

Wood-Mizer® Resaw

Safety, Operation & Maintenance Manual

HRPBR Option

Rev. A2.04

Safety is our #1 concern!

Form #1734



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

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SECTION 1 SPECIFICATIONS

Model: HRPBR Rev. A1.00+

Machine Dimensions:

Length: 174 43/64"
 Width: 53 5/16"
 Outfeed Table Height: 35" - 37" (Adjustable)

Weight (Option Only): 650 lbs

Material Dimensions:

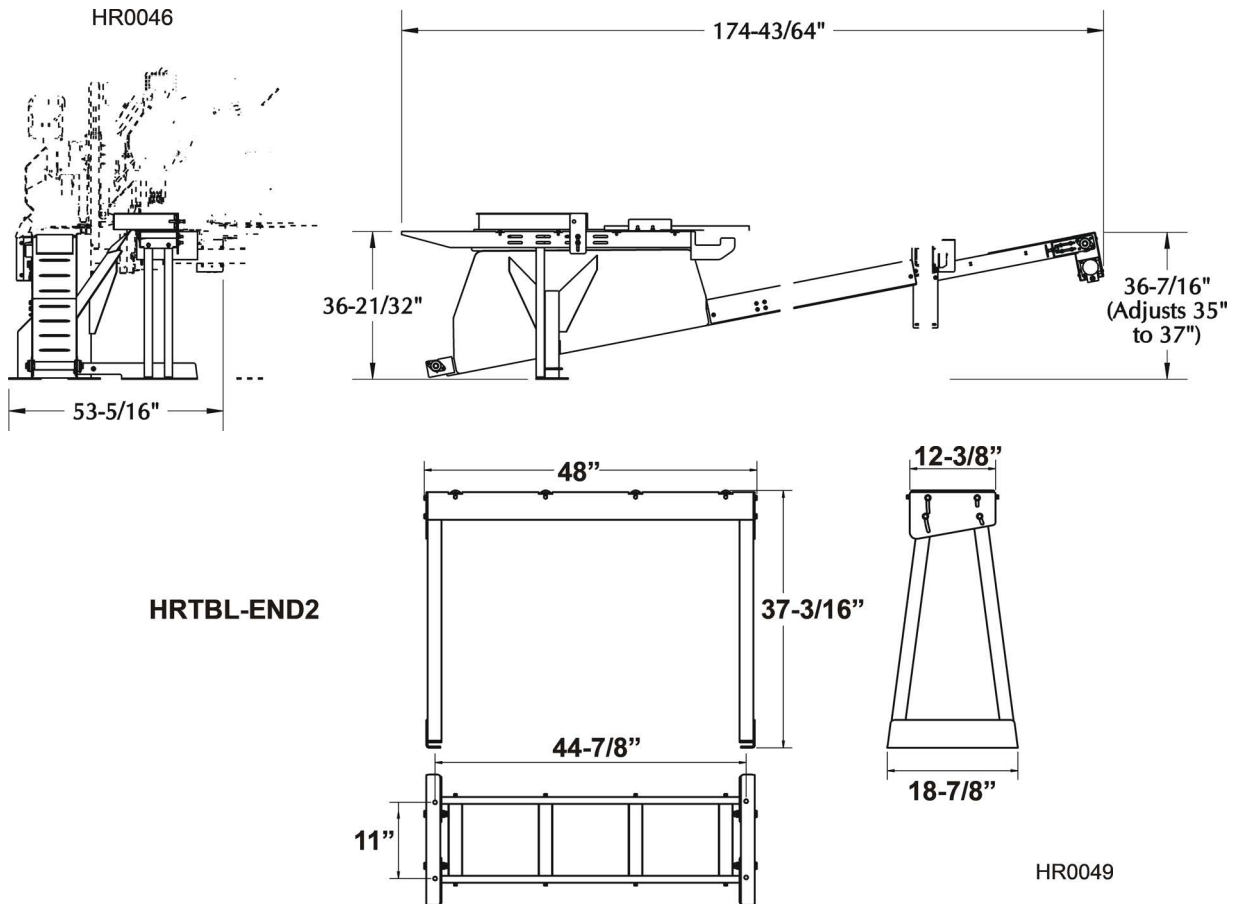
Minimum Board Height: 1/4"
 Maximum Board Height: 1 3/4"
 Maximum Material Height: 8"
 Maximum Material Length: 60"
 Maximum Material Width: 6"

Feed System:

Feed Rate: 70 fpm
 Feed Motor: 1/6HP 90RPM

Electrical Requirements:

Voltage: 115V
 Amperage: 2.1A



SECTION 2 INSTALLATION

NOTE: The electrical control box mounts on HR130E15 models prior to Rev. A2.01 may interfere with material as it travels across the board return conveyor. Mounts after Rev. A2.01 were modified to eliminate this interference. Contact customer service for information concerning retrofitting older revisions if adding the HRPBR option.

2.1 Outfeed Table

See **Figure 2-1**. At the outfeed end of the resaw conveyor, remove the lower left and right belt tensioner mounting bolts, flat washers and lock nuts. Place the outfeed table mount plate in position over the mounting holes and replace the bolts and hardware.

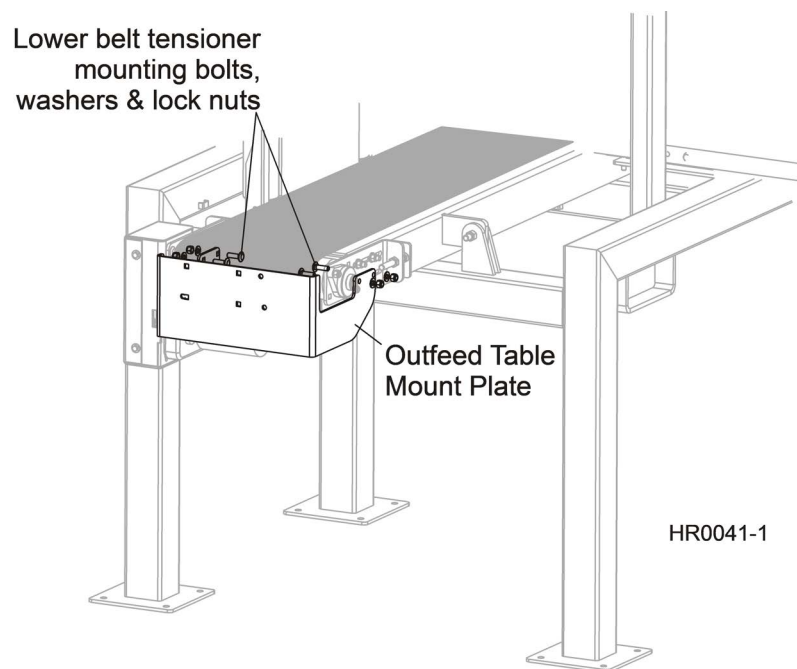


FIG. 2-1

See Figure 2-2. Assemble the leg to the outfeed table assembly with four provided 3/8-16 x 3" carriage head bolts, flat washers and nylon lock nuts. Leave the bolts loose until the table is leveled in the next step

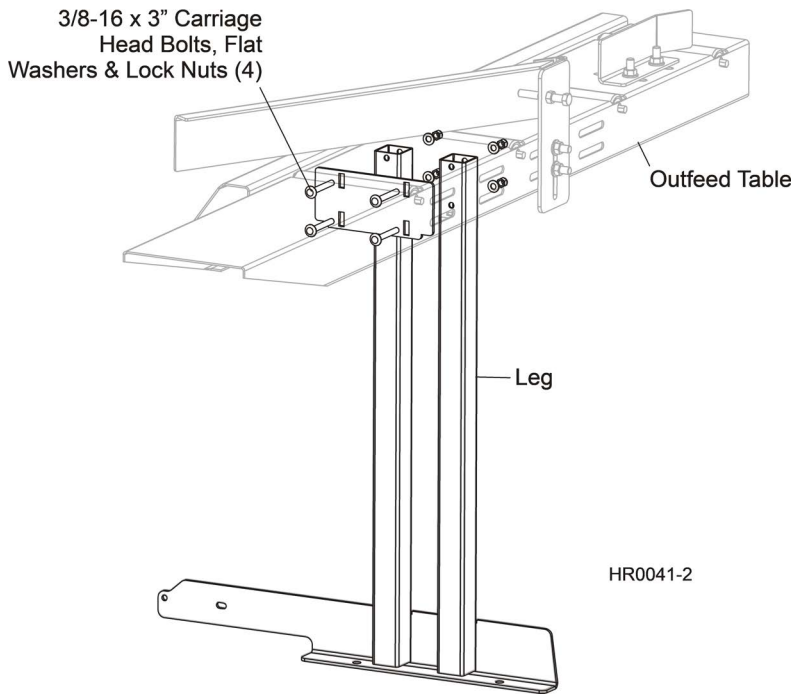


FIG. 2-2

See Figure 2-3. Install the outfeed table to the mount plate using four 3/8-16 x 1" carriage head bolts, flat washers and nylon lock nuts. Be sure the table rollers are positioned level with or slightly lower than the resaw conveyor belt. Use a straight edge across the belt and rollers. Adjust the outfeed table up or down as necessary, make sure it is level and tighten the table and leg mounting bolts.

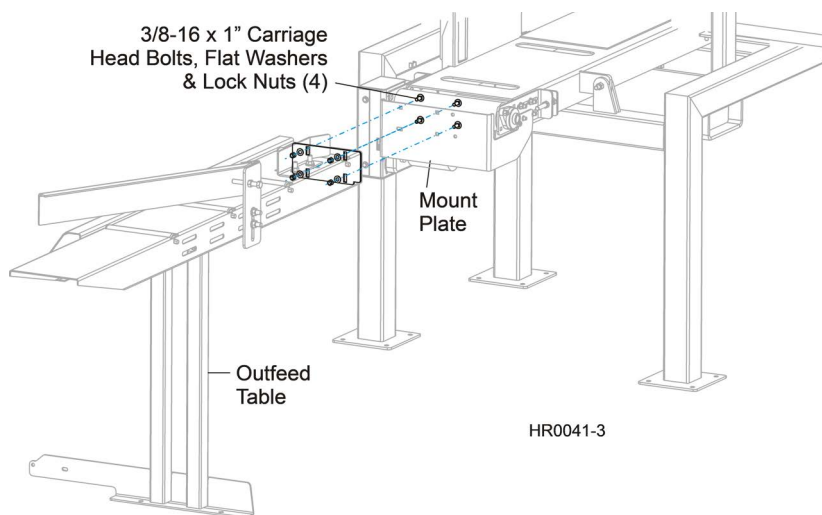


FIG. 2-3

2.2 Return Table

See **Figure 2-4**. Assemble the lower return table to the upper return table and install the side mount and brace plates to the upper return table using ten provided 3/8-16 x 1" carriage head bolts, flat washers and nylon lock nuts.

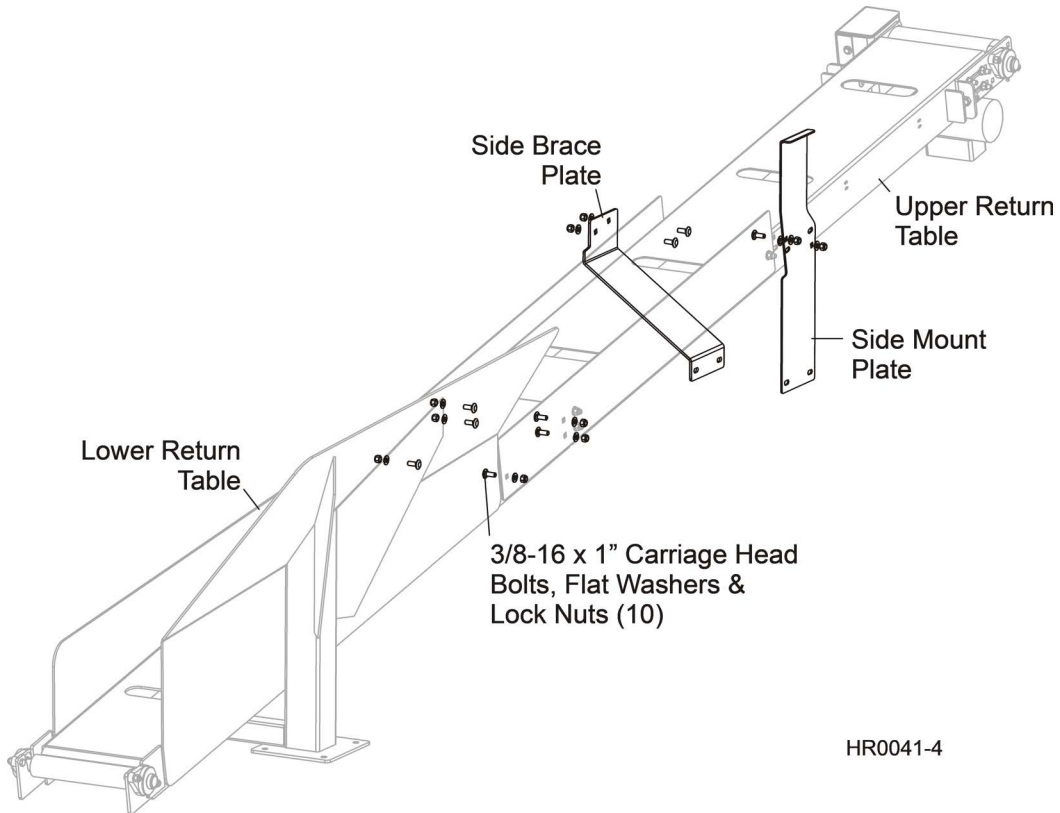


FIG. 2-4

See Figure 2-5. Attach the return table assembly to the outfeed table leg and resaw leg using three sets of the provided U-bolts, flat washers and hex nuts. Be sure the return table side plate is positioned under the outfeed table side plate. Adjust the return table up or down so the return end is positioned at the level of the table that material will be returned to.

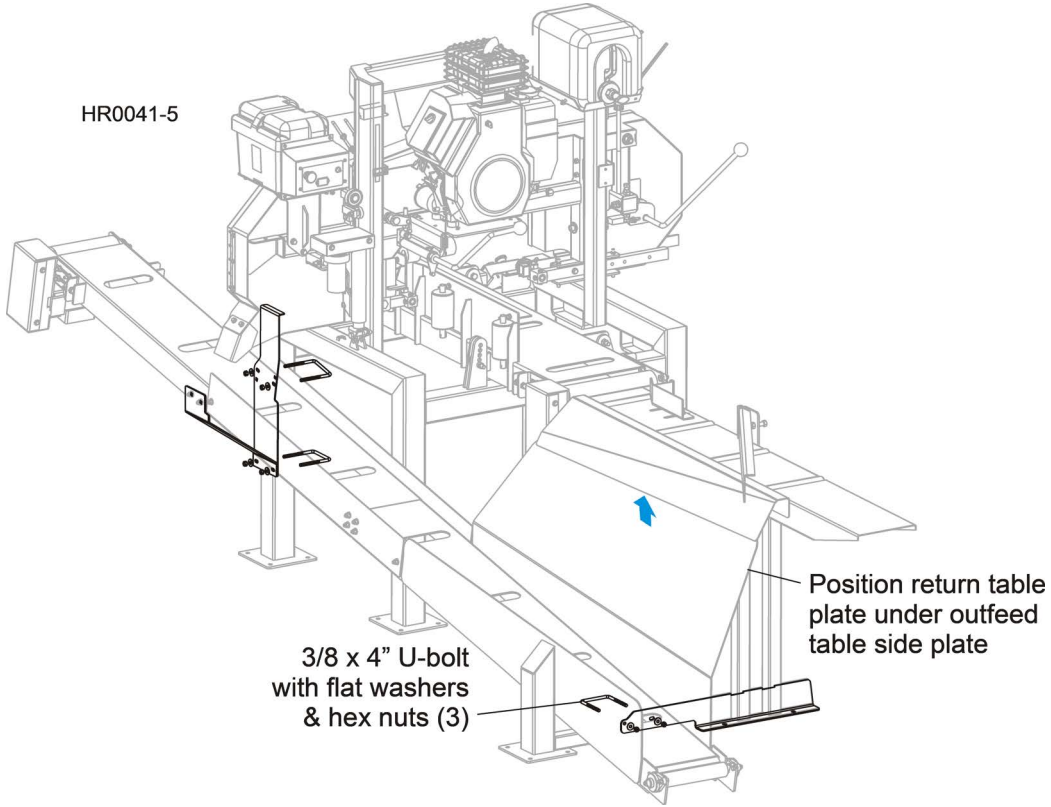


FIG. 2-5

2

Installation

Return Table

See **Figure 2-6**. Install the return belt to the return table assembly. Loosen the belt tensioners on each side of the upper return table frame and push the belt roller in to provide slack to install the belt. Remove the seam wire from the belt and place the belt around the rollers at the drive and idle ends of the return table. Secure the belt by replacing the seam wire. Adjust the belt tensioners on each side of the upper return table to tension the belt.

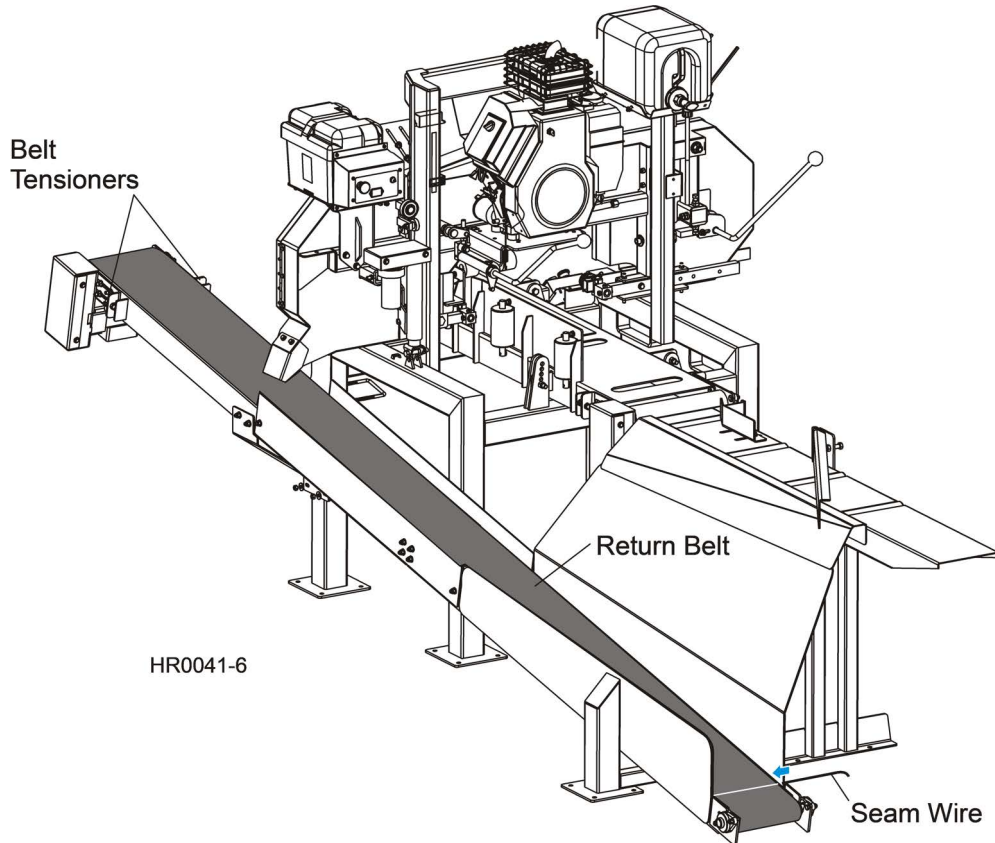


FIG. 2-6

2.3 Control Box

See **Figure 2-7**. Install the control mount to the resaw frame with two U-bolts, flat washers and hex nuts. Install the control box to the mount. Plug the motor power cord into a grounded 110/120V receptacle. Use the supplied wire ties to secure the cables to the machine. Be sure all cables are secure and out of the path of the operators.

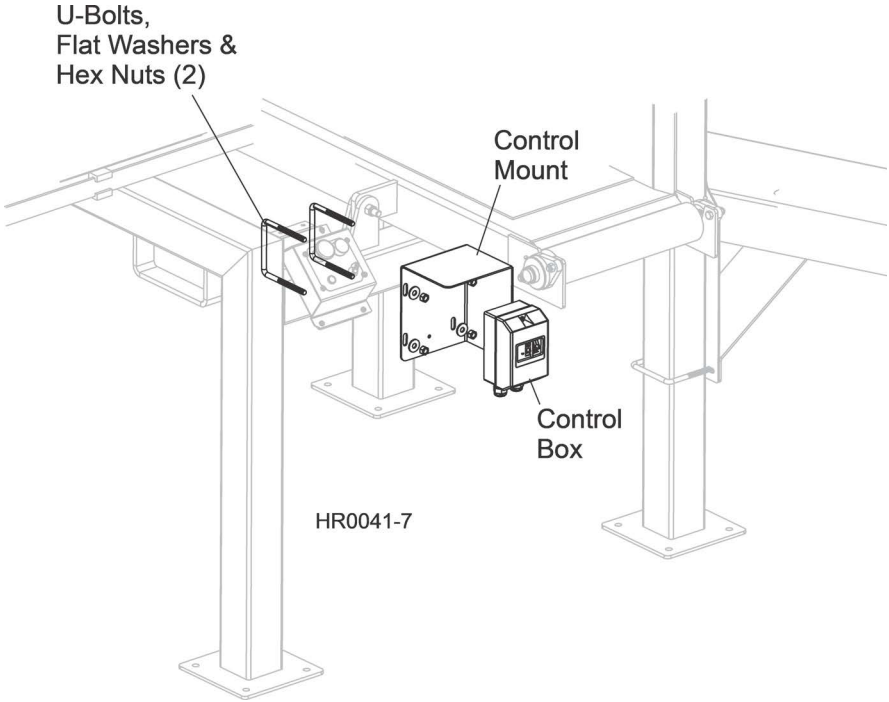


FIG. 2-7

SECTION 3 OPERATION

3.1 Setup

1. Cut a piece of material on the resaw to use for setting up the return system.
2. Turn off and lockout the power to the resaw and the return control box.



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

3. Adjust the small outfeed fence to 1/2" wider than the setup piece. Loosen the two adjustment bolts, slide the fence in or out and retighten the bolts.

See Figure 3-1.

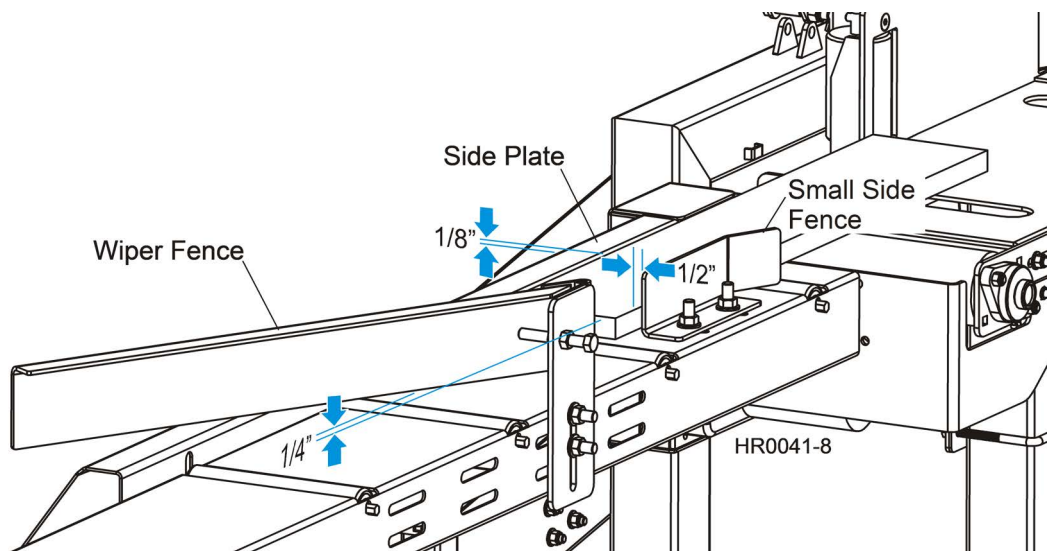


FIG. 3-1

4. Adjust the side plate up or down so the top of the plate is 1/8" lower than the thickness of the finished material. Loosen the four adjustment bolts, adjust the plate up or down and retighten the bolts.
5. Adjust the wiper fence approximately 1/4" above the thickness of the finished material. This will allow finished material to pass under the fence and continue off the end of the table. Loosen the two adjustment bolts, adjust the wiper fence up or down and retighten

the bolts. The stop bolt needs to be adjusted depending on the length of material being processed. Generally, the fence should be adjusted narrower for shorter material and wider for longer material. This adjustment can be fine-tuned during operation until the material falls onto the return track as desired. To adjust the stop bolt, loosen the jam nuts and turn the bolt to move in or out. Retighten the jam nuts.

6. Raise or lower the height of the end of the return track to the height of the table that will receive the returned material. Loosen the nuts on the two front U-bolts and raise or lower the return track and retighten the U-bolt nuts.

See Figure 3-2.

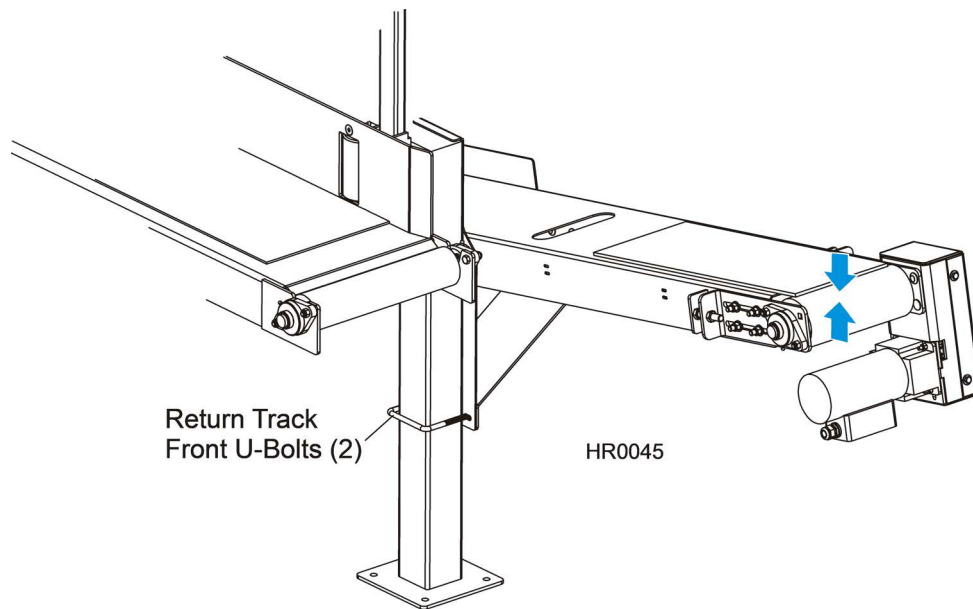


FIG. 3-2

3.2 Feed Operation

1. Start the resaw as instructed in the resaw operator's manual.
2. Push the start (#1) switch on the HRPBR control to start the return feed motor.
3. Feed material end-to-end through the resaw.
4. Observe flow of material through return system. Stop resaw and return feed and make adjustments as necessary.
5. Push the stop (#0) switch on the HRPBR control to stop the return feed motor.

SECTION 4 MAINTENANCE



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

1. If the return belt begins to slip, tighten the belt. Loosen the tensioner locking bolts on both sides of the frame. Loosen the outer jam nut on each adjustment bolt. Use a wrench to hold the adjustment bolt and turn the inner jam nut clockwise to push the return belt roller out. Turn the adjustment bolts on each side of the frame equally. Only tighten the belt until it no longer slips. Retighten outer jam nuts and the locking bolts.

See Figure 4-1.

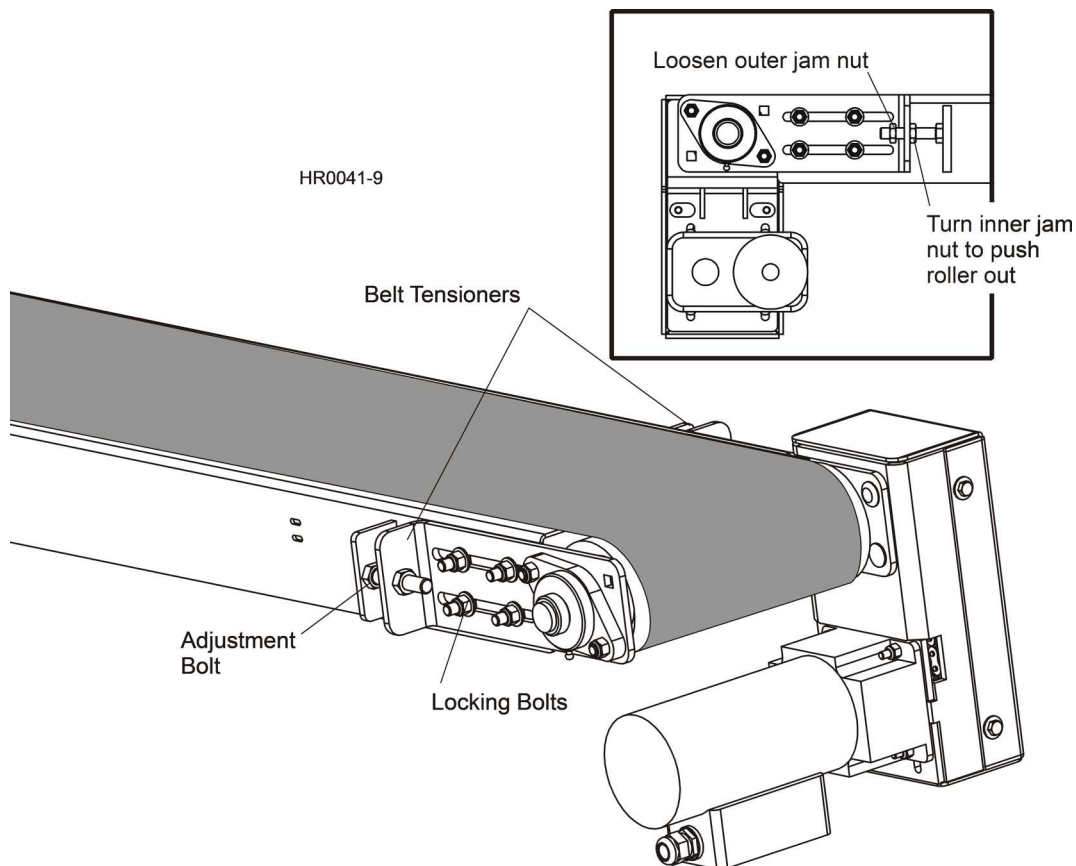


FIG. 4-1

2. After tightening the belt, run the belt for a few minutes and make sure the belt remains centered on the drive rollers while running. If the return belt keeps travelling to one side or the other, loosen the belt tensioner locking bolts on one side of the belt. Use a wrench to

hold the alignment bolt and adjust the jam nuts to move the end of the roller in or out.

See Figure 4-2. Example: If the belt is tracking to the left, extend the left tensioner bracket out to move the belt to the right. Adjust in small increments until the belt travels straight. Retighten the locking nuts.

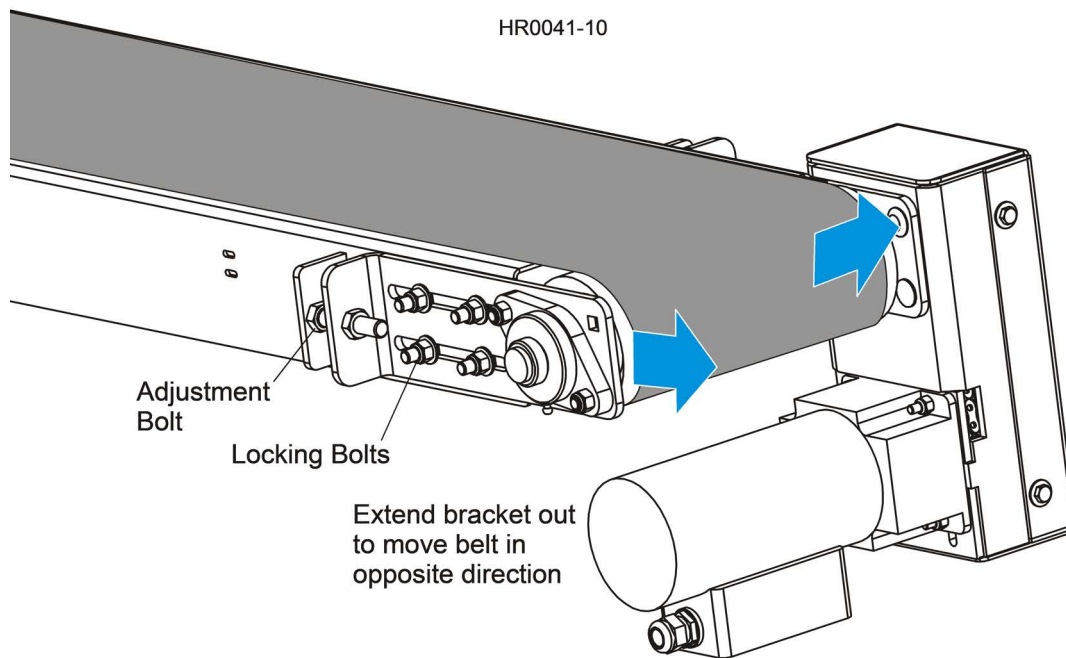
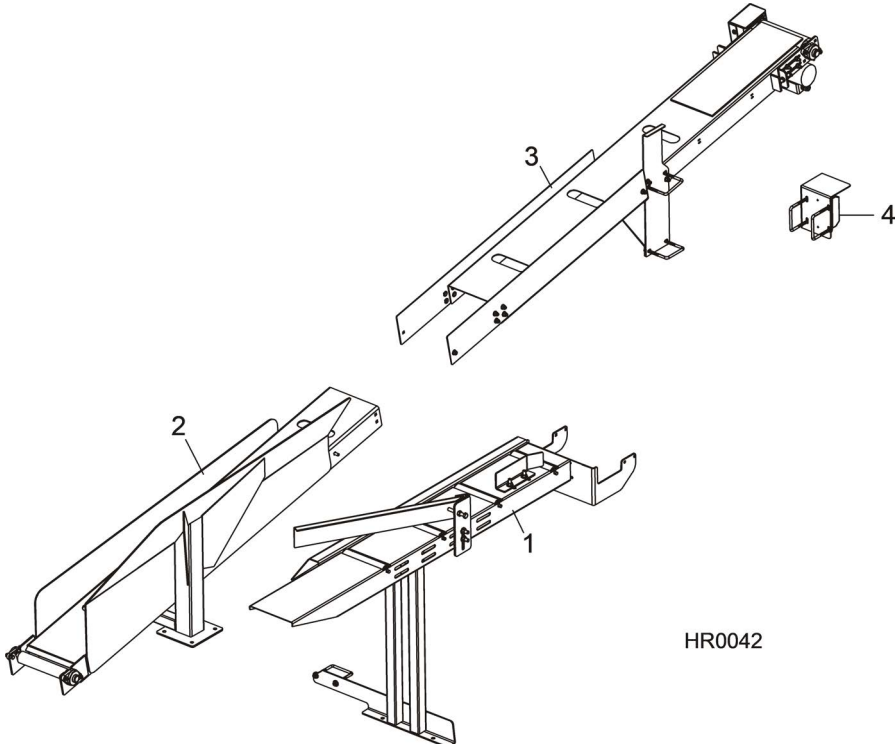


FIG. 4-2

3. Periodically check the retrun belt for wear. Replace a damaged or worn belt as needed. Always check the return belt alignment after installing a new belt. Align the retrun belt after replacing if necessary.

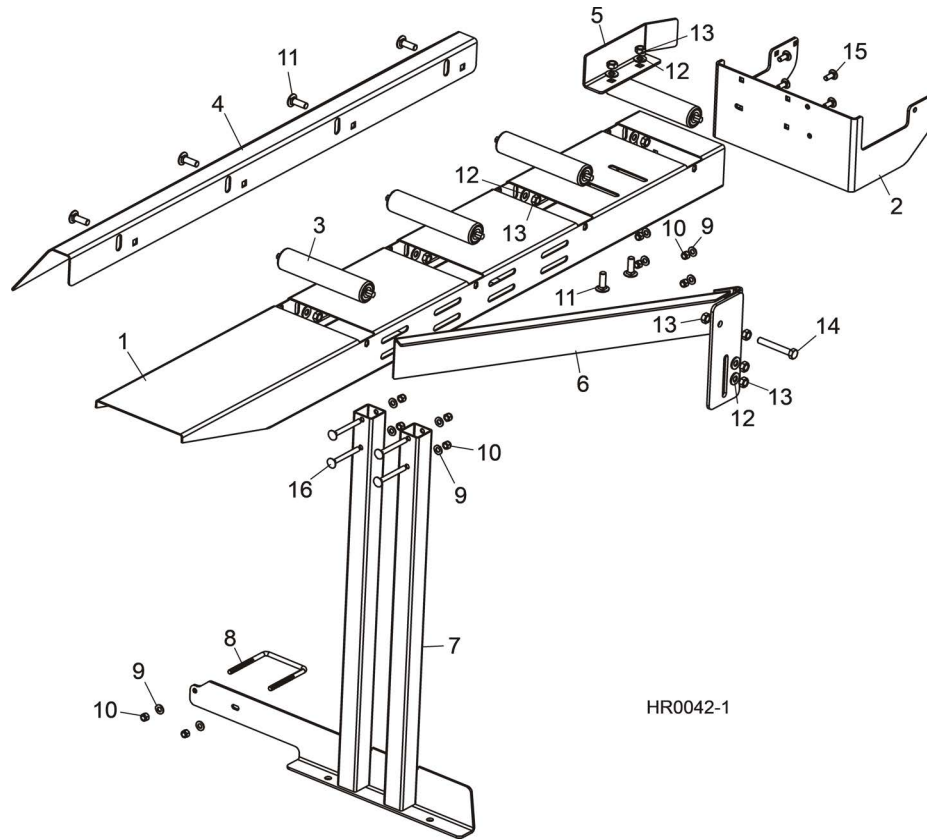
SECTION 5 REPLACEMENT PARTS

5.1 HRPBR Option Complete



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	HRPBR	RETURN OPTION, HR100 SERIES POWERED BOARD		1
1		Outfeed Table Parts (See Section 5.2)		
2		Lower Conveyor Table Parts (See Section 5.3)		
3		Upper Conveyor Table Parts (See Section 5.4)		
4		Control Parts (See Section 5.6)		
		Stand Alone Table Parts (See Section 5.7)		
	M1735	Manual, HRPBR Option Master		1

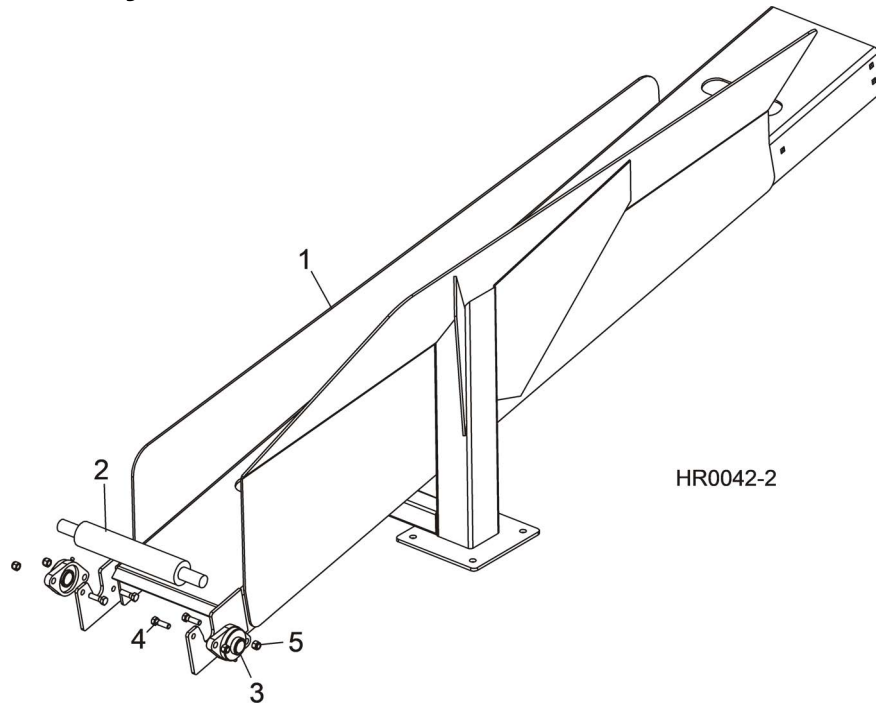
5.2 Outfeed Table



HR0042-1

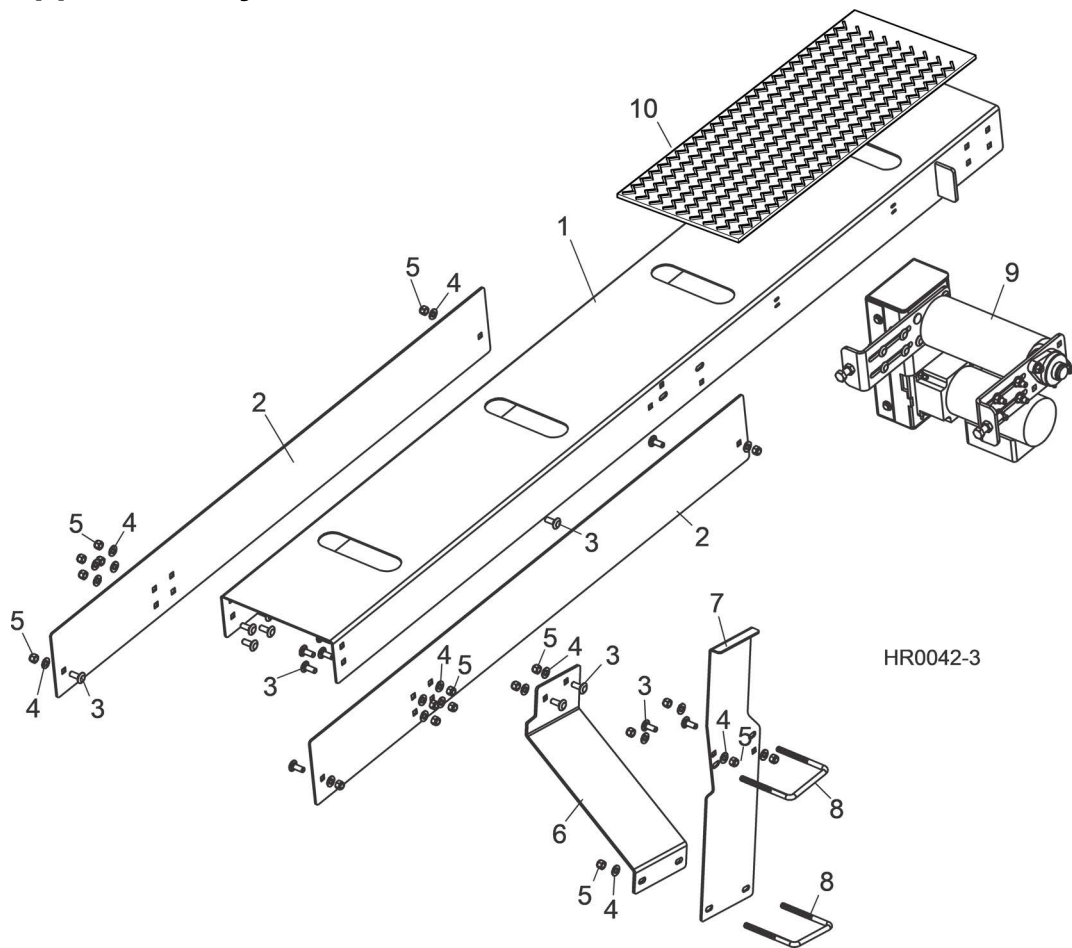
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	062573	TABLE ASSEMBLY, HRPBR OUTFEED		1
1	059657	Table Weldment, Outfeed		1
2	059570	Plate, Outfeed Table Mount		1
3	059584	Roller, 1.90" OD x 9"		4
4	059653	Plate, Outfeed Table Side		1
5	059654	Plate, Outfeed Table Guide		1
6	062574	Fence Weldment, Outfeed Table		1
7	059663	Leg Weldment, Outfeed Table		1
8	003207	Bolt, 3/8-16 x 4" x 5" 'U'		1
9	F05011-3	Washer, 3/8" SAE Flat		10
10	F05010-10	Nut, 3/8-16 Hex Nylon Lock		10
11	F05008-150	Bolt, 1/2-13 x 1 1/2" Carriage Head		8
12	F05011-2	Washer, 1/2" SAE Flat		8
13	F05010-35	Nut, 1/2-13 Hex		10
14	F05008-11	Bolt, 1/2-13 x 3 1/2" Hex Head Full Thread		1
15	F05007-165	Bolt, 3/8-16 x 1" Carriage Head Grade 5		4
16	F05007-134	Bolt, 3/8-16 x 3" Carriage Head		4

5.3 Lower Conveyor Table



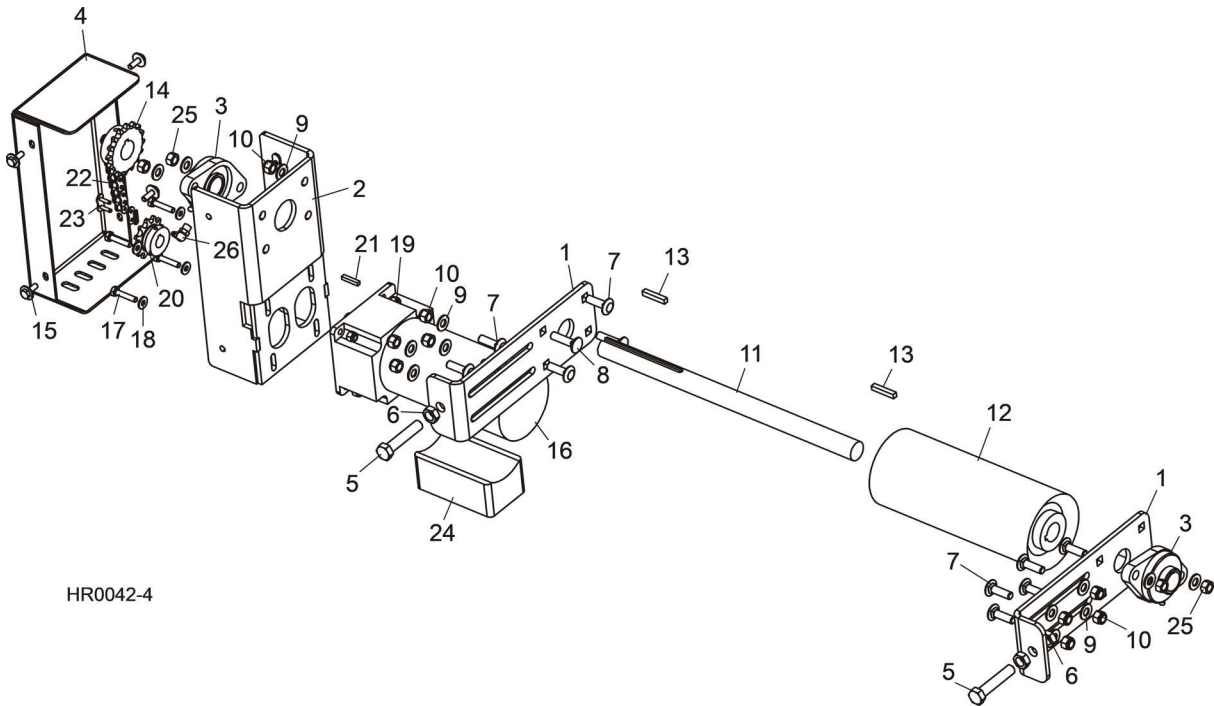
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	059651	TABLE WELDMENT, HRPBR LOWER CONVEYOR		1
2	062572	ROLLER, CONVEYOR IDLER		1
3	038124	BEARING, 1" VF2S 216 FLANGED		2
4	F05007-123	BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 5		4
5	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		4

5.4 Upper Conveyor Table



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	062563	TABLE WELDMENT, HRPBR UPPER CONVEYOR		1
2	059666	PLATE, CONVEYOR CONNECTOR SIDE		2
3	F05007-165	BOLT, 3/8-16 X 1" CARRIAGE HEAD		16
4	F05011-3	WASHER, 3/8" SAE FLAT		20
5	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		20
6	059673	PLATE, SIDE BRACE		1
7	065158	PLATE, BRACE SPACER		1
8	003207	BOLT, 3/8-16 X 4" X 5" 'U'		2
9		DRIVE PARTS (See Section 5.5)		
10	062576	BELT, 9" X 28'-3" Z-TOP CONVEYOR		1

5.5 Conveyor Drive



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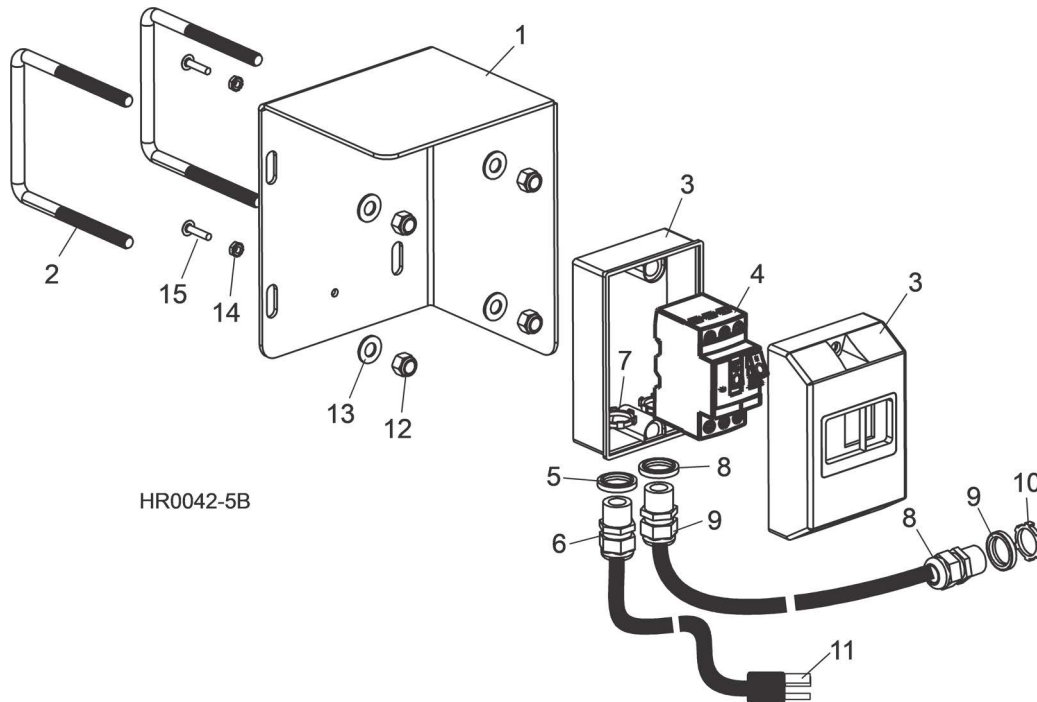
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	062568	DRIVE ASSEMBLY, HRPBR CONVEYOR		1
1	063125	Plate, Belt Roller Tensioner		2
2	007605	Mount Weldment, Drive Motor		1
3	038124	Bearing, 1" VF2S 216 Flanged		2
4	007606	Cover, Conveyor Drive Pulley		1
5	F05008-135	Bolt, 1/2-20 x 2 1/2" Hex Head Full Thread Grade 5		2
6	F05010-16	Nut, 1/2-20 Hex Jam		4
7	F05007-127	Bolt, 3/8-16 x 1 1/4" Carriage Head Grade 5		12
8	F05007-85	Bolt, 3/8-16 x 1 1/2" Carriage Head		2
9	F05011-3	Washer, 3/8" SAE Flat		10
10	F05010-10	Nut, 3/8-16 Hex Nylon Lock		10
11	059678	Shaft, Conveyor Belt Pulley		1
12	062569	Pulley, 4" x 10" Conveyor		1
13	017832	Key, 1/4" Square x 1 3/8"		2
14	007311	Sprocket, 40B16 x 1" Bore		1
15	F05005-134	Bolt, 1/4-20 x 3/4" Conical Washer Head		4
16	062577	Motor, 1/6HP 90RPM 115/230V 1PH 19:1 Gear		1
17	F05005-3	Bolt, 1/4-20 x 1 1/4" Hex Head		4
18	F05011-11	Washer, 1/4" SAE Flat		4

5 Replacement Parts

Conveyor Drive

REF	PART #	DESCRIPTION	COMMENTS	QTY.
19	F05010-69	Nut, 1/4-20 Hex Nylon Lock		4
20	025704	Sprocket, 40B12 x 5/8" Bore		1
21	S31027	Key, 3/16" Square x 1"		1
22	063184	Chain, #40 x 39 Pitch (19 1/2") Roller		1
23	P04200	Link, #40 Master		1
24	065170	Box, Motor Conduit		1
25	F05010-25	Nut, 3/8-16 Swaged Lock		4
26	P04108	Fitting, Grease 90 Deg. 1/4-28		1

5.6 Control Box



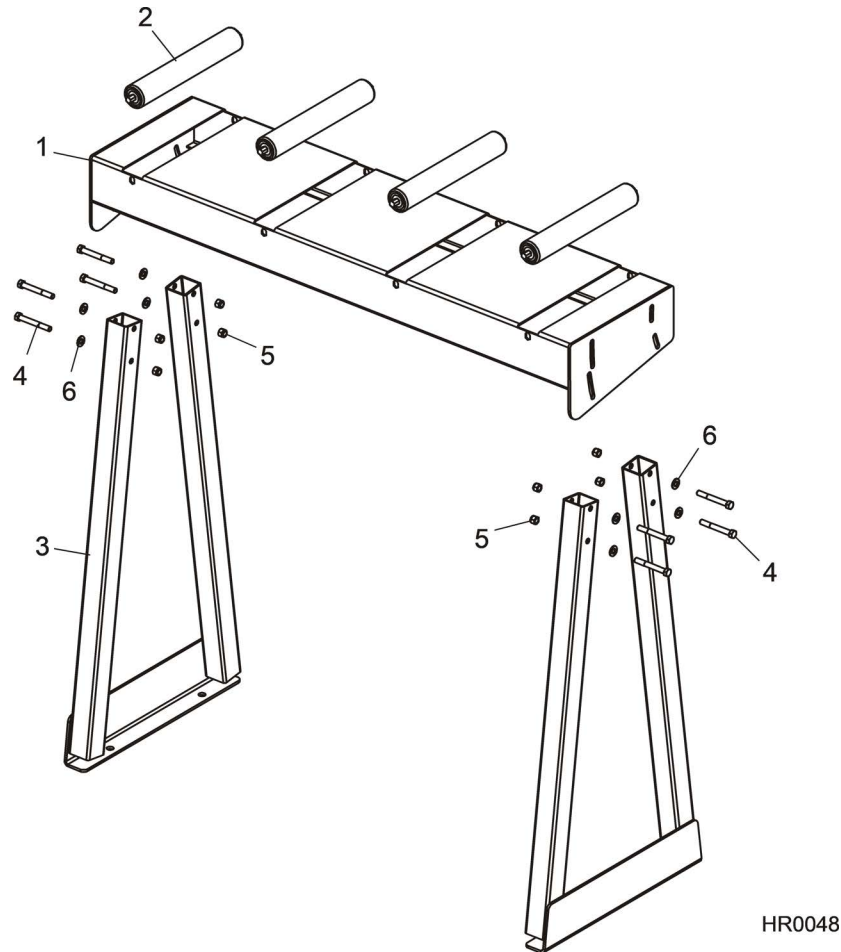
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REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	062564	PLATE, CONTROL BOX MOUNT		1
2	003207	BOLT, 3/8-16 X 4" X 5" 'U'		2
	069859	CONTROL ASSEMBLY, HRPBR CONVEYOR		1
3	069399	Enclosure, GV2 Manual Motor Starter		1
4	MBGV2ME07	Motor Starter, Manual 1.6-2.5A Protector		1
5	E20460	Ring, 1/2" Sealing		1
6	051299	Connector, 1/2" NPT .17-.47		1
7	E20461	Nut, 1/2" #141 Lock		1
	069860	Cable Assembly, HRPBR Motor		1
8	051299	Connector, 1/2" NPT .17-.47		2
9	E20460	Ring, 1/2" Sealing		2
10	E20461	Nut, 1/2" #141 Lock		2
11	050206	Cord, 3' x 3 16AWG Conductor Power		1
12	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		4
13	F05011-3	WASHER, 3/8" FLAT SAE		4
14	F05010-14	NUT, #10-24 KEPS		2
15	F05004-33	SCREW, 10-24 X 7/8 ROUND HEAD		2

5 Replacement Parts

Stand Alone Table Assembly

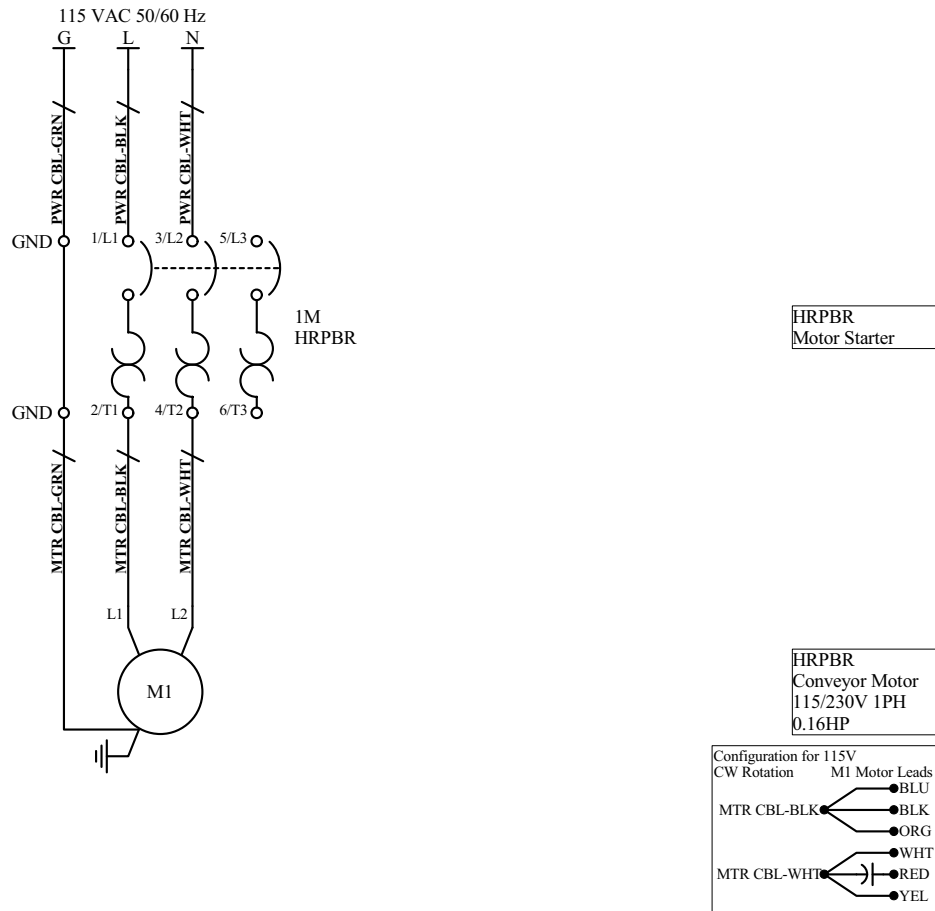
5.7 Stand Alone Table Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	HRTBL-END2	TABLE ASSEMBLY, HR STAND ALONE		1
1	059561	Table Weldment, HR End		1
2	059563	Roller, 1.90" OD x 12"		4
3	059564	Leg Weldment, HR Table		2
4	F05007-73	Bolt, 3/8-16 x 3" Hex Head Grade 5		8
5	F05010-10	Nut, 3/8-16 Hex Nyloc		8
6	F05011-3	Washer, 3/8" Flat SAE		8
	HRTBL-1680	Manual, HR Tables		1

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Schematic



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