Chain Board Tailer

Safety, Operation, Maintenance & Parts Manual

CBT-430 Tailer **rev. A3.00**

Safety is our #1 concern!

Form #1205

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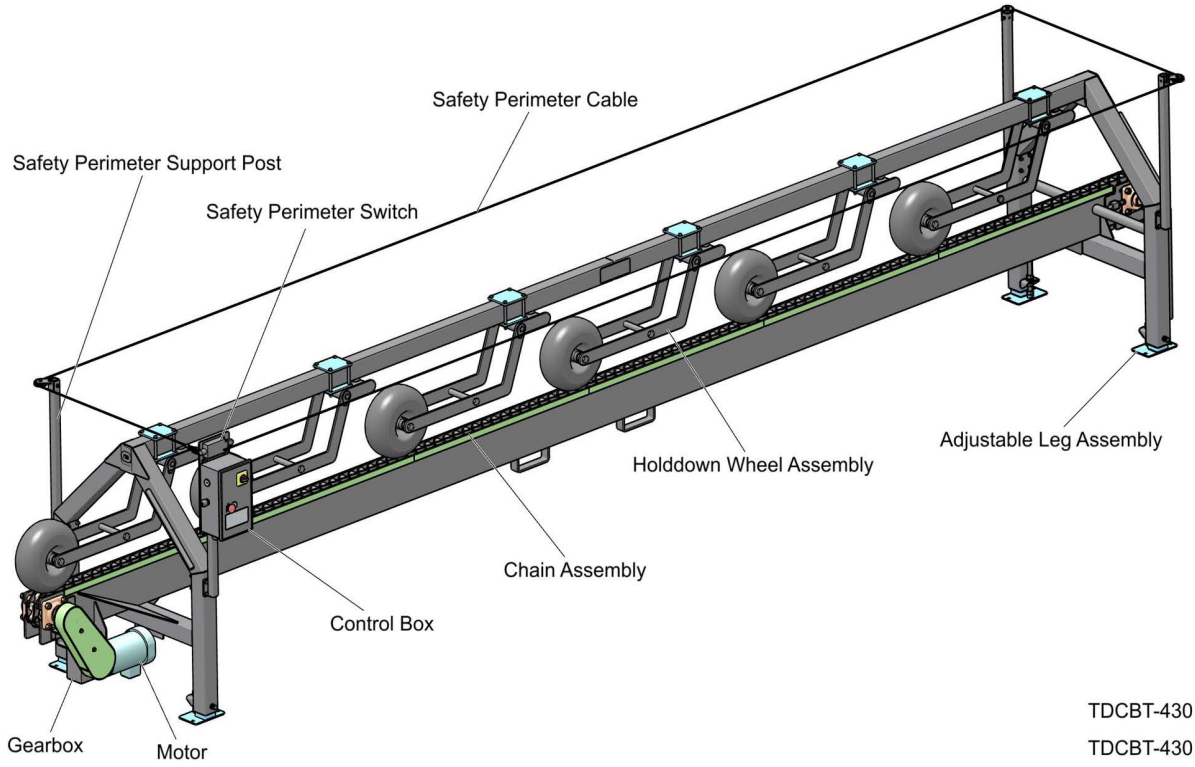
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SECTION 1 INTRODUCTION

1.1 About This Manual

This manual is to replace or to be used with all previous information received concerning the Tailer. 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.



TDCBT-430

FIG. 1-1

1.2 Getting Service

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

General Contact Information

Toll free phone numbers are listed below for the *continental* U.S. and Canada. See the next page for contact information for specific Wood-Mizer locations.

	United States	Canada
Sales	1-800-553-0182	1-877-866-0667
Service	1-800-525-8100	1-877-866-0667
Website	www.woodmizer.com	www.woodmizer.ca
E-mail	woodmizer@woodmizer.com	oninfo@woodmizer.com

Office Hours: All times are Eastern Standard Time. Please remember that Indiana does not observe Daylight Savings Time in the summer.

Monday - Friday	Saturday (Indianapolis Office Only)	Sunday
8 a.m. to 5 p.m.	8 a.m. to 12 p.m.	Closed

Please have your serial number and your customer number ready when you call. The serial number is stamped on the identification tag on the side of the frame.

Wood-Mizer will accept these methods of payment:

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

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

If your equipment was purchased outside the United States or Canada, contact the distributor for service.

Wood-Mizer Locations

USA World Headquarters

Serving North & South America, Oceania, East Asia

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

Phone: 317.271.1542 or 800.553.0182
Customer Service: 800.525.8100
Fax: 317.273.1011
Email: infocenter@woodmizer.com

Canadian Headquarters

Serving Canada

Wood-Mizer Canada
396 County Road 36, Unit B
Lindsay, ON K9V 4R3

Phone: 705.878.5255 or 877.357.3373
Fax: 705.878.5355
Email: ContactCanada@woodmizer.com

Brazil Headquarters

Serving Brazil

Wood-Mizer do Brasil
Rua Dom Pedro 1, No: 205 Bairro: Sao Jose
Ivoti/RS CEP:93.900-000

Tel: +55 51 9894-6461/ +55 21 8030-3338/ +55 51 3563-4784
Email: info@woodmizer.com.br

Europe Headquarters

Serving Europe, Africa, West Asia

Wood-Mizer Industries Sp z o.o.
Nagorna 114
62-600 Kolo, Poland

Phone: +48.63.26.26.000
Fax: +48.63.27.22.327

Branches & Authorized Sales Centers

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

1.3 Customer and Equipment Identification

An identification plate is located on the frame of the saw. The plate contains the serial number and configuration information of your machine. You will also receive a customer number when you purchase your machine.

These numbers will help expedite our service to you. Please locate them now and write them below so you have quick, easy access to them.

Identification Information (To be filled in by purchaser)

Model No. _____

Serial No. _____

Customer No. _____

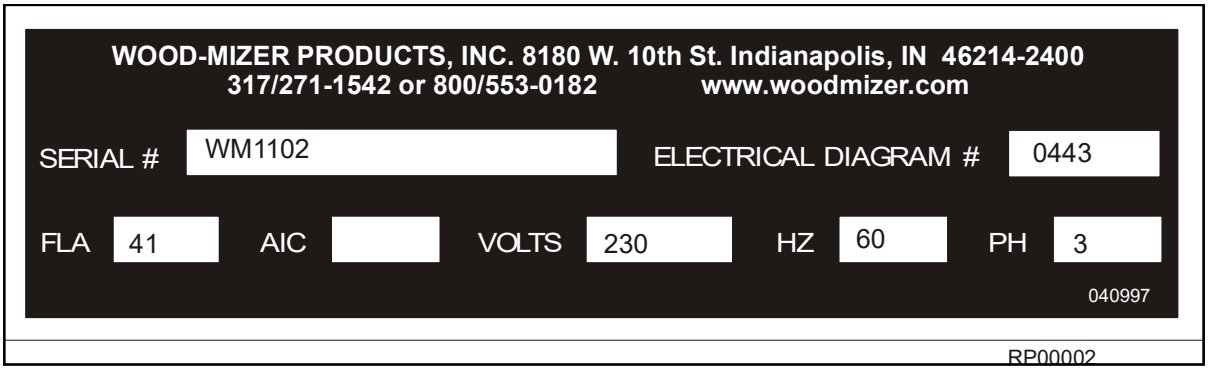


FIG. 1-1

1.4 Tailer Dimensions

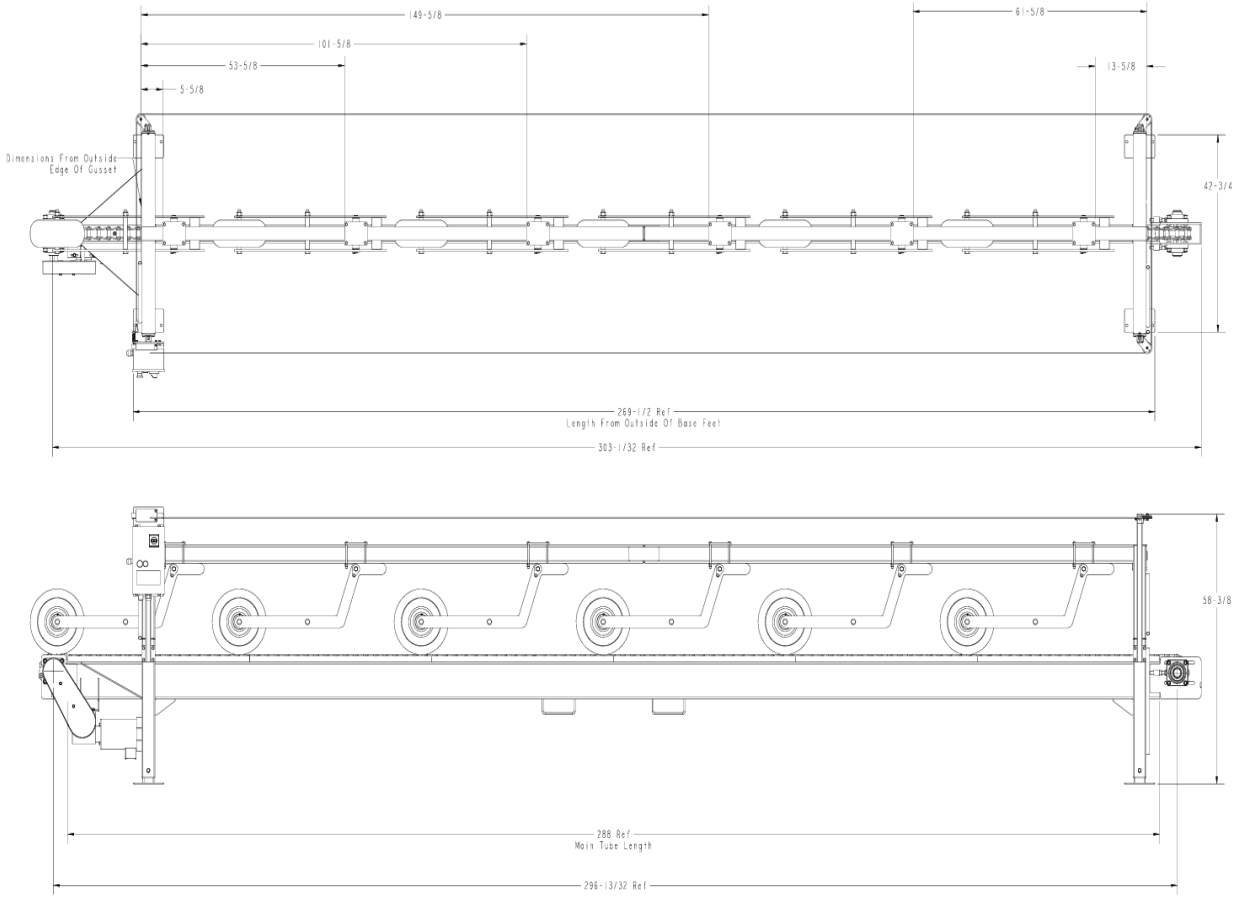


FIG. 1-2

1.5 Specifications

Model: CBT-430 Rev. A3.00

Dimensions

Length: 25' 8-31/32"
Width: 4'-7 59/64"
Height (Ground To Electrical Box): 61 7/8"

Weight:

Basic Unit: lbs.

Capacity:

Board/Slab Length: 2' to 18'

Motor:

Manufacturer: Leeson
Horsepower Rating: 2
RPM: 1725

Rates:

Normal Power Usage: 2.5 Amps, 1.90 kVa or 1.50 kWh
Chain Speed: 200 ft./min.*

Electrical Requirements:

Electrical Service: 460V 3-Phase 50/60Hz 10A
Suggested Wire Size (50' max.): 14AWG

NOTE: Service mains fused disconnect provided by end user. Recommended fusing 10A Time Delay. See Electrical Information Section for schematics.

*Chain speed changed from 100 ft/min. to 200 ft/min. with Rev. A2.00. Use kit 038589 to retrofit previous revisions

TAILER SPECIFICATIONS

SECTION 2 SAFETY

2.1 Safety Symbols

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



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



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



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

NOTICE: indicates vital information.

NOTE: gives helpful 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.

OBSERVE SAFETY INSTRUCTIONS

NOTICE: Read the entire Owner's Manual before operating the Tailer. 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 Tailer. The Tailer 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 and operation of your Conveyor. All owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the Conveyor.



SETUP

WARNING! Use extreme care and proper equipment to lift and move the tailer. Lift under the base of the machine only. Failure to do so may result in personal injury and/or machine damage.

WEAR SAFETY CLOTHING

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

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



KEEP TAILER AND AREA AROUND TAILER CLEAN

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

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 TAILER BEFORE OPERATION

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



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

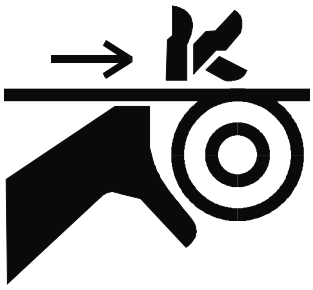
KEEP PERSONS AWAY

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

KEEP HANDS AWAY

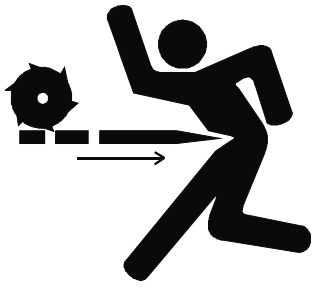
DANGER! Moving Parts Can Crush and Cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating or towing. Failure to do so may result in serious injury.

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

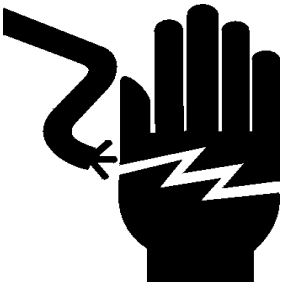
WARNING! Kickback Hazard. Stay clear of area during operation. Follow all anti-kickback service and safety rules. Failure to do so may result in serious injury.



USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND 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 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 Tailer 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.

DANGER! Lockout procedures must be used during:

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

Maintenance hazards include:

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

Failure to lockout may result in:

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

To control maintenance dangers:

Lockout procedures must be followed (see ANSI Standard Z244.1-1982 and 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.

Tailer LOCKOUT PROCEDURE

Lockout procedures must be followed (see ANSI Standard Z244.1-1982 and OSHA regulation 1910.147).

Purpose:

This procedure establishes the minimum requirements for lockout of energy sources that could cause injury.

Responsibility:

The responsibility for seeing that this procedure is followed is binding upon all workers. All workers shall be instructed in the safety significance of the lockout procedure. It is your responsibility to ensure safe operation of the machine.

Sequence of Lockout Procedure:

1. Notify all persons that a lockout is required and the reason therefore.
2. If the Tailer is operating, shut it down by the normal stopping procedure.
3. Operate the switch so that the energy sources are disconnected or isolated from the Tailer. Stored energy such as moving blades and feed system shall be dissipated.
4. Lockout the energy isolating devices with assigned individual locks.
5. After ensuring that no persons are exposed and as a check on having disconnected the energy sources, operate the push button or other normal operating controls to make certain the Tailer will not operate. Caution: Return operating controls to neutral position after the test.
6. The Tailer is now locked out.

Restoring Equipment to Service

1. When the job is complete and the Tailer is ready for testing or normal service, check the Tailer area to see that no one is exposed.
2. When the Tailer is all clear, remove all locks. The energy isolating devices may be operated to restore energy to the Tailer.

Procedure Involving More Than One Person

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

Rules for Using Lockout Procedure

The Tailer 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.

Owner'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 AWMV Products 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 Tailer.

SECTION 3 SETUP AND OPERATION

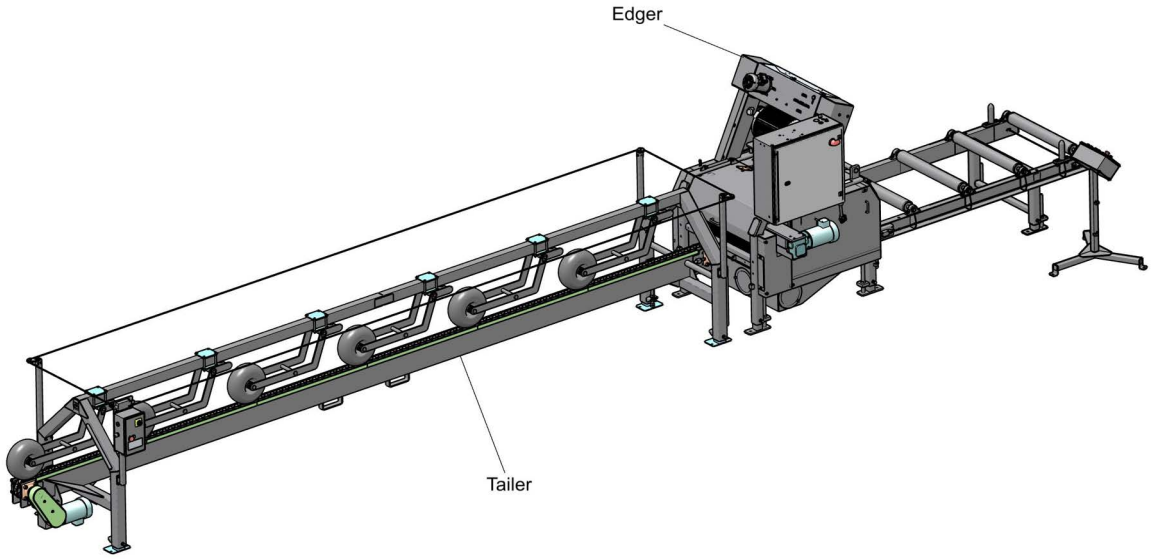
3.1 Setup

Use a forklift or other appropriate equipment to move the tailer.

WARNING! Use extreme care and proper equipment to lift and move the tailer. Lift under the base of the machine only. Failure to do so may result in personal injury and/or machine damage.

Place the tailer on a concrete foundation strong enough to support the weight of the machine. Allow for room around the unit.

1. Place the tailer on the outfeed side of the edger as shown below.
2. Align the tailer drive chain so it is positioned in the center of the edger and boards from the edger can get on the tailer without obstruction.

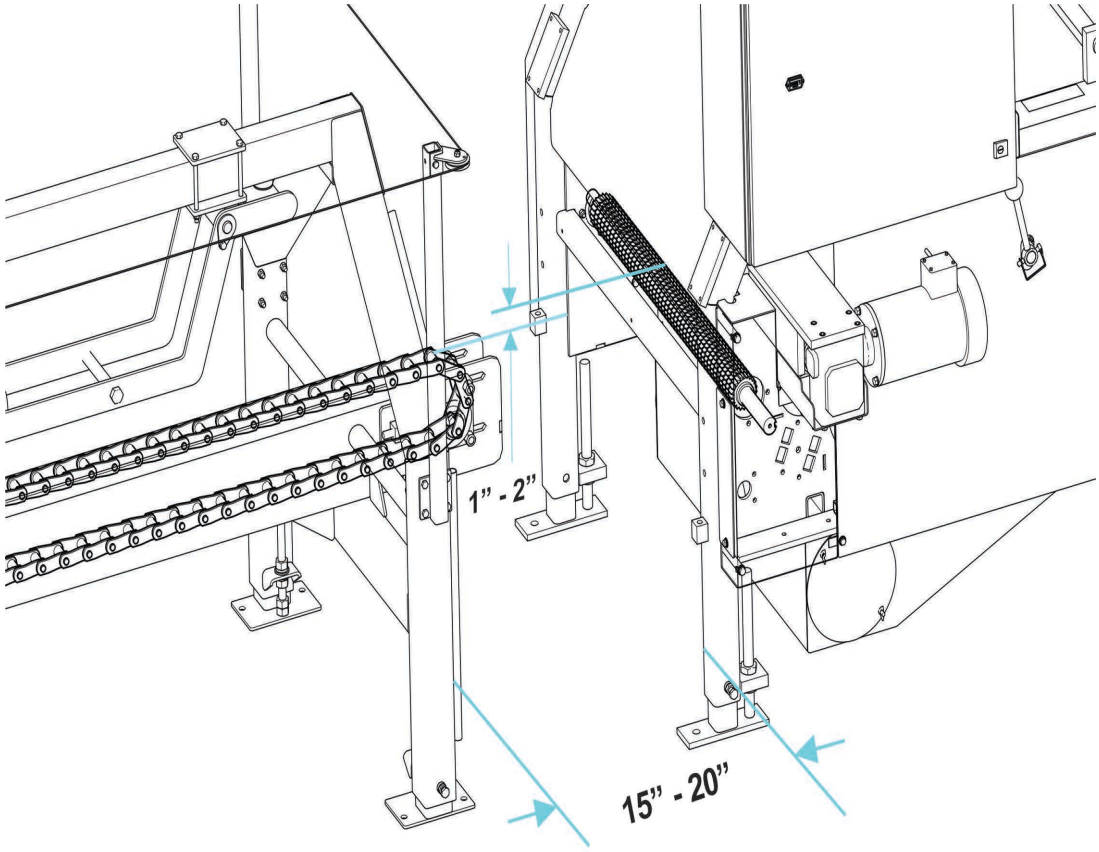


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FIG. 3-1

3. Position the tailer approximately 15” to 20” away from the edger.

4. Measure that the tailer drive chain is approximately 1” to 2” lower than the upper edge of the edger outfeed rollers to allow for a slight drop of boards from the edger.

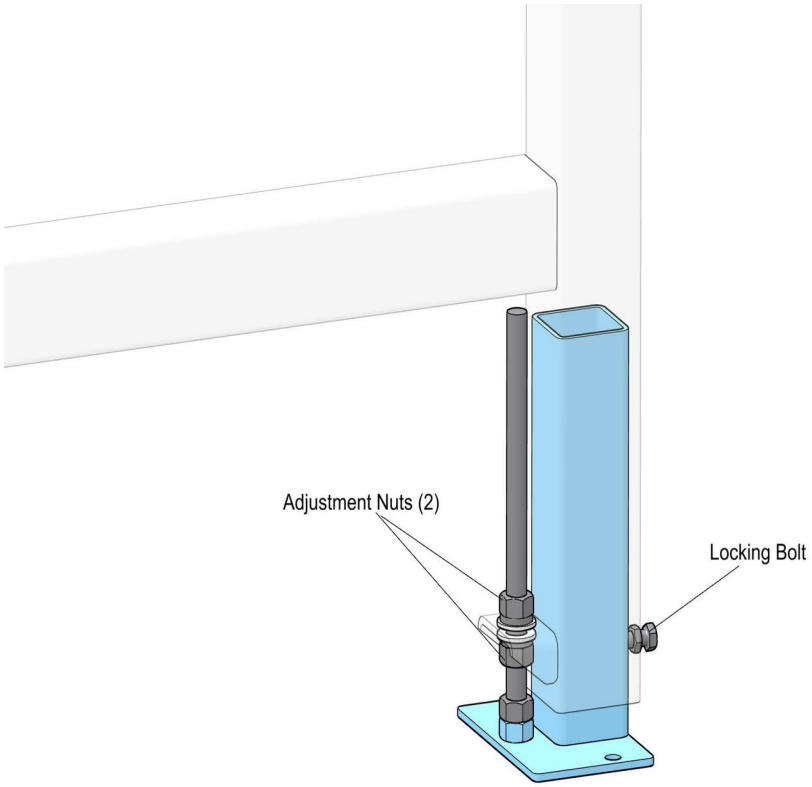


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FIG. 3-2

5. Adjust the tailer legs so the feet firmly contact the ground.
6. Loosen the locking bolt.
7. Turn the adjustment nuts counterclockwise to raise the tailer, turn the adjustment nuts clockwise to lower the tailer.
8. Level the unit before securing.



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FIG. 3-3

9. Tighten the adjustment nuts when the height adjustment is complete.
10. Secure the leg with the locking bolt.
11. Secure the tailer to the foundation with anchor bolts.

3.2 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 operation.



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.

WARNING! Always shut off the motor to stop the chain whenever the tailer is not in use. Failure to do so may result in serious injury.

Perform the following steps prior to operating the tailer to make the required electrical connections:

1. Open the electrical box installed to the Tailer.

2. Locate the disconnect switch in the upper right corner inside the tailer electrical box.
3. Unplug the hole in the right side of the electrical box.
4. Route the power supply cable through the hole.
5. Connect the power supply wires to the disconnect switch in the electrical box.

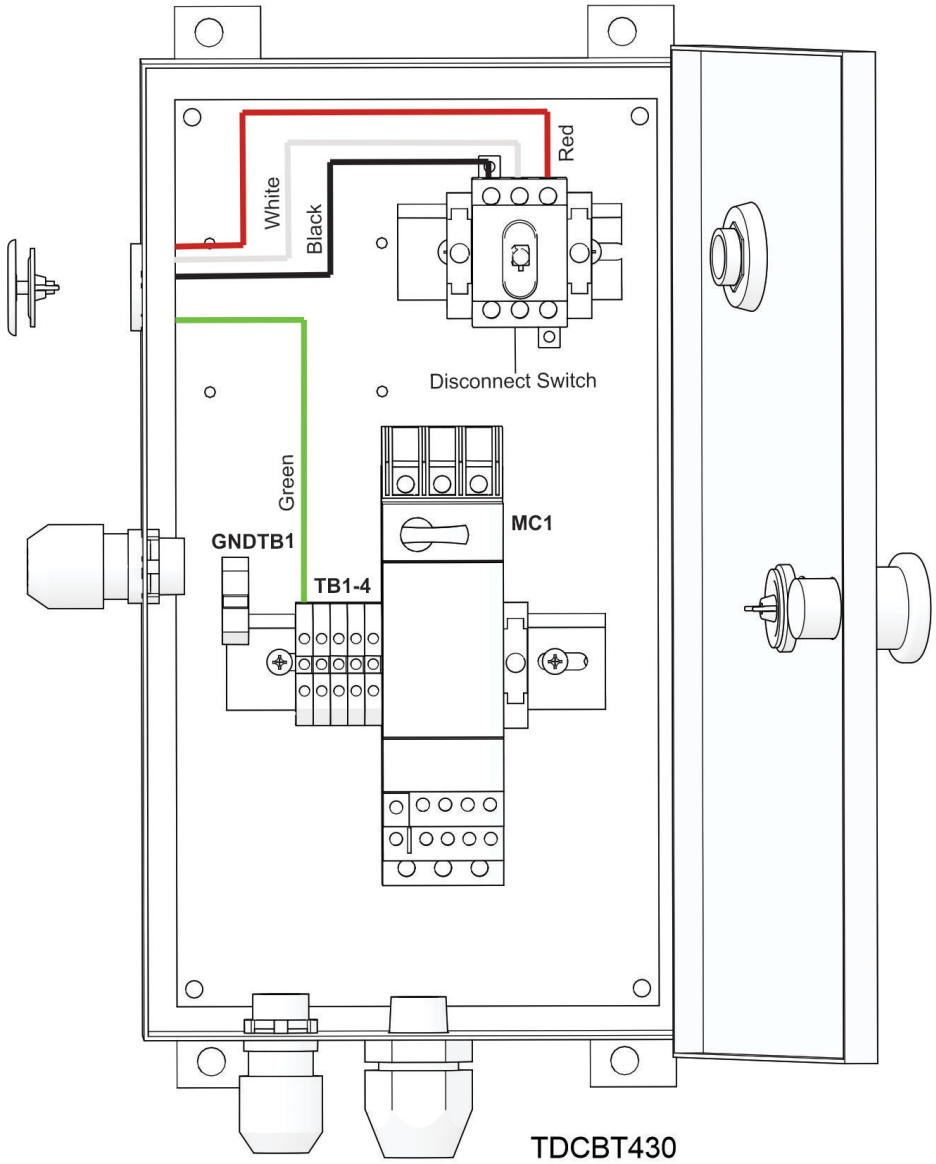


FIG. 3-4

6. Connect the tailer to the Edger electrical box.
7. To connect, remove the feed drive fixed guard from the left side of the Edger.
8. Route the tailer cable through the cable tube on the Edger.
9. Open the Edger electrical box and remove the hole plug located in the bottom of the box.
10. Install the provided black connector to the hole.
11. Secure the connector with the provided connector nut.
12. Route the tailer cable to the inside of the Edger electrical box through the black connector.

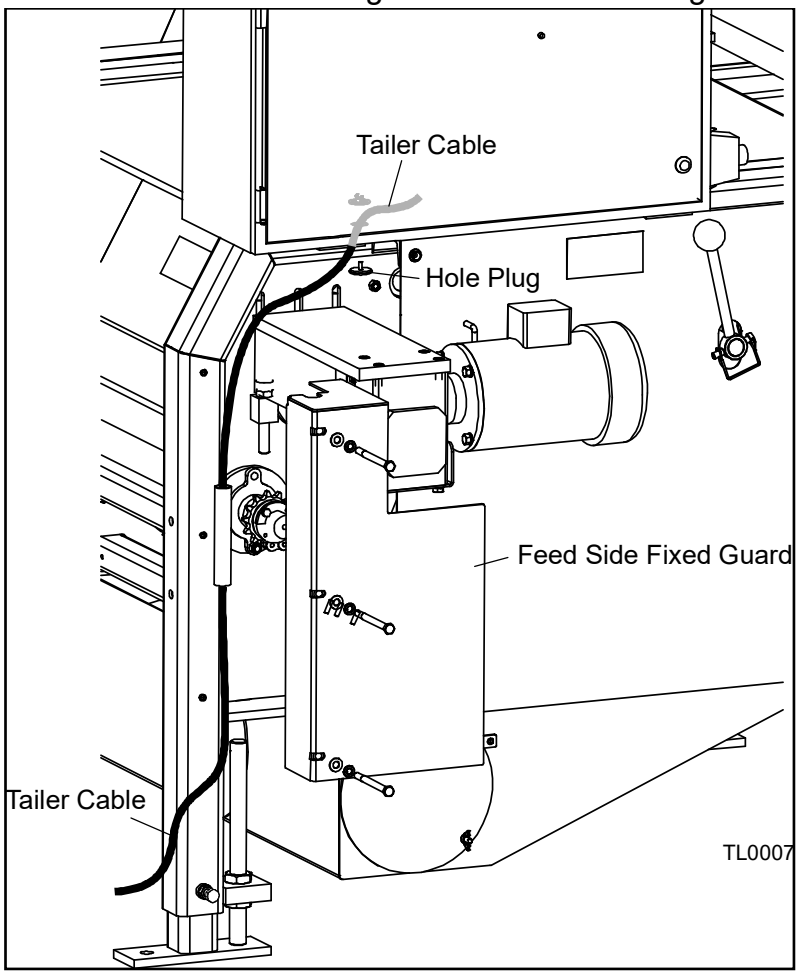


FIG. 3-5

13. Reinstall the feed side fixed guard to the Edger.

14. Install the provided white connector to the tailer cable inside the Edger electrical box.

The tailer cable wire connections are shown below.

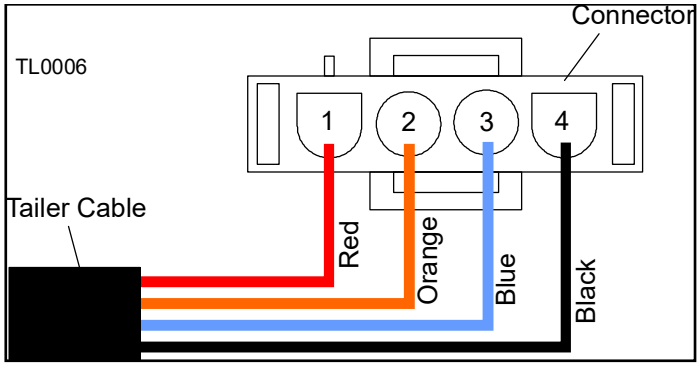


FIG. 3-6

15. Locate the existing plugged Edger/Tailer cable on the bottom of the Edger electrical box.

16. Unplug and connect the Edger/Tailer cable to the tailer cable to complete the electrical installation.

17. See Electrical Information Section for schematics.

18. Close the Edger electrical box.

3.3 Starting And Stopping The Machine

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

DANGER! Always be sure all persons are away from the tailer before starting the motor. Failure to do so will result in serious injury.

WARNING! Always wear eye, ear, respiration, and foot protection when operating the tailer. Failure to do so may result in serious injury.

1. If necessary, release the E-STOP button by turning it clockwise until it pops out.

   The front of the tailer electrical box has a disconnect switch to power on the tailer.

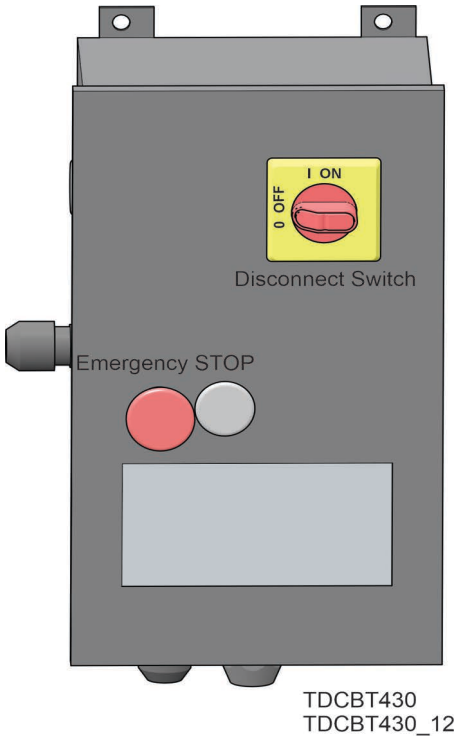


FIG. 3-1

2. To turn the tailer power on, turn the disconnect switch to the ON position.

   NOTE: It is necessary to have the edger powered on to operate the tailer. To turn the edger power on, push the green MACHINE-START button on the edger control box. See the edger Owner's Manual to check how to operate the edger.

   NOTE: The covers and the electrical cabinet must be closed before the edger can be started.

The emergency switches on the electrical box can be used to shutdown the tailer.

1. Push the E-STOP button in an emergency to stop the tailer drive chain.
2. This button must be released by turning clockwise before the tailer can be restarted.

   IMPORTANT: The E-STOP button shuts down both the tailer and the edger at the same time.

Pull out the emergency red wire around the tailer whenever it is necessary to shut down the tailer and the edger.

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 a synthesized hydrocarbon formulated 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.

WoodMizer offers replacement gear oil in 8 ounce bottles.

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.

4.2 Tensioning the Chains

1. Adjust the infeed drive chain tension as needed.
2. Locate the adjustment bolts at the front of the tailer on both sides of the frame.
3. Use the adjustment bolts to adjust the infeed drive chain tension as described below.

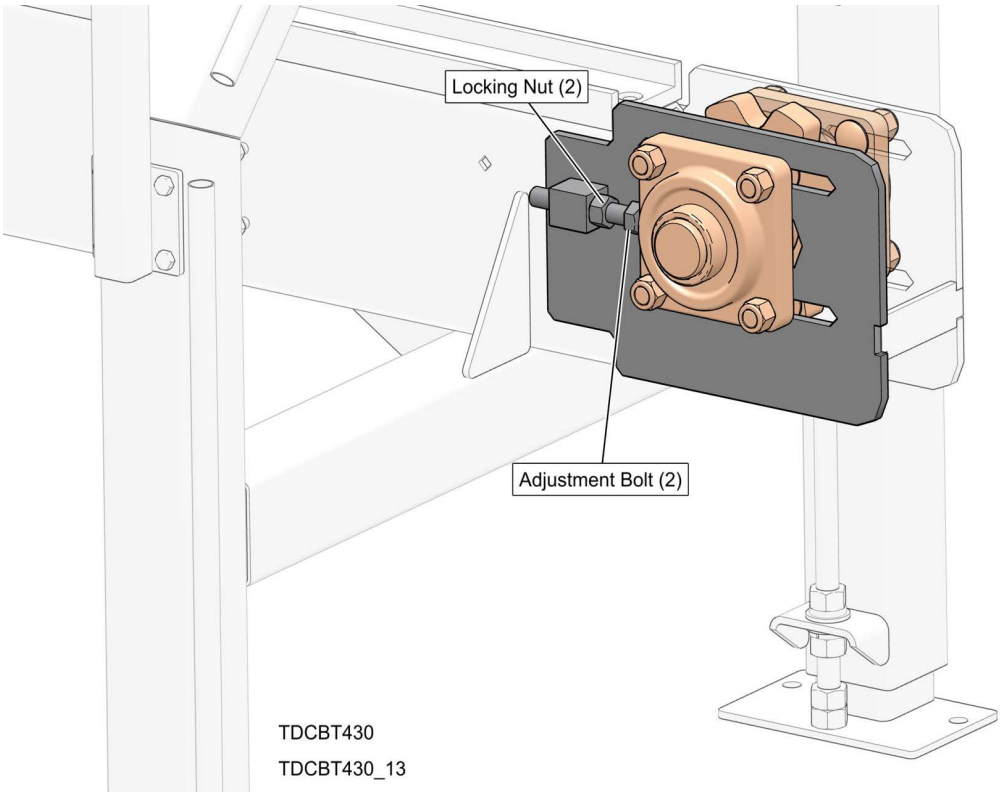


FIG. 4-1

To adjust the infeed drive chain tension:

1. Loosen the infeed drive chain bearing mounting bolts.
2. Turn the adjustment bolts counterclockwise to tension the infeed drive chain.
3. Turn the adjustment bolts clockwise to loosen the infeed drive chain.
4. Secure the adjustment bolts with the locking nuts when the chain tensioning procedure is complete.

Periodically check the tailer motor drive chain tension and adjust **as needed**. The chain needs to be adjusted if the chain slack exceeds 1" (25.4mm).

To check the motor drive chain tension:

1. Always make sure the motor is not running.
2. Loosen the two bolts securing the drive chain guard as shown below.
3. Remove the guard from the tailer.

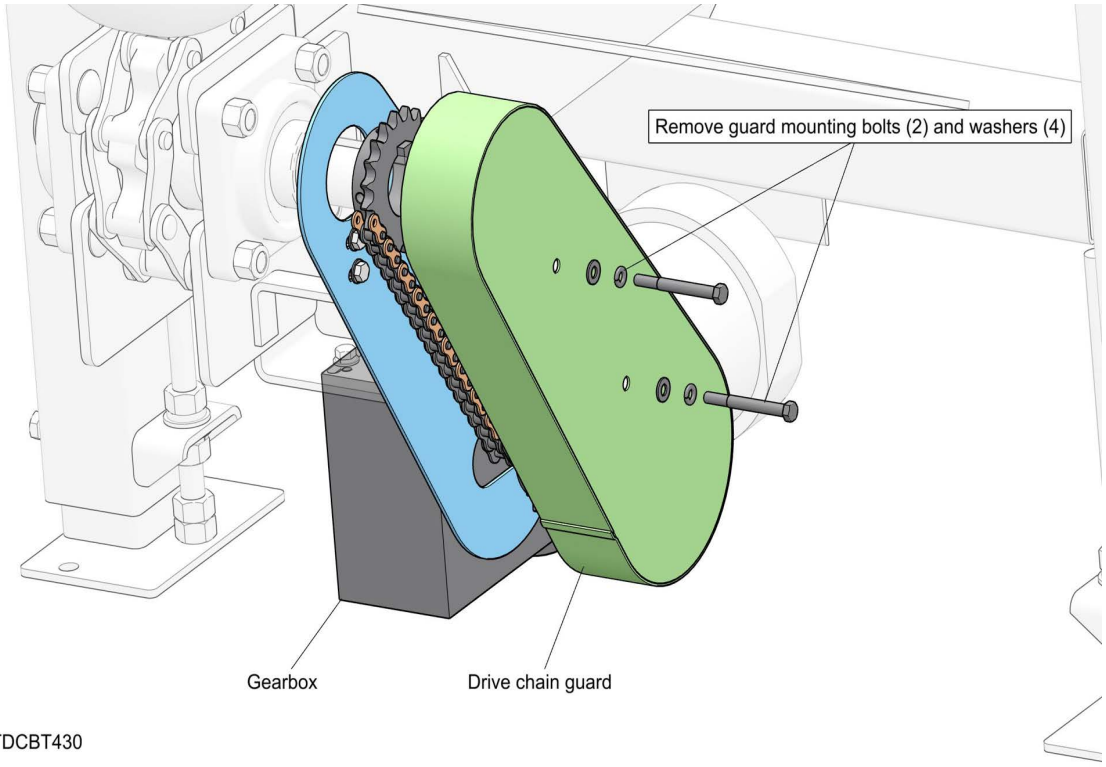
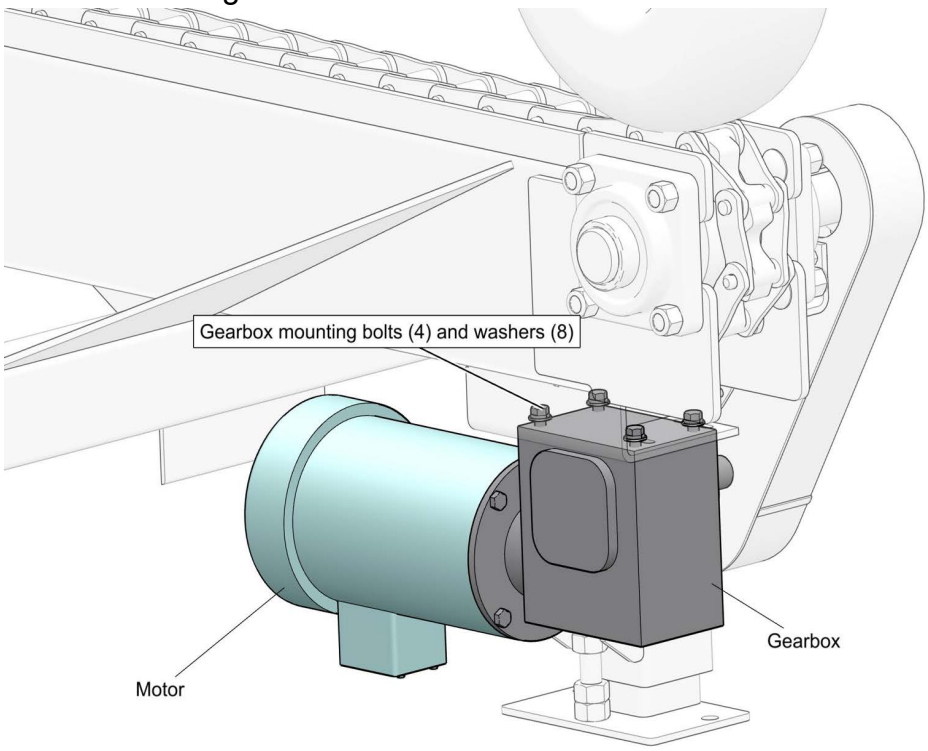


FIG. 4-2

The properly tensioned chain can be deflected 1/2" (12.7mm) in the center of the chain. If necessary follow the instructions below.

To adjust the motor drive chain:

1. Make sure the motor is not running.
2. Loosen the four adjustment bolts (4) securing the tailer gearbox to the mount motor/gearbox bracket.
3. Move the gearbox and motor to adjust the drive chain until the center of the chain can be deflected 1/2" (12.7mm).
4. Use gearbox mounting bolts to tension the motor drive chain.



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FIG. 4-3

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

5. After the drive chain has been adjusted, tighten the gearbox adjustment bolts (4).
6. Reinstall the drive chain guard and secure in place with the guard mounting bolts (2).

4.3 Lubrication

1. 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.

SECTION 5 REPLACEMENT PARTS

5.1 How To Use The Parts List

- 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.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77. The diamond (◆) indicates M06666 is not available except in subassembly K05555.

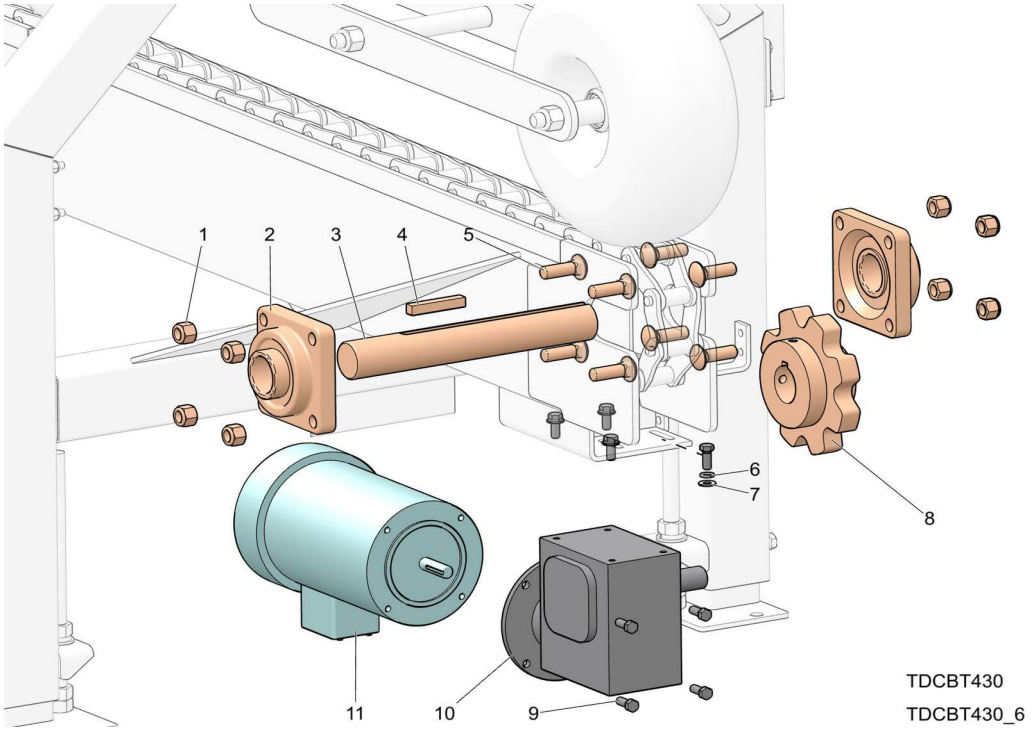
5.2 Sample Assembly

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SAMPLE ASSEMBLY, COMPLETE (Includes All Indented Parts Below)	A01111	1	
1	Sample Part	F02222-22	1	
2	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
	Sample Part (Indicates Part Is Only Available With A03333)	S04444-4	1	◆
3	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
	Sample Part (Indicates Part Is Only Available With K05555)	M06666	2	◆
4	Sample Part	F07777-77	1	

To Order Parts:

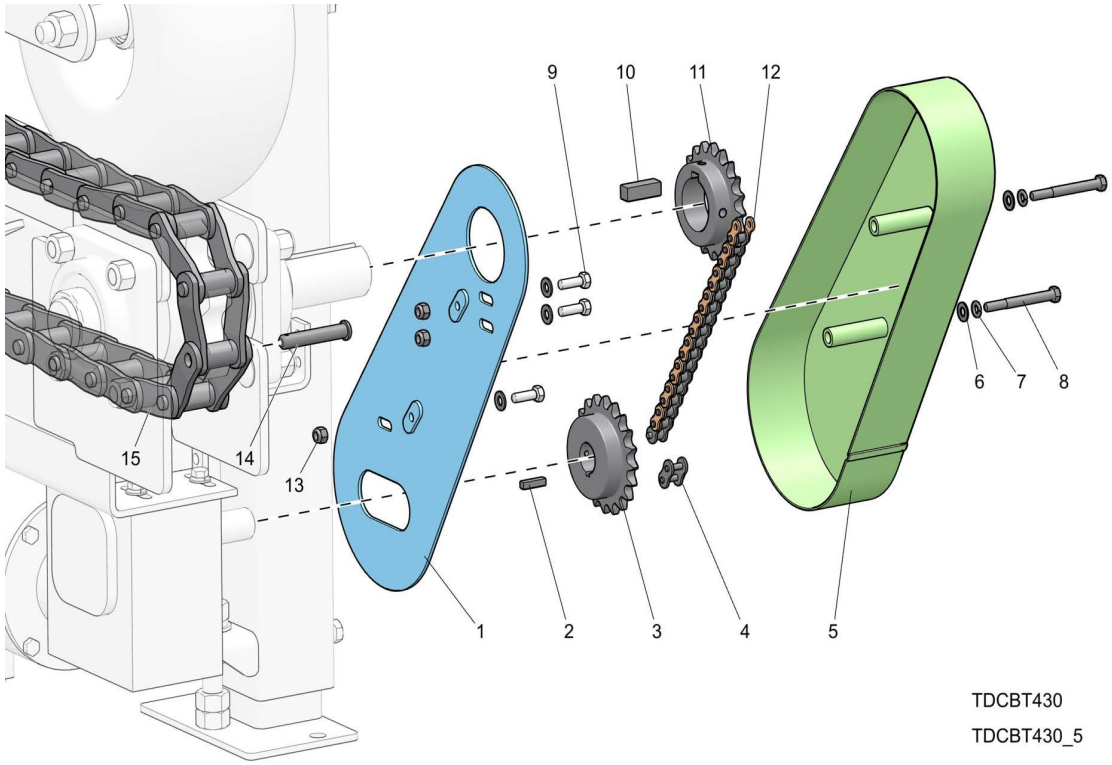
From the continental U.S., call ***1-800-525-8100*** to order parts. Have your customer number, VIN, and part numbers ready when you call. From other international locations, contact the AWMV distributor in your area for parts.

5.3 Outfeed, Drive Side



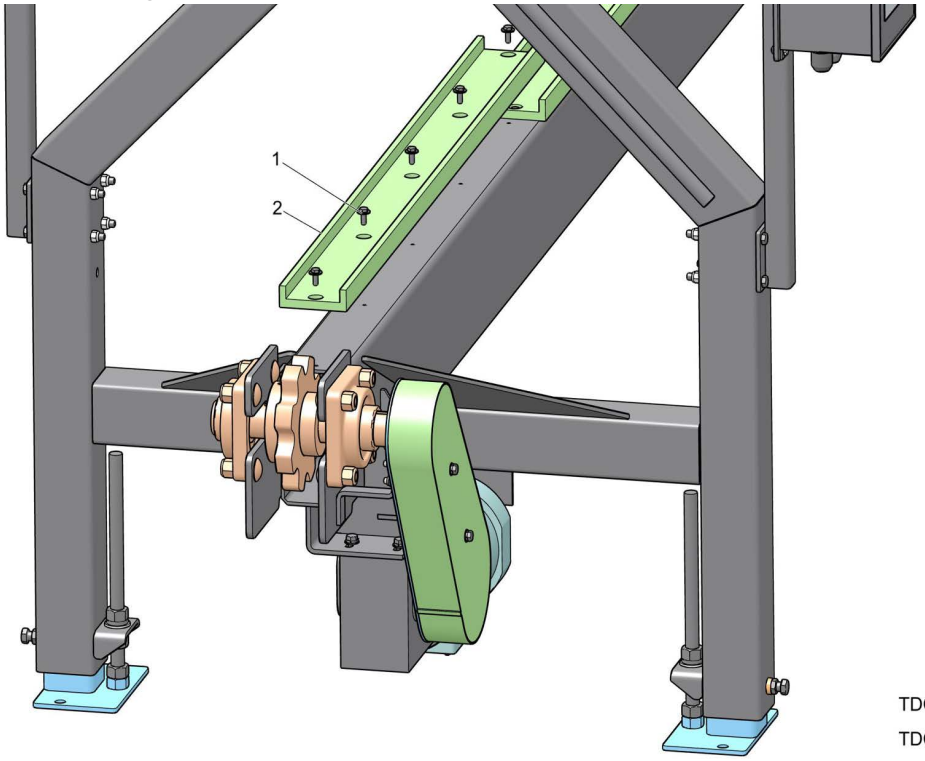
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05010-34	Nut, 5/8-11 Nyl Lock		8
2	033712	Bearing, 1 15/16 4-Bolt Flange		2
3	051387	Shaft, Drive End		1
4	S12249	Key, 1/2x1/2x3		1
5	F05009-116	Bolt, 5/8-11x2 Gr5 Carriage		8
6	F05011-4	Washer, 3/8 Split Lock		4
7	F05011-3	Washer, 3/8 Flat SAE		4
8	033716	Sprocket Assy, Drive WR7808		1
	F05008-9	Screw, 1/2-13x1 OP Nyl Insert Socket Set		2
9	F05007-87	Bolt, 3/8-16x1 Gr5 HH		8
10	051444	Gearbox, BMQ224 15:1 Right		1
11	079197	Motor, 2HP 3P 230/460 56C Premium Eff		1

5.4 Outfeed Drive Cover and Chain



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	048033	Guard Wldmt, Drive Rear		1
2	S21486	Key, 1/4x1		1
3	038564	Sprocket, 50B20x1 1/8		1
4	P20208	Link, #50 Master		1
5	048038	Guard Wldmt, Front Chain		1
6	F05011-17	Washer, 5/16 SAE Flat		5
7	F05011-13	Washer, 5/16 Split Lock		2
8	F05006-62	Bolt, 5/16-18x3 HH Gr5		2
9	F05006-27	Bolt, 5/16-18 x 1 Gr 5 HH		3
10	033738	Key, 1/2 Sqx1 1/2		1
11	048028	Sprocket, 50B20x1 15/16		1
12	048039	Chain, Roller, #50x39-3/8 (63 Pitches)		1
13	F05010-58	Nut, 5/16-18 Nyl Lock		3
14	017643	Pin, Connecting WR78 Chain		6
15	145737	Chain, WR78 x 235P; 613-1/8"		1

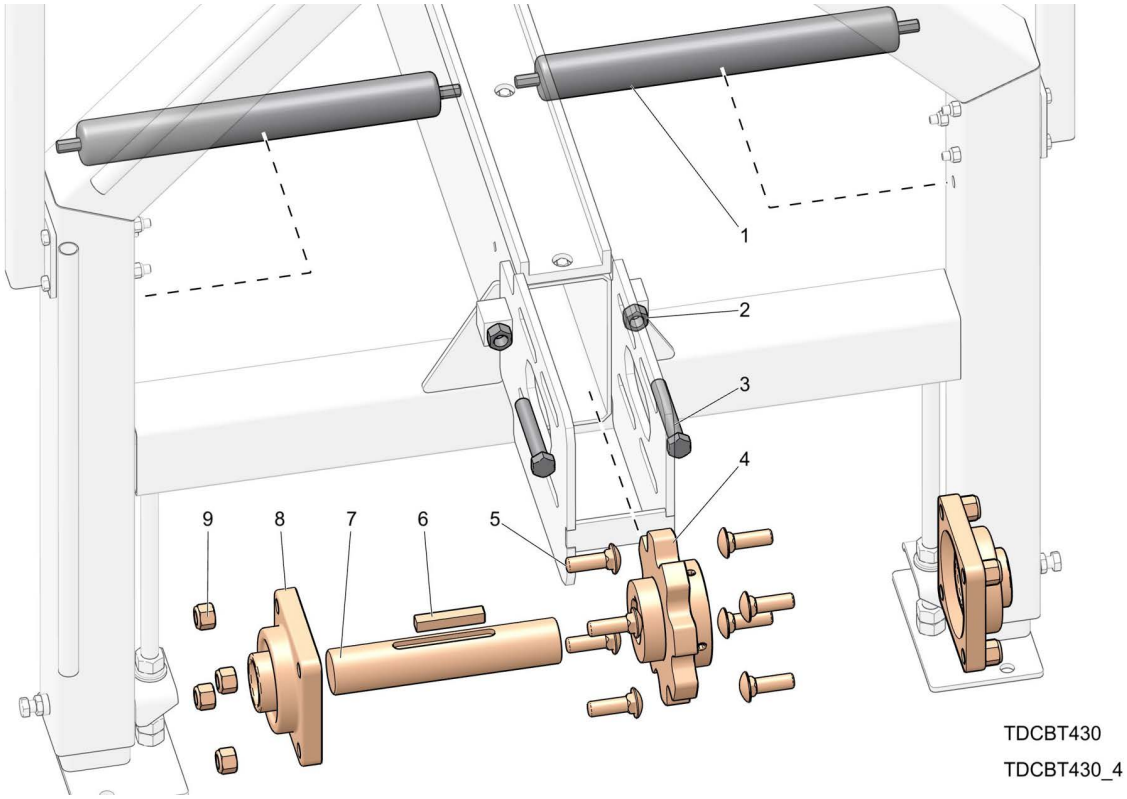
5.5 Channel Assembly



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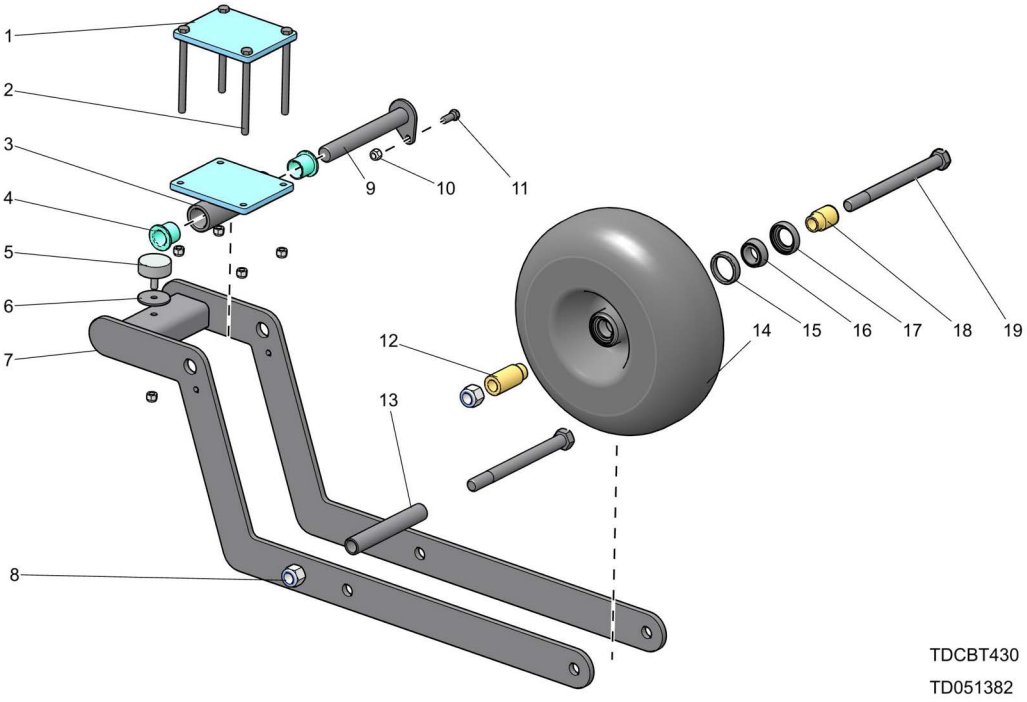
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05005-207	Bolt, 1/4-20x3/4 W/Conical Washer & Patch		30
2	033722	Channel, UHMW Conveyor		6

5.6 Infeed, Idle Side



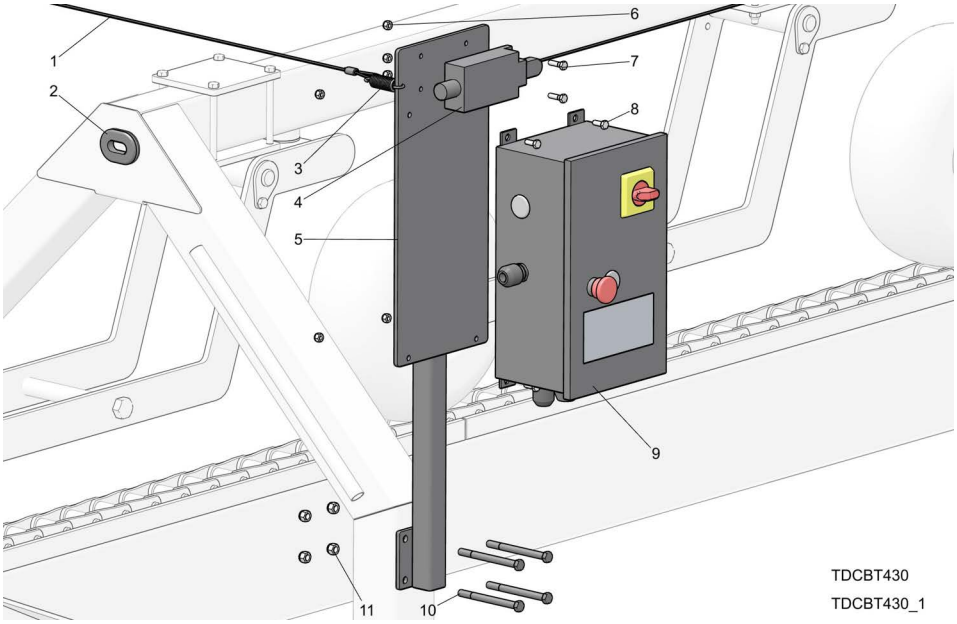
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	051399	Roller, 1.90 ODx15.75		2
2	F05010-5	Nut, 5/8-11 Hex		2
3	F05009-8	Bolt, 5/8-11x4 HH FT		2
	051385	Sprocket Assy, Idler, Tailer		1
4	033716	Sprocket Assy, Drive WR7808		1
	036718	Sprocket Wldmnt, Drive WR7808		1
	F05008-9	Screw, 1/2-13x1 OP Nyl Insert Socket Set		2
5	F05009-116	Bolt, 5/8-11x2 Gr5 Carriage		8
6	S12249	Key, 1/2x1/2x3		1
7	051512	Shaft, Idle End		1
8	033712	Bearing, 1 15/16 4-Bolt Flange		2
9	F05010-34	Nut, 5/8-11 Nyl Lock		8

5.7 Hold-Down Wheel Assembly



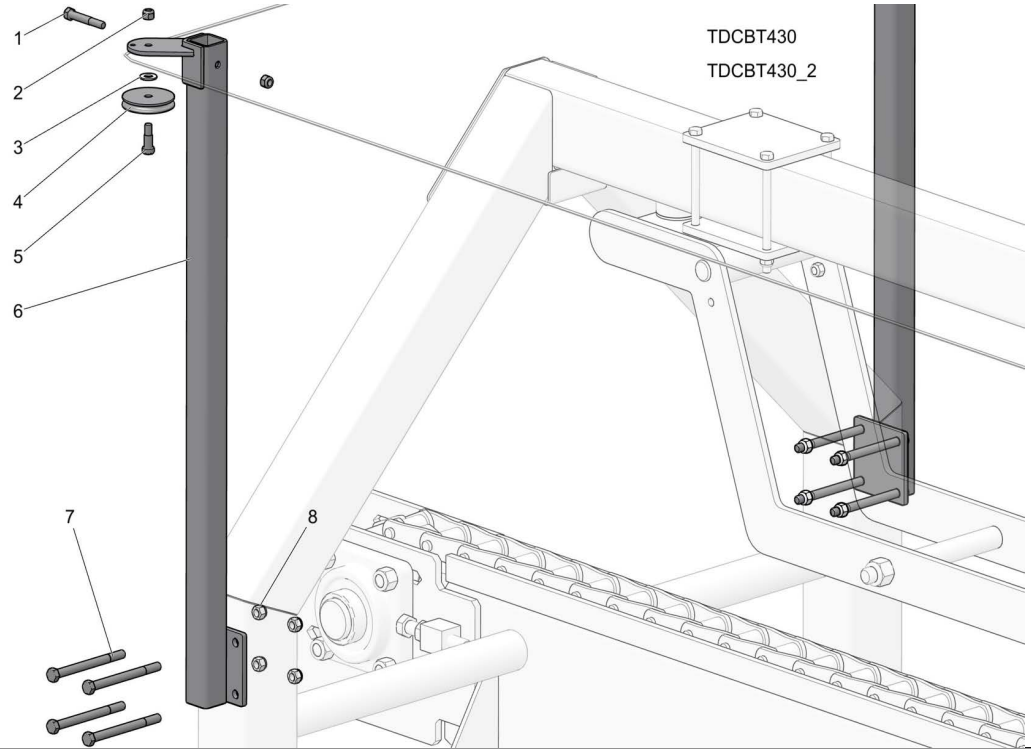
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	051382	Assy, Tailer Holddown Wheel		6
1	051381	Plate, Mount 5x6x3/8		2
2	F05007-101	Bolt, 3/8-16x5 1/2 HH Gr5		4
3	051390	Pivot Wldmt, Wheel Mount		1
4	P109	Bushing, 1 IDx1-1/4 ODx1-1/4 Fl		2
5	034175	Bumper, Table		1
6	054081	Plate, Bumper Spacer		1
7	048031	Bracket Wldmt, Wheel Mount		1
8	F05010-103	NUT, 3/4-10 NYLOCK		2
9	047367	Pin Wldmt, Hold-Down Pivot		1
10	F05010-10	Nut, 3/8-16 Hex Nyl Lock		6
11	F05007-87	Bolt, 3/8-16x1 Gr5 HH		1
12	047436	Spacer, 3/4IDx1-1/4OD Long		1
13	047383	Tube, .82IDx1.05ODx6-13/16		1
14	019107	Wheel, 15x6-6.00 Air Filled		1
15	P289	Insert, Brg Race 1in TRB Brg		2
16	P190	BEARING, 1IN ID TAPERWD ROLLER		2
17	P191	Seal, 1-1/4 ID Bearing		2
18	047435	Spacer, 3/4IDx1-1/4OD Short		1
19	F05013-6	Bolt, 3/4-10x9 Gr5 HH		2

5.8 Safety Perimeter Switch and Electrical Box



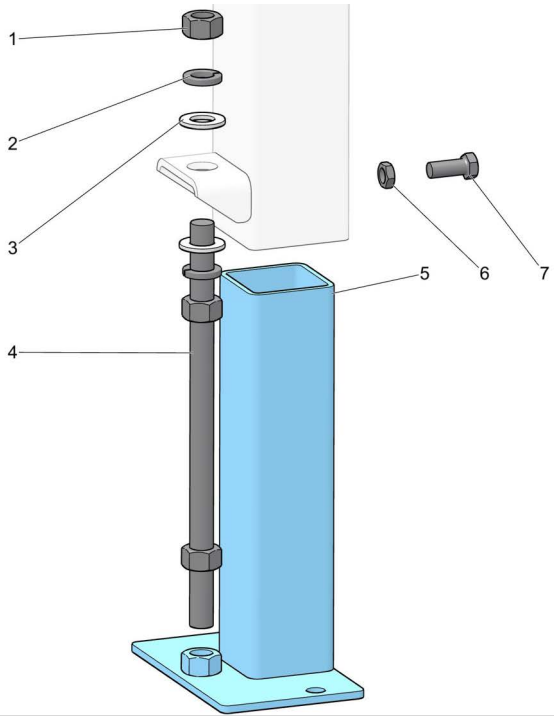
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	145734	Assy, Safety Switch Cable		1
2	085613	Grommet, Rubber, 1 x 1 3/4 Oval		2
3	015479	Spring, 3/4x2 7/8x12Ga		1
4	051300	Switch, Perimeter Safety		1
5	047387	Post Wldmt, Control Mount		1
6	F05010-69	Nut, 1/4-20 Nylock		6
7	F05005-101	BOLT, 1/4-20 X 1 HEX HEAD GR5		2
8	F05005-123	Bolt, 1/4-20x3/4 HH Gr5		1
9	025292_LID	Part, New		4
10	F05007-35	Bolt, 3/8-16x4 1/2 Hex Head Gr5 Zinc		4
11	F05010-10	Nut, 3/8-16 Hex Nyl Lock		4

5.9 Safety Perimeter Posts



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	047392	Bracket Assy, E-Stop Cable		3
1	F05006-30	Bolt, 5/16-18x2 1/4 HH		2
2	F05010-58	Nut, 5/16-18 Nyl Lock		1
3	F05011-3	Washer, 3/8 Flat SAE		1
4	P07996	Pulley, 2 1/2 Nylon		1
5	F05007-79	BOLT, 3/8X5/8 SHOULDER, ZN		1
6	047384	Post Wldmt, E-Stop Support		3
7	F05007-35	Bolt, 3/8-16x4 1/2 Hex Head Gr5 Zinc		12
8	F05010-10	Nut, 3/8-16 Hex Nyl Lock		12

5.10 Tailer Feet



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REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05010-7	NUT, 3/4-10 FREE HEX ZN		12
2	F05011-6	Washer, 3/4 Split Lock		8
3	F05011-62	Washer, 3/4 SAE Flat		8
4	048025	Rod, 3/4-10 x 13-5/8		4
5	051438	Foot Wldmt, Tailer		4
6	F05010-31	Nut, 1/2-13 Zinc Jam		4
7	F05008-37	Bolt, 1/2-13x1 1/4 Hex Head GR5 Zinc		4

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Symbol Diagram

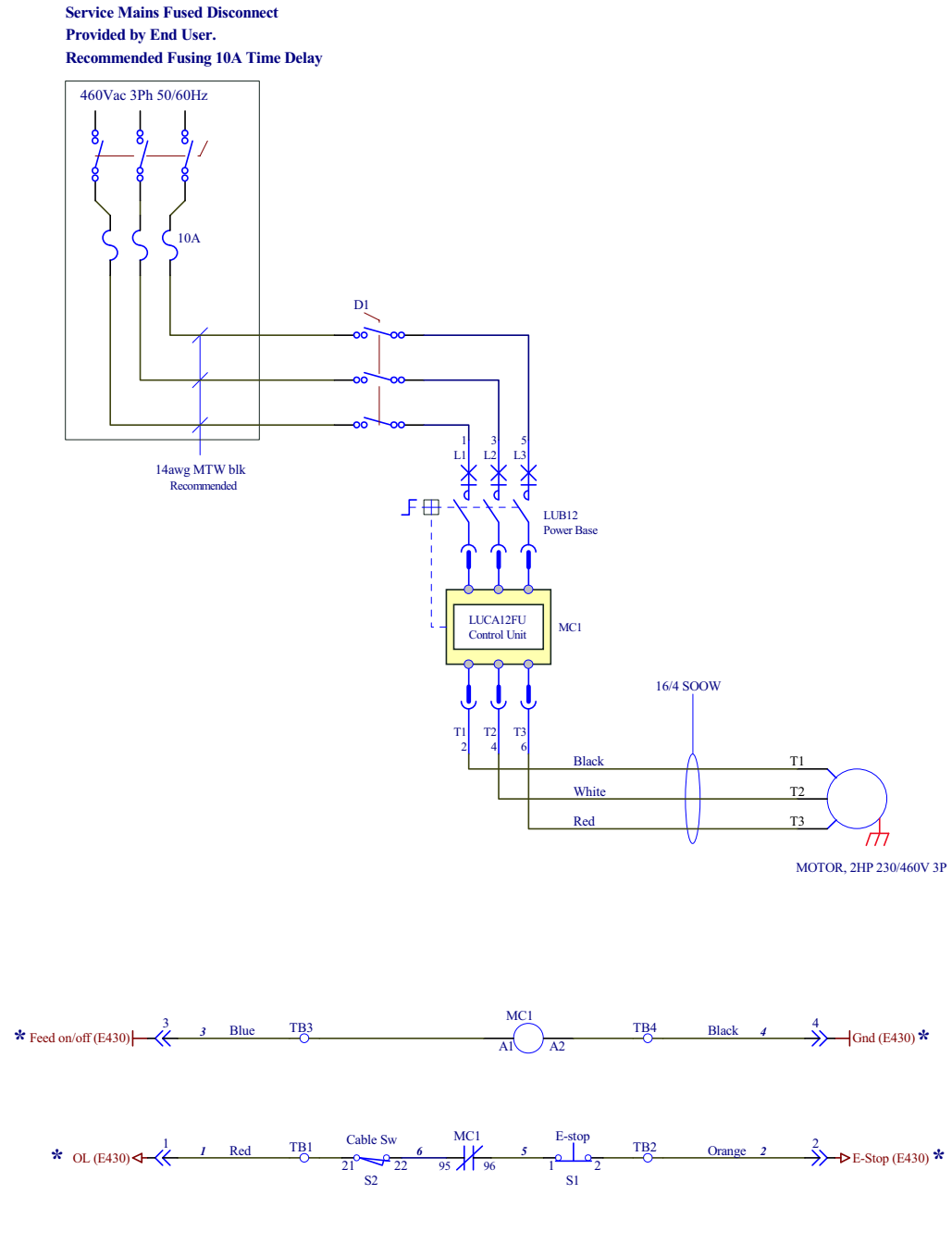


FIG. 6-1 SYMBOL DIAGRAM

6.2 Electrical Component List

Component	AWMV Part No.	Description
D1	050903-1	Disconnect, 40A 3P Non-Fused 6mm
MC1-1	051995	Contactor, Phase Barrier
MC1-2	051993	Contactor, 12A Power Base
MC1-3	051994	Contactor, 1.25-5A 3P Control
MC1-4	052386	Contactor, 1NO 1NC U-Line Auxiliary
S1	024945	Switch, PB E-Stop Red
S2	051298	Switch, Cable Pull Normal Stop
TB1-4	024893	Terminal Block, 2 Tier Phoenix
GNDTB1-2	051344	Terminal Block, Green/Yellow Grounding
M1	042390	Motor, 2HP 230/460V 3P

6.3 Component Layout Diagrams

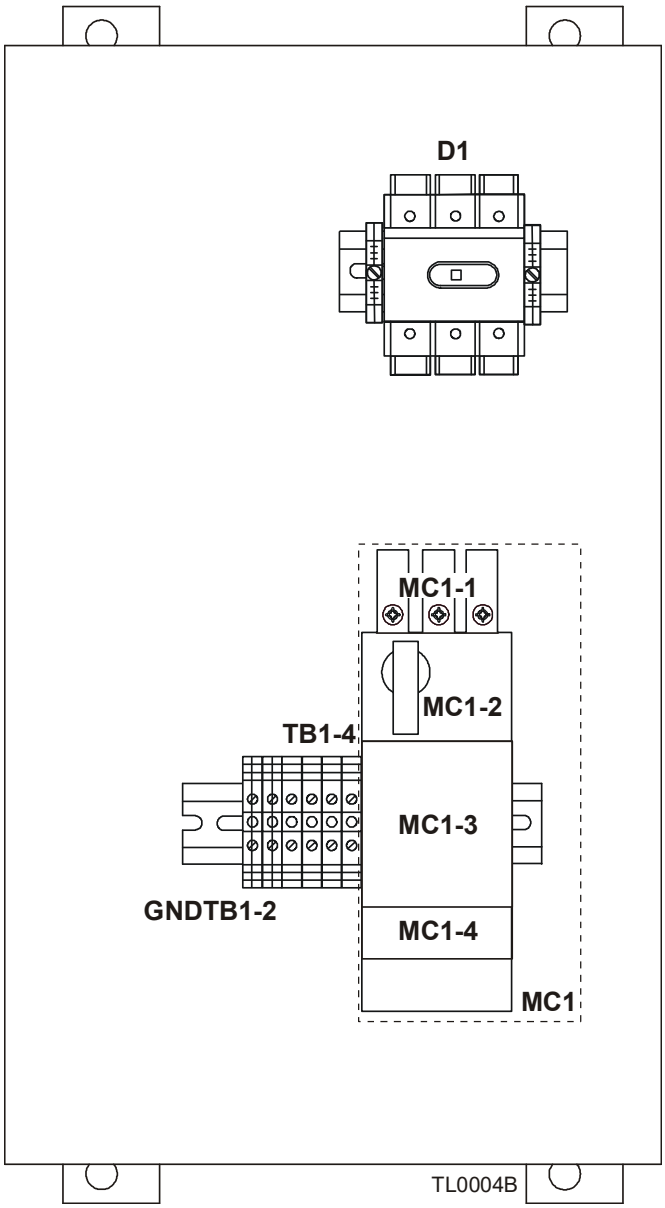


FIG. 6-2

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