



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 prihodnjo uporabo

Wood-Mizer®

Safety, Setup, Operation, Maintenance and Parts Manual

MP100 E11-R

rev. A1.00



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

April 2015

Form #909

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

Table of Contents

Section-Page

SECTION 1	INTRODUCTION	1-1
1.1	Machine Description	1-1
1.2	Machine and Site Preparation.....	1-2
1.3	The major components of the moulder.....	1-2
1.4	If You Need To Order Parts	1-3
1.5	If You Need Service	1-3
SECTION 2	SAFETY	2-1
2.1	Safety Symbols.....	2-1
2.2	Safety Instructions.....	2-1
SECTION 3	MOULDER ASSEMBLY	3-1
3.1	Mounting Parts of MP100 Moulders.....	3-1
3.2	Unpacking the Moulder.....	3-5
SECTION 4	SETUP & OPERATION	4-1
4.1	Moulder Setup	4-1
4.2	Log Clamp Operation.....	4-7
4.3	Mounting the Planing Knives.....	4-8
4.4	Mounting the Moulding Knives	4-11
4.5	Moulder Operation, MP100.....	4-16
4.6	Machine Start-Up (MP100).....	4-21
SECTION 5	MAINTENANCE	5-1
5.1	Wear Life.....	5-1
5.2	Sawdust Removal	5-1
5.3	Head Track & Rollers.....	5-1
5.4	Vertical Mast	5-1
5.5	Miscellaneous Lubrication	5-1
5.6	Manual Up/Down System	5-2
5.7	Drive Belt Tension Adjustment.....	5-3
5.8	Cutter Bearings.....	5-5
5.9	Long-Term Storage	5-5
5.10	Safety Devices Inspection	5-7
SECTION 6	SPECIFICATIONS	6-1
6.1	Overall Dimensions	6-1
6.2	Moulder Specifications.....	6-2
6.3	Dust Extractor Specifications	6-5

Table of Contents

Section-Page

SECTION 7	MOTOR BRAKE	7-1
7.1	Maintenance/repair	7-1
7.2	Maintenance	7-2
ROZDZIAŁ 9	LISTA CZĘŚCI ZAMIENNYCH	8-1
9.1	Sposób korzystania z listy części zamiennych	8-1
9.2	Przykładowy zespół	8-1
9.3	Głowica strugarki	8-2
9.4	Głowica skrawająca	8-3
9.5	Noże kształtowe	8-5
9.6	Napęd posuwu ręcznego przód/tył	8-7
9.7	Zespół rolek jezdnych	8-9
9.8	Wspornik przewodu zasilającego	8-11
9.9	Skala i wskaźnik wysokości położenia freza	8-12
9.10	Zespół kół zębatych do napędu posuwu góra/dół	8-14
9.11	Skrzynka elektryczna MP100-R	8-16
9.12	Wkładki poślizgowe	8-18
9.13	Nalepki ostrzegawcze i informacyjne strugarki	8-20
9.14	Zespół ogranicznika	8-22

Table of Contents

Section-Page

SECTION 1	INTRODUCTION	1-1
1.1	Machine Description	1-1
1.2	Machine and Site Preparation.....	1-2
1.3	The major components of the moulder.....	1-2
1.4	If You Need To Order Parts	1-4
1.5	If You Need Service	1-4
SECTION 2	SAFETY	2-1
2.1	Safety Symbols.....	2-1
2.2	Safety Instructions.....	2-1
SECTION 3	MOULDER ASSEMBLY	3-1
3.1	Mounting Parts of MP100 Moulders.....	3-1
3.2	Unpacking the Moulder.....	3-5
SECTION 4	SETUP & OPERATION	4-1
4.1	Moulder Setup	4-1
4.2	Log Clamp Operation.....	4-7
4.3	Mounting the Planing Knives.....	4-8
4.4	Mounting the Moulding Knives	4-11
4.5	Moulder Operation, MP100.....	4-16
4.6	Machine Start-Up (MP100).....	4-21
SECTION 5	MAINTENANCE	5-1
5.1	Wear Life.....	5-1
5.2	Sawdust Removal	5-1
5.3	Head Track & Rollers.....	5-1
5.4	Vertical Mast	5-1
5.5	Miscellaneous Lubrication	5-1
5.6	Manual Up/Down System	5-2
5.7	Drive Belt Tension Adjustment.....	5-3
5.8	Cutter Bearings.....	5-5
5.9	Long-Term Storage	5-5
5.10	Safety Devices Inspection	5-7
SECTION 6	SPECIFICATIONS	6-1
6.1	Overall Dimensions	6-1
6.2	Moulder Specifications.....	6-2
6.3	Dust Extractor Specifications	6-5

Table of Contents

Section-Page

SECTION 7	ELECTRICAL INFORMATION	7-1
7.1	Electrical Diagram, MP100EH5S	7-2
7.2	Electrical Component List, MP100EH5S.....	7-3
7.3	Electrical Diagram, MP100EH5-1	7-4
7.4	Electrical Component List, MP100EH5-1	7-5
7.5	Electrical Diagram, MP100EB5-S	7-6
7.6	Electrical Component List, MP100EB5-S	7-7
7.7	Electrical Diagram, MP100EC5.....	7-8
7.8	Electrical Component List, MP100EC5	7-9
7.9	Electrical Diagram, MP150EH5S	7-10
7.10	Electrical Component List, MP150EH5S.....	7-11
7.11	Electrical Diagram, MP100EH11-R.....	7-12
7.12	Electrical Component List, MP100EH11-R.....	7-13
SECTION 8	MOTOR BRAKE	8-1
8.1	Maintenance/repair	8-1
8.2	Maintenance	8-2
ROZDZIAŁ 9	LISTA CZĘŚCI ZAMIENNYCH	9-1
9.1	Sposób korzystania z listy części zamiennych	9-1
9.2	Przykładowy zespół.....	9-1
9.3	Głowica strugarki	9-2
9.4	Głowica skrawająca	9-4
9.5	Noże kształtowe.....	9-6
9.6	Napęd posuwu ręcznego przód/tył	9-8
9.7	Zespół rolek jezdnych	9-10
9.8	Wspornik przewodu zasilającego	9-12
9.9	Skala i wskaźnik wysokości położenia freza	9-13
9.10	Zespół kół zębatych do napędu posuwu góra/dół.....	9-15
9.11	Skrzynka elektryczna MP100-R	9-17
9.12	Wkładki poślizgowe	9-19
9.13	Nalepki ostrzegawcze i informacyjne strugarki	9-21
9.14	Zespół ogranicznika	9-23

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.

1.2 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

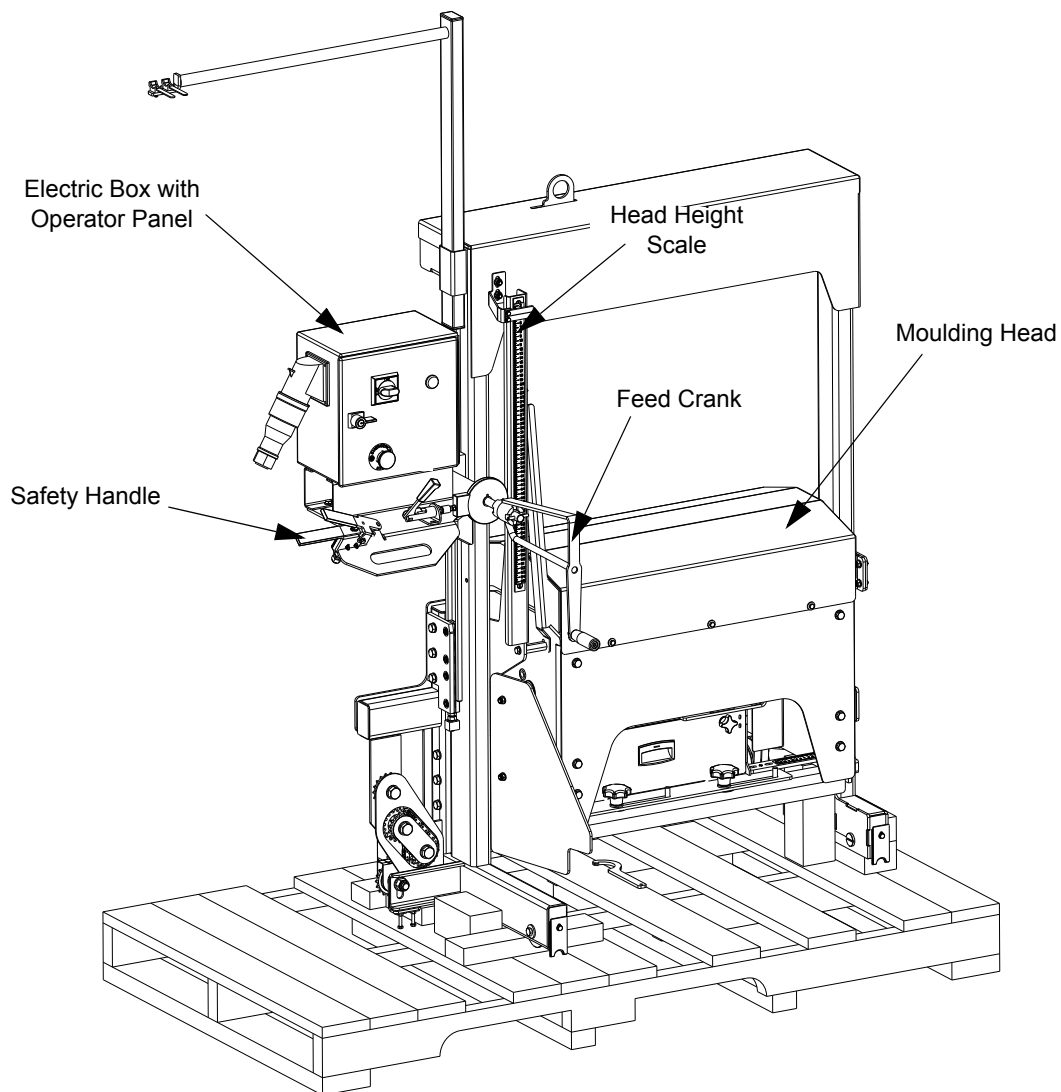


FIG. 1-0 MP100-R

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.

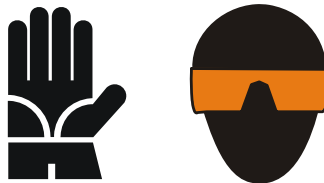


Wear Safety Clothing



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



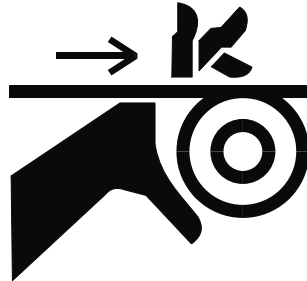
DANGER! Keep all persons at a safe distance of at least 3 meters from the machine when operating the moulder. Failure to do so will result in serious injury.

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.

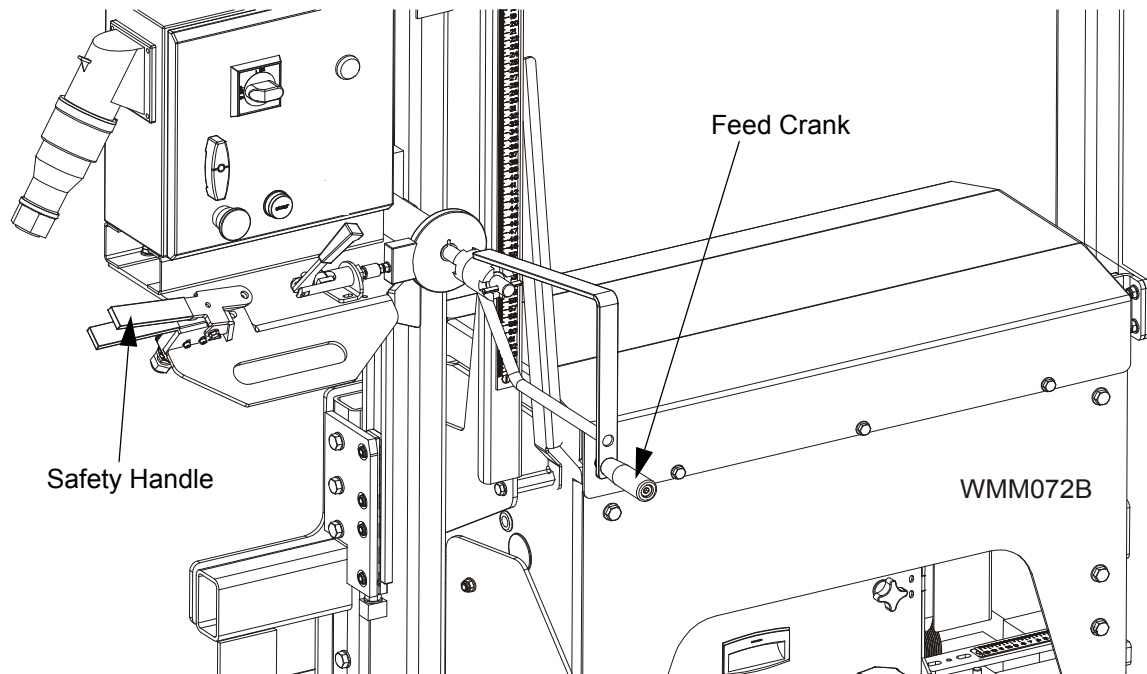


FIG. 2-1



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.

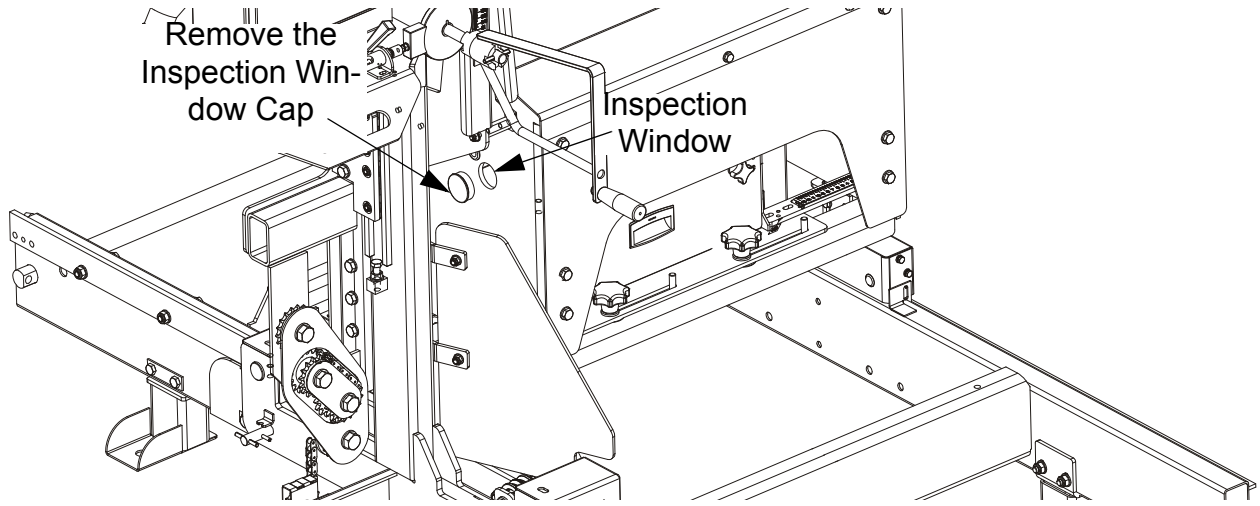


FIG. 2-2



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).

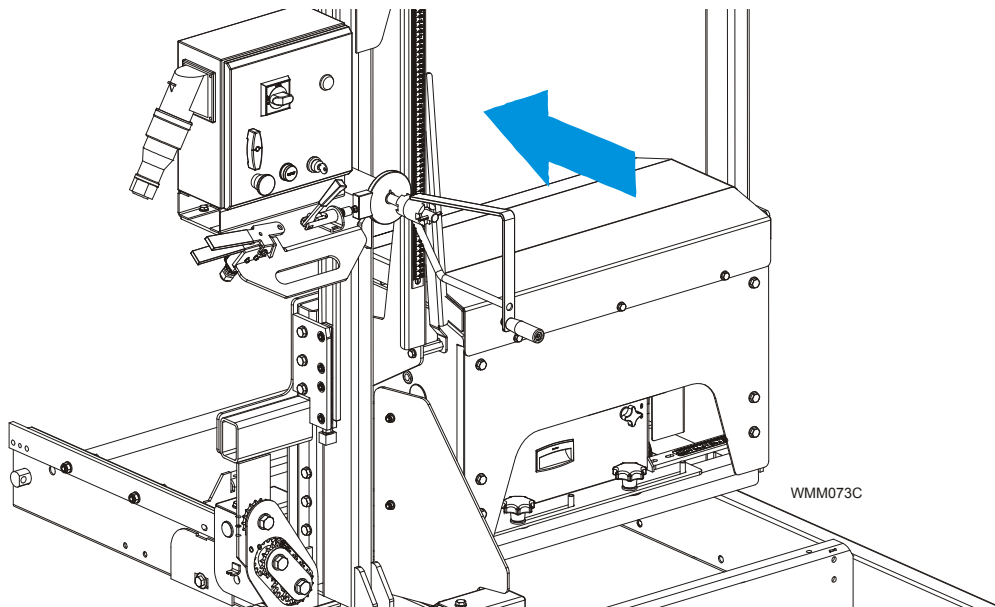


FIG. 2-3

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

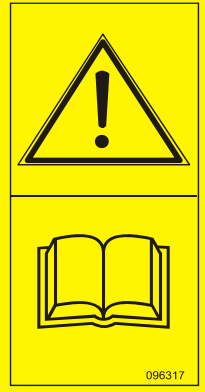


Decals View	Decal No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the moulder. Observe all safety instructions and rules when operating the machine.
	099220	Close guards prior to operating the machine.
	099221	CAUTION! Keep all persons a safe distance away from work area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

TABELA 2-1

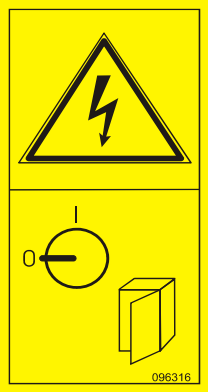
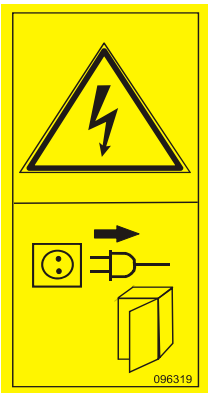




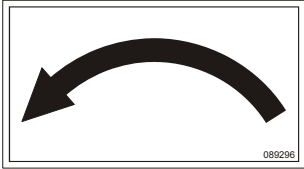
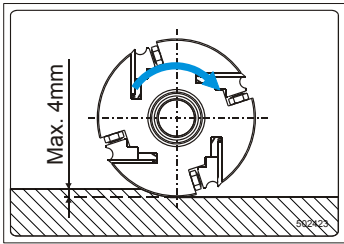

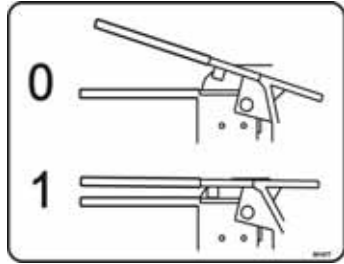

 <p>096316</p>	096316	Do not open or close the electric box when the switch is not in the "0" position.
 <p>096319</p>	096319	Always disconnect the power cord before opening the electric box.
	S12004G	Always wear eye protection equipment when operating this machine.
	S12005G	Always wear ear protection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

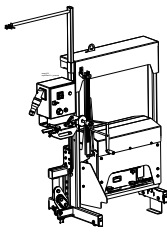
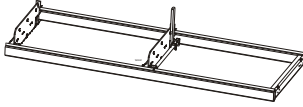
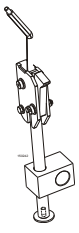
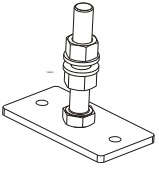


Fig.	Wood-Mizer Part No.	Description	Qty. MP100
	515625-R 514048-3	Moulder Head	1
	514972	LT15 Bed Section, Complete (2.75 m) with Side Support	3
	514955	Log Clamp	3
	514997	Log Side Support, Complete	14
	515062	Bumper, Right	2
	515063	Bumper, Left	2

Table 1:

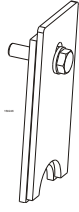

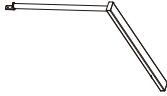
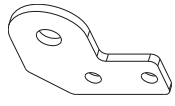

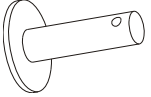
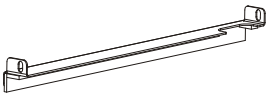
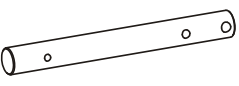



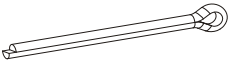




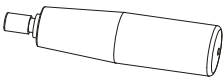

	515518	Scraper, Left, Right	4
	515413-1	Wedge	1
	515518	Track Wiper	4
	086132-1	Power Cord Bracket	1
	501414-1	Plate, LT15 Power Feed Support	2
	502443	Wrench, Bearing Nut	1
	502848	Alignment Tools Set, ELBE RF 100120	1
	095919	Bottom Bracket	2
	P12165	Bushing, Rubber	2
	086182-1	Mount Wdmt, Carriage 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 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.

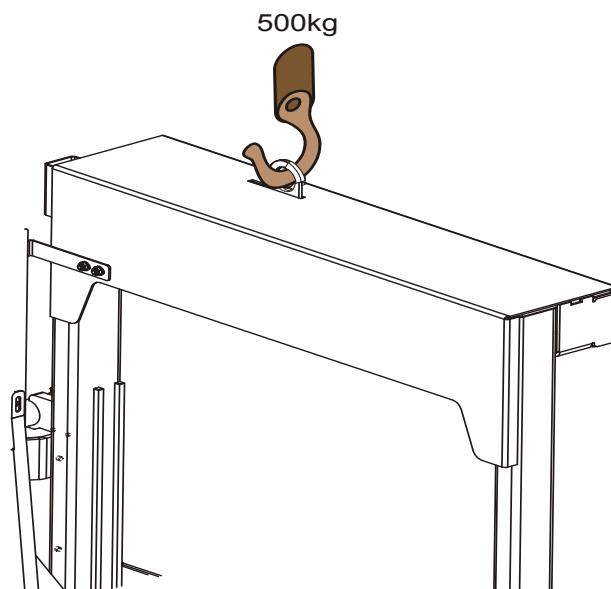


FIG. 3-1

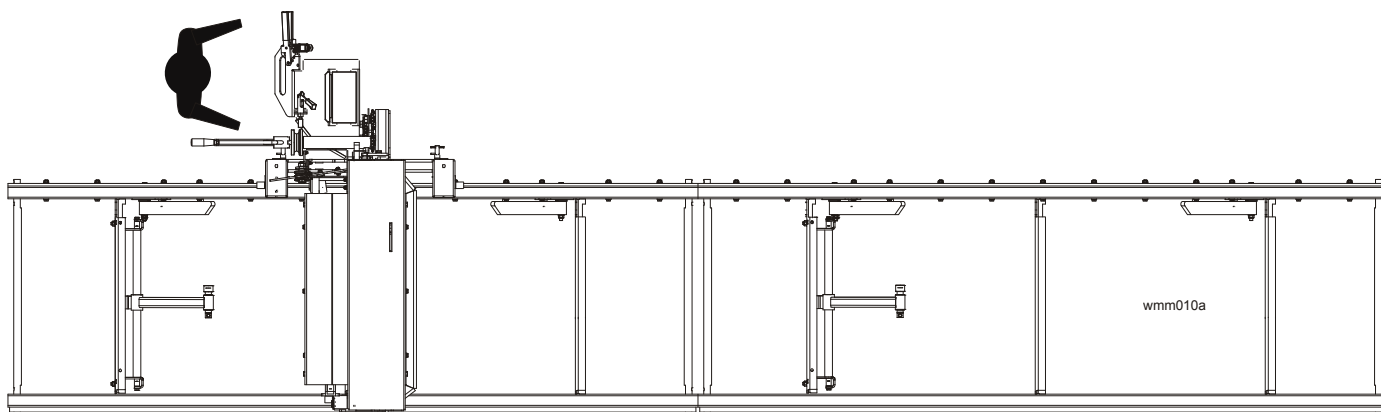
SECTION 4 SETUP & OPERATION

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 300lx¹.
- 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

TABLE 4-1

1. The light source can not cause stroboscopic effect.

1ph 230 VAC UL	70 A class J	7 AWG / 10mm ²
----------------	--------------	---------------------------

TABLE 4-1



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

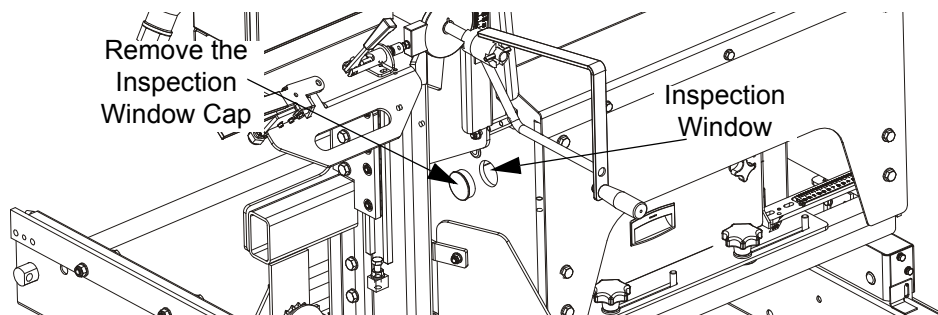


FIG. 4-0



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.

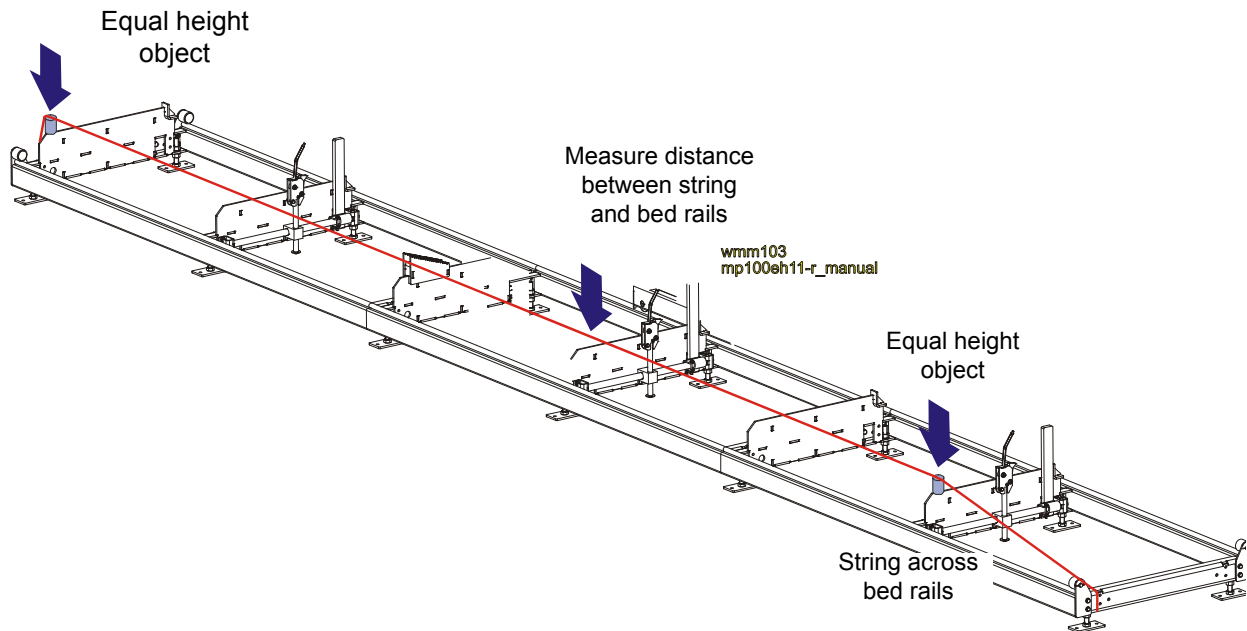


FIG. 4-1

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.

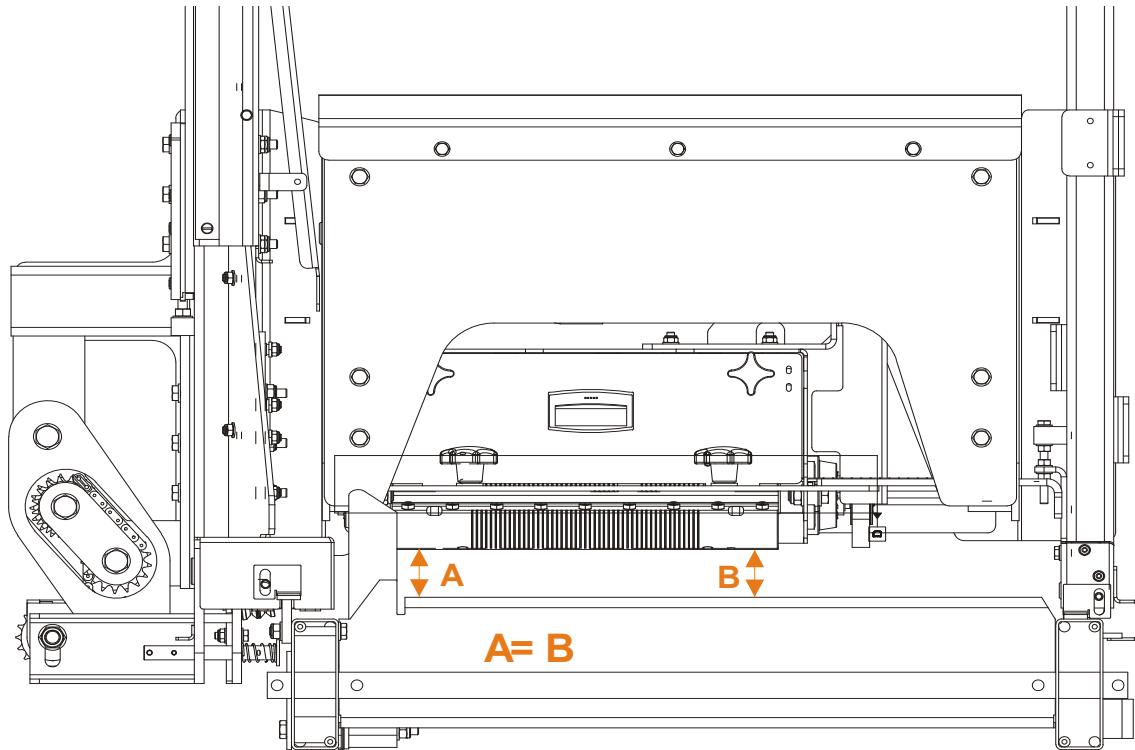


FIG. 4-2

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.

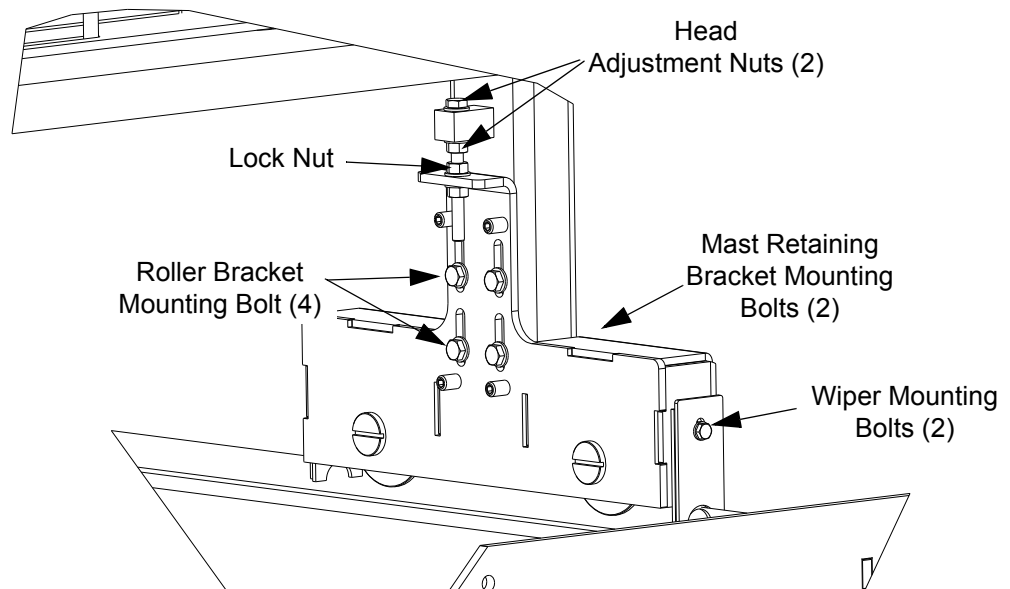


FIG. 4-3

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.

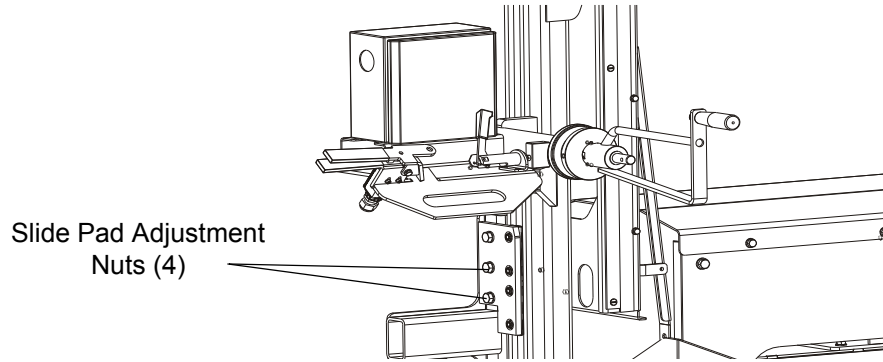


FIG. 4-3

4.2 Log Clamp Operation

To Clamp Logs

1. Position the clamps against the log, far enough down 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 4-4.

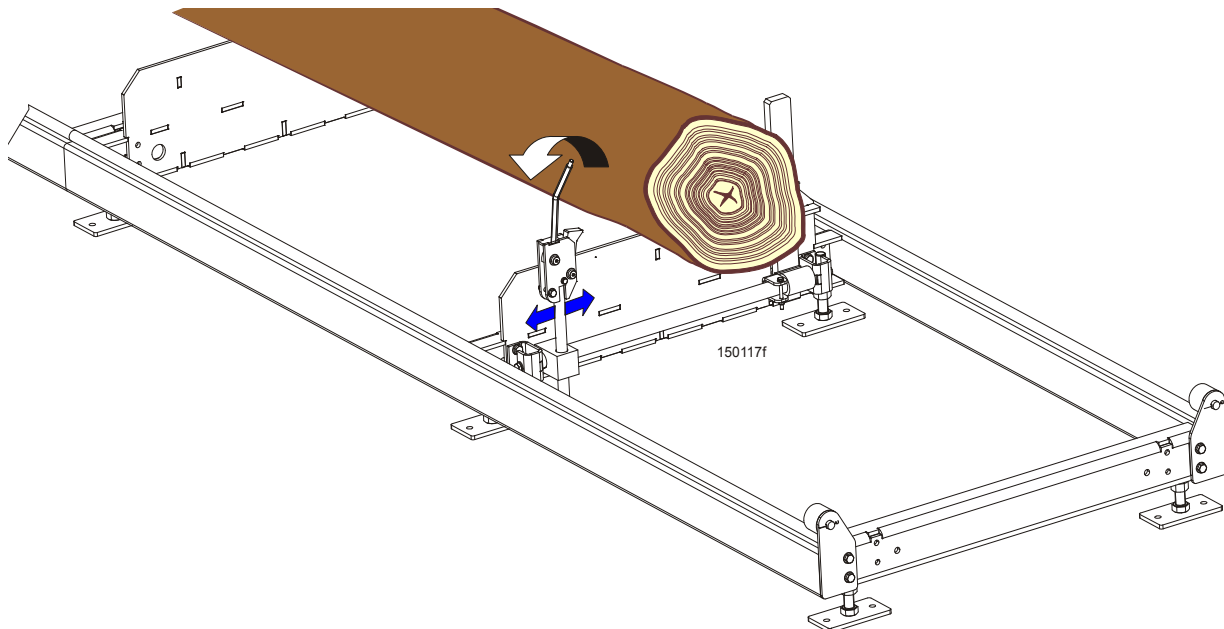




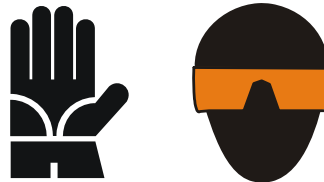
FIG. 4-4


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.

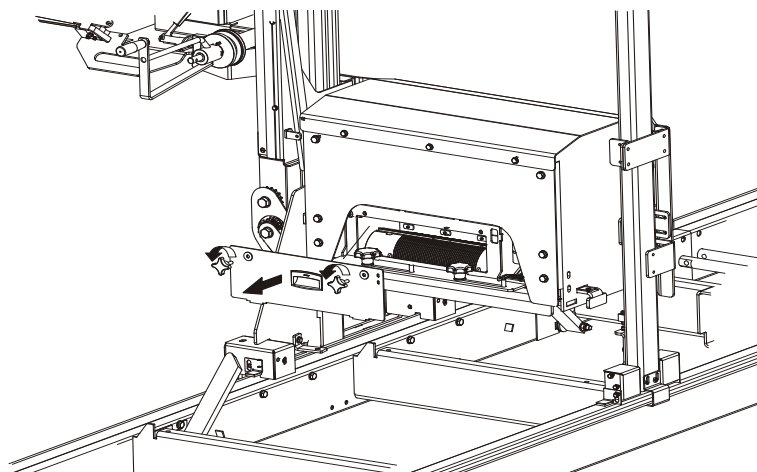
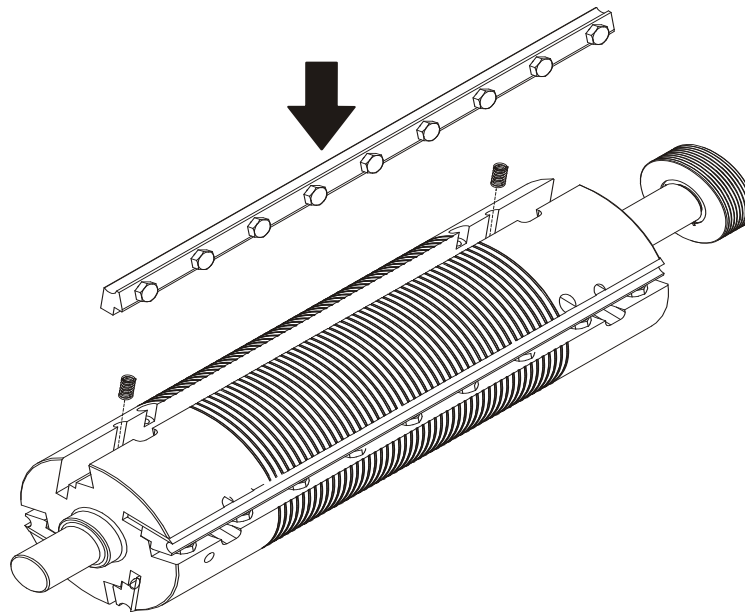


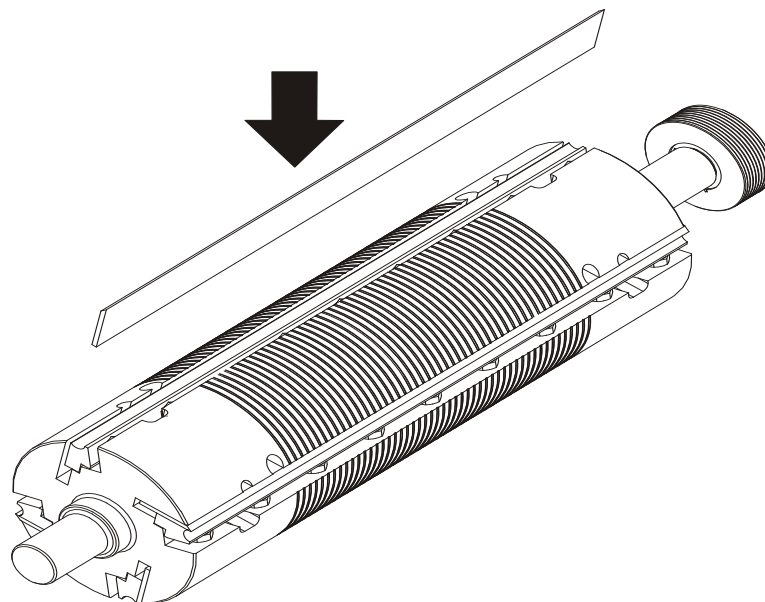
FIG. 4-4

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

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. 4-4**

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

**FIG. 4-4**

- 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.

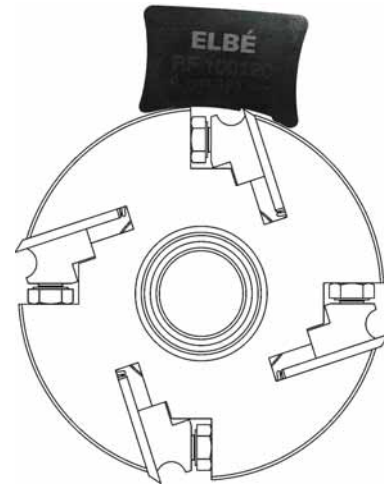





FIG. 4-4


- Tighten all mounting strip bolts starting from middle of the cutter, to the outside.
- 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.

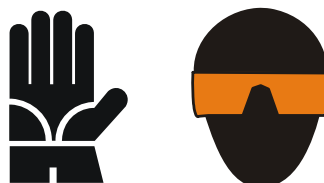
To remove the knife from the cutter, loosen the mounting strip bolts. Carefully remove the knife.


 **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.

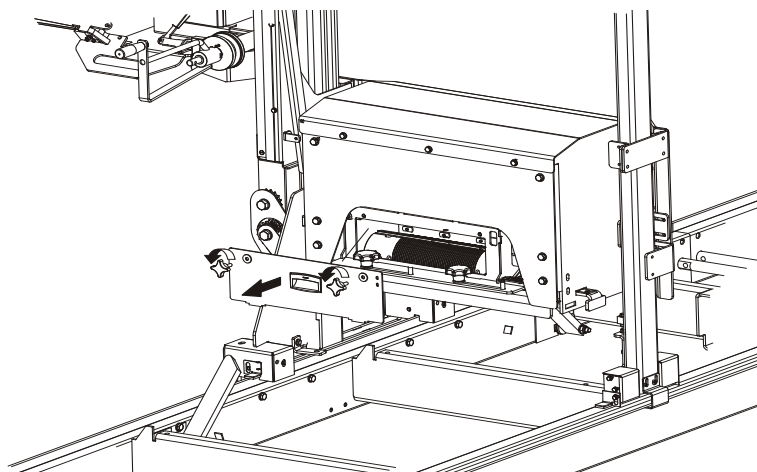


FIG. 4-4

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.

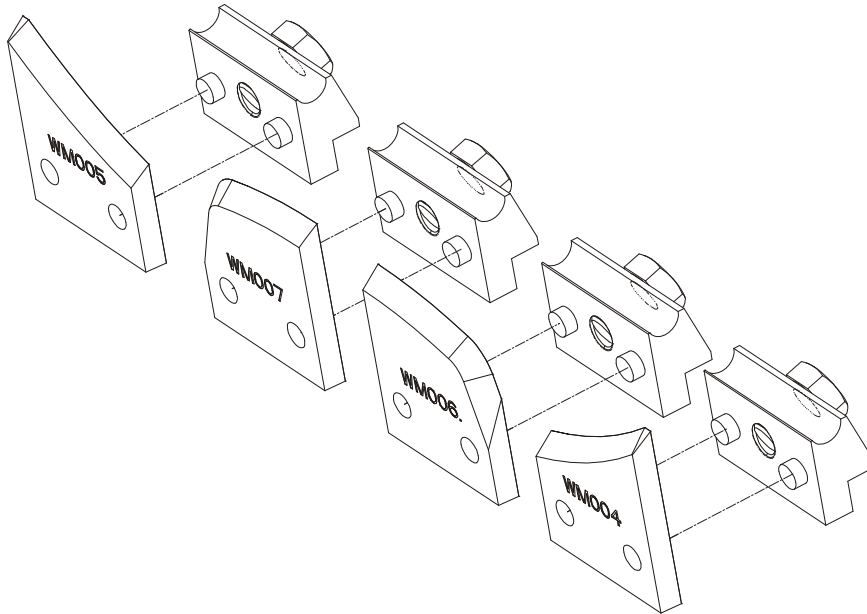


FIG. 4-4

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

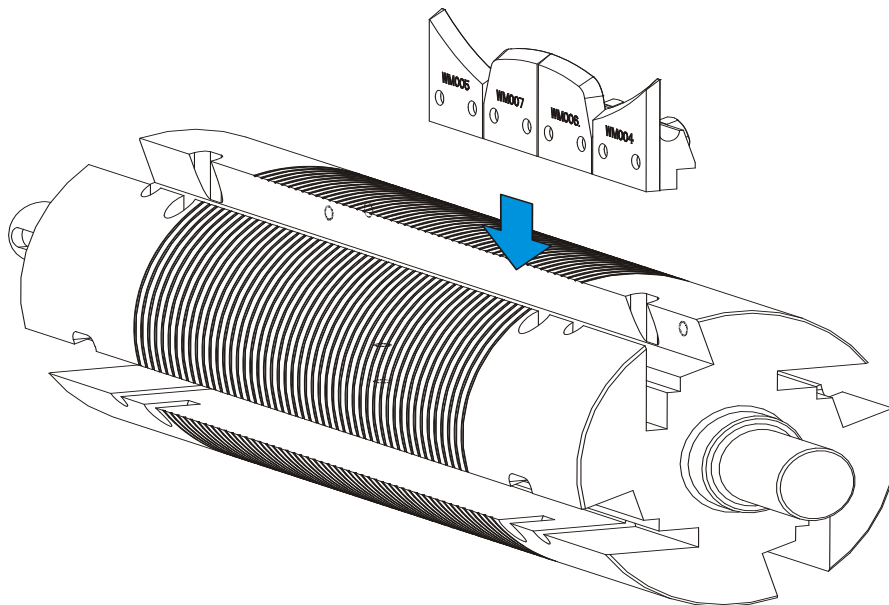
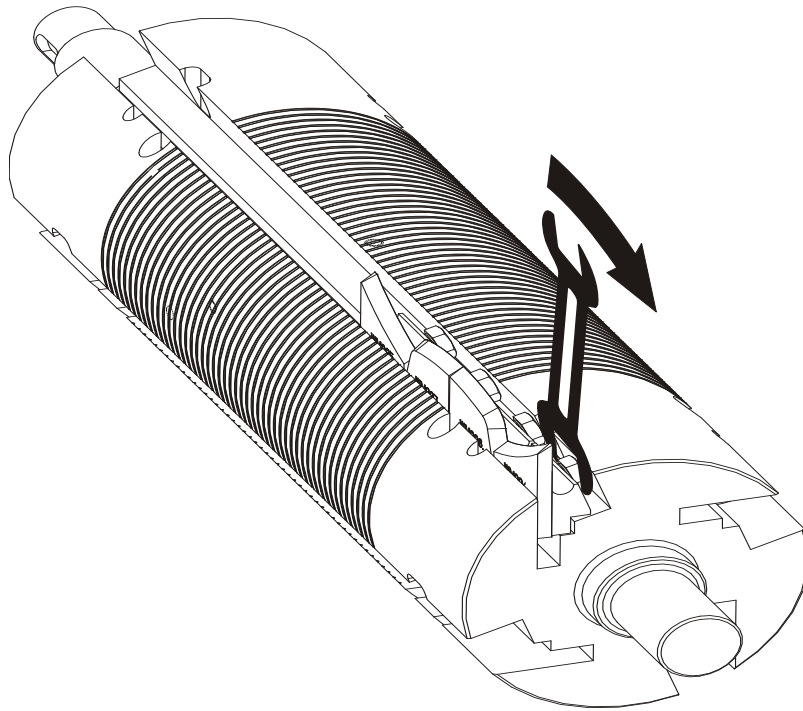
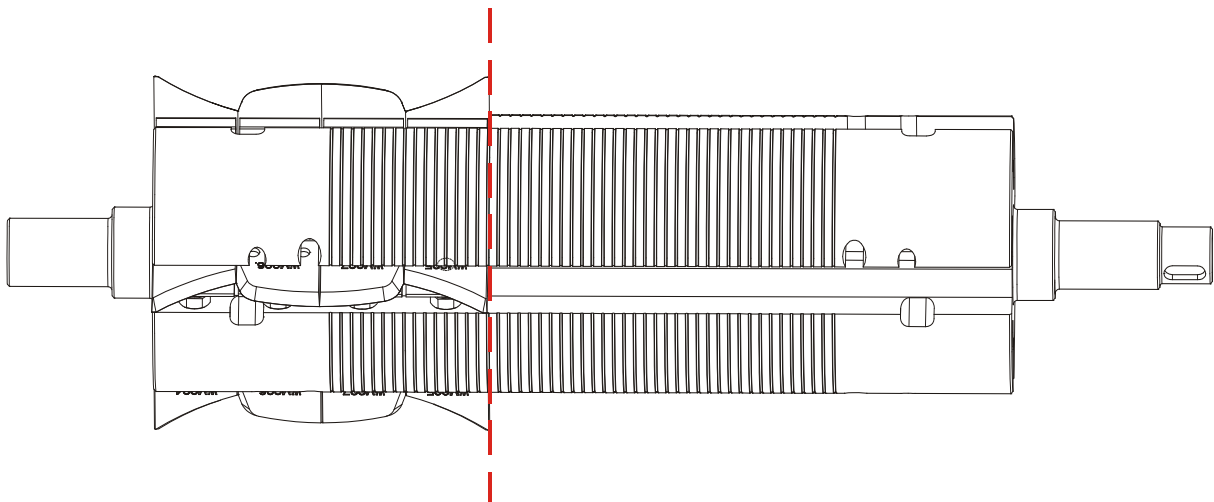


FIG. 4-4


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


**FIG. 4-4**

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. 4-4**

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.

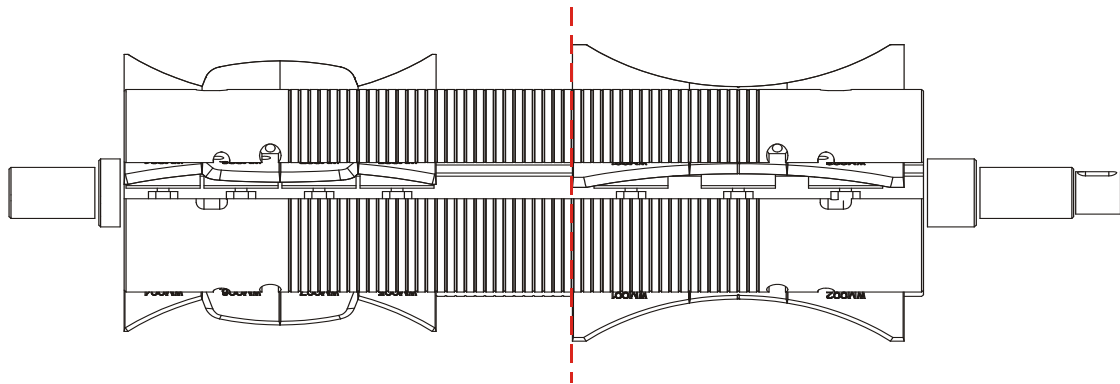


FIG. 4-4

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.

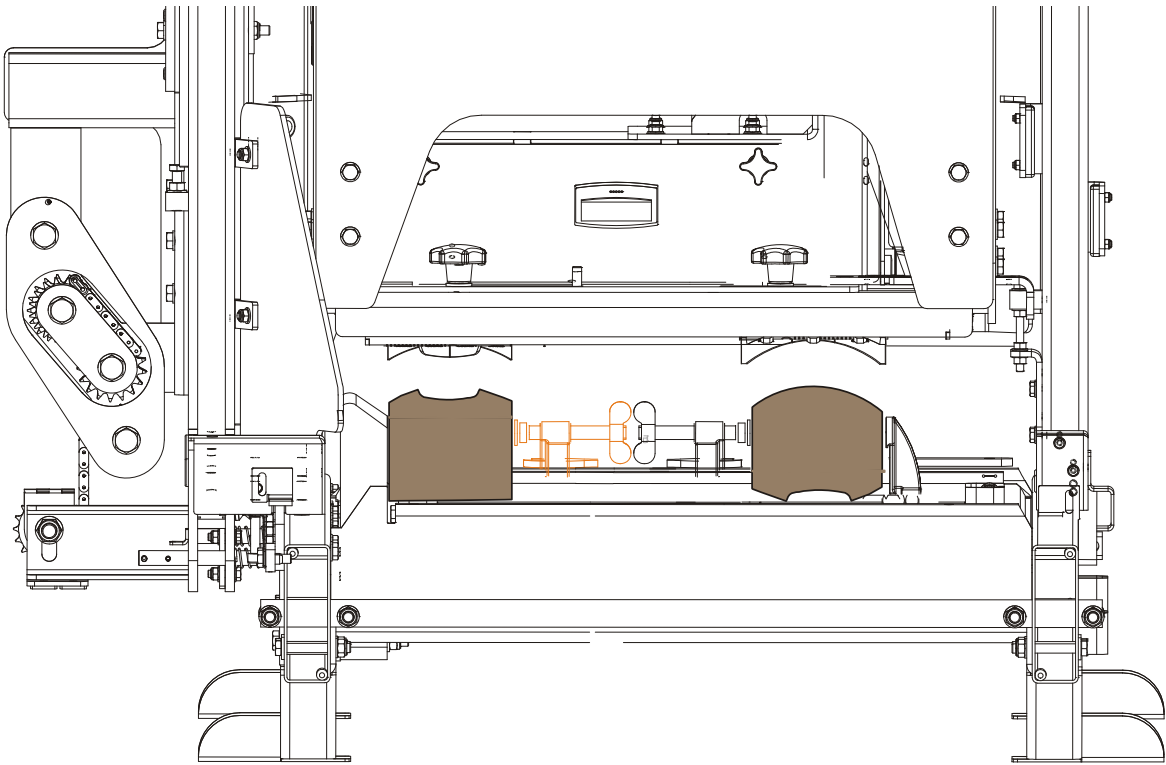


FIG. 5



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

4.5 Moulder Operation, MP100

4.5.1 Control Overview

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

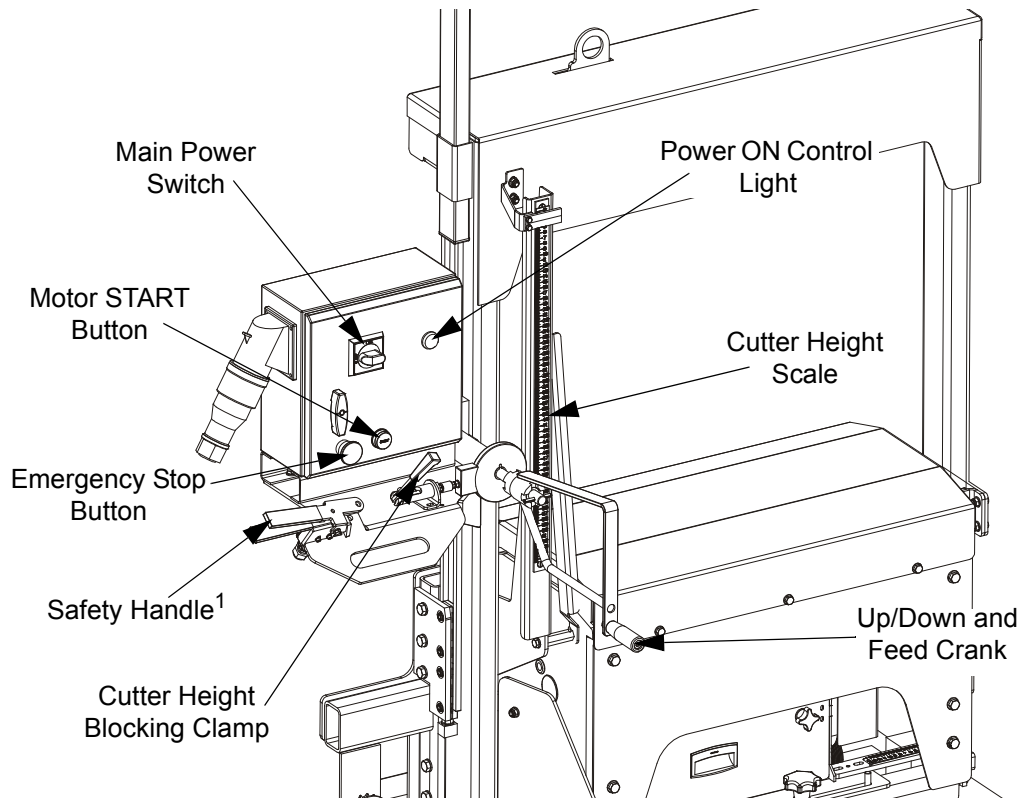


FIG. 4-2

1. Safety Handle¹

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).

4.5.3 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.

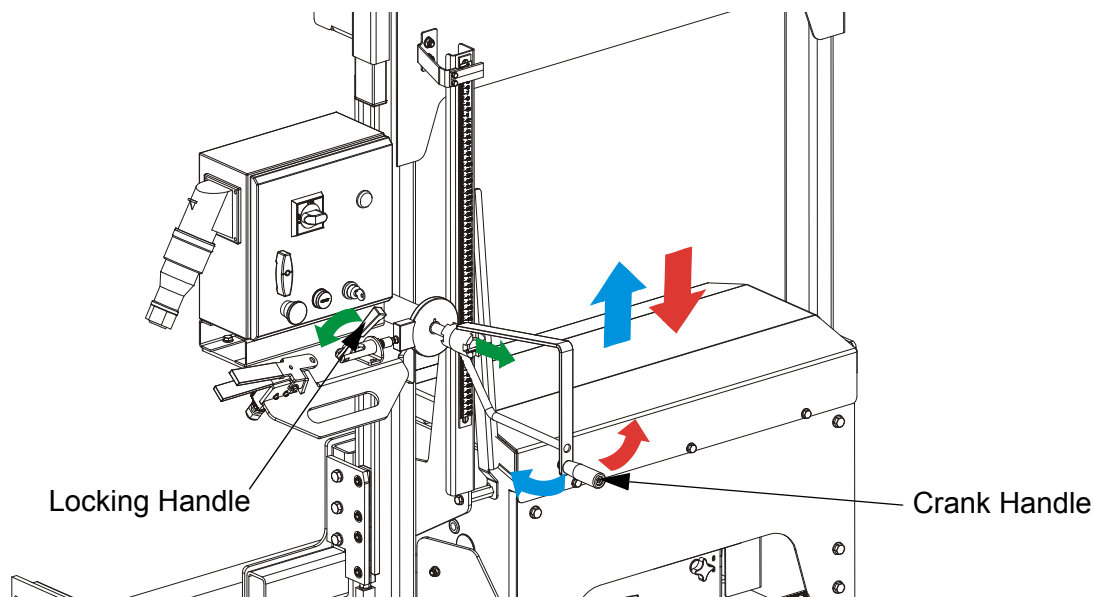


FIG. 4-4

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.

4.5.5 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.

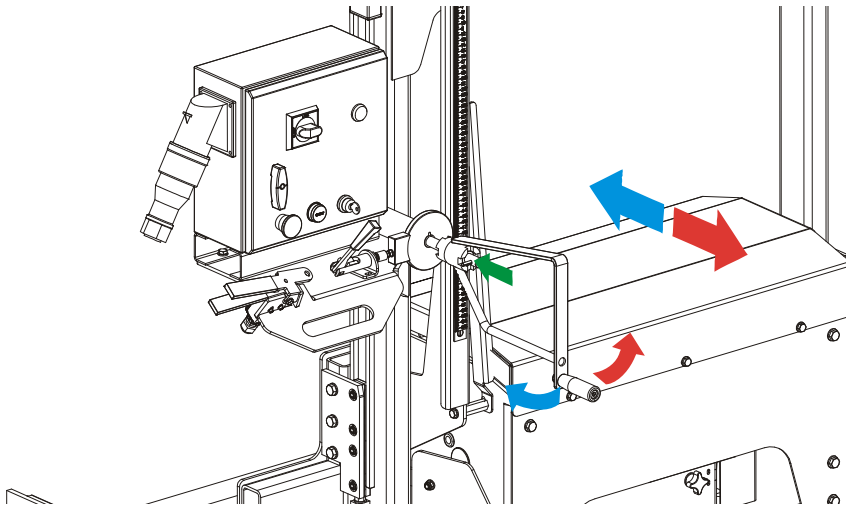


FIG. 4-6



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.

- 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.

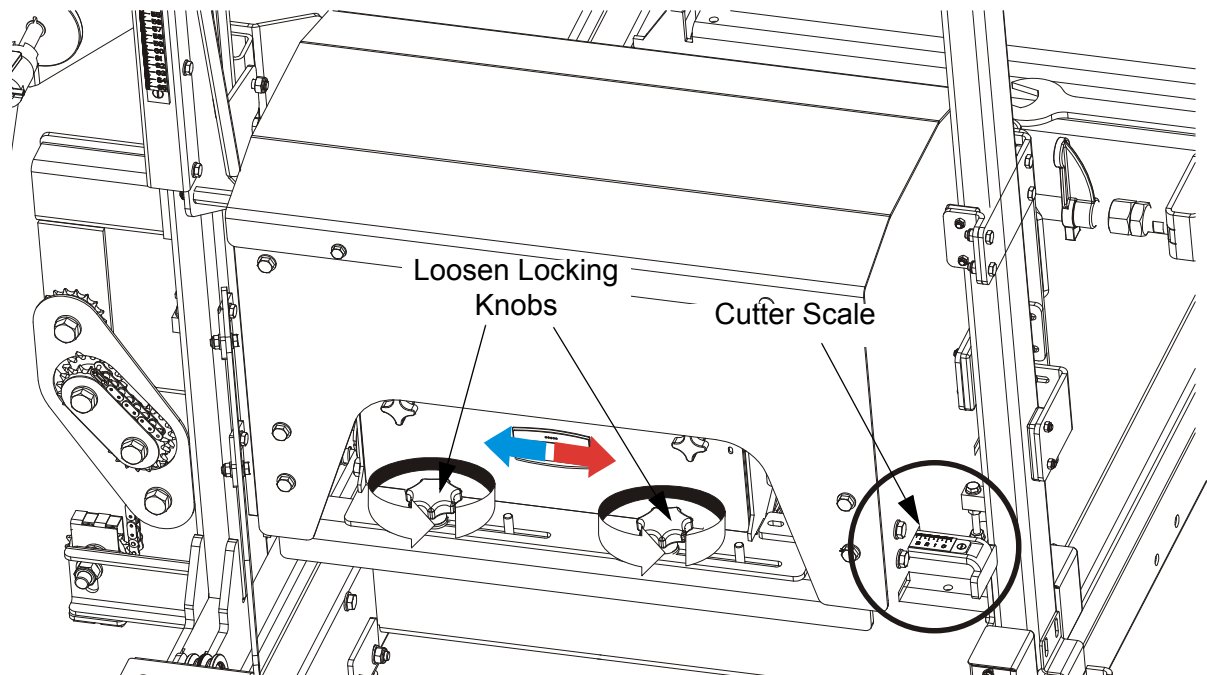


FIG. 4-7

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.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.

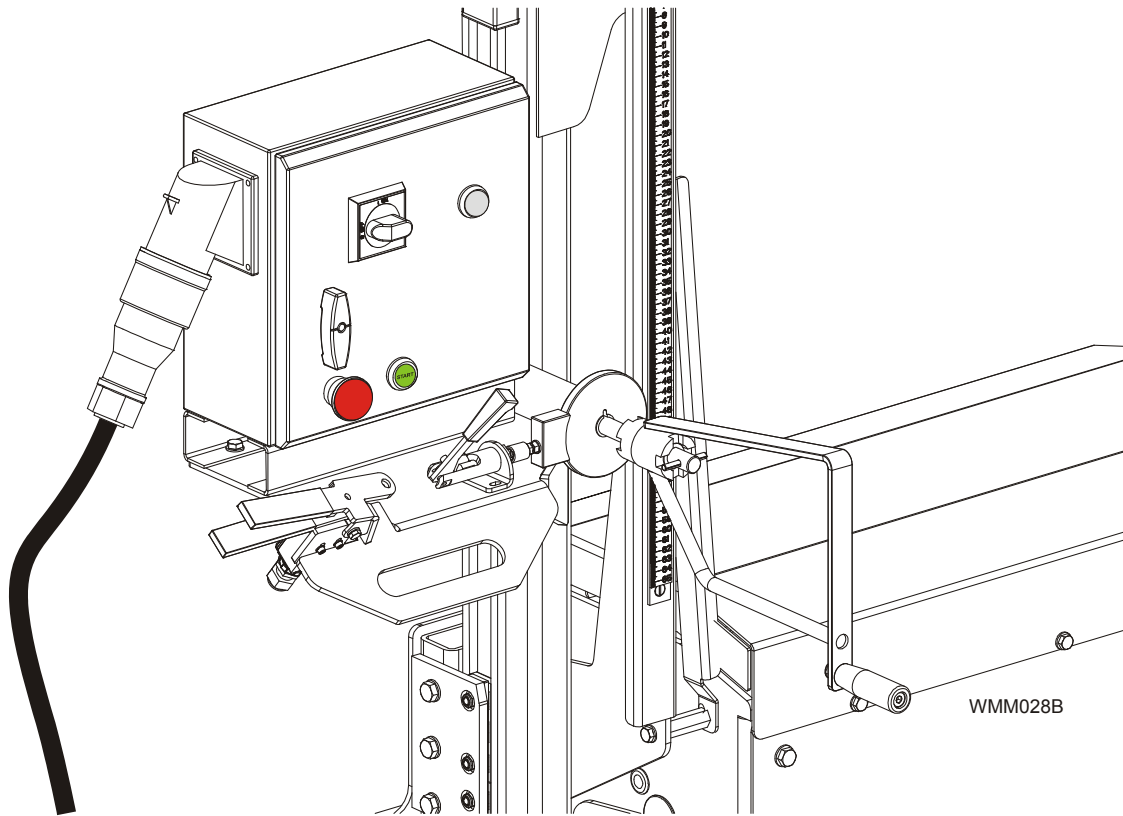



FIG. 4-8

SECTION 5 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.


5.1 Wear Life

See Table 5-1. 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 5-1

5.2 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.

5.3 Head Track & Rollers

See Figure 5-1.

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


5.4 Vertical Mast

 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.

5.5 Miscellaneous Lubrication

 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.

5.6 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 5-2.

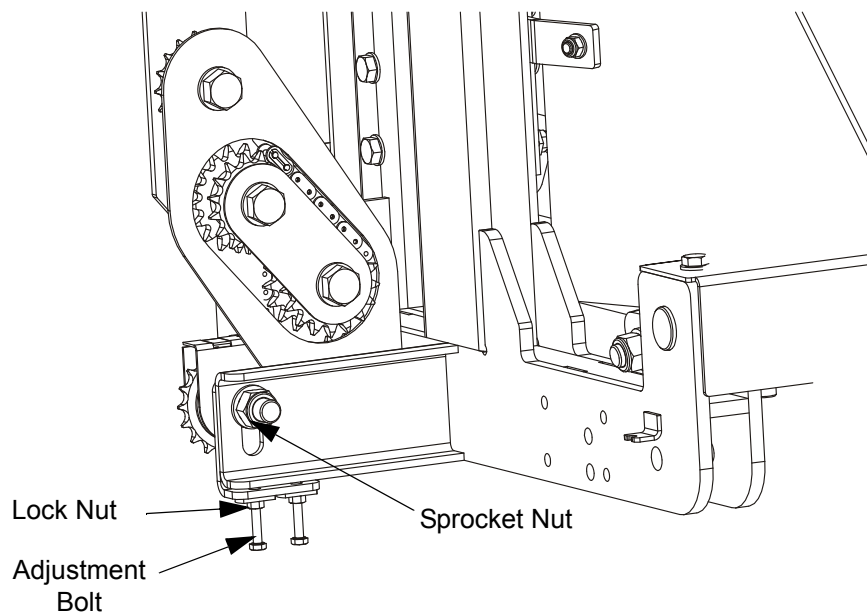


FIG. 5-2

5.7 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.

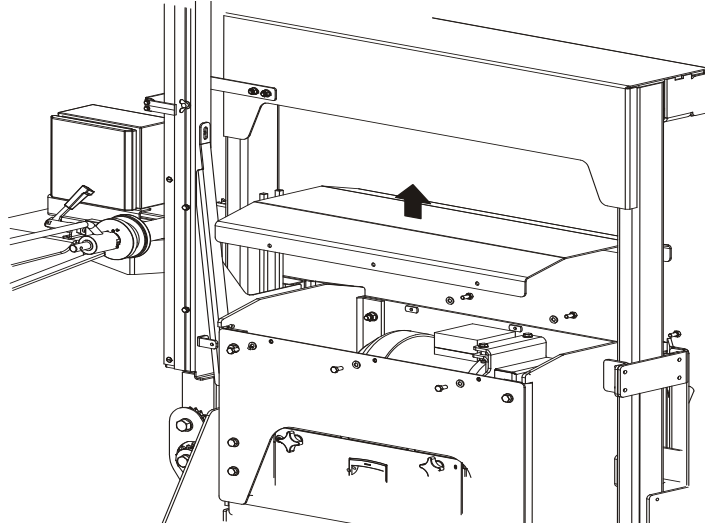


FIG. 5-2

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

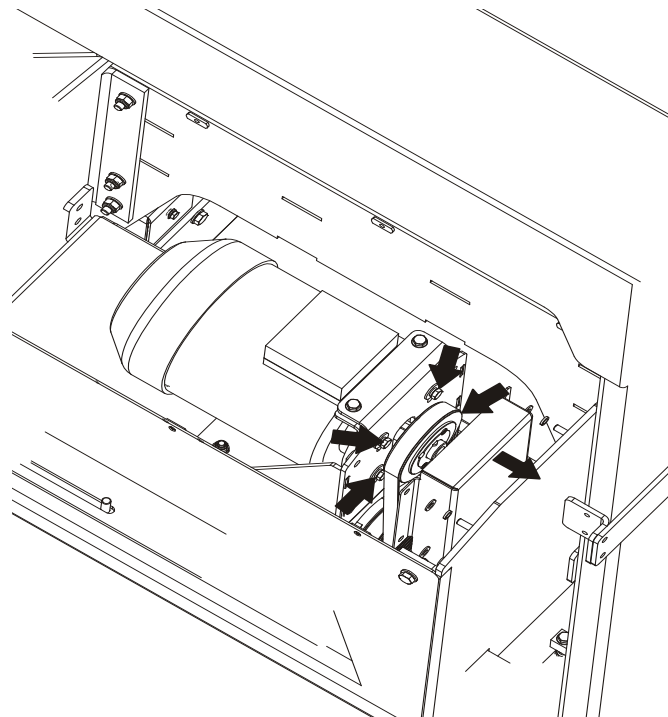


FIG. 5-2

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

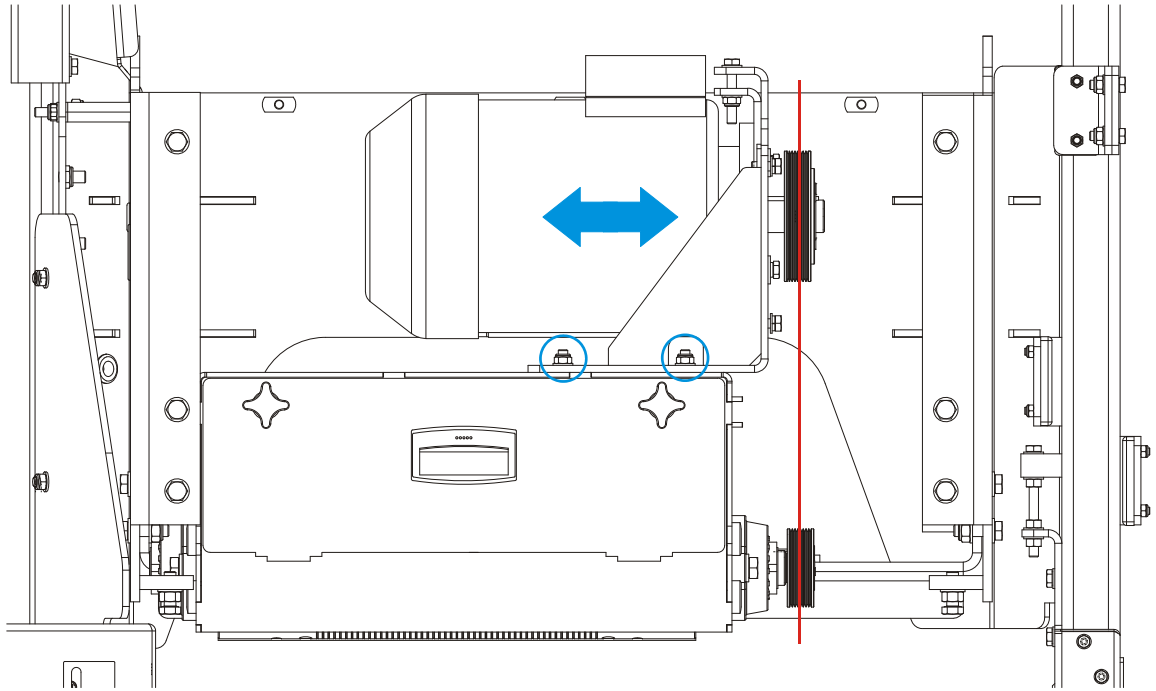


FIG. 5-2

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.

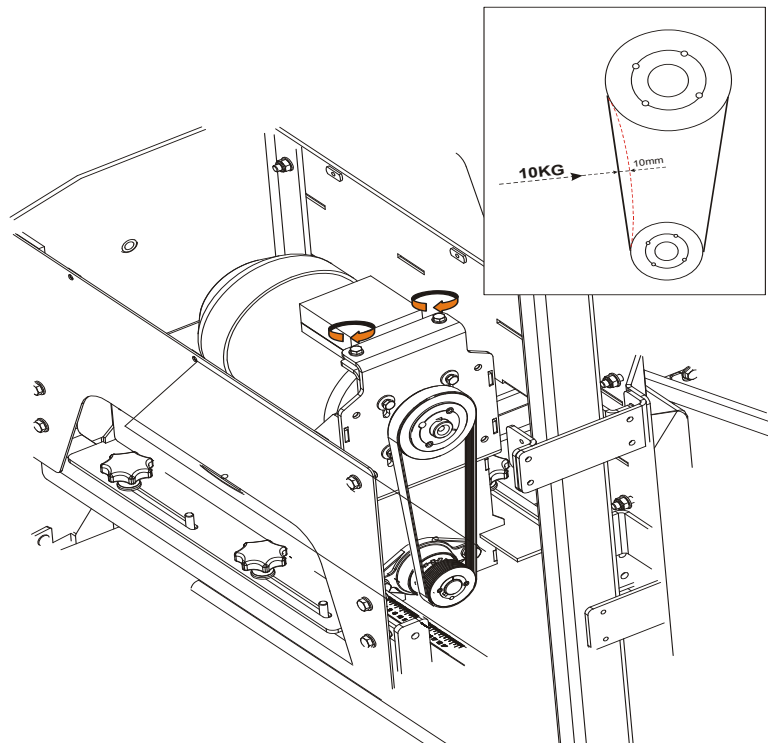


FIG. 5-2



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.

5.8 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.

5.9 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.

5.10 Safety Devices Inspection

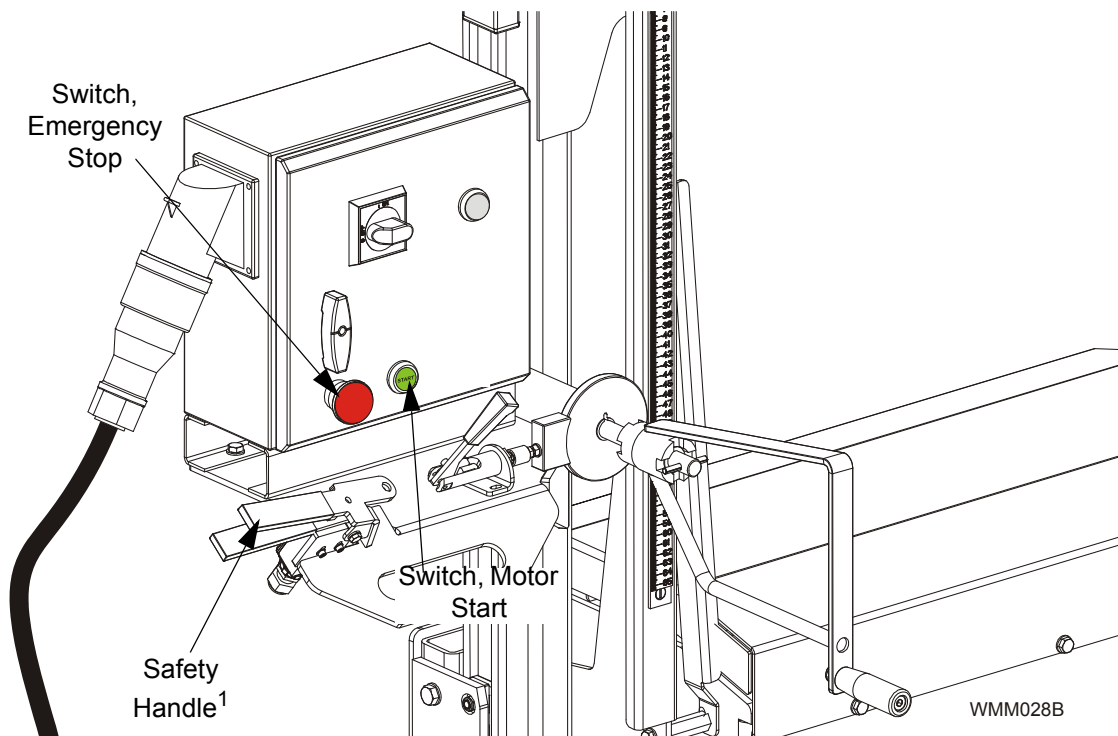
MP100E11-R Moulder – Safety Devices Inspection

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

- E-STOP button and its circuit inspection
- Safety handle and its circuit inspection¹
- 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.



2. Safety handle and its circuit inspection

1. It does not concern the US version.

- 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 6 SPECIFICATIONS

6.1 Overall Dimensions

See **Figure 6-1**. The major dimensions of the MP100-R moulder are shown below (all dimensions are in millimeters).

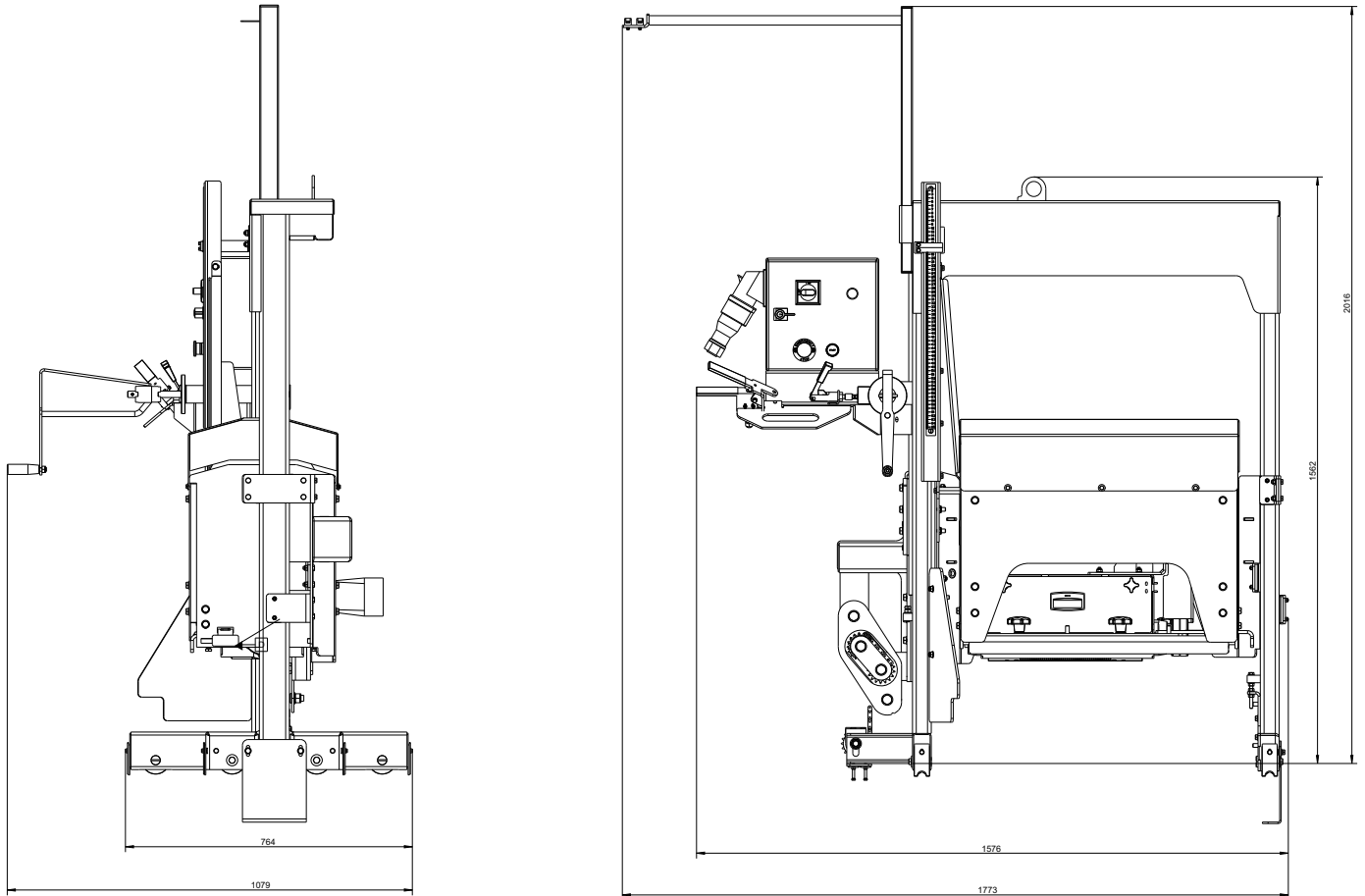


FIG. 6-1 MP100

See **Table 6-1**. 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 6-1

6.2 Moulder Specifications

See Table 6-2. See the table below for the Wood-Mizer moulder nomenclature.

	Voltage
MP100EH11-R	3 ph 400V

TABLE 6-2

See Table 6-3. See the table below for the Wood-Mizer moulder main motor specifications.

	Motor Specifications
Motor Type	E11 Electric Motor
Manufacturer	Cantoni Motor, Poland
Voltage	400V 50Hz
Maximum Current	14.8 A
Motor RPM	2885 RPM
Rated Output	7,5kW (11HP)
Manufacturer Part #	PSKg-112 M-2B14/C160
WM Part #	514844

TABLE 6-3

See Table 6-4. The noise level of the MP100 moulder is given below.^{1 2 3}

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

TABLE 6-4

See Table 6-5. 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 6-5

¹ Using horizontal adjustment

See Table 6-6. 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 6-7)

TABLE 6-6

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard. Value for associated uncertainty $K=4\text{dB}$.
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 .

6 SPECIFICATIONS

Moulder Specifications

See Table 6-7. 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 6-7

¹ According to EN 847-1:2005 European Standard

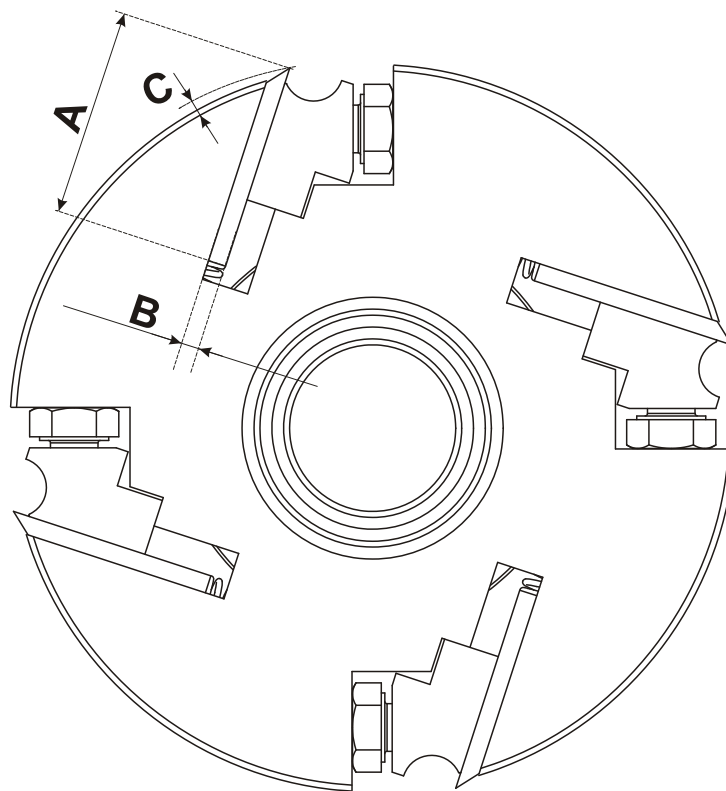


FIG. 6-1

6.3 Dust Extractor Specifications

See Table 6-8. 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 6-8

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

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

SECTION 7 MOTOR BRAKE

7.1 Maintenance/repair

Wear of spring – applied brakes

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

Inspections

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

Maintenance intervals

Service brakes	<ul style="list-style-type: none"> ■ according to service life calculation ■ otherwise every six months ■ after 4000 operating hours at the latest
-----------------------	---

TABLE 7-1.

7.2 Maintenance



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

Please observe the following for inspections and maintenance operations:

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

Checking the rotor thickness



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

- Remove the motor cover and seal ring (if mounted).
- Measure the rotor thickness with a caliper gauge. On brakes with friction plates, observe edging on outer diameter of friction plate.
- Compare measured rotor thickness with minimally permissible rotor thickness [See Table 12-2](#)
- Replace the complete rotor if necessary.

Check air gap

- Measure the air gap "sL_ü" between armature plate and rotor using a feeler gauge (see chapter 3.3).
- Compare the measured air gap to the maximum permissible air gap "sL_{ümax}." (see table below).
- If necessary, adjust air gap to "sL_ürated".

Brake Type	sL _ü rated +0.1mm -0.05mm	sL _{ümax} Service Brake	Max. adjustment permissible wear	Rotor thickness		Excess of the adjuster nut h _E max. [mm]
				min. ¹⁾ [mm]	max. [mm]	
INTORQ BFK458-25	0,4 mm (1/64")	1,0 mm (3/64")	4,0 mm (5/32")	12 mm (15/32")	16 mm (5/8")	17 mm (43/64")

TABLE 12-2

ROZDZIAŁ 9 LISTA CZĘŚCI ZAMIENNYCH

9.1 Sposób korzystania z listy części zamiennych

- W odpowiednim rozdziale znaleźć część na ilustracji.
- Za pomocą numeru odpowiadającego znalezionej części należy odszukać jej dokładny numer katalogowy wraz opisem w tabelce.
- Części ukazane jako elementy składowe podzespołu są dostępne wraz z tym podzespołem.
- Części zaznaczone kwadracikiem (◆) są dostępne jedynie w zespole podanym w wierszu tabeli znajdującym się powyżej tej części.

Zobacz przykładową tabelę poniżej. Przykładowa część #A01111 zawiera część F02222 - 2 i podzespół A03333. Podzespół A03333 zawiera część S04444 - 4 oraz podzespół K05555. Kwadracik (◆) wskazuje, że część S04444 - 4 jest dostępna wyłącznie w podzespolu A03333. Podzespół K05555 zawiera części M06666 i F07777 - 77. Kwadracik (◆) wskazuje, że część M06666 jest dostępna jedynie w podzespolu K05555.

9.2 Przykładowy zespół				
LP.	OPIS(◆ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.	
	PRZYKŁADOWY ZESPÓŁ, KOMPLETNY (zawiera wszystkie wyszczególnione poniżej części)	A01111	1	
1	Przykładowa część	F02222-22	1	
2	Przykładowy podzespół (zawiera wszystkie wyszczególnione poniżej części)	A03333	1	
	Przykładowa część (wskazuje, że część jest dostępna jedynie w podzespolu A03333)	S04444-4	1	◆
3	Przykładowy podzespół (zawiera wszystkie wyszczególnione poniżej części)	K05555	1	
	Przykładowa część (wskazuje, że część jest dostępna jedynie w podzespolu K05555)	M06666	2	◆
4	Przykładowa część	F07777-77	1	

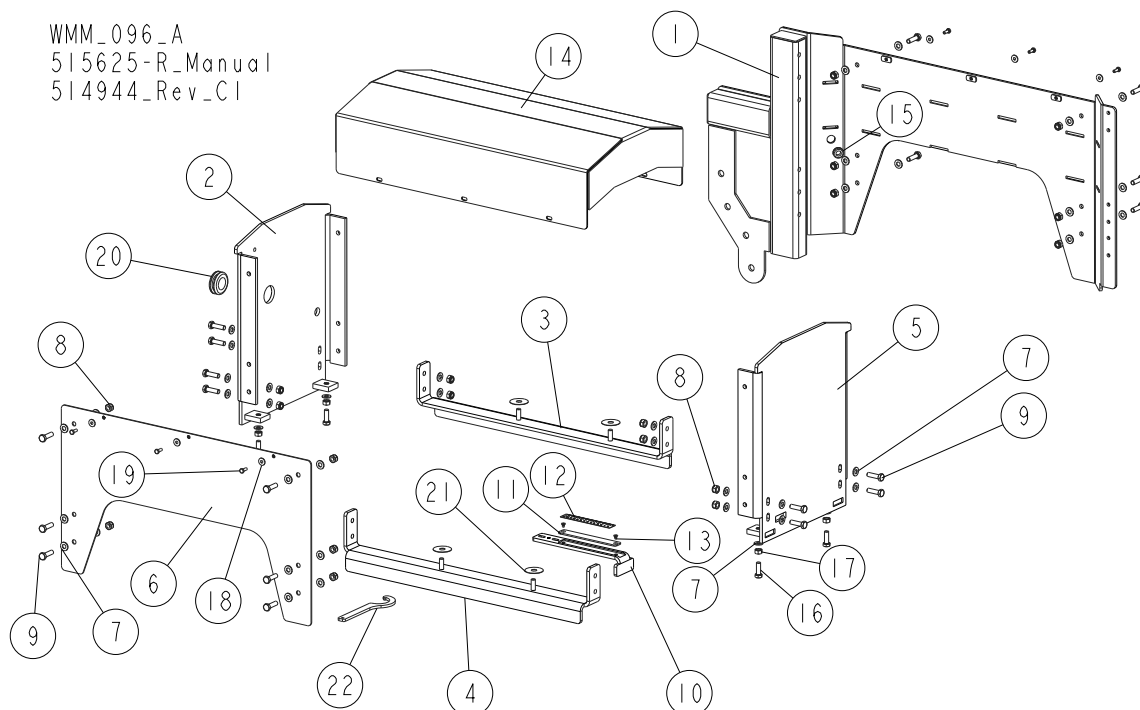
Ażeby zamówić części zamienne należy:

Będąc w Europie zatelefonować do zakładu produkcyjnego i głównej europejskiej siedziby firmy Wood-Mizer, znajdujących się w miejscowości Koło-Polska, na numer **+48-63-2626000** lub **+48-3912-1319**. Z terenu USA zadzwonić na numer **1-800-448-7881**. W czasie rozmowy należy mieć "pod ręką" osobisty numer klienta, numer identyfikacyjny krawędziarki oraz numer części zamiennej. W celu zamówienia części skontaktować się można również z właściwym miejscowo przedstawicielem naszej firmy.



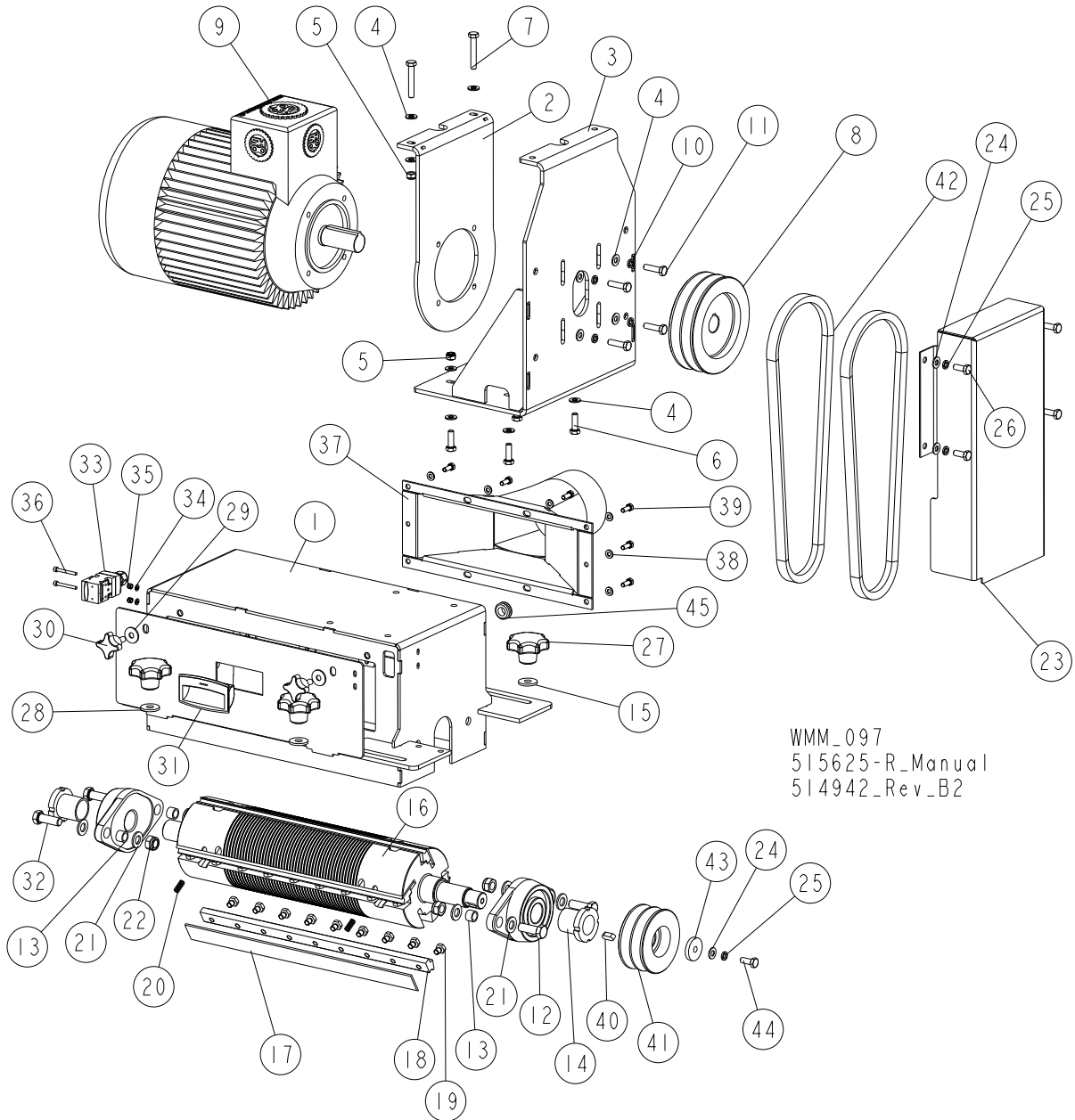
UWAGA! Zaleca się korzystanie jedynie z oryginalnych części zamiennych.

9.3 Głowica strugarki



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	GŁOWICA STRUGARKI KOMPL.	514944	1
1	ZESPÓŁ WYSOKOŚCI FREZA	501897-1	1
2	STRONA LEWA SKRZYNI FREZA	501895-1	1
3	KĄTOWNIK PRAWY STRUGARKI	501951-1	1
4	KĄTOWNIK LEWY STRUGARKI	501952-1	1
5	STRONA PRAWA SKRZYNI FREZA	501896-1	1
6	ŚCIANA TYLNA SKRZYNI FREZA	501905-1	1
7	PODKŁADKA OKR. 10,5 FE/ZN5 PN-78/M-82005	F81055-1	44
8	NAKRĘTKA M10 Z WKŁADKĄ POLIAMIDOWĄ	F81033-1	20
9	ŚRUBA M10X35 8.8 FE/ZN5 PN-85/M-82105	F81003-17	20
	SKAŁA WAŁKA FREZA KPL.	502352	1
10	CIĘGNO FREZA	501949-1	1
	PODZIAŁKA POZIOMA METRYCZNA, KPL.	501203	1
11	PODSTAWA PODZIAŁKI, PODZ. KPL.	501205	1
12	NALEPKA, PODZIAŁKA METRYCZNA 0-20, PODZ. KPL.	501206	1
13	WKRĘT M5X8-5.8-B-FE/ZN5 PN-85/M-82207	F81000-33	2
14	POKRYWA GŁOWICY MP100 - R	514943-1	1
15	PIERŚCIEŃ GUMOWY 20/13.	086188	1
16	ŚRUBA M10X30 5.8 FE/ZN5 PN-M/82105	F81003-2	4
17	NAKRĘTKA ZWYKŁA M10 8 FE/ZN5 PN-86/M-82144	F81033-3	4
18	PODKŁADKA 6.5 POW. FE/ZN5 PN-M/82030.	F81053-11	6
19	ŚRUBA M6X16-8.8-FE/ZN5 PN-M/82105	F81001-15	6
20	PRZEPUST GUMOWY 30X42X8.	509717	1
21	PODKŁADKA NYLONOWA 33/64x1 3/4x1/32	014972	4
22	KLUCZ NAKRĘTKI ŁOŻYSKOWEJ N53	502443	1

9.4 Głowica skrawająca



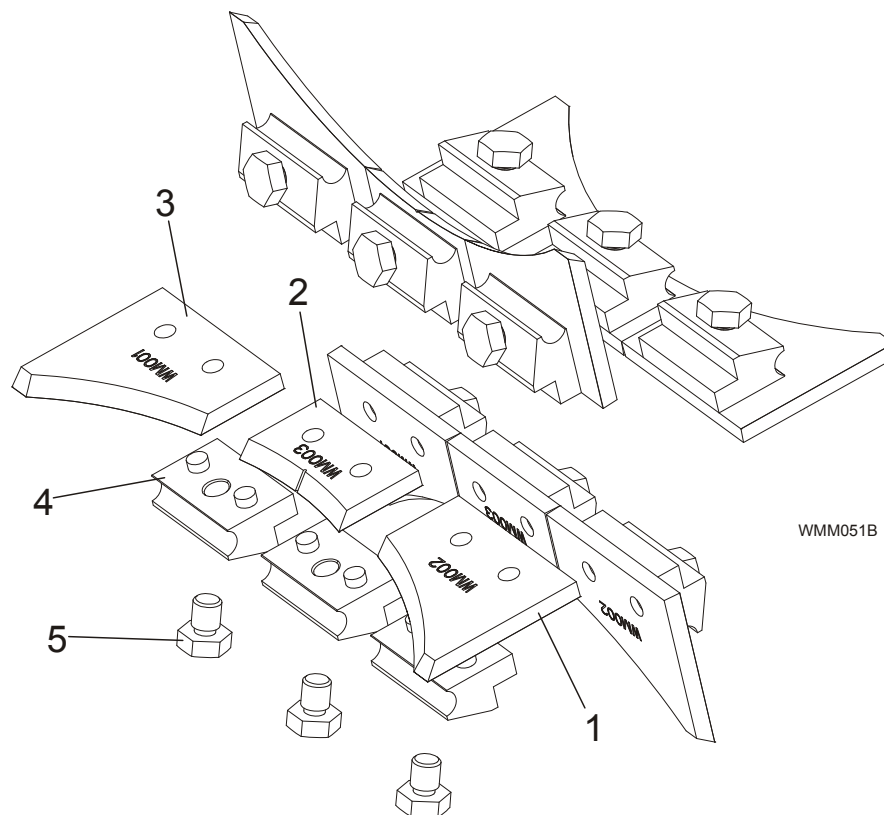
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515625-R_Manual
514942_Rev_B2

LP.	OPIS (♦ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.
	GŁOWICA SKRAWAJĄCA KPL.	514942	1
1	OBUDOWA FREZA STRUGARKI	501890-1	1
	SILNIK ELEKTR. 7.5 KW Z UCHWYTEM, KPL.	514941	1
2	UCHWYT SILN. 7.5 KW.	514586-1	1
3	WSPORNIK SILNIKA 7.5 KW, MAŁOWANY.	514945-1	1
4	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	16
5	NAKRĘTKA M8 8 FE/ZN5 PN-85/M-82175	F81032-2	6
6	ŚRUBA M8X25-8.8-B-FE/ZN5 PN/M-82105.	F81002-5	4
7	ŚRUBA M8X50 -8.8- FE/ZN5 PN-85/M-82105	F81002-19	2
8	KOŁO PASOWE B-2 N140(F02326+T31105)	515618-1	1
9	SILNIK PSKG-112 M-2B14/C160	514844	1
10	PODKŁADKA SPRĘŻYSTA 8.2 FE/ZN5 PN-M/82008	F81054-4	4

LP.	OPIS (◆ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.
11	ŚRUBA M8X30 8.8 FE/ZN5 PN-85/M-82105	F81002-7	4
	ZESPÓŁ ŁOŻYS. Z TULEJKAMI FYTJ 507 (SKF)	513046	2
12	ZESPÓŁ ŁOŻYSKOWY FYTJ 507 (SKF)	513045	1
13	TULEJKA (SKF)	513047	2
14	TULEJA WCIĄGANA H2307	513386	1
15	PODKŁ. OKRĄGŁA POWIĘKSZ.10.5 FE/ZN5	F81055-6	4
	WAŁ NOŻOWY PODSTAWOWY, KPL.	500949	1
16	KORPUS WAŁU NOŻOWEGO, CYNKOWANY.	500950-1	1
17	NÓŻ DO STRUGARKI HSS 410X35X3.	501199	4
	DOCISK NOŻA PROSTEGO, KPL.	500951	4
18	KORPUS DOCISKU NOŻA, CYNKOWANY.	500952-1	1
19	ŚRUBA M8X10-8.8-FE/ZN5 BN-70/1601-01	F81002-47	9
20	SPRĘŻYNA 18X6X1.	501200	8
21	PODKŁADKA OKR. 13-FE/ZN5 PN-78/M-82005	F81056-1	8
22	NAKRĘTKA Z WKŁADKĄ POL. M12 8 FE/ZN5	F81034-2	4
23	OSŁONA PASA NAPĘDOWEGO, MALOWANA.	503756-1	1
24	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	5
25	PODKŁADKA SPRĘŻYSTA 8.2 FE/ZN5 PN-M/82008	F81054-4	5
26	ŚRUBA M8X20 8.8 FE/ZN5 PN-85/M-82105	F81002-4	4
27	POKRĘTŁO ŻEŃSKIE SR1580 63XM10 (462081 MOSS).	501189	4
28	MASKOWNICA	501904-1	1
29	PODKŁADKA ISO 7093-1-8-200 HV-A2E.	F81054-11	2
30	POKRĘTŁO GWIAZDKOWE SR.40/M8X20 (462053 MOSS)	500973	2
31	UCHWYT WPUSZCZANY EPR.90-PF-C1(261051-C1).	100012	1
32	ŚRUBA M12X35 8.8 FE/ZN5 PN-85/M-82105	F81004-24	4
33	WYŁĄCZNIK BEZPIECZEŃSTWA AZ17-11ZRK	094232	1
34	PODKŁADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	2
35	NAKRĘTKA M4-8-FE/ZN5 PN/M-82175.	F81029-1	2
36	ŚRUBA IMB.M4X35 8.8 FE/ZN PN-87/M-82302	F81011-34	2
37	WYCIĄG TROCIN STRUGARKI	502379-1	1
38	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	9
39	ŚRUBA M6X16-8.8-FE/ZN5 PN-M/82105	F81001-15	9
40	WPUST PRYZMATYCZNY A8X7X20 PN-70/M-85005.	099059	1
41	KOŁO PASOWE 2B N90/N25	515617-1	1
42	PASEK KLINOWY B LP=1000	515619	2
43	PODKŁADKA 9/35-6 CYNK.	093854-1	1
44	ŚRUBA M8X20 5.8 FE/ZN5 PN-85/M-82105	F81002-1	1
45	PIERŚCIEŃ GUMOWY 20/13.	086188	1

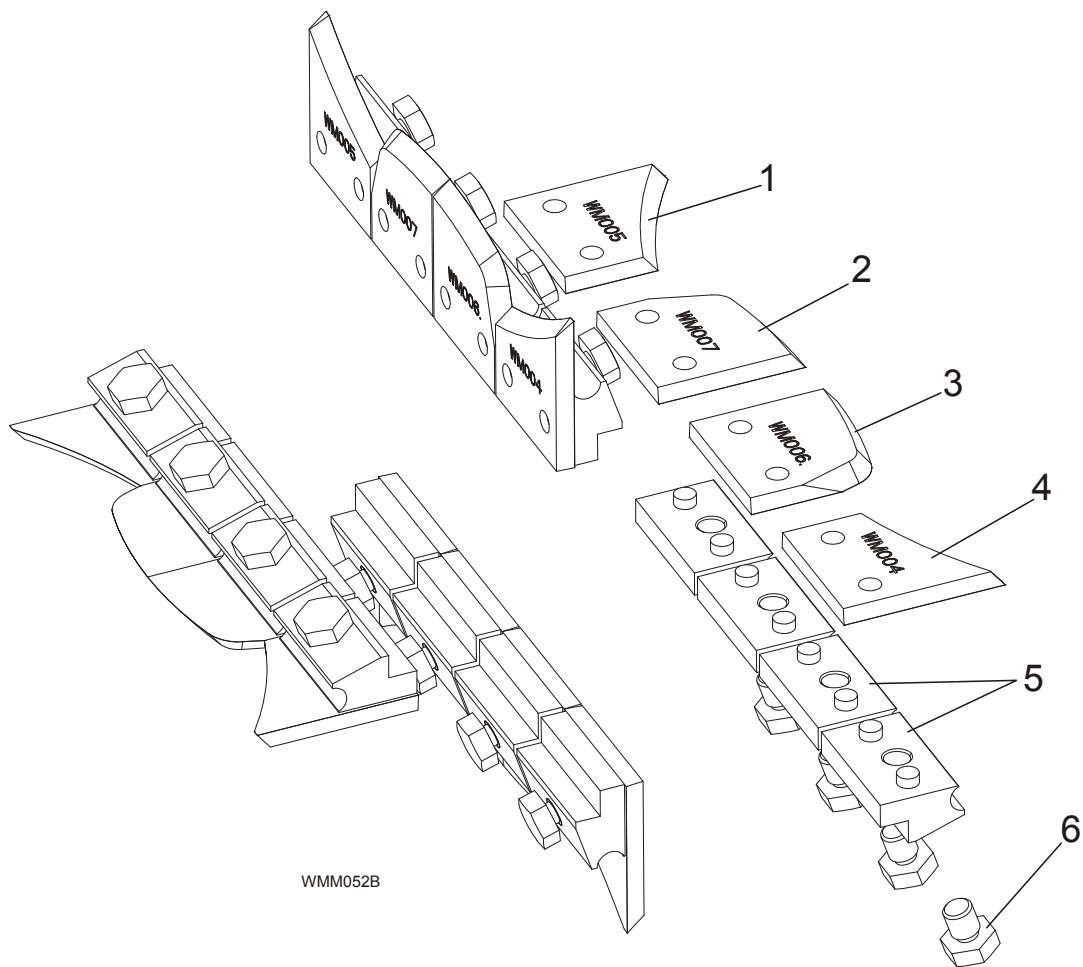
9.5 Noże kształtowe

9.5.1 Zestaw noży do profilu nr 1



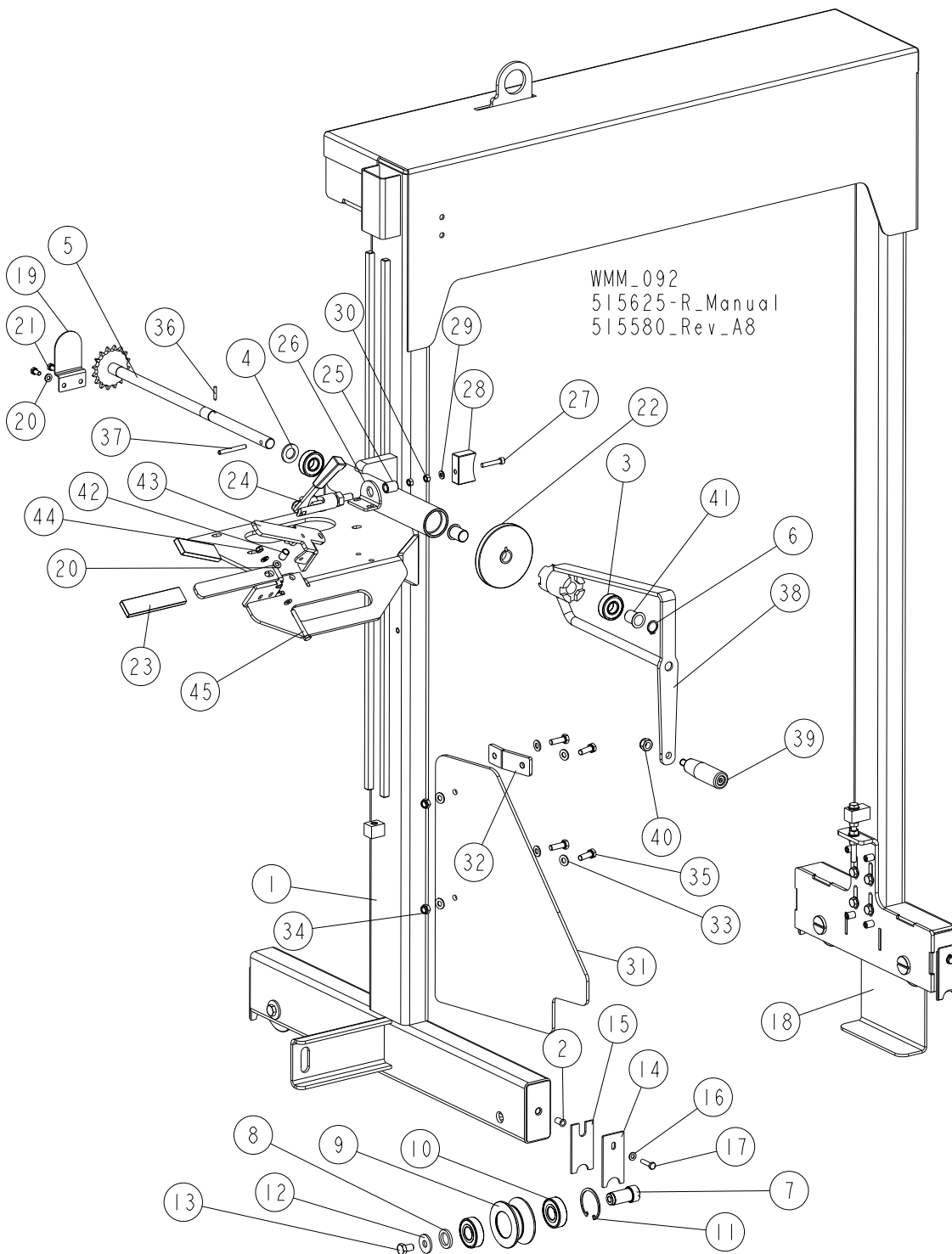
LP.	OPIS (♦ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.
	KOMPLET NOŻY O PROFILU NR 1	503093-S	1
	ZESTAW NOŻY DO PROFILU NR 1	501222	4
1	NÓŻ PROFILOWY WM002	501227	1
2	NÓŻ PROFILOWY WM003	501228	1
3	NÓŻ PROFILOWY WM001	501226	1
	WKŁADKA DOCISKOWA NOŻA PROFILOWANEGO, KPL	501175	3
4	KORPUS WKŁADKI DOCISKOWEJ NOŻA PROFILOWANEGO	501176-1	1
5	ŚRUBA M8x12-8.8-Fe/Zn5 PN-M/82105	F81002-6	1

9.5.2 Zestaw noży do profilu nr 2



LP.	OPIS (◆ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.
	KOMPLET NOŻY O PROFILU NR 2	503094-S	1
	ZESTAW NOŻY DO PROFILU NR 2	501223	4
1	NÓŻ PROFILOWY WM005	501230	1
2	NÓŻ PROFILOWY WM007	501232	1
3	NÓŻ PROFILOWY WM006	501231	1
4	NÓŻ PROFILOWY WM004	501229	1
	WKŁADKA DOCISKOWA NOŻA PROFILOWANEGO, KPL	501175	4
5	KORPUS WKŁADKI DOCISKOWEJ NOŻA PROFILOWANEGO	501176-1	1
6	ŚRUBA M8x12-8.8-Fe/Zn5 PN-M/82105	F81002-6	1

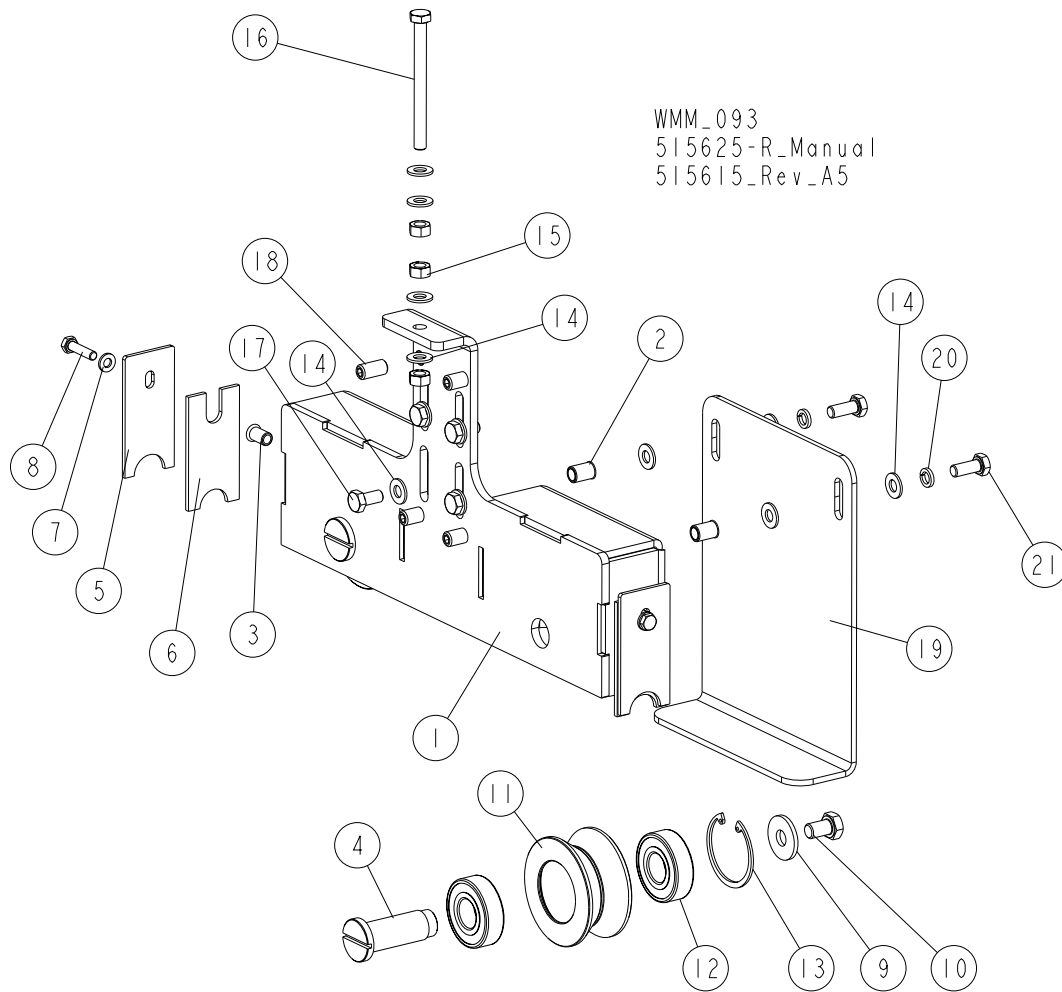
9.6 Napęd posuwu ręcznego przód/tył



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	MASZT STRUGARKI MP100EH11-R KPL.	515580	1
	MASZT STRUGARKI MP100EH11-R MALOWANY	515579-1	1
1	MASZT STRUGARKI MP100EH11-R-SPAWANY	515578	1
2	NITONAKR. NIERDZ. M6 1.5-4.0 STOZ.	F81031-9	2

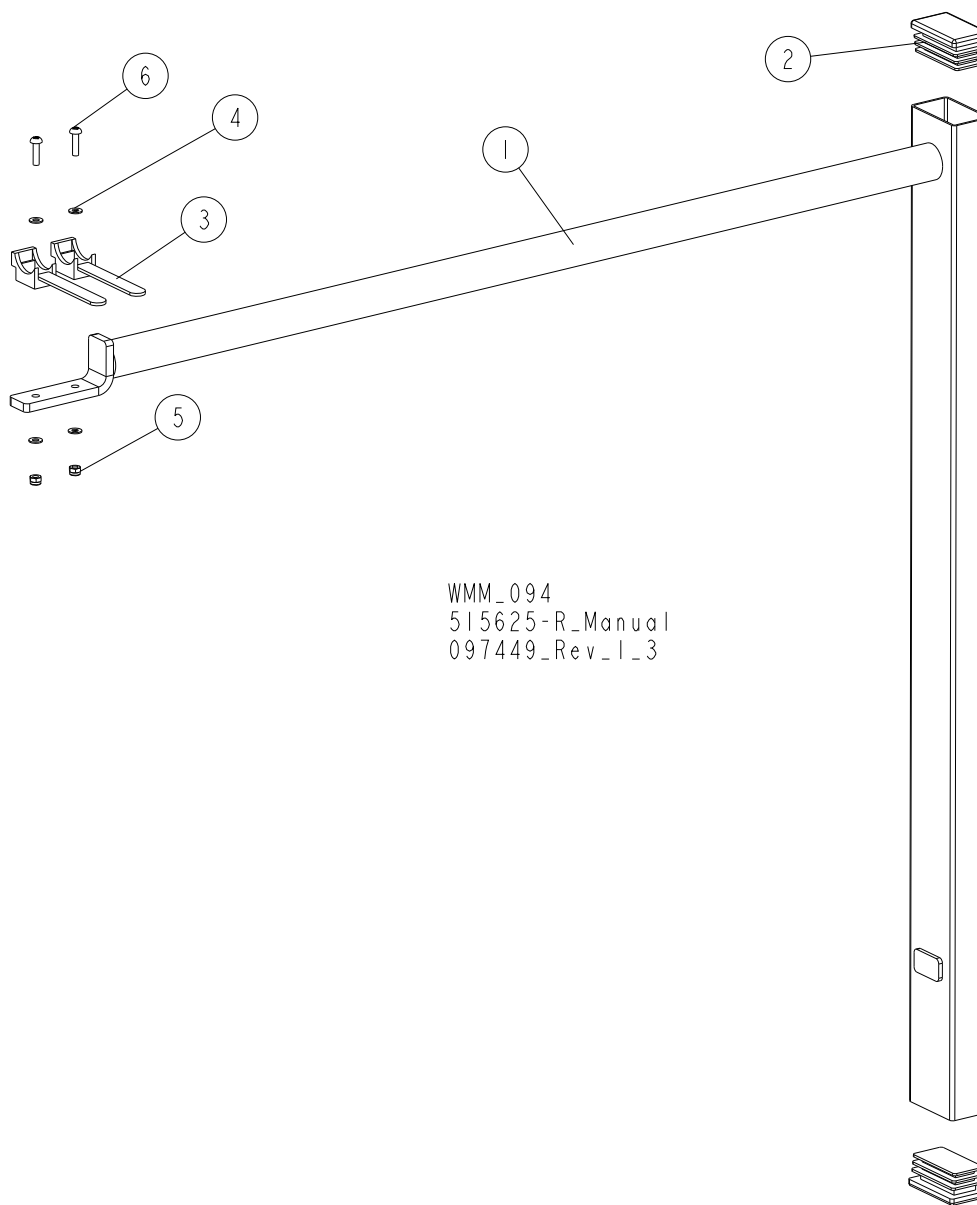
LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
3	ŁOŻYSKO TOCZNE 6203-2RS	086114	2
4	PODKŁADKA 17 FE/ZN5 PN-78/M-82008	F81058-1	1
5	WAŁEK Z KOŁEM ŁAŃC. LT15, SPAWANY.	086183	1
6	PIERŚCIEŃ OSADCZY SPR. 17Z PN-M/ 85111.	F81090-21	1
7	SWORZEŃ ROLKI PROWADZĄCEJ USTALONEJ	515018	2
8	PODKŁADKA 20.5X30-4	515021	2
	ROLKA PROWADZĄCA MASZT	515015	2
9	ROLKA PROWADZĄCA	514889	1
10	ŁOŻYSKO TOCZNE 6204 2RS CX.	088447	2
11	PIERŚCIEŃ OSADCZY W 47, PN-81/M-85111	089653	1
12	PODKŁADKA 11/30-3 CYNK	088787-1	2
13	ŚRUBA M10X16-8.8 FE/ZN5 PN-M/82105	F81003-13	2
	SKROBAK KPL.	515518	2
14	BLACHA DOCISKOWA ZGARNIACZA	515024-1	1
15	SKROBAK PROWADNIKA POSUWU P/T	515022	1
16	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	1
17	ŚRUBA M6X25 5.8 FE/ZN5 PN-85/M-82105	F81001-3	1
18	ZESPÓŁ ROLEK JEZDNYCH Patrz Rozdział 9.7	515615	1
19	OSŁONA GÓRNEJ ZĘBATKI GŁOWICY LT15-MALOWANA	092567-1	1
20	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	5
21	ŚRUBA M6X12 8.8 FE/ZN5 PN-85/M-82105	F81001-7	2
22	KÓŁKO BLOKADY POSUWU STRUG.	501957-1	1
23	OSŁONA RĘKOJEŚCI REWA 91626	086875	2
	BLOKADA POSUWU G/D STRUGARKI	502502	1
24	UCHWYT BLOKADY	090273	1
25	TULEJKA DOCISKU BLOKADY STRUGARKI	502501	1
26	UCHWYT BLOKADY POSUWU G/D	502497	1
27	ŚRUBA IMB. M6X35 8.8 FE/ZN5 PN-M/82302	F81001-23	1
28	KOSTKA BLOKADY G/D STRUGARKI	501964	1
29	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	1
30	NAKRĘTKA M6 8 FE/ZN5 PN-85/M-82144	F81031-1	2
	OSŁONA DOLNA STRUGARKI, KPL.	501958	1
31	PLYTA OSŁONA STRUGARKI	502536	1
32	UCHWYT BOCZNY, OSŁONA DOLNA STRUGARKI	502517-1	2
33	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	6
34	NAKRĘTKA M8 8 FE/ZN5 PN-85/M-82175	F81032-2	2
35	ŚRUBA M8X25-8.8-B-FE/ZN5 PN/M-82105.	F81002-5	4
36	KÓŁEK WALCOWY 4M6X20 DIN 6325 HRC60	F81048-82	1
37	KÓŁEK SPRĘŻYSTY 6X50 FE/ZN5 PN-M/85023	F81045-1	1
	KORBA NAPĘDU - KPL.	508239	1
38	KORBA NAPĘDU JAZDY- MALOWANA	508238-1	1
39	RĘKOJEŚĆ OBROTOWA L=85 M10, RO11-M10.	086338	1
40	NAKRĘTKA M10 Z WKŁADKĄ POLIAMIDOWA	F81033-1	1
41	TULEJKA GFM 1719-25 (IGUS).	094142	2
42	SPRĘŻYNA 0,75 LTH	P32011	1
43	DŹWIGNIA ZAŁĄCZENIA NAPĘDU SPAW. - MAL.	097221-1	1
44	NAKRĘTKA M6-8-B-FE/ZN5 PN-85/M-82175.	F81031-2	1
45	ŚRUBA M6X50-8.8-FE/ZN5 PN-M/82101	F81001-62	1

9.7 Zespół rolek jezdnych



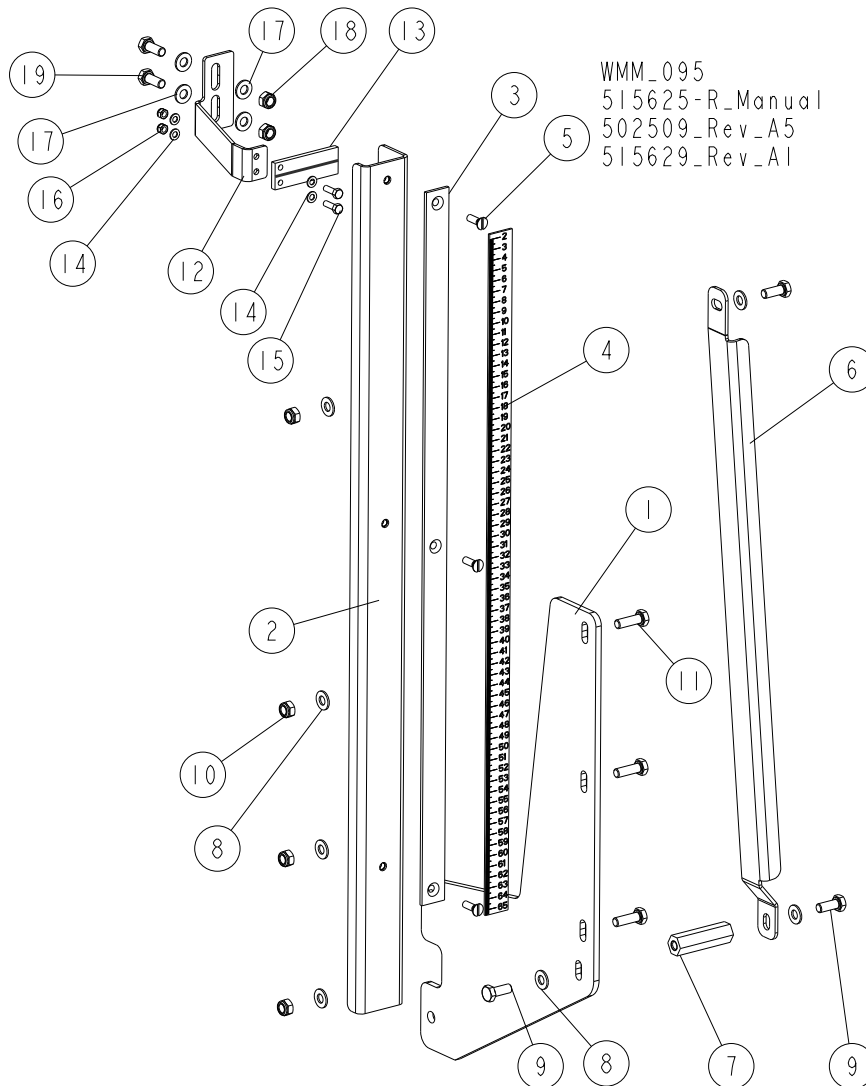
LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	ZESPÓŁ ROLEK JEZDNYCH	515615	1
1	WSPORNIK ROLEK JEZDNYCH	515614-1	1
2	NITONAKRĘTKA M8 - OTWARTA/KOŁNIERZ STOŻ.-AL	F81032-10	2
3	NITONAKR. NIERDZ. M6 1.5-4.0 STOŻ.	F81031-9	2
4	SWORZEŃ ROLKI REGULOWANEJ	515611	2
	SKROBAK KPL.	515518	2
5	BLACHA DOCISKOWA ZGARNIACZA	515024-1	1
6	SKROBAK PROWADNIKA POSUWU P/T	515022	1
7	PODKŁADKA 6.4 FE/ZN5 PN-78/M-82005	F81053-1	1
8	ŚRUBA M6X25 5.8 FE/ZN5 PN-85/M-82105	F81001-3	1
9	PODKŁADKA 11/30-3 CYNK	088787-1	2
10	ŚRUBA M10X16-8.8 FE/ZN5 PN-M/82105	F81003-13	2
	ROLKA PROWADZĄCA MASZT	515015	2
11	ROLKA PROWADZĄCA	514889	1
12	ŁOŻYSKO TOCZNE 6204 2RS CX.	088447	2

LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ	
13	PIERŚCIEŃ OSADCZY W 47, PN-81/M-85111	089653	1	
14	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	12	
15	NAKRĘTKA M8-8-B-FE/ZN5 PN/M-82144.	F81032-1	3	
16	ŚRUBA M8X90-8.8 FE/ZN5 PN-85/M-82105	F81002-16	1	
17	ŚRUBA M8X16-8.8-B-FE/ZN5	F81002-20	4	
18	WKRĘT DOCISKOWY NIERDZEWNY M10X1X20 DIN 913	F81015-1	4	
19	PŁYTA PROWADZĄCA MASZT	515616-1	1	
20	PODKŁADKA SPRĘŻYSTA 8.2 FE/ZN5 PN-M/82008	F81054-4	2	
21	ŚRUBA M8X20 5.8 FE/ZN5 PN-85/M-82105	F81002-1	2	

9.8 Wspornik przewodu zasilającego


LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	WSPORNIK PRZEWODU ZASILAJACEGO LT15, KPL.	097449	1
1	WSPORNIK PRZEWODU ZAS. MAL. LT15	086132-1	1
2	WKŁADKA DO RURY 50X30 GR 1-3 NR KAT 111366.	095919	2
3	UCHWYT-OPASKA ZACISKOWA PLASTYKOWA	F81082-1	2
4	PODKŁADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	4
5	NAKRĘTKA M4-8-FE/ZN5 PN/M-82175.	F81029-1	2
6	WKRĘT M4X16 5.8-B FE/ZN5, PN-M/82202.	F81011-42	2

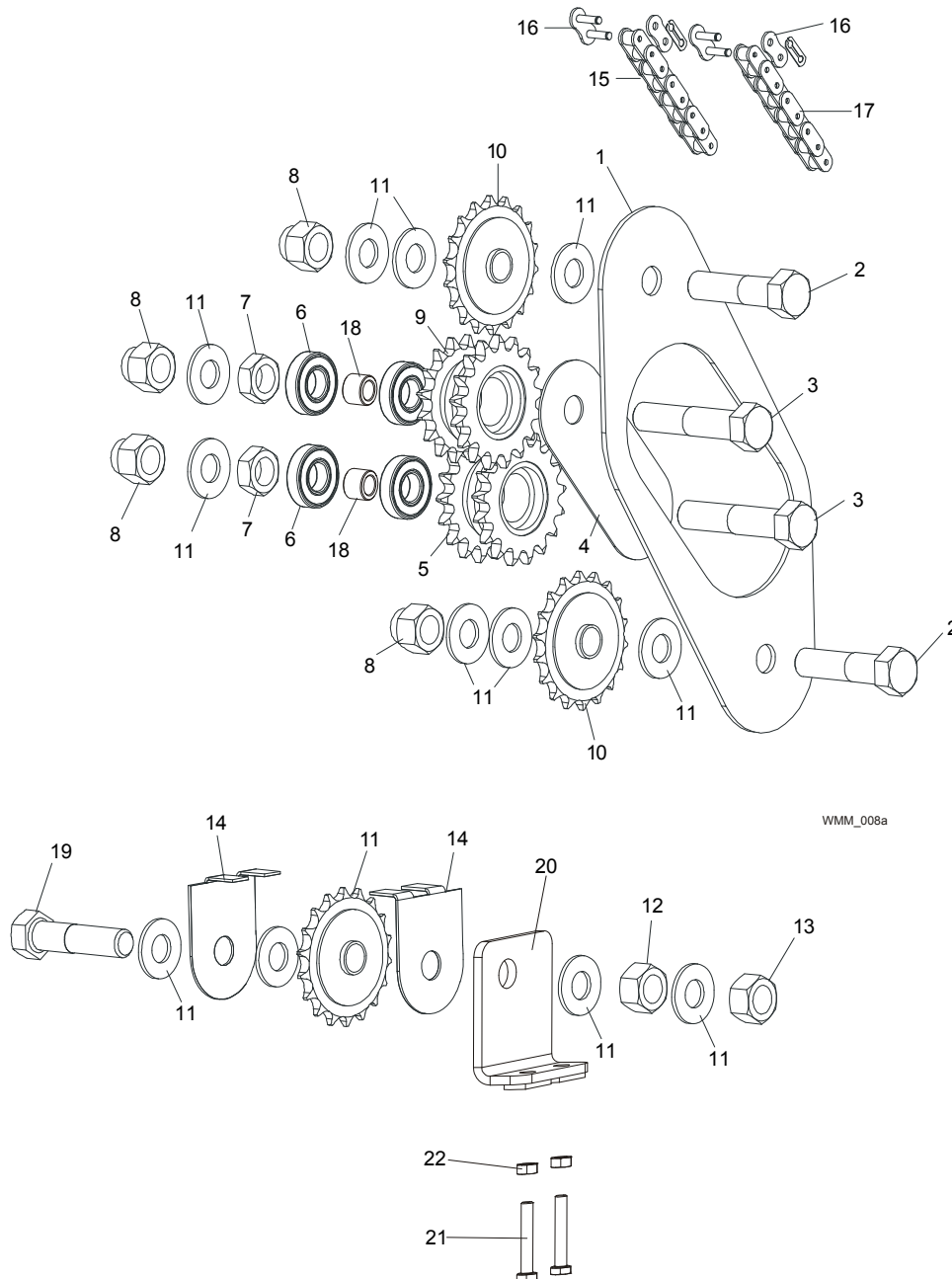
9.9 Skala i wskaźnik wysokości położenia freza



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	SKALA STRUGARKI G/D KOMPL.	502509	1
1	PODSTAWA SKALI, MALOWANA.	502515-1	1
2	UCHYT SKALI STRUGARKI SPAW.MAL	502508-1	1
3	PŁASKOWNIK SKALI	502506	1
4	SKALA WYSOKOŚCI STRUGARKI	502505	1
5	WKRĘT M6X20-5.8-B-FE/ZN5 PN-85/M-82207.	F81001-31	3
6	WSPORNIK SKALI, MALOWANY.	501988-1	1
7	PRĘT DYSTANSOWY STRUGARKI	502532-1	1
8	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	10
9	ŚRUBA M8X20 8.8 FE/ZN5 PN-85/M-82105	F81002-4	3
10	NAKRĘTKA M8 8 FE/ZN5 PN-85/M-82175	F81032-2	4
11	ŚRUBA M8X25-8.8-B-FE/ZN5 PN/M-82105.	F81002-5	3
	WSKAŹNIK KPL. DO STRUGARKI MP100EH11-R	515629	1
12	WSPORNIK WSKAŹNIKA PODZIAŁKI	515624-1	1

LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ	
13	WSKAŹNIK PODZIAŁKI	094821	1	
14	PODKŁADKA 5.3 FE/ZN5 PN-78/M-82005	F81052-1	4	
15	ŚRUBA M5X16 8.8 FE/ZN5	F81000-20	2	
16	NAKRĘTKA M5-8-FE/ZN5 DIN985	F81030-2	2	
17	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	4	
18	NAKRĘTKA M8 8 FE/ZN5 PN-85/M-82175	F81032-2	2	
19	ŚRUBA M8X20 8.8 FE/ZN5 PN-85/M-82105	F81002-4	2	

9.10 Zespół kół zębatych do napędu posuwu góra/dół,

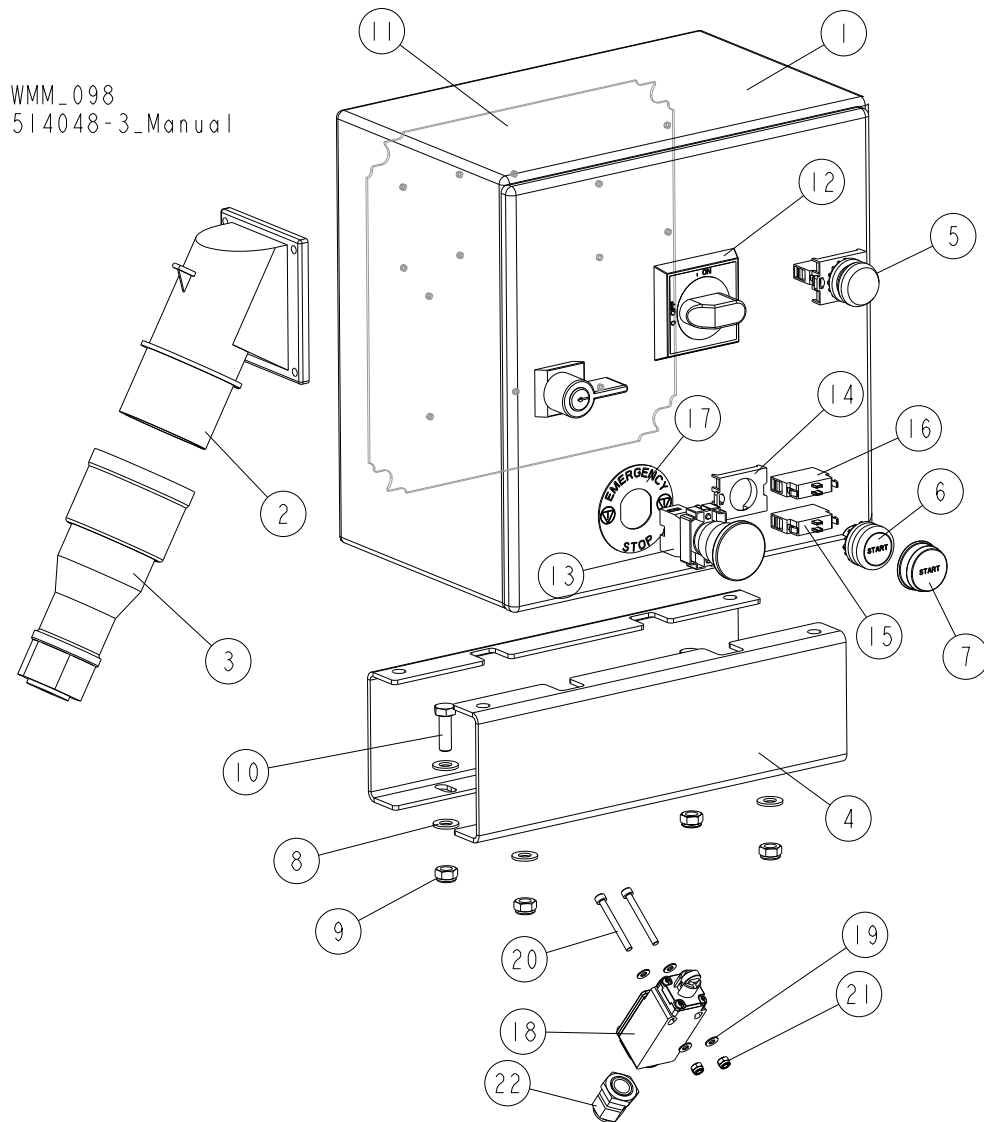


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LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
1	OSŁONA ŁAŃCUCHA POSUWU G/D WEWN LT15	014907-1	1
2	ŚRUBA M16X65-8.8-B- FE/ZN5 PN-M/82105	F81006-1	2
3	ŚRUBA M16X80 8.8-B- FE/ZN5 PN-M/82105	F81006-11	2
4	PŁYTKA MONTAŻOWA ZĘBATEK POSUWU GÓRA/DÓŁ STRONA NAPĘDOWA	087104-1	1
5	KOŁO ŁAŃCUCHOWE PODW. 17/17	086812-1	1
6	ŁOŻYSKO, R-10	P04156	4
7	NAKRĘTKA NISKA M16 FE/ZN5 8 PN-M/82153	F81036-4	2
8	NAKRĘTKA M16-8-FE/ZN5 PN-M/82175	F81036-2	4
9	KOŁO ŁAŃCUCHOWE PODWÓJNE 16/17	086813-1	1
10	KOŁO ZĘBATE ŁAŃCUCHOWE, 17T G1#40-41 5/8" S/W	P04333	3

11	PODKŁADKA OKR. 17 FE/ZN5 PN-M/82005	F81058-1	12	
12	NAKRĘTKA M16-5.8 -FE/ZN5 PN-M/82144	F81036-1	1	
13	NAKRĘTKA M16-8-FE/ZN5 PN-M/82175	F81036-2	1	
14	OSŁONA ZĘBATKI ŁAŃCUCHA LT15	092566-1	2	
15	ŁAŃCUCH ROLKI, #40 X 111 1/2"	014831	1	
16	ZAPINKA ŁAŃCUCHA, #40	P04200	2	
17	ŁAŃCUCH ROLKI, #40 X 14 1/2"	P12496	1	
18	TULEJKA - CYNKOWANA	095938-1	2	
19	ŚRUBA M16x80 8.8-B- Fe/Zn5 PN-M/82105	F81006-11	1	
20	NAPINACZ SPAW/MALOW	502525-1	1	
21	ŚRUBA M6x40-8.8-Fe/Zn5 PN-M/82105	F81001-5	2	
22	NAKRĘTKA M6-8-Fe/Zn5 PN-M/82144	F81031-1	2	

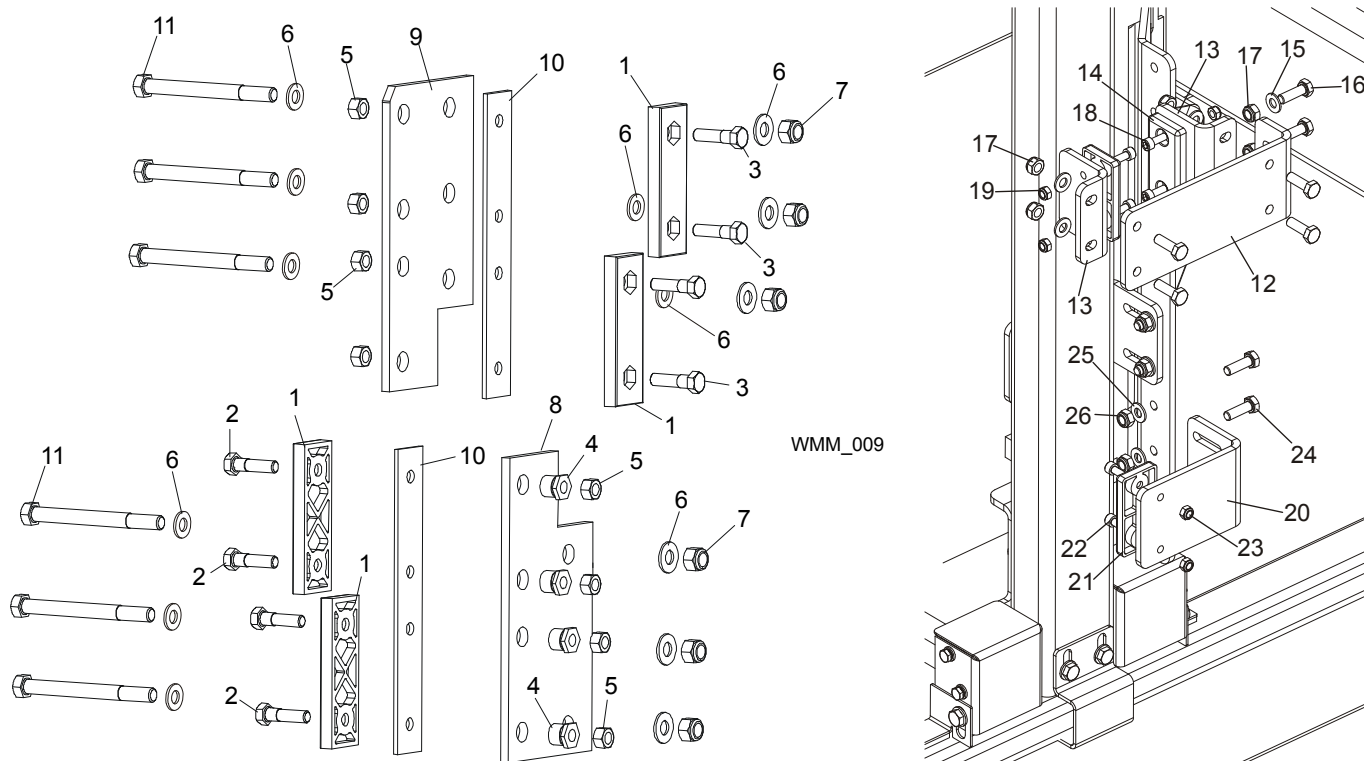
9.11 Skrzynka elektryczna MP100-R



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	SKRZYNNKA ELEKTRYCZNA MP100 E11	514049	1
1	SKRZYNNKA EL. HYDRAULIKI AC 4KW	088266	1
2	WTYCZKA ZASILANIA 16A 5P 778152-6 PCE.	E85239	1
3	GNIAZDO PRZENOŚNE 16A 5P 2152-6TT PCE.	E85240	1
4	NOGA SKRZYNNKI ELEKTRYCZNEJ	505604-1	2
5	LAMPKA KONTR. M22 NIEBIESKA LED 24V	090448	1
6	PRZYCISK "START" ZIEL. PODSW. M22 DO OBUDOW	094315	1
7	MEMBRANA PRZYCISKOWA IP67 M22-T-D	094316	1
8	PODKŁADKA 8.4 FE/ZN5 PN-78/M-82005	F81054-1	8
9	NAKRĘTKA M8 8 FE/ZN5 PN-85/M-82175	F81032-2	4
10	ŚRUBA M8X25-8.8-B-FE/ZN5 PN/M-82105.	F81002-5	4
11	PŁYTA MONTAŻOWA SKRZ. EL.	507750	1
12	POKRĘTŁO WYŁĄCZNIKA OHB S2A1 AB	502312-1	1

LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ	
13	WYŁĄCZNIK AWARYJNY XB4 BS542	086556	1	
14	ŁĄCZNIK M22-A	100905	1	
15	ELEMENT LED M22 LED-G	501004	1	
16	ELEMENT STYKOWY M22 K10 MOELLER	091362	1	
17	PODKŁADKA POD WYŁĄCZNIK BEZP.	086561	1	
18	WYŁĄCZNIK KRAŃCOWY GLCB01C	100910	1	
19	PODKŁADKA 4.3 FE/ZN5 PN-78/M-82005	F81051-2	4	
20	ŚRUBA IMB.M4X40 8.8 FE/ZN PN-87/M-82302	F81011-37	2	
21	NAKRĘTKA M4-8-FE/ZN5 PN/M-82175.	F81029-1	2	
22	DŁAWIK DP9/H	F81096-2	1	

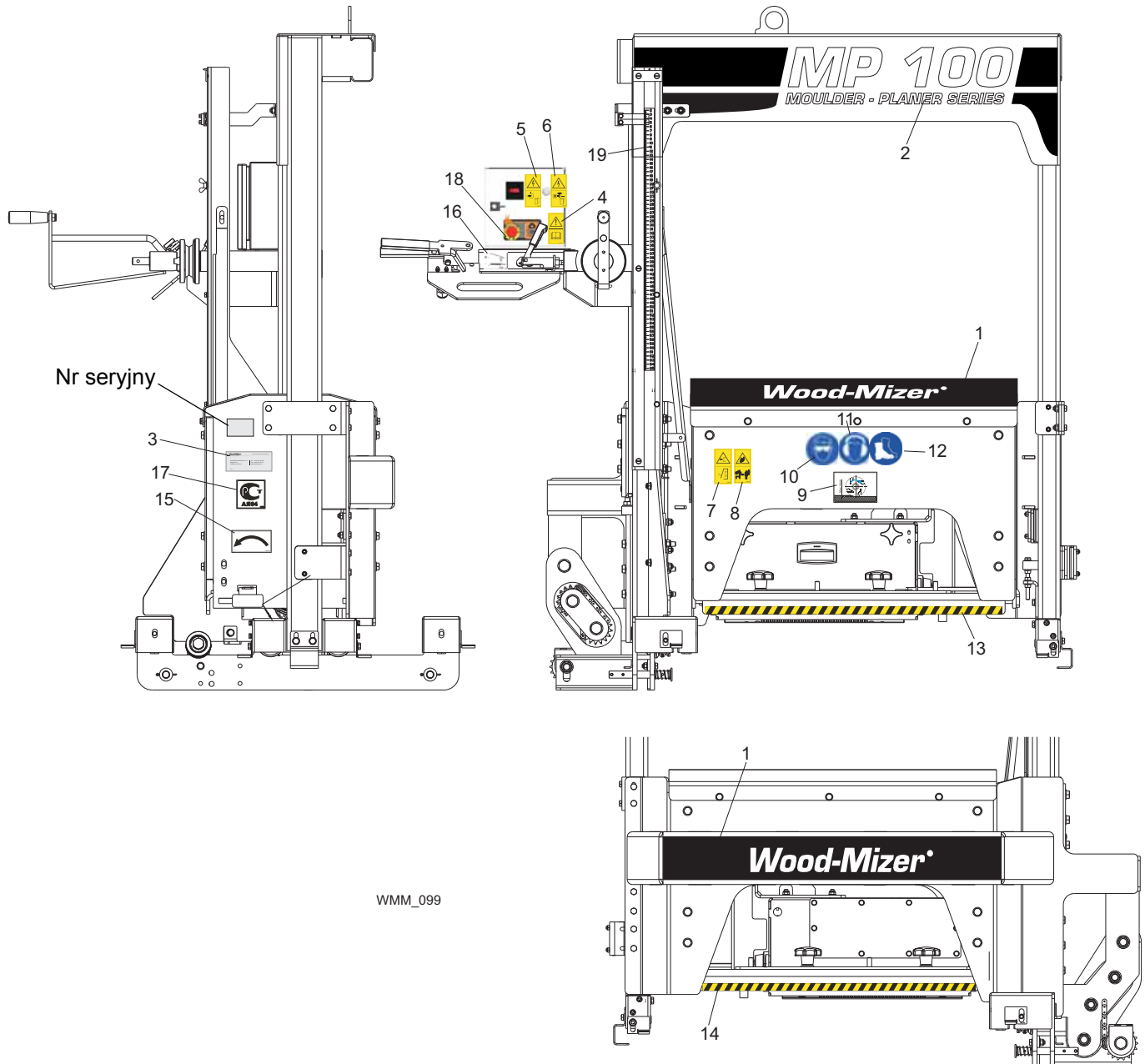
9.12 Wkładki poślizgowe



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
1	WKŁADKA POŚLIZGOWA UKŁADU POSUWU GÓRA/DÓŁ	M04096	4
2	ŚRUBA M8X35-8.8-FE/ZN5 PN-M/82105	F81002-13	4
3	ŚRUBA M8X20-8.8-FE/ZN5 PN-M/82105	F81002-4	4
4	WKRETKA REGULACYJNA PROW. GŁ. LT15 CYNK.	086683-1	4
5	NAKRĘTKA, M8-8-B-FEZN5 Z WKŁ. PN-M/82175	F81032-2	8
6	PODKŁADKA OKR. 10,5 FE/ZN5 PN-78/M-82005	F81055-1	12
7	NAKRĘTKA Z WKŁ. M10-8-B -FE/ZN PN-M82175	F81033-1	8
8	PŁYTA PROWADNICY GŁ. LT15	086682-1	1
9	PŁYTA PROWADNIKA GÓRNEGO	094139-1	1
10	PŁYTA DYSTANSOWA ŚLIZGU	094140-1	2
11	ŚRUBA M10x115-8.8 Fe/Zn5 PN-M/82101	F81003-19	6
	ŚLIZGACZ GÓRNY	502503	1
12	WSPORNIK ŚLIZGACZA	501902-1	1
13	WSPORNIK GÓRA ŚLIZGACZA	501903-1	2
14	WKŁADKA POŚLIZGOWA	P13576	2
15	PODKŁADKA OKRĄGŁA 8,4-Fe/Zn5 PN-M/82005	F81054-1	10
16	ŚRUBA M8x25-8.8-B-Fe/Zn5 PN-M/82105	F81002-5	6
17	NAKRĘTKA M8-8-B-FeZn5 Z WKŁ. PN-M/82175	F81032-2	6
18	ŚRUBA IMB. M6x16 -8.8- Fe/Zn5 PN-M/82302	F81001-21	4
19	NAKRĘTKA M6-8-B-Fe/Zn5 PN-M/82175	F81031-2	4
	ŚLIZGACZ DOLNY	502504	2
20	WSPORNIK PROWADNIKA PRAWY	501991-1	1

21	WKŁADKA POŚLIGZOWA	P13576	1	
22	ŚRUBA IMB. M6x16 -8.8- Fe/Zn5 PN-M/82302	F81001-21	2	
23	NAKRĘTKA M6-8-B-Fe/Zn5 PN-M/82175	F81031-2	2	
24	ŚRUBA M8x25-8.8-B-Fe/Zn5 PN-M/82105	F81002-5	4	
25	PODKŁADKA OKRĄGŁA 8,4-Fe/Zn5 PN-M/82005	F81054-1	4	
26	NAKRĘTKA M8-8-B-FeZn5 Z WKŁ. PN-M/82175	F81032-2	4	

9.13 Nalepki ostrzegawcze i informacyjne strugarki

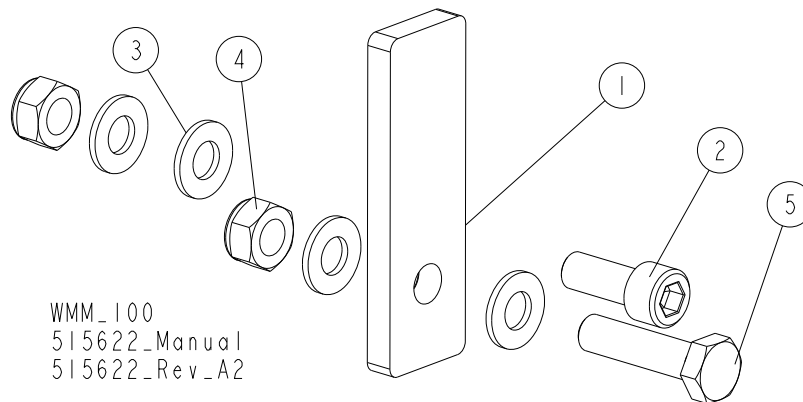


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LP.	OPIS (♦ wskazuje części dostępne jedynie w zespołach)	NUMER KAT.	SZT.
	ZESTAW NALEPEK STRUGARKI MP100-R	516126	1
1	NALEPKA, WOOD-MIZER STRUGARKI	502581	2
2	NALEPKA, TYP STRUGARKI MP100	502582	1
3	NALEPKA ADRES SIEDZIBY ODDZIAŁU EUROPA	015841	1
4	NALEPKA, CZYTAJ INSTRUKCJE OBSŁUGI, PIKTOGRAM	096317	1
5	NALEPKA, WYSOKIE NAPIĘCIE W SKRZ. EL. - PIKTOGRAM	096316	1
6	NALEPKA, WYCIĄGNIJ WTYCZKĘ PRZED OTW. SKRZ. EL. - PIKTOGRAM	096319	1
7	NALEPKA, PRACA BEZ ZABEZP. ZABRONIONA, PIKTOGRAM	099220	1
8	NALEPKA, ZACHOWAJ BEZP. ODLEGŁOŚĆ, PIKTOGRAM	099221	1
9	NALEPKA, MAKSYMALNA GRUBOŚĆ SKRAWANIA	502423	1
10	NALEPKA, OCHRONIAJ WZROK, PIKTOGRAM	S12004G	1
11	NALEPKA, OCHRONA SŁUCHU, PIKTOGRAM	S12005G	1

12	NALEPKA, UŻYWAJ OBUWIE OCHRONNE PIKTOGRAM	501465	1	
13	NALEPKA, PASEK OSTRZEG. CZARNO-ŻÓŁTY	087649	1	
14	NALEPKA, PASEK OSTRZEG. CZARNO-ŻÓŁTY	502481	1	
15	NALEPKA KIERUNKU OBROTÓW	089296	1	
16	NALEPKA, DŹWIGNIA BEZPIECZEŃSTWA	501477	1	
17	NALEPKA, TRAK Z CERTYFIKACJĄ ROSYJSKA	099401	1	
18	NALEPKA SKRZYŃKI EL. HEBLARKI	502320-4	1	
19	NALEPKA, SKALA WYSOKOŚCI HEBLARKI	502505	1	

9.14 Zespół ogranicznika



LP	OPIS (◆ Wskazuje części dostępne jedynie w zespołach)	NR CZĘŚCI	ILOŚĆ
	ZESPÓŁ OGRANICZNIKA DO MP100EH11-R	515622	1
1	OGRANICZNIK DO MP100EH11-R	515621-1	1
2	ŚRUBA IMB. M10X25 8.8 FE/ZN5 PN-M/82302	F81003-32	1
3	PODKŁADKA OKR. 10,5 FE/ZN5 PN-78/M-82005	F81055-1	5
4	NAKRĘTKA M10 Z WKŁADKA POLIAMIDOWA	F81033-1	2
5	ŚRUBA M10X40-8.8 FE/ZN5 PN-M/82105	F81003-16	1

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

We herewith declare,

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

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

Designation of the machine:

Log Moulder

TYPE:

MP100EH5S-1, MP150EH5S-1

No. of manufacturer:

.....

Applicable EC Directives:

EC Machinery Directive 2006/42/EC
EC Electromagnetic Compatibility Directive
2004/108/EC

Used harmonized standards:

PN-EN ISO 12100:2012
PN-EN 861+A2:2012
PN-EN ISO 13849-1:2008
PN-EN 60204-1:2010
PN-EN ISO 13857:2010

Notified Body according to annex IV :

INSTYTUT TECHNOLOGII DREWNA
Centrum Certyfikacji Wyrobów Przemysłu Drzewnego
ul. Winiarska 1, 60-654 Poznań

Notification No:

1583

Responsible for:

EC type examination

EC type-examination certificate no.

0418/2015

Responsible for Technical Documentation:

Adam Kubiak / R&D Manager
Wood-Mizer Industries Sp. z o.o.
62-600 Koło, ul. Nagórna 114, Poland
Tel. +48 63 26 26 000

Place/Date/Authorized Signature:

Koło, 30.01.2015 **Adam Kubiak**

Title :

R&D Manager