

LT300 Training Workbook

Date _____

Installation

- ___ Position Mill
- ___ Position Control Station in relationship to mill
- ___ Anchor Equipment
- ___ Install Lube System
- ___ Hook up hydraulic lines from mill to control station
- ___ Hook up all Electrical wires from mill to control station
- ___ Hook up Air Lines

Sawmill Alignment

Tech Name/s _____

- ___ Level sub frame front to back
- ___ Level sub frame between 8 ft. decks
- ___ Level saw head full travel with frame adj.
- ___ Level bed rails
- ___ Level blade to bed rail
- ___ Check side support alignment

Blade Guide Alignment

Tech Name/s _____

- ___ Open outer blade guide arm approx. 24"
- ___ Remove Top & Bottom Guide Disk
- ___ Raise roller so it's not touching the blade.
- ___ Install and track blade w/motor
- ___ Make sure nothing is touching the blade
- ___ Check vertical blade wheel tilt both sides + or - 1/32"
- ___ Check blade guide arm alignment horizontal within 1/32"
- ___ Check blade guide arm alignment vertical within 1/32"
- ___ Install blade guide disks
- ___ Check that back edge of the blade is beyond back edge of guide
- ___ Set gap between flange and back of blade
- ___ Deflect blade
- ___ Check vertical blade wheel tilt both sides + or - 1/32"
- ___ Horizontal disk alignment check level to the blade with .010 gauge.
- ___ Vertical disk alignment check + or - 1/32"
- ___ Adjust upper block to .010 of blade with gauge.
- ___ Adjust transducer sensor
- ___ Set lower head stop bolt at 1"
- ___ Set upper head stop bolt at 35 1/2"
- ___ Align Laser to the cut line. **Trainee/Signature** _____

Tech Name/s _____

Maintenance

Every 50 Hours

- ___ Clean Mast Rails/Remove any sawdust from underneath possibly sooner
- ___ **Check Drive Belt Tension (typically it will require tightening)**
- ___ Clean track rails and adjust scrapers
- ___ Clean and lube mast rails and adjust scrapers
- ___ Check track oil reservoir
- ___ Oil all chains with ATF
- ___ Lube blade guide arm ATF
- ___ Lube pivot points operators seat
- ___ Lube Log clamp
- ___ Lube log loader
- ___ Log turner
- ___ Side Supports Linkage
- ___ Check Hydraulic fluid level
- ___ Check hydraulic fittings for leaks

Every 500 Hours

- ___ Replace hydraulic filter
- ___ Lubricate Ball Screw TriGEL-450R
- ___ Lube Thrust bearing
- ___ Inspect power feed chain and sprockets for wear

Every 750 Hours

- ___ Lube wheel hubs with Amoco Rycon #2 or Chevron SRI #2
- ___ Blade Wheels need to be recrowned for blade to track consistently. Typically needs to be done between 500 & 1000 hours. We offer recrown service exchange program.

Every 2000 Hours

- ___ Replace hydraulic fluid

Every 5000 Hours or once a year

- ___ Drain oil from gearbox and replace

Trainee/s Signature _____

Safety Overview

Tech Name/s _____

- ___ Danger! Indicates an imminent hazardous situation which, if not avoided, will result in death or serious injury.
- ___ Warning! Suggest a potentially hazardous situation which, if not avoided, could result in serious injury or death.
- ___ Caution!

Blade Application

Tech Name/s _____

Make a chart

Trainee/s Signature _____

Softwood

13-degree hook

1 1/2" blade

.055 or .045

Medium Hardwood

10 or 13 degree hook

1 1/2" or 1 1/4"

.055, .050 or .045

Extremely Hardwood or frozen

4, 9 or 10-degree hook

1 1/2" or 1 1/4" if frozen 1 1/4 " only

.055 or .045

___ Change blades every 1000ft. or 2 hours, whichever comes first.

Operation

Tech Name/s _____

___ Start Button

___ Emergency Stop Button

___ Key Switch

___ Joy Stick Overview Head Mode

___ Joy Stick Overview Bed Mode

___ Program Yellow and Blue Buttons

___ Adjust Lube Flow/Explain

___ Adjust Max. H.P. /Explain

___ Adjust Max Power Feed/Explain

___ Adjust Upper Head Limit 35.5"

___ Set stop block to protect transducer

___ Saw a log or two explaining what you are doing

___ Have trainee saw a minimum of 2 hours

Trainee/s Signature _____

___ The training provided is an overview. It is not intended to be a substitute for the owner's, operator's manual, and/or option manuals. Read all product manuals and observe all safety instructions including dangers, warnings, and cautions prior to operating your mill w/o trainer present.

___ Customer has been offered and reviewed copy of recommended spare parts list.

There is a 10% discount at the time of commissioning.

___ Review the benefits of the Maintenance Agreement & sign up if customer wishes to take advantage of the offer.

If for any reason the above list was not completed 100% please note below:

RETURN REPORT TO JB AND FILE A COPY FOR YOUR RECORDS

Incline Conveyor

Installation

- ___ Position Incline in relation to LT300
- ___ Adjust height to match LT300 and out feed deck.
- ___ Level across width
- ___ Anchor Incline
- ___ Explain belt adjustment
- ___ Show lubrication points

Transfer Deck

Installation

- ___ Position deck in relation to incline
- ___ Adjust height in relation to the incline
- ___ Mount and adjust optical eyes
- ___ Anchor Transfer Deck
- ___ Level across width and length
- ___ Show lubrication points

In Feed Deck

Installation

- ___ Position in relation to LT300
- ___ Add valves to LT300 valve body
- ___ Hook up hydraulic lines
- ___ Install all electrical components to LT300 and route din plugs
- ___ Anchor in feed deck
- ___ Show lubrication points

Tech Name _____

Trainee/s Signature _____

If for any reason the above list was not completed 100% please note below:

RETURN REPORT TO JB AND FILE A COPY FOR YOUR RECORDS

Three-way Deck

Installation

- ___ Position in relationship to the Incline Conveyor
- ___ Adjust height to match that of the Incline Conveyor
- ___ Hook up air lines and connector chain (TWC-EXT only)
- ___ Route and hook up photo eye
- ___ Route and hook up E-stop and communication cables to the LT300
- ___ Mount the auxiliary control box to the LT300 control box
- ___ Hold down Ref. 1 for 30 seconds after switching on power to activate 3-way program
- ___ Anchor the deck.
- ___ Level across width and length

Training

- ___ Operate the deck manually
- ___ Explain photo eye operation and adjustment
- ___ Default wire (x12 right, x13 left, take off and tape for straight through)
- ___ Left operation
- ___ Right operation
- ___ Stack commands
- ___ Operate manually
- ___ Cancel command

Maintenance

- ___ Grease roller bearings every 50 hours of operation
- ___ Lubricate drive chain every 50 hours of operation

Tech Name _____

Trainee/s Signature _____

If for any reason the above list was not completed 100% please note below:

RETURN REPORT TO JB AND FILE A COPY FOR YOUR RECORDS

E430 Edger

Installation

- ___ Place edger and in-feed table in desired location
- ___ Adjust height and level edger
- ___ Mount in-feed table and adjust to match height of first lower in-feed roller. Set 1/16" lower than top of roller
- ___ Anchor in position
- ___ Hook up perimeter switch and reset (Red ring will show when reset)
- ___ Plug control box wires into main electrical box and fasten in clamps provided
- ___ Check drive belt tension
- ___ Check the rotation of the blade. (Feed rollers will run forward with the blades rotation backwards)

Training

- ___ Show how to start edger and use operational controls
- ___ Demonstrate the use of kick-back release/feed reverse
- ___ Demonstrate E-Stop and perimeter safety switch
- ___ With covers removed, show operation of slow down proxies and how to adjust
- ___ Check and explain laser adjustment
- ___ Demonstrate raising rear upper roller to gain access to blades
- ___ Demonstrate removing saw tooth and reinstall
- ___ Explain how to change the blades

Maintenance

Daily

- ___ Remove debris from feed rollers
- ___ Use a soft cloth and remove debris from the blade drive shaft

Every 40 Hours

- ___ Check belt for wear and retension
- ___ Check tension of out feed drive chain **Tech Name** _____
- ___ Check laser drive chain tension
- ___ Check laser belt for wear and tension **Trainee/s Signature** _____

Every 200 Hours

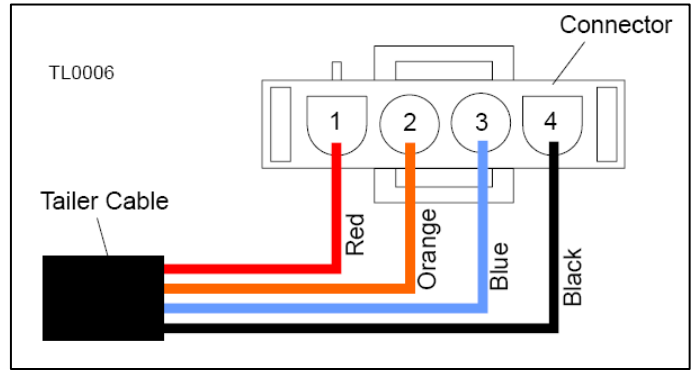
- ___ Lubricate the blade shaft bearings
- ___ Lubricate the in-feed table rollers
- ___ Lubricate the upper feed roller and lower feed bearings

If for any reason the above list was not completed 100% please note below:

RETURN REPORT TO JB AND FILE A COPY FOR YOUR RECORDS

Tailer Option

- ___ Set in line with edger 15" to 20" away
- ___ Align with output on edger
- ___ Adjust legs so tailer chain is 1" to 2" lower than out feed roller
- ___ Run tailer control cable into edger electrical cabinet and hook up
- ___ Turn on edger, check tailer rotation.



Training

- ___ Explain the tailer operation

Maintenance

Daily

- ___ Clean and check track for debris

50 Hours

- ___ Check the tension of the feed chain and adjust as needed
- ___ Check the tension of the drive chain and adjust as needed
- ___ Lubricate the drive chain with Dextron III or similar oil

200 Hours

- ___ Grease feed chain sprockets
- ___ Change the gearbox oil (first time only)

500 Hours

- ___ Check oil level in the drive gearbox

1000 Hours

- ___ Change the gearbox oil

Tech Name _____

Trainee/s Signature _____

If for any reason the above list was not completed 100% please note below:

RETURN REPORT TO JB AND FILE A COPY FOR YOUR RECORDS

LT300 w/Steel Wheels Spare Parts List Rev A8.00+

Part # 052163

<u>Part Description</u>	<u>Part #</u>	<u>Quantity</u>	<u>Price each</u>	<u>Total</u>
25" Wheel Scrapers	042245	2	\$8.65	\$17.30
Bearing, Blade Wheel Inner	045208	2	\$21.50	\$43.00
Bearing, Race Inner	045209	2	\$22.50	\$45.00
Bearing, Blade Wheel Outer	045210	2	\$26.88	\$53.76
Bearing Kit, B/G Roller	K07079	2	\$17.75	\$35.50
Bearing, Race Outer	045211	2	\$17.95	\$35.90
Belt, Drive Rev. A8.00 +/- 60hz	036636	1	\$227.63	\$227.63
Bolt, EZ Glide Long	F05004-178	4	\$0.40	\$1.60
Bolt, EZ Glide Short	F05004-200	4	\$0.40	\$1.60
Breaker, Q8-Q9-Q10	051915	1	\$42.45	\$42.45
Bushing, Carriage Stop Rubber	P12165	2	\$1.50	\$3.00
Cat Track, Right Side Rev A5.00+	036219	4	\$10.75	\$43.00
Cat Track, Left Side Rev A5.00+	039220	4	\$10.75	\$43.00
Cat Track Cross Bar, Long	023612-4	4	\$3.29	\$13.16
Cat Track Cross Bar, Short	023612-5	4	\$1.10	\$4.40
Coupler insert, P/F Drive	042655-2	1	\$41.92	\$41.92
EZ Glide Wear Disc	036347	8	\$16.00	\$128.00
Grease, Ballscrew	042399	2	\$32.90	\$65.80
Nozzles, Lube	033479	2	\$8.00	\$16.00
Potentiometer	025200	1	\$78.76	\$78.76
Relay, Solid State K7 through K29	024925	1	\$52.50	\$52.50
Relay, Solid State K5	024932	1	\$54.70	\$54.70
Relay, Solid State K6	024933	1	\$45.00	\$45.00
Roller, B/G	A04925	2	\$44.95	\$89.90
Seals, Blade Wheel Bearing	045212	2	\$18.75	\$37.50
Sensor, Proxi	025041	1	\$48.40	\$48.40
Shaft Kit, B/G Motor	036514	1	\$30.33	\$30.33
Sprocket, B/G Motor	033120	1	\$25.99	\$25.99

\$1,325.10 Kit price

If purchased with the mill or at time of commissioning - 10% discount =

\$132.51

\$1,192.59 Discounted price

LT300 w/Belted Wheels Spare Parts List Rev A8.00+

Part # 052162

<u>Part Description</u>	<u>Part #</u>	<u>Quantity</u>	<u>Price each</u>	<u>Total</u>
Bearing, Blade Wheel Inner	045208	2	\$21.50	\$43.00
Bearing, Race Inner	045209	2	\$22.50	\$45.00
Bearing, Blade Wheel Outer	045210	2	\$26.88	\$53.76
Bearing Kit, B/G Roller	K07079	2	\$17.95	\$35.90
Bearing, Race Outer	045211	2	\$17.75	\$35.50
Belt, Drive Rev. A8.00 +/- 60hz	036636	1	\$227.63	\$227.63
Bolt, EZ Glide Long	F05004-178	4	\$0.40	\$1.60
Bolt, EZ Glide Short	F05004-200	4	\$0.40	\$1.60
Breaker, Q8-Q9-Q10	051915	1	\$42.45	\$42.45
Bushing, Carriage Stop Rubber	P12165	2	\$1.50	\$3.00
Cat Track, Right Side Rev A5.00+	036219	4	\$10.75	\$43.00
Cat Track, Left Side Rev A5.00+	039220	4	\$10.75	\$43.00
Cat Track Cross Bar, Long	023612-4	4	\$3.25	\$13.00
Cat Track Cross Bar, Short	023612-5	4	\$1.10	\$4.40
Coupler insert, P/F Drive	042655-2	1	\$41.92	\$41.92
EZ Glide Wear Disc	036347	8	\$16.00	\$128.00
Grease, Ballscrew	042399	2	\$32.90	\$65.80
Nozzles, Lube	033479	2	\$8.00	\$16.00
Potentiometer	025200	1	\$78.76	\$78.76
Relay, Solid State K7 through K29	024925	1	\$52.50	\$52.50
Relay, Solid State K5	024932	1	\$54.70	\$54.70
Relay, Solid State K6	024933	1	\$45.00	\$45.00
Roller, B/G	A04925	2	\$44.95	\$89.90
Seals, Blade Wheel Bearing	045212	2	\$18.75	\$37.50
Sensor, Proxi	025041	1	\$48.40	\$48.40
Shaft Kit, B/G Motor	036514	1	\$30.33	\$30.33
Sprocket, B/G Motor	033120	1	\$25.99	\$25.99

TOTAL \$1,307.64 Kit price

If purchased with the mill or at time of commissioning - 10% discount = \$130.76

\$1,176.88 Discounted price

