

**Wood-Mizer® SLPT-016
MR6000
Operator's Manual**

MR6000-SLPT-016

rev. A1.01

Safety is our #1 concern!

Form #2531



WARNING! Read and understand this manual before using this machine.

California

Proposition 65 Warning



WARNING: Breathing gas/diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

Always start and operate the engine in a well-ventilated area.
If in an enclosed area, vent the exhaust to the outside.
Do not modify or tamper with the exhaust system.
Do not idle the engine except as necessary.

For more information go to **www.P65warnings.ca.gov**.



WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection.

For more information go to **www.P65Warnings.ca.gov/wood**.

Active Patents assigned to Wood-Mizer, LLC

Wood-Mizer, LLC has received patents that protect our inventions which are a result of a dedication to research, innovation, development, and design. Learn more at: woodmizer.com/patents

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

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Wood-Mizer® LLC

Limited Product Warranty

Wood-Mizer

Wood-Mizer LLC ("Warrantor"), an Indiana corporation with its principal place of business at 8180 West Tenth Street, Indianapolis, IN 46214-2400 USA, warrants to the purchaser ("Purchaser") that for the time periods specifically stated herein and subject to the terms, conditions and limitations stated herein, the equipment manufactured by the Warrantor will be free from defects in material and workmanship attributable to Warrantor so long as, during the warranty periods stated herein, the equipment is installed, operated and maintained in accordance with the instructions provided by Warrantor.

PRODUCT	MODEL CLASS	LENGTH OF WARRANTY		EFFECTIVE DATE
		USA & CANADA	NON USA & CANADA	
Portable Sawmills, Resaws, Edgers	LT, LX, HR, EG	Two years	One year	Date of purchase
Portable Sawmills with Chassis	LT28, LT35, LT40, LT50, LT70, LX450	Two years, excluding the chassis, which chassis shall have a five year warranty	One year	
Industrial Sawmills, Resaws, Edgers	WM, HR, EG, TVS, SVS	One year	One year	
TITAN Industrial	WB, TV, HR, EG, EA, MR	One year	One year	Date of purchase or date of installation / training (if applicable), whichever occurs first, not to exceed 6 months from date of purchase
Material Handling	TWC, IC, TD, LD, GC, CR, CB, CC	One year	One year	
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	
Options and Accessories	Various	One year*	One year*	
Moulders, Extractors	MP, MD	Two years	One year	
Kilns	KS, KD	One year	One year	
Slab Flatteners	MB	Two years	One year	
Pallet Equipment	PD, PC	One year	One year	
Log Splitters	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

* Warranty on Options will match the warranty on the primary equipment when purchased on same invoice.

Exclusions from 90 Day, Limited One Year and Two Year Warranty

Warrantor shall have **no** responsibility under this warranty for any wear components, including, but not limited to: belts, blade guides, blades, electric motor brushes, drum switches, filters, fuses, hoses, bearings (excluding cylindrical drive bearings), bushings, cable carriers, and spark plugs. All wear components are furnished **"as is"**, without any warranty from Warrantor. This limited warranty does not cover any defects caused by misuse, negligence, alterations, damage due to overload, abnormal conditions, excessive operation, accident, or lack of performance of normal maintenance services.

Several components which are used in the manufacture of the equipment but not manufactured by Warrantor such as cant hooks, power plants, laser sights, batteries, tires, and trailer axles have warranties provided by the original equipment manufacturer (written copies available upon request). Warrantor does not separately warrant such items. Components or equipment manufactured by third parties are not covered by this warranty. Warrantor, however, will provide reasonable assistance to the Purchaser to make claims against any warranties applicable to such component parts as provided by such original equipment manufacturers. Components or equipment manufactured by third parties are not covered by this Warranty.

Five Year Limited Chassis Warranty

The limited five year chassis warranty described above, DOES NOT extend to (a) any damage stemming from accident, improper towing, overload, abuse, misuse, abnormal conditions, negligence, excessive operation, or lack of maintenance, (b) rust caused by exposure to corrosive atmospheric conditions, or (c) the sawmill head, carriage, axle, brakes, or any hydraulic or electrical components attached to the chassis.

Warrantor's Obligations as To Defects

In the event that the equipment fails to perform due to defective materials or workmanship attributable to Warrantor under normal use and service within the established warranty period, Purchaser's sole and exclusive remedy and Warrantor's sole liability shall be to replace or repair, in Warrantor's sole and subjective discretion, any defective part at Warrantor's principal place of business without cost to the Purchaser if such defect exists. The determination of whether a product is defective shall be made by Warrantor in Warrantor's sole and subjective discretion. The Purchaser must notify Warrantor prior to shipping any defective part. Warrantor, at its sole discretion, may cover expenses incurred in shipping the defective part to Warrantor for evaluation; provided, however, that Warrantor will not be responsible for labor, travel time, mileage, removal, installation or incidental or consequential damages. However, any part in excess of 140 pounds must be returned by the Purchaser, to the Warrantor's nearest authorized facility at the Purchaser's expense, if return is requested by Warrantor. Warrantor shall have a reasonable time within which to replace or repair the defective part. If Warrantor determines that the product is not defective under the terms of this warranty in Warrantor's sole and subjective discretion, then Purchaser shall be responsible for any expenses incurred by Warrantor in returning the equipment to the Purchaser.

Limitations and Disclaimers of Other Warranties

EXCEPT FOR THE EXPRESS WARRANTY PROVISIONS STATED ABOVE, WARRANTOR DISCLAIMS ALL WARRANTIES, EXPRESS AND/OR IMPLIED, INCLUDING WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT AND TITLE. No representation or other affirmation of fact by representatives of Warrantor, whether verbal or in writing, including photographs, brochures, samples, models, or other sales aids, shall constitute a warranty or other basis for any legal action against Warrantor. There are no other representations, promises, agreements, covenants, warranties, guarantees, stipulations or conditions, express or implied, by Warrantor except as expressly set forth herein. THE ORIGINAL PURCHASER AND ANY INTENDED USER OR BENEFICIARY OF THIS EQUIPMENT, SHALL NOT BE ENTITLED TO RECOVER ANY INDIRECT, SPECIAL, PUNITIVE, EXEMPLARY, CONSEQUENTIAL, SPECIAL, OR INCIDENTAL DAMAGES OR LOSSES, INCLUDING BUT NOT LIMITED TO, DAMAGES OF LOST PRODUCTION, LOST REVENUE, LOST PRODUCT, LOST PROFITS, LOST BUSINESS, LOSS OF USE, LOSS OF GOODWILL, OR BUSINESS INTERRUPTION, FROM WARRANTOR FOR ANY REASON WHATSOEVER INCLUDING WITHOUT LIMITATION WARRANTY OR DEFECT IN THE PRODUCT REGARDLESS OF THE SOLE, JOINT AND/OR CONCURRENT NEGLIGENCE, BREACH OF CONTRACT, BREACH OF WARRANTY, STRICT LIABILITY IN TORT OR STATUTORY CLAIMS OR OTHER LEGAL FAULT OR RESPONSIBILITY OF EITHER WARRANTOR OR PURCHASER OR ITS EMPLOYEES OR AGENTS. Warrantor does not warrant that its equipment meets or complies with the requirements of any particular safety code or governmental requirements.

Defective items replaced under the terms of this warranty become the property of Warrantor.

Design Changes

Warrantor reserves the right to change the design of its products from time to time without notice and without obligation to make corresponding changes in or to its products previously manufactured.

Rights of Purchasers

The validity and effect of this limited warranty as well as its interpretation, operation and effect, shall be determined exclusively by the principles of law and equity of the State of Indiana, USA. This limited warranty gives Purchaser specific legal rights. Purchaser may also have other rights, which may vary from state to state. Some states may not allow limitations as to the duration of implied warranties or to the exclusion or limitation of incidental or consequential damages, so some of the limitations and exclusions detailed set forth above may not apply. In the event that any one or more of the provisions of this warranty shall be or become invalid, illegal or unenforceable in any respect, the validity, legality and enforceability of the remaining provisions of this warranty shall not be affected thereby.

Interpretations

This Warranty constitutes the entire warranty agreement between Warrantor and Purchaser and supersedes any prior understandings or agreements pertaining to the same subject matter. This warranty cannot be amended except in writing which refers to this warranty which is signed by both Warrantor and Purchaser.

SECTION 1 INTRODUCTION

1.1 About This Manual

This manual replaces any previous information received on your Wood-Mizer® equipment.

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

1.2 Getting Service

For contact information, sales, service, parts, and additional manuals, sign into your account on <https://wood-mizer.com>, or call inside the USA: 1-800-553-0182 or from outside the USA: 317-271-1542

1.3 Specifications

Equipment specification are included in the Online Manuals, which are found at <https://apps.woodmizer.com/Manuals/Manuals.aspx?parent=0>.

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 serious injury or death.

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

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

NOTICE indicates vital information. Safety Instructions

2.2 Owner/operator'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 LLC 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 equipment.

OBSERVE ALL SAFETY INSTRUCTIONS

NOTICE Read the entire Operator's Manual before operating this equipment.

Note all safety warnings throughout this manual and those posted on the machine.

Be able to access this manual at all times while operating this equipment.

Read additional manufacturer's manuals and observe their applicable safety instructions.

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

This equipment is not intended for use by or around children.

It is the owner/operator's responsibility to comply with all applicable federal, state, and local laws, rules, and regulations regarding the ownership, operation, and transporting your equipment.



Operators should become thoroughly familiar with and comply with these applicable laws for operating and transporting equipment.

 **WARNING!** Clean sawdust from all guards, vents, control boxes, or any area where sawdust may gather **after every 8-hour shift**. Failure to do so may result in fire, causing death or serious injury.



WEAR SAFETY CLOTHING (PERSONAL PROTECTION EQUIPMENT)

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



Secure all loose clothing, hair, and jewelry before operating the equipment.

Wear gloves only when handling/changing saw blades or material, not near rotating blades.

NOTICE Some woods require respiration protection when operating the equipment. **It is the operator's responsibility to know which woods require respiration protection.**

KEEP SAFETY LABELS IN GOOD CONDITION

NOTICE Ensure 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.

NOTICE If replacing a component that has a safety decal affixed to it, ensure the new component also has the safety decal affixed in the same place.

KEEP AREA CLEAN

WARNING! Maintain a clean and clear path for all necessary movement around the system and material stacking areas.

Do not allow children in the area. Failure to follow this may result in death or serious injury.

CHECK EQUIPMENT BEFORE OPERATION



DANGER! Ensure all guards and covers are in place and secured before operating equipment.

NOTICE Review all safety settings/equipment at the beginning of each shift, after maintenance/repair, or after a prolonged shutdown.

KEEP PERSONS AWAY



DANGER! Keep all persons out of the path of moving equipment and logs when operating.

Kickback danger! Ensure all persons are out of the path of the blades before starting or operating motor.

KEEP HANDS AWAY



DANGER! All electrical installation, service, and/or maintenance work must be performed by a qualified electrician and is in accordance with applicable electrical codes.

Shut off the all motors and **lock out the system** before clearing debris, changing blades, or any other maintenance activity.



WARNING! Avoid contact with any hot parts (motors).

Allow the system to cool sufficiently before beginning any service function, including debris removal.

Avoid contact with sharp edges of the cutting blades.

Wear protective gloves when handling blades.

Stay a safe distance from rotating members (shafts, pulleys, fans, etc.) and ensure loose clothing or long hair does not engage rotating members

Do not adjust the engine drive belt with the engine running.

2.3 Electrical Lockout Procedures

RULES FOR USING LOCKOUT PROCEDURE

The equipment 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.

LOCKOUT PROCEDURES MUST BE USED DURING, BUT NOT LIMITED TO:

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

MAINTENANCE HAZARDS INCLUDE, BUT NOT LIMITED TO:

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

FAILURE TO LOCKOUT MAY RESULT IN, BUT NOT LIMITED TO:

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

TO CONTROL MAINTENANCE DANGERS:

- Lockout procedures must be followed (see **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), alter-

native effective protective techniques shall be employed which may require special skills and planning.

- Always follow safe operations practices in the workplace.

EQUIPMENT LOCKOUT PROCEDURE

Lockout procedures per OSHA regulation 1910.147, appendix A:

GENERAL

The following simple lockout procedure is provided to assist owner/operators in developing their procedures so they meet the requirements of **OSHA regulation 1910.147**. When the energy isolating devices are not lockable, tagout may be used, provided the owner/operator complies with the provisions of the standard which require additional training and more rigorous periodic inspections. When tagout is used and the energy isolating devices are lockable, the owner/operator must provide full operator protection (see OSHA regulation 1910.147, paragraph (c)(3)) and additional training and more rigorous periodic inspections are required. For more complex systems, more comprehensive procedures may need to be developed, documented, and utilized.

PURPOSE

This procedure establishes the minimum requirements for the lockout of energy isolating devices whenever maintenance or servicing is done on machines or equipment. It shall be used to ensure that the machine or equipment is stopped, isolated from all potentially hazardous energy sources and locked out before personnel perform any servicing or maintenance where the unexpected energization or start-up of the machine or equipment or release of stored energy could cause injury.

COMPLIANCE WITH THIS PROGRAM

All personnel are required to comply with the restrictions and limitations imposed upon them during the use of lockout. The authorized personnel are required to perform the lockout in accordance with this procedure. All operators, upon observing a machine or piece of equipment which is locked out to perform servicing or maintenance shall not attempt to start, energize, or use that machine or equipment.

SEQUENCE OF LOCKOUT

1. Notify all affected personnel that servicing or maintenance is required on a machine or equipment and that the machine or equipment must be shut down and locked out to perform the servicing or maintenance.
2. The authorized employee shall refer to the company procedure to identify the type and magnitude of the energy that the machine or equipment utilizes, shall understand the hazards of the energy, and shall know the methods to control the energy.

3. If the machine or equipment is operating, shut it down by the normal stopping procedure (depress the stop button, open switch, close valve, etc.).
4. De-activate the energy isolating device(s) so that the machine or equipment is isolated from the energy source(s).
5. Lock out the energy isolating device(s) with assigned individual lock(s).
6. Stored or residual energy (such as that in capacitors, springs, elevated machine members, rotating flywheels, hydraulic systems, and air, gas, steam, or water pressure, etc.) must be dissipated or restrained by methods such as grounding, repositioning, blocking, bleeding down, etc.
7. Ensure that the equipment is disconnected from the energy source(s) by first checking that no personnel are exposed, then verify the isolation of the equipment by operating the push button or other normal operating control(s) or by testing to make certain the equipment will not operate.



CAUTION! Return operating control(s) to neutral or "off" position after verifying the isolation of the equipment.

8. The machine or equipment is now locked out.

RESTORING EQUIPMENT TO SERVICE

When the servicing or maintenance is completed and the machine or equipment is ready to return to normal operating condition, the following steps shall be taken.

1. Check the machine or equipment and the immediate area around the machine to ensure that nonessential items have been removed and that the machine or equipment components are operationally intact.
2. Check the work area to ensure that all personnel have been safely positioned or removed from the area.
3. Verify that the controls are in neutral.
4. Remove the lockout devices and re-energize the machine or equipment.

NOTE: The removal of some forms of blocking may require re-energization of the machine before safe removal.

5. Notify affected personnel that the servicing or maintenance is completed and the machine or equipment is ready for use.

PROCEDURE INVOLVING MORE THAN ONE PERSON

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

2.4 Safety Labels Description

See table below for safety labels description.

TABLE 2-1

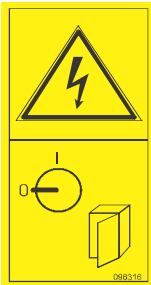
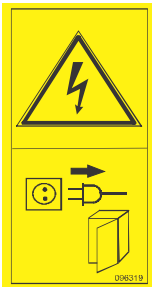
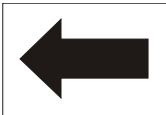
Label View	Description
	096317 CAUTION! Read and understand operator's manual before handling the machine.
	099220 Close guards prior to operating the machine
	096316 Electric box opening is possible with the switch in "0" position only.
	096319 Always disconnect the power cord before opening the electric box.

TABLE 2-1

	524993 Hand injury hazard
	S20097-US Motor rotate direction

SECTION 3 MR6000 MAINTENANCE

3.1 General instructions



WARNING! Lock out power supply before performing any maintenance. See Electrical Lockout Procedures (OSHA regulation 1910.147, appendix A, reprinted in [Section 2.3 Electrical Lockout Procedures](#)).

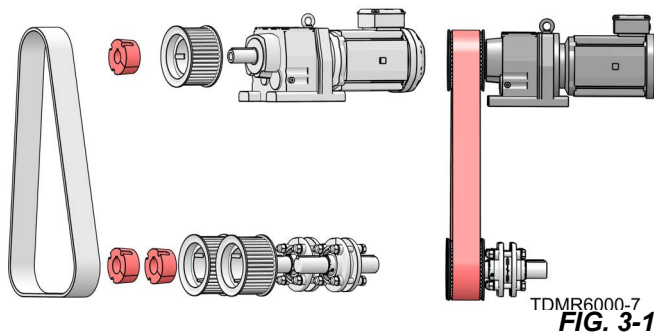
Ensure all electrical installation, service, and/or maintenance is performed by a qualified electrician.

The accumulator tank should be purged at the start of every shift. This can be done by drain valve (112762) in air tank assembly.

3.2 Pulley Alignment

NOTICE All belts and pulleys must be carefully aligned to avoid premature belt wear and equipment damage.

The pulleys are mounted with tapered bushings.



1. Loosen the tapered bushings of all pulleys enough to position the pulleys **all in same plane**.
2. Use a straight edge to ensure all pulleys are aligned.
3. Tension the belts according to the instructions below.

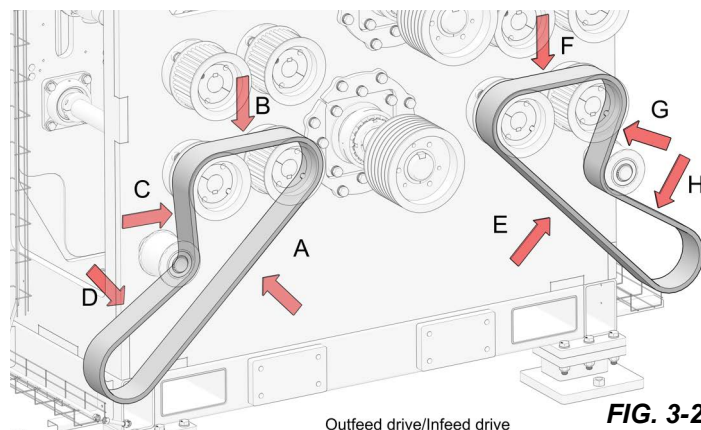
3.3 Belt Tension Values

GENERAL RULES OF TENSIONING:

- Ideal tension is the lowest tension at which the belt will not slip under peak load conditions.
- Check the belt tension frequently during the first 24 to 48 hours of operation.
- Over tensioning will shorten the life of the belt and the bearings.
- Keep belts free from foreign material which may cause slip.
- Make belt drive inspections periodically and re-tension as required. This will prevent slippage and optimize belt life.

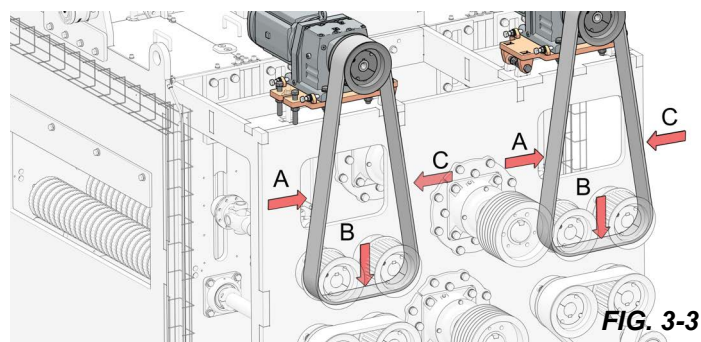
Infeed/Outfeed Belt Tension		see Fig. 3-2
	NEW	USED
Belt Tension A, B, C, D, E, F, G, H	931.2 [lbs] 4142 [N]	809.8 [lbs] 3602 [N]
Frequency [Hz]		
A [recommended]	52.93	49.35
B, F	151.76	141.51
C	245.20	228.65
D	120.37	112.24
E [recommended]	53.75	50.13
G	257.03	239.69
H	120.10	111.99

*"NEW" values are for the initial stages.
"USED" are for further stages as the belt becomes looser.*



Pressroll Drive Belt Tension		see Fig. 3-3
	NEW	USED
Belt Tension A, B, C	931.2 [lbs] 4142 [N]	809.8 [lbs] 3602 [N]
Frequency [Hz]		
A, C [recommended]	53.30	49.70
B	151.78	141.54

*"NEW" values are for the initial stages.
"USED" are for further stages as the belt becomes looser.*



Set the tension by tightening/loosening the belt.
Tensions are as follows:

	NEW	USED
Belt Tension	931.2 [lbs] 4142 [N]	809.8 [lbs] 3602 [N]
InFeed Rolls Deflection Values - D see Fig. 3-4		
	NEW	USED
Deflection Force	58.2 [lbs] 258.9 [N]	50.06 [lbs] 225.1 [N]
Deflection Amount	0.41 [in] 10.4 [mm]	
OutFeed Rolls Deflection Values - E see Fig. 3-4		
	NEW	USED
Deflection Force	58.2 [lbs] 258.9 [N]	50.6 [lbs] 225.1 [N]
Deflection Amount	0.40 [in] 10.2 [mm]	
Press Rolls Deflection Values - A, B, C see Fig. 3-4		
	NEW	USED
Belt Tension	931.2 [lbs] 4142 [N]	809.8 [lbs] 3602 [N]
Deflection Force	58.2 [lbs] 258.9 [N]	50.6 [lbs] 225.1 [N]
Deflection Amount	A, C - 0.40[in] or 10.2 [mm] B - 0.14[in] or 3.6 [mm]	
RULE OF THUMB: 1/64in DEFLECTION PER INCH OF SPAN. "NEW" values are for the initial stages. "USED" are for further stages as the belt becomes looser.		

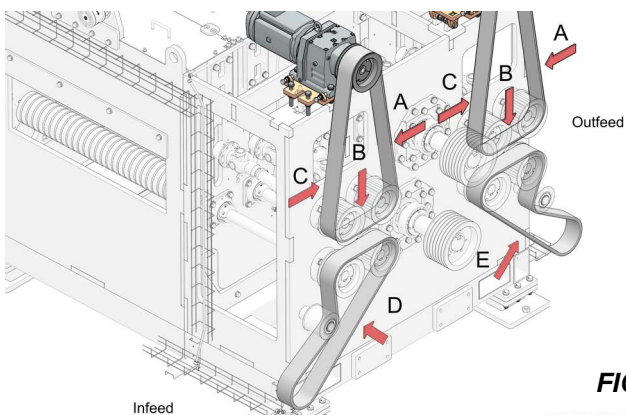


FIG. 3-4

Arbor Drive Tension and Deflection Values		see Fig. 3-5
	NEW	USED
Belt Tension	2189.2 [lbs] 9738.05 [N]	1459.5 [lbs] 6 492,18 [N]
Deflection Force	68.5 [lbs] 304,7 [N]	45.7 [lbs] 203,28 [N]
Deflection Amount	0.35 [in] 8,89 [mm]	
	Frequency [Hz]	
	59.3	48.4
RULE OF THUMB: 1/64in DEFLECTION PER INCH OF SPAN. "NEW" values are for the initial stages. "USED" are for further stages as the belt becomes looser.		

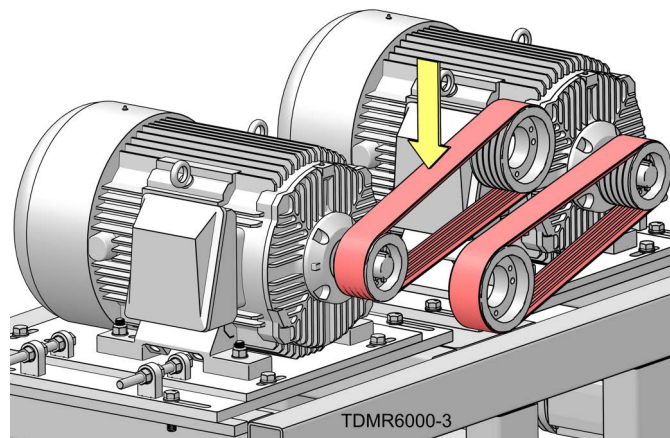


FIG. 3-5

3.4 Belt Tension Adjustment

Note (see Fig. 3-6) that the drive motors may be moved backwards with the adjustment bolts to access the belts for maintenance.

FOR ALL MOTORS:

1. Loosen motor mounting bolts.
2. Loosen jam nuts.
3. Tighten/loosen adjustment bolts as needed.
4. Tighten jam nuts.
5. Tighten mounting bolts.

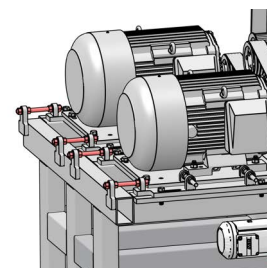


FIG. 3-6

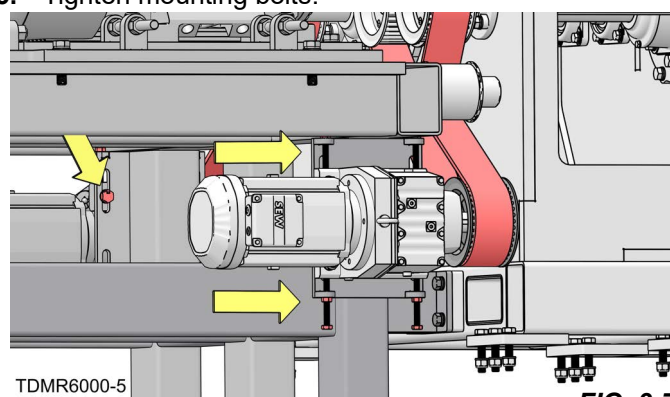
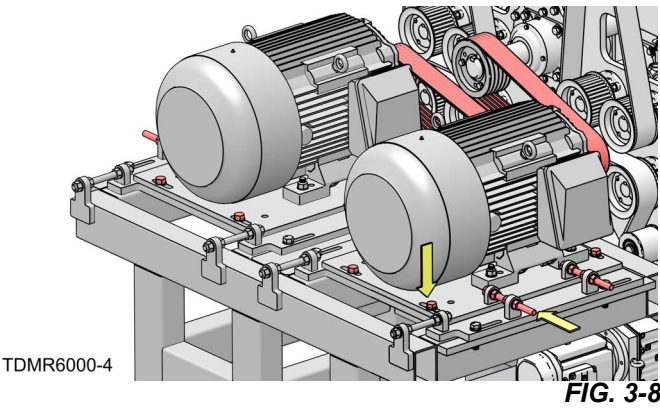


FIG. 3-7



3.5 Bearings

UCF210 and UCFC210 Bearings

Care should be taken when re-greasing bearings to avoid overfilling. Overfilling may lead to excessive heat and/or

unseating the seals. Grease should be introduced in small increments and under light pressure.

NOTICE The approximate amount of grease is 5 grams.

NOTICE The use of pneumatic greasing equipment is not recommended unless low pressure is assured.

Whenever possible, the shaft should be rotated during lubrication to insure proper grease distribution throughout the raceways.

Greases used in re-lubricating bearings should be NLGI # 2 compatible with a lithium thickener, mineral base oil and a temperature range of -10 to +260 degrees F.

General greasing intervals based on RPM and operating conditions are shown in Table 3-1. Wood-Mizer's recommendation is highlighted. However, experience is the preferred method of determining greasing intervals and fill amounts.

Type of unit	dn value	Environmental conditions	Operating temperature F	Relubrication Frequency	
				Hours	Period
Standard	40,000 and below	Ordinary	5 to 176	1500 to 3000	6 to 12 months

Outside of the Sawbox
UCF210 and UCFC210 Bearings

Press Roll Units
UCFC210 Bearings

Standard	70,000 and below	Very Dusty	5 to 212	100 to 500	1 week to 1 month
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d = inner diameter of bearing (mm)
n = speed in RPM

TABLE 3-1

Arbor Bearings (Pre Revision)

Grease type - **Mobil Polyrex EM NLGI Grade 2**

22216 E – DOOR BEARINGS

- **Initial Fill:** Fill 30-50% of the free space inside the bearing (between balls/rollers, cage and raceways) with 21-35g of grease. Then, add 36g (23%) of grease to each side of the bearing housing.
- Add 1g grease every week or 40 hours
- Add 9g of grease every 437 hours

22218 EK – MAIN BEARINGS

- **Initial Fill:** Fill 30-50% of the free space inside the bearing (between balls/rollers, cage and raceways) with 34-51g of grease. Then, add 76g (40%) of grease to each side of the bearing housing.
- Add 4.5g grease every week or 40 hours
- Add 32g of grease every 277 hours

NOTICE! The ideal running temperature of properly greased bearings is 140°F / 60°C. Monitoring the temperature is the best method for checking proper grease filling.

Under or over-filled bearings will cause excessive heat and can damage the bearings.

Arbor Bearings (Post Revision)

Grease type - **Mobile SHC100**

2216 ETN9 – DOOR BEARINGS

- **Initial Fill:** Fill 30-50% of the free space inside the bearing (between balls/rollers, cage and raceways) with 24-40g of grease. Then, add 36g (23%) of grease to each side of the bearing housing.
- Add 0.75g grease every 2 weeks or 80 hours
- Add 23g of grease every 2580 hours

22218 EK – ARBOR SHAFT FLOATING BEARING

- **Initial Fill:** Fill 30-50% of the free space inside the bearing (between balls/rollers, cage and raceways) with 34-51g of grease. Then, add 76g (40%) of grease to each side of the bearing housing.
- Add 4.5g of grease every week or 40 hours
- Add 32g of grease every 277 hours

2218 K – ARBOR SHAFT FIXED BEARING

- **Initial Fill:** Fill 30-50% of the free space inside the bearing (between balls/rollers, cage and raceways) with 34-51g of grease. Then, add 76g (40%) of grease to each side of the bearing housing.
- Add 1.2g of grease every week or 40 hours
- Add 32g of grease every 2060 hours

NOTICE! The ideal running temperature of properly greased bearings is 140°F / 60°C. Monitoring the temperature is the best method for checking proper grease filling.

Under or over-filled bearings will cause excessive heat and can damage the bearings.

LINEAR BEARINGS -HIWIN RGW25CCZAH_KK

- Initial Nominal life = 1000km ±26000 hours
- Orientation - Vertical
- Stroke = 320mm
- Frequency = 2/min – 8 hours per shift
- Travel/Hour = 0.0384 km
- Relubrication interval = 100km = $\pm 2600/2 = 1800$ hours (Corrected for vertical orientation)
- Lubrication quantity 1.2 cm³

BELT ROUTING BALL BEARINGS

- Sealed for Life no lubrication required

BEARING RUN-IN PROCEDURE

The arbor and door bearings require a run-in period after installation. This procedure **MUST** take place before full production can begin.

1. Run the arbors for 30 seconds **WITHOUT** the arbor sleeves installed.
2. Allow the arbors to rest for 3 minutes.
3. Repeat steps 1 & 2 a total of 10 times.

NOTICE! Bearing temperatures should remain stable at **130-140 degrees Fahrenheit (54-60 degrees Celsius)**.

IF the temperature falls within the acceptable range and remains stable, then procedure is complete.

IF the temperature does **NOT** fall within the acceptable range, continue on to steps **4 through 6**.

4. Remove a small amount of grease from the bearing cavity.
5. Note the amount of grease removed.
6. Repeat steps **1 through 5** until acceptable temperature range is achieved and remains stable.

3.6 Universal Joint

Grease Type – **Lithium based E.P. Grease NLGI 1 or 2**

- Lubrication interval every 500 hours
- Purge all 4 bearing seals
- Estimated life: ±50,000 hours

Refer to the manufacturer's (*Johnson Power*) manual for complete maintenance information.

3.7 Motors

Arbor Motors

Refer to the manufacturer's (*Elektrim Motors*) manual for maintenance information.

Gear Motors

Refer to the manufacturer's (*SEW Eurodrive*) manual for maintenance information.

3.8 Mount New Bearings

Detailed mounting instructions and tolerances for each bearing type can be found at mount.skf.com.

3.9 Pneumatic Cylinders

Refer to the manufacturer's (*Festo*) manuals for maintenance information.

3.10 Misting Pumps

Refer to the manufacturer's (*Aeromist*) manuals for maintenance information.

3.11 Rollers

Check the rollers before starting work. Any debris must be moved. Use a wire brush with an eco-friendly/biodegradable cleaner.

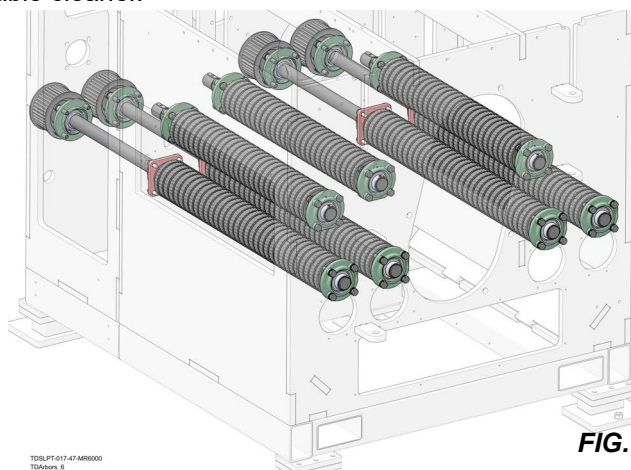


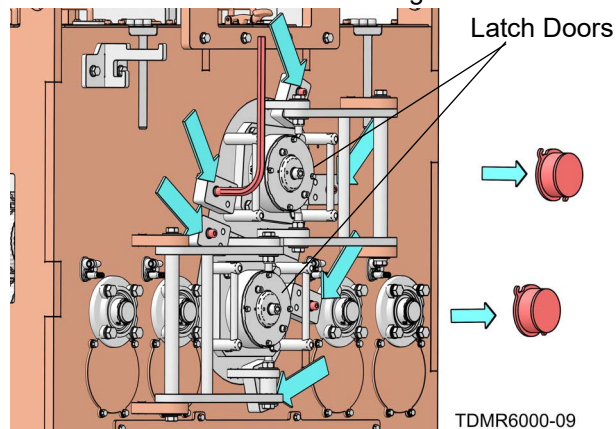
FIG. 3-9

3.12 Change Arbor Blades



WARNING! Blade arbors are heavy. Use proper lift devices to maneuver the arbors.

1. Loosen the two mounting screws to remove arbor hub cover on both door latches.
2. Remove the three bolts securing each door latch.



TDMR6000-09

FIG. 3-10

3. Remove the central bolt on both arbors. The machine

3 MR6000 Maintenance

Change Arbor Blades

NOTE: If doors fail to open, use the supplied slide hammer to force them.

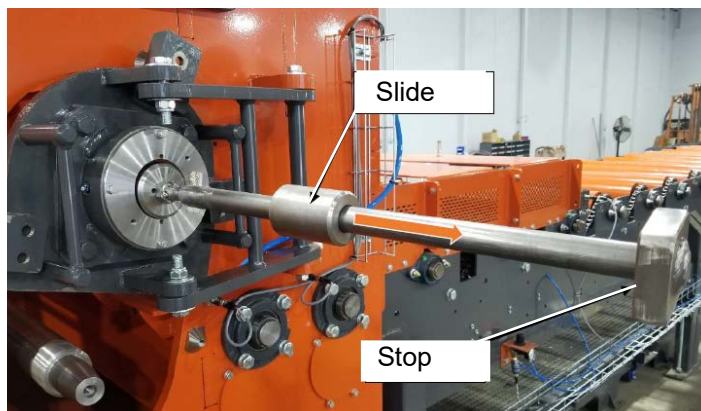


FIG. 3-12

a. Screw the thread of the slide hammer into the central hole of the door/arbor.

b. Forcefully slide the weight to the rear stop, jolting the door open.

5. Loosen the arbors with the nut wrench, arbor spanner and a 1/2in drive, (see fig. 3-13) or use the arbor nut socket with the impact wrench (see fig. 3-14).

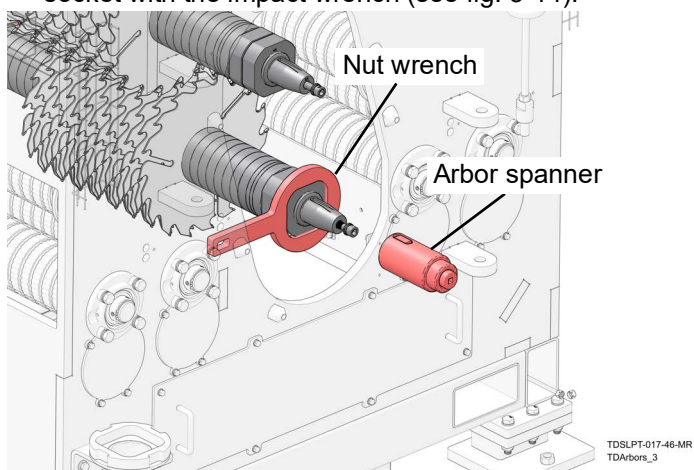


FIG. 3-13

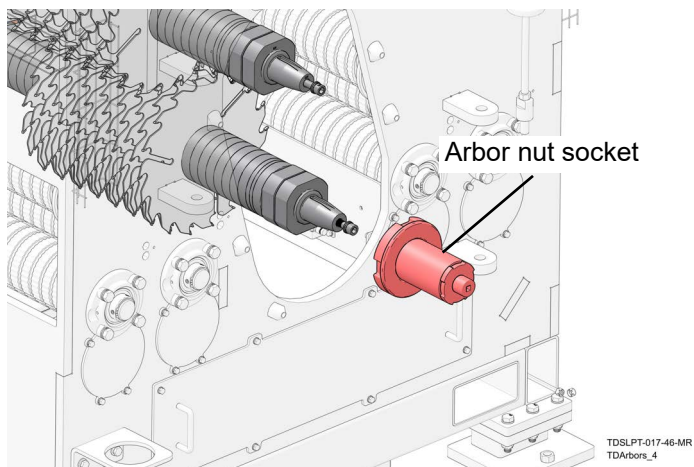


FIG. 3-14

- a. Brace the nut wrench on an interior frame member.
- b. Slide an appropriate tool over the arbor shaft, ensuring it is keyed in the shaft.
- c. For the upper arbor, depending on the machine orientation, turn the wrench clockwise if the cutout is slanted upwards to the right. See Fig. 3-15.
- d. If the cutout is slanted upwards to the left, turn the tool counter-clockwise. See Fig. 3-16. Horizontal arrow indicates the direction of the material.

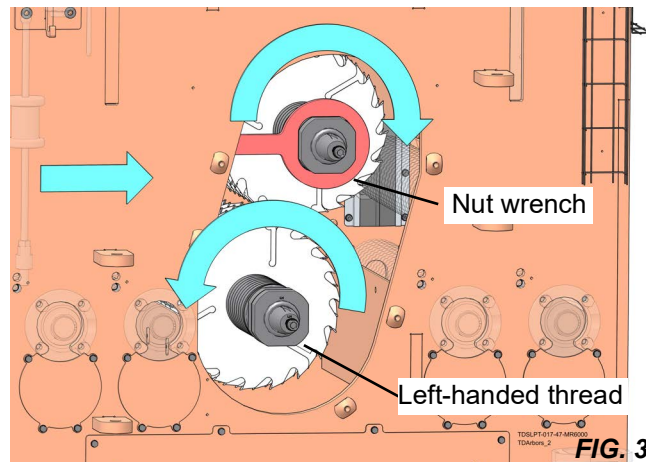


FIG. 3-15

- e. For the lower arbor, depending on the machine orientation, turn the tool counter-clockwise if the cutout is slanted upwards to the right. See Fig. 3-15.
- f. If the cutout is slanted upwards to the left, turn the tool clockwise. See Fig. 3-16. Horizontal arrow indicates the direction of the material.

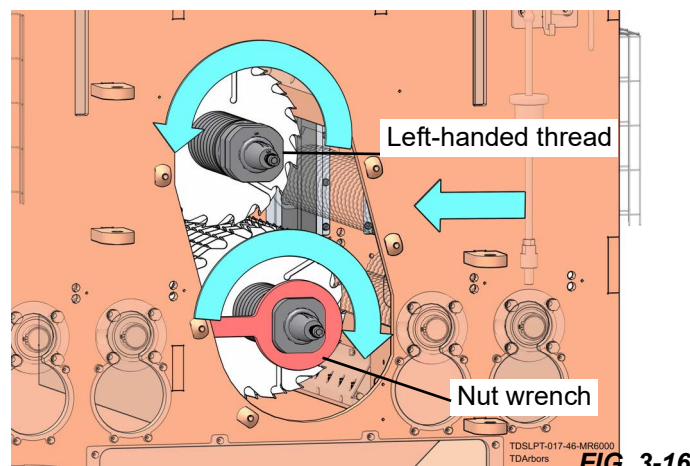


FIG. 3-16

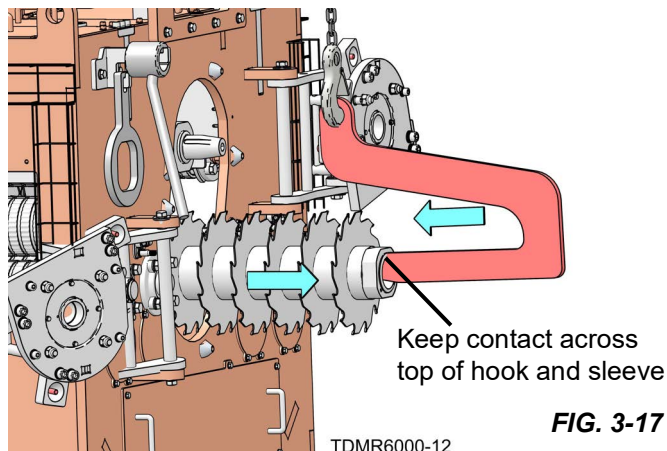


WARNING! Wear gloves when handling blades.

6. Remove the central arbor sleeve from the shaft.
 - a. Pull the arbor sleeve straight out approximately 1ft.
 - b. Lower the sleeve removal hook, keeping the top of the hook against the top of the inner sleeve.
 - c. Slide the hook in until it touches the arbor shaft.

NOTICE Do not damage the arbor shaft threads.

- d. Continue to pull the sleeve out until it rests up against the back of the hook.



NOTE: The sleeve assembly weighs approximately 175lb. (80kg).

With the sleeve assembly fully loaded on the hook, the hook should tilt upwards to prevent the sleeve from sliding off.

- e. Place the sleeve on a sturdy, padded work surface.

7. Before removing the sleeve nut, brush the thread.

NOTICE Marking the spacers will make the current blade spacing/pattern easier to maintain.

Note the rotation of the upper and lower blades.

8. Replace blades, as needed.

NOTE: Take care not to line up the teeth between 2 adjacent blades during the staggering the blades. The new blades have 2 sets of keyways allowing them to mount in 2 ways.

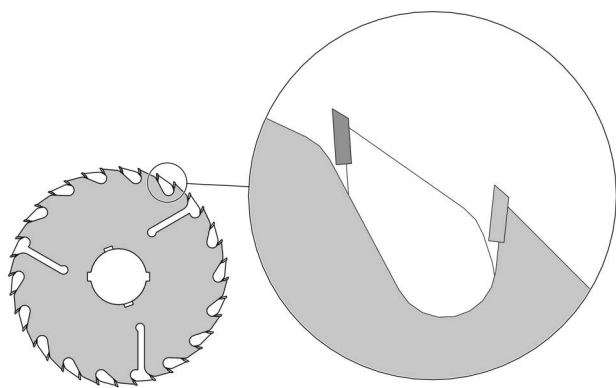


FIG. 3-18

9. Before reassembling the blades, spacers, and nut, apply Anti-seize compound to the nut and the thread.

NOTE: Ensure there is no slack between the blades and spacers.



WARNING! Wipe the arbor shaft, sleeve, and the conical interface between the nose of the arbor

and the door bearing with a soft cloth and dry graphite.

10. Slide the assembly straight onto the arbor until only 1ft protrudes from the shaft.

NOTICE Do not damage the arbor shaft threads. Keep the hook resting against the arbor while sliding the sleeve onto the arbor.

11. Rotate the sleeve to align the keyways on the sleeve to the keys on the shaft.

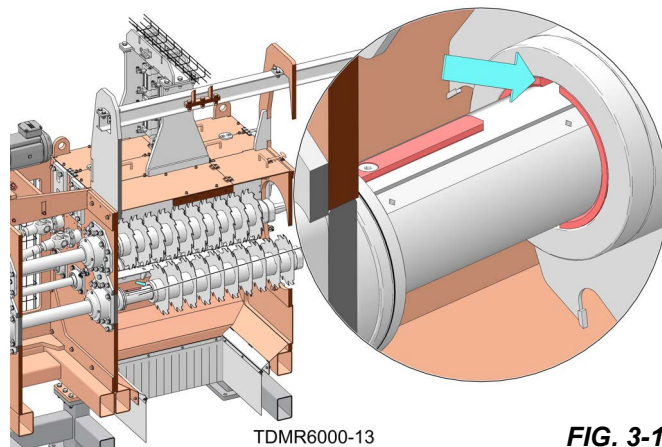


FIG. 3-19

12. Reattach the arbor nut with the nut wrench (spanner) and arbor wrench (spanner) in the reverse of Fig 3-16 and Fig 3-16.

13. Additional socket tool can be used to loosen or tighten the nuts with an 1/2in drive impact wrench.

14. Reseal the arbor doors in the reverse order of opening them.

15. Inspect the CV joints at least once a month. If loose, use a threadlocker and grubscrews tightened to 88 in.lb (7.3 ft.lb) (110Nm).

Cutting size adjustment

To get a cutting size of 1in use 1in spacer with the Kerf. Number of blades will be equal to 14. In order to increase cutting size to 2in use spacer with the Kerf and without the Kerf. The number of blades will decrease and will be 8, see Fig 3-20

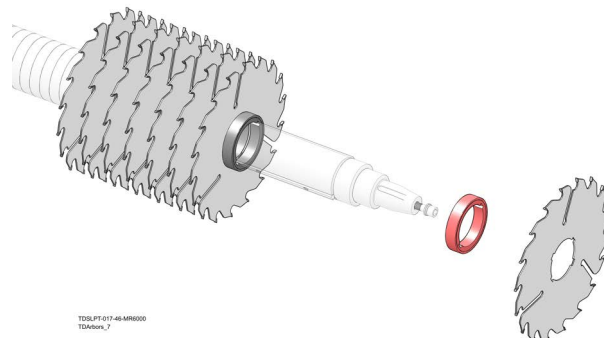


FIG. 3-20

3.13 Arbors adjustment

To adjust the upper and bottom arbors, please follow the procedure described below.

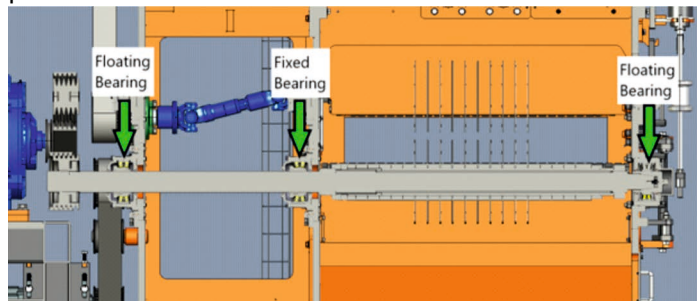


FIG. 3-21

The arbor does not have any specific locating features, but relies on accurate fitting.

The arbor is positioned with the central fixed bearing. The spherical roller bearing is fitted to the shaft with a taper adapter and locked in position with a lock nut and washer. The bearing is locked in the housing with a locating ring as shown in Figure 3-22

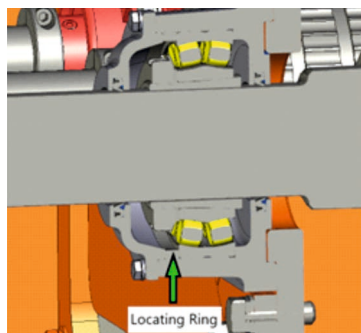


FIG. 3-22

The remaining 2 bearings on the arbor should be setup to have almost equal float in both directions.

The belt drive side bearing is identical to the central fixed/locating bearing without the locating ring. The bearing should be positioned to have $\pm 5\text{mm}$ of float in both direction.

The door bearing is mounted to the conical cup so that it fits on the nose of the arbor. The bearing has $\pm 5\text{mm}$ of float in both direction. This float allows for thermal expansion as well as inaccuracy in the arbor nose position.

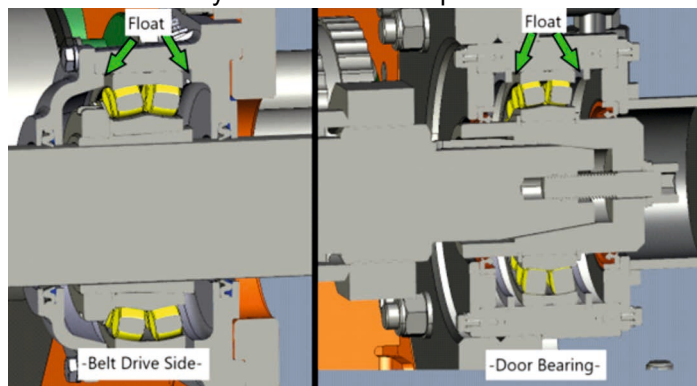


FIG. 3-23

When mounting the bearings, please refer to FIG. 3-19. Given dimensions are identical for both arbors.

Potential areas of miss match error.

Since the two arbors are manually positioned, they will likely have a small mismatch in relation to each other.

The adjustable spacer is shimmed to line up the arbor shoulders.

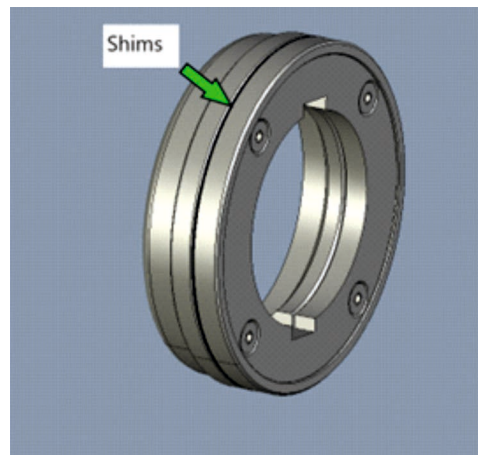


FIG. 3-24

Troubleshooting

If the problem occurs during service, the problem can be attributed to a few factors:

1. Movement of the arbor.

Put a mark on the arbor and give it a firm tap with a rubber mallet. If the arbor moves, the fixed bearing needs to be refitted. There should not be any movement in the arbor.

2. Debris on the arbor or sleeve

With every blade change the arbor, sleeves and spacers should be cleaned to ensure accurate placement.

3. Incorrect spacer/blade stacking

Size of the spacers is very specific for the cutting pattern. There is also a special spacer with large internal chamfers to fit against the sleeve shoulder. Ensure all the slack is taken out of the blades/spacers stack. The stacked sleeves can be compared outside of the machine.

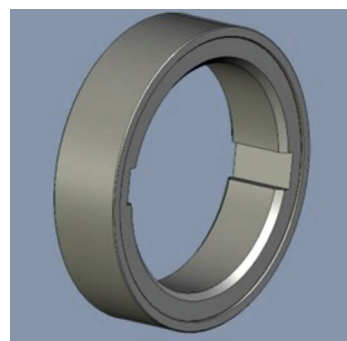


FIG. 3-18 SLEEVE SHOULDER SPACER

4. Loosening of the adjustable spacer

The adjustable spacer may become loose over times and get clogged with debris. Check that the bolts are tight and clean any debris frequently. If you dismount the spacer from the arbor make sure to mount it back on the same arbor. If you mount back the spacer from the upper arbor on the bottom arbor then the arbors alignment will be lost.

5. Excessive vibration.

Check the quality of the arbor drive belts.

Conclusions:

- The arbor and sleeve should be cleaned during every blade change to ensure accuracy and longevity of the system.
- The door bearing/cup should always be tightened before starting up the machine to prevent damage to the door cone and arbor assembly.

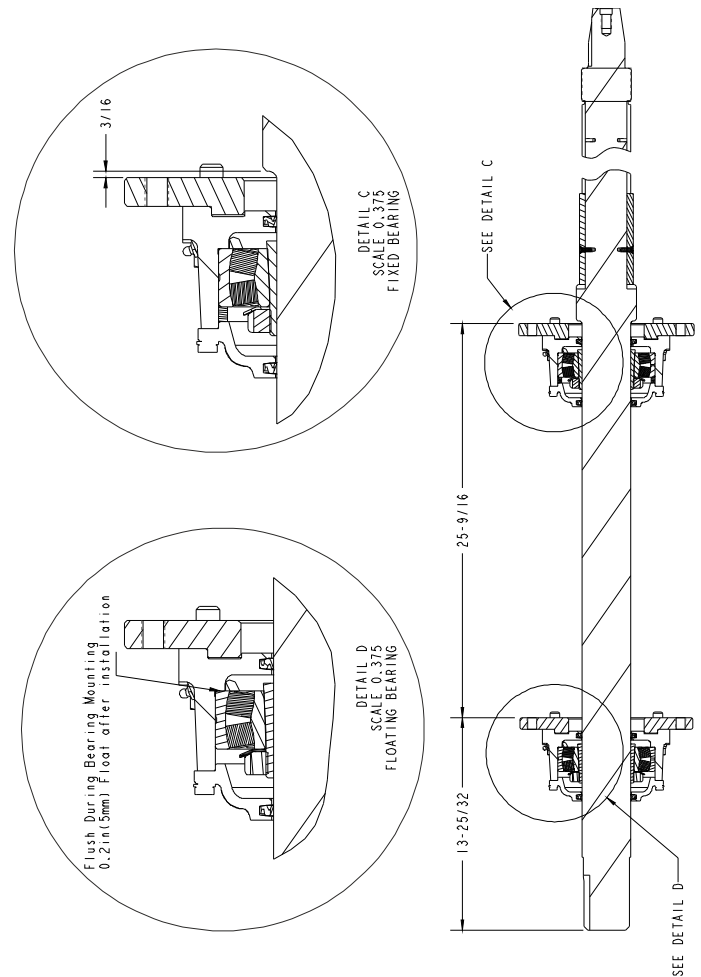


FIG. 3-19 WORKBENCH BEARING POSITIONS