964	1	
30	WASHER, 6.4 FLAT ZINC	F81053-1	1	
31	NUT, M6 8 HEX ZINC	F81031-1	2	
	GUARD, COMPLETE LOWER	**501958**	**1**	
32	PLATE, GUARD	502536	1	
33	BRACKET, LOWER GUARD SIDE	502517-1	2	
34	WASHER, 8.4 FLAT ZINC	F81054-1	6	
35	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2	
36	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
37	PIN, 4M6X20 DIN 6325 HRC60 DOWEL	F81048-82	1	
38	PIN, 6X50 ZINC-PLATED ROLL	F81045-1	1	
	HANDLE, CRANK - COMPLETE	**538948**	**1**	
39	HANDLE, CRANK	508238-1	1	
40	KNOB, L=85 M10 RO11-M10 PLASTIC CRANK HANDLE	086338	1	
41	NUT, M10 HEX NYLON ZINC LOCK	F81033-1	1	
42	BUSHING, GFM 1719-25 (IGUS)	094142	2	
43	SPRING, 0.75 LTH	P32011	1	

REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
44	HANDLE WELDMENT, BLADE ENGAGEMENT	097221-1	1	
45	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1	
46	BOLT, M6X50-8.8 HEX HEAD ZINC	F81001-62	1	
47	**PULLEY, MP100 MANUAL FEED - COMPLETE**	502527	1	
48	PULLEY, LT15 FEED ROPE	086117	1	
49	BEARING, 6003 DDUCM NSK	086116	2	
50	RING, 17 ZINC-PLATED STOPPING LIGHT TYPE	F81039-1	1	
51	SCREW, M6x10-8.8 HEX SOCKET HEAD CAP ZINC	F81001-12	2	
52	SCREW, M6X8 45H GEOMET HEX SOCKET SET W/FLAT POINT	F81013-1	1	

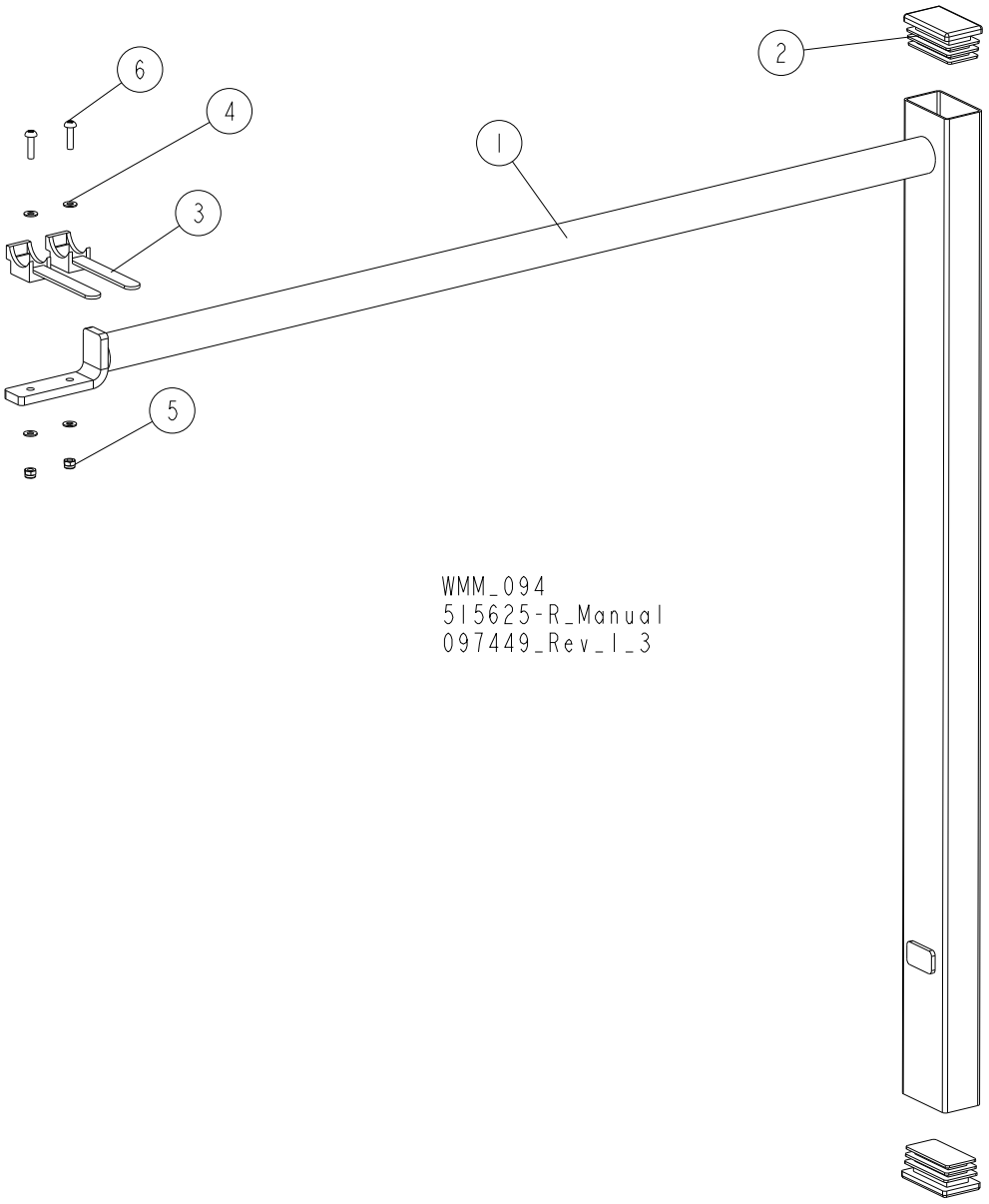
9.7 Track Roller Assembly



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	ROLLER ASSEMBLY, TRACK	**515615**	**1**	
1	BRACKET, TRACK ROLLER MOUNT	515614-1	1	
2	PIN, ADJUSTABLE ROLLER	515611	2	
3	NUT, M6 1.5-4.0 STAINLESS STEEL RIVET	F81031-9	2	
	COMPLETE SCRAPER	**517611**	**2**	
4	PLATE, SCRAPER CLAMPING	517610-1	1	
5	SCRAPER	517609	1	
6	WASHER, 6.4 FLAT ZINC	F81053-1	1	
7	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	1	
8	BOLT,M6X25 5.8 HEX HEAD FULL THREAD ZINC	F81001-3	1	
9	WASHER, 11/30-3 ZINC-PLATED	088787-1	2	
10	BOLT, M10X16-8.8 HEX HEAD FULL THREAD ZINC	F81003-13	2	
	ROLLER ASSEMBLY, TRACK	**515015**	**2**	
11	ROLLER, TRACK	514889	1	
12	BEARING, 6204 2RS CX ROLLING	088447	2	
13	RING, W 47 INSIDE RETAINING	089653	1	
14	WASHER, 8.4 FLAT ZINC	F81054-1	12	

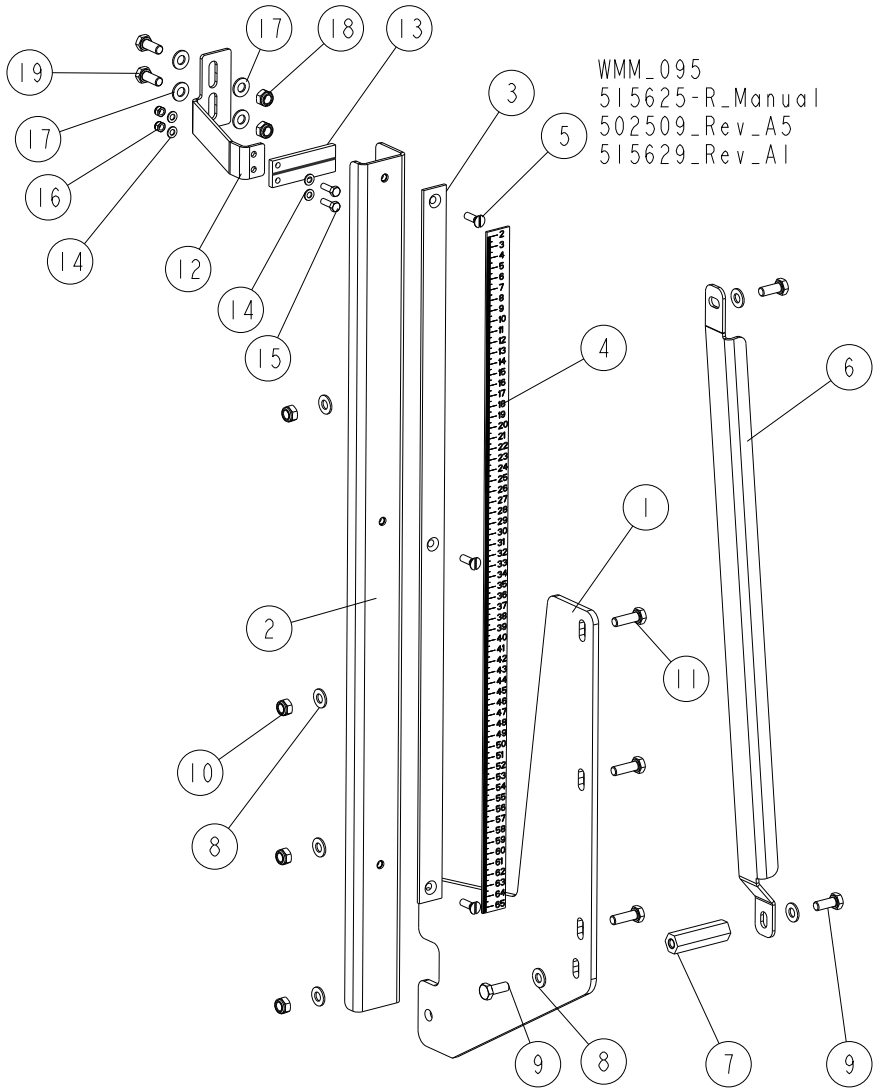
REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
15	NUT, M8-8-B HEX ZINC	F81032-1	3	
16	BOLT, M8X90-8.8 HEX HEAD FULL THREAD ZINC	F81002-16	1	
17	BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC	F81002-20	4	
18	SCREW, M10X1X20 DIN 913 STAINLESS STEEL SET	F81015-1	4	
19	NUT, M8 2.0-4.5 STAINLESS STEEL RIVET	F81032-10	2	
20	PLATE, MAST GUIDE	515616-1	1	
21	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
22	BOLT, M8X20 5.8 HEX HEAD FULL THREAD ZINC	F81002-1	2	
23	WASHER, 20.5X/30-7.4 ZINC-PLATED	518177-1	2	
24	WASHER, 20.5X30-4 ZINC-PLATED	515021-1	2	

9.8 Power Cord Hanger



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	HANGER, LT15 POWER CORD - COMPLETE	**097449**	**1**	
1	HANGER, LT15 POWER CORD	086132-1	1	
2	CAP, 50X30 BLACK	095919	2	
3	HOLDER, CABLE PLASTIC TIE	F81082-1	2	
4	WASHER, 4.3 FLAT ZINC	F81051-2	4	
5	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	2	
6	SCREW, M4X16 5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-42	2	

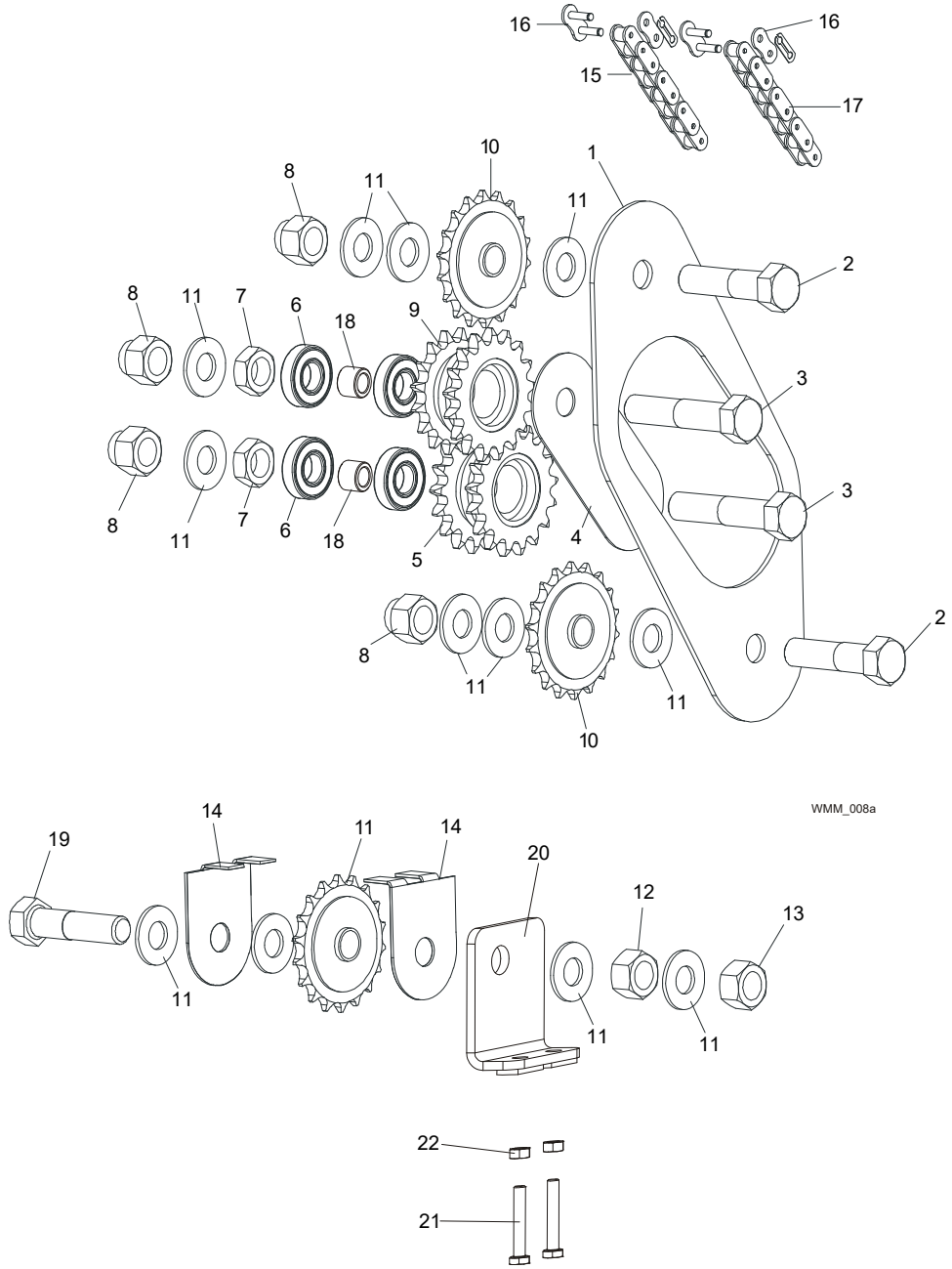
9.9 Cutter Height Scale & Indicator



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	SCALE, CUTTER HEIGHT - COMPLETE	**502509**	**1**	
1	PLATE, CUTTER HEIGHT SCALE MOUNT	502515-1	1	
2	BRACKET WELDMENT, CUTTER HEIGHT SCALE MOUNT	502508-1	1	
3	BAR, SCALE	502506	1	
4	SCALE, CUTTER HEIGHT	502505	1	
5	SCREW, M6X20-5.8-B SLOTTED COUNTERSUNK HEAD ZINC	F81001-31	3	
6	BRACKET, CUTTER HEIGHT SCALE	501988-1	1	
7	BAR, SPACER	502532-1	1	
8	WASHER, 8.4 FLAT ZINC	F81054-1	10	
9	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	3	
10	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4	
11	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	3	
	INDICATOR, MP100EH11-R CUTTER HEIGHT SCALE	**515629**	**1**	
12	BRACKET, SCALE INDICATOR	515624-1	1	

REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
13	INDICATOR, CUTTER HEIGHT SCALE	094821	1	
14	WASHER, 5.3 FLAT ZINC	F81052-1	4	
15	BOLT, M5X16-8.8 HEX HEAD FULL THREAD ZINC	F81000-20	2	
16	NUT, M5-8 DIN985 HEX NYLON ZINC LOCK	F81030-2	2	
17	WASHER, 8.4 FLAT ZINC	F81054-1	4	
18	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2	
19	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	2	

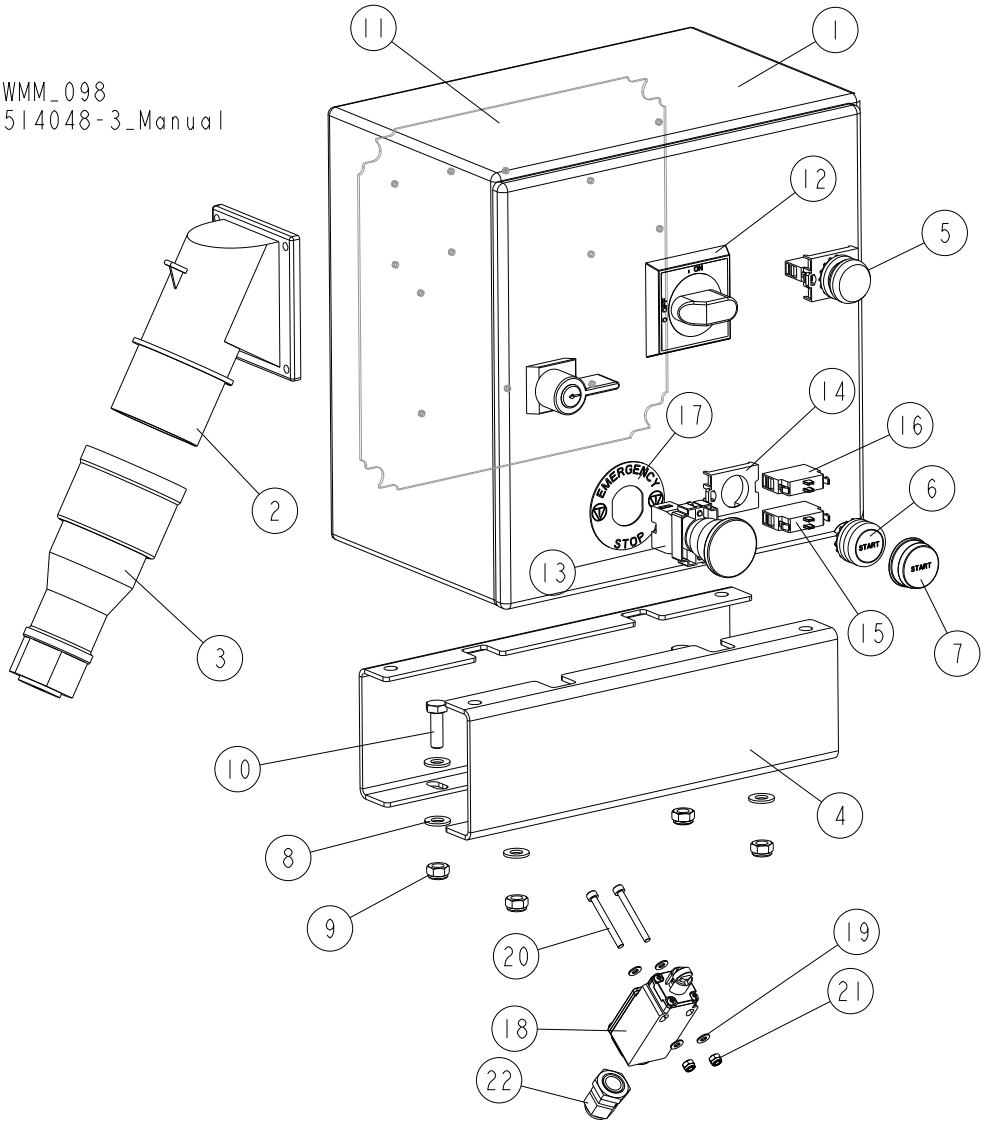
9.10 Up/Down Sprocket Assembly



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 SPROCKET MOUNT (DRIVE SIDE)	087104-1	1	
5	SPROCKET WELDMENT, 17/17 DUAL	086812-1	1	
6	BEARING, R-10	P04156	4	
7	NUT, M16 8 THIN ZINC	F81036-4	2	
8	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4	
9	SPROCKET, 16/17 DUAL	086813-1	1	
10	SPROCKET #40 IDLER 17T 5/8 ID	P04333	3	

11	**WASHER, 17 ZINC FLAT**	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, CHAIN SPROCKET**	092566-1	2	
15	**CHAIN, #40 X 111 1/2”**	014831	1	
16	**LINK, #40 MASTER**	P04200	2	
17	**CHAIN, #40 X 14 1/2”**	P12496	1	
18	**BUSHING, ZINC-PLATED**	095938-1	2	
19	**BOLT, M16x80 8.8-B HEX HEAD FULL THREAD ZINC**	F81006-11	1	
20	**TENSIONER WELDMENT**	502525-1	1	
21	**BOLT, M6x40-8.8 HEX HEAD FULL THREAD ZINC**	F81001-5	2	
22	**NUT, M6-8 HEX ZINC**	F81031-1	2	

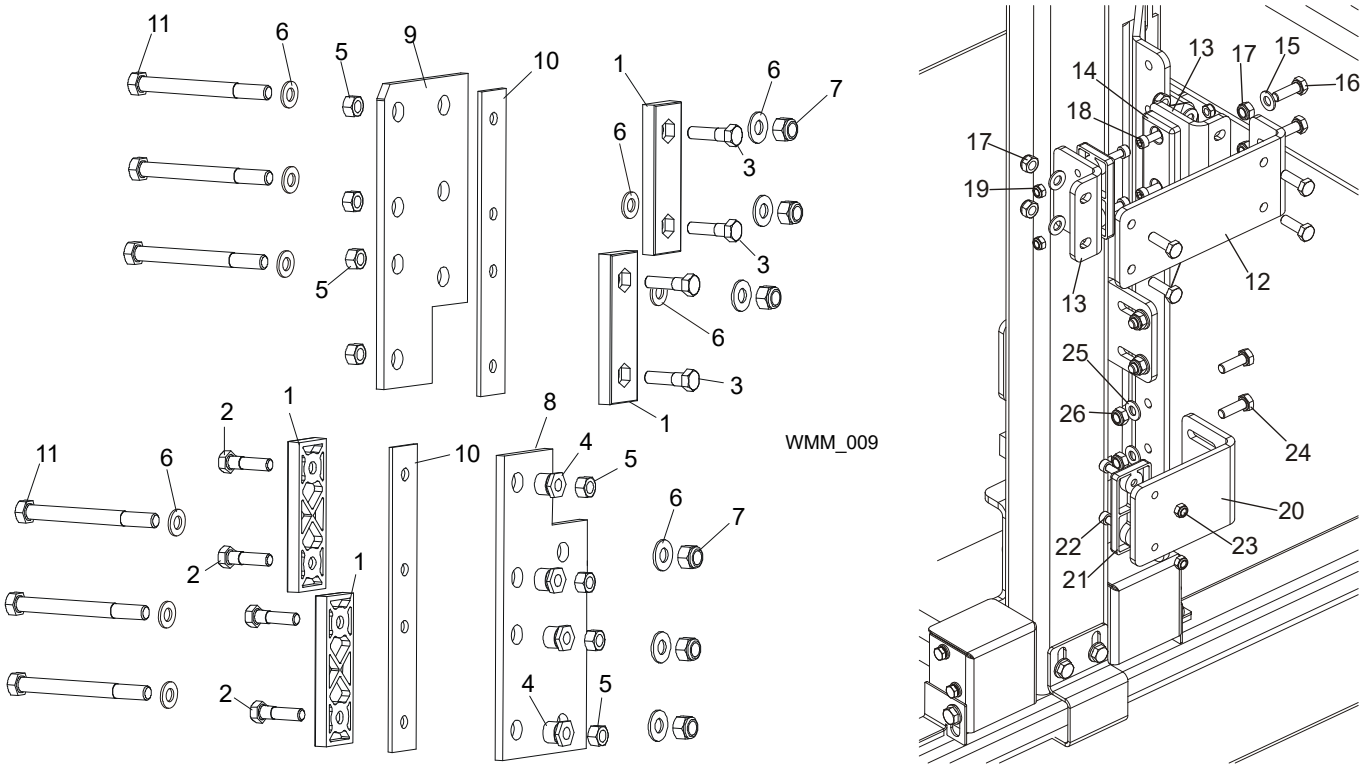
9.11 MP100-R Electrical Box



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	BOX, MP100 E11 ELECTRICAL	**514049**	**1**	
1	BOX, AC 4KW ELECTRICAL	088266	1	
2	PLUG, 16A 5P 778152-6 PCE	E85239	1	
3	SOCKET, 16A 5P 2152-6TT PCE	E85240	1	
4	BRACKET, ELECTRICAL BOX MOUNT	505604-1	2	
5	LIGHT, M22 24V LED BLUE CONTROL	090448	1	
6	BUTTON, M22 GREEN ILLUMINATED START	094315	1	
7	DIAPHRAGM, IP67 M22-T-D PROTECTIVE	094316	1	
8	WASHER, 8.4 FLAT ZINC	F81054-1	8	
9	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4	
10	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
11	PLATE, ELECTRICAL BOX MOUNT	507750	1	
12	HANDLE, OHB S2A1 AB SWITCH	502312-1	1	

REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
13	BUTTON, XB4 BS542 EMERGENCY STOP	086556	1	
14	CONNECTOR, M22-A	100905	1	
15	ELEMENT, M22 LED-G LED	501004	1	
16	ELEMENT, M22 K10 CONTACT	091362	1	
17	WASHER, EMERGENCY STOP BUTTON	086561	1	
18	SWITCH, KMB2S11 SAFETY	100910	1	
19	WASHER, 4.3 FLAT ZINC	F81051-2	4	
20	SCREW, M4X40 8.8 HEX SOCKET HEAD CAP ZINC	F81011-37	2	
21	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	2	
22	GLAND, DP9/H CABLE	F81096-2	1	

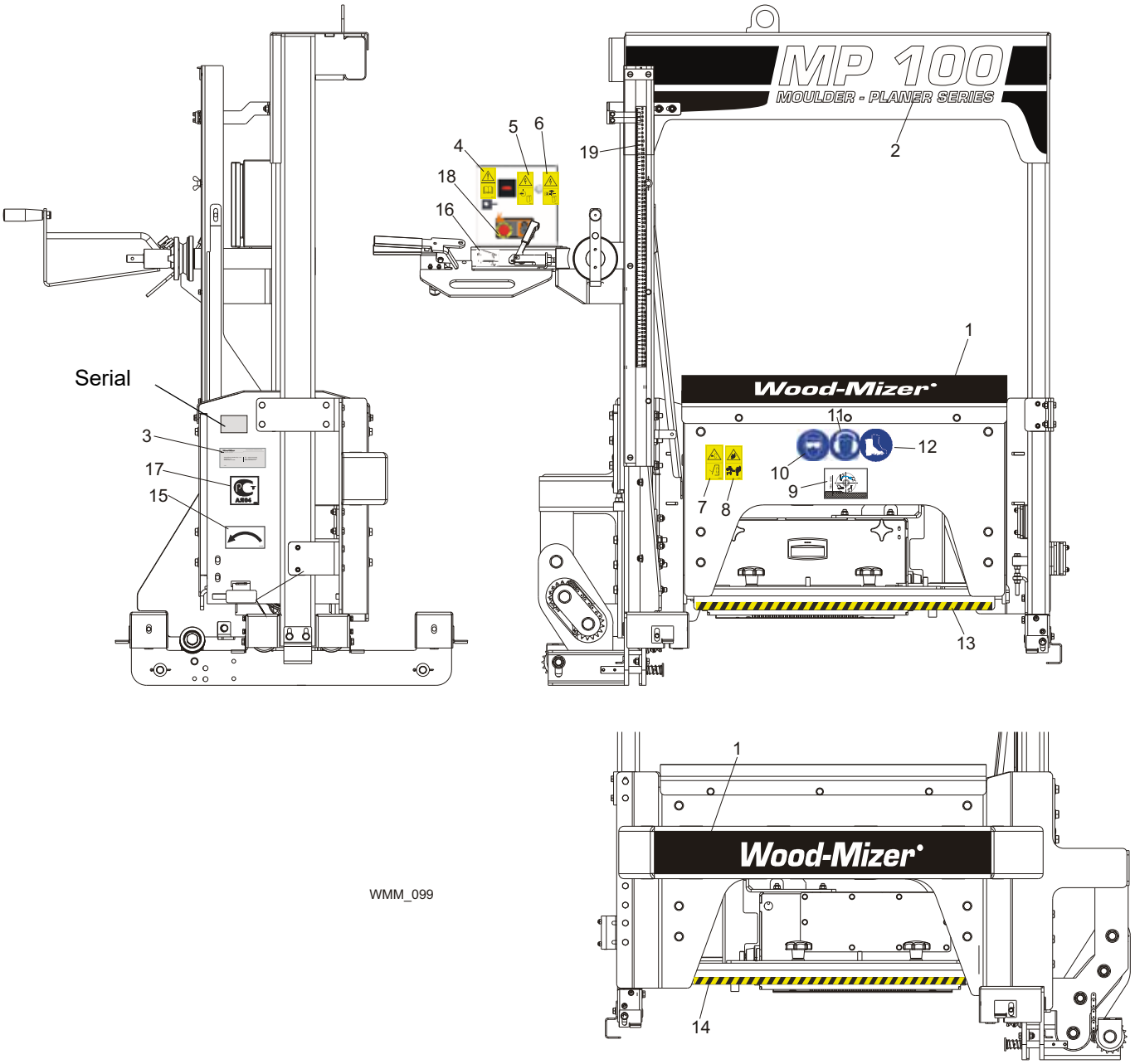
9.12 Slide Pads



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
1	**PADS, DELRIN UP/DOWN SLIDE**	M04096	4	
2	**BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC**	F81002-13	4	
3	**BOLT, M8X20-8.8 HEX HEAD FULL THREAD ZINC**	F81002-4	4	
4	**NUT, LT15 SLIDE PAD ADJUSTMENT ZINC-PLATED**	086683-1	4	
5	**NUT, M8-8-B HEX NYLON ZINC LOCK**	F81032-2	8	
6	**WASHER, 10.5 ZINC FLAT**	F81055-1	12	
7	**NUT, M10-8-B HEX NYLON ZINC LOCK**	F81033-1	8	
8	**PLATE, HEAD GUIDE**	086682-1	1	
9	**PLATE, HEAD UPPER GUIDE**	094139-1	1	
10	**PLATE, SLIDE PAD SPACER**	094140-1	2	
11	**BOLT, M10x115-8.8 HEX HEAD ZINC**	F81003-19	6	
	PAD ASSEMBLY, UPPER TRACK	502503	1	
12	BRACKET, TRACK PAD MOUNT	501902-1	1	
13	BRACKET, TRACK PAD	501903-1	2	
14	PAD, CATAPILLAR TRACK	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, M6x16-8.8 HEX SOCKET HEAD CAP ZINC	F81001-21	4	
19	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	4	
	PAD ASSEMBLY, LOWER TRACK	502504	2	
20	BRACKET, TRACK PAD - RIGHT	501991-1	1	

21	PAD, CATAPILLAR TRACK	P13576	1	
22	SCREW, M6x16-8.8 HEX SOCKET HEAD CAP ZINC	F81001-21	2	
23	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
24	**BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC**	F81002-5	4	
25	**WASHER, 8.4 FLAT ZINC**	F81054-1	4	
26	**NUT, M8-8-B HEX NYLON ZINC LOCK**	F81032-2	4	

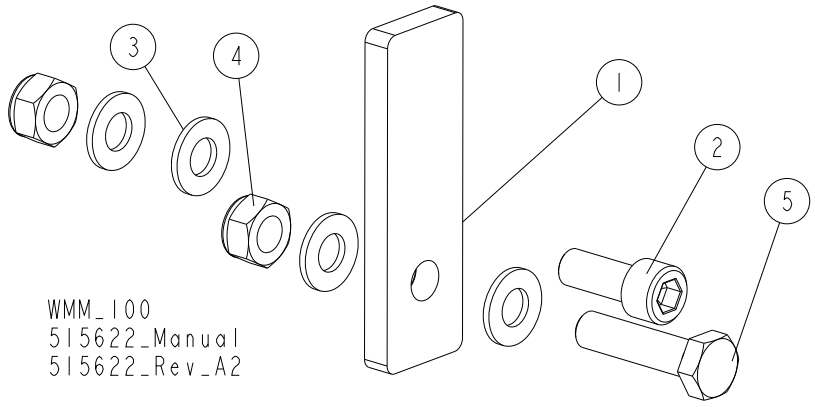
9.13 Decals



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	DECAL KIT, MP100-R MOULDER	**516126**	**1**	
1	DECAL, ”WOOD-MIZER”	502581	2	
2	DECAL, MOULDER MODEL	502582	1	
3	DECAL, EUROPEAN HEADQUARTER ADDRESS	015841	1	
4	DECAL ”READ THE OPERATION MANUAL” (PICTOGRAM)	096317	1	
5	DECAL “HAZARDOUS VOLTAGE INSIDE THE ELECTRICAL BOX” (PICTOGRAM)	096316	1	
6	DECAL ”REMOVE THE PLUG BEFORE OPENING THE ELECTRICAL BOX” (PICTOGRAM)	096319	1	
7	DECAL ”CLOSE ALL GUARDS AND COVERS BEFORE STARTING THE MACHINE” (PICTOGRAM)	099220	1	
8	DECAL "KEEP A SAFE DISTANCE” (PICTOGRAM)	099221	1	
9	DECAL, MAXIMUM PLANING THICKNESS	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 STRIP (BLACK & YELLOW)	087649	1	
14	DECAL, WARNING STRIP (BLACK & YELLOW)	502481	1	
15	DECAL, REVOLUTIONS DIRECTION	089296	1	
16	DECAL, SAFETY HANDLE	501477	1	
17	DECAL, CE CERTIFIED SAWMILL (RUSSIAN)	099401	1	
18	**DECAL, ELECTRICAL BOX**	502320-4	1	
19	**DECAL, HEIGHT SCALE**	502505	1	

9.14 Stop Plate Assembly



REF.	DESCRIPTION (◆ indicates parts available in assemblies only)	PART #	QTY	
	PLATE ASSEMBLY, MP100EH11-R STOP	**515622**	**1**	
1	PLATE, MP100EH11-R STOP	515621-1	1	
2	SCREW, M10X25 8.8 HEX SOCKET HEAD CAP ZINC	F81003-32	1	
3	WASHER, 10.5 FLAT ZINC	F81055-1	5	
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2	
5	BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	1	

Wood-Mizer
from forest to final form

EC declaration of conformity

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

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

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

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

We, the undersigned herewith declare, that:

Designation of the machine:	**Log Moulder**
Type:	MP100EH5S, MP150EH5S
Serial Number:	……
Is in conformity with the following EC directives:	EC Machinery Directive 2006/42/EC EC Electromagnetic Compatibility Directive 2014/30/EU
And is in conformity with the following Harmonized Standards:	PN-EN ISO 12100:2012; PN-EN 861+A2:2012; PN-EN ISO 13849-1:2016-02 PN-EN 60204-1:2010 PN-EN ISO 13857:2010;
Notified Body according to annex IV :	Sieć Badawcza Łukasiewicz INSTYTUT TECHNOLOGII DREWNA Centrum Certyfikacji Wyrobów Przemysłu Drzewnego ul. Winiarska 1, 60-654 Poznań
Notification No:	1583
EC type-examination certificate no.	0418/2015
Responsible for Technical Documentation:	Piotr Adamiec / Engineering Manager Wood-Mizer Industries Sp. z o.o. 62-600 Koło, ul. Nagórna 114, Poland Tel. +48 63 26 26 000
Place/Date/Authorized Signature:	Koło, 30.01.2020 
Title :	Engineering Manager