

Roll Case and Roll Case Sorting Conveyors

Safety, Operation, and Maintenance Manual

RC	rev. A1.00
RCS	rev. A1.00

Safety is our #1 concern!

Form #2705

Relevant Models:

Roll Case	Roll Case Sorting
RC-30W-12L-3EC	RCS-30W-12L-5EC-LH
RC-30W-16L-3EC	RCS-30W-16L-5EC-LH
RC-30W-20L-3EC	RCS-30W-20L-5EC-LH
	RCS-30W-12L-5EC-RH
	RCS-30W-16L-5EC-RH
	RCS-30W-20L-5EC-RH
Control Assemblies	Control Assemblies
RC-CTRL-3EC1 - 1 Drive Configuration	RCS-CTRL-5EC2 - 2 Drive Configuration
RC-CTRL-6EC2 - 2 Drive Configuration	RCS-CTRL-8EC3 - 3 Drive Configuration
RC-CTRL-9EC3 - 3 Drive Configuration	RCS-CTRL-10EC4 - 4 Drive Configuration



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

Limited Product Warranty

Wood-Mizer

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

PRODUCT	MODEL CLASS	LENGTH OF WARRANTY		EFFECTIVE DATE
		USA & CANADA	NON USA & CANADA	
Portable Sawmills, Resaws, Edgers	LT, LX, HR, EG	Two years	One year	Date of purchase
Portable Sawmills with Chassis	LT28, LT35, LT40, LT50, LT70, LX450	Two years, excluding the chassis, which chassis shall have a five year warranty	One year	
Industrial Sawmills, Resaws, Edgers	WM, HR, EG, TVS, SVS	One year	One year	
TITAN Industrial	WB, TV, HR, EG, EA, MR	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
Material Handling	TWC, IC, TD, LD, GC, CR, CB, CC	One year	One year	
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	
Options and Accessories	Various	One year*	One year*	
Moulders, Extractors	MP, MD	Two years	One year	
Kilns	KS, KD	One year	One year	
Slab Flatteners	MB	Two years	One year	
Pallet Equipment	PD, PC	One year	One year	
Log Splitters	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

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

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

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

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

Five Year Limited Chassis Warranty

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

Warrantor's Obligations as To Defects

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

Limitations and Disclaimers of Other Warranties

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

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

Design Changes

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

Rights of Purchasers

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

Interpretations

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

SECTION 1 INTRODUCTION

1.1 About This Manual

This manual replaces any previous information received on your Wood-Mizer® equipment.

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

1.2 Getting Service

For contact information, sales, service, parts, and additional manuals, sign into your account on <https://woodmizer.com>, or call inside the USA: 1-800-553-0182 or from outside the USA: 317-271-1542

1.3 Specifications

Equipment specification are included in the Online Manuals, which are found at <https://apps.woodmizer.com/Manuals/Manuals.aspx?parent=0>.

SECTION 2 SAFETY

2.1 Safety Symbols

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

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

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

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

NOTICE indicates vital information.

2.2 Safety Instructions

NOTE: ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding only equipment damage appear where applicable throughout the manual.

 **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. 

OBSERVE SAFETY INSTRUCTIONS

NOTICE Read the entire Operator's Manual before operating the Roll Case. 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 persons who have read and understood the entire operator's manual should operate the Roll Case. The Roll Case is not intended for use by or around children.

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



KEEP ROLL CASE AND AREA AROUND ROLL CASE 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.

CAUTIONS FOR ROLL CASE SETUP

 **WARNING!** Securely fasten the feet of an incline Roll Case to the floor before operating the machine. Failure to do so may result in serious injury or death.

CHECK ROLL CASE BEFORE OPERATION

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



KEEP PERSONS AWAY

 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating Roll Case. Failure to do so may result in serious injury or death.

WARNING! Keep hands away from area underneath the table top. Serious injury may result.

USE PROPER PROCEDURE WHEN CONDUCTING MAINTENANCE

 **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 control 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.



WARNING! Consider all electrical circuits energized and dangerous.

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.

SECTION 3 CONTROLS OPERATION

Left and Right operations noted in this manual are observed from the operator's point of view from the control unit. The material will be moving away from the operator.

Screen appearance and options will vary based on chosen configuration. For screens that are not universally used or otherwise identified, the appearance shown in these instructions are for a 5 Way, 2 Deck setup.

3.1 Operation

1. Use the control switch on the operator assembly to toggle to Auto or Manual Mode. See FIG. 3-1

NOTE: When running in manual mode, the indicator light on the Start/Stop button will flash.

When running in auto mode, the indicator light on the Start/Stop button will remain on.

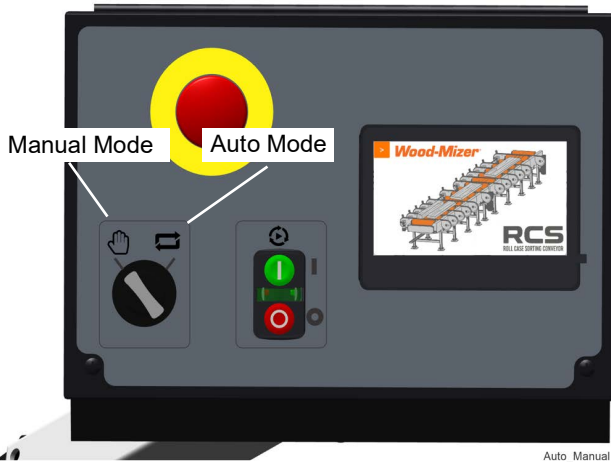


FIG. 3-1

2. Select the arrow button in the upper left corner of the screen.
3. Choose Operation.

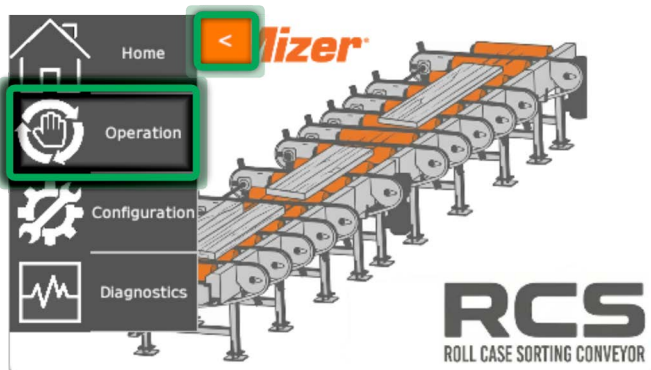


FIG. 3-2

4. Select the Cycle button.

NOTE: Whether in Auto or Manual Mode, this button will open the main operation screen. The content shown is dynamic based on the mode and deck configuration. The main operation screen shows the active default sort direction in orange, and the next piece sort direction in green.

The roller indicators in the upper right hand corner will either be red or green depending on if they are disabled/stopped or enabled.

NOTE: Rollers automatically stop during a sweep and will restart once complete.

AUTO MODE

See FIG. 3-3, 5 Way, 2 Decks - Auto mode with piece counter turned on as an example.

1. To override the next sort direction, select the button on screen that indicates the desired sort direction.

NOTE: After the sort override completes, the sort will return to default.

2. If an incorrect sort direction override is selected, press the **Next Piece** button to cancel, OR hold down the physical stop button on the control assembly for 2 seconds.

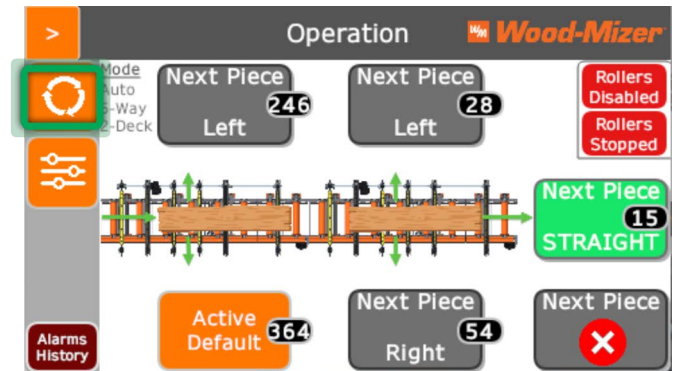


FIG. 3-3

MANUAL MODE

See FIG. 3-4, 5 Way, 2 Decks - Manual mode as an example.

1. Touch a blue button to perform a full cycle of that particular sweep cycle.
2. Touch and hold a yellow button to perform that particular function.

NOTE: Yellow buttons will only activate motors as long as the button is being pressed.

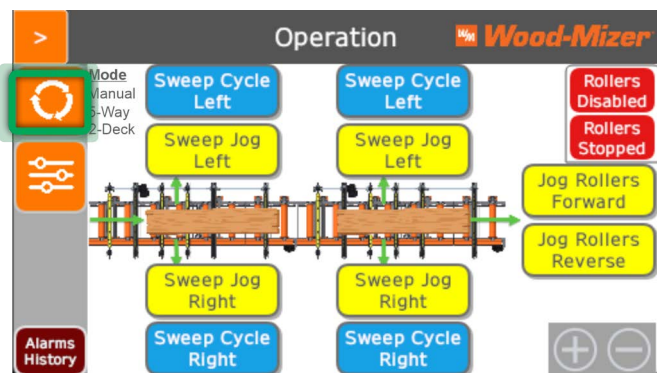


FIG. 3-4

QUICK SETTINGS

This screen is a short cut for common operation settings and temporary overrides. See FIG. 3-5

NOTE: Setting defaults and normal setup operation is performed in the Configuration menu. See the next section in this chapter, "Configuration".

1. Select the Quick Settings button.
2. Adjust Sweep and Roller speeds as needed.
3. Turn Piece Counters ON or OFF.
4. Setup physical selector button settings.

NOTE: These settings, on the right side of the screen, set the output when the green selector button is pressed.

A single push of the green button will perform the first set function.

A double push of the green button will perform the second set function.

A long, 2 second, push will cancel the next sort override and will return to default sort.

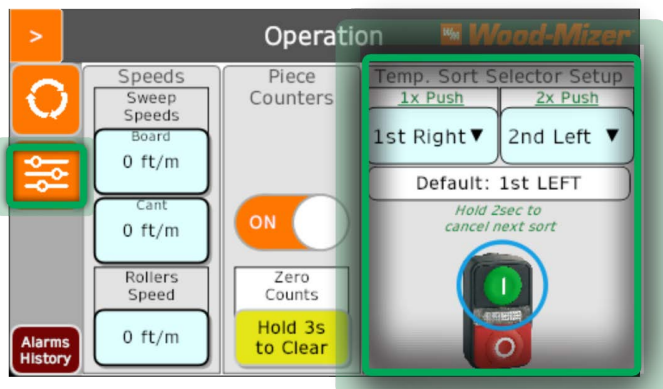


FIG. 3-5

5. View Warnings and Alarms as needed for troubleshooting.

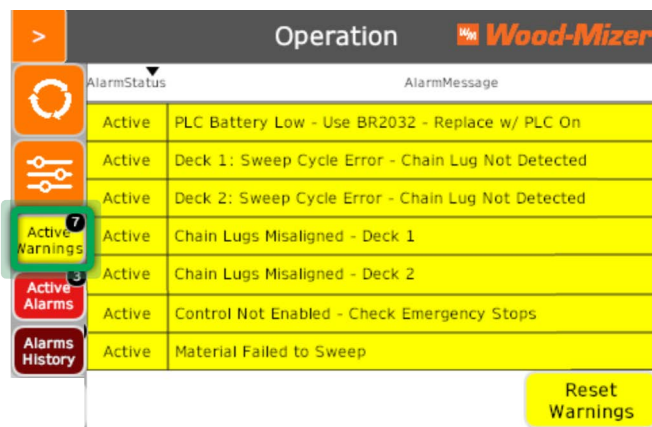


FIG. 3-6

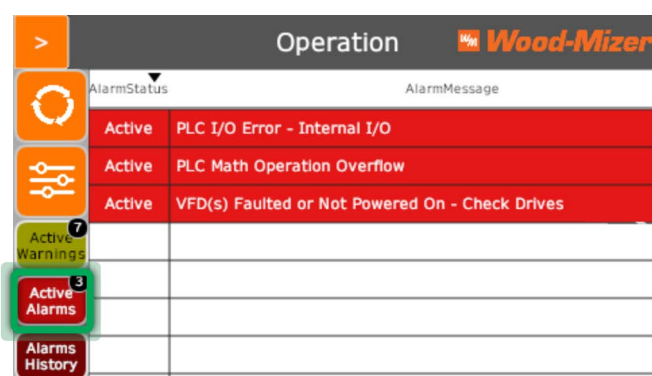


FIG. 3-7

3.2 Configuration

1. Select the arrow button in the upper left corner of the screen.
2. Choose Configuration.

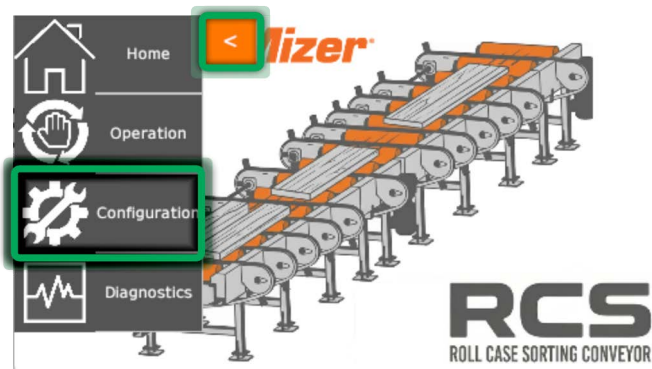


FIG. 3-8

MODE SELECTION

1. From the start menu, choose **Configuration**.
2. Select **System Mode** and then choose deck/sorting configuration that is installed as shown in FIG. 3-9.

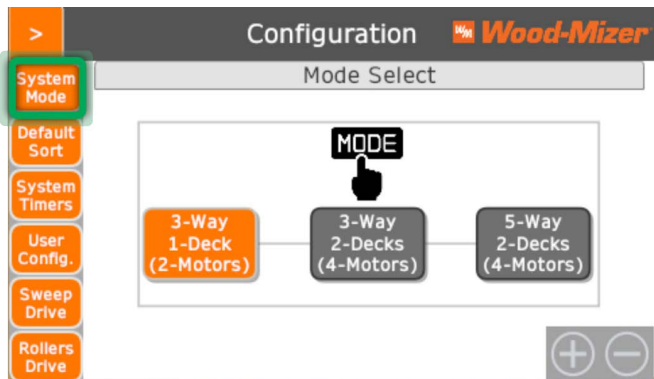


FIG. 3-9

SORTING SETUP

The sweep settings available on screen will vary based on the mode selected.

NOTE: 5 Way, 2 Decks shown in this example.

1. Select **Default Sort**.
2. For each deck, select what material type will be swept, Board or Cant, and sweep direction, Left, Right, or Straight.

NOTE: Cants should be swept in the direction of the sweep motor.

Direction is established from the operator's point of view in the cab.

Default 5 Way sort configuration shown in FIG. 3-10.

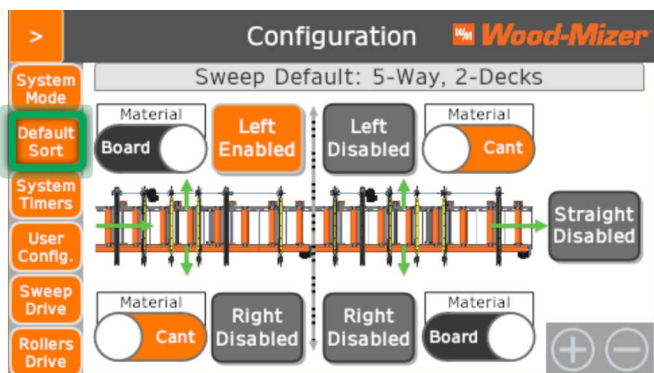


FIG. 3-10

SYSTEM TIMERS AND SENSORS

1. Select **System Timers**.
2. Set On Delay or Off Delay for Paddle Sensor(s).

NOTE: On Delay time will determine how much time passes after a paddle is pressed before the chain sweeps sort the lumber.

Off Delay time will determine how much time passes after a paddle returns to its up position before the chain sweeps sort the lumber.

3. Chain Lug Sensor(s) settings likely will not need to be adjusted from the factory setting of 10s cycle time. However, in the event that the sweep lugs stop over the sensor, the *Sensor Lockout* setting can be adjusted to allow the lug to clear the sensor after each sweep.
 - If sweep chains run at a very low speed, cycle takes longer to complete. Sweep cycle error presents before chain lug makes it to lug sensor. Increase time.
 - If sweep chains run at max speed, cycle may complete too quickly. Sweep chains will keep moving until controller recognizes lug at sensor. Faster error detection is needed. Decrease time.

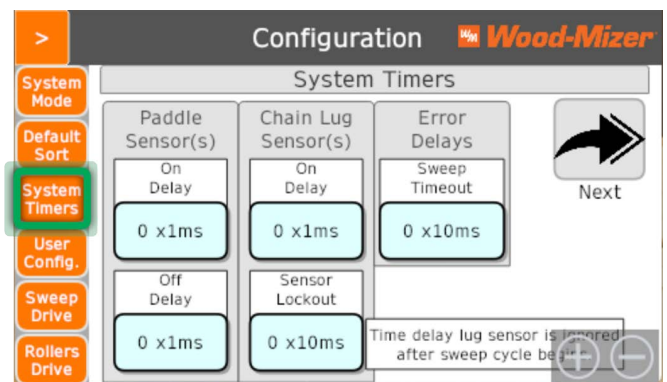


FIG. 3-11

4. Press **Next** to advance to second System Timers screen.
5. Set Sweep Delays for left and right sweeps for boards and cants.

NOTE: These timers set at zero with factory settings will allow the lugs to sweep the material off the deck. These settings allow the stop position of the lugs to be adjusted.

When sweeping toward the sweep motors, the lugs will stop on top of the deck, opposite the sweep motors, in position for the next sweep.

When sweeping away from the sweep motors, the lugs may stop out of position.

6. Add delay time to either left or right side as needed to position lugs as needed for next sweep. See FIG. 3-12.

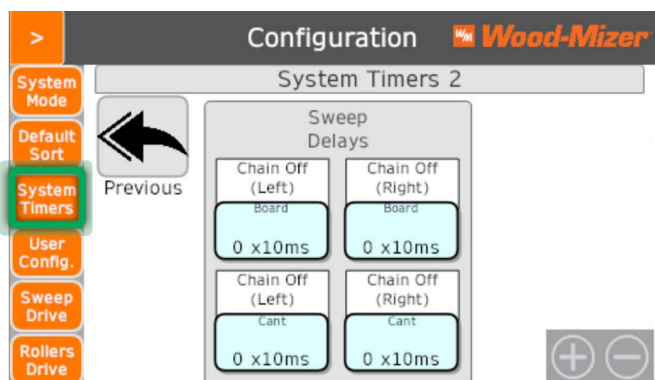


FIG. 3-12

USER CONFIGURATION

Paddle plate sensors can be set to trigger a sweep either when depressed or when returned upward after lumber passes over.

1. Set whether to sweep when board is present at paddle plate or past paddle plate. See FIG. 3-13

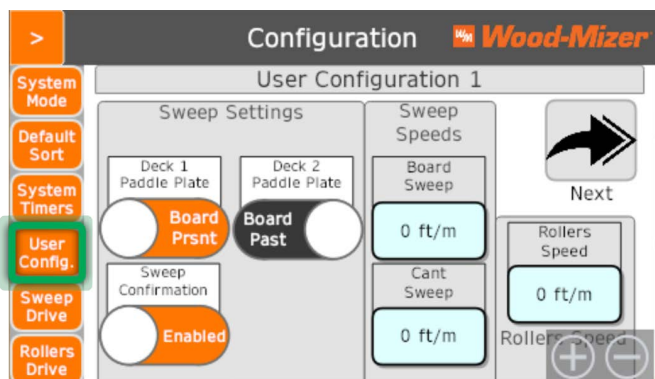
NOTE: For 3 Way, 2 Decks setups, the option to choose to sweep on the deck 1 or deck 2 paddle will be shown. See FIG. 3-14

2. Choose whether to Enable or Disable Sweep Confirmation.

NOTE: This is an error checking option that will check to verify that after a sweep, there is no material remaining on the deck.

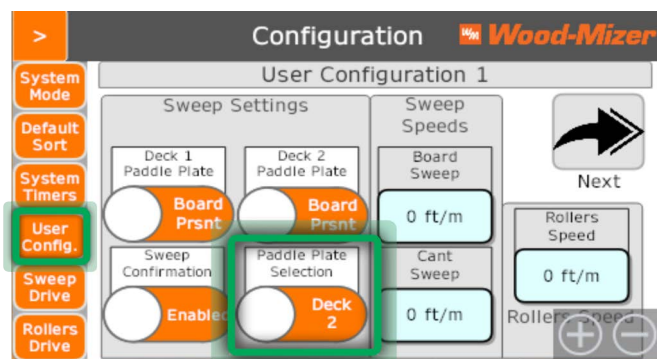
3. Set sweep speeds for both boards and cants.
4. Set roller speed.

NOTE: As speeds are adjusted up, the relative speed will be shown as green bar in the area above the speed input.



5 Way, 2 Decks

FIG. 3-13



3 Way, 2 Decks

FIG. 3-14

5. Press **Next** to advance to second User Configuration screen.

This screen displays total pieces processed in any direction and which direction the last piece was swept.

6. To reset total piece count, press Zero Counts button for 3s.
7. To restore factory defaults for the whole screen, press Restore button for 3s. See FIG. 3-15

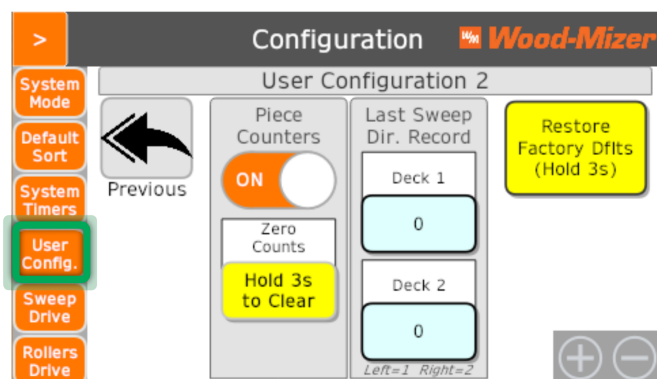


FIG. 3-15

SWEEP & ROLLERS GEARING CONFIGURATION

NOTE: These settings should not need to be adjusted from the factory, but are present for sim-

ple adjustment in the case of a custom gearing configuration being installed by the manufacturer.

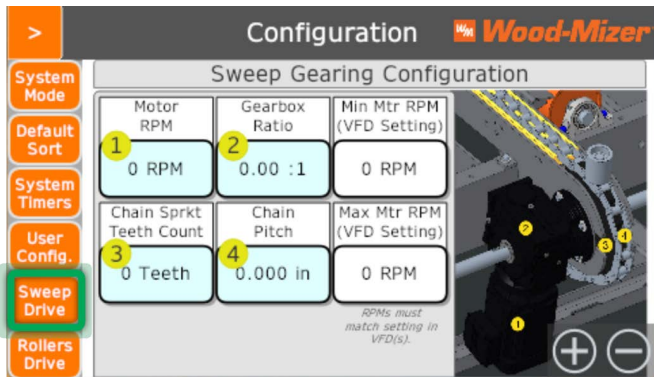


FIG. 3-16

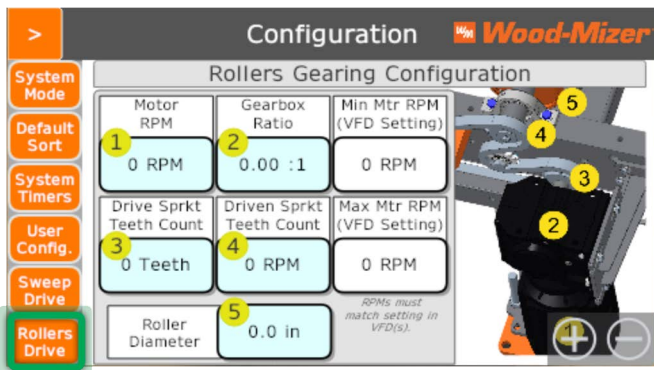


FIG. 3-17

3.3 Diagnostics

1. Select the arrow button in the upper left corner of the screen.
2. Choose Diagnostics.

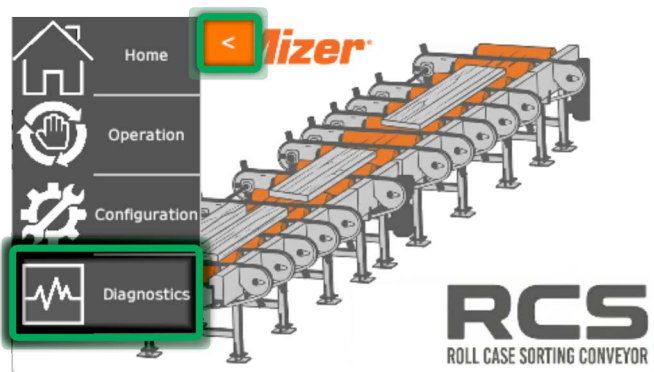


FIG. 3-18

3. Select PLC Inputs.

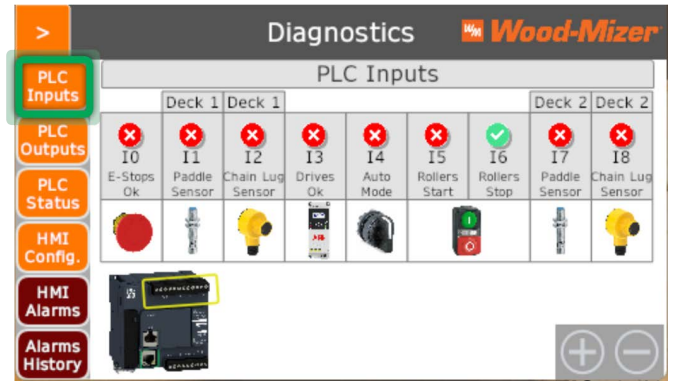


FIG. 3-19

❌ Value = False: PLC input not present

✅ Value = True: PLC input present

4. Troubleshoot and correct as needed.
5. Select PLC outputs.
6. Use yellow "Test" buttons to test each output.

NOTE: PLC must be in "Manual Mode" to run tests.

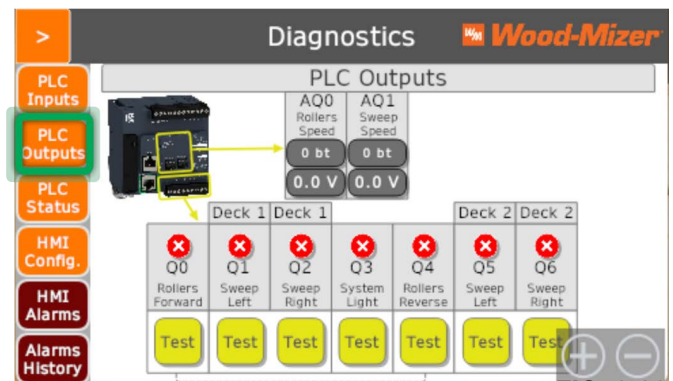


FIG. 3-20

❌ Value = False: PLC input not present

✅ Value = True: PLC input present

7. Troubleshoot and correct as needed.

8. View PLC component status.

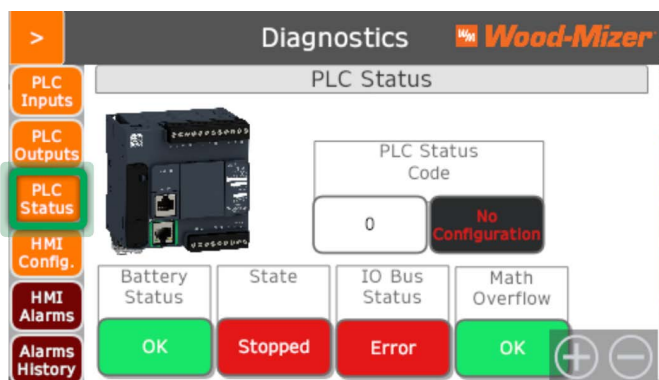


FIG. 3-21

9. Select HMI Config.

This screen can be used to change settings on the physical HMI unit (Date/Time, Buzzer, Brightness, etc.)

10. Use Up/Down buttons to scroll list.

11. Adjust settings as needed.

This screen is used to download an updated program that may be provided for download from a USB drive.

12. Scroll down to **Download from**.

NOTE: If a USB drive is detected, that option will be available.



FIG. 3-22

13. To view Current Alarms and Alarms History, select the appropriate button as shown.

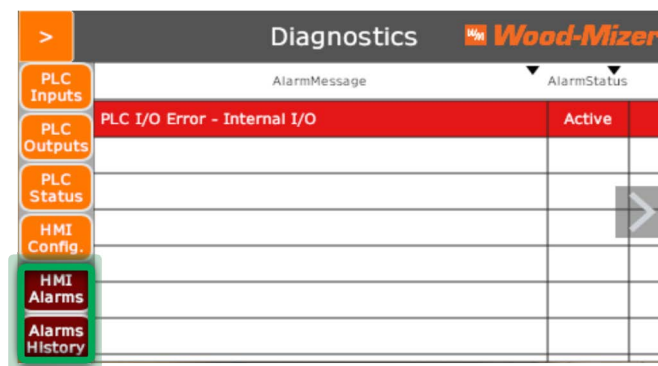


FIG. 3-23

SECTION 4 MAINTENANCE

4.1 General Maintenance



WARNING! Before performing any inspection, lubrication, adjustment, cleaning, or repair, Apply lockout/tagout devices per site procedure.

Never lubricate chains while machine is running.



CAUTION! Pinch points and sharp edges can cause minor to moderate injury.

Keep hands, hair, and loose clothing away from chains, sprockets, and rollers. Use tools/brushes, not hands, to remove debris.

1. Inspect the rollcase, chain sweeps, guards, and surrounding area after every use.
2. Check for and remove sawdust, wood debris, and pitch buildup in:
 - chain guards,
 - sweep channels,
 - roller beds,
 - motor and gearbox areas,
 - electrical enclosures.
3. Inspect for loose, damaged, or missing fasteners, guards, or safety labels.

NOTICE Failure to keep the equipment clean may result in premature component wear, reduced accuracy of sweep operation, and unplanned downtime.

4.2 Sawdust and Debris Removal



WARNING! Clean sawdust from all guards, vents, chain covers, and motor/gearbox areas after **every 8-hour shift**.

1. Remove chain and drive guards as required.
2. Use compressed air or a vacuum to remove debris from:
 - chain drives and sprockets,
 - sweep assemblies,
 - roller shafts and bearing housings,
 - gearmotor housings and ventilation openings.
3. Verify all debris is removed from beneath the machine frame.
4. Reinstall all guards and fully tighten all fasteners before restoring power.

4.3 Grease Bearings Lubrication

Grease points are provided on pillow block bearings supporting the roller shafts, paddle sensors (RCS only) and sweep drive shafts (RCS only).



CAUTION! Do not over-lubricate bearings. Over-lubrication can cause seal failure and bearing overheating.

1. Lubricate greasable bearings **every 250 operating hours**.
2. Clean grease fittings before applying lubricant.
3. Apply Lithium-based NLGI #2 grease slowly until a small amount purges at the seals.
4. Wipe away excess grease.

NOTE: Bearings are factory pre-lubricated. Supplemental lubrication is not required prior to initial service interval. Relubricate only at the recommended intervals.

4.4 Chain Drive Inspection and Lubrication



WARNING! Releasing chain tension can cause sudden movement.

1. Inspect chain **every 40 operating hours**.
 - Check chain tension.
 - Inspect for stiff links, rust, cracking, or elongation.
 - Inspect sprocket teeth for hooking or uneven wear.
 - Verify sprocket alignment.
2. Lubricate chain **every 40 operating hours**.
 - Use a chain lubricant suitable for dusty environments.
 - Apply a light, even coating.
 - Remove excess lubricant to prevent sawdust accumulation.

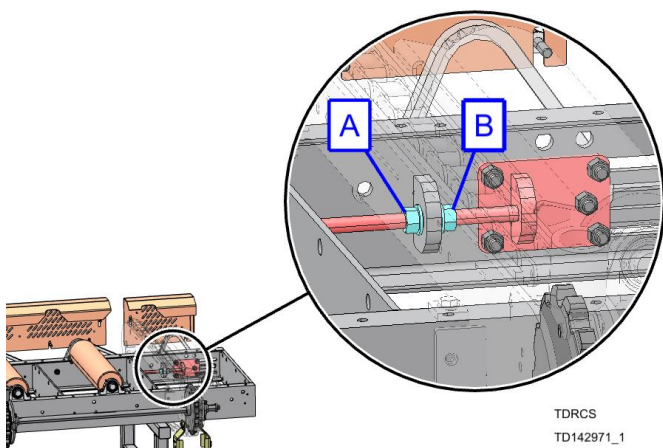
NOTICE Excessively tight chains accelerate wear on bearings, shafts, and gearboxes.

4.5 Chain Tension Adjustment



WARNING! Stored energy in chain tensioner may cause sudden movement during adjustment.

1. Loosen/tighten tensioner fasteners as applicable. See “” on page 2
 - To increase chain tension loosen tensioner nut B and tighten tensioner nut A.
 - To decrease chain tension, loosen tensioner nut A and tighten tensioner nut B.
2. Adjust chain tension to allow slight mid-span deflection.
3. Ensure sprockets are aligned in the same plane.
4. Tighten all fasteners securely.



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FIG. 4-1

5. Run the machine briefly and recheck tension.

NOTICE Replace chain if elongation exceeds allowable limits or if chain engagement is irregular.

4.6 Roller and Sweep Inspection

Inspect rollers and sweep assemblies **every 40 operating hours**.

- Verify rollers rotate freely without binding.
- Inspect roller surfaces for flat spots or excessive wear.
- Inspect sweep assemblies for bending, cracking, or loose attachments.
- Verify sweep travel is smooth and consistent.

NOTICE Damaged rollers or sweeps may cause erratic lumber transfer or sorting errors.

4.7 Gearmotor and Drive Inspection



CAUTION! Gearmotors may be hot during or after operation.

Inspect **every 250 operating hours**.

- Check for oil leaks.
- Inspect mounting bolts for tightness.
- Listen for abnormal noise or vibration.
- Ensure gearbox ventilation openings remain clear of debris.

4.8 Electrical and Control System Inspection



WARNING! Electrical shock hazard. Only qualified personnel may service electrical components.

Inspect **every 250 operating hours**.

- Inspect control enclosures for sawdust accumulation.
- Check wire connections for looseness or discoloration.
- Inspect sensor mounting and alignment.
- Verify cable strain reliefs and conduit fittings are secure.

4.9 Maintenance Chart

Interval	Maintenance Task
Every 8 Hours	Remove sawdust and debris from guards, chains, rollers, motors, and work area
Every 40 Hours	Inspect chains, sprockets, rollers, and sweeps; lubricate chains
Every 250 Hours	Grease bearings; inspect gearmotors; inspect electrical enclosures
Every 1,000 Hours	Inspect chain elongation; inspect sprockets; inspect sweep assemblies for fatigue
Annually or as required	Replace worn chains, sprockets, bearings, and damaged rollers or sweeps