INDUSTRIAL PRODUCTS

Safety, Operation & Parts Manual

SHR10, SHR20-L, SHR20-H, SHR20-380, SHR25-L, SHR25-H rev. A1.05

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

October 2005

Form #1346

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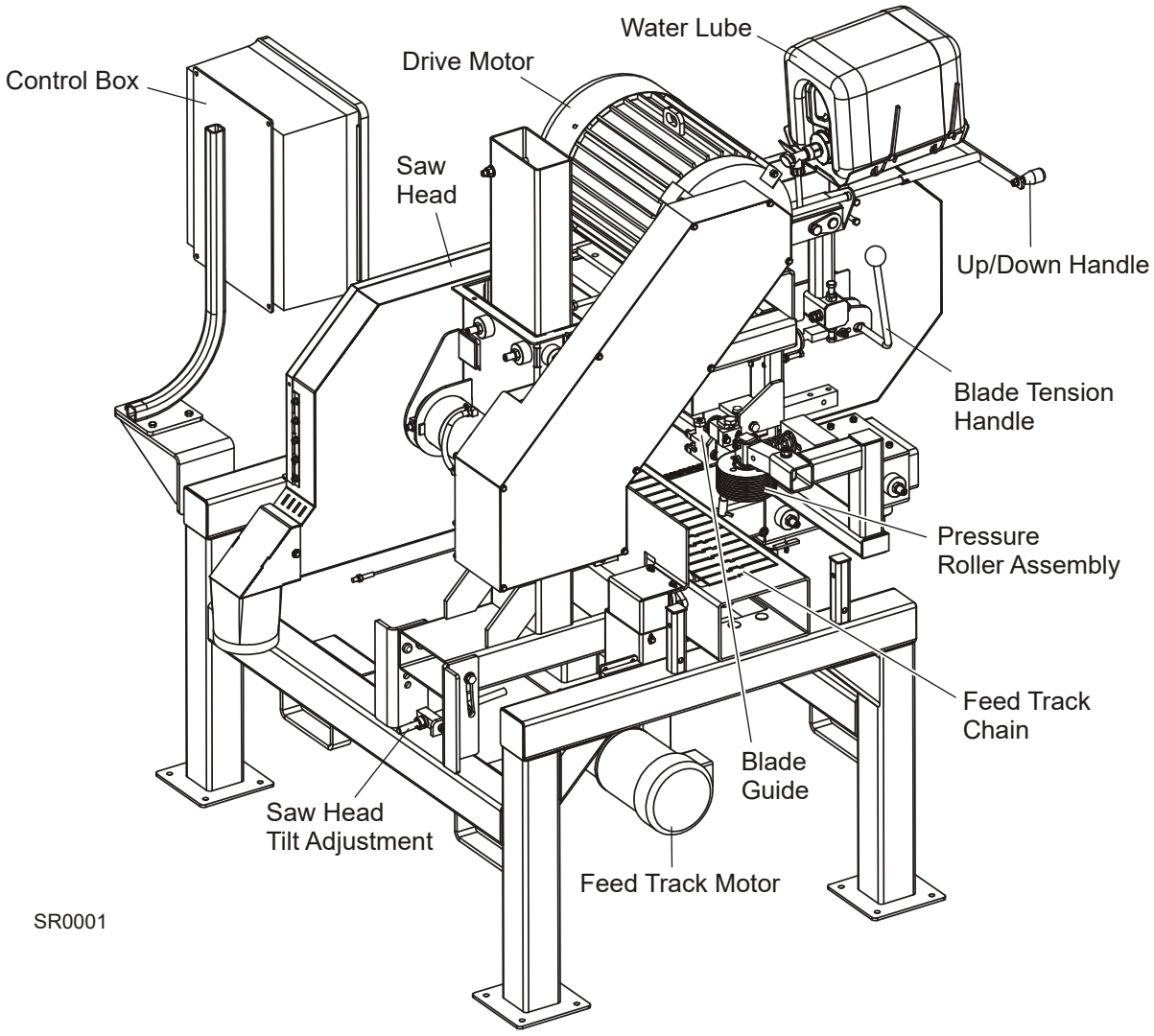
SECTION 1 INTRODUCTION

1.1 About This Manual

This manual is to replace or to be used with all previous information received on the Wood-Mizer® * Single Head Resaw. All future mailings will be an addition to or a revision of individual sections of this manual as we obtain new information.

The information and instructions given in this manual do not amend or extend the limited warranties for the equipment given at the time of purchase.



*Wood-Mizer® is a registered trademark of Wood-Mizer Products, Inc.

1.2 Getting Service

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

General Contact Information

Toll free phone numbers are listed below for the *continental* U.S. and Canada. See the next page for contact information for more Wood-Mizer locations.

	United States	Canada
Sales	1-800-553-0182	1-877-866-0667
Service	1-800-525-8100	1-877-866-0667
Website	www.woodmizer.com	www.woodmizer.ca
E-mail	woodmizer@woodmizer.com	oninfo@woodmizer.com

Office Hours: All times are Eastern Standard Time.

Monday - Friday	Saturday (Indianapolis Office Only)	Sunday
8 a.m. to 5 p.m.	8 a.m. to 12 p.m.	Closed

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

Wood-Mizer will accept these methods of payment:

- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order. In most cases, items will ship on the day they are ordered. Second Day and Next Day shipping are available at additional cost.

If your sawmill was purchased outside the United States or Canada, contact the distributor for service.

Wood-Mizer Locations

USA World Headquarters

Serving North & South America, Oceania, East Asia

Wood-Mizer LLC
8180 West 10th Street
Indianapolis, IN 46214

Phone: 317.271.1542 or 800.553.0182
Customer Service: 800.525.8100
Fax: 317.273.1011
Email: infocenter@woodmizer.com

Canadian Headquarters

Serving Canada

Wood-Mizer Canada
396 County Road 36, Unit B
Lindsay, ON K9V 4R3

Phone: 705.878.5255 or 877.357.3373
Fax: 705.878.5355
Email: ContactCanada@woodmizer.com

Brazil Headquarters

Serving Brazil

Wood-Mizer do Brasil
Rua Dom Pedro 1, No: 205 Bairro: Sao Jose
Ivoti/RS CEP:93.900-000

Tel: +55 51 9894-6461/ +55 21 8030-3338/ +55 51 3563-4784
Email: info@woodmizer.com.br

Europe Headquarters

Serving Europe, Africa, West Asia

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

Phone: +48.63.26.26.000
Fax: +48.63.27.22.327

Branches & Authorized Sales Centers

For a complete list of dealers, visit www.woodmizer.com

1.3 Customer and Equipment Identification

An identification plate is located on the frame of the saw. The plate contains the serial number and configuration information of your machine. You will also receive a customer number when you purchase your machine.

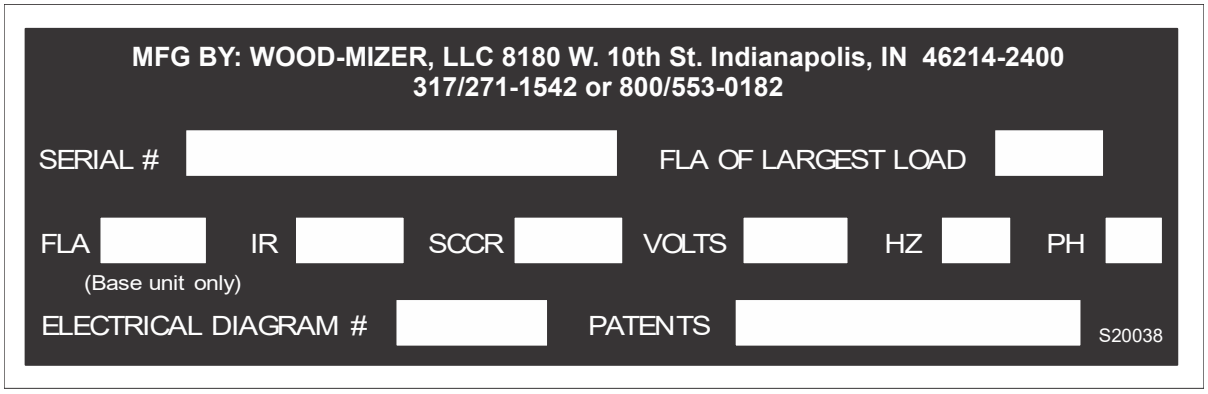
These numbers will help expedite our service to you. Please locate them now and write them below so you have quick, easy access to them.

Identification Information (To be filled in by purchaser)

Model No. _____

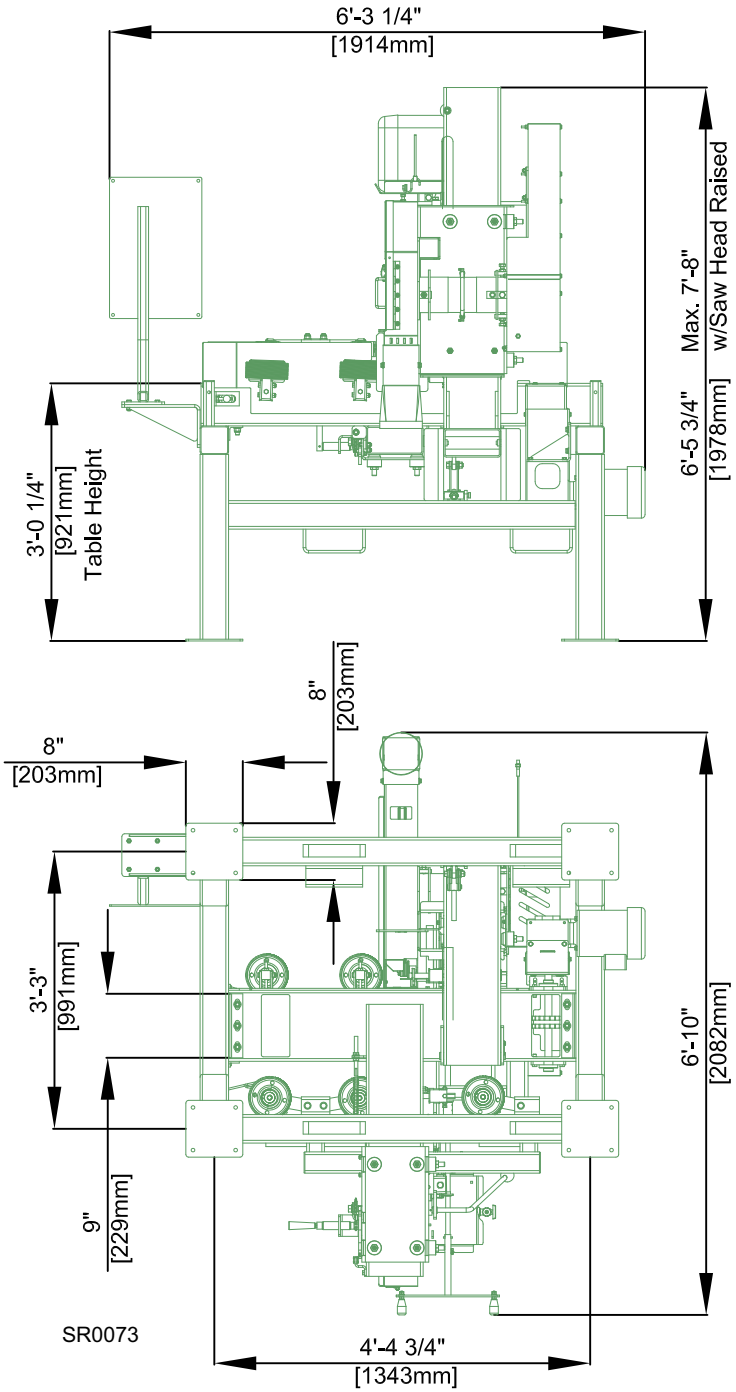
Serial No. _____

Customer No. _____



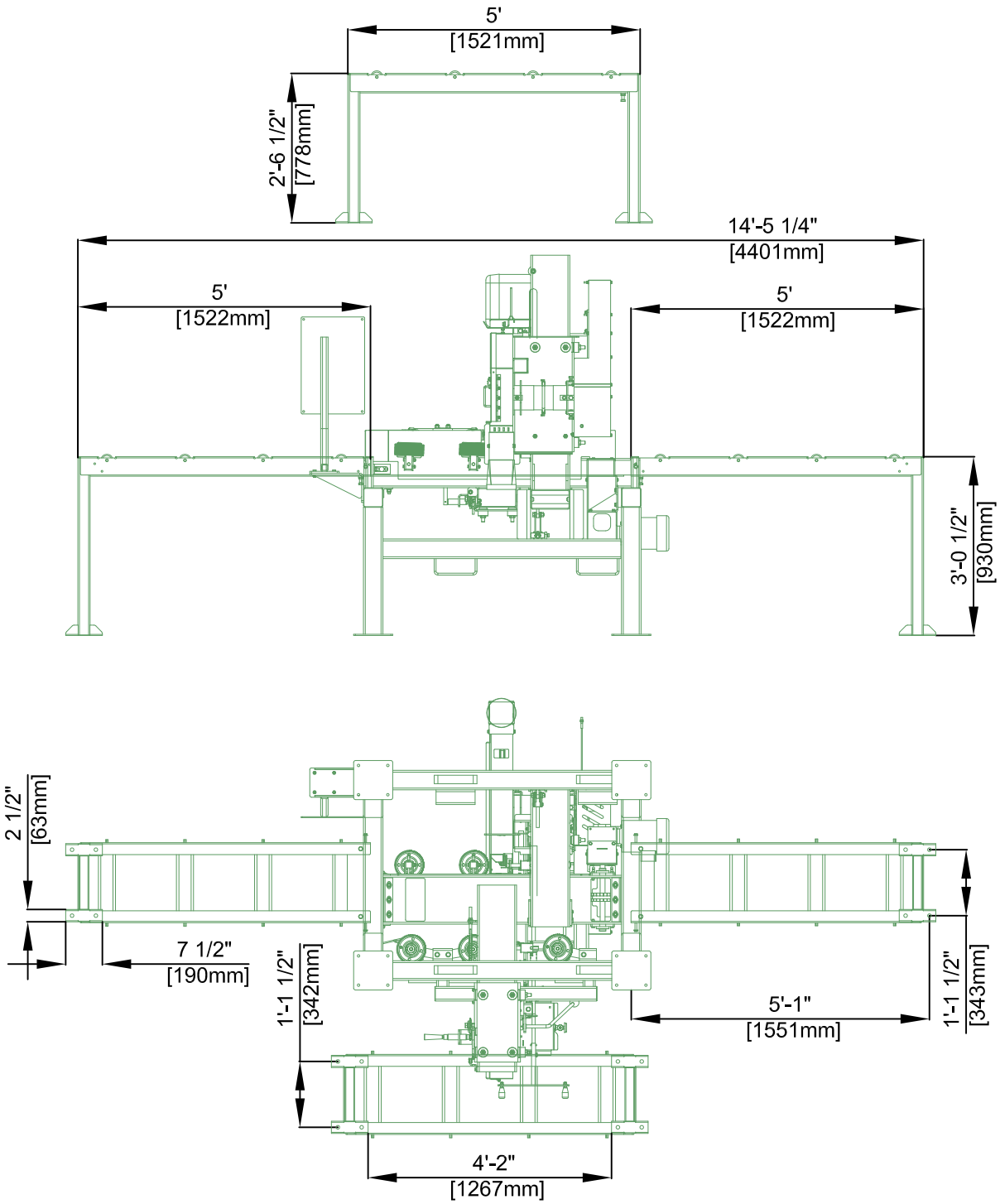
IDENTIFICATION PLATE

1.4 Dimensions



SINGLE HEAD RESAW

SINGLE HEAD RESAW W/OPTIONAL LOADING TABLES



SINGLE HEAD RESAW W/TABLES

1.5 Specifications

Model: SHR Rev. A1.00+

Machine Dimensions:	
Length:	76"
Length w/Optional Loading Tables :	172 3/8"
Width:	82"
Minimum Width w/Optional Side Table:	102"
Minimum Height:	78"
Maximum Height (w/Saw Head Raised):	92"
Table Height:	36 7/8"
Weight (Basic Unit):	1200 lbs
Material Dimensions:	
Minimum Cut Height:	1/4"
Maximum Cut Height:	10 1/2"
Maximum Material Height:	25"
Minimum Material Length:	18"
Maximum Material Length:	Unlimited
Minimum Material Width:	1"
Maximum Material Width:	10"
Feed System:	
Feed Rate:	0-100 Ft/Min
Feed Motor Horsepower:	1
Feed Motor RPM:	1725
Blade:	
Length:	158"
Standard Width:	1 1/4"
Optional Width:	1 1/2"
Profile:	Many types available depending upon cutting needs

Blade Motor:	**E10**	**E20**	**E25**
Manufacturer:	Lincoln	Lincoln	Lincoln
Horsepower Rating:	10	20	25
Weight:	128 lbs.	287 lbs.	380 lbs.
Speed:	1745 RPM	1755 RPM	1775 RPM
Drive Belt:	3/5V800	3/5V800	3/5V800

Electrical Requirements:	**SHR-10**	**SHR20-H***	**SHR20-380**	**SHR20-L**	**SHR25-H****	**SHR25-L**
Fused Disconnect:	100 Amps	60 Amps	60 Amps	100 Amps	60 Amps	100 Amps
Time Delay Fuse:	70 Amps	40 Amps	40 Amps	80 Amps	50 Amps	100 Amps
Suggested Wire Size:	6AWG	8AWG	8AWG	4AWG	8AWG	3AWG
FLA of Largest Load:	41.5	24.1	24.1	48.2	29.4	58.8
Machine FLA:	45.5	26.2	26.2	52.5	31.5	63
AIC/SCCR:	200K/5K	200K/5K	200K/5K	200K/5K	200K/5K	200K/5K
Volts/Hz/Phase:	230/60/1	460/50-60/3	380/50-60/3	230/50-60/3	460/50-60/3	230/50-60/3

*Use transformer kit 054930 for use with 575V
**Use transformer kit 054929 for use with 575V

SINGLE HEAD RESAW SPECIFICATIONS

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.

WARNING! Clean sawdust from all guards, vents, control boxes, or any area where sawdust may gather **after every shift**. Failure to do so may result in fire, causing death or serious injury.

OBSERVE SAFETY INSTRUCTIONS

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

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

Only persons who have read and understood the entire operator's manual should operate the Single Head Resaw. The Single Head 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 Single Head Resaw. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the Single Head Resaw.

WEAR SAFETY CLOTHING

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

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

WARNING! Always wear eye, ear, respiration, and foot protection when operating or servicing the resaw.

KEEP RESAW AND AREA AROUND RESAW CLEAN

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

HANDLE LUBRICANTS SAFELY

WARNING! Use ONLY water with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so may result in serious injury or death.

DISPOSE OF SAWING BY-PRODUCTS PROPERLY

IMPORTANT! Always properly dispose of all sawing by-products, including sawdust and other debris.

CHECK RESAW BEFORE OPERATION

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

Be sure the blade housing and pulley covers are in place and secure. Use the cover latch to secure blade housing covers.

WARNING! Check for proper rotation of the blade before operating the machine. Failure to do so may result in serious injury and/or machine damage.

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

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

WARNING! Use both hands to operate the blade tensioner handle. Failure to do so may result in injury.

KEEP PERSONS AWAY

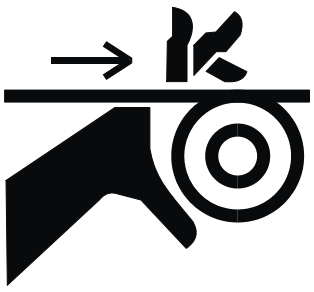
DANGER! Keep all persons out of the path of moving equipment and boards when operating the resaw. Failure to do so will result in serious injury.

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

DANGER! Always be aware of and take proper protective measures against rotating shafts, pulleys, sprockets, 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! Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

WARNING! Coastdown Required. Always shut down the resaw 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.

WARNING! Always keep clear of exiting sawdust. Keep hands, feet and any other objects away from the sawdust chute when operating resaw. Failure to do so may result in serious injury.

USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND MAINTENANCE

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! ARC FLASH AND SHOCK HAZARD! Hazardous voltage inside the electric sawmill disconnect box, starter box, 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 resaw operation. Wear appropriate Personal Protection Equipment.

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.

WARNING! Remove the blade before performing any service to the motor or resaw. Failure to do so may result in serious injury.

DANGER! Lockout procedures must be used during:

Changing or adjusting blades
Unjamming operations
Cleaning
Mechanical repair
Electrical maintenance
Retrieval of tools/parts from work area
Activities where guards or electrical panel guard is open or removed

Maintenance hazards include:

Blade contact
Pinch points
Kickbacks
Missiles (thrown blades/wood chips)
Electrical

Failure to lockout may result in:

Cut
Crush
Blindness
Puncture
Serious injury and death
Amputation
Burn
Shock
Electrocution

To control maintenance dangers:

Lockout procedures must be followed (see ANSI Standard Z244.1-1982 and OSHA regulation 1910.147).
Never rely on machine stop control for maintenance safety (emergency stops, on/off buttons, interlocks).
Do not reach into moving blades or feed systems. Allow all coasting parts to come to a complete stop.
Electrical power supply and air supply must both be locked out.
Where established lockout procedures cannot be used (electrical troubleshooting or mechanical dynamic troubleshooting), alternative effective protective techniques shall be employed which may require special skills and planning.
Always follow safe operations practices in the workplace.

RESAW LOCKOUT PROCEDURE

Lockout procedures must be followed (see ANSI Standard Z244.1-1982 and OSHA regulation 1910.147).

Purpose:

This procedure establishes the minimum requirements for lockout of energy sources that could cause injury.

Responsibility:

The responsibility for seeing that this procedure is followed is binding upon all workers. All workers shall be instructed in the safety significance of the lockout procedure. It is your responsibility to ensure safe operation and maintenance of the machine.

Sequence of Lockout Procedure:

1. Notify all persons that a lockout is required and the reason therefore.
2. If the resaw is operating, shut it down by the normal stopping procedure.
3. Operate the switch so that the energy sources are disconnected or isolated from the resaw. Stored energy such as moving blades and feed system shall be dissipated.
4. Lockout the energy isolating devices with assigned individual locks.
5. After ensuring that no persons are exposed and as a check on having disconnected the energy sources, operate the push button or other normal operating controls to make certain the resaw will not operate. Caution: Return operating controls to neutral position after the test.
6. The resaw is now locked out.

Restoring Equipment to Service

1. When the job is complete and the resaw is ready for testing or normal service, check the resaw area to see that no one is exposed.
2. When the resaw is all clear, remove all locks. The energy isolating devices may be operated to restore energy to the resaw.

Procedure Involving More Than One Person

In the preceding steps, if more than one individual is required to lock out the resaw, each shall place his own personal lock on the energy isolating devices.

Rules for Using Lockout Procedure

The resaw shall be locked out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch or valve bearing a lock.

Owner's Responsibility

The procedures listed in this manual may not include all ANSI, OSHA, or locally required safety procedures. It is the owner/operator's responsibility and not Wood-Mizer Products to ensure all operators are properly trained and informed of all safety protocols. Owner/Operators are responsible for following all safety procedures when operating and performing maintenance to the resaw.

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.

SECTION 3 SETUP AND OPERATION

3.1 Setup

Use a forklift or other appropriate equipment to move the resaw.

WARNING! Use extreme care and proper equipment to lift and move the resaw. Lift the machine from sides only, never from under the front or rear of the base or upper carriage. Failure to do so may result in personal injury and/or machine damage.

See Figure 3-1.

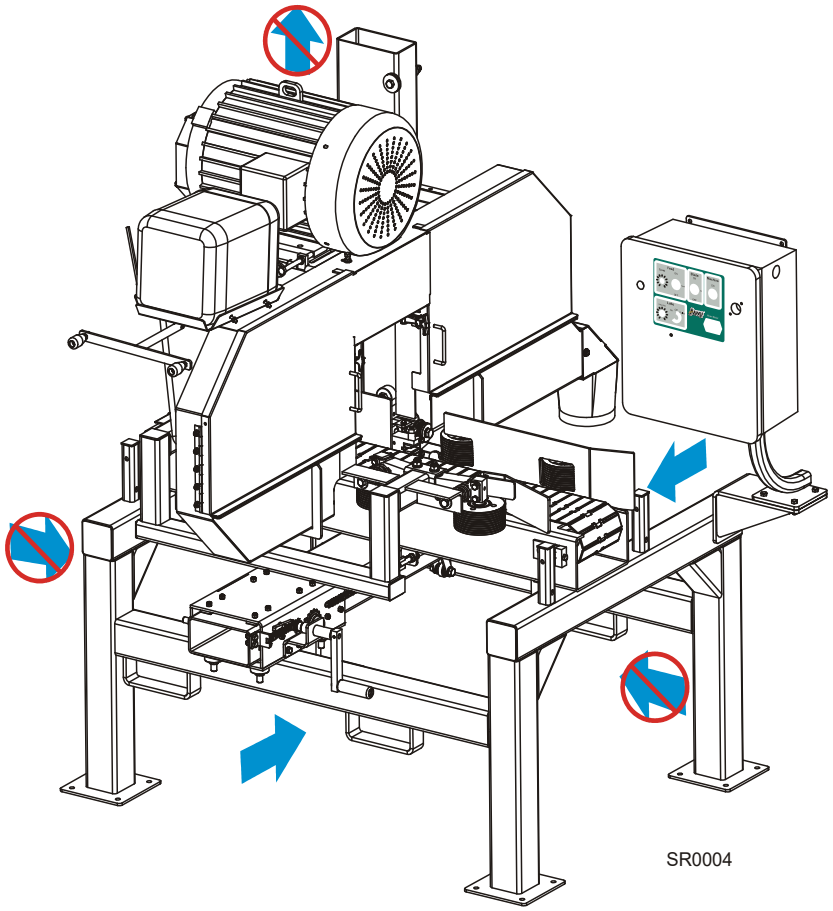


FIG. 3-1

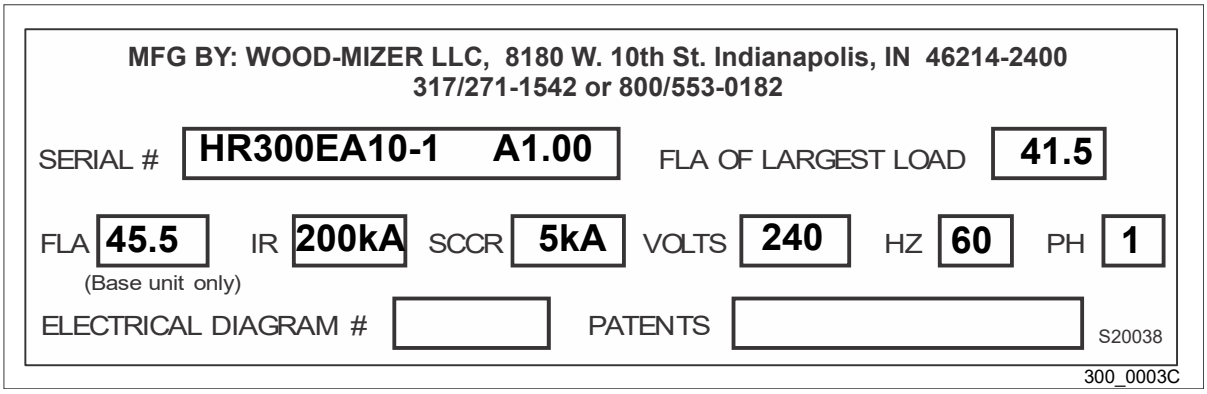
Place the resaw on a concrete foundation strong enough to support the weight of the machine. Allow for room around the resaw to feed and remove material. Secure the resaw to the foundation with anchor bolts.

3.2 Electrical Installation

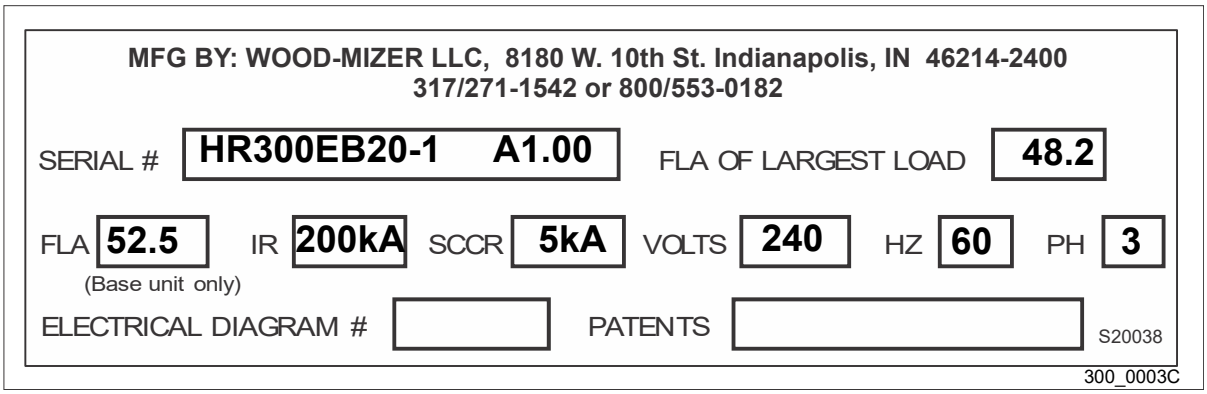
DANGER! Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.

DANGER! Hazardous voltage inside the electric control box 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 resaw operation.

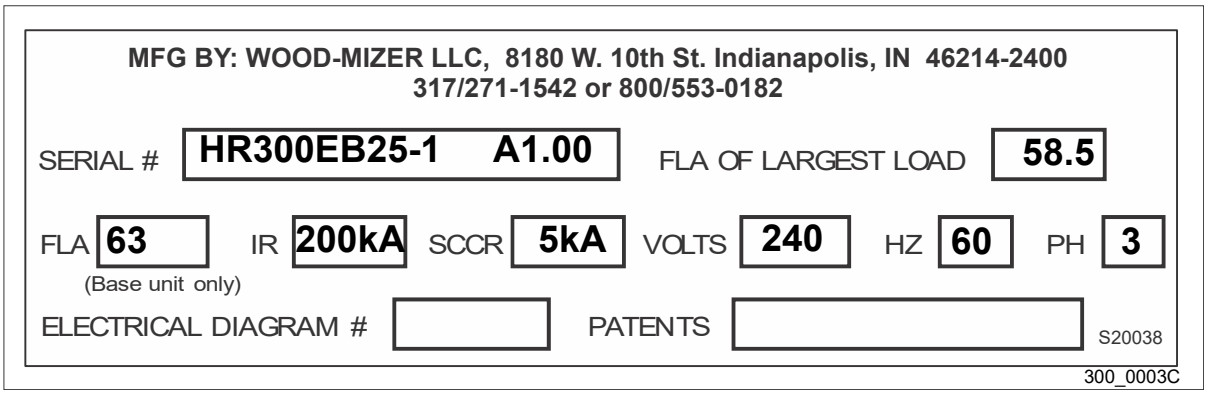
The resaw identification plates including the required electrical information are shown below:



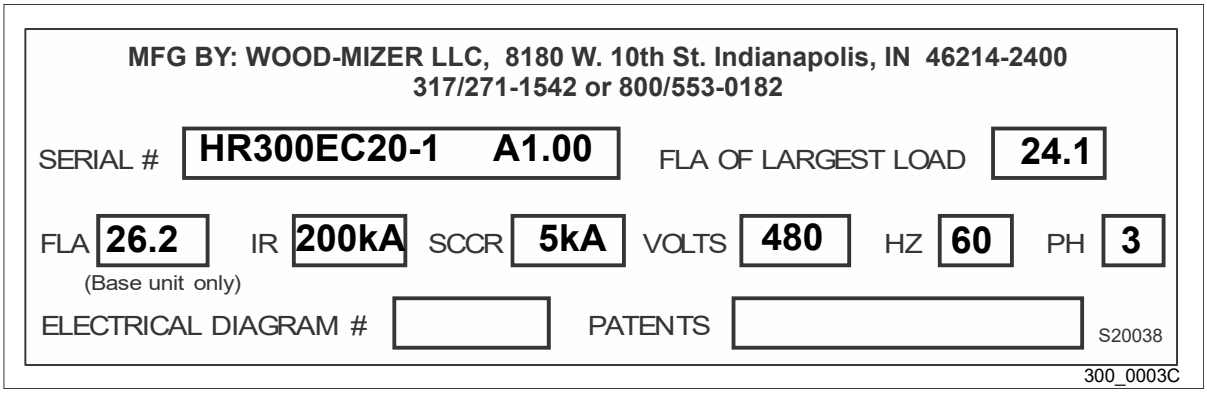
HR300EA10-1 IDENTIFICATION PLATE



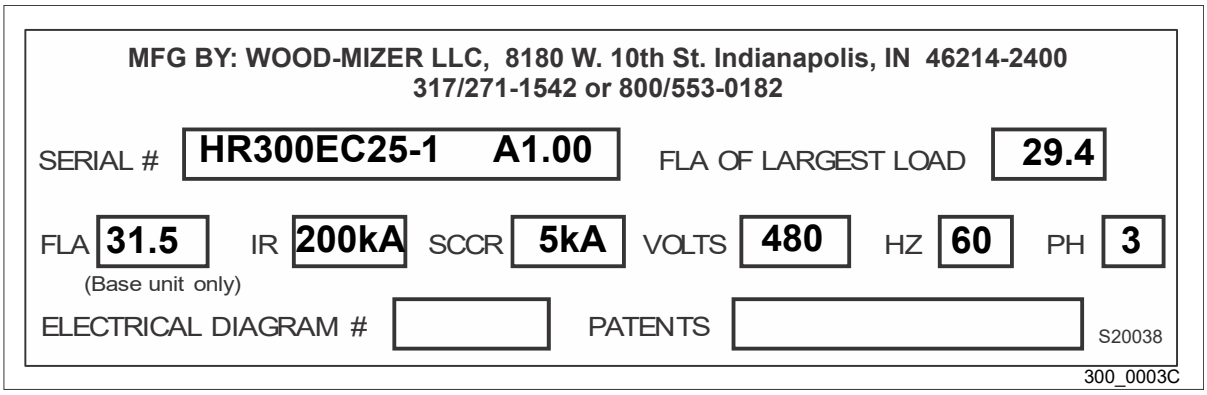
HR300EB20-1 IDENTIFICATION PLATE



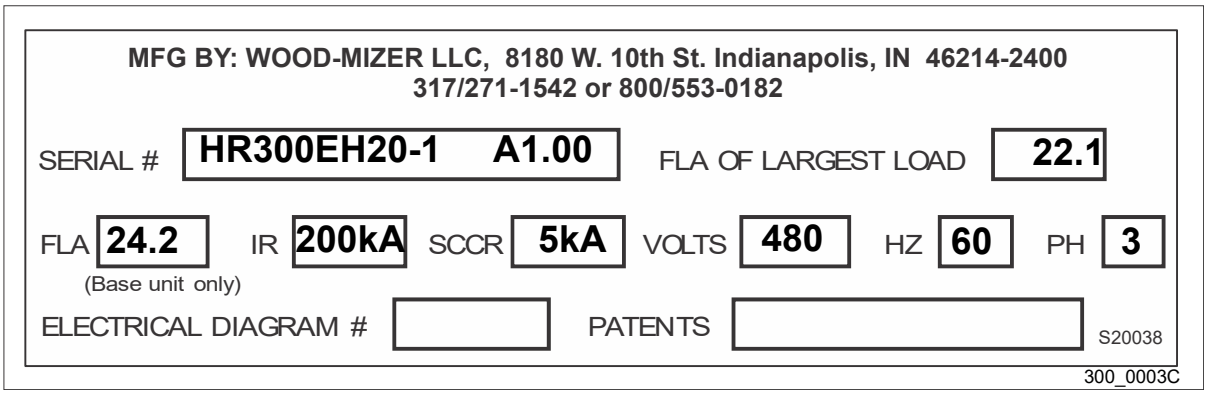
HR300EB25-1 IDENTIFICATION PLATE



HR300EC20-1 IDENTIFICATION PLATE



HR300EC25-1 IDENTIFICATION PLATE



HR300EH20-1 IDENTIFICATION PLATE

IMPORTANT! The resaw is wired for use with a 240 or 480 volt power supply. To operate other power supplies an additional transformer is required. See the table below for transformers available from Wood-Mizer. All transformers are manufactured by Square D.

See Table 3-1.

Conversion To	240 volts	400 volts	480 volts	600 volts
HR300EA10-1	N/A	N/A	N/A	N/A
HR300EB20-1	X	078212	X	078213
HR300EB25-1	X	078212	X	078213
HR300EC20-1	X	X	X	068047
HR300EC25-1	X	069616	X	068047
HR300EH20-1	X	X	X	X

TABLE 3-1

Perform the following steps prior to operating the resaw to make required electrical connections:

600V configuration only: Transformer can be purchased separately for the resaw (part no. 068047 for 25HP and part no. 068049 for 20HP).

1. Unlock and open the control box on the resaw.

2. Locate the main disconnector in the upper right corner of the control box. Route the power supply cable through the control box side hole next to the disconnector. Connect the power supply wires to the main disconnector in the control box as shown below. **IMPORTANT!** If the blade motor runs backwards, switch any two of the three incoming high voltage wires connected to terminals L1, L2 or L3 to reverse the motor rotation.

See Figure 3-2.

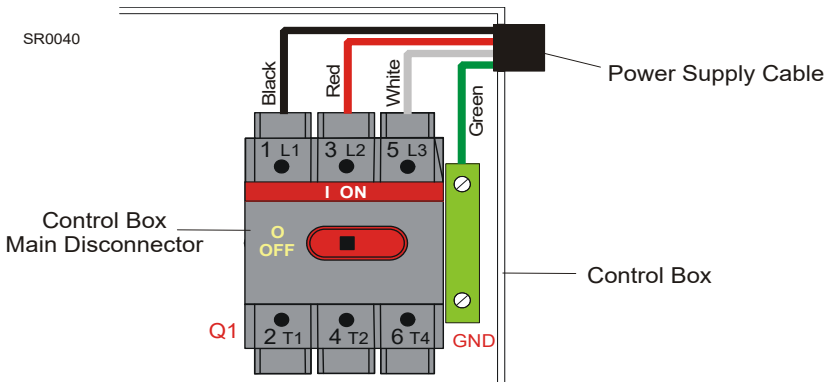


FIG. 3-2

3. Close and lock the resaw control box.

4. Check for proper rotation of the resaw blade. The infeed will always rotate the correct direction, but the blade rotation can be reversed. Push the MACHINE-ON button and then the BLADE-ON button. The blade should spin counterclockwise as viewed from the control side of the saw head. If the blade spins in the wrong direction, turn off the machine, disconnect and lockout the electrical power and check the wiring. *See SECTION 14* for electrical wiring diagrams.

WARNING! Check for proper rotation of the blade before operating the machine. Failure to do so may result in serious injury and/or machine damage.

3.3 Replacing The Blade

DANGER! Always disengage the blade and shut off the resaw motor before changing the blade. Failure to do so will result in serious injury.

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

Open the two blade housing covers that cover the blade wheels. Lower the hinged middle blade housing cover. Turn the blade tension handle to release the blade tension until the wheel is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

When installing a blade, make sure the teeth are pointing the correct direction. The teeth should be pointing toward the infeed and sawdust chute sides of the resaw. Install the blade so it is lying around the wheels.

Position 1 1/4” wide blades on the wheels so the gullet is 1/8" (3.0 mm) out from the edge of the wheel. Position 1 1/2” wide blades on the wheels so the gullet is 3/16” (4.5 mm) out from the edge of the wheel.

Close the blade housing cover.

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

3.4 Tensioning The Blade

The blade tensioner is factory-set so proper blade tension is achieved when the rubber spring is compressed 1/4” (6.3 mm). An indicator bolt is provided to indicate when the rubber spring has been compressed properly. To tension the blade, turn the blade tension handle up until it locks in place.

WARNING! Use both hands to operate the blade tensioner handle. Failure to do so may result in injury.

Check the back side of the rubber spring washer is aligned with the indicator bolt head. If not, release the blade tension and turn the tensioner shaft counterclockwise to compress the rubber spring more; clockwise to compress the rubber spring less.

See Figure 3-3. Use the scalloped disk to turn the tensioner shaft.

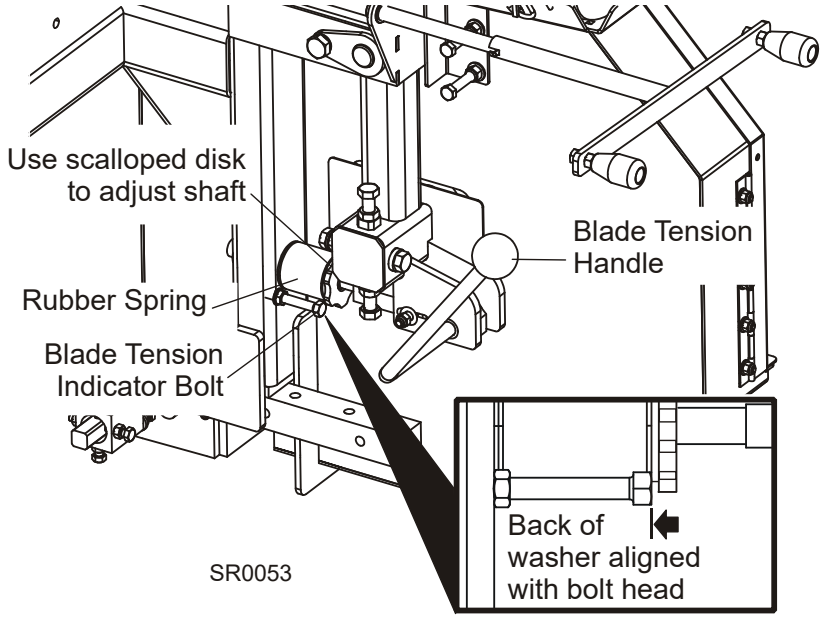


FIG. 3-3

Tension the blade and recheck the alignment of the rubber spring washer with the indicator bolt head.

Check the blade tension occasionally when adjusting the cant control or while cutting. As the blade and belts heat up and stretch, the blade tension will change. Adjust the tensioner shaft as necessary to maintain proper blade tension.

3.5 Tracking The Blade

1. Make sure the blade housing covers are closed and all persons are clear of the open side of the saw head.

2. Start the motor, rotating the blade until the blade positions itself on the wheels.

> **WARNING!** Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

3. Turn off the motor, open the blade housing covers and check the position of the blade on the blade wheels.

   See Figure 3-4. Position 1 1/4” wide blades so the gullet is 1/8" (3.0 mm) out from the edge of the blade wheel (±1/16 [1.5 mm])(±1/32 [.75 mm]). Position 1 1/2” blades so the gullet is 3/16” (4.5 mm) out from the edge of the blade wheel (±1/16 [1.5 mm]).

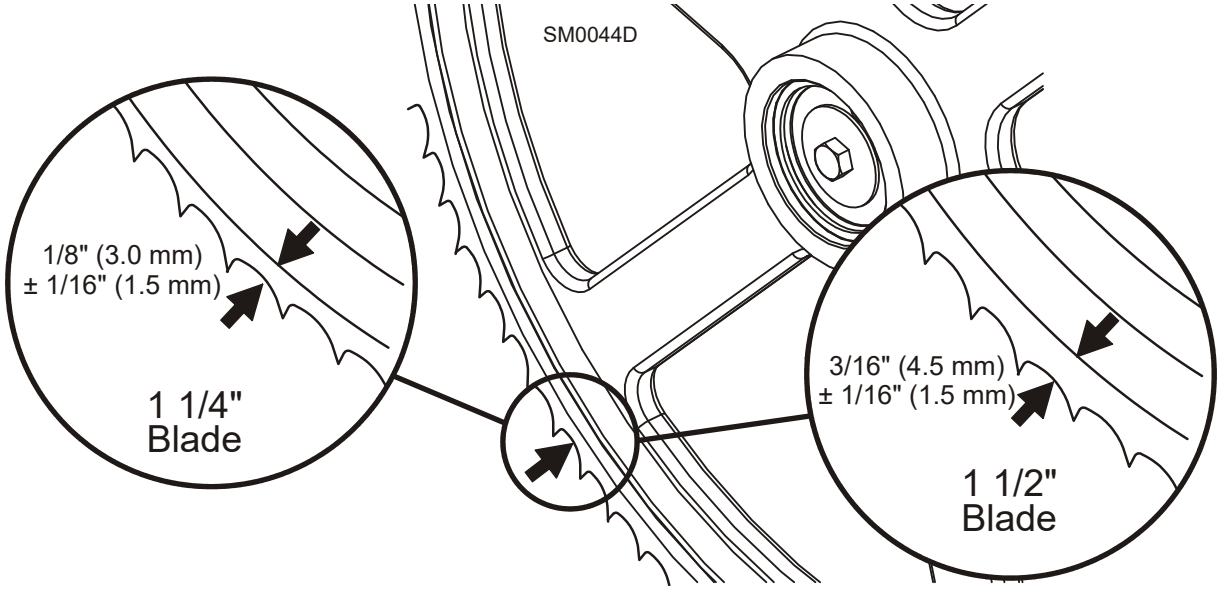


FIG. 3-4

See Figure 3-5. To adjust where the blade travels on the blade wheels, use the cant control.

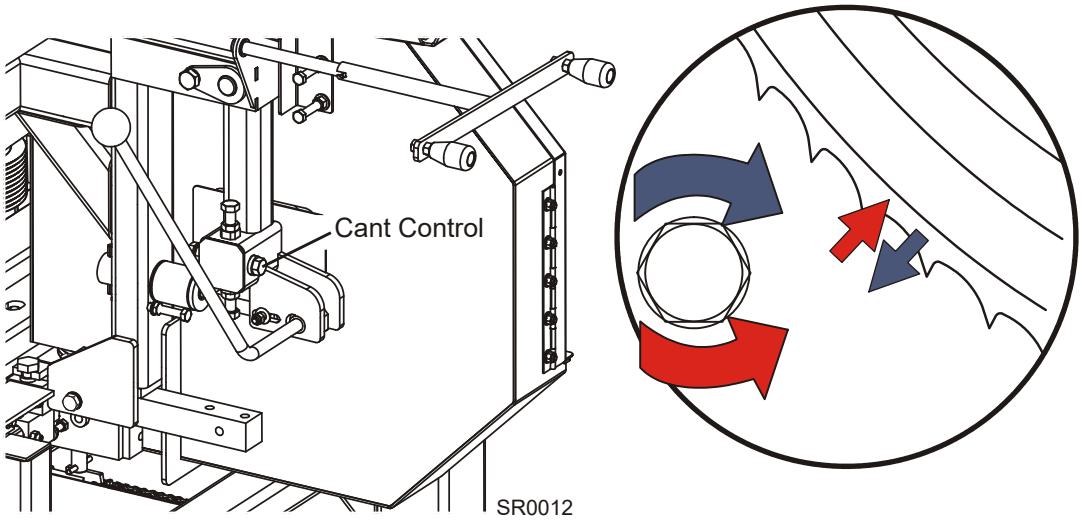


FIG. 3-5

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

4. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.

5. Close the blade housing covers.

DANGER! Make sure all guards and covers are in place and secured before operating the resaw. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure.

IMPORTANT! After aligning the blade on the wheels, always double-check the blade guide spacing and location. (*See Section 5* for more information.)

3.6 Starting And Stopping The Machine

DANGER! Make sure all guards and covers are in place and secured before operating the resaw. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure.

DANGER! Always be sure all persons are away from the resaw before starting the motor. Failure to do so will result in serious injury.

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

1. If necessary, release the MACHINE E-STOP button by turning it clockwise until it pops out.

   See Figure 3-2. The main control box has switches to start and stop resaw functions.

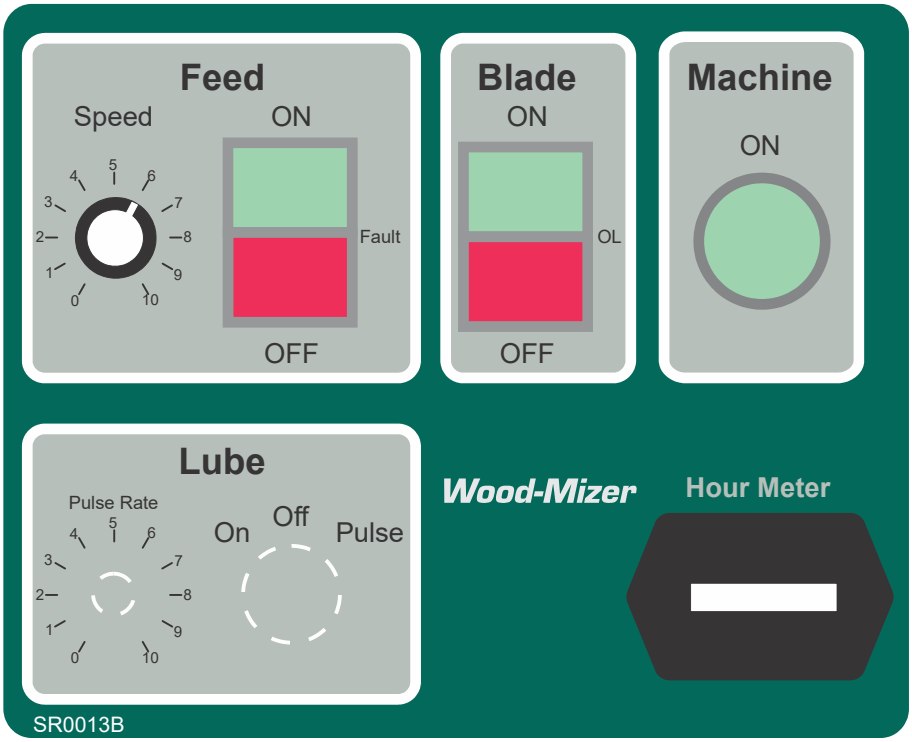


FIG. 3-2

2. To turn the resaw power on, push the green MACHINE-ON button on the control box.

3. Push the BLADE-ON button to start the resaw blade.

4. Push the FEED-ON button to start the resaw feed system.

5. Adjust the feed rate with the feed speed potentiometer. Turn the feed rate switch clockwise to increase the feed rate as desired. Maximum feed rate varies with width and hardness of the wood.

The switches on the control box can be used to shutdown the resaw.

1. Push the MACHINE-E-STOP button in an emergency to stop and shut down the resaw. This button must be released by turning clockwise before the resaw can be restarted.

2. Push the FEED-OFF or BLADE-OFF buttons to stop the corresponding functions without shutting down the machine.

3.7 Up/Down Operation

1. Install a blade, if needed, and check for correct blade tension. (*See Section 3.3*).

2. Set the saw head to the desired height. (The blade height scale shows the height of the blade above the feed chain.)

See Figure 3-1. Use the up/down crank handle to raise or lower the saw head. Turn the handle clockwise to raise the saw head or counterclockwise to lower the saw head.

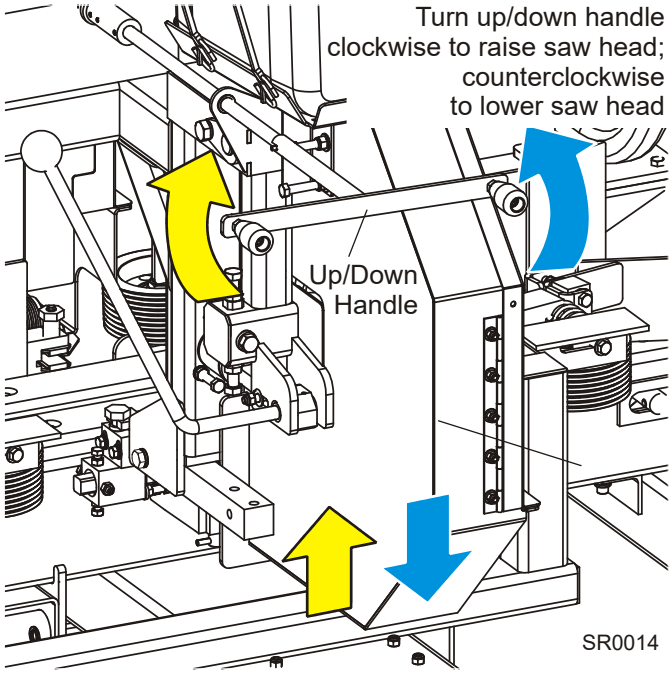


FIG. 3-1

3.8 Saw Head Tilt Adjustment

See Figure 3-2. Use the tilt adjustment bolt to tilt the saw head as desired. Install the crank handle from the up/down system to the tilt adjustment bolts, if necessary. Remove the locking bolt from one of the tilt adjustment holes. Loosen the two bolts in the slotted holes. Turn the crank handle clockwise or counterclockwise to tilt the saw head as shown.

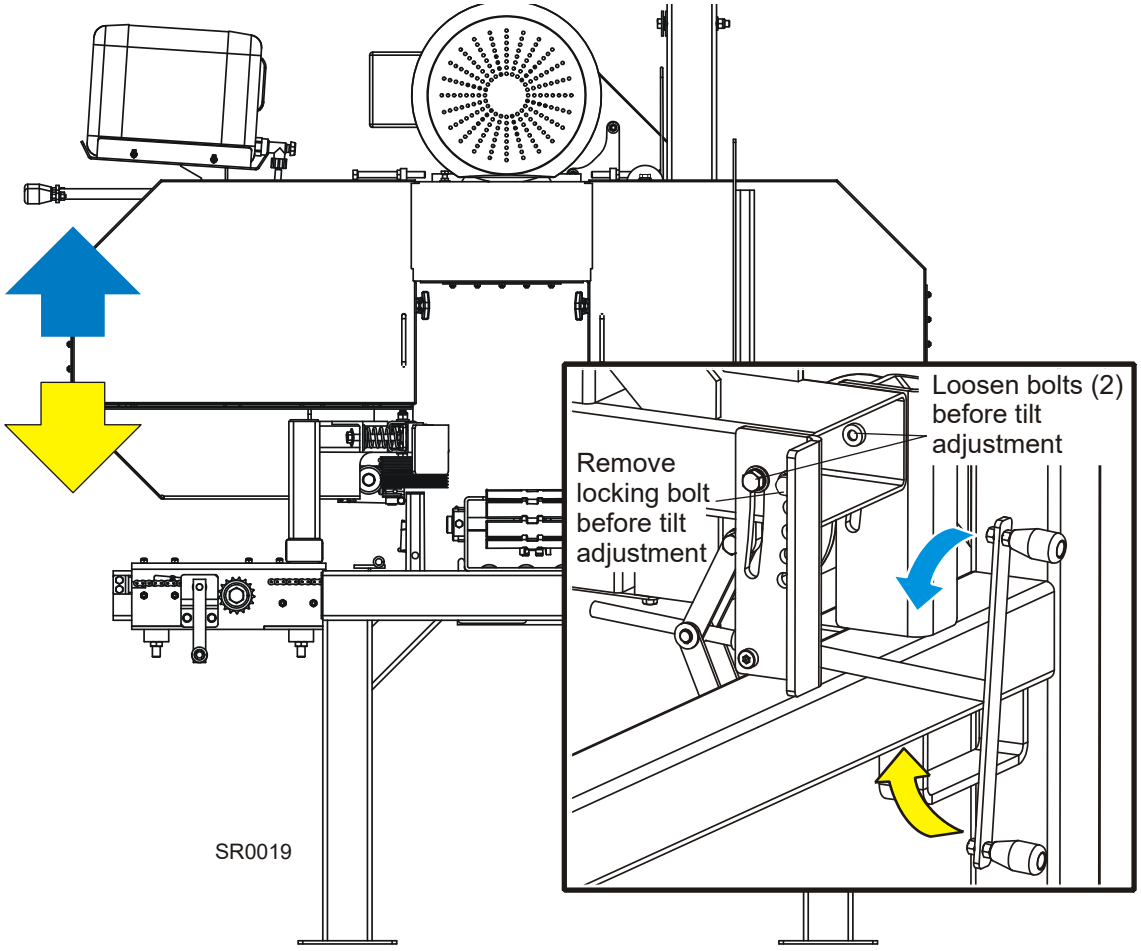


FIG. 3-2

Replace the locking bolt in the hole to secure the saw head in place as desired. **NOTE:** Each hole is an additional 2-degree saw head tilt. This allows to tilt the saw head up to 8 degrees.

Retighten the two bolts in the slotted holes when done to secure the saw head.

3.9 Pressure Roller Adjustment

See Figure 3-3. Use the crank handle to move the pressure roller assembly in or out. Turn the crank handle clockwise to move the pressure rollers closer to the stationary rollers. Lift the sprocket lock and turn the crank handle counterclockwise to move the pressure rollers away from the stationary rollers.

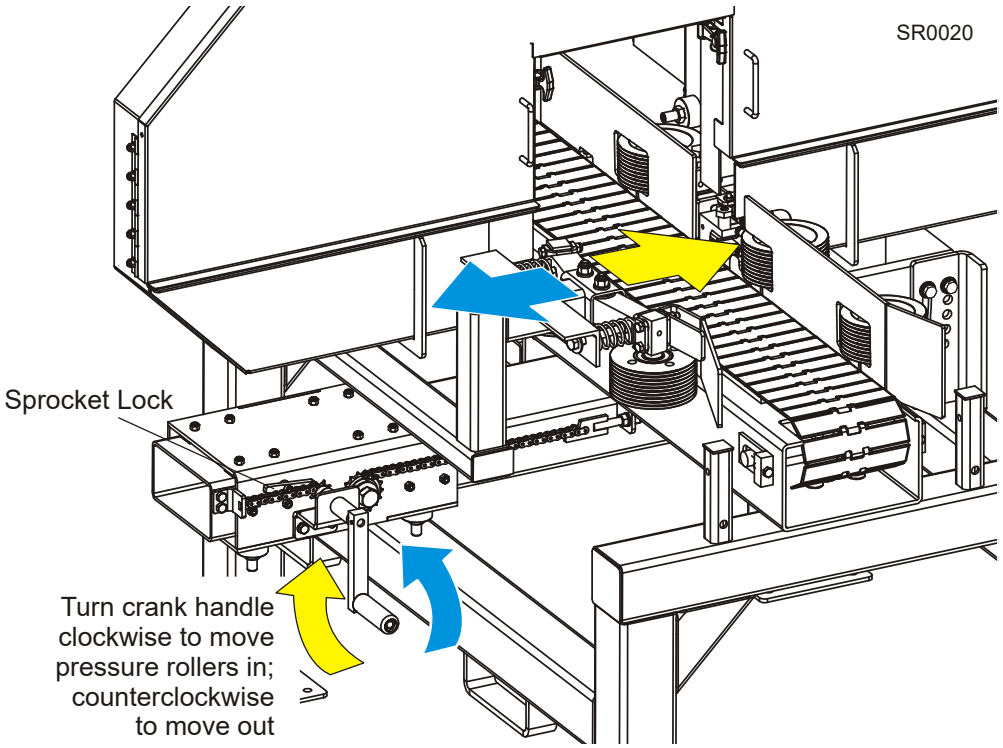


FIG. 3-3

Adjust the pressure roller assembly so its rollers are about 1” closer to the stationary rollers than the actual material width to be cut. This allows for the necessary pressure to be applied to feed the material into the feed system and make the cut.

3.10 Water Lube Operation

The Water Lube System keeps the blade clean. Water flows from a 5-gallon (18.9 liter) bottle through a hose to the blade guide where the blade enters the log. A valve in the bottle cap controls the amount of water flow.

See Figure 3-4.

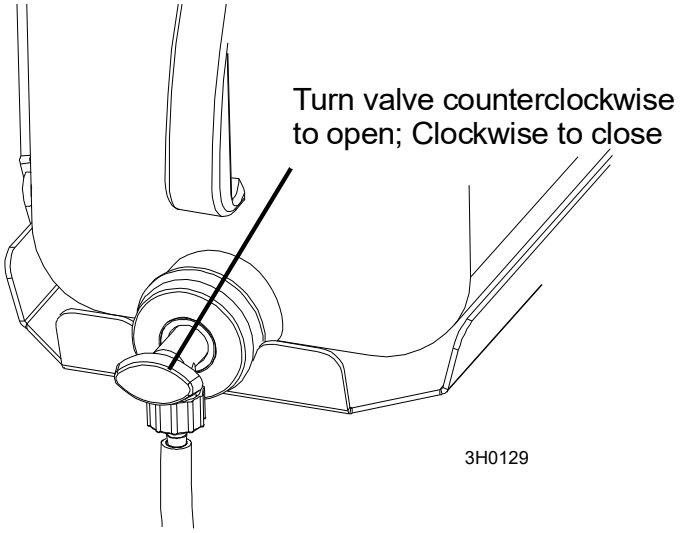


FIG. 3-4

Not all types of wood require the use of the Water Lube System. When it is needed, use just enough water to keep the blade clean. This saves water, and lowers the risk of staining the boards with water. Usual flow will be 1-2 gallons (3.8-7.6 liters) per hour.

Before removing the blade, let the blade spin with water running on it for about 15 seconds. This will clean the blade of sap buildup. Wipe the blade dry with a rag before storing or sharpening.

For further lubrication benefits, add one 12oz. bottle of Wood-Mizer Lube Additive to 5 gallons of water. Wood-Mizer Lube Additive enables some previously impossible timbers to be cut by significantly reducing resin buildup on the blade. It helps to reduce heat buildup, wavy cuts, and blade noise. This biodegradable and environmentally friendly pre-mix includes a water softener additive, so it works with hard water.

WARNING! Use ONLY water and Wood-Mizer Lube Additive with the water lube accessory. Never use flammable fuels or liquids such as diesel fuel. Failure to do so can damage the equipment and may result in serious injury or death.

If you are sawing in freezing temperatures, remove the water lube bottle from the resaw when done sawing and store it in a warm place. Blow any remaining water from the water lube hose.

If your resaw is equipped with the optional LubeMizer System, see the separate LubeMizer System manual for operation instructions.

3.11 The Lube-Mizer System (Optional)

This option is used in place of the standard Water Lube system to lubricate the blade during sawing. The Lube-Mizer option applies lubricant to both sides of the blade as you are sawing to reduce resin buildup on the blade. The system utilizes an automatic valve which activates the lubricant flow only when the blade is rotating. The Lube-Mizer control switches allow you to adjust the volume of lubricant for various wood types. The Lube-Mizer option uses less volume than the standard Water Lube, helping to reduce lubricant/sawdust mess and waste, and to prevent stained boards.

Usual flow will be between .07 and 2.5 gallons (2.6 - 9.5 liters) per hour.

1. To start the self-priming system,
   - Open the water lube bottle valve all the way.
   - Push the Blade-On button on the control box to start the blade.
   - Turn the lube control switch to PULSE * and set the lube dial to the desired flow rate. Use the lowest setting that successfully eliminates pitch buildup.

     NOTE: Softwood applications will usually require more lubricant than hardwood applications.
2. Cut the material as normal.
3. To shut off the lube,
   - Turn the lube control switch to OFF.
   - Close the lube bottle valve all the way.

*Pulse is suitable for most cutting applications. CONTINUOUS delivers a steady stream of lubricant and should be used only for heavy pitch buildup or occasional blade cleaning.

See Figure 3-1. The lube controls are shown in the following graphic.

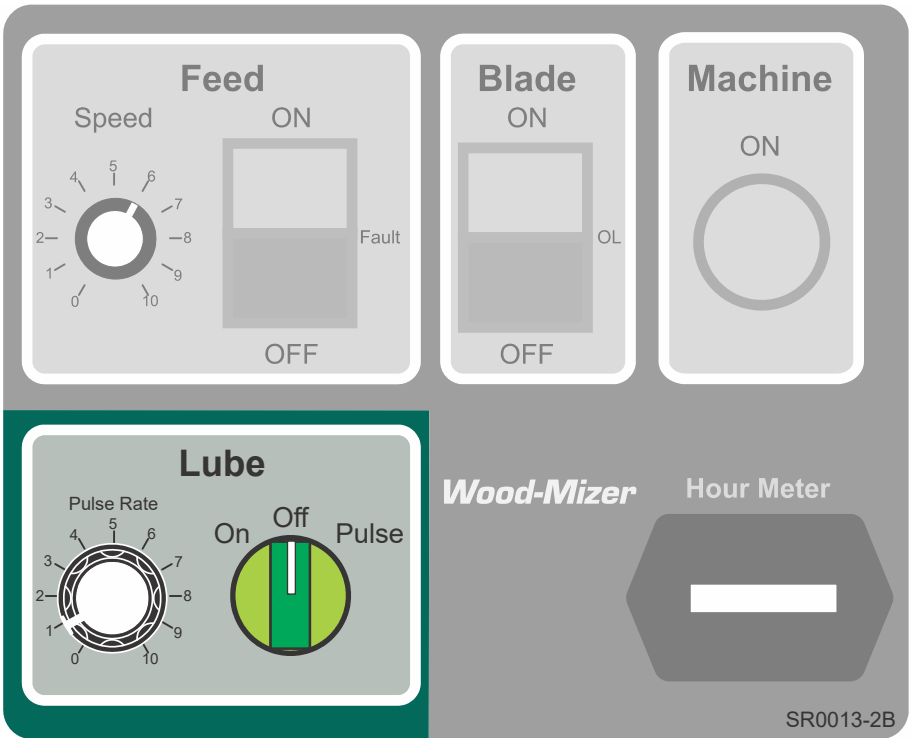


FIG. 3-2

4. If you are sawing or storing the resaw in freezing temperatures, use windshield washer fluid to help prevent the water from freezing

> **CAUTION!** Add windshield washer fluid to the water tank and prime as recommended when sawing or storing the resaw in below-freezing temperatures. Use windshield washer fluid with a freezing point of at least -20°F (-29°C). Failure to do so will cause damage to the Lube-Mizer system may result.

For further benefits, add one 12oz. bottle of Wood-Mizer Lube Additive to a 5 gallon jug of water. Wood-Mizer Lube Additive enables some previously impossible timbers to be cut by significantly reducing resin buildup on the blade. It helps to reduce heat buildup, wavy cuts, and blade noise. This biodegradable and environmentally friendly pre-mix includes a water softener additive, so it works with hard water.

WARNING! Use ONLY water, Wood-Mizer Lube Additive or windshield washer fluid with the water lube accessory. Never use flammable fuels or liquids such as diesel fuel. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so can damage the equipment and may result in serious injury or death.

See Table 3-3. Use windshield washer fluid as an antifreeze to prevent the water from freezing and damaging the Lube-Mizer system. See the chart below for recommended mixture levels depending on the temperature where you are sawing or storing the resaw.

Run the Lube-Mizer system on the “Continuous” setting for 30 seconds after adding the windshield washer fluid to the system. This will insure the water throughout the system will not freeze and damage the check valves.

Ratio WWF [1]:Water to fill 5 Gal. tank	Freezing Point Of Solution	
	(°F)	(°C)
5:0	-22	-30
4:1	-3	-19
3:2	7	-14
2.5:2.5	13	-10
1:4	24	-4
0:5	32	0

TABLE 3-3

[1] WWF = Windshield Washer Fluid with -20°F (-29°C) freezing point.

See Figure 3-2. A diagram showing the plumbing for the LMS system is provided for your reference.

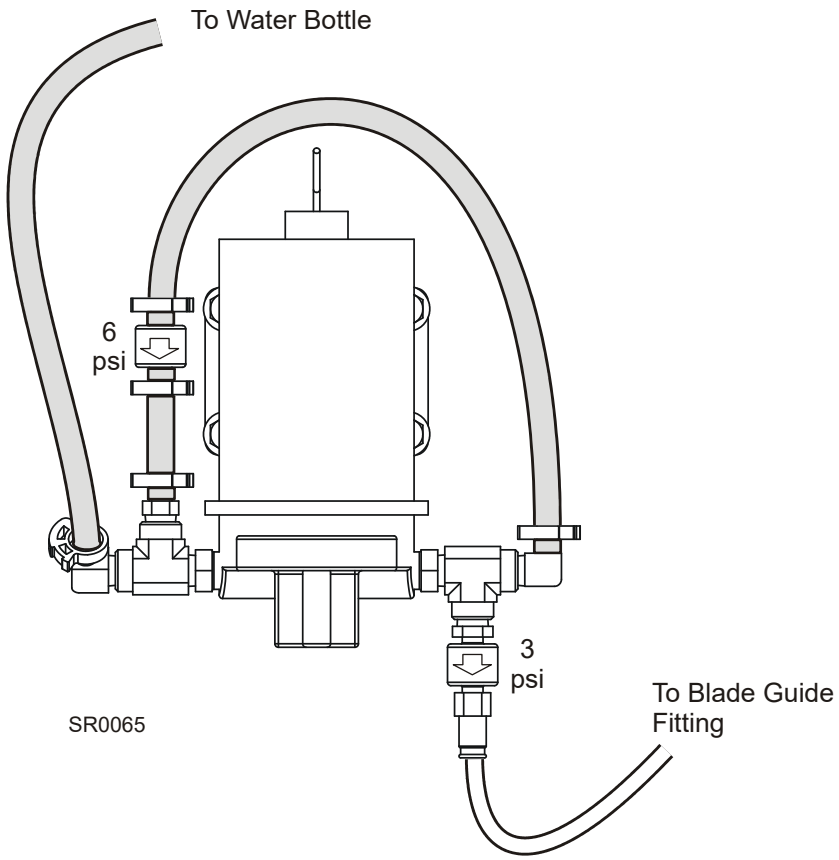


FIG. 3-2

3.12 Loading Tables Installation (Optional)

The resaw optional loading tables are available to provide assistance to operators to better handle the material. The Loading Table Assembly (Part No. 054464) includes two front/rear end tables and one side table. The front/rear tables are used to feed and pick up material by operators on both ends of the machine. The side table is provided to help transfer unfinished material to the front operator to proceed with another cut.

WARNING! Always disconnect and lockout power before performing any service to the resaw. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

To install the loading tables to the resaw, perform the following steps:

1. Disconnect the power supply to the resaw and perform the lockout procedure.

2. Place both end tables next to the front and rear ends of the machine. Use the provided fasteners to secure the front and rear end tables to the resaw frame as shown.

See Figure 3-3.

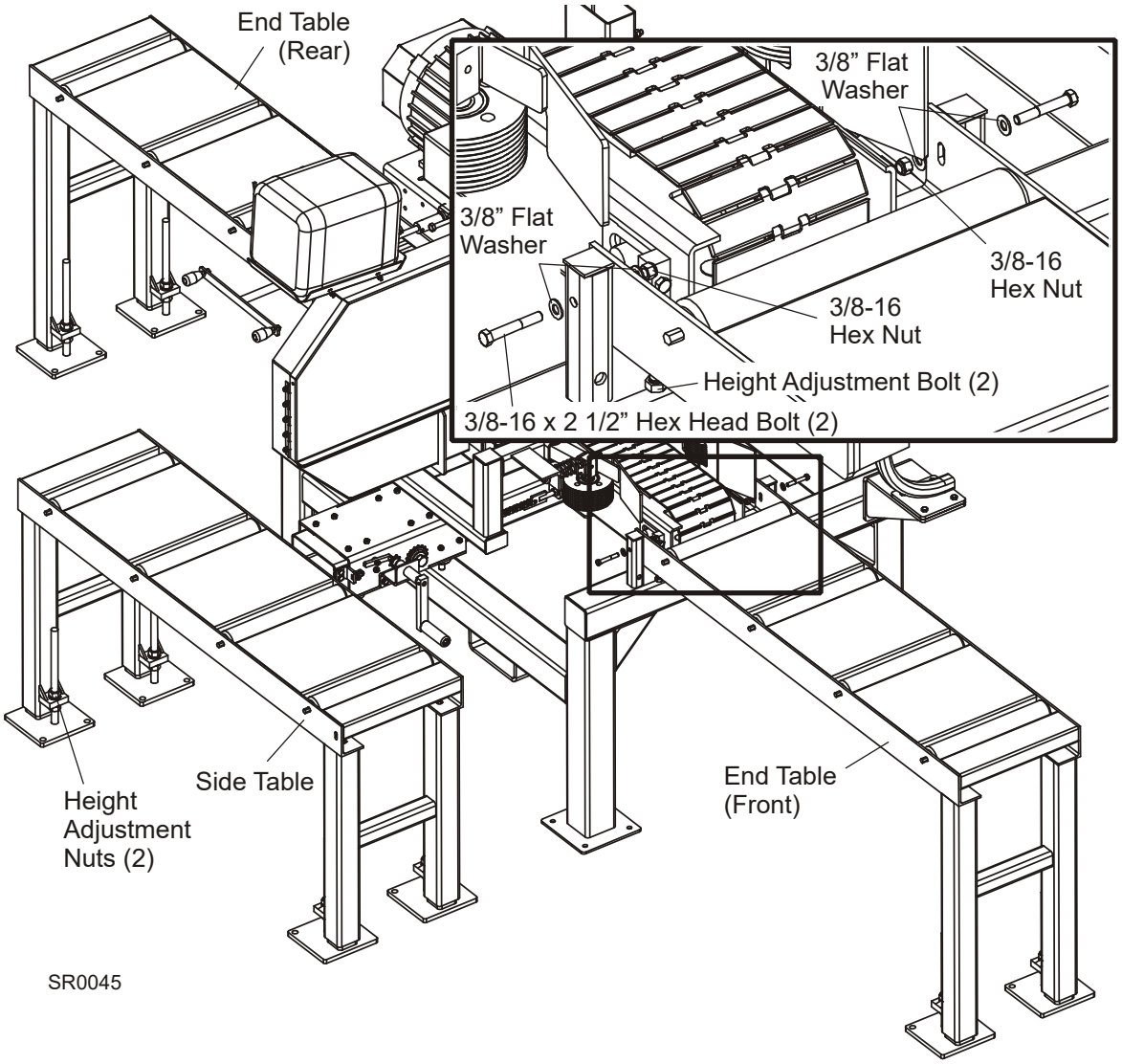


FIG. 3-3

3. Place the side table at the convenient location next to the resaw. Make sure the side table does not interfere with the main unit during operation.

4. Adjust the end and side tables as necessary. Use the height adjustment nuts at the bottom of the table legs to raise or lower the tables. Make sure the end tables and the feed track are level. Use the end tables adjustment bolts to raise or lower the other end of the end tables.

3.13 Pre-Operation Check

Prior to operating the resaw always perform these basic checks:

1. Make sure the resaw has been properly set up.

2. Make sure the motor drive belt is tensioned properly. *See Section 4.4* for more information.

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

3. Be sure all guards and covers are in place and secured.

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

4. Also be aware that the blade is spinning whenever the motor is ON. You should always turn off the motor to stop the blade whenever the resaw is not in use and ensure that all parts have stopped moving before removing any covers or guards.

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.

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

5. An Emergency Stop is located on the resaw control box. Press the Emergency Stop to shut down the resaw. Before operating the resaw again, turn the E-Stop switch clockwise and release.

WARNING! Always disconnect and lockout power before performing any service to the resaw. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

3.14 Operation Procedure

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

DANGER! Keep all persons out of the path of moving equipment and boards when operating the resaw or loading boards. Failure to do so will result in serious injury.

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

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

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

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

1. Install a blade, if necessary.
2. Tension the blade as described in *Section 3.4 Tensioning The Blade*.
3. Adjust the saw head height as described in *Section 3.7 Up/Down Operation*.
4. Adjust the saw head tilt as described in *Section 3.8 Saw Head Tilt Adjustment*.
5. Adjust the pressure roller assembly to the width of the material to be cut as described in *Section 3.9 Pressure Roller Adjustment*..
6. Perform the pre-operation check of the machine as described in *Section 3.13 Pre-Operation Check*.

7. Start the blade motor as described in *Section 3.6 Starting And Stopping The Machine*.

8. Use the feed rate potentiometer on the control box to set the feed track speed as desired.

9. Place the material on the feed track and push it into the pressure and stationary rollers. Use another piece of material to push it against the resaw blade. Make sure another person picks up the material on the other end of the resaw.

10. Repeat the above procedures for all boards to be cut.

11. Shutdown the machine when done cutting.

SECTION 4 MAINTENANCE

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

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

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

4.1 Blade Guides

WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off. If the machine is turned on and moving parts activated, serious injury may result.

1. Check the rollers for performance and wear every blade change. Make sure the rollers are clean and spinning freely. If not, replace them. Replace any rollers which have worn smooth or have become cone shaped.

2. Make sure the blade screw in the top center of the C-frame is 1/16" (1.5 mm) away from the blade. If not, loosen the nut and adjust the screw as necessary. Check the screw every blade change. Failing to maintain this adjustment will lead to early blade breakage.

   See Figure 4-1.

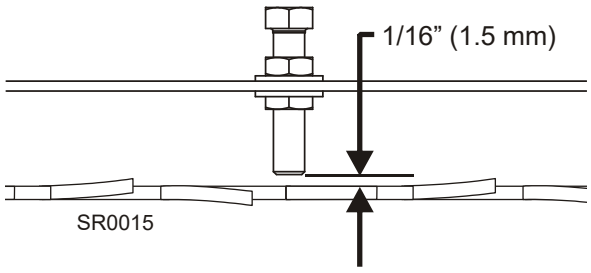


FIG. 4-1

High-Performance Guides Only:

3. Inspect the blocks at every blade change for damage or wear. If the block housing is bent or damaged, replace the block assembly. Also, replace the block assemblies before the blocks are worn to a point the blade may contact the block housing.

4. Check the guide blocks are properly spaced from the blade every 25 hours of operation. Use the provided shim or a feeler gauge to check the blocks are adjusted .008” - .010” from the blade.

25

As the blocks wear, the front inside corner will wear more than the body of the block. When the corner wears far enough, sawing performance will be affected even if the body of the block is adjusted properly to the blade. At this point, the block should be rotated or replaced. Rotate the blocks by switching their locations so the worn corner is located on the outside. If you have access to the appropriate equipment, you can also grind or mill the blocks to a new flat surface and reuse them. It is recommended you develop a routine schedule for replacing the blade guide blocks based on your sawing conditions and experience.

See Figure 4-2.

To adjust the top block up, loosen the clamp bolt and mounting bolt. Turn the adjustment bolt counterclockwise. Retighten the mounting bolt and clamp bolt.

To adjust the bottom block up, loosen the clamp bolt and mounting bolt. Use the provided adjustment tool to turn the adjustment screw clockwise. Retighten the mounting bolt and clamp bolt.

IMPORTANT! The blocks should be parallel to the blade. Check the space between the insert and the blade at each side of the insert to insure it is parallel. Use the appropriate outer adjustment bolt to tilt the insert mounting plate so the insert is parallel to the blade. *See Section 7.2* for instructions about checking and adjusting the assembly level with the blade.

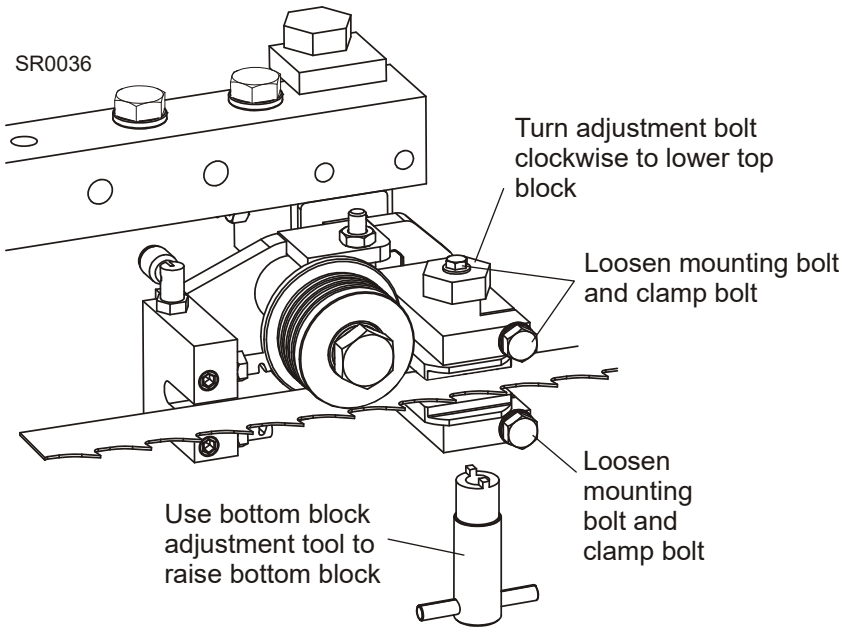


FIG. 4-2

Preventing sap buildup on the blade is critical when using the high-performance blade guide system. If the wood you are sawing leaves sap buildup using plain water in the blade lube system, use Wood-Mizer lube additive (4-Pak 60 oz. bottles part no. ADD-1).

4.2 Sawdust Removal

WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off and perform the lockout procedure. If the machine is turned on and moving parts activated, serious injury may result.

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

WARNING! Always keep clear of exiting sawdust. Keep hands, feet and any other objects away from the sawdust chute when operating resaw. Failure to do so may result in serious injury.

WARNING! Always check to ensure the steel fingers inside the sawdust chute are in place before operating the resaw. The steel fingers have been designed to help prevent a broken blade or some other object from becoming a projectile and exiting the sawdust chute. Failure to have these fingers in place may result in serious injury.

4.3 Blade Wheel Belts

WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off and perform the lockout procedure. If the machine is turned on and moving parts activated, serious injury may result.

Rotate the blade wheel belts and check them for wear. Rotating the belts every 50 hours will provide longer belt life. Replace belts as necessary. For maximum belt and blade performance use only B72.5 belts supplied by your nearest Wood-Mizer outlet.

4.4 Tensioning the Belts

DANGER! Coastdown Required. Always shut down the resaw 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.

WARNING! Always disconnect and lockout power before performing any service to the resaw. Follow the lockout procedure provided in the safety section (*See Section 2.2*). 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.

CAUTION! Never apply belt dressing as this will damage the belt and cause early failure.

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

See Figure 4-3. To adjust the drive belt tension:

- Unbolt and remove the drive belt guard.
- Loosen the four motor mount bolts securing the motor to the motor mount.

- Use the left and right adjustment bolts as shown below to move the motor mount until the belt is tensioned properly (7/16" (11mm) deflection with 18 lbs. of deflection force).

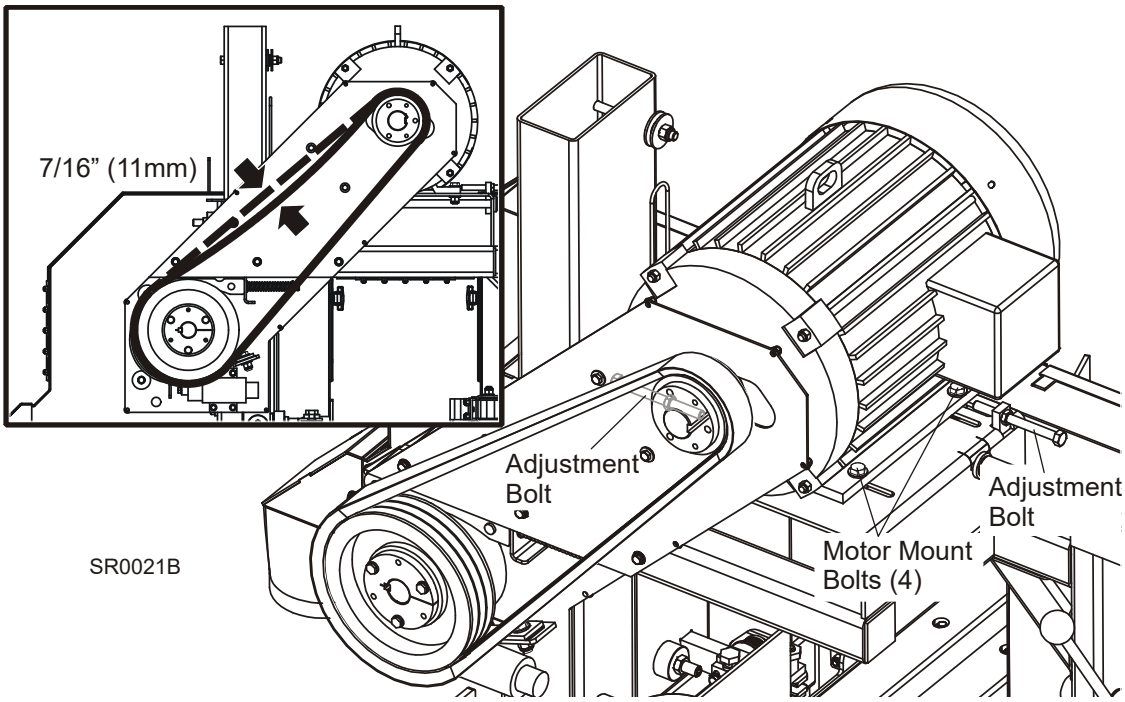


FIG. 4-3

CAUTION! Do not over tighten the drive belt as it can cause premature belt failure or damage to the drive belt bearings and motor.

CAUTION! Do not under-tighten the drive belt as it can cause the slippage of the belt on the drive pulleys.

- Retighten the four motor mount bolts when tension adjustment is complete.
- Retighten the left and right adjustment bolts to secure the motor mount in place.
- Close and secure the drive belt guard.

AR Periodically check the drive belt for wear. Replace any damaged or worn belts as needed.

4.5 Tensioning the Chains

DANGER! Coastdown Required. Always shut down the resaw 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.

WARNING! Always disconnect and lockout power before performing any service to the resaw. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

See Figure 4-4. To tension the feed track, use the two bolts and nuts at the operator end of the resaw. Do not overtension the feed track.

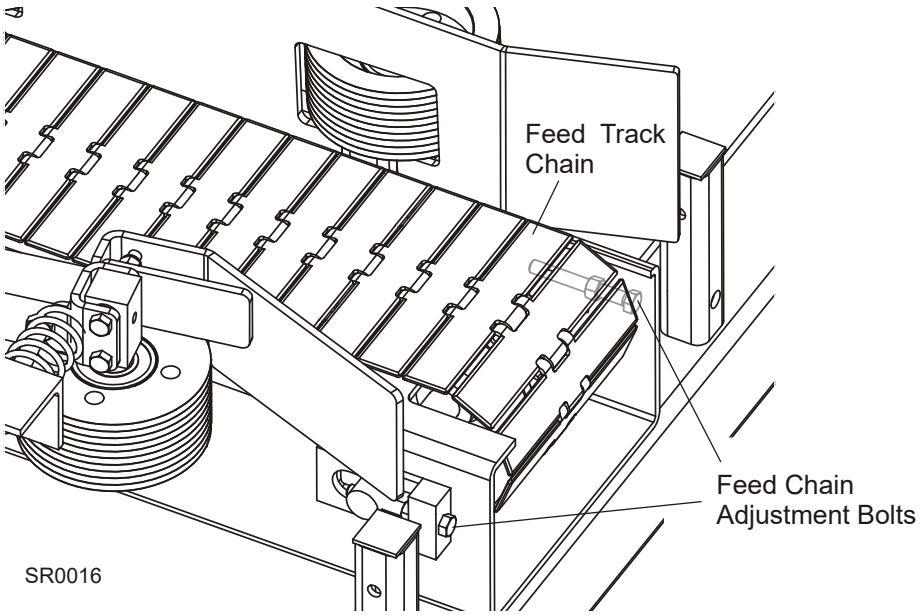


FIG. 4-4

See Figure 4-5. To tension the pressure roller chain, loosen the tensioner nuts and adjust the chain tension as needed.

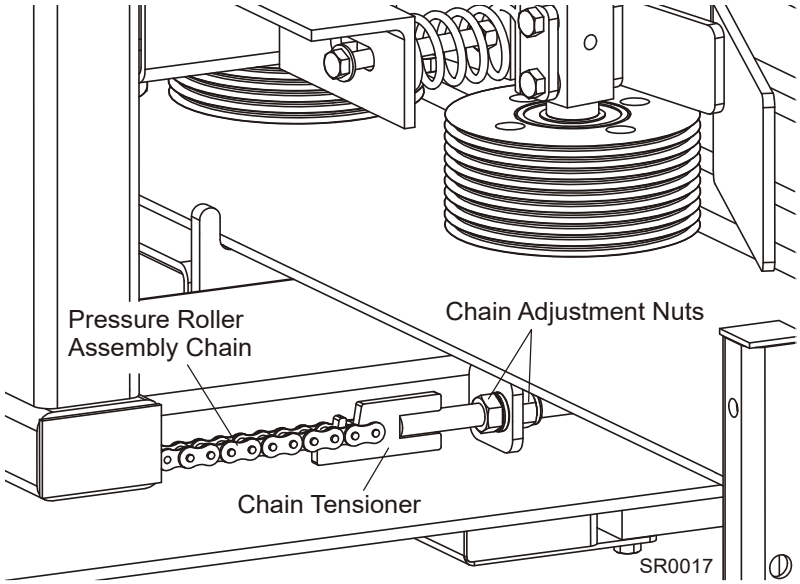


FIG. 4-5

See Figure 4-6. To tension the feed motor chain, use the four adjustment nuts securing the gearbox to the resaw frame and two nuts on the chain housing. Do not overtension.

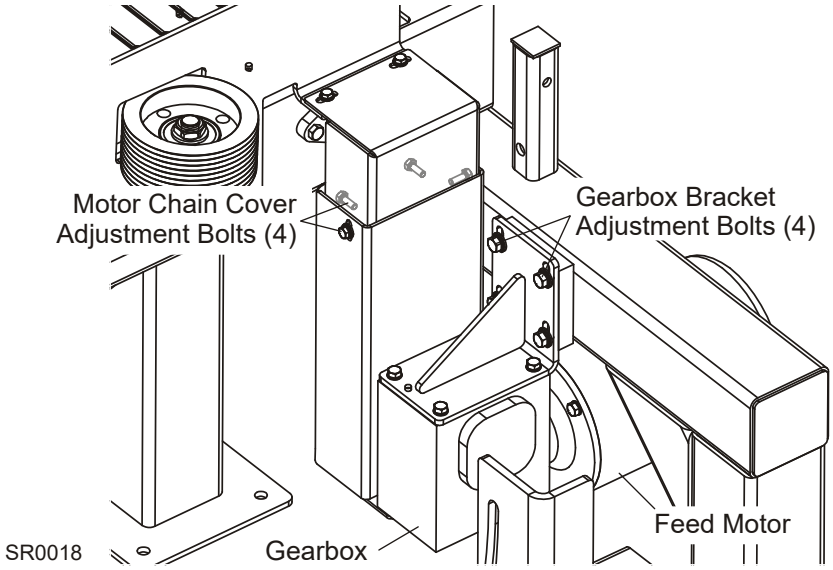


FIG. 4-6

4.6 Drive Bearing

WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off and perform the lockout procedure. If the machine is turned on and moving parts activated, serious injury may result.

500 Drain and refill the fluid in the drive-side cylinder bearing housing every 500 hours of operation.

Disconnect the oil level view hose from the fitting at the top of the bearing housing. With the fitting at the bottom of the bearing housing still connected, allow oil to drain from the oil level view hose. Once drained, pour fresh Automatic Transmission Fluid (ATF) such as Dexron III ATF into the hose until the oil level is in the acceptable range as indicated on the gauge decal. Reconnect the hose to the top fitting.

See Figure 4-7.

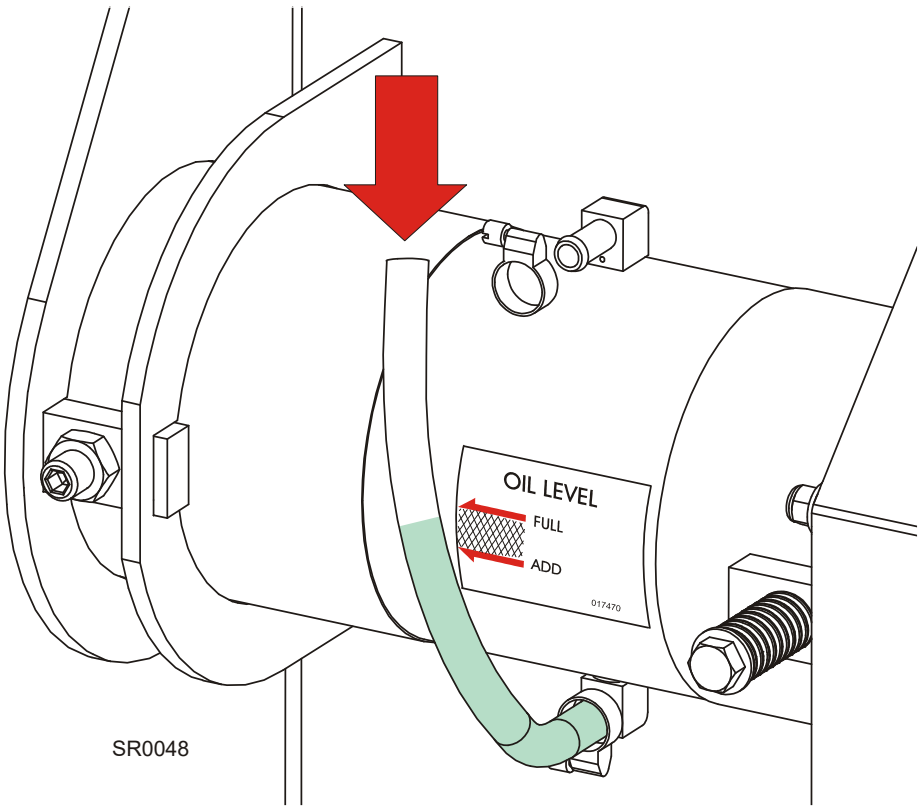


FIG. 4-7

4.7 Checking the Rollers

8 **1.** Check the feed rollers every 8 hours of operation. Remove any dirt or debris from the rollers. Make sure they spin freely, without much play.

4.8 Miscellaneous

WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off and perform the lockout procedure. If the machine is turned on and moving parts activated, serious injury may result.

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.

2. Check the resaw alignment every setup.

3. Grease the up/down screw under the motor mount bracket with a NLGI No. 2 grade lithium grease as needed.

4. Lubricate the saw head tilt screw threads with a NLGI No. 2 grade lithium grease as needed.

5. Grease the feed track bearings with a NLGI No. 2 grade lithium grease every fifty hours of operation.

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

7. Check the feed track gearbox oil level. Add a synthetic gear oil such as Mobil SHC 634 as needed.

   Drain and refill the gearbox with 24 ounces of oil after the first 2500 hours of resaw operation or after six months, whichever comes first. Repeat every 5000 hours or once a year, whichever comes first.

   Wood-Mizer offers replacement gear oil in 8 ounce bottles (3 required for complete oil replacement).

4.9 Lube-Mizer (Optional)

DANGER! Hazardous voltage inside the electric control box 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 resaw operation.

Periodically check lube hoses and lines for buildup. Remove and flush with water as needed.

SECTION 5 ALIGNMENT

The Wood-Mizer resaw is factory aligned. The resaw alignment should be performed as necessary or approximately every 1500 hours of operation to solve sawing problems not related to blade performance.

5.1 Alignment Procedure

Blade Wheel Alignment

The blade wheels should be adjusted so they are level in the vertical and horizontal planes. If the blade wheels are tilted up or down, the blade will want to travel in the tilted direction. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels.

1. Use the blade guide alignment tool to check the vertical alignment of each blade wheel. Attach the tool to the blade near the inner blade guide mount. Be sure the tool does not rest on a tooth or burr, and is lying flat against the bottom of the blade.

   See Figure 5-1.

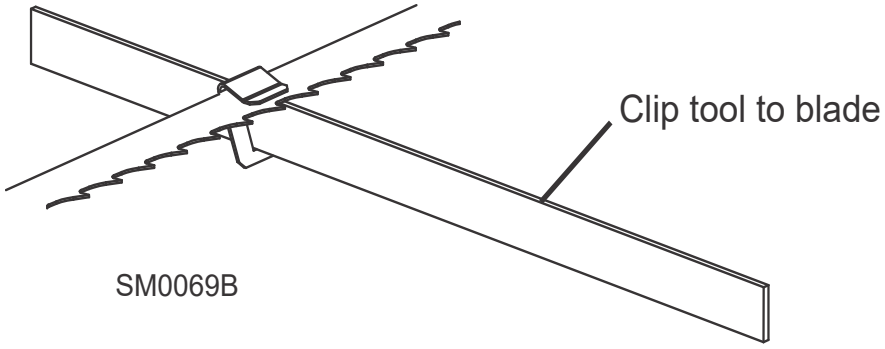


FIG. 5-1

2. Measure from the bottom of the tool front end to the top surface of the resaw feed track.

3. Measure from the bottom of the tool rear end to the top surface of the feed track.

4. If the two measurements differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the drive-side blade wheel.

See Figure 5-2. Use the vertical adjustment screws to adjust the drive-side blade wheel. To tilt the wheel down, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

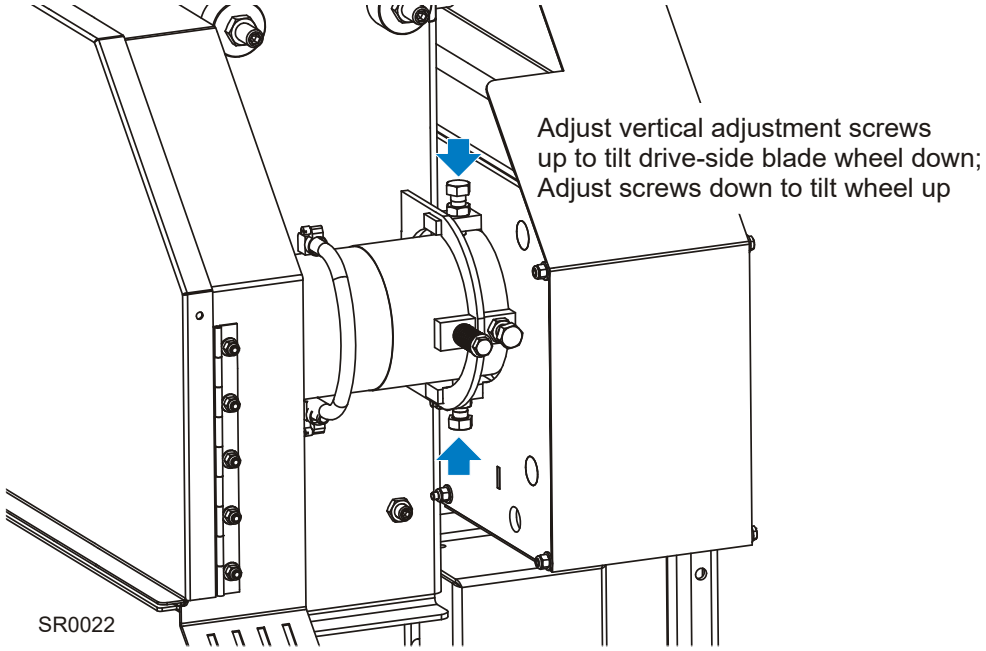


FIG. 5-2

5. Recheck the vertical tilt of the drive-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the feed track (within 1/16" [1.5 mm]). Readjust the drive belt tension as necessary.

6. Remove the tool from the blade and reattach it near the outer blade guide assembly.

7. Measure from the tool to the feed track at both ends of the tool. If the measurements at the front and rear ends of the tool differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the idle-side blade wheel.

See Figure 5-3. Use the vertical adjustment screws to adjust the idle-side blade wheel. To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel down, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

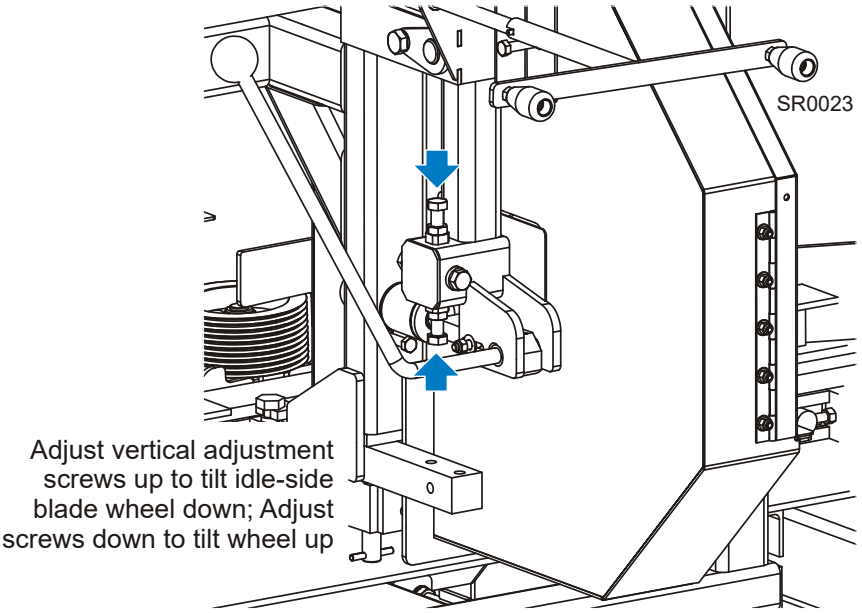


FIG. 5-3

8. Recheck the vertical tilt of the idle-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the resaw feed track (within 1/16" [1.5 mm]).

9. Check the position of the blade on the idle-side blade wheel.

See Figure 5-4. The horizontal tilt of the blade wheel should be adjusted so that the gullet of an 1-1/4" blade is 1/8" (3 mm) out from the front edge of the wheel (±1/32 [0.75 mm])(±1/16 [1.5 mm]). The gullet of an 1-1/2" blade should be 3/16" (4.5 mm) out from the front edge of the wheel (±1/16 [1.5 mm]). Do not let the teeth ride on the wheels.

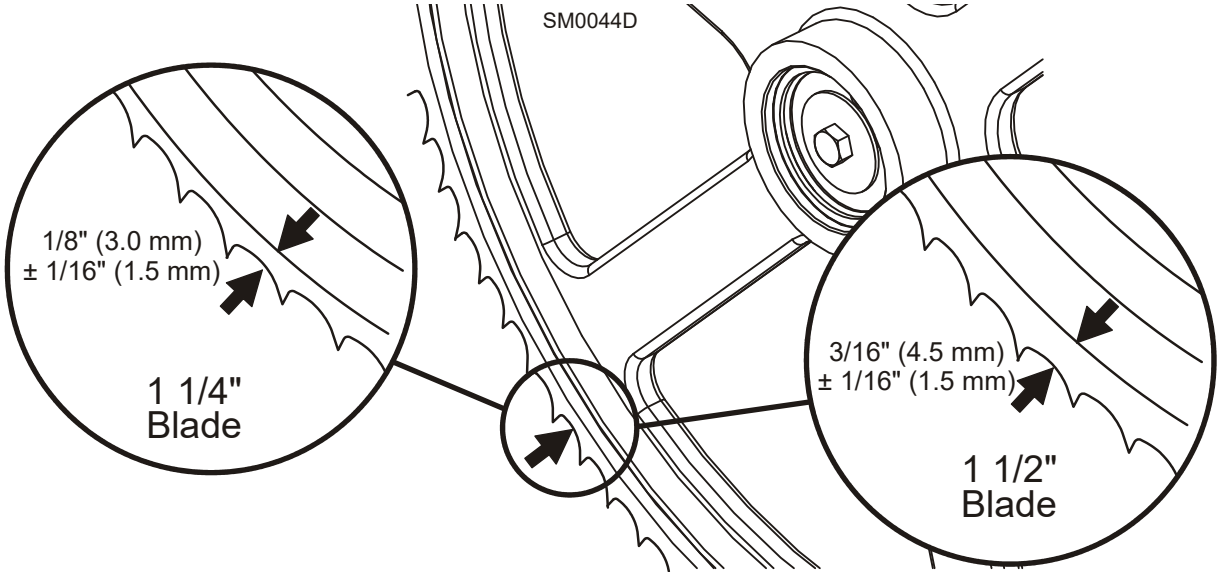


FIG. 5-4

See Figure 5-5. Use the cant control adjustment to adjust the idle-side blade wheel. If the blade is too far forward on the wheel, turn the cant control counterclockwise. If it is too far back on the wheel, turn the cant control clockwise.

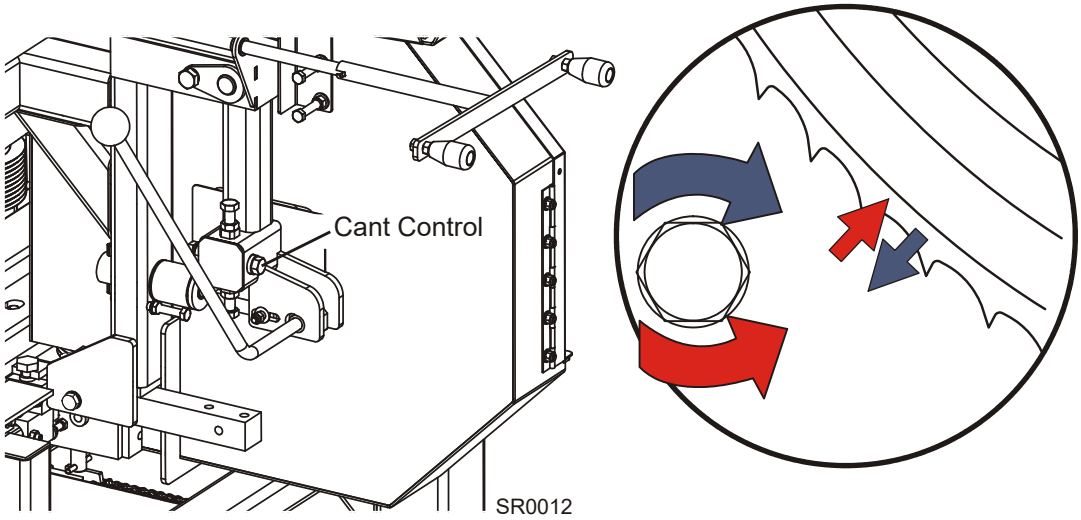


FIG. 5-5

10. Check the position of the blade on the drive-side blade wheel. The blade should be positioned on the wheel as described for the idle-side blade wheel. Adjust the drive-side blade wheel if necessary.

See Figure 5-6. Use the horizontal adjustment screw to adjust the drive-side blade wheel. Loosen the top vertical screw to allow movement of the drive shaft. To move the blade back on the wheel, loosen the jam nut and turn the horizontal adjustment screw clockwise one quarter turn.

To move the blade out on the wheel, loosen the jam nut and turn the horizontal adjustment screw counterclockwise one quarter turn.

Repeat adjustments in quarter-turn increments until the blade tracks properly on the drive-side blade wheel. Tighten the horizontal adjustment screw jam nut and the top vertical screw.

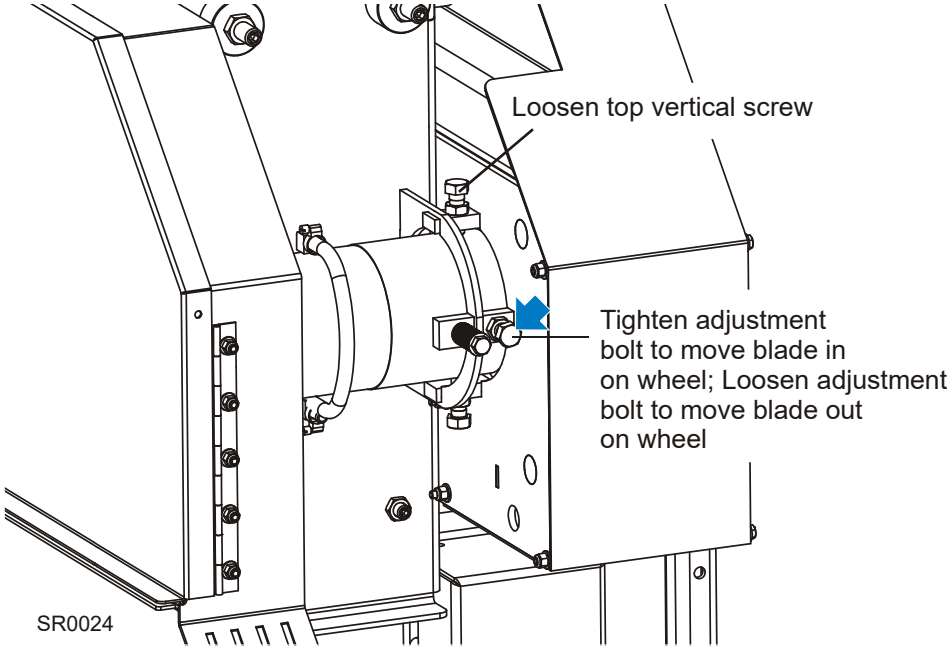


FIG. 5-6

Saw Head Adjustment

Making these adjustments correctly will insure the saw head cuts smoothly and blade will remain parallel with the feed track.

See Figure 5-7. To adjust the saw head tilt, use the upper and lower horizontal adjustment screws. To raise or lower the outside of the saw head, loosen the two upper and lower adjustment nuts. Use the screws to adjust the saw head tilt as shown. Recheck the measurement from the blade to the feed track and adjust the upper and lower horizontal adjustment screws until the outside of the saw head is parallel with the feed track. Tighten the upper and lower adjustment nuts when finished.

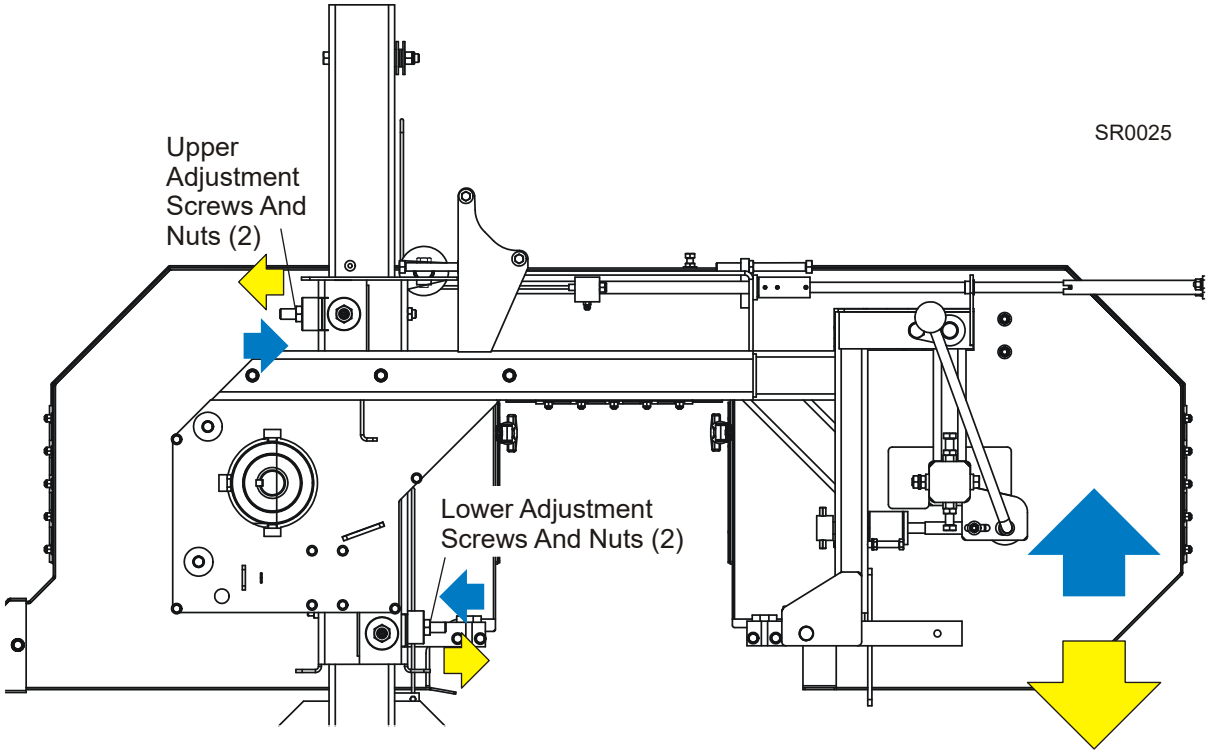


FIG. 5-7

Blade Guide Installation

Each Wood-Mizer resaw has two blade guide assemblies that help the blade maintain a straight cut. The two blade guide assemblies are positioned on the saw head to guide the blade on each side of the material being cut.

One blade guide assembly is mounted in a stationary position on the drive side of the saw head. This assembly is referred to as the "inner" blade guide assembly.

The other blade guide assembly is mounted on the idle side of the saw head. It is referred to as the "outer" assembly and is adjustable for several widths of materials to be processed.

> **NOTE:** Before installing the blade guide assemblies, remove the blade guide adjusting screws and apply a lubricating oil such as 10W30 or Dexron III to each screw. This will prevent the screws and threaded holes from corroding and make screw adjustments easier.

1. Remove the blade from the resaw.

2. **High-Performance Guides Only:** Inspect the guide blocks and repair or replace as necessary. Loosen the top block clamp bolt and mounting bolt. Turn the adjustment bolt counterclockwise to raise the top block all the way up. Remove the bottom guide block from each blade guide assembly and install the provided alignment bar.

   See Figure 5-8.

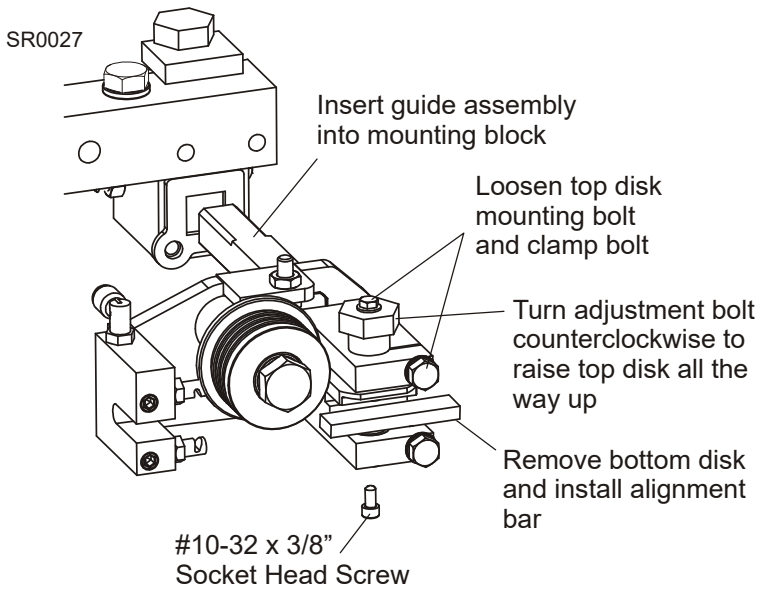


FIG. 5-8

3. Install each blade guide assembly to the mounting blocks and push all the way back. Install, tension and track a new blade. Adjust the outer blade guide assembly so the roller flange is 1/8" from the back of the blade. Adjust the inner blade guide assembly so the roller flange is 1/16" from the blade.

   See Figure 5-9. Tighten the two previously-loosened tilt adjustment screws to secure the blade guide assembly. Turn the top adjustment bolt clockwise to raise the blade guide assembly so the roller does not contact the blade.

   NOTE: Before adjusting the top bolt, unload pressure on the bolt by turning 1/2 turn in the opposite direction it was last adjusted.

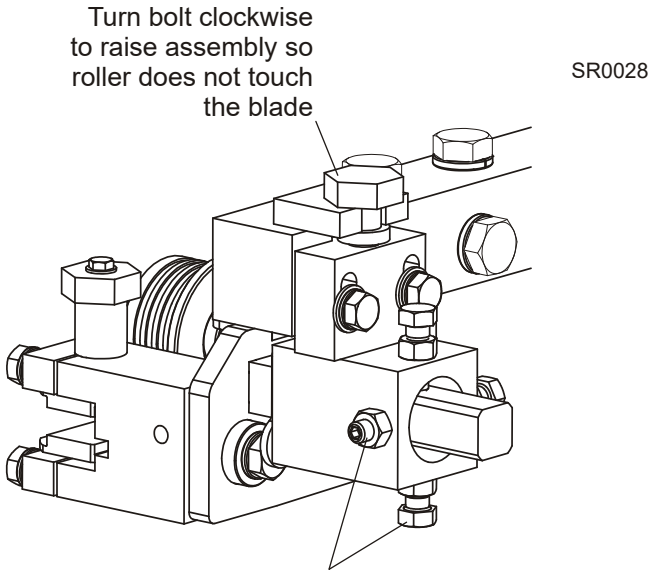


FIG. 5-9

Blade Guide Deflection

Perform the following steps to achieve proper blade deflection with the blade guides.

1. Raise the saw head until the blade is 8" (200 mm) above a feed track. Measure the actual distance with a tape from the top of the feed track to the bottom of the blade.

   See Figure 5-10.

   Turn the top adjustment bolt counterclockwise to lower the assembly until the blade guide roller deflects the blade down until the bottom of the blade measures 7 3/4" (195 mm) from the feed track.

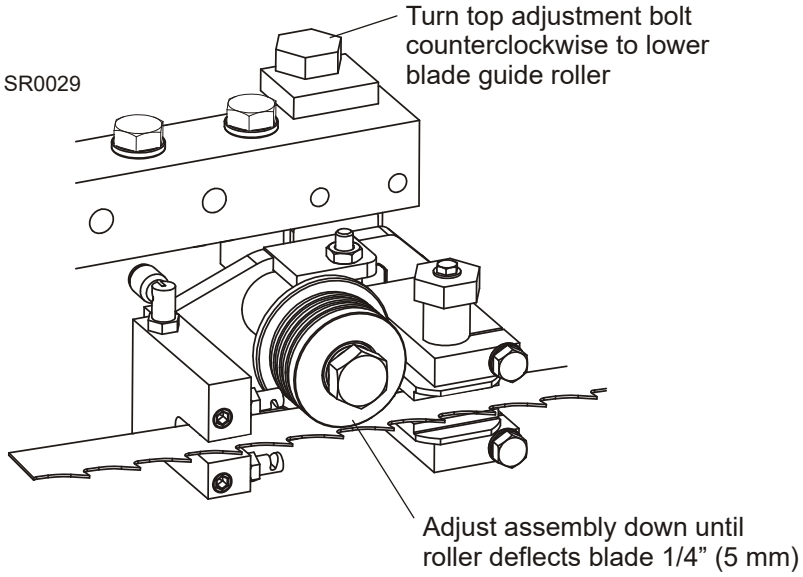


FIG. 5-10

   NOTE: Before adjusting the top bolt, unload pressure on the bolt by turning 1/2 turn in the opposite direction it was last adjusted.

2. Repeat for the other blade guide.

Blade Guide Vertical Tilt Alignment

The blade guides should be adjusted properly in the vertical plane. If the blade guides are tilted vertically, the blade will try to travel in the tilted direction.

A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

1. Clamp the alignment tool on the blade. Position the tool close to the outer blade guide roller. Be sure the tool does not rest on a tooth or burr, and is lying flat on the blade.

   See Figure 5-11.

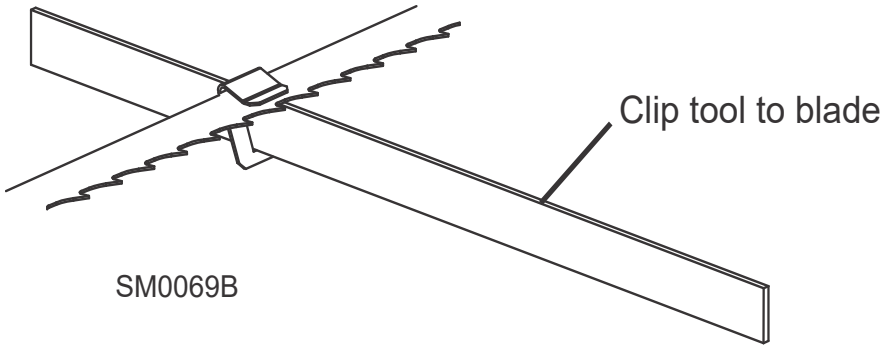


FIG. 5-11

2. Measure the distance from the feed track to the bottom edge of the tool front end.
3. Measure the distance from the feed track to the bottom edge of the tool rear end.
4. If the measurement from the tool to the feed track is not equal, adjust the vertical tilt of the outer blade guide roller.
5. Loosen one set screw at the side of the blade guide assembly.

See Figure 5-12. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten top screw. To tilt the roller down, loosen the top screw and tighten the bottom screw. Tighten the jam nuts and recheck the tilt of the blade.

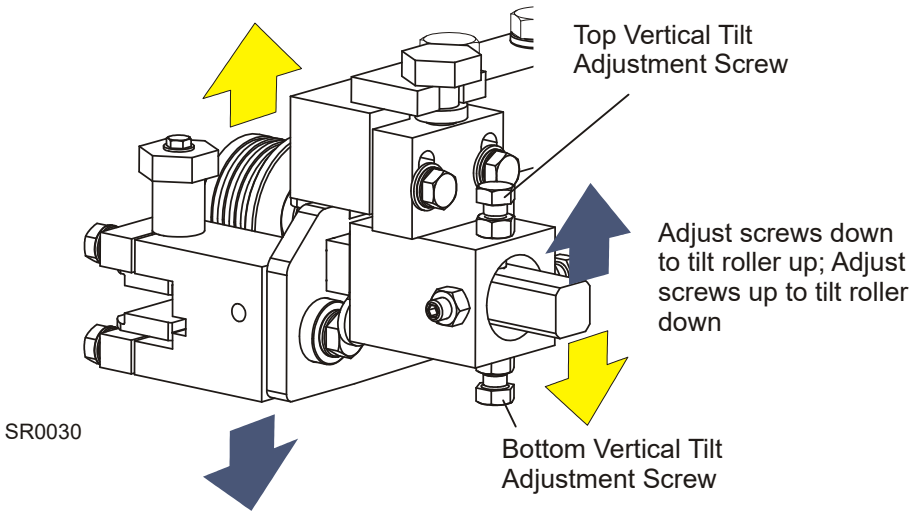


FIG. 5-12

6. Move the blade guide alignment tool close to the inner blade guide roller assembly and repeat the above steps. Adjust the vertical tilt of the inner blade guide if necessary.

7. After adjusting the vertical tilt of the blade guides, recheck the blade deflection and adjust if necessary.

Blade Guide Horizontal Tilt Adjustment

If the blade guides are tilted in the wrong direction horizontally, the back of the blade may contact the flange as the roller is spinning down, causing it to push the blade away from the guide roller.

1. Remove the blade guide alignment tool from the blade.

2. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

   See Figure 5-13.

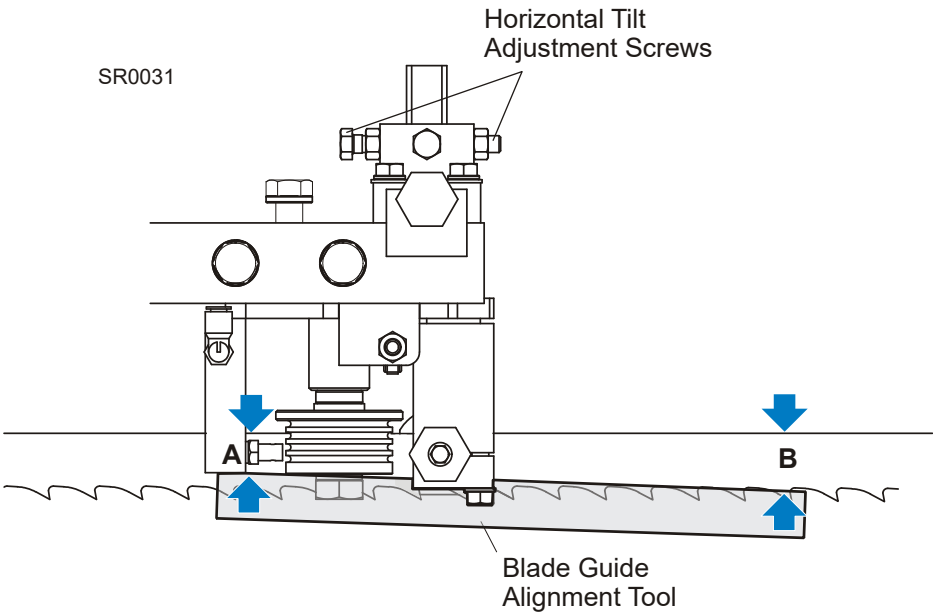


FIG. 5-13

3. Measure between the back edge of the blade and the tool at the end closest to the inner blade guide ("B").

4. Measure between the back edge of the blade and the other end of the tool ("A").

   The roller should be tilted slightly to the left (’A’ 1/8" [3 mm] less than ’B’ ±1/8" [3 mm]).

See Figure 5-14. Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the right screw. Tighten the jam nuts and recheck the tilt of the blade.

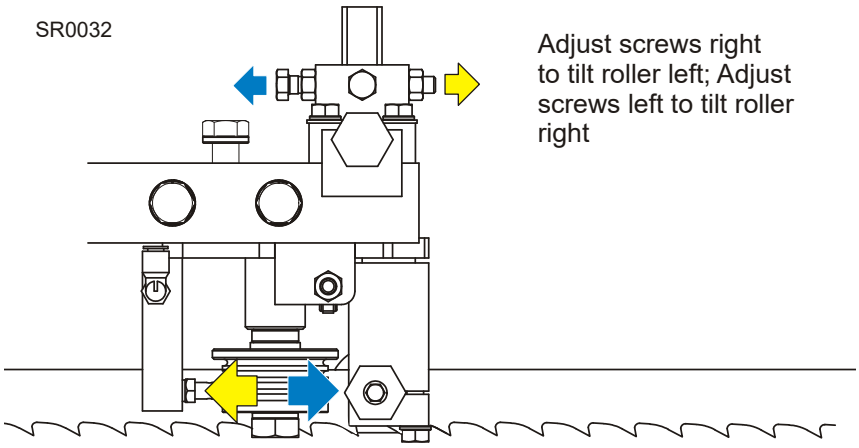


FIG. 5-14

5. Repeat the above steps for the inner blade guide roller assembly.

NOTE: Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. *See Blade Handbook, Form #600.*

Blade Guide Flange Spacing

Each blade guide must be adjusted so the roller flange is the correct distance from the back edge of the blade. If the flange is too close to or too far from the blade, the resaw will not cut accurately.

> **HINT:** When adjusting blade guide spacing, loosen the top set screw and one side set screw only. This will ensure horizontal and vertical tilt adjustments are maintained when the adjustment screws are retightened.

1. Measure the distance between the flange on the inner blade guide roller to the back edge of the blade. This distance should measure 1/16" (1.5 mm). Adjust the roller back or forward if necessary.

   See Figure 5-15. Loosen the top and one side screw shown. Back the stop bolt out of the way if necessary. Tap the blade guide forward or backward until properly positioned. Retighten the screws and jam nuts. Adjust the stop bolt against the blade guide bracket.

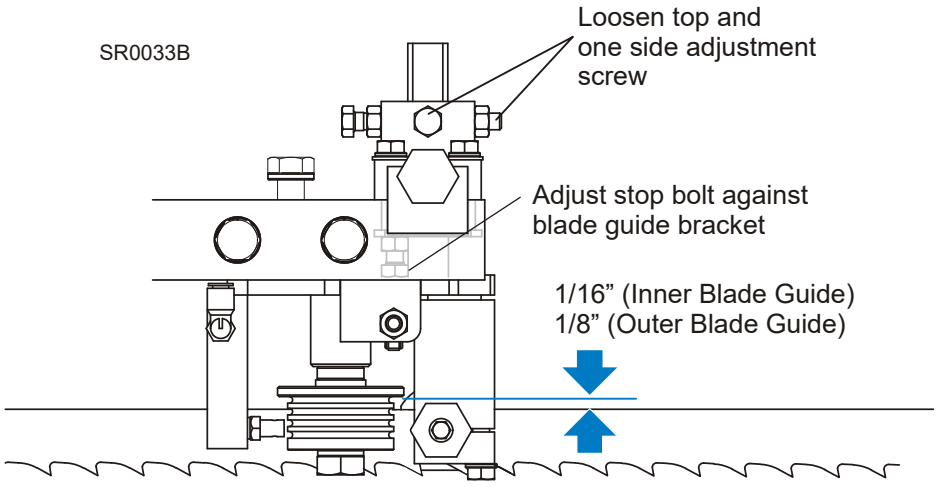


FIG. 5-15

2. Measure the distance between the flange on the outer blade guide roller to the back edge of the blade. This distance should measure 1/8" (3.0 mm). Adjust the roller back or forward if necessary.

Blade Deflector Adjustment (Standard Guides Only)

1. Install, tension and track the blade.

2. Check the blade deflector is centered around and not touching the blade. Loosen the mounting bolt and move the deflector up or down as necessary. Retighten the mounting bolt. Loosen the stop bolt jam nuts and adjust the stop bolt against the deflector. Retighten the jam nuts.

   See Figure 5-16.

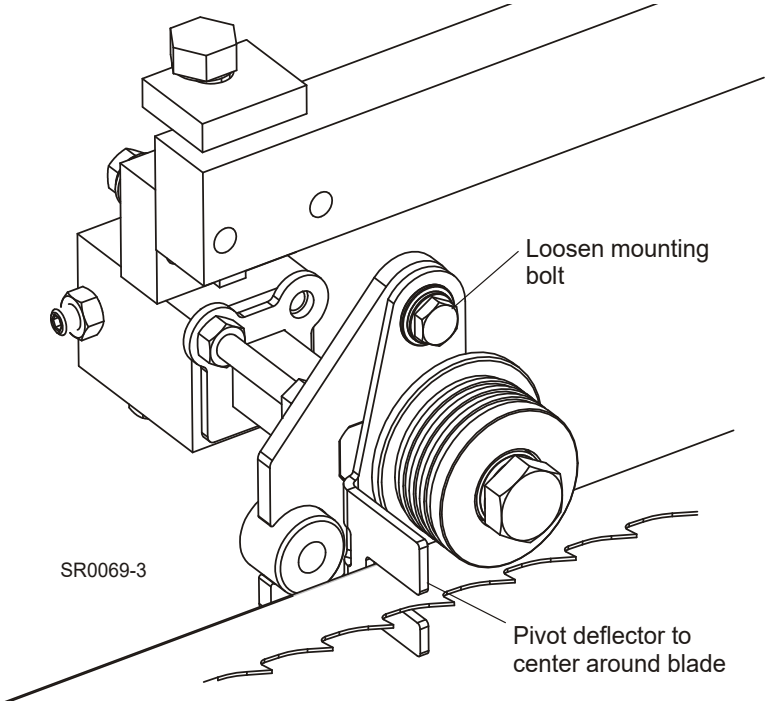


FIG. 5-16

Blade Guide Level (High-Performance Guides Only)

Perform the following adjustments to make sure the blade guide assembly is parallel to the blade.

1. Loosen the alignment bar mounting bolt. Use the provided bottom block adjustment tool to adjust the alignment bar up so the bar is close to, but not touching the bottom of the blade. Retighten the alignment bar mounting bolt

2. Check that the gap from the alignment bar to the blade is the same along entire length of the bar. Shine a flashlight behind the blade guide assembly to help you see the gap between the bar and the blade.

   To adjust, loosen the block tilt clamp bolt to pivot the block assembly until the alignment bar is parallel to the blade. Retighten the bolt. Repeat for the second blade guide assembly.

See Figure 5-17.

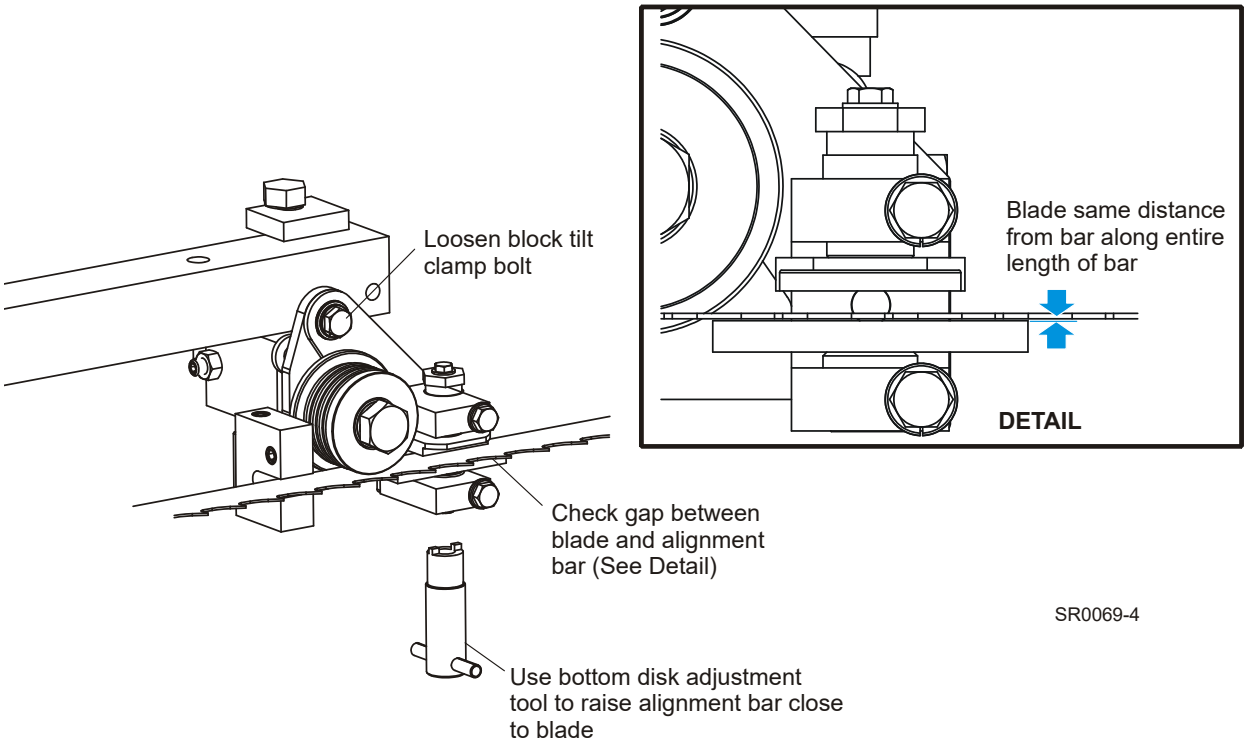


FIG. 5-17

Blade Block Adjustment (High-Performance Guides Only)

1. Replace the alignment bar on each blade guide with the bottom guide block. Use the provided bottom block adjustment tool to lower the bottom block all the way down.

   See Figure 5-18.

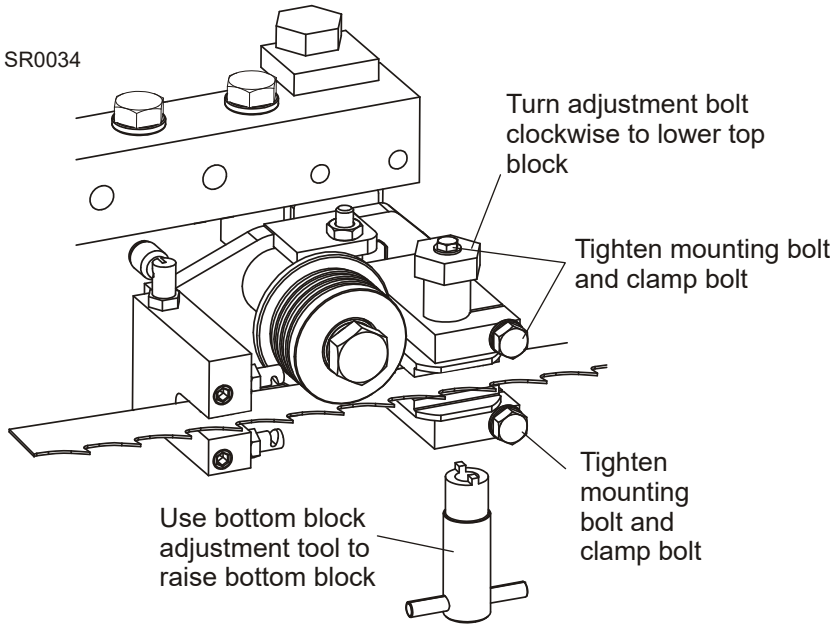


FIG. 5-18

2. Use the bottom block adjustment tool to raise the bottom block to .008" - .010" from the blade. Use the provided shim to set the distance from the block to the blade. Tighten the bottom block mounting bolt and clamp bolt.

3. Turn the top block adjustment bolt clockwise to lower the top block to .008" - .010" from the blade (using the shim as a guide). Tighten the top block mounting bolt and clamp bolt.

4. After tightening the clamp bolt, recheck the distance from the top block to the blade and readjust if necessary.

Pressure Roller Adjustment

Check all pressure rollers for alignment. Each pressure roller should be at the same distance from the corresponding stationary roller to make sure the material is pressed evenly along its length when cutting.

1. Measure the distance between each pair of pressure and stationary rollers.

2. Use the adjustment bolts and jam nuts to move each pressure roller in or out if necessary.

   See Figure 5-19. Loosen the jam nut on the adjustment bolt as shown. Turn the adjustment bolt clockwise to move the pressure roller away from the stationary roller. Turn the adjustment bolt counterclockwise to move the pressure roller closer to the stationary roller. Retighten the jam nut.

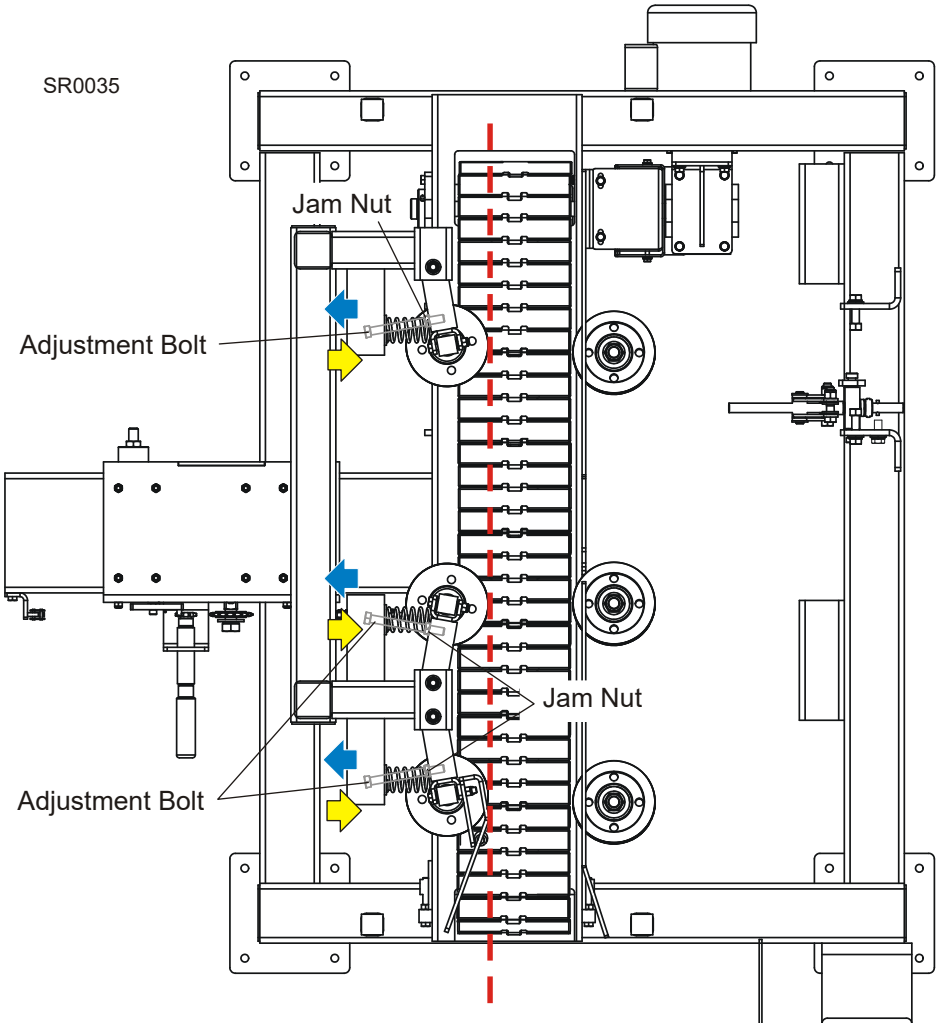


FIG. 5-19

Blade Height Scale Adjustment

After the entire resaw has been aligned and all adjustments made, check that the blade height scale indicates the true distance from the blade to the feed track.

1. Measure from the bottom edge on a down-set tooth of the blade to the top of the feed track.

2. View the blade height scale with eyes level with the indicator. The scale should indicate the actual distance from the blade to the feed track. Adjust the indicator if necessary.

   See Figure 5-20. Loosen the indicator mounting bolt. Adjust the scale indicator up or down until the indicator is aligned with the correct mark on the scale (+0 -1/32 [0.8 mm]). Retighten the scale mounting bolts.

   For example, if the measurement from the down-set tooth of the blade to the feed track was 8" (200 mm), make sure the indicator reads 8" (200 mm) on the scale.

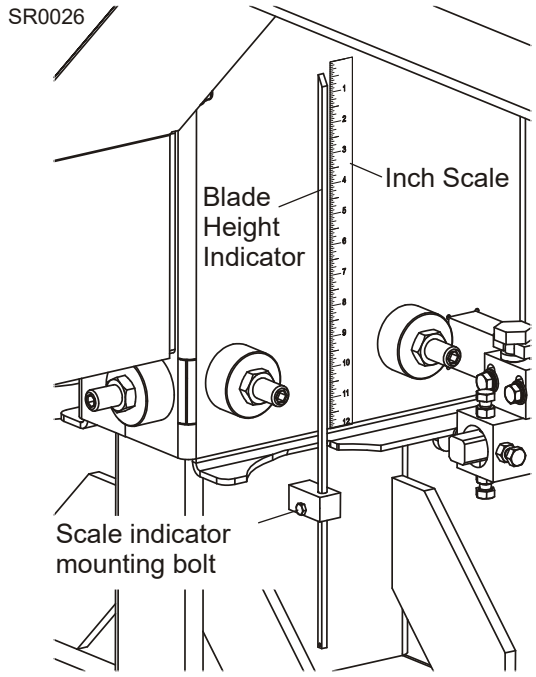


FIG. 5-20

Brake Adjustment

DANGER! Coastdown Required. Always shut down the resaw 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.

WARNING! Always disconnect and lockout power before performing any service to the resaw. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

Check the brake cable alignment if necessary.

Remove the drive belt guard to access the brake assembly.

See Figure 5-21. Verify that the drive belt can not be rotated. If the drive belt can be rotated, loosen the brake cable adjustment nut until the belt can not move.

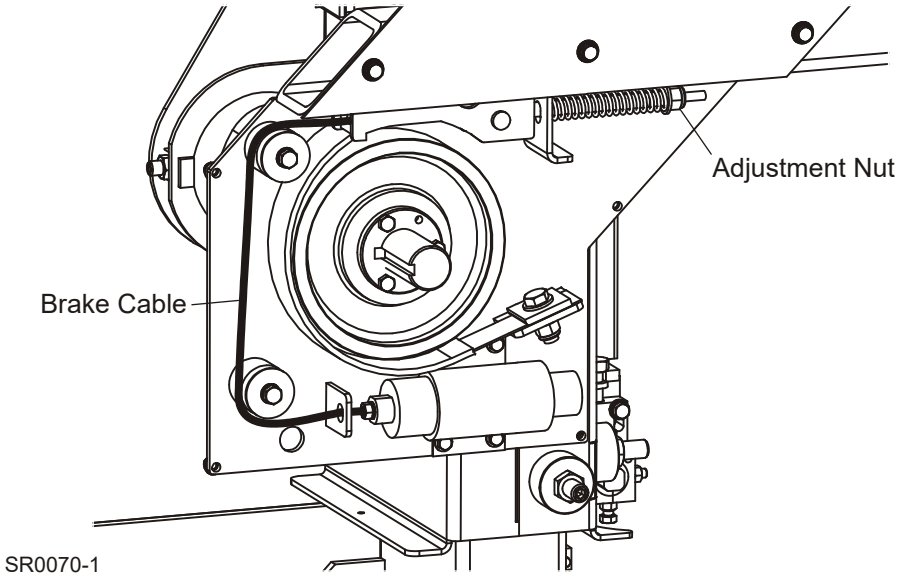


FIG. 5-21

See Figure 5-22. When the brake is engaged properly, the brake cable should be 1/4" away from the brake band.

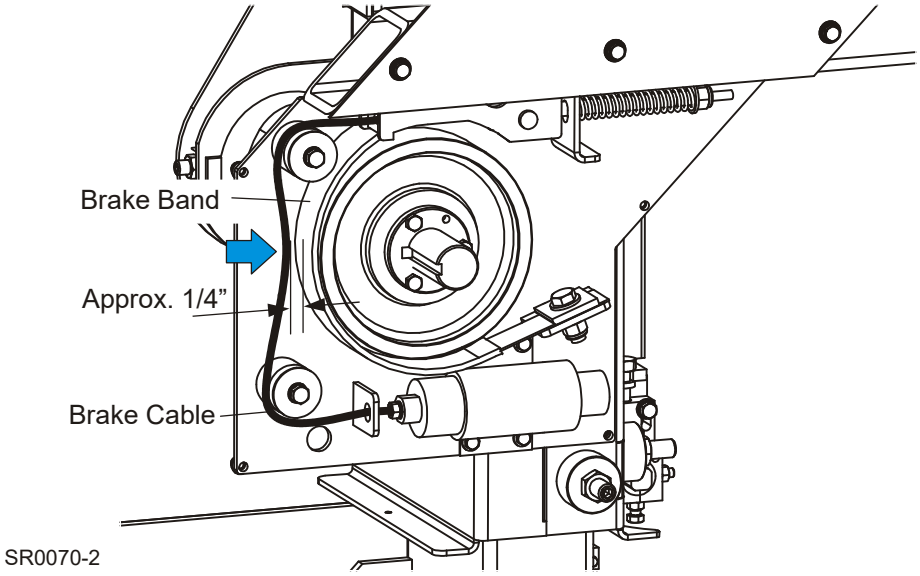


FIG. 5-22

See Figure 5-23. Start the machine and verify that the brake actuator pulls the cable in to release. If the brake does not release, tighten the brake cable adjustment nut until the brake releases.

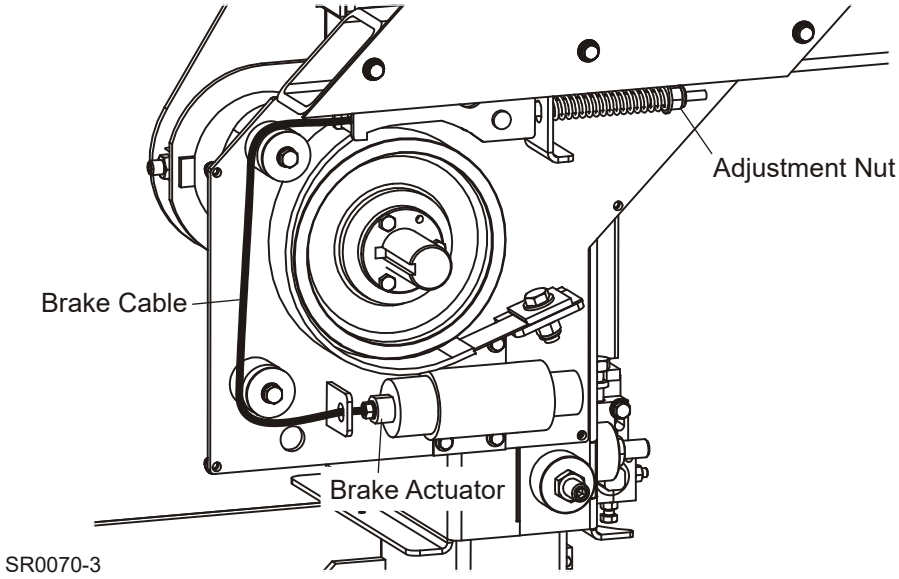


FIG. 5-23

Replace and secure the drive belt guard to the machine.

SECTION 6 REPLACEMENT PARTS

6.1 How To Use The Parts List

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

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

6.2 Sample Assembly

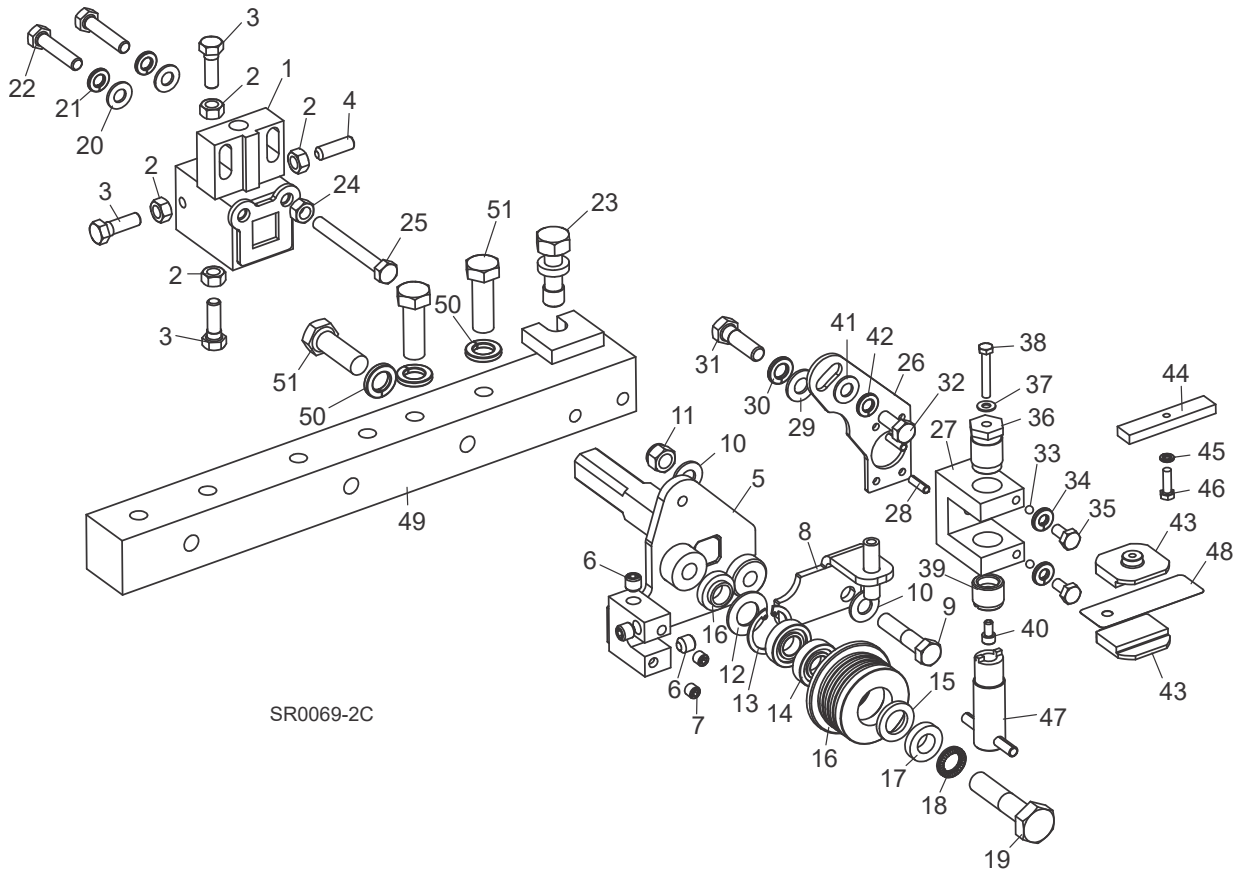
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SAMPLE ASSEMBLY, COMPLETE (Includes All Indented Parts Below)	A01111	1	
1	Sample Part	F02222-22	1	
2	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
	Sample Part (Indicates Part Is Only Available With A03333)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

To Order Parts:

From the continental U.S., call ***1-800-525-8100*** to order parts. Have your customer number, VIN, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.

SECTION 7 BLADE GUIDES

7.1 Blade Guide Assembly, Idle Side



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	GUIDE ASSEMBLY, IDLE SIDE BLADE ROLLER	006338	1	
	Block Assembly, Blade Guide Mount	065677	1	
1	Block Weldment, Blade Guide Mount	003911	1	◆
2	Nut, 5/16-18 Hex	F05010-17	4	
3	Bolt, 5/16-18 x 1” Hex Head Stainless Steel	F05006-88	3	
4	Screw, 5/16-18 x 1” Socket Head Flat Point Stainless Steel Set	F05006-122	1	
5	Shaft Weldment, Idle Side Guide	003924	1	
6	Fitting, 1/8" NPT Socket Pipe Plug	P30127	3	
7	Fitting, 1/16” NPT Socket Pipe Plug	007734	2	
8	Bracket Weldment, Water Lube	006322	1	
9	Bolt, 3/8-16UNF-2A x 1 3/4” Grade 5	F05007-119	1	
10	Washer, 3/8” SAE Flat	F05011-3	2	
11	Nut, 3/8-16 Hex Nylon Lock	F05010-10	1	

	Roller Assembly, Blade Guide (standard for use with 1 1/4” & 1 1/2” blades)	A04925 [1]	1	
	Roller Assembly, Extended Blade Guide (optional for use with 1 1/2” blades)	014299 [1]	1	
	Bearing Kit, Blade Guide Rebuild	K07079	1	
12	Washer, 5/8" White Felt	P04252	1	
13	Ring, 1 1/8" Interior Retaining	F04254-1	1	
14	Bearing, R8-2RS Blade Guide	015975	2	◆
15	Washer, 5/8" Gray Felt	P06455	1	
	Screw, 1/4-28 x 1/4” Socket Head Cup Point Set Black Oxide	F05005-105	1	
	Instruction Sheet, Blade Guide Rebuild	057407-1507	1	
16	Roller, Flanged Blade Guide (1 1/4” & 1 1/2” blade)	S04250	1	◆
	Roller, Flanged Blade Guide (1 1/2” blade)	014298	1	◆
	Instruction Sheet, Blade Guide Roller Replacement	A04925-364	1	
17	Spacer, Blade Guide	S04253	2	
18	Washer, 1/2” Nord-Lock	F05011-125	1	
19	Bolt, 1/2-13 x 2 1/4” Hex Head Grade 5	F05008-10	1	
20	Washer, 5/16” SAE Flat	F05011-17	2	
21	Washer, 5/16” Split Lock	F05011-13	2	
22	Bolt, 5/16-18 x 1 1/2” Hex Head	F05006-76	2	
23	Bolt, Blade Guide Vertical Adjustment	035656	1	
24	Nut, 5/16-18 Hex	F05010-17	1	
25	Bolt, 5/16-18 x 2 3/4” Hex Head Full Thread	F05006-136	1	
	GUIDE KIT, HIGH-PERFORMANCE BLADE GUIDE (OPTIONAL)	006340 [2]	1	
	Block Assembly, Idle Side Blade Guide	003928	1	
26	Plate, Block Tilt Adjustment	003915	1	
27	Block, Guide Block Mount	003909	1	
28	Pin, 3/16” x 5/8” Roll	F05012-22	2	
29	Washer, 3/8” SAE Flat	F05011-3	1	
30	Washer, 3/8” Split Lock	F05011-4	1	
31	Bolt, 3/8-16 x 1 1/4” Hex Head Grade 5	F05007-123	1	
32	Bolt, 5/16-18 x 3/4” Hex Head	F05006-102	1	
33	Ball, 3/16” Dia. Nylon	003914	2	
34	Washer, 1/4” Split Lock	F05011-14	2	
35	Bolt, 1/4-20 x 1/2” Hex Head	F05005-15	2	
36	Bolt, Blade Guide Block Mount	003994	1	
37	Washer, #10 Brass	042867	1	
38	Bolt, #10-32 x 1 1/4” Hex Head Stainless Steel	F05004-240	1	
39	Screw, Lower Block Adjustment	044057	1	
40	Screw, #10-32 x 3/8” Socket Head Stainless Steel	F05004-200	1	
41	Washer, 5/16” SAE Flat	F05011-17	1	
42	Washer, 5/16” Split Lock	F05011-13	1	

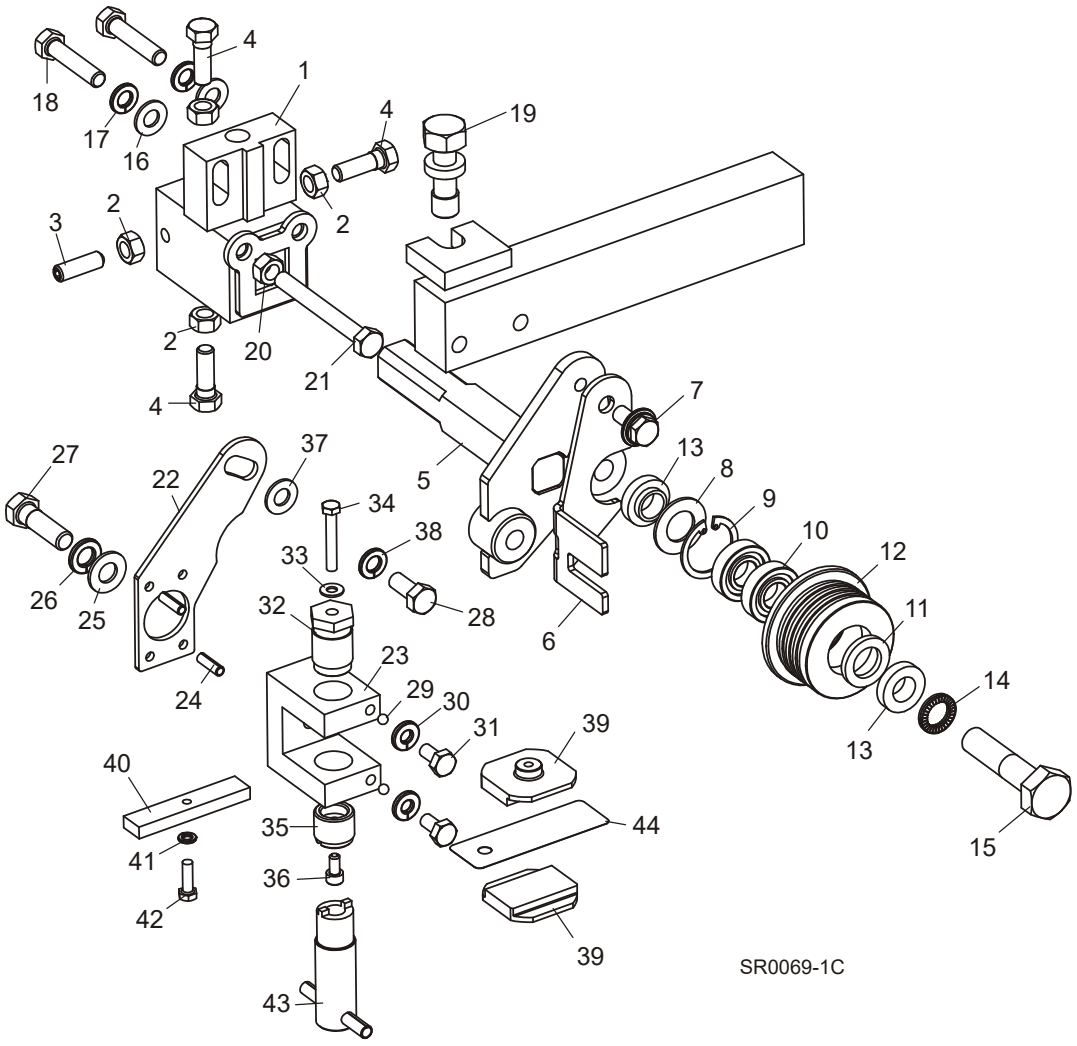
43	Block, Blade Guide Wear (Standard for 1 1/4” Blades)	052355 [3]	2	
	Block, Blade Guide Wear (Optional for 1 1/2” Blades)	052309 [3]	2	
	Block Assembly, 1” Sq. EZ-Glide Wear	036347 [3]	2	
44	Block, Blade Guide Alignment	035799	1	
45	Washer, #10 Split Lock	F05011-20	1	
46	Screw, #10-32 x 5/8” Hex Head	F05004-152	1	
47	Adjustment Tool, Lower Guide Block	044064	1	
48	Shim, .008" Blade Guide Block Spacer	035248	1	
	Drive Side Blade Guide Parts (*See Section 7.2*)			
49	**BAR WELDMENT, SHR IDLE SIDE BLADE GUIDE**	036864	1	
50	**WASHER, 1/2" SPLIT LOCK**	F05011-9	3	
51	**BOLT, 1/2-13 X 1 1/2" HEX HEAD GRADE 5**	F05008-33	3	

[1] The resaw is equipped standard with blade guide rollers that can be used with the standard 1 1/4” blade or 1 1/2” blades. Optional extended blade guide rollers are available for use with 1 1/2” blades. The extended rollers may provide more stability during difficult sawing, but will reduce the total amount of times the blade can be reused after sharpening. Use kit 006382 to convert the rollers and guide blocks for both blade guides for 1 1/2” blades.

[2] High-Performance Blade Guide Kit requires LMS blade lube system. If resaw already equipped with LMS, use kit 006340 to upgrade both drive and idle side blade guides to High-Performance. If no LMS, add kit LMS-SHR.

[3] 052355 blocks for use with 1 1/4” blade provided as standard equipment. 052309 blocks available for optional use with 1 1/2” blades. Use kit 006382 to convert the rollers and guide blocks for both blade guides for 1 1/2” blades. EZ-Glide blocks 036347 are available for customers who prefer this block.

7.2 Blade Guide Assembly, Drive Side



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	GUIDE ASSEMBLY, DRIVE SIDE BLADE ROLLER	003905	1	
	Block Assembly, Blade Guide Mount	003910	1	
1	Block Weldment, Blade Guide Mount	003911	1	◆
2	Nut, 5/16-18 Hex	F05010-17	4	
3	Screw, 5/16-18 x 1” Socket Head Flat Point Stainless Steel Set	F05006-122	1	
4	Bolt, 5/16-18 x 1” Hex Head Stainless Steel	F05006-88	3	
5	Shaft Weldment, Drive Side Guide	003913	1	
6	Plate, Blade Guide Deflector	003916	1	
7	Bolt, 5/16-18 x 3/4” Hex Head w/Flat & Lock Washer	F05006-101	1	
	Roller Assembly, Blade Guide (standard for use with 1 1/4” & 1 1/2” blades)	A04925 [1]	1	
	Roller Assembly, Extended Blade Guide (optional for use with 1 1/2” blades)	014299 [1]	1	

	Bearing Kit, Blade Guide Rebuild	K07079	1	
8	Washer, 5/8" White Felt	P04252	1	
9	Ring, 1 1/8" Interior Retaining	F04254-1	1	
10	Bearing, R8-2RS Blade Guide	015975	2	◆
11	Washer, 5/8" Gray Felt	P06455	1	
	Screw, 1/4-28 x 1/4” Socket Head Cup Point Set Black Oxide	F05005-105	1	
	Instruction Sheet, Blade Guide Rebuild	057407-1507	1	
12	Roller, Flanged Blade Guide (1 1/4” & 1 1/2” blade)	S04250	1	◆
	Roller, Flanged Blade Guide (1 1/2” blade)	014298	1	◆
	Instruction Sheet, Blade Guide Roller Replacement	A04925-364	1	
13	Spacer, Blade Guide	S04253	2	
14	Washer, 1/2” Nord-Lock	F05011-125	1	
15	Bolt, 1/2-13 x 2 1/4” Hex Head Grade 5	F05008-10	1	
16	Washer, 5/16” SAE Flat	F05011-17	2	
17	Washer, 5/16” Split Lock	F05011-13	2	
18	Bolt, 5/16-18 x 1 1/2” Hex Head	F05006-76	2	
19	Bolt, Blade Guide Vertical Adjustment	035656	1	
20	Nut, 5/16-18 Hex	F05010-17	1	
21	Bolt, 5/16-18 x 2 3/4” Hex Head Full Thread	F05006-136	1	
	GUIDE KIT, HIGH-PERFORMANCE BLADE GUIDE (OPTIONAL)	006340 [2]	1	
	Block Assembly, Drive Side Blade Guide	003927	1	
22	Plate, Block Tilt Adjustment	003915	1	
23	Block, Guide Block Mount	003909	1	
24	Pin, 3/16” x 5/8” Roll	F05012-22	2	
25	Washer, 3/8” SAE Flat	F05011-3	1	
26	Washer, 3/8” Split Lock	F05011-4	1	
27	Bolt, 3/8-16 x 1 1/4” Hex Head Grade 5	F05007-123	1	
28	Bolt, 5/16-18 x 3/4” Hex Head	F05006-102	1	
29	Ball, 3/16” Dia. Nylon	003914	2	
30	Washer, 1/4” Split Lock	F05011-14	2	
31	Bolt, 1/4-20 x 1/2” Hex Head	F05005-15	2	
32	Bolt, Blade Guide Block Mount	003994	1	
33	Washer, #10 Brass	042867	1	
34	Bolt, #10-32 x 1 1/4” Hex Head Stainless Steel	F05004-240	1	
35	Screw, Lower Block Adjustment	044057	1	
36	Screw, #10-32 x 3/8” Socket Head Stainless Steel	F05004-200	1	
37	Washer, 5/16” SAE Flat	F05011-17	1	
38	Washer, 5/16” Split Lock	F05011-13	1	
39	Block, Blade Guide Wear (Standard for 1 1/4” Blades)	052355 [3]	2	
	Block, Blade Guide Wear (Optional for 1 1/2” Blades)	052309 [3]	2	
	Block Assembly, 1” Sq. EZ-Glide Wear	036347 [3]	2	
40	Block, Blade Guide Alignment	035799	1	
41	Washer, #10 Split Lock	F05011-20	1	

42	Screw, #10-32 x 5/8” Hex Head	F05004-152	1	
43	Adjustment Tool, Lower Guide Block	044064	1	
44	Shim, .008" Blade Guide Block Spacer	035248	1	
	Idle Side Blade Guide Parts (*See Section 7.1*)			

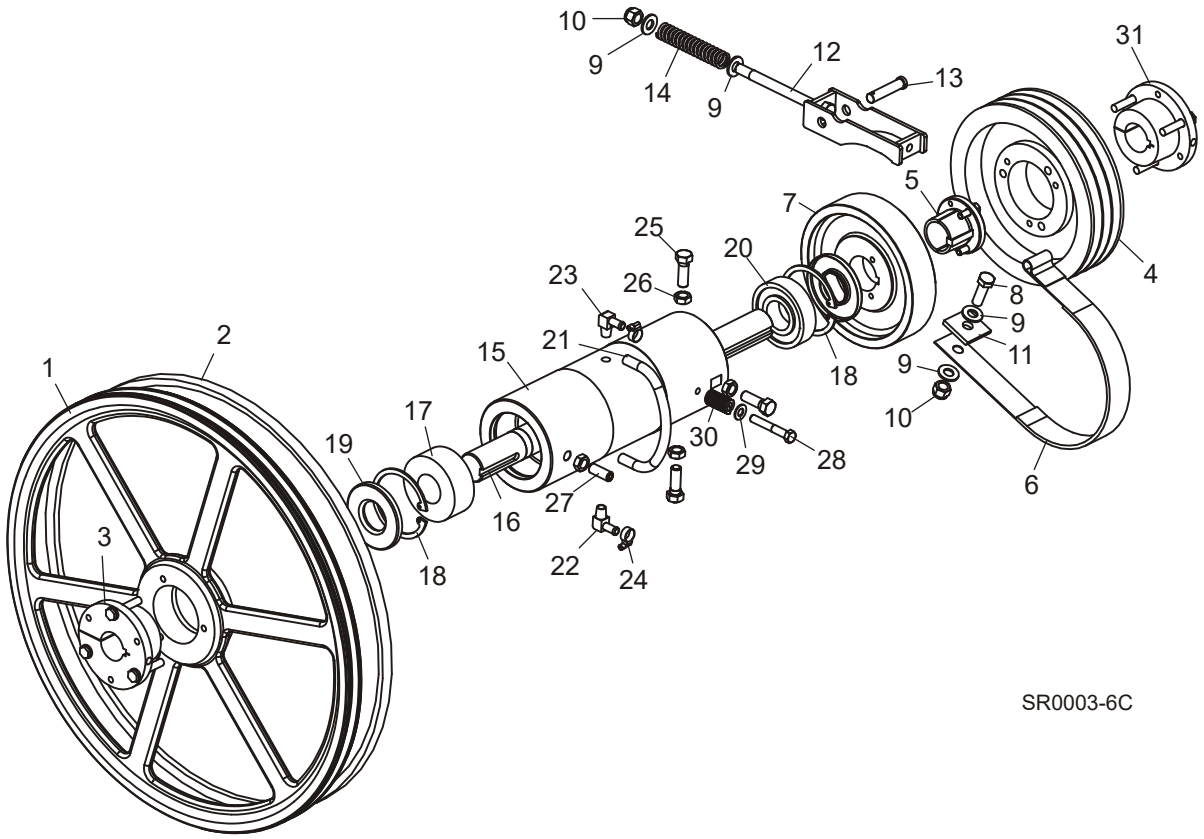
[1] The resaw is equipped standard with blade guide rollers that can be used with the standard 1 1/4” blade or 1 1/2” blades. Optional extended blade guide rollers are available for use with 1 1/2” blades. The extended rollers may provide more stability during difficult sawing, but will reduce the total amount of times the blade can be reused after sharpening. Use kit 006382 to convert the rollers and guide blocks for both blade guides for 1 1/2” blades.

[2] High-Performance Blade Guide Kit requires LMS blade lube system. If resaw already equipped with LMS, use kit 006340 to upgrade both drive and idle side blade guides to High-Performance. If no LMS, add kit LMS-SHR.

[3] 052355 blocks for use with 1 1/4” blade provided as standard equipment. 052309 blocks available for optional use with 1 1/2” blades. Use kit 006382 to convert the rollers and guide blocks for both blade guides for 1 1/2” blades. EZ-Glide blocks 036347 are available for customers who prefer this block.

SECTION 8 BLADE WHEELS & DRIVE

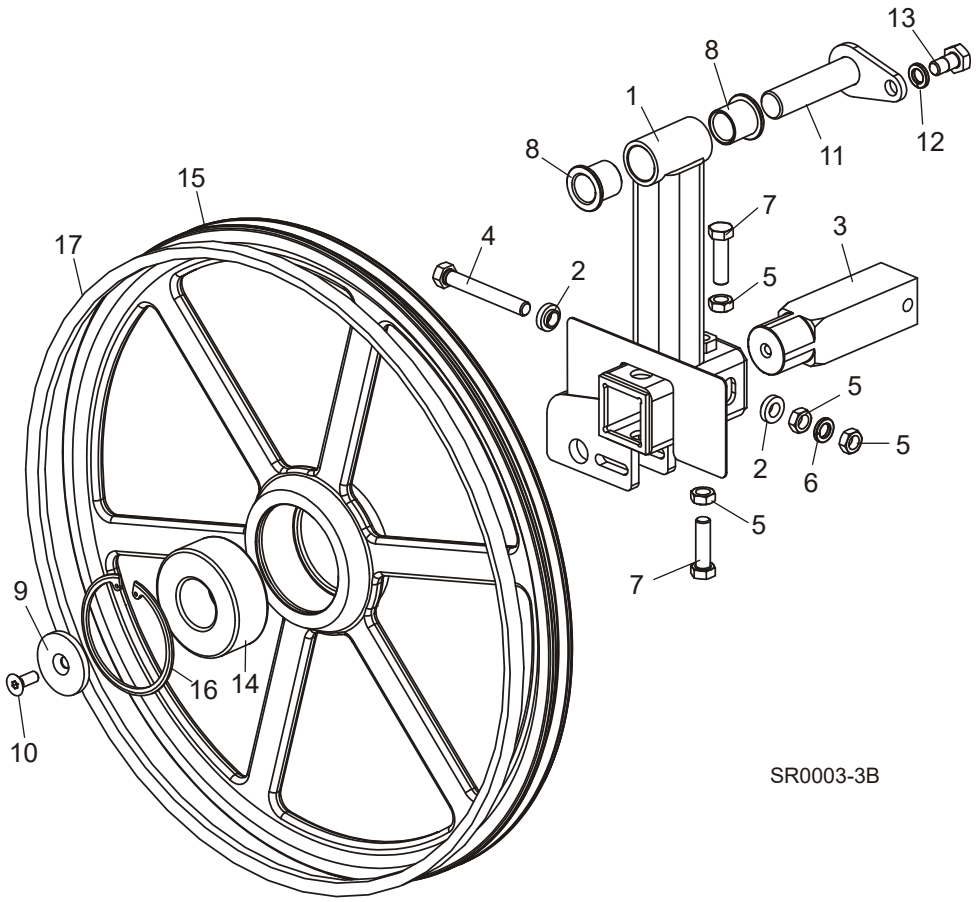
8.1 Blade Drive Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	SHEAVE, 24" SHR "V"GROOVE	036827	1	
2	BELT, B72.5	017922-1	1	
3	BUSHING, SF X 1 9/16"	016532	1	
4	SHEAVE, 3/5V X 9.25SF (SHR25 60HZ ONLY)	007349	1	
	SHEAVE, 3/5V X 9.75SF (SHR20 60HZ ONLY)	036929	1	
	SHEAVE, 3/5V5.5SDS (SHR20 50HZ ONLY)	006320	1	
	SHEAVE, 2B8.6SK (SHR10 ONLY)	038845	1	
5	BUSHING, P1 1-9/16 SPLIT TAPER	014003	1	
6	BAND, UPPER PIVOT BRAKE	014391	1	
7	PULLEY, BRAKE	014000	1	
8	BOLT, 1/2-13 X 1 1/2" HEX HEAD GRADE 5	F05008-33	1	
9	WASHER, 1/2" SAE FLAT	F05011-2	4	
10	NUT, 1/2-13 HEX NYLON LOCK	F05010-8	2	
11	PLATE, 1/4" X 1 3/4" X 1 3/4" BRAKE STRAP	S04195	1	

12	**BRAKE LINK WELDMENT, SHR**	036953	1	
13	**PIN, 1/2" X 2 1/4" CLEVIS**	F05012-81	1	
14	**SPRING, .88" X 4.31" X .125"**	036954	1	
	BEARING ASSEMBLY, SHR	036925	1	
15	Housing, SHR Cylindrical Bearing	036927	1	
16	Shaft, SHR Drive	036928	1	
17	Bearing, MU5308TV	036926	1	
18	Ring, 90mm I17 IR Retaining	F04254-17	2	
19	Seal, CR15890	P10206	2	
20	Bearing, 6308 C3, Open	016055	1	
21	Tube, Oil Level	016394	1	
22	Fitting, 1/4" NPT x 3/8" Hose Barb, Elbow	016330	2	
23	Fitting, 1/4" NPT x 3/8" Hose Barb, Vented Elbow	016331	1	
24	Hose Clamp, 7/32"-5/8"	P649	2	
25	**BOLT, 1/2-20 X 1 1/2" HEX HEAD GRADE 5**	F05008-53	3	
26	**NUT, 1/2-20 HEX JAM**	F05010-16	4	
27	**BOLT, 1/2-20 X 1 1/2" STAINLESS STEEL CONE POINT**	F05004-170	1	
28	**BOLT, 3/8-16 X 2-1/2" HEX HEAD GRADE 5**	F05007-125	1	
29	**WASHER, 3/8" FLAT SAE**	F05011-3	1	
30	**SPRING, 3/4" OD X 1 1/2" DIE**	034430	1	
31	**BUSHING, SF X 1 9/16" (SHR20 & SHR25 60HZ ONLY)**	016532	1	
	BUSHING, SDS X 1 5/8" (SHR20 50HZ ONLY)	033249	1	
	BUSHING, SK X 1 9/16" (SHR10 ONLY)	014690	1	

8.2 Idle Blade Wheel Assembly

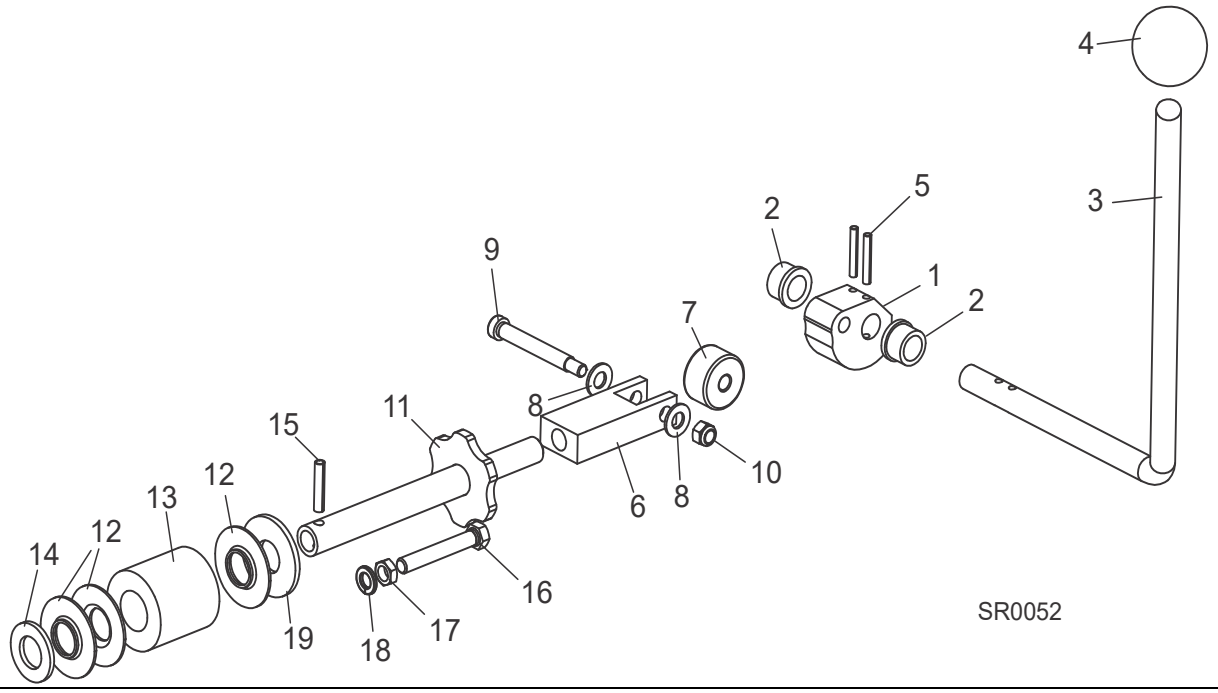


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	IDLER ASSEMBLY, SHR	036877	1	
1	Idler Weldment, SHR	036874	1	
2	Spacer, .510" x .937" x .34"	S04253	2	
3	Shaft, 1 3/4" Idler, 3/8" Retainer	016398	1	
4	Bolt, 1/2-20 x 3 3/4" Hex Head Full Thread Grade 2	F05008-111	1	
5	Nut, 1/2-20 Hex Jam	F05010-16	4	
6	Washer, 1/2" Split Lock	F05011-9	1	
7	Bolt, 1/2-20 x 1 3/4" Hex Head Full Thread	F05008-127	2	
8	Bushing, 1" ID x 1-1/4" OD Flanged	P109	2	
9	Retainer, 13/32" I.D. x 2 1/4" O.D. x 1/4	016397	1	
10	Screw, 3/8-16 x 1" Socket Head	F05007-64	1	
11	**PIN WELDMENT, SIDE SUPPORT**	042232	1	
12	**WASHER, 1/2" SPLIT LOCK**	F05011-9	1	
13	**BOLT, 1/2-13 X 1 HEX HEAD GRADE 2**	F05008-50	1	
	WHEEL ASSEMBLY, 24 IDLE, BELTED	017835	1	

14	Bearing, 5309-2RS	016014	1	
15	Sheave, 24" Idler "V"Groove	034871	1	
16	Ring, 100mm Internal Beveled	F04254-28	1	
17	**BELT, B72.5**	017922-1	1	

SECTION 9 SAW HEAD

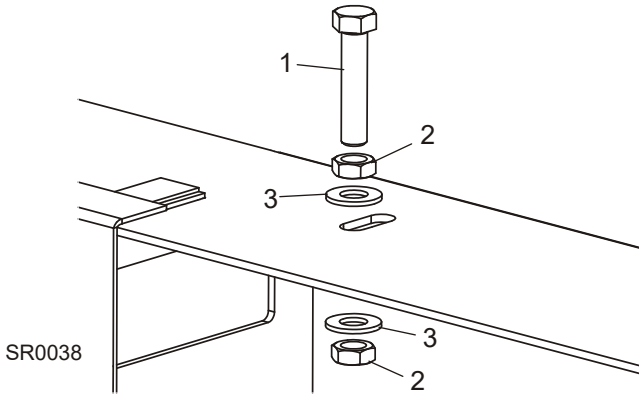
9.1 Blade Tensioner Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TENSION ASSEMBLY, CAM ACTUATED BLADE	038643	1	
1	Cam, Tension	049104	1	
2	Bushing, 5/8” x 7/8” x 1/2” Bronze	P05135	2	
3	Handle, Blade Tensioner	048804	1	
4	Knob, 5/8-18 Ball	P04211	1	
5	Pin, 3/16” x 1 1/4” Roll	F05012-16	2	
6	Block, Tensioner Bearing Mount	049321	1	
7	Cam Follower, 3/8" x 1 3/8" x 13/16"	048219	1	
8	Washer, 3/8” SAE Flat	F05011-3	2	
9	Bolt, 3/8 x 2 1/2” Socket Head Shoulder	F05007-202	1	
10	Nut, 5/16-18 Hex Nylon Lock	F05010-58	1	
11	Shaft Weldment, Blade Tension	038642	1	
12	Guide, Tension Handle	014925	3	
13	Spring, Rubber Tensioner Blade	014828	1	
14	Washer, 3/4" SAE Flat	F05011-62	1	
15	Pin, 1/4" x 1 1/4" Roll	F05012-12	1	
16	Bolt, 3/8-16 x 2 1/2" Hex Head Full Thread	F05007-157	1	
17	Nut, 3/8-16 Jam	F05010-29	1	

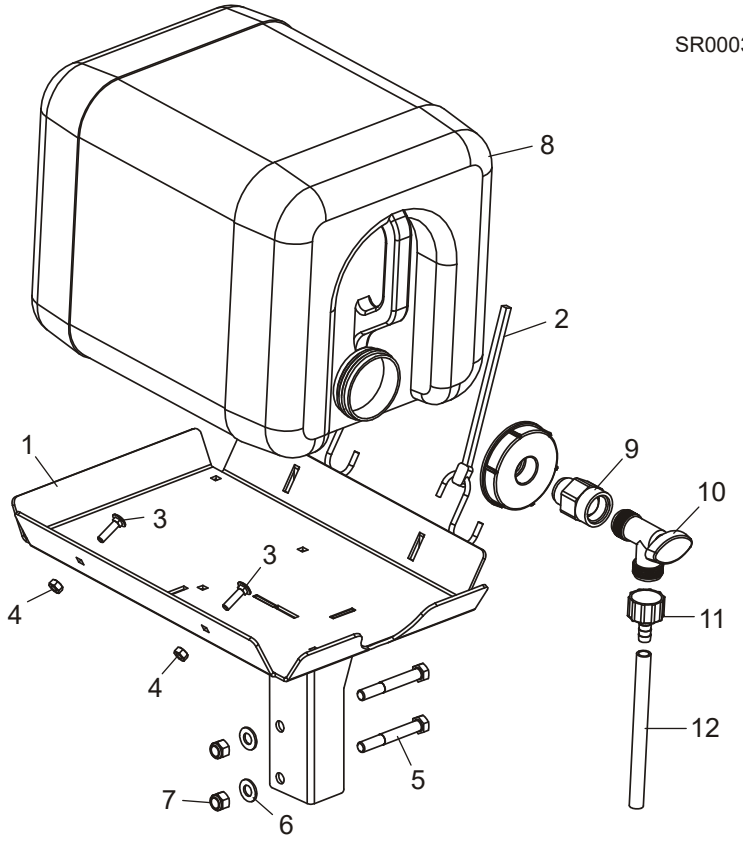
18	Washer, 3/8” Split Lock	F05011-4	1	
19	Washer, 3/4" USS Flat	F05011-29	1	

9.2 Middle Throat Screw



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**BOLT, 3/8-16 X 1 3/4" HEX HEAD GRADE 5**	F05007-129	1	
2	**NUT, 3/8-16 JAM**	F05010-29	2	
3	**WASHER, 3/8" FLAT SAE**	F05011-3	2	

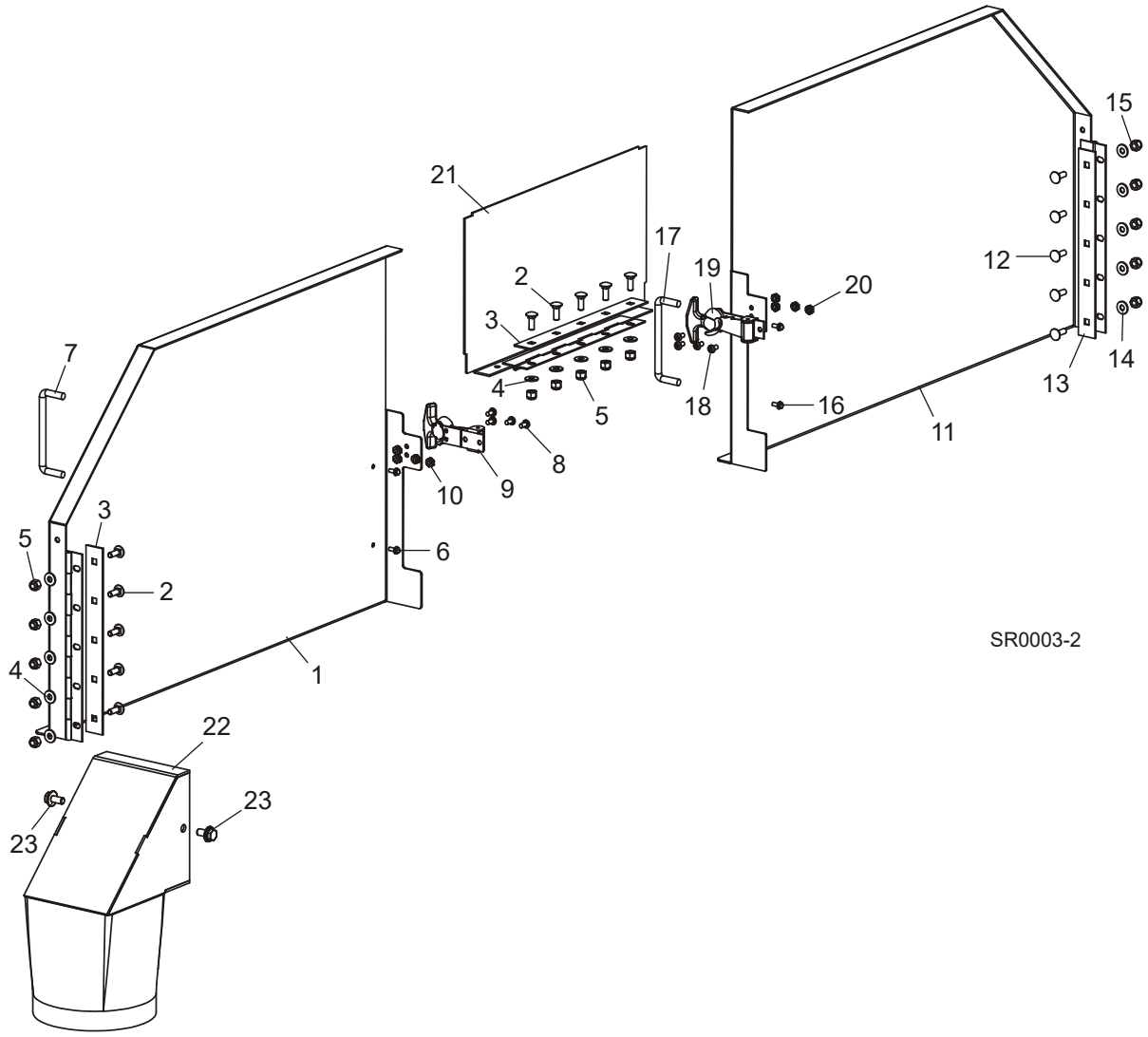
9.3 Water Lube Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TRAY ASSEMBLY, LT28 WATER BOTTLE	048599	1	
1	Tray Weldment, LT28 Water Bottle	048600	1	
2	Strap, 20" Rubber w/Hook	P11668	2	
3	Bolt, 1/4-20 X 1" Carriage Head	F05005-34	2	
4	Nut, 1/4-20 Hex Lock	F05010-21	2	
5	Bolt, 3/8-16 x 2 3/4" Hex Head	F05007-29	2	
6	Washer, 3/8" Flat SAE	F05011-3	2	
7	Nut, 3/8-16 Hex Nylon Lock	F05010-10	2	
8	Bottle Assembly, Water Lube w/Cap	014642	1	
	O-ring, Water Bottle Cap	061372 [1]	1	
9	Fitting, 3/4" FPT x 3/4" MPT	014636	1	
10	Valve, 5/8" 90 deg. Male Shutoff	014100	1	
11	Fitting, 5/8-3/8 Hose Barb	014113	1	
12	Hose, Water Lube Stock	R01885	6 ft.	

[1] If the water bottle cap keeps leaking, add this o-ring to the cap. Leave the existing o-ring installed.

9.4 Covers & Sawdust Chute

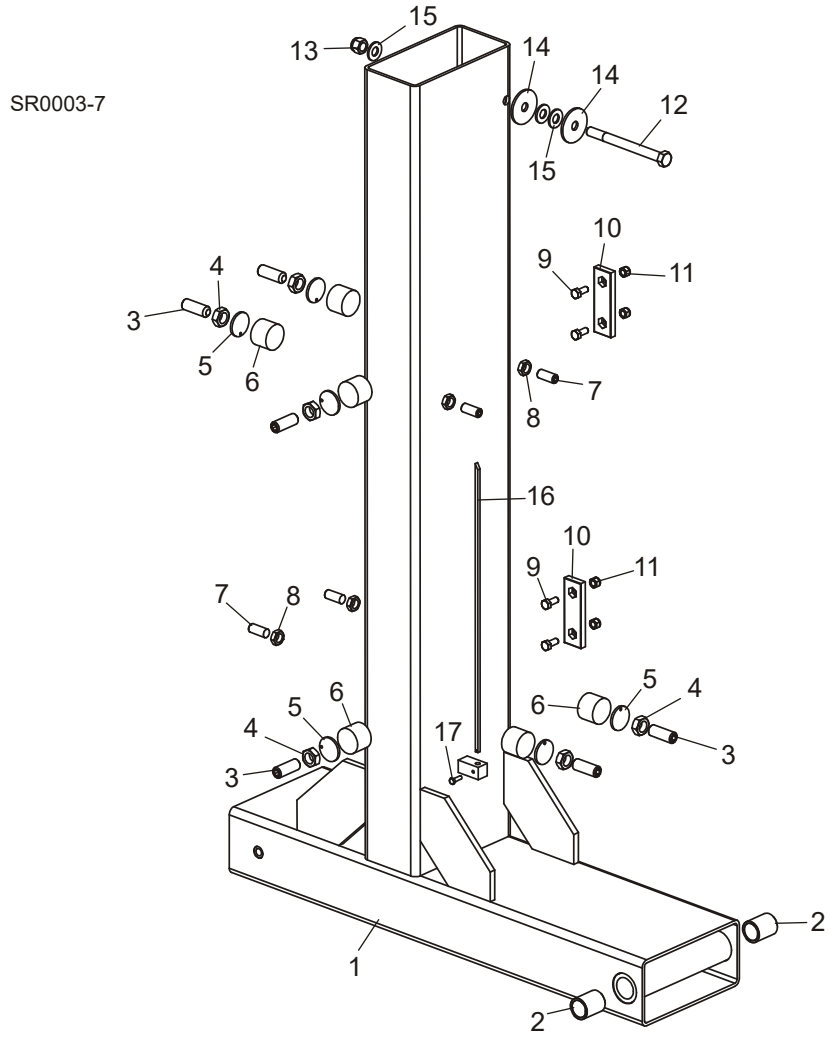


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	COVER ASSEMBLY, SHR DRIVE SIDE	036922	1	
1	Door Weldment, SHR Drive Side	036879	1	
2	Bolt, 1/4-20 x 3/4" Carriage	F05005-113	5	
3	Plate, Hinge Backing	034251	1	
4	Washer, 1/4" SAE Flat	F05011-11	5	
5	Nut, 1/4-20 Nylon Lock	F05010-69	5	
6	Bolt, #8-32 x 3/8" Self Tap	F05015-8	2	
7	Handle, 4" w/Bolts	P08065	1	
8	Screw, #10-24 x 3/8" Phillips	F05004-3	4	
9	Latch, Flexible Draw	014829	1	

10	Nut, #10-24 Keps	F05010-14	4	
	COVER ASSEMBLY, SHR IDLE SIDE	036921	1	
11	Door Weldment, SHR Drive Side	036879	1	
12	Bolt, 1/4-20 x 3/4" Carriage	F05005-113	5	
13	Plate, Hinge Backing	034251	1	
14	Washer, 1/4" SAE Flat	F05011-11	5	
15	Nut, 1/4-20 Nylon Lock	F05010-69	5	
16	Bolt, #8-32 x 3/8" Self Tap	F05015-8	2	
17	Handle, 4" w/Bolts	P08065	1	
18	Bolt, #10-24 x 3/8" Phillips	F05004-3	4	
19	Latch, Flexible Draw	014829	1	
20	Nut, #10-24 Keps	F05010-14	4	
21	**COVER WELDMENT, SHR MIDDLE**	036895	1	
22	**EXTENSION WELDMENT, SHR DUST CHUTE**	036943	1	
23	**BOLT, 5/16-18 X 3/4" HEX HEAD W/FLAT & LOCK WASHER**	F05006-101	2	

SECTION 10 UP/DOWN

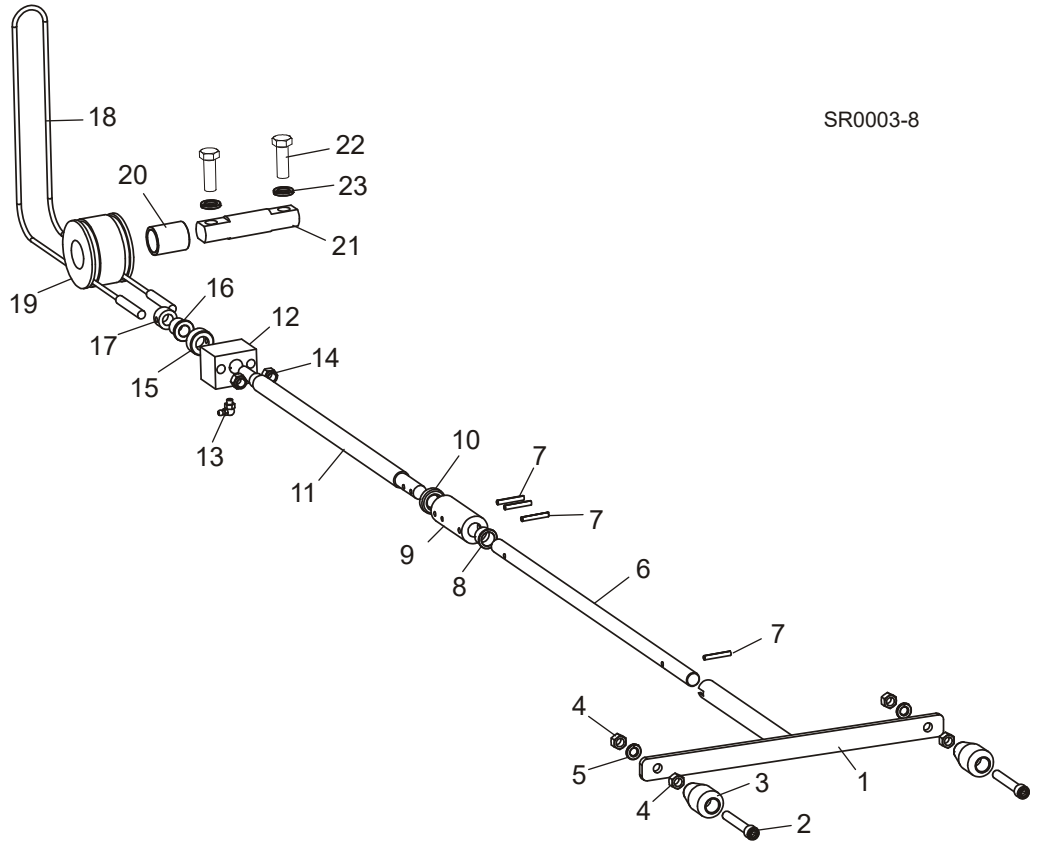
10.1 Mast Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**UPRIGHT WELDMENT, SHR**	036916	1	
2	**BUSHING, 1" X 1 1/4" X 1 1/2" BRONZE**	P05041	2	
3	**SCREW, 5/8-18 X 1 3/4" SOCKET HEAD**	F05009-27	6	
4	**NUT, 5/8-18 HEX JAM**	F05010-11	6	
5	**PAD, NYLON BACKING**	042432	6	
6	**PAD, ROUND NYLON**	033098	6	
7	**BOLT, 1/2-13 X 1 1/4" BRASS TIP STAINLESS STEEL**	F05008-18	4	
8	**NUT, 1/2-13 JAM**	F05010-31	4	
9	**BOLT, 5/16-18 X 3/4" HEX HEAD GRADE 2**	F05006-5	4	

10	**PADS, DELRIN UP/DOWN SLIDE**	M04096	2	
11	**NUT, 5/16-18 HEX NYLON LOCK**	F05010-58	4	
12	**BOLT, 1/2-13 X 5 1/2" HEX HEAD GRADE 5**	F05008-28	1	
13	**NUT, 1/2-13 HEX NYLON LOCK**	F05010-8	1	
14	**WASHER, 1/2" X 2" FENDER**	F05011-38	2	
15	**WASHER, 1/2" SAE FLAT**	F05011-2	3	
16	**POINTER, MH BLADE HEIGHT STRAIGHT**	S22636	1	
17	**SCREW, 10-24 X 5/8" HEX HEAD**	F05004-18	1	

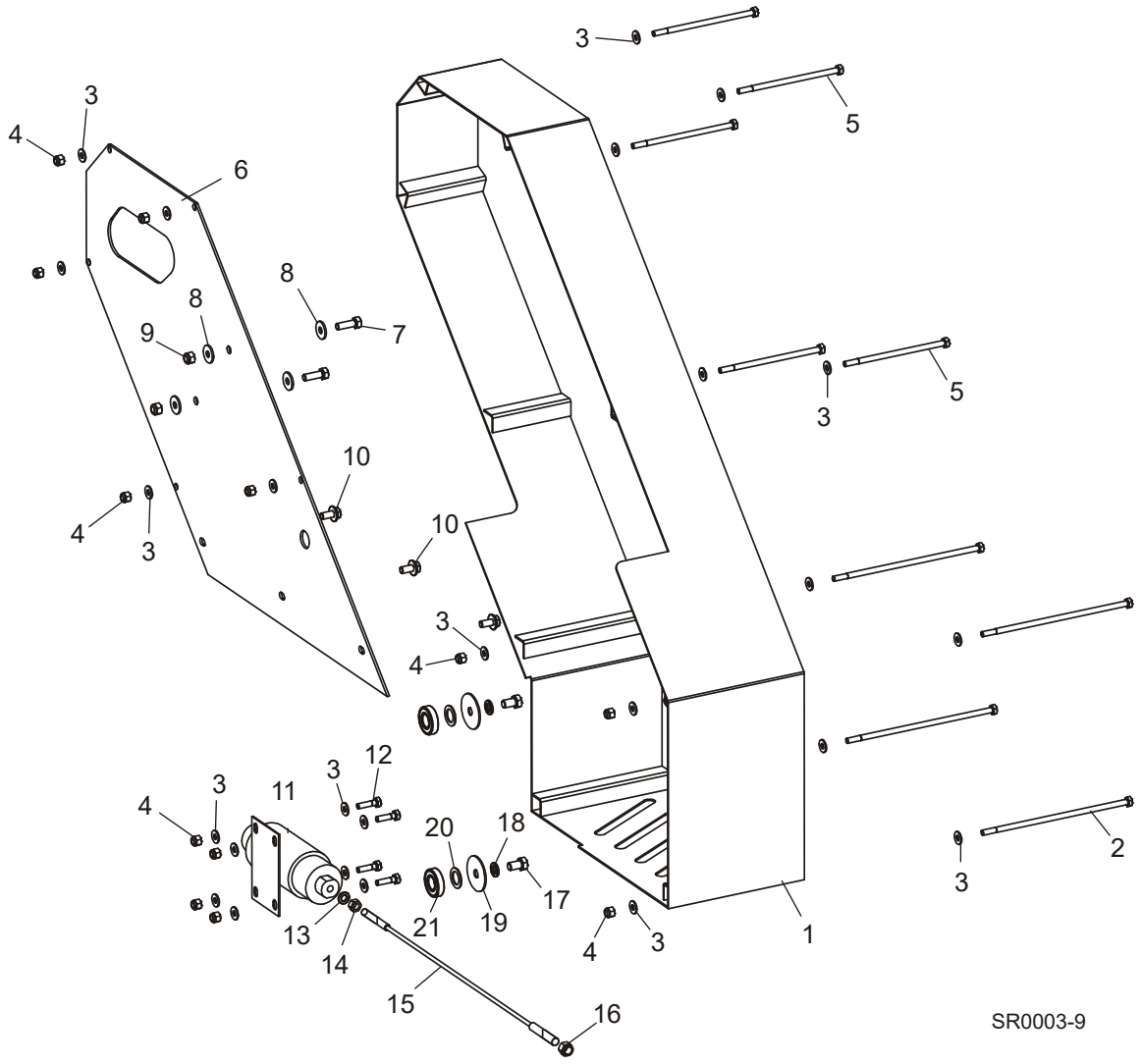
10.2 Up/Down System Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	HANDLE ASSEMBLY, UP/DOWN CRANK	033251	1	
1	Handle Weldment, Crank	033253	1	
2	Screw, 3/8-16 x 3 1/2" Socket Head Cap	F05007-111	2	
3	Knob, 3/8" Bore Tapered Plastic	060170	2	
4	Nut, 3/8-16 Jam	F05010-29	4	
5	Washer, 3/8" Split Lock	F05011-4	2	
6	**SHAFT, HEAD CRANK, SHR**	036949	1	
7	**PIN, 3/16" X 1 1/4" ROLL**	F05012-16	4	
8	**BUSHING, .635" I.D. X 3/4" O.D. NYLON FLANGED**	P22478	1	
9	**COUPLING, UP/DOWN CRANK**	S22476	1	
10	**BEARING, 5/8" THRUST**	P04214	1	
11	**ROD, HEIGHT ADJUSTMENT**	S22208	1	
12	**BLOCK, HEIGHT ADJUSTMENT**	S22209	1	
13	**FITTING, GREASE 90 DEG. 1/4-28**	P04108	1	
14	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	2	
15	**COLLAR, 5/8" I.D. LOCK**	P05035	1	
16	**BUSHING, 1/2" X 3/4" BRONZE FLANGED**	P22317	1	

17	**COLLAR, 1/2" I.D. X 7/8" O.D. LOCK**	014820	1	
18	**CABLE, UP/DOWN RESAW**	S22307	1	
19	**PULLEY, 2-GROOVED CABLE**	S22205	1	
20	**BUSHING, 1" X 1 1/4" X 1 1/2" BRONZE**	P05041	1	
21	**PIN, CABLE ROLLER**	S22203	1	
22	**BOLT, 1/2-13 X 1 1/2" HEX HEAD GRADE 5**	F05008-33	2	
23	**WASHER, 1/2" SPLIT LOCK**	F05011-9	2	

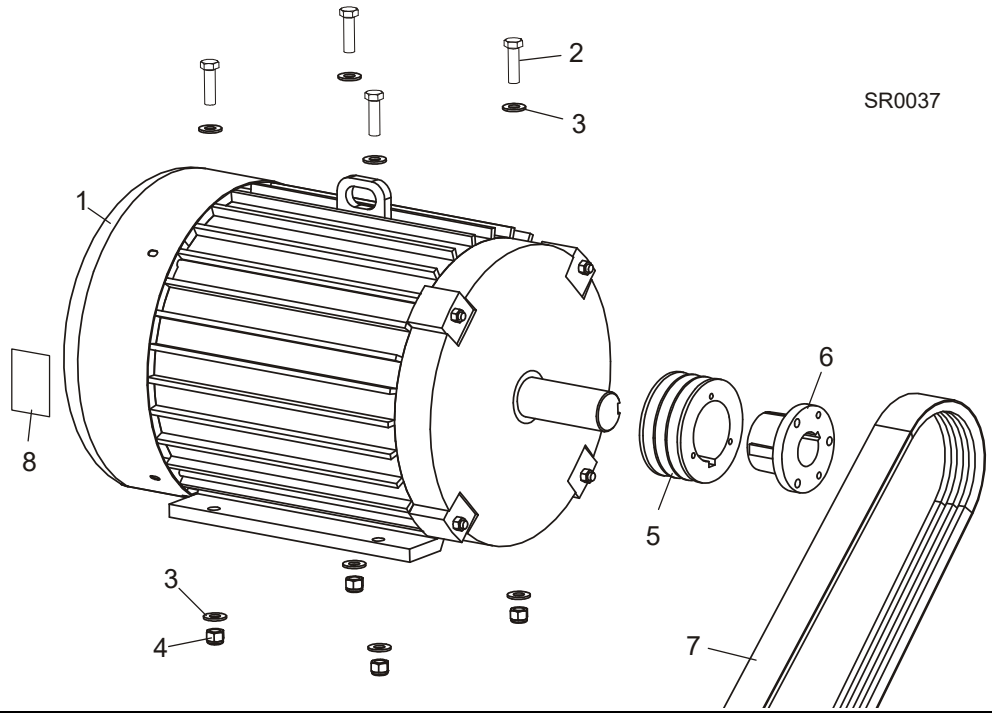
10.3 Drive Belt Covers and Brake Solenoid



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	GUARD WELDMENT, SHR	036935	1	
2	BOLT, 1/4-20 X 8" HEX HEAD GRADE 5	F05005-173	4	
3	WASHER, 1/4" SAE FLAT	F05011-11	26	
4	NUT, 1/4-20 NYLON LOCK	F05010-69	13	
5	BOLT, 1/4-20 X 5 1/2" HEX HEAD GRADE 5	F05005-82	5	
6	PLATE, REAR GUARD	036896	1	
7	BOLT, 5/16-18 X 1" HEX HEAD GRADE 5	F05006-27	2	
8	WASHER, 5/16" STANDARD FLAT	F05011-16	4	
9	NUT, 5/16-18 HEX NYLON LOCK	F05010-58	2	
10	BOLT, 5/16-18 X 3/4" HEX HEAD W/FLAT & LOCK WASHER	F05006-101	3	

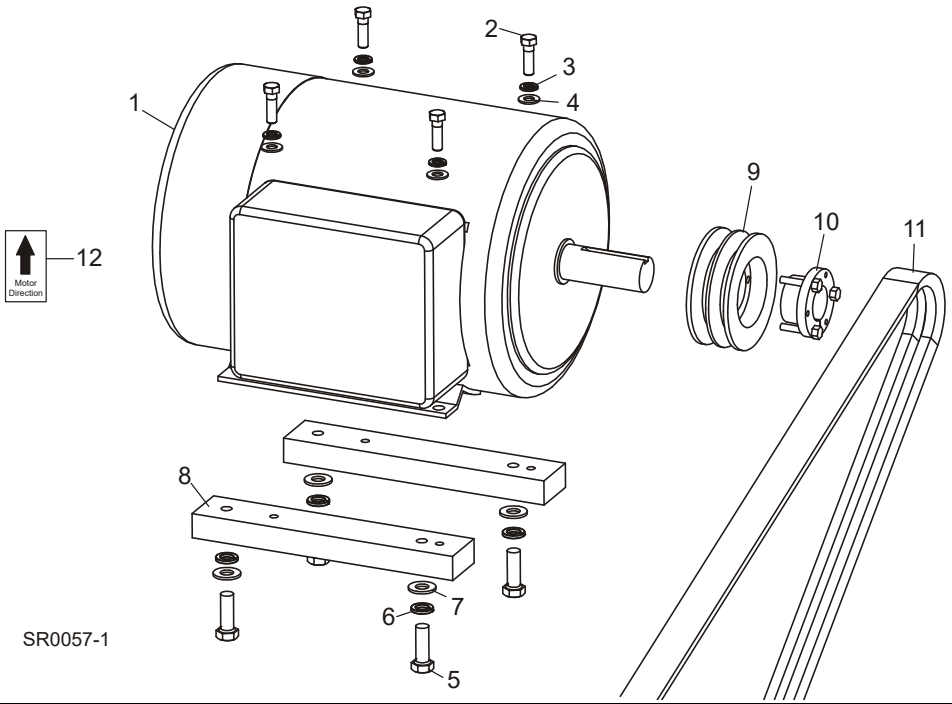
11	**SOLENOID, 39#, 24VDC**	038442	1	
12	**BOLT, 1/4-20 X 1" HEX HEAD GRADE 5**	F05005-101	4	
13	**WASHER, 5/16" SPLIT LOCK**	F05011-13	1	
14	**NUT, 5/16-24 HEX**	F05010-28	1	
15	**CABLE, SHR BRAKE**	038460	1	
16	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	1	
17	**BOLT, 3/8-16 X 1/2" HEX HEAD GRADE 5**	F05004-124	2	
18	**WASHER, 3/8" SPLIT LOCK**	F05011-4	2	
19	**WASHER, .39" X 1.75" X 14GA**	036931	2	
20	**SHIM, 5/8" X 1" X 1/16"**	016510	2	
21	**BEARING, R-10**	P04156	2	

10.4 Blade Motor Assembly (20HP/25HP)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	MOTOR ASSEMBLY, 20HP SINGLE HEAD RESAW	038489	1	
	MOTOR ASSEMBLY, 25HP SINGLE HEAD RESAW	038488	1	
1	Motor, Lincoln 20HP 1775 RPM (SHR20-L, SHR20-H & SHR20-380 Only)	074144	1	
	Motor, Lincoln 25HP 1725 RPM (SHR25-L & SHR25-H Only)	074121	1	
2	Bolt, 1/2-13 x 1 3/4" Hex Head Grade 5	F05008-88	4	
3	Washer, 1/2" SAE Flat	F05011-2	8	
4	Nut, 1/2-13 Hex Nylon Lock	F05010-8	4	
5	Sheave, 3/5V4.9 Drive (20HP Motor Only)	034560	1	
	Sheave, 3/5V4.65 Drive (25HP Motor Only)	007350	1	
6	Bushing, Q1 x 1 5/8" (20HP Motor Only)	034503	1	
	Bushing, SDS x 1 7/8" (25HP Motor Only Rev. A1.04+)	007351	1	
7	Belt, 3/5V800 Drive	038478	1	
	Driven Sheave & Bushing (*See Section 8.1*)			
8	**DECAL, MOTOR DIRECTION**	S20097	1	

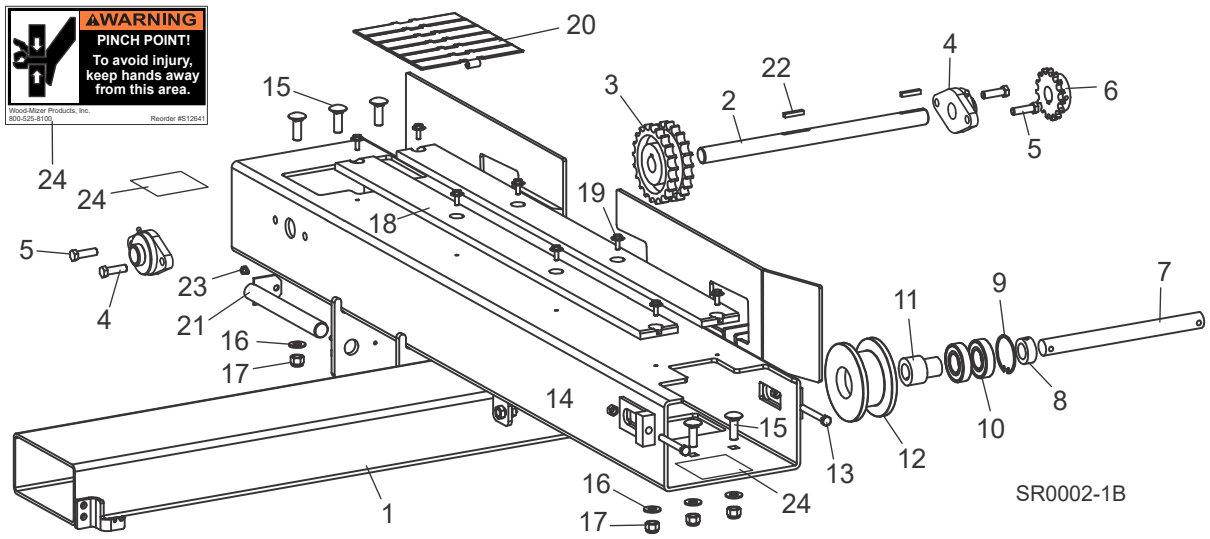
10.5 Blade Motor Assembly (10HP)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	MOTOR ASSEMBLY, 10HP SINGLE HEAD RESAW	038490	1	
1	Motor, Lincoln 10HP 1725 RPM Single Phase	038487	1	
2	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5	F05007-123	4	
3	Washer, 3/8" Split Lock	F05011-4	4	
4	Washer, 3/8" SAE Flat	F05011-3	4	
5	Bolt, 1/2-13 x 1 1/2" Hex Head Grade 5	F05008-33	4	
6	Washer, 1/2" Split Lock	F05011-9	4	
7	Washer, 1/2" SAE Flat	F05011-2	4	
8	Spacer, 10HP SHR Motor	038661	2	
9	Sheave, 2B4.0SH	P21003	1	
10	Bushing, SH x 1 3/8"	P21001	1	
11	Belt, 2BX74 Drive	P10277-2	1	
	Driven Sheave & Bushing (*See Section 8.1*)			
12	**DECAL, MOTOR DIRECTION**	S20097	1	

SECTION 11 FEED

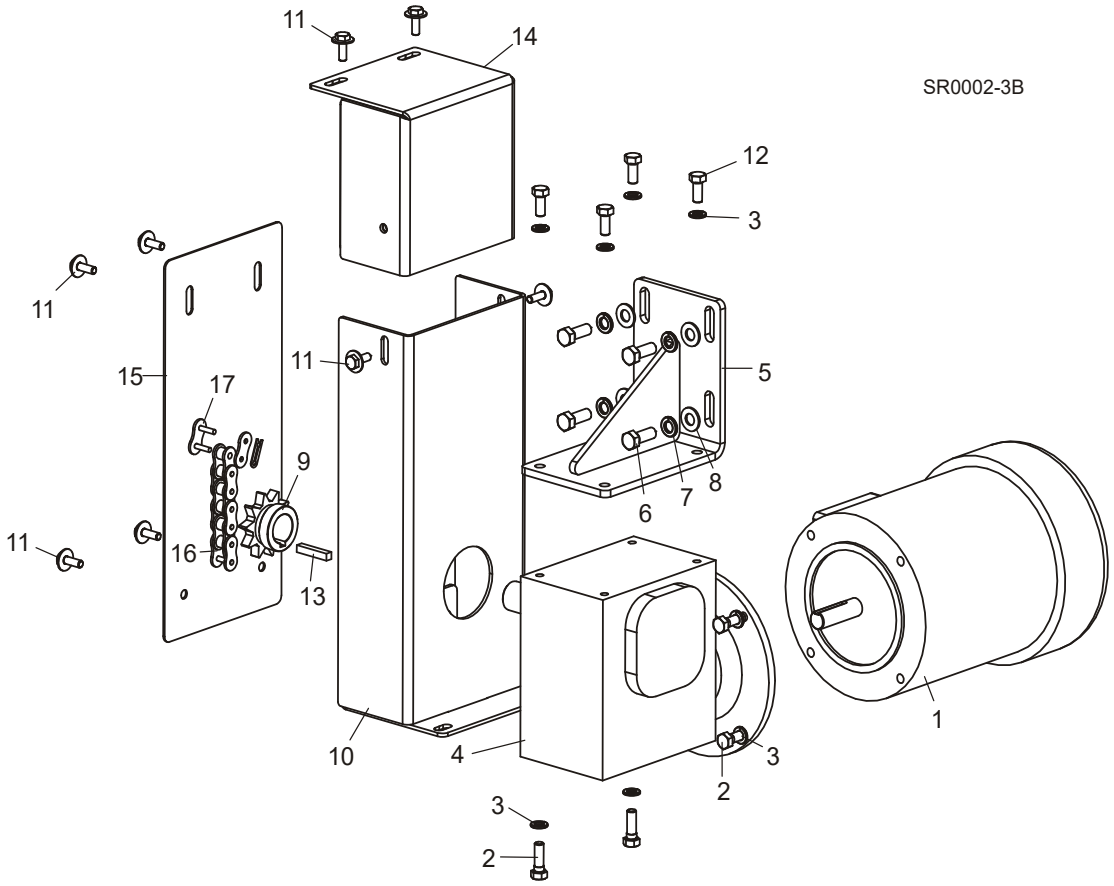
11.1 Feed Track Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	TUBE WELDMENT, DRIVE CHAIN	054349	1	
2	SHAFT, CHAIN DRIVE	054372	1	
3	SPROCKET, 21-22T FEED	P20202	1	
4	BEARING, 1 FLANGED, VF2S 216	038124	2	
5	BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 5	F05007-123	4	
6	SPROCKET, 50-15 X 1"	054172	1	
7	SHAFT, MULTIHEAD FEED IDLER	S22425	1	
8	COLLAR, 1" LOCK	038090	1	
9	RING, 62MM IR RETAINING	F04254-12	1	
10	BEARING, 6206-2NSE	P11035	2	
11	BUSHING, FEED IDLER	S20286	1	
12	PULLEY, FEED IDLER	S20282	1	
13	BOLT, 3/8-16 X 3" HEX HEAD FULL THREAD	F05007-1	2	
14	NUT, 3/8-16 HEX	F05010-1	2	
15	BOLT, 1/2-13 X 1-1/2" CARRIAGE	F05008-150	6	
16	WASHER, 1/2" SAE FLAT	F05011-2	6	
17	NUT, 1/2-13 HEX NYLON LOCK	F05010-8	6	
18	STRIP, 40-7/8 X 2-3/4" PRE-DRD TYVAR	054373	2	
19	BOLT, 1/4-20 X 3/4" HEX HEAD W/CONICAL WASHER	F05005-134	8	
20	CHAIN, 7-1/2" X 105" FLAT FEED TRACK	054374	1	
21	POST WELDMENT, CONTROL	054427	1	
22	KEY, 1/4SQ X1 3/8	017832	2	

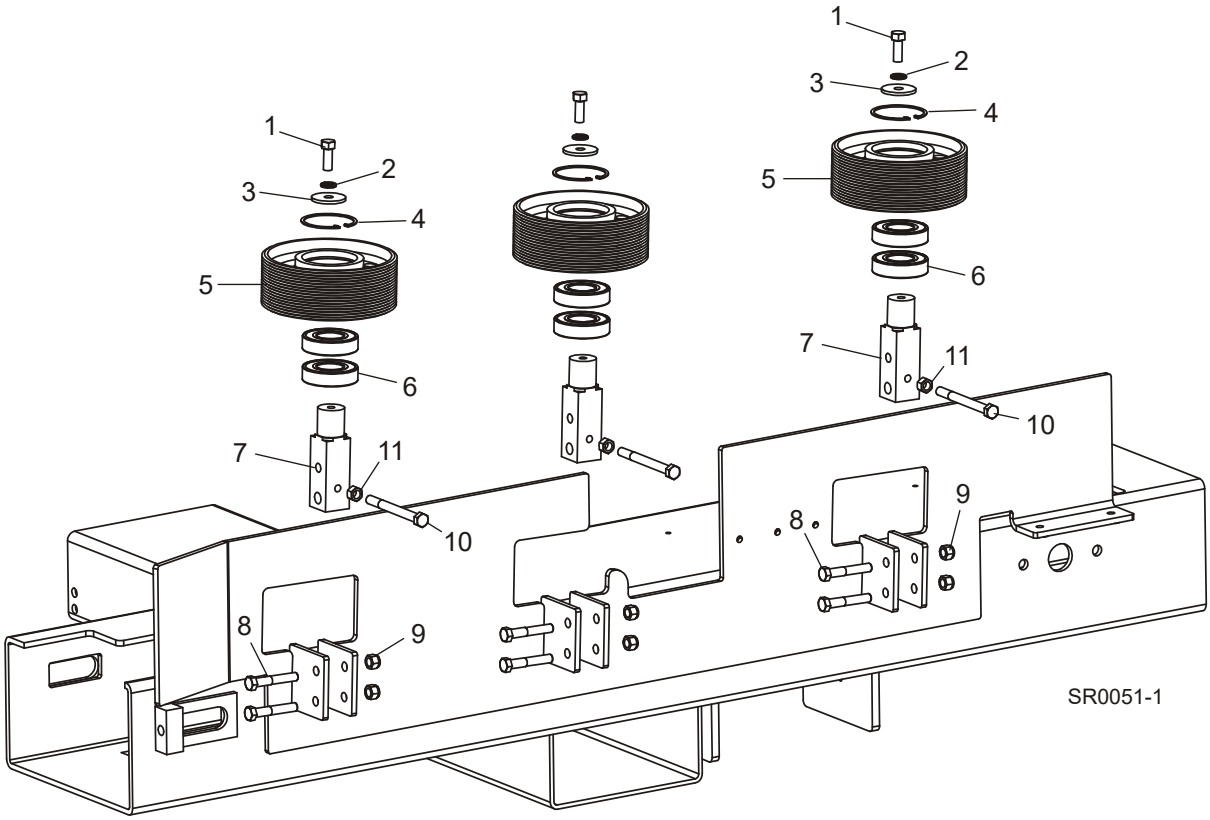
23	**BOLT, 1/4-20 X 1/2" HEX HEAD**	F05005-15	1	
24	**DECAL, PINCH POINT WARNING**	S12641	2	

11.2 Feed Motor Assembly



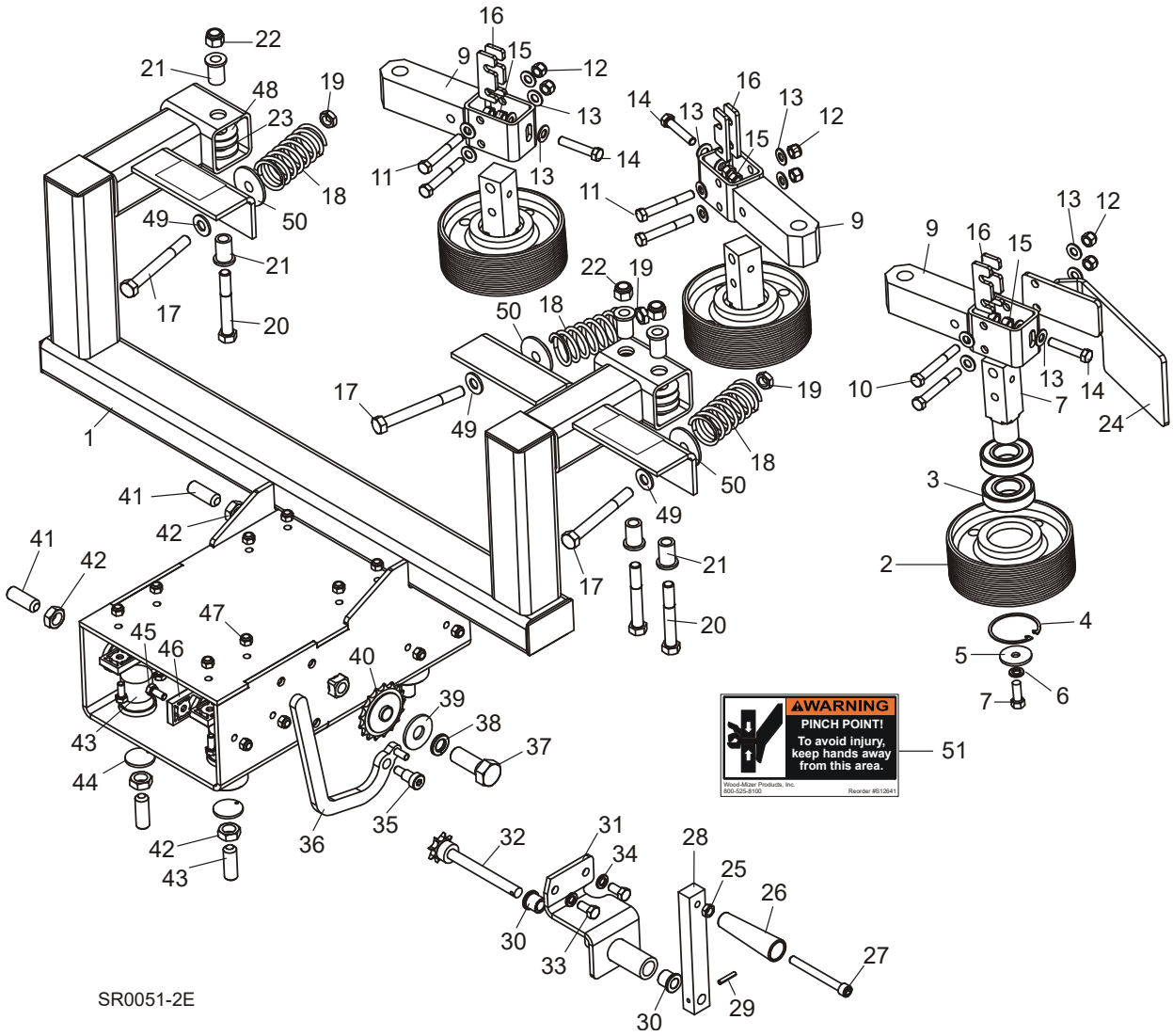
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	MOTOR, 1HP AC FEED	047486	1	
2	BOLT, 5/16-18 X 1" HEX HEAD GRADE 2	F05006-1	6	
3	WASHER, 5/16" SPLIT LOCK	F05011-13	10	
4	GEARBOX, 90 DEG. BMQ220 RIGHT	054363	1	
5	PLATE WELDMENT, GEARBOX MOUNT	054435	1	
6	BOLT, 3/8-16 X 1" HEX HEAD GRADE 5	F05007-87	4	
7	WASHER, 3/8" SPLIT LOCK	F05011-4	4	
8	WASHER, 3/8" FLAT SAE	F05011-3	4	
9	SPROCKET, 50BS10 X 1 MGR END	P21414	1	
10	GUARD WELDMENT, LOWER	054451	1	
11	BOLT, 1/4-20 X 3/4" HEX W/CONICAL WASHER HEAD	F05005-134	8	
12	BOLT, 5/16-18 X 3/4" HEX HEAD	F05006-102	4	
13	KEY, 1/4" SQUARE X 1 3/8"	017832	1	
14	COVER WELDMENT, TOP DRIVE	054448	1	
15	PLATE, FRONT COVER	054455	1	
16	CHAIN, #50 X 28 3/4"	054484	1	
17	LINK, #50 MASTER	P20208	1	

11.3 Stationary Feed Rollers



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, STATIONARY FEED	054368	3	
1	Bolt, 3/8-16 x 1" Hex Head	F05007-7	1	
2	Washer, 3/8" Split Lock	F05011-4	1	
3	Washer, 3/8" ID x 1 1/2" OD x 1/8" Thick	F05011-104	1	
4	Ring, 62mm Interior Retaining	F04254-12	1	
5	Roller, Feed	054369	1	
6	Bearing, 6206-2NSE	P11035	2	
7	Shaft, Stationary Roller	054370	1	
8	**BOLT, 3/8-16 X 2-1/4 HEX HEAD GRADE 5**	F05007-201	6	
9	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	6	
10	**BOLT, 3/8-16 X 4" HEX HEAD FULL THREAD G5**	F05007-92	3	
11	**NUT, 3/8-16 HEX**	F05010-1	3	

11.4 Pressure Roller Assembly

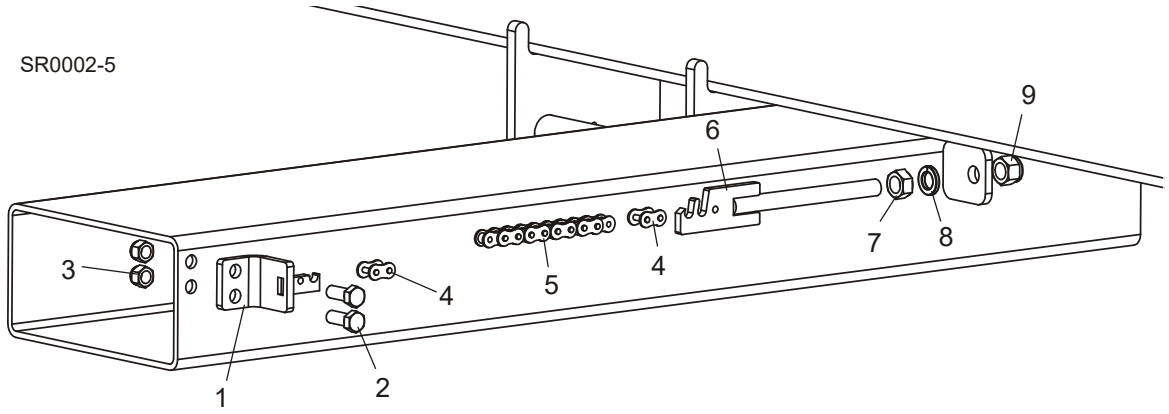


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, PRESSURE	054375	1	
1	Frame Weldment, Pressure Roller	054376	1	
	Roller Assembly, Stationary Feed	054368	3	
2	Roller, Feed	054369	1	
3	Bearing, 6206-2NSE	P11035	2	
4	Ring, 62mm Inside Retaining	F04254-12	1	
5	Washer, 3/8" ID x 1 1/2" OD x 1/8" Thick	F05011-104	1	
6	Washer, 3/8" Split Lock	F05011-4	1	

7	Bolt, 3/8-16 x 1" Hex Head	F05007-7	1	
8	Shaft, Stationary Roller	054370	1	
9	Block Weldment, Roller Mount	054399	3	
10	Bolt, 3/8-16 x 3" Hex Head Grade 5	F05007-73	2	
11	Bolt, 3/8-16 x 2 3/4" Hex Head Grade 5	F05007-206	4	
12	Nut, 3/8-16 Hex Nylon Lock	F05010-10	6	
13	Washer, 3/8" Flat SAE	F05011-3	18	
14	Bolt, 3/8-16 x 2" Hex Head Full Thread	F05007-16	3	
15	Nut, 3/8-16 Hex	F05010-1	6	
16	Plate, Roller Shaft Spacer	038583	6	
17	Bolt, 1/2-13 x 4 1/2" Hex Head Grade 5	F05008-35	3	
18	Spring. 1-11/16" x 3-1/2" x .177" (MH100-300)	054462	3	
19	Nut, 1/2-13 Hex Jam	F05010-31	3	
20	Bolt, 1/2-13 x 3 1/2" Hex Head Grade 5	F05008-61	3	
21	Bushing, 1/2" x 3/4" x 1-1/4"	054403	6	
22	Nut, 1/2-13 Hex Nylon Lock	F05010-8	3	
23	Spacer, 1" x 1-3/4" x 1/8"	054423	6	
24	Shoe Weldment, Cant	054400	1	
	Crank Assembly, Roller Feed	054417	1	
25	Nut, 3/8-16 Hex Jam	F05010-29	1	
26	Handle, 3/8" Bore Tapered Plastic	060170	1	
27	Bolt, 3/8-16 x 3 1/2" Socket Head	F05007-111	1	
28	Block, Press Roller Handle	007346	1	
29	Pin, 3/16" x 1" Roll	F05012-11	1	
30	Bushing, 1/2" X 3/4" Bronze Flanged	P22317	2	
31	Feed Weldment, In/Out	054418	1	
32	Shaft Weldment, Roller Feed	054433	1	
33	Bolt, 3/8-16 x 3/4" Hex Head Grade 5	F05007-118	2	
34	Washer, 3/8" Split Lock	F05011-4	2	
35	Screw, 3/8-16 1/2x1/2 Socket Shoulder	F05008-63	1	
36	Stop Assembly, Pressure Roller	065695	1	
37	Bolt, 5/8-11 x 1-1/2" Hex Head Full Thread Grade 5	F05009-41	1	
38	Washer, 5/8" Split Lock	F05011-27	1	
39	Washer, 5/8" Standard Flat	F05011-40	1	
40	Sprocket, #40 Idler 17T 5/8" ID	P04333	1	
41	Screw, 5/8-18 x 1 3/4" Flat Point Socket Set	F05009-27	6	
42	Nut, 5/8-18 Hex Jam	F05010-11	6	
43	Pad, Round Nylon	033098	6	
44	Pad, Nylon Backing	042432	6	
45	Bolt, 5/16-18 x 3/4" Hex Head Grade 2	F05006-5	11	
46	Pads, Delrin Up/Down Slide	M04096	6	
47	Nut, 5/16-18 Hex Nylon Lock	F05010-58	12	
48	Spacer, 3/4" ID x 1 3/4'' OD x 1/16" Thick	054467	3	

49	Washer, 1/2" SAE Flat Grade 5	F05011-101	3	
50	Bushing, Spring	054457	3	
51	**DECAL, HAND PINCH POINT WARNING**	S12641	2	

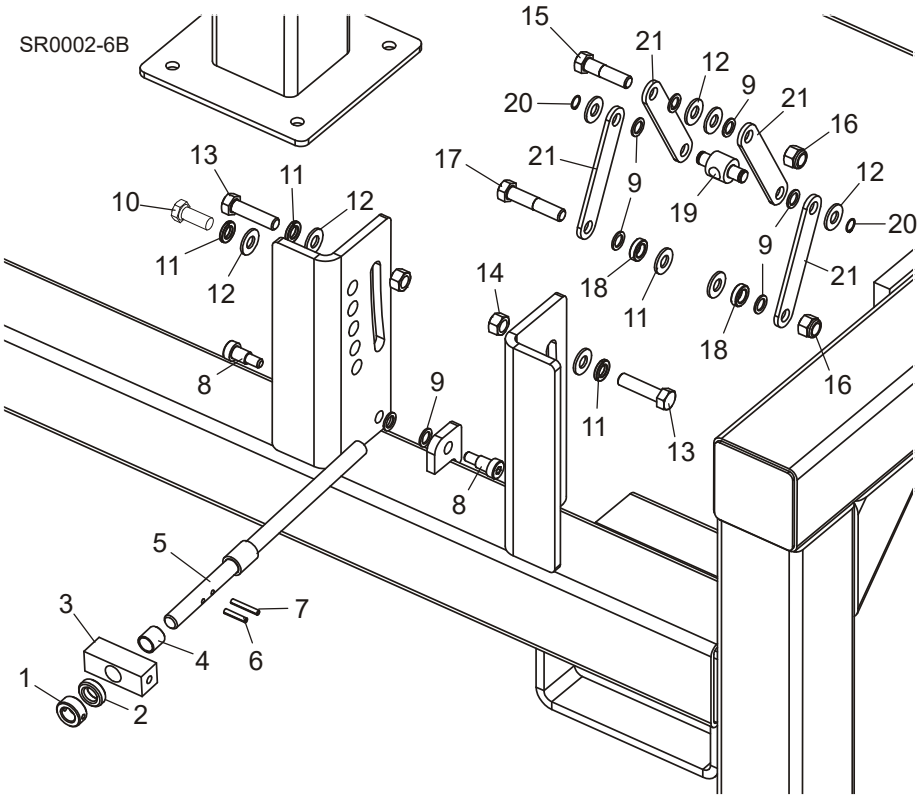
11.5 Pressure Roller Chain Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**PLATE WELDMENT, CHAIN MOUNT**	054414	1	
2	**BOLT, 3/8-16 X 1" HEX HEAD GRADE 5**	F05007-87	2	
3	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	2	
4	**LINK, #40 MASTER**	P04200	2	
5	**CHAIN, #40 X 21-1/2"**	054465	1	
6	**TENSIONER WELDMENT, POWER FEED CHAIN**	015721	1	
7	**NUT, 1/2-13 FREE HEX**	F05010-35	1	
8	**WASHER, 1/2" SPLIT LOCK**	F05011-9	1	
9	**NUT, 1/2-13 HEX NYLON LOCK**	F05010-8	1	

SECTION 12 FRAME

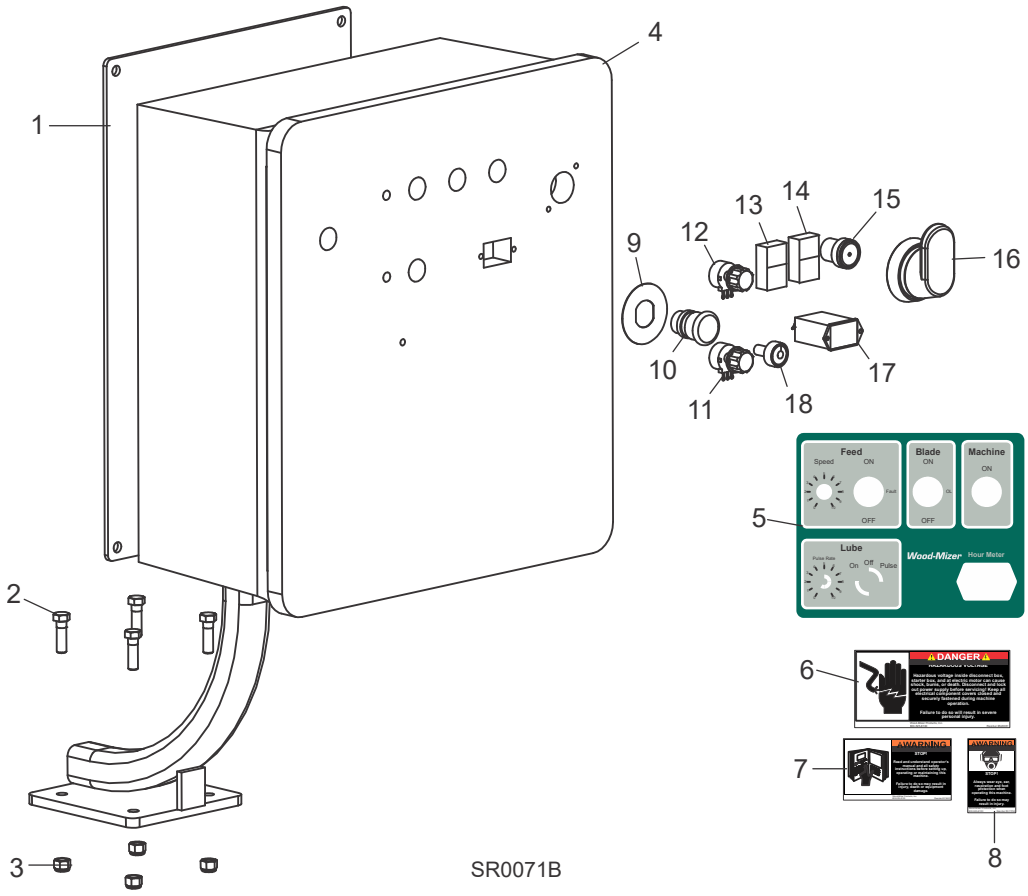
12.1 Saw Head Tilt Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SHAFT ASSEMBLY, SHR TILT	038479	1	
1	Collar, 5/8" I.D. x 1 1/8" O.D. Lock 3/16" thru.	016267	1	
2	Bearing, 5/8" Thrust	P04214	1	
3	Pivot, SHR Tilt	038470	1	
4	Spacer, 5/8" I.D. x 3/4" O.D. x 3/4" Long Bronze	P09130	1	
5	Shaft Weldment, SHR Tilt Adjustment	038477	1	
6	Pin, 3/16" x 1" Roll	F05012-11	1	
7	Pin, 3/16" x 1 1/4" Roll	F05012-16	1	
8	**BOLT, 3/8-16 1/2 X 5/8" THREADED SHOULDER**	F05008-115	2	
9	**WASHER, 1/2" X 3/4" X 1/16" NYLON**	P05251-1	8	
10	**BOLT, 1/2-13 X 1 1/4" HEX HEAD GRADE 5**	F05008-37	1	
11	**WASHER, 1/2" SPLIT LOCK**	F05011-9	3	
12	**WASHER, 1/2" SAE FLAT**	F05011-2	9	
13	**BOLT, 1/2-13 X 2" HEX HEAD FULL THREAD GRADE 5**	F05008-116	2	
14	**NUT, 1/2-13 SWAGED HEX 2-WAY LOCK**	F05010-3	2	

15	BOLT, 1/2-13 X 2" HEX HEAD GRADE 5	F05008-102	1	
16	NUT, 1/2-13 HEX NYLON LOCK	F05010-8	2	
17	BOLT, 1/2-13 X 2 1/2" HEX HEAD GRADE 5	F05008-74	1	
18	SPACER, 1/2" I.D. X 7/8" O.D. X 1/4"	041626	2	
19	TRUNION, SHR TILT	038475	1	
20	RING, SHAFT 1/2" OR 3100-50 RETAINING	F04254-18	2	
21	LINK, SHR TILT ADJUSTMENT	038474	4	

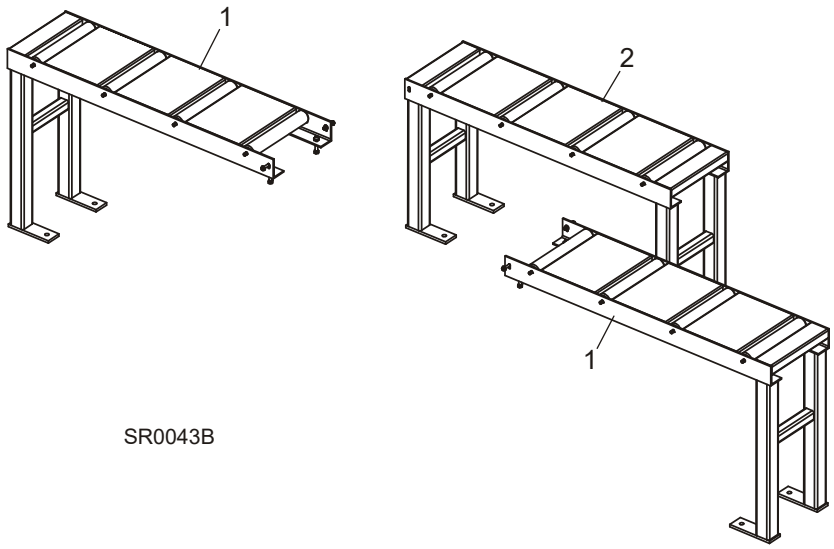
12.2 Control Box & Harnesses



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**POST WELDMENT, CONTROL**	054427	1	
2	**BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 5**	F05007-123	4	
3	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	4	
	CONTROL BOX ASSEMBLY, SHR 230V 1PH 10HP (NOT SHOWN)	052480	1	
	CONTROL BOX ASSEMBLY, SHR 460V 3PH 20HP (NOT SHOWN)	052476	1	
	CONTROL BOX ASSEMBLY, SHR 380V 3PH 20HP (NOT SHOWN)	052772	1	
	CONTROL BOX ASSEMBLY, SHR 230V 3PH 20HP (NOT SHOWN)	052478	1	
	CONTROL BOX ASSEMBLY, SHR 460V 3PH 25HP (NOT SHOWN)	052472	1	
	CONTROL BOX ASSEMBLY, SHR 230V 3PH 25HP (NOT SHOWN)	052474	1	
4	Enclosure, Control Box	052494	1	

	Insert Assembly, SHR 460V 3Ph 25HP	052471	1	
	Insert Assembly, SHR 230V 3Ph 25HP	052473	1	
	Insert Assembly, SHR 460V 3Ph 20HP	052475	1	
	Insert Assembly, SHR 380V 3Ph 20HP	052771	1	
	Insert Assembly, SHR 230V 3Ph 20HP	052477	1	
	Insert Assembly, SHR 230V 1Ph 10HP	052479	1	
	Harness Assembly, Feed Motor	052486-1	1	
	Harness Assembly, Brake	052488	1	
	Harness Assembly, Blade Motor (380/460V 3-Phase Only)	052492	1	
	Harness Assembly, Blade Motor (230V 3-Phase Only)	052520	1	
	Harness Assembly, Blade Motor (230V 1-Phase Only)	052523	1	
5	Decal, Control Box	052444	1	
6	Decal, Electrical Hazard Danger	S20061	1	
7	Decal, Read Manual Warning	016402	1	
8	Decal, Eye/Ear Protection Warning	S11753	1	
9	Legend, E-Stop Round Yellow	050992	1	
10	Switch, E-Stop Complete Push-Pull XB5	052497	1	
	Contact, NC ZBE102	050540	1	
11	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)	024590	1	
12	Potentiometer Assembly, 1K SHR Feed Control	052451	1	
13	Switch, 2 PBw/Pilot Green Flush Red Extend	052499	1	
	Switch Body, 22mm Red LED 1NO 1NC 24V XB5	052498	1	
14	Switch, 2 PBw/Pilot Green Flush Red Extend	052499	1	
	Switch Body, 22mm Red LED 1NO 1NC 24V XB5	052498	1	
	Contact, NC ZBE102	050540	2	
15	Switch, PB Green Flush Illum ZB5	052503	1	
	Switch Body, 22mm Grn LED 1NO 24V XB5	052502	1	
16	Disconnect, 100Amp 3P Non-Fused 6mm	050906-1	1	
	Operator, Red/Yellow Pistol Grip 6mm	050907-1	1	
	Shaft, Pistol Grip Disconnect 290mm x 6mm	050908-1	1	
17	Hour Meter, 12 Volt DC	015401	1	
18	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)	052612	1	
	Switch Head, 22mm Illum Green Selector (LMS Option Only)	052613	1	
	See Electrical Information Section in *Operator's Manual* for a complete list of electrical components			

12.3 Feed Tables (Optional)

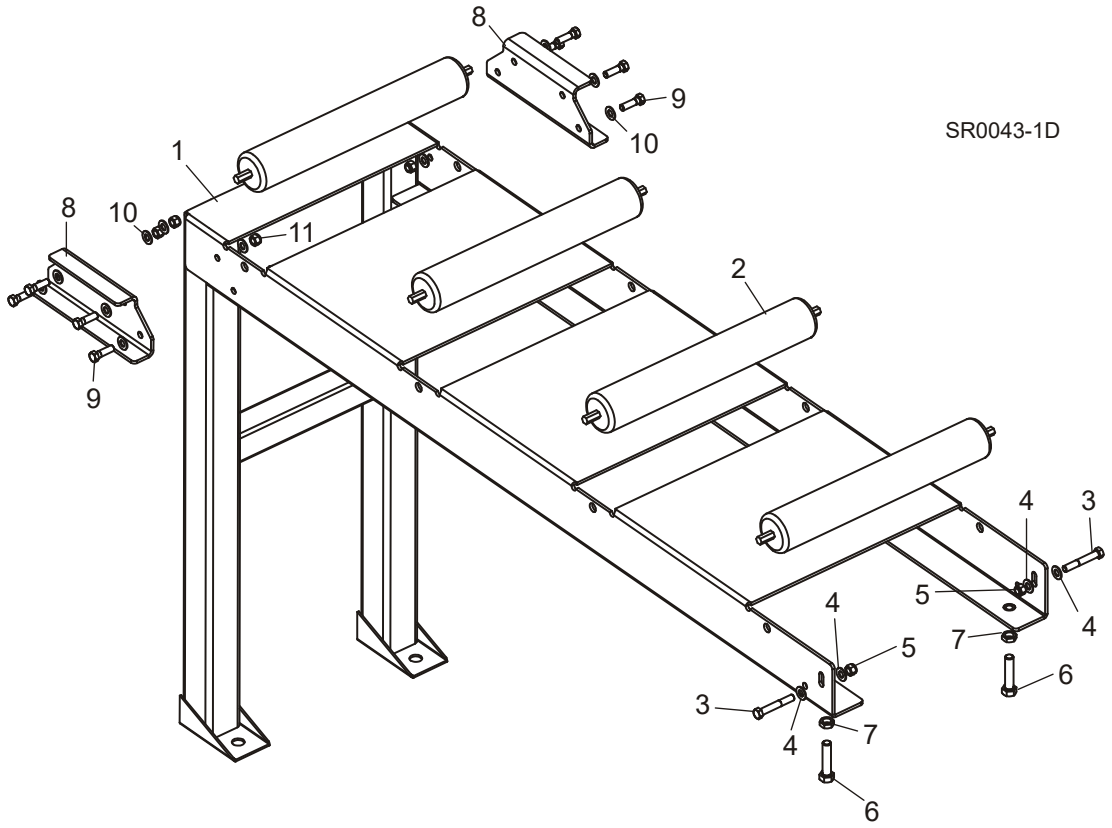


SR0043B

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TABLE ASSEMBLY, OPTIONAL FEED	054464	1	
1	End Table Parts (*See Section 13.1*)			
2	Side Table Parts (*See Section 13.2*)			

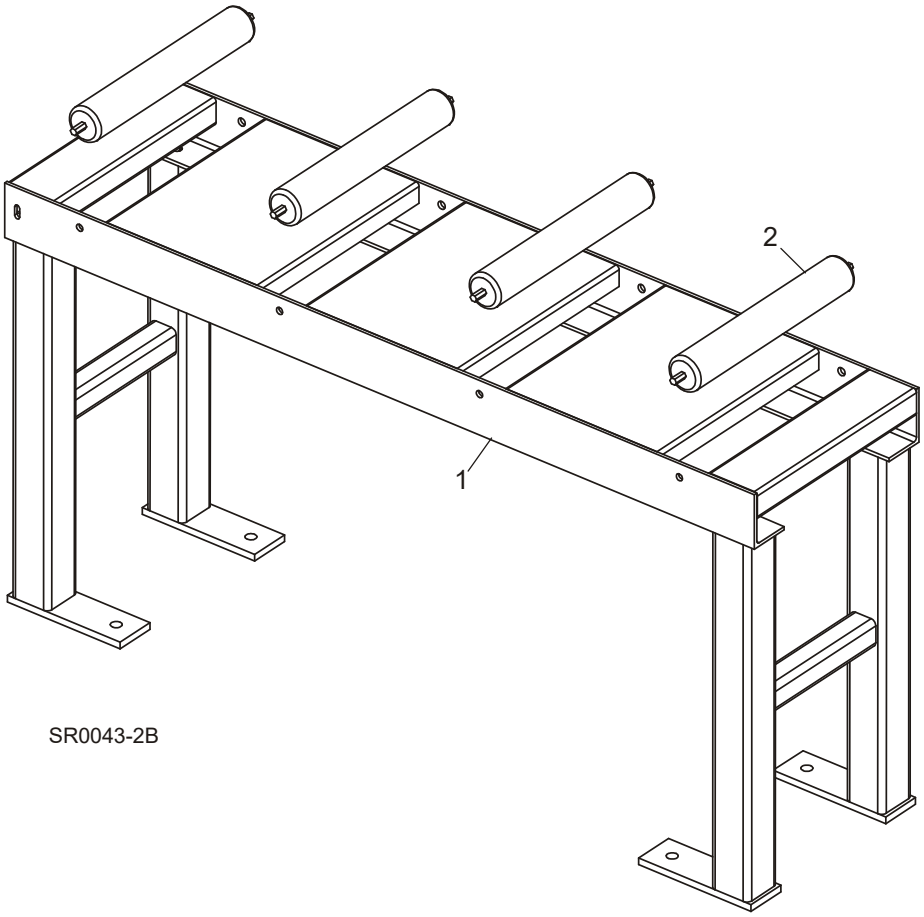
SECTION 13 OPTIONS

13.1 End Table (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TABLE ASSEMBLY, END	054404	2	
1	Table Weldment, End	054405	1	
2	Roller, 2.5" OD x 16"	054412	4	
3	Bolt, 3/8-16 X 2 1/2" Hex Head Grade 2	F05007-47	2	
4	Washer, 3/8" Flat SAE	F05011-3	4	
5	Nut, 3/8-16 Hex Nylon Lock	F05010-10	2	
6	Bolt, 1/2-13 X 2 1/4" Hex Head Full Thread	F05008-27	2	
7	Nut, 1/2-13 Hex Jam	F05010-31	2	
	CONNECTOR KIT, SHR TABLE	003622	1	
8	Plate, SHR Table Connector	003621	2	
9	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5	F05007-123	8	
10	Washer, 3/8" SAE Flat	F05011-3	16	
11	Nut, 3/8-16 Hex Nylon Lock	F05010-10	8	

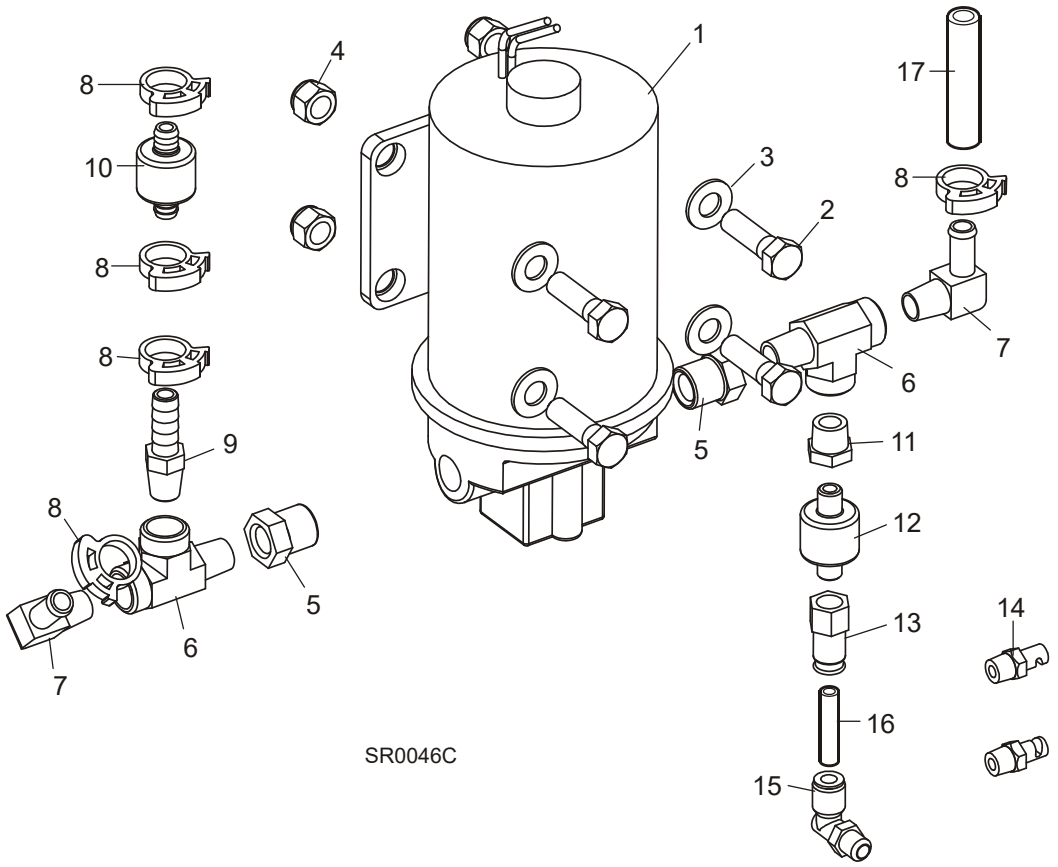
13.2 Side Table (Optional)



SR0043-2B

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TABLE ASSEMBLY, SIDE	054442	1	
1	Table Weldment, Side	054443	1	
2	Roller, 2.5 OD x16	054412	4	

13.3 Lube-Mizer Pump Assembly (Optional)



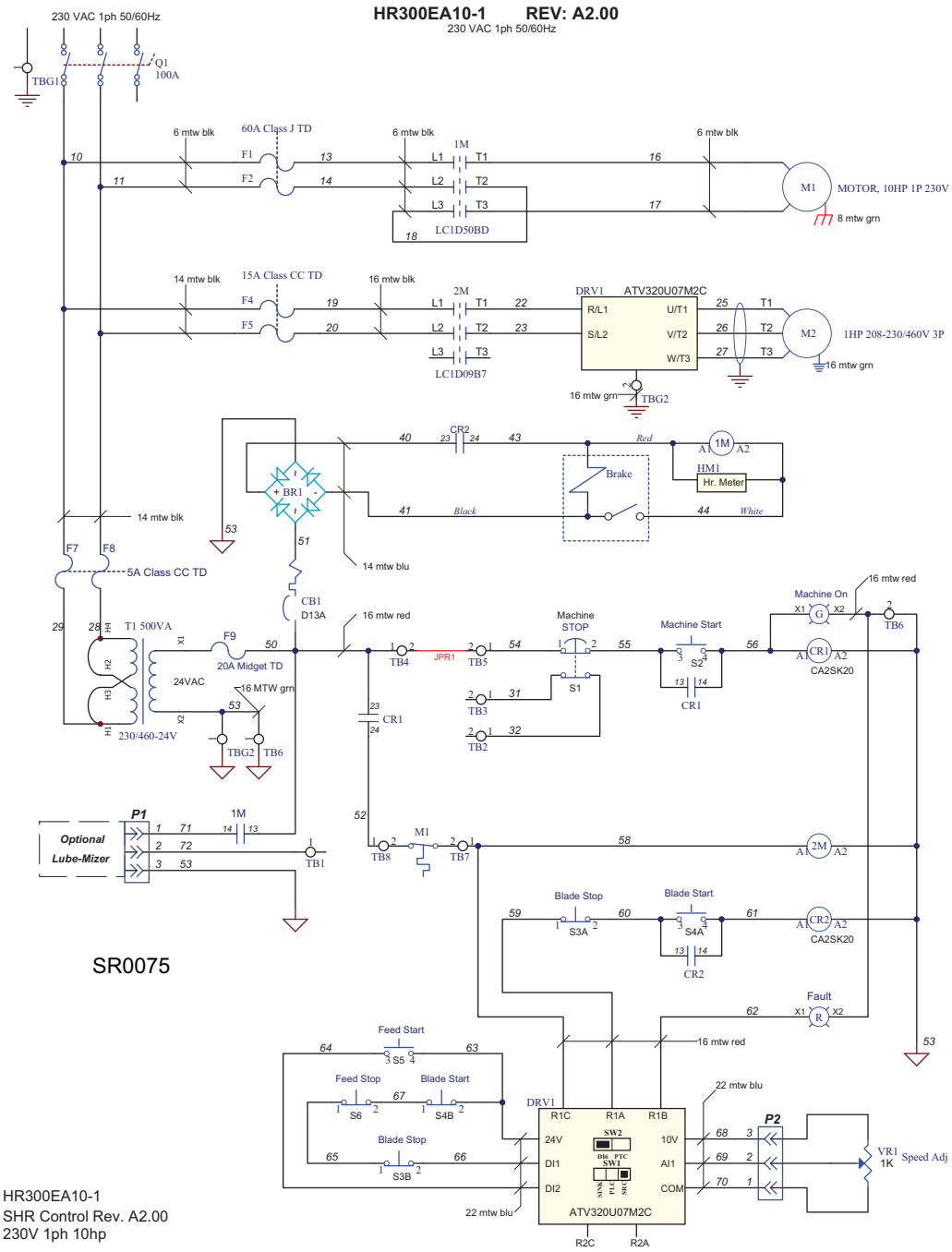
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	LUBE ADDITIVE, CASE 4 60 OZ. BOTTLES	ADD-1	1	
	LUBE-MIZER OPTION, FIELD-INSTALLED SHR	LMS-SHR	1	
	Pump Assembly, SHR LubeMizer	038563	1	
1	Pump Assembly, Lube	050029	1	
2	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5	F05007-123	4	
3	Washer, 3/8" Flat SAE	F05011-3	8	
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	4	
5	Fitting, 3/8" NPT-1/4" NPT Reducer	015490	2	
6	Fitting, 1/4" NPT x 1/4" JIC Male Run Tee	P09141	2	
7	Fitting, 1/4" NPT x 3/8" Hose Barb, Elbow	016330	2	
8	Clamp, Single Snap Grip #38	016845	5	
9	Fitting, 1/4" NPT-3/8" Barb	014685	1	
10	Valve, 3/8" Barb 6PSI Check	033448	1	
11	Reducer, 1/4" NPT - 1/8" NPT	P22680	1	
12	Valve, 1/8" NPT 3PSI Check	033449	1	
13	Fitting, 1/4" TB x 1/8" NPT Male Air	033450	1	

14	Fitting, Blade Lube Spray	033479	2	
15	Fitting, 1/4" MPT x 1/4" Tube Swivel Elbow	P09736	1	
16	Tubing, 1/4" Air	R01869	2 ft.	
17	Tubing, 3/8" ID Flex PVC Braided	R01885-1	2.75 ft.	
	Control Assembly, SHR LubeMizer	052615	1	

SECTION 14 ELECTRICAL INFORMATION

14.1 Electrical Symbol Diagrams

HR300EA10-1



HR300EA10-1
SHR Control Rev. A2.00
230V 1ph 10hp

FIG. 14-1 SYMBOL DIAGRAM (HR300EA10-1)

HR300EB20-1

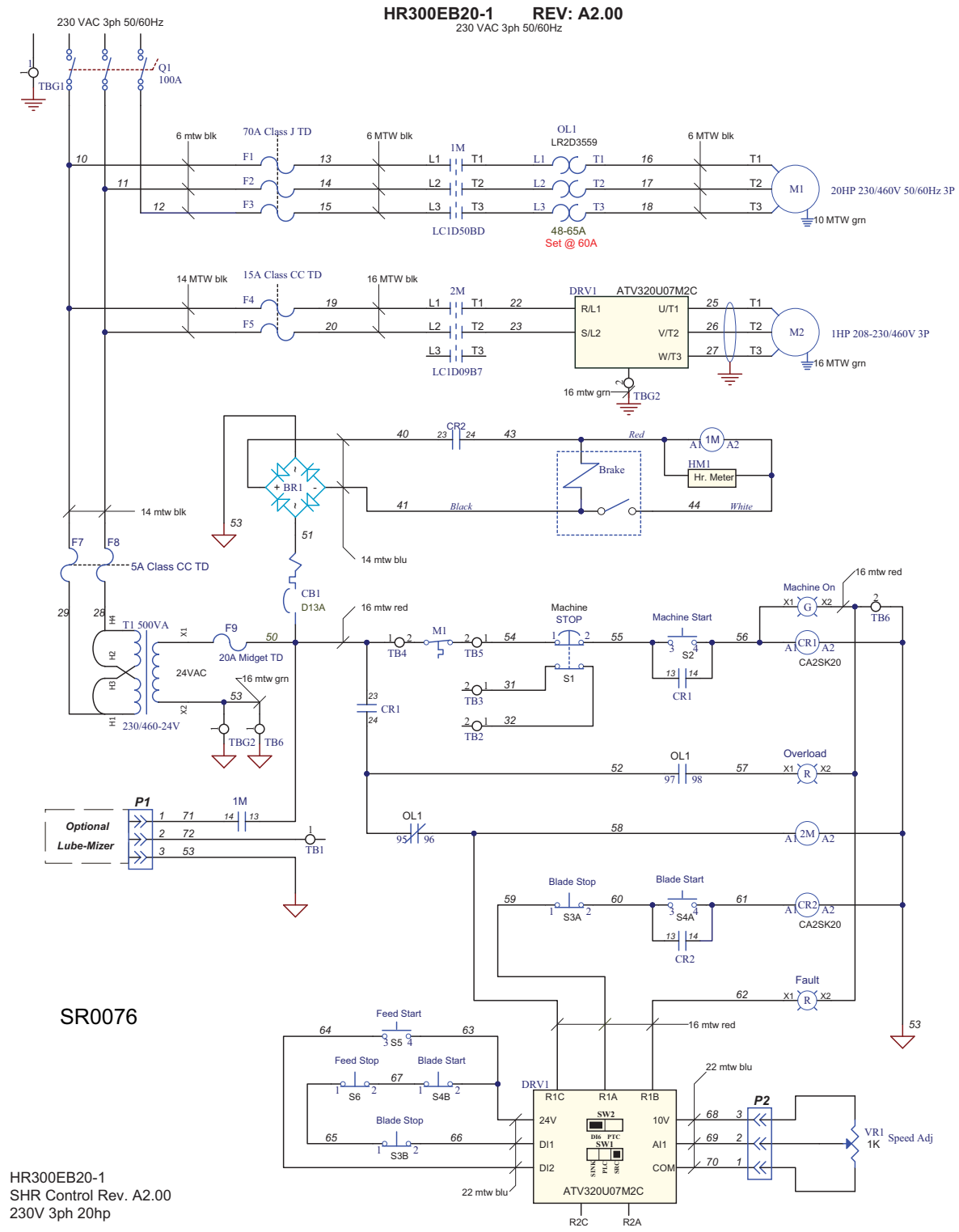


FIG. 14-2 SYMBOL DIAGRAM (HR300EB20-1)

HR300EC20-1

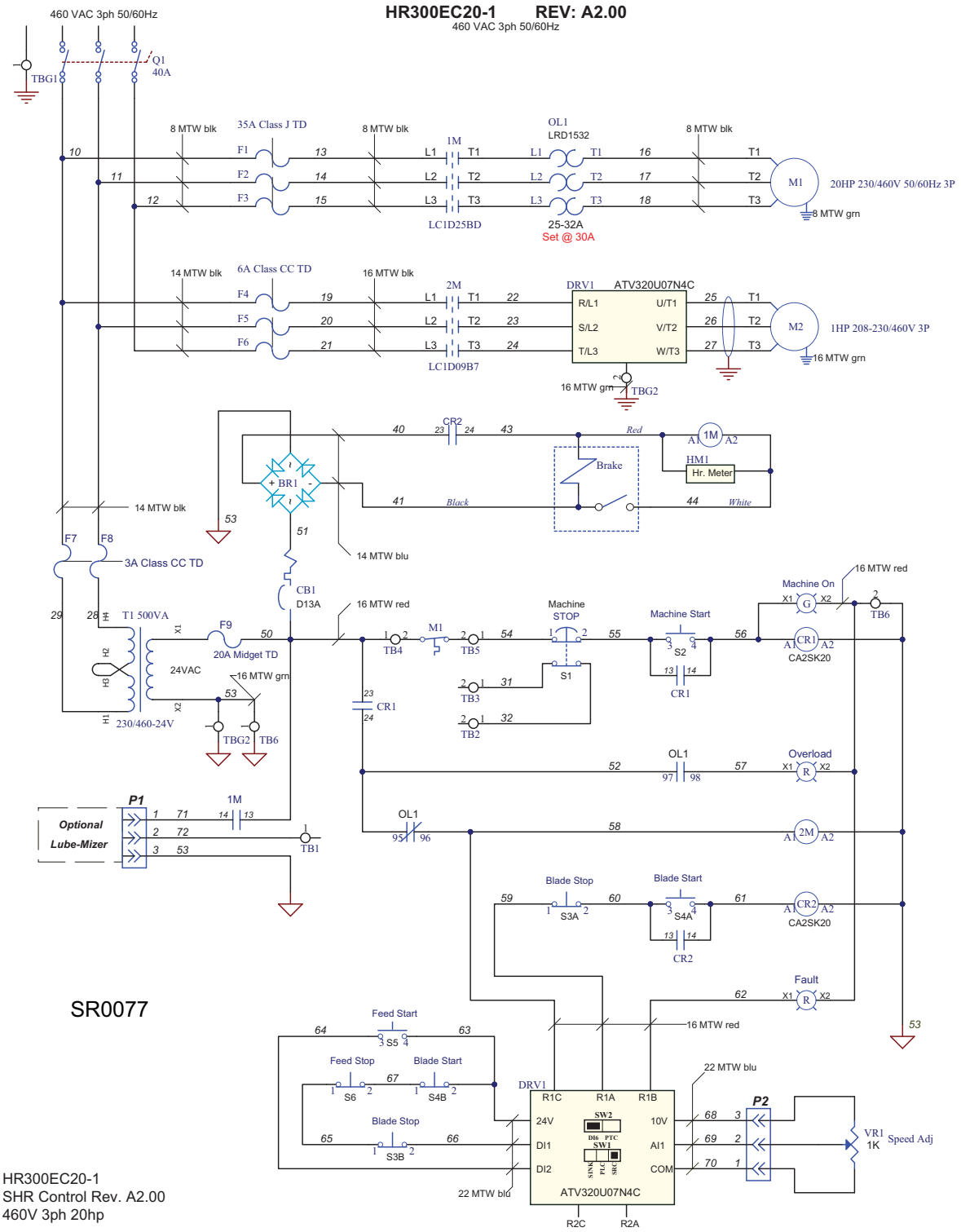


FIG. 14-3 SYMBOL DIAGRAM (HR300EC20-1)

HR300EH20-1

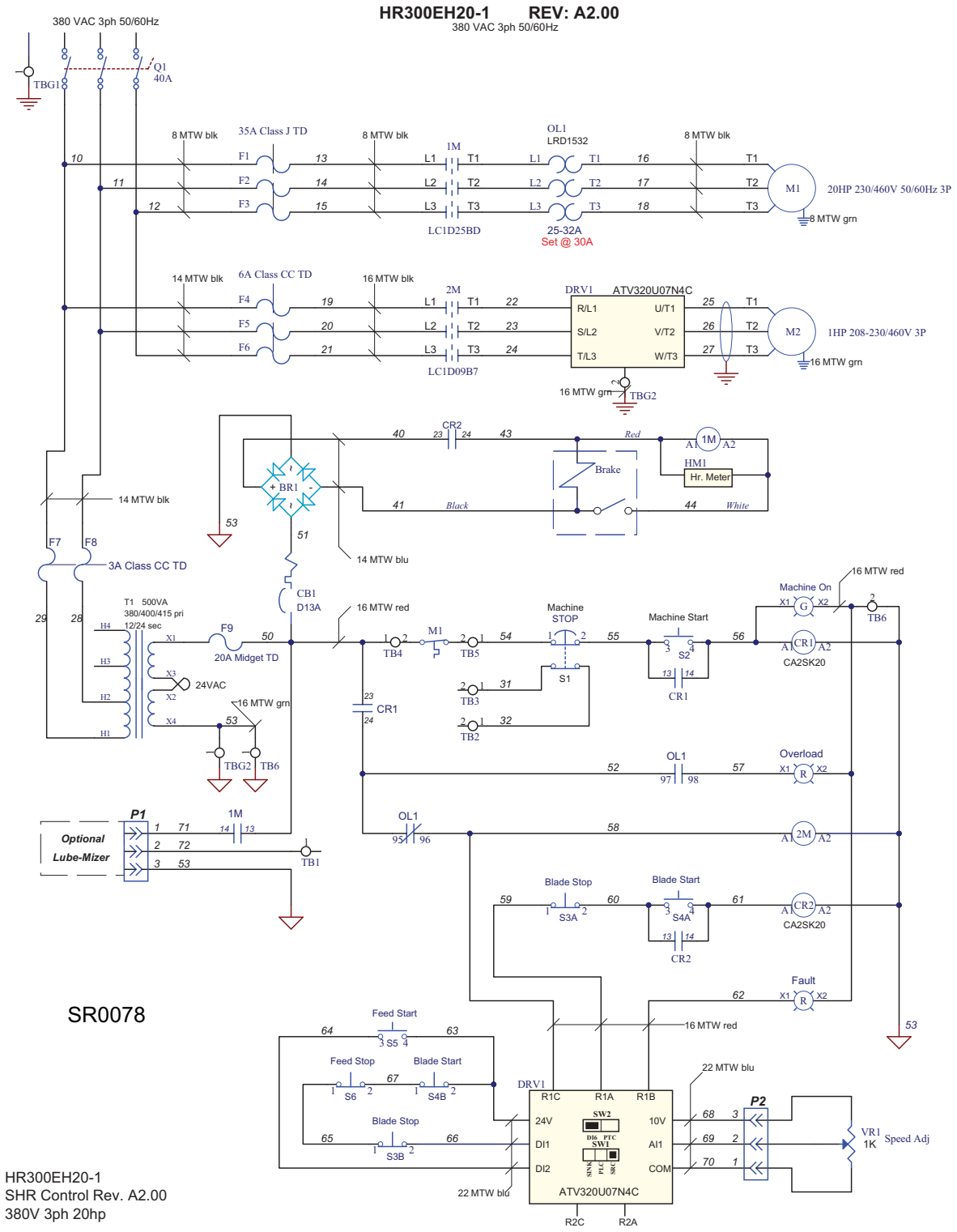


FIG. 14-4 SYMBOL DIAGRAM (HR300EH20-1)

HR300EB25-1

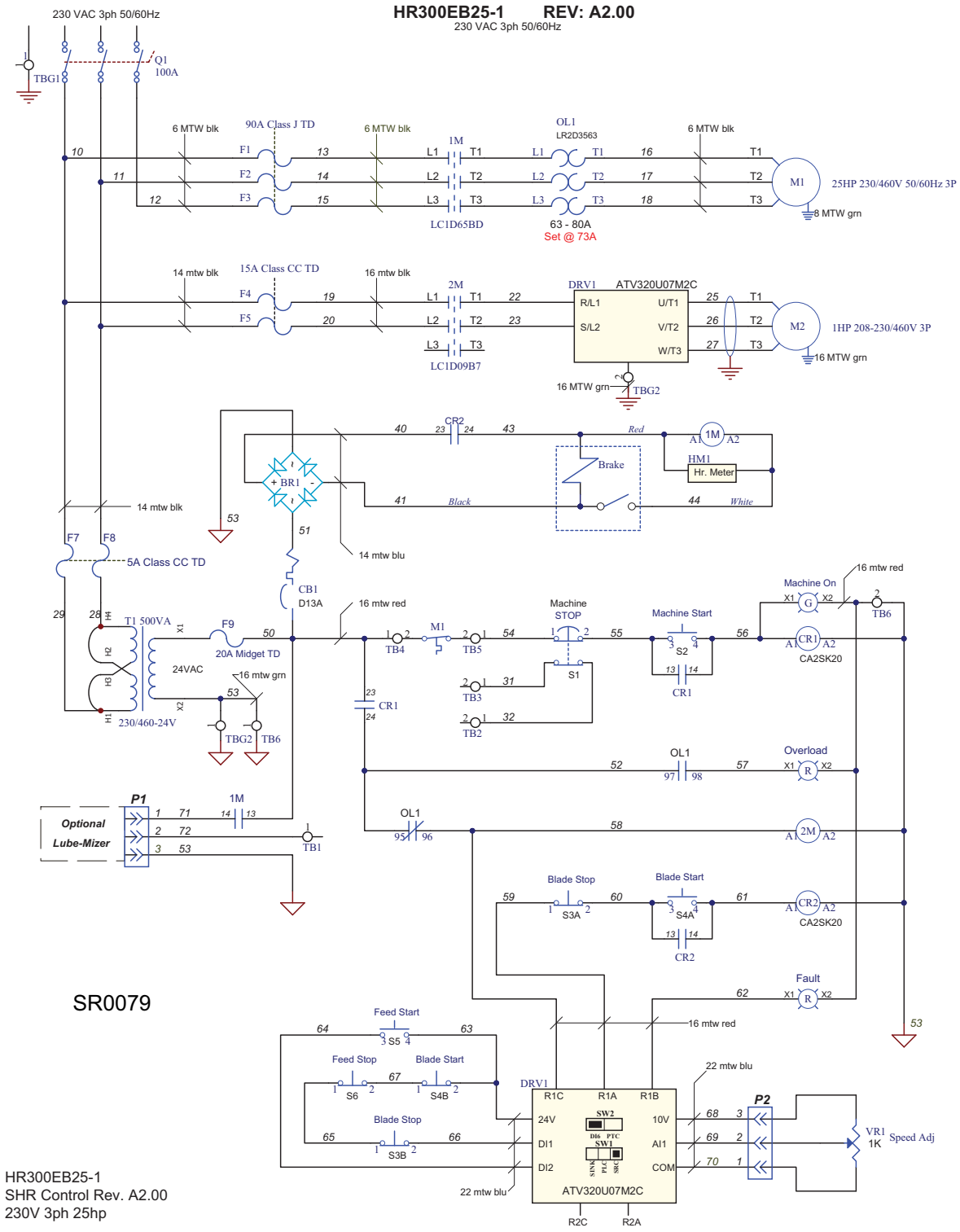
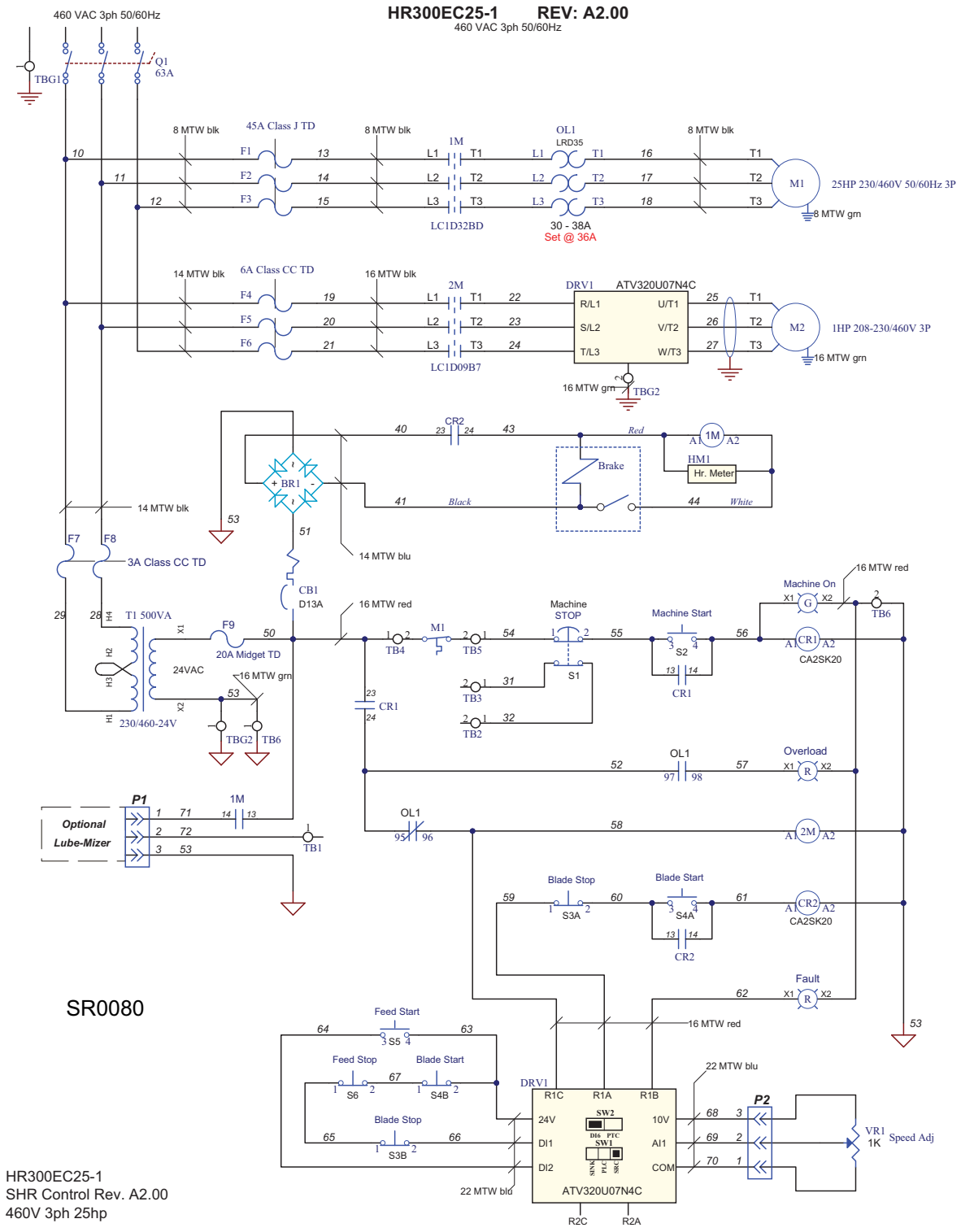


FIG. 14-5 SYMBOL DIAGRAM (HR300EB25-1)

HR300EC25-1



HR300EC25-1
SHR Control Rev. A2.00
460V 3ph 25hp

FIG. 14-6 SYMBOL DIAGRAM (HR300EC25-1)

LMS-SHR Lube-Mizer Option

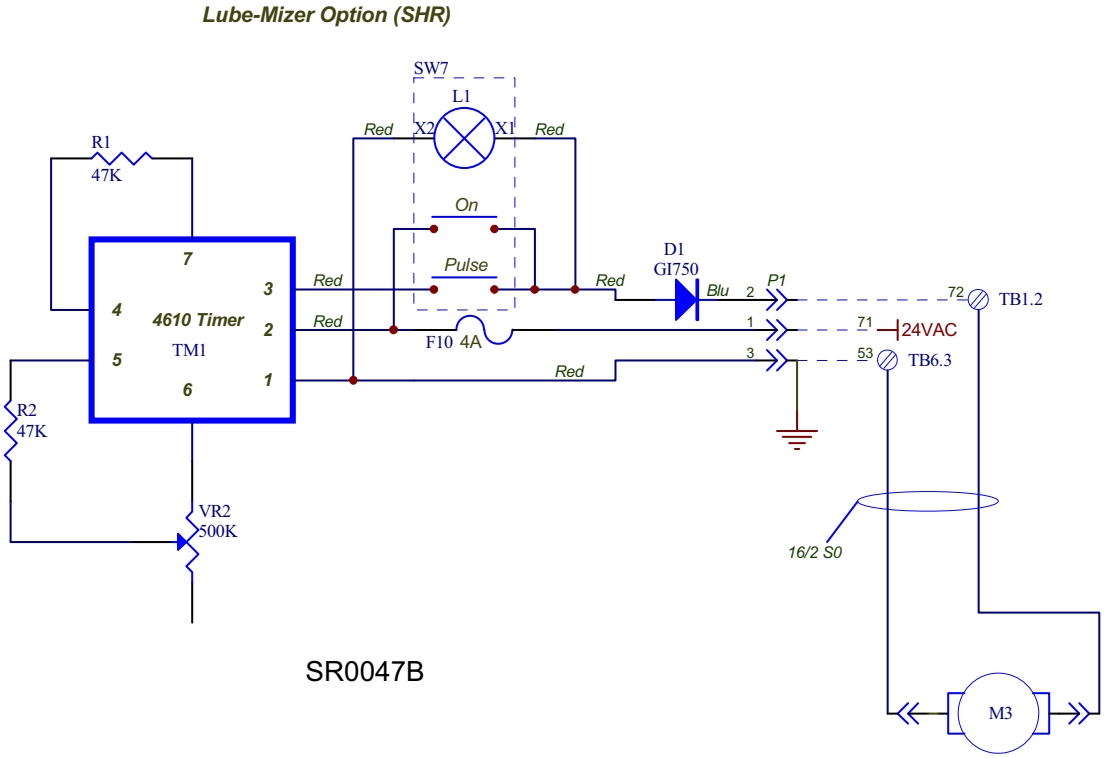


FIG. 14-7 SYMBOL DIAGRAM (LUBE-MIZER)

14.2 Electrical Component List (SHR25-H)

Component	Wood-Mizer Part No.	Description
1M	052465	Contactor, 3 Pole 24VDC 32A
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1-F3	052458	Fuse, 45A Class J Delay
F4-F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052454	Fuse, 3A 600V KLDR Time Delay
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401	Hour Meter, 12 Volt DC
M1	038485	Motor, 25HP 1775RPM
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
OL1	052466	Overload Relay, 30-38A Class 10
Q1	050881-1	Disconnect, 63Amp 600V 3P 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052453	Transformer, 208-480V/24V 500VA
TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A
TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA
TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052459	Terminal Block, 8GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052481	AC Drive Assembly, w/Software
VR1	052451	Potentiometer Assembly, 1K SHR Feed Control
VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

14.3 Electrical Component List (SHR25-L)

Component	Wood-Mizer Part No.	Description
1M	053604	Contactor, 65A 3P 24VDC D-A Series
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1-F3	052515	Fuse, 90A Class J Delay
F4, F5	052513	Fuse, 15A 600V CCMR Time Delay
F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052511	Fuse, 5A 600V KLDR Time Delay (SHR10/SHR20-L/SHR25-L Only)
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401	Hour Meter, 12 Volt DC
M1	038485	Motor, 25HP 1775RPM
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
OL1	069636	Overload Relay, 48-65A
Q1	050906-1	Disconnect, 100Amp 3P Non-Fused 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052453	Transformer, 208-480V/24V 500VA
TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A (LMS Option Only)
TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA
TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052525	Terminal Block, 4GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052518-1	AC Drive Assembly, w/Software (ATV320)
VR1	052451	Potentiometer Assembly, 1K SHR Feed Control

VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

14.4 Electrical Component List (SHR20-H)

Component	Wood-Mizer Part No.	Description
1M	051322	Contactor, 3 Pole 24VDC
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1-F3	052506	Fuse, 35A Class J Delay
F4-F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052454	Fuse, 3A 600V KLDR Time Delay
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401 [1]	Hour Meter, 12 Volt DC
M1	038486	Motor, 20HP 1755RPM
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
OL1	052505	Overload Relay, 25-32A Class 10
Q1	050903-1	Disconnect, 40A 3P Non-Fused 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052453	Transformer, 208-480V/24V 500VA
TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A (LMS Option Only)
TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA
TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052459	Terminal Block, 8GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052481	AC Drive Assembly, w/Software

VR1	052451	Potentiometer Assembly, 1K SHR Feed Control
VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

[1] Was ENM Corp. #T14BH517BC9 (2/09).

14.5 Electrical Component List (SHR20-L)

Component	Wood-Mizer Part No.	Description
1M	053601	Contactor, 50A 3P 24VDC D-A Series
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1, F2	052521	Fuse, 70A Class J Delay
F3	052521	Fuse, 70A Class J Delay
F4, F5	052513	Fuse, 15A 600V CCMR Time Delay
F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052511	Fuse, 5A 600V KLDR Time Delay
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401	Hour Meter, 12 Volt DC
M1	038486	Motor, 20HP 1755RPM
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
OL1	069636	Overload Relay, 48-65A Everlink Thermal
Q1	050906-1	Disconnect, 100Amp 3P Non-Fused 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052453	Transformer, 208-480V/24V 500VA
TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A (LMS Option Only)
TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA

TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052525	Terminal Block, 4GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052518-1	AC Drive Assembly, w/Software (SHR10/SHR20-L/SHR25-L Only) (ATV320)
VR1	052451	Potentiometer Assembly, 1K SHR Feed Control
VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

14.6 Electrical Component List (SHR20-380)

Component	Wood-Mizer Part No.	Description
1M	051322	Contactor, 3 Pole 24VDC
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1-F3	052506	Fuse, 35A Class J Delay
F4-F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052454	Fuse, 3A 600V KLDR Time Delay
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401	Hour Meter, 12 Volt DC
M1	038486	Motor, 20HP 1755RPM
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
OL1	052505	Overload Relay, 25-32A Class 10
Q1	050903-1	Disconnect, 40A 3P Non-Fused 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052773	Transformer, 380/400/415-12/24V 500VA (SHR20-380 Only)
TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A (LMS Option Only)

TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA
TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052459	Terminal Block, 8GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052481	AC Drive Assembly, w/Software
VR1	052451	Potentiometer Assembly, 1K SHR Feed Control
VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

14.7 Electrical Component List (SHR10)

Component	Wood-Mizer Part No.	Description
1M	053601	Contactor, 50A 3P 24VDC D-A Series
2M	025290	Contactor, 24VAC Coil 3 Pole 9A
BR1	E10456	Rectifier, 200 PIV 35A Bridge
CB1	052463	Breaker, 13A 1 Pole Curve D
CR1, CR2	052464	Relay, 2NO 24VAC Control
D1	052616	Diode Assembly, SHR Lube (LMS Option Only)
F1, F2	052733	Fuse, 60A Class J Delay
F4, F5	052513	Fuse, 15A 600V CCMR Time Delay
F6	052456	Fuse, 6A 600V CCMR Time Delay
F7, F8	052511	Fuse, 5A 600V KLDR Time Delay
F9	052455	Fuse, 20A Midget 250VAC Delay
F10	024150-4	Fuse, 4A ATO Blade Pink (LMS Option Only)
HM1	015401	Hour Meter, 12 Volt DC
M1	038487	Motor, 10HP 1725RPM Single Phase
M2	047486	Motor, 1HP AC Feed
M3	050029	Pump Assembly, Lube (LMS Option Only)
Q1	050906-1	Disconnect, 100Amp 3P Non-Fused 6mm
	050907-1	Operator, Red/Yellow Pistol Grip 6mm
	050908-1	Shaft, Pistol Grip Disconnect 290mm x 6mm
R1, R2	024591	Resistor Assembly, 47K Yellow Lube Timer (LMS Option Only)
S1	052497	Switch, E-Stop Complete Push-Pull XB5
	050540	Contact, NC ZBE102
S2	052503	Switch, PB Green Flush Illum ZB5
	052502	Switch Body, 22mm Grn LED 1NO 24V XB5
S3/S4	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
	050540	Contact, NC ZBE102 (Qty. 2)
S5/S6	052499	Switch, 2 PBw/Pilot Green Flush Red Extend
	052498	Switch Body, 22mm Red LED 1NO 1NC 24V XB5
SW7	052612	Switch Body, 22mm Green LED 2NO 24V (LMS Option Only)
	052613	Switch Head, 22mm Illum Green Selector (LMS Option Only)
T1	052453	Transformer, 208-480V/24V 500VA

TM1	052614	Timer Control, Repeat Cycle 24VAC 5 A (LMS Option Only)
TB1-TB5	052461	Terminal Block, 1 Tier Screwless 12GA
TB6	052462	Term Block, 1 Tier/2 Conn Screwless 12GA
TBG1	052525	Terminal Block, 4GA GND Screwless
TBG2	052460	Terminal Block, 12GA GND Screwless
U1	052518-1	AC Drive Assembly, w/Software (ATV320)
VR1	052451	Potentiometer Assembly, 1K SHR Feed Control
VR2	024590	Potentiometer Assembly, Lube-Mizer Control (LMS Option Only)

14.8 Component Layout Diagrams

Control Box (SHR20-H/SHR20-380/SHR25-H)

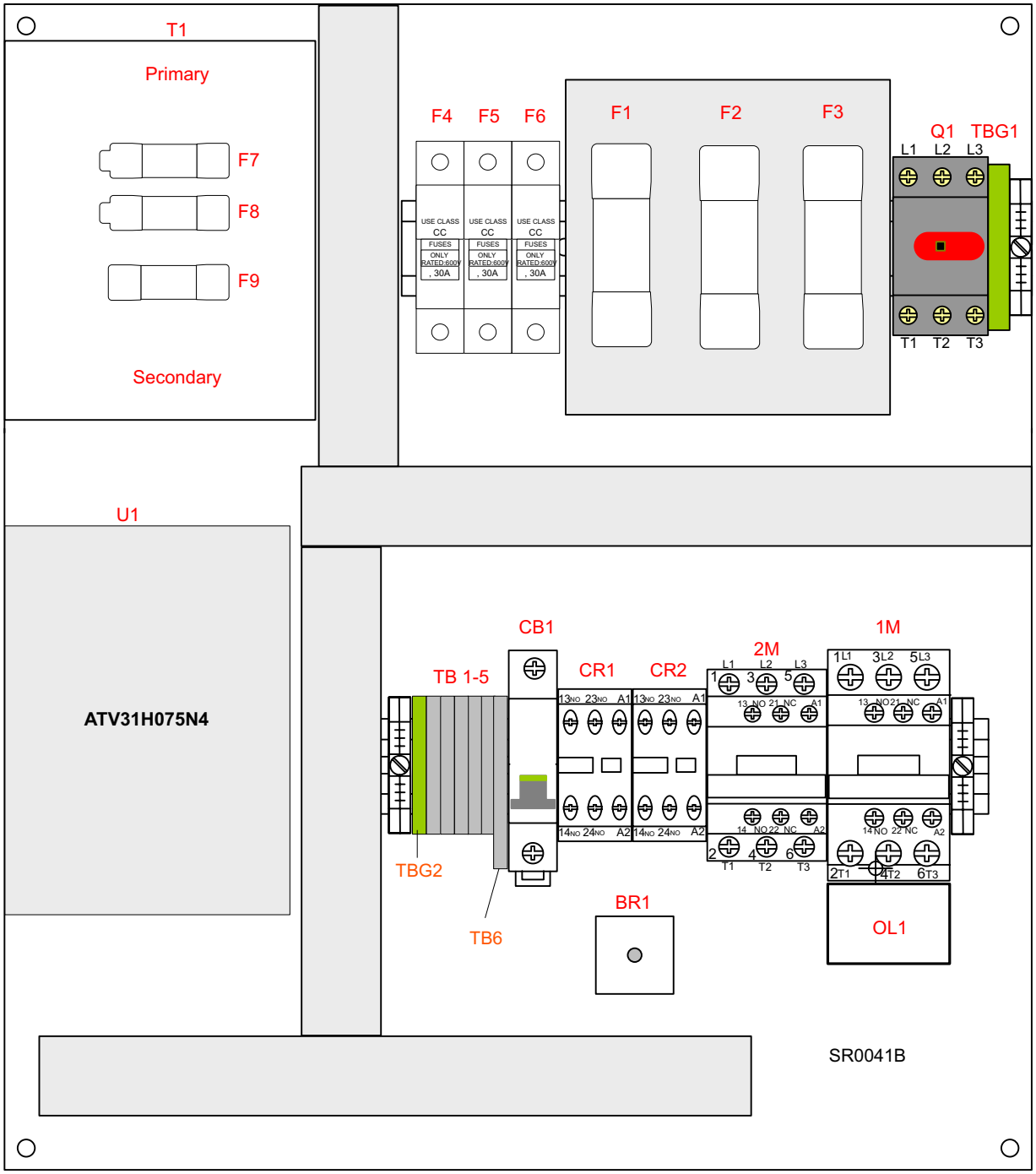


FIG. 14-8

Control Box (SHR20-L/SHR25-L)

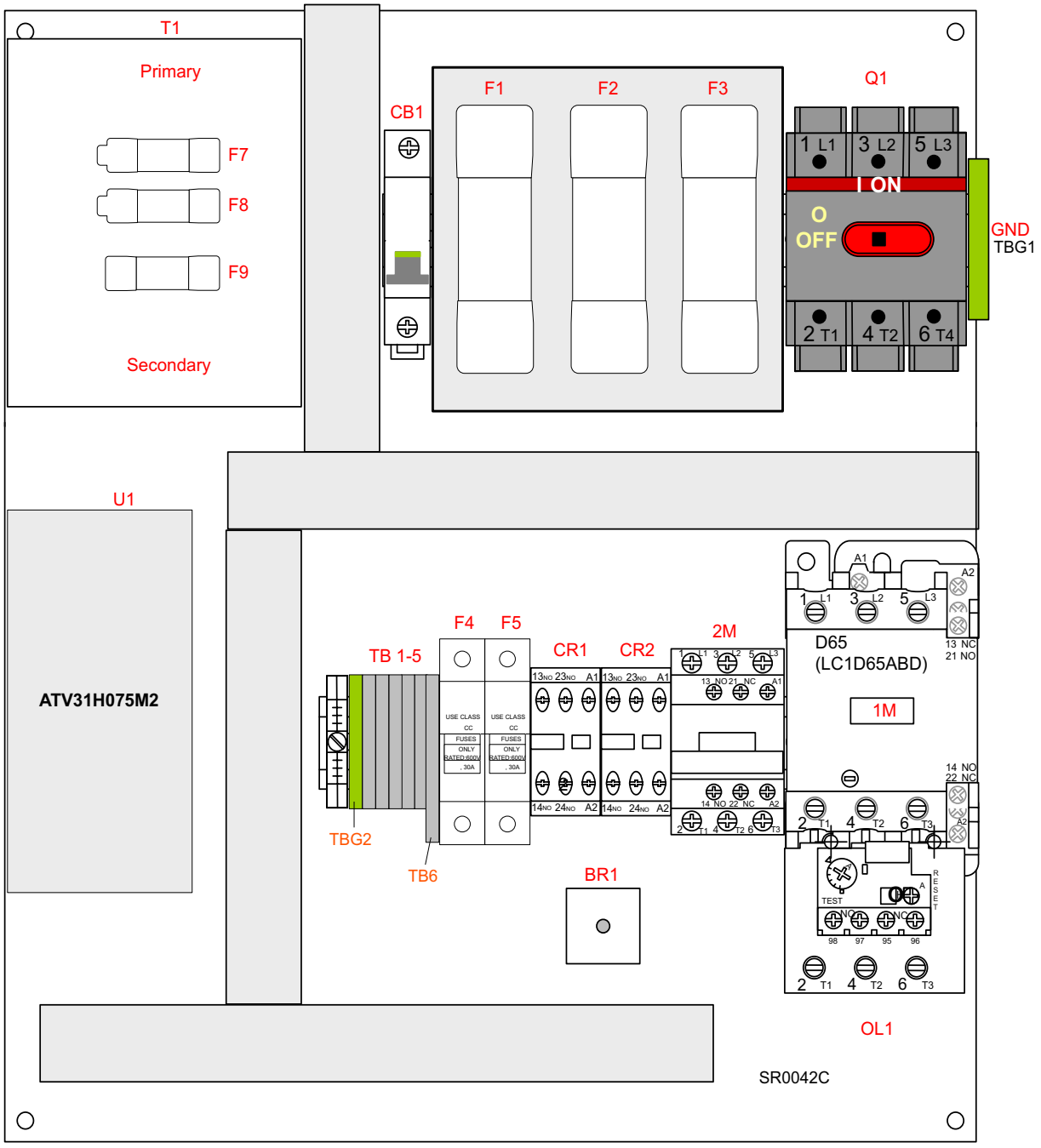


FIG. 14-9

Control Box (SHR10)

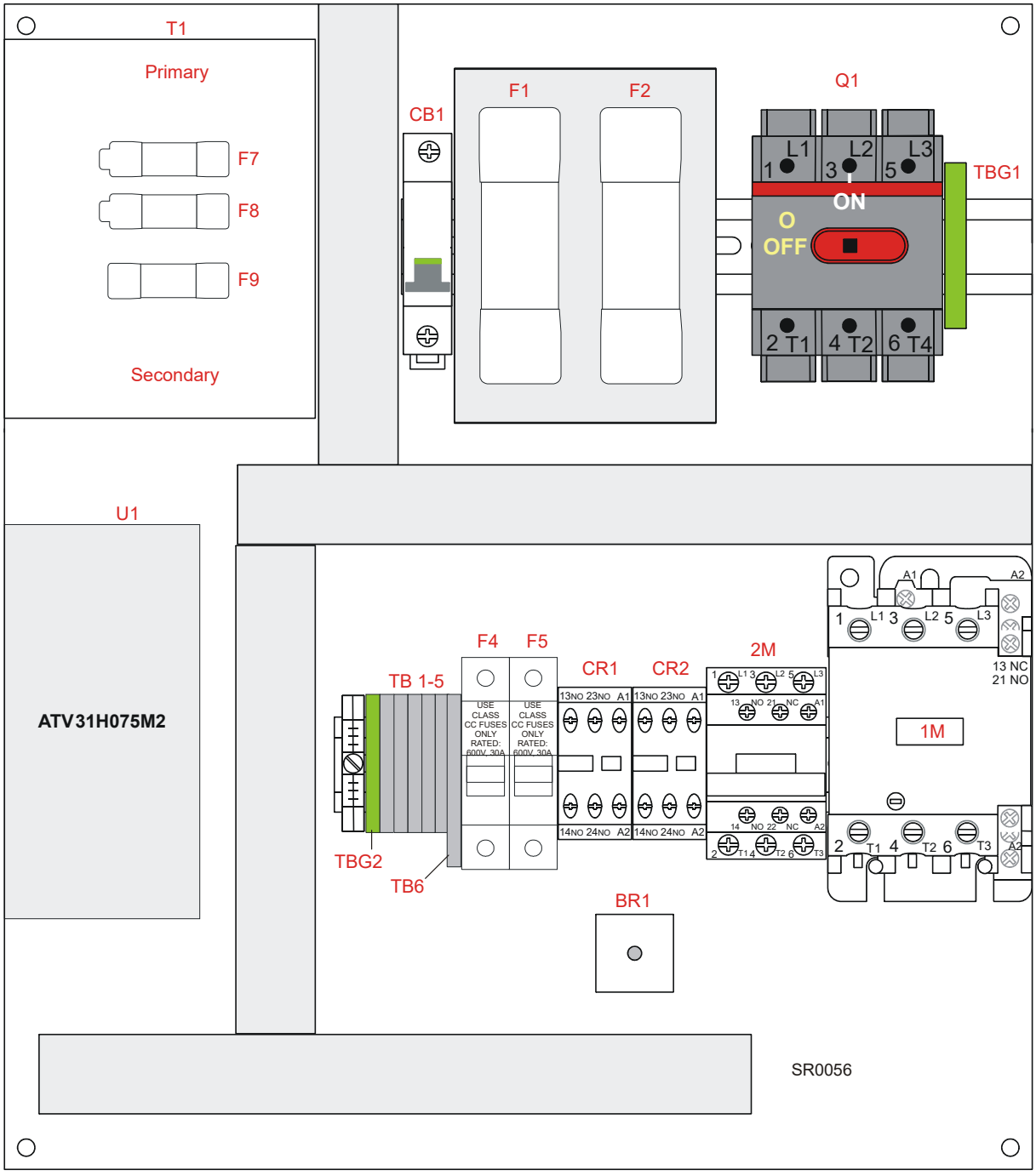


FIG. 14-10

Control Box Door Panel

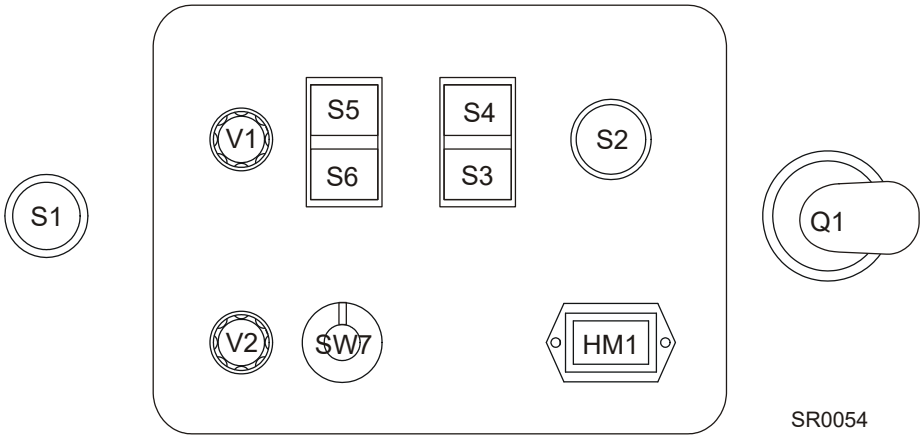


FIG. 14-11

INDEX

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