

AC Debarker Option

Safety, Installation, Operation, Maintenance & Parts Manual

MKII for LT70 AC Sawmills rev. D.2



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

Form #961

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SECTION 1 SAFETY & GENERAL INFORMATION



This symbol calls your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions. This symbol accompanies a signal word. The word **DANGER** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. **WARNING** suggests a potentially hazardous situation which, if not avoided, could result in death or serious injury. **CAUTION** refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury to persons or equipment. Read all safety instructions before operating this equipment and observe all safety warnings!

1.1 Installation and Maintenance



DANGER! On electric mills, hazardous voltage inside the disconnect box, starter box, and at the electric motor can cause shock, burns, or death. Disconnect and lock out power supply before performing debarker installation! Follow all applicable electrical codes.

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. Failure to do so will result in serious injury or death.

DANGER! Before performing any service to this equipment, turn the key to the OFF position, remove the key, and disconnect the sawmill battery ground terminal. Failure to do so will result in serious injury or death.



WARNING! Before replacing the debarker blade, move the sawmill blade guide arm in front of the sawmill blade to cover the blade teeth. Failure to do so may result in serious injury or death.

1.2 Operation and Towing



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

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

DANGER! Always remove the key from the control panel before preparing the debarker for towing. Failure to do so may result in serious injury.



WARNING! Debarker is ON when warning bell sounds. DO NOT disconnect the warning bell. Doing so may result in serious injury.

WARNING! If the debarker continues to run with the key switch in the OFF position, remove the negative battery terminal from the battery post.

DO NOT continue to operate the mill if the main key switch does not control debarker operation. Doing so could result in serious injury. Call Wood-Mizer customer service for more information.

SECTION 2 DEBARKER INSTALLATION



DANGER! On electric mills, hazardous voltage inside the disconnect box, starter box, and at the electric motor can cause shock, burns, or death. Disconnect and lock out power supply before performing debarker installation! Follow all applicable electrical codes.

DANGER! Before performing any service to this equipment, turn the key to the OFF (0) position, remove the key, and disconnect the sawmill battery ground terminal. Failure to do so will result in serious injury or death.



CAUTION! Due to various design changes and past retrofits and options, you should very carefully look your mill over to determine Debarker compatibility before beginning Debarker installation.

2

Debarker Installation

Debarker Frame Mounting Holes

2.1 Debarker Frame Mounting Holes

IMPORTANT! Sawmills are equipped with pre-drilled Debarker mounting holes. **Verify hole locations before beginning Debarker installation. Proper hole location is imperative for safe and effective Debarker operation.**

2.2 Debarker Installation

NOTE: You will not use all components of the debarker bag assembly during installation. Excess hardware is included to cover all possible mill variations and needs.

1. Remove the four pre-installed bolts and nuts from the debarker frame mounting blocks.
2. Assemble the debarker to the sawmill saw head. Align the mounting block holes and the holes in the saw head. Insert the bolts from the back of the saw head, through the debarker mounting block holes. Use the lock nuts to secure in place. Tighten the mounting bolts to 20 ft.-lbs. torque. Do not tighten the set screws in the mounting blocks until debarker alignment has been performed.

NOTE: When installing, make sure the blade guide motor wire harness is routed between the saw head and the pivot arm.

See Figure 2-1.

2 Debarker Installation

Debarker Installation

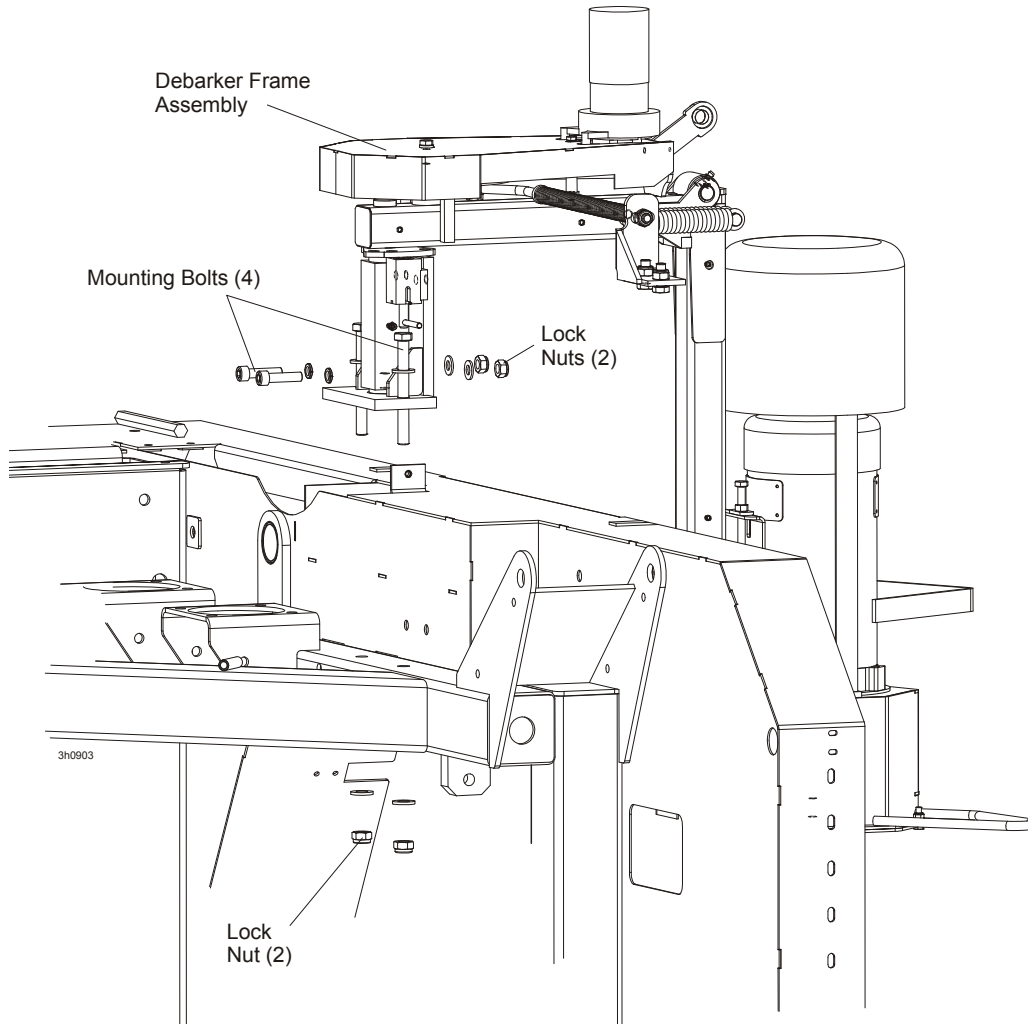


FIG. 2-1

3. Assemble the debarker cutting head to the mount plate on the frame. Use the four provided M8x35-8.8 bolts, 8.4 split lock washers and M8-8-B nuts to mount the cutting head to the debarker frame. Use the lower set of four holes in the head mounting plate. The upper set of holes are provided in the event the cutting head needs to be adjusted further down than the slotted motor mount holes will allow.

See Figure 2-2.

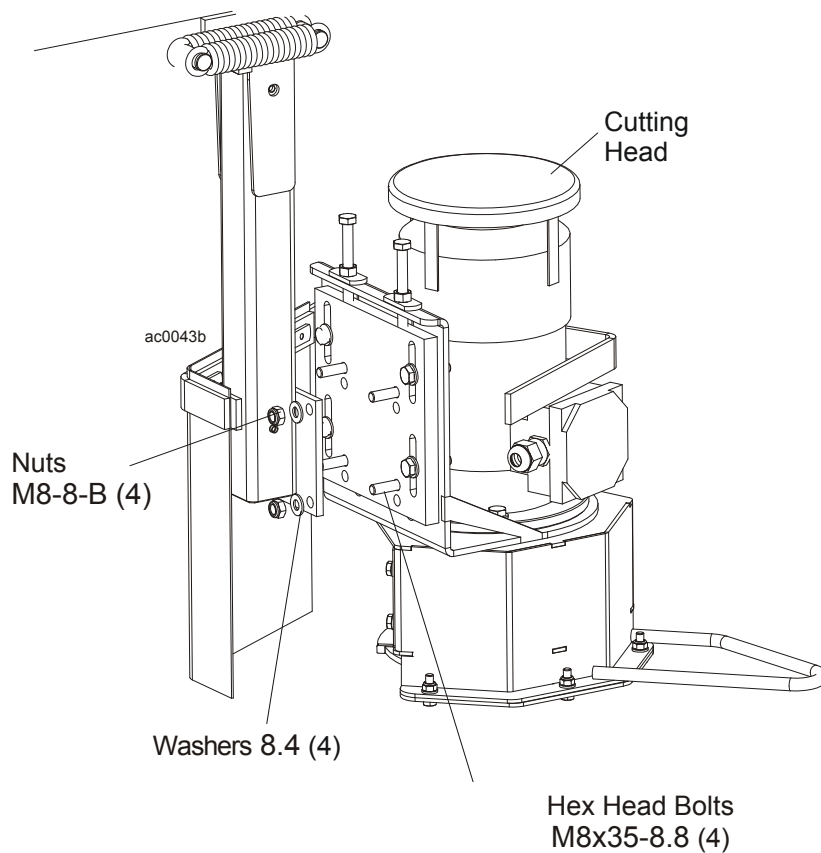


FIG. 2-2

2 Debarker Installation

Debarker Installation

4. Install the spring arm assembly to the debarker in/out pulley using the M10x45-8.8 hex head bolt, two flat washers, and two lock nuts provided.
5. Remove the idle-side blade housing cover. Align the two holes in the spring arm bracket with the two holes in the top of the saw head blade housing. Use the provided M10x25-8.8 hex head bolts and M10-8 nylon lock nuts to secure the spring arm bracket saw head. Replace the blade housing cover. Close the middle blade housing cover.

See Figure 2-3.

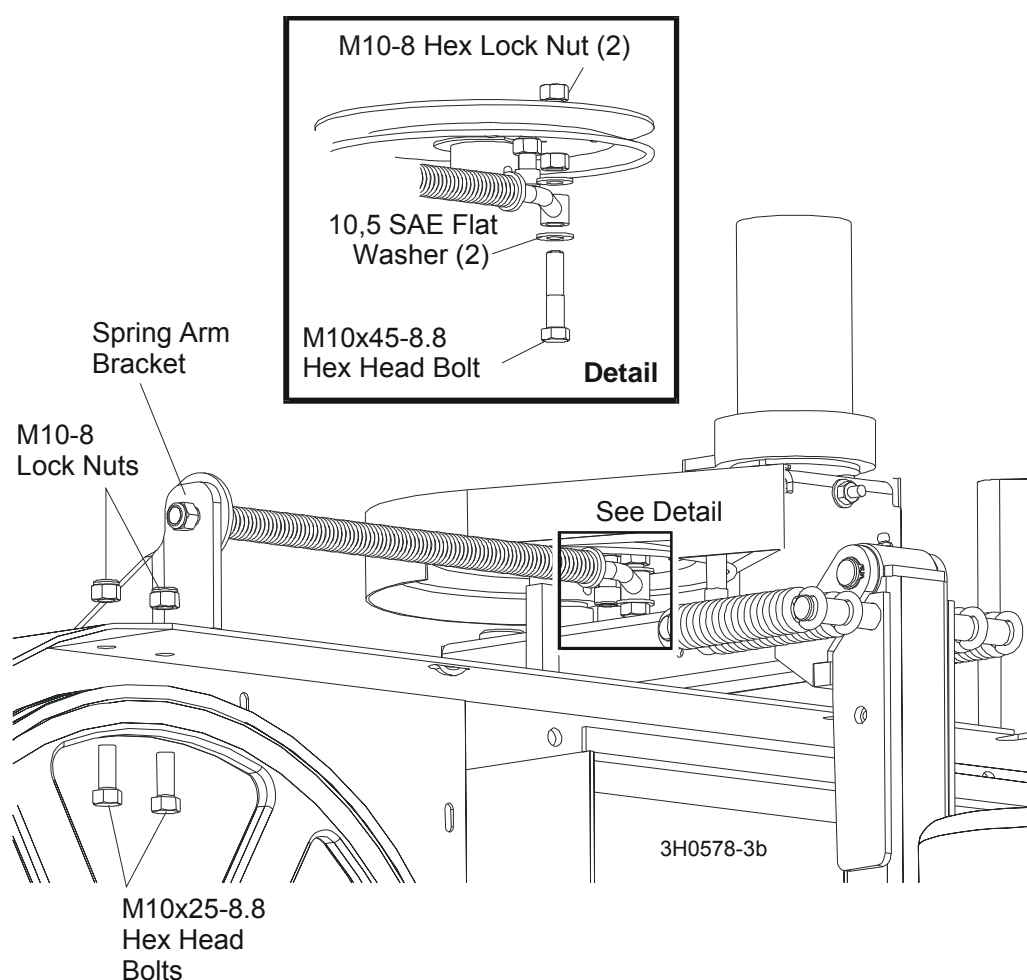


FIG. 2-3

6. Install the blade guard bracket and flexible debris guard to the debarker head with two 6.4 flat washers, lock washers, and M6x16 8.8 hex head bolts. Be sure the bottom of the debris guard is even with the bottom of the debarker blade.

See Figure 2-4.

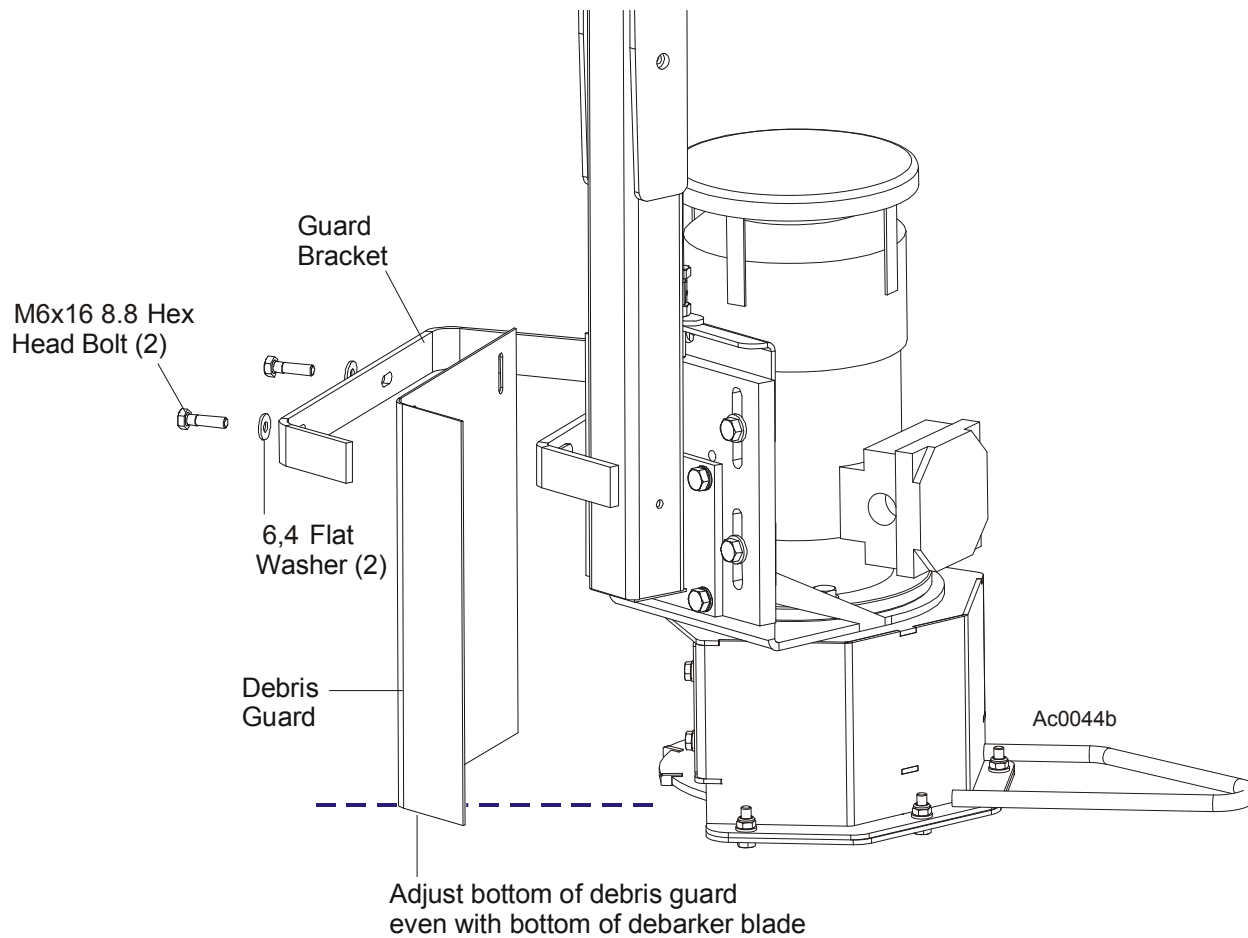


FIG. 2-4

2.3 Wiring Instructions



DANGER! On electric mills, hazardous voltage inside the disconnect box, starter box, and at the electric motor can cause shock, burns, or death. Disconnect and lock out power! Follow all applicable electrical codes.

DANGER! Before performing any service to this equipment, turn the key to the OFF (0) position, remove the key, and disconnect the sawmill battery ground terminal. Failure to do so will result in serious injury or death.



IMPORTANT! Avoid pinch and pivot points, unnecessary wire bending and open spaces where the wire could get caught by a log, etc. If you have any questions, call Wood-Mizer customer service.

1. The debarker wires are pre-wired for the debarker option. The debarker wires are pre-routed and stored under a guard which is removed before debarker installation ([See Section 2.2](#)).
2. Route the harness between the debarker mount and saw head as shown. Slide the harness through one of the supplied harness clamps until about 75 mm (3") of the harness protrudes past the clamp. Install the clamp at location #1 on the debarker frame with a 1/4" flat washer and 1/4-20 x 1/2" hex head bolt.

See Figure 2-5.

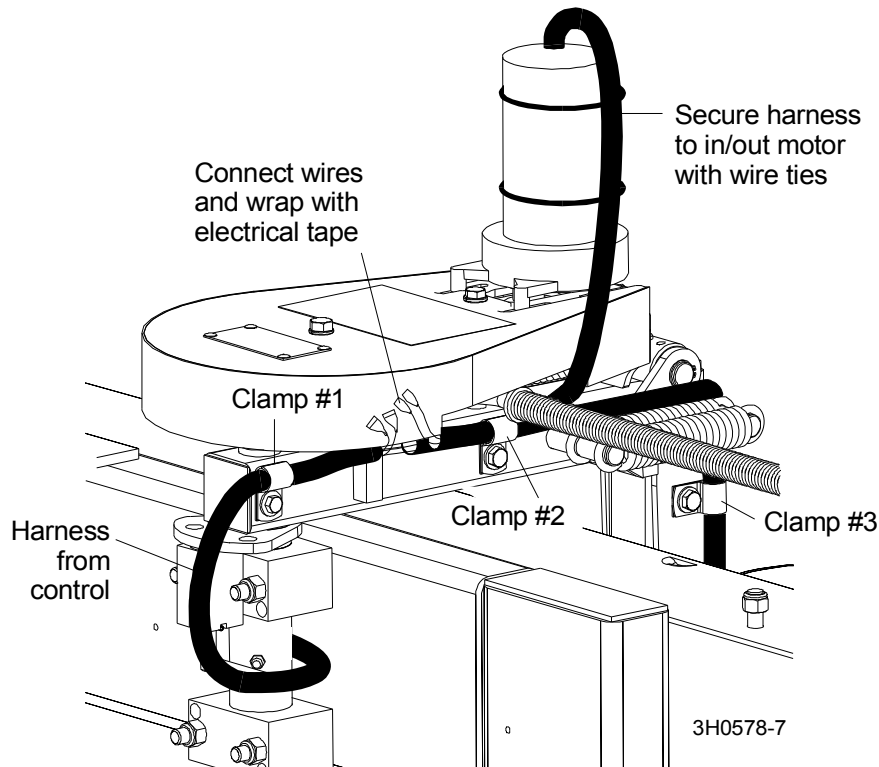


FIG. 2-5

3. Route the two long wires through the remaining long section of conduit. Slide the harness through two harness clamps and secure at #2 and #3 locations on the debarker frame with 1/4" flat washers and 1/4-20 x 7/8" hex head bolts. Be sure to leave enough slack in the harness to allow the debarker its full range of movement and also to prevent undue wire stress from sharply bent wires.
4. Install the shortest piece of conduit over the red and black debarker in/out motor wires.
5. Route the cable underneath the spring arm, through harness clamp #2, to the control cable.
6. Use two of the provided wire ties to secure the harness to the side of the drive motor.
7. Strip the end of the black drive motor wire and install a provided 1/4" male quick connect terminal.

Cut the red drive motor wire so it is 25 mm (1") shorter than the black drive motor wire, strip the end, and install a provided 1/4" male quick connect terminal. This will allow the wires to be neatly bundled together and wrapped later.

2

Debarker Installation

Wiring Instructions

8. Connect the red drive motor wire to the red control harness wire. Connect the black drive motor wire to the black control harness wire. Wrap the wire connections with electrical tape.
9. Slide the blade motor harness through a harness clamp and secure at location #4 on the debarker frame with a 1/4" flat washer and 1/4-20 x 7/8" hex head bolt.

See Figure 2-6.

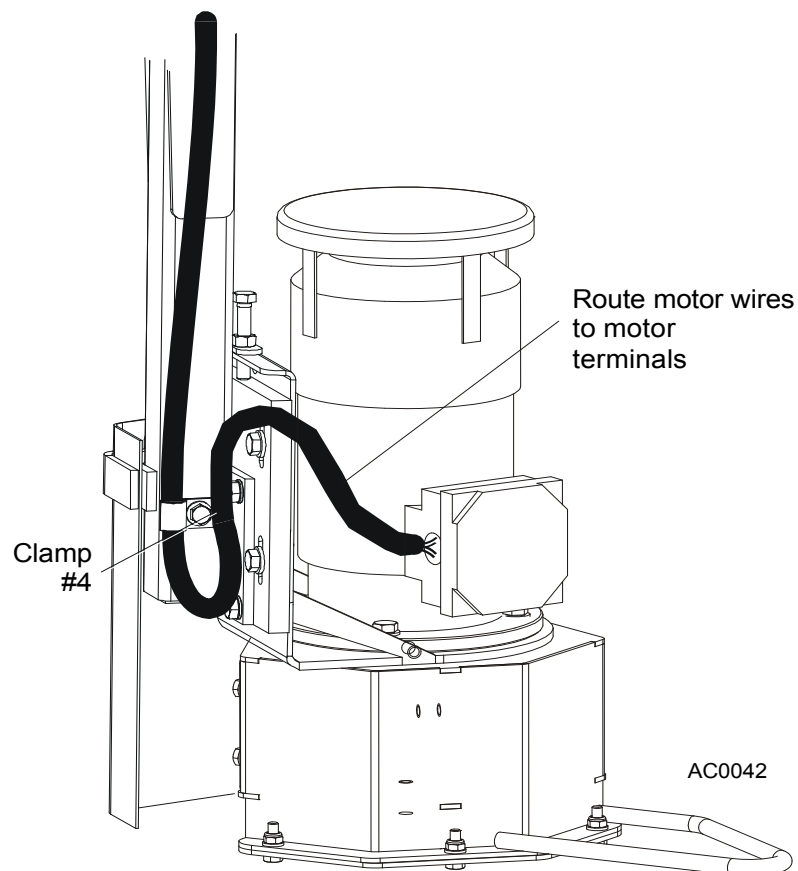


FIG. 2-6

10. Open the electric box installed to the debarker motor.
11. Slide the blade motor harness through a harness hole in the small electric box and connect wires as shown in the electrical diagrams ([See Section 4](#)).



IMPORTANT! Make sure that the ring terminals do not touch the motor body.

12. Replace all removed covers and guards.

2.4 Control Component Installation



DANGER! On electric mills, hazardous voltage inside the disconnect box, starter box, and at the electric motor can cause shock, burns, or death. Disconnect and lock out power! Follow all applicable electrical codes.

DANGER! Before performing any service to this equipment, turn the key to the OFF (0) position, remove the key, and disconnect the sawmill battery ground terminal. Failure to do so will result in serious injury or death.

1. Remove the front panel (leave wire connections) from the control box.
2. Locate the small red #21 and black #22 wires on the bottom of the control box.
3. Using the back side of the front panel for a guideline, cut out holes in the front panel lexan decal for the debarker switches. Install the provided toggle switches, the control lamp, 1/16" nylon washers, and rubber boots in place as shown.

2 Debarker Installation

Control Component Installation

See Figure 2-7.

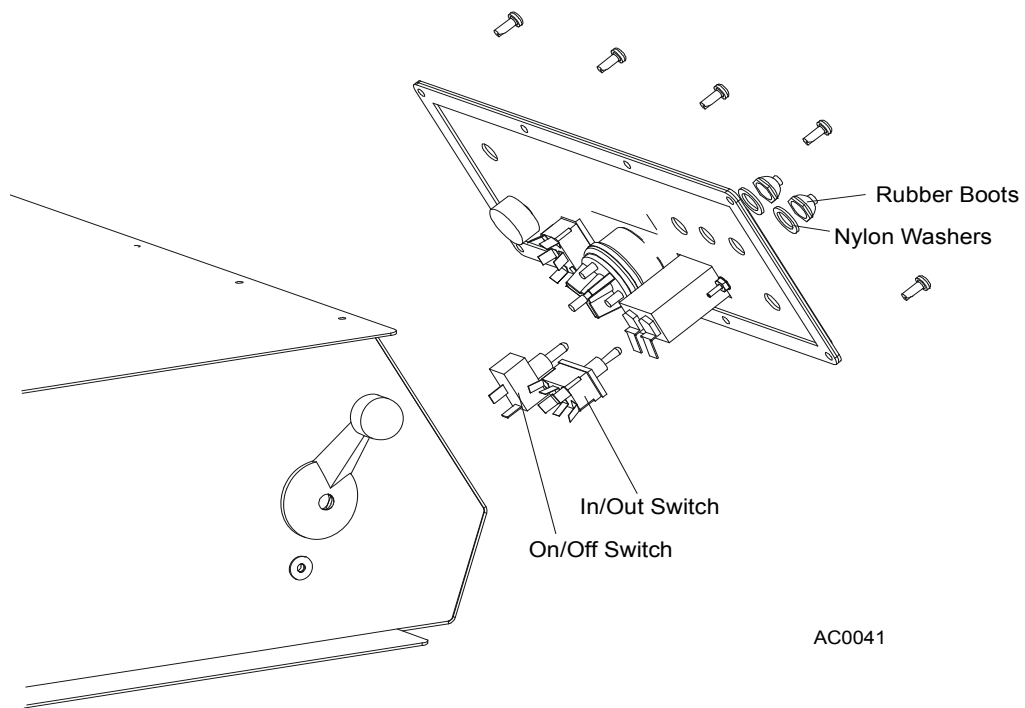


FIG. 2-7

4. Locate the bundle of wires on the floor of the sawmill control box. Make sure the debarker in/out switch is oriented horizontally as shown.

5. Connect the red wire from the debarker on/off switch to terminal #3 of the power feed drum switch.
6. Connect the black wire from the debarker in/out switch to the rear -12V white strip.
7. Connect the small red #21 wire to the debarker in/out switch bottom left terminal.
8. Connect the small black #22 wire to the debarker in/out switch top middle terminal.

See Figure 2-8. Box housing removed for clarity. Only wires referred to above are shown. Standard control box shown, Super model control differs slightly.

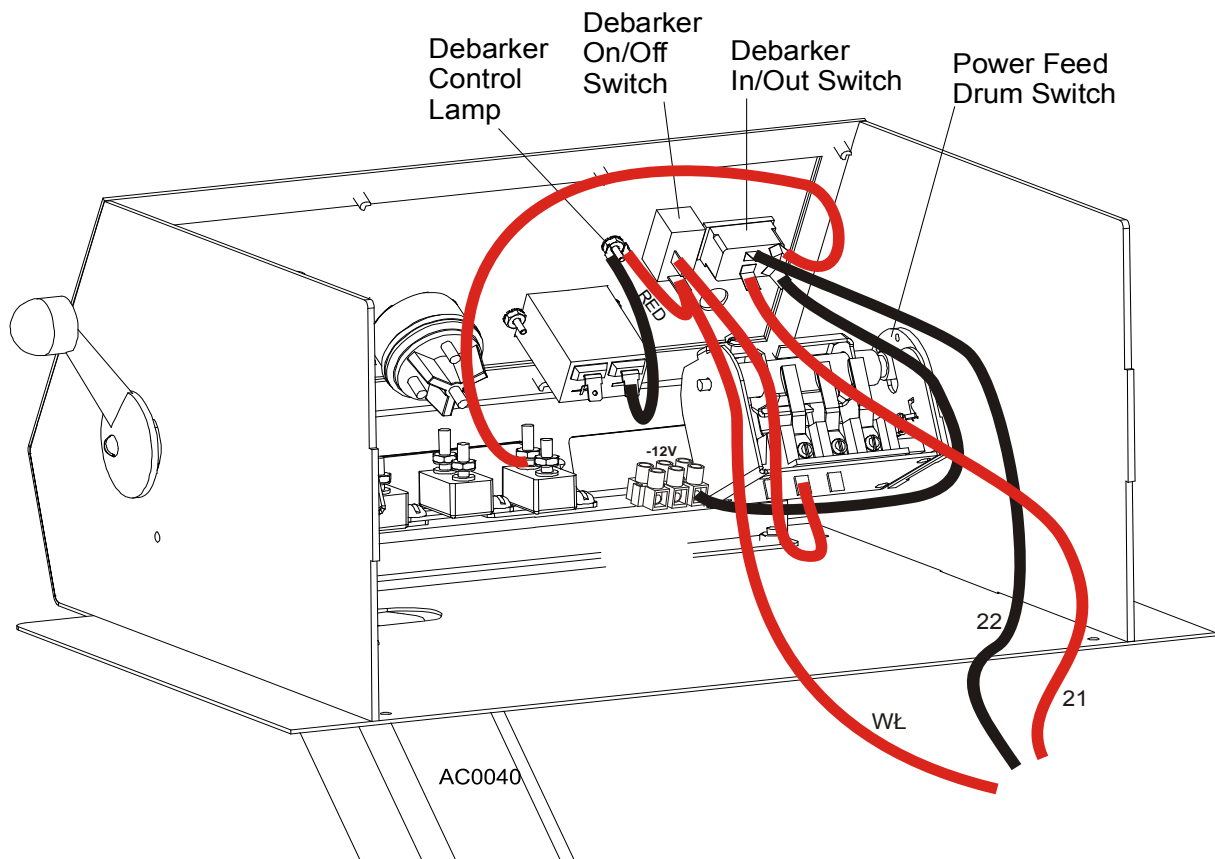


FIG. 2-8

9. Connect WŁ wire to the on/off switch.
10. Connect red wire from the debarker on/off switch WŁ connector to the debraker control lamp + connector.

2

Debarker Installation

Electric Box Installation

11. Connect red wire (not marked) to the debarker in/out switch terminal.
12. Connect black wire from the ground connector (-12V) to the Debarker In/Out Switch
13. Reinstall the front and rear panels, side panel, and control box top cover to the control box.

2.5 Electric Box Installation

1. Locate the debarker motor wire inside the electric box.
2. Connect the debarker motor wires to T1, T2 and T3 studs of the F5S thermal relay inside the electric box ([See Electrical Information](#)).
3. Any other debarker wires are pre-routed and proper connections are already made.

2.6 Alignment

DANGER! Before performing any service to this equipment, turn the key to the OFF (0) position and remove the key. Failure to do so will result in serious injury or death.

Two adjustments are required for proper debarker operation:

- The debarker blade should be centered with the sawmill blade.
 - The debarker blade should remain parallel to the sawmill blade throughout the debarker's range of motion.
1. Turn the key to ACC (3) and use the debarker in/out switch to move the debarker all the way in. Turn the key to OFF (0) and remove the key. This will prevent the debarker from being turned on while performing alignment procedures.
 2. Clip the blade guide alignment tool to the sawmill blade. Make sure the tool lies flat on the blade and does not contact a tooth that could cause it to angle.

See Figure 2-9.

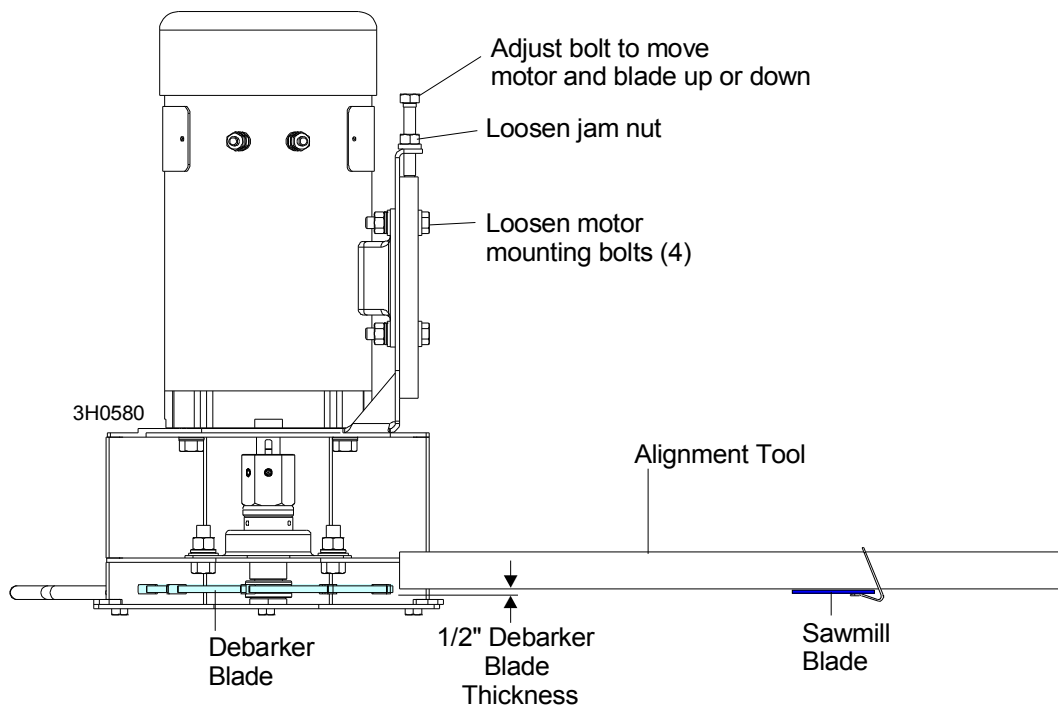


FIG. 2-9

2

Debarker Installation

Alignment

3. Check the height of the debarker blade against the alignment tool. The bottom edge of the tool should align with the center of the debarker blade.

To adjust the blade up or down, loosen the four blade motor mount bolts. Loosen the jam nuts on the adjustment bolts. Turn the adjustment bolts clockwise to push the motor and blade down. Turn the adjustment bolts counterclockwise and slide the motor up to raise the motor and blade. Retighten the adjustment bolts jam nuts and four motor mount bolts.

4. Insert the key and use the debarker in/out switch to move the debarker all the way out. Turn the key to OFF (0) and remove the key.

SECTION 3 OPERATION AND MAINTENANCE

3.1 Locking Pin Operation

See Figure 3-1. The debarker is equipped with a locking pin located where the debarker frame pivots in the mounting blocks. Two hole locations are provided for the locking pin. The inner hole should be used to lock the debarker in place when towing the sawmill. The outer position can be used to hold the debarker out of the way when debarking is not required during sawing.

Before operating the debarker, make sure the locking pin is secured in its disengaged position. Turn the key switch to OFF (0) and remove the key. Pull the debarker out to relieve pressure on the locking pin. Pull the pin down and rotate so the small roll pin is aligned with the disengaged position slot. Release the locking pin.

Before towing the sawmill, lock the debarker in the travel position. Turn the key switch to ACC (3) and use the debarker in/out switch to move the debarker all the way in. Turn the key to OFF (0) and remove the key. Push the debarker in until the travel position hole aligns with the locking pin. Pull the pin down and rotate until the small roll pin is aligned with the engaged position slot. Release the locking pin.

To move the debarker out of the way during sawing, turn the key switch to ACC (3) and use the debarker in/out switch to move the debarker all the way out. Turn the key to OFF (0) and remove the key. Push the debarker out until the outer hole is aligned with the locking pin. Pull the pin down and rotate until the small roll pin is aligned with the engaged position slot. Release the locking pin.

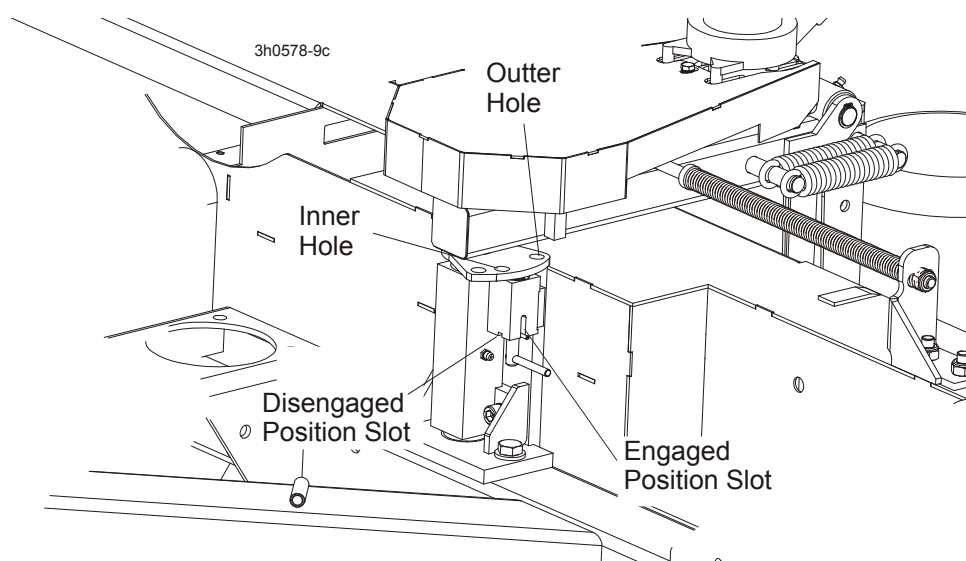


FIG. 3-1

3 Operation and Maintenance

Operation

3.2 Operation

The Debarker Option allows you to remove bark from logs before cutting.

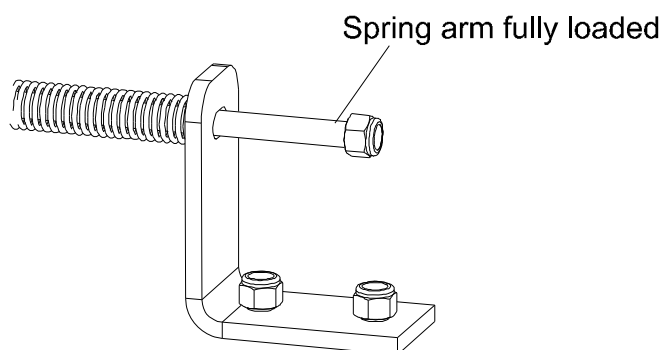


DANGER! Make sure all guards and covers are in place and secured before operating the debarker option. Failure to do so may result in serious injury.

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

1. Remove the blade motor cover before operating the debarker.
2. Use the in/out switch on the control box to pivot the debarker all the way out.
3. Move the sawmill carriage forward and pivot the debarker in until the front fence engages with the end/side of the log. Continue to pivot the debarker in until the spring arm is fully loaded and the spring rod will not extend any further through the mounting bracket.

See Figure 3-2.



3H0208

FIG. 3-2

4. Turn the debarker on/off switch to ON (1).
5. Proceed with cutting. The spring will keep the debarker against the side of the log. Depending on log shape, you may have to pivot the debarker in and out for smooth cutting.



NOTE: The debarker can continuously remove up to approximately 25 mm (1") of material from the log; no motor cool down time is required. Slower feed rates may be required for optimal debarker operation.


6. Once the carriage is past the end of the log, pivot the debarker away from the log. Return the carriage.



IMPORTANT! Should the carriage be returned before the debarker has been pivoted out of the way of the log, the debarker is designed to pivot upwards. If this happens, continue to **SLOWLY** return the carriage; or stop, pivot the debarker out and then return the carriage. **DO NOT** move the carriage forward while the debarker is contacting the log without the blade spinning.

7. When done sawing and ready to store or transport the sawmill, replace the debarker blade motor cover. Place the debarker in its travel position before towing the sawmill ([See Section 3.1](#)).

3.3 Maintenance

 **DANGER!** Before performing any service to this equipment, turn the key to the OFF (0) position and remove the key. Failure to do so will result in serious injury or death.

1. Lubricate the two pivot joints with a NLGI #2 grade lithium grease every 40 hours of operation.

See Figure 3-3.

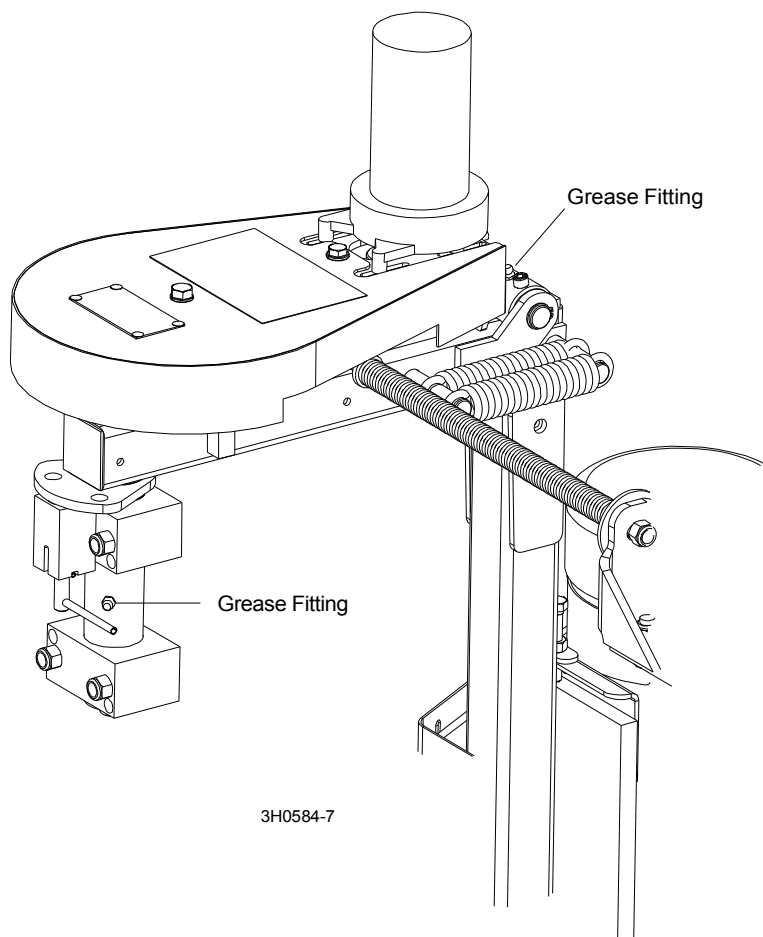


FIG. 3-3

2. Periodically check the flexible guard. Adjust the guard up or down so the bottom is even with the bottom of the debarker blade. Replace the guard as needed.

3. Periodically check the debarker blade. Align or replace as needed.



WARNING! Before replacing the debarker blade, move the sawmill blade guide arm in front of the sawmill blade to cover the blade teeth. Failure to do so may result in serious injury or death.

To replace the debarker blade, remove the lower blade guard plate. Place one wrench on the blade arbor, above the blade bearing. Place the other wrench on the lower bolt and rotate clockwise (bolt has left-hand threads). Remove the bolt and washer. Remove the blade and spacer.

Reinstall the spacer with the new blade. Reinstall the bolt and washer and turn counterclockwise to tighten. Reinstall the blade guard plate.

4. Periodically check belt for tension and wear. Adjust or replace as necessary. To tighten the belt, turn the key switch to OFF (0) and remove the key. Remove the belt guard and loosen the four motor mount screws. Turn the adjustment nut clockwise to move the motor out and tighten the belt. The belt should be tensioned to allow 9.5 mm (3/8") deflection measured halfway between the pulleys with 1.3-2.2 kg (3-5 lbs). of force. Retighten the motor mount screws and replace the belt guard.

See Figure 3-4.

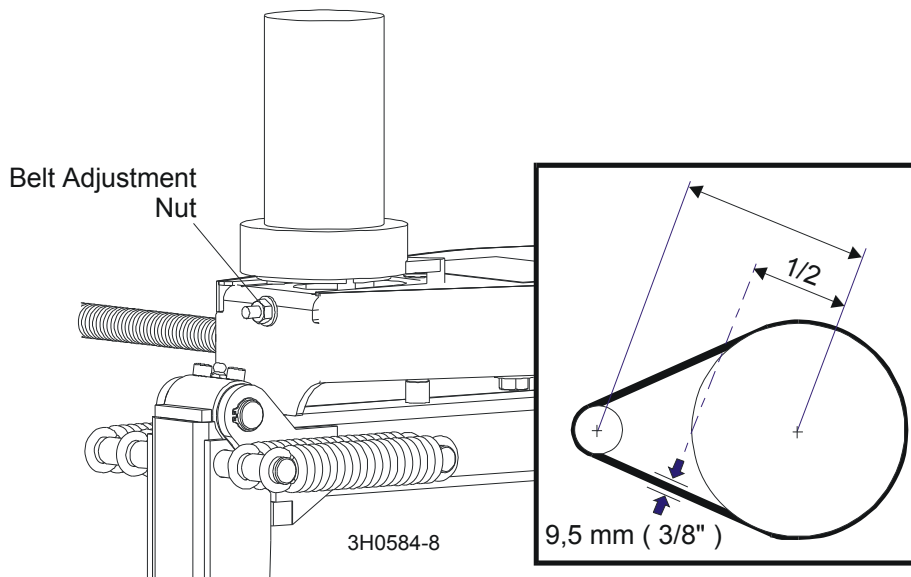


FIG. 3-4

5. Apply a dry lubricant such as Teflon spray or silicon to the spring rod and spring every 40 hours of operation.

3.4 Troubleshooting



DANGER! Before performing any service to this equipment, turn the key to the OFF (0) position, remove the key, and disconnect the sawmill battery ground terminal. Failure to do so will result in serious injury or death.

| PROBLEM | CAUSE | SOLUTION |
|---------------------------------------------------------------------------|--------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 70 amp circuit breaker tripping | Wood or bark jammed in blade guard | Turn key to OFF position, remove key. Remove wood or bark from blade guard |
| | Pivot pin is binding. | Inspect for bind by moving debarker head to full in position. Turn key to OFF position, remove key. Pull arm to full out position by hand. If available, use a weight scale to pull arm to full out position. Should not have more than 12 pounds of resistance to pull out. Ensure pivot pin has been greased properly. Check pivot clamps for correct installation. Loosen pivot clamp bolts slightly, check for reduced binding |
| | Ring terminal of red wire touching debarker motor housing at motor | Move terminal away from motor housing. Reset circuit breaker and retest. |
| Light comes on, but debarker motor and warning horn do not operate | Circuit breaker weak from repeated tripping. | Replace circuit breaker |
| | Circuit breaker tripped | Reset circuit breaker. |
| Debarker shuts off, but the circuit breaker is not tripped. | Bad ignition wire connection | Check ignition wire connection outside and inside of debarker control box. |
| | Intermittent key switch | Replace key switch |
| | Other loose wiring connection | Check wiring connections inside control box. |
| Debarker will not shut off. | Solenoid is stuck closed. | Replace solenoid. |
| IN/OUT Motor does not move IN or OUT | Drive belt too loose | Tighten enough to allow movement. DO NOT OVER-TIGHTEN. |
| | Switch not working properly | Check wiring to switch for loose connections. If wiring looks OK, replace switch. |

SECTION 4 DEBARKER PARTS

4.1 How To Use The Parts List

- Use the table of contents or index 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.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

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

| 4.2 Sample Assembly | | | | |
|----------------------------|---------------------------------------------------------------|-----------|-----|---|
| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY | |
| | SAMPLE ASSEMBLY, COMPLETE (INCLUDES ALL INDENTED PARTS BELOW) | A01111 | 1 | |
| 6 | Sample Part | F02222-22 | 1 | |
| | Sample Subassembly (Includes All Indented Parts Below) | A03333 | 1 | |
| 7 | Sample Part (◆ Indicates Part Is Only Available With A03333) | S04444-4 | 1 | ◆ |
| | Sample Subassembly (Includes All Indented Parts Below) | K05555 | 1 | |
| 8 | Sample Part (◆ Indicates Part Is Only Available With K05555) | M06666 | 2 | ◆ |
| 9 | Sample Part | F07777-77 | 1 | |

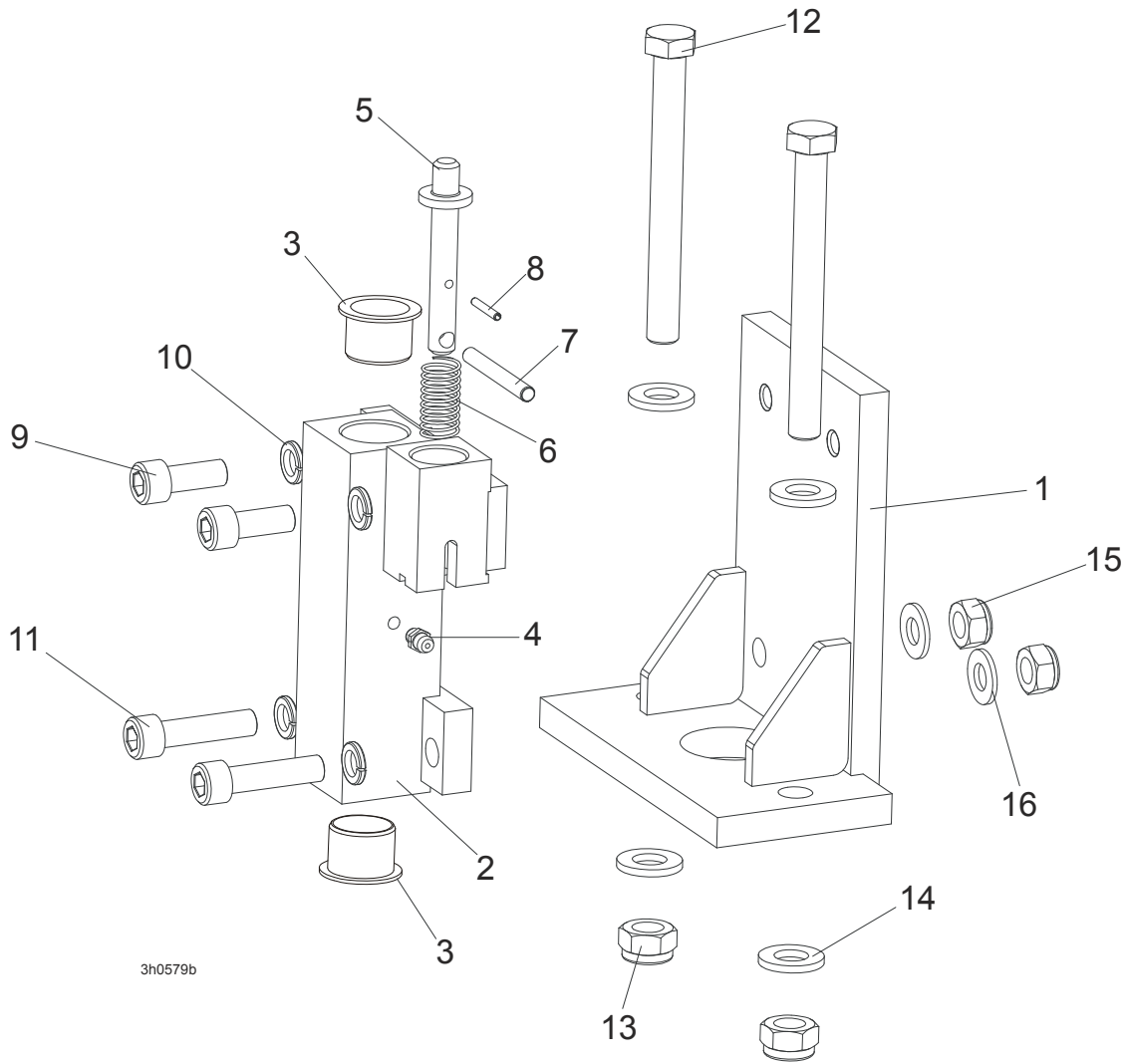
To Order Parts:

- From Europe call our European Headquarters and Manufacturing Facility in Kolo, Poland at **+48-63-2610233** or **+48-3912-1319**. From the continental U.S., call **1-800-448-7881** to order parts. Have your customer number, vehicle identification number, and part numbers ready when you call.
- From other international locations, contact the Wood-Mizer distributor in your area for parts.

4 Debarker Parts

Locking Pin Assembly

4.3 Locking Pin Assembly



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|-----------------|----------|
| 1 | MOUNTING PLATE LT60/70/80 | 089942-1 | 1 |
| 2 | ARM, DEBARKER FRAME PIVOT | 089947-1 | 1 |
| | Arm, Debarker Frame Pivot | 091008 | 1 |
| 3 | Bushing, GFM - 2528 - 21 | 091009 | 2 |
| 4 | FITTING, M6 STRAIGHT GREASE | 086280 | 1 |
| 5 | PIN, DEBARKER LOCKING | 089972-1 | 1 |
| 6 | SPRING, .58" OD X 1 1/8" | 021243 | 1 |
| 7 | PIN, 6X50 ROLL ZINC | F81045-1 | 1 |
| 8 | PIN, 3X20 ROLL ZINC | F81044-5 | 1 |
| 9 | BOLT, M10X30-5.8 | F81003-2 | 2 |
| 10 | WASHER, 10.5 ZINC FLAT | F81055-2 | 4 |

Debarker Parts
Locking Pin Assembly

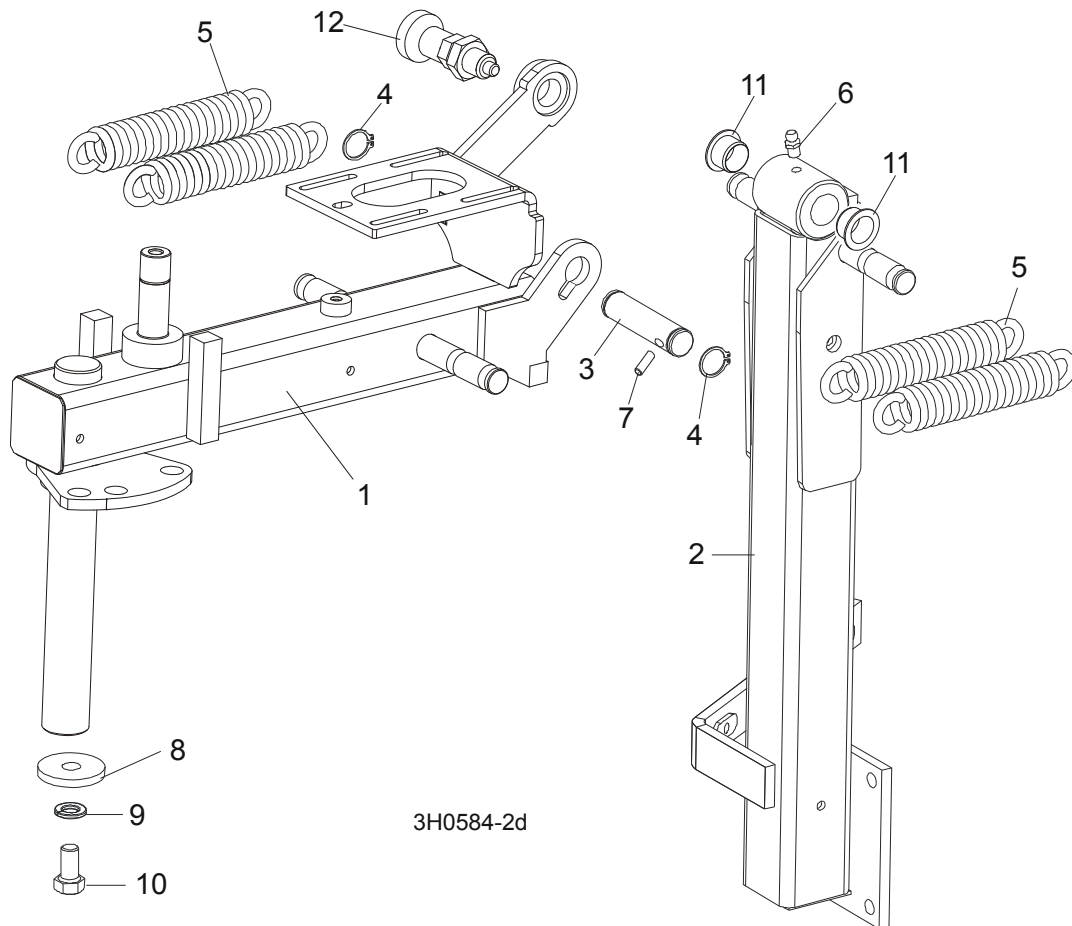
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| | | | | |
|----|--------------------------------------------|-----------|---|--|
| 11 | SCREW, M10X40 8.8 HEX SOCKET HEAD CAP ZINC | F81003-22 | 2 | |
| 12 | BOLT M12X55 -8.8-B-FE/ZN5 | F81004-23 | 2 | |
| 13 | NUT, M12-8, SELF LOCKING | F81034-2 | 2 | |
| 14 | WASHER, 13 ZINC FLAT | F81056-1 | 4 | |
| 15 | NUT, M10-8-B HEX NYLON ZINC LOCK | F81033-1 | 2 | |
| 16 | WASHER, 10.5 ZINC FLAT | F81055-1 | 2 | |

4 Debarker Parts

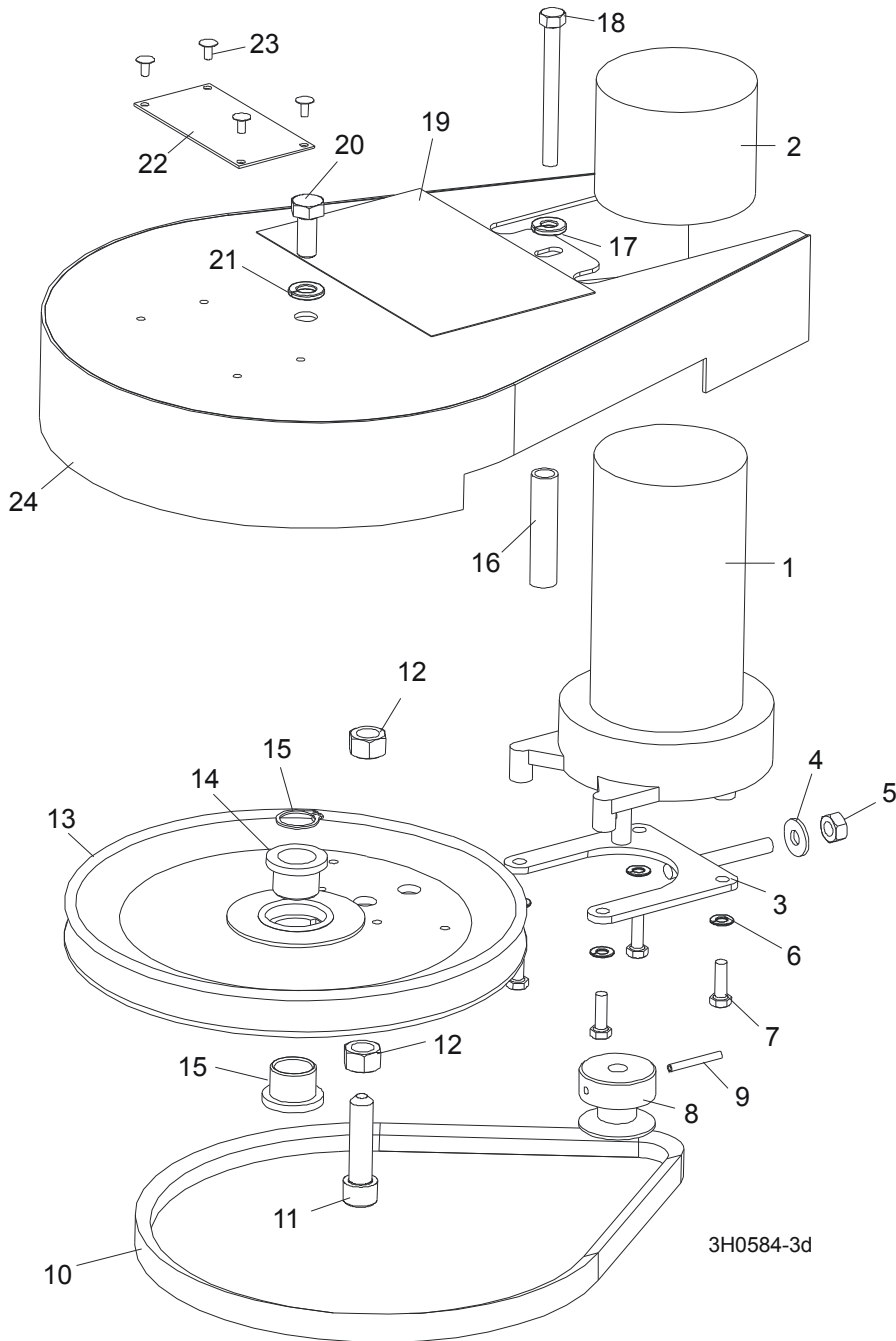
Frame Assembly

4.4 Frame Assembly



| REF. | DESCRIPTION (◆Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|-----------|-----|
| 1 | ARM WELDMENT, DEBARKER HORIZONTAL | 089963-1 | 1 |
| 2 | ARM WELDMENT, DEBARKER VERTICAL | 089966-1 | 1 |
| 3 | PIN, VERTICAL ARM PIVOT | 089588-1 | 1 |
| 4 | RING, Z16 OUTER RETAINING | F81090-11 | 2 |
| 5 | SPRING, DEBARKER ARM | 021185 | 4 |
| 6 | FITTING, M6 GREASE | 086280 | 1 |
| 7 | PIN, H 5X12-B ROLL ZINC | F81044-8 | 1 |
| 8 | WASHER, .40 X 1.44 X .18 | 089973-1 | 1 |
| 9 | WASHER, 3/8" SPLIT LOCK | F81055-2 | 1 |
| 10 | BOLT, 3/8-16 X 3/4" HEX HEAD GRADE 2 | F81003-1 | 1 |
| 11 | BUSHING, GFM - 1618-12 | 091455 | 2 |
| 12 | PIN, 45308DNW DETENT | 089939 | 1 |

4.5 In/Out Motor Drive Assembly



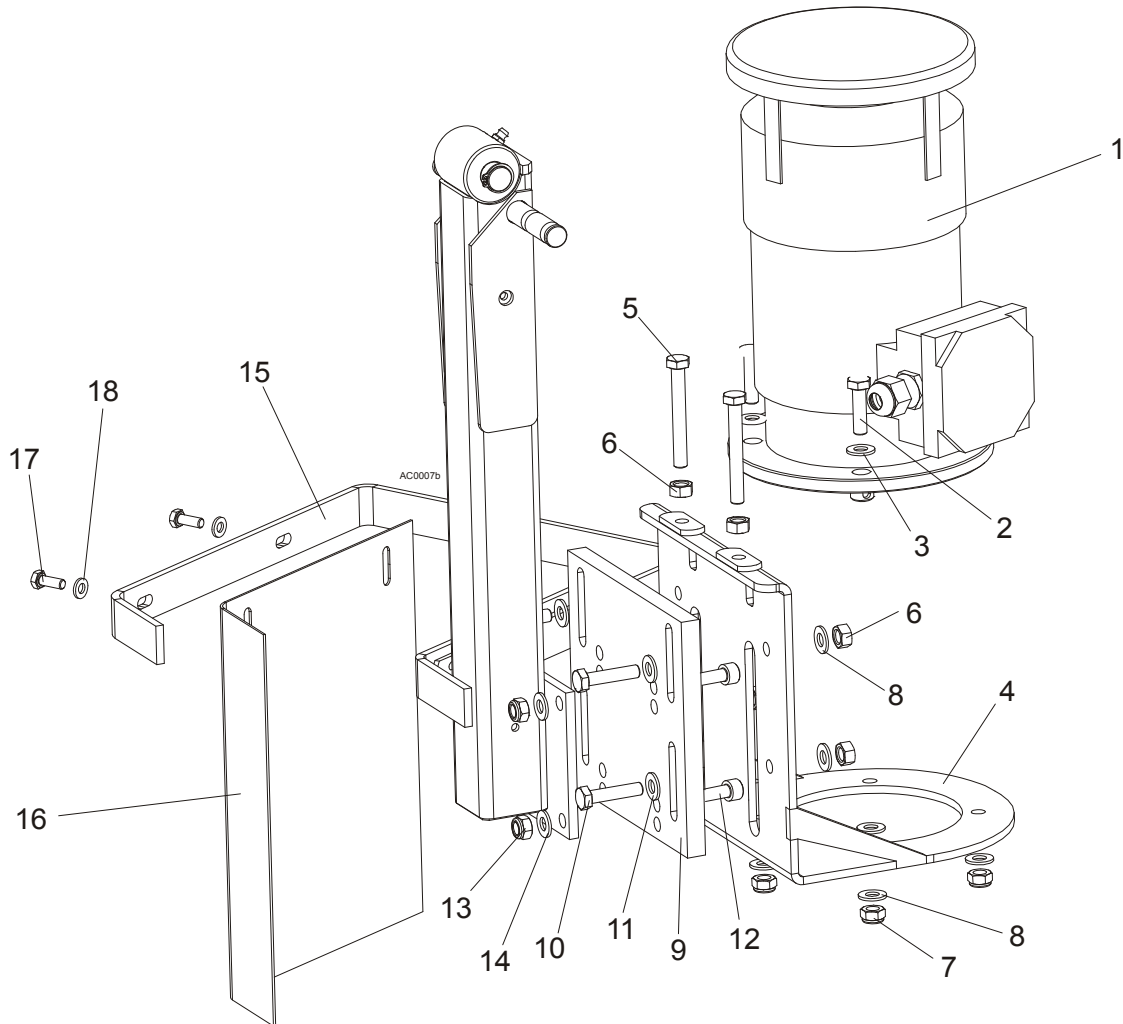
| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|----------|-----|
| 1 | MOTOR, 53:1 GEAR | P09698-1 | 1 |
| | Gear Kit, Klauber Motor Replacement | P12569 | 1 |
| | Shaft Kit, Klauber Motor Replacement | 009695 | 1 |

4

Debarker Parts*In/Out Motor Drive Assembly*

| | | | | |
|----|---------------------------------------------------|------------|---|--|
| 2 | CAP, IN/OUT MOTOR WEATHER RUBBER | 023720 | 1 | |
| 3 | TENSIONER WELDMENT, DEBARKER IN/OUT MOTOR PAINTED | 089969-1 | 1 | |
| 4 | WASHER, 6.5 ZINC FLAT | F81053-11 | 1 | |
| 5 | NUT, M6-8 ZINC HEX | F81031-1 | 1 | |
| 6 | WASHER, 5.1 ZINC SPLIT LOCK | F81052-2 | 4 | |
| 7 | BOLT, #10-32X1/2" HEX HEAD ZINC | F05004-60 | 4 | |
| 8 | SHEAVE, DEBARKER MOTOR ZINC-PLATED | 089954-1 | 1 | |
| 9 | PIN, 1/8X3/4" ROLL | F05012-6 | 1 | |
| 10 | BELT, AVX 13X800 | 089986 | 1 | |
| 11 | SCREW, M10X40 8.8 HEX SOCKET HEAD CAP ZINC | F81003-22 | 1 | |
| 12 | NUT, M10-8-B ZINC HEX | F81033-3 | 2 | |
| 13 | PULLEY, DEBARKER MOTOR | 091154-1 | 1 | |
| 14 | BUSHING, FLANGED BRONZE | 089948 | 2 | |
| 15 | RING, Z16 SPRING RETAINING | F81090-11 | 1 | |
| 16 | SPACER, ZINC-PLATED | 089949-1 | 1 | |
| 17 | WASHER, Z 6.1 ZINC SPLIT LOCK | F81053-3 | 1 | |
| 18 | BOLT, M6X80 5.8 HEX HEAD FULL THREAD ZINC | F81001-61 | 1 | |
| 19 | DECAL, WARNING | 021172 | 1 | |
| 20 | BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC | F81002-20 | 1 | |
| 21 | WASHER, 8.2 ZINC SPLIT LOCK | F81054-4 | 1 | |
| 22 | PLATE, DEBARKER REVISION | 005801-293 | 1 | |
| 23 | RIVET, 1/8" X 1/4" ALUMINIUM POP | F04203-2 | 4 | |
| 24 | GUARD WELDMENT, DEBARKER V-BELT PAINTED | 090519-1 | 1 | |

4.6 Blade Motor Assembly

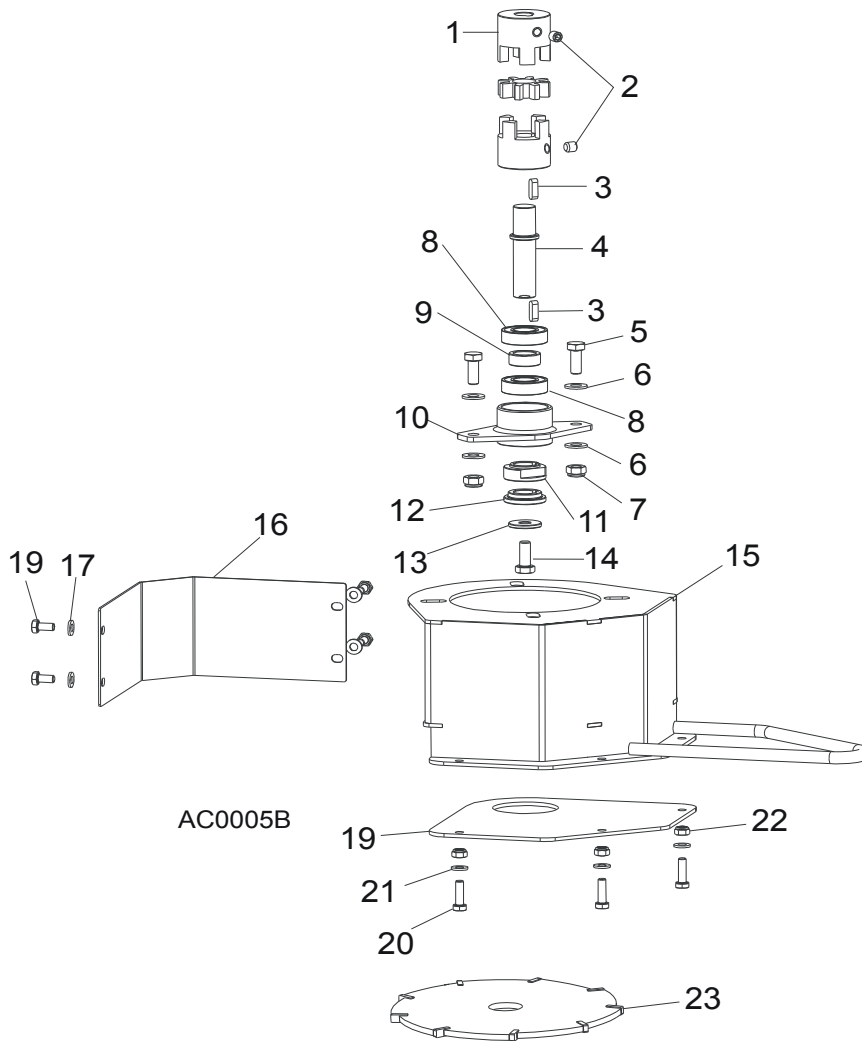


| REF. | DESCRIPTION (◆Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|---------------|----------|
| | HEAD ASSEMBLY, AC DEBARKER | 086565 | 1 |
| | Debarker Blade Motor Assembly, AC | 086504 | 1 |
| 1 | Motor, AC Debarker Electric | 086389 | 1 |
| 2 | Bolt, M8 x 30 8.8 B Hex Head Zinc | F81002-7 | 4 |
| 3 | Washer, 8.4 Zinc Flat | F81054-1 | 4 |
| 4 | Bracket, AC Debarker Motor Mount Painted | 086500-1 | 1 |
| 5 | Bolt, M8X65 8.8 Hex Head Full Thread Zinc | F81002-9 | 2 |
| 6 | Nut, M8-8-B Hex Zinc | F81032-1 | 4 |
| 7 | Nut, M8-8-B Hex Nylon Zinc Lock | F81032-2 | 4 |
| 8 | Washer, 8.4 Zinc Flat | F81054-1 | 6 |
| 9 | Plate, Debarker Motor Mounting | 089551 | 1 |
| 10 | Bolt, M8x35-8.8 Hex Head Full Thread Zinc | F81002-13 | 4 |

4**Debarker Parts***Blade Motor Assembly*

| | | | | |
|----|---------------------------------------------|-----------|---|--|
| 11 | Washer, 8.4 Zinc Flat | F81054-1 | 4 | |
| 12 | Bolt, M8x30 -8.8 Socket Head | F81002-31 | 4 | |
| 13 | Nut, M8-8-B Hex Nylon Zinc Loc | F81032-2 | 4 | |
| 14 | Washer, 8.4 Zinc Flat | F81054-1 | 4 | |
| 15 | Guard, Debarker Wrap-Around Painted | 089561-1 | 1 | |
| 16 | Guard, Debarker Flexible Debris | 089562 | 1 | |
| 17 | Bolt, M6 x 16 8.8 Hex Head Full Thread Zinc | F81001-15 | 2 | |
| 18 | Washer, 6.4 Zinc Flat | F81053-1 | 2 | |

4.7 Blade Housing Assembly

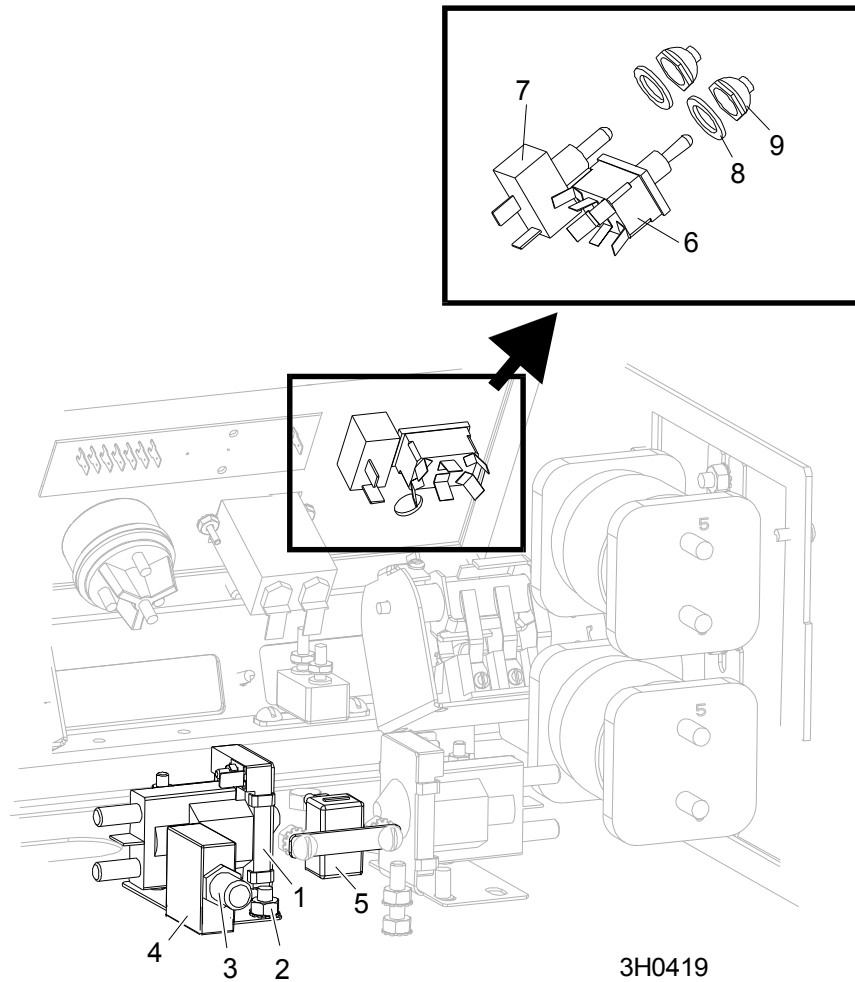


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|----------|-----|
| 1 | ROTEX CLUTCH, AC DEBARKER | 086525 | 1 |
| 2 | SCREW M8 X 8-33H | F81014-1 | 2 |
| 3 | KEY 5H9 X 5 X 17 | 086279 | 2 |
| 4 | SHAFT, AC DEBARKER CLUTCH | 086507 | 1 |
| 5 | BOLT, M8 X 20 8.8 B HEX HEAD | F81002-4 | 2 |
| 6 | WASHER, 8.4 FLAT | F81054-1 | 2 |
| 7 | NUT, M8 8 HEX | F81032-2 | 2 |
| 8 | BEARING 6003-2RS-P66 | 086116 | 2 |

4**Debarker Parts***Blade Housing Assembly*

| | | | | |
|----|-------------------------------------|----------|---|--|
| 9 | SPACER, AC DEBARKER CLUTCH | 086357 | 1 | |
| 10 | BUSHING, AC DEBARKER CLUTCH BEARING | 086354 | 1 | |
| 11 | BUSHING, AC DEBARKER CLUTCH CLAMP | 086355 | 1 | |
| 12 | BUSHING, AC DEBARKER CLUTCH | 086356 | 1 | |
| 13 | WASHER, 8.5 MM | 086363 | 1 | |
| 14 | BOLT, M8 X 20 - 8.8 HEX HEAD | F81002-4 | 1 | |
| 15 | HOUSING WELDMENT, DEBARKER BLADE | 086366-1 | 1 | |
| 16 | GUARD, DEBARKER CLUTCH | 086372-1 | 1 | |
| 17 | WASHER, 6.4 SPLIT LOCK | F81053-1 | 4 | |
| 18 | BOLT, M6 X 12 8.8 HEX HEAD | F81001-7 | 4 | |
| 19 | GUARD, AC DEBARKER LOWER | 086371-1 | 1 | |
| 20 | BOLT, M6 X 20 - 8.8 HEX HEAD | F81001-2 | 3 | |
| 21 | WASHER, 6.4 SPLIT LOCK | F81053-1 | 3 | |
| 22 | NUT, M6 8.8 HEX | F81031-2 | 3 | |
| 23 | BLADE, DEBARKER 7" DIA. | 021236 | 1 | |

4.8 Debarker Control Assembly

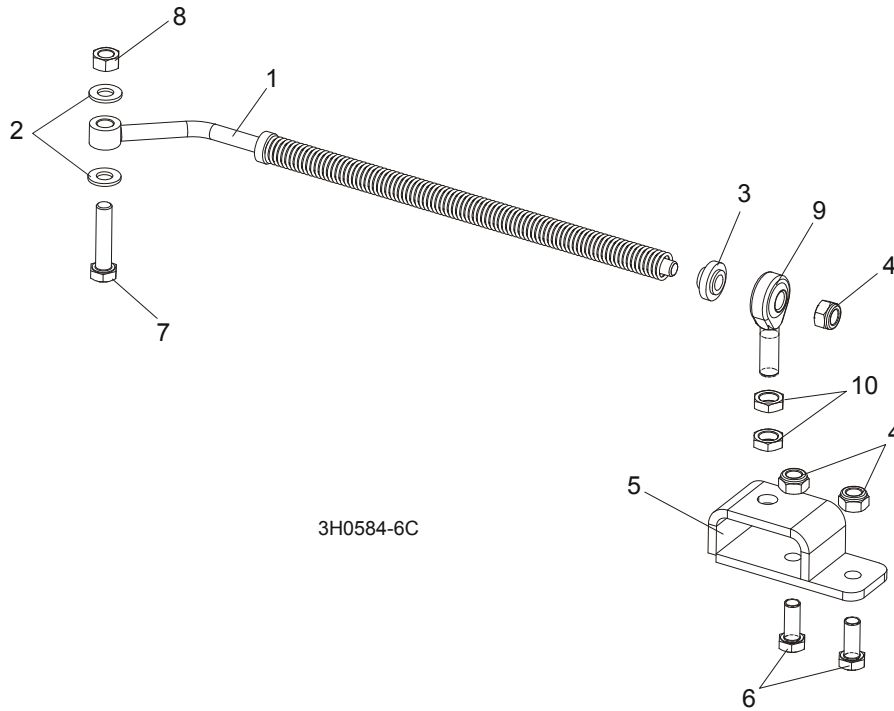


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |
|------|--------------------------------------------------------------|----------|-----|
| | CONTROL ASSEMBLY, DEBARKER (NON-REMOTE) | 023676 | 1 |
| | CONTROL ASSEMBLY, DEBARKER (REMOTE) | 023677 | 1 |
| 1 | Solenoid, 12V 100A Continuous Duty GND Coil | P10449 | 1 |
| | Diode Assembly, Solenoid GND Coil Chassis | 015426 | 1 |
| 2 | Nut, 1/4-20 Self-Locking | F05010-9 | 2 |
| 3 | Boot, Circuit Breaker | 021253 | 1 |
| 4 | Breaker, 70 Amp Manual Reset Panel Mount | 015527 | 1 |
| 5 | Breaker, 15 Amp Manual Reset | E20430 | 1 |
| 6 | Switch, DPDT Toggle Return Center Screw Terminal | 024200 | 1 |
| 7 | Switch, SPST Toggle Quick Connect | P03027 | 1 |
| 8 | Washer, 1/2 x 3/4 x 1/16" Nylon | P05251-1 | 2 |
| 9 | Boot, Toggle Switch | P02575 | 2 |

4 Debarker Parts

Spring Rod Assembly

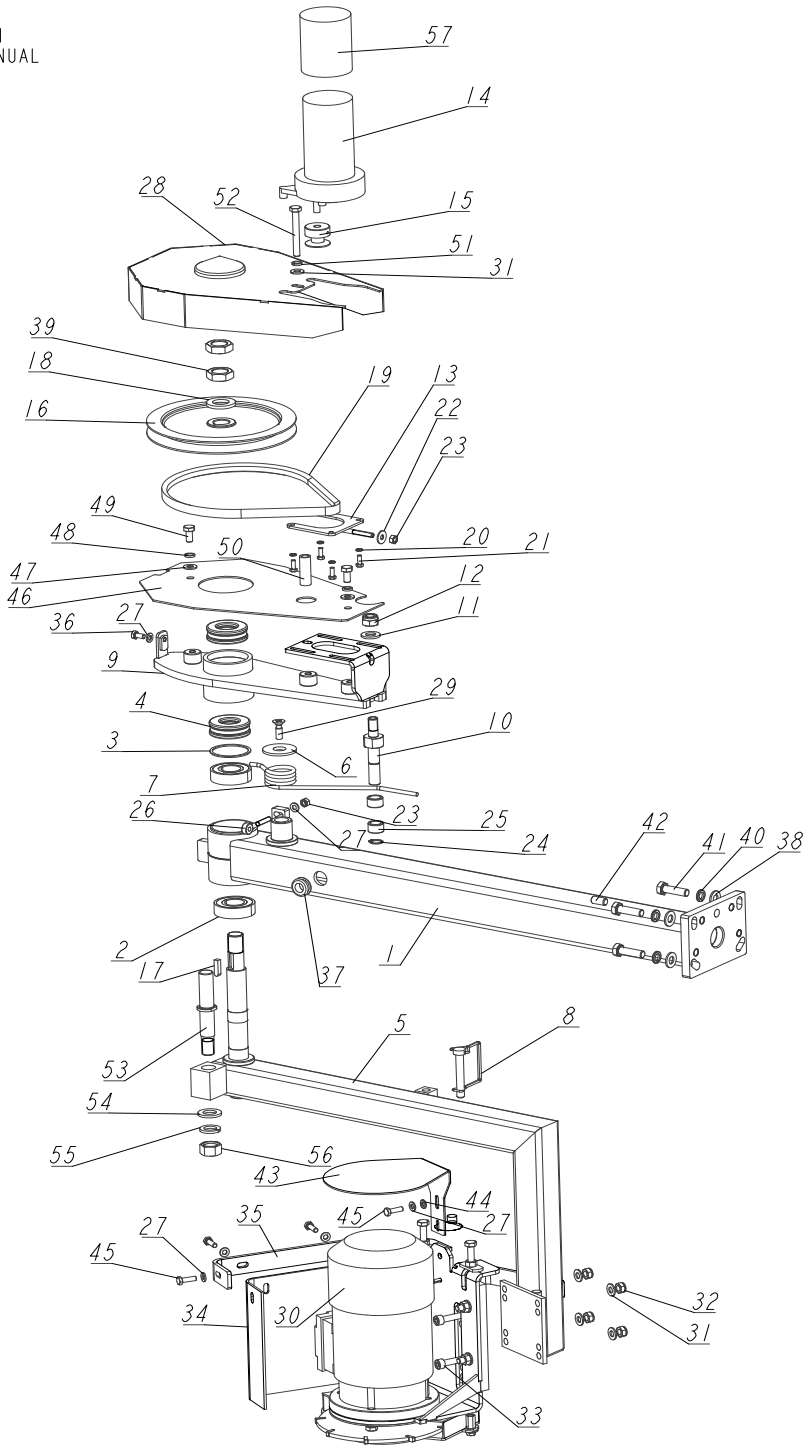
4.9 Spring Rod Assembly



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART# | QTY | |
|------|--------------------------------------------------------------|---------------|----------|--|
| | ROD, ZINC-PLATED | 089974 | 1 | |
| 1 | Rod, Debarker Spring Zinc-plated | 089979-1 | 1 | |
| 2 | Washer, 10.5 Zinc Flat | F81055-1 | 2 | |
| 3 | Washer, Fender Zinc | 089982-1 | 1 | |
| 4 | Nut, M10-8-B Hex Nylon Zinc Lock | F81033-1 | 3 | |
| 5 | Bracket, Dbk Spring Rod Mounting Painted | 092238-1 | 1 | |
| 6 | Bolt, M10x25-8.8 Hex Head Full Thread Zinc | F81003-11 | 2 | |
| 7 | Bolt, M10x45-8.8 Hex Head Full Thread Zinc | F81003-3 | 1 | |
| 8 | Nut, M10-8-B-FE | F81033-3 | 1 | |
| 9 | Rod End, SA12 CX Right-hand | 087035 | 1 | |
| 10 | Nut, M12-04-A Thin Zinc-plated | F81034-6 | 2 | |

4.10 Wider Debarker Assembly

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Debarker Parts*Wider Debarker Assembly*

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART# | QTY | |
|------|----------------------------------------------------------------------|-----------|-----|--|
| - | LT70 AC DEBARKER - WIDER | 525865 | 1 | |
| - | LT70 DC DEBARKER - WIDER | 525864 | 1 | |
| 1 | ARM, DEBARKER HORIZONTAL | 525867-1 | 1 | |
| 2 | BEARING, 6205 2RS BALL | 091804 | 2 | |
| 3 | RING, SPACER | 098491-1 | 1 | |
| 4 | BEARING, 51305 THRUST | 098597 | 2 | |
| 5 | ARM, DEBARKER SWING | 526624-1 | 1 | |
| 6 | PLATE, SPRING BUSHING | 098592-1 | 1 | |
| 7 | SPRING, DEBARKER RETAINING | 098605 | 1 | |
| 8 | PIN, 3/8X2 1/4 SQ WIRE LOCK | 014151 | 1 | |
| 9 | ARM WELDMENT, DEBARKER | 098626-1 | 1 | |
| 10 | PIN, DEBARKER | 098593-1 | 1 | |
| 11 | WASHER, 13 FLAT ZINC | F81056-1 | 1 | |
| 12 | NUT, M12 8 HEX NYLON ZINC LOCK | F81034-2 | 1 | |
| 13 | TENSIONER WELDMENT, DEBARKER MOTOR | 089969-1 | 1 | |
| 14 | MOTOR, CURRENT APP. 1/30HP RPM32, 12VDC R | 079214M | 1 | |
| 15 | SHEAVE, DEBARKER MOTOR ZINC-PLATED | 089954-1 | 1 | |
| 16 | PULLEY, DEBARKER MOTOR | 098594-1 | 1 | |
| 17 | KEY, 6X6X23 | 089191 | 1 | |
| 18 | WASHER, 21 FLAT ZINC | F81059-2 | 1 | |
| 19 | BELT, 4L280 | P04031 | 1 | |
| 20 | WASHER, 5.1 SPLIT LOCK | F81052-2 | 4 | |
| 21 | BOLT, #10-32X1/2" HEX HEAD ZINC | F05004-60 | 4 | |
| 22 | WASHER, 6.5 SPECIAL FLAT ZINC | F81053-11 | 1 | |
| 23 | NUT, M6-8 HEX ZINC | F81031-1 | 2 | |
| 24 | RING, Z14 OUTSIDE RETAINING | F81090-31 | 1 | |
| 25 | BEARING, 1412 NEEDLE | 098595 | 2 | |
| 26 | BOLT, M6 EYE | 098596 | 1 | |
| 27 | WASHER, 6.4 FLAT ZINC | F81053-1 | 6 | |
| 28 | GUARD, DEBARKER V-BELT | 098598-1 | 1 | |
| 29 | SCREW, M8X25-5.8 CROSS RECESSED COUNTERSUNK HEAD ZINC | F81002-51 | 1 | |
| 30 | DRIVE ASSEMBLY, DEBARKER BLADE - AC See Section 4.11 | 096239 | 1 | |
| | DRIVE ASSEMBLY, DEBARKER BLADE - DC See Section 4.12 | 100922 | 1 | |
| 31 | WASHER, 8.4 FLAT ZINC | F81054-1 | 5 | |
| 32 | NUT, M8-8-B HEX NYLON ZINC LOCK | F81032-2 | 4 | |
| 33 | SCREW, M8X30-8.8 HEX SOCKET HEAD CAP ZINC | F81002-31 | 4 | |
| 34 | GUARD, DEBARKER FLEXIBLE DEBRIS | 097020 | 1 | |
| 35 | GUARD, DEBARKER WRAP-AROUND | 098695-1 | 1 | |
| 36 | BOLT, M6X12 8.8 HEX HEAD FULL THREAD ZINC | F81001-7 | 1 | |
| 37 | GROMMET, 20/13 RUBBER | 086188 | 1 | |
| 38 | WASHER, 10.5 FLAT ZINC | F81055-1 | 4 | |
| 39 | NUT, M20X1.5 THIN ZINC | F81037-7 | 2 | |

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART# | QTY | |
|------|--------------------------------------------------------------|-----------------------|-----|--|
| 40 | WASHER, Z 10.2 SPLIT LOCK ZINC | F81055-2 | 4 | |
| 41 | BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC | F81003-17 | 4 | |
| 42 | SCREW, M10X1X20 DIN 913 STAINLESS STEEL SET | F81015-1 | 2 | |
| 43 | GUARD, DEBARKER MOTOR | 101332-1 ¹ | 1 | |
| 44 | WASHER, 6.1 DIN 127 (A2-304) STAINLESS STEEL SPLIT LOCK | F81053-4 ¹ | 1 | |
| 45 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 4 | |
| - | GUARD ASSEMBLY | 519064 | 1 | |
| 46 | PLATE, GUARD | 519061-1 | 1 | |
| 47 | WASHER, 8.4 FLAT ZINC | F81054-1 | 2 | |
| 48 | WASHER, 8.2 SPLIT LOCK ZINC | F81054-4 | 2 | |
| 49 | BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC | F81002-20 | 2 | |
| 50 | BUSHING, 9/13-40.5 | 519067-1 | 1 | |
| 51 | WASHER, 8.2 SPLIT LOCK ZINC | F81054-4 | 1 | |
| 52 | BOLT, M8X65 8.8 HEX HEAD FULL THREAD ZINC | F81002-9 | 1 | |
| - | PIN ASSEMBLY, LOCKING | 519066 | 1 | |
| 53 | PIN, LOCKING | 519065-1 | 1 | |
| 54 | WASAHER, 17 FLAT ZINC | F81058-1 | 1 | |
| 55 | WASHER, 16.3 SPLIT LOCK ZINC | F81058-2 | 1 | |
| 56 | NUT, M16-8 HEX ZINC | F81036-1 | 1 | |
| 57 | CAP, 2.5 ID X 3 RUBBER | 023720 | 1 | |

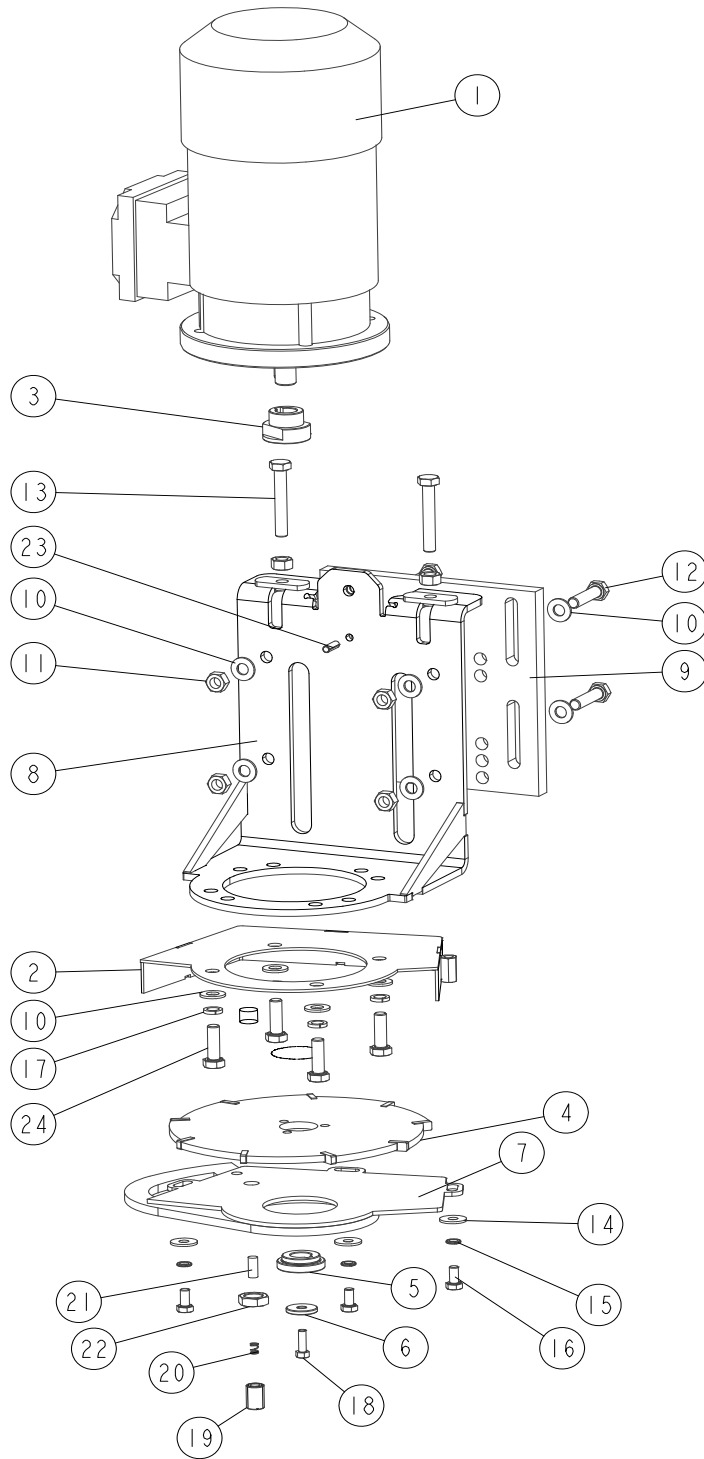
¹ Used on AC debarkers (525865) only

4 Debarker Parts

AC Debarker Blade Drive

4.11 AC Debarker Blade Drive

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096239_MANUAL



Debarker Parts

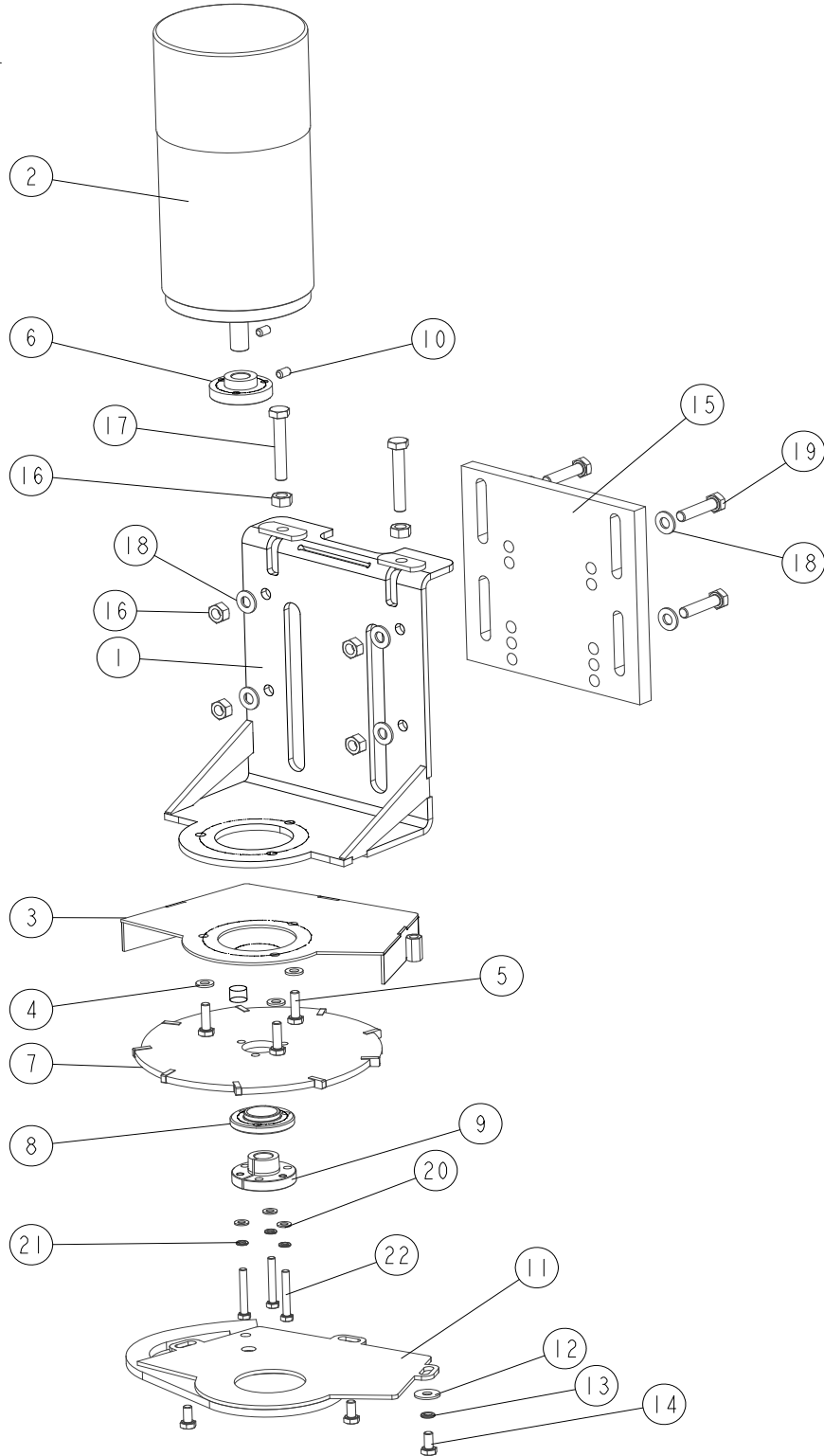
AC Debarker Blade Drive

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| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART# | QTY | |
|------|--------------------------------------------------------------|-----------|-----|--|
| - | DRIVE ASSEMBLY, DEBARKER BLADE - AC | 096239 | 1 | |
| 1 | MOTOR, STKG71X-2C IMB5 AC DEBARKER | 096777 | 1 | |
| 2 | GUARD, DEBARKER BLADE UPPER | 096244-1 | 1 | |
| 3 | BUSHING, CLAMPING | 096088 | 1 | |
| 4 | BLADE, 180 B-06.5/5.0 D-25.5 - COMPLETE | 083848-1 | 1 | |
| 5 | BUSHING, RETAINING | 096087 | 1 | |
| 6 | WASHER | 096238-1 | 1 | |
| 7 | GUARD, DEBARKER BLADE LOWER | 096245-1 | 1 | |
| 8 | BRACKET, DEBARKER MOTOR MOUNT | 096780-1 | 1 | |
| 9 | PLATE, DEBARKER MOTOR MOUNT | 089551 | 1 | |
| 10 | WASHER, 8.4 FLAT ZINC | F81054-1 | 12 | |
| 11 | NUT, M8-8-B HEX ZINC | F81032-1 | 6 | |
| 12 | BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC | F81002-13 | 4 | |
| 13 | BOLT, M8X50-8.8 HEX HEAD FULL THREAD ZINC | F81002-19 | 2 | |
| 14 | WASHER, 6.5 SPECIAL FLAT ZINC | F81053-11 | 3 | |
| 15 | WASHER, Z 6.1 SPLIT LOCK ZINC | F81053-3 | 3 | |
| 16 | BOLT, M6X12 8.8 HEX HEAD FULL THREAD ZINC | F81001-7 | 3 | |
| 17 | WASHER, 8.2 SPLIT LOCK ZINC | F81054-4 | 4 | |
| 18 | BOLT, M5X16 8.8 HEX HEAD FULL THREAD ZINC | F81000-20 | 1 | |
| - | PIN ASSEMBLY, DEBARKER BLADE BRAKING | 501464 | 1 | |
| 19 | SCREW, M12X18 SET | 501462 | 1 | |
| 20 | SPRING, 0.5X5.5-7 | 501463 | 1 | |
| 21 | PIN, DEBARKER BLADE BRAKING | 501461 | 1 | |
| 22 | NUT, M12-04-A THIN | F81034-6 | 1 | |
| 23 | PIN, 5X16 ROLL ZINC | F81044-3 | 1 | |
| 24 | BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC | F81002-5 | 4 | |

4.12 DC Debarker Blade Drive

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100922_MANUAL



Debarker Parts

DC Debarker Blade Drive

4

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART# | QTY | |
|------|--------------------------------------------------------------|-----------|-----|--|
| - | DRIVE ASSEMBLY, DC DEBARKER BLADE | 100922 | 1 | |
| 1 | BRACKET, DC DEBARKER MOTOR MOUNT | 097493-1 | 1 | |
| 2 | MOTOR, 0.75HP/1550 R.P.M. 12V DC | 100918 | 1 | |
| 3 | GUARD, DEBARKER BLADE UPPER | 097499-1 | 1 | |
| 4 | WASHER, 6.4 FLAT ZINC | F81053-1 | 3 | |
| 5 | BOLT, M6X20 8.8 HEX HEAD FULL THREAD ZINC | F81001-2 | 3 | |
| 6 | BUSHING, CLAMPING | 097496 | 1 | |
| 7 | BLADE, 180 B-06.5/5.0 D-25.5 - COMPLETE | 083848-1 | 1 | |
| 8 | BUSHING, MOUNTING | 097495 | 1 | |
| 9 | BUSHING, SPLIT TAPER | 097494 | 1 | |
| 10 | SCREW, M6X10-45H HEX SOCKET ZINC SET W/FLAT POINT | F81001-26 | 2 | |
| 11 | GUARD, DEBARKER BLADE LOWER | 096245-1 | 1 | |
| 12 | WASHER, 6.5 SPECIAL FLAT ZINC | F81053-11 | 3 | |
| 13 | WASHER, Z 6.1 SPLIT LOCK ZINC | F81053-3 | 3 | |
| 14 | BOLT, M6X12 8.8 HEX HEAD FULL THREAD ZINC | F81001-7 | 3 | |
| 15 | PLATE, DEBARKER MOTOR MOUNT | 089551 | 1 | |
| 16 | NUT, M8-8-B HEX ZINC | F81032-1 | 6 | |
| 17 | BOLT, M8X50-8.8 HEX HEAD FULL THREAD ZINC | F81002-19 | 2 | |
| 18 | WASHER, 8.4 FLAT ZINC | F81054-1 | 8 | |
| 19 | BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC | F81002-13 | 4 | |
| 20 | WASHER, 5.3 FLAT ZINC | F81052-1 | 3 | |
| 21 | WASHER, 5.1 SPLIT LOCK ZINC | F81052-2 | 3 | |
| 22 | BOLT, M5X35 8.8 HEX HEAD FULL THREAD ZINC | F81000-10 | 3 | |