

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

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**Chain Conveyor (GC1)      rev. A1.00**

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***Safety is our #1 concern!***

*Form #1762*

**Models Effected:**

GC1, Conveyor, Cross Transfer Chain Base 20

GC1-EXT, Conveyor, Green Chain Ext 10'



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

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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, Kilns	MP, MD, KS, KD	One year	One year	
Slab Flatteners	MB	Two years	One year	
Pallet Equipment	PD, PC	One year	One year	
Log Splitters	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

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

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

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

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

**Five Year Limited Chassis Warranty**

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

**Warrantor’s Obligations as To Defects**

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

**Limitations and Disclaimers of Other Warranties**

EXCEPT FOR THE EXPRESS WARRANTY PROVISIONS STATED ABOVE, WARRANTOR DISCLAIMS ALL WARRANTIES, EXPRESS AND/OR IMPLIED, INCLUDING WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NONINFRINGEMENT 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**

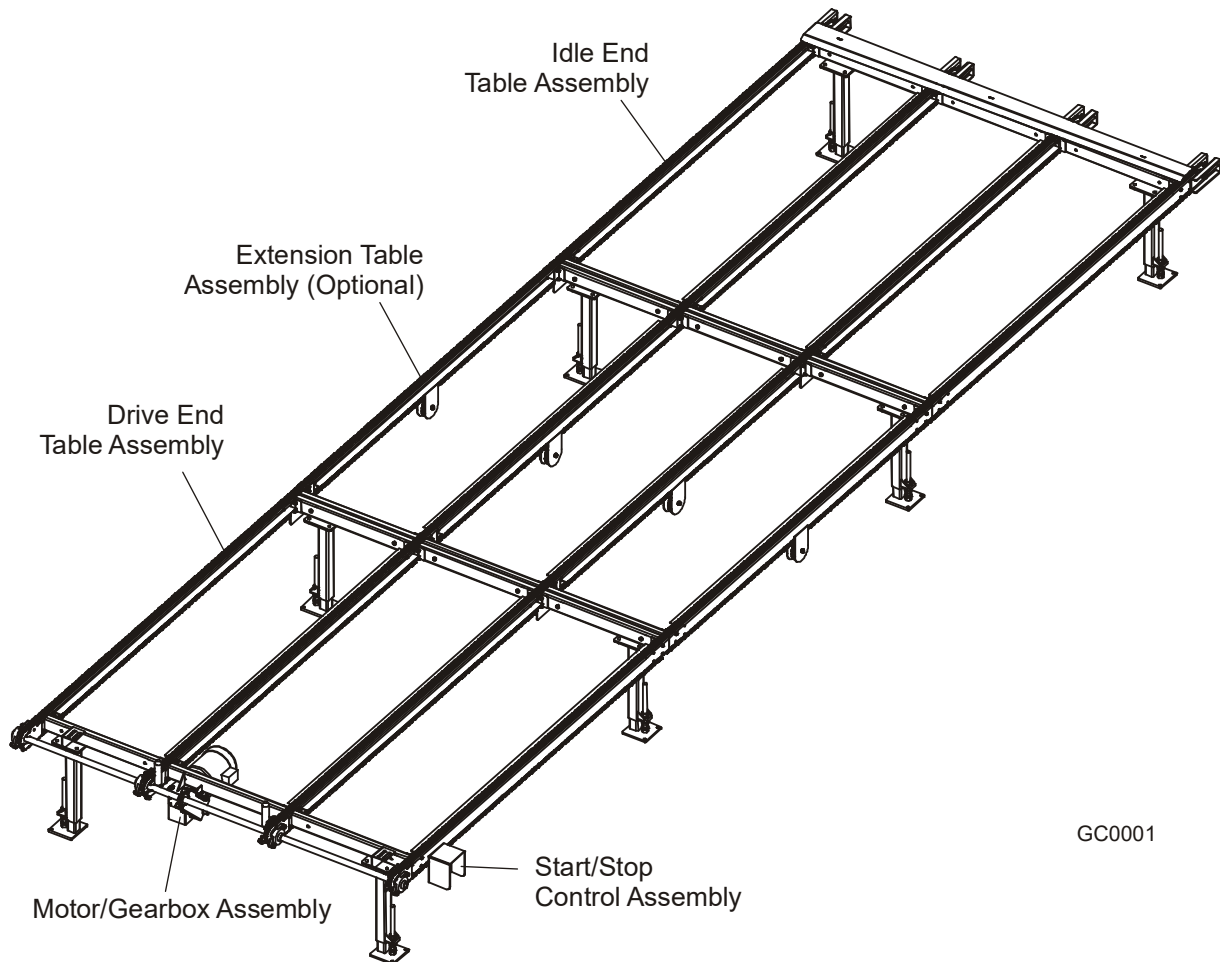
This Warranty constitutes the entire warranty agreement between Warrantor and Purchaser and supersedes any prior understandings or agreements pertaining to the same subject matter. This warranty cannot be amended except in writing which refers to this warranty which is signed by both Warrantor and Purchaser.

## SECTION 1 INTRODUCTION

### 1.1 About This Manual

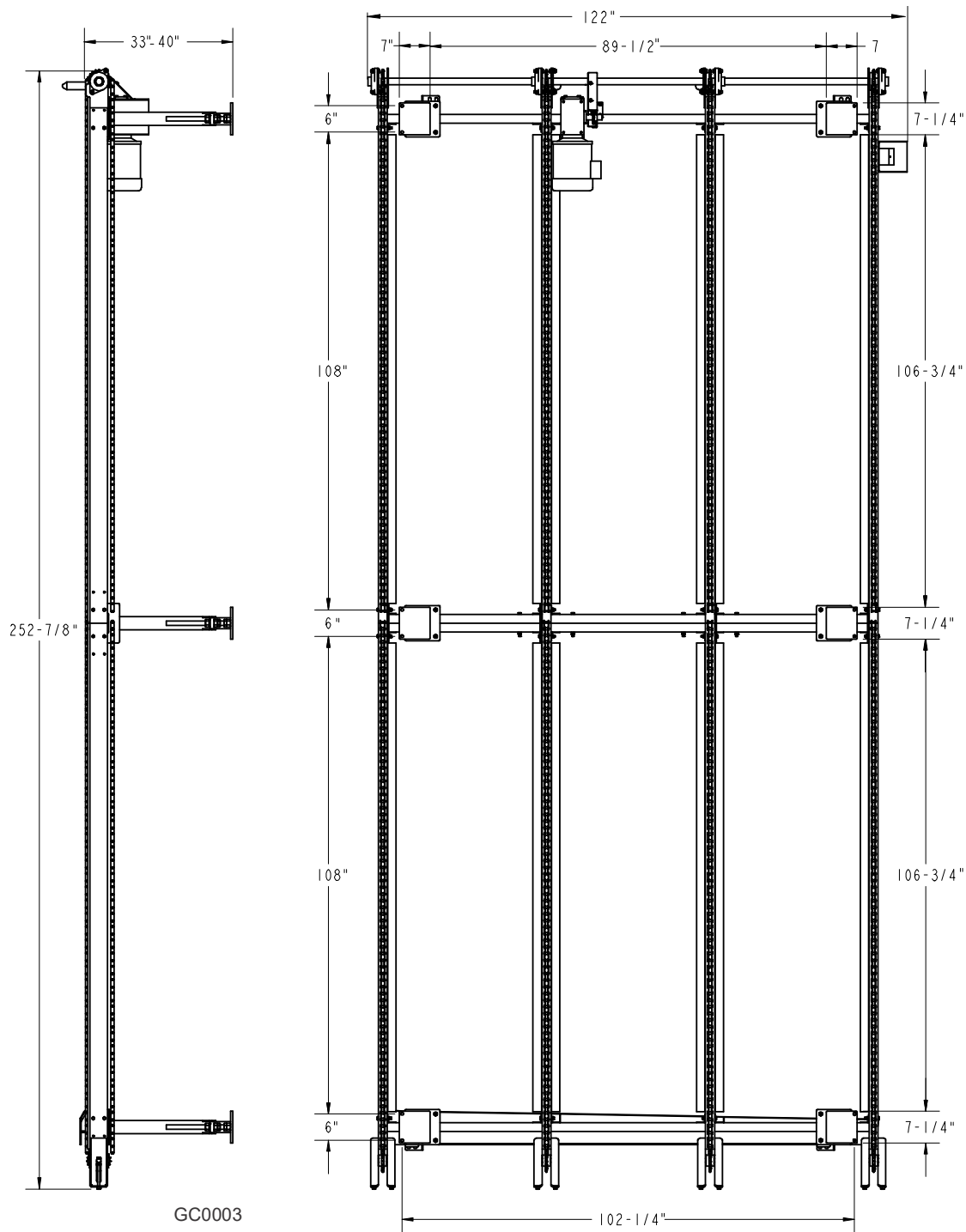
This manual is to replace or to be used with all previous information received concerning the GC conveyor. All future mailings will be an addition to or a revision of individual sections of this manual as we obtain new information.

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.



GC0001

## 1.2 Dimensions



**CONVEYOR DIMENSIONS**



## 1.3 Specifications

### Model: GC Conveyor Rev. A1.00

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#### Dimensions

Length: 21'-7/8"  
Length w/Extension Table: 30'-11 7/8"  
Width: 10'-2"  
Height: 38"

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#### Weight:

Basic Unit: lbs.

#### Capacity:

Board/Slab Length: 4' to 12'

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#### Motor:

Manufacturer: Leeson  
Horsepower Rating: 1.5  
RPM:

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#### Rates:

Normal Power Usage:  
Chain Speed: ft./min.

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#### Electrical Requirements:

Electrical Service: 460V 3-Phase 50/60Hz 10A  
Suggested Wire Size (50' max.): AWG

### GC 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.



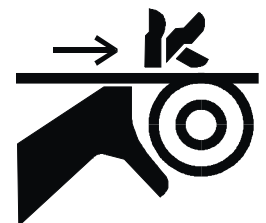
### KEEP PERSONS AWAY

 **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	

### MAINTENANCE HAZARDS INCLUDE:

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

### FAILURE TO LOCKOUT MAY RESULT IN:

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

### 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

#### Drive End Table 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.

1. Assemble the provided drive end table rails as shown in FIG 3-1.
2. Use the fasteners to secure the rails in place as shown in FIG 3-1.
3. Install the leg assemblies to the drive end table. **See Fig. 3-2.**

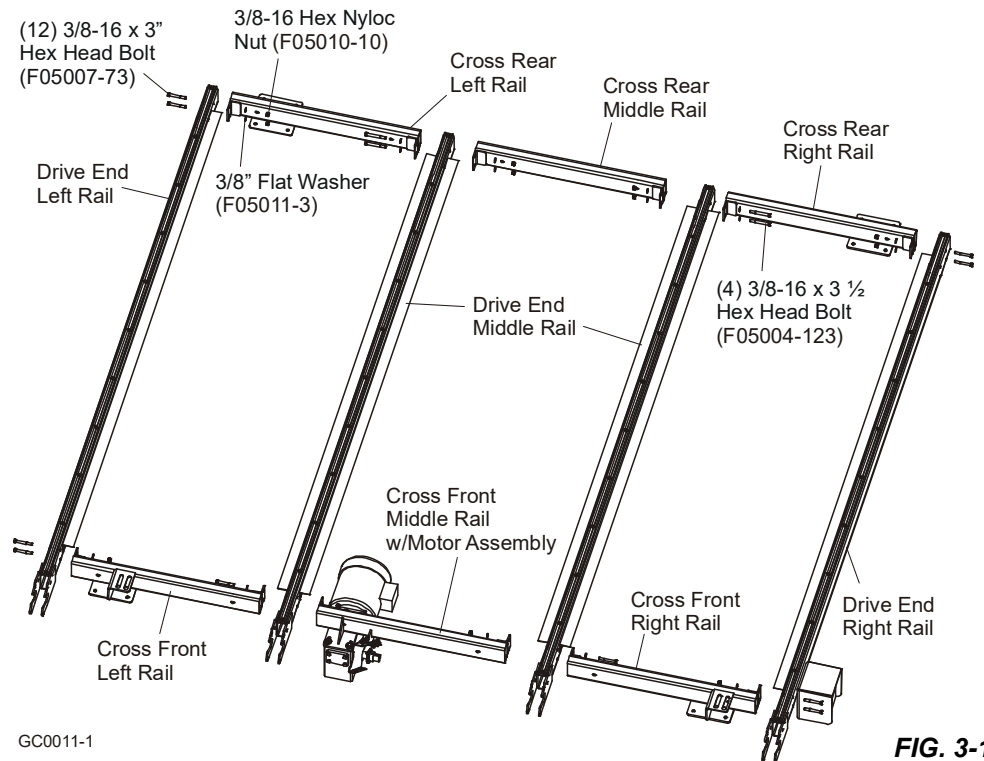


FIG. 3-1

4. Use the hex head bolts and nylon hex lock nuts to secure the legs in place.
5. Install the drive shaft with the sprockets and bearings to the drive end table as shown in FIG.3-3.
6. Adjust the distance between the sprockets and bearings on the drive shaft to install the drive shaft to the frame, if necessary.

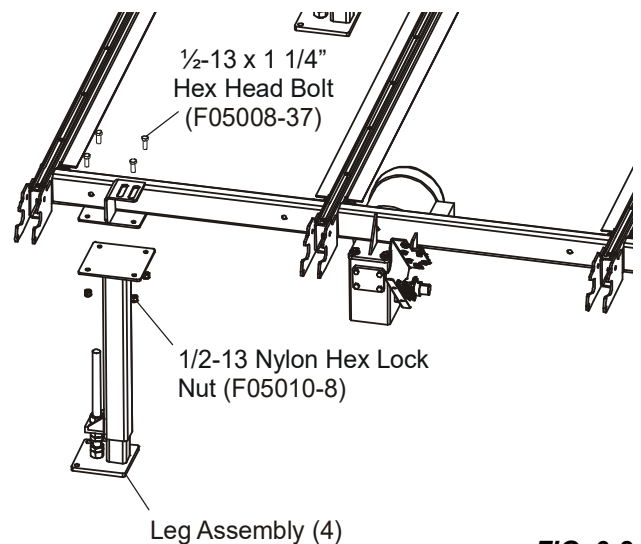
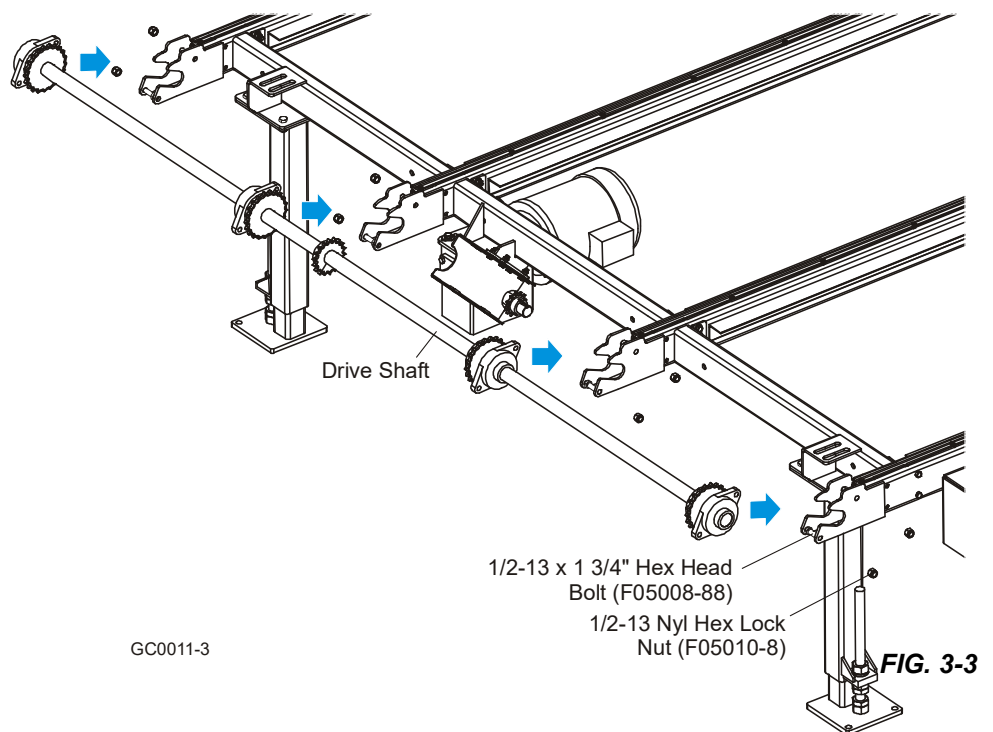
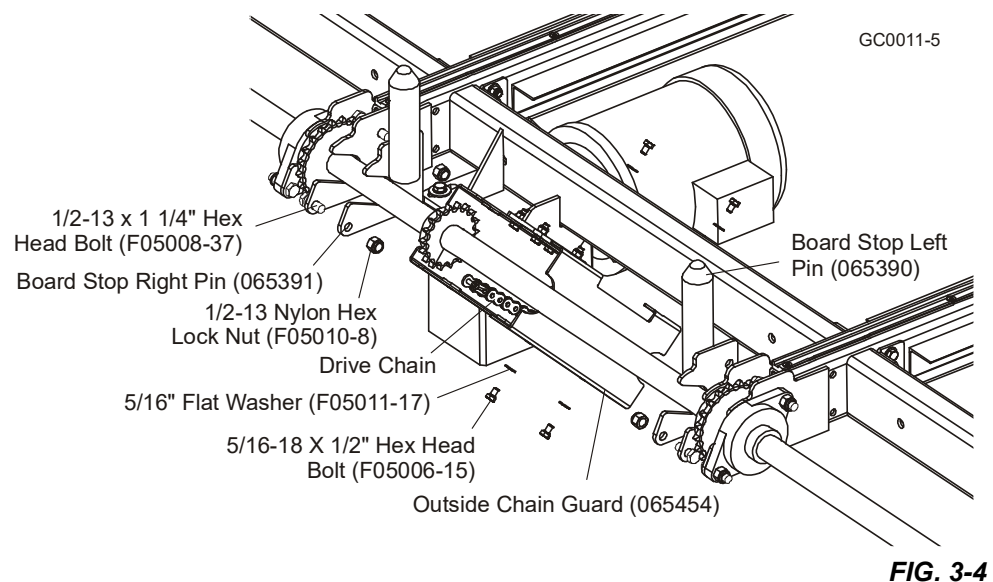


FIG. 3-2

7. Use the provided hex head bolts and nylon hex lock nuts to secure the bearings on the drive shaft to the conveyor frame. See Fig. 3-3.

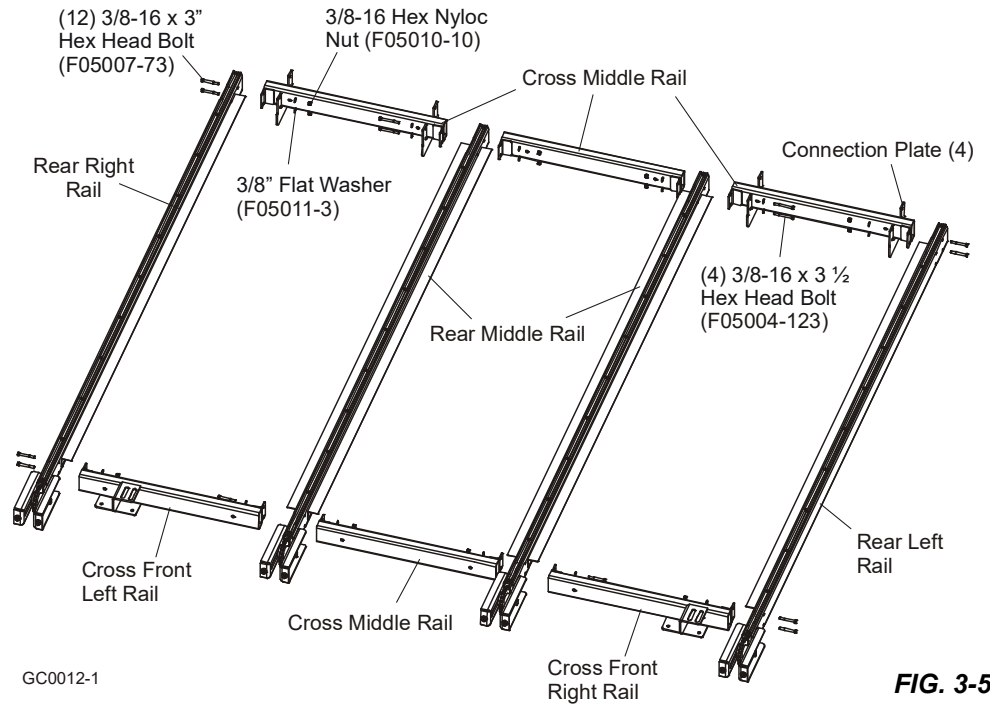


8. Install the board stop left and right pins to the conveyor frame. See Fig. 3-4.
9. Use the hex head bolts and nylon hex lock nuts to secure the board stop pins in place.
10. Install the drive chain to the motor assembly. See Section 4.2 for more information on the chain tensioning.
11. Install the outside chain guard to the motor assembly.
12. Use the provided hex head bolts and flat washers to secure the chain guard in place.



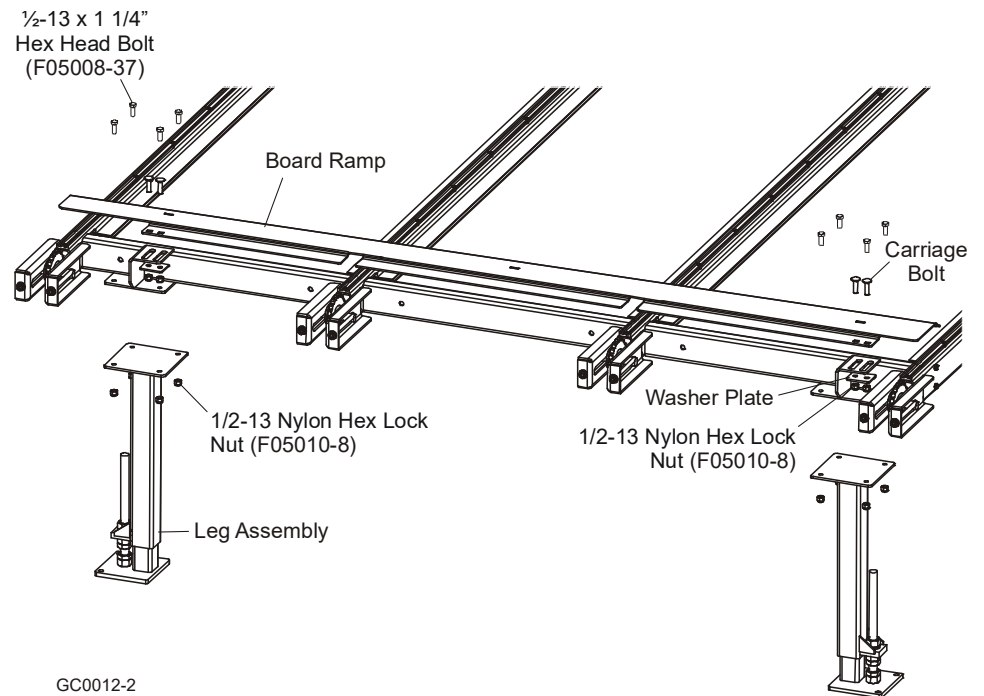
**Idle End Table Assembly**

1. Assemble the provided drive end table rails as shown in FIG. 3-5.
2. Use the connection plates and fasteners to secure the rails in place.



**FIG. 3-5**

3. Install the leg assemblies and the board ramp to the idle end table. **See Fig. 3-6.**
4. Use the hex head bolts, carriage bolts and nylon hex lock nuts to secure the legs and the board ramp in place.



**FIG. 3-6**



5. Install the idle end table to the drive end table as shown in FIG. 3-7.
6. Use the provided and existing hex head bolts and nuts to secure the end tables in place.
7. Install the transfer chain to the conveyor. [See Section 4.2](#) for more information on the chain tensioning.

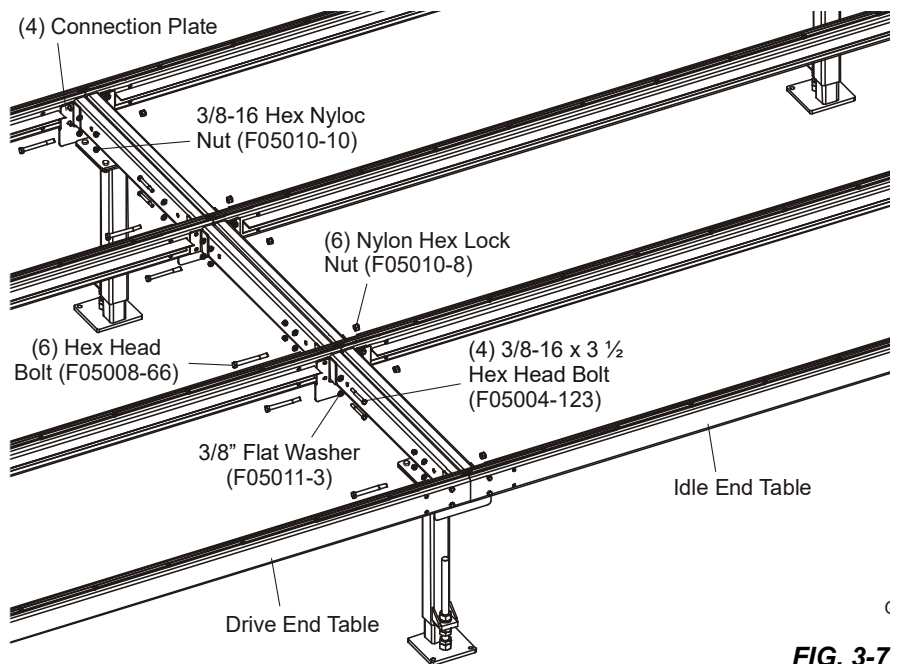


FIG. 3-7

8. Adjust the legs so the conveyor is level. **See Fig. 3-8.**
9. Adjust the legs so the feet firmly contact the ground.
10. Use the adjustment and locking nuts as necessary.
11. Tighten the locking nuts when the height adjustment is complete.
12. Secure the conveyor to the foundation with anchor bolts.

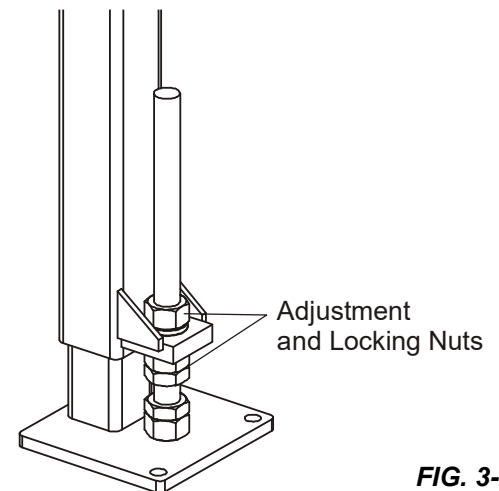


FIG. 3-8



## 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.

**DANGER!** 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 Edger operation.

Perform the following steps to make the required electrical connections:

1. Route the cable from the start/stop control assembly to the drive motor.
2. Remove the cover from the drive motor junction box.
3. Remove the plug from the bottom of the motor junction box. Install the cable connector to the junction box.
4. Connect the black wires from the control cable to the yellow motor wires.

### HIGH VOLTAGE (460V) ONLY:

- 1). Connect the black wire labeled U/L1/C/L+ from the control cable to the yellow wire labeled T1 located in the junction box.
- 2). Connect the black wire labeled V/L2 to the yellow wire labeled T2.
- 3). Connect the black wire labeled W/L3/D/L- to the yellow wire labeled T3. Secure and insulate the wire connections properly.
- 4). Connect the remaining motor wire T4 to wire T7, wire T5 to wire T8, and wire T6 to wire T9, if necessary.
- 5). Make sure all the motor wires are insulated properly.

### LOW VOLTAGE (208-230V) ONLY:

- 1). Connect the black wire labeled U/L1/C/L+ from the control cable to the yellow wires labeled T1 and T7 located in the junction box.
  - 2). Connect the black wire labeled V/L2 to the yellow wires labeled T2 and T8.
  - 3). Connect the black wire labeled W/L3/D/L- to the yellow wires labeled T3 and T9.
  - 4). Secure and insulate the wire connections properly.
  - 5). Connect the remaining motor wire T4 to wires T5 and T6.
  - 6). Make sure all the motor wires are insulated properly.
5. Replace the cover to the motor junction box. Secure the control cable to the conveyor frame as necessary.

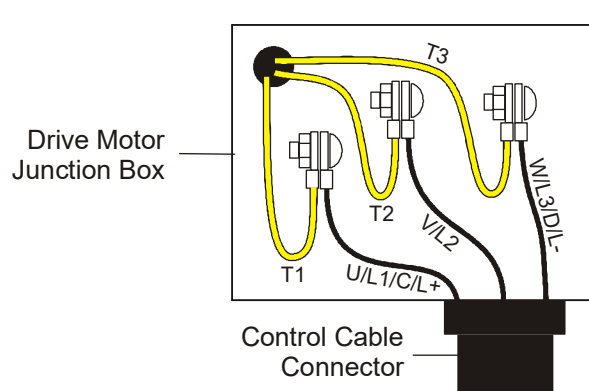
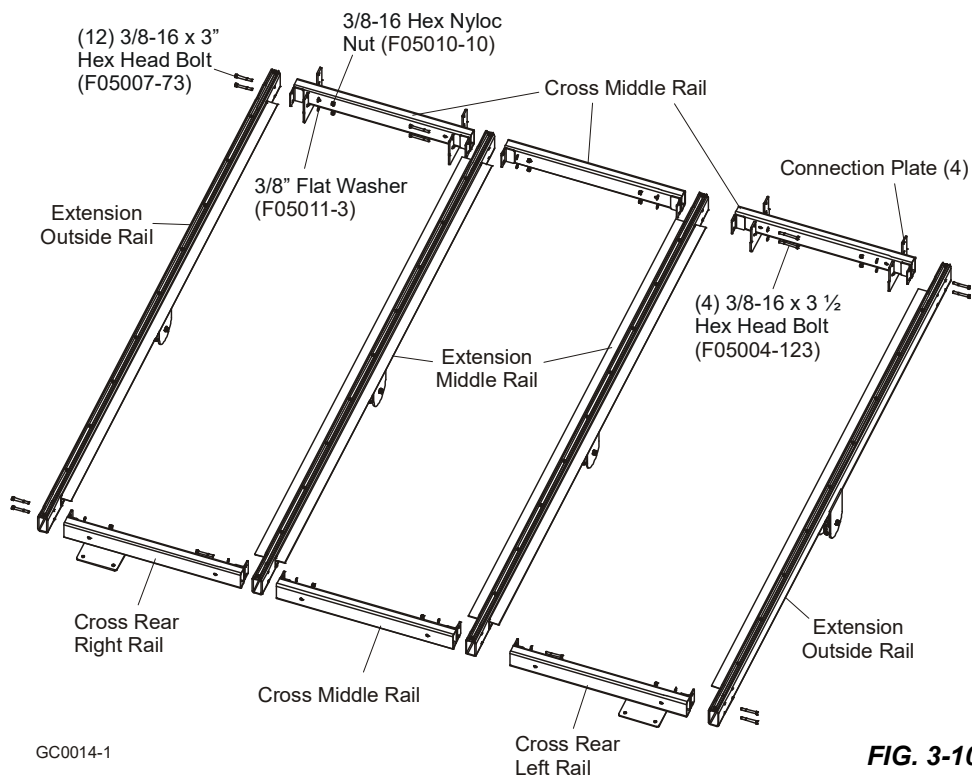


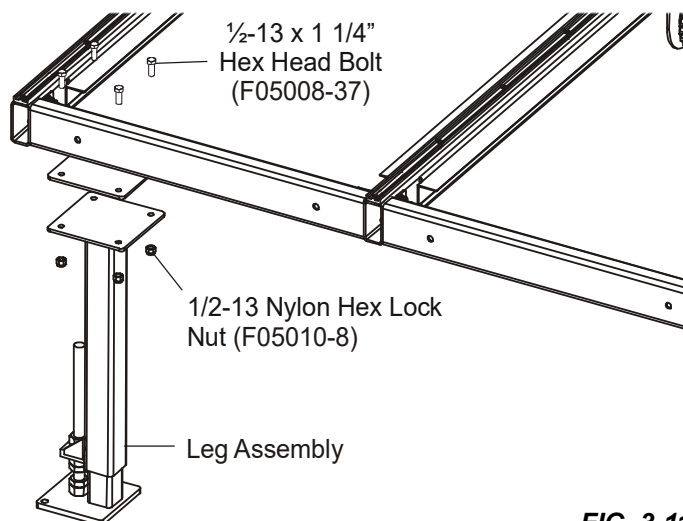
FIG. 3-9

**Extension Table Assembly (Optional)**

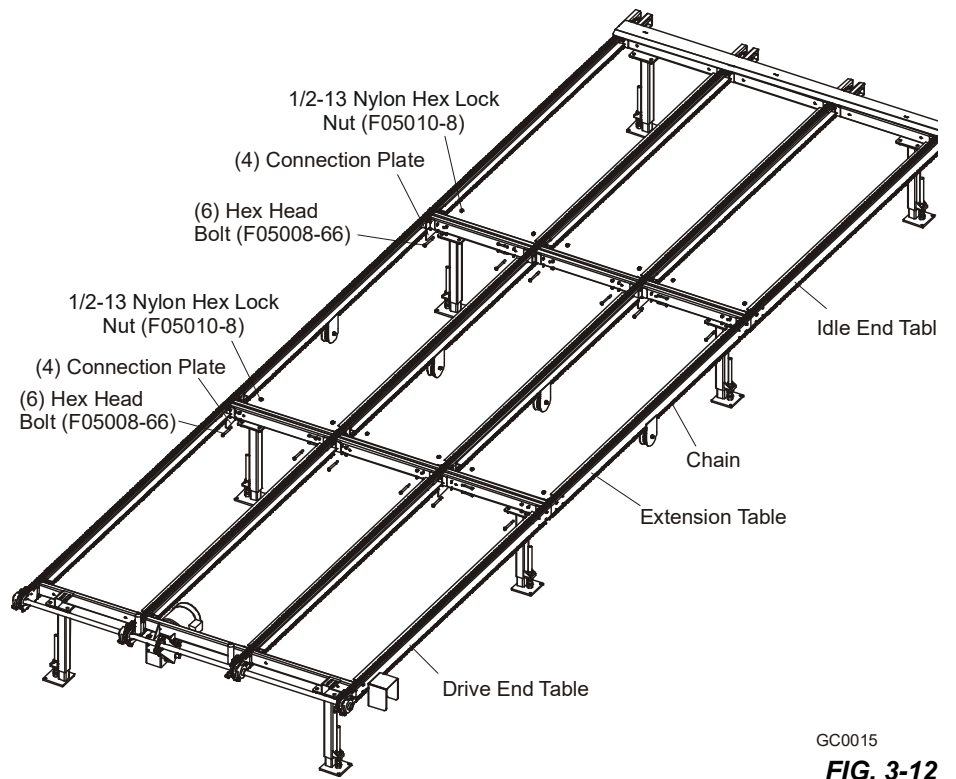
1. Assemble the extension table rails as shown in FIG. 3-10.
2. Use the connection plates and fasteners to secure the rails in place.


**FIG. 3-10**

3. Install the leg assemblies to the extension table.
4. Use the hex head bolts and nylon hex lock nuts to secure the legs in place.



**FIG. 3-11**

5. Disconnect and remove the conveyor chain from the existing idle and drive end tables.
6. Install the extension table between the idle and drive end tables as shown in FIG. 3-12.
7. Use the provided and existing hex head bolts and nuts to secure the tables in place.
8. Install the provided and existing conveyor chain to the conveyor. [See Section 4.2](#) for more information on the chain tensioning.



GC0015  
**FIG. 3-12**

## SECTION 4 MAINTENANCE

 **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!** Always wear proper and necessary safety equipment when performing service functions. Proper safety equipment includes eye protection, breathing protection, hand protection and foot protection.

### 4.1 Gearbox Oil

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

The Mobil Glygoyle 460 gear oil is used for extremely long life. Change oil only when performing maintenance that requires gearbox disassembly.


If oil must be replaced, use only Mobil Glygoyle 460.

Wood-Mizer offers replacement gear oil in 8 ounce bottles.

### 4.2 Lubrication

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


### 4.3 Tensioning the Chains

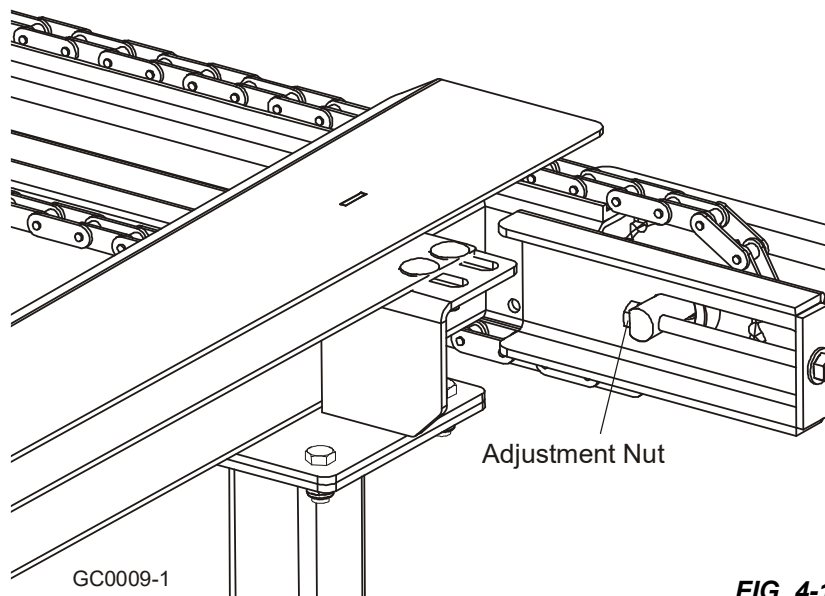
 **DANGER!** Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death.

Adjust the conveyor chain tension as needed.

Locate the adjustment nuts at the end of the idle side table.

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.



**FIG. 4-1**

Periodically check the motor drive chain tension and adjust the as needed.

1. Turn off the power to the motor when checking the tension.
2. Adjust the chain if the slack exceeds 1/2" (12.7mm).
3. Loosen the four bolts securing the drive chain guard as shown below.
4. Remove the guard from the conveyor and check the drive chain tension.

Adjust the motor drive chain tension:

1. Turn off the power to the motor.
2. Loosen the mount bolts (4) securing the gearbox to the conveyor frame.
3. Move the gearbox and motor assembly to adjust the drive chain.

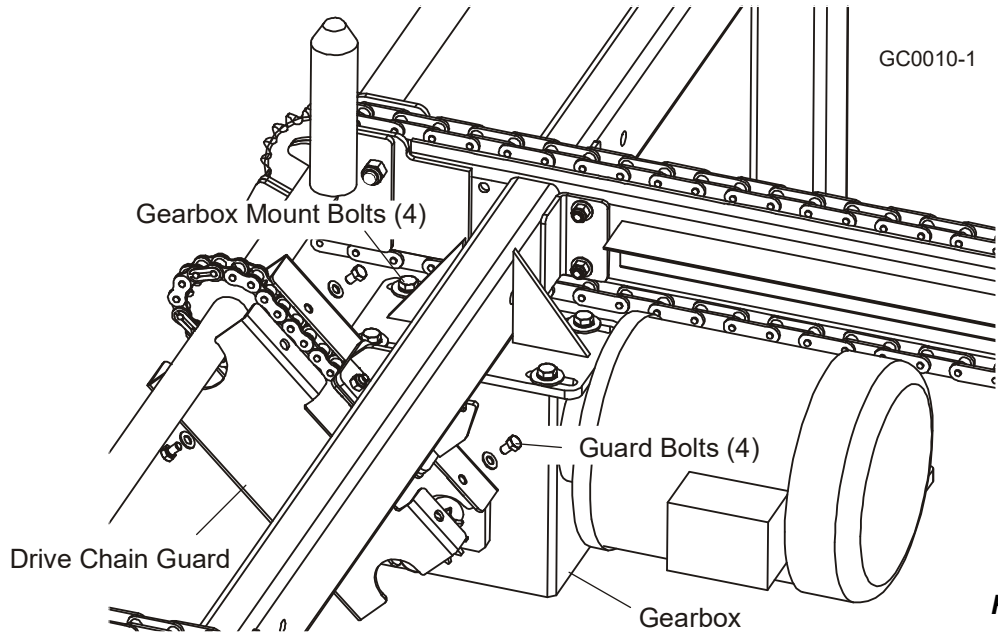


FIG. 4-2



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

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

## 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

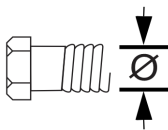
The Sample Assembly, Complete, part number 02345 (top level assembly) includes two parts (F0222-22 and F0333-33) and the 098765 subassembly.

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



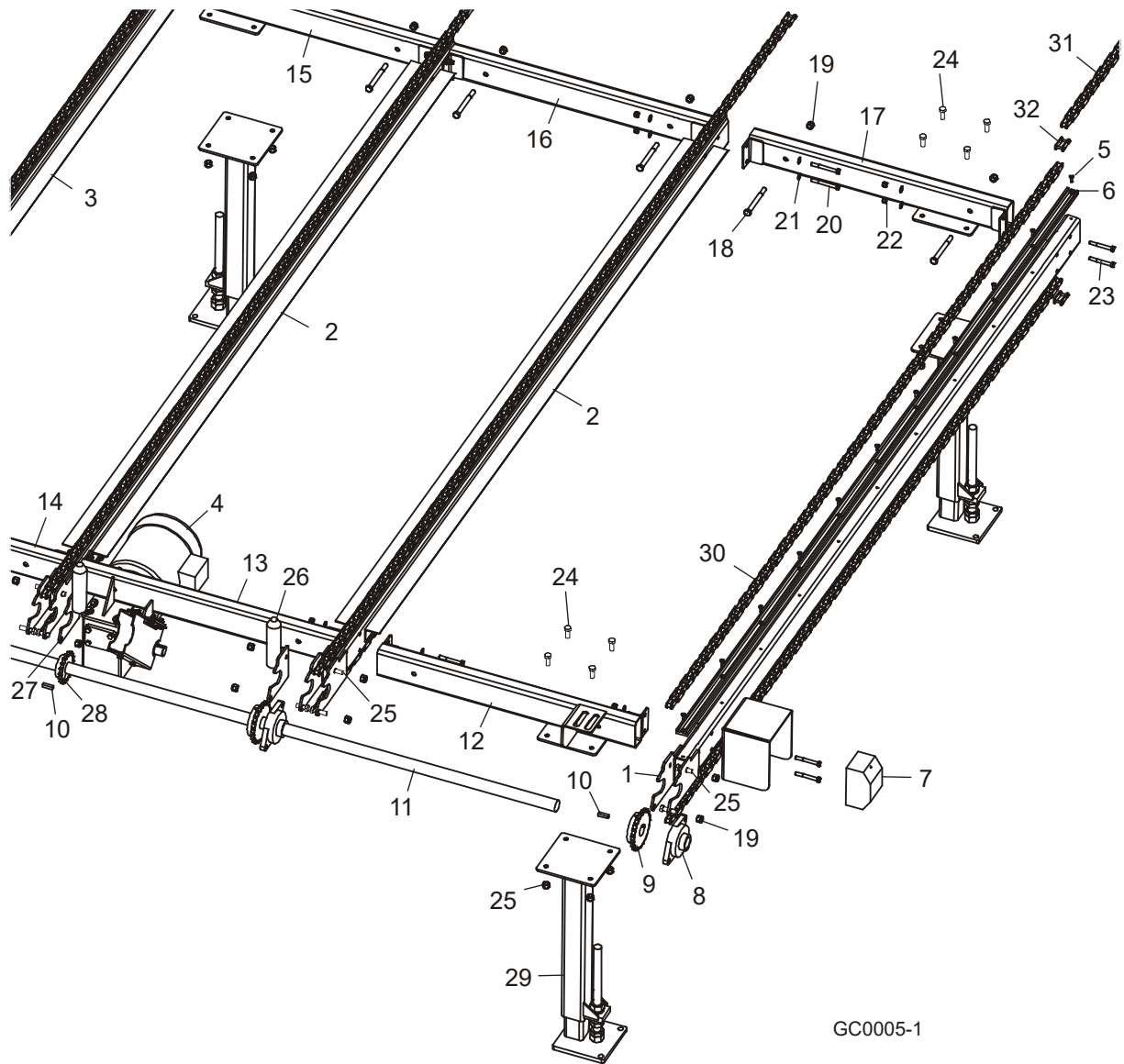
Metric Grade 8.8



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 Drive End Table Assembly



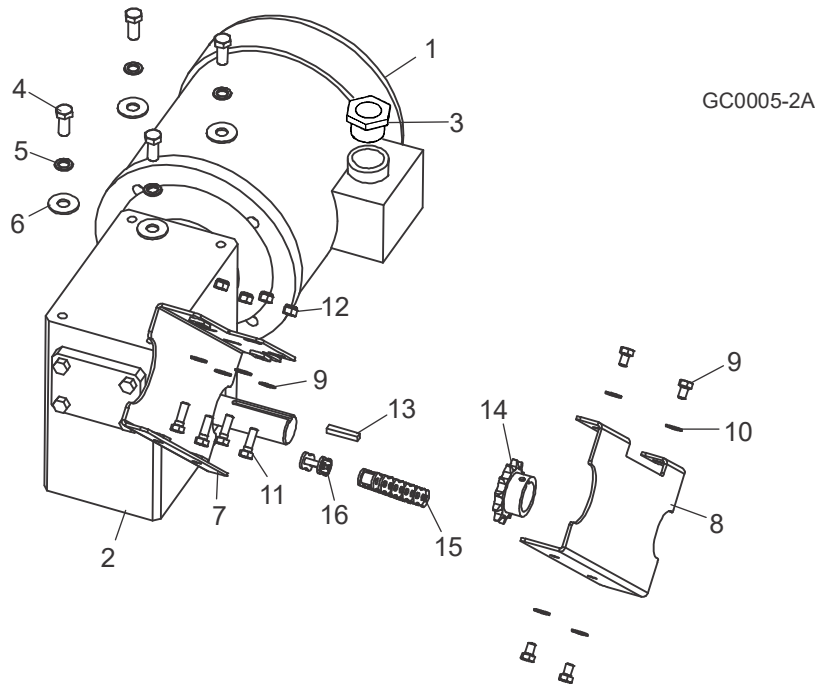
GC0005-1

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	064768	<b>TABLE ASSEMBLY, DRIVE END</b>		1
1	064785	Rail Weldment, Drive End Right		1
2	064786	Rail Weldment, Drive End Middle		2
3	064787	Rail Weldment, Drive End Left		1
4		Motor/Gearbox Assembly	<a href="#">(See Section 5.5)</a>	
5	F05005-117	Screw, 1/4-20 x 3/4" FSH BO		44
6	064777	Slide, Cross Trans Chain		4
7	064745	Control Assembly, SLPCTD 460V Start/Stop		
8	064719	Bearing, VF2S-224		4
9	064716	Sprocket, 60B21 x 1 1/2"		4
10	S12892	Key, 3/8" x 3/8" x 1 3/8"		5
11	064776	Shaft, 1-1/2" GC Drive		1
12	064790	Rail Weldment, Cross Front Right		1
13	064792	Rail Weldment, Cross Front W/Motor Mount		1



REF	PART #	DESCRIPTION	COMMENTS	QTY.
14	064791	Rail Weldment, Cross Front Left		1
15	064793	Rail Weldment, Cross Rear Left		1
16	064789	Rail Weldment, Cross Middle		1
17	064794	Rail Weldment, Cross Rear Right		1
18	F05008-66	Bolt, 1/2-13 x 5" Hex Head Cap Grade 5		6
19	F05010-8	Nut, 1/2-13 Nyl Hex Lock		34
20	F05004-123	Bolt, 3/8-16 x 3 1/2" Hex Head Grade 5		4
21	F05011-3	Washer, 3/8" Flat SAE		24
22	F05010-10	Nut, 3/8-16 Hex Nyloc		16
23	F05007-73	Bolt, 3/8-16 x 3" Hex Head Grade 5		12
24	F05008-37	Bolt, 1/2-13 x 1 1/4" Hex Head Grade 5		20
25	F05008-88	Bolt, 1/2-13 x 1 3/4" Hex Head Grade 5		8
26	065390	Pin Weldment, Board Stop Left		1
27	065391	Pin Weldment, Board Stop Right		1
28	101797	Sprocket, 50B18 x 1 1/2"		1
29		Green Chain Leg Assembly	<a href="#">(See Section 5.6)</a>	
30	064779	Chain, C2060 x 118-1/2" (79 pitches)		8
31	064761	Chain, C2060 x 22 1/2" (15 pitches)		4
32	064780	Link, C2060 Master		12

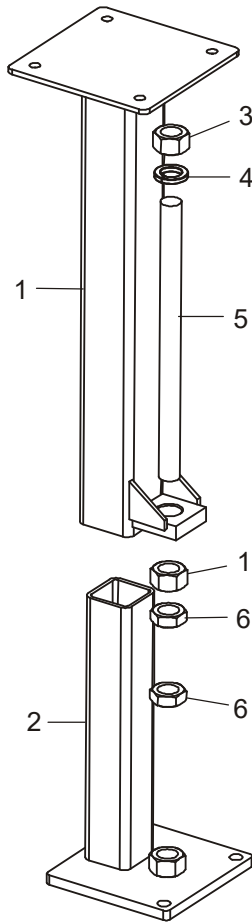
## 5.5 Drive Motor Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	065415	<b>MOTOR/GEARBOX ASSEMBLY, 1.5HP X 50:1 GC</b>		1
1	065413	Motor, Leeson G132249.00 1.5 Hp 182T		1
2	065414	Gearbox, 50:1 Grove GR8300261		1
3	038742	Bushing, 3/4MNPT-1/2FNPT Pipe		1
4	F05007-145	<b>BOLT, 7/16-14 X 1" HEX HEAD GRADE 5</b>		4
5	F05011-48	<b>WASHER, 7/16" SPLIT LOCK</b>		4
6	F05011-35	<b>WASHER, 7/16" STANDARD FLAT</b>		4
7	065456	<b>COVER WELDMENT, GC CHAIN DRIVE</b>		1
8	065454	<b>GUARD, CHAIN, OUTSIDE GC</b>		1
9	F05006-15	<b>BOLT, 5/16-18 X 1/2" HEX HEAD GRADE 5</b>		4
10	F05011-17	<b>WASHER, 5/16" SAE FLAT</b>		8
11	F05006-1	<b>BOLT, 5/16-18 X 1" HEX HEAD</b>		4
12	F05010-58	<b>NUT, 5/16-18 NYLOK HEX</b>		4
13	017832	<b>KEY, 1/4" SQ X 1 3/8"</b>		1
14	064763	<b>SPROCKET, 50B12 X 1 1/4"</b>		1
15	065246	<b>CHAIN, #50 X 31-7/8" 51 PITCHES ROLLER</b>		1
16	P20208	<b>LINK, #50 MASTER</b>		1

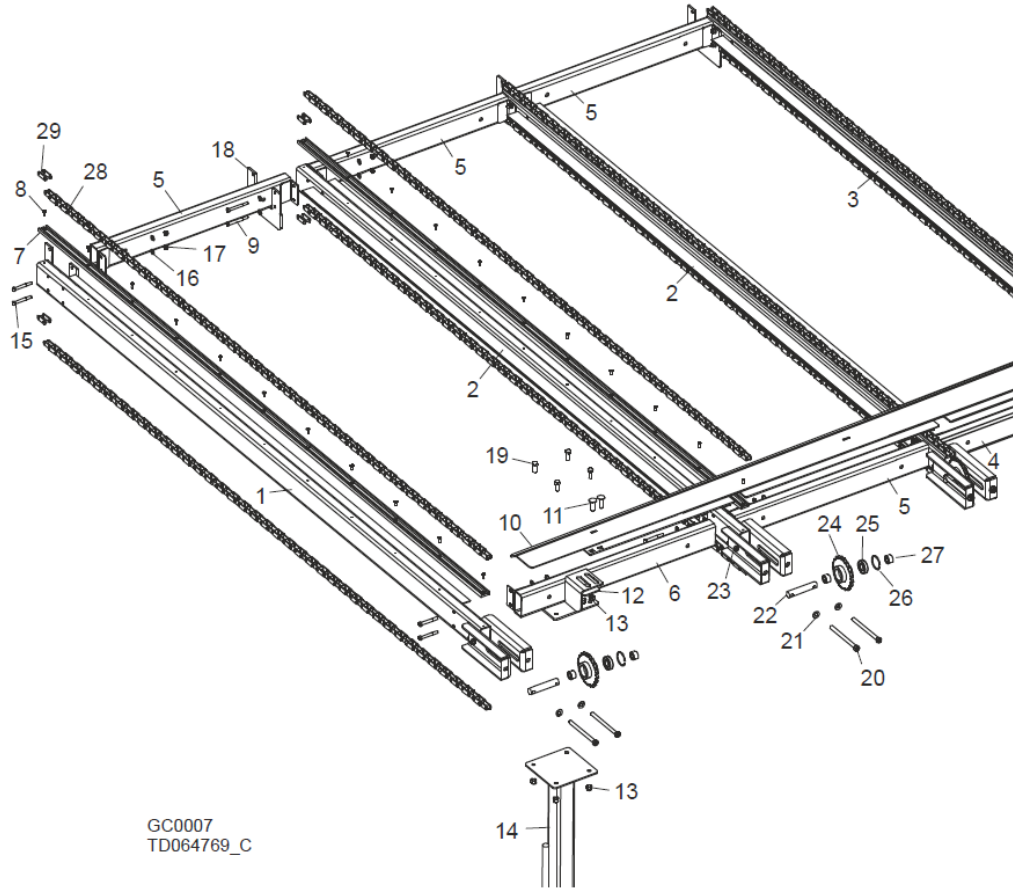
## 5.6 SLeg Assembly

GC0006



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	064803	<b>LEG ASSEMBLY, GREEN CHAIN</b>		1
1	064729	Leg Weldment, Green Chain		1
2	038593	Foot Weldment, IC5		1
3	F05010-140	Nut, 1-14 Free Hex		2
4	F05011-53	Washer, 1in Split Lock		1
5	038595	Rod, 1-14" x 14 1/2"		1
6	F05010-118	Nut, 1-14 Hex Jam		2

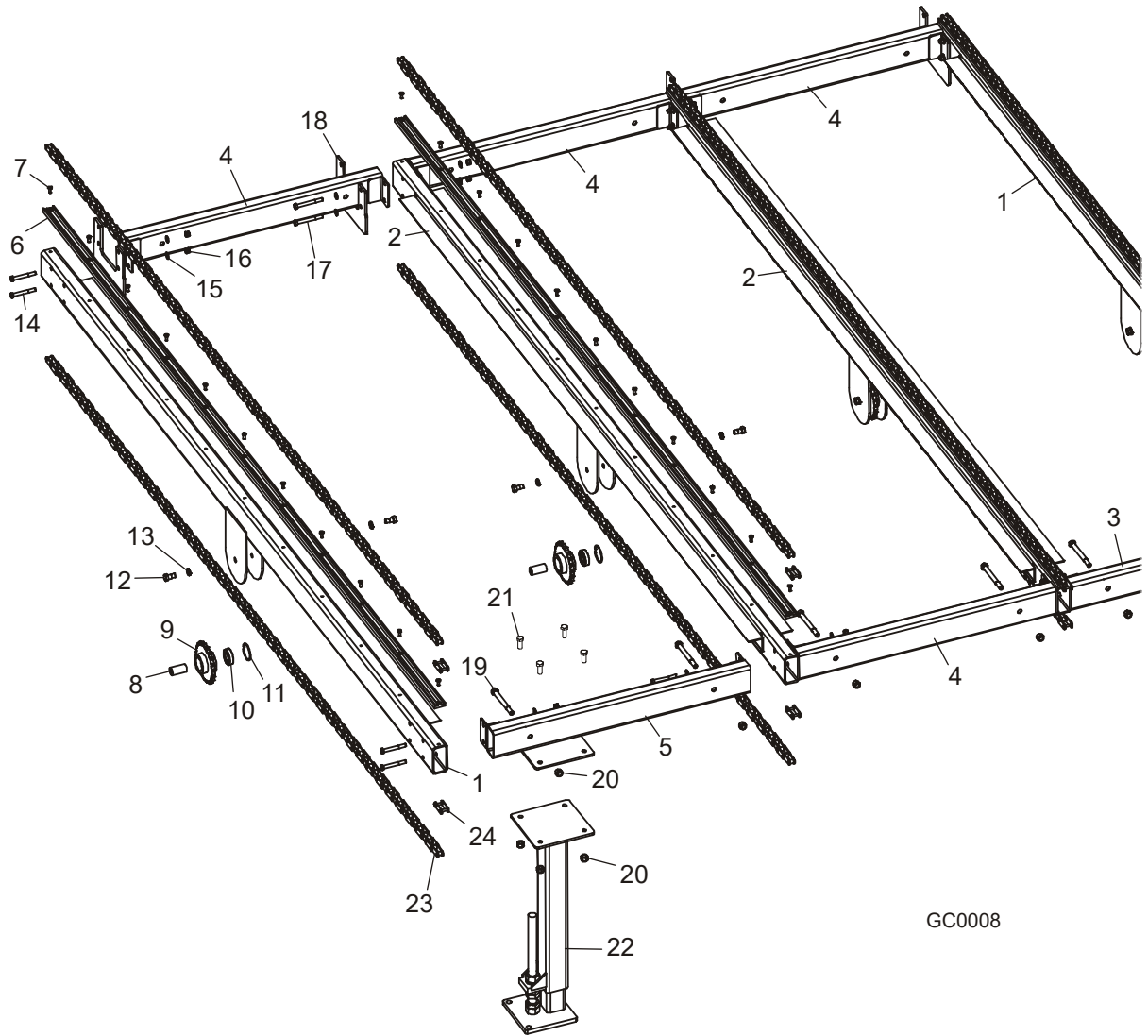
## 5.7 Idle End Table Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	064769	<b>TABLE ASSEMBLY, IDLE END</b>		1
1	064797	Rail Weldment, Rear Right		1
2	064798	Rail Weldment, Rear Middle		2
3	064799	Rail Weldment, Rear Left		1
4	064790	Rail Weldment, Cross Front Right		1
5	064789	Rail Weldment, Cross Middle		4
6	064791	Rail Weldment, Cross Front Left		1
7	064777	Slide, Cross Trans Chain		4
8	F05005-117	Screw, 1/4-20 x 3/4" FSH BO		44
9	F05004-123	Bolt, 3/8-16 x 3 1/2" Hex Head Grade 5		4
10	064802	Ramp Weldment, GC Board, Left		1
11	F05008-163	Bolt, 1/2-13 x 1 3/4" Carriage		4
12	065405	Plate, 7Ga x 1/2 Bolt Washer		2
13	F05010-8	Nut, 1/2-13 Nyl Hex Lock		12
14		Leg Assembly, Green Chain	<a href="#">(See Section 5.6)</a>	
15	F05007-73	Bolt, 3/8-16 x 3" Hex Head Grade 5		12
16	F05011-3	Washer, 3/8" Flat SAE		24
17	F05010-10	Nut, 3/8-16 Hex Nyloc		16
18	065394	Plate, 1/4" GC Connection		4
19	F05008-37	Bolt, 1/2-13 x 1 1/4" Hex Head Grade 5		8
20	064766	Bolt Weldment, 1/2-20 x 6 3/4" Hex Head		8

REF	PART #	DESCRIPTION	COMMENTS	QTY.
21	F05011-2	Washer, 1/2" SAE Flat		8
22	064735	Shaft, Idler		4
23	F05010-16	Nut, 1/2-20 Hex Jam		8
	064717	Sprocket, 6021 x 1 Idler		4
24	064784	Sprocket Weldment, 6021 Idler		1
25	042360	Bearing, R16 Sealed		1
26	F04254-35	Ring, 2 ID IR N5000-200 Retaining		1
27	130502	Sleeve, 1.02IDx1.25ODx.72Long		2
28	064779	Chain, C2060 x 118-1/2 (79 pitches)		8
29	064780	Link, C2060 Master		8

## 5.8 Extension Table Assembly



GC0008

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	064770	<b>TABLE ASSEMBLY, EXTENSION</b>		1
<b>1</b>	064796	Rail Weldment, Extension Outside		2
<b>2</b>	064795	Rail Weldment, Extension Middle		2
<b>3</b>	064793	Rail Weldment, Cross Rear Left		1
<b>4</b>	064789	Rail Weldment, Cross Middle		4
<b>5</b>	064794	Rail Weldment, Cross Rear Right		1
<b>6</b>	064777	Slide, Cross Trans Chain		4
<b>7</b>	F05005-117	Screw, 1/4-20 x 3/4" FSH BO		44
<b>8</b>	064760	Pin, Middle Idler		4
	064717	Sprocket, 6021 x 1 Idler		4
<b>9</b>	064784	Sprocket Weldment, 6021 Idler		1
<b>10</b>	042360	Bearing, R16 Sealed		1
<b>11</b>	F04254-35	Ring, 2 ID IR N5000-200 Retaining		1
<b>12</b>	F05008-50	Bolt, 1/2-13 x 1" Hex Head		8
<b>13</b>	F05011-9	Washer, 1/2" Split Lock		8

REF	PART #	DESCRIPTION	COMMENTS	QTY.
14	F05007-73	Bolt, 3/8-16 x 3" Hex Head Grade 5		12
15	F05011-3	Washer, 3/8" Flat SAE		24
16	F05010-10	Nut, 3/8-16 Hex Nyloc		16
17	F05004-123	Bolt, 3/8-16 x 3 1/2" Hex Head Grade 5		4
18	065394	Plate, 1/4" GC Connection		4
19	F05008-66	Bolt, 1/2-13 x 5" Hex Head Cap Grade 5		6
20	F05010-8	Nut, 1/2-13 Nyl Hex Lock		14
21	F05008-37	Bolt, 1/2-13 x 1 1/4" Hex Head Grade 5		8
22		Leg Assembly, Green Chain	<a href="#">(See Section 5.6)</a>	
23	064779	Chain, C2060 x 118-1/2 (79 pitches)		8
24	064780	Link, C2060 Master		8