

Cross Transfer Deck Incline

Safety, Operation, Maintenance & Parts Manual

Incline Chain Conveyor rev. A1.00-A1.02

Safety is our #1 concern!

Form #2480

MODELS EFFECTED:

CPI-10C-EA2U	CPI-10C-EB2U	CPI-10C-EC2U
CPI-15C-EA2U	CPI-15C-EB2U	CPI-15C-EC2U
CPI-20C-EA2U	CPI-20C-EB2U	CPI-20C-EC2U
CPI-25C-EA2U	CPI-25C-EB2U	CPI-25C-EC2U
CPI-30C-EA2U	CPI-30C-EB2U	CPI-30C-EC2U



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

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Indianapolis, Indiana 46214

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Wood-Mizer® LLC

Limited Product Warranty

Wood-Mizer

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	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	Date of purchase
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	
Options and Accessories	Various	One year*	One year*	
Moulders, Extractors	MP, MD	Two years	One year	
Kilns	KS, KD	One year	One year	
Slab Flatteners	MB	Two years	One year	
Pallet Equipment	PD, PC	One year	One year	
Log Splitters	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

* 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 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 replace or repair 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 WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT 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 other basis for any legal action against Warrantor. There are no other representations, promises, agreements, covenants, warranties, guarantees, stipulations or conditions, express or implied, by Warrantor except as expressly set forth herein. THE ORIGINAL PURCHASER AND ANY INTENDED USER OR BENEFICIARY OF THIS EQUIPMENT, SHALL NOT BE ENTITLED TO RECOVER ANY INDIRECT, SPECIAL, PUNITIVE, EXEMPLARY, CONSEQUENTIAL, SPECIAL, OR INCIDENTAL DAMAGES OR LOSSES, 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, so 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 which is signed by both Warrantor and Purchaser.

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 GENERAL 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 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 equipment.

 **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.

WEAR SAFETY CLOTHING

 **WARNING!** Secure all loose clothing, hair, and jewelry before operating the equipment.

Always wear eye, ear, and foot protection when operating or servicing the equipment.

EQUIPMENT SETUP

 **WARNING!** Use two or more people when lifting loads heavier than 50 pounds.

Set up the equipment on solid, level ground.

Check the control box and Emergency Stop switches for proper operation prior to each use of the machine.

CHECK EQUIPMENT BEFORE OPERATION

 **DANGER!** Ensure all guards and covers are in place and secured before operating.

KEEP PERSONS AWAY

 **DANGER!** Keep all persons out of the path of moving equipment when operating equipment.

KEEP HANDS AWAY

 **DANGER!** Remove power before clearing debris or any other maintenance activity.

 **WARNING!** Avoid contact with any hot parts (motors).

Allow the system to cool sufficiently before beginning any service function, including debris removal.

Stay a safe distance from rotating members (rollers, sprockets, etc.) and ensure loose clothing or long hair does not engage rotating members

Do not adjust the motor drive chain with the engine running.

Coastdown required. Shut down the conveyor and allow all moving parts to come to a complete stop before removing any guards or covers.

KEEP SAFETY LABELS IN GOOD CONDITION

NOTICE Ensure 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.

NOTICE If replacing a component that has a safety decal affixed to it, ensure the new component also has the safety decal affixed in the same place.

KEEP AREA CLEAN



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

Do not allow children in the area.

DISPOSE OF WOOD BY-PRODUCTS PROPERLY

NOTICE Properly dispose of all wood by-products, including sawdust, chips, and other debris, including operation waste such as oil, filters, etc.

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 energization 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.

NOTE: The removal of some forms of blocking may require re-energization of the machine before safe removal.

5. Notify affected personnel that the servicing or maintenance is completed and the machine or equipment is ready for use.

PROCEDURE INVOLVING MORE THAN ONE PERSON

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

SECTION 3 SETUP

The conveyor transfers material in only one direction, but can temporarily run in the reverse direction to clear jams.

The middle section can be repeated in sequence to extend the length of the conveyor.

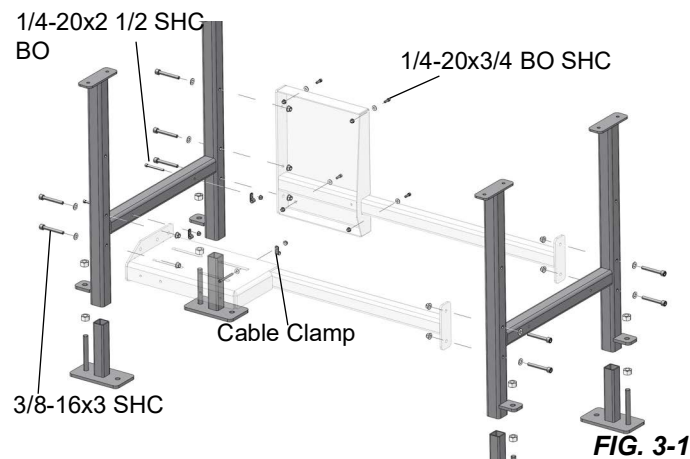
WARNING! Use two or more people when lifting loads heavier than 50 pounds.



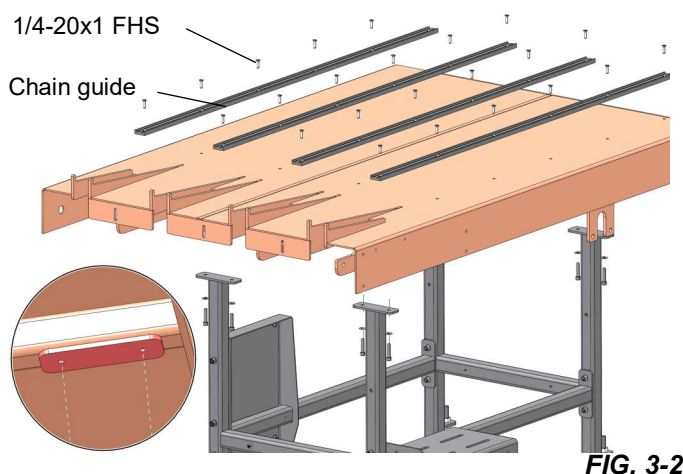
Prepare a firm, level area where the deck can be anchored. A cement pad with 1/2" diameter anchor bolts is recommended.

3.1 Drive Section

1. Assemble the adjustable feet to the table legs as shown in FIG. 3-1.



2. Assemble the chain guide channels and leg supports to the table as shown in FIG. 3-2.

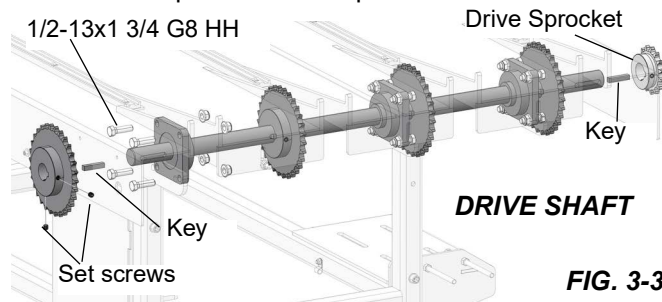


NOTE: The legs fit on plates welded onto the table bottom.

3. Loosen (**do not remove**) the set screws on all sprockets.

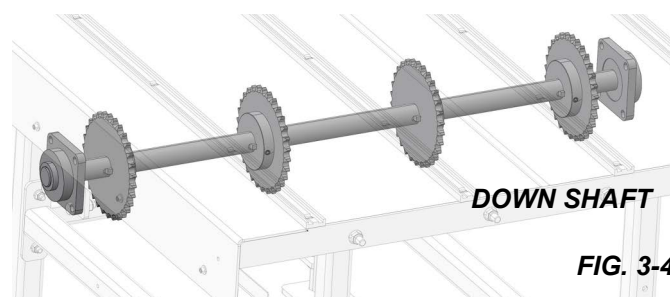
4. Slide the bearings and sprockets onto the chain drive shaft **in the order and orientation** as shown in FIG. 3-3 and FIG.3-4.

5. Ensure that the sprocket keys aligns properly in the shaft and sprocket for all sprockets.



DRIVE SHAFT

FIG. 3-3



DOWN SHAFT

FIG. 3-4

IDLE SIDE

6. Install cable channel and clip to the underside of the table.
7. Install the emergency cord bolt to the side of the table.

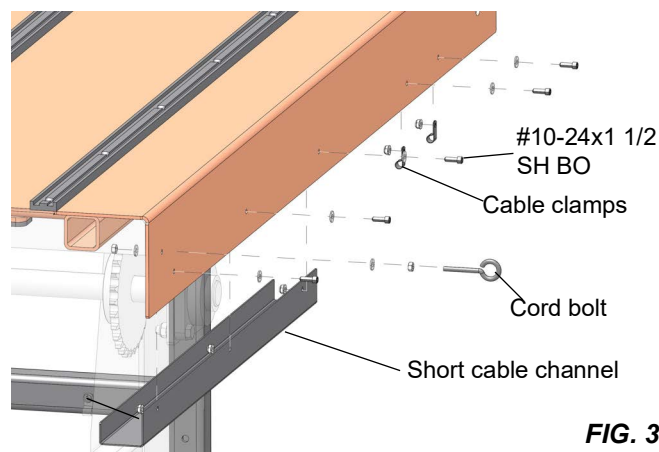


FIG. 3-5

DRIVE SIDE

8. Install the emergency cord bolt on the drive side in the same manner as shown in FIG. 3-5.

9. Screw one nut on each motor adjustment bolt before inserting into the motor mount shelf. See FIG. 3-6.

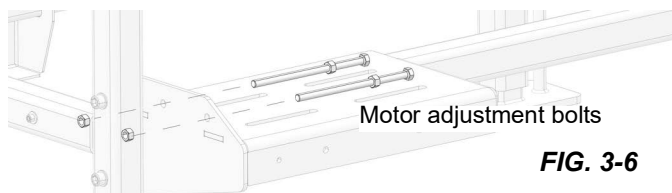


FIG. 3-6

10. Prior to mounting, add 28 oz. of Mobil Glygoyle 460 Gear Oil and install the vent plug.
11. Bolt down the gear motor to the shelf, but do not tighten securely yet. See FIG. 3-7.
12. Bolt the back cover to the frame as shown in FIG. 3-7.
13. Loosen the sprocket set screws and place the sprocket and the key on the gear shaft.
14. Wrap the drive chain around the drive sprocket on the drive shaft (FIG.3-3) and the gearbox sprocket; secure the chain with the master link.

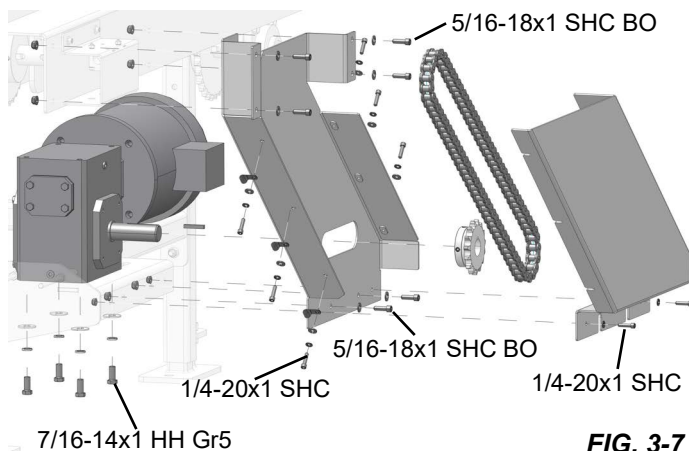


FIG. 3-7

NOTICE Ensure that the drive sprocket and the gearbox sprocket align in the same plane as shown in FIG. 3-8.

15. Use the adjustment bolts to tension the chain on the sprockets as shown in FIG. 3-6.

NOTICE Do not over tension the drive chain. Damage will occur. Allow up to

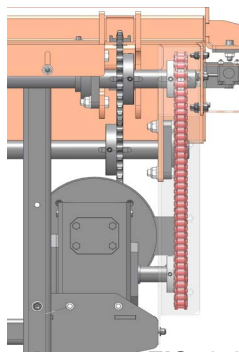


FIG. 3-8

1/2in (12mm) of slack in the chain.

16. Tighten the sprocket set screws and gearbox mounting bolts when the drive chain is properly aligned and tensioned.
17. Install the front drive chain cover.

ELECTRICAL BOX

1. Mount the electrical box to the frame by the 4 bolts at the inside corners of the box as shown in FIG. 3-9.

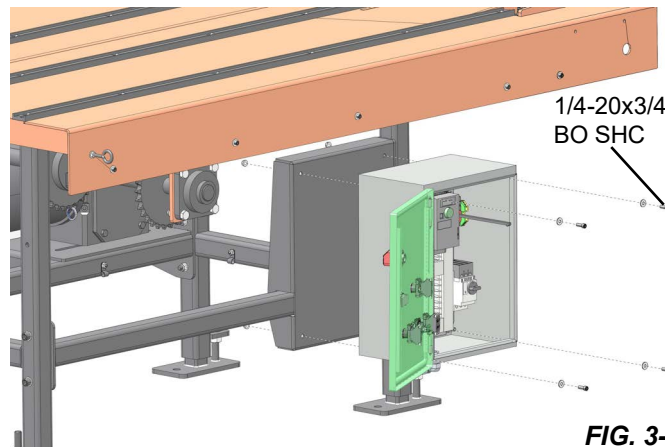


FIG. 3-9

2. Wait until the unit is nearly completed to route the cables.

3.2 Middle Section

Multiple middle sections can be installed in series to increase the length of the conveyor.

1. Assemble the middle in the same manner as the drive section.
 - 1). Assemble the down shaft as shown in FIG. 3-4.
 - 2). Assemble the chain guides as shown in FIG. 3-2.
 - 3). Assemble the cable channel and cord bolt as shown in FIG. 3-5.
 - 4). Assemble the down shaft to the table.



WARNING! Use two or more people when lifting loads heavier than 50 pounds.



- 5). Install the table to the table legs as shown in FIG. 3-2.

Connect the Drive and Middle Sections

1. Install the assembled middle section to the drive section as shown in FIG. 3-10.

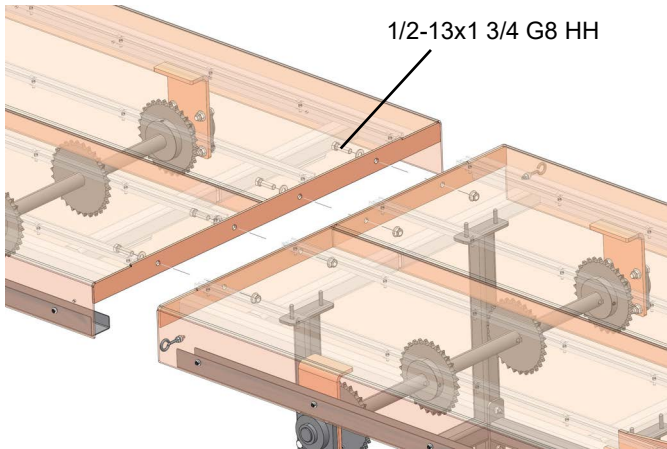


FIG. 3-10

2. Secure the sections in place with the bolts and nylon lock hex head nuts.
3. Repeat these middle section assembly steps for all middle sections.

3.3 Incline End Section

Assemble Table

1. Assemble the incline end section legs and table in the same manner as the drive section. See FIG. 3-12.



WARNING! Use two or more people when lifting loads heavier than 50 pounds.



2. Assemble and install the end chain shaft as shown in FIG. 3-11.

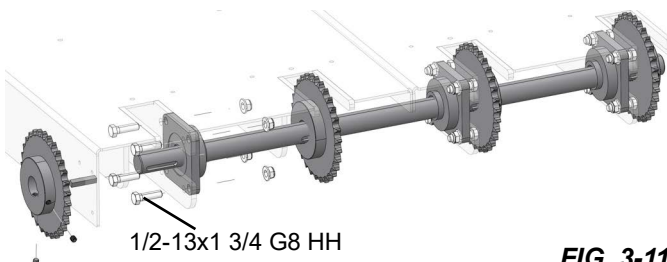


FIG. 3-11

3. Assemble and install the down shaft as shown in FIG. 3-12.

4. Install the slide bracket to the table.

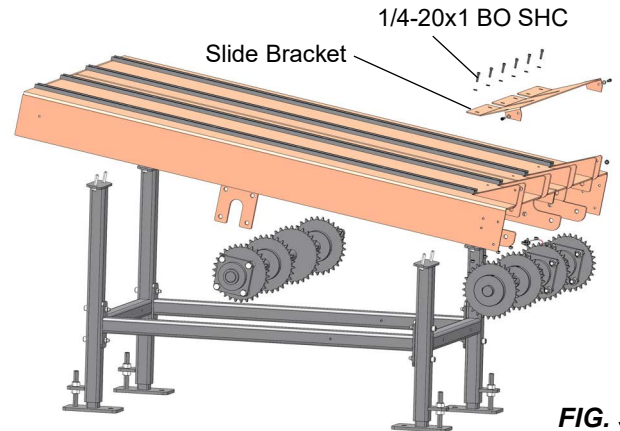


FIG. 3-12

Assemble Link Segment

1. Assemble the chain shaft in the same manner as the drive shaft (see FIG. 3-3).
2. Bolt the chain shaft onto the link weldment.
3. Slide the link segment cover over the sprockets as shown in FIG. 3-13.

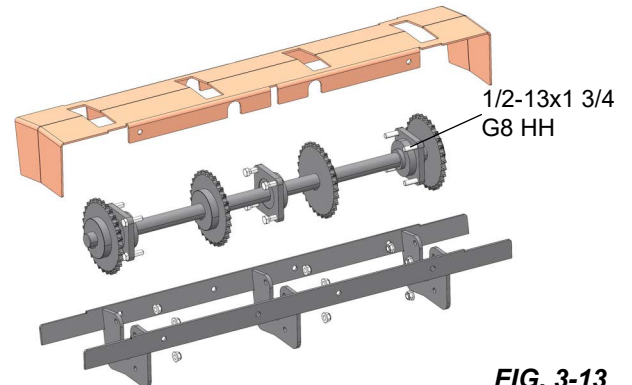


FIG. 3-13

Connect Incline to Middle Section

Align the middle and incline sections on the link segment and bolt together as shown in FIG. 3-14.

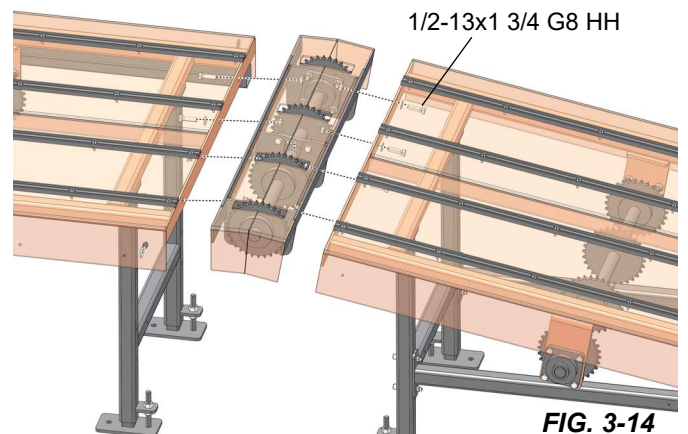


FIG. 3-14

4. Route the chains through the all tables and secure with the master link.

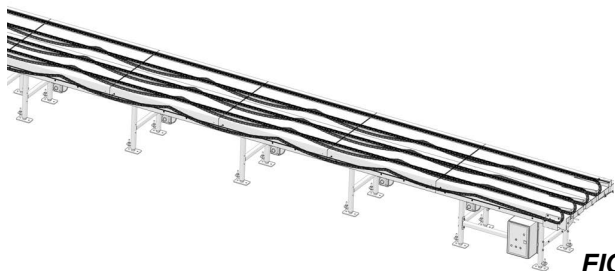


FIG. 3-15

NOTE: The chains go over the sprockets on the down shafts.

The chains do not need to be tensioned.

3.4 Safety Switch

1. Install the emergency cable bracket and cable on the end table on both sides of the conveyor.

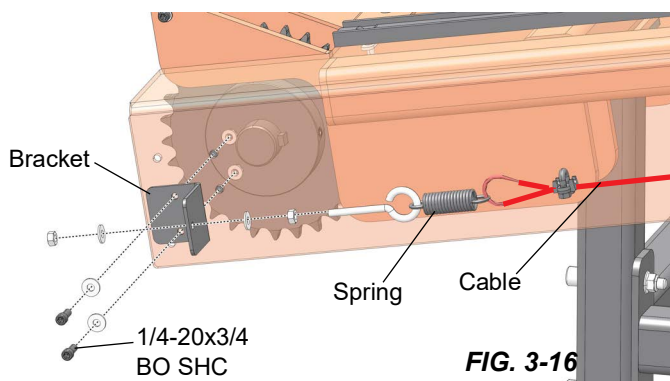


FIG. 3-16

2. Route the emergency cable through the eye bolts up to the drive on both sides end of the conveyor.

3. Install the safety switch, cover, and cable as shown in FIG. 3-17.

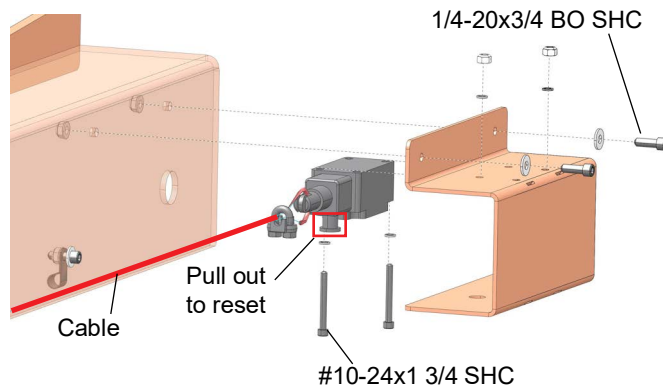


FIG. 3-17

NOTE: If the switch is tripped or not reset the conveyor will refuse to start.

4. Test the safety switch.
 - 1). Verify module is NOT reset (button pushed in).
 - 2). Try to start conveyor, should not start.
 - 3). Reset the switch by pulling it out.
 - 4). Start conveyor; chains should move.
 - 5). Trip the switch with the chains running; chains should stop.

SECTION 4 OPERATION

4.1 Operation Check



DANGER! Electrical installation and adjustments must be done by a qualified electrician.



WARNING! Secure all loose clothing, hair, and jewelry before operating the equipment.

Do not adjust the motor drive chain with the motor running.

Ensure the drive chain guard is in place and secured before operating the conveyor.

1. Ensure the conveyor has been properly set up.
2. Ensure the motor drive chain is tensioned properly.
3. Ensure the drive chain guards are in place and secured.
4. Turn off the motor to stop the transfer chains whenever the conveyor is not in use.
5. Ensure that all parts have stopped moving and the unit is electrically locked out before removing any covers or guards.

4.2 Power

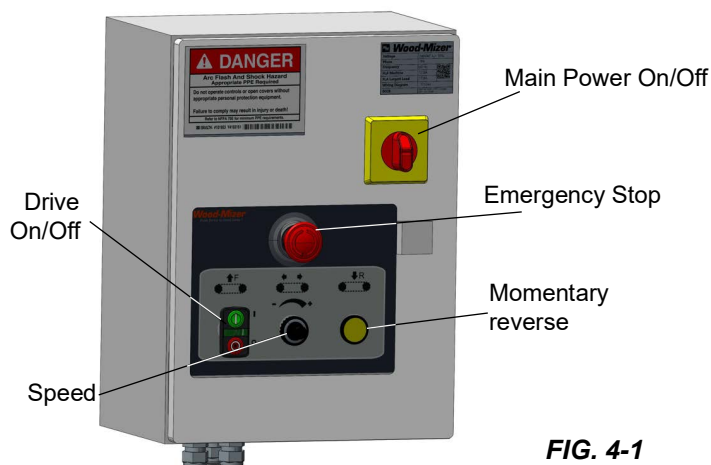


FIG. 4-1

1. Turn main power on or off to the unit by turning the red power knob.
2. Turn motor power on or off by toggling the switch.

NOTE: Motor switch glows green while motor is running.

3. Set the conveyor speed by turning the speed knob.

NOTE: The conveyor must come to an normal (non-emergency) stop before reversing.

4. Press and hold the yellow button to momentarily reverse the transfer chains.

The Emergency Stop should only be used for emergencies. If used, it must be rotated clockwise and pulled out before resetting.

4.3 Safety Cable

An emergency safety cable runs the length of the conveyor on both side.

Pull the cable to stop the all operation on the conveyor.

Reset the safety switch by pulling down on the blue (color not shown) toggle switch as shown in FIG. 4-2.

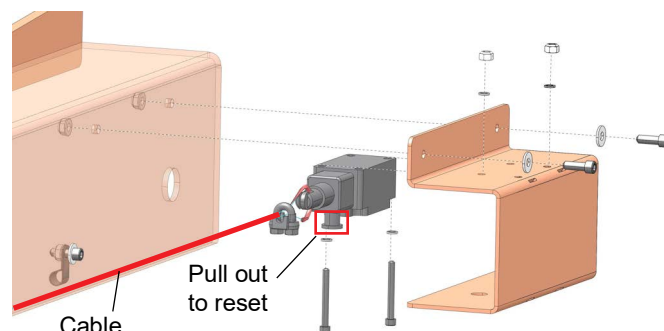


FIG. 4-2

NOTE: If the switch is tripped or not reset the conveyor will refuse to start.

SECTION 5 MAINTENANCE



DANGER! Turn off and disconnect power supply before performing any service to the unit.



WARNING! Take proper protective measures against rotating shafts, pulleys, fans, etc.

Stay a safe distance from rotating members so that loose clothing or long hair does not engage rotating members.

Wear proper safety equipment (eye, ear, hand, breathing, or foot) when performing service functions.

5.1 Tensioning the Drive Chain

1. Periodically check and adjust the drive chain tension.
2. Remove the drive cover to the drive chain housing and remove the drive cover.
3. Loosen (do not remove) the four mounting bolts securing the gearbox to the gearbox mount bracket.
4. Move the gearbox/motor assembly until the center of the chain sags approximately 1/2" (12 mm).



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

5. Retighten the gearbox mounting bolts.
6. Replace the drive cover to the drive chain housing.

5.2 Belt Alignment

1. Periodically check and realign the belt if necessary.
2. Make sure the belt remains centered on the rollers while running.
3. Loosen the jam nut on one or both lower roller belt tensioner bolts.
4. Turn the tensioner bolts to tension or loosen the belt.
5. Tighten the jam nuts and start the drive motor to check if the belt still needs to be aligned.
6. Repeat the steps until the belt stays in place on the rollers while running.
7. Retighten the jam nuts when the belt alignment procedure is complete.

NOTE: You can also use the adjustment bolt securing one side of the drive roller to align the belt. To align the belt, loosen the jam nut and turn the adjustment bolt to align the belt as necessary. Make sure the belt remains centered on the drive roller while operating the . Also, make sure the drive chain is properly tensioned after tightening the adjustment bolt and jam nut.

5.3 Check Chain Wear

1. Periodically check the chains or chain guides for wear; replace as needed.
2. Always check the belt alignment after installing a new belt.

5.4 Check the Sprockets

Check the sprockets every 8 hours of operation. Remove any dirt or debris.

5.5 Gearbox Oil

Check the gearbox oil level in the gearbox periodically.

Add a synthetic gear oil such as Mobil Glygoyle 460 to the gearbox as needed.

CHANGE GEARBOX OIL

1. Drain and refill the gearbox every 6000 hours of operation or every 2 years, whichever comes first.
2. Use 28 ounces (0.83L) of Mobil Glygoyle 460 oil to refill the gearbox.
3. Change oil every time when performing maintenance that requires gearbox disassembly.
4. Wood-Mizer offers replacement gear oil in 8 ounce (0.24L) bottles.

5.6 Lubrication

Lubricate the roller bearings every 200 hours of operation with one to two pumps of high-quality lithium-based grease such as Shell Alvania No. 3. **Do not over-grease.**

SECTION 6 REPLACEMENT PARTS

6.1 How To Use The Parts List

- Use the table of contents to locate the assembly that contains the part you need.
- 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. 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.

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	A01111	SAMPLE ASSEMBLY, COMPLETE (INCLUDES ALL INDENTED PARTS BELOW)		1
1	F02222-22	Sample Part		1
	A03333	Sample Subassembly (Includes all indented parts below)		1
2	S04444-4	Sample Part (◆ Indicates part is only available with A03333)	Available in assemblies only.	1
	K05555	Sample Subassembly (Includes all indented parts below)		1
3	M06666	Sample Part (◆ Indicates part is only available with K05555)	Available in assemblies only.	2
4	F07777-77	Sample Part		1

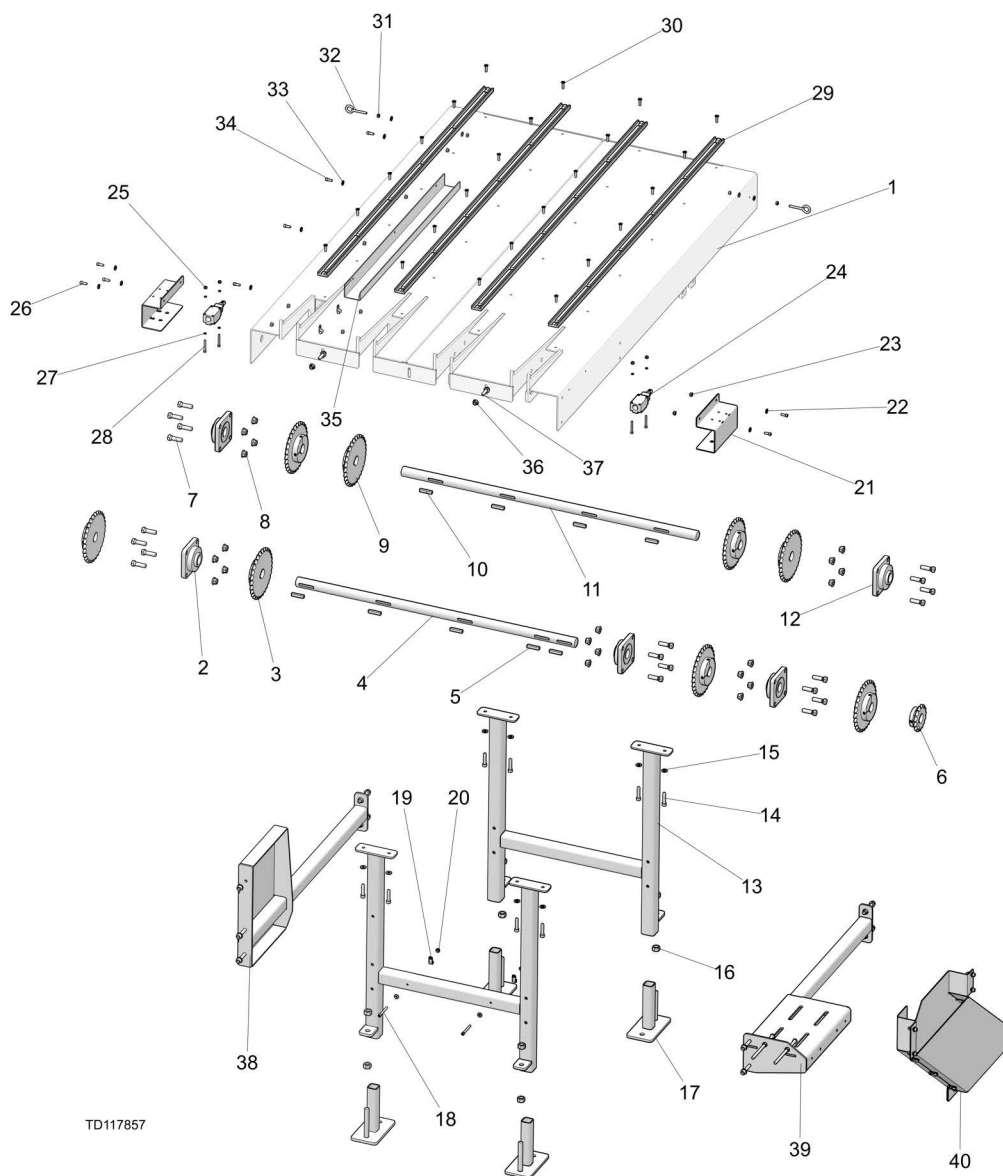
To Order Parts:

- Use your online Customer Gateway Account to find and order parts.
- From the continental U.S., call **1-800-525-8100** to order parts. Have your customer number, serial number (VIN when applicable), and part numbers ready when you call.
- From international locations, contact the Wood-Mizer distributor in your area for parts.

6.2 Torque Values

Grade		Units	SAE 5	SAE 8
Grade Mark				
Bolt Dia.	Threads. Per In.	Units	SAE 5	SAE 8
6	32	in-lbs (Nm)	20 (2.3)	-
8	32	in-lbs (Nm)	24 (2.7)	30 (3.4)
10	24	in-lbs (Nm)	35 (4.0)	45 (5.1)
10	32	in-lbs (Nm)	40 (4.5)	50 (5.7)
12	24	in-lbs (Nm)	50 (5.7)	65 (7.3)
1/4	20	in-lbs (Nm)	95 (10.7)	125 (14.1)
1/4	28	in-lbs (Nm)	95 (10.7)	150 (17.0)
5/16	18	ft-lbs (Nm)	17 (22.6)	23 (31.2)
5/16	24	ft-lbs (Nm)	20 (27.1)	25 (33.8)
3/8	16	ft-lbs (Nm)	30 (40.7)	40 (54.2)
3/8	24	ft-lbs (Nm)	35 (47.5)	45 (61.0)
7/16	14	ft-lbs (Nm)	50 (67.8)	65 (88.1)
7/16	20	ft-lbs (Nm)	55 (74.6)	70 (94.9)
1/2	13	ft-lbs (Nm)	75 (101.7)	100 (135.6)
1/2	20	ft-lbs (Nm)	85 (115.3)	110 (149.2)
9/16	12	ft-lbs (Nm)	105 (142.4)	135 (183.1)
9/16	18	ft-lbs (Nm)	115 (155.9)	150 (203.4)
5/8	11	ft-lbs (Nm)	150 (203.4)	195 (264.4)
5/8	18	ft-lbs (Nm)	160 (217.0)	210 (284.8)
3/4	10	ft-lbs (Nm)	170 (230.5)	220 (298.3)
3/4	16	ft-lbs (Nm)	175 (237.3)	225 (305.1)
7/8	9	ft-lbs (Nm)	302 (409.5)	473 (640.9)
7/8	14	ft-lbs (Nm)	300 (406.8)	400 (542.4)
1	8	ft-lbs (Nm)	466 (631.8)	714 (967.4)

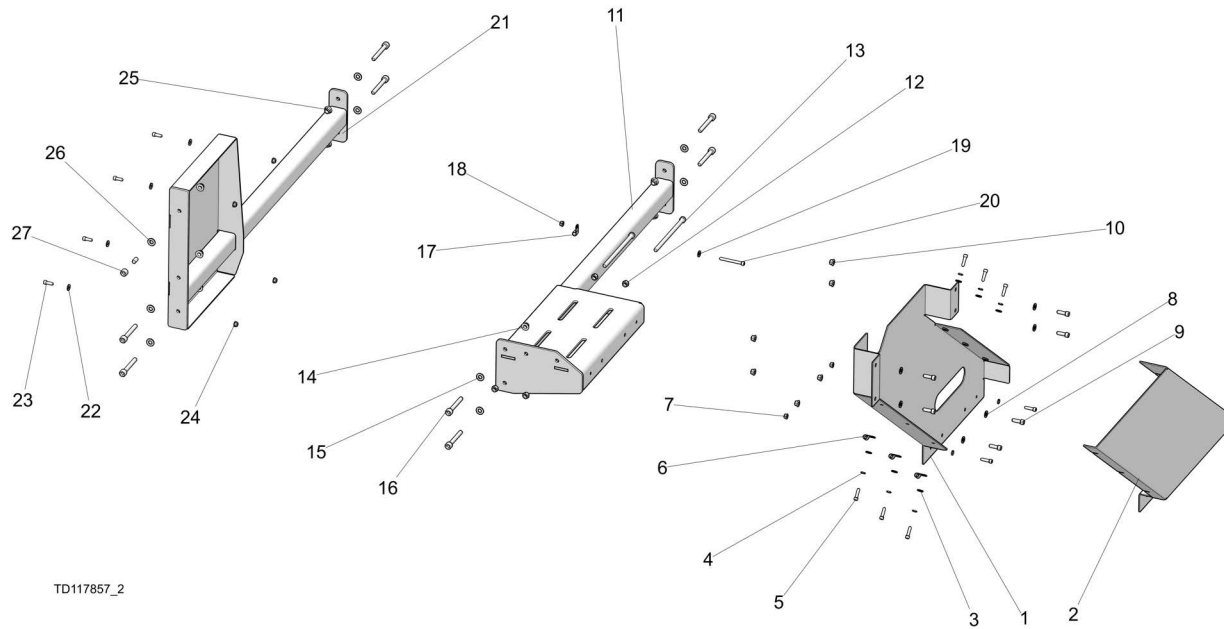
6.3 Conveyor Drive Table



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117857	Assembly, Drive Table		1
1	117856	Weldment, Drive Table		1
	117828	Assembly, Drive Shaft With Bearings		1
2	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		3
3	119037	Sprocket, 60B30x1 7/16		4
4	117829	Shaft, Chain Drive		1
5	014693	Key, 3/8x3/8x1 7/8		5
6	117912	Sprocket, #60x15T-1 7/16" ID		1
	117821	Assembly, Down Shaft With Bearings		1
7	F05009-73	Bolt, 1/2-13x1 3/4 Gr8 HH		20

REF	PART #	DESCRIPTION	COMMENTS	QTY.
8	F05010-223	Nut, 1/2-13 Flanged Hex Nylock		20
9	119037	Sprocket, 60B30x1 7/16		4
10	014693	Key, 3/8x3/8x1 7/8		4
11	117820	Shaft, Chain Drive		1
12	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		2
13	117975	Weldment, Table Legs		2
14	F05007-53	Bolt, 3/8-16x1 3/4 SHC		8
15	F05011-3	Washer, 3/8 Flat SAE		10
	117977	Assembly, Adjustable Foot		4
16	117846	Weldment, Adjustable Foot		4
17	F05010-5	Nut, 5/8-11 Hex		8
18	F05005-179	Screw, 1/4-20x2 1/2 SHC BO		2
19	050201	Cable Clamp, .375 Coated 1/4" Mo		4
20	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		7
	117957	Assembly, Switch With Cover		2
21	117945	Bracket, Emergency Switch Mount		2
22	F05011-11	Washer, 1/4 SAE Flat		4
23	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		4
24	052154	Switch, Cable Pull Normal Stop w/Reset		2
25	F05010-160	Nut, #10-24 Hex Self-Locking		4
26	F05005-26	Screw, 1/4-20x3/4 BO SHC		4
27	F05011-20	Washer, #10 Split Lock		8
28	F05004-192	Bolt, #10-24x1 1/2 SH BO		4
29	130469	Channel, CG7-2060 Chain Guide		4
30	F05005-118	Screw, 1/4-20x1 FHS		24
31	F05010-63	Nut, 1/4-20 Free Hex		4
32	F05005-91	Bolt, 1/4-20x2 Eye		2
33	F05011-11	Washer, 1/4 SAE Flat		11
34	F05005-26	Screw, 1/4-20x3/4 BO SHC		5
35	117927	Bracket, Cable Rail Short		1
36	F05010-222	Nut, 3/8-16 Flanged Hex Nylock		2
37	F05007-67	Screw, 3/8-16x1 1/2 Unpl SHC		2
38	118100	Assembly, Electric Box Beam	(See Section 6.4)	1
39	117982	Assembly, Motor Shelf	(See Section 6.4)	1
40	117956	Assembly, Drive Chain Cover	(See Section 6.4)	1

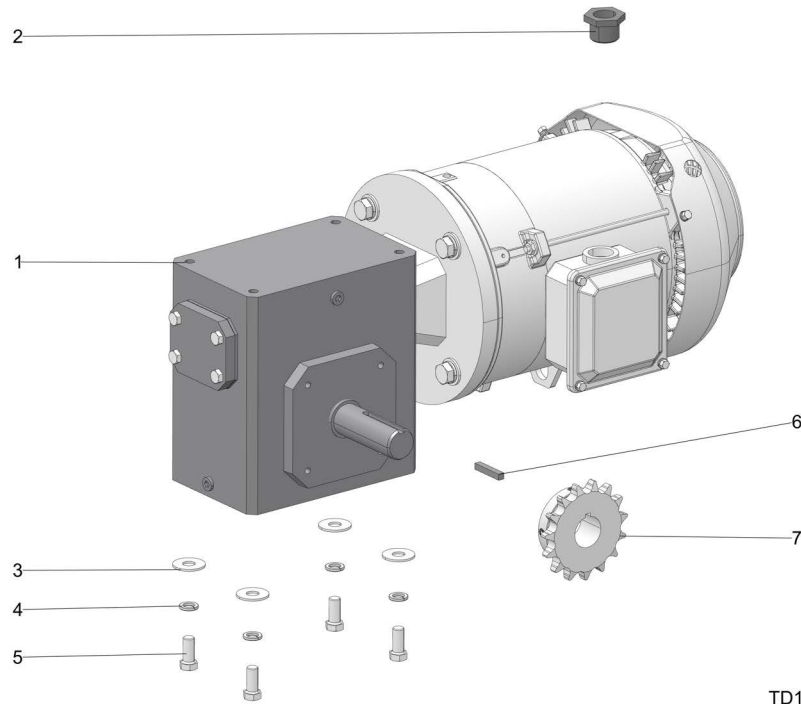
6.4 Drive Table Rails and Cover



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117956	Assembly, Drive Chain Cover		1
1	117917	Weldment, Back Cover		1
2	117916	Bracket, Front Cover		1
3	F05011-11	Washer, 1/4 SAE Flat		6
4	F05011-14	Washer, 1/4 Split Lock		8
5	F05005-84	Screw, 1/4-20x1 SHC BO		8
6	050201	Cable Clamp, .375 Coated 1/4" Mo		3
7	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		2
8	F05011-17	Washer, 5/16 SAE Flat		6
9	F05006-19	Bolt, 5/16-18x1 SHC B/O		6
10	F05010-221	Nut, 5/16-18 Flanged Hex Nylock		6
	117982	Assembly, Motor Shelf		1
11	117981	Weldment, Motor Shelf Beam		1
12	F05010-1	Nut, 3/8-16 Hex		4
13	F05007-128	Bolt, 3/8-16x7 HH		2
14	F05010-222	Nut, 3/8-16 Flanged Hex Nylock		4
15	F05011-3	Washer, 3/8 Flat SAE		4
16	F05007-103	Screw, 3/8-16x3 SHC		4
17	050201	Cable Clamp, .375 Coated 1/4" Mo		1
18	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		1
19	F05011-11	Washer, 1/4 SAE Flat		1
20	F05005-179	Screw, 1/4-20x2 1/2 SHC BO		1
	118100	Assembly, Electric Box Beam		1
21	117983	Weldment, Electric Box Beam		1

REF	PART #	DESCRIPTION	COMMENTS	QTY.
22	F05011-11	Washer, 1/4 SAE Flat		4
23	F05005-26	Screw, 1/4-20x3/4 BO SHC		4
24	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		4
25	F05010-222	Nut, 3/8-16 Flanged Hex Nylock		5
26	F05011-3	Washer, 3/8 Flat SAE		5
27	F05007-103	Screw, 3/8-16x3 SHC		5

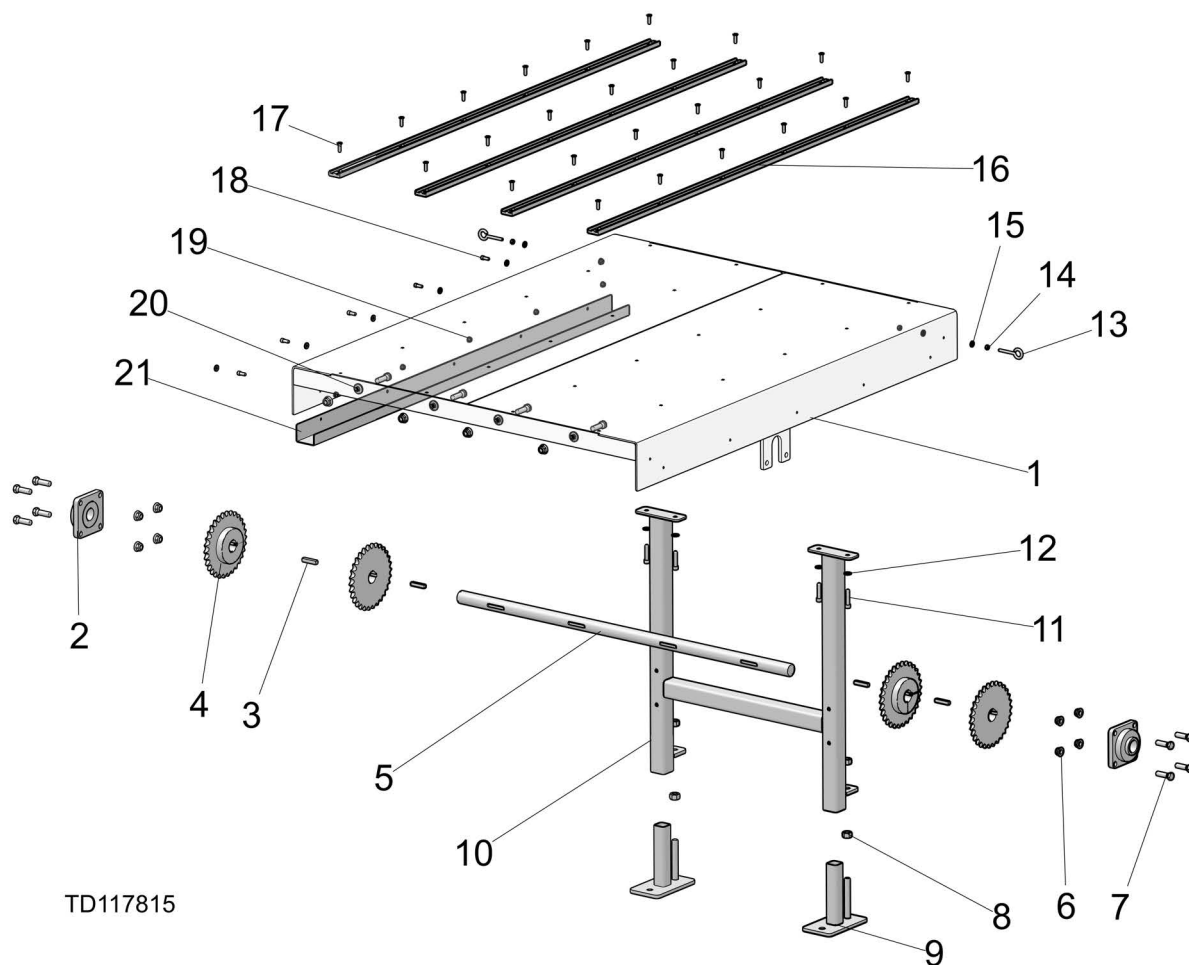
6.5 Assembly, Gearbox with Motor



TD117914A

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117914	Assembly, Gearbox with Motor	Removed after restructuring BOM after 11/14/2022 per ECN 38811	1
	065415	Motor/Gearbox Assy, 1.5HPx50:1 GC	Removed after restructuring BOM after 11/14/2022 per ECN 38811.	1
1	130097	Motor, 1.5HP 1200RPM 230/460V Marathon	Replaced 065413 after 4/4/2022 per ECN 38474.	1
	065413	Motor, 1.5HP 1200RPM 230/460V Marathon	Replaced by 130097 after 4/4/2022 per ECN 38474.	1
2	038742	Bushing, 3/4MNPT-1/2FNPT Pipe	Added after 9/8/22 per ECN 38709	1
3	F05011-35	Washer, 7/16 Standard Flat		4
4	F05011-48	Washer, 7/16 Split Lock		4
5	F05007-145	Bolt, 7/16-14x1 HH Gr5		4
6	028080	Key, 1/4 Sq x 1-1/2 lg		1
7	117913	Sprocket, #60x15T- 1 1/4" ID		1

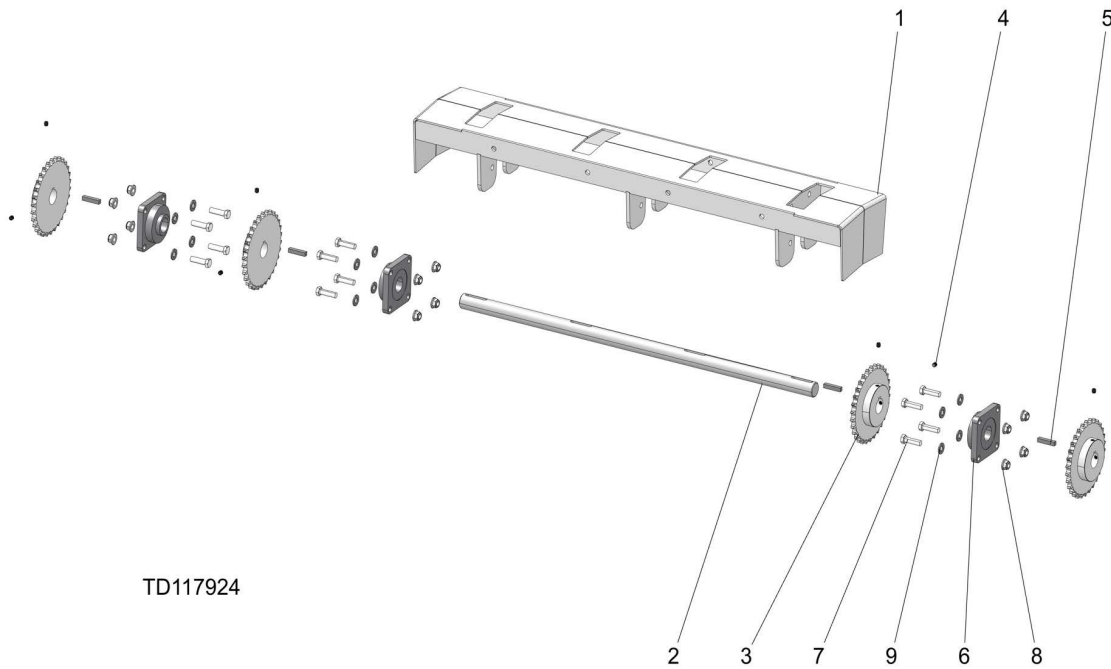
6.6 Middle Section



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117815	Assembly, Pallet Recycling 5 Ft Segment		1
1	117812	Weldment, Pallet Recycling 5 Ft Segment		1
	117821	Assembly, Down Shaft With Bearings		1
2	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		2
3	014693	Key, 3/8x3/8x1 7/8		4
4	119037	Sprocket, 60B30x1 7/16		4
5	117820	Shaft, Chain Drive		1
6	F05010-223	Nut, 1/2-13 Flanged Hex Nylock		12
7	F05009-73	Bolt, 1/2-13x1 3/4 Gr8 HH		12
	117977	Assembly, Adjustable Foot		2
8	F05010-5	Nut, 5/8-11 Hex		4
9	117846	Weldment, Adjustable Foot		2
10	117975	Weldment, Table Legs		1
11	F05007-53	Bolt, 3/8-16x1 3/4 SHC		4
12	F05011-3	Washer, 3/8 Flat SAE		4

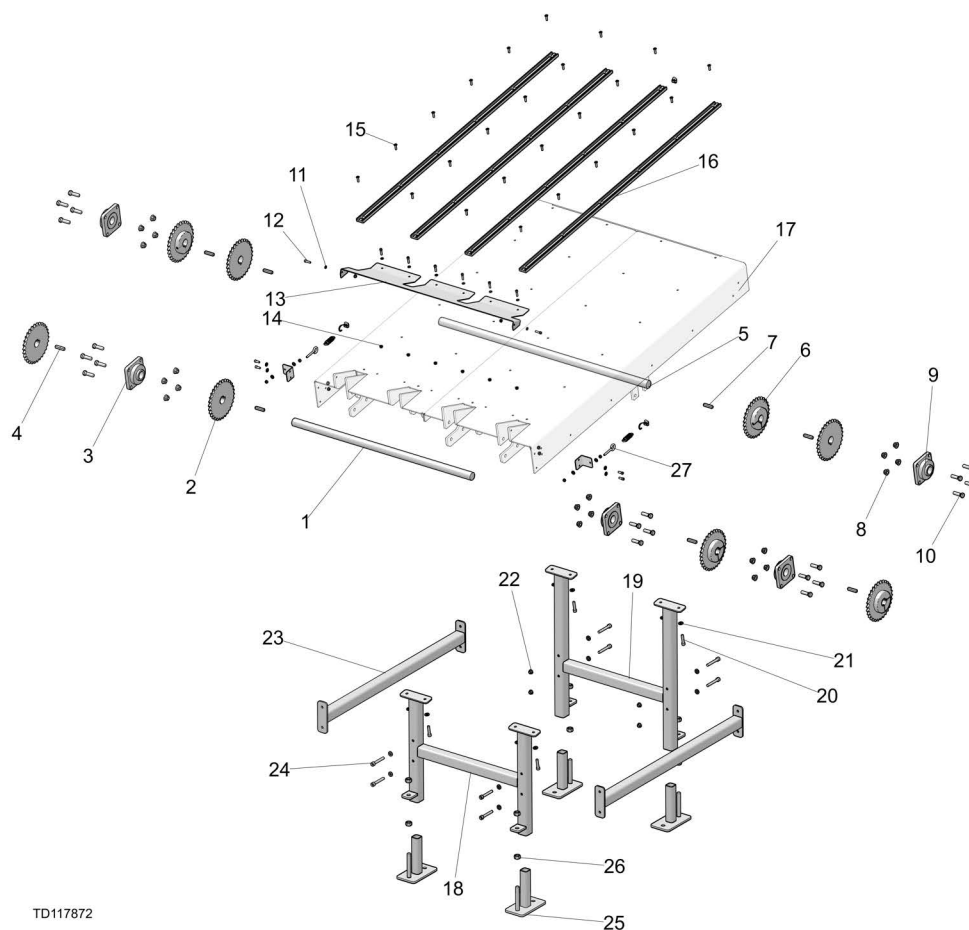
REF	PART #	DESCRIPTION	COMMENTS	QTY.
13	F05005-91	Bolt, 1/4-20x2 Eye		2
14	F05010-63	Nut, 1/4-20 Free Hex		4
15	F05011-11	Washer, 1/4 SAE Flat		9
16	130469	Channel, CG7-2060 Chain Guide		4
17	F05005-118	Screw, 1/4-20x1 FHS		24
18	F05005-26	Screw, 1/4-20x3/4 BO SHC		5
19	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		5
20	F05011-101	Washer, 1/2 SAE Flat Gr5-8		4
21	117925	Bracket, Cable Channel		1

6.7 Conveyor Link Segment



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117924	Assembly, Link Segment		1
1	117923	Weldment, Link Segment		1
	117837	Assembly, End Table Chain Shaft		1
2	117836	Shaft, Chain Drive		1
	119037	Sprocket, 60B30x1 7/16		4
3	119037-1	Sprkt, 30T #60 Chain 1-7/16 ID		1
4	119037-2	Sprkt, 30T #60 Chain 1-7/16 ID		2
5	014693	Key, 3/8x3/8x1 7/8		4
6	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		3
	117926	Bracket, Link Segment Cover	Added to 117923 after 12/1/22 per ECN 38828	1
7	F05009-73	Bolt, 1/2-13x1 3/4 Gr8 HH		12
8	F05010-223	Nut, 1/2-13 Flanged Hex Nylock		12
9	F05011-101	Washer, 1/2 SAE Flat Gr5-8		12

6.8 Conveyor Incline Section

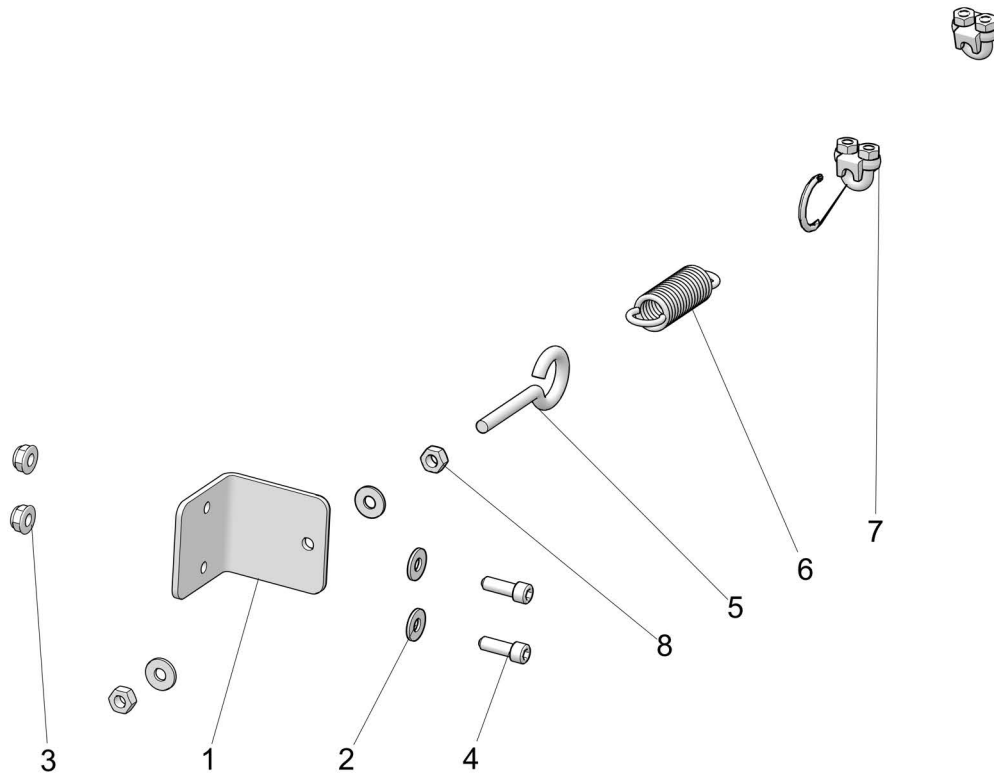


TD117872

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117872	Assembly, Incline Section		1
	117837	Assembly, End Table Chain Shaft		1
1	117836	Shaft, Chain Drive		1
2	119037	Sprocket, 60B30x1 7/16		4
3	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		3
4	014693	Key, 3/8x3/8x1 7/8		4
	117821	Assembly, Down Shaft With Bearings		1
5	117820	Shaft, Chain Drive		1
6	119037	Sprocket, 60B30x1 7/16		4
7	014693	Key, 3/8x3/8x1 7/8		4
8	F05010-223	Nut, 1/2-13 Flanged Hex Nylock		20
9	038667	Bearing, 1-7/16 Dia, 4-Bolt Flange		2
10	F05009-73	Bolt, 1/2-13x1 3/4 Gr8 HH		20
11	F05011-14	Washer, 1/4 Split Lock		8
12	F05005-84	Screw, 1/4-20x1 SHC BO		8
13	117919	Bracket, Slider		1
14	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		8

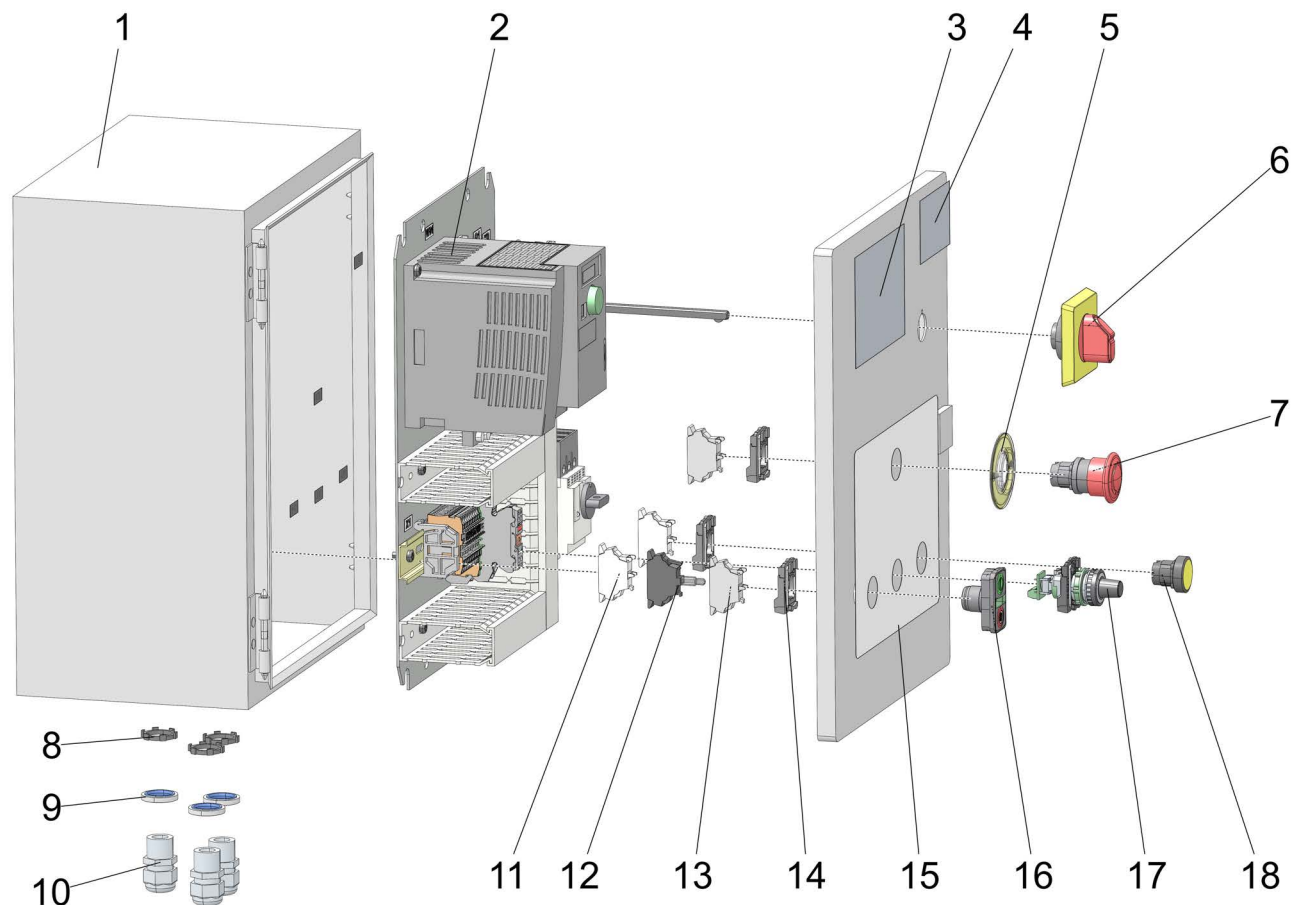
REF	PART #	DESCRIPTION	COMMENTS	QTY.
15	F05005-118	Screw, 1/4-20x1 FHS		24
16	130469	Channel, CG7-2060 Chain Guide		4
17	117869	Weldment, Incline Section		1
18	118102	Weldment, Incline Leg Short		1
19	118101	Weldment, Incline Leg Long		1
20	F05007-53	Bolt, 3/8-16x1 3/4 SHC		8
21	F05011-3	Washer, 3/8 Flat SAE		16
22	F05010-222	Nut, 3/8-16 Flanged Hex Nylock		8
23	117978	Weldment, Link Profile		2
24	F05007-103	Screw, 3/8-16x3 SHC		8
	117977	Assembly, Adjustable Foot		4
25	117846	Weldment, Adjustable Foot		4
26	F05010-5	Nut, 5/8-11 Hex		8
27	117955	Ass, Emergency Cable Tension	(See Section 6.9)	2

6.9 Conveyor Emergency Cable Tension



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	117955	Assembly, Emergency Cable Tension		1
1	117946	Bracket, Emergency Cable Switch Mount		1
2	F05011-11	Washer, 1/4 SAE Flat		4
3	F05010-220	Nut, 1/4-20 Flanged Hex Nylock		2
4	F05005-26	Screw, 1/4-20x3/4 BO SHC		2
5	F05005-91	Bolt, 1/4-20x2 Eye		1
6	015479	Spring, 3/4x2 7/8x12Ga		1
7	117954	Assembly, Safety Switch Cable		1
8	F05010-63	Nut, 1/4-20 Free Hex		2

6.10 Chain Conveyor Control Box



TDCPI-05

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	121243	Assy, Enclosure, CP-xxC-EAxx	240V Single Phase	1
	121246	Assy, Enclosure, CP-xxC-EBxx	240V Three Phase	1
	121249	Assy, Enclosure, CP-xxC-ECxx	480V Three Phase	1
1	121252	Enclosure, Modified, CP-xxC		1
2	121244	Assy, PNL, CP-xxC-EAxx		1
	121247	Assy, PNL, CP-xxC-EBxx		1
	121250	Assy, PNL, CP-xxC-ECx		1
3	068573	Decal, Arc Flash Warning		1
4	121243-NPLBL	Label, Nameplate, 121243		1
	121246-NPLBL	Label, Nameplate, 121246		1
	121249-NPLBL	Label, Nameplate, 121249		1
5	050992	Legend, Ø60mm E-Stop		1
6	050883-1	Handle, Disconnect RED/YEL 6mm Shaft		1
7	068940	Push-Button, Mshrm Mntnd Red TrnRI ZB5		1
8	E20461	Nut, 1/2 npt Connector Lock		3
9	E20460	Ring, 1/2 Sealing		3

REF	PART #	DESCRIPTION	COMMENTS	QTY.
10	051299	Connector, 1/2" NPT .17-.47		3
11	068920	Contact Block, NO ZB5		2
12	068910	Light Module, Green ZB5		1
13	068921	Contact Block, NC ZB5		2
14	068951	Switch Collar, Mount ZB5		3
15	121262	Decal, XTrans Conv		1
16	068909	Push Button, Grn/Red Marked Flush		1
17	068582	Potentiometer, 22mm 4.7k-Ohm		1
18	068902	Push Button Head, Flush Yellow		1