

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

Chain Conveyor (CC7) rev. A1.00

Safety is our #1 concern!

Form #2040

Models Effected:

SLPILD, Incline Log Deck

SLPILD-USED, Incline Log Deck, Used



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

California

Proposition 65 Warning



WARNING: Breathing gas/diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

Always start and operate the engine in a well-ventilated area.
If in an enclosed area, vent the exhaust to the outside.
Do not modify or tamper with the exhaust system.
Do not idle the engine except as necessary.

For more information go to www.P65warnings.ca.gov.



WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection.

For more information go to www.P65Warnings.ca.gov/wood.

Active Patents assigned to Wood-Mizer, LLC

Wood-Mizer, LLC has received patents that protect our inventions which are a result of a dedication to research, innovation, development, and design. Learn more at: woodmizer.com/patents

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Wood-Mizer, LLC
8180 West 10th Street
Indianapolis, Indiana 46214

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Wood-Mizer® LLC Limited Product Warranty



Wood-Mizer LLC ("Warrantor"), an Indiana corporation with its principal place of business at 8180 West Tenth Street, Indianapolis, IN 46214-2400 USA, warrants to the purchaser ("Purchaser") that for the time periods specifically stated herein and subject to the terms, conditions and limitations stated herein, the equipment manufactured by the Warrantor will be free from defects in material and workmanship attributable to Warrantor so long as, during the warranty periods stated herein, the equipment is installed, operated and maintained in accordance with the instructions provided by Warrantor.

PRODUCT	MODEL CLASS	LENGTH OF WARRANTY		EFFECTIVE DATE
		USA & CANADA	NON USA & CANADA	
Portable Sawmills, Resaws, Edgers	LT, LX, HR, EG	Two years	One year	Date of purchase
Portable Sawmills with Chassis	LT28, LT35, LT40, LT50, LT70, LX450	Two years, excluding the chassis, which chassis shall have a five year warranty	One year	
Industrial Sawmills, Resaws, Edgers	WM, HR, EG, TVS, SVS	One year	One year	Date of purchase or date of installation / training (if applicable), whichever occurs first, not to exceed 6 months from date of purchase
TITAN Industrial	WB, TV, HR, EG, EA, MR	One year	One year	
Material Handling	TWC, IC, TD, LD, GC, CR, CB, CC	One year	One year	
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	Date of purchase
Options and Accessories	Various	One year*	One year*	
Moulders, Extractors	MP, MD	Two years	One year	
Kilns	KS, KD	One year	One year	
Slab Flattener	MB	Two years	One year	
Pallet Equipment	PD, PC	One year	One year	
Log Splitters	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

* Warranty on Options will match the warranty on the primary equipment when purchased on same invoice.

Exclusions from 90 Day, Limited One Year and Two Year Warranty

Warrantor shall have **no** responsibility under this warranty for any wear components, including, but not limited to: belts, blade guides, blades, electric motor brushes, drum switches, filters, fuses, hoses, bearings (excluding cylindrical drive bearings), bushings, cable carriers, and spark plugs. All wear components are furnished "as is", without any warranty from Warrantor. This limited warranty does not cover any defects caused by misuse, negligence, alterations, damage due to overload, abnormal conditions, excessive operation, accident, or lack of performance of normal maintenance services.

Several components which are used in the manufacture of the equipment but not manufactured by Warrantor such as cant hooks, power plants, laser sights, batteries, tires, and trailer axles have warranties provided by the original equipment manufacturer (written copies available upon request). Warrantor does not separately warrant such items. Components or equipment manufactured by third parties are not covered by this warranty. Warrantor, however, will provide reasonable assistance to the Purchaser to make claims against any warranties applicable to such component parts as provided by such original equipment manufacturers. Components or equipment manufactured by third parties are not covered by this Warranty.

Five Year Limited Chassis Warranty

The limited five year chassis warranty described above, DOES NOT extend to (a) any damage stemming from accident, improper towing, overload, abuse, misuse, abnormal conditions, negligence, excessive operation, or lack of maintenance, (b) rust caused by exposure to corrosive atmospheric conditions, or (c) the sawmill head, carriage, axle, brakes, or any hydraulic or electrical components attached to the chassis.

Warrantor's Obligations as To Defects

In the event that the equipment fails to perform due to defective materials or workmanship attributable to Warrantor under normal use and service within the established warranty period, Purchaser's sole and exclusive remedy and Warrantor's sole liability shall be to replace or repair, in Warrantor's sole and subjective discretion, any defective part at Warrantor's principal place of business without cost to the Purchaser if such defect exists. The determination of whether a product is defective shall be made by Warrantor in Warrantor's sole and subjective discretion. The Purchaser must notify Warrantor prior to shipping any defective part. Warrantor, at its sole discretion, may cover expenses incurred in shipping the defective part to Warrantor for evaluation; provided, however, that Warrantor will not be responsible for labor, travel time, mileage, removal, installation or incidental or consequential damages. However, any part in excess of 140 pounds must be returned by the Purchaser, to the Warrantor's nearest authorized facility at the Purchaser's expense, if return is requested by Warrantor. Warrantor shall have a reasonable time within which to replace or repair the defective part. If Warrantor determines that the product is not defective under the terms of this warranty in Warrantor's sole and subjective discretion, then Purchaser shall be responsible for any expenses incurred by Warrantor in returning the equipment to the Purchaser.

Limitations and Disclaimers of Other Warranties

EXCEPT FOR THE EXPRESS WARRANTY PROVISIONS STATED ABOVE, WARRANTOR DISCLAIMS ALL WARRANTIES, EXPRESS AND/OR IMPLIED, INCLUDING WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT AND TITLE. No representation or other affirmation of fact by representatives of Warrantor, whether verbal or in writing, including photographs, brochures, samples, models, or other sales aids, shall constitute a warranty or other basis for any legal action against Warrantor. There are no other representations, promises, agreements, covenants, warranties, guarantees, stipulations or conditions, express or implied, by Warrantor except as expressly set forth herein. THE ORIGINAL PURCHASER AND ANY INTENDED USER OR BENEFICIARY OF THIS EQUIPMENT, SHALL NOT BE ENTITLED TO RECOVER ANY INDIRECT, SPECIAL, PUNITIVE, EXEMPLARY, CONSEQUENTIAL, SPECIAL, OR INCIDENTAL DAMAGES OR LOSSES, INCLUDING BUT NOT LIMITED TO, DAMAGES OF LOST PRODUCTION, LOST REVENUE, LOST PRODUCT, LOST PROFITS, LOST BUSINESS, LOSS OF USE, LOSS OF GOODWILL, OR BUSINESS INTERRUPTION, FROM WARRANTOR FOR ANY REASON WHATSOEVER INCLUDING WITHOUT LIMITATION WARRANTY OR DEFECT IN THE PRODUCT REGARDLESS OF THE SOLE, JOINT AND/OR CONCURRENT NEGLIGENCE, BREACH OF CONTRACT, BREACH OF WARRANTY, STRICT LIABILITY IN TORT OR STATUTORY CLAIMS OR OTHER LEGAL FAULT OR RESPONSIBILITY OF EITHER WARRANTOR OR PURCHASER OR ITS EMPLOYEES OR AGENTS. Warrantor does not warrant that its equipment meets or complies with the requirements of any particular safety code or governmental requirements.

Defective items replaced under the terms of this warranty become the property of Warrantor.

Design Changes

Warrantor reserves the right to change the design of its products from time to time without notice and without obligation to make corresponding changes in or to its products previously manufactured.

Rights of Purchasers

The validity and effect of this limited warranty as well as its interpretation, operation and effect, shall be determined exclusively by the principles of law and equity of the State of Indiana, USA. This limited warranty gives Purchaser specific legal rights. Purchaser may also have other rights, which may vary from state to state. Some states may not allow limitations as to the duration of implied warranties or to the exclusion or limitation of incidental or consequential damages, so some of the limitations and exclusions detailed set forth above may not apply. In the event that any one or more of the provisions of this warranty shall be or become invalid, illegal or unenforceable in any respect, the validity, legality and enforceability of the remaining provisions of this warranty shall not be affected thereby.

Interpretations

This Warranty constitutes the entire warranty agreement between Warrantor and Purchaser and supersedes any prior understandings or agreements pertaining to the same subject matter. This warranty cannot be amended except in writing which refers to this warranty which is signed by both Warrantor and Purchaser.

SECTION 1 INTRODUCTION

1.1 About This Manual

This manual is to replace or to be used with all previous information received concerning the CC conveyor. All future mailings will be an addition to or a revision of individual sections of this manual as we obtain new information.

The information and instructions given in this manual do not amend or extend the limited warranties for the equipment given at the time of purchase.

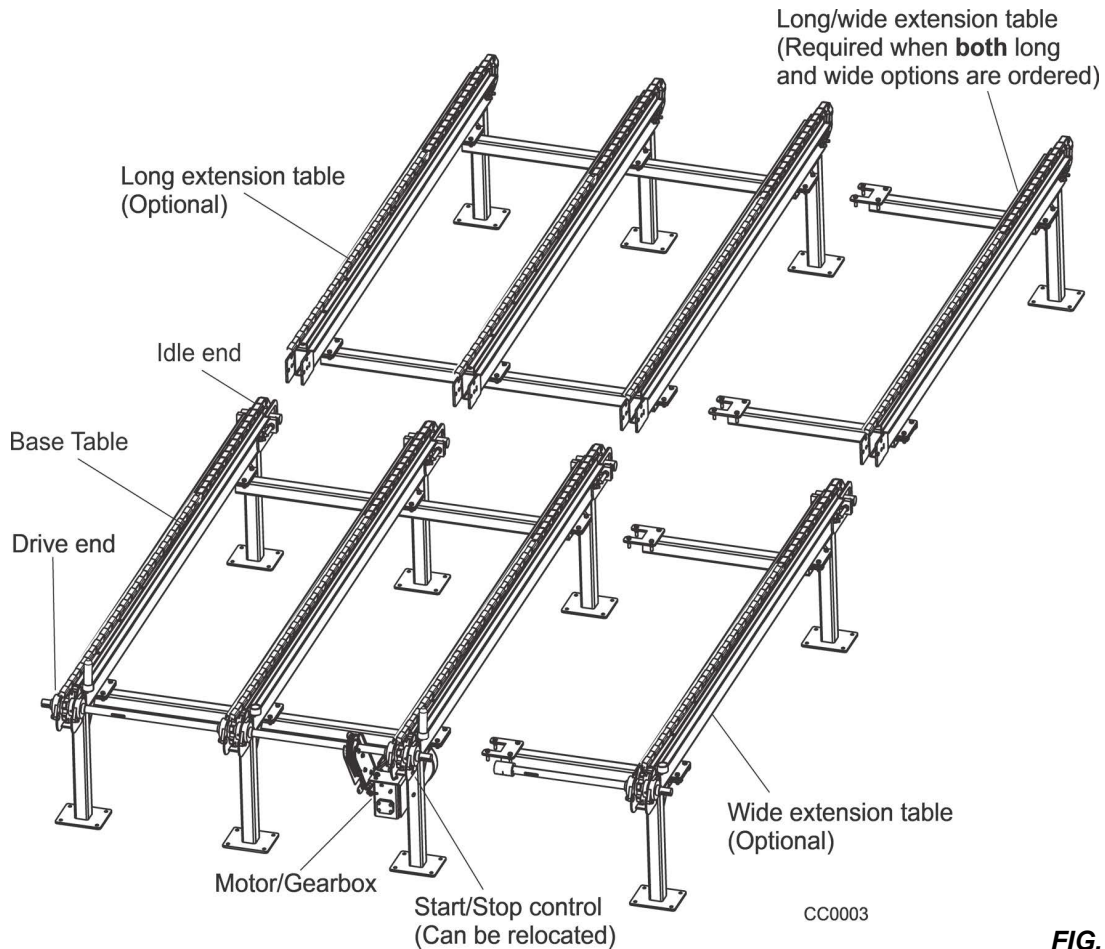


FIG. 1-1

1.2 Dimensions

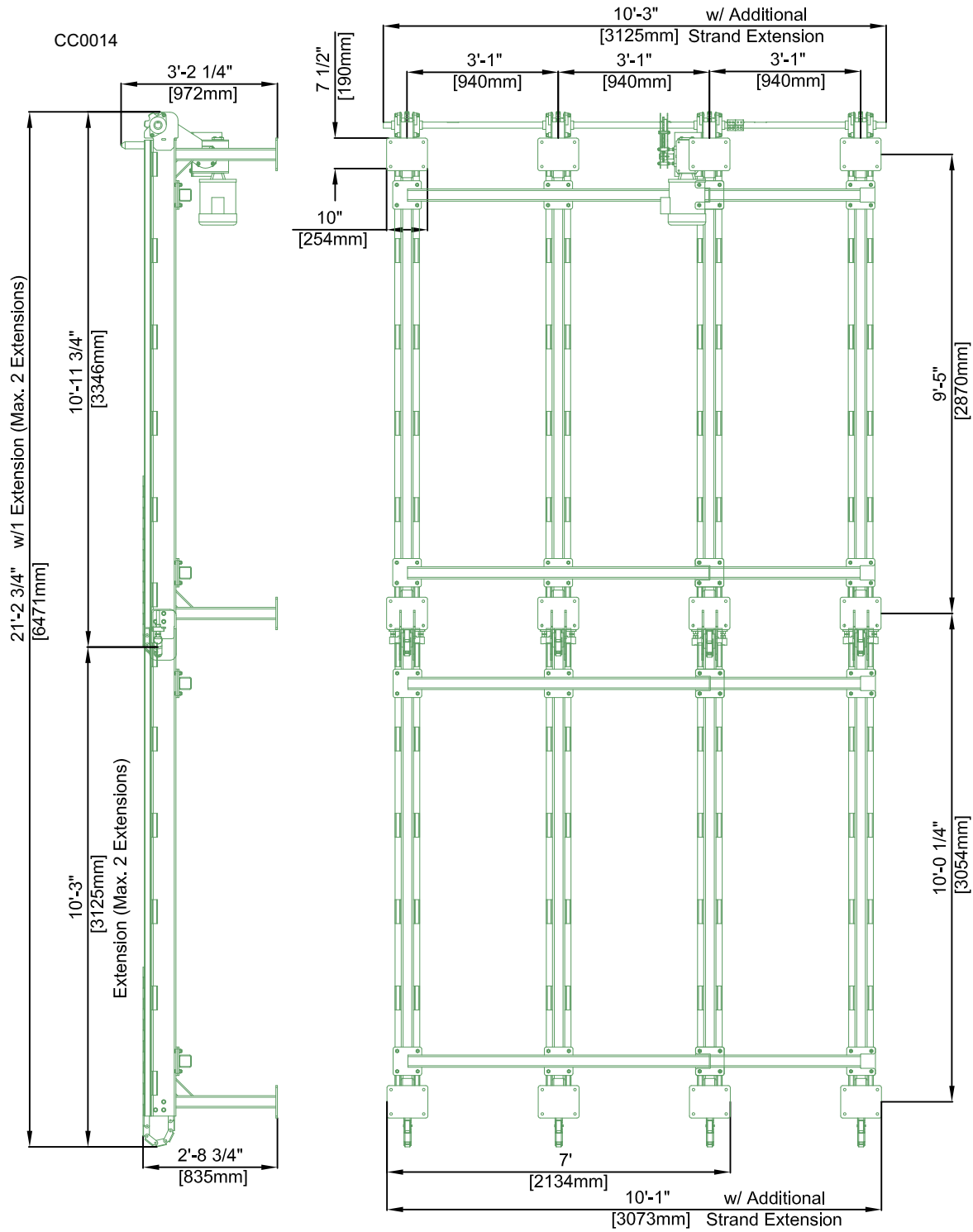


FIG. 1-2

1.3 Specifications

	Board/Slab Length 4' to 12'	1220-3658mm
	Weight: 3000 lbs.	1360kg
Model: CC7 Conveyor Rev. A1.00+		
Normal Power Usage		
Dimensions:	Chain Speed: ft./min.	m/min.
Electrical Requirements:	Length: 10'-11 3/4"	3346mm
	Length w/1 Extension Table: 21'-2 3/4"	6471mm
	Length w/2 Extension Tables: 30'-11 7/8"	9445mm
	Suggested Wire Size (50' max.): AWG	2134mm
	Width: 7'	3125mm
	Width w/Additional Strand Extension: 10'-3"	972mm
	Height: 38-1/4"	
Weight:		
	Basic Unit: lbs.	
Drive:		
	Manufacturer: Leeson	
	Horsepower Rating: 1.5HP	
	RPM: 1170	
Capacity:		
	Board/Slab Length 4' to 12'	1220-3658mm
	Weight: 3000 lbs.	1360kg
Rates:		
	Normal Power Usage	
	Chain Speed: ft./min.	m/min.
Electrical Requirements:		
	Electrical Service: 230/460V 3 Phase 50/60Hz 10A	
	Suggested Wire Size (50' max.): AWG	

FIG. 1-3 CC CONVEYOR SPECIFICATIONS

SECTION 2 SAFETY

2.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety.



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



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



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

NOTICE indicates vital information.

2.2 Safety Instructions

OWNER/OPERATOR'S RESPONSIBILITY

The procedures listed in this manual may not include all ANSI, OSHA, or locally required safety procedures. **It is the owner/operator's responsibility and not Wood-Mizer LLC to ensure all operators are properly trained and informed of all safety protocols.** Owner/Operators are responsible for following all safety procedures when operating and performing maintenance to the equipment.

Observe ALL Safety Instructions

NOTICE Read the entire Operator's Manual before operating this equipment.

Note all safety warnings throughout this manual and those posted on the machine.

Be able to access this manual at all times while operating this equipment.

Read additional manufacturer's manuals and observe their applicable safety instructions.

Only persons who have read and understood the entire operator's manual should operate this equipment.

This equipment is not intended for use by or around children.




It is the owner/operator's responsibility to comply with all applicable federal, state, and local laws, rules, and regulations regarding the ownership, operation, and transporting your equipment. Operators

should become thoroughly familiar with and comply with these applicable laws for operating and transporting equipment.


2.3 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.

SETUP

 **WARNING!** Use extreme care and proper equipment to lift and move the conveyor. Lift under the base of the machine only.


WEAR SAFETY CLOTHING

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


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



KEEP CONVEYOR AND AREA AROUND CONVEYOR CLEAN

 **DANGER!** Maintain a clean and clear path for all necessary movement around the conveyor and lumber stacking areas.


DISPOSE OF SAWING BY-PRODUCTS PROPERLY


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

NOTICE Always properly dispose of all sawing by-products, including sawdust and other debris, coolant, oil, fuel, oil filters and fuel filters.




CHECK CONVEYOR BEFORE OPERATION

 **DANGER!** Make sure all guards and covers are in place and secured before operating the conveyor.


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



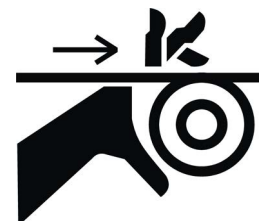
KEEP PERSONS AWAY

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

KEEP HANDS AWAY

 **DANGER!** Moving parts can crush and cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating or towing.

Be aware of and take proper protective measures against rotating shafts, pulleys, sprockets, etc.



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! Coastdown required! Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

2.4 Electrical Lockout Procedures

RULES FOR USING LOCKOUT PROCEDURE

The sawmill shall be locked out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch or valve bearing a lock.

LOCKOUT PROCEDURES MUST BE USED DURING:

Changing or adjusting blades	Electrical maintenance
Unjamming operations	Retrieval of tools/parts from work area
Cleaning	Activities where guards or electrical panel guard is open or removed
Mechanical repair	

Table 1:

MAINTENANCE HAZARDS INCLUDE:

Blade contact	Missiles (thrown blades/wood chips)
Pinch points	Electrical
Kickbacks	

Table 2:

FAILURE TO LOCKOUT MAY RESULT IN:

Cut	Serious injury and death
Crush	Amputation
Blindness	Burn
Puncture	Shock
Electrocution	

Table 3:

TO CONTROL MAINTENANCE DANGERS:

- Lockout procedures must be followed (see OSHA regulation 1910.147).
- Never rely on machine stop control for maintenance safety (emergency stops, on/off buttons, interlocks).
- Do not reach into moving blades or feed systems. Allow all coasting parts to come to a complete stop.
- Electrical power supply and air supply must both be locked out.
- Where established lockout procedures cannot be used (electrical troubleshooting or mechanical dynamic troubleshooting), alternative effective protective techniques shall be employed which may require special skills and planning.
- Always follow safe operations practices in the workplace.

SAWMILL LOCKOUT PROCEDURE

Lockout procedures per OSHA regulation 1910.147, appendix A:

GENERAL

The following simple lockout procedure is provided to assist owner/operators in developing their procedures so they meet the requirements of OSHA regulation 1910.147. When the energy isolating devices are not lockable, tagout may be used, provided the owner/operator complies with the provisions of the standard which require additional training and more rigorous periodic inspections. When tagout is used and the energy isolating devices are lockable, the owner/operator must provide full operator protection (see OSHA regulation 1910.147, paragraph (c)(3)) and additional training and more rigorous periodic inspections are required. For more complex systems, more comprehensive procedures may need to be developed, documented, and utilized.

PURPOSE

This procedure establishes the minimum requirements for the lockout of energy isolating devices whenever maintenance or servicing is done on machines or equipment. It shall be used to ensure that the machine or equipment is stopped, isolated from all potentially hazardous energy sources and locked out before personnel perform any servicing or maintenance where the unexpected energization or start-up of the machine or equipment or release of stored energy could cause injury.

COMPLIANCE WITH THIS PROGRAM

All personnel are required to comply with the restrictions and limitations imposed upon them during the use of lockout. The authorized personnel are required to perform the lockout in accordance with this procedure. All operators, upon observing a machine or piece of equipment which is locked out to perform servicing or maintenance shall not attempt to start, energize, or use that machine or equipment.

SEQUENCE OF LOCKOUT

1. Notify all affected personnel that servicing or maintenance is required on a machine or equipment and that the machine or equipment must be shut down and locked out to perform the servicing or maintenance.
2. The authorized employee shall refer to the company procedure to identify the type and magnitude of the energy that the machine or equipment utilizes, shall understand the hazards of the energy, and shall know the methods to control the energy.
3. If the machine or equipment is operating, shut it down by the normal stopping procedure (depress the stop button, open switch, close valve, etc.).
4. De-activate the energy isolating device(s) so that the machine or equipment is isolated from the energy source(s).
5. Lock out the energy isolating device(s) with assigned individual lock(s).
6. Stored or residual energy (such as that in capacitors, springs, elevated machine members, rotating fly-wheels, hydraulic systems, and air, gas, steam, or water pressure, etc.) must be dissipated or restrained by methods such as grounding, repositioning, blocking, bleeding down, etc.
7. Ensure that the equipment is disconnected from the energy source(s) by first checking that no personnel are exposed, then verify the isolation of the equipment by operating the push button or other normal operating control(s) or by testing to make certain the equipment will not operate.



CAUTION! Return operating control(s) to neutral or "off" position after verifying the isolation of the equipment.

8. The machine or equipment is now locked out.

RESTORING EQUIPMENT TO SERVICE

When the servicing or maintenance is completed and the machine or equipment is ready to return to normal operating condition, the following steps shall be taken.

1. Check the machine or equipment and the immediate area around the machine to ensure that nonessential items have been removed and that the machine or equipment components are operationally intact.
2. Check the work area to ensure that all personnel have been safely positioned or removed from the area.
3. Verify that the controls are in neutral.

4. Remove the lockout devices and re-energize the machine or equipment.

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

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

PROCEDURE INVOLVING MORE THAN ONE PERSON

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

SECTION 3 INSTALLATION AND SETUP

3.1 Installation

TABLE FRAME ASSEMBLY

Use a forklift or other appropriate equipment to move the conveyor parts, if necessary.

WARNING! Use extreme care and proper equipment to lift and move the conveyor parts. Failure to do so may result in personal injury and/or machine damage.

Assemble the framework table rails and cross members as shown below. Use the fasteners to secure the rails in place. **If you have ordered the wide extension option, it should also be mounted at this time.**

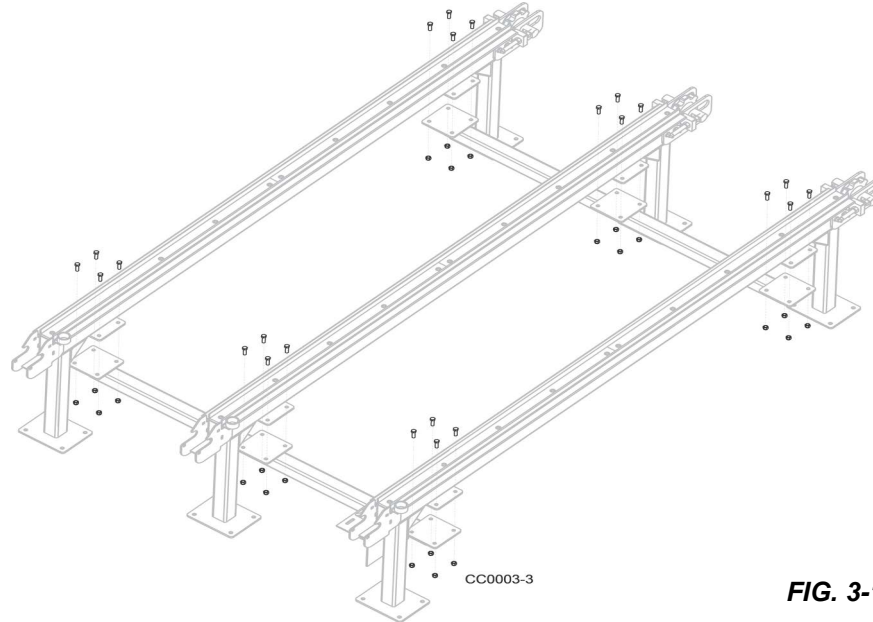


FIG. 3-1

DRIVE SHAFT ASSEMBLY

1. Assemble the shaft in the proper order, as shown in FIG. 3-2. If you have ordered the wide extension option, the shaft extension should also be assembled at this time. See Section “” Wide Extension Table Assembly (Optional)..
2. Start with the middle sprocket and work outward. Be sure the keys align on the sprockets. Allow room between the sprockets and the bearing for the carriage bolts that mount the bearing to the frame, as shown in FIG. 3-2.
3. Install the carriage bolts for the bearings on the frame prior to installing the drive shaft to the framework. Set the shaft into the frame and align the bearings to the carriage bolts as shown in FIG. 3-2.
4. Tighten all fasteners, including the set screws for the sprockets.

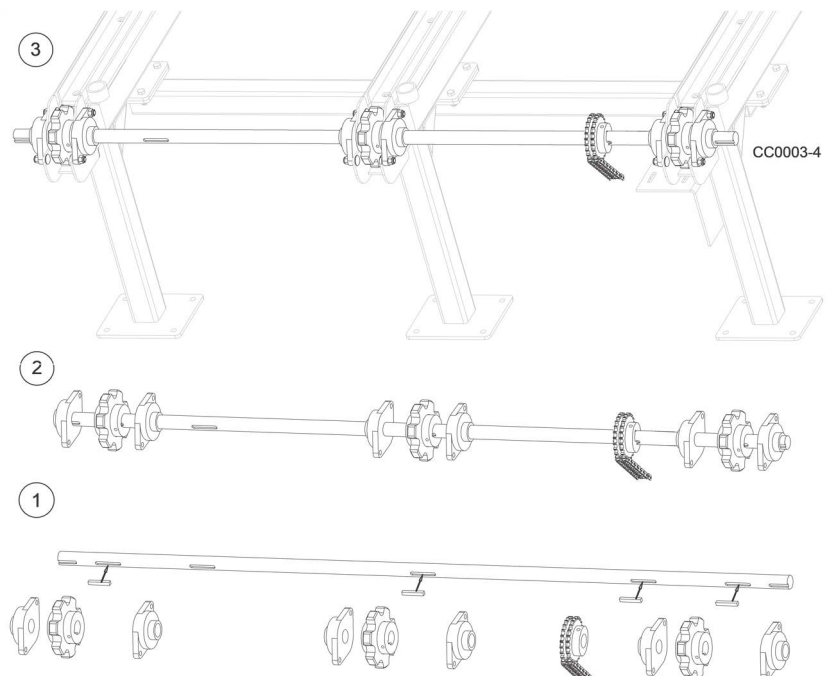


FIG. 3-2

MOTOR/GEARBOX ASSEMBLY

Prior to mounting, add 28 oz. of Mobil Glygoyle 460 Gear Oil and install the vent plug.

1. Mount the motor and gearbox to the frame with the fasteners as shown in FIG. 3-3. Be sure to include both the flat and lock washers. Do not tighten at this time.
2. Install the threaded rods, nuts, and washers to the gearbox assembly as shown in FIG. 3-3.
3. Put the chain guard over the threaded rods and nuts as shown in I above. Slip the spacers over the threaded rod. Align the lower sprocket key with the gearbox shaft and sprocket, and insert as shown in FIG. 3-3. Align the lower sprocket with the upper sprocket. Mount the drive chain on the two sprockets.

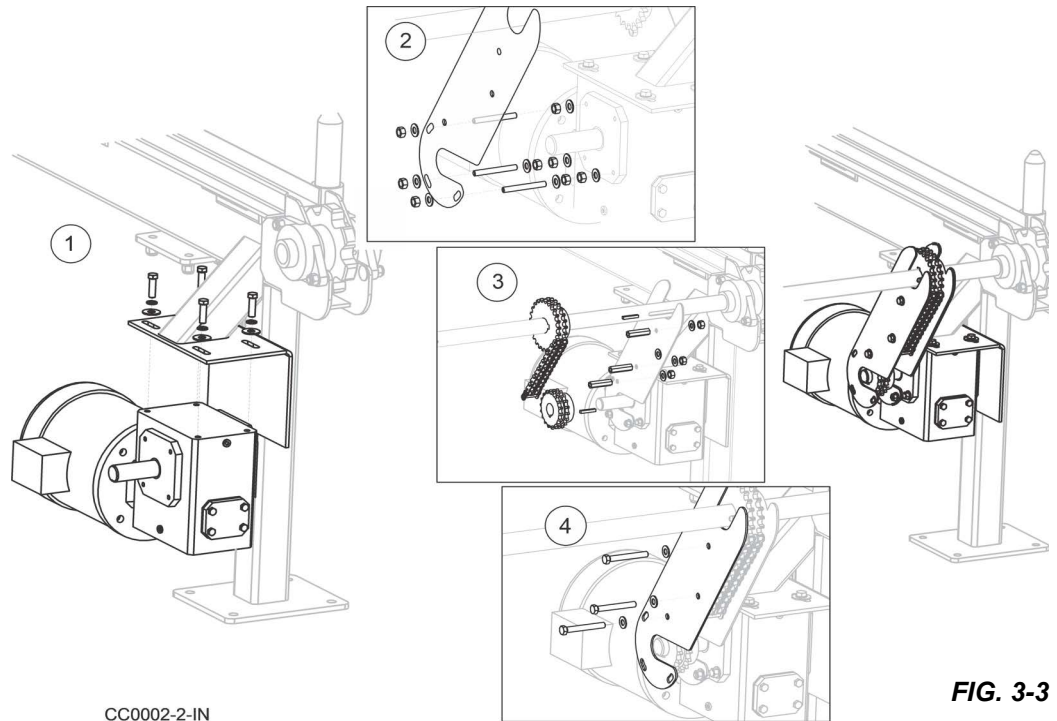


FIG. 3-3

4. Install the chain guard over the drive chain as shown in FIG. 3-3. Tension the drive chain by moving the gearbox assembly forward or back as needed. Tighten the gearbox mounting bolts when the drive chain has a moderate amount of tension. **Do not over tension, or damage to the gearbox or motor may occur.**

IDLE END TABLE ASSEMBLY

The idle end of the base unit comes pre-assembled from the factory. If the conveyor chain should need adjustment, [See Section 4.2](#) for information on the chain tensioning.

ELECTRICAL INSTALLATION



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.

Hazardous voltage inside the electric disconnect box, starter box, 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 operation.

Install a fused disconnect switch within sight of the machine. Typical minimum switch, fuse, and wire sizes are shown. All electrical installation must meet local electrical codes. Fuses are sized for short-circuit protection only.

3-Phase Volts	Fuse Disconnect	Time Delay Fuse	Suggested Wire Size
460 VAC	30 Amps	5 Amps	16AWG up to 50'

TABLE 3-1

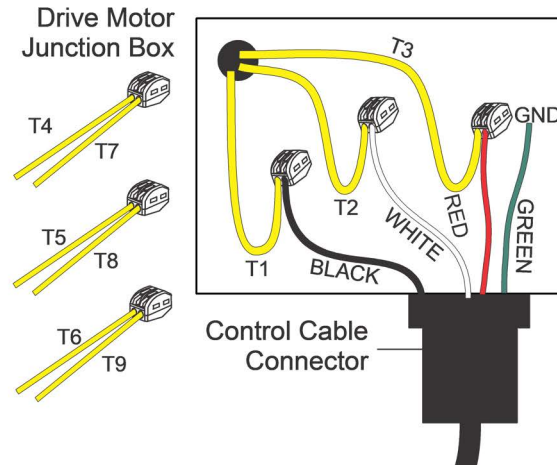
The electrical specifications are shown below.

Model	FLA of Largest Load	FLA	IR (AIC)	SCCR	Voltage	Hz	Phase
CC7-3.0C-3	2.7A	2.7A	15kA	25kA	460V	60	3

TABLE 3-2

The control box for the CC7 Chain Conveyor comes partially assembled from the factory. To install, perform the following steps:

1. Determine a mounting location convenient to your operation and secure the box to the frame. Use caution to ensure the control box and cable route are not subject to damage from moving parts or normal operation.
2. Open the enclosure of the box to mount the box. Retrieve the motor end cord grip connector, cord, wire connectors, and mounting clamp from inside the box. Replace the enclosure lid.
3. Open the conveyor motor junction box and remove a connector plug from the bottom of the motor junction box (if not previously removed). Install the cable cord grip connector to the motor junction box.
4. In the junction box, connect the green wire from the control cable to the ground motor wire or lug.
5. Connect the control cable's black wire to T1, the white wire to T2, and the red wire to T3 on the motor. (See Fig. 3-4)
6. Connect the remaining motor wire located in the junction box as follows with the terminals provided: T4 to wire T7, wire T5 to wire T8, and wire T6 to wire T9.
7. Replace and secure the cover to the motor junction box. Secure the control cable to the conveyor frame with the P07584 cable clamp, as necessary.



CC0011

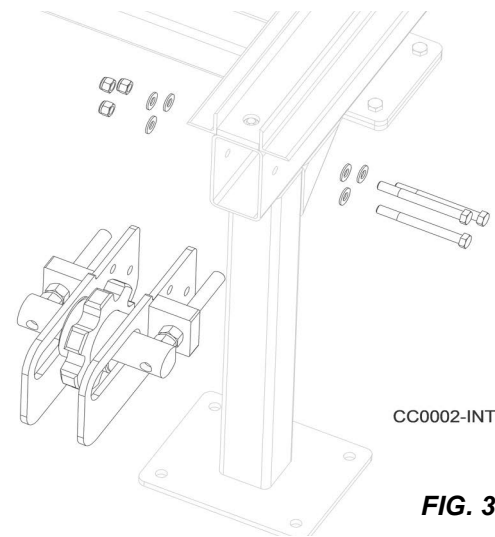
FIG. 3-4

LONG EXTENSION TABLE ASSEMBLY (OPTIONAL)



DANGER! Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death. To attach the optional long extension table, apply the following steps:

1. Disconnect the master link and remove the chain on the base unit table.
2. Remove the idle end assembly from the base unit by unbolting the three side bolts.
3. Remount the idle end assembly on to the extension rail with the three bolts.
4. With the fasteners from the extension kit, join the base unit rail with the extension rail.
5. Join the base unit chain to the extension kit chain with the master links.
6. Mount the full length chain on to the rails and adjust the tension. [See Section 4.2.](#)
7. Repeat for the other table rails, including extensions.
8. Install the extension's framing cross members in the same way as the base unit's. See FIG. 3-1.



CC0002-INT

FIG. 3-5

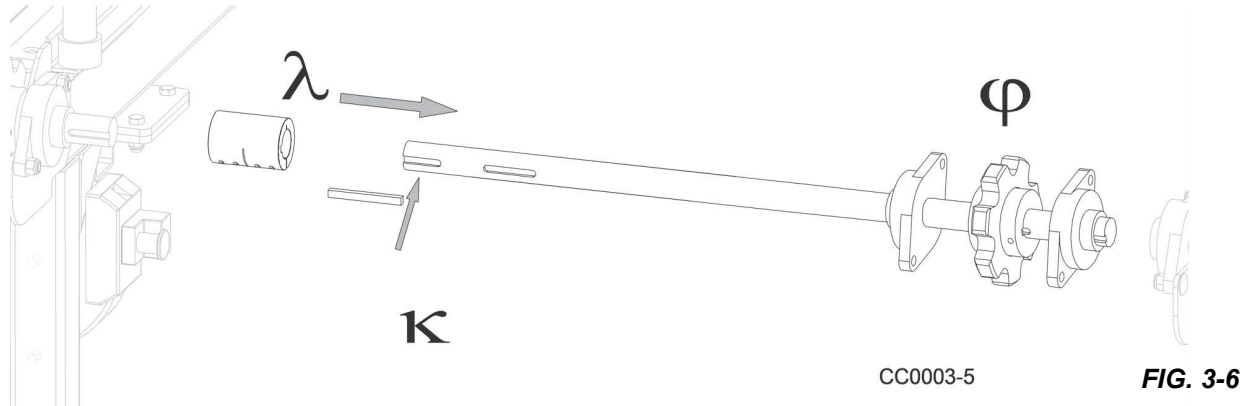
WIDE EXTENSION TABLE ASSEMBLY (OPTIONAL)



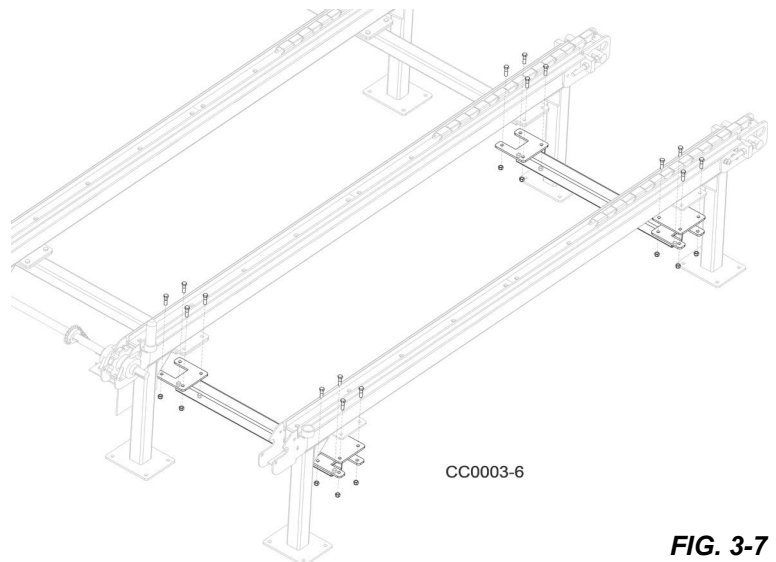
DANGER! Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death.

To attach the optional long extension table, apply the following steps:

1. Assemble the drive shaft extension as shown below.



2. Align the key in the sprocket and shaft, then slide the bearings on either side of the sprocket as shown in FIG. 1-6.
3. Align the key in the coupler and slide the coupler over the key as shown in FIG. 3-6.
4. Do not tighten the coupler at this time.
5. Align the extension rail with the base unit. Use the longer bolts that come with the extension kit.
6. Attach the framing cross members as shown in FIG. 3-7.
7. Install the carriage bolts for the bearings on the frame prior to installing the assemble shaft to the framework.
8. Set the shaft into the frame and align the bearings to the carriage bolts.
9. Tighten all fasteners, including the set screws for the sprockets.
10. Connect the conveyor chain. [See Section 4.2](#) for more information on tensioning the chain.



LONG/WIDE EXTENSION TABLE ASSEMBLY (OPTIONAL)

The long/wide extension is used when both the long and the wide extension are ordered.

Follow the installation instructions for the long extension table, using the wide extension table rail instead of the base unit table rail.

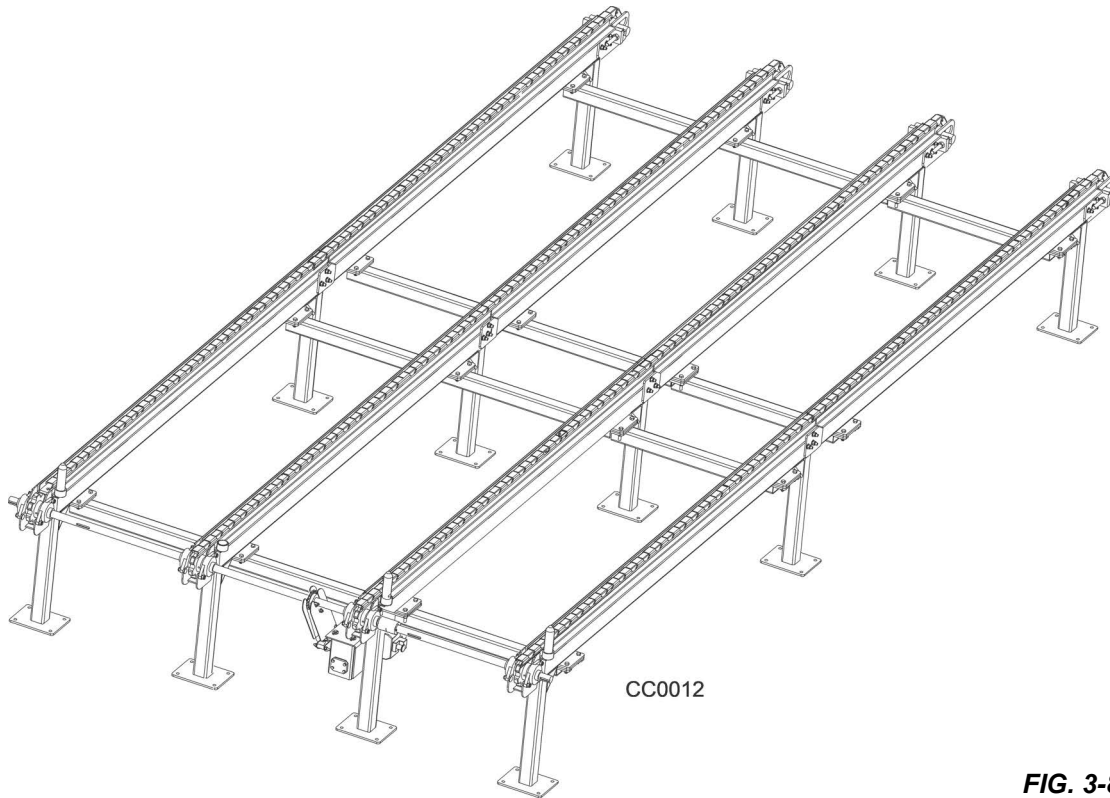


FIG. 3-8

SECTION 4 MAINTENANCE



DANGER! Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc.

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.

Wear proper and necessary safety equipment (eye, breathing, hand, and foot protection) when performing service functions.

4.1 Gearbox Oil

Check the gearbox oil level. Add a synthetic gear oil Mobil Glygoyle 460 PAG as needed.

Other gear oils may not be compatible with Mobil Glygoyle 460.

4.2 Tensioning the Chains

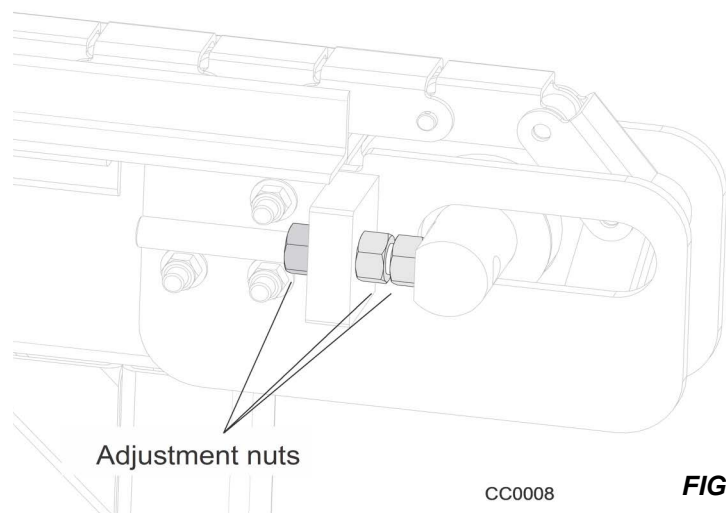
DANGER! Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death.

Adjust the conveyor chain tension as needed.

1. Loosen the chain enough to raise it approximately 3 inches off of the chain channel.
2. Locate the adjustment nuts at the idle end of the table.
3. Use the adjustment nuts on both sides of the sprocket assembly to adjust the chain tension.



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



CC0008

FIG. 4-1

Periodically check the motor drive chain tension and adjust the as needed. The chain needs to be adjusted if the chain slack exceeds 1/2" (12.7mm).

1. Disconnect power to the motor.
2. Loosen the four fasteners securing the drive chain guard as shown below.
3. Remove the guard from the conveyor and check the drive chain tension.

To adjust the motor drive chain tension (if necessary):

1. Disconnect power to the motor.
2. Loosen the mount bolts securing the gearbox to the conveyor frame.
3. Move the gearbox and motor assembly to adjust the drive chain.



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

4. After the drive chain has been adjusted, tighten the gearbox mount bolts.
5. Reinstall the drive chain guard and secure in place with the guard mounting fasteners.

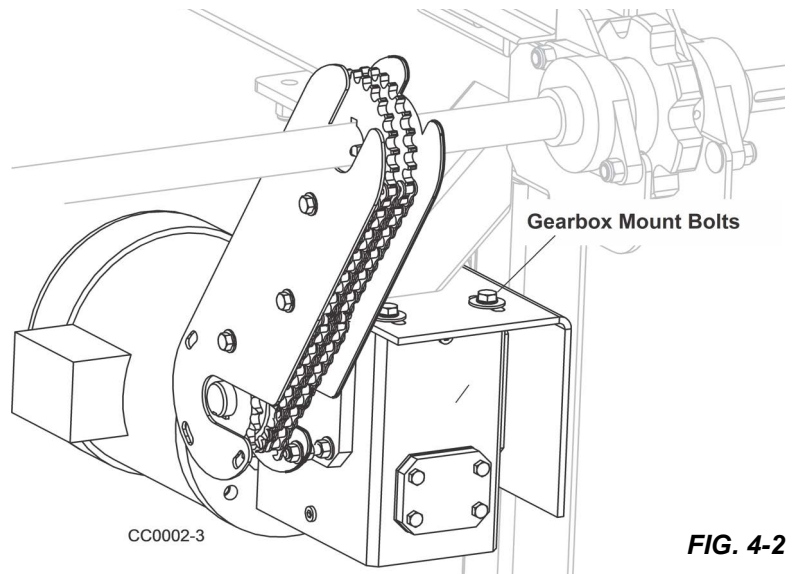


FIG. 4-2

4.3 Lubrication

Lubricate the drive end bearings every **200 hours** of operation with one to two pumps of lithium-based grease such as Shell Alvania No. 3. Do not overgrease.

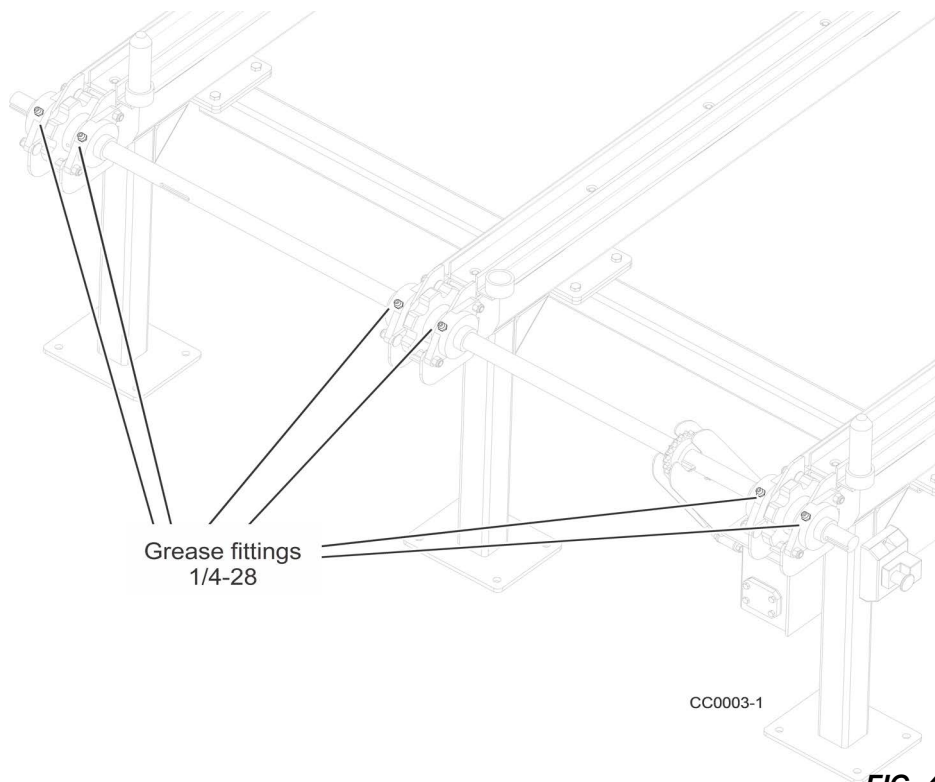


FIG. 4-3

SECTION 5 REPLACEMENT PARTS

5.1 How To Use The Parts List

- Use the table of contents to locate the assembly that contains the part you need.
- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.

To Order Parts

- From the continental US, call **1-800-525-8100** to order parts. 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.

5.2 Sample Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	012345	SAMPLE ASSEMBLY, COMPLETE	INCLUDES ITEMS 1-6	1
1	F02222-22	Sample Part		1
2	F03333-33	Sample Part		2
	098765	Sample Subassembly	Includes items 3-6	1
3	S04444-44	Subassembly Sample Part		1
4	K55555	Subassembly Sample Part		1
	054321	Sample Sub-Subassembly	Includes items 5-6	2
5	022222	Sub-Subassembly Sample Part		1
6	F10234-56	Sub-Subassembly Sample Part		1

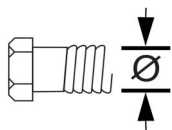
The Sample Assembly, Complete, part number 02345 (top level assembly) includes two parts (F0222-22 and F0333-33) and the 098765 subassembly.

Subassembly 098765 contains two parts(S04444-44 and K55555) and two copies of sub-subassembly 054321.

Each sub-subassembly 054321 contains two parts (022222 and F10234-56).

5.3 Torque Values

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



Metric Bolt Head Identification



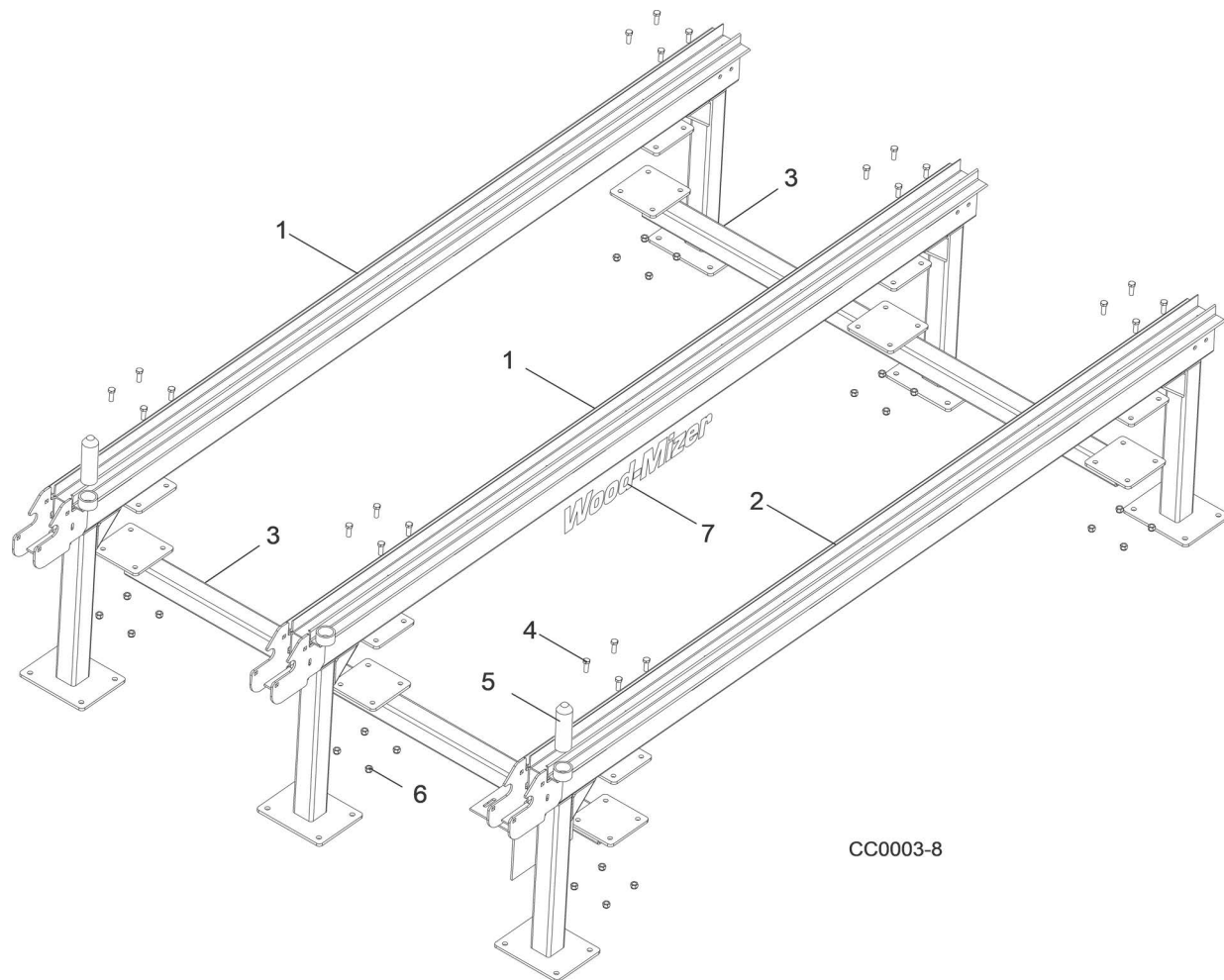
8.8
Metric Grade 8.8



10.9
Metric Grade 10.9

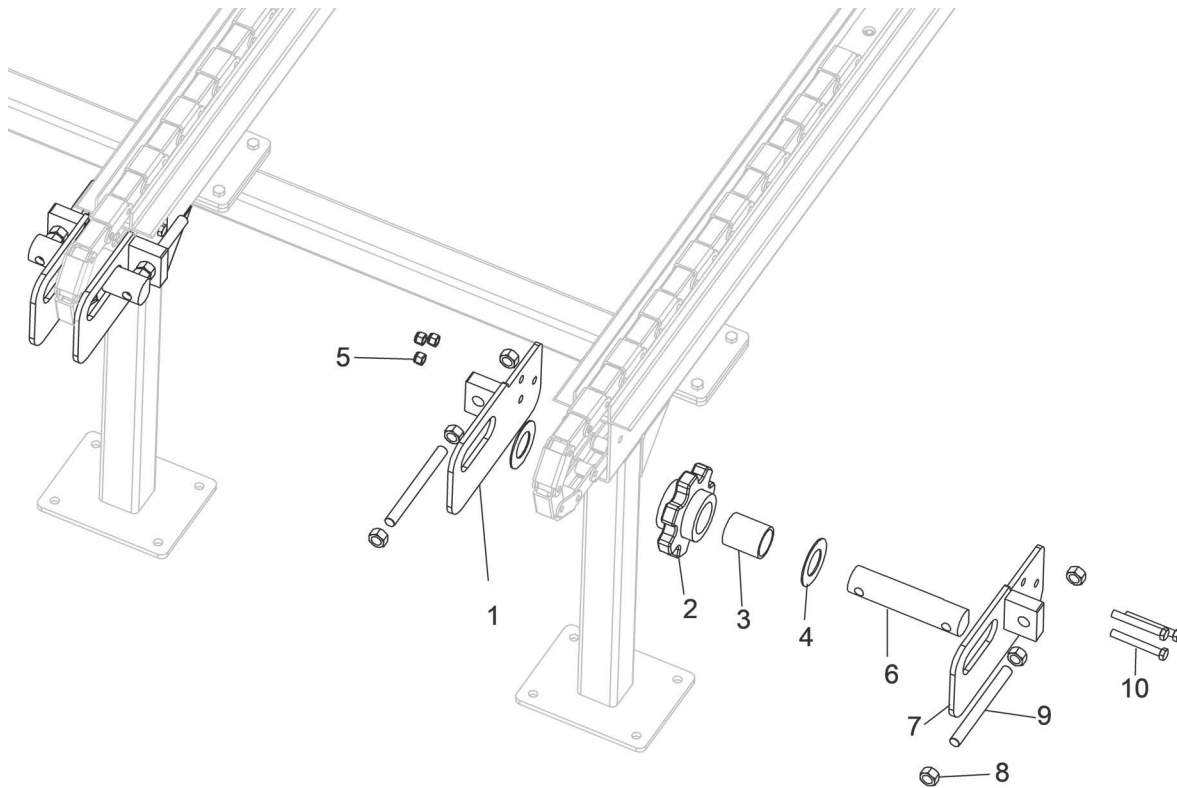
COARSE THREAD					FINE THREAD				Wrench Size	
Diameter & Thread Pitch	Metric 8.8		Metric 10.9		Diameter & Thread Pitch	Metric 8.8		Metric 10.9		
	N-m	lbs-ft	N-m	lbs-ft		N-m	lbs-ft	N-m		lbs-ft
6 x 1.0	8	6	11	8						10 mm
8 x 1.25	20	15	27	20	8 x 1.0	21	16	29	22	13 mm
10 x 1.5	39	29	54	40	10 x 1.25	41	30	57	42	16 mm
12 x 1.75	68	50	94	70	12 x 1.25	75	55	103	76	18 mm
14 x 2.0	109	80	151	111	14 x 1.5	118	87	163	120	21 mm
16 x 2.0	169	125	234	173	16 x 1.5	181	133	250	184	24 mm
18 x 2.5	234	172	323	239	18 x 1.5	263	194	363	268	27 mm
20 x 2.5	330	244	457	337	20 x 1.5	367	270	507	374	30 mm
22 x 2.5	451	332	623	460	22 x 1.5	495	365	684	505	34 mm
24 x 3.0	571	421	790	583	24 x 2.0	623	459	861	635	36 mm
30 x 3.0	1175	867	1626	1199	30 x 2.0	1258	928	1740	1283	46 mm

5.4 Framework



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	071117	Tube Green Chain weldment		2
2	076058	End Tube Green Chain Drive weldment		1
3	071135	Rail Mount Green Chain weldment		2
4	F05008-33	Bolt, 1/2-13 x 1 1/2" Hex Head Grade 5		24
5	039065	Pin, Board Pivot		2
6	F05010-8	Nut, 1/2-13 Nylok Hex		24
7	065034	Decal, 20.5" White Wood-Mizer Logo		2

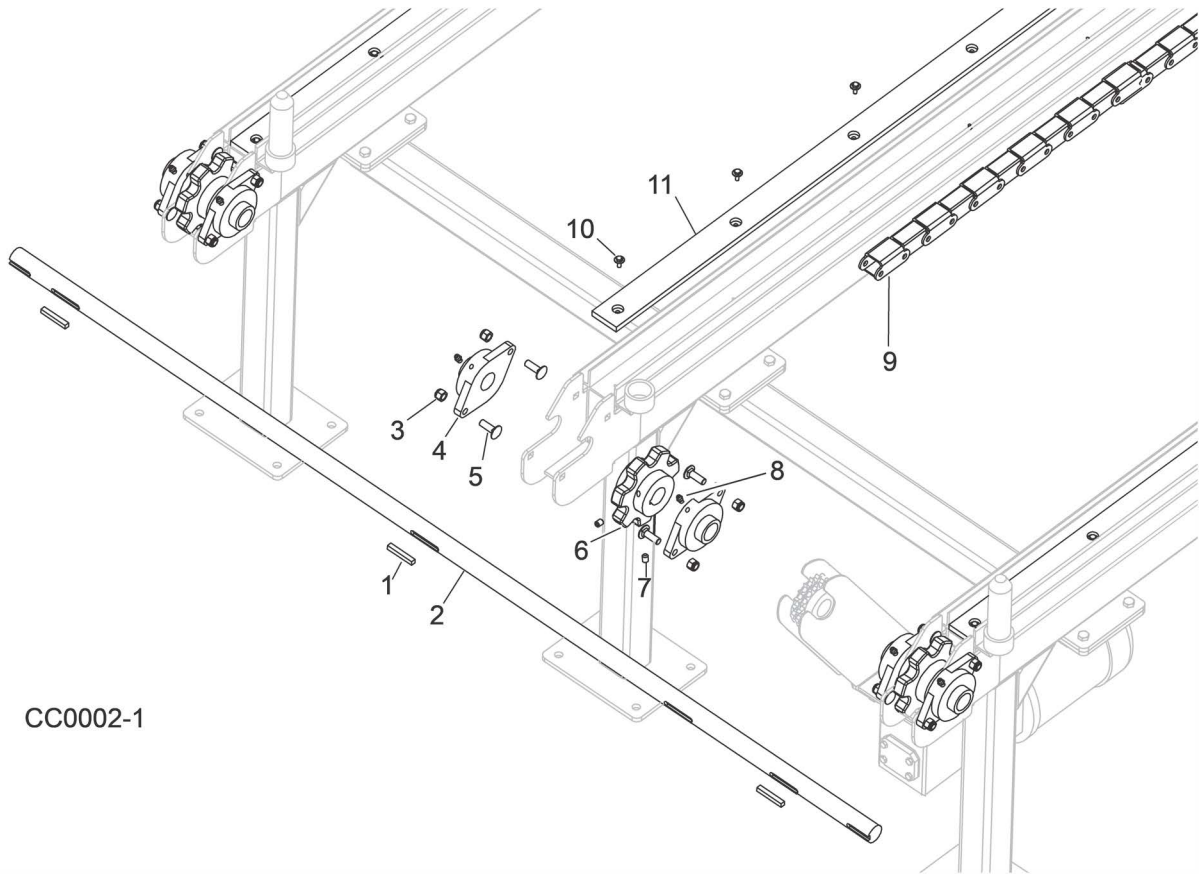
5.5 Idler End Assembly



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REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	076070	Right Green Chain Idler Weldment		3
	076067	Green Chain Idler Sprocket Assembly		3
2	076072	Bushing, Bronze 1-15/16 x 2-5/16 x 2-3/4		3
3	071114	Green Chain Idler Sprocket Weldment		3
4	033735	Washer, 1.95" ID x 4" OD x .075"		6
5	F05010-8	Nut, 1/2-13 Hex Nylock		9
6	033718	Shaft, Chain Idler		3
7	076069	Left Green Chain Idler Weldment		3
8	F05010-92	Nut, 3/4-16 Hex		18
9	017642	Stud, 3/4-16 x 7 3/4"		6
10	F05008-66	Bolt, 1/2-13 x 5" Hex Head Grade 5		9

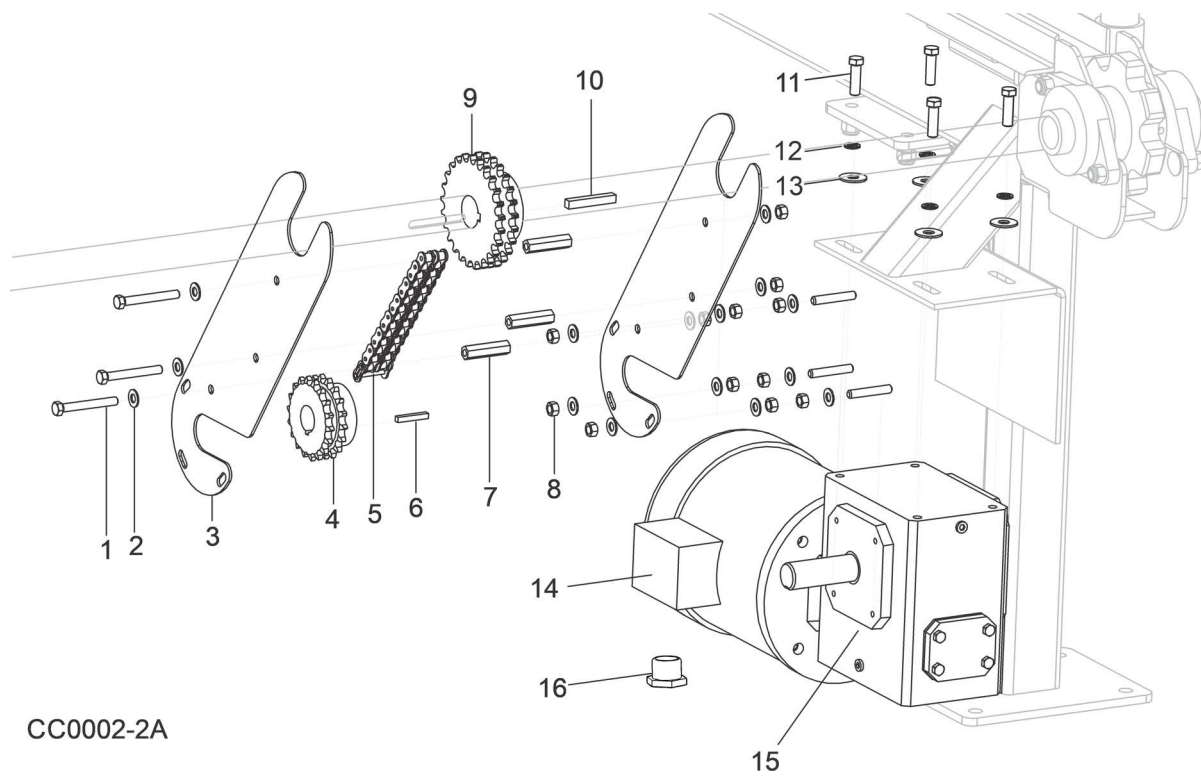
5.6 Drive End Table Assembly



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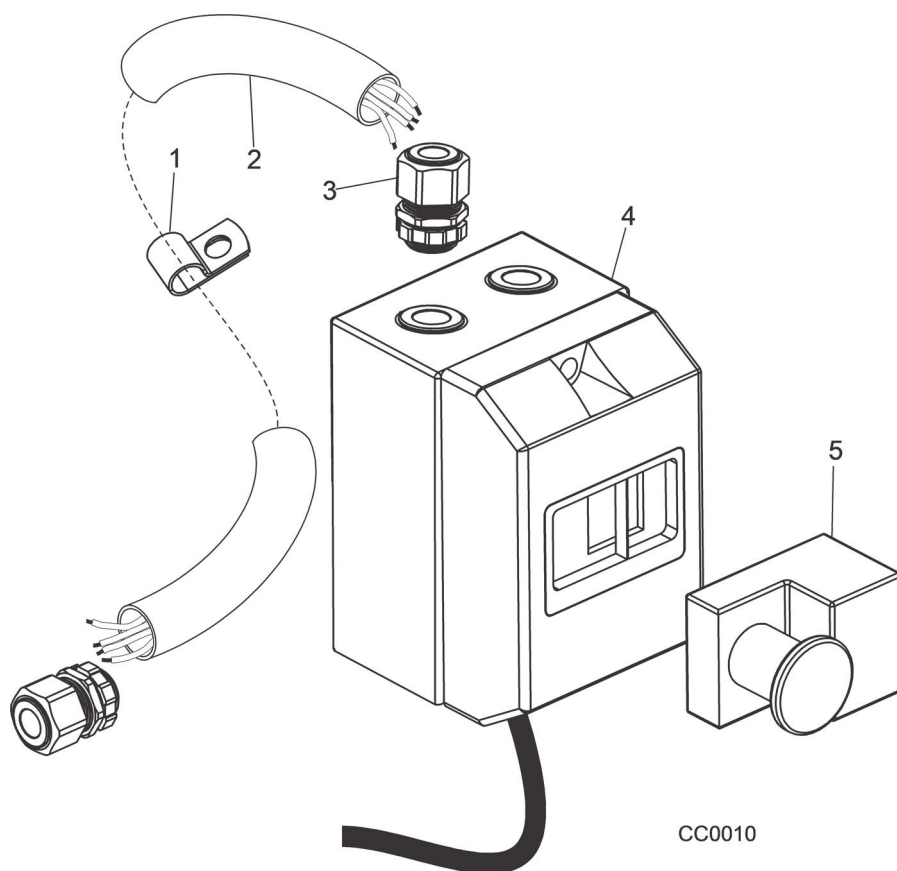
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	039380	Key, 3/8" Square x 2 1/2"		3
2	071134	Shaft, 1-1/2" Green Chain		1
3	F05010-8	Nut, 1/2-13 Hex Nylock		12
4	064719	Bearing, VF2S-224		6
5	F05008-150	Bolt, 1/2-13 x 1 1/2" Carriage, Zinc		12
6	071132	Sprocket Driver Green Chain weldment		3
7	F05007-12	SCREW, 3/8-16 X 1/2" SOCKET HEAD CUP PoINT, B/O		6
8	P05060	Fitting, 1/4-28 Grease		6
9	071108	Chain, 81X Rooftop Wood Conveying w/Master Link		3
	071109	Link, Master Chain, 81X-RT 271 Inch (103		1
10	F05005-207	Bolt, 1/4-20 x 3/4" Hex Head w/Washer&Patch		30
11	071126	Channel, UHMW Conveyor		6

5.7 Drive Motor Assembly



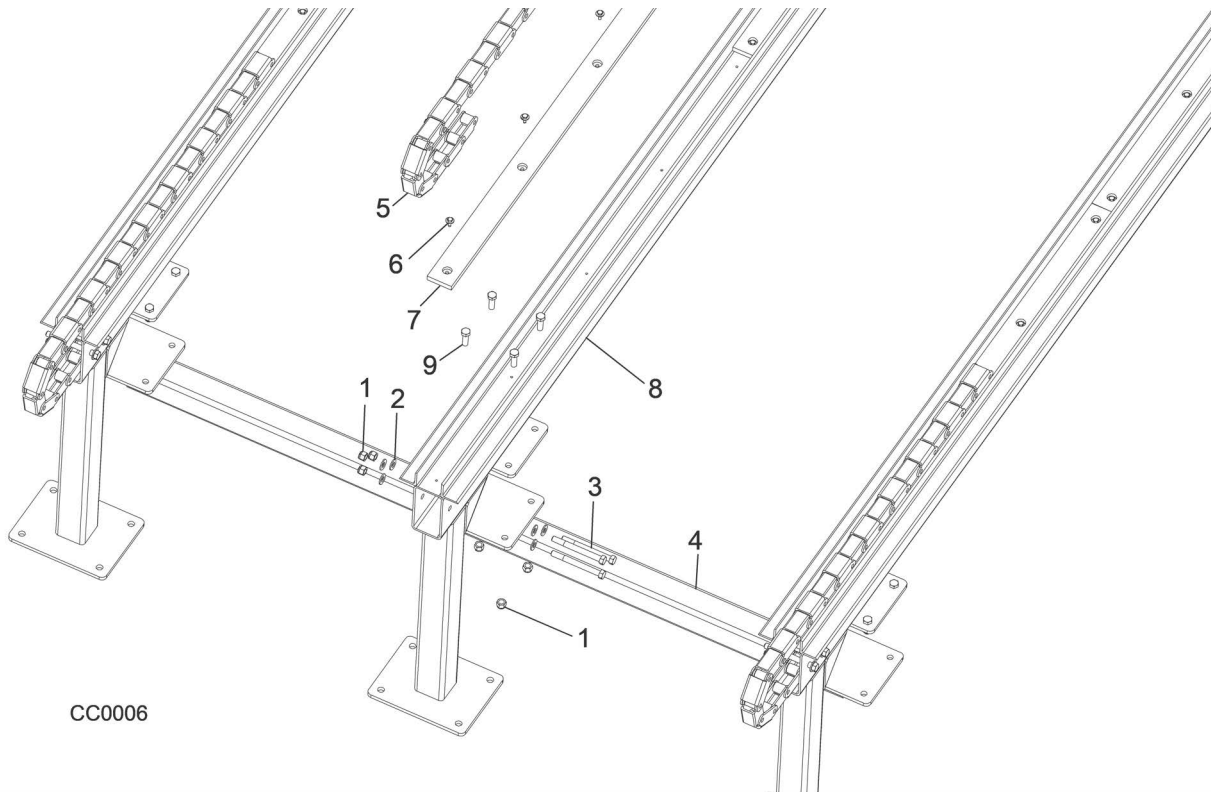
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05007-1	BOLT, 3/8-16X3 HH FULL THRD, ZN		3
2	F05011-3	Washer, 3/8" Flat SAE		11
3	076066	Plate, Green Chain Guard		2
4	074283	Sprocket, D50B18Hx1-1/4 Bore		1
5	038543	Chain, Double 50x40-5/8, 65 Pitches		1
	015258	Link, #50-2 Master		1
6	042810	Key, 1/4Sq x 1 5/8		1
7	074272	Hex, 9/16x2-1/4 Spacer, Threaded		3
8	F05010-1	Nut, 3/8-16 Hex		11
9	074284	Sprocket, D50B25Hx1-1/2 Bore		1
10	039380	Key, 3/8 Sq x 2-1/2"		1
11	F05007-138	Bolt, 7/16-14 x 1-1/2" Hex Head FT Grade 5		4
12	F05011-48	Washer, 7/16" Split Lock		4
13	F05011-35	Washer, 7/16" Standard Flat		4
	065415	Motor/Gearbox Assy, 1.5HP x 50:1 GC		1
14	065413	Motor. Leeson G132249.00 1.5 Hp 182T		1
15	065414	Gearbox, 50:1 Grove GR8300261		1
16	038742	Bushing, 3/4MNPT-1/2FNPT Pipe	Added after 9/8/2022 per ECN 38709	1

5.8 Control Box



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	068224	Control Box, 1.5HP Motor Starter 3-phase		1
1	P07584	Clamp, 1/2" EMT Coated		1
2	068225	Cable Assy, 1.5HP Motor 15' 3Ph 16AWG		1
3	069753	Connector, M20 0.17-0.45 Cord Grip		2
4	069399	Enclosure, GV2 Manual Motor Starter		1
5	069400	E-Stop Button Kit, GV2		1
	MBGV2ME08	Motor Starter, Manual 2.5-4A Protector		1
	052293-2	Junction Block, 2-Position Wire Clamp (not shown)		6

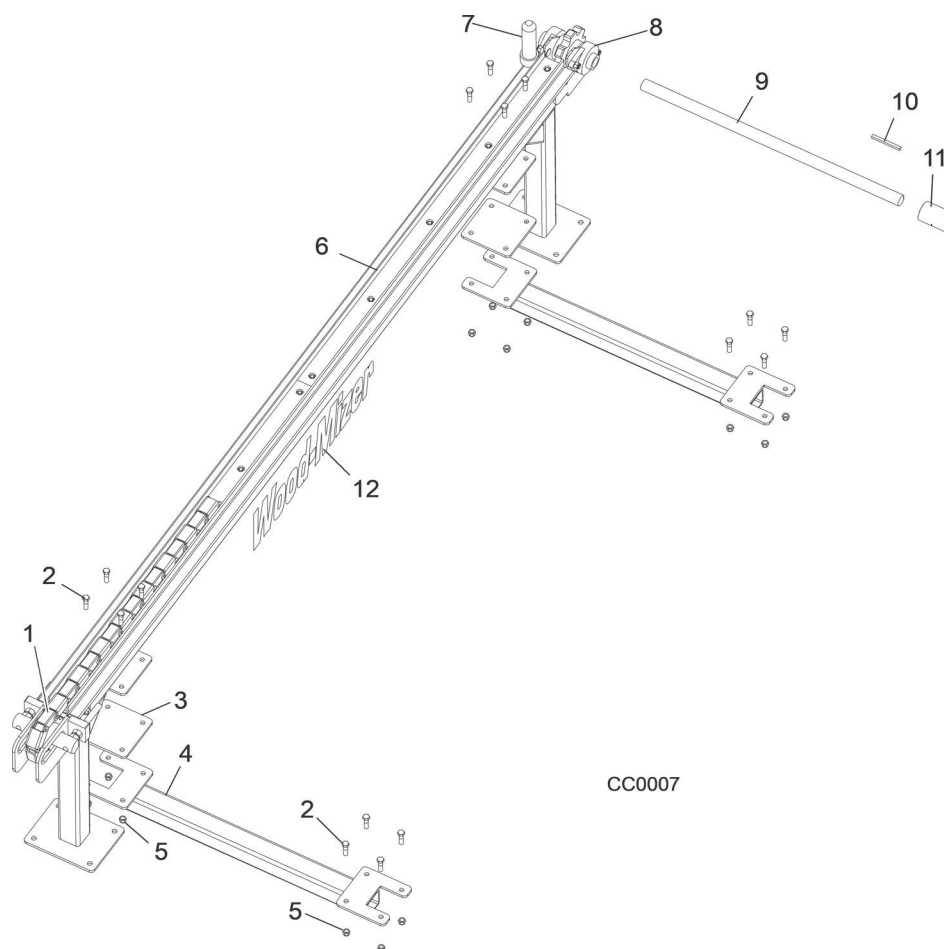
5.9 Long Extension Table Assembly



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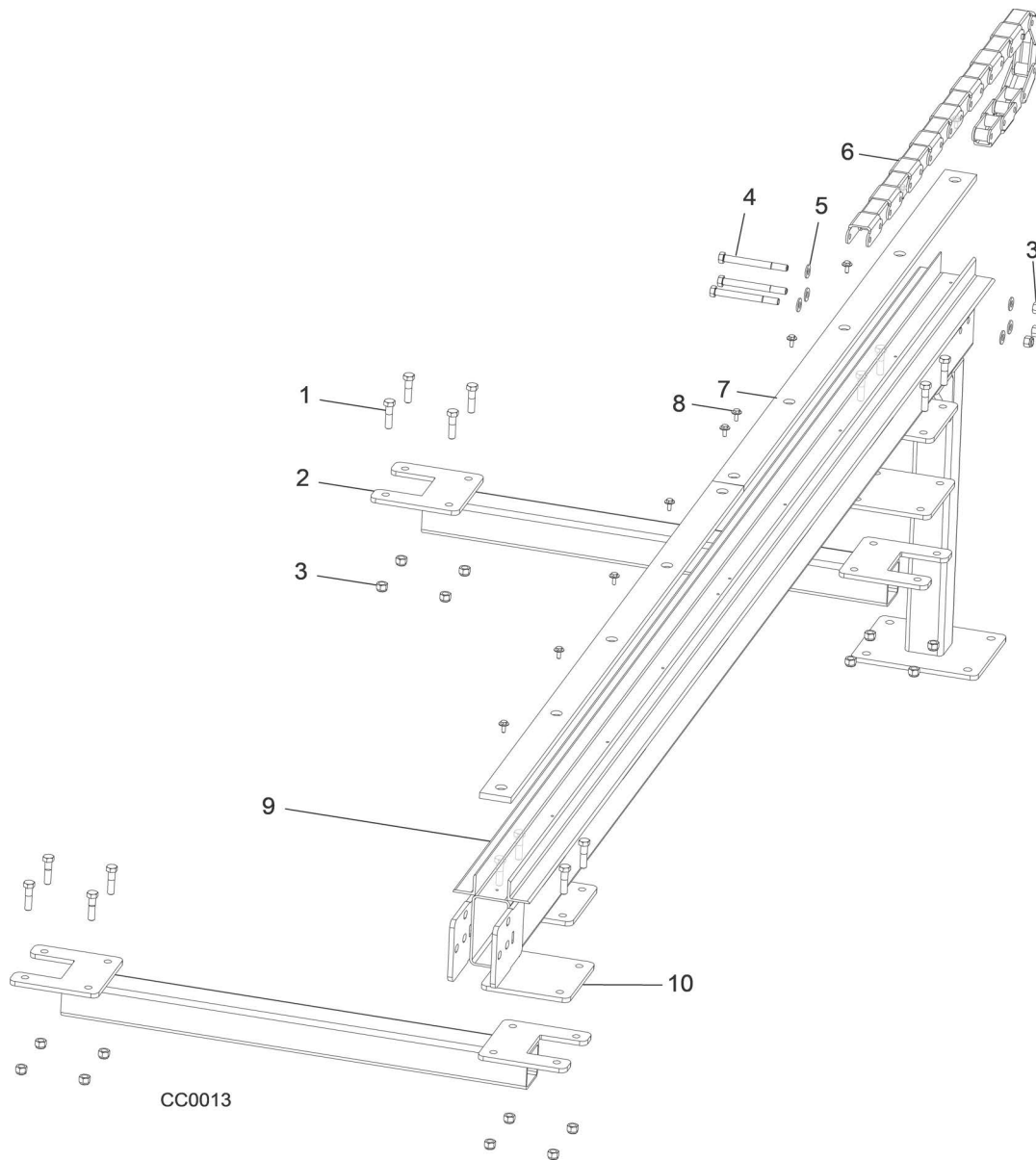
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	071141	TABLE ASSEMBLY, Long		1
1	F05010-8	Nut, 1/2-13 Nylok Hex		33
2	F05011-2	Washer, 1/2" SAE Flat		18
3	F05008-66	Bolt, 1/2-13 x 5" Hex Head Grade 5		9
4	071135	Rail Mount Green Chain Weldment		2
5	074128	Chain, 81 XRT Conveying Extension		3
	076059	Extension Green Chain Rail Assembly		3
6	F05005-207	Bolt, 1/4-20 x 3/4" Hex Head w/Washer&Patch		10
7	071126	Channel, UHMW Conveyor		2
8	071139	Green Chain Tube Weldment		1
9	F05008-33	Bolt, 1/2-13 x 1 1/2" Hex Head Grade 5		24

5.10 Wide Extension Table Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	076063	TABLE ASSEMBLY, Wide		1
1		Idle End Assembly (See Section 5.5)		
2	F05008-102	Bolt, 1/2-13 x 2" Hex Head Grade 5		16
3	071125	Plate, Bracket Deck Attachment		2
4	076061	Weldment, Green Chain Rail Add-On		2
5	F05010-8	Nut, 1/2-13 Hex Lock		16
6	071117	Tube Green Chain Weldment		1
7	039065	Pin, Board Pivot		1
8		Drive End Table Assembly (See Section 5.6)		
9	076065	Shaft, 1-1/2 Green Chain Extension		1
10	076077	Key, 3/8" Square x 4"		1
11	076076	Coupling, 1-1/2" Dia Shaft		1
12	065034	Decal, 20.5" White Wood-Mizer Logo		2

5.11 Long/Wide Extension Table Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	076064	Rail Assy, Extension Add Green Chain		1
1	F05008-102	Bolt, 1/2-13 x 2" Hex Head Grade 5		16
2	076061	Weldment, Green Chain Rail Add-On		2
3	F05010-8	Nut, 1/2-13 Nylok Hex		19
4	F05008-66	Bolt, 1/2-13 x 5" Hex Head Grade 5		3
5	F05011-2	Washer, 1/2" SAE Flat		2
6	074128	Chain, 81XRT Conveying Extension		1
	076059	Rail Assy, Extension Green Chain		1
7	071126	Channel, UHMW Conveyor		2
8	F05005-207	Bolt, 1/4-20 x 3/4" Hex Head w/Washer & Patch		10
9	071139	Tube, Weldment Green Chain		1
10	071125	Plate, Bracket Deck Attachment		2