

**Safety, Operation, Maintenance &
Parts Manual**

Incline Conveyor

rev. A1.03

Safety is our #1 concern!

Form #2021

Models Effected:

CB6-3.2, Belt Conveyor, Incline For WM4000/WM4500



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

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SECTION 1 SAFETY

1.1 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.

1.2 Safety Instructions

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



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



OBSERVE SAFETY INSTRUCTIONS



IMPORTANT! Read the entire Operator's Manual before operating the conveyor. 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 conveyor. The conveyor 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, operation of your Wood-Mizer products. All Wood-Mizer product owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.



KEEP CONVEYOR AND AREA AROUND CONVEYOR CLEAN




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

CAUTIONS FOR CONVEYOR SETUP


WARNING! Securely fasten the feet of an incline conveyor to the floor before operating the machine. Failure to do so may result in serious injury or death.

CHECK CONVEYOR BEFORE OPERATION

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




KEEP PERSONS AWAY

 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating conveyor. Failure to do so may result in serious injury or death.

SECTION 2 SETUP & OPERATION

2.1 Installation and Setup

The Incline Conveyor allows you to quickly transport boards away from your Wood-Mizer sawmill. The following manual will guide you in installation, operation, and maintenance of the Incline Conveyor.

 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating conveyor. Failure to do so may result in serious injury or death.

See Figure 2-1. The major components of the Incline Conveyor are identified below.

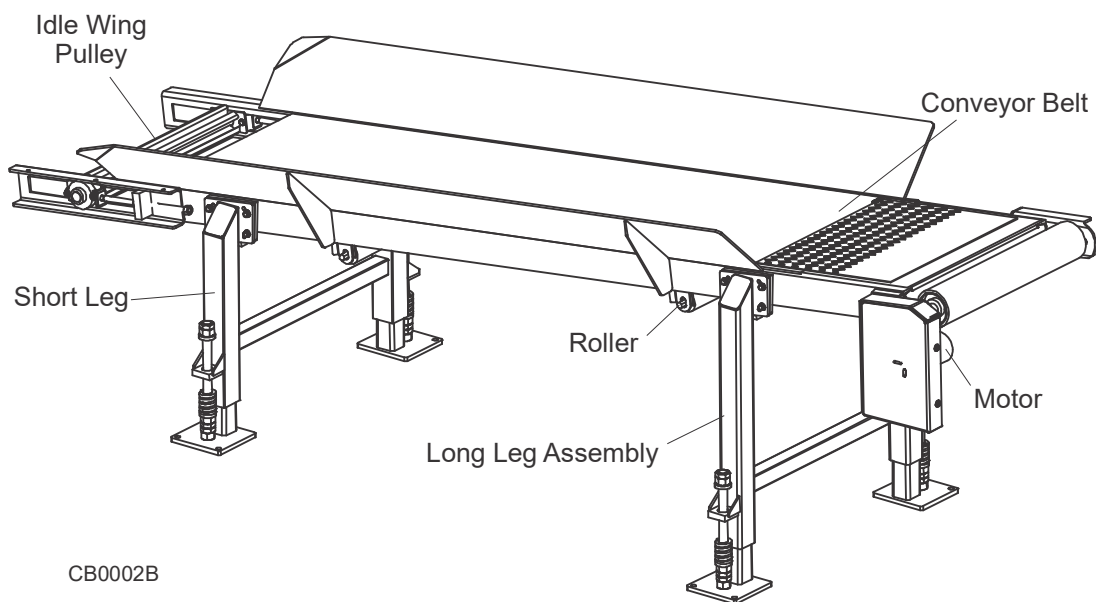


FIG. 2-0

2.1.1 Specifications

See **Figure 2-2**. The specifications of the Incline Conveyor are shown below.

Model: CB6-3.2 Rev. A1.00+

Dimensions:		Metric
	Length: 11'-5 3/4"	3496mm
	Width: 3'-6 1/4"	1076mm
	Width (Belt Only): 2'-2"	660mm
	Height (Lower End): 23" min. - 29" max.	584mm - 736mm
	Height (Upper End): 39" min. - 45" max.	991mm - 1143mm
Weight:	Basic Unit: lbs.	kg
Drive Motor:	Hydraulic (Powered and Controlled from Sawmill)	

FIG. 2-1 INCLINE CONVEYOR

2 Setup & Operation

Dimensions

2.1.2 Dimensions

See Figure 2-3. The overall dimensions of the Incline Conveyor are shown below.

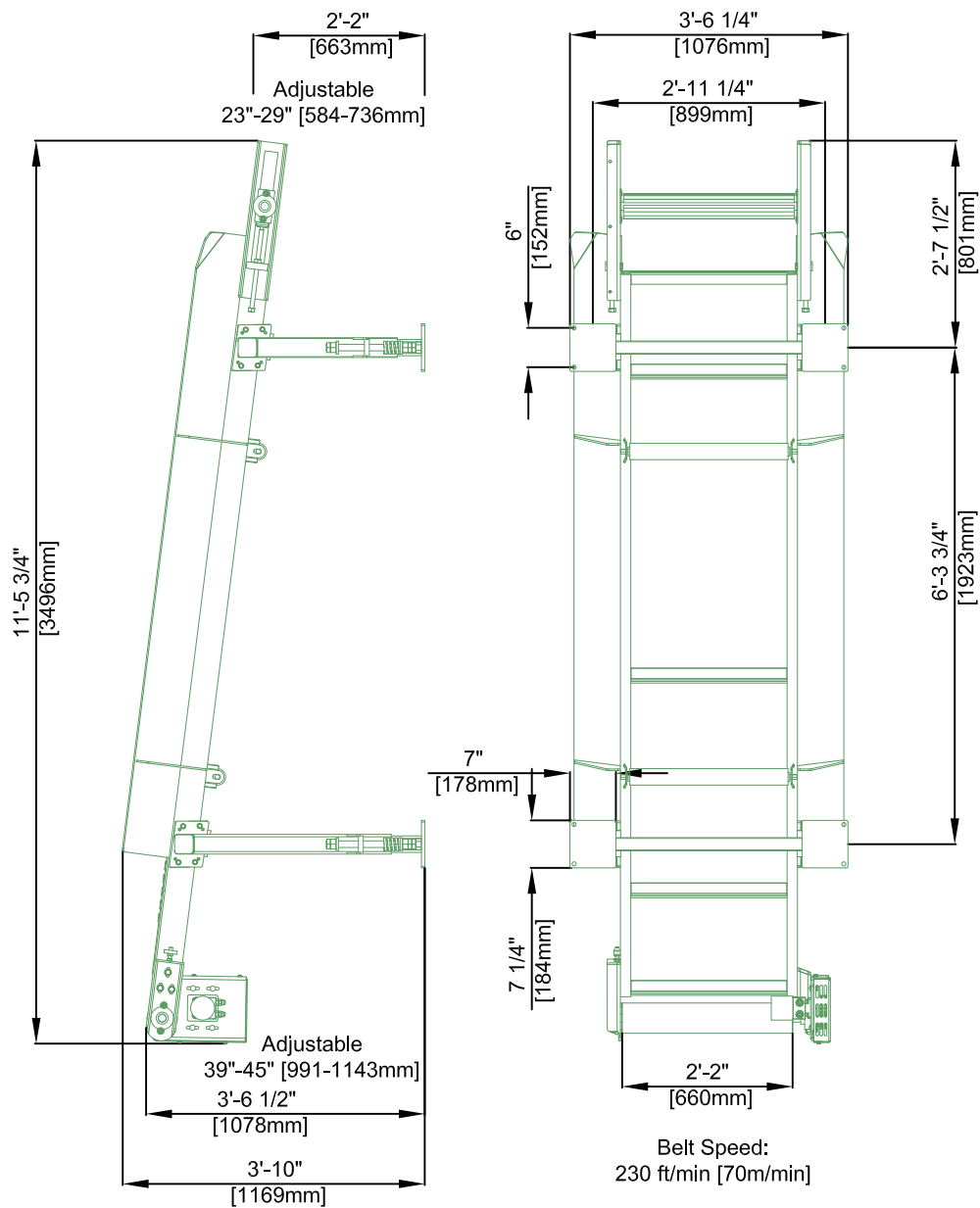



FIG. 2-2 INCLINE CONVEYOR

2.1.3 Installation

Prepare a firm, level area where the conveyor can be anchored next to the Wood-Mizer sawmill. A cement pad with 1/2" diameter anchor bolts is recommended.

 **WARNING!** Securely fasten the feet of the incline conveyor to the floor before operating the machine. Failure to do so may result in serious injury or death.

Position the Incline Conveyor at the end of the sawmill where boards are returned. Slide the conveyor toward the sawmill bed to position the conveyor fence as close to the roller bearing mount as possible. Make sure the conveyor is parallel to the sawmill frame.

See Figure 2-4.

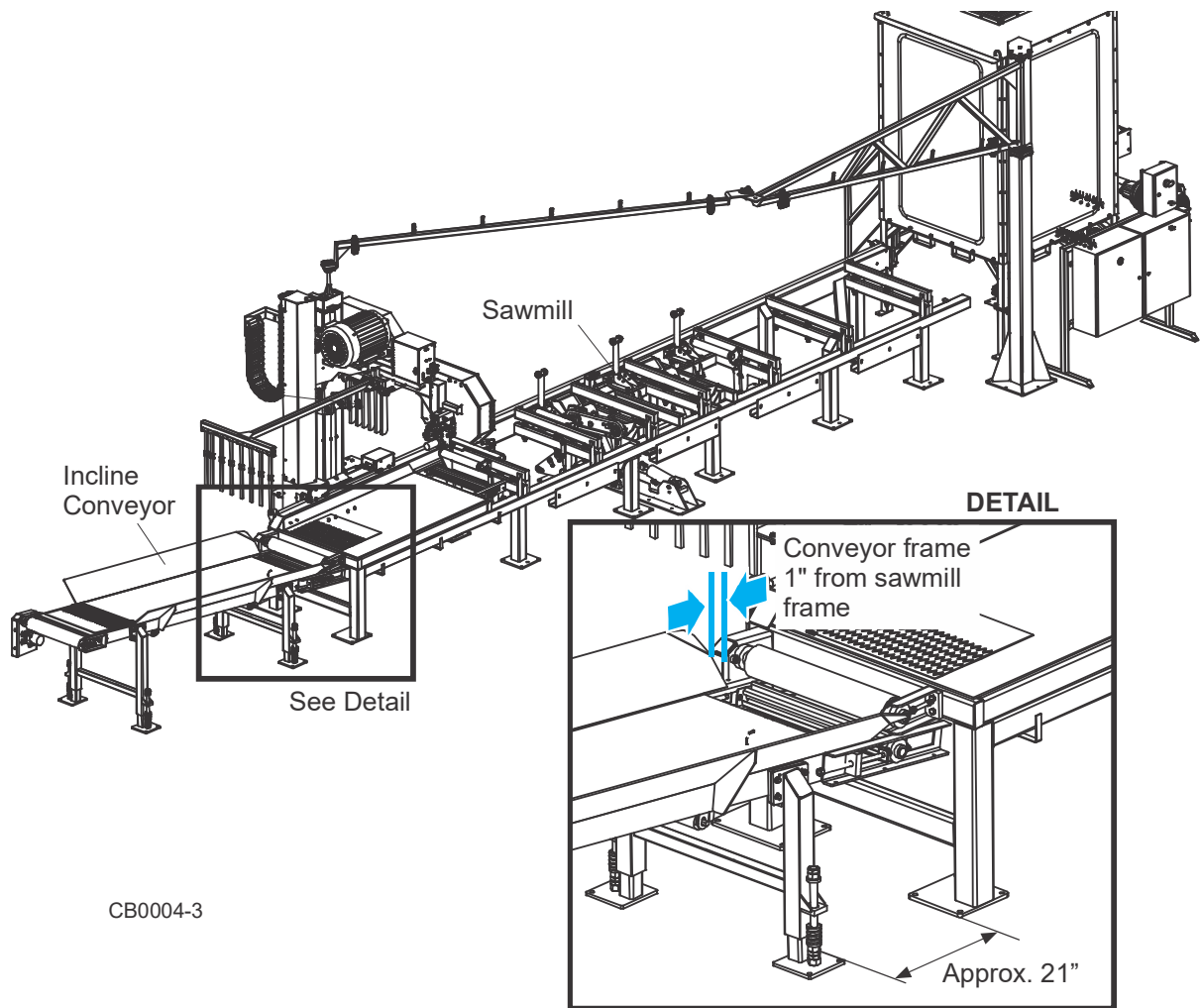


FIG. 2-3

2

Setup & Operation

Installation

After the incline conveyor is positioned, adjust the legs so the high end of the conveyor is at the desired height.

Loosen the jam nuts and adjustment nuts on each leg. Adjust the legs to the desired height and tighten the top adjustment nut to compress the spring 1/16" to 1/8". Make sure the feet firmly contact the ground. Anchor the conveyor to the floor with 1/2" anchor bolts and nuts.

See Figure 2-5.

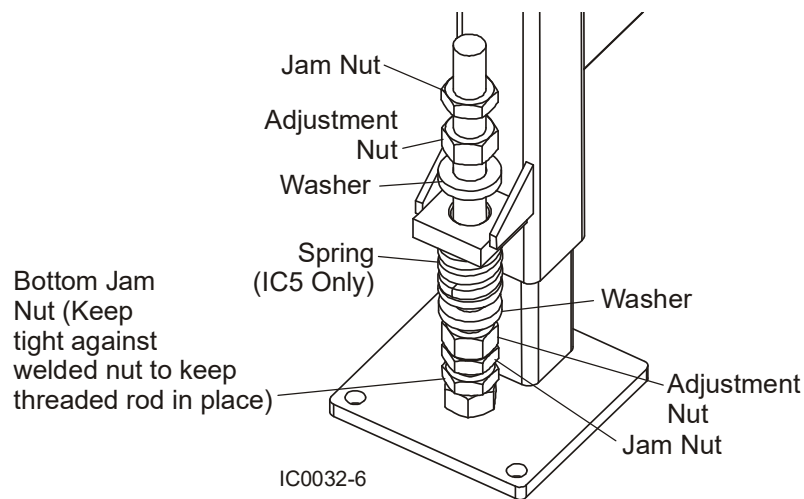


FIG. 2-3

Connect the existing and provided hydraulic hoses as shown below.

See Figure 2-6.

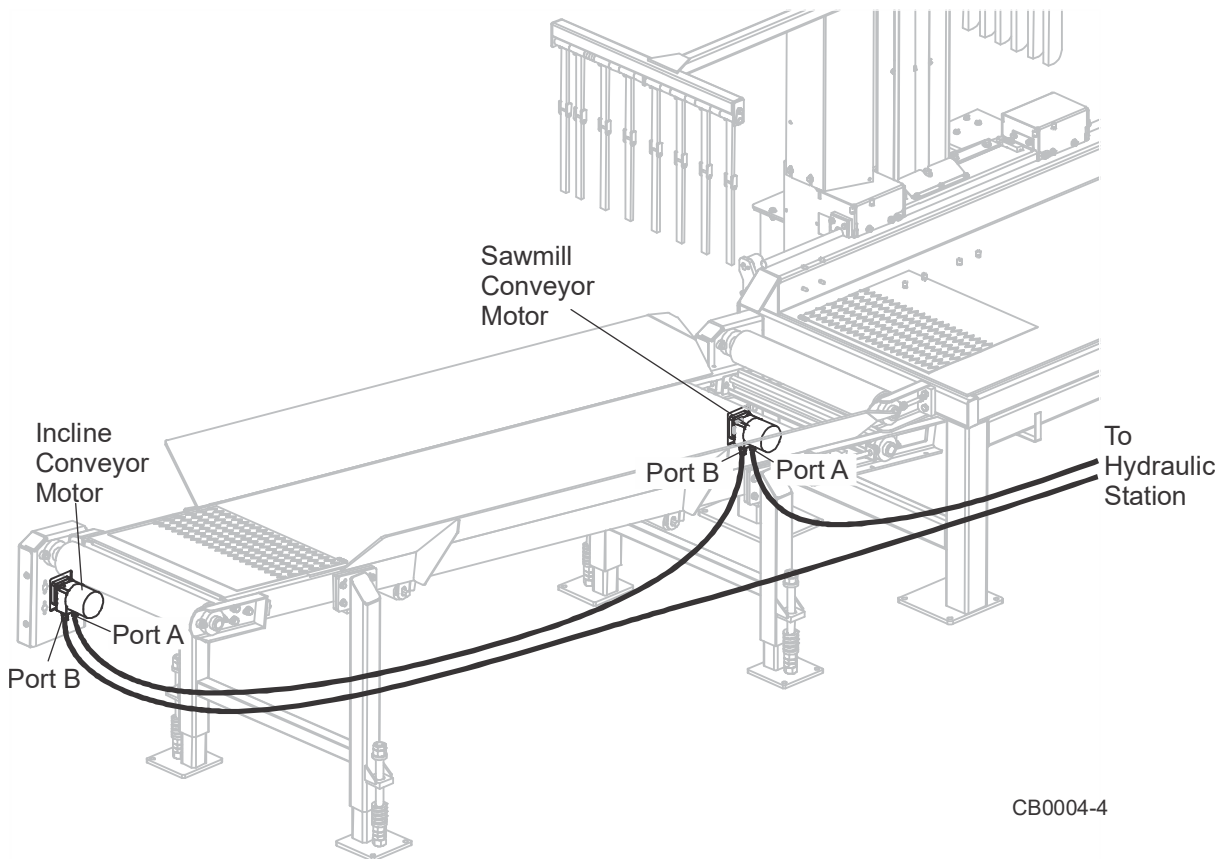


FIG. 2-3

2.2 Operation

See your sawmill operator's manual for information on the conveyor operation.

SECTION 3 MAINTENANCE

3.1 Belt Alignment



The Incline Conveyor is factory-aligned. Periodically check and realign the conveyor belt if necessary. Make sure the belt remains centered on the drive roller and idle wing pulley while running. If the conveyor belt keeps traveling to the side of the drive roller and/or idle wing pulley follow the realignment procedure below.

To realign the conveyor belt:

1. Loosen the jam nuts on one or both idle wing pulley alignment bolts.

See Figure 3-1.

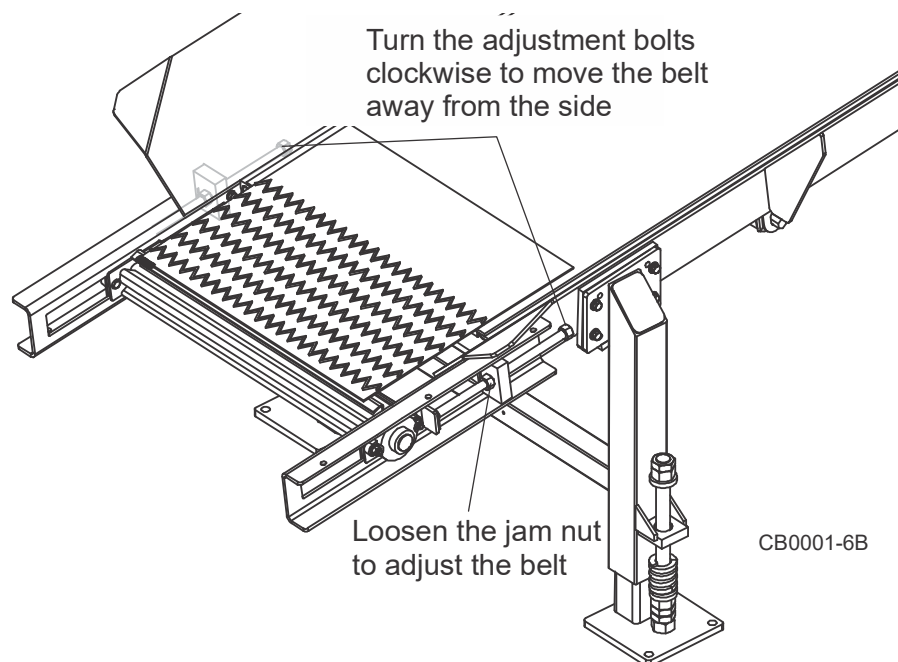


FIG. 3-1

2. Turn one of the alignment bolts clockwise to move the idle wing pulley downward and away from the side. Turn the alignment bolt counterclockwise to move the idle wing pulley upward.
3. Start the drive roller motor and check if the conveyor belt still needs to be aligned. Repeat the steps until the conveyor belt stays in place on the drive roller and idle wing pulley

while running.

4. Tighten the jam nuts when the belt alignment procedure is complete.

NOTE: You can also use the three adjustment nuts and bolts securing one side of the drive roller bearing bracket to adjust the conveyor belt. To adjust the conveyor belt, loosen the three adjustment nuts and move the bracket to tighten or loosen the belt if necessary. Make sure the belt remains on the drive roller and the idle wing pulley while running.

See Figure 3-2.

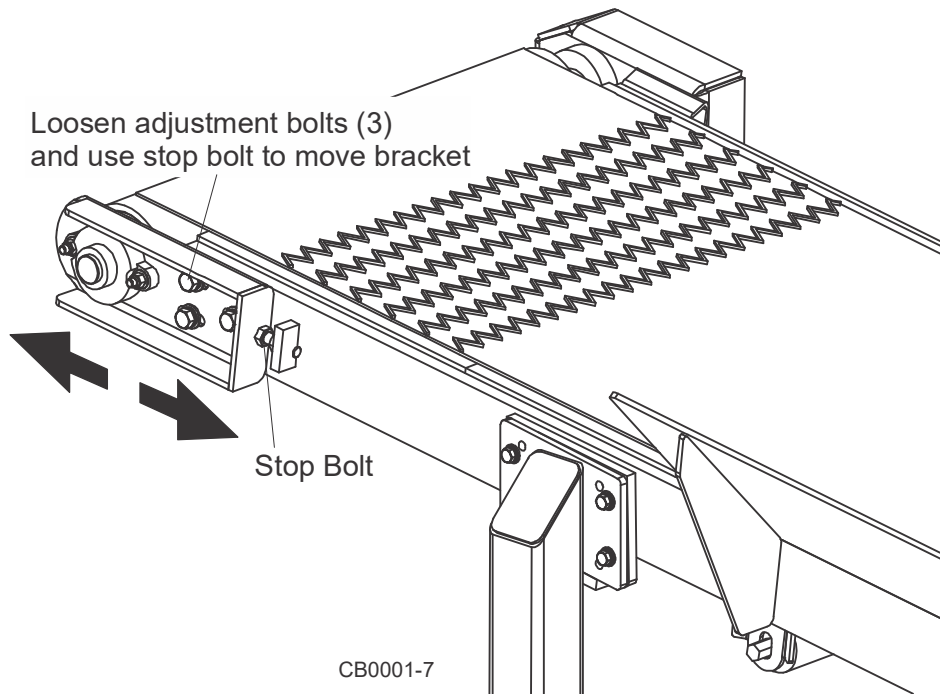


FIG. 3-2

Tighten the adjustment nuts when the belt realignment procedure is complete.



Periodically check the conveyor belt for wear. Replace a damaged or worn belt as needed. Always check the conveyor belt alignment after installing a new belt. Align the conveyor belt after replacing if necessary.

3.2 Drive Chain Adjustment



Periodically check the incline conveyor drive chain tension. Adjust the drive chain tension as needed. The drive chain needs to be adjusted if the chain slack exceeds 1" (25.4mm).



DANGER! Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death.

To check the drive chain tension, remove the four drive guard screws and remove the guard.

See Figure 3-3.

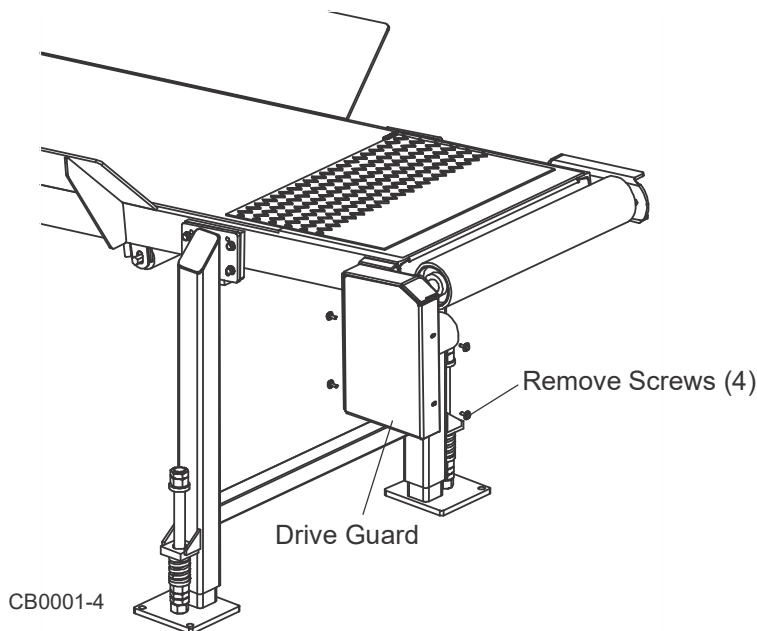


FIG. 3-3

To adjust the drive chain, follow the instructions below.

1. Make sure the drive motor is not running.
2. Loosen the four adjustment bolts securing the conveyor drive motor assembly to the motor mount plate.

3. Move the motor to adjust the drive chain until the center of the chain can be deflected 1/2" (12.7mm).

See Figure 3-4.

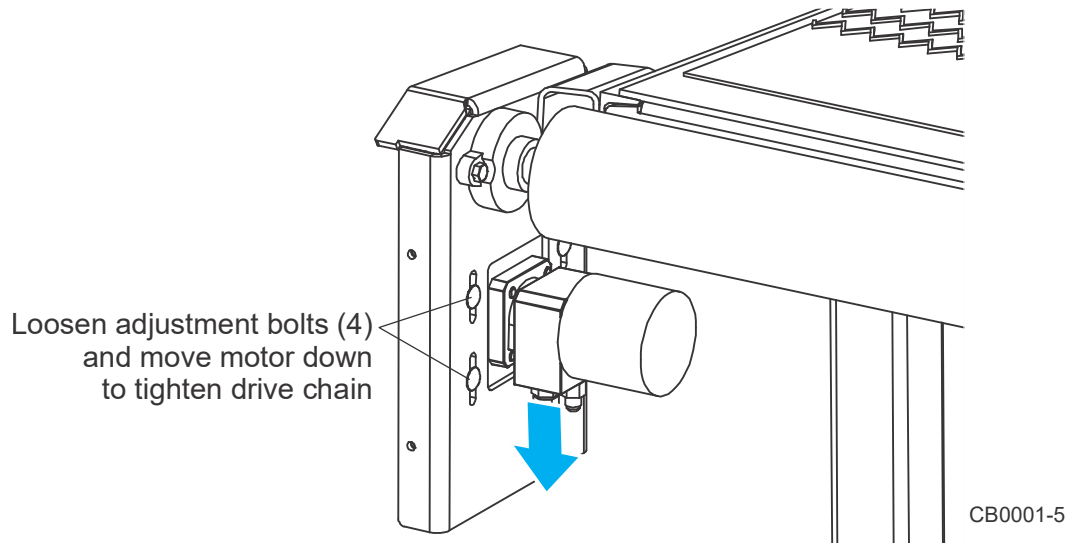


FIG. 3-4



CAUTION! Do not over-tension the conveyor drive chain. Damage to the motor will occur.

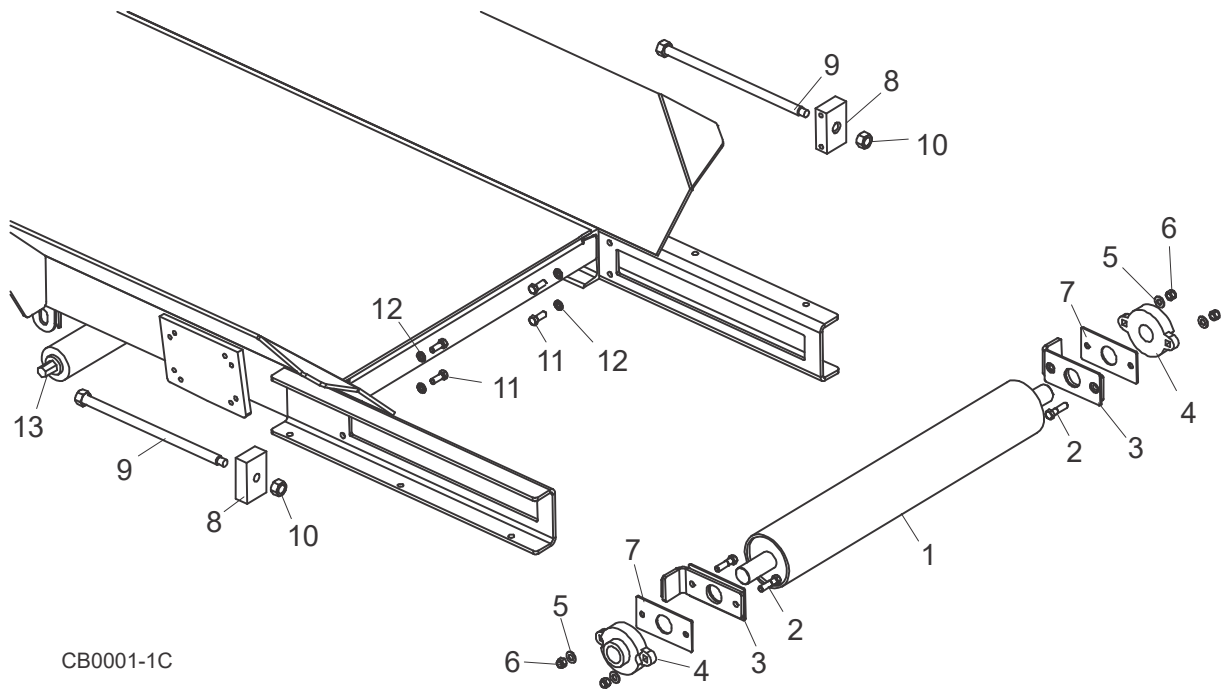
4. After the drive chain has been adjusted, tighten the adjustment bolts.
5. Reinstall the drive guard and hardware.

3 Replacement Parts

Idle Wing Pulley & Rollers

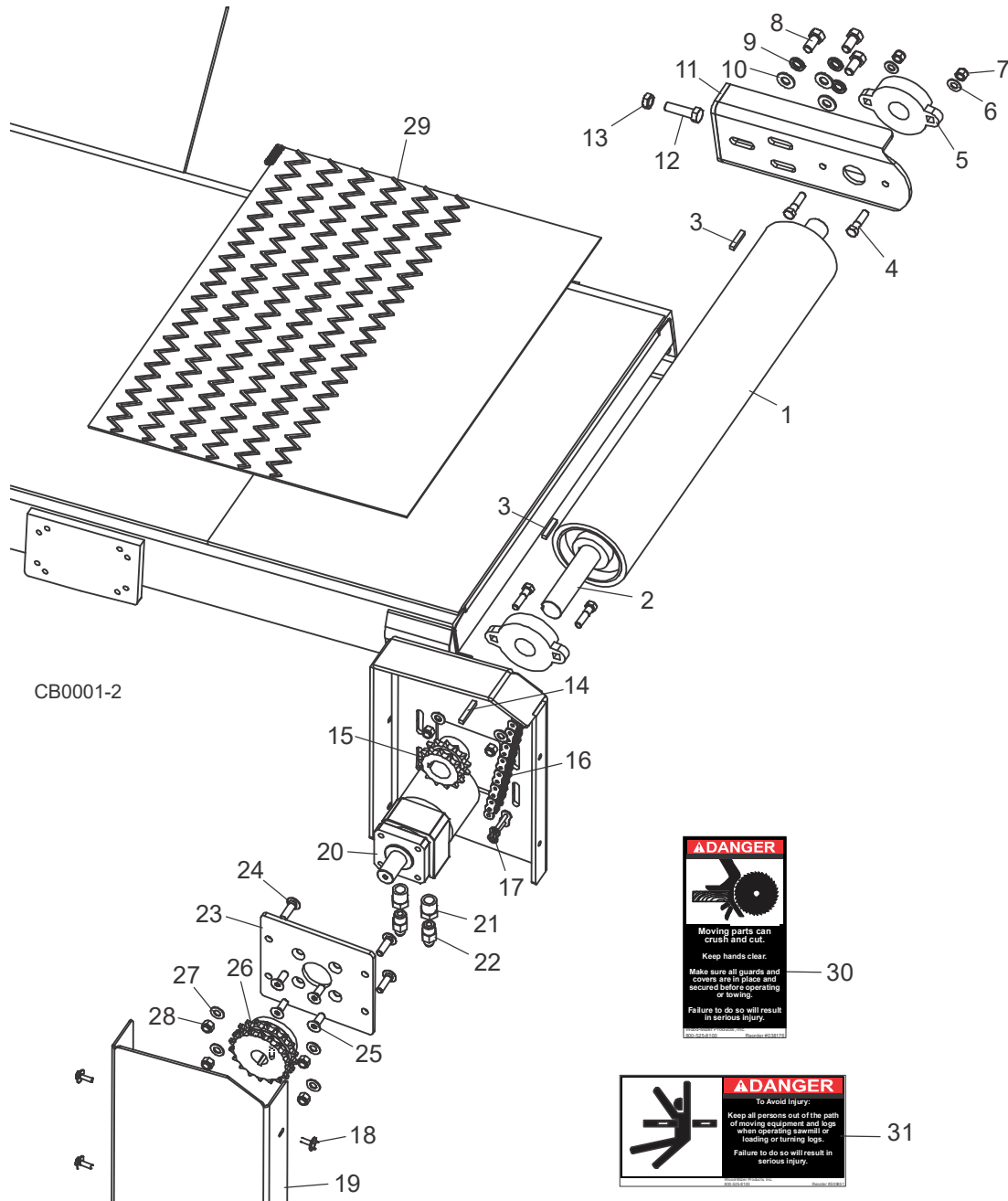
SECTION 3 REPLACEMENT PARTS

3.1 Idle Wing Pulley & Rollers



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	076962	PULLEY, IDLE CONVEYOR BELT		1
2	F05007-78	BOLT, 3/8-16 X 1 1/2" HEX HEAD GRADE 5		4
3	016697	ROLLER WELDMENT, ADJUSTMENT		1
4	016744	BEARING, FLANGE		2
5	F05011-3	WASHER, 3/8" SEA FLAT		4
6	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		4
7	016760	PLATE, BEARING		2
8	016766	BLOCK, TENSION		2
9	016912	BOLT WELDMENT, ADJUSTMENT		2
10	F05010-50	NUT, 5/8-18 PLAIN		2
11	F05007-82	BOLT, 3/8-16 X 1" HEX HEAD GRADE 8		4
12	F05011-4	WASHER, 3/8" SPLIT LOCK		4
13	038167	ROLLER, 2 1/2 X 25 BF PAINTED		2

3.2 Motor & Drive Roller



CB0001-2

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	016748	ROLLER ASSEMBLY, DRIVE		1
1	017831	Roller, Drive		1
2	016745	Shaft, Drive Roller		1
3	017832	Key, 1/4" Square x 1 3/8"		2

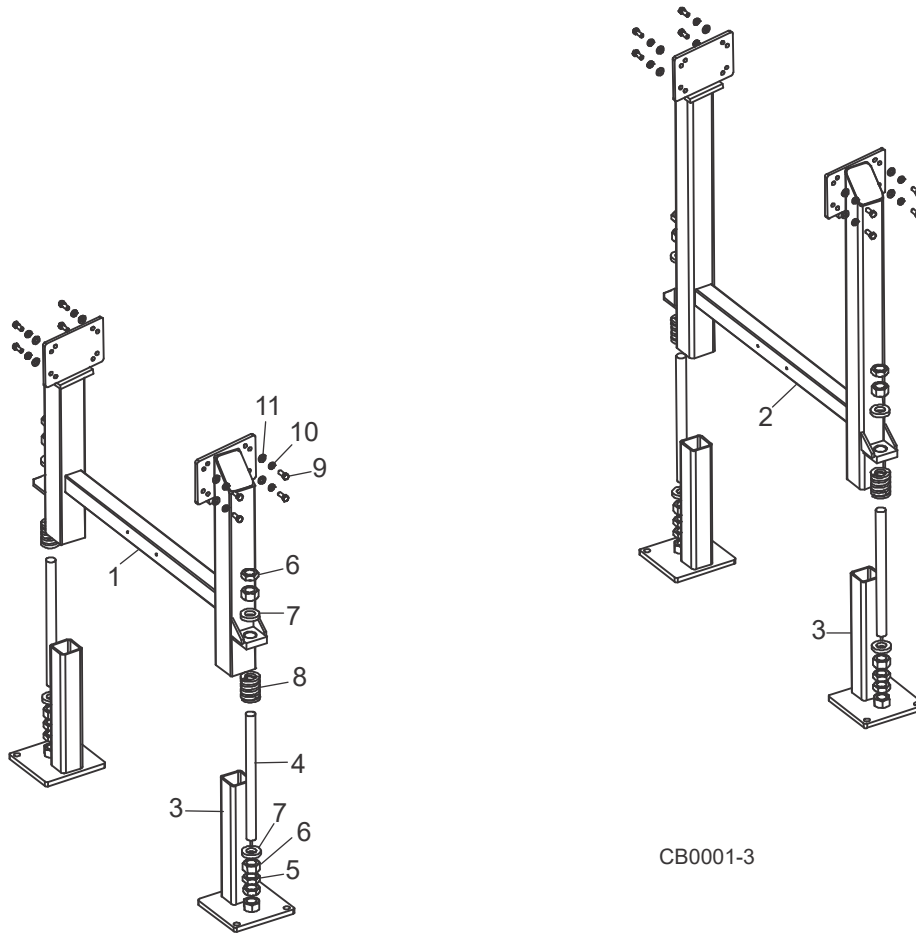
3

Replacement Parts

Motor & Drive Roller

REF	PART #	DESCRIPTION	COMMENTS	QTY.
4	F05007-78	BOLT, 3/8-16 X 1 1/2" HEX HEAD GRADE 5		4
5	016744	BEARING, FLANGE		2
6	F05011-3	WASHER, 3/8" SAE FLAT		4
7	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		4
8	F05008-128	BOLT, 1/2-13 X 1" HEX HEAD GRADE 8		3
9	F05011-9	WASHER, 1/2" SPLIT LOCK		3
10	F05011-2	WASHER, 1/2" SAE FLAT		3
11	036186	BRACKET, BEARING		1
12	F05008-127	BOLT, 1/2-20 X 1 3/4" HEX HEAD FULL THREAD		1
13	F05010-16	NUT, 1/2-20 HEX JAM		1
14	S04124	KEY, 1/4" X 1 11/16"		1
15	036008	SPROCKET, DOUBLE 50-13 X 1.25		1
16	065958	CHAIN, DOUBLE 50 X 21 7/8" 35 PITCHES		1
17	015258	LIN, 50-2 MASTER		1
18	F05005-134	BOLT, 1/4-20 X 3/4" HEX HEAD GRADE 5		4
19	071168	GUARD WELDMENT, SHORT CONVEYOR DRIVE		1
	065960	MOTOR ASSEMBLY, SHORT CONVEYOR DRIVE		1
20	P20206	Motor, Hydraulic		1
	061136	Kit, Hydraulic Motor Seal		1
21	028073	Fitting, 1/2" NPT-3/8" JIC Hex Reducer		2
22	036822	Fitting, 3/8" NPT-#8 JIC Male Connector		2
23	065956	Plate, Hydraulic Motor Mount		1
24	F05007-127	Bolt, 3/8-16 x 1 1/4" Carriage Grade 5		4
25	F05007-64	Screw, 3/8-16 x 1" FSHC		4
26	065957	Sprocket, Double 50B18 x 1 Bore w/Screw		1
27	F05011-3	Washer, 3/8" Flat SAE		4
28	F05010-10	Nut, 3/8-16 Hex Nylon Lock		4
29	071177	BELT, CONVEYOR 24" X 260" Z-TOP		1
30	038176	DECAL, BLADE HAZARD DANGER		1
31	S09851	DECAL, KEEP AWAY DANGER		1
	059506	DECAL, AWMV BY WM FOR 6" LOGO		1
	074030	HOSE KIT, SHORT INCLINE		1
	R02134	Hose, 1/2" High Pressure Series 245 Hydraulic		26 ft.
	042831	Fitting, 1/2" Hose End 37 Deg. Female Swivel		4
	074089	UNION, 1/2" TB-1/2" TB JIC SMALL HEX		1
	016816	FITTING, 3/8" JIC CAP		2

3.3 Leg Assembly



CB0001-3

REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	038526	LEG WELDMENT, MIDDLE		1
2	074205	LEG WELDMENT, CB6 LONG PADDED		1
	038523	FOOT ASSEMBLY, IC5 W/SPRING		4
3	038593	Foot Weldment, IC2/IC5		1
4	038595	Rod, 1-14 x 14 1/2" Threaded		1
5	F05010-118	Nut, 1-14 Hex Jam		3
6	F05010-140	Nut, 1-14 Hex		2
7	038521	Washer, 1 1/32" ID x 1 15/16" OD x 3/8" Thick		2
8	038592	Spring, 2" OD x 1" ID x 2 1/2" Extra HD Die (IC5 Only)		1
9	F05007-87	BOLT, 3/8-16 X 1" HEX HEAD GRADE 5		16
10	F05011-4	WASHER, 3/8" SPLIT LOCK		16
11	F05011-3	WASHER, 3/8" SAE FLAT		16
	F05008-131	BOLT, 1/2" X 5-12" CONCRETE WEDGE ANCHOR		8

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maintenance

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R

replacement parts

idle wing pulley 1

leg assembly (IC2/IC5) 4

motor & drive roller (IC5) 2

S

setup

installation 1