Safety, Operation & Parts Manual

E430 Industrial Edger rev. A1.00 - A4.00
EG400 Industrial Edger rev. A4.01 - A5.02

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

July 2010

Form #1209

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

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**.

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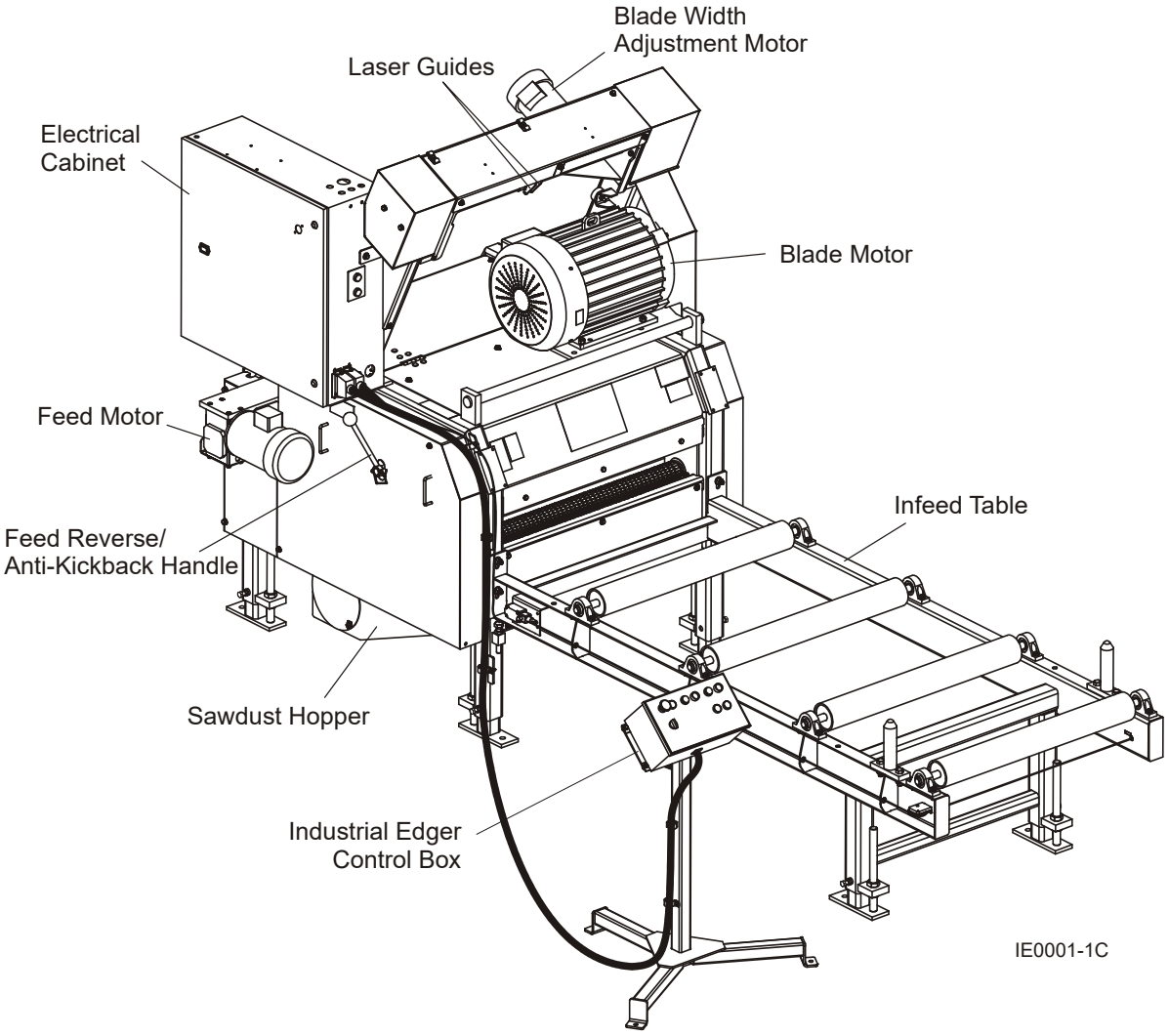
SECTION 1 INTRODUCTION

1.1 About This Manual

This manual is to replace or to be used with all previous information received on the Wood-Mizer® * Industrial Edger. 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.

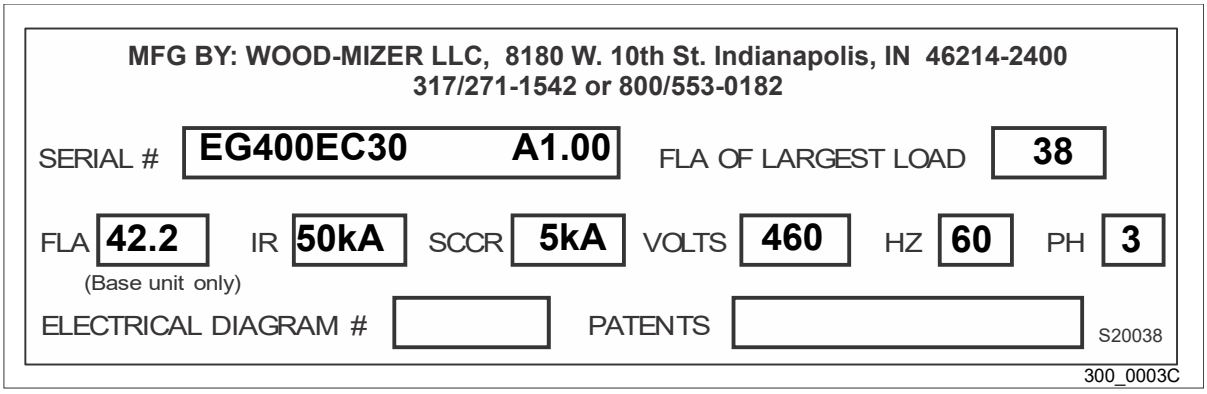
Identification Information (To be filled in by purchaser)

Model No. _____

Serial No. _____

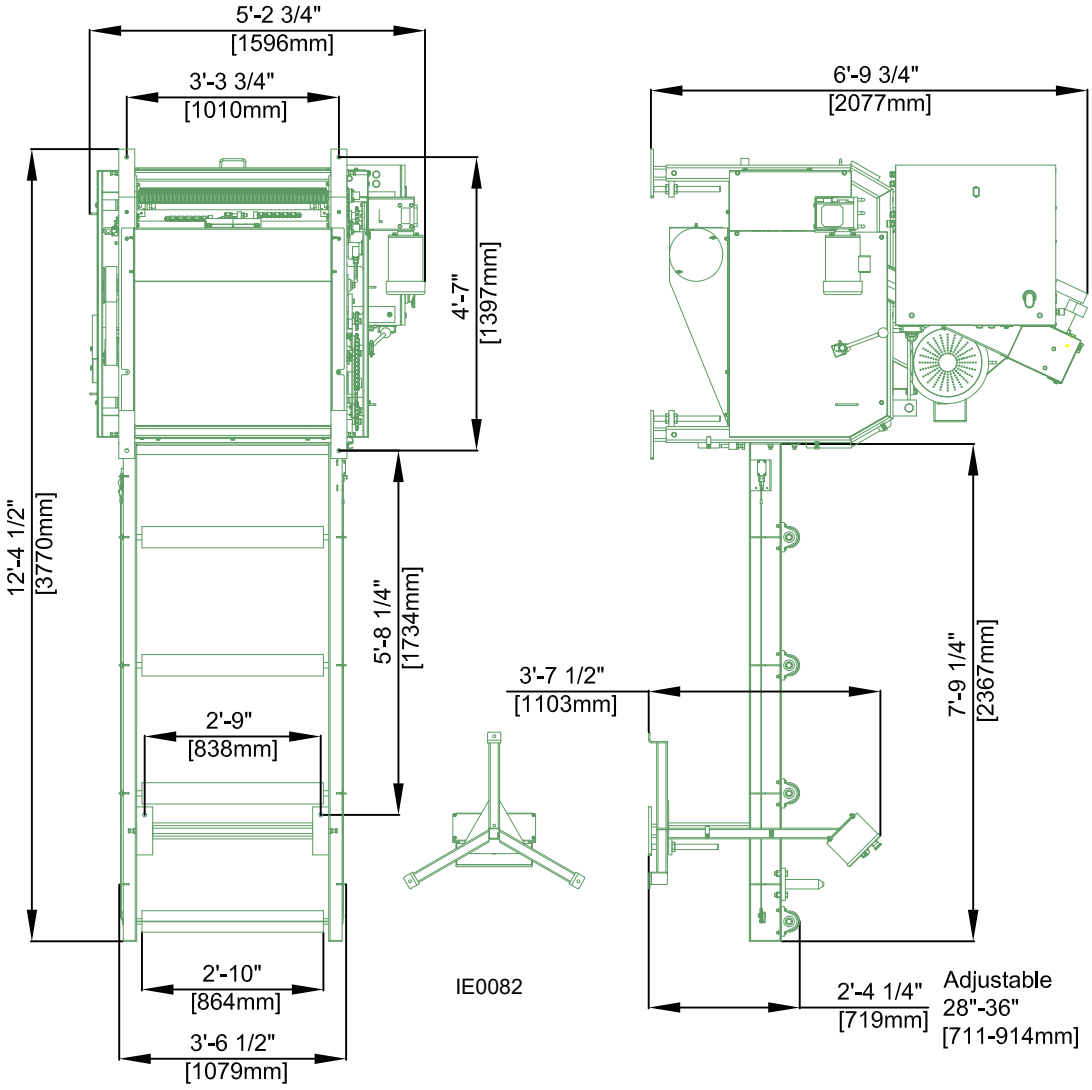
Customer No. _____

:



EG400 IDENTIFICATION PLATE

1.4 Dimensions



INDUSTRIAL EDGER DIMENSIONS

1.5 Specifications

Model: E430/EG400 Rev. A1.00+

Machine Dimensions:	
Length:	148 1/2"
Width:	62 3/4"
Height:	81 3/4"
Infeed Table Height:	28" - 36" Adjustable
Infeed Table Length:	93 3/4"
Weight:	3750 lbs
Material Dimensions:	
Maximum Feed Width:	36"
Maximum Board Width Cut:	28"
Minimum Board Width Cut:	3"
Maximum Board Thickness:	4"
Minimum Board Thickness:	1"
Electrical Installation Requirements:	
380 - 415V 50Hz 3Ph:	100 Amp
460V 60Hz 3Ph:	100 Amp
Blade System:	
Diameter:	16"
Bore:	3 1/2"
Teeth:	14
Kerf:	9/32"
Blade RPM (No Load):	2239
Width Adjustment Motor Horsepower:	1/2
Width Adjustment Motor RPM:	1725
Feed System:	
Minimum Feed Speed (4" material):	44 Ft/Min
Medium Feed Speed (2" material):	78 Ft/Min
Maximum Feed Speed (1" material):	111 Ft/Min
Feed Motor Horsepower:	2
Feed Motor RPM:	1725
Blade Motor:	
Horsepower:	30
RPM (No Load):	1765
Motor Shaft Diameter:	1 7/8"
Motor Pulley Diameter:	8 1/2"
Drive Pulley Diameter:	6.7"
Drive Belt:	35VX900

INDUSTRIAL EDGER SPECIFICATIONS

1.6 Warranty

Wood-Mizer® LLC

Limited Product Warranty

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, FS	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
TITAN Industrial	WB, TV, HR, EG, EA, MR	One year	One year	
Material Handling	TWC, IC, TD, LD, GC, CR, CB, CC	One year	One year	
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	Date of purchase
Options and Accessories	Various	One year[1]	One year[1]	
Moulders, Kilns	MP, SD, KD	One year	One year	
Pallet Dismantler	PD	**One year**	**One year**	
Log Splitter	**FS**	**One year**	**One year**	
Replacement Parts	Various	90 days	90 days	

[1] 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, and/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 repair or replace 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 AND WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NONINFRINGEMENT 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 any other basis, for any legal action against Warrantor. There are no other representations, promises, agreements, covenants, warranties, guarantees, stipulations or conditions, expressed or implied, by Warrantor, except as expressly set forth herein. THE PURCHASER AND ANY INTENDED USER OR BENEFICIARY OF THIS EQUIPMENT, SHALL NOT BE ENTITLED TO RECOVER ANY INDIRECT, SPECIAL, PUNITIVE, EXEMPLARY, CONSEQUENTIAL, SPECIAL, OR INCIDENTIAL DAMAGES OR LOSES, 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, therefore 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 that is signed by both Warrantor and Purchaser.

SECTION 2 SAFETY

2.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions.

DANGER! indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

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

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

IMPORTANT! indicates vital information.

NOTE: gives helpful information.

Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

2.2 Safety Instructions

NOTE: ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding only equipment damage appear where applicable throughout the manual.

OBSERVE SAFETY INSTRUCTIONS

IMPORTANT! Read the entire Owner's Manual before operating the Edger. 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 Edger. The Edger 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 Edger. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the Edger.

WEAR SAFETY CLOTHING

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

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

KEEP EDGER AND AREA AROUND EDGER CLEAN

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

DISPOSE OF SAWING BY-PRODUCTS PROPERLY

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

CHECK EDGER BEFORE OPERATION

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

WARNING! Check for proper rotation of the blades 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 Edger 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! Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.

Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to do so may result in serious injury.

WARNING! Always check the control box mounted and cable activated Emergency Stop switches for proper operation prior to each use of the machine. Failure to do so may result in serious injury.

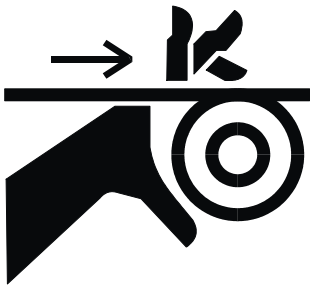
KEEP PERSONS AWAY

DANGER! Keep all persons out of the path of moving equipment and boards when operating the Edger. 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 or towing. Failure to do so may 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! Coastdown Required. Always shut down the edger 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! Kickback Hazard. Stay clear of area during operation. Follow all anti-kickback service and safety rules. 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 edger 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.

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.

EDGER 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 of the machine.

Sequence of Lockout Procedure:

1. Notify all persons that a lockout is required and the reason therefore.

2. If the edger 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 edger. 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 edger will not operate. Caution: Return operating controls to neutral position after the test.

6. The edger is now locked out.

Restoring Equipment to Service

1. When the job is complete and the edger is ready for testing or normal service, check the edger area to see that no one is exposed.

2. When the edger is all clear, remove all locks. The energy isolating devices may be operated to restore energy to the edger.

Procedure Involving More Than One Person

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

Rules for Using Lockout Procedure

The edger 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 edger.

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 edger.

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

See Figure 3-1.

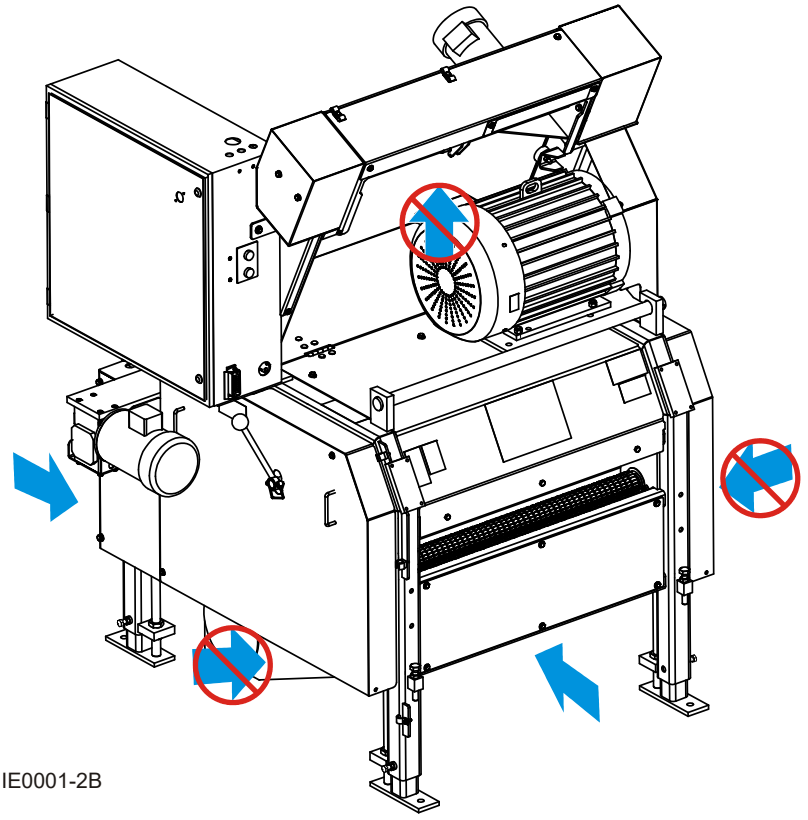


FIG. 3-1

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

See Figure 3-2. Adjust the four legs of the edger so the infeed height is appropriate for your application. Loosen the locking bolt and turn the adjustment nut counterclockwise to raise the edger, clockwise to lower the edger. Retighten the locking bolt.

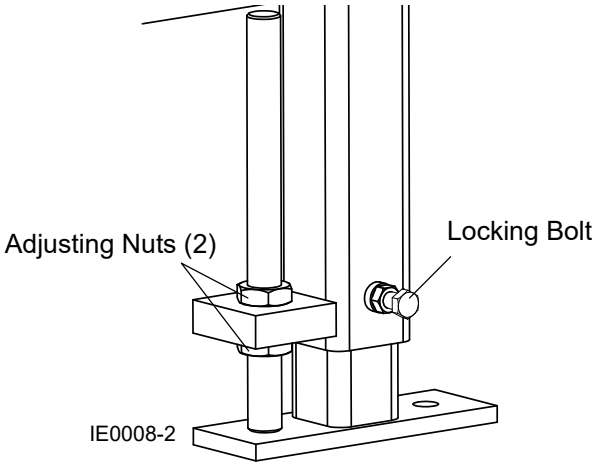


FIG. 3-2

See Figure 3-3. Assemble the infeed table to the front of the edger with the bolts provided. Use the height adjustment bolt and nut to support the infeed table properly before securing the infeed table to the edger on both sides.

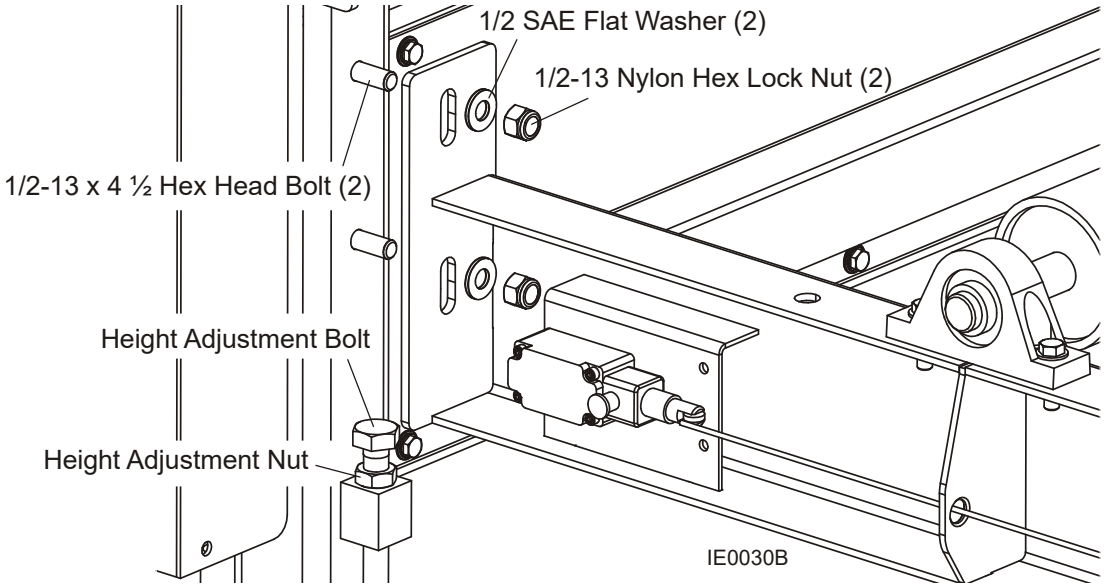


FIG. 3-3

Adjust the infeed table height in the same manner as the edger legs so the table is aligned with the infeed rollers of the edger. **NOTE:** Make sure the infeed table rollers are leveled with the edger lower infeed drive rollers before starting cutting.

3.2 Electrical Installation

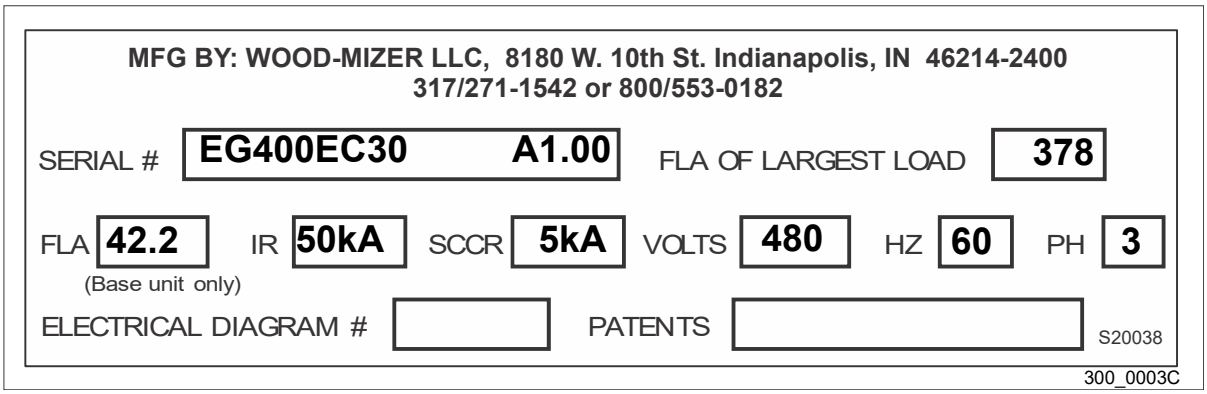
DANGER! Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.

DANGER! Hazardous voltage inside the electric 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 edger operation.

Electrical Requirements

CAUTION! The edger motors and transformer are pre-wired for 480 volt, 60 Hz power supplies. If you plan to use a 480 volt, 60 Hz edger with another type of power supply, you will need to rewire the motor to avoid damage to the machine.

The edger identification plate including the required electrical information is shown below:



EG400 IDENTIFICATION PLATE

IMPORTANT! The edger is wired for use with a 480 volt power supply. To operate the edger with 240V, 400V or 600V 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 From/To	240 to 480 volts	400 to 480 volts	600 to 480 volts
Wood-Mizer Part No.	069711	068054	068185

TABLE 3-1

Installation

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

1. Unlock and open the electrical box on the edger.

2. Locate the main disconnector in the upper right corner inside the electrical box. Route the power supply cable through the upper hole in the electrical box and above the disconnector. Connect the power supply wires to the main disconnector in the electrical box as shown.

See Figure 3-4. Rev. A3.00+: Connect the power supply to the main disconnector in the electrical box.

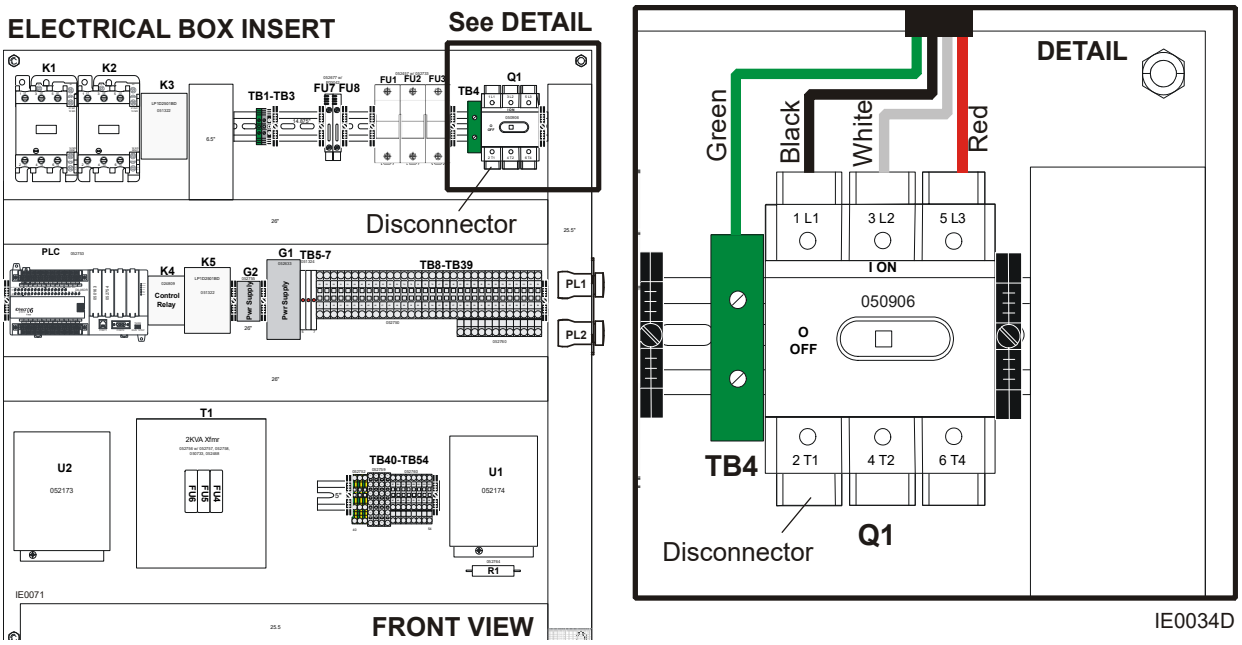


FIG. 3-4

See Figure 3-5. Rev. A1.00 - A2.00: Connect the power supply to the main disconnector in the electrical box.

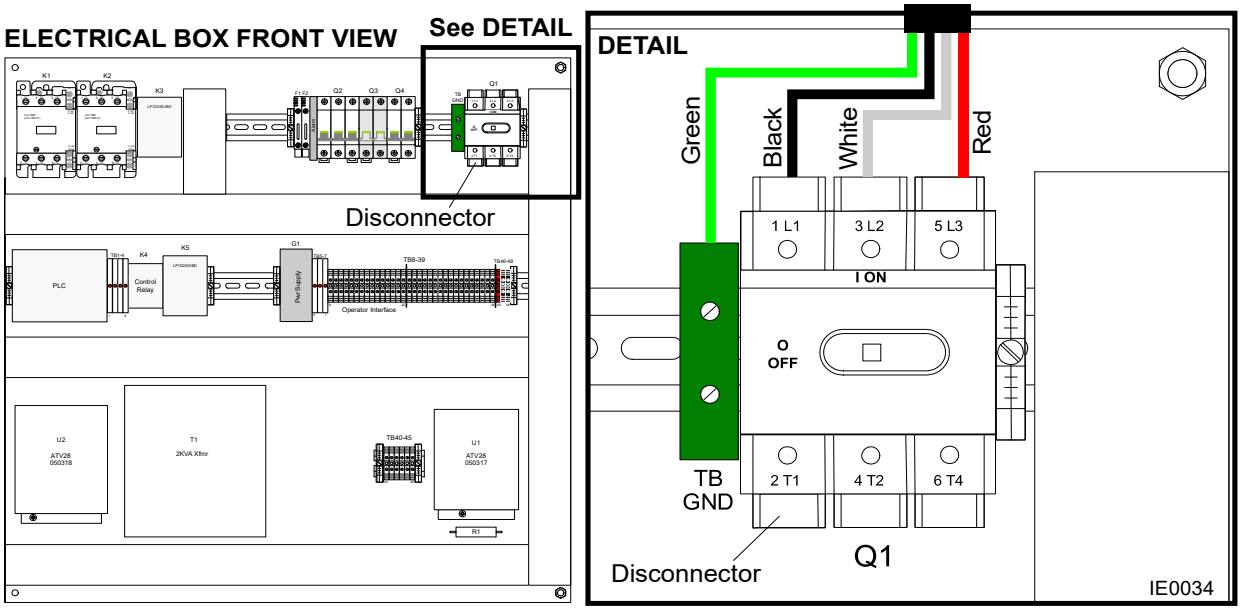


FIG. 3-5

3. Close the electrical box and lock with keys.

4. Setup the edger control box next to the edger. Make sure that the place where the control box is located is safe and comfortable to operate the edger. Connect the control box cable to the electrical box.

   See Figure 3-6. Connect the edger control box to the electrical box as shown.

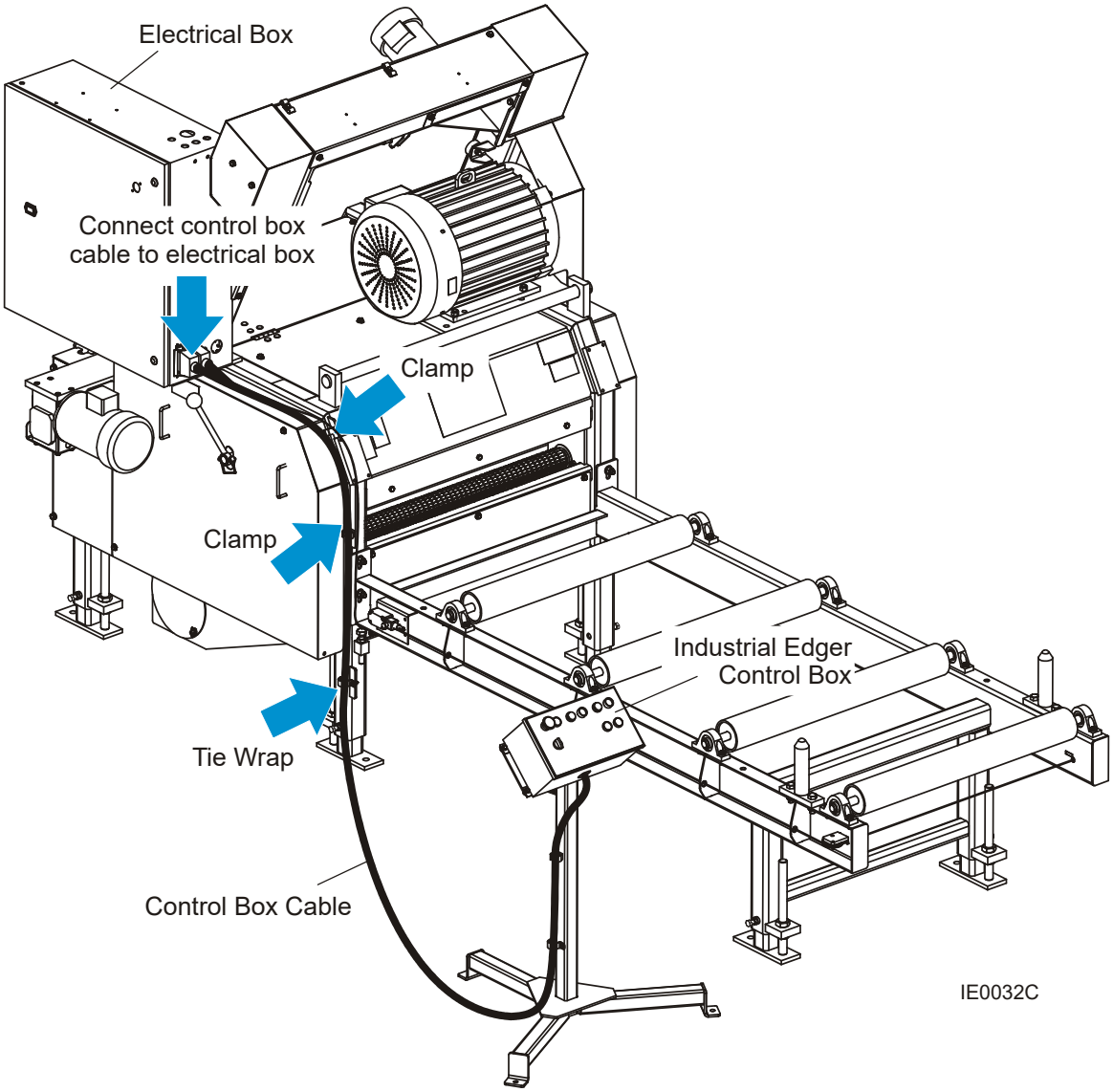


FIG. 3-6

5. Secure the control box cable with three cable clamps (3) installed to the edger frame. Make sure that the drive side removable guard can be accessed easily if necessary.

6. Connect the existing safety switch cable from the electrical box to the safety switch located on the left side of the infeed table frame. Secure the cable with the tie wraps to the control box cable.

   See Figure 3-7.

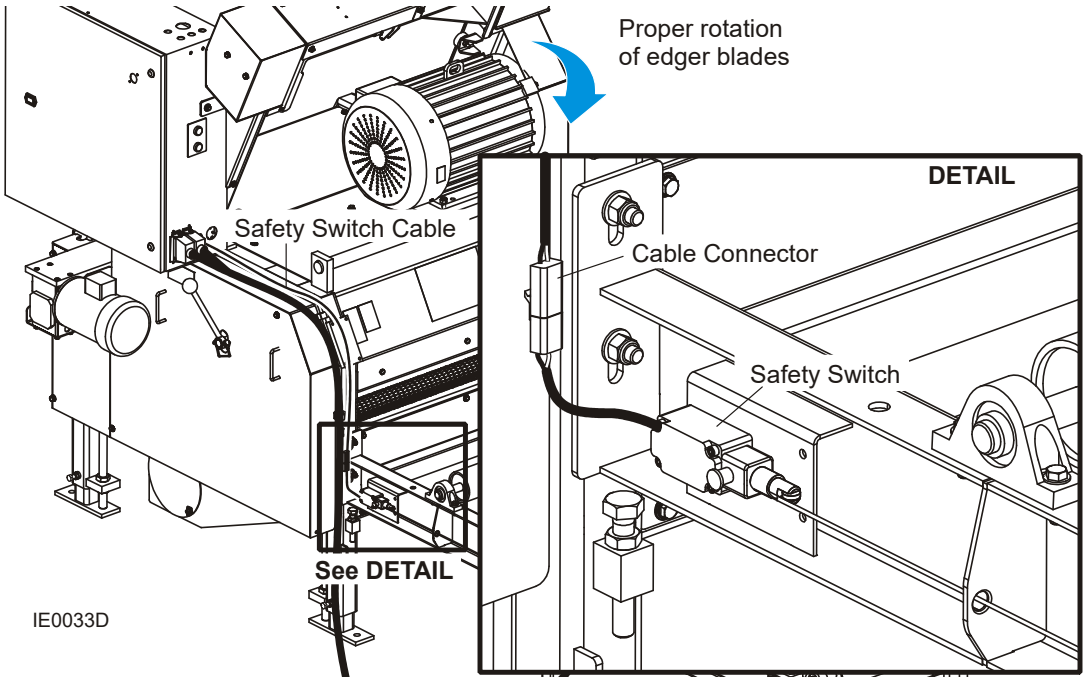


FIG. 3-7

7. Check for proper rotation of the edger blades. The infeed will always rotate the correct direction, but the blade rotation can be reversed. Push the MACHINE-START button and then the BLADES-START button. The blades should spin clockwise as viewed from the control side of the machine. If the blades spin in the wrong direction, turn off the machine, disconnect and lockout the electrical power and check the wiring. *See SECTION 6* for electrical wiring diagrams.

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

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 edger is not in use. Failure to do so may result in serious injury.

3.3 Pre-Operation Check

Prior to operating the Edger; always perform these basic checks:

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

2. Make sure the motor drive belt is tensioned properly. *See Section 4.3* 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 the anti-kickback fingers are in proper working condition.

   See Figure 3-8.

> **WARNING!** Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.
>
> Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to do so may result in serious injury.

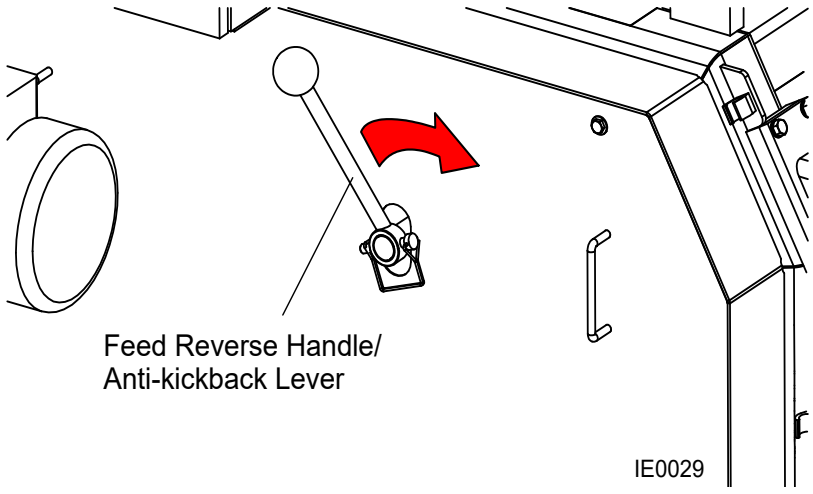


FIG. 3-8

NOTE: The feed reverse handle/anti-kickback lever lifts the anti-kickback finger, shuts down the blades and reverses the infeed movement. Release the lever and restart the blades by pressing the START BLADES button on the control box to continue cutting.

4. 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 Edger. Failure to do so may result in serious injury.

5. Also be aware that the blades are spinning whenever the motor is ON. You should always turn off the motor to stop the blade whenever the Edger 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 Edger is not in use. Failure to do so may result in serious injury.

6. An Emergency Stop is located on the front panel of the Edger control box. Press the Emergency Stop to shut down the edger. Before operating the Edger again, turn the E-Stop switch clockwise and release.

   The Edger is also equipped with one more Emergency Stop switch located on the infeed table. The switch is activated by pulling the red cable installed around the infeed table frame. Pull the cable to shut down the edger. Restart the Edger using the buttons and switches on the control box when necessary.

WARNING! Always check the control box mounted and cable activated Emergency Stop switches for proper operation prior to each use of the machine. Failure to do so may result in serious injury.

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

3.4 Starting & Stopping The Machine

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

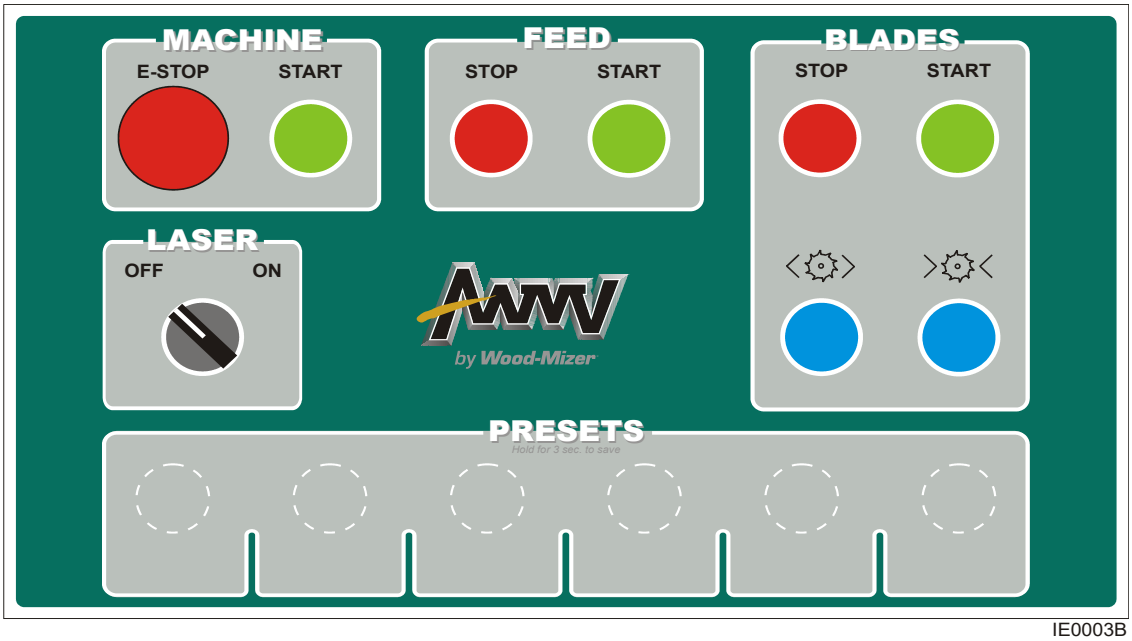
DANGER! Always be sure all persons are away from the edger before starting the motor. Failure to do so will result in serious injury.

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

WARNING! Always check the control box mounted and cable activated Emergency Stop switches for proper operation prior to each use of the machine. 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. Rev. A3.00+: The main control panel has switches to start and stop edger functions.



IE0003B

FIG. 3-2

See Figure 3-3. Rev. A1.00 - A2.00: The main control panel has switches to start and stop edger functions.

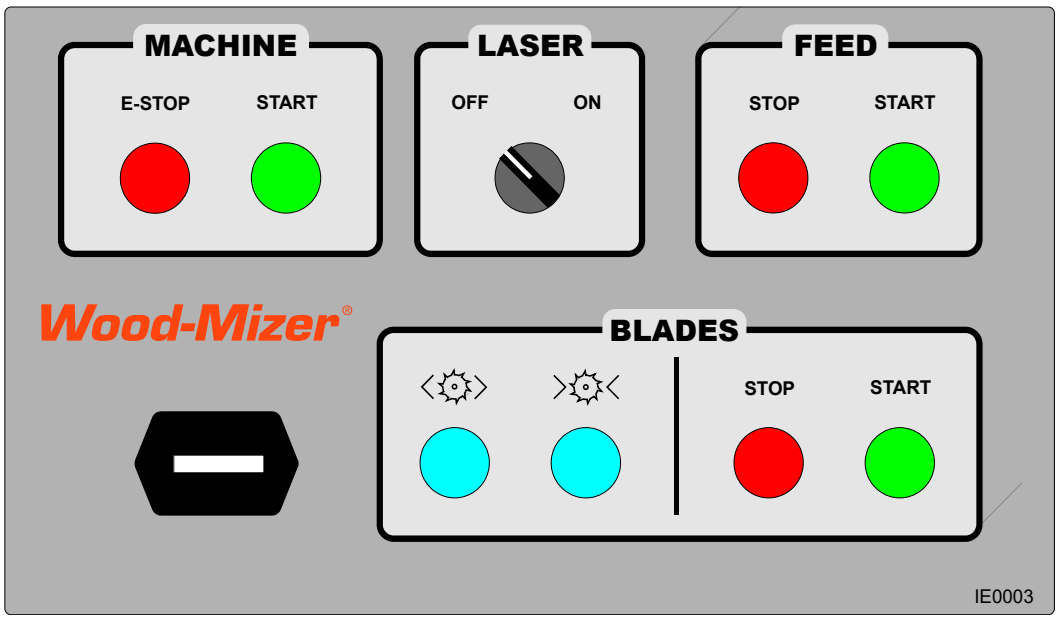


FIG. 3-3

2. To turn the edger power on, push the green MACHINE-START button on the control box.

   NOTE: The covers and the electrical cabinet must be closed before the edger can be started.

3. Turn the laser guides on by turning the LASER switch to the ON position.

4. Adjust the position of the blade by pushing the left or right blue POSITION buttons on the control box until the lasers indicate the desired position.

   NOTE (Rev. A3.01+): If there is material still in the feed path or the feed rollers are not in the rest position, the MACHINE START light on the control panel and MACHINE ON light on the electrical cabinet will flash. Changes in blade position cannot be made while the lights are flashing.

   NOTE: If the edger is equipped with the optional Setworks, you can use the preset buttons to move the blades to the desired position. *See Section 3.6* for details.

5. Push the BLADES-START button to start the edger blades.

6. Push the FEED-START button to start the edger feed system. **NOTE:** The edger feed system will not start unless the blades have been started first.

The following switches on the main control panel can be used to shutdown the edger.

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

   Pull out the emergency red wire around the infeed table whenever it is necessary to shut down the edger.

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

3. Turn the LASERS switch to OFF to turn off the laser guides.

3.5 Edging Lumber

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

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

1. Start the machine and turn the lasers on as described in *Section 3.4 Starting & Stopping The Machine*.

2. Place the board in the approximate center of the infeed table. Use the provided pivot posts to assist loading if necessary.

   See Figure 3-9.

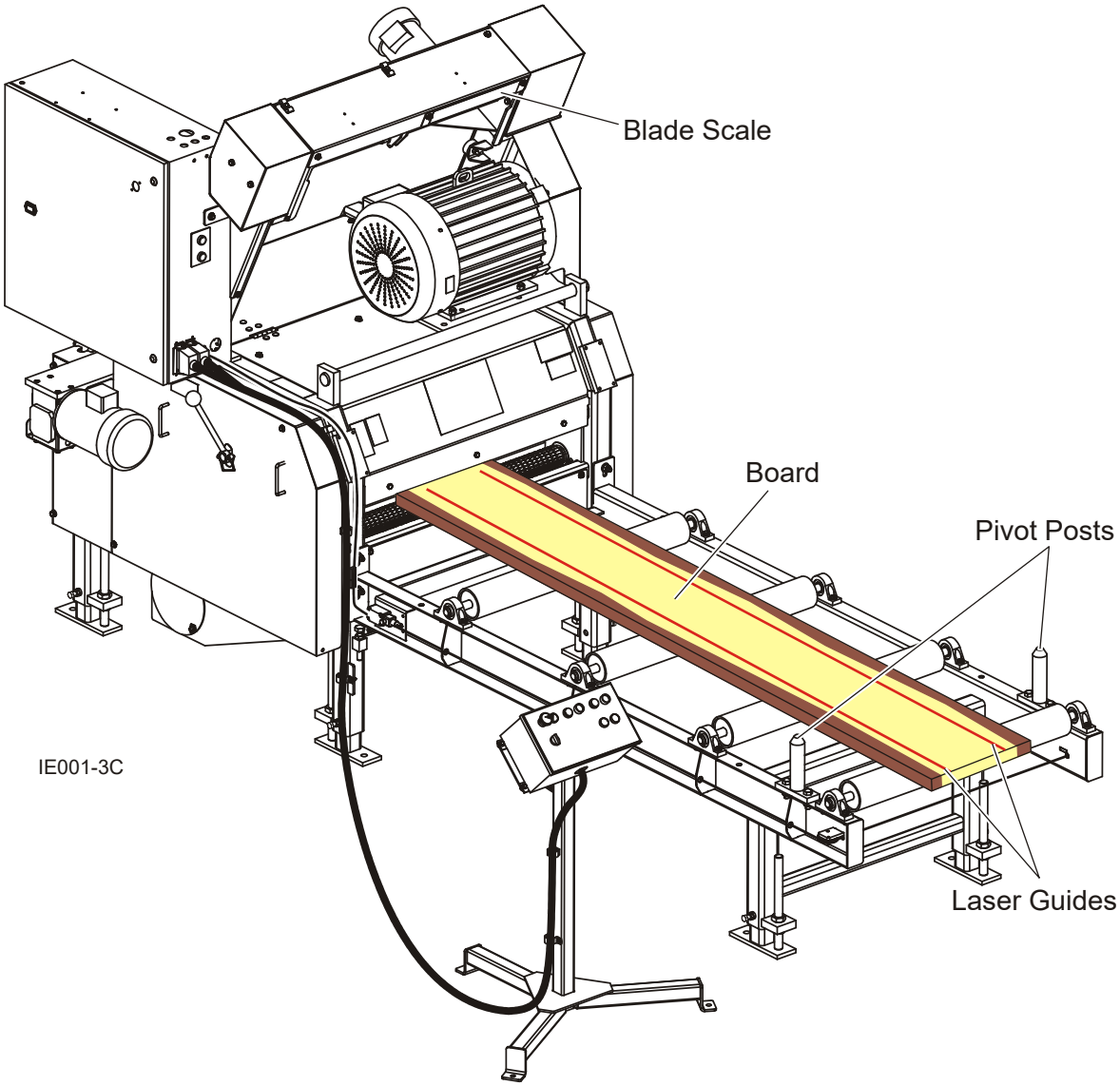


FIG. 3-9

3. Use the blade adjustment button on the control panel to move the blades as desired. The laser lights will show the path of the blade. Use the top scale located on the laser guide housing to determine the width of cut. **NOTE:** If the edger is equipped with the optional LED display, use the display unit to determine the width of cut.

   NOTE: If the edger is equipped with the optional Setworks, you can use the preset buttons to move the blades to the desired width. Use the optional LED display to check the current width of cut. *Section 3.6 Setworks Setup & Operation (Optional)* for details.

4. Start the blade motors and the feed motor. Push the board into the edger until the feed system takes the board.

5. Repeat the above procedures for all boards to be edged.

6. Shut down the machine when done edging.

3.6 Setworks Setup & Operation (Optional)

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

WARNING! Always check the control box mounted and cable activated Emergency Stop switches for proper operation prior to each use of the machine. Failure to do so may result in serious injury.

Setworks Calibration

The Setworks may need to be calibrated before operating the edger. To calibrate the Setworks, push the MACHINE START button on the control box to turn the edger power on. **NOTE:** The covers and the electrical cabinet must be closed before starting the edger.

Use the BLADES IN or BLADES OUT buttons to move the blades until they are exactly 10" (254mm) apart. Press and hold the FEED START and FEED STOP buttons simultaneously until the display shows "10" (or “254mm”). The Setworks is now calibrated and ready to operate.

Setworks Enable/Disable

It is possible for the operator to enable or disable the Setworks, if necessary. To enable or disable the Setworks, turn the edger power on.

Software version 4.6+: To enable Setworks in imperial units, press and hold the PRESET #1 & the FEED STOP buttons simultaneously for 10 seconds until the display reads “Imperial Setworks Enabled”. To enable Setworks in metric units, press and hold the PRESET #2 & the FEED STOP buttons simultaneously for 10 seconds until the display reads “Metric Setworks Enabled”. To disable Setworks, press and hold the PRESET #3 & the FEED STOP buttons simultaneously for 10 seconds until the display reads “Setworks Disabled”.

Software versions prior to 4.6: Press and hold the FEED START button until the display shows "10"" to operate the Setworks using imperial (fractional) values. To operate the Setworks using metric values, press and hold the FEED STOP button until the display shows "254mm". To disable the Setworks, press and hold the BLADES IN button until all the preset button lights go out. After changing the status of the Setworks it is necessary to turn the edger off and back on. This ensures that all the systems have been reset completely.

Setworks Operation

To use the Setworks when operating the edger:

1. Push the MACHINE START button on the control box to turn the edger power on, if necessary.
2. Enable the Setworks as described above, if necessary.
3. Turn the laser guides on by turning the LASER switch to the ON position.
4. Press one of the six Setworks switches on the control box to adjust the position of the blades. Pressing the preset button will move the blades to the position already programmed into the button. Use the optional LED display to check the current width of cut.
5. Push the BLADES START button to start the edger blades.
6. Push the FEED START button to start the edger feed system.

Setworks Programming

The Setworks default values are programmed in the factory but can be easily reprogrammed by the edger operator.

See Table 3-4. The default values of the preset buttons are shown below.

Setworks Button #	Imperial	Metric
Preset 1	8"	203mm
Preset 2	10"	254mm
Preset 3	12"	305mm
Preset 4	14"	356mm
Preset 5	16"	406mm
Preset 6	18"	457mm

TABLE 3-4

To reprogram the Setworks preset buttons:

1. Use the BLADES IN or BLADES OUT buttons to move the blades to the desired position.

2. Press and hold one of the Setworks buttons for 3 seconds. While the new value is being stored the preset light indicator will be off. When the value is stored the light indicator will turn on.

3. Repeat steps 1-2 for the remaining preset buttons.

3.7 Remote Operation (Optional)

The 6-button remote transmitter is used to change the width of cut on the edger as necessary. To move the blades to the desired position, press one of the buttons on the remote transmitter. **NOTE:** If the Edger is not equipped with the optional Setworks, buttons #5 and #6 are the only functioning buttons on the remote transmitter. Press the button #5 to move the blades in; press the button #6 to move the blades out.

See Figure 3-10. The 6-button remote transmitter is shown below.

FIG. 3-10

NOTE: If the Edger is equipped with the optional Setworks, the remote buttons 1-4 have the same preset values programmed as the values stored in the Setworks preset buttons 1-4 on the operator control box.

See Table 3-5. The default values of the remote transmitter buttons when the Edger is equipped with the optional Setworks are shown below.

Remote Button #	Imperial	Metric
Preset 1	8"	203mm
Preset 2	10"	254mm
Preset 3	12"	305mm
Preset 4	14"	356mm
Preset 5	Press to Move Blades In	
Preset 6	Press to Move Blades Out	

TABLE 3-5

The operator can easily change the factory-programmed preset values by using the optional Setworks preset buttons on the control box. To reprogram the Setworks preset buttons:

1. Use the BLADE-IN or BLADE-OUT buttons to move the blades to the desired position.

2. Press and hold one of the Setworks buttons for 3 seconds. While the new value is being stored the preset light indicator will be off. When the value is stored the light indicator will turn on.

3. Repeat steps 1-2 for the remaining preset buttons.

SECTION 4 MAINTENANCE

Refer to the motor manufacturer's manual for maintenance intervals and procedures regarding the power supply unless otherwise instructed in this manual. Follow the manufacturer's recommendations for dusty conditions.

IMPORTANT! This manual only provides information about additional procedures or procedures to be performed at different time intervals than found in the manufacturer's manuals. Refer to the manufacturer's manual for complete maintenance instructions.

4.1 Replacing the Blade Teeth

DANGER! Coastdown Required. Always shut down the edger 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 edger. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

See Figure 4-1. Replace the blade teeth as necessary. Dull blade teeth will cause the motor to work harder and will result in decreased cut quality and accuracy. Blade teeth life will vary depending on maintenance of machine, operator, species of wood being sawn, and condition of wood being sawn. To remove the blade teeth perform the following steps:

- Unbolt and open the rear top blade guard. Make sure the guard is secured properly during the blade tooth replacement procedure.

- Lift the upper idle roller with a rod. To do so, insert the rod into the slot on the right side of the upper idle roller. Make sure the roller rests safely before starting the blade tooth replacement procedure.

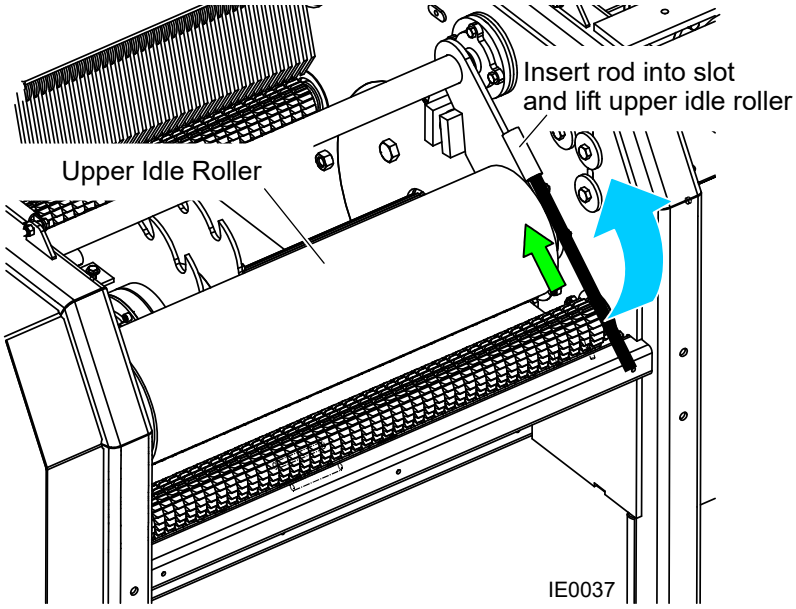


FIG. 4-1

- Place the blade tooth replacement tool on the blade tooth to be removed. Secure the replacement tool with the locking pin, so that the longer end of the locking pin comes both through the lower hole in the replacement tool and the hole in the blade tooth.

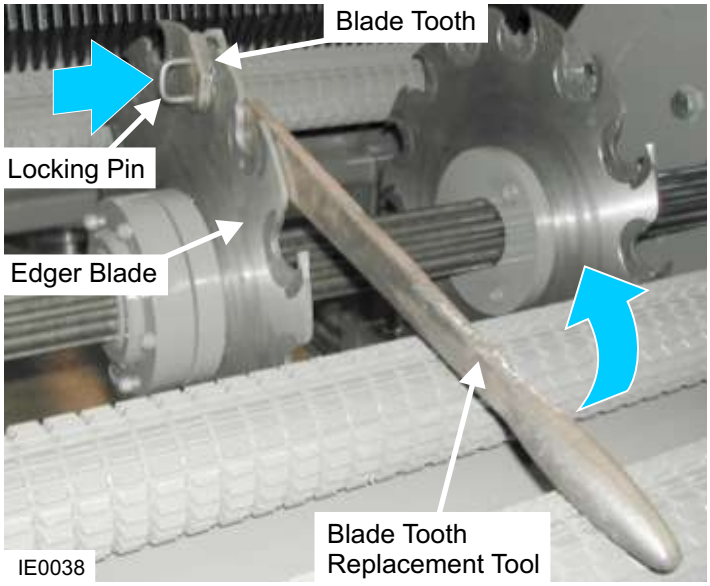


FIG. 4-1

- Remove the blade tooth by moving the replacement tool handle upwards.

To replace the blade tooth perform the following steps:

- Install the new blade tooth in the blade tooth replacement tool. Secure the blade tooth to the replacement tool with the locking pin.
- Place the replacement tool on the blade where the blade tooth is to be installed.
- Move the replacement tool downwards to install the new blade tooth in place.
- Remove the locking pin from the replacement tool when done. Remove the replacement tool from the blade.
- Repeat the procedure with the remaining blade teeth.
- Use the rod to lower the idle roller when done.
- Close the rear top blade guard. Secure the guard with the existing bolts.

4.2 Changing the Blades

1. Replace the blades as necessary. **NOTE:** It may be necessary to replace the blades only due to their damage. The blades are equipped with replaceable cutting teeth. *See Section 4.1* to replace the blade teeth.

   DANGER! Before changing the blades, make sure the blades have come to a complete stop and the edger is shut down completely. Failing to do so can cause serious injury.

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

   WARNING! Always wear eye, glove and foot protection when handling saw blades.

2. Unbolt and open the rear top blade guard.

3. Use a supporting strap to keep the shaft in place before removing the blade door assembly on the left side of the edger.

   See Figure 4-2.

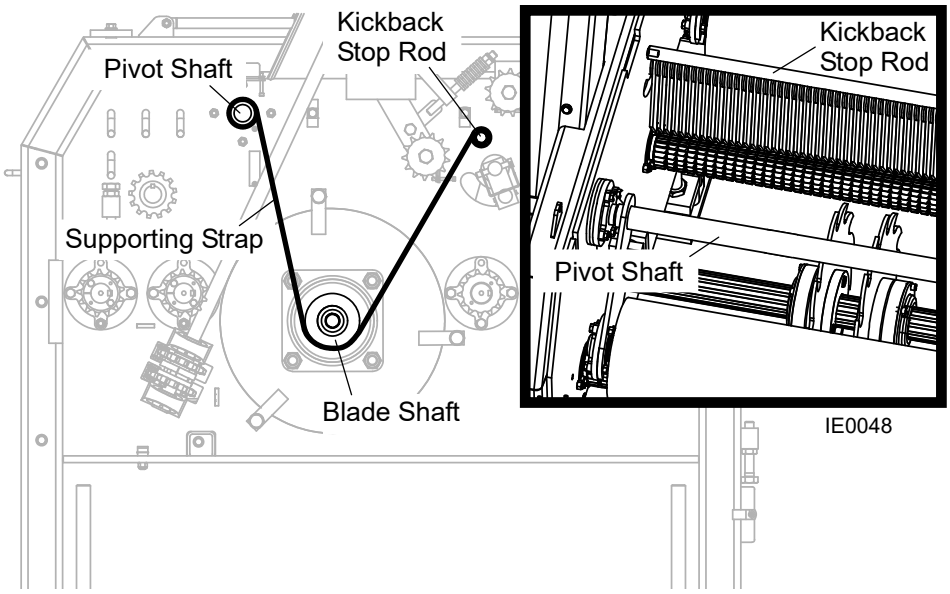


FIG. 4-2

4. Remove the locking nuts securing the right and left blade pushers to the blades. Uninstalled the blade pushers from the blades.

5. Remove the feed drive side removable guard from the Edger.

6. Remove the blade door assembly from the Edger. To remove, first unbolt the blade door assembly. Loosen the retaining bolt and remove the four mounting nuts on the bearing. Pry the blade door assembly from the Edger and remove the door.

   See Figure 4-3.

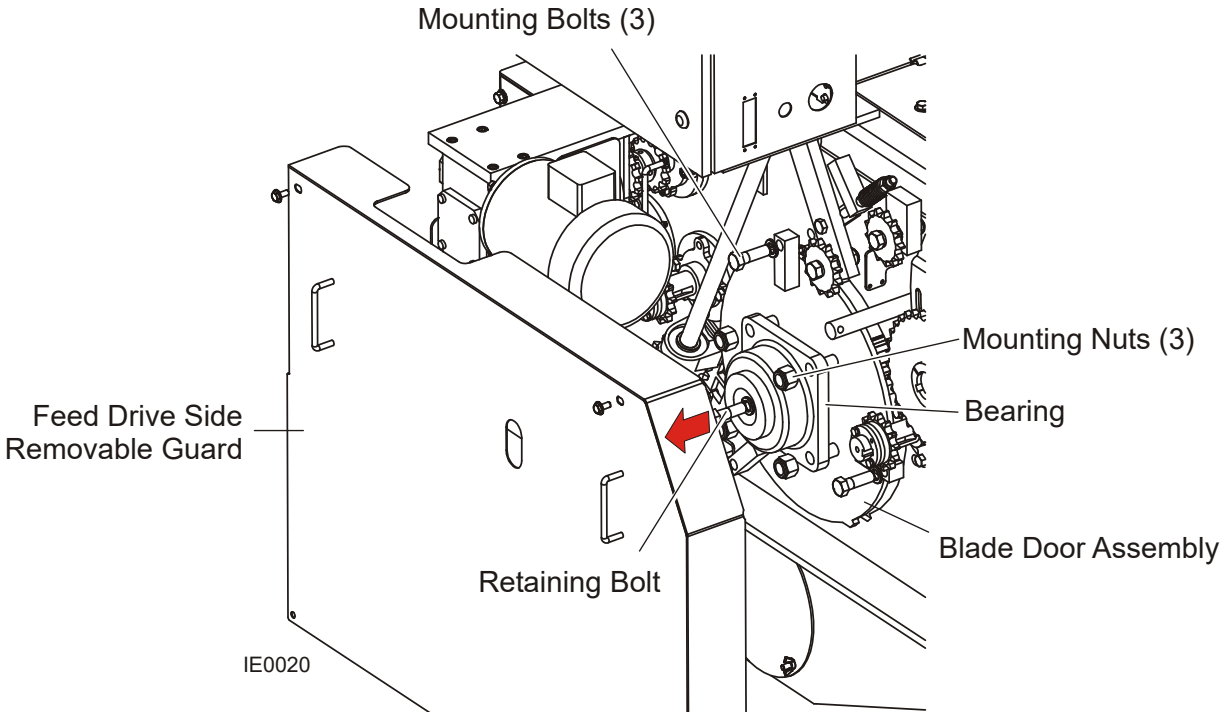


FIG. 4-3

7. Remove the blades from the shaft. Make sure the right and left blade pushers are already uninstalled from the blades and lowered properly.

8. Slide the blades out through the blade door hole. **NOTE:** It can be necessary to raise the shaft 2-3 inches to allow the blades to pass the blade pushers.

   See Figure 4-4.

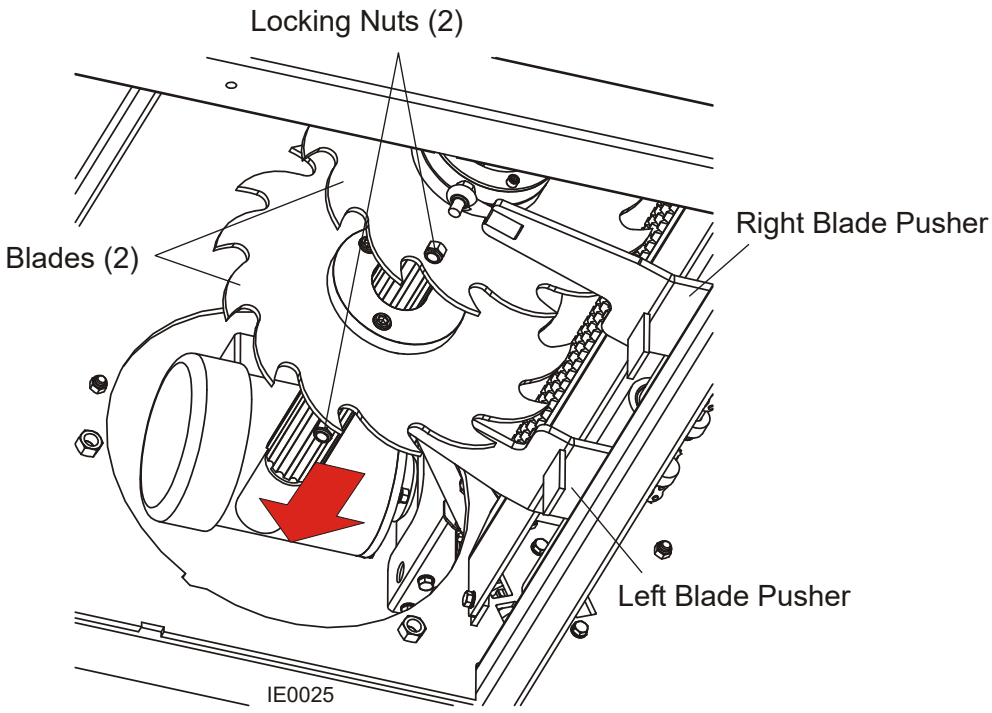


FIG. 4-4

9. Place the new blades on the shaft and position them next to the right and left blade pushers. Install the right and left blade pushers to the blades. Reinstall the blade locking nuts to secure the pushers to the blades.

10. Reinstall the blade door assembly and secure in place with the mounting bolts.

11. Reinstall the blade bearing and retaining bolt. Secure the bearing in place with the existing mounting nuts.

12. Remove the supporting strap from the blade assembly.

13. Close and secure the rear top blade guard.

4.3 Tensioning the Belts

DANGER! Coastdown Required. Always shut down the edger 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 edger. 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.

8

1. Check the drive belt for wear every 8 hours of operation and more frequently during the first 24-48 hours of operation. Tension or replace as necessary. Tension should be 1/2" deflection with 16 lbs of force for new belts or 1/2" deflection with 11 lbs of force for used belts.

See Figure 4-5. To tension the drive belt:

- Unbolt and open the blade drive side removable guard.
- Loosen the motor mounting nut securing the adjustment bolt.
- Use the adjustment bolt as shown below to move the motor mount up or down until the belt is properly tensioned.

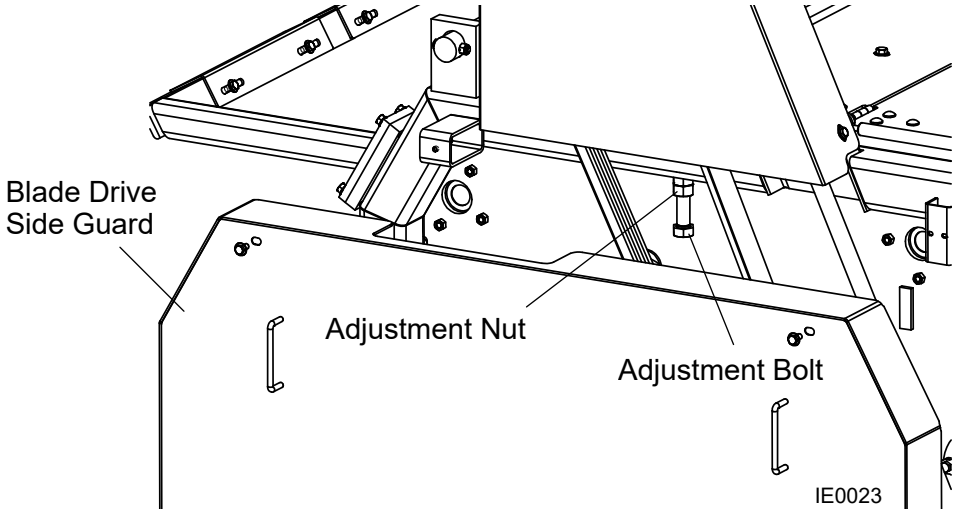


FIG. 4-5

CAUTION! Do not over tighten the drive belt as it can cause premature belt and/or bearing failure.

CAUTION! Do not under-tighten the drive belt as it can cause one or all of the following damages: slippage of the belt on the drive pulley, binding or fetching up of the saws while in the cut, damage or bending of saws

- Retighten the motor mounting nut when done.
- Close and secure the blade drive side removable guard.

2. Check the laser light box timing belt for wear every 8 hours of operation. Tension or replace as necessary. The belt tensioner should be adjusted closely enough to remove any belt slack. Do not overtighten.

   See Figure 4-6. To tension the laser light box belt:

   - Locate the adjustment pulley in the laser light box. Loosen the mounting nut securing the adjustment pulley.
   - Push the adjustment pulley up or down until the belt is tensioned as needed.

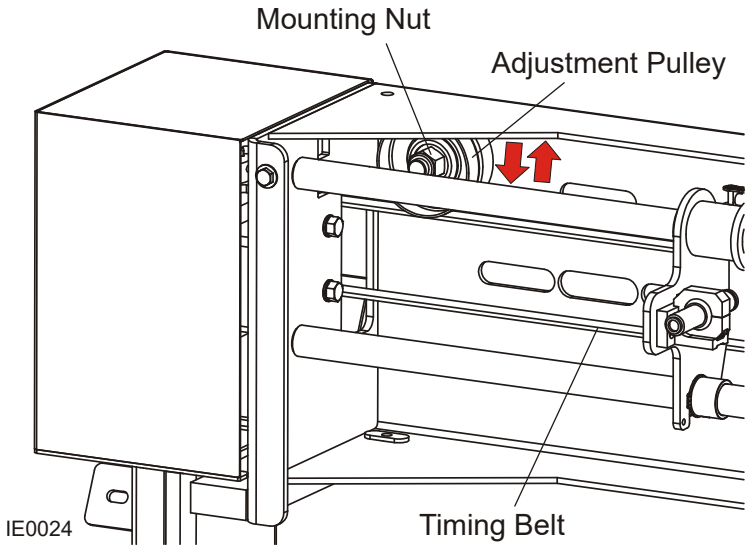


FIG. 4-6

   - Retighten the adjustment nut to secure the adjustment pulley when done.

4.4 Tensioning the Chains

DANGER! Coastdown Required. Always shut down the edger 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 edger. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

IMPORTANT: It is necessary to tension the outfeed drive chain first before tensioning the infeed drive chain.

See Figure 4-7. Refer to the following diagram for chain routing instructions.

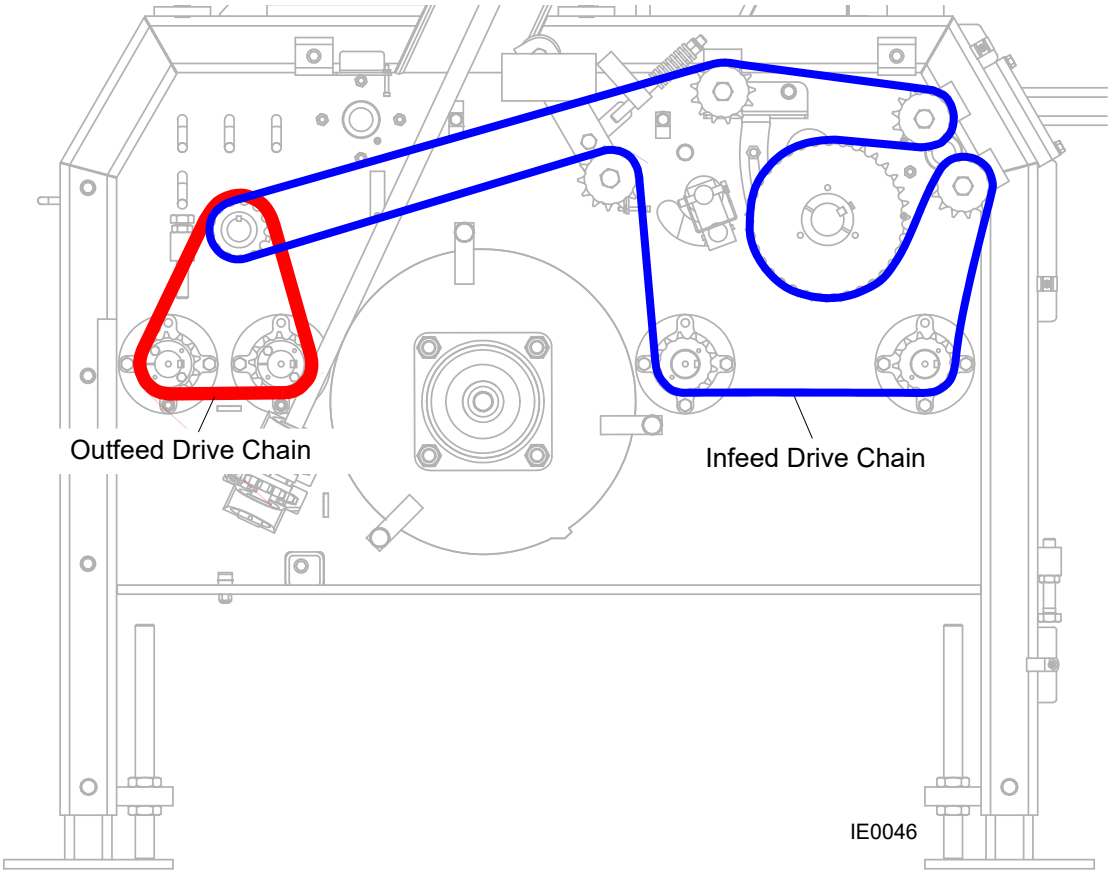


FIG. 4-7

See Figure 4-8. To tension the outfeed drive chain:

- Unbolt and open the feed side fixed guard.

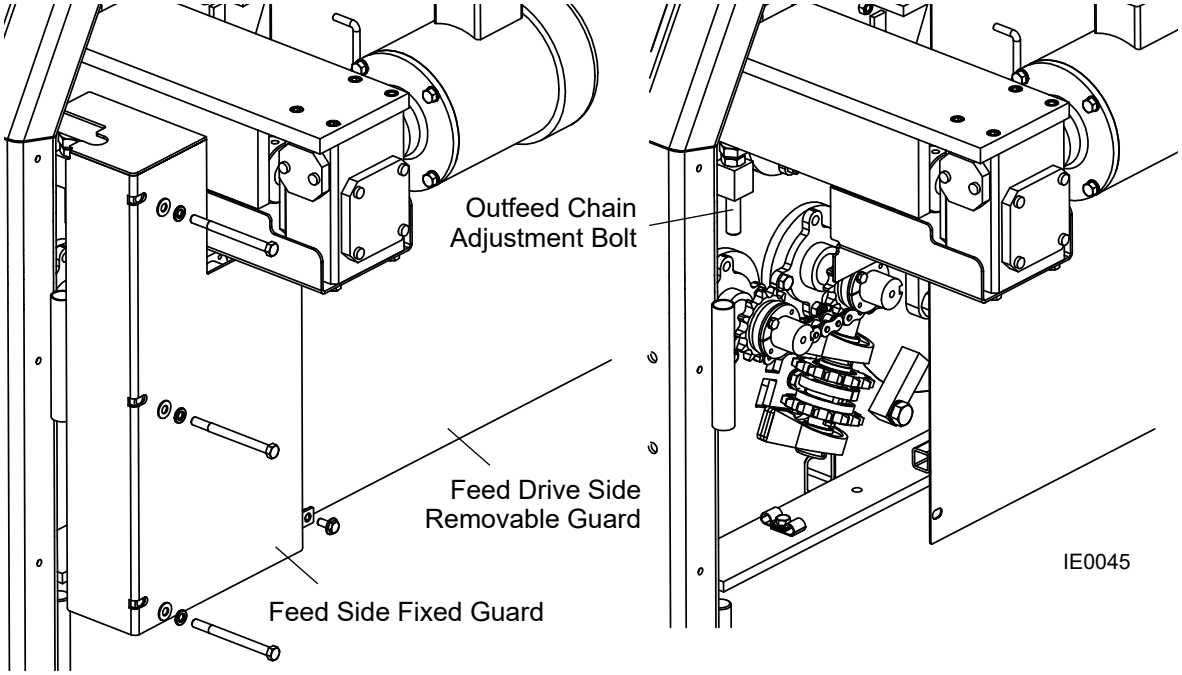


FIG. 4-8

- Loosen the four bolts securing the edger feed drive assembly to the edger frame.
- Rotate the adjustment bolt below the edger feed drive assembly clockwise/counter-clockwise until the outfeed drive chain is tensioned as needed. The outfeed chain total deflection should not exceed 1/4" in the center of the chain between the sprockets.
- Tighten the four bolts mounting the edger feed drive assembly to the edger frame.
- Close and secure the feed side fixed guard.

See Figure 4-9. To tension the infeed drive chain, unbolt and open the feed drive side removable guard.

- Use the adjustment nut on the drive chain tensioner until the drive chain is tensioned as needed. The total deflection of the spring should be from 3/8" to 1/2".

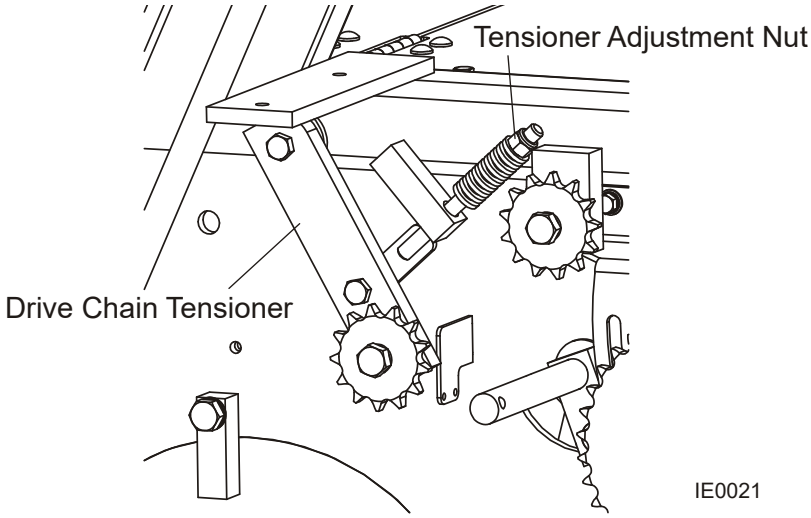


FIG. 4-9

- Close and secure the feed drive side removable guard when done.

40

Check the laser drive chains for tension every 40 hours of operation and tension as necessary. Remove the chain slack but do not overtighten. The properly adjusted chain should have 1/4" to 3/8" vertical deflection when applying 6 to 8 pounds of force.

See Figure 4-10. To tension the laser drive chain, use the two adjustment nuts at the rear of each laser assembly until the chain is tensioned as needed.

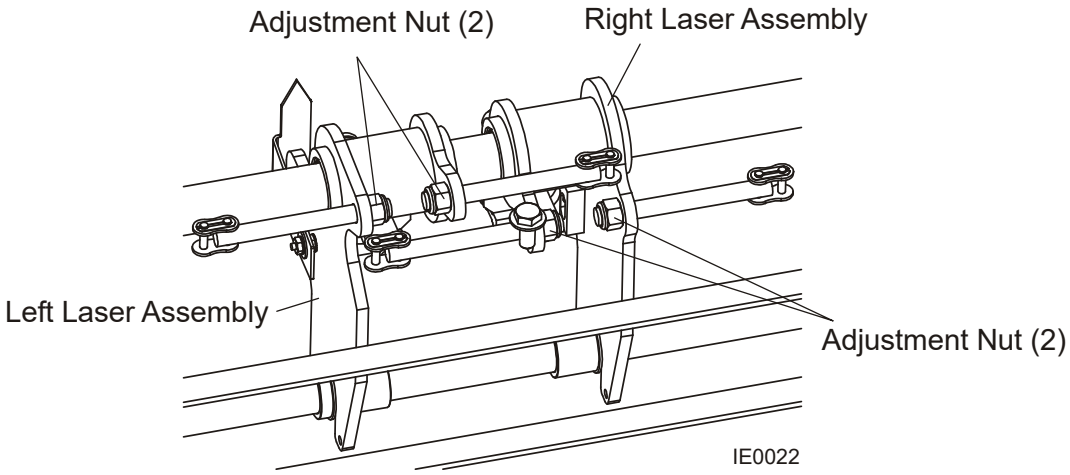


FIG. 4-10

4.5 Checking the Rollers

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

4.6 Lubrication

8 **1.** Use a soft cloth to clean any debris from the blade drive shaft every 8 hours of operation.

200 **2.** Lubricate the blade shaft bearings every 200 hours of operation with one to two pumps of lithium-based grease such as Shell Alvania No. 3. Do not overgrease.

200 **3.** Lubricate the roller bearings every 200 hours of operation with a high-quality lithium-based grease such as Shell Alvania No. 3.

4.7 Feed Rate

See Table 4-1. The feed rate can be readjusted. There are three possible feed rates depending on the board thickness. The factory setting is shown below.

Board Thickness	Average Feed Rate (ft./min.)
Up to 1.5"	111
1.5"-4"	78
4"	44

TABLE 4-1

The feed rate can be readjusted by changing the position of two proximity switches located under the feed drive side removable guard.

DANGER! Coastdown Required. Always shut down the edger 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 edger. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

See Figure 4-11. To change the position of the proximity switch, remove the anti-kick-back lever and feed drive side removable guard from the Edger.

- Loosen the nuts securing the proximity switches to the mount bracket.

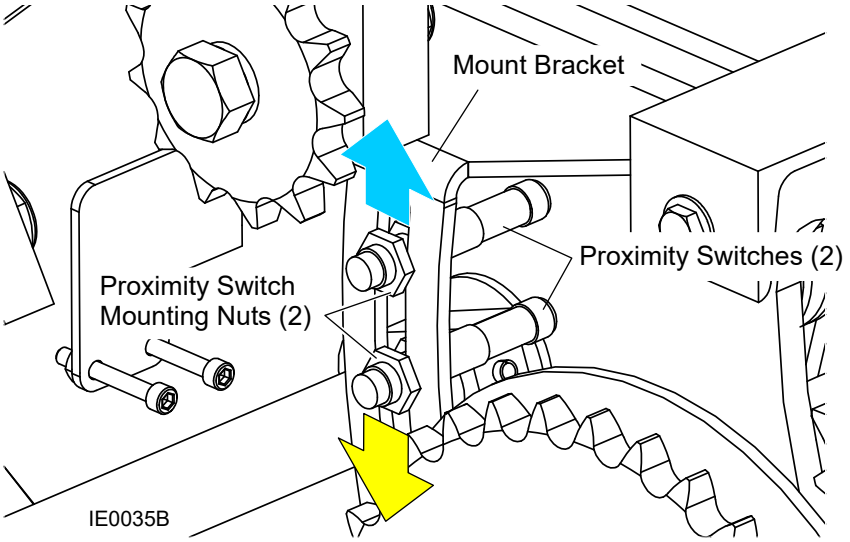


FIG. 4-11

- Move the proximity switches to a desired position.
- Tighten the nuts on the proximity switches and secure in place.
- Reinstall the feed drive side removable guard and anti-kickback lever to the Edger.

4.8 Maintaining and Sharpening Anti-Kickback Fingers

This machine has the potential for kick-backs. Kick-backs can cause the board to be suddenly and uncontrollably hurled towards the operator. Such action can result in severe injury or death.

If you are working with frozen boards or with boards that have protruding knots, the chance of kickbacks is increased.

The infeed opening of the Industrial Edger is equipped with anti-kickback fingers to help prevent kickback from occurring. To maintain the safety of your Edger, periodically inspect the machine to ensure all anti-kickback fingers are intact and undamaged and have a sharp point. Missing or damaged parts can affect the safety of the machine operator or bystanders and should be replaced immediately. Dulled parts should be re-ground with a hand grinder or replaced.

DANGER! Always ensure that there is a sharp point on the anti-kickback fingers before each use of the Edger.

Be sure anti-kickback fingers are free from obstruction and are in a downward position with lever released. Failure to do so may result in serious injury.

4.9 Laser Guides Alignment

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.

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

1. Open the blade housing cover to access the edger blades.

2. Run a straight edge from the front of the Edger frame to the back. Put the straight edge next to the blade and make sure it is parallel to the blade.

   See Figure 4-12.

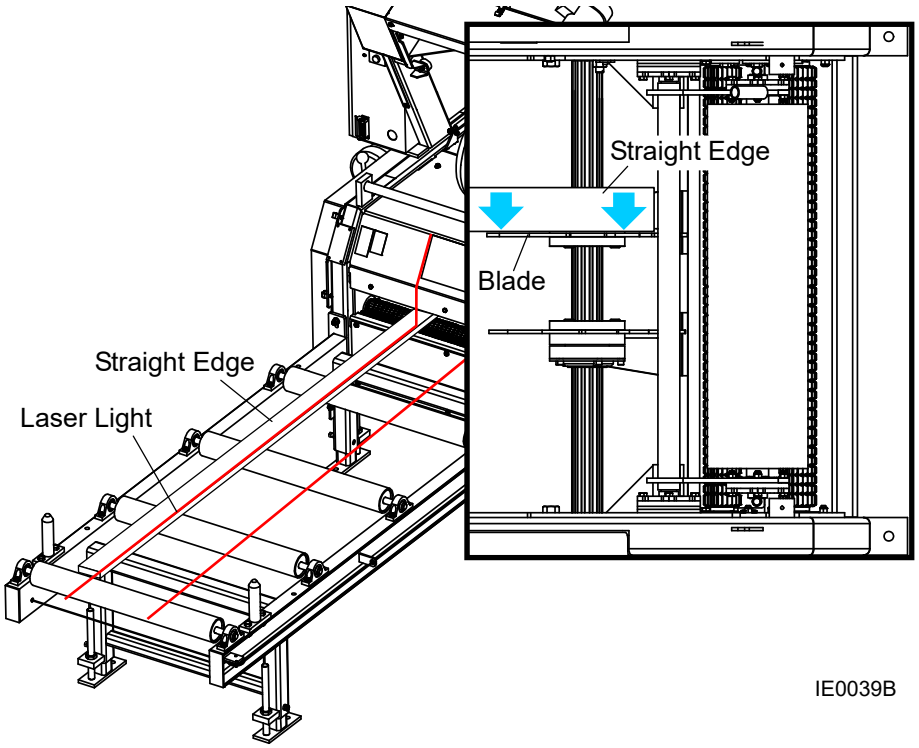


FIG 4-12

3. Turn on the edger and check the position of the laser lights on the straight edge. Adjust the laser guides if necessary. Read below for laser adjustment procedures.

4. To move the laser light up or down, loosen the nut on the slotted screw securing the laser to the guide assembly.

5. Move the rear part of the laser guide assembly up or down to put the laser light closer or further away from the edger main frame.

   See Figure 4-13.

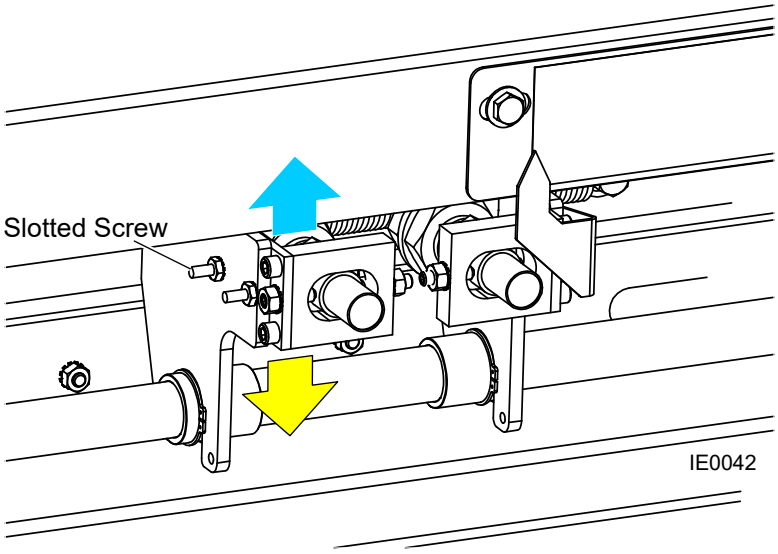


FIG 4-13

6. Make sure the laser light lays down on all four infeed table rollers.

7. Tighten the nut on the slotted screw when finished.

8. To move the laser light right or left, loosen two set screws located on both sides of the laser guide. Tighten the left set screw to move the laser guide to the left side. Tighten the right set screw to move the laser guide to the right side.

   See Figure 4-14.

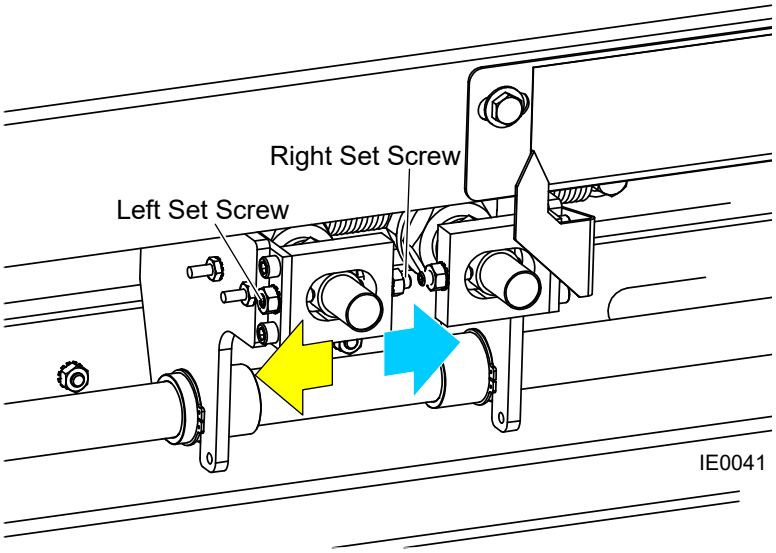


FIG 4-14

9. Check if the laser light is parallel to the straight edge.

10. Secure both set screws in place when finished.

11. To move the laser light when slanted, use the laser guide adjustment nut on the laser guide assembly. Turn the adjustment nut clockwise to move the laser light as shown below and check the laser light position. Turn the adjustment nut counterclockwise to move the laser light to the opposite directions as shown below and check the laser light position. Make sure the laser light is parallel to the straight edge.

See Figure 4-15.

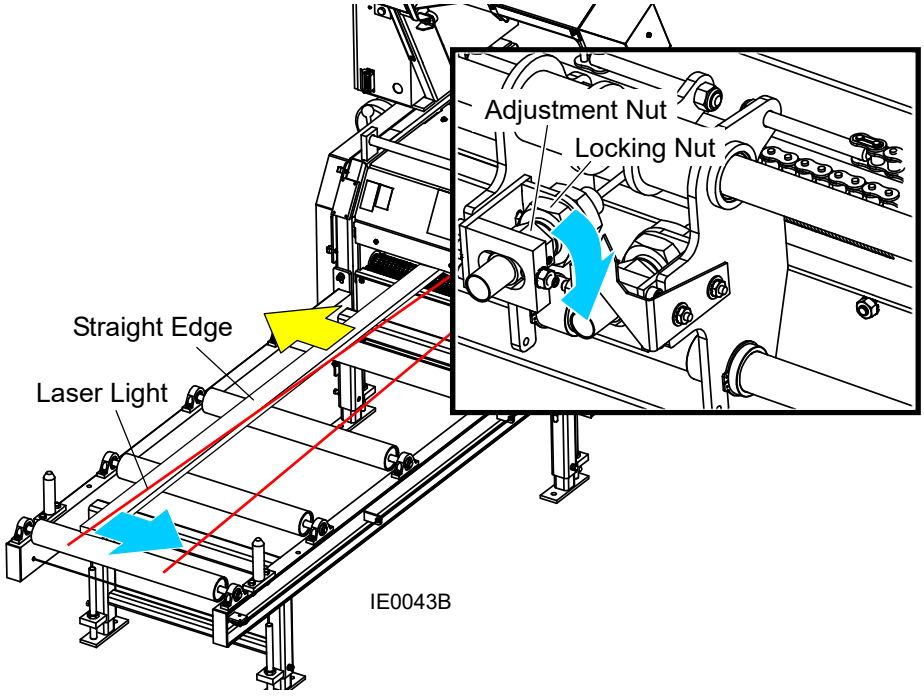


FIG 4-15

12. Repeat the steps above to align the other laser guide assembly if necessary.

4.10 Table Fence Alignment

E430 Rev. A1.00 - A1.04 Only

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

WARNING! Coastdown Required. Always shut down the edger 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 edger. Follow the lockout procedure provided in the safety section (*See Section 2.2*). Failure to do so may result in serious injury.

1. Open the blade housing cover to access the edger blades.

2. Run a straight edge from the front of the Edger frame to the back. Put the straight edge next to the blade. Make sure the straight edge is parallel to the blade.

   See Figure 4-16.

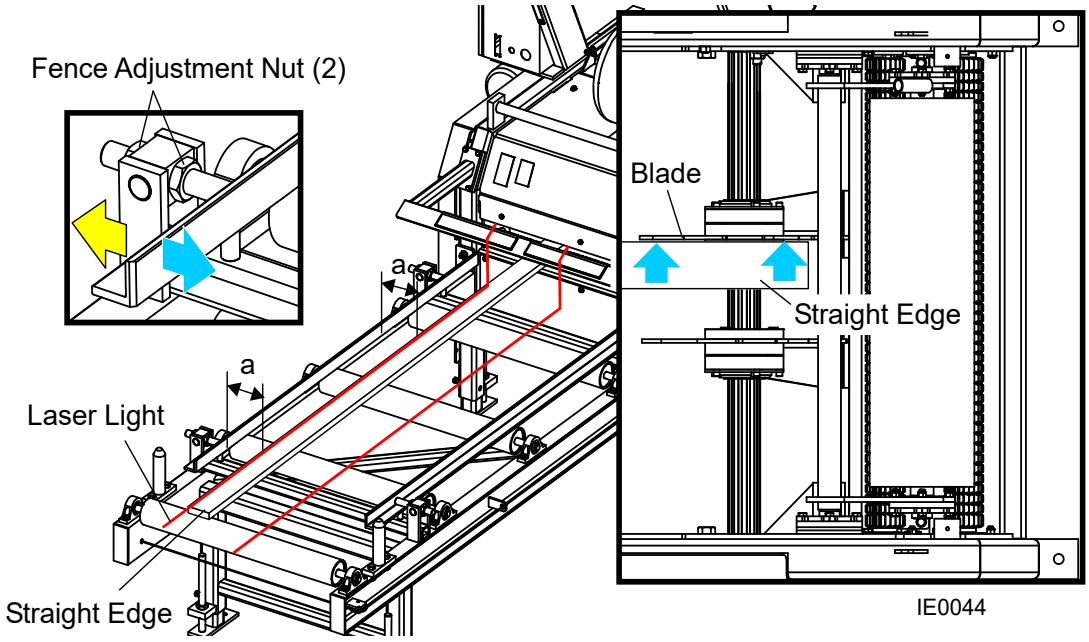


FIG 4-16

3. Turn on the edger and check if the laser lights are aligned correctly. Perform the Laser Guide Alignment procedure if necessary. (*See Section 4.9*)

4. Measure the distance from the straight edge to the fence at the front and rear of the infeed table. Use the fence adjustment nuts (2) to adjust the front fence parallel with the laser light. Make sure the distance on the scale shows the correct distance from the straight edge to the fence.

5. Tighten the fence adjustment nuts when done.

6. Repeat the steps above to adjust the other table fence.

MAINTENANCE LOG

Inspect/replace blade teeth or blade	See Section 4.1 See Section 4.2	Daily	DAILY MAINTENANCE PROCEDURES
Check drive/laser timing belts for wear and tension [1]	See Section 4.3	Daily	
Check infeed rollers	See Section 4.5	Daily	
Check blade drive shaft	See Section 4.6	Daily	
Inspect kickback fingers	See Section 4.8	Daily	

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		40 HRS	80 HRS	120 HRS	160 HRS	200 HRS	240 HRS	280 HRS	320 HRS	360 HRS	400 HRS
Check feed/laser drive chain tension	See Section 4.4										
Lubricate blade shaft and roller bearings	See Section 4.6										

[1] Check more frequently during the first 24-48 hours of operation.

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		440 HRS	480 HRS	520 HRS	560 HRS	600 HRS	640 HRS	680 HRS	720 HRS	760 HRS	800 HRS
Check feed/laser drive chain tension	See Section 4.4										
Lubricate blade shaft and roller bearings	See Section 4.6										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		840 HRS	880 HRS	920 HRS	960 HRS	1000 HRS	1040 HRS	1080 HRS	1120 HRS	1160 HRS	1200 HRS
Check feed/laser drive chain tension	See Section 4.4										
Lubricate blade shaft and roller bearings	See Section 4.6										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1240 HRS	1280 HRS	1320 HRS	1360 HRS	1400 HRS	1440 HRS	1480 HRS	1520 HRS	1560 HRS	1600HRS
Check feed/laser drive chain tension	*See Section 4.4*										
Lubricate blade shaft and roller bearings	*See Section 4.6*										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1640 HRS	1680 HRS	1720 HRS	1760 HRS	1800 HRS	1840 HRS	1880 HRS	1920 HRS	1960 HRS	2000 HRS
Check feed/laser drive chain tension	*See Section 4.4*										
Lubricate blade shaft and roller bearings	*See Section 4.6*										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2040 HRS	2080 HRS	2120 HRS	2160 HRS	2200 HRS	2240HRS	2280 HRS	2320 HRS	2360 HRS	2400 HRS
Check feed/laser drive chain tension	*See Section 4.4*										
Lubricate blade shaft and roller bearings	*See Section 4.6*										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2440 HRS	2480 HRS	2520 HRS	2560 HRS	2600 HRS	2640HRS	2680 HRS	2720 HRS	2760 HRS	2800 HRS
Check feed/laser drive chain tension	*See Section 4.4*										
Lubricate blade shaft and roller bearings	*See Section 4.6*										

SECTION 5 REPLACEMENT PARTS

5.1 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.

5.2 Sample Assembly

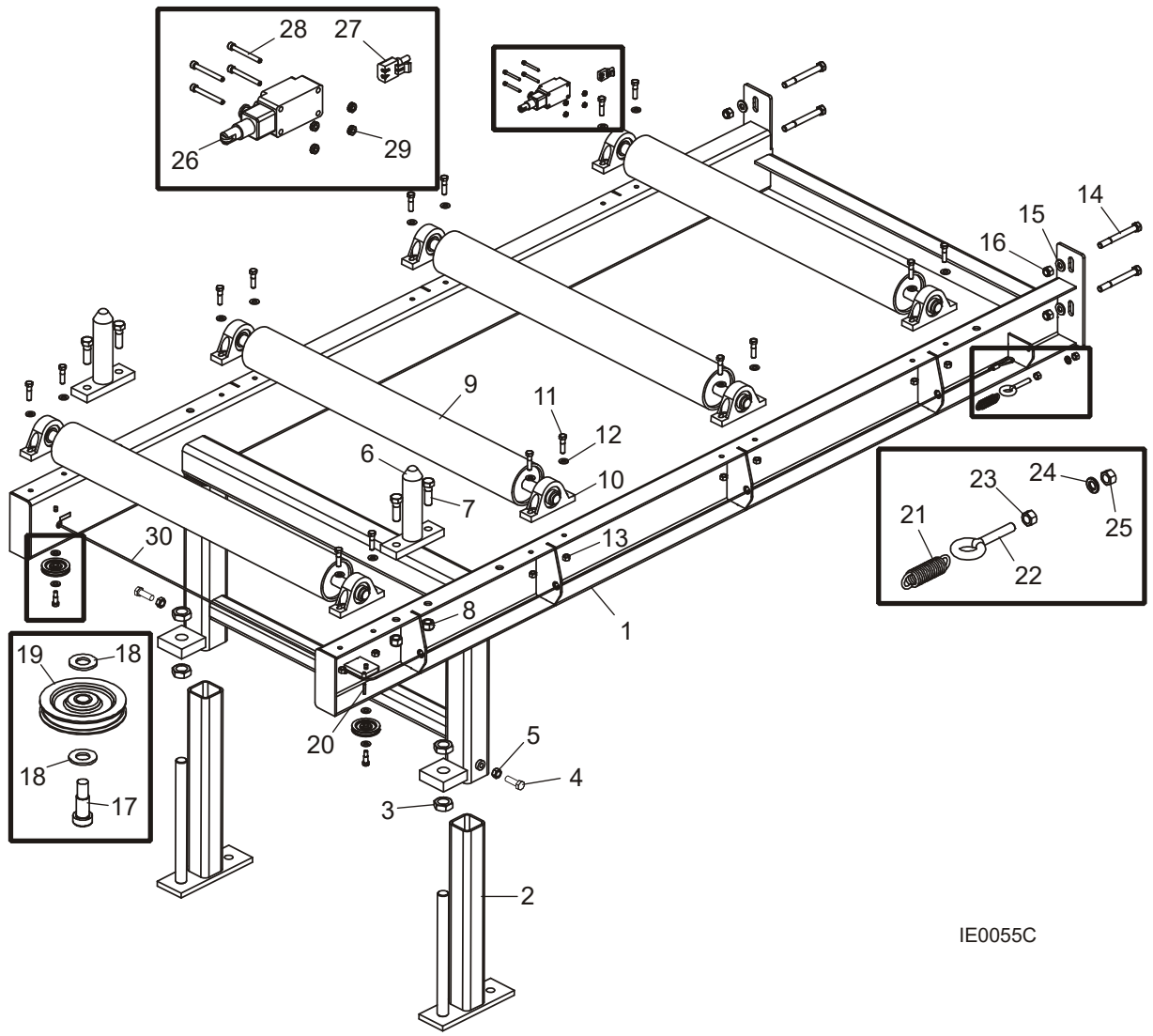
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SAMPLE ASSEMBLY, COMPLETE (Includes All Indented Parts Below)	A01111	1	
1	Sample Part	F02222-22	1	
2	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
	Sample Part (Indicates Part Is Only Available With A03333)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

5.3 Infeed Table Assembly

E430 ***Rev. A3.00 - A4.00***
EG400 ***Rev. A4.00+***



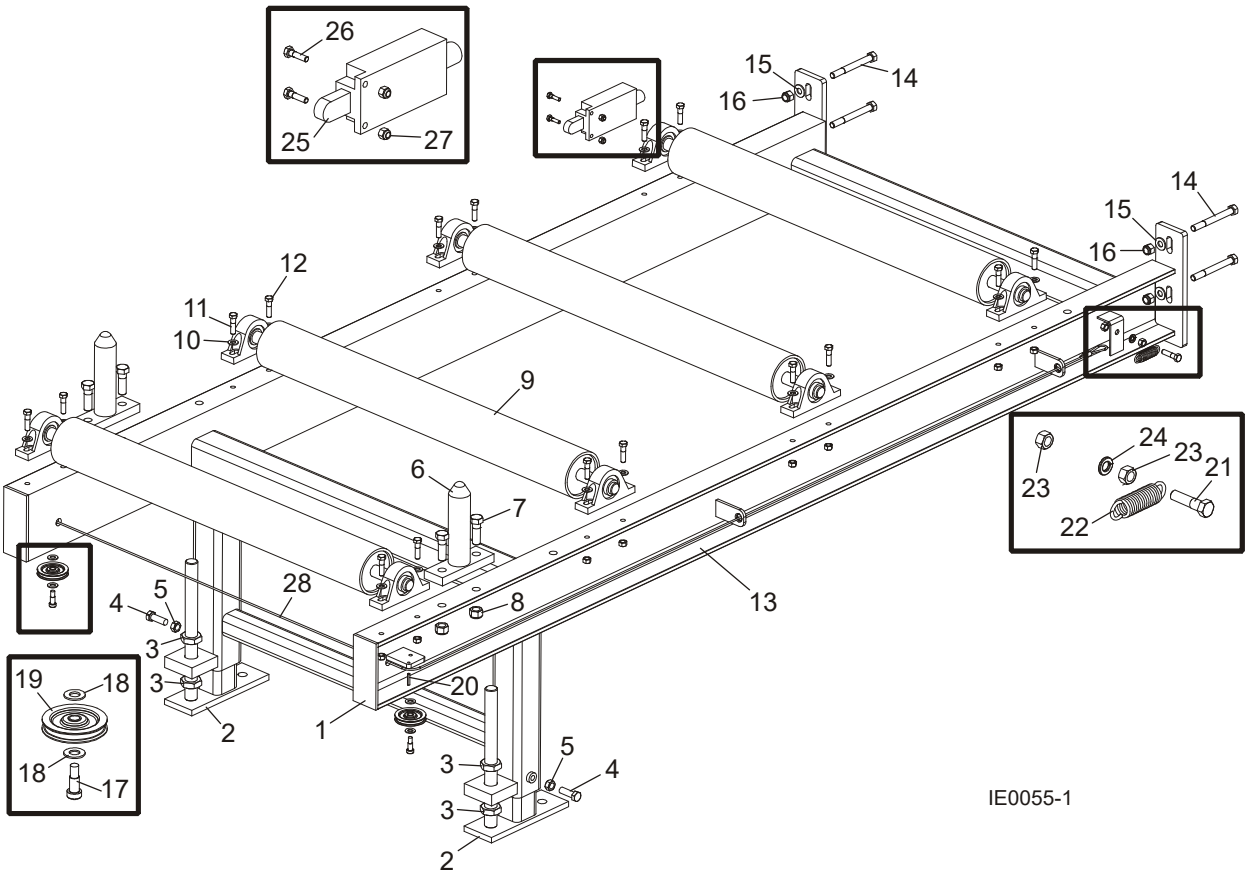
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	INFEED ASSEMBLY, EDGER	039142	1	
1	Frame Weldment, Infeed	039133	1	
	Foot Assembly, Edger	039143	2	
2	Foot Weldment, Edger	039115	1	
3	Nut, 1-14 Hex Jam	F05010-118	2	
4	Bolt, 1/2-13 x 1 1/2" Hex Head Grade 5	F05008-33	2	
5	Nut, 1/2-13 Free Hex	F05010-35	2	
6	Shaft Weldment, Board Pivot	039118	2	

7	Bolt, 5/8-11 x 2" Hex Head Grade 2	F05009-2	4	
8	Nut, 5/8-11 Nylon Lock	F05010-34	4	
	Roller Assembly, Infeed	039140	4	
9	Roller Weldment, Infeed	039122	1	
10	Bearing, 1 Pillow Block Lock	039141	2	
11	Bolt, 3/8-16 x 1 1/2" Hex Head Grade 5	F05007-78	4	
12	Washer, 3/8" Flat	F05011-3	4	
13	Nut, 3/8-16 Swaged	F05010-25	4	
14	Bolt, 1/2-13 x 4 1/2" Hex Head Grade 5	F05008-35	4	
15	Washer, 1/2" SAE Flat	F05011-2	4	
16	Nut, 1/2-13 Nylon Hex Lock	F05010-8	4	
17	Bolt, 3/8" x 5/8" Shoulder	F05007-79	2	
18	Washer, 3/8" Flat	F05011-3	4	
19	Pulley, 2 1/2" Nylon	P07996	2	
20	Pin, 3/16" x 1" Zinc Roll	F05012-11	2	
21	Spring, 3/4 x 2 7/8 x 12 Ga	015479	1	
22	Bolt, 3/8-16 x 2" Turned Eye	F05007-30	1	
23	Nut, 3/8-16 Hex Jam	F05010-29 [1]	1	
24	Washer, 3/8" Split	F05011-4	1	
25	Nut, 3/8-16 Hex	F05010-1 [1]	1	
	Switch Assembly, Perimeter Safety Pull w /Reset	052155	1	
26	Switch, Cable Pull Normal Stop w/Reset	052154	1	
27	Connector, 2P Plug Housing	024262-2	1	
28	Screw, 10-24 x 1 3/4" Socket Head Cap	F05004-192	4	
29	Nut, #10-24 Keps	F05010-14	2	
30	Cable Assembly, Safety Switch	039381	1	

[1] Inner Hex Nut F05010-1 replaced with Jam Nut F05010-29 1/08 to provide additional cable tension adjustment.

5.4 Infeed Table Assembly

E430 ***Rev. A1.00 - A2.00***



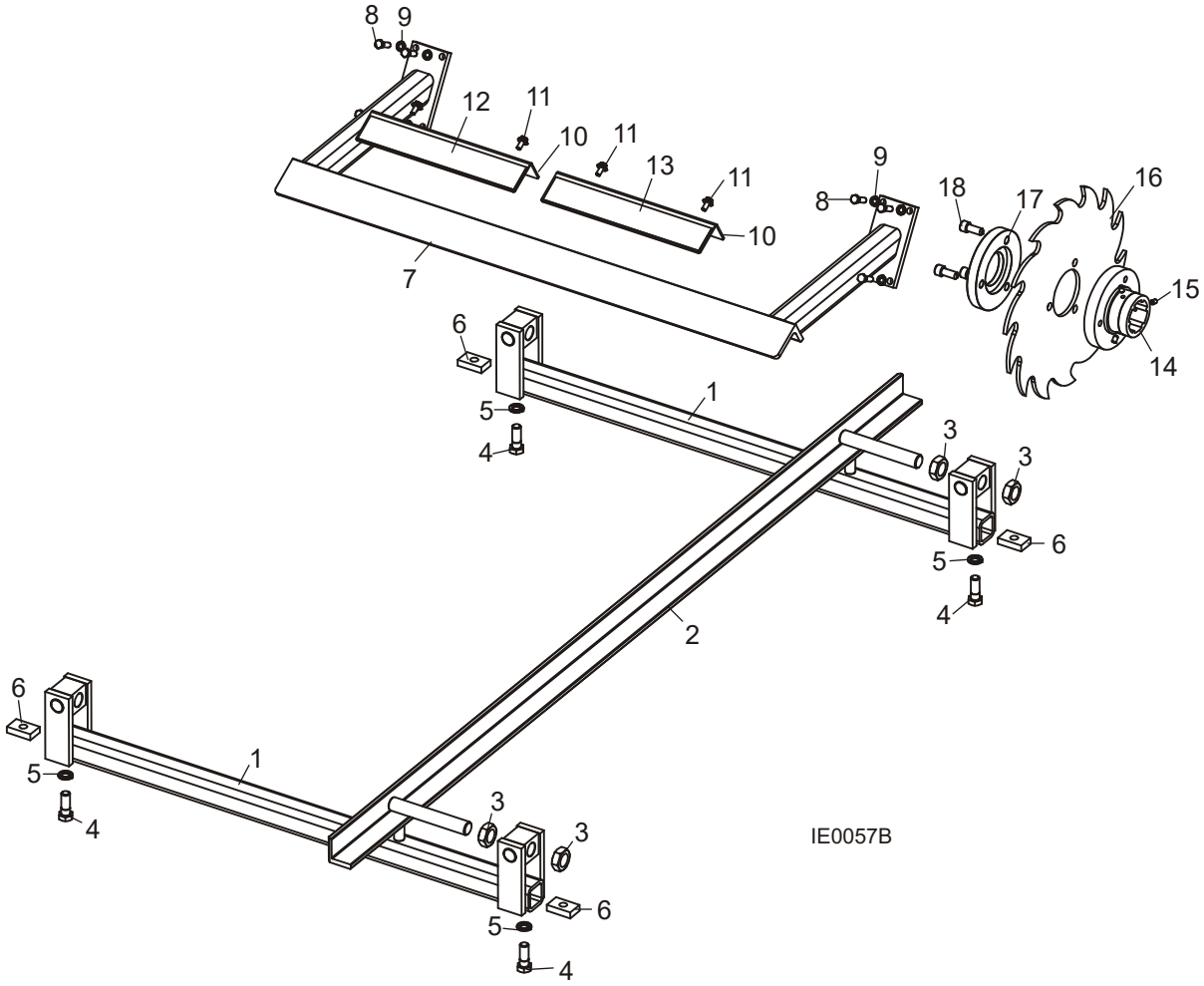
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	INFEED ASSEMBLY, EDGER	039142	1	
1	Frame Weldment, Infeed	039133	1	
	Foot Assembly, Edger	039143	2	
2	Foot Weldment, Edger	039115	1	
3	Nut, 1-14 Hex Jam Zinc	F05010-118	2	
4	Bolt, 1/2-13x1 1/2 Hex Head Grade 5	F05008-33	2	
5	Nut, 1/2-13 Free Hex	F05010-35	2	
6	Shaft Weldment, Board Pivot	039118	2	
7	BOLT, 5/8-11X2 Hex Head Grade 2	F05009-2	4	
8	Nut, 5/8-11 Nylon Lock	F05010-34	4	
	Roller Assembly, Infeed	039140	4	
9	Roller Weldment, Infeed	039122	1	
10	Bearing, 1 Pillow Block SS Lock	039141	2	
11	Bolt, 3/8-16X1 1/2 Hex Head Grade 5	F05007-78	4	

12	Washer, 3/8 Flat	F05011-3	4	
13	Nut, 3/8-16 Swaged	F05010-25	4	
14	Bolt, 1/2-13 x 4 1/2 Hex Head Grade 5	F05008-35	4	
15	Washer, 1/2 SAE Flat	F05011-2	4	
16	Nut, 1/2-13 Nylon Hex Lock	F05010-8	4	
17	Bolt, 3/8 X 5/8 Shoulder	F05007-79	2	
18	Washer, 3/8 Flat	F05011-3	4	
19	Pulley, 2 1/2 Nylon	P07996	2	
20	Pin, 3/16 x 1 Zinc Roll	F05012-11	2	
21	Bolt, 3/8-16 x 1 1/2 Hex Head Grade 5	F05007-78	1	
22	Spring, 3/4 x 2 7/8 x 12 Ga	015479	1	
23	Nut, 3/8-16 Hex	F05010-1 [1]	2	
24	Washer, 3/8 Split	F05011-4	1	
25	Switch Assembly, Perimeter Safety	051300	1	
26	Bolt, 1/4-20 x 1 Hex Head Grade 5	F05005-101	2	
27	Nut, 1/4 Nylon	F05010-69	2	
28	Cable Assembly, Safety Switch	039381	1	

[1] Inner Hex Nut F05010-1 replaced with Jam Nut F05010-29 1/08 to provide additional cable tension adjustment.

5.5 Infeed Table Fence And Scales

E430 ***Rev. A2.00 - A4.00***



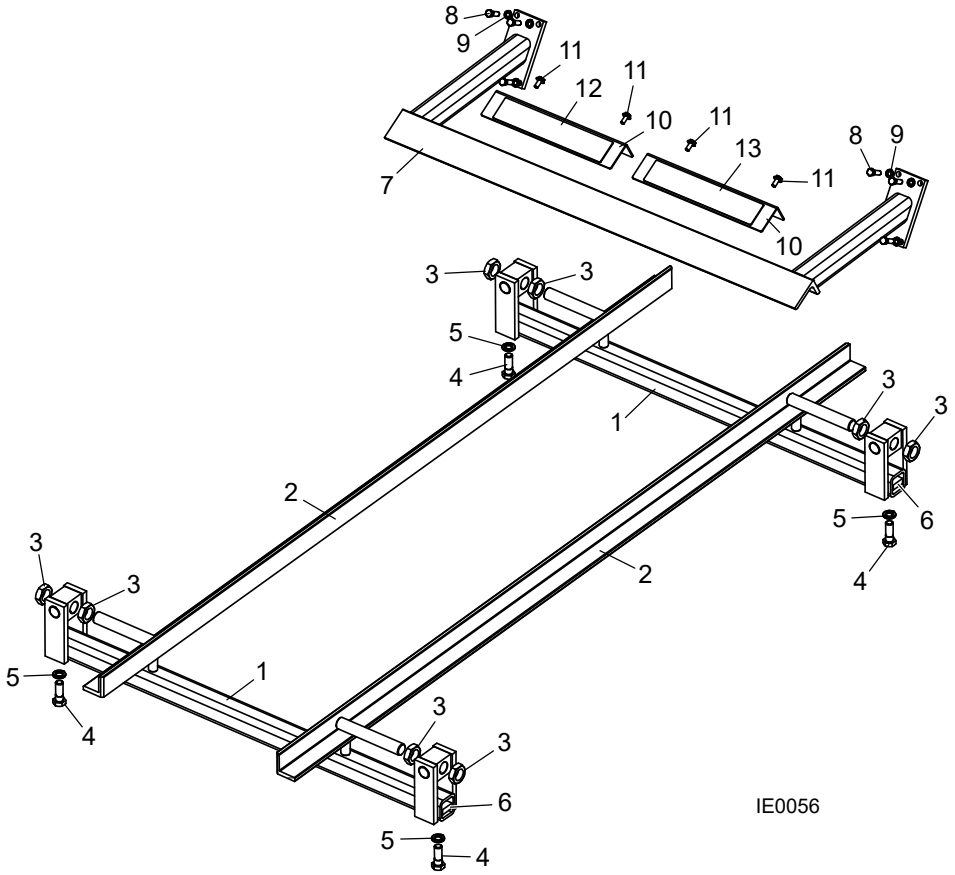
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	FENCE ASSEMBLY, E430 (OPTIONAL)	036681	1	
1	Mount Weldment, Fence	039119	2	
2	Fence Weldment, Edger	039120	1	
3	Nut, 1-14 Hex Jam ZinC	F05010-118	4	
4	Bolt, 5/8-11 x 1 3/4 Hex Head	F05009-33	4	
5	Washer, 5/8 Split Zinc Lock	F05011-27	4	
6	Block, Infeed Adjust	039042	4	
	Scale Assembly, Fence	039363	1	
7	Mount Weldment, Scale	039162	1	
8	Bolt, 3/8-16 x 1 1/4 Hex Head Gr5	F05007-123	8	
9	Washer, 3/8 Split	F05011-4	8	

10	Plate, Fence Scale Mount	039362	2	
11	Bolt, 5/16-18 x 3/4 Hex Head W/Washer	F05006-101	4	
12	Decal, Fence Scale (1-13)	039358	1	
13	Decal, Fence Scale (13-1)	039357	1	
	Blade Assembly, Fixed w/Collar	003333 [1]	1	
14	Collar, Fixed Edger Blade	003332	1	
15	Screw, 5/16-18 x 1/2" Cone Point Set	F05006-38	3	
16	Blade, 16" Dia. x 14T Carbon Tip Edger	039234-CT	1	
17	Ring, Edger Blade Lock	039128	1	
18	Screw, 1/2-13 x 1 1/4" Socket Head Cap	F05008-38	3	

[1] Added 7/07. Blade is positioned inline with fence to trim both sides of boards.

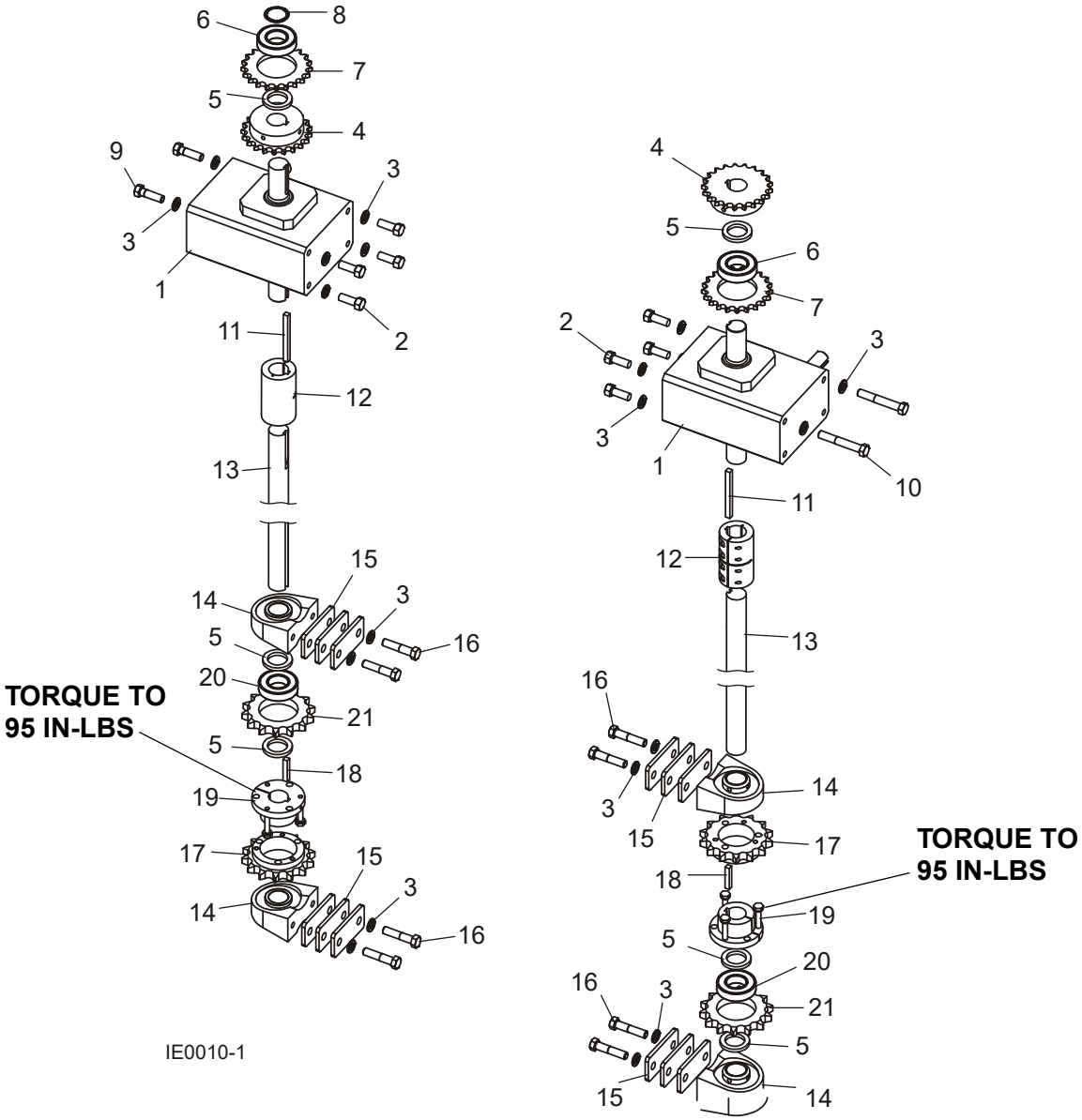
5.6 Infeed Table Fence And Scales

E430 ***Rev. A1.00 - A1.04***



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**MOUNT WELDMENT, FENCE**	039119	2	
2	**FENCE WELDMENT, EDGER**	039120	2	
3	**NUT, 1-14 HEX JAM ZINC**	F05010-118	8	
4	**BOLT, 5/8-11 X 1 3/4 HEX HEAD**	F05009-33	4	
5	**WASHER, 5/8 SPLIT ZINC LOCK**	F05011-27	4	
6	**BLOCK, INFEED ADJUST**	039042	4	
	SCALE ASSEMBLY, FENCE	039363	1	
7	Mount Weldment, Scale	039162	1	
8	Bolt, 3/8-16 x 1 1/4 Hex Head Gr5	F05007-123	8	
9	Washer, 3/8 Split	F05011-4	8	
10	Plate, Fence Scale Mount	039362	2	
11	Bolt, 5/16-18 x 3/4 Hex Head W/Washer	F05006-101	4	
12	Decal, Fence Scale (1-13)	039358	1	
13	Decal, Fence Scale (13-1)	039357	1	

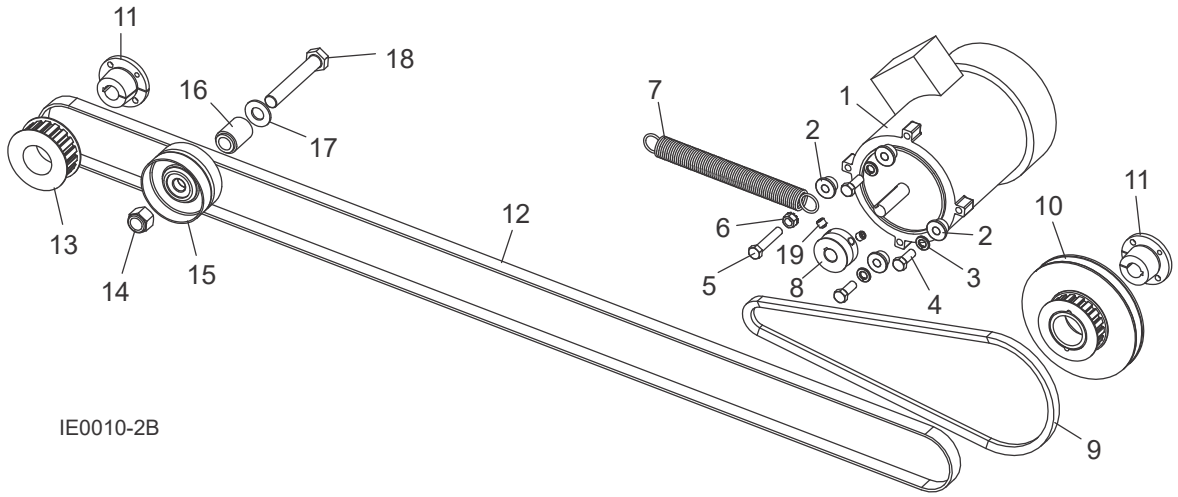
5.7 Blade and Laser Drives



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**GEARBOX, IO60-60:1-RL**	039203	2	
2	**BOLT, 3/8-16X1 HEX HEAD**	F05007-7	8	
3	**WASHER, 3/8 SPLIT**	F05011-4	20	
4	**SPROCKET, 40B21 X 1**	039197	2	
5	**SPACER, 1 1/64 ID X1 1/2 OD X 3/16**	039250	6	
	SPROCKET ASSEMBLY, 4021 IDLER	039201	2	
6	Bearing, R16 Sealed	042360	1	
7	Sprocket, 40A21 Bored	039199	1	

8	**RING, 1 DIA PUSH NUT 5115-100**	F04254-40	1	
9	**BOLT, 3/8-16X 1 1/4 HEX HEAD GR5**	F05007-123	2	
10	**BOLT, 3/8-16 X 2 1/2 HEX HEAD GR5**	F05007-125	2	
11	**KEY, 1/4 X 1 11/16**	S04124	4	
12	**COUPLER, 1 IN CLAMP STYLE**	039193	2	
13	**SHAFT, BLADE DRIVE**	039208	2	
14	**BEARING, MTBS-216**	039204	4	
15	**PLATE, BEARING RISER**	039205	12	
16	**BOLT, 3/8-16 UNF-2A X 1-3/4 GR5**	F05007-119	8	
17	**SPROCKET, H60SH14**	039195	2	
18	**KEY, 1/4SQ X 1 3/8**	017832	2	
19	**BUSHING, SH X 1**	039202	2	
	SPROCKET ASSEMBLY, 6014 IDLER	039200	2	
20	Bearing, R16 Sealed	042360	1	
21	Sprocket, 60A14 Bored	039198	1	

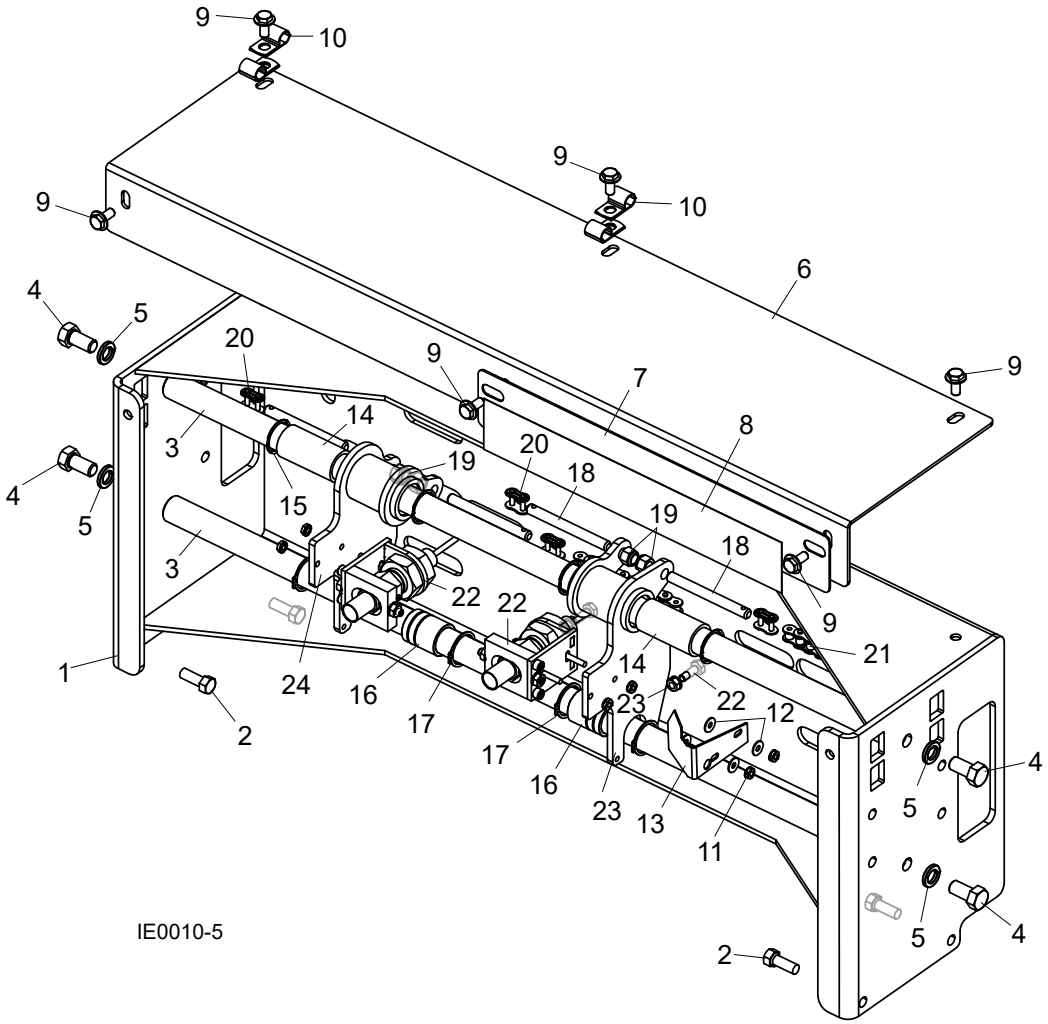
5.8 Laser Drive Motor



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**MOTOR, LINCOLN 1/2HP 1725RPM**	039274	1	
2	**BOSS, MOTOR MOUNT**	039182	4	
3	**WASHER, 3/8 SPLIT**	F05011-4	3	
4	**BOLT, 3/8-16 X 1 HEX HEAD GR5**	F05007-87 [1]	3	
5	**BOLT, 3/8-16 X 2 HEX HEAD FT**	F05007-16	1	
6	**NUT, 3/8-16 KEPS**	F05010-19	1	
7	**SPRING, 1 OD X .105 X 9 EXT.**	039303	1	
8	**SHEAVE, 1 3/4 FEED MOTOR**	015135	1	
9	**BELT, 4L390**	039276	1	
10	**SPROCKET/SHEAVE ASSEMBLY, BLADE IN/OUT**	039326	1	
11	**BUSHING, H 3/4**	039323	2	
12	**BELT, TIMING 1/2 PITCH 200 T 3/4 WIDE**	039320	1	
13	**SPROCKET, TIMING 1/2 PITCH 18T 1 WIDE**	039321	1	
14	**NUT, 5/8-18 NYLON ZINC LOCK**	F05010-71	1	
15	**PULLEY, 3-1/4 OD IDLER**	041701	1	
16	**TUBE, SPACER 41/64 X 1 1/8 X 1 17/32**	039348	1	
17	**WASHER, 5/8 SAE FLAT**	F05011-5	1	
18	**BOLT, 5/8-18 X 3 1/4 HEX HEAD GR 5**	F05009-98	1	
19	**SCREW, 3/8-16 X 3/8" SH CUP PT SET**	F05007-68	2	

[1] Replaces F05007-123 Bolt, 3/8-16 x 1 1/4 Hex Head Gr5 used in edgers prior to A1.02

5.9 Laser Guides Housing

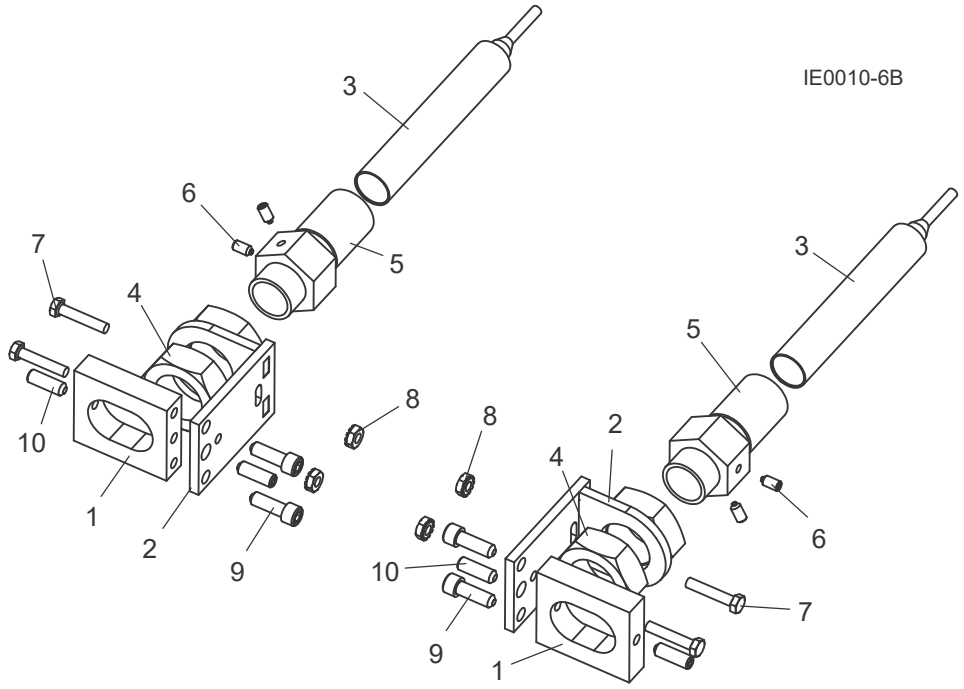


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**BOX WELDMENT, LASER GUIDE**	039185	1	
2	**BOLT, 3/8-16 X 1 HEX HEAD**	F05007-7	4	
3	**ROD, LASER SLIDE**	039206	2	
4	**BOLT, 1/2-13X1 HEX HEAD**	F05008-50 [1]	4	
5	**WASHER, 1/2 SPLIT LOCK**	F05011-9	4	
6	**COVER WELDMENT, LASER BOX TOP**	039360	1	
7	**PLATE, BLADE SCALE MOUNT**	039361	1	
8	**DECAL, BLADE SCALE (4-28)**	039356	1	
9	**BOLT, 5/16-18 X 3/4 HEX HEAD W/WASHER**	F05006-101	6	
10	**CLAMP, 1/2 EMT COATED**	P07584	4	
11	**NUT, #10-24 KEPS**	F05010-14	2	
12	**WASHER, #10 SAE FLAT**	F05011-18	4	

13	**POINTER, BLADE SCALE**	039359	1	
14	**BUSHING, 1 X 1 1/4 X 2 1/2 BRONZE**	039254	2	
15	**RING, 1 1/4 SPIRAL RETAINING**	F04254-42	4	
16	**BUSHING, 1 X 1 1/4 X 1 1/2 W/GROOVES**	039253	2	
17	**RING, 1 1/4 EXTERNAL 5100-125**	F04254-43	4	
18	**ROD, 40 CHAIN TENSIONER**	039192	4	
19	**NUT, 3/8-16 HEX NYLON LOCK**	F05010-10	4	
20	**LINK, #40 MASTER**	P04200	4	
21	**CHAIN, #40 X 83 1/2**	039333	2	
22	**LASER ASSEMBLY, E430/EG400** (*See Section 5.10*)			
23	**GUIDE WELDMENT, LASER LEFT**	039183 [2]	1	
24	**GUIDE WELDMENT, LASER RIGHT**	039184 [2]	1	

[1] Replaces F05008-128 Bolt,1/2-13 X 1 Hex Head Gr8 used in edgers prior to A1.02.
[2] Guide Weldments modified with additional 1/4" between plates to improve range of laser adjustment. Tube bore modified to improve fit of bushings to eliminate slop in laser adjustment (Rev. A1.04).

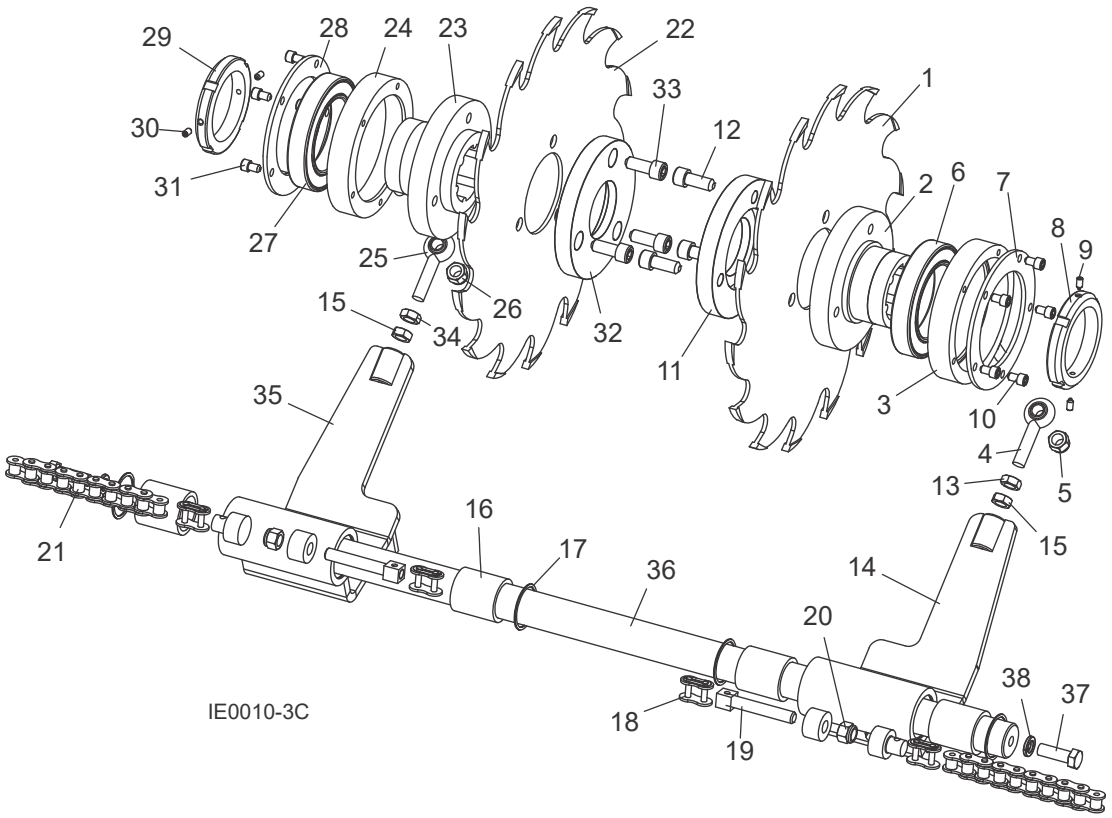
5.10 Laser Guides



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	LASER ASSEMBLY, E430/EG400	039376 [1]	2	
1	Block, Laser Adjust, 19mm	110830	1	
2	Mount Weldment, E430/EG400 Laser	039374	1	
3	Laser, 60 Deg, 15MW Line, CL-815WC	110828	1	
4	Nut, 1-14 Hex Jam ZC	F05010-118	1	
5	Sleeve, Laser Mount, 19mm	110829	1	
6	Screw, #10-32 x 3/8 Socket Head Set, Nylon	F05004-208	2	
7	Bolt, #10-24 x 1 Unslotted Hex Head	F05004-156	2	
8	Nut, #10-24 Keps	F05010-14	2	
9	Screw, 1/4-20 x 3/4 BO Socket Head	F05005-26	2	
10	Screw, 1/4-20x3/4 SH CP Nyl Lock	F05005-94	2	

[1] 110828, 110829, 110830 replaced 039377, 039371, 039375 to accommodate 19mm diameter laser (Rev. A5.02). 18mm diameter laser no longer available.

5.11 Blades Assembly

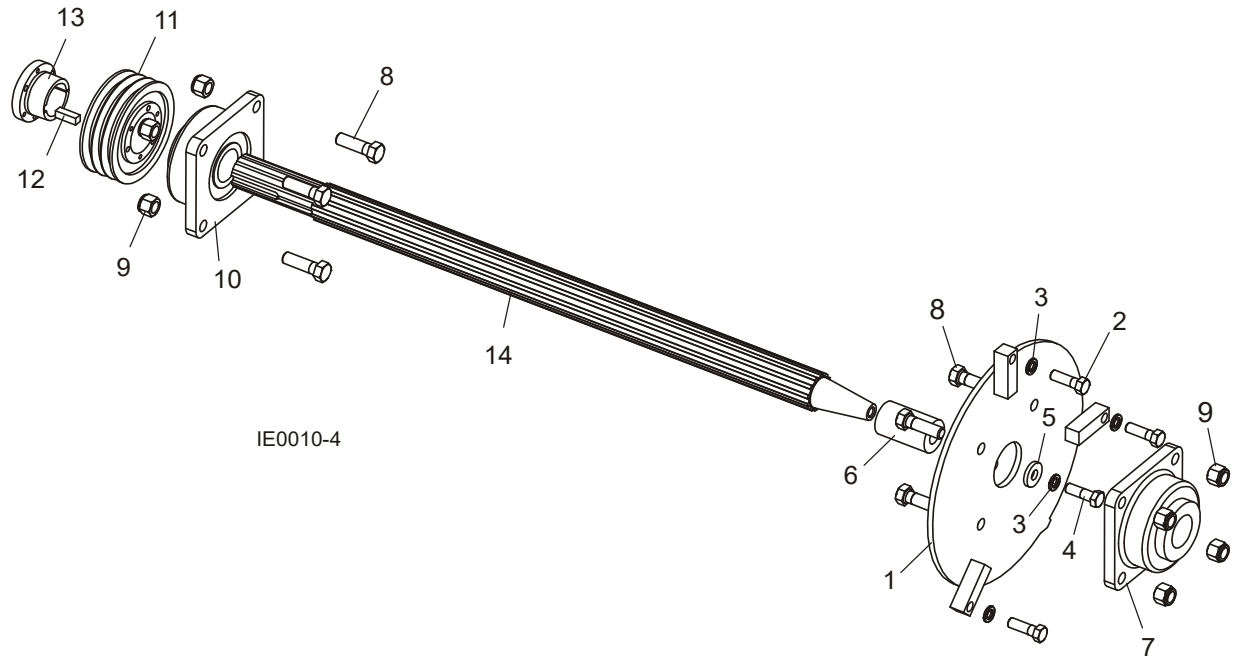


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	COLLAR ASSEMBLY, BLADE	039327 [1]	1	
1	Blade, 16" Dia. x 14 Tooth Edger	039234	1	
	Blade, 16" Dia. x 14 Tooth Edger w/Carbide Tip Inserts	039234-CT	1	
	Shank, Edger Blade Insert (pkg. of 10)	048337-10	1.4 pkg.	
	Shank, Edger Blade Insert (pkg. of 50)	048337	.28 pkg.	
	Insert, High Speed Steel Edger Blade Tooth (pkg. of 10)	048338-10	1.4 pkg.	
	Insert, High Speed Steel Edger Blade Tooth (pkg. of 100)	048338	.14 pkg.	
	Insert, Carbide Tip Edger Blade Tooth (pkg. of 10)	048339-10	1.4 pkg.	
	Insert, Carbide Tip Edger Blade Tooth (pkg. of 110)	048339	.13 pkg.	
2	Collar, Industrial Edger Blade	039127	1	
3	Collar Weldment, Bearing	039235	1	
4	Rod End, 1/2" Male	P09137	1	
5	Nut, 1/2-13 Nylon Hex Lock	F05010-8	1	
6	Bearing, 6016-2RS	039233	1	
7	Plate, Bearing Retaining	039012	1	
	Nut Assembly, Arbor w/Set Screws	036650	1	
8	Nut, AN16	039129 [2]	1	◆

9	Screw, 1/4-20 x 1/2" Nylon Tip Set	F05005-166	2	
10	Bolt, 5/16-18 x 1/2" Socket Head	F05006-39	5	
11	Ring, Industrial Edger Blade Lock	039128	1	
12	Bolt, 1/2-13 x 1 1/4" Socket Head	F05008-38	3	
13	Nut, 1/2-20 Hex Jam	F05010-16	1	
14	**PUSHER WELDMENT, LEFT BLADE**	039237	1	
15	**NUT, 1/2-20 HEX JAM**	F05010-16	2	
16	**BUSHING, 1 7/8" OD X 1 1/2" ID X 2" BRONZE**	039251	4	
17	**RING, 1 7/8" SPIRAL RETAINING**	F04254-41	4	
18	**LINK, #60 CL**	042398	4	
19	**ROD ASSEMBLY, CHAIN TENSIONER**	039191	2	
20	**NUT, 1/2-13 NYLON HEX LOCK**	F05010-8	2	
21	**CHAIN, #60 X 84 3/4"**	039370	2	
	COLLAR ASSEMBLY, BLADE	039239 [1]	1	
22	Blade, 16" Dia. x 14 Tooth Edger	039234	1	
	Blade, 16" Dia. x 14 Tooth Edger w/Carbide Tip Inserts	039234-CT	1	
	Shank, Edger Blade Insert (pkg. of 10)	048337-10	1.4 pkg.	
	Shank, Edger Blade Insert (pkg. of 50)	048337	.28 pkg.	
	Insert, High Speed Steel Edger Blade Tooth	048338	14 pkg.	
	Insert, Carbide Tip Edger Blade Tooth	048339	14 pkg.	
23	Collar, Industrial Edger Blade	039127	1	
24	Collar Weldment, Bearing	039235	1	
25	Rod End, 1/2" Male	P09137	1	
26	Nut, 1/2-13 Nylon Hex Lock	F05010-8	1	
27	Bearing, 6016-2RS	039233	1	
28	Plate, Bearing Retaining	039012	1	
	Nut Assembly, Arbor w/Set Screws	036650	1	
29	Nut, AN16	039129 [2]	1	◆
30	Screw, 1/4-20 x 1/2" Nylon Tip Set	F05005-166	2	
31	Bolt, 5/16-18 x 1/2" Socket Head	F05006-39	5	
32	Ring, Industrial Edger Blade Lock	039128	1	
33	Bolt, 1/2-13 x 1 1/4" Socket Head	F05008-38	3	
34	Nut, 1/2-20 Hex Jam	F05010-16	1	
35	**PUSHER WELDMENT, RIGHT BLADE**	039236	1	
36	**SHAFT, BLADE SLIDE**	039209	1	
37	**BOLT, 1/2-13X1 1/2 HH GR5**	F05008-33	2	
38	**WASHER, 1/2 SPLIT LOCK**	F05011-9	2	
	WRENCH, EDGER BLADE INSERT	048336 [1]	1	
	Pin, Edger Blade Wrench Replacement	061106	1	

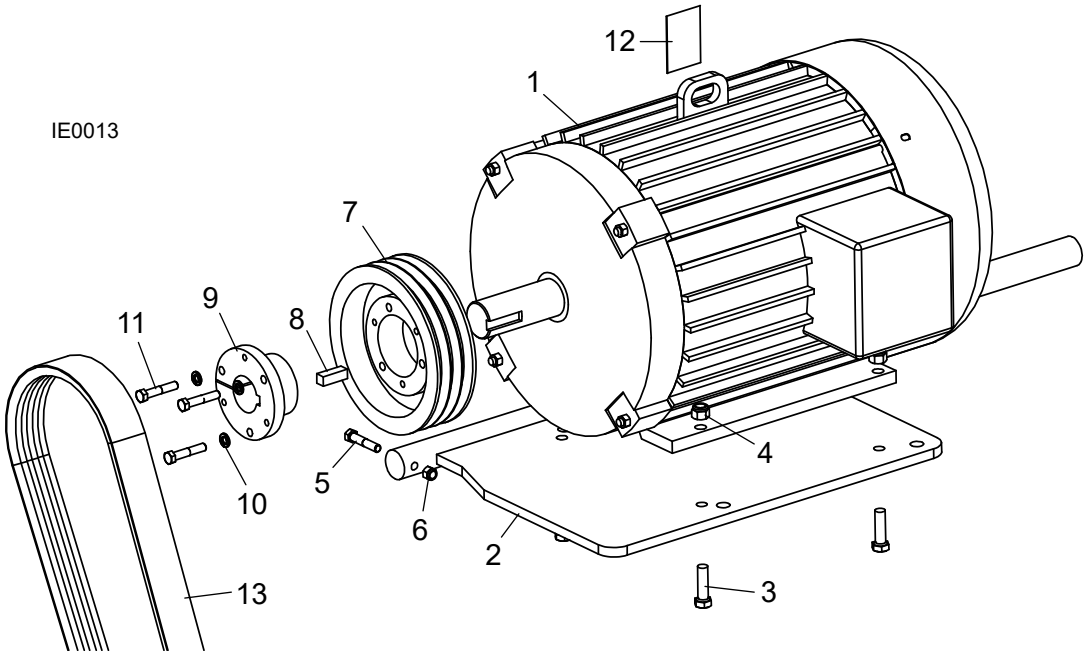
[1] Added Insert Wrench 048336 required to remove/install blade inserts (Rev. A3.00; sold separately prior to A3.00).
[2] Nut Assembly 035650 with Nylon-Tipped Set Screws created to better secure arbor nut (Rev. A1.03).

5.12 Blades Shaft



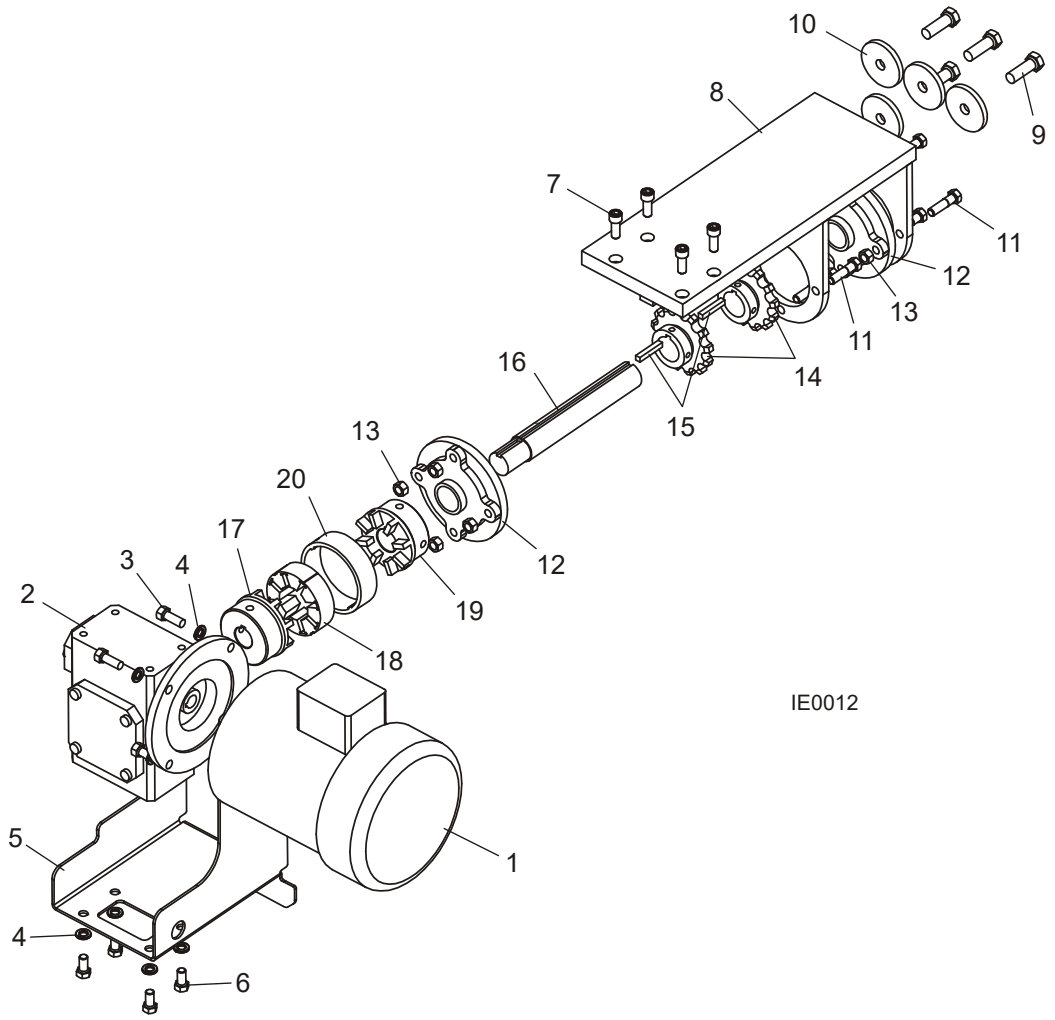
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**DOOR WELDMENT, BLADE**	039338	1	
2	**BOLT, 5/8-11 X 2 1/2 GR5 HEX HEAD**	F05009-20	3	
3	**WASHER, 5/8 SPLIT ZINC LOCK**	F05011-27	4	
4	**BOLT, 5/8-18 X 2 HEX HEAD FT**	F05009-15	1	
5	**WASHER, 21/32 X 1 5/8 X 1/4 THICK**	034685	1	
6	**CUP, BLADE DRIVE SHAFT**	039001	1	
7	**BEARING, F-U335D**	039150	1	
8	**BOLT, 3/4-10 X 2 1/2 HEX HEAD GR5**	F05009-44	8	
9	**NUT, 3/4-10 NYLOCK**	F05010-103	8	
10	**BEARING, FE-U335D**	039151	1	
11	**SHEAVE, 35V670**	039269	1	
12	**KEY, 1/2 SQ X 1 1/2**	033738	1	
13	**BUSHING, SK X 2 3/16**	039267	1	
14	**SHAFT, 2 7/16 DIA.**	039002	1	

5.13 Blades Motor Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	MOTOR ASSEMBLY, INDUSTRIAL EDGER	039265	1	
1	Motor, Lincoln 30HP 1800RPM	042301	1	
2	Mount Weldment, Motor	039112	1	
3	Bolt, 1/2-13 x 1 3/4 Hex Head GR5 Zinc	F05008-88	4	
4	Nut, 1/2-13 Nylon Hex Lock	F05010-8	4	
5	Bolt, 3/8-16 x 2 Hex Head Gr5	F05007-124	1	
6	Nut, 3/8-16 Hex Nylon Lock	F05010-10	1	
7	Sheave, 35V850	039268	1	
8	Key, 1/2 Sq x 1 1/2	033738	1	
9	Bushing, SF x 1 7/8	039266	1	
10	Washer, 3/8 Split	F05011-4	3	
11	Bolt, 3/8-16x2 Hex Head	F05007-72	3	
12	Decal, Motor Direction	S20097	1	
13	**BELT, 3 X 5V X 900**	039270	1	

5.14 Feed Drive Assembly

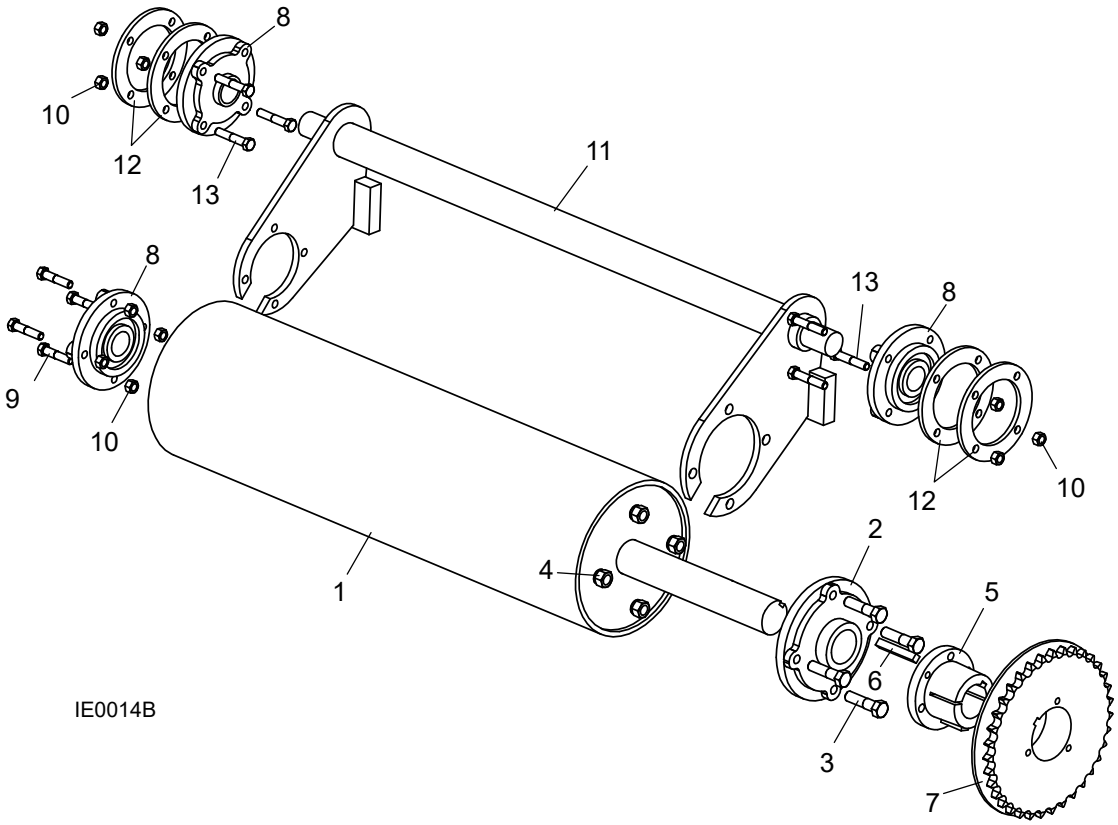


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	DRIVE ASSEMBLY, EDGER FEED	039249	1	
1	Motor, 2HP 3P 230/460 56C Premium Eff	079197 [1]	1	
2	Gearbox, IC60 Up/Down	042793	1	
3	Bolt, 3/8-16 x 1 Hex Head	F05007-7	4	
4	Washer, 3/8 Split	F05011-4	8	
5	Guard, Board Feed	039339	1	
6	Bolt, 3/8-16 x 3/4 Hex Head Gr2	F05007-27	4	
7	Bolt, 3/8-16 x 1 Socket Head Cap BO	F05007-52	4	
8	Mount Weldment, Board Drive	039138	1	
9	Bolt, 1/2-13 x 1 1/2 Hex Head Gr5	F05008-33	4	
10	Washer, Drive Side Bearing	033909	4	
11	Bolt, 3/8-16 x 1 1/2 Hex Head Gr5	F05007-78	8	

12	Bearing, VFCS-320	039152	2	
13	Nut, 3/8-16 Swaged	F05010-25	8	
14	Sprocket, H6013 x 1.25 Bore Keyed	039155	2	
15	Key, 1/4 Square x 1 1/2 Long	028080	2	
16	Shaft, Edger Power Feed	039214	1	
	Coupling, 10R x 1 x 1-1/8 Power Feed	042655 [2]	1	
17	Coupling Body, 10R x 1	042655-1	1	
18	Coupling Spider, Urethane 10R w/Screws	042655-2	1	
19	Coupling Body, 10R x 1-1/8	042655-4	1	
20	Coupling Ring, Steel 10R	042655-5	1	

[1] Replaced 042390 2HP 3PH 230/460 TEFC 56C No Base Motor (Rev. A4.04).
[2] Coupler set screws supplied with complete coupler 042655 or Coupling Spider 042655-2 only.

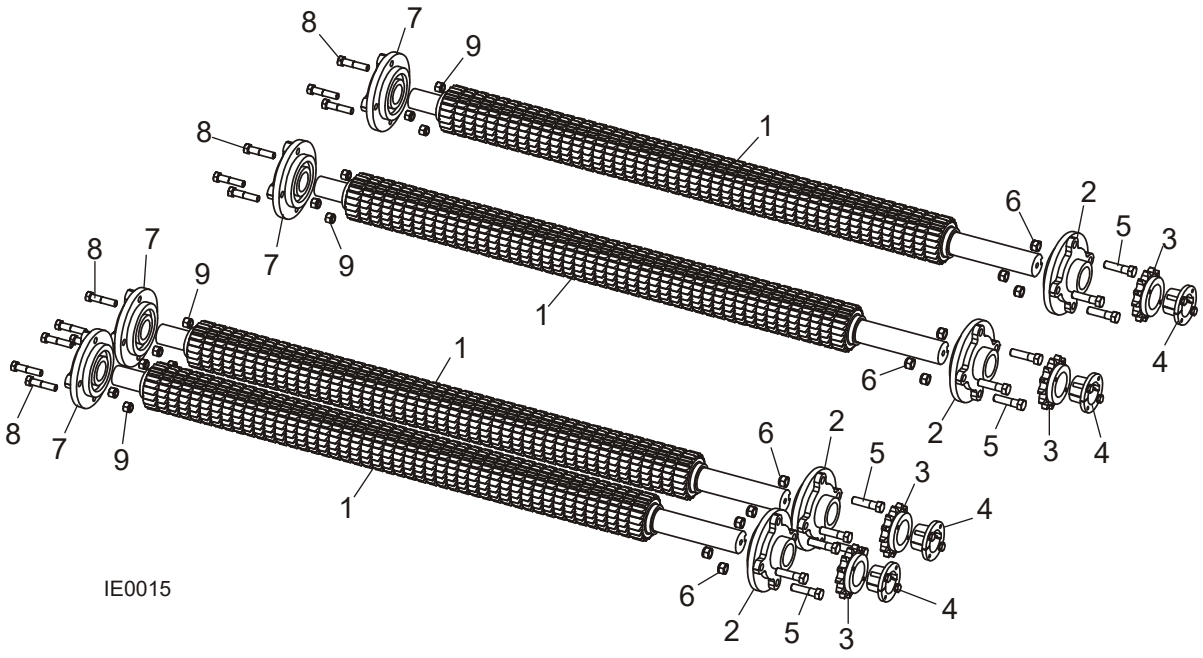
5.15 Upper Driven Roller



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, UPPER DRIVEN	039258	1	
1	Roller Weldment, Infeed Holddown	039086	1	
2	Bearing, VFCS-328	039154	1	
3	Bolt, 1/2-13 x 2 Hex Head	F05008-76	4	
4	Nut, 1/2-13 Nylon Hex Lock	F05010-8	4	
5	Bushing, Q1 x 1 3/4	039260	1	
6	Key, 3/8 Sq x 2 1/2	039380	1	
7	Sprocket Wldmt, Feed Drive 60Q35	036484 [1]	1	
8	Bearing, VFCS-320	039152	3	
9	Bolt, 3/8-16 UNF-2A x 1-3/4 Gr5	F05007-119	4	
10	Nut, 3/8-16 Swaged Lock	F05010-25	10	
11	Pivot Weldment, Driven Holddown	039111	1	
12	Spacer, Bearing	039007	4	
13	Bolt, 3/8-16 x 2 Hex Head Gr5	F05007-124	6	

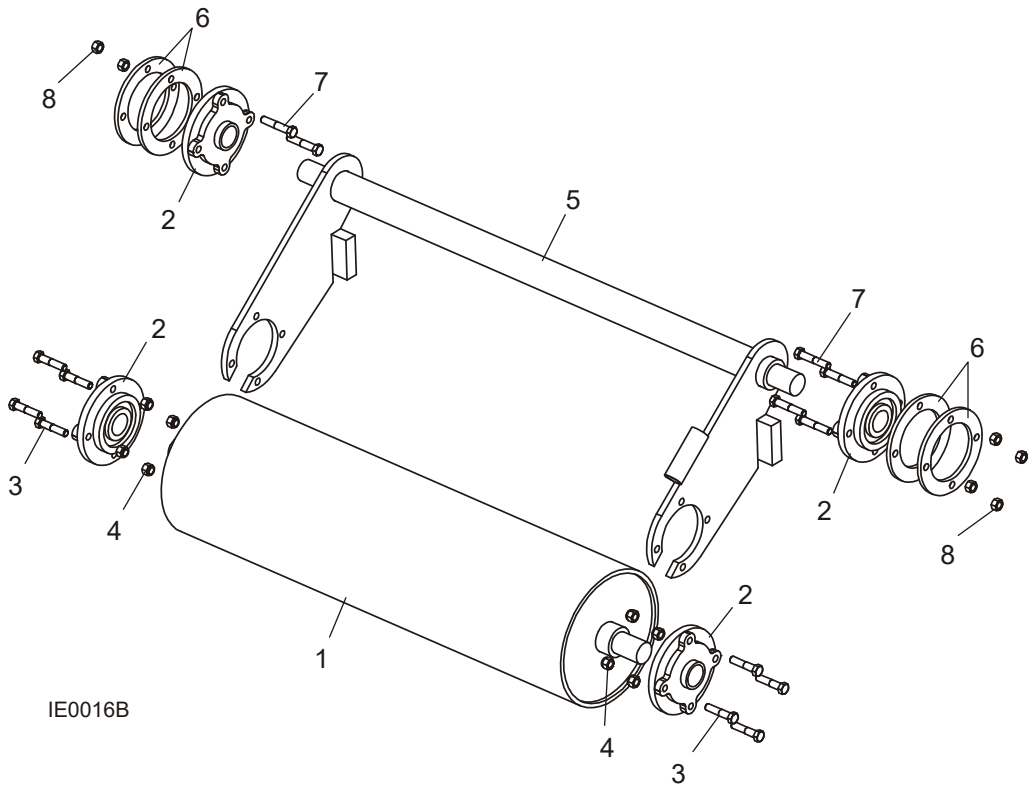
[1] Replaces 039259 Sprocket, 60Q35 used in industrial edgers prior to Rev. A1.02.

5.16 Lower Drive Rollers



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, LOWER DRIVE	039255	4	
1	Shaft, Lower Drive	039169	1	
2	Bearing, VFCS-323	039153	1	
3	Sprocket, 60H13	039256	1	
4	Bushing, QT x 1 7/16	P12962	1	
5	Bolt, 7/16-14 x 1 3/4 G8 Hex Head	F05009-60	3	
6	Nut, 7/16-14 Nylon Lock	F05010-135	3	
7	Bearing, 1 1/4, 4 Bolt Flange	039152	1	
8	Bolt, 3/8-16 UNF-2A x 1-3/4 Gr5	F05007-119	3	
9	Nut, 3/8-16 Hex Nylon Lock	F05010-10	3	

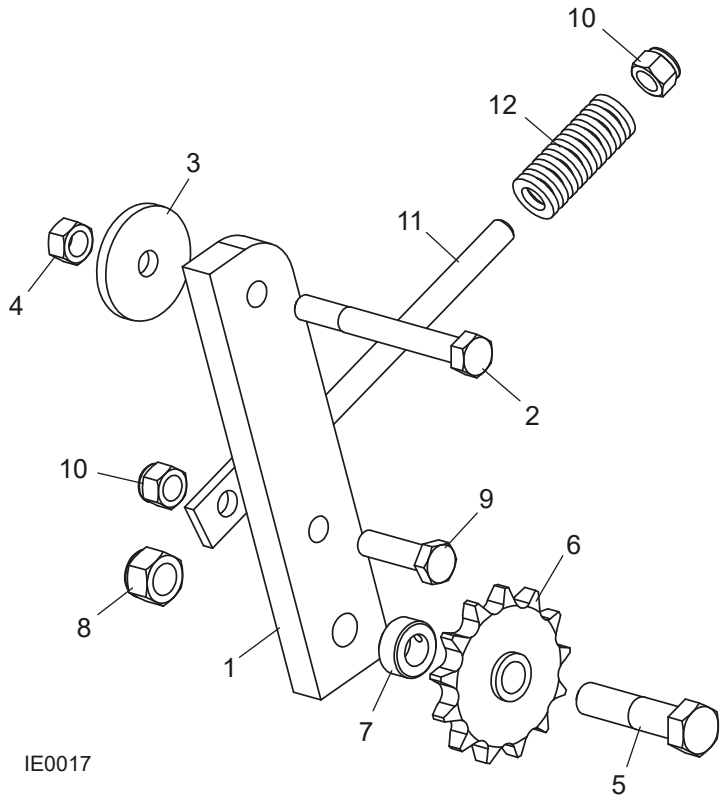
5.17 Upper Idle Roller



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	ROLLER ASSEMBLY, UPPER IDLE	039257	1	
1	Roller Weldment, Idle Holddown	039109	1	
2	Bearing, VFCS-320	039152	4	
3	Bolt, 3/8-16UNF-2A x 1-3/4" Grade 5	F05007-119	8	
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	8	
5	Pivot Weldment, Idle Holddown	039110	1	
6	Spacer, Bearing	039007	4	
7	Bolt, 3/8-16 x 2" Hex Head Grade 5	F05007-124 [1]	6	
8	Nut, 3/8-16 Swagged	F05010-25 [1]	6	

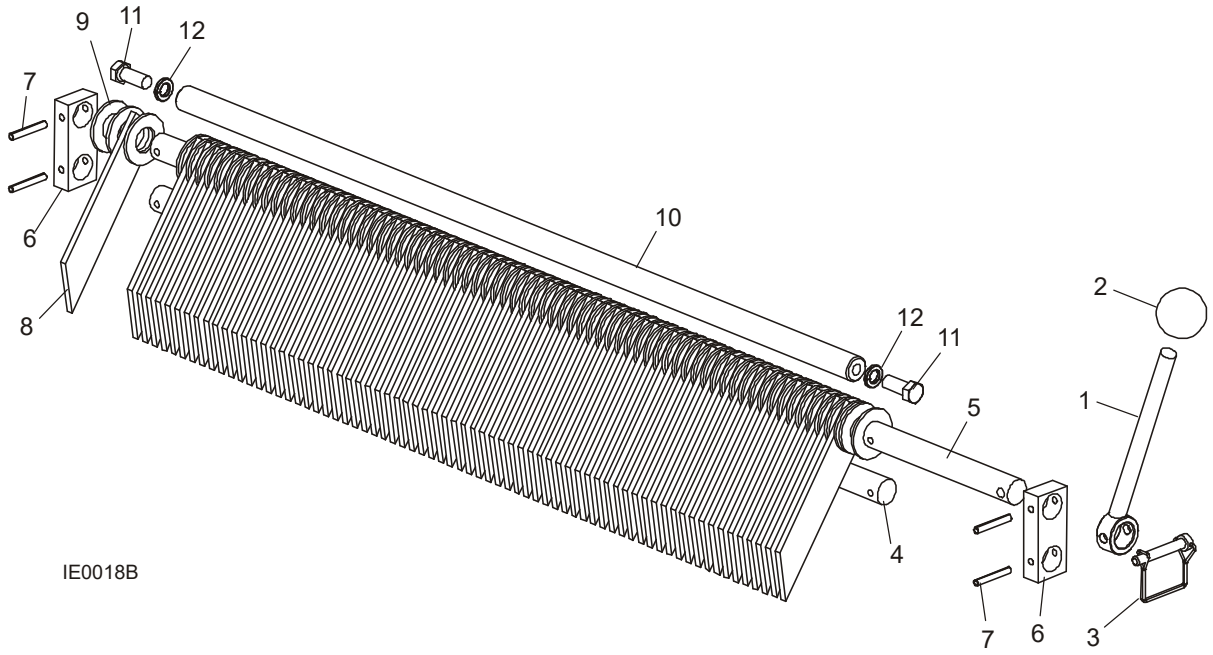
[1] Removed two 3/8-16 x 2" Hex Head Bolts (F05007-124) and 3/8-16 Nuts (F05010-25) for mounting of new proximity assembly (038722) (Rev. A3.00).

5.18 Tensioner Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TENSIONER ASSEMBLY, INDUSTRIAL EDGER	039262	1	
1	Block, Idler Pivot	039097	1	
2	Bolt, 1/2-13 x 4 1/2 Hex Head Gr5	F05008-35	1	
3	Washer, Drive Side Bearing	033909	1	
4	Nut, 1/2-13 Swaged Hex 2-way Lock	F05010-3	1	
5	Bolt, 5/8-11 x 2 3/4 Hex Head	F05009-21	1	
6	Sprocket, 60BB13H x 5/8 Idler	034224	1	
7	Collar, 5/8 ID Lock	P05035	1	
8	Nut, 5/8-11 Nylon Lock	F05010-34	1	
9	Bolt, 1/2-13 x 1 3/4 Hex Head Gr5 Zinc	F05008-88	1	
10	Nut, 1/2-13 Nylon Hex Lock	F05010-8	2	
11	Tensioner Weldment, Drive Chain	039116	1	
12	Spring, EH100 x 250	039263	1	

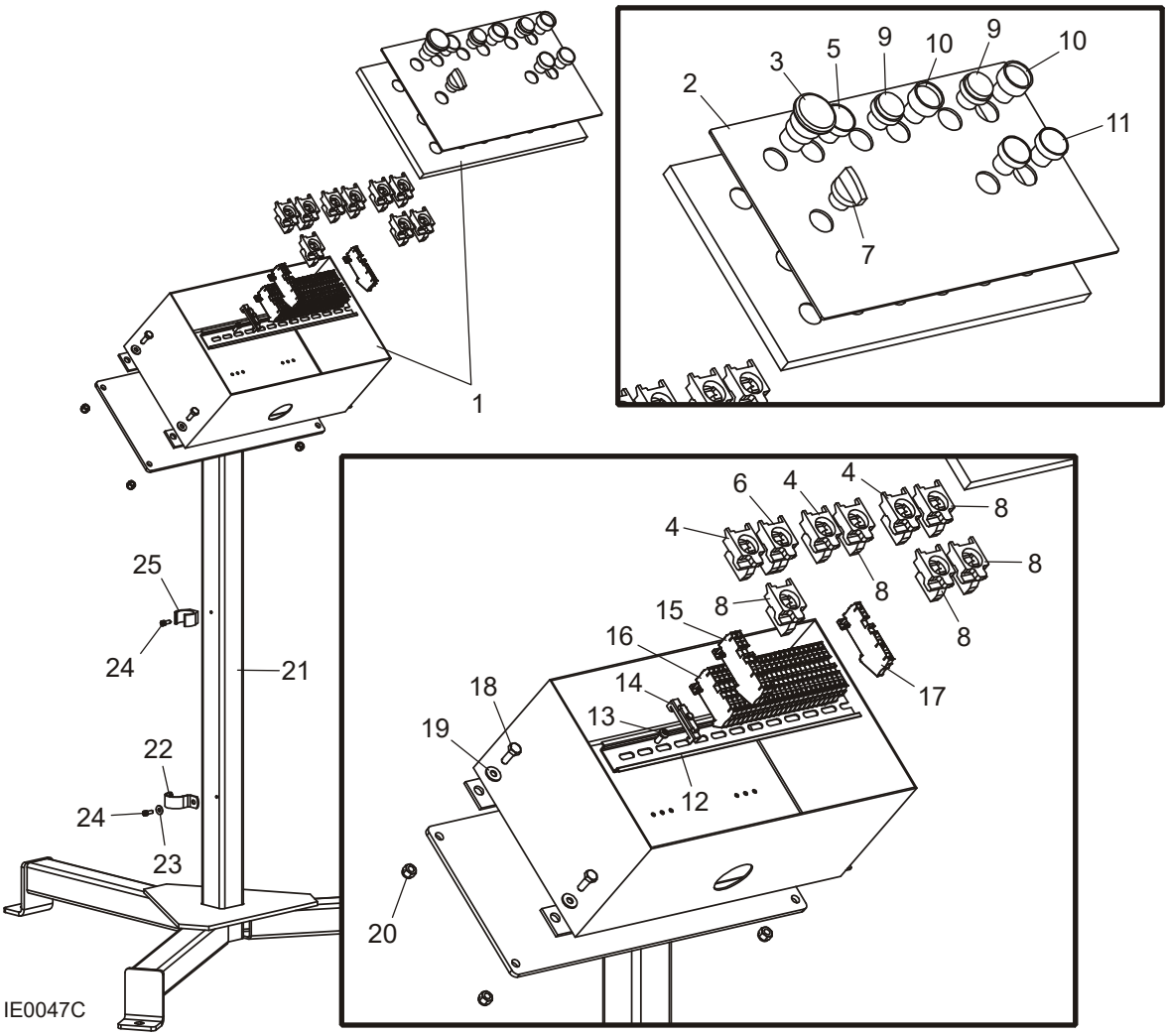
5.19 Kickback Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	KICKBACK ASSEMBLY, INDUSTRIAL EDGER	039261	1	
1	Handle Weldment, Kickback Lift	039213	1	
2	Knob, 5/8-18 Ball	P04211	1	
3	Pin, 3/8 x 2 1/4" SQ Wire Lock	014151	1	
4	Shaft, Kickback Upper	039073	1	
5	Shaft, Kickback Lower	039074	1	
6	Block, Kickback Link	039106	2	
7	Pin, 1/4 x 1 3/4" Roll	F05012-53	4	
8	Finger, 1/4" Kickback	038238	70	
9	Washer, 1" ID SAE Flat	F05011-28	145	
10	Rod, Kickback Stop	039387	1	
11	Bolt, 1/2-13x1 1/4" Hex Head Grade 5	F05008-37	2	
12	Washer, 1/2" Split Lock	F05011-9	2	

5.20 Operator Control Assembly

E430 ***Rev. A3.00 - A4.00***
EG400 ***Rev. A4.00+***



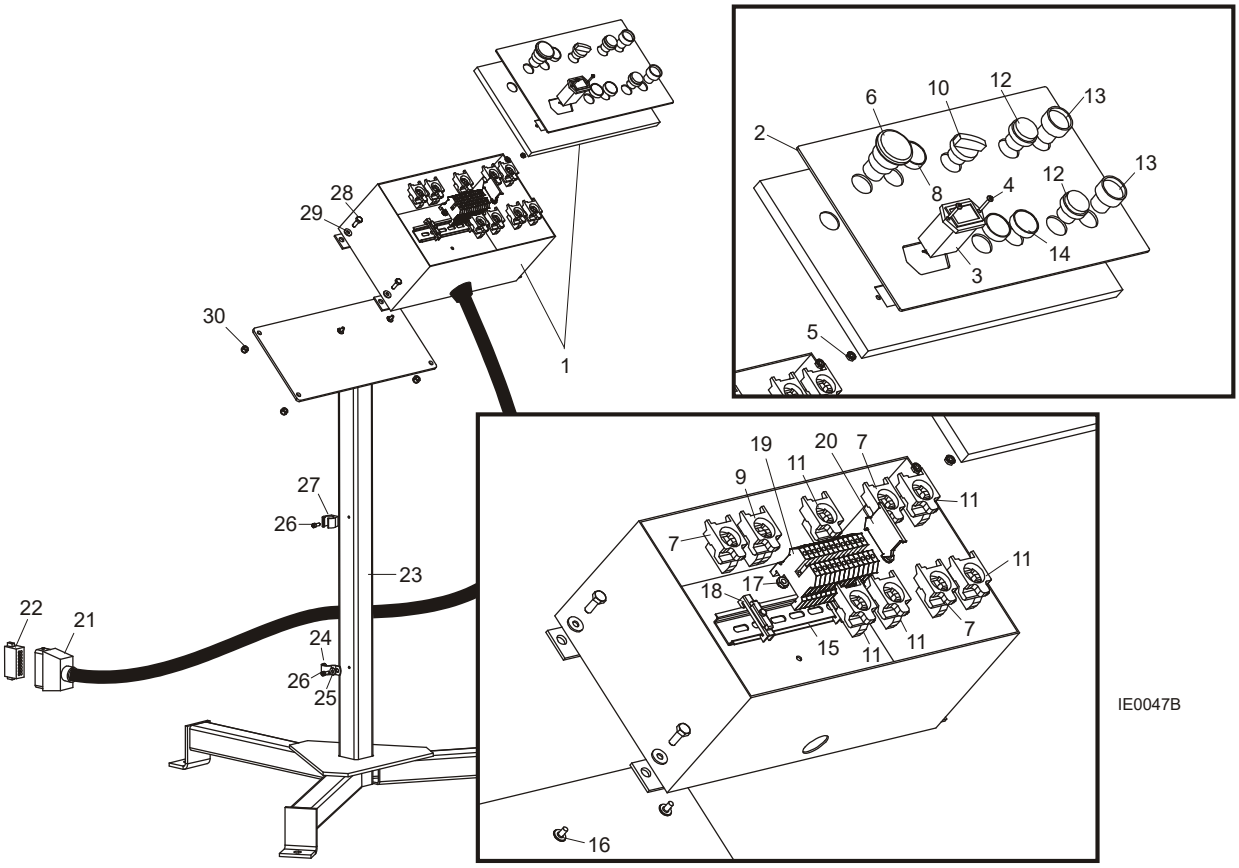
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	CONTROL ASSEMBLY, OPERATOR	039367 [1]	1	
	Operator Assembly, Industrial Edger 2006	052739	1	
1	Enclosure, E430/EG400 Setworks Operator	054667	1	
2	Decal, Industrial Edger Operator Control 2006 (AWMV)	052769	1	
3	Switch Head, Red Push Button 22mm XB4	024945	1	
4	Switch Body, 22mm 1NC XB4	025161	3	
5	Switch Head, Green Flush ZB4	051301	1	
6	Switch Body, 22mm Green LED 1NO 24V XB4	025236-31	1	
7	Switch Head, 2 Pos. Maint. ZB4	051302	1	
8	Switch Body, 22mm 1NO XB4	025242	5	

9	Switch Body, Red Extended	050151	2	
10	Switch Head, Green Guarded	050152	2	
11	Switch Head, 22mm Mom Flush Blue XB4	050197	2	
12	Rail, 35mm x 7.5mm x 12.75" Steel DIN	024474-12_75	1	
13	Bolt, #10-24 x 1/2" Phillips Pan Head	F05015-17	3	
14	Clamp, Plastic DIN Rail	E22707	1	
15	Terminal Block, 3P Gray Cage Clamp	052760	2	
16	Terminal Block, 2P Gray Cage Clamp	052750	24	
17	Terminal Block, Green/Yellow GND 3P	052752	1	
	Harness Assembly, Industrial Edger Control 2006	052748 [2]	1	
	Hood, Top Entry 32P	052776	1	
	Connector, 1-1/4" NPT 0.875-1.0 Straight	073750	1	
	Insert, 16P Cage Clamp Male (1-16)	052777	1	
	Insert, 16P Cage Clamp Male (17-32)	052778	1	
	Connector, 1-1/4" NPT 0.875-1.0 45deg	073775	1	
18	Bolt, 1/4-20 x 3/4" Hex Head Full Thread	F05005-1	4	
19	Washer, 1/4" SAE Flat	F05011-11	4	
20	Nut, 1/4-20 Hex Nylon Lock	F05010-69	4	
21	Stand Weldment, Edger Control	039336	1	
22	Clamp, 1" EMT	P05436	1	
23	Washer, #10 SAE Flat	F05011-18	1	
24	Screw, #10-24 x 1/2" Socket Head	F05004-26	2	
25	Bracket, 3/4" Flex Mounting	039379	1	

[1] *See Section 5.22* if control equipped with optional Networks.
[2] 073750 connector replaced 050350 and 073775 connector replaced 052775 (Rev. A4.03).

5.21 Operator Control Assembly

E430 ***Rev. A1.00 - A2.00***

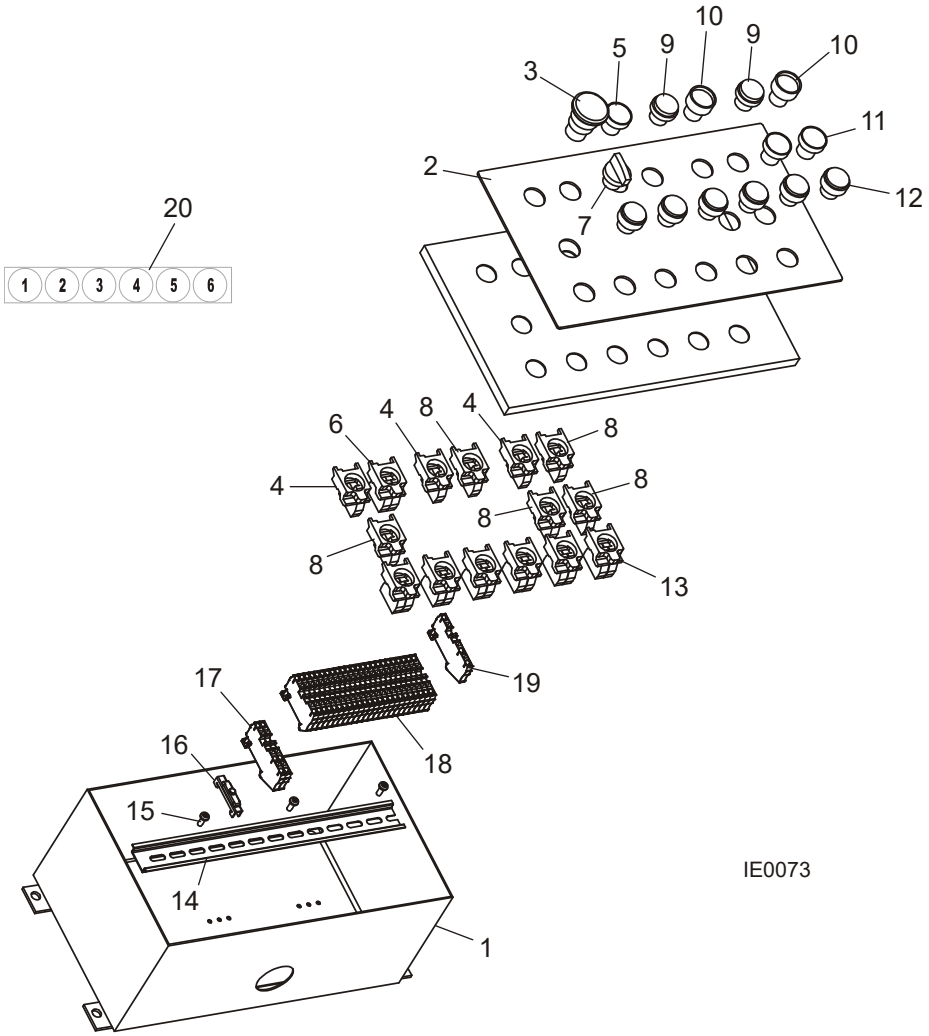


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	CONTROL ASSEMBLY, OPERATOR	039367	1	
1	Operator Assembly, Industrial Edger	051306	1	
2	Decal, Industrial Edger Operator Control (AWMV)	052290	1	
	Decal, Industrial Edger Operator Control (Wood-Mizer)	039354	1	
3	Hour Meter, Rectangle Mount	015401	1	
4	Screw, #6-32 x 3/4" Socket Button Head Stainless Steel	F05004-93	2	
5	Nut, #6-32 Self-Locking Hex	F05010-59	2	
6	Switch Head, Red Push Button 22mm XB4	024945	1	
7	Switch Body, 22mm 1NC XB4	025161	3	
8	Switch Head, Green Flush ZB4	051301	1	
9	Switch Body, 22mm Green LED 1NO 24V XB4	025236-31	1	
10	Switch Head, 2 Pos. Maint. ZB4	051302	1	
11	Switch Body, 22mm 1NO XB4	025242	5	
12	Switch Body, Red Extended	050151	2	

13	Switch Head, Green Guarded	050152	2	
14	Switch Head, 22mm Mom Flush Blue XB4	050197	2	
15	Rail, 35mm x 7.5mm x 6.875 Steel DIN	024474-6_875	1	
16	Screw, #10-24 x 3/8" Phillips Pan Head w/Neoprene Washer	F05004-148	2	
17	Nut, #10-24 Self-Locking Hex	F05010-14	2	
18	Clamp, Plastic DIN Rail	E22707	2	
19	Terminal Block, 1-Tier Phoenix	024893	13	
20	End Cap, Terminal Block	050935	1	
	Cable Assembly, Industrial Edger Operator Interface	051296	1	
21	Connector, 16 Pin Single Lever Hood	015658	1	
22	Insert, Male 10A 16 Pin Screw Terminal 1-16	E23105	1	
23	Stand Weldment, Edger Control	039336	1	
24	Clamp, 1/2" EMT	P05088	1	
25	Washer, #10 SAE Flat	F05011-18	1	
26	Screw, #10-24 x 1/2" Socket Head	F05004-26	2	
27	Bracket, 1/2" Flex Mounting	039379	1	
28	Bolt, 1/4-20 x 3/4" Hex Head Full Thread	F05005-1	4	
29	Washer, 1/4" SAE Flat	F05011-11	4	
30	Nut, 1/4-20 Hex Nylon Lock	F05010-69	4	

5.22 Operator Control Assembly (w/Optional Setworks)

E430 ***Rev. A3.00 - A4.00***
EG400 ***Rev. A4.00+***



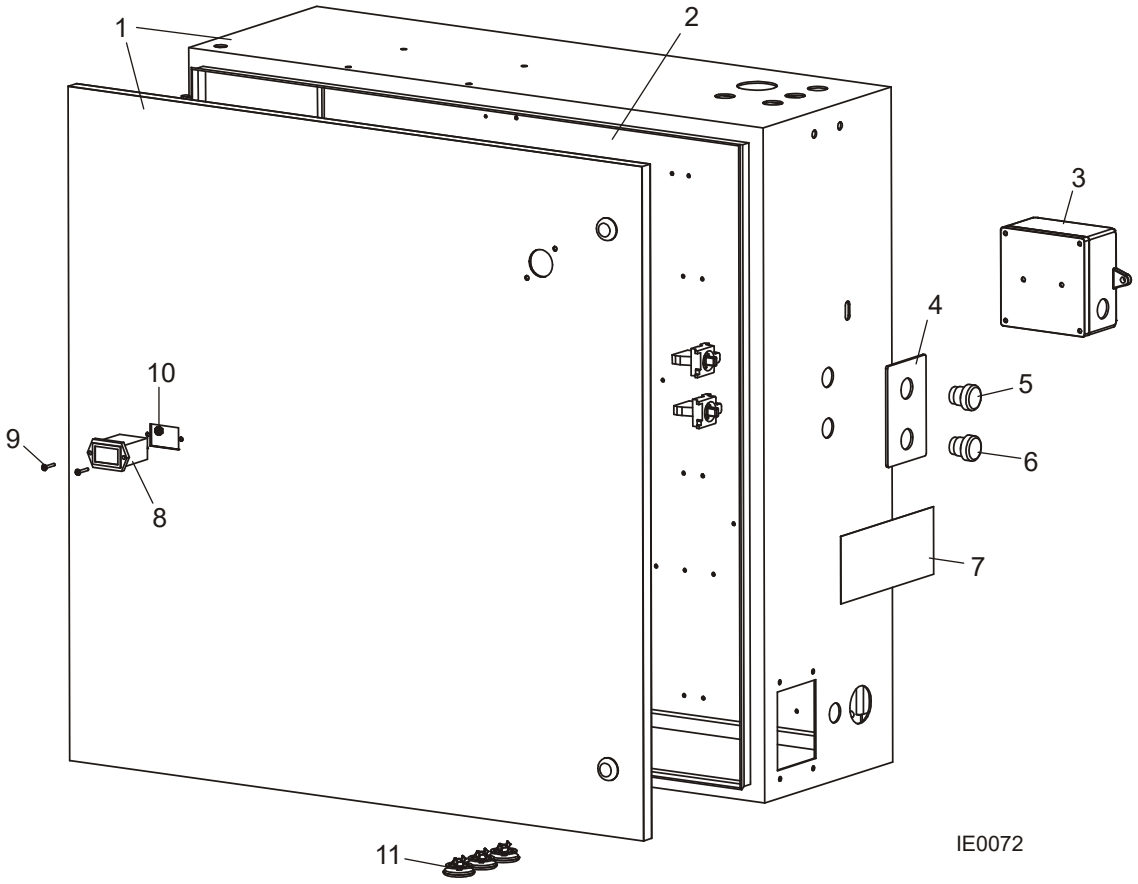
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	OPERATOR ASSEMBLY, CONTROL W/SETWORKS (FACTORY INSTALLED)	052770	1	
1	Enclosure, E430/EG400 Setworks Operator	054667	1	
2	Decal, Industrial Edger Operator Control w/Setworks (AWMV)	054649	1	
3	Switch Head, Red Push Button 22mm XB4	024945	1	
4	Switch Body, 22mm 1NC XB4	025161	3	
5	Switch Head, Green Flush ZB4	051301	1	
6	Switch Body, 22mm Green LED 1NO 24V XB4	025236-31	1	
7	Switch Head, 2 Pos. Maint. ZB4	051302	1	
8	Switch Body, 22mm 1NO XB4	025242	5	
9	Switch Body, Red Extended	050151	2	

10	Switch Head, Green Guarded	050152	2	
11	Switch Head, 22mm Mom Flush Blue XB4	050197	2	
12	Switch, Head 22mm Mom Flush LED Blue XB4	025237-68	6	
13	Switch Body, 22mm Blue LED 1 NO 24V XB4	025236-61	6	
14	Rail, 35mm x 7.5mm x 12.75" Steel DIN	024474-12_75	1	
15	Bolt, #10-24 x 1/2" Phillips Pan Head	F05015-17	3	
16	Clamp, Plastic DIN Rail	E22707	1	
17	Terminal Block, 3P Gray Cage Clamp	052760	2	
18	Terminal Block, 2P Gray Cage Clamp	052750	24	
19	Terminal Block, Green/Yellow GND 3P	052752	1	
20	Label Set, E430/EG400 Setworks Preset	052822	1	
	Harness Assembly, Industrial Edger Control 2006	052748 [1]	1	
	Hood, Top Entry 32P	052776	1	
	Connector, 1-1/4" NPT 0.875-1.0 Straight	073750	1	
	Insert, 16P Cage Clamp Male (1-16)	052777	1	
	Insert, 16P Cage Clamp Male (17-32)	052778	1	
	Connector, 1-1/4" NPT 0.875-1.0 45deg	073775	1	

[1] 073750 connector replaced 050350 and 073775 connector replaced 052775 (Rev. A4.03).

5.23 Electrical Cabinet, Laser Interface & Harnesses

E430 ***Rev. A3.00 - A4.00***
EG400 ***Rev. A4.00+***

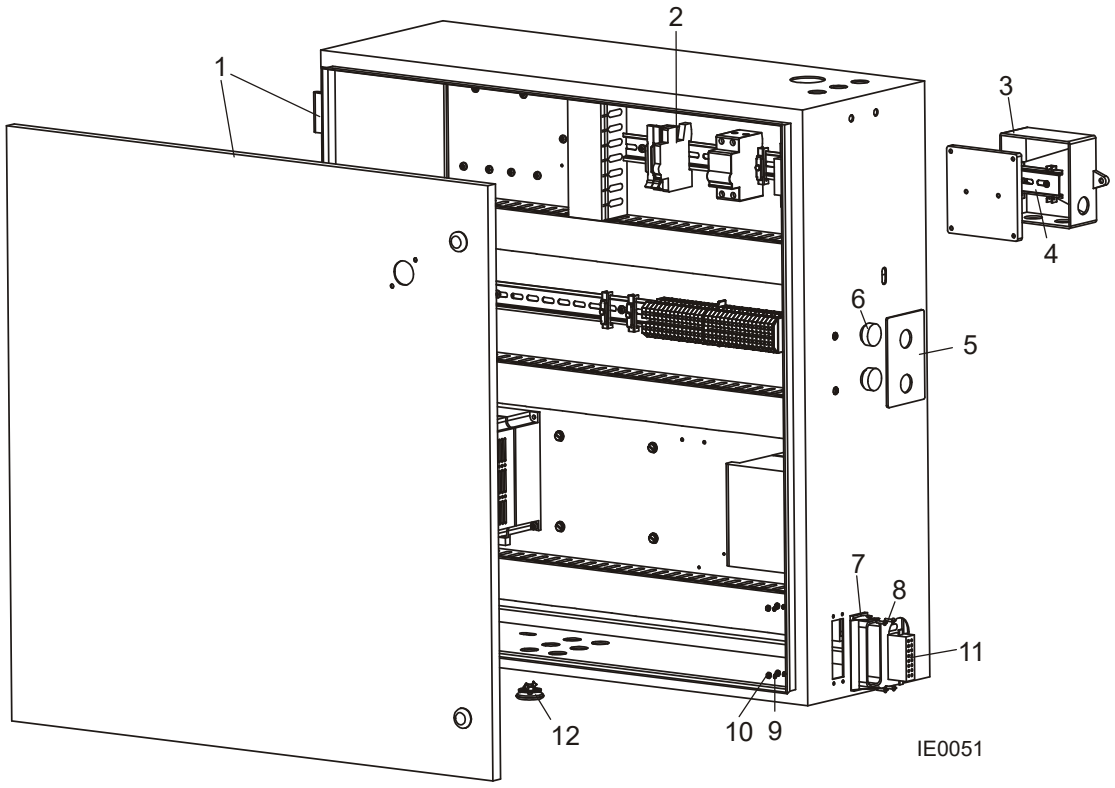


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	BOX ASSEMBLY, EDGER ELECTRICAL	052738	1	
1	Enclosure, Industrial Edger Setworks Control	054807	1	
2	Electrical Components (*See Section 6.8*)			
	Interface Assembly, Industrial Edger Laser 2006	052749	1	
3	Enclosure Assembly, Industrial Edger Laser Interface	051309	1	
	Laser Interface Components (*See Section 6.8*)			
4	Decal, Industrial Edger 2005 Status Lights	052289	1	
5	Light, Green 24V 22mm LED XB4 Pilot	024970-3	1	
6	Light, Red 24V 22mm LED XB4 Pilot	024970-4	1	
7	Decal, Wood-Mizer Logo 6"	059506	1	
8	Hour Meter, Rectangle Mount	015401	1	
9	Screw, #6-32 x 3/4" Socket Button Head Stainless Steel	F05004-93	2	
10	Nut, #6-32 Self-Locking Hex	F05010-59	2	
11	Plug, AS050 OilTite	024685	3	

	Connector Assembly, Industrial Edger Interface 2006	052747	1	
	Insert, 16P Spring Clamp 1-16 Female	052766	1	
	Insert, 16P Spring Clamp 17-32 Female	052767	1	
	Cable Assembly, E430/EG400 PLC to Display Interface	052765	1	
	Cable Assembly, Industrial Edger Left Cover Switch	051311	1	
	Cable Assembly, Industrial Edger Center Cover Switch	051312	1	
	Cable Assembly, Industrial Edger Right Cover Switch	051313	1	
	Cable Assembly, Industrial Edger Perimeter Switch 2006	052744	1	
	Cable Assembly, Industrial Edger Low Feed Proximity 2006	052740	1	
	Cable Assembly, Industrial Edger Medium Feed Proximity 2006	052741	1	
	Cable Assembly, Industrial Edger Reverse Switch 2006	052745	1	
	Harness Assembly, Industrial Edger Blade Motor 2006	052746	1	
	Harness Assembly, Industrial Edger Feed Motor	051330	1	
	Harness Assembly, Industrial Edger Blade Position Motor	051319	1	

5.24 Electrical Cabinet, Laser Interface & Harnesses

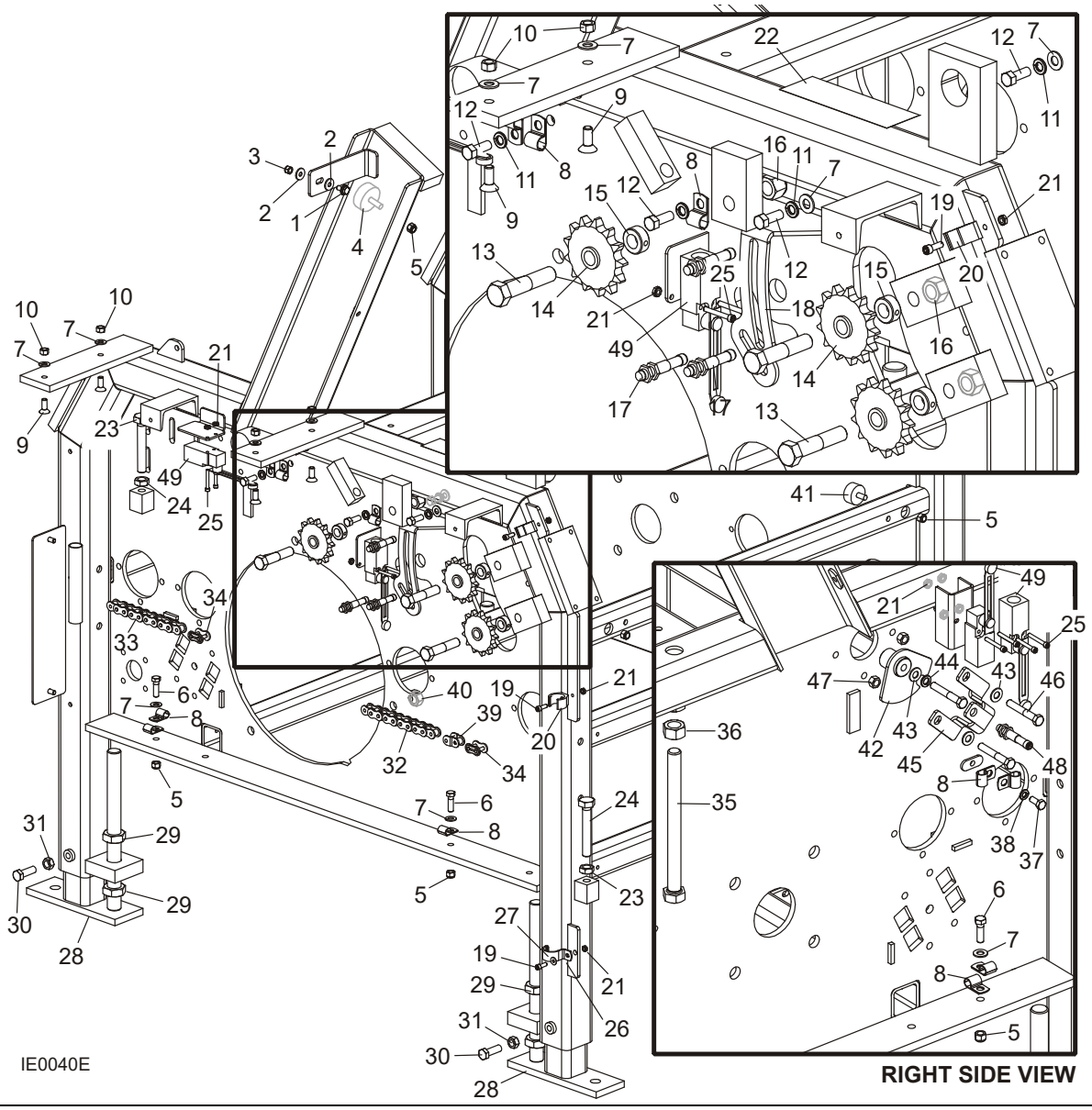
E430 ***Rev. A1.00 - A2.00***



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	BOX ASSEMBLY, EDGER ELECTRICAL	051329	1	
	Panel Assembly, Industrial Edger Control	051328	1	
1	Enclosure, Industrial Edger Control w/Panel	051327	1	
2	Electrical Components (*See Section 6.9*)			
3	Box Assembly, Industrial Edger Laser	039355	1	
4	Laser Interface Components (*See Section 6.9*)			
5	Decal, Industrial Edger Status Lights	039355	1	
6	Status Light/Laser Power Supply Parts (*See Section 6.9*)			
7	Connector, 16-Pin Panel Mount Single Lever	E23103	1	
8	Screw, #4-40 x 1/2" Slotted Round Head	F05004-14	4	
9	Washer, #4 Split Lock	F05011-21	4	
10	Nut, #4-40 Hex	F05010-43	4	
	Connector Assy, Industrial Edger Interface	051314	1	
11	Insert, Female 10A 16P Screw Terminal 1-16	E23106	1	
12	Plug, AS050 OilTite	024685	2	
	Cable Assy, Industrial Edger Left Cover Switch	051311	1	

	Cable Assy, Industrial Edger Center Cover Switch	051312	1	
	Cable Assy, Industrial Edger Right Cover Switch	051313	1	
	Cable Assy, Industrial Edger Low Feed Prox	051315	1	
	Cable Assy, Industrial Edger Med Feed Prox	051316	1	
	Cable Assy, Industrial Edger Perimeter Switch	051317	1	
	Cable Assy, Industrial Edger Reverse Switch	051318	1	
	Harness Assy, Industrial Edger Blade Position Motor	051319	1	
	Harness Assy, Industrial Edger Feed Motor	051330	1	
	Harness Assy, Industrial Edger Blade Motor	051331	1	

5.25 Frame Assembly



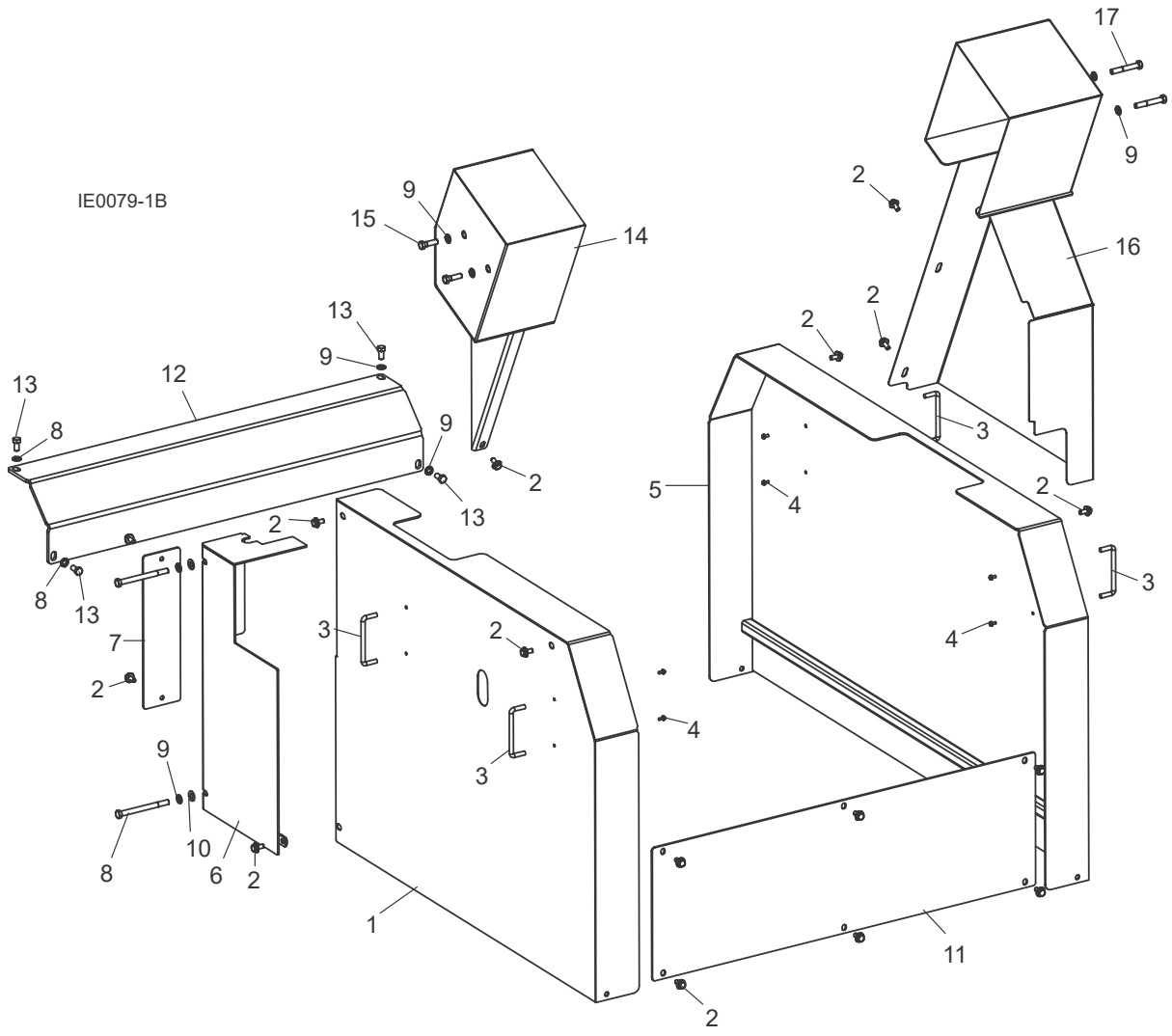
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BOLT, 5/16-18 X 3/4" HEX HEAD W/WASHER	F05006-101	1	
2	WASHER, 5/16" STANDARD FLAT	F05011-16	2	
3	NUT, 5/16-18 NYLON LOCK	F05010-58	1	
4	BUMPER, TABLE	034175	2	
5	NUT, 3/8-16 HEX NYLON LOCK	F05010-10	5	
6	BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 2	F05007-2	3	
7	WASHER, 3/8" FLAT	F05011-3	9	
8	CLAMP, 1/2" EMT COATED	P07584	10	
9	SCREW, 3/8-16 X 1" ZINC AND BAKE FS	F05007-64	4	

10	**NUT, 3/8-16 SWAGED**	F05010-25	4	
11	**WASHER, 3/8" SPLIT**	F05011-4	4	
12	**BOLT, 3/8-16 X 1" HEX HEAD**	F05007-7	4	
13	**BOLT, 5/8-11 X 3" GRADE 2**	F05009-32	3	
14	**SPROCKET, 60BB13H X 5/8" IDLER**	034224	3	
15	**COLLAR, 5/8" ID LOCK**	P05035	3	
16	**NUT, 5/8-11 NYLON LOCK**	F05010-34	3	
17	**SENSOR, IND PROXIMITY M12 PNP NS EX**	051439 [1]	3	
18	**PLATE, PROXIMITY MOUNT**	039313	1	
19	**SCREW, 1/4-20 X 3/4" BO SOCKET HEAH CAP**	F05005-26	3	
20	**BRACKET, 3/4" FLEX MOUNTING**	038752 [1]	2	
21	**NUT, #10-24 KEPS**	F05010-14	11	
22	**PLATE, SERIAL IDENTIFICATION**	S20038	1	
23	**BOLT, 5/8-11 X 4" HEX HEAD FULL THREAD GRADE 5**	F05009-31 [2]	3	
24	**NUT, 5/8-11 HEX JAM**	F05010-82 [2]	3	
25	**BOLT, #10-24 X 1 1/2" SOCKET HEAD**	F05004-51	8	
26	**WASHER, #10 SAE FLAT**	F05011-18	1	
27	**CLAMP, 1" EMT**	P05436 [1]	1	
	FOOT ASSEMBLY, EDGER	039143	4	
28	Foot Weldment, Edger	039115	1	
29	Nut, 1-14 Hex Jam	F05010-118	2	
30	**BOLT, 1/2-13 X 1 1/2" HEX HEAD GRADE 5**	F05008-33	4	
31	**NUT, 1/2-13 FREE HEX**	F05010-35	4	
32	**CHAIN, #60 X 135 3/4"**	039369	1	
33	**CHAIN, #60 X 32 1/4"**	039368	1	
34	**LINK, #60 CL**	042398	2	
35	**BOLT, 3/4-10 X 9" HEX HEAD FULL THREAD**	F05013-13	1	
36	**NUT, 3/4-10 FREE HEX**	F05010-7	1	
37	**BOLT, 5/16-18 X 3/4" HEX HEAD GRADE 2**	F05006-5	1	
38	**WASHER, 5/16" SPLIT LOCK**	F05011-13	1	
39	**LINK, #60 HALF**	036683 [3]	1	
40	**NUT, 5/8-11 UNPLATED HEX**	F05010-54	2	
41	**BUMPER, 1 1/2" X 5/8" URETHANE**	038138	4	
	PROXIMITY ASSEMBLY, E430/EG400 BOARD SENSING	038722 [1]	1	
42	Activator Weldment, Outfeed Sensor	038715	1	
43	Washer, 3/8" Flat SAE	F05011-3	3	
44	Washer, 3/8" Split Lock	F05011-4	1	
45	Bracket, Outfeed Proximity Mount	038710	1	
46	Bolt, 3/8-16 x 2 1/2" Hex Head Grade 5	F05007-125	3	
47	Nut, 3/8-16 Swagged Lock	F05010-25	2	
48	Sensor, Ind Proximity M12 PNP NS Ex	051439	1	
49	**SWITCH, SAFETY LIMIT**	039378	4	

[1] Added Proximity Sensor 051439, Clamps P05436 and 038752 replace P05088 and 039379 to accommodate larger cables, added Board Sensing Proximity Assembly 038722 (Rev. A3.00).
[2] Frame weldment modified and Bolt F05009-31 and Jam Nut F05010-82 reoriented from top for easier assembly and adjustment (Rev. A1.04).
[3] Half Link 036683 added Rev. A1.04 as needed to allow proper fit of chain.

5.26 Housing Covers & Control Assembly

E430 ***Rev. A4.00***
EG400 ***Rev. A4.00+***

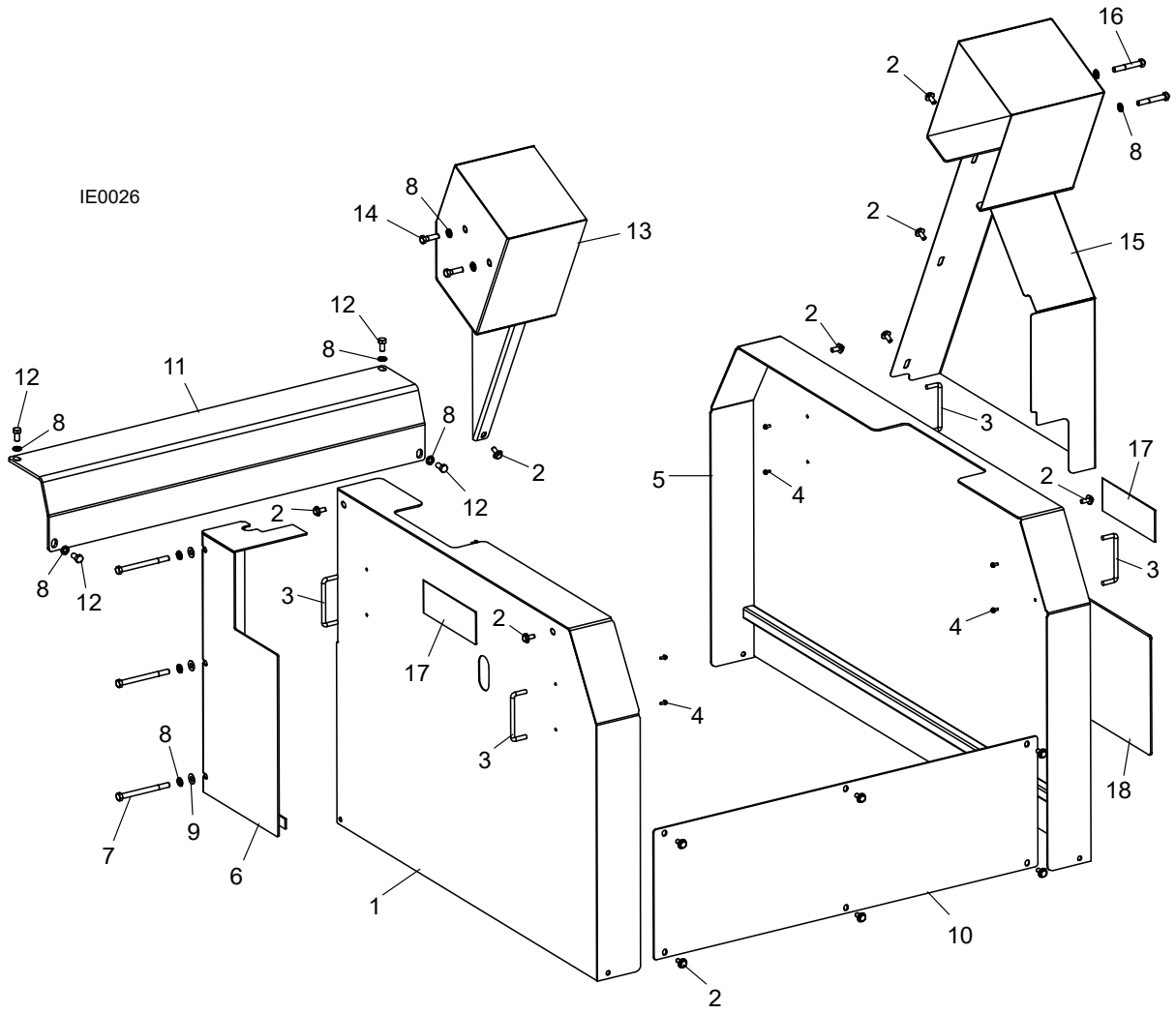


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	GUARD, FEED DRIVE SIDE REMOVABLE	039220	1	
2	BOLT, 5/16-18 X 3/4" HEX HEAD W/WASHER	F05006-101	15	
3	HANDLE, 4" W/BOLT	P08065	4	
4	SCREW, #8-32 X 3/8" SELF TAP	F05015-8	8	
5	GUARD WELDMENT, BLADE DRIVE SIDE	039219	1	
6	GUARD WELDMENT, FEED SIDE	003315	1	
7	COVER, TAILER DRIVE ACCESS	003306	1	
8	BOLT, 3/8-16 X 4 1/2" HEX HEAD	F05007-35	2	
9	WASHER, 3/8" SPLIT	F05011-4	10	

10	**WASHER, 3/8" SAE FLAT**	F05011-3	2	
11	**GUARD, LOWER FRONT**	039296	1	
12	**PLATE, DRIVE GUARD**	039210	1	
13	**BOLT, 3/8-16 X 3/4 HEX HEAD**	F05007-27	4	
14	**GUARD WELDMENT. ELEC BOX SIDE TOP**	039228	1	
15	**BOLT, 3/8-16 X 1 1/4" HEX HEAD GR5**	F05007-123	2	
16	**GUARD WELDMENT, MOTOR SHEAVE**	039229	1	
17	**BOLT, 3/8-16 X 2 1/2" HEX HEAD GR5**	F05007-125	2	

5.27 Housing Covers & Control Assembly

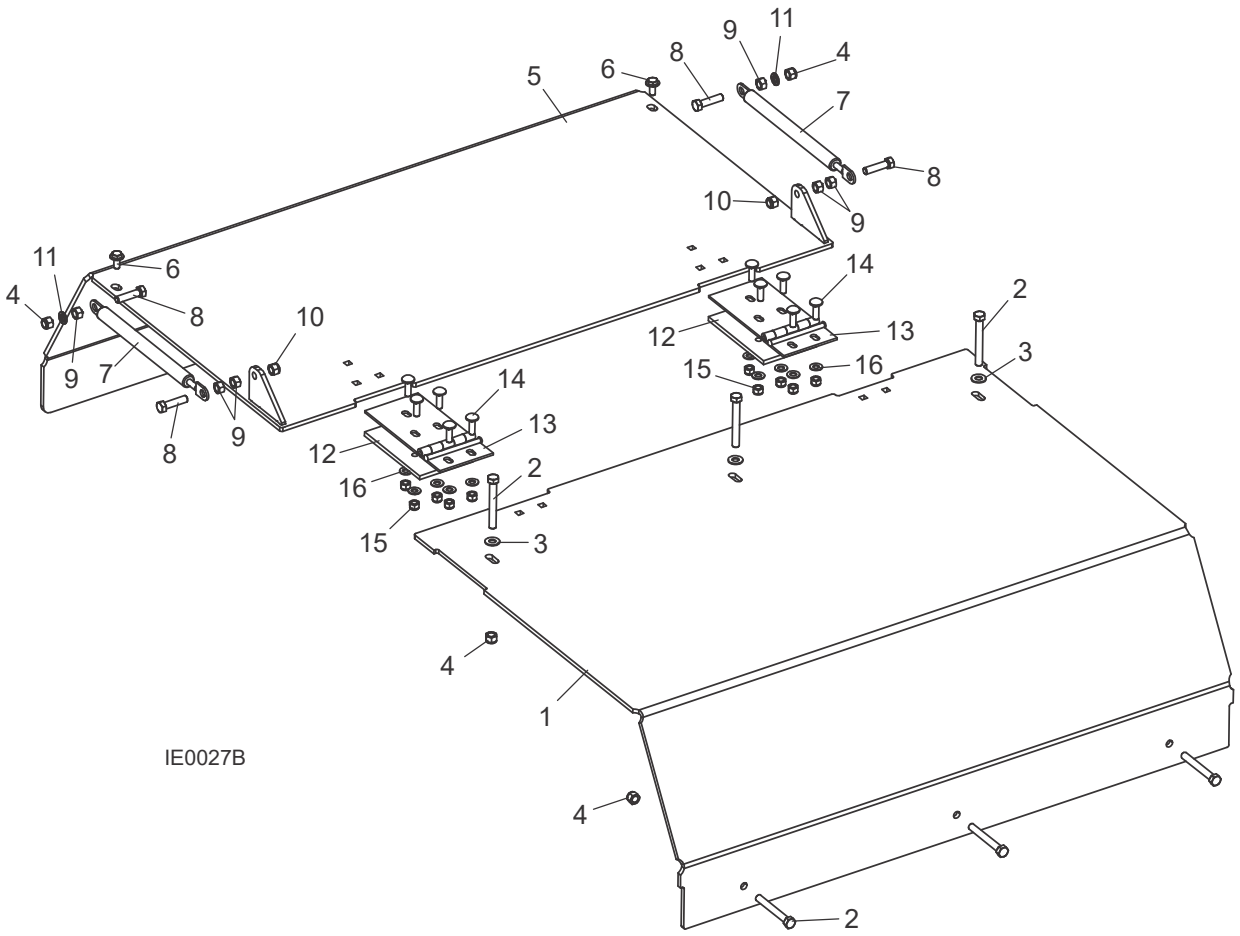
E430 ***Rev. A1.00 - A3.01***



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	GUARD, FEED DRIVE SIDE REMOVABLE	039220	1	
2	BOLT, 5/16-18 X 3/4" HEX HEAD W/WASHER	F05006-101	13	
3	HANDLE, 4" W/BOLT	P08065	4	
4	SCREW, #8-32 X 3/8" SELF TAP	F05015-8	8	
5	GUARD WELDMENT, BLADE DRIVE SIDE	039219	1	
6	GUARD WELDMENT, FEED SIDE FIXED	039248	1	
7	BOLT, 3/8-16 X 4 1/2" HEX HEAD	F05007-35	3	
8	WASHER, 3/8" SPLIT	F05011-4	11	
9	WASHER, 3/8" SAE FLAT	F05011-3	3	
10	GUARD, LOWER FRONT	039296	1	

11	**PLATE, DRIVE GUARD**	039210	1	
12	**BOLT, 3/8-16 X 3/4" HEX HEAD**	F05007-27	4	
13	**GUARD WELDMENT. ELEC BOX SIDE TOP**	039228	1	
14	**BOLT, 3/8-16 X 1 1/4" HEX HEAD GR5**	F05007-123	2	
15	**GUARD WELDMENT, MOTOR SHEAVE**	039229	1	
16	**BOLT, 3/8-16 X 2 1/2" HEX HEAD GR5**	F05007-125	2	
17	**DECAL, MOVING PARTS DANGER**	033254	2	
18	**DECAL, INDUSTRIAL EDGER LOGO**	039384	1	

5.28 Top Blade Guard Assembly

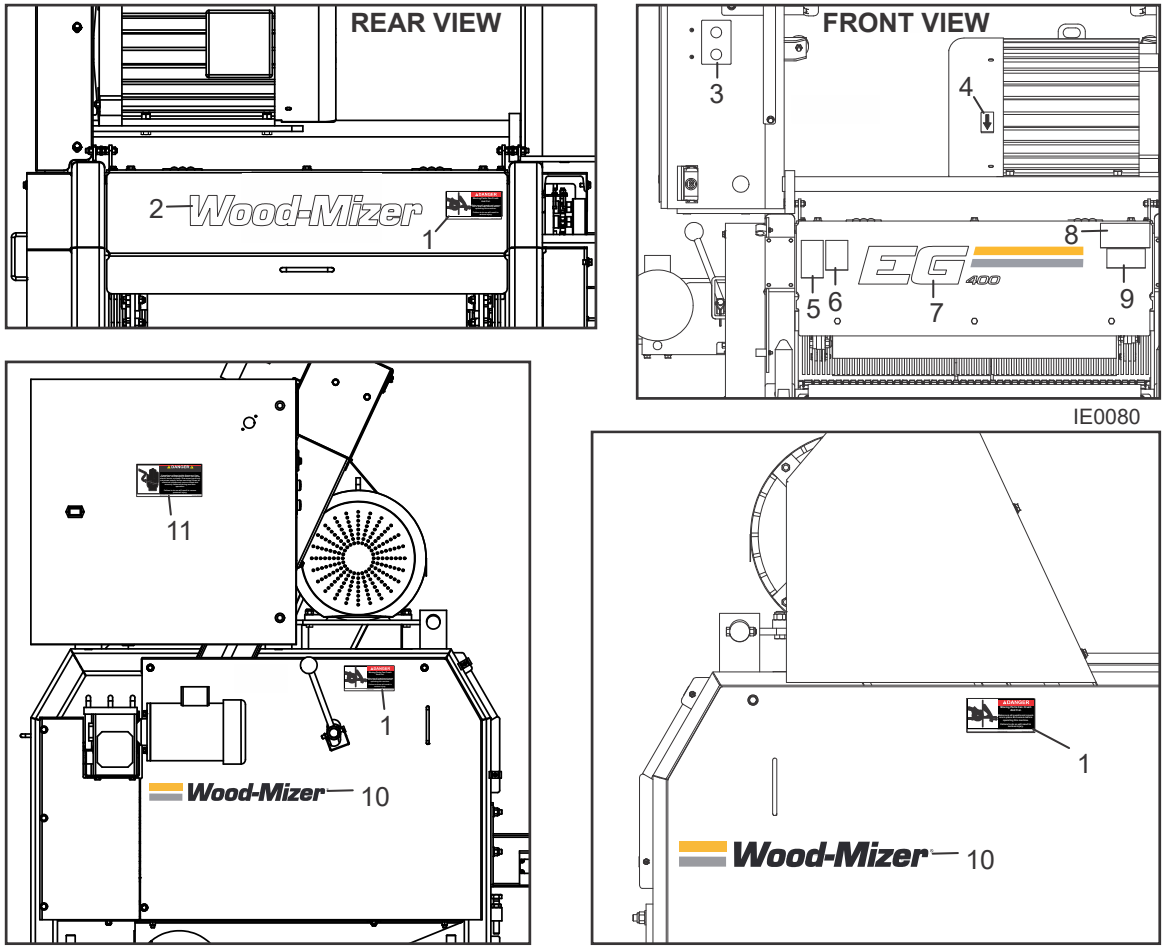


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	GUARD ASSEMBLY, TOP BLADE	039273	1	
1	Plate, Top Front Cover	039020	1	
2	Bolt, 3/8-16 x 3 Hex Head Full Thread	F05007-1	6	
3	Washer, 3/8 Flat	F05011-3	3	
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	8	
5	Guard Weldment, Rear Blade	039272	1	
6	Bolt, 5/16-18 x 3/4 Hex Head W/Washer	F05006-101	2	
7	Spring, Perimeter Fence Gas	P22309	2	
8	Bolt, 3/8-16 x 1 1/2 Hex Head Full Thread	F05007-17	4	
9	Nut, 3/8-16 Hex	F05010-1	6	
10	Nut, 3/8-16 Swaged	F05010-25	2	
11	Washer, 3/8 Split	F05011-4	2	
12	Plate, Hinge Stiffener	039314	2	
13	Hinge, 2 x 5.5 x 3.5 x .125, w/Slots	038136	2	

14	Bolt, 5/16-18 x 1 Carriage	F05006-9	10	
15	Nut, 5/16-18 Nylon Lock	F05010-58	10	
16	Washer, 5/16 SAE Flat	F05011-17	10	

5.29 Decals

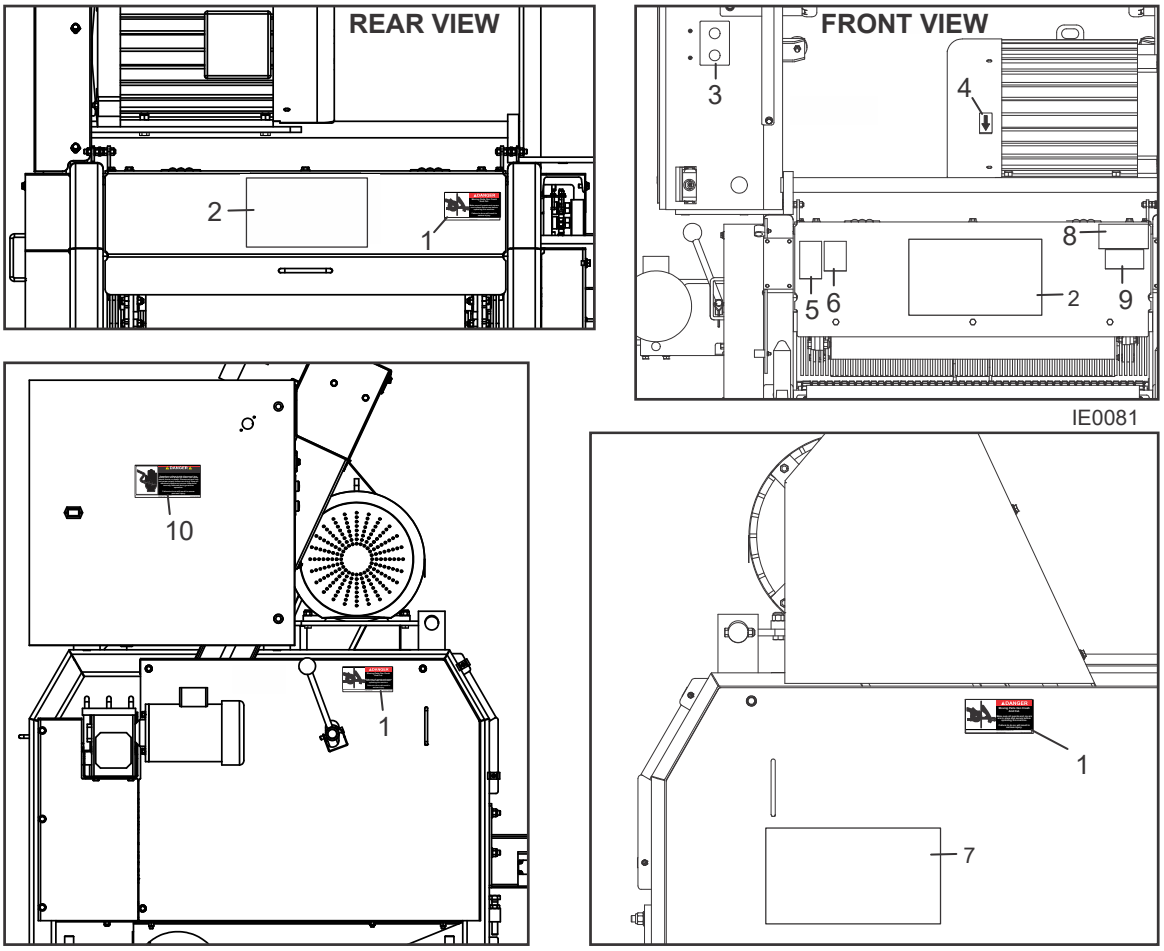
EG400 ***Rev. A4.01+***



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	DECAL, MOVING PARTS DANGER	033254	2	
2	DECAL, WOOD-MIZER LOGO 20.5" WHITE	065034	1	
3	DECAL, E430/EG400 STATUS LIGHT	052289	1	
4	DECAL, MOTOR DIRECTION	S20097	1	
5	DECAL, BLADE HAZARD DANGER	038176	1	
6	DECAL, EYE/EAR PROTECTION WARNING	S11753	1	
7	DECAL, EG400 LOGO	076279	1	
8	DECAL, READ MANUAL WARNING	016402	1	
9	DECAL, KICKBACK HAZARD WARNING	038134	1	
10	DECAL, WOOD-MIZER LOGO WITH STRIPES	076273	2	
11	DECAL, ELECTRICAL HAZARD DANGER	S20061	1	

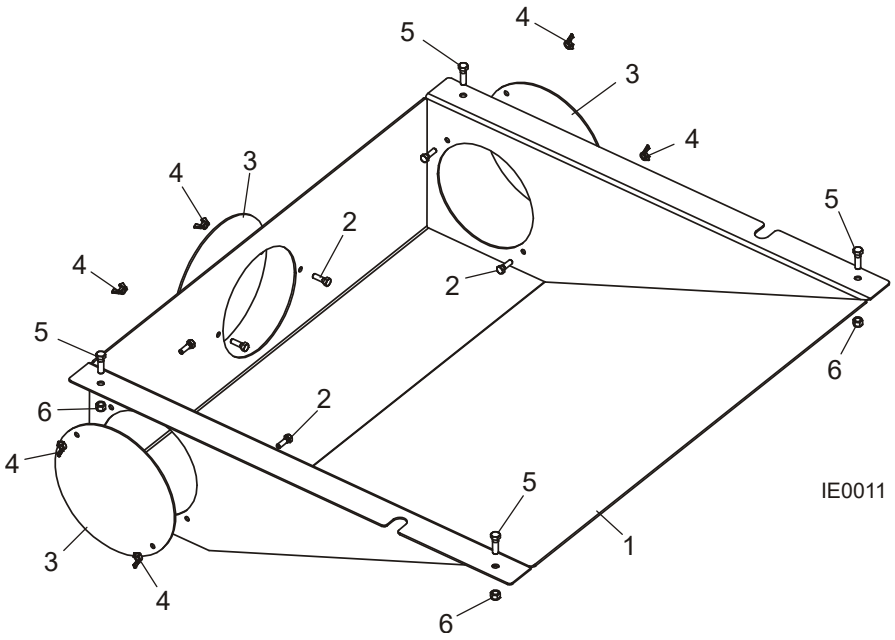
5.30 Decals

EG400 ***Rev. A4.00***
E430 ***Rev. A1.00 - A4.00***



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	DECAL, MOVING PARTS DANGER	033254	2	
2	DECAL, LOGO E430/EG400 BLADE DOOR	039383	2	
3	DECAL, E430/EG400 STATUS LIGHT	052289	1	
4	DECAL, MOTOR DIRECTION	S20097	1	
5	DECAL, BLADE HAZARD DANGER	038176	1	
6	DECAL, EYE/EAR PROTECTION WARNING	S11753	1	
7	DECAL, INDUSTRIAL EDGER LOGO	039384	1	
8	DECAL, READ MANUAL WARNING	016402	1	
9	DECAL, KICKBACK HAZARD WARNING	038134	1	
10	DECAL, ELECTRICAL HAZARD DANGER	S20061	1	

5.31 Chute Assembly



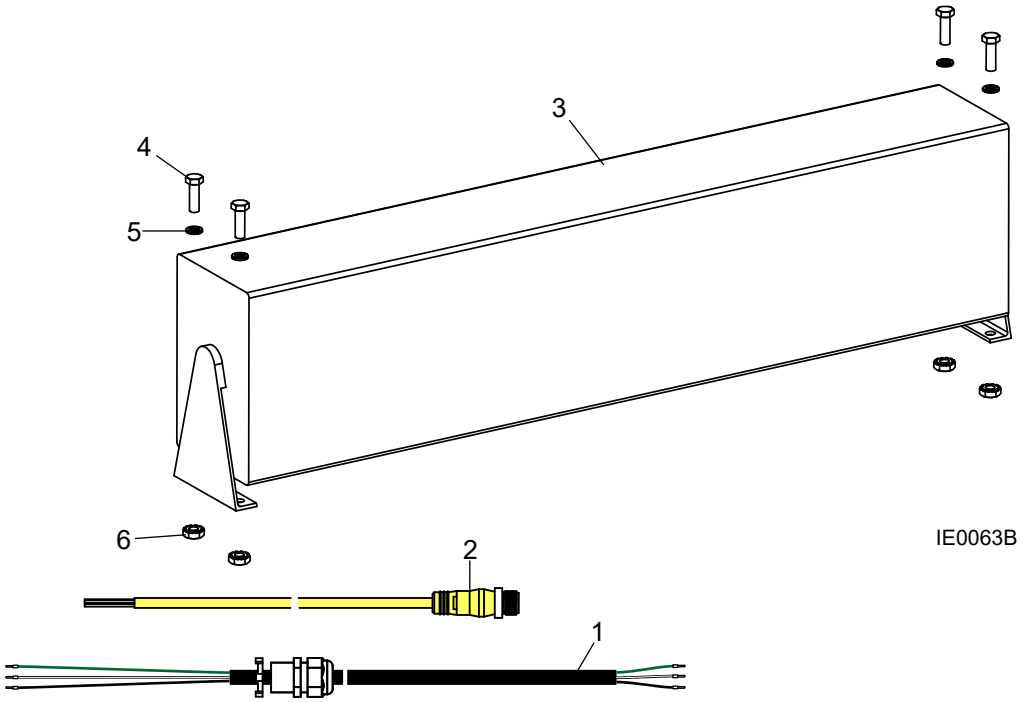
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	CHUTE ASSEMBLY, INDUSTRIAL EDGER	039290	1	
1	Hopper Weldment, Industrial Edger	039289	1	
2	Bolt, 5/16-18 x 1 Hex Head Gr2	F05006-1	6	
3	Cover, Hopper Hole	039288	3	
4	Nut, 5/16-18 Wing	F05010-23	6	
5	Bolt, 3/8-16 x 1 1/4 Hex Head Gr5	F05007-123	4	
6	Nut, 3/8-16 Hex Nylon Lock	F05010-10	4	

5.32 Setworks Retrofit (Optional)

E430 ***Rev. A3.00 - A4.00***
EG400 ***Rev. A4.00+***

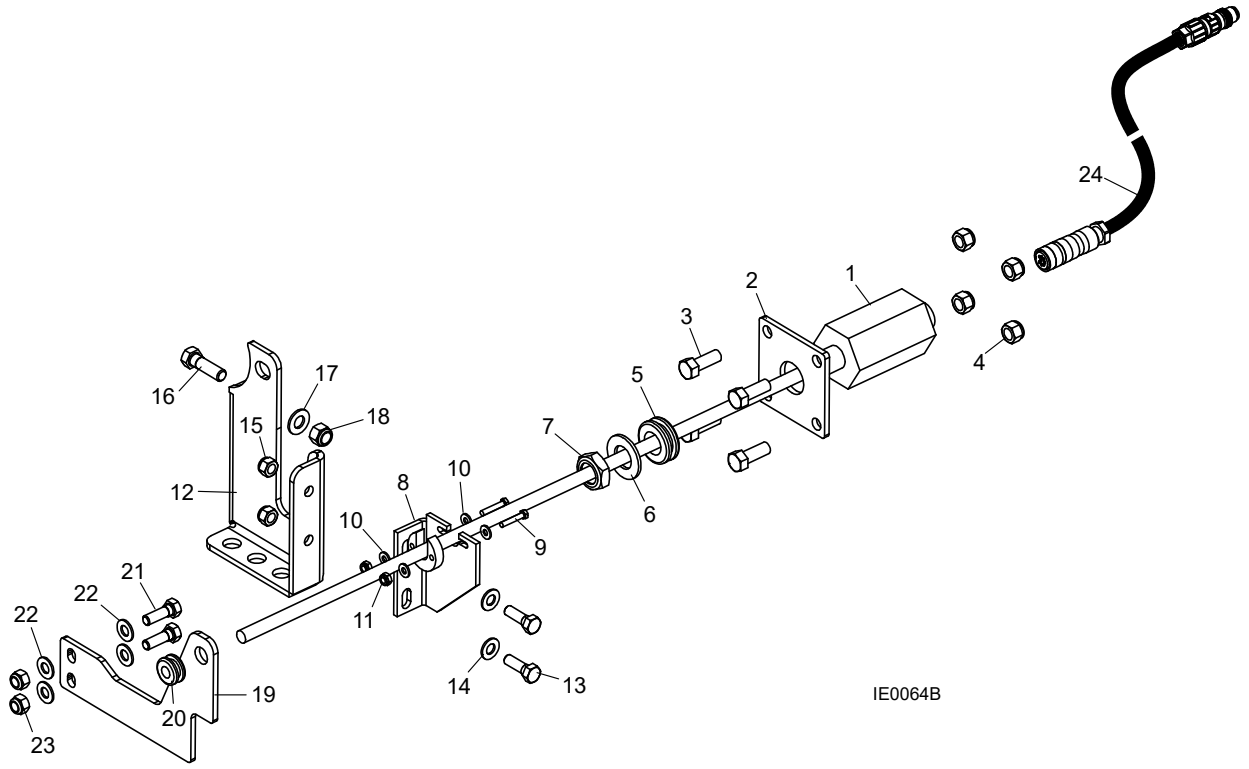
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SETWORKS RETROFIT, E430/EG400 (FIELD INSTALLED)	E4SET-A	1	
1	Transducer Cover Parts (*See Section 5.35*)			
2	Transducer Parts (*See Section 5.34*)			
3	LED Display Parts (*See Section 5.33*)			
4	Wireless Remote Parts (*See Section 5.37*)			
5	Add-On Control Switch Parts (*See Section 5.36*)			
6	Instruction Sheet, E430/EG400 Remote Option	E4REM-1271	1	
7	Instruction Sheet, E430/EG400 Setworks Option	E4SET-1270	1	

5.33 Display Assembly (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	DISPLAY ASSEMBLY, LED 10" CHARACTER	038764	1	
1	Cable Assembly, E430/EG400 Display Power	052780	1	
2	Cable Assembly, E430/EG400 Display to Box	052784	1	
3	Display, 2" x 10" Character LED	038762	1	
4	Screw, 10-24 x 5/8" Hex Head	F05004-18	4	
5	Washer, #10 Split Lock	F05011-20	4	
6	Nut, #10-24 Keps	F05010-14	4	

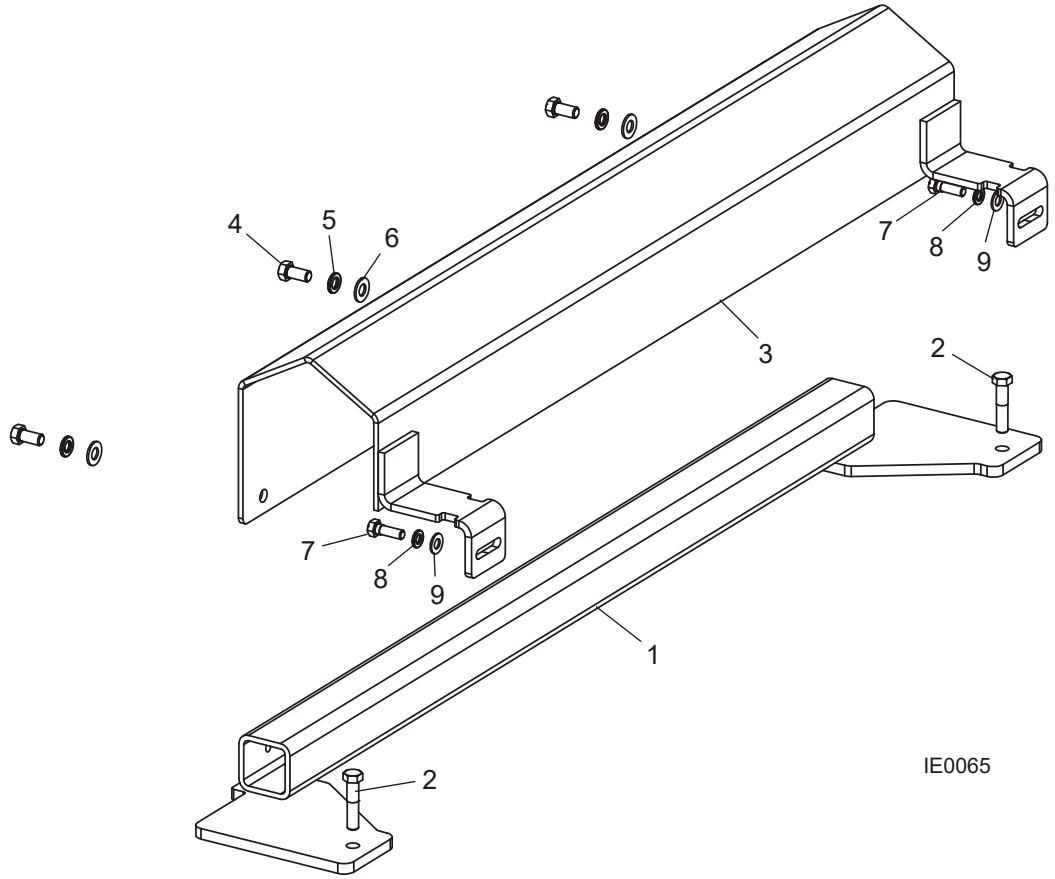
5.34 Transducer Assembly (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	TRANSDUCER ASSEMBLY, E430/EG400 EDGER	038701	1	
1	Transducer, Position 20"	038694	1	
2	Plate, Linear Sensor Mount	038689	1	
3	Bolt, 3/8-16 x 1" Hex Head	F05007-7	4	
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	4	
5	Grommet, 3/4" ID Rubber	025247	1	
6	Washer, 3/4" ID Nylon	025250	1	
7	Nut, 3/4-16 Nylon Lock	F05010-171	1	
8	Plate, E430/EG400 Transducer Ring Mount	038695	1	
9	Screw, #8-32 x 7/8" Hex Head Stainless Steel	F05004-182	2	
10	Washer, #8 Sae Flat	F05011-41	4	
11	Nut, #8-32 Hex Nylon Lock	F05010-169	2	
12	Bracket, Pusher Magnet Mount	038688	1	
13	Bolt, 5/16-18 x 1" Hex Head Grade 2	F05006-1	2	
14	Washer, 5/16" SAE Flat	F05011-17	2	
15	Nut, 5/16-18 Nylon Lock	F05010-58	2	
16	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5	F05007-123	1	
17	Washer, 3/8" SAE Flat	F05011-3	1	
18	Nut, 3/8-16 Hex Nylon Lock	F05010-10	1	

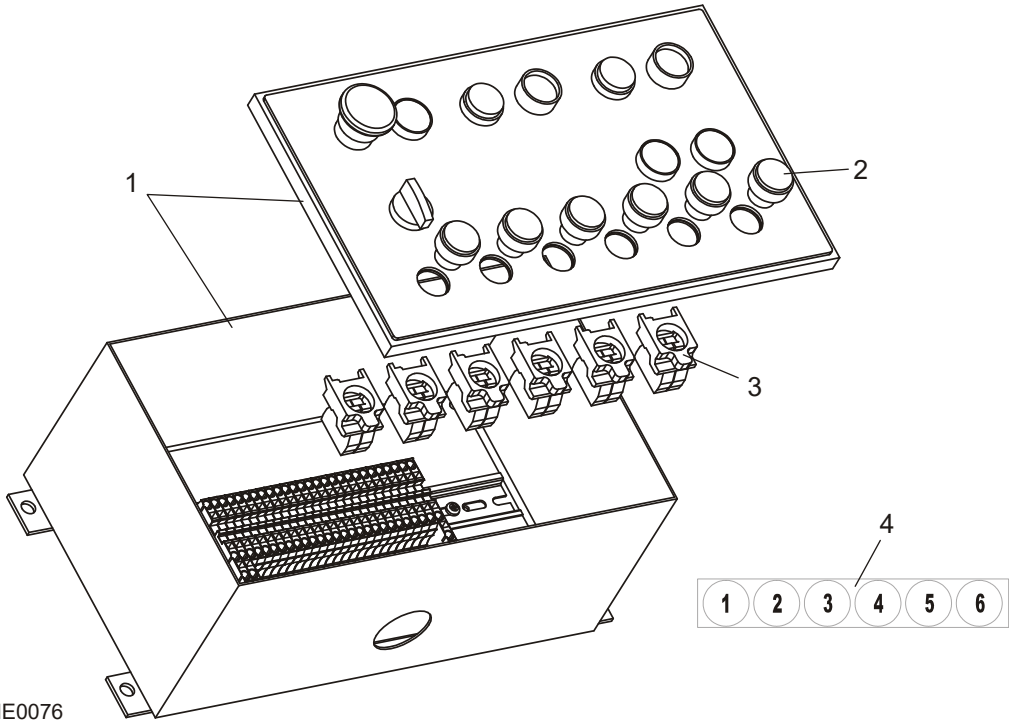
19	Bracket, 7Ga Rod End	038700	1	
20	Grommet, Rubber 3/8" ID	025248	1	
21	Bolt, 5/16-18 x 1" Hex Head Grade 2	F05006-1	2	
22	Washer, 5/16" SAE Flat	F05011-17	4	
23	Nut, 5/16-18 Nylon Lock	F05010-58	2	
24	Cable Assembly, E430/EG400 Transducer	052781	1	

5.35 Transducer Cover Assembly (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	COVER ASSEMBLY, E430/EG400 EDGER TRANSDUCER	038718	1	
1	Tube Weldment, E430/EG400 Cross Cover	038706	1	
2	Bolt, 3/8-16 x 1 3/4" Grade 5	F05007-119	2	
3	Guard Weldment, E430/EG400 Transducer	038707	1	
4	Bolt, 3/8-16 x 3/4" Hex Head Grade 5	F05007-118	3	
5	Washer, 3/8" Split Lock	F05011-4	3	
6	Washer, 3/8" Flat SAE	F05011-3	3	
7	Bolt, 5/16-18 x 1" Hex Head Grade 2	F05006-1	2	
8	Washer, 5/16" Split Lock	F05011-13	2	
9	Washer, 5/16" SAE Flat	F05011-17	2	

5.36 Setworks Switch Assembly (Optional)



IE0076

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	**CONTROL ASSEMBLY, OPERATOR** (*See Section 5.20*)			
	SWITCH KIT, E430/EG400 SETWORKS (FIELD INSTALLED)	052819	1	
2	Switch Head, 22mm Mom Flush LED Blue XB4	025237-68	6	
3	Switch Body, 22mm Blue LED 1 NO 24V XB4	025236-61	6	
4	Label Set, E430/EG400 Setworks Preset	052822	1	

5.37 Remote Assembly (Optional)

IE0075

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	REMOTE ASSEMBLY, E430/EG400 BLADE POSITION WIRELESS	E4REM	1	
1	Transmitter, 6-Button Remote	052798	1	
	Receiver Assembly, 6-Function w/Connector	052800	1	
	Screw, 1/4-20 x 5/8" Socket Cap Stainless Steel	F05005-128	4	
	Antenna Kit, 2-Foot Extension	052801	1	
	Washer, 5/8 x 15/16 x .094 Nylon	F05011-19	1	

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Symbol Diagram

EG400EC30 ***Rev. A5.00+***

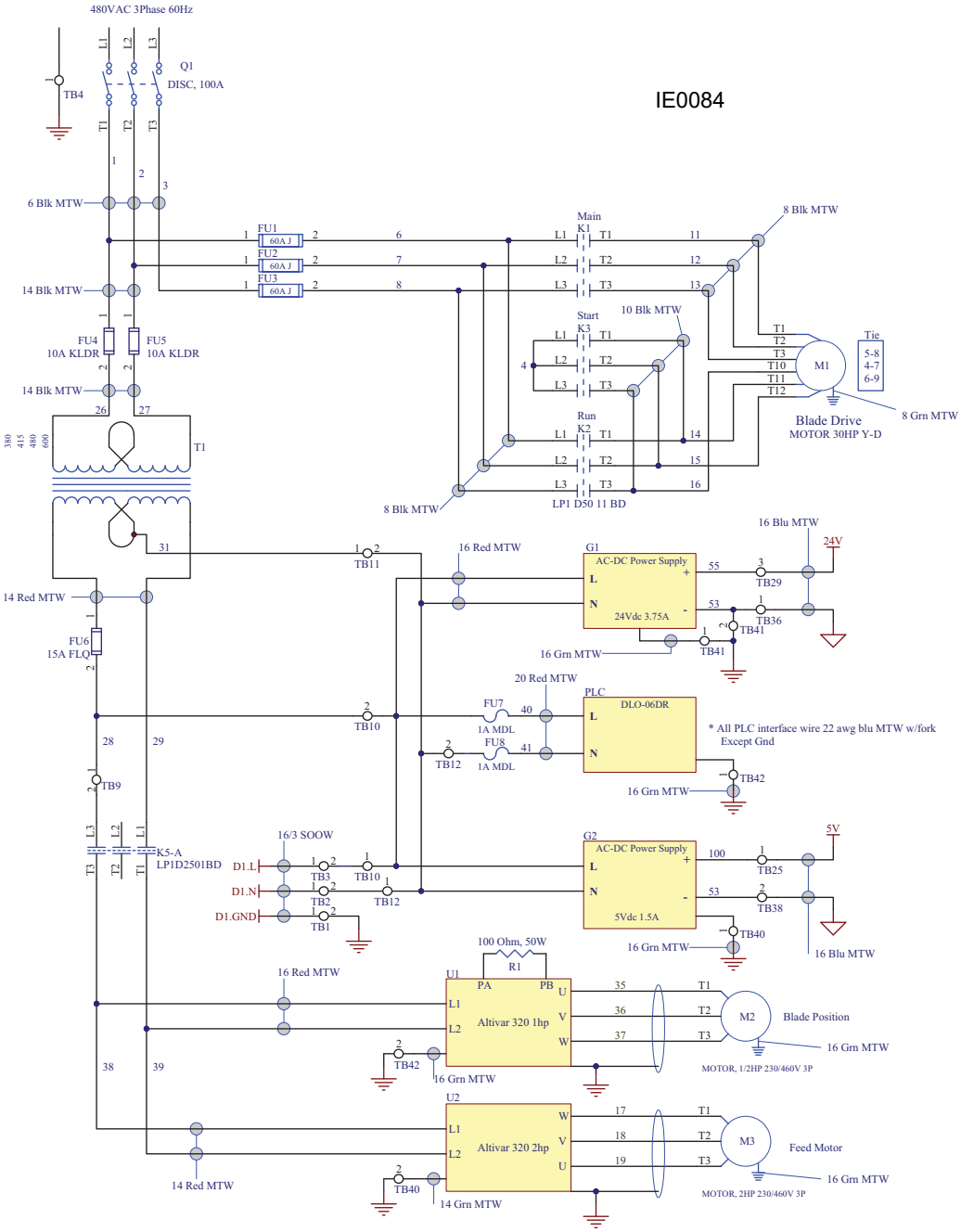


FIG. 6-1 SYMBOL DIAGRAM (1 OF 6)

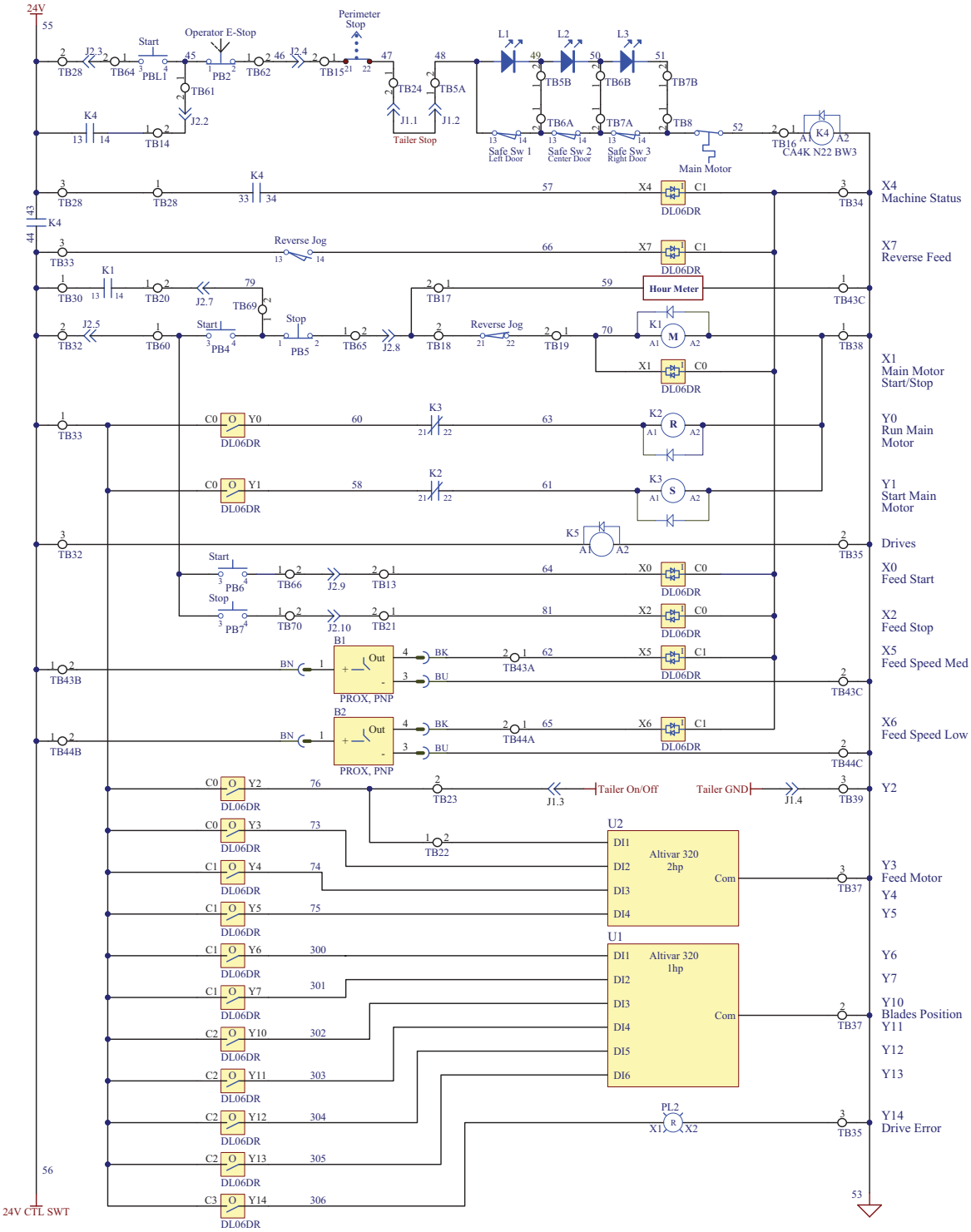


FIG. 6-1 SYMBOL DIAGRAM (2 OF 6)

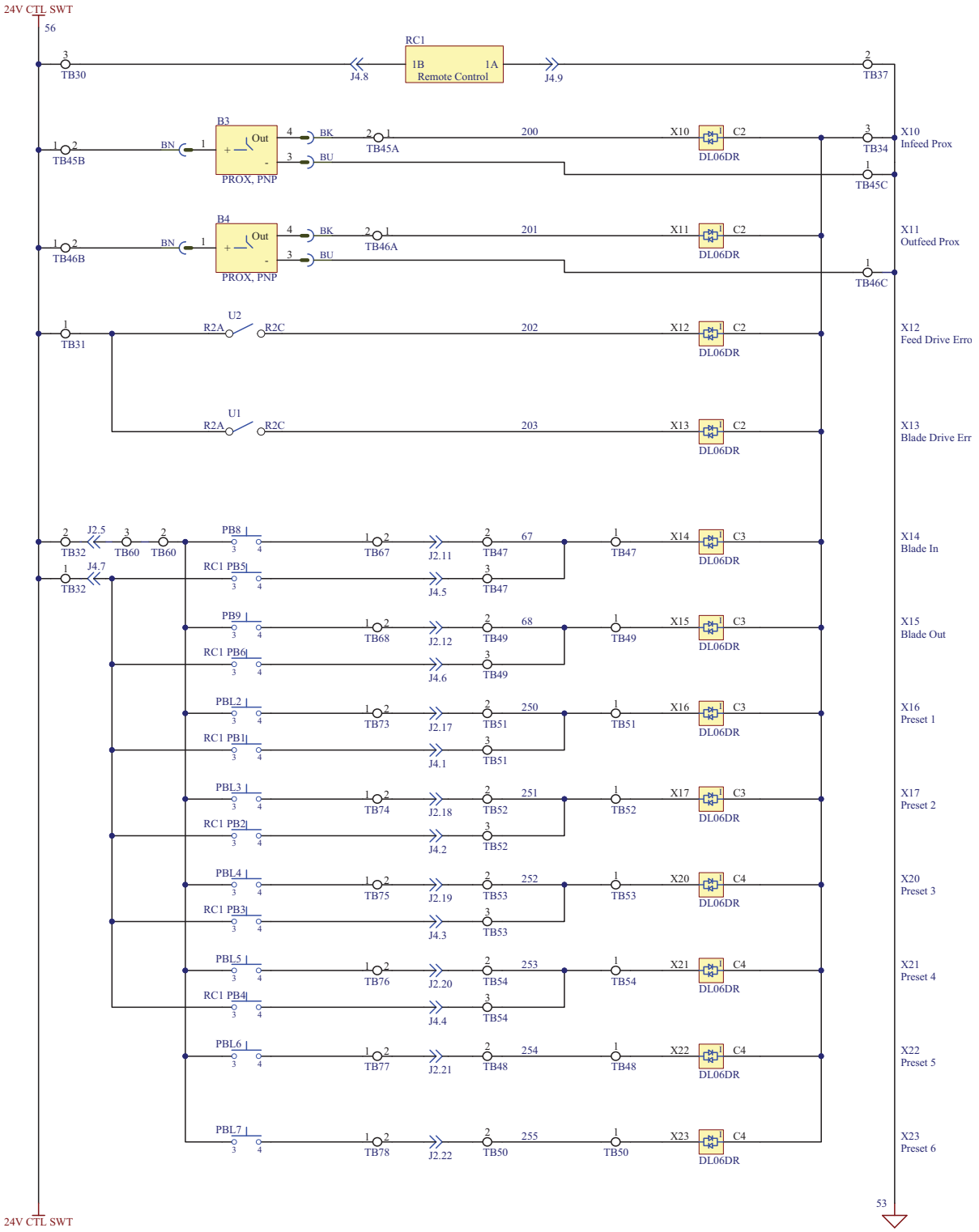

24V CTL SWT
56
TB30
J4.8
RC1
1B
1A
Remote Control
J4.9
TB37
B3
Out
PROX, PNP
BN
BK
BU
TB45B
TB45A
TB45C
200
X10
C2
DL06DR
TB34
X10
Infeed Prox
B4
TB46B
TB46A
TB46C
201
X11
Outfeed Prox
U2
R2A
R2C
TB31
202
X12
Feed Drive Erro
U1
203
X13
Blade Drive Err
J2.5
TB32
TB60
PB8
RC1 PB5
J4.7
TB67
J2.11
TB47
67
X14
Blade In
J4.5
PB9
RC1 PB6
TB68
J2.12
TB49
68
X15
Blade Out
J4.6
PBL2
RC1 PB1
TB73
J2.17
TB51
250
X16
Preset 1
J4.1
PBL3
RC1 PB2
TB74
J2.18
TB52
251
X17
Preset 2
J4.2
PBL4
RC1 PB3
TB75
J2.19
TB53
252
X20
Preset 3
J4.3
PBL5
RC1 PB4
TB76
J2.20
TB54
253
X21
Preset 4
J4.4
PBL6
TB77
J2.21
TB48
254
X22
Preset 5
PBL7
TB78
J2.22
TB50
255
X23
Preset 6
53
24V CTL SWT

FIG. 6-1 (3 OF 6)

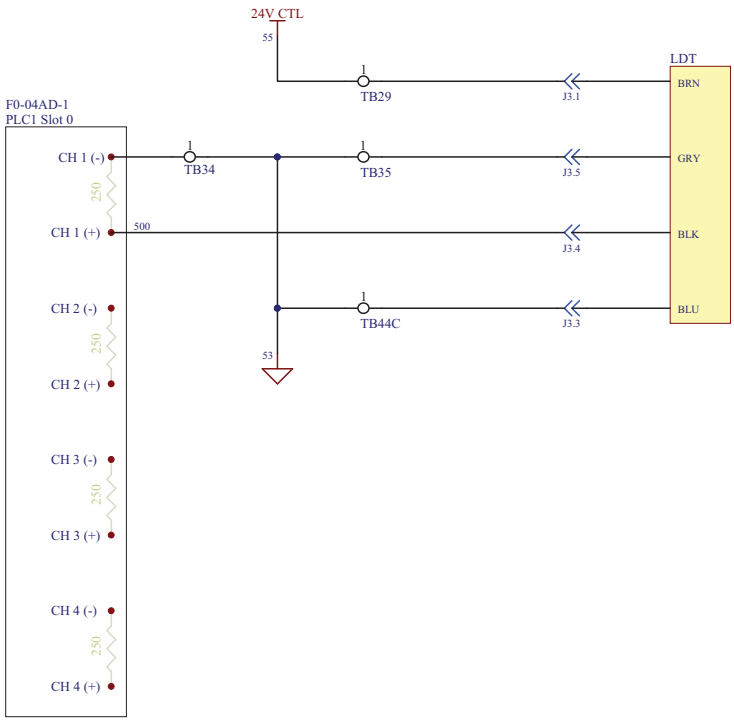

24V CTL
55
LDT
1
TB29
J3.1
BRN
F0-04AD-1
PLC1 Slot 0
CH 1 (-)
1
TB34
1
TB35
J3.5
GRY
250
CH 1 (+)
500
J3.4
BLK
CH 2 (-)
1
TB44C
J3.3
BLU
250
53
CH 2 (+)
CH 3 (-)
250
CH 3 (+)
CH 4 (-)
250
CH 4 (+)

FIG. 6-1 (4 OF 6)

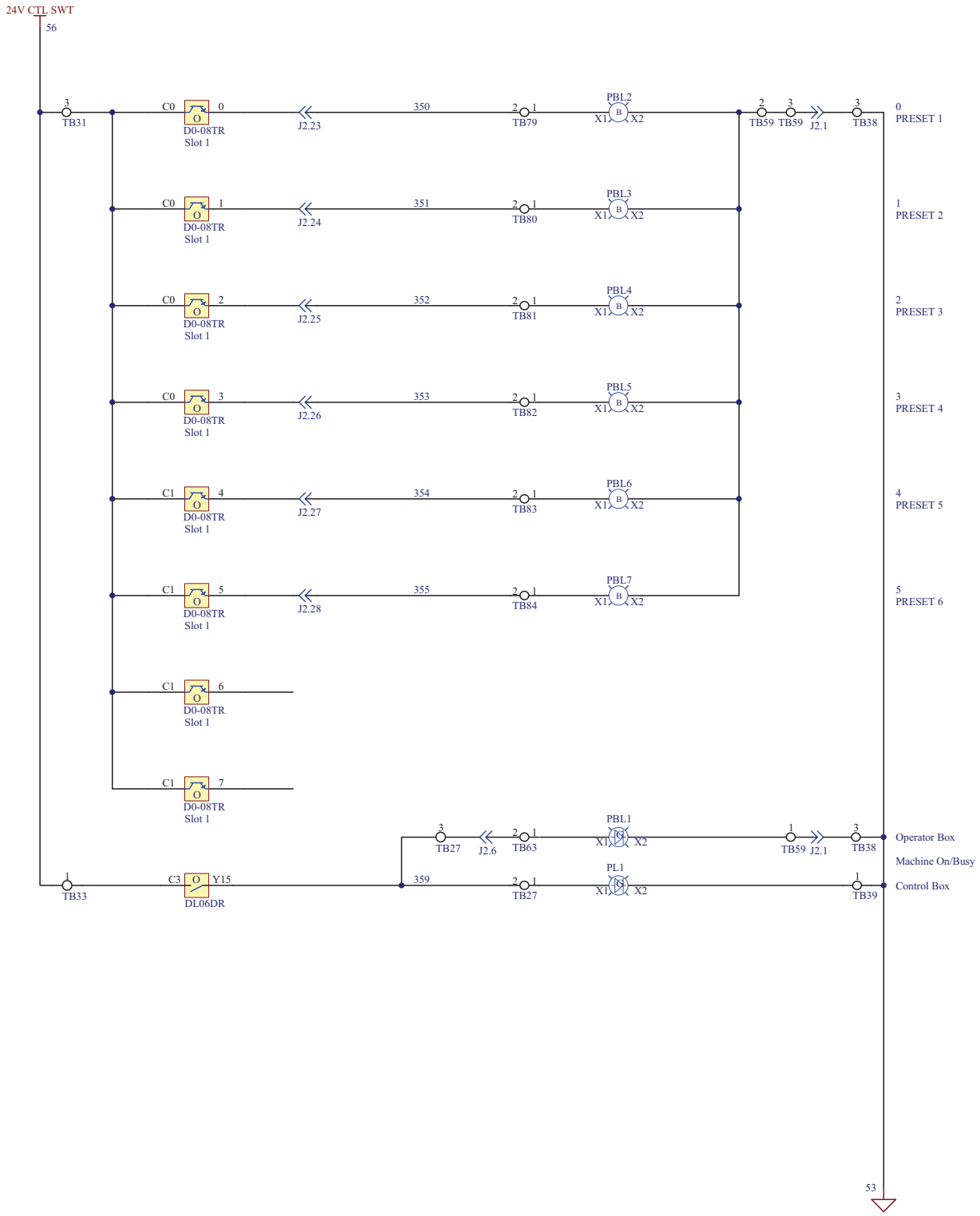

24V CTL SWT
56
TB31
C0
D0-08TR
Slot 1
J2.23
350
TB79
PBL2
X1
X2
TB59
TB59
J2.1
TB38
0
PRESET 1
J2.24
351
TB80
PBL3
1
PRESET 2
J2.25
352
TB81
PBL4
2
PRESET 3
J2.26
353
TB82
PBL5
3
PRESET 4
C1
J2.27
354
TB83
PBL6
4
PRESET 5
J2.28
355
TB84
PBL7
5
PRESET 6
6
7
TB27
J2.6
TB63
PBL1
Operator Box
Machine On/Busy
TB33
C3
Y15
DL06DR
359
PL1
Control Box
TB39
53

FIG. 6-1 (5 OF 6)

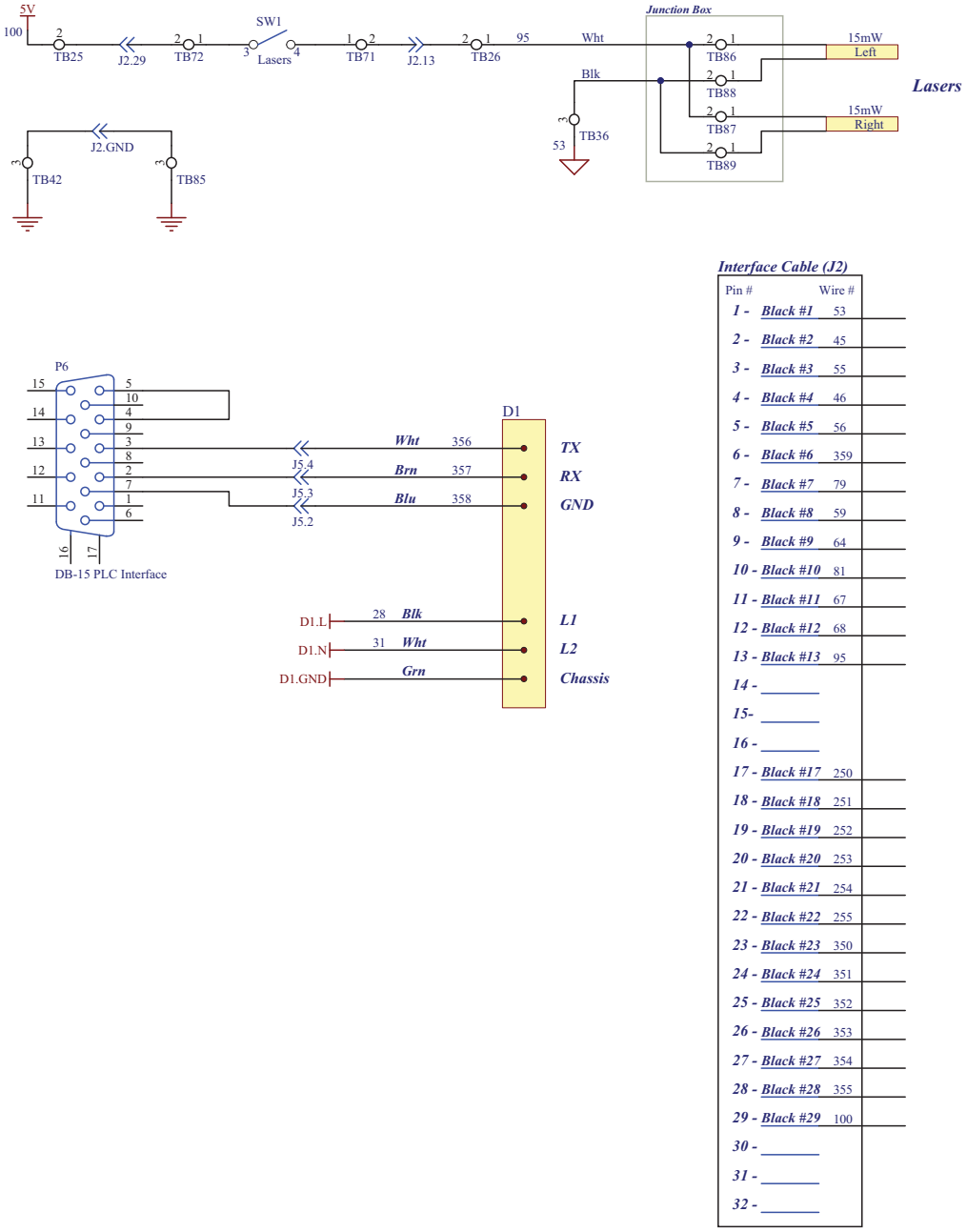

5V
100
TB25
J2.29
TB72
SW1
Lasers
TB71
J2.13
TB26
95
Wht
Junction Box
TB86
15mW
Left
Blk
TB88
Lasers
TB87
15mW
Right
TB36
53
TB89
J2.GND
TB42
TB85
P6
DB-15 PLC Interface
16
17
D1
J5.4
J5.3
J5.2
Wht 356
Brn 357
Blu 358
TX
RX
GND
D1.L
D1.N
D1.GND
28 Blk
31 Wht
Grn
L1
L2
Chassis
Interface Cable (J2)
Pin # Wire #
1 - Black #1 53
2 - Black #2 45
3 - Black #3 55
4 - Black #4 46
5 - Black #5 56
6 - Black #6 359
7 - Black #7 79
8 - Black #8 59
9 - Black #9 64
10 - Black #10 81
11 - Black #11 67
12 - Black #12 68
13 - Black #13 95
14 -
15-
16 -
17 - Black #17 250
18 - Black #18 251
19 - Black #19 252
20 - Black #20 253
21 - Black #21 254
22 - Black #22 255
23 - Black #23 350
24 - Black #24 351
25 - Black #25 352
26 - Black #26 353
27 - Black #27 354
28 - Black #28 355
29 - Black #29 100
30 -
31 -
32 -

FIG. 6-1 (6 OF 6)

6.2 Electrical Symbol Diagram

EG400EC30 Rev. A4.03 - A4.04

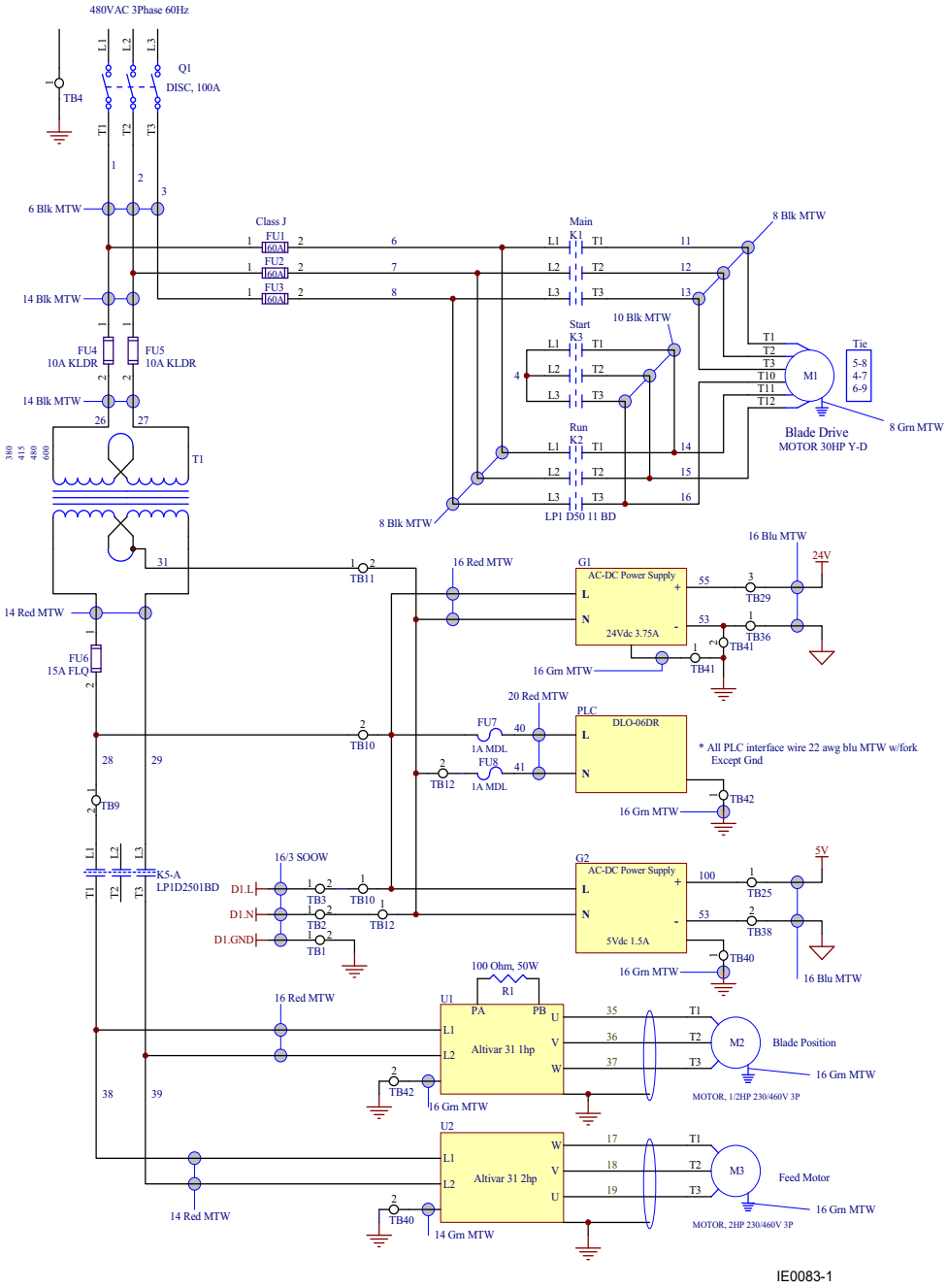
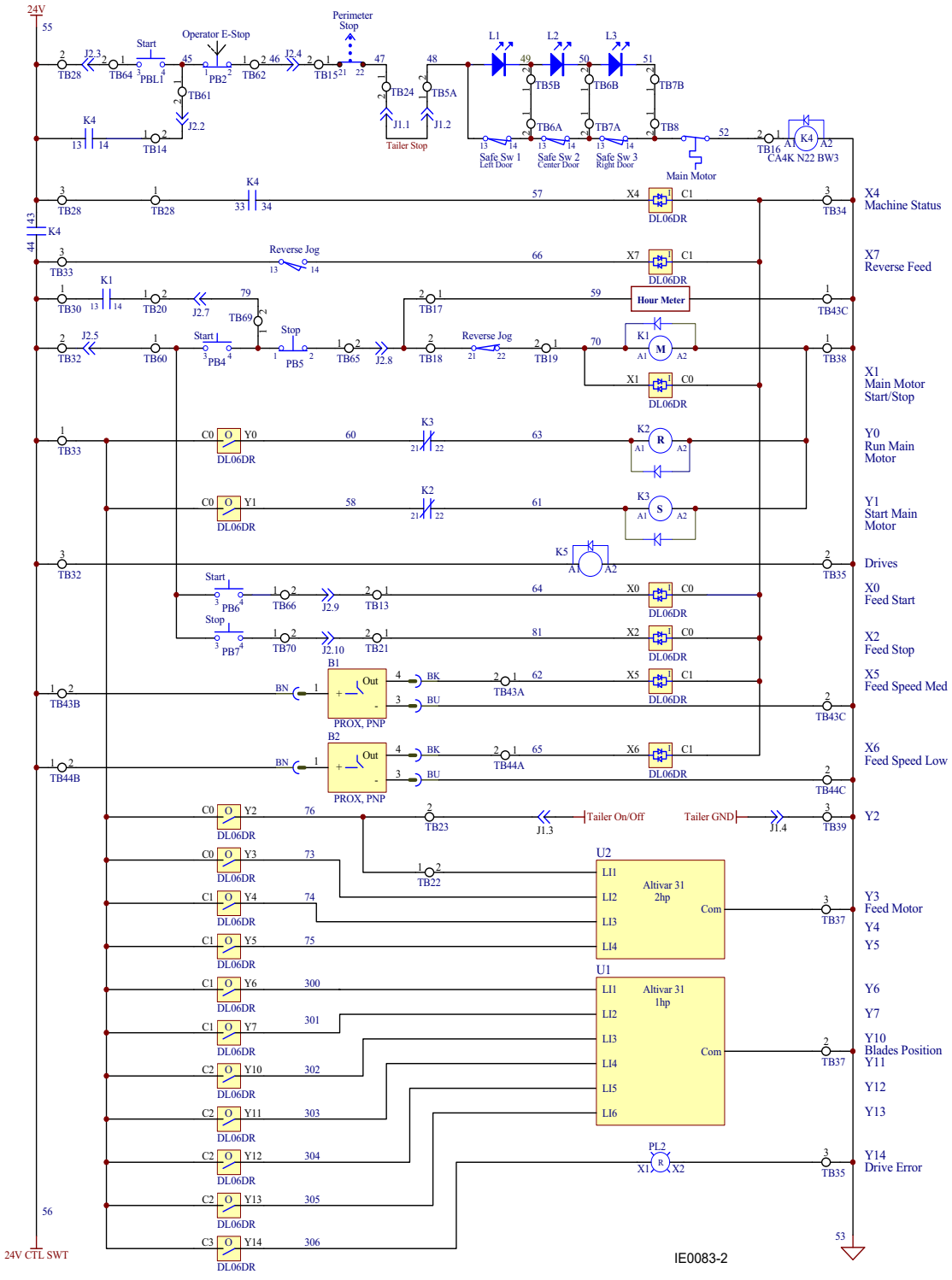
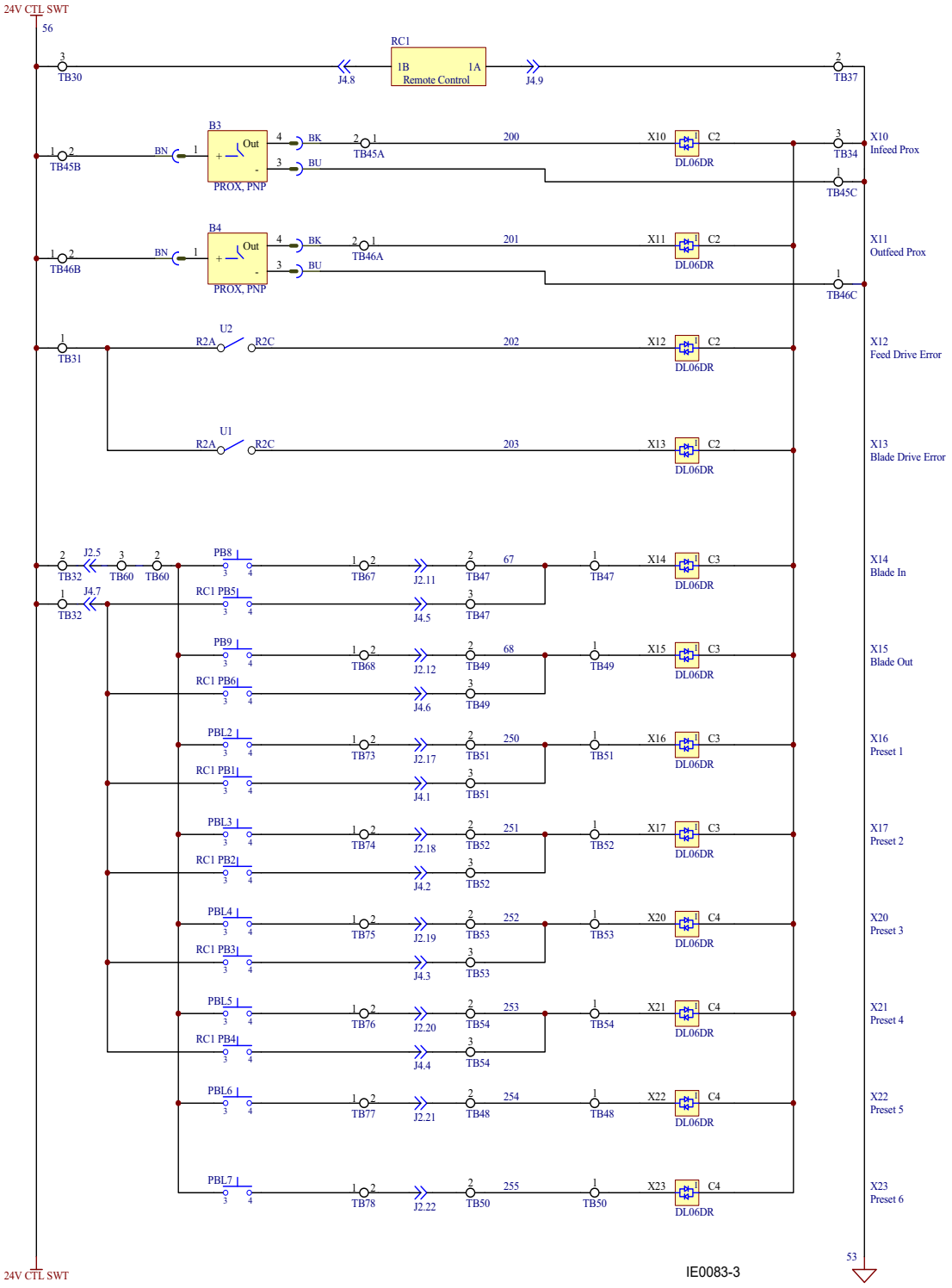


FIG. 6-2 SYMBOL DIAGRAM (1 OF 6)



Wood-Mizer Industrial Edger **Page 2**

FIG. 6-2 SYMBOL DIAGRAM (2 OF 6)



Wood-Mizer Industrial Edger **Page 3**

FIG. 6-2 (3 OF 6)

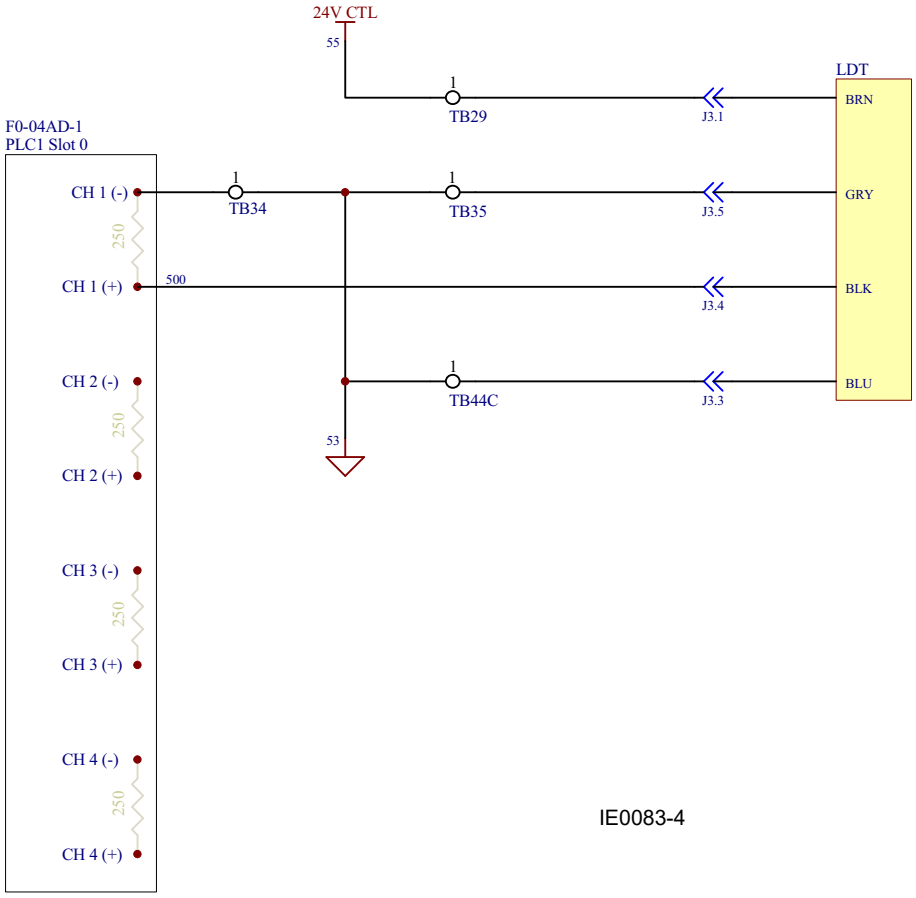

24V CTL
55
1
TB29
J3.1
LDT
BRN
F0-04AD-1
PLC1 Slot 0
CH 1 (-)
1
TB34
1
TB35
J3.5
GRY
250
CH 1 (+)
500
J3.4
BLK
CH 2 (-)
1
TB44C
J3.3
BLU
250
53
CH 2 (+)
CH 3 (-)
250
CH 3 (+)
CH 4 (-)
250
CH 4 (+)
IE0083-4

FIG. 6-2 (4 OF 6)

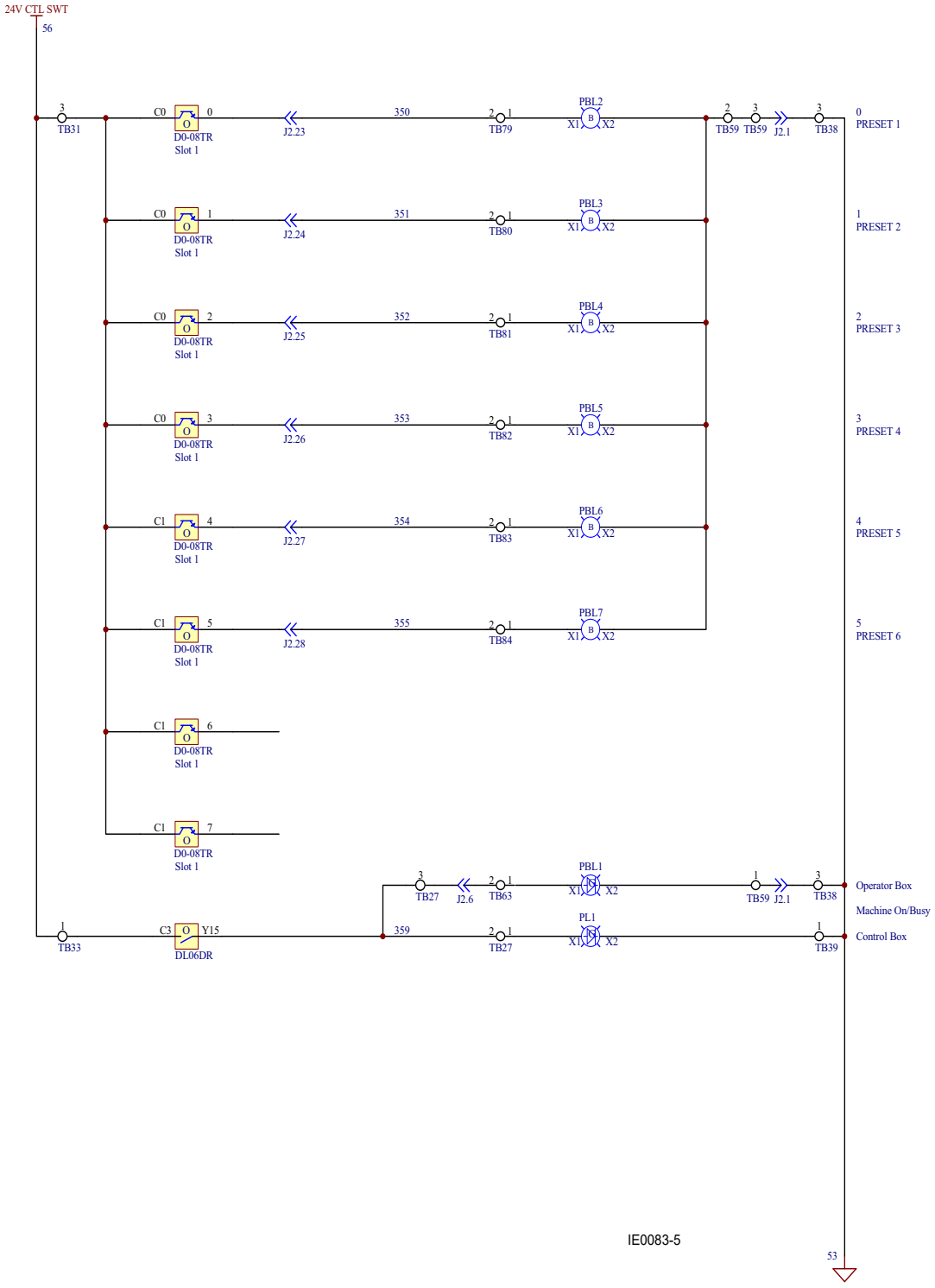

24V CTL SWT
56
TB31
C0
D0-08TR
Slot 1
J2.23
350
TB79
PBL2
X1
X2
TB59
TB59
J2.1
TB38
0
PRESET 1
J2.24
351
TB80
PBL3
1
PRESET 2
J2.25
352
TB81
PBL4
2
PRESET 3
J2.26
353
TB82
PBL5
3
PRESET 4
C1
J2.27
354
TB83
PBL6
4
PRESET 5
J2.28
355
TB84
PBL7
5
PRESET 6
6
7
TB27
J2.6
TB63
PBL1
Operator Box
Machine On/Busy
TB33
C3
Y15
DL06DR
359
PL1
Control Box
TB39
IE0083-5
53

FIG. 6-2 (5 OF 6)

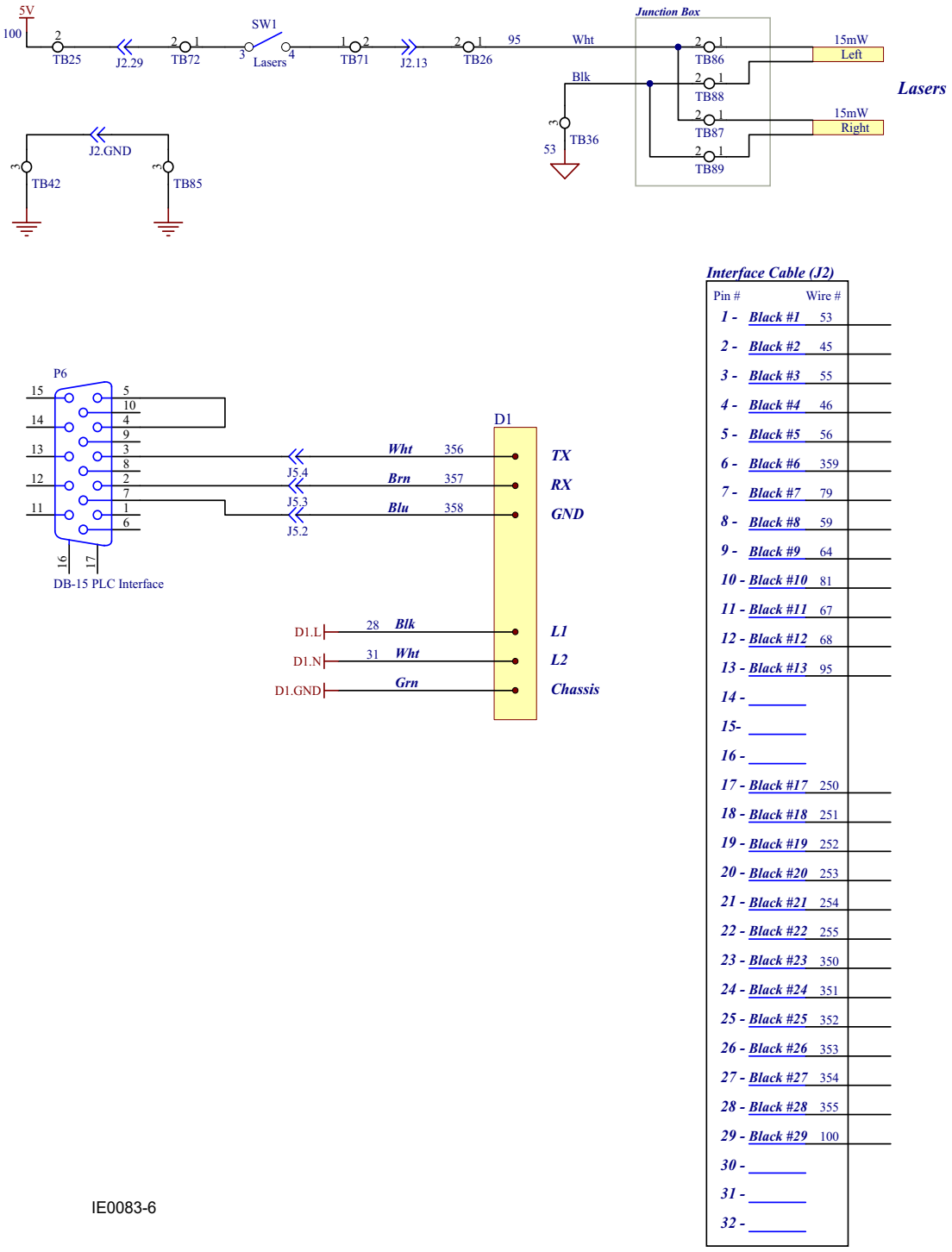

5V
100
TB25
J2.29
TB72
SW1
Lasers
TB71
J2.13
TB26
95
Wht
Junction Box
TB86
15mW
Left
Blk
TB88
Lasers
TB87
15mW
Right
TB36
53
TB89
J2.GND
TB42
TB85
P6
DB-15 PLC Interface
J5.4
J5.3
J5.2
D1
Wht 356
Brn 357
Blu 358
TX
RX
GND
D1.L
D1.N
D1.GND
28 Blk
31 Wht
Grn
L1
L2
Chassis
Interface Cable (J2)
Pin # Wire #
1 - Black #1 53
2 - Black #2 45
3 - Black #3 55
4 - Black #4 46
5 - Black #5 56
6 - Black #6 359
7 - Black #7 79
8 - Black #8 59
9 - Black #9 64
10 - Black #10 81
11 - Black #11 67
12 - Black #12 68
13 - Black #13 95
14 -
15-
16 -
17 - Black #17 250
18 - Black #18 251
19 - Black #19 252
20 - Black #20 253
21 - Black #21 254
22 - Black #22 255
23 - Black #23 350
24 - Black #24 351
25 - Black #25 352
26 - Black #26 353
27 - Black #27 354
28 - Black #28 355
29 - Black #29 100
30 -
31 -
32 -
IE0083-6

FIG. 6-2 (6 OF 6)

6.3 Electrical Symbol Diagram

E430 ***Rev. A3.01 - A4.00***
EG400EC30 ***Rev. A4.00 - A4.02***

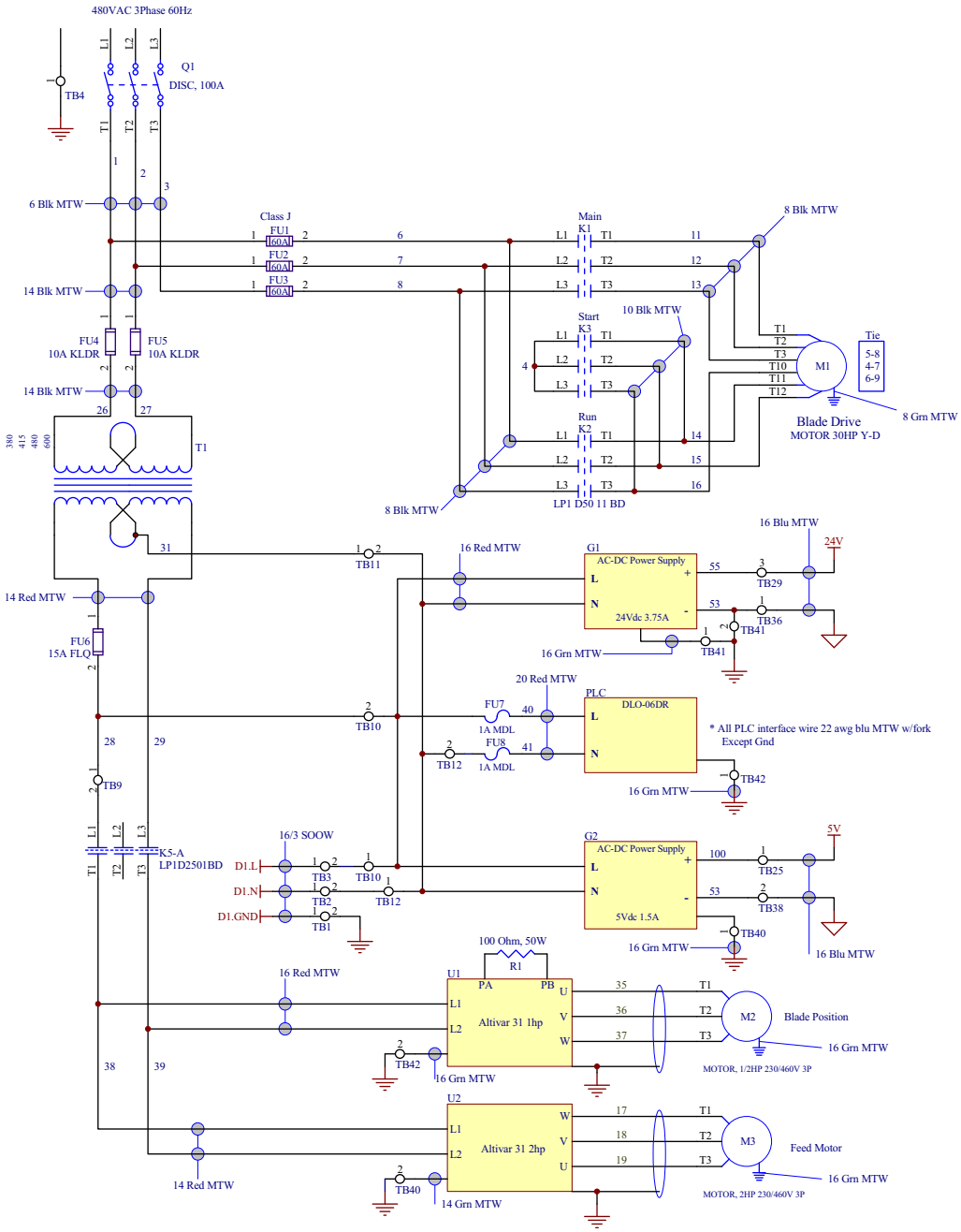


FIG. 6-3 SYMBOL DIAGRAM (1 OF 6)

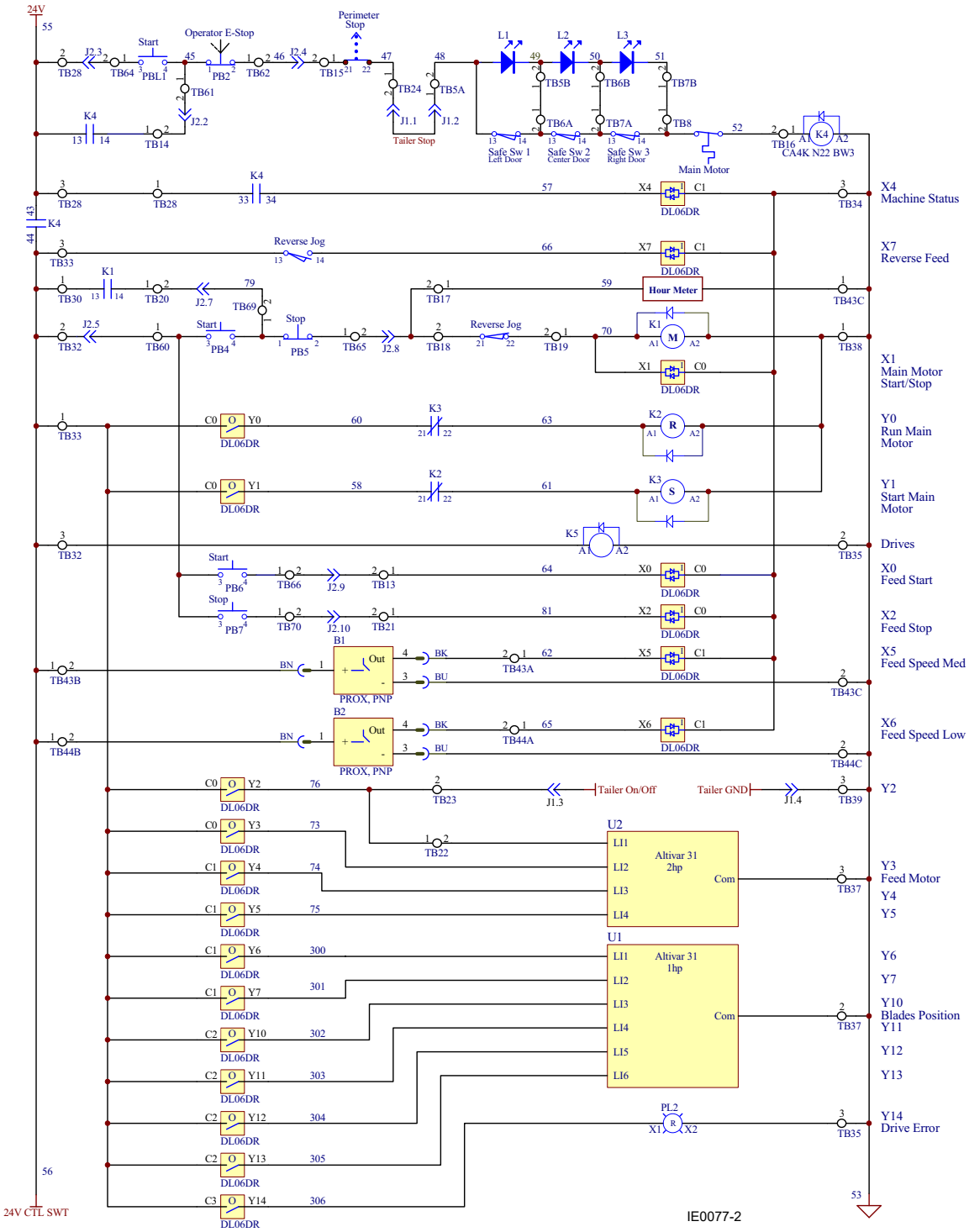


FIG. 6-3 SYMBOL DIAGRAM (2 OF 6)

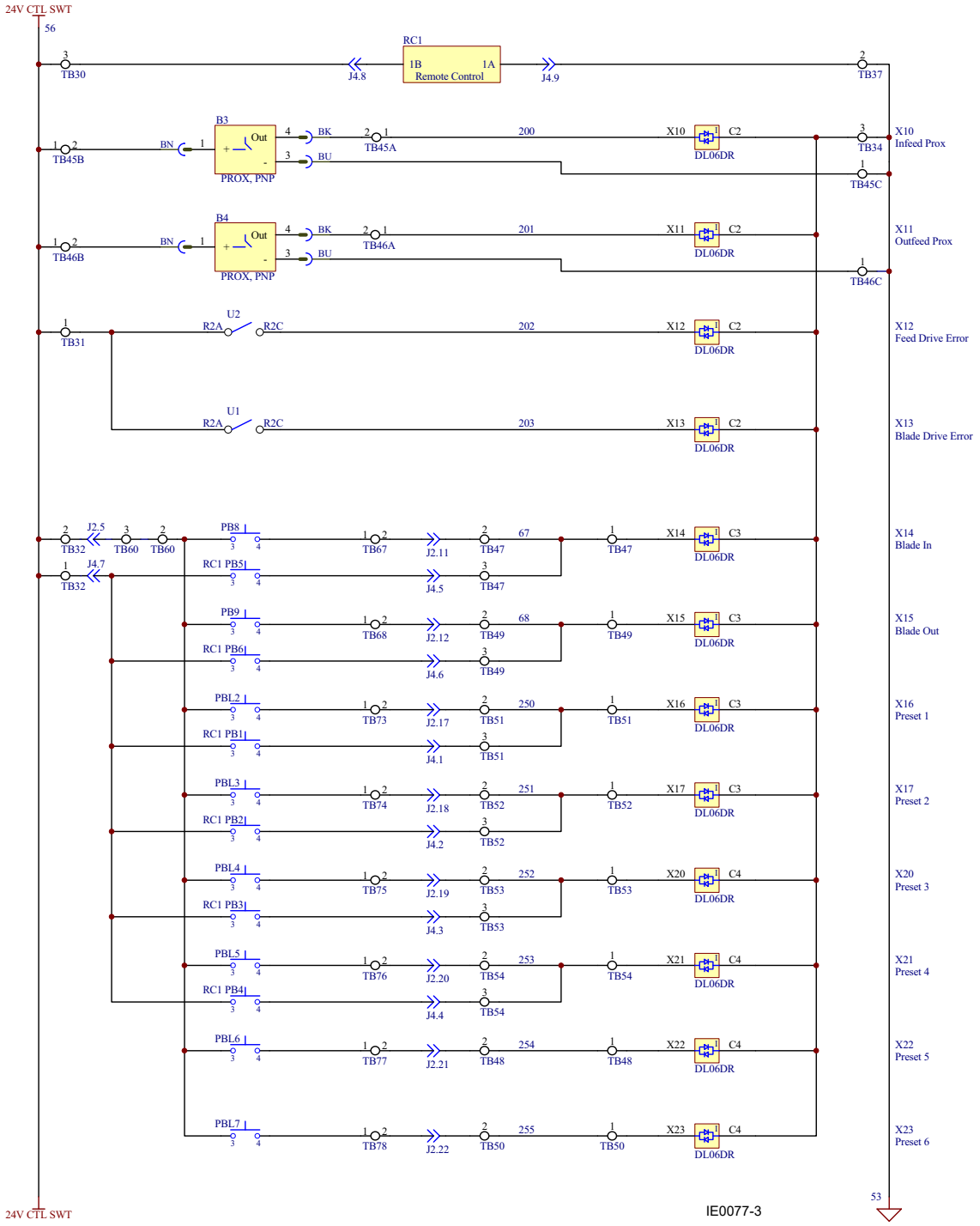

24V CTL SWT
56
RC1
1B
1A
Remote Control
J4.8
J4.9
TB30
TB37
B3
B4
Out
PROX, PNP
BN
BK
BU
TB45B
TB46B
TB45A
TB46A
TB45C
TB46C
200
201
202
203
X10
X11
X12
X13
C2
DL06DR
X10 Infeed Prox
X11 Outfeed Prox
X12 Feed Drive Error
X13 Blade Drive Error
U1
U2
R2A
R2C
TB31
J2.5
J4.7
TB32
TB60
PB8
RC1 PB5
PB9
RC1 PB6
PBL2
RC1 PB1
PBL3
RC1 PB2
PBL4
RC1 PB3
PBL5
RC1 PB4
PBL6
PBL7
TB67
TB68
TB73
TB74
TB75
TB76
TB77
TB78
J2.11
J2.12
J2.17
J2.18
J2.19
J2.20
J2.21
J2.22
J4.5
J4.6
J4.1
J4.2
J4.3
J4.4
TB47
TB49
TB51
TB52
TB53
TB54
TB48
TB50
67
68
250
251
252
253
254
255
X14
X15
X16
X17
X20
X21
X22
X23
C3
C4
X14 Blade In
X15 Blade Out
X16 Preset 1
X17 Preset 2
X20 Preset 3
X21 Preset 4
X22 Preset 5
X23 Preset 6
53
24V CTL SWT
IE0077-3

FIG. 6-3 (3 OF 6)

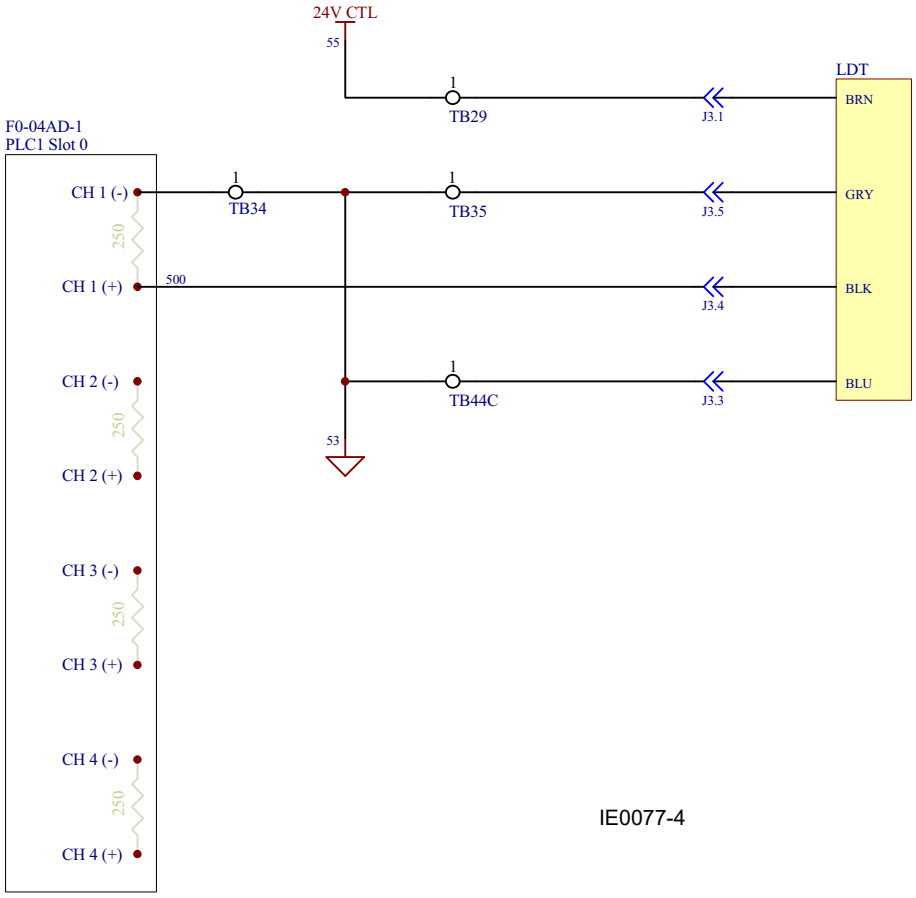

24V CTL
55
LDT
1
TB29
J3.1
BRN
F0-04AD-1
PLC1 Slot 0
CH 1 (-)
1
TB34
1
TB35
J3.5
GRY
250
CH 1 (+)
500
J3.4
BLK
CH 2 (-)
1
TB44C
J3.3
BLU
250
53
CH 2 (+)
CH 3 (-)
250
CH 3 (+)
CH 4 (-)
250
CH 4 (+)
IE0077-4

FIG. 6-3 (4 OF 6)

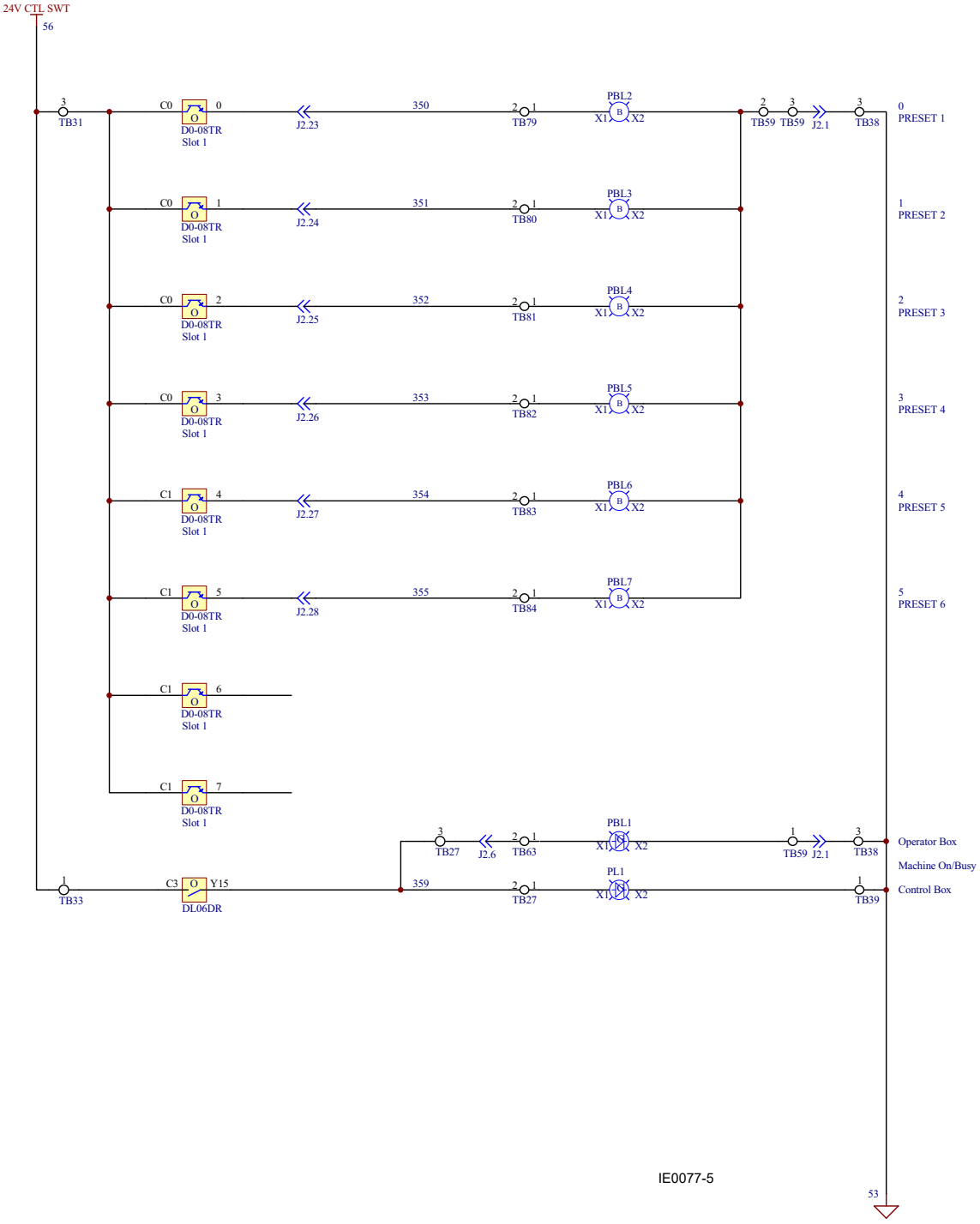

24V CTL SWT
56
TB31
C0
0
D0-08TR
Slot 1
J2.23
350
TB79
PBL2
X1
X2
TB59
TB59
J2.1
TB38
0
PRESET 1
C0
1
J2.24
351
TB80
PBL3
1
PRESET 2
C0
2
J2.25
352
TB81
PBL4
2
PRESET 3
C0
3
J2.26
353
TB82
PBL5
3
PRESET 4
C1
4
J2.27
354
TB83
PBL6
4
PRESET 5
C1
5
J2.28
355
TB84
PBL7
5
PRESET 6
C1
6
C1
7
TB27
J2.6
TB63
PBL1
TB59
J2.1
TB38
Operator Box
Machine On/Busy
TB33
C3
Y15
DL06DR
359
TB27
PL1
TB39
Control Box
IE0077-5
53

FIG. 6-3 (5 OF 6)

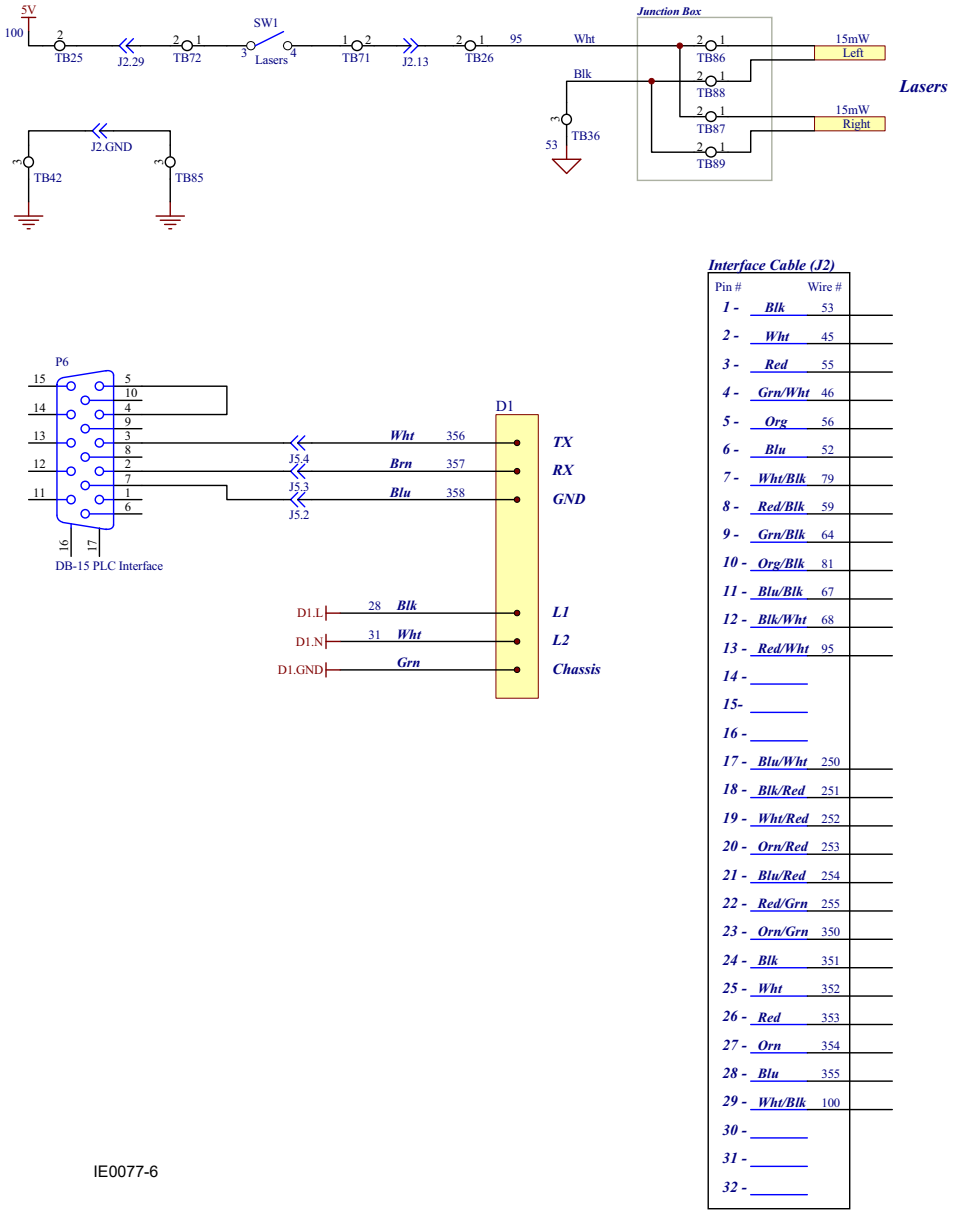

5V
100
TB25
J2.29
TB72
SW1
Lasers
TB71
J2.13
TB26
95
Wht
Blk
TB36
53
Junction Box
TB86
TB88
TB87
TB89
15mW
Left
15mW
Right
Lasers
J2.GND
TB42
TB85
P6
DB-15 PLC Interface
J5.4
J5.3
J5.2
Wht 356
Brn 357
Blu 358
D1
TX
RX
GND
D1.L
D1.N
D1.GND
28 Blk
31 Wht
Grn
L1
L2
Chassis
IE0077-6
Interface Cable (J2)
Pin # Wire #
1 - Blk 53
2 - Wht 45
3 - Red 55
4 - Grn/Wht 46
5 - Org 56
6 - Blu 52
7 - Wht/Blk 79
8 - Red/Blk 59
9 - Grn/Blk 64
10 - Org/Blk 81
11 - Blu/Blk 67
12 - Blk/Wht 68
13 - Red/Wht 95
14 -
15-
16 -
17 - Blu/Wht 250
18 - Blk/Red 251
19 - Wht/Red 252
20 - Orn/Red 253
21 - Blu/Red 254
22 - Red/Grn 255
23 - Orn/Grn 350
24 - Blk 351
25 - Wht 352
26 - Red 353
27 - Orn 354
28 - Blu 355
29 - Wht/Blk 100
30 -
31 -
32 -

FIG. 6-3 (6 OF 6)

6.4 Electrical Symbol Diagram

E430 ***Rev. A3.00***

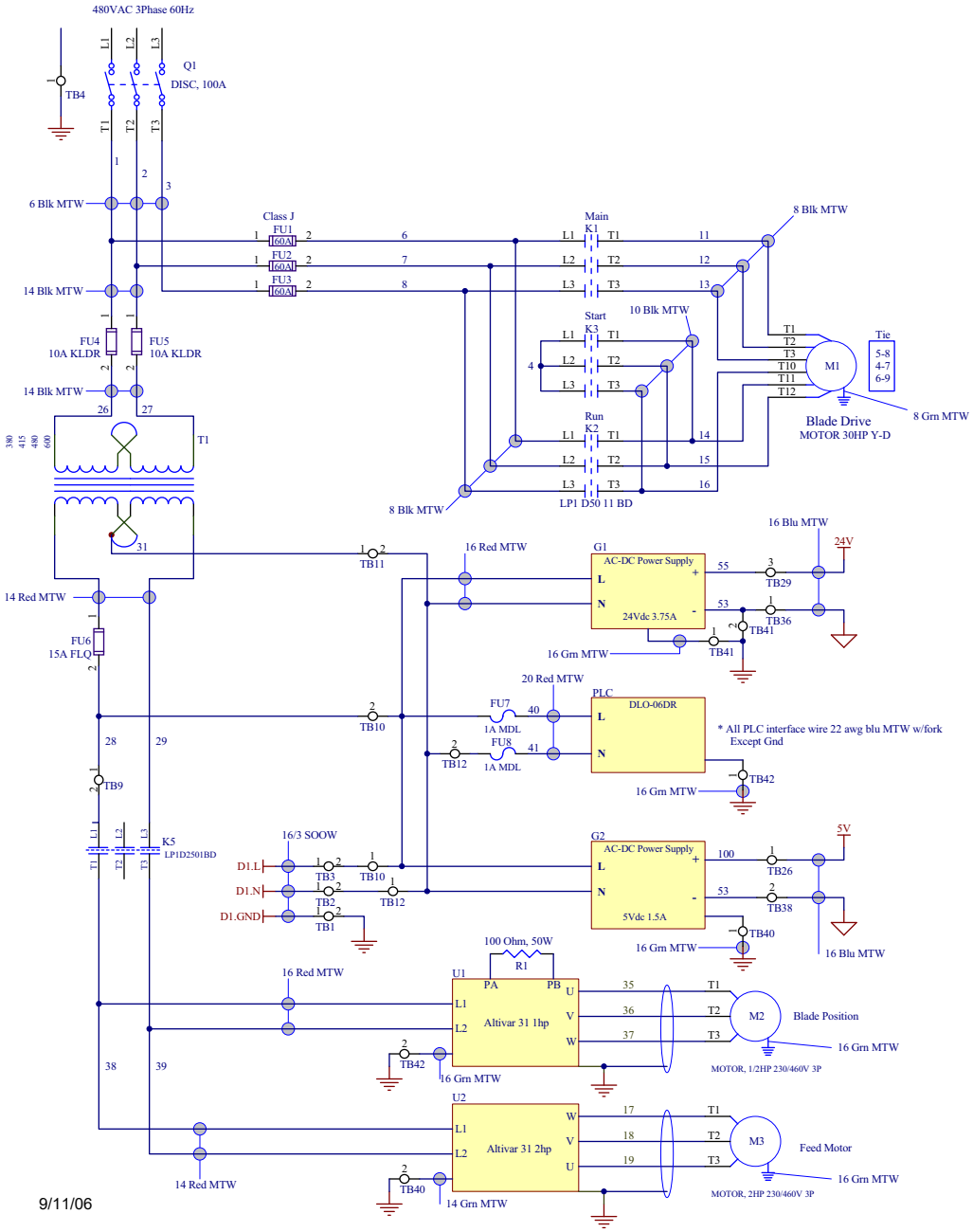


FIG. 6-4 SYMBOL DIAGRAM (1 OF 6)

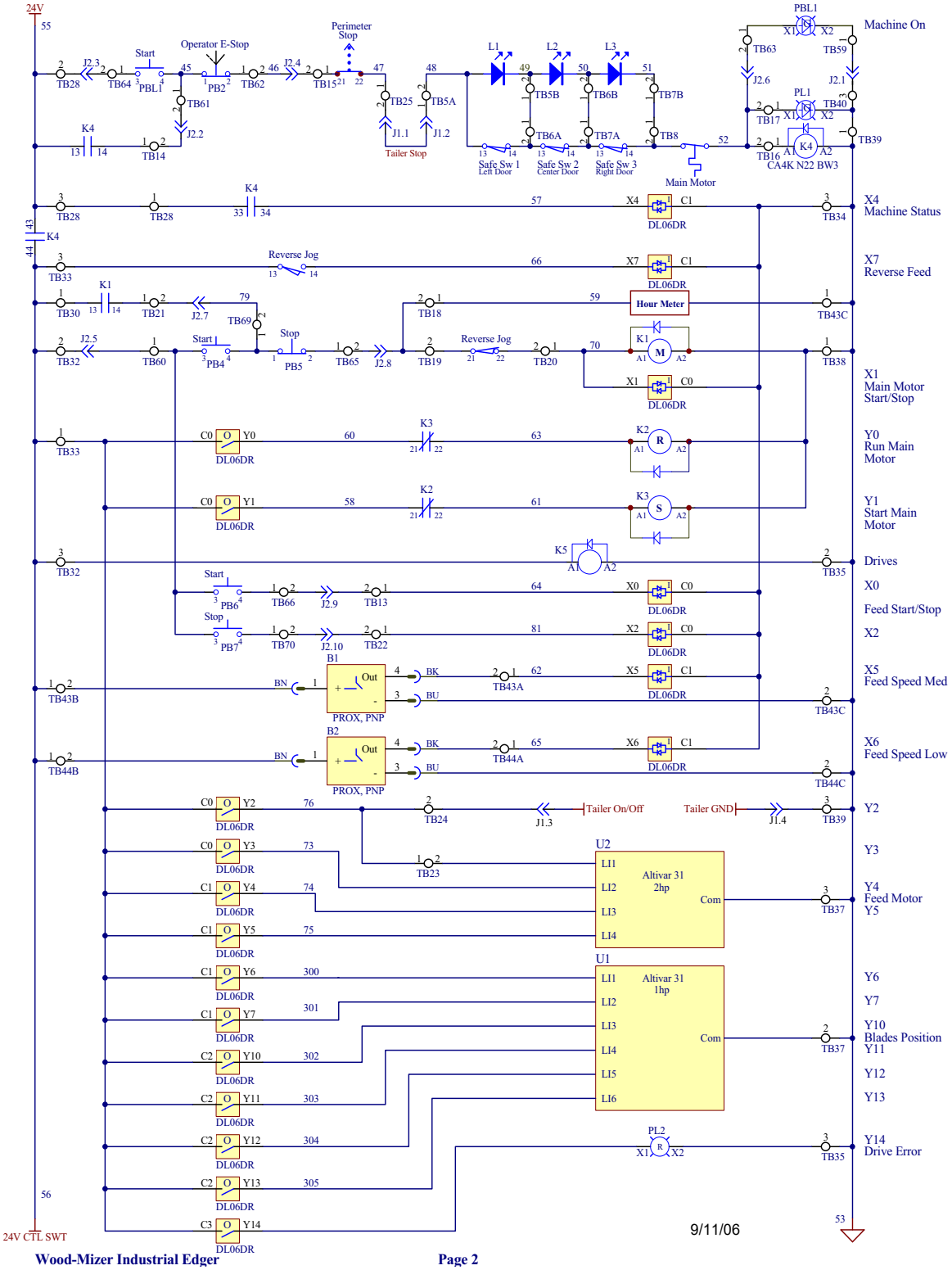


FIG. 6-4 SYMBOL DIAGRAM (2 OF 6)

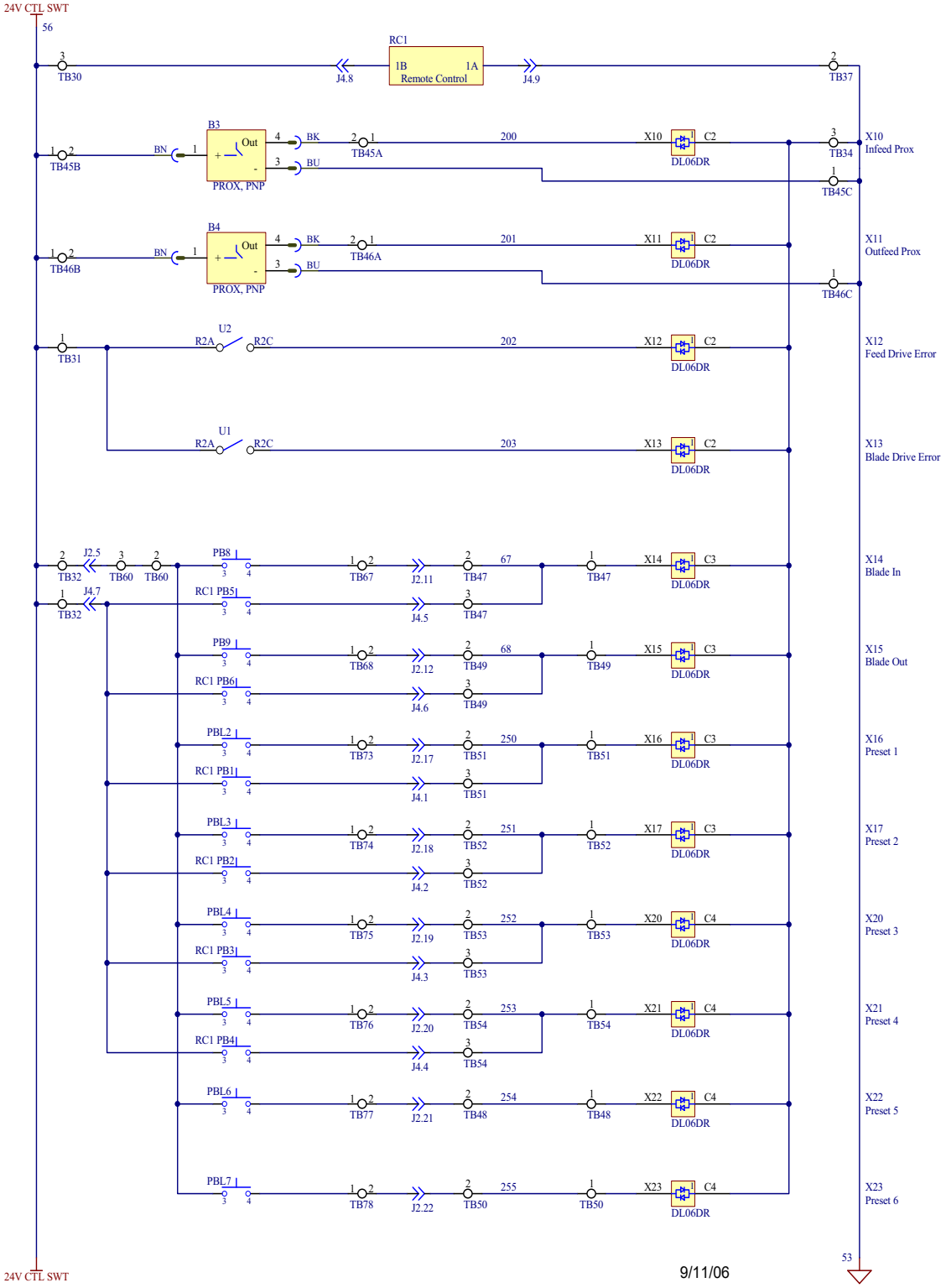

24V CTL SWT
56
RC1
1B
1A
Remote Control
TB30
J4.8
J4.9
TB37
B3
Out
PROX, PNP
BN
BK
BU
TB45B
TB45A
TB45C
200
X10
C2
DL06DR
TB34
X10
Infeed Prox
B4
TB46B
TB46A
TB46C
201
X11
Outfeed Prox
U2
R2A
R2C
TB31
202
X12
Feed Drive Error
U1
203
X13
Blade Drive Error
J2.5
TB32
TB60
PB8
RC1 PB5
PB9
RC1 PB6
PBL2
RC1 PB1
PBL3
RC1 PB2
PBL4
RC1 PB3
PBL5
RC1 PB4
PBL6
PBL7
J4.7
TB67
TB68
TB73
TB74
TB75
TB76
TB77
TB78
J2.11
J2.12
J2.17
J2.18
J2.19
J2.20
J2.21
J2.22
J4.5
J4.6
J4.1
J4.2
J4.3
J4.4
TB47
TB49
TB51
TB52
TB53
TB54
TB48
TB50
67
68
250
251
252
253
254
255
X14
X15
X16
X17
X20
X21
X22
X23
C3
C4
Blade In
Blade Out
Preset 1
Preset 2
Preset 3
Preset 4
Preset 5
Preset 6
53
9/11/06

FIG. 6-4 (3 OF 6)

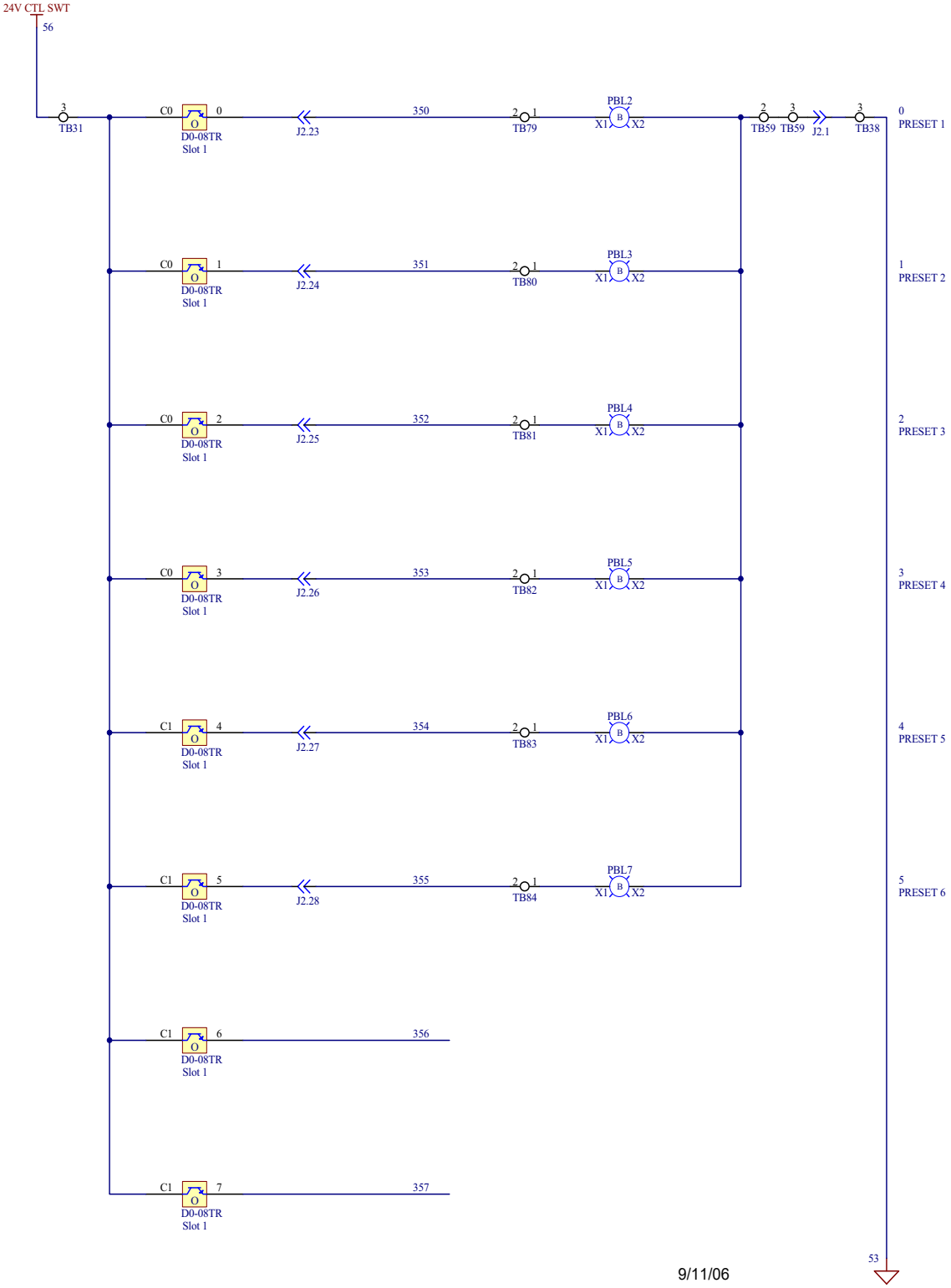
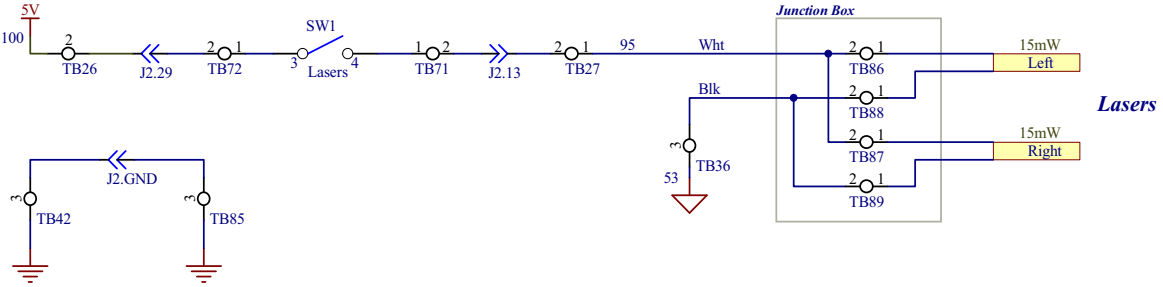
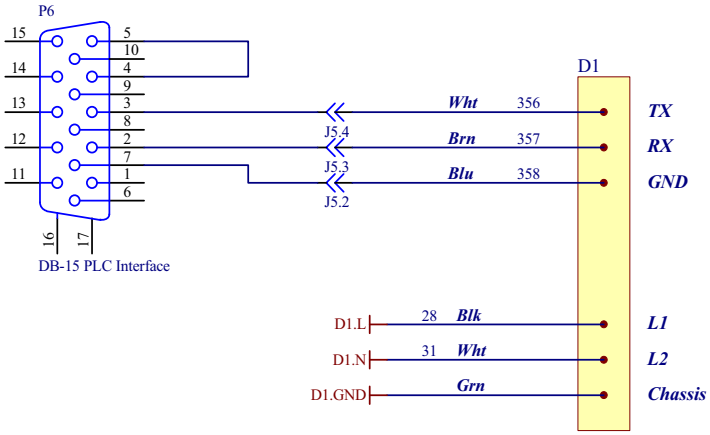

24V CTL SWT
56
TB31
C0
D0-08TR
Slot 1
J2.23
350
TB79
PBL2
X1
X2
TB59
TB59
J2.1
TB38
0
PRESET 1
J2.24
351
TB80
PBL3
1
PRESET 2
J2.25
352
TB81
PBL4
2
PRESET 3
J2.26
353
TB82
PBL5
3
PRESET 4
C1
J2.27
354
TB83
PBL6
4
PRESET 5
J2.28
355
TB84
PBL7
5
PRESET 6
356
357
9/11/06
53

FIG. 6-4 (4 OF 6)



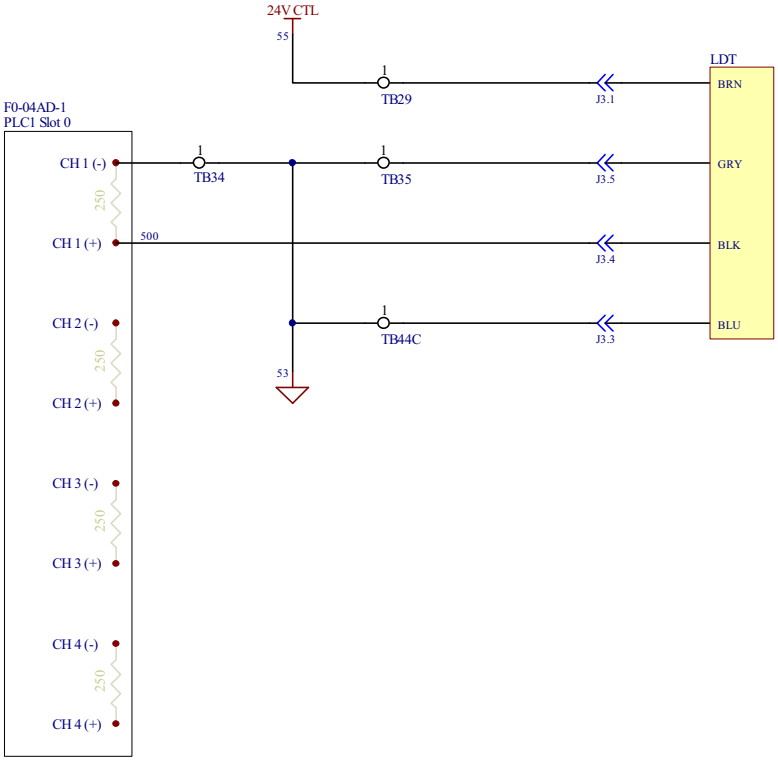


Interface Cable (J2)

Pin #		Wire #
1 -	Blk	53
2 -	Wht	45
3 -	Red	55
4 -	Grn/Wht	46
5 -	Org	56
6 -	Blu	52
7 -	Wht/Blk	79
8 -	Red/Blk	59
9 -	Grn/Blk	64
10 -	Org/Blk	81
11 -	Blu/Blk	67
12 -	Blk/Wht	68
13 -	Red/Wht	95
14 -		
15-		
16 -		
17 -	Blu/Wht	250
18 -	Blk/Red	251
19 -	Wht/Red	252
20 -	Orn/Red	253
21 -	Blu/Red	254
22 -	Red/Grn	255
23 -	Orn/Grn	350
24 -	Blk	351
25 -	Wht	352
26 -	Red	353
27 -	Orn	354
28 -	Blu	355
29 -	Wht/Blk	100
30 -		
31 -		
32 -		

/11/06

FIG. 6-4 (5 OF 6)



Wood-Mizer Industrial Edger **Page 5**

FIG. 6-4 (6 OF 6)

6.5 Electrical Symbol Diagram

E430 ***Rev. A2.00***

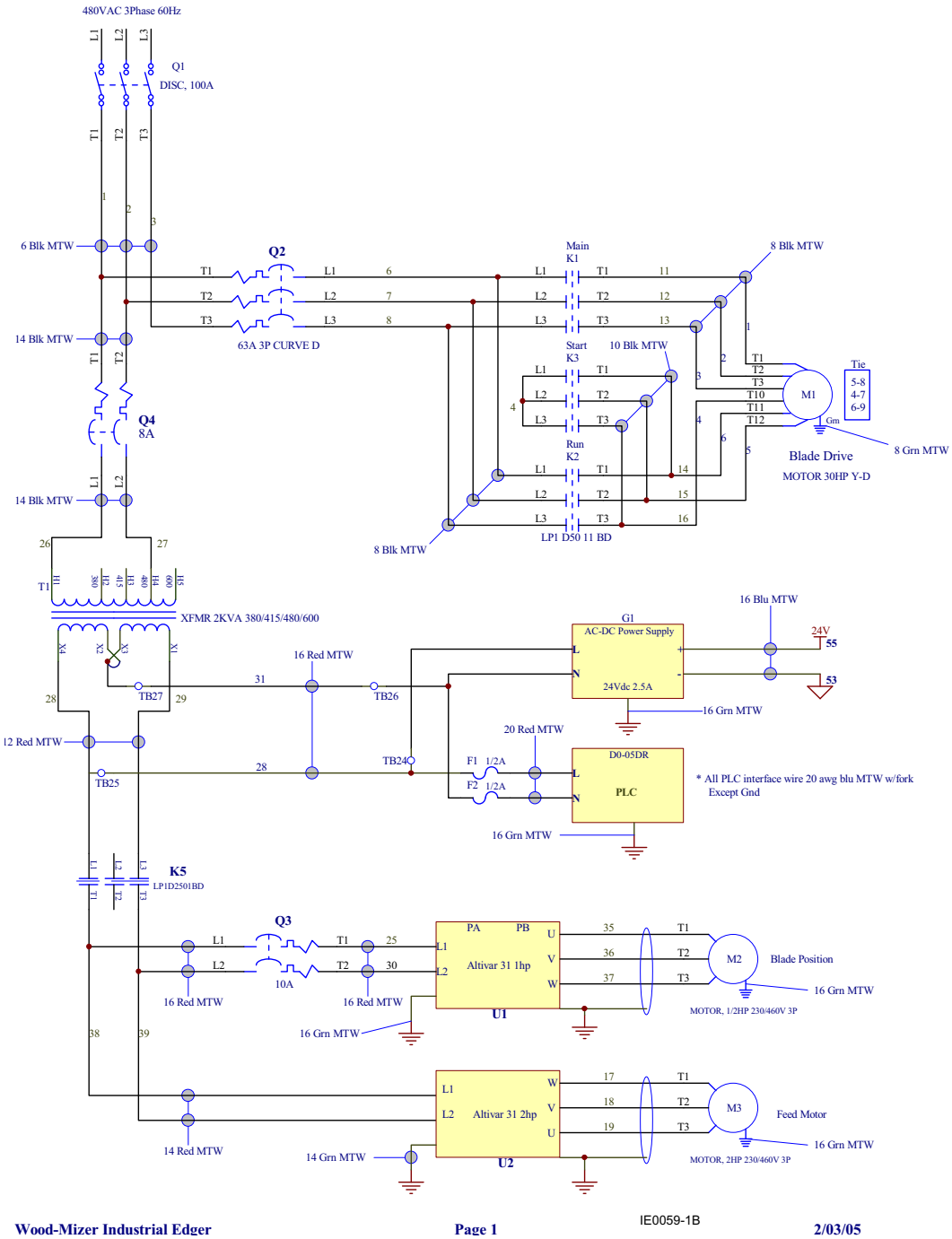


FIG. 6-5 SYMBOL DIAGRAM (1 OF 3)

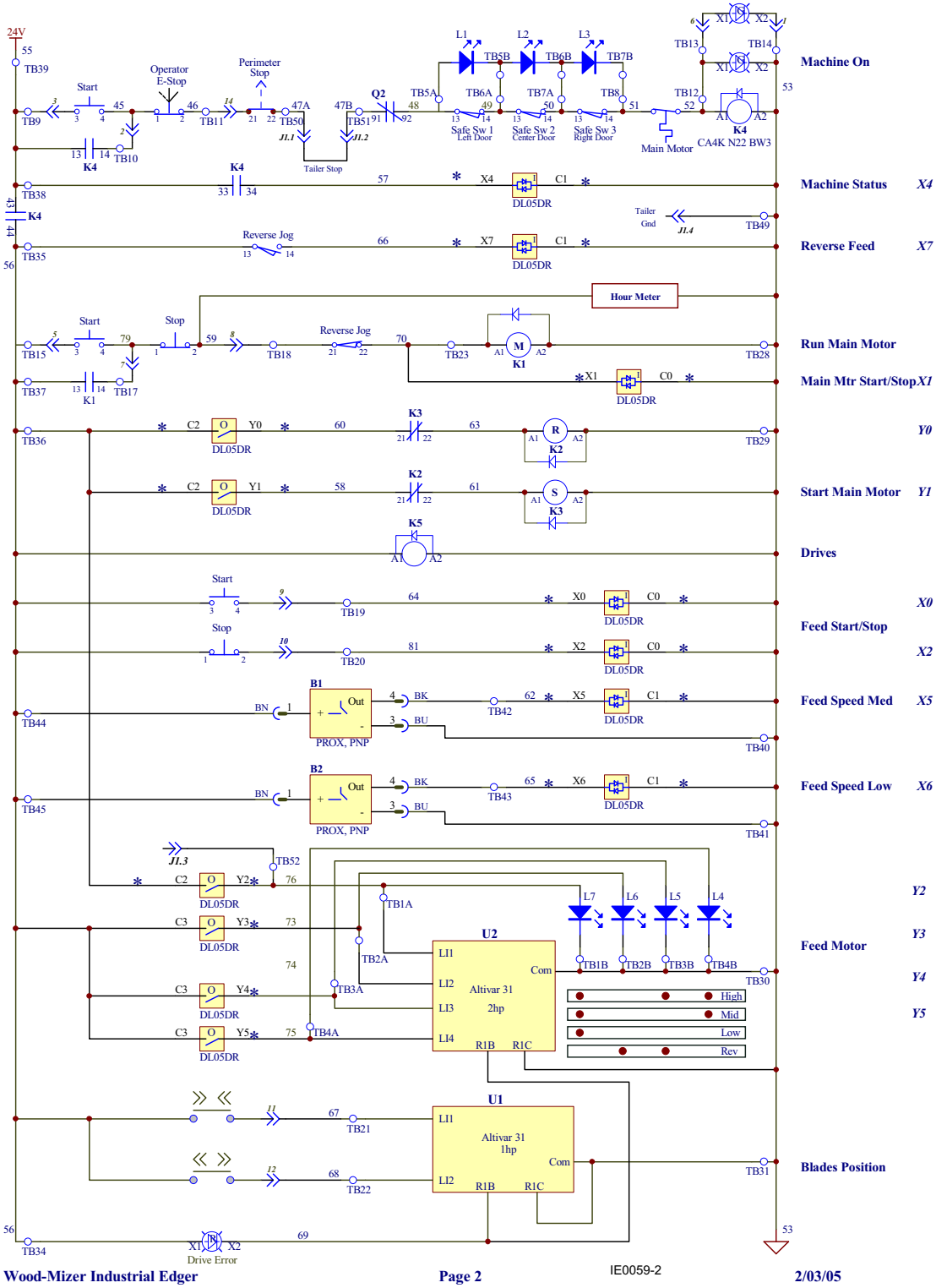
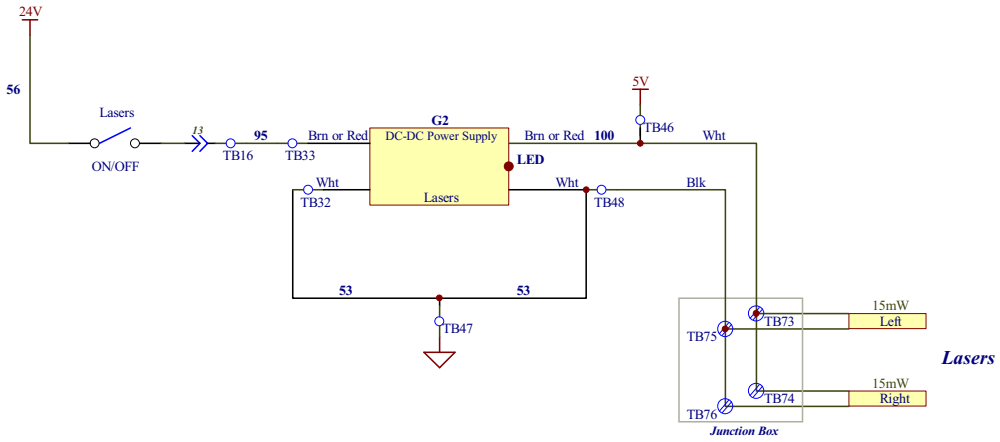


FIG. 6-5 SYMBOL DIAGRAM (2 OF 3)


24V
56
Lasers
ON/OFF
13
TB16
95
TB33
Brn or Red
G2
DC-DC Power Supply
Brn or Red
100
5V
TB46
Wht
LED
Wht
TB32
Lasers
Wht
TB48
Blk
53
53
TB47
15mW
Left
TB73
TB75
Lasers
15mW
Right
TB74
TB76
Junction Box

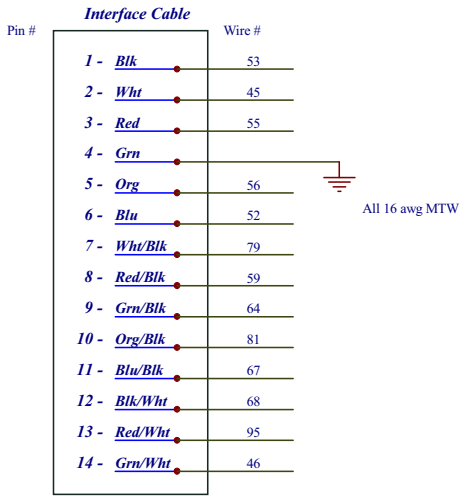

Interface Cable
Pin #
Wire #
1 - Blk 53
2 - Wht 45
3 - Red 55
4 - Grn
5 - Org 56
6 - Blu 52
7 - Wht/Blk 79
8 - Red/Blk 59
9 - Grn/Blk 64
10 - Org/Blk 81
11 - Blu/Blk 67
12 - Blk/Wht 68
13 - Red/Wht 95
14 - Grn/Wht 46
All 16 awg MTW

FIG. 6-5 (3 OF 3)

6.6 Electrical Symbol Diagram

E430 ***Rev. A1.03***

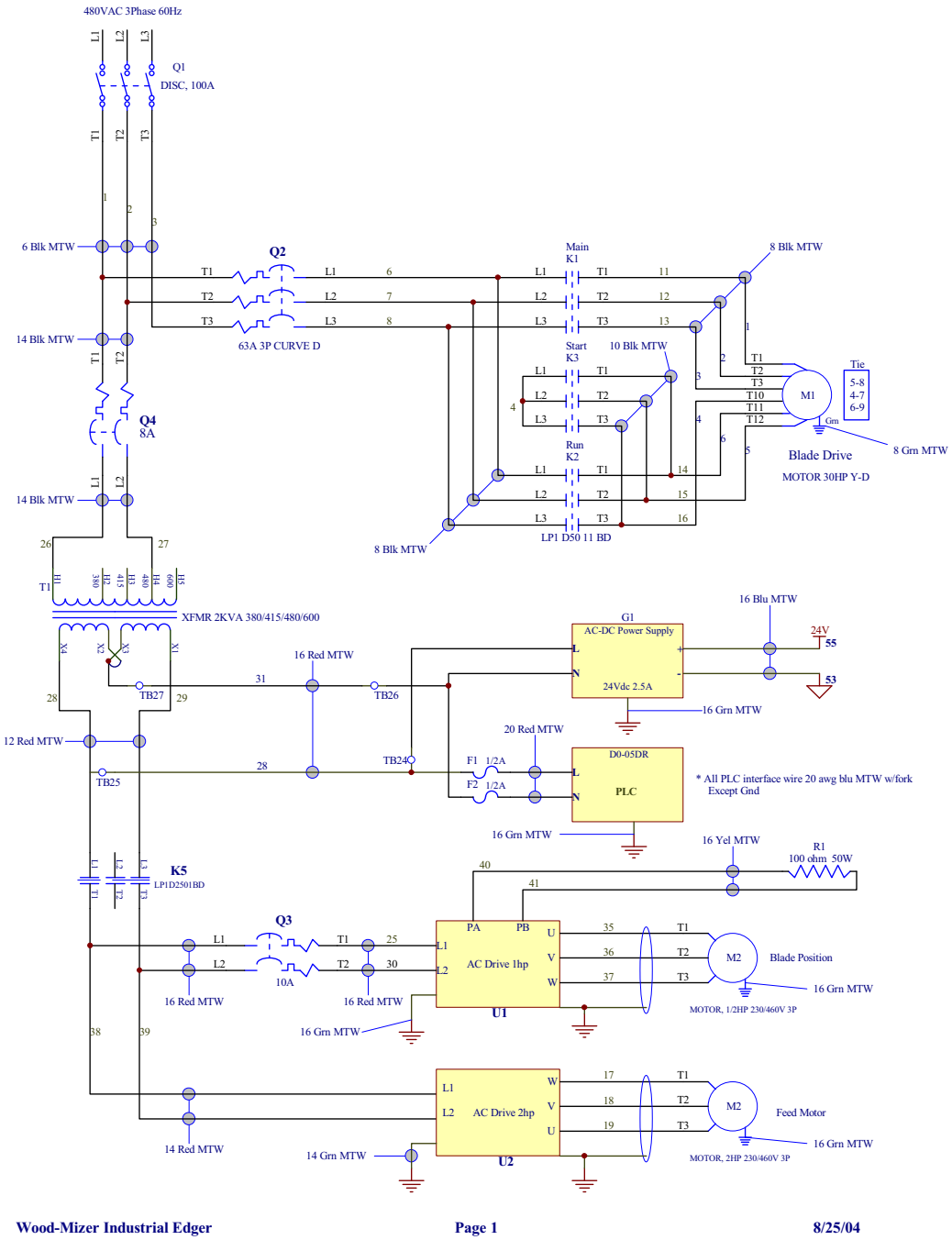


FIG. 6-6 SYMBOL DIAGRAM (1 OF 3)

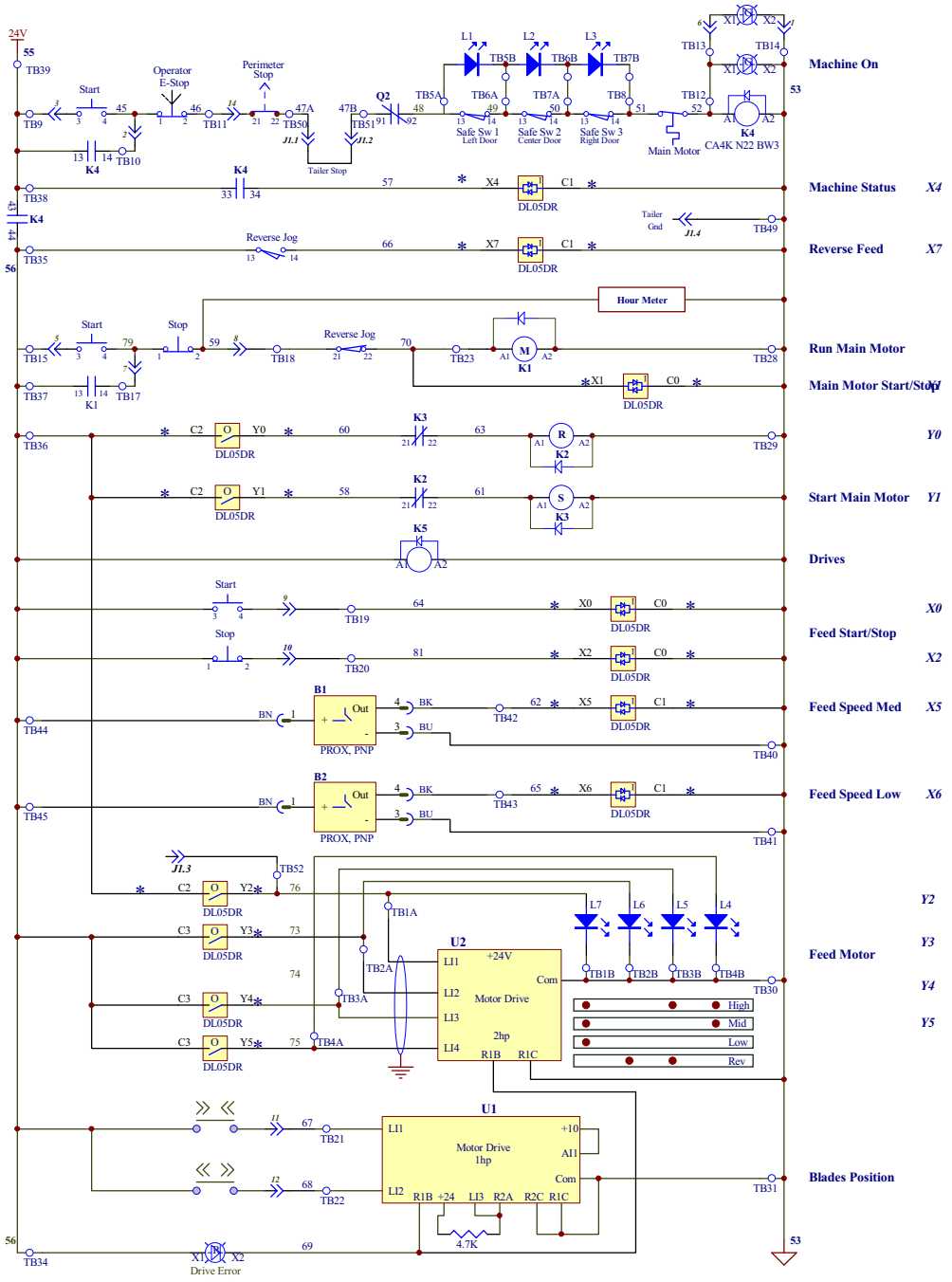
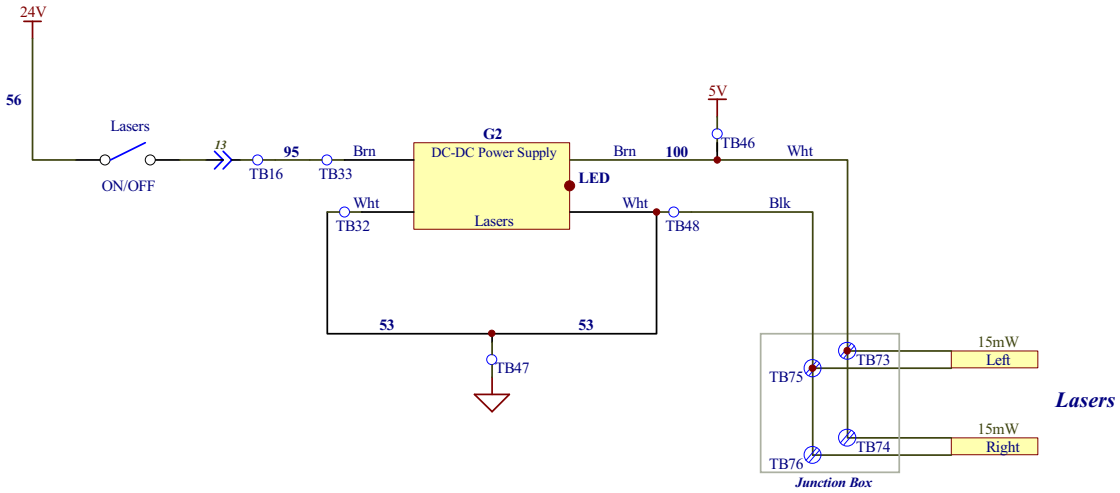
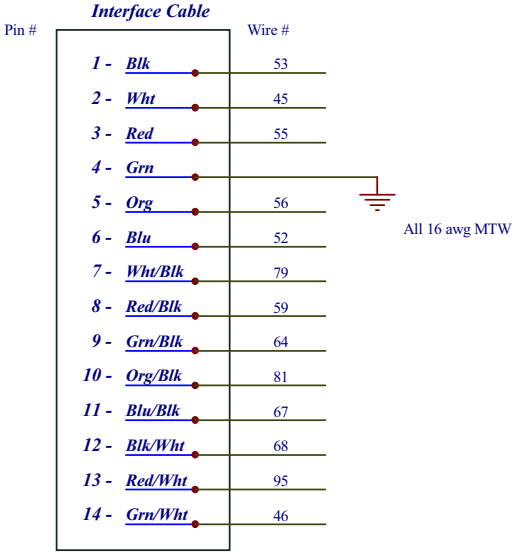


FIG. 6-6 SYMBOL DIAGRAM (2 OF 3)





:er Industrial Edger **Page 3** **9/19/03**

FIG. 6-6 (3 OF 3)

6.7 Electrical Symbol Diagram

E430 ***Rev. A1.00 - A1.02***

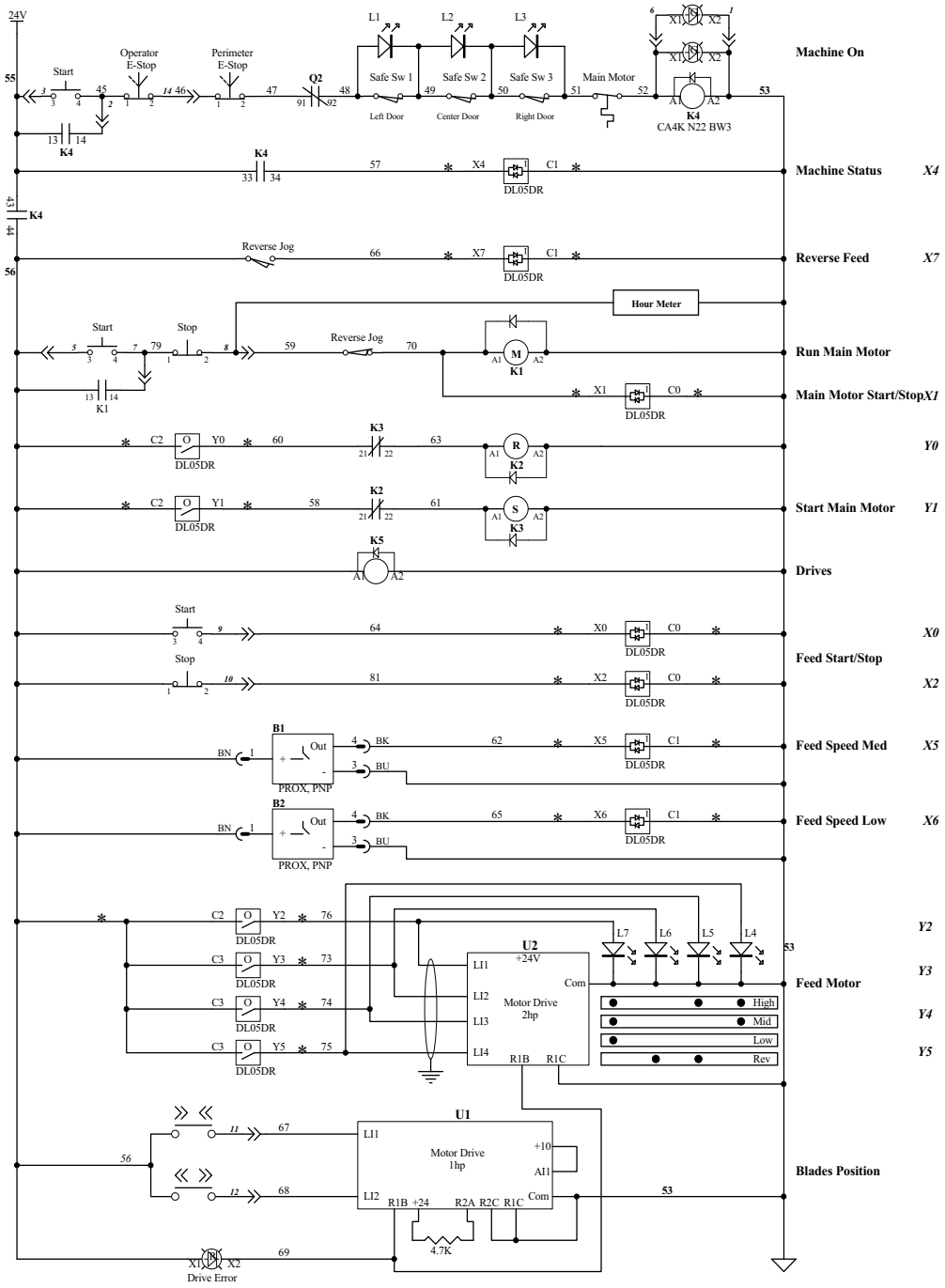
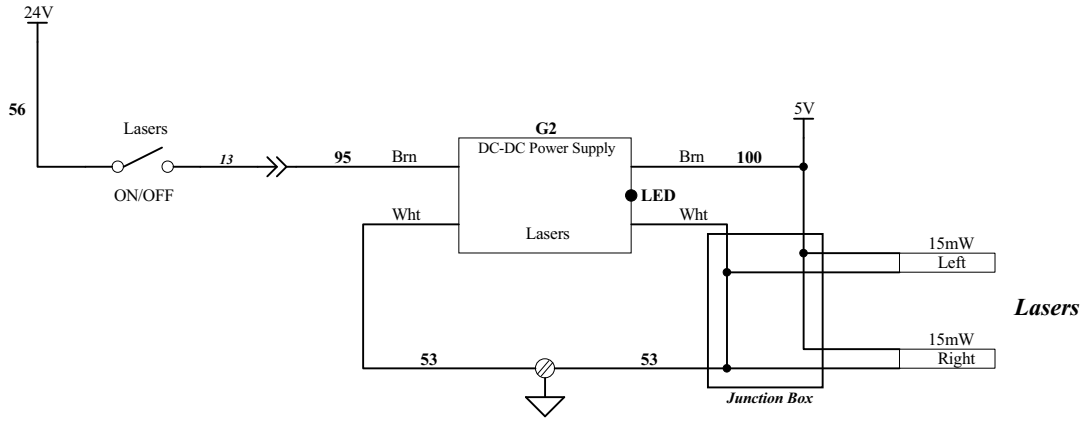


FIG. 6-7 SYMBOL DIAGRAM (1 OF 3)



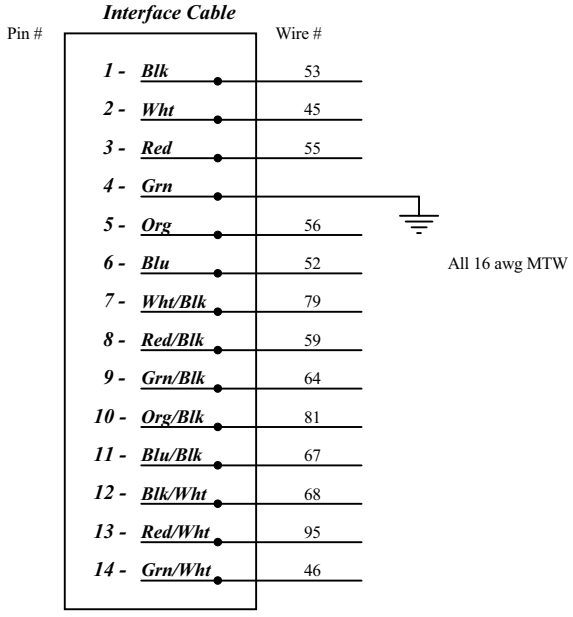


FIG. 6-7 SYMBOL DIAGRAM (2 OF 3)

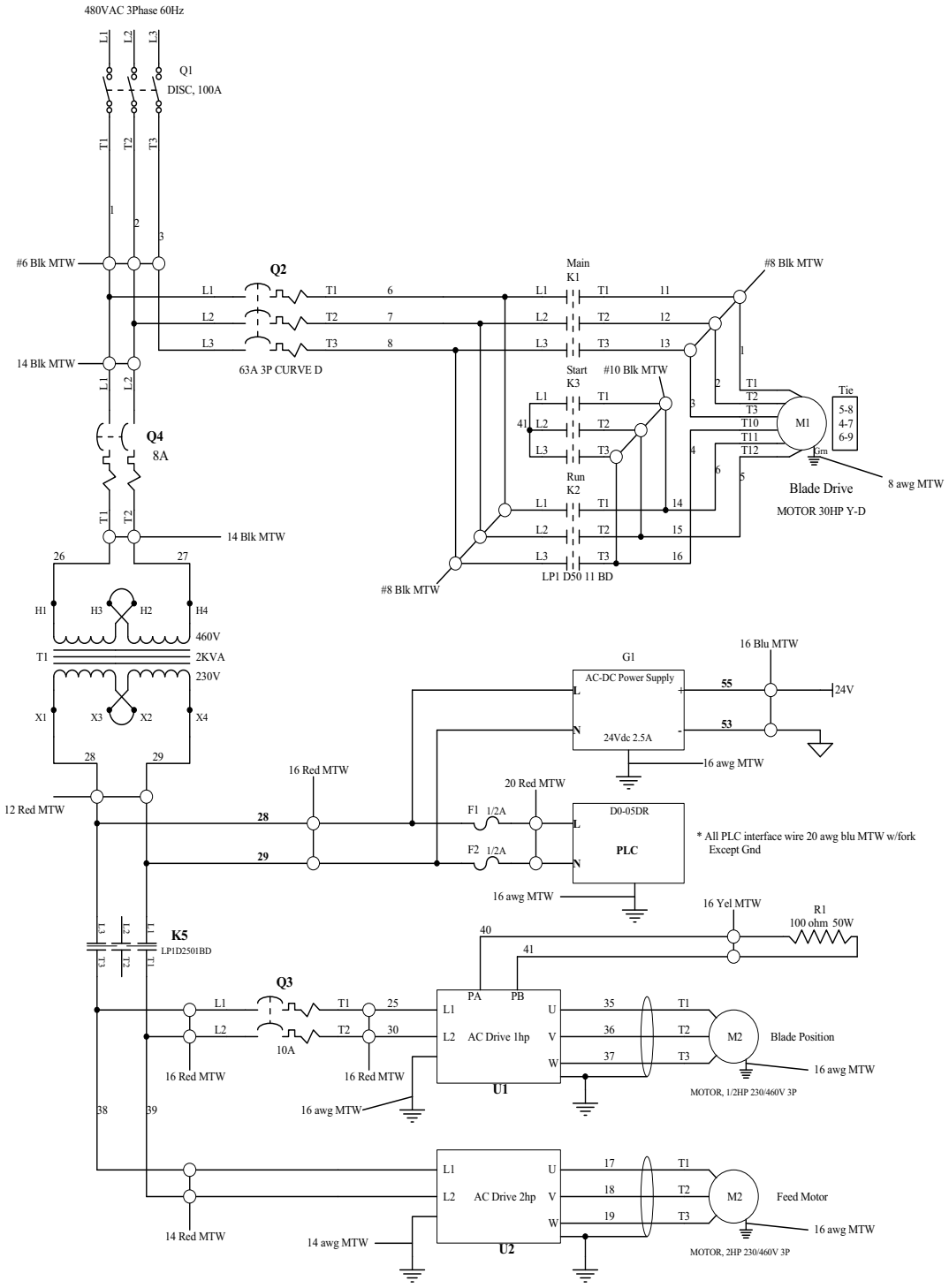


FIG. 6-7 SYMBOL DIAGRAM (3 OF 3)

6.8 Electrical Component List

E430 ***Rev. A3.01 - A4.00***
EG400EC30 ***Rev. A4.00+***

Component	Wood-Mizer Part No.	Description
FU1, FU2, FU3	052733	Fuse, 600V 60A Class J
FU4, FU5	052757	Fuse, 10A 600V KLDR Class CC
FU6	052758	Fuse, 15A 600V Time Delay Midget
FU7, FU8	P03042	Fuse, MDL 1 Amp Glass
G1	052633	Power Supply, 110/230VAC 24VDC 3.75A
G2	052755	Power Supply, 110/230VAC 5VDC 1.5A
H1	015401 [1]	Hour Meter, 12 Volt DC
K1, K2	053601 [2]	Contactor, 50A 3P 24VDC D-A Series
K3, K5	051322	Contactor, Industrial Edger
K4	024809	Relay, IEC 3NO 1NC 3A 24VDC Control
M1	042301	Motor, 30HP 1800RPM Blade Drive
M2	039274	Motor, 1/2HP 1725RPM Blade Position
M3	042390	Motor, 2HP 3PH 230/460V TEFC 56C No Base
PB2	024945	Switch Head, Red Push Button 22mm XB4
	025161	Switch Body, 22mm 1NC XB4
PB4, PB6	050152	Switch Head, Green Guarded
	025242	Switch Body, 22mm 1NO XB4
PB5	050151	Switch Head, Red Extended
	025161	Switch Body, 22mm 1NC XB4
PB7	050151	Switch Head, Red Extended
	025242	Switch Body, 22mm 1NO XB4
PB8, PB9	050197	Switch Head, 22mm Mom Flush Blue XB4
	025242	Switch Body, 22mm 1NO XB4
PBL1	051301	Switch Head, Green Flush ZB4
	025236-31	Switch Body, 22mm Green LED 1NO 24V XB4
PBL2-PBL7	025237-68	Switch Head, 22mm Mom Flush LED Blu XB4
	025236-61	Switch Body, 22mm Blu LED 1 NO 24V ZB4
PL1	024970-3	Light, Green 24V 22mm LED XB4 Pilot
PL2	024970-4	Light, Red 24V 22mm LED XB4 Pilot
PLC	052753	PLC Assembly, E430 (Programmed w/Modules)
	069356	PLC Assembly, E430 2006 (Programmed)
	050163	PLC Module, 4 CH Analog Input 4-20MA
	052754	PLC Module, D06 8P Relay Out
Q1	050906-1 [3]	Disconnect, 100A 3Phase Non-Fused 6mm
	050907-1 [3]	Operator, Red/Yellow Pistol Grip Disconnect 6mm
	050908-1 [3]	Shaft, Disconnect Operator Extension 6mm

R1	052764	Resistor Assembly, 50W 100 Ohm
Reverse Jog, SAFE SW1-SW3	039378	Switch, Safety Limit
SW1	051302	Switch Head, 2 Pos. Maint. ZB4
	025242	Switch Body, 22mm 1NO XB4
T1	052756	Transformer, 2KVA 460V - 230V
TB1	051344	Terminal Block, Green/Yellow Grounding
TB2	024893	Terminal Block, 1 Tier Gray
TB3	051308	Temrinal Block, 1 Tier Black
TB4	050887	Terminal Block, 1 Tier Ground
TB5-7	051324-1	Terminal Block, 2 Tier w/LED
TB8-TB26, TB61-84, TB86-TB89	052750	Terminal Block, 2P Gray Cage Clamp
TB27-39, TB47-54, TB59-60	052760	Terminal Block, 3P Gray Cage Clamp
TB40, TB42 TB85	052752	Terminal Block, Green/Yellow GND 3P
TB43-TB46	052759	Terminal Block, 3 Tier Cage Clamp
U1 [4]	052173	Drive Assembly, IE Blade Position Motor 2005
U2 [4]	052174	Drive Assembly, IE Feed Motor 2005

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

[2] DIN rail-mount contactor 053601 replaces panel-mount contactor 025013 originally supplied prior to 1/11 due to a change in vendor supply. Replacement of old-style contactor requires 9" DIN rail 024474-9, three screws F05015-17 and two clamps E22707. Three 5/32" diameter holes in the mounting panel are required to mount DIN rail. New contactors include transient suppression, eliminating the need for three diode suppression modules 023360.

[3] 5mm Disconnect Shaft OHY45J5 replaced by vendor with 6mm shaft OXP6X290 (2/10). Replacement of any disconnect component requires replacement of disconnect, shaft and operator handle (050906-1, 050907-1 & 050908-1).

[4] Part numbers for U1 & U2 incorrectly reversed prior to 10/06.

6.9 Electrical Component List

E430 ***Rev. A3.00***

Component	Wood-Mizer Part No.	Description
FU1, FU2, FU3	052733	Fuse, 600V 60A Class J
FU4, FU5	052757	Fuse, 10A 600V KLDR Class CC
FU6	052758	Fuse, 15A 600V Time Delay Midget
FU7, FU8	P03042	Fuse, MDL 1 Amp Glass
G1	052633	Power Supply, 110/230VAC 24VDC 3.75A
G2	052755	Power Supply, 110/230VAC 5VDC 1.5A
H1	015401	Hour Meter, Rectangle Mount
K1, K2	053601 [1]	Contactor, 50A 3P 24VDC D-A Series
K3, K5	051322	Contactor, Industrial Edger
K4	024809	Relay, IEC 3NO 1NC 3A 24VDC Control
M1	042301	Motor, 30HP 1800RPM Blade Drive
M2	039274	Motor, 1/2HP 1725RPM Blade Position
M3	042390	Motor, 2HP 3PH 230/460V TEFC 56C No Base
PB2	024945	Switch Head, Red Push Button 22mm XB4
	025161	Switch Body, 22mm 1NC XB4
PB4, PB6	050152	Switch Head, Green Guarded
	025242	Switch Body, 22mm 1NO XB4
PB5, PB7	050151	Switch Head, Red Extended
	025161	Switch Body, 22mm 1NC XB4
PB8, PB9	050197	Switch Head, 22mm Mom Flush Blue XB4
	025242	Switch Body, 22mm 1NO XB4
PBL1	051301	Switch Head, Green Flush ZB4
	025236-31	Switch Body, 22mm Green LED 1NO 24V XB4
PBL2-PBL7	025237-68	Switch Head, 22mm Mom Flush LED Blu XB4
	025236-61	Switch Body, 22mm Blu LED 1 NO 24V ZB4
PL1	024970-3	Light, Green 24V 22mm LED XB4 Pilot
PL2	024970-4	Light, Red 24V 22mm LED XB4 Pilot
PLC	052753	PLC Assembly, E430 (Programmed w/Modules)
	069356	PLC Assembly, E430 2006 (Programmed)
	050163	PLC Module, 4 CH Analog Input 4-20MA
	052754	PLC Module, D06 8P Relay Out
Q1	050906-1 [2]	Disconnect, 100A 3Phase Non-Fused 6mm
	050907-1 [2]	Operator, Red/Yellow Pistol Grip Disconnect 6mm
	050908-1 [2]	Shaft, Disconnect Operator Extension 6mm
R1	052764	Resistor Assembly, 50W 100 Ohm
Reverse Jog, SAFE SW1-SW3	039378	Switch, Safety Limit

SW1	051302	Switch Head, 2 Pos. Maint. ZB4
	025242	Switch Body, 22mm 1NO XB4
T1	052756	Transformer, 2KVA 460V - 230V
TB1	051344	Terminal Block, Green/Yellow Grounding
TB2	024893	Terminal Block, 1 Tier Gray
TB3	051308	Temrinal Block, 1 Tier Black
TB4	050887	Terminal Block, 1 Tier Ground
TB5-7	051324	Terminal Block, 2 Tier w/LED
TB8-TB27, TB61-84, TB86-TB89	052750	Terminal Block, 2P Gray Cage Clamp
TB28-39, TB47-54, TB59-60	052760	Terminal Block, 3P Gray Cage Clamp
TB40, TB42 TB85	052752	Terminal Block, Green/Yellow GND 3P
TB43-TB46	052759	Terminal Block, 3 Tier Cage Clamp
U1	052173	Drive Assembly, IE Blade Position Motor 2005
U2	052174	Drive Assembly, IE Feed Motor 2005

[1] DIN rail-mount contactor 053601 replaces panel-mount contactor 025013 originally supplied prior to 1/11 due to a change in vendor supply. Replacement of old-style contactor requires 9” DIN rail 024474-9, three screws F05015-17 and two clamps E22707. Three 5/32” diameter holes in the mounting panel are required to mount DIN rail. New contactors include transient suppression, eliminating the need for three diode suppression modules 023360.

[2] 5mm Disconnect Shaft OHY45J5 replaced by vendor with 6mm shaft OXP6X290 (2/10). Replacement of any disconnect component requires replacement of disconnect, shaft and operator handle (050906-1, 050907-1 & 050908-1).

6.10 Electrical Component List

E430 ***Rev. A1.00 - A2.00***

Component	Wood-Mizer Part No.	Description
Alarm	024051 [1]	Circuit Breaker, Aux Alarm Switch 1NO1NC
E1	024970-3	Light, Green 24V 22mm LED XB4 Pilot
E2	024970-4	Light, Red 24V 22mm LED XB4 Pilot
F1, F2	051326	Fuse, MDL 1/2 Amp Slow Blow Glass
G1	051321	Power Supply, 110/230VAC 24VDC 2.5A
G2	025124	Power Supply, 10-24V Laser
H1	015401	Hour Meter, Rectangle Mount
K1, K2	053601 [2]	Contactor, 50A 3P 24VDC D-A Series
K3, K5	051322	Contactor, Industrial Edger
K4	024809	Relay, IEC 3NO 1NC 3A 24VDC Control
M1	042301	Motor, 30HP 1800RPM
M2	039274	Motor, 1/2HP 1725RPM
M3	042390	Motor, 2HP 3PH 230/460V TEFC 56C No Base
Q1	050906-1 [3]	Disconnect, 100A 3Phase Non-Fused 6mm
	050907-1 [3]	Operator, Red/Yellow Pistol Grip Disconnect 6mm
	050908-1 [3]	Shaft, Disconnect Operator Extension 6mm
Q2	025111	Breaker, 63A 3 Pole Curve D C60N
Q3	023134	Breaker, 10A 2P Circuit
Q4	E23068	Breaker, 8A 2P 480V Curve D
PLC	051332	PLC Assembly, Industrial Edger (Programmed)
R1	051323 [6]	Resistor, 50W 100 Ohm
S1	051301	Switch Head, Green Flush ZB4
	025236-31	Switch Body, 22mm Green LED 1NO 24V XB4
S2	024945	Switch Head, Red Push Button 22mm XB4
	025161	Switch Body, 22mm 1NC XB4
S4, S6	050152	Switch Head, Green Guarded
	025242	Switch Body, 22mm 1NO XB4
S5, S7	050151	Switch Head, Red Extended
	025161	Switch Body, 22mm 1NC XB4
S8, S9	050197	Switch Head, 22mm Mom Flush Blue XB4
	025242	Switch Body, 22mm 1NO XB4
S10	051302	Switch Head, 2 Pos. Maint. ZB4
	025242	Switch Body, 22mm 1NO XB4
Reverse Jog, SAFE SW1-SW3	039378	Switch, Safety Limit
TB1-4, TB5-7	051324	Terminal Block, 2 Tier w/LED

TB8-39, TB40-45, TB49-53 [4], TB60-72	024893	Terminal Block, 1 Tier Phoenix
TB46, TB73-74	051307	Terminal Block, 1 Tier Red
TB47-48, TB75-76	051308	Terminal Block, 1 Tier Black
TB GND	050887	Terminal Block, 14-1/0 AWG Grounding
T1	051979	Transformer, 380/415/480/600 - 110/220V
	050320 [5]	Transformer, 2KVA 480/240 1P 50/60Hz
U1	052173 [6]	AC Drive, ATV31 1HP 200-240V 1P/3P
U2	052174 [7]	AC Drive, ATV31 2HP 200-240V 1P/3P

[1] Replaces 024072 listed prior to 3/06 (duplicate parts).

[2] DIN rail-mount contactor 053601 replaces panel-mount contactor 025013 originally supplied prior to 1/11 due to a change in vendor supply. Replacement of old-style contactor requires 9" DIN rail 024474-9, three screws F05015-17 and two clamps E22707. Three 5/32" diameter holes in the mounting panel are required to mount DIN rail. New contactors include transient suppression, eliminating the need for three diode suppression modules 023360.

[3] 5mm Disconnect Shaft OHY45J5 replaced by vendor with 6mm shaft OXP6X290 (2/10). Replacement of any disconnect component requires replacement of disconnect, shaft and operator handle (050906-1, 050907-1 & 050908-1).

[4] TB49-53 added 12/03 to accommodate tailer option.

[5] Transformer 050320 replaced with 051979 to accommodate international voltages and provide auxiliary 110V power supply (Rev. A1.03).

[6] 052173 Drive Assembly with ATV31 AC Drive replaces 051333 Drive Assembly with ATV28 originally supplied prior to Rev. A2.00. Resistor 051323 not required with new drive. *See Form #1219* for retrofit instructions.

[7] 052174 Drive Assembly with ATV31 AC Drive replaces 051334 Drive Assembly with ATV28 originally supplied prior to Rev. A2.00. *See Form #1219* for retrofit instructions.

6.11 Component Layout Diagrams

E430 ***Rev. A3.01 - A4.00***
EG400EC30 ***Rev. A4.00+***

Control Cabinet/Laser Interface

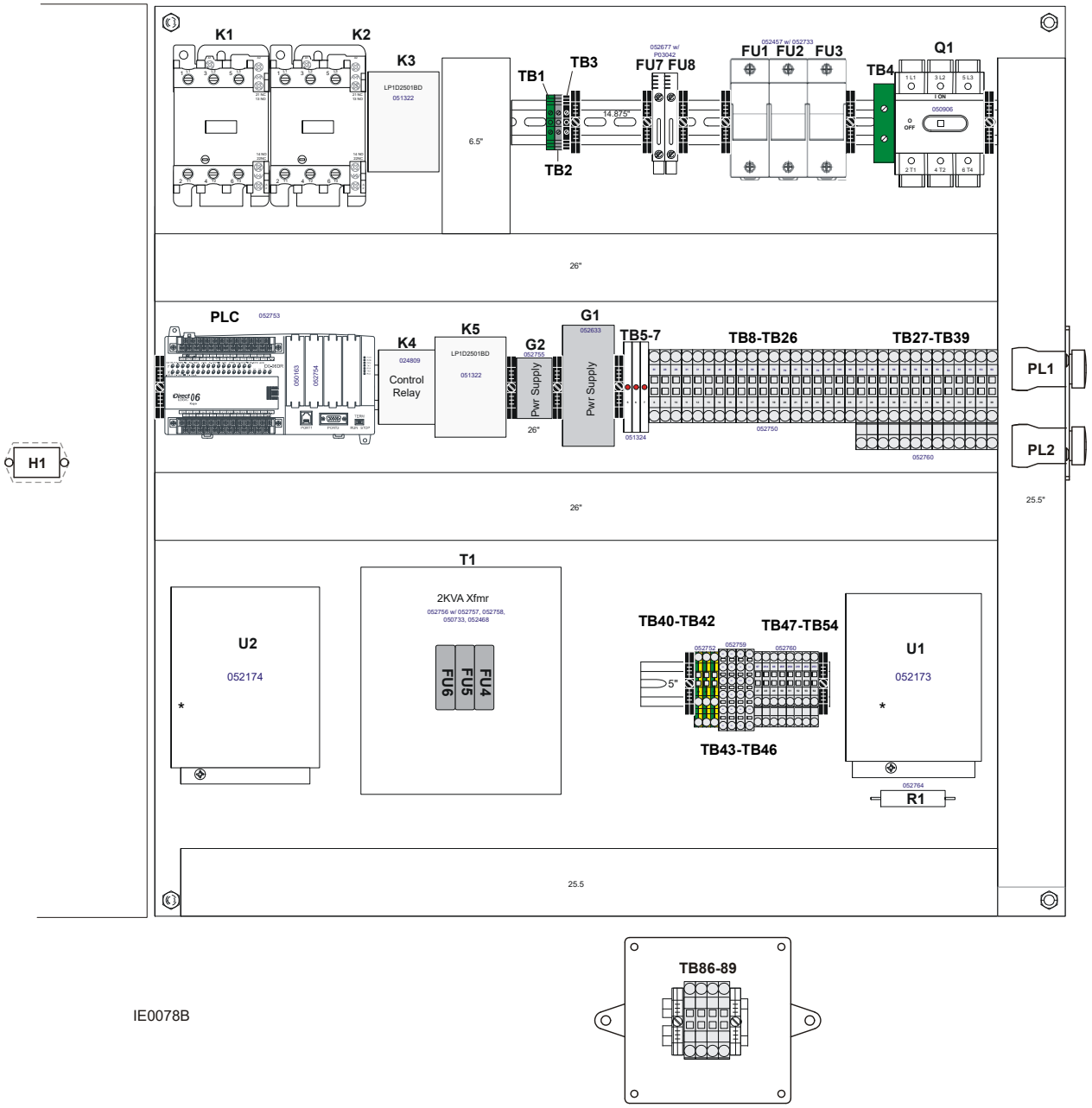


FIG. 6-8

Operator Interface without Setworks

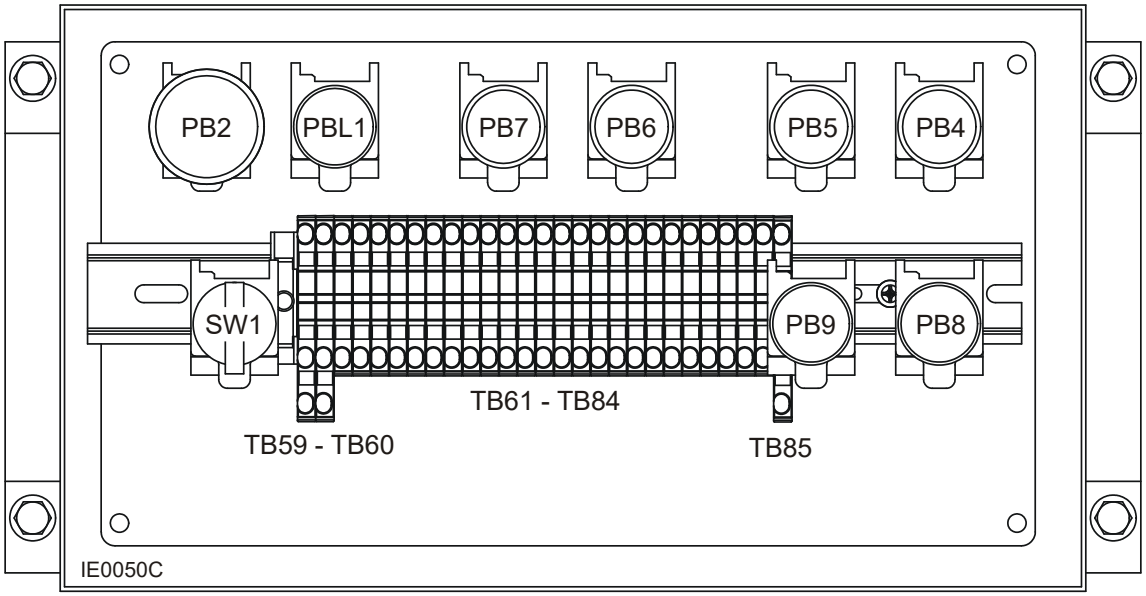


FIG. 6-9

Operator Interface with Setworks

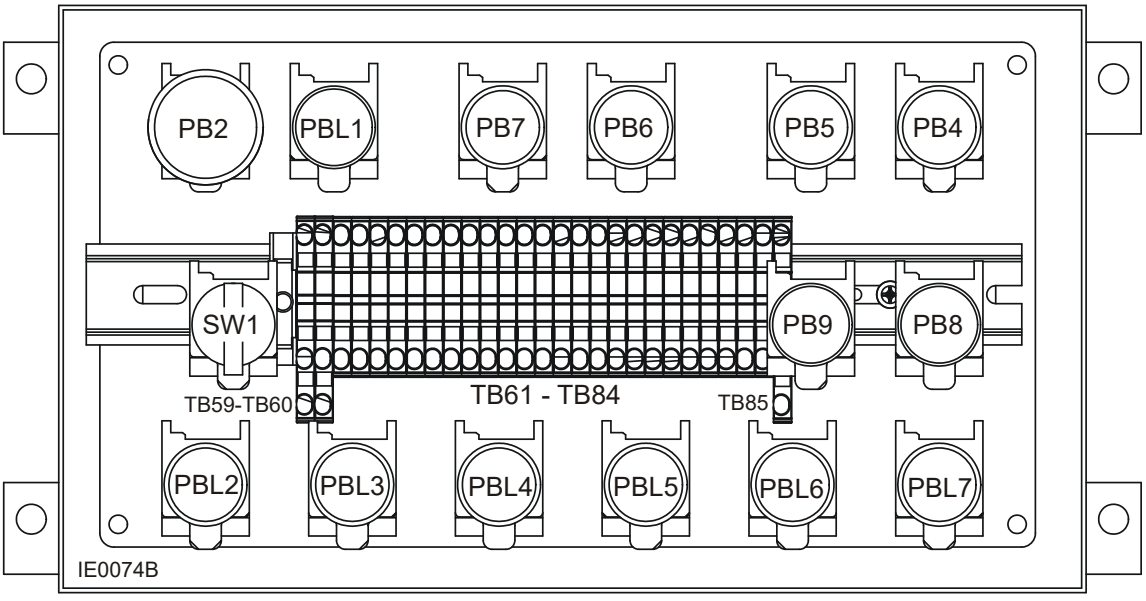
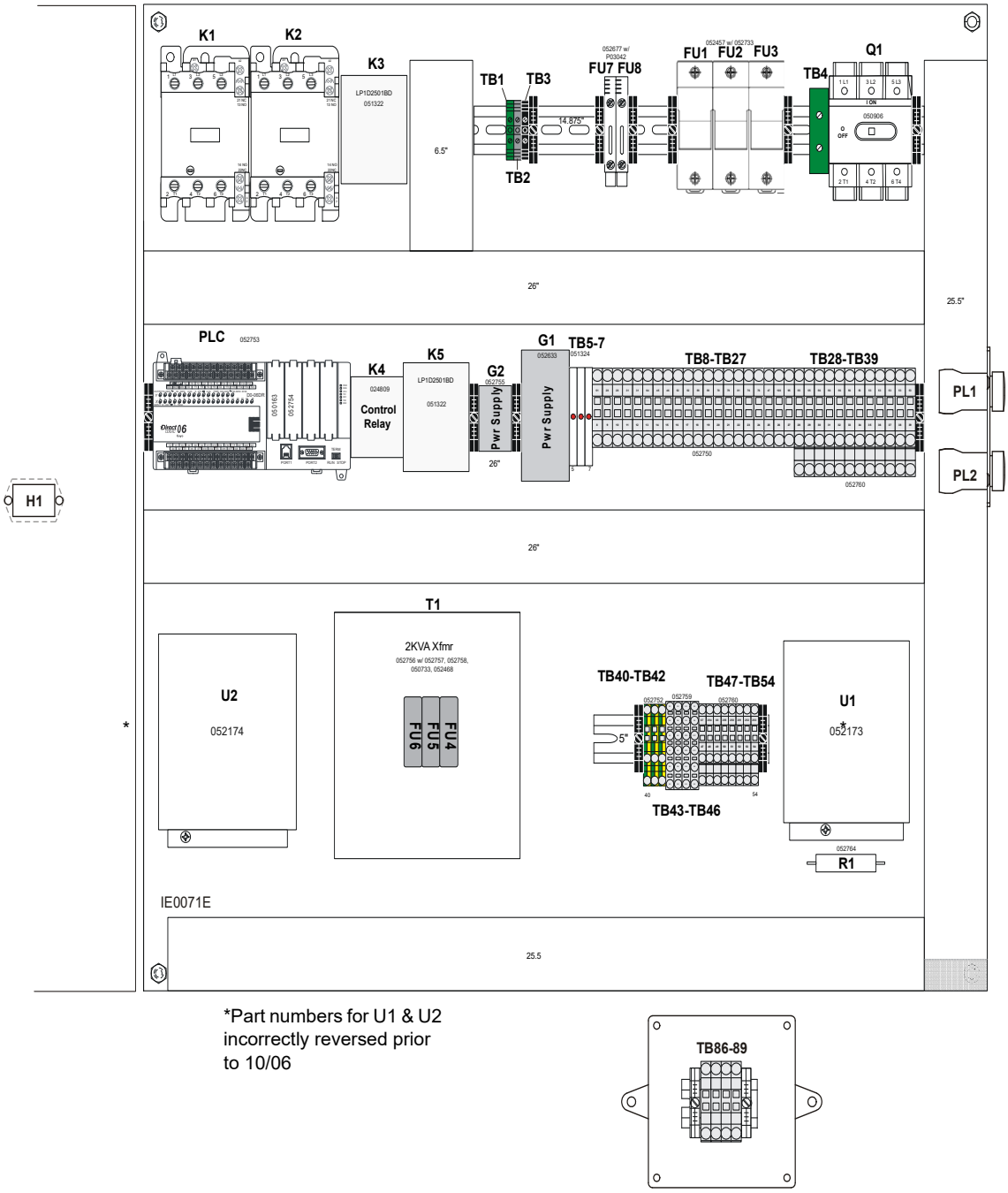


FIG. 6-10

6.12 Component Layout Diagrams

E430 Rev. A3.00

Control Cabinet/Laser Interface



*Part numbers for U1 & U2 incorrectly reversed prior to 10/06

FIG. 6-11

Operator Interface without Setworks

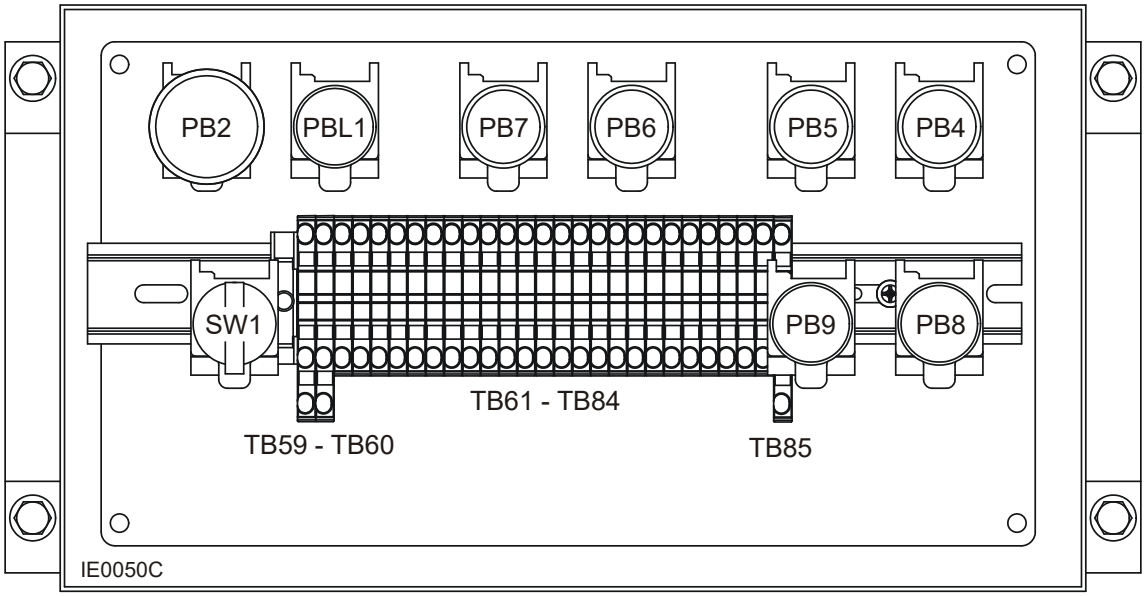


FIG. 6-12

Operator Interface with Setworks

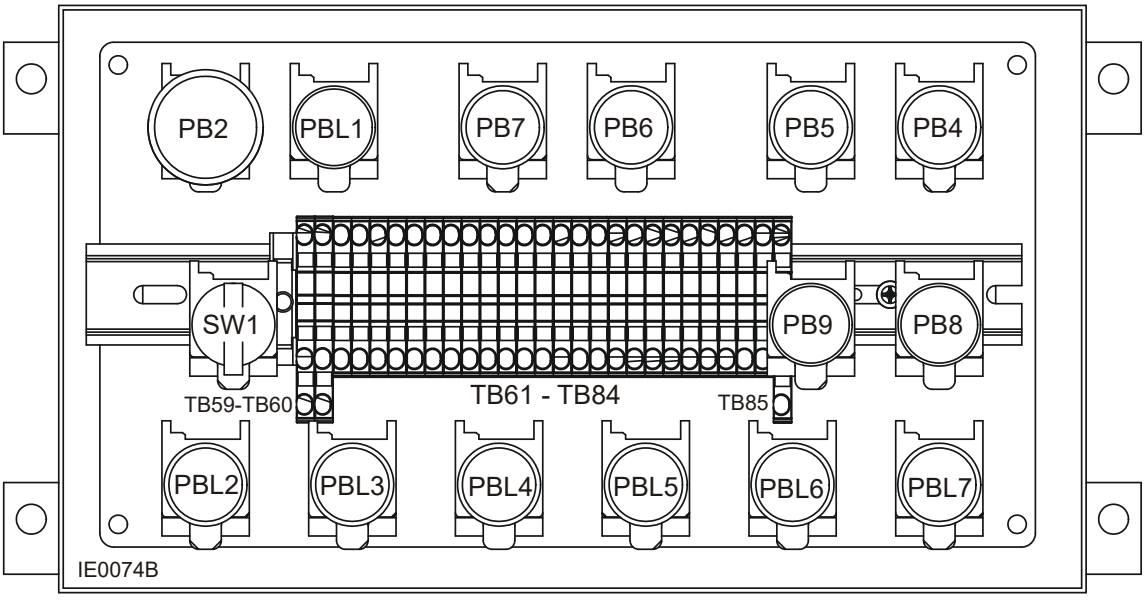


FIG. 6-13

6.13 Component Layout Diagrams

E430 *Rev. A1.00-A2.00*

Control Cabinet/Laser Interface

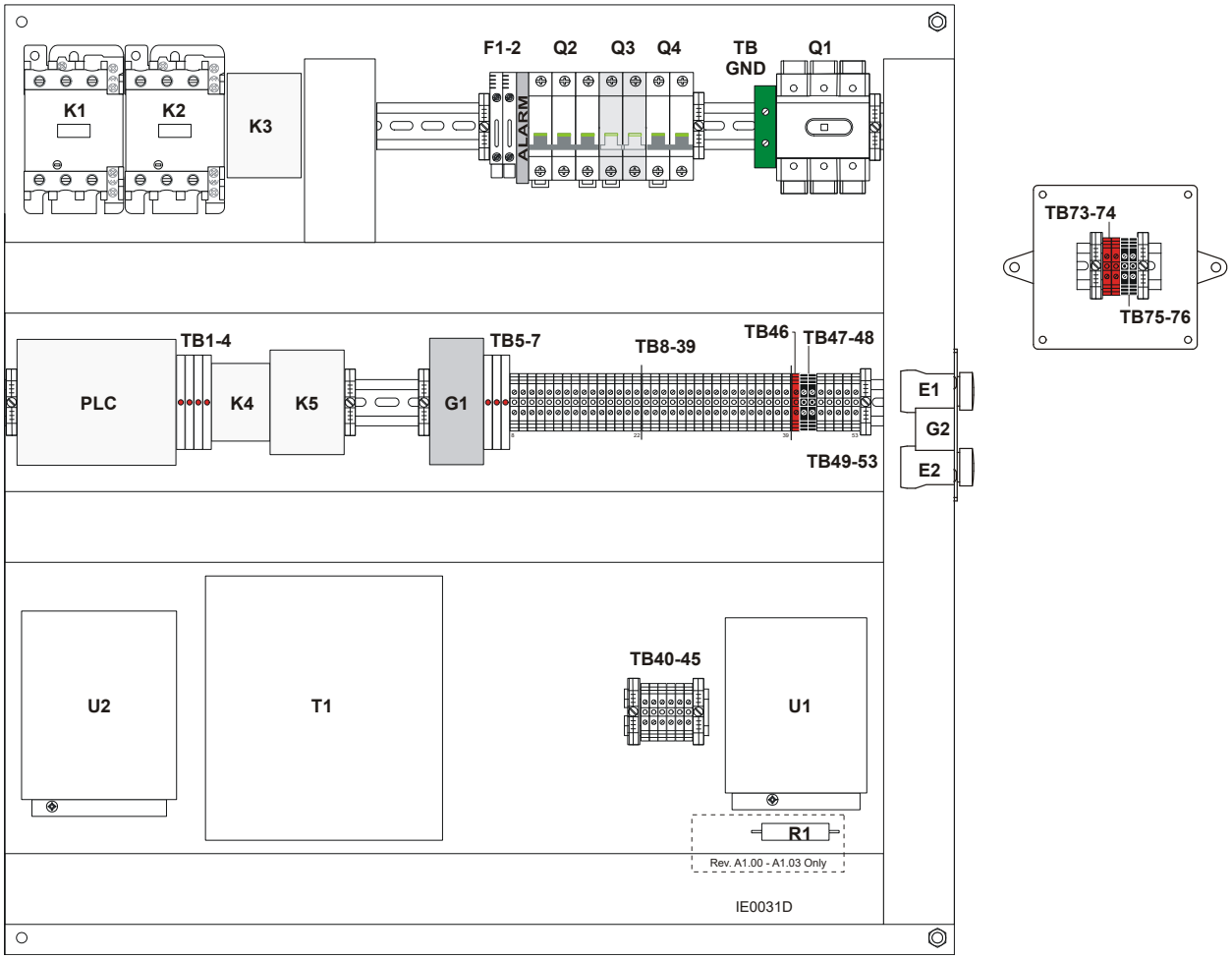


FIG. 6-14

Operator Interface

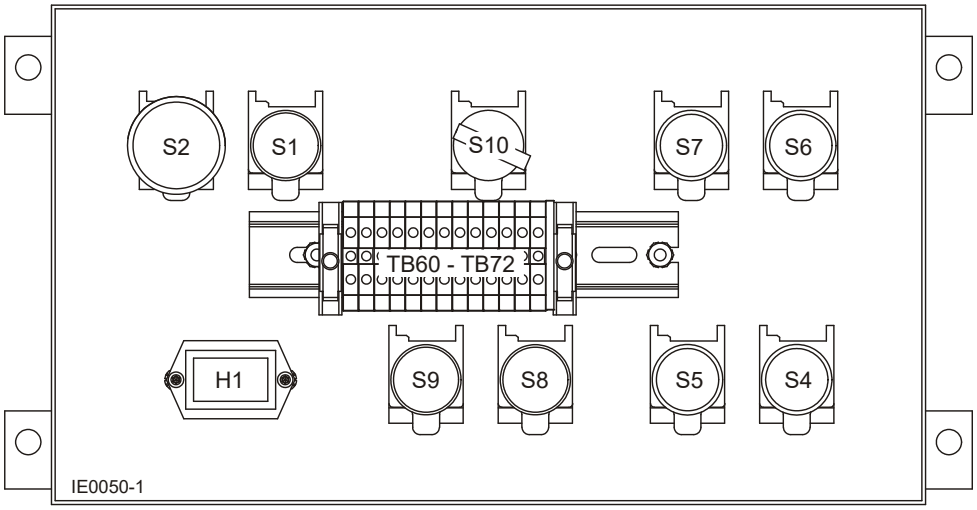


FIG. 6-15

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