

Wood-Mizer®

TV6000

**Safety, Operation,
Maintenance**

TV6000

rev. 1.00



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

Form #2515

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Getting Service

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.

Wood-Mizer will accept these methods of payment:

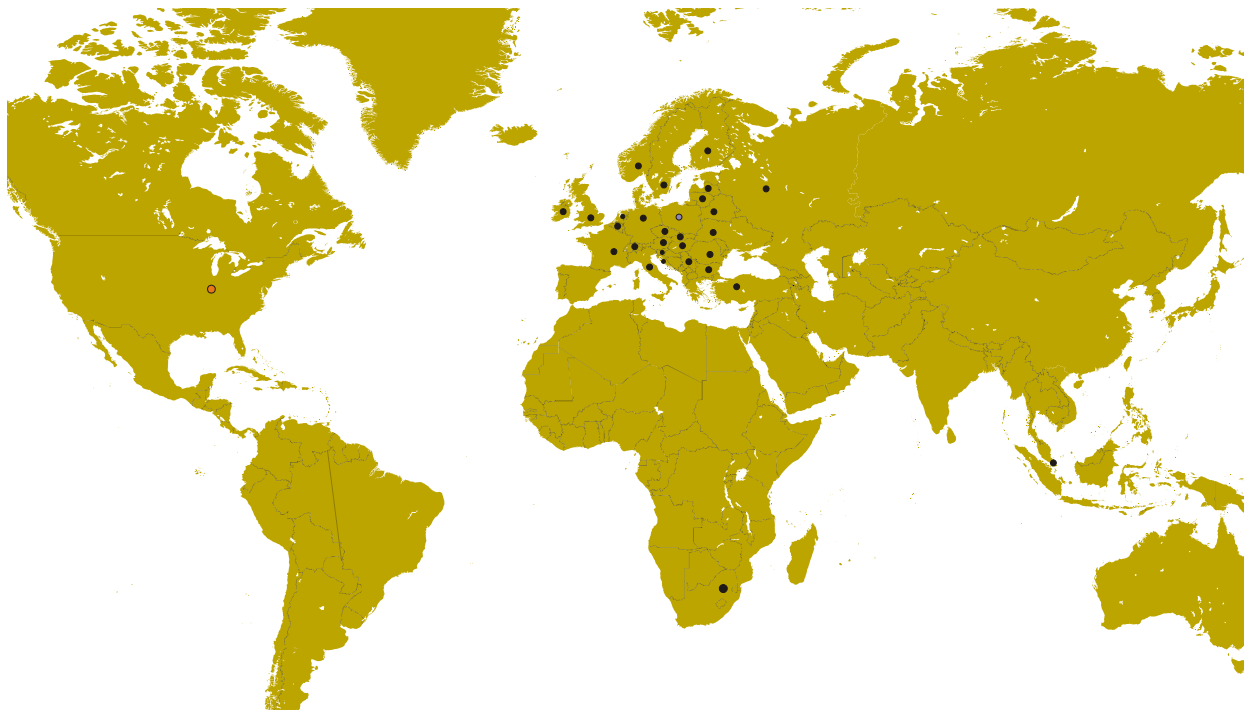
- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

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

Technical data are subject to change without prior notice.

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

Branches & Authorized Sales Centers Wood-Mizer Locations (North and South America)



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Branches & Authorized Sales Centers

For a complete list of dealers, visit www.woodmizer.com

SECTION 1 SAFETY

1.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions.



DANGER! indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



WARNING! suggests a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION! refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury or damage to equipment.



IMPORTANT! indicates vital information.

NOTE: gives helpful information.



Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

1.2 Safety Instructions



IMPORTANT! The saw is intended for sawing wood only. The saw must not be used for other purposes such as cutting ice, metal or any other materials. [See Section 5.2](#) for log size capacities of the machine.

IMPORTANT! The operator of the sawmill should get adequate training in operation and adjustment of the machine.

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 Operator's Manual before operating the machine. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

Only adult persons who have read and understood the entire operator's manual should operate the machine. The machine is not intended for use by or around children.

IMPORTANT! It is always the owner's responsibility to comply with all applicable national and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer TVS/SVS saw. All Wood-Mizer TVS/SVS owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.

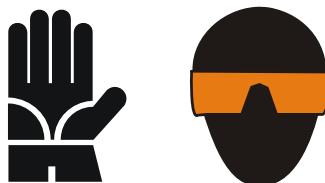


Wear Safety Clothing



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

WARNING! Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or 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 Machine And Area Around Clean



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

Dispose Of Sawing By-Products Properly



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

CAUTION! The machine work-stand should be equipped with a 4 kg/8.818 lb or bigger dry powder extinguisher.

Check the Machine Before Operation



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



WARNING! Fasten the machine to the floor before operating.

IMPORTANT! The machine's operator should get training in operation and adjustment of the machine.



Keep Persons Away



DANGER! Keep all persons out of the path of moving equipment and lumber when operating the machine. Failure to do so will result in serious injury.

DANGER! Always be sure all persons are out of the path of the blade before starting the motor. Failure to do so will result in serious injury.



WARNING! Allow blade to come to a complete stop before opening the blade housing cover. Failure to do so will result in serious injury.

Keep Hands Away



DANGER! Always shut off the blade motor before changing the blade. Failure to do so will result in serious injury.

DANGER! Motor components can become very hot during operation. Avoid contact with any part of a hot motor. Contact with hot motor components can cause serious burns. Therefore, never touch or perform service functions on a hot motor. Allow the motor to cool sufficiently before beginning any service function.

DANGER! Always keep hands away from moving bandsaw blade. Failure to do so will 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.



WARNING! Use extreme caution when spinning the blade wheels by hand. Make sure your hands are clear of the blade and wheel spokes before spinning. Failure to do so may result in serious injury.

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 blades.

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 boxes 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 machine 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.

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.

WARNING! Remove the blade before performing any service to the motor. Failure to do so may result in serious injury.



DANGER! The operator must not for any reason perform any laser maintenance or repair work.

DANGER! Never clean the blade or the blade wheels using a brush or a scraper while the blade is in motion.

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.

Keep Safety Labels In Good Condition



IMPORTANT! Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order more decals.

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

Fire-Fighting

CAUTION! The machine’s work-stand should be equipped with a 4 kg/8.818 lb or bigger dry powder extinguisher.

Safety Labels Description

See Table 1-1. See the table below for descriptions of the pictographic warning and informational decals placed on the saw.

TABLE 1-1

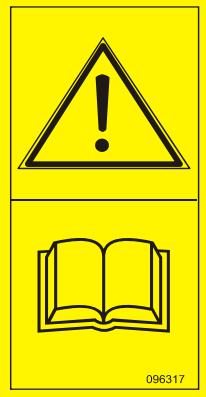
Decals View	Decal No.	Description
	096317	Carefully read the operator’s manual before operating the machine. Observe all safety instructions and rules when operating.
	099220	Close all guards prior to operating the machine.

TABLE 1-1

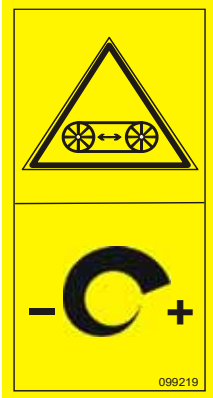
 099219	099219	Blade tension adjustment. Turn right to tighten; turn left to release.
 099221	099221	Keep all persons at a safe distance from work area when operating the machine.
 096314	096314	Keep all persons at a safe distance from work area when operating the machine.

TABLE 1-1

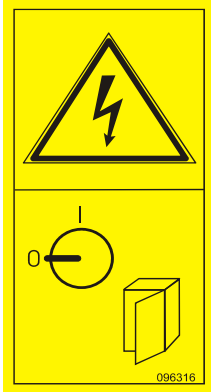
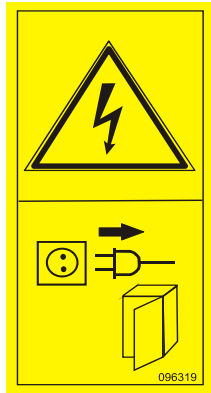
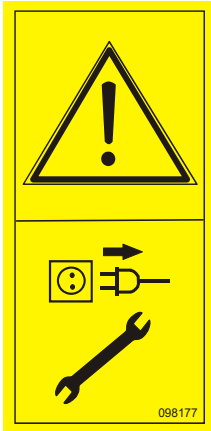
	096316	Opening of the electric box is possible only when the switch is in the "0" position.
	096319	Always disconnect the power cord before opening the electric box.
	098177	Always disconnect the power cord before performing any service.

TABLE 1-1

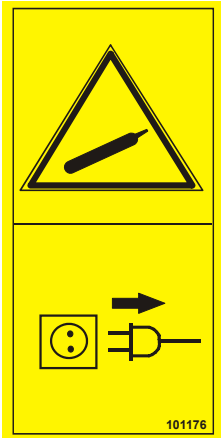
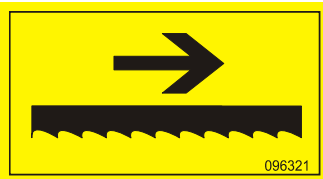
 099540	099540	CAUTION! Gear train - Keep a safe distance!
 101176	101176	CAUTION! Compressed air in the system even after electric power disconnection
 096321	096321	Blade movement direction
 500031	500031	CAUTION! Do not adjust the turnbuckles!

TABLE 1-1

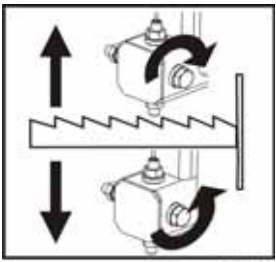
	S12004G	Always wear eye protection equipment when operating this machine.
	S12005G	Always wear ear protection equipment when operating this machine.
	501465	CAUTION! Always wear safety boots when operating this machine.
	501467	Lubrication point
	P11789	Blade alignment. Turn right to move the blade out on the wheel; turn left to move the blade in on the wheel.

TABLE 1-1

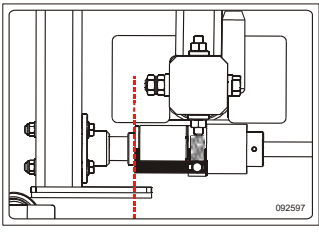
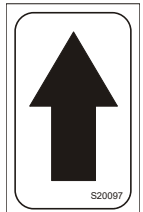
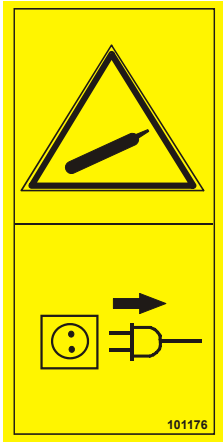
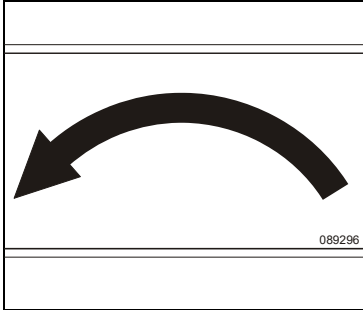
	092597	Blade tension adjustment (See Section 2.5)
	P85070	CE sign
	S20097	Motor rotation direction
	505346	Tensioner valve handle positions
	101176	CAUTION! Compressed air in the system even after electric power disconnection
	513181	Pneumatic system pressure value

TABLE 1-1

	089296	Rotation direction
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SECTION 2 OPERATION

2.1 General Information

Thank you for choosing Wood-Mizer wood processing equipment!

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.

TV6000 saw is intended for sawing wood only. The machine must not be used for any other purposes such as cutting ice, metal or other materials.

Using the machine correctly, you will obtain a material of the highest quality and high degree of accuracy.

The TV6000 saw should be operated only by an adult who has read and understood the entire operator's manual.

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

See Figure 2-1. The TV6000 main components are shown below.

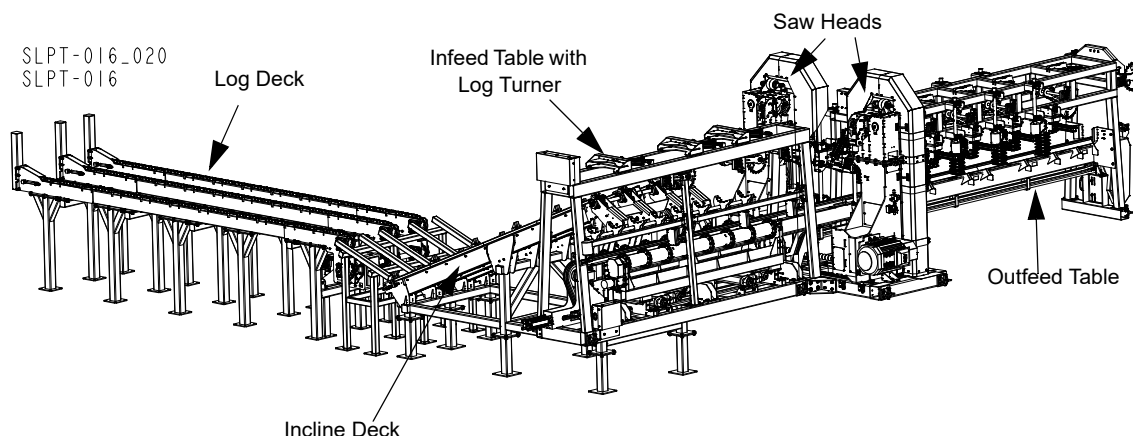


FIG. 2-1. TV6000 MAIN COMPONENTS

2.2 TV6000 Setup



IMPORTANT! Before starting to use the machine you have to meet the following conditions:

- Set up the saw on firm and level ground. Secure the saw to the ground to prevent moving during operation. A concrete foundation or pads and anchored bolts are recommended.
- The machine should always be operated with the sawdust collection system turned on.
- The machine should be operated under roof only.
- The machine should be operated in temperatures of -15° C to 40° C (5°F to 104°F) only.
- The light intensity in the operator's work-place must be at least 300lx¹.



IMPORTANT! When starting the machine for the first time, check that the blade rotation direction is as indicated by the arrow located on the blades covers. If the rotation direction is incorrect, invert the phases in the phase inverter located in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of all machine motors (machines not equipped with a phase failure relay). If your machine is equipped with a phase failure relay, the motors will not start until the phases are not set properly.



IMPORTANT! When starting the machine for the first time, let it run without any load for 1-2 hours. It will let the infeed and outfeed table drive components grind in.



DANGER! It is recommended that a 30mA Ground Fault Interrupter (GFI) be used.

- The TV6000 can be lifted using a forklift only. The forklift must be rated for at least 8000kg (18000 lb). The saw is equipped with forklift pockets.

2.3 Machine Start



DANGER! Before starting the machine, perform these steps to avoid injury and/or damage to the equipment:

- Close the blade housing covers and replace any guards removed for service.
- Check the feed track and remove all loose objects such as tools, wood, etc.

1. The light source can not cause stroboscopic effect.

- Check that the blades are properly tensioned.
- Make sure all persons are at a safe distance from the machine.
- Check that the emergency stops are released.
- Turn on the dust extraction system

NOTE: The machine will not start if either of the emergency stops is on.



CAUTION! If the blade breaks during machine operation, push the emergency stop button to stop the blade motor and wait at least 10 seconds before you open the blade housing cover.

2.4 LubeMizer System

The Lube Mizer system is used to lubricate the blade during sawing. The LubeMizer applies lubricant to both sides of the blade as you are sawing to reduce resin buildup on the blade. The LubeMizer controls allow you to adjust volume of the lubricant for various types of wood. The LubeMizer option uses less volume than the standard Water Lube, helping to reduce lubricant/sawdust mess and waste, and to prevent stained boards.

Usual flow will be between 2.6 - 9.5 liters (.687 - 2.5 gallon) per hour.

1. To start the self-priming system:

- Open the water lube bottle valve all the way.
- Turn the lube control switch to PULSE¹ and set the lube dial to the desired flow rate. Use the lowest setting that successfully eliminates pitch buildup.

NOTE: Softwood applications will usually require more lubricant than hardwood applications.

2. Cut the log.

3. To shut off the lube:

- Turn the lube control switch to OFF.
- Close the lube bottle valve all the way.

4. If you are sawing or storing the machine in freezing temperatures, use windshield washer fluid to help prevent the water from freezing.



CAUTION! Add windshield washer fluid to the water tank and prime as recommended when sawing or storing the machine in freezing temperatures. Use windshield washer fluid with a freezing point of at least -20°F (-29°C). Failure to do so will result in damage to the LubeMizer system.

¹Pulse is suitable for most cutting applications. CONTINUOUS delivers a steady stream of lubricant and should be used only for heavy pitch buildup or occasional blade cleaning.

Lube Additives

For further benefits, add one 12oz. (0.35 L) bottle of Wood-Mizer Lube Additive to a 5-gallon (18.9 L) jug of water. Wood-Mizer Lube Additive enables some previously impossible timbers to be cut by significantly reducing resin buildup on the blade. It helps to reduce heat buildup, wavy cuts, and blade noise. This biodegradable and environmentally friendly pre-mix includes a water softener additive, so it works with hard water.



WARNING! Use ONLY water, Wood-Mizer Lube Additive or windshield washer fluid with the water lube accessory. Never use flammable fuels or liquids such as diesel fuel. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so can damage the equipment and may result in serious injury or death.

See Table 2-1. Use windshield washer fluid as an antifreeze to prevent the water from freezing and damaging the LubeMizer system. See the chart below for recommended mixture levels depending on the temperature where you are sawing or storing the machine.

Run the LubeMizer system on the “Continuous” setting for 30 seconds after adding the windshield washer fluid to the system. This will insure the water throughout the system will not freeze and damage the check valves.



CAUTION! Add windshield washer fluid to the water tank and prime as recommended when sawing or storing the machine in freezing temperatures. Use windshield washer fluid with a freezing point of at least -20°F (-29°C). Failure to do so may cause damage to the LubeMizer system.

Ratio WWF ¹ :Water to fill 5 Gal. tank	Freezing Point of Solution	
	(°F)	(°C)
5:0	-22	-30
4:1	-3	-19
3:2	7	-14
2.5:2.5	13	-10
1:4	24	-4
0:5	32	0

TABLE 2-1

¹ WWF = Windshield Washer Fluid with -20°F (-29°C) freezing point.

2.5 Operation Procedure

1. Install a blade if necessary.



WARNING! Always wear gloves and eye protection when handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from area when coiling, carrying or changing the blade. Failure to do so may result in serious injury.

2. Close the blade housing cover.
3. Tension the blade as described in [See Section 5.5 Tensioning the Blade](#) .
4. Slowly spin the blade wheel by hand.



WARNING! Use extreme caution when spinning the blade wheel by hand. Make sure your hands are clear of the blade and the wheel spokes before spinning. Failure to do so may result in serious injury.

5. Check alignment of the blade on the blade wheels and the blade guides. Adjust as necessary.
6. Set the cutting width as desired.



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

7. Perform pre-start check.
8. Start the blade motors.
9. Turn on the Lube Mizer system.
10. Using the feed chain speed switch, set the feed rate as desired.



DANGER! Always be sure all persons are out of the path of the blade before starting the motor. Failure to do so will result in serious injury.



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

11. Place the test material on the feed chain and start the feed chain.



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.

12. Stop the blades and the feed chain. Measure the finished material and adjust the saw heads in or out as necessary. Repeat with the test material until the desired finished dimension is obtained.
13. Restart the blade and the feed chain.
14. Place the material on the infeed table.
15. Monitor the blade tension as the operation continues. Adjust the blade tension if required.
16. If material jam occurs, stop the blade motor and the feed chain.



WARNING! Allow the blade to come to a complete stop before servicing. Failure to do so will result in serious injury.

17. After the operation is complete, shut off the blade motor and the feed chain.
18. Release the blade tension if you have finished sawing for the day.



CAUTION! Remove tension from the blade when the machine is not in use.

SECTION 3 MAINTENANCE

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



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



WARNING! Disconnect air supply and release compressed air from the air system before servicing the saw! Failure to do so may result in serious injury.



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

Be sure to refer to the motor manual for maintenance procedures concerning the blade motor.

3.1 Blade Guides

Check the rollers for performance and wear every blade change. Make sure the rollers are clean and spinning freely. If not, rebuild them. Replace any rollers which have worn smooth or have become cone shaped. See the Parts manual for blade guide rebuild kits and complete roller assemblies.

3.2 Sawdust Removal

Remove bark and excess sawdust from and around loading decks, log turner, TV6000 input and output tables and saw heads, especially in places where movable parts are installed: chains, sprockets, bushings and rollers.



CAUTION! Never use grease on the saw head rollers as it will collect sawdust.

3.3 Miscellaneous Lubrication



1. Infeed table. Using the grease nipples, lubricate the bottom bearings and the upper hold-down roller bearings with a lithium grease.



2. Outfeed table. Using the grease nipples, lubricate the bearings of upper hold-down rollers, the side disc bearings and end pivot roller bearings with a lithium grease.



CAUTION! Never apply grease to the feed chain. It causes sawdust buildup in chain links.

3. Log Decks. Lubricate the chain drive and transport chain shaft bearings using the grease nipples.

4. Using the grease nipples, lubricate the saw head blade wheels, wheel bushings, blade guide bushings and linear bushings. For each grease nipple use 1 g of grease per month.
5. Using the grease nipples, lubricate the debarker bushings.
6. Periodically check the LUBE MASTER spray system. See the manufacturer's manual.

3.4 Decals

Make sure all safety warning decals are readable. Remove sawdust and dirt. Replace any damaged or unreadable decals immediately. Order decals from your Customer Service Representative.

3.5 Belts

1. Check the blade wheel belts for wear every 50 hours of operation. Replace as needed.

2. Periodically check all belts for wear. Replace any damaged or worn belts as needed.

3.6 Lubricator Reservoir

See Figure 3-1 Be sure to keep Lubricator Reservoir filled with biodegradable lubricant.

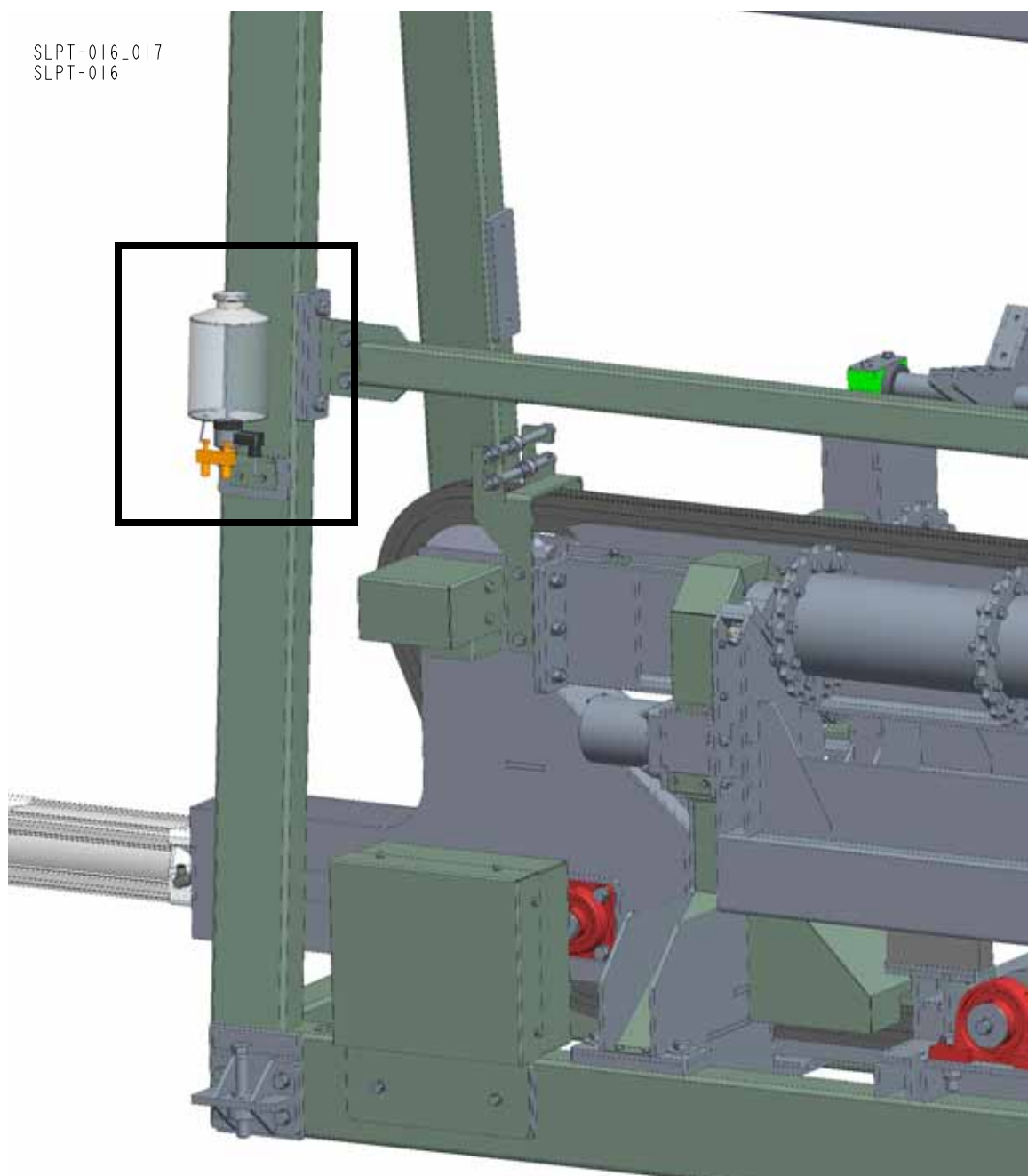


FIG. 3-1

3.7 Lube Mizer System

1. Clean the lube filter as needed.

To clean,

- Make sure the lube control is in the OFF position and the lube bottle valve is closed completely.
- Unscrew the filter reservoir and flush it with water.
- Remove the cylindrical mesh filter and gently flush it with water.
- Replace the filter and the reservoir.

See Figure 3-2

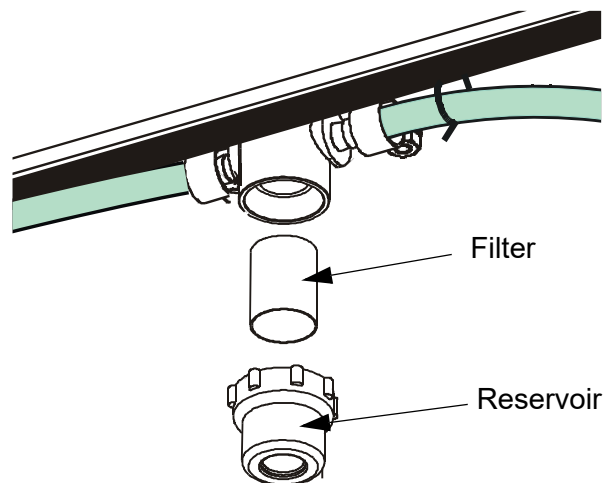


FIG. 3-2

2. Periodically check the lube hoses and lines for any buildup. Remove and flush with water as needed.
3. Periodically check the blade guide bracket nozzles for any buildup. Remove and flush with water as needed.

SECTION 4 TV6000 DETAILED LUBRICATION SCHEDULE

4.1 Infeed

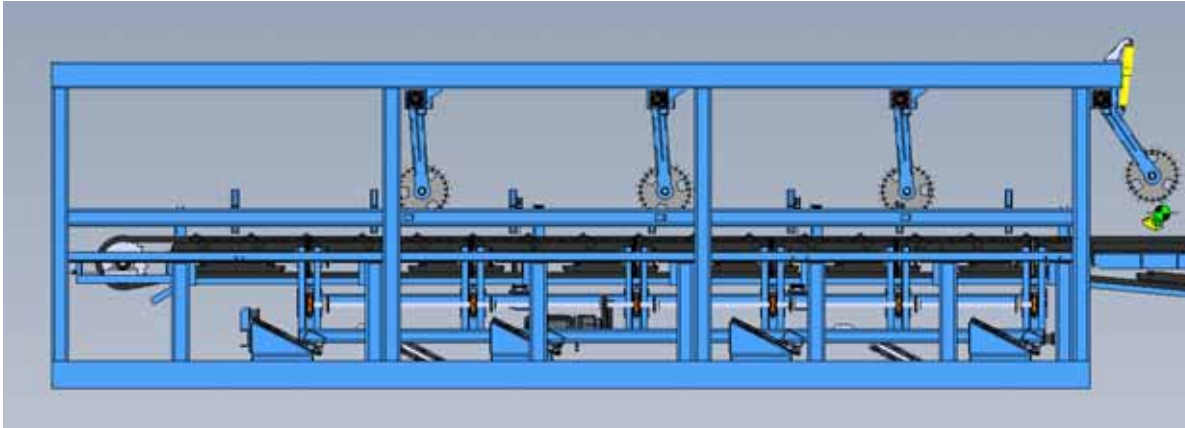


FIG. 4-1

4.1.1 Log Loader

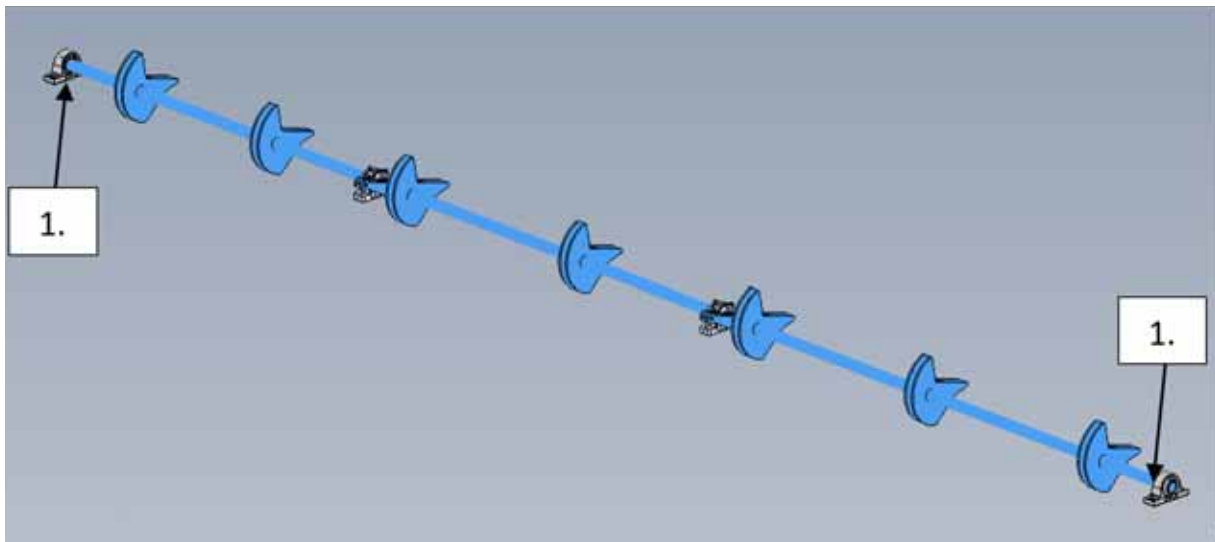


FIG. 4-2

4.1.2 Tail Head

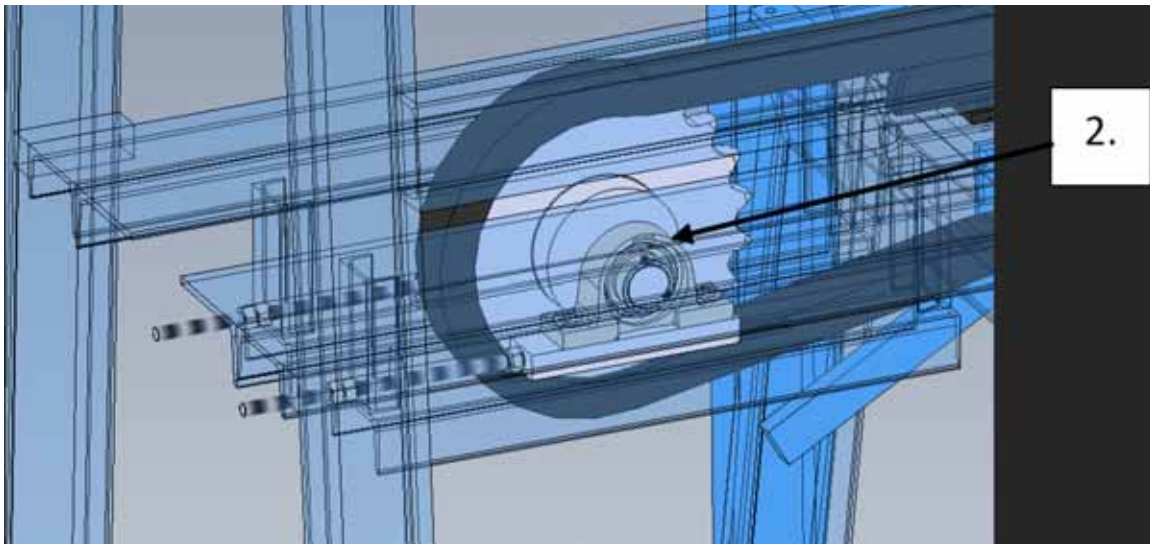


FIG. 4-3

4.1.3 Log Turner

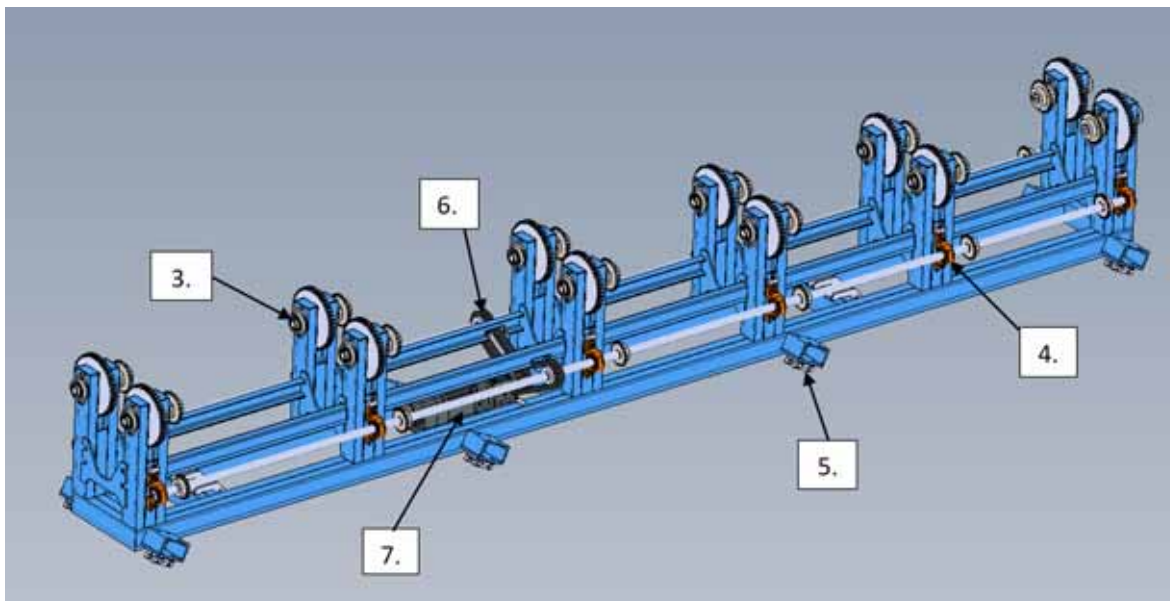
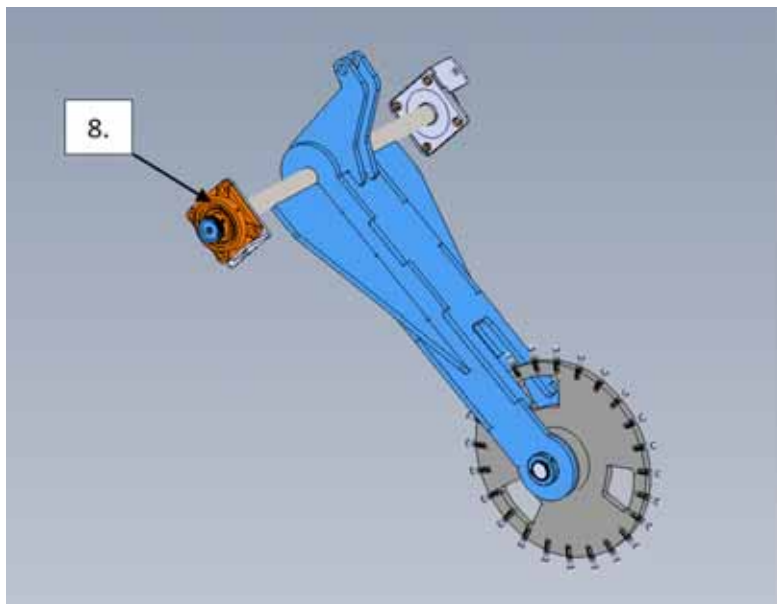


FIG. 4-4

4.1.4 Hold down Assemblies**FIG. 4-5**

4.2 Headrig

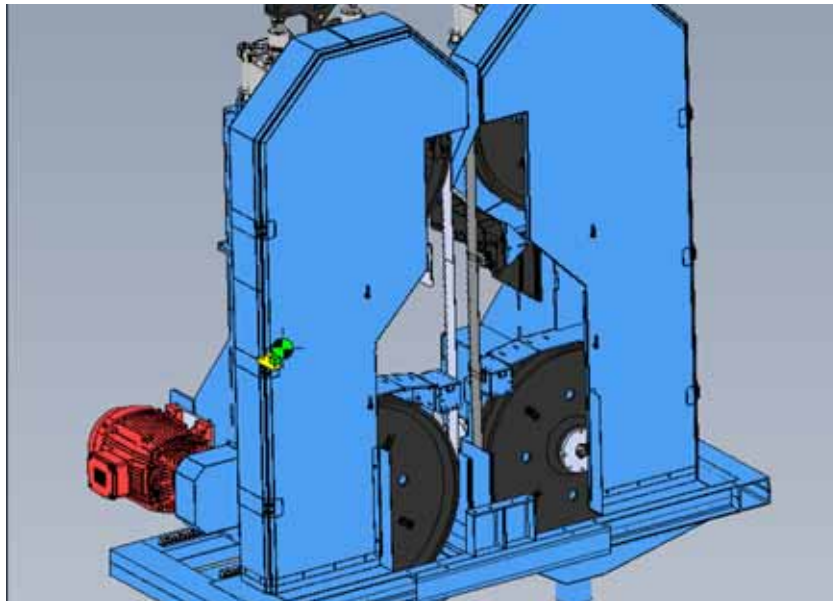


FIG. 4-6

4.2.1 Headrig Base

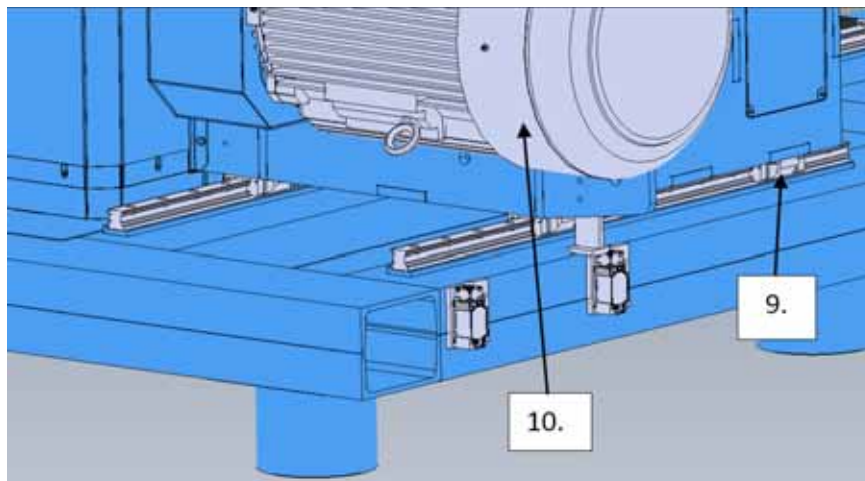


FIG. 4-7

4.2.2 Top Sliding Head

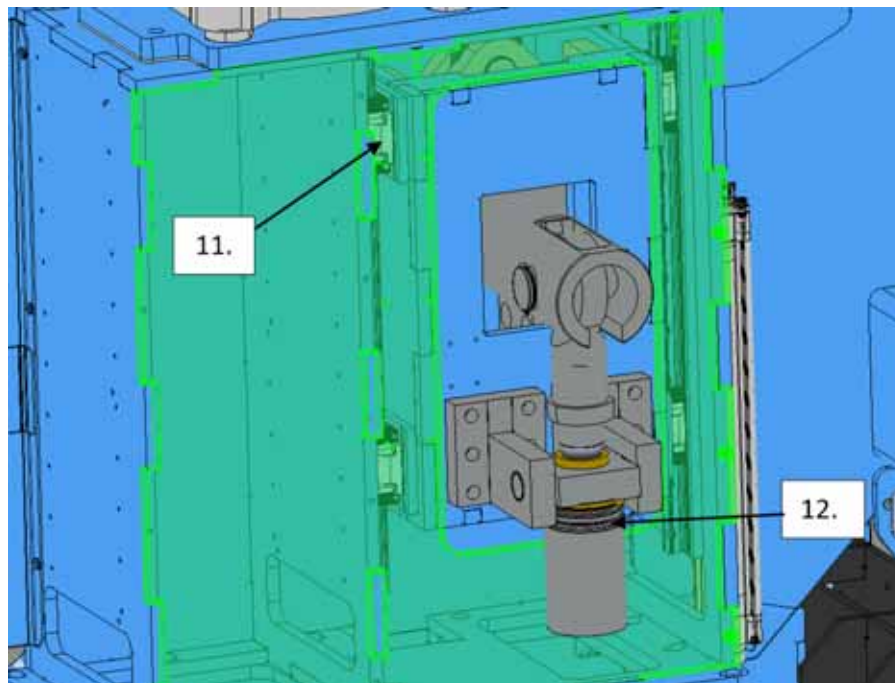


FIG. 4-8

4.2.3 Adjustable Guides

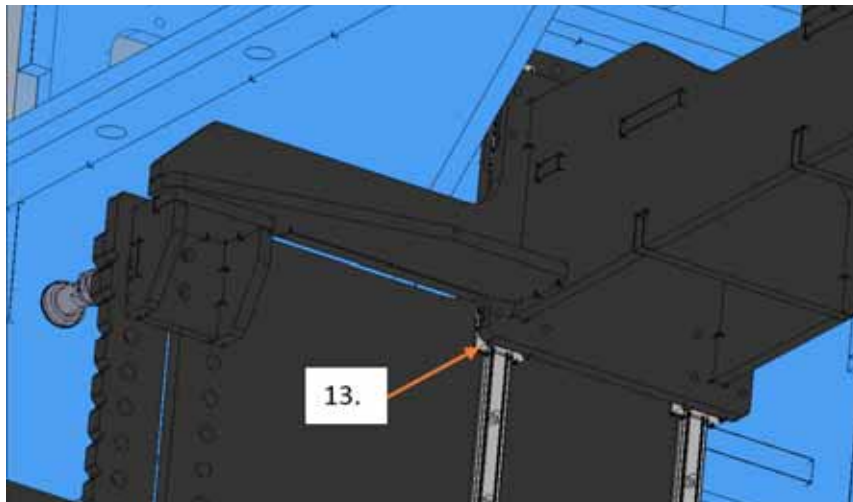


FIG. 4-9

4.2.4 Bandsaw Wheel - Drive Assembly (Bottom)

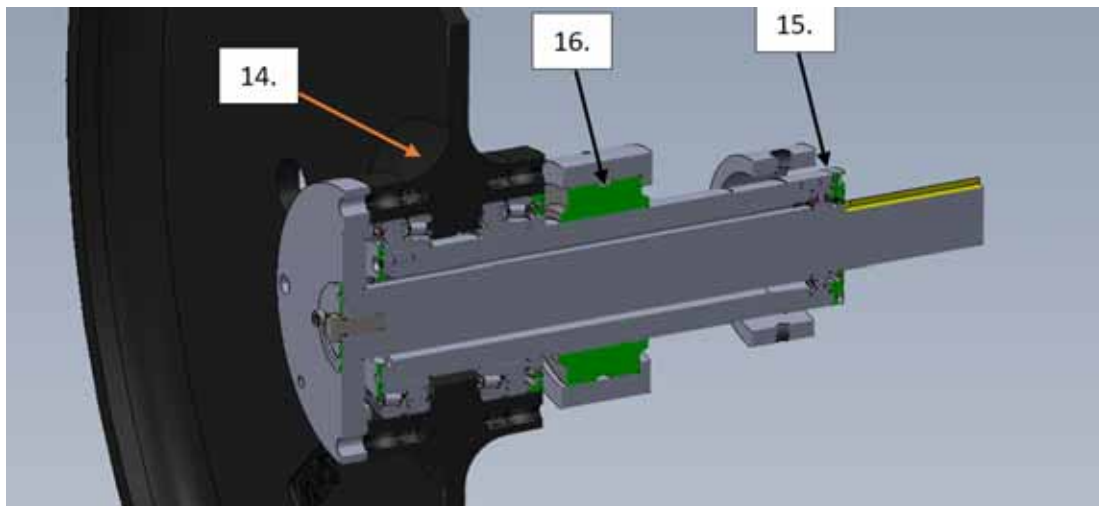


FIG. 4-10

4.2.5 Bandsaw Wheel - Non-Drive Assembly (Top)



FIG. 4-11

4.2.6 BallscREW

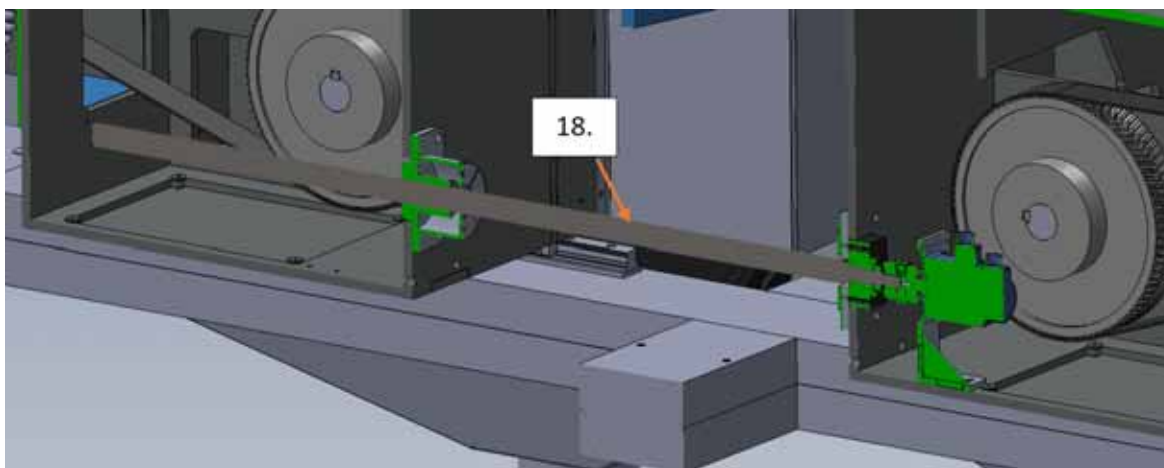


FIG. 4-12

4.3 Side Pressure Outfeed - Flitch Drop-off

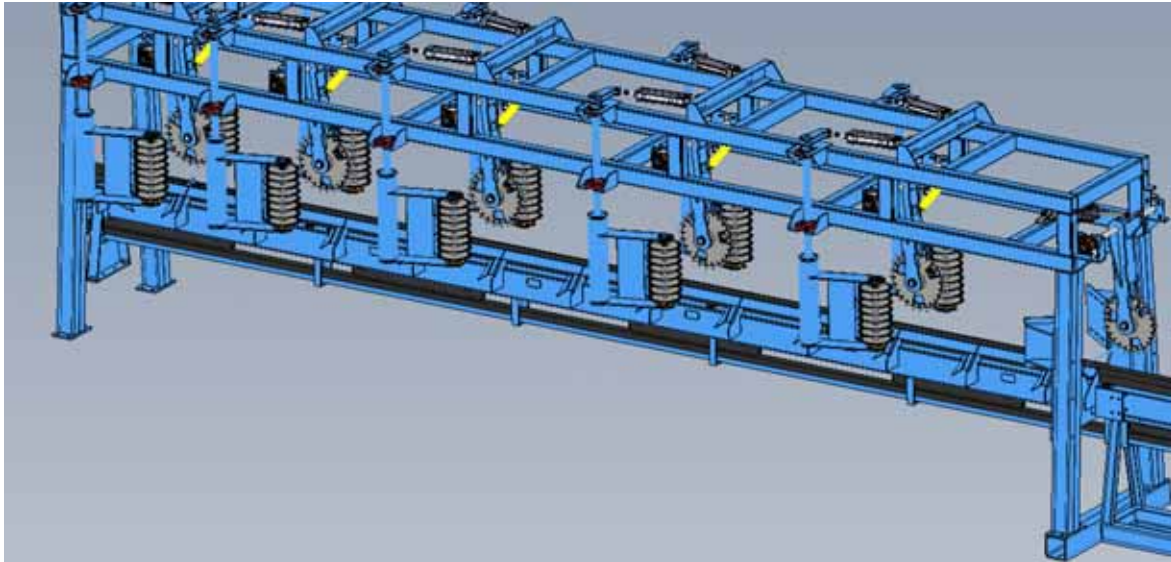


FIG. 4-13

4.3.1 Side Pressure Assembly

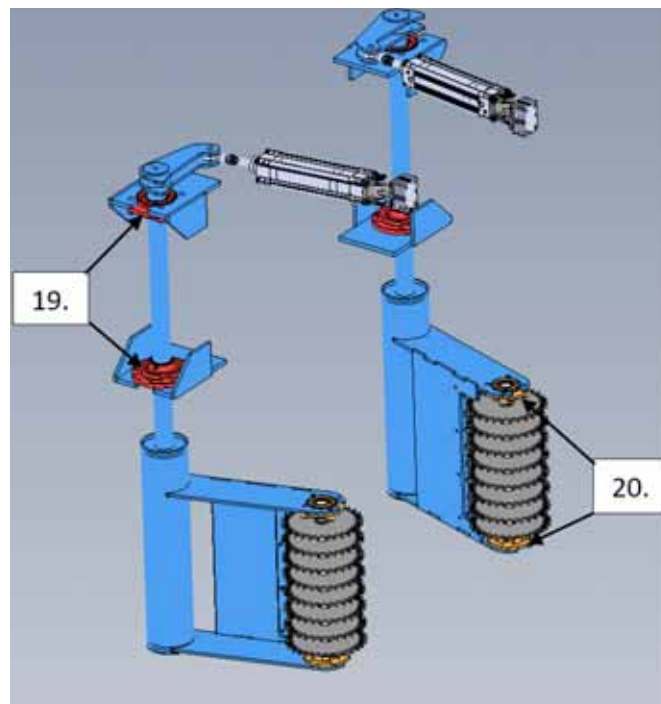


FIG. 4-14

4.3.2 Outfeed Hold Down Assembly

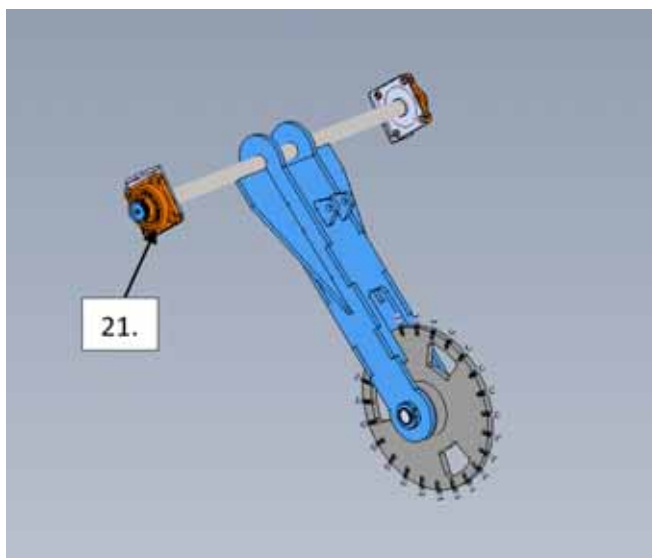


FIG. 4-15

4.4 Extended Outfeed - Cant Discharge

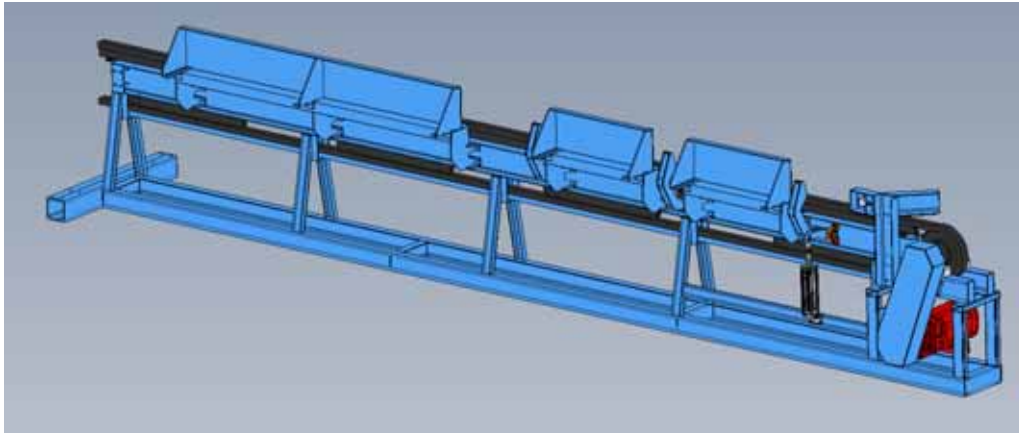


FIG. 4-16

4.4.1 Cant Kicker Assembly

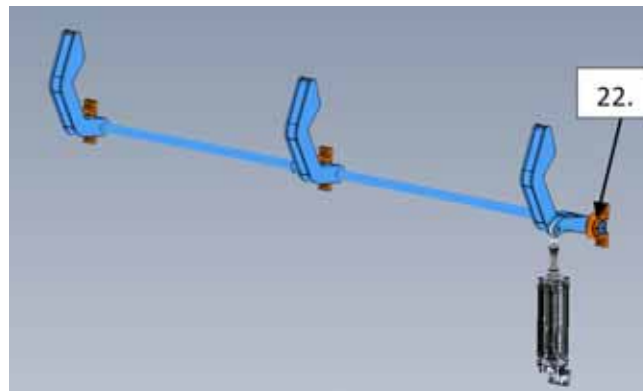


FIG. 4-17

4.4.2 Sharp Chain Drive

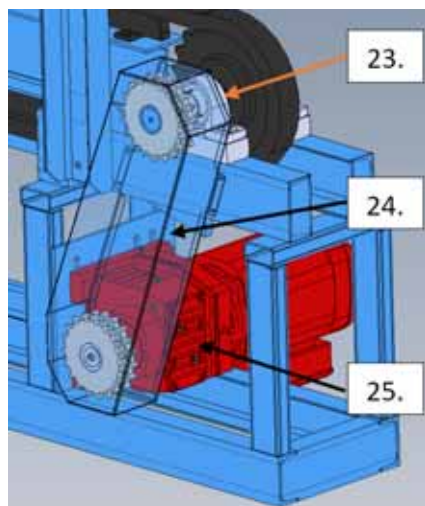


FIG. 4-18

4.5 Lubrication Schedule

Care should be taken when re-greasing bearings to avoid overfilling. Overfilling can lead to excessive heat and or unseating of the seals. Grease should be introduced in small increments and under light pressure. The use of pneumatic greasing equipment is not recommended unless low pressure is assured. Whenever possible, the shaft should be rotated during relubrication to insure proper grease distribution throughout the raceways.

The grease fill shown in table below provides a general rule for re-greasing amounts.

Average Grease Density = 0.96g/cm³ (0.0347 lb/in³)

Average Grease supplied per pump = 1.5cm³ (0.09 in³) ±1.44g

	Note	Location	Lubrication Type	Frequency
1	Bearing Unit - UCP210 – Zerk x2	Singulator/Log Loader	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
2	Bearing Unit - UCP210 – Zerk x2 (1 per side)	Tail Head	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±5g every 1 month
3	Bearing Unit - FYTB 35 TF – Zerk 2x12 (2 Per Sprocket)	Log Turner	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±3g every 1 month
4	Bearing Unit - UCP207 – Zerk 6x2 (6 per side)	Log Turner	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±3g every 1 month
5	Linear Bearing – MHT35 – Zerk 4x2 (4 Per side)	Log Turner	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every 1 month
6	Roller Chain – 12B1 and 16B1	Log Turner	Chain Oil	Weekly
7	Gearmotor – SEW - R57 - 1.1kW (1.5HP)	Log Turner	Oil + Grease as per Manual/Nameplate	See SEW Maintenance Manual pg.114(Gearbox) pg.121 (Motor)
8	Bearing Unit – UCF207 – Zerk 4x2 (4 Per Side)	Infeed Hold Down	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
9	Linear Bearing – MHT35 – Zerk 4x2 (4 Per Headrig)	Headrig - Base	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every 1 month
10	Electric Motor - 20NFM-3-60-18-364T Frame– Zerk 2x2 (2 per Motor)	Headrig	POLYREX EM (Check Nameplate) Elektrim Manual	±23g every 9 months (After 1600h)
11	Linear Bearing – MHT25 – Zerk 8x2 (8 Per Headrig)	Headrig - Top	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every 3 month
12	Thrust Bearing – 51309 – Open x2 (1 per Headrig)	Headrig - Top	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	Replace grease every 12 months ±29g
13	Linear Bearing – MHT15 – Zerk 4x2 (4 Per Headrig)	Headrig – Adjustable Guide	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every 3 month
14	Wheel Bearings - 23024 EJW33C3 – 1x Zerk on Wheel	Bandsaw Wheels	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every week
15	Roller Bearing – NU1012ML – Zerk 1 per Headrig	Headrig Bottom	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every 1 month
16	Spherical Plain Bearing - GE120DO.2RS	Headrig Bottom	Re-Lubrication not required	-
17	Wheel Bearings - 23024 EJW33C3 – 1x Zerk on Wheel	Bandsaw Wheels	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±1g every week

TABLE 4-1

18	Ballscrew – Apply Directly to Ballscrew	Servo Sizing/Ballscrew	Shell Gadus S2 V220 2/Alvania EP 2, Retinax EP2	±3g every 2-3 months (Every 500 hours)
19	Bearing Unit - UCFC210 – Zerk 10x2 (10 per Side)	Side Pressure Outfeed – Hold Down	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
20	Bearing Unit - UCFC206 – Zerk 10x2 (10 per Side)	Side Pressure Outfeed – Hold Down	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
21	Bearing Unit - UCFC207 – Zerk 6x2 (6 per Side)	Side Pressure Outfeed – Hold Down	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
22	Bearing Unit - UCP207 – Zerk x3	Cant Discharge	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 month
23	Bearing Unit - UCP212 – Zerk x2 (1 per side)	Sharp Chain Drive	Grease - NLGI # 2, Mineral Oil Based, Lithium Thickener	±1g every 1 week
24	Roller Chain – 20B2	Sharp Chain Drive	Chain Oil	Weekly
25	Gearmotor – SEW – R87 - 7.5kW (10HP)	Sharp Chain Drive	Oil + Grease as per Manual/Nameplate	See SEW Maintenance Manual pg.114(Gearbox) pg.121 (Motor)
26	Roller Chain – 32B1	Sharp Chain	Chain Oil	weekly

TABLE 4-1

SECTION 5 ALIGNMENT

Perform all steps in this section to completely realign or align the saw after its first setup.



DANGER! Always shut off the machine motors before changing the blades. Failure to do so may result in serious injury.



WARNING! Always wear gloves and eye protection whenever handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from work area when changing blades. Failure to do so may result in serious injury.

5.1 Blade Wheels Alignment

The blade wheels should be adjusted so they are level in the vertical and horizontal planes. If the blade wheels are tilted vertically, the blade will want to move in the tilted direction. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels. The blade guide rollers should not touch and deflect the blade when the blade wheels are adjusted.

Rotate the blade wheels and check the distance from different places on the inner edge of the blade wheel to one chosen place on the surface of head weldment. To make alignment of the blade wheels, [See Section 5.7](#)

See Figure 5-1

552200_009
552200_MANUAL

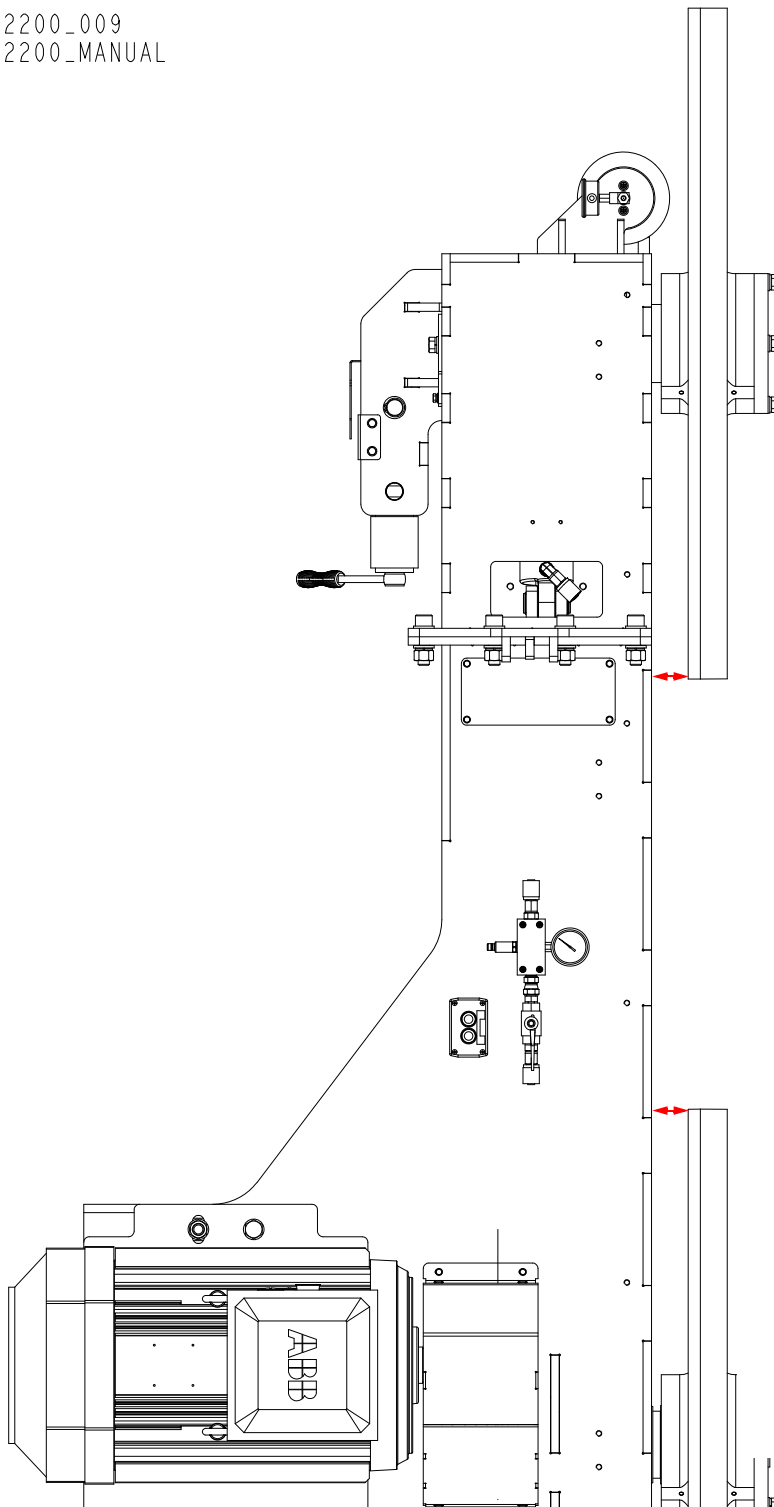


FIG. 5-1

5.2. Blade Installation and Tracking the Blade

1. Install a new blade around the two blade wheels so that the teeth located between the blade guide assemblies point to the infeed table. Make sure the teeth are pointing the correct direction.
2. Apply proper tension. To tension the blade, [See Section 5.5](#)
3. Manually spin one of the blade wheels until the blade positions itself on the blade wheels.

Check that the blade is properly positioned on the blade wheels.

See Figure 5-2 The blade should be placed on the blade wheels so that the gullet is 7.0 mm (0.3") $\pm$ 1.0 mm (0.04") out from the front edge of the wheel.

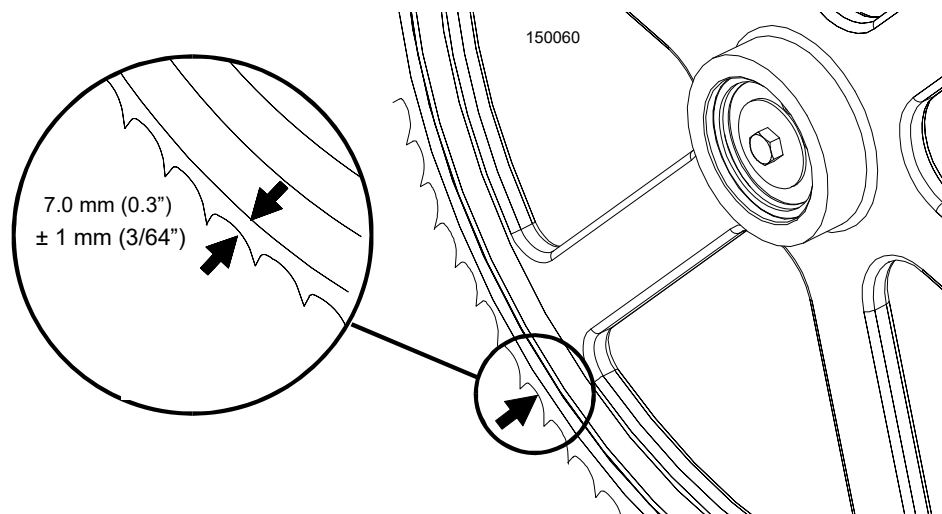


FIG. 5-2

If necessary, adjust the idle blade wheel horizontal position. [See Section 5.7.2](#) to achieve parameters from the figure above. The blade guide rollers should not touch and deflect the blade when the blade wheels are adjusted.

4. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the blade wheels.

5.3 Aligning the Blade Guides

The blade guide assemblies help the blade maintain a straight cut.

Blade guide alignment includes four steps:

- Blade Deflection,
- Blade Guide Vertical Tilt,
- Blade Guide Flange Spacing,
- Blade Guide Horizontal Tilt.

Perform alignment of the the blade guides after you have aligned the blade on the wheels.

NOTE: During blade guide alignment, remove the blade guide adjusting screws and apply lubricating oil such as 10W30 or Dexron III to each screw. This will prevent the screws and threaded holes from corroding and make screw adjustments easier.

5.3.1 Blade Deflection

Perform the following steps to achieve proper blade deflection with the blade guides.

1. Measure the actual distance with a tape from the table to the blade.

See Figure 5-3

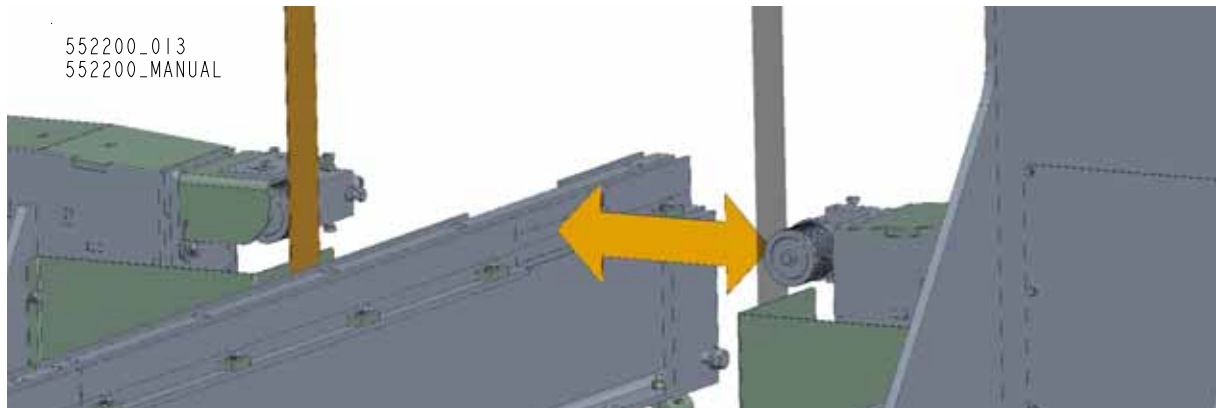


FIG. 5-3

See Figure 5-4

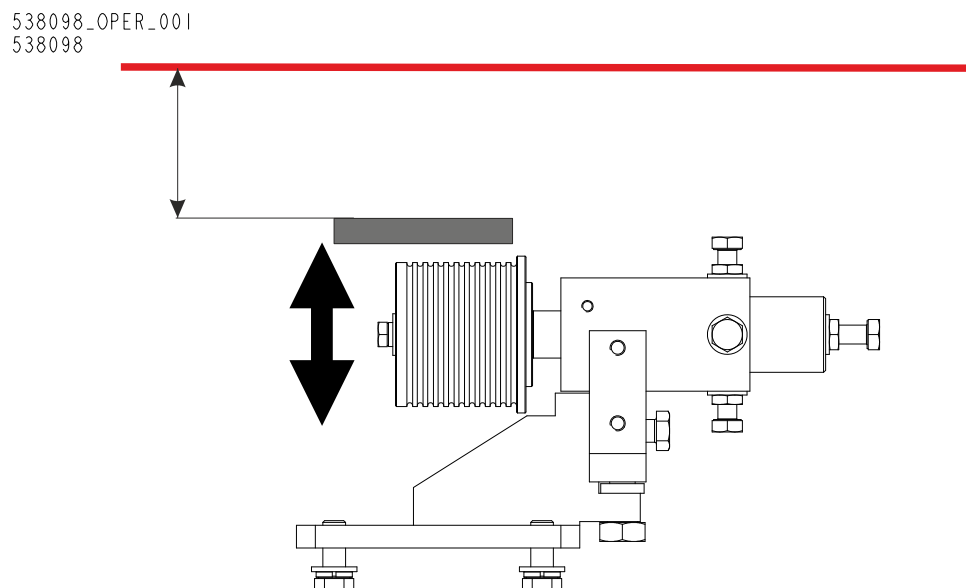


FIG. 5-4

2. [See Section 5.6](#) to use appropriate fasteners to align the blade guide until the blade guide deflects

the blade 6.0 mm.

3. Repeat for the other blade guides.

NOTE: Be sure that the blade guide touches the blade in both guide assemblies.

5.3.2 Blade Guide Horizontal Tilt Adjustment

See Figure 5-5

1. Mount the alignment brackets to the tables.
2. Attach ropes to the alignment brackets.

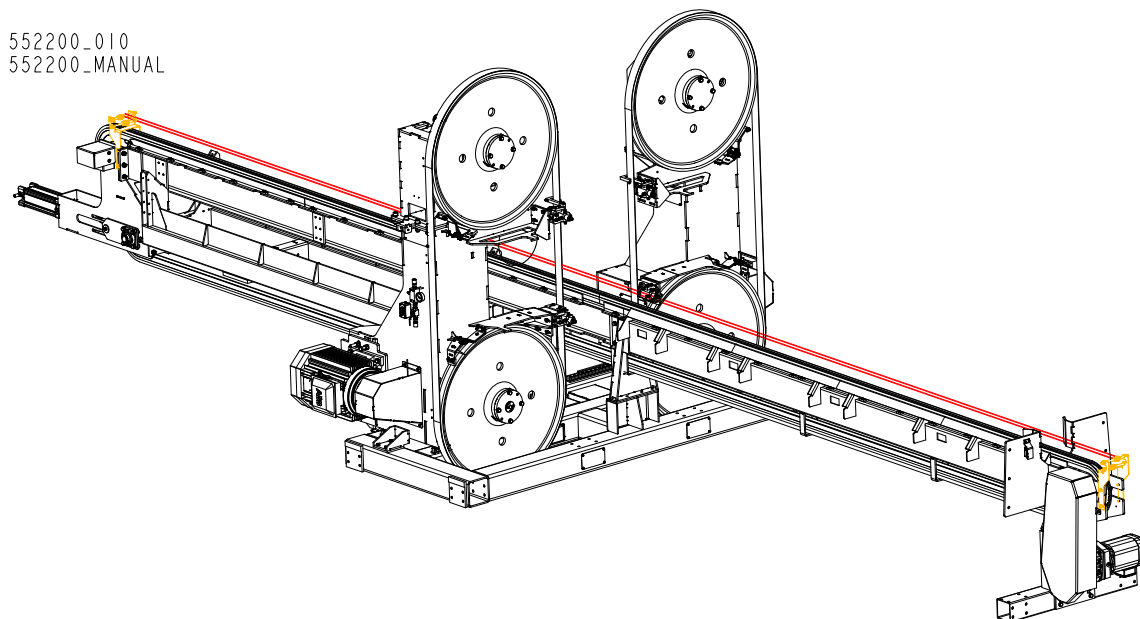


FIG. 5-5

See Figure 5-6

3. Attach the LTBGAT tools to the blades. Be sure the tools do not rest on a tooth or burr, and are lying flat against the blades.

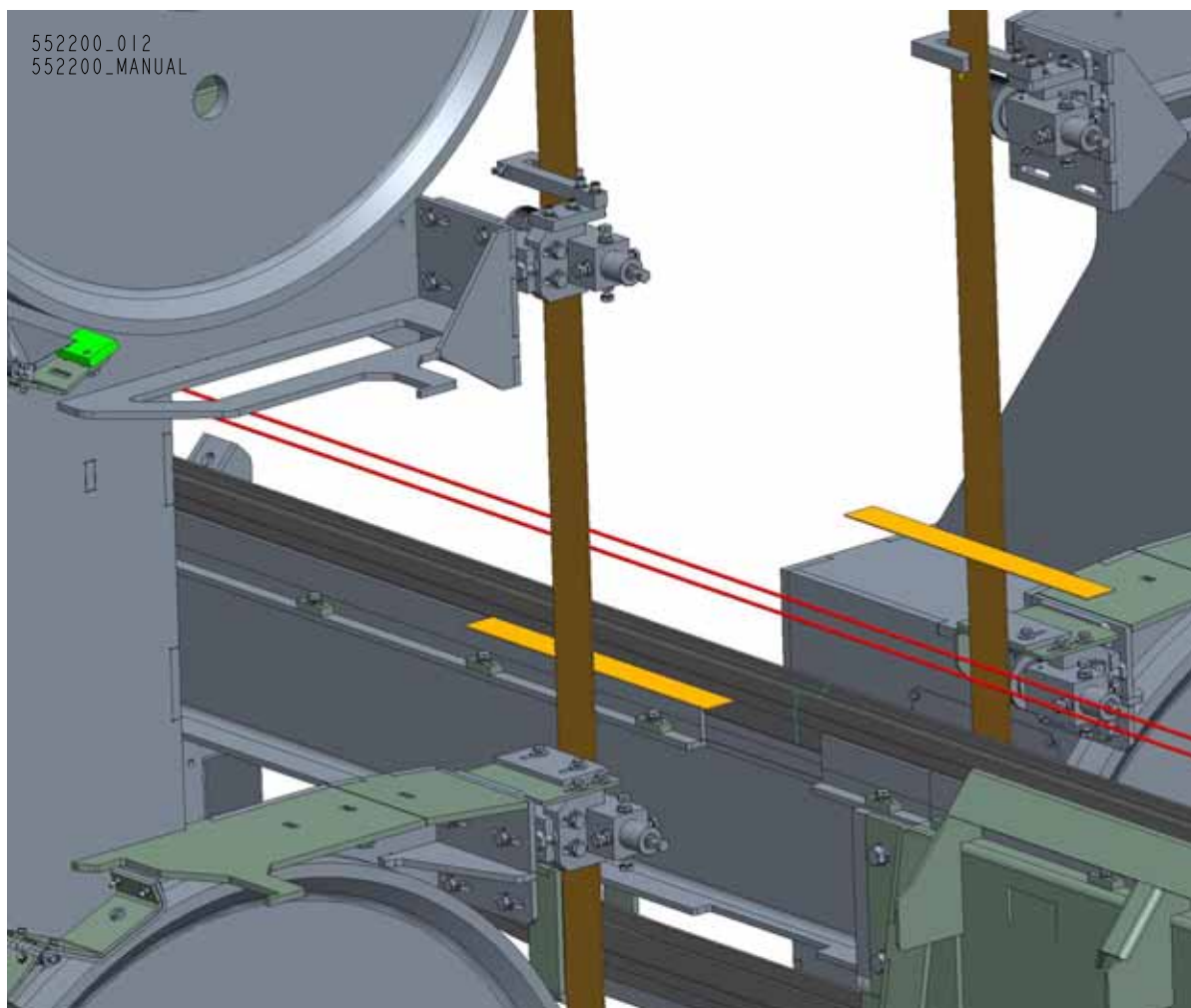


FIG. 5-6

See Figure 5-7

Check that the blade guide does not tilt the blade left or right. A Blade Guide Alignment Tool (LTBGAT) is provided to help you measure the vertical tilt of the blade.

4. Measure the distance from the edge of the tool to the ropes at the back end of the tool and then at

the front end of the tool.

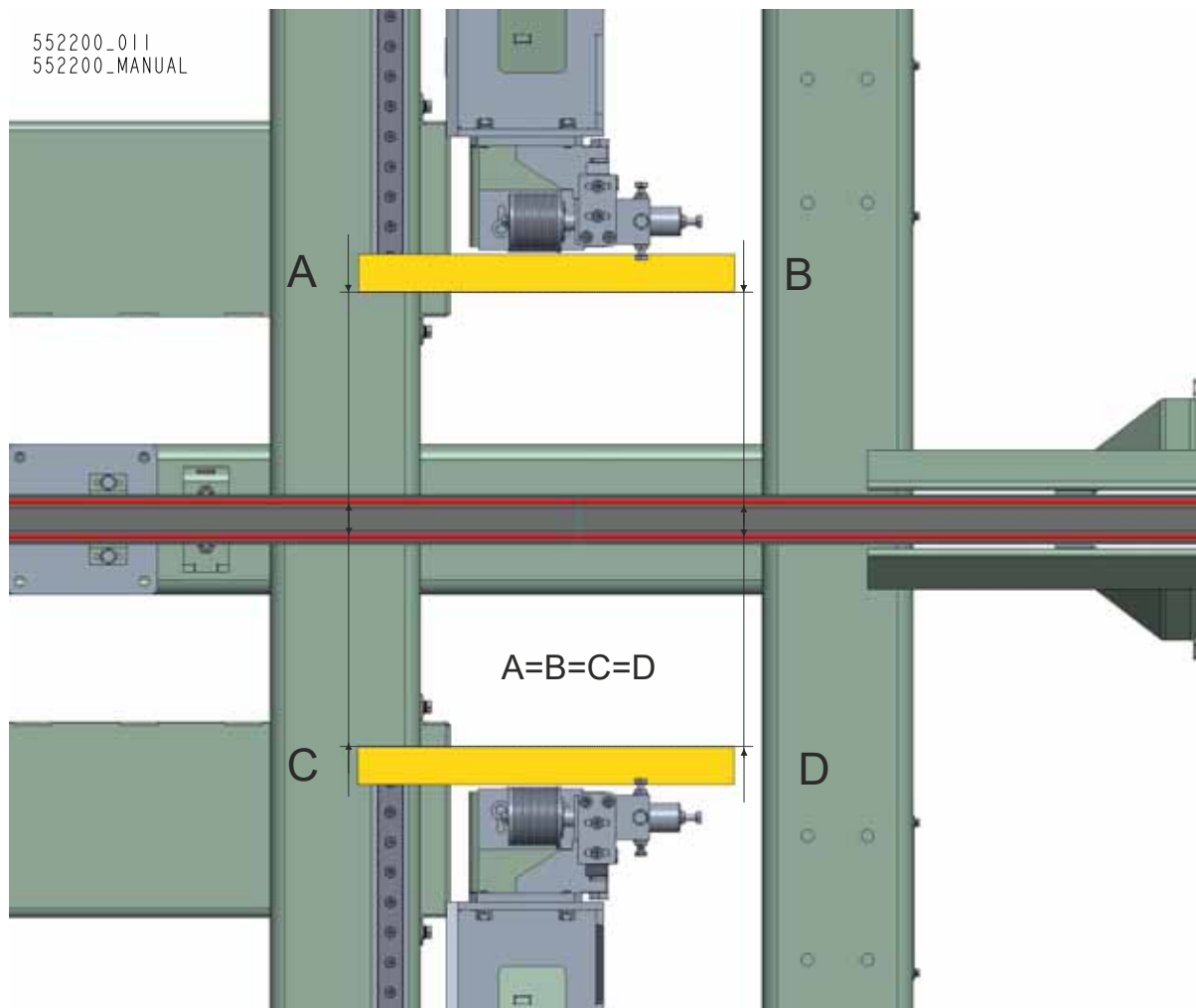


FIG. 5-7

5. All four distances should be equal. If the distances A and B or C and D differ, adjust the horizontal tilt of the blade guide. [See Section 5.6](#).

NOTE: If major adjustments to blade guide tilt were made, measure the actual blade guide deflection again to ensure the correct 6.0 mm (0.24") blade guide deflection is achieved. Adjust if necessary.

5.3.3 Blade Guide Spacing

1. Adjust the blade guides so the blade guide flange is approximately 8 mm (0.31") from the back of the blade. [See Section 5.6.](#)

See Figure 5-8

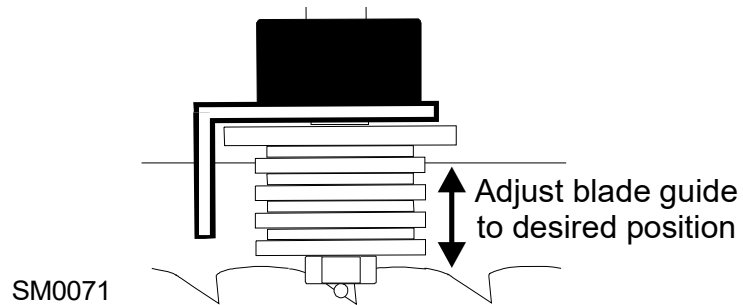


FIG. 5-8

5.3.4 Blade Guide Vertical Tilt Adjustment

1. Finally, both blade guides must be tilted vertically.

See Figure 5-9

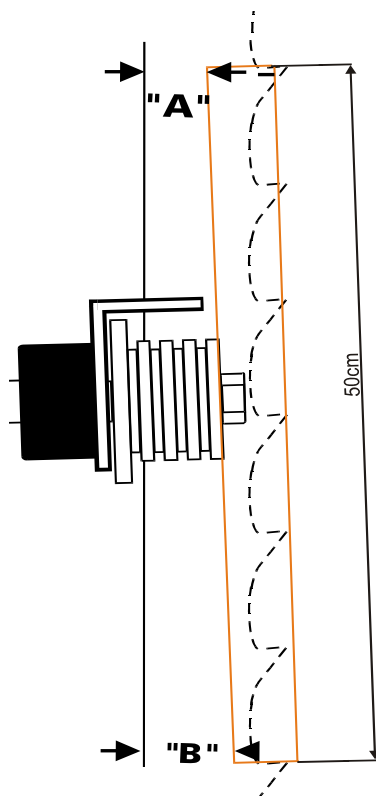


FIG. 5-9

2. Place the Blade Guide Alignment Tool against the face of the blade guide roller.
3. Center the tool on the roller and measure the distance between the back edge of the blade and the ruler at the end closest to the blade guide ("B").
4. Measure between the back edge of the blade and the other end of the ruler ("A").
5. The roller should be tilted slightly up ($A = B - 6.0 \text{ mm [0.24"]}$).
6. Use the set screws to adjust the horizontal tilt of the roller. [See Section 5.6.](#)

5.4 Replacing the Blade



DANGER! Always shut off the machine motors before changing the blades. Failure to do so may result in serious injury.



WARNING! Always wear gloves and eye protection whenever handling bandsaw blades. Changing blades is safest when done by one person! Keep all other persons away from work area when changing blades. Failure to do so may result in serious injury.

See Figure 5-10 Turn the blade tension valve handle (A) to “0” position to release the blade tension. Open the blade cover. Lift the blade out of the blade housing.

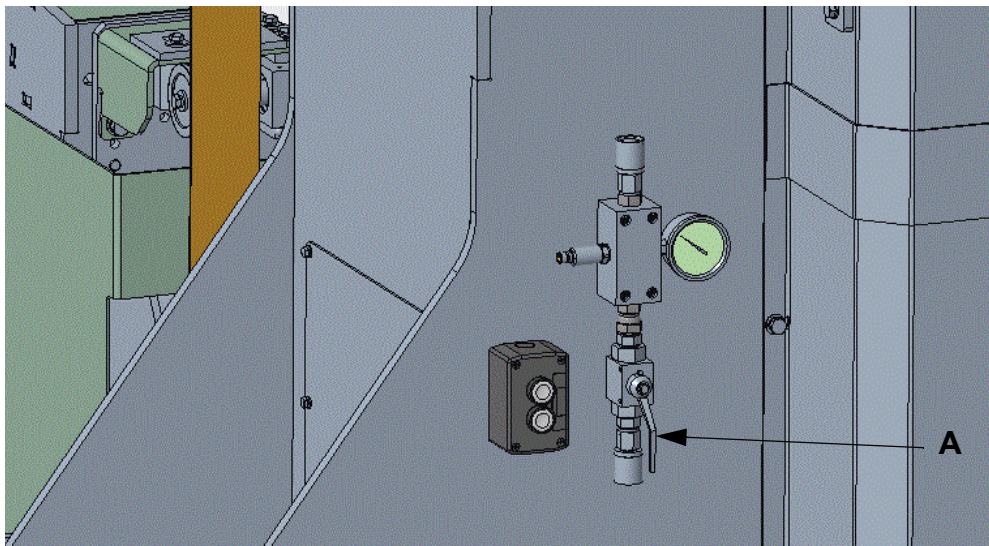


FIG. 5-10

Install a new blade around the blade wheels so that the teeth located between the blade guide assemblies point to the infeed table. Make sure the teeth are pointing the correct direction.

Close the blade housing cover.

Next, tension the blade as described in the following instructions.

5.5 Tensioning the Blade

See Figure 5-11

1. Connect the air pressure hose to the fitting (A).
2. Pump compressed air to the compensation unit until the pressure gauge (B) shows air pressure of 1 bar.

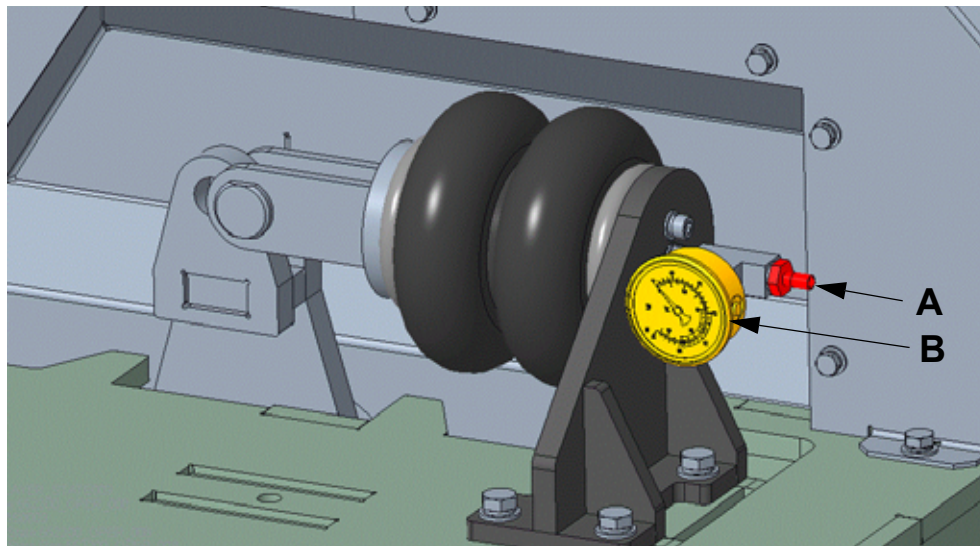


FIG. 5-11

See Figure 5-12

3. Turn the hydraulic lock valve (C) to the "Open" position.
4. Push the buttons (D) to pump hydraulic pressure until 110 bar (1600 PSI) is shown on the pressure gauge (E).

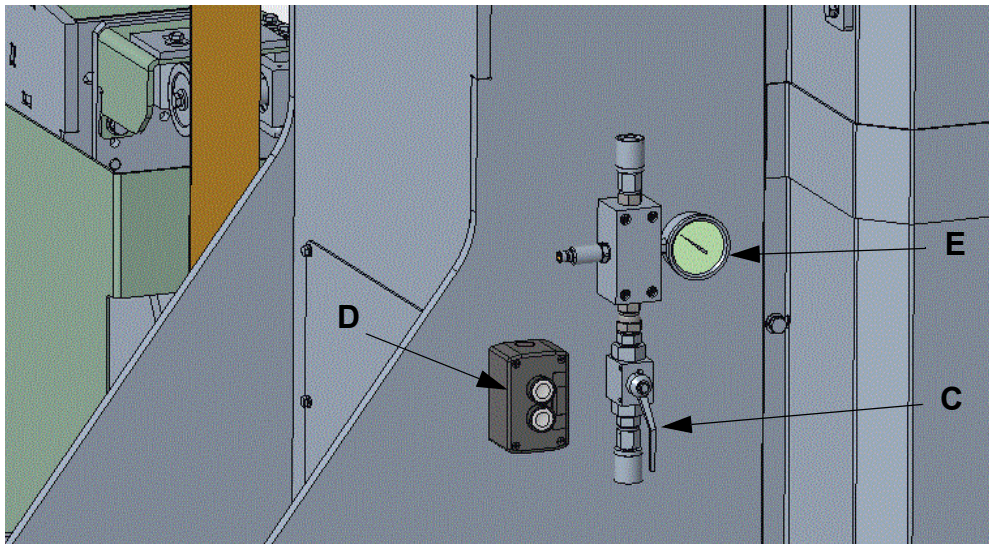


FIG. 5-12

5. Connect the air pressure hose to the fitting (A).
6. Pump compressed air to the compensation unit until the arrow indicator (F) points directly down.

See Figure 5-13

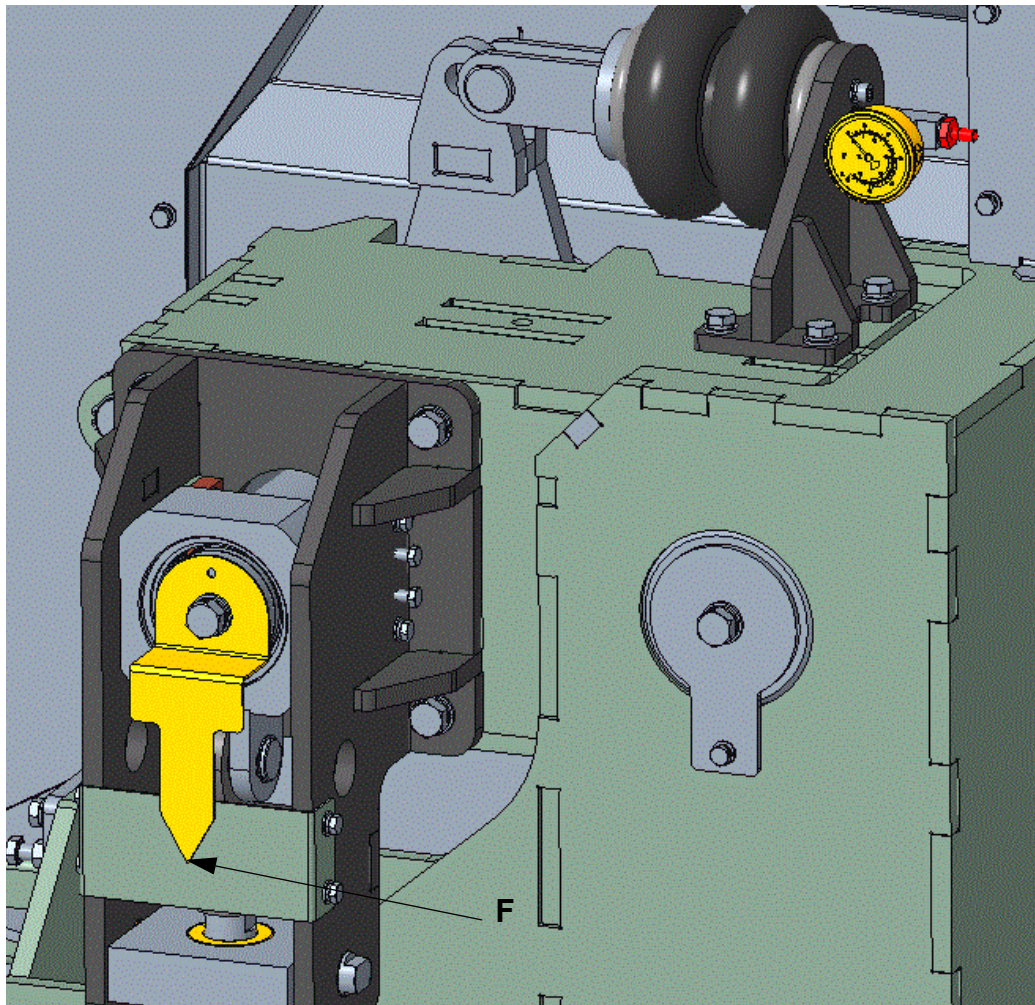


FIG. 5-13

7. Repeat steps 4 - 6 until hydraulic pressure is 110 bar and at the same time the arrow indicator points directly down.
8. Turn the hydraulic lock valve (C) to the "closed" position.

See Figure 5-14

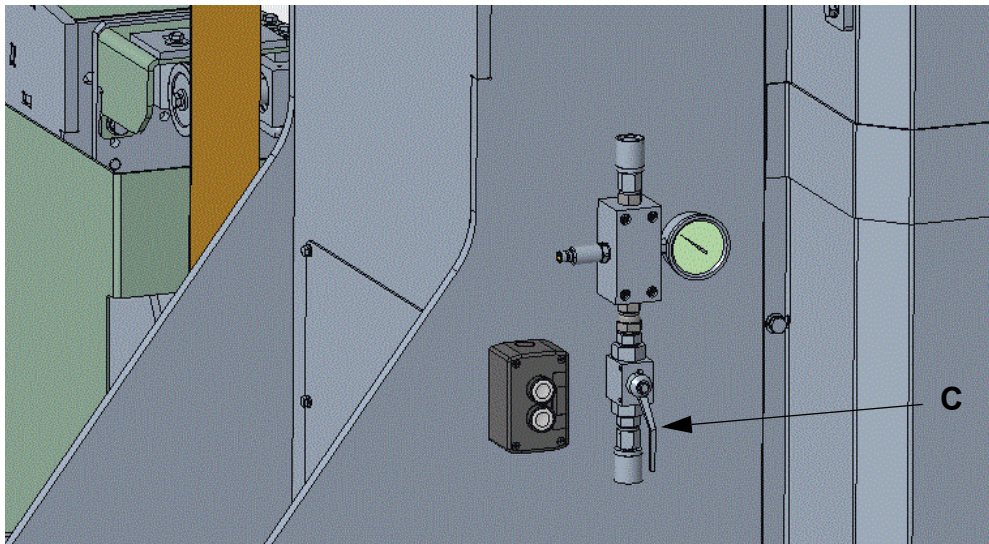


FIG. 5-14

 **CAUTION!** Release the blade tension when the TV6000 is not in use (for example at the end of a shift). Tension the blade again before starting the motor.

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

5.6 Aligning the Blade Guides - Detailed

To align the blade guides use the fasteners as shown in the pictures below.

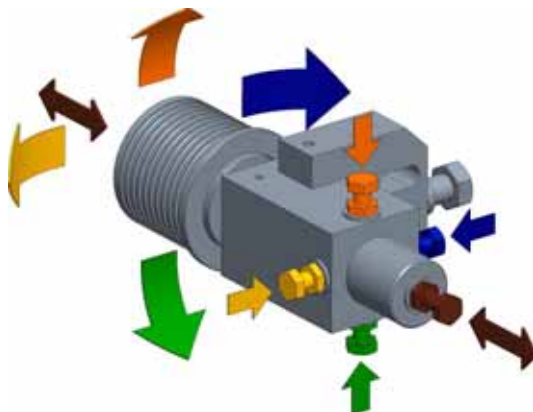
See Figure 5-15.

552200_004
552200_MANUAL



FIG. 5-15

552200_003
552200_MANUAL



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5.7 Aligning the Blade Wheels - Detailed

5.7.1 Drive Wheel

See **Figure 5-17** To align the drive wheel use the fasteners shown in the pictures below.

552200_005
552200_MANUAL

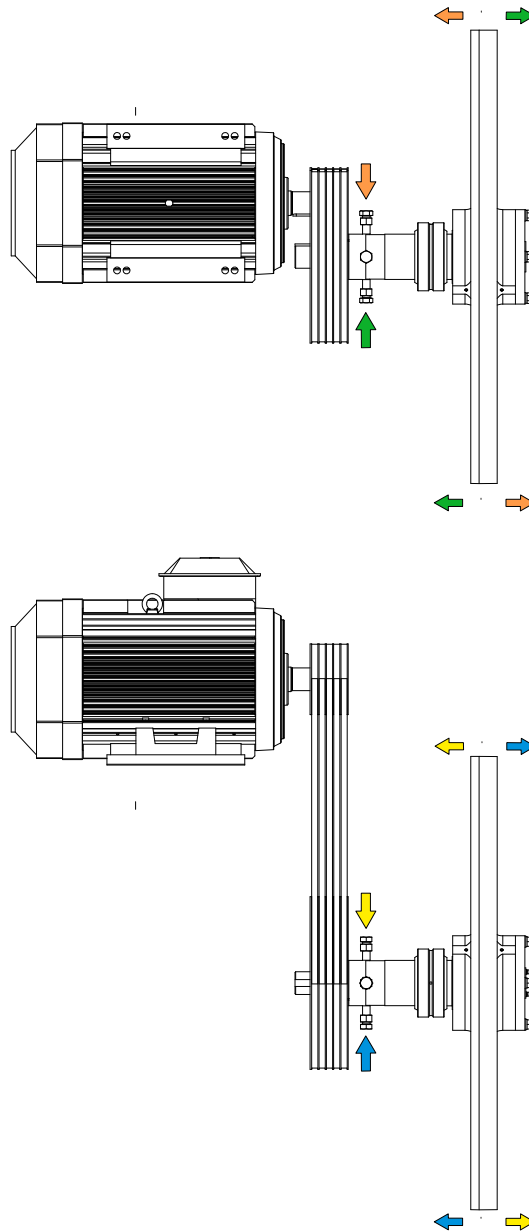


FIG. 5-17

5.7.2 Idle Wheel

See Figure 5-18 To align the idle wheel vertically, use the handle (A) as shown in the pictures below.

552200_006
552200_MANUAL

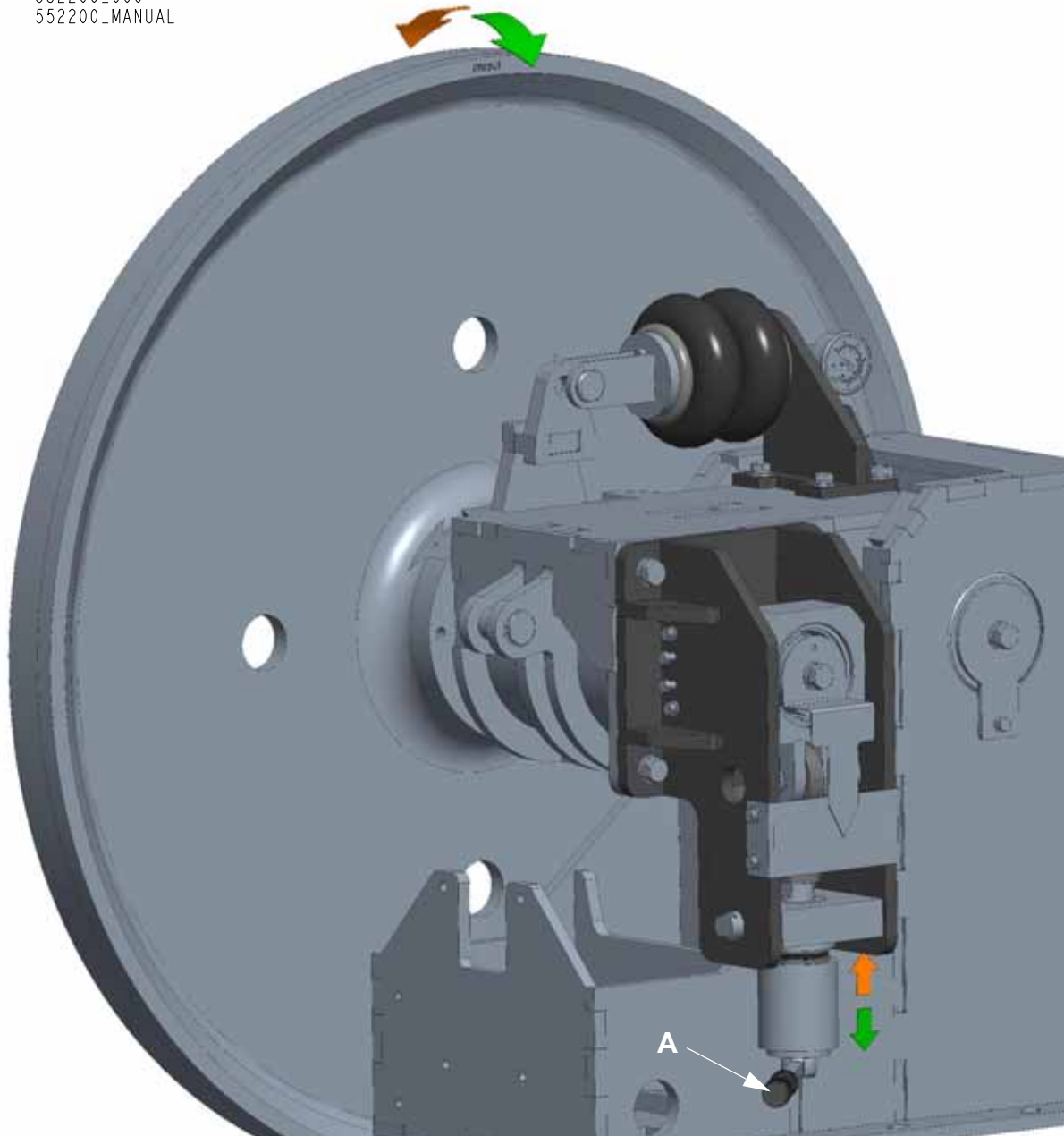


FIG. 5-18

See Figure 5-19 To align the idle wheel horizontally:

- Loosen the bolts (B),
- Screw or unscrew the bolts (C),
- Tighten the bolts (B).

552200_007
552200_MANUAL

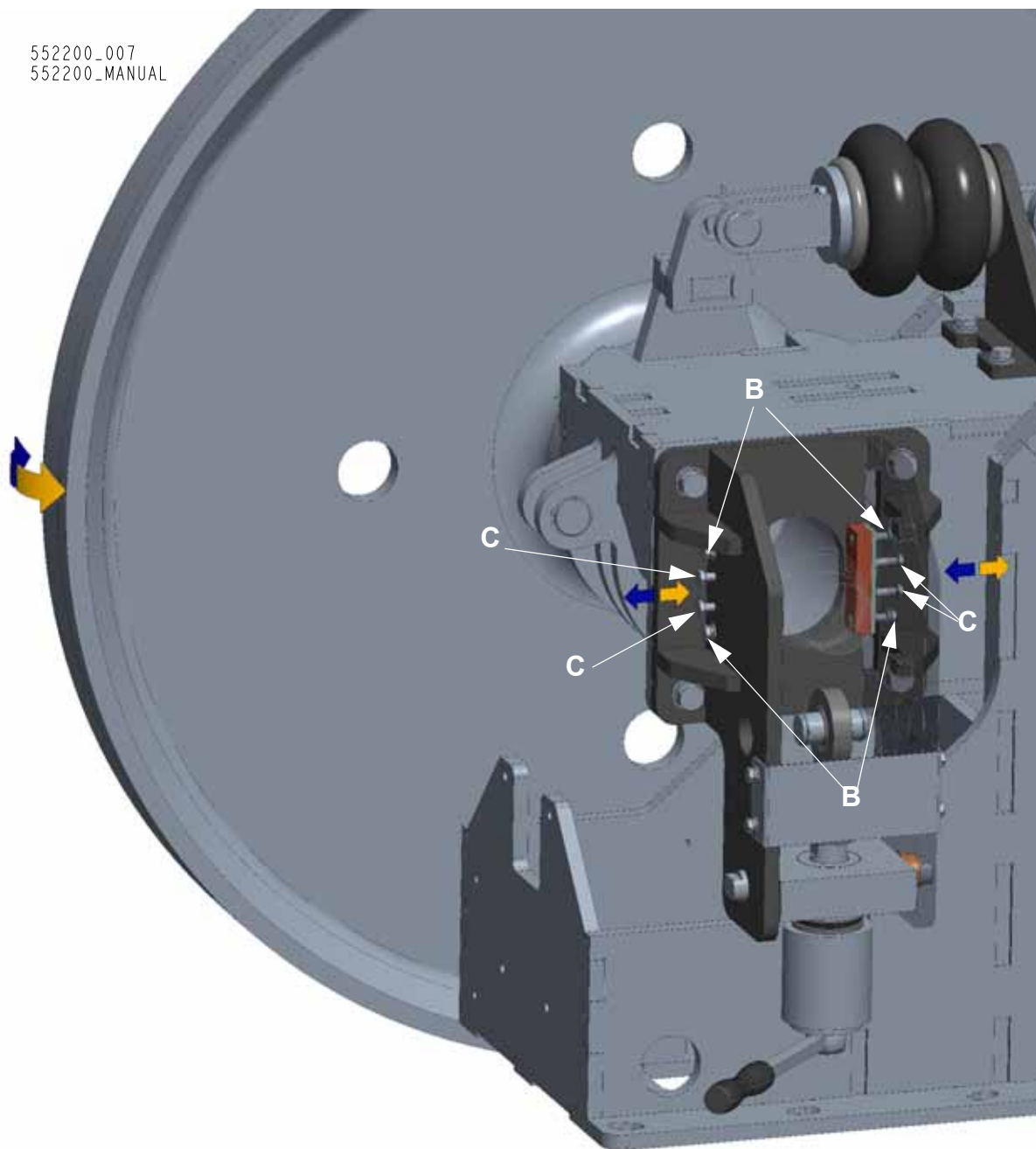


FIG. 5-19

5.8 Debarkers alignment

See Figure 5-20 To adjust the debarkers position:

1. Loosen the bolts A or/and B,
2. Use the fasteners as shown in the picture below,
3. Tighten the bolts A or/and B.

552200_008
 552200_MANUAL

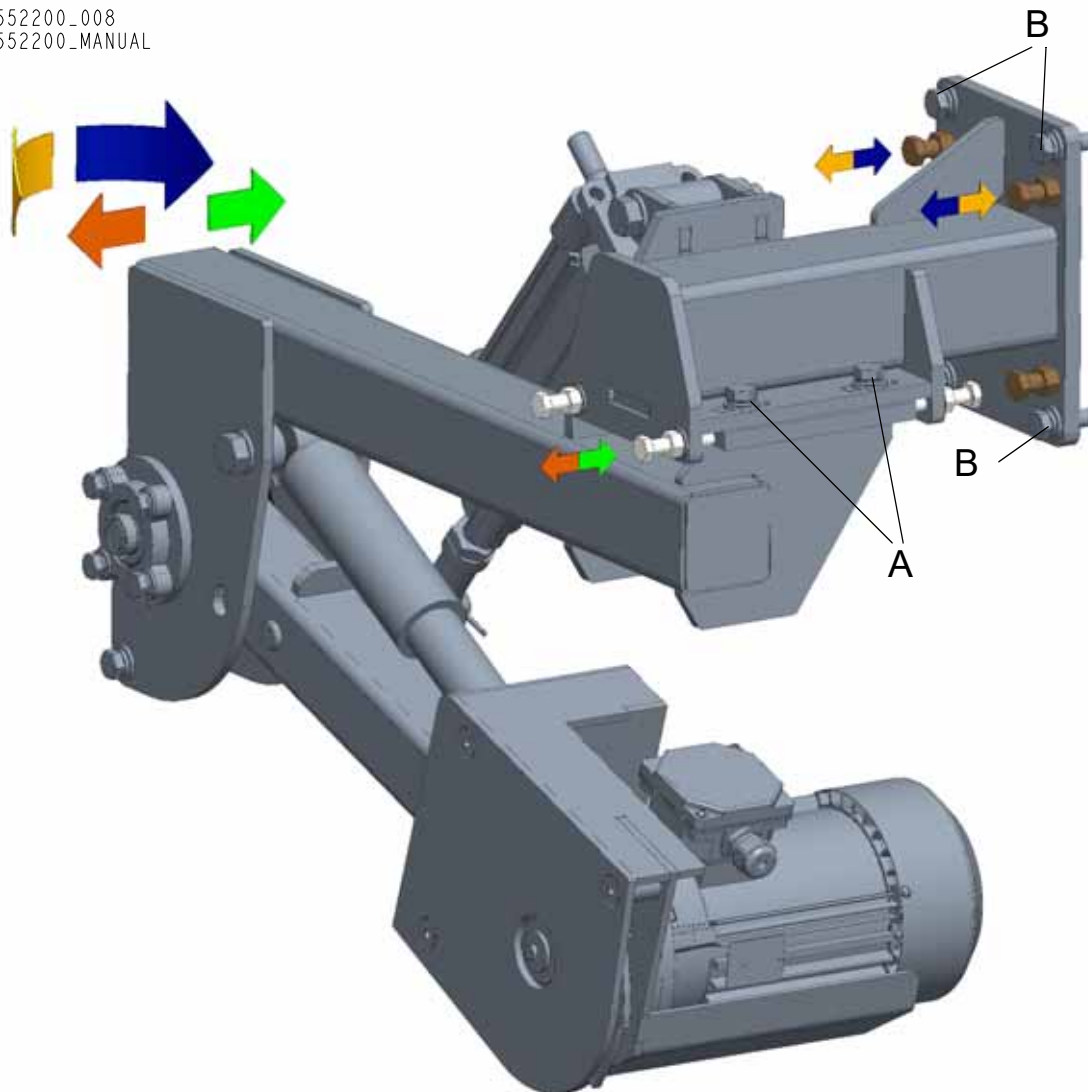


FIG. 5-20

5.9 LD1

CAUTION! Do not overtension the chains. Overtensioning may lead to early failure of the gear, bearings, rollers and chains.

See Figure 5-21 Tension the transport chain using the fasteners (A) & (B). Tension both sides evenly.

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SLPT-016

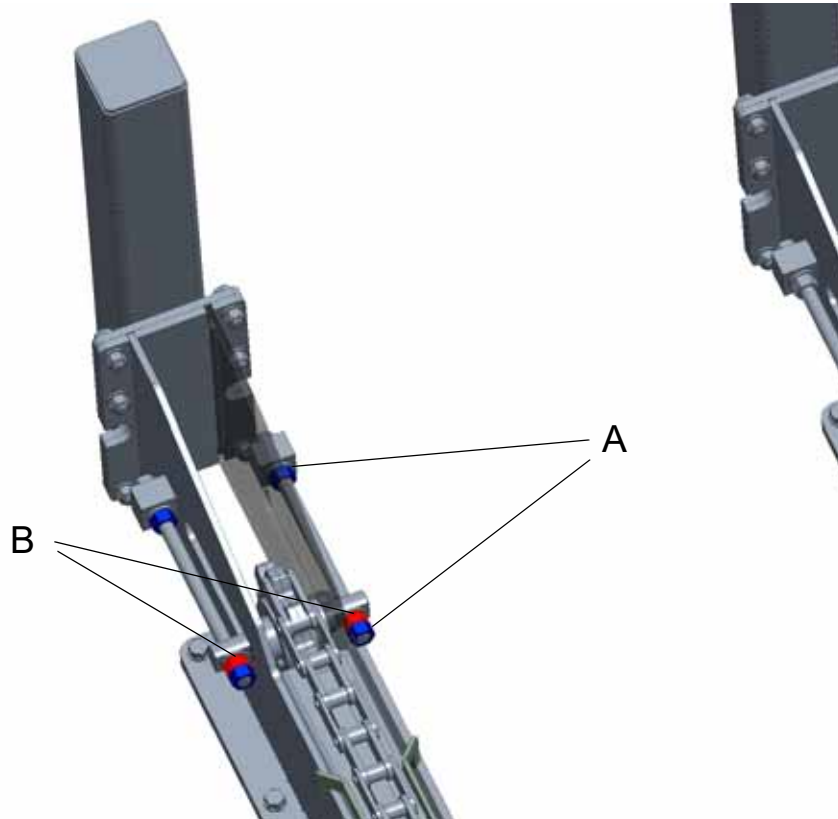


FIG. 5-21

5.10 Incline Deck

CAUTION! Do not overtension the chains. Overtensioning may lead to early failure of the gear, bearings, rollers and chains.

5.10.1 Tensioning the Transport Chain

See Figure 5-22 Tension the transport chain using the fasteners (A). Tension both sides evenly.

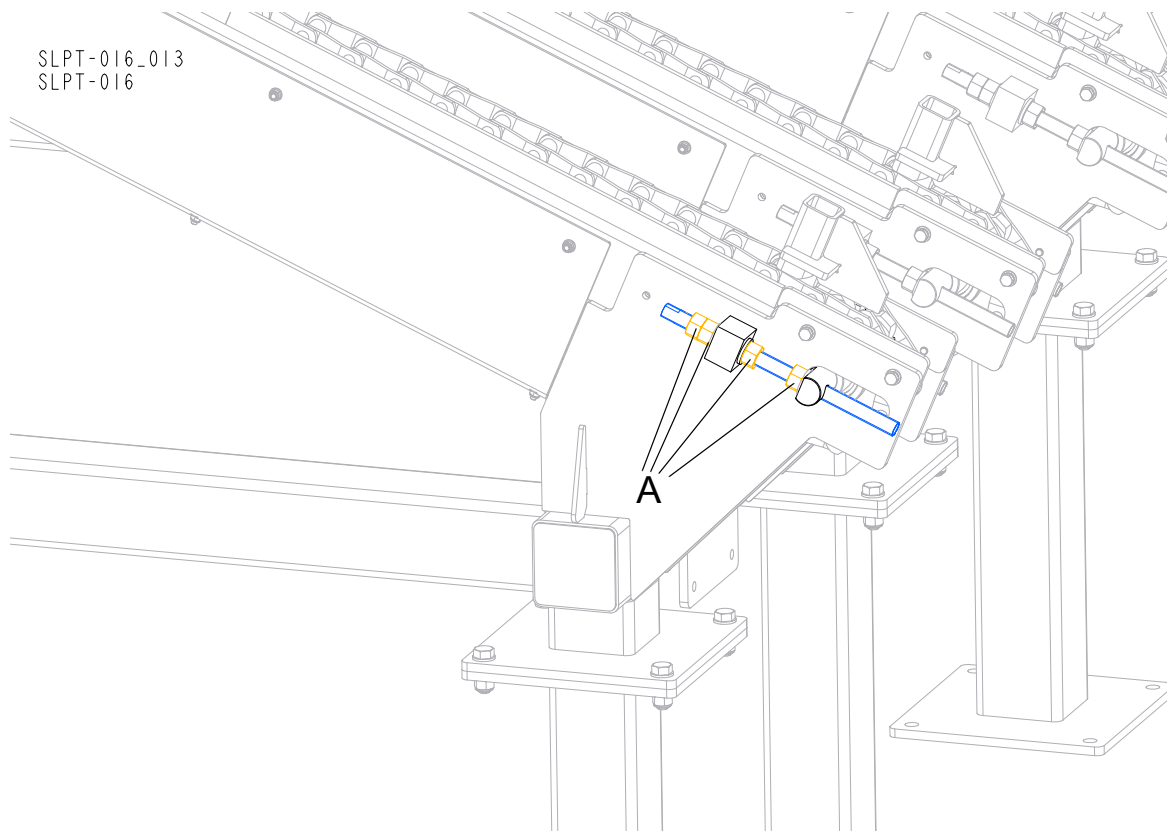


FIG. 5-22

5.10.2 Tensioning the Drive Chain

See **Figure 5-23** To tension the drive chain:

- Loosen the nuts (A),
- Tension the drive chain using the fasteners (B),
- Tighten the nuts (A).

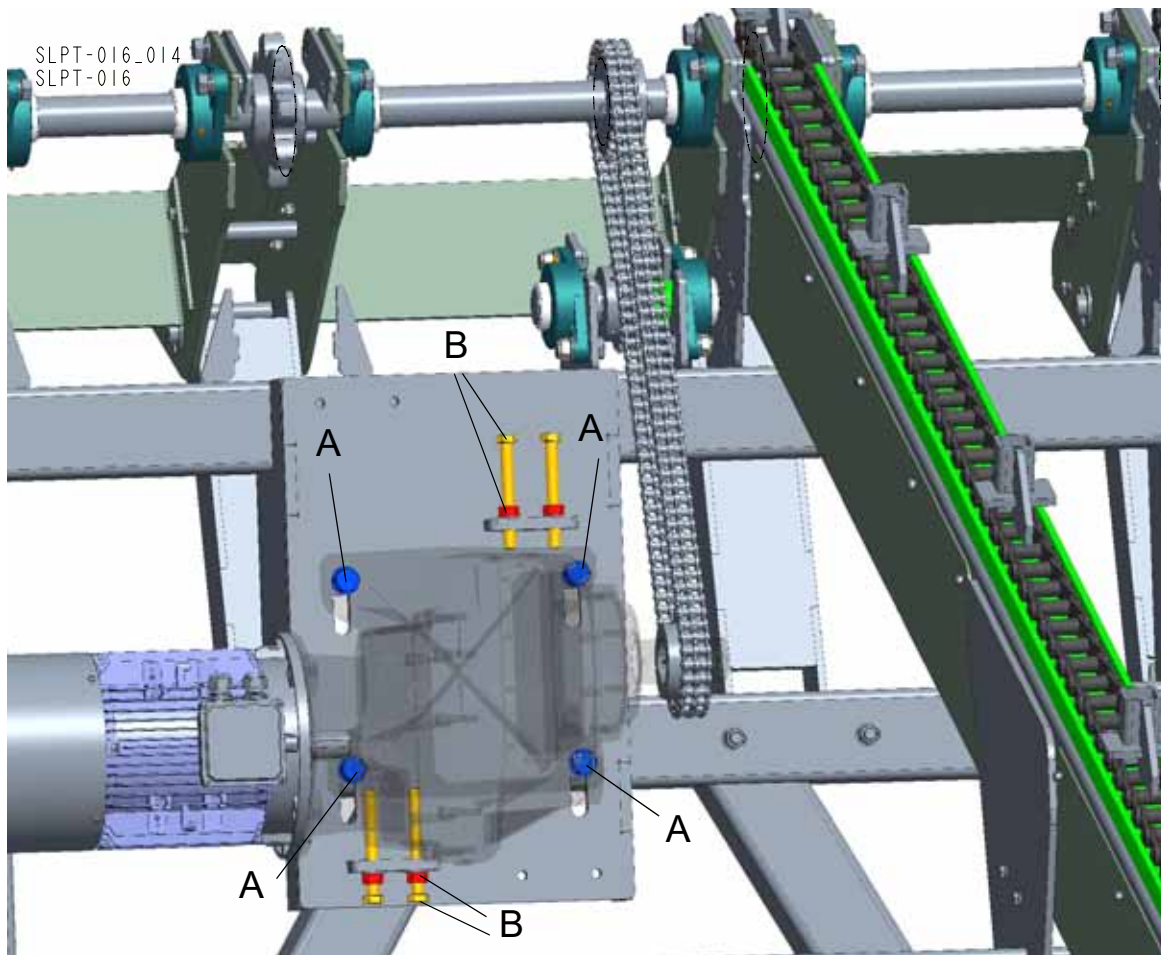


FIG. 5-23

5.11 TV6000 Tables

CAUTION! Do not overtension the chains. Overtensioning may lead to early failure of the gear, bearings, rollers and chains.

5.11.1 Tensioning the Log Turner Drive Chain

See Figure 5-24 Tension the log turner drive chain using the fasteners (A).

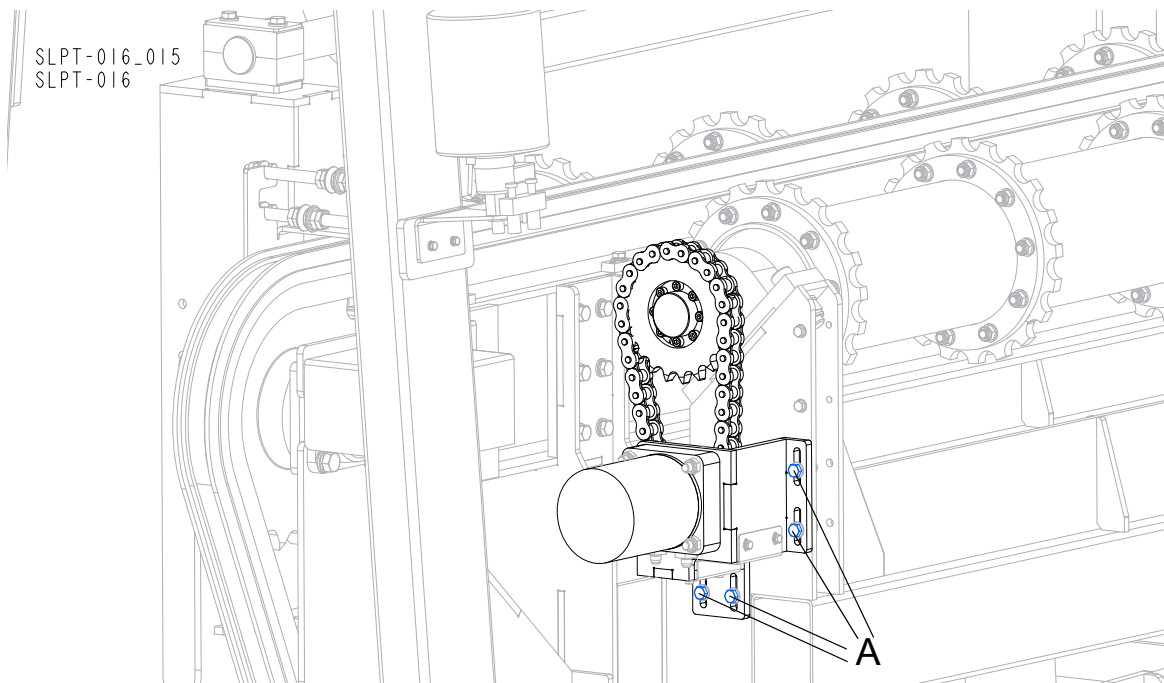


FIG. 5-24

5.11.2 Tensioning the Transport Chain

See Figure 5-25 To tension the main transport chain:

- Loosen the nuts (A),
- Tension the main transport chain using the fasteners (B),
- Tighten the nuts (A).

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SLPT-016

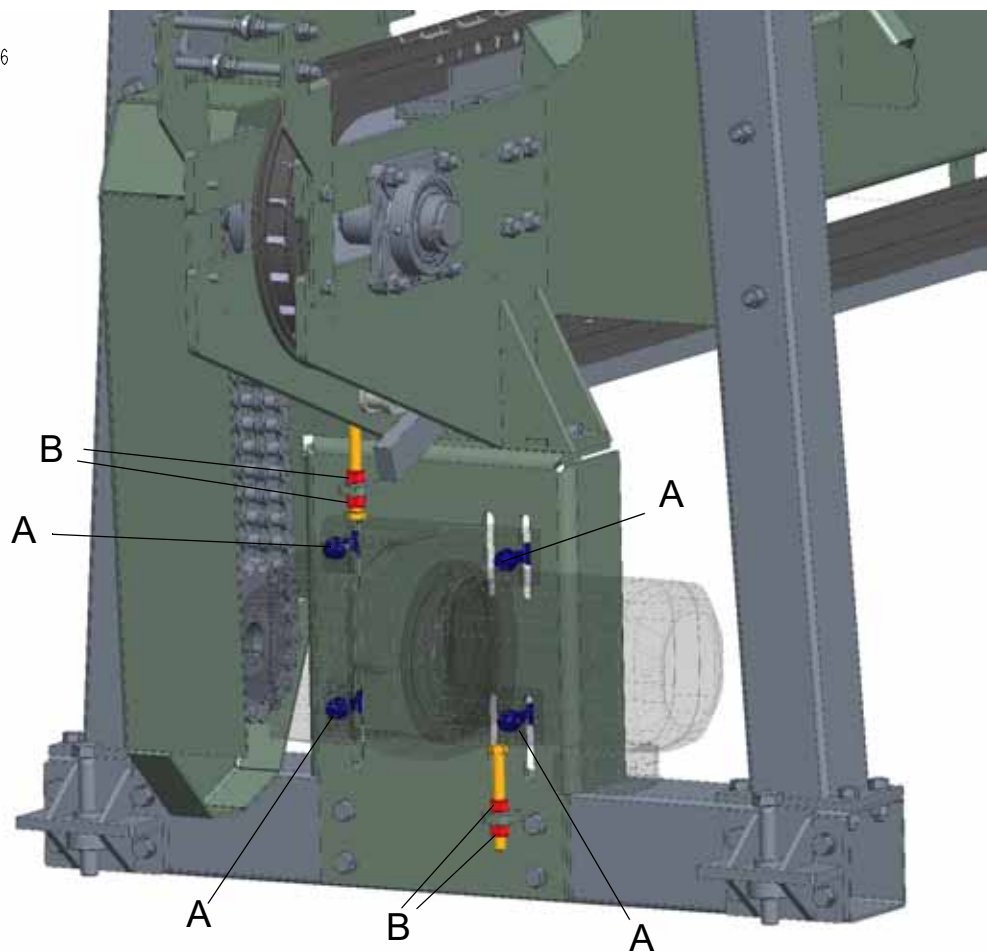


FIG. 5-25

5.11.3 Hold-Down Wheel Alignment

See Figure 5-26 The hold-down wheel alignment includes the following steps:

1. To align the hold-down wheel horizontally:
 - Loosen the fasteners (A),
 - Align the hold-down wheel using the fasteners (B),
 - Tighten the fasteners (A).
2. To align the hold-down wheel vertically:
 - Loosen the fasteners (C),
 - Align the hold-down wheel using the fasteners (D),
 - Tighten the fasteners (C).

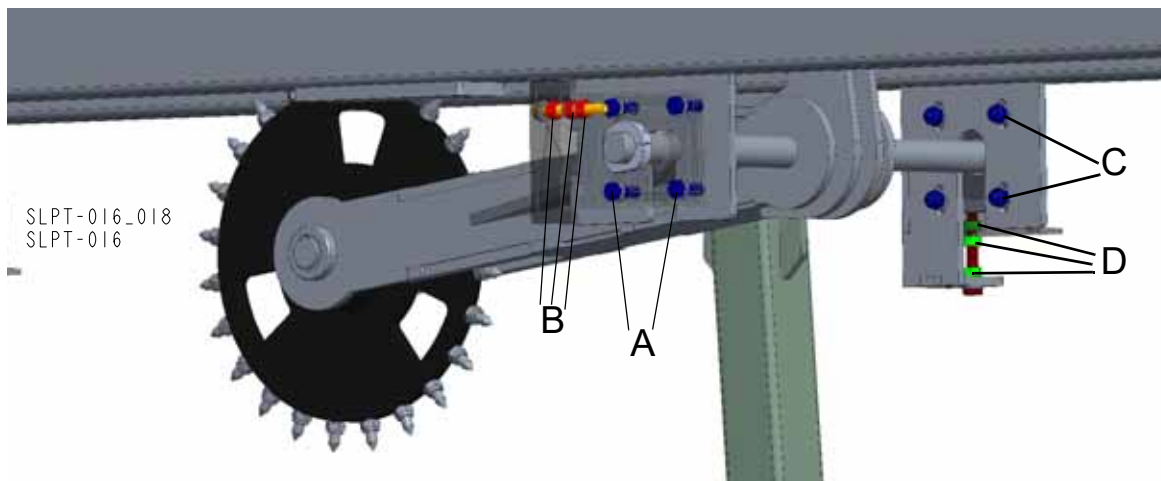


FIG. 5-26

5.12 Drive Belt Adjustment



WARNING! Do not for any reason adjust the drive belt with the motor running. Doing so may result in serious injury.



See Table. 5-1. Check the drive belt tension after the first 20 hours, and every 50 hours thereafter. See the table below for drive belt tension specifications for your resaw.

Motor	Belt Tension
ABB 45 kW	12mm (5") deflection with deflection force of 4.6 kG for new belts, deflection force of 3 kG for used belts

TABLE 5-1

5.12.1 Drive Belt Tension

See Figure 5-27 To adjust the drive belt tension:

1. Dismount the inspection plate.

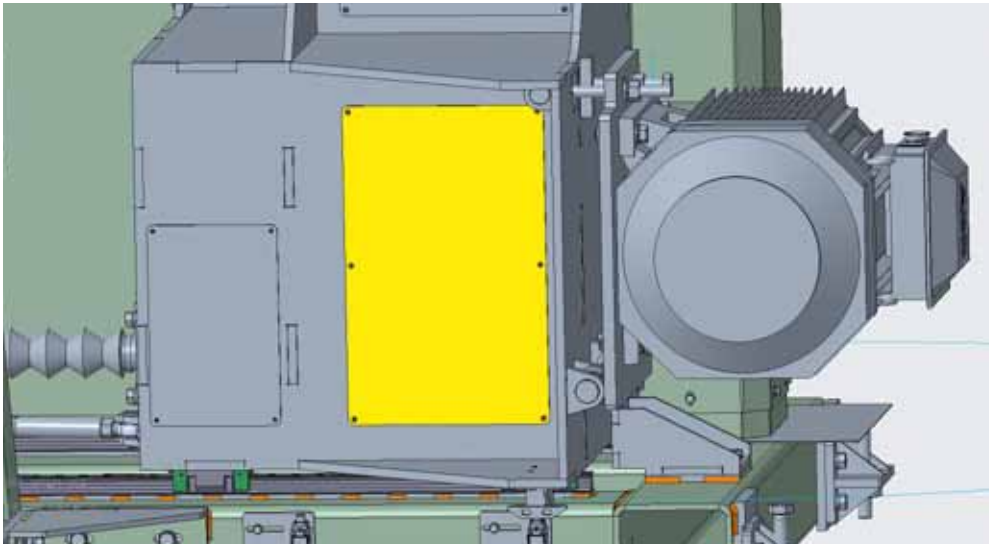


FIG. 5-27

See Figure 5-28

2. Tension the drive belts using the fasteners. **NOTE:** Be sure to adjust the bolts evenly so the motor remains in alignment.

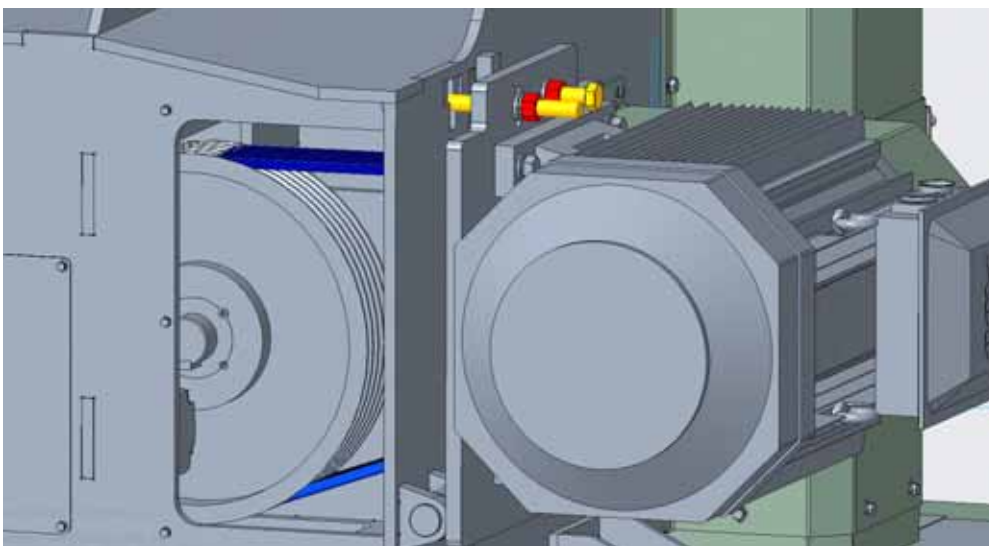


FIG. 5-28

See Figure 5-29

3. Mount the inspection plate.

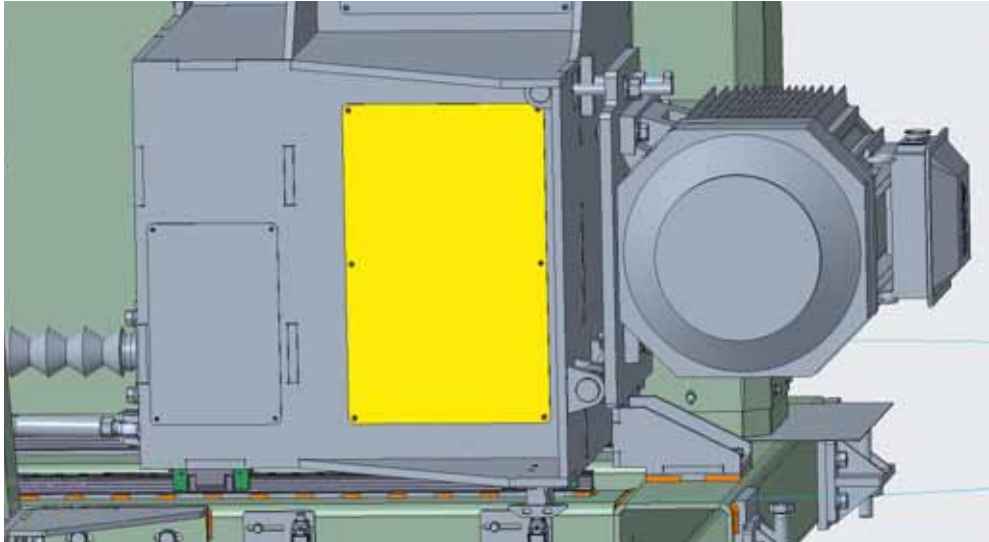


FIG. 5-29



Periodically check the belt for wear. Replace if damaged or worn.

5.12.2 Keep the motor and drive pulleys aligned to prevent premature belt wear.

To align the motor pulley to the drive pulley:

See Figure 5-30

- 1. Dismount the cover.**

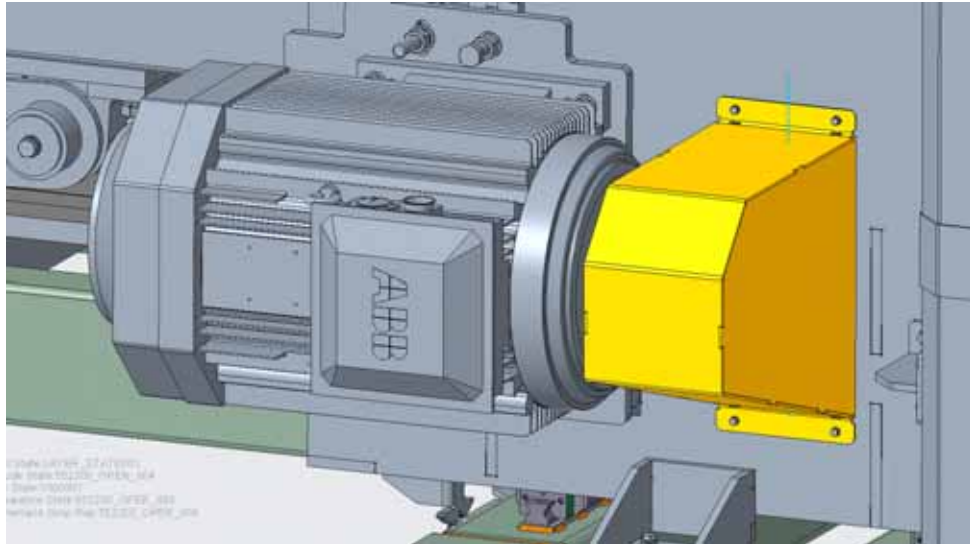


FIG. 5-30

See Figure 5-31

2. Loosen the taper lock bushing mounted on the motor drive shaft.
 - Unbolt the bolts (A),

ALIGNMENT

Keep the motor and drive pulleys aligned to prevent premature belt wear.

- Screw one bolt into the place marked (B) in the drawing below,

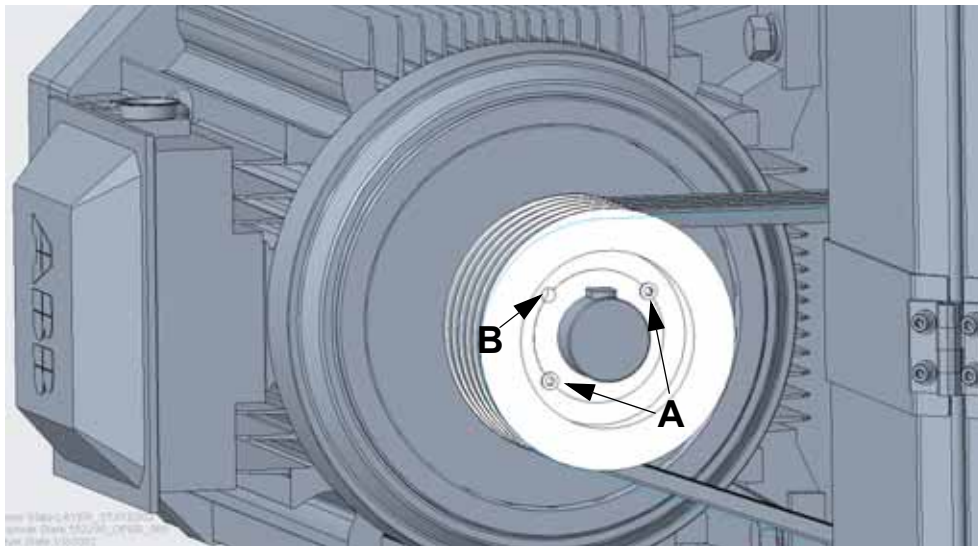


FIG. 5-31

3. Slide the motor pulley until it is in line with the wheel pulley.

See Figure 5-32

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552200

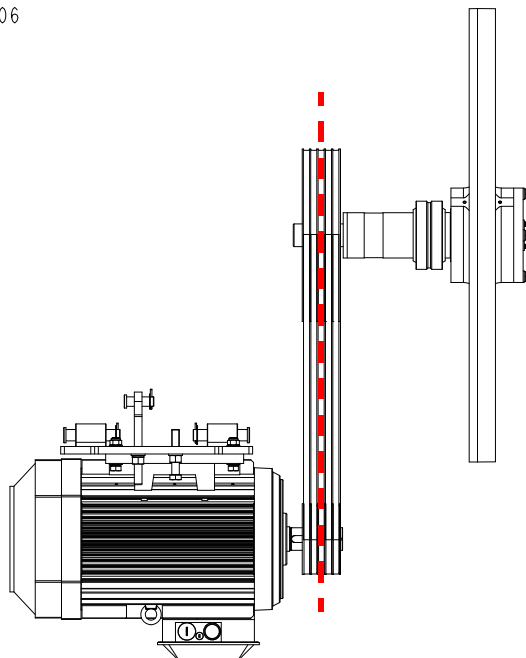


FIG. 5-32

4. After performing the alignment, tighten the taper lock bushing and mount the cover.
5. Check the drive belt tension.

5.13 Replacing the Drive Belts



DANGER! Always shut off the machine motors before replacing the drive belts. Failure to do so may result in serious injury.

See Figure 5-33

1. Dismount the inspection plate.

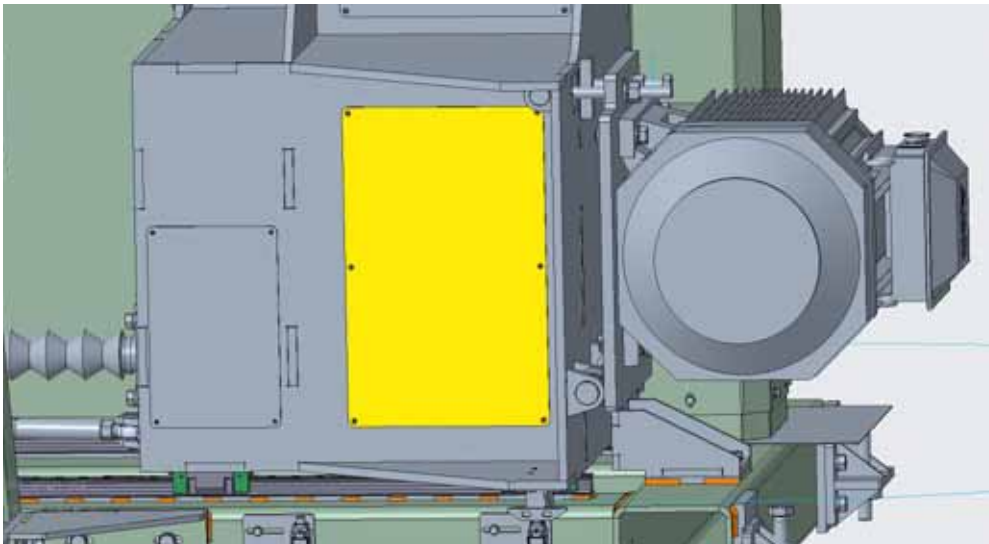
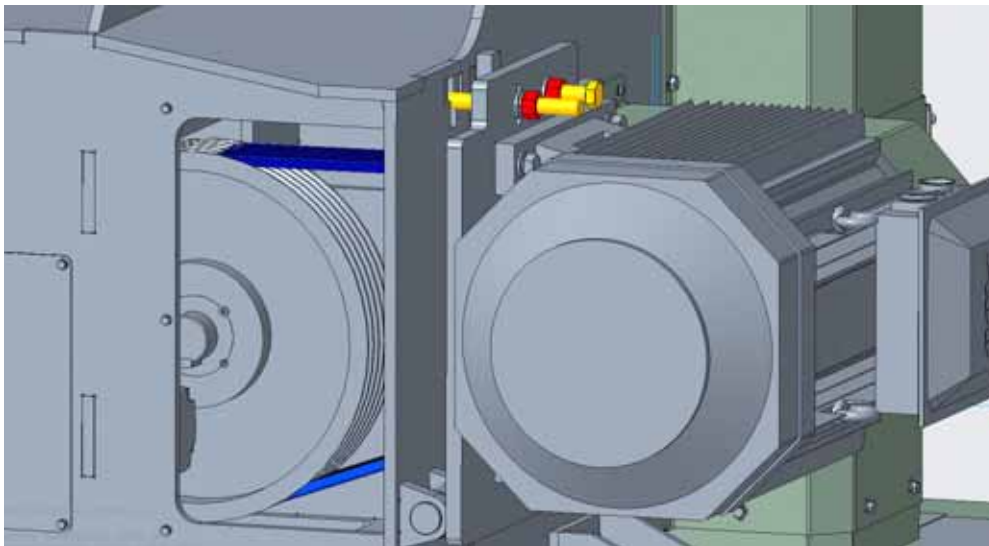


FIG. 5-33

See Figure 5-34

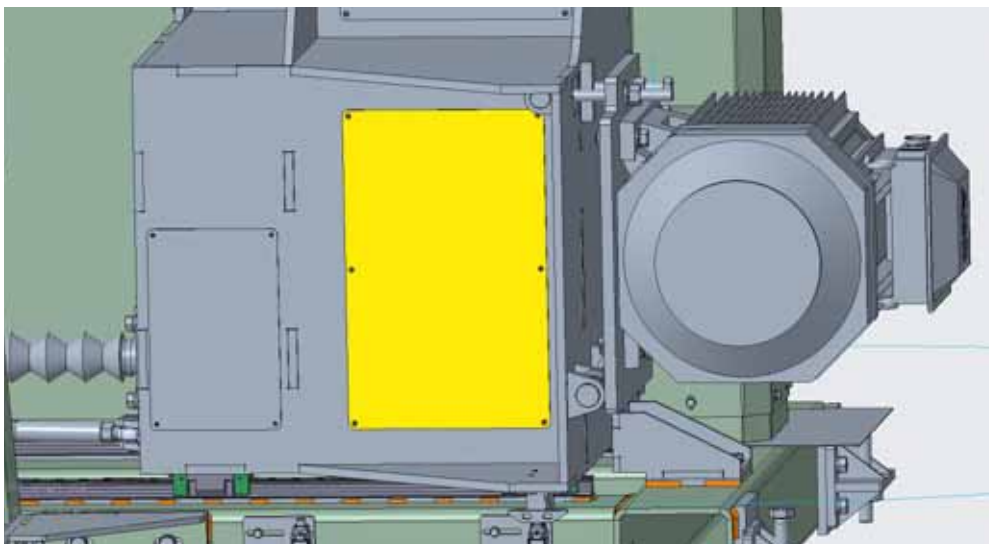
2. Loosen the drive belts using the fasteners.

**FIG. 5-34**

3. Replace and tension the drive belts.

See Figure 5-35

4. Mount the inspection plate.

**FIG. 5-35**

SECTION 6 SPECIFICATIONS

6.1 Overall Dimensions

The major dimensions of the TV6000 saw are shown below (all dimensions are in millimeters and inches).

6.2 TV6000

See Figure 6-1 TV6000 - all dimensions are given in millimeters and inches.

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SLPT-016

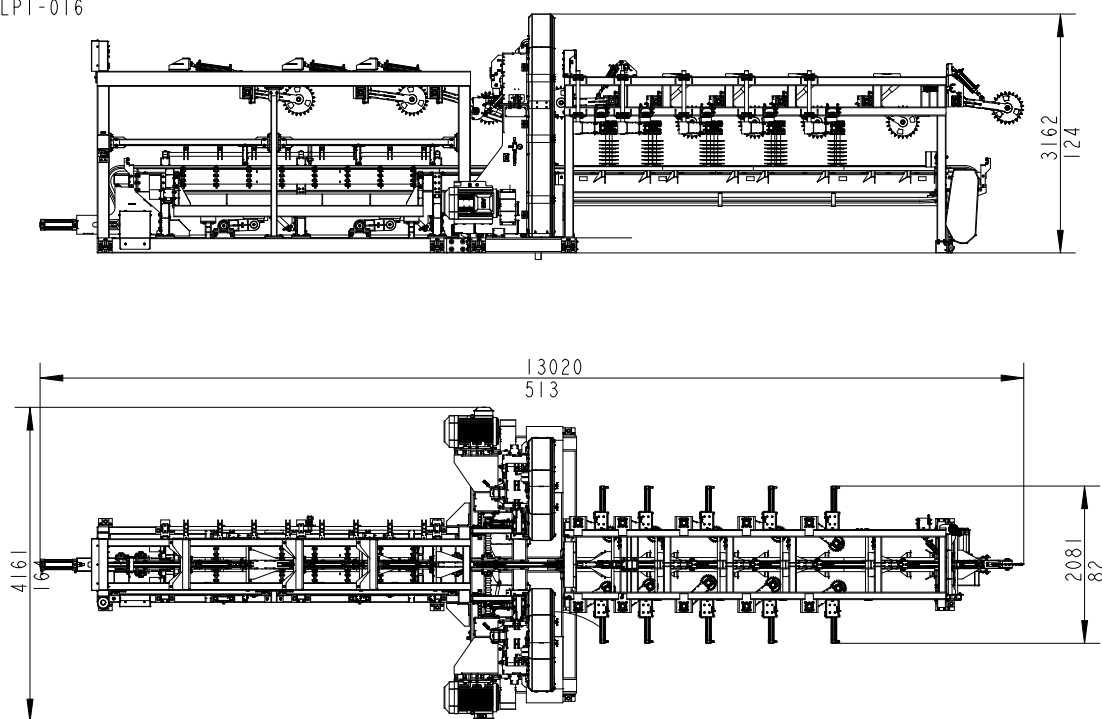


FIG. 6-1 552200

6.2.1 TV6000 Infeed

See Figure 6-2 TV6000 Infeed - all dimensions are given in millimeters and inches.

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SLPT-016

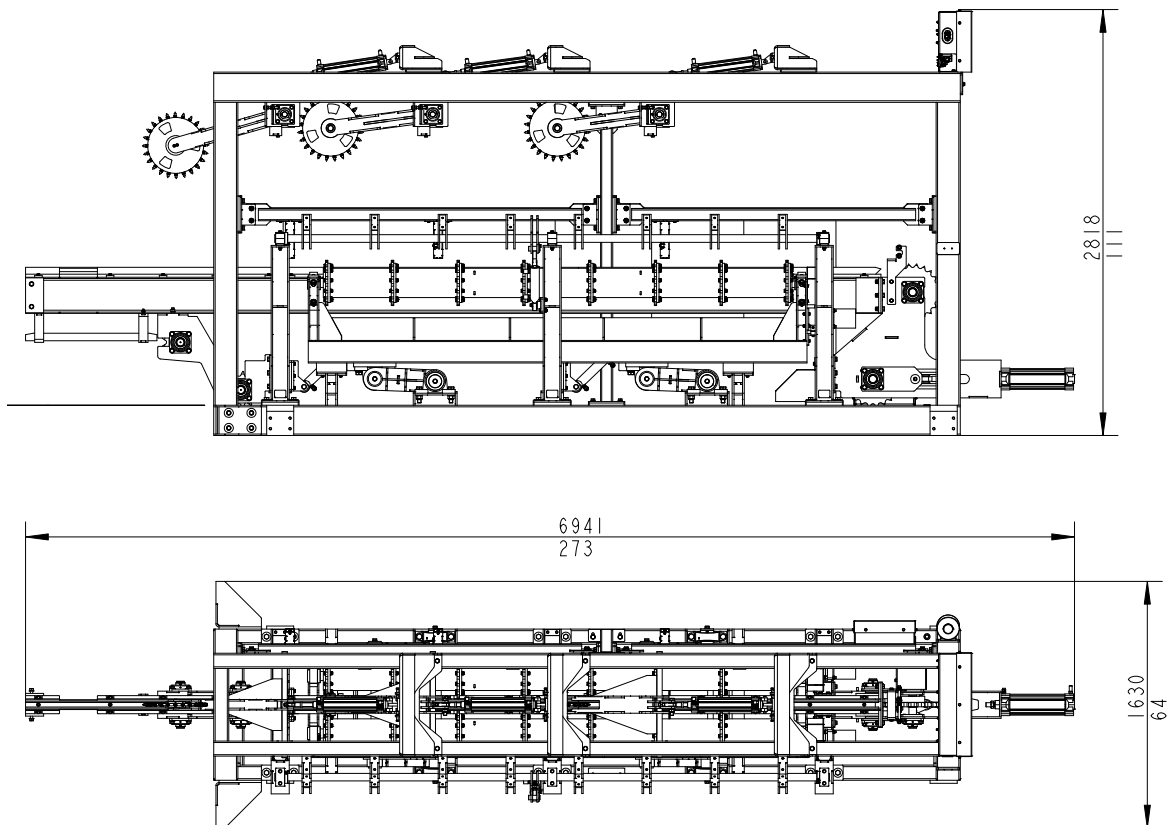


FIG. 6-2 551871

6.2.2 TV6000 Outfeed

See Figure 6-3 TV6000 Outfeed - all dimensions are given in millimeters and inches.

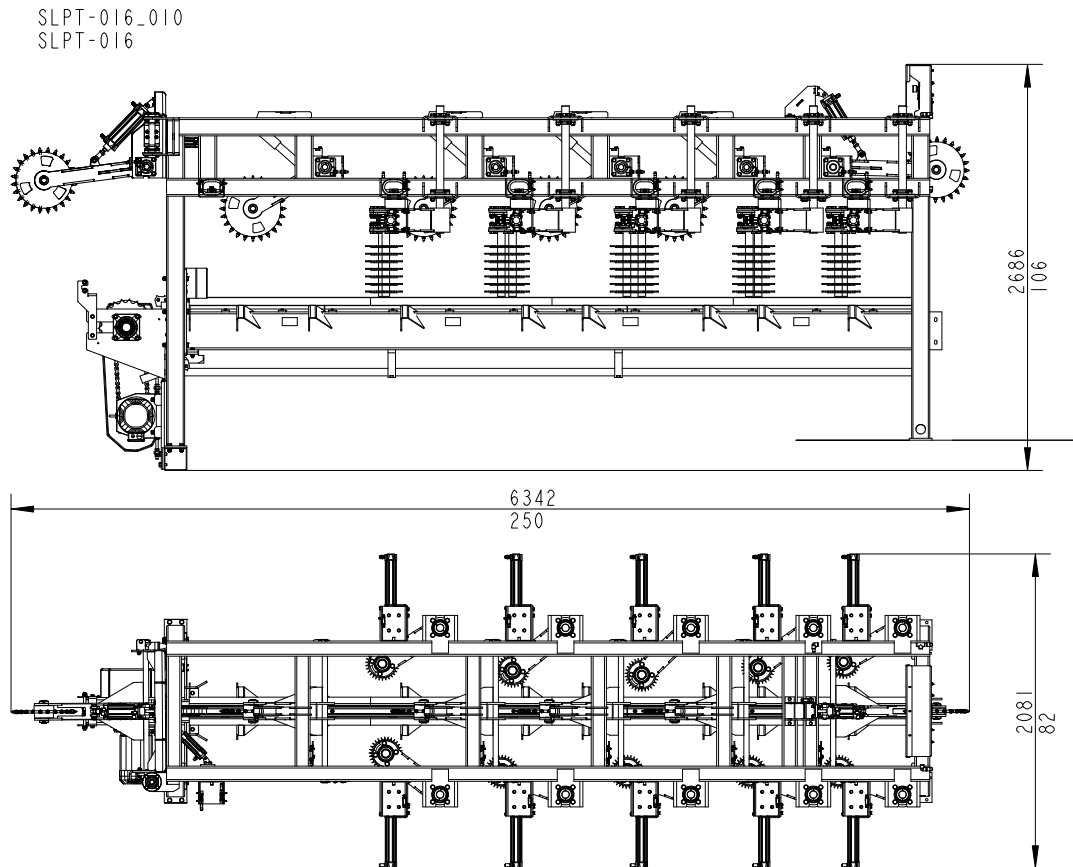


FIG. 6-3 552402

6.3 Material Dimensions

See Table 6-1.TV6000 input material specifications

	SLPT-016 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")

TABLE 6-1

6.4 Cutting Capacity

TV6000 can process up to 6 logs per minute.

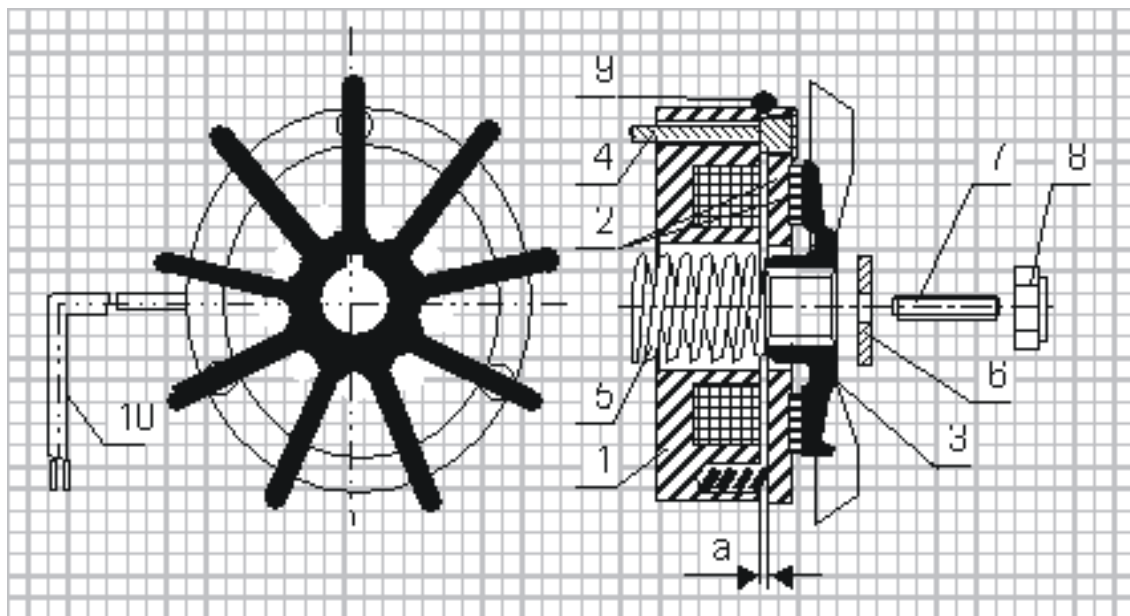
6.5 Motor Specifications

See Table 6-2. The TV6000 motors are listed below.

Motor Type	Manufacturer	Power	Other Specifications
Blade Motor	ABB	45kW	460 V/60Hz; 98 A
Debarker Motor	Indukta, Polska	1.1 kW	460 V/60Hz; 2,5 A
Outfeed Table, Feed Chain Motor	SEW	5.5 kW	460 V/60Hz; 12A
Hydraulic Pump Motor	IOW	7.5kW	460 V/60Hz; 16 A

TABLE 6-2

SECTION 7 DC ELECTROMAGNETIC BRAKE (CE ONLY), SIEMENS MOTORS



- 1 - Electromagnet,
- 2 - Armature complete with brake linings,
- 3 - Fan,
- 4 - Retaining bolt
- 5 - Central spring,
- 6 - Special washer,
- 7 - Set screw,
- 8 - Self-locking nut,
- 9 - Sealing ring,
- 10 - Output cable.

7.1 Design and principle of operation

The DC electromagnetic brake type H consists of 3 main subassemblies:

- electromagnet (1),
- armature complete (2)
- cast iron fan (3).

Electromagnet (1) energised: The DC voltage from the motor applied via the rectifying circuit causes the attraction of the armature (2) releasing the brake and thus the fan (3) is free to rotate.

Electromagnet (1) de-energised: The electromagnet stops to attract the armature (2) and spring

presses the armature with brake linings (2) against the fan and the brake is thus applied.

7.2 Service

During normal operation and at the routine inspections verify the air gap and check if all screws are tight. In case when any symptoms of inefficient braking are observed, then use the self-locking nut (8) to re-adjust the air gap to the value corresponding to Table 1.

Such readjustment may be repeated until the brake linings are completely worn out. When this will occur, a complete armature with brake linings (2) must be replaced.

If the air gap of the brake is correctly adjusted and despite of it the brake does not operate properly (the brake fails to release), it may be caused by:

- the electromagnet (1): burned coil or defected output cable (10),
- rectifying circuit (installed in the electric motor terminal box).

The above mentioned subassemblies should be checked and defected part replaced.

Table 1:

TYPE	H-63	H-71	H-80	H-90	H-100	H-112	H-132	H-160
Nominal Gap „a”	0.2 ±0,05	0.2 ±0,05	0.2 ±0,05	0.2 ±0,05	0.2 ±0,1	0.2 ±0,1	0.2 ±0,1	0.2 ±0,1