

Wood-Mizer® Gullet
Safety, Operation, Maintenance
& Parts Manual

Gullet Grinder

rev. C.00

Safety is our #1 concern!

October 2023

Form #1758



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	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 GENERAL 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

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.

 **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.

WEAR SAFETY CLOTHING


 **WARNING!** Secure all loose clothing and jewelry before operating the equipment.

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


Wear hand protection while servicing the equipment blades.

Wear respiratory protection when sawing woods that require it. (It is up to the sawyer to know which woods require respiratory protection.)

HANDLE FUEL/LUBRICANTS SAFELY


 **DANGER!** Due to the flammable nature of fuel and oil, never smoke, weld, grind or allow sparks near your engine or storage tanks, especially during times of fueling.


Do not allow fuel to spill on a hot engine during fueling operations or otherwise.

 **WARNING!** Store gasoline away from sawdust and other flammable materials.

Do not use flammable fuels or liquids such as diesel fuel. Use **ONLY** water and Wood-Mizer Lube Additive with the water lube accessory.


EQUIPMENT SETUP

 **DANGER!** Do not operate the equipment without **all** covers and guards in place.


 **WARNING!** Set up the equipment on solid, level ground.

Keep all persons out of the area between the frame rails while loading and unloading the equipment.


CHECK EQUIPMENT BEFORE OPERATION

 **DANGER!** Ensure all guards and covers are in place and secured before operating or towing the equipment.

Use the safety retainer pin and cable to fasten blade housing covers.


 **WARNING!** Do not operate the equipment without the bed end retaining brackets properly installed; the saw head may fall from the log bed.

KEEP PERSONS AWAY


 **DANGER!** Keep all persons out of the path of moving equipment and logs when operating equipment or loading and turning logs.

Ensure the blade is disengaged and all persons are out of the path of the blade before starting the engine or motor.

KEEP HANDS AWAY

 **DANGER!** Remove power before clearing debris or any other maintenance activity.

Disengage the blade and shut off the equipment engine before changing the blade.

 **WARNING!** Avoid contact with any hot parts (motors).

Allow the system to cool sufficiently before beginning any service function, including debris removal.

Avoid contact with sharp edges of the cutting blades.

Stay a safe distance from rotating members (shafts, pulleys, fans, etc.) and ensure loose clothing or long hair does not engage rotating members


Do not spin the blade wheels by hand. Spinning the blade wheels by hand may result in serious injury.

Disengage the clutch/brake mechanism whenever the equipment is not cutting.

Do not adjust the engine drive belt with the engine running.

Keep hands, feet, etc., clear of exiting sawdust chute when operating equipment.

UP/DOWN SYSTEM SAFETY

 **WARNING!** Secure the saw head with a chain with a minimum of 1900 lbs. working load capacity before adjusting the up/down chain.

Release pressure from the up/down assist prior to performing any service to the assembly. Parts are under tension and may fly apart.

Do not disassemble the pressurized cylinder. Parts are under pressure and may fly apart or damage the cylinder.


KEEP SAFETY LABELS IN GOOD CONDITION

NOTICE Ensure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local

distributor, or call your Customer Service Representative to order more decals.


NOTICE If replacing a component that has a safety decal affixed to it, ensure the new component also has the safety decal affixed in the same place.

KEEP MILL AND AREA AROUND MILL CLEAN


 **WARNING!** Maintain a clean and clear path for all necessary movement around the mill and material stacking areas.

Do not allow children in the area of the mill.

GAS OR DIESEL ENGINE OPERATION

 **DANGER!** Operate your engine/machine only in well ventilated areas.


Do not operate an engine with a fuel or oil leak.


 **WARNING!** Do not operate engine without proper and operational spark arrester/muffler.

DISPOSE OF WOOD BY-PRODUCTS PROPERLY

NOTICE Properly dispose of all wood by-products, including sawdust, chips, and other debris, including operation waste such as oil, filters, etc.

WORKING WITH BATTERIES


 **DANGER!** Batteries expel explosive gases; keep sparks, flames, burning cigarettes, or other ignition sources away at all times.

 **WARNING!** Always wear safety goggles and a face shield when working near batteries.

Wash hands after handling batteries to remove possible lead, acid, or other contaminants.

Charge the battery in a well ventilated area.

Do not attempt to charge a frozen battery.

 **CAUTION!** Do not overcharge the battery. Overcharging may reduce the overall service life of the battery.

Ensure the battery is fully charged before transporting the equipment. If the battery is not fully charged, excessive vibration could reduce the overall service life of the battery.

NOTICE When working with batteries, use extreme care to avoid spilling or splashing electrolyte (dilute sulfuric acid) as it can destroy clothing and burn the skin.

EMERGENCY TREATMENT FOR CONTACT WITH BATTERY COMPONENTS (LEAD/SULFURIC ACID) per SDS (Safety Data Sheet):

EYE CONTACT	Sulfuric Acid and Lead: Flush eyes immediately with large amounts of water for at least 15 minutes while lifting lids. Seek immediate medical attention.
SKIN CONTACT	Sulfuric Acid: Flush affected area(s) with large amounts of water using deluge emergency shower, if available, shower for at least 15 minutes. Remove contaminated clothing, including shoes. If symptoms persist, seek medical attention. Wash contaminated clothing before reuse. Discard contaminated shoes. Lead: Wash immediately with soap and water.
INGESTION	Sulfuric Acid: Administer large amounts of water. Do NOT induce vomiting or aspiration into the lungs may occur and can cause permanent injury or death; consult physician.
INHALATION	Sulfuric Acid: Remove to fresh air immediately. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Consult a physician. Lead: Remove from exposure, gargle, wash nose and lips; consult physician.

2.3 Electrical Lockout Procedures

RULES FOR USING LOCKOUT PROCEDURE

The equipment 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, BUT NOT LIMITED TO:

- 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, BUT NOT LIMITED TO:

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

FAILURE TO LOCKOUT MAY RESULT IN, BUT NOT LIMITED TO:

- Cut
- Crush

- Blindness
- Puncture
- Electrocutation
- Serious injury and death
- Amputation
- Burn
- Shock

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.

EQUIPMENT 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 flywheels, 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 equipment, **each shall place his own personal lock on the energy isolating devices.**

SECTION 3 GENERAL INFORMATION

3.1 Component ID

Major components of the Gullet Grinder are shown below.

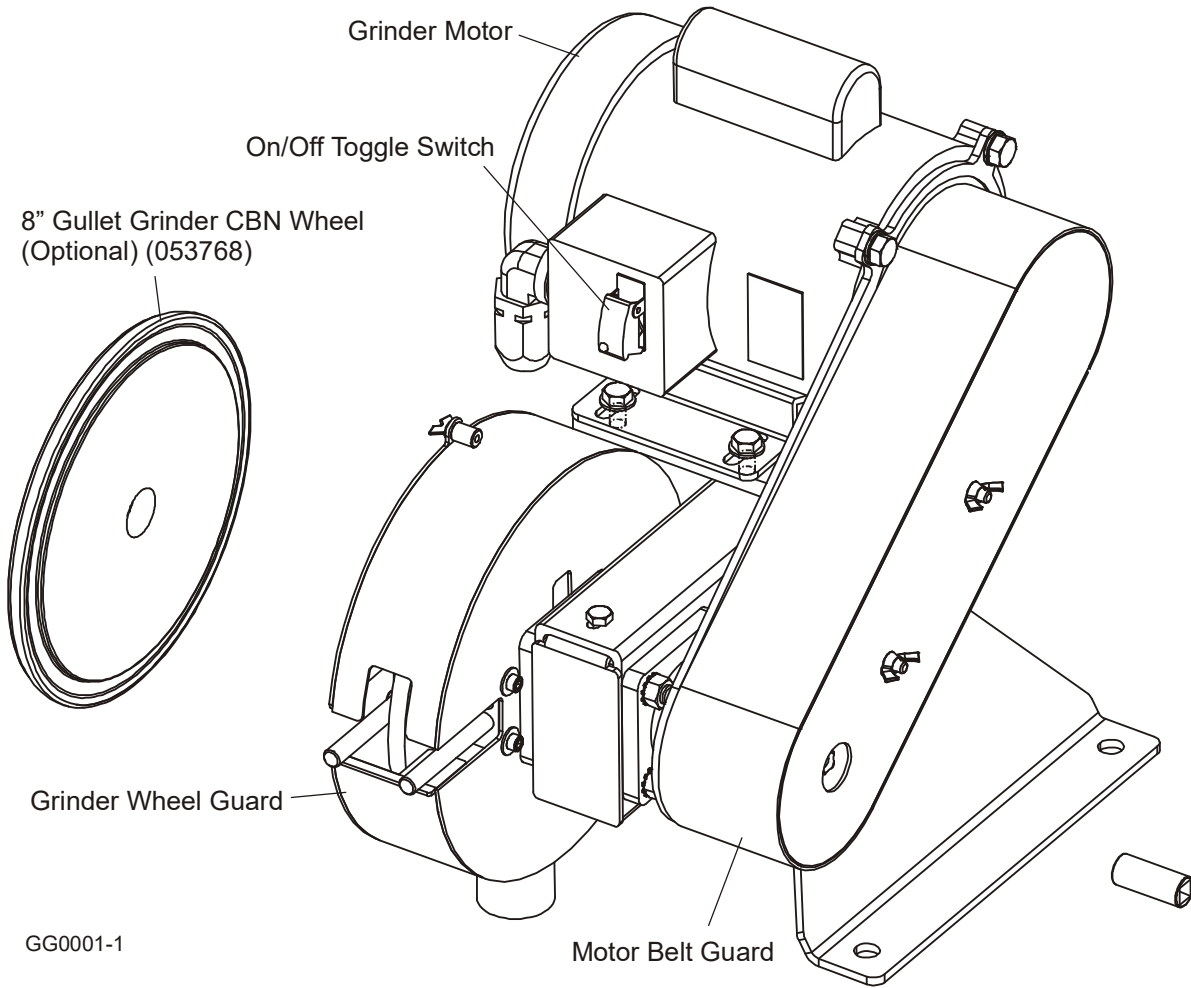


FIG. 3-1

3.2 Dimensions

Dimensions of the Gullet Grinder are shown below.

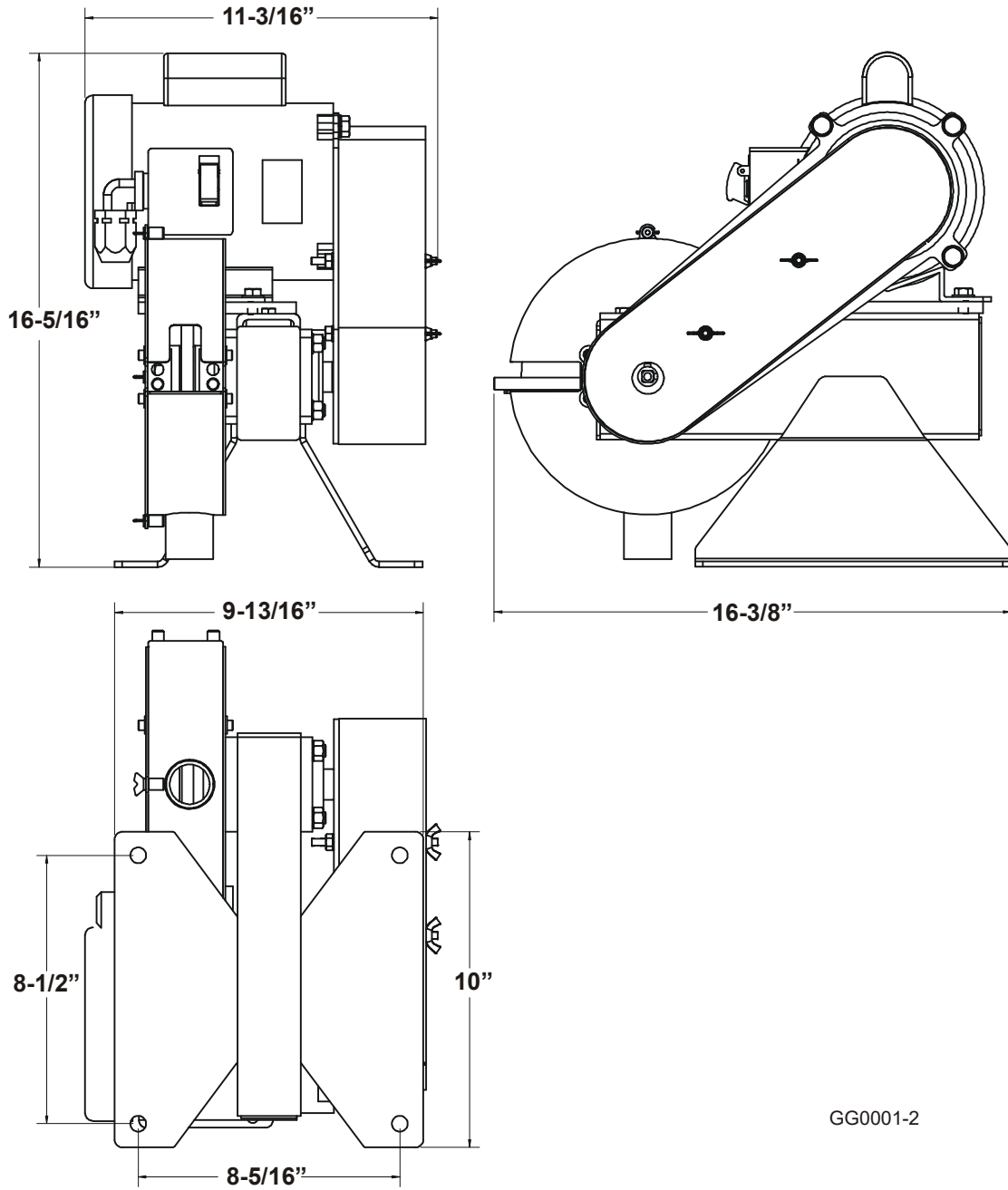


FIG. 3-2

SECTION 4 SETUP & OPERATION

4.1 Setup

Place the grinder on a table or workbench sturdy enough to support the weight of the machine. Be sure there is enough room on either side of the grinder to allow for the blade to be handled. Secure the grinder to the workbench.

Electrical Connection

Plug the power cord from the motor electrical box into a grounded 110-120 volt receptacle.



DANGER! For the user's safety, the power cord on this product has a grounded plug. This power cord should only be used with correctly grounded (3-hole) receptacles to avoid electrical shock.

4.2 Operation



WARNING! Always wear gloves and eye protection when handling bandsaw blades. Keep all other persons away from area when coiling, carrying or changing a blade. Failure to do so may result in serious injury.

Turn the ON/OFF switch to the ON position to start the grinder motor. Position the blade so the blade rests on the block pins in the grinding wheel guard opening. Grind the blade gullet with multiple passes to receive best results and to prevent burning. Turn the ON/OFF switch to the OFF position to stop the grinder motor when you finished grinding.

4.3 Grinding Wheel Installation

Remove the grinding wheel guard wing studs (3) and outside guard to access the grinding wheel. Place the provided plug socket at the other end of the shaft to hold the shaft in place. Unscrew the hex head bolt from the grinding wheel shaft and remove the bolt and wheel spacer. Remove the grinding wheel from the grinder.

Install the appropriate Wood-Mizer grinding wheel. Reinstall the wheel spacer and hex head bolt and tighten to secure the grinding wheel. Reinstall the outside guard and wing studs to the grinder wheel guard assembly.

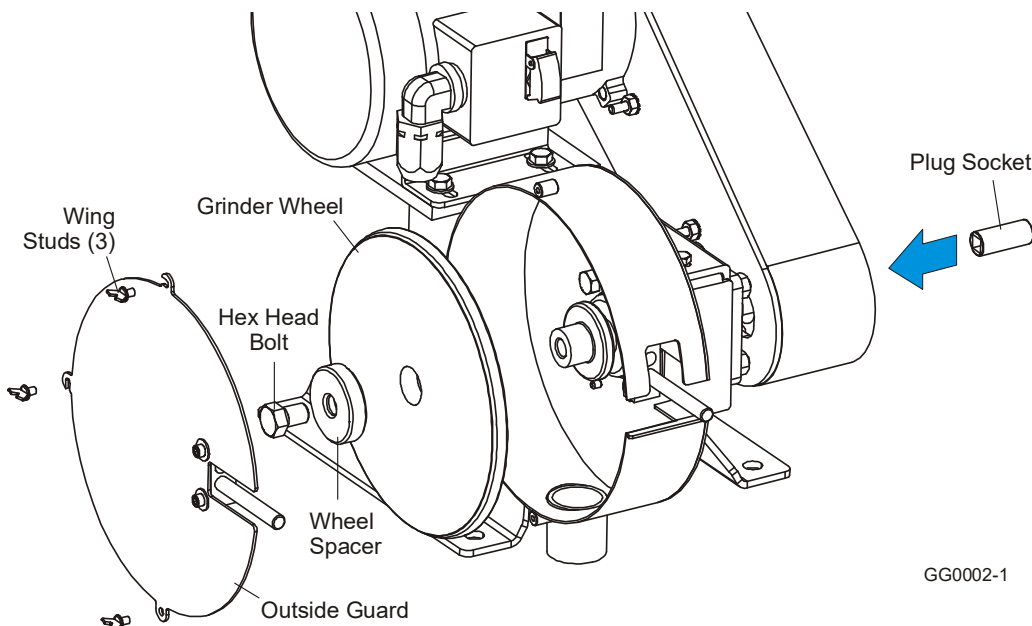


FIG. 4-1



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

SECTION 5 MAINTENANCE & ALIGNMENT

5.1 Maintenance



WARNING! Always turn off and disconnect power before performing any service to the machine.

Grinding Wheel Replacement

Check the grinding wheel often and change as necessary. Wheels approved for use with the grinder are available from Wood-Mizer (8" Vitrified Gullet Grinder Wheel part # 060757; 8" Gullet Grinder CBN Wheel (Optional) part #053768).

The grinding wheel should be in good condition. Replace if worn.

[See Section 4.3](#) for grinding wheel installation instructions.

Motor Drive Belt Adjustment

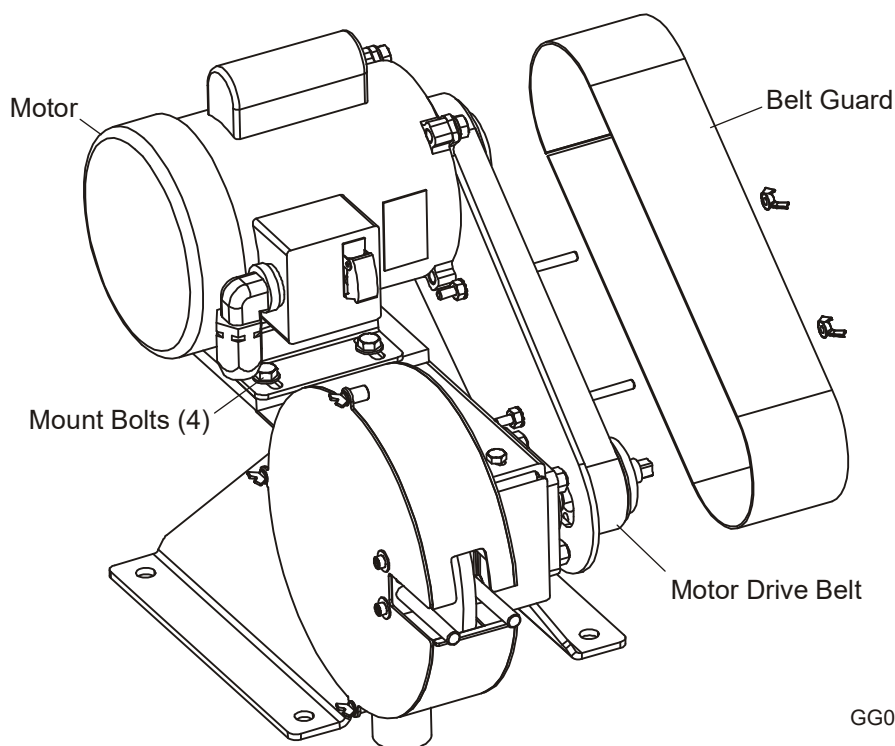


WARNING! Before performing service near moving parts such as pulleys, motors and belts, first turn the toggle switch to the OFF (#0) position. If the toggle switch is turned on and moving parts activated, serious injury may result.

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

To adjust the drive belt tension:

1. Remove the belt guard from the grinder. Loosen the motor mount bolts securing the motor to the grinder mount. Move the motor assembly away from the grinding wheel to tighten the belt; move the motor assembly towards the grinding wheel to loosen the belt.



GG0002-2

FIG. 5-0

2. Tighten the motor mount bolts to secure the motor assembly in place. Replace the belt guard to the grinder.
Periodically check the motor drive belt for wear. Replace any damaged or worn belts as needed.

Clean Grinder

Clean metal particles from the grinder and area surrounding after each day of operation. Pay particularly close attention to the moving parts of the grinder to ensure metal particles do not accumulate and interfere with grinder operation.

5.2 Troubleshooting



WARNING! Always turn off and disconnect power before performing any service to the machine.

PROBLEM	POSSIBLE CAUSE	SOLUTION
My grind motor does not turn on.	No power.	Check power supply and power cable.
	Improper wiring.	Check wiring per schematic. Ensure proper configuration at grind motor.
	Bad grinder motor.	Replace motor.
My grind motor is turning the wrong direction.	Improper wiring.	Interchange internal leads to grind motor. See motor nameplate for detailed information.
My start /stop toggle switch does not work.	No power.	Check power supply and power cable.
	Improper wiring.	Check wiring per schematic. Ensure proper configuration at grind motor.
	Bad switch contact.	Replace the start/stop toggle switch.

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Schematic

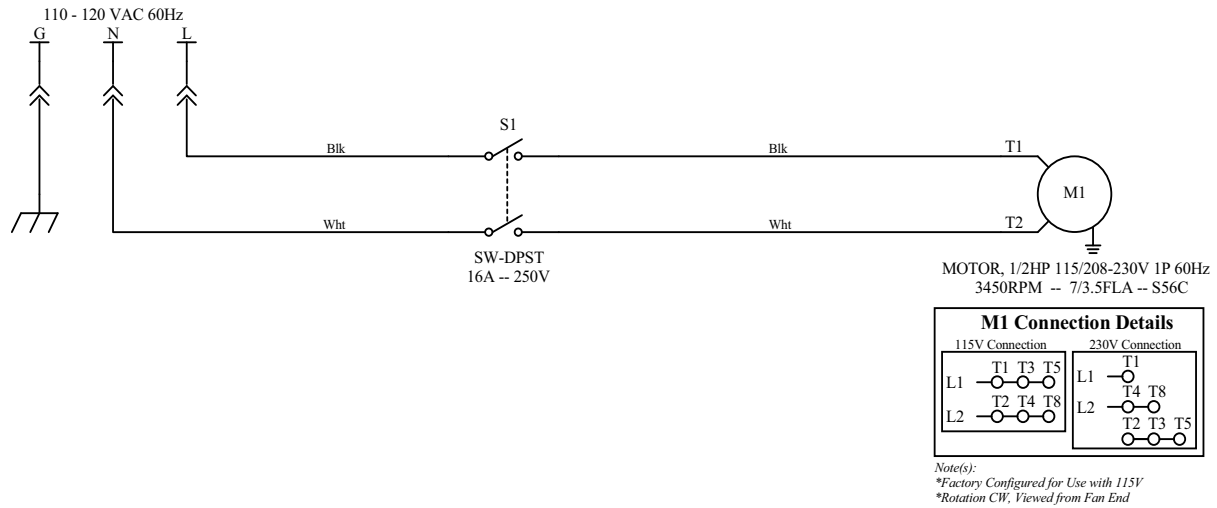
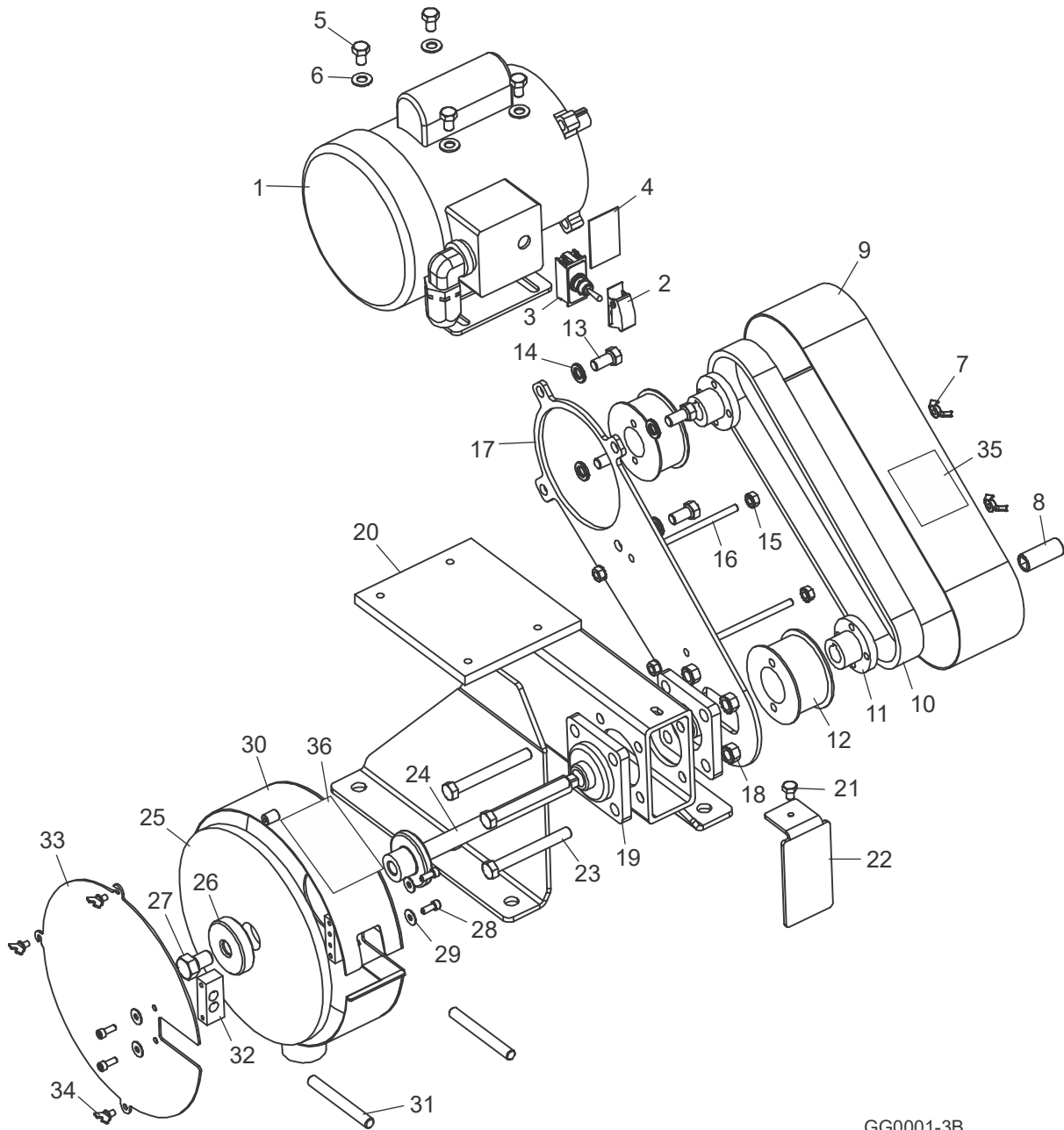


FIG. 6-1

SECTION 7 REPLACEMENT PARTS

7.1 Grinder Complete



GG0001-3B

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	060760	GRINDER ASSEMBLY, GULLET		1
	060758	Motor Assembly, Grinder		1
1	130064	Motor, Marathon 1/2HP 1P 115/230V 3450RPM	ECN: 38402, 066119-OBS	1
2	069578	Safety Cover, Black Toggle Switch		1
3	052440	Switch, DPST Toggle 1HP Screw Terminals		1
4	S20097	Decal, Motor Direction		1
	069579	Cable Assembly, Weld Band Grinder		1
5	F05006-15	Bolt, 5/16-18 x 1/2" Hex Head Grade 5		4

REF	PART #	DESCRIPTION	COMMENTS	QTY.
6	F05011-17	Washer, 5/16" SAE Flat		4
7	F05010-13	Nut, 1/4-20 Wing		2
8	060088	Socket, 3/8" Female Pipe Plug		1
9	060771	Guard Weldment, Gullet Grinder		1
10	P30200	Belt, 27" x 1" Gear		1
11	030343	Bushing, 5/8" Keyed Bore G Split Taper		2
12	074806	Pulley, 21Toothx1in STBGearbeltRSHP	Replaced pulleys 030340 and 030431 to decrease RPM on grinder wheel to 3600 (9/15).	2
13	F05007-27	Bolt, 3/8-16 x 3/4" Hex Head Grade 2		4
14	F05011-4	Washer, 3/8" Split Lock		4
15	F05010-9	Nut, 1/4-20 Keps		4
16	050726	Rod, Gullet Guard Mount		2
17	060772	Mount Plate, Gullet Guard		1
18	F05010-19	Nut, 3/8-16 Keps		4
19	050385	Bearing, 5/8" Pillow		2
20	060761	Grind Weldment, Gullet		1
21	F05005-67	Bolt, 1/4-20 x 3/8" Hex Head Grade 2		1
22	060774	Guard, Gullet Grinder Tube		1
23	F05007-135	Bolt, 3/8-16 x 3 1/4" Hex Head		4
24	060756	Shaft, Gullet Grinder	Shaft shortened for better fit (9/15).	1
25	060757	Wheel, 8" Vitrified Gullet Grinder		1
	053768	Wheel, 8" Gullet Grinder CBN (Optional)		1
26	050383	Spacer, Gullet Grinder Wheel		1
27	F05008-114	Bolt, 1/2-20 x 3/4" Hex Head Cap		1
	060775	Guard Assembly, Gullet Grind		1
28	F05004-45	Bolt, 10-24 x 1/2" SH		4
29	F05011-18	Washer, #10 SAE Flat		4
30	060764	Guard Weldment, Gullet Grind		1
31	F05012-130	Pin, 3/8" x 3-1/4" Dowel		2
32	050392	Block, Guide Pin		2
33	050395	Guard, Gullet Grind Outside		1
34	F05004-59	Stud, #10-24 x 1/4" Wing		1
35	S10691	Decal, AGA Eye Warning		1
36	S10692	Decal, Cover Warning		1

7.2 Component List

ID	Wood-Mizer Part No.	Description
M1	130064	Motor,Marathon 1/2HP 1P 115/230V 3450RPM
S1	052440	Switch, DPST Toggle 1HP Screw Terminals