Pallet Notcher PN200
Safety, Operation,
Maintenance, & Parts Manual

PN200 WMAM **rev. A1.00**

Safety is our #1 concern!

July 2020

Form #2422

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

California

Proposition 65 Warning

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

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

Active Patents assigned to Wood-Mizer, LLC

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

Wood-Mizer, LLC

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SECTION 1 INTRODUCTION

1.1 About This Manual

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

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

1.2 Getting Service

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

1.3 Specifications

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

SECTION 2 SAFETY

2.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety.

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

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

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

NOTICE indicates vital information.

2.2 Safety Instructions

OWNER/OPERATOR'S RESPONSIBILITY

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

Observe ALL Safety Instructions

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

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

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

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

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

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

It is the owner/operator's responsibility to comply with all applicable federal, state, and local laws, rules, and regulations regarding the ownership, operation, and transporting your equipment. Operators should become thoroughly familiar with and comply with these applicable laws for operating and transporting equipment.

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

Keep Work Area Clean

WARNING! Maintain a clean and clear path for all necessary movement around the equipment and lumber stacks.

NOTICE Always properly dispose of all sawing by-products, including sawdust and wood debris.

If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed.

Inspect all safety decals to ensure they 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.

Wear Safety Clothing (Personal Protection Equipment)

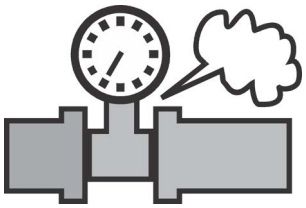
WARNING! Wear eye, ear, and foot protection when operating or servicing the sawmill.

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

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

Pneumatic Operations I

WARNING! If air pressure is lost during a cycle and power not disconnected, cycle will complete when pressure returns.



Safety cover will drop if air pressure is lost.

2.3 Electrical Lockout Procedures

RULES FOR USING LOCKOUT PROCEDURE

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

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

- Changing or adjusting blades
- 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, BUT NOT LIMITED TO:

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

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

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

TO CONTROL MAINTENANCE DANGERS:

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

EQUIPMENT LOCKOUT PROCEDURE

Lockout procedures per OSHA regulation 1910.147, appendix A:

GENERAL

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

PURPOSE

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

COMPLIANCE WITH THIS PROGRAM

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

SEQUENCE OF LOCKOUT

1. Notify all affected personnel that servicing or maintenance is required on a machine or equipment and that the machine or equipment must be shut down and locked out to perform the servicing or maintenance.

2. The authorized employee shall refer to the company procedure to identify the type and magnitude of the energy that the machine or equipment utilizes, shall understand the hazards of the energy, and shall know the methods to control the energy.

3. If the machine or equipment is operating, shut it down by the normal stopping procedure (depress the stop button, open switch, close valve, etc.).

4. De-activate the energy isolating device(s) so that the machine or equipment is isolated from the energy source(s).

5. Lock out the energy isolating device(s) with assigned individual lock(s).

6. Stored or residual energy (such as that in capacitors, springs, elevated machine members, rotating flywheels, hydraulic systems, and air, gas, steam, or water pressure, etc.) must be dissipated or restrained by methods such as grounding, repositioning, blocking, bleeding down, etc.

7. Ensure that the equipment is disconnected from the energy source(s) by first checking that no personnel are exposed, then verify the isolation of the equipment by operating the push button or other normal operating control(s) or by testing to make certain the equipment will not operate.

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

8. The machine or equipment is now locked out.

RESTORING EQUIPMENT TO SERVICE

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

1. Check the machine or equipment and the immediate area around the machine to ensure that nonessential items have been removed and that the machine or equipment components are operationally intact.

2. Check the work area to ensure that all personnel have been safely positioned or removed from the area.

3. Verify that the controls are in neutral.

4. Remove the lockout devices and re-energize the machine or equipment.

SECTION 3 OPERATION

WARNING! Use on new lumber only. Failure to follow this may result in death or serious injury. Hot metal debris from nails, etc., in reused lumber may cause sawdust to ignite.

Do not operate this machine with safeguards bypassed.

This machine is intended to be used as a stand-alone unit, not integrated with other machines.

3.1 Site Preparation

An outside source of compressed air adjustable from 80-120 psi (5.6-8.4 Kg/cm) is required.

WARNING! Have a certified electrician install the power to your machine. Failure to do so may result in death or serious injury.

Ensure the power supply cables are not a trip hazard.

Do not operate without dust collection connected to dust port/outlet.

Do not run system with panel door open.

CAUTION! Improper voltage will cause damage to the motor and electronic components. Have a qualified electrician install the power supply to begin using your equipment.

NOTICE The power supply must meet the motor specifications concerning wire size, fused disconnect, and voltage, which are provided in the motor's manual. The electrical installation must also meet local codes.

Ensure the blade spins in the proper direction. If not, have the electrician change the motor rotation.

Use dust collection of 3,000 cfm or better.

3.2 Onsite setup

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

Do not allow children in the area of the equipment.

Set up the equipment on level ground.

Do not use in low lighting.

Do not use in a high moisture environment.

Do not use in extreme temperatures.

"Home position" when connected to a pneumatic system has the table forward and the lid open.

FIG. 3-1 HOME POSITION

3.3 Controls

CONTROL POWER -- supplies power to the control panel. See Fig. 1-2.

EMERGENCY STOP - disconnects all external power to the machine. See Fig. 1-2.

CYCLE START BUTTONS - *both buttons must be pressed simultaneously.* Initial press turns on the cutter head. Subsequent presses cycle the notcher. See Fig. 1-3.

CYCLE INTERRUPT BUTTON - immediately returns the notcher to home postition and turns off the cutter head. See Fig. 1-3.

SYSTEM STATUS LIGHT -

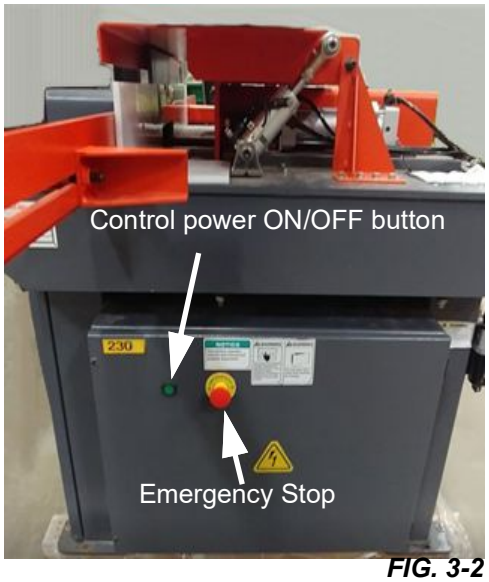


FIG. 3-2

FIG. 3-3

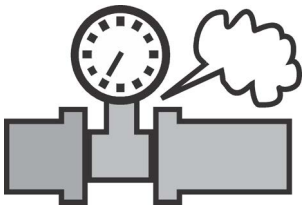
3.4 Operation

WARNING! Keep hands 12” away from the blades at all times.

1. Ensure the area is clear and free from unnecessary personnel.
2. Set the board stops at the desired distance.
3. Verify Emergency Stop on the machine electrical cabinet door is released; if not released, twist and pull “Emergency Stop” to release.
4. Turn on Control Power by pressing the green power button on the electrical panel door. See Fig. 1-2.
5. Press and hold the two green Cycle buttons simultaneously until the motor engages and the buttons light (approximately 5 seconds).
   - **a.** System Initiated pilot light turns on
   - **b.** Motor starter engaged; system controls are locked out for 5 sec to allow for motor startup.
6. Load a board into the cutting fence.

   NOTE: Ensure electrical panel door is fully closed.
7. Press and **hold** the two green Cycle buttons again to start the cutting cycle; both buttons must be pressed during cut cycle or the cut cycle will abort.

WARNING! If air pressure is lost during a cycle and power not disconnected, cycle will complete when pressure returns.



Safety cover will drop if air pressure is lost.

- **a.** The pneumatic clamp secures the board.
- **b.** The lid (safety cover) closes.

NOTE: Cycle will not continue if the lid is not fully closed!

- **c.** The table moves across the cutting head and returns.
- **d.** The lid (safety cover) opens.

WARNING! The blades remain spinning as the board is unloaded.

8. Release Cycle buttons.
9. Unload the board and set the next board in the fence.
10. Press both green buttons simultaneously to begin a second cycle.
11. Repeat for the amount of board to be notched.

3.5 System Stop

The system is equipped with two stop buttons: one "Emergency Stop" on the machine electrical cabinet door and one "Cycle Stop" on the operator pedestal.

EMERGENCY STOP

1. Press the “Emergency Stop” at any time to power down the complete system.
   - **a.** The cut motor is de-energized and will coast to a stop.
   - **b.** The clamp remains engaged in the closed position to prevent the possibility of the wood being “kicked” loose injuring the operator.
   - **c.** The protective lid will open.

2. Check the system for any issues and resolve said issues.
3. Twist and pull to release “Emergency Stop” button.

CYCLE STOP

1. Press “Cycle Stop” button on the operator console to abort the current cut cycle.
    a. The cut motor is de-energized and will coast to a stop.
    b. The table will return to the home position.
    c. Once the table returns to the home position the clamp will be released and the protective lid will open.
2. Twist and pull the “Cycle Stop” button to release the “System Stop”.

NOTE: After either a Cycle Stop or Emergency Stop verify that all issues with the machine are resolved. Once resolved the system is ready to be restarted following Start-Up

3.6 Operational Error Codes

During operation the System Ready light may display flashing error codes to indicate malfunctions.See *Section 4.3 Troubleshooting*.

SECTION 4 MAINTENANCE

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

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

Ensure your unit is on a level surface and secure from movement.

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

General Maintenance

Ensure power is removed.

Check for/remove debris in guards, clamps, motor compartment, sawdust exhaust, and around the work station after every use.

4.1 Lubricate

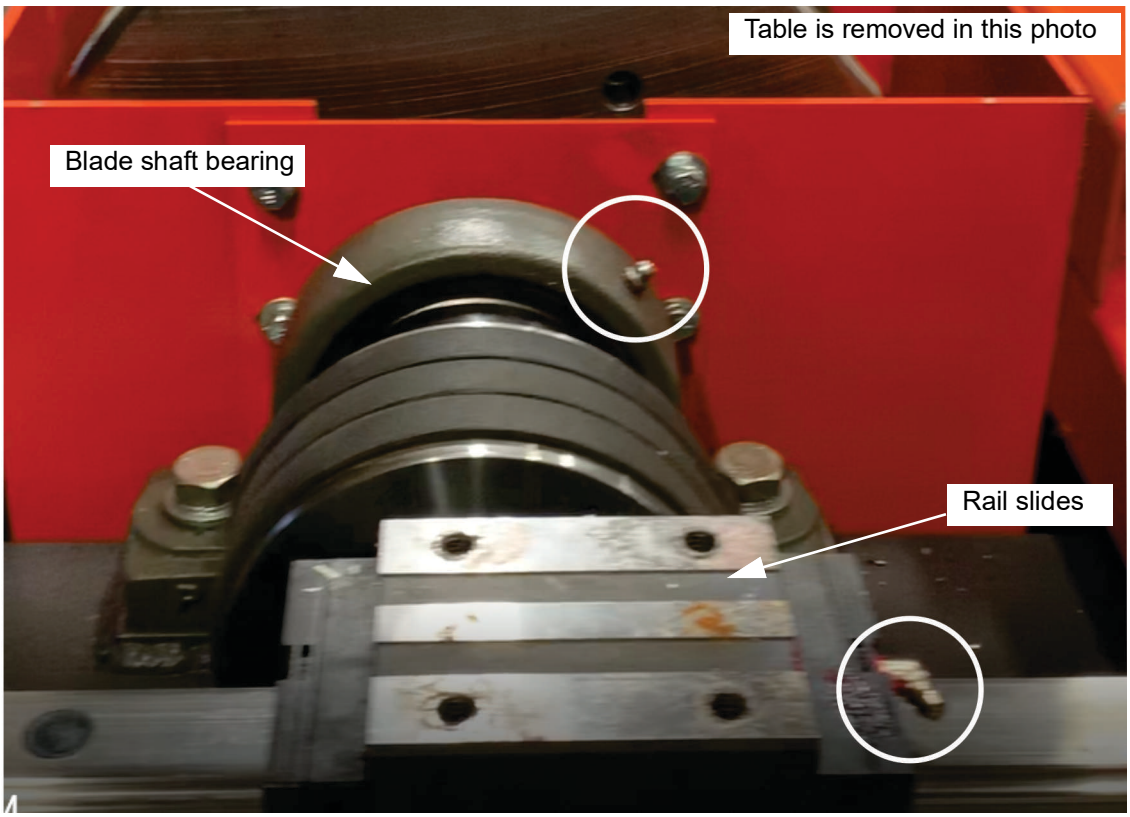


FIG. 4-1

Grease fittings are located on the rail slides (4) and the blade shaft bearings (2).

4.2 Changing the blades

Remove the table

1. Ensure power has been locked out. (See Section 2.3 Electrical Lockout Procedures.)
2. Disconnect the compressed air supply.
3. Disconnect the air lines from the rear of the pallet notcher. See Fig. 4-2.

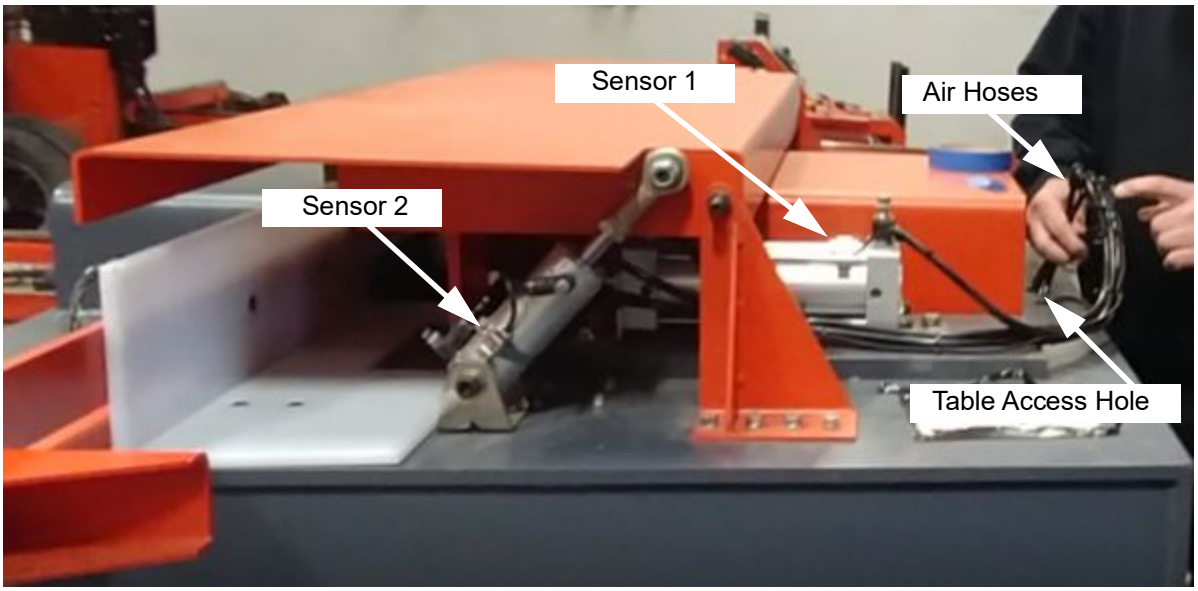


FIG. 4-2

NOTE: Ensure that you can reattach the hoses in the same positions. Mark or otherwise secure the hoses for smooth reattachment.

4. Drop the air hoses through the table access hole.
5. Remove sensors 1 and 2 from the cylinders.
   - **a.** Mark where the sensor 1 and its clamp are located from the factory (for reattachment in the same location).
   - **b.** Loosen (do not remove) the sensor clamp to remove the sensor. (See Fig. 4-3.)

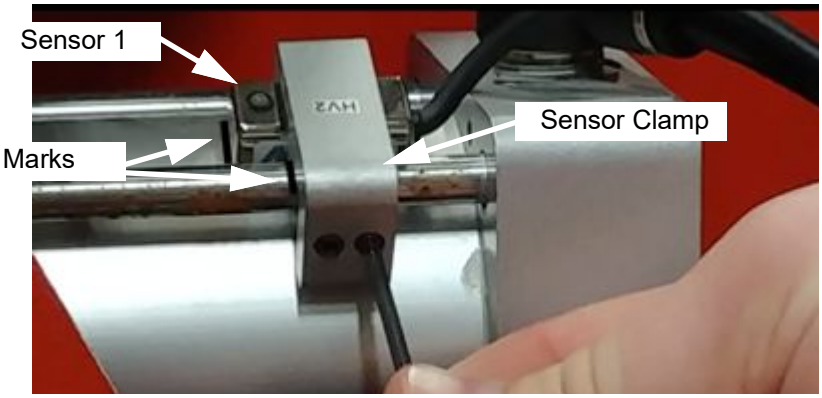


FIG. 4-3

   - **c.** Mark where the sensor 2 and its clamp are located from the factory (for reattachment in the same location).

d. Remove the sensor 2 and its clamp. (See Fig. 4-4.)

NOTE: The sensors are only on one side.

Do not misplace the clamp; it will be needed for reattachment.

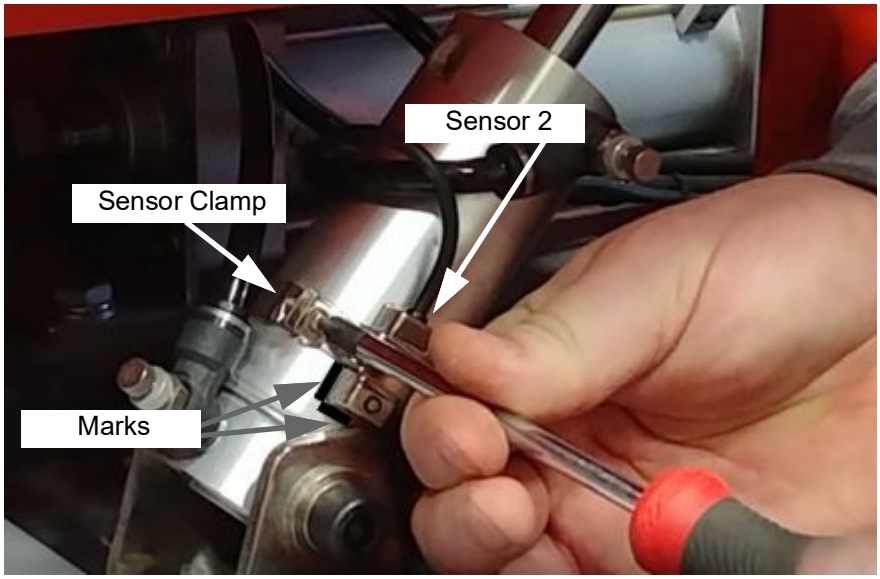


FIG. 4-4

e. Clip the wire wraps to free the sensor cables.

f. Drop the sensors through the table access hole. See Fig. 4-2.

6. Manually pull the table towards the rear of the machine.

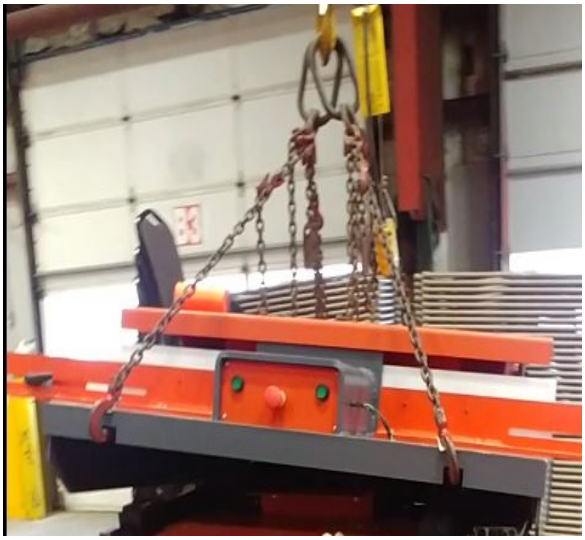
7. Unfasten and remove the box fastened to the underside of the table at the rear center, along with the hoses and wires. See Fig. 4-5.

FIG. 4-5

8. Remove the 4 sets of 4 table mounting bolts (16 total) from the top of the table.

The table is now disconnected.

9. Use a crane or other lifting device to raise the table from the stand. See Fig. 4-6.



FRONT LIFT POINTS

REAR LIFT POINTS

FIG. 4-6

10. Set the table top aside in a secure location.

Remove blades

1. Take a measurement of the distance along the shaft between the outer blades and the end of the shaft threads to determine a baseline for returning the new blades to a similar position. See Fig. 4-7.

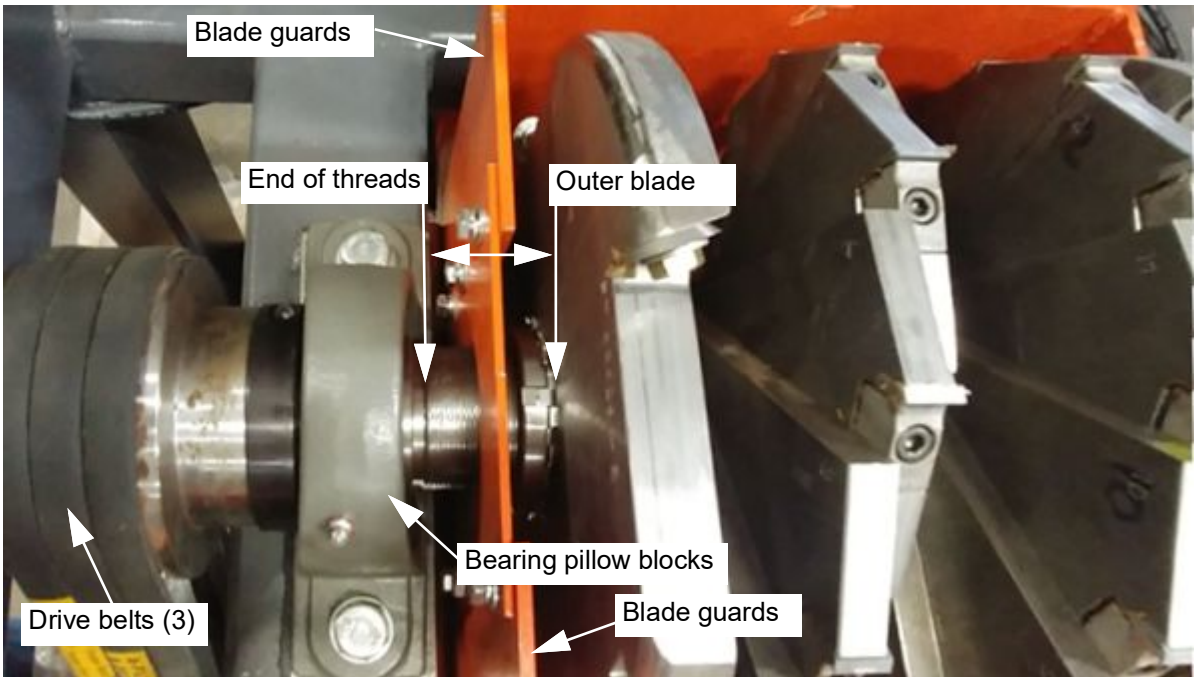


FIG. 4-7

2. Remove the cutter blade guards. See Fig. 4-7.
3. Remove the drive belts. See Fig. 4-7.
4. Unbolt the bearing pillow blocks, both sides. See Fig. 4-7.

   NOTICE: The blades weigh over 200 lbs (90kg). Use a lifting device.

5. Lift the blades and shaft completely out of the machine stand.
6. Place the blade set on a secure workstation.
7. See *Section 5.4 Notching Head Assembly* for parts breakdown.

8. Loosen the set screw and remove the collar at the end of the shaft.

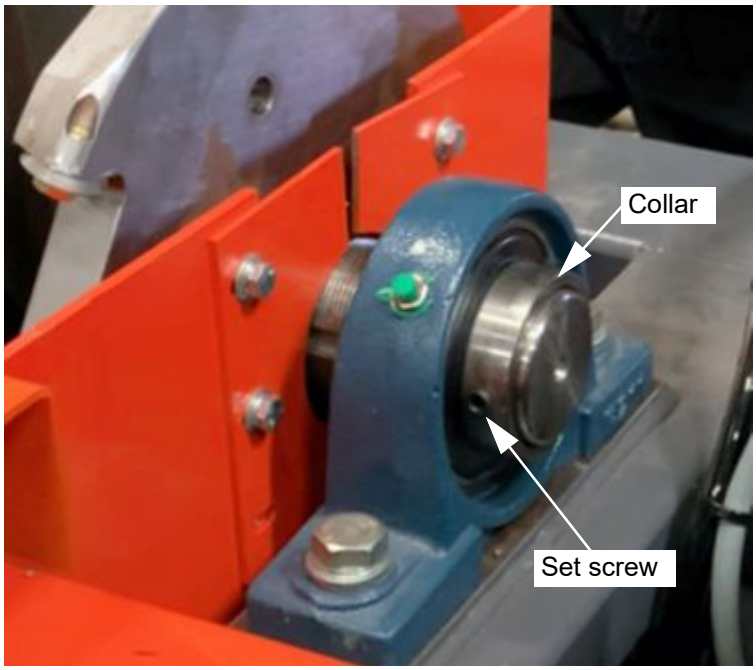


FIG. 4-8

9. Remove the bearing pillow block.

10. Remove the spanner nut and its locking retainer.

11. Slide off the old cutting blades.

12. Slide on the new cutting blades in numeric order and in a spiral pattern. See Fig. 4-9.

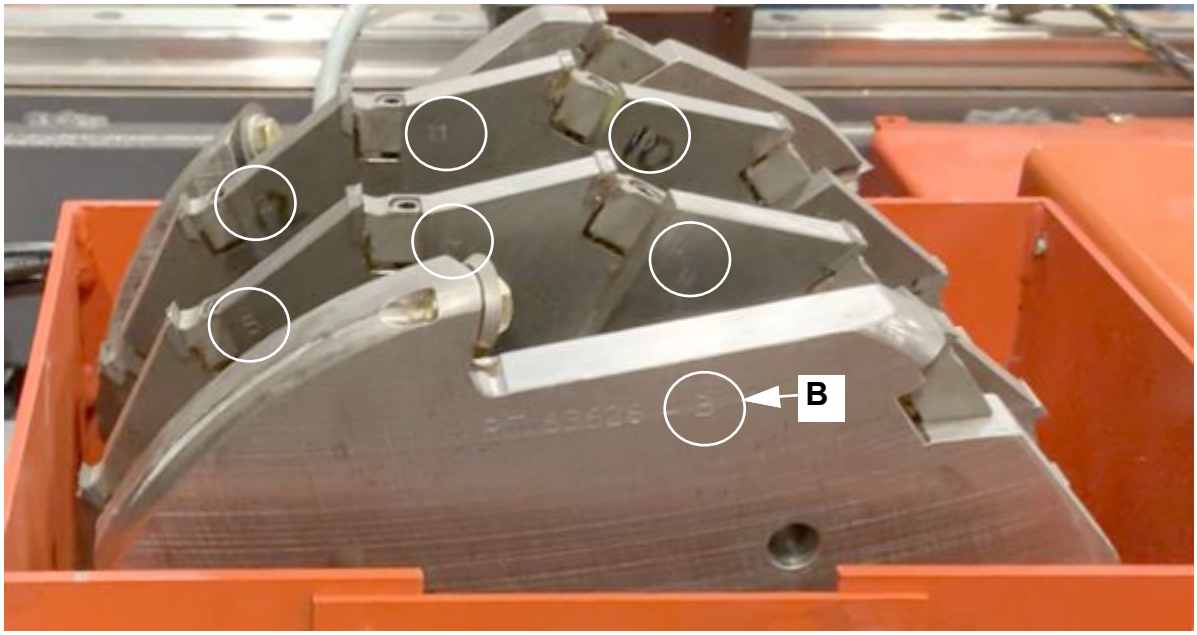


FIG. 4-9

a. Place the “B” outer blade on the pulley end of the shaft.

b. Follow the numbering on the blades, creating an evenly spaced spiral as you slide on the next blades. (Blades are keyed.)

c. Place the “A” outer blade on the far end of the shaft.

d. Set the shaft key in place.

e. Ensure the blades are compacted together with no gaps.

13. Replace the locking retainer, spanner nut, bearing pillow blocks, and collar to the shaft in the reverse order that they were disassembled.

Replace the cutter head

1. Set the cutter head onto the base of the machine approximately in the same position as it came out.

2. Use a square to realign the shaft parallel to the frame of the unit; when parallel, tighten the bearing pillow blocks.

NOTICE The blade shaft must be aligned parallel for proper operation.

3. Grease the pillow blocks while they are easily accessible.

Replace the table

Replace the table in the reverse order that it was removed.

Ensure the sensors are replaced according to the marks made when the sensors were removed.

4.3 Troubleshooting

“System Ready” indicator light is also used as a fault indicator. When an error occurs this light will flash a fault code followed by a 2 second pause.

Faults can be cleared by pressing and releasing the “Cycle Stop” button.

CONSTANT FLASHING

Cut Stop button pressed.

(this error is expressed only if all other errors have been corrected).

Release “Cut Stop” button.

1 FLASH

Cycle button tied down.

One or both “Cycle” buttons has been observed to be constantly pressed.

Verify neither button is pressed continuously.

2 FLASHES

Motor overload.

The motor overload has been observed by the PLC to have tripped.

Open machine electrical cabinet and press the reset button on the motor overload.

3 FLASHES

Clamp Sensor fault.

Clamp has been observed by the PLC to not leave the open position upon start of cut cycle.

Verify sensor is properly mounted and operational.

Verify the system is connected to a sufficient air supply and the air shutoff is in the on position.

4 FLASHES

Protective lid not closed.

The protective lid has been observed by the PLC to not be in the closed position.

Verify the sensor is properly mounted and operational.

Verify the system is connected to a sufficient air supply and the air shutoff is in the on position.

5 FLASHES

Cut Position error.

Table is observed by PLC to not reach the cut position.

Verify the sensor is properly mounted and operational.

Verify the system is connected to a sufficient air supply and the air shutoff is in the on position.

6 FLASHES

Table Home Position error.

Table is observed by the PLC to have not returned to the home position after a cut has been made.

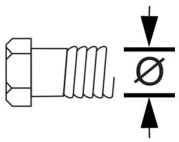
Verify the sensor is properly mounted and operational.

Verify the system is connected to a sufficient air supply and the air shutoff is in the on position.

Once all faults are cleared the system may be restarted following the start-up procedure.

SECTION 5 SERVICE PARTS

5.1 Torque Values



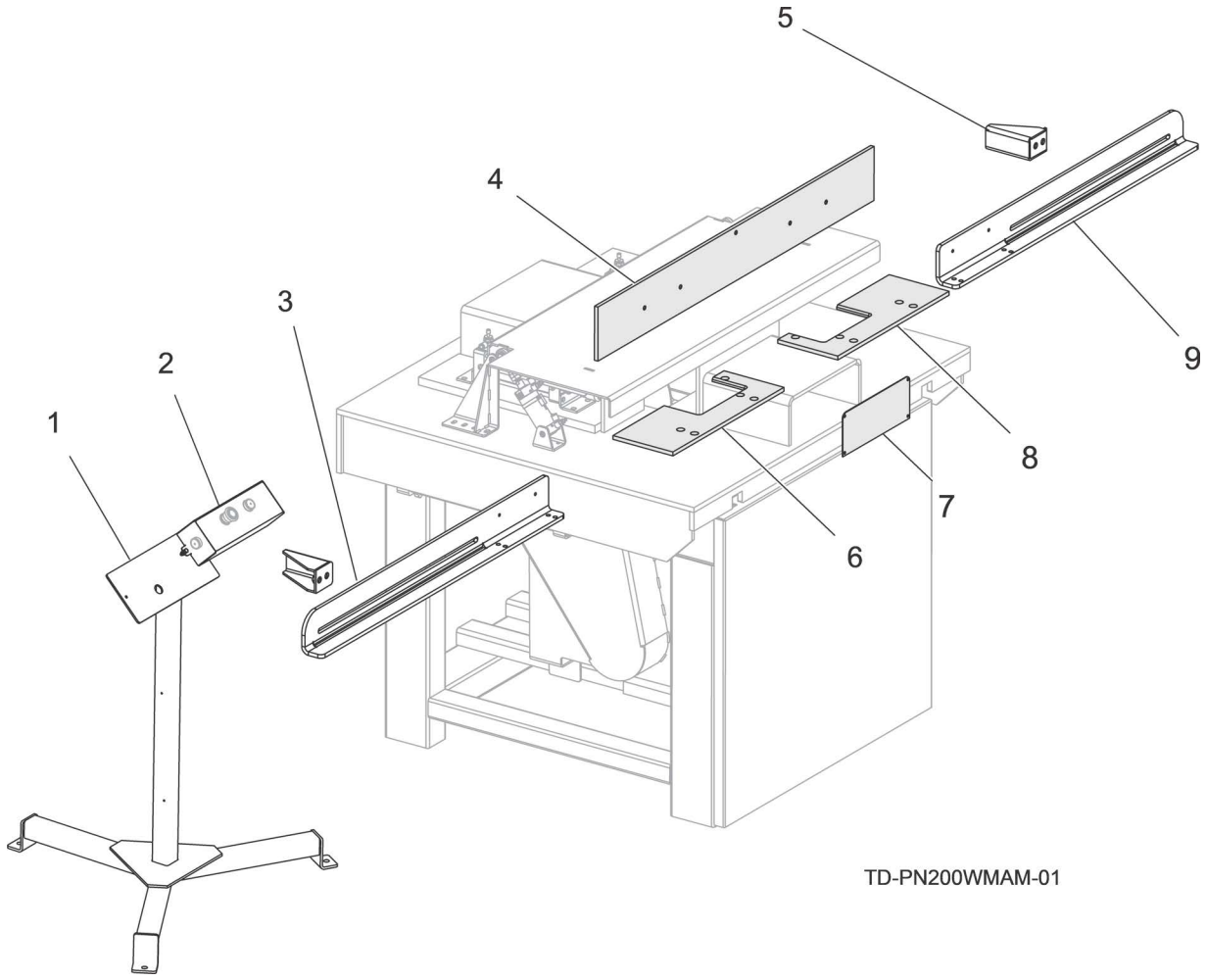
Metric Bolt Head Identification

Metric Grade 8.8

Metric Grade 10.9

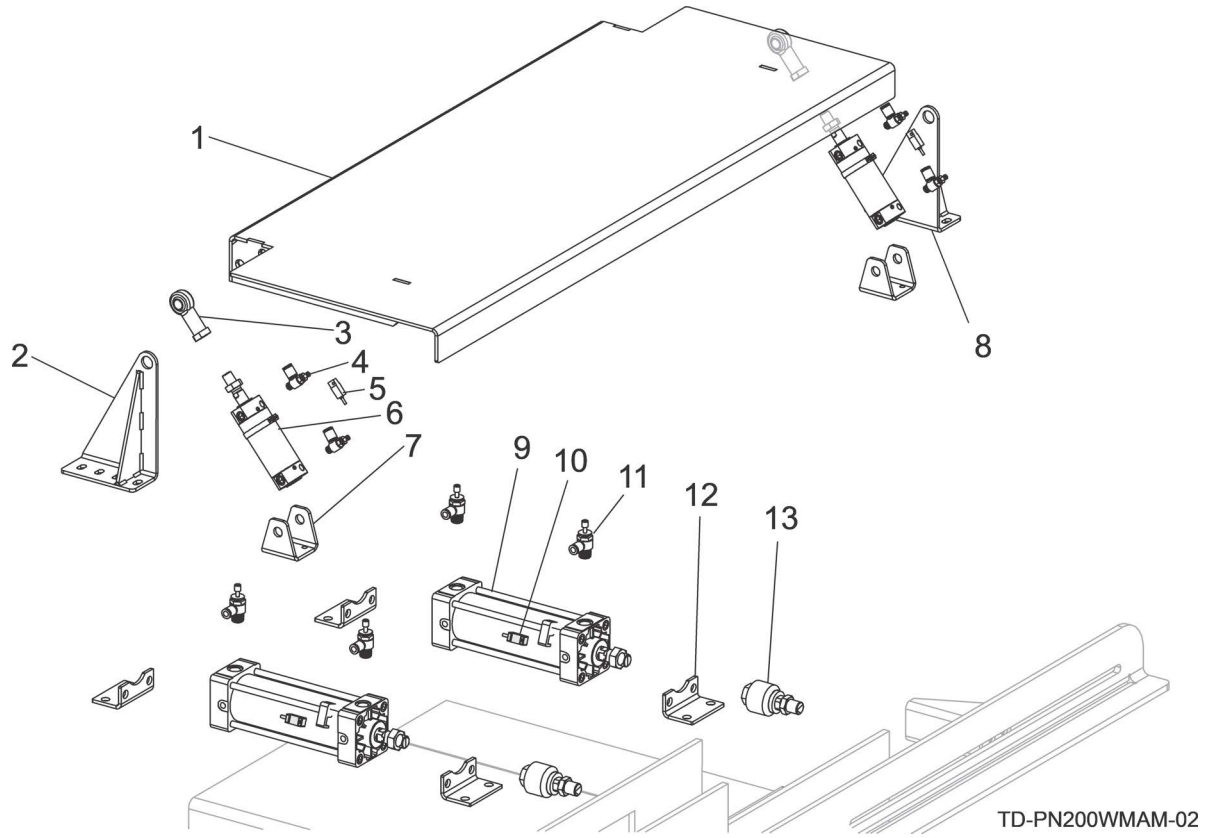
COARSE THREAD					FINE THREAD					Wrench Size
Diameter & Thread Pitch	Metric 8.8		Metric 10.9		Diameter & Thread Pitch	Metric 8.8		Metric 10.9		
	N-m	lbs-ft	N-m	lbs-ft		N-m	lbs-ft	N-m	lbs-ft	
6 x 1.0	8	6	11	8						10 mm
8 x 1.25	20	15	27	20	8 x 1.0	21	16	29	22	13 mm
10 x 1.5	39	29	54	40	10 x 1.25	41	30	57	42	16 mm
12 x 1.75	68	50	94	70	12 x 1.25	75	55	103	76	18 mm
14 x 2.0	109	80	151	111	14 x 1.5	118	87	163	120	21 mm
16 x 2.0	169	125	234	173	16 x 1.5	181	133	250	184	24 mm
18 x 2.5	234	172	323	239	18 x 1.5	263	194	363	268	27 mm
20 x 2.5	330	244	457	337	20 x 1.5	367	270	507	374	30 mm
22 x 2.5	451	332	623	460	22 x 1.5	495	365	684	505	34 mm
24 x 3.0	571	421	790	583	24 x 2.0	623	459	861	635	36 mm
30 x 3.0	1175	867	1626	1199	30 x 2.0	1258	928	1740	1283	46 mm

5.2 Front Panels



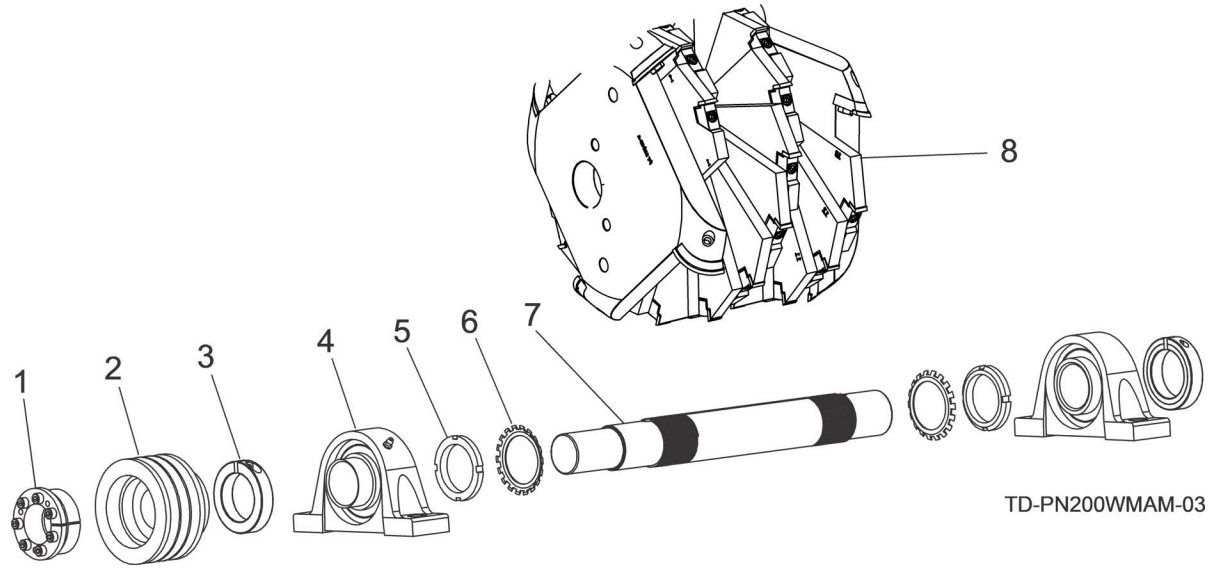
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	123179	Weldment, PN200 Controls		
2	123180	Wledment, Control Box		
3	123198	Bracket, Extension Arm Left		1
4	123177	Plate, UHMW Clamp		1
5	123186	Weldment, Board Stop		2
6	123191	Plate, UHMW Base, Left		1
7	123207	Plate, Control Panel Cover		1
8	123172	Plate, UHMW Base, Right		1
9	123190	Bracket, Extension Arm Right		1

5.3 Table Parts



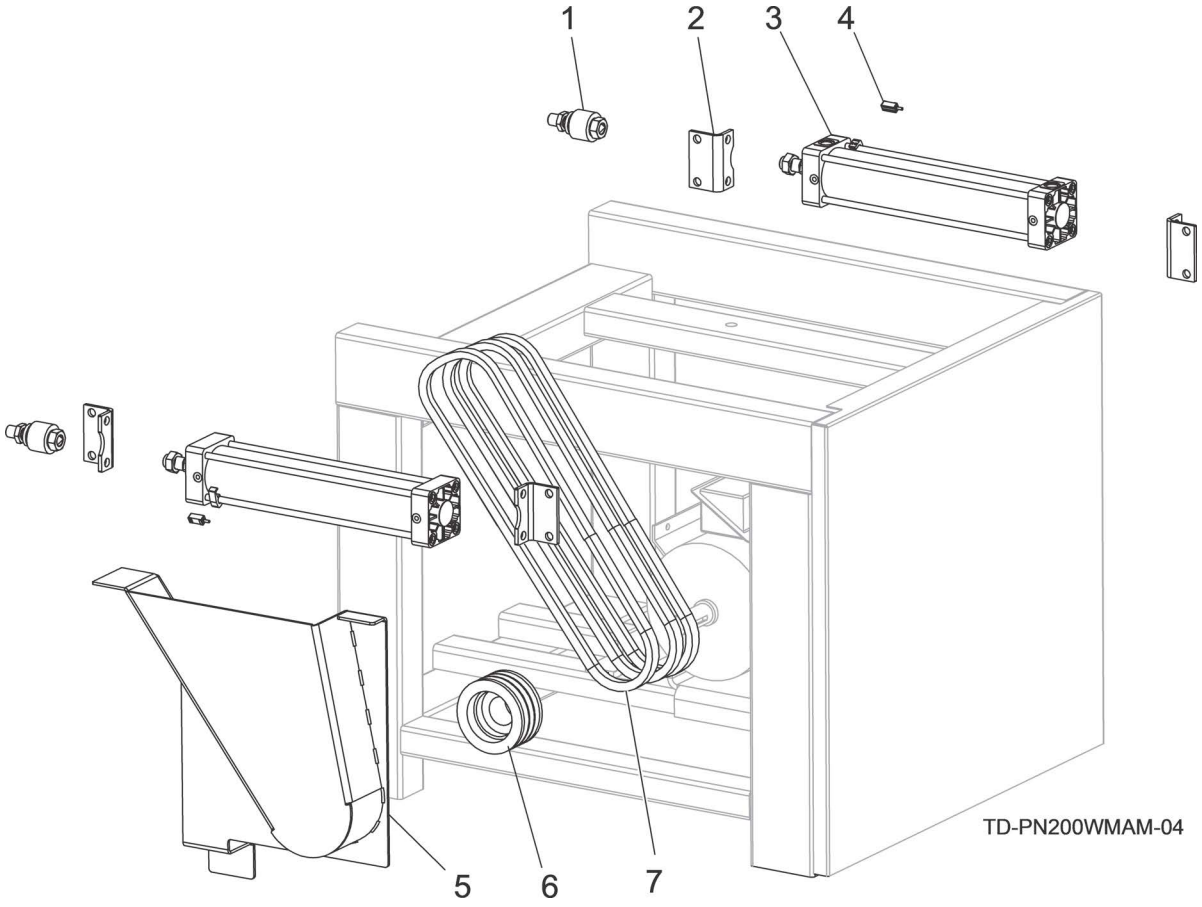
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	123175	Weldment, Cover		1
2	123195	Weldment, Cover Mount Left		1
	123170	Assembly, Cylinder, 40mm Bore, 50mm Stroke		2
3	123199	Rod End, M14		1
4	123213	Flow Control, 1/8 BSPT Inlet x 8mm Outlet		2
5	123278	RCM		1
6	123192	Cylinder, 40mm Bore, 50mm Stroke		1
7	123263	Bracket, Cylinder Mount, 40mm		1
8	123196	Weldment, Cover Mount Right		1
	123171	Assembly, Cylinder 63mm Bore		2
9	123201	Cylinder, 63mm Bore, 150mm Stroke		1
10	123279	RCA		1
11	123273	Flow Control, 3/8 BSPT Inlet x 8 mm Outlet		2
12	123267	Bracket, Cylinder Mount, 63mm		2
13	123253	Floating Joint, M18		1

5.4 Notching Head Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	123229	Assembly, Notching Head		1
1	123281	Bushing, 50mm Keyless		1
2	123282	Sheave, Notching Head		1
3	123276	Shaft Collar, 60mm		2
4	123228	Pillow Block, 55mm		2
5	123275	Nut, M60 x 2 mm Retaining		2
6	F05026-19	Washer, M60 Spring Lock		2
7	123183	Shaft, Cutter Head		1
8	123262	Cutter Head (See *Section 5.6 Cutter Head*)		1

5.5 Lower Parts

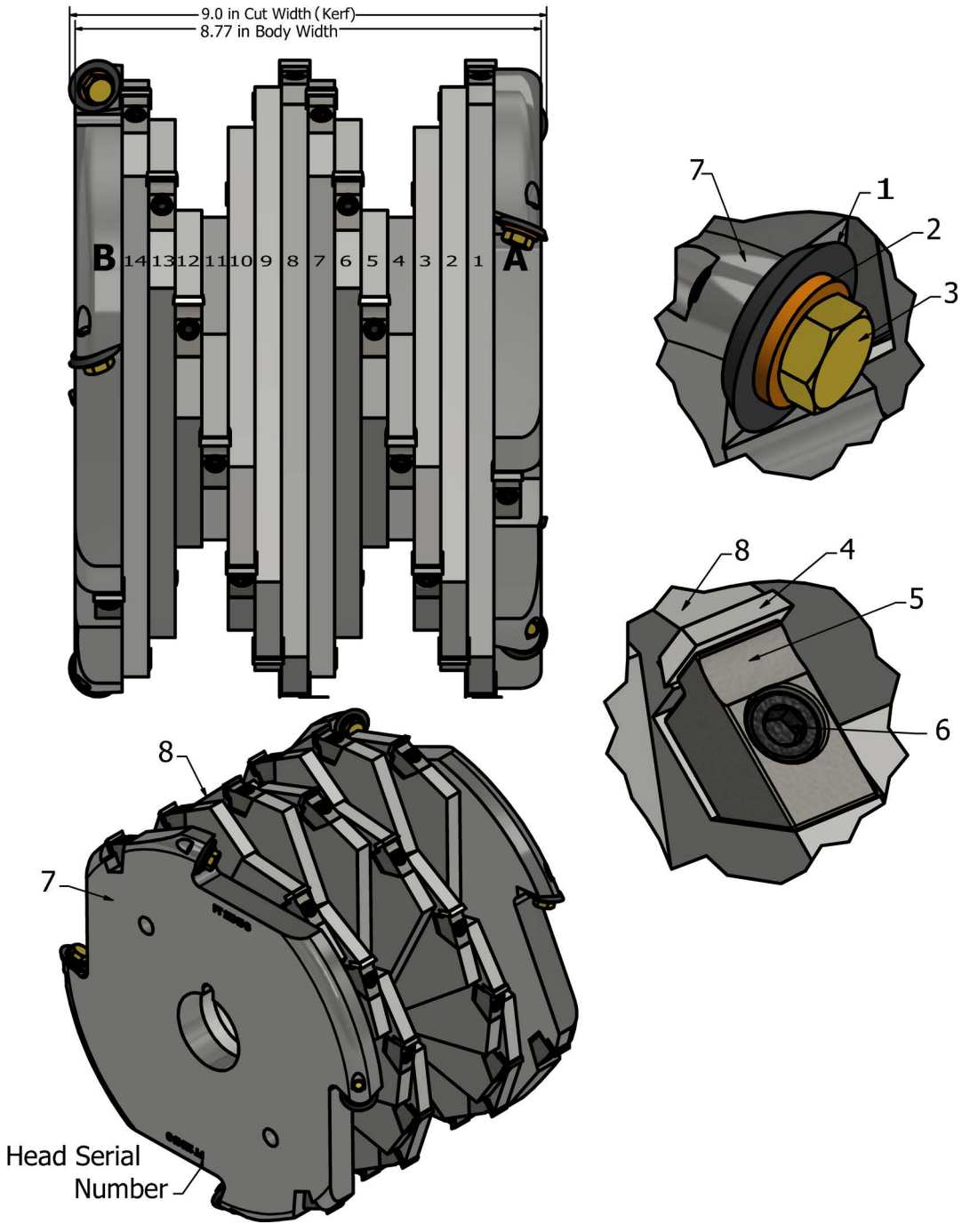


REF	PART #	DESCRIPTION	COMMENTS	QTY.
	123280	Assembly, Cylinder, 80mm		2
1	123254	Floating Joint, M20		1
2	123268	Bracket, Cylinder Mount, 80mm		2
3	123212	Cylinder, 80mm Bore, 370mm Stroke		1
4	123279	RCA		1
5	123232	Weldment, Drive Belt Cover		1
6	123283	Sheave, Motor		1
7	123255	Belt, 55		3

5.6 Cutter Head

(1) INH-NS - Indexable Notching Head

12" Diameter x 9" Kerf x 60 mm Bore x 10 mm Keyway x ½" Radius



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	PT 301	Round Carbide Insert - NW Grade - 1" Diameter		8
2	PT 310	Carbide Shield - Grade 8		8
3	PT 311	Hex Screw for Radius Insert		8
4	PT 501	Carbide Insert - NW Grade - 1/2" Tall - 2 Sided		32
5	PT 510	Wedge Block		32
6	PT 511	Wedge Screw - 1/4" (15 ft-lb torque)		32
7	PT 300	Indexable Radius Plate (A + B)		2
8	PT 500	Indexable Chipper Plate (1-14)		14

To order cutter head parts, have the head serial number available and contact:

PROFILE TECHNOLOGIES
(800) 369-4242 toll free
(314) 965-9111 main
(314) 966-5550 fax
info@profiletech.com
www.profiletech.com

INDEXABLE NOTCHING HEAD INSTRUCTIONS FOR INSTALLATION

When your head arrives it will come in (3) boxes. Each has a label in the upper left hand corner that tells you what parts are inside. The 9" head is composed of 16 Plates typically, 2 Radius Plates (PT 300) labeled A and B and (14) Chipper Plates (PT 500) labeled 1,2,3,4,5,6,7,8,9,10,11,12,13,14.

1. Turn off all power at machine and put electrical lock out on power box.

2. Check orientation of shaft and head rotation before installing plates to ensure proper installation.

3. Plates are typically installed B,14,13,12,11,10,9,8,7,6,5,4,3,2,1,A with the B plate being on the pulley side as viewed from the operator or in feed of the machine.

4. Slide spring washer against A radius plate, put on final locking nut.

5. Tighten locking nut with wrench to MFG designated torque on both sides of head.

6. Plates in head assembly should not have any movement and should be a solid assembly.

7. **IMPORTANT:** Check each of the (8) hex screws in the radius plates and make sure they are tight and did not loosen in transit. Hand tight plus 1/8-1/4 turn with wrench

8. **IMPORTANT:** Check each of the (32) socket head cap screws (Allen) in the wedge blocks to ensure they are at 15 FT-LB of torque before using head.

9. Upon running the notching head through your first maintenance cycle it is important to note how many bundles of stringers are notched before your tips become dull. Signs of wear include burning in the corners of the radius cut, excessive tear out, cut becomes LOUDER. All of these are signs it is time to flip your tips and reorder inserts so you have a backup set and are not down on production.

10. When calling to order new parts for your notching head please have the Head Serial Number (PT 12345-A) available. If you need plates please also write down the plate numbers needed (1-14) or A and B.