

**ELECTRICAL INFORMATION and
FLUID POWER SCHEMATIC**

HR250SEC25U

B1.00+


8180 W 10th St
Indianapolis, IN 46214

HR250SEC25U WMLLC A4 121319


Creator	MOC
Create Date	5/28/2024
Last Editor	SDC
Edit date	9/5/2024
Design Revision	A4
Project Type	Schematic project
Total Pages	28
Report Pages	11
Supply Type	120VAC/24VDC

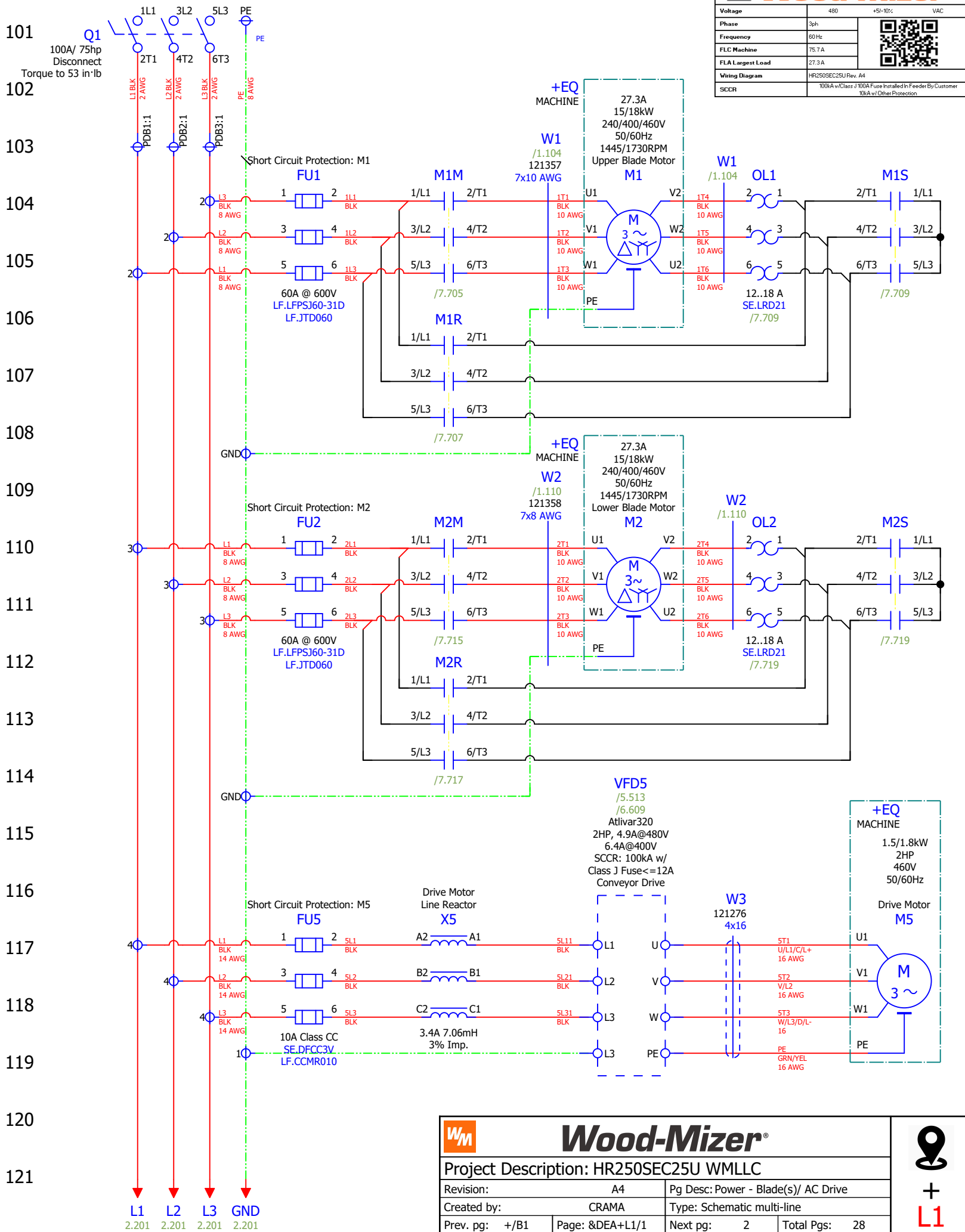
Revision History

Date	Revision	Revision Record	Drawn By	Checked By
12/03/19	0	Initial Design	MOC	AR
05/13/20	A	Revised for construction by NPMF	MOC	AR
01/11/23	A1	Added blade lube system. Interlocked feed drive to lower blade status.	MOC	-
05/10/23	A2	Updated page layout for consistency.	MOC	-
08/30/24	A4	Release to production.	MOC	SDC

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision: A4		Pg Desc: Revision History	
Mounting Location: &DEA/B1		Type: Overview	
Prev. pg: A1	Page: B1	Next pg: +L1/1	Total Pgs: 28

Wood-Mizer

Voltage	480	+5/-10%	VAC
Phase	3ph		
Frequency	60 Hz		
FLC Machine	75.7 A		
FLA Largest Load	27.3 A		
Wiring Diagram	HR250SEC25U Rev. A4		
SCCR	100kA w/Class J 100A Fuse Installed In Feeder By Customer 10kA w/ Other Protection		

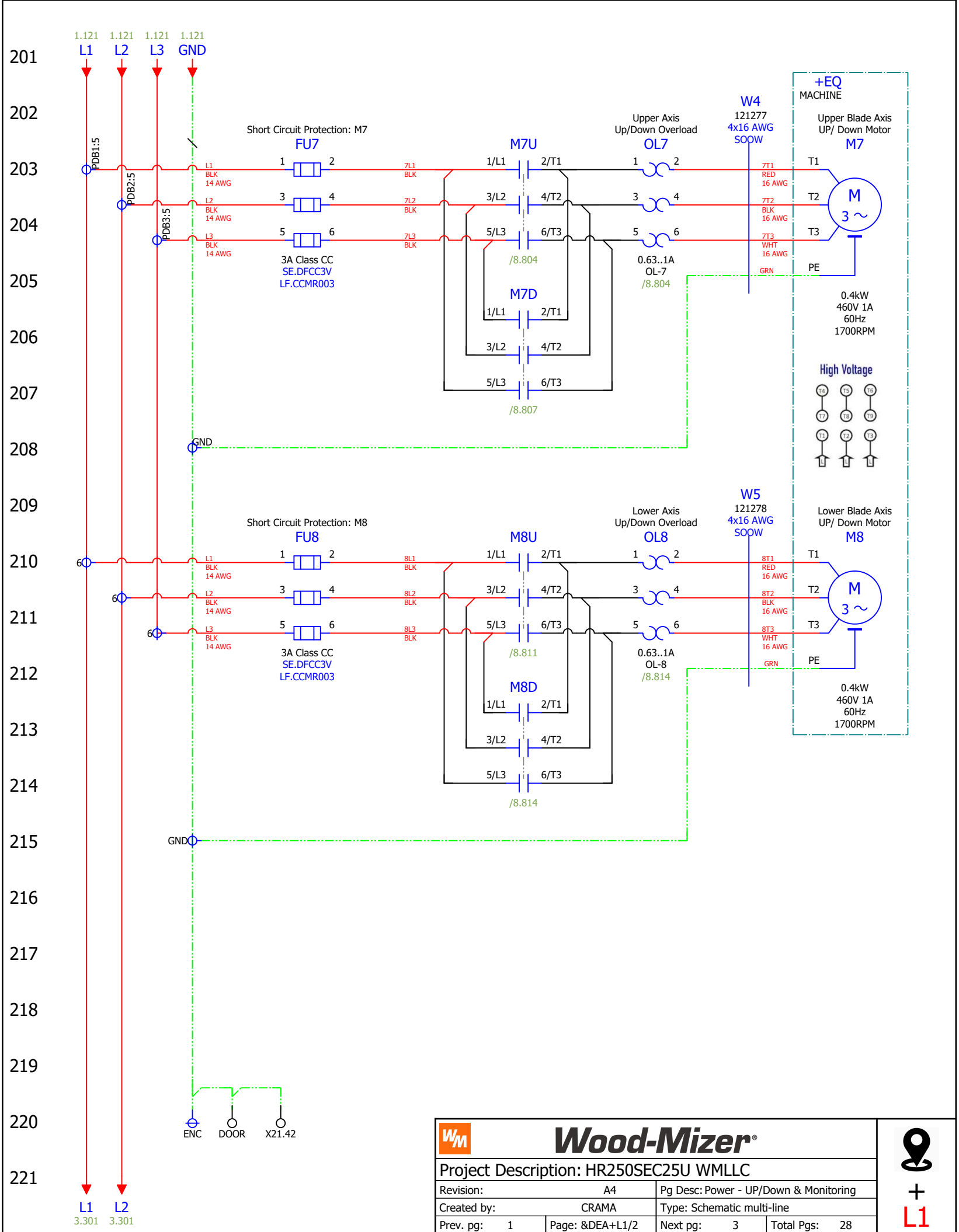


Wood-Mizer

Project Description: HR250SEC25U WMLLC

Revision:	A4	Pg Desc:	Power - Blade(s)/ AC Drive
Created by:	CRAMA	Type:	Schematic multi-line
Prev. pg:	+/B1	Page:	&DEA+L1/1
Next pg:	2	Total Pgs:	28

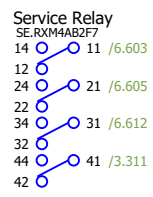
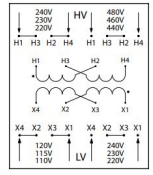
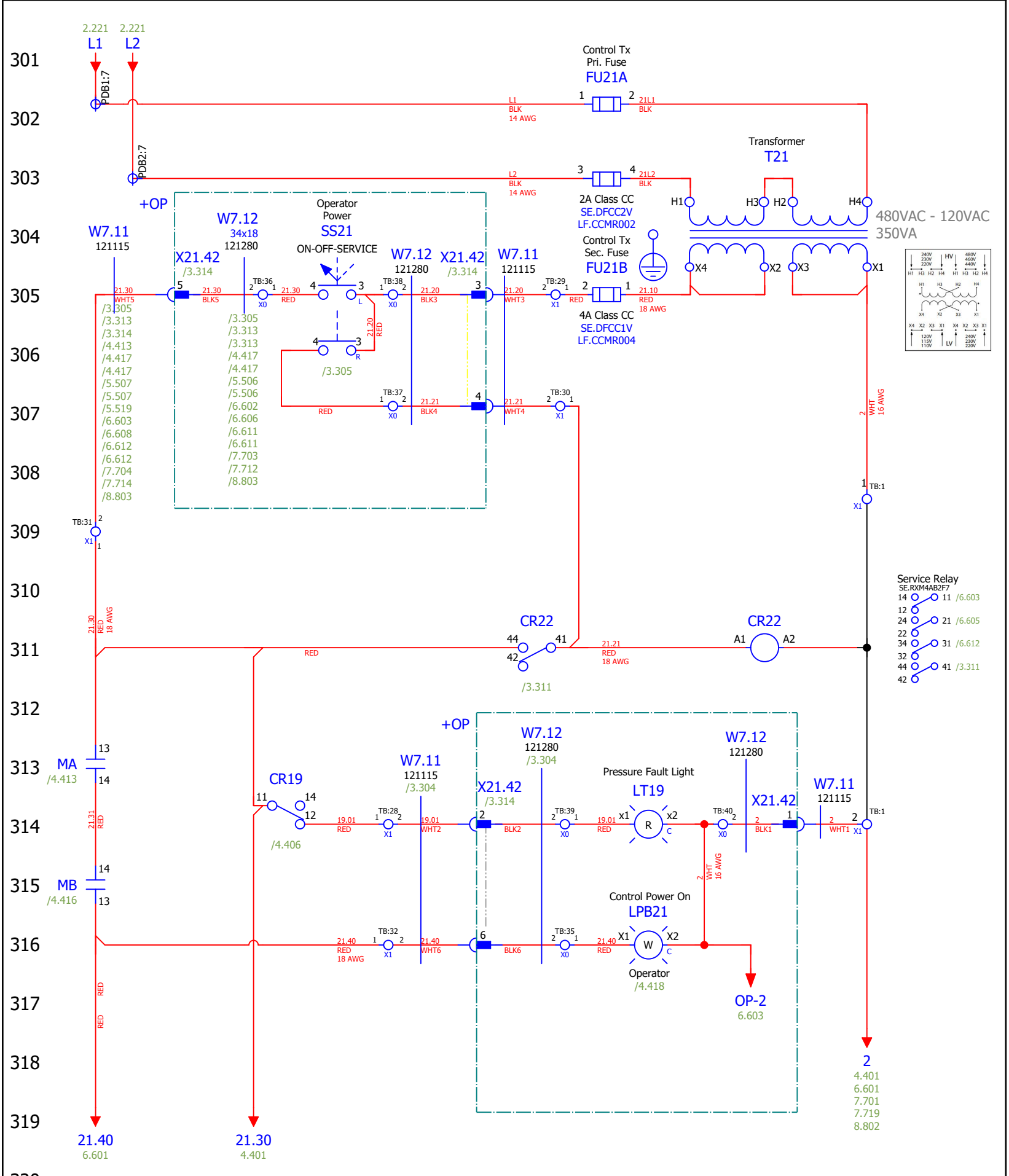
L1

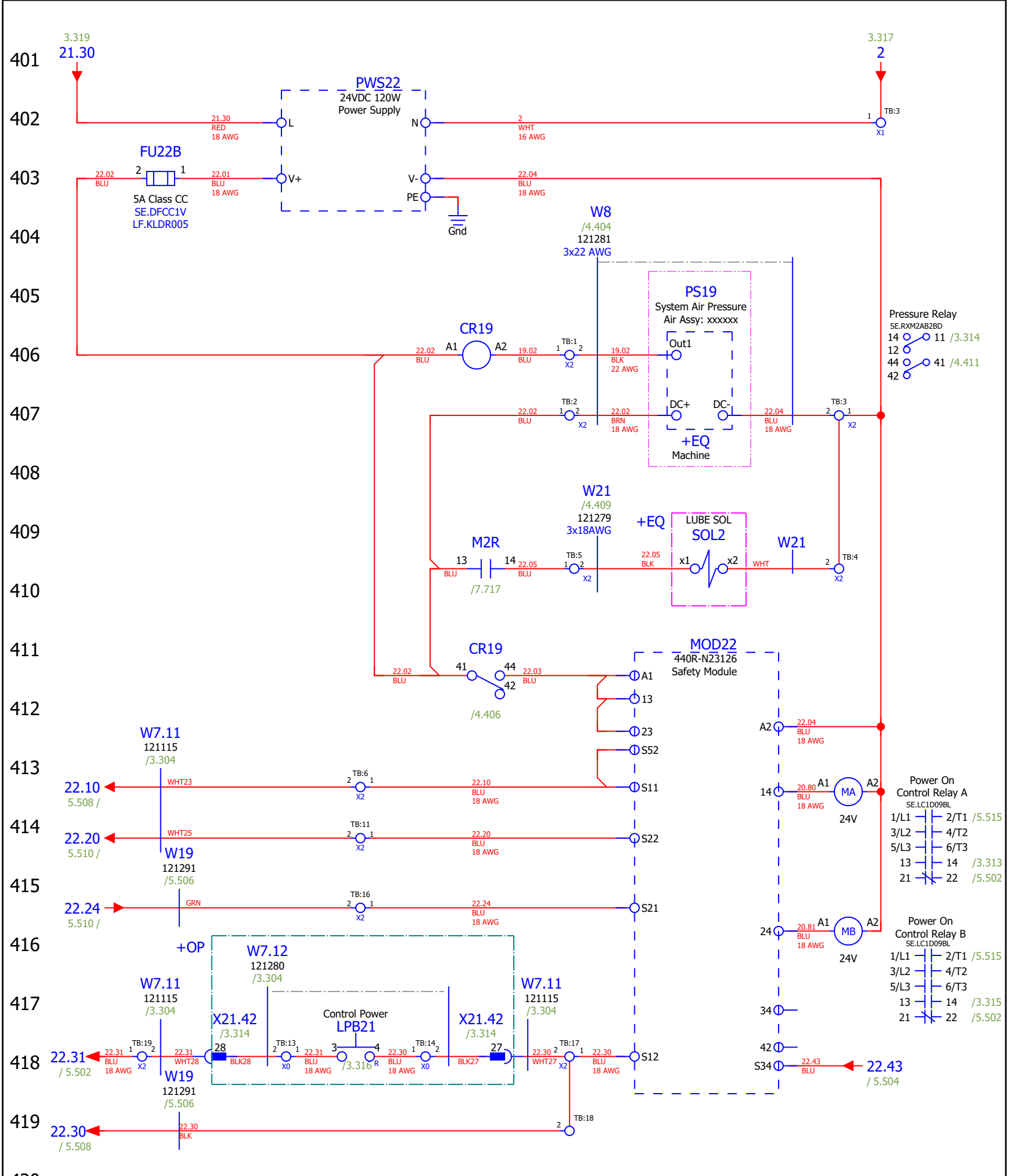


Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Power - UP/Down & Monitoring	
Created by:	CRAMA	Type: Schematic multi-line	
Prev. pg:	1	Page: &DEA+L1/2	Next pg: 3
		Total Pgs:	28

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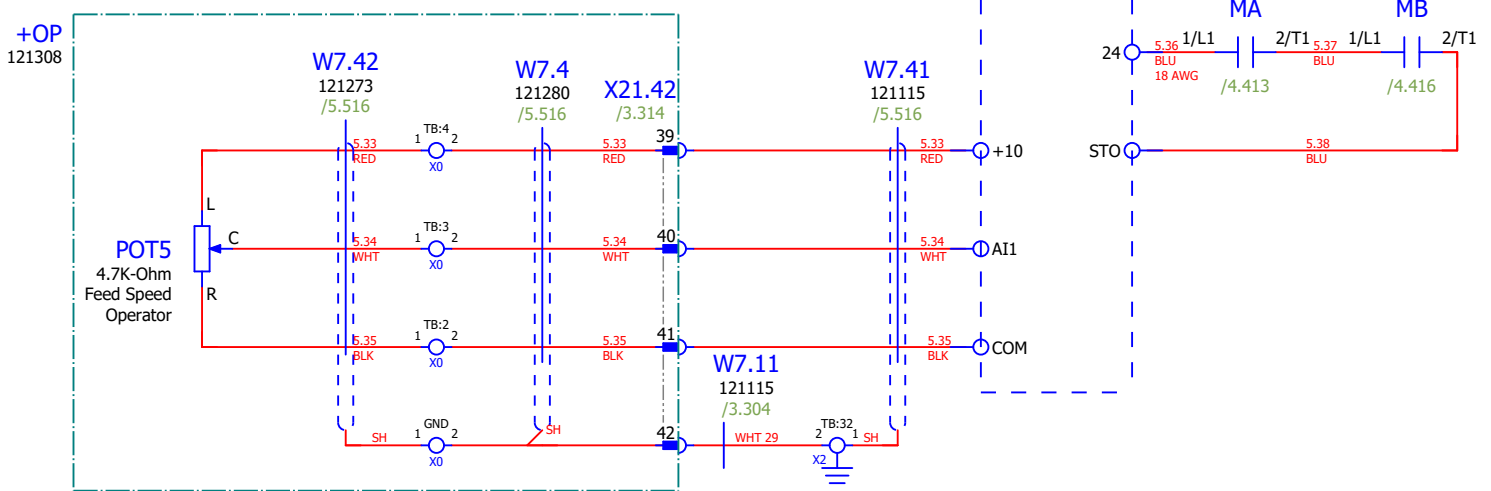
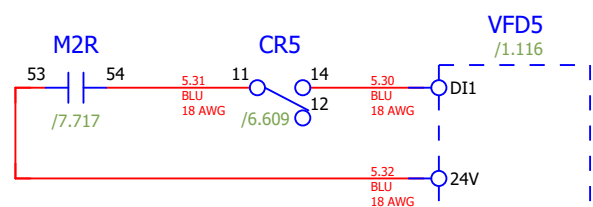
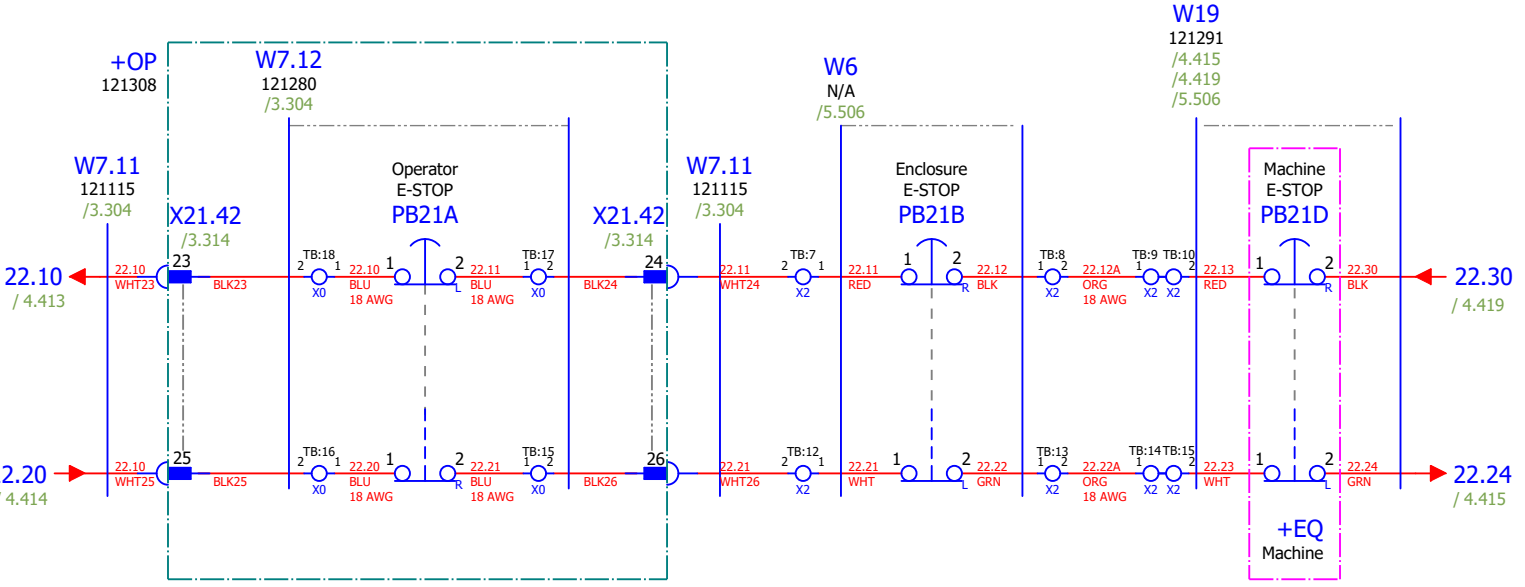
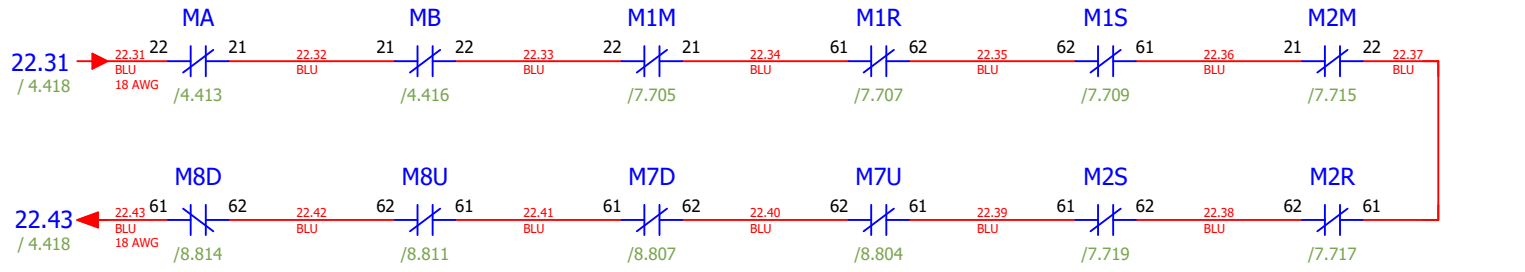
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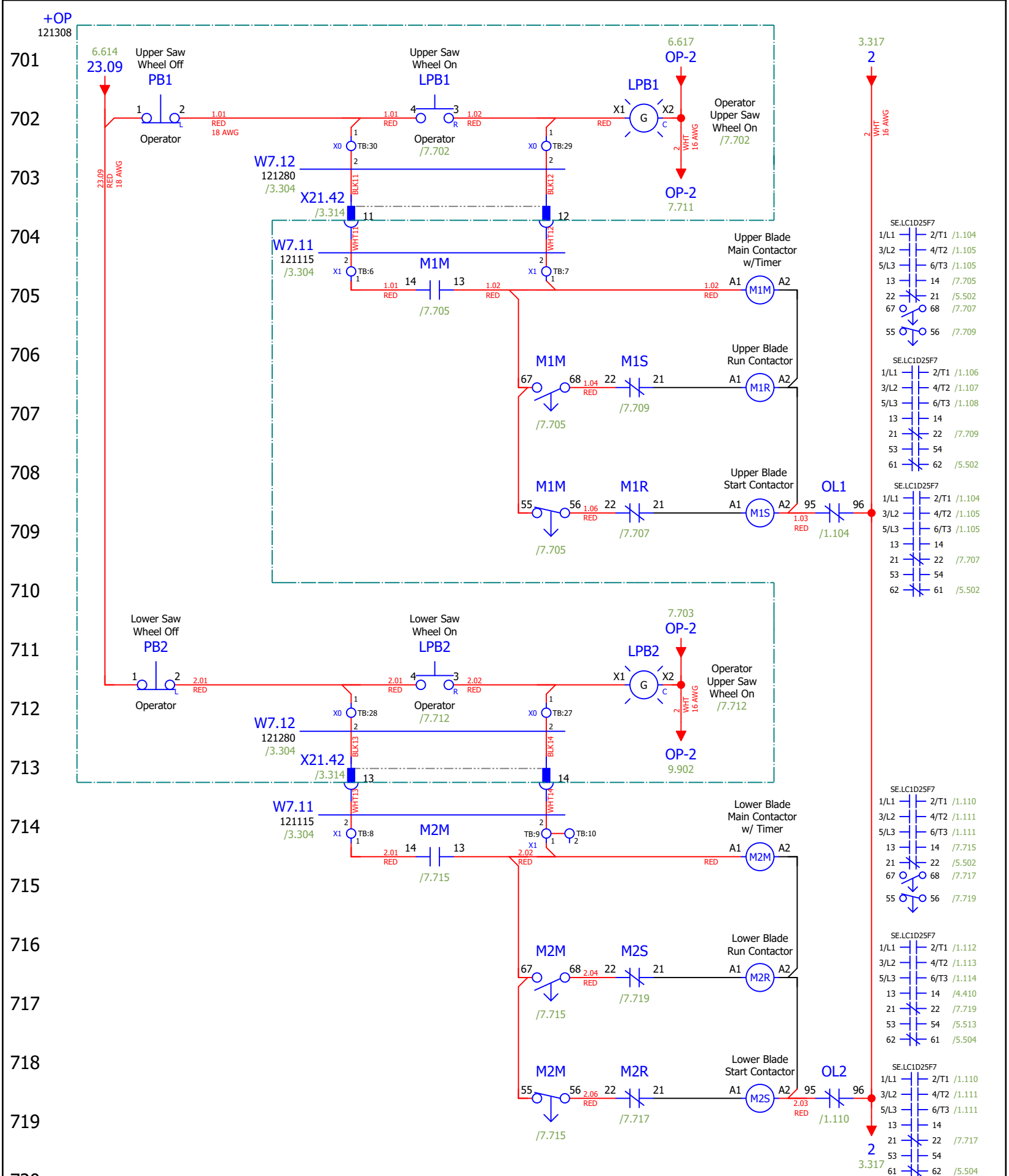
Project Description: HR250SEC25U WMLLC		
Revision: A4	Pg Desc: DC Controls - Safety	
Created by: CRAMA	Type: Schematic multi-line	
Prev. pg: 3	Page: &DEA+L1/4	
Next pg: 5	Total Pgs: 28	

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		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc:	DC Controls - E-Stop/Belt Speed
Created by:	CRAMA	Type:	Schematic multi-line
Prev. pg:	4	Page:	&DEA+L1/5
Next pg:	6	Total Pgs:	28







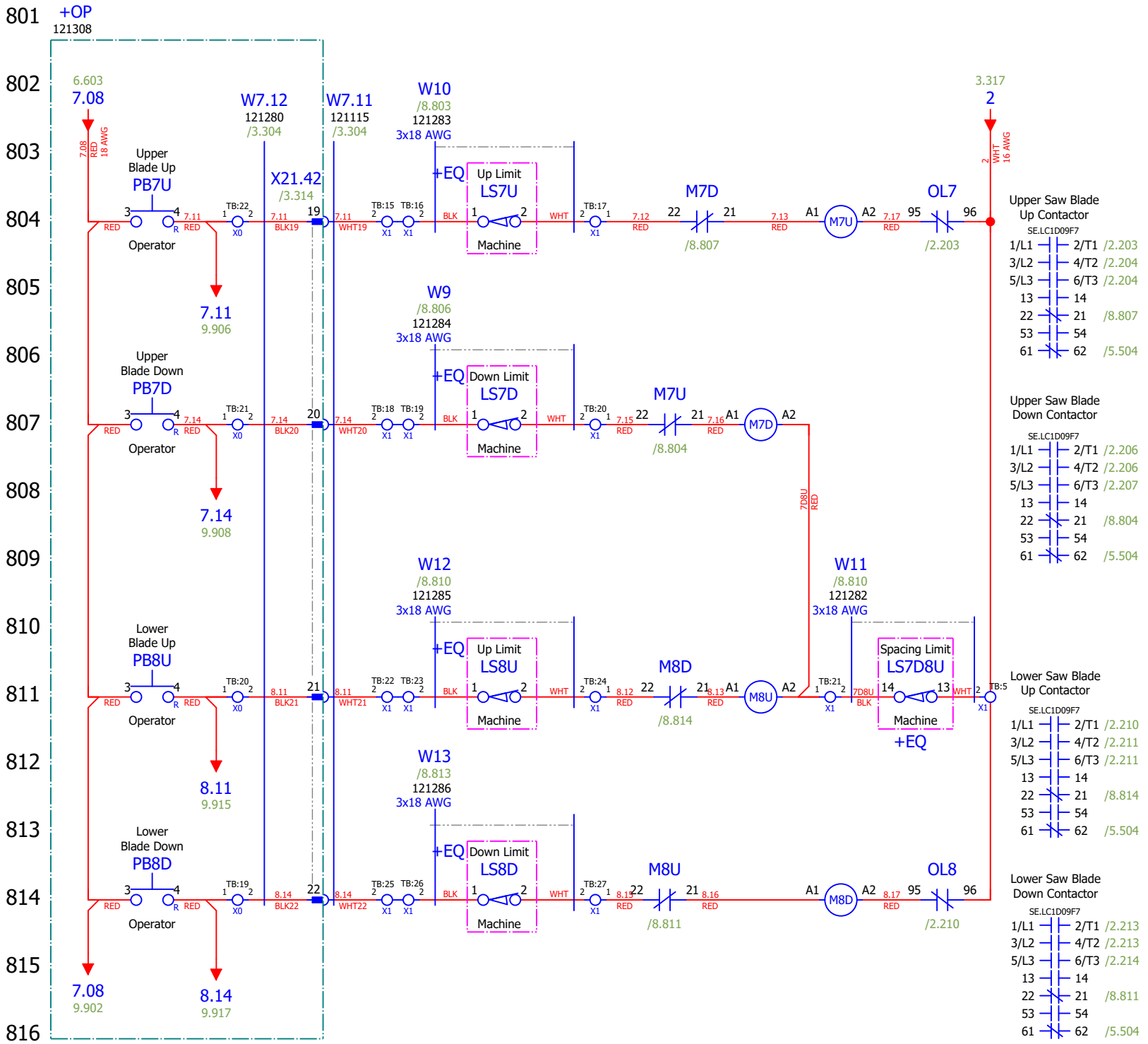
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Project Description: HR250SEC25U WMLLC



Revision: A4	Pg Desc: AC Controls - Blade(s) On/Off
Created by: CRAMA	Type: Schematic multi-line
Prev. pg: 6	Page: &DEA+L1/7
Next pg: 8	Total Pgs: 28

L1



Upper Saw Blade Up Contactor
SE.LC1D09F7

1/L1	2/T1	/2.203
3/L2	4/T2	/2.204
5/L3	6/T3	/2.204
13	14	
22	21	/8.807
53	54	
61	62	/5.504

Upper Saw Blade Down Contactor
SE.LC1D09F7

1/L1	2/T1	/2.206
3/L2	4/T2	/2.206
5/L3	6/T3	/2.207
13	14	
22	21	/8.804
53	54	
61	62	/5.504

Lower Saw Blade Up Contactor
SE.LC1D09F7

1/L1	2/T1	/2.210
3/L2	4/T2	/2.211
5/L3	6/T3	/2.211
13	14	
22	21	/8.814
53	54	
61	62	/5.504

Lower Saw Blade Down Contactor
SE.LC1D09F7

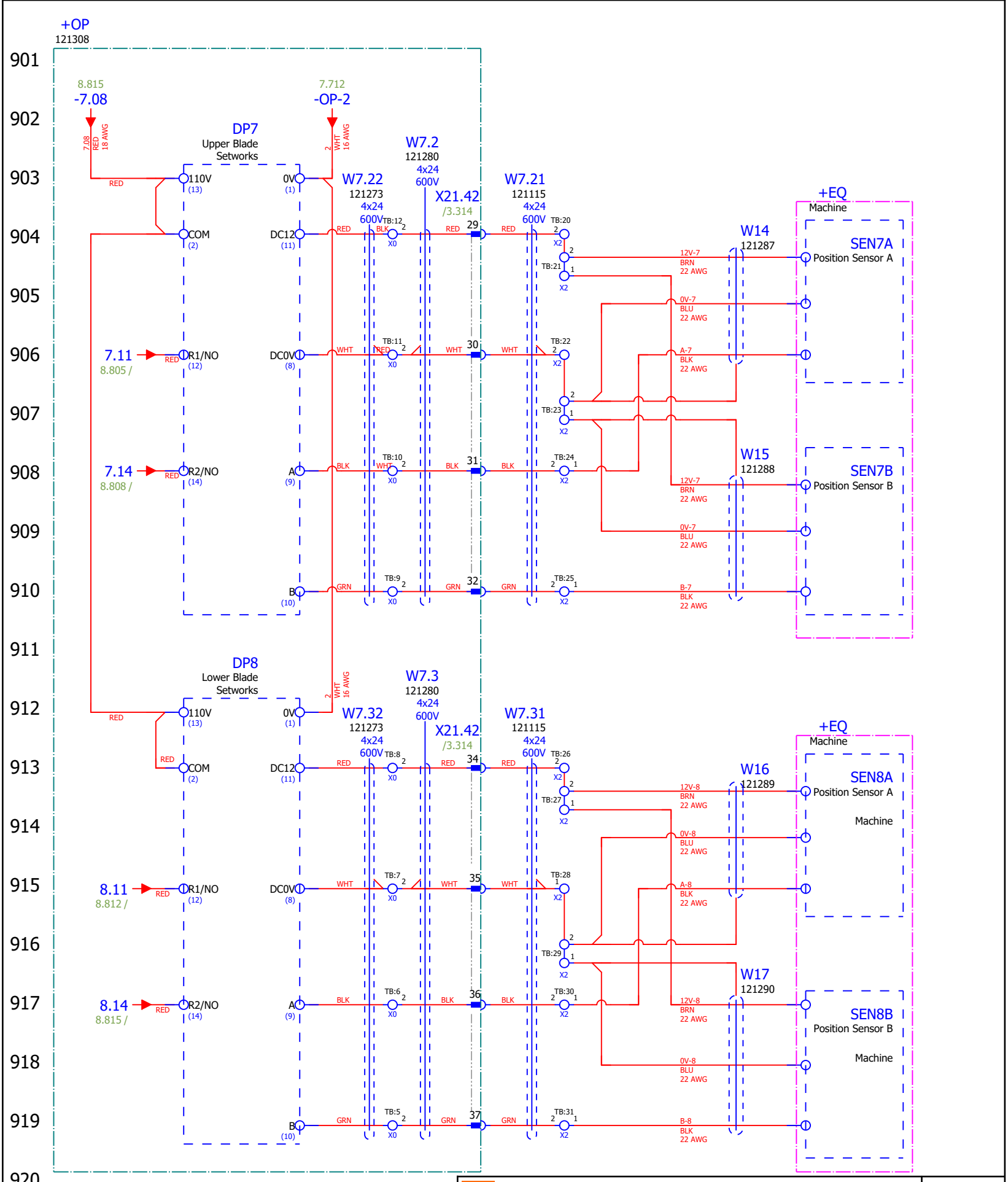
1/L1	2/T1	/2.213
3/L2	4/T2	/2.213
5/L3	6/T3	/2.214
13	14	
22	21	/8.811
53	54	
61	62	/5.504

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Project Description: HR250SEC25U WMLLC

Revision:	A4	Pg Desc: Control - Blade(s) Up/Down
Created by:	CRAMA	Type: Schematic multi-line
Prev. pg:	7	Page: &DEA+L1/8
	Next pg:	9
	Total Pgs:	28





Wood-Mizer
 Project Description: HR250SEC25U WMLLC

Revision:	A4	Pg Desc: Control - Blade Sensor(s)
Created by:	CRAMA	Type: Schematic multi-line
Prev. pg: 8	Page: &DEA+L1/9	Next pg: 10
		Total Pgs: 28

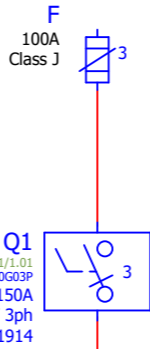
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 L1

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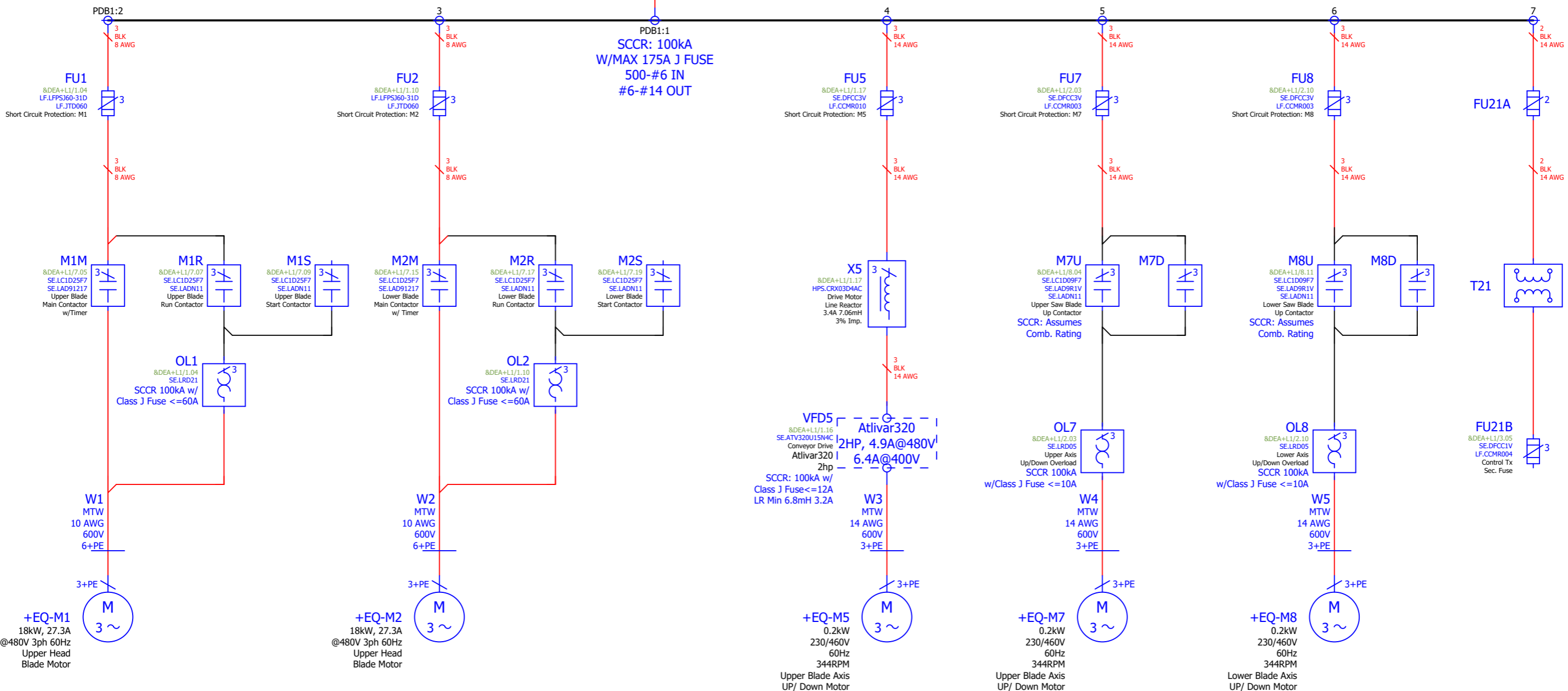
B
C
D
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Wood-Mizer	
Voltage	480 +/-10% VAC
Phase	3ph
Frequency	60Hz
FLC Machine	75.7 A
FLA Largest Load	27.3 A
Wiring Diagram	HR250SEC25U Rev. A2
SCCR	100kA w/Class J 100A Fuse Installed In Feeder By Customer 100A w/ Other Protection

SYSTEM SCCR: 100ka 480V 3ph
FEEDER SCCR: 100ka 480V 3ph
LOWEST BRANCH SCCR: 100ka 480V 3ph



PDB1:1
SCCR: 100ka
W/MAX 175A J FUSE
500-#6 IN
#6-#14 OUT



Branch 1
SCCR: 100ka
PER COMPONENT MARKING

Branch 2
SCCR: 100ka
PER COMPONENT MARKING

Branch 3
SCCR: 100ka
PER COMPONENT MARKING

Branch 4
SCCR: 100ka
PER COMPONENT MARKING

Branch 5
SCCR: 100ka
PER COMPONENT MARKING


Branch 6
SCCR: 200ka
PER FUSE RATING

Wood-Mizer	
Project Description: HR250SEC25U WMLLC	
Revision: A4	Pg Desc: POWER SLD/SCCR
Mounting Location: +L1	Type: Schematic single-line
Prev. pg: 9	Page: &DEA+L1/10
Next pg: +DOC/C1	Total Pgs: 28

Wood-Mizer Parts List

WM_PARTS_LIST-WM_MntLoc


Device Tag	LOC	Function	Manufacturer	Wood-Mizer Part Number	Description	Qty.	X-Ref
CR5	L1	Conveyor On Control Relay	Schneider Electric	061418	Relay, Plug-In RXM 2CO 120VAC 12A	1	+L1/6.609
CR5	L1	=	Schneider Electric	068320	Relay Socket, 2CO Din-Mount	1	+L1/6.609
CR19	L1	Pressure Relay	Schneider Electric	068319	Relay, Plug-In RXM 2CO 24VDC 12A	1	+L1/4.406
CR19	L1	=	Schneider Electric	068320	Relay Socket, 2CO Din-Mount	1	+L1/4.406
CR22	L1	Service Relay	Schneider Electric	116711	Relay, Plug-In RXM 4CO 120VAC 12A	1	+L1/3.311
CR22	L1	=	Schneider Electric	121126	Relay Socket, 4CO Din-Mount	1	+L1/3.311
CR23	L1	Saw Blade Tension Relay	Schneider Electric	061418	Relay, Plug-In RXM 2CO 120VAC 12A	1	+L1/6.612
CR23	L1	=	Schneider Electric	068320	Relay Socket, 2CO Din-Mount	1	+L1/6.612
FU1	L1	Short Circuit Protection: M1	Littlefuse	052457	Fuse Blk, 3P Class J 60A Indicating DIN	1	+L1/1.104
FU1	L1	=	Littelfuse	052733	Fuse, 60A 600V Class J	3	+L1/1.104
FU2	L1	Short Circuit Protection: M2	Littlefuse	052457	Fuse Blk, 3P Class J 60A Indicating DIN	1	+L1/1.110
FU2	L1	=	Littelfuse	052733	Fuse, 60A 600V Class J	3	+L1/1.110
FU5	L1	Short Circuit Protection: M5	Schneider Electric	052380	Fuse Holder, 3P Class CC Screw Clamp	1	+L1/1.117
FU5	L1	=	Littelfuse	051957	Fuse, 10A 600V Class CC Delay	3	+L1/1.117
FU7	L1	Short Circuit Protection: M7	Schneider Electric	052380	Fuse Holder, 3P Class CC Screw Clamp	1	+L1/2.203
FU7	L1	=	Littelfuse	052793	Class CC Fuse 3 A	3	+L1/2.203
FU8	L1	Short Circuit Protection: M8	Schneider Electric	052380	Fuse Holder, 3P Class CC Screw Clamp	1	+L1/2.210
FU8	L1	=	Littelfuse	052793	Class CC Fuse 3 A	3	+L1/2.210
FU21A	L1	Control Tx Pri. Fuse	Schneider Electric	052512	Fuse Holder, 2P Class CC Screw Clamp	1	+L1/3.302
FU21A	L1	=	Littelfuse	E22716	Fuse, 2A 600V Class CC	1	+L1/3.302
FU21B	L1	Control Tx Sec. Fuse	Schneider Electric	052731	Fuse Holder, 1P Class CC Screw Clamp	1	+L1/3.305
FU21B	L1	=	Littelfuse	052713	Fuse, 4A 600V Calss CC Delay	1	+L1/3.305
FU22B	L1		Schneider Electric	052731	Fuse Holder, 1P Class CC Screw Clamp	1	+L1/4.403
FU22B	L1		Littelfuse	052511	Fuse, 5A KLDR	1	+L1/4.403
M1M	L1	Upper Blade Main Contactor w/Timer	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.705
M1M	L1	=	Schneider Electric	078372	Contactor, Wye-Delta Assy Kit D09-D38	1	+L1/7.705
M1R	L1	Upper Blade Run Contactor	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.707
M1R	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/7.707
M1S	L1	Upper Blade Start Contactor	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.709
M1S	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/7.709
M2M	L1	Lower Blade Main Contactor w/ Timer	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.715
M2M	L1	=	Schneider Electric	078372	Contactor, Wye-Delta Assy Kit D09-D38	1	+L1/7.715
M2R	L1	Lower Blade Run Contactor	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.717
M2R	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/7.717
M2S	L1	Lower Blade Start Contactor	SE	E23404	Contactor, 25A 3P 120VAC Coil	1	+L1/7.719
M2S	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/7.719
M7D	L1	Upper Saw Blade Down Contactor	Schneider Electric	E23403	Contactor, 9A 3P 120VAC Coil	1	+L1/8.807
M7D	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/8.807
M7U	L1	Upper Saw Blade Up Contactor	Schneider Electric	E23403	Contactor, 9A 3P 120VAC Coil	1	+L1/8.804
M7U	L1	=	Schneider Electric	068091	Reversing Kit, Contactor w/ Interlock	1	+L1/8.804
M7U	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/8.804
M8D	L1	Lower Saw Blade Down Contactor	Schneider Electric	E23403	Contactor, 9A 3P 120VAC Coil	1	+L1/8.814
M8D	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/8.814
M8U	L1	Lower Saw Blade Up Contactor	Schneider Electric	E23403	Contactor, 9A 3P 120VAC Coil	1	+L1/8.811
M8U	L1	=	Schneider Electric	068091	Reversing Kit, Contactor w/ Interlock	1	+L1/8.811
M8U	L1	=	Schneider Electric	116741	Contact, 1NC & 1NO Auxiliary	1	+L1/8.811
MA	L1	Power On Control Relay A	Schneider Electric	024890	Contactor, 9A 3P 24VDC Coil	1	+L1/4.413
MB	L1	Power On Control Relay B	Schneider Electric	024890	Contactor, 9A 3P 24VDC Coil	1	+L1/4.416
MOD22	L1	Safety Module	Allen Bradley	116684	Safety Module	1	+L1/4.411
OL1	L1		Schneider Electric	053524	Overload, 12-18A Thermal	1	+L1/1.104
OL2	L1		Schneider Electric	053524	Overload, 12-18A Thermal	1	+L1/1.110
OL7	L1	Upper Axis Up/Down Overload	Schneider Electric	116680	Overload, 0.63-1A Class 10 Single Ph Sens	1	+L1/2.203
OL8	L1	Lower Axis Up/Down Overload	Schneider Electric	116680	Overload, 0.63-1A Class 10 Single Ph Sens	1	+L1/2.210
PB21B	L1	Enclosure E-STOP	Schneider Electric	068940	Pushbutton Head, 22mm E-Stop Twist-Pull	1	+L1/5.508
PB21B	L1	=	Schneider Electric	068950	Collar, Mount 1NC ZB5	1	+L1/5.508
PB21B	L1	=	Schneider Electric	068921	Contact Block, NC ZB5	1	+L1/5.508
PB21B	L1	=	Schneider Electric	050992	Legend, E-Stop, Round Yellow	1	+L1/5.508
PDB1	L1	AC Mains Distribution	Cooper Bussmann	069801	Distribution Block, 1P 1in 6out 380A DIN	1	+L1/1.103

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Parts List	
Mounting Location:	&DEA+DOC/C1	Type: Parts list	
Prev. pg:	+L1/10	Page:	C1
Next pg:	C2	Total Pgs:	28

Terminal line-up diagram

Terminal strip +OP-X0


Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB:40	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.14
TB:39	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.14
TB:38	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.05
TB:37	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.07
TB:36	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.05
TB:35	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/3.16
TB:34	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.16
TB:33	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.12
TB:32	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.12
TB:31	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.14
TB:30	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/7.02
TB:29	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/7.02
TB:28	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/7.12
TB:27	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/7.12
TB:26	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.05
TB:25	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.06
TB:24	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.06
TB:23	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/6.03
TB:22	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/8.04
TB:21	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/8.07
TB:20	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/8.11
TB:19	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/8.14
TB:18	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.08
TB:17	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.08
TB:16	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.10
TB:15	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.10
TB:14	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/4.18
TB:13	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/4.18
TB:12	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.04
TB:11	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.06
TB:10	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.08
TB:9	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.10
TB:8	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.13
TB:7	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.15
TB:6	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.17

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Terminal Lineup Diagram	
Mounting Location:	&DEA+DOC/D1	Type: Terminal line-up diagram	
Prev. pg:	C4	Page:	D1
		Next pg:	D2
		Total Pgs:	28

Terminal line-up diagram


Terminal strip +OP-X0

Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB:5	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/9.19
TB:4	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.16
TB:3	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.17
TB:2	0	068100	Terminal Block, 2Pos 1.5mm Clamp	•				&DEA+L1/5.18
GND	0	068101	Terminal Block, 2pos 1.5mm GND Clamp	•				&DEA+L1/5.19

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Terminal Lineup Diagram	
Mounting Location:	&DEA+DOC/D2	Type: Terminal line-up diagram	
Prev. pg:	D1	Page:	D2
Next pg:	D3	Total Pgs:	28


Terminal line-up diagram

Terminal strip +L1-X1								
Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB:1	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068115	068102		&DEA/3.08
TB:2	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/6.19
TB:3	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/4.02
TB:4	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/7
TB:5	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/8.11
TB:6	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/7.05
TB:7	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/7.05
TB:8	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/7.14
TB:9	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068115	068102		&DEA/7.14
TB:10	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/7.14
TB:11	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/6.05
TB:12	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/6.08
TB:13	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/6.08
TB:14	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/6.03
TB:15	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/8.04
TB:16	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/8.04
TB:17	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/8.04
TB:18	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113			&DEA/8.07
TB:19	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●		068102		&DEA/8.07
TB:20	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/8.07
TB:21	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/8.11
TB:22	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/8.11
TB:23	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/8.11
TB:24	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/8.11
TB:25	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/8.14
TB:26	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/8.14
TB:27	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/8.14
TB:28	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/3.14
TB:29	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/3.05
TB:30	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/3.07
TB:31	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/3.09
TB:32	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/3.16
TB:33	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●		068102		&DEA/6.16
TB:34	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113			&DEA/6.19
TB:35	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/6.12

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Terminal Lineup Diagram	
Mounting Location:	&DEA+DOC/D3	Type: Terminal line-up diagram	
Prev. pg:	D2	Page:	D3
		Next pg:	D4
		Total Pgs:	28

Terminal line-up diagram


Terminal strip +L1-X1								
Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB:36	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/6.13
TB:37	0	068100	Terminal Block, 2Pos 1.5mm Clamp	┆		068102		&DEA/6.12
TB:38	0	068100	Terminal Block, 2Pos 1.5mm Clamp	┆				&DEA/6.14

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Terminal Lineup Diagram	
Mounting Location:	&DEA+DOC/D4	Type: Terminal line-up diagram	
Prev. pg:	D3	Page:	D4
		Next pg:	D5
		Total Pgs:	28

Terminal line-up diagram

Terminal strip +L1-X2


Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB:1	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/4.06
TB:2	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/4.07
TB:3	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/4.07
TB:4	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/4.10
TB:5	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/4.10
TB:6	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/4.13
TB:7	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/5.08
TB:8	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/5.08
TB:9	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/5.08
TB:10	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/5.08
TB:11	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/4.14
TB:12	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/5.10
TB:13	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/5.10
TB:14	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/5.10
TB:15	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/5.10
TB:16	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/4.15
TB:17	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/4.18
TB:18	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/4.19
TB:19	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/4.18
TB:20	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/9.04
TB:21	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/9.04
TB:22	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/9.06
TB:23	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/9.07
TB:24	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/9.08
TB:25	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/9.10
TB:26	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/9.13
TB:27	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/9.13
TB:28	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●	068113	068102		&DEA/9.15
TB:29	0	068100	Terminal Block, 2Pos 1.5mm Clamp	●				&DEA/9.16
TB:30	0	068100	Terminal Block, 2Pos 1.5mm Clamp			068102		&DEA/9.17
TB:31	0	068100	Terminal Block, 2Pos 1.5mm Clamp					&DEA/9.19
TB:32	0	068101	Terminal Block, 2pos 1.5mm GND Clamp					&DEA/5.19

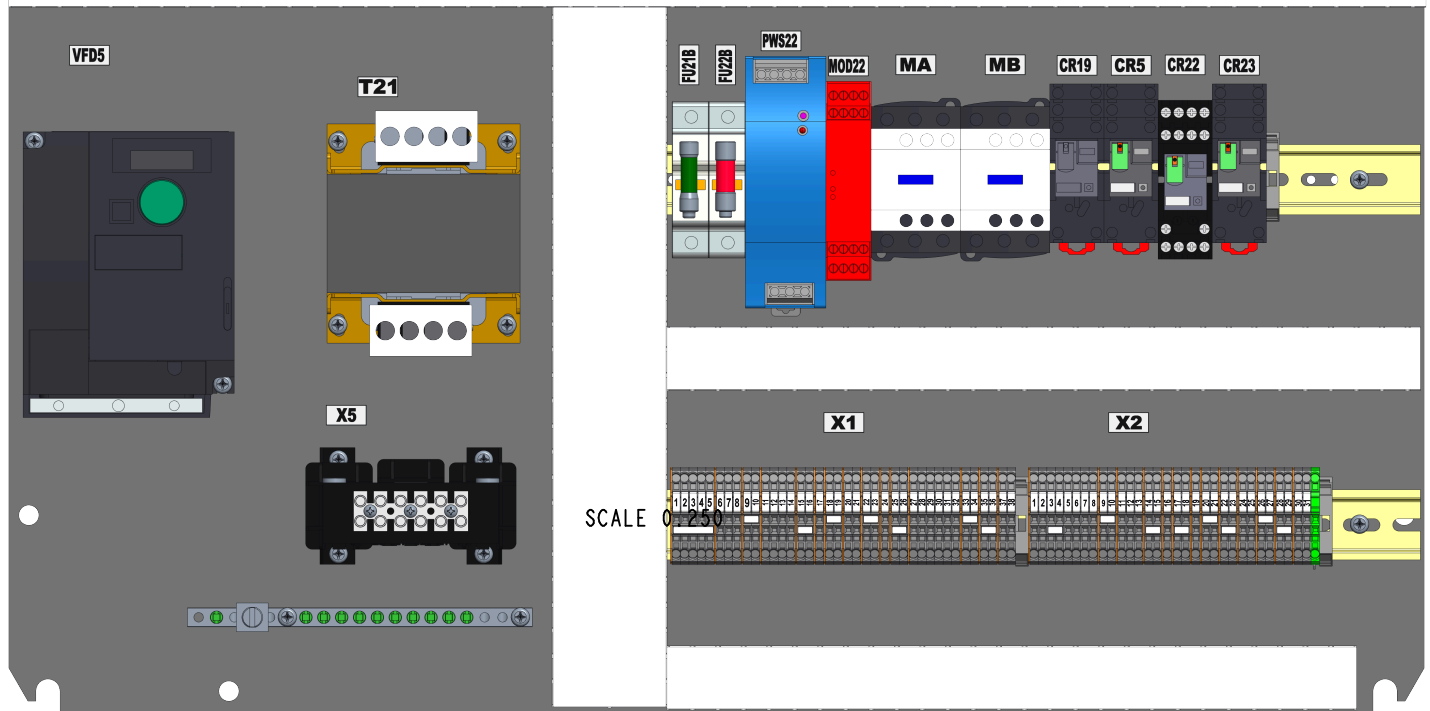
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Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Terminal Lineup Diagram	
Mounting Location:	&DEA+DOC/D5	Type: Terminal line-up diagram	
Prev. pg:	D4	Page:	D5
		Next pg:	E1
		Total Pgs:	28

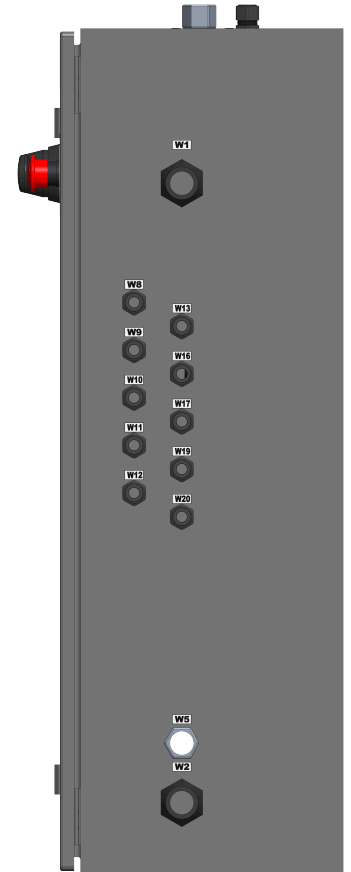
VFD Parameters		
ATV320U154NC		
Parameter	Description	Value
TCC	2 / 3 wire control	2 Wire
CFG	Macro config selection	Start/Stop
BFR	Std. motor frequency	60Hz NEMA
IPL	Stop type - I/P phase loss	Freewheel
NPR	Rated motor power	2hp
UNS	Nominal motor voltage	480
NCR	Nominal motor current	3.3A
FRS	Nominal motor frequency	60Hz
NSP	Nominal motor speed	1680
TFR	Max. output frequency	80
STUN	Tune selection	Default
ITH	Motor thermal current	3.3A
ACC	Acceleration ramp time	3.5s
DEC	Deceleration ramp time	2.5s
LSP	Low speed	0Hz
HSP	High Speed	60Hz
VFD PN	VFD WM Part Number	052093-2


Cable Overview

Cable Designation	Cable Part Number	Cable Description	Cable X-Ref
W1	121357	Cable Assy, HR250SEC Upper Blade Power	+L1/1.104
W2	121358	Cable Assy, HR SEC Lower Blade Power Cable	+L1/1.110
W3	121276	Cable Assy, HR150/250 Belt Motor Power Cable	+L1/1.117
W4	121277	Cable Assy, HR250S Upper Axis Up/Down Motor	+L1/2.203
W5	121278	Cable Assy, HR250S Lower Axis Up/Down Motor	+L1/2.210
W6	N/A	Cable Assy, HR250S Enclosure E-Stop	+L1/5.506
W7.2	121280	Cable Assy, HR250S Operator Control	+L1/9.903
W7.3	121280	Cable Assy, HR250S Operator Control	+L1/9.912
W7.4	121280	Cable Assy, HR250S Operator Control	+L1/5.516
W7.11	121115	Cable Assy, HR250S Operator Bulkhead	+L1/3.304
W7.12	121280	Cable Assy, HR250S Operator Control	+L1/3.304
W7.21	121115	Cable Assy, HR250S Operator Bulkhead	+L1/9.904
W7.22	121273	Cable Assy, HR250S Operator Control	+L1/9.904
W7.31	121115	Cable Assy, HR250S Operator Bulkhead	+L1/9.913
W7.32	121273	Cable Assy, HR250S Operator Control	+L1/9.913
W7.41	121115	Cable Assy, HR250S Operator Bulkhead	+L1/5.516
W7.42	121273	Cable Assy, HR250S Operator Control	+L1/5.516
W8	121281	Cable Assy, HR250S Pressure Switch	+L1/4.404
W9	121284	Cable Assy, HR250S Upper Blade Down LS	+L1/8.806
W10	121283	Cable Assy, HR250S Upper Blade Up LS	+L1/8.803
W11	121282	Cable Assy, HR250S Head Spacing Switch	+L1/8.810
W12	121285	Cable Assy, HR250S Lower Blade Up LS	+L1/8.810
W13	121286	Cable Assy, HR250 Lower Blade Down LS	+L1/8.813
W14	121287	Cable Assy, HR250S Upper Blade Sensor A	+L1/9.904
W15	121288	Cable Assy, HR250S Upper Blade Sensor B	+L1/9.908
W16	121289	Cable Assy, HR250S Lower Blade Sensor A	+L1/9.913
W17	121290	Cable Assy, HR250S Lower Blade Sensor B	+L1/9.917
W19	121291	Cable Assy, HR250S Outfeed E-Stop	+L1/5.506
W20	121292	Cable Assy, HR250 Tension Solenoid	+L1/6.619
W21	121279	Cable Assy, HR250 Lubricating Solenoid	+L1/4.409

		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Cable Overview	
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Prev. pg:	E1	Page:	E2
		Next pg:	G1
		Total Pgs:	28





		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision: A4		Pg Desc: ENC Layout	
Mounting Location: &DEA+DOC/G2		Type: Panel layout	
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Wood-Mizer

Wrench and lightning bolt icon
I O II
SS21
Lightning bolt icon
LPB21

Curved arrow icon
POT5

DP7

Red button: PB1
White button: PB7U
Green button: LPB1
Black button: PB7D
CH-525 display with grid of buttons

O I
LSS23
LT19
Lightning bolt icon
LPB5


Red button: PB5
White button: POT5
Green button: LPB5

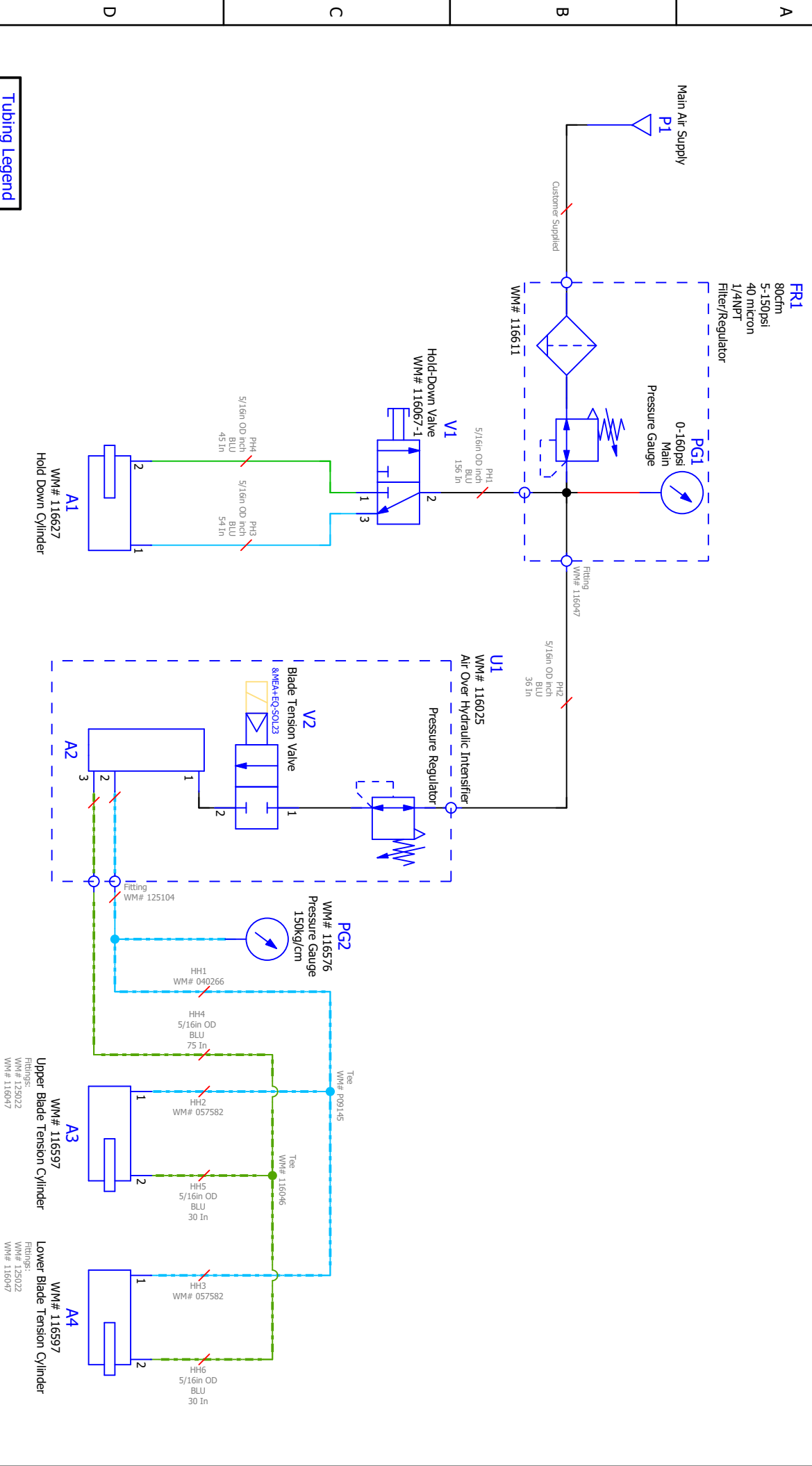
DP8

Red button: PB2
White button: PB8U
Green button: LPB2
Black button: PB8D
CH-525 display with grid of buttons

Revision History

Date	Revision	Revision Record	Drawn By	Checked By
08/29/24	A4	Release to production	SDC	MAM

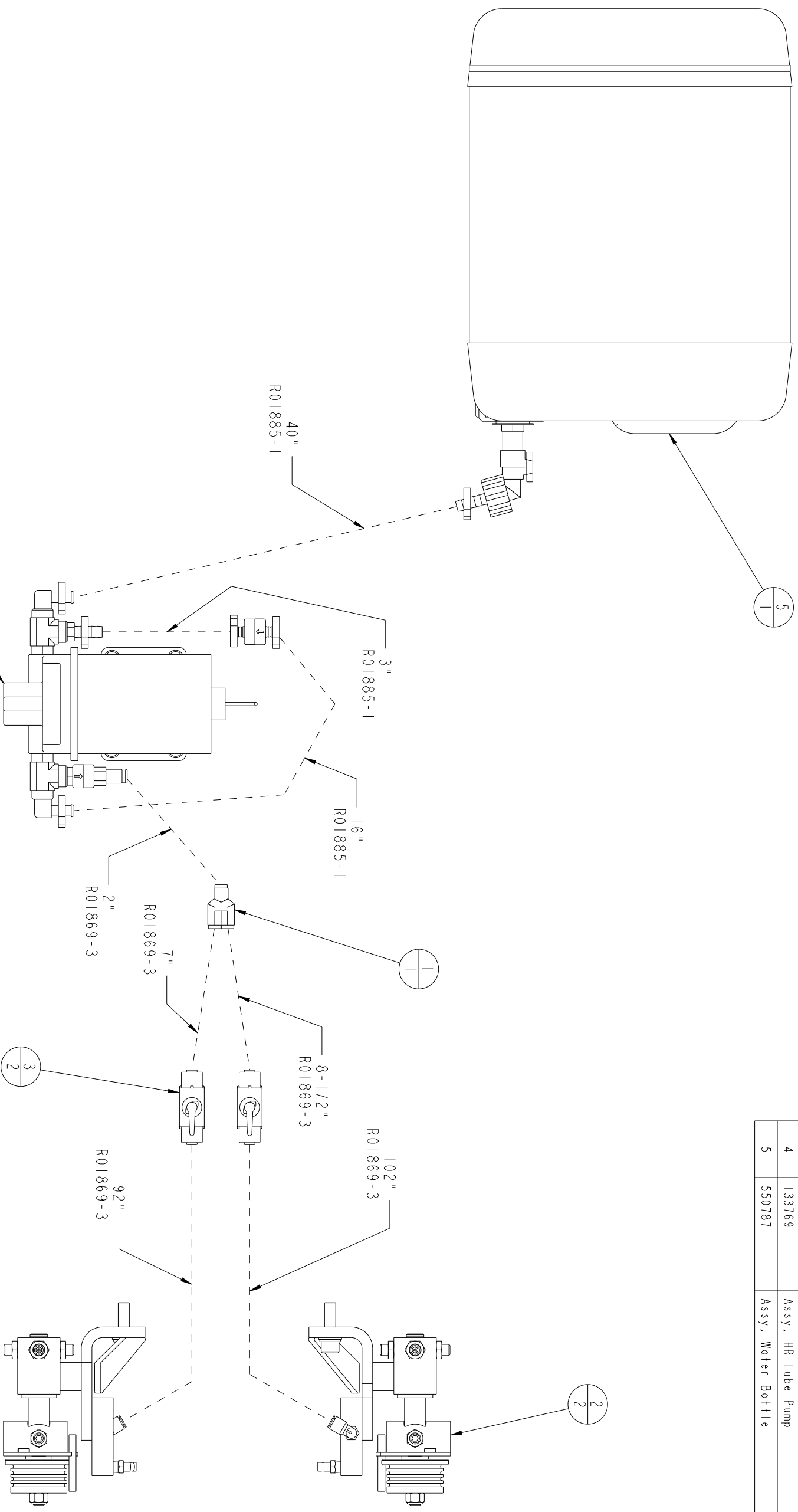
		Wood-Mizer®	
Project Description: HR250SEC25U WMLLC			
Revision:	A4	Pg Desc: Revision History	
Mounting Location:	&DPHA/B1	Type: Overview	
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Tubing Legend

PH:	Pneumatic Pressure
PH:	Actuator Pressure
PH:	Actuator Return
HH:	Hydraulic Pressure
HH:	Actuator Pressure
HH:	Actuator Return

ITEM	PART NUMBER	DESCRIPTION	QTY
1	042546	Union, 1/4" Tubing Y Push-In	1
2	130435	Assy, IS Blade Guide	2
3	133760	Valve, 1/4" PVC Manual Ball	2
4	133769	Assy, HR Lube Pump	1
5	550787	Assy, Water Bottle	1



TOLERANCES UNLESS NOTED

Wood-Mizer Products, Inc.

8180 W. 10th, Indianapolis, In 46214-2400 (317) 271-1542
 8829 East State Rd. 46, Greensburg, In 47240-7449 (812) 663-5257

xxx ±.005	SHEET	SCALE	DATE	DESIGNED	DRAWN	CHECKED
.xx ±.010	1 of 1	0.250	9/13/2024	RTL	RTL	---
HOLES ±.010						
FRACT ±.000						
ANGLE ± 1/2°						
GRIND #6						

DESCRIPTION: **Assy, HR250 Lube**

NUMBER: **LUBE_SYS**

REVISION: **1**