

**Inclined Belt Conveyor  
Safety, Operation, Maintenance &  
Parts Manual**

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**CB6-3.2 Conveyor rev. A1.00 - A1.03**

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

*April 2013*

*Form #2022*

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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.

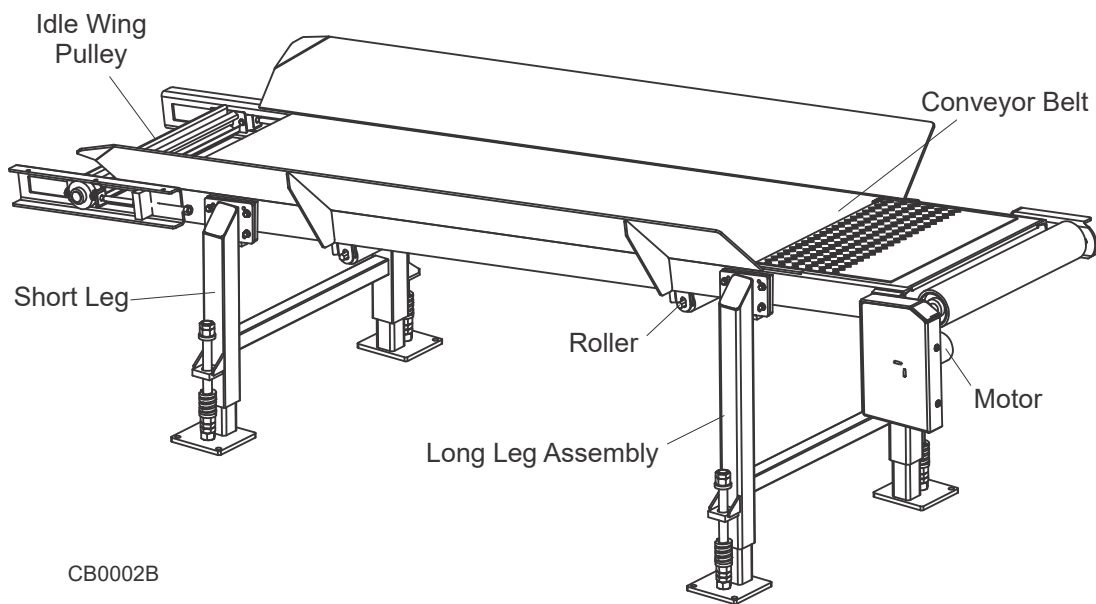


FIG. 2-0

## **2** Setup & Operation *Specifications*

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### **2.1.1** Specifications

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

#### **Model: CB6-3.2 Rev. A1.00+**

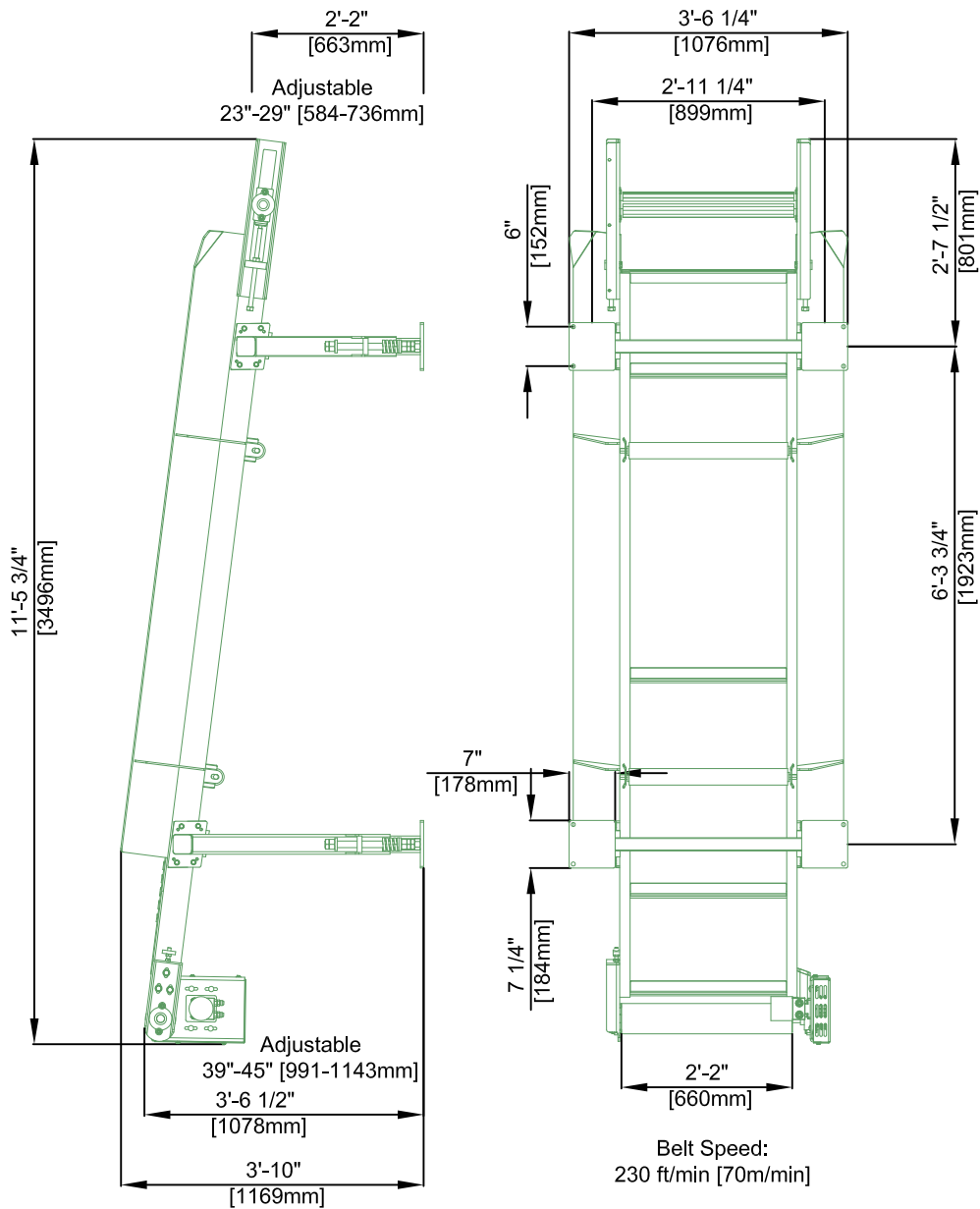
<b>Dimensions:</b>		<b>Metric</b>
Length:	11'-5 3/4"	3496mm
Width:	3'-6 1/4"	1076mm
Width (Belt Only):	2'-2"	660mm
Height (Lower End):	23" min. - 29" max.	584mm - 736mm
Height (Upper End):	39" min. - 45" max.	991mm - 1143mm
<b>Weight:</b>		
	Basic Unit: lbs.	kg
<b>Drive Motor:</b>		
	Hydraulic (Powered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

**FIG. 2-1 INCLINE CONVEYOR**



**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.

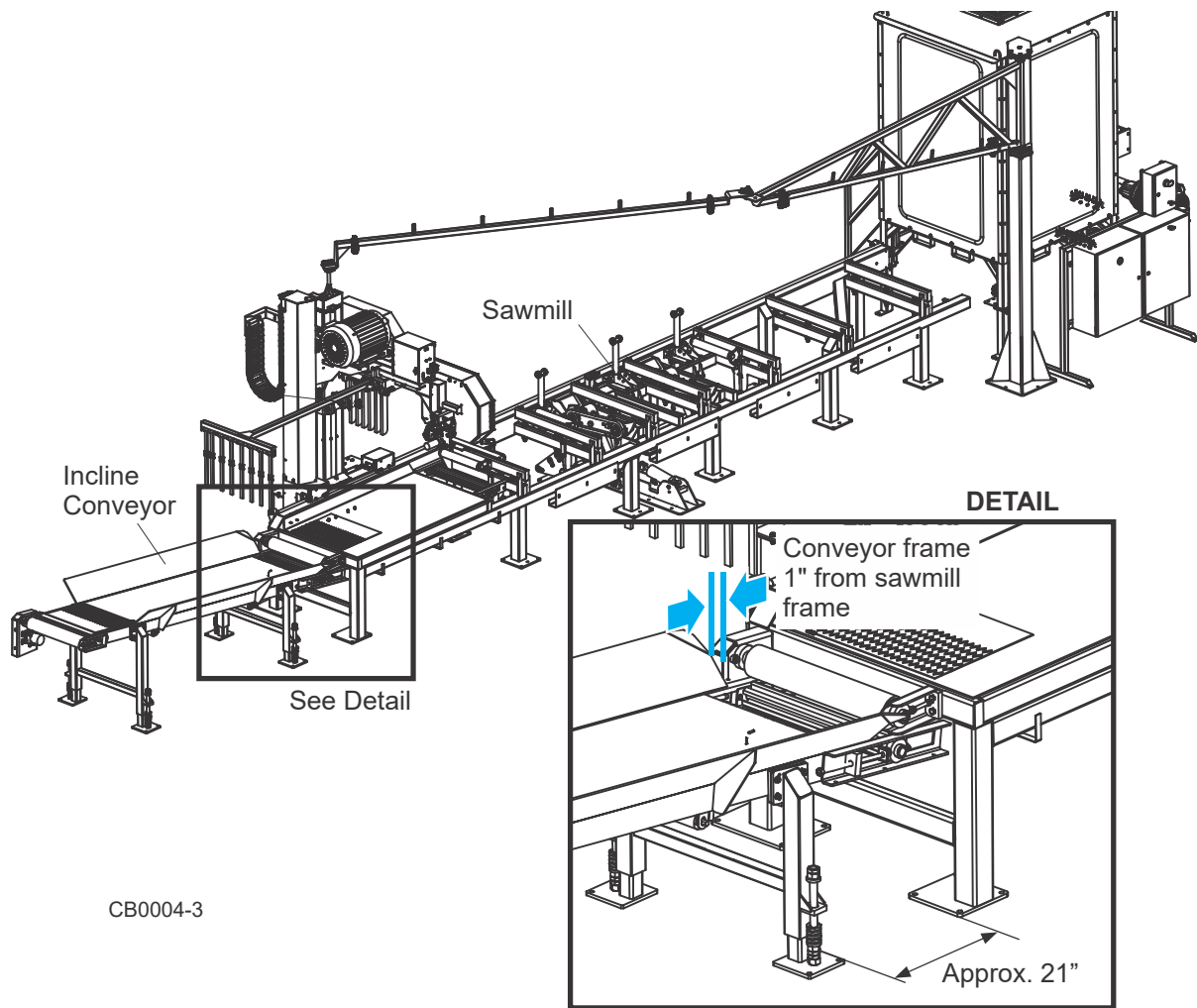


FIG. 2-3

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.

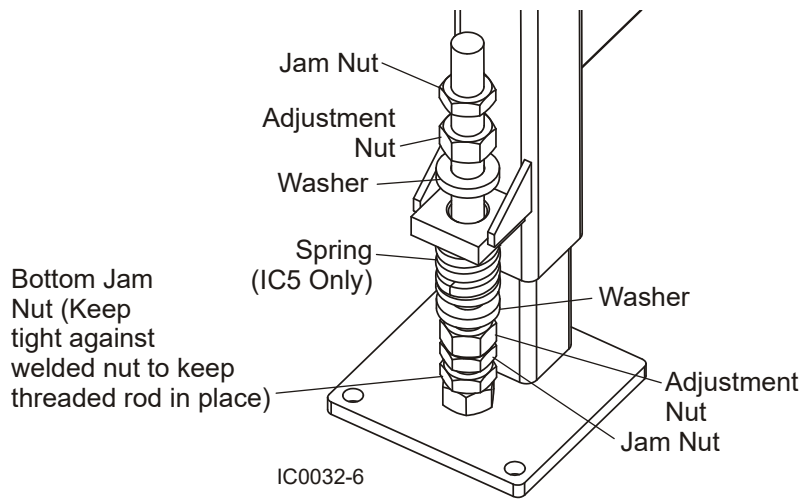


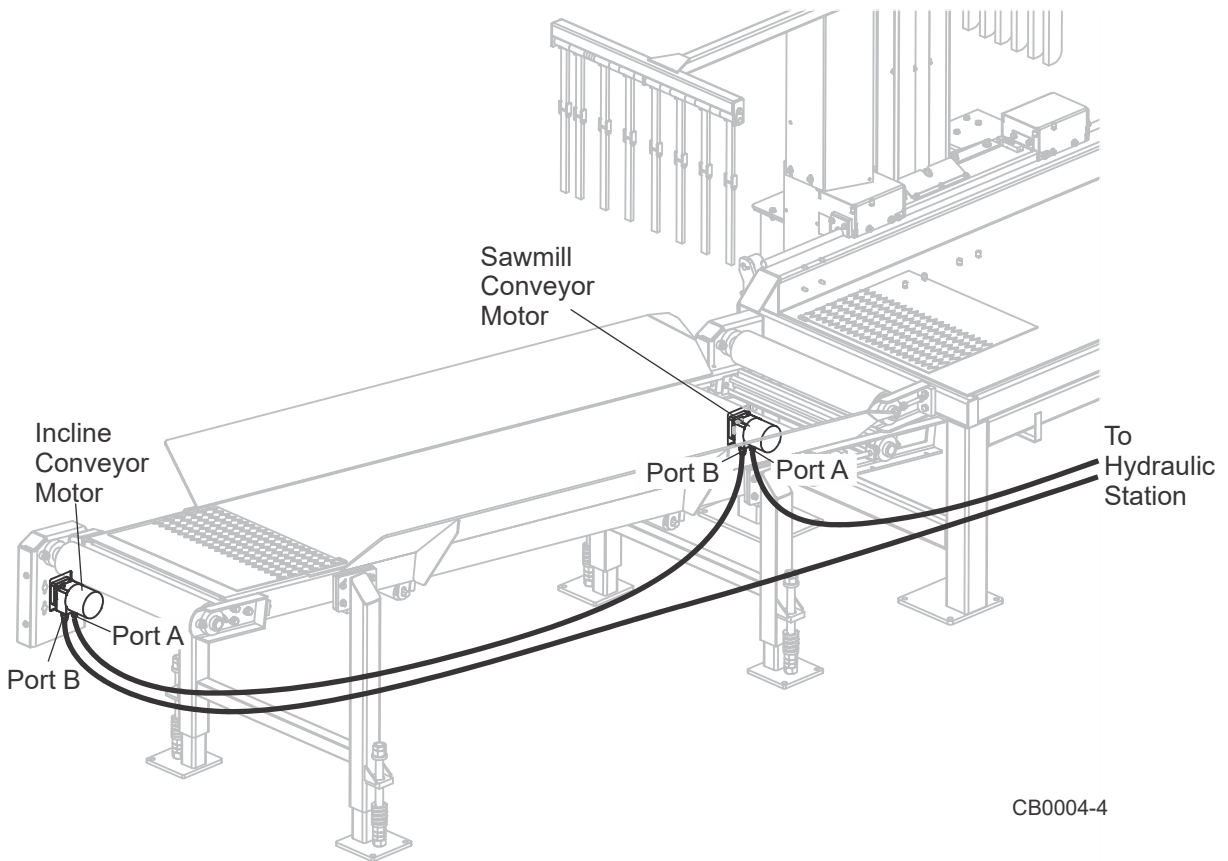
FIG. 2-3

## 2 Setup & Operation

### Installation

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

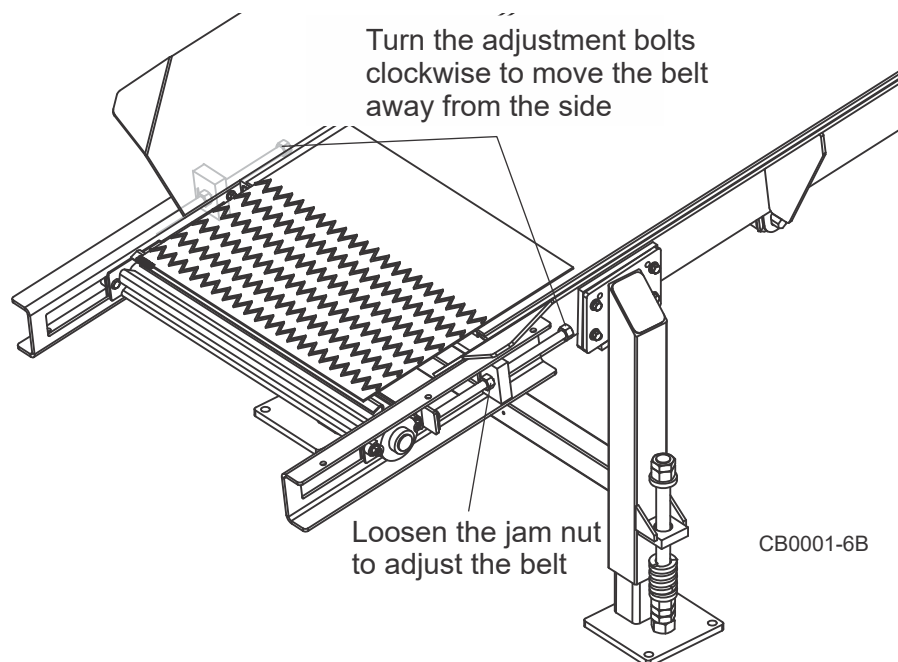


The Incline Conveyor is factory-aligned. Periodically check and realign the conveyor belt if necessary. Make sure the belt remains centered on the drive roller and idle wing pulley while running. If the conveyor belt keeps traveling to the side of the drive roller and/or idle wing pulley follow the realignment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

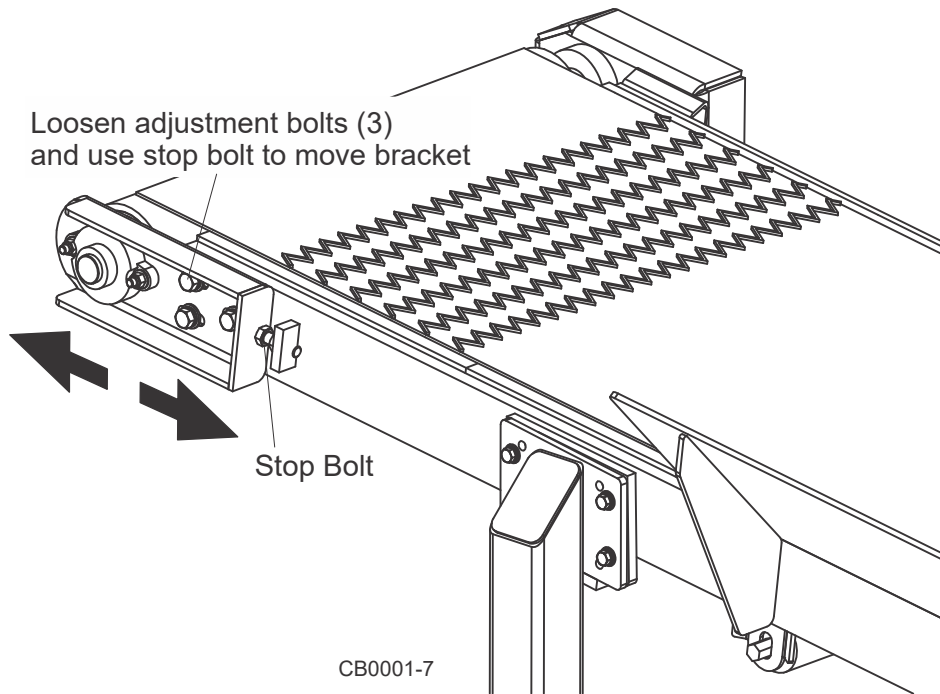


FIG. 3-2

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



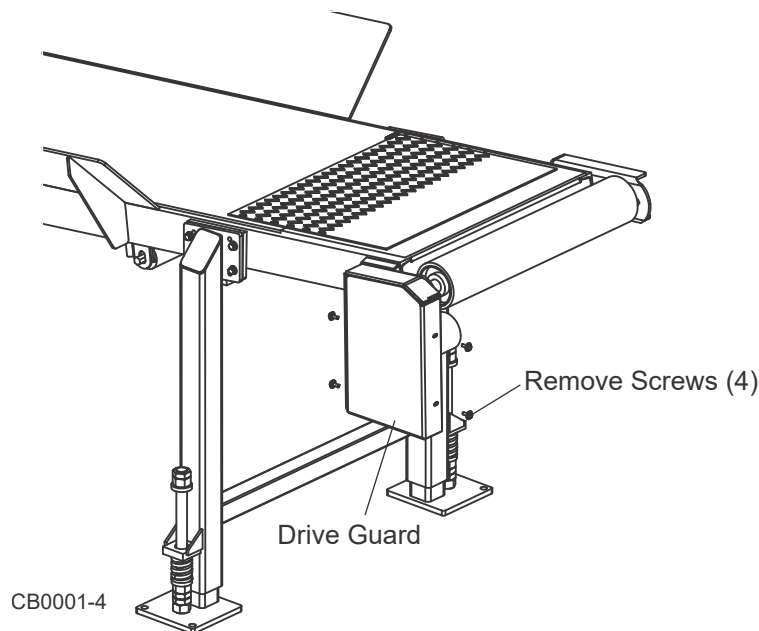
Periodically check the incline conveyor drive chain tension. Adjust the drive chain tension as needed. The drive chain needs to be adjusted if the chain slack exceeds 1" (25.4mm).



**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**

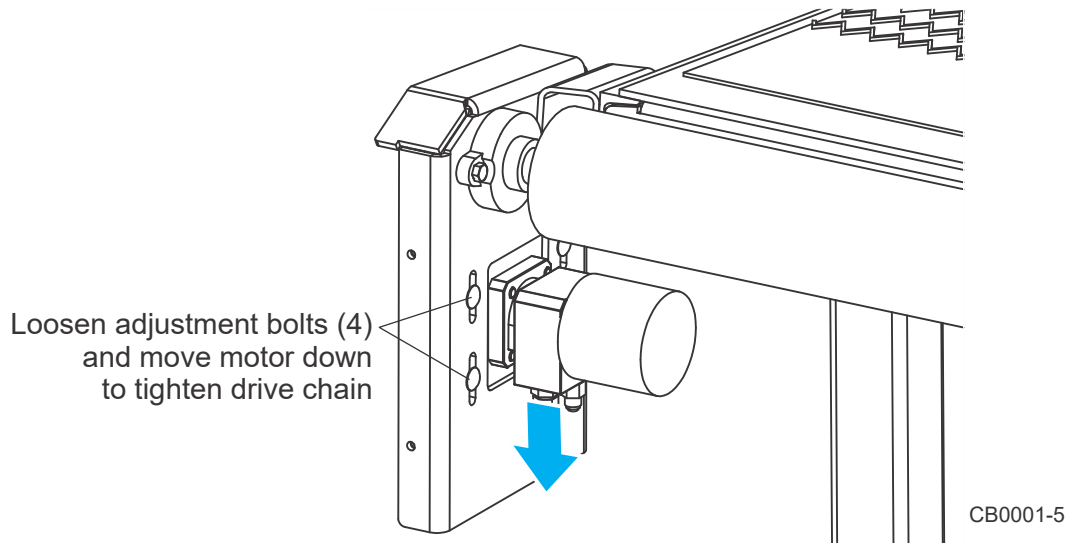
To adjust the drive chain, follow the instructions below.

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.

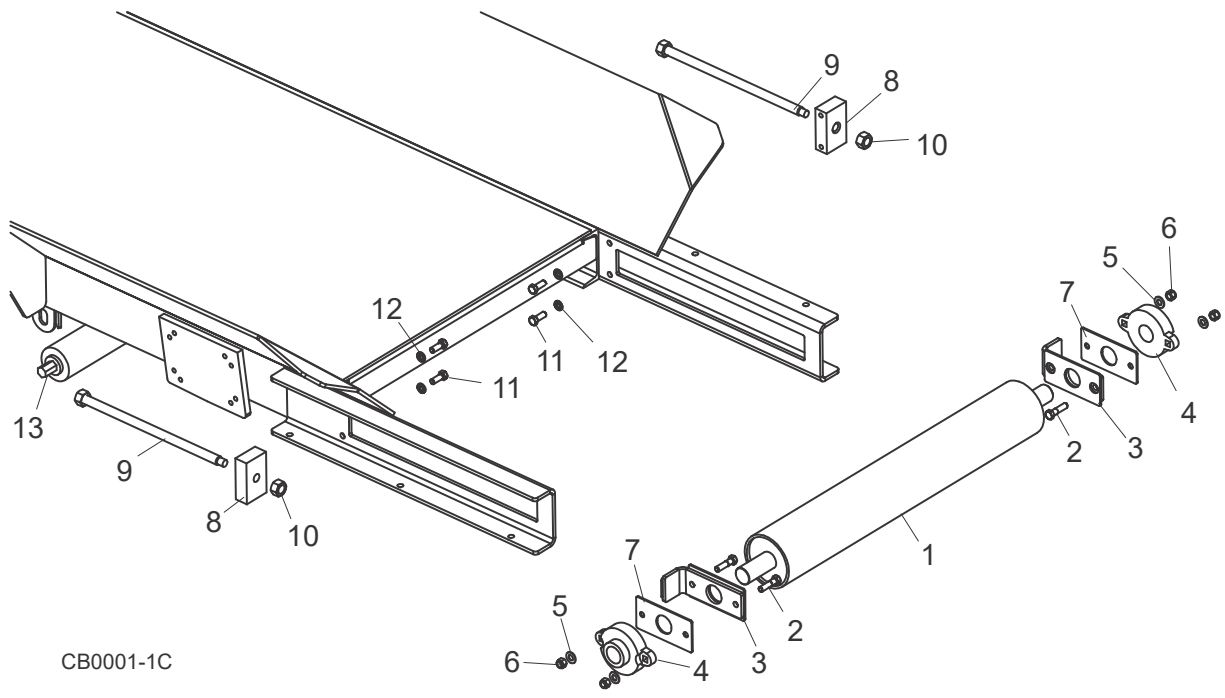
4. After the drive chain has been adjusted, tighten the adjustment bolts.
5. Reinstall the drive guard and hardware.

# 4 Replacement Parts

## Idle Wing Pulley & Rollers

### SECTION 4 REPLACEMENT PARTS

#### 4.1 Idle Wing Pulley & Rollers

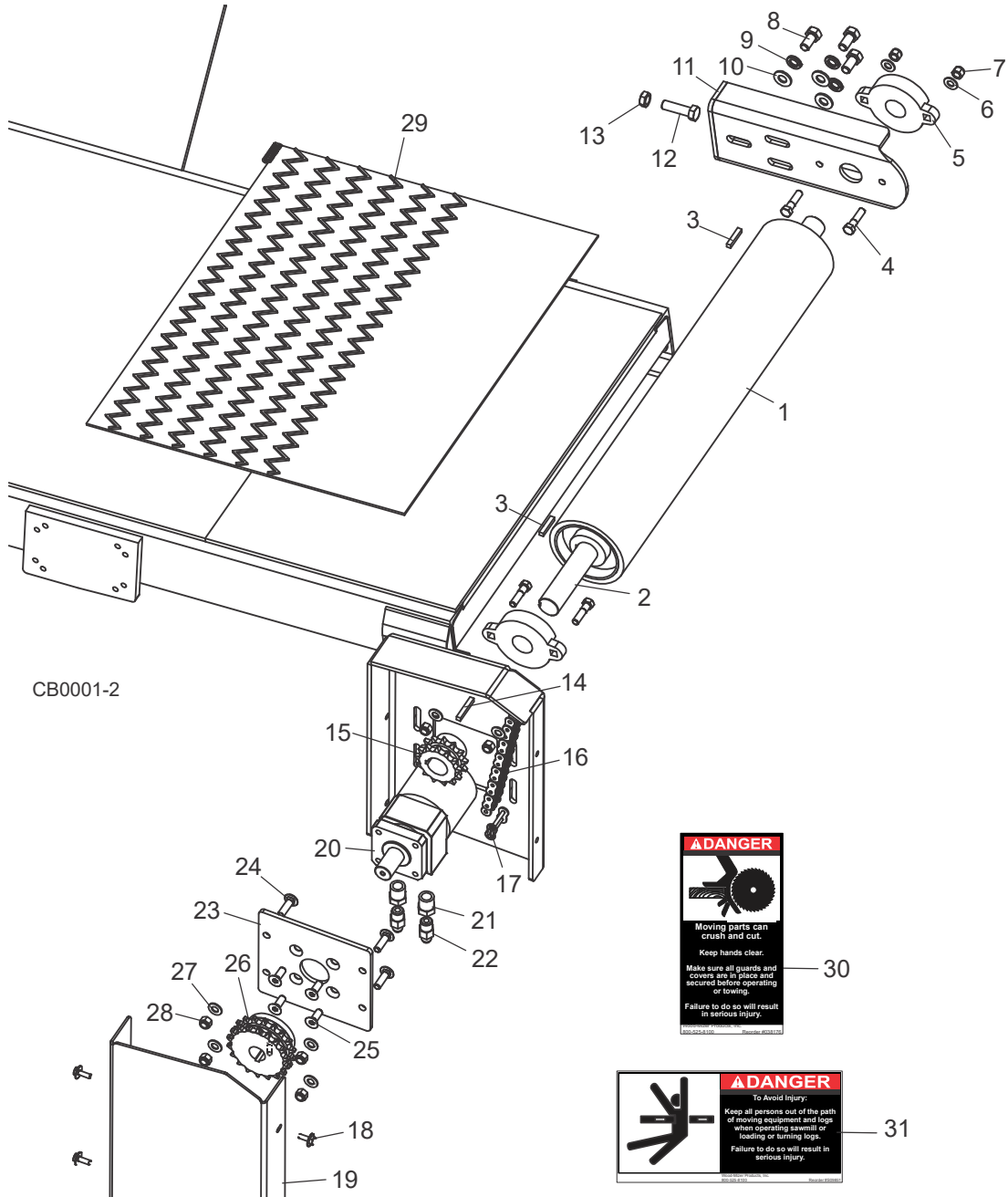


CB0001-1C

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

<sup>1</sup> Replaced 016920 Idle Wing Pulley to improve durability (Rev. A1.03).

### 4.2 Motor & Drive Roller



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>ROLLER ASSEMBLY, DRIVE</b>	016748	1
1	Roller, Drive	017831	1
2	Shaft, Drive Roller	016745	1
3	Key, 1/4" Square x 1 3/8"	017832	2

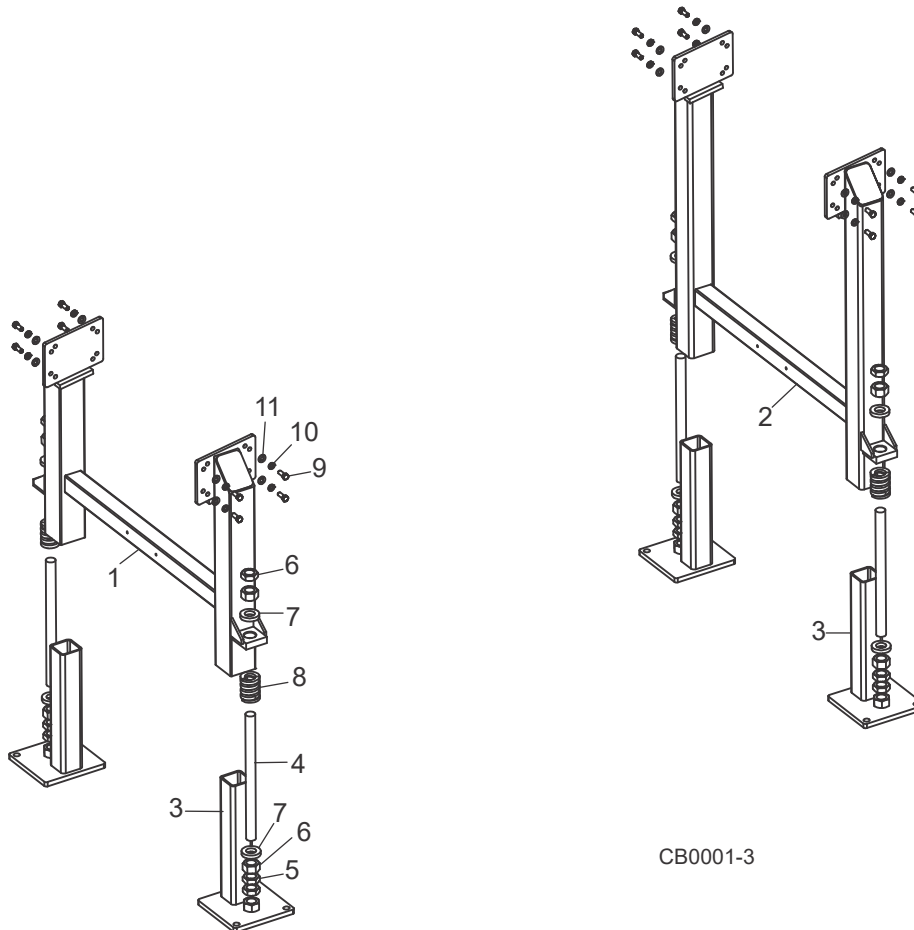
## 3

**Replacement Parts***Motor & Drive Roller*

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

<sup>1</sup> Replaced (2) 016819 3/8" NPT-3/8" JIC Male Connector Fitting to improve performance (Rev. A1.02).

### 4.3 Leg Assembly



CB0001-3

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

<sup>1</sup> Replaced 038527 Long Leg Weldment (Rev. A1.01).

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