

# **Wood-Mizer®**

## **SLPT-016**

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

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**SLPT-016**

**rev. 1.00**

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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.

*Form #SLPT-016*

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Wood-Mizer is committed to providing you with the latest technology, best quality and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we're meeting current wood-processing demands. Your comments and suggestions are welcome.

### *General Contact Information*

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Koło, Nagórna 114 St, Poland at **+48-63-2626000**. From the continental U.S., call our U.S. Headquarter 8180 West 10th St. Indianapolis, IN 46214, toll-free at **1-800-525-8100**. Ask to speak with a Customer Service Representative. Please have your machine identification number and your customer number ready when you call. The Service Representative can help you with questions about the operation and maintenance of your machine. He also can schedule you for a service call.

### **Office Hours:**

| Country | Monday - Friday | Saturday       | Sunday |
|---------|-----------------|----------------|--------|
| Poland  | 7 a.m.- 3 p.m.  | Closed         | Closed |
| US      | 8 a.m.- 5 p.m.  | 8 a.m.- 12 p.m | Closed |

Please have your vehicle identification number and your customer number ready when you call.

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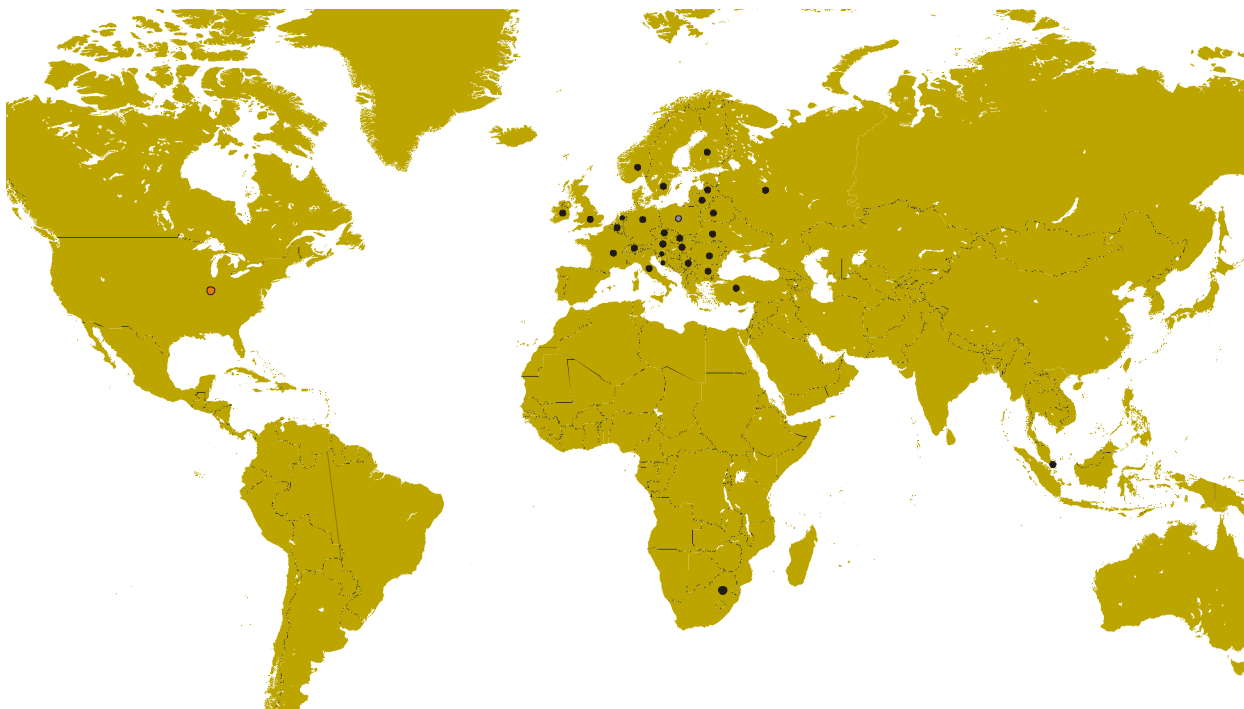
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order.

Technical data are subject to change without prior notice.

Actual product may differ from product images. Some illustrations show machines with optional equipment.

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## Branches & Authorized Sales Centers

For a complete list of dealers, visit [www.woodmizer.com](http://www.woodmizer.com)

## SECTION 1 SERVICING THE SLPT LINE

### 1.1 General Information

Wood-Mizer is committed to providing you with the latest technology, best quality and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we're meeting current wood-processing demands. Your comments and suggestions are welcome.

The present documentation contains information that should be used when preparing the machine for operation, working with it and when servicing or repairing it, as well.

The SLPT line is intended for sawing and processing wood only. See Section Specifications for board size capacities of the machine. The machine must not be used for any other purposes such as cutting ice, metal or any other materials.

Using the machine correctly, you will obtain a high degree of accuracy and efficiency.

The SLPT line should be operated only by an adult (18 and more years old) who has read and understood the entire operator's manual. The SLPT line is not intended for use by or around children.

The machine is built to be durable and easy to operate and maintain.

### 1.2 If You Need To Order Parts

From Europe call our European Headquarters and Manufacturing Facility in Koło, Nagórna Street, Poland at **+48-63-2626000**. Please have the vehicle identification number and your customer number ready when you call. Wood-Mizer will accept these methods of payment:

- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order. In most cases, items will ship on the day they are ordered. Second Day and Next Day shipping are available at additional cost.

### 1.3 Customer and SLPT Line Identification

Each Wood-Mizer SLPT line has its own serial number. In addition, when you pick up your SLPT line, you will receive a customer number. These two numbers will help expedite our service to you. Please locate them now and write them below so you can access them fast and easily when needed.

# 1 SERVICING THE SLPT LINE

## If You Need Service

See figure 1-1 An exemplary identification plate is described below.

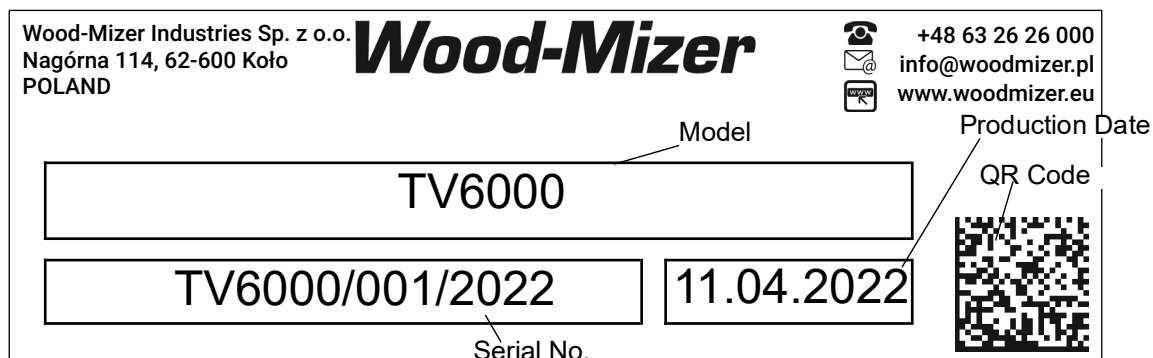


FIG. 1-1

## 1.4 If You Need Service

From Europe call our European Headquarters and Manufacturing Facility in Koło, Nagórna Street, Poland at **+48-63-2626000**. Ask to speak with a Customer Service Representative. Please have the vehicle identification number and your customer number ready when you call. The Service Representative can help you with questions about the operation and maintenance of your moulder. He also can schedule you for a service call.

### Office Hours:

| Country | Monday - Friday    | Saturday | Sunday |
|---------|--------------------|----------|--------|
| Poland  | 8.00 am - 04:30 pm | Closed   | Closed |

## 1.5 SLPT Line Main Components

See figure 1-2 The main components of the SLPT-016 line are shown below.

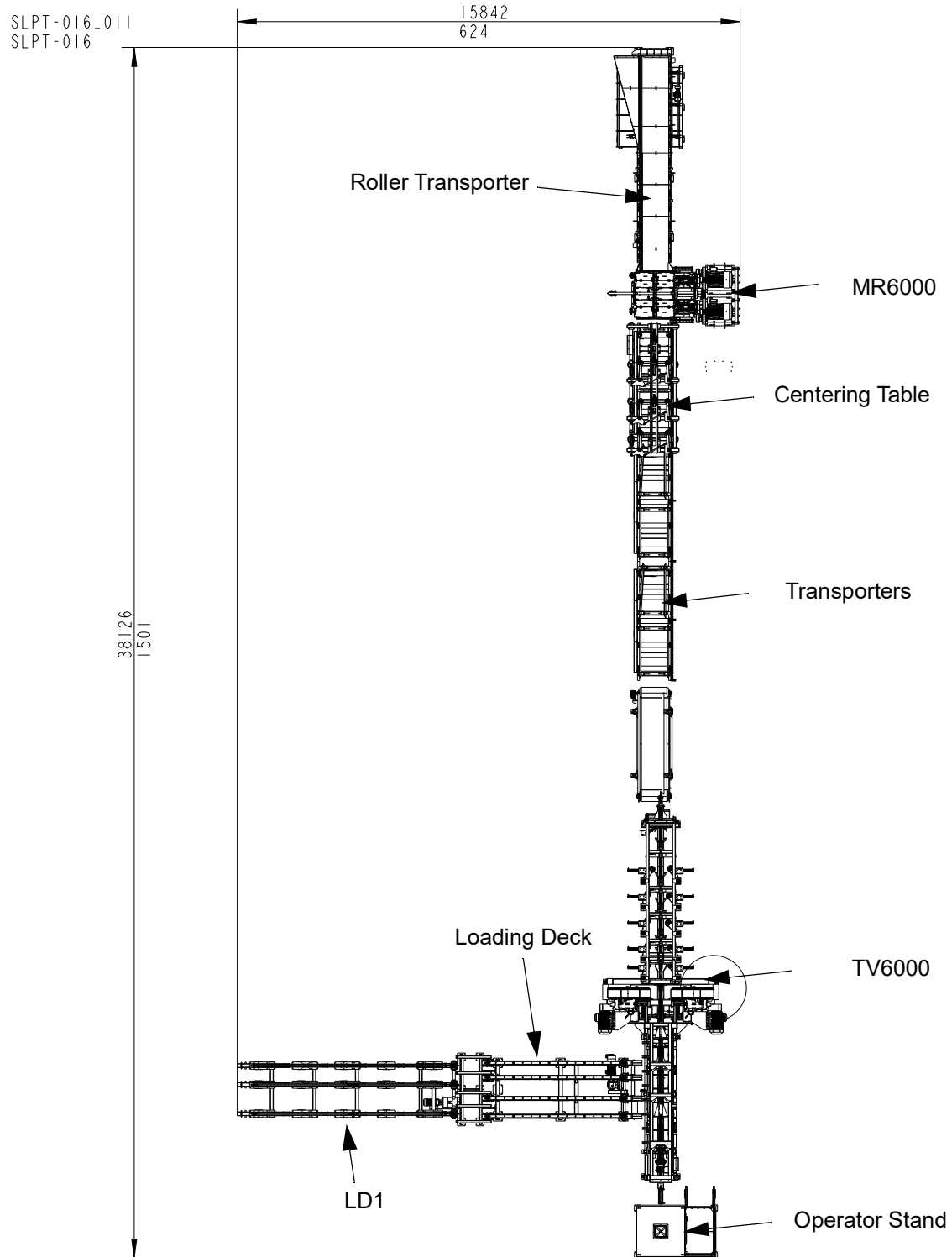


FIG. 1-1 SLPT-016 LINE

## SECTION 2 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 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 to persons or 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.



## 2.2 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.

### *Observe Safety Instructions*



**IMPORTANT!** Read the entire Owner's Manual before operating the SLPT line. Take notice of all safety warnings throughout this manual and those posted on the machines. Keep this manual with this line 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 SLPT line. The SLPT line is not intended for use by or around children.

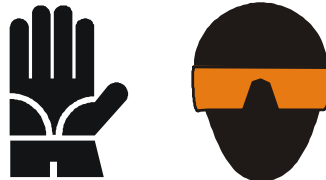


**IMPORTANT!** It is always owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer SLPT line. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the SLPT line.



***Wear Safety Clothing***

**WARNING!** Secure all loose clothing and jewelry before operating the SLPT line. Failure to do so may result in serious injury or death.



**WARNING!** Always wear safety goggles and gloves when replacing the blade. Changing blades is safest when done by one person! Keep all other persons away from work area when changing a blade. Failure to do so may result in serious injury.

**WARNING!** Always wear eye, ear, respiration, and foot protection when operating or servicing the machine.

***Keep The SLPT Line And Area Around the SLPT Line Clean***

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

***Dispose of Sawing By-Products Properly***

**IMPORTANT!** Always properly dispose of all sawing by-products, including sawdust and other debris.

***Check The SLPT Line Before Operation***

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

***Keep Persons Away***

**DANGER!** Always remember to keep all persons out of the path of moving equipment and boards before turning on or while operating the SLPT line. Failure to do so may result in serious injury.

***Keep Hands Away***

**DANGER!** Keep your hands away from the moving chain. Failure to do so may result in serious injury.



**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.



***Use Proper Maintenance Procedures***

**DANGER!** Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.



**DANGER!** Hazardous voltage inside the electric and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during the SLPT line operation.



**WARNING!** Consider all electrical circuits energized and dangerous.



**WARNING!** Disconnect and lock out power supply before servicing! Failure to do so may result in serious injury.



**IMPORTANT!** The SLPT line is equipped with emergency stop buttons. They are used to immediately stop the line in hazardous situations. The e-stop buttons should always be in proper working condition.



**WARNING!** Never assume or take the word of another person that the power is off; check it out and lock it out.



**WARNING!** Do not wear rings, watches, or other jewelry while working around an open electrical circuit.



**CAUTION!** The sawmill's work-stand should be equipped with a 4 kg or bigger dry powder extinguisher.



**CAUTION!** Never clean the blade or the blade wheels with a brush or a scraper during sawmill operation.



**IMPORTANT!** When the work is finished the blade tension should be released. Before turning the motor on, the blade should be tensioned once again.



**WARNING!** If the blade or drive belt break, wait until all rotating parts are completely stopped. Failure to do so may result in serious injury or death.



**CAUTION!** Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.



**CAUTION!** Always wear gloves when handling the blade. Never grab the blade with bare hands!



**CAUTION!** If the blade breaks during sawmill operation, push the EMERGENCY STOP button to stop the blade motor and wait 10 seconds before you open the blade housing cover.

### ***Keep Safety Labels In Good Condition***



**IMPORTANT!** Always be sure that all safety warning decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact Wood-Mizer Customer Service or the Wood-Mizer distributor in your area to order a new decal.

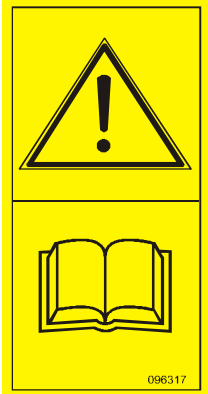


**IMPORTANT!** If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed.

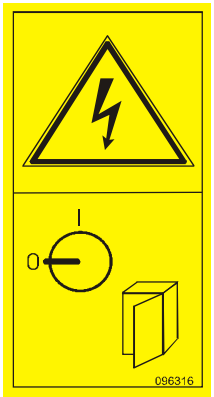
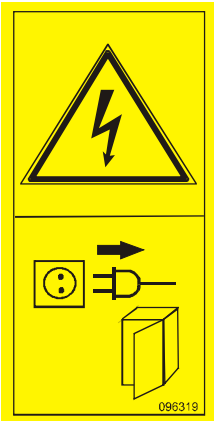
**Safety Labels Description**

**See table 2-1.** See the table below for descriptions of the safety labels placed on the SLPT line.

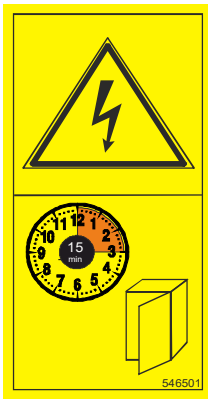
**TABLE 2-1**

| Label View                                                                          | Label Number | Description                                                                                                                               |
|-------------------------------------------------------------------------------------|--------------|-------------------------------------------------------------------------------------------------------------------------------------------|
|    | 096317       | CAUTION! Read thoroughly the manual before operating the SLPT line. Observe all safety instructions and rules when operating the machine. |
|  | 099220       | Close all guards and covers before starting the machine.                                                                                  |
|  | 099221h      | CAUTION! Keep all persons within a safe distance from work area while operating the SLPT line.                                            |

**TABLE 2-1**

|                                                                                     |        |                                                                                 |
|-------------------------------------------------------------------------------------|--------|---------------------------------------------------------------------------------|
|    | 096314 | Keep all persons a safe distance away from work area when operating the unit.   |
|   | 096316 | Do not open the electric box when the switch <b>is not</b> in the "0" position. |
|  | 096319 | Always disconnect the power cord before opening the electric box!               |

**TABLE 2-1**

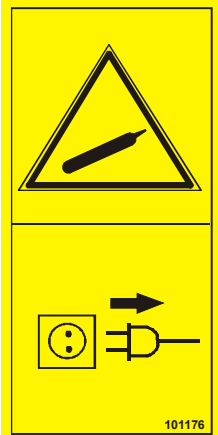
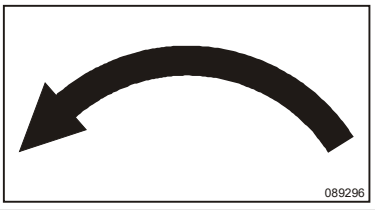
|                                                                                     |        |                                                                                                                  |
|-------------------------------------------------------------------------------------|--------|------------------------------------------------------------------------------------------------------------------|
|    | 546501 | CAUTION! After turning off the power of the SLPT line, wait at least 15 minutes before opening the electric box. |
|   | 099540 | CAUTION! Toothed gear - keep persons away!                                                                       |
|  | 509255 | CAUTION! Hand injury hazard. Stay within a safe distance from the rotating elements.                             |



**TABLE 2-1**

|                                                                                     |         |                                                                |
|-------------------------------------------------------------------------------------|---------|----------------------------------------------------------------|
|    | S12004G | Always wear safety goggles when operating the equipment!       |
|    | S12005G | Always wear protective ear muffs when operating the equipment! |
|   | 501465  | Always wear safety boots when operating the equipment!         |
|  | P85070  | CE Certified Machine (Small)                                   |
|  | S20097  | Motor Rotation Direction                                       |

TABLE 2-1

|                                                                                     |        |                                                                               |
|-------------------------------------------------------------------------------------|--------|-------------------------------------------------------------------------------|
|    | 101176 | CAUTION! Compressed air in the system even after electric power disconnection |
|    | 513181 | Pressure value of the pneumatic system                                        |
|  | 089296 | Rotation direction                                                            |
|  | 532260 | CAUTION! Risk of falling from a height                                        |

**TABLE 2-1**

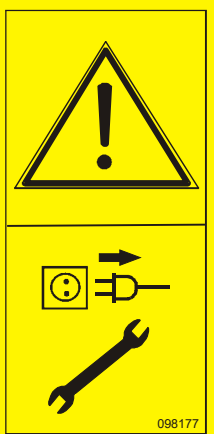
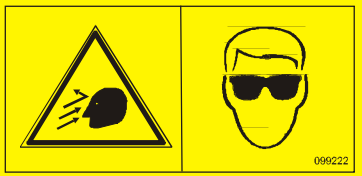
|                                                                                     |        |                                                                                 |
|-------------------------------------------------------------------------------------|--------|---------------------------------------------------------------------------------|
|    | 524992 | CAUTION! Board ejection danger                                                  |
|   | 098177 | Disconnect power supply before servicing.                                       |
|  | 099222 | Sawdust chute warning. Always wear safety goggles when operating the equipment. |

TABLE 2-1

|                                                                                                                                                                                                                                                                                                                                                                                                                                                             |        |                  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|------------------|
|  A yellow rectangular safety label. The top half features a black and white illustration of a gate with vertical bars, slightly ajar, with red arrows indicating the open position. The bottom half features a red octagonal stop sign with the word "STOP" in white capital letters. The number "532259" is printed in small black text at the bottom right of the label. | 532259 | STOP - gate open |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|------------------|

## SECTION 3 OPERATION

### 3.1 SLPT Line Setup



**IMPORTANT!** Before starting to use the sawmill, you have to meet the following conditions::

- Set up the machines and conveyors on firm, level ground. Fasten the machines and conveyors to the ground to prevent moving during operation. A concrete foundation (rated to support 40t/m<sup>2</sup> (8193 lbs/ft<sup>2</sup>) at each sawmill foot position) and 16mm (0.62", 5/8") anchored bolts are recommended.
- The machines must not be operated without a sawdust extraction system connected and started.



**DANGER!** The sawdust extraction conveyor needs to be grounded.

- The machines should be operated under roof only.
- The machines can be operated in the temperature range of -15°C to 40°C (5 °F to 104 °F)
- The intensity of light at the operator's work-place must be at least 300lx<sup>1</sup>.

---

1. The light cannot cause stroboscopic effect.

# 3 **OPERATION** *SLPT Line Setup*

See Figure 3-1. The operators' workplace is shown in the figure below.

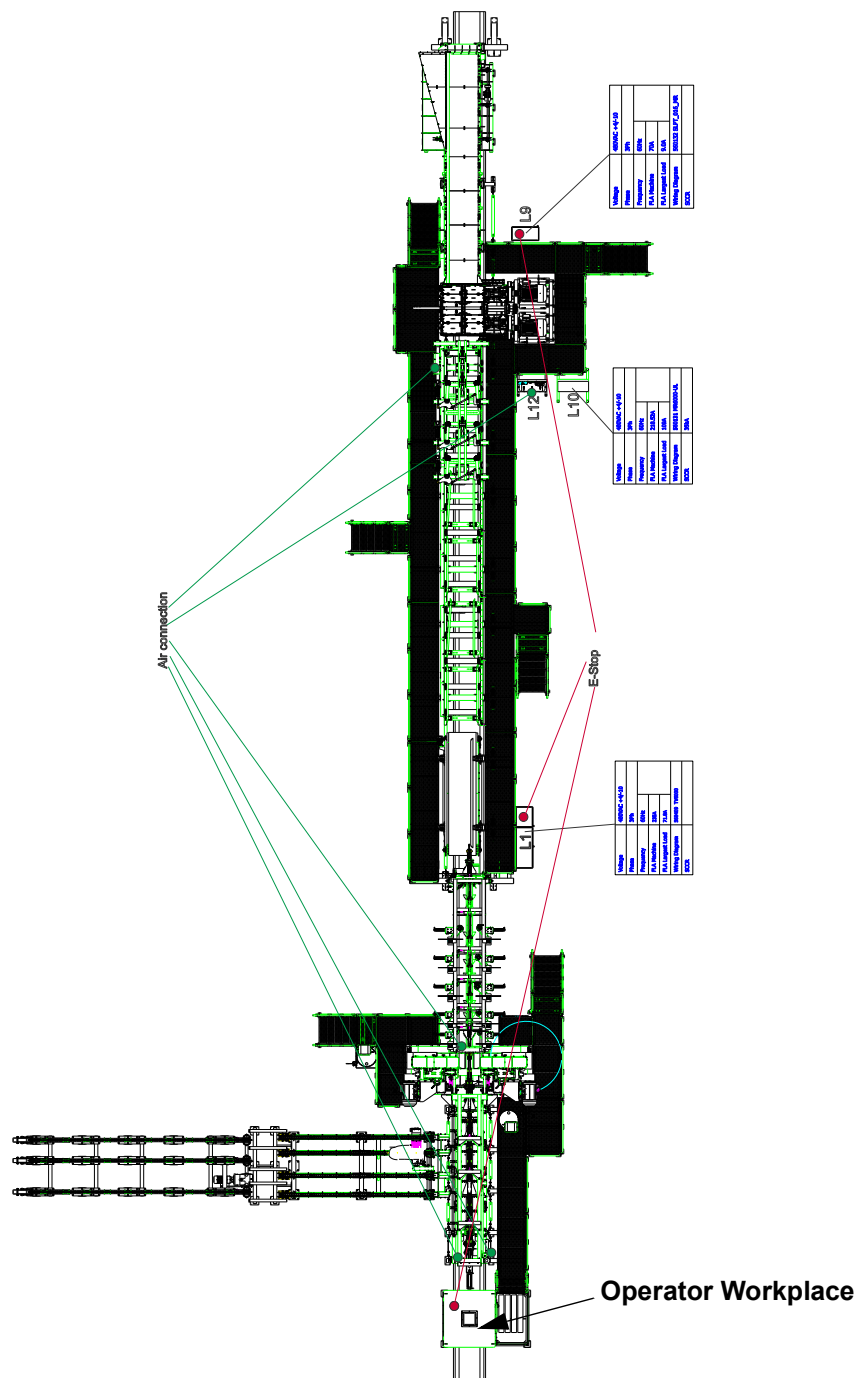


FIG. 3-1 SLPT LINE



**IMPORTANT!** Be sure that all persons are away from the sawmill before starting it.



**IMPORTANT!** Despite the installation of a safety fence, it is not possible to fence off all persons from the other side of the SLPT line, due to the need to feed logs and collect the sawn material.

- Have a qualified electrician install the power supply (according to EN 60204 Standard). The power supply must meet the specifications given in the table below.

See table 3-1.

|                                    | Voltage          | Phase | Freq | FLA Machine | FLA Largest Load | Wiring Diagram        | SCCR |
|------------------------------------|------------------|-------|------|-------------|------------------|-----------------------|------|
| <b>Power Supply L1 Parameters</b>  | 480VAC<br>+4/-10 | 3Ph   | 60Hz | 235A        | 71.8A            | 568409<br>TV6000      |      |
| <b>Power Supply L9 Parameters</b>  | 480VAC<br>+4/-10 | 3Ph   | 60Hz | 218.52A     | 109A             | 560131<br>MR6000-UL   | 35kA |
| <b>Power Supply L10 Parameters</b> | 480VAC<br>+4/-10 | 3Ph   | 60Hz | 70A         | 9A               | 560132<br>SLPT_016_MR |      |

**TABLE 3-1**



**IMPORTANT!** When starting the machine for the first time, check if the main motor rotation direction is as indicated by the arrow located on the motor body (fan guard). If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation direction of all sawmill motors.



**DANGER!** It is recommended to use a 30mA Ground Fault Interrupter (GFI).

- Make sure the pressure gauge shows 0.6MPa (6bar). Adjust the pressure if necessary. To adjust the air pressure, turn the pressure regulator: clockwise to increase the pressure, counterclockwise to decrease it; lowering the cap. A shut-off valve should be used to disconnect the air supply and release compressed air from the hydraulic system. During operation, the valve should be in the “SUP.” position, and in order to release compressed air, the valve should be in the “Exh.” position.



**WARNING!** Before starting any service work, disconnect the air supply and release compressed air from the air

system! Failure to do so may result in serious injury..

See Figure 3-2.

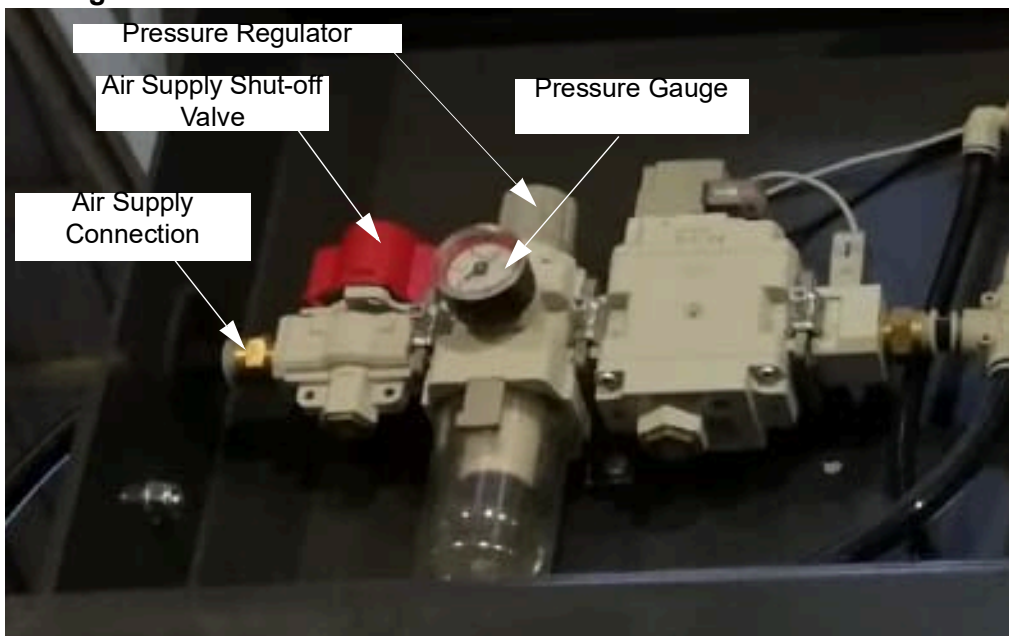


FIG. 3-2



**IMPORTANT!** If at any time you need to immediately stop the SLPT line operation, press one of the Emergency Stop (E-Stop) buttons located on the line.

Turn and pull the Emergency Stop button to unlock the SLPT line operation.

See Figure 3-3.



FIG. 3-3 EMERGENCY STOP BUTTON



## EMERGENCY STOP BUTTONS ARRANGEMENT:

See Figure 3-4. There are three places where E-Stop buttons are placed:

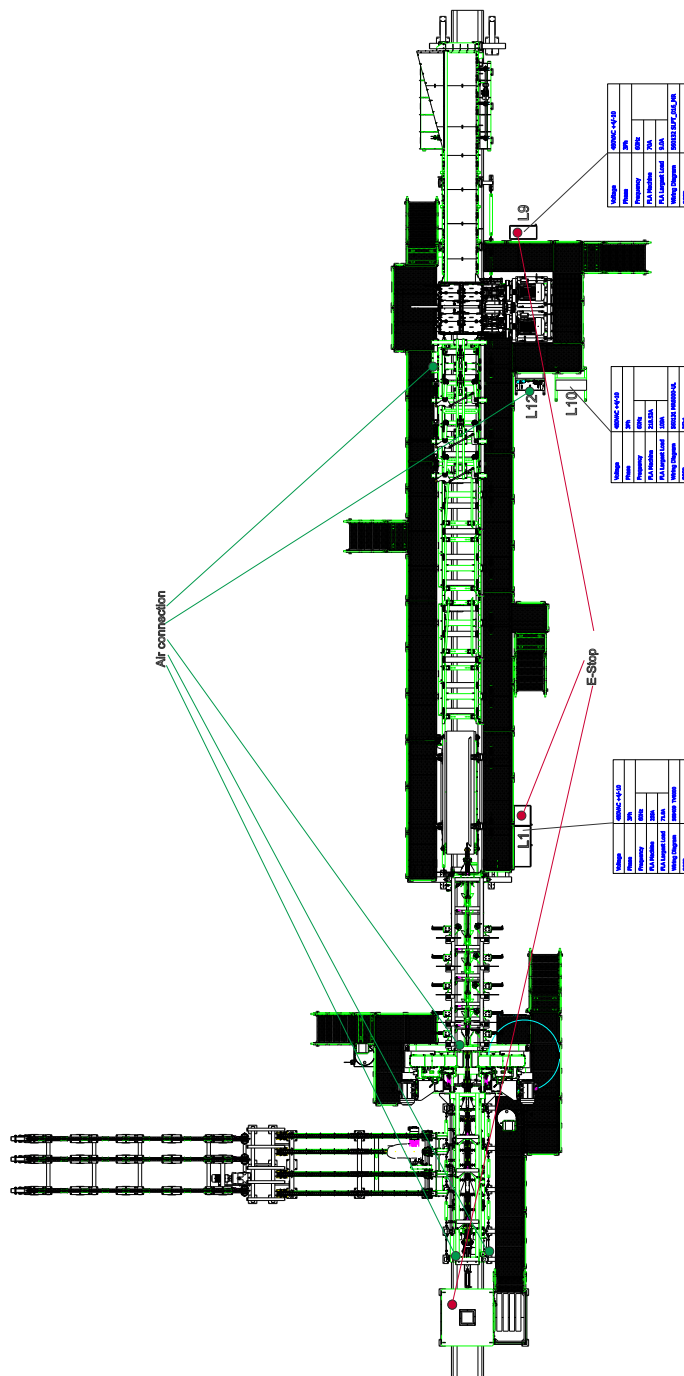
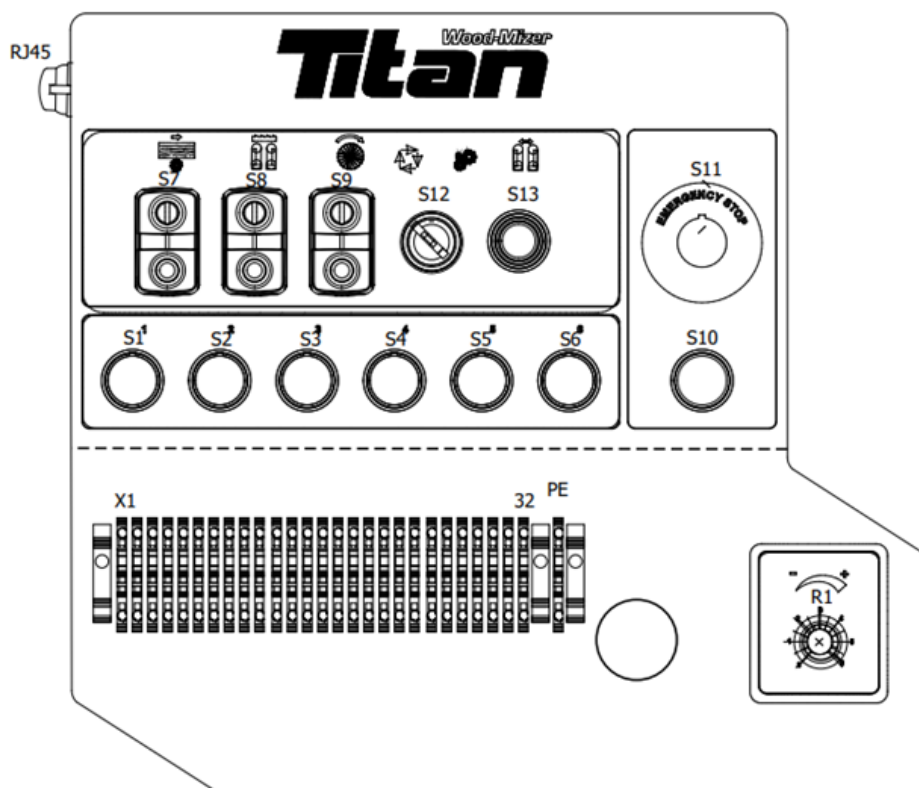


FIG. 3-4 SLPT LINE

## SECTION 4 CONTROL PANEL, HMI

### 4.1 Control panel description

See Figure 4-1.



**FIG. 4-1 SLPT-016 CONTROL PANEL**

- S1 – S6 buttons – TV6000 saw head position memory buttons. Six programmable buttons the operator can use to move the saw head to a preset position in the Automatic mode. To program the saw head positions, enter the Settings menu and choose "Preset Memory".
- S7 Start/Stop button – starts all drives on the line. The feed can be started in the automatic mode only, after starting the blade drives, i the TV6000 and MR6000. It is not possible to start the line in the Automatic mode if certain external conditions are not met (starting additional equipment).
- S8 Start/Stop button – starts the TV6000 main motors. The motors start in a certain sequence, i.e. after the right motor is fully started, the left motor starts. They stop at

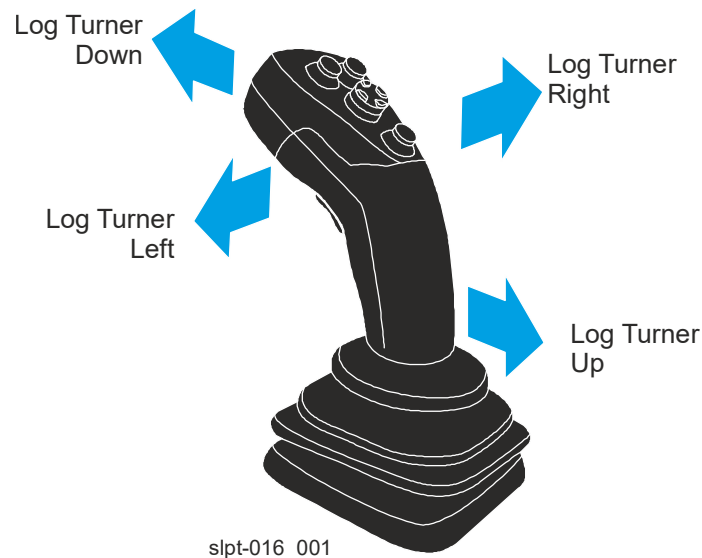
the same time. The motors can be started only when the MR6000 motors are not running or startup of the motors has already been completed. It is not possible to start the line in the Automatic mode if certain external conditions are not met (starting additional equipment).

- S9 Start/Stop button – starts the MR6000 main motors. The motors start in a certain sequence, i.e. after the lower motor is fully started, the upper motor starts. They stop at the same time. The motors can be started only when the TV6000 motors are not running or startup of the motors has already been completed. It is not possible to start the line in the Automatic mode if certain external conditions are not met (starting additional equipment).
- S12 switch – used to switch between the modes of operation: Manual and Automatic. When this switch is in the Manual position, sawing is not possible, each function can be controlled manually and the main motors can be started. When the line is controlled manually, the external conditions do not have to be met. It is also not necessary to disable all functions activated in this mode; they will be disabled automatically when switching from the Manual to Automatic mode (including the main motors if they have been started). In the Automatic mode all functions of the line work automatically and all external conditions have to be met. If, during normal operation of the line in the Automatic mode, the mode is switched to the Manual mode, the line will be turned off immediately.
- S13 button – for setting the TV6000 saw heads in the blade replacement position. Pressing this button when the line is not working and the operation mode switch is switched to Manual, will cause the saw heads to move to the blade replacement position (the heads will move all the way out, to the position when the covers can be opened).
- S11 button – emergency stop button of the line
- S10 button – for resetting the safety circuit. It is necessary to reset the safety circuit each time the line is turned on after activating any of the safety switch.
- R1 potentiometer – used to set the feed rate of the line in the Automatic mode. In the Manual mode the feed rate is set for each drive separately.
- RJ45 connector – service connector used for programming

**Operator's Joystick:**

Before the first use of the line, or when the joystick works incorrectly, perform calibration of the joystick – see "Settings" for more information. These functions are also available in the Manual mode.

See Figure 4-2.



**FIG. 4-2**

**Joystick Control Overview:**

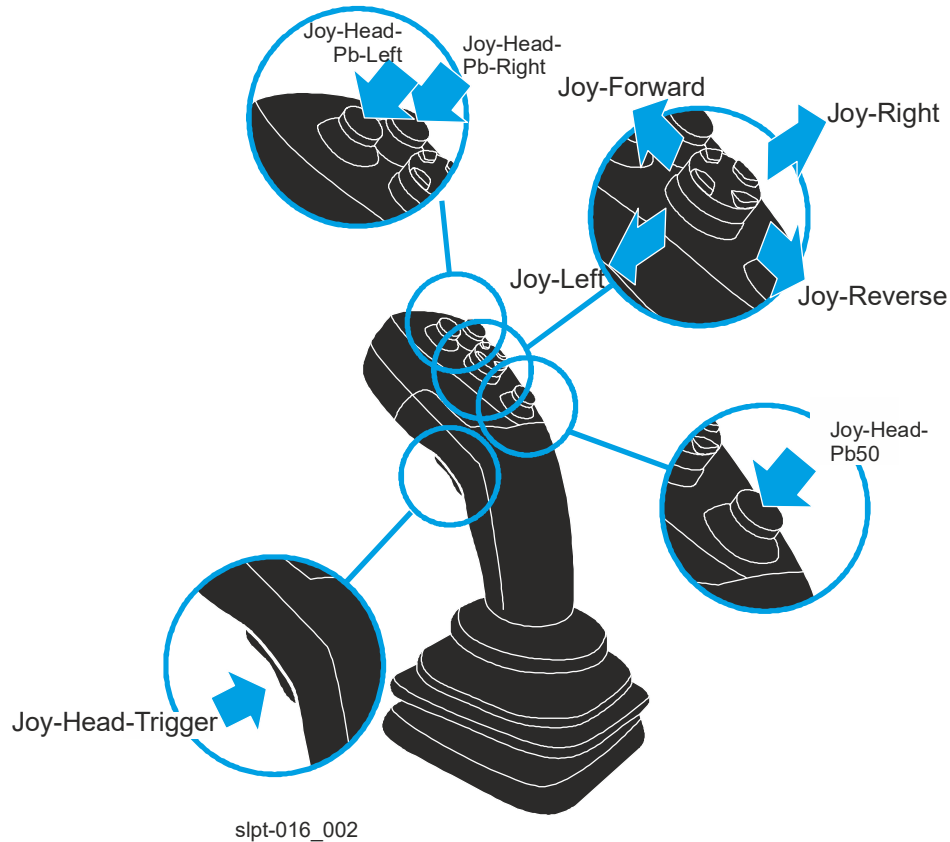
Pushing the joystick **left** turns the log turner left. To increase the speed of log rotation, push the joystick harder.

Pushing the joystick **right** turns the log turner right. To increase the speed of log rotation, push the joystick harder

Push the joystick **backward** to raise the log turner.

Push the joystick **forward** to lower the log turner.

See Figure 4-3. Joystick Buttons Description:



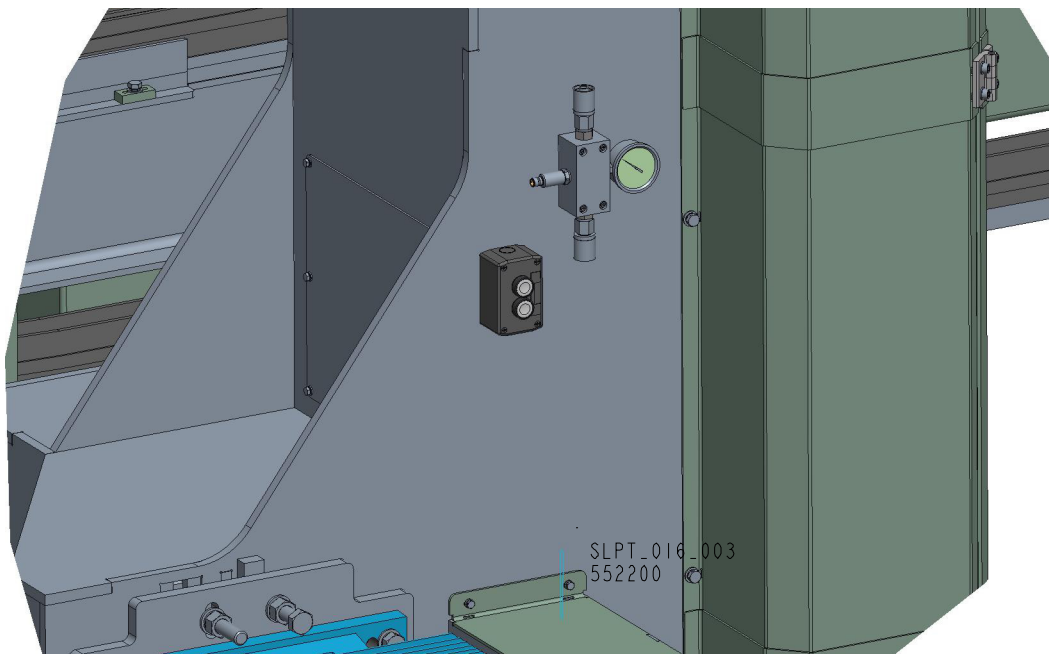
**FIG. 4-3**

- Joy-Head Trigger – press to load a log onto the log turner (if the turner is in its upper position).
- Joy- Head\_Pb Left – press to activate the debarkers in the Automatic mode.
- Joy\_Head-Pb Right – pressing this button turns off and raises the debarkers in the Automatic mode.
- Joy-Head-Pb – pres200s to turn on the Incline Log Deck in the Automatic mode.
- Joy-Reverse – press to activate the Log Deck and move it forward.
- Joy-Forward – press to move the Log Deck backward.

**Tensioning the blades:**

The saw heads are equipped with UP and DOWN arrow buttons. To tension the blade, place the mode selection switch in the Manual position and press the UP arrow button. The hydraulic pump will be activated and the hydraulic cylinder will be filled with hydraulic fluid. The filling process will be automatically stopped when the pressure value, shown on the pressure gauge next to the control cassette, reaches the value set in the “Settings” menu of the TV6000 saw. Then it is necessary to close the manual valve located next to the cassette. To loosen the blade, activate the Manual mode of operation and open the manual valve. Next, press the DOWN arrow button. After pressing this button, pressure will be released from the cylinder and the blade will be loosened

See Figure 4-4.



**FIG. 4-4**

## 4.2 HMI Interface

After starting the control system appears the main screen:

See Figure 4-5.

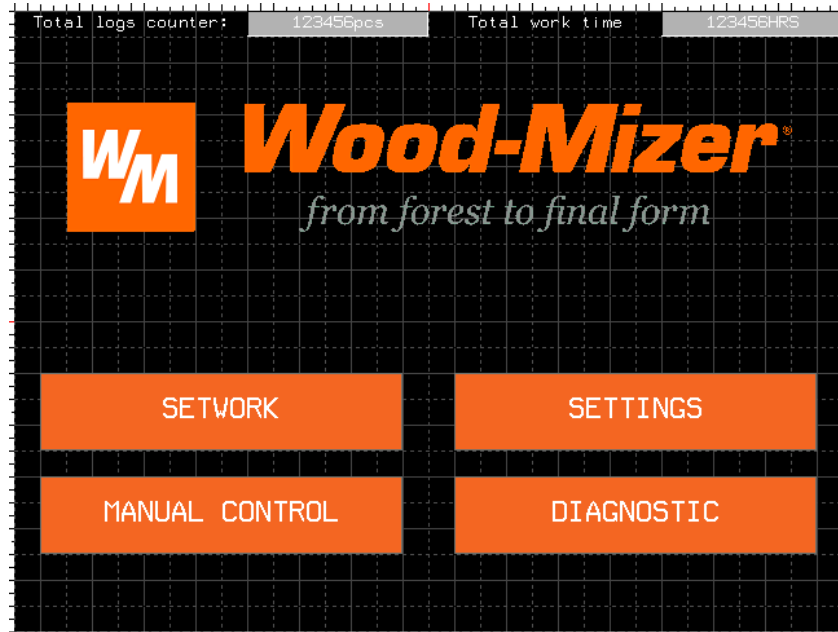


FIG. 4-5

Description of the touch buttons displayed on the main screen:

- Total logs counter – indicates the number of logs processed on the line; counts logs sawn on the TV6000 saw.
- Total work time – counts the total runtime of the line in the Automatic mode (in hours).
- Setwork – after pressing this button, the Setwork menu can be accessed.
- Settings – press to enter the Settings menu.
- Manual control – after pressing this button, the Manual mode of operation is activated. In this mode each function can be controlled individually. It works only after switching the operation mode switch to the Manual position.
- Diagnostic – press to display the diagnostic menu where the inputs, outputs and diagnostics of each drive can be viewed.

### Setwork Menu

See Figure 4-6.

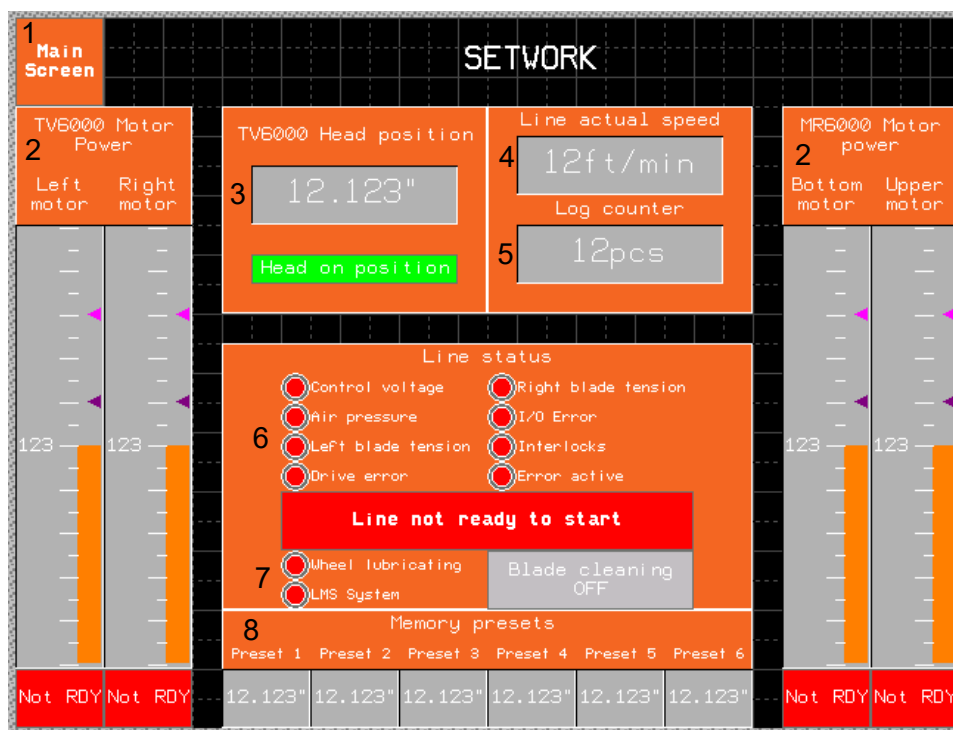


FIG. 4-6

1. **Main Screen** button – press to return to the main menu

2. **TV6000 Motor Power** and **MR6000 Motor Power**

This indicator shows actual values of current for the left and right TV6000 motor. If the rated motor current is exceeded, the colour of the indicator will change to orange after the first threshold is exceeded, and to red after the second threshold is exceeded.

The current states of the motors are shown at the bottom of the indicator:

Not RDY – the motor is not running or currently is being started,

READY – the motor start-up is completed

3. **TV6000 Head position**

This indicator shows current TV6000 saw head positions. The values are displayed in the units of measure selected in the Settings menu.



The inscription below the current saw head position value indicates that the TV6000 saw heads are positioning. When the saw heads start moving, "Head on position" changes to "Positioning".

#### **4. Line actual speed**

This indicator shows the feed rate of the line (actual MR6000 feed rate).

#### **5. Log counter**

The log counter indicates the number of logs already processed. It can be reset in the Settings menu.

#### **6. Line status**

It is impossible to start the line if all conditions listed in this section are not met (all lights must be green). In such a case, the message "Line not ready to start" is displayed. The operator can start the line if the message "Line ready to start" appears on the screen (all conditions for starting the line are met). When the line is already started, the inscription will change to "Line is working".

#### **7. Wheel lubricating. LMS System.**

The operating status of the LMS System and wheel lubrication system can be checked in this place on the screen. The wheel lubrication system is activated automatically after the second TV6000 motor has been started and cannot be turned off for technical reasons. It is only possible to select its mode of operation in the Settings menu of the TV6000 saw. The indicator Wheel lubricating indicates the operating status of this system. The blade cleaning system can be activated automatically after the line is started (if such an option is selected in the TV6000 Settings menu), or it can be turned on manually by using the Blade cleaning key shown above. Both systems can work in a continuous or pulsating mode that must be selected in the TV6000 Settings menu.

#### **8. Memory presets**

This section contains six saw head positions stored in the Networks memory (the unit of measure is selected by the user). The values can be changed in the Setting menu.

### Settings Menu

See Figure 4-7.

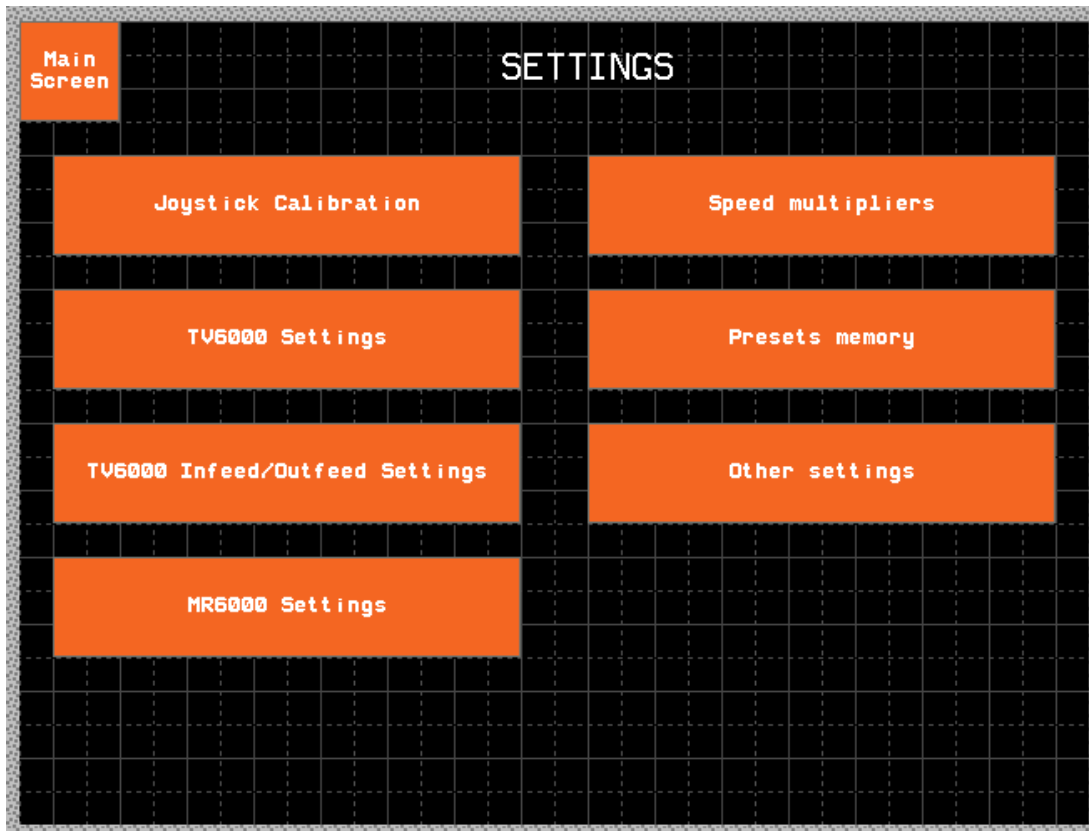


FIG. 4-7

- **Joystick calibration** – press to enter the joystick calibration menu.
- **TV6000 Settings** – use to display the TV6000 settings menu.
- **TV6000 Infeed outfeed settings** – push to access settings of the TV6000 infeed and outfeed table.
- **MR6000 Settings** – use to display the MR6000 settings menu.
- **Speed multipliers** –after pressing, the line speed settings menu is displayed.
- **Presets memory** – push to access the menu of preset saw head positions.
- **Other settings** – press to access the other settings menu.

### Joystick Calibration Menu

See Figure 4-8.

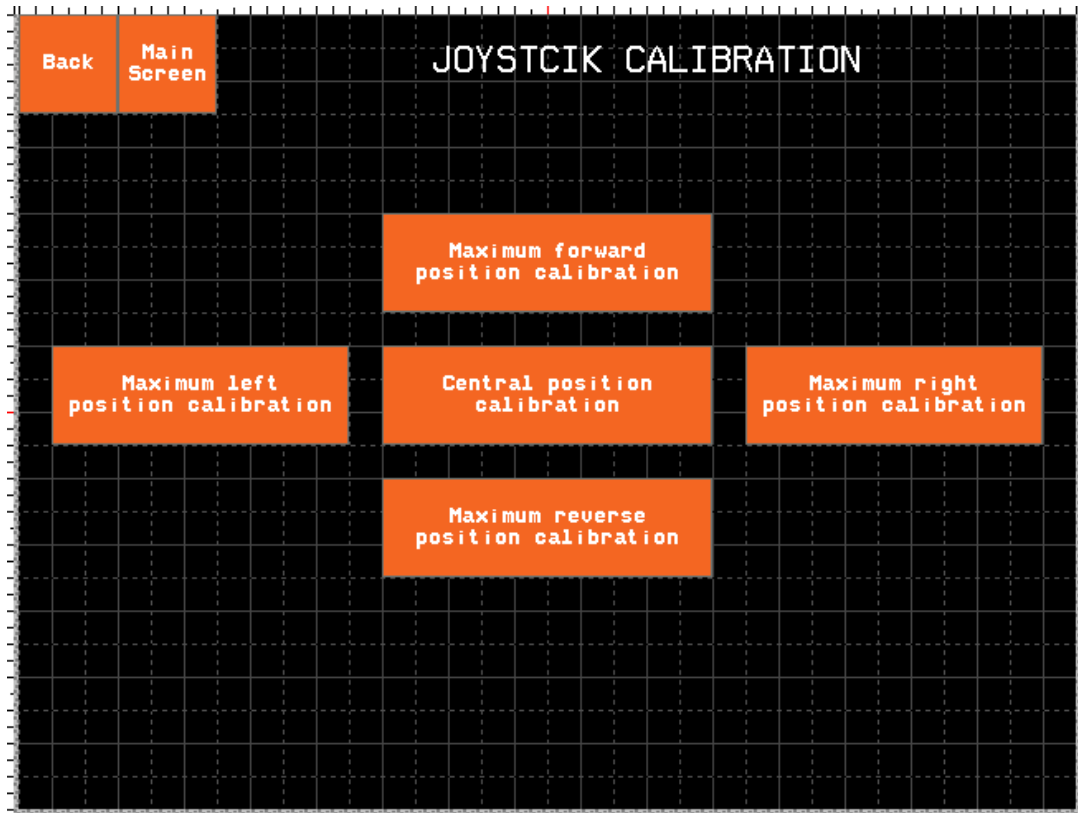


FIG. 4-8

Using this menu, the operator can perform calibration of the analog joystick functions (e.g. after replacement of the joystick or if there is any problem with the control of proportional log rotation). The calibration procedure is performed only once and it is not necessary repeat it if the joystick works correctly.

The calibration procedure can be carried out when the line is turned off and when the operation mode switch is in the Manual position.

- Step 1: When the joystick is in the middle position, press "Central position calibration" button.
- Step 2: Push the joystick all the way forward and, holding it in this position, press "Maximum forward position calibration" button.
- Step 3: Move the joystick all the way backward and, holding it in this position, press "Maximum reverse position calibration" button.

- Step 4: Push the joystick all the way left and, holding it in this position, press "Maximum left position calibration" button.
- Step 5: Push the joystick all the way right and, holding it in this position, press "Maximum right position calibration" button.

### TV6000 Settings Menu

See Figure 4-9.

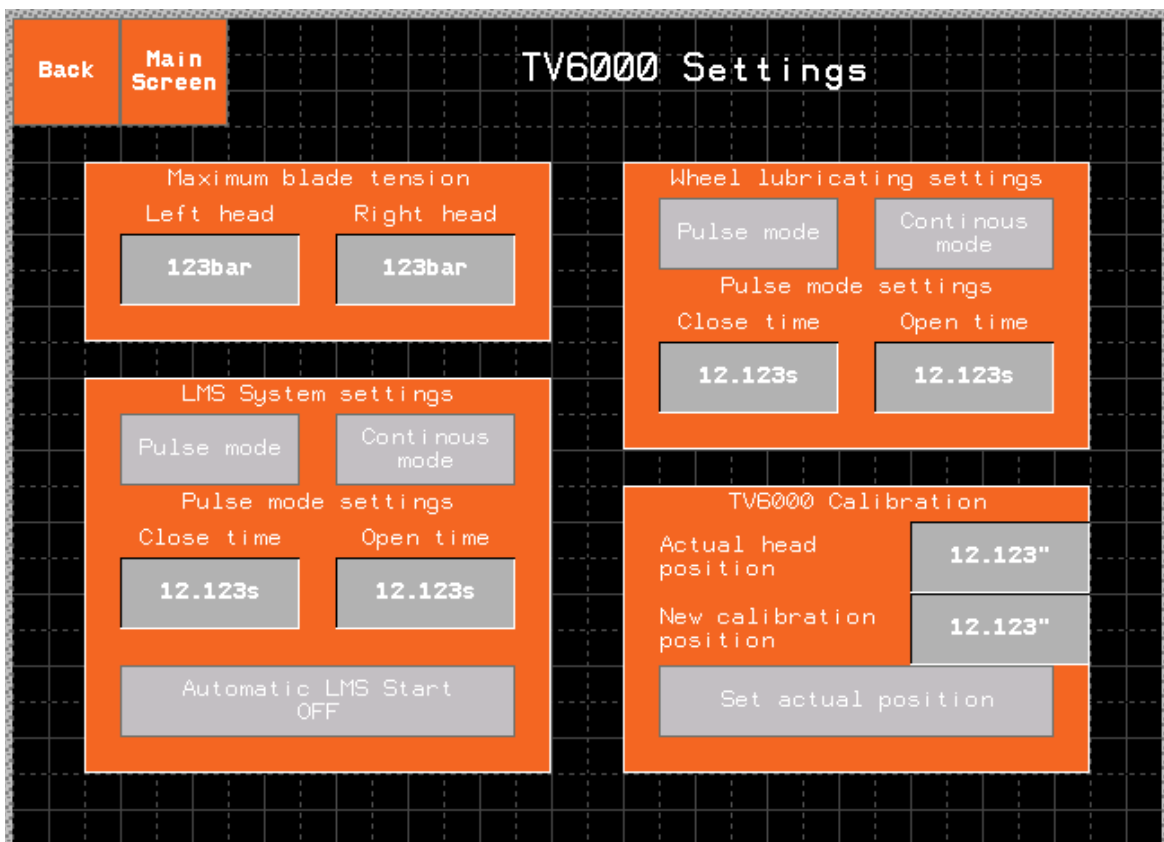


FIG. 4-9

- **Maximum Blade Tension.** In this place on the screen, the operator can set the maximum pressure to which the TV6000 blades will be tensioned. After touching the field, a keypad appears; it can be used to enter the value. When the pressure reaches the preset pressure value during tensioning of the blades, the tension valve will be closed. If during the machine operation, the pressure in the tension system drops 10 bar below the pressure set in this field, an alarm will be displayed. If the blade breaks, or when the pressure drops 25 bar below the set pressure, the TV6000 saw will be turned off and an alarm will be displayed.

- **LMS System Settings.** The following LMS System parameters can be set in this section:

*Pulse mode* – this key places the LMS system in the Pulse mode. In this mode water flows to the blades in a pulsational manner. The water flow time and the time of pauses between successive water flows can be set in the fields Close time and Open time (in seconds). Example: if you want the water to flow to the blades every five seconds for two seconds, enter 5.000 into the Close time field and 2.000 into the Open time field.

*Automatic LMS Start* – use to enable automatic starting of the LMS system along with the main TV6000 motors. If this option is not selected, the LMS system must be activated manually each time the TV6000 machine is turned on (with the Blade cleaning key on the Setworks screen). The LMS system is turned off automatically along with the TV6000 motors. In the Manual mode of operation, only continuous operation of the LMS system is possible (Continuous mode).

- **Wheel lubricating settings.** These keys lets the operator set the mode of operation of the TV6000 wheel lubrication system.

*Pulse mode key* – activates the Pulse mode of the wheel lubrication system. The Close time and Open time are set in the same manner as for the LMS System.

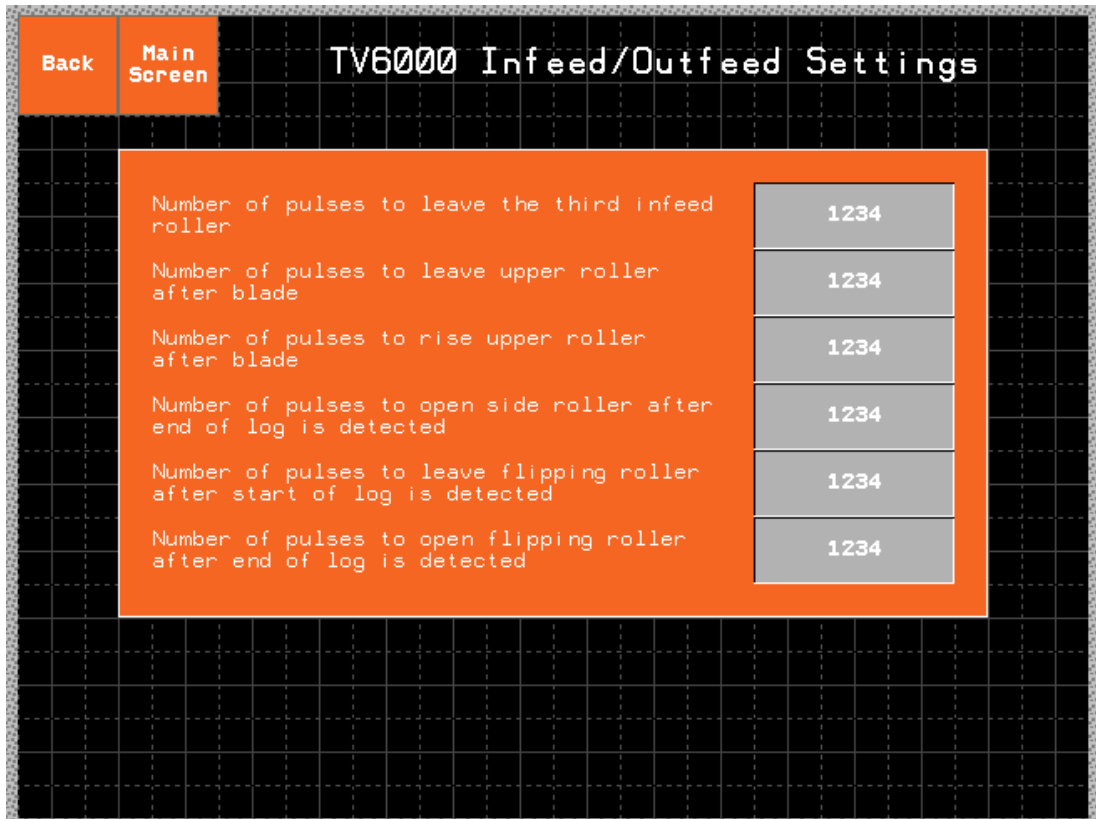
*Continuous mode key* - use to place the wheel lubrication system in the Continuous mode of operation.

The wheel lubrication system is started automatically as soon as the main TV6000 motors are turned on. It turns off as soon as the main TV6000 motors are turned off. The manual control of this system is possible in the Manual mode of the machine only.

- **TV6000 Calibration** – lets the operator calibrate the TV6000 head position. To perform the calibration, measure the distance between the blades when they are tensioned. Then enter the measured value into the "New calibration position" field and confirm the new position using the Set actual position key.

**TV6000 Infeed/Outfeed Settings**

See Figure 4-10.



**FIG. 4-10**

The TV6000 Infeed/Outfeed Settings menu allows the user to preset movements of the rollers on the TV6000 infeed and outfeed tables.

- **Number of pulses to lower the third infeed roller** – in this place the operator can set the number of pulses that will be counted by the feed system encoder to the moment when the third infeed roller starts lowering. The roller will lower later if the preset number of pulses will be higher.
- **Number of pulses to lower upper roller after blade** – the operator can set the number of pulses that will be counted from the moment the third turner sensor detected the rear end of the log to the moment when the TV6000 hold-down roller located behind the blade starts moving up.
- **Number of pulses to rise upper roller after blade** – the operator can set the number of pulses that will be counted from the moment the third turner sensor detected the rear end of the log to the moment when the TV6000 hold-down roller

located behind the blade starts moving up.

- **Number of pulses to open side roller after end of log is detected** – the user can preset the number of pulses that will be counted by the feed system encoder from the moment the third turner sensor detected the rear end of the log to the moment when the side rollers on the outfeed table starts opening.
- **Number of pulses to lower flipping roller after start of log is detected** – the number of pulses that will be counted from the moment the flipping roller sensor detected the front end of the log to the moment when the flipping roller starts lowering.
- **Number of pulses to open flipping roller after end of log is detected** – the number of pulses that will be counted from the moment the flipping roller sensor detected the rear end of the log to the moment when the flipping roller starts opening.

### MR6000 Settings Menu

See Figure 4-11.

The screenshot displays the 'MR6000 Settings' menu on a grid background. At the top left, there are two buttons: 'Back' and 'Main Screen'. The title 'MR6000 Settings' is centered at the top. Below the title, there are two main sections: 'Infeed roller pulses settings' and 'Outfeed roller pulses settings'. Each section contains four settings, each with a text label and a numeric input field showing '1234'.

| Infeed roller pulses settings                  |      |                                               |      |
|------------------------------------------------|------|-----------------------------------------------|------|
| Number of pulses to close first infeed roller  | 1234 | Number of pulses to open first infeed roller  | 1234 |
| Number of pulses to close second infeed roller | 1234 | Number of pulses to open second infeed roller | 1234 |

| Outfeed roller pulses settings                  |      |                                                |      |
|-------------------------------------------------|------|------------------------------------------------|------|
| Number of pulses to close first outfeed roller  | 1234 | Number of pulses to open first outfeed roller  | 1234 |
| Number of pulses to close second outfeed roller | 1234 | Number of pulses to open second outfeed roller | 1234 |

FIG. 4-11

The following settings can be made in the MR6000 Settings menu:

- **Number of pulses to close first infeed roller** – the user can preset the number of pulses that will be counted from the moment the front end of the log was detected to the moment when the first MR6000 infeed roller starts lowering.
- **Number of pulses to open first infeed roller** - the number of pulses that will be counted from the moment the front end of the log was detected to the moment when the first MR6000 infeed roller starts moving up.
- **Number of pulses to close second infeed roller** - the number of pulses that will be counted from the moment the first roller closed to the moment when the second MR6000 infeed roller starts lowering.
- **Number of pulses to open second infeed roller** - the number of pulses that will be counted from the moment the first roller moved up to the moment when the second MR6000 infeed roller starts lowering.
- **Number of pulses to close first outfeed roller** - the number of pulses that will be counted from the moment the second MR6000 infeed roller moved down to the moment when the first MR6000 outfeed roller starts lowering.
- **Number of pulses to open first outfeed roller** - the number of pulses that will be counted from the moment the second MR6000 infeed roller moved up to the moment when the first MR6000 outfeed roller starts raising.
- **Number of pulses to close second outfeed roller** - the number of pulses that will be counted from the moment the first MR6000 outfeed roller moved down to the moment when the second MR6000 outfeed roller starts lowering.
- **Number of pulses to open second outfeed roller** - the number of pulses that will be counted from the moment the first MR6000 outfeed roller moved up to the moment when the second MR6000 outfeed roller starts raising.



## Menu Speed multipliers

See Figure 4-12.

|                                     | Actual saved value | New value |
|-------------------------------------|--------------------|-----------|
| TV6000 Feed speed multiplier        | 1.12               | 1.12      |
| L5 Belt conveyor speed multiplier   | 1.12               | 1.12      |
| L6 Roller conveyor speed multiplier | 1.12               | 1.12      |
| L6 Roller conveyor speed multiplier | 1.12               | 1.12      |
| L7 Roller conveyor speed multiplier | 1.12               | 1.12      |
| L8 Centering table speed multiplier | 1.12               | 1.12      |
| L10 Outfeed table speed multiplier  | 1.12               | 1.12      |

Buttons: Save as default, Load default, Save values

FIG. 4-12

Due to the fact that there are gear motors with different ratios on the line, multipliers are used to adjust the speed and ensure smooth movement of the material along the entire line. The main machine is the MR6000 edger and preset speeds of other machines on the line are calculated as a percentage of its speed. For example, after entering a speed multiplier value for TV6000 of 0.8, the calculated feed rate will be 80 percent of the MR6000 rated feed rate.

The Actual saved value column includes the values that are currently stored in the Networks memory.

A new value can be entered in the New value column. To enter the new value, use a keypad that will appear after touching a given field.

Press the Save values key to store the entered values in the Networks memory.

It is also possible to save the values as default values. To do this, press the Save as

default key after entering the values.

The default values can be restored at any time by pressing the Load default key.

### **Preset settings**

See Figure 4-13.

|          | Actual saved value | New value |
|----------|--------------------|-----------|
| Preset 1 | 12.123"            | 12.123"   |
| Preset 2 | 12.123"            | 12.123"   |
| Preset 3 | 12.123"            | 12.123"   |
| Preset 4 | 12.123"            | 12.123"   |
| Preset 5 | 12.123"            | 12.123"   |
| Preset 6 | 12.123"            | 12.123"   |

Save as default

Save values      Load default

**FIG. 4-13**

The user can preset six TV6000 saw head positions in this menu. After pressing any of the keys with saved saw head position during machine operation (Preset1-Preset 6), the saw will automatically sets in this position.

The Actual saved value column includes the values that are currently stored in the Networks memory.

A new saw head position value can be entered in the New value column. To enter the new value, use a keypad that will appear after touching a given field.

Press the Save values key to store the entered values in the Networks memory.

It is also possible to save the values as default values. To do this, press the Save as default key after entering the values.

The default values can be restored at any time by pressing the Load default key.

### Other Settings

See Figure 4-14.



FIG. 4-14

This menu includes general settings.

- Machine unit settings – the operator can select the unit of measure in which the line will be working: metric in millimeters or imperial decimal.
- MR6000 outfeed table board detection delay – this function allows the operator to set a delay in operation of the board removal chains after detection of a board.

- Log turner Up/Down hydraulic speed – the speed of log turner up/down movement can be set in this place.
- Sensor blow up settings – the user can set the desired time of blowing off the sensors. The sensor blow-off is turned on automatically as soon as the line is started. It is also possible to set the pause time and the valve opening time.

## SECTION 5 MAINTENANCE

This section lists the maintenance procedures that need to be performed.



**This symbol** identifies the interval (hours of operation) at which each maintenance procedure should be performed.



**WARNING!** Always disconnect and lock out power supply before performing any maintenance work, cleaning or servicing the line. Failure to do so may result in serious injury.



**WARNING!** After turning off the power supply of the line, wait 15 minutes before starting the maintenance procedures.



**WARNING!** Before starting the maintenance procedures, disconnect the air supply and release compressed air from the air system. Failure to do so may result in serious injury.

### 5.1 Sawdust Removal



Remove sawdust from the blade wheel housing and sawdust chute at every blade change.



Sawdust and any other waste being under and near Loading Deck, TV6000 saw, conveyors, and MR6000 Multirip should be removed every 8 hours.

### 5.2 General Maintenance



1. Every 50 hours of the SLPT line operation, lubricate all the chains with Dexron III ATF oil.



2. Every 4 hours of the SLPT line operation, lubricate the transport chain of the loading decks with Dexron III ATF oil.

3. Check the bristle length on the brush once a week, if sawdust removal is not accurate enough, you need to lower the roller equipped with the brush.



4. Every 300 hours, check the condition of the transport chains on the chain conveyors with stop hooks.



**CAUTION!** Do not use solid lubricants. It causes sawdust buildup in chain links.

### 5.3 Chain Tension Adjustment



Every 50 hours of operation of the SLPT line, check and adjust (if necessary) the tension of the drive chains of:

- chain conveyor
- inclined conveyor,
- roller conveyors
- belt conveyors

The chains should have approximately 0.59 Inch of slack.



Every 50 hours of operation of the SLPT line, check and adjust (if necessary) the tension of the transport chains of:

- loading decks,
- chain conveyors,
- chain conveyors with stop hooks,

### 5.4 Belt Conveyors Adjustment And Check Up

- Check for the wear of the belt and the belt abrasions.
- Adjust the Belt tension when the belt starts to slip
- If the belt starts to move to one side of the conveyor, adjust the belt tension.

### 5.5 Safety Devices Inspection

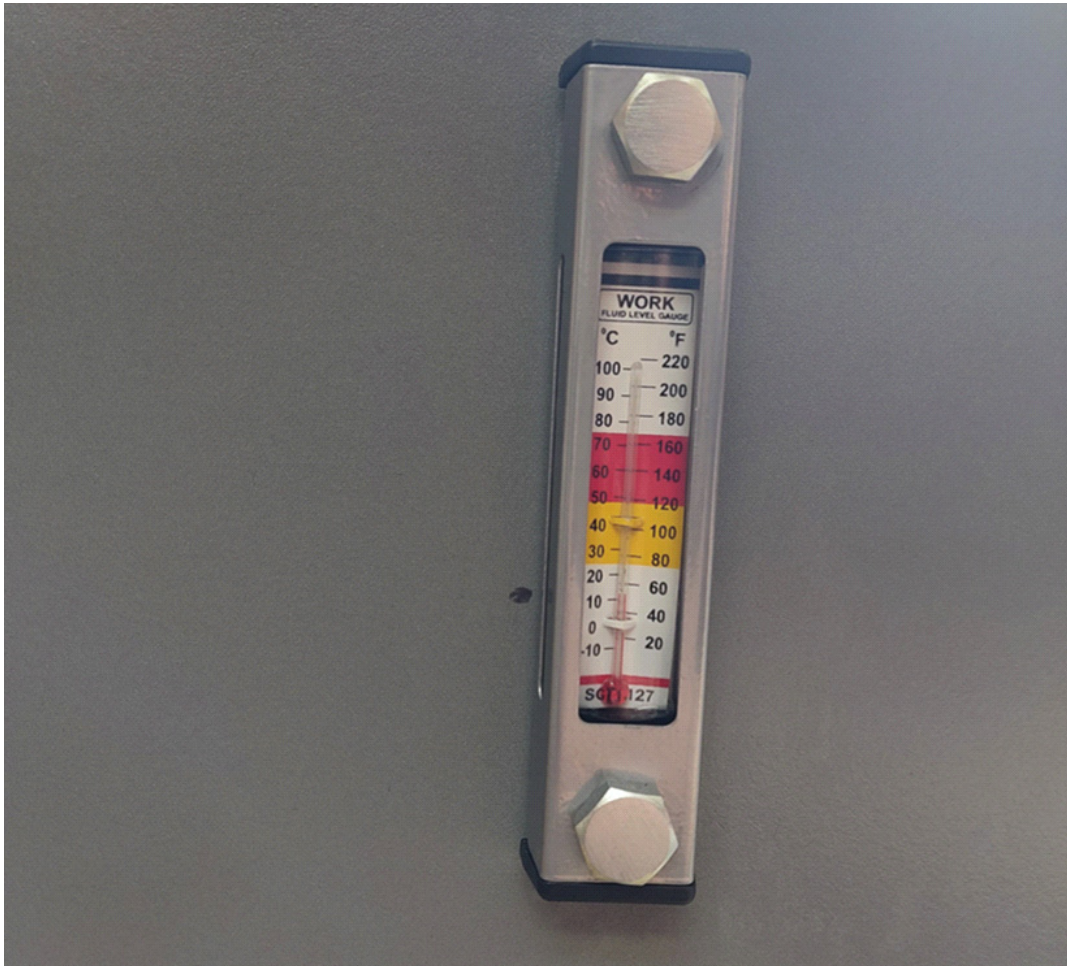
#### ***SLPT – Safety Devices Inspection***

Before beginning a shift, inspect the following safety devices of the SLPT line:

- E-STOP button and its circuit inspection,
- inspection of the control circuits with the E-STOP button pressed,
- inspection of blade cover safety switches and their circuits.

## 5.6 Refilling Hydraulic Oil in The Hydraulic Unit.

See Figure 5-1. Do not overfill hydraulic oil above the yellow mark..



**FIG. 5-1**

## SECTION 6 SPECIFICATIONS

### 6.1 SLPT-016 Material Dimensions

Patrz Tabela 6-1. TV6000 Input Material specification.

|                       | SLPT-016<br>TV6000 |
|-----------------------|--------------------|
| Min Material Diameter | 100 mm (4")        |
| Max Material Diameter | 460 mm (18")       |
| Min Material Length   | 1828 mm (72")      |
| Max Material Length   | 3657 mm (144")     |

FIG. 6-1 TV6000

Patrz Tabela 6-2. MR6000 Input Material specification.

|               | SLPT-016<br>MR6000 |
|---------------|--------------------|
| Max Thickness | 160mm (6")         |
| Min Thickness | 25mm (1")          |
| Max Length    | N/A                |
| Min Length    | 1000mm (39")       |
| Max Width     | 920mm (36")        |
| Min Width     | 100mm (4")         |

TABELA 6-2 MR6000



## 6.2 SLPT-016 Line Dimensions

See Figure 6-1 (all dimensions are given in millimeters and inches).

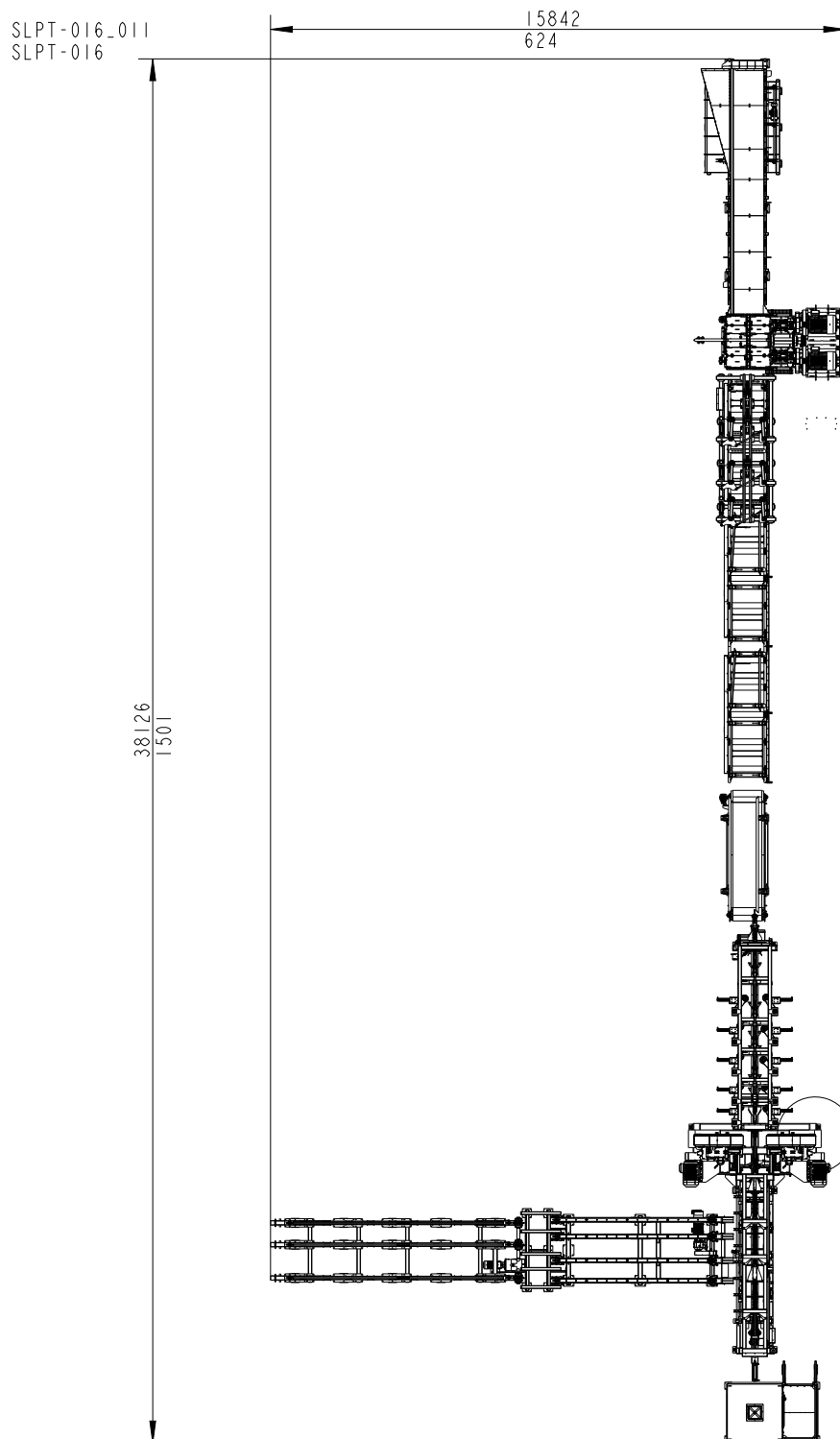


FIG. 6-1 SLPT-016 LINE

## 6.3 SLPT-016 Line Components Dimensions<sup>1</sup>

### 6.3.1 LD1

See Figure 6-2 LD1 - all dimensions are given in millimeters and inches.

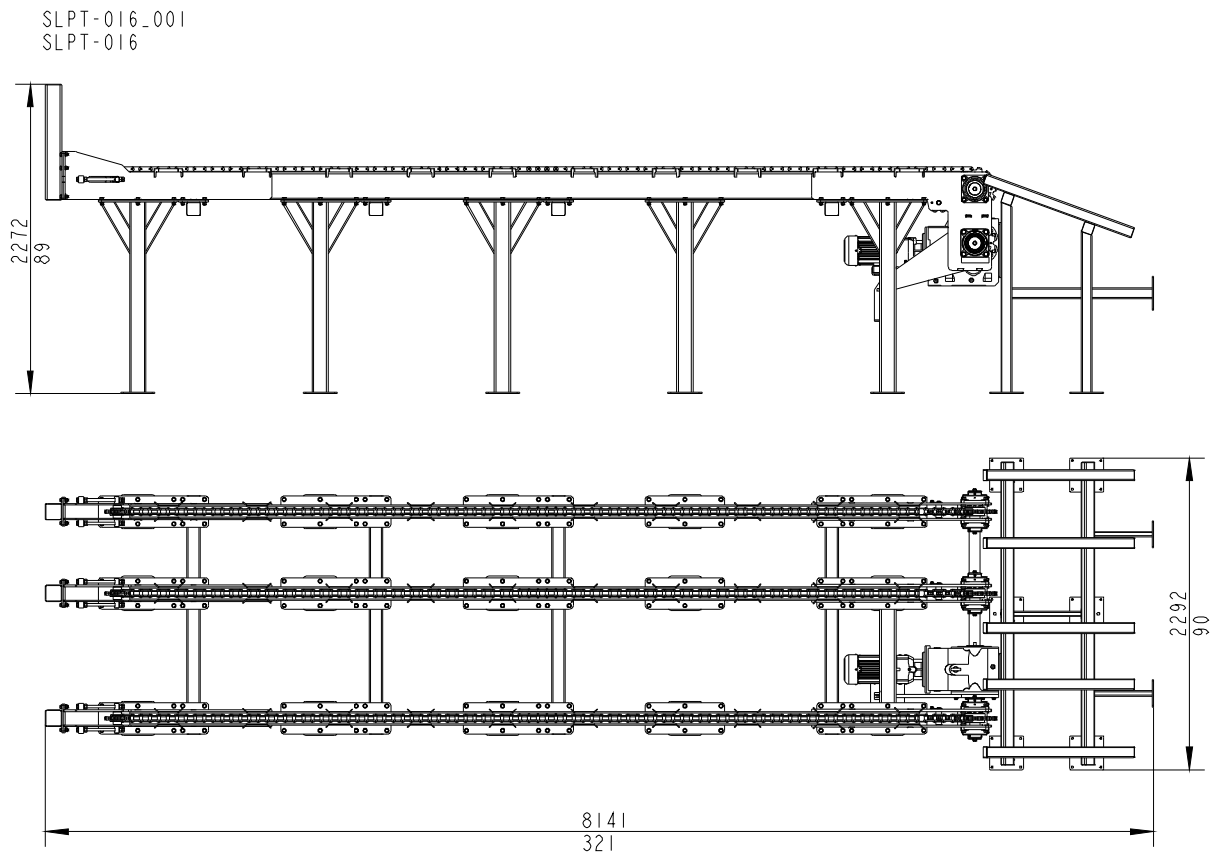


FIG. 6-2 719400-SLPT-016

1. Important information - dimensions of the other SLPT-016 line components are given in manuals concerning those particular components.

### 6.3.2 Loading Deck

See Figure 6-3 Loading Deck - all dimensions are given in millimeters and inches.

SLPT-016\_002  
SLPT-016

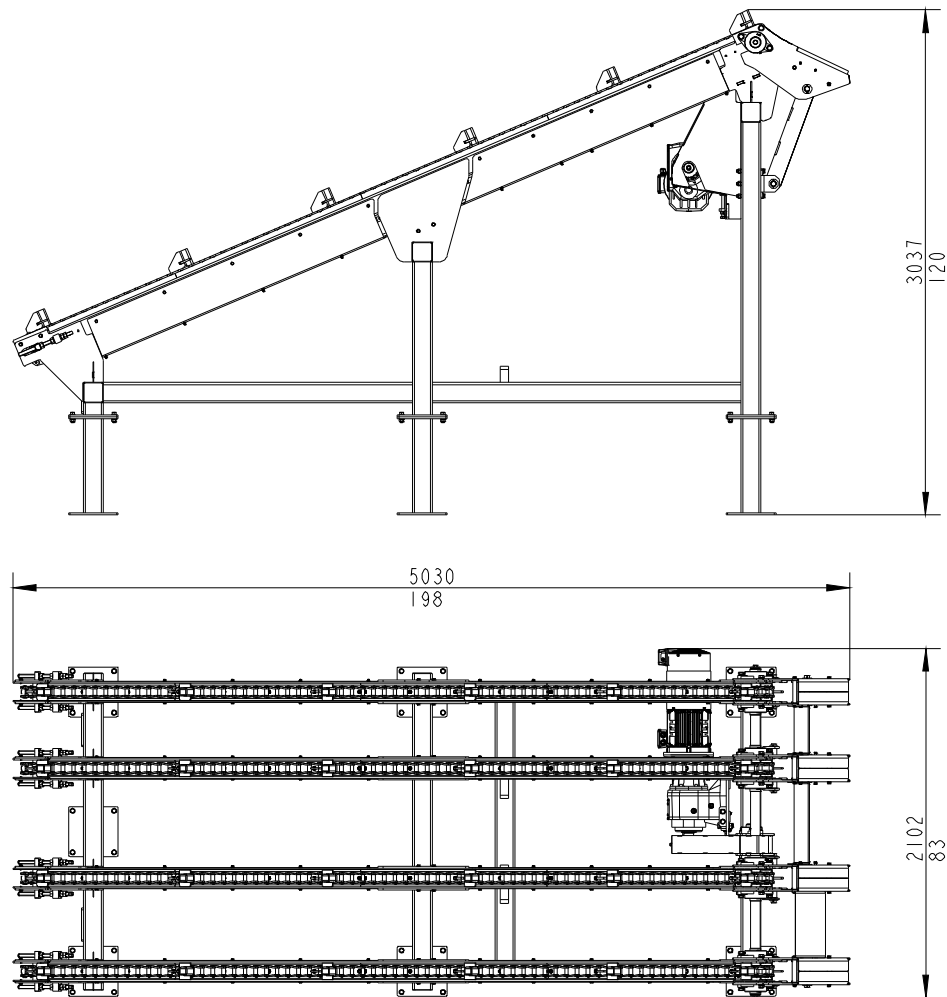


FIG. 6-3 719401-SLPT-016

### 6.3.3 Roller Table

See Figure 6-4 Roller Table - all dimensions are given in millimeters and inches.

SLPT-016\_003  
SLPT-016

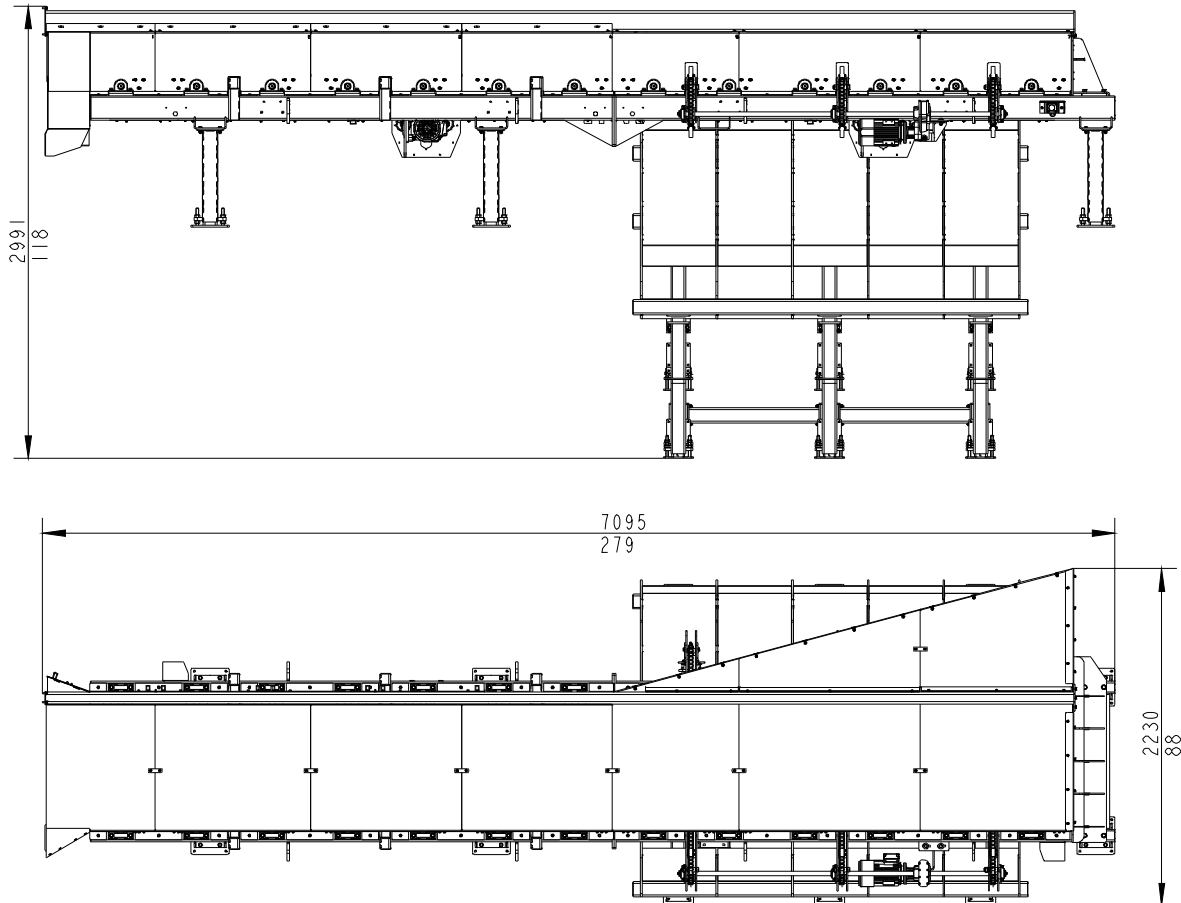
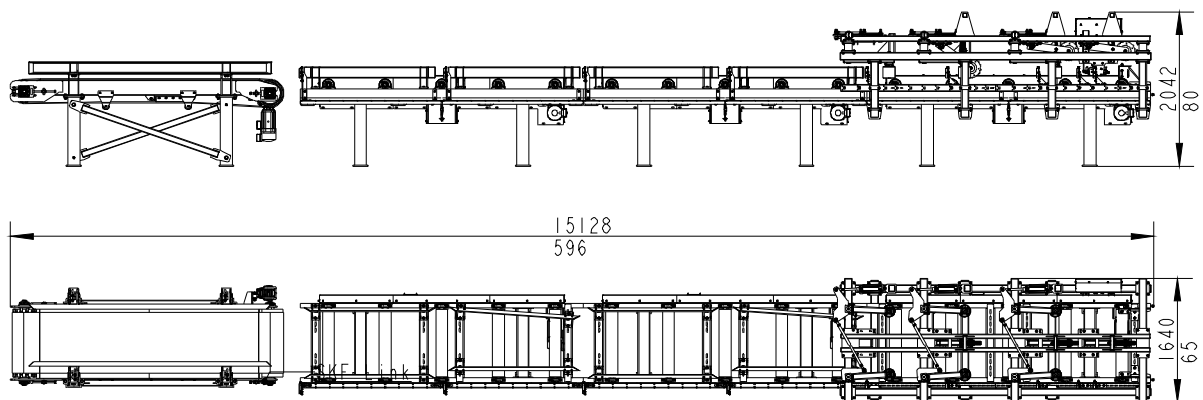


FIG. 6-4 719407-SLPT-016

## 6.4 Transporters and Centering Table

**See Figure 6-5** Transporters and Centering Table - all dimensions are given in millimeters and inches.

SLPT-016\_004  
 SLPT-016



**FIG. 6-5 556900**

### 6.4.1 Roller Table With Guides

See Figure 6-6 Roller table with guides- all dimensions are given in millimeters and inches.

SLPT-016\_005  
SLPT-016

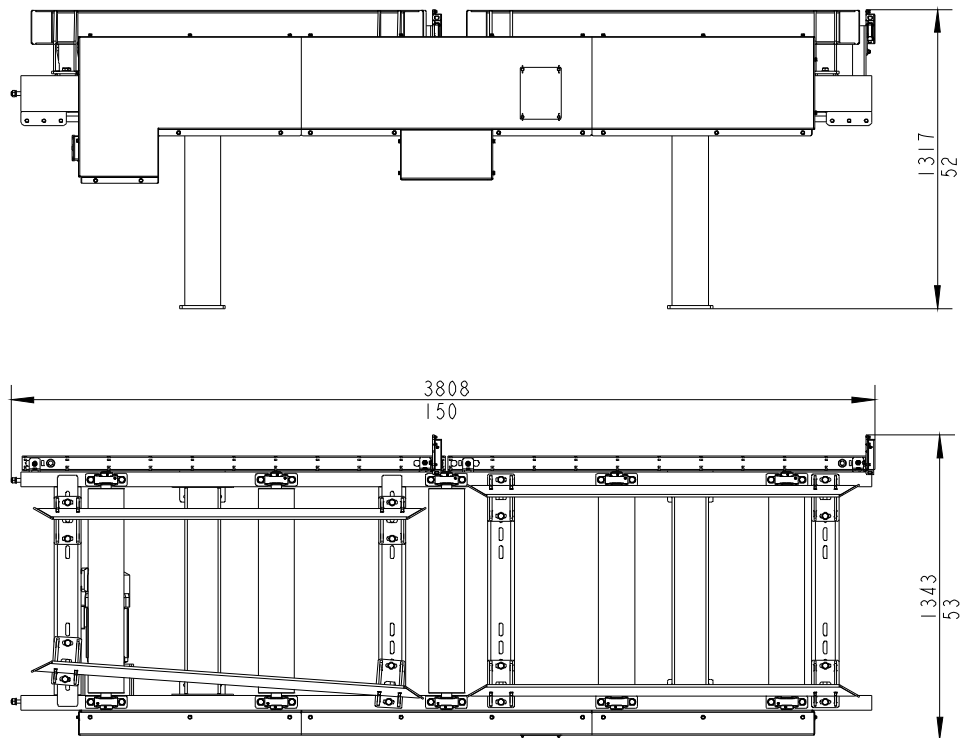


FIG. 6-6 560090

## 6.4.2 Centering Table

See Figure 6-7 Centering Table - all dimensions are given in millimeters and inches.

SLPT-016\_006  
SLPT-016

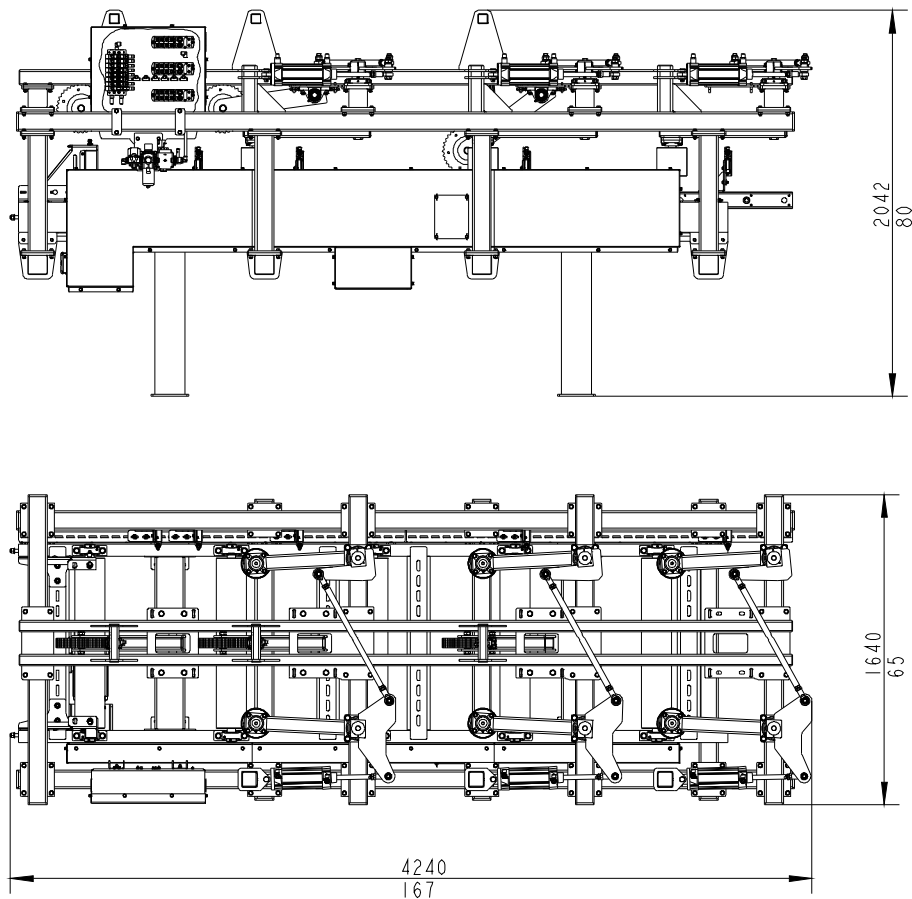


FIG. 6-7 560100

### 6.4.3 Belt Conveyor

See Figure 6-8 Belt Conveyor - all dimensions are given in millimeters and inches.

SLPT-016.007  
SLPT-016

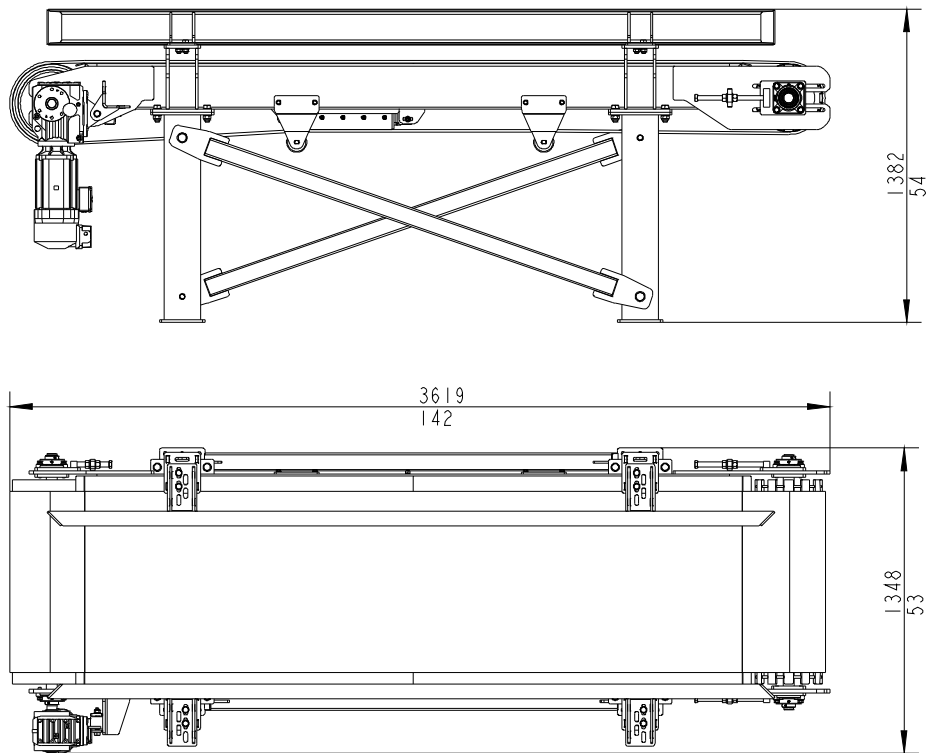


FIG. 6-8 561300



## 6.5 TV6000

See Figure 6-9 TV6000 - all dimensions are given in millimeters and inches.

SLPT-016\_008  
SLPT-016

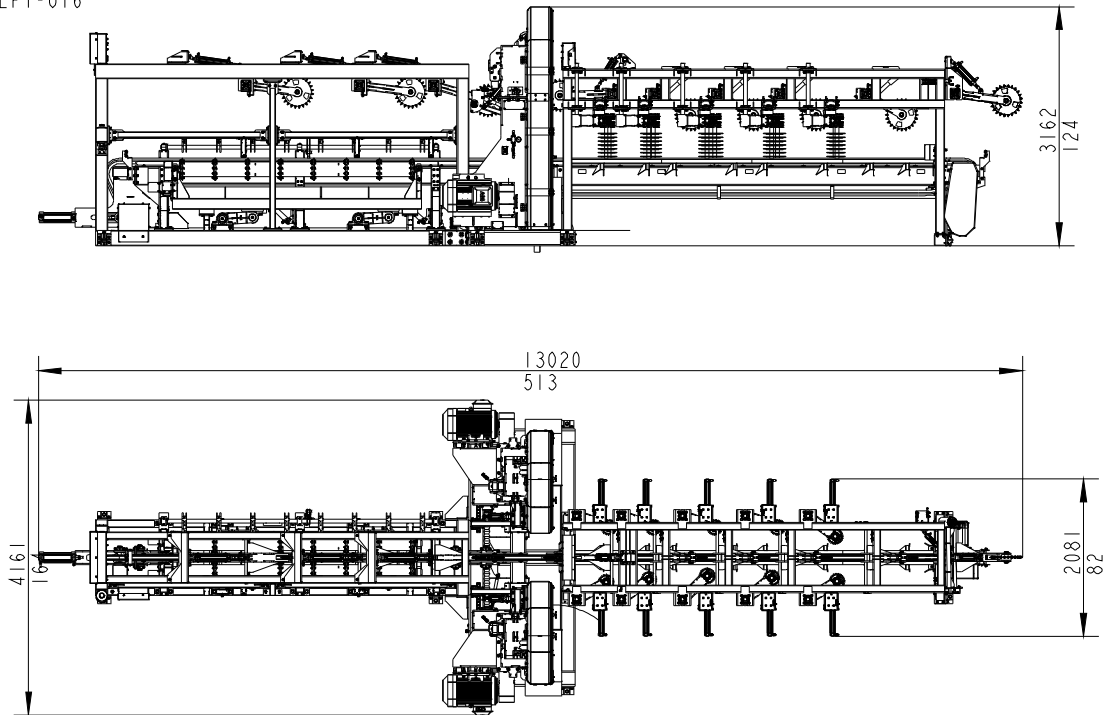
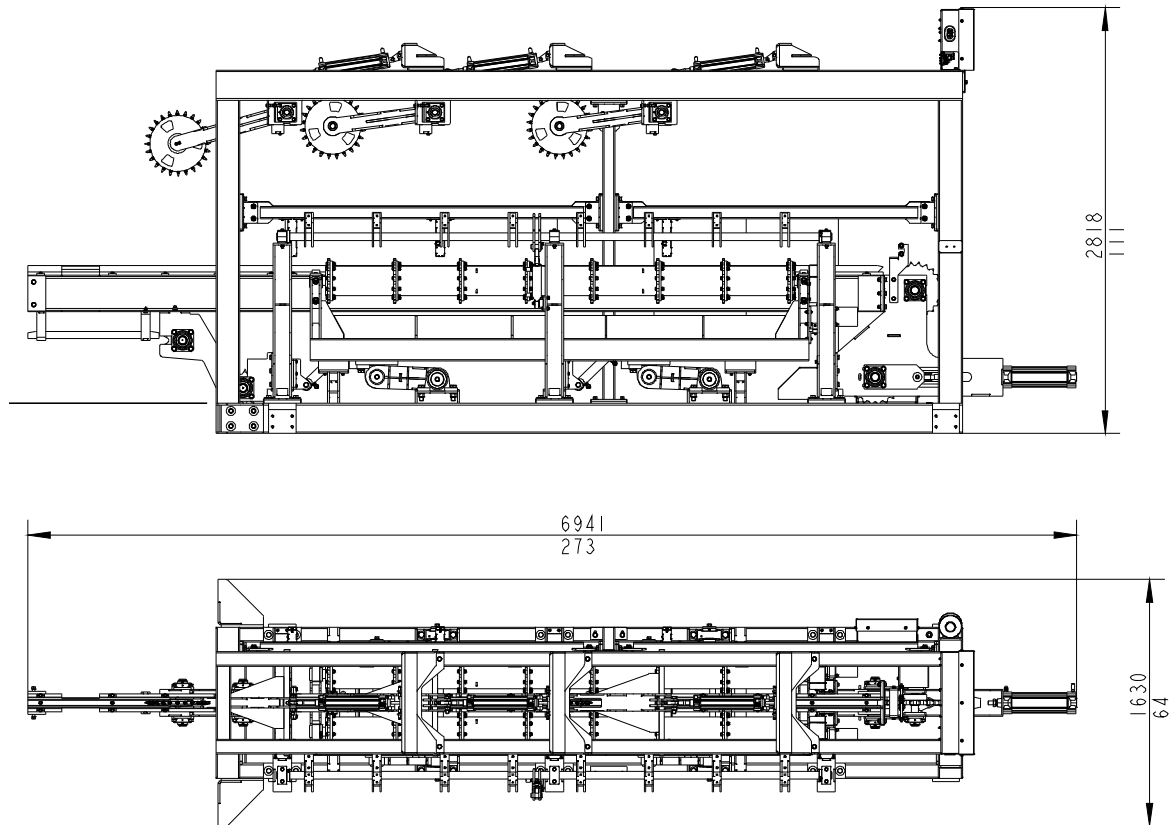


FIG. 6-9 552200

**6.5.1 TV6000 Infeed**

See Figure 6-10 TV6000 Infeed - all dimensions are given in millimeters and inches.

SLPT-016\_009  
SLPT-016



**FIG. 6-10 551871**

## 6.5.2 TV6000 Outfeed

See Figure 6-11 TV6000 Outfeed - all dimensions are given in millimeters and inches.

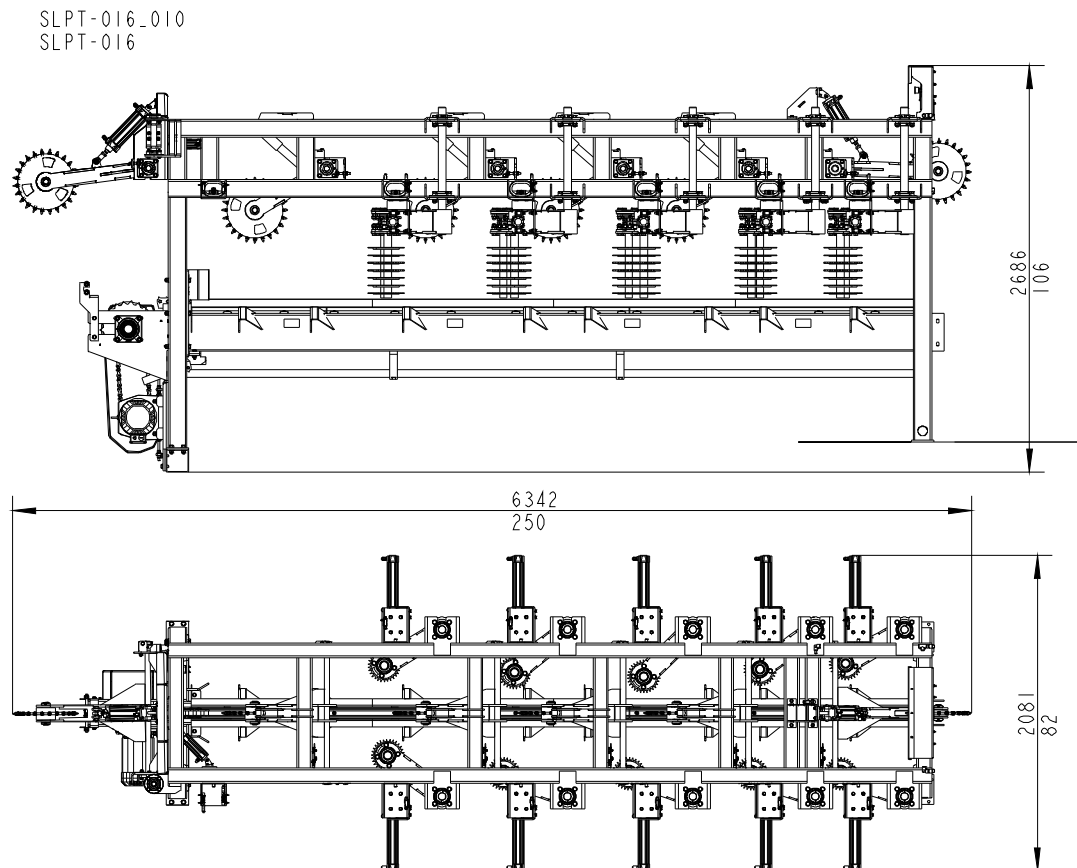


FIG. 6-11 552402

- The materials being sawn on the line should be the same length. To cut a different length material, it may be necessary to change the locations of sensors, hold-down rollers and side discs.
- It is recommended that the materials being sawn be sorted by a diameter to achieve a higher production rate. In case of various log diameters, the largest diameter must be taken into account when adjusting the feed rate.
- The logs being cut should not have any protruding knots. The protruding knots may cause the log being cut to be unstable and not guided properly with the hold-down rollers.
- It is recommended that the material to be sawn should be debarked before sawing. This will increase the productivity of the line.

## 6.6 Air Supply System Specifications

**Patrz Tabela 6-3.** The Air Supply System specifications are given in the table below:

| Air Supply | Pressure   |
|------------|------------|
| SLP        | Min. 6 bar |

**TABELA 6-3**

## SECTION 7 SLPT PARTS LIST

**To Order Parts:**

- From Europe call our European Headquarters and Manufacturing Facility in Kolo, Poland at **+48-63-2626000**. From the continental U.S., call our toll-free Parts hotline at **1-800-525-8100**. Have your customer number, vehicle identification number, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.

**Office Hours:**

| Country | Monday - Friday | Saturday        | Sunday |
|---------|-----------------|-----------------|--------|
| Poland  | 7-15            | Closed          | Closed |
| US      | 8 a.m.- 5 p.m.  | 8 a.m.- 12 p.m. | Closed |

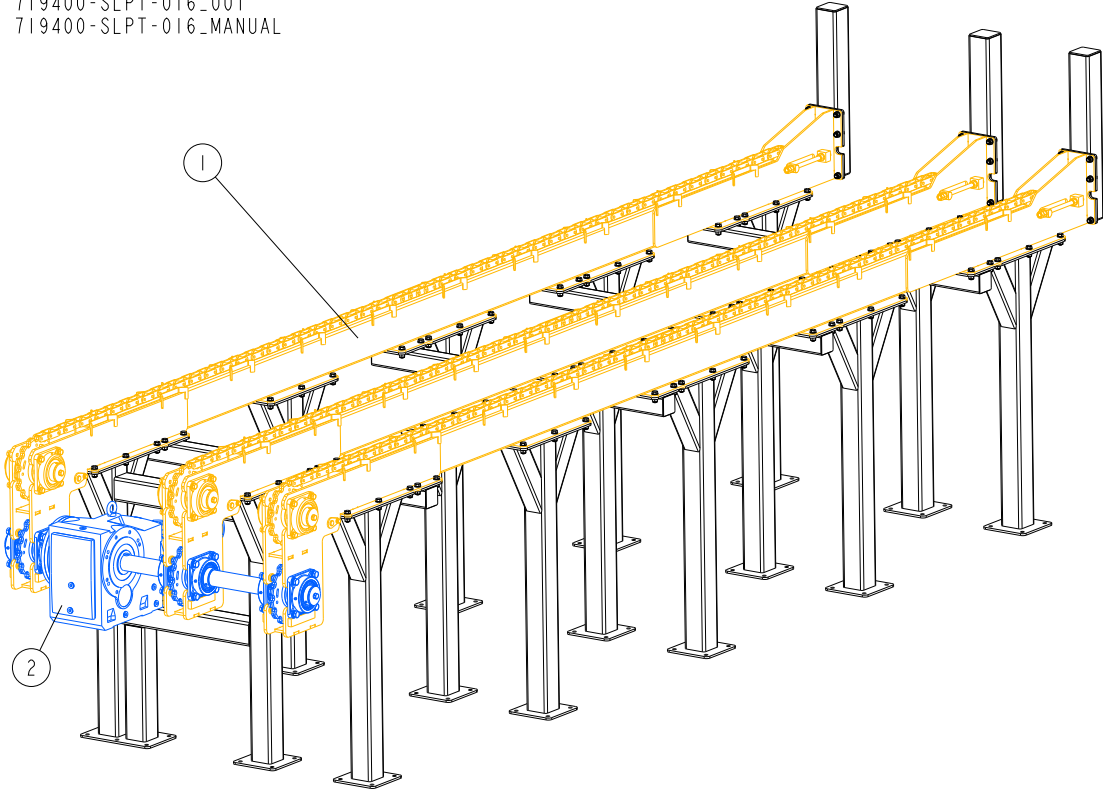


**CAUTION!** It is strongly recommended that only original spare parts be used.

SECTION 8 LD1 719400-SLPT-016

8.1 LD1 719400-SLPT-016

719400-SLPT-016\_001  
719400-SLPT-016\_MANUAL

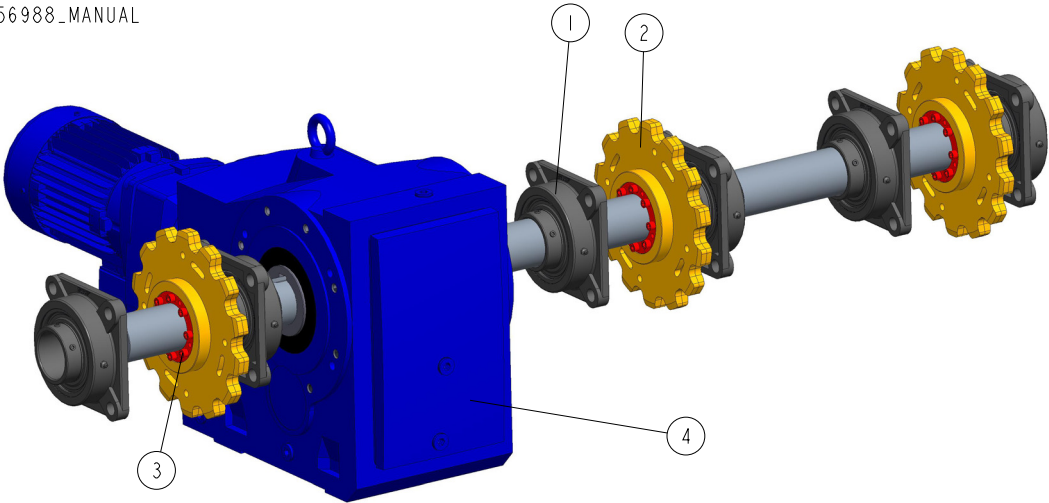


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #          | QTY |  |
|------|--------------------------------------------------------------|-----------------|-----|--|
| -    | LOG DECK, LD1 + BOARD REMOVAL                                | 719400-SLPT-016 | 1   |  |
| -    | DECK, LOG - COMPLETE                                         | 556574          | 1   |  |
| 1    | LOG DECK SEGMENT - COMPLETE <a href="#">See Section 9.4</a>  | 556562          | 3   |  |
| 2    | DRIVE ASSEMBLY <a href="#">See Section 8.2</a>               | 556988          | 1   |  |

8.2 Drive Assembly

556988\_001

556988\_MANUAL

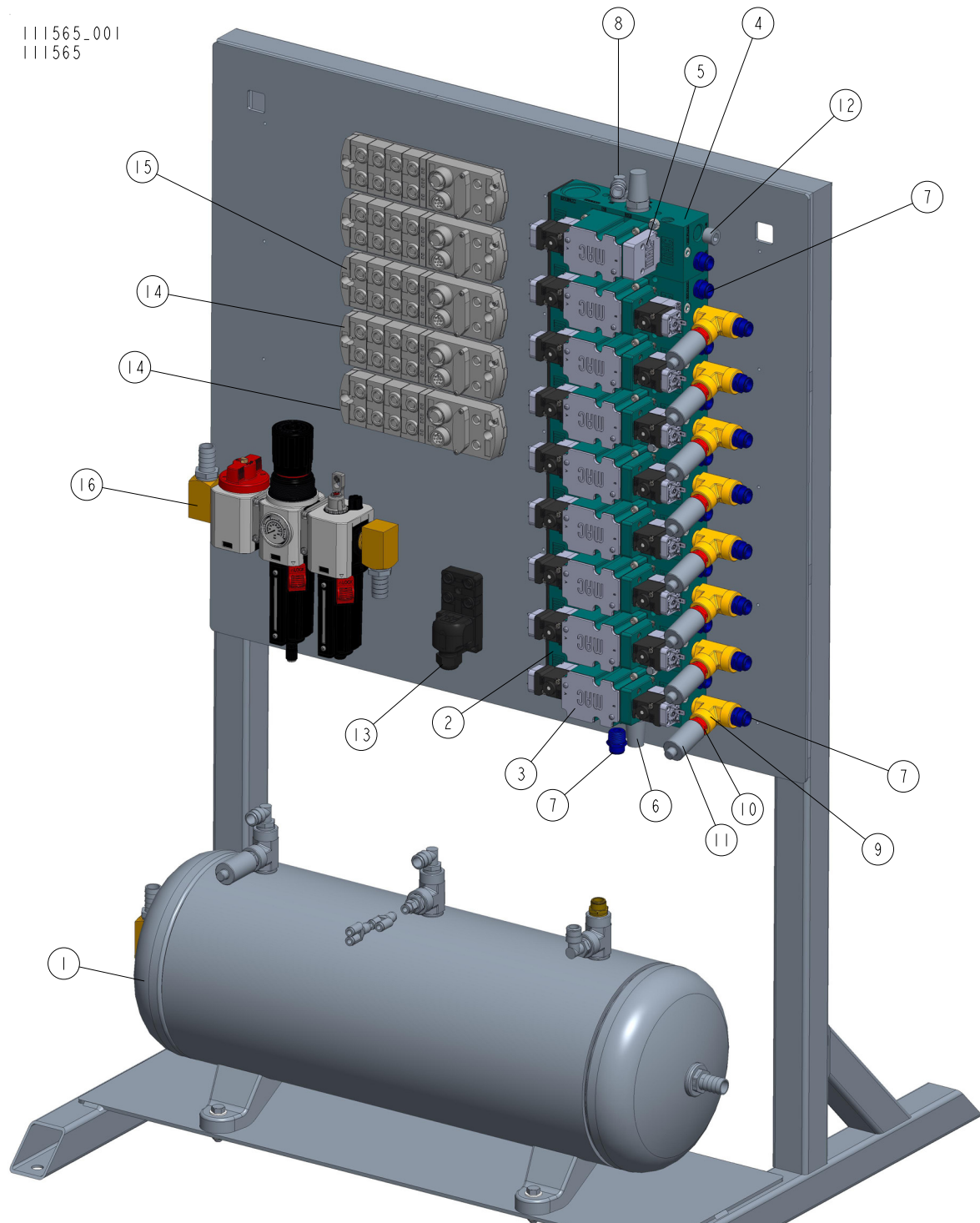


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #   | QTY |  |
|------|--------------------------------------------------------------|----------|-----|--|
| -    | DRIVE ASSEMBLY                                               | 556988   | 1   |  |
| 1    | BEARING, UCF 216 SKF W/HOUSING                               | 556987   | 6   |  |
| 2    | SPROCKET, 81X Z14                                            | 556992-1 | 3   |  |
| 3    | BUSHING, BK70 ID 80 (T78142) CLAMPING                        | 556996   | 3   |  |
| 4    | MOTOREDUCER, SK 9072.1/32AZ - 112MP/4 CUS TF (ver.UL)        | 557912   | 1   |  |



## SECTION 9 PNEUMATIC MAIN BOX 111565

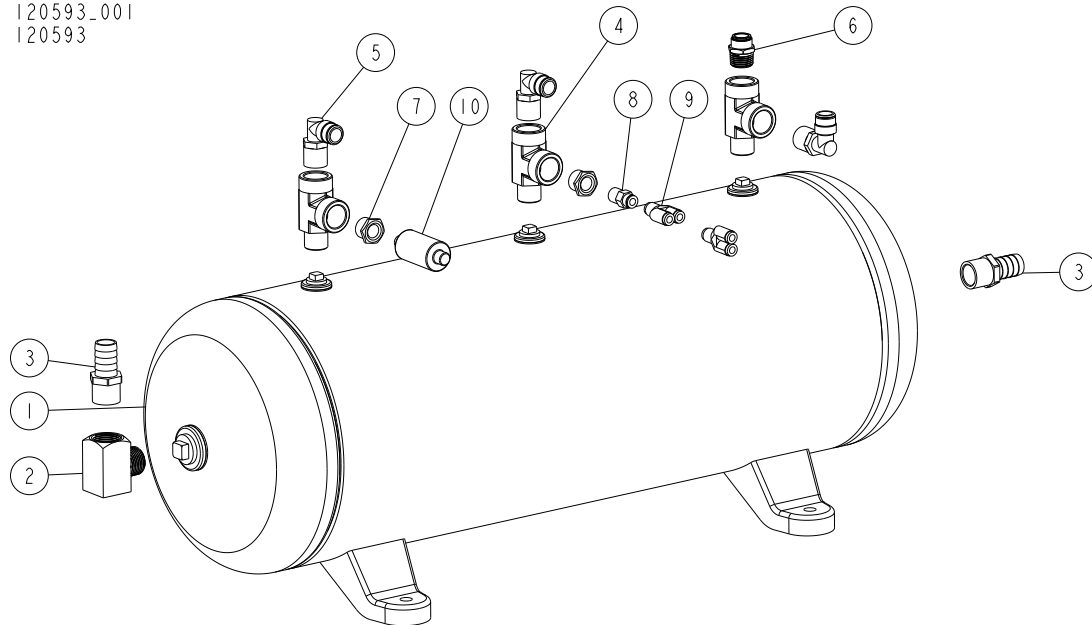
### 9.1 Pneumatic main box 111565



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |  |
|------|--------------------------------------------------------------|--------|-----|--|
| -    | Assy, MR3000 PP, Stand                                       | 111565 | 1   |  |
| 1    | ASSY, AIR TANK <a href="#">See Section 9.2</a>               | 120593 | 1   |  |
| -    | ASSY, MR3000 PP, VALVE BANK                                  | 111561 | 1   |  |
| -    | VALVE, AIR 4/3 CLSD 1/2NPT 24DC DIN A SND                    | 112517 | 8   |  |

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)   | PART # | QTY |  |
|------|----------------------------------------------------------------|--------|-----|--|
| 2    | VALVE, BASE ONLY 1/2NPT 6300 SERIES                            | 112521 | 1   |  |
| 3    | VALVE, 4/3 CLSD 24DC DIN A VLV ONLY                            | 112520 | 1   |  |
| -    | VALVE, AIR 4/2 SNGL 1/2NPT 24DC DIN A SND                      | 112516 | 1   |  |
| 4    | VALVE, BASE ONLY 1/2NPT 6300 SERIES                            | 112521 | 1   |  |
| 5    | VALVE, AIR 4/2 SNGL 24DC DIN A VLV ONLY                        | 112519 | 1   |  |
| 6    | MUFFLER, 3/4NPT AIR                                            | 120293 | 2   |  |
| 7    | FITTING, 1/2NPT-1/2"PUSH-IN STRAIGHT                           | 111560 | 18  |  |
| 8    | FITTING, 1/2NPT-1/2IN 90 DEG AIR                               | 016880 | 1   |  |
| 9    | FITTING, 1/2NPT MALE RUN TEE                                   | 003674 | 8   |  |
| 10   | FITTING, 1/2NPTX1/4NPT HEX BUSHING                             | P31321 | 8   |  |
| 11   | SWITCH, 7.5-145PSI 24V M12 PNP PRESSURE                        | 069487 | 8   |  |
| 12   | PLUG, 1/2NPT PIPE                                              | P26258 | 1   |  |
| 13   | <b>JUNCTION BLOCK, 4 PORT M12 4-PIN</b>                        | 112623 | 1   |  |
| 14   | <b>PLC MODULE, ETHERNET_IP DI16 IP67</b>                       | 112619 | 2   |  |
| 15   | <b>PLC MODULE, ETHERNET_IP DO8X2A IP67</b>                     | 112620 | 3   |  |
| 16   | <b>ASSY, FRL WITH FITTINGS</b> <a href="#">See Section 9.3</a> | 120594 | 1   |  |

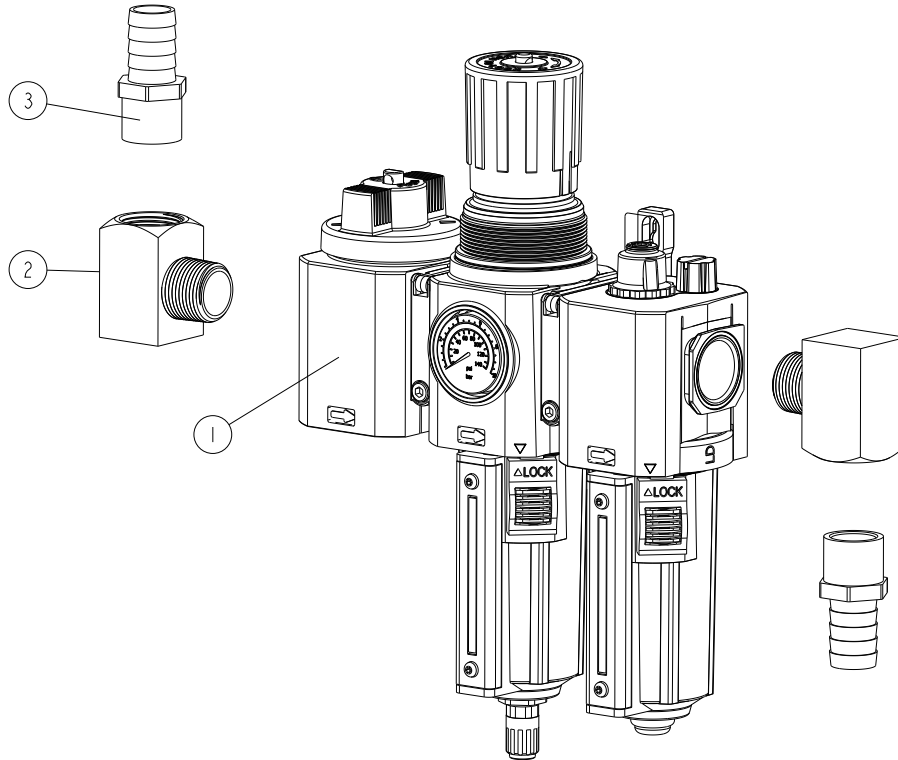
## 9.2 Air Tank 120593

120593\_001  
120593

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |  |
|------|--------------------------------------------------------------|--------|-----|--|
| -    | Assy, Air Tank                                               | 120593 | 1   |  |
| 1    | AIR STORAGE TANK, 10 GALLON, ASME-CODE                       | 120332 | 1   |  |
| 2    | FITTING, ELBOW 90 3/4 NPT FML X ML                           | 112474 | 1   |  |
| 3    | FITTING, 3/4 BRASS HOSE BARB                                 | 057420 | 2   |  |
| 4    | FITTING, 1/2NPT MALE RUN TEE                                 | 003674 | 3   |  |
| 5    | FITTING, 1/2NPT-1/2IN 90 DEG AIR                             | 016880 | 3   |  |
| 6    | FITTING, 1/2NPT-1/2" PUSH-IN STRAIGHT                        | 111560 | 1   |  |
| 7    | FITTING, 1/2NPTX1/4NPT HEX BUSHING                           | P31321 | 2   |  |
| 8    | FITTING, 1/4 NPT - 1/4 TUBE STRAIGHT                         | P20903 | 1   |  |
| 9    | UNION, 1/4TB Y                                               | 042546 | 2   |  |
| 10   | SWITCH, 7.5-145PSI 24V M12 PNP PRESSURE                      | 069487 | 1   |  |

**9.3 FRL With Fittings 120594**

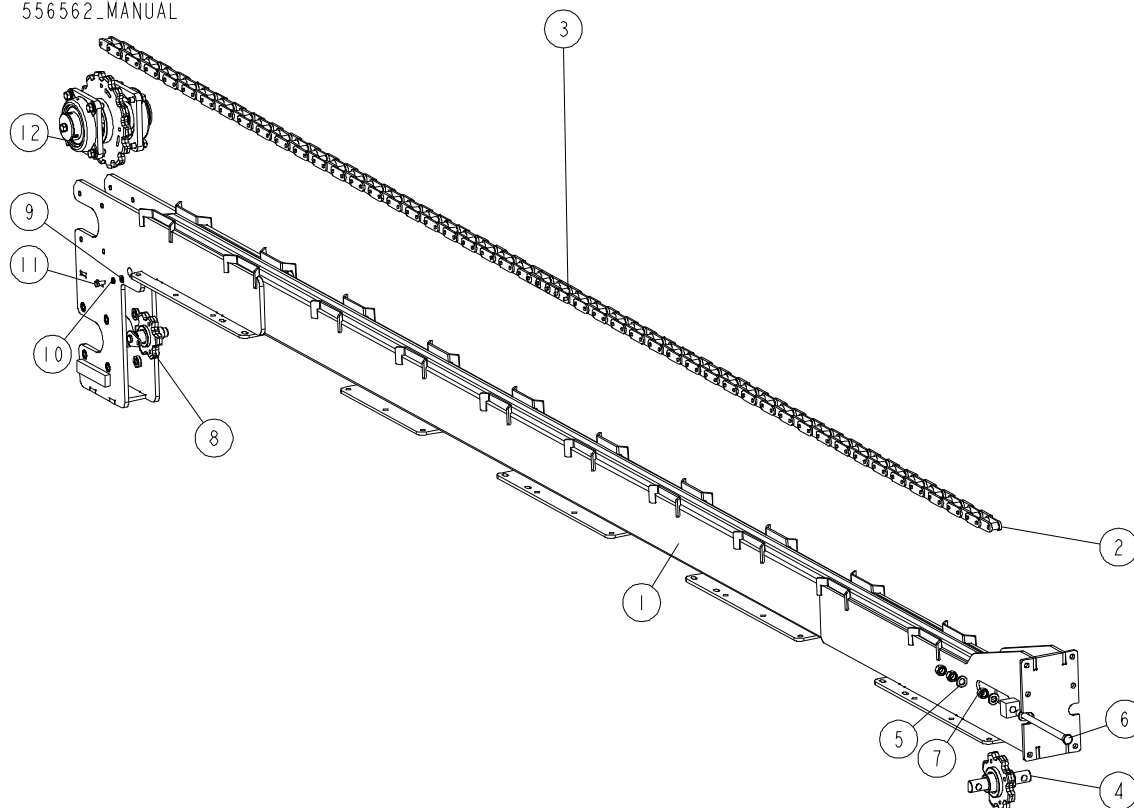
120594\_001  
120594



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART # | QTY |  |
|------|--------------------------------------------------------------|--------|-----|--|
| -    | Assy, FRL with fittings                                      | 120594 | 1   |  |
| 1    | FRL, 3/4NPT                                                  | 113323 | 1   |  |
| 2    | FITTING, ELBOW 90 3/4 NPT FML X ML                           | 112474 | 2   |  |
| 3    | FITTING, 3/4 BRASS HOSE BARB                                 | 057420 | 2   |  |

## 9.4 Log Deck Segment 556562

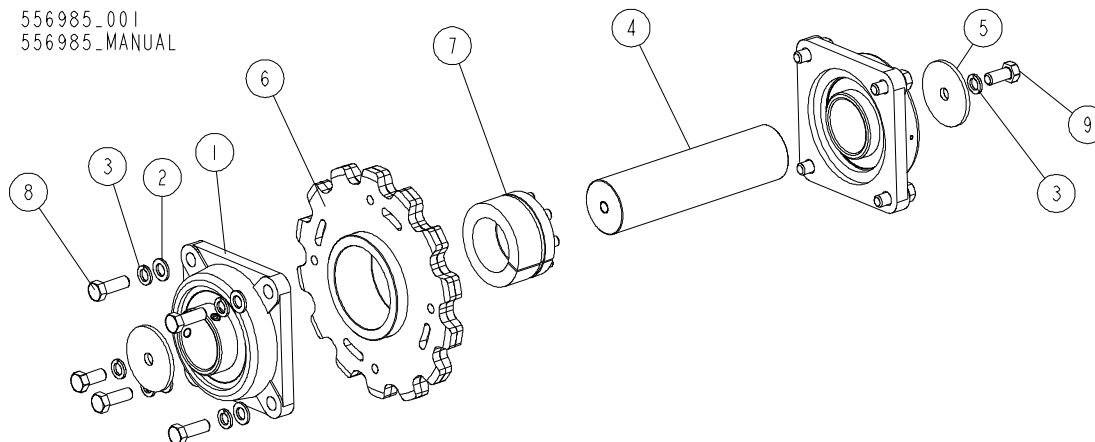
556562\_001  
556562\_MANUAL



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)     | PART #    | QTY |  |
|------|------------------------------------------------------------------|-----------|-----|--|
| -    | <b>LOG DECK SEGMENT - COMPLETE</b>                               | 556562    | 1   |  |
| 1    | SEGMENT, LOG DECK                                                | 556563-1  | 1   |  |
| -    | CHAIN, 81XH - COMPLETE                                           | 556564    | 1   |  |
| 2    | CHAIN, 81XH, 213 LINKS (L=14115MM)                               | 556950    | 1   |  |
| 3    | LINK, 81XH MASTER                                                | 719078    | 5   |  |
| 4    | WHEEL, CHAIN TENSION - COMPLETE                                  | 541951    | 1   |  |
| 5    | WASHER, 21 FLAT ZINC                                             | F81059-2  | 6   |  |
| 6    | BOLT, M20X340-8.8 HEX HEAD FULL THREAD ZINC                      | F81007-44 | 2   |  |
| 7    | NUT, M20-8- HEX ZINC                                             | F81037-1  | 6   |  |
| 8    | CHAIN SUPPORT SPROCKET - COMPLETE                                | 541978    | 1   |  |
| 9    | WASHER, 13-FLAT ZINC                                             | F81056-1  | 1   |  |
| 10   | WASHER, Z12.2 SPLIT LOCK ZINC                                    | F81056-2  | 1   |  |
| 11   | BOLT, M12X25-8.8 FZINC                                           | F81004-31 | 1   |  |
| 12   | IDLE SIDE CHAIN SUPPORT ASSEMBLY <a href="#">See Section 9.5</a> | 556985    | 1   |  |

## 9.5 Idle Side Chain Support Assembly 556985

556985\_001  
556985\_MANUAL

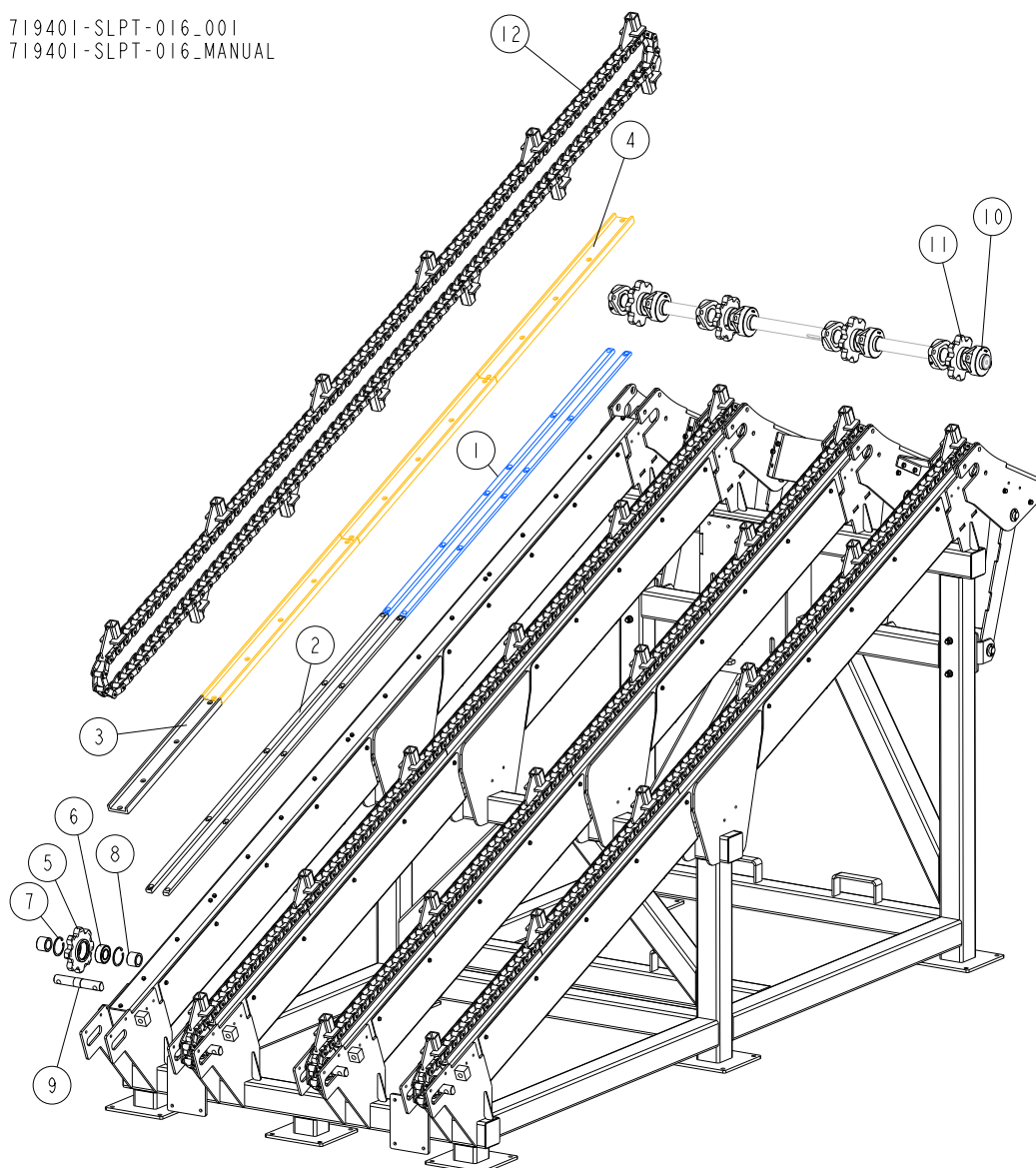


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #    | QTY |  |
|------|--------------------------------------------------------------|-----------|-----|--|
| -    | <b>IDLE SIDE CHAIN SUPPORT ASSEMBLY</b>                      | 556985    | 1   |  |
| 1    | BEARING, UCF 215 NSK W/HOUSING                               | 717152    | 2   |  |
| 2    | WASHER, 17 FLAT ZINC                                         | F81058-1  | 8   |  |
| 3    | WASHER, 16,3 SPLIT LOCK ZINC                                 | F81058-2  | 10  |  |
| 4    | SHAFT, DRIVEN                                                | 556986    | 1   |  |
| 5    | WASHER, 90/17-6                                              | 556583-1  | 2   |  |
| 6    | SPROCKET, 81X Z14                                            | 556983-1  | 1   |  |
| 7    | BUSHING, BK70 FI WEW. 75 (T78141) CLAMPING                   | 556982    | 1   |  |
| 8    | BOLT, M16X45-8.8-HEX HEAD FULL THREAD ZINC                   | F81006-46 | 8   |  |
| 9    | BOLT, M16X35-8.8-HEX HEAD FULL THREAD ZINC                   | F81006-74 | 2   |  |

## SECTION 10 719401-SLPT-016

### 10.1 719401-SLPT-016

719401-SLPT-016\_001  
719401-SLPT-016\_MANUAL



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #    | QTY |  |
|------|--------------------------------------------------------------|-----------|-----|--|
| -    | CONVEYOR CHANNEL ASSEMBLY                                    | 528331    | 4   |  |
| 1    | CHANNEL, CONVEYOR TOP                                        | 528199    | 2   |  |
| 2    | CHANNEL, CONVEYOR BOTTOM                                     | 528196    | 2   |  |
| -    | CONVEYOR CHANNEL ASSEMBLY                                    | 528332_   | 1   |  |
| 3    | CHANNEL, DWH78 CONVEYOR                                      | 528194    | 4   |  |
| 4    | CHANNEL, UHMW CONVEYOR                                       | 033722    | 12  |  |
| -    | TENSIONING SPROCKET ASSEMBLY                                 | 528333    | 4   |  |
| -    | SPROCKET, Z8 - COMPLETE                                      | 507234    | 1   |  |
| 5    | SPROCKET, Z8 REAR PTD.                                       | 089919-1  | 1   |  |
| 6    | BEARING, 3208. 2RSR. TVH (FAG). ROLLING                      | 088449    | 1   |  |
| 7    | RING, W80 OUTSIDE RETAINING                                  | F81090-25 | 2   |  |



## 719401-SLPT-016

719401-SLPT-016

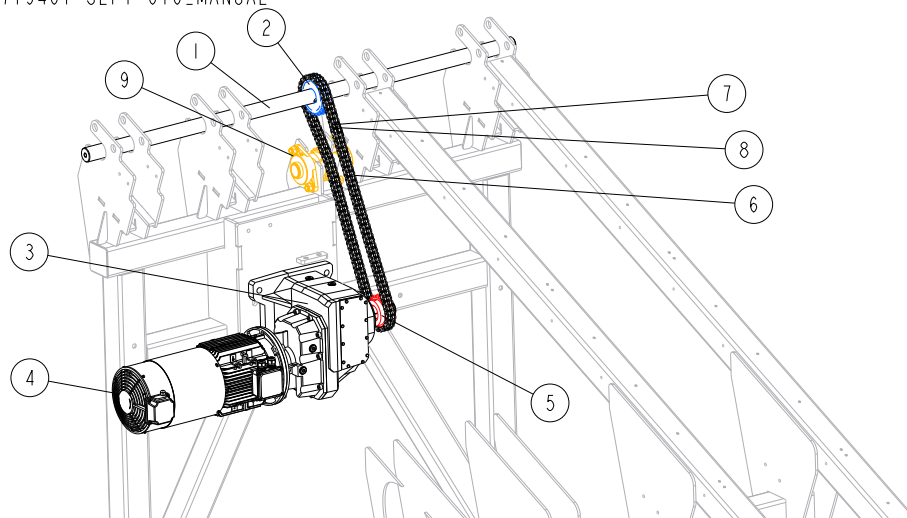
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| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #   | QTY |  |
|------|--------------------------------------------------------------|----------|-----|--|
| 8    | BUSHING, 40.5/60-33                                          | 528334-1 | 2   |  |
| 9    | AXLE, TENSIONING SPROCKET                                    | 528455-1 | 1   |  |
| 10   | BEARING, UCFL211 W/HOUSING                                   | 513117   | 8   |  |
| 11   | SPROCKET, Z8                                                 | 089888   | 4   |  |
| 12   | CHAIN, MAIN                                                  | 528490-1 | 4   |  |



## 10.2 719401-SLPT-016

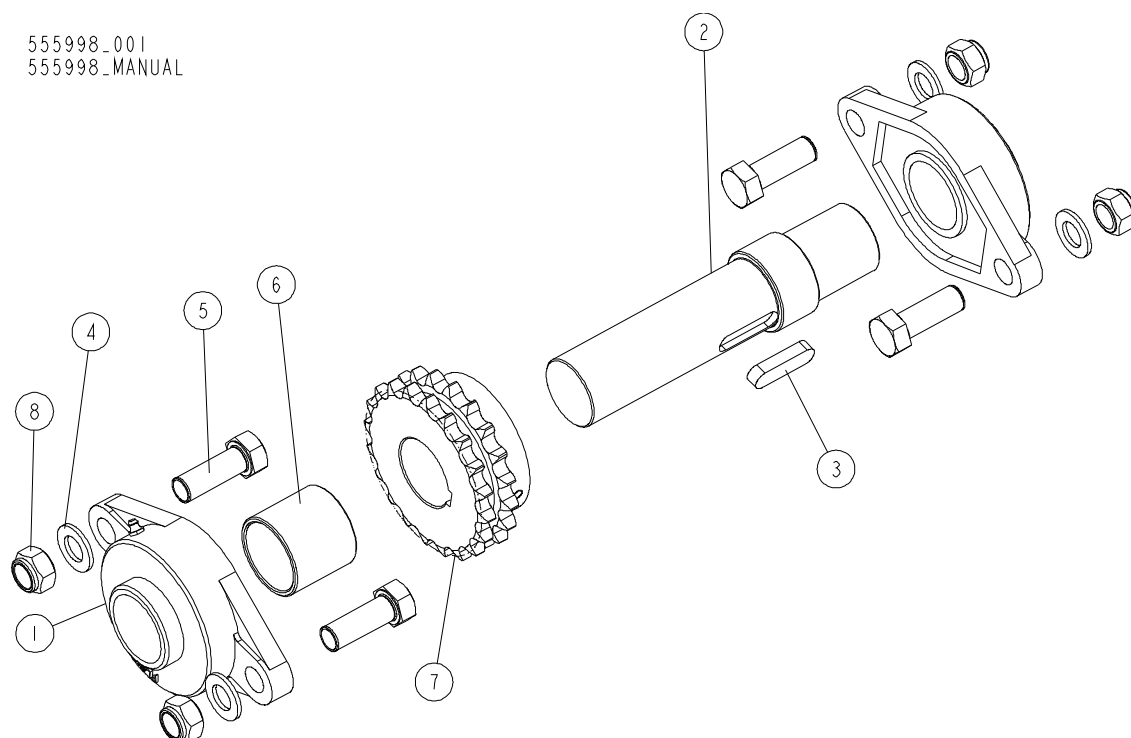
719401-SLPT-016\_002  
719401-SLPT-016\_MANUAL



| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)                   | PART #          | QTY |
|------|--------------------------------------------------------------------------------|-----------------|-----|
| -    | <b>LOADING DECK</b>                                                            | 719401-SLPT-016 | 1   |
| 1    | SHAFT, MAIN                                                                    | 528304          | 1   |
| 2    | SPROCKET, Z24/?55/12A-2                                                        | 555996-1        | 1   |
| -    | HMZ-603/50,89-300/38-B7 + E-IE3-132S-4-5,5-300/38-400/690V-HPS-O3-UL-50HZ-IP66 | 556228          | 1   |
| 3    | HMZ-603/50,89-300/38-B7                                                        | 556230          | 1   |
| 4    | MOTOR, E-IE3-132S-4-5,5-300/38-400/690V-HPS-O3-UL-50HZ-IP66                    | 556229          | 1   |
| 5    | SPROCKET, Z20/N60/12A-2                                                        | 555997-1        | 1   |
| -    | MOTOREDUCTER CHAIN - COMPLETE                                                  | 555999          | 1   |
| 6    | CHAIN, 12A-2, (3/4"X1/2"), 114 LINKS L=2.17 IWIS                               | 556226          | 1   |
| 7    | HALF LINK, 12A-2 (3/4"X1/2") IWIS W/COTTER PIN                                 | 556225          | 1   |
| 8    | LINK, 12A-2, (3/4"X1/2") IWIS MASTER                                           | 556224          | 1   |
| 9    | TENSIONING ASSEMBLY, <a href="#">See Section 10.3</a>                          | 555998          | 1   |

## 10.3 Tensioning Assembly 555998

555998\_001  
555998\_MANUAL

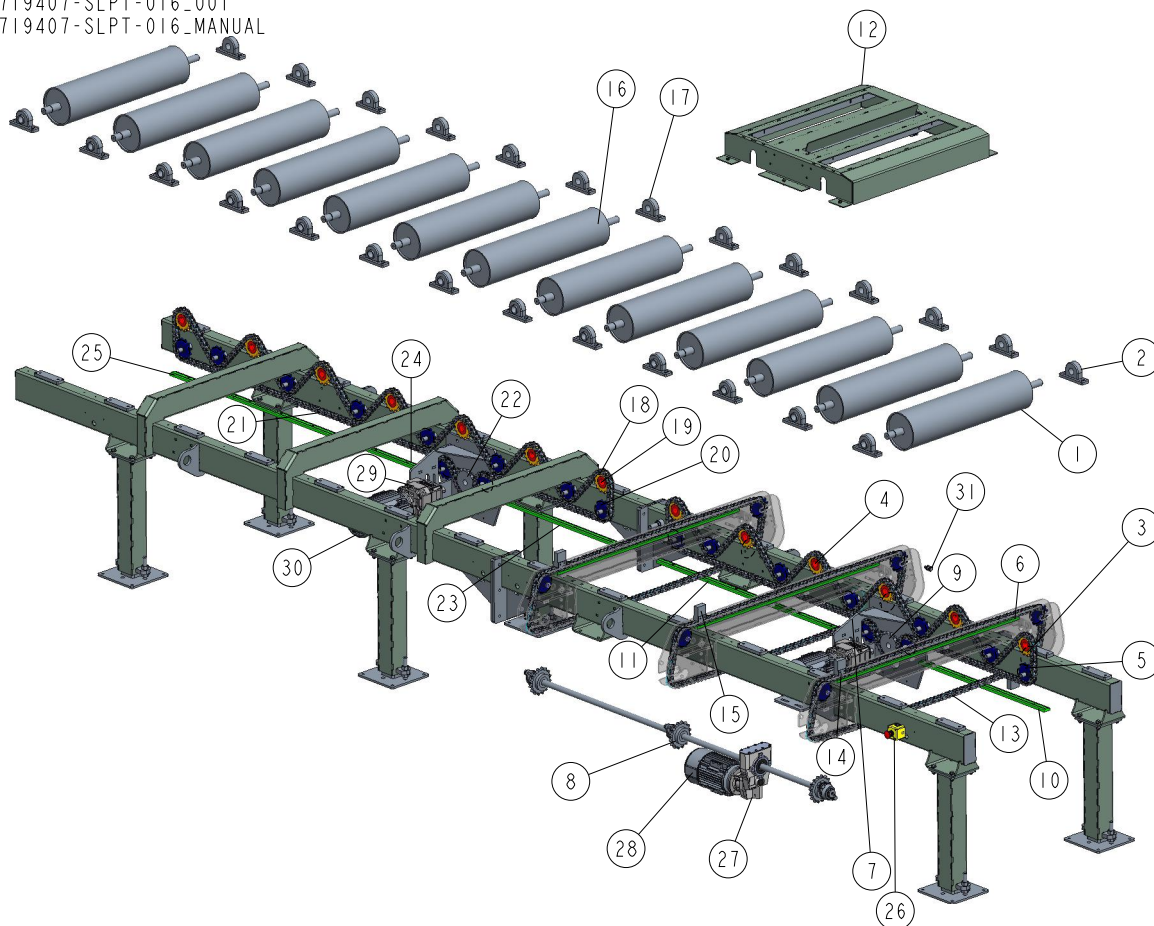


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #    | QTY |  |
|------|--------------------------------------------------------------|-----------|-----|--|
| -    | <b>TENSIONING ASSEMBLY</b>                                   | 555998    | 1   |  |
| 1    | BEARING, UCFL210 W/HOUSING                                   | 098824    | 2   |  |
| 2    | SHAFT, TENSION SPROCKET                                      | 513074    | 1   |  |
| 3    | KEY, A 14X9X50 PARALLEL                                      | 514071    | 1   |  |
| 4    | WASHER, 19 FLAT ZINC                                         | F81060-1  | 4   |  |
| 5    | BOLT, M18X50-8.8 HEX HEAD FULL THREAD ZINC                   | F81008-1  | 4   |  |
| 6    | BUSHING, 50/58-52 PTD                                        | 513104-1  | 1   |  |
| 7    | SPROCKET, Z20/N50/12A-2                                      | 555995-1  | 1   |  |
| 8    | NUT, M18 HEX NYLON ZINC LOCK                                 | F81039-15 | 4   |  |

## SECTION 11 ROLLER TABLE

### 11.1 Roller Table

719407-SLPT-016\_001  
719407-SLPT-016\_MANUAL

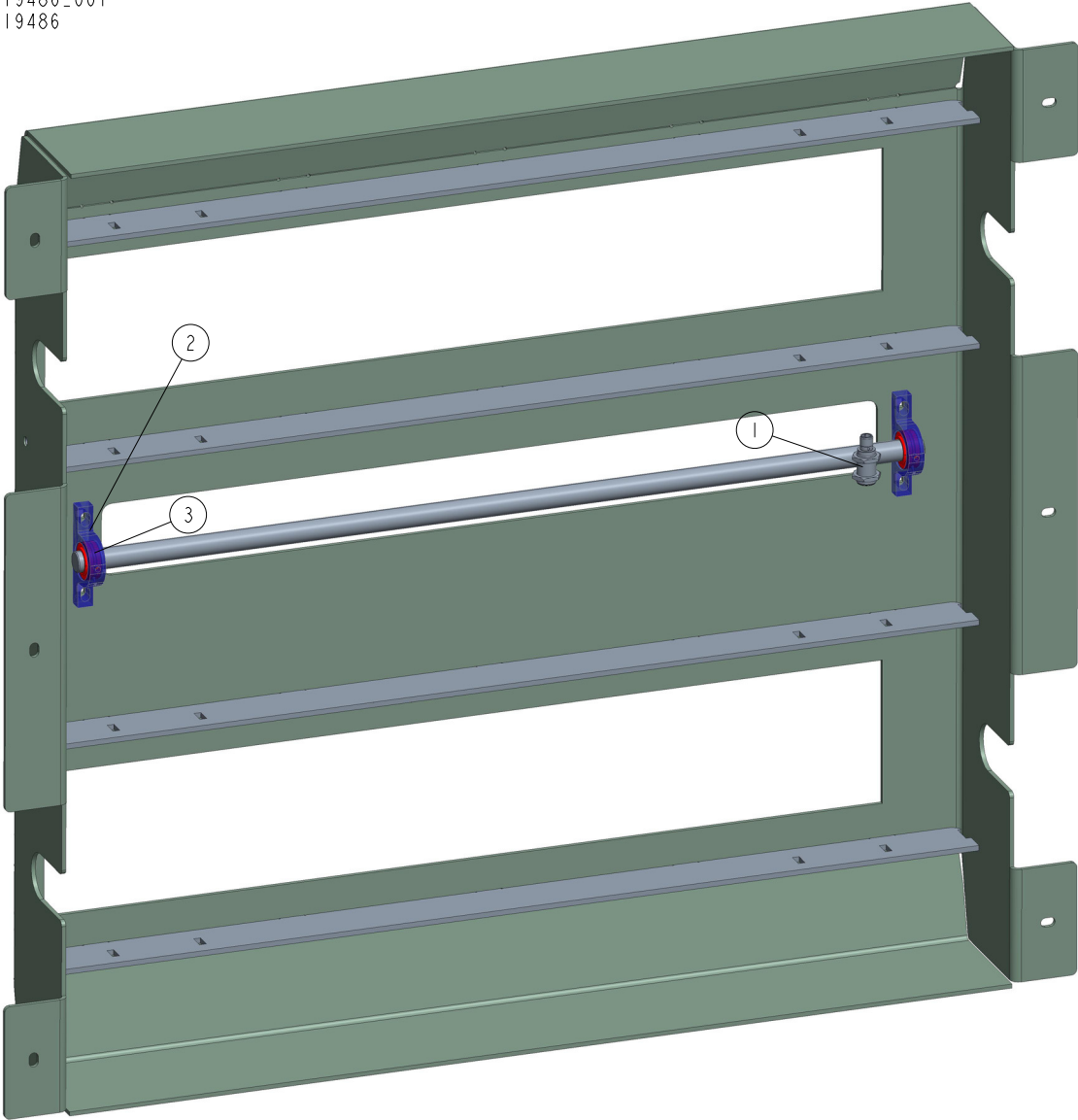


| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only) | PART #          | QTY |  |
|------|--------------------------------------------------------------|-----------------|-----|--|
| -    | <b>ROLLER TABLE</b>                                          | 719407-SLPT-016 | 1   |  |
| -    | TABLE, ROLLER                                                | 719468          | 1   |  |
| -    | ROLLER, SORTING TABLE - COMPLETE                             | 534853          | 6   |  |
| 1    | ROLLER, SORTING TABLE - COMPLETE                             | 534858-1        | 1   |  |
| 2    | BEARING, UCP207 (CX) W/HOUSING                               | 511501          | 2   |  |
| 3    | SPROCKET, 16B1 Z=13 N60 T12204                               | 534934          | 1   |  |
| 4    | BUSHING, BK13 322627 MOUNTING                                | 715106          | 1   |  |
| 5    | SPROCKET, 16B1 Z=12 ULMER 554570                             | 715087          | 16  |  |
| 6    | BAR, 16B-1 CHAIN GUIDE                                       | 534918          | 3   |  |
| 7    | CHAIN, LONGITUDINAL DRIVE                                    | 534936          | 1   |  |
| 8    | TRANSVERSE DRIVE ASSEMBLY <a href="#">See Section 11.3</a>   | 534941          | 1   |  |
| 9    | SPROCKET ASSEMBLY                                            | 535008          | 1   |  |
| -    | PLATE, SLIDE 1 - COMPLETE                                    | 534970          | 1   |  |
| 10   | BAR, 16B-1 CHAIN GUIDE                                       | 534968          | 1   |  |
| -    | PLATE, SLIDE 2 - COMPLETE                                    | 719525          | 1   |  |
| 11   | BAR, 16B-1 CHAIN GUIDE                                       | 534971          | 1   |  |

| REF. | DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)        | PART #   | QTY |  |
|------|---------------------------------------------------------------------|----------|-----|--|
| 12   | COVER 2 - COMPLETE <a href="#">See Section 11.2</a>                 | 719486   | 1   |  |
| -    | TRANSVERSE DRIVE CHAIN - COMPLETE                                   | 535010   | 3   |  |
| 13   | CHAIN, 16 B1 L=1676 MM                                              | 534973   | 2   |  |
| 14   | LINK, CHAIN W/TWO-SIDED DOG MK2                                     | 533999   | 2   |  |
| 15   | BLOCK, DOG                                                          | 534878-1 | 2   |  |
| -    | ROLLER TABLE 2                                                      | 719490   | 1   |  |
| -    | ROLLER, SORTING TABLE - COMPLETE                                    | 534853   | 7   |  |
| 16   | ROLLER, SORTING TABLE                                               | 534858-1 | 1   |  |
| 17   | BEARING, UCP207 (CX) W/HOUSING                                      | 511501   | 2   |  |
| 18   | SPROCKET, 16B1 Z=13 N60 T12204                                      | 534934   | 1   |  |
| 19   | BUSHING, BK13 322627 MOUNTING                                       | 715106   | 1   |  |
| 20   | SPROCKET, 16B1 Z=12 ULMER 554570                                    | 715087   | 8   |  |
| 21   | TRANSVERSE DRIVE CHAIN                                              | 719506   | 1   |  |
| 22   | SPROCKET ASSEMBLY                                                   | 535008   | 1   |  |
| -    | PLATE, SLIDE 1 - COMPLETE                                           | 719527   | 1   |  |
| 23   | BAR, 16B-1 CHAIN GUIDE                                              | 534968   | 1   |  |
| -    | PLATE, SLIDE 2 - COMPLETE                                           | 534972   | 1   |  |
| 24   | BAR, 16B-1 CHAIN GUIDE                                              | 534971   | 1   |  |
| -    | PLATE, SLIDE 2 - COMPLETE                                           | 719509   | 1   |  |
| 25   | BAR, 16B-1 CHAIN GUIDE                                              | 719508   | 1   |  |
| -    | EMERGENCY STOP SWITCH ASSEMBLY W/GUARD                              | 536687   | 2   |  |
| -    | SWITCH ASSEMBLY, EMERGENCY STOP                                     | 527795   | 1   |  |
| 26   | SWITCH, EMERGENCY XALJ174F                                          | E22703-P | 1   |  |
| -    | HR-302/18, 16-140/24-B8 + E-IE3-90L-4-1, 5-140/24- 230/400V-50HZ-UL | 719514   | 1   |  |
| 27   | MOTOREDUCER, HR302/36.21                                            | 719514_1 | 1   |  |
| 28   | MOTOR, 90B14 2800                                                   | 719514_2 | 1   |  |
| -    | HM-302/40, 5-140/24-L-B3 + E-IE3-90S-4-1, 1-140/24-230/400V-50HZ-UL | 719513   |     |  |
| 29   | MOTOREDUCER HM302/29.41                                             | 719513_1 | 1   |  |
| 30   | MOTOR, 90B14 1400                                                   | 719513_3 | 1   |  |
| -    | GUARD, INDUCTIVE SENSOR                                             | 536694   | 1   |  |
| 31   | SENSOR, IGC204 MAGNETIC SHUTOFF                                     | 512970   | 1   |  |

11.2 Cover

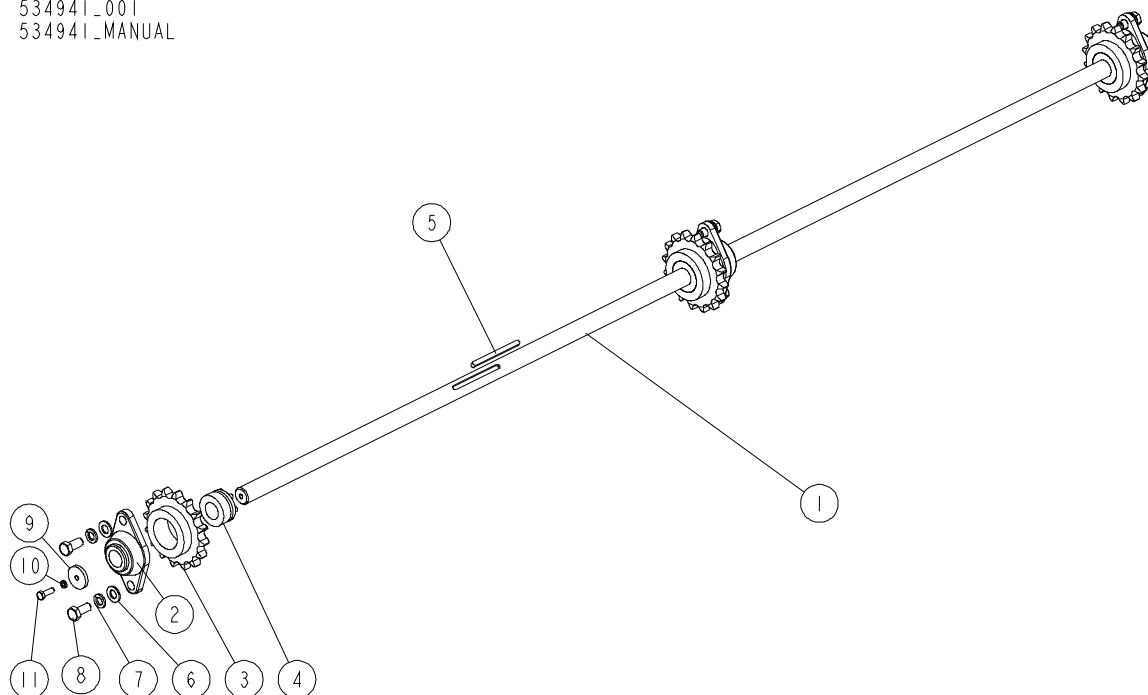
719486\_001  
719486



| REF | DESCRIPTION (u indicates parts available in assemblies only) | PART #   | QTY |  |
|-----|--------------------------------------------------------------|----------|-----|--|
| -   | COVER 2 - COMPLETE                                           | 719486   | 1   |  |
| 1   | SENSOR, IGC204 MAGNETIC SHUTOFF                              | 512970   | 1   |  |
| -   | BUMPER, COMPLETE                                             | 534999   | 1   |  |
| -   | BEARING HOUSING - COMPLETE                                   | 554588   | 2   |  |
| 2   | HOUSING, BEARING                                             | 554587-1 | 1   |  |
| 3   | BEARING, GE202RS                                             | 554589   | 1   |  |

## 11.3 Transverse Drive Assembly. (534941)

534941\_001  
534941\_MANUAL

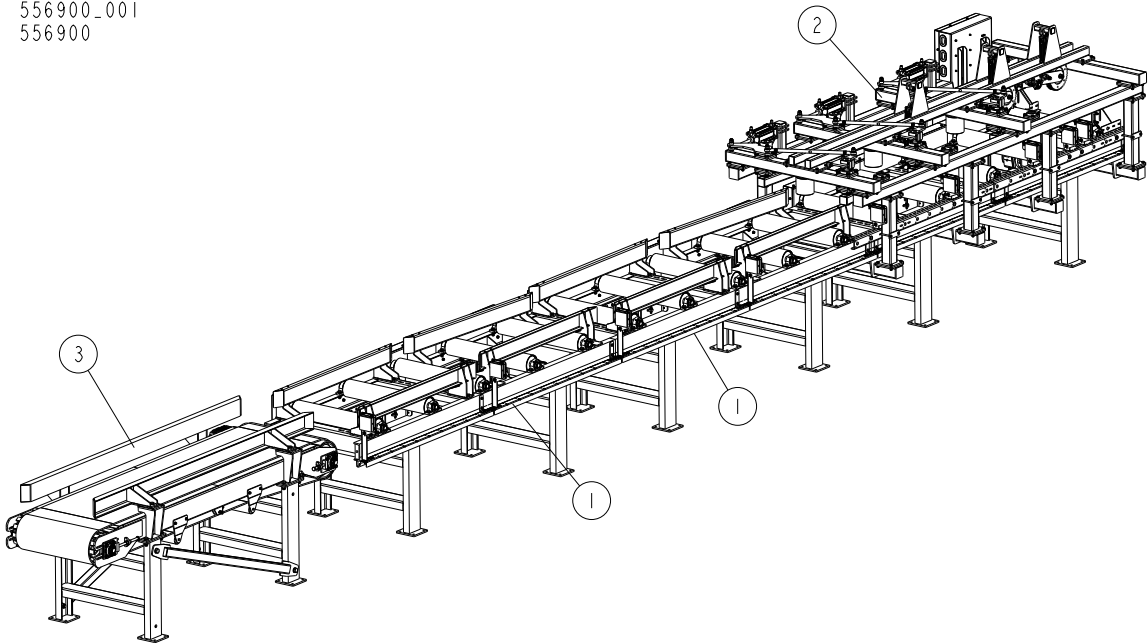


| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART #   | QTY |  |
|-----|--------------------------------------------------------------|----------|-----|--|
| -   | <b>TRANSVERSE DRIVE ASSEMBLY</b>                             | 534941   | 1   |  |
| 1   | SHAFT, TRANSVERSE DRIVE                                      | 534942   | 1   |  |
| 2   | BEARING, FYTB30FJ BALL (SKF)                                 | 090851   | 3   |  |
| 3   | SPROCKET, 16B-1 Z16                                          | 534920   | 3   |  |
| 4   | BUSHING, BK13 30/55323626 MOUNTING                           | 534919   | 3   |  |
| 5   | KEY, A8X7X110, PARALLEL                                      | 534943   | 1   |  |
| 6   | WASHER, FLAT, M14 BOLT, ZINC                                 | F81057-2 | 6   |  |
| 7   | WASHER, M14 SPLIT LOCK ZINC                                  | F81057-1 | 6   |  |
| 8   | BOLT, M14X30 -8.8 HEX HEAD FULL THREAD ZINC                  | F81005-6 | 6   |  |
| 9   | WASHER, 8.5/40-6 ZINC-PLATED                                 | 512011-1 | 2   |  |
| 10  | WASHER 8,2 ZINC                                              | F81054-4 | 2   |  |
| 11  | BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC                  | F81002-5 | 2   |  |

SECTION 12 CONVEYORS SET 556900

12.1 Conveyors Set 556900

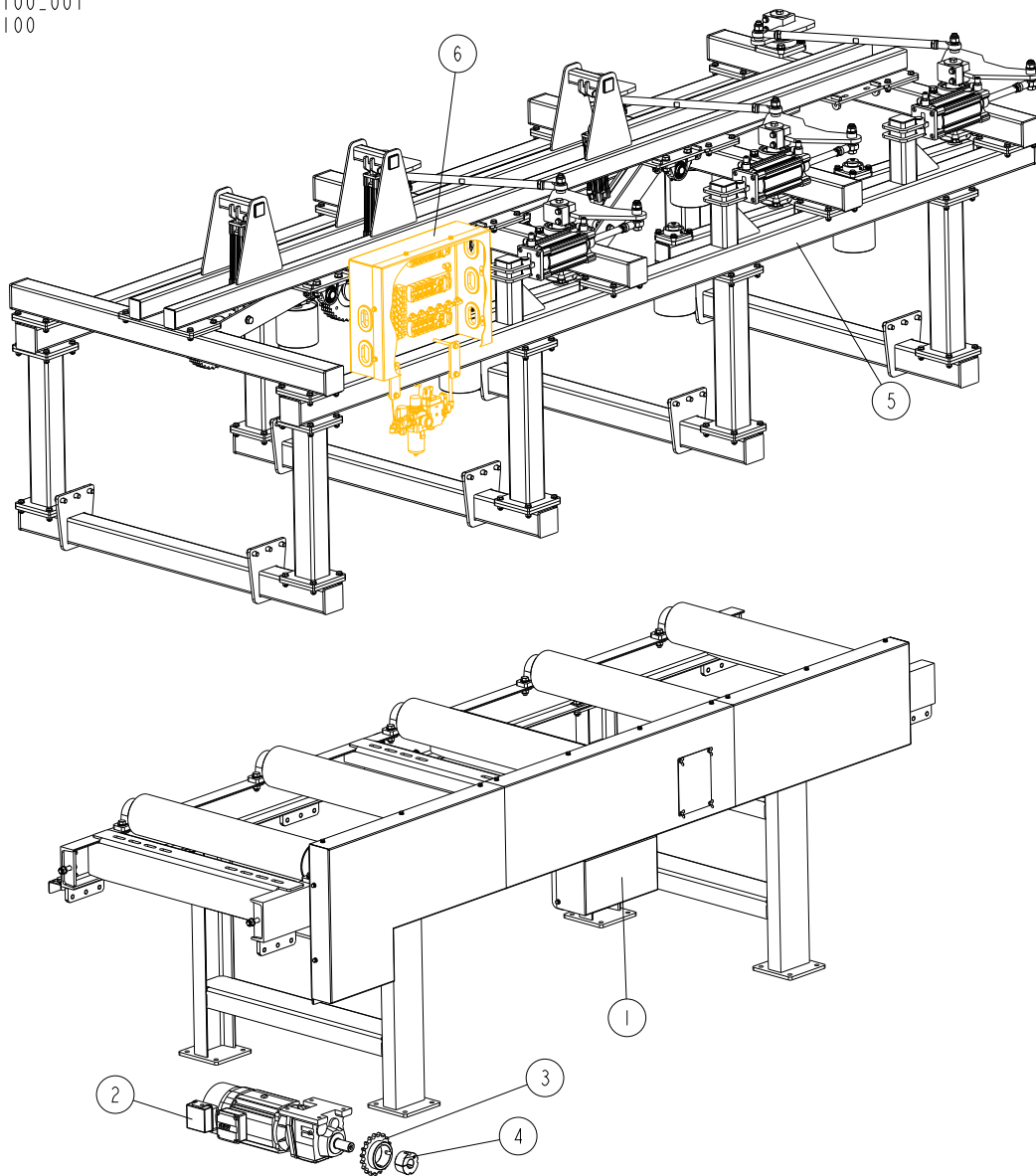
556900\_001  
556900



| REF | DESCRIPTION (◆ indicates parts available in assemblies only)     | PART # | QTY |  |
|-----|------------------------------------------------------------------|--------|-----|--|
| -   | NELSON WOOD SHIMS CONVEYORS SET                                  | 556900 | 1   |  |
| 1   | ROLLER TABLE W/GUIDES <a href="#">See Section 12.10</a>          | 560090 | 2   |  |
| 2   | CENTERING TABLES <a href="#">See Section 12.2</a>                | 560100 | 1   |  |
| 3   | NELSON WOOD SHIMS BELT CONVEYOR <a href="#">See Section 12.9</a> | 561300 | 1   |  |

## 12.2 Centering Table (560100)

560100\_001  
560100

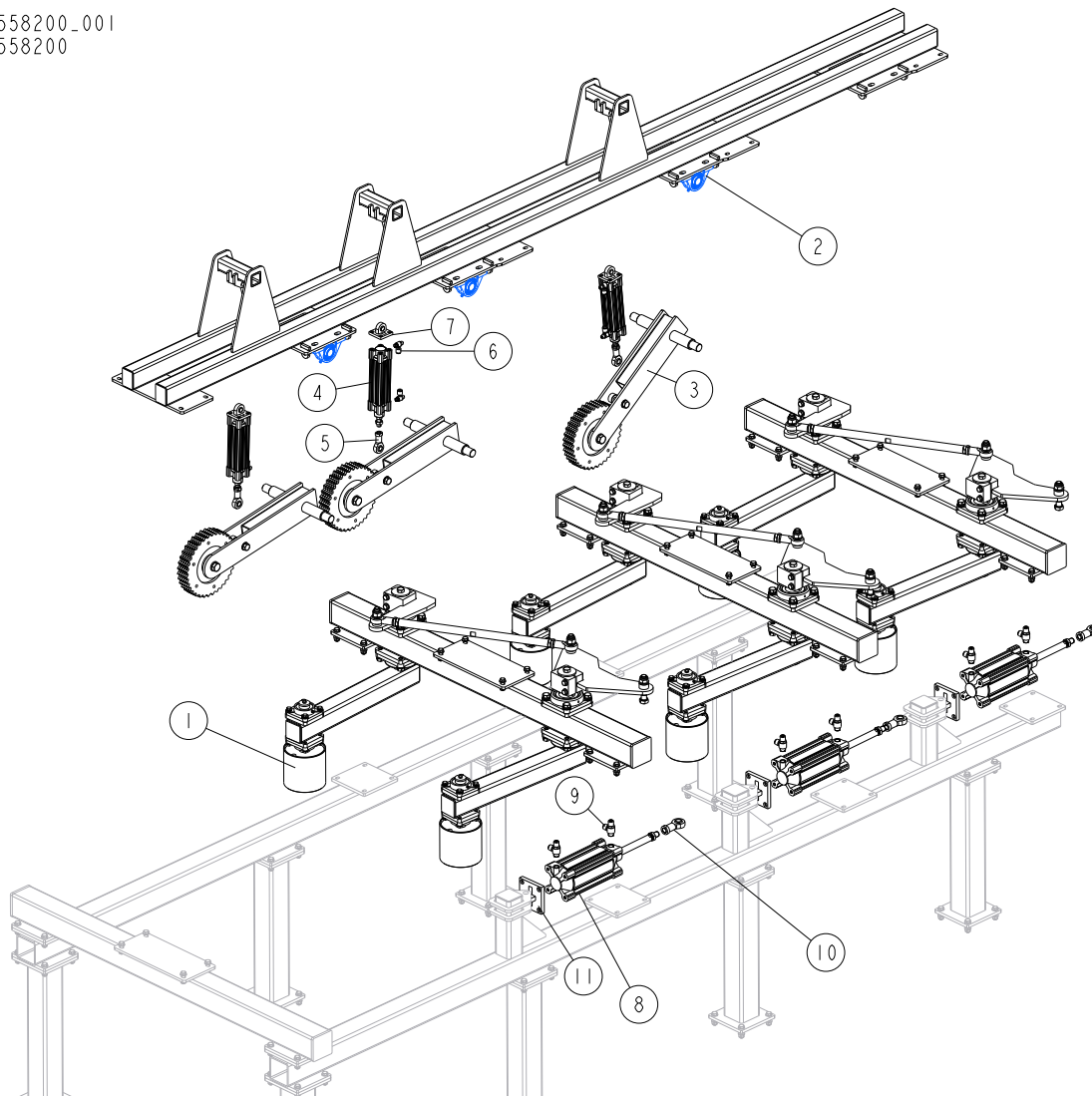


| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | CENTERING TABLE                                              | 560100 | 1   |  |
| 1   | ROLLER TABLE <a href="#">See Section 12.11</a>               | 556870 | 1   |  |
| -   | CENTERING TABLE DRIVE                                        | 560057 | 1   |  |
| 2   | MOTOREDUCER SEW R57DRN100LM4/TF/V                            | 560055 | 1   |  |
| -   | SPROCKET, 16B-1 Z19 OTW. 35                                  | 560058 | 1   |  |
| 3   | SPROCKET, 16B-1 Z19 T88397                                   | 556885 | 1   |  |
| 4   | BUSHING, TAPER LOCK 2517 X 35                                | 536118 | 1   |  |
| 5   | CENTERING MODULE <a href="#">See Section 12.3</a>            | 558200 | 1   |  |
| 6   | PNEUMATIC BOX <a href="#">See Section 12.6</a>               | 560084 | 1   |  |



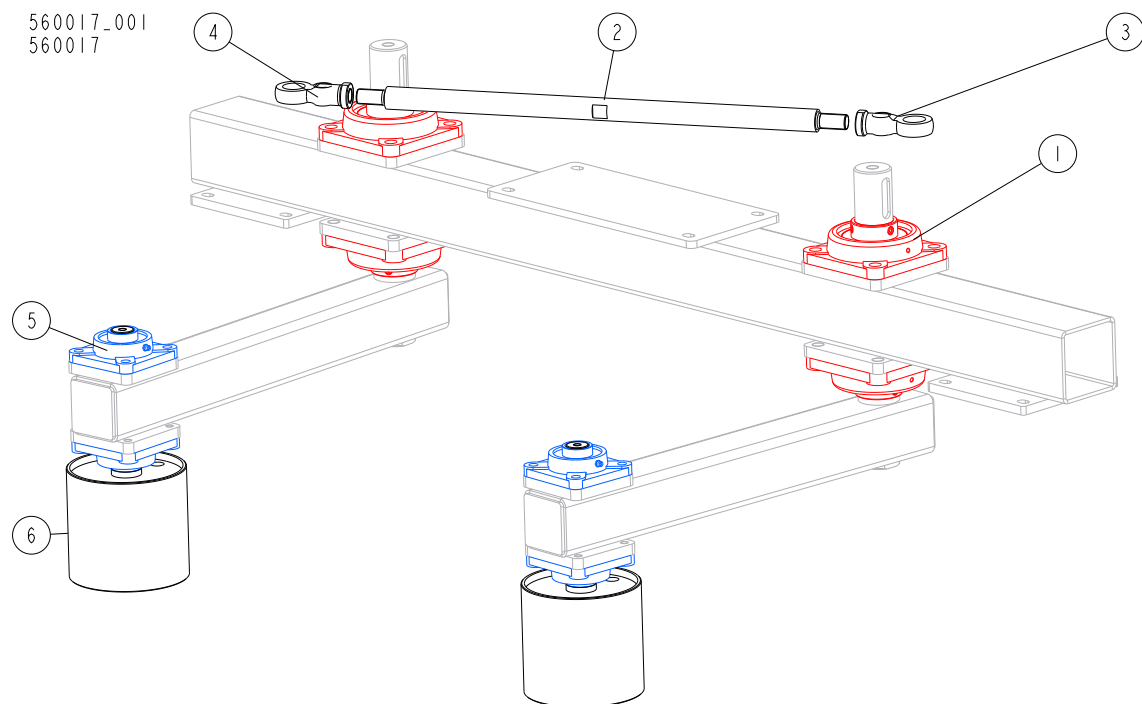
## 12.3 Centering Module. (558200)

558200\_001  
558200



| REF | DESCRIPTION (◆ indicates parts available in assemblies only)   | PART # | QTY |  |
|-----|----------------------------------------------------------------|--------|-----|--|
| -   | <b>CENTERING MODULE</b>                                        | 558200 | 1   |  |
| 1   | <b>CENTERING ROLLERS</b> <a href="#">See Section 12.4</a>      | 560017 | 3   |  |
| -   | <b>TUBE, ROLLER MOUNT - COMPLETE</b>                           | 558167 | 1   |  |
| 2   | BEARING, UCP 206 SKF W/HOUSIG                                  | 560069 | 6   |  |
| 3   | <b>UPPER HOLD-DOWN ROLLER</b> <a href="#">See Section 12.5</a> | 558168 | 3   |  |
| -   | <b>UPPER ROLLER AIR CYLINDER ASSEMBLY</b>                      | 558179 | 3   |  |
| 4   | CYLINDER, CP96SDB50-150 AIR                                    | 511709 | 1   |  |
| 5   | EYE, KJ16D SPHERICAL ROD (SMC)                                 | 528120 | 1   |  |
| 6   | VALVE, AS2201F-02-10SD /SMC/ THROTTLE                          | 528124 | 2   |  |
| 7   | SWIVEL MOUNTING CLIP, CS5050 SMC                               | 558180 | 1   |  |
| -   | <b>CENTERING ROLLER AIR CYLINDER ASSEMBLY</b>                  | 560011 | 3   |  |
| 8   | CYLINDER, CP96SDB100-160C-M9BW AIR                             | 528089 | 1   |  |
| 9   | VALVE, AS4201F-04-12SD THROTTLE                                | 528086 | 2   |  |
| 10  | EYE, KJ20D SPHERICAL ROD                                       | 528092 | 1   |  |
| 11  | SWIVEL MOUNTING CLIP CS5100                                    | 560010 | 1   |  |

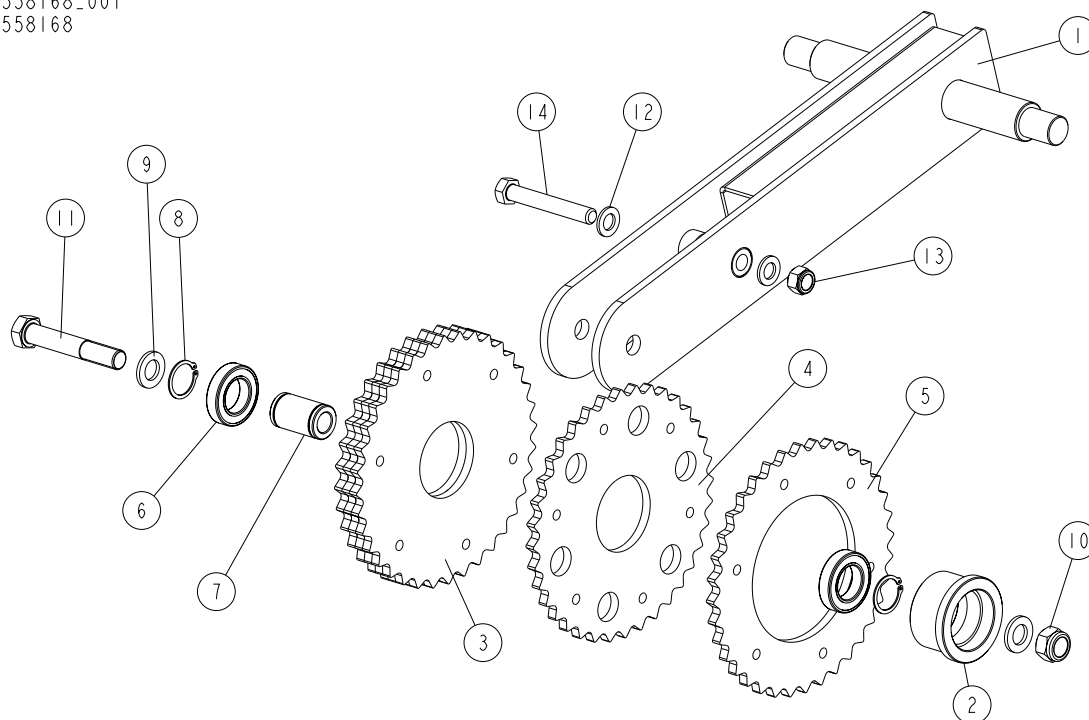
## 12.4 Centering Rollers (560017)



| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART #   | QTY |  |
|-----|--------------------------------------------------------------|----------|-----|--|
| -   | <b>CENTERING ROLLERS</b>                                     | 560017   | 1   |  |
| 1   | <b>BEARING, UCF 210 FAG/SKF/NSK/INA W/HOUSING</b>            | 523104   | 4   |  |
| -   | <b>ROD, TORQUE</b>                                           | 523348   | 1   |  |
| 2   | ROD, CONNECTION                                              | 523347-1 | 1   |  |
| 3   | JOINT, GN 648.1-20-M20X1,5-W BALL                            | 528103   | 1   |  |
| 4   | JOINT, GN 648.1-20-M20X1,5L-W BALL                           | 528104   | 1   |  |
| 5   | <b>BEARING, UCF 206 SKF W/HOUSING</b>                        | 520775   | 4   |  |
| 6   | <b>ROLLER, PRESSURE WLDMT/PTD</b>                            | 528068-1 | 2   |  |

## 12.5 Upper Hold-Down Roller (558168)

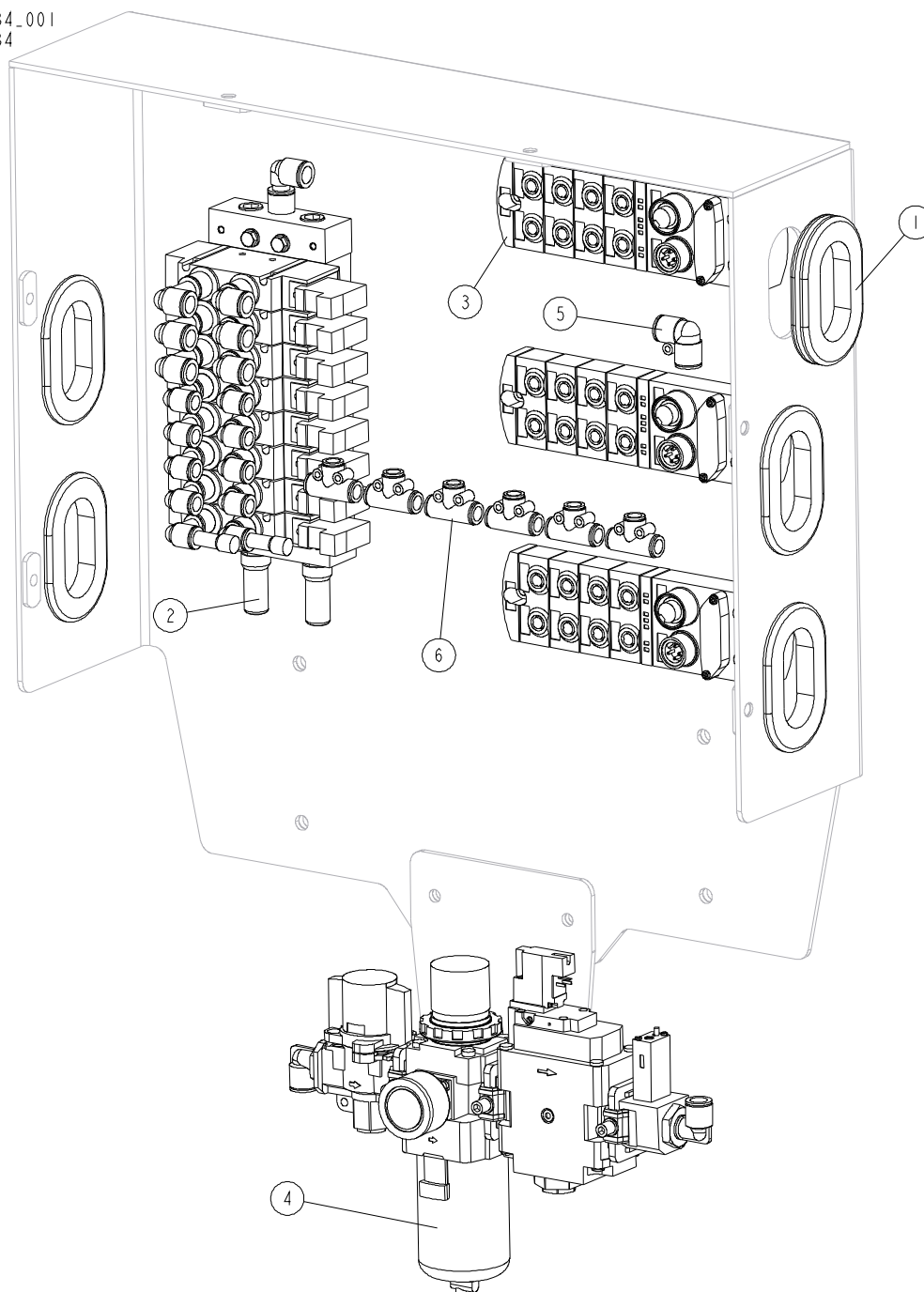
558168\_001  
558168



| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART #    | QTY |  |
|-----|--------------------------------------------------------------|-----------|-----|--|
| -   | UPPER HOLD-DOWN ROLLER                                       | 558168    | 1   |  |
| 1   | ARM, HOLD-DOWN ROLLER                                        | 558171-1  | 1   |  |
| -   | ROLLER, HOLD-DOWN                                            | 558177-1  | 1   |  |
| -   | ROLLER WELDMENT, HOLD-DOWN                                   | 558174    | 1   |  |
| 2   | BUSHING, HOLD-DOWN ROLLER                                    | 558172    | 1   |  |
| 3   | SPROCKET, MIDDLE                                             | 558176    | 1   |  |
| 4   | SPROCKET, ROLLER                                             | 558173    | 2   |  |
| 5   | SPROCKET, OUTER                                              | 558175    | 2   |  |
| 6   | BEARING, 6007-2RS ROLLING                                    | 096955    | 2   |  |
| 7   | BUSHING, HOLD-DOWN ROLLER                                    | 558178    | 1   |  |
| 8   | RING, Z35 OUTSIDE RETAINING                                  | F81090-36 | 2   |  |
| 9   | WASHER, 21 FLAT ZINC                                         | F81059-2  | 2   |  |
| 10  | NUT, M20-8- DIN985 HEX NYLON ZINC LOCK                       | F81037-2  | 1   |  |
| 11  | BOLT, M20X120-8.8 HEX HEAD ZINC                              | F81007-14 | 1   |  |
| 12  | WASHER, 17 FLAT ZINC                                         | F81058-1  | 2   |  |
| 13  | NUT, M16 HEX NYLON ZINC LOCK                                 | F81036-2  | 1   |  |
| 14  | BOLT, M16X110-8.8-B-HEX HEAD ZINC                            | F81006-24 | 1   |  |

## 12.6 Pneumatic box 560084

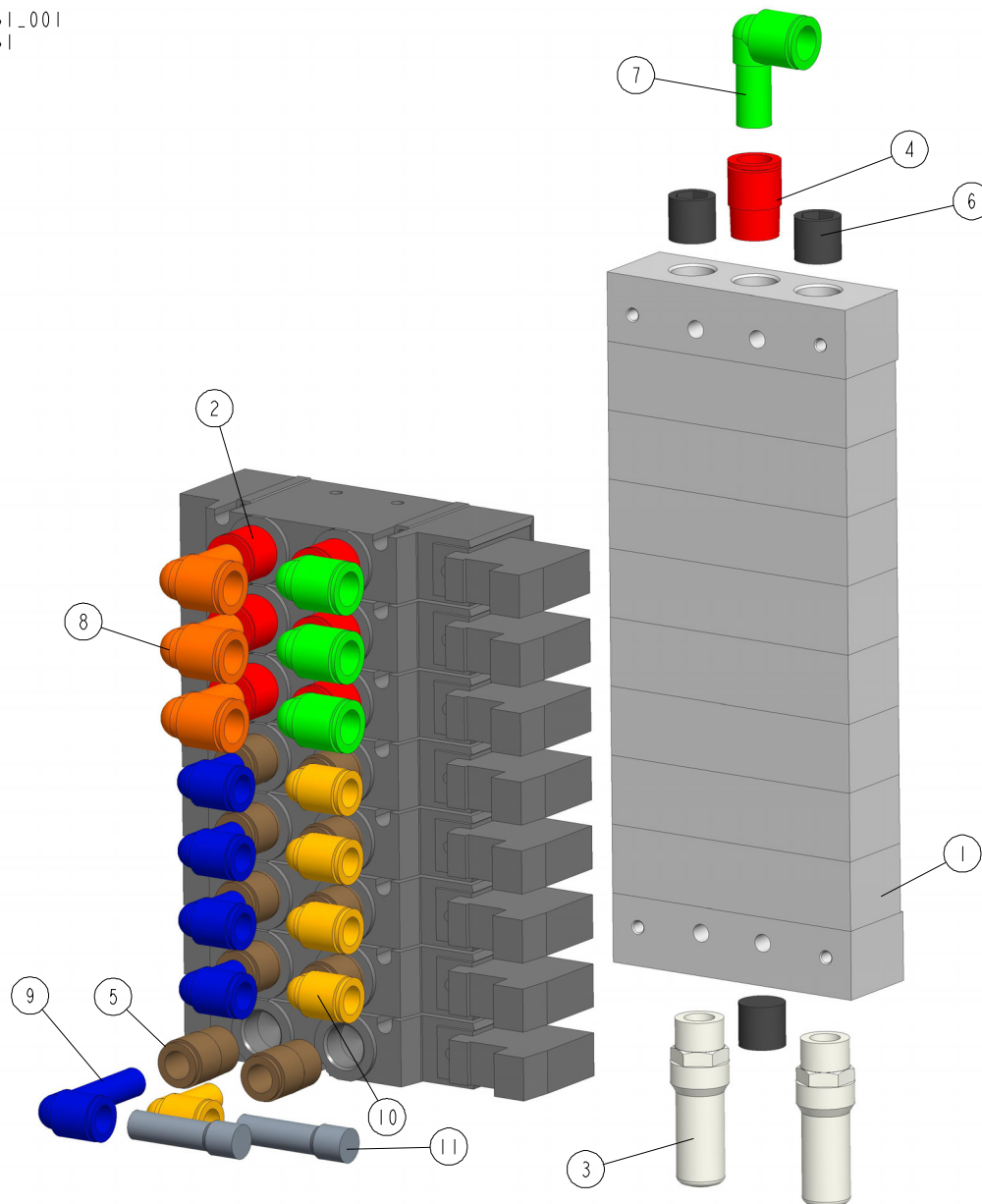
560084\_001  
560084



| REF | DESCRIPTION (♦ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | PNEUMATIC BOX                                                | 560084 | 1   |  |
| 1   | GROMMET, RUBBER                                              | 089532 | 5   |  |
| 2   | ASSY, VALVE BANK <a href="#">See Section 12.7</a>            | 560061 | 1   |  |
| 3   | PLC MODULE ETHERNET/IP IMPACT67 DIO16                        | 564691 | 3   |  |
| 4   | AIR SUPPLY ASSEMBLY <a href="#">See Section 12.8</a>         | 560064 | 1   |  |
| 5   | FITTING, KQ2L12-00A MALE ELBOW                               | 535336 | 1   |  |
| 6   | FITTING, TEE                                                 | 511069 | 6   |  |

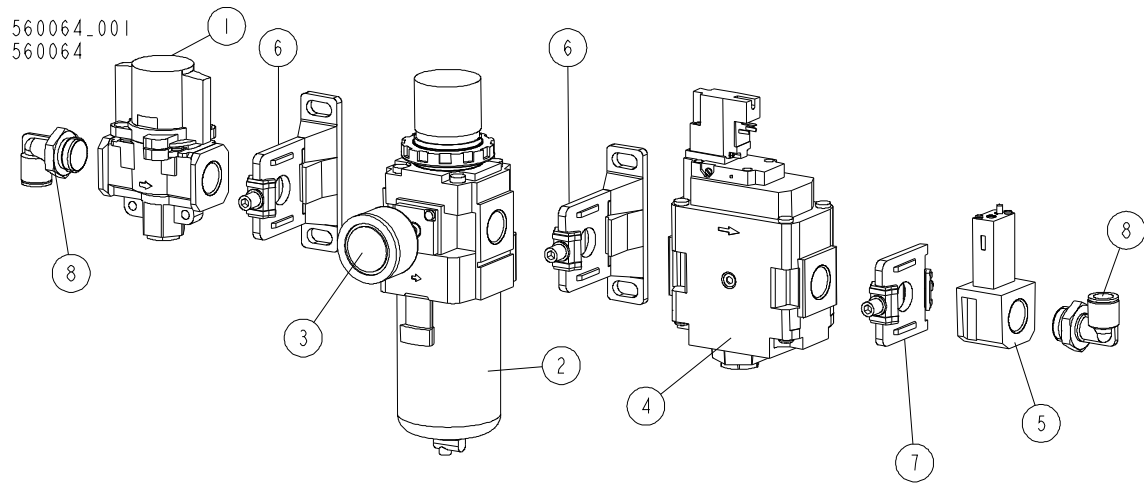
## 12.7 Valve Bank 560061

560061-001  
560061



| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | ASSY, VALVE BANK                                             | 560061 | 1   |  |
| 1   | BASE, MANFOLD SS5Y9-23-08-00F-Q                              | 560062 | 1   |  |
| 2   | VALVE, 5/2-3/8" SY9120-5YO-03F-Q SOLENO                      | 531836 | 8   |  |
| 3   | SILENCER, R3/8 - AN30-03                                     | 515598 | 2   |  |
| 4   | FITTING, KQ2S12-03AS MALE                                    | 533270 | 7   |  |
| 5   | FITTING, KQ2S10-03AS HEX HEAD MALE CONNECTOR                 | 560063 | 10  |  |
| 6   | PLUG, BS38A SMC HOLE                                         | 533267 | 3   |  |
| 7   | FITTING, KQ2L12-99A ELBOW                                    | 534714 | 4   |  |
| 8   | FITTING, KQ2W12-99A SMC ELBOW                                | 560091 | 3   |  |
| 9   | FITTING, KQ2W10-99A SMC ELBOW                                | 547623 | 5   |  |
| 10  | FITTING, KQ2L10-99A SMC ELBOW                                | 539675 | 5   |  |
| 11  | PLUG, KQ2P-10 SMC                                            | 552699 | 2   |  |

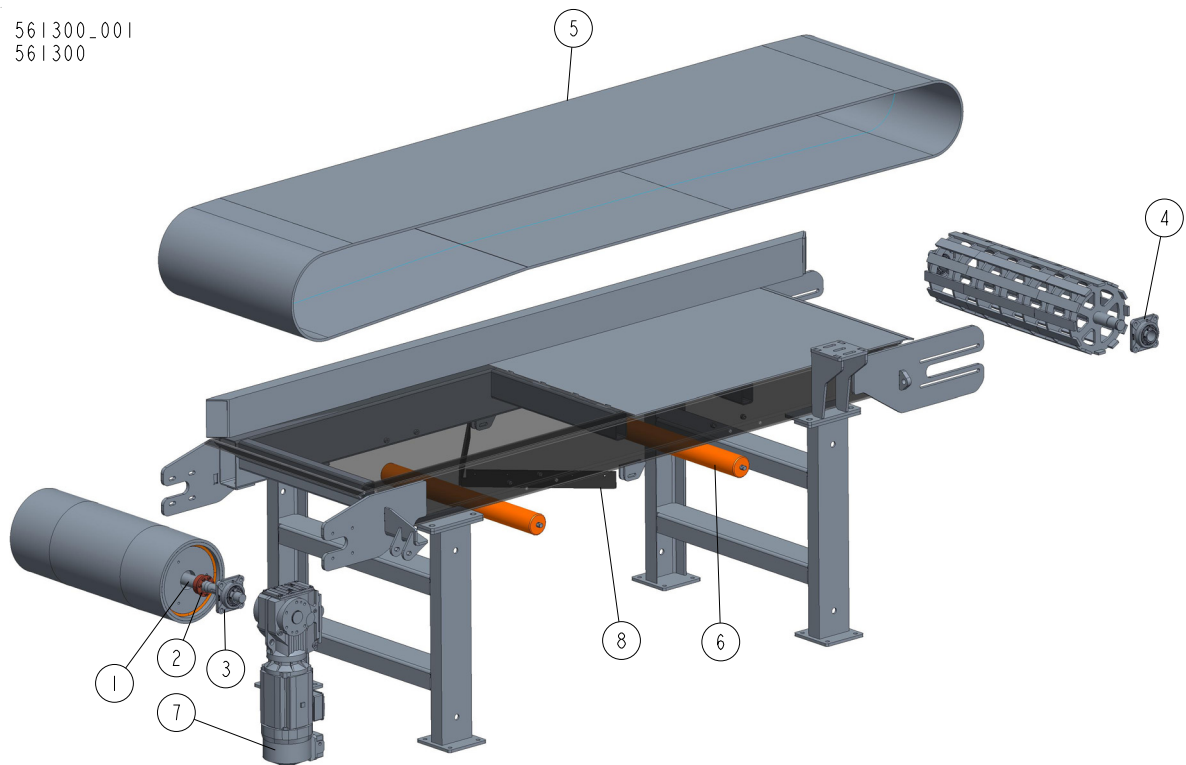
## 12.8 Air Supply Assembly 560064



| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | AIR SUPPLY ASSEMBLY                                          | 560064 | 1   |  |
| 1   | VALVE, 3/2 VHS40-F04B-S HAND RELIEF                          | 533280 | 1   |  |
| 2   | REGULATOR, AW40-F04H-B FILTER (SMC)                          | 533281 | 1   |  |
| 3   | GAUGE, R1/8" G46-10-01-L PRESSURE (SMC)                      | 533282 | 1   |  |
| 4   | VALVE, AV4000-F04S-5YOB-A SOFT START (SM)                    | 533283 | 1   |  |
| 5   | SWITCH, IS10E-40F04-6L-A PRESSURE (SMC)                      | 533286 | 1   |  |
| 6   | SPACER, Y400T-A W/BACKET (SMC)                               | 533284 | 2   |  |
| 7   | SPACER, Y400-A                                               | 533285 | 1   |  |
| 8   | FITTING, 1/2" FI=12 KQ2L12-G04A MALE ELB                     | 533288 | 2   |  |

## 12.9 Belt Conveyor (561300)

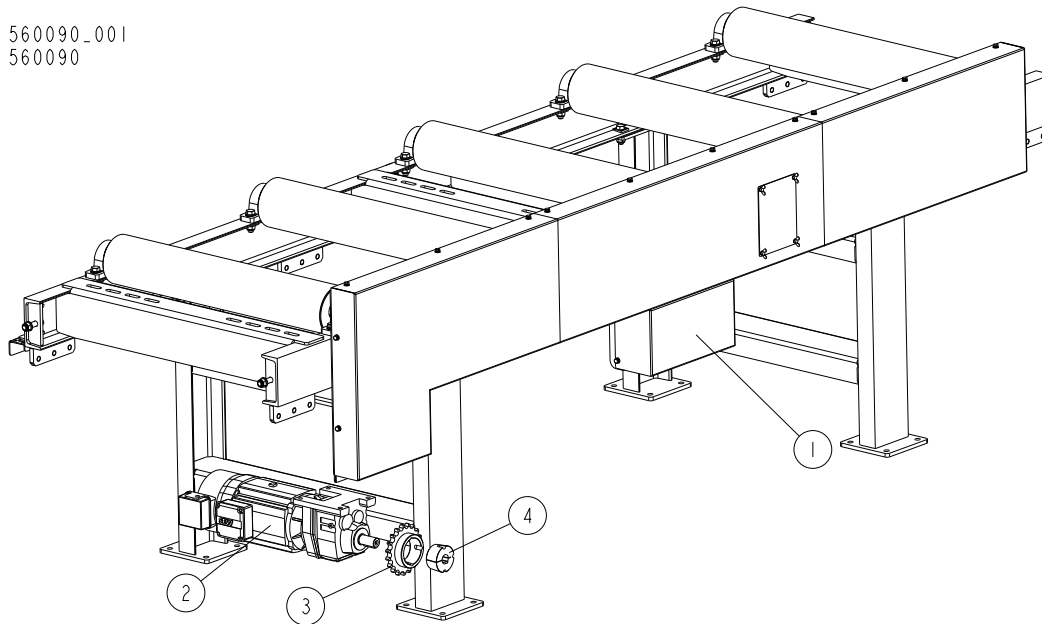
561300\_001  
561300



| REF | DESCRIPTION (♦ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | <b>NELSON WOOD SHIMS BELT CONVEYOR</b>                       | 561300 | 1   |  |
| -   | <b>DRIVE SIDE PULLEY - COMPLETE</b>                          | 561253 | 1   |  |
| 1   | SHAFT, DRIVE SIDE PULLEY                                     | 561324 | 1   |  |
| 2   | SLEEVE, BK16 50X80 HABERKORN CLAMPING                        | 529007 | 2   |  |
| 3   | BEARING, UCF209 SKF W/HOUSING                                | 539016 | 2   |  |
| -   | <b>IDLE SIDE PULLEY - COMPLETE</b>                           | 561260 | 1   |  |
| 4   | BEARING, UCF209 SKF W/HOUSING                                | 539016 | 2   |  |
| 5   | <b>BELT, L=7550 MM</b>                                       | 561283 | 1   |  |
| -   | <b>ROLLER ASSEMBLY</b>                                       | 561285 | 2   |  |
| 6   | ROLLER, Ø=89-900/3                                           | 719125 | 1   |  |
| 7   | <b>MOTOREDUCER, KA67/T DRN100L4/TF/V</b>                     | 561322 | 1   |  |
| -   | <b>BELT SCRAPER - COMPLETE</b>                               | 561294 | 1   |  |
| 8   | PLATE, BELT SCRAPER - COMPLETE                               | 561293 | 2   |  |

## 12.10 Roller Table with Guides (560090)

560090\_001  
560090

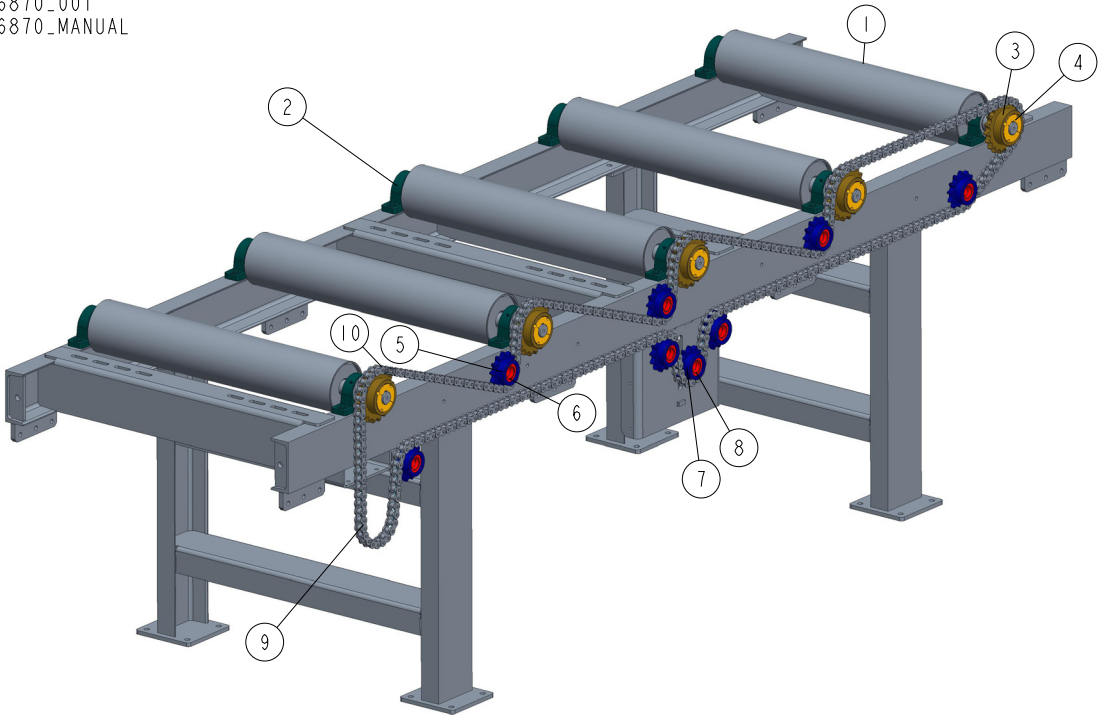


| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART # | QTY |  |
|-----|--------------------------------------------------------------|--------|-----|--|
| -   | ROLLER TABLE W/GUIDES                                        | 560090 | 1   |  |
| 1   | ROLLER TABLE <a href="#">See Section 12.11</a>               | 556870 | 1   |  |
| -   | ROLLER TABLE DRIVE                                           | 560056 | 1   |  |
| 2   | MOTOREDUCER SEW R47DRN100LM4/TF/V                            | 560054 | 1   |  |
| -   | SPROCKET, 16B-1 Z19 OTW. 30                                  | 556890 | 1   |  |
| 3   | SPROCKET, 16B-1 Z19 T88397                                   | 556885 | 1   |  |
| 4   | BUSHING, TAPERLOCK 2517/30 T31121                            | 556891 | 1   |  |



12.11 Roller Table (556870)

556870\_001  
556870\_MANUAL



| REF | DESCRIPTION (◆ indicates parts available in assemblies only) | PART #   | QTY |  |
|-----|--------------------------------------------------------------|----------|-----|--|
| -   | ROLLER TABLE                                                 | 556870   | 1   |  |
| -   | ROLLER - COMPLETE                                            | 556880   | 5   |  |
| 1   | ROLLER                                                       | 556881-1 | 1   |  |
| 2   | BEARING, UCP 208 W/HOUSING                                   | 523125   | 2   |  |
| -   | SPROCKET, 16B-1 Z19 OTW. 40                                  | 556887   | 1   |  |
| 3   | SPROCKET, 16B-1 Z19 T88397                                   | 556885   | 1   |  |
| 4   | BUSHING, TAPERLOCK 2517/40 T31125                            | 556886   | 1   |  |
| -   | SPROCKET, CHAIN GUIDE - COMPLETE                             | 556869-1 | 7   |  |
| 5   | SPROCKET, CHAIN GUIDE                                        | 556868   | 1   |  |
| 6   | BEARING, 6007-2RS ROLLING                                    | 096955   | 2   |  |
| -   | SPROCKET, CHAIN TENSION - COMPLETE                           | 558143-1 | 1   |  |
| 7   | SPROCKET, CHAIN GUIDE                                        | 556868   | 1   |  |
| 8   | BEARING, 6007-2RS ROLLING                                    | 096955   | 2   |  |
| -   | ROLLER TABLE CHAIN                                           | 560067   | 1   |  |
| 9   | CHAIN, 16B-1 311 LINKS 7899 MM                               | 556896   | 1   |  |
| 10  | LINK, 16B-1 IWIS T35759                                      | 560068   | 1   |  |